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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED

2151726-2

C

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE  
SMART APPLICATOR

2119951-1  
2161326-1

-  
-

8-2151726-5  
8-2151726-4

1901094-3  
-

-  
-

2168400-6 (QUANTITY 2)

2151726-5

C

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

PNEUMATIC FEED

2119950-1

1338683-8

5-18022-5

2119641-1

2119799-1

2063440-2

2151726-6

C

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

NONE

2151726-7

7-2151726-7

C

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 4.06 mm [ .160 ] F

INSUL 5.33 mm [ .210 ] OV

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: POSITIVE LOCK RECEPTACLE

WIRE STRIP LENGTH INSULATION DIAMETER RANGE

5.50-6.10 mm [ .217-.240 IN ] Ø4.00-5.30 mm [ .157-.209 IN ]

TERMINAL APPLICATION SPECIFICATION

114-18365

TERMINALS APPLIED

TE TERMINAL TE TERMINAL TE TERMINAL TE TERMINAL

928960-7 928960-8

WIRE SIZE

CRIMP HEIGHT mm [ INCH ]

CRIMP HEIGHT REFERENCE SETTING

6.00mm2 2.58+/-0.05 [ .102+/- .002 ] 6.7

5.50mm2 2.48+/-0.05 [ .098+/- .002 ] 7.8

5.00mm2 2.39+/-0.05 [ .094+/- .002 ] 8.6

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:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151726-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151726-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151726-6

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242.  
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

TERMINAL PITCH IS NOT COMPATIBLE WITH MECHANICAL FEED.

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.22.

THIS IS A DOUBLE WIRE COMBINATION.

