

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151017-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151017-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151017-4	-	-	-
	2151017-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151017-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151017-4	-	-	-
	2151017-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	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	
2151017-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
2151017-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151017-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE		TYPE
WIRE	1.22 mm [.048]	F
INSUL	2.03 mm [.080]	F

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIV MATE-N-LOK PIN CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-4.00 mm [.126-.157 IN]		Ø1.20-1.75 mm [.047-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5050	(C)114-1111	-
	(B)114-16017	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 170359-1	(A) 170359-2	(A) 170359-3	(A) 170359-4
(A) 1-170359-2	(A) 1-170359-3	(A) 170361-1	(A) 170361-2
(A) 170361-3	(A) 170361-4	(A) 170361-5	(A) 170361-6
(A) 1-170361-3	-	-	-

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TERMINAL APPLICATION SPECIFICATION	(B)114-16017	(C)114-1111	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 1-770901-0	(B) 770901-1	(B) 770901-2	(B) 770901-3
(C) 1-794218-0	(C) 794218-1	(C) 794218-2	(C) 794218-3
(B) 770902-4	(B) 770902-1	(B) 770902-2	(B) 770902-3
(B) 1-770902-1	(B) 770902-5	(B) 770902-6	(B) 1-770902-0
(C) 1-794219-0	(C) 794219-1	(C) 794219-2	(C) 794219-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.34mm2	0.78+/-0.05 [.031+/- .002]	8.2
24 AWG OR 0.22mm2	0.69+/-0.05 [.027+/- .002]	9.1
26 AWG OR 0.14mm2	0.63+/-0.05 [.025+/- .002]	9.8

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26 AWG	0.63+/-0.05 [.025+/- .002]	9.8

- 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: 8-2151017-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151017-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151017-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151017-6
- 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 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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 -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)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			C	ECR-16-001720	03FEB2016	MR GB

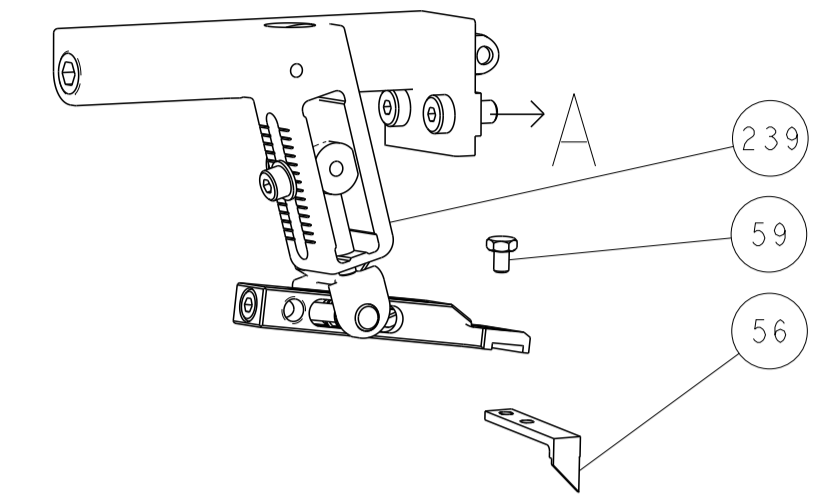
-	1	-	1	1	1	2119798-1	DETENT PIN	247	
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245	
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	-	-	-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	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	1-1752354-5	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	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	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	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	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	2119092-1	BOLT, ADJUSTMENT	35	
-	1	1	1	1	1	1752356-1	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	1803095-1	FLOATING SHEAR, FRONT	9	
	1	1	1	1	1	1333225-9	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	-	6	
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1	1-238011-3	BLOCK, CRIMPER SPACER	4	
	1	1	1	1	1	1-2119582-9	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2	
	1	1	1	1	1	568176-6	CRIMPER, WIRE	1	
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	±		

