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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2151123-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151123-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151123-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151123-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2151123-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151123-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151123-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151123-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
2151123-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151123-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN 2000			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.46 mm [.185-.215 IN]		Ø1.27-2.79 mm [.050-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794121-1	3-794121-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	0.91 +/- 0.05 [.036 +/- .002]	7.4
20 AWG	0.86 +/- 0.05 [.034 +/- .002]	7.9
22 AWG	0.76 +/- 0.05 [.030 +/- .002]	8.9

- 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: 8-2151123-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151123-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151123-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151123-6
- 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 2-23419-6 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 -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.

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

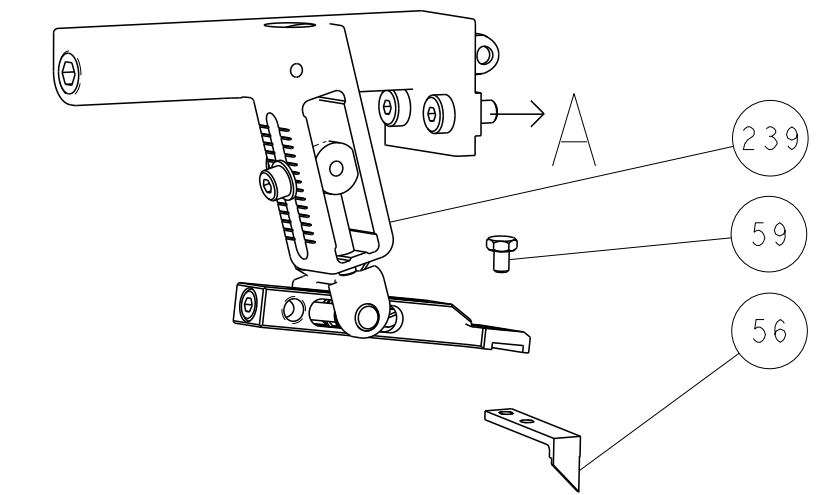
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			B		ECR-15-003642	05MAR2015	MR	TE

1	-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
1	-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
1	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
1	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
1	-	-	-	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	-	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
1	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
1	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
1	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
1	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
1	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
1	-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
1	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
1	-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
1	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
1	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
1	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
1	-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
1	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
1	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
1	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
1	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
1	-	1	1	1	1	455888-6	SPACER, CRIMPER	82
1	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
1	-	1	-	1	1	2119740-1	TAG, IDENTIFICATION	67
1	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
1	-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
1	-	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	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
1	-	-	-	1	1	1338685-1	PAWL, FEED	56
1	-	2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
1	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
1	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
1	-	-	-	-	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	-	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	1320908-6	SPACER, STRIP GUIDE	30
1	-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
1	-	1	1	1	1	455888-4	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	1333230-2	ANVIL, COMBINATION	8
1	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
1	-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	-	1	1	1	1	1-1633965-0	CRIMPER, INSULATION O PREMIUM	3
1	-	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	-	1	1	1	1	3-456403-3	CRIMPER, WIRE PREMIUM	1

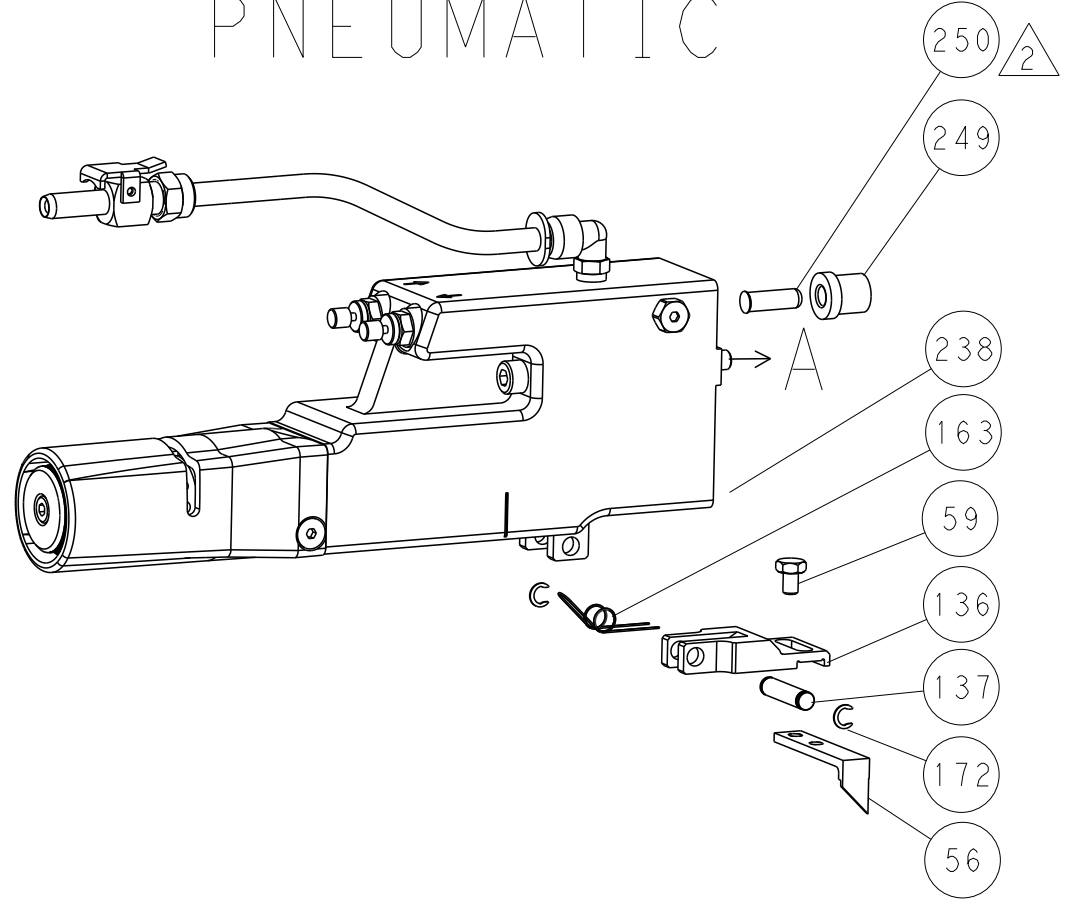
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mm	0 PLC ±.5 1 PLC ±.5 2 PLC ±.5 3 PLC ±.5 4 PLC ±.5 ANGLES ±.0001	X. ZHAO	S. XI	16 JUN 2011	Ocean Side Feed Applicator
MATERIAL:	FINISH:	APVD	PRODUCT SPEC	DATE	SIZE
		I. CRUZ		16 JUN 2011	A1 00779
			APPLICATION SPEC		CAGE CODE
					00779
			WEIGHT		DRAWING NO
					©=2151123
					RESTRICTED TO
					Customer Accessible Production Drawing
					SCALE
					1:2
					SHEET
					1 of 4
					REV
					B

