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APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA. Table with columns: CRIMP SIZE, WIRE SIZE, INSUL. SIZE.

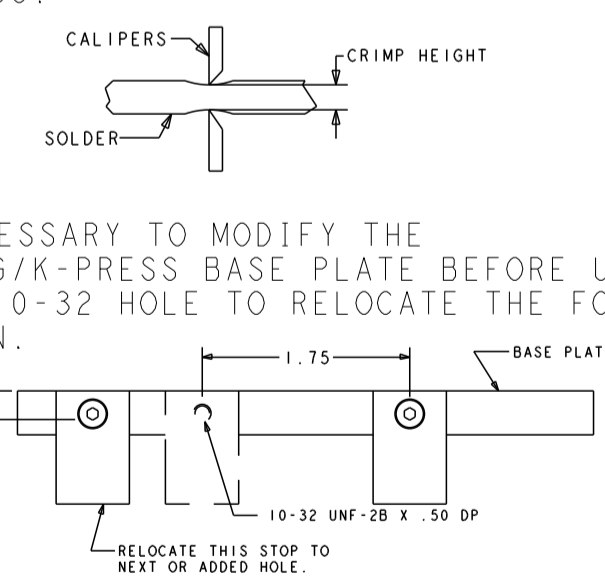
TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Includes wire strip length, insulation diameter range, terminal application specification, and terminals applied.



Table with columns: WIRE SIZE, CRIMP HEIGHT INCH [mm], CRIMP HEIGHT REFERENCE SETTING, SOLDER.

- 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.
5 ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
7 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
8 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY.
9 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE.
10 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.
11 ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
12 ITEMS 5 AND 9 OR ITEMS 10 AND 22 ARE REQUIRED WHEN RUNNING ON A LEADMAKER.
13 FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
14 GROUP 1 TERMINALS: .160 IN [4.06mm] MAX INSULATION
GROUP 2 TERMINALS: .260 IN [6.60mm] MAX INSULATION

- 3 USE ITEMS 5, 9, OR 42 WITH GROUP 1 TERMINALS USE ITEMS 10, 22, OR 43 WITH GROUP 2 TERMINALS
6 TO CHECK CRIMP HEIGHT. CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
7 IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
8 ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
9 ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.



*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various components like APPLICATOR SHIM PACK, GUARD ASSY, INSERT, GUARD, BRACKET, SPACER, etc.

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

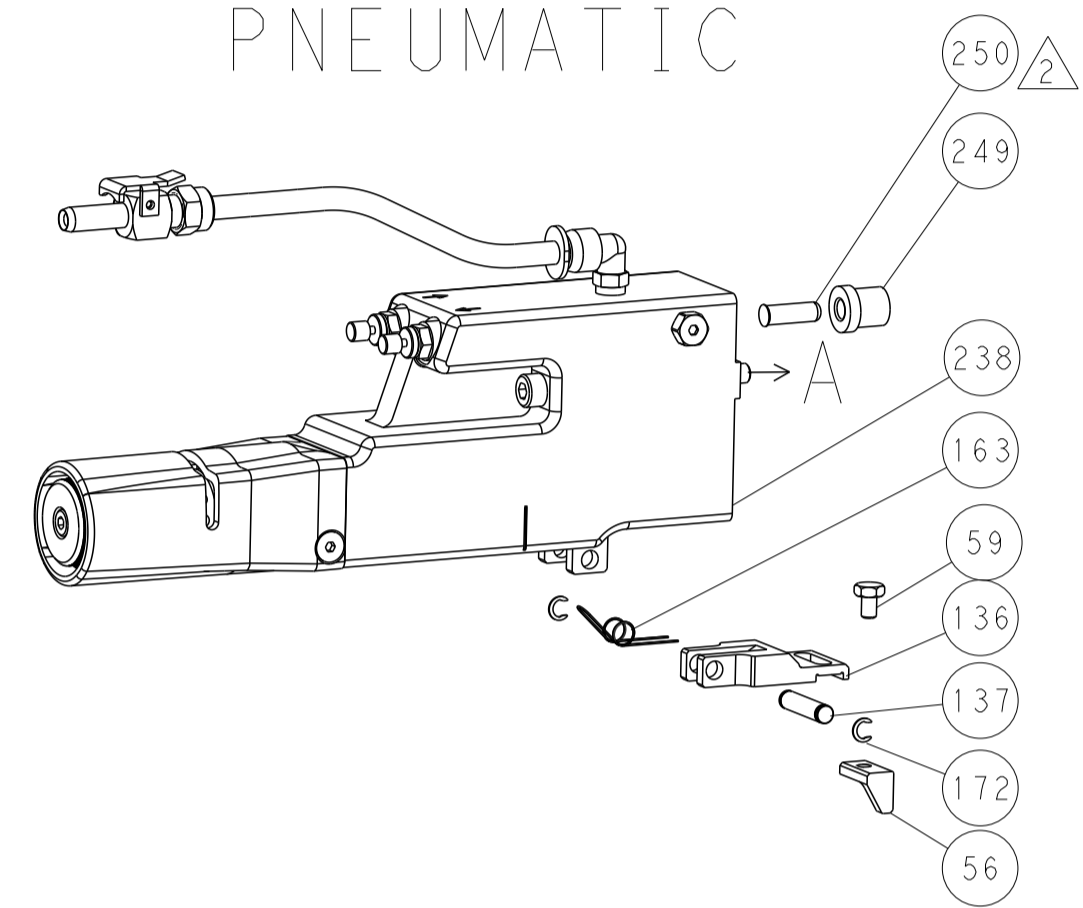
REVISIONS table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD. Lists revisions C1, C2, D.

