

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2151744-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151744-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151744-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151744-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2151744-5	F	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151744-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151744-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151744-6	F	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
2151744-7	F	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151744-7	E	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 1.40 mm [.055]	F	
INSUL 2.79 mm [.110]	F	

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: REC/TAB CONTACT NEXT GENERATION SOFT SHELL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.20-4.80 mm [1.65-.189 IN]	Ø1.14-2.70 mm [0.045-.106 IN]		
TERMINAL APPLICATION SPECIFICATION	114-106118		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1971785-1	1971785-2	1971786-1	1971786-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.56mm2	1.05+/-0.03 [0.041+/-0.001]	7.8
22 AWG OR 0.34mm2	0.98+/-0.03 [0.039+/-0.001]	8.2

- 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: 8-2151744-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151744-5  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151744-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151744-6
- 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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	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
-	1	-	1	1	1	2119798-1	DETENT PIN	247

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

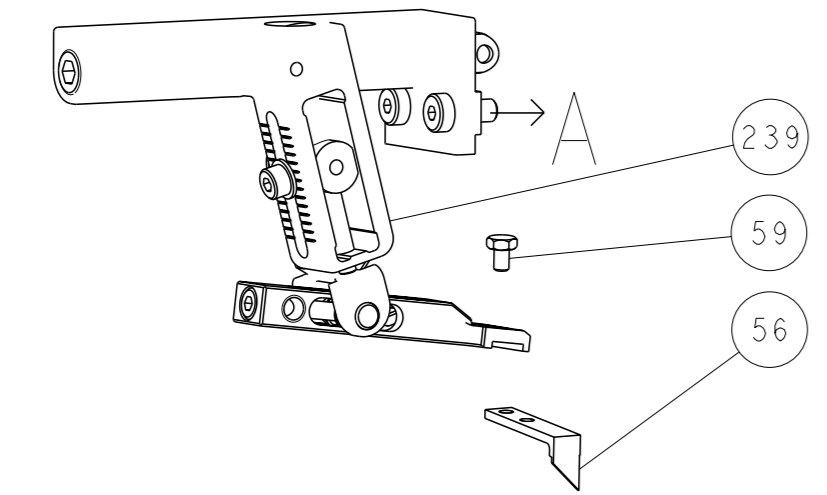
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E	21SEP2016	MZ	TE		ECR-16-013390
E1	27OCT2016	MZ	JDG		ECR-16-015239
F	07APR2017	BW	TE		ECR-17-005120

REV	DATE	BY	CHK	APPV	DESCRIPTION	ITEM NO	
-	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	2119082-8 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
-	-	-	-	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	455888-6 SPACER, CRIMPER	82
-	1	1	1	1	1	22278-8 SPRING, COMPRESSION	77
-	1	1	1	1	1	854769-4 HOLDER, INS	74
-	1	1	1	1	1	2119956-1 DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-9 DEPRESSOR, WIRE	70
-	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	1	1	1	21028-2 PIN, SLOTTED SPRING .062 X .250	58
-	-	-	-	1	1	1338685-1 PAWL, FEED	56
-	4	4	4	4	4	2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	5018030-1 NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5 BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2 SPACER, TONKER	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	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	1-1320908-0 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	1-1803079-0 ANVIL, WITH STABILIZER	8
-	1	1	1	1	1	4-240641-2 SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119780-9 DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-2 BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	8-1803187-7 CRIMPER, INSULATION F	3
-	1	1	1	1	1	455888-1 SPACER, CRIMPER	2
-	1	1	1	1	1	1-456402-4 CRIMPER, WIRE PREMIUM	1

