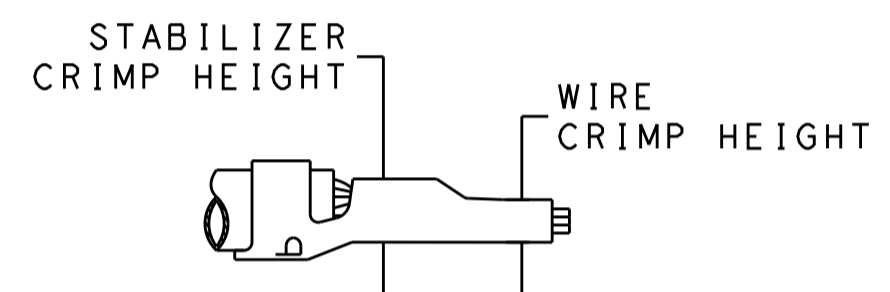


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO		PART NUMBERS REQUIRED			
					PNEUMATIC FEED	SERVO LATCH PLATE SMART APPLICATOR	2119950-1	1338685-1	5-18022-5	2119641-1
2151314-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	MECHANICAL FEED	2119951-1	-	8-2151314-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)
2151314-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151314-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE SMART APPLICATOR	2119951-1	-	8-2151314-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)
2151314-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151314-7	C	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
7-2151314-*	-	SEE CRIMP TOOLING KITS BELOW	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
STABILIZER	2.79 mm [.110]	O
INSULATION	3.94 mm [.155]	F

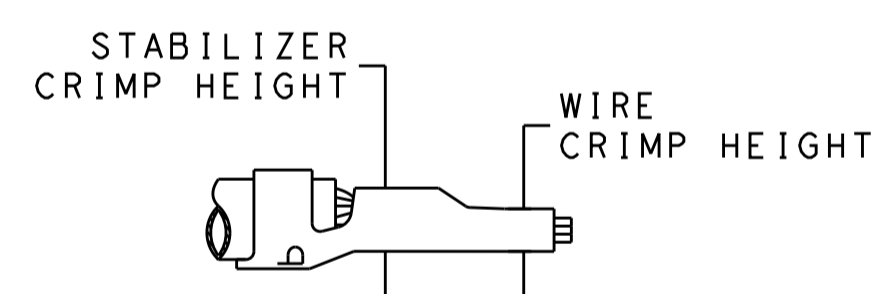
PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2151314-7	C	12 AWG	7-456408-6	815664-2	6-2119582-7	1633923-5
7-2151314-8	C	14 AWG	2-456408-5	815664-6	6-2119582-7	1633923-5
7-2151314-9	C	18-16 AWG	2-456408-6	815664-7	6-2119582-7	1633923-5

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.83-5.59 mm [.190-.220 IN]		Ø2.29-3.81 mm [.090-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-794013-1			



WIRE SIZE	WIRE CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.16+/-0.05 [.085+/- .002]	7-456408-6	2.79+/-0.05 [.110+/- .002]	815664-2	9.1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.83-5.59 mm [.190-.220 IN]		Ø2.29-3.81 mm [.090-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-770060-1			



WIRE SIZE	WIRE CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.40+/-0.05 [.055+/- .002]	2-456408-5	2.75+/-0.10 [.108+/- .004]	815664-6	7.6
18-16 AWG	1.09+/-0.05 [.043+/- .002]	2-456408-6	2.40+/-0.10 [.094+/- .004]	815664-7	7.8

- 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: 8-2151314-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151314-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151314-5
 - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151314-6
- 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. 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 ITEM 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 3.72.
- ITEMS 1 & 178 TO BE USED WITH 12 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- ITEMS 253 & 254 TO BE USED WITH 14 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- ITEMS 255 & 256 TO BE USED WITH 18-16 AWG ONLY. APPLICATOR TO BE SET UP WITH THESE ITEMS.
- POSITION ITEM 19 BETWEEN ITEMS 1 AND 178.

***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.

-79	-78	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
1	-	-	1	1	1	1	1	2-456408-6	CRIMPER, WIRE PREMIUM	256
1	-	-	1	1	1	1	1	815664-7	CRIMPER, WIRE-O	255

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	REV	DATE	BY	APPV
			A	RELEASED	13MAR2013	LG TE
			B	ECR-15-010117	15JUL2015	KH TE
			B1	ECR-15-011816	10AUG2015	JH UG
			C	ECR-16-005909	09MAY2016	KH LZ

