

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
	2151477-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
					SERVO LATCH PLATE	2119951-1	-	8-2151477-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2151477-4	-	-	-	
	2151477-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
					SERVO LATCH PLATE	2119951-1	-	8-2151477-5	1901094-3	-	2168400-6 (QUANTITY 2)	
	2151477-5	H	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1	
					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	
	2151477-6	H	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1	
					-	-	-	-	-	-	-	
	2151477-7	H	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
-					-	-	-	-	-	-		
3-2151477-2	H	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS	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		
				SERVO LATCH PLATE	2119951-1	-	8-2151477-5	1901094-3	-	2168400-6 (QUANTITY 2)		
7-2151477-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm (.055)	F
INSUL	3.18 mm (.125)	O

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2MM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.30-3.90 mm (.130-.154 IN)		Ø	△3
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1718760-1	1718760-2	967067-1	963142-2
1718760-3	-	-	-
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	△9
0.75mm2	1.05+/-0.03 [.041+/- .001]	5.9	
20 AWG OR 0.50mm2	0.93+/-0.03 [.037+/- .001]	7.2	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2MM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.30-3.90 mm (.130-.154 IN)		Ø	△3
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2141116-1	2208328-3	967067-1	963142-2
2141116-3	-	-	-
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	△9
0.75mm2	0.98+/-0.03 [.039+/- .001]	6.8	
20 AWG OR 0.50mm2	0.93+/-0.03 [.037+/- .001]	7.2	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2MM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.30-3.90 mm (.130-.154 IN)		Ø	△3
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1718760-1	1718760-2	1718760-3	967067-1
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	△9
20 AWG (.19 / 0.203 mm)	0.99+/-0.03 [.039+/- .001]	6.7	
0.61mm2	0.99+/-0.03 [.039+/- .001]	6.7	

- 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: 8-2151477-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151477-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151477-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151477-6
- 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 ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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
- 13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
 SEAL P/N 967067-1 INS. DIA.: 1.4-2.1mm.
 SEAL P/N 963142-2 INS. DIA.: 0.9-1.3mm.
- 14 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.

***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.

△3 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

△6 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.

-	1	-	-	-	-	1803430-1	AIR FEED MODULE	290	
-	-	-	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	
-77	-32	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

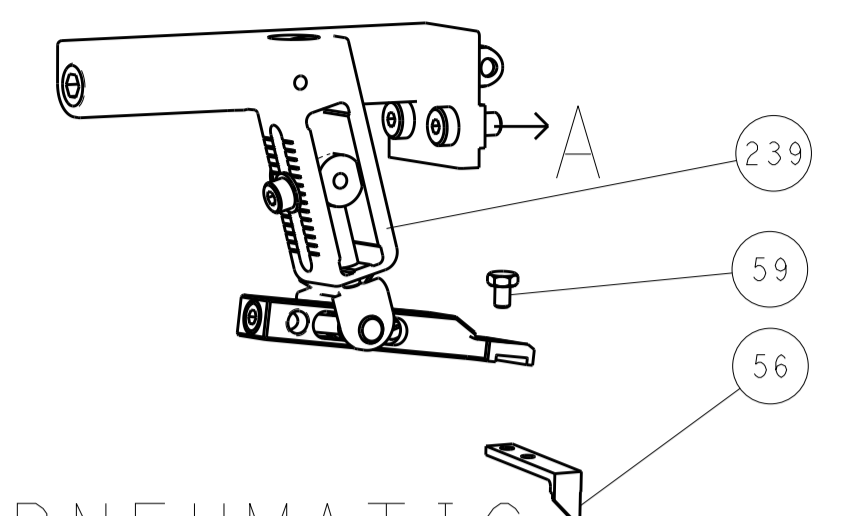
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE		LOC	DIST	REVISIONS					
2119599-1		A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
				G2		ECR-16-005595	18APR2016	JH	JDG
				H		ECR-16-011268	05AUG2016	YY	JT
				H1		ECR-16-015428	4NOV2016	RS	LZ
				H2		ECR-17-001637	04FEB2017	KH	LZ

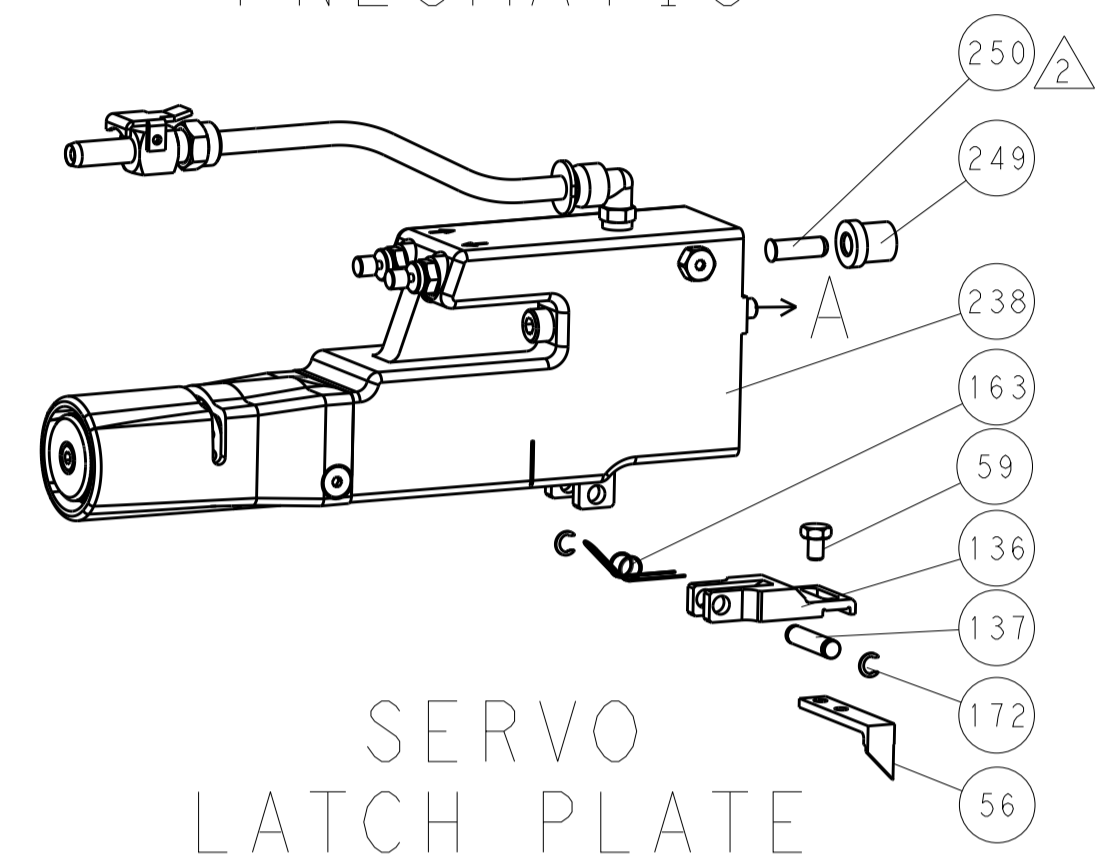
-	1	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	-	-	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	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	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	-	-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	1	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	-	-	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	-	-	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	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10

