

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151138-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151138-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
2151138-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE
2151138-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE
2151138-7	C	FINE CRIMP HEIGHT ADJUST	NONE
7-2151138-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA

CRIMP SIZE	TYPE
WIRE 1.40 mm [.055]	F
INSUL 1.78 mm [.070]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170376-1	170376-2	170376-3	170376-4
170262-1	170262-2	170262-3	170262-4
170262-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	0.88+/-0.05 [.035+/- .002]	8.2
22 AWG OR 0.30mm2	0.81+/-0.05 [.032+/- .002]	8.9
24 AWG OR 0.20mm2	0.71+/-0.05 [.028+/- .002]	9.9
26 AWG OR 0.13mm2	0.71+/-0.05 [.028+/- .002]	9.9

- 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: 8-2151138-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151138-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151138-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151138-6
- 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 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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.
- 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

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	-	8-2151138-5	1901094-3	-	2168400-6 (QUANTITY 2)	
SMART APPLICATOR	2161326-1	-	8-2151138-4	-	-	-	
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
SERVO LATCH PLATE	2119951-1	-	8-2151138-5	1901094-3	-	2168400-6 (QUANTITY 2)	
SMART APPLICATOR	2161326-1	-	8-2151138-4	-	-	-	
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	
-	-	-	-	-	-	-	
-	-	-	-	-	-	-	
-	-	-	-	-	-	-	
-	-	-	-	-	-	-	

P	LTM	DESCRIPTION	DATE	OWN	APVD			
		ECR-15-002729	18FEB2015	MR	JT			
-	-	-	-	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	2119082-5	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
-	1	1	1	1	1	455053-2	PLATE, RETAINING	180
-	1	1	1	1	1	4-21028-0	PIN, SLOTTED SPRING .094 X .750	177
-	2	2	2	2	2	1-22278-0	SPRING, COMPRESSION	176
-	1	1	1	1	1	1803129-1	PLATE, RETAINER	175
-	-	-	-	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	455888-5	SPACER, CRIMPER	82
-	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	53
-	1	1	1	1	1	18031-1	SCR, SET, CUP POINT M3 X 5.0	52
-	1	1	1	1	1	1424303-3	HOLDER, TERMINAL	51
-	1	1	1	1	1	455052-3	CARRIER, 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	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	1752356-3	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	2119533-3	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	1333201-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1-238011-3	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1-2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1	1	2-456402-4	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

*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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	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