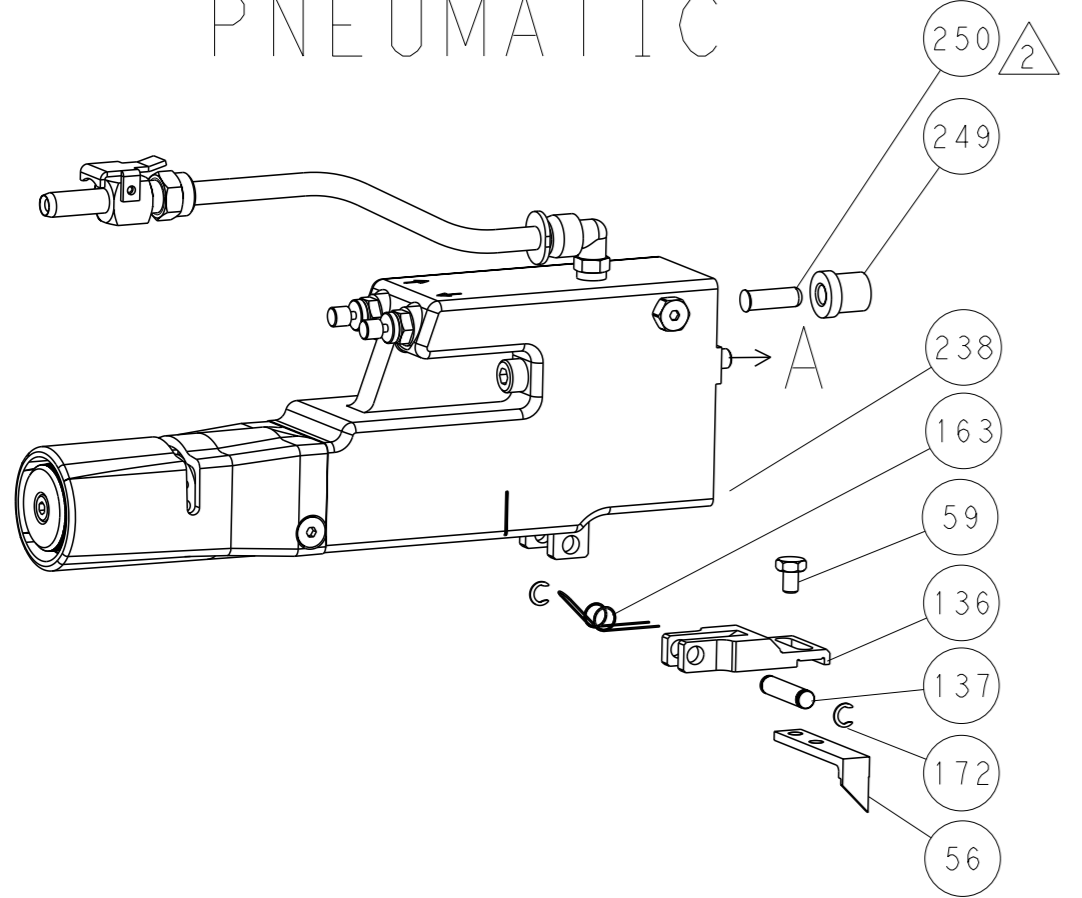
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	DWG: H. HUANG CHK: S. XI S. XI DATE: 31AUG2012 DATE: 31AUG2012 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151744 RESTRICTED TO: - SCALE: 1:2 SHEET: 1 of 4 REV: F
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LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

