

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151008-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	
	2151008-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\Delta_4$	SERVO LATCH PLATE	2119951-1	-	8-2151008-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151008-4	-	-	
	2151008-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\Delta_4$	PNEUMATIC FEED	2119950-1	1338685-3	5-18022-5	2119641-1	2119799-1	2063440-1
					-	-	-	-	-	-	
	2151008-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151008-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 LIF FLAG FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-6.00 mm [.157-.236 IN]		$\varnothing$ 2.50-3.80 mm [.098-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-20088		
	(B)114-19025		
TERMINALS APPLIED $\Delta_0$			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 180464-1	(A) 180464-2	(B) 100645-2	(B) 100645-3
(A) 180464-4	(A) 180464-5	(A) 1-180464-2	(A) 2-180464-4
(A) 180464-9	(A) 1-180464-1	(A) 2-180464-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm <sup>2</sup>	1.93 +/- 0.05 [.076 +/- .002]	6.1
2.00mm <sup>2</sup>	1.85 +/- 0.05 [.073 +/- .002]	6.9
1.50mm <sup>2</sup>	1.80 +/- 0.05 [.071 +/- .002]	7.1
1.00mm <sup>2</sup>	1.70 +/- 0.05 [.067 +/- .002]	8.0

- $\Delta_1$  RECOMMENDED SPARE PARTS
- $\Delta_2$  GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- $\Delta_4$  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151008-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151008-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151008-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- $\Delta_6$  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62. 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 ITEMS 37.
- $\Delta_7$  GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- $\Delta_8$  MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- $\Delta_9$  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.
- $\Delta_{10}$  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- $\Delta_{11}$  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.
- $\Delta_{12}$  WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.87.
- $\Delta_{13}$  CUT TO LENGTH AT ASSEMBLY.
- $\Delta_{14}$  QUANTITY OF ITEM 129 IS IN METERS.
- $\Delta_{15}$  ALL BELLMOUTH AND CUTOFF VALUES USED SHOULD BE FROM APPLICATION SPECIFICATION 114-19025.

**\*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	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
-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
			A1		ECR-15-007271	11MAY2015	MR	GB

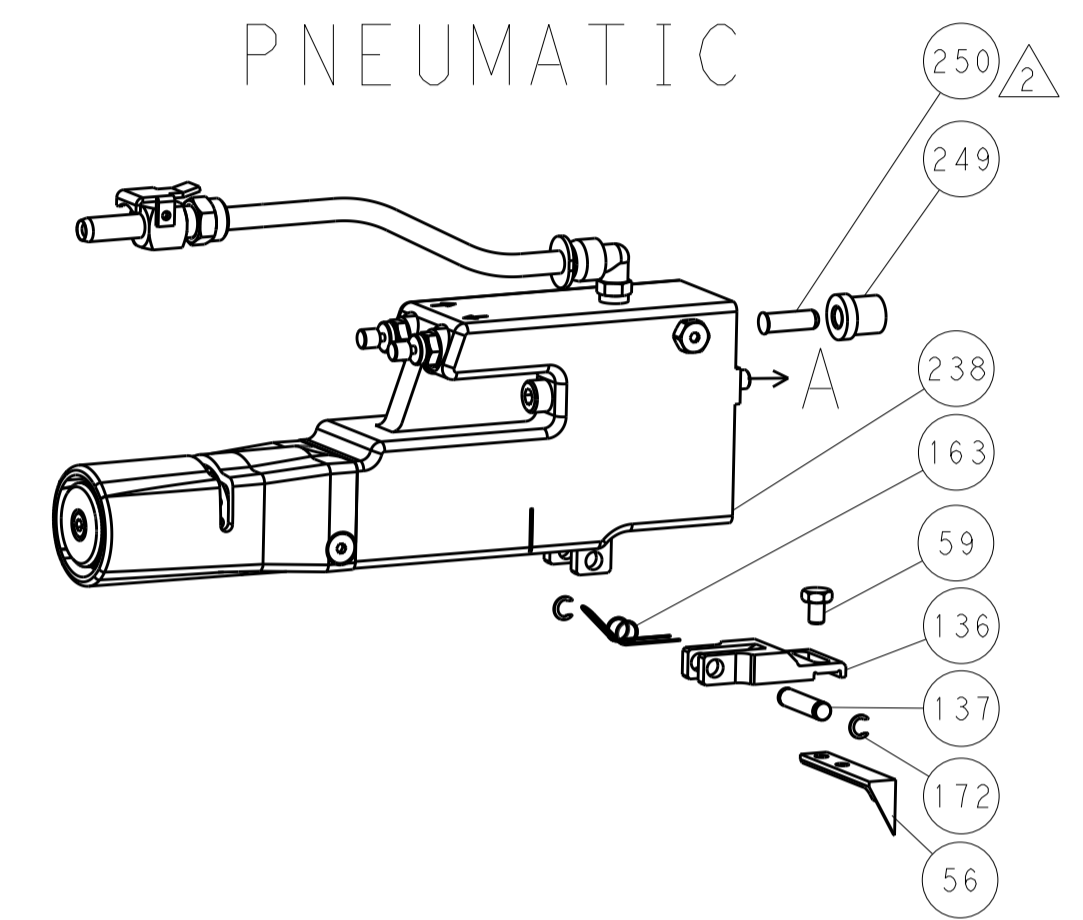
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
$\Delta_6$	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	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	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	143
-	-	-	-	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	2217068-1	BRACKET, AIR BLAST	130
$\Delta_4$	-	-	-	0.5m	2030758-3	TUBING, POLYURETHANE	129
-	1	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	127
-	1	1	1	1	986220-3	CLAMP, CABLE, BLACK	126
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	455888-4	SPACER, CRIMPER	120
-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	23238-1	INSERT, COUPLING	101
-	1	1	1	1	3-690712-4	FRONT STRIP GUIDE	96
$\Delta_3$	-	2	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	455888-3	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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
$\Delta_6$	-	3	-	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	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
-	-	-	-	1	1338685-3	PAWL, FEED	56
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	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	1	1-2119644-2	RAM WASHER, PRECISION	38
$\Delta_6$	-	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	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	2-1320908-4	SPACER, STRIP GUIDE	30
-	1	1	1	1	1-1901086-9	PLATE, STRIP GUIDE	29
-	2	2	2	2	22281-6	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	6-690754-5	DRAG, SPECIAL	25
-	1	1	1	1	7-690440-0	GUIDE, REAR STRIP	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	4	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-6	STRIPPER, SIDE FEED	19
$\Delta_7$	-	1	1	1	3-853720-9	BLADE, SLUG	15
$\Delta_7$	-	1	1	1	1-853721-3	BLADE, SLUG	10
$\Delta_7$	-	1	1	1	2-1803012-8	PLATE, REAR SHEAR	9
$\Delta_7$	1	1	1	1	1803010-3	ANVIL, SPECIAL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	-	-	-	-	-	-	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
$\Delta_7$	1	1	1	1	9-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
$\Delta_7$	1	1	1	1	4-456408-0	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC $\pm$	1 PLC $\pm 0.5$	2 PLC $\pm 0.13$	3 PLC $\pm 0.013$	4 PLC $\pm 0.001$	ANGLES $\pm$	FINISH	20JAN2015	20JAN2015	L. HUANG	L. ZHANG
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
						A1		00779		C=2151008	
Customer Accessible Production Drawing				SCALE		SHEET		1		OF 4	

