

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151612-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2151612-5	1901094-3	-	2168400-6 (QUANTITY 2)	
	2151612-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SMART APPLICATOR	2161326-1	-	8-2151612-4	-	-	-	-
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
					SERVO LATCH PLATE	2119951-1	-	8-2151612-5	1901094-3	-	2168400-6 (QUANTITY 2)	
	2151612-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SMART APPLICATOR	2161326-1	-	8-2151612-4	-	-	-	-
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
	2151612-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	-
					-	-	-	-	-	-	-	
	2151612-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
	7-2151612-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
1.96 mm	[.077]	F
2.67 mm	[.105]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH 5.00-5.02 mm [.197-.198 IN]	INSULATION DIAMETER RANGE Ø1.96-2.64 mm [.077-.104 IN]
TERMINAL APPLICATION SPECIFICATION	DELPHI SPECIFICATION
TERMINALS APPLIED	
TE TERMINAL	DELPHI TERMINAL
1642331-1	12110844

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.50 +/- 0.05 [.059 +/- .002]	8.7
0.80mm2	1.40 +/- 0.05 [.055 +/- .002]	9.6

- 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: 8-2151612-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151612-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151612-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151612-6
- 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 ITEM 50.
- 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

**\*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.

ITEM NO	DESCRIPTION	ITEM NO
260	APPLICATOR SHIM PACK	260
252	O-RING, .676 ID, .070 DIA. MAT.	252
250	PUSH ROD, AIR FEED	250
249	BUSHING, LCH5-12, MISUMI	249
248	FEED CAM, AIR FEED	248
247	DETENT PIN	247
246	SPRING, COMPRESSION	246
245	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-77	PART NO	

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

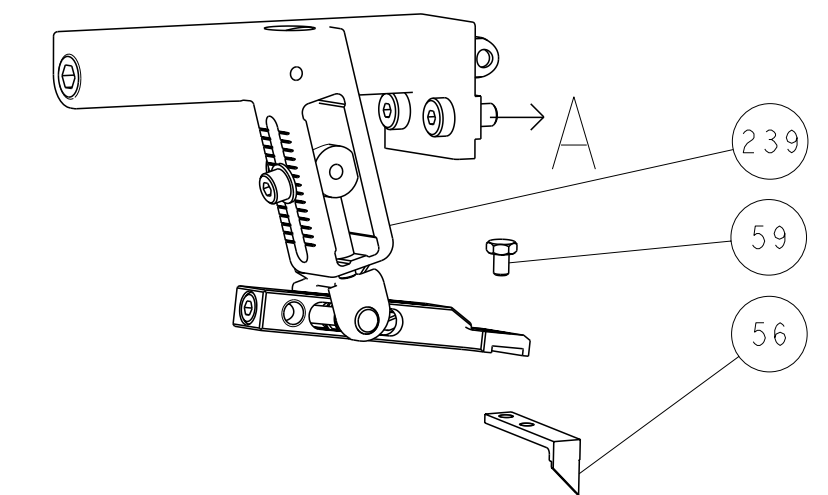
SET UP GAUGE	LOC	DIST	REVISIONS				
2119599-1	A	66	P LTR	DESCRIPTION	DATE	DWN	APVD
			A	RELEASED	24APR2012	LG	GB

ITEM NO	DESCRIPTION	ITEM NO
244	CAM, SNAIL, INSULATION ADJUSTMENT	244
243	WASHER, WAVE SPRING, CREST-TO-CREST	243
242	RETAINER, INSULATION DIAL	242
241	SCR, SKT HD CAP M3 X 5.0	241
240	SHCS, LOW HEAD, RoHS, M5 X 16	240
239	MECHANICAL FEED ASSEMBLY	239
238	AIR FEED MODULE	238
213	TAG, IDENTIFICATION	213
198	SPACER, FEEDER	198
177	PIN, SLOTTED SPRING 3.0 X 20.0	177
176	SPRING, COMPRESSION	176
175	GUIDE PIN, HOLDDOWN	175
174	GUIDE PIN, HOLDDOWN	174
172	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
166	MAGNET, RARE EARTH HIGH ENERGY	166
164	COUNTER, MAGNETIC	164
163	SPRING, FEED FINGER	163
137	PIN, RETAIN, GRVD, 3/16 X .854	137
136	HOLDER, FEED FINGER, AF	136
135	MEMORY CHIP, PROGRAMMED	135
133	SERVO FEED LATCH ASM	133
120	SPACER, CRIMPER	120
119	WASHER, FLAT, REG M4	119
117	FEED FINGER ASSEMBLY, SF	117
82	SPACER, CRIMPER	82
71	DOCUMENTATION PACKAGE	71
70	DEPRESSOR, WIRE	70
69	WASHER, SPACER	69
67	TAG, IDENTIFICATION	67
66	SCREW, DRIVE, RH, RoHS	66
63	LIMITER, ADJUSTMENT BOLT	63
62	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
60	SCR, BHSC, RoHS (M4 X 8)	60
59	SCR, HEX HD CAP, M4 X 6.0	59
56	PAWL, FEED	56
54	SHCS, LOW HEAD, RoHS, M4 X 12	54
52	NUT, HEX, REG, RoHS, M3.5	52
51	HOLDDOWN, TERMINAL	51
50	STANDOFF, HOLD-DOWN	50
49	SCR, SKT HD CAP M4 X 6.0	49
48	FEED CAM, PRE FEED	48
47	FEED CAM, POST FEED	47
46	APPLICATOR BASIC ASSEMBLY, SF	46
44	RAM, AMP STYLE, SIDE FEED	44
41	SCR, BHSC, RoHS (M8 X 25)	41
40	DISC, NUMBERED FA WIRE ADJUSTMENT	40
39	APPLICATOR SHIM PACK	39
38	RAM WASHER, PRECISION	38
37	FA HEAD, ATLANTIC STYLE	37
35	BOLT, ADJUSTMENT	35
34	SUPPORT, TERMINAL	34
33	SCR, BHSC, RoHS (M4 X 20)	33
32	HEX HEAD, FLANGED, M5 X 8mm LONG	32
30	SPACER, STRIP GUIDE	30
29	ASSEMBLY, STRIP GUIDE	29
28	SPACER, CRIMPER	28
24	PLATE, STRIP GUIDE	24
21	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
20	WASHER, FLAT, REG M4	20
19	STRIPPER, SIDE FEED	19
13	INSERT, SHEAR	13
12	SPRING, COMPRESSION	12
11	STOP, SHEAR	11
10	SHEAR HOLDER, FRONT	10
9	FLOATING SHEAR, FRONT	9
8	ANVIL, COMBINATION	8
7	-	7
6	-	6
5	DEPRESSOR, SHEAR	5
4	BLOCK, CRIMPER SPACER	4
3	CRIMPER, INSULATION F PREMIUM	3
2	SPACER, CRIMPER	2
1	CRIMPER, WIRE PREMIUM	1