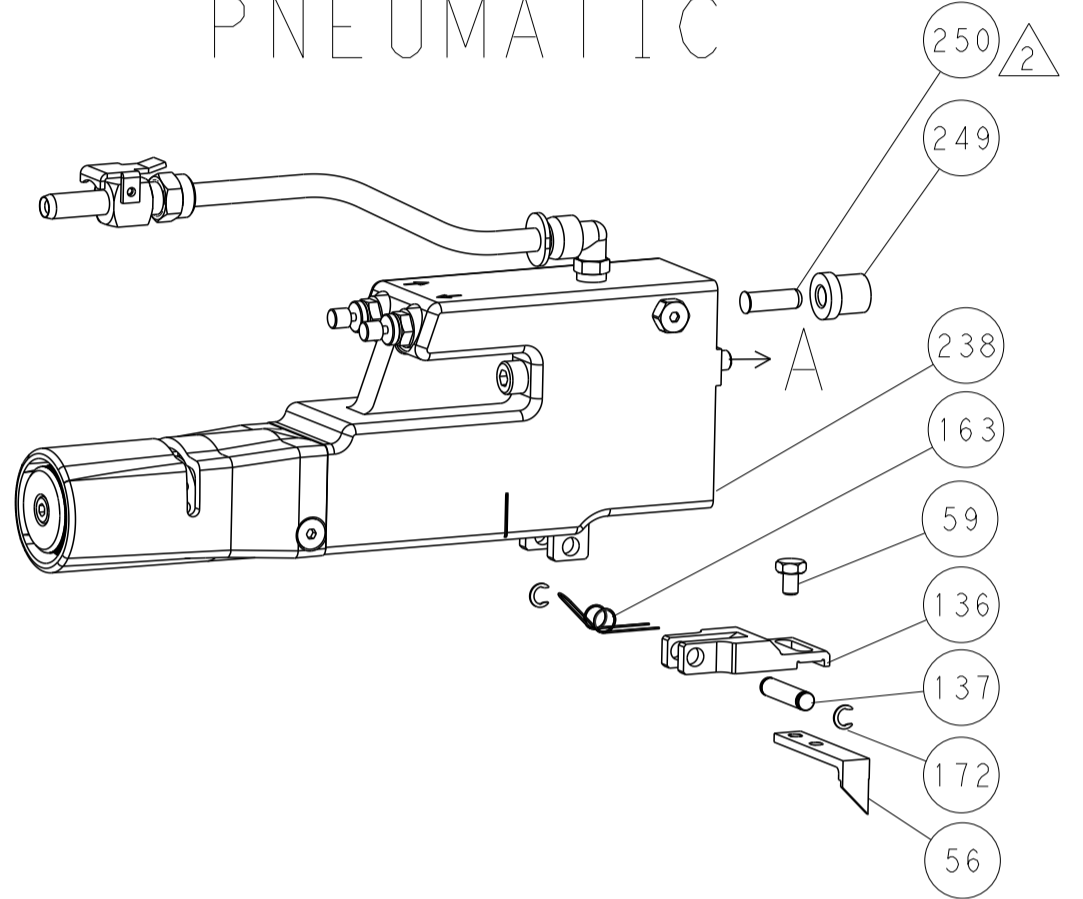
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV C

