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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

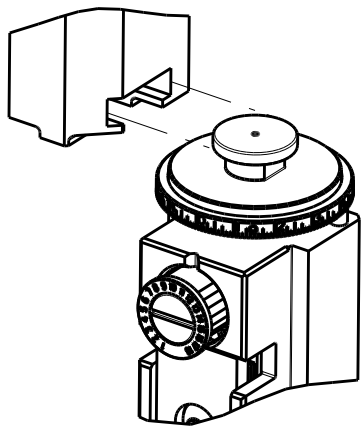
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151813-2

E

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE
SMART APPLICATOR

2119951-1
2161326-1

-
-

8-2151813-5
8-2151813-4

1901094-3
-

-
-

2168400-6 (QUANTITY 2)

2151813-5

E

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

2151813-6

E

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

-

-

-

-

-

-

2151813-7

E

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2151813-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 2.54 mm [.100] F

INSUL 3.30 mm [.130] F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 2.8 X 0.8 LITEALUM

WIRE STRIP LENGTH INSULATION DIAMETER RANGE

3.20-3.80 mm [.126-.150 IN] Ø2.88-3.04 mm [.113-.120 IN]

TERMINAL APPLICATION SPECIFICATION

114-94204

TERMINALS APPLIED

TE TERMINAL TE TERMINAL TE TERMINAL TE TERMINAL

2-2177895-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

2.50mm2

1.52±0.04 [.0598±.0016]

3.2

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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151813-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151813-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151813-6

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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 99 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.

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.

TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT.

SET THE FINE CRIMP HEIGHT ADJUSTMENT HEAD TO PROPER CRIMP HEIGHT PRIOR TO TIGHTENING/LOCKING THE BRASS TIP SET SCREW, ITEM 99, AGAINST THE ADJUSTMENT BOLT THREADS.

APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

*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.

-	1	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	268
-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	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	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

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		LOC	DIST	REVISIONS			
2119599-1		A	66	P	LTR	DESCRIPTION	DATE
							DWN
							APVD
				C4		ECR-15-001216	25JAN2015
							MR
				C5		ECR-15-003249	03MAR2015
							RS
				D		ECR-15-015082	14OCT2015
							DJG
				E		ECR-16-002616	23FEB2016
							XZ
							CT

-	1	1	1	1	2119082-4	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	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	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	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	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2256587-1	SCR, SET, SOFT TIP, M4	99
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1	2-2119656-3	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1-1752356-7	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	1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	1	1901086-1	PLATE, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	690472-2	STRIPPER	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-5	STOP, SHEAR	11
-	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	2161316-5	ANVIL, COMBINATION	8
-	1	1	1	1	2-240641-9	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-1722335-0	SHEAR DEPRESSOR ASSEMBLY	5
-	1	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1-1722335-2	CRIMPER, INSULATION F	3
-	-	-	-	-	-	-	2
1	1	1	1	1	2217303-2	CRIMPER, WIRE, CONICAL BLEND	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE AND WITHOUT NOTICE. THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE AND WITHOUT NOTICE.		DWN	C. CHEN	07FEB2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK	S. XI	07FEB2013	NAME Ocean Side Feed Applicator -	
mm		APVD	J. CRUZ	07FEB2013		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC				
0 PLC ±.0005		APPLICATION SPEC				
1 PLC ±.0005		MATERIAL				
2 PLC ±.0005		FINISH				
3 PLC ±.0005		WEIGHT				
4 PLC ±.0005		Customer Accessible Production Drawing				
ANGLES		SCALE				
FINISH		SHEET				
-		REV				

