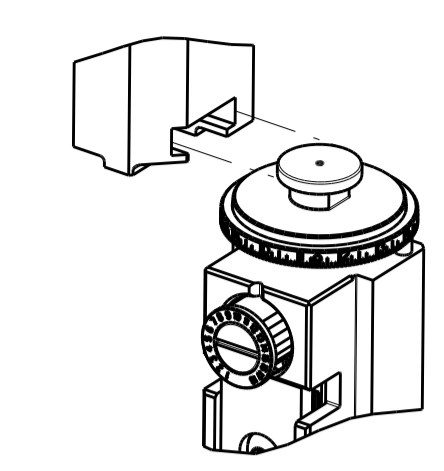


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151919-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151919-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151919-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151919-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151919-7	A	CRIMP TOOLING KIT	-

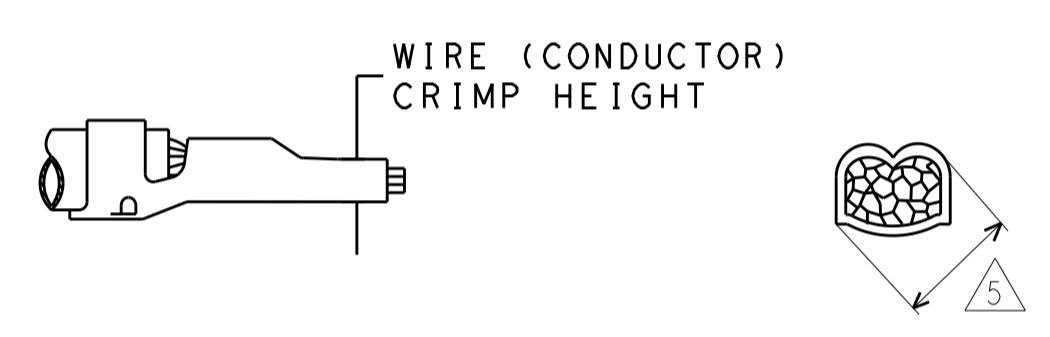
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



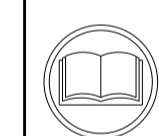
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
STABILIZER	1.40 mm [.055]	F
INSULATION	2.67 mm [1.05]	O

APPLICATOR INSTRUCTIONS
DWG_APP_INSTRUCTIONS: 646

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: PC BOARD CLIP-IN TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.08-6.10 mm [.200-.240 IN]	1.70-3.05 mm [.067-.120 IN]		
TERMINAL APPLICATION SPECIFICATION	ATS-638918000 Rev B		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949196-1	08-70-0106	1949196-5	39000277
1949196-2	39000132	1949196-6	98000193
1949196-3	39000230	1949196-7	98000194
1949196-4	39000276		



WIRE SIZE	CRIMP HEIGHT mm [INCH]	STABILIZER CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.80mm ²	1.14 MAX [.045 MAX]	1.74+0.04/-0.04 [.0685+.0015/-0.0015]	7.0
20 AWG OR 0.50mm ²	1.14 MAX [.045 MAX]	1.74+0.04/-0.04 [.0685+.0015/-0.0015]	7.0
22 AWG OR 0.35mm ²	1.14 MAX [.045 MAX]	1.74+0.04/-0.04 [.0685+.0015/-0.0015]	7.0
24 AWG OR 0.20mm ²	1.14 MAX [.045 MAX]	1.74+0.04/-0.04 [.0685+.0015/-0.0015]	7.1



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 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.
- 5 CRIMP HEIGHT MEASURING OVER WIRE BARREL CLOSEST TO INSULATION BARREL SHOULD HAVE A DIAGONALLY MEASUREMENT OF 1.74+/-0.04mm FOR ALL WIRE SIZES. WIRE BARREL ON END OF TERMINAL SHOULD MEASURE 1.14mm MAXIMUM.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

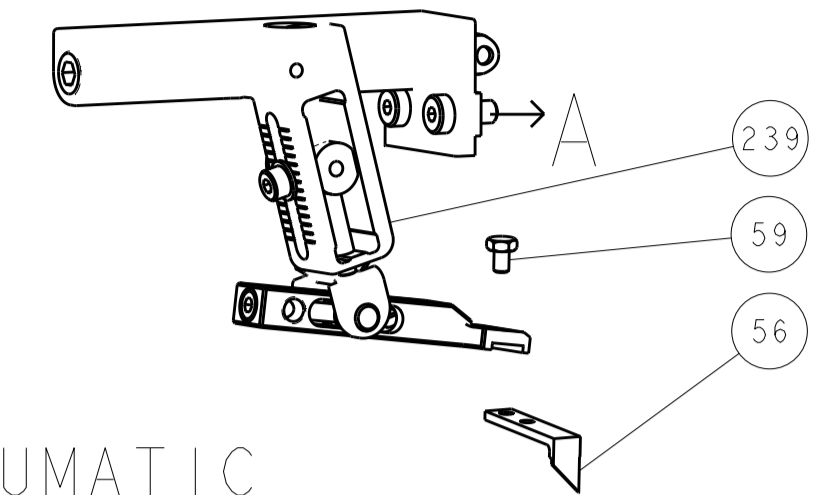
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		A1		ECR-13-008341	21MAY2013	BH	GB
		B		ECR-19-015686	09OCT2019	FZ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	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
-	-	1	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1	1	456402-1	CRIMPER, WIRE PREMIUM	50
-	1	2	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	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	455888-1	SPACER, CRIMPER	15
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1633293-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2-1803018-8	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	2	1	7-1633305-1	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

