

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2151668-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151668-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151668-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151668-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2151668-5	F	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151668-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151668-4	-	-	
	2151668-6	F	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-
2151668-7	F	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
7-2151668-7	D	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.66 mm [.026]	F
INSUL	0.75 mm [.030]	F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: JST TERMINAL	JST CRIMP SPECIFICATION
TERMINAL NAME: 1.25mm PITCH CONNECTOR	
WIRE STRIP LENGTH 1.50-1.50 mm [.059-.059 IN]	INSULATION DIAMETER RANGE Ø0.80-1.00 mm [.031-.039 IN]
TERMINAL APPLICATION SPECIFICATION H4009/017-00 Rev -	
TERMINALS APPLIED	
TE TERMINAL	JST TERMINAL
1832568-1	SSHL-002T-P0.2
TE TERMINAL	JST TERMINAL
2113433-1	SGHD-002GA-P0.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.54+/-0.02 [.021+/-0.001]	5.7
28 AWG	0.50+/-0.02 [.020+/-0.001]	6.1
30 AWG	0.46+/-0.02 [.018+/-0.001]	6.4

- 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: 8-2151668-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151668-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151668-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151668-6
- 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 ITEM 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 5.26.

**\*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	REV	DATE	BY	APPV
			C	28APR2014	XZ	TE
			D	23JUN2016	MZ	JDG
			E	01JUN2016	MZ	JDG
			F	15NOV2016	TB	CT

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO			
-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260	
-	-	1	-	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252	
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250	
-	-	-	-	1	1803259-1	BUSHING, FLANGED	249	
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248	
-	-	1	-	1	2119798-1	DETENT PIN	247	
-	-	1	-	1	1-22279-3	SPRING, COMPRESSION	246	
-	-	1	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245	
-	-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	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	
-	-	-	-	-	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	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
-	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	-	1	1	1	1-455888-6	SPACER, CRIMPER	82	
-	-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	-	1	1	1	1-2119791-4	DEPRESSOR, WIRE	70	
-	-	1	-	1	2119740-1	TAG IDENTIFICATION	67	
-	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	-	1	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
-	-	3	-	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62	
-	-	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	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	-	-	-	1	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	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	-	1	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	-	1	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	-	1	1	1	1	1-2119644-4	RAM WASHER, PRECISION	38
-	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	-	1	1	1	1	2-1752356-6	SUPPORT, TERMINAL	34
-	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	-	1	1	1	1	1320908-8	SPACER, STRIP GUIDE	30
-	-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	-	1	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
-	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	-	1	1	1	1	7-1633927-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	-	1	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	-	1	1	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
-	-	1	1	1	1	8-1803017-5	CRIMPER, INSULATION F	3
-	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	-	1	1	1	1	5-1633730-4	CRIMPER, WIRE	1

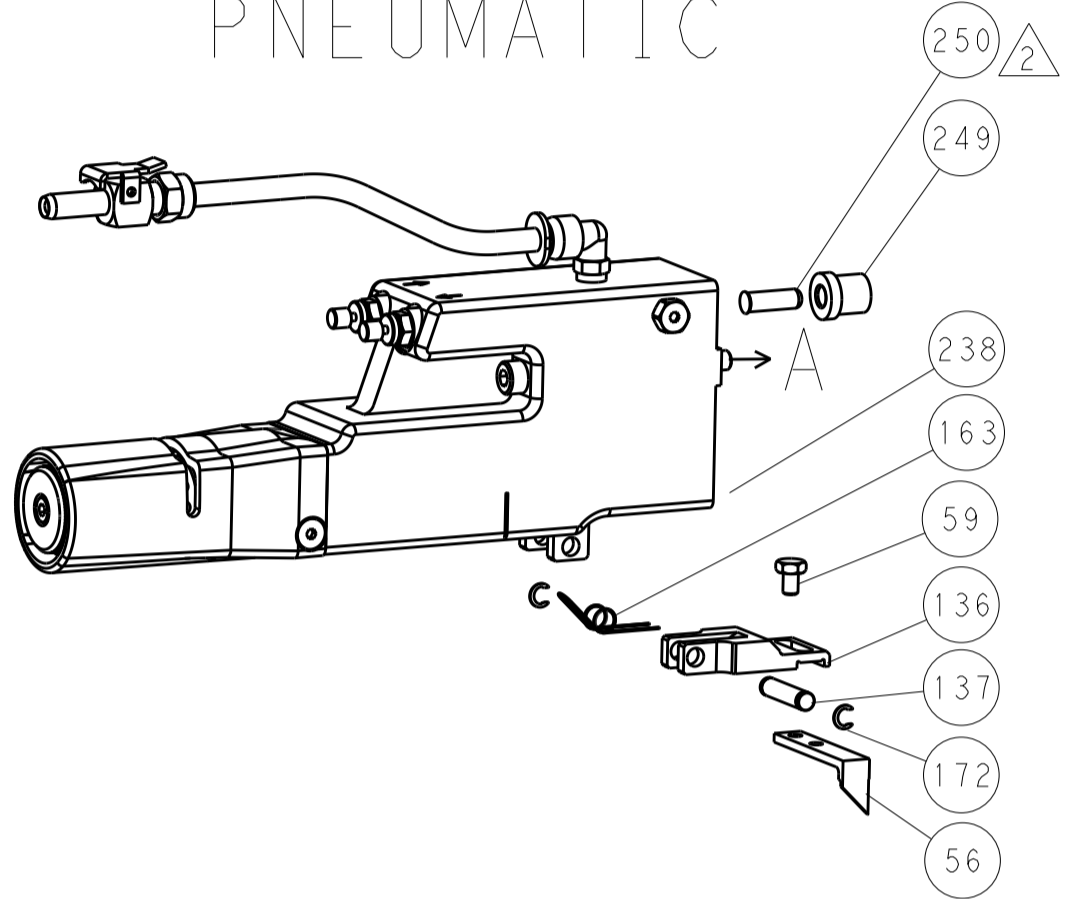
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	CHK	DATE	NAME
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	CH. HUANG	L. ZHANG	21FEB2014	TE Connectivity Harrisburg, PA 17105-3608
		APVD	U. GUO	21FEB2014	Ocean Side Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SHEET:	REV:
			1:2	1 of 4	F

