

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2151015-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151015-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151015-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151015-4	-	-	
	2151015-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151015-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2151015-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SMART APPLICATOR	2161326-1	-	8-2151015-4	-	-	-
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151015-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
7-2151015-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

CRIMP	SIZE	TYPE
WIRE	1.58 mm [0.062]	F
INSUL	3.17 mm [0.125]	F

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 4.2mm PITCH MINI-FIT TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [0.118-.138 IN]		Ø2.50-2.95 mm [0.098-.116 IN]	
TERMINAL APPLICATION SPECIFICATION	MOLEX 63900-2600 REV J		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
286603-1	39-00-0038	286611-1	39-00-0040
286603-2	39-00-0055	286611-2	39-00-0061
286603-3	39-00-0207	286611-3	39-00-0053
286603-4	39-00-0163	286611-4	39-00-0120
286603-5	39-00-0059	286611-5	39-00-0126
286603-6	39-00-0153	286611-6	39-00-0219
286603-7	39-00-0181	286611-8	39-00-0411
286603-8	39-00-0213	286611-9	39-00-0430
1-286603-0	44485-1211	1-286611-1	39-00-0121
1-286603-1	39-00-0114	1-286611-2	39-00-0420
1-286603-2	39-00-0428	1-286611-3	39-00-0437
1-286603-3	39-00-0419	1-286611-4	39-00-0426
1-286603-4	39-00-0425	1-286611-6	39-00-0075
1-286603-5	39-00-0436	1-286611-7	39-00-0427
1-286603-6	39-00-0440	1-286611-8	40-13-0853
1-286603-7	39-00-0073	2-286611-0	30490-1002
1-286603-8	39-00-0108	2-286611-1	30490-2002
1-286603-9	39-00-0169	2-286611-2	40-01-0853
2-286603-0	39-00-0175	2-286611-3	98-00-0174
2-286603-1	39-00-0194	2-286611-4	30490-0002
2-286603-2	39-00-0200		
2-286603-3	39-00-0405		
2-286603-4	39-00-0407		
2-286603-5	39-00-0410		
2-286603-6	40-13-0851		
2-286603-8	44485-1311		
2-286603-9	44485-1411		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.80mm2	1.02+/-0.05 [0.040+/-0.002]	5.9
18 AWG	1.02+/-0.05 [0.040+/-0.002]	5.9
0.50mm2	0.995+/-0.045 [0.039+/-0.0018]	6.2
20 AWG	0.995+/-0.045 [0.039+/-0.0018]	6.2
0.35mm2	0.895+/-0.045 [0.035+/-0.0018]	7.1
22 AWG	0.895+/-0.045 [0.035+/-0.0018]	7.1
0.20mm2	0.83+/-0.04 [0.033+/-0.0016]	7.7
24 AWG	0.83+/-0.04 [0.033+/-0.0016]	7.7

- 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: 8-2151015-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151015-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151015-5
 - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151015-6

TERMINAL DATA: MOLEX TERMINAL		CMOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 4.2mm PITCH MINI-FIT TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [0.118-.138 IN]		Ø2.50-2.95 mm [0.098-.116 IN]	
TERMINAL APPLICATION SPECIFICATION	MOLEX 63900-2600 REV J		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
286603-9	44476-1111	1-2113022-1	46083-1211
2-286603-7	44476-1211	1-2113022-2	46083-1221
286611-7	44478-1111	1-2113022-3	46134-1111
1-286611-9	44478-1211	1-2113022-4	46134-1121
2113022-1	45750-1211	1-2113022-5	46134-1211
2113022-2	45750-1111	1-2113022-6	46134-1221
2113022-3	46012-1111		
2113022-4	46018-1541		
2113022-5	46083-1111		
2113022-6	46098-1541		
2113022-7	46012-1141		
2113022-8	46012-1211		
2113022-9	46012-1241		
1-2113022-0	46083-1121		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.80mm2	1.02+/-0.05 [0.040+/-0.002]	5.9
18 AWG	1.02+/-0.05 [0.040+/-0.002]	5.9
0.50mm2	0.995+/-0.045 [0.039+/-0.0018]	6.2
20 AWG	0.995+/-0.045 [0.039+/-0.0018]	6.2

- 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 50, 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, 50.
- 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

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
						2119957-2	APPLICATOR SHIM PACK	260
						8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252