Main BOM table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD. Lists hundreds of components including SHCS, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, TAG, IDENTIFICATION, SPACER, FEEDER, RING, RETAIN, EXTERN, 3/16 CRESCENT, MAGNET, RARE EARTH HIGH ENERGY, COUNTER, MAGNETIC, SPRING, FEED FINGER, PIN, RETAIN, GRVD, 3/16 X .854, HOLDER, FEED FINGER, AF, MEMORY CHIP, PROGRAMMED, SERVO FEED LATCH ASM, SPRING, COMPRESSION, FRONT STRIP GUIDE, SCR, SKT HD CAP, RoHS, M3 X 8.0, SCR, SKT HD CAP, RoHS, M5 X 65, SPACER, CRIMPER, SPACER, DOCUMENTATION PACKAGE, DEPRESSOR, WIRE FUNNEL, SPACER, WIRE FUNNEL DEPRESSOR, WASHER, FLAT, REG M3, TAG, IDENTIFICATION, SCREW, DRIVE, RH, RoHS, 2 x .188, LIMITER, ADJUSTMENT BOLT, SCR, SET, SOC, CONE POINT, M3 x 4.0, SCR, SET, FLT POINT M5 X 20.0, SCR, BHSC, RoHS (M4 X 8), SCR, HEX HD CAP, M4 X 6.0, FINGER, FEED, SHCS, LOW HEAD, RoHS, M4 X 12, SCR, SKT HD CAP, RoHS, M4 X 16, SCR, SKT HD CAP M4 X 6.0, APPLICATOR BASIC ASSEMBLY, SF, RAM, AMP STYLE, SIDE FEED, SUPPORT, INSULATION, SUPPORT, INSULATION, SCR, BHSC, RoHS (M8 X 25), DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, PRECISION, FA HEAD, ATLANTIC STYLE, BOLT, ADJUSTMENT, SPRING, COMPRESSION, HEX HEAD, FLANGED, M5 x 8mm LONG, SCR, SKT HD CAP, RoHS, M4 X 5, PLATE, REAR STRIP GUIDE, SPRING, COMPRESSION, LEVER, DRAG RELEASE, DRAG, TERMINAL, GUIDE, STRIP, FRONT, SCR, SKT HD SHLDR 5.0 DIA X 6.0, WIRE FUNNEL, SCR, SKT HD CAP, RoHS, M4 X 8.0, WASHER, FLAT, REG M4, STRIPPER, SIDE FEED, HOLD DOWN, TERMINAL, REAR FLOATING SHEAR, SCR, SKT HD CAP, RoHS, M3 X 6, SHEAR PLATE, REAR, SHEAR HOLDER, REAR, INSERT, SHEAR, SPRING, COMPRESSION, STOP, SHEAR, TERMINAL SUPPORT, TERMINAL SUPPORT, ANVIL, SAND-BLASTED 16-14, GUIDE, CARRIER SCRAP, DEPRESSOR SHEAR, REAR, WIRE FUNNEL, BLOCK, FL CRIMPER SPACER, CRIMPER, SEMI FLAT 16-14.

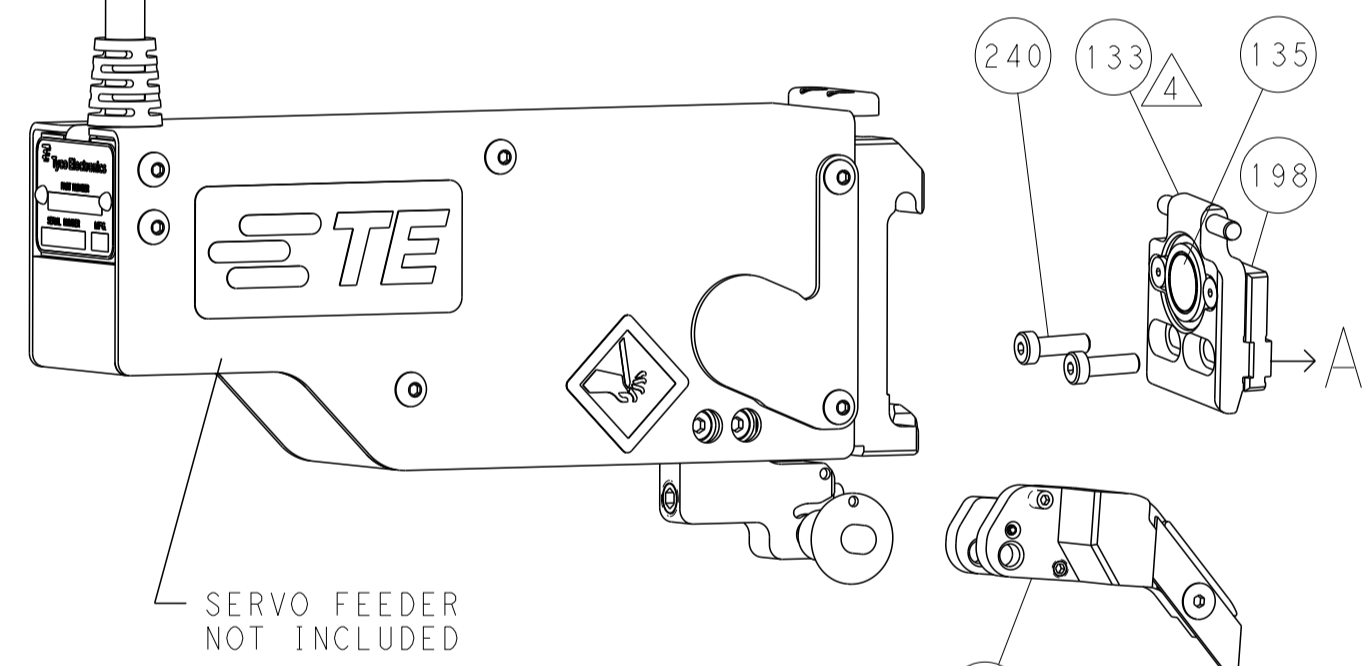
Technical drawing header including dimensions, tolerances, dimensions, material, weight, and customer information. Includes company logo for TE Connectivity.

