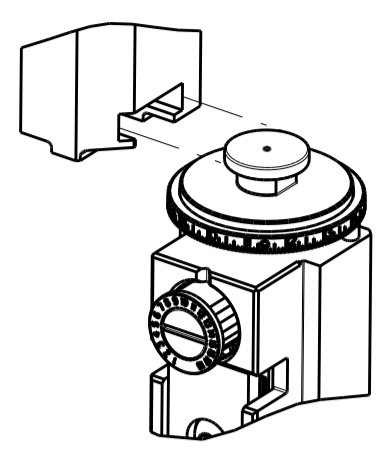


SET UP GAUGE 2119599-1
LOC A DIST 66
REVISED: P LTR DESCRIPTION DATE DWN APVD
A RELEASED 20MAR2013 CC SX

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER
PART NUMBER REVISION DESCRIPTION FEED TYPE
CONVERT TO PART NUMBERS REQUIRED
PNEUMATIC FEED 2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1
SERVO LATCH PLATE 2119951-1 8-2151352-5 1901094-3
SMART APPLICATOR 2161326-1 8-2151352-4
MECHANICAL FEED 2119949-1 1338685-1 5-18022-5 2119653-1
SERVO LATCH PLATE 2119951-1 8-2151352-5 1901094-3 2168400-6 (QUANTITY 2)
SMART APPLICATOR 2161326-1 8-2151352-4
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
SERVO LATCH PLATE 4
SERVO LATCH PLATE 12
NON-CRIMP HEIGHT ADJUST
FINE CRIMP HEIGHT ADJUST
CRIMP TOOLING KIT



APPLICATOR DATA
CRIMP SIZE TYPE
WIRE 2.10 mm [.083] F
INSUL 2.50 mm [.098] OV
APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: FCI TERMINAL FCI CRIMP SPECIFICATION
TERMINAL NAME: FCI CLIP 1.5X0.8 SICMA-2
WIRE STRIP LENGTH 5.00-5.50 mm [.196-.217 IN] INSULATION DIAMETER RANGE 1.35-1.82 mm [.053-.072 IN]
TERMINAL APPLICATION SPECIFICATION
TERMINALS APPLIED
TE TERMINAL FCI TERMINAL TE TERMINAL FCI TERMINAL
286938-1 211CC2S1120 286938-2 211CC2S1230

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING
0.75mm2 1.22+/-0.04 [.048+/-0.002] 5.1
0.35+0.35mm2 1.21+/-0.04 [.048+/-0.002] 5.2
0.60mm2 1.19+/-0.04 [.047+/-0.002] 5.5
0.50mm2 1.18+/-0.04 [.046+/-0.002] 5.6
0.35mm2 1.15+/-0.05 [.045+/-0.002] 5.9

- 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: 8-2151352-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151352-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151352-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151352-6
- 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 ITEM 50.
- 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.

Item list table with columns: PART NO, DESCRIPTION, ITEM NO
2119957-2 APPLICATOR SHIM PACK 260
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
-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)

Large parts list table with columns: ITEM NO, PART NO, DESCRIPTION, ITEM NO
2119798-1 DETENT PIN 247
1-22279-3 SPRING, COMPRESSION 246
2119758-1 RAM, AMP STYLE, SIDE FEED, NON-ADJ. 245
2119082-8 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
993111-1 PIN, SLOTTED SPRING 3.0 X 20.0 177
8-22280-7 SPRING, COMPRESSION 176
1752353-2 GUIDE PIN, HOLDDOWN 175
1901680-2 GUIDE PIN, HOLDDOWN 174
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
SEE NOTE 4 MEMORY CHIP, PROGRAMMED 135
1633743-1 SERVO FEED LATCH ASM 133
1-18028-2 WASHER, FLAT, REG M4 119
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 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
1-5018030-0 NUT, HEX, REG, RoHS, M3.5 52
1901681-1 HOLDDOWN, TERMINAL 51
1-1752354-8 STANDOFF, HOLD-DOWN 50
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
2119644-1 RAM WASHER, PRECISION 38
2119085-1 FA HEAD, ATLANTIC STYLE 37
2119092-1 BOLT, ADJUSTMENT 35
1-1752356-3 SUPPORT, TERMINAL 34
2079383-5 SCR, BHSC, RoHS (M4 X 20) 33
2161328-1 HEX HEAD, FLANGED, M5 X 8mm LONG 32
1320908-3 SPACER, STRIP GUIDE 30
2119959-1 ASSEMBLY, STRIP GUIDE 29
1-455888-0 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
2119533-1 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
3-1633927-4 ANVIL, COMBINATION 8
- 7
- 6
2119757-8 DEPRESSOR, SHEAR 5
3-238011-3 BLOCK, CRIMPER SPACER 4
2-2119785-2 CRIMPER, INSULATION OVERLAP PREMIUM 3
455888-4 SPACER, CRIMPER 2
4-1633738-7 CRIMPER, WIRE 1
-77 -7 -6 -5 -2 -1 PART NO DESCRIPTION ITEM NO