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

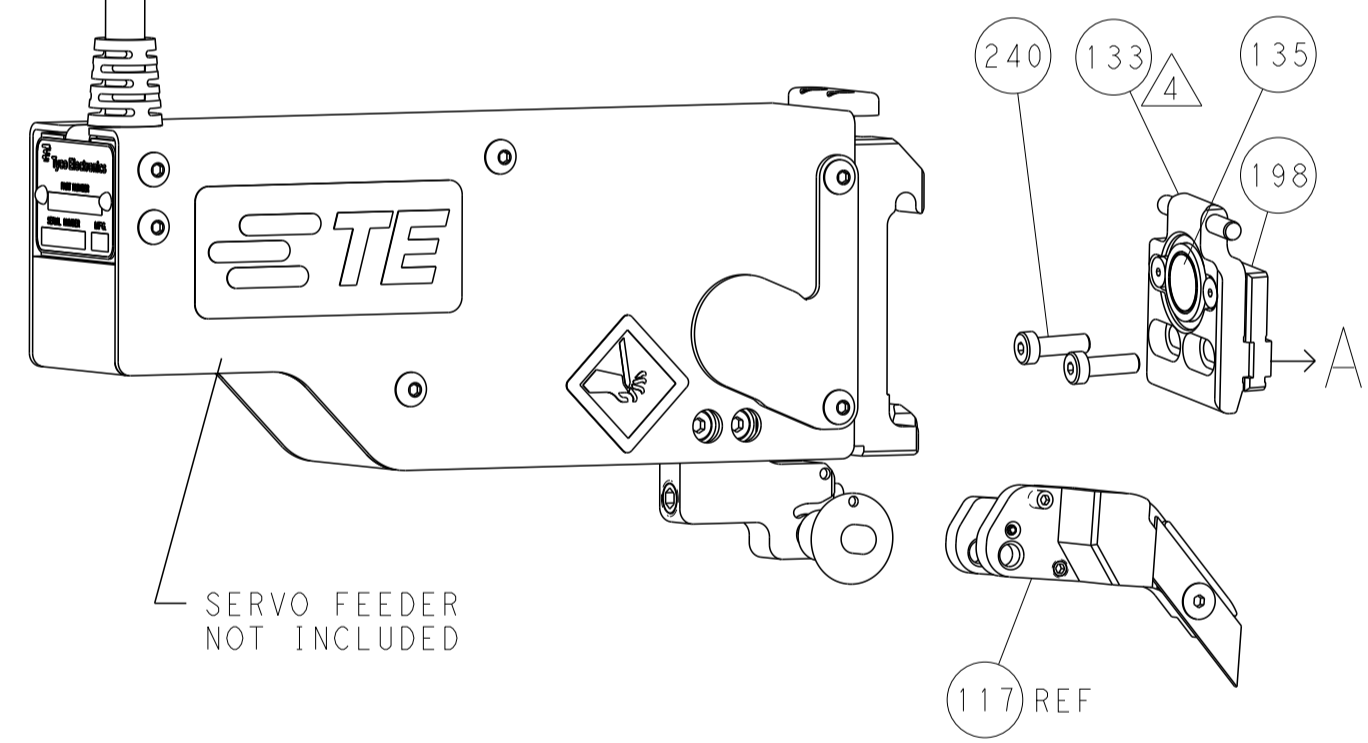
### FEED TYPE MECHANICAL



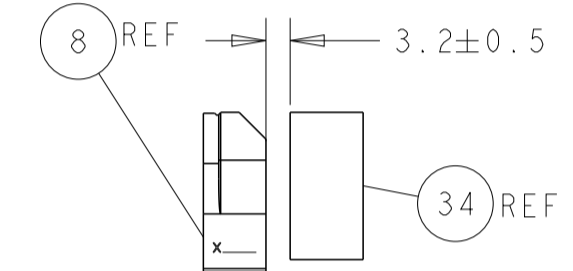
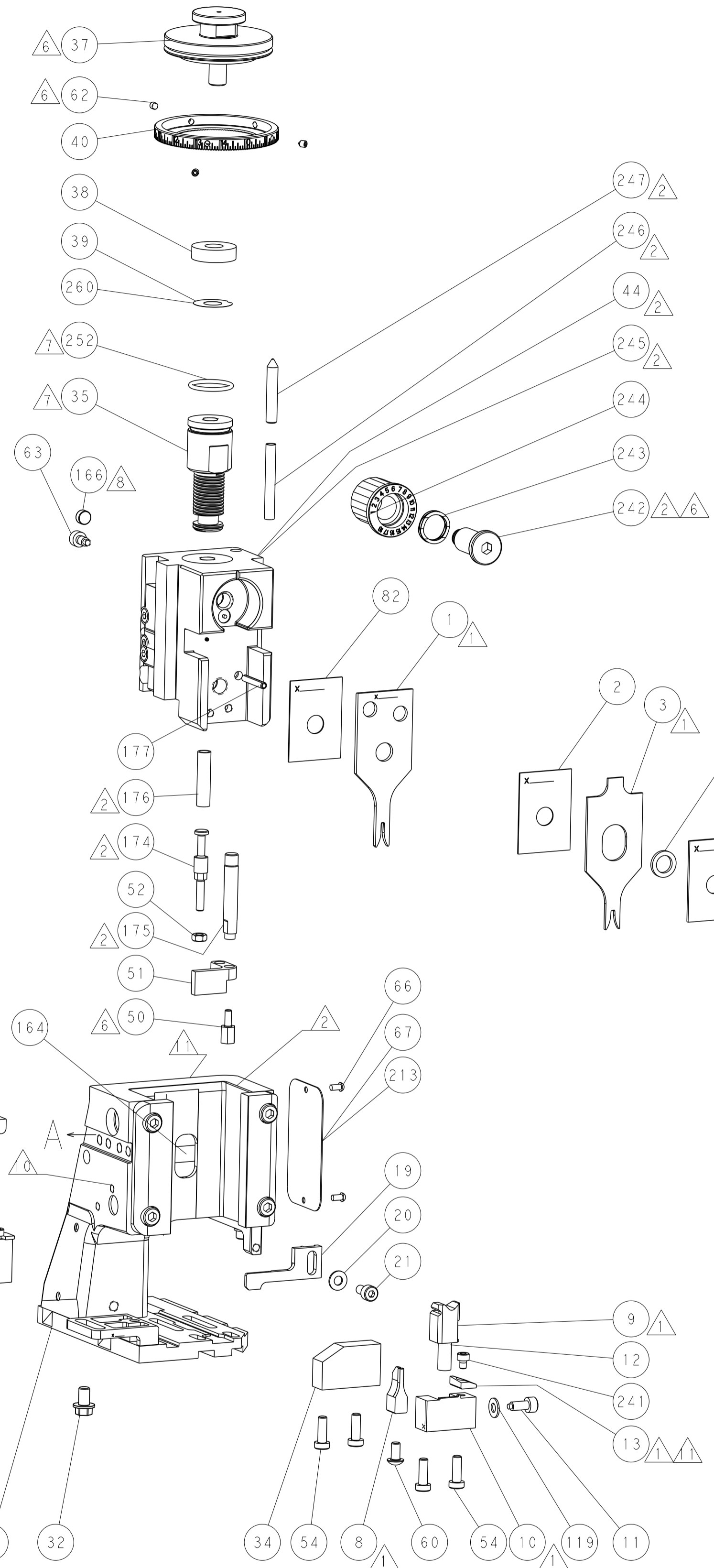
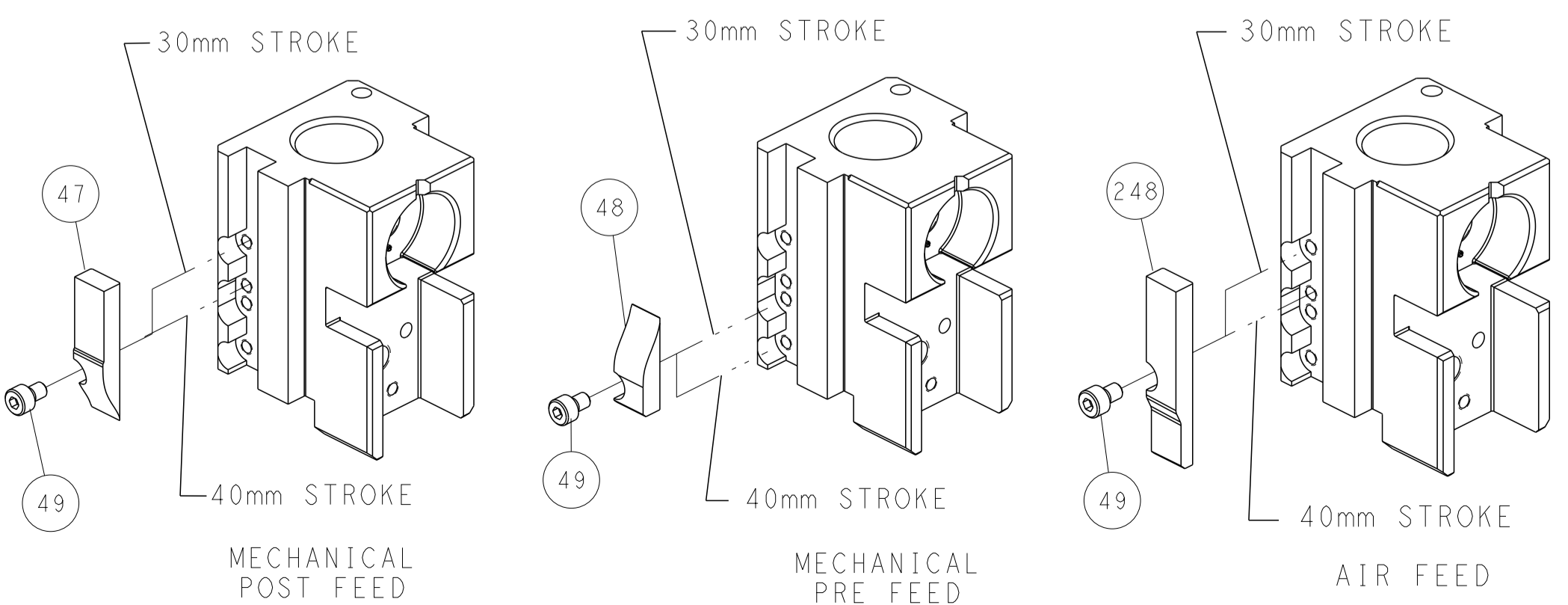
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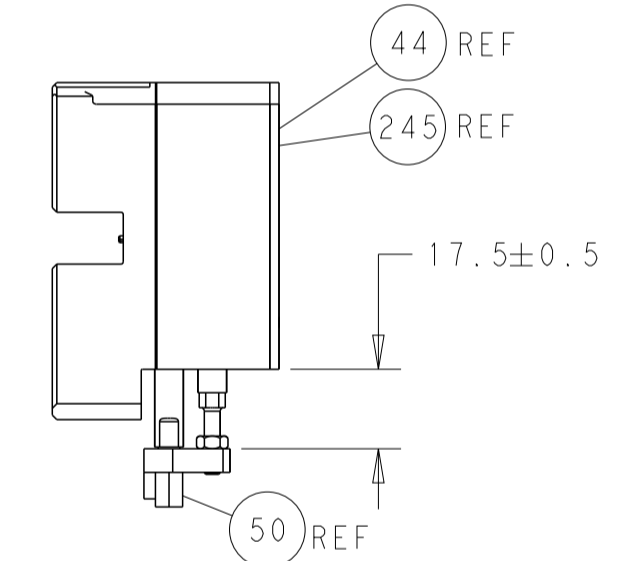
### SERVO LATCH PLATE