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

FEED TYPE PNEUMATIC

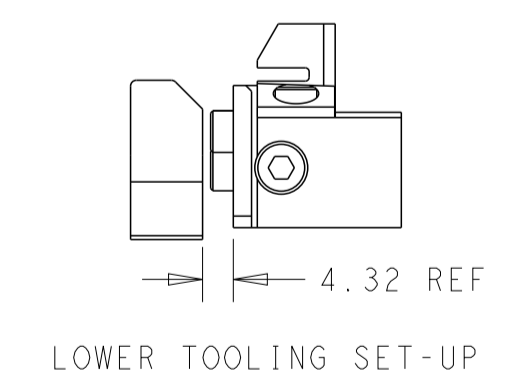
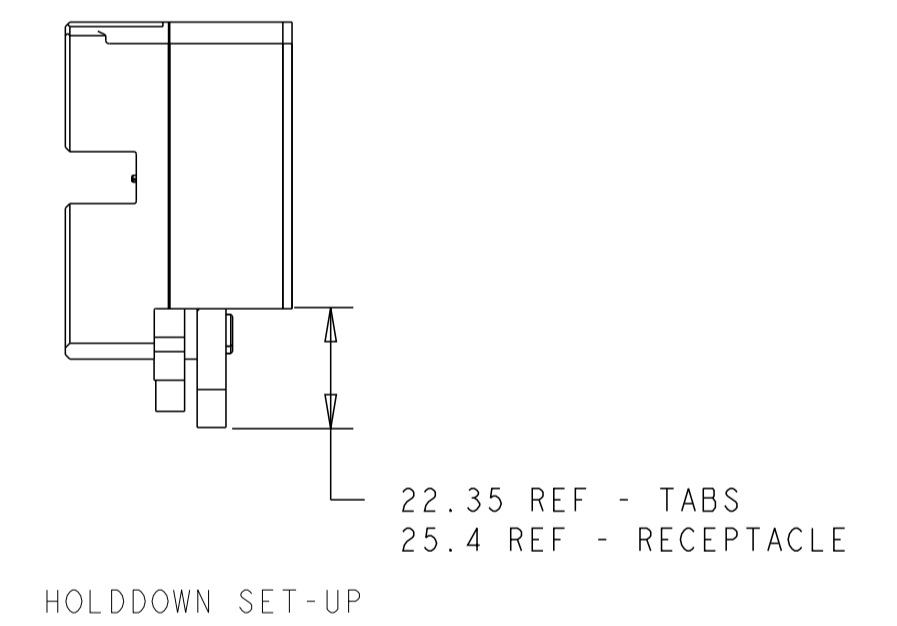
