

8

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

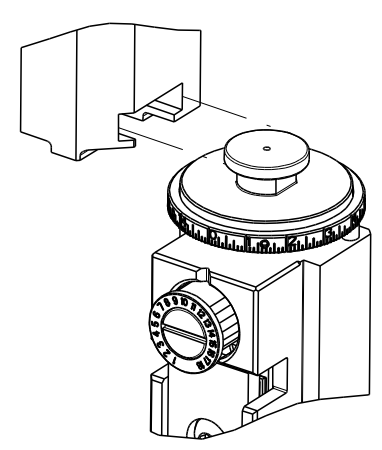
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151049-1

D

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1 2119951-1 2161326-1

2151049-2

D

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1 2119951-1 2161326-1

2151049-5

D

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

MECHANICAL FEED

2119949-1 2119950-1 1338685-1

2151049-6

D

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

PNEUMATIC FEED

2119950-1 1338685-1 5-18022-5

2151049-7

D

FINE CRIMP HEIGHT ADJUST

NONE

-

-

7-2151049-7

B

CRIMP TOOLING KIT

-

-

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [1.30]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: MCP 1.2 LOCKING LANCE RECET

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

114-18464

-

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1452671-1	7-1452671-1	967067-1	
1452671-2	7-1452671-2		
1452671-3	7-1452671-3		

WIRE SIZE

CRIMP HEIGHT

CRIMP HEIGHT REFERENCE SETTING

1.50mm2	1.31+/-0.05 [1.052+/-0.002]	5.0
16 AWG	1.26+/-0.05 [1.050+/-0.002]	5.6
1.00mm2	1.10+/-0.05 [1.043+/-0.002]	7.2
18 AWG	1.05+/-0.05 [1.041+/-0.002]	7.7

RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151049-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151049-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151049-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151049-6

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED
PNEUMATIC FEED	2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1
SERVO LATCH PLATE	2119951-1 - 8-2151049-5 1901094-3 - 2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1 - 8-2151049-4 - -
MECHANICAL FEED	2119949-1 1338685-1 5-18022-5 2119653-1 - -
SERVO LATCH PLATE	2119951-1 - 8-2151049-5 1901094-3 - 2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1 - 8-2151049-4 - -
MECHANICAL FEED	2119949-1 1338685-1 5-18022-5 2119653-1 - -
PNEUMATIC FEED	2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1
-	- - - - - -
-	- - - - - -
-	- - - - - -

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-1

LOC A

DIST 66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
C		ECR-12-018432	23OCT2012	XZ	TE
C1		ECR-13-000861	16JAN2013	XZ	TE
D		ECR-13-004534	14MAR2013	L.Z	U.G

2119641-1

FEED CAM, AIR FEED

248

2119798-1

DETENT PIN

247

1-22279-3

SPRING, COMPRESSION

246

2119758-1

RAM, AMP STYLE, SIDE FEED, NON-ADJ.

