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APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED (2119950-1 to 2063440-1), and rows for Pneumatic Feed, Servo Latch Plate, Smart Applicator, Mechanical Feed, Servo Latch Plate, Smart Applicator, Mechanical Feed, Pneumatic Feed.

APPLICATOR DATA. Table with columns: CRIMP SIZE, WIRE SIZE, INSUL SIZE, and TYPE. Includes APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Includes table for Wire Strip Length vs Insulation Diameter Range and TERMINALS APPLIED table.

WIRE SIZE vs CRIMP HEIGHT mm [INCH] vs CRIMP HEIGHT REFERENCE SETTING table.

- 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.

*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 6 columns: Item No, Part No, Description, Item No. Lists items 261, 260, 252, 249, 248, 247.

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

REVISIONS. Table with columns: REVISIONS, DESCRIPTION, DATE, DWN, APVD.

Large parts list table with columns: Part No, Description, Date, Dwn, Apvd. Lists numerous components like SPRING, RAM, CAM, WASHER, RETAINER, SCR, SHCS, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, TAG, IDENTIFICATION, SPACER, FEEDER, STANDOFF, HOLD-DOWN, PIN, SLOTTED SPRING, SPRING, GUIDE PIN, RING, MAGNET, COUNTER, SPRING, FEED FINGER, PIN, RETAIN, GRVD, HOLDER, FEED FINGER, AF, MEMORY CHIP, SERVO FEED LATCH ASM, WASHER, FEED FINGER ASSEMBLY, SF, SPACER, CRIMPER, TOOL, SIZING, DOCUMENTATION PACKAGE, TAG, IDENTIFICATION, SCREW, DRIVE, RH, RoHS, LIMITER, ADJUSTMENT BOLT, SCR, SET, SOC, CONE POINT, SCR, BHSC, PAWL, FEED, SHCS, LOW HEAD, NUT, HEX, REG, HoHS, HOLDDOWN, TERMINAL, SCR, SKT HD CAP, FEED CAM, PRE FEED, FEED CAM, POST FEED, APPLICATOR BASIC ASSEMBLY, SF, RAM, AMP STYLE, SIDE FEED, SCR, BHSC, DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, PRECISION, FA HEAD, ATLANTIC STYLE, BOLT, ADJUSTMENT, SUPPORT, TERMINAL, SCR, BHSC, HEX HEAD, FLANGED, SPACER, STRIP GUIDE, ASSEMBLY, STRIP GUIDE, SPACER, CRIMPER, STRIP GUIDE, SCR, SKT HD CAP, RoHS, WASHER, FLAT, REG M4, STRIPPER, SIDE FEED, INSERT, SHEAR, SPRING, COMPRESSION, STOP, SHEAR, SHEAR HOLDER, FRONT, SHEAR, FLOATING, ANVIL, COMBINATION, DEPRESSOR, SHEAR, BLOCK, CRIMPER SPACER, CRIMPER, INSULATION F PREMIUM, SPACER, CRIMPER, CRIMPER, WIRE PREMIUM.

