

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. 20

COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

SET UP GAUGE 2119599-1			LOC A	DIST 66	REVISIONS		
P	LTN	DESCRIPTION	DATE	OWN	APPV		
A		RELEASED	18MAR2013	CC	TE		

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151860-1	A	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	-	8-2151860-5	1901094-3	1-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151860-4	-	-	-
	2151860-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151860-5	1901094-3	1-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151860-4	-	-	-
	2151860-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	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	
2151860-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
				-	-	-	-	-	-	-	
2151860-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
				-	-	-	-	-	-	-	
7-2151860-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA

CRIMP WIRE	SIZE	TYPE
WIRE	2.12 mm [.083]	F
INSUL	2.54 mm [1.00]	OV

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: FCI TERMINAL FCI CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH 4.62-5.38 mm [1.82-.212 IN]	INSULATION DIAMETER RANGE Ø1.30-2.10 mm [.051-.083 IN]
TERMINAL APPLICATION SPECIFICATION	FCI SPEC
TERMINALS APPLIED	

TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
286964-1	211CL2S1120	286964-2	211CL2S1230

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.28 +/- 0.04 [.050 +/- .002]	4.2
0.35+0.35mm2	1.27 +/- 0.04 [.050 +/- .002]	4.4
0.60mm2	1.25 +/- 0.04 [.049 +/- .002]	4.5
0.50mm2	1.22 +/- 0.04 [.048 +/- .002]	4.7
0.35mm2	1.18 +/- 0.04 [.046 +/- .002]	4.9

- 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: 8-2151860-4
  - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151860-4
  - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151860-5
  - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151860-6
- 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, 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.52.

\*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.

- 2 2 2 2 2 2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	269
- 2 2 2 2 2 2	22283-1	SPRING, COMPRESSION	268
- 1 1 1 1 1 1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	267
- 1 1 1 1 1 1	356835-1	LEVER, DRAG RELEASE	266
- 1 1 1 1 1 1	240792-1	DRAG, TERMINAL	265
- 2 2 2 2 2 2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	264
- 1 1 1 1 1 1	1-690438-0	FRONT STRIP GUIDE	263
- 2 2 2 2 2 2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	262
- 1 1 1 1 1 1	1633782-3	FENCE	261
- - 1 - - -	2119957-2	APPLICATOR SHIM PACK	260
- 1 - 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 -7 -6 -5 -2 -1	PART NO	DESCRIPTION	ITEM NO

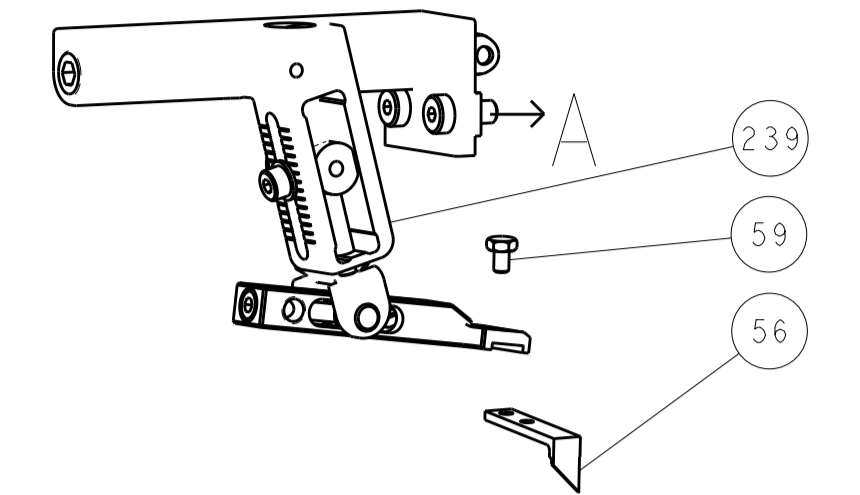
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

- 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	2119082-8	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	1-1752354-6	STANDOFF, HOLD-DOWN	180
- 1 1 1 1 1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
- 1 1 1 1 1	8-22280-7	SPRING, COMPRESSION	176
- 1 1 1 1 1	1752353-2	GUIDE PIN, HOLDDOWN	175
- 1 1 1 1 1	1901680-2	GUIDE PIN, HOLDDOWN	174
- - - - 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	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
- 1 1 1 1 1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
- 1 1 1 1 1	1901681-1	HOLDDOWN, TERMINAL	51
- - - - 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	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	1-1320908-2	SPACER, STRIP GUIDE	30
- 1 1 1 1 1	2119959-3	ASSEMBLY, STRIP GUIDE	29
- 1 1 1 1 1	1-455888-0	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	3-1633927-3	ANVIL, COMBINATION	8
- - - - -	-	-	7
- - - - -	-	-	6
- 1 1 1 1 1	2119757-8	DEPRESSOR, SHEAR	5
- 1 1 1 1 1	238011-4	BLOCK, CRIMPER SPACER	4
1 1 1 1 1 1	1633963-9	CRIMPER, INSULATION OVERLAP PREMIUM	3
- 1 1 1 1 1	455888-3	SPACER, CRIMPER	2
1 1 1 1 1 1	4-1633664-9	CRIMPER, WIRE	1
-77 -7 -6 -5 -2 -1	PART NO	DESCRIPTION	ITEM NO

