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|--|-------------------|--------------------------|--------------------------|---|--|------------------------|------------------------|-----------|-----------|---|---|-------------------|-----------|-----------|-------------|-----------|-----------|------------------------|-------------------|-----------|---|-------------|-----------|---|------------------------|------------------|-----------|---|-------------|---|---|---|-----------------|-----------|-----------|-----------|-----------|---|---|-------------------|-----------|---|-------------|-----------|---|------------------------|------------------|-----------|---|-------------|---|---|---|
| COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 2151406-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | <table border="1"> <tr> <th>CONVERT TO</th> <th colspan="5">PART NUMBERS REQUIRED</th> </tr> <tr> <td>PNEUMATIC FEED</td> <td>2119950-1</td> <td>1338685-1</td> <td>5-18022-5</td> <td>2119641-1</td> <td>2119799-1</td> <td>2063440-1</td> </tr> <tr> <td>SERVO LATCH PLATE</td> <td>2119951-1</td> <td>-</td> <td>8-2151406-5</td> <td>1901094-3</td> <td>-</td> <td>2168400-6 (QUANTITY 2)</td> </tr> <tr> <td>SMART APPLICATOR</td> <td>2161326-1</td> <td>-</td> <td>8-2151406-4</td> <td>-</td> <td>-</td> <td>-</td> </tr> <tr> <td>MECHANICAL FEED</td> <td>2119949-1</td> <td>1338685-1</td> <td>5-18022-5</td> <td>2119653-1</td> <td>-</td> <td>-</td> </tr> <tr> <td>SERVO LATCH PLATE</td> <td>2119951-1</td> <td>-</td> <td>8-2151406-5</td> <td>1901094-3</td> <td>-</td> <td>2168400-6 (QUANTITY 2)</td> </tr> <tr> <td>SMART APPLICATOR</td> <td>2161326-1</td> <td>-</td> <td>8-2151406-4</td> <td>-</td> <td>-</td> <td>-</td> </tr> </table> | CONVERT TO | PART NUMBERS REQUIRED | | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | SERVO LATCH PLATE | 2119951-1 | - | 8-2151406-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | SMART APPLICATOR | 2161326-1 | - | 8-2151406-4 | - | - | - | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | SERVO LATCH PLATE | 2119951-1 | - | 8-2151406-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | SMART APPLICATOR | 2161326-1 | - | 8-2151406-4 | - | - | - |
| | CONVERT TO | PART NUMBERS REQUIRED | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | SERVO LATCH PLATE | 2119951-1 | - | 8-2151406-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | SMART APPLICATOR | 2161326-1 | - | 8-2151406-4 | - | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | SERVO LATCH PLATE | 2119951-1 | - | 8-2151406-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| SMART APPLICATOR | 2161326-1 | - | 8-2151406-4 | - | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2151406-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | <table border="1"> <tr> <td>MECHANICAL FEED</td> <td>2119949-1</td> <td>1338685-1</td> <td>5-18022-5</td> <td>2119653-1</td> <td>-</td> <td>-</td> </tr> <tr> <td>SERVO LATCH PLATE</td> <td>2119951-1</td> <td>-</td> <td>8-2151406-5</td> <td>1901094-3</td> <td>-</td> <td>2168400-6 (QUANTITY 2)</td> </tr> <tr> <td>SMART APPLICATOR</td> <td>2161326-1</td> <td>-</td> <td>8-2151406-4</td> <td>-</td> <td>-</td> <td>-</td> </tr> </table> | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | SERVO LATCH PLATE | 2119951-1 | - | 8-2151406-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | SMART APPLICATOR | 2161326-1 | - | 8-2151406-4 | - | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| SERVO LATCH PLATE | 2119951-1 | - | 8-2151406-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| SMART APPLICATOR | 2161326-1 | - | 8-2151406-4 | - | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2151406-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | <table border="1"> <tr> <td>MECHANICAL FEED</td> <td>2119949-1</td> <td>1338685-1</td> <td>5-18022-5</td> <td>2119653-1</td> <td>-</td> <td>-</td> </tr> <tr> <td>PNEUMATIC FEED</td> <td>2119950-1</td> <td>1338685-1</td> <td>5-18022-5</td> <td>2119641-1</td> <td>2119799-1</td> <td>2063440-1</td> </tr> </table> | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2151406-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | <table border="1"> <tr> <td>-</td> <td>-</td> <td>-</td> <td>-</td> <td>-</td> <td>-</td> <td>-</td> </tr> </table> | - | - | - | - | - | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| - | - | - | - | - | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2151406-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | <table border="1"> <tr> <td>-</td> <td>-</td> <td>-</td> <td>-</td> <td>-</td> <td>-</td> <td>-</td> </tr> </table> | - | - | - | - | - | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| 7-2151406-7 | A | CRIMP TOOLING KIT | - | <table border="1"> <tr> <td>-</td> <td>-</td> <td>-</td> <td>-</td> <td>-</td> <td>-</td> <td>-</td> </tr> </table> | - | - | - | - | - | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| - | - | - | - | - | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| APPLICATOR DATA | | |
|-----------------------------------|-----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [0.080] | F |
| INSUL | 2.54 mm [0.100] | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | TE CRIMP SPECIFICATION |
|---|--|
| TERMINAL NAME: MQS1.2, SOCKET CONTACT | |
| WIRE STRIP LENGTH 4.30-4.90 mm [0.169-.193 IN] | INSULATION DIAMETER RANGE Ø1.90-2.40 mm [0.075-.094 IN] |
| TERMINAL APPLICATION SPECIFICATION 114-18286 | |
| TERMINALS APPLIED | |
| TE TERMINAL 929398-1 | TE TERMINAL 1355661-1 |
| TE TERMINAL 1355661-3 | TE TERMINAL |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 1.50mm2 | 1.44+/-0.03 [0.057+/-0.001] | 9.2 |
| 1.00mm2 | 1.25+/-0.03 [0.049+/-0.001] | 11.6 |

- 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: 8-2151406-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151406-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151406-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151406-6
- 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 ITEM 50.
- 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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