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

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REVISIONS

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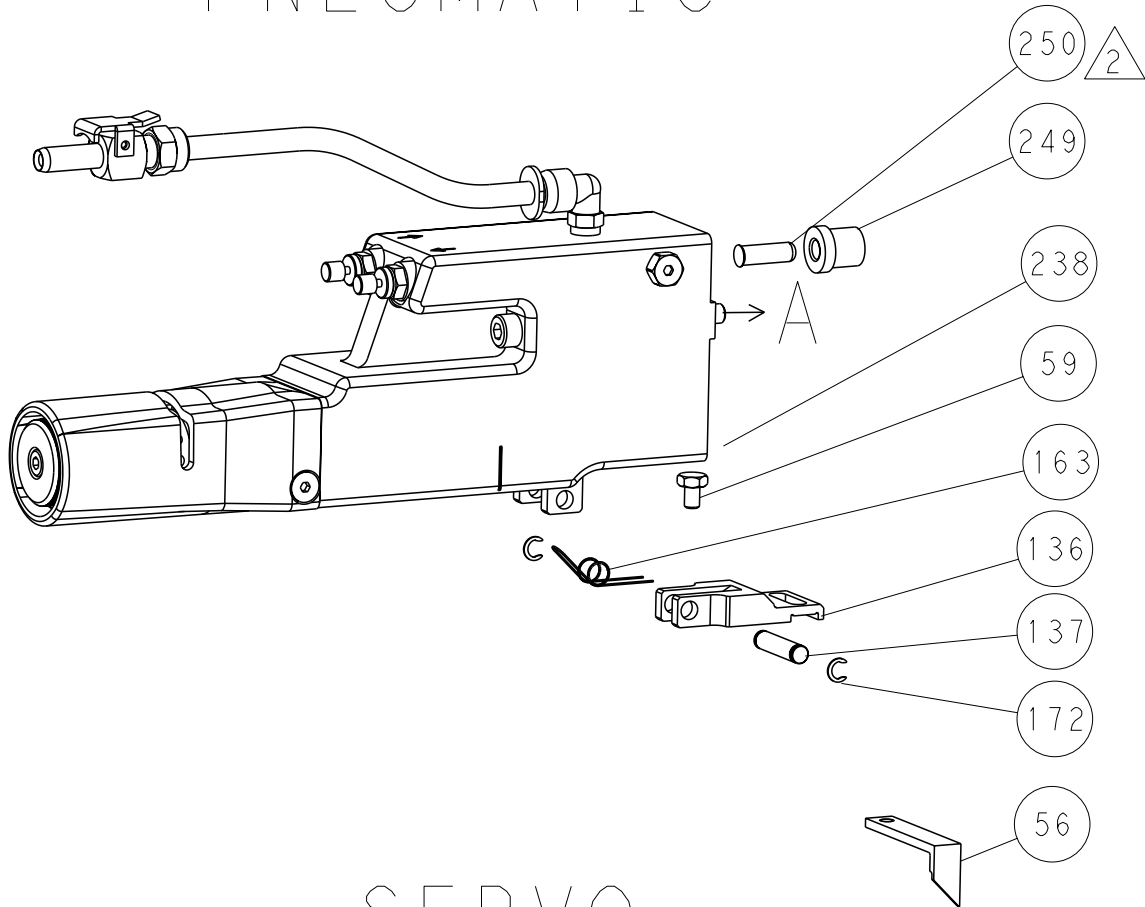
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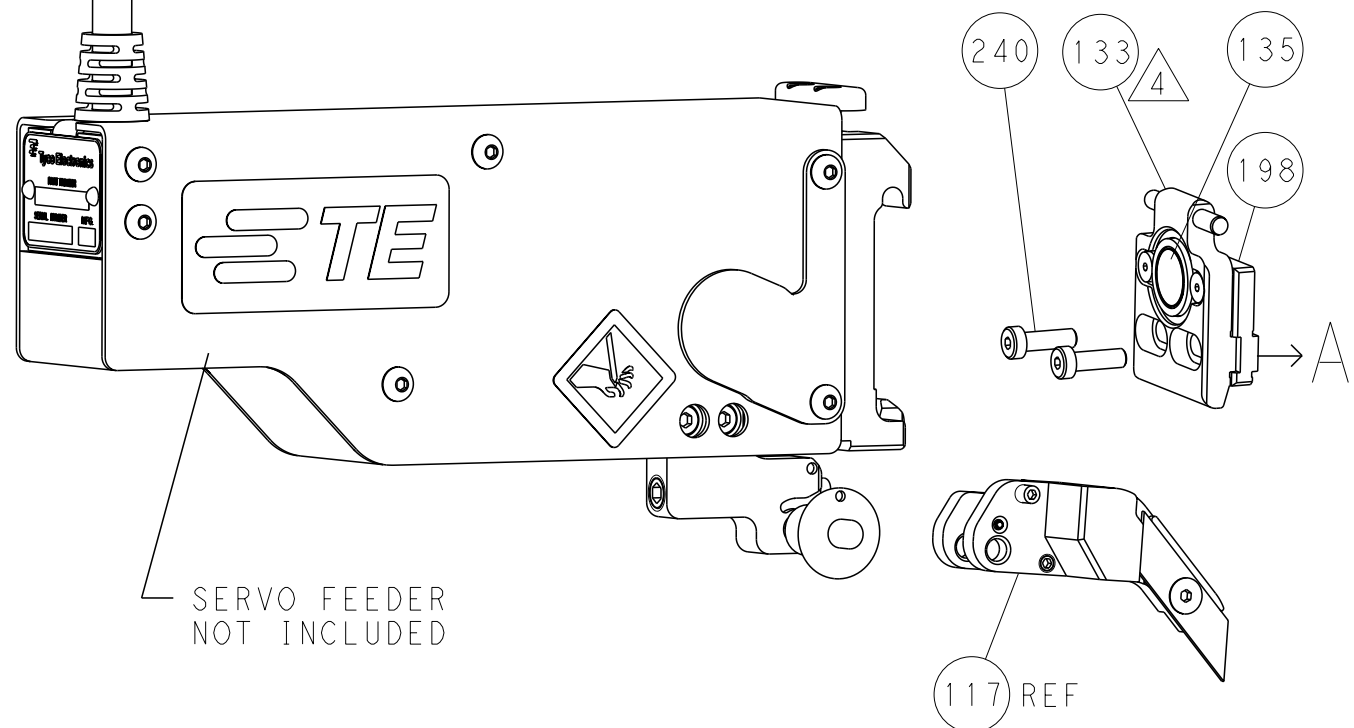
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A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