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 LTR	DESCRIPTION	DATE	OWN	APPD
	A			RELEASED	04NOV2011	LG	GB
	A1			ECR-15-018756	30DEC2015	JH	CT

-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	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	-	-	-	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	455888-9	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	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	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	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	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	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	1	1	1	1	1-1752356-9	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	1320908-6	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	462006-6	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	3-1633129-3	ANVIL, COMBINATION .062	8
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	1-2119582-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	4-456403-2	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
mm	0 PLC ±	1 PLC ±	2 PLC ±
	3 PLC ±	4 PLC ±	5 PLC ±
	6 PLC ±	7 PLC ±	8 PLC ±
	9 PLC ±	10 PLC ±	FINISH

TE Connectivity
Harrisburg, PA 17105-3608

Ocean Side Feed
Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151015
RESTRICTED TO: 1

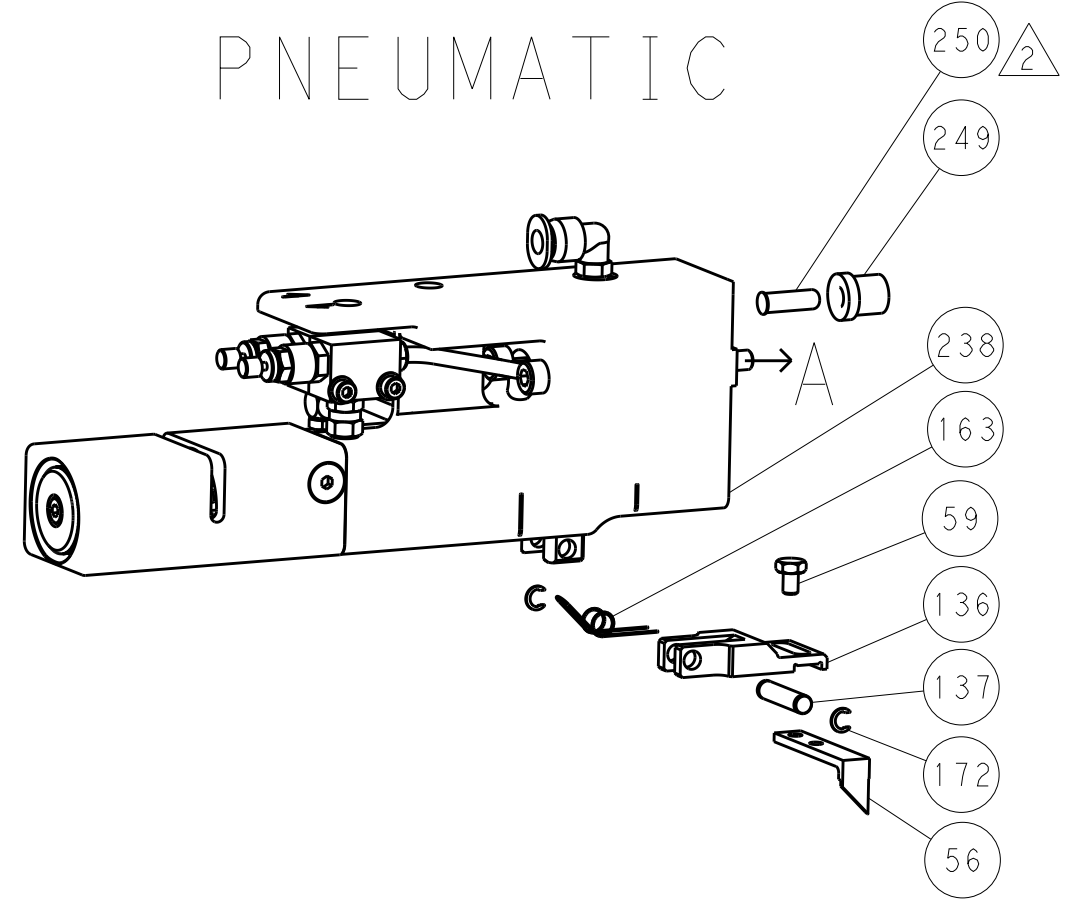
CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:2 SHEET 1 OF 4 REV: A1

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

FEED TYPE MECHANICAL



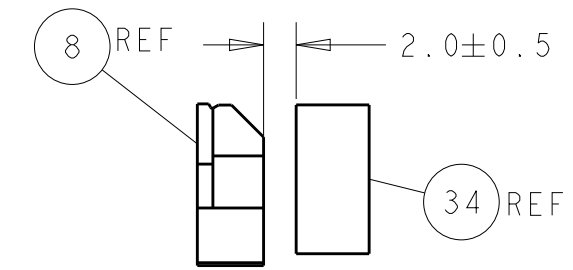
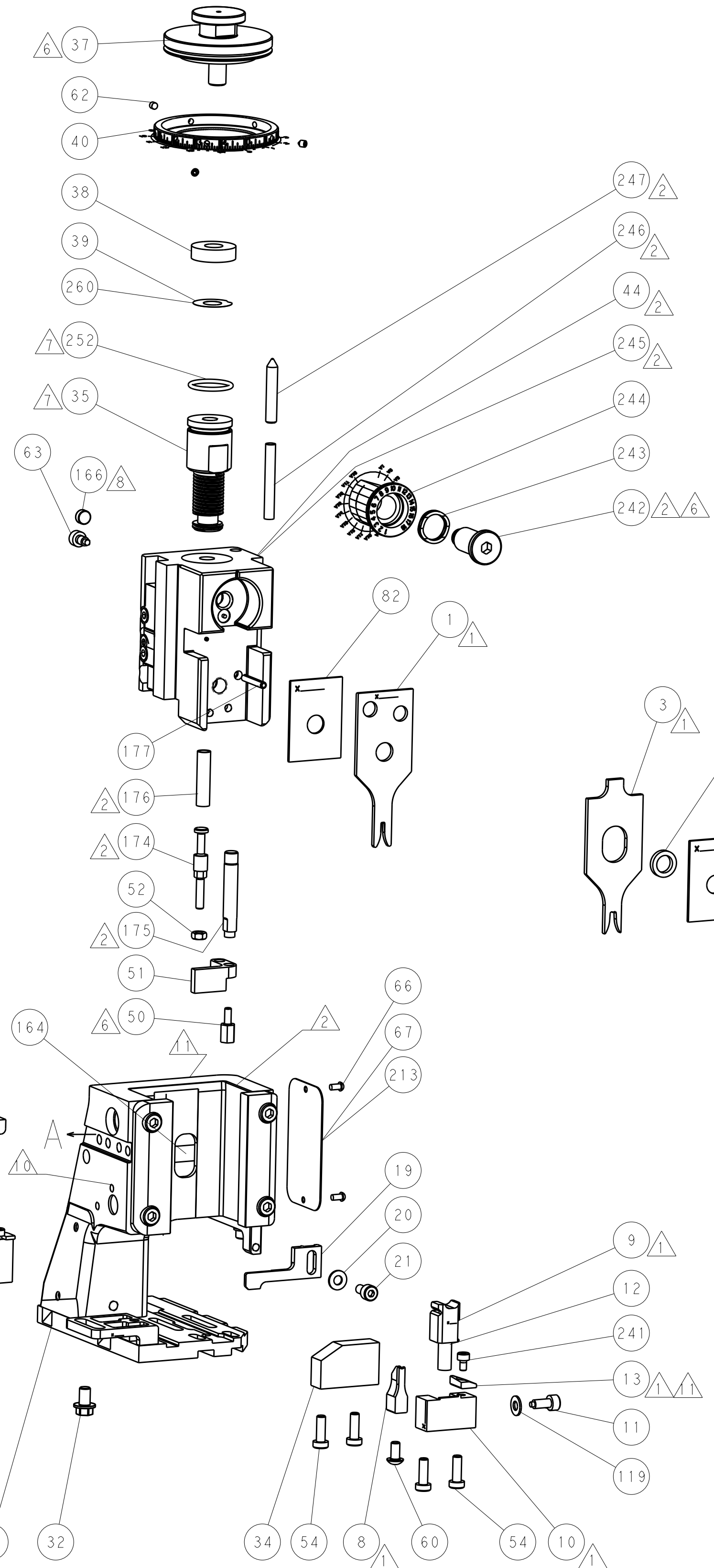
PNEUMATIC



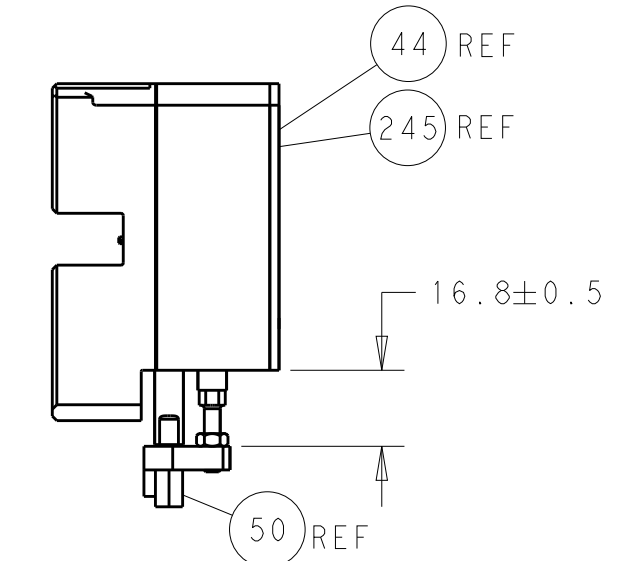
SERVO LATCH PLATE



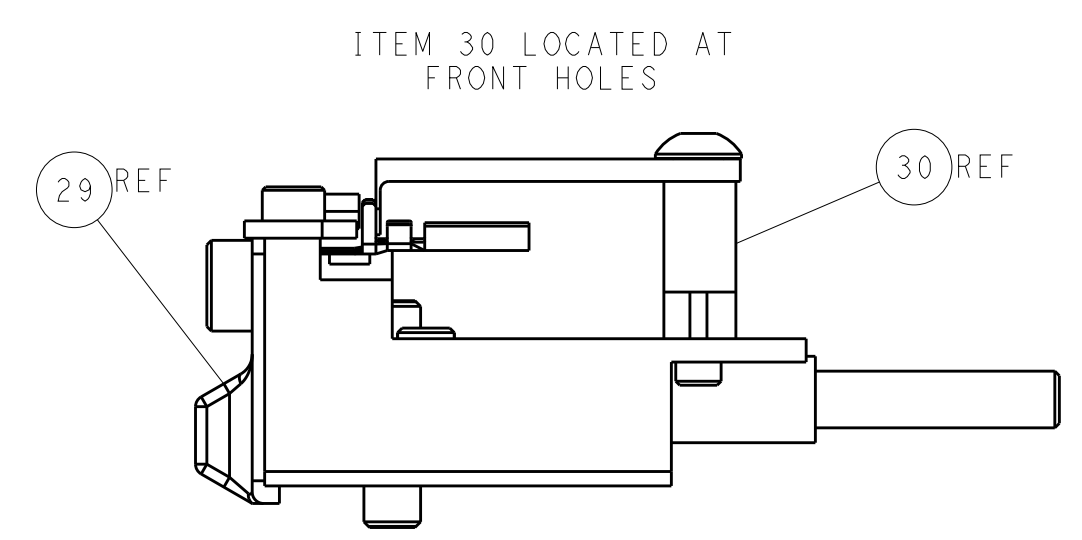
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



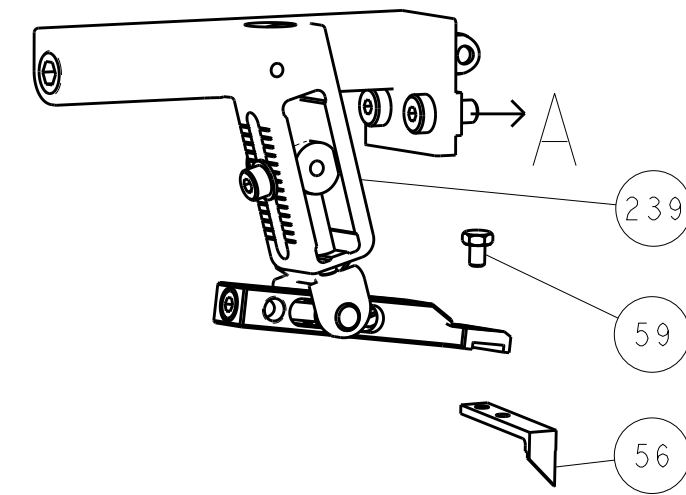
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

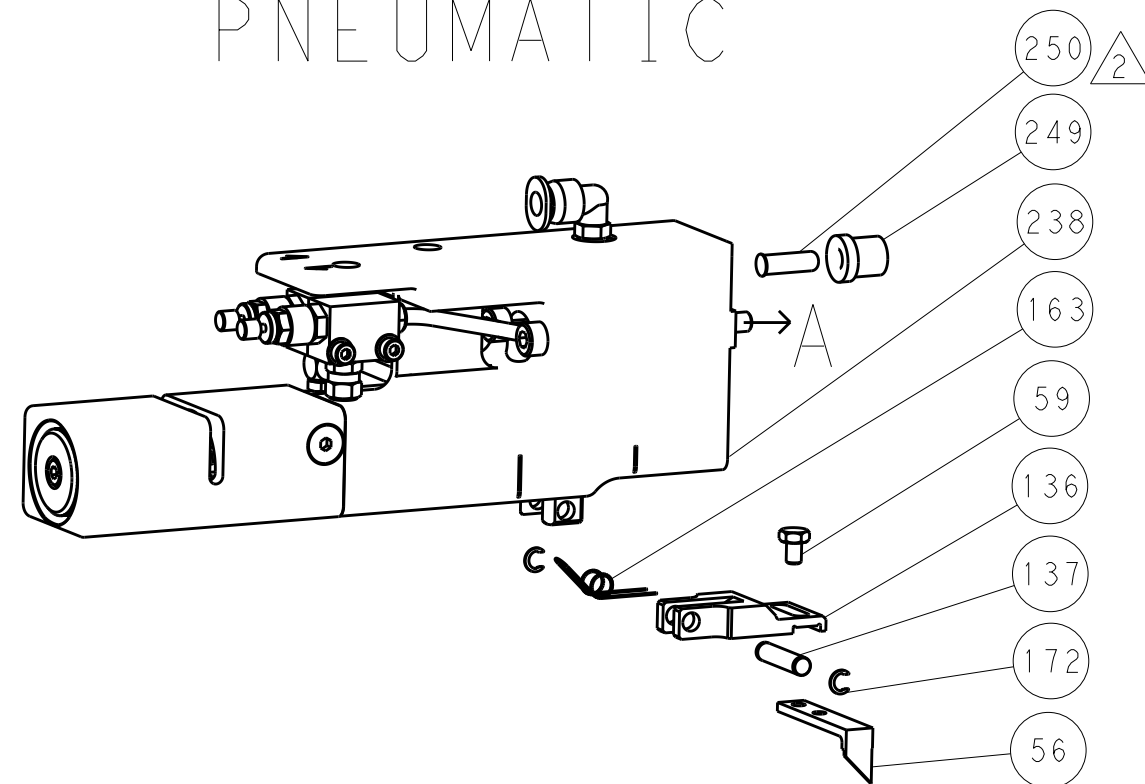
<small>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS TO BE CONTAINED AND CONTROLLED BY THE USER'S ORGANIZATION UNLESS BY CONTRACT FOR THE LATEST VERSION.</small>		DWN: STAKEM 11OCT2011 CHK: G. BAILEY 11OCT2011 APVD: T. ELBIN 11OCT2011	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151015	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: A
MATERIAL: - FINISH: -		WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