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

TE Connectivity
Harrisburg, PA 17105-3608

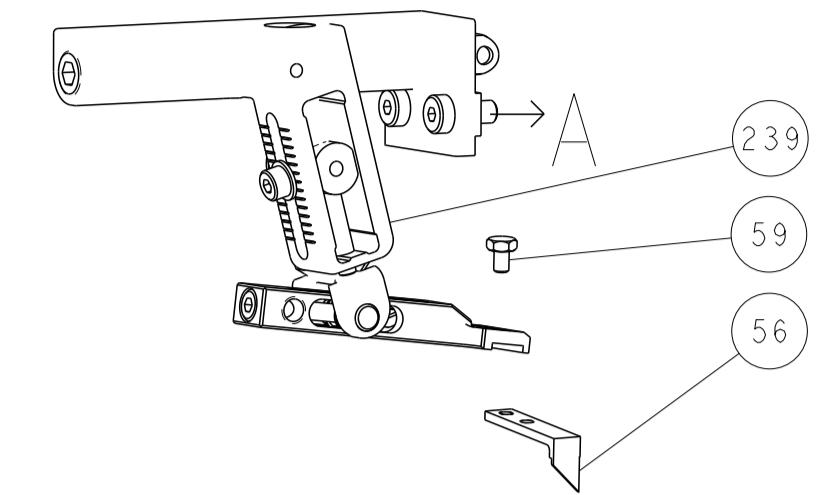
Ocean Side Feed Applicator

STANDARD DIMENSIONS: mm PLC ±.05 2 PLC ±.03 3 PLC ±.013 4 PLC ±.0091 ANGLES ±.0001 FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: ±.05 ±.03 ±.013 ±.0091	OWN: Y. YIN CHK: G. BAILEY APVD: S. XI PRODUCT SPEC: APPLICATION SPEC: MATERIAL: WEIGHT: SCALE: 1:2 SHEET 1 OF 4	DATE: 07SEP2011 DATE: 07SEP2011
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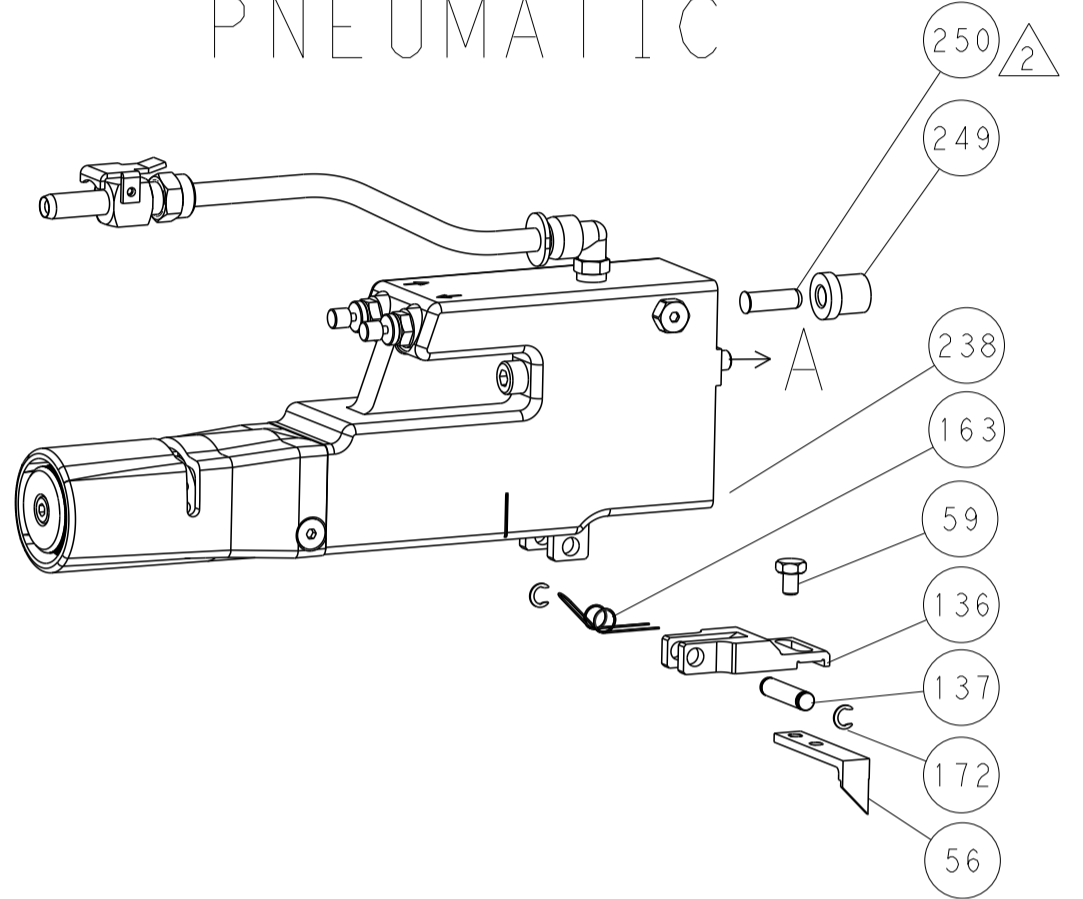
Customer Accessible Production Drawing