***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)

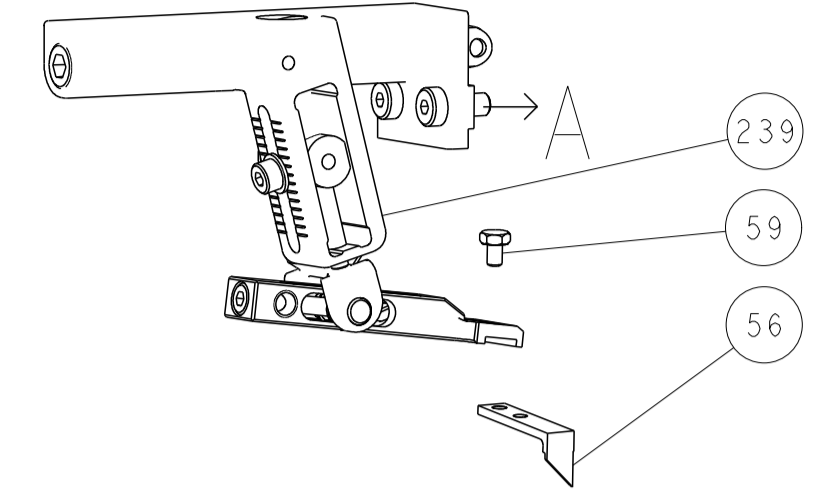
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|---------------------------|----------|------------|----------|-----|-------------|-----------|-----|------|
| SET UP GAUGE 2119599-1 | LOC A | DIST 66 | REVISONS | | | | | |
| | | | P | LTR | DESCRIPTION | DATE | OWN | APVD |
| | | | 1 | | DEVELOPMENT | 01DEC2011 | L.Z | S.X |
| | | | A | | RELEASE | 10JUL2012 | L.Z | S.X |

| | | | | | | | | |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 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 | 18023-1 | SCR, SKT HD CAP M3 X 5.0 | 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 |
| - | 1 | 1 | 1 | 1 | 1 | 993111-1 | PIN, SLOTTED SPRING 3.0 X 20.0 | 177 |
| - | 1 | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 |
| - | 1 | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 |
| - | 1 | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 |
| - | - | - | - | 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 | 455888-4 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | - | - | - | - | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS | 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 | 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 | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 54 |
| - | 1 | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | 1 | 1 | 1 | 1 | 1 | 1901681-1 | HOLDDOWN, TERMINAL | 51 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1752354-7 | STANDOFF, HOLD-DOWN | 50 |
| - | - | - | - | - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | - | 2 | 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 | - | - | - | - | 2119370-1 | RAM, AMP STYLE, SIDE FEED | 44 |
| - | 1 | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | - | - | - | - | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
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| - | 1 | 1 | 1 | 1 | 1 | 2119644-2 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | 1 | - | - | - | - | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | 1 | 1 | 1 | 1 | 1 | 1752356-6 | 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 | 1320908-3 | 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 | 454276-5 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 5-1633131-3 | ANVIL, COMBINATION .080 | 8 |
| - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2119757-4 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 3-238011-5 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1633996-0 | CRIMPER, INSULATION SPECIAL | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-8 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 4-456405-7 | CRIMPER, WIRE PREMIUM | 1 |
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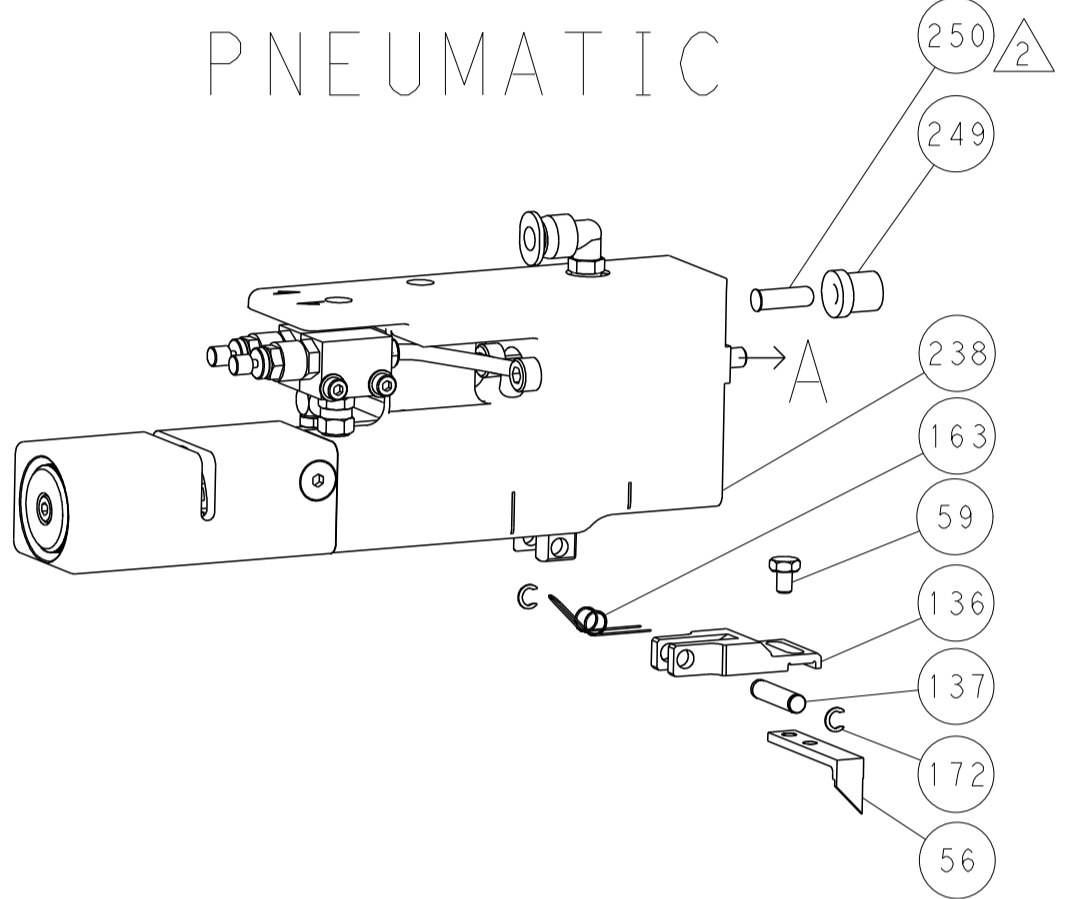
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| MATERIAL: | | FINISH: | | APPLICATION SPEC | | SIZE CAGE CODE DRAWING NO | |
| | | | | WEIGHT | | A 00779 2151406 | |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | | | | | SCALE 1:1 SHEET 1 OF 4 REV A | |

| LOC | | DIST | | REVISIONS | | | |
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| - | - | SEE SHEET 1 | - | - | - | | |