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

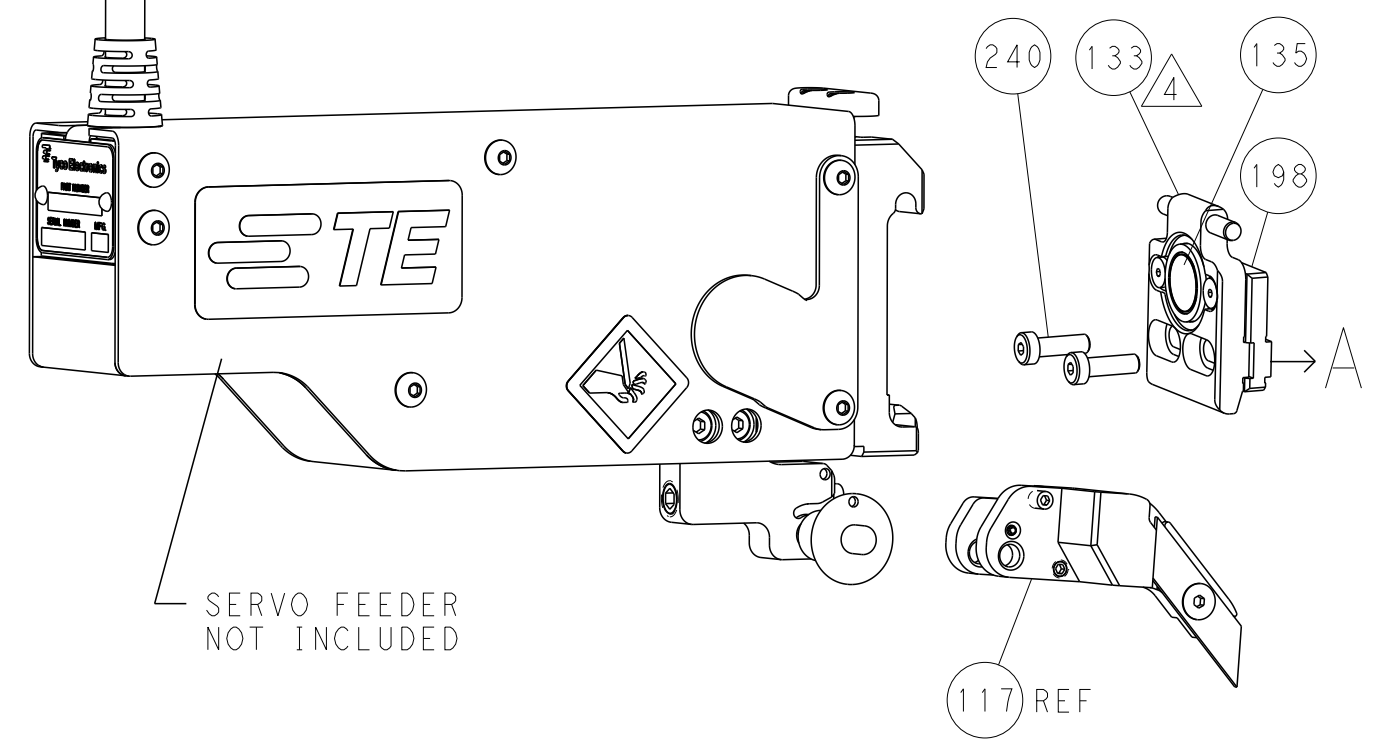