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

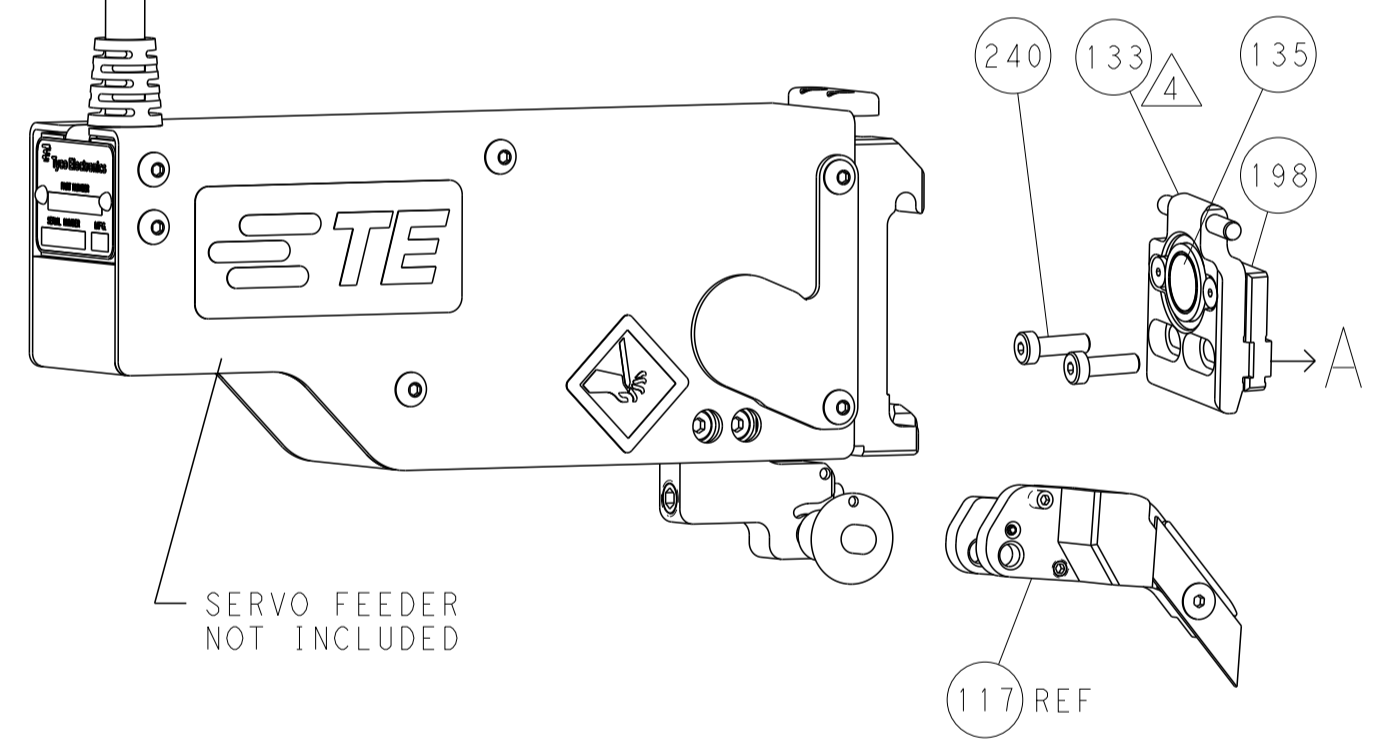
FEED TYPE MECHANICAL



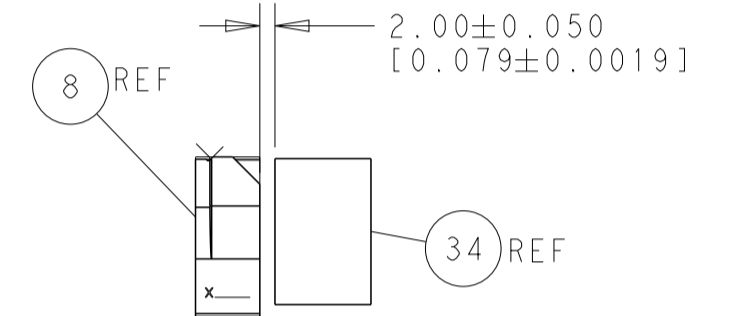
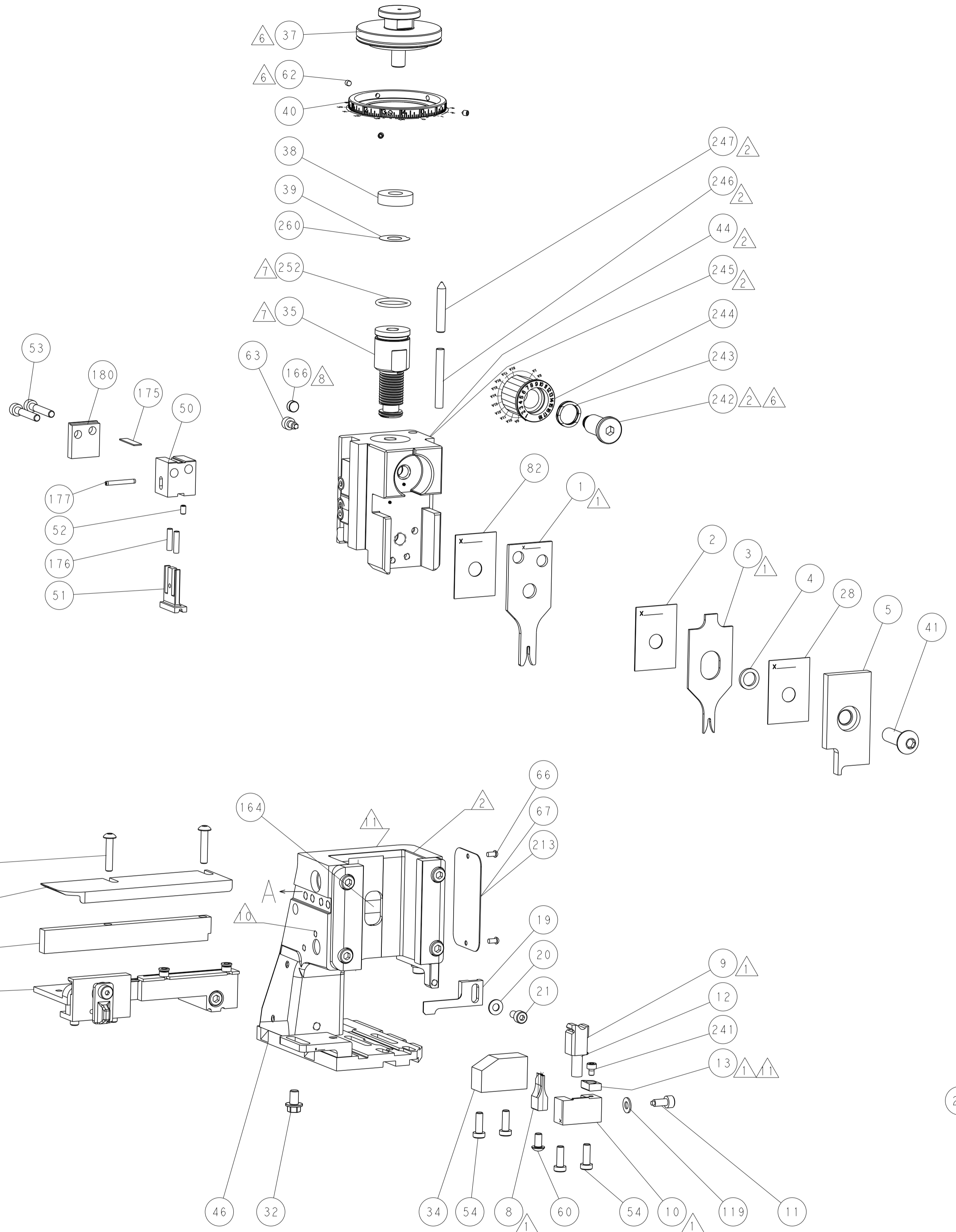
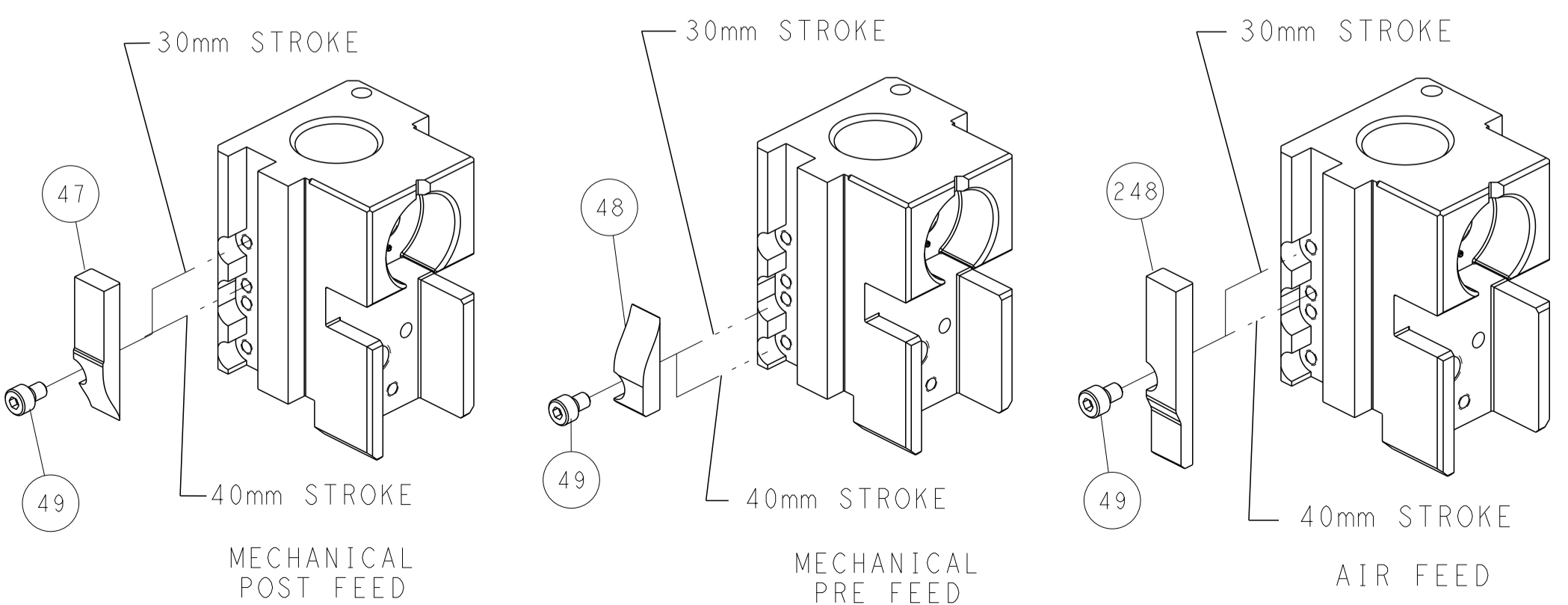
PNEUMATIC