LOC	DIST	REV	DATE	BY	APPV
A	66				

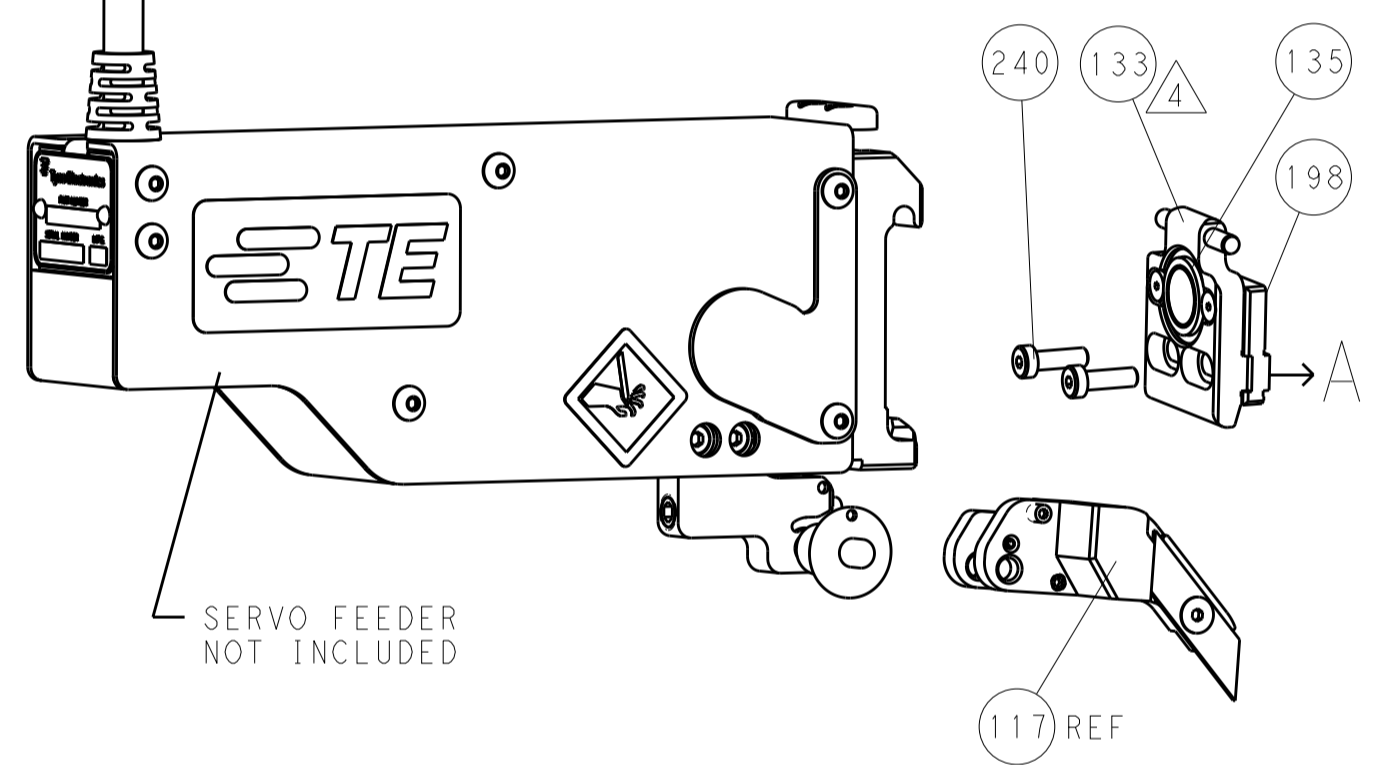
FEED TYPE MECHANICAL



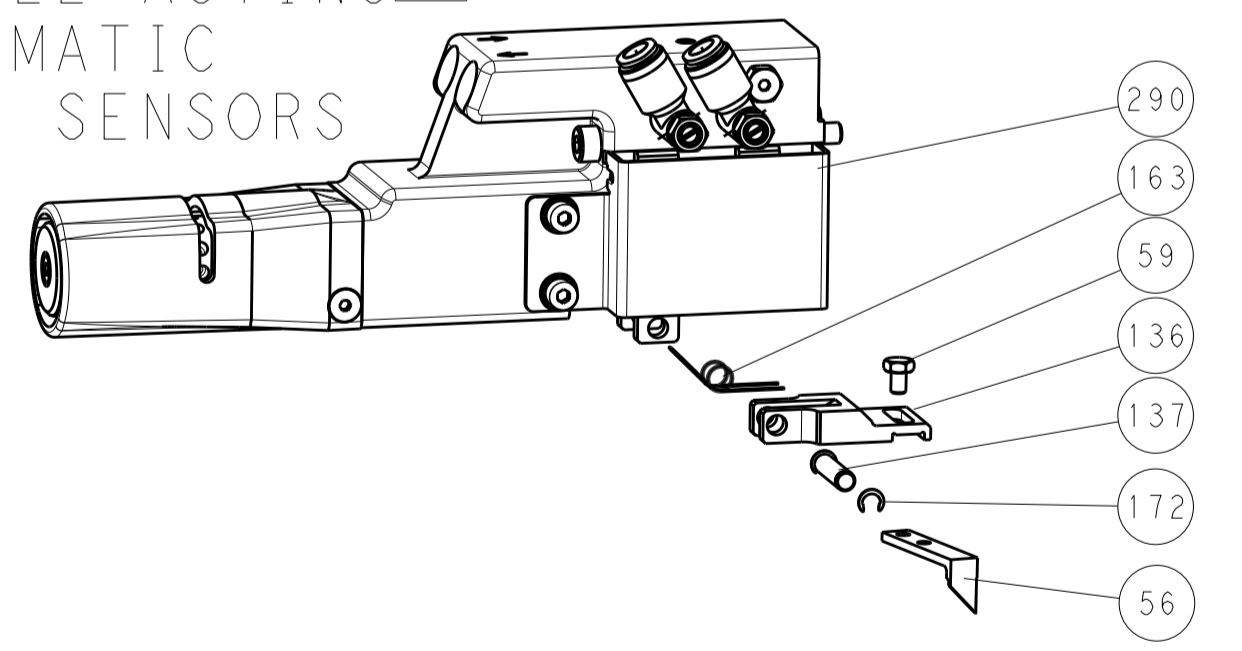
PNEUMATIC



