

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2151946-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151946-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151946-5	1901094-3	1-1752354-5	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151946-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
	2151946-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151946-5	1901094-3	1-1752354-5	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151946-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
2151946-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
2151946-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151946-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.81 mm [.150]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: RECEPTACLE T-20 FOR BULB ASSEMBLY	
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]	INSULATION DIAMETER RANGE Ø2.00-2.30 mm [.079-.091 IN]
TERMINAL APPLICATION SPECIFICATION 114-61038	
TERMINALS APPLIED	
TE TERMINAL	TE SEAL
2005163-1	963293-1

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WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.85mm2	1.41 +/- 0.05 [.056 +/- .002]	4.8
0.85mm2	1.40 +/- 0.05 [.055 +/- .002]	4.9
0.50mm2	1.30 +/- 0.05 [.051 +/- .002]	6.0
0.50mm2	1.27 +/- 0.05 [.050 +/- .002]	6.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.34 +/- 0.05 [.053 +/- .002]	5.6
18 AWG	1.33 +/- 0.05 [.052 +/- .002]	5.7

- 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: 8-2151946-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151946-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151946-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151946-6
- 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 ITEMS 62. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.39. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 14 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.
- 15 RUNS AVS WIRE.
- 16 RUNS AEXF WIRE.

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 LISED 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.

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
-77	PART NO	DESCRIPTION

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	REV	DATE	BY	APPV
			A	RELEASED	21MAY2013	GH GB
			A1	ECR-16-005746	20APR2016	RS LZ
			A2	ECR-18-011100	12JUL2018	AW TE

-	-	-	-	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
-	-	-	-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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 PNT, 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 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
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	-	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	2119656-9	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	1752356-1	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	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	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	1-1633920-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	1-240641-8	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1-238011-6	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	7-2119784-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1-455888-8	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

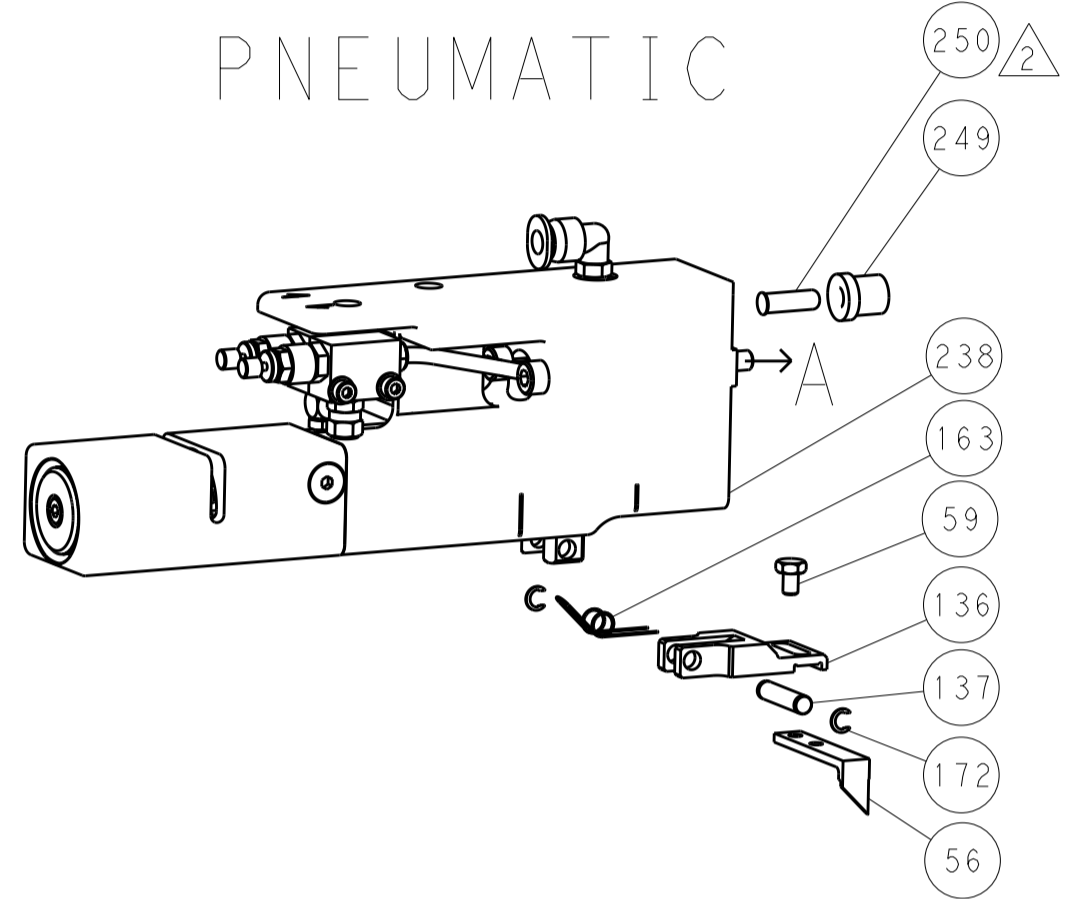
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	3 PLC ±	4 PLC ±	ANGLES ±	24APR2013	T. ELBIN	T. ELBIN					
MATERIAL	FINISH	WEIGHT		Customer Accessible Production Drawing		SCALE	SHEET	1	OF	4	REV
						1:2					A2