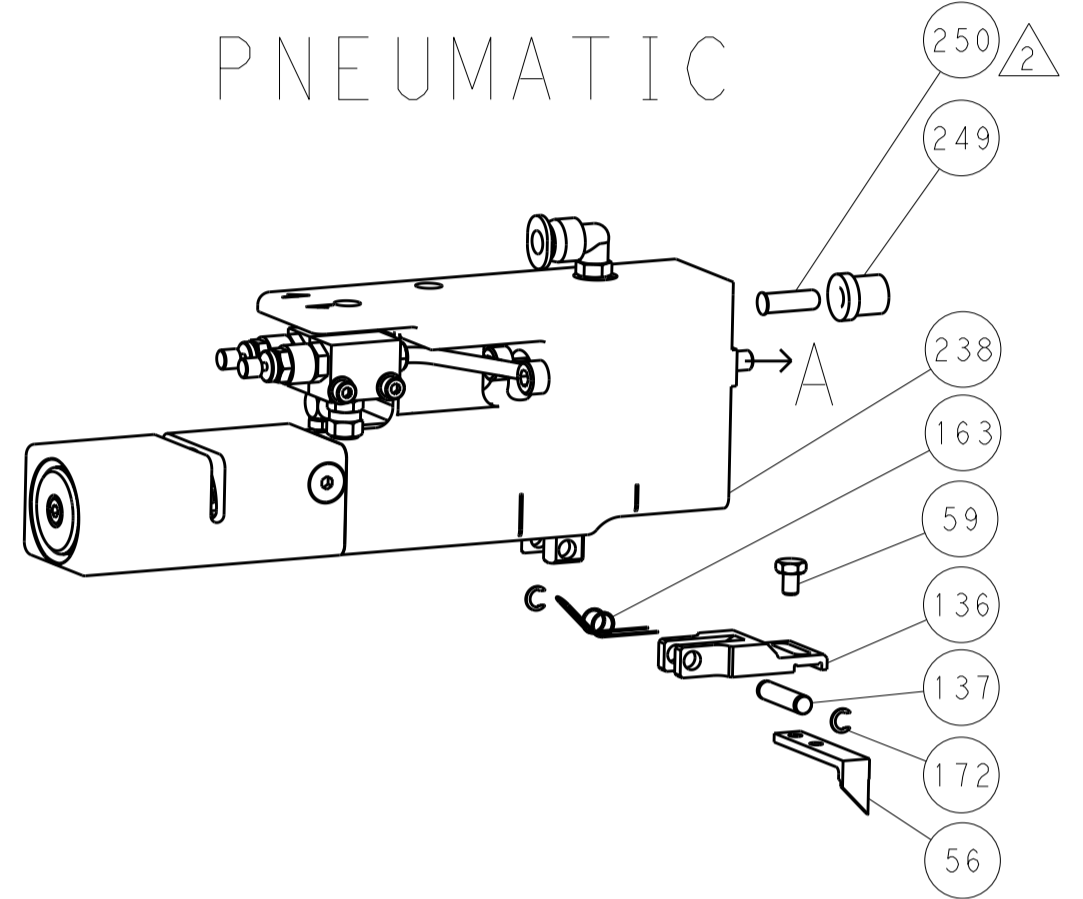
TE Connectivity
Ocean Side Feed Applicator
Customer Accessible Production Drawing
SCALE 1:1 SHEET 1 OF 4 REV A