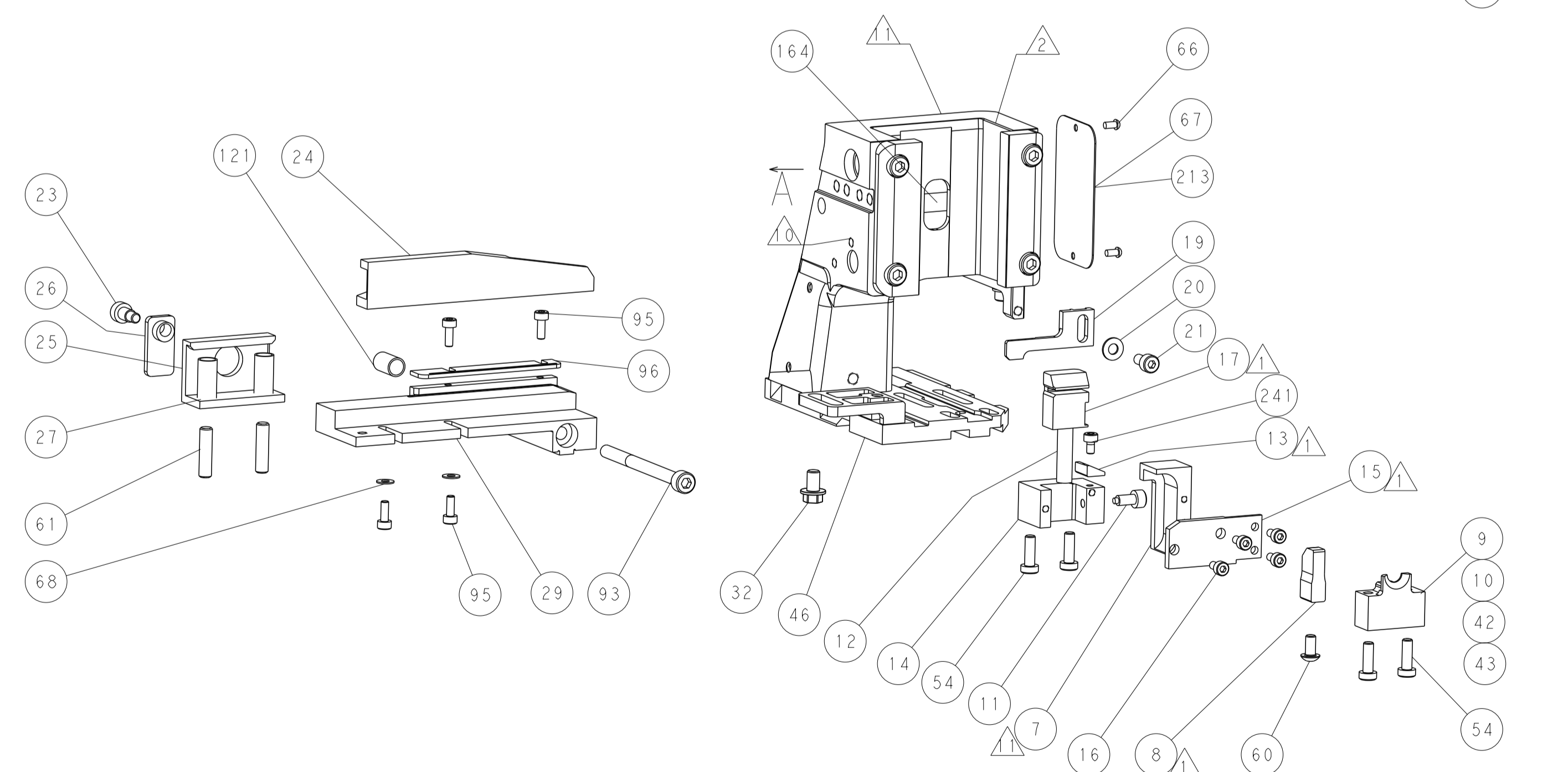
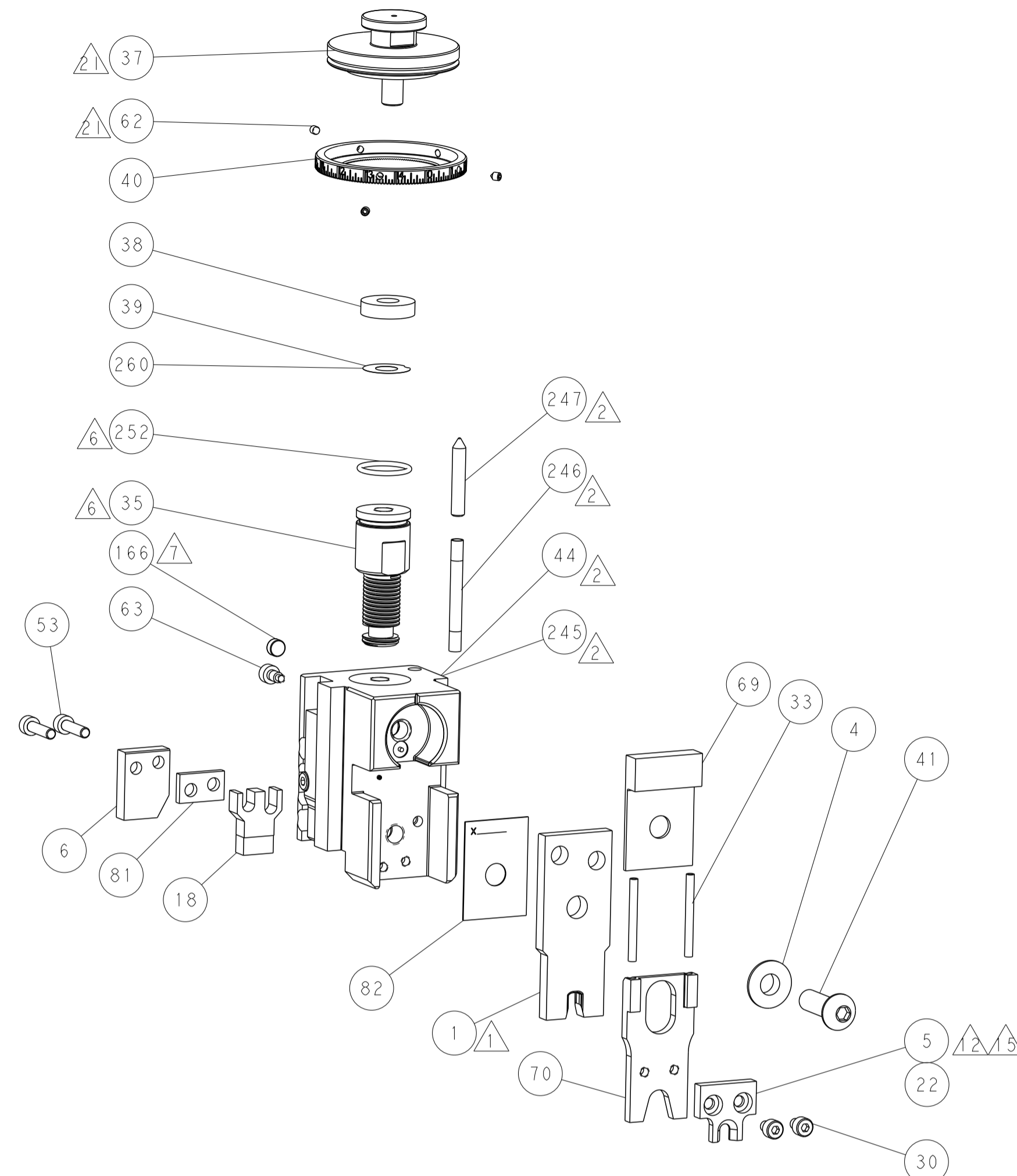
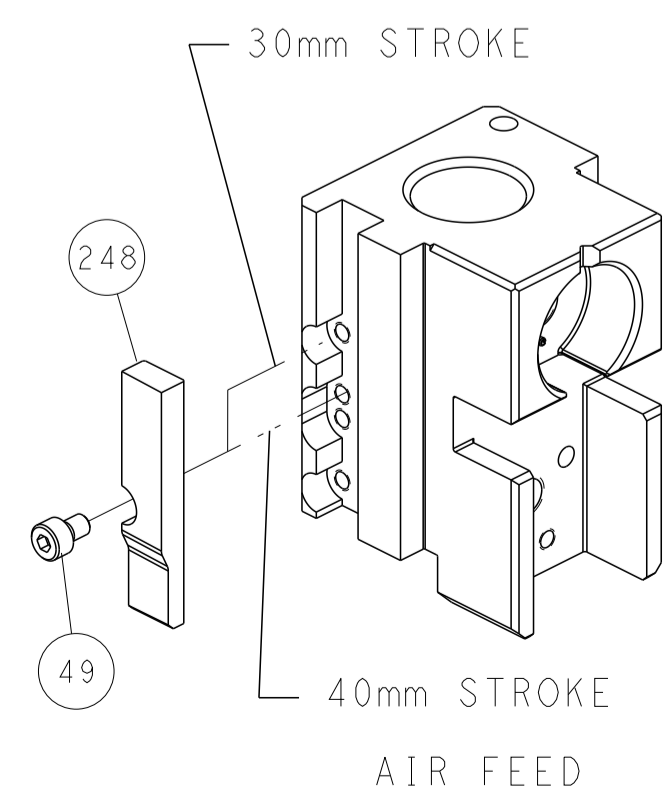