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

### FEED TYPE MECHANICAL



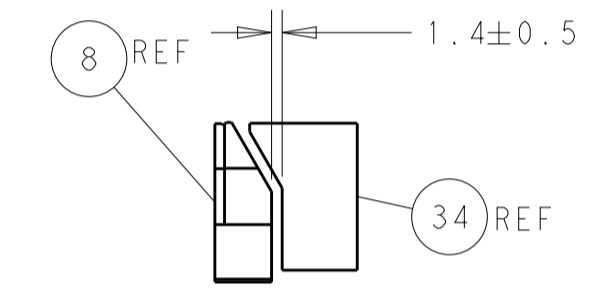
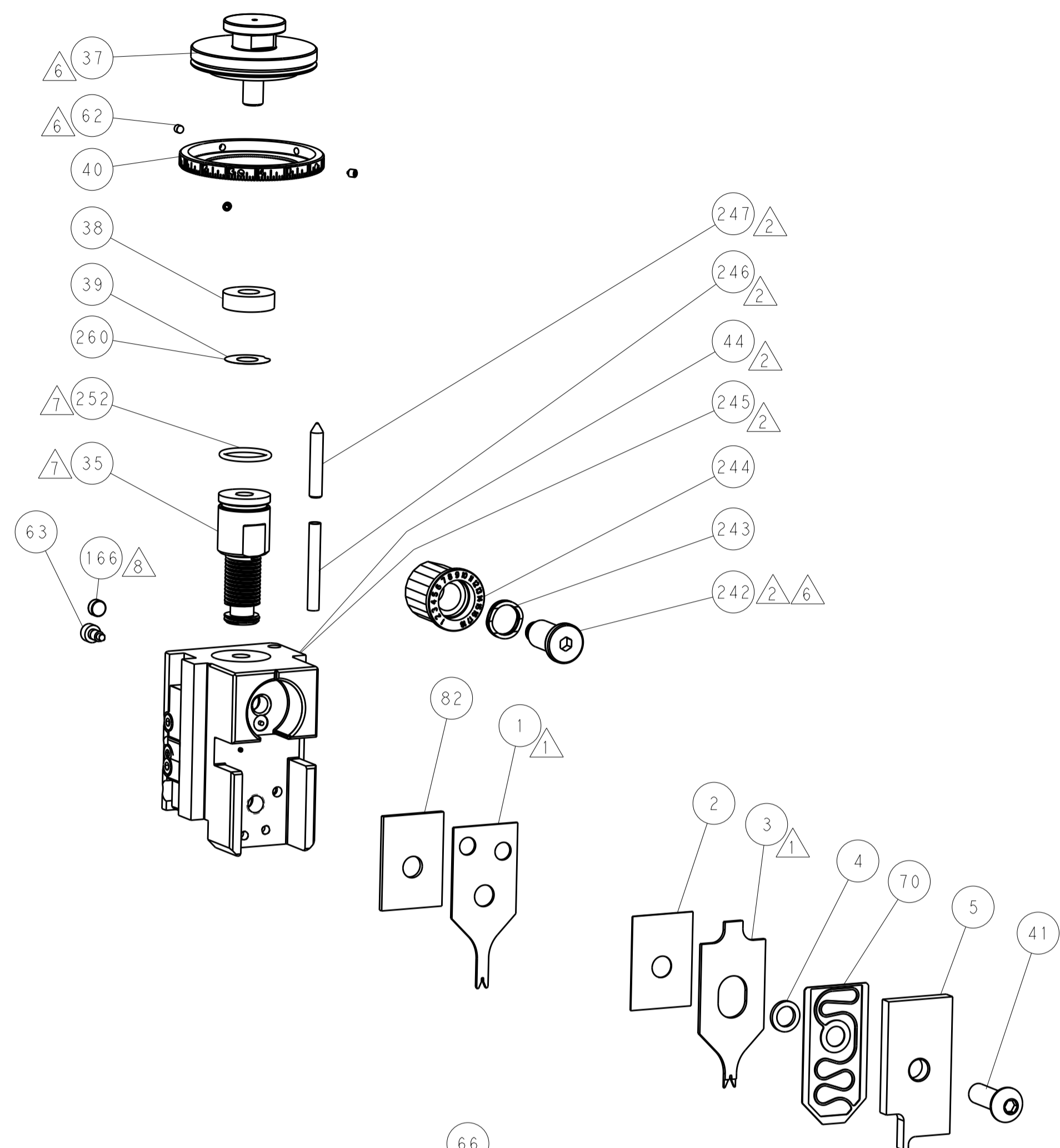
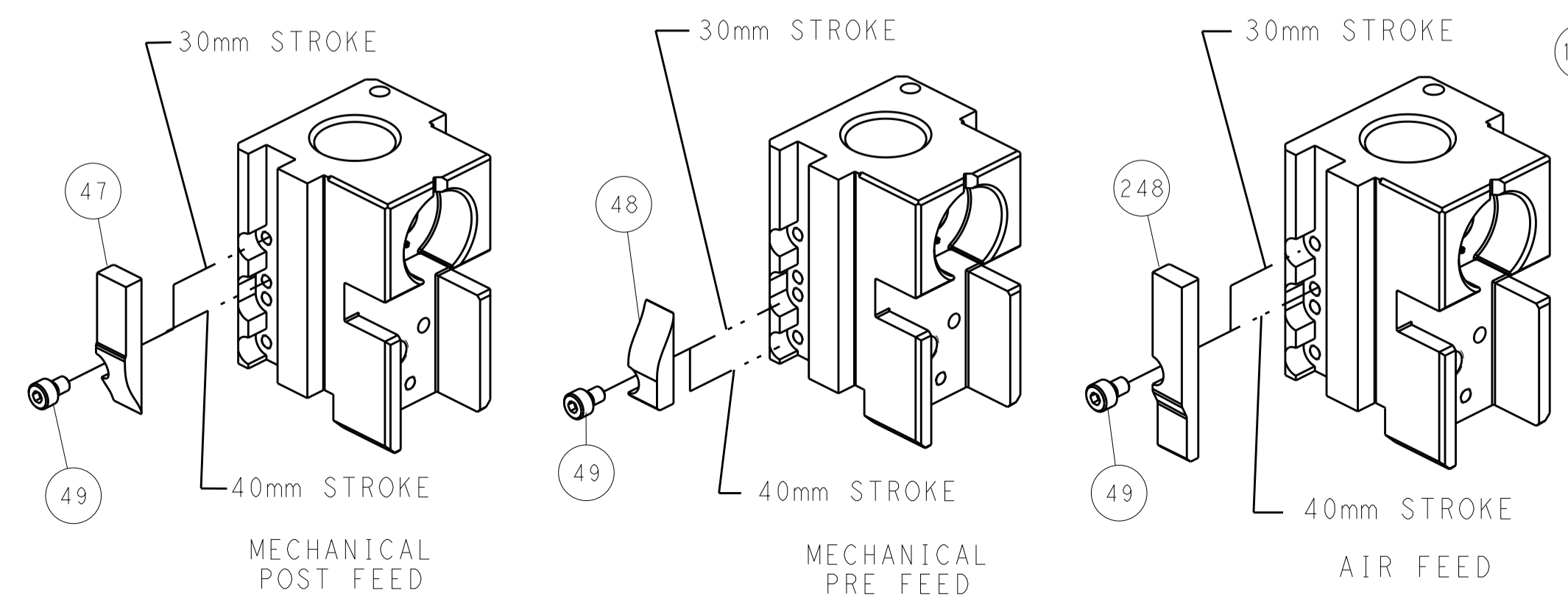
### PNEUMATIC