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO						
-	-	-	-	1	1	1	1	1	2-456408-5	CRIMPER, WIRE PREMIUM	254
-	-	-	-	1	1	1	1	1	815664-6	CRIMPER, WIRE-O	253
-	-	-	-	1	1	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	-	-	-	-	-	2119641-1	FEED CAM, AIR FEED	248
-	-	-	-	-	-	-	-	-	2119798-1	DETENT PIN	247
-	-	-	-	-	-	-	-	-	1-22279-3	SPRING, COMPRESSION	246
-	-	-	-	-	-	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	-	-	-	-	-	-	-	-	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	-	-	-	-	-	-	-	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	-	-	-	-	-	-	-	2119083-1	RETAINER, INSULATION DIAL	242
-	-	-	-	-	-	-	-	-	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	-	-	-	-	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	-	-	-	-	-	2063440-1	AIR FEED MODULE	238
-	-	-	-	-	-	-	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	-	-	-	-	-	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	-	-	-	-	-	7-456408-6	CRIMPER, WIRE PREMIUM	178
-	-	-	-	-	-	-	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	-	-	-	-	-	-	-	-	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	-	-	-	-	-	-	-	-	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	-	-	-	-	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	-	-	-	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	-	-	-	-	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	-	-	-	-	-	-	-	REF REF	SEE NOTE 4	135
-	-	-	-	-	-	-	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	-	-	-	-	-	-	-	-	1-18028-2	WASHER, FLAT, REG M4	119
-	-	-	-	-	-	-	-	-	REF REF		117
-	-	-	-	-	-	-	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	-	-	-	-	-	-	-	-	455888-5	SPACER, CRIMPER	82
-	-	-	-	-	-	-	-	-	2119956-1	DOCUMENTATION PACKAGE	71
-	-	-	-	-	-	-	-	-	2119740-1	TAG, IDENTIFICATION	67
-	-	-	-	-	-	-	-	-	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	-	-	-	-	-	-	-	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	-	-	-	-	-	-	-	-	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	-	-	-	-	-	-	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	-	-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	-	-	-	-	1338685-1	PAWL, FEED	56
-	-	-	-	-	-	-	-	-	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	-	-	-	-	-	-	-	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
-	-	-	-	-	-	-	-	-	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	-	-	-	-	-	-	-	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	-	-	-	-	-	-	-	-	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	-	-	-	-	-	-	-	-	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	-	-	-	-	-	-	-	-	2119957-1	APPLICATOR SHIM PACK	39
-	-	-	-	-	-	-	-	-	2119644-5	RAM WASHER, PRECISION	38
-	-	-	-	-	-	-	-	-	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	-	-	-	-	-	-	-	-	2119092-1	BOLT, ADJUSTMENT	35
-	-	-	-	-	-	-	-	-	469465-4	STOP, WIRE	34
-	-	-	-	-	-	-	-	-	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	-	-	-	-	-	-	-	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	-	-	-	-	-	-	-	-	1-1320908-0	SPACER, STRIP GUIDE	30
-	-	-	-	-	-	-	-	-	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	-	-	-	-	-	-	-	-	455888-3	SPACER, CRIMPER	28
-	-	-	-	-	-	-	-	-	1320928-2	STRIP GUIDE	24
-	-	-	-	-	-	-	-	-	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	-	-	-	-	-	-	-	-	1-18028-2	WASHER, FLAT, REG M4	20
-	-	-	-	-	-	-	-	-	2119533-3	STRIPPER, SIDE FEED	19
-	-	-	-	-	-	-	-	-	2119806-1	INSERT, SHEAR	13
-	-	-	-	-	-	-	-	-	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	-	-	-	-	1-356885-4	STOP, SHEAR	11
-	-	-	-	-	-	-	-	-	2119805-1	SHEAR HOLDER, FRONT	10
-	-	-	-	-	-	-	-	-	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1	1	1	1633923-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	-	-	6
-	-	-	-	-	-	-	-	-	-	-	5
-	-	-	-	-	-	-	-	-	-	-	4
1	1	1	1	1	1	1	1	1	6-2119582-7	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	-	455888-7	SPACER, CRIMPER	2
-	-	-	-	-	-	-	-	-	815664-2	CRIMPER, WIRE-O	1