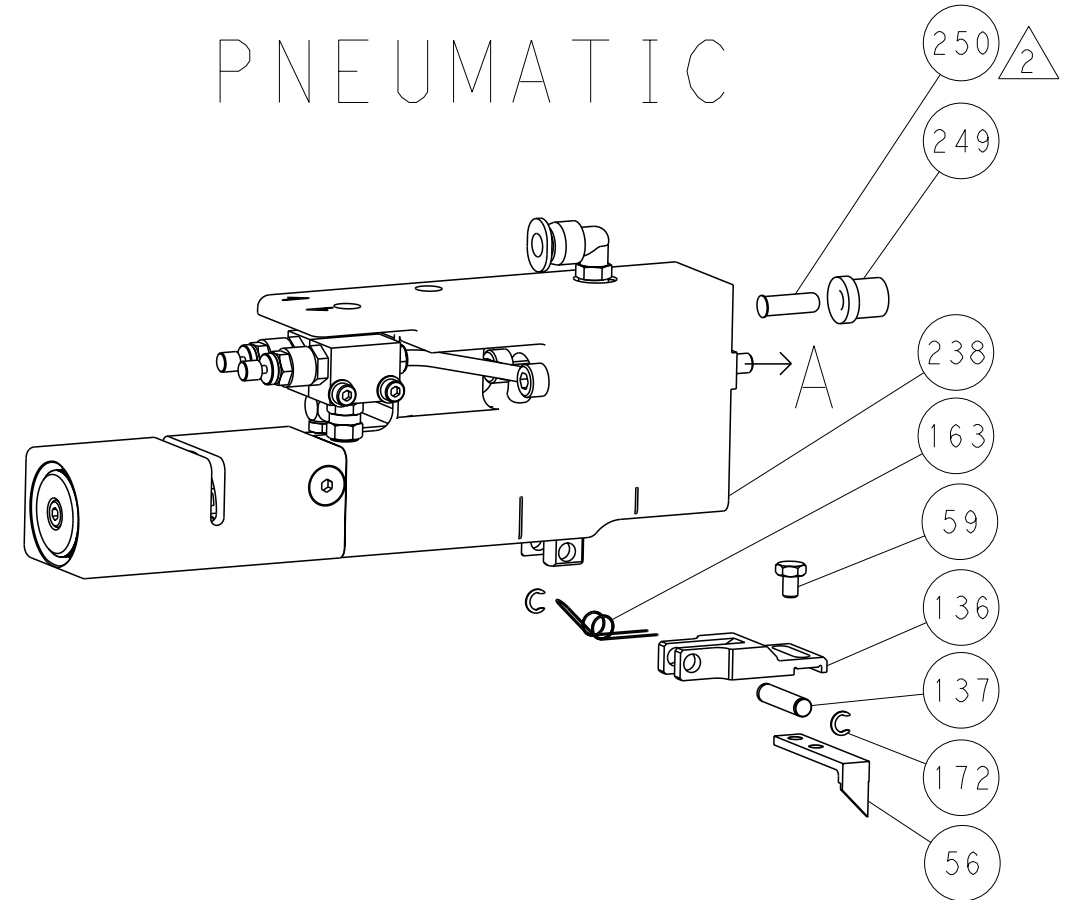
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ±.1 7 PLC ±0.1 5 PLC ±0.02 4 PLC ±0.005 ANGLES ±.0005 FINISH	DWN: J.YIN 15FEB2012 CHK: G.BALLEY 15FEB2012 APVD: S.LI 15FEB2012 PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151612 RESTRICTED TO: CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:1 SHEET: 1 OF 4 REV: A
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LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1			