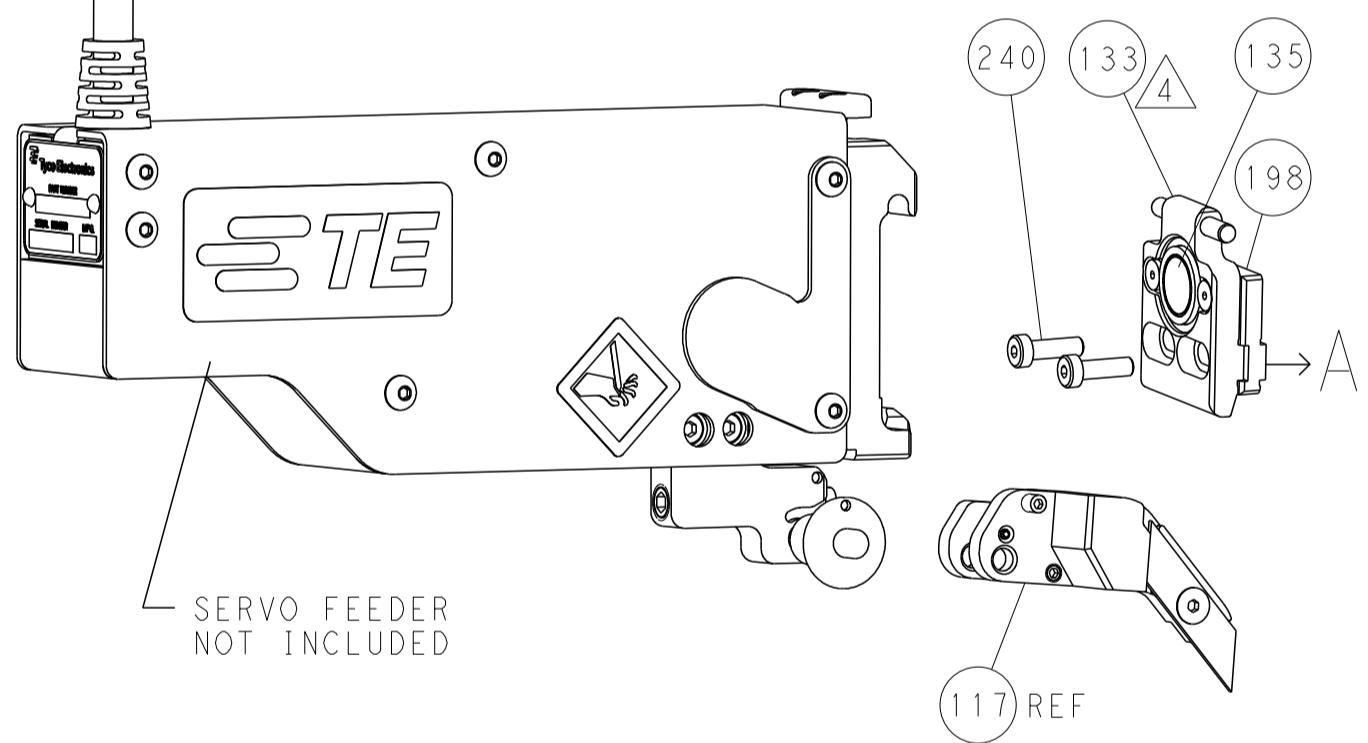
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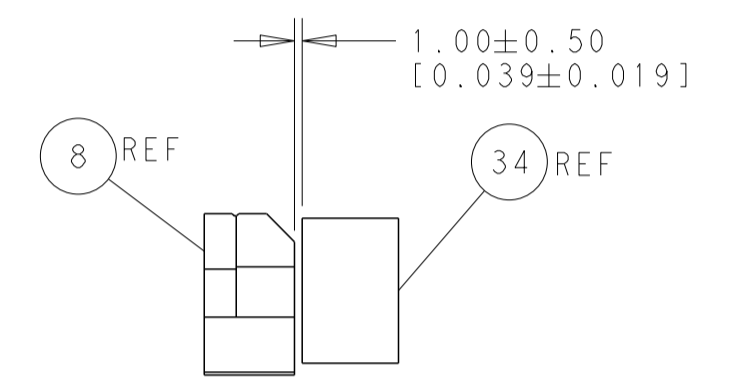
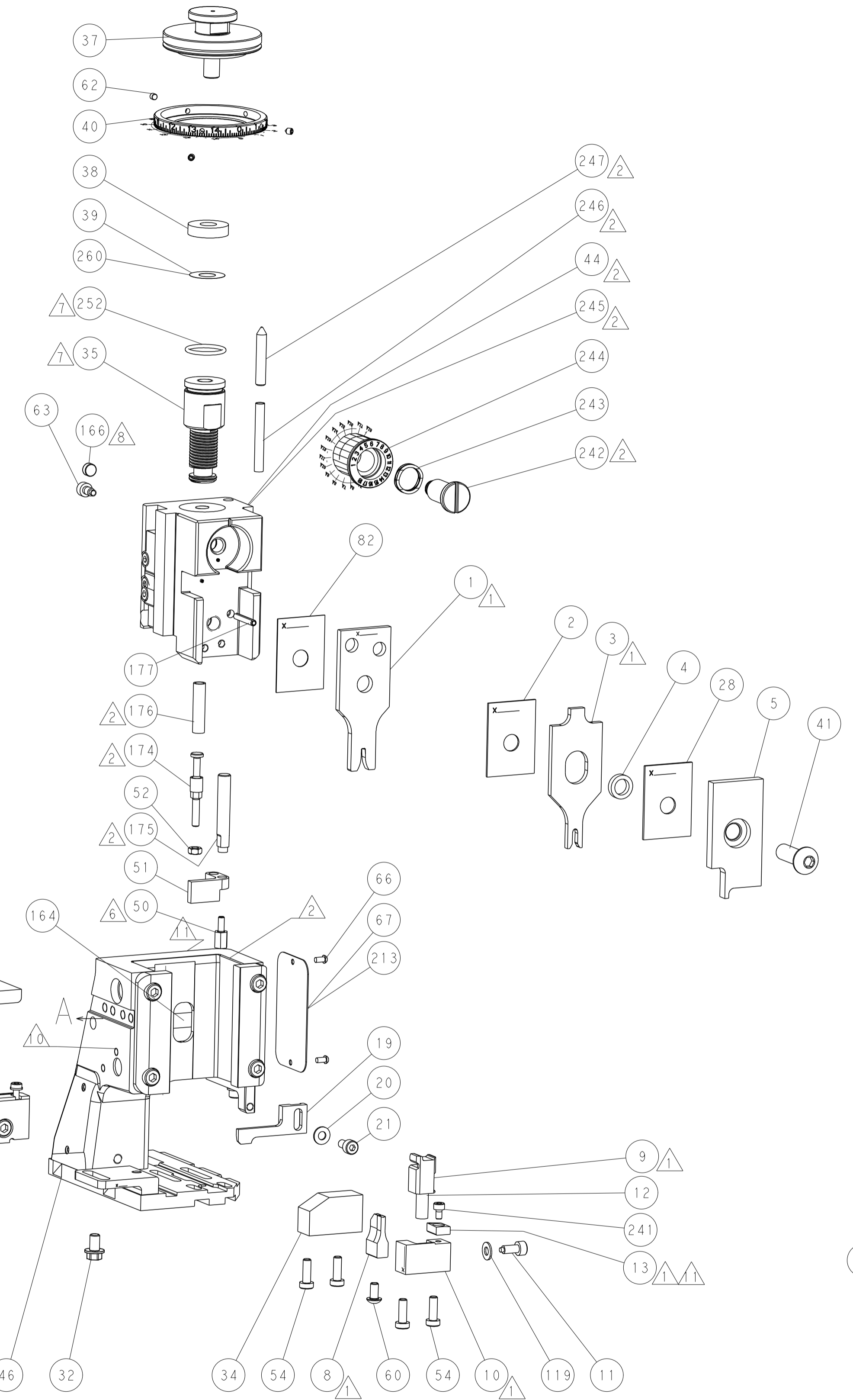
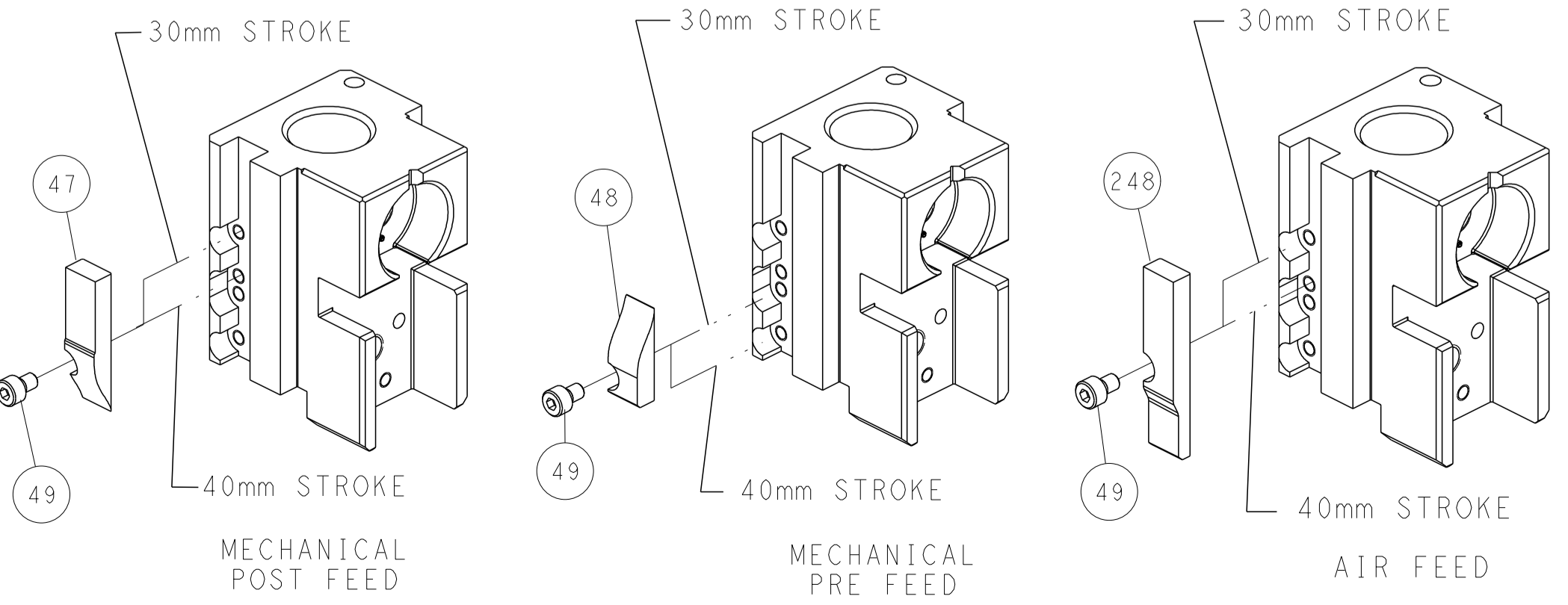
PNEUMATIC



