

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER
PART NUMBER REVISION DESCRIPTION FEED TYPE
CONVERT TO PART NUMBERS REQUIRED
PNEUMATIC FEED 2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1
SERVO LATCH PLATE 2119951-1 - 8-2266072-5 1901094-3 2-1752354-3 2168400-6 (QUANTITY 2)
SMART APPLICATOR 2161326-1 - 8-2266072-4 - - -

APPLICATOR DATA
CRIMP SIZE TYPE
WIRE 2.03 mm [.080] F
INSUL 4.06 mm [.160] O
APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION
TERMINAL NAME: TAB 2.8 x 0.8
WIRE STRIP LENGTH INSULATION DIAMETER RANGE
TERMINAL APPLICATION SPECIFICATION
TERMINALS APPLIED

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION
TERMINAL NAME: TAB 2.8 X 0.8
WIRE STRIP LENGTH INSULATION DIAMETER RANGE
TERMINAL APPLICATION SPECIFICATION
TERMINALS APPLIED

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING
1.00mm2 1.20+/-0.05 [.047+/- .002] 6.0
0.75mm2 1.18+/-0.05 [.046+/- .002] 6.2
0.50mm2 1.15+/-0.05 [.045+/- .002] 6.5

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING
0.61mm2 1.18+/-0.03 [.046+/- .001] 6.2

- 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: 8-2266072-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266072-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266072-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266072-6
- 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 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.
- 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.
- 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. THE INSULATION RANGE IS 1.2-2.1 mm.
- 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.
- THE APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

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.

Table with 3 columns: Item No, Description, Item No
- - 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
REVISIONS
DESCRIPTION DATE DWN APVD
B ECR-15-004295 18MAR2015 RK GB
B1 ECR-16-008300 8JUN2016 RS LZ

Table with 3 columns: Item No, Description, Item No
- - - - 1 - 2079988-1 BUSHING, LCH5-12, MISUMI 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 2119082-9 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
- 1 1 1 1 1 2-1752354-3 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 5-22280-0 SPRING, COMPRESSION 176
- 1 1 1 1 1 1752353-3 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 455888-4 SPACER, CRIMPER 82
- 1 1 1 1 1 2119956-1 DOCUMENTATION PACKAGE 71
- 1 1 1 1 1 2119791-9 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 POINT, 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 SKT HD CAP, M4 X 6.0 59
- 1 1 1 1 1 985575-3 SCR, FLT SKT HD CAP M3 X 10.0 57
- - - - 1 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 4-1722335-3 STRIPPER, SIDE FEED 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 2-2119656-1 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 1-1752356-6 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 455888-3 SPACER, CRIMPER 28
- 1 1 1 1 1 1320928-6 STRIP GUIDE 24
- 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 318707-1 FLOATING SHEAR, FRONT 9
- 1 1 1 1 1 2-1333204-6 ANVIL, COMBINATION 8
- 1 1 1 1 1 2119781-1 DEPRESSOR, SHEAR 5
- 1 1 1 1 1 238011-7 BLOCK, CRIMPER SPACER 4
- 1 1 1 1 1 1-1633965-8 CRIMPER, INSULATION O PREMIUM 3
- 1 1 1 1 1 1-455888-1 SPACER, CRIMPER 2
- 1 1 1 1 1 1-456405-6 CRIMPER, WIRE PREMIUM 1
-77 -7 -6 -5 -2 -1 PART NO DESCRIPTION ITEM NO