FEED TYPE MECHANICAL



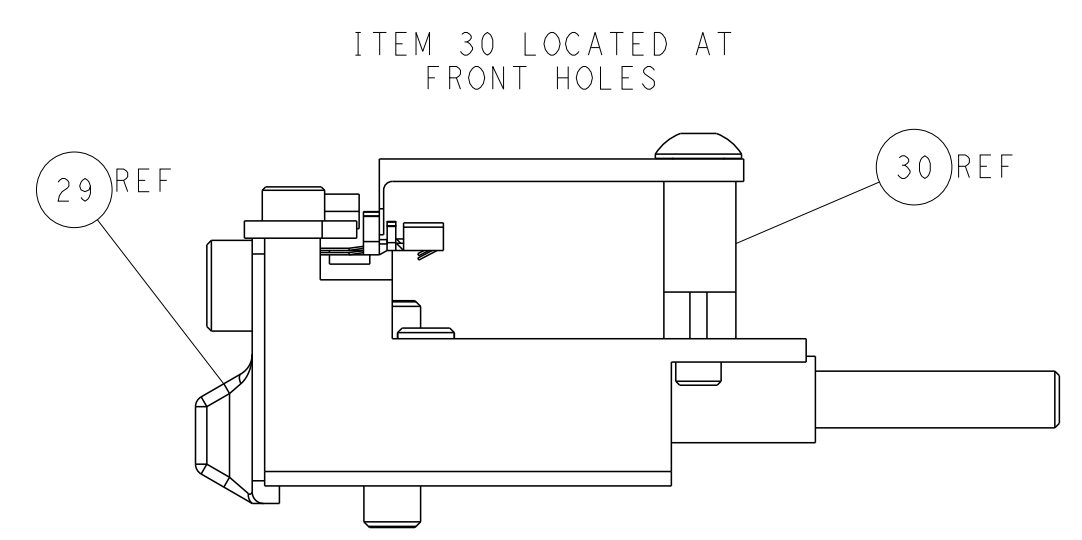
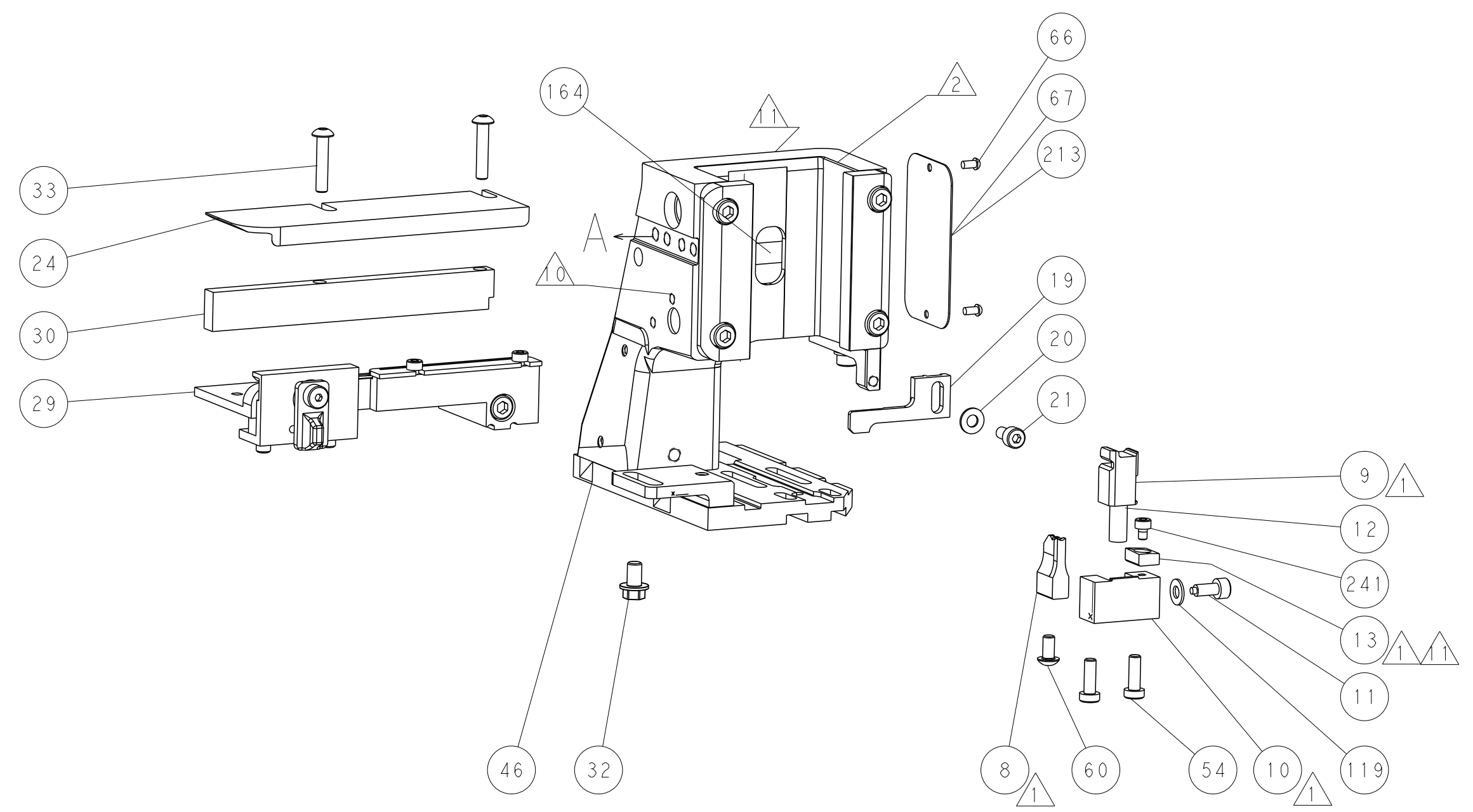
