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RELEASED FOR PUBLICATION

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

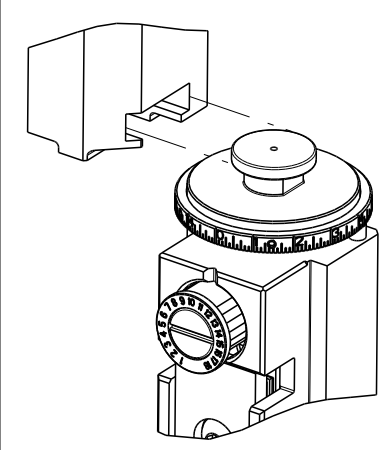
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151050-1

F

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1

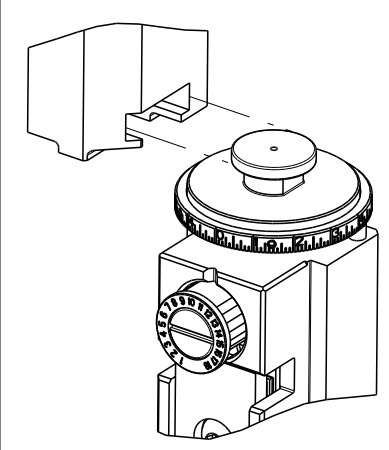
1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1



2151050-2

F

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

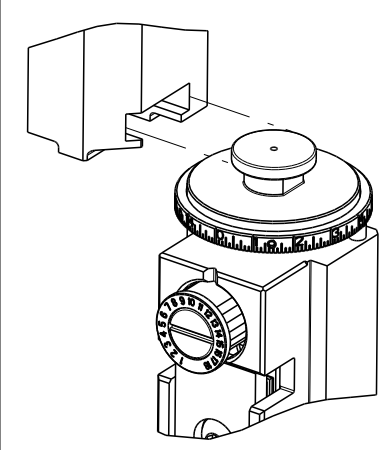
1338685-1

5-18022-5

2119653-1

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2151050-5

F

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119949-1

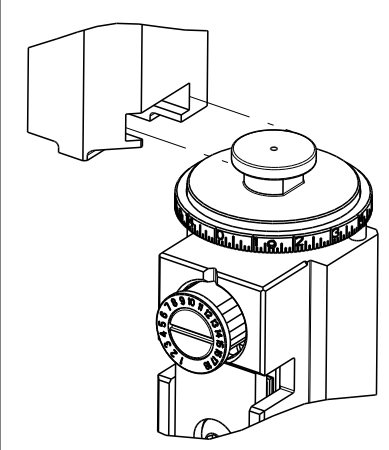
1338685-1

5-18022-5

2119653-1

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2151050-6

F

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119950-1

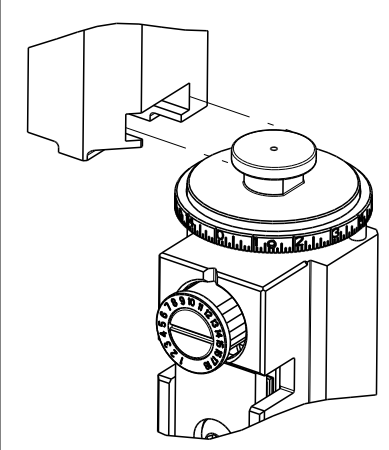
1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1



2151050-7

F

FINE CRIMP HEIGHT ADJUST

NONE

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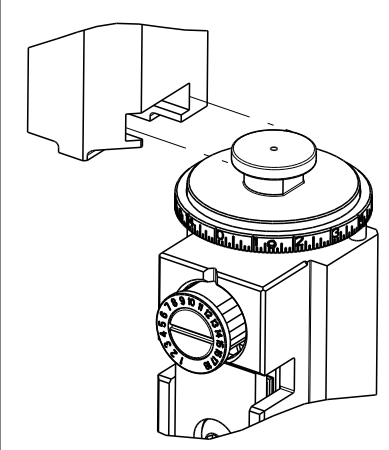
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7-2151050-7

A

CRIMP TOOLING KIT

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APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 1.57 mm [.062] F

INSUL 2.29 mm [.090] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: MICRO TIMER 2 CONTACT

WIRE STRIP LENGTH INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 1.6 X 0.6 TYPE A

WIRE STRIP LENGTH INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 1.6 X 0.6 TYPE A

WIRE STRIP LENGTH INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 1.6 X 0.6 TYPE A

WIRE STRIP LENGTH INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

WIRE SIZE CRIMP HEIGHT CRIMP HEIGHT

0.50mm2 1.12+/-0.05 [.044+/- .002] 5.0

0.35mm2 1.05+/-0.03 [.041+/- .001] 5.8

0.25mm2 1.00+/-0.03 [.039+/- .001] 6.3

0.20mm2 0.98+/-0.03 [.039+/- .001] 6.5

WIRE SIZE CRIMP HEIGHT CRIMP HEIGHT

0.35mm2 1.05+/-0.03 [.041+/- .001] 7.6

0.25mm2 1.00+/-0.03 [.039+/- .001] 8.1

0.20mm2 0.98+/-0.03 [.039+/- .001] 8.3

WIRE SIZE CRIMP HEIGHT CRIMP HEIGHT

0.35mm2 1.08+/-0.03 [.043+/- .001] 6.7

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:

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. 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 ITEMS 37, 50.