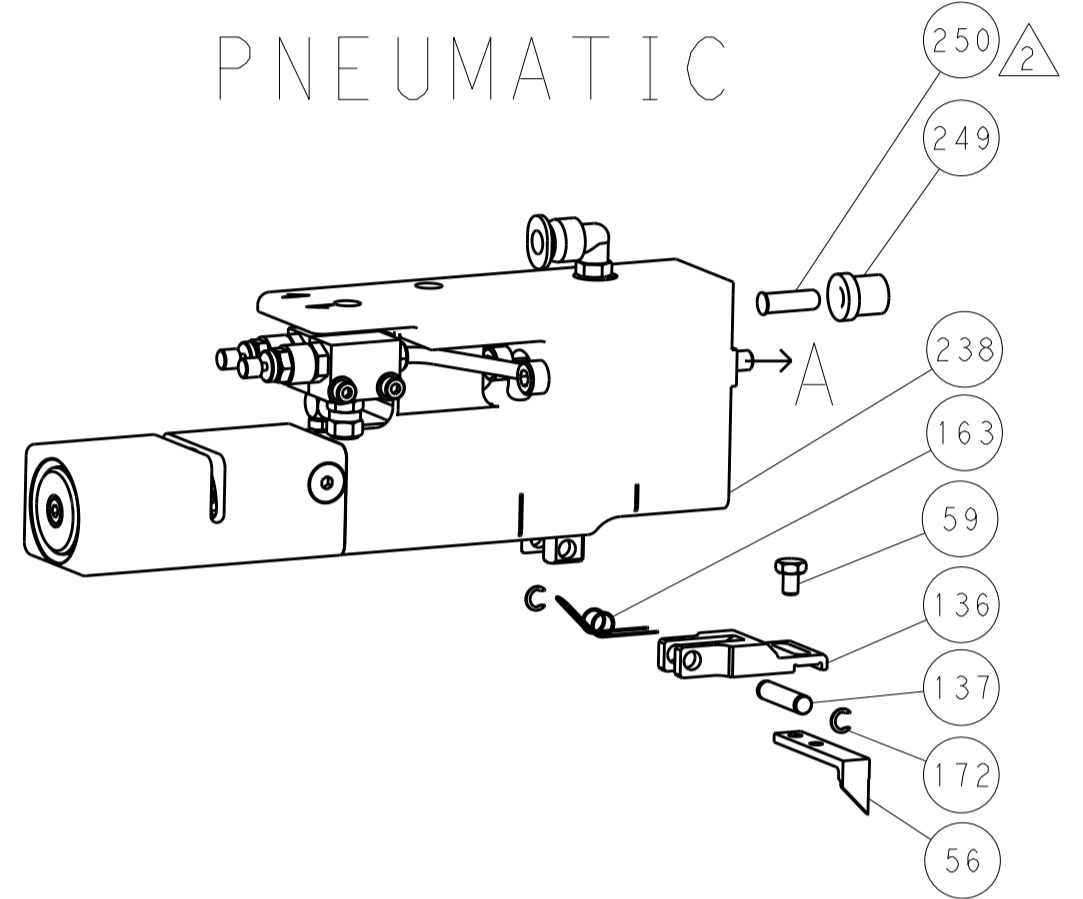
TE Connectivity
Ocean Side Feed Applicator
Customer Accessible Production Drawing
SCALE 1:2 SHEET 1 OF 4 REV B1

