

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2151059-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151059-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151059-5	1901094-3	1-1752354-3	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151059-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2151059-5	J	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151059-5	1901094-3	1-1752354-3	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151059-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151059-6	J	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
2151059-7	J	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151059-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	OV

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.60 mm [.157-.181 IN]	Ø2.20-3.00 mm [.087-.118 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)114-18037		
	(B)114-18388		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 964326-1	(A) 964326-5	(A) 8-964326-1	(B) 1241404-1
(B) 1241404-3	(B) 1-2208460-1	(B) 1-2208460-3	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 6, 3/4 .8K FLATCONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.60 mm [.157-.181 IN]	Ø2.20-3.00 mm [.087-.118 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)114-18037		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 927837-1	(A) 927837-2	(A) 927837-3	(A) 927837-4
(A) 927837-5	(A) 1-927837-5	(A) 964203-1	(A) 964203-2
(A) 964203-3	(A) 964203-4	(A) 964203-5	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.60 mm [.157-.181 IN]	Ø2.20-3.00 mm [.087-.118 IN]		
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1241404-1	-	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.04+/-0.05 [.080+/- .002]	6.8
2.00mm2	1.90+/-0.05 [.075+/- .002]	8.5
1.50mm2	1.76+/-0.05 [.069+/- .002]	9.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.04+/-0.05 [.080+/- .002]	4.8
2.25mm2	1.97+/-0.05 [.078+/- .002]	5.5
2.00mm2	1.90+/-0.05 [.075+/- .002]	6.2
1.50mm2	1.76+/-0.05 [.069+/- .002]	7.6
16 AWG	1.70+/-0.05 [.067+/- .002]	8.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2+1.00mm2	2.04+/-0.05 [.080+/- .002]	6.8

- 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: 8-2151059-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151059-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151059-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151059-6
- 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. 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, 180.
- 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 TERMINAL LUBRICANT IS RECOMMENDED.

**\*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.

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 THE 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.

-	-	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
-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)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			H	ECR-15-000890	21JAN2016	KH UG
			J	ECR-17-003887	17MAR2017	KH CT

-	-	-	-	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	2119082-4	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	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	1-1752354-3	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	455888-8	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	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	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	1901681-2	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	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	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	1-1752356-1	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	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	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	2119533-1	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	1333207-2	ANVIL, COMBINATION .110	8
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	2119785-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1	1	1	456408-3	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	BY	APPV	NAME
mm	0 PLC	±		16SEP2011	YIN		TE Connectivity
	1 PLC	±		16SEP2011	BAILEY		Harrisburg, PA 17105-3608
	2 PLC	±					
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
MATERIAL	FINISH						

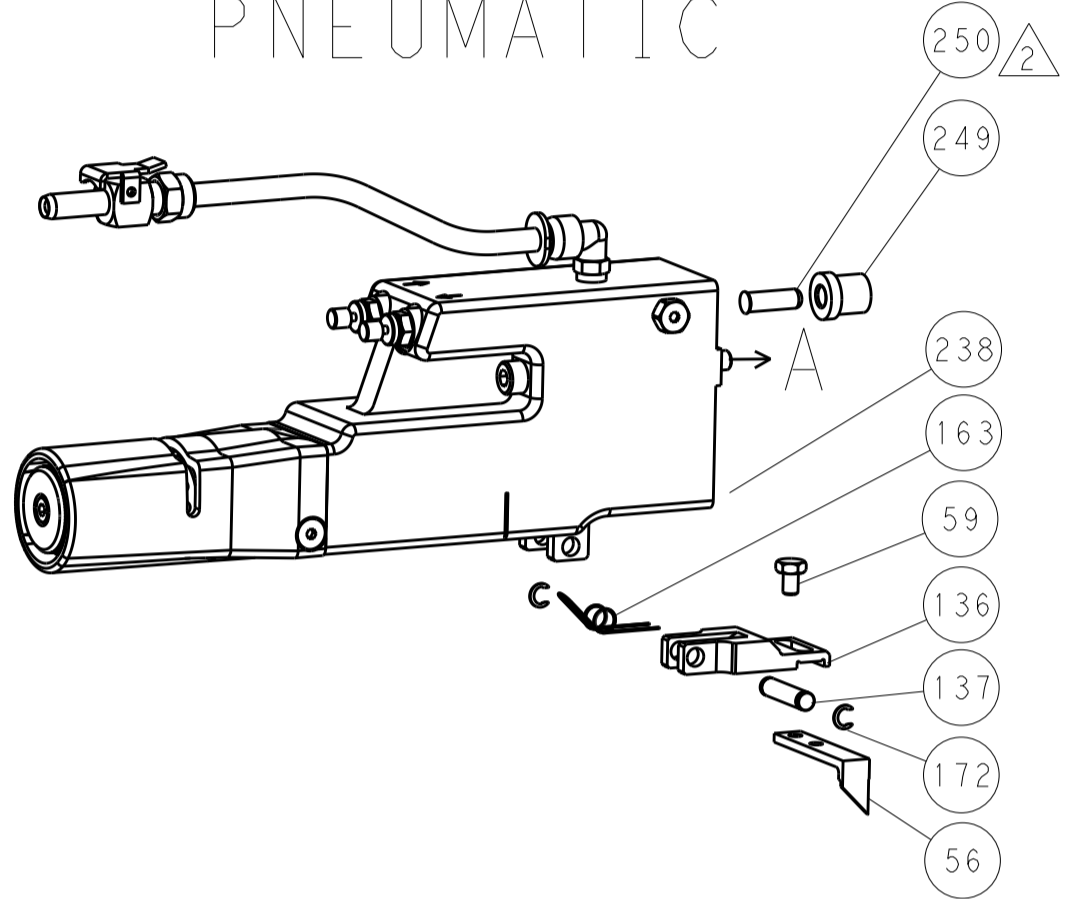
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 of 4 REV J

