

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|--------------------------------------|-------------------|-----------------------------------|-----------------------|-------------|-------------|-----------|------------------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2151540-1 | G | 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 | - | 8-2151540-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151540-4 | - | - | |
| | | | | | 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 | - | 8-2151540-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | 2151540-2 | G | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SMART APPLICATOR | 2161326-1 | - | 8-2151540-4 | - | - | - |
| | | | | | 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 | - | 8-2151540-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151540-4 | - | - | |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 |
| 2151540-5 | G | 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 | |
| | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | |
| 2151540-6 | G | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | | |
| | | | | - | - | - | - | - | - | | |
| 2151540-7 | G | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | | |
| 3-2151540-2 | G | 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 | - | 8-2151540-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | |
| 7-2151540-7 | 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: SIEMENS TERMINAL TE CRIMP SPECIFICATION | | | |
|--|------------------|------------------------------|------------------|
| TERMINAL NAME: FEMALE TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.10-4.70 mm [.161-.185 IN] | | Ø1.10-1.40 mm [.043-.055 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-13060 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | SIEMENS TERMINAL | TE TERMINAL | SIEMENS TERMINAL |
| 1393364-1 | V23540X7000Y10 | 1-1438299-0 | |
| 1393367-1 | V23540X7000Y11 | 1393364-2 | |
| 1438299-2 | V23540X7000Y31 | 1393367-2 | |
| 1438299-1 | V23540X7000Y30 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.35mm2 | 0.97 +/- 0.04 [.038 +/- .002] | 7.7 |
| 0.22mm2 | 0.89 +/- 0.04 [.035 +/- .002] | 8.7 |

- 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: 8-2151540-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151540-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151540-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151540-6
- 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. 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 ITEMS 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 IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.

| | | | | | | | | | |
|-----|-----|----|----|----|----|-----------|-------------------------------------|-------------|---------|
| - | 1 | - | - | - | - | 1803430-1 | AIR FEED MODULE | 290 | |
| - | 1 | 1 | 1 | 1 | 1 | 1633782-2 | FENCE | 267 | |
| - | - | - | 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 | - | 1803259-1 | BUSHING, FLANGED | 249 | |
| - | - | - | - | 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 | 2119082-8 | 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 | |
| -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 | | | | | |
|--------------|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119999-1 | A | 66 | P | LTM | DESCRIPTION | DATE | OWN | APVD |
| | | | F1 | | ECR-17-001043 | 24JAN2016 | RS | LZ |
| | | | G | | ECR-00-004127 | 23MAR2017 | TB | CT |

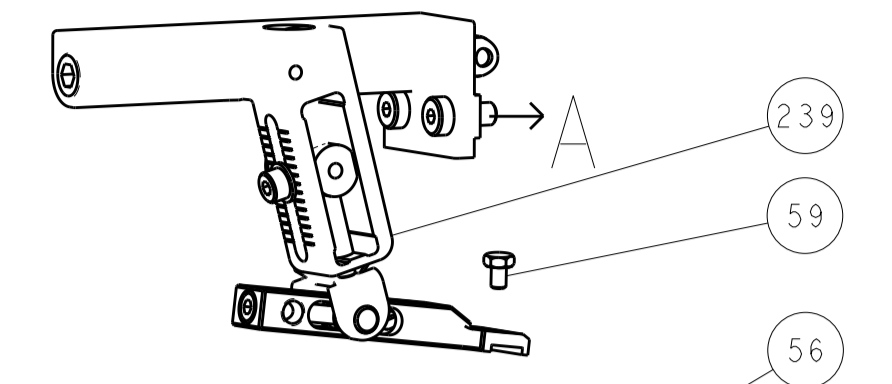
| | | | | | | | | | |
|---|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | 1 | 1 | 1 | 1 | 1 | 18023-1 | SCR, SKT HD CAP M3 X 5.0 | 241 |
| - | - | - | 2 | 2 | - | - | 2168400-6 | SHCS, LOW HEAD, RoHS, M5 X 16 | 240 |
| - | - | - | - | - | - | 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 | 1-22281-8 | SPRING, COMPRESSION | 121 |
| - | 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 | 2168083-6 | SCR, SKT HD CAP, RoHS, M5 X 65 | 93 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 455888-7 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 4 | 4 | 4 | 4 | 4 | 4 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 69 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2-690438-2 | FRONT STRIP GUIDE | 68 |
| - | 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 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 2-18032-5 | SCR, SET, FLT POINT M5 X 20.0 | 61 |
| - | 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 | 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 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 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 | 1-1752356-8 | 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 | 1320908-6 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2-1901086-1 | PLATE, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 22281-8 | SPRING, COMPRESSION | 27 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 240792-2 | DRAG, TERMINAL | 25 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1320928-6 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 980371-4 | SCR, SKT HD SHLDR 5.0 DIA X 6.0 | 23 |
| - | 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 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 454276-5 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1-1333201-9 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119757-4 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2-238011-2 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 4-2119784-2 | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 455888-7 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 5-562108-3 | CRIMPER, WIRE, F | 1 |

| THIS IS INTENDED TO BE USED FOR THE IDENTIFICATION OF THE DRAWING. IT IS NOT TO BE USED FOR THE IDENTIFICATION OF THE PARTS. IT IS THE RESPONSIBILITY OF THE USER TO VERIFY THE IDENTIFICATION OF THE PARTS. | CHK | DATE | NAME |
|--|-----------|-----------|------|
| 1 | STAKEM | 14NOV2011 | |
| 2 | G. BAILEY | 14NOV2011 | |
| 3 | FLBLN | 14NOV2011 | |