245

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

2119083-1

RETAINER, INSULATION DIAL

242

18023-1

SCR, SKT HD CAP M3 X 5.0

241

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

2119580-1

MECHANICAL FEED ASSEMBLY

239

2063440-1

AIR FEED MODULE

238

2119740-2

TAG, IDENTIFICATION

213

1901094-3

SPACER, FEEDER

198

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

8-22280-7

SPRING, COMPRESSION

176

1752353-2

GUIDE PIN,HOLDDOWN

175

1901680-2

GUIDE PIN,HOLDDOWN

174

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

994970-2

COUNTER, MAGNETIC

164

240638-1

SPRING, FEED FINGER

163

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

2119799-1

HOLDER,FEED FINGER, AF

136

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

1633743-1

SERVO FEED LATCH ASM

133

1-18028-2

WASHER, FLAT, REG M4

119

2119944-1

FEED FINGER ASSEMBLY,SF

117

455888-4

SPACER, CRIMPER

82

2119956-1

DOCUMENTATION PACKAGE

71

2119740-1

TAG,IDENTIFICATION

67

2168078-1

SCREW, DRIVE, RH, RoHS

66

2119793-1

LIMITER, ADJUSTMENT BOLT

63

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

985575-3

SCR, FLT SKT HD CAP M3 X 10.0

57

1338685-1

PAWL, FEED

56

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

1901681-1

HOLDDOWN, TERMINAL

51

1-1752354-7

STANDOFF,HOLD-DOWN

50

18023-9

SCR, SKT HD CAP M4 X 6.0

49

2119652-1

FEED CAM, PRE FEED

48

2119653-1

FEED CAM, POST FEED

47

2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

2119370-1

RAM, AMP STYLE, SIDE FEED

44

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

2119957-1

APPLICATOR SHIM PACK

39

2119644-1

RAM WASHER, PRECISION

38

2119085-1

FA HEAD, ATLANTIC STYLE

37

2119092-1

BOLT, ADJUSTMENT

35

1752356-6

SUPPORT, TERMINAL

34

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

1320908-8

SPACER, STRIP GUIDE

30

2119959-2

ASSEMBLY, STRIP GUIDE

29

455888-5

SPACER, CRIMPER

28

1320928-1

STRIP GUIDE

24

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

1-18028-2

WASHER, FLAT, REG M4

20

2119533-1

STRIPPER, SIDE FEED

19

2119806-1

INSERT, SHEAR

13

3-22280-3

SPRING, COMPRESSION

12

1-356885-4

STOP, SHEAR

11

2119805-1

SHEAR HOLDER, FRONT

10

318707-1

FLOATING SHEAR, FRONT

9

4-1333203-8

ANVIL, COMBINATION

8

2119781-1

DEPRESSOR, SHEAR

5

3-238011-8

BLOCK, CRIMPER SPACER

4

3-2119784-7

CRIMPER, INSULATION O PREMIUM

3

455888-3

SPACER, CRIMPER

2

1633169-3

CRIMPER, WIRE, SPECIAL

1

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [1.30]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: MCP 1.2 LOCKING LANCE RECET

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

114-18464

-

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1452671-1	7-1452671-1	967067-1	
1452671-2	7-1452671-2		
1452671-3	7-1452671-3		

WIRE SIZE

CRIMP HEIGHT

CRIMP HEIGHT REFERENCE SETTING

1.50mm2	1.31+/-0.05 [1.052+/-0.002]	5.0
16 AWG	1.26+/-0.05 [1.050+/-0.002]	5.6
1.00mm2	1.10+/-0.05 [1.043+/-0.002]	7.2
18 AWG	1.05+/-0.05 [1.041+/-0.002]	7.7

RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151049-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151049-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151049-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151049-6

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED
PNEUMATIC FEED	2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1
SERVO LATCH PLATE	2119951-1 - 8-2151049-5 1901094-3 - 2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1 - 8-2151049-4 - -
MECHANICAL FEED	2119949-1 1338685-1 5-18022-5 2119653-1 - -
SERVO LATCH PLATE	2119951-1 - 8-2151049-5 1901094-3 - 2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1 - 8-2151049-4 - -
MECHANICAL FEED	2119949-1 1338685-1 5-18022-5 2119653-1 - -
PNEUMATIC FEED	2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1
-	- - - - - -
-	- - - - - -
-	- - - - - -

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-1

LOC A

DIST 66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
C		ECR-12-018432	23OCT2012	XZ	TE
C1		ECR-13-000861	16JAN2013	XZ	TE
D		ECR-13-004534	14MAR2013	L.Z	U.G

2119641-1

FEED CAM, AIR FEED

248

2119798-1

DETENT PIN

247

1-22279-3

SPRING, COMPRESSION

246

2119758-1

RAM, AMP STYLE, SIDE FEED, NON-ADJ.