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

FEED TYPE MECHANICAL



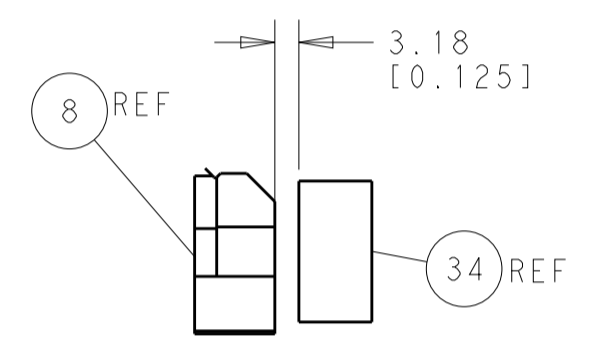
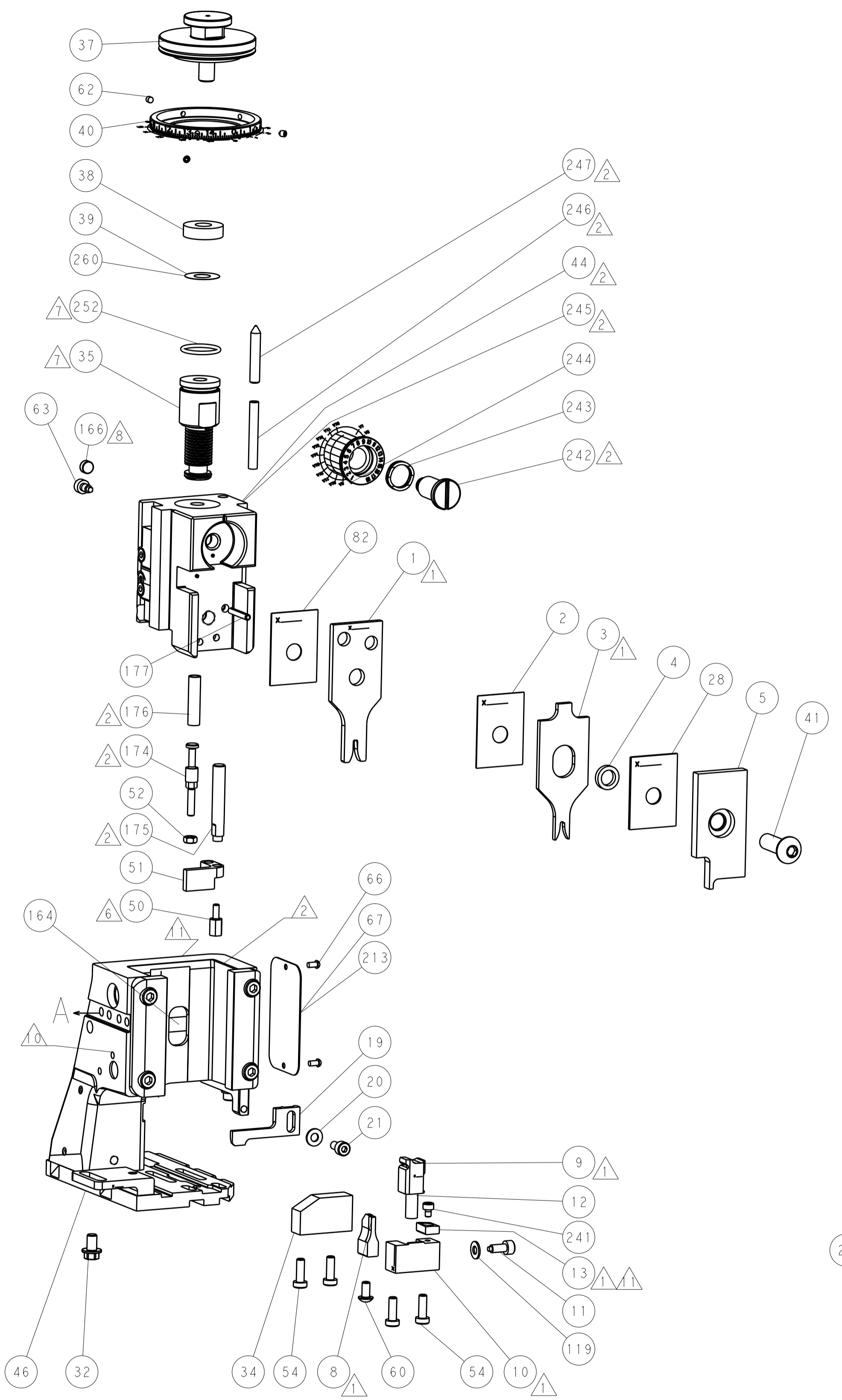
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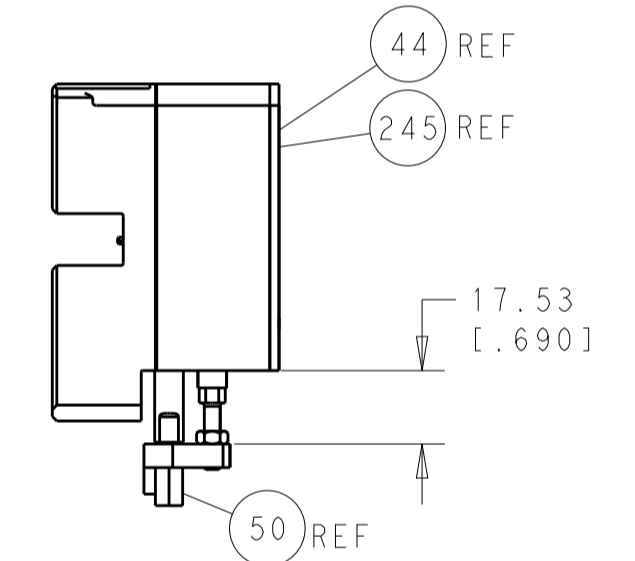
SERVO LATCH PLATE