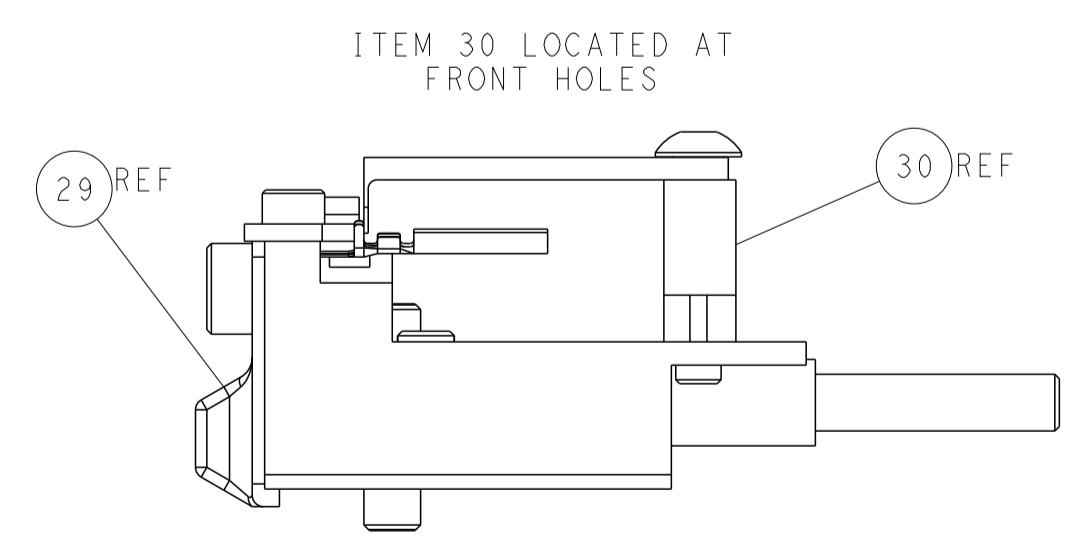
### CAM POSITIONS



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: H. HUANG 09NOV2011 CHK: S. XI 09NOV2011 APVD: J. CRUZ 09NOV2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151017	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: C	RESTRICTED TO: - Customer Accessible Production Drawing		