245

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

2119083-1

RETAINER, INSULATION DIAL

242

18023-1

SCR, SKT HD CAP M3 X 5.0

241

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

2119580-1

MECHANICAL FEED ASSEMBLY

239

2063440-1

AIR FEED MODULE

238

2119740-2

TAG, IDENTIFICATION

213

1901094-3

SPACER, FEEDER

198

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

8-22280-7

SPRING, COMPRESSION

176

1752353-2

GUIDE PIN,HOLDDOWN

175

1901680-2

GUIDE PIN,HOLDDOWN

174

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

994970-2

COUNTER, MAGNETIC

164

240638-1

SPRING, FEED FINGER

163

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

2119799-1

HOLDER,FEED FINGER, AF

136

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

1633743-1

SERVO FEED LATCH ASM

133

1-18028-2

WASHER, FLAT, REG M4

119

2119944-1

FEED FINGER ASSEMBLY,SF

117

455888-4

SPACER, CRIMPER

82

2119956-1

DOCUMENTATION PACKAGE

71

2119740-1

TAG,IDENTIFICATION

67

2168078-1

SCREW, DRIVE, RH, RoHS

66

2119793-1

LIMITER, ADJUSTMENT BOLT

63

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

985575-3

SCR, FLT SKT HD CAP M3 X 10.0

57

1338685-1

PAWL, FEED

56

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

1901681-1

HOLDDOWN, TERMINAL

51

1-1752354-7

STANDOFF,HOLD-DOWN

50

18023-9

SCR, SKT HD CAP M4 X 6.0

49

2119652-1

FEED CAM, PRE FEED

48

2119653-1

FEED CAM, POST FEED

47

2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

2119370-1

RAM, AMP STYLE, SIDE FEED

44

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

2119957-1

APPLICATOR SHIM PACK

39

2119644-1

RAM WASHER, PRECISION

38

2119085-1

FA HEAD, ATLANTIC STYLE

37

2119092-1

BOLT, ADJUSTMENT

35

1752356-6

SUPPORT, TERMINAL

34

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

1320908-8

SPACER, STRIP GUIDE

30

2119959-2

ASSEMBLY, STRIP GUIDE

29

455888-5

SPACER, CRIMPER

28

1320928-1

STRIP GUIDE

24

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

1-18028-2

WASHER, FLAT, REG M4

20

2119533-1

STRIPPER, SIDE FEED

19

2119806-1

INSERT, SHEAR

13

3-22280-3

SPRING, COMPRESSION

12

1-356885-4

STOP, SHEAR

11

2119805-1

SHEAR HOLDER, FRONT

10

318707-1

FLOATING SHEAR, FRONT

9

4-1333203-8

ANVIL, COMBINATION

8

2119781-1

DEPRESSOR, SHEAR

5

3-238011-8

BLOCK, CRIMPER SPACER

4

3-2119784-7

CRIMPER, INSULATION O PREMIUM

3

455888-3

SPACER, CRIMPER

2

1633169-3

CRIMPER, WIRE, SPECIAL

1

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [1.30]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: MCP 1.2 LOCKING LANCE RECET

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

114-18464

-

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1452671-1	7-1452671-1	967067-1	
1452671-2	7-1452671-2		
1452671-3	7-1452671-3		

WIRE SIZE

CRIMP HEIGHT

CRIMP HEIGHT REFERENCE SETTING

1.50mm2	1.31+/-0.05 [1.052+/-0.002]	5.0
16 AWG	1.26+/-0.05 [1.050+/-0.002]	5.6
1.00mm2	1.10+/-0.05 [1.043+/-0.002]	7.2
18 AWG	1.05+/-0.05 [1.041+/-0.002]	7.7

RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151049-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151049-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151049-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151049-6

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

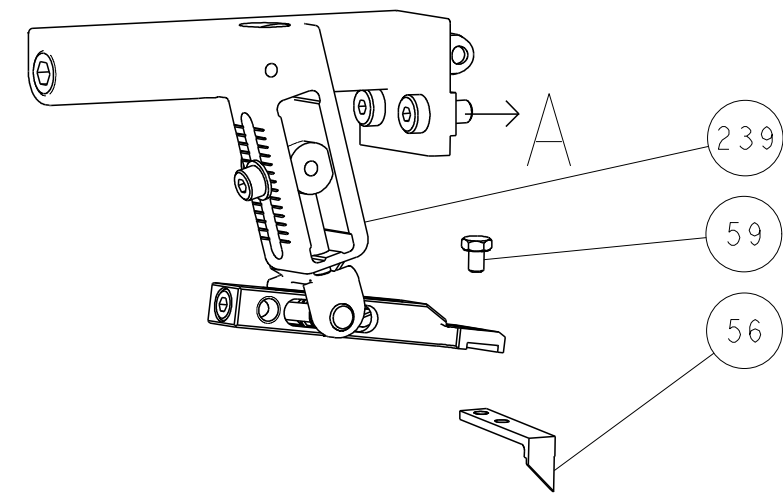
APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