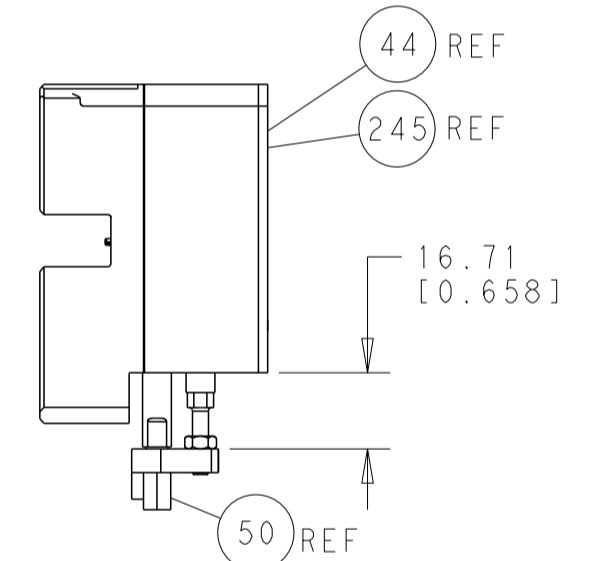
SERVO LATCH PLATE



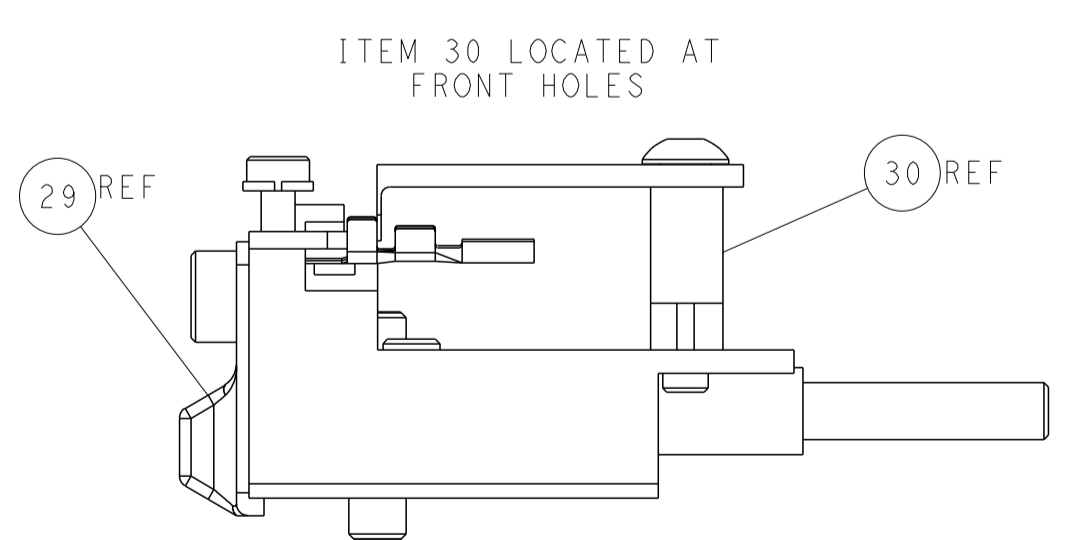
CAM POSITIONS



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: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN L. ZHANG 01DEC2011 | TE Connectivity |
| 0 PLC | ±.1 | 1 PLC | ±0.1 | CHK L. ZHANG 01DEC2011 | Harrisburg, PA 17105-3608 |
| 1 PLC | ±0.02 | 2 PLC | ±0.02 | APVD S. XI 01DEC2011 | |
| 2 PLC | ±0.005 | 3 PLC | ±0.005 | PRODUCT SPEC | NAME Ocean Side Feed Applicator |
| 3 PLC | ±0.005 | 4 PLC | ±0.005 | APPLICATION SPEC | SIZE CAGE CODE DRAWING NO |
| 4 PLC | ±0.005 | ANGLES | ±.1 | WEIGHT | A 00779 C=2151406 |
| MATERIAL | FINISH | RESTRICTED TO | | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | SCALE 1:1 SHEET 2 OF 4 REV A |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151406-1 | 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 | - | 8-2151406-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | 2-2151406-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151406-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | 2-2151406-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | 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 |
| | 2-2151406-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151406-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|-----------------------------------|------------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 2.54 mm [.100] | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---------------------------------------|-------------|--------------------------------|-------------|
| TERMINAL NAME: MQS1.2, SOCKET CONTACT | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.30-4.90 mm [1.69-.193 IN] | | Ø1.90-2.40 mm [.075-.094 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-18286 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 929398-1 | 1355661-1 | 1355661-3 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|---------------------------------|--------------------------------|
| 1.50mm ² | 1.44 +/- 0.03 [.057 +/- .001] | 9.2 |
| 1.00mm ² | 1.25 +/- 0.03 [.049 +/- .001] | 11.6 |

- 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: 8-2151406-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151406-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151406-5
- 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 ITEM 50.
- 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 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | 1 | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| -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)

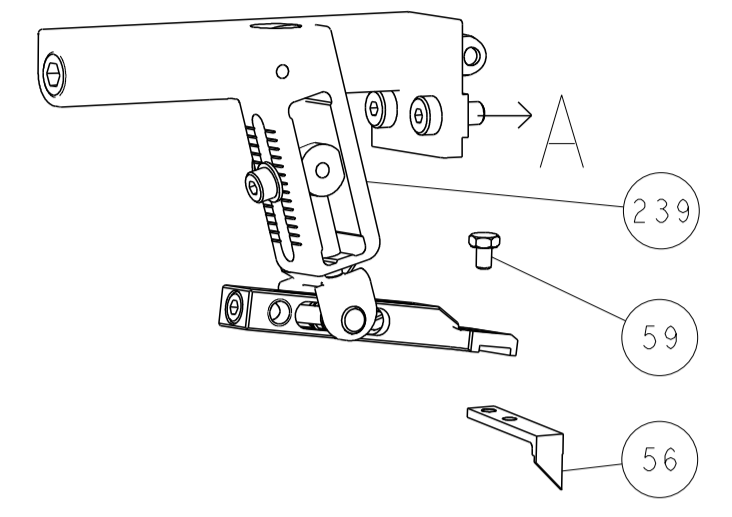
| SET UP GAUGE | LOC | DIST | REVISONS | | | | | |
|--------------|-----|------|----------|-----|-------------|------|-----|------|
| 2119599-1 | A | 66 | P | LTR | DESCRIPTION | DATE | OWN | APVD |
| | | | - | - | SEE SHEET 1 | - | - | - |

| | | | | | | | |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 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 | 18023-1 | SCR, SKT HD CAP M3 X 5.0 | 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 | 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 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | - | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS | 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 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | - | 1 | 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 | 1 | 1 | 1 | 1-1752354-7 | STANDOFF, HOLD-DOWN | 50 |
| - | - | - | 1 | 2 | 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 | 2119644-2 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 1752356-6 | 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 | 1320908-3 | 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 | 2119806-1 | INSERT, SHEAR | 13 |
| - | - | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | - | 1 | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| | - | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| | - | 1 | 1 | 1 | 454276-5 | FLOATING SHEAR, FRONT | 9 |
| | 1 | 1 | 1 | 1 | 5-1633131-3 | ANVIL, COMBINATION .080 | 8 |
| - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 2119757-4 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 3-238011-5 | BLOCK, CRIMPER SPACER | 4 |
| | 1 | 1 | 1 | 1 | 1-1633996-0 | CRIMPER, INSULATION SPECIAL | 3 |
| - | 1 | 1 | 1 | 1 | 455888-8 | SPACER, CRIMPER | 2 |
| | 1 | 1 | 1 | 1 | 4-456405-7 | CRIMPER, WIRE PREMIUM | 1 |
| -77 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