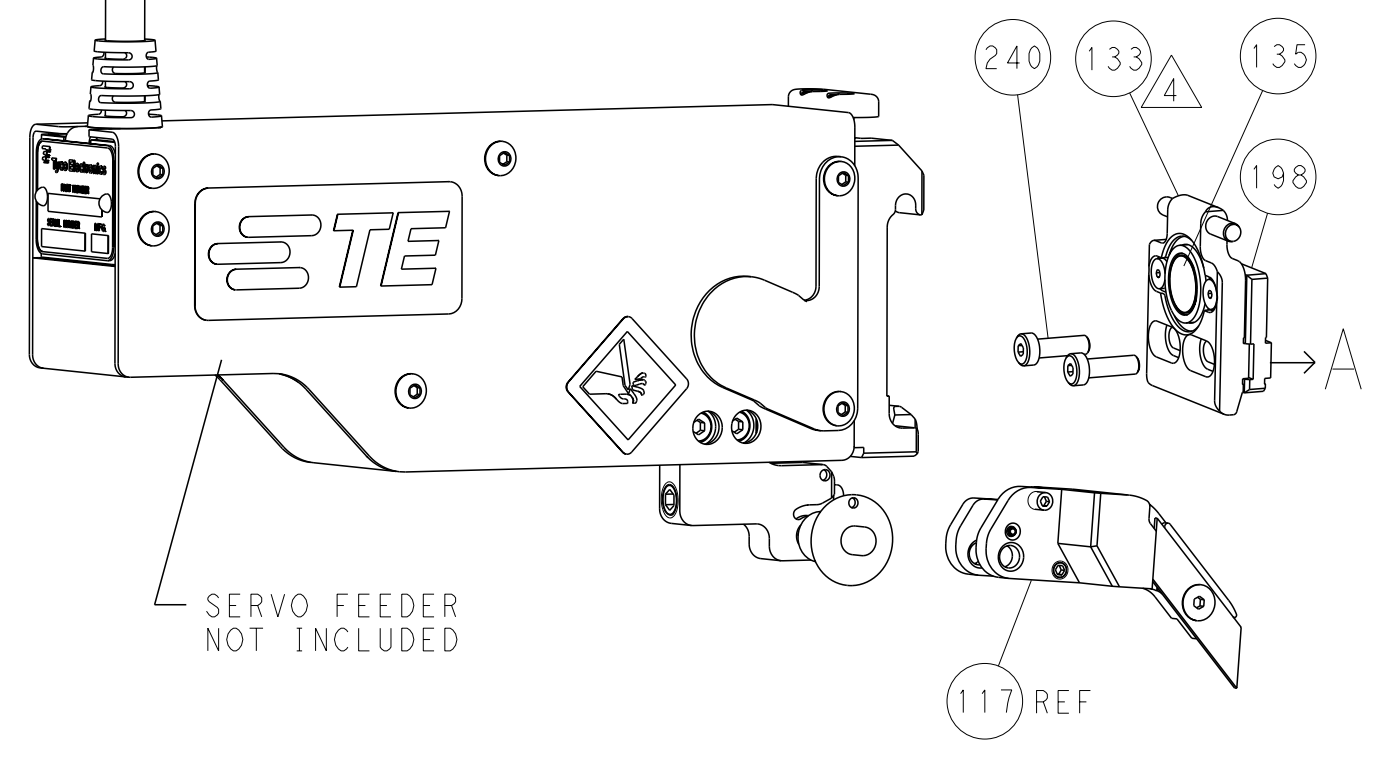
### FEED TYPE MECHANICAL



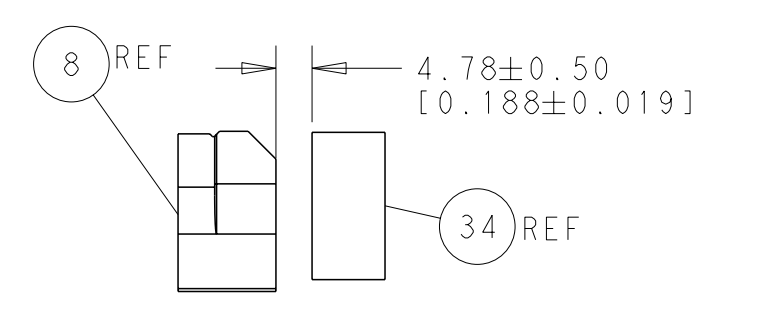