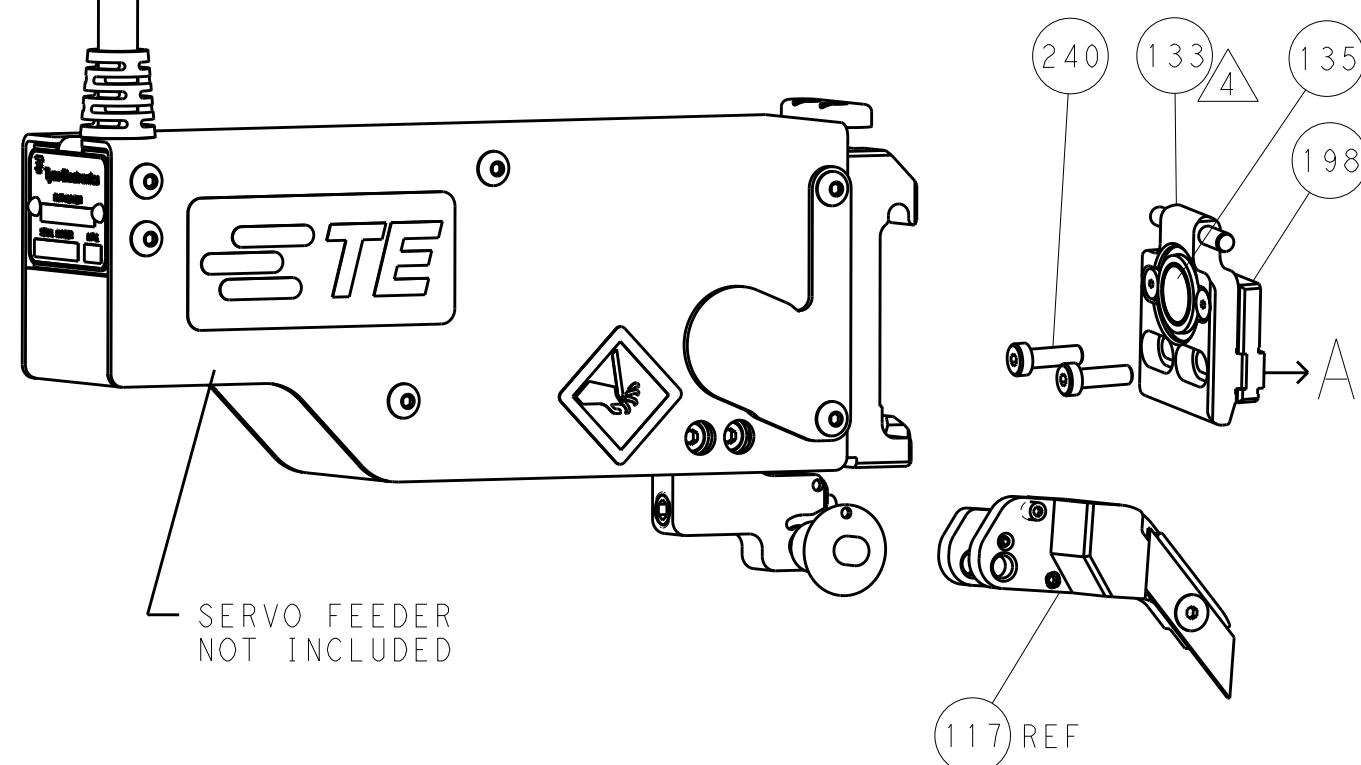
FEED TYPE MECHANICAL



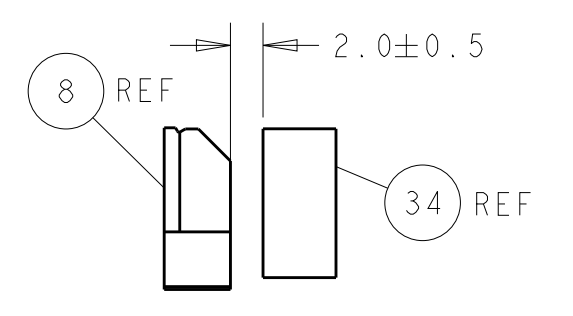