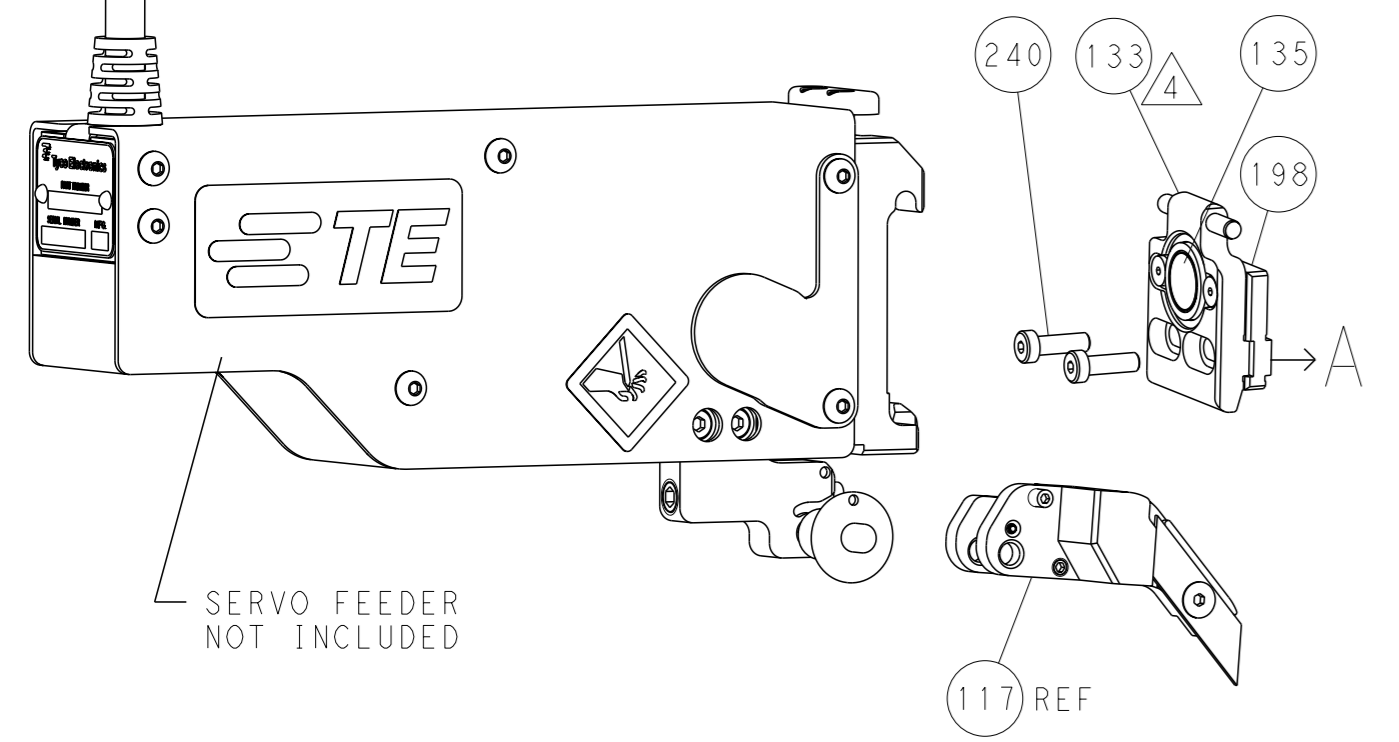
### FEED TYPE MECHANICAL



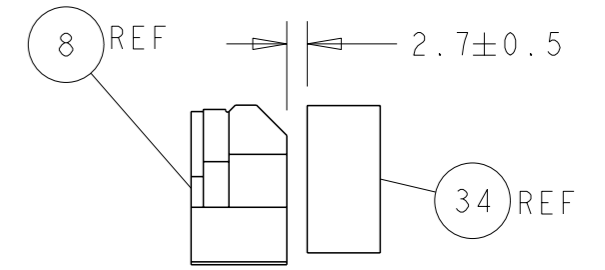
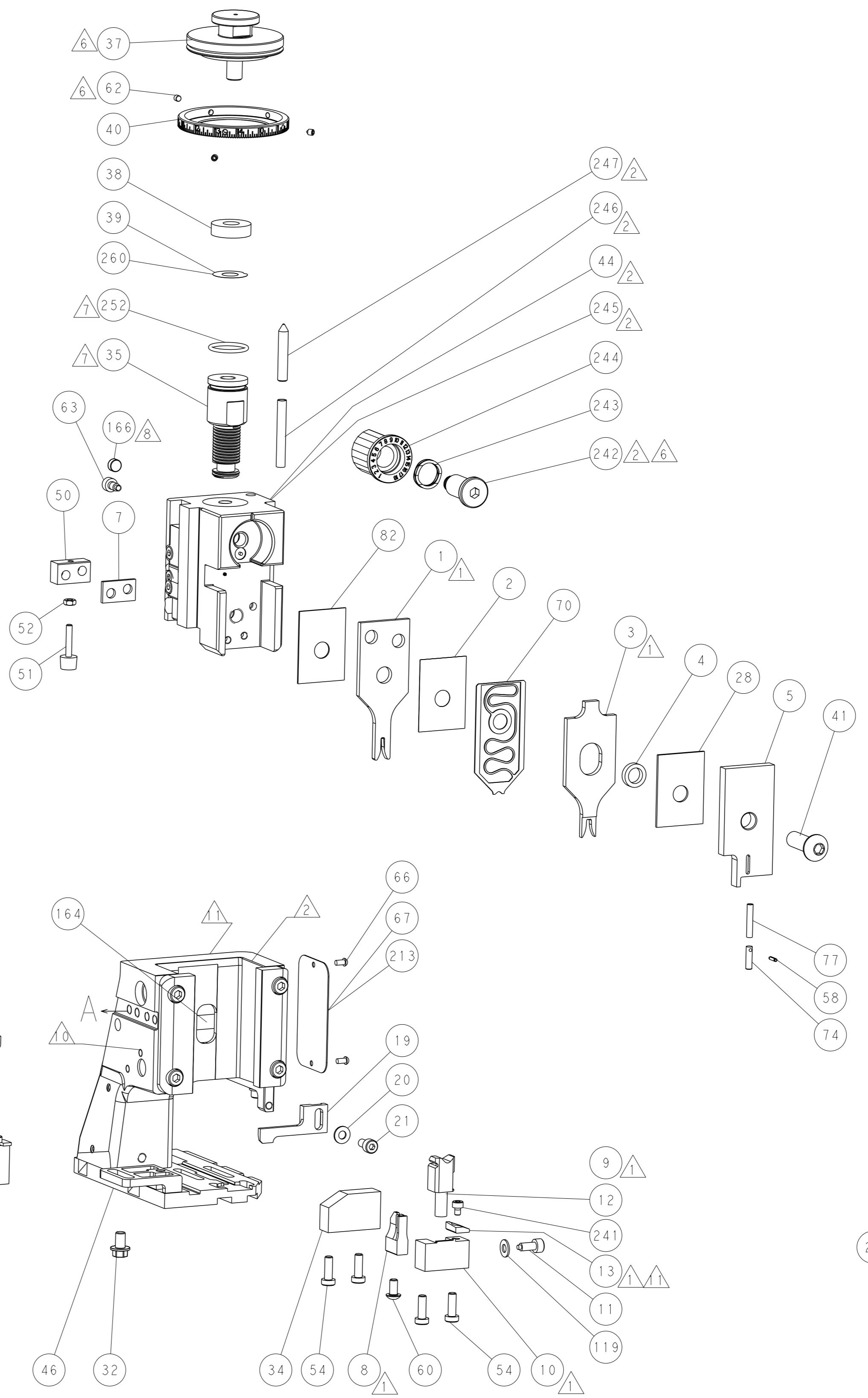