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

FEED TYPE MECHANICAL



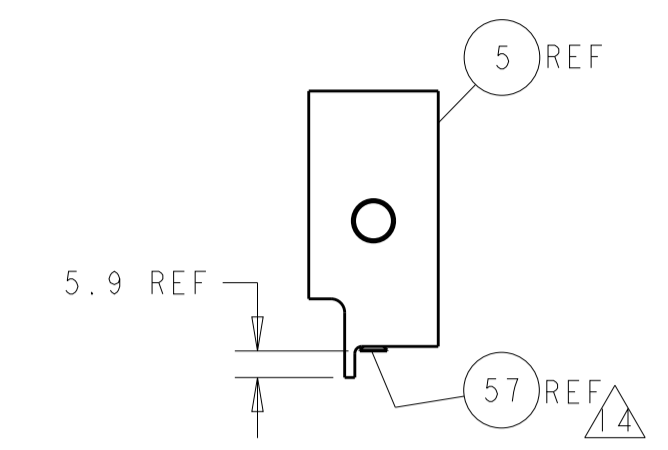
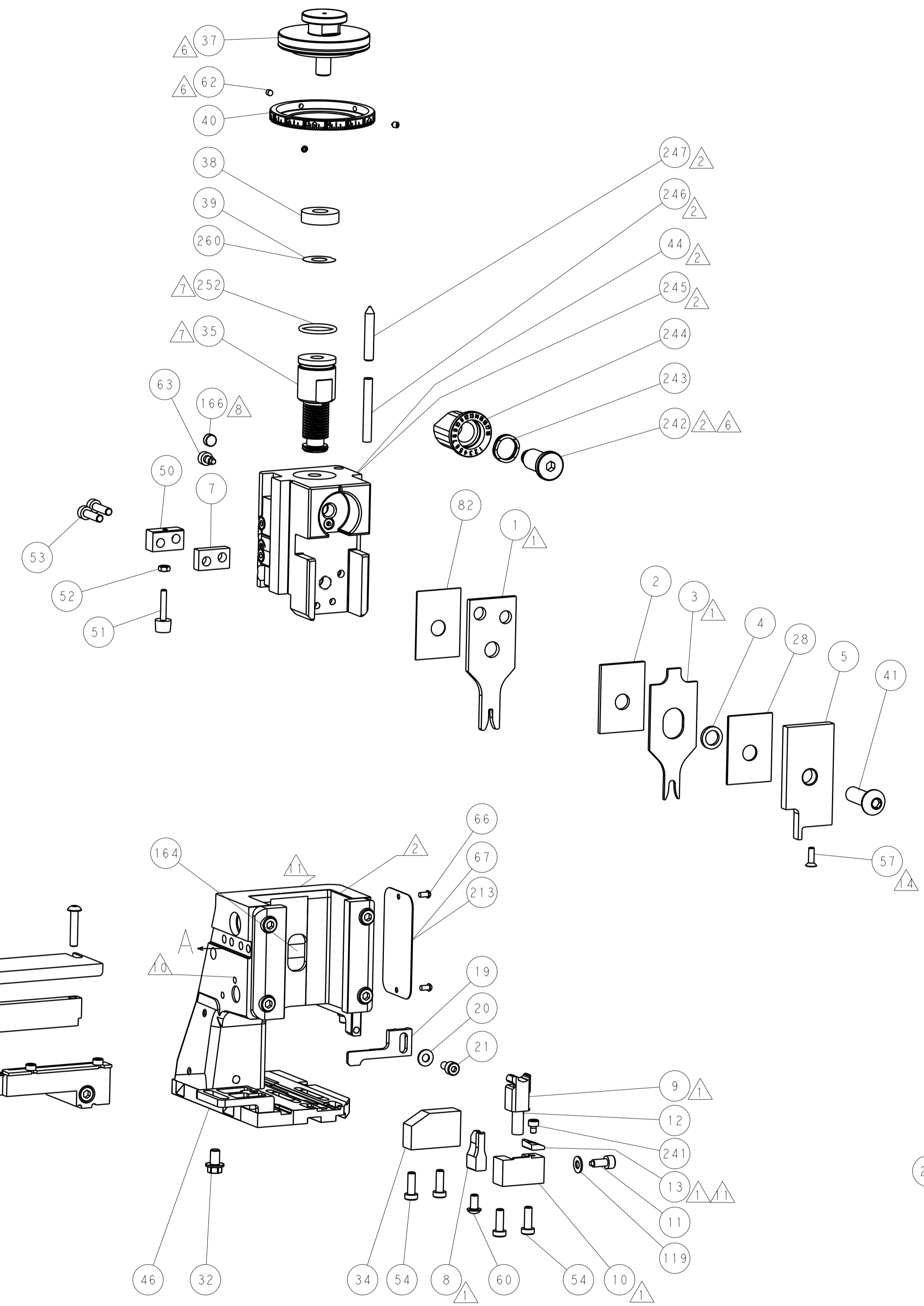
PNEUMATIC