SERVO LATCH PLATE



***FEED FINGER REPRESENTATION ABOVE MAY DIFFER FROM ACTUAL FEED FINGER THAT IS REQUIRED BY THIS APPLICATOR

CAM POSITIONS



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:		OWN	B. WEAVER	17OCT2011	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC	±		CHK	G. HOFFNER	17OCT2011	
	1 PLC	±		APVD	T. ELBIN	17OCT2011	NAME
	2 PLC	±					OCEAN SIDE FEED APPLICATOR
	3 PLC	±					PRODUCT SPEC
	4 PLC	±					APPLICATION SPEC
	ANGLES	±					SIZE
	FINISH	±					CAGE CODE
MATERIAL				WEIGHT			DRAWING NO
							A1 00779
							©=2151032
							RESTRICTED TO
							Customer Accessible Production Drawing
							SCALE 1:1 SHEET 2 OF 4 REV D

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2151032-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	1338685-1	5-18022-5	-	-	-
					SERVO LATCH PLATE	2119951-1	2161540-1	8-2151032-5	1901094-3	1976043-1
	2-2151032-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	-	1338685-1	5-18022-5	-	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1
2-2151032-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2151032-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	.205 [5.21 mm]	Ø
INSUL	.000 [0.00 mm]	-

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: FULLY INSULATED FASTON

WIRE STRIP LENGTH .265-.297 IN [6.73-7.54 mm]	INSULATION DIAMETER RANGE Ø 3
TERMINAL APPLICATION SPECIFICATION 114-2123	

TERMINALS APPLIED 9

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-350815-2	3-520116-2	3-520140-2	5-520150-2
5-350815-2	3-520124-2	3-520140-4	6-520150-2
3-350819-2	9-520124-2	5-520140-2	3-520276-2
5-350819-2		9-520140-2	9-520276-2
3-520106-2		3-520150-2	3-521142-2
		3-521150-2	3-1969626-1

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14 AWG	0.075+/-0.002 [1.91+/-0.05]	6.4	.187 IN [4.750mm]
16, (2)18, OR (3)20	0.070+/-0.002 [1.78+/-0.05]	7.7	.187 IN [4.750mm]

- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151032-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151032-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 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.
- 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.
- ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- ITEMS 5 AND 9 OR ITEMS 10 AND 22 ARE REQUIRED WHEN RUNNING ON A LEADMAKER.
ITEM 42 OR ITEM 43 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- GROUP 1 TERMINALS: Ø .160 IN [4.06mm] MAX INSULATION
GROUP 2 TERMINALS: Ø .260 IN [6.60mm] MAX INSULATION

- USE ITEMS 5, 9, OR 42 WITH GROUP 1 TERMINALS
USE ITEMS 10, 22, OR 43 WITH GROUP 2 TERMINALS
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø .19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
- CALIPERS, CRIMP HEIGHT, SOLDER
- 1.75, 10-32 UNF-28 X .50 DP, RELOCATE THIS STOP TO HOLE OR ADD HOLE, BASE PLATE ASSEMBLY
- IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
- ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

*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.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.

ITEM NO	DESCRIPTION	ITEM NO
- REF REF REF	462992-5 GUARD ASSY	257
- REF REF REF	679532-1 INSERT, GUARD	256
- 1 1 1	189728-1 BRACKET, SPACER	255
- 1 1 1	568681-1 SPACER, BASE PLATE	253
- 1 1 1	2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- - - 1	2119640-1 PUSH ROD, AIR FEED	250
- - - 1	1803259-1 BUSHING, FLANGED	249
- 2 2 2	1-22279-3 SPRING, COMPRESSION	246
- 1 1 1	18023-1 SCR, SKT HD CAP M3 X 5.0	241
- - 2 -	2168400-6 SHCS, LOW HEAD, RoHS, M5 X 16	240
- - - -	2119580-1 MECHANICAL FEED ASSEMBLY	239
-77 -27 -25 -22	PART NO DESCRIPTION	ITEM NO

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 2119599-1
 LOC A DIST 66

REV	DATE	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

REV	DATE	DESCRIPTION	DATE	OWN	APVD
-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1901094-3	SPACER, FEEDER	198
-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	240638-1	SPRING, FEED FINGER	163
	-	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
-	-	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2119798-2	DETENT PIN	145
-	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	1	2-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
	-	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	2119799-1	HOLDER, FEED FINGER, AF	136
	-	REF	-	SEE NOTE 4 MEMORY CHIP, PROGRAMMED	135
-	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	240641-6	SPACER	81
-	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	2161332-1	DEPRESSOR, WIRE FUNNEL	70
-	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
-	2	2	1-18028-4	WASHER, FLAT, REG M3	68
-	1	-	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	462427-2	FINGER, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	462433-7	SUPPORT, INSULATION	43
	-	1	462433-6	SUPPORT, INSULATION	42
-	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	2119644-2	RAM WASHER, PRECISION	38
-	2	2	5-22278-1	SPRING, COMPRESSION	33
-	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
-	1	1	2161336-1	PLATE, REAR STRIP GUIDE	29
-	2	2	22281-9	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	684042-4	GUIDE, STRIP, FRONT	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	462431-5	WIRE FUNNEL	22
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	463460-3	HOLD DOWN, TERMINAL	18
	-	1	469542-3	REAR FLOATING SHEAR	17
-	4	4	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	-	1	2161335-2	SHEAR PLATE, REAR	15
-	1	1	2119862-2	SHEAR HOLDER, REAR	14
	-	1	2280441-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	356885-4	STOP, SHEAR	11
	-	1	462843-6	TERMINAL SUPPORT	10
	-	1	462843-5	TERMINAL SUPPORT	9
	1	1	464282-2	ANVIL, SAND-BLASTED 16-14	8
	-	1	803925-2	GUIDE, CARRIER SCRAP	7
-	1	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
	-	1	462431-4	WIRE FUNNEL	5
-	1	1	238009-3	BLOCK, FL CRIMPER SPACER	4
	1	1	464281-1	CRIMPER, SEMI FLAT 16-14	1
-77 -27 -25 -22	PART NO	DESCRIPTION	ITEM NO		