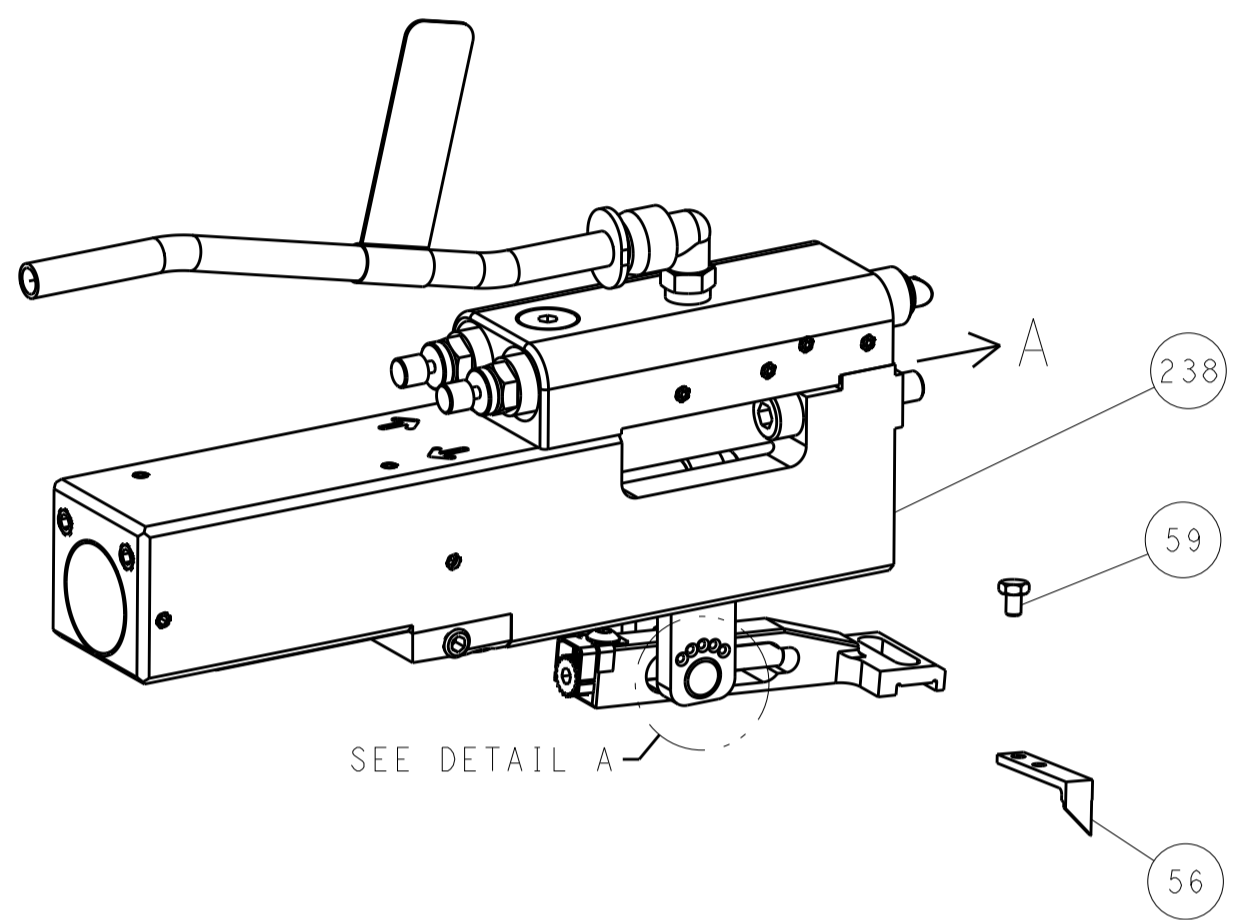
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CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION			