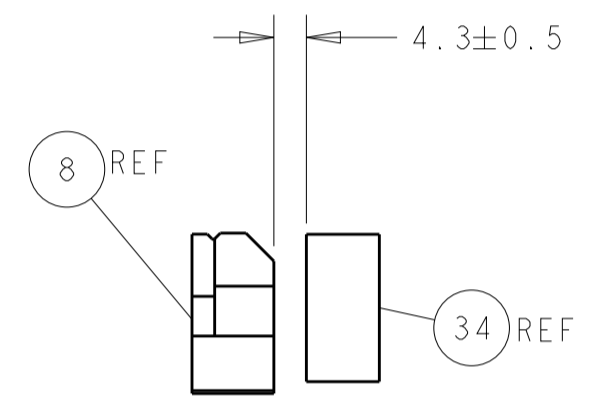
SERVO LATCH PLATE



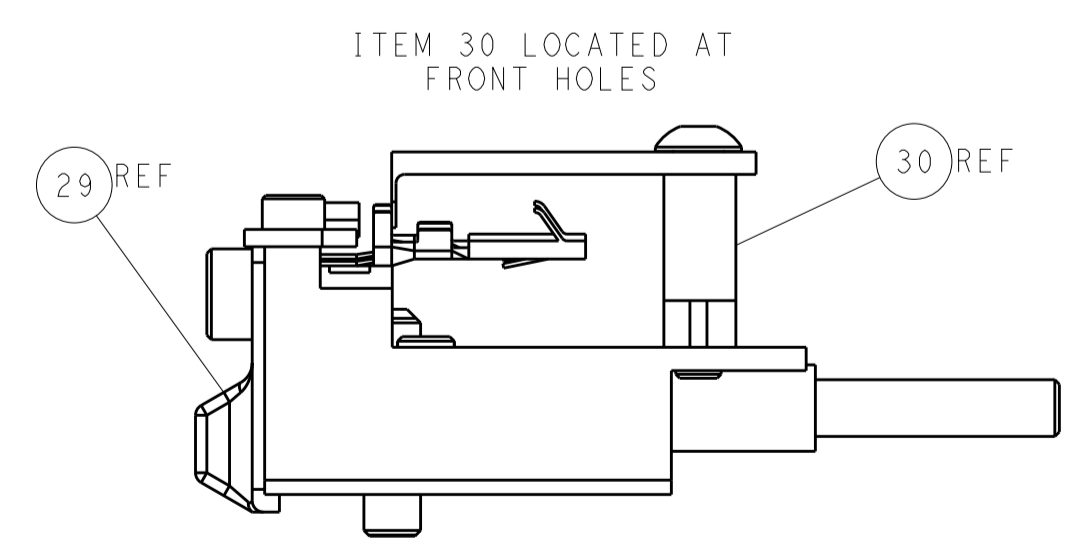
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