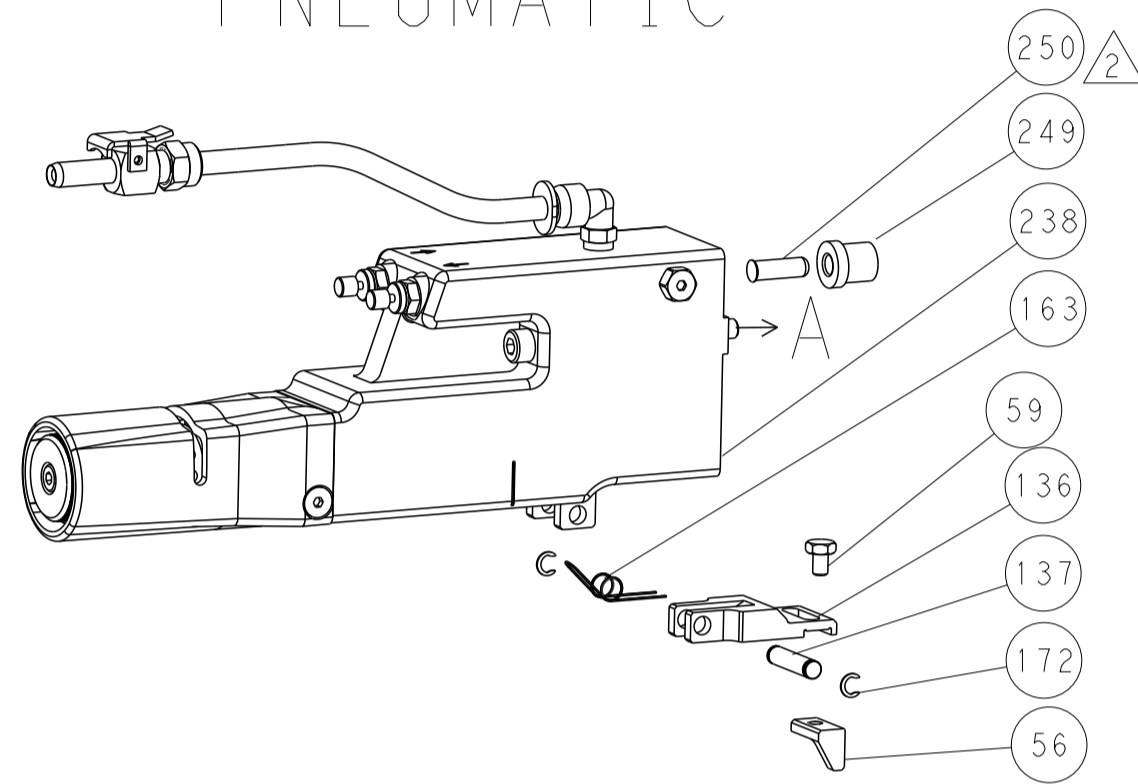
TE Connectivity
 Harrissburg, PA 17105-3608

OCEAN SIDE FEED APPLICATOR

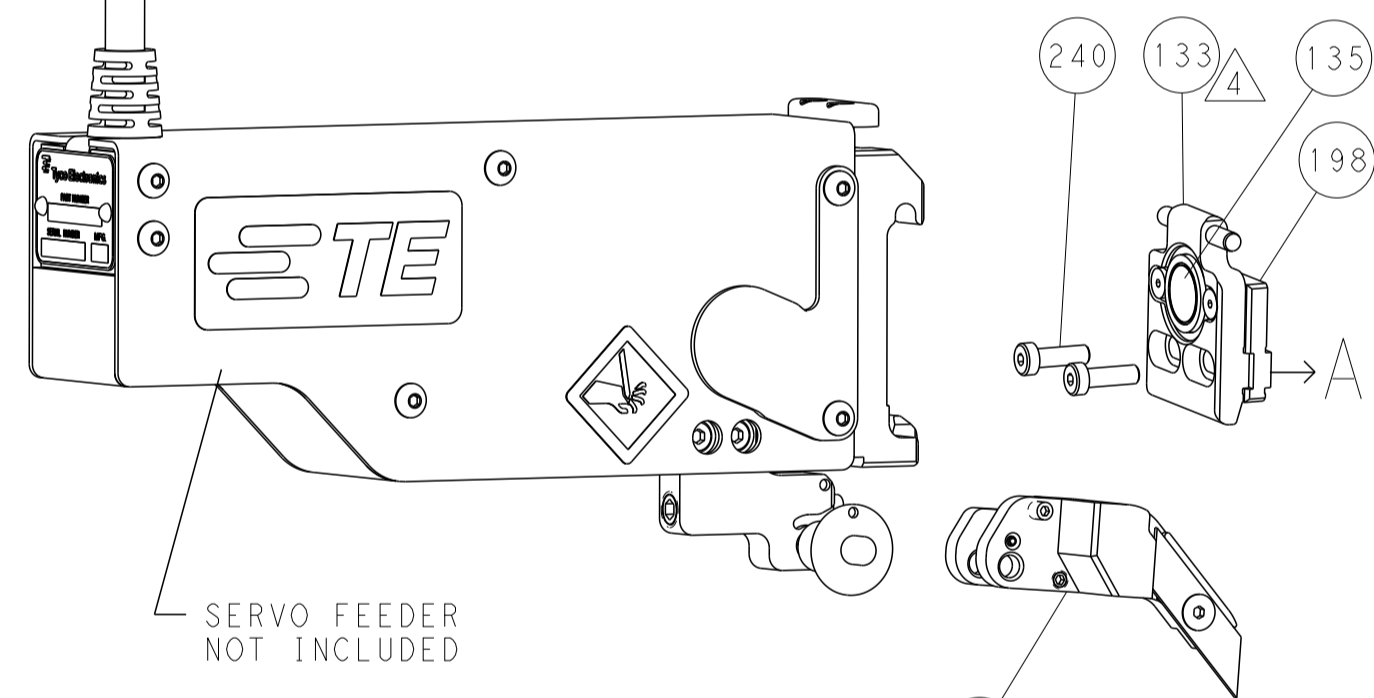
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV D