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

FEED TYPE MECHANICAL



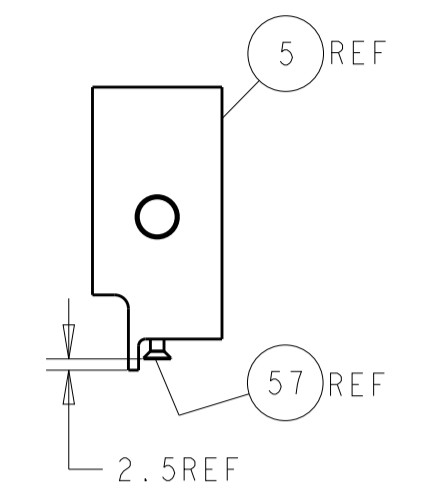
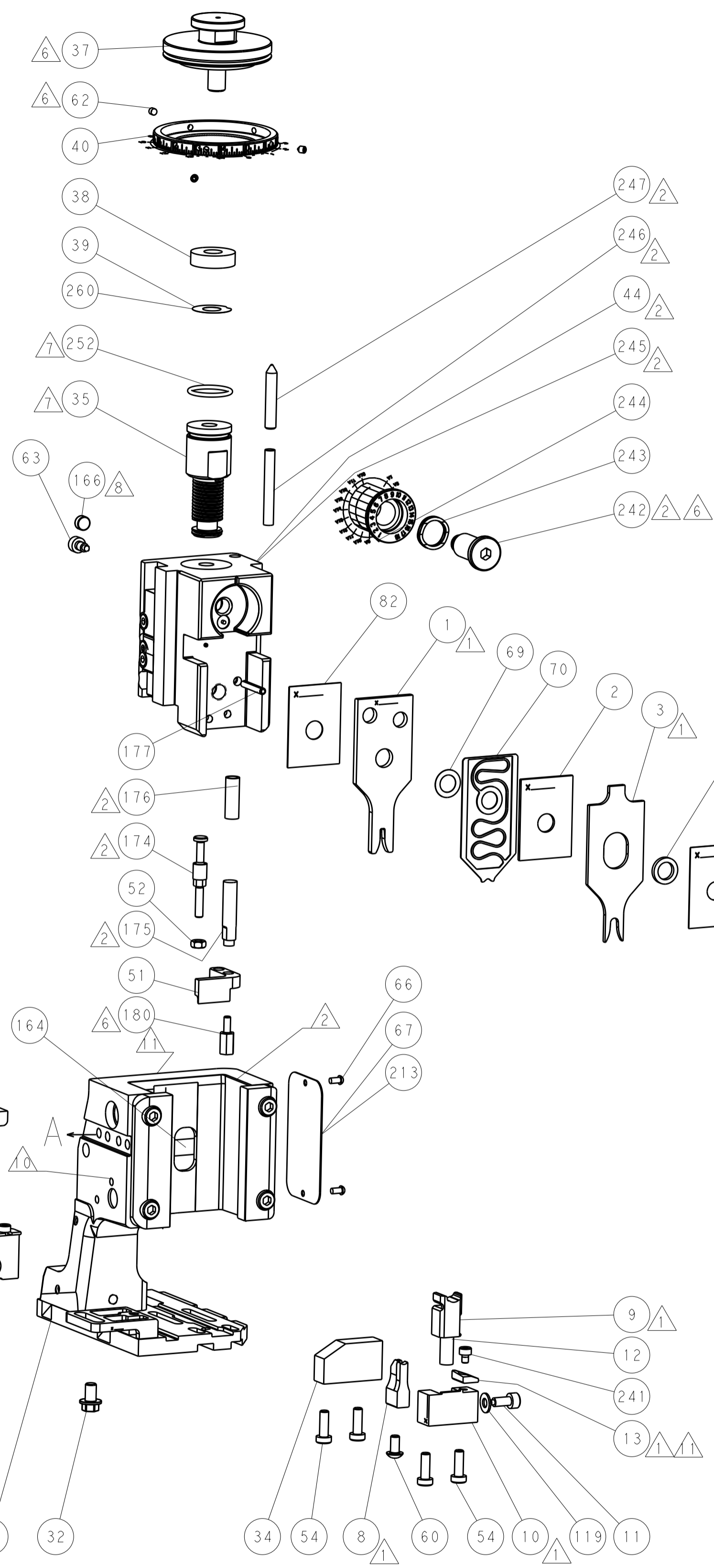
PNEUMATIC



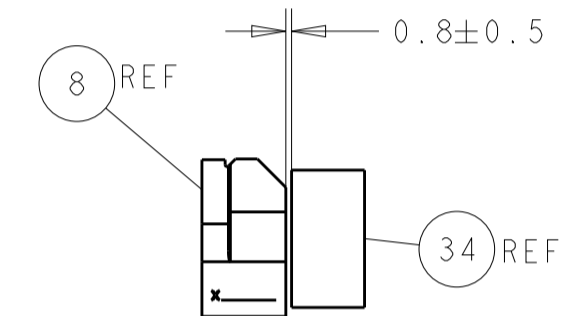
SERVO LATCH PLATE



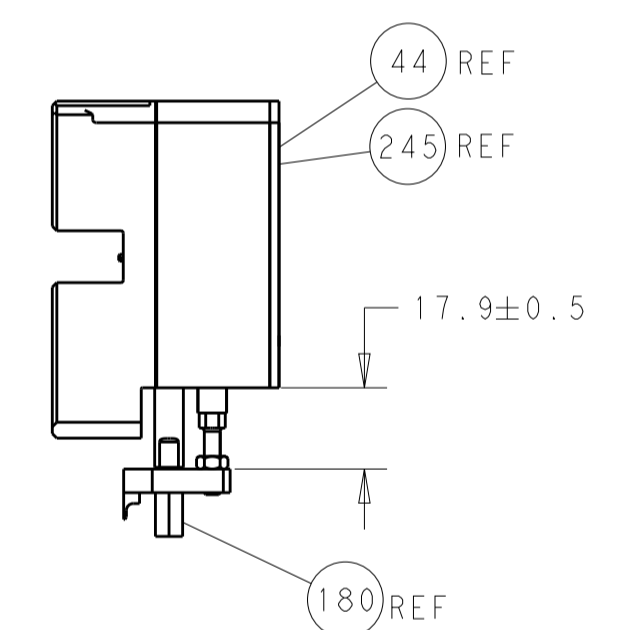
CAM POSITIONS



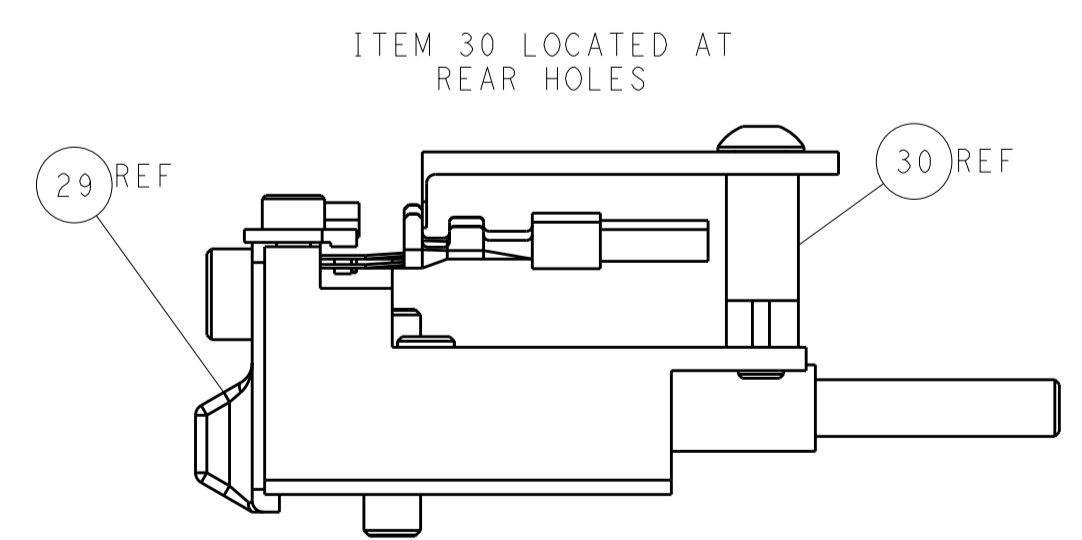
SHEAR DEPRESSOR DETAIL



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 X ZHAO 09OCT2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK T. ELBIN 09OCT2013		NAME	
				APVD L. ZHANG 09OCT2013		Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 ©=2266072	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV B1	

APPLICATOR STYLE CONVERSION CHART table with columns: CONVERT TO, PART NUMBERS REQUIRED, FEED TYPE, DESCRIPTION, REVISION, PART NUMBER, PACIFIC VERSION TERMINATOR INTERFACE ADAPTER.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE, WIRE, INSUL, APPLICATOR INSTRUCTIONS.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION table with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION table with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING table with columns: WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING.

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- RECOMMENDED SPARE PARTS
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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 ITEM 62 & 180.
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MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
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Table with columns: 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)

REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD

Main parts list table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD

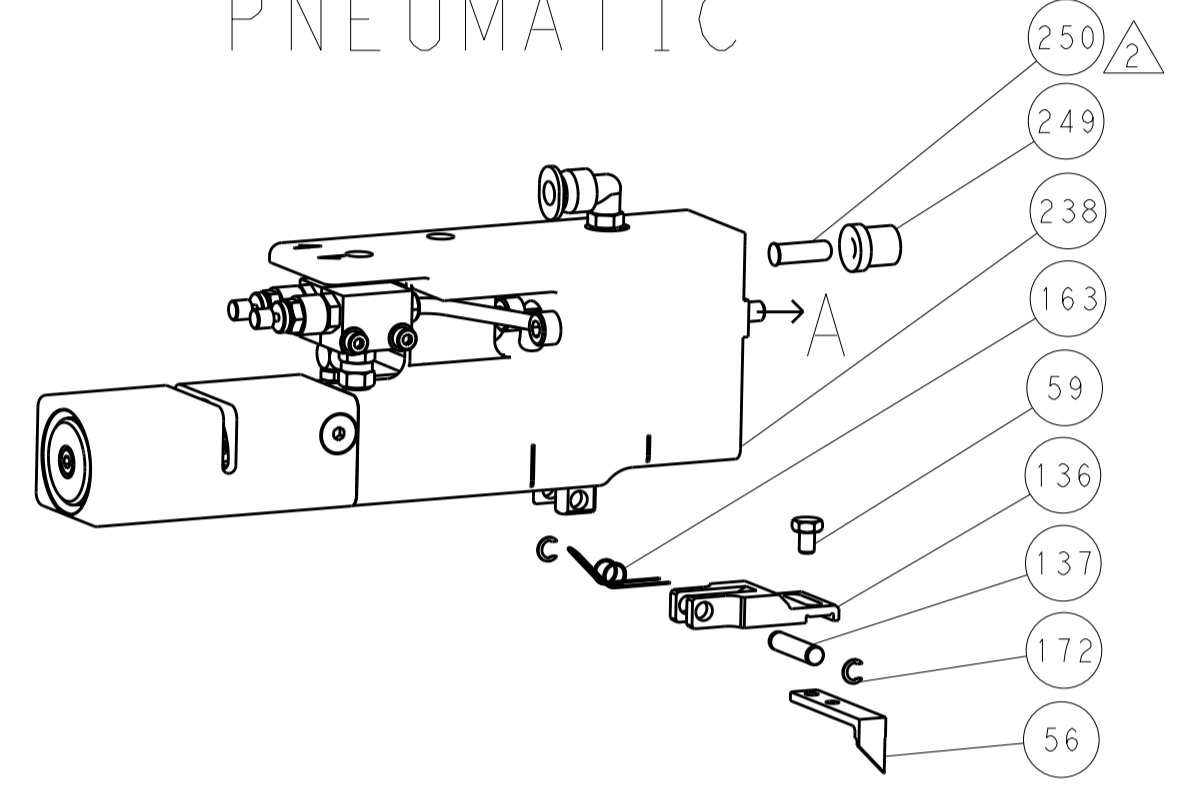
Customer Accessible Production Drawing with fields for DIMENSIONS, TOLERANCES, MATERIAL, FINISH, WEIGHT, SCALE, SHEET 3 OF 4