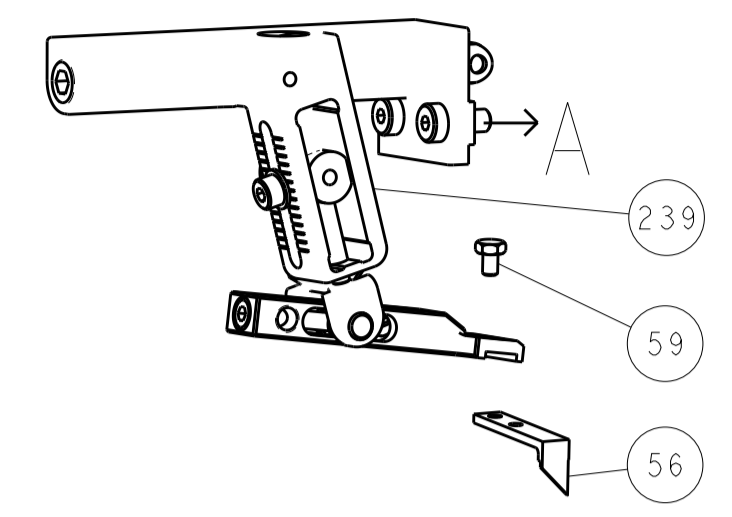
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

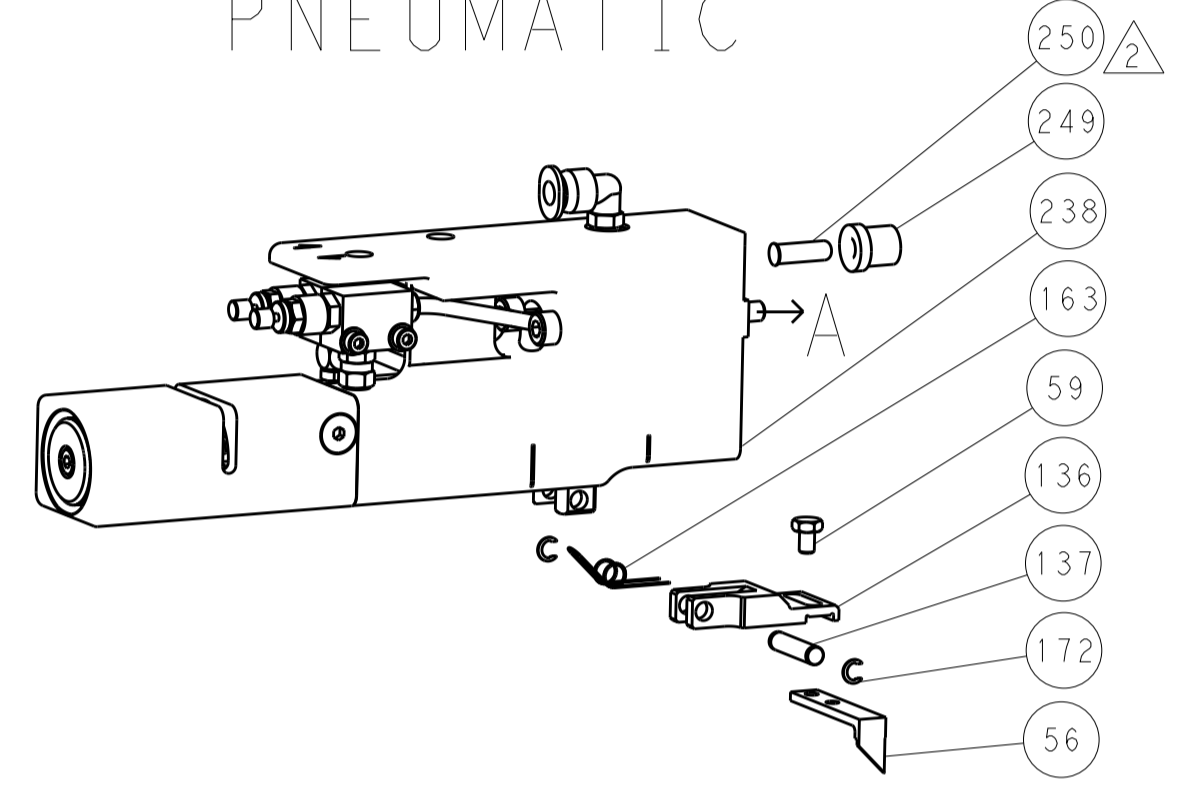
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: T. ELBIN 24APR2013		NAME: Ocean Side Feed Applicator	
				APVD: T. ELBIN 24APR2013		PRODUCT SPEC:	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				WEIGHT:		RESTRICTED TO:	
				Customer Accessible Production Drawing		SCALE: 1:2 SHEET 2 OF 4 REV: A2	