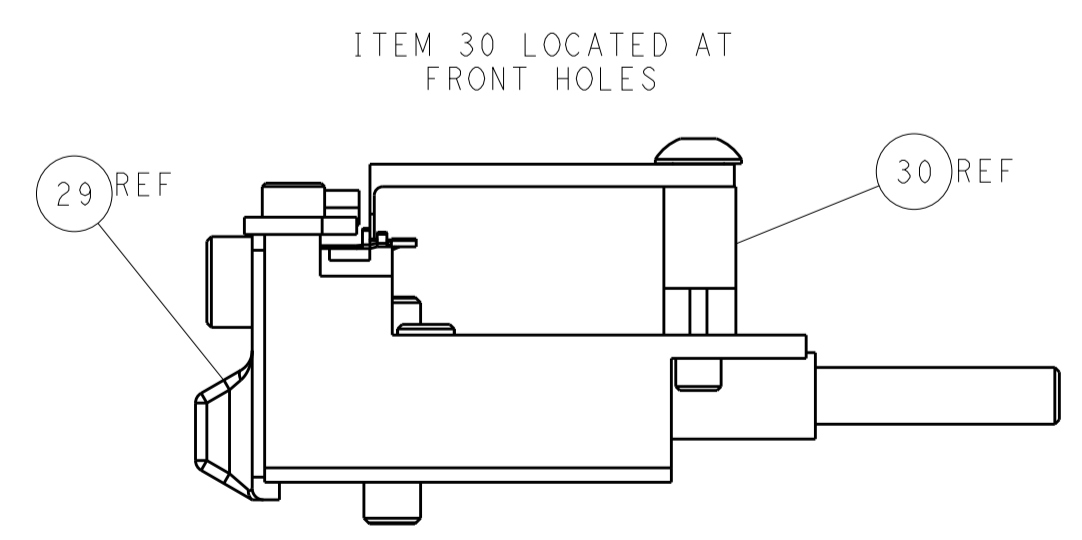
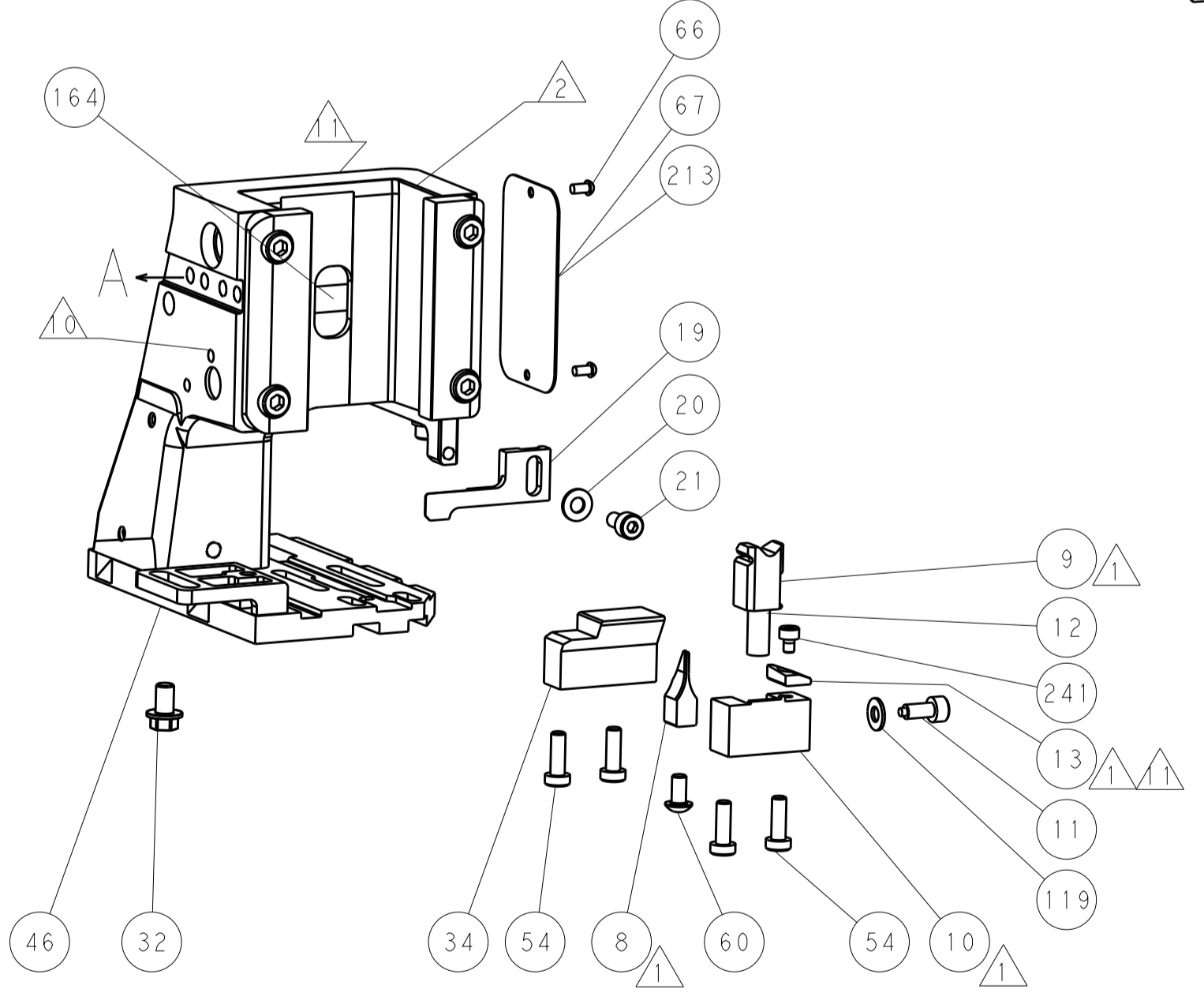
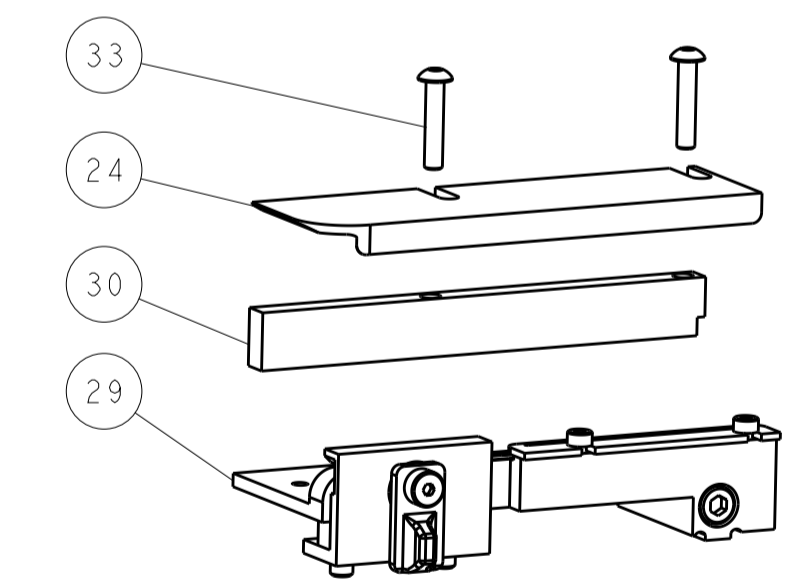
### SERVO LATCH PLATE



### CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT FRONT HOLES

FEED TRACK POSITION GUIDE BY INSULATION BARREL

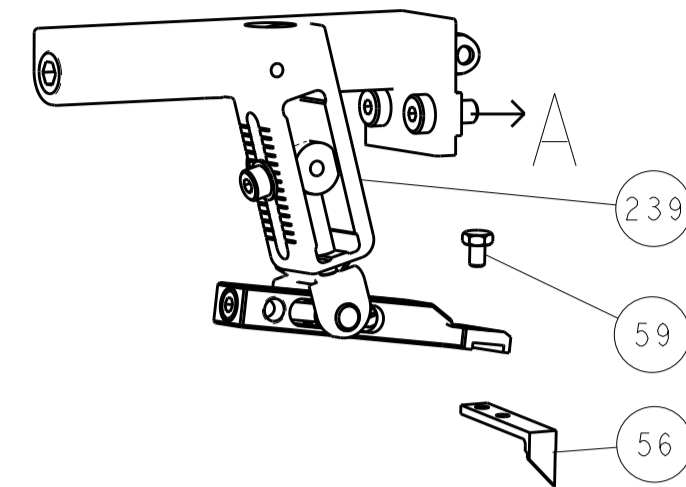
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG 21FEB2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK L. ZHANG 21FEB2014		NAME Ocean Side Feed Applicator	
				APVD H. GUO 21FEB2014		RESTRICTED TO	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=2151668	
				WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV F	
				Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

