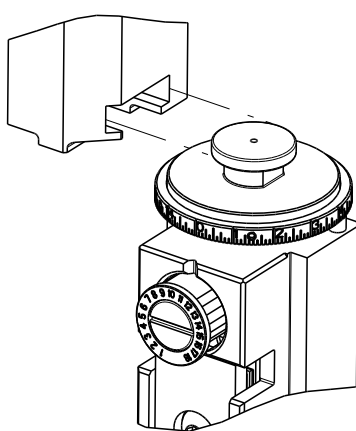


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION
	2151083-1	E	FINE CRIMP HEIGHT ADJUST	
	2151083-2	E	FINE CRIMP HEIGHT ADJUST	
	2151083-5	E	FINE CRIMP HEIGHT ADJUST	
	2151083-6	E	NON-CRIMP HEIGHT ADJUST	
	2151083-7	E	FINE CRIMP HEIGHT ADJUST	
	7-2151083-7	C	CRIMP TOOLING KIT	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DYNAMIC D1000 SERIES REC CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
1.70-2.30 mm [.067-.091 IN]			Ø1.40-2.20 mm [.055-.087 IN]
TERMINAL APPLICATION SPECIFICATION		114-5377	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1827572-2	1871731-1	1903114-2	1903122-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.86mm2	1.15+/-0.03 [.045+/- .001]	4.8
20 AWG OR 0.52mm2	1.00+/-0.03 [.039+/- .001]	6.3
22 AWG OR 0.35mm2	0.85+/-0.03 [.033+/- .001]	7.8



- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151083-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151083-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151083-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151083-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 