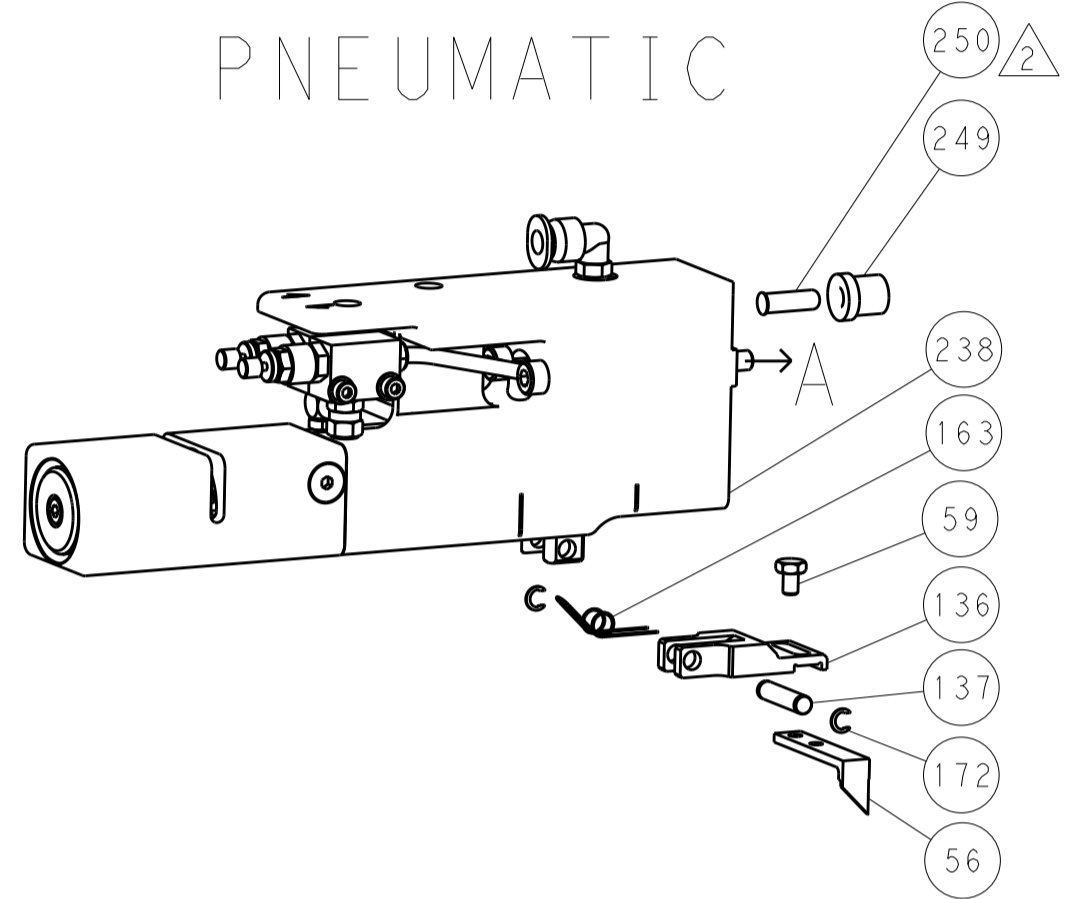
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. 20			OWN: C. CHEN 29 JAN 2013			S. XI 29 JAN 2013			
DIMENSIONS:						TOLERANCES UNLESS OTHERWISE SPECIFIED:			
mm						0 PLC ±	APPLICATOR SPEC		
						1 PLC ±0.1	REVISIONS		
MATERIAL:						2 PLC ±0.02	NAME: Ocean Side Feed Applicator		
						3 PLC ±0.005	SIZE: A1		
						4 PLC ±0.0005	CAGE CODE: 00779		
						ANGLES ±	DRAWING NO: 2151860		
						FINISH	SHEET 1 OF 4		
						WEIGHT	SCALE: 1:1		
						Customer Accessible Production Drawing	REV A		

