

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2151920-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151920-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151920-5	1901094-3	1-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151920-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2151920-5	F	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151920-5	1901094-3	1-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151920-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151920-6	F	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
				-	-	-	-	-	-		
2151920-7	F	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151920-7	D	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.52 mm [.060]	F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: MINI FIT JR OVERALL TIN FEMALE CRIMP TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	2.80-3.30 mm [.110-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		ATS-639020200	

TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572221-1	39000046	1572222-9	39000145
1572221-2	39000065	1572222-5	39000221
1-1572221-1	39000091	1572222-6	39000432
1-1572221-2	39000139	1-1572222-0	40010854
1572221-7	39000183	1-1572222-1	98000175
1572221-8	39000209	1572222-1	39000048
1572221-9	39000215	1572222-2	39000067
1-1572221-8	39000434	1572222-4	39000128
1-1572221-9	46018-2541		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2 OR 22AWG	0.795+/-0.035 [.0315+/-0.0015]	5.9
0.20mm2 OR 24AWG	0.735+/-0.035 [.029+/-0.001]	6.3
0.12mm2 OR 26AWG	0.69+/-0.03 [.027+/-0.001]	7.0
0.08mm2 OR 28AWG	0.66+/-0.03 [.026+/-0.001]	7.4

- 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: 8-2151920-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151920-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151920-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151920-6
- 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 ITEMS 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 5.01.

***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	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
-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			
			P	DATE	BY	APP'D
			D	ECR-15-011784	06AUG2015	MR GB
			E	ECR-15-014135	25SEP2015	KH TE
			F	ECR-15-016803	18NOV2015	XZ TE

6	-	1	-	1	1	2119798-1	DETENT PIN	247
	-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
	-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	-	-	2063440-1	AIR FEED MODULE	238
	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
6	-	1	1	1	1	1-1752354-6	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	-	-	MEMORY CHIP, PROGRAMMED	135
	-	-	1	1	-	1633743-1	SERVO FEED LATCH ASM	133
	-	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	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	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
	-	-	-	-	1	1338685-1	PAWL, FEED	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
	-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
	-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
	-	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	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	1	1-2119644-4	RAM WASHER, PRECISION	38
6	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
7	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	1752356-1	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	1320908-6	SPACER, STRIP GUIDE	30
	-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	28
	-	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1	1	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	1-356885-3	STOP, SHEAR	11
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	-	1	1	1	1	1-1633917-4	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	-	1	1	1	1	6-1633961-8	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	-	1	1	1	1	6-456402-4	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	BY	APP'D	NAME
mm		0 PLC	±	29MAR2013	J. YIN		G. BAILEY
		1 PLC	±0.5				
		2 PLC	±0.13				
		3 PLC	±0.013				
		4 PLC	±0.001				
		ANGLES	±0.0001				
		FINISH	±				

PRODUCT SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
APPLICATION SPEC	A1	00779	2151920	-