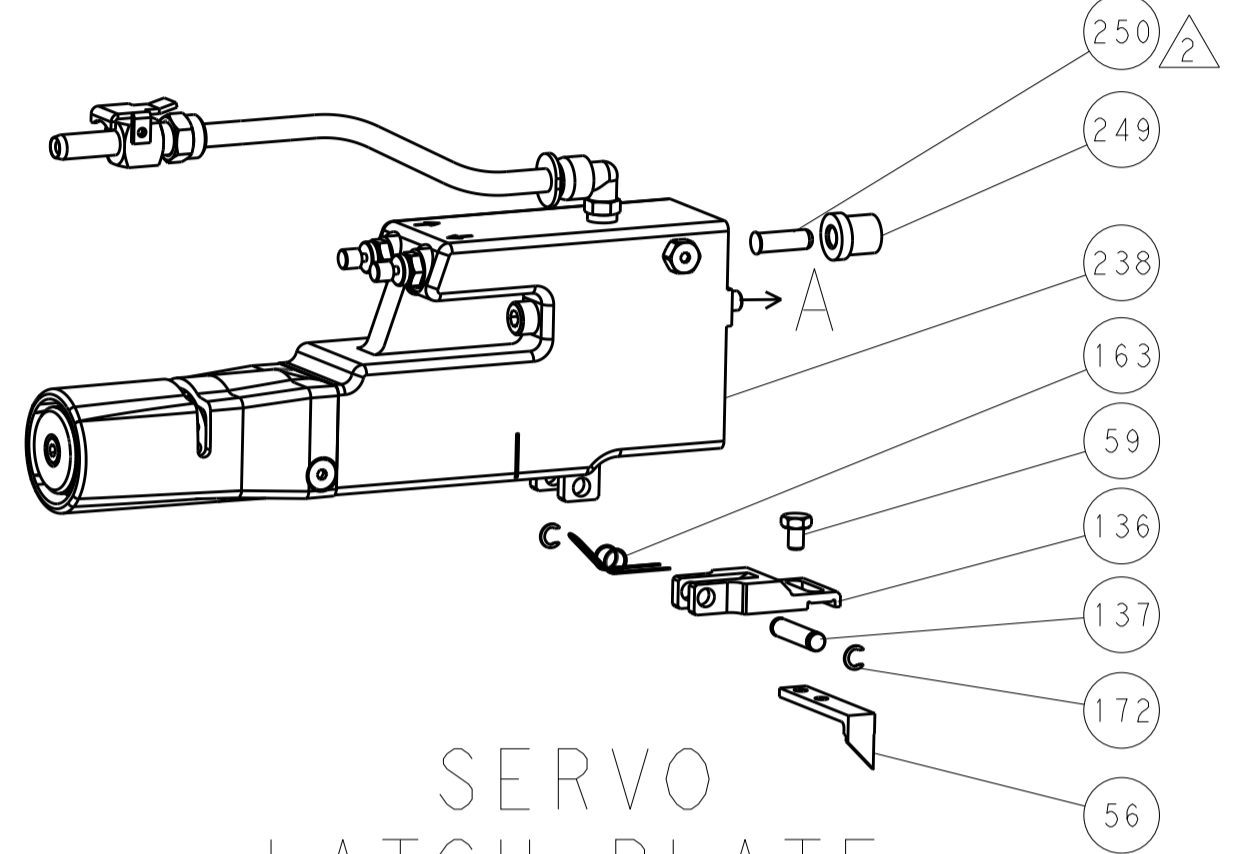
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | |
|-------------|-------|--|--|
| mm | 0 PLC | ± | |
| | 1 PLC | ± | |
| | 2 PLC | ± | |