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

FEED TYPE MECHANICAL



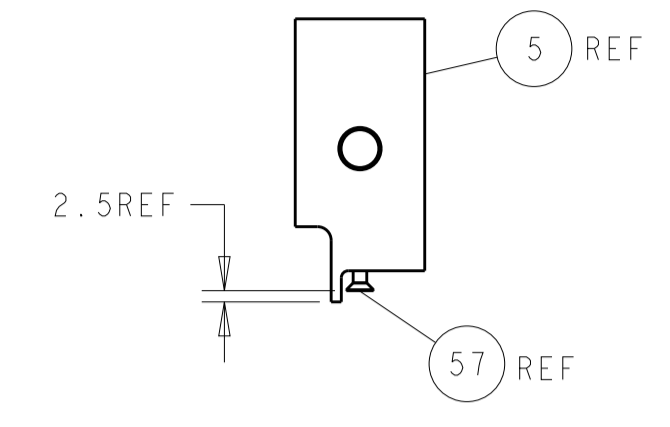
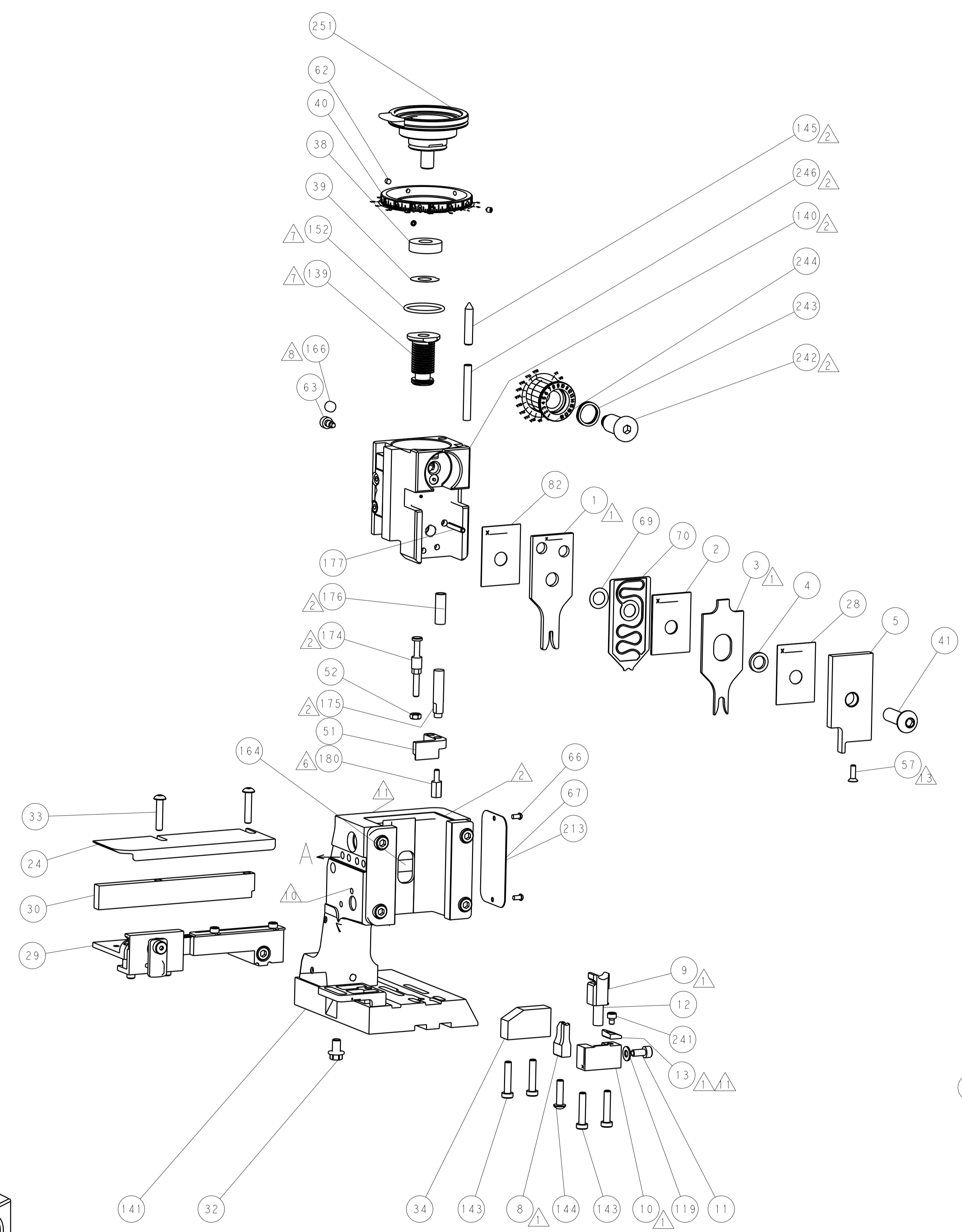
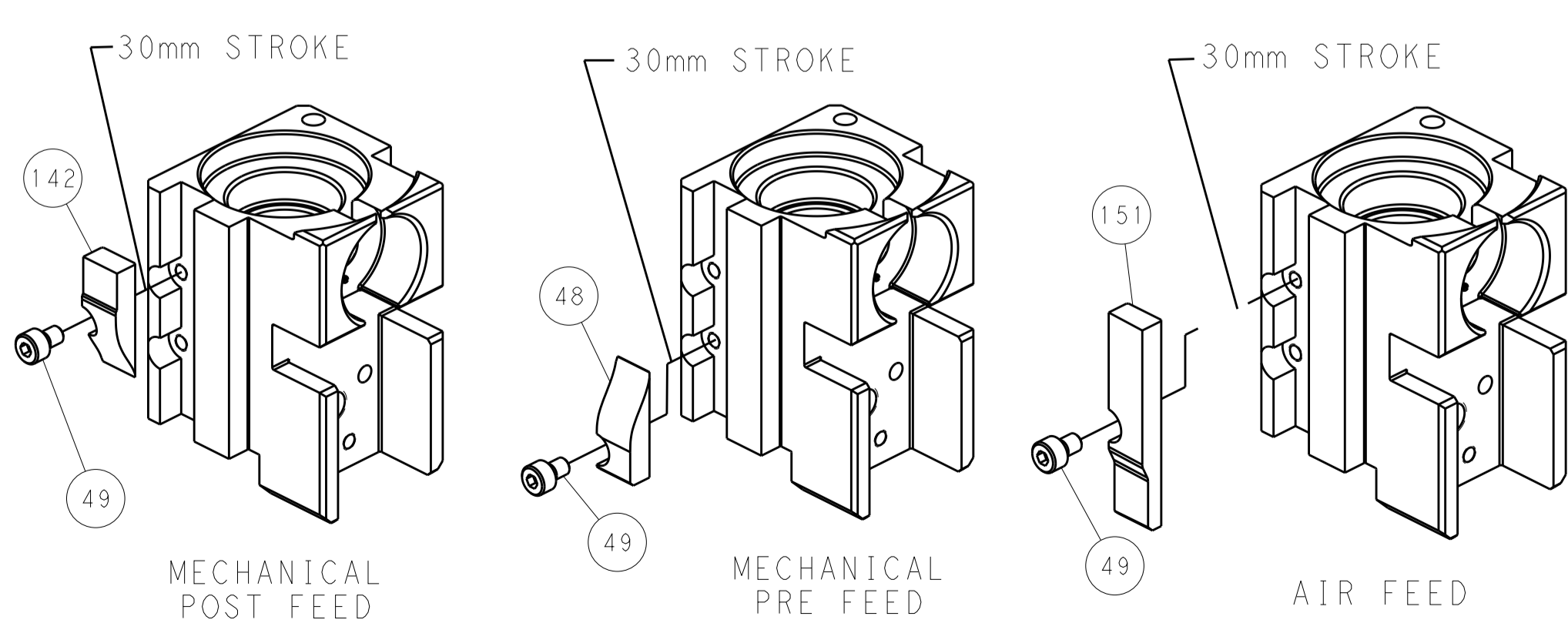
PNEUMATIC