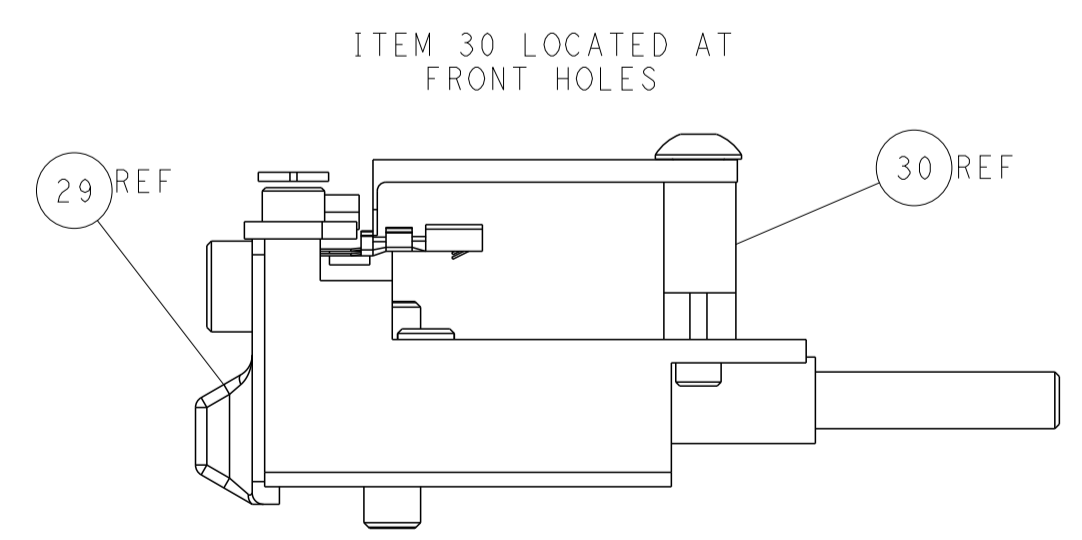
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN Y. YIN 07SEP2011	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		CHK G. BAILEY 07SEP2011	NAME Ocean Side Feed Applicator
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.0001		APVD S. XI 07SEP2011	PRODUCT SPEC APPLICATION SPEC
MATERIAL: .		WEIGHT .	SIZE A1 CAGE CODE 00779 DRAWING NO C=2151138
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2	SHEET 2 OF 4 REV C

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Table: APPLICATOR STYLE CONVERSION CHART. Columns: CONVERT TO, PART NUMBERS REQUIRED. Rows: PNEUMATIC FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, etc.

Table: APPLICATOR DATA. Columns: CRIMP, SIZE, TYPE. Rows: WIRE, INSUL, APPLICATOR INSTRUCTIONS.

Table: TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED.

Table: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Rows: 20 AWG OR 0.50mm2, 22 AWG OR 0.30mm2, etc.

- 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...

*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.

Table: Conversion table for PART NO and DESCRIPTION. Rows: 1-1, 1-1, 1-1, 1-1, 1-1, 1-1.