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

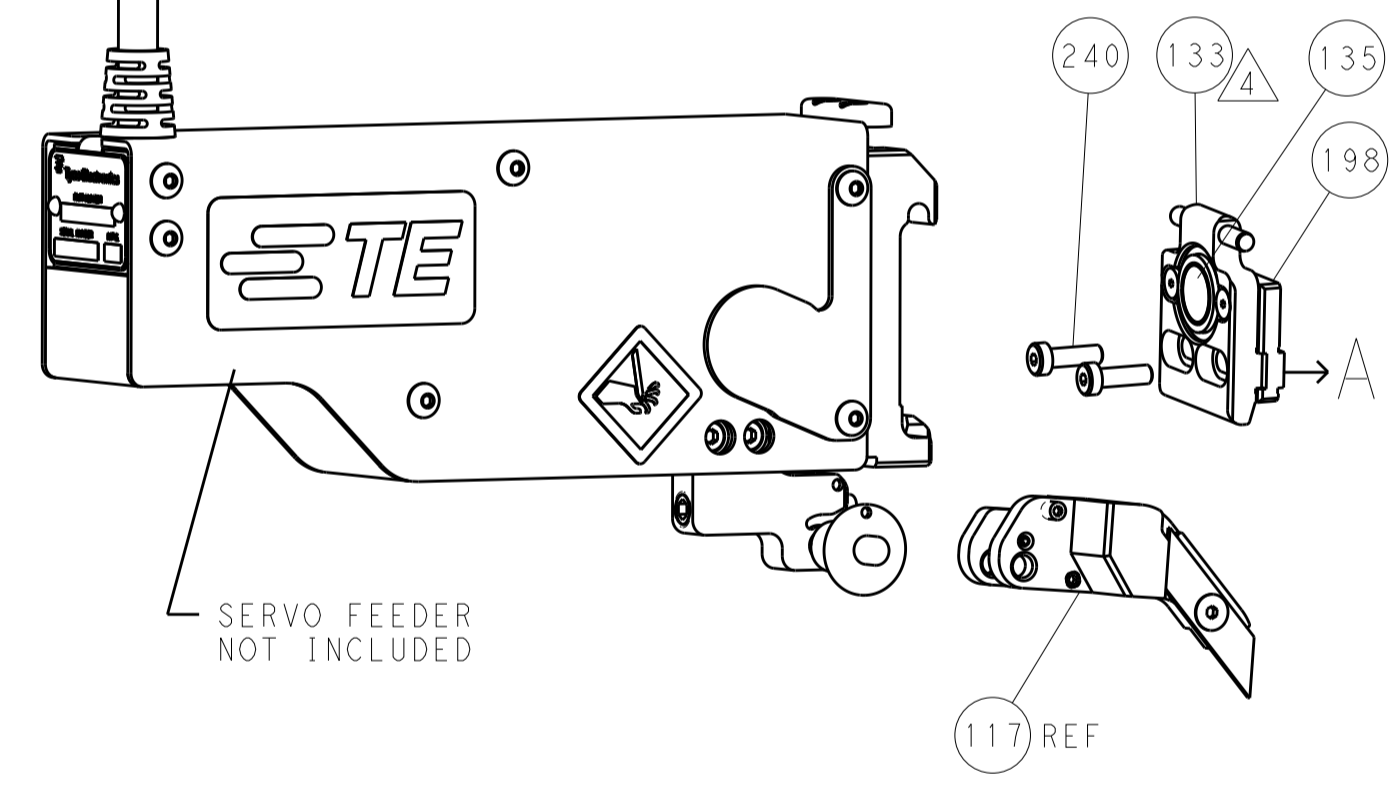
FEED TYPE MECHANICAL