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

FEED TYPE PNEUMATIC

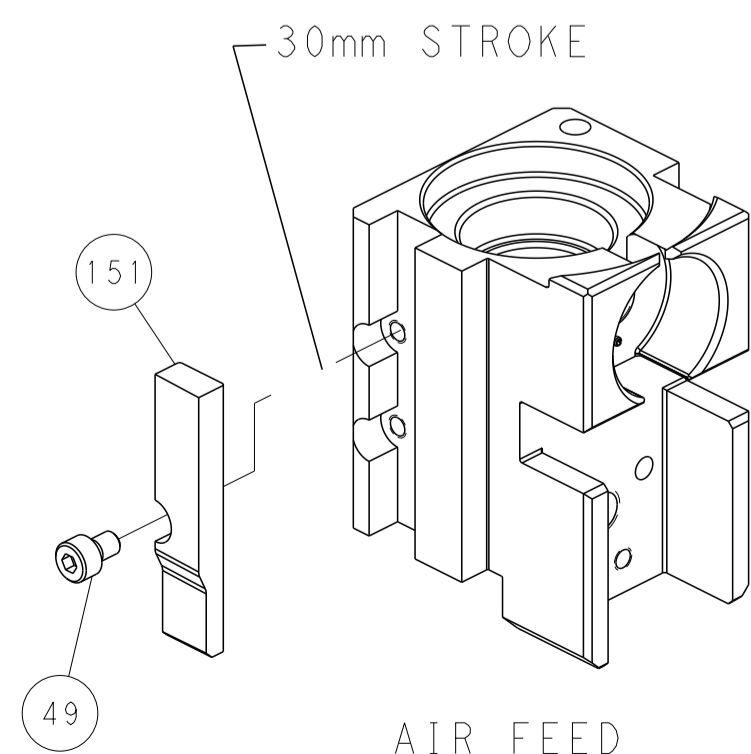


SERVO LATCH PLATE

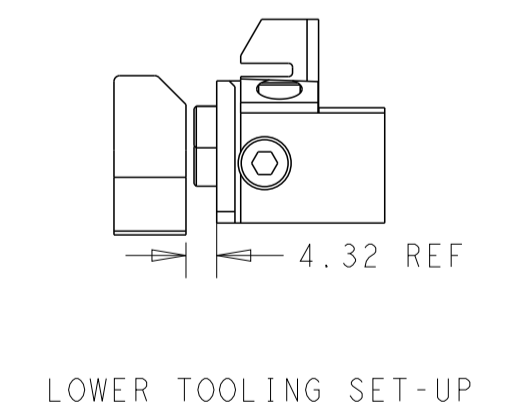
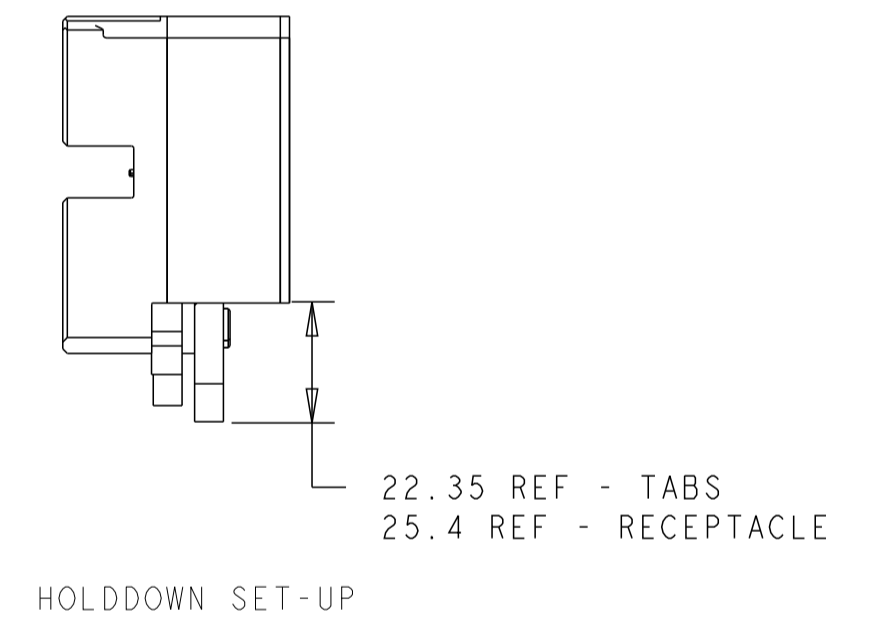
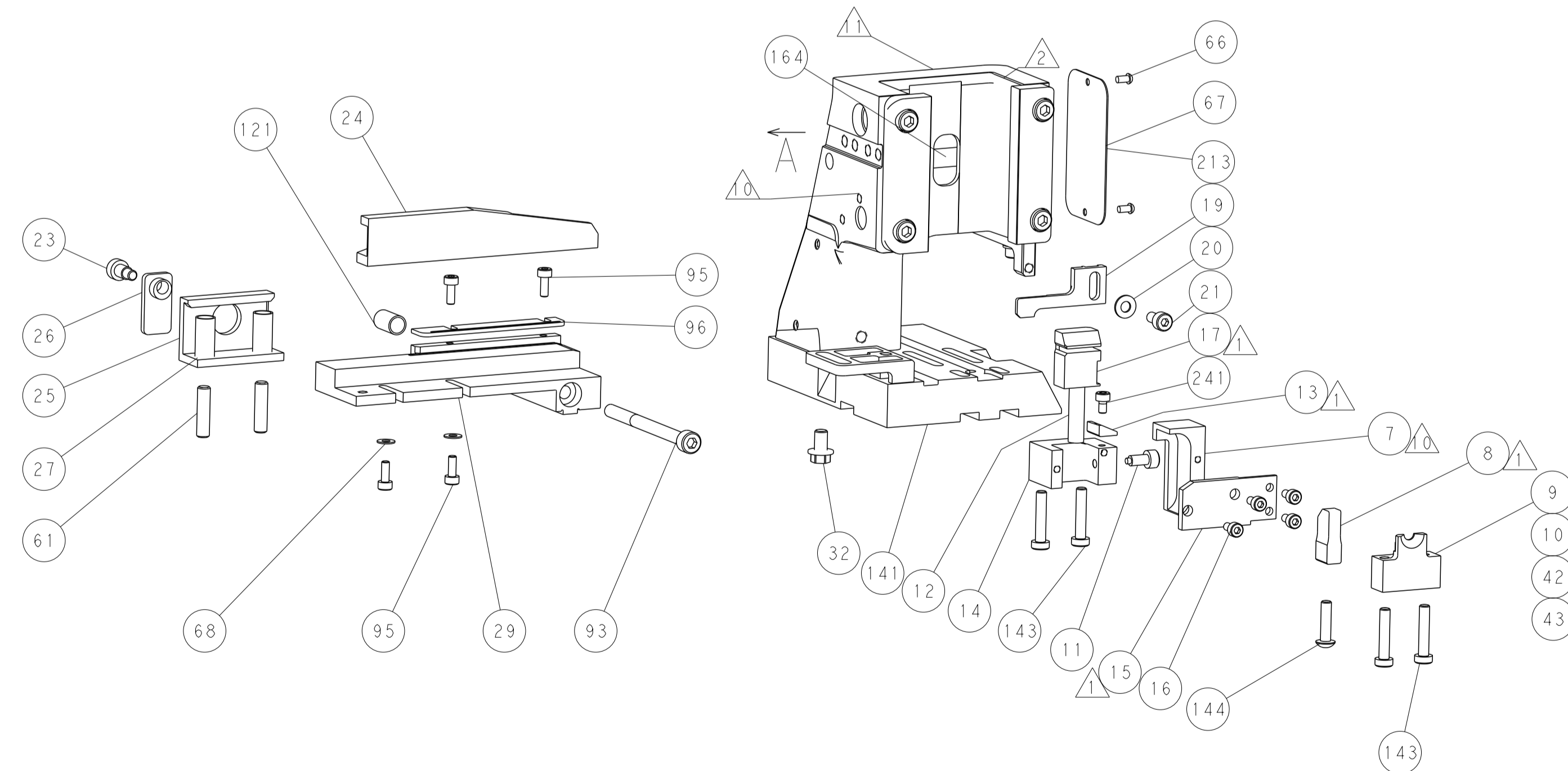
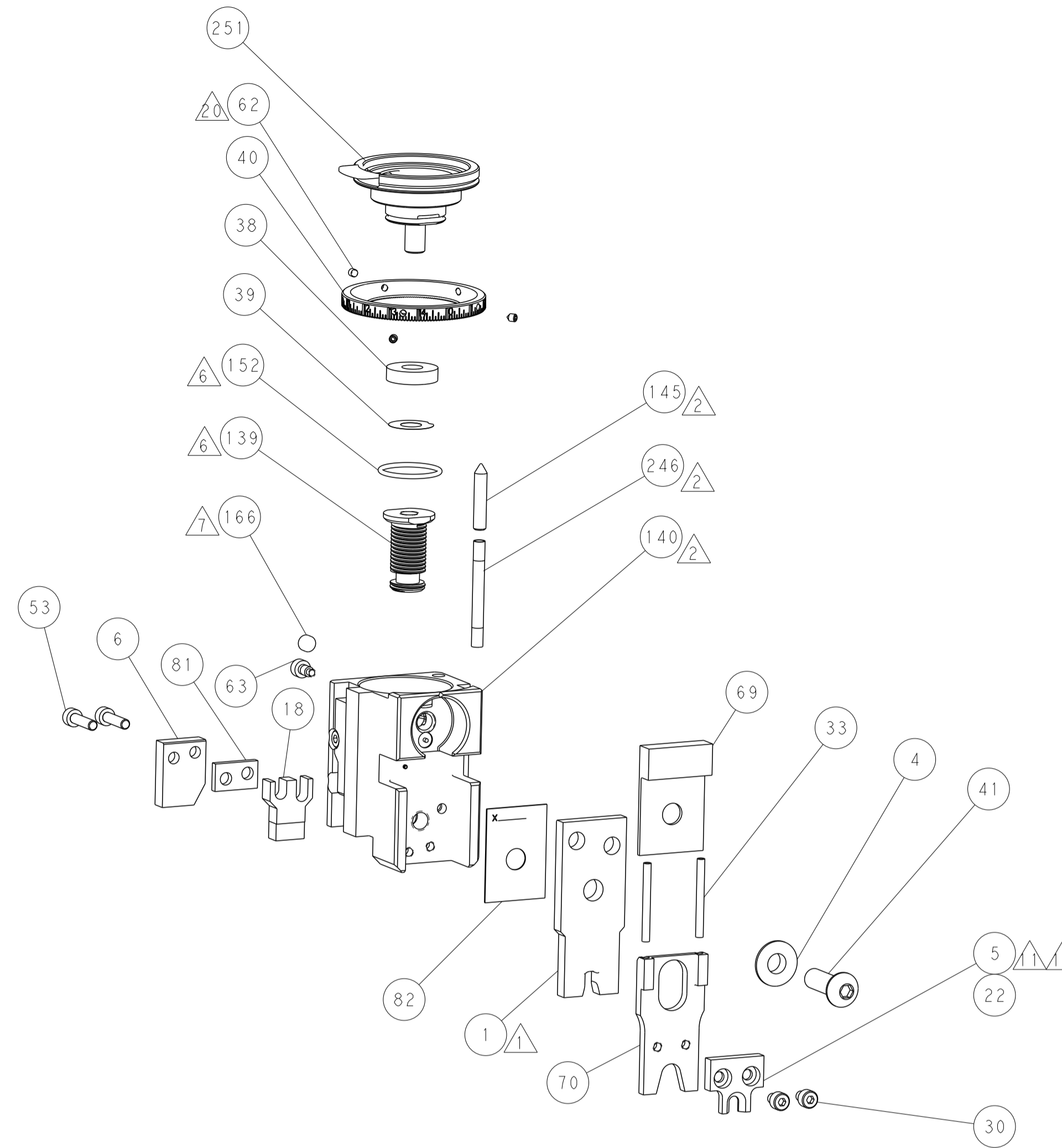


***FEED FINGER REPRESENTATION ABOVE MAY DIFFER FROM ACTUAL FEED FINGER THAT IS REQUIRED BY THIS APPLICATOR

CAM POSITION



AIR FEED



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 B. WEAVER 17OCT2011		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK G. HOFENER 17OCT2011	NAME		
MATERIAL				APVD T. ELBIN 17OCT2011	PRODUCT SPEC		
					APPLICATION SPEC		
				WEIGHT	SIZE	CAGE CODE	DRAWING NO
					A1	00779	©=2151032
				Customer Accessible Production Drawing		SCALE	1:2 SHEET 4 OF 4 REV D