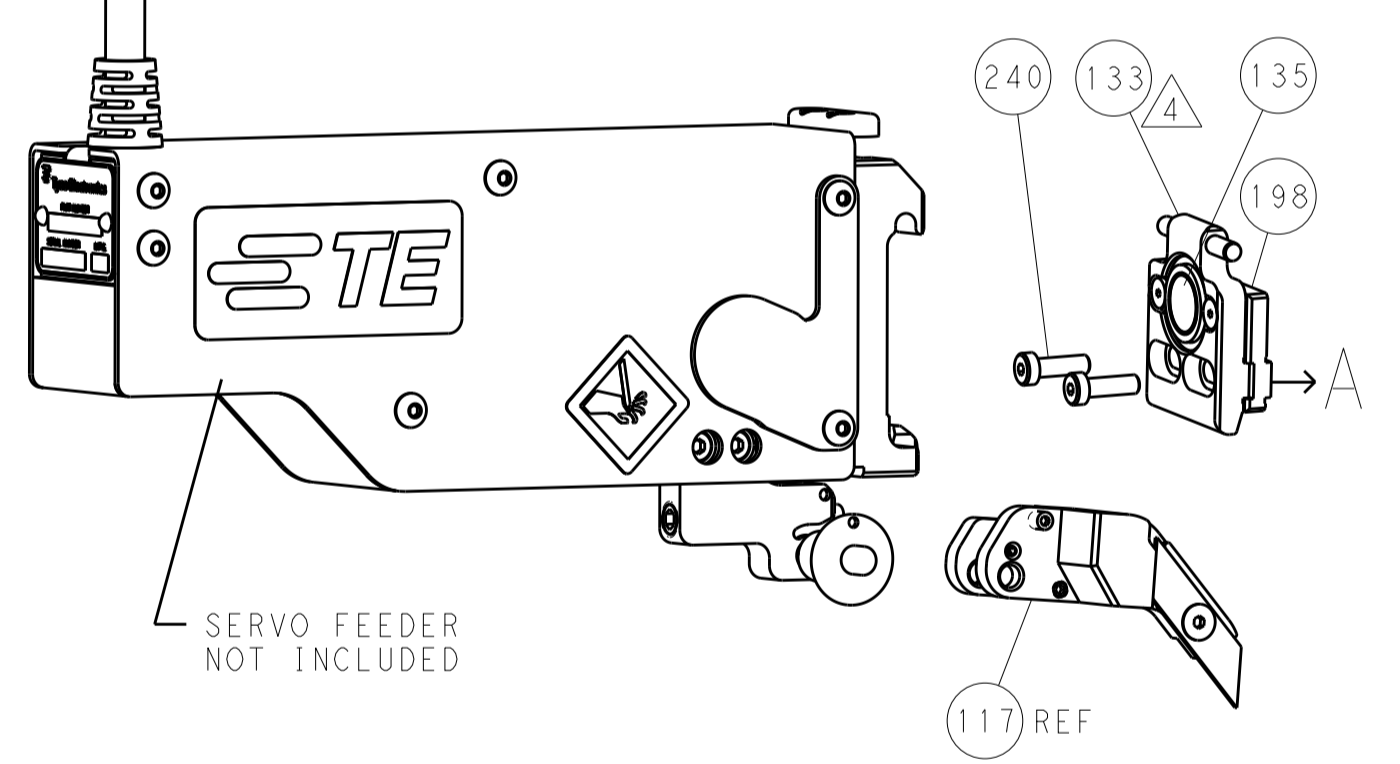
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