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
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					SERVO LATCH PLATE	2119951-1	-	8-2151017-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151017-4	-	-	
	2-2151017-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151017-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151017-4	-	-	
	2-2151017-5	C	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
	2-2151017-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151017-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

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CRIMP SIZE	TYPE	
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(A) 1-170361-3	-	-	-

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(B) 1-770901-0	(B) 770901-1	(B) 770901-2	(B) 770901-3
(C) 1-794218-0	(C) 794218-1	(C) 794218-2	(C) 794218-3
(B) 770902-4	(B) 770902-1	(B) 770902-2	(B) 770902-3
(B) 1-770902-1	(B) 770902-5	(B) 770902-6	(B) 1-770902-0
(C) 1-794219-0	(C) 794219-1	(C) 794219-2	(C) 794219-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.34mm2	0.78+/-0.05 [.031+/-0.002]	8.2
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- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
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 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151017-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151017-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151017-5
- 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 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

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-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO
-	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

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

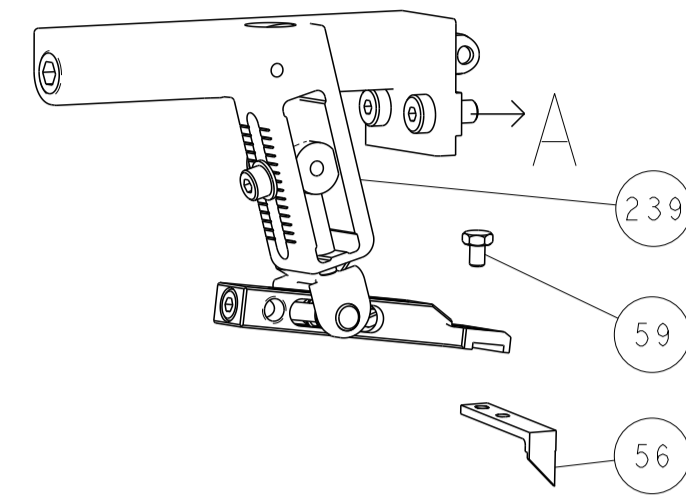
SET UP GAUGE	LOC	DIST	REVISIONS					
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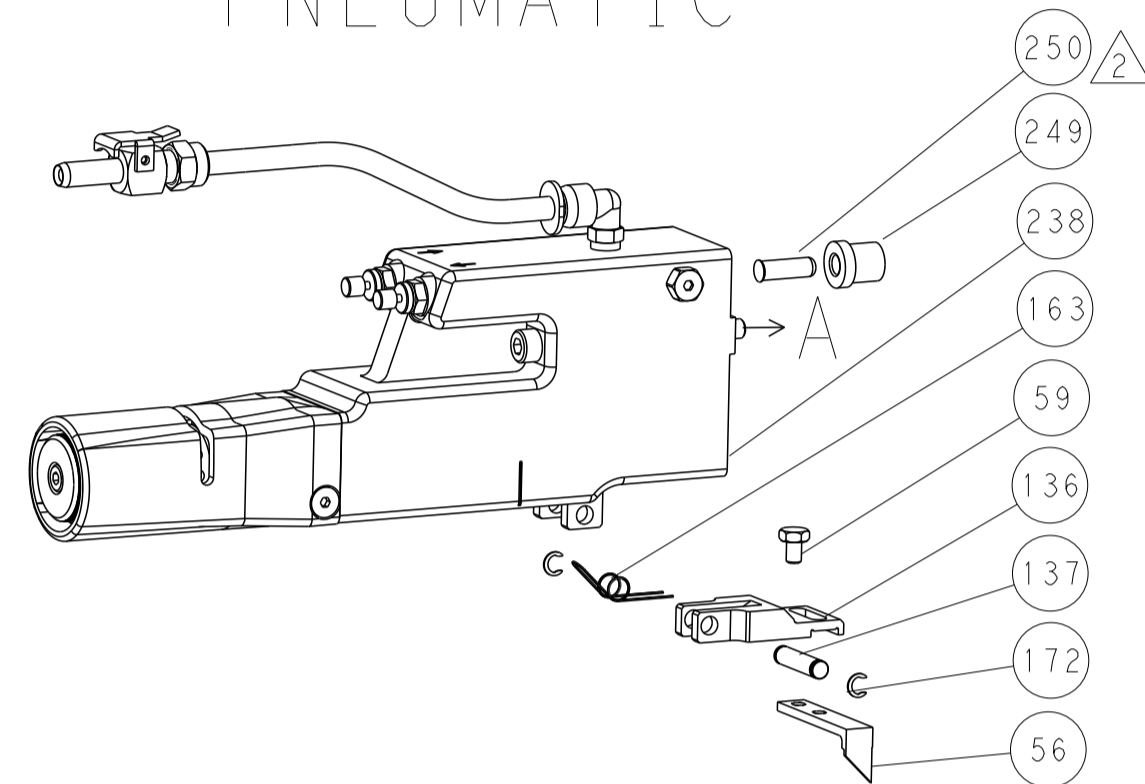
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	-	-	1:2	SHEET 3 OF 4
Customer Accessible Production Drawing		SCALE 1:2		SHEET 3 OF 4		REV C		ITEM NO		REV	