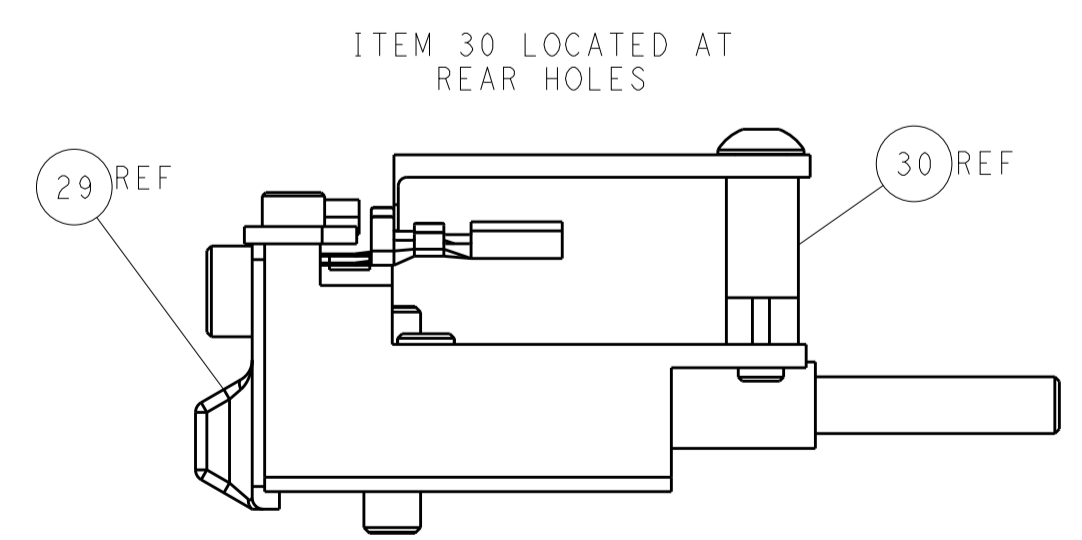
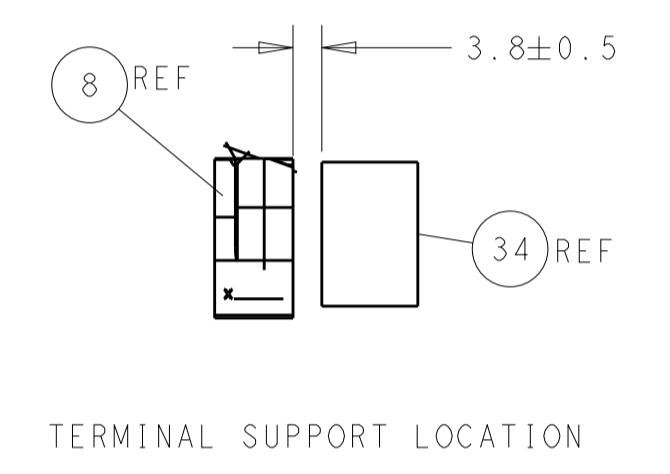
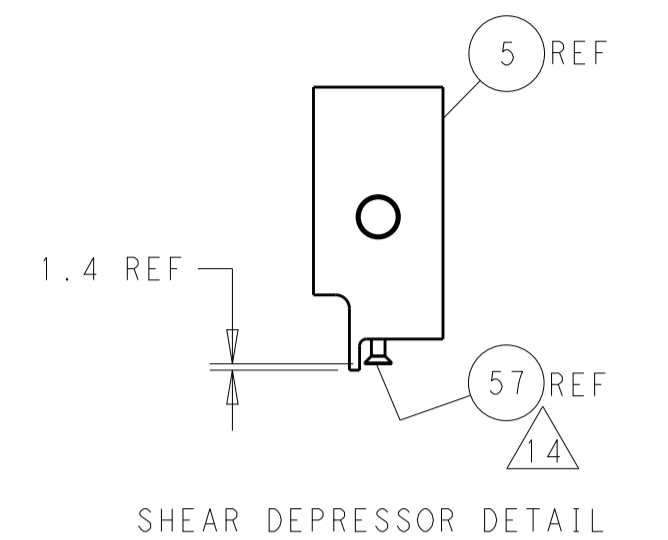
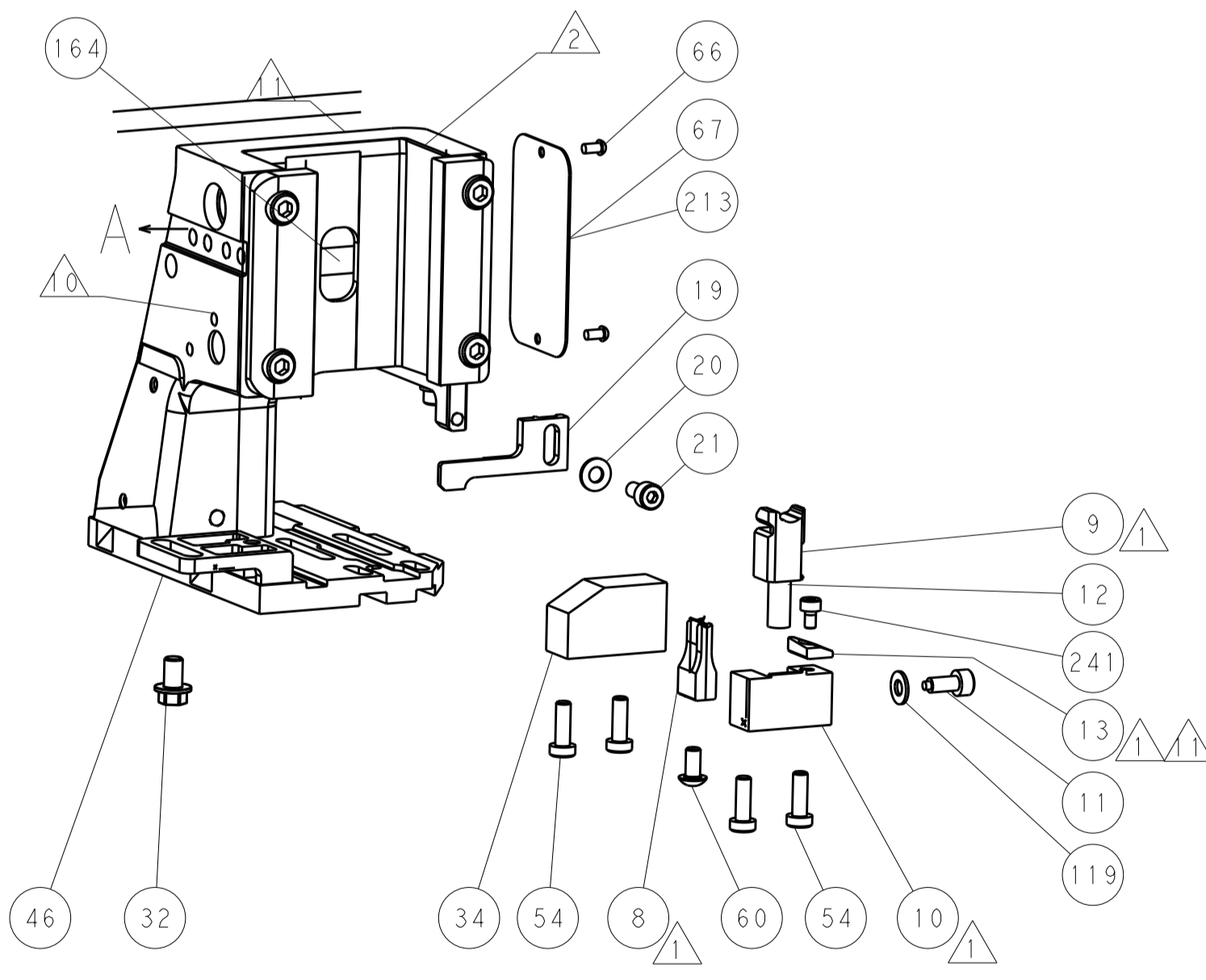