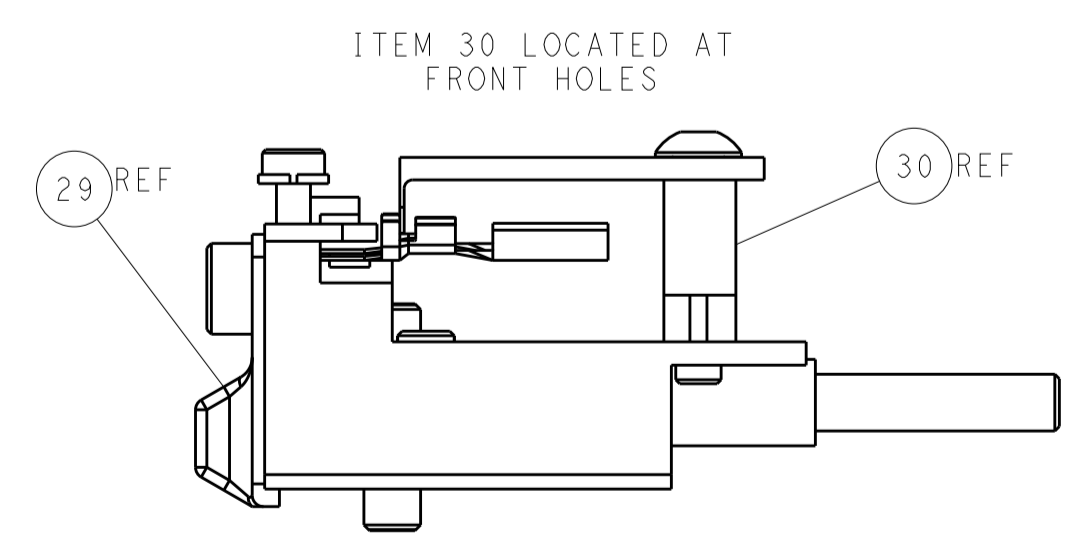
CAM POSITIONS



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)