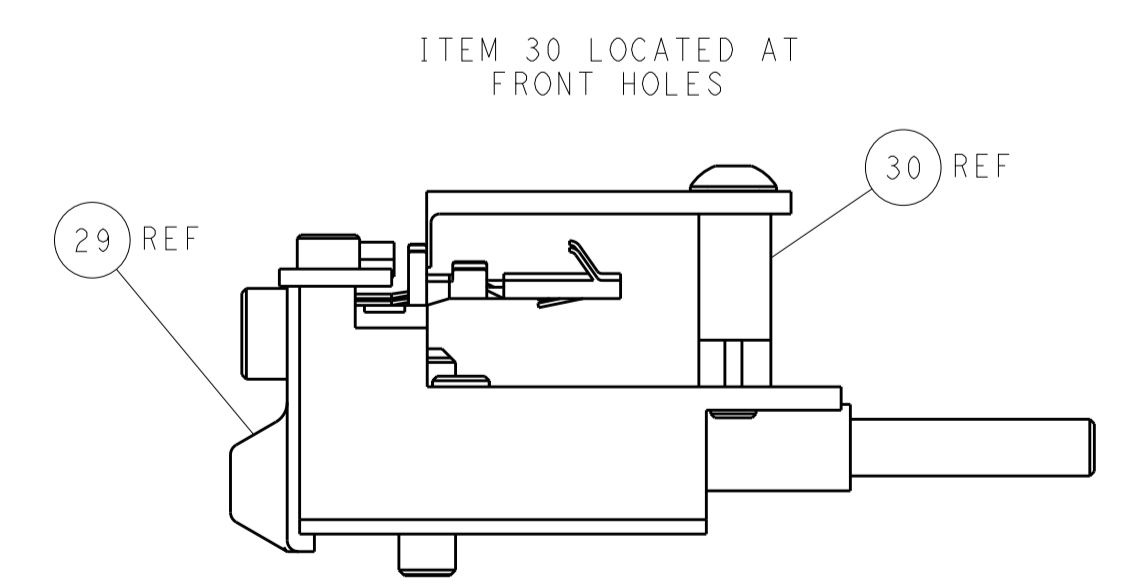
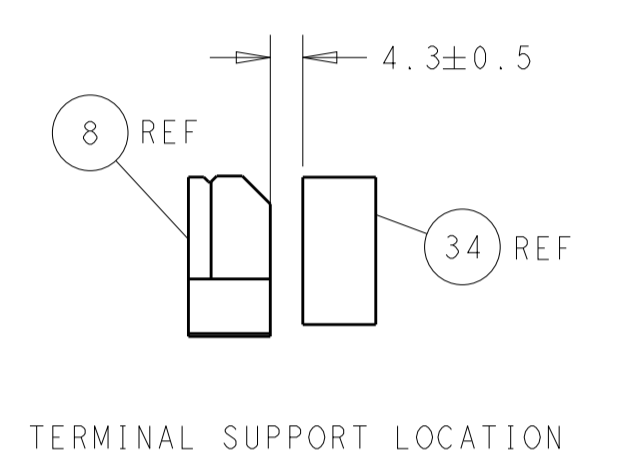
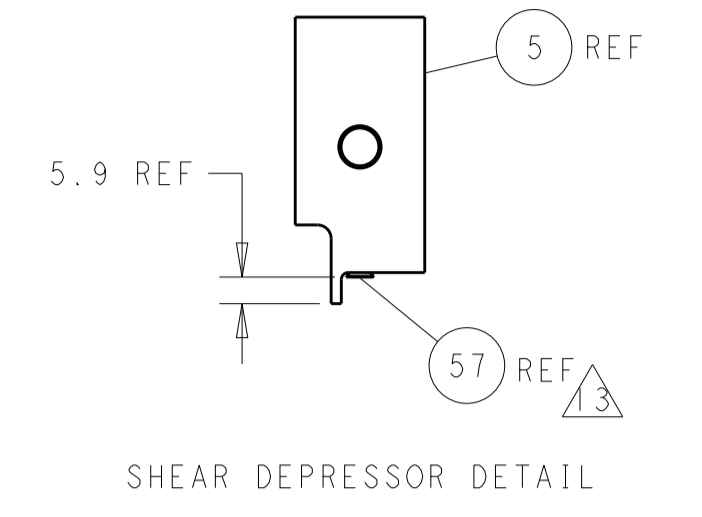