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

### FEED TYPE MECHANICAL



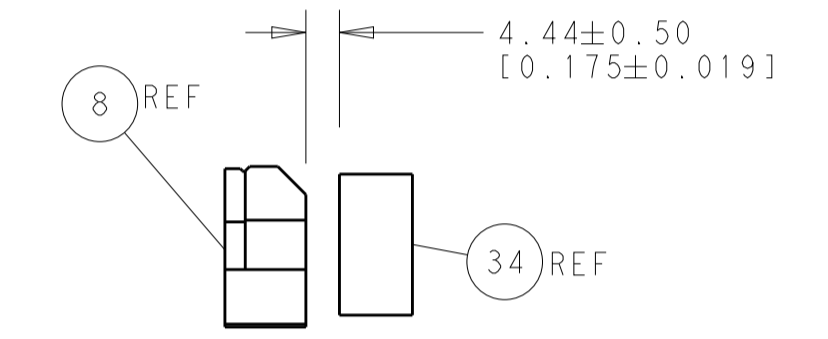
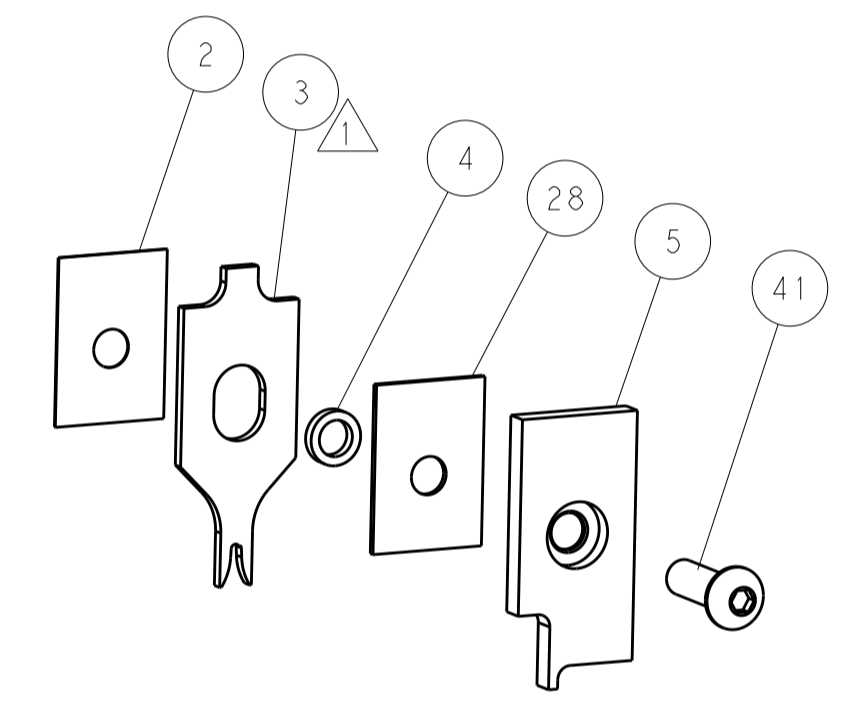
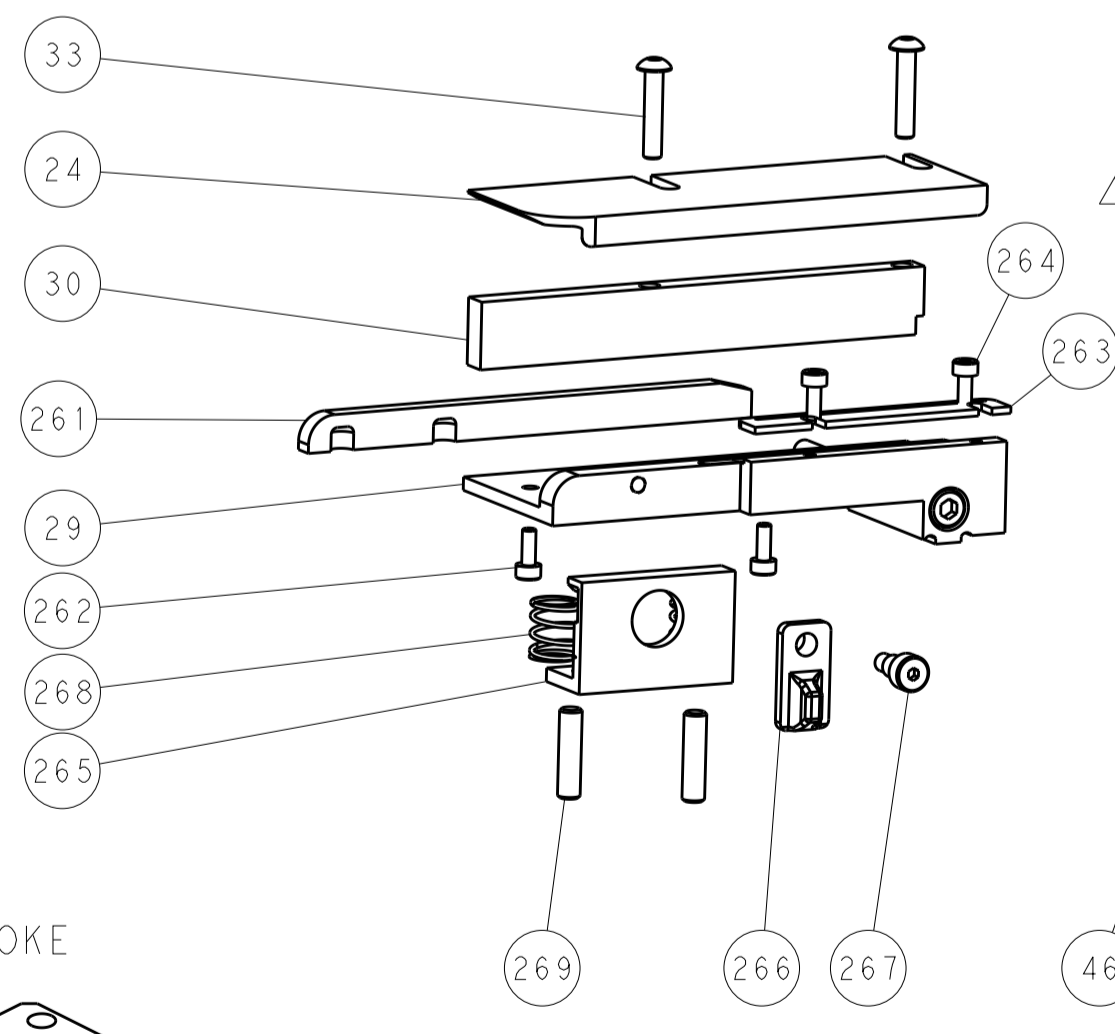
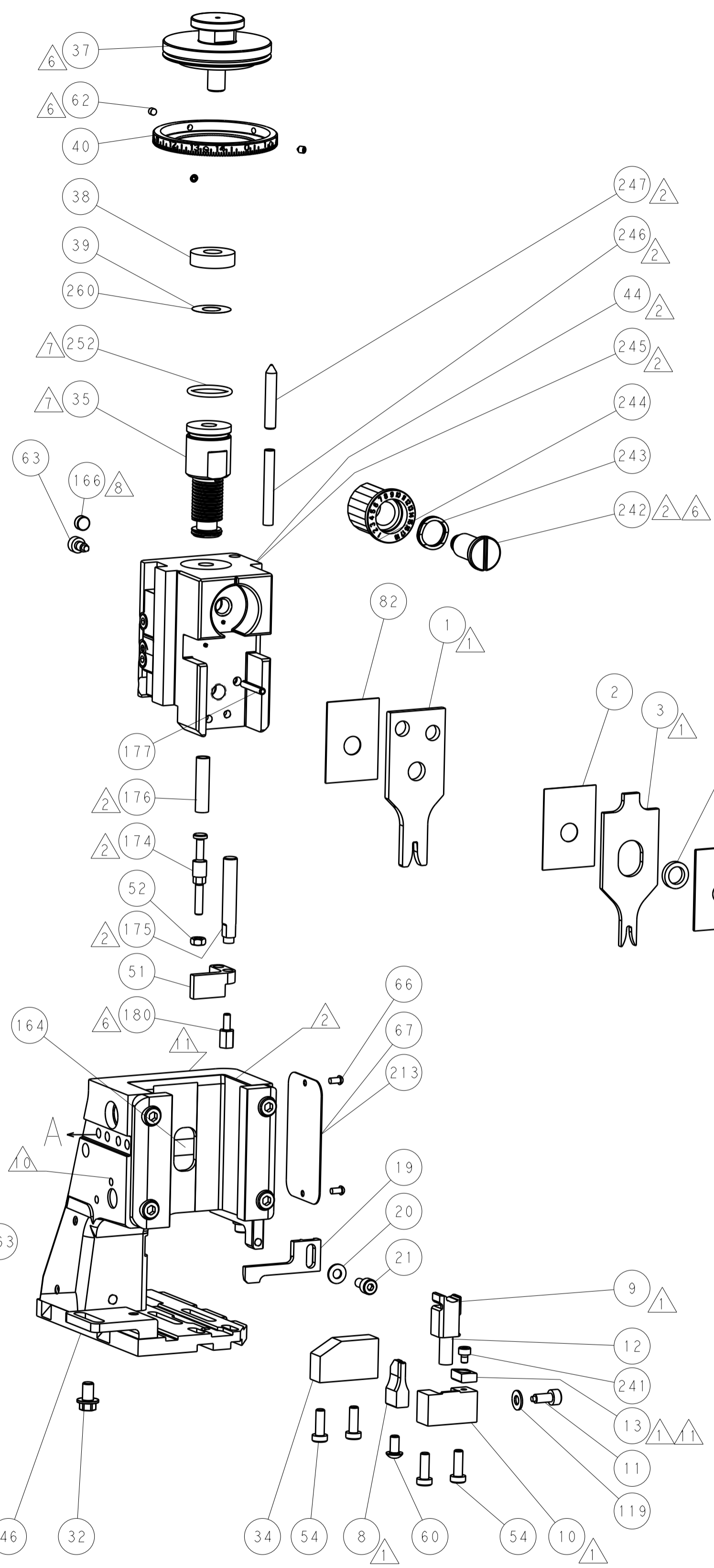
### PNEUMATIC