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

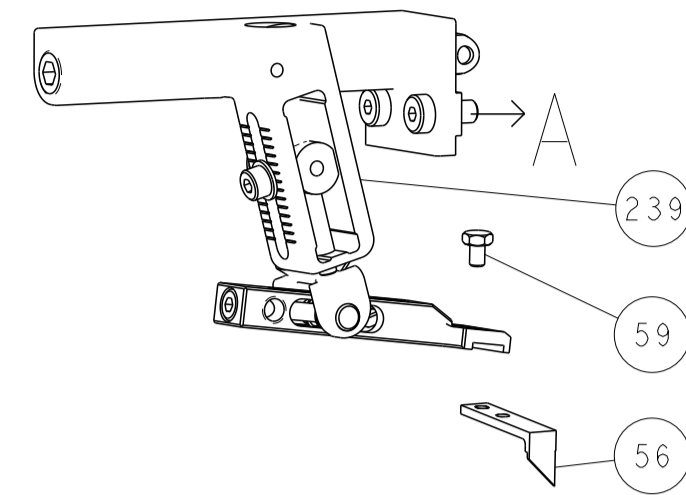
Table: REVISIONS. Columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Row: SEE SHEET 1.

Table: BOM/Parts List. Columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Rows: 2079988-1 BUSHING, LCH5-12, MISUMI, 1-22279-3 SPRING, COMPRESSION, etc.

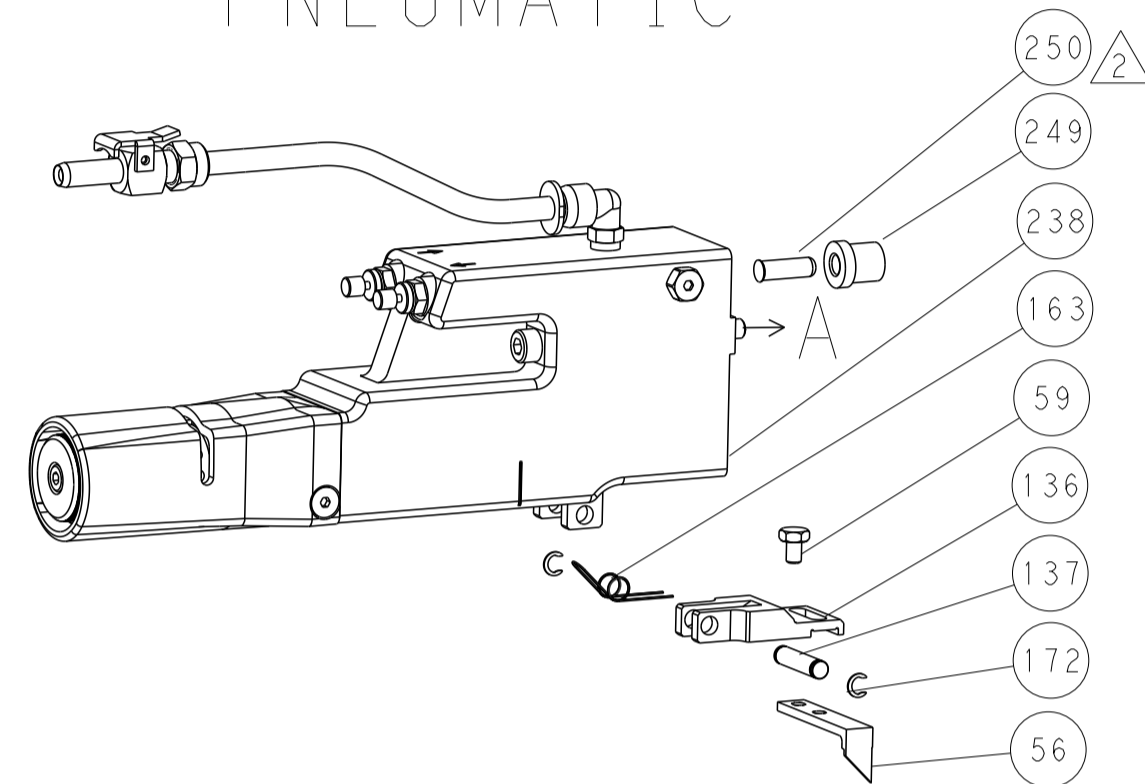
Table: DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE, SHEET 3 OF 4, REV C.