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

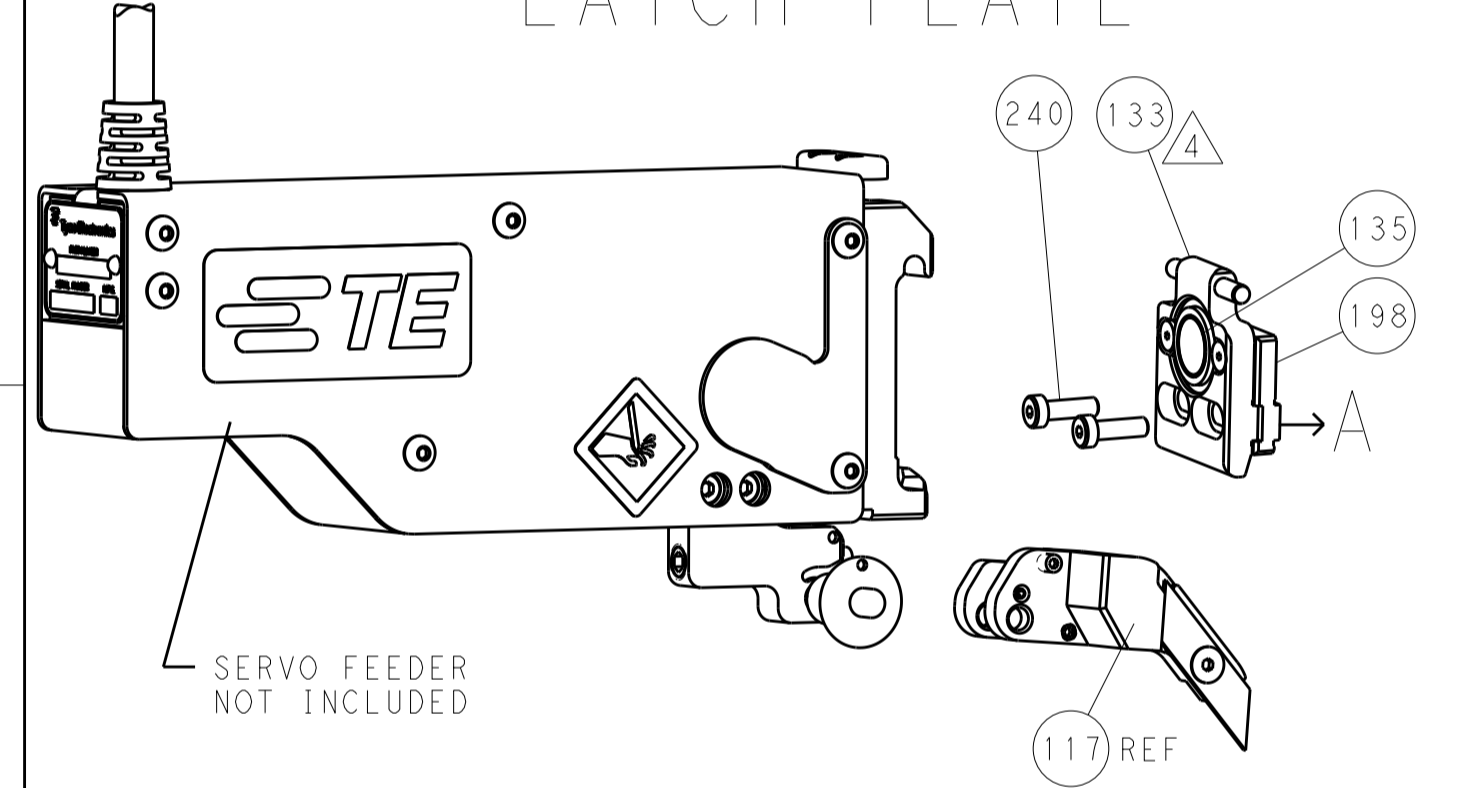
FEED TYPE MECHANICAL



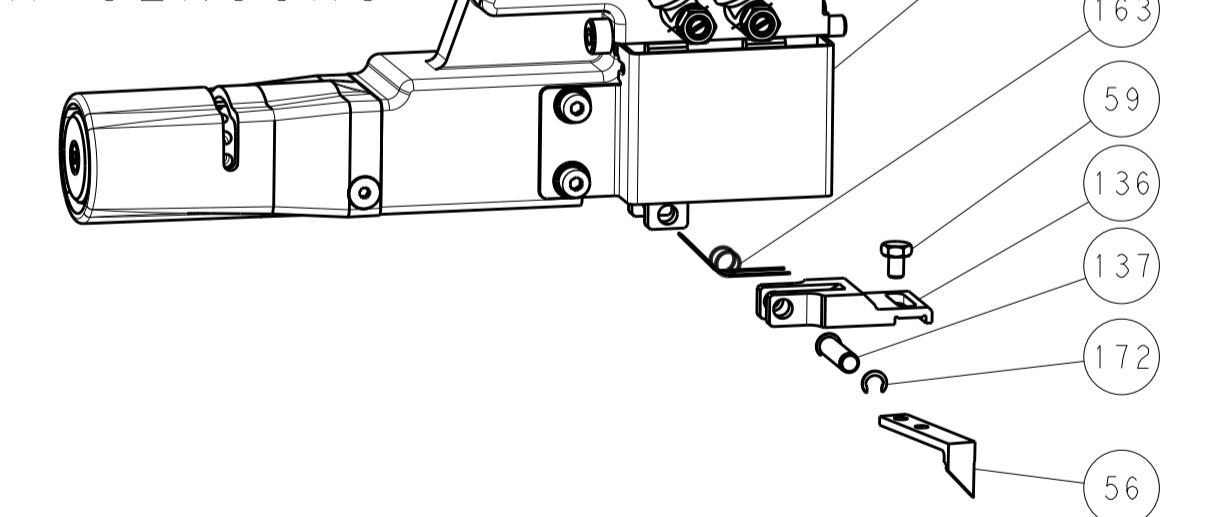
PNEUMATIC