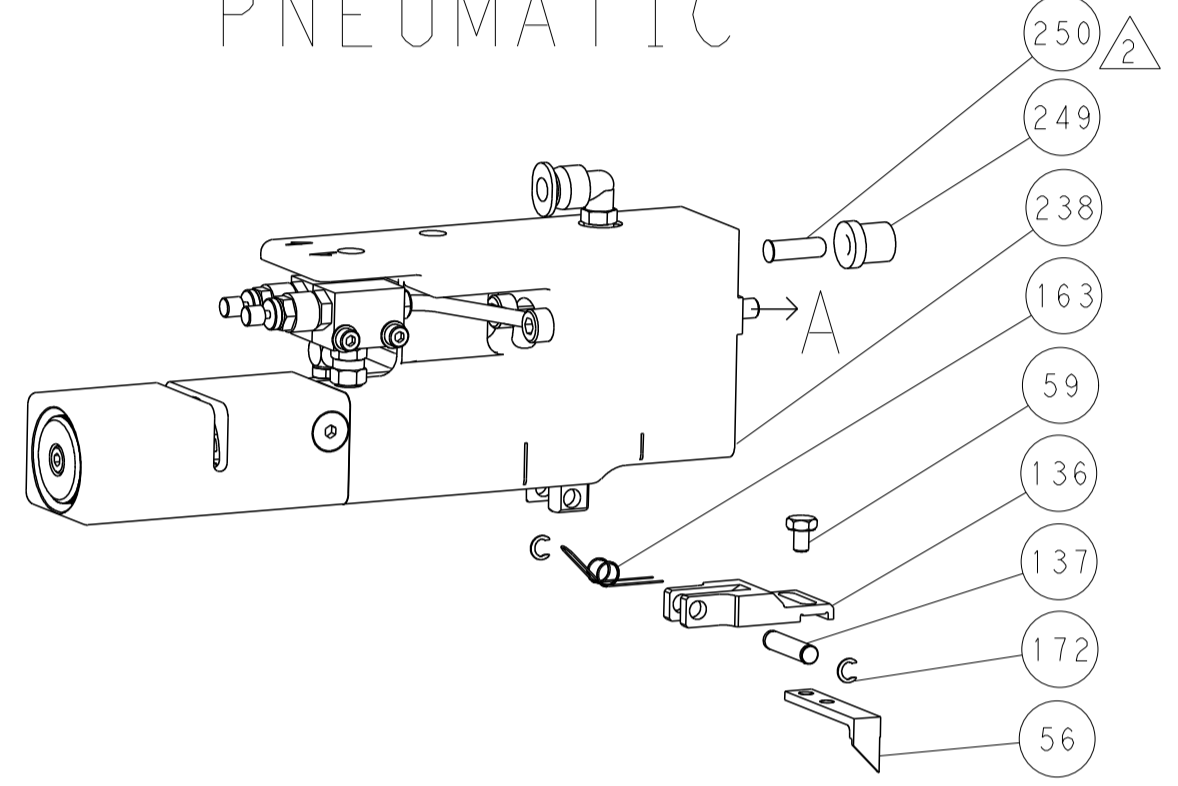
| | | | | | | |
|----------------|--|--|--|---|---|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN L. ZHANG 01DEC2011 | | TE Connectivity Harrisburg, PA 17105-3608 |
| | | 0 PLC ±.1 1 PLC ±.01 2 PLC ±.02 3 PLC ±.005 4 PLC ±.0005 ANGLES ±.1 | | CHK L. ZHANG 01DEC2011 | | |
| MATERIAL: | | FINISH: | | APVD S. XI 01DEC2011 | NAME Ocean Side Feed Applicator | |
| | | | | APPLICATION SPEC | SIZE CAGE CODE DRAWING NO RESTRICTED TO | |
| | | | | WEIGHT | A 00779 ©=2151406 | |
| | | | | CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:1 SHEET 3 OF 4 REV A | | |