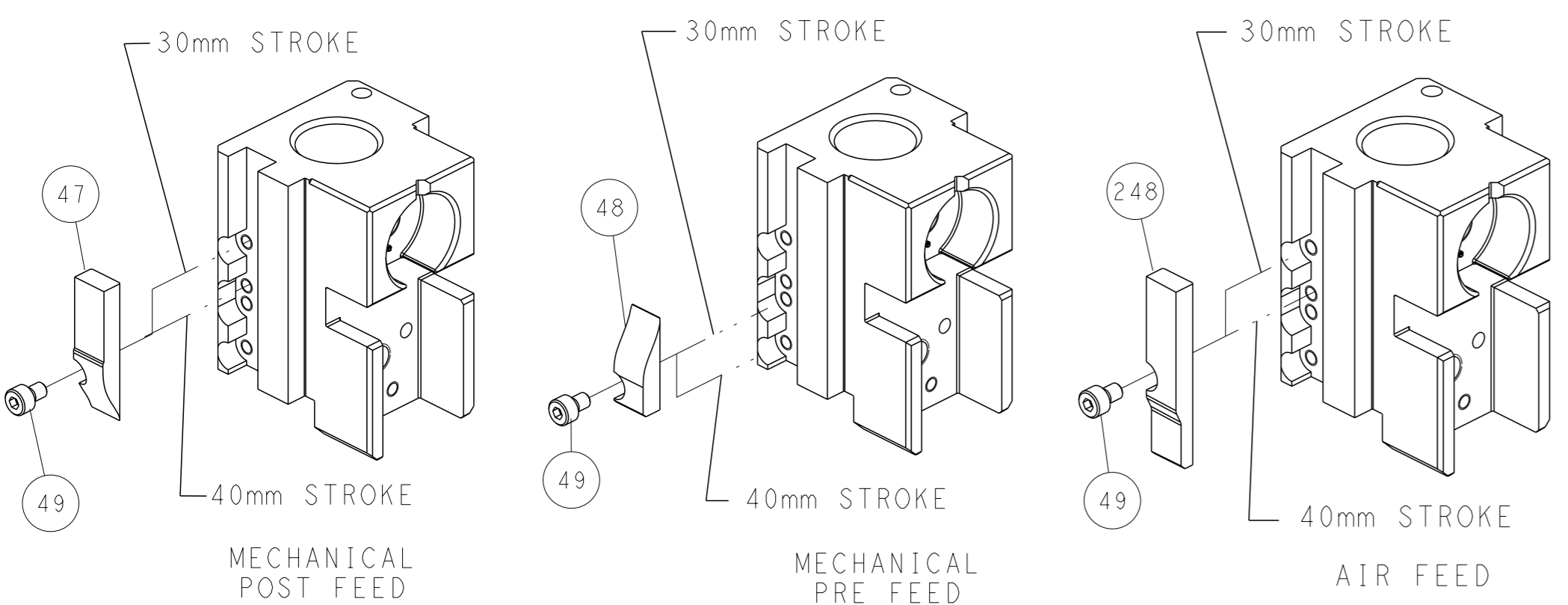
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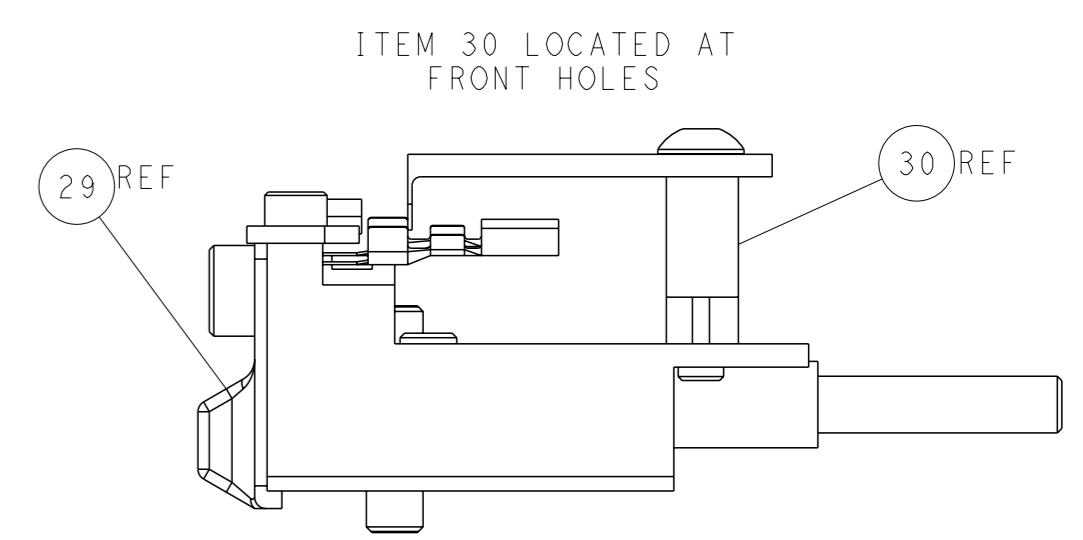
### SERVO LATCH PLATE



### CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

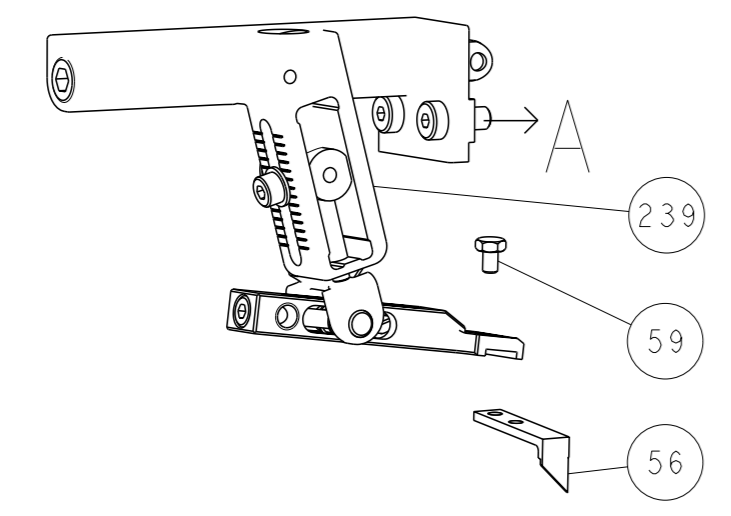
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: H. HUANG CHK: S. XI APVD: S. XI DATE: 31AUG2012	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151744 SCALE: 1:2	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ±	MATERIAL:	WEIGHT:	RESTRICTED TO:	SHEET 2 OF 4 REV F