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

### FEED TYPE MECHANICAL



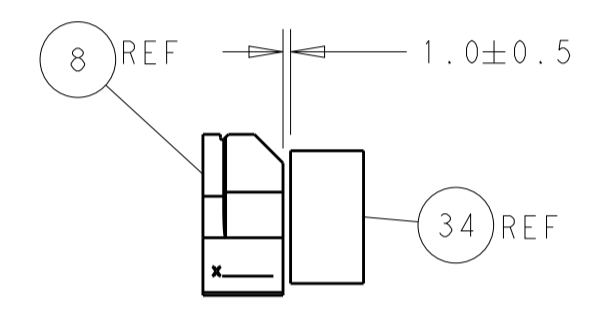
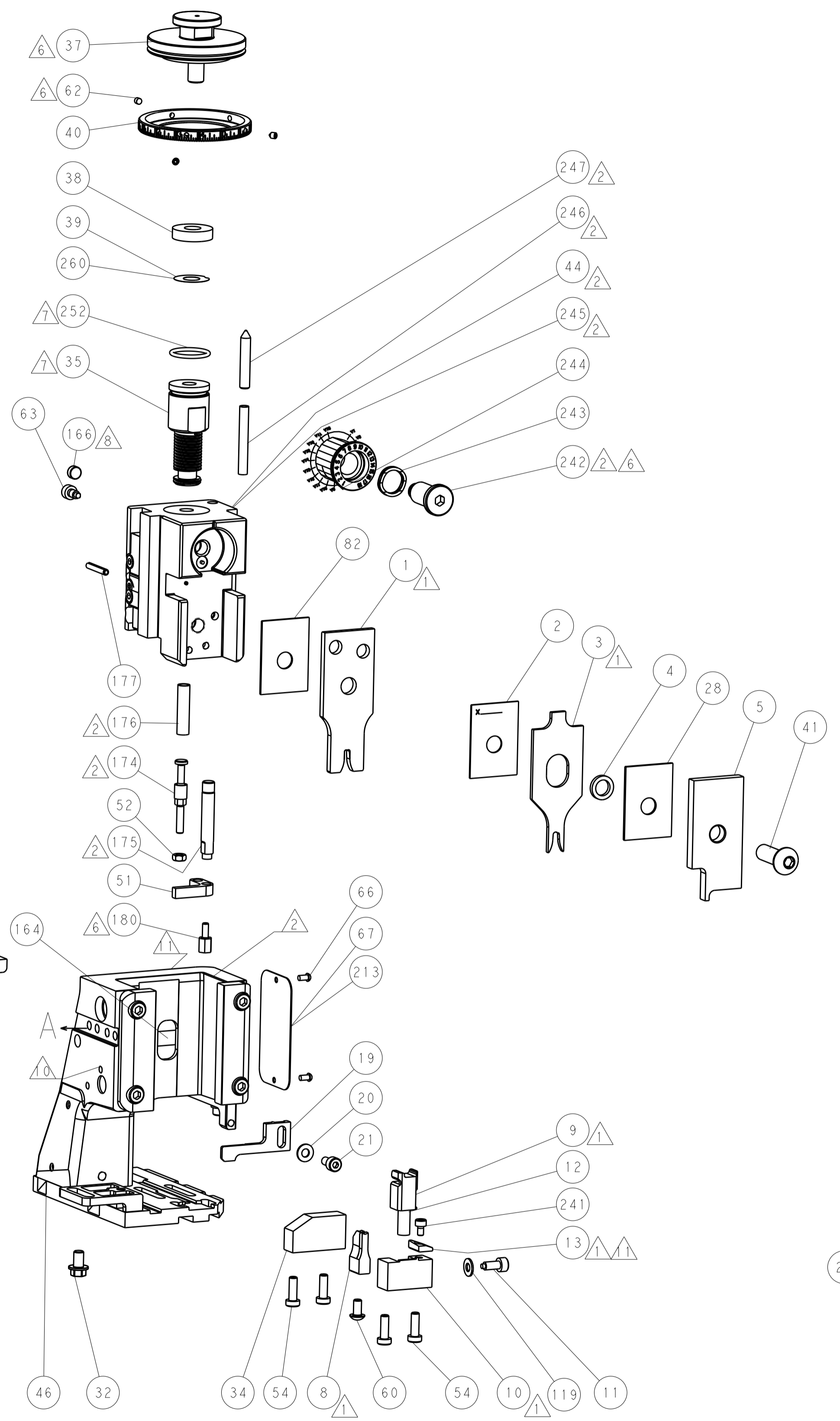