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

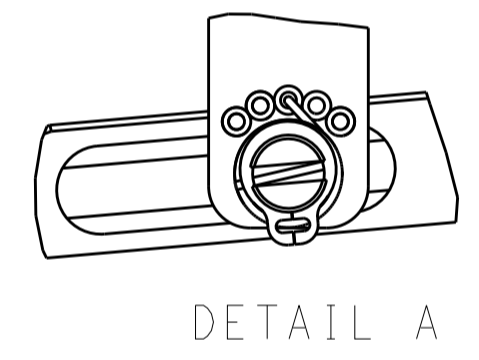
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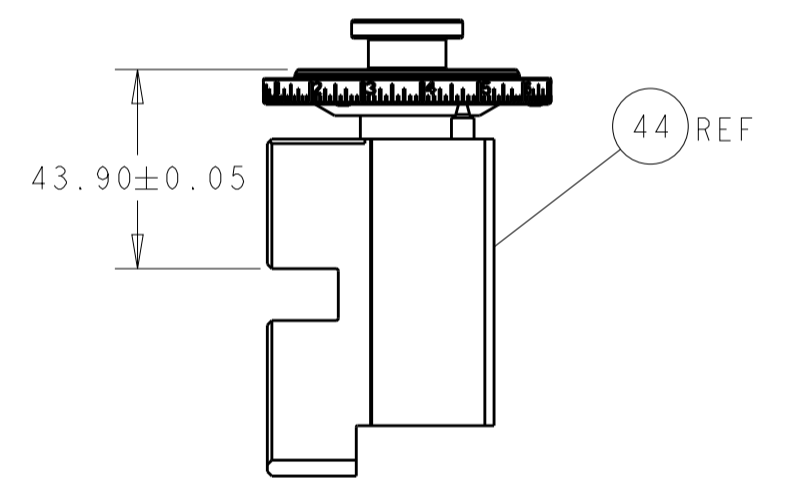
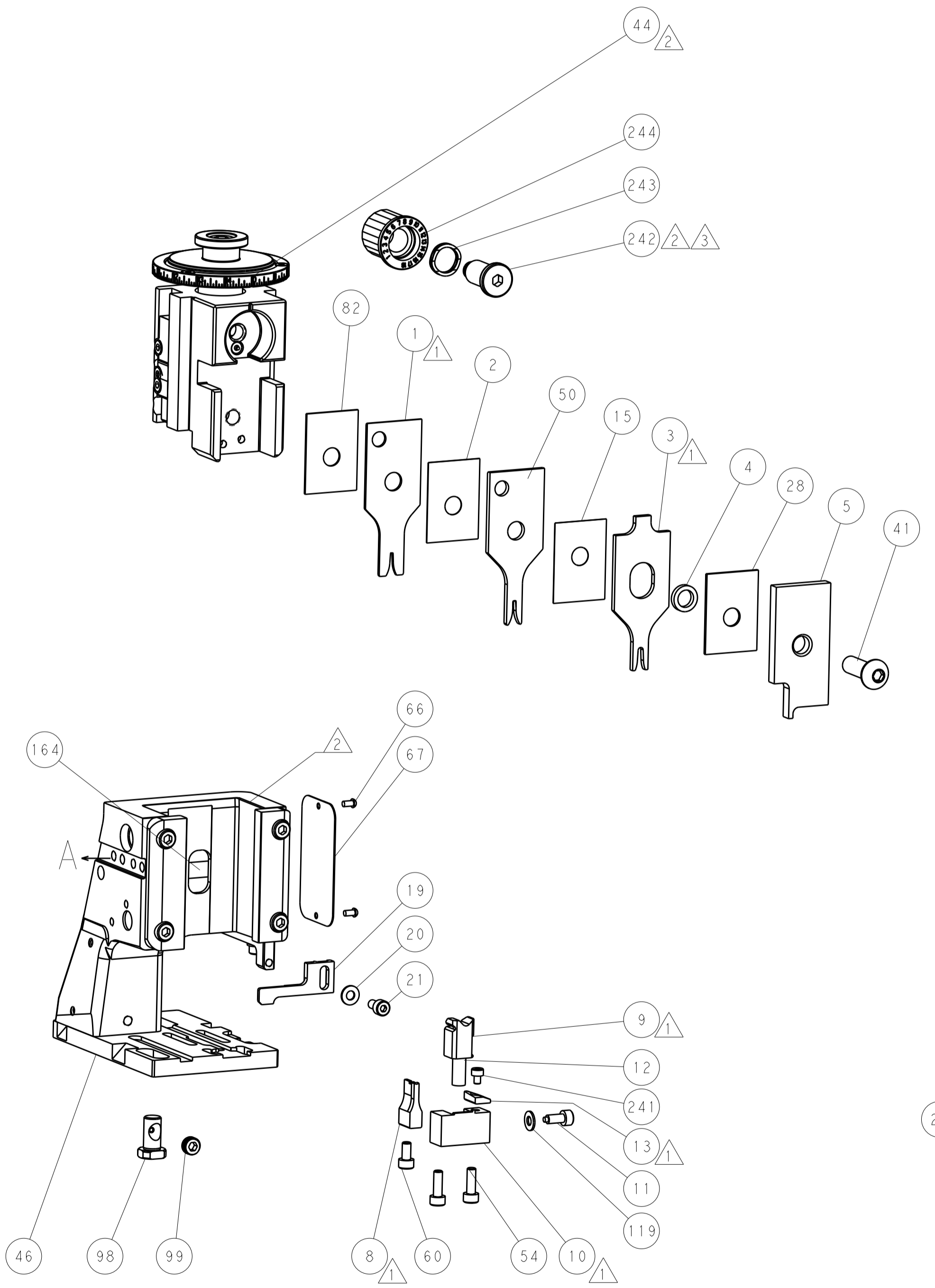
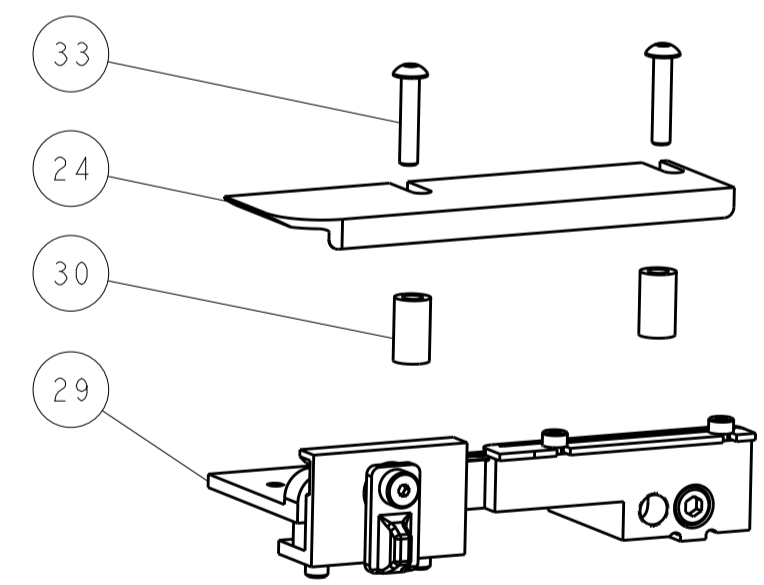
PNEUMATIC



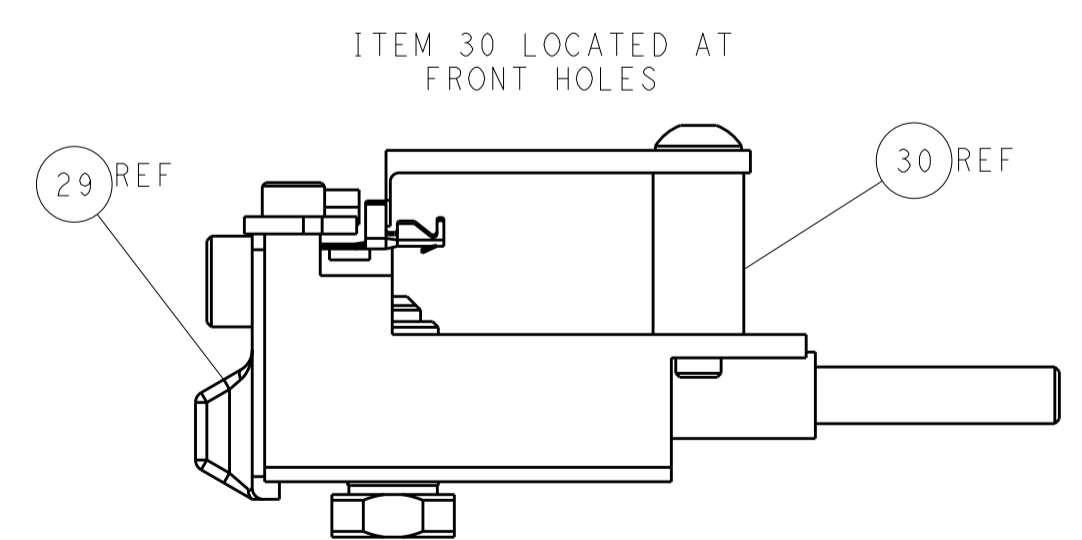
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