APPLICATOR STYLE CONVERSION CHART

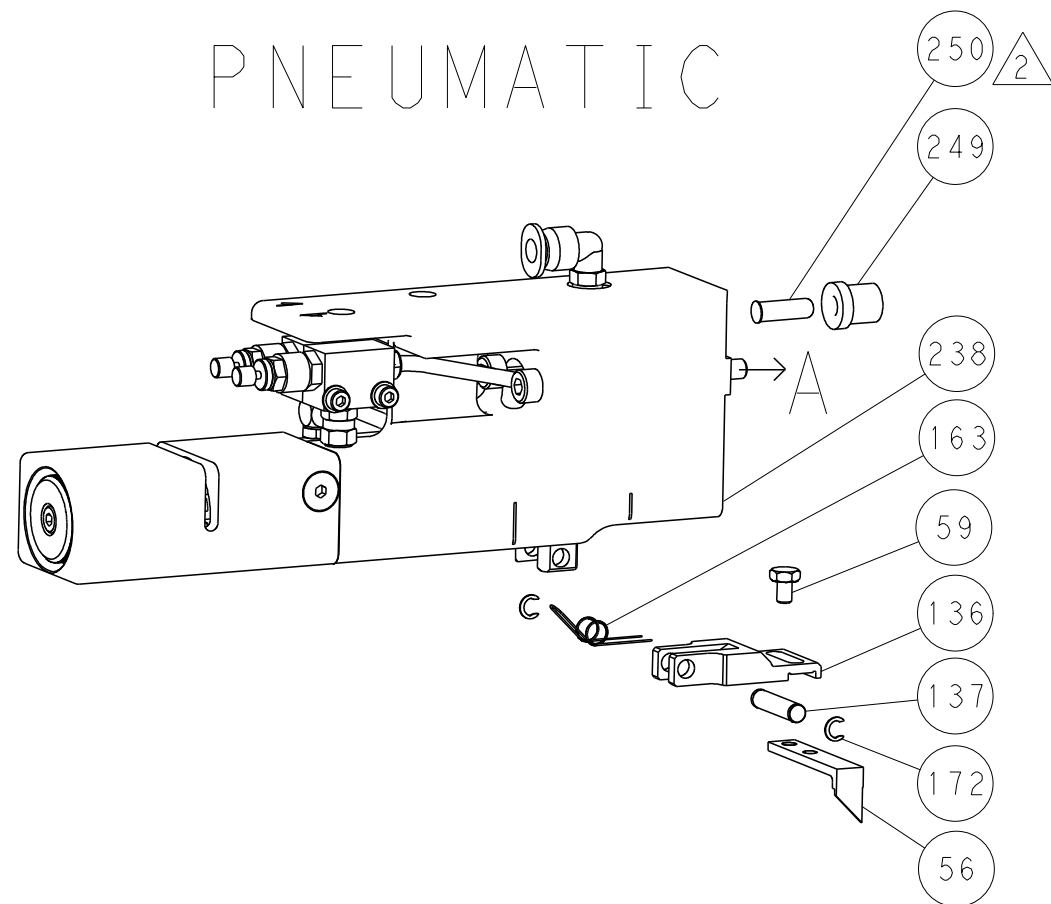
CONVERT TO	PART NUMBERS REQUIRED
PNEUMATIC FEED	2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1
SERVO LATCH PLATE	2119951-1 - 8-2151049-5 1901094-3 - 2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1 - 8-2151049-4 - -
MECHANICAL FEED	2119949-1 1338685-1 5-18022-5 2119653-1 - -
SERVO LATCH PLATE	2119951-1 - 8-2151049-5 1901094-3 - 2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1 - 8-21510