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

D

C

B

A

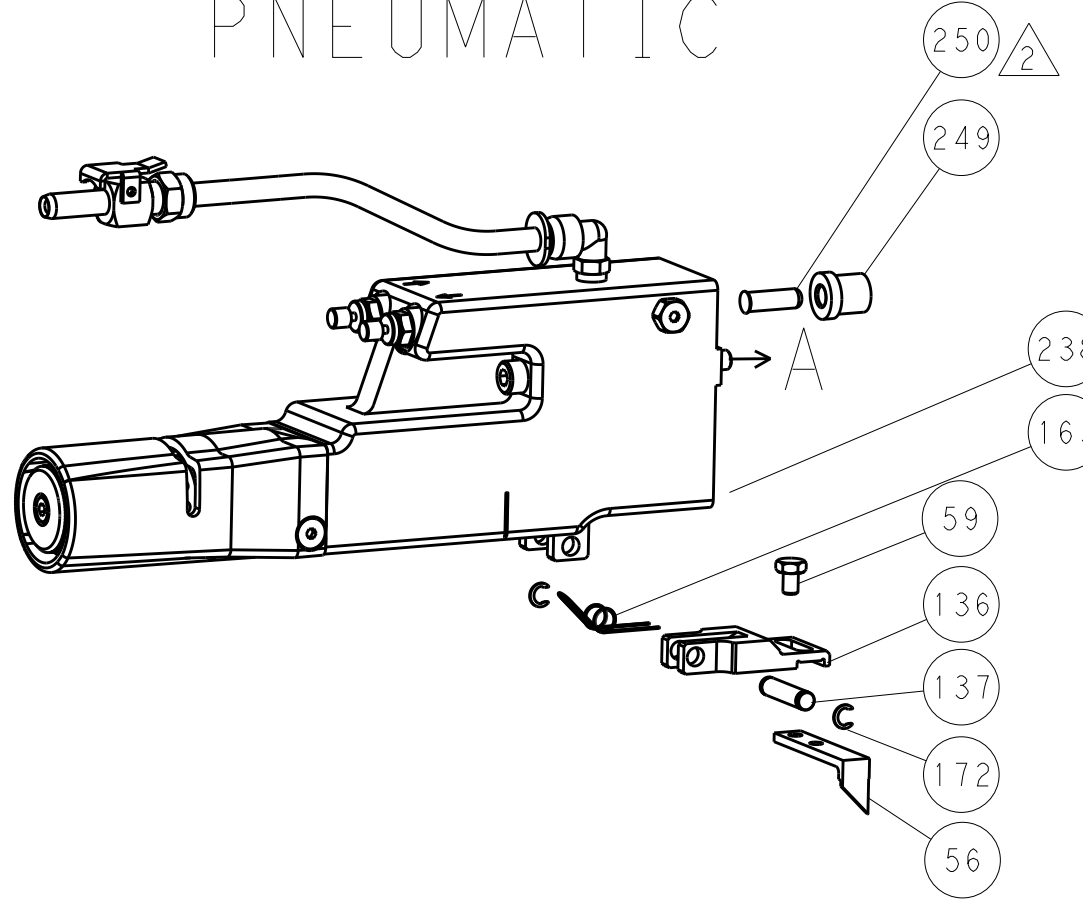
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