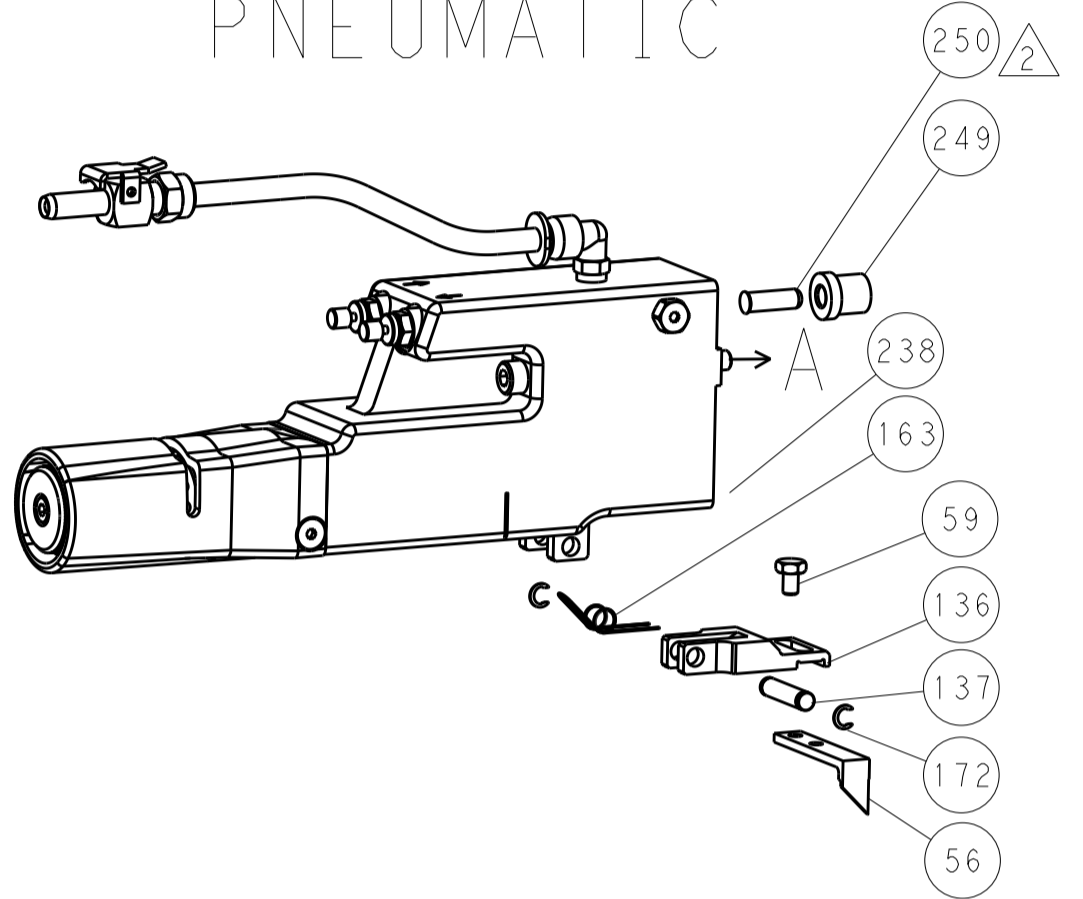
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		NAME	
mm	0 PLC	±		31JAN2013	ELB	31JAN2013	TE Connectivity
	1 PLC	±			T		Harrisburg, PA 17105-3608
	2 PLC	±			ELBIN		
	3 PLC	±			M		
	4 PLC	±			CLIFFORD		
	5 PLC	±					
	6 PLC	±					
	ANGLES	±					
	FINISH						