LOC		DIST		REVISIONS							
A		66		P	LTR	DESCRIPTION			DATE	DWN	APVD
					-	SEE SHEET 1			-	-	-

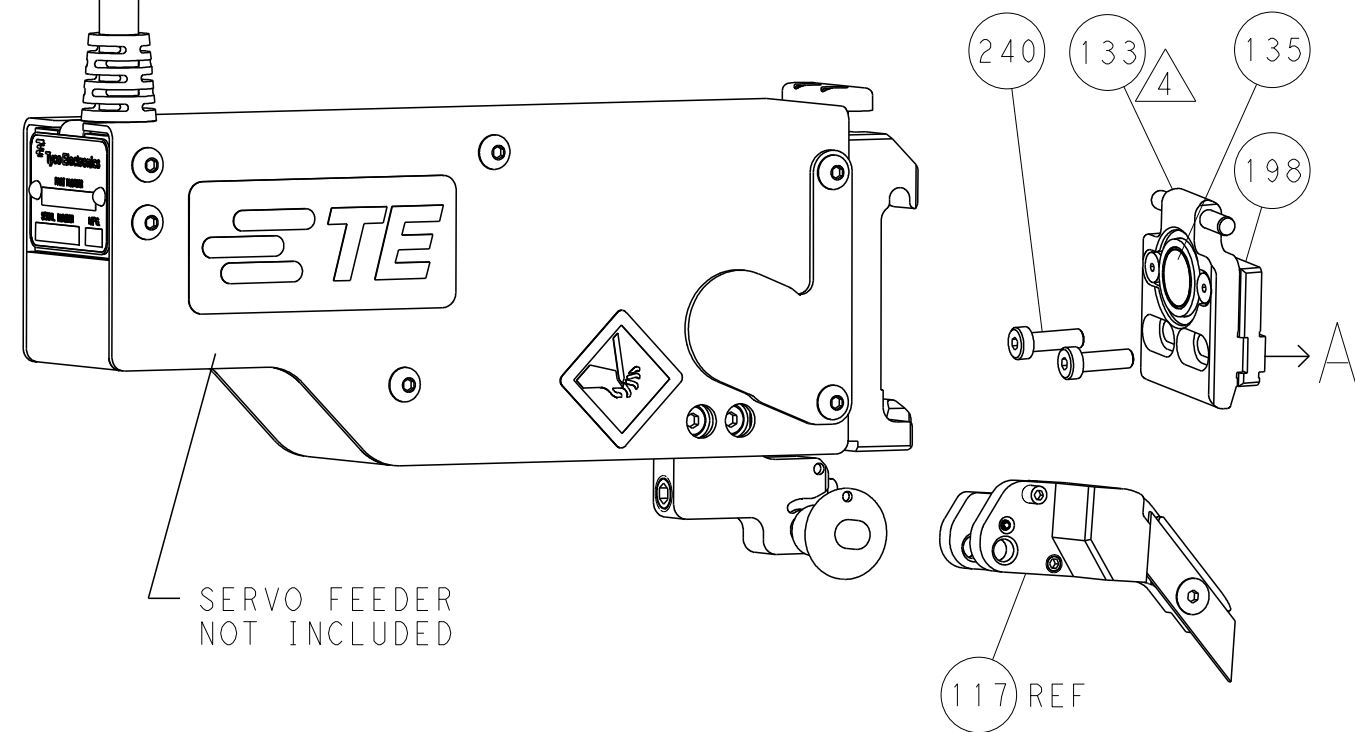