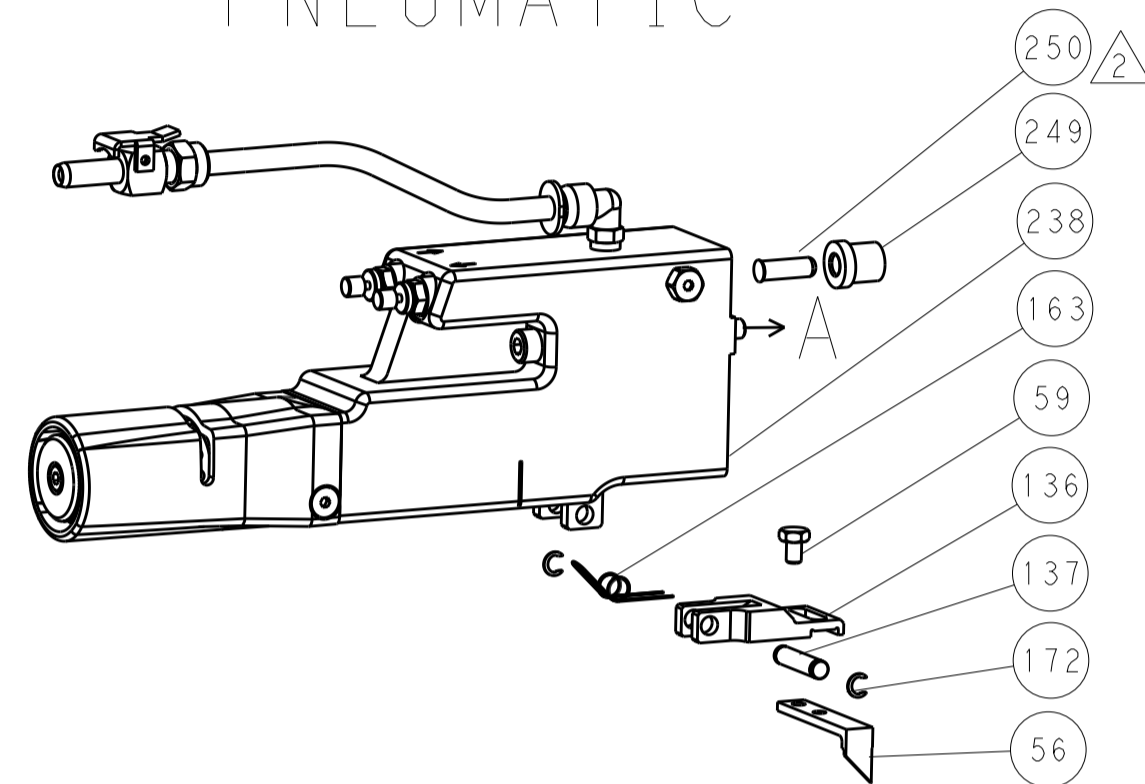


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