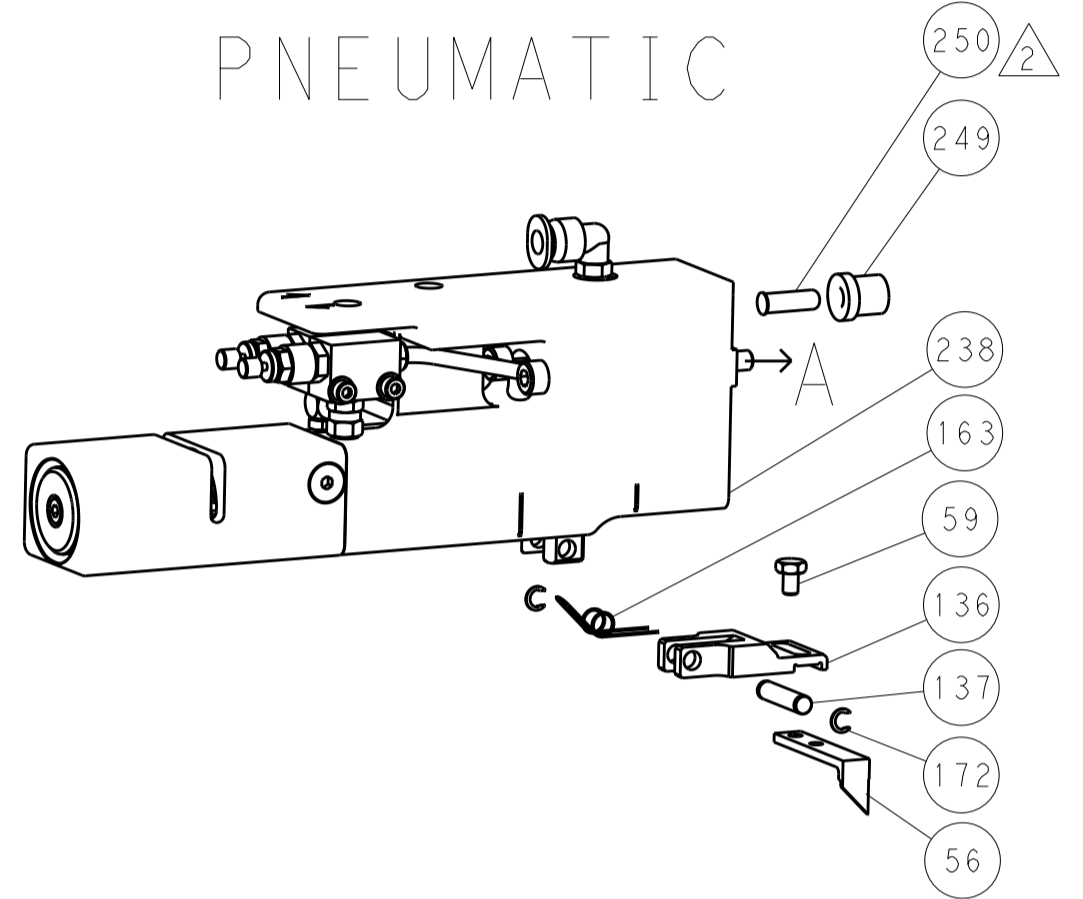
Customer Accessible Production Drawing. Includes dimensions, tolerances, material, weight, and drawing info like APVD: 27JUN2013.

REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LTN	DESCRIPTION		
		SEE SHEET 1		