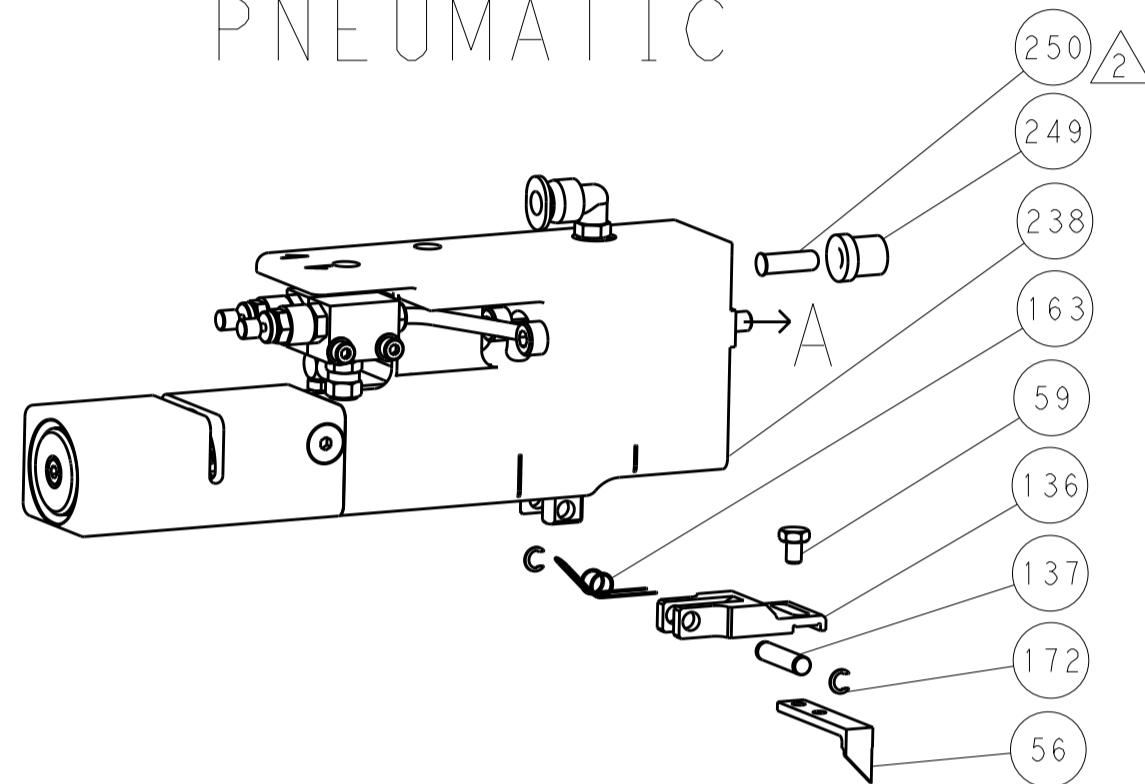
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mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	APVD S. XI 13AUG2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME Ocean Side Feed Applicator		RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 2 of 4		REV A	