# FEED TYPE MECHANICAL



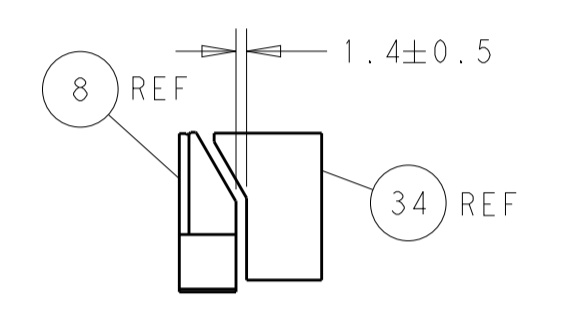
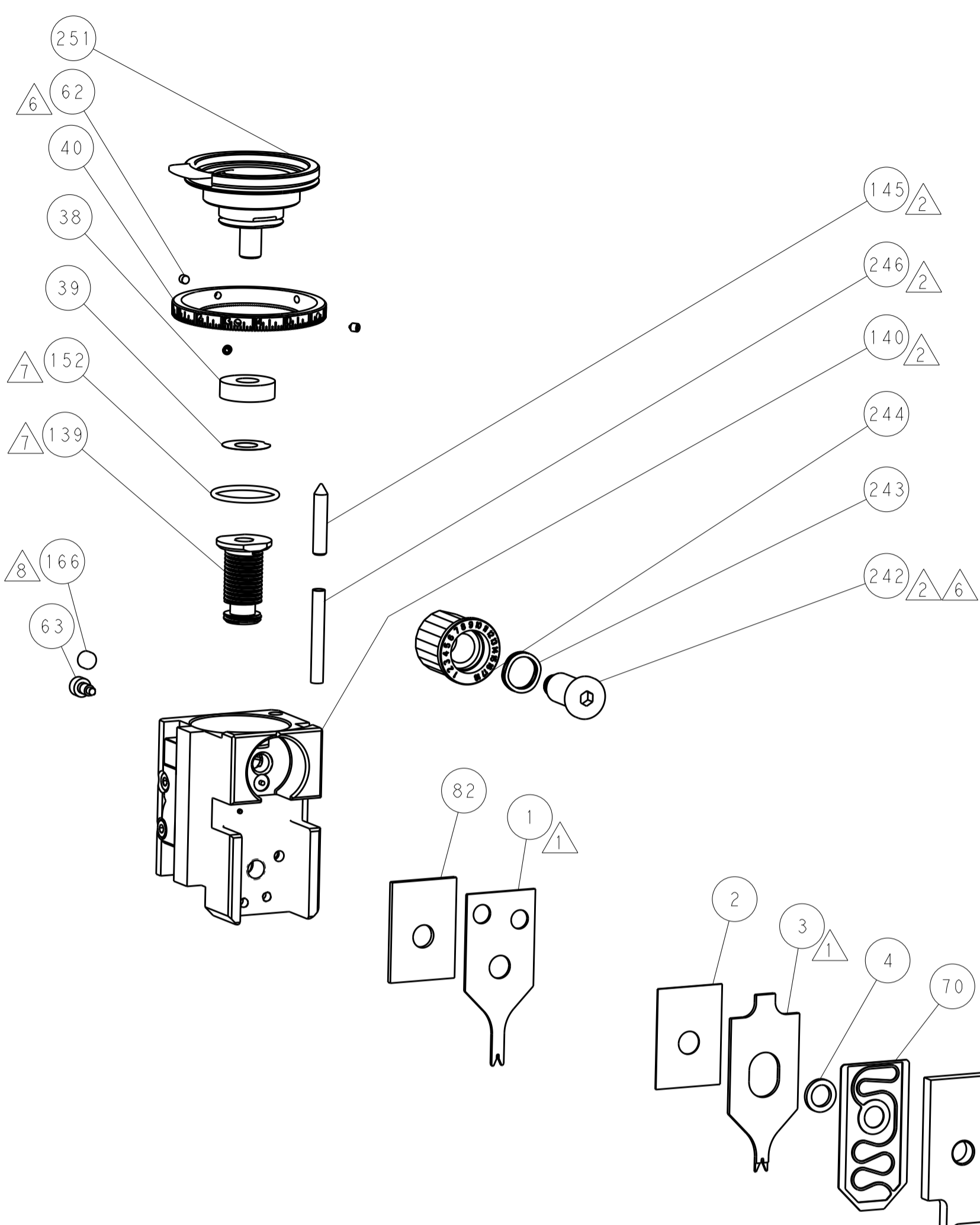
# PNEUMATIC