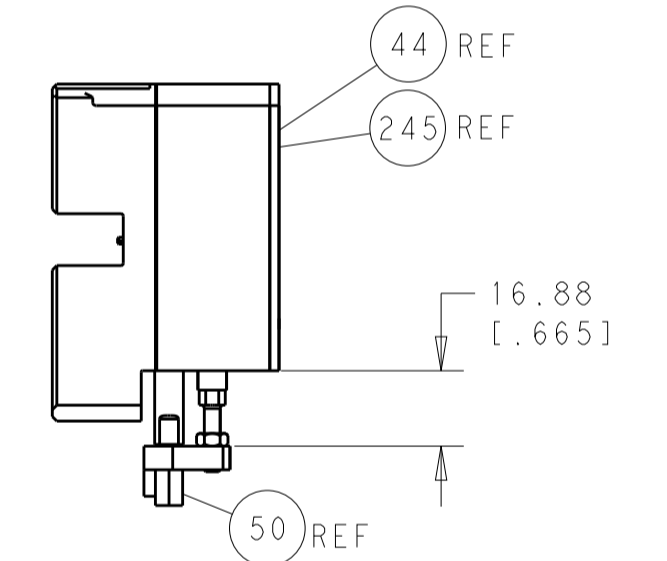
### SERVO LATCH PLATE



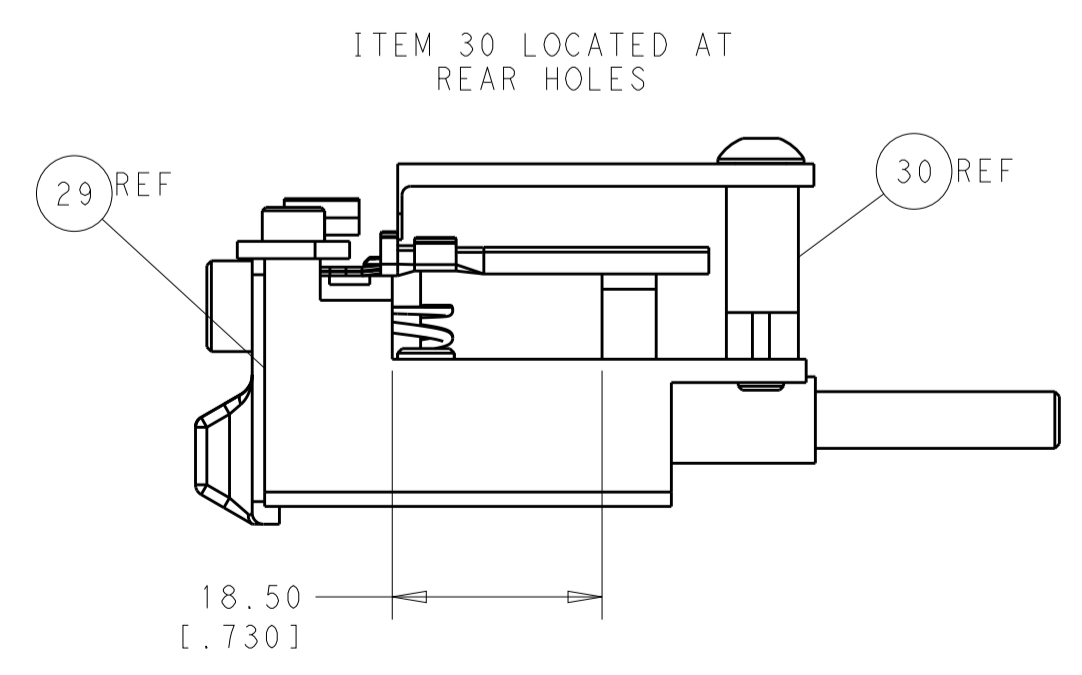
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



ITEM 30 LOCATED AT REAR HOLES

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)

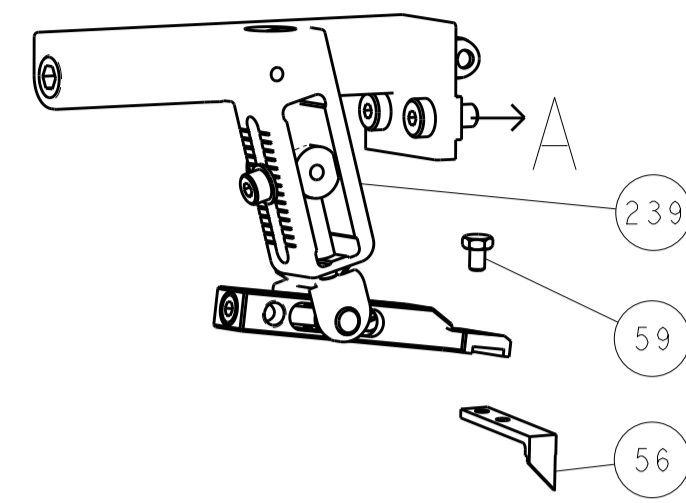
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: C. CHEN 29JAN2013		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	APVD: S. XI 29JAN2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME: Ocean Side Feed Applicator	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2151860	
				WEIGHT:		RESTRICTED TO:	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV A	



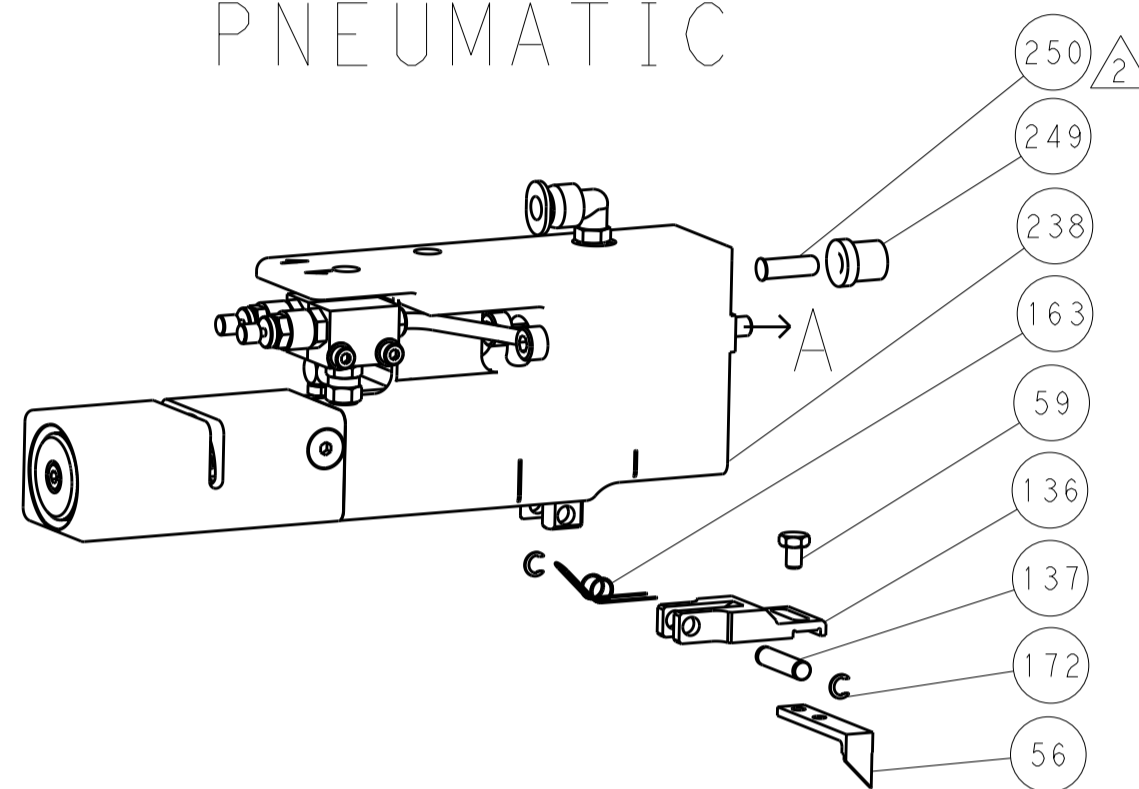
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