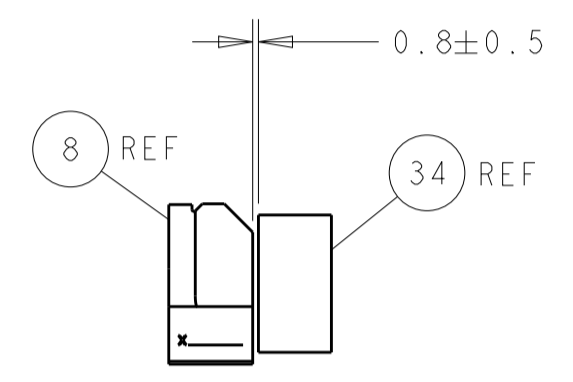
SERVO LATCH PLATE



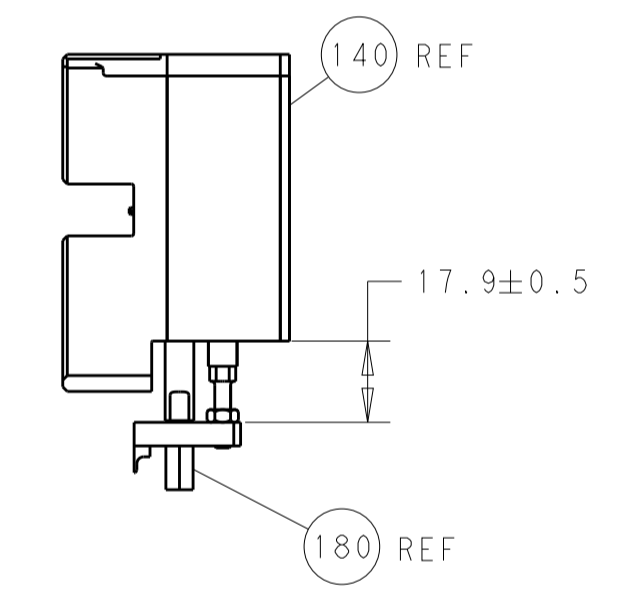
CAM POSITIONS



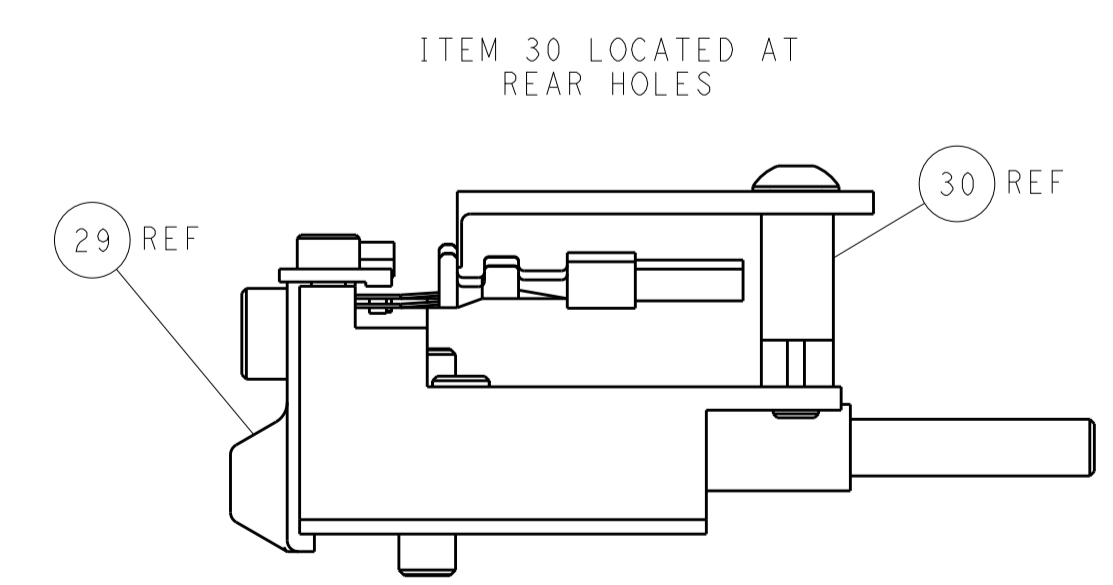
SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X. ZHAO 09OCT2013		REV: T. ELBIN 09OCT2013		NAME: Ocean Side Feed Applicator	
mm	0 PLC	±		PRODUCT SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
	1 PLC	±		APPLICATION SPEC	A1	00779	2266072		
	2 PLC	±		WEIGHT	Customer Accessible Production Drawing		SCALE	SHEET	OF
	3 PLC	±		FINISH			1:2	4	4
	4 PLC	±							
	ANGLES	±							