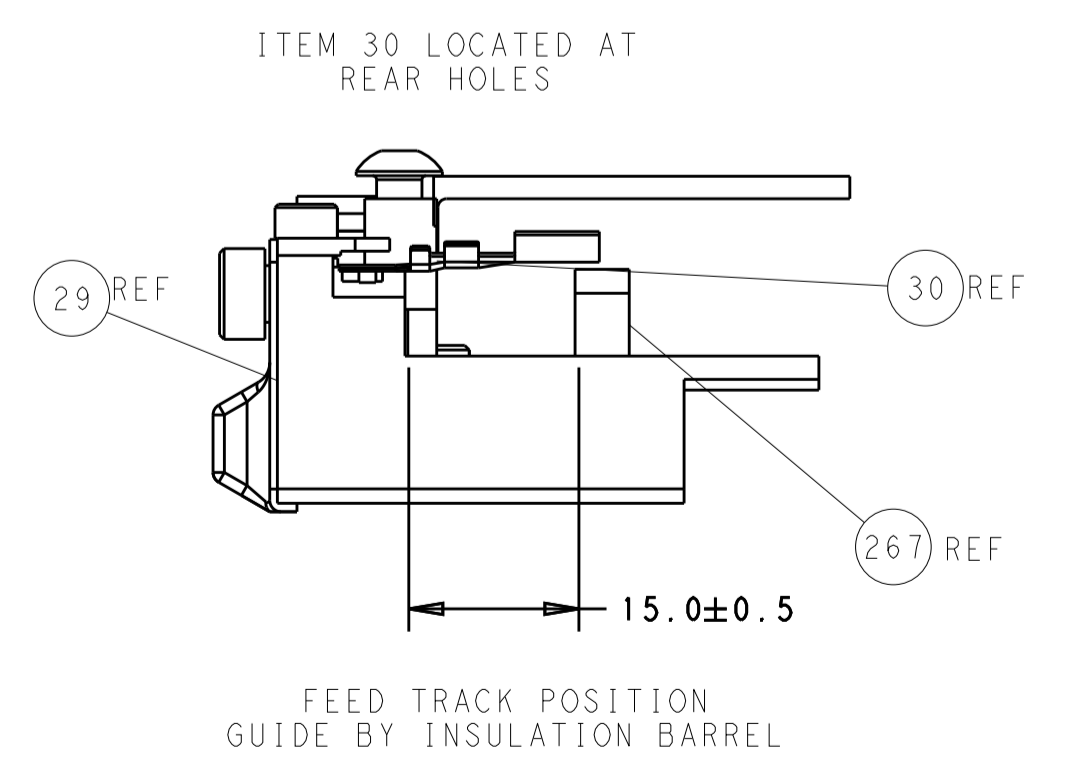
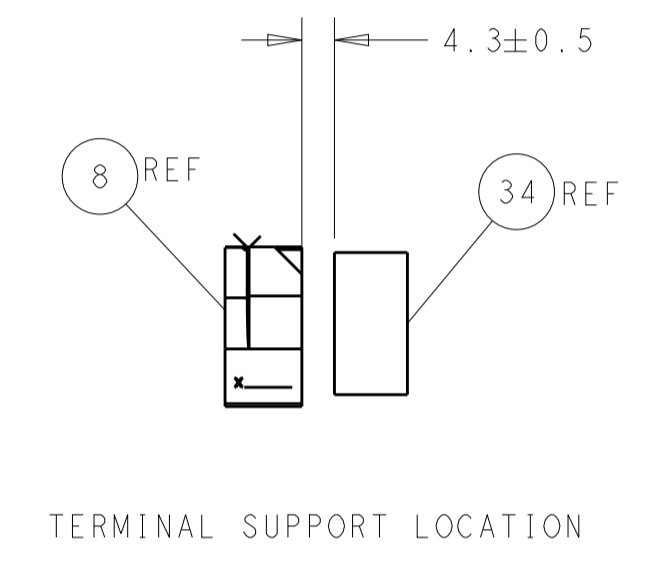
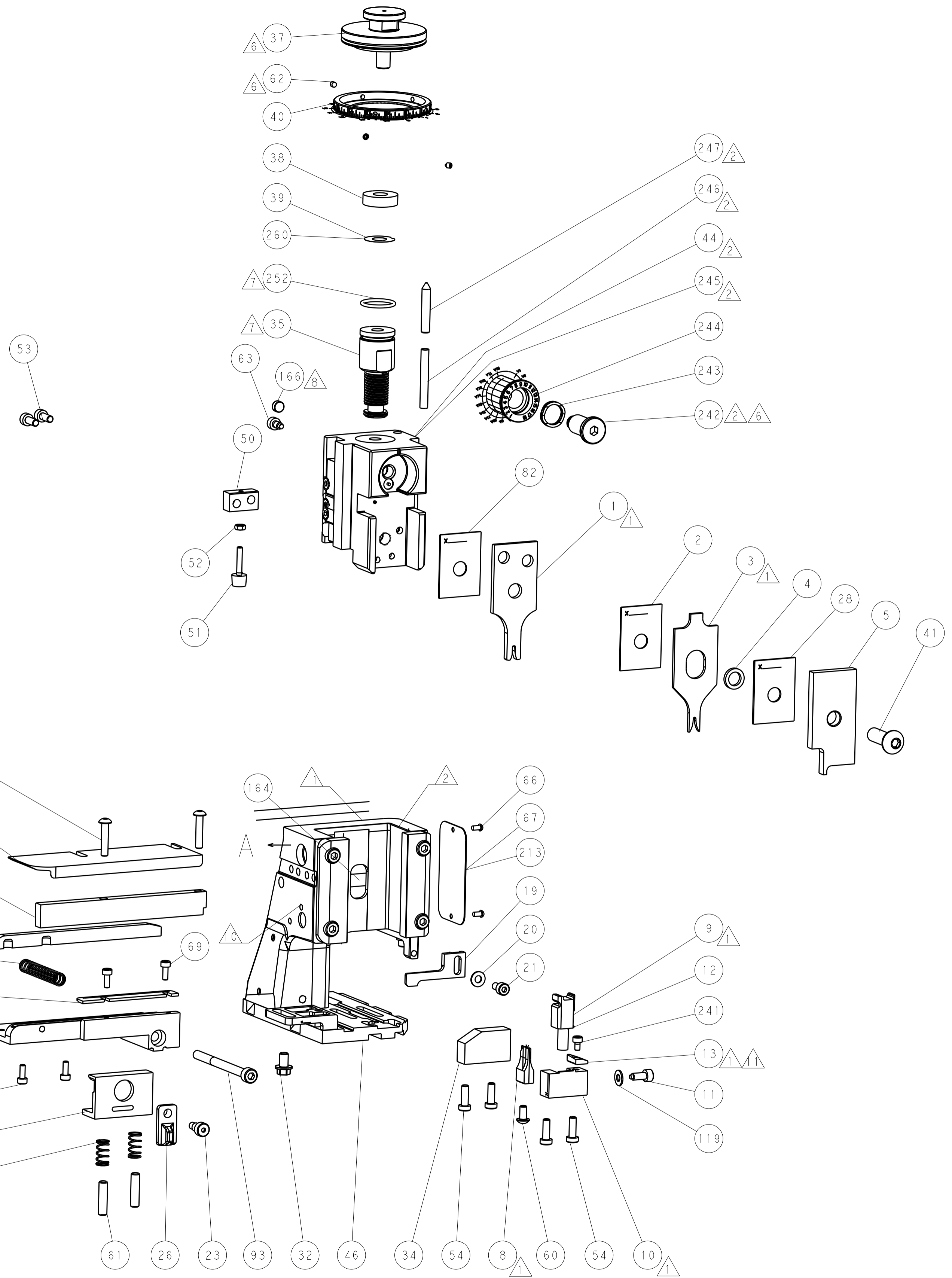
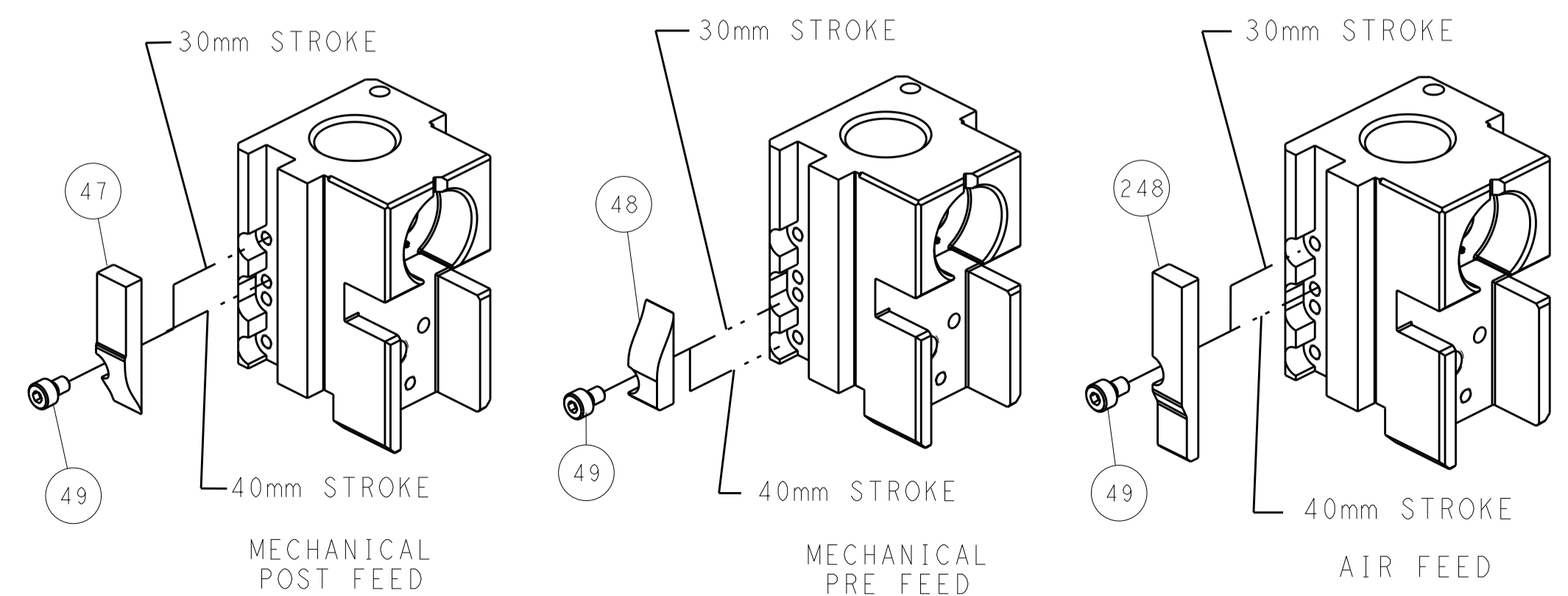
SERVO LATCH PLATE



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: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: R. STAKEM 14NOV2011 | | TE Connectivity | |
| mm | 0 PLC | ± | | CHK: G. BAILEY 14NOV2011 | NAME | Ocean Side Feed Applicator | |
| | 1 PLC | ± | | APVD: T. ERLIN 14NOV2011 | SIZE | CAGE CODE | DRAWING NO. |
| | 2 PLC | ± | | | RESTRICTED TO | | |
| | 3 PLC | ± | | | | | |
| | 4 PLC | ± | | | | | |
| | ANGLES | ± | | | | | |
| MATERIAL: | FINISH: | WEIGHT: | | | | | |
| | | | | | | | |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | | | SCALE | 1:2 | SHEET | 2 OF 4 |
| | | | | REV | G | | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|--------------------------|--------------------------------------|-------------------|-----------------------------------|-----------------------|-------------|-------------|-----------|------------------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151540-1 | G | 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 | - | 8-2151540-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151540-4 | - | - | - |
| | 2-2151540-2 | G | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151540-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151540-4 | - | - | - |
| | 2-2151540-5 | G | 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 |
| | 2-2151540-7 | G | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | | | | | - | - | - | - | - | - | - |
| | | | | | - | - | - | - | - | - | - |
| 4-2151540-2 | G | FINE CRIMP HEIGHT ADJUST | DOUBLE ACTING PNEUMATIC WITH SENSORS | 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 | |
| | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151540-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | |
| 7-2151540-7 | 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: SIEMENS TERMINAL TE CRIMP SPECIFICATION | | | |
|--|------------------|-------------------------------|------------------|
| TERMINAL NAME: FEMALE TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.10-4.70 mm [1.61-.185 IN] | | Ø1.10-1.40 mm [0.043-.055 IN] | |
| TERMINAL APPLICATION SPECIFICATION | | | |
| | 114-13060 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | SIEMENS TERMINAL | TE TERMINAL | SIEMENS TERMINAL |
| 1393364-1 | V23540X7000Y10 | 1-1438299-0 | |
| 1393367-1 | V23540X7000Y11 | 1393364-2 | |
| 1438299-2 | V23540X7000Y31 | 1393367-2 | |
| 1438299-1 | V23540X7000Y30 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 0.35mm2 | 0.97+/-0.04 [0.038+/-0.002] | 7.7 |
| 0.22mm2 | 0.89+/-0.04 [0.035+/-0.002] | 8.7 |