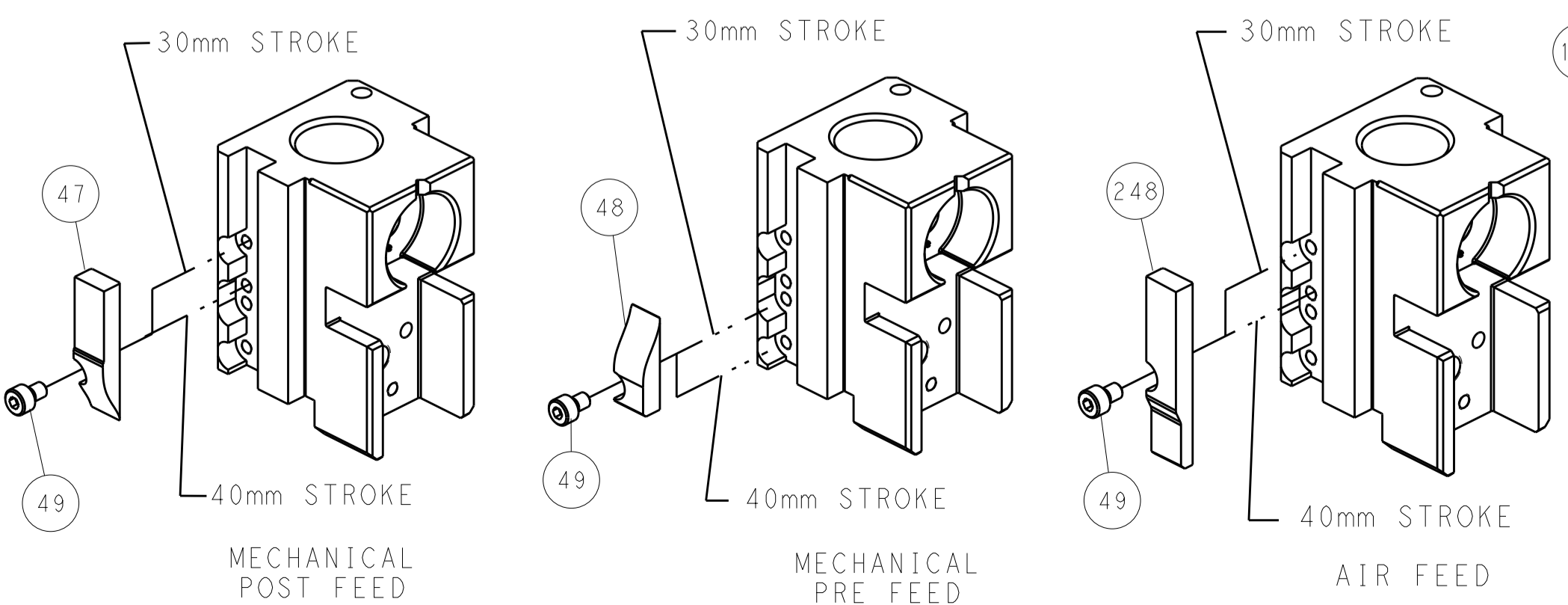
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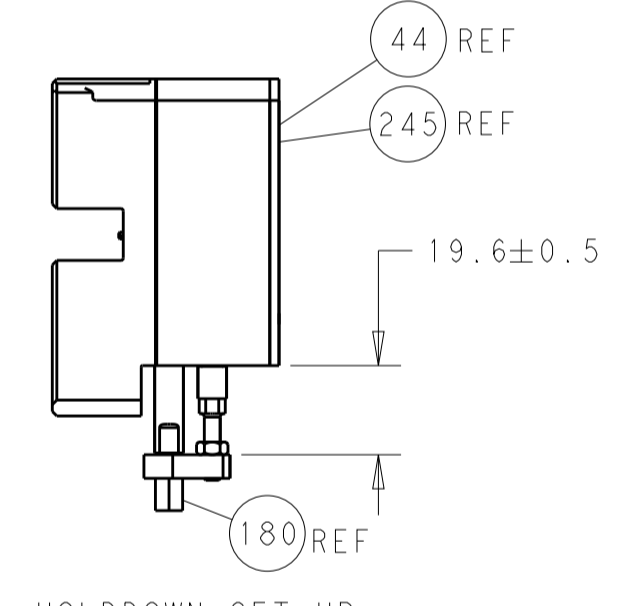
### SERVO LATCH PLATE



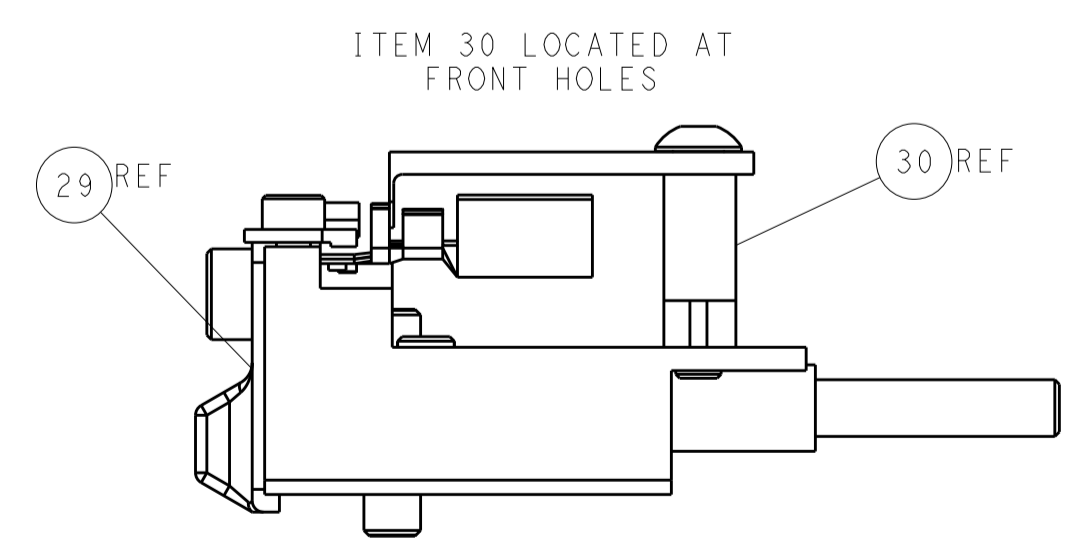
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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:		DWG: T. YIN 16SEP2011		TE Connectivity	
mm	0 PLC	±		CHK: G. BAILEY 16SEP2011	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD: S. XI 16SEP2011	PRODUCT SPEC	SIZE	CAGE CODE DRAWING NO
	2 PLC	±			APPLICATION SPEC	A1	00779 ©=2151059
	3 PLC	±			WEIGHT	Customer Accessible Production Drawing	SCALE 1:2 SHEET 2 of 4 REV J
	4 PLC	±			ANGLES		
MATERIAL	FINISH						

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151059-1	J	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	-	8-2151059-5	1901094-3	1-1752354-3	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151059-4	-	-	-
	2-2151059-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151059-5	1901094-3	1-1752354-3	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151059-4	-	-	-
	2-2151059-5	J	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
	2-2151059-7	J	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151059-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.10]	F
INSUL	3.56 mm [1.40]	OV
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60 mm [1.57-.181 IN]		Ø2.20-3.00 mm [1.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18037	-	-
	(B)114-18388	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 964326-1	(A) 964326-5	(A) 8-964326-1	(B) 1241404-1
(B) 1241404-3	(B) 1-2208460-1	(B) 1-2208460-3	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 6.3/4.8K FLATCONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60 mm [1.57-.181 IN]		Ø2.20-3.00 mm [1.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18037	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 927837-1	(A) 927837-2	(A) 927837-3	(A) 927837-4
(A) 927837-5	(A) 1-927837-5	(A) 964203-1	(A) 964203-2
(A) 964203-3	(A) 964203-4	(A) 964203-5	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60 mm [1.57-.181 IN]		Ø2.20-3.00 mm [1.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1241404-1	-	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.04+/-0.05 [1.080+/- .002]	6.8
2.00mm2	1.90+/-0.05 [1.075+/- .002]	8.5
1.50mm2	1.76+/-0.05 [1.069+/- .002]	9.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.04+/-0.05 [1.080+/- .002]	4.8
2.25mm2	1.97+/-0.05 [1.078+/- .002]	5.5
2.00mm2	1.90+/-0.05 [1.075+/- .002]	6.2
1.50mm2	1.76+/-0.05 [1.069+/- .002]	7.6
16 AWG	1.70+/-0.05 [1.067+/- .002]	8.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2+1.00mm2	2.04+/-0.05 [1.080+/- .002]	6.8

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. 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: 8-2151059-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151059-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151059-5
- 5. 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, 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- TERMINAL LUBRICANT IS RECOMMENDED.

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.

**\*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	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-77	-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	DATE	OWN	APVD
-	-	-	-	-	-	SEE SHEET 1	-	-

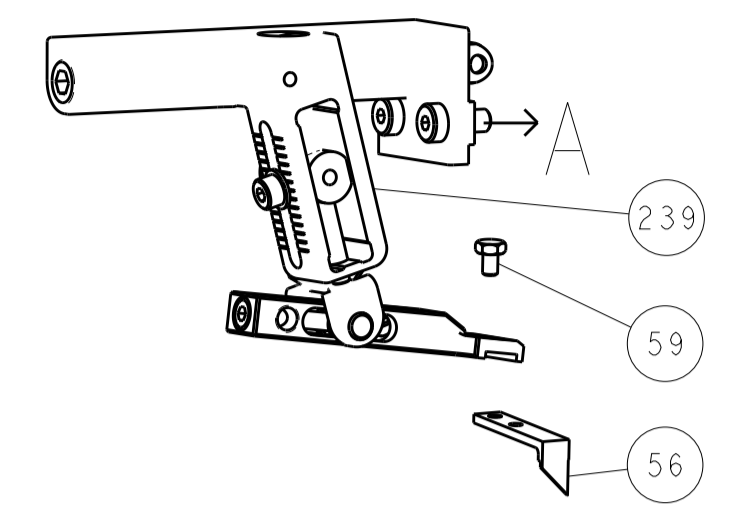
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	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
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-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	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
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-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	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	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
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-	1	1	1	1	455888-8	SPACER, CRIMPER	82
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-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-2	HOLDDOWN, TERMINAL	51
-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
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-	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	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1-1752356-1	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	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	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	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1333207-2	ANVIL, COMBINATION .110	8
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	2119785-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	1	1	456408-3	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC	±		T. YIN	16SEP2011	G. BAILEY	16SEP2011	S. XI	16SEP2011	TE Connectivity Harrisburg, PA 17105-3608	
	1 PLC	±								Ocean Side Feed Applicator	
	2 PLC	±								SIZE CAGE CODE DRAWING NO RESTRICTED TO	
	3 PLC	±								A1 00779 ©=2151059	
	4 PLC	±								Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV J	
	ANGLES	±									

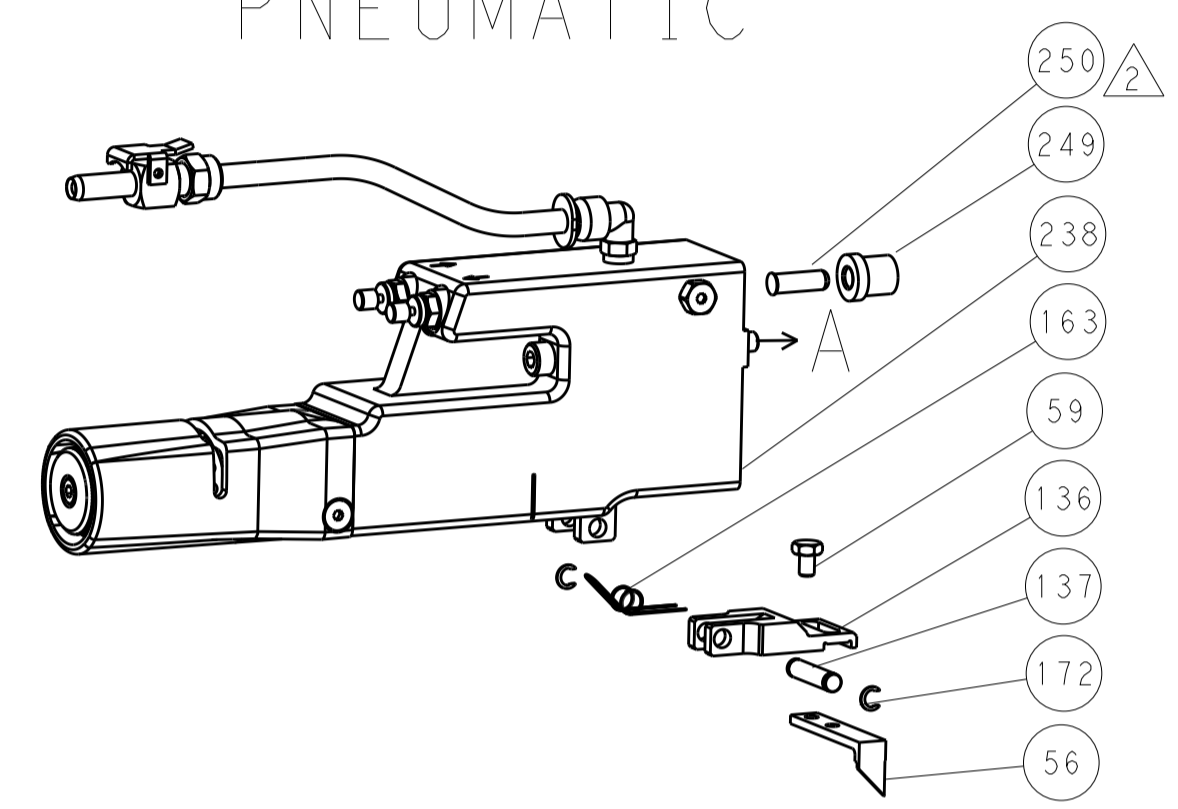


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

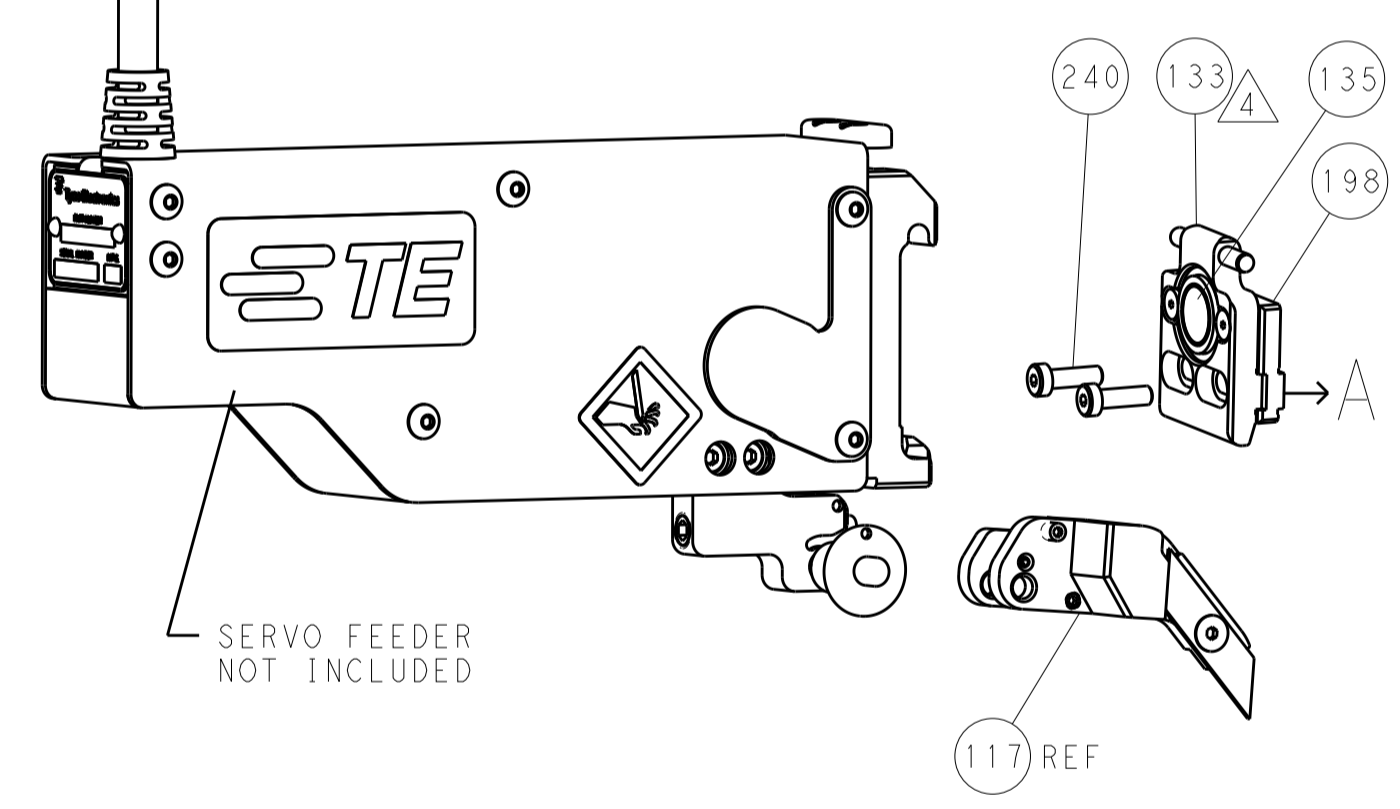
# FEED TYPE MECHANICAL



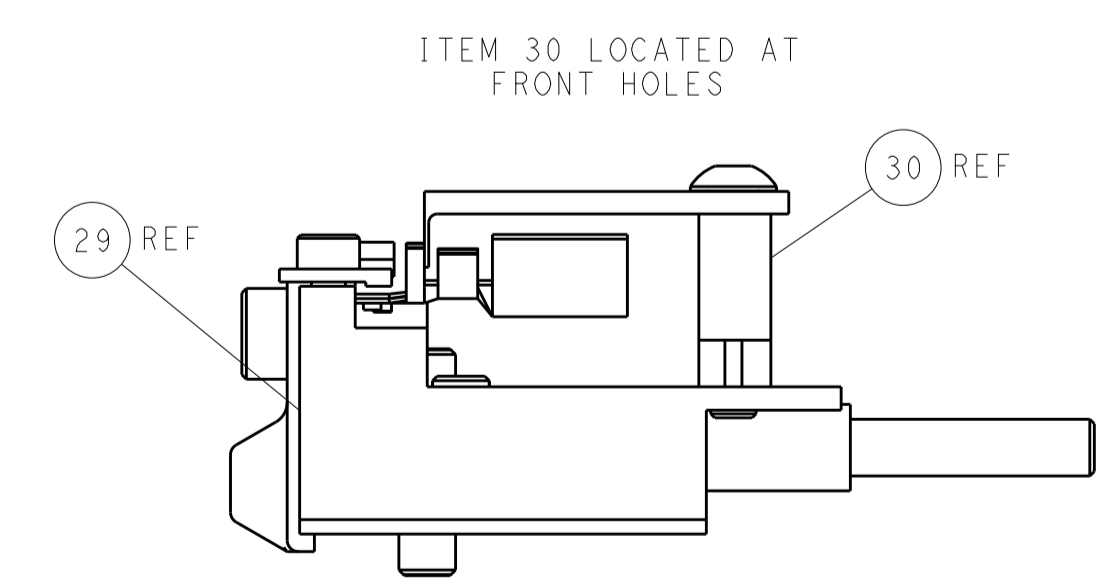
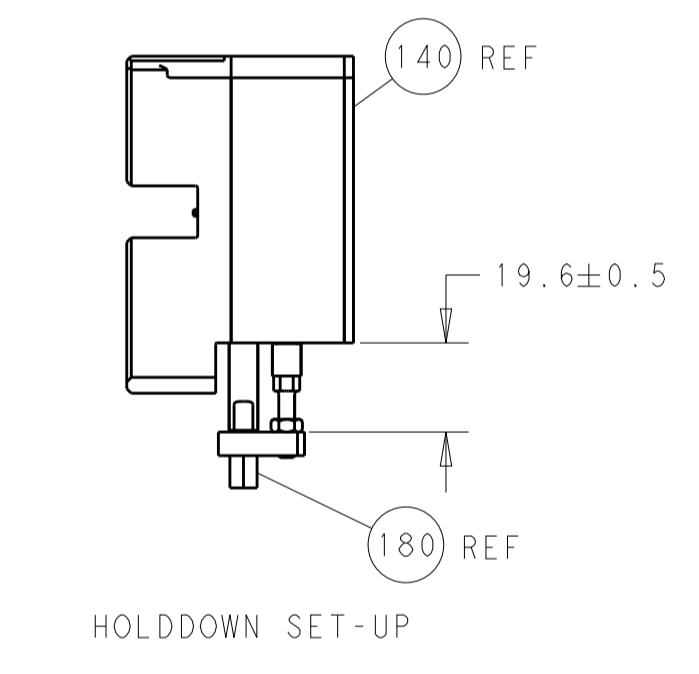
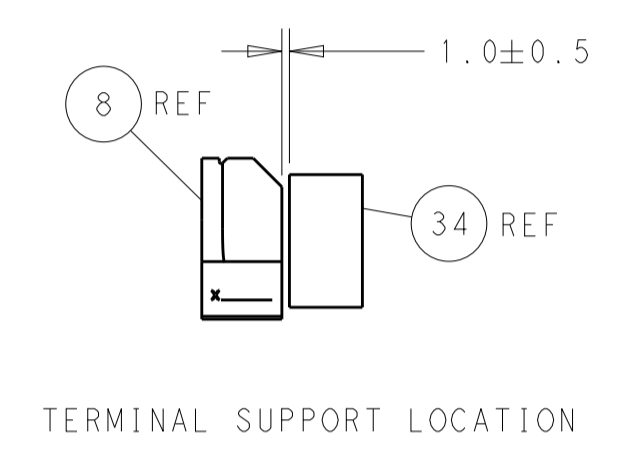
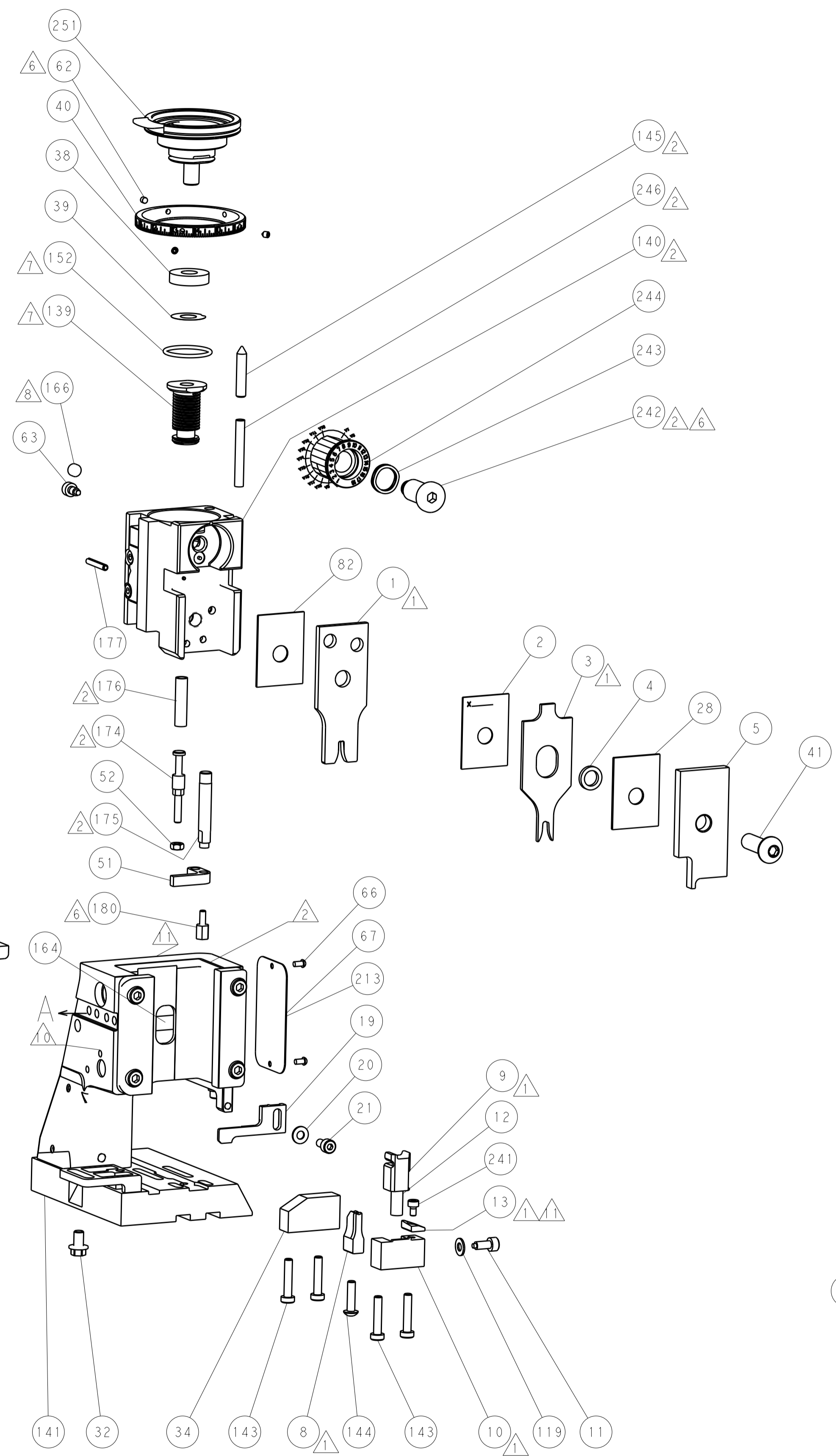
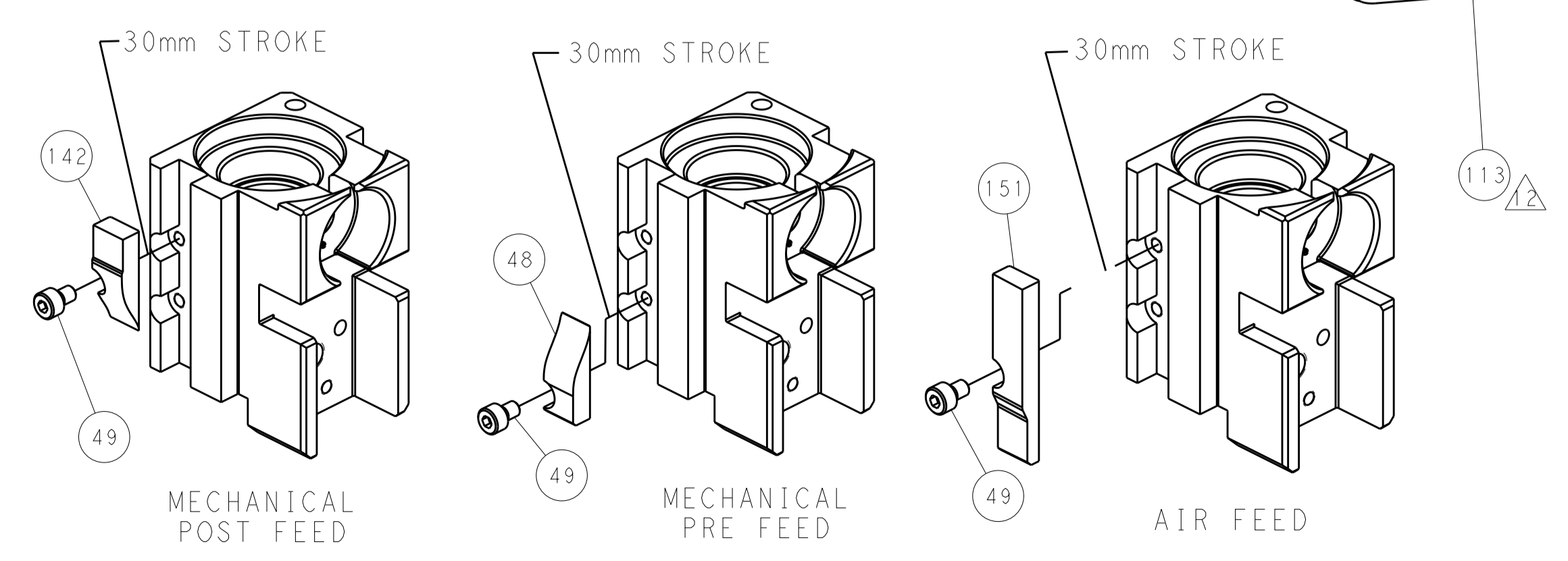
# PNEUMATIC



# 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 16SEP2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL							
Customer Accessible Production Drawing				SCALE 1:2	SHEET 4 OF 4	REV J	