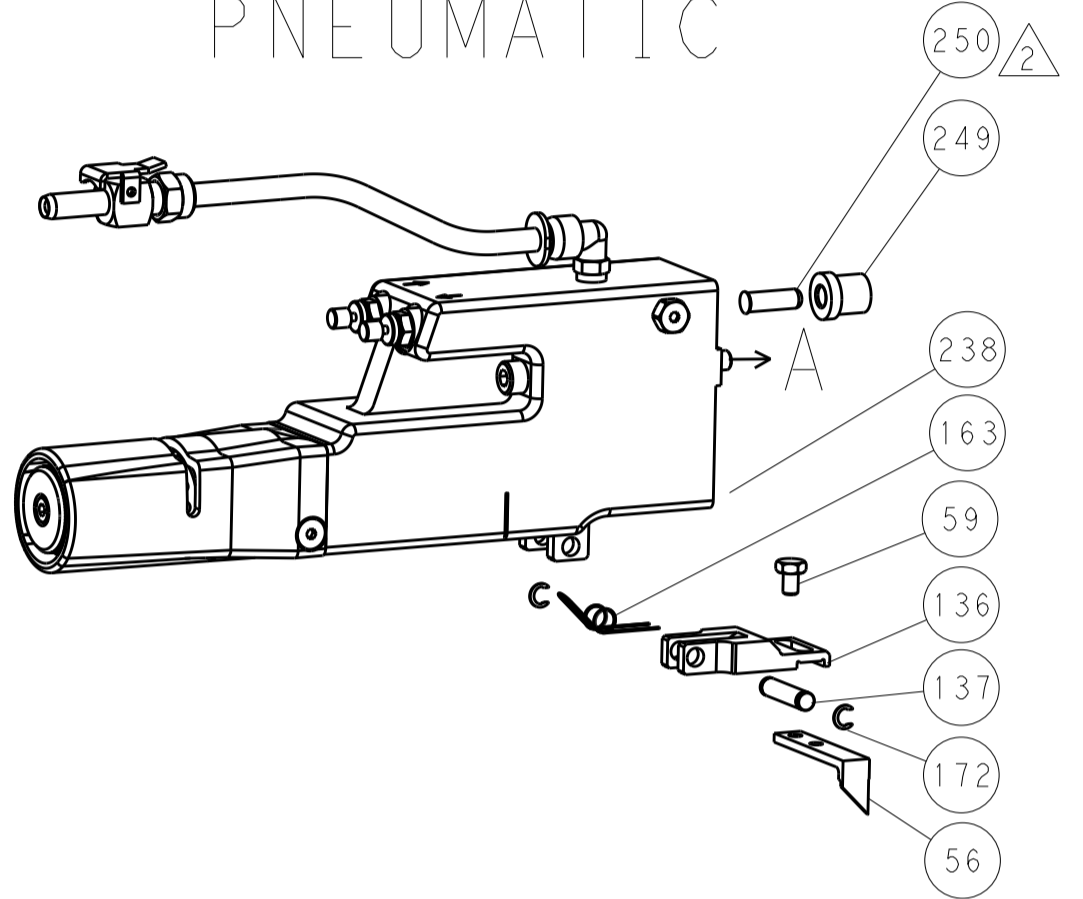
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV F