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

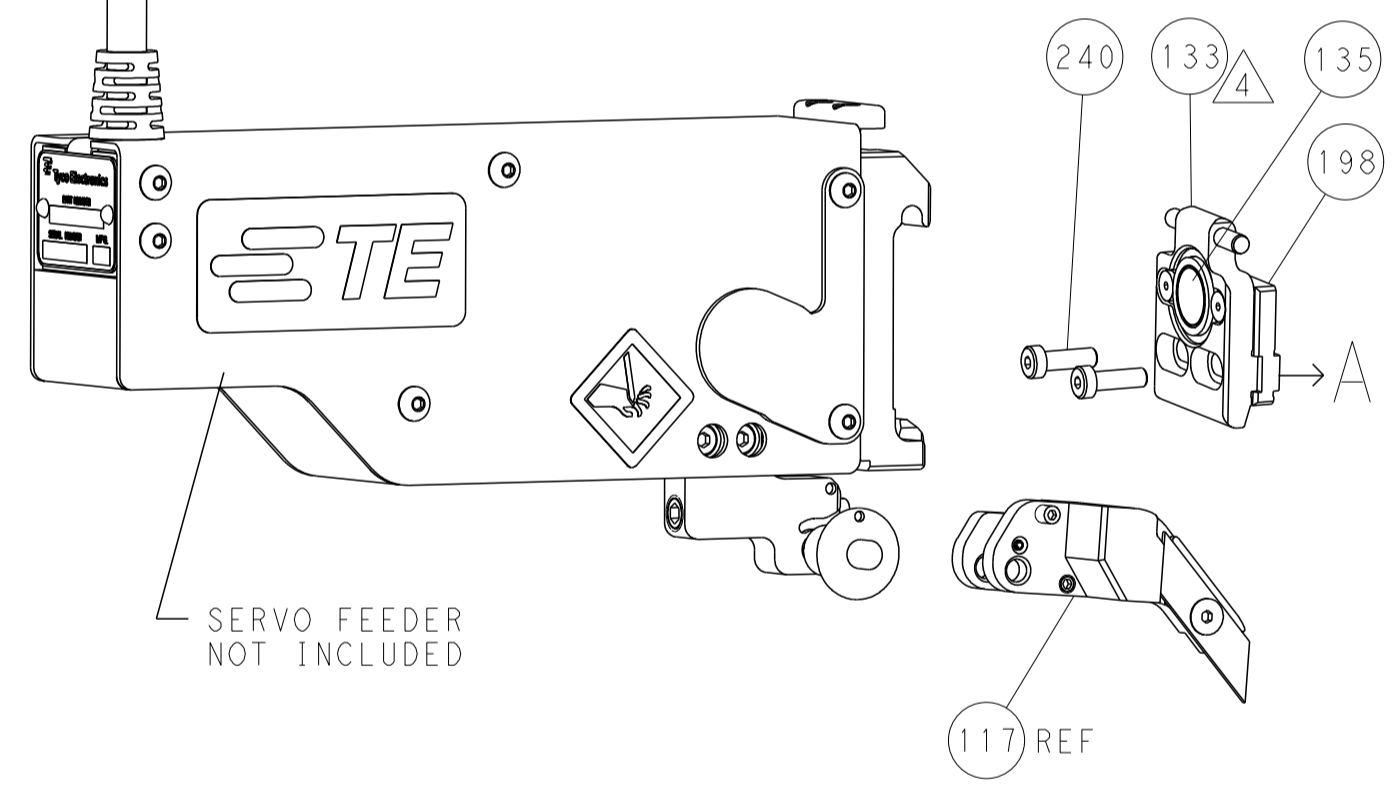
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