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

FEED TYPE MECHANICAL



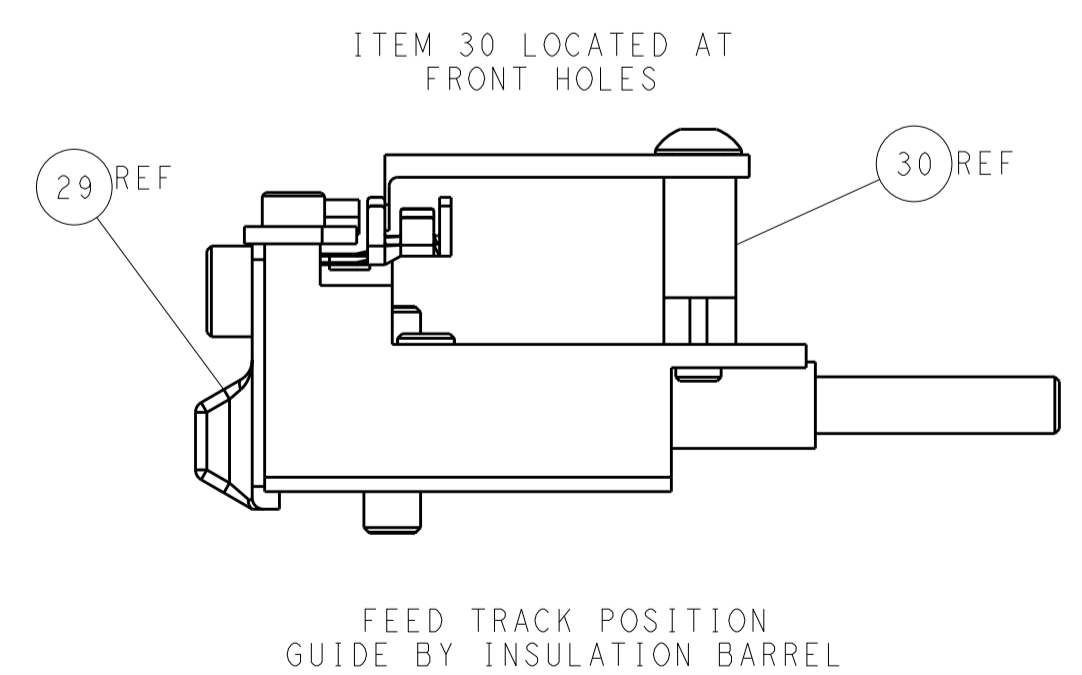
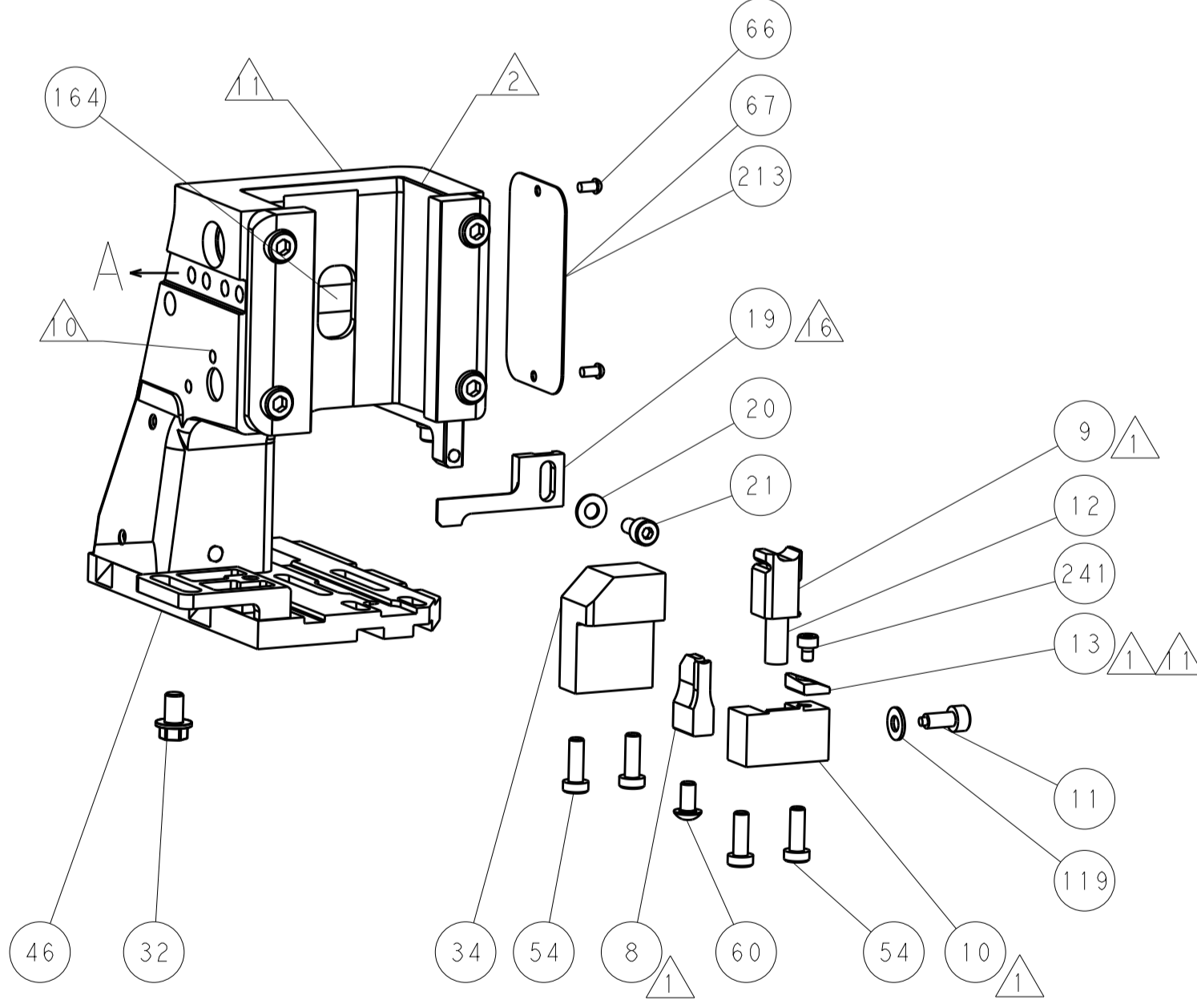