FEED TYPE MECHANICAL



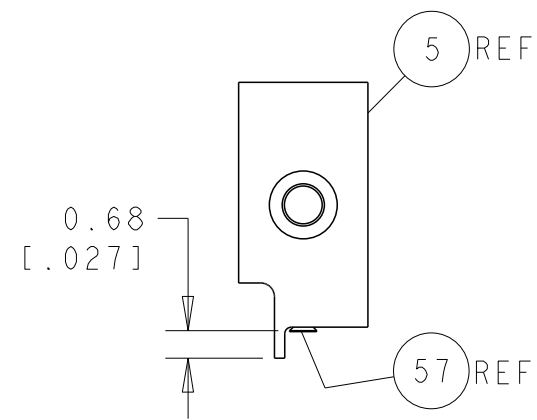
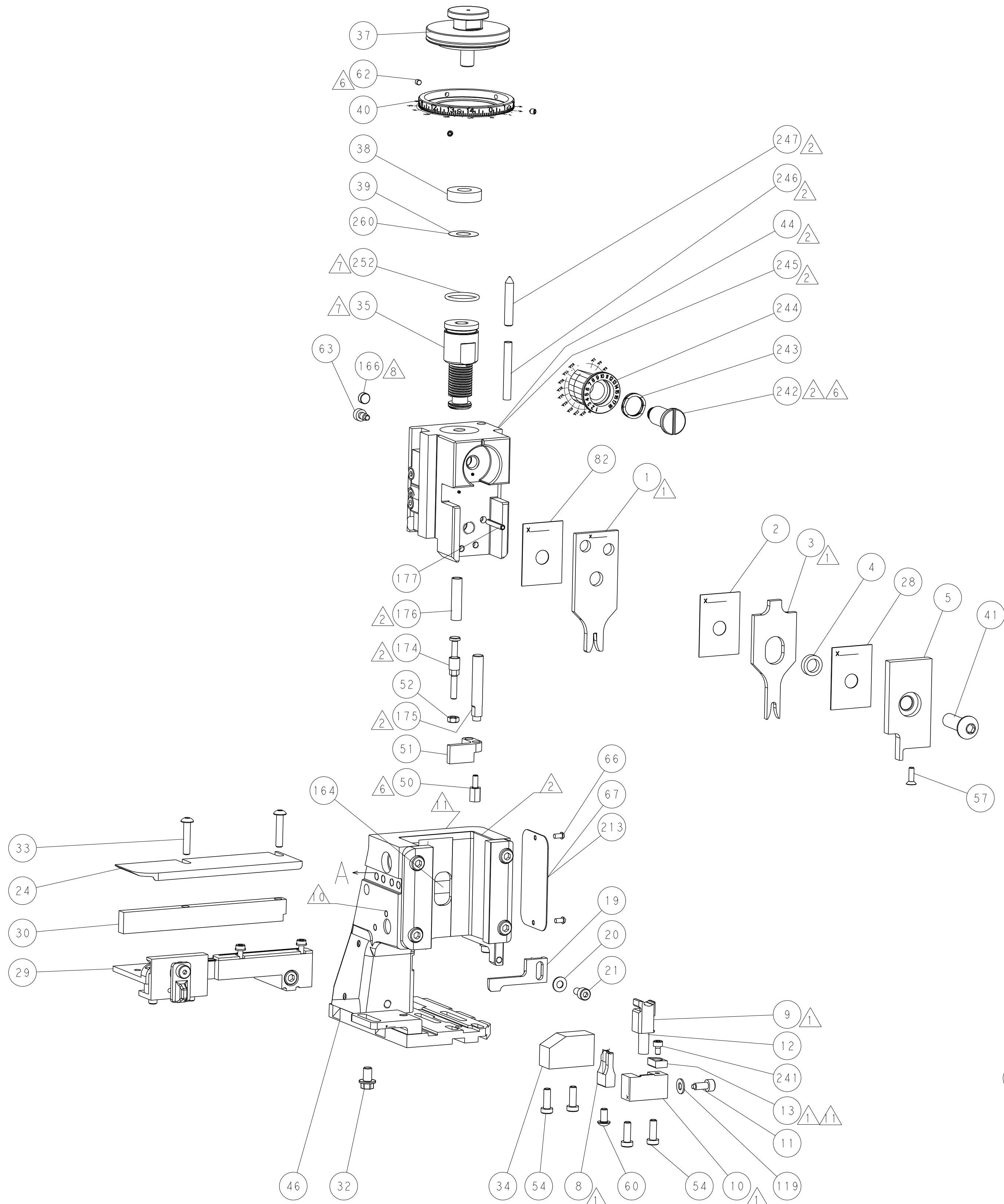
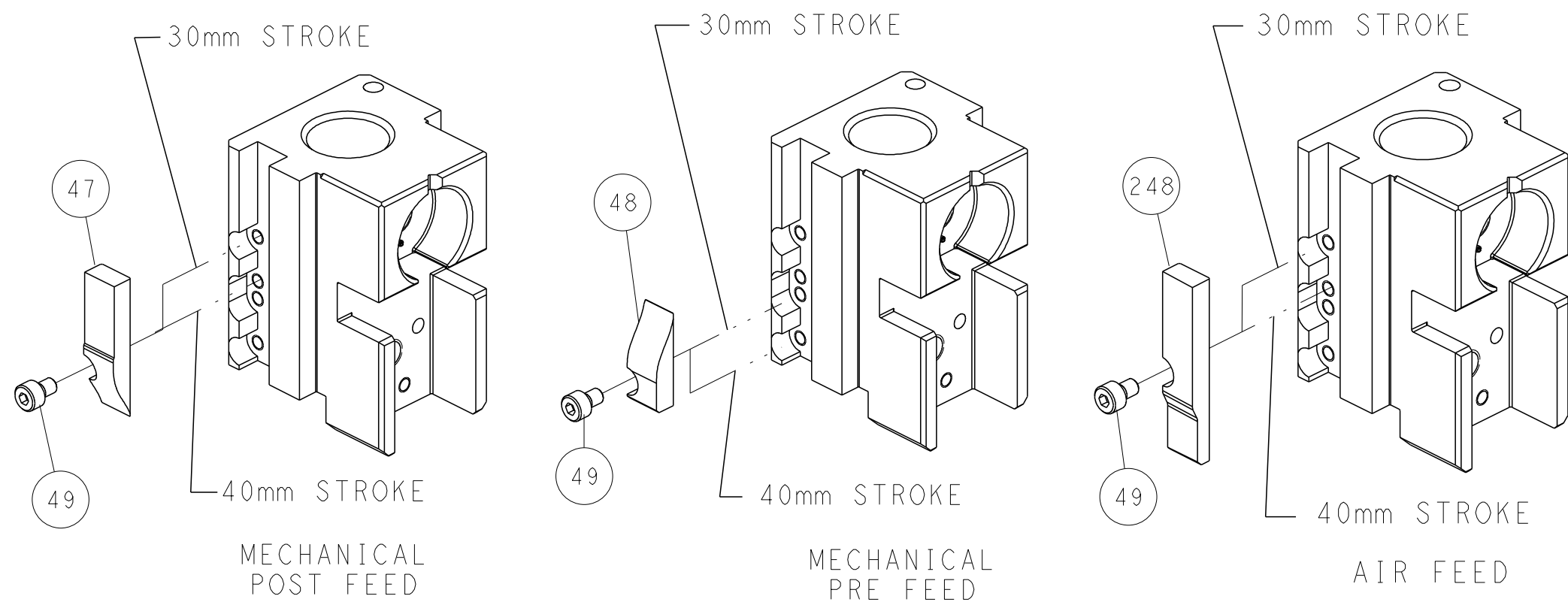
PNEUMATIC



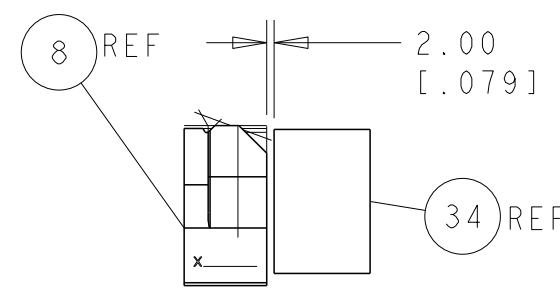
SERVO LATCH PLATE



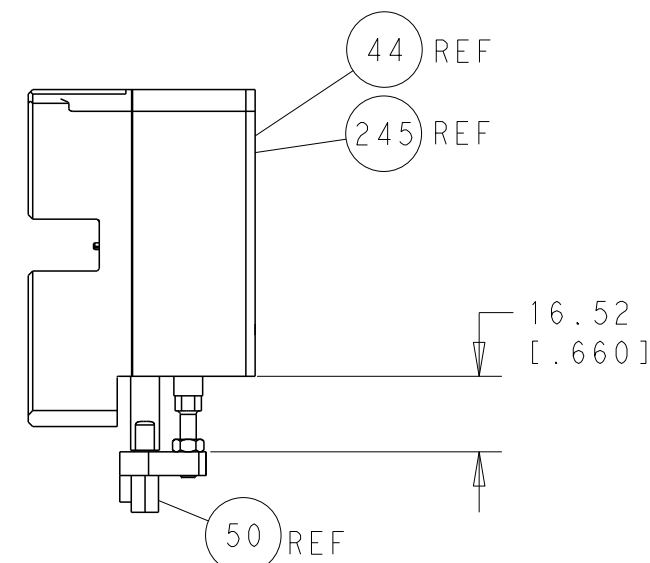
CAM POSITIONS



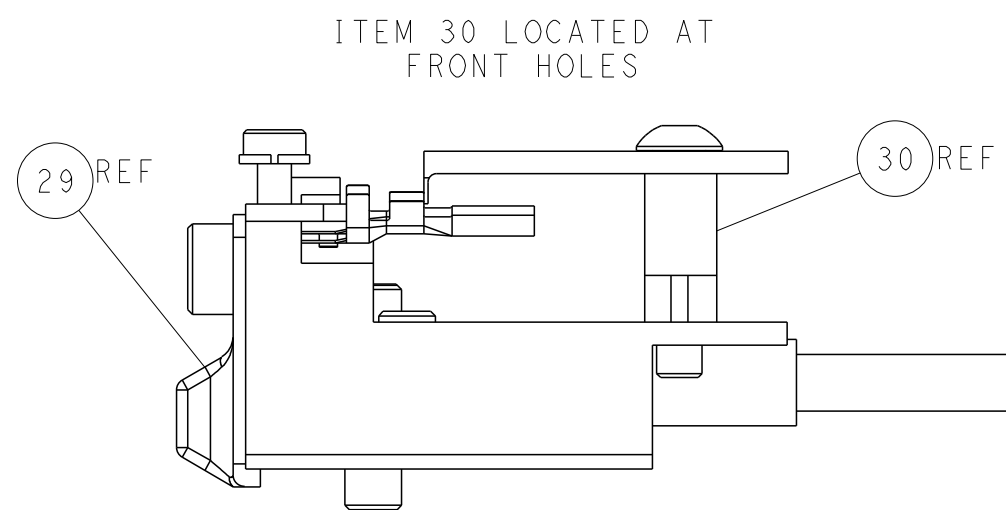
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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CHK S. XI 30APR2011		NAME Ocean Side Feed Applicator	RESTRICTED TO	
APVD J. CRUZ 30APR2011		PRODUCT SPEC	SIZE A1	
APPLICATION SPEC		WEIGHT	CAGE CODE 00779	
MATERIAL		FINISH	DRAWING NO 2151049	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2	SHEET 2 OF 4	
			REV D	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

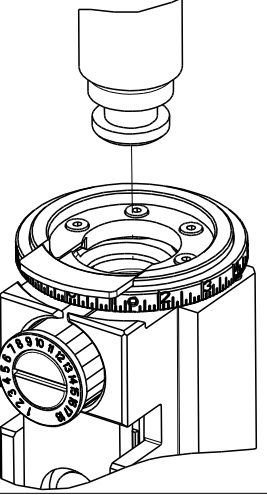
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2151049-1

REVISION

D

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2-2151049-1

D

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1

2-2151049-2

D

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

2-2151049-5

D

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

MECHANICAL FEED

2119949-1

2-2151049-7

D

FINE CRIMP HEIGHT ADJUST

NONE

PNEUMATIC FEED

2119950-1

7-2151049-7

B

CRIMP TOOLING KIT

-

-

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: MCP 1.2 LOCKING LANCE RECET

WIRE STRIP LENGTH

3.30-3.90 mm [.130-.154 IN]

INSULATION DIAMETER RANGE

Ø1.90-2.40 mm [.075-.094 IN]

TERMINAL APPLICATION SPECIFICATION

114-18464

-

-

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1452671-1	7-1452671-1	967067-1	
1452671-2	7-1452671-2		
1452671-3	7-1452671-3		

WIRE SIZE

1.50mm2

CRIMP HEIGHT

mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

5.0

1.50mm2

1.31+/-0.05 [.052+/-0.002]

5.0

16 AWG

1.26+/-0.05 [.050+/-0.002]

5.6

1.00mm2

1.10+/-0.05 [.043+/-0.002]

7.2

18 AWG

1.05+/-0.05 [.041+/-0.002]

7.7

RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151049-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151049-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151049-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151049-6

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED
PNEUMATIC FEED	2119950-1
SERVO LATCH PLATE	2119951-1
SMART APPLICATOR	2161326-1
MECHANICAL FEED	2119949-1
SERVO LATCH PLATE	2119951-1
SMART APPLICATOR	2161326-1
MECHANICAL FEED	2119949-1
PNEUMATIC FEED	2119950-1
-	-
-	-

2119799-1

2063440-1

SET UP GAUGE

2119599-1

LOC

A

DIST

66

REVISIONS

P	LYR	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

-

-

-

1

-

2079988-1

BUSHING, LCH5-12, MISUMI

249

-

1

1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

1

1

1

1

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

-

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

-

1

1

1

1

18023-1

SCR, SKT HD CAP M3 X 5.0

241

-

-

2

-

-

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

1

-

2063440-1

AIR FEED MODULE

238

-

-

1

-

-

2119740-2

TAG,IDENTIFICATION

213

-

-

1

-

-

1901094-3

SPACER, FEEDER

198

-

1

1

1

1

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

-

1

1

1

1

8-22280-7

SPRING, COMPRESSION

176

-

1

1

1

 1 | 1752353-2 | GUIDE PIN,HOLDDOWN | 175 || - | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN,HOLDDOWN | 174 |
-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66
-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1-1752354-7	STANDOFF,HOLD-DOWN	50
-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1320908-8	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1	1	1320928-1	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	4-1333203-8	ANVIL, COMBINATION	8
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	3-2119784-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	1	1	1633169-3	CRIMPER, WIRE, SPECIAL	1

-77

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-25

-22

-21

PART NO

DESCRIPTION

ITEM NO

PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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DIMENSIONS:

mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.013

4 PLC ±0.0001

ANGLES ±.5

FINISH

MATERIAL

-

OWN

30APR2011

CHK

30APR2011

S.XI

30APR2011

APVD

30APR2011

PRODUCT SPEC

-

APPLICATION SPEC

-

SIZE

CASE CODE

DRAWING NO

RESTRICTED TO

WEIGHT

-

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

SCALE

1:2

SHEET

3

OF

4

REV

D

TE Connectivity

Harrisburg, PA 17105-3608

Ocean Side Feed

Applicator

00779

©=2151049

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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