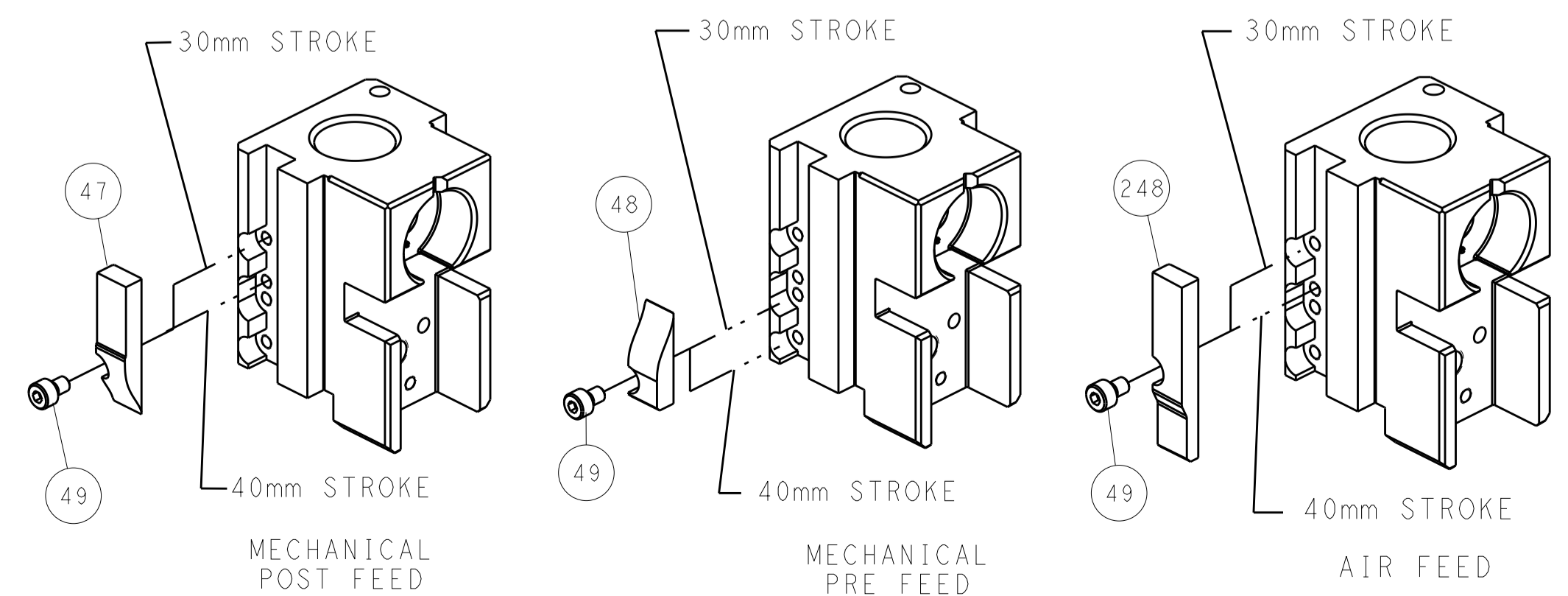


HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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:		DWG: BOB HIGMAN 26MAR2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
ANGLES	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
			1:2	A1	00779	©=2151919	
Customer Accessible Production Drawing				SHEET 2 OF 4		REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151919-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151919-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151919-7	A	CRIMP TOOLING KIT	-

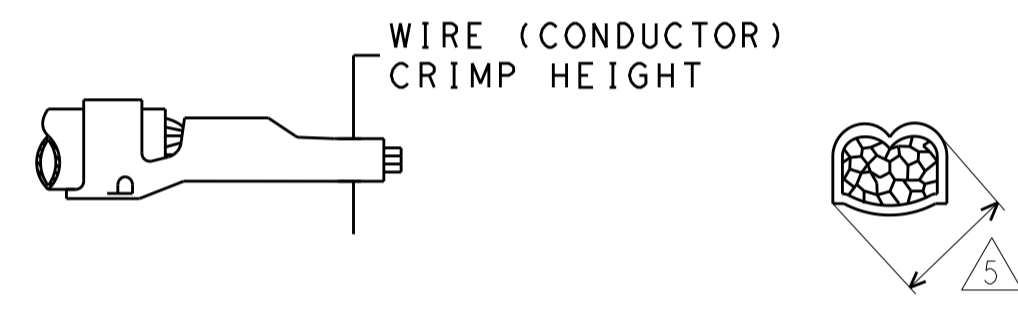
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
STABILIZER	1.40 mm [.055]	F
INSULATION	2.67 mm [.105]	O

APPLICATOR INSTRUCTIONS
DWG_APP_INSTRUCTIONS:646

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: PC BOARD CLIP-IN TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.08-6.10 mm [.200-.240 IN]	1.70-3.05 mm [.067-.120 IN]		
TERMINAL APPLICATION: ATS-638918000 Rev B			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949196-1	08-70-0106	1949196-5	39000277
1949196-2	39000132	1949196-6	98000193
1949196-3	39000230	1949196-7	98000194
1949196-4	39000276		



WIRE SIZE	CRIMP HEIGHT mm [INCH]	STABILIZER CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.80mm2	1.14 MAX [.045 MAX]	1.74+0.04/-0.04 [.0685+.0015/-0.0015]	7.0
20 AWG OR 0.50mm2	1.14 MAX [.045 MAX]	1.74+0.04/-0.04 [.0685+.0015/-0.0015]	7.0
22 AWG OR 0.35mm2	1.14 MAX [.045 MAX]	1.74+0.04/-0.04 [.0685+.0015/-0.0015]	7.0
24 AWG OR 0.20mm2	1.14 MAX [.045 MAX]	1.74+0.04/-0.04 [.0685+.0015/-0.0015]	7.1