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

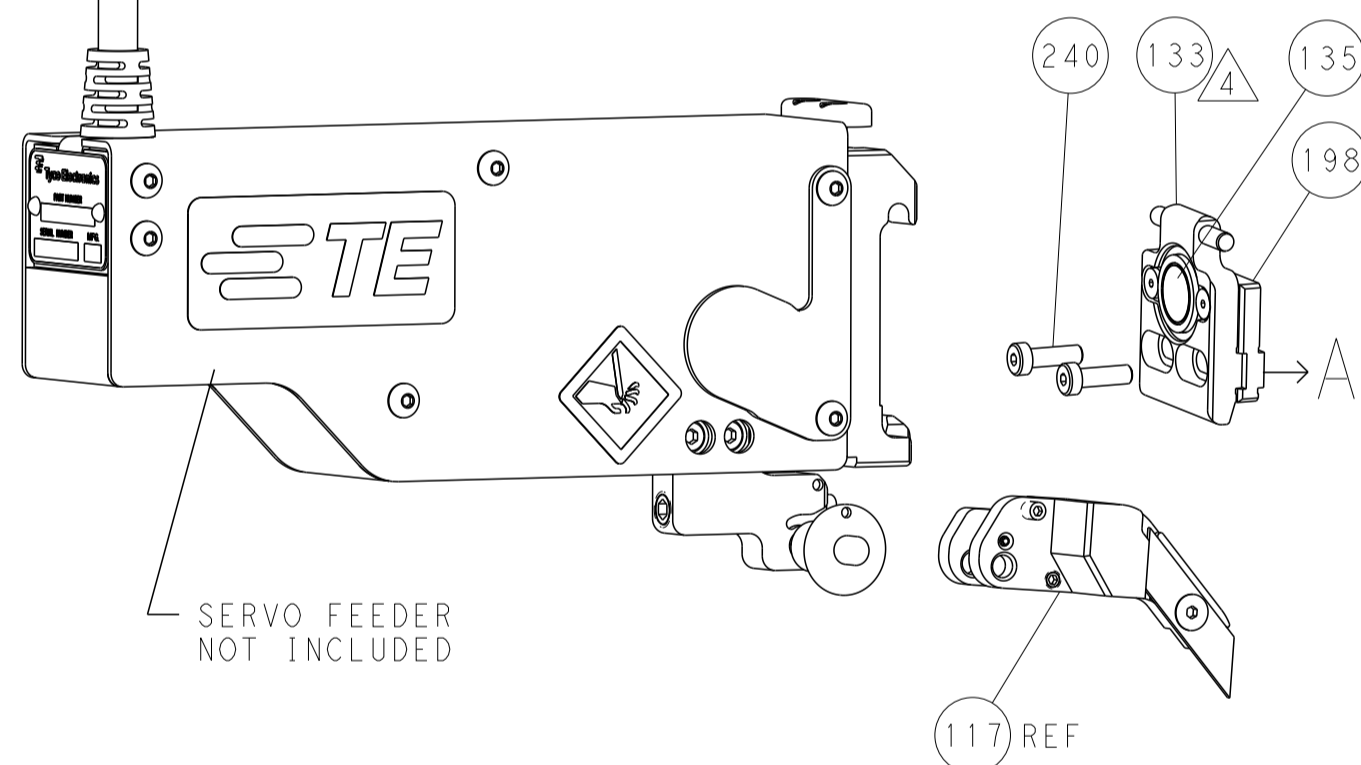
FEED TYPE MECHANICAL



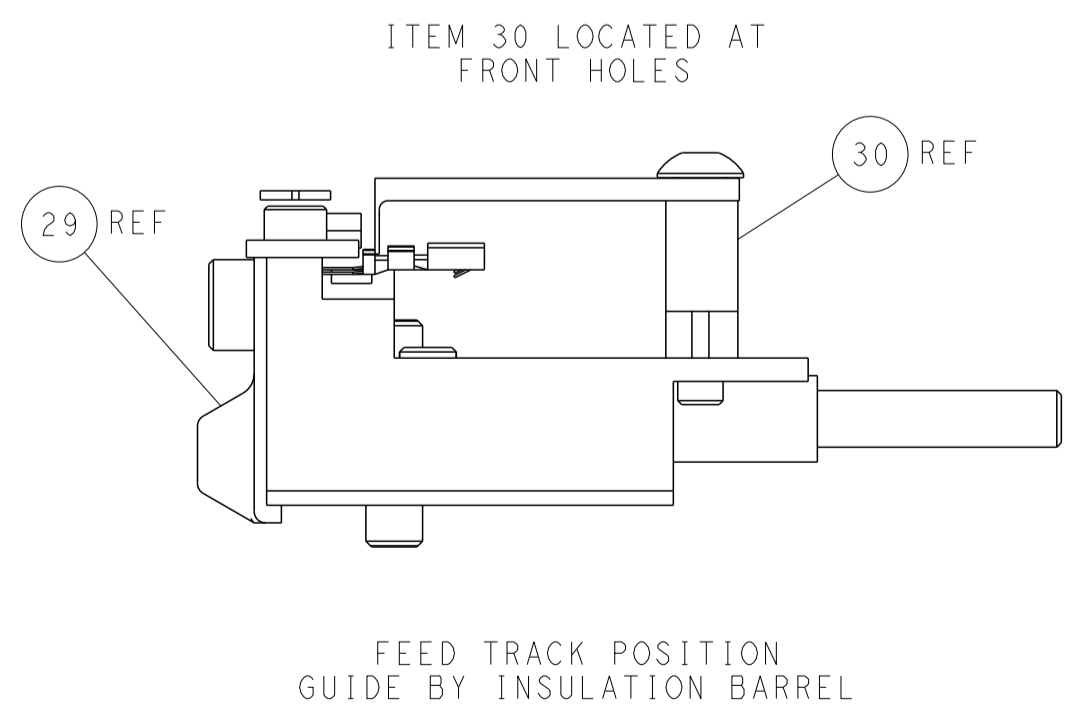
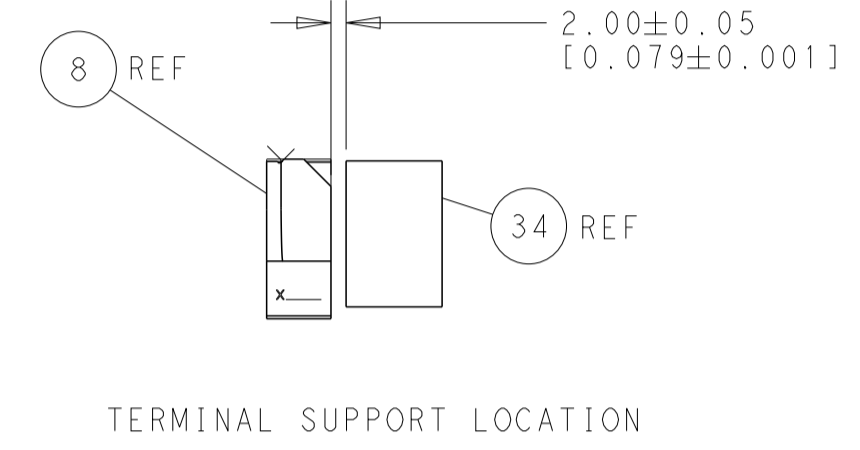
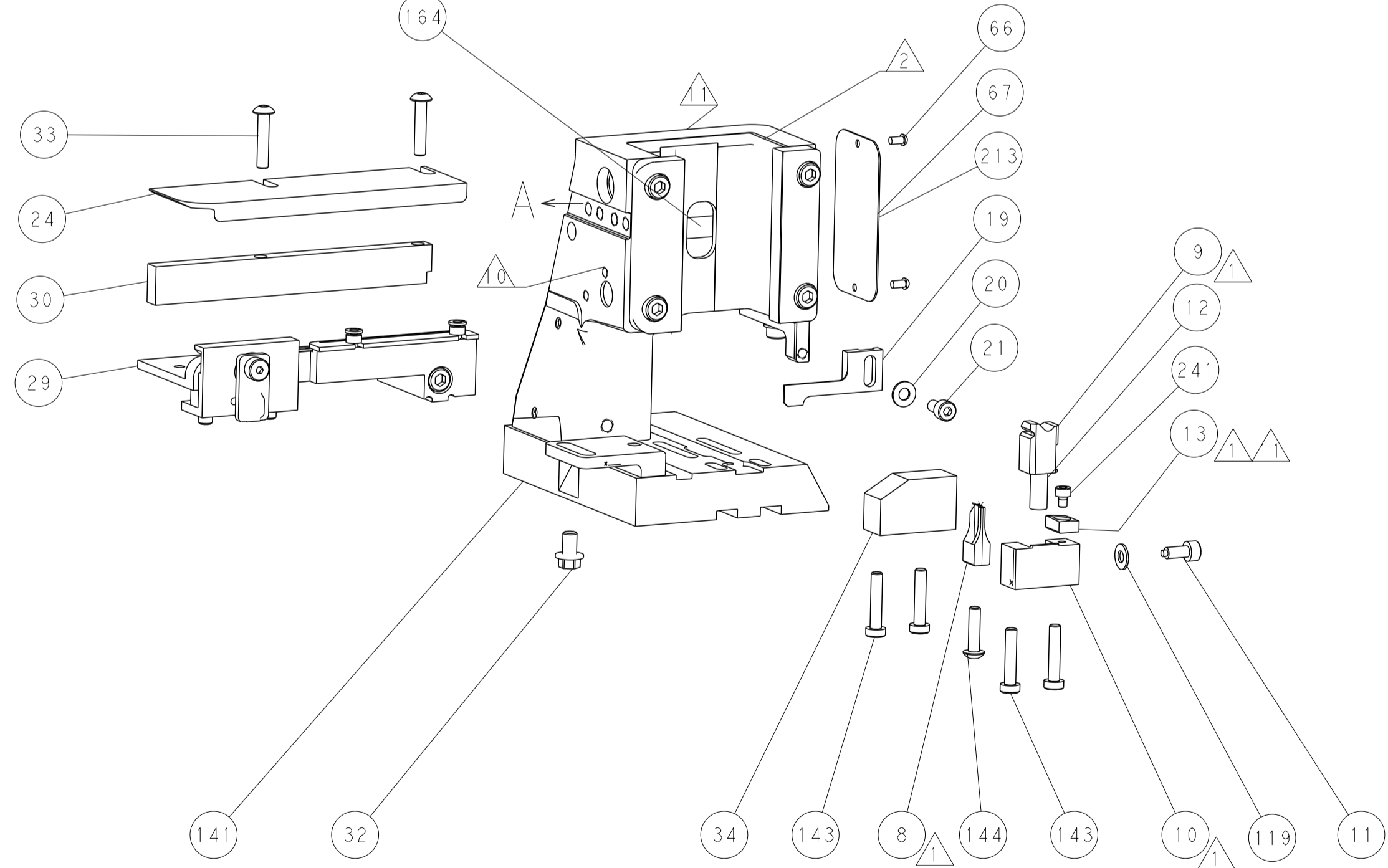
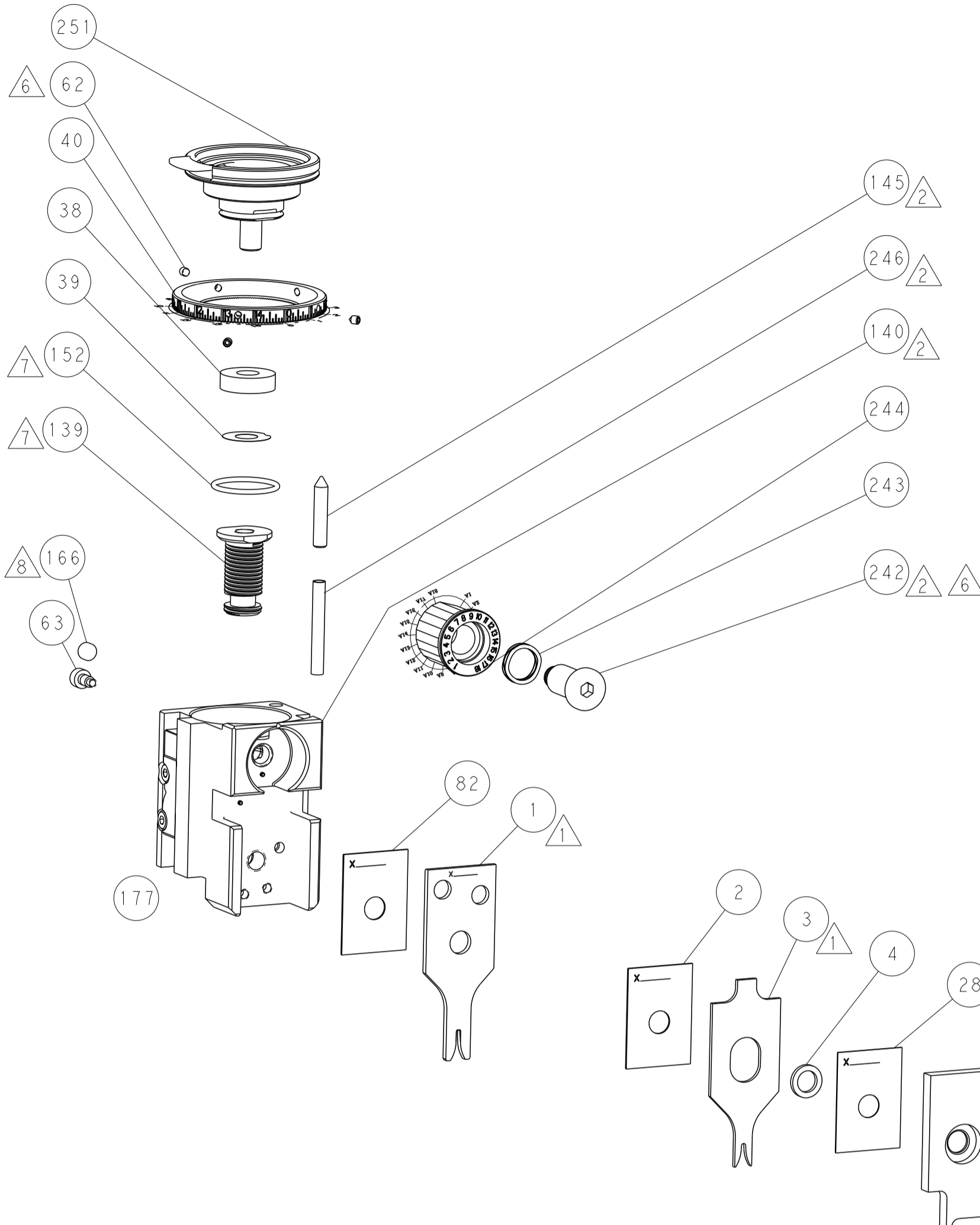