FEED TYPE MECHANICAL



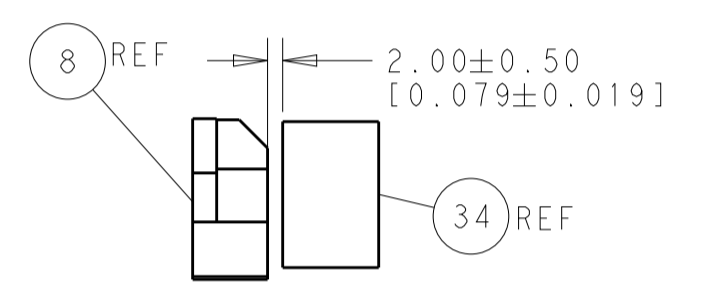
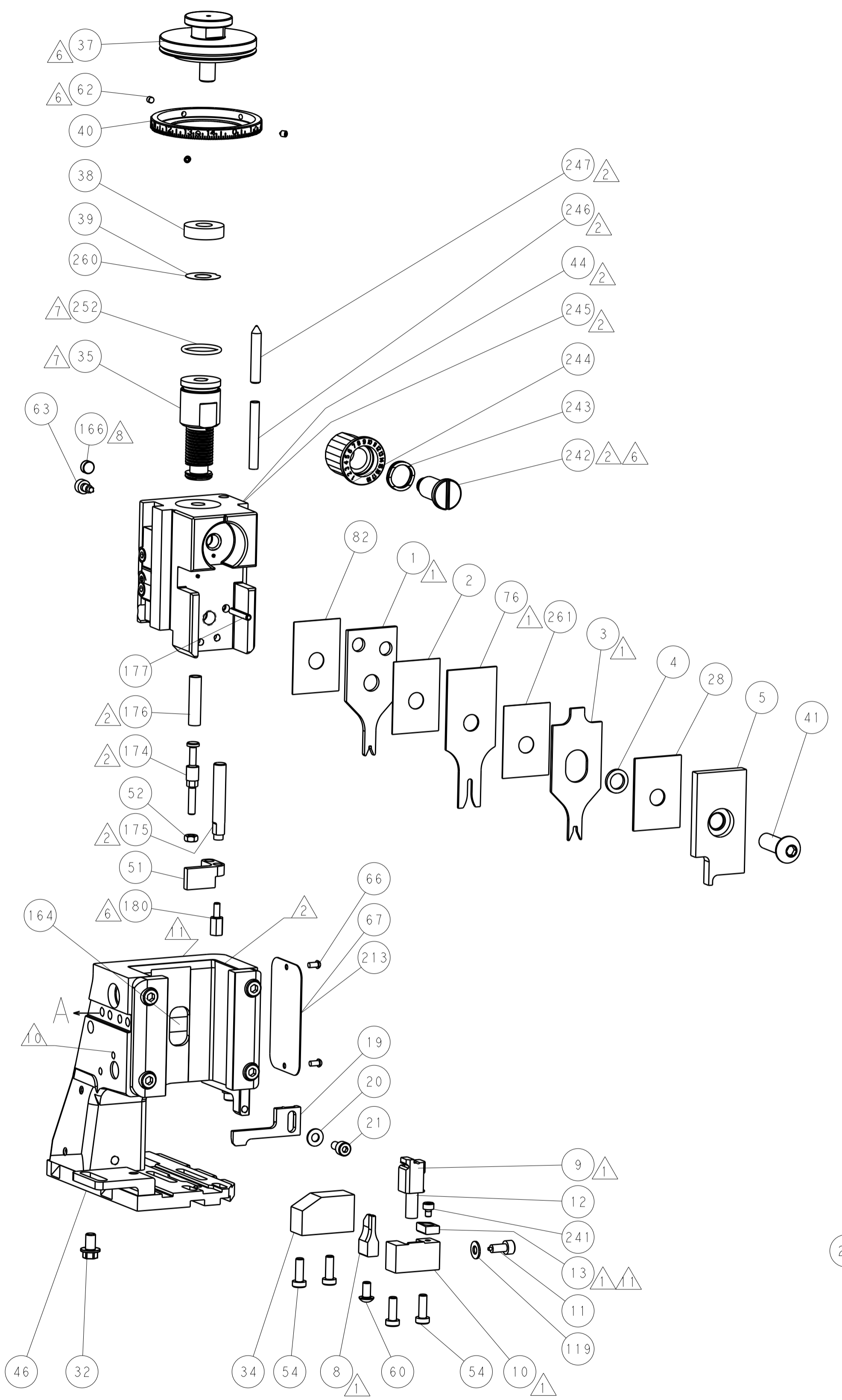
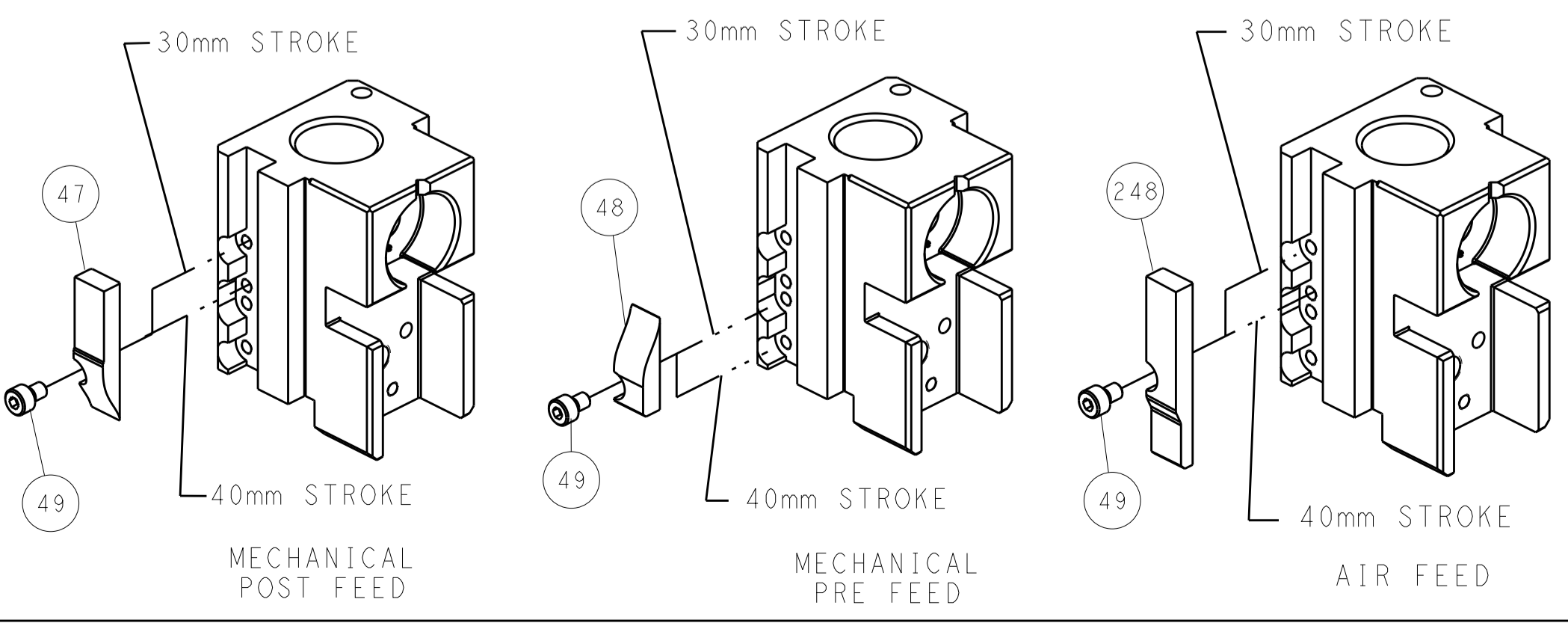
PNEUMATIC