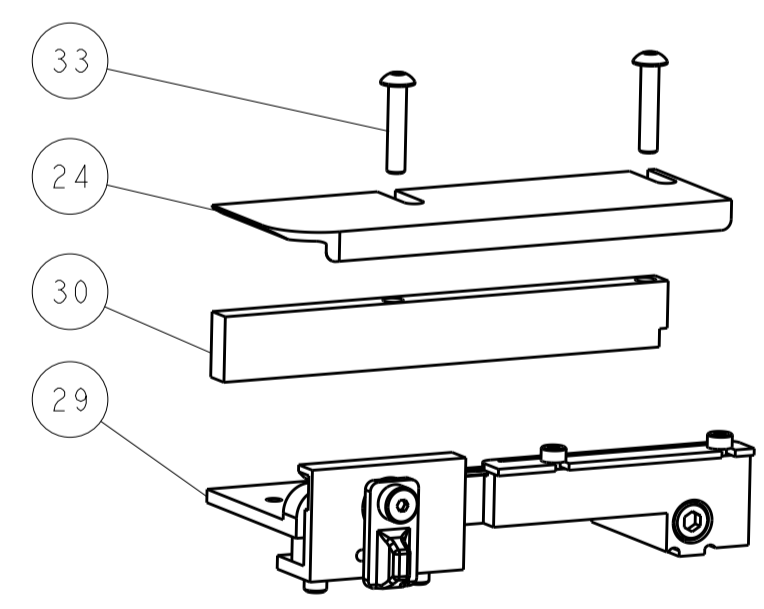
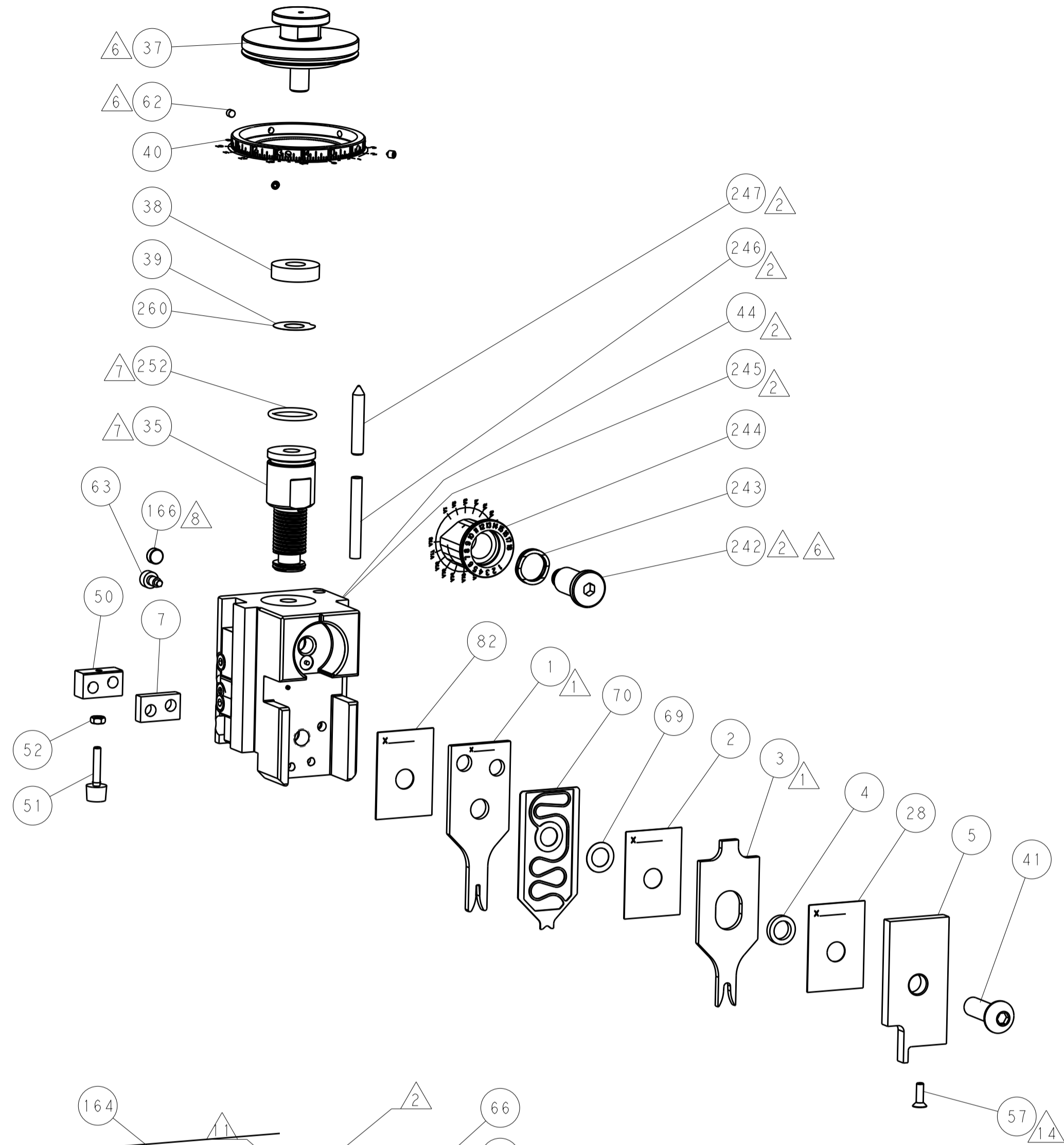
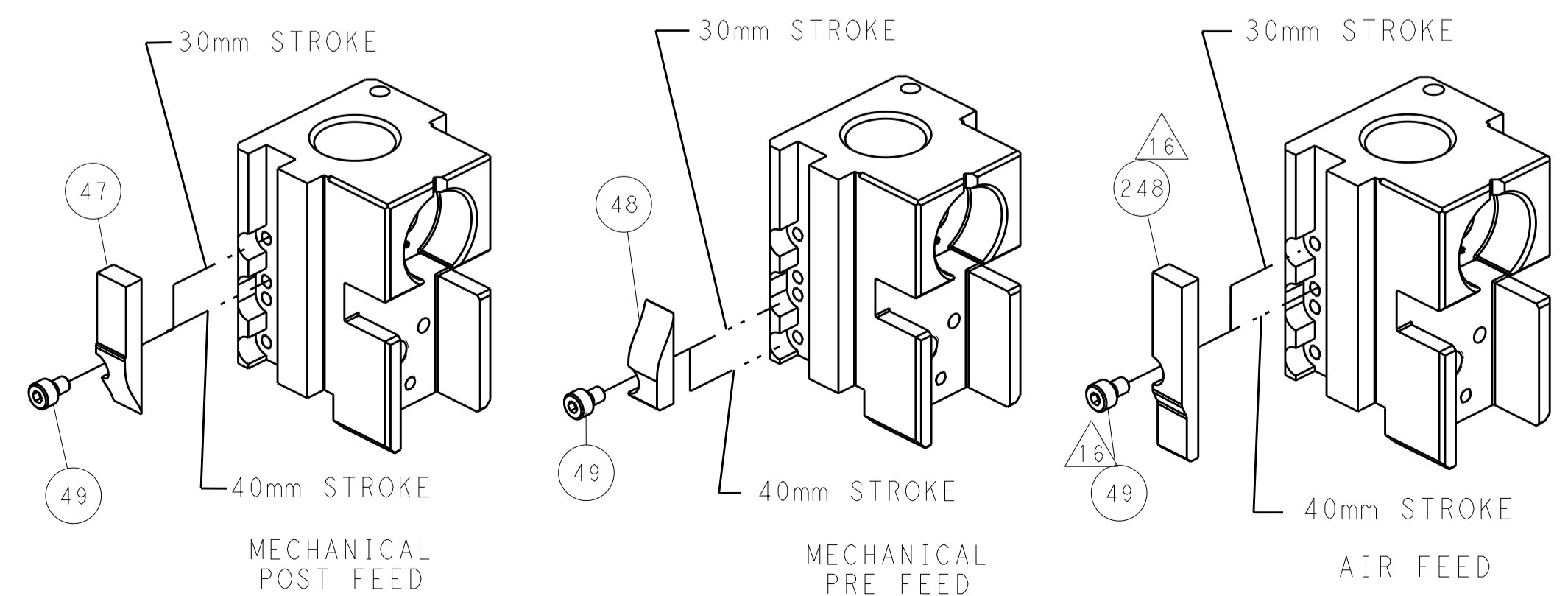
SERVO LATCH PLATE