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- CRIMP HEIGHT MEASURING OVER WIRE BARREL CLOSEST TO INSULATION BARREL SHOULD HAVE A DIAGONALLY MEASUREMENT OF 1.74+/-0.04mm FOR ALL WIRE SIZES. WIRE BARREL ON END OF TERMINAL SHOULD MEASURE 1.14mm MAXIMUM.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

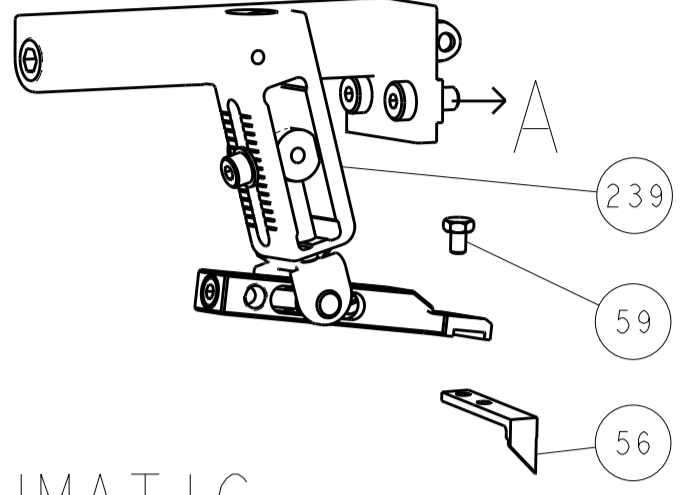
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A	66	-	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	1	1		2119082-9 CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1		2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1		2119083-1 RETAINER, INSULATION DIAL	242	
-	1	1		7-18023-7 SCR, SKT HD CAP M3 X 4.0	241	
-	-	1		2119580-1 MECHANICAL FEED ASSEMBLY	239	
-	1	-		2844940-1 AIR FEED MODULE	238	
-	REF	REF		994970-2 COUNTER, MAGNETIC	164	
-	1	-		2119641-2 FEED CAM, AIR FEED	151	
-	1	1		2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	2	2		2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	143	
-	-	1		2119653-2 FEED CAM, POST FEED	142	
-	1	1		1-1803583-0 APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1		1803516-1 RAM ASSEMBLY, SF PACIFIC	140	
-	1	1		1-18028-2 WASHER, FLAT, REG M4	119	
-	1	1		2844908-1 SCREW, LOCKING	99	
-	1	1		2844907-1 POST, LOCKING	98	
-	1	1		455888-7 SPACER, CRIMPER	82	
-	1	1		1803607-3 DOCUMENTATION PACKAGE	71	
-	1	1		2119740-1 TAG, IDENTIFICATION	67	
-	2	2		2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1		5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1		1338685-1 PAWL, FEED	56	
-	1	1		456402-1 CRIMPER, WIRE PREMIUM	50	
-	1	2		18023-9 SCR, SKT HD CAP M4 X 6.0	49	
-	-	1		2119652-1 FEED CAM, PRE FEED	48	
-	1	1		1803602-1 SCR, BHSC, RoHS (M8 X 25)	41	
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2		2-2844962-6 SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1		2844992-1 ASSEMBLY, STRIP GUIDE	29	
-	1	1		1-455888-0 SPACER, CRIMPER	28	
-	1	1		1320928-2 STRIP GUIDE	24	
-	1	1		2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1		1-18028-2 WASHER, FLAT, REG M4	20	
-	1	1		2119533-1 STRIPPER, SIDE FEED	19	
-	1	1		455888-1 SPACER, CRIMPER	15	
-	1	1		2119806-1 INSERT, SHEAR	13	
-	1	1		3-22280-3 SPRING, COMPRESSION	12	
-	1	1		1-356885-4 STOP, SHEAR	11	
-	1	1		2119805-1 SHEAR HOLDER, FRONT	10	
-	1	1		1803095-6 FLOATING SHEAR, FRONT	9	
-	1	1		1633293-6 ANVIL, COMBINATION	8	
-	-	-		-	7	
-	-	-		-	6	
-	1	1		2119757-8 DEPRESSOR, SHEAR	5	
-	1	1		238011-4 BLOCK, CRIMPER SPACER	4	
-	1	1		2-1803018-8 CRIMPER, INSULATION O	3	
-	1	1		455888-3 SPACER, CRIMPER	2	
-	1	1		7-1633305-1 CRIMPER, WIRE PREMIUM	1	
-	77	-22	-21	PART NO	DESCRIPTION	ITEM NO