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

FEED TYPE MECHANICAL



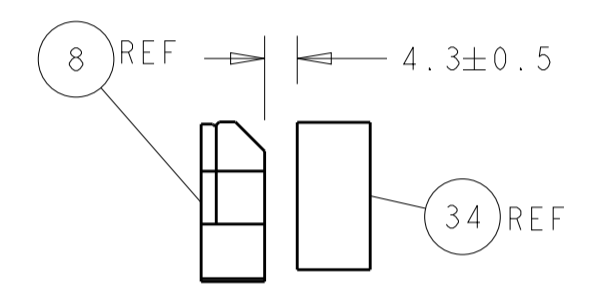
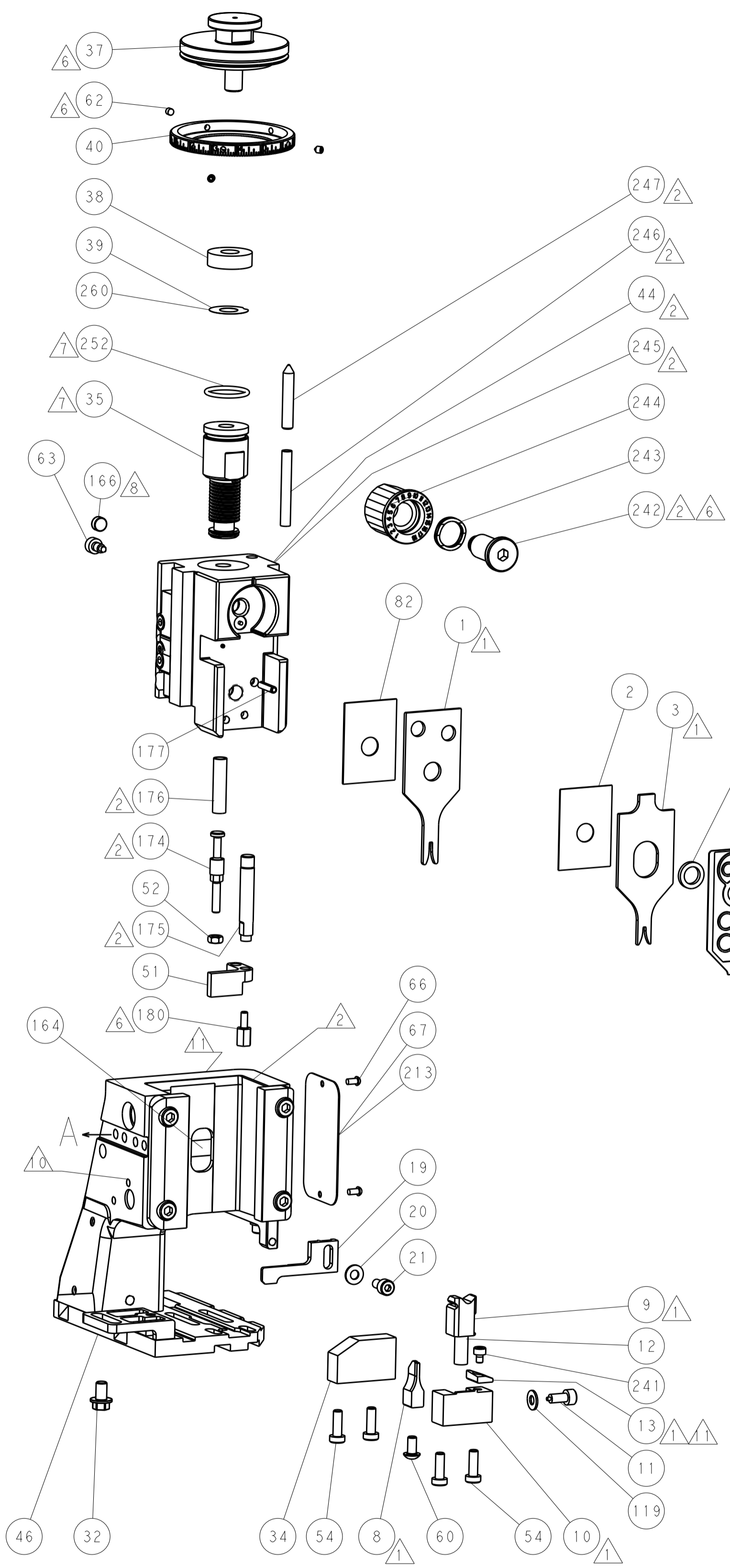
PNEUMATIC