### FEED TYPE

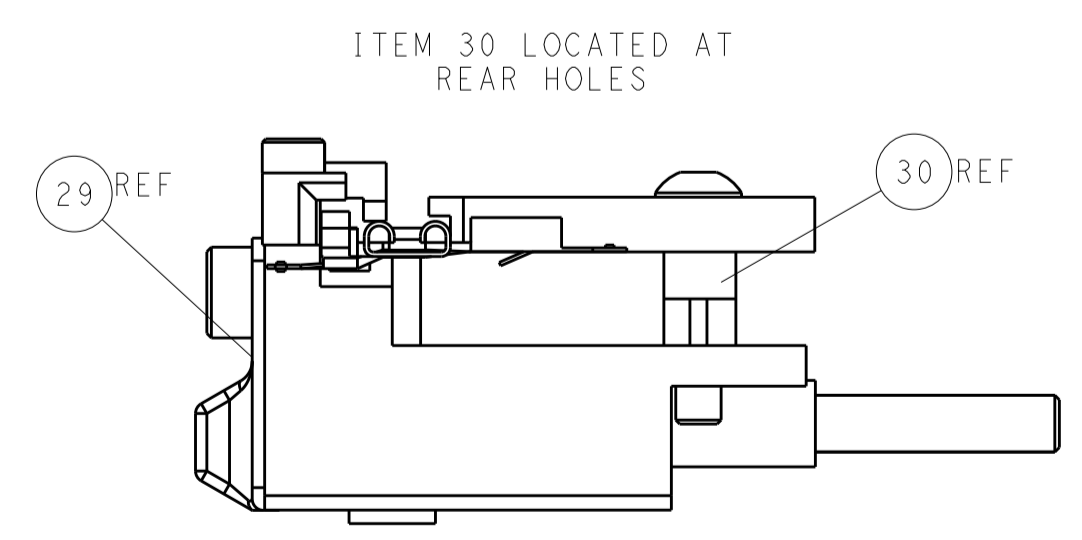
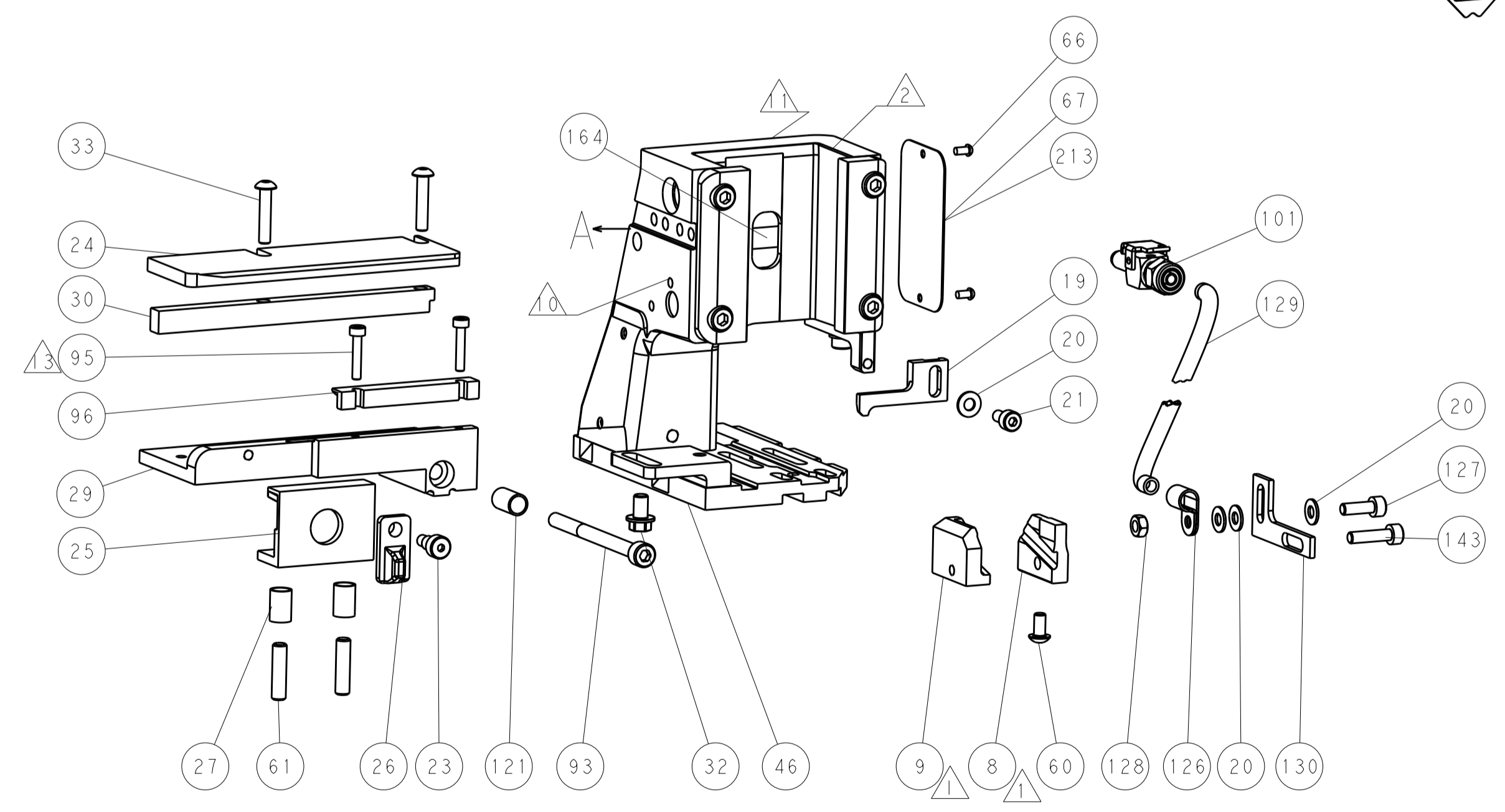
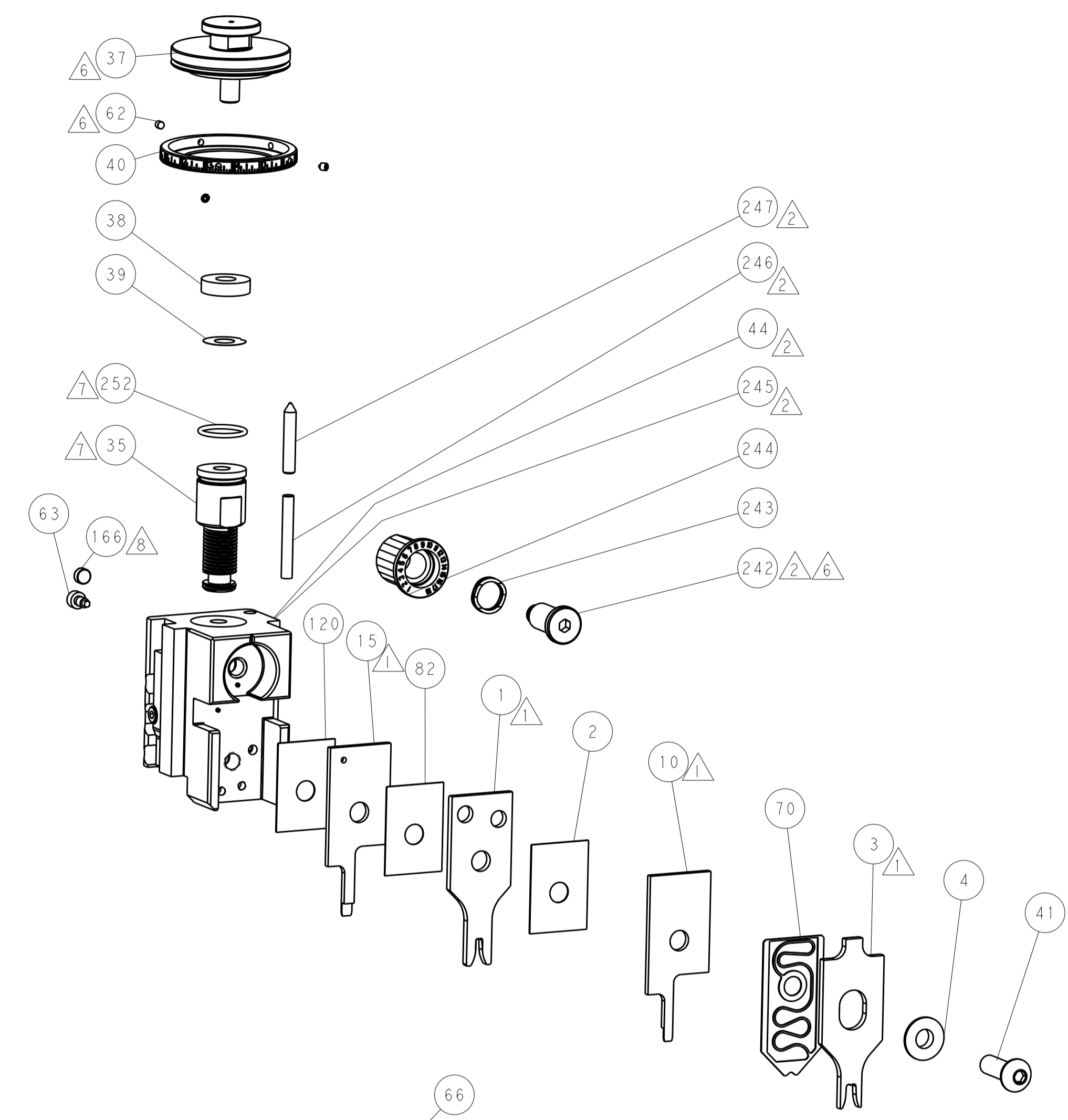