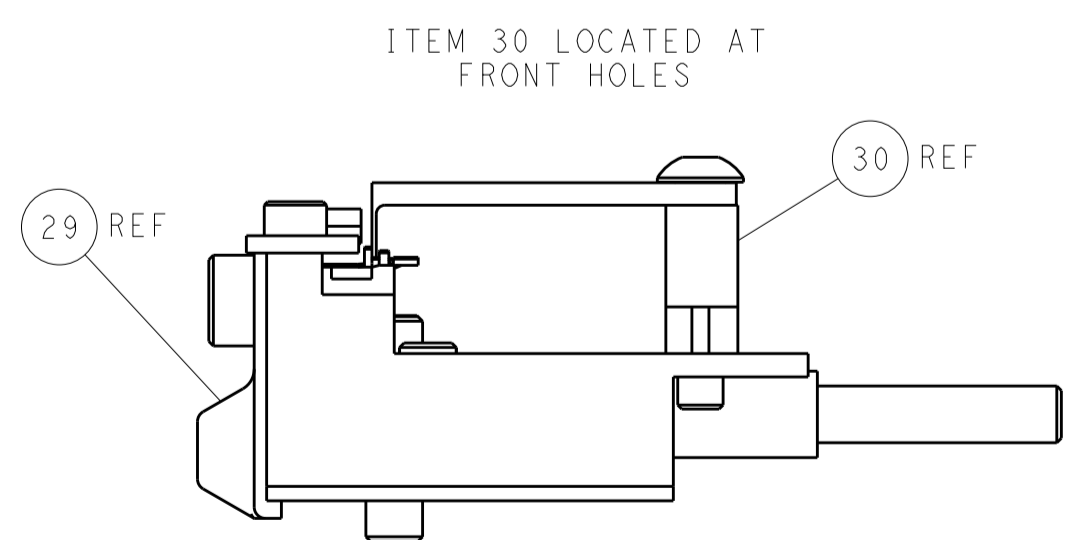
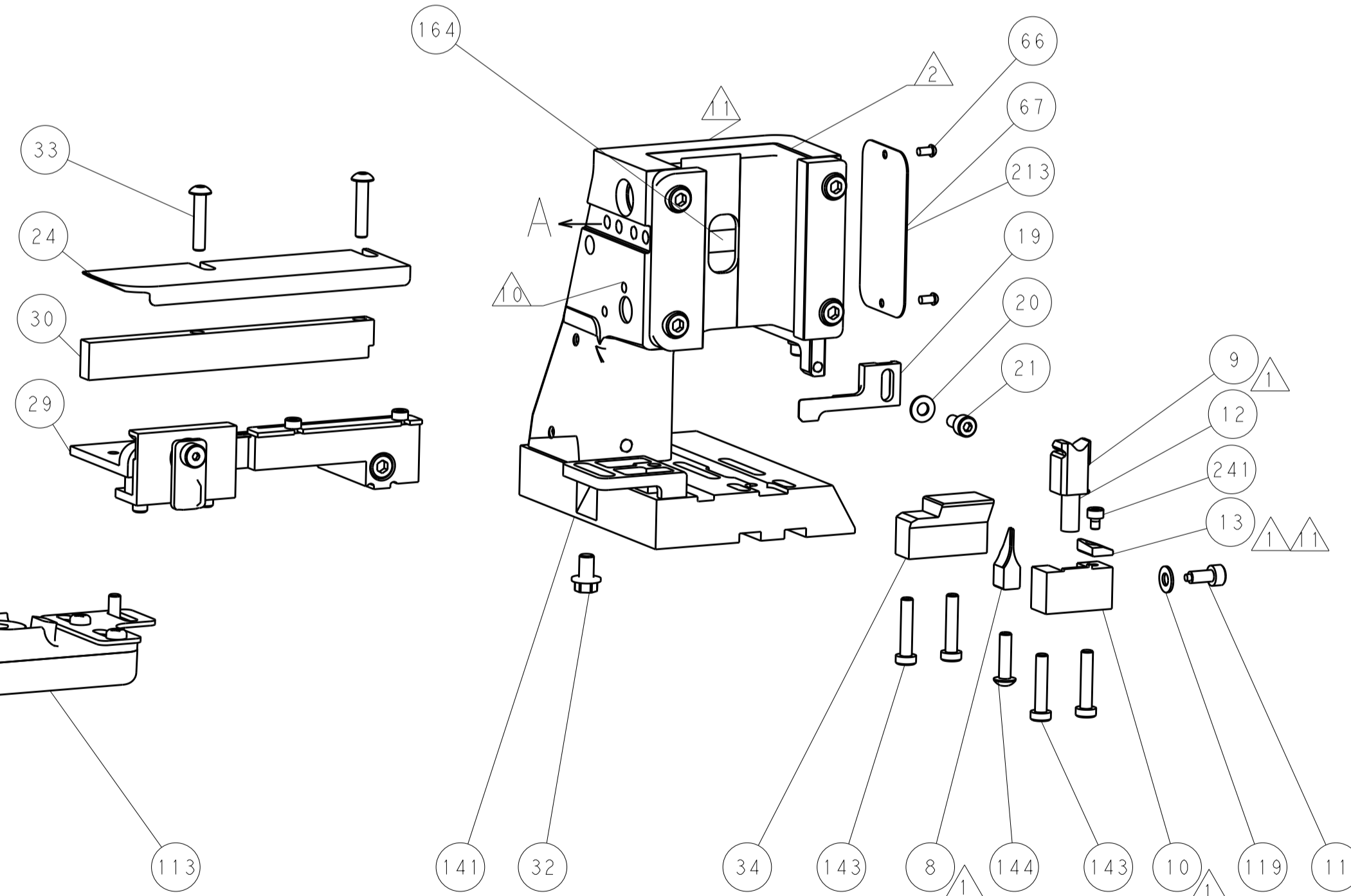
# SERVO LATCH PLATE



# CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT FRONT HOLES

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 21FEB2014		STE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: L. ZHANG 21FEB2014		NAME: Ocean Side Feed Applicator	
				APVD: H. GUO 21FEB2014		PRODUCT SPEC:	
						APPLICATION SPEC:	
				WEIGHT:		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
				A   00779   C=2151668		Customer Accessible Production Drawing	
				SCALE: 1:2		SHEET 4 OF 4 REV F	