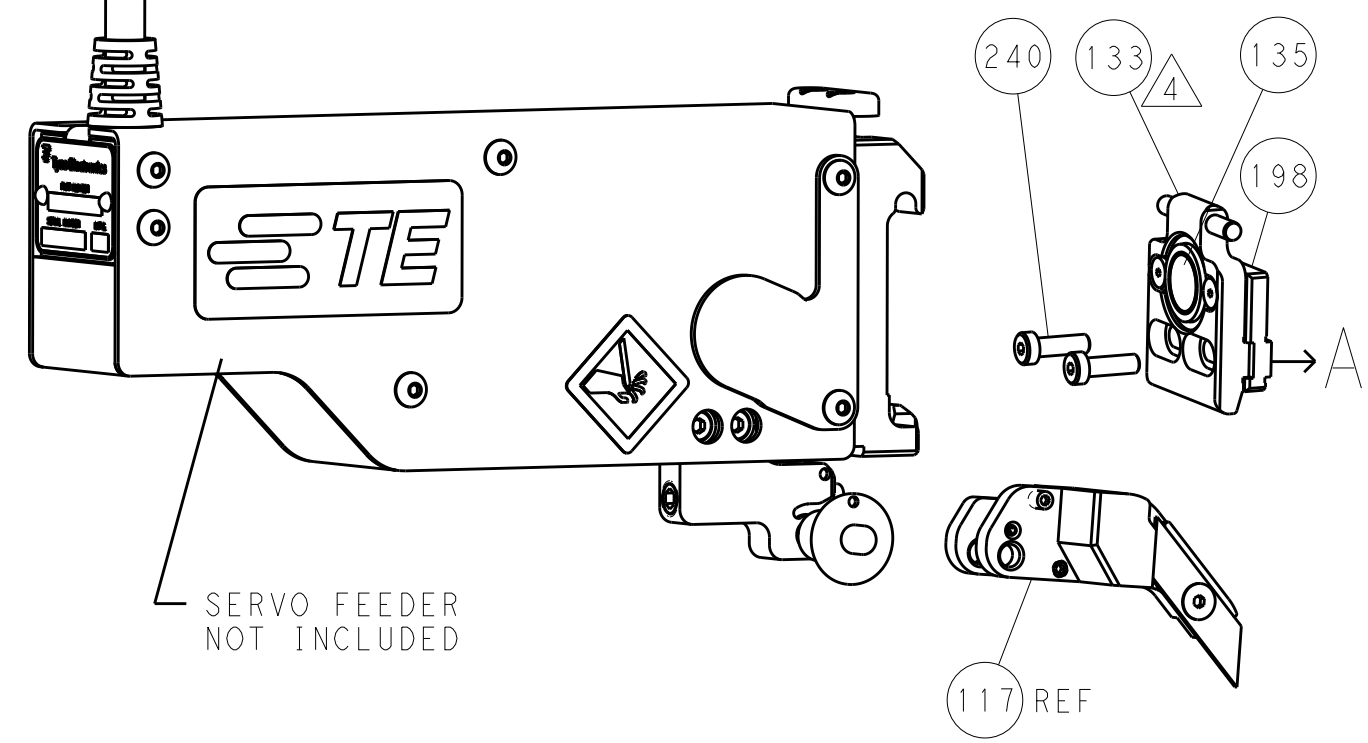
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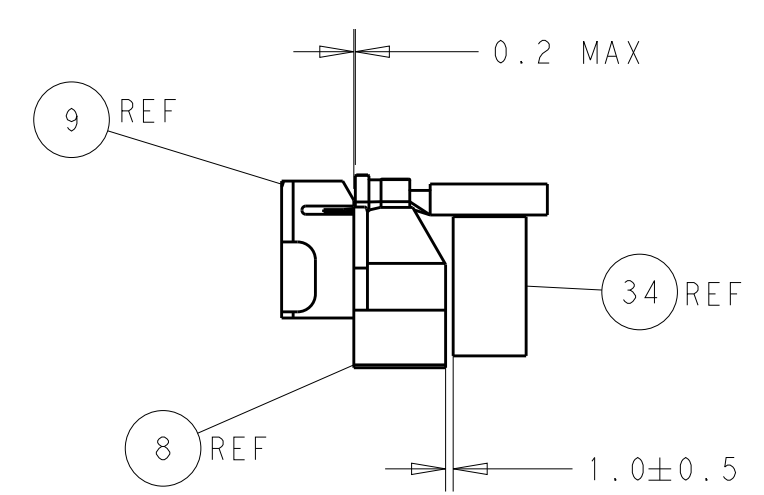
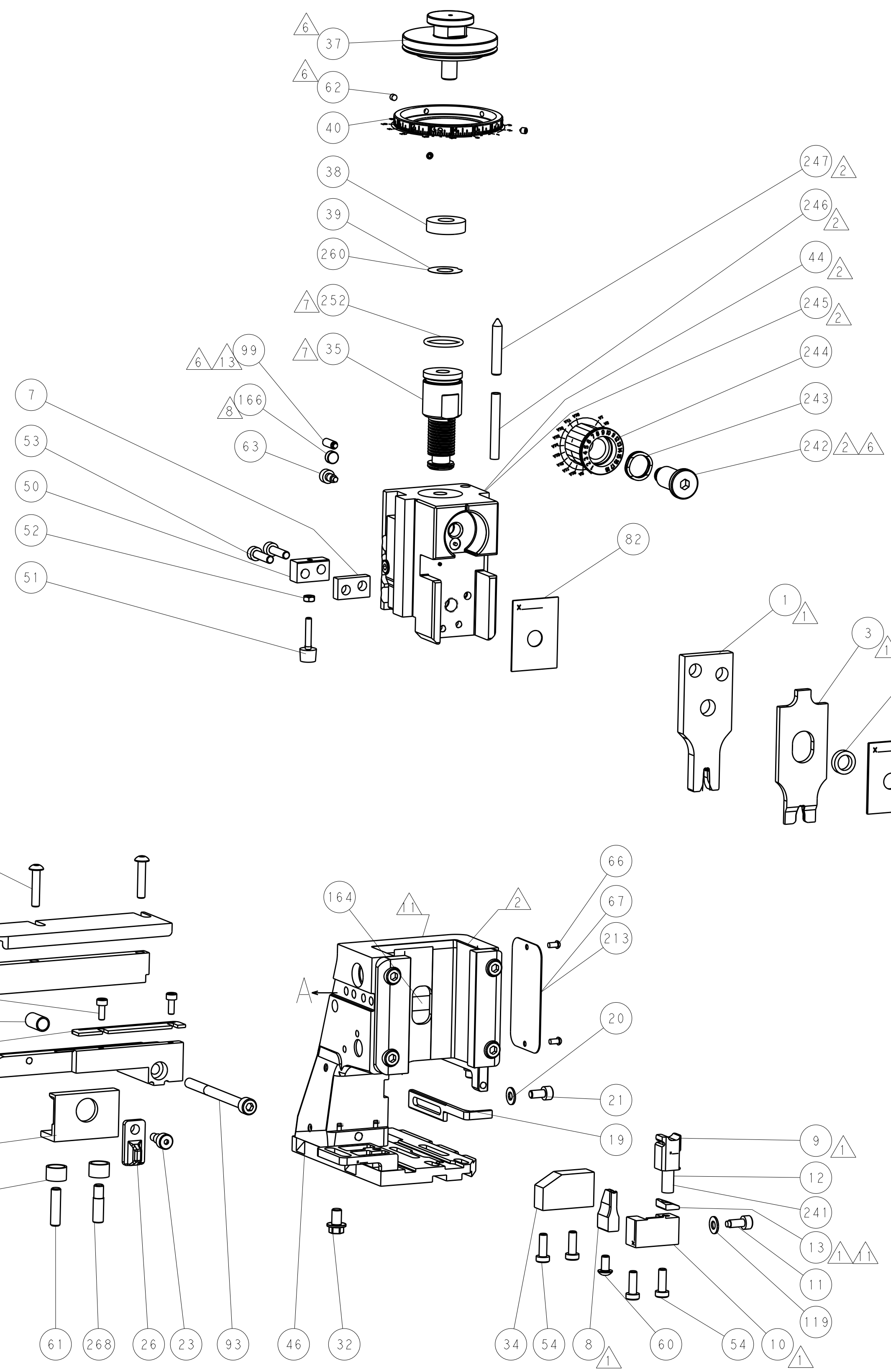
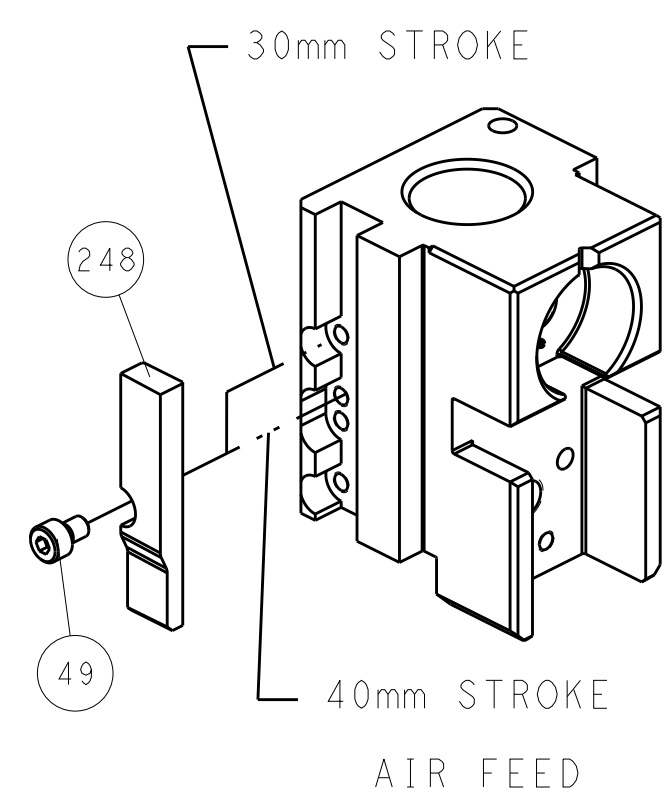
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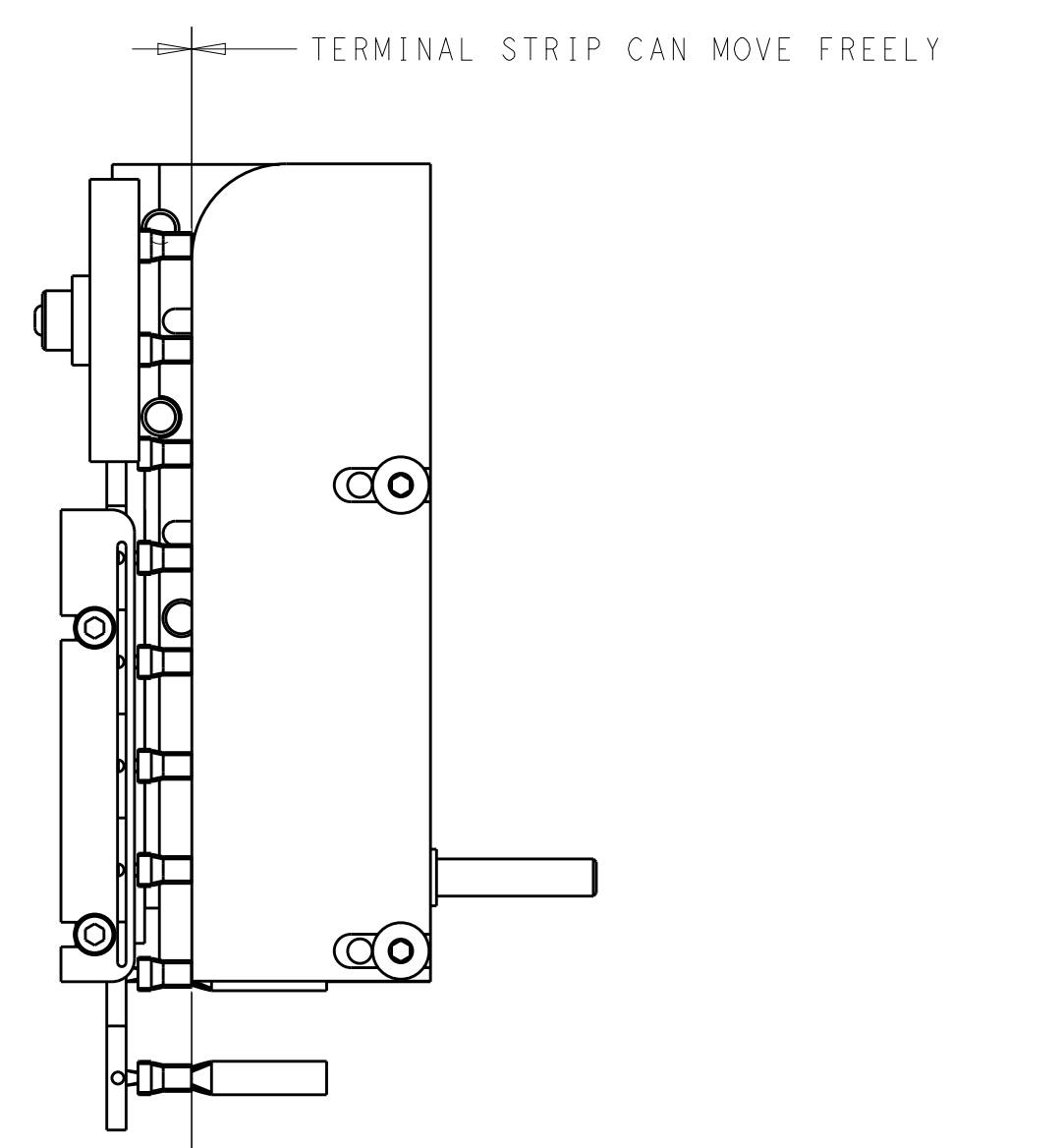
SERVO
LATCH PLATE



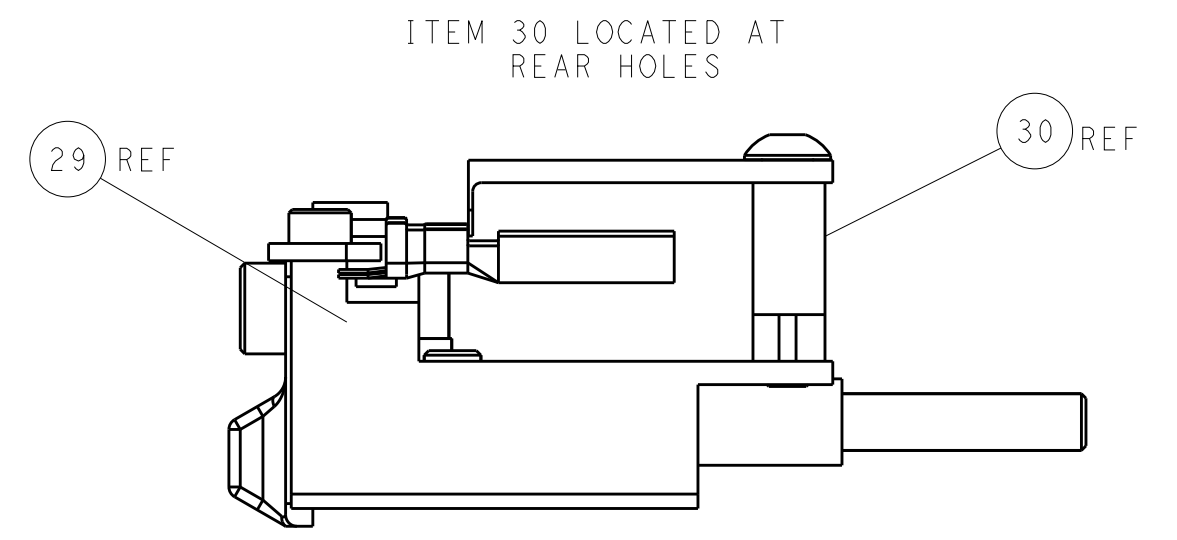
CAM POSITION



TERMINAL SUPPORT LOCATION



TERMINAL STRIP CAN MOVE FREELY WITH A MINIMUM OF SIDE CLEARANCE



FEED TRACK POSITION GUIDE BY WIRE 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 07FEB2013				APVD J. CRUZ 07FEB2013				NAME Ocean Side Feed Applicator			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC			
0 PLC				±				APPLICATION SPEC			
1 PLC				±				SIZE			
2 PLC				±				CAGE CODE			
3 PLC				±				DRAWING NO			
4 PLC				±				RESTRICTED TO			
ANGLES				FINISH				A1			
MATERIAL				WEIGHT				00779			
								©=2151813			
								Customer Accessible Production Drawing			
								SCALE 1:2			
								SHEET 2 OF 4			
								REV E			

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

D

C

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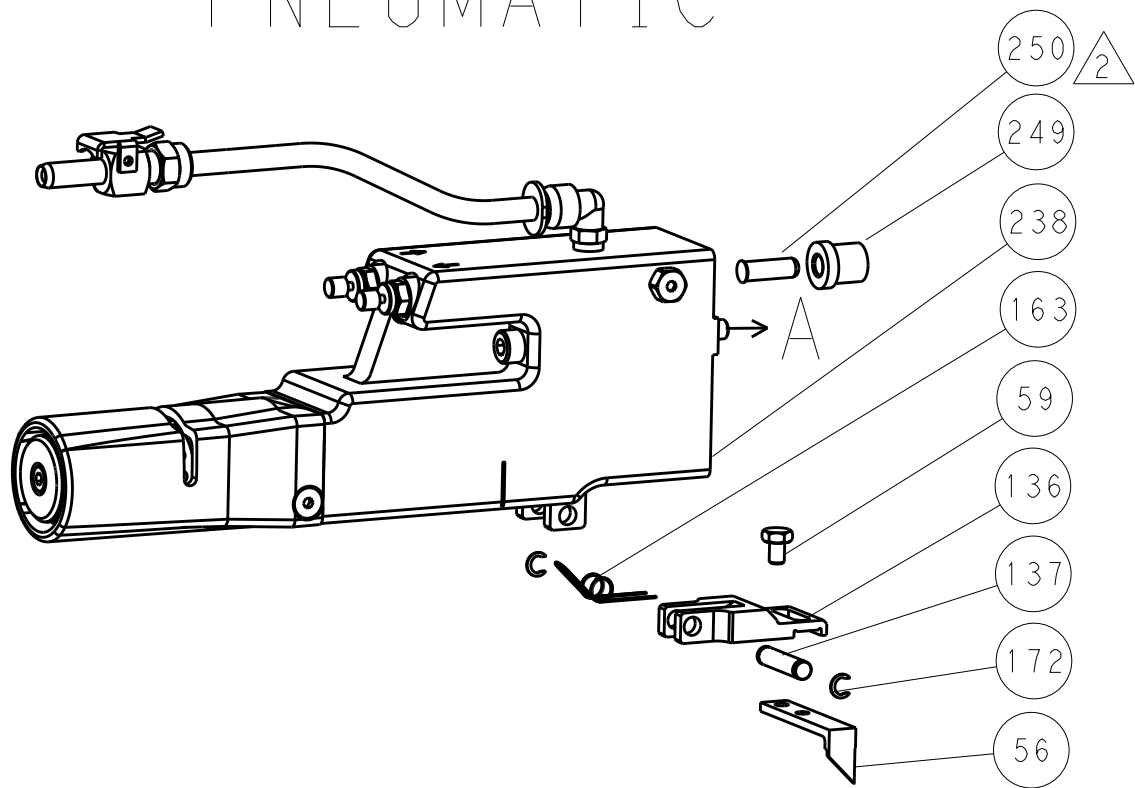
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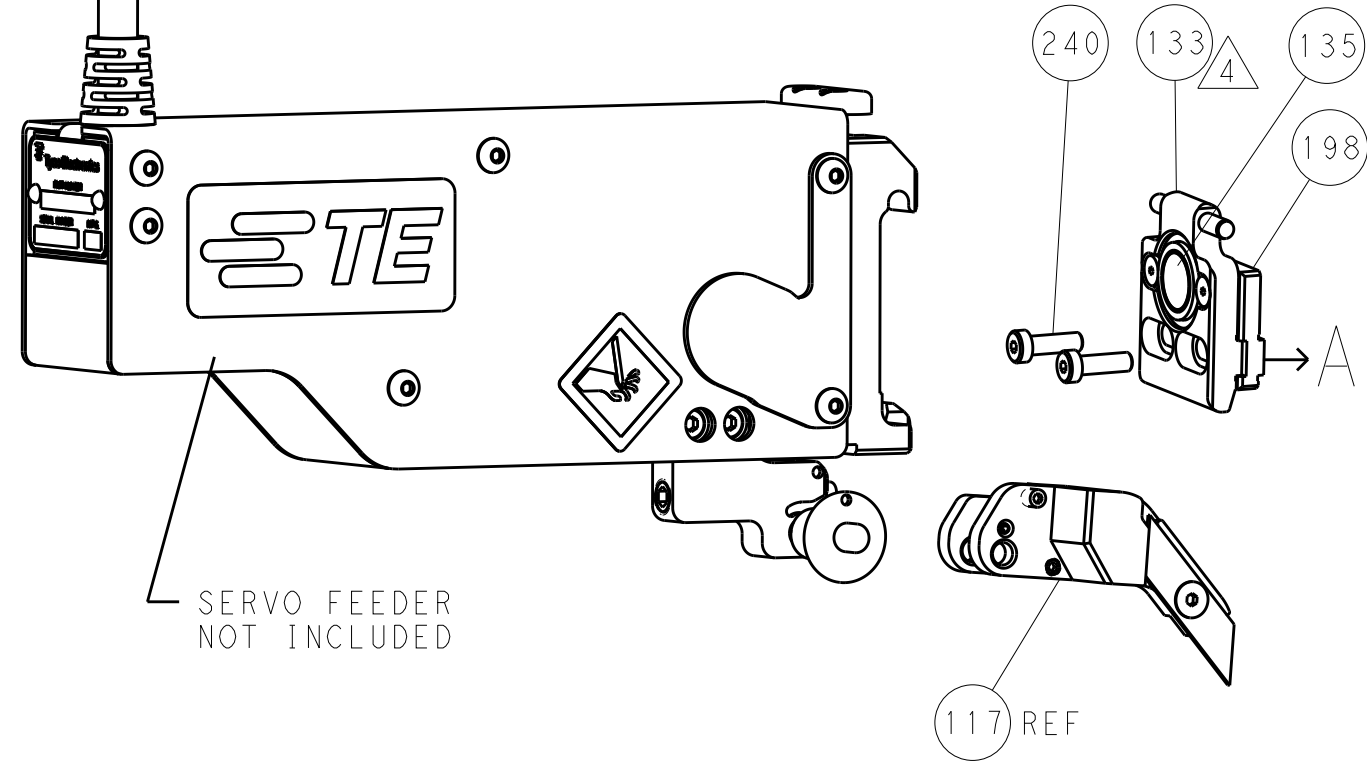
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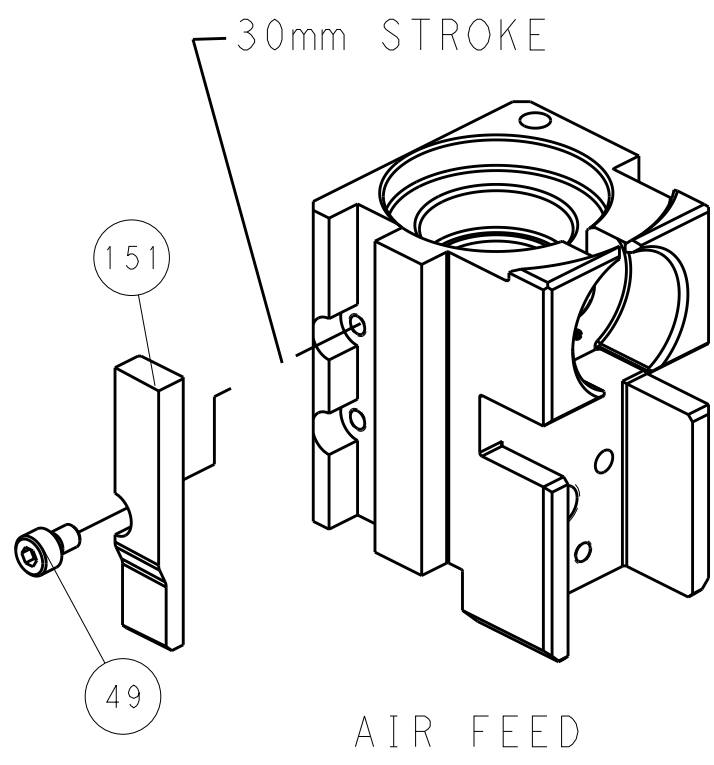
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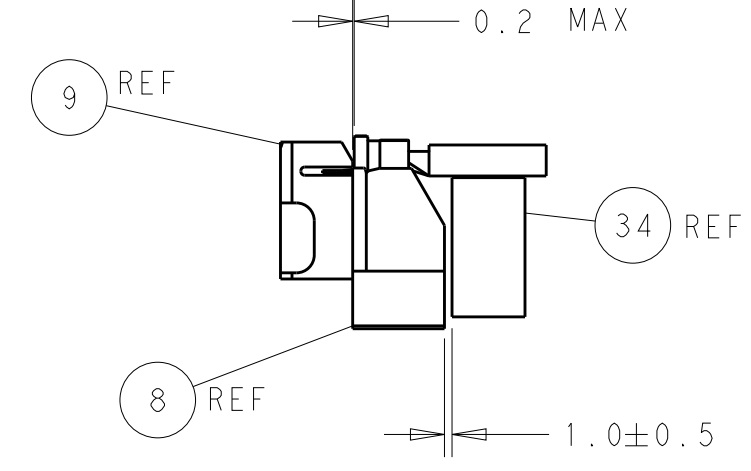
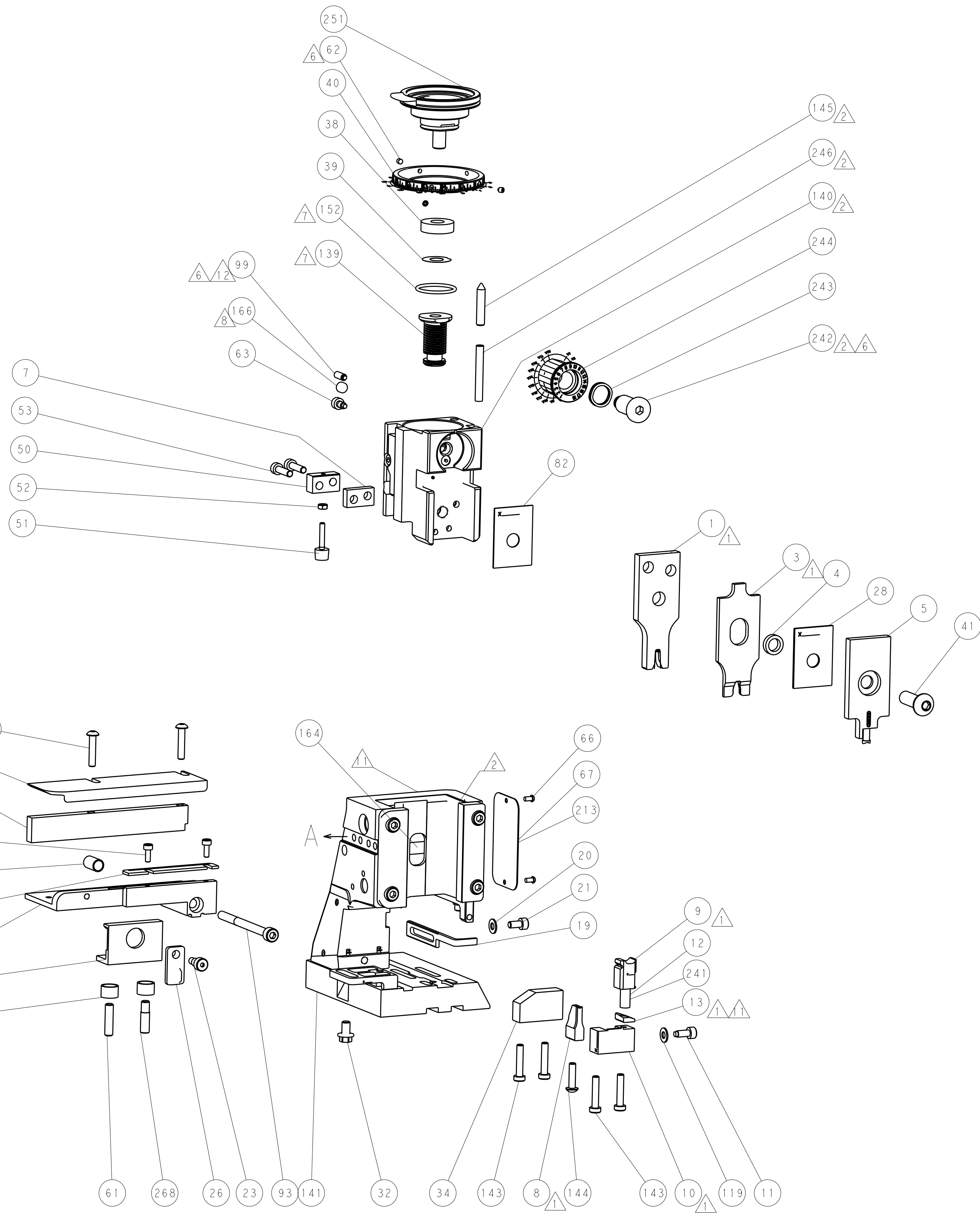
SERVO LATCH PLATE



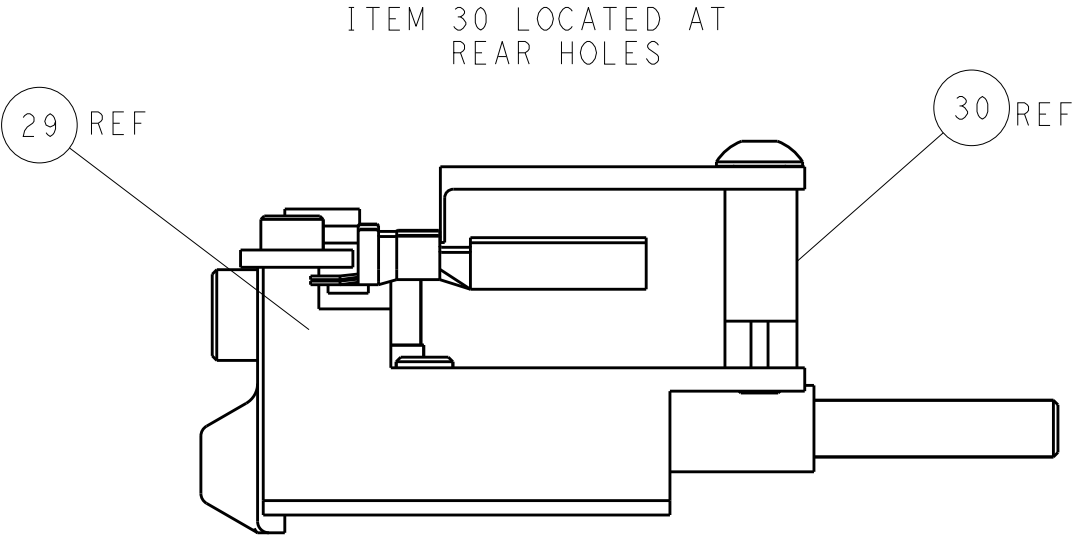
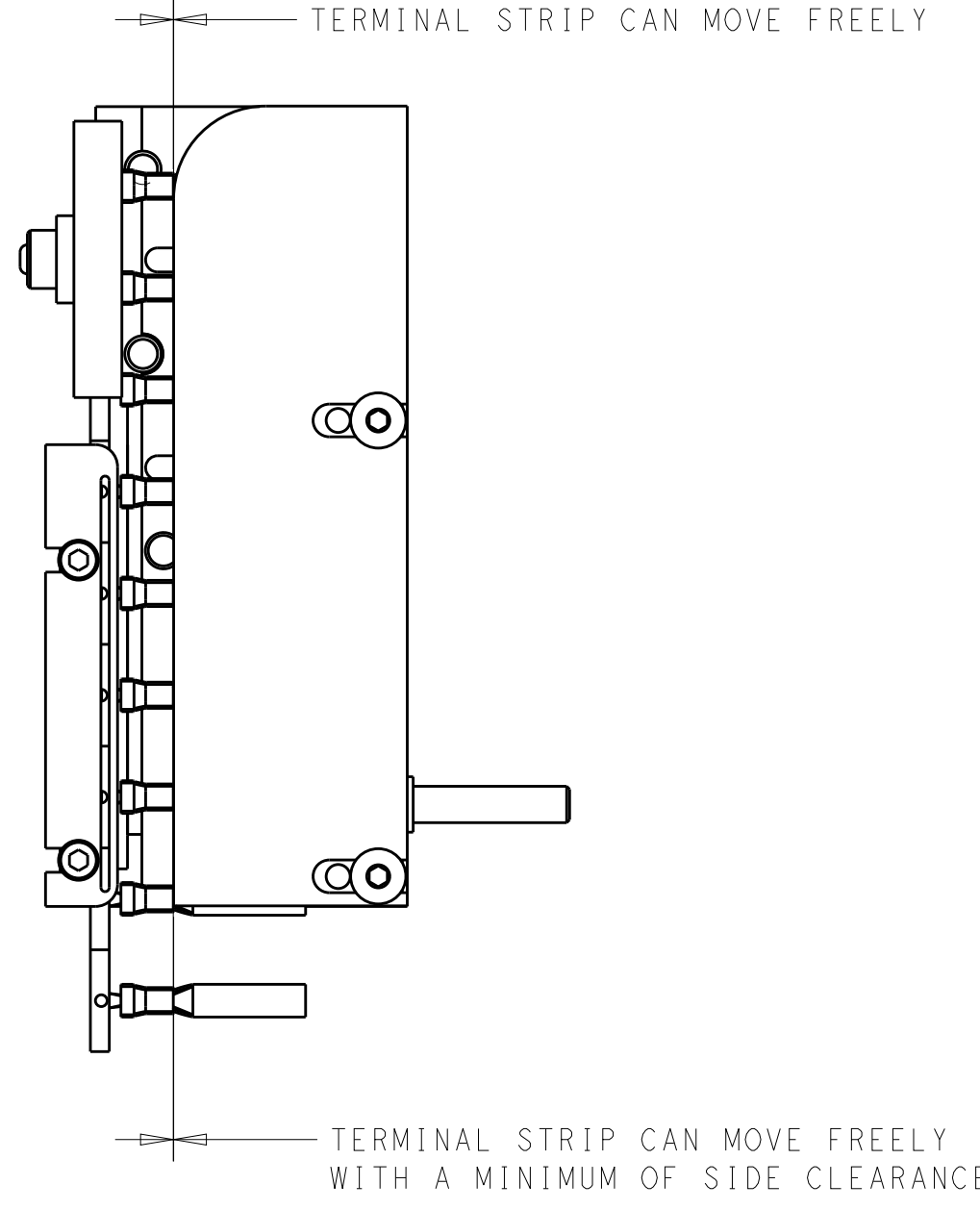
CAM POSITION



AIR FEED



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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:				CHK S. XI 07FEB2013				NAME Ocean Side Feed Applicator			
mm				APVD J. CRUZ 07FEB2013				SIZE A1			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC				CAGE CODE 00779			
0 PLC ±				APPLICATION SPEC				DRAWING NO 2151813			
1 PLC ±				WEIGHT				SCALE 1:2			
2 PLC ±				FINISH				SHEET 4			
3 PLC ±				Customer Accessible Production Drawing				REV E			
4 PLC ±											
ANGLES											

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION