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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

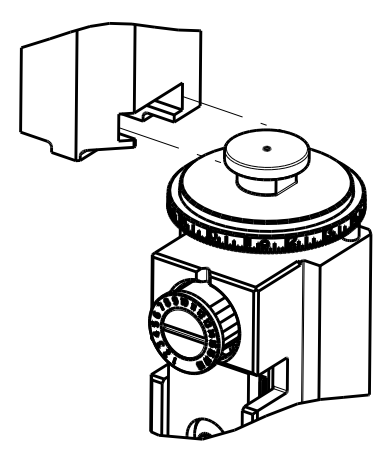
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151364-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
2151364-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151364-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151364-4	-	-	
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
				SERVO LATCH PLATE	2119951-1	-	8-2151364-5	1901094-3	-	2168400-6 (QUANTITY 2)
2151364-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SMART APPLICATOR	2161326-1	-	8-2151364-4	-	-	-
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151364-6	D	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
				-	-	-	-	-	-	-
2151364-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
				-	-	-	-	-	-	-
7-2151364-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: FORD TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, PIN AND RECEPTACLE

WIRE STRIP LENGTH

4.30-6.40 mm [.169-.252 IN]

INSULATION DIAMETER RANGE

Ø 2.13 [.084 IN] MAX

TERMINAL APPLICATION SPECIFICATION

NONE

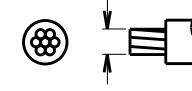
△4

TERMINALS APPLIED

△3

TE TERMINAL	FORD TERMINAL	TE TERMINAL	FORD TERMINAL
286521-2	1L2T-14461-AA	286526-1	F67B-14487-AA
286521-3	F6TB-14461-AB	349676-1	A47-6GA-F6
286521-4	E7EB-14461-CA		
TE TERMINAL	MOLEX TERMINAL		
1832536-1	33093-0009		

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

△9

16 AWG	1.32 +/- 0.05 [.052 +/- .002]	4.7
18 AWG	1.16 +/- 0.05 [.046 +/- .002]	5.6
0.75mm2	1.10 +/- 0.05 [.043 +/- .002]	6.1
20 AWG	1.04 +/- 0.05 [.041 +/- .002]	6.6

△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: 8-2151364-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151364-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151364-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151364-6

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 ITEMS 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.

△0

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

△1

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.

△2

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

△3

TERMINAL LUBRICANT IS RECOMMENDED.

△4

-	-	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
-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 2119599-1

LOC A

DIST 66

P	LTR	DESCRIPTION	DATE	DWN	APVD
A1		ECR-16-006233	27APR2016	JH	JDG
B		ECR-17-006921	12MAY2017	TB	TE
C		ECR-17-009657	03JULY2017	TB	TE
D		ECR-17-2151364	24OCT2017	FZ	KZ

△6

-	-	-	-	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
-	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
-	-	-	-	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	455888-5	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	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 PNT, 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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	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	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-9	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-3	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	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1803095-5	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	4-1633131-6	ANVIL, COMBINATION .080	8
-	1	1	1	1	1	240641-8	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1-2119785-3	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	1-455888-5	SPACER, CRIMPER	2
1	1	1	1	1	1	1-456405-3	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

△1

-	-	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
-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)

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

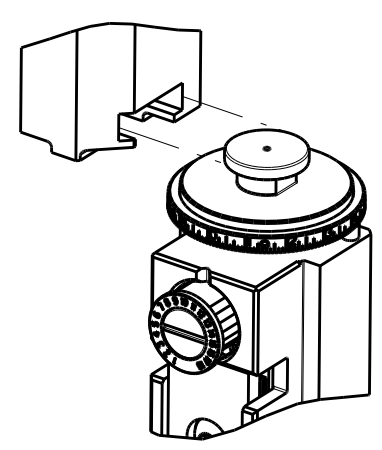
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151364-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
2151364-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151364-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151364-4	-	-	
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
				SERVO LATCH PLATE	2119951-1	-	8-2151364-5	1901094-3	-	2168400-6 (QUANTITY 2)
2151364-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SMART APPLICATOR	2161326-1	-	8-2151364-4	-	-	-
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151364-6	D	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
				-	-	-	-	-	-	-
2151364-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
				-	-	-	-	-	-	-
7-2151364-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: FORD TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, PIN AND RECEPTACLE

WIRE STRIP LENGTH

4.30-6.40 mm [.169-.252 IN]

INSULATION DIAMETER RANGE

Ø 2.13 [.084 IN] MAX

TERMINAL APPLICATION SPECIFICATION

NONE

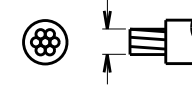
△4

TERMINALS APPLIED

△3

TE TERMINAL	FORD TERMINAL	TE TERMINAL	FORD TERMINAL
286521-2	1L2T-14461-AA	286526-1	F67B-14487-AA
286521-3	F6TB-14461-AB	349676-1	A47-6GA-F6
286521-4	E7EB-14461-CA		
TE TERMINAL	MOLEX TERMINAL		
1832536-1	33093-0009		

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

△9

16 AWG	1.32 +/- 0.05 [.052 +/- .002]	4.7
18 AWG	1.16 +/- 0.05 [.046 +/- .002]	5.6
0.75mm2	1.10 +/- 0.05 [.043 +/- .002]	6.1
20 AWG	1.04 +/- 0.05 [.041 +/- .002]	6.6

△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: 8-2151364-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151364-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151364-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151364-6

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 ITEMS 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.

△0

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

△1

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.

△2

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

△3

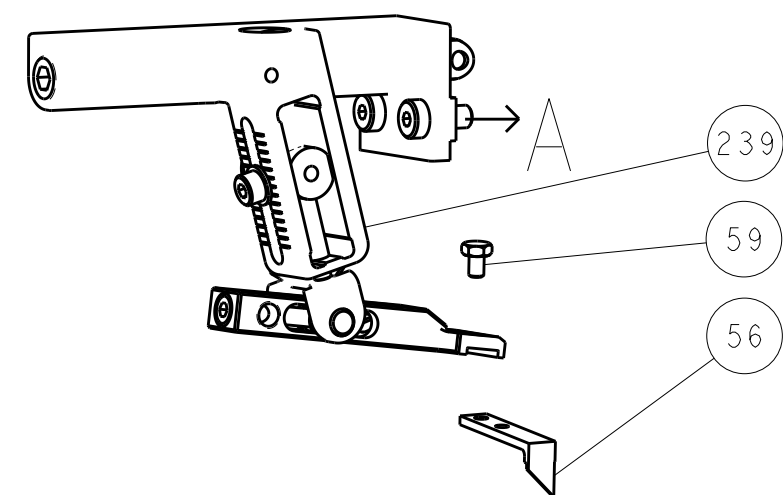
TERMINAL LUBRICANT IS RECOMMENDED.

△4

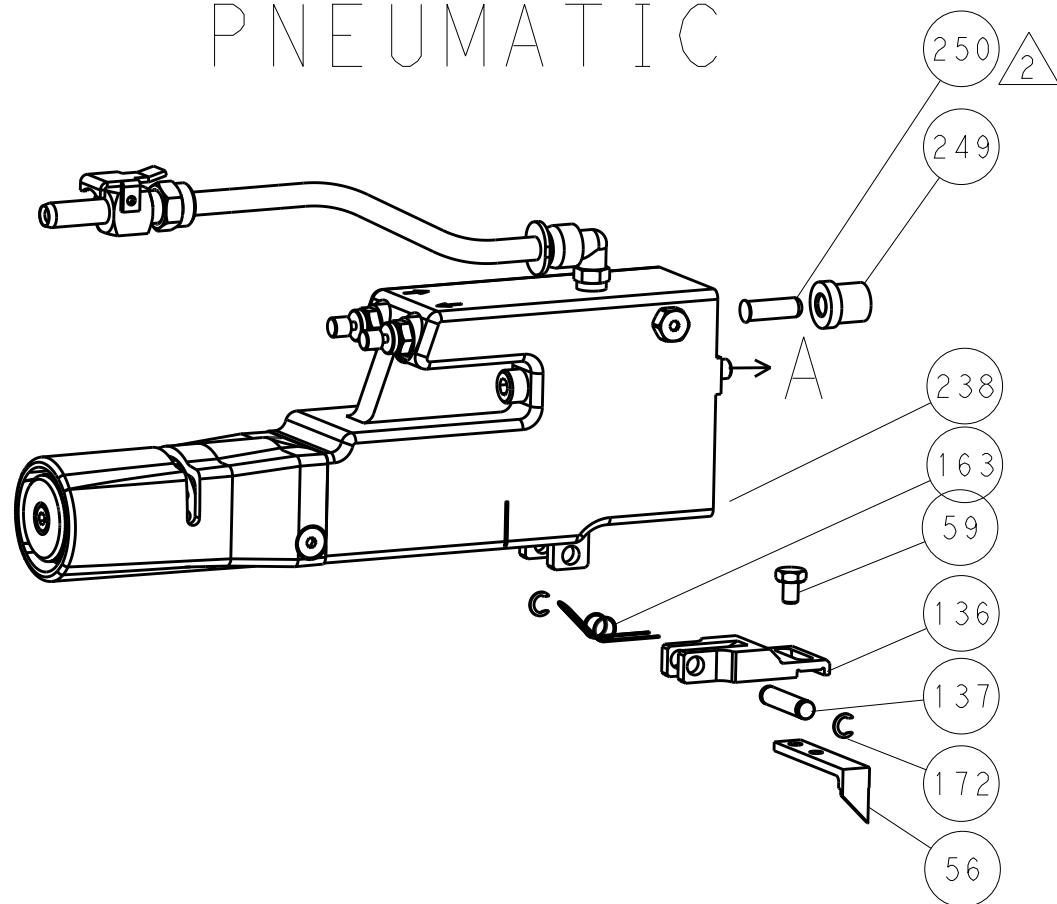
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-2		

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

FEED TYPE MECHANICAL



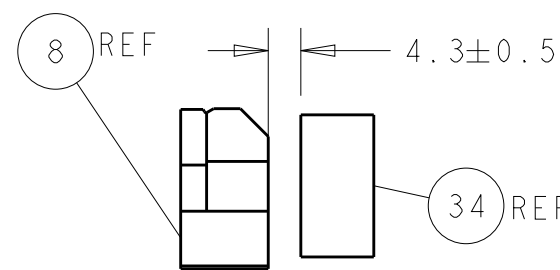
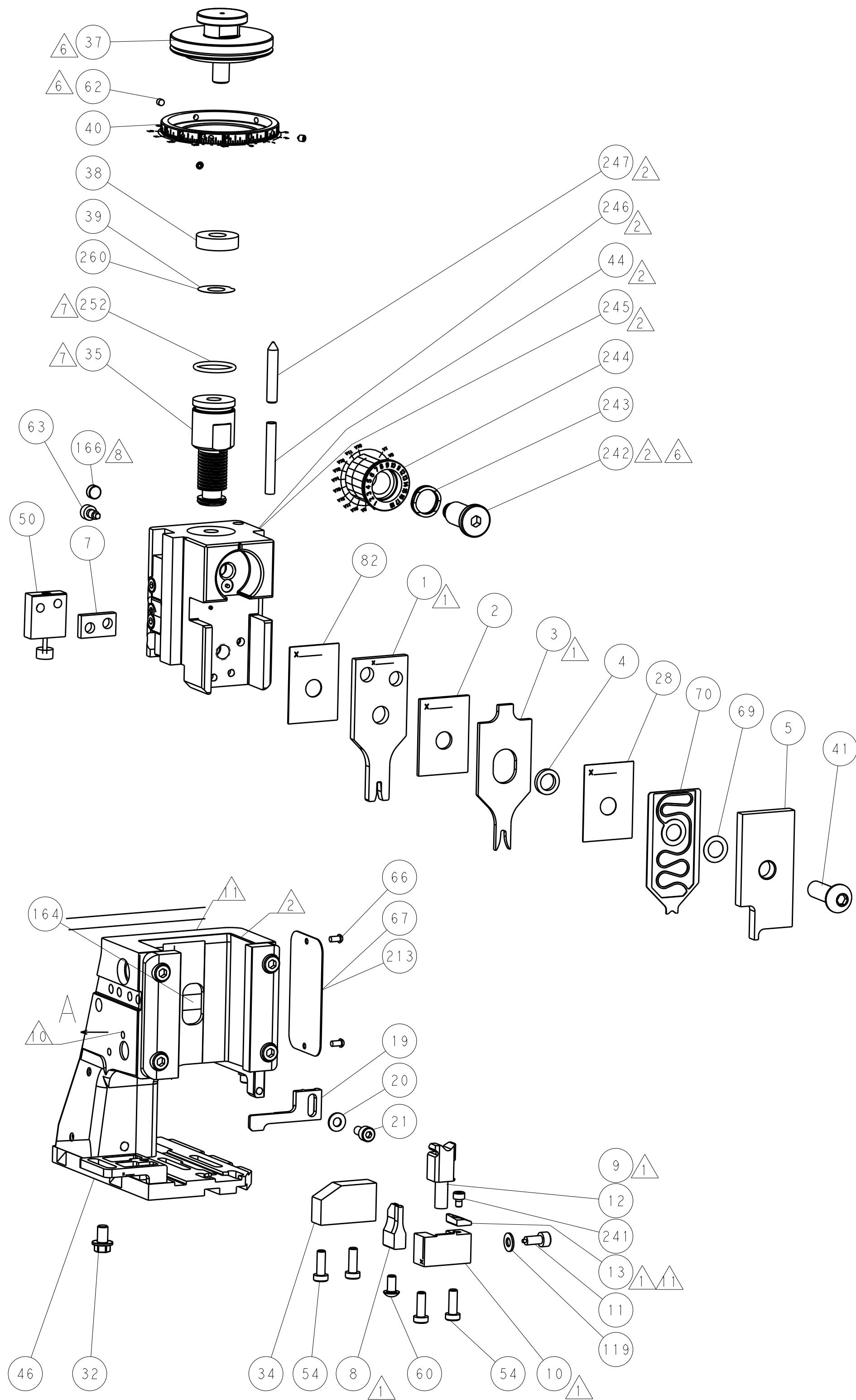
PNEUMATIC



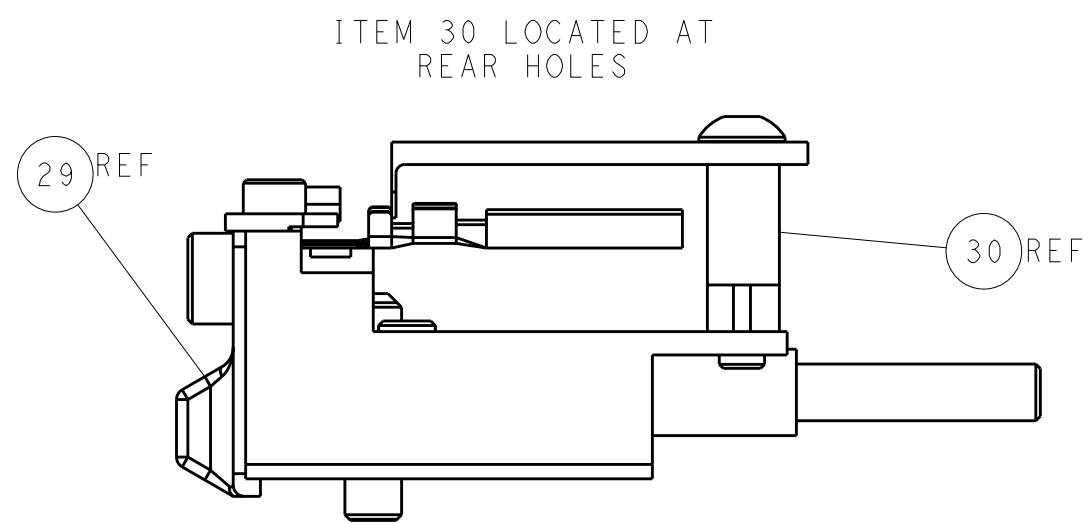
SERVO LATCH PLATE



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)

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CHK S. XI 16AUG2012				APVD S. XI 16AUG2012				NAME Ocean Side Feed Applicator			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC			
0 PLC				±				APPLICATION SPEC			
1 PLC				±				SIZE			
2 PLC				±				CAGE CODE			
3 PLC				±				DRAWING NO			
4 PLC				±				RESTRICTED TO			
ANGLES				±				A1			
FINISH				-				00779			
MATERIAL				-				C=2151364			
								Customer Accessible Production Drawing			
								SCALE 1:2			
								SHEET 2 OF 4			
								REV D			

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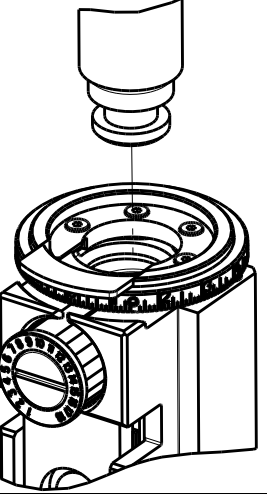
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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2151364-1

REVISION

D

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

CONVERT TO

SERVO LATCH PLATE

PART NUMBERS REQUIRED

2119951-1

-

8-2151364-5

1901094-3

-

2168400-6 (QUANTITY 2)

CONVERT TO

SMART APPLICATOR

PART NUMBERS REQUIRED

2161326-1

-

8-2151364-4

-

-

CONVERT TO

MECHANICAL FEED

PART NUMBERS REQUIRED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

CONVERT TO

SERVO LATCH PLATE

PART NUMBERS REQUIRED

2119951-1

-

8-2151364-5

1901094-3

-

2168400-6 (QUANTITY 2)

CONVERT TO

SMART APPLICATOR

PART NUMBERS REQUIRED

2161326-1

-

8-2151364-4

-

-

CONVERT TO

MECHANICAL FEED

PART NUMBERS REQUIRED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

CONVERT TO

-

PART NUMBERS REQUIRED

-

-

-

-

-

CONVERT TO

-

PART NUMBERS REQUIRED

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.03 mm [.080]

F

INSUL

2.79 mm [.110]

OV

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: FORD TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, PIN AND RECEPTACLE

WIRE STRIP LENGTH

4.30-6.40 mm [1.69-.252 IN]

INSULATION DIAMETER RANGE

2.13 [.084 IN] MAX

TERMINAL APPLICATION SPECIFICATION

NONE

-

-

TERMINALS APPLIED

-

-

TE TERMINAL

FORD TERMINAL

TE TERMINAL

FORD TERMINAL

286521-2

1L2T-14461-AA

286526-1

F67B-14487-AA

286521-3

F67B-14461-AB

349676-1

A47 6GA-F6

286521-4

E7EB-14461-CA

TE TERMINAL

MOLEX TERMINAL

1832536-1

33093-0009

WIRE SIZE

16 AWG

1.32+/-0.05 [.052+/-0.002]

4.7

WIRE SIZE

18 AWG

1.16+/-0.05 [.046+/-0.002]

5.6

WIRE SIZE

0.75mm2

1.10+/-0.05 [.043+/-0.002]

6.1

WIRE SIZE

20 AWG

1.04+/-0.05 [.041+/-0.002]

6.6

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: 8-2151364-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151364-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151364-5

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.
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.

-

1

1

1

1

2119782-1

FINE ADJUST HEAD ASM, PACIFIC STYLE

251

-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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION OF THIS DRAWING.

OWN

CHK

DATE

APVD

DATE

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

±

±

±

±

±

±

MATERIAL

-

WEIGHT

-

TE Connectivity

Harrisburg, PA 17105-3608

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

Customer Accessible Production Drawing

SCALE

1:2

SHEET

3

OF

4

REV

D

SET UP GAUGE

2119599-1

LOC

A

DIST

66

REVISIONS

P

LTR

DESCRIPTION

DATE

OWN

APVD

-

-

SEE SHEET 1

-

-

-

-

-

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-

-

-

1

-

1803259-1

BUSHING, FLANGED

249

-

1

1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

1

1

1

1

2119082-8

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

7-18023-7

SCR, SKT HD CAP M3 X 4.0

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

-

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

-

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

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

-

1

1

1

1

2119955-1

ASSY, LUBRICATOR, SIDE FEED

113

-

1

1

1

1

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

1

1

1

2119791-5

DEPRESSOR, WIRE

70

-

1

1

1

1

2119943-1

WASHER, SPACER

69

-

1

-

1

1

2119740-1

TAG,IDENTIFICATION

67

-

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 PNT, 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

-

2

2

2

2

2-2168083-5

SCR, SKT HD CAP, RoHS, M4 X 14

53

-

1

1

1

1

1803382-1

HOLD DOWN, SPRING LOADED

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

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

2119644-1

RAM WASHER, PRECISION

38

-

1

1

1

1

1-1752356-8

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

1-1320908-0

SPACER, STRIP GUIDE

30

-

1

1

1

1

2119959-9

ASSEMBLY, STRIP GUIDE

29

-

1

1

1

1

455888-3

SPACER, CRIMPER

28

-

1

1

1

1

1320928-6

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

1-356885-3

STOP, SHEAR

11

-

1

1

1

1

2119805-1

SHEAR HOLDER, FRONT

10

-

1

1

1

1

1803095-5

FLOATING SHEAR, FRONT

9

-

1

1

1

1

1

4-1633131-6

ANVIL, COMBINATION .080

8

-

1

1

1

1

1

240641-8

SPACER

7

-

-

-

-

-

-

-

6

-

1

1

1

1

2119757-8

DEPRESSOR, SHEAR

5

-

1

1

1

1

238011-5

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1

1-2119785-3

CRIMPER, INSULATION OVERLAP PREMIUM

3

-

1

1

1

1

1

1-455888-5

SPACER, CRIMPER

2

-

1

1

1

1

1

1-456405-3

CRIMPER, WIRE PREMIUM

1

-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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION OF THIS DRAWING.

OWN

CHK

DATE

APVD

DATE

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

±

±

±

±

±

±

MATERIAL

-

WEIGHT

-

TE Connectivity

Harrisburg, PA 17105-3608

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

Customer Accessible Production Drawing

SCALE

1:2

SHEET

3

OF

4

REV

D

SET UP GAUGE

2119599-1

LOC

A

DIST

66

REVISIONS

P

LTR

DESCRIPTION

DATE

OWN

APVD

-

-

SEE SHEET 1

-

-

-

-

-

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-

-

-

1

-

1803259-1

BUSHING, FLANGED

249

-

1

1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

1

1

1

1

2119082-8

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

7-18023-7

SCR, SKT HD CAP M3 X 4.0

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

-

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

-

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

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

-

1

1

1

1

2119955-1

ASSY, LUBRICATOR, SIDE FEED

113

-

1

1

1

1

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

1

1

1

2119791-5

DEPRESSOR, WIRE

70

-

1

1

1

1

2119943-1

WASHER, SPACER

69

-

1

-

1

1

2119740-1

TAG,IDENTIFICATION

67

-

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 PNT, M3 x 4.0

62

-

-

-

1

1

5-18022-5

SCR, HEX HD

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

D

C

B

A

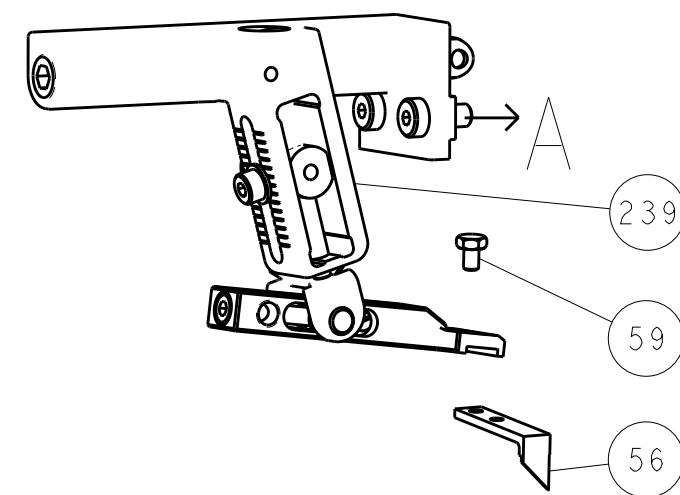
D

C

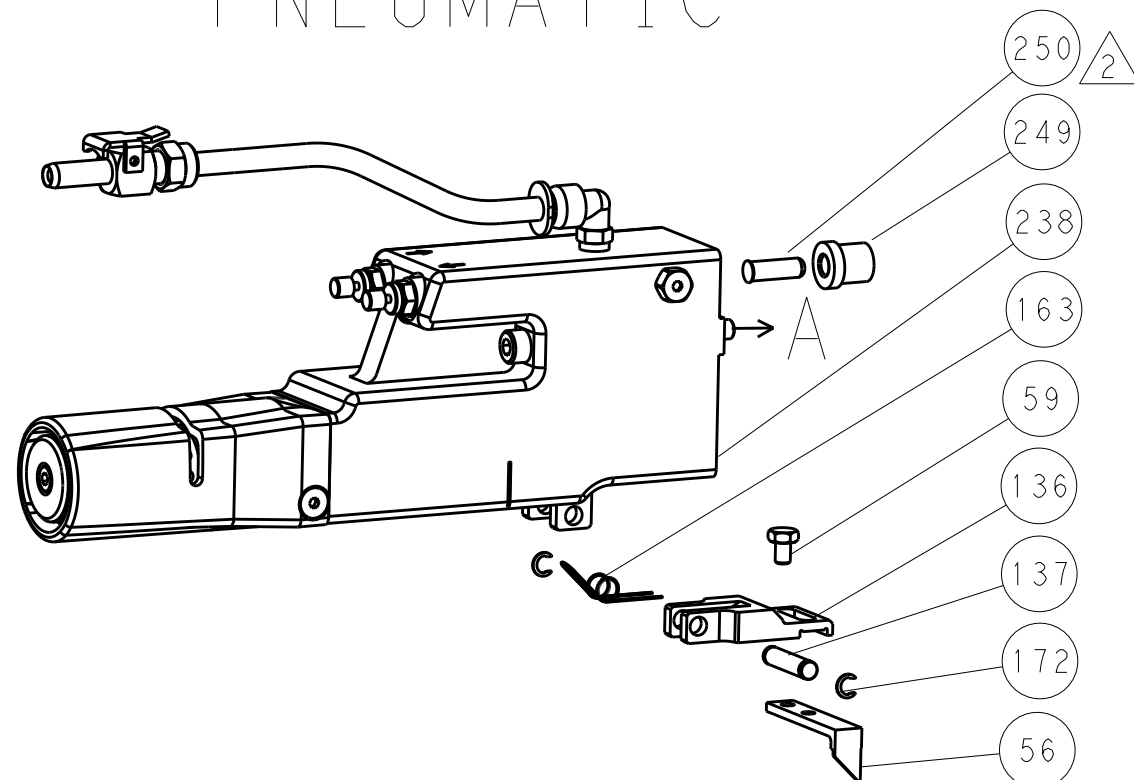
B

A

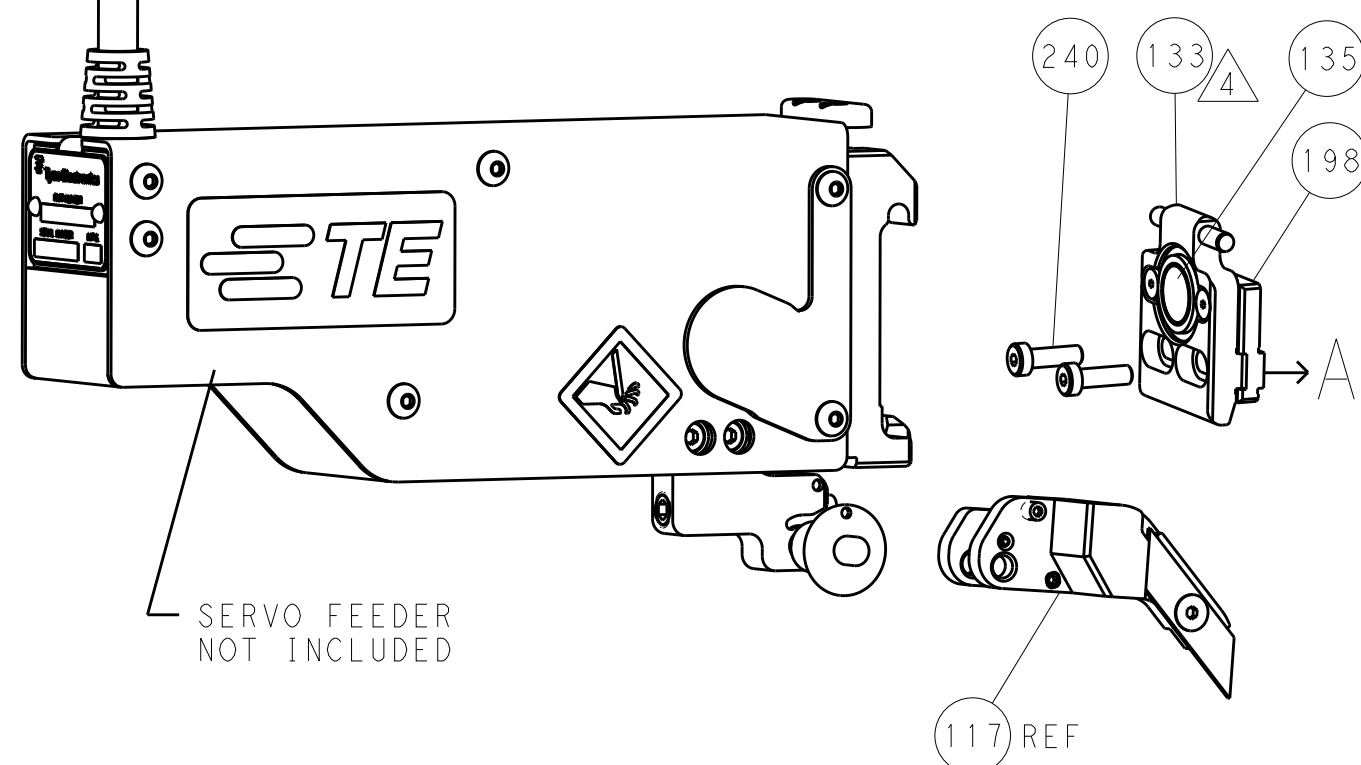
FEED TYPE MECHANICAL



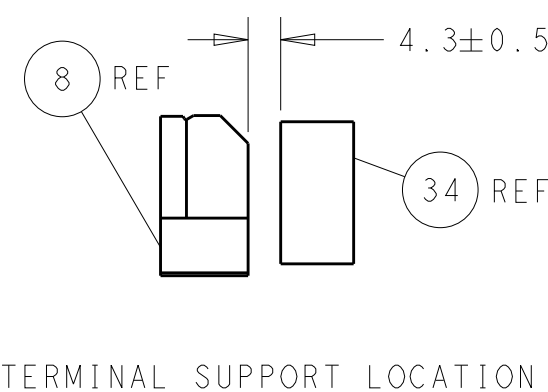
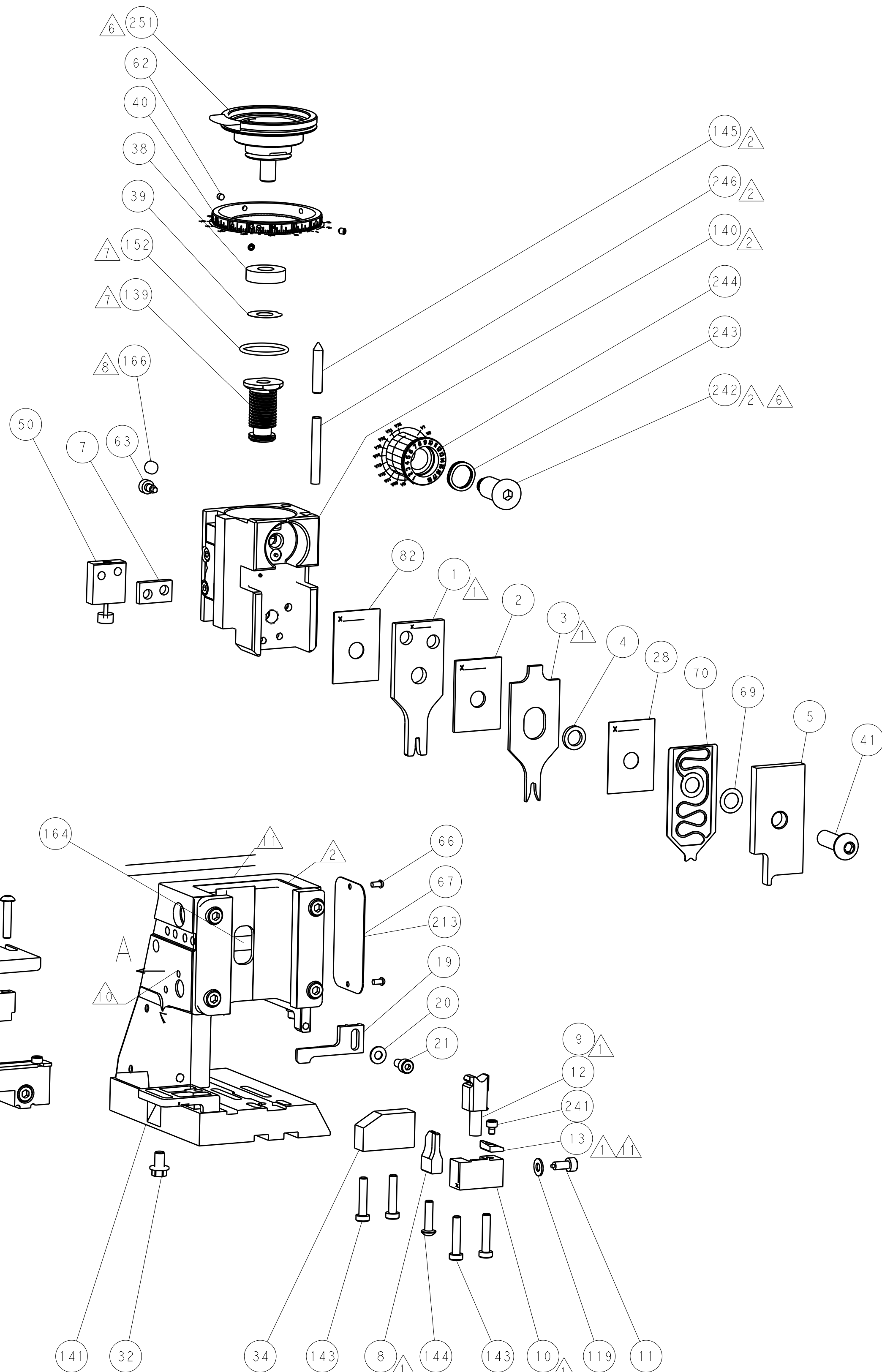
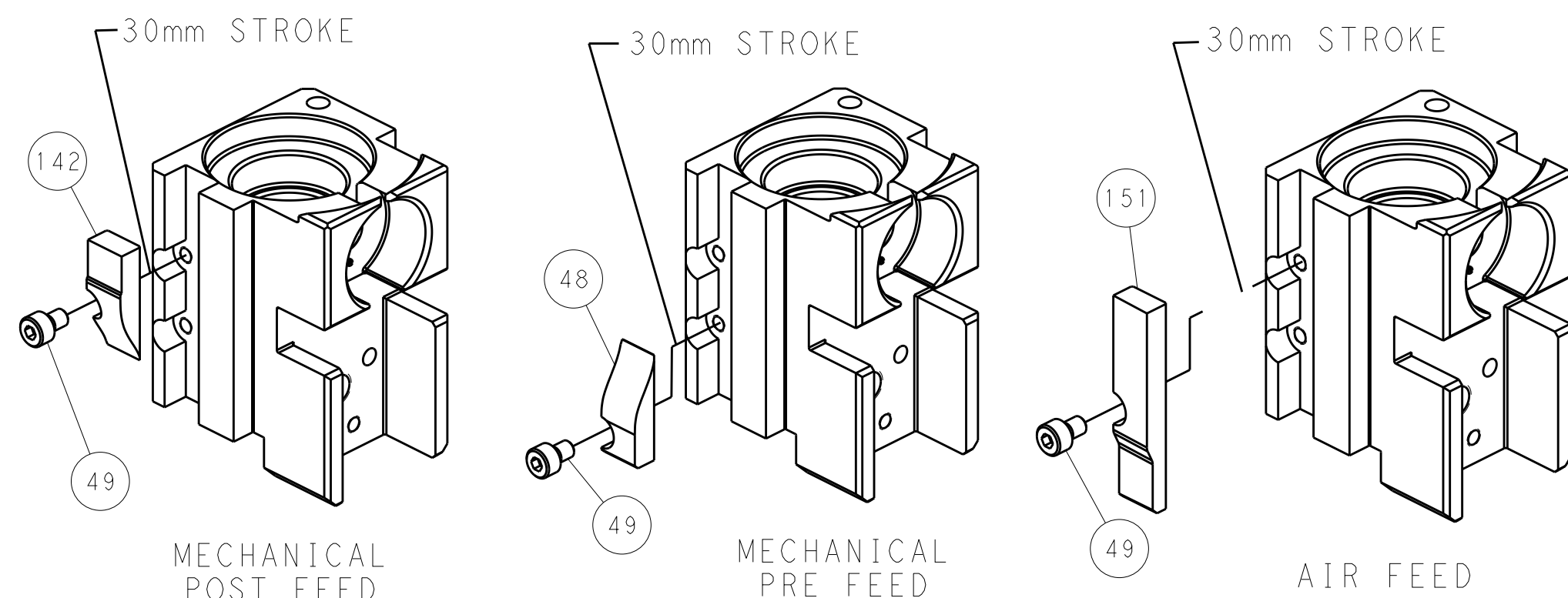
PNEUMATIC



SERVO LATCH PLATE

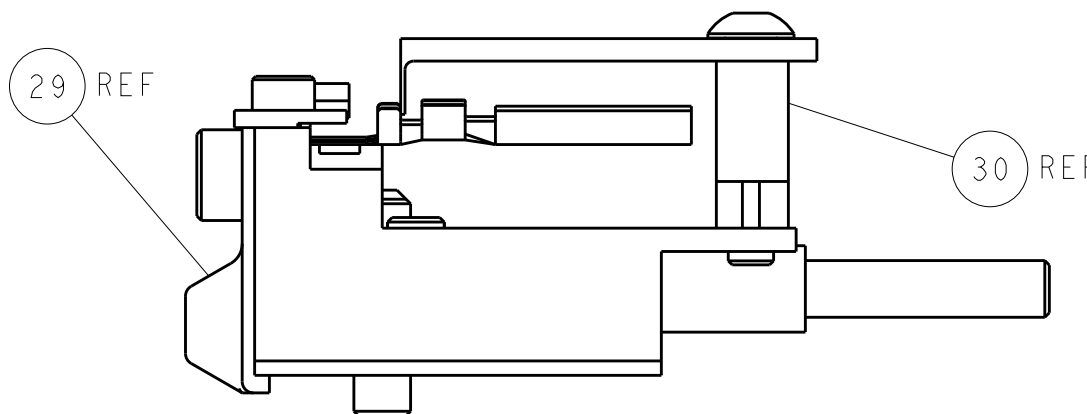


CAM POSITIONS



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT REAR HOLES



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)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG CHK S. XI APVD S. XI		16AUG2012 16AUG2012 16AUG2012		NAME Ocean Side Feed Applicator	
MATERIAL		FINISH		PRODUCT SPEC		APPLICATION SPEC		SIZE A1	
				WEIGHT		CAGE CODE 00779		DRAWING NO C=2151364	
				Customer Accessible Production Drawing		SCALE 1:2		SHEET 4	
								REV D	

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[2151364-1](#)