- 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: 8-2151540-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151540-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151540-5
- 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 ITEMS 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF 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 IS EQUIPPED WITH THE DOUBLE ACTING 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.

| -77 | -42 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |
|-----|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| - | - | - | - | - | - | 1803430-1 | AIR FEED MODULE | 290 |
| - | - | - | - | - | - | 1633782-2 | FENCE | 267 |
| - | - | - | - | - | - | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | - | - | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | - | - | 1803259-1 | BUSHING, FLANGED | 249 |
| - | - | - | - | - | - | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | - | - | - | - | 2119082-8 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | - | - | - | - | - | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | - | - | - | - | - | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | - | - | - | - | - | 18023-1 | SCR, SKT HD CAP M3 X 5.0 | 241 |
| - | - | - | - | - | - | 2168400-6 | SHCS, LOW HEAD, RoHS, M5 X 16 | 240 |

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

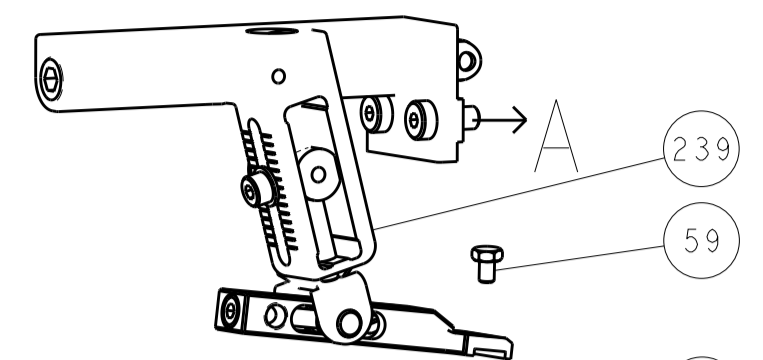
| SET UP GAUGE | LOC | DIST | REVISIONS | | | | | |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1 | A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | | - | - | SEE SHEET 1 | - | - | - |

| | | | | | | | | |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | - | - | - | - | 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 | 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 | 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 | 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 | 1-22281-8 | SPRING, COMPRESSION | 121 |
| - | 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 | 2168083-6 | SCR, SKT HD CAP, RoHS, M5 X 65 | 93 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-7 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 4 | 4 | 4 | 4 | 4 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 69 |
| - | 1 | 1 | 1 | 1 | 1 | 2-690438-2 | FRONT STRIP GUIDE | 68 |
| - | 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 |
| - | 2 | 2 | 2 | 2 | 2 | 2-18032-5 | SCR, SET, FLT POINT M5 X 20.0 | 61 |
| - | 1 | - | - | - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | - | - | - | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 2 | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 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 | 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 | 1-1752356-8 | 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 | 2-1901086-1 | PLATE, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 2 | 2 | 2 | 2 | 2 | 22281-8 | SPRING, COMPRESSION | 27 |
| - | 1 | 1 | 1 | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| - | 1 | 1 | 1 | 1 | 1 | 240792-2 | DRAG, TERMINAL | 25 |
| - | 1 | 1 | 1 | 1 | 1 | 1320928-6 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 1 | 980371-4 | SCR, SKT HD SHLDR 5.0 DIA X 6.0 | 23 |
| - | 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 | 454276-5 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1-1333201-9 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2119757-4 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 2-238011-2 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1 | 1 | 4-2119784-2 | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-7 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 1 | 1 | 1 | 5-562108-3 | CRIMPER, WIRE, F | 1 |

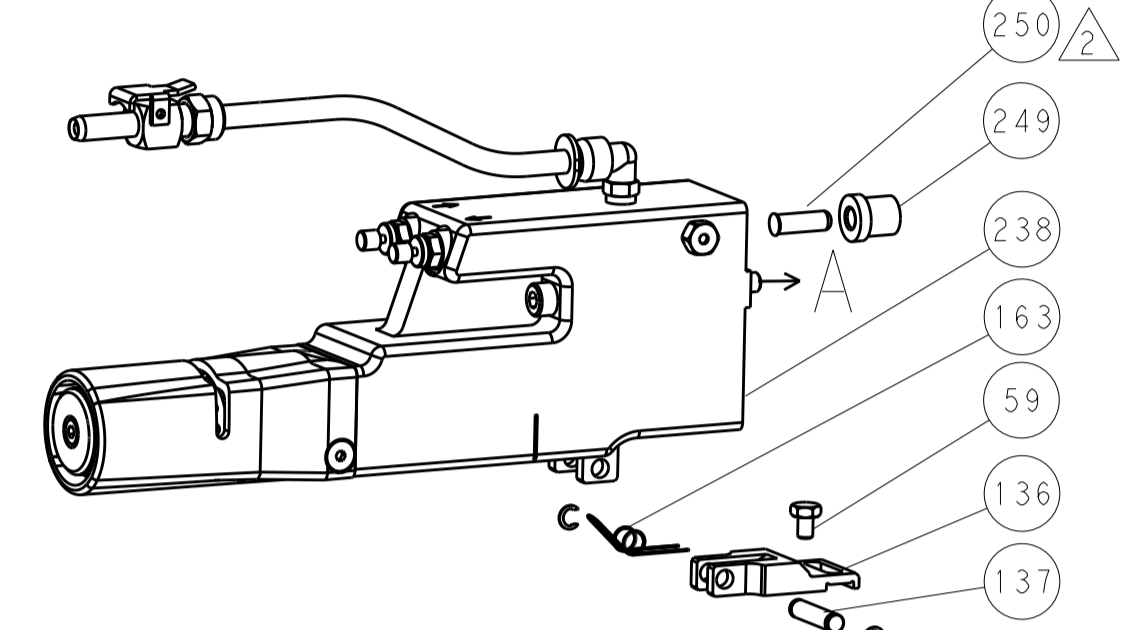
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DATE | CHK | APVD | NAME | PRODUCT SPEC | APPLICATION SPEC | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|-------------|---------|--|----------|--|--------|-----------|-----------|--------------|------------------|------|-----------|------------|---------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 14NOV2011 | STAKEM | 14NOV2011 | G. BAILEY | | | A1 | 00779 | 2151540 | |
| | 3 PLC ± | 4 PLC ± | ANGLES ± | 14NOV2011 | ELBLN | | | | | | | | |
| MATERIAL | FINISH | WEIGHT | SCALE | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | SCALE | SHEET | 3 | OF | 4 | REV | G | |