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

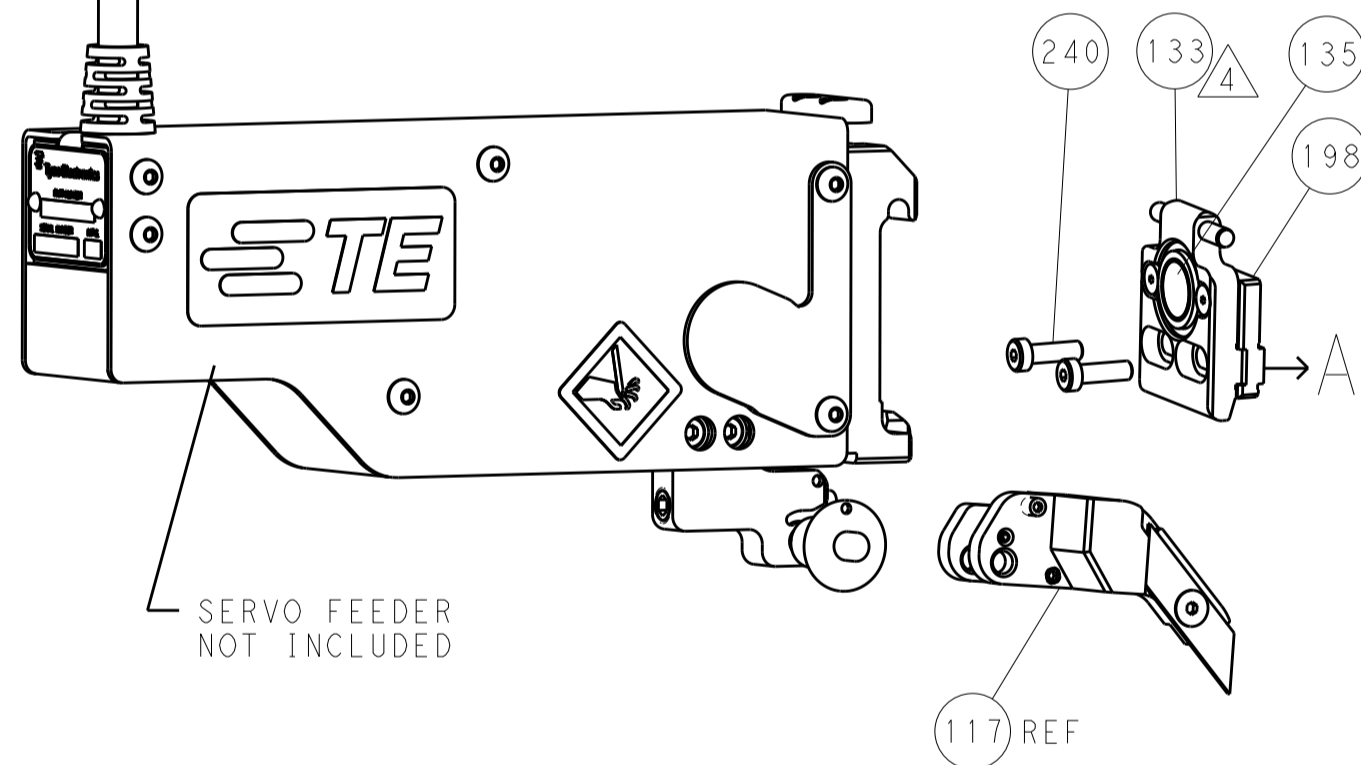
FEED TYPE MECHANICAL