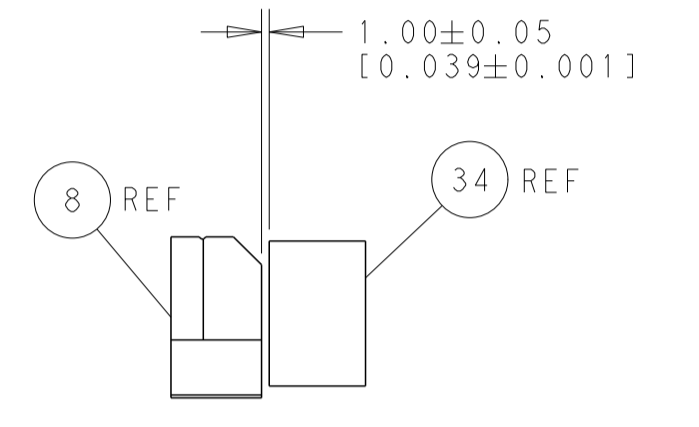
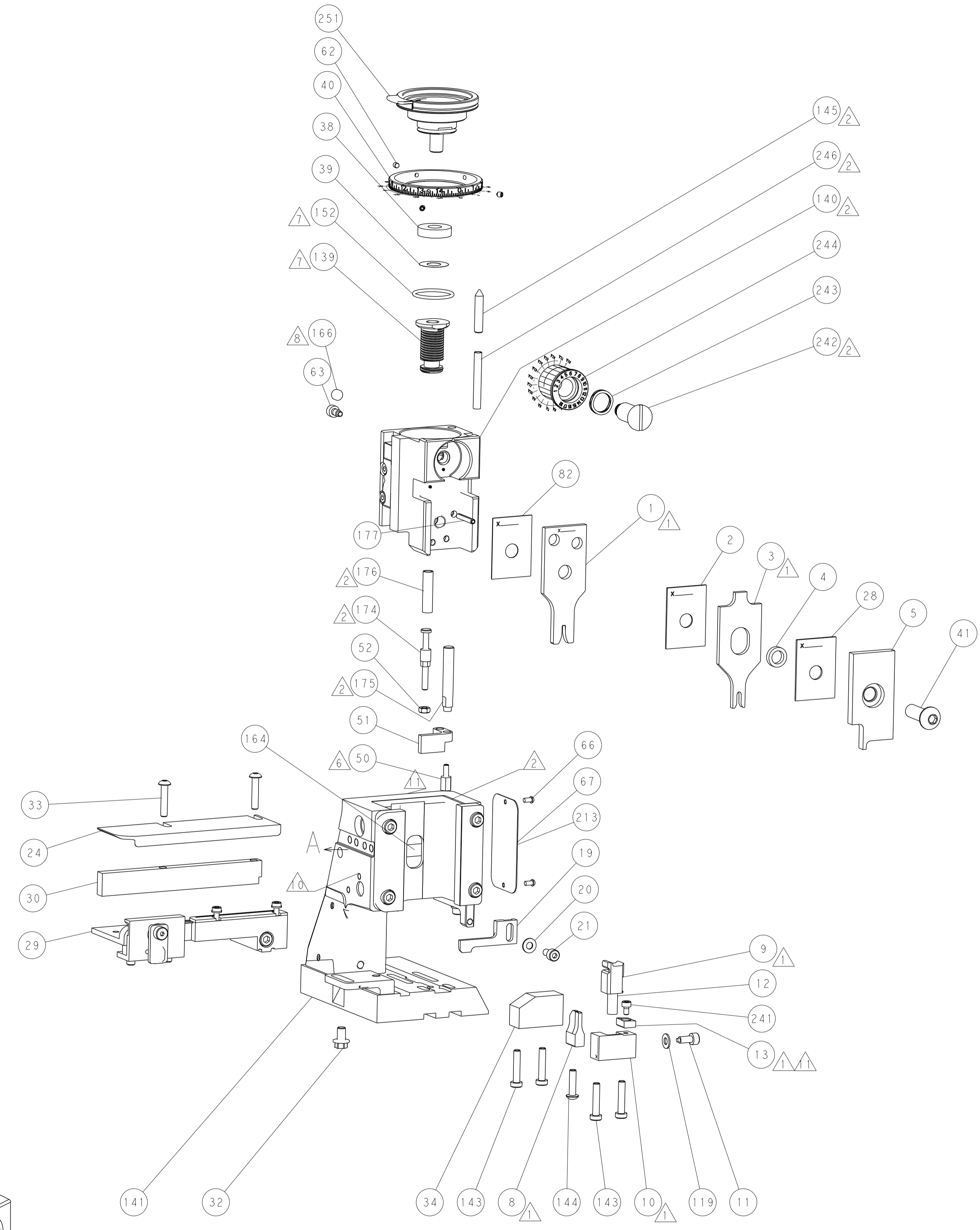
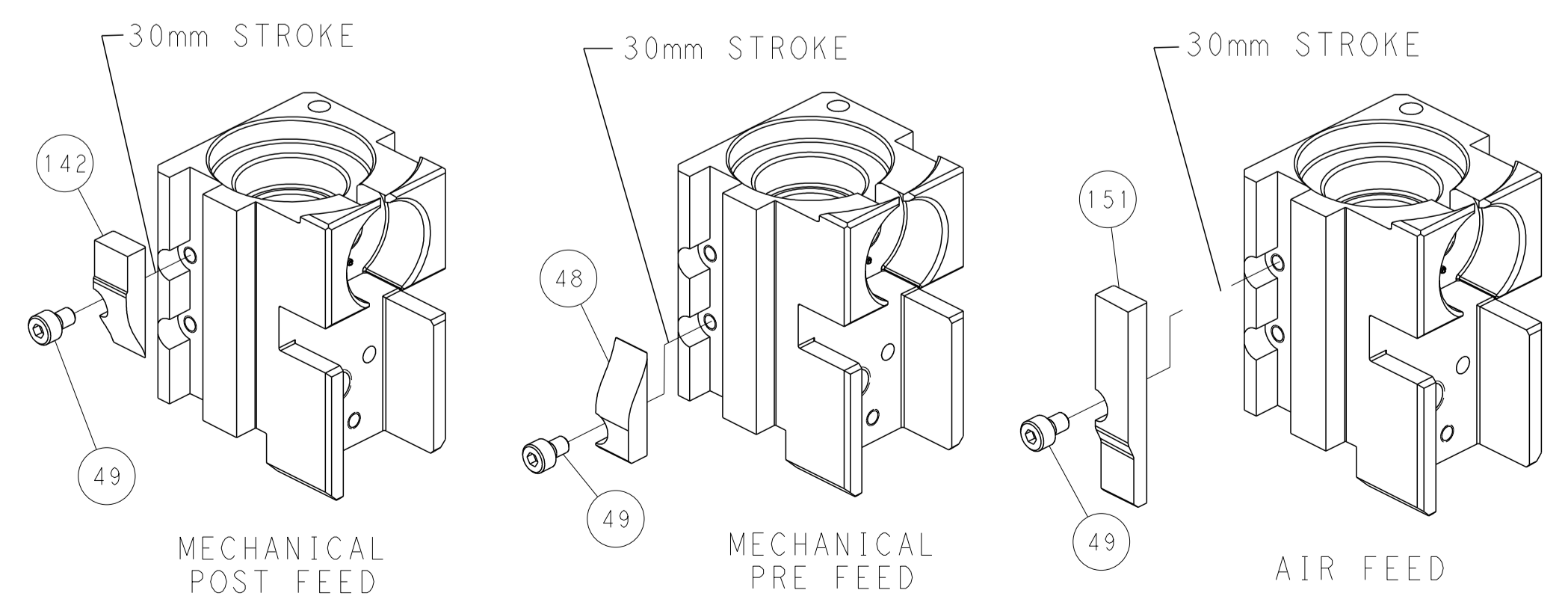
PNEUMATIC