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

REVISIONS

DESCRIPTION

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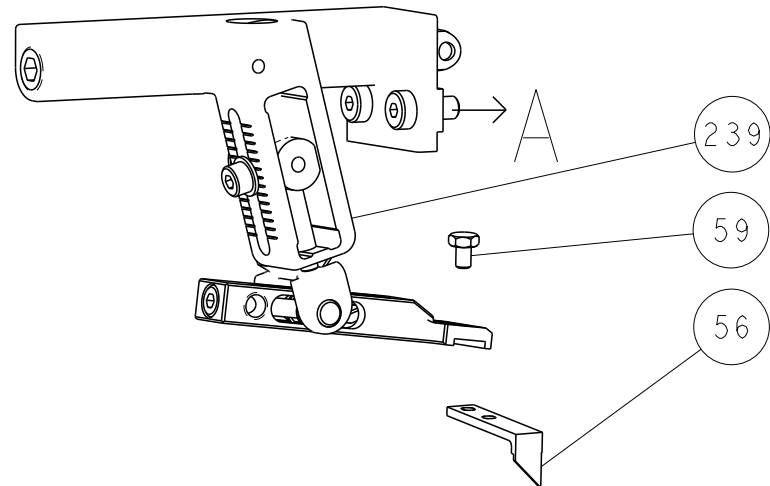
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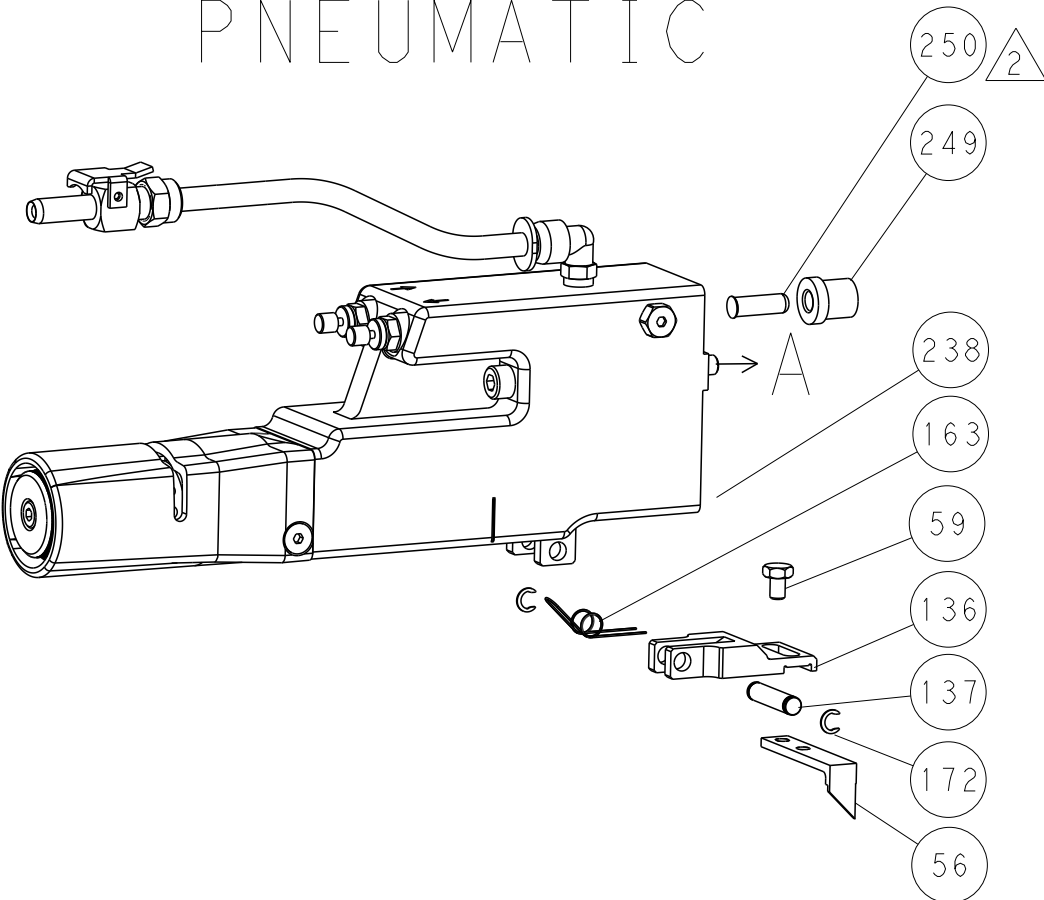
44