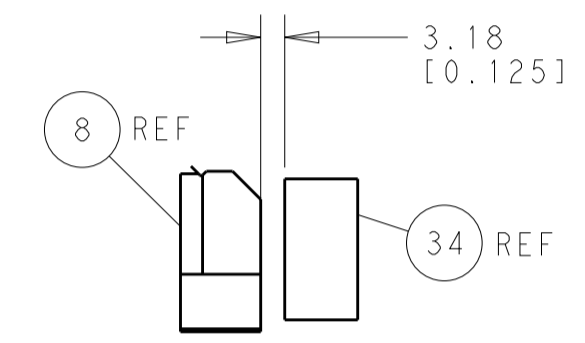
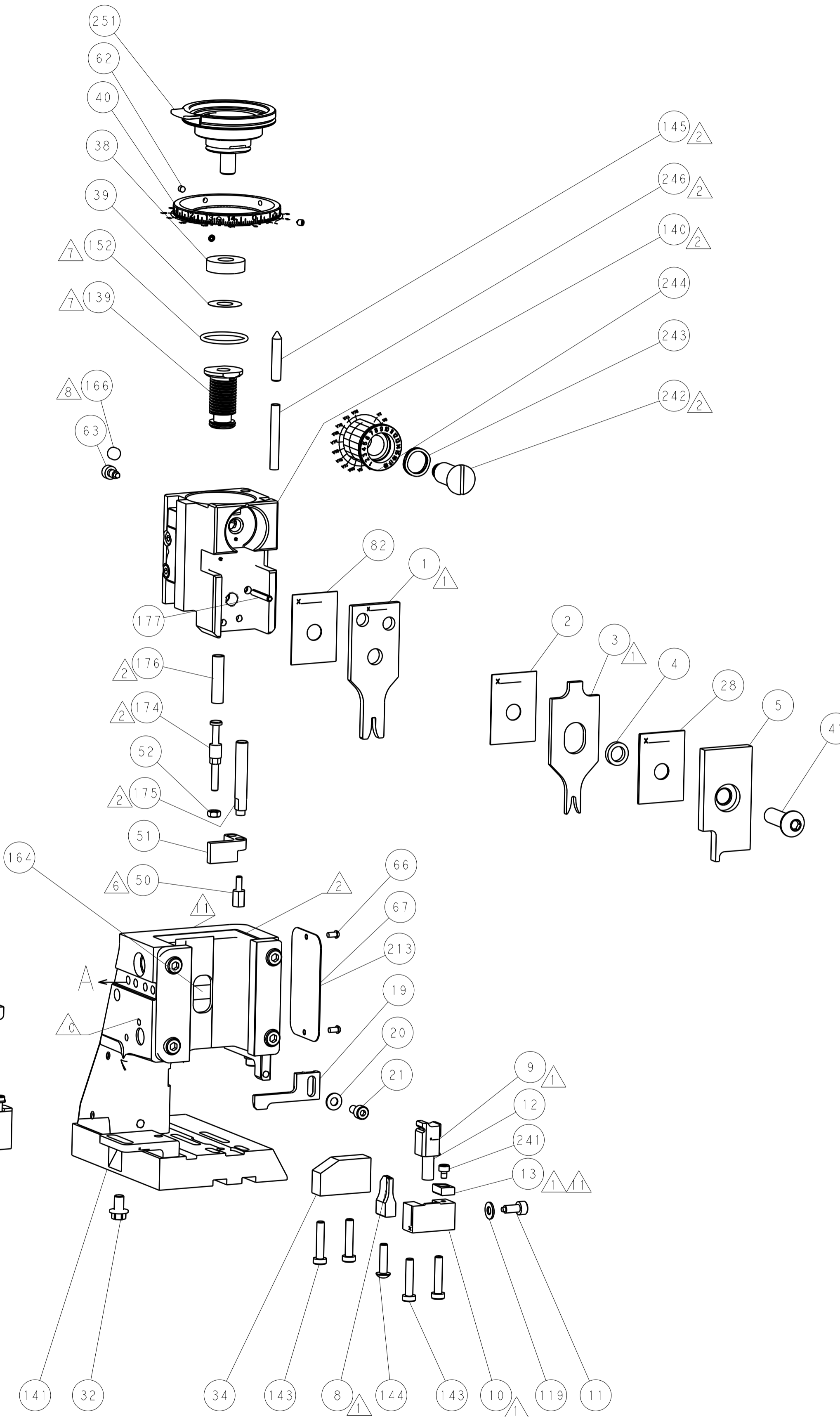
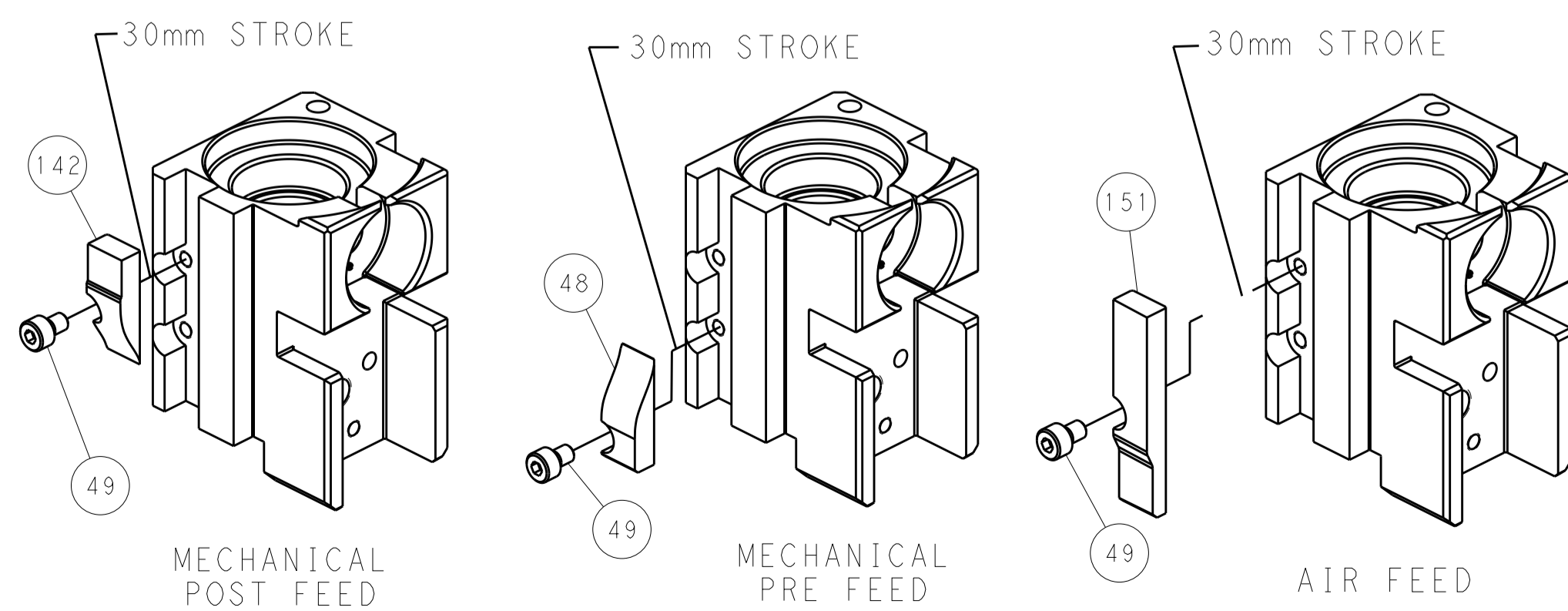
PNEUMATIC