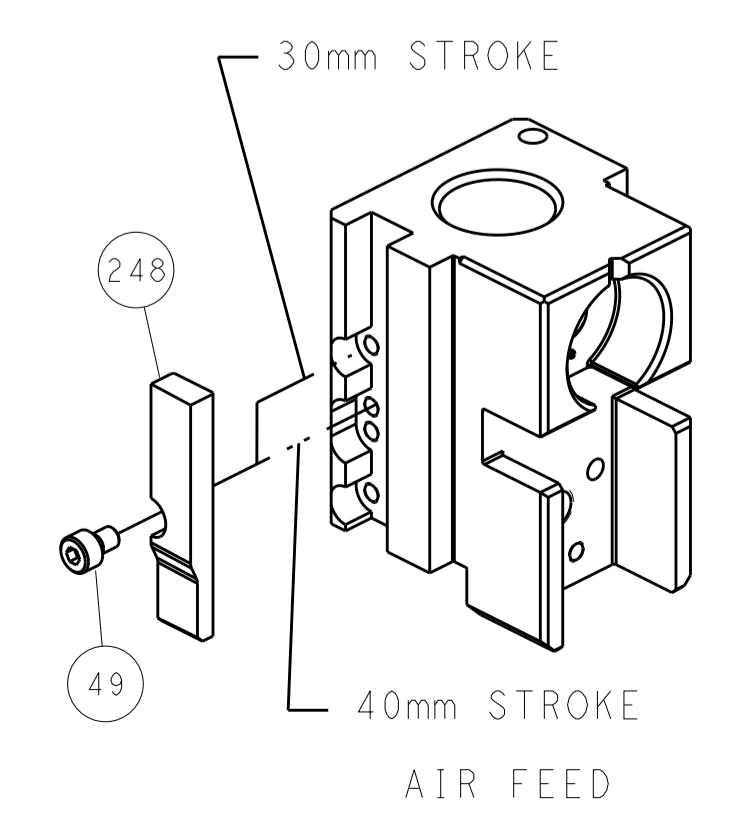
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITION



FEED TRACK POSITION GUIDE BY INSULATION AND BODY

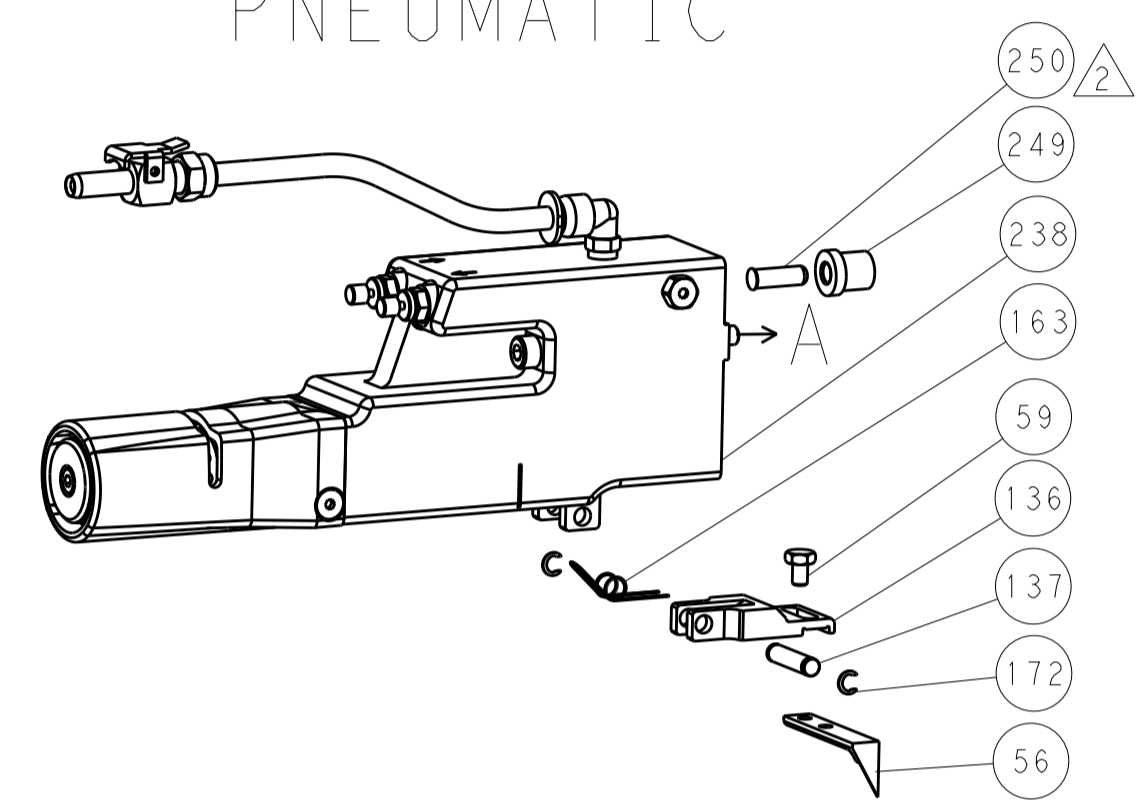
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		DWN R. HUANG 20JAN2015 CHK L. ZHANG 20JAN2015 APVD H. GUO 20JAN2015		NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151008	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 2 OF 4 REV A1	