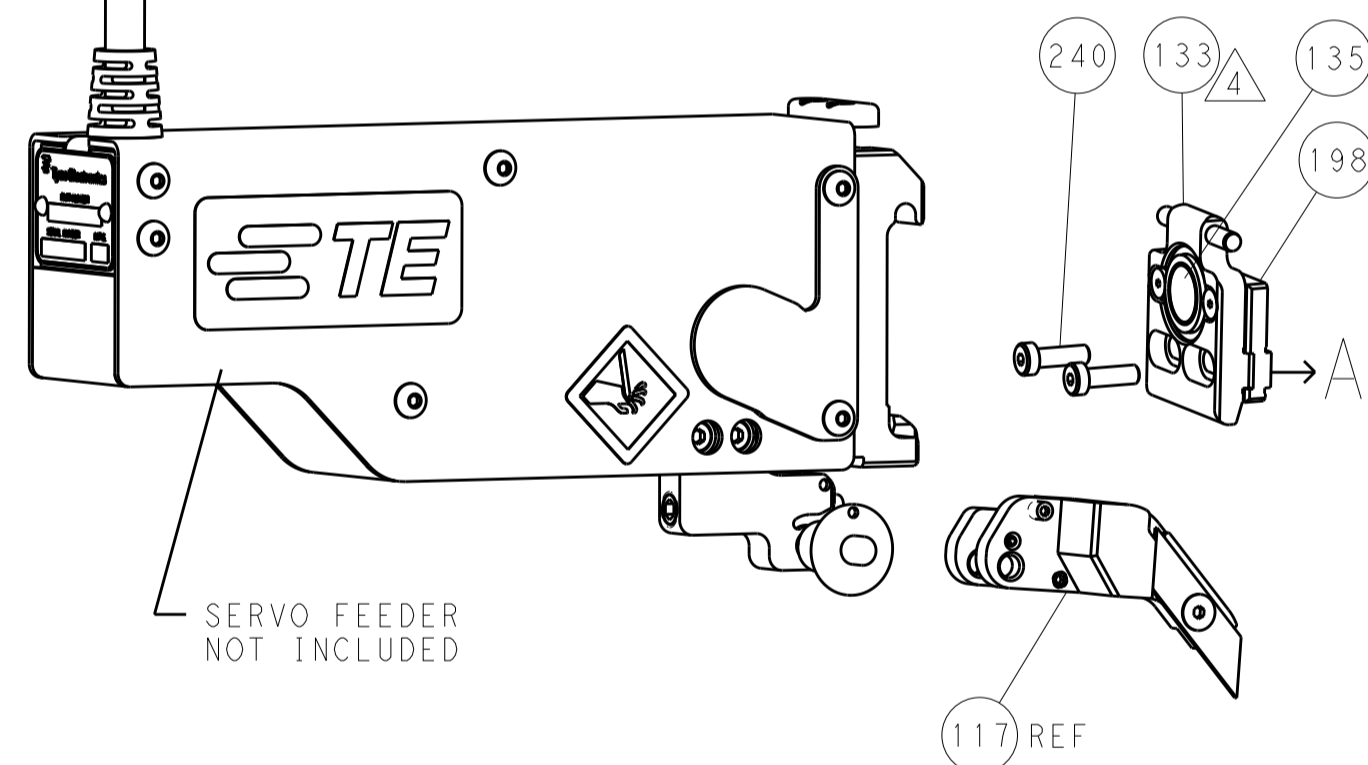
### FEED TYPE MECHANICAL



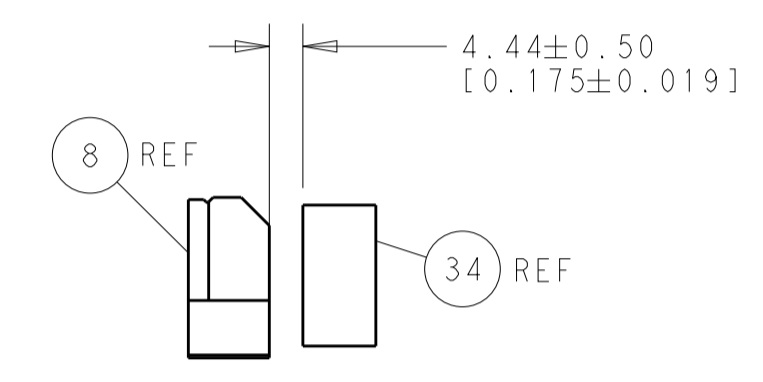