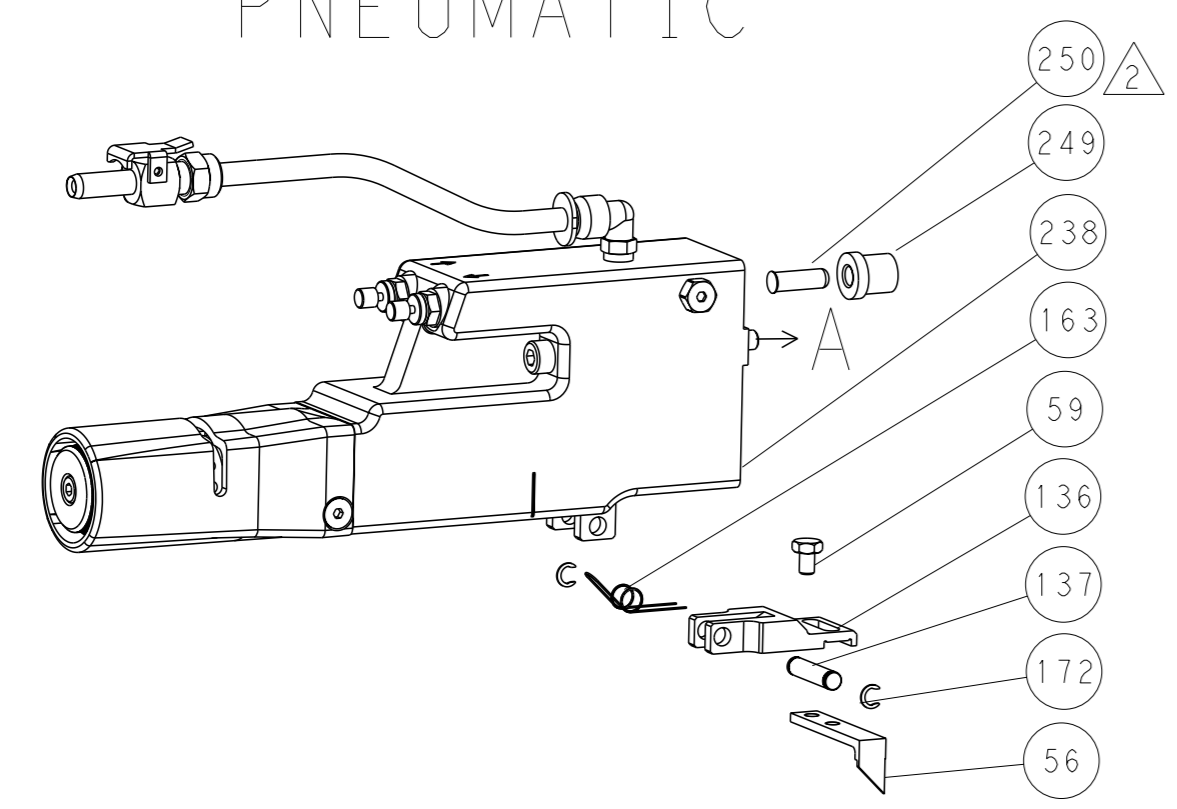


LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

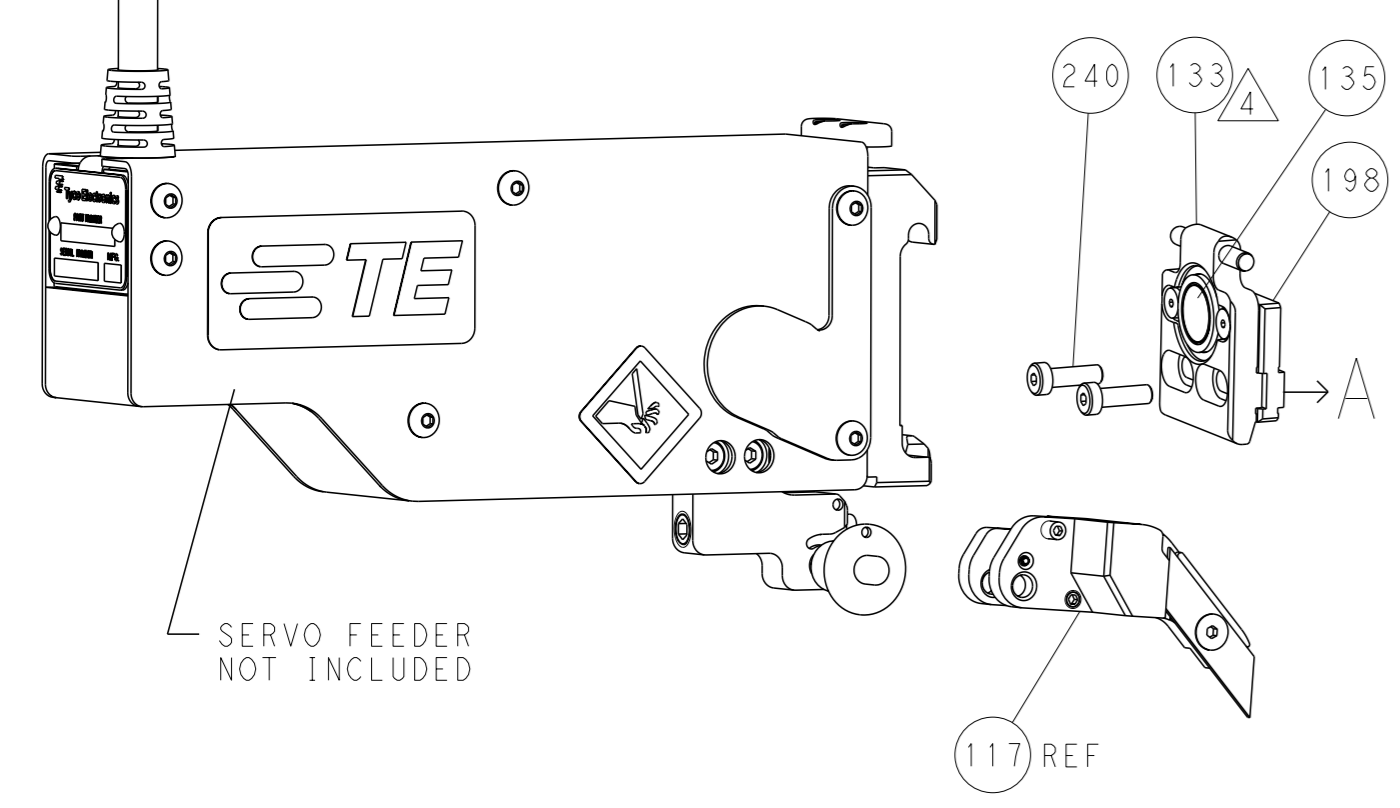
# FEED TYPE MECHANICAL



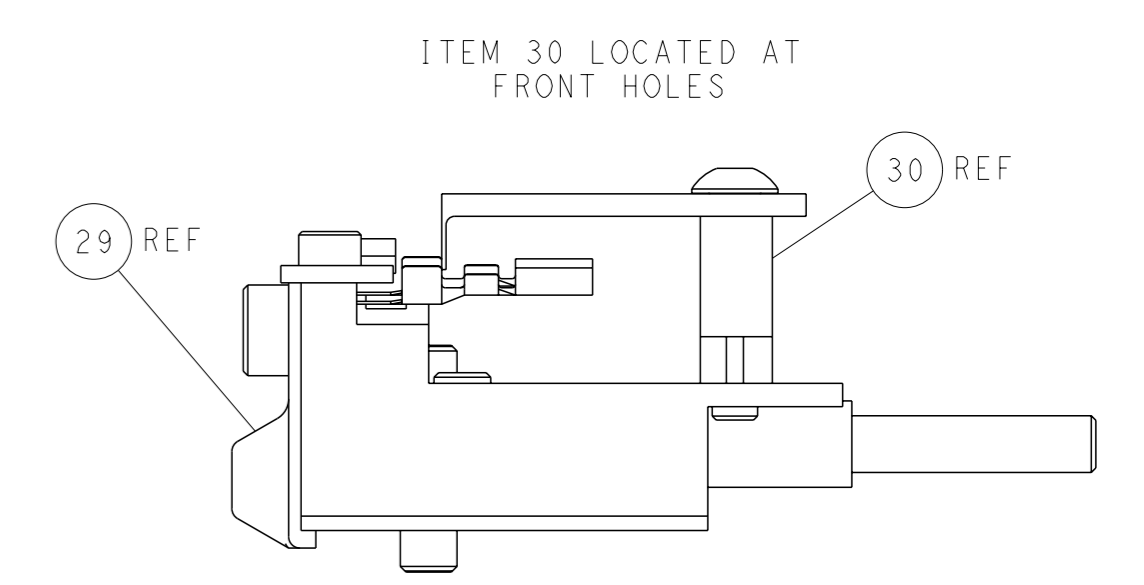