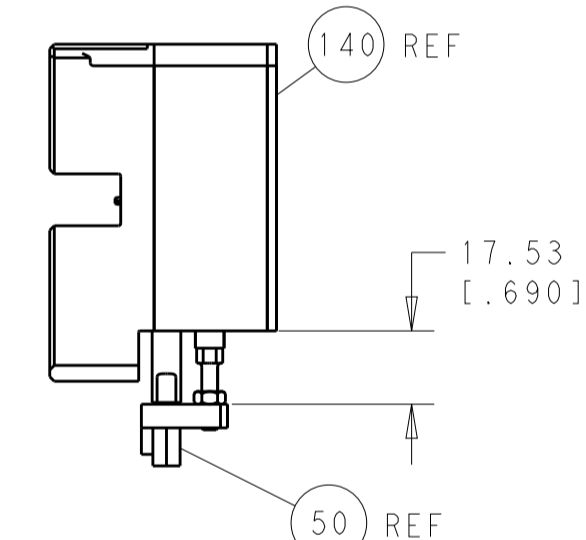
SERVO LATCH PLATE



CAM POSITIONS

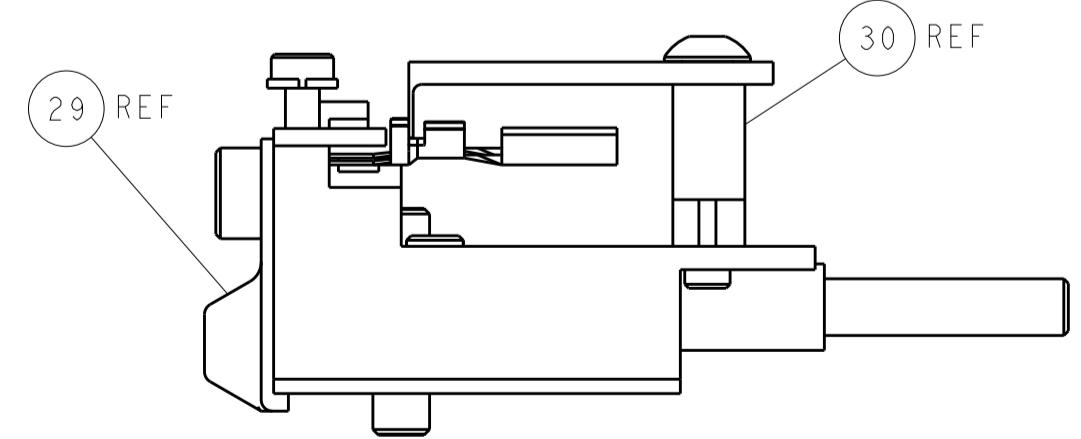


TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

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: C. CHEN 13AUG2012		STE TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	ANGLES ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
			1:1	A1	00779	©=2151352	
Customer Accessible Production Drawing				SHEET 4 OF 4 REV A			