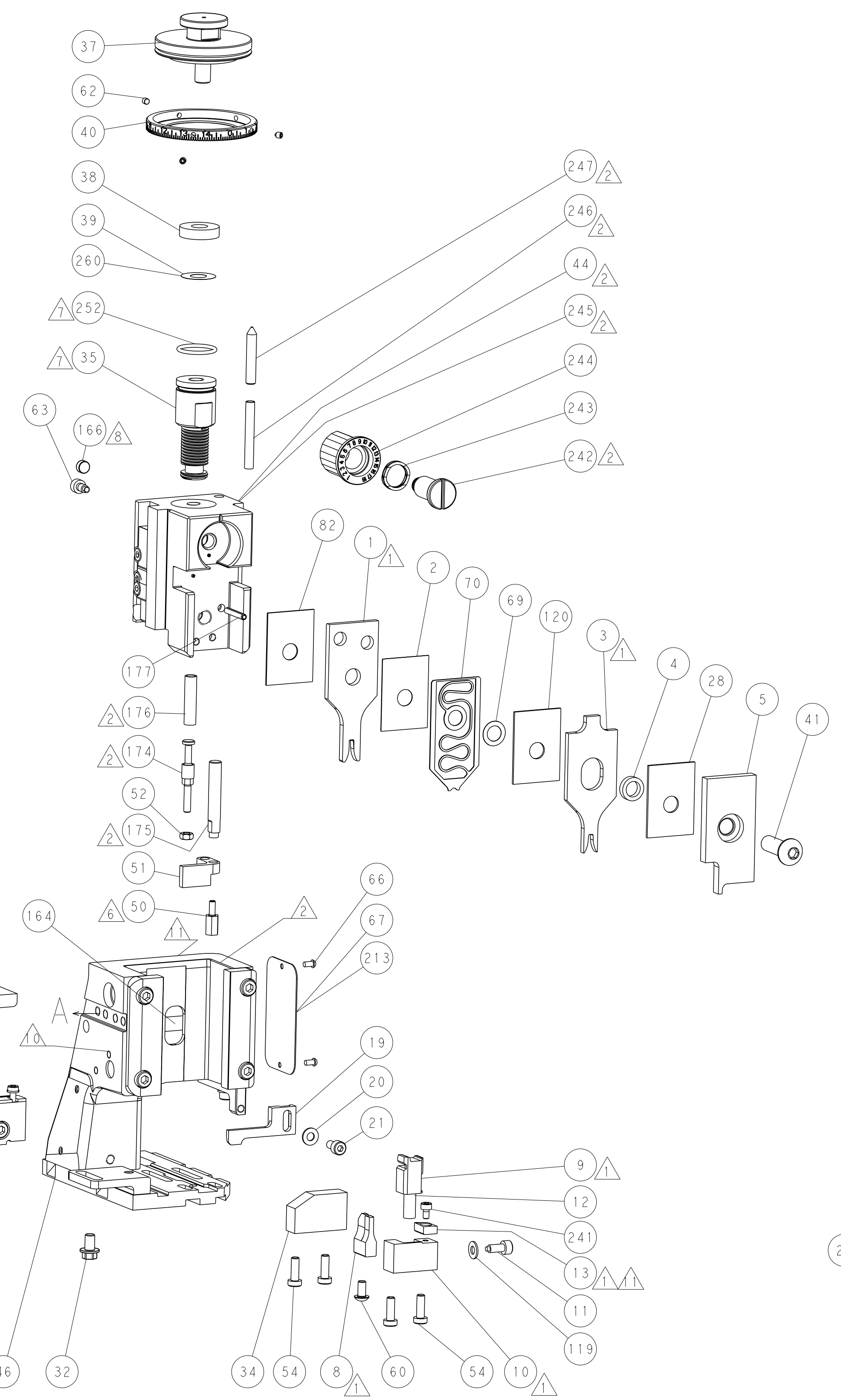
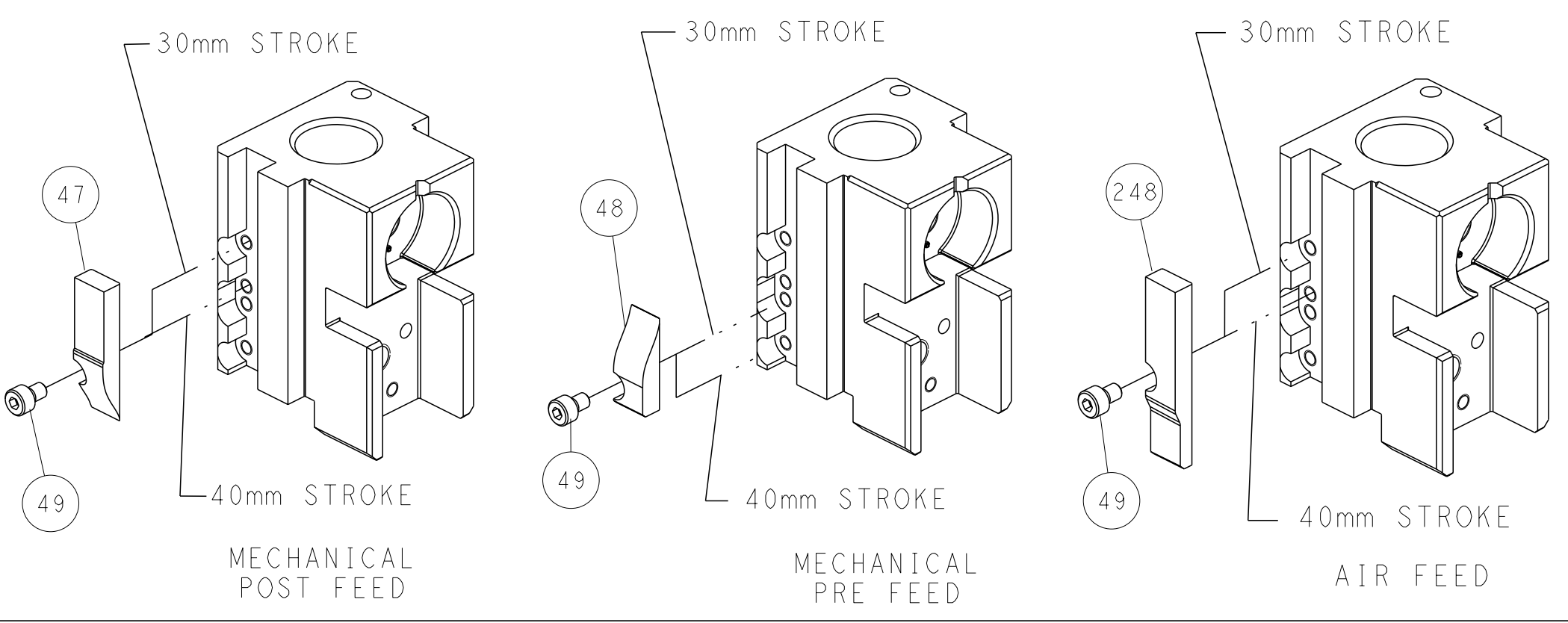
### PNEUMATIC



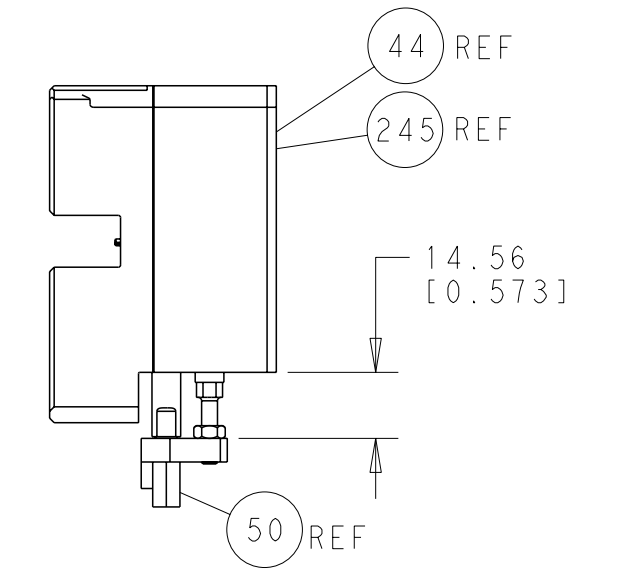
### SERVO LATCH PLATE



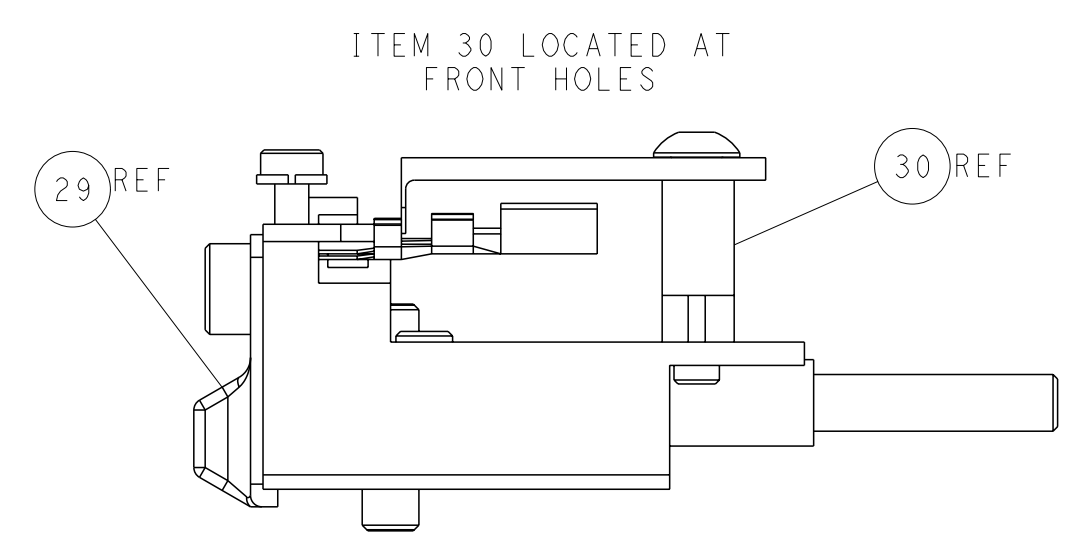
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



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:		DWN Y. LIN 15FEB2012		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.005	5 PLC ±0.005	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK G. BAILEY 15FEB2012		NAME Ocean Side Feed Applicator	
APVD S. XI 15FEB2012		PRODUCT SPEC:		APVD S. XI 15FEB2012		APPLICATION SPEC:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1		SHEET 2 OF 4		REV A	

Table with columns: PACIFIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a diagram of the terminator interface adapter.

APPLICATOR DATA table with columns: CRIMP SIZE, TYPE, WIRE, INSUL. Also includes APPLICATOR INSTRUCTIONS 408-10389 and a small diagram.

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED table.

WIRE SIZE table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- 1 RECOMMENDED SPARE PARTS
2 GREASE BEARING SURFACES LIGHTLY
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4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
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 ITEM 50.
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.
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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.

\*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various parts like FINE ADJUST HEAD ASM, PUSH ROD, BUSHING, etc.

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. Includes a table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD.

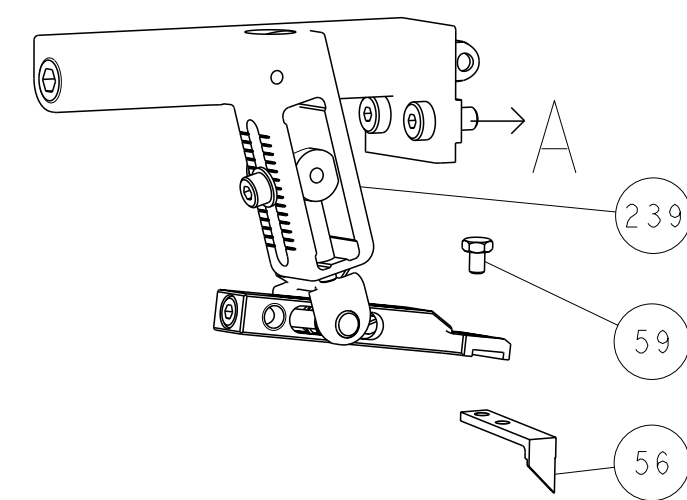
Large table listing parts and quantities. Columns include quantity, drawing number, description, and item number. Includes a variety of components like retainers, screws, washers, and applicator parts.

Dimensional information, tolerances, and material specifications. Includes a diagram of a hole and various fields for dimensions, tolerances, and material.

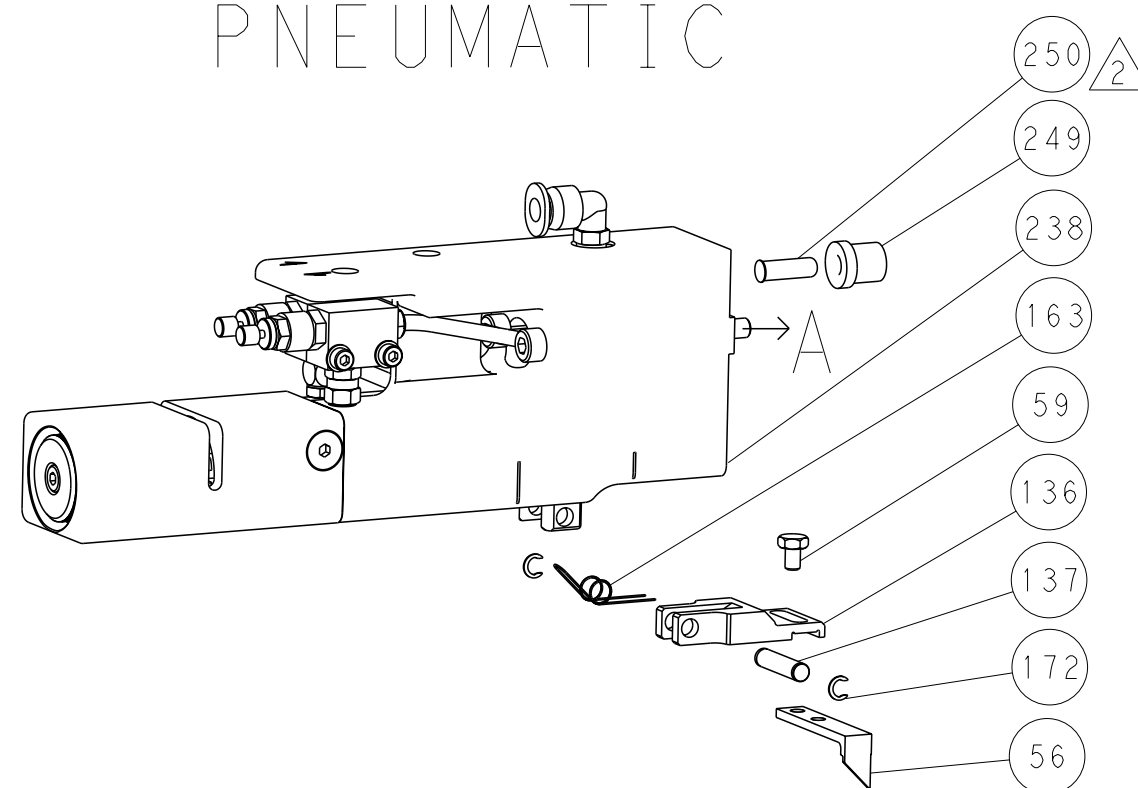
LOC	DIST	REV	DESCRIPTION	DATE	DWN	APVD
A	66		SEE SHEET 1			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

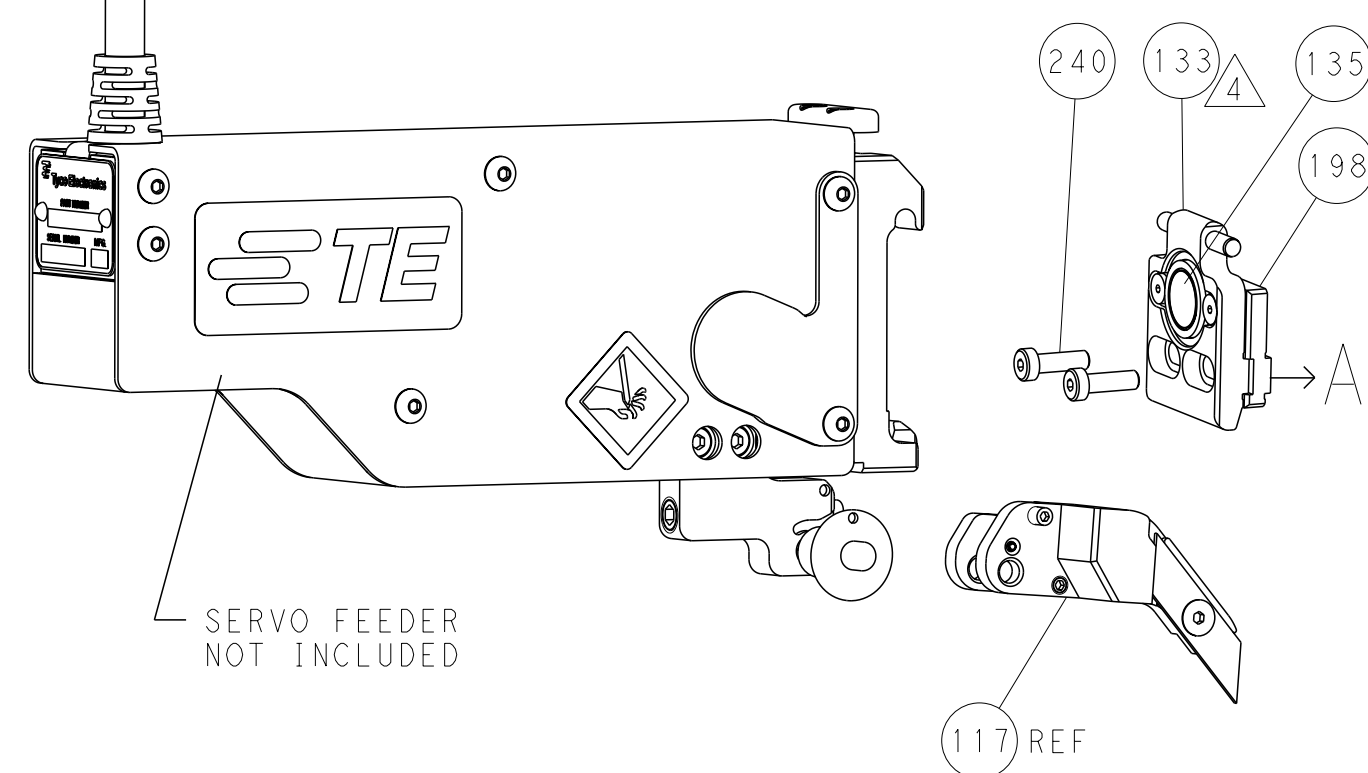
## FEED TYPE MECHANICAL



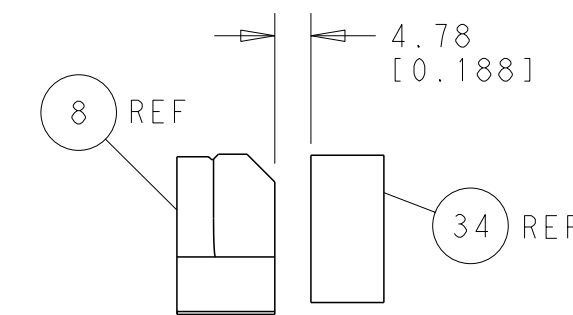
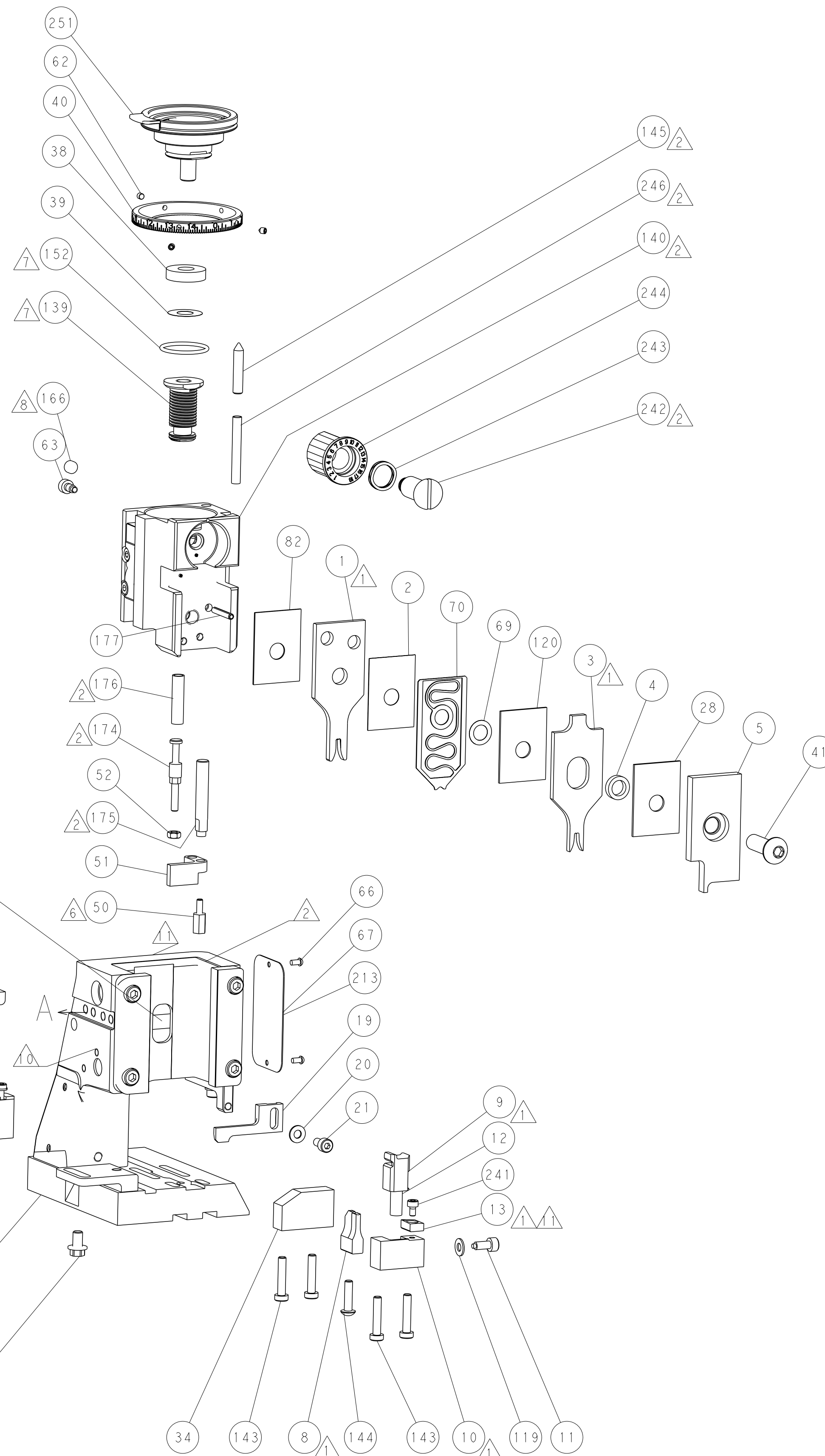
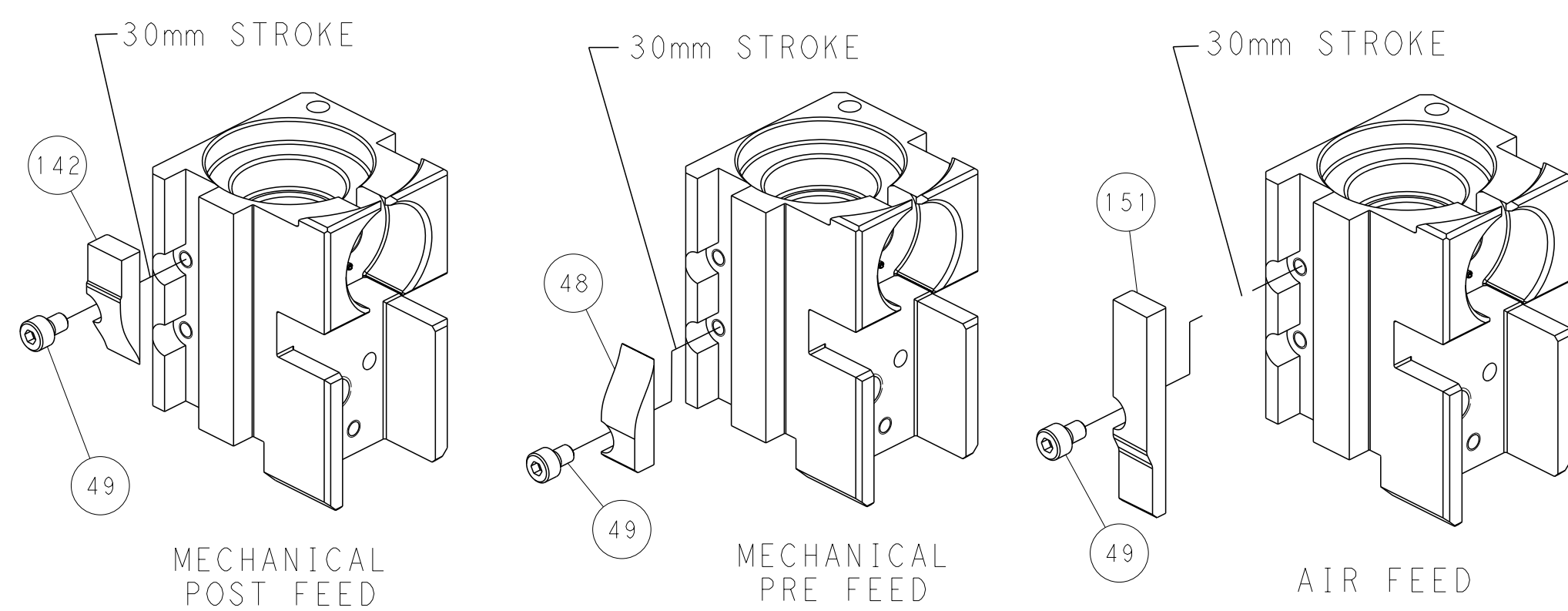
## PNEUMATIC



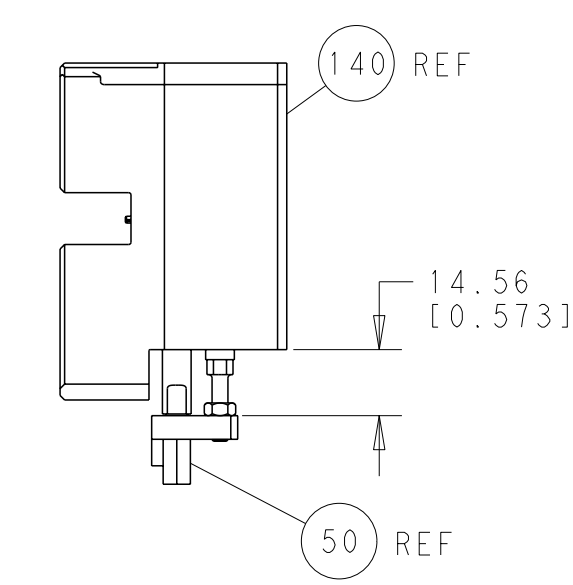
## SERVO LATCH PLATE



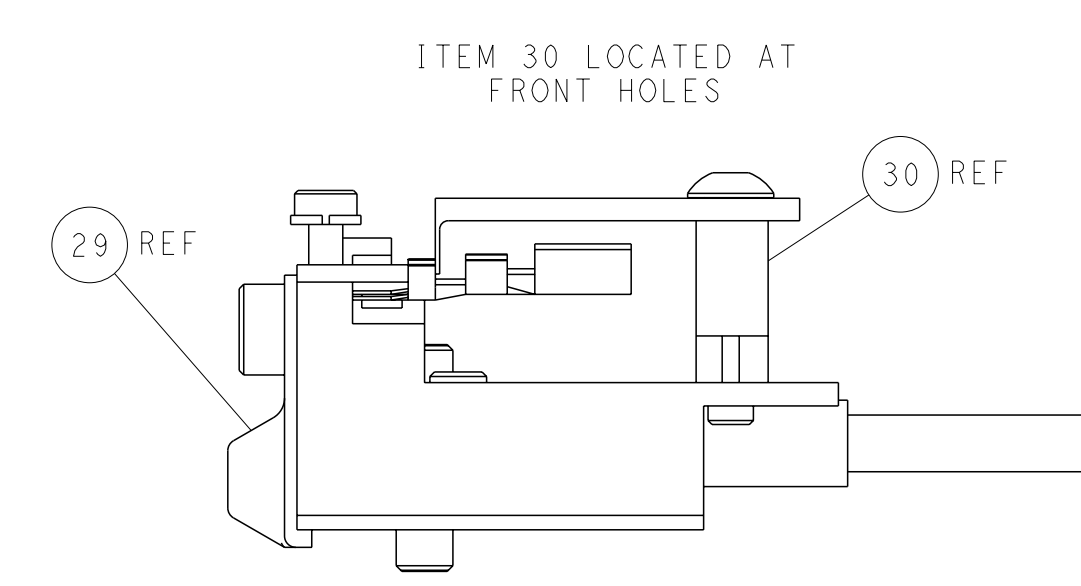
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES FINISH	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151612 RESTRICTED TO:
MATERIAL:		WEIGHT:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:1 SHEET: 4 OF 4 REV: A