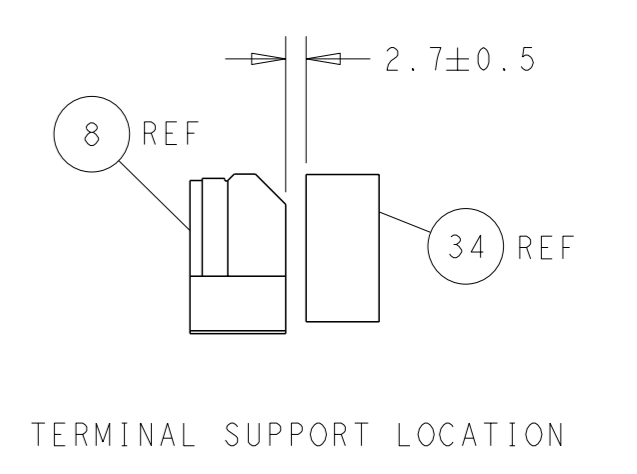
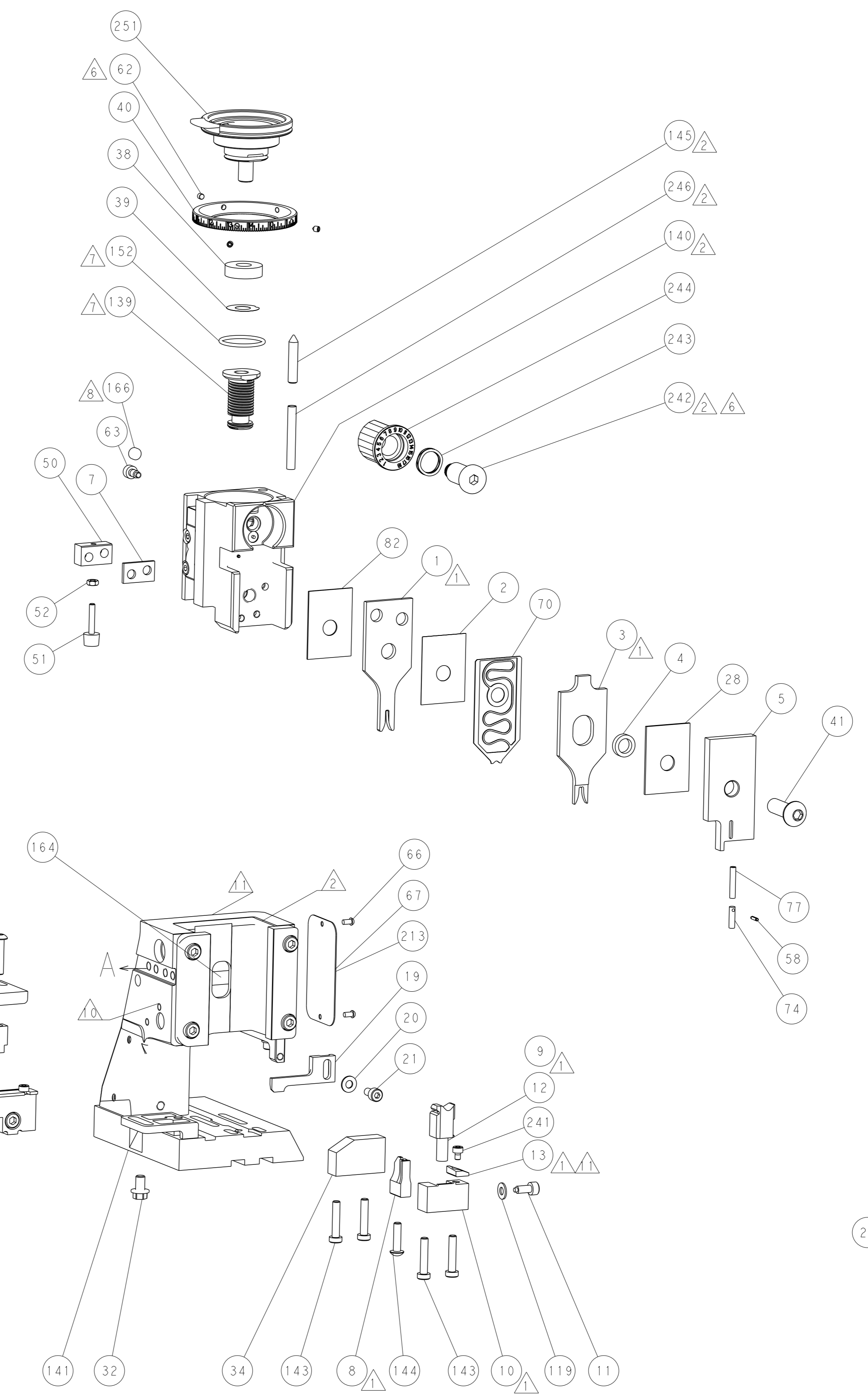
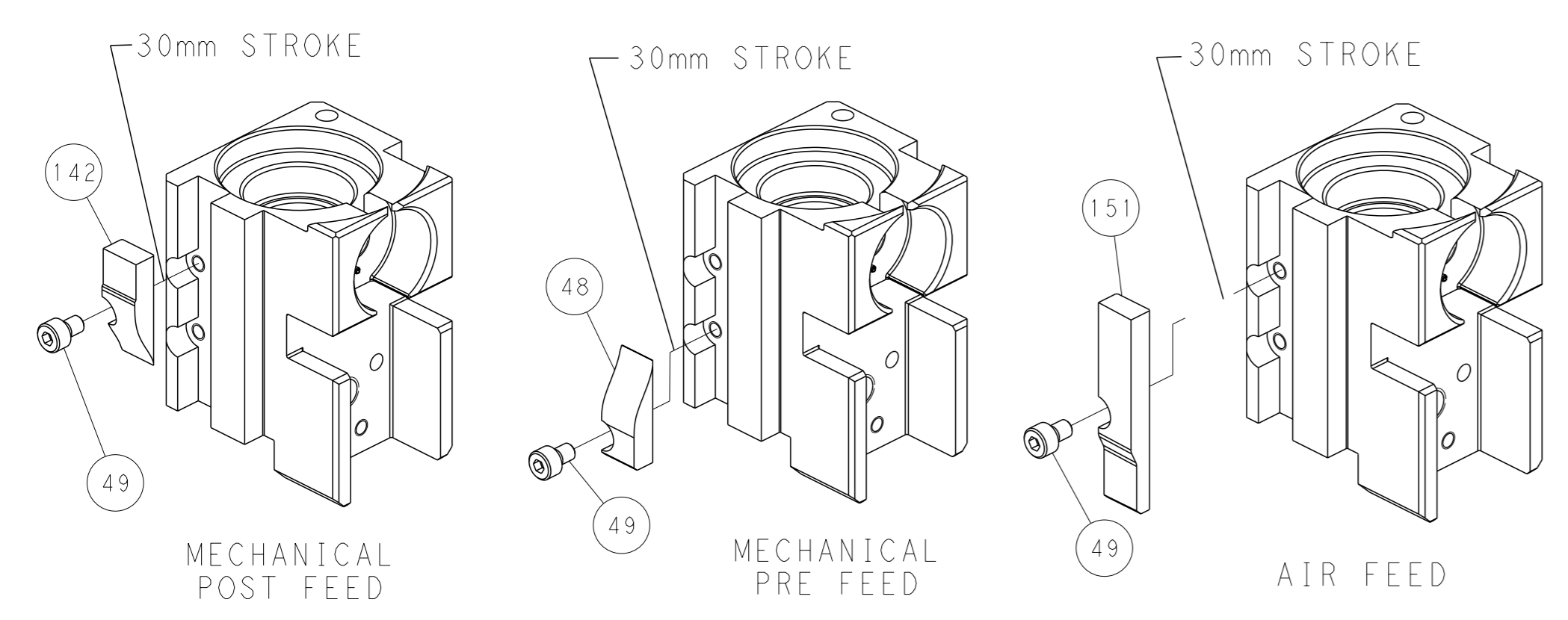
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



**PACIFIC VERSION**  
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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	DATE: 31AUG2012 NAME: Ocean Side Feed Applicator SIZE: A1 SCALE: 1:2	CAGE CODE: 00779 DRAWING NO: 2151744 SHEET: 4 of 4 REV: F