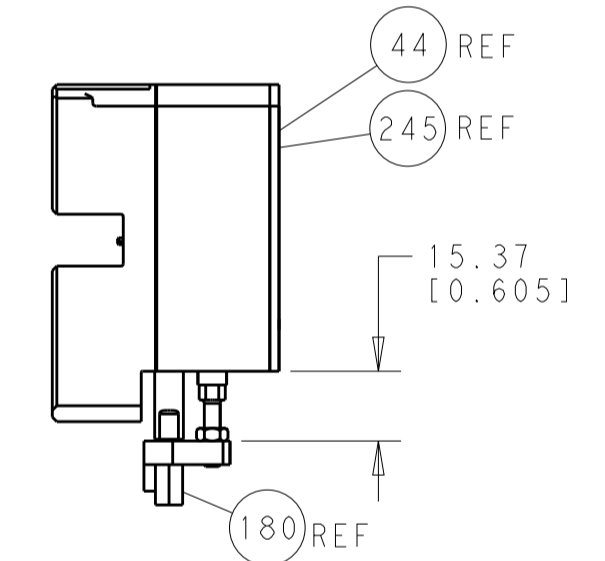
SERVO LATCH PLATE



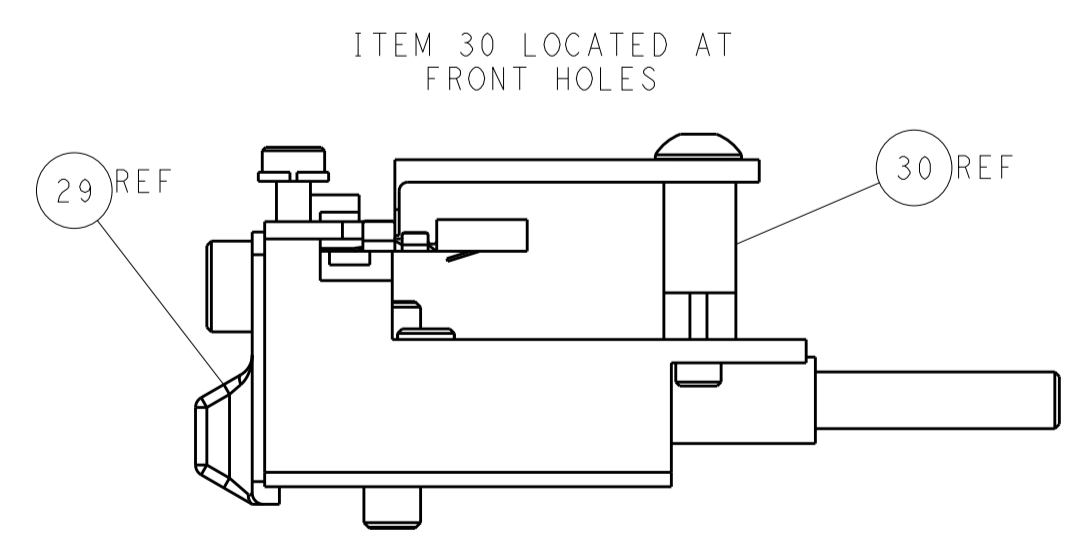
CAM POSITIONS



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 A. HUANG 27 JUN 2013		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 ±0.0013	NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		APVD L. ZHANG 27 JUN 2013		RESTRICTED TO	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A11 00779 ©=2151986	
				WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV A	
				Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151986-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151986-5	1901094-3	2-1752354-0	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151986-4	-	-	-
	2-2151986-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151986-5	1901094-3	2-1752354-0	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151986-4	-	-	-
	2-2151986-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151986-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151986-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.29 mm [.090]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT 26-22 AWG, AMP LEAF			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.18-3.96 mm [1.25-.156 IN]		Ø1.27-1.63 mm [.050-.064 IN]	
TERMINAL APPLICATION SPECIFICATION	114-9003	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
583204-2	583267-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.84+/-0.05 [.033+/-0.002]	8.7
(2)26	0.81+/-0.05 [.032+/-0.002]	9.1
24 AWG	0.76+/-0.05 [.030+/-0.002]	9.7
26 AWG	0.74+/-0.05 [.029+/-0.002]	9.9

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. 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: 8-2151986-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151986-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151986-5