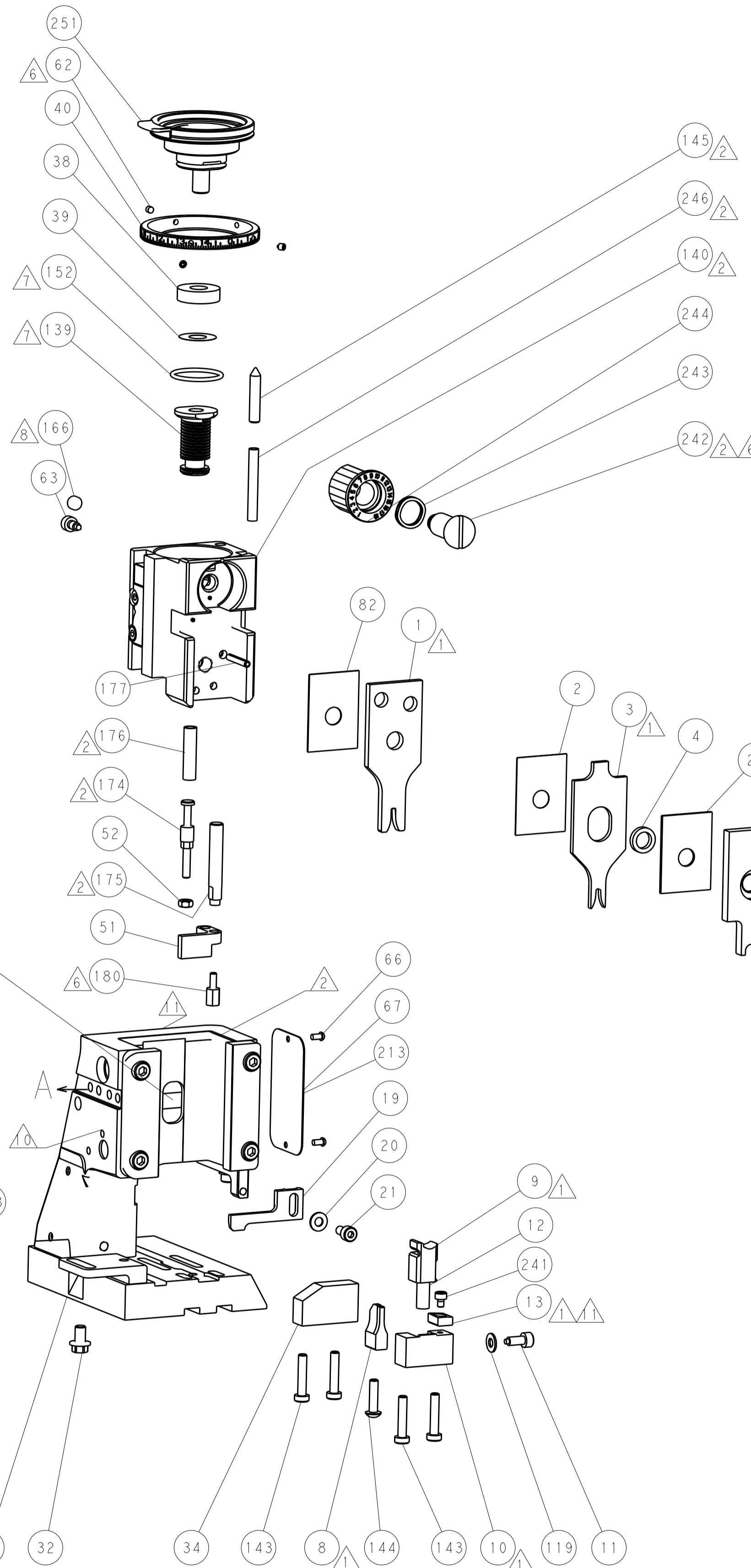
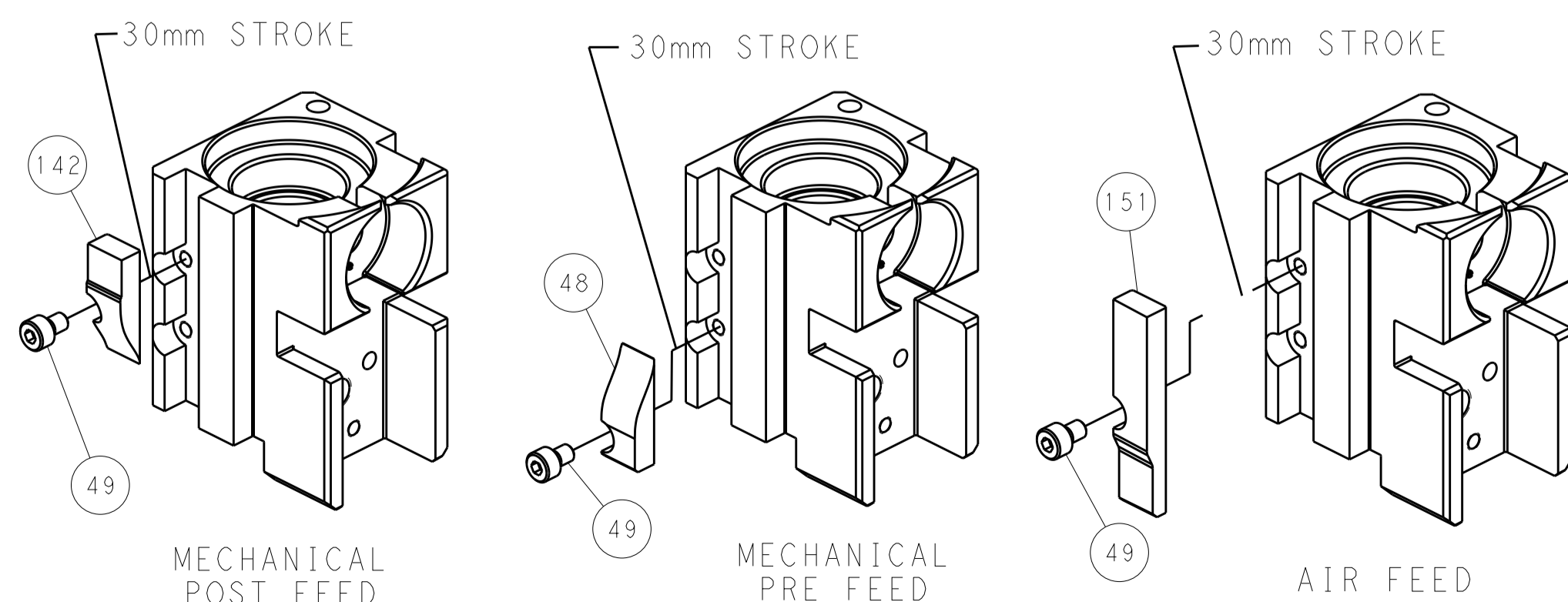
### PNEUMATIC