FEED TYPE

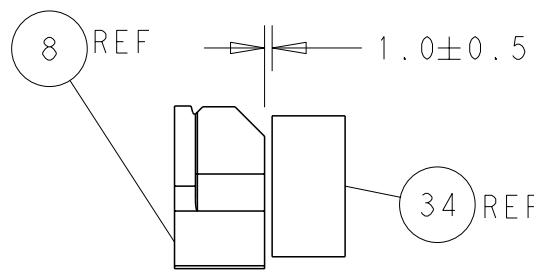
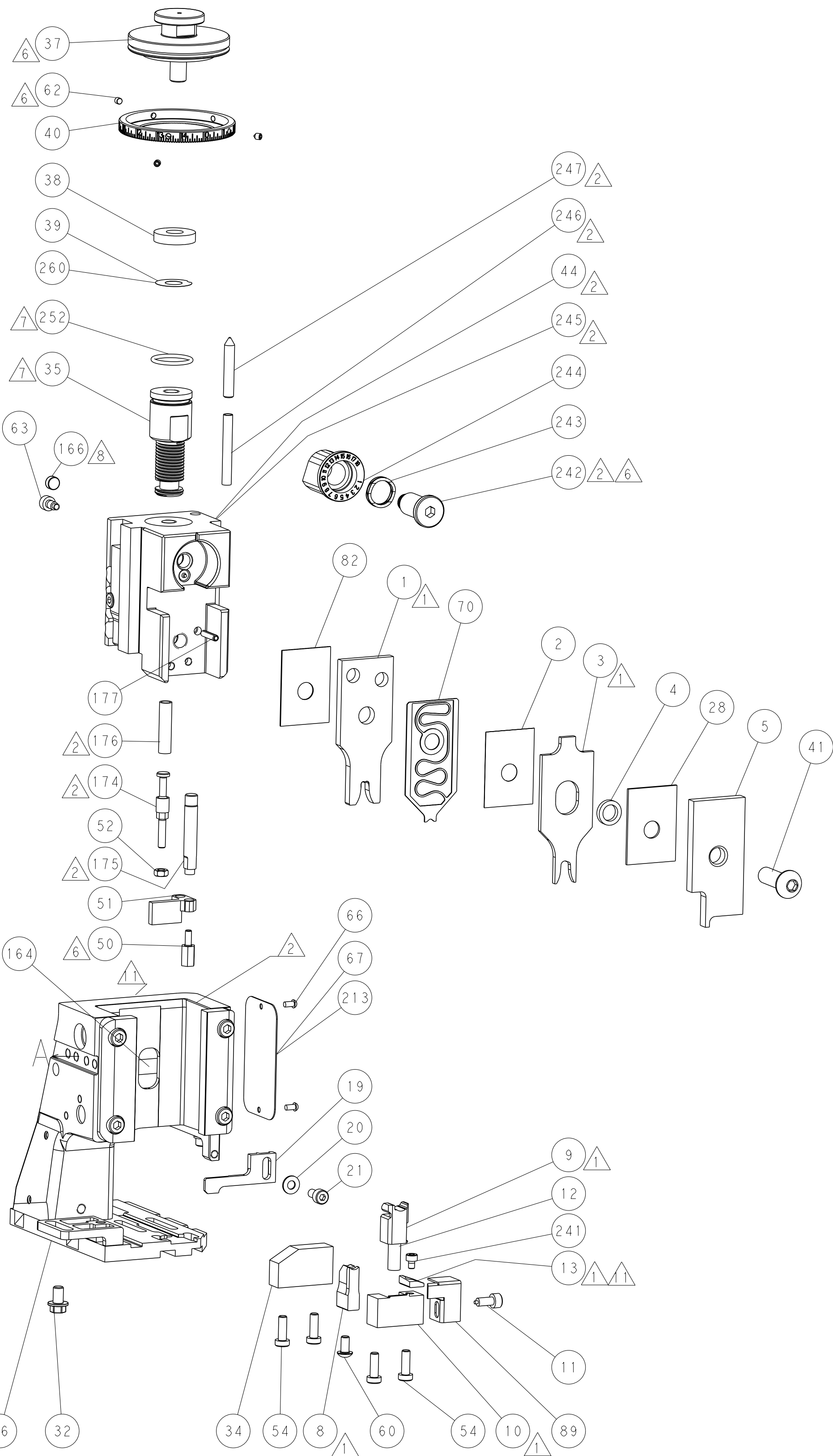
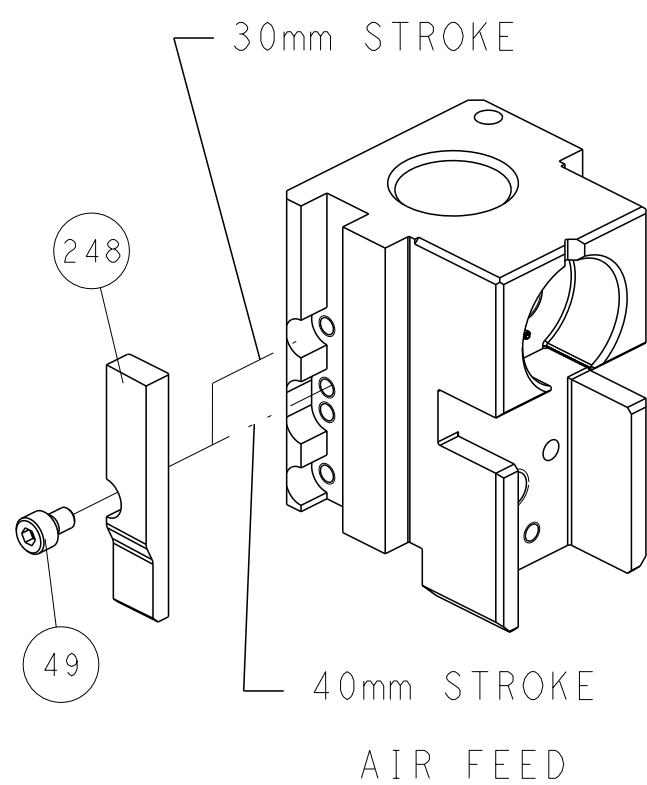
PNEUMATIC



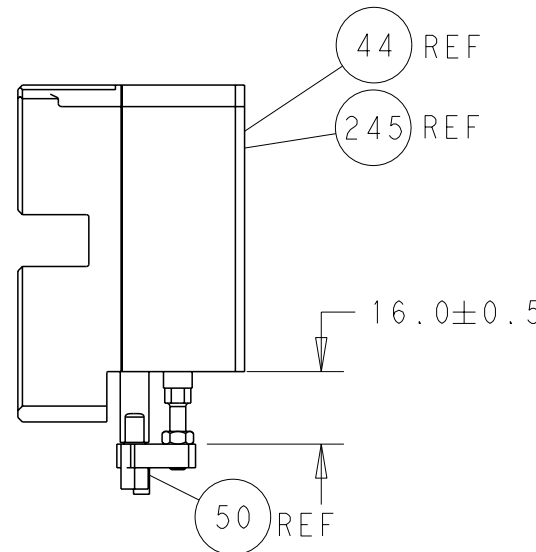
SERVO LATCH PLATE



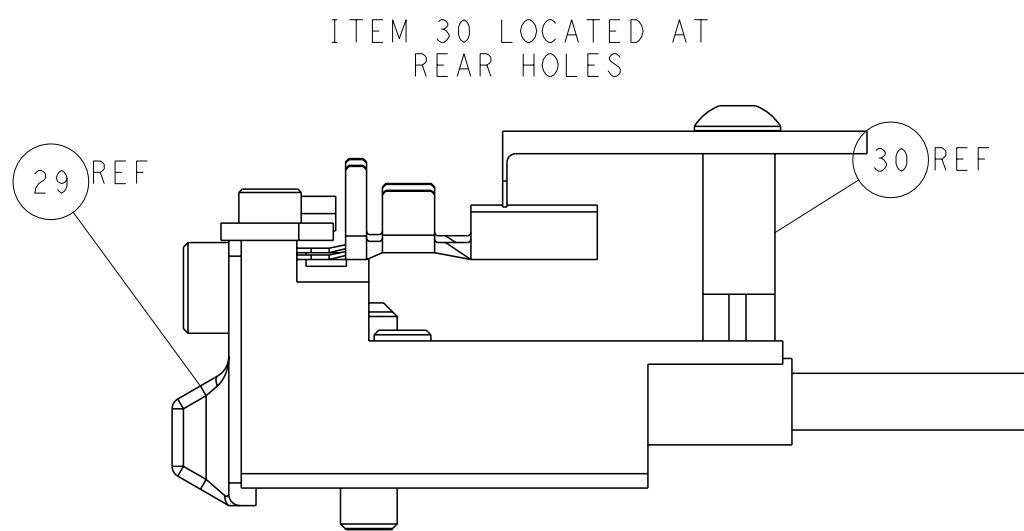
CAM POSITION



TERMINAL SUPPORT LOCATION

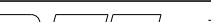



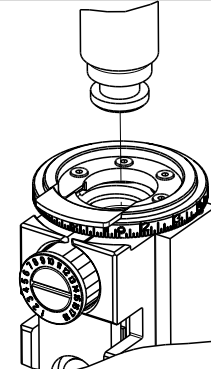

HOLDDOWN SET-UP




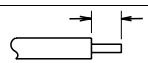


FEED TRACK POSITION GUIDE BY WIRE BARREL





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

1. THIS DRAWING IS A CONTROL DOCUMENT FOR INTERFACED PARTS CORPORATION AND IS THE PROPERTY OF INTERFACED PARTS CORPORATION. IT IS TO BE USED ONLY FOR THE PARTS SPECIFICALLY IDENTIFIED HEREON.				DWN K. HUANG 31OCT2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:				CHK S.XI 31OCT2012			
mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC - APPLICATION SPEC -			
MATERIAL		-		WEIGHT		RESTRICTED TO	
-		-		-		-	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 2 of 4 REV C	











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© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.									
<div>PACIFIC VERSION TERMINATOR INTERFACE ADAPTER</div> <div></div>	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151726-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151726-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2151726-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	SMART APPLICATOR	2161326-1	-	8-2151726-4	-	-	-
					-	-	-	-	-	-	-
	2-2151726-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151726-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [ .160 ]	F
INSUL	5.33 mm [ .210 ]	OV
APPLICATOR INSTRUCTIONS  408-10389		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE	
5.50-6.10 mm [ .217-.240 IN ]		Ø4.00-5.30 mm [ .157-.209 IN ]	
TERMINAL APPLICATION SPECIFICATION 	114-18365	-	-
TERMINALS APPLIED 	-	-	-
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928960-7	928960-8		

WIRE SIZE 	CRIMP HEIGHT mm [ INCH ] 	CRIMP HEIGHT REFERENCE SETTING 
6.00mm2	2.58+/-0.05 [ .102+/- .002 ]	6.7
 5.50mm2	2.48+/-0.05 [ .098+/- .002 ]	7.8
5.00mm2	2.39+/-0.05 [ .094+/- .002 ]	8.6








-  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:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151726-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151726-5
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 50, 62 & 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.
-  TERMINAL PITCH IS NOT COMPATIBLE WITH MECHANICAL FEED.
-  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.
-  THIS IS A DOUBLE WIRE COMBINATION.

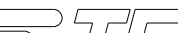
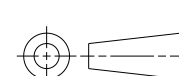
\*WARNING  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-77	-27	-25	-22	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 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LYR	DESCRIPTION	DATE
			-	-	SEE SHEET 1	-

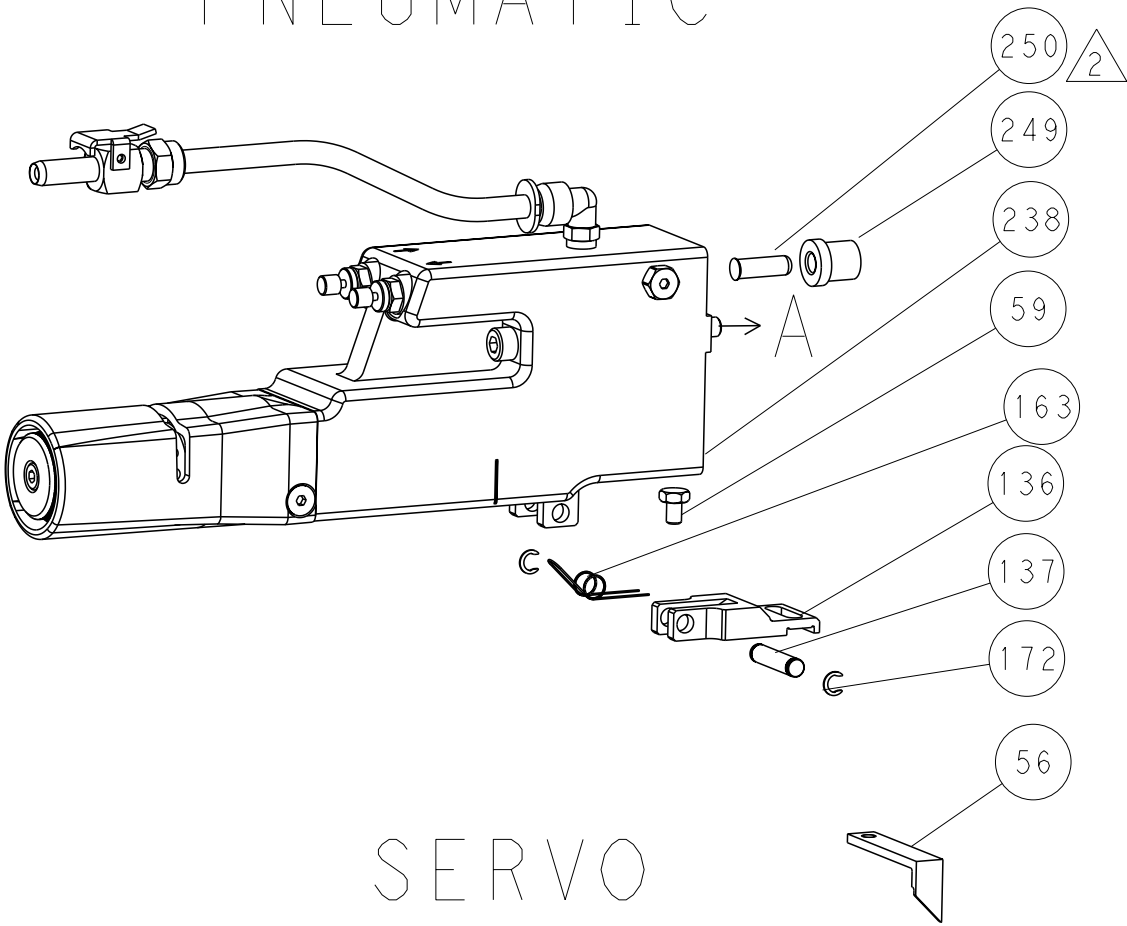
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG,IDENTIFICATION	213
-	-	1	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	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	2119798-2	DETENT PIN	145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	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
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	318563-1	GUARD, FRONT CHIP	89
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	-	1	2119740-1	TAG,IDENTIFICATION	67
-	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	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1338683-8	FEED PAWL	56
-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1976052-1	HOLDDOWN,TERMINAL	51
-	1	1	1	2-1752354-4	STANDOFF,HOLD-DOWN	50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	2119644-3	RAM WASHER, PRECISION	38
-	1	1	1	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1-1320908-8	SPACER, STRIP GUIDE	30
-	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-3	STOP, SHEAR	11
 -	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
 -	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
 1	1	1	1	1633216-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	1	6-238011-0	BLOCK, CRIMPER SPACER	4
 1	1	1	1	4-1803221-9	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	455888-1	SPACER, CRIMPER	2
 1	1	1	1	2-657555-1	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK S. XI	31OCT2012	NAME  Ocean Side Feed Applicator	RESTRICTED TO		
mm		0 PLC ±		APVD S. XI	31OCT2012				
		1 PLC ±		PRODUCT SPEC					
		2 PLC ±		APPLICATION SPEC					
		3 PLC ±				SIZE A1	CAGE CODE 00779		
		4 PLC ±							
		FINISH	±	WEIGHT		DRAWING NO ©=2151726			
MATERIAL						-			
-						-			
-						-			
Customer Accessible Production Drawing				SCALE		1:2	SHEET		
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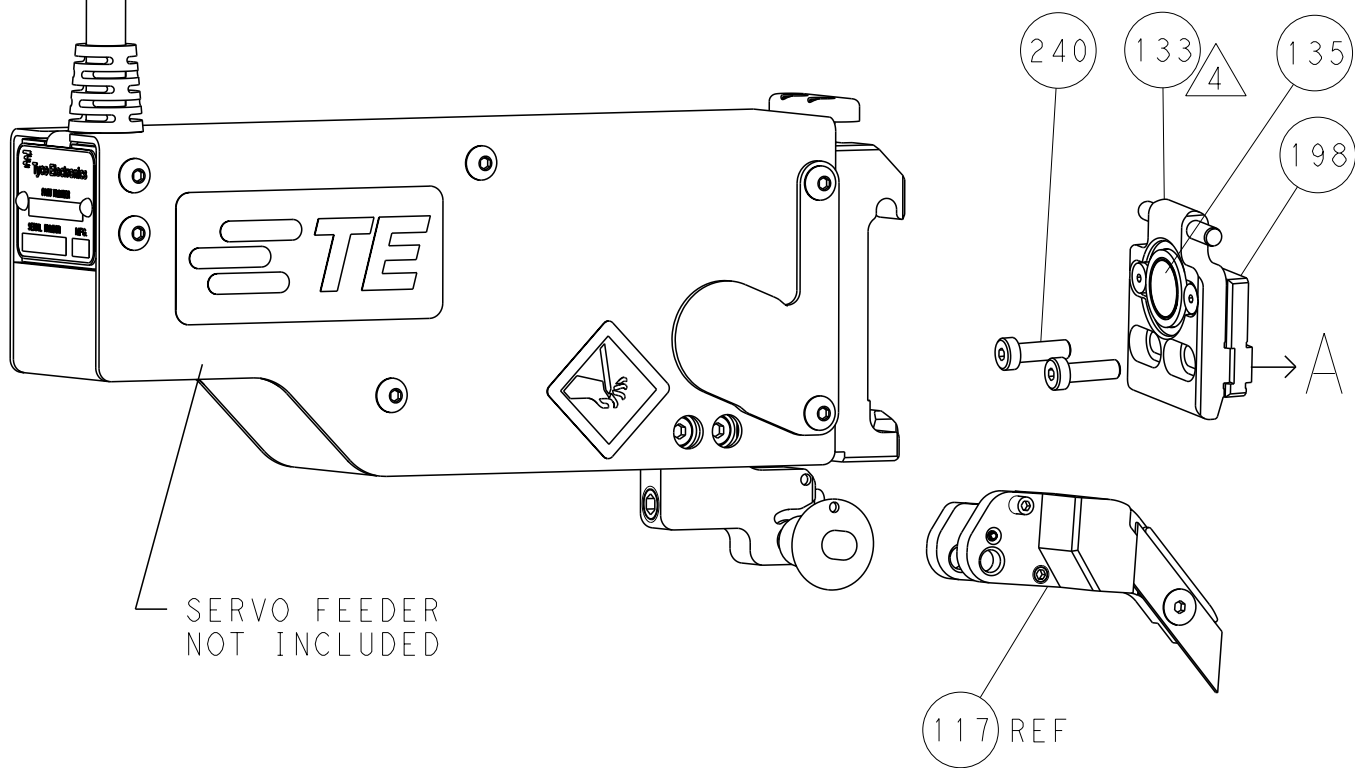
LOC		DIST	REVISIONS					
A		66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-		SEE SHEET 1	-	-	-

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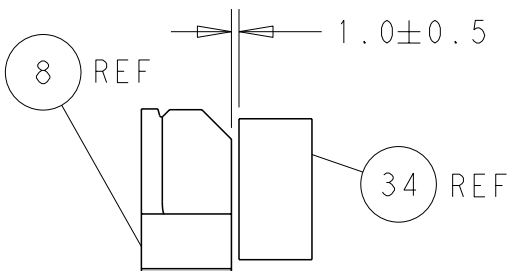
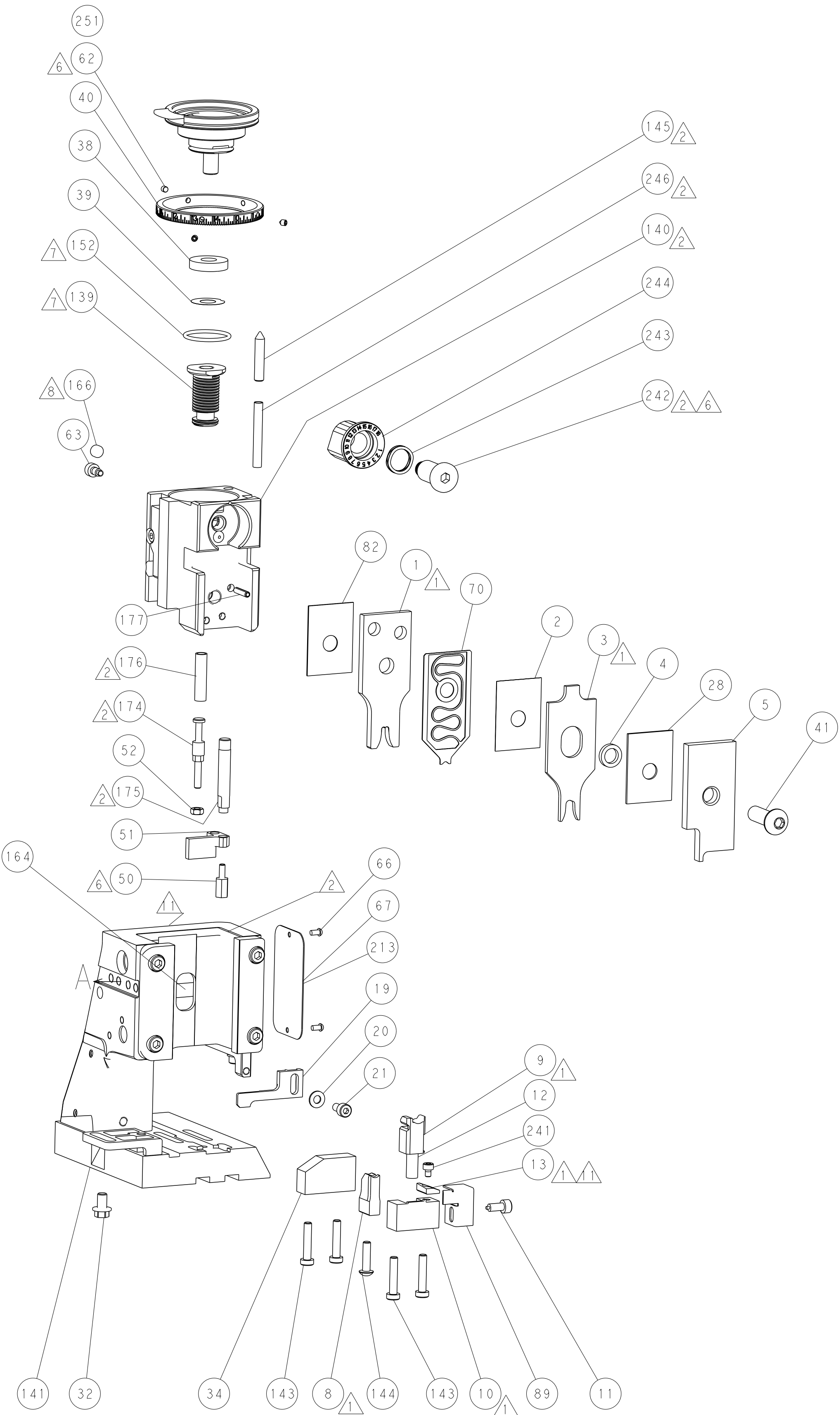
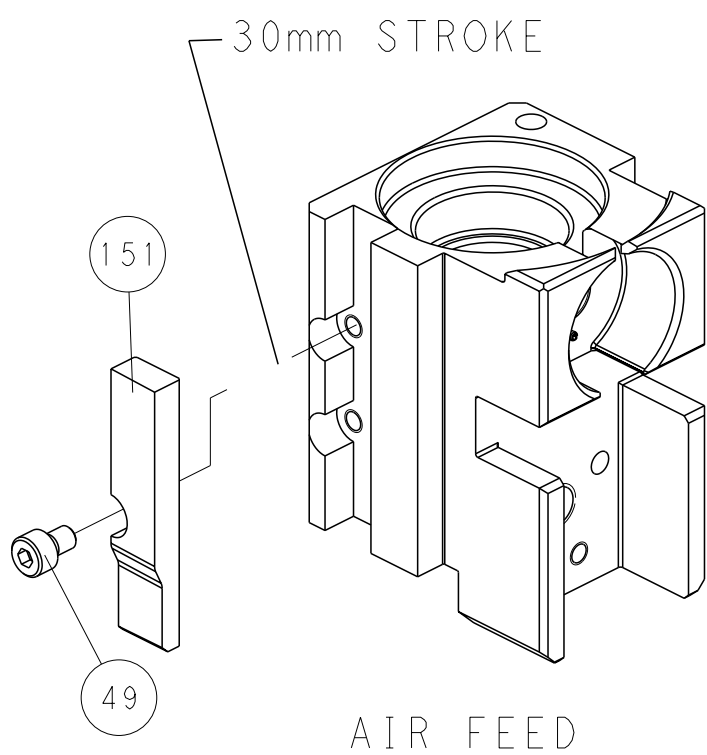
PNEUMATIC



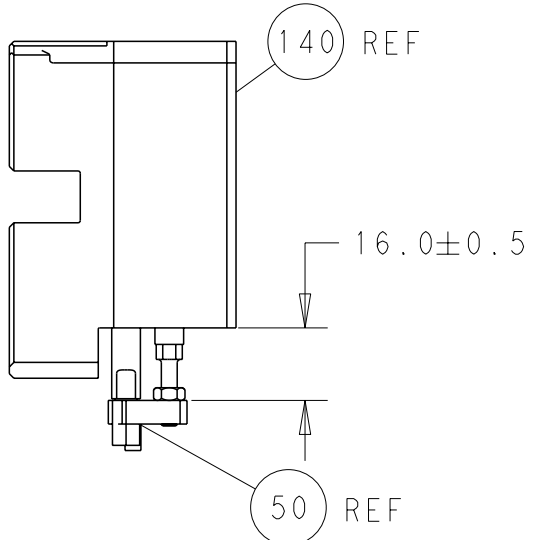
SERVO LATCH PLATE



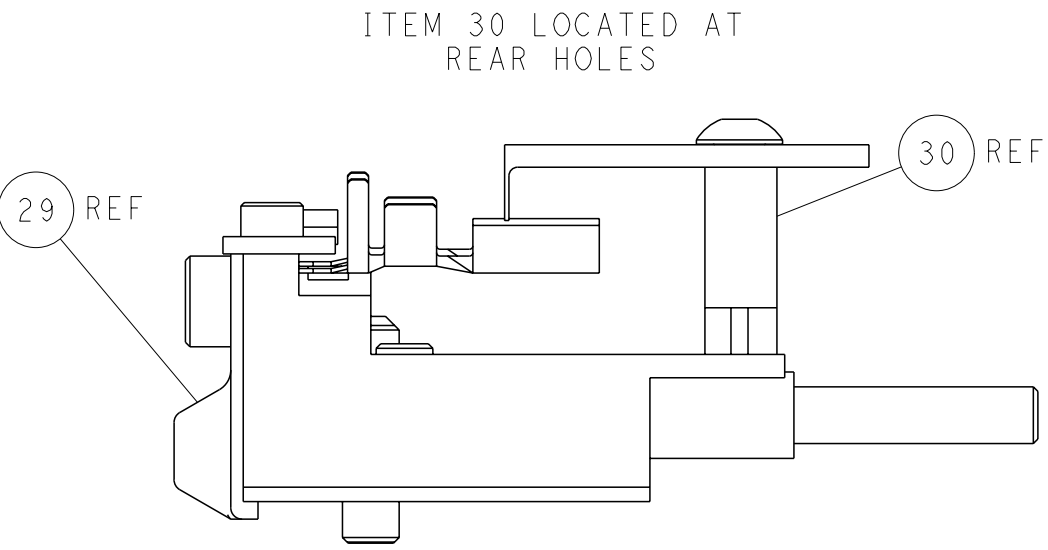
CAM POSITION



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

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				CHK S. XI	31OCT2012			
				APVD S. XI	31OCT2012	NAME Ocean Side Feed Applicator		
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		
				0 PLC ±		APPLICATION SPEC		
				1 PLC ±				
				2 PLC ±				
				3 PLC ±				
				4 PLC ±				
				ANGLES				
				FINISH				
MATERIAL						WEIGHT		
						Customer Accessible Production Drawing		
						SCALE 1:2		
						SHEET 4 OF 4		
						REV C		

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