- 5. 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 & 242.
- 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. 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

***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	1	1	1	455888-3	SPACER, CRIMPER	261
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-77	-27	-25	-22	-21	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)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119082-4	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	-	-	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	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	2-1752354-0	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	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
-	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	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	461679-1	TOOL, SIZING	76
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1338685-1	PAWL, FEED	56
-	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	2119652-1	FEED CAM, PRE FEED	48
-	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	2119644-1	RAM WASHER, PRECISION	38
-	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	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	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	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	1633861-4	SHEAR, FLOATING	9
-	1	1	1	1	1-1803057-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	3-1633962-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1	1	3-1633713-4	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

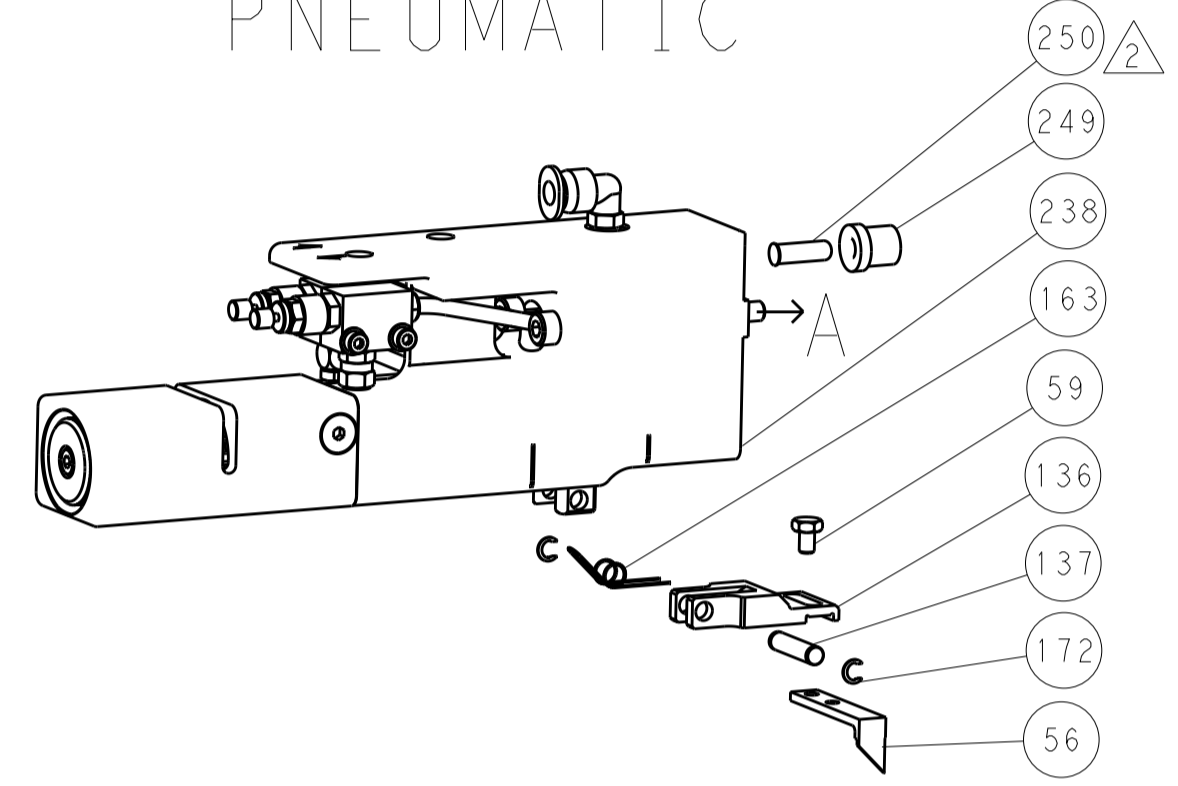
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	ANGLES ±.0001										
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	OF	REV	A	00779	©=2151986	3	4
Customer Accessible Production Drawing										SCALE	1:2