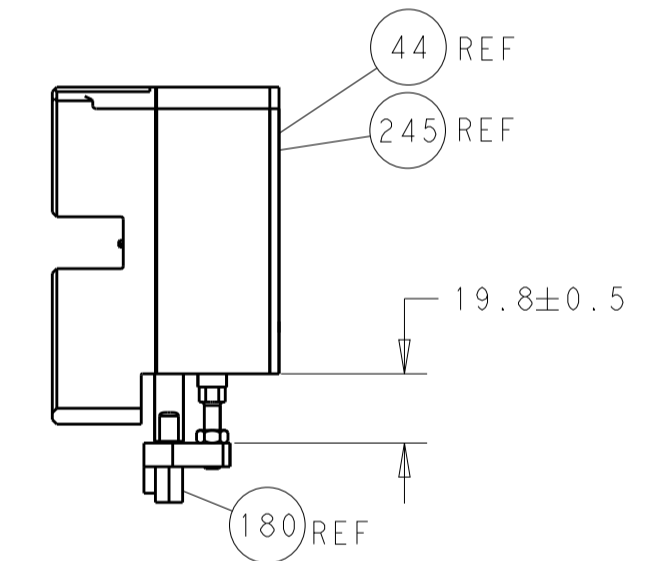
SERVO LATCH PLATE



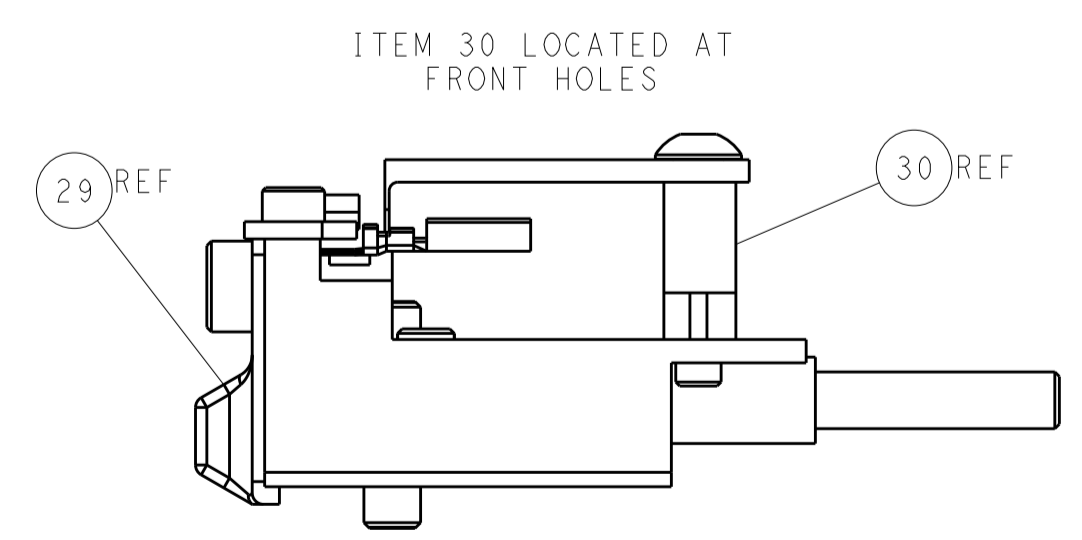
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INS. BARREL

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 3 PLC ±0.13 4 PLC ±0.013 ANGLES ±0.0001		DWN Y. YIN 29MAR2013 CHK G. BAILEY 29MAR2013 APVD H. GUO 29MAR2013		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
WEIGHT:		SCALE: 1:2		SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151920		SHEET 2 OF 4 REV F	

Table with columns: PACIFIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a drawing of the Pacific Version Terminator Interface Adapter.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH and INSULATION DIAMETER RANGE.

TERMINAL APPLICATION SPECIFICATION table with columns: TE TERMINAL, MOLEX TERMINAL, TE TERMINAL, MOLEX TERMINAL.

TERMINALS APPLIED table with columns: TE TERMINAL, MOLEX TERMINAL, TE TERMINAL, MOLEX TERMINAL.

Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Includes icons for wire crimping.



- 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.
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 ITEMS 62 & 180.
GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
MAGNET 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.
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 BACK SIDE OF THE HOUSING.

*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, REVISIONS table with columns: P, L, M, DESCRIPTION, DATE, DWN, APVD.

Large table listing various components and their quantities. Columns include part numbers, descriptions like SPRING, COMPRESSION, WASHER, etc., and item numbers.