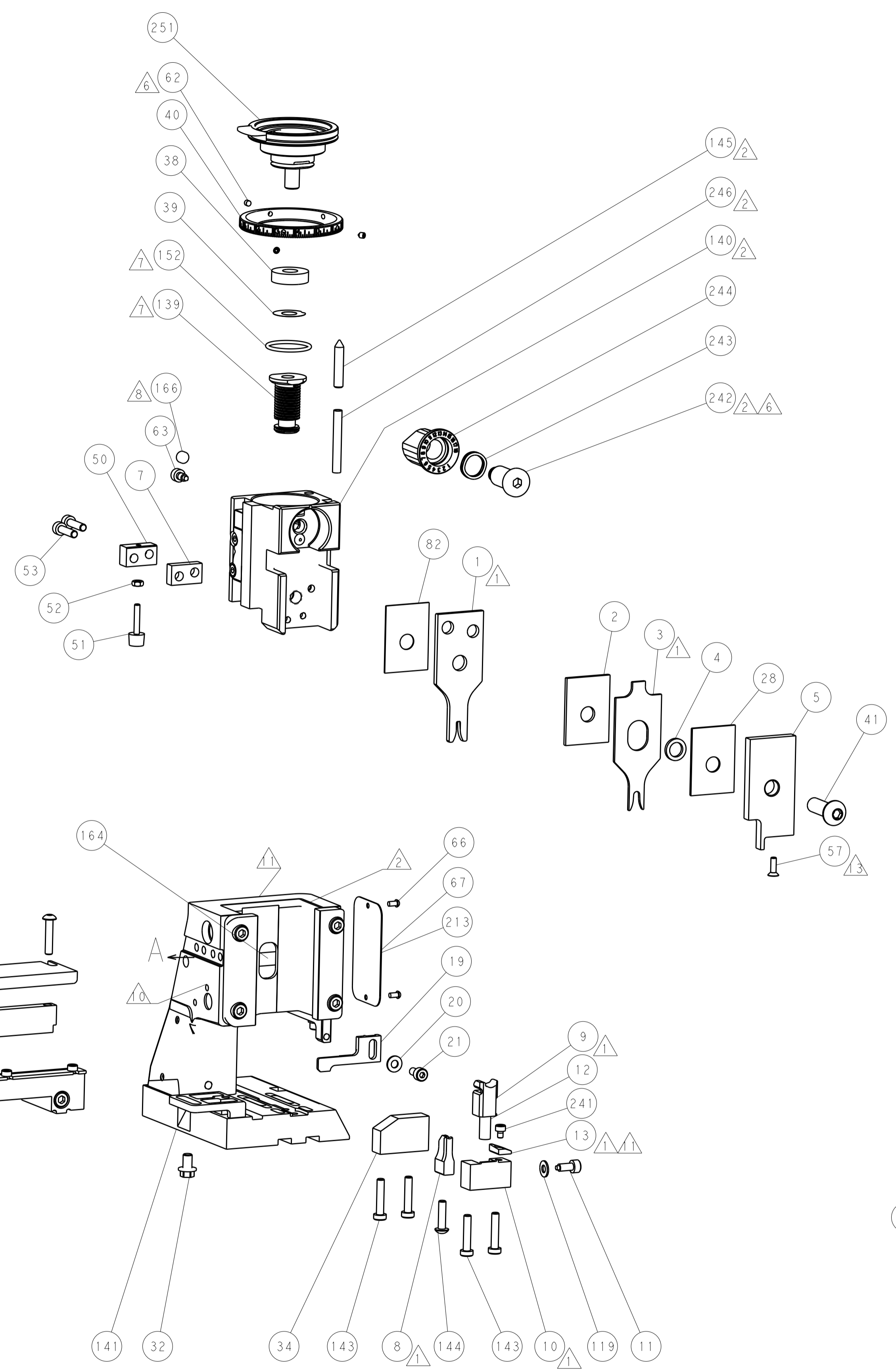
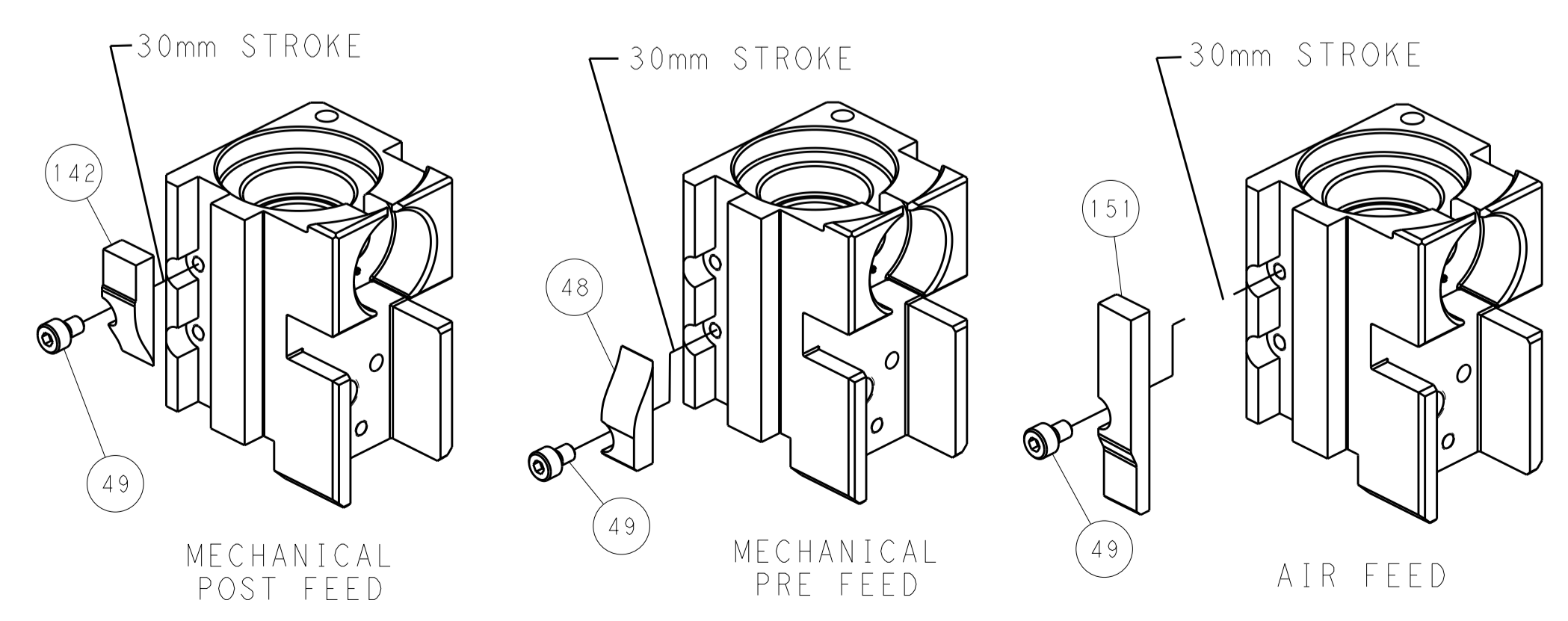
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151946 RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 4 OF 4 REV: A2