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

FEED TYPE MECHANICAL



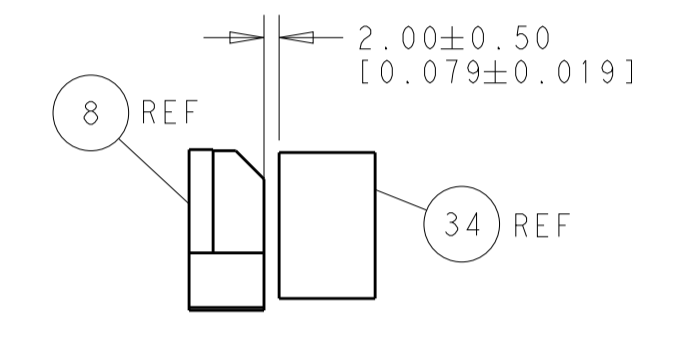
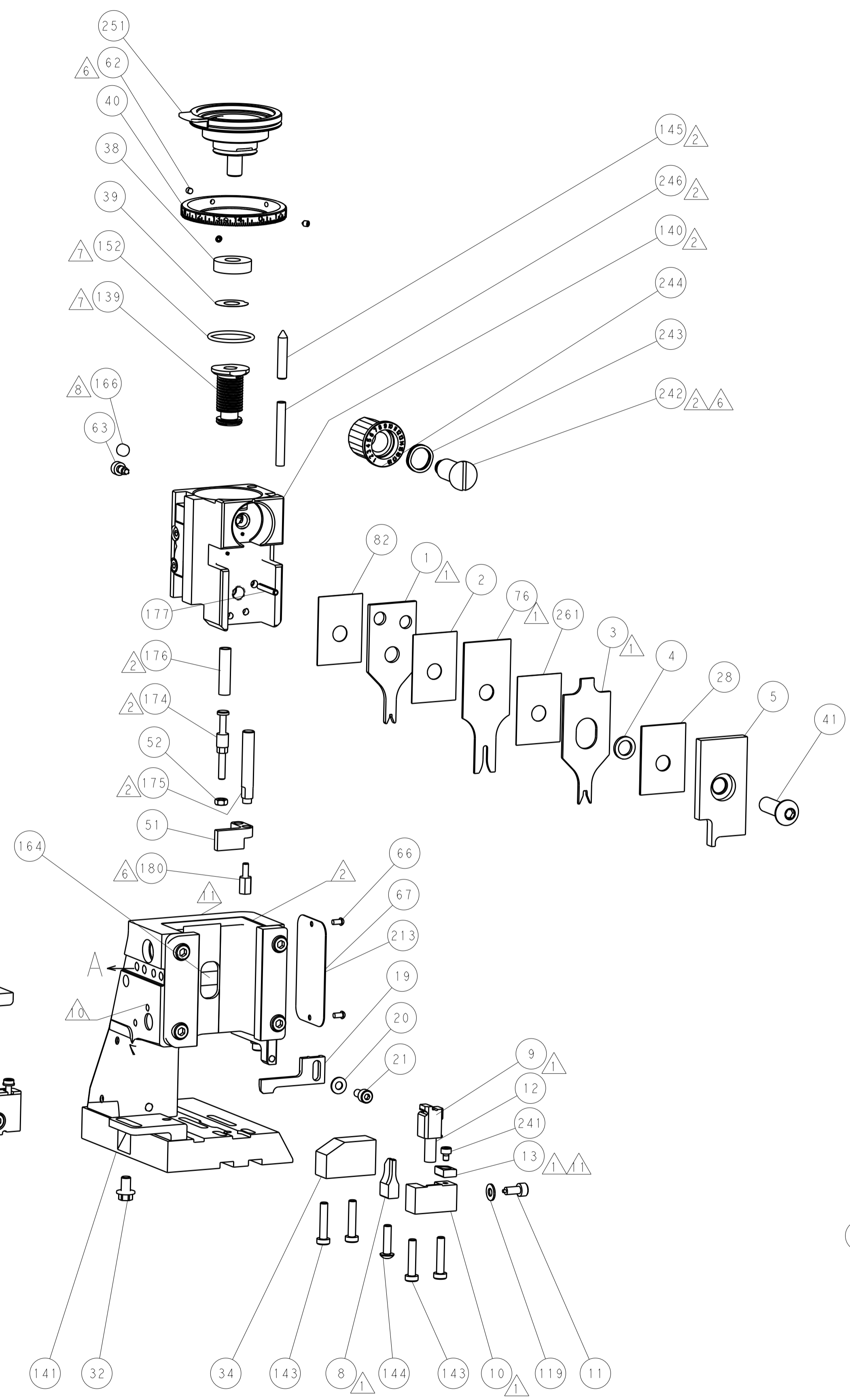
PNEUMATIC