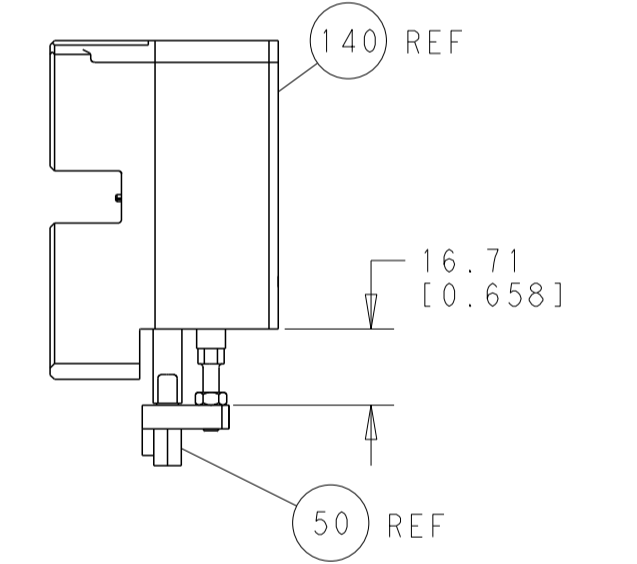
SERVO LATCH PLATE



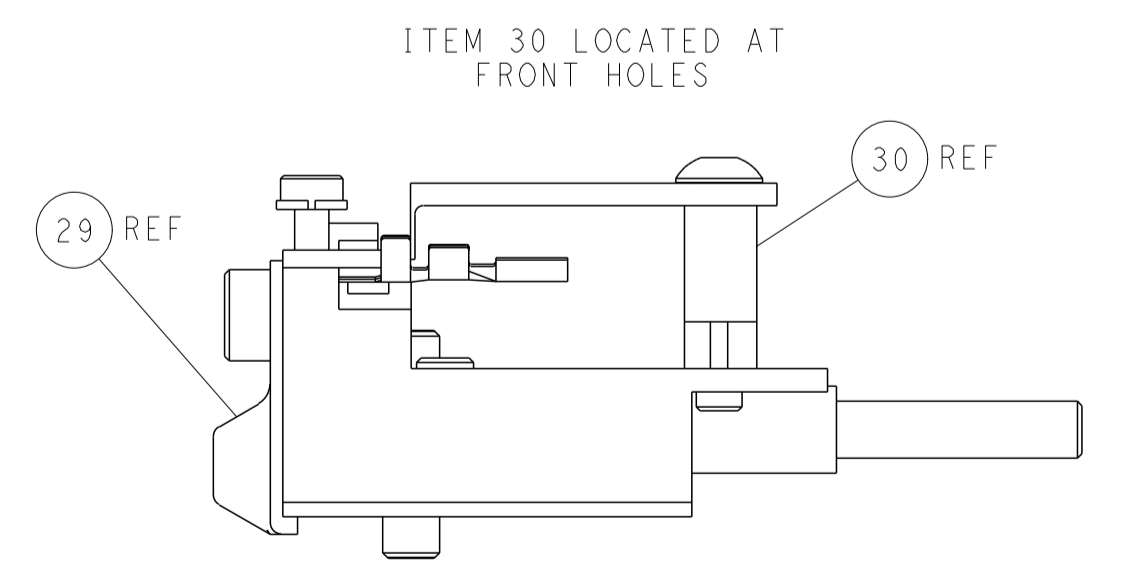
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.05 2 PLC ±.02 3 PLC ±.005 4 PLC ±.0005 ANGLES ±.1 | | DWN L. ZHANG 01DEC2011 CHK L. ZHANG 01DEC2011 APVD S. XI 01DEC2011 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A 00779 C=2151406 RESTRICTED TO | |
| MATERIAL | | FINISH | | SCALE 1:1 | | SHEET 4 OF 4 REV A | |