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

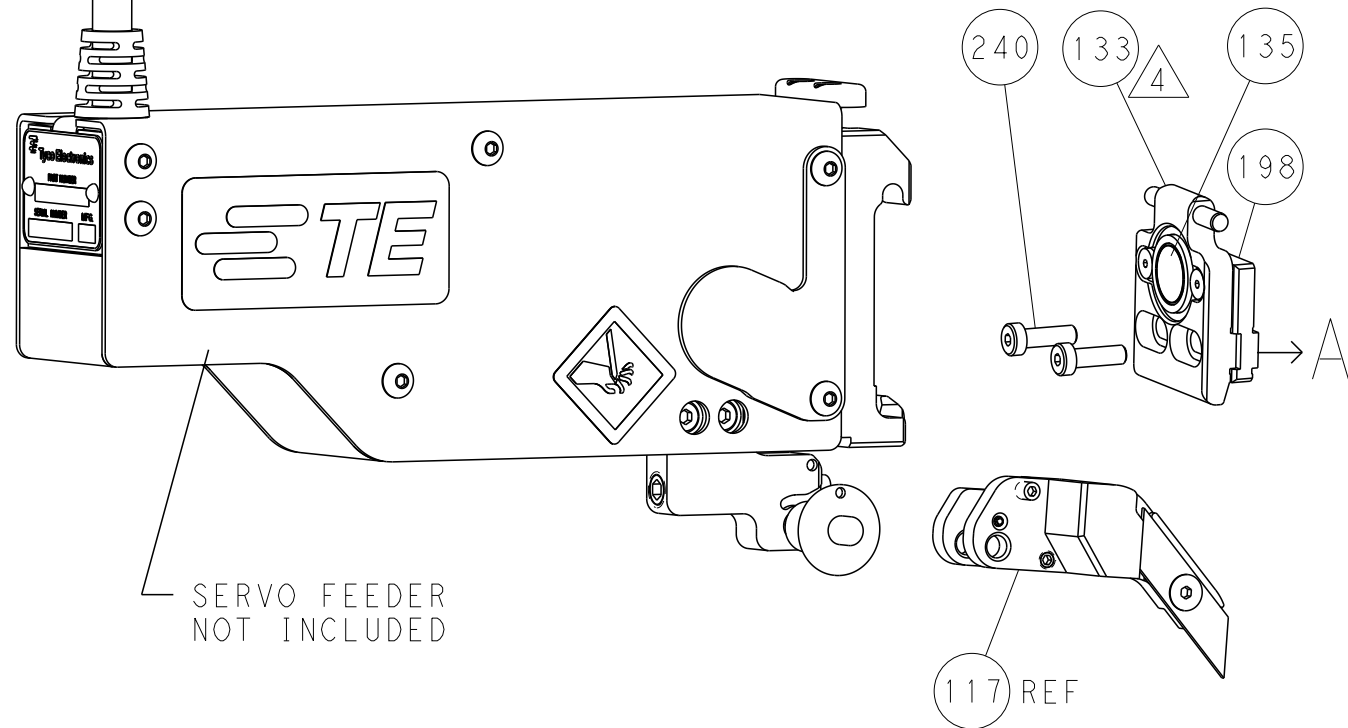
FEED TYPE
MECHANICAL



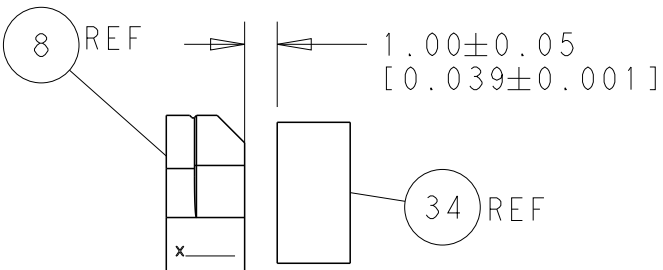
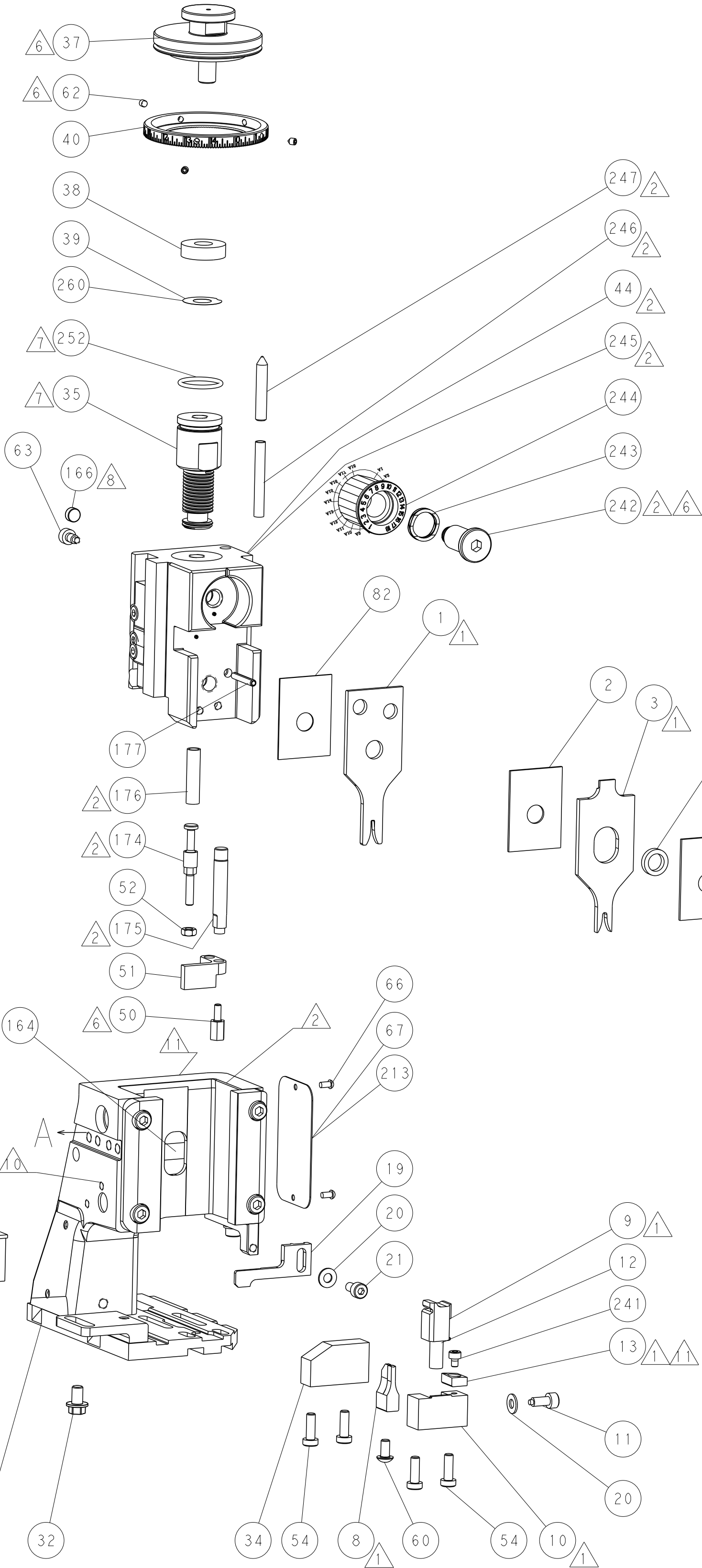
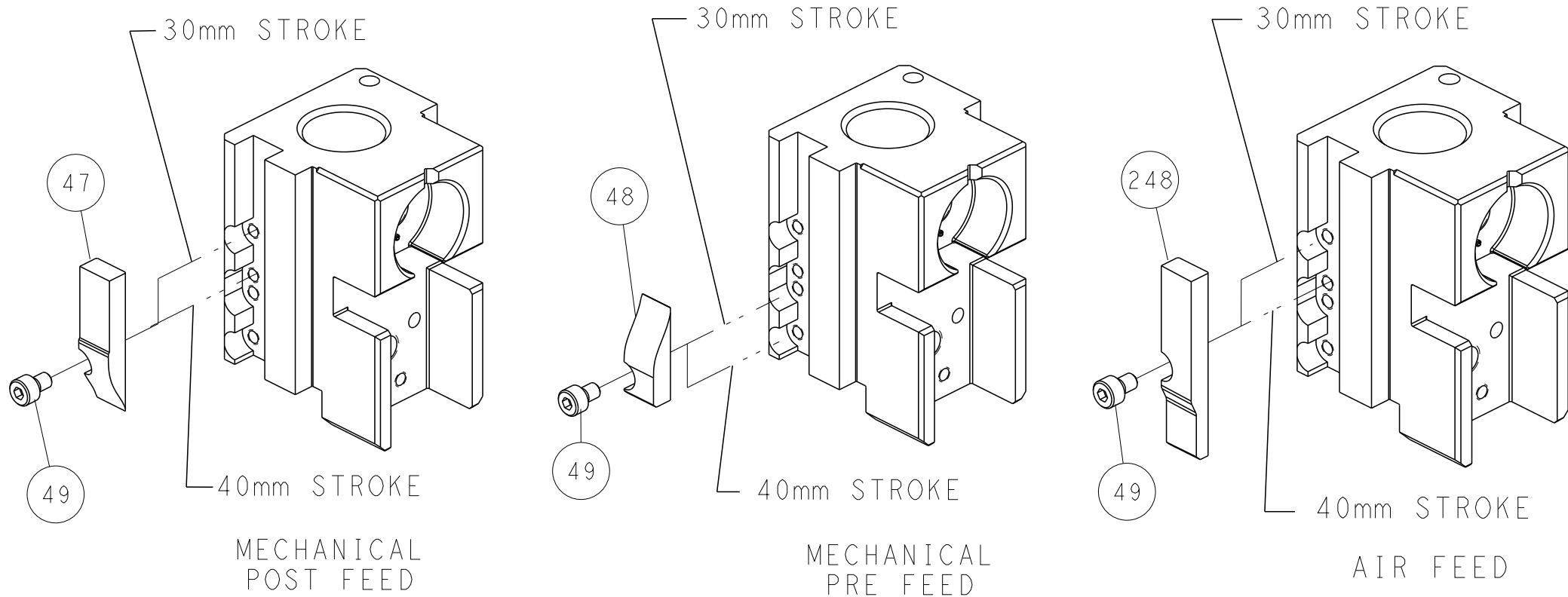
PNEUMATIC



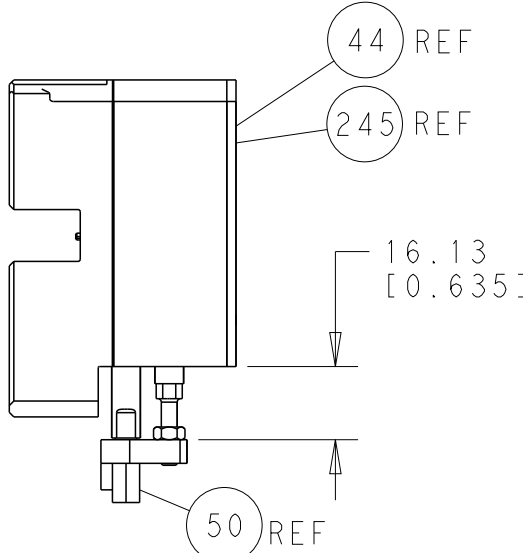
SERVO
LATCH PLATE



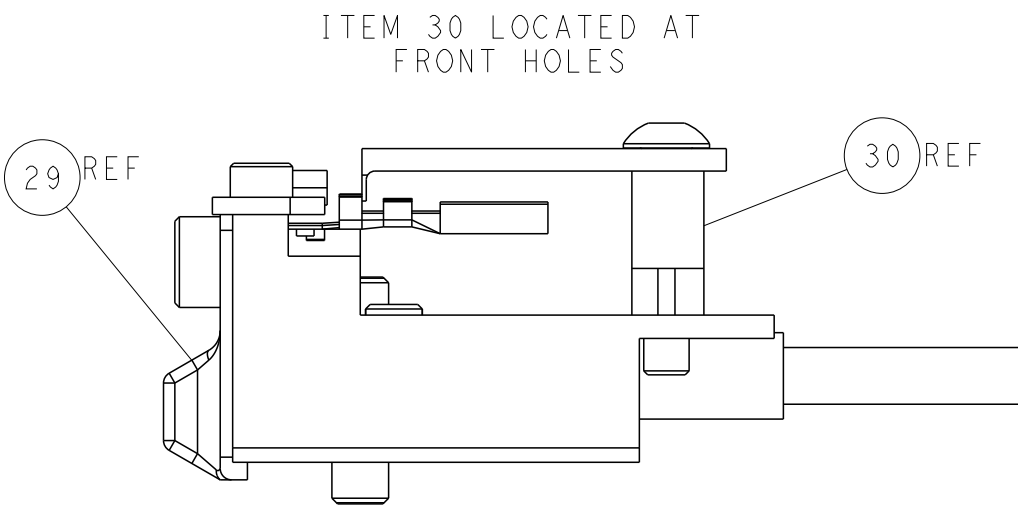
CAM POSITIONS



TERMINAL SUPPORT LOCATION



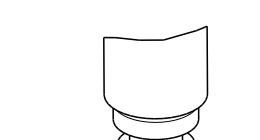
HOLDDOWN SET-UP



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO VERIFY THE LATEST VERSION OF THIS DRAWING. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN	Y. YIN	14SEP2011	TE Connectivity Harrisburg, PA 17105-3608			
CHK		G. BAILEY	14SEP2011	NAME	Ocean Side Feed Applicator			
APVD		S. XI	14SEP2011	PRODUCT SPEC	-			
APPLICATION SPEC		-				SIZE		
MATERIAL		-				CAGE CODE		
FINISH		-				DRAWING NO		
WEIGHT		-				RESTRICTED TO		
Customer Accessible Production Drawing		SCALE				1:2		
						SHEET		
						2 of 4		
						REV		
						F		

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151050-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151050-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151050-4	-	-	-
	2-2151050-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151050-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151050-4	-	-	-
	2-2151050-5	F	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
2-2151050-7	F	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
7-2151050-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: MICRO TIMER 2 CONTACT			
WIRE STRIP LENGTH 3.50-4.20 mm [.138-.165 IN]		INSULATION DIAMETER RANGE Ø1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-18081 Rev E	-	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL (A) 964261-2	TE TERMINAL (A) 964261-3	TE TERMINAL (A) 4-964261-1	TE TERMINAL (A) 1241858-2
(A) 4-1241858-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
0.50mm2		1.12+/-0.05 [.044+/- .002]		5.0
0.35mm2		1.05+/-0.03 [.041+/- .001]		5.8
0.25mm2		1.00+/-0.03 [.039+/- .001]		6.3
0.20mm2		0.98+/-0.03 [.039+/- .001]		6.5



- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
3. 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: 8-2151050-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151050-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151050-5
5. 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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TAB 1.6 X 0.6 TYPE A			
WIRE STRIP LENGTH 3.20-3.80 mm [.126-.150 IN]		INSULATION DIAMETER RANGE Ø1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-18081 Rev E	-	-	-
	(B)114-18082 Rev C	-	-
TERMINALS APPLIED			
TE TERMINAL (B) 964265-2	TE TERMINAL (B) 964265-3		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
0.35mm2		1.05+/-0.03 [.041+/- .001]		7.6
0.25mm2		1.00+/-0.03 [.039+/- .001]		8.1
0.20mm2		0.98+/-0.03 [.039+/- .001]		8.3

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TAB 1.6 X 0.6 TYPE A			
WIRE STRIP LENGTH 3.20-3.80 mm [.126-.150 IN]		INSULATION DIAMETER RANGE Ø 1.2-1.4 mm [.047-.055 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-18082	-	-	-
	(B)114-18081	-	-
TERMINALS APPLIED			
TE TERMINAL (A) 2141882-2	TE TERMINAL (A) 2141882-3	TE TERMINAL (B) 2141900-2	TE TERMINAL (B) 2141900-3

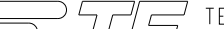
WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
0.35mm2		1.08+/-0.03 [.043+/- .001]		6.7

*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.

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

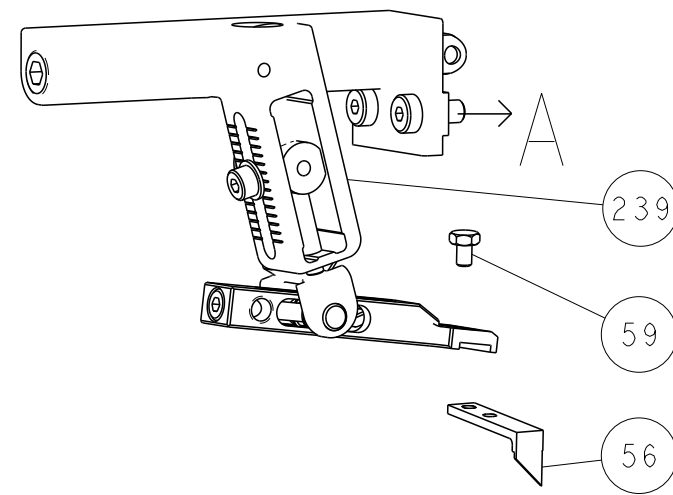
SET UP GAUGE 2119599-1	LOC A	DIS 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

6	-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
	-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	1	1	2119082-5	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	7-18023-7	SCR, SKT HD CAP M3 X 4.0	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	
4	-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
	-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
	-	1	1	1	1	455888-5	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, 2 x .188	66	
6	-	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	1338685-1	PAWL, FEED	56	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
6	-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
	-	1	1	1	1	1-1752354-9	STANDOFF,HOLD-DOWN	50
	-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0
-	-	-	-	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	1-1752356-3	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	1320908-1	SPACER, STRIP GUIDE	30	
-	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	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	
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1333202-1	ANVIL, COMBINATION	8
	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

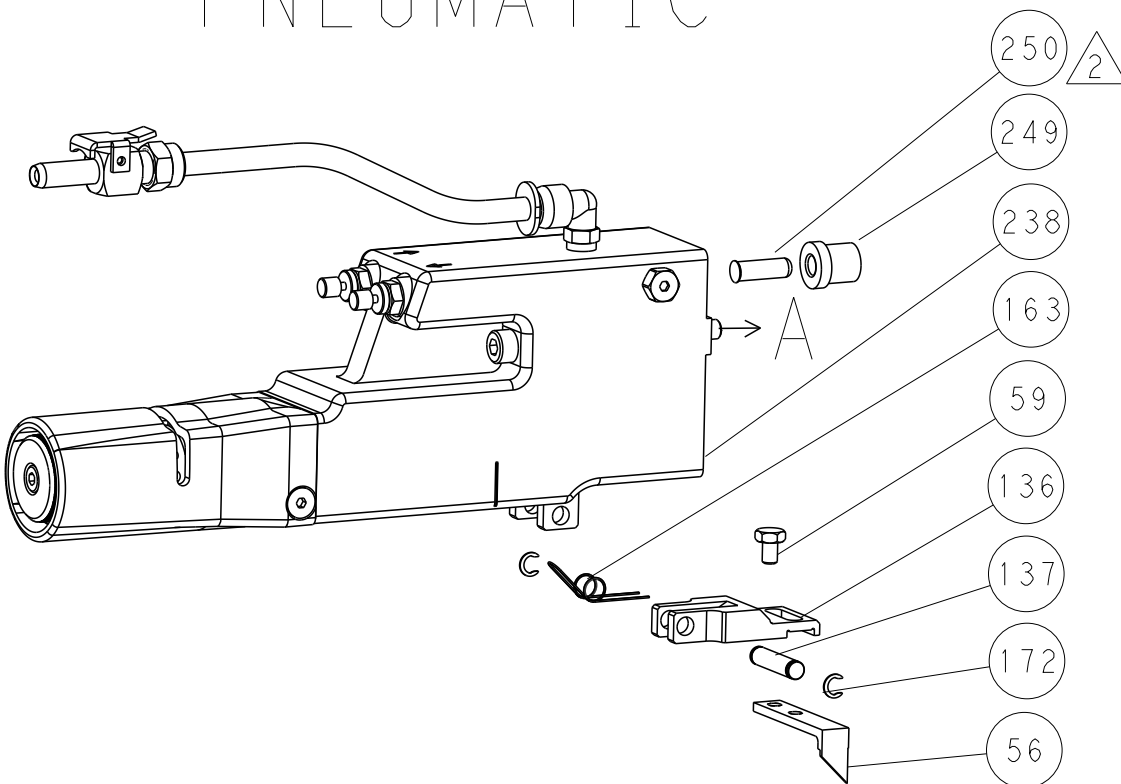
THE FOLLOWING IS A SUMMARY OF THE INFORMATION CONTAINED IN THIS DRAWING. IT IS THE RESPONSIBILITY OF THE USER TO OBTAIN THE LATEST REVISIONS OF THIS DRAWING. IT IS THE RESPONSIBILITY OF THE USER TO OBTAIN THE LATEST REVISIONS OF THIS DRAWING.				DWN T.YIN 14SEP2011		 TE Connectivity Harrisburg, PA 17105-3608			
				CHK G.BAILEY 14SEP2011					
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S.XI 14SEP2011		NAME		Ocean Side Feed Applicator	
		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		PRODUCT SPEC		SIZE		CAGE CODE	
MATERIAL -		FINISH -		APPLICATION SPEC		DRAWING NO		RESTRICTED TO	
				WEIGHT -		A1 00779 C=2151050		-	
Customer Accessible Production Drawing						SCALE		1:2	
						SHEET		3 OF 4	
						REV		F	

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

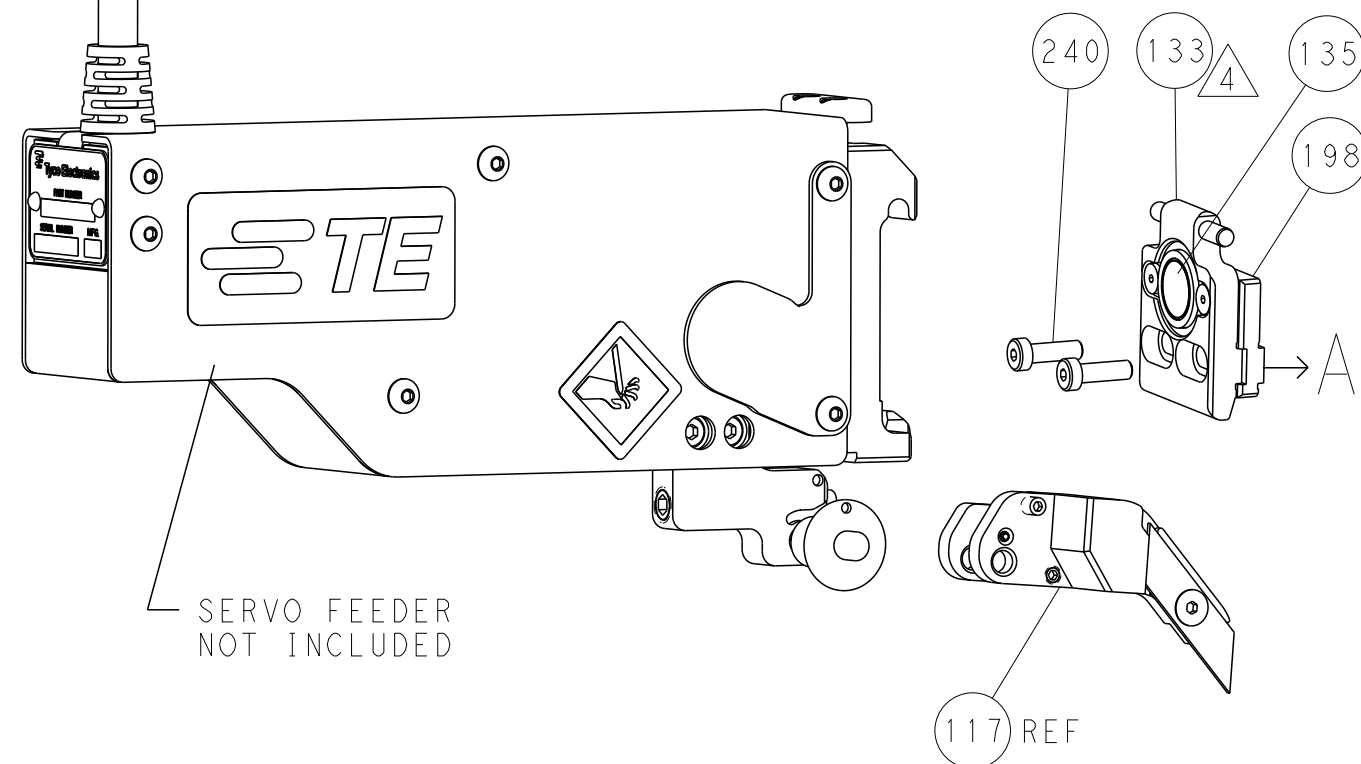
FEED TYPE
MECHANICAL



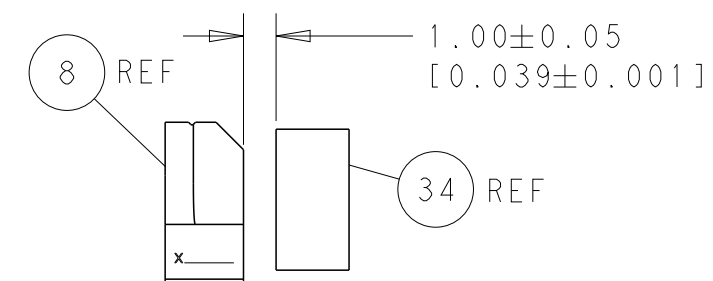
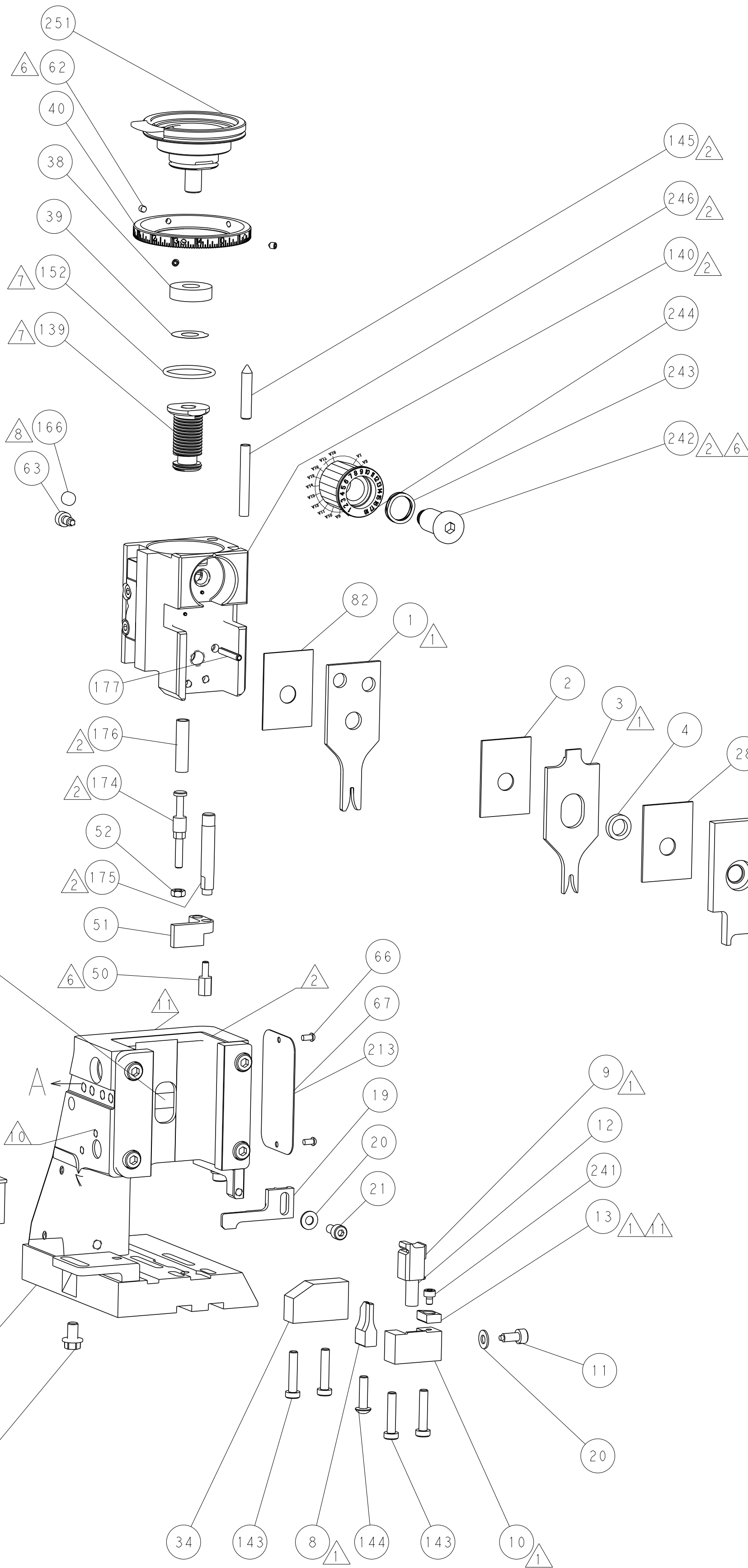
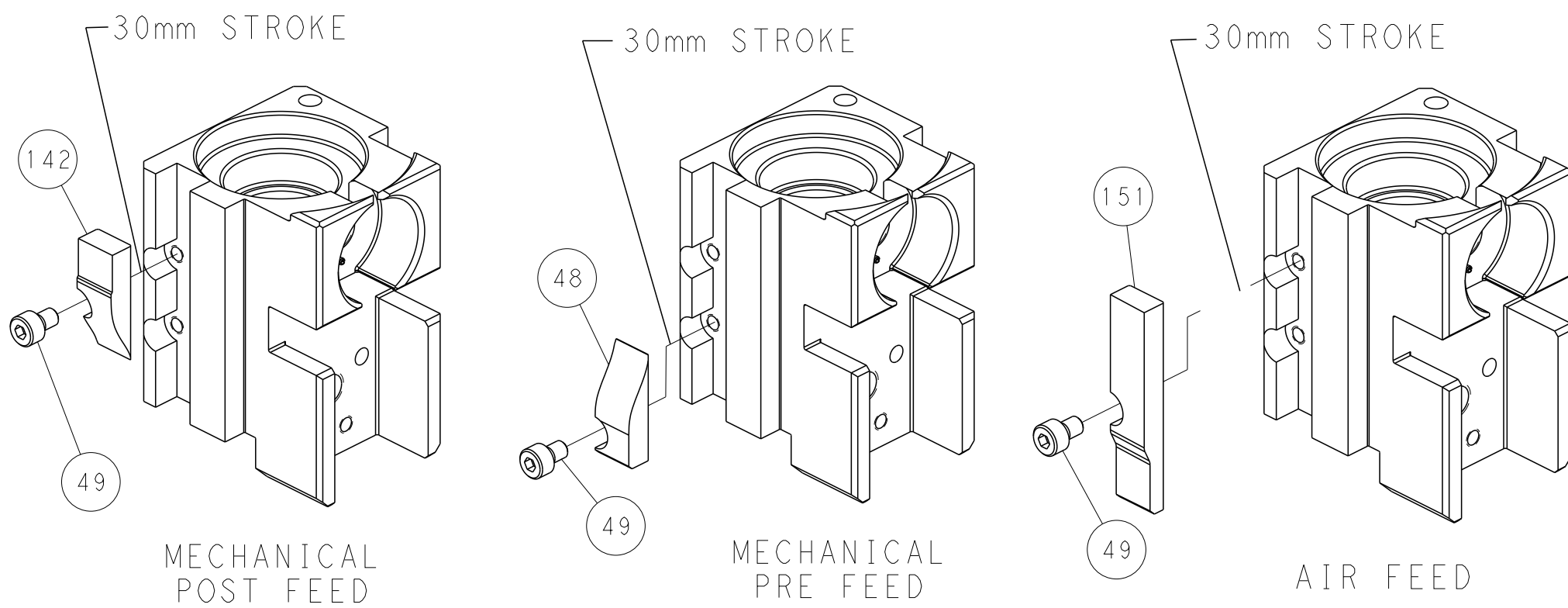
PNEUMATIC



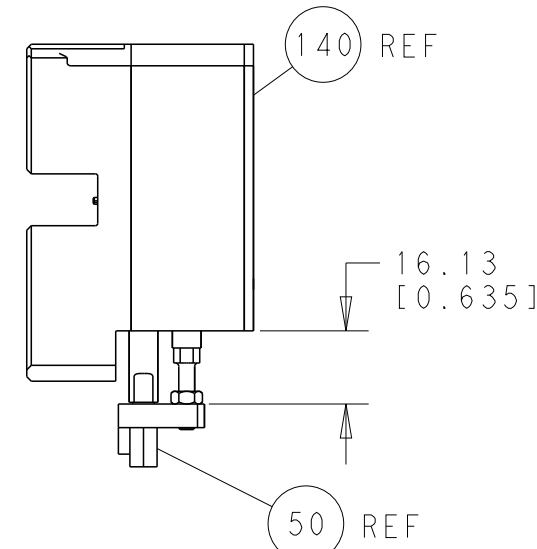
SERVO
LATCH PLATE



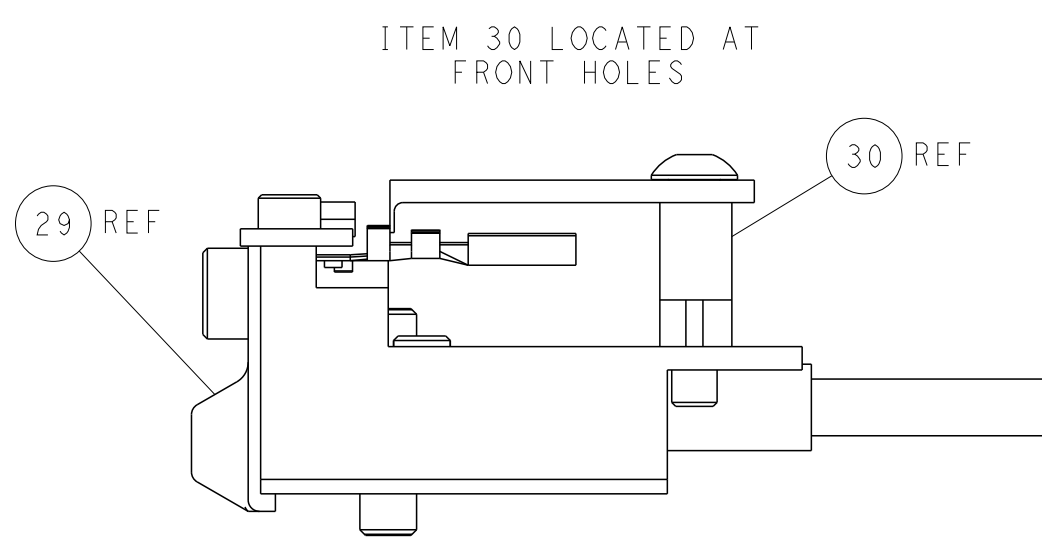
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		DWN	Y. YIN	14SEP2011	 TE Connectivity Harrisburg, PA 17105-3608	
		CHK	G. BAILEY	14SEP2011		
		APVD	S. XI	14SEP2011	NAME	
		PRODUCT SPEC			Ocean Side Feed Applicator	
		APPLICATION SPEC			-	
		WEIGHT			-	
		Customer Accessible Production Drawing			-	
		SCALE			1:2	
		SHEET			4 of 4	
		REV			F	

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