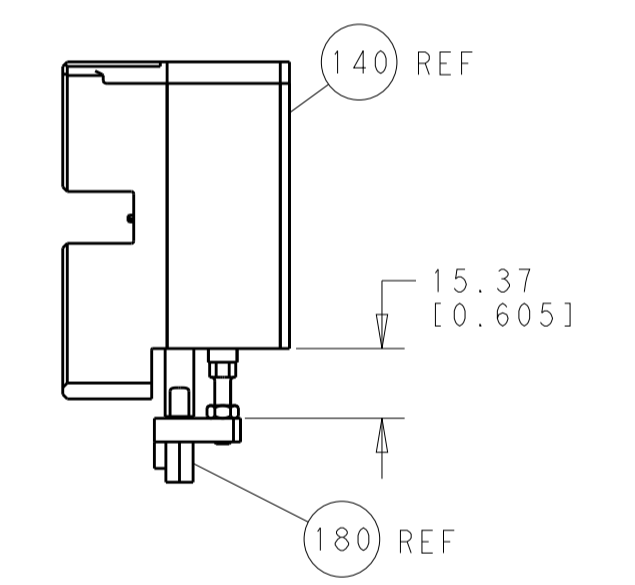
SERVO LATCH PLATE



CAM POSITIONS

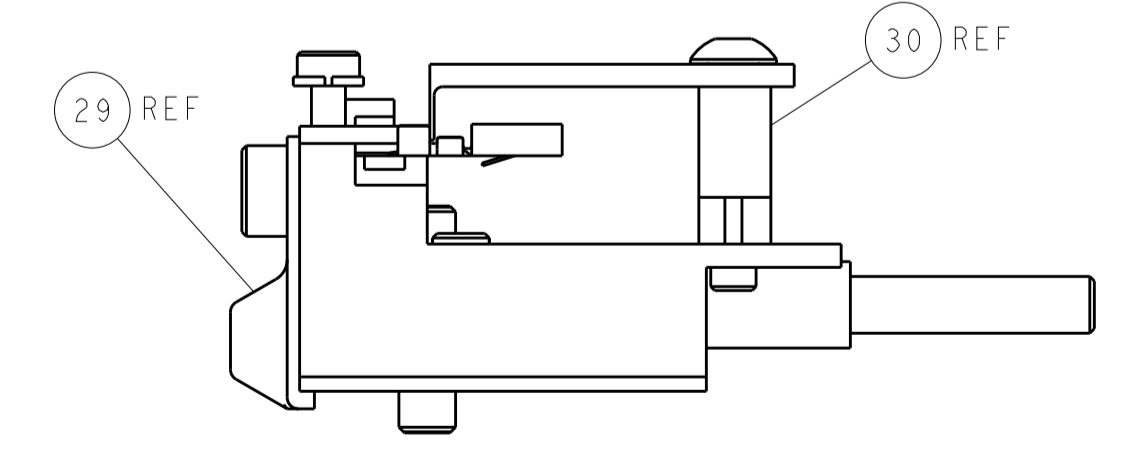


TERMINAL SUPPORT LOCATION



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: R. HUANG 27JUN2013		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD: L. ZHANG 27JUN2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
				SIZE: A1		CAGE CODE: 00779	
				DRAWING NO: 2151986		SCALE: 1:2	
				SHEET: 4		REV: A	