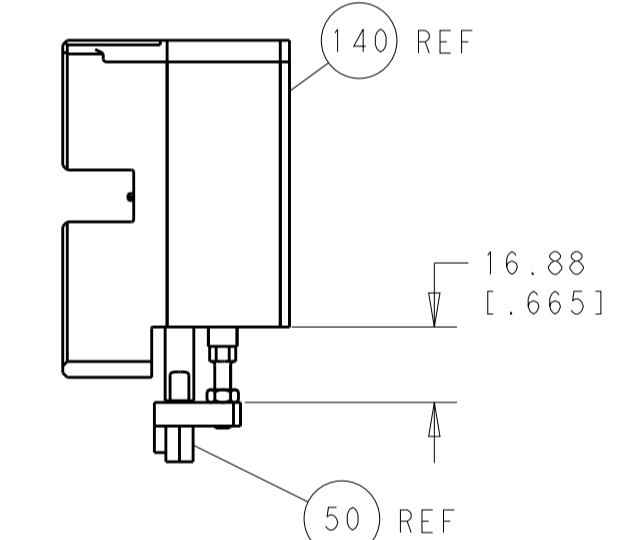
### SERVO LATCH PLATE



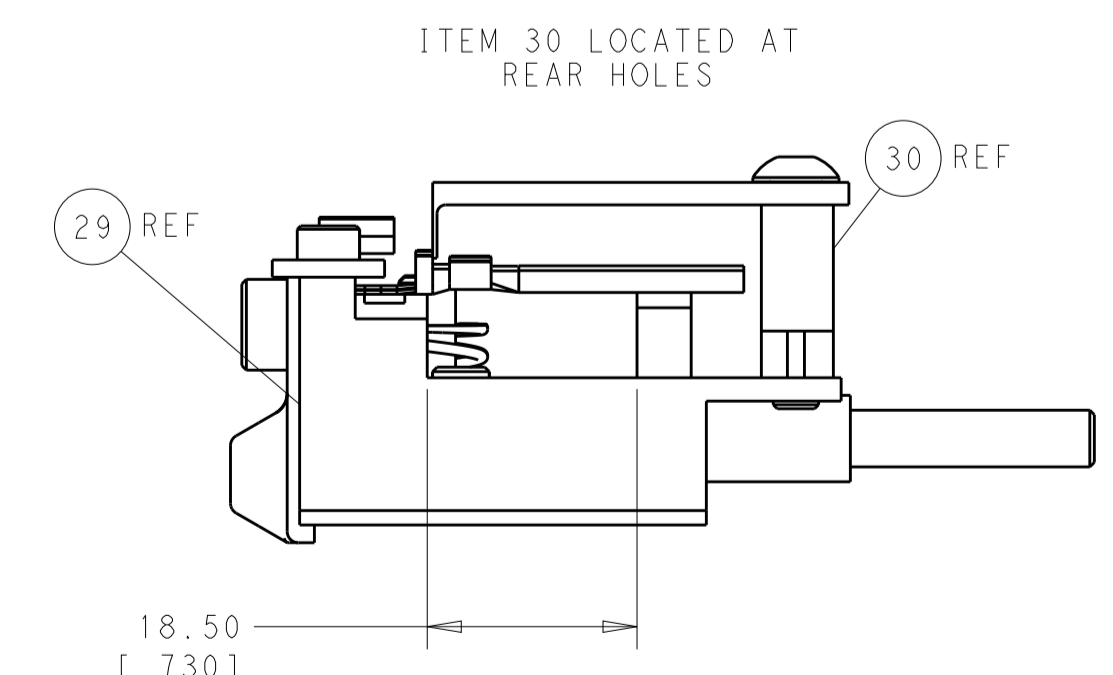
### CAM POSITIONS



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED BY THE ORIGINAL DRAWING. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED.</small>		DWN: C. CHEN 29JAN2013 CHK: S. XI 29JAN2013 APVD: J. CRUZ 29JAN2013	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.1	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151860 SCALE: 1:1	RESTRICTED TO: SHEET 4 OF 4 REV A