DOUBLE ACTING PNEUMATIC WITH SENSORS



CAM POSITIONS



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN BOB HIGMAN 02APR2012 CHK T. ELBIN 02APR2012 APVD M. CLIFFORD 02APR2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151477 SCALE 1:2 SHEET 2 OF 4 REV H2	
MATERIAL FINISH				TE Connectivity Harrisburg, PA 17105-3608			

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
	2-2151477-1	H	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	-	8-2151477-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2151477-4	-	-	-	
					DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	
					SERVO LATCH PLATE	2119951-1	-	8-2151477-5	1901094-3	-	2168400-6 (QUANTITY 2)	
	2-2151477-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SMART APPLICATOR	2161326-1	-	8-2151477-4	-	-	-	-
					DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	
					SERVO LATCH PLATE	2119951-1	-	8-2151477-5	1901094-3	-	2168400-6 (QUANTITY 2)	
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					DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1	
2-2151477-5	H	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	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		
				DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1		
2-2151477-7	H	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-		
				-	-	-	-	-	-	-		
4-2151477-2	H	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	2168400-6 (QUANTITY 2)		
				PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1		
				SERVO LATCH PLATE	2119951-1	-	8-2151477-5	1901094-3	-	2168400-6 (QUANTITY 2)		
7-2151477-7	A		CRIMP TOOLING KIT	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.18 mm [.125]	O

APPLICATOR INSTRUCTIONS 408-10389

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TERMINAL NAME: TAB CONTACT 1.2MM			
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3.30-3.90 mm [.130-.154 IN]			
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1718760-1	1718760-2	967067-1	963142-2
1718760-3			
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
0.75mm2	1.05+/-0.03 [.041+/-0.001]	5.9	
20 AWG OR 0.50mm2	0.93+/-0.03 [.037+/-0.001]	7.2	

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TERMINALS APPLIED			
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2141116-3			
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
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3.30-3.90 mm [.130-.154 IN]			
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1718760-1	1718760-2	1718760-3	967067-1
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
20 AWG (19 / 0.203 mm)	0.99+/-0.03 [.039+/-0.001]	6.7	
0.61mm2	0.99+/-0.03 [.039+/-0.001]	6.7	

- 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: 8-2151477-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151477-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151477-5
- 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 ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- 8 MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. SEAL P/N 967067-1 INS. DIA:1.4-2.1mm. SEAL P/N 963142-2 INS. DIA:0.9-1.3mm.
- 13 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.

THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.

***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.

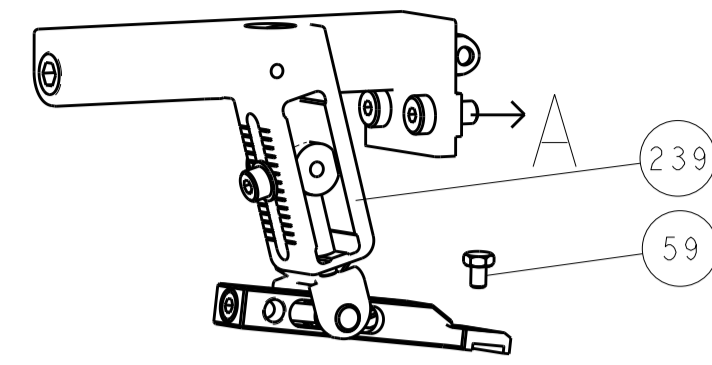
-	1	-	-	-	-	1803430-1	AIR FEED MODULE	290
-	1	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-77	-42	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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