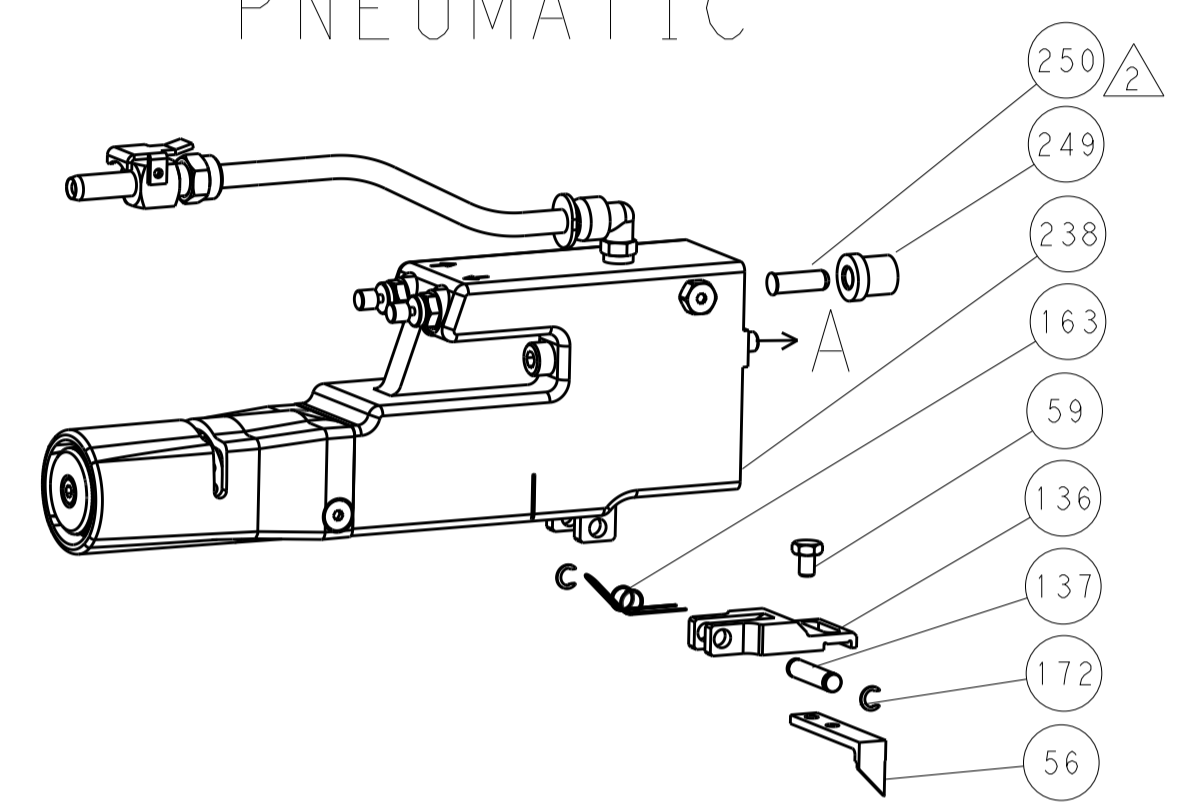
Form with fields for DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE, SHEET 3 OF 4, REV F.