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

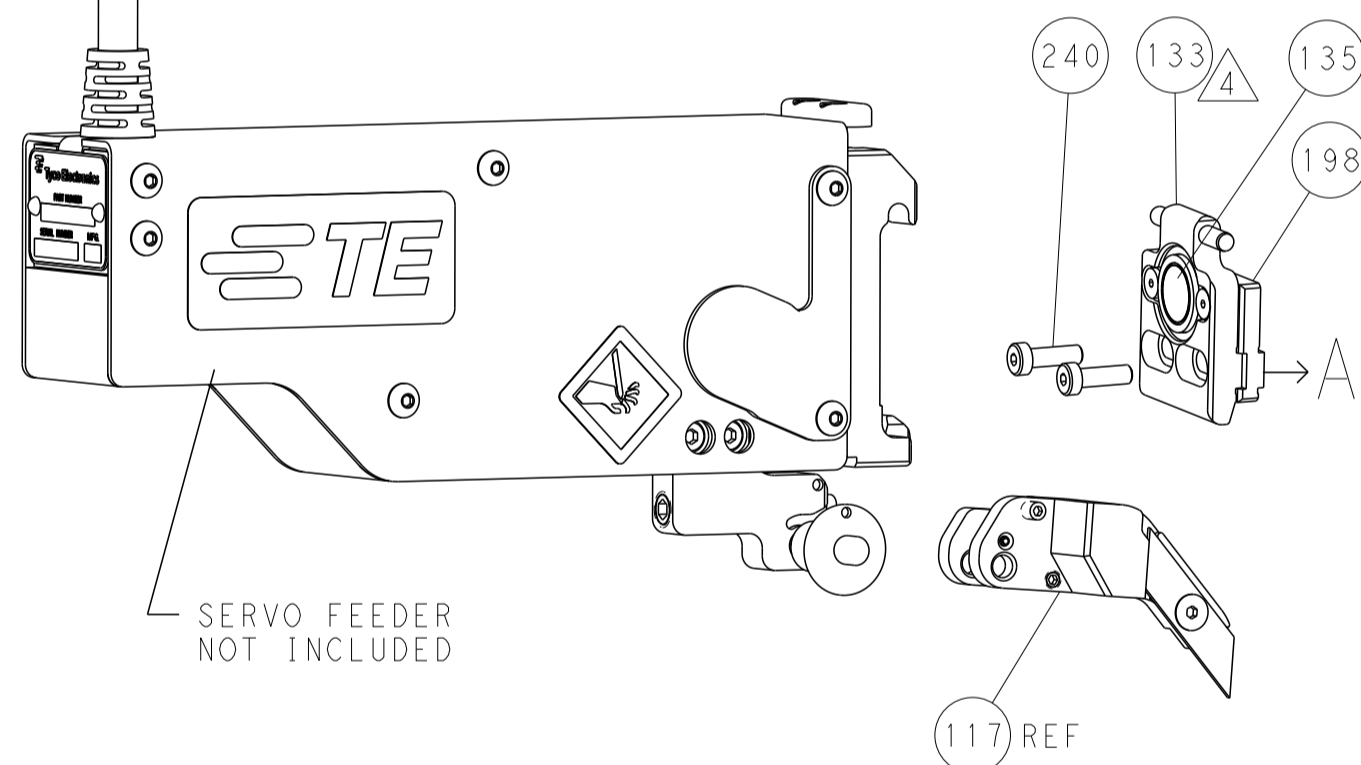
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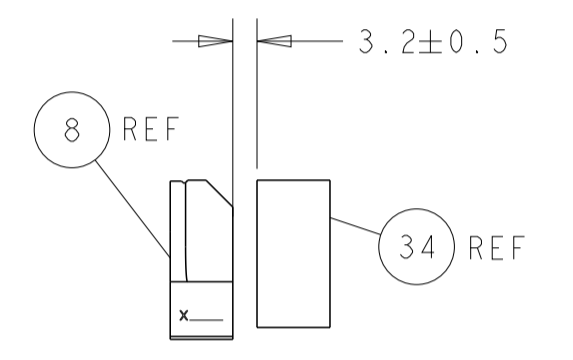