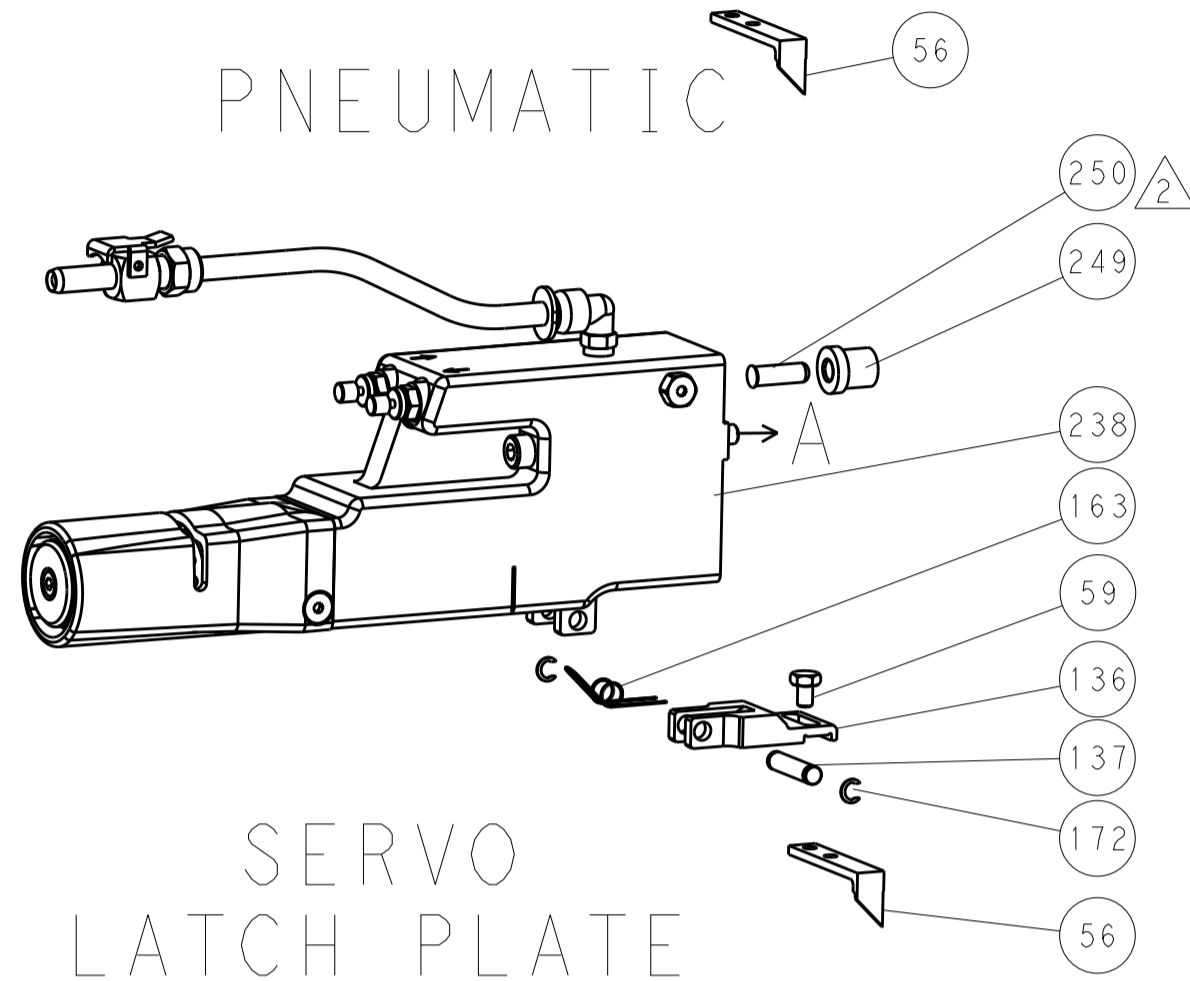
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	P	L	M	A
			DESCRIPTION	DATE	OWN	APVD
			SEE SHEET 1			

-	1	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	1	2119082-9	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	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
-	2	-	-	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	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	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	1	2119798-2	DETENT PIN	145
-	1	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	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	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	1	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	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	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	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	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	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	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	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-6	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	7-1333201-4	ANVIL, COMBINATION	8
-	1	1	1	1	1	5-240641-0	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1			