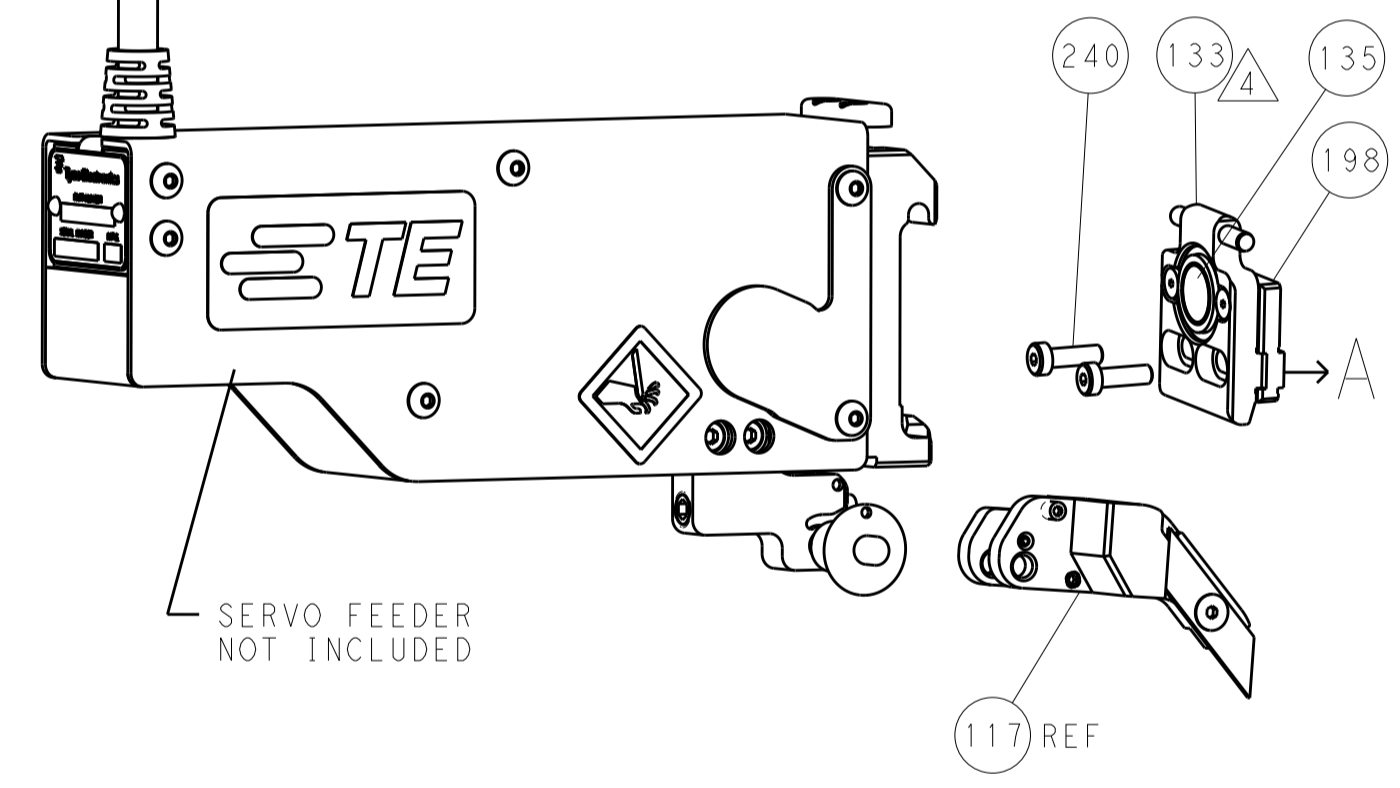


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

### FEED TYPE PNEUMATIC



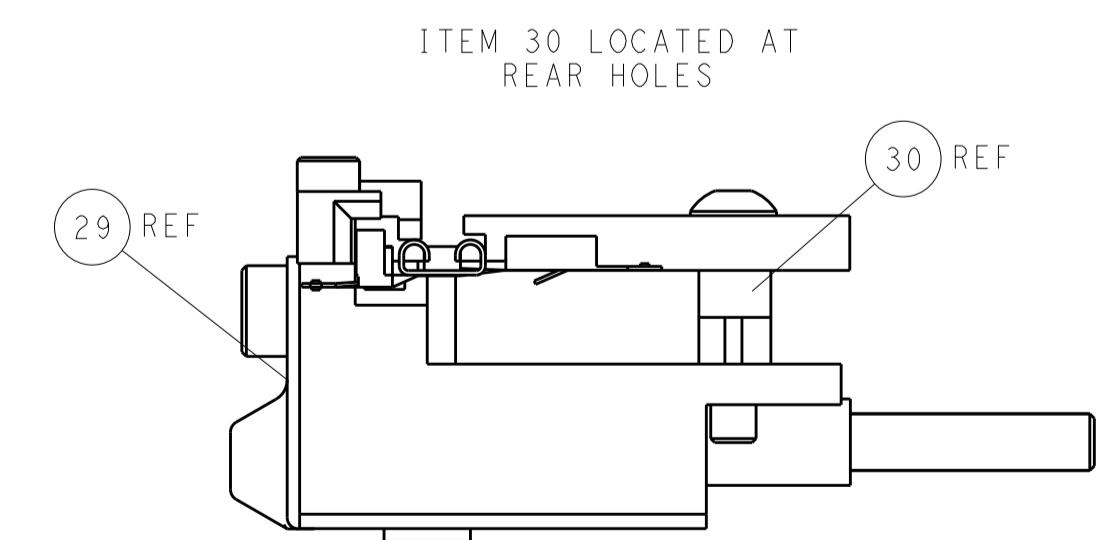
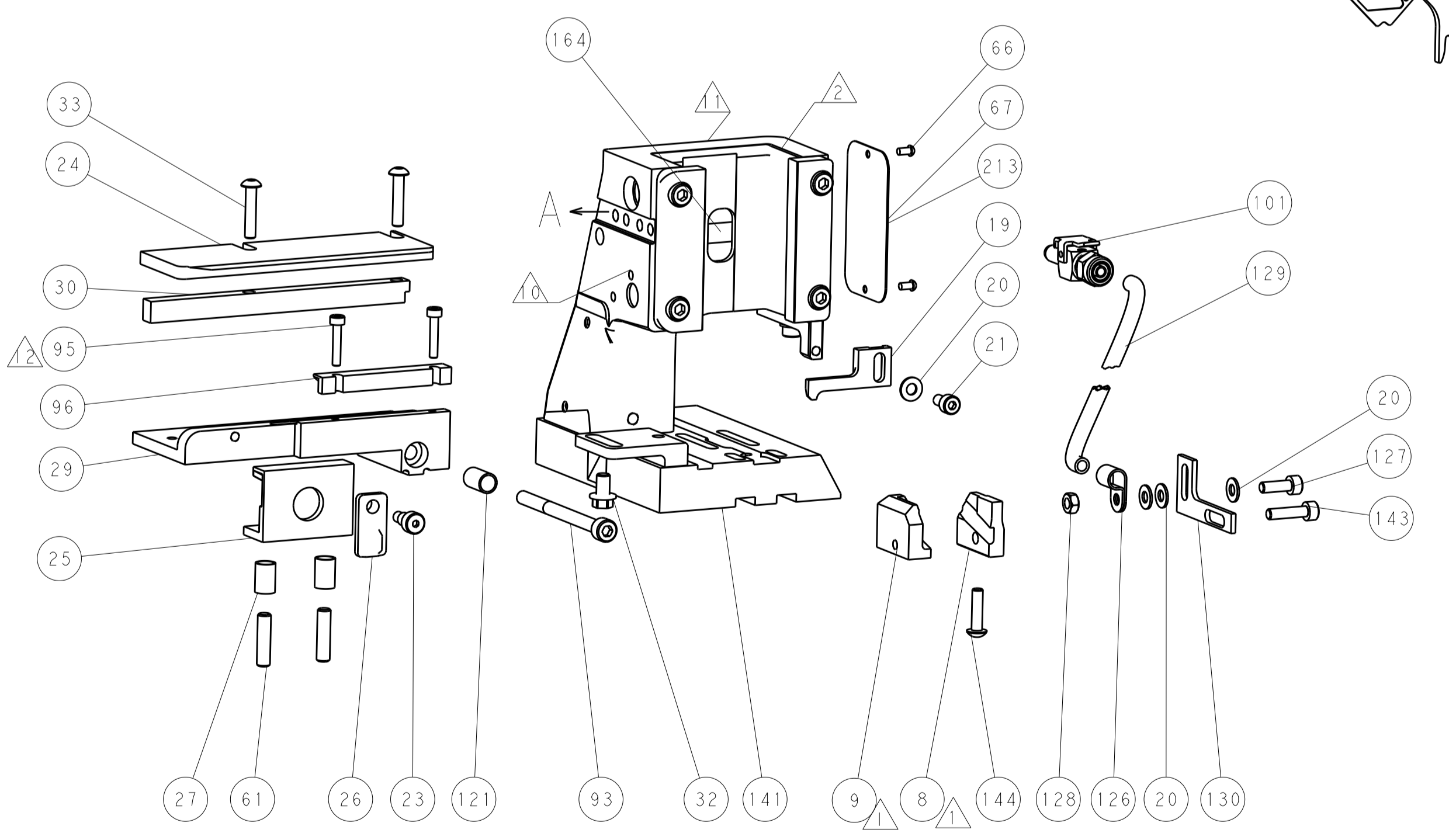
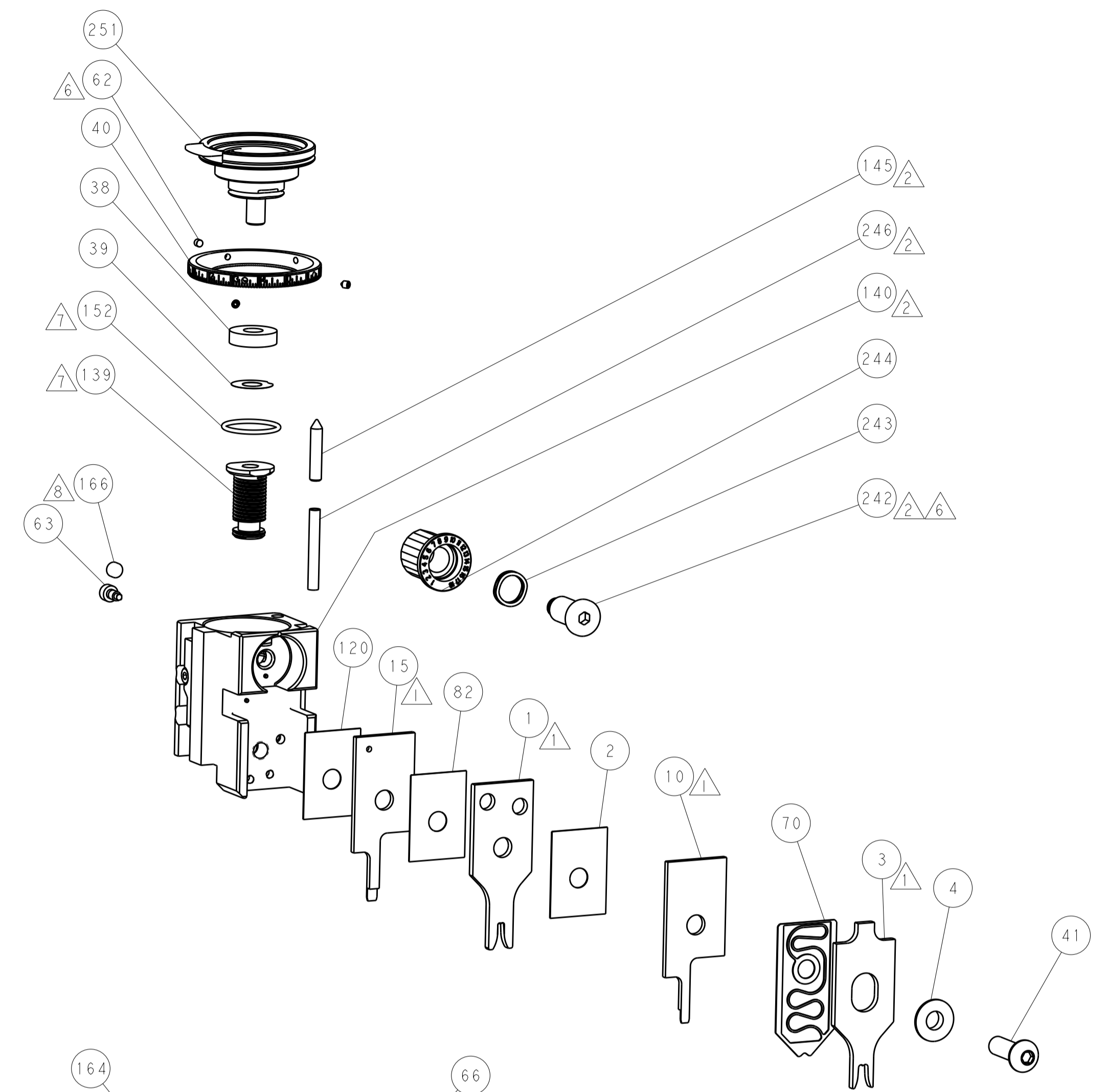
### SERVO LATCH PLATE



### CAM POSITION



AIR FEED



FEED TRACK POSITION  
GUIDE BY INSULATION AND BODY

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

<small>THE DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF MERCHANTABILITY. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: H. HUANG 20JAN2015 CHK: L. ZHANG 20JAN2015 APVD: H. GUO 20JAN2015	NAME: STE TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: A1 00779 Customer Accessible Production Drawing	SIZE: CAGE CODE DRAWING NO: 2151008 SCALE: 1:2 SHEET 4 OF 4 REV A1