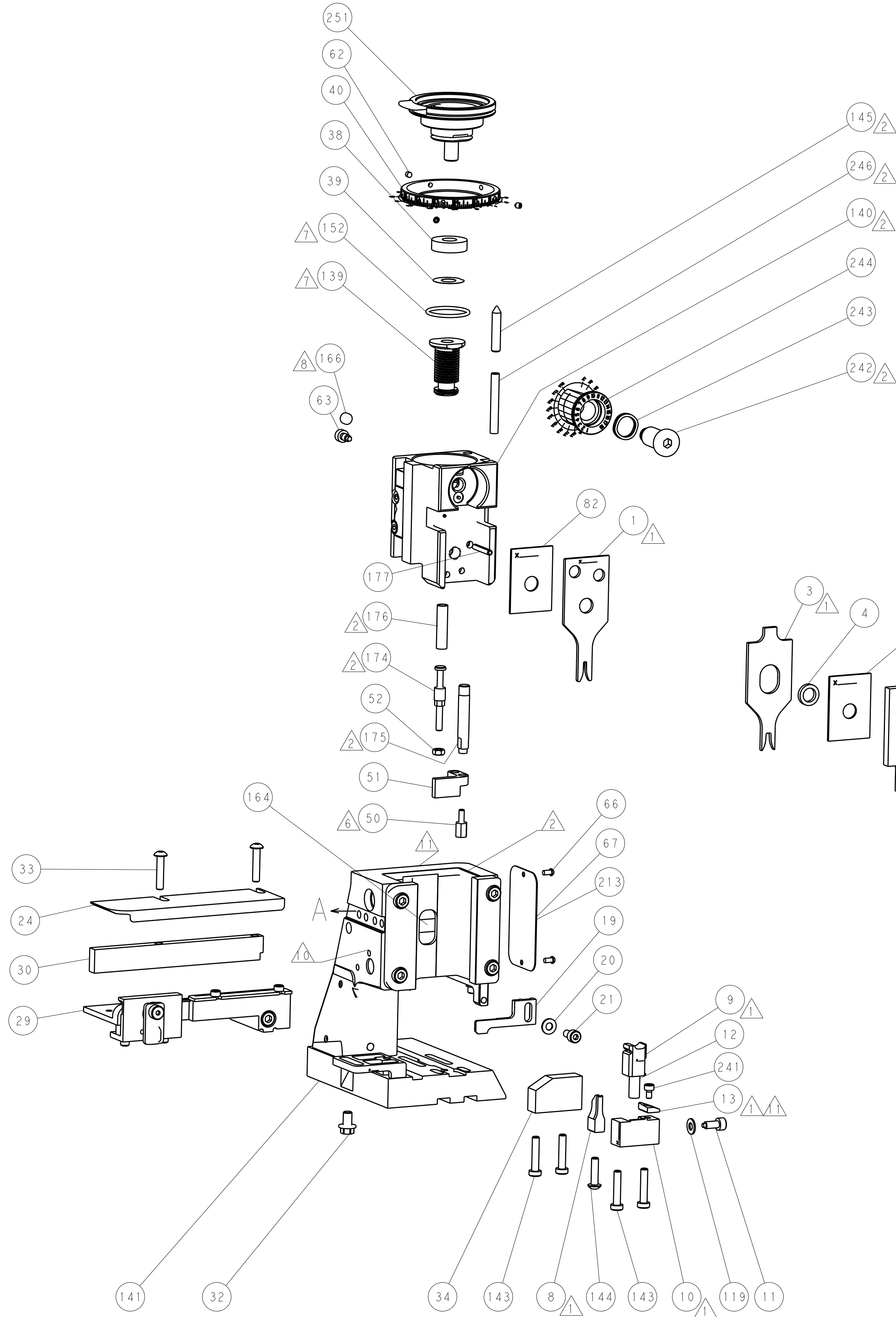
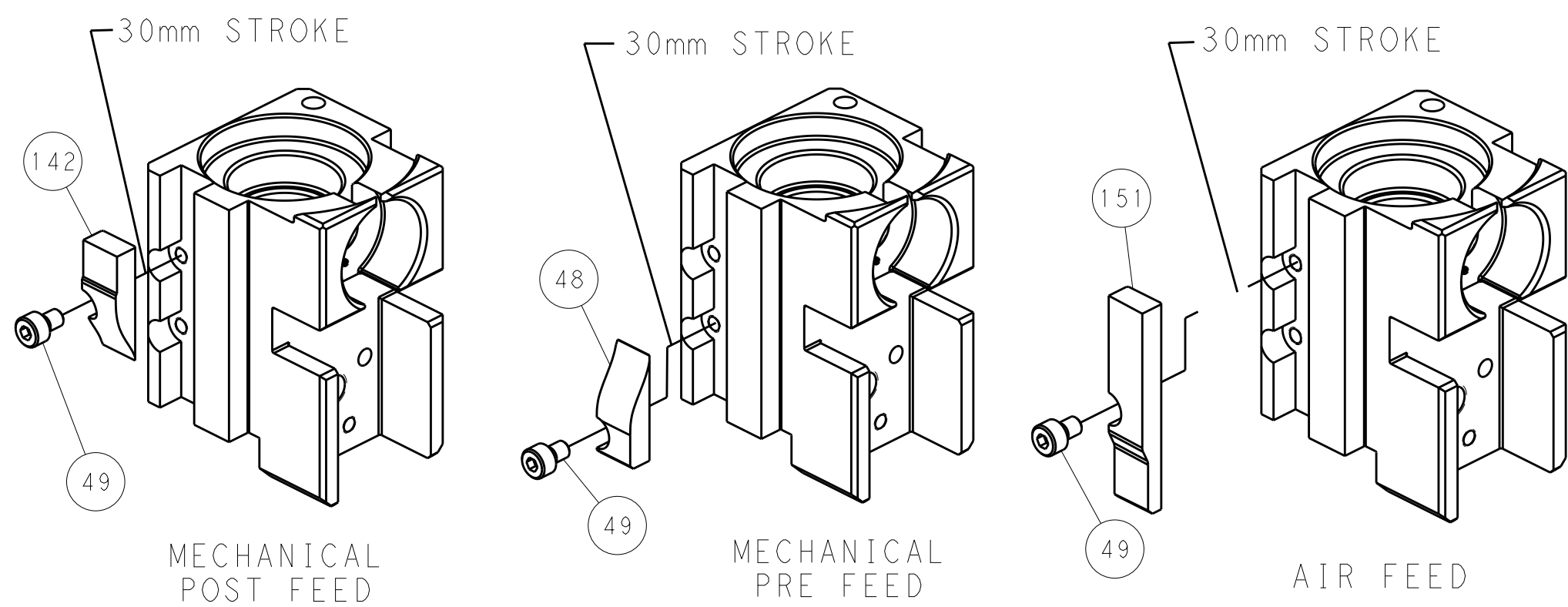
PNEUMATIC