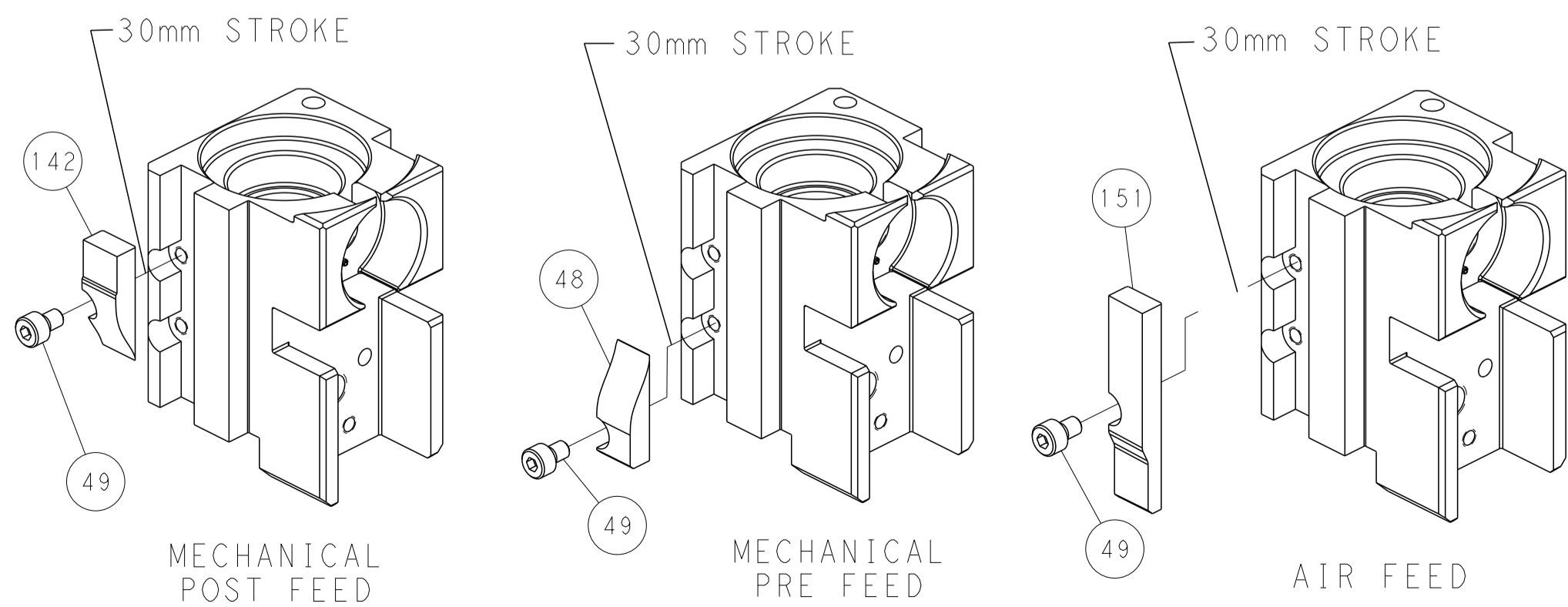
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 07SEP2011		STE TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	4 PLC ±0.001	5 PLC ±0.001	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK G. BAILEY 07SEP2011		NAME Ocean Side Feed Applicator	
				S. XI 07SEP2011		RESTRICTED TO	
				APVD		SIZE CAGE CODE DRAWING NO	
				PRODUCT SPEC		A 00779 C=2151138	
				APPLICATION SPEC		SCALE 1:2 SHEET 4 OF 4 REV C	
				WEIGHT		Customer Accessible Production Drawing	