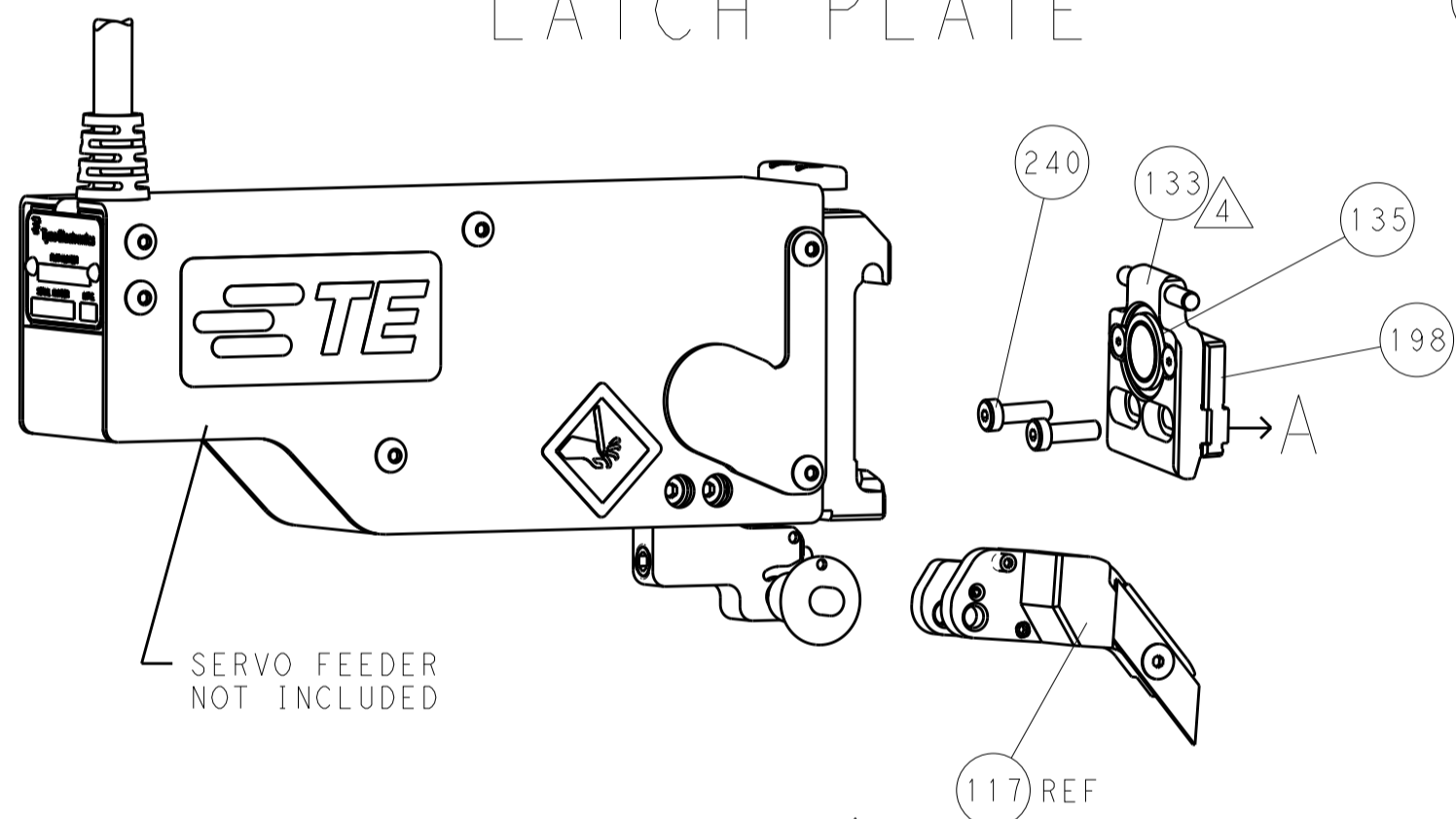
FEED TYPE MECHANICAL



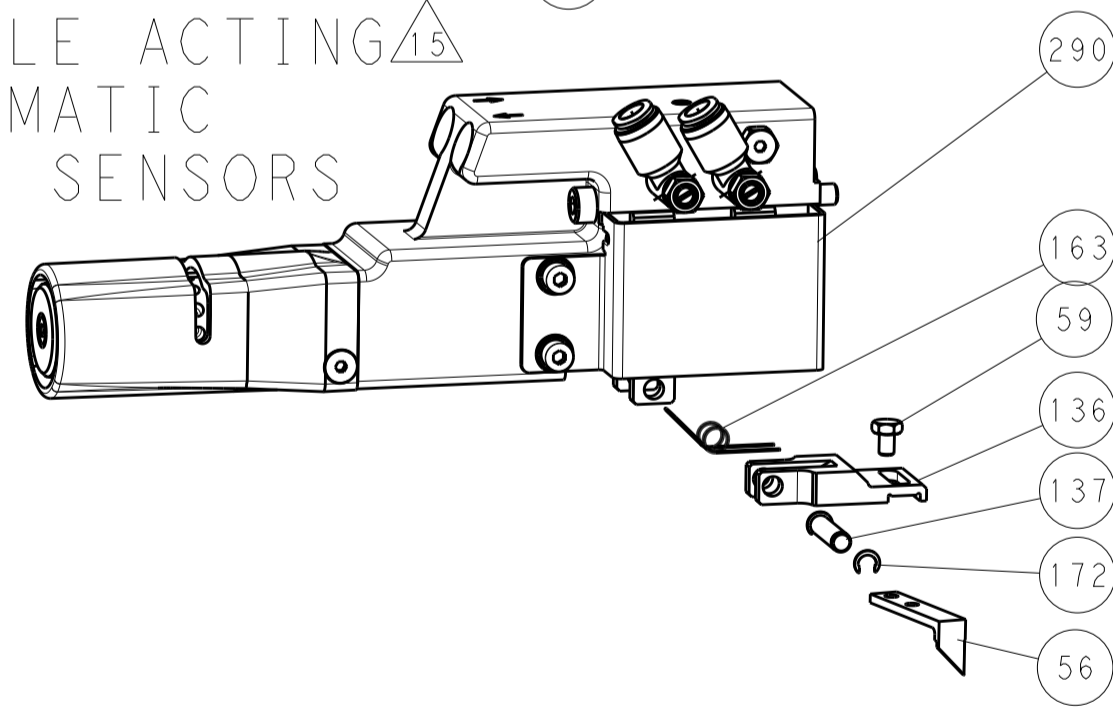
PNEUMATIC



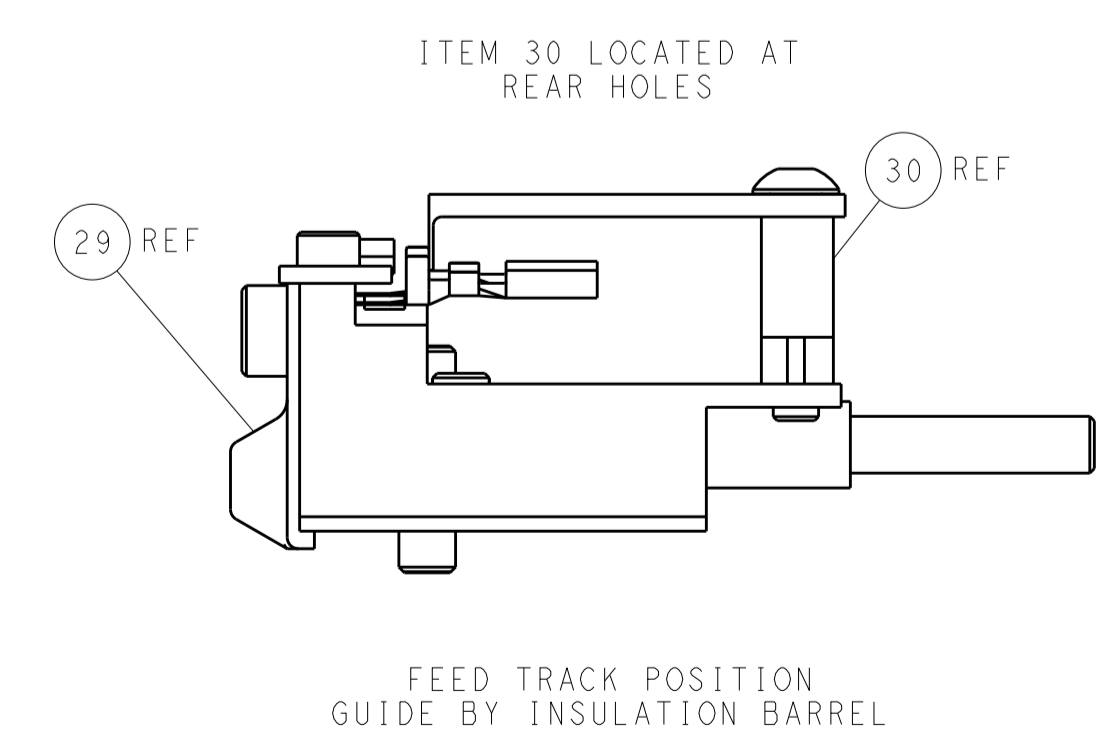
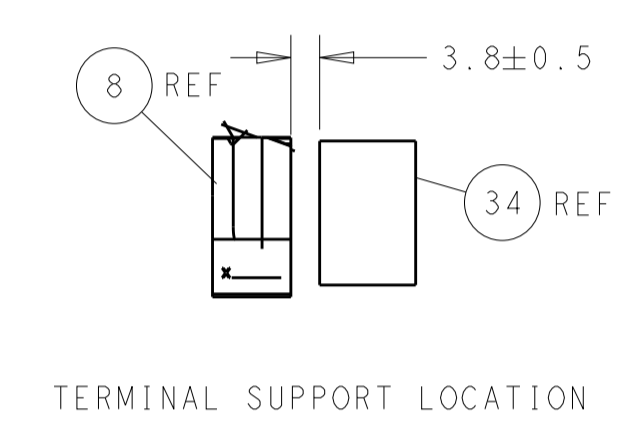
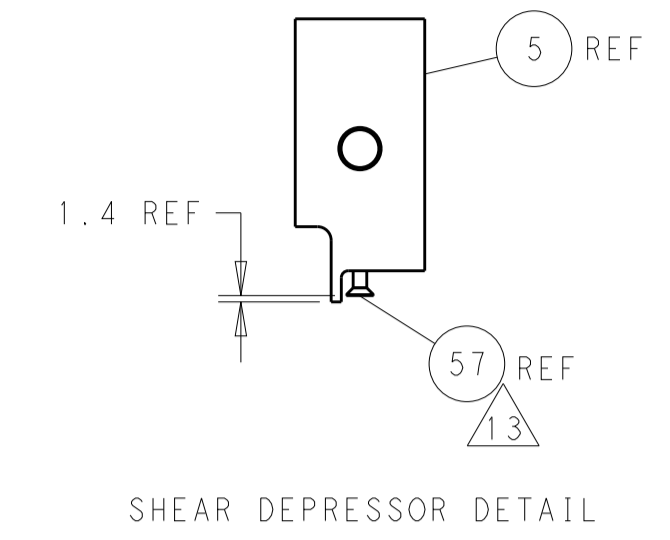
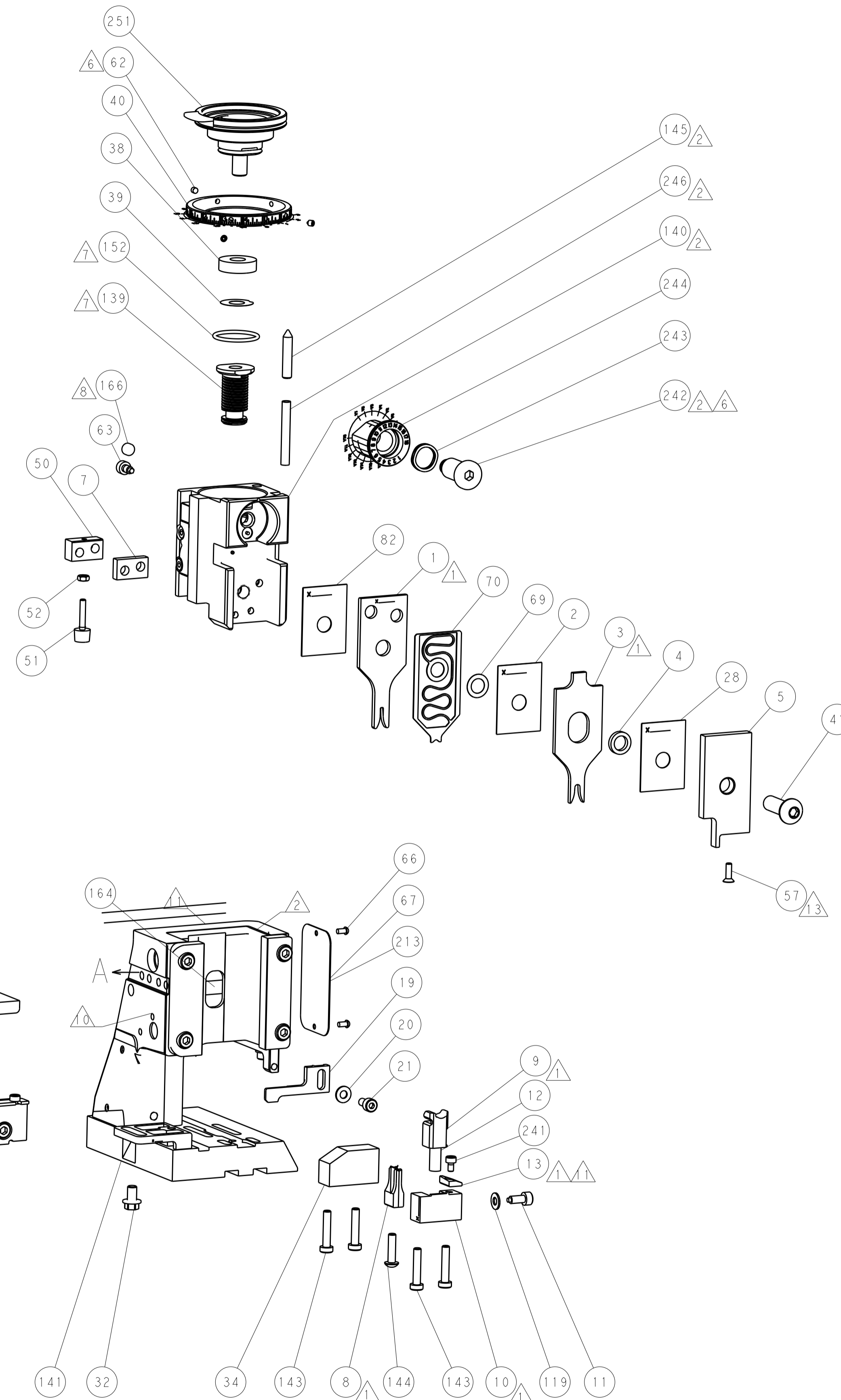
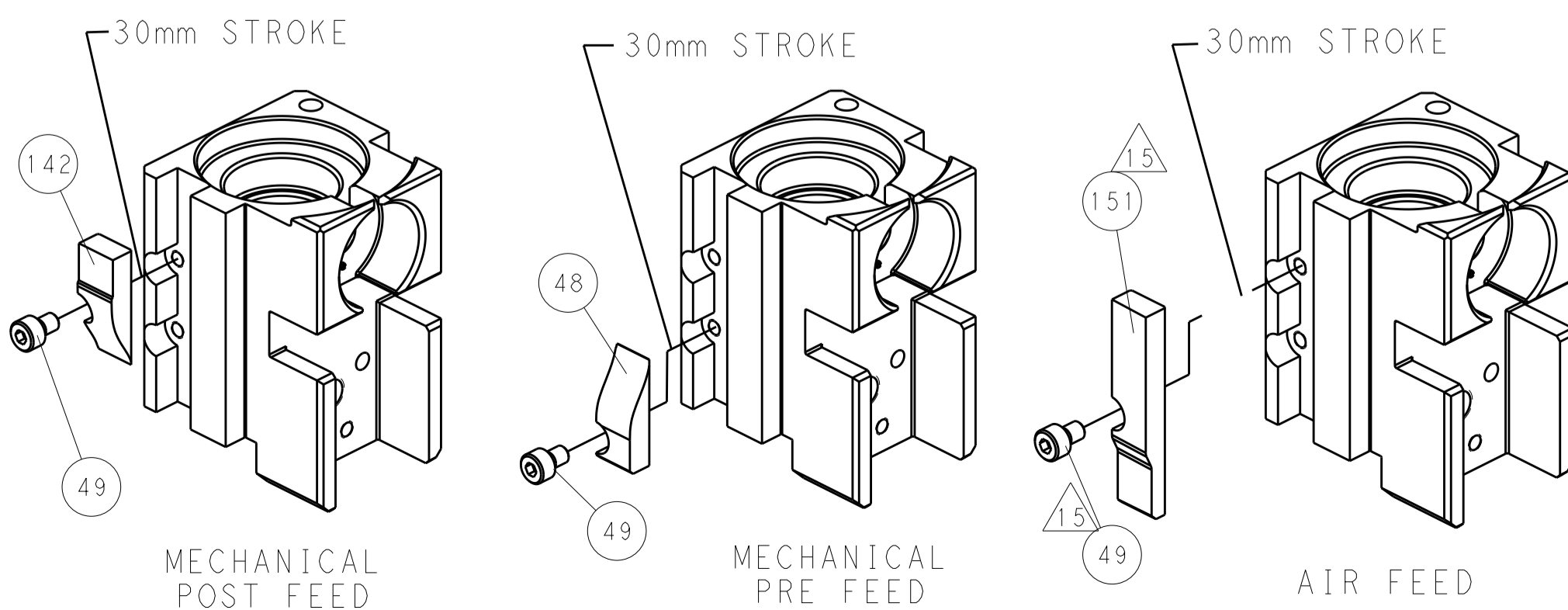
SERVO LATCH PLATE



DOUBLE ACTING PNEUMATIC WITH SENSORS



CAM POSITIONS



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

LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB_HIGMAN 02APR2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: T.ELBIN 02APR2012		NAME: Ocean Side Feed Applicator	
				APVD: M.CLEFFORD 02APR2012		SIZE: CAGE CODE DRAWING NO: A1 00779 ©=2151477	
				PRODUCT SPEC:		RESTRICTED TO:	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2 SHEET 4 OF 4 REV: H2	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION