

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151853-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	
	2151853-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	-	8-2151853-5	1901094-3	1-1752354-9	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151853-4	-	-	-
	2151853-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-2
					-	-	-	-	-	-	
	2151853-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151853-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	6.10 mm [.240]	OV

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: PRONER TERMINAL PRONER CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 8mm NG1 CAPACITE 3 A 6mm	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.95-5.96 mm [.234-.235 1N]	∅ 1.3x
TERMINAL APPLICATION SPECIFICATION	PRONER SPEC

TERMINALS APPLIED				
TE TERMINAL	PRONER TERMINAL	TE SEAL	PRONER SEAL	CABLE DIAMETER
1544227-1	2398-D-001	1544316-1		∅ 3.20-4.10

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.10 +/- 0.05 [.122 +/- .002]	5.8
5.00mm2	3.00 +/- 0.05 [.118 +/- .002]	6.9
4.00mm2	2.72 +/- 0.05 [.107 +/- .002]	9.5
3.00mm2	2.54 +/- 0.05 [.100 +/- .002]	11.4

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151853-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151853-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151853-6
- 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 62 & 180. 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 ITEM 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 2.70. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- ¹³ APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- ¹⁴ GRIND AT ASSEMBLY.

***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	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	1	1	1	1803078-1	SPACER, PRECISION	259
-	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
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2161314-1	RAM, STEPPED, ATLANTIC, SF, NON-ADJ.	245
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-77	-7	-6	-5	-2	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	P	LTN	DESCRIPTION	DATE	OWN	APVD
			B		ECR-15-016084	03NOV2015	MR	JDG
			C		ECR-17-003525	10MAR2017	MZ	KZ

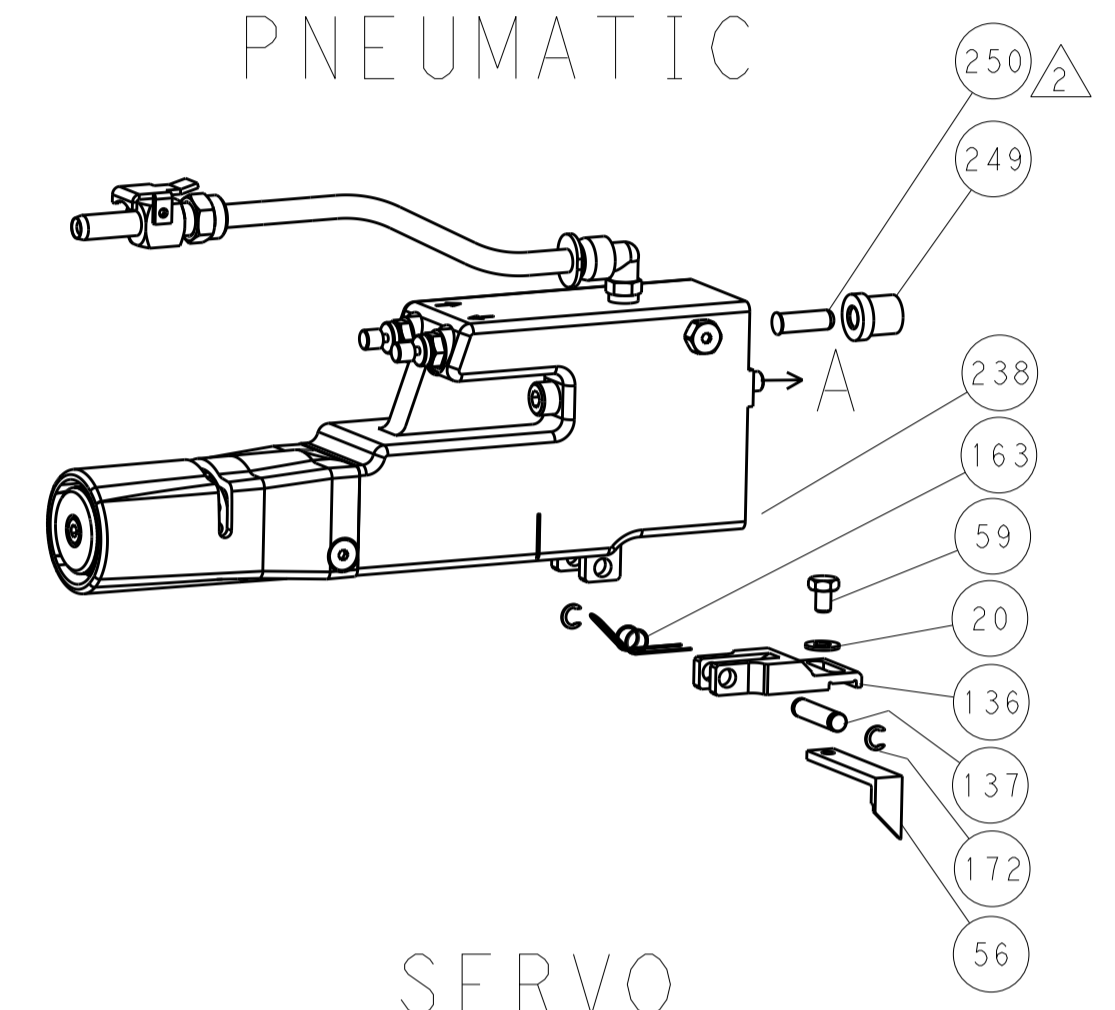
⁶	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	2	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	-	1	2063440-2	AIR FEED MODULE	238
	-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
	-	-	1	1	-	1901094-3	SPACER, FEEDER	198
⁶	-	1	1	1	1	1-1752354-9	STANDOFF, HOLD-DOWN	180
	-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	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
⁸	-	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	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
	-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
	-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	1	1	1	1	318563-1	GUARD, FRONT CHIP	89
	-	1	1	1	1	455888-8	SPACER, CRIMPER	82
¹³	-	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
	-	1	1	1	1	1633470-2	EXTENSION PLATE	78
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-6	DEPRESSOR, WIRE	70
	-	1	1	1	1	2119943-1	WASHER, SPACER	69
	-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
⁶	-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	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
¹⁴	-	1	1	1	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
	-	-	-	-	1	1338683-8	FEED PAWL	56
	-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
	-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
	-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1	1	2119656-3	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	-	1	1	2161311-1	RAM, STEPPED, AMP STYLE, SIDE FEED	44
	-	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	2119644-4	RAM WASHER, PRECISION	38
⁶	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
¹	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	1752356-3	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	1320908-2	SPACER, STRIP GUIDE	30
	-	1	1	1	1	2119959-5	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-4	SPACER, CRIMPER	28
	-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1	1	1320928-4	STRIP GUIDE	24
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
¹	-	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	1	2119805-2	SHEAR HOLDER, FRONT	10
¹	-	1	1	1	1	318059-4	FLOATING SHEAR, FRONT	9
¹	1	1	1	1	1	6-1633620-4	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2-2119781-7	DEPRESSOR, SHEAR	5
	-	1	1	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
¹	1	1	1	1	1	1803101-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	1	1	1-455888-7	SPACER, CRIMPER	2
¹	1	1	1	1	1	1-1633738-7	CRIMPER, WIRE	1
	-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	7 PLC ±	8 PLC ±	9 PLC ±	10 PLC ±
	ANGLES	FINISH		MATERIAL		WEIGHT		SCALE		SHEET	
				Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 of 4		REV C	

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

FEED TYPE

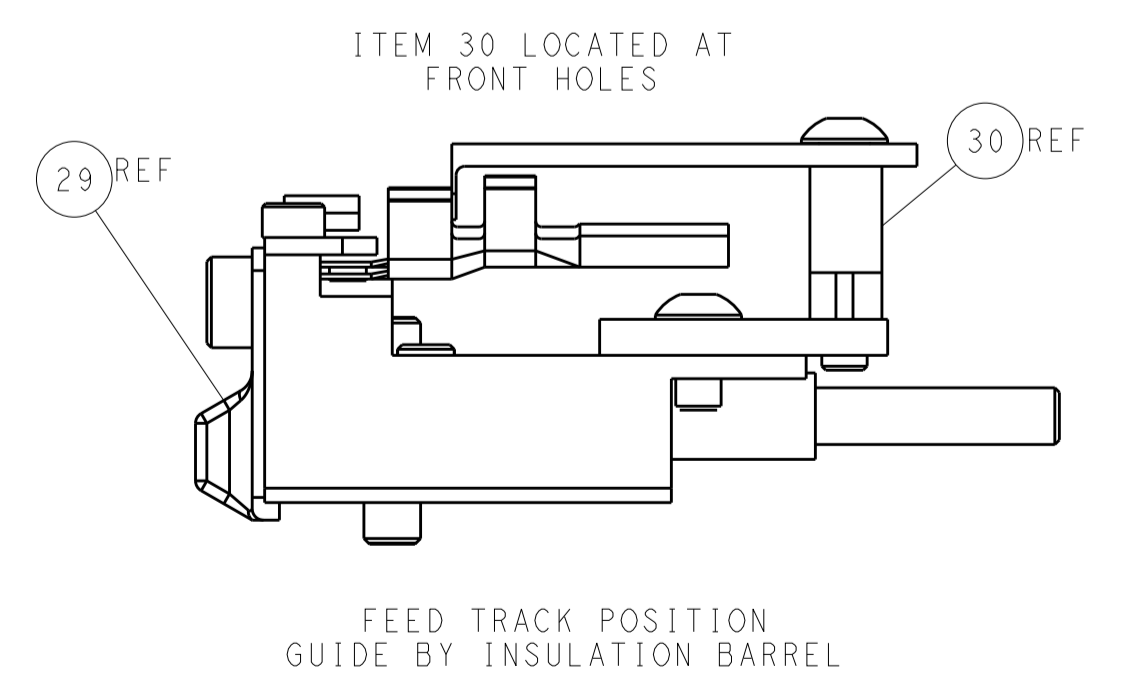
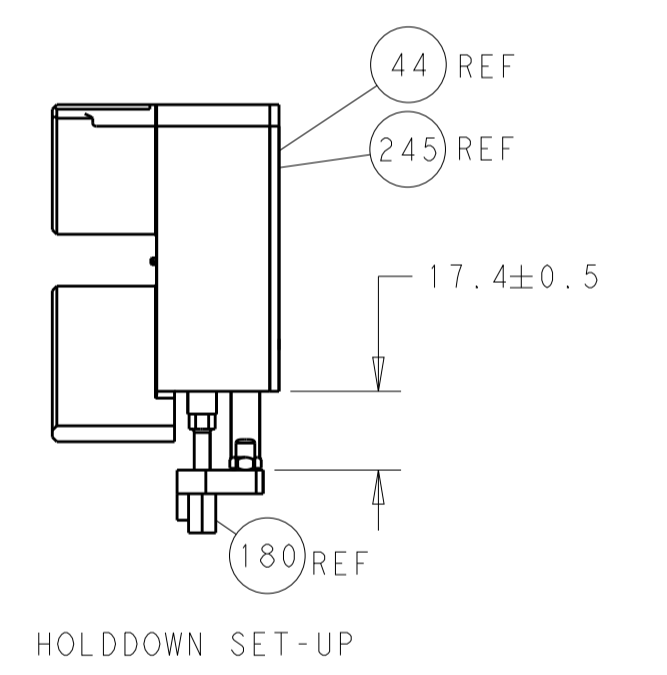
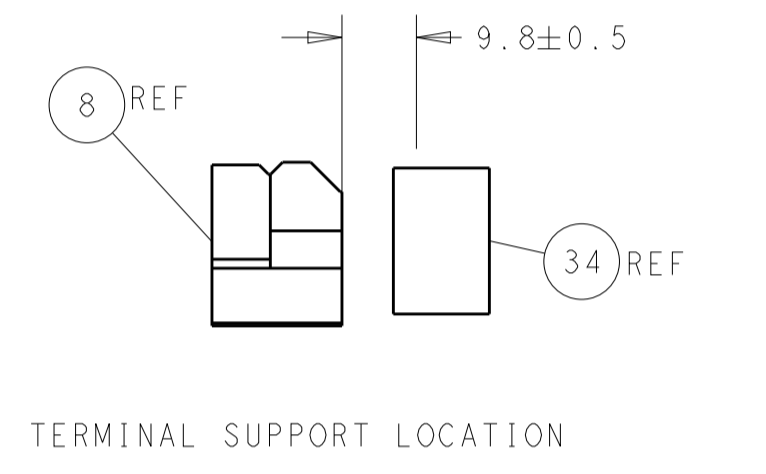
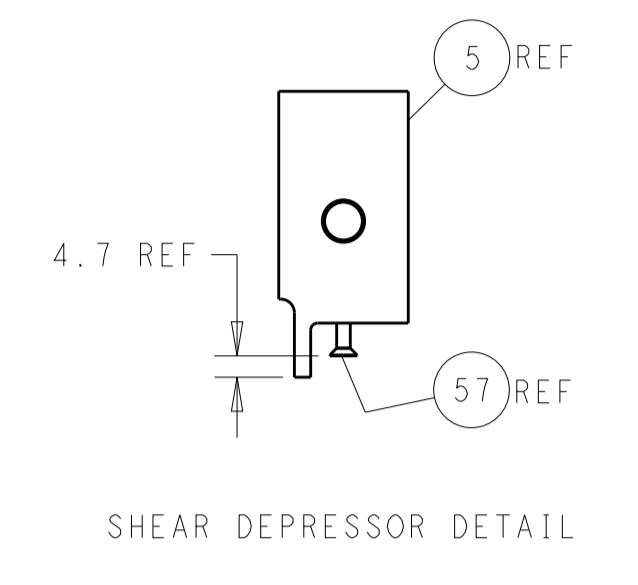
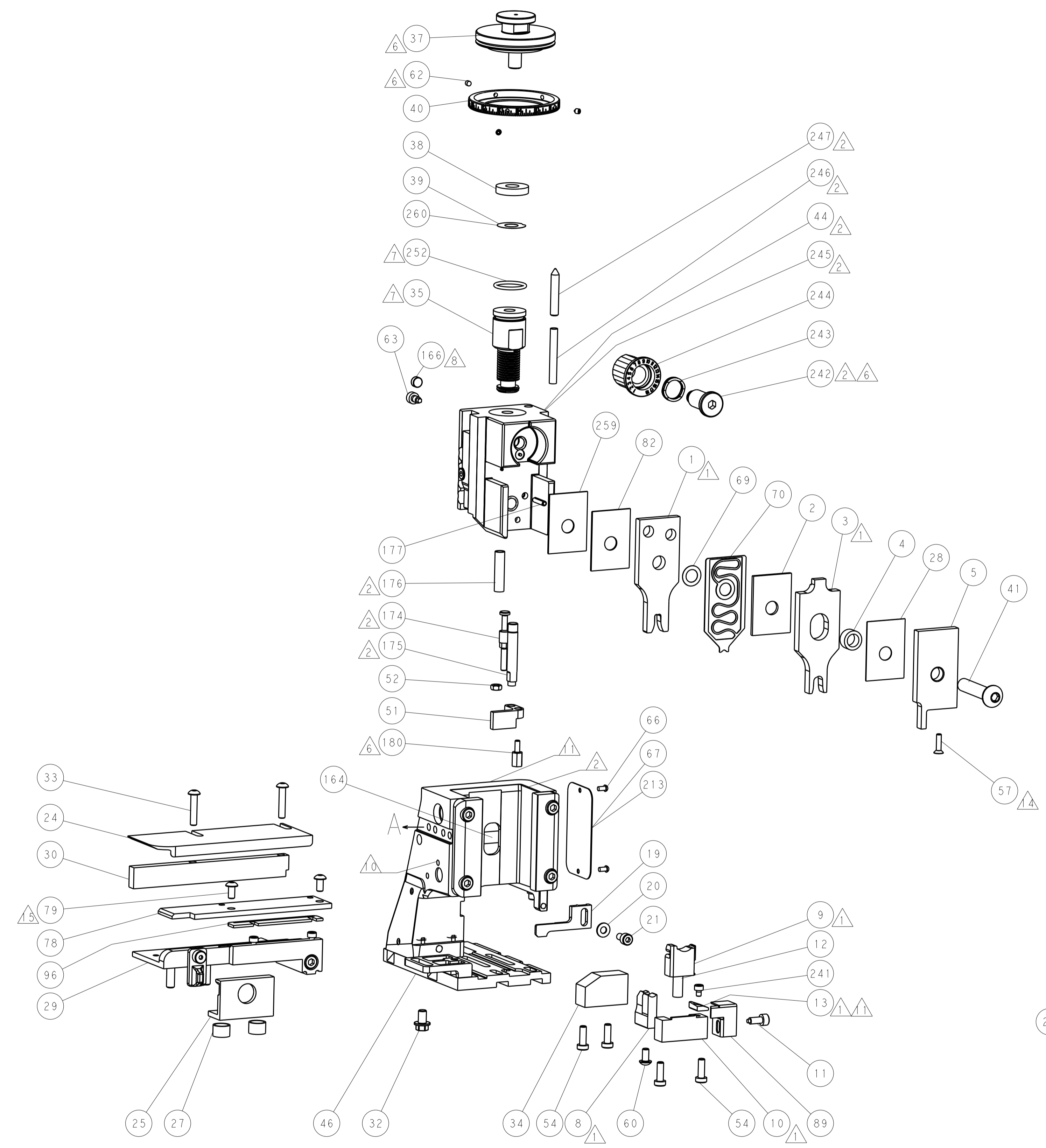
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION

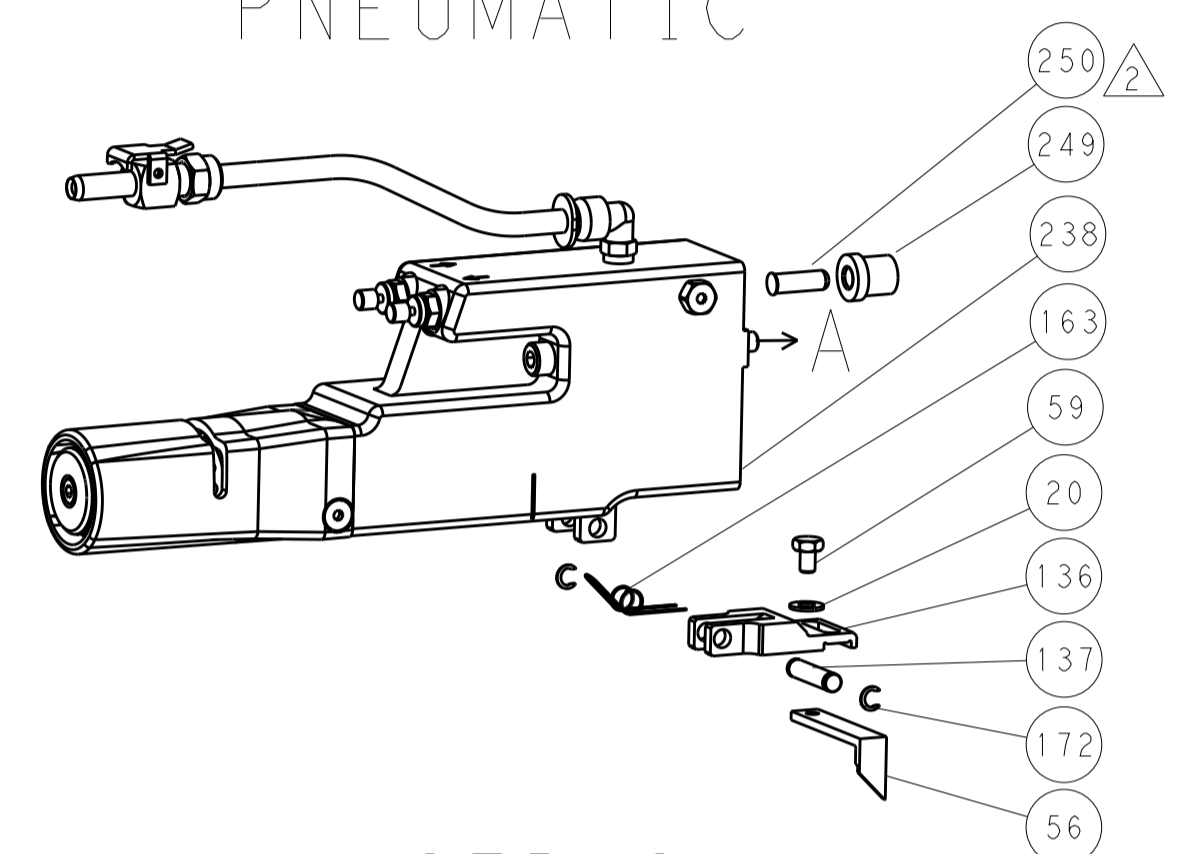


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

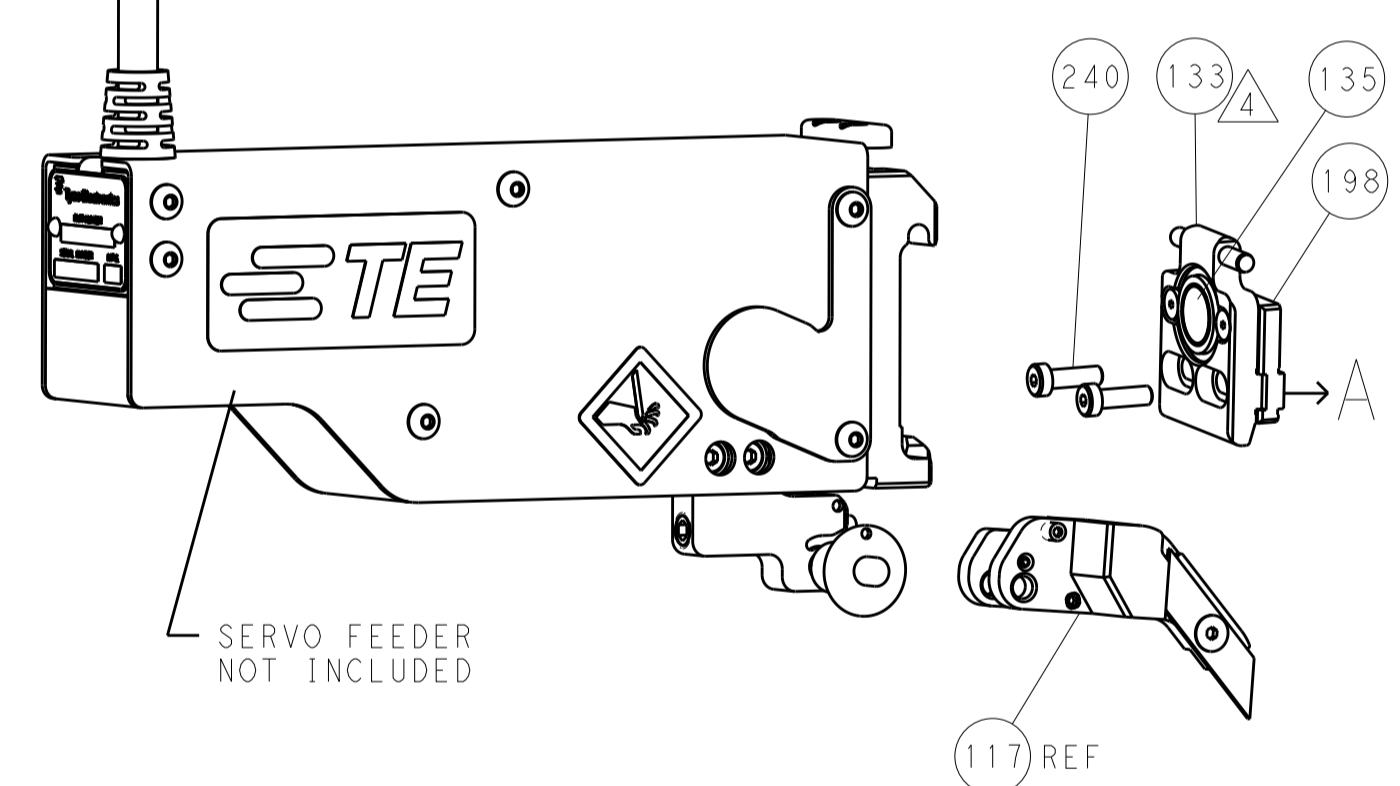
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		APVD S. XI 14JAN2013		RESTRICTED TO	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 ©=2151853	
				WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV C	
				Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

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

FEED TYPE PNEUMATIC



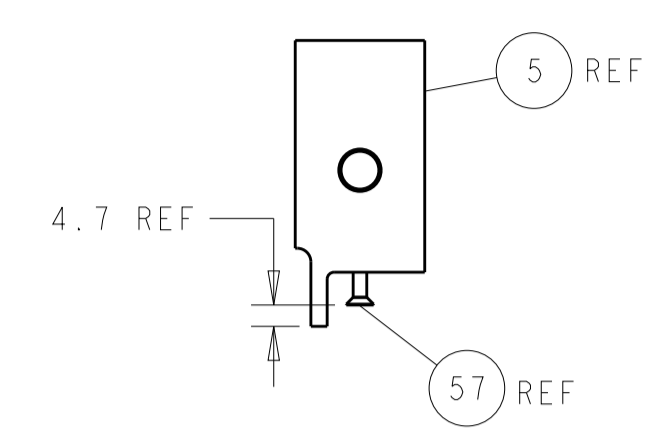
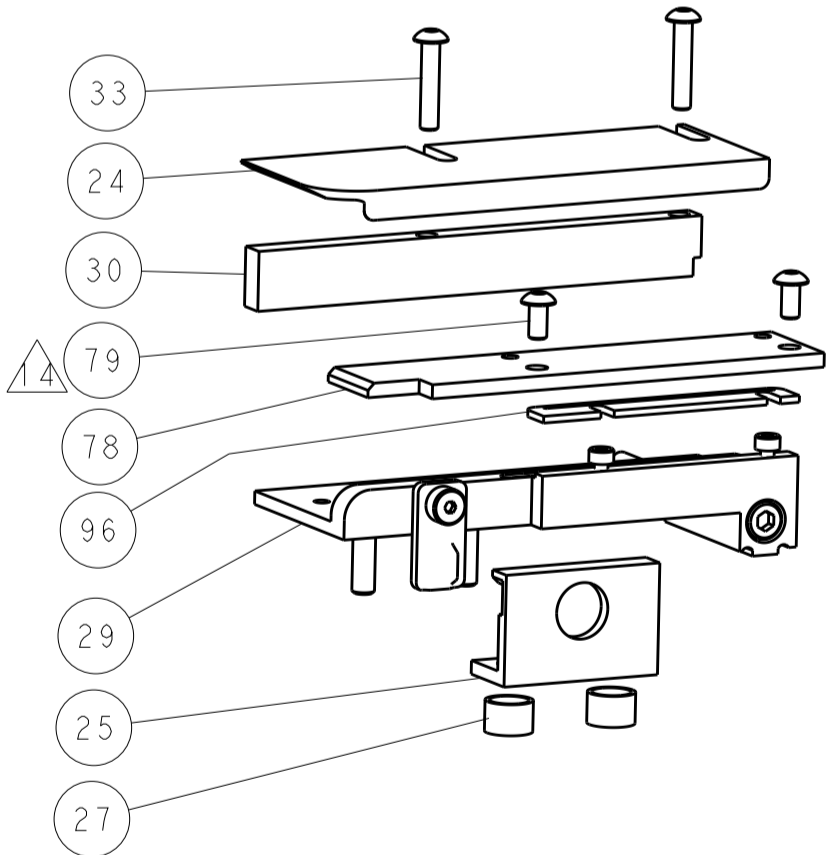
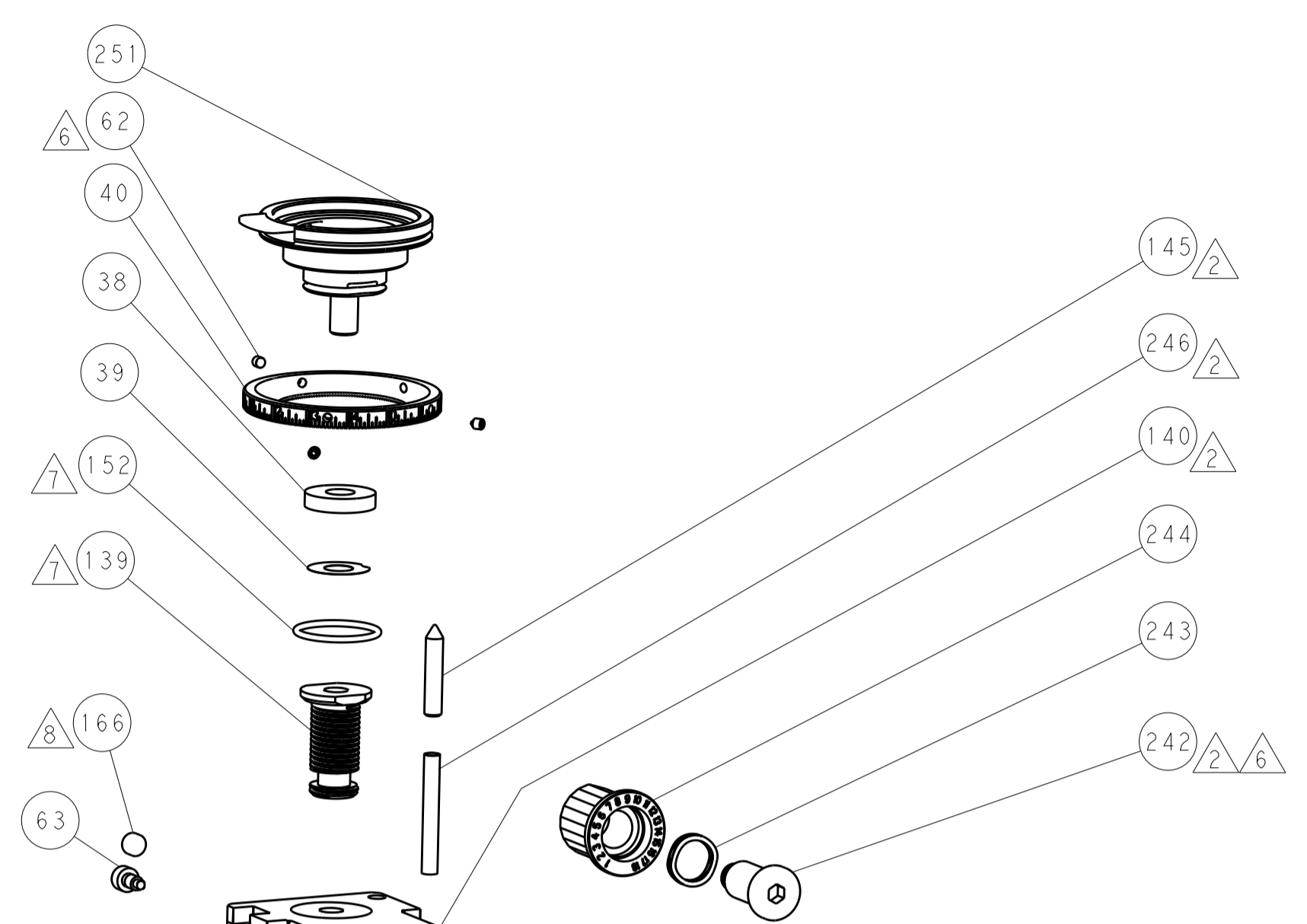
SERVO LATCH PLATE



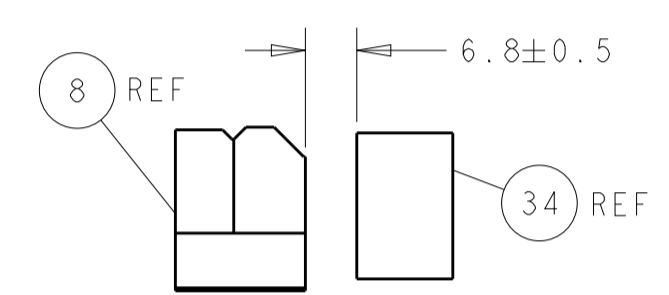
CAM POSITION



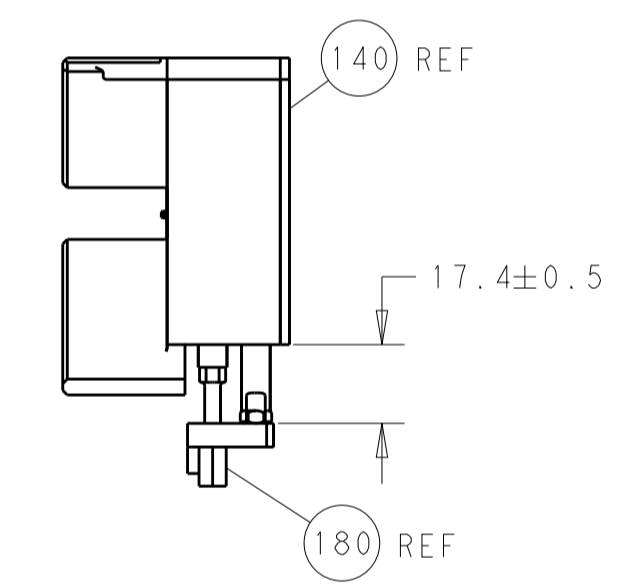
AIR FEED



SHEAR DEPRESSOR DETAIL

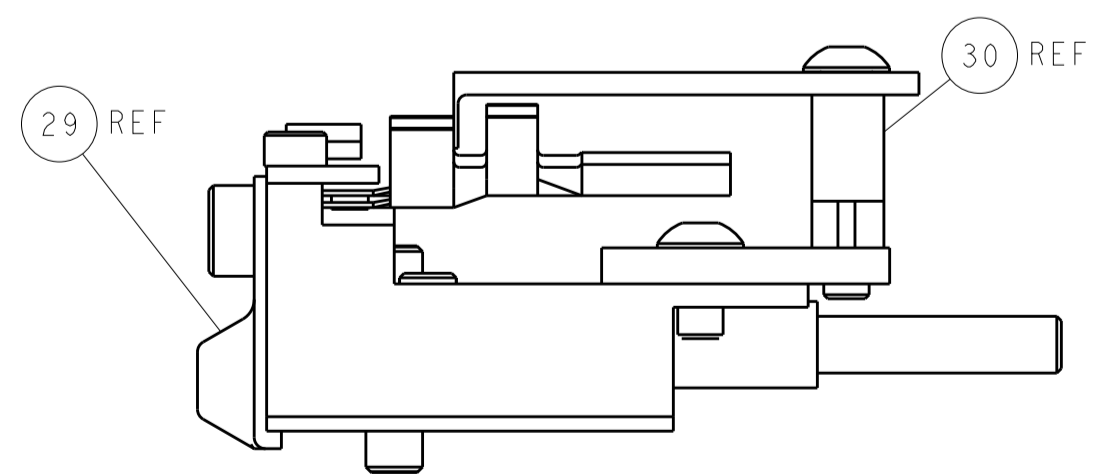


TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

ITEM 30 LOCATED AT
FRONT 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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 14JAN2013		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK G. BAILEY 14JAN2013	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD S. XI 14JAN2013	PRODUCT SPEC	RESTRICTED TO	
	2 PLC	±		APPL. SPEC	SIZE	CAGE CODE	DRAWING NO.
	3 PLC	±		WEIGHT	A1	00779	©=2151853
	4 PLC	±		MATERIAL	Customer Accessible Production Drawing	SCALE	1:2
	ANGLES	±		FINISH		SHEET	4 OF 4
						REV	C