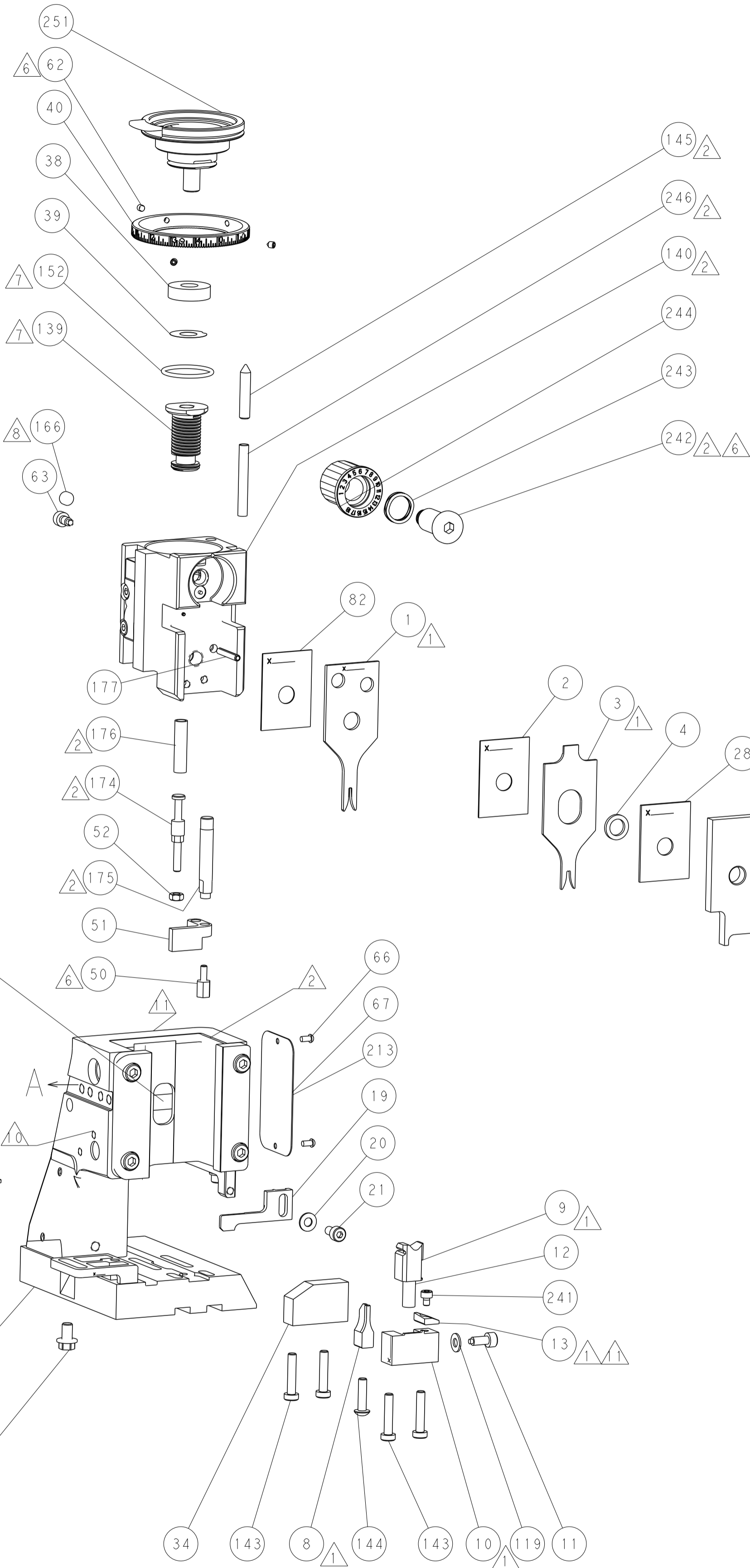
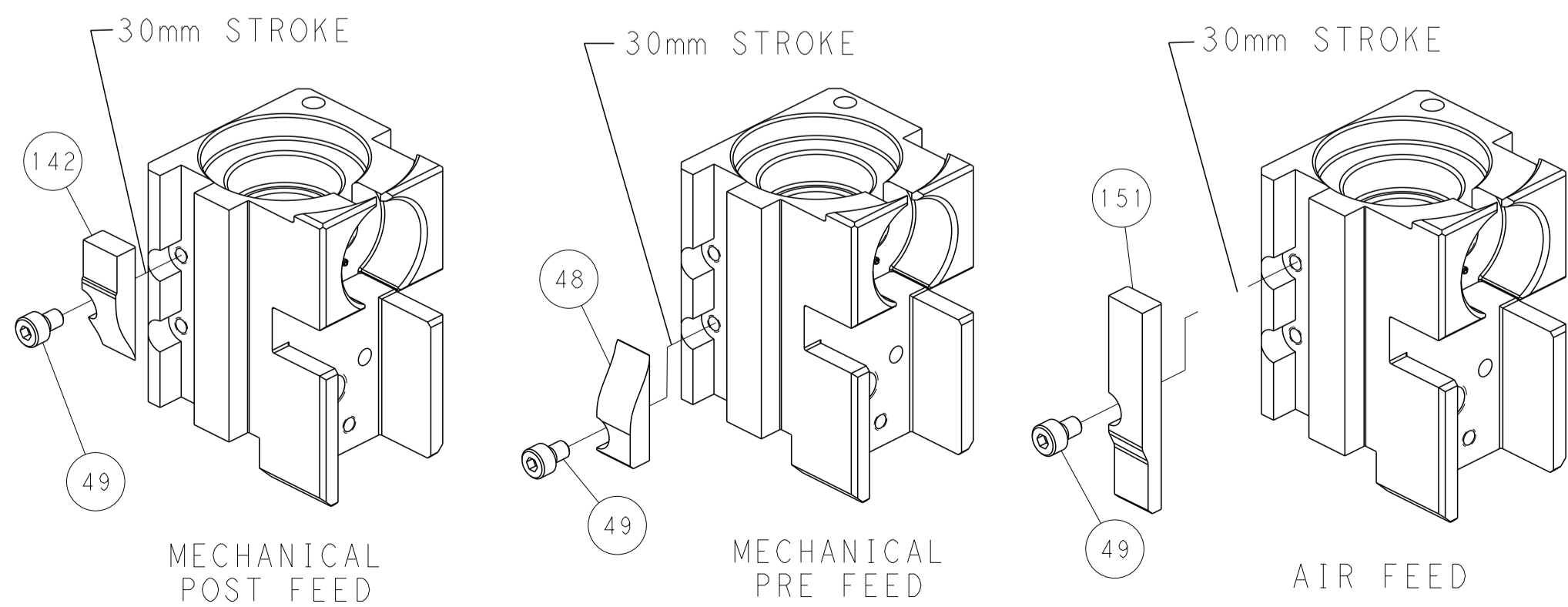
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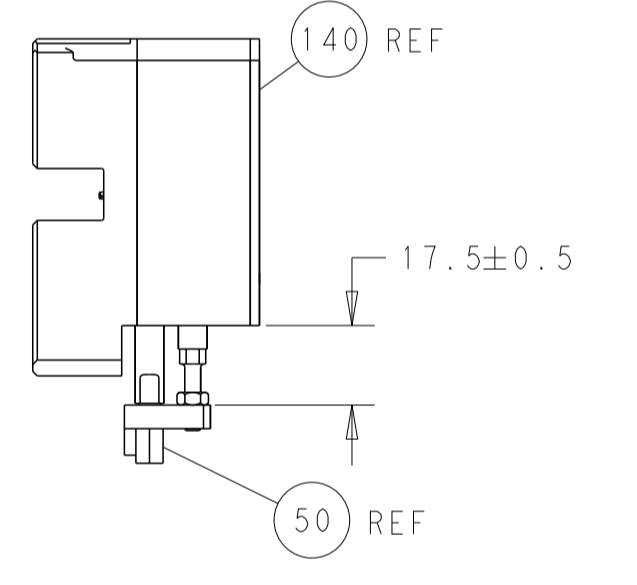
# SERVO LATCH PLATE



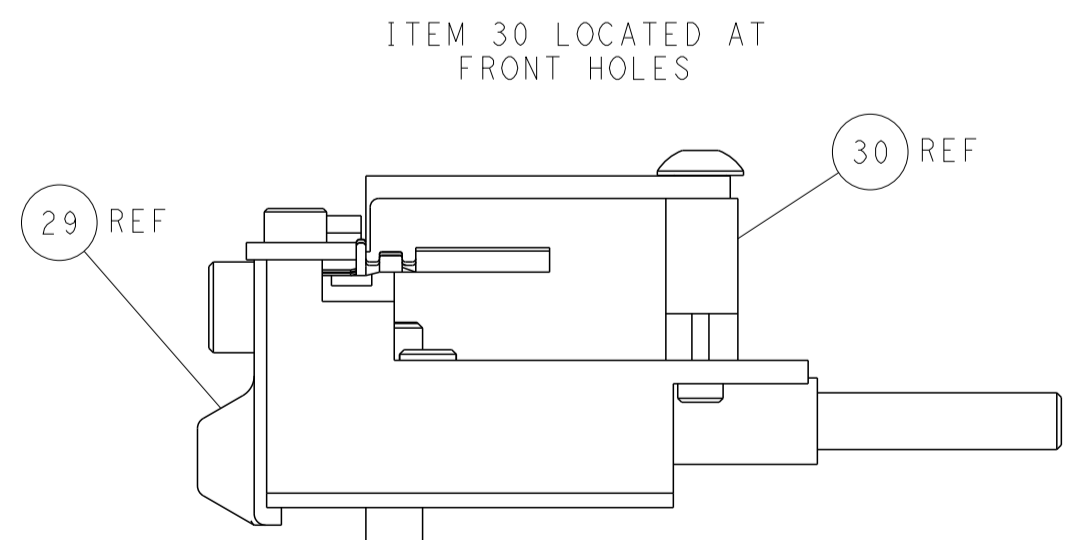
# CAM POSITIONS



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: H. HUANG 09NOV2011		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD: J. CRUZ 09NOV2011		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET: 4 OF 4		REV: C	