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.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 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.
- 12 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

*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

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

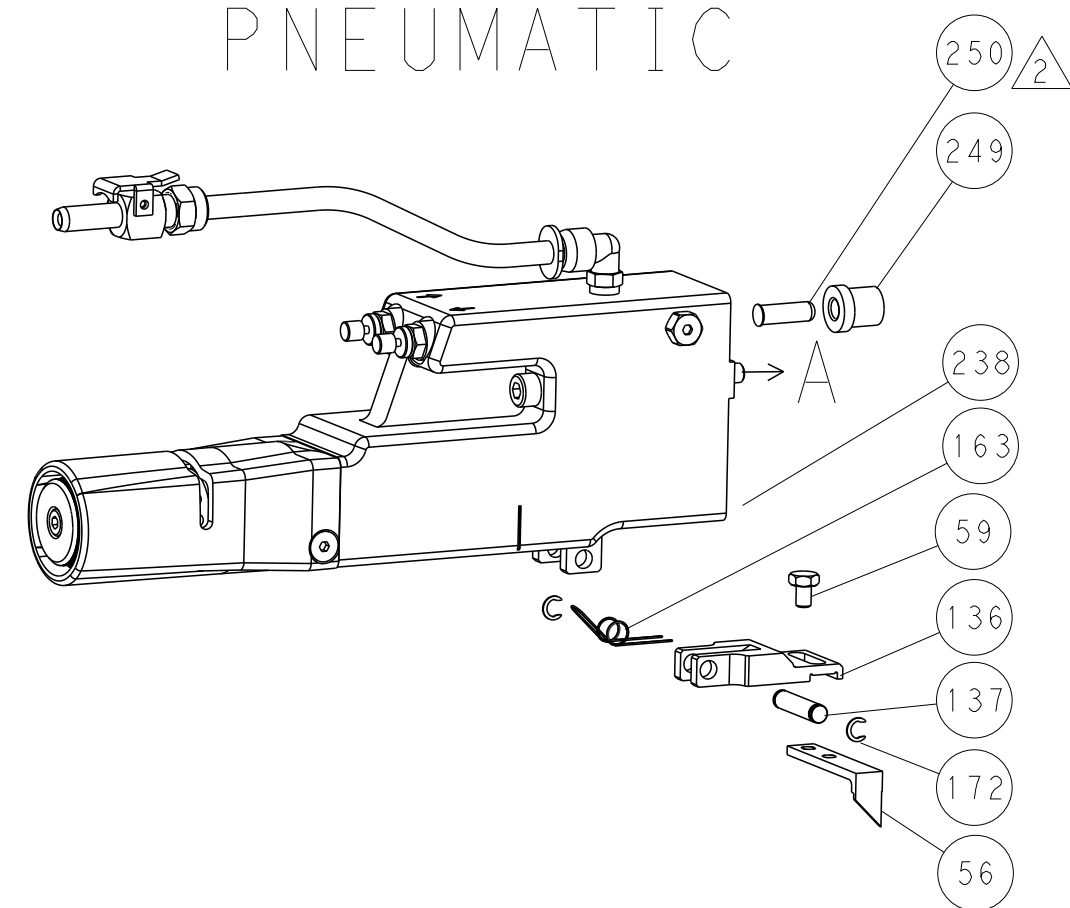
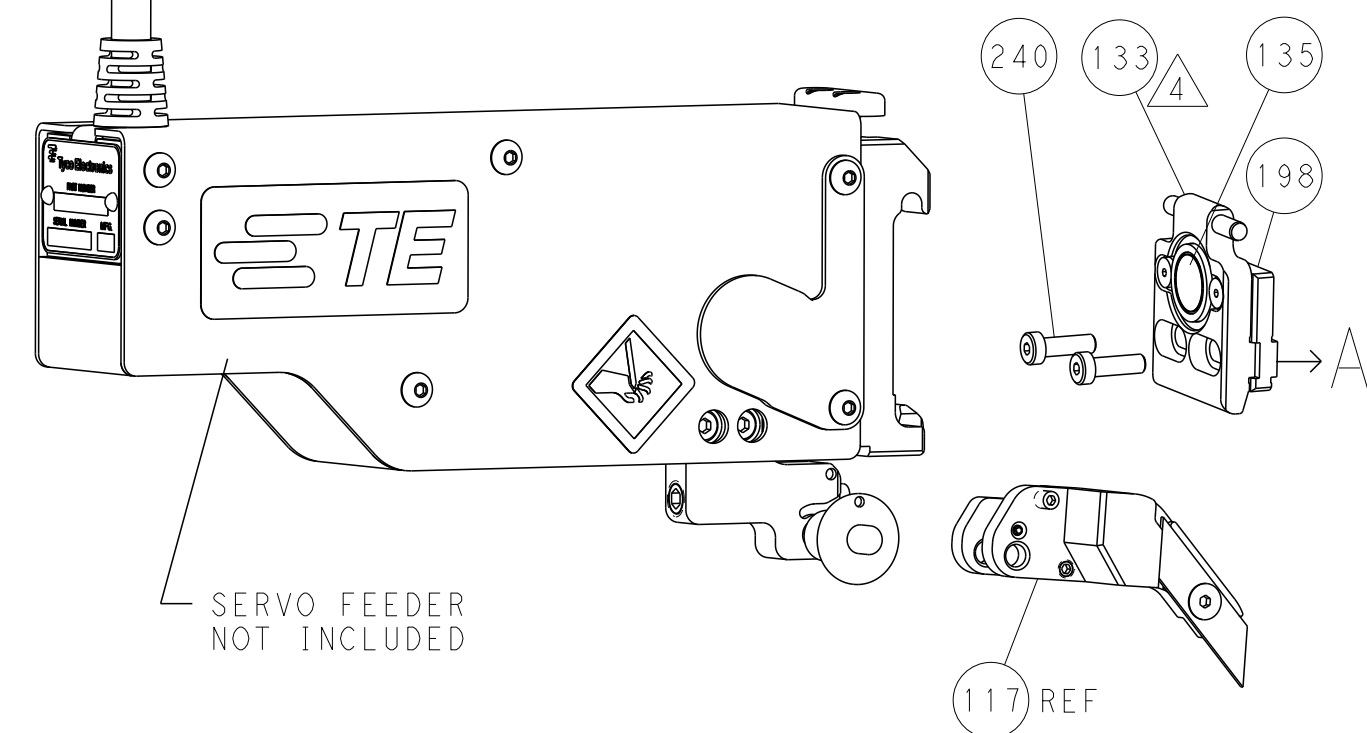
SET UP GAUGE 2119599-1	LOC A	DIS 66	REVISIONS							
			P	LTR	DESCRIPTION			DATE	DWN	APVD
				E	ECR-15-004756			26MAR2015	MR	JT

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	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	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	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	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	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	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	2-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	3-1729372-5	ANVIL	8
-	1	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1-238011-3	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1633962-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1	1	4-1633730-4	CRIMPER, WIRE	1

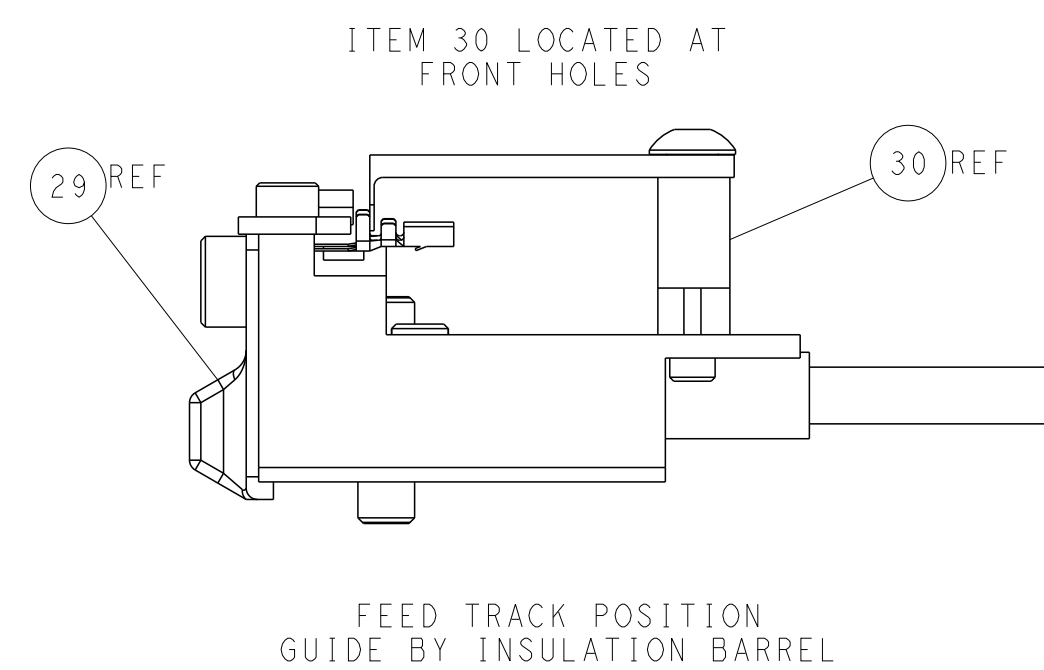
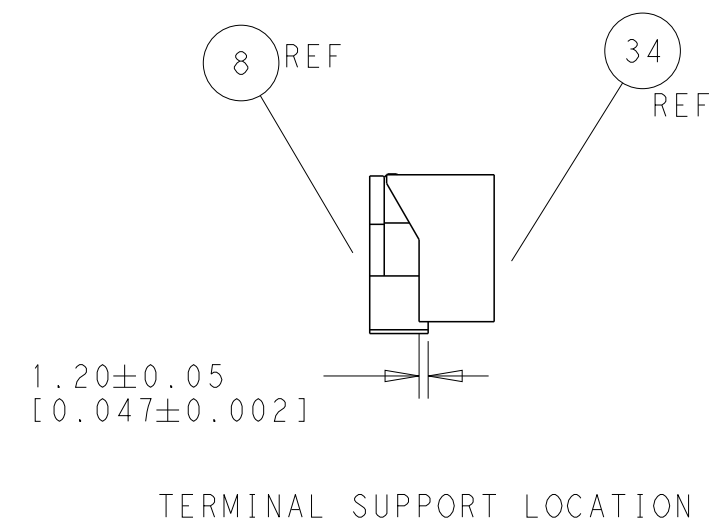
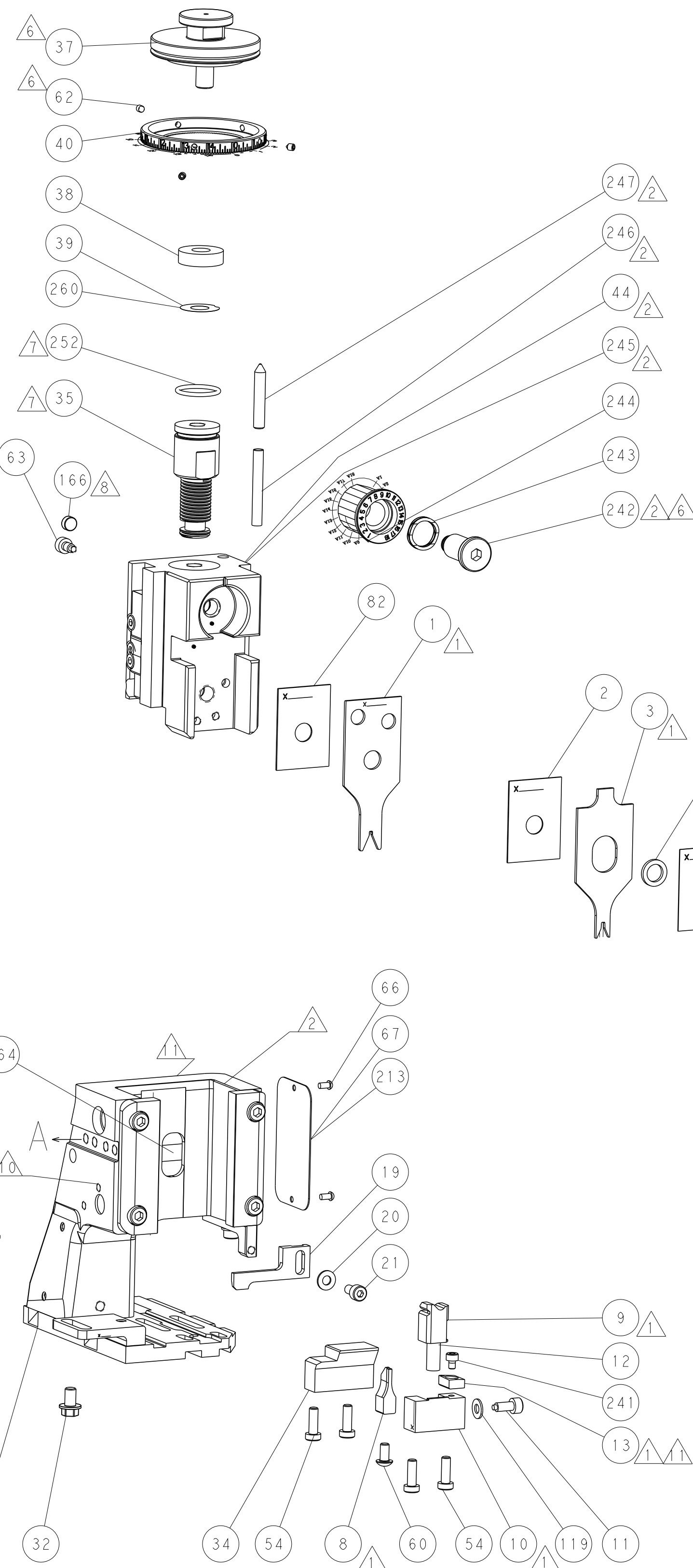
-77 -7 -6 -5 -2 -1		PART NO	DESCRIPTION		ITEM NO
THIS IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHALL BE CONTACTED FOR THE LATEST EDITION.		OWN K. HUANG	31AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK			
mm		APVD S. XI	31AUG2011		
		PRODUCT SPEC			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC			
0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5 FINISH		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
MATERIAL		WEIGHT		00779	©=2151083
		Customer Accessible Production Drawing		SCALE	1:2
		SHEET		1	OF 4
		REV		E	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

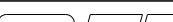
PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS



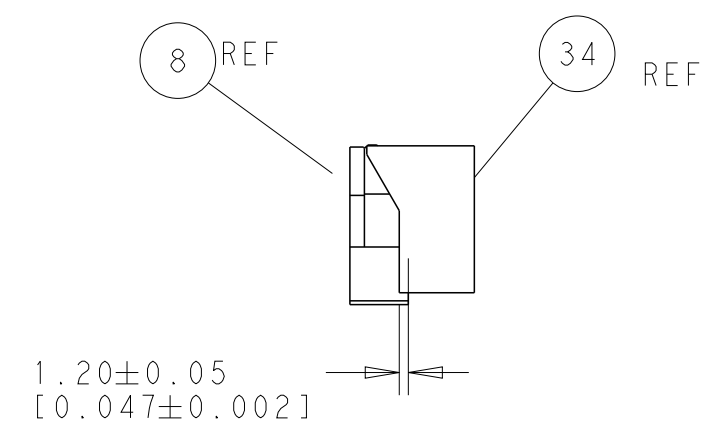
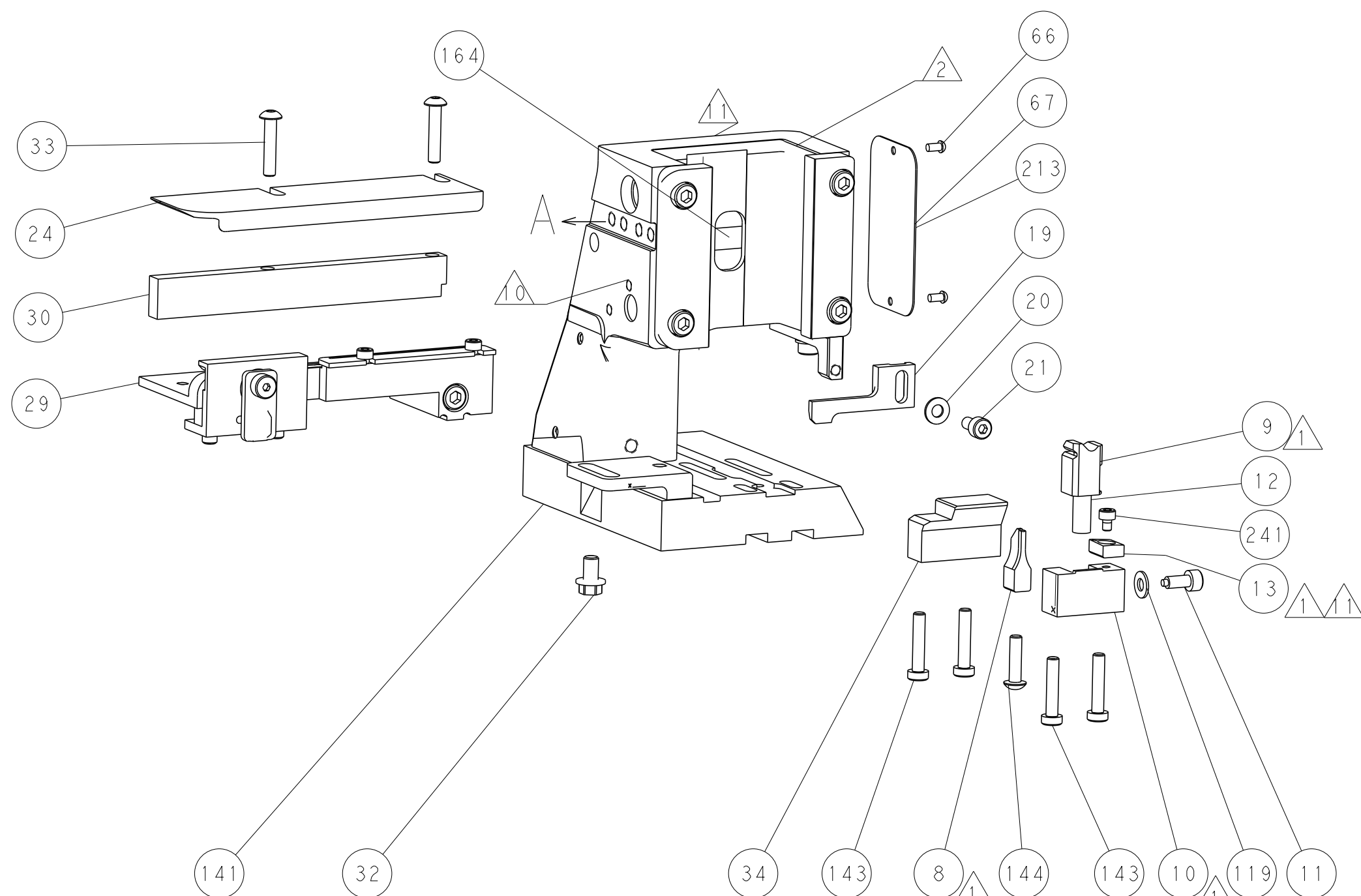
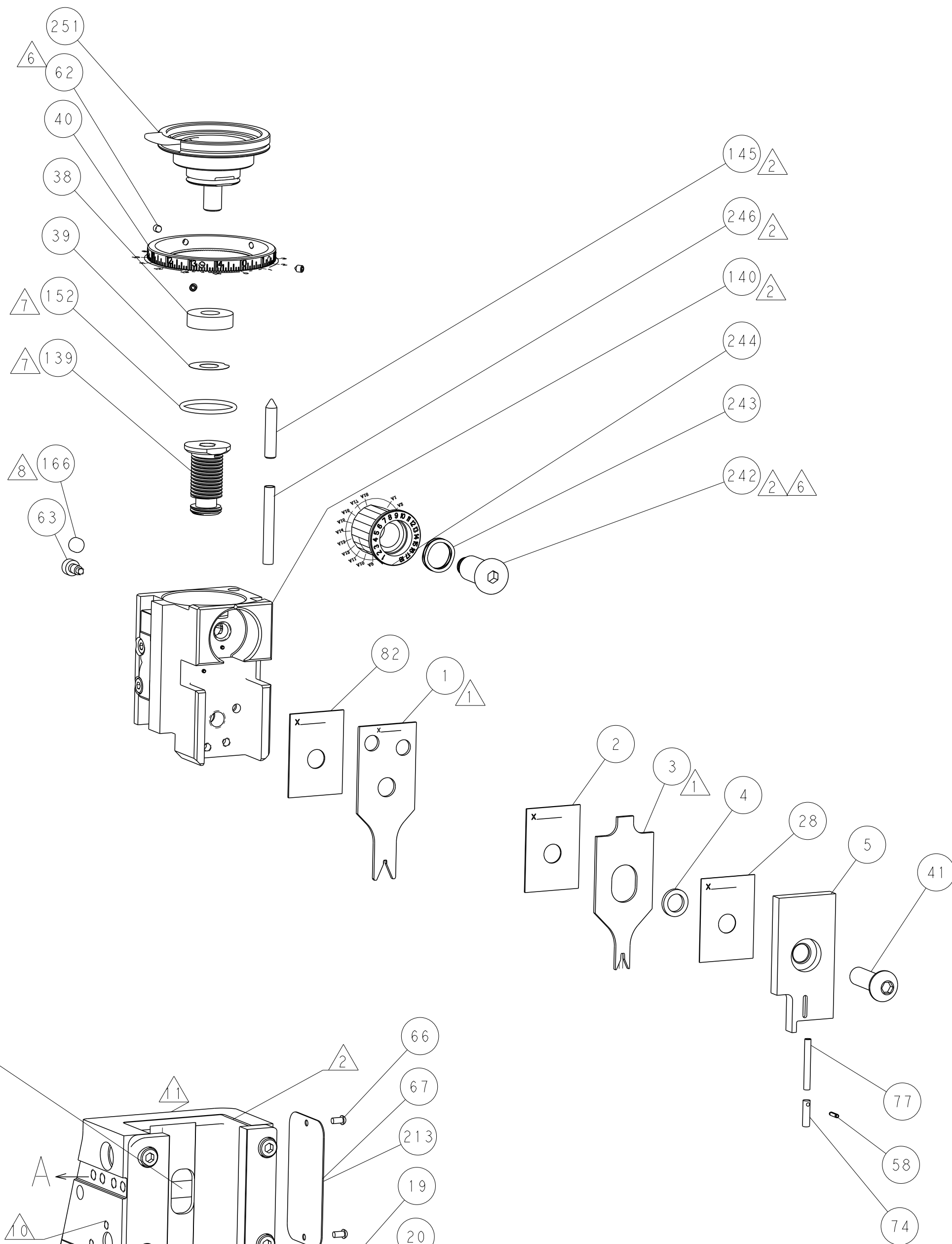
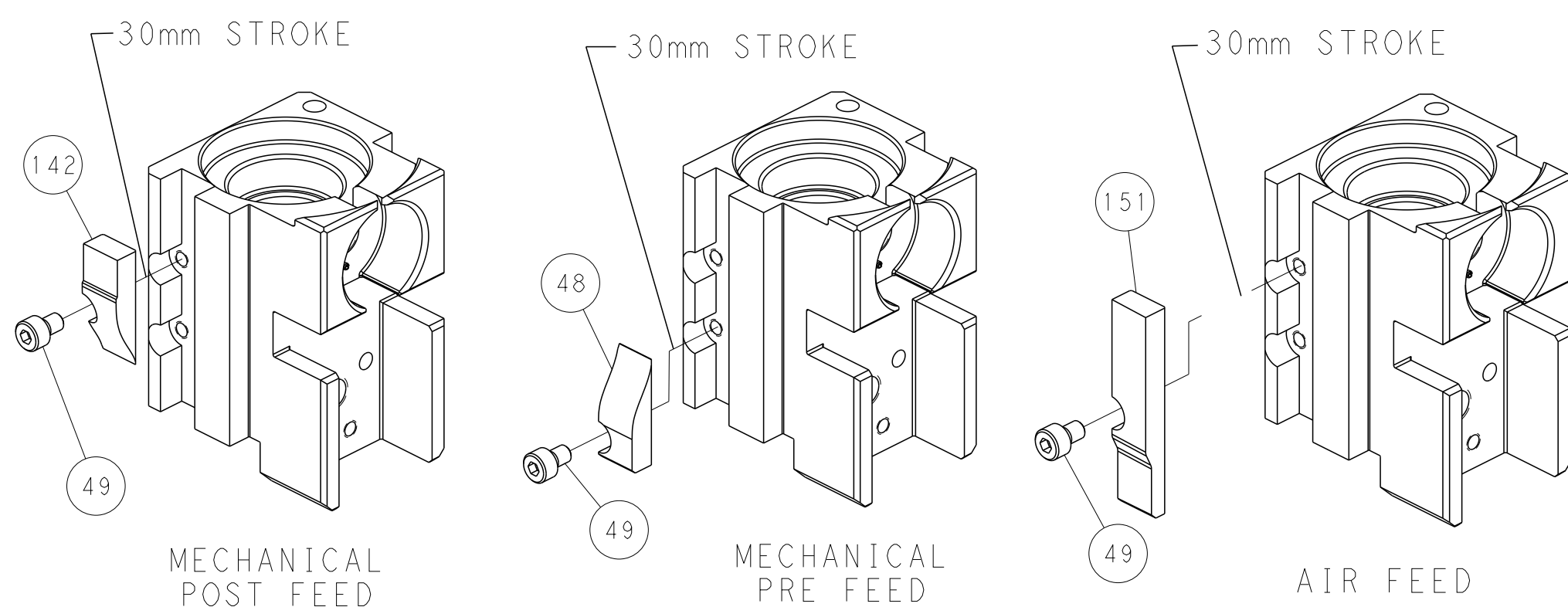
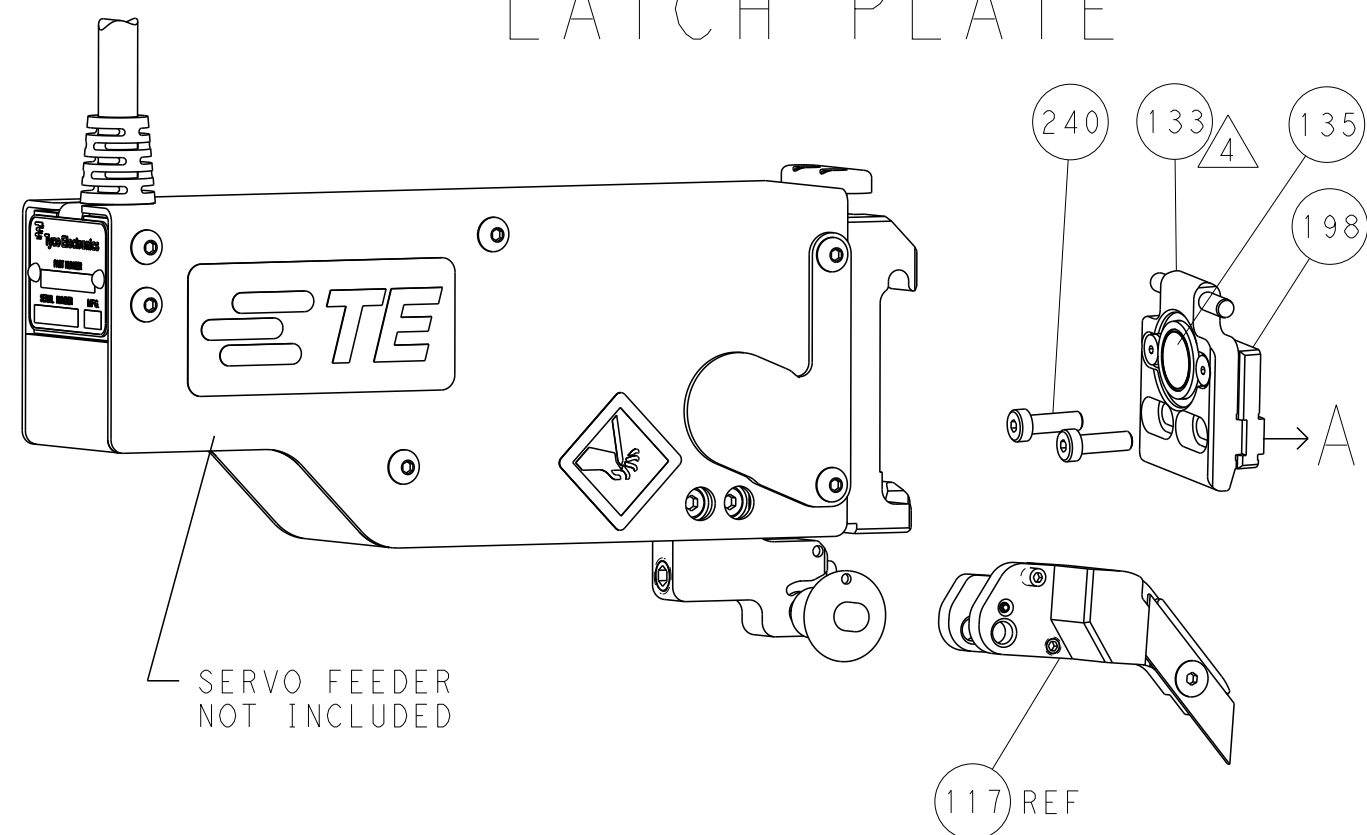
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1°		APPROVED BY S. XI		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC APPLICATION SPEC		SIZE A		CAGE CODE 00779	
MATERIAL -		FINISH -		WEIGHT C-2151083		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 2 of 4	
				REV F			

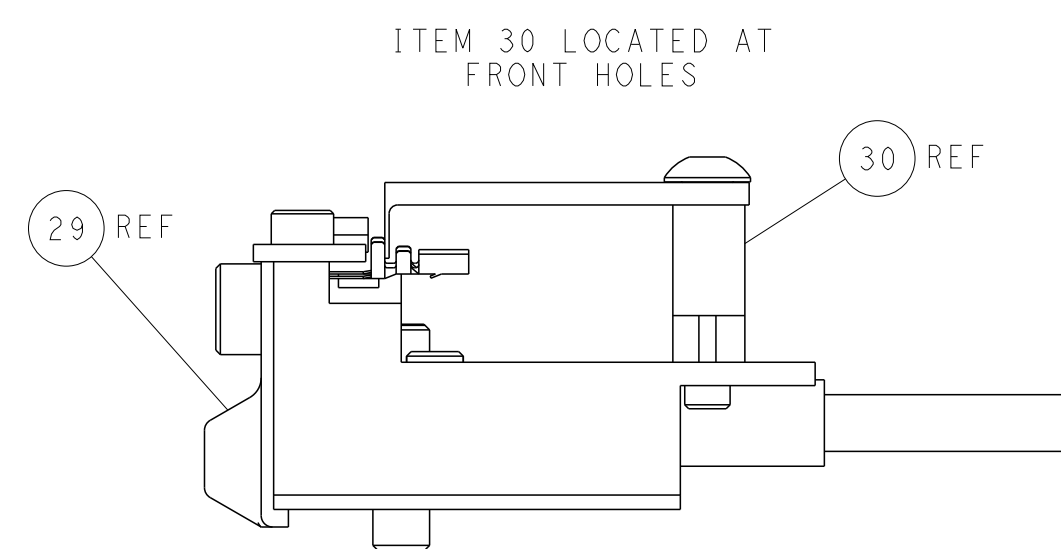
PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS

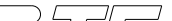
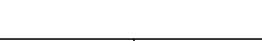


TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 +/- 0.5 1 PLC +/- 0.13 2 PLC +/- 0.013 3 PLC +/- 0.0001 ANGLES +/-		ARVD 31AUG2011 PRODUCT SPEC NAME Ocean Side Feed Applicator APPLICATION SPEC	
MATERIAL - FINISH -		WEIGHT -		SIZE CASE CODE DRAWING NO A1 00779 C=2151083 RESTRICTED TO -	
Customer Accessible Port Connection		SCALE 1:2		SHEET 4 of 4 REV E	

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