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

FEED TYPE MECHANICAL



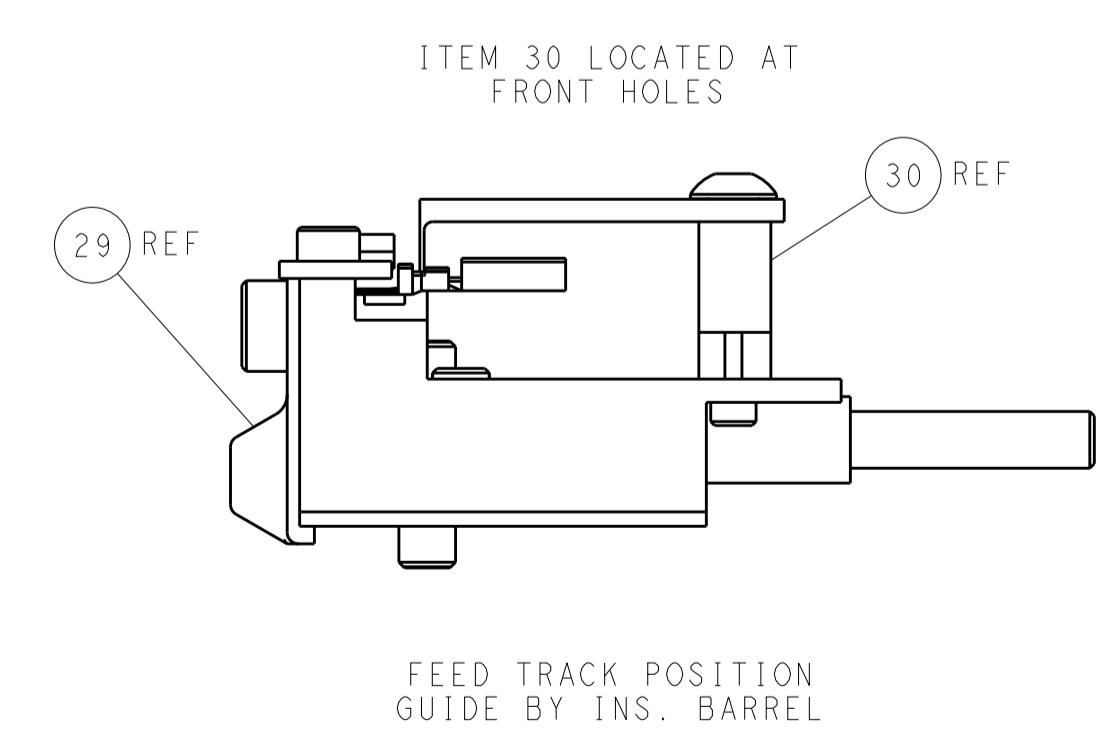
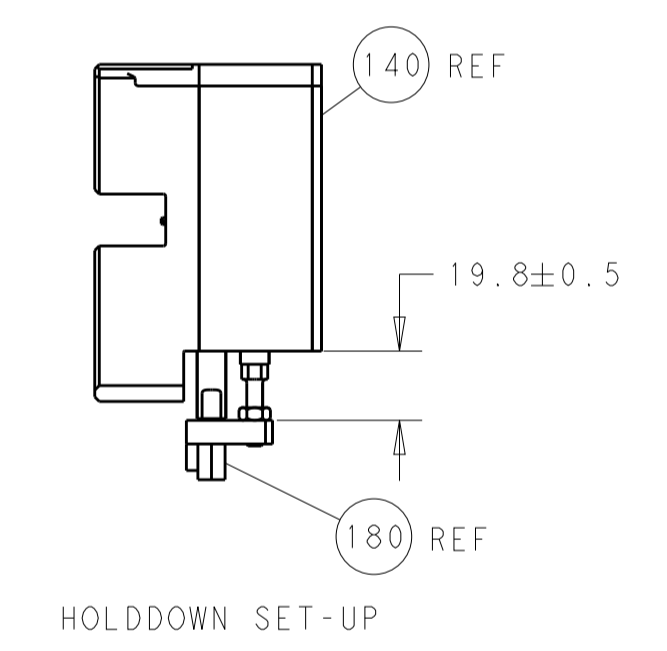
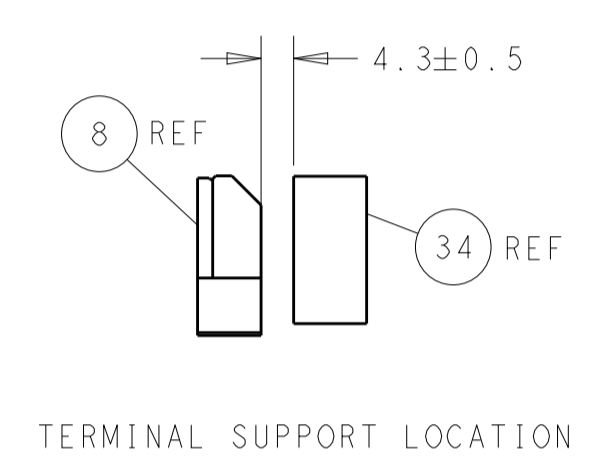
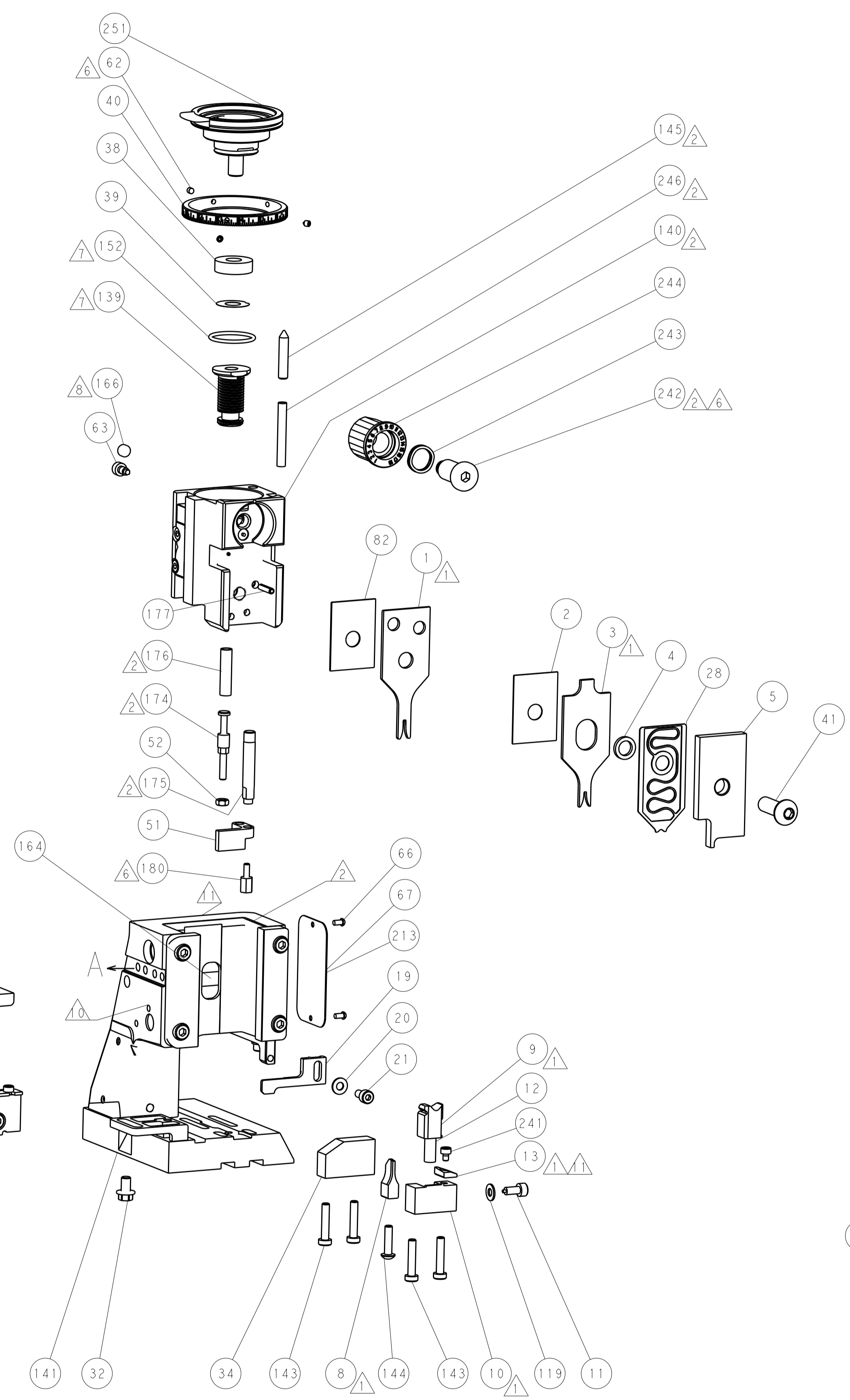
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 29MAR2013		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD G. BAILEY 29MAR2013	NAME Ocean Side Feed Applicator
MATERIAL	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO.	RESTRICTED TO
			1:2	A1	00779	©=2151920	
Customer Accessible Production Drawing				SHEET	4	OF 4	REV F