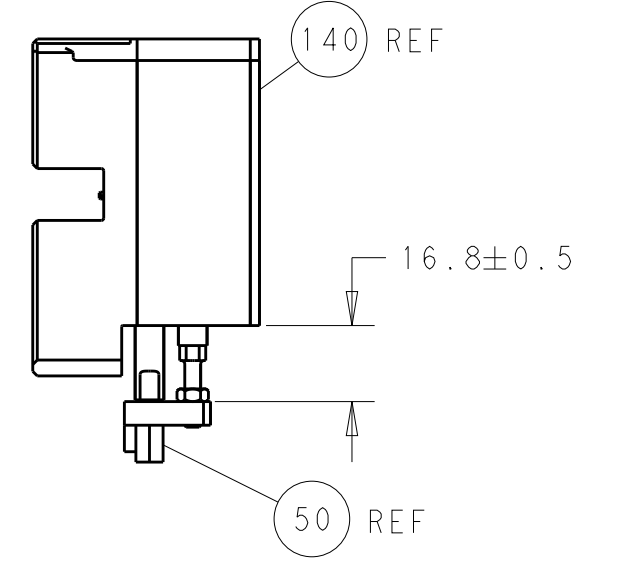
SERVO LATCH PLATE



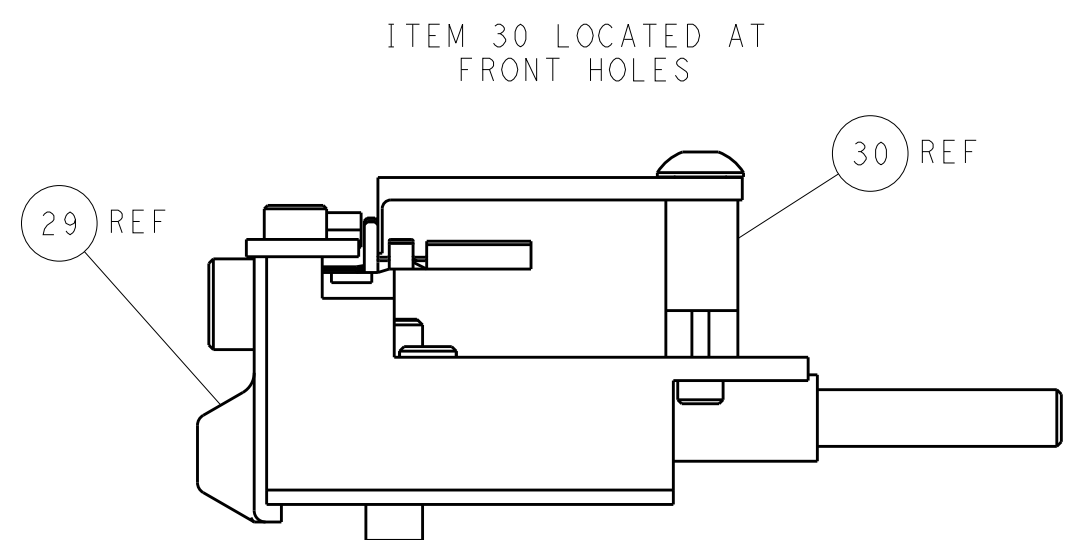
CAM POSITIONS



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: R. STAKEM 11OCT2011		CHK: G. BAILEY 11OCT2011		APVD: T. ERLIN 11OCT2011		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2151015	RESTRICTED TO: -
MATERIAL:								WEIGHT:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2
								SHEET 4 OF 4		REV A	