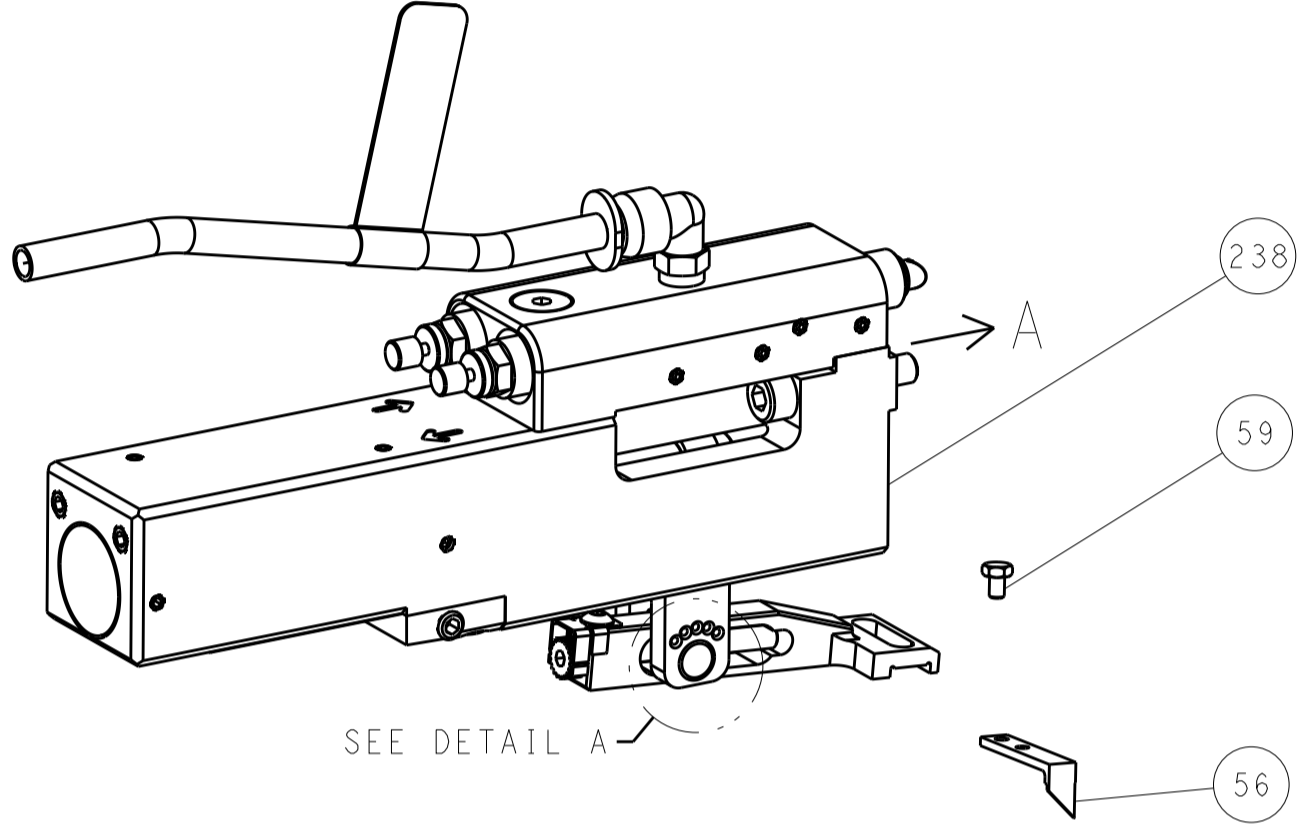
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LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