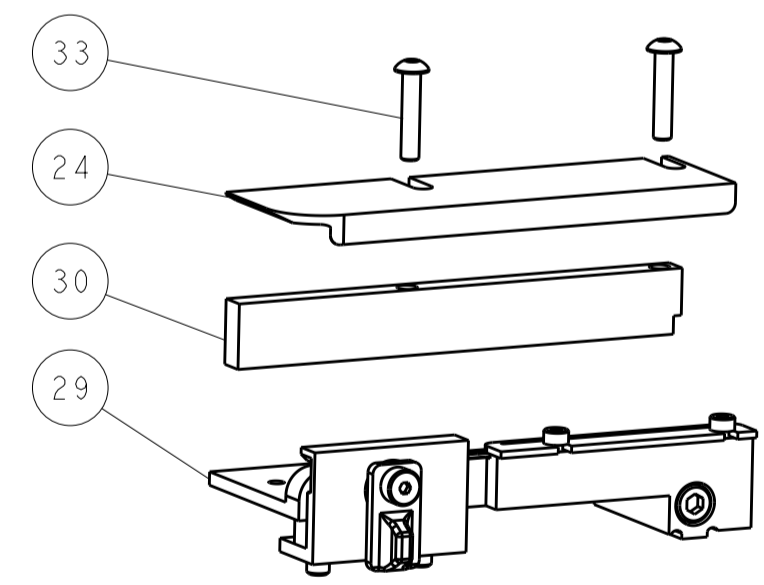
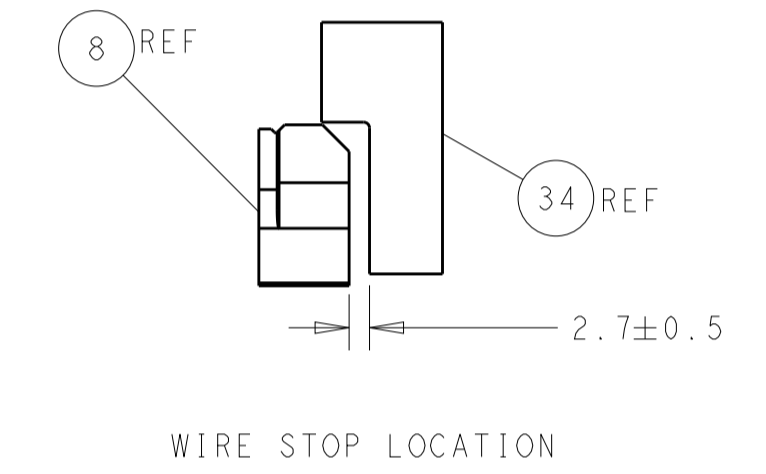
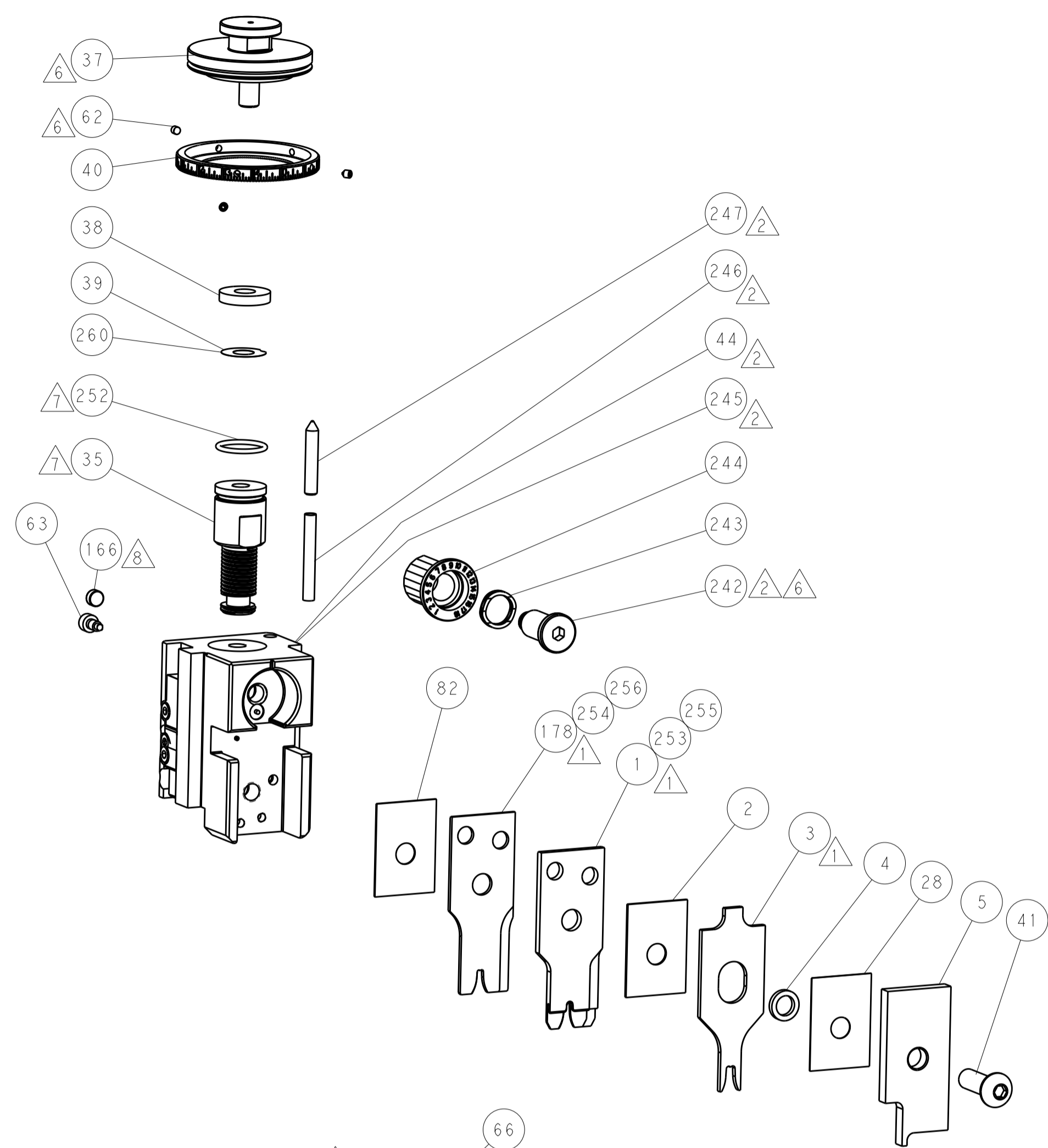
PNEUMATIC



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)

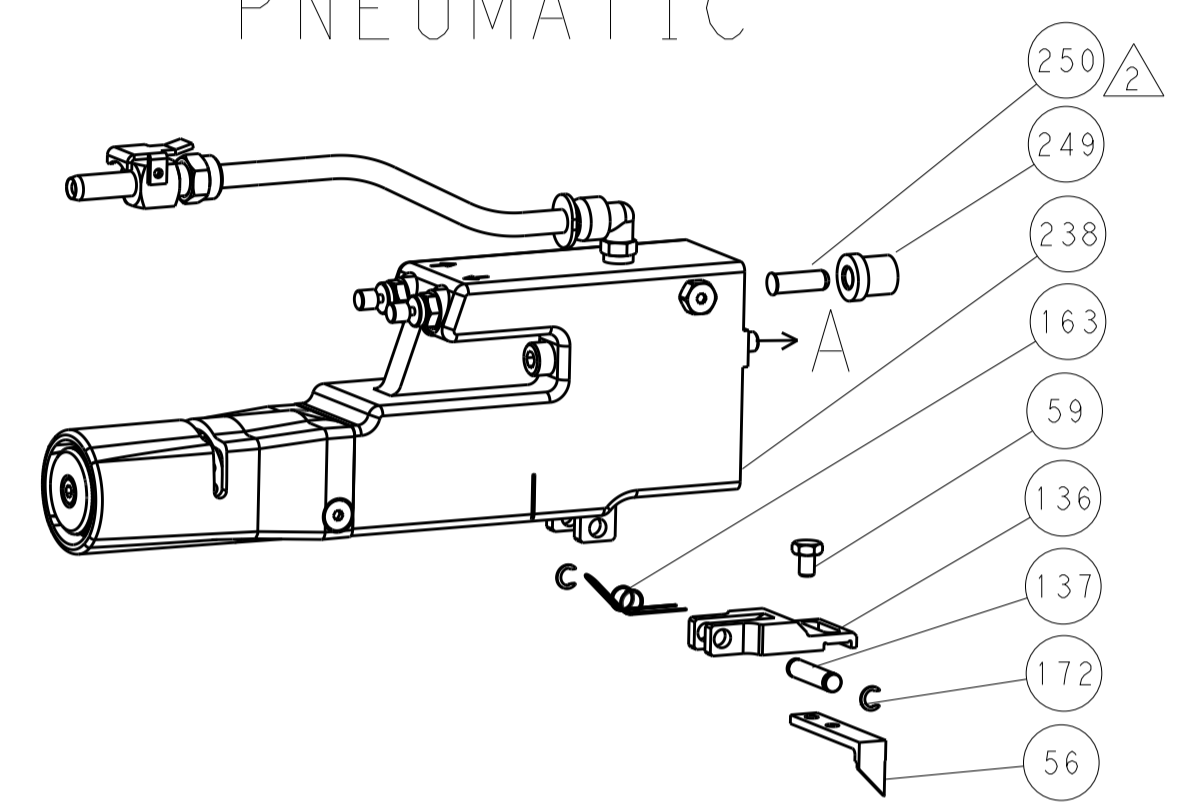
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: L. GROSS 31JAN2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	CHG: T. ELBIN 31JAN2013	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD: M. CLIFFORD 31JAN2013	NAME: Ocean Side Feed Applicator	RESTRICTED TO	
MATERIAL:				PRODUCT SPEC:	APPLICATION SPEC:	SIZE: A1	CAGE CODE: 00779
				WEIGHT:	SCALE: 1:2	DRAWING NO: C=2151314	SHEET 2 OF 4
Customer Accessible Production Drawing						REV: C	

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

FEED TYPE MECHANICAL



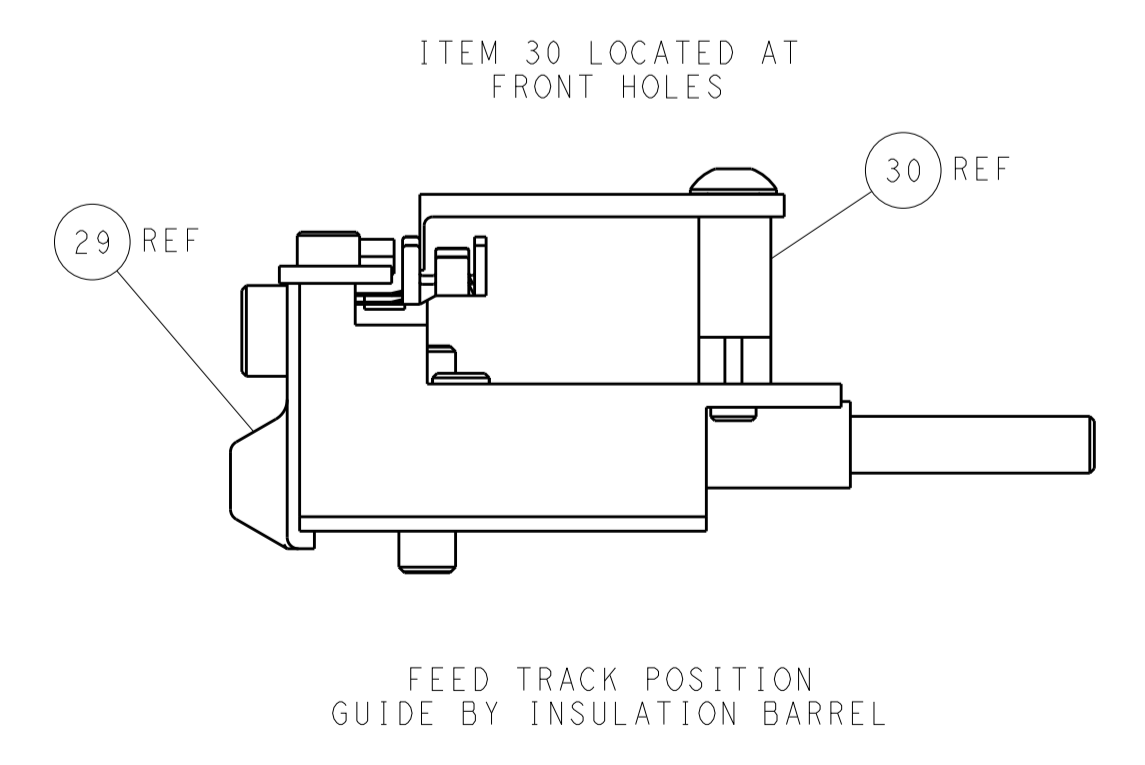
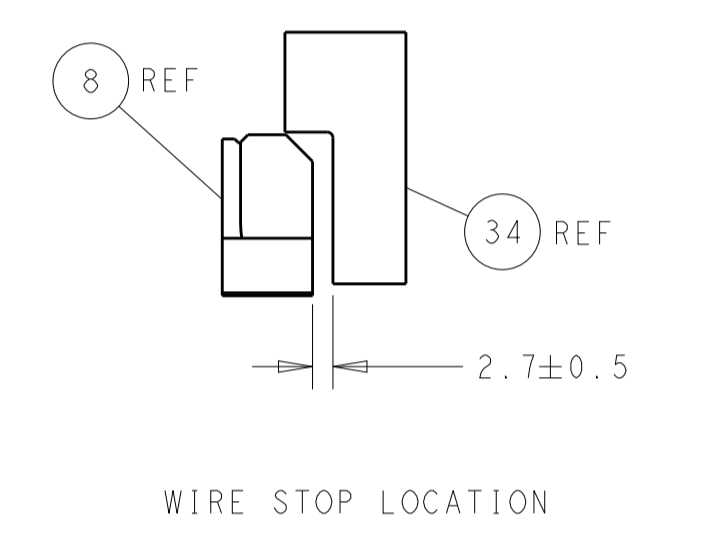
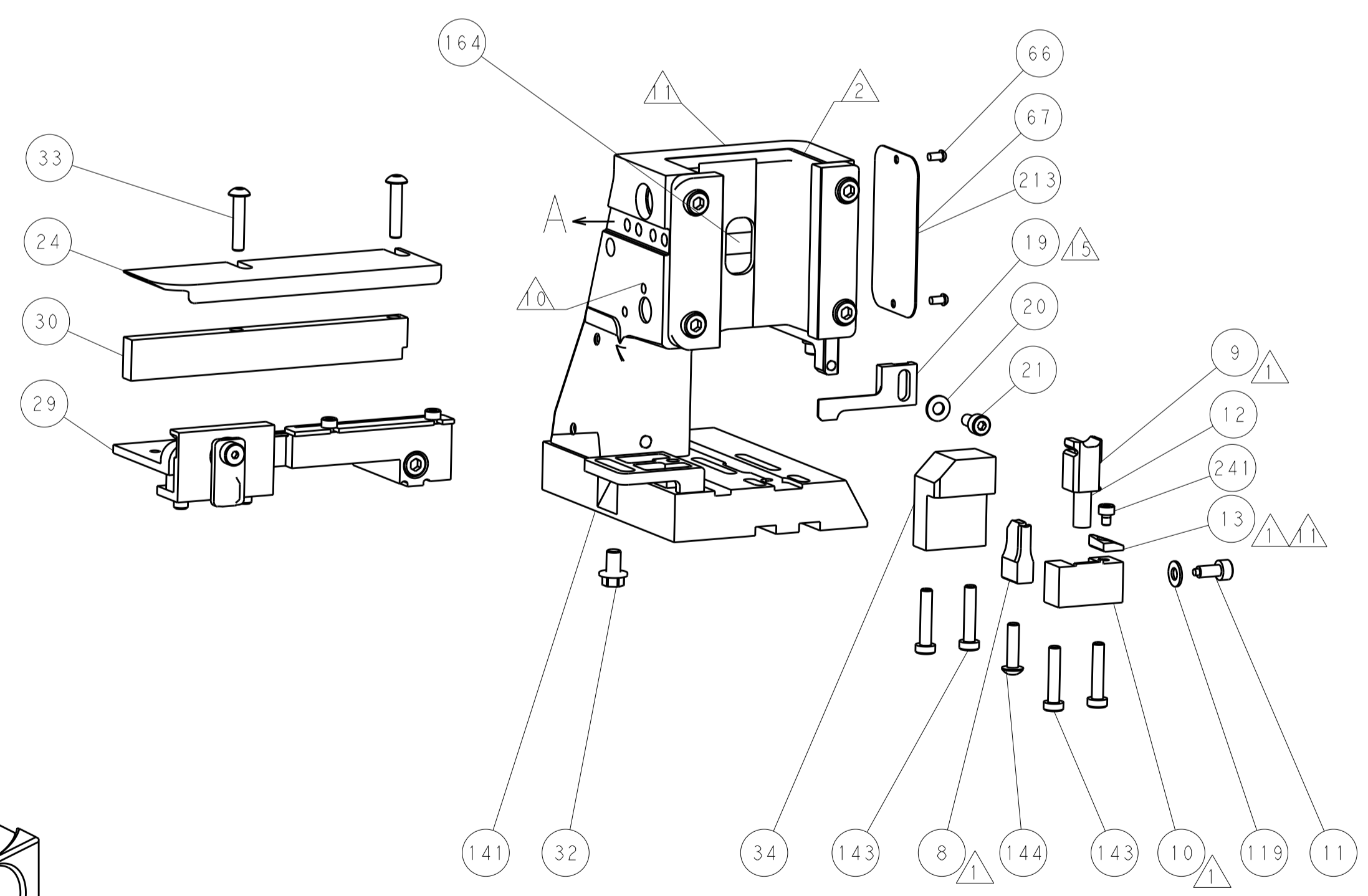
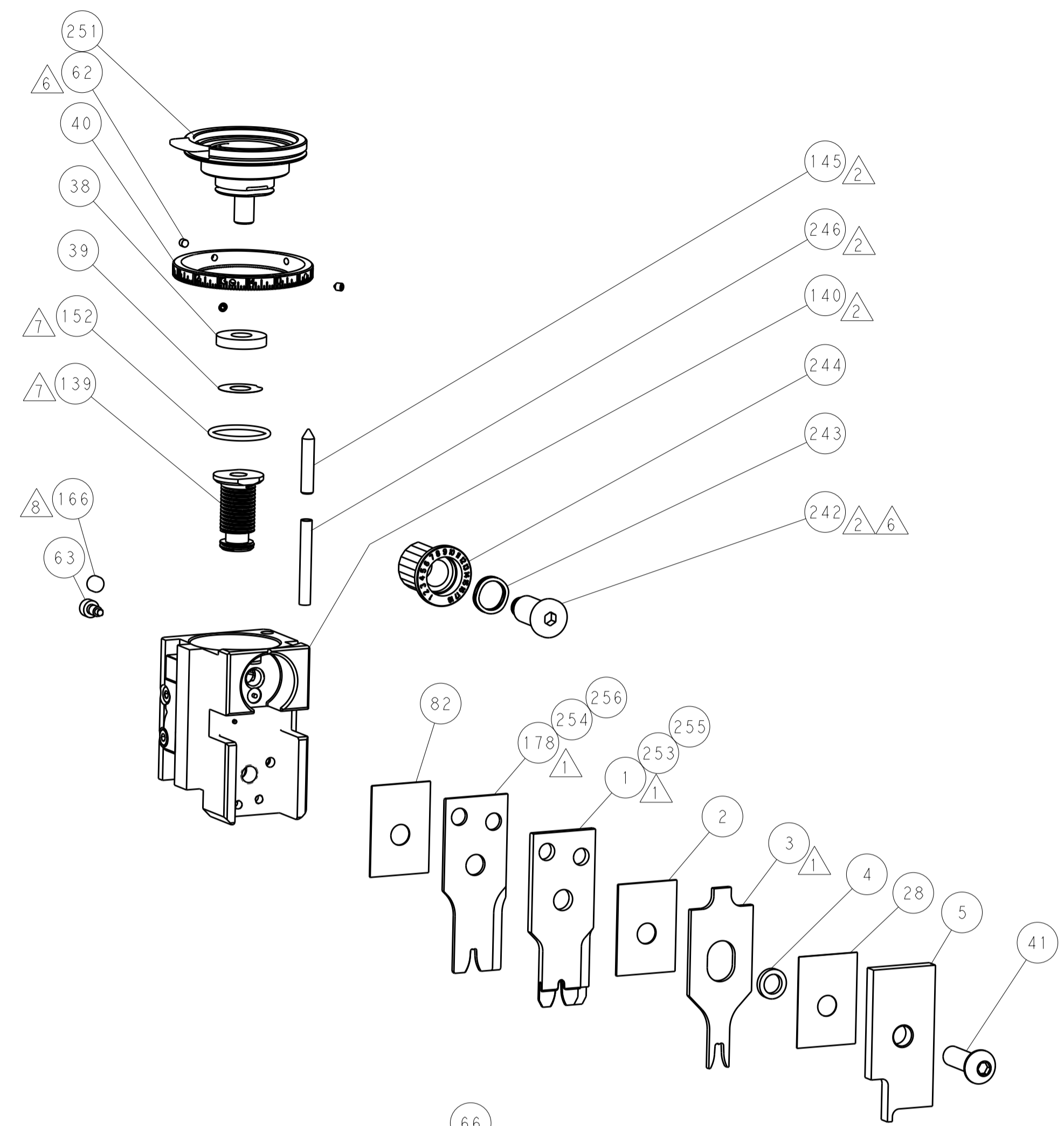
PNEUMATIC



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)

<small>THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT OBLIGATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: EL_GROSS 31JAN2013 CHK: T_ELBIN 31JAN2013 APVD: M_CLEFFORD 31JAN2013	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: CAGE CODE DRAWING NO: RESTRICTED TO:
MATERIAL:	FINISH:	A 00779 ©=2151314 Customer Accessible Production Drawing	SCALE: 1:2 SHEET 4 OF 4 REV C