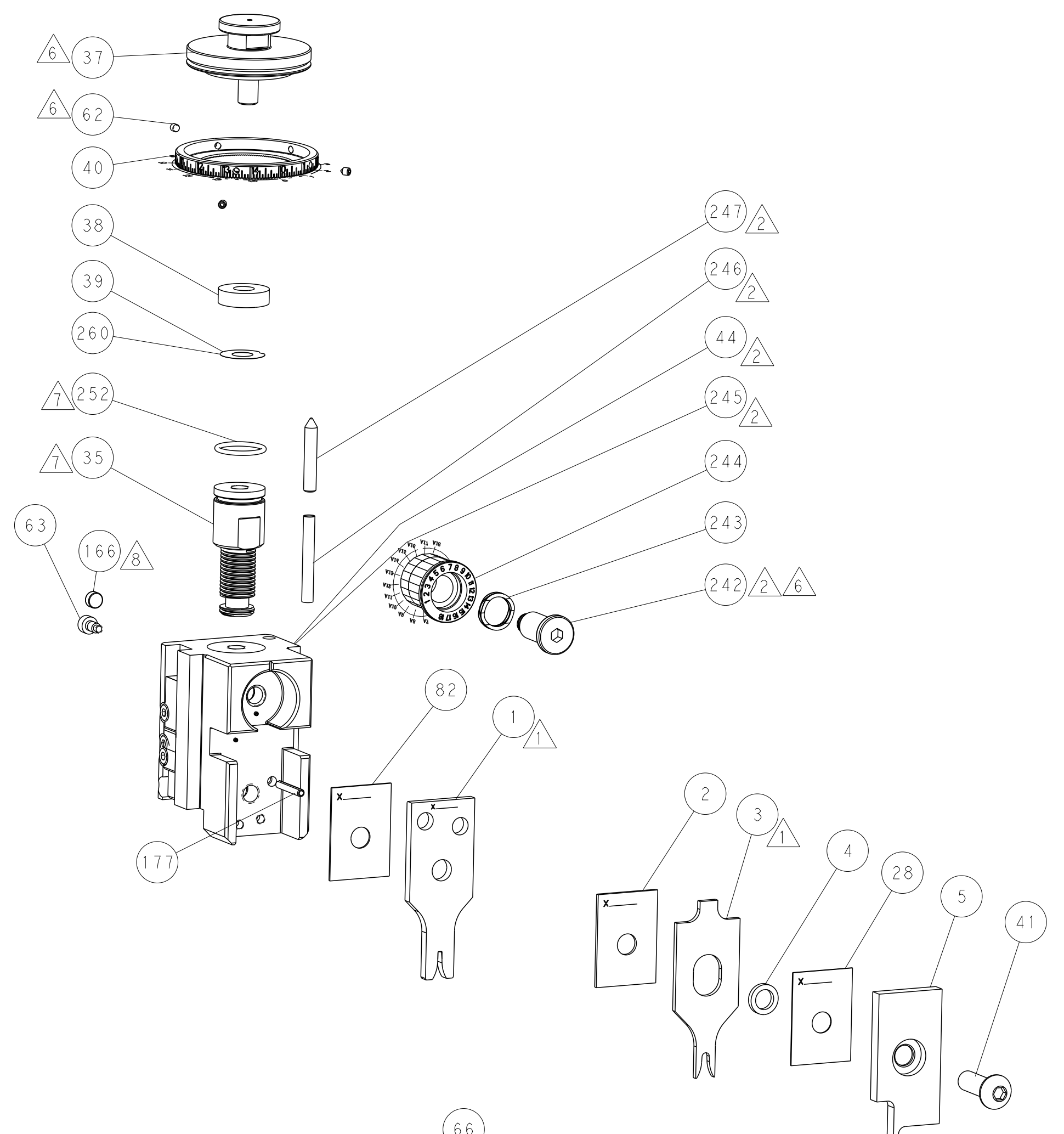
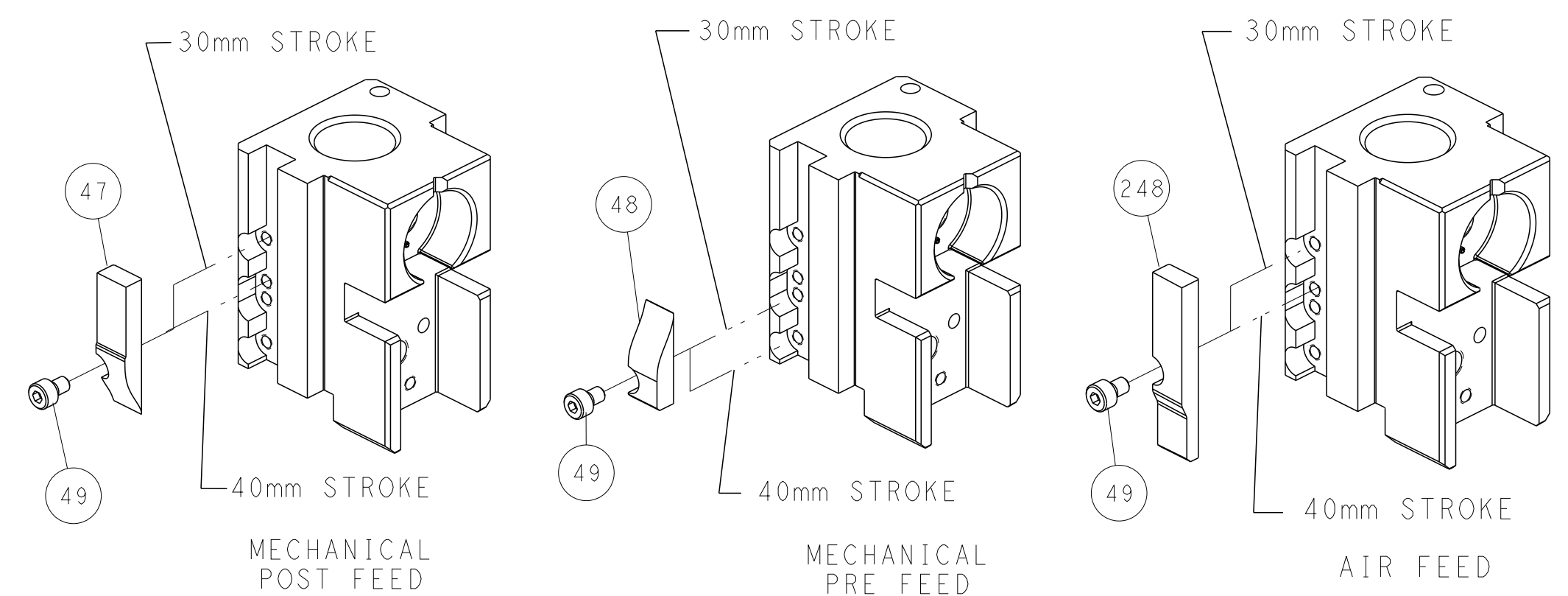
PNEUMATIC



SERVO LATCH PLATE



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 3 PLC ±0.13 4 PLC ±0.013 ANGLES ±0.0001		DWN X_ZHAO 16JUN2011 CHK S_XI 16JUN2011 APVD J_CRUZ 16JUN2011		NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151123	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 2 OF 4 REV B	

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009.

C

B

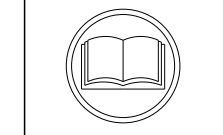
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Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a diagram of the Pacific Version Terminator Interface Adapter.

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

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED table.

Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.



- 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...

*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.

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

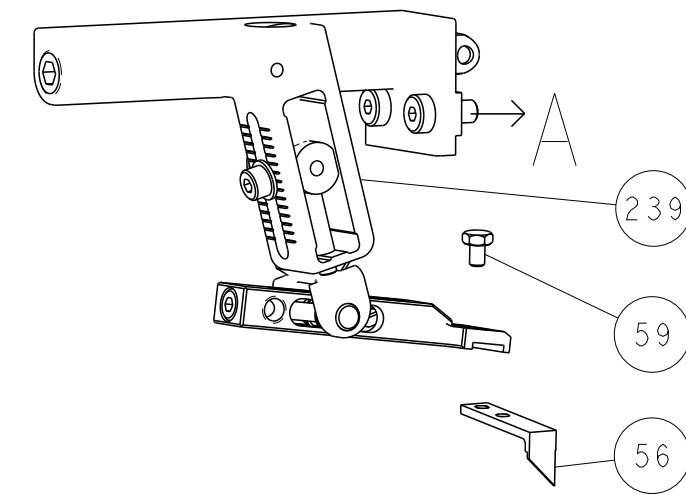
Table with columns: SET UP GAUGE, LOC, DIST, REVISIONS. Includes a small table for REVISIONS.

Large table with columns: ITEM NO, PART NO, DESCRIPTION, ITEM NO. Lists various components like FINE ADJUST HEAD ASM, PUSH ROD, BUSHING, SPRING, etc.

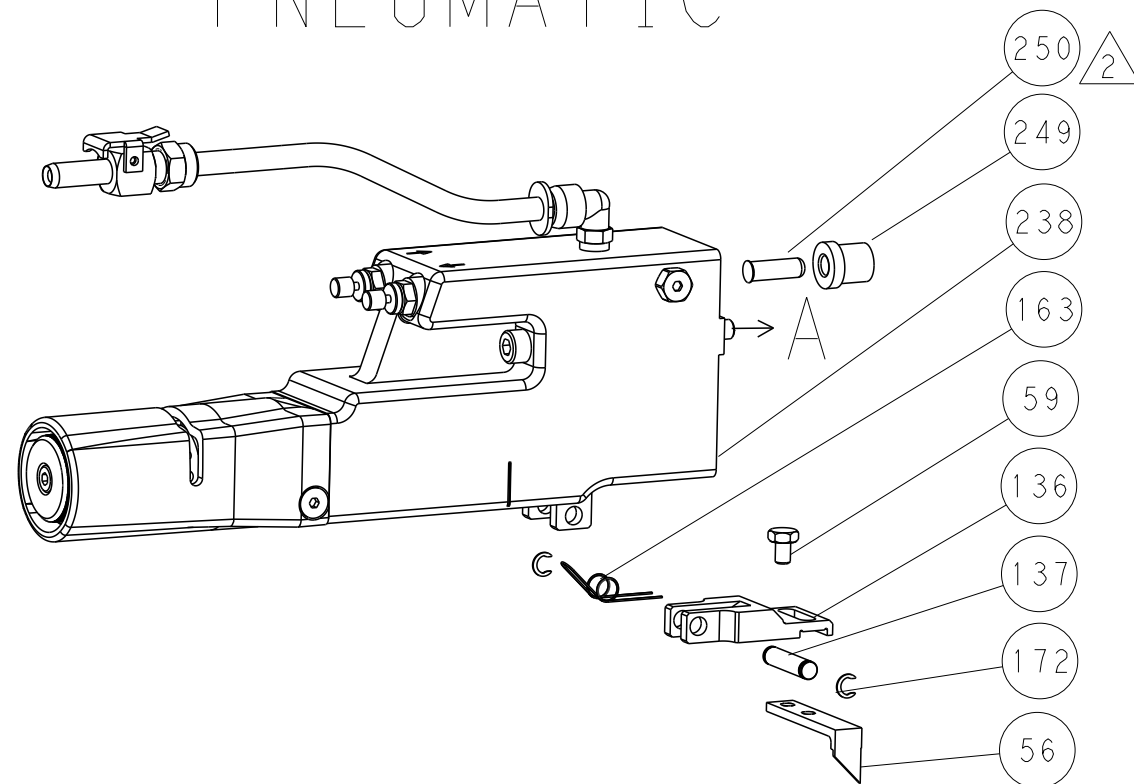
Product information block including dimensions, tolerances, material, finish, weight, and customer accessible production drawing information.

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

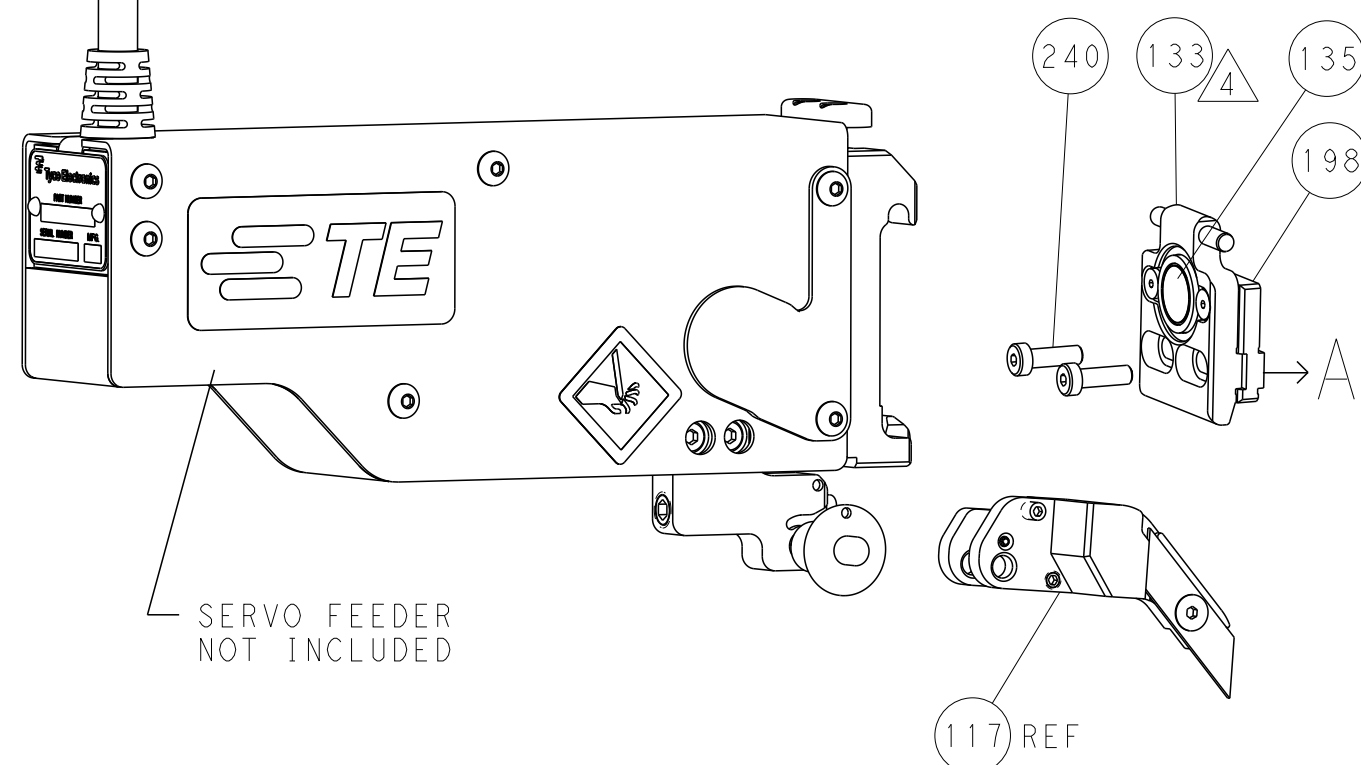
FEED TYPE MECHANICAL



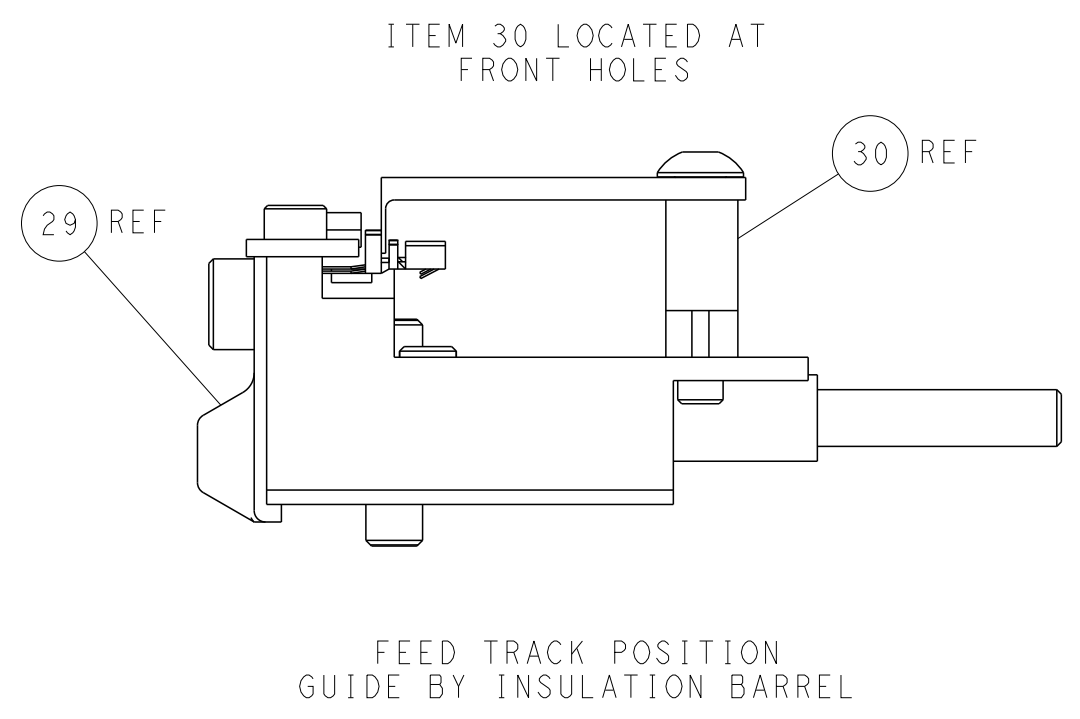
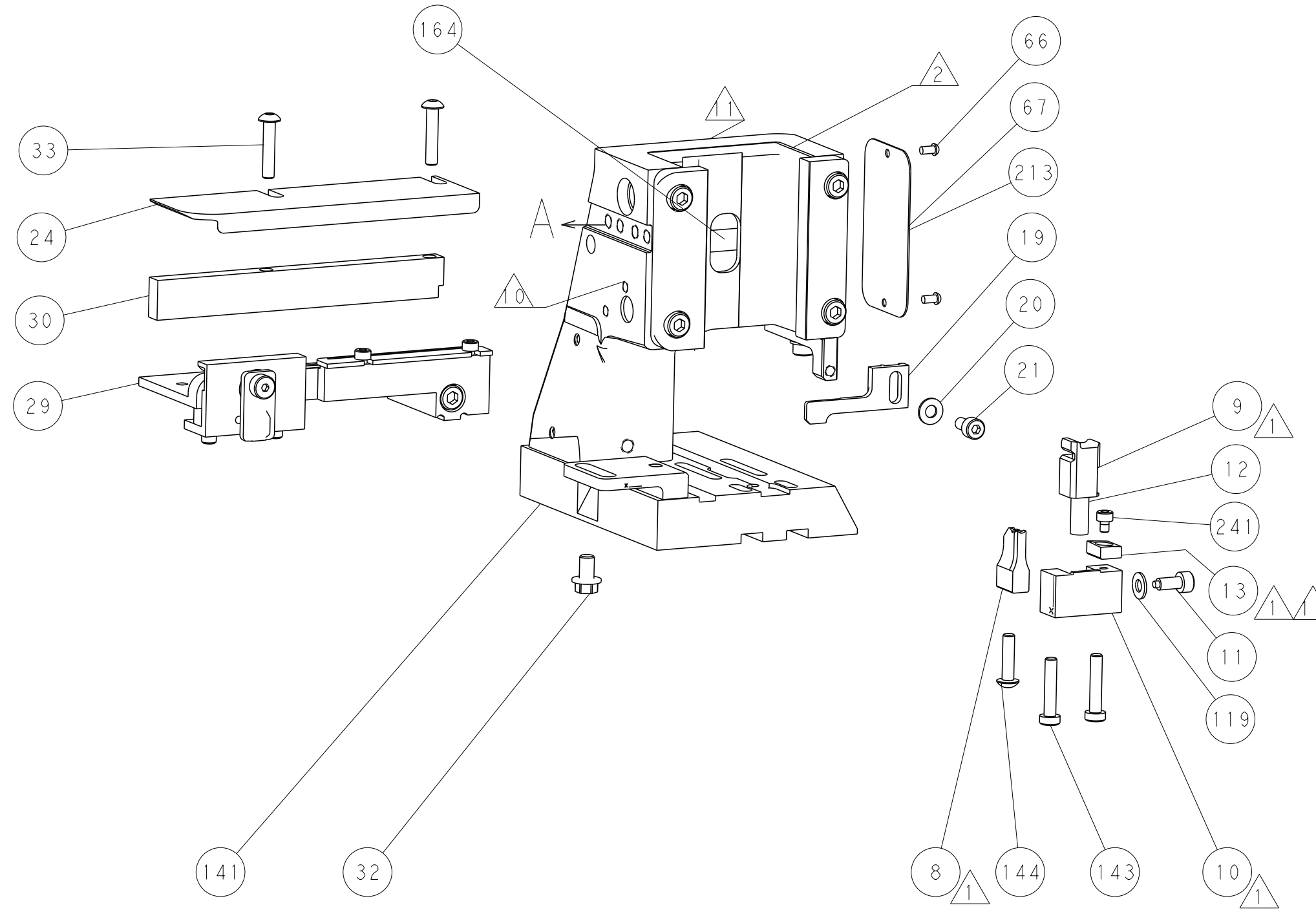
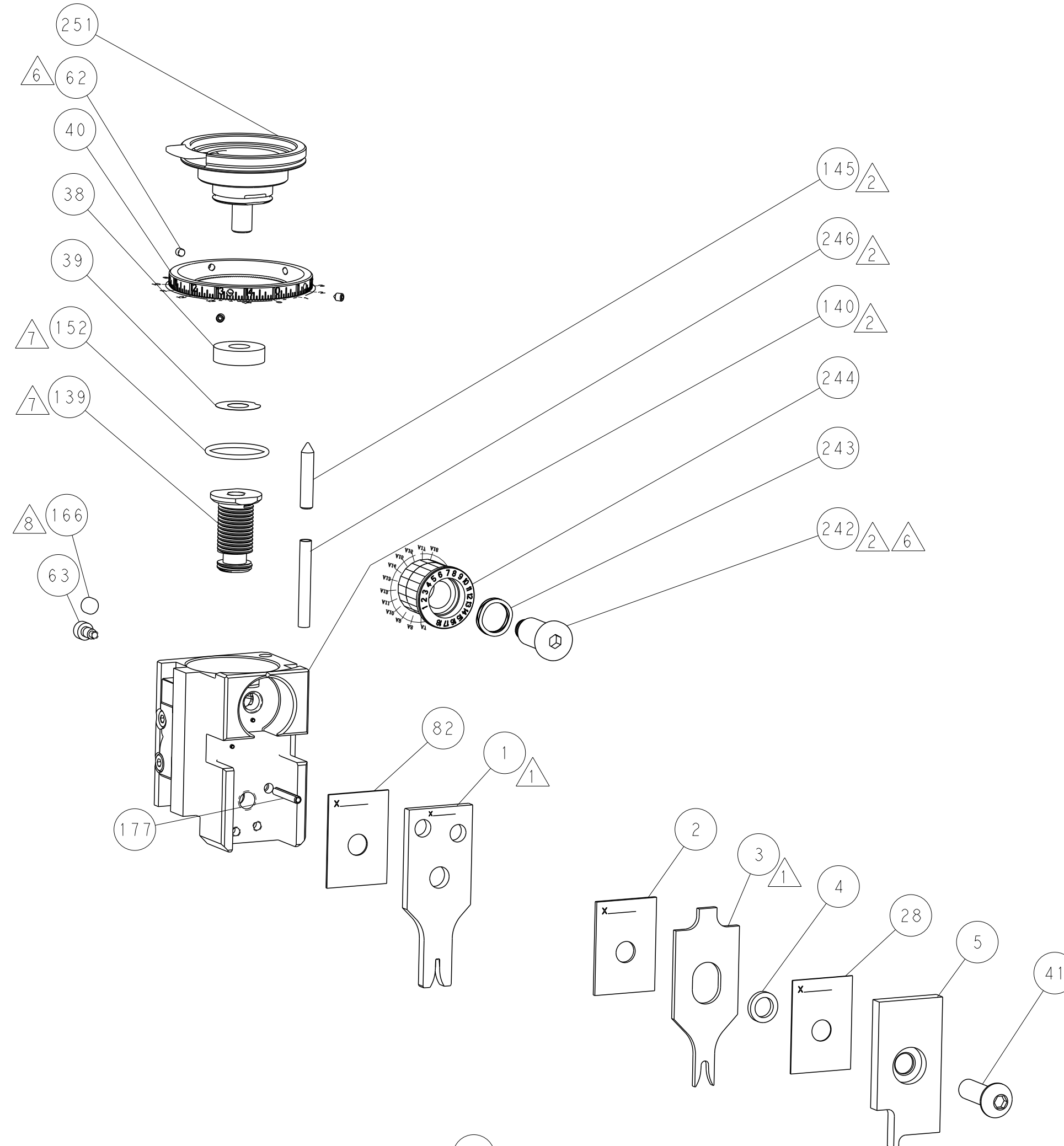
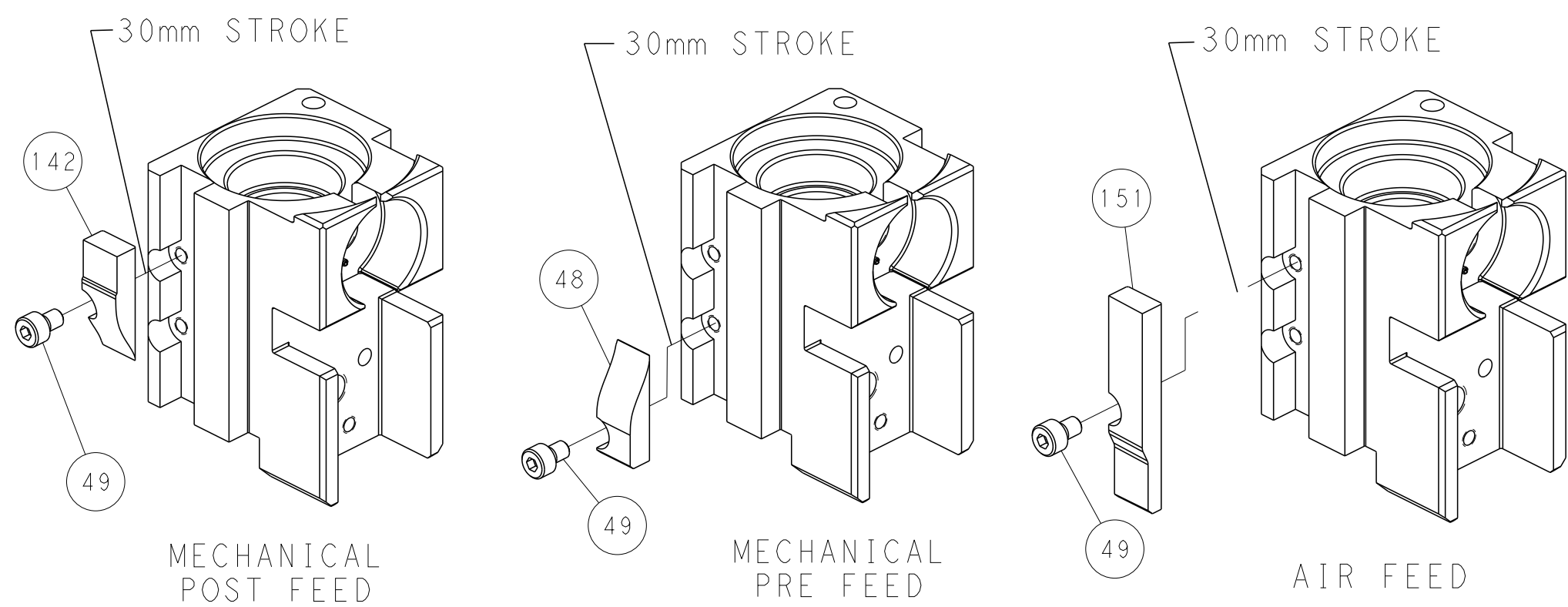
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X.ZHAO 16JUN2011		STE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD S.XI 16JUN2011	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME		RESTRICTED TO	
				Ocean Side Feed Applicator			
				SIZE CAGE CODE DRAWING NO		SCALE 1:2 SHEET 4 OF 4 REV B	
				WEIGHT		Customer Accessible Production Drawing	
				A1 00779 C=2151123			