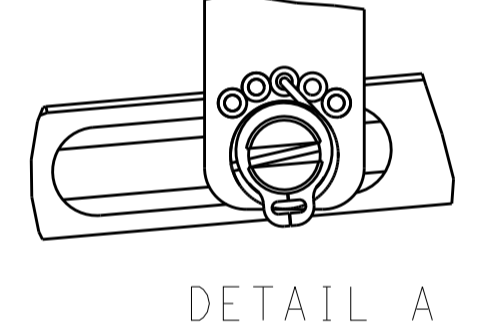
FEED TYPE MECHANICAL



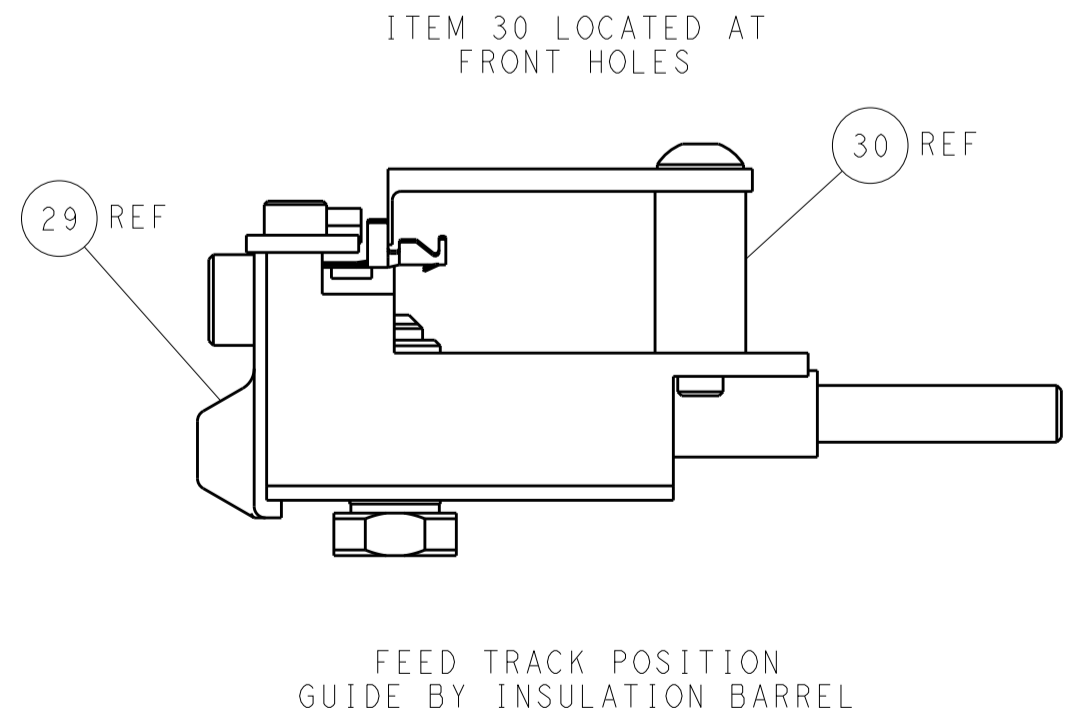
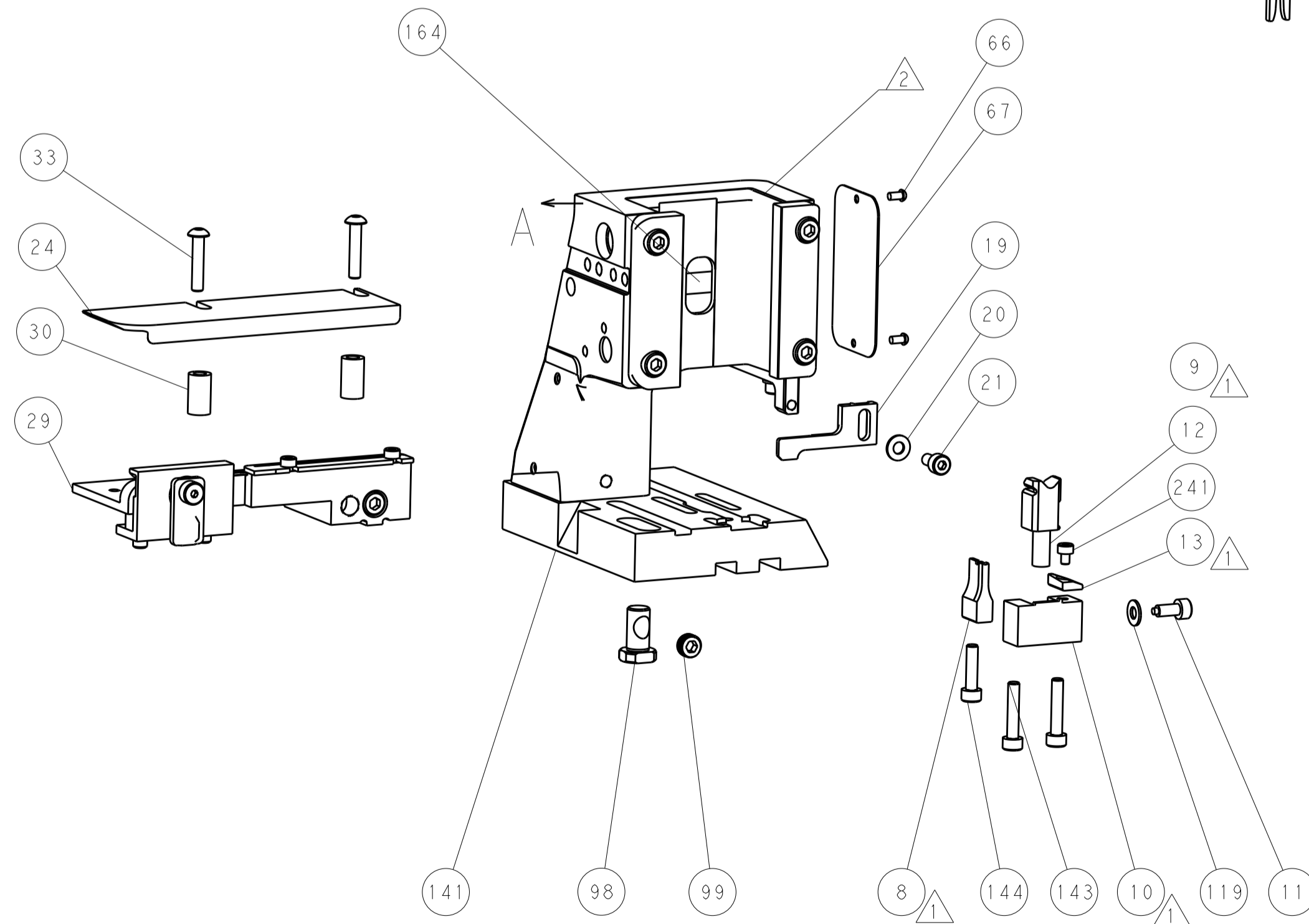
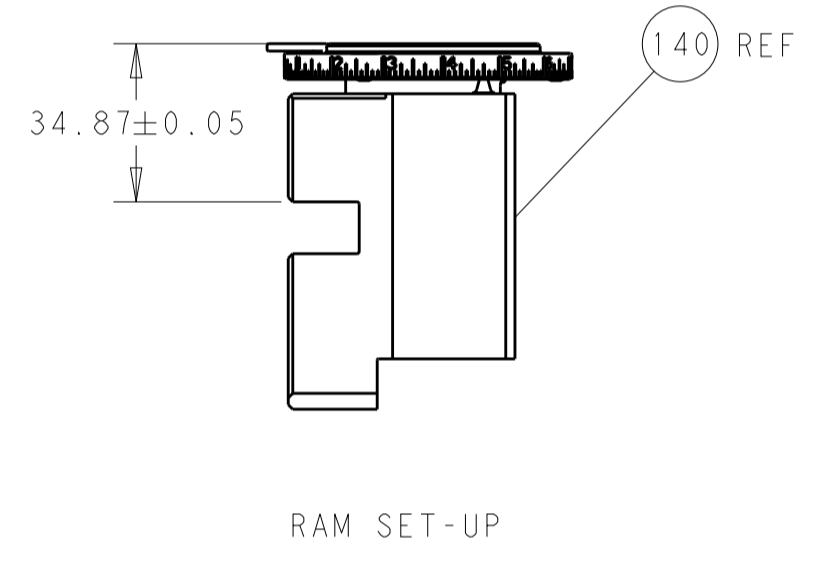
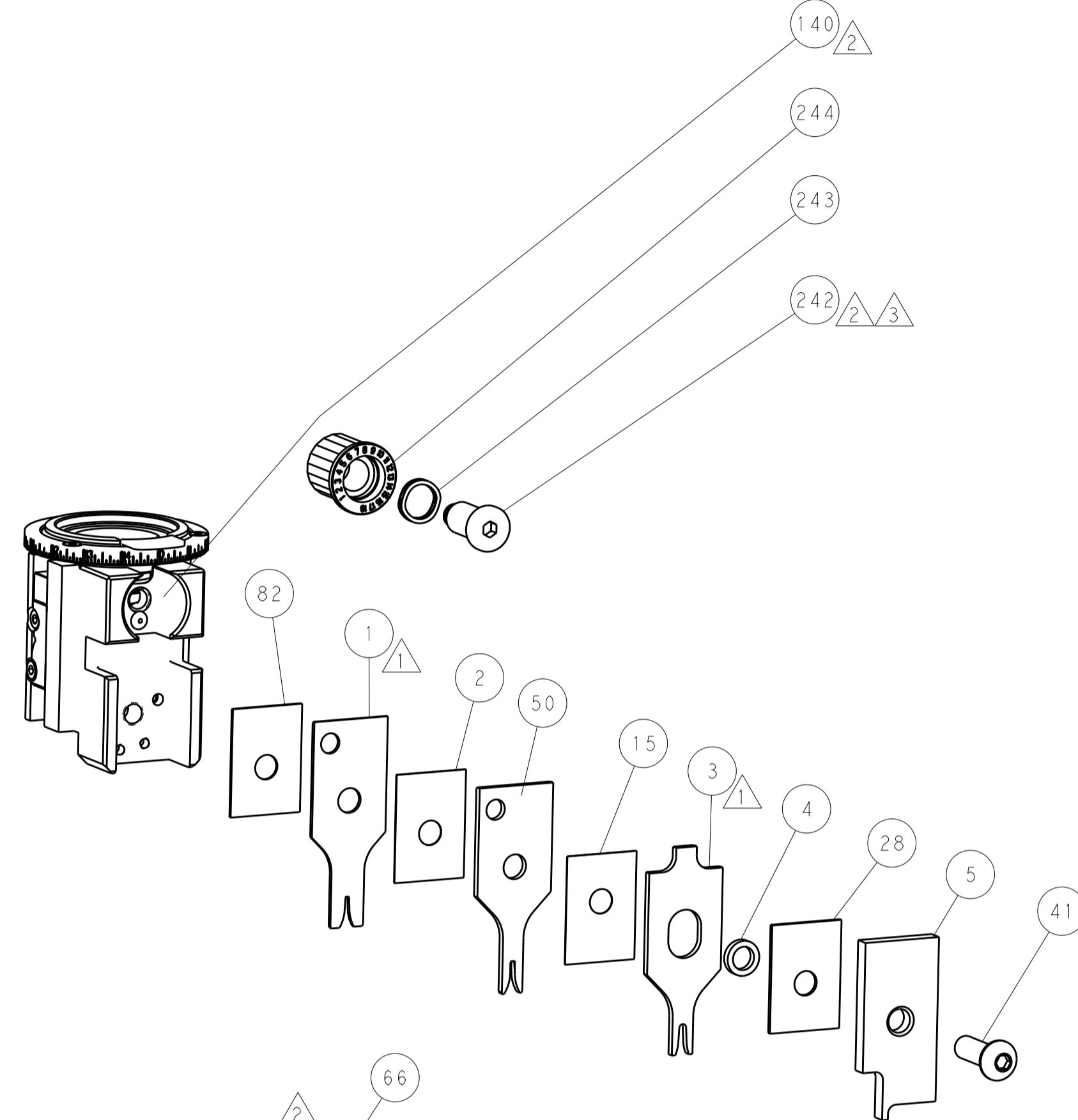
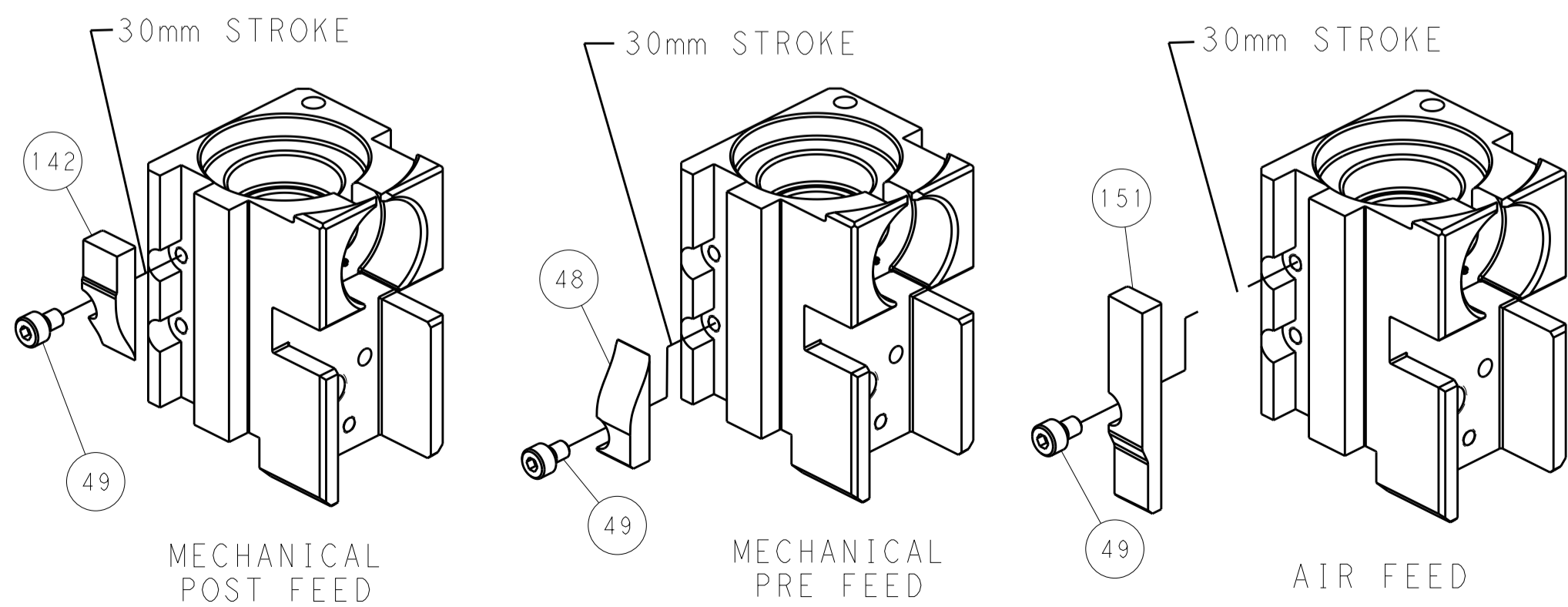
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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:		OWN: BOB HIGMAN 26MAR2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: G. BAILEY 26MAR2013		NAME: Ocean Side Feed Applicator	
				APVD: M. CLIFFORD 26MAR2013		RESTRICTED TO:	
				PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				APPLICATION SPEC:		A1 00779 ©=2151919	
				WEIGHT:		SCALE: 1:2 SHEET 4 OF 4 REV B	
				Customer Accessible Production Drawing			