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

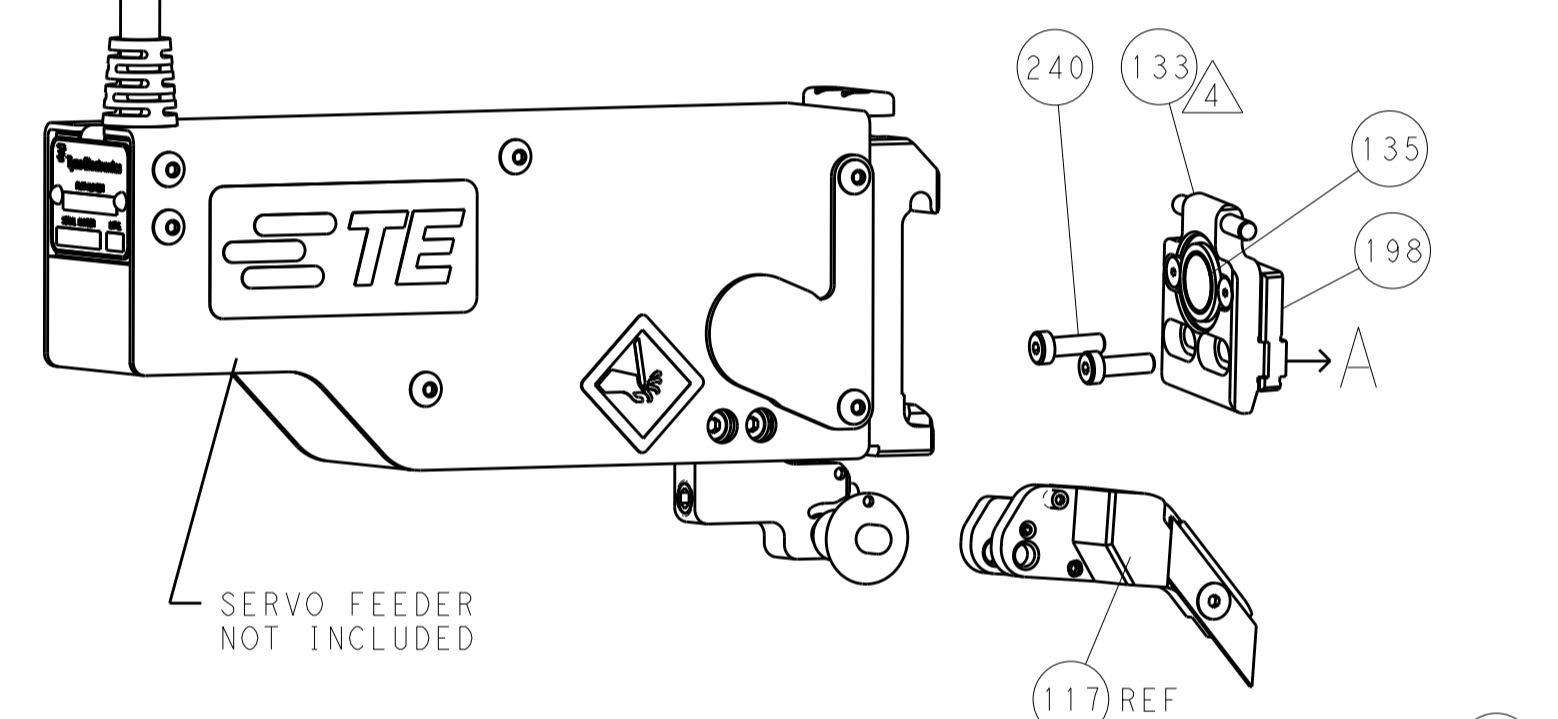
FEED TYPE MECHANICAL



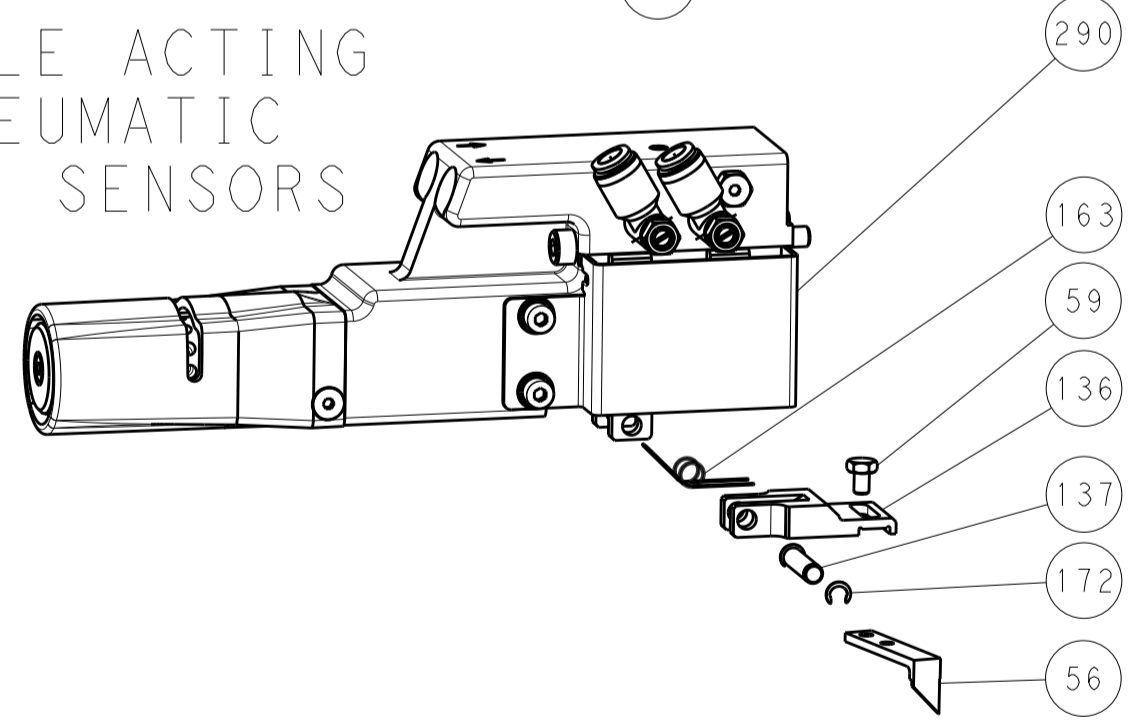
PNEUMATIC



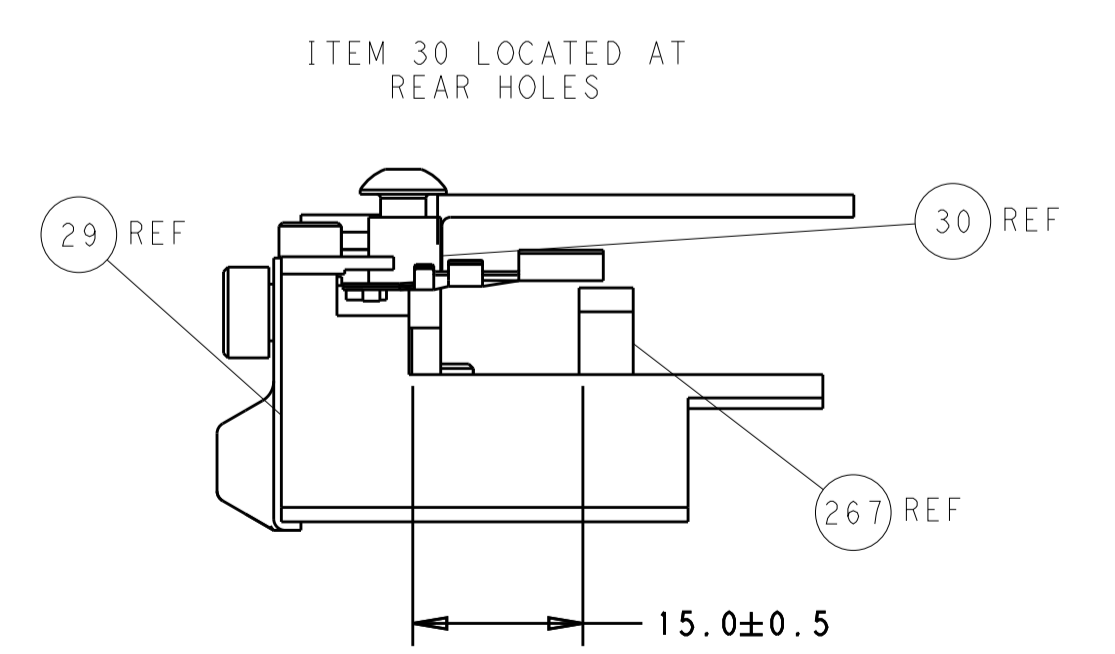
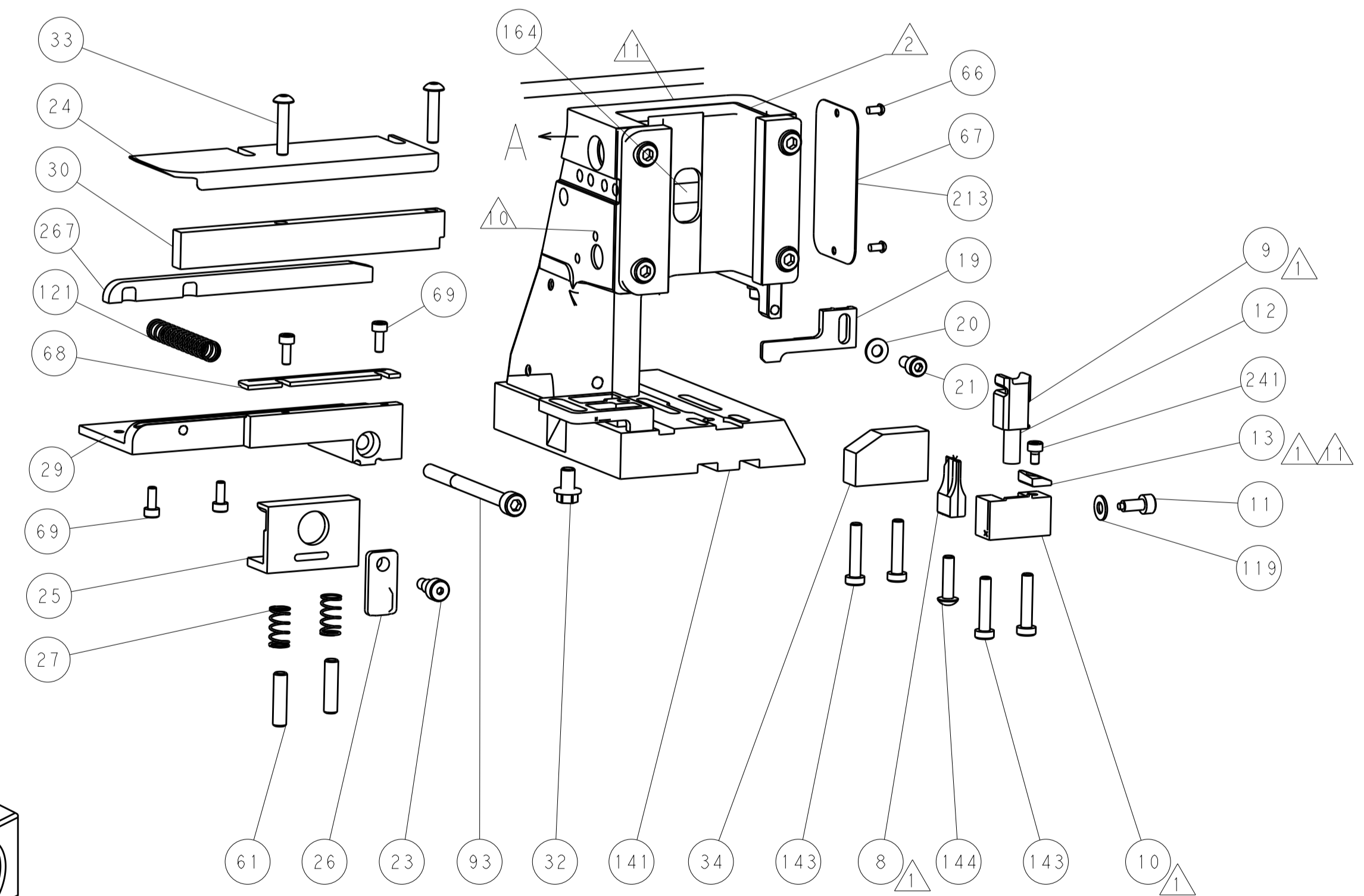
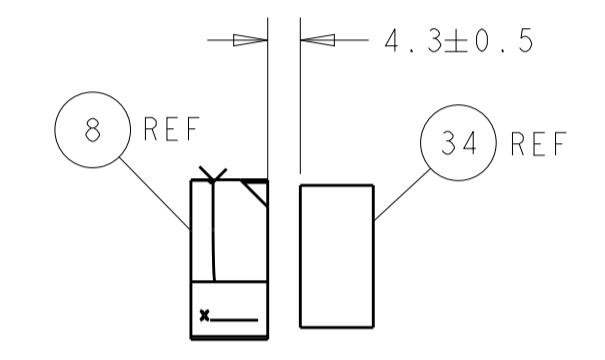
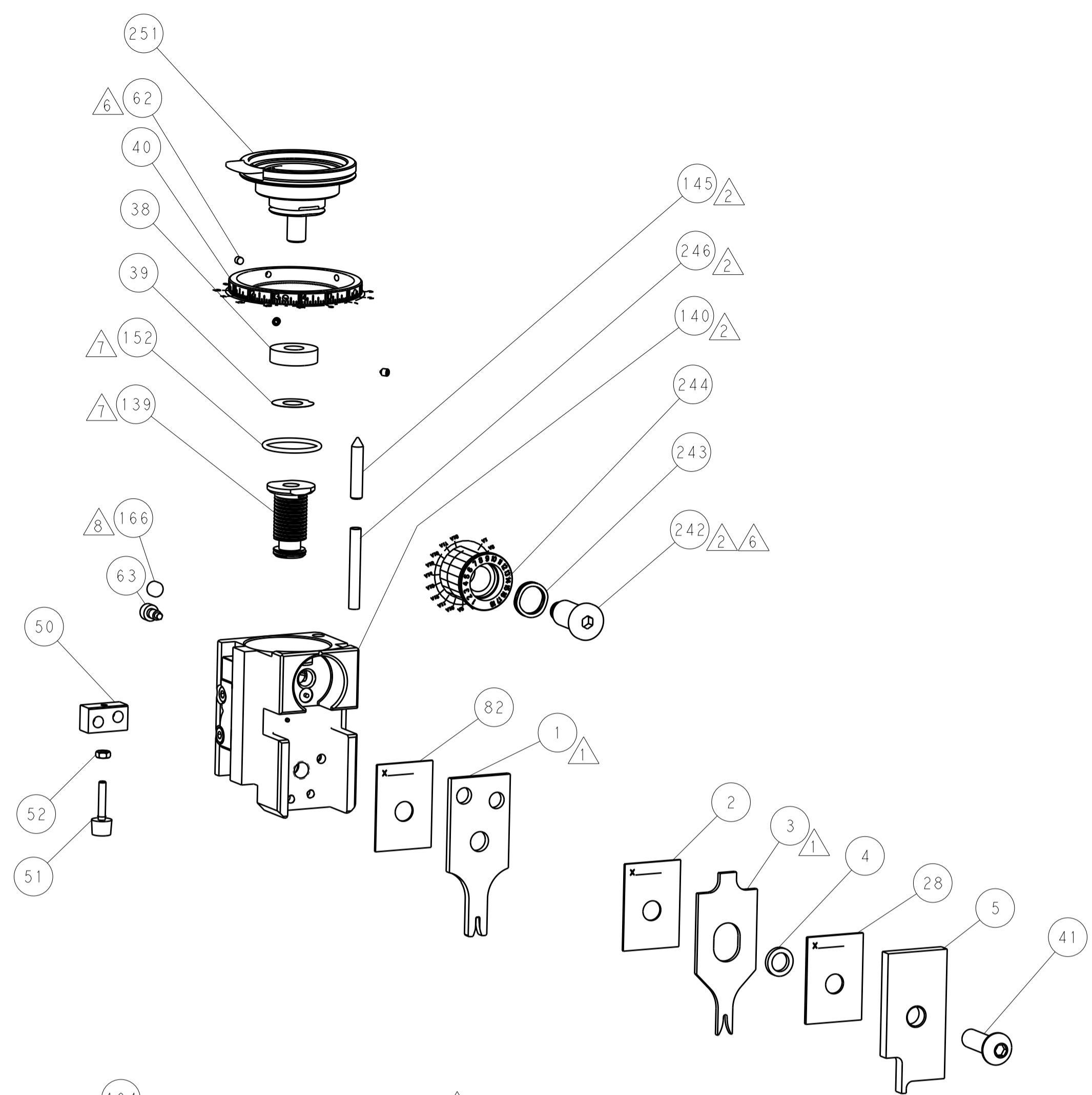
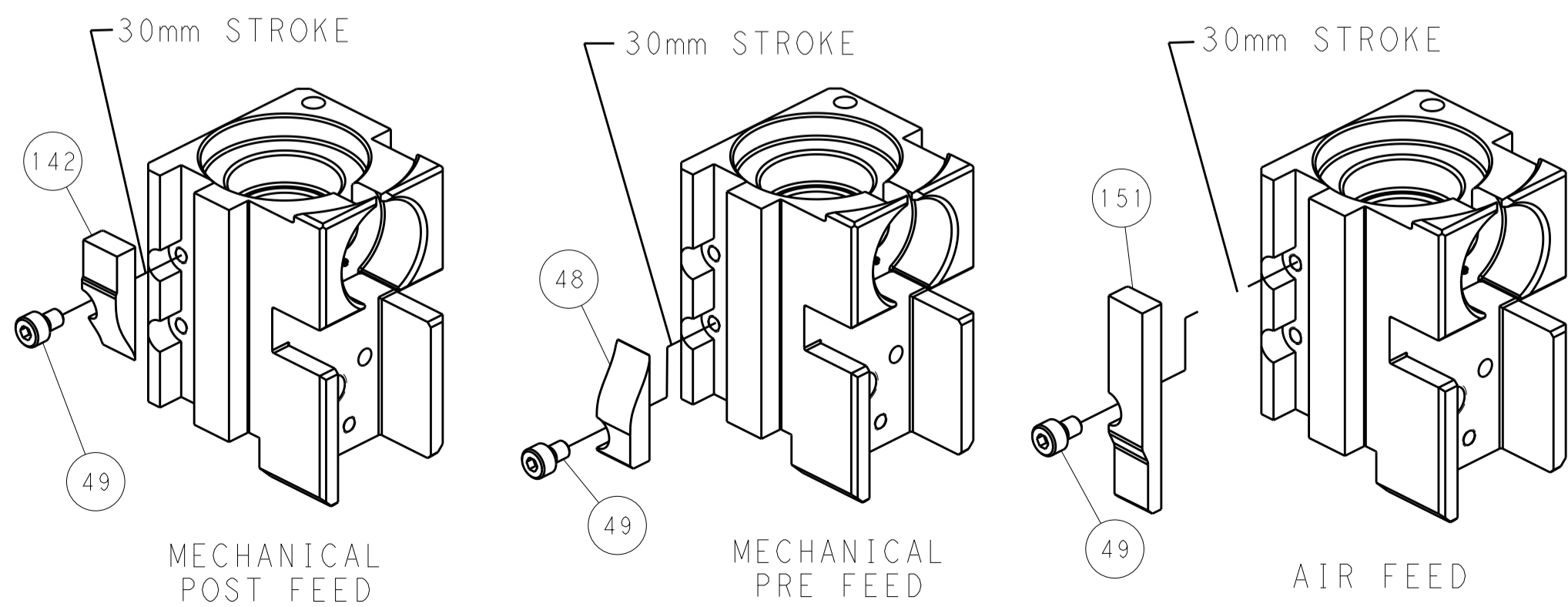
SERVO LATCH PLATE



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)

| | | | | | |
|-------------|---------|--|---------|--|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DMN: STAKEM 14NOV2011 | TE Connectivity Harrisburg, PA 17105-3608 |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | CHK: G. BAILEY 14NOV2011 | |
| MATERIAL: | | FINISH: | | APVD: T. ELBIN 14NOV2011 | NAME: Ocean Side Feed Applicator |
| | | | | PRODUCT SPEC: | SIZE: CAGE CODE: DRAWING NO: |
| | | | | APPLICATION SPEC: | RESTRICTED TO: |
| | | | | WEIGHT: | A 00779 C=2151540 |
| | | | | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | SCALE: 1:2 SHEET 4 OF 4 REV G |