

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151692-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151692-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151692-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151692-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2151692-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	-	8-2151692-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151692-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151692-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
				-	-	-	-	-	-	-	
2151692-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151692-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.94 mm [.155]	O

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO POWER QUADLOK SOCKET CONTACT, SWS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.10 mm [.138-.161 IN]		Ø 3.4mm MAX [.134 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-18141-1		
	114-18141-10 ⁵		

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
968680-2	1-968681-5	967610-1	
968681-2	2-968681-5		
968681-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.15+/-0.03 [.045+/-0.001]	6.6
0.35mm2	1.08+/-0.03 [.043+/-0.001]	7.4

- 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: 8-2151692-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151692-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151692-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151692-6
- 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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
- 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
- ¹³ THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION DIA QUOTED IS OUTSIDE DIAMETER OF SEAL. WIRE INSULATION DIA IS DEPENDENT ON SEAL BEING APPLIED. SEAL PN 967610-1 INS. DIA RANGE IS Ø1.4-2.1mm [.055-.083 IN].
- ¹⁴ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- ¹⁵ CRIMPER & ANVIL DIMENSIONS CONFORM WITH 114-18141-10 SPEC.

***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
			A	RELEASED	04SEP2012	LG GB
			A1	ECR-14-008728	11JUN2014	KH UG

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	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	2119798-1	DETENT PIN	247
-	-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	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	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	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	1	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	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	-	-	1	1338685-1	PAWL, FEED	56
-	-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	2	2	2	2	1-18023-1	SCR, SKT HD CAP M4 X 10.0	53
-	-	-	-	-	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	2119644-1	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	1-1752356-8	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	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	-	1	1	1	1	1320928-1	STRIP GUIDE	24
-	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	-	3	3	3	3	1-18028-2	WASHER, FLAT, REG M4	20
-	-	1	1	1	1	2119533-3	STRIPPER, SIDE FEED	19
-	-	1	1	1	1	879657-2	HOLD DOWN	18
-	-	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	318707-1	FLOATING SHEAR, FRONT	9
-	-	1	1	1	1	1-1633129-9	ANVIL, COMBINATION .062	8
-	-	1	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	-	-	6
-	-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	-	1	1	1	1	3-1633965-7	CRIMPER, INSULATION O PREMIUM	3
-	-	1	1	1	1	1-455888-8	SPACER, CRIMPER	2
-	-	1	1	1	1	9-657555-1	CRIMPER, WIRE PREMIUM	1

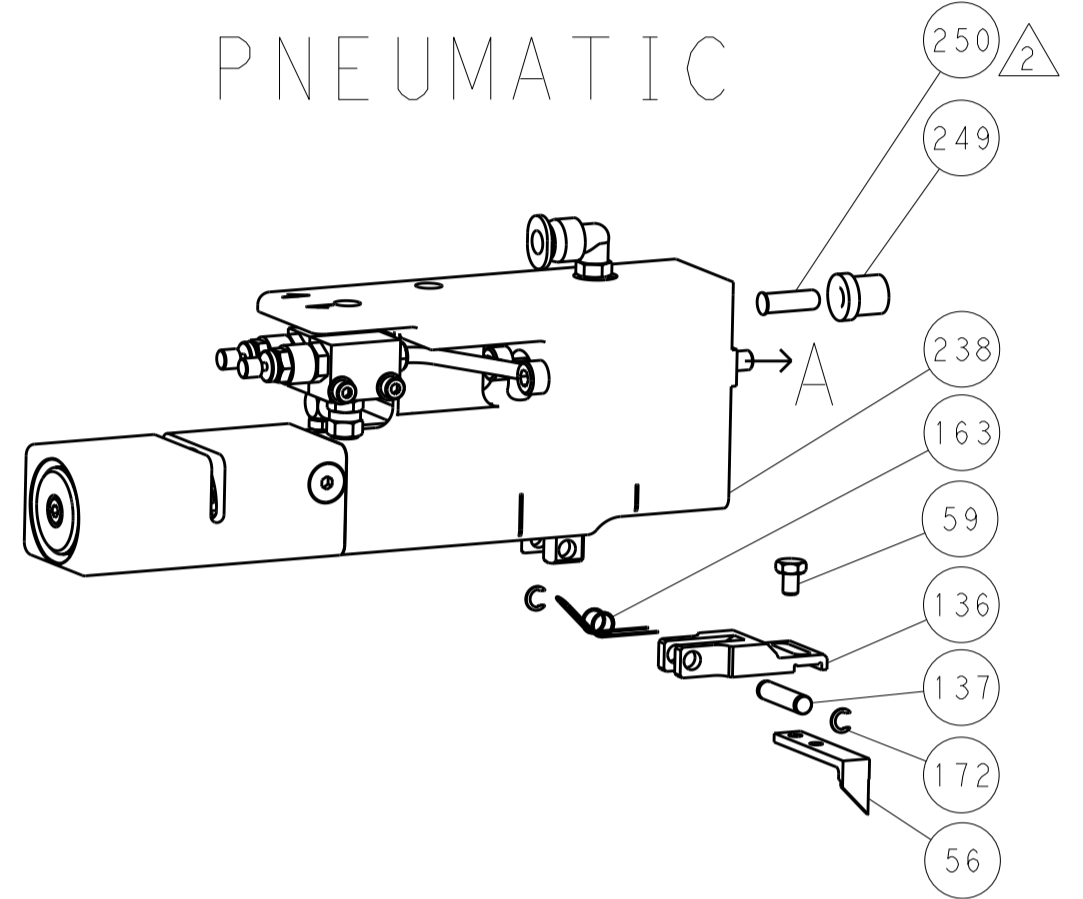
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MATERIAL:	FINISH:	WEIGHT:	APPLICATOR SPEC:		APPLICATOR SPEC:		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
			-		-		A1	00779	©=2151692		
Customer Accessible Production Drawing		SCALE	SHEET		1 OF 4		REV	A1			

LOC	DIST	REV	DATE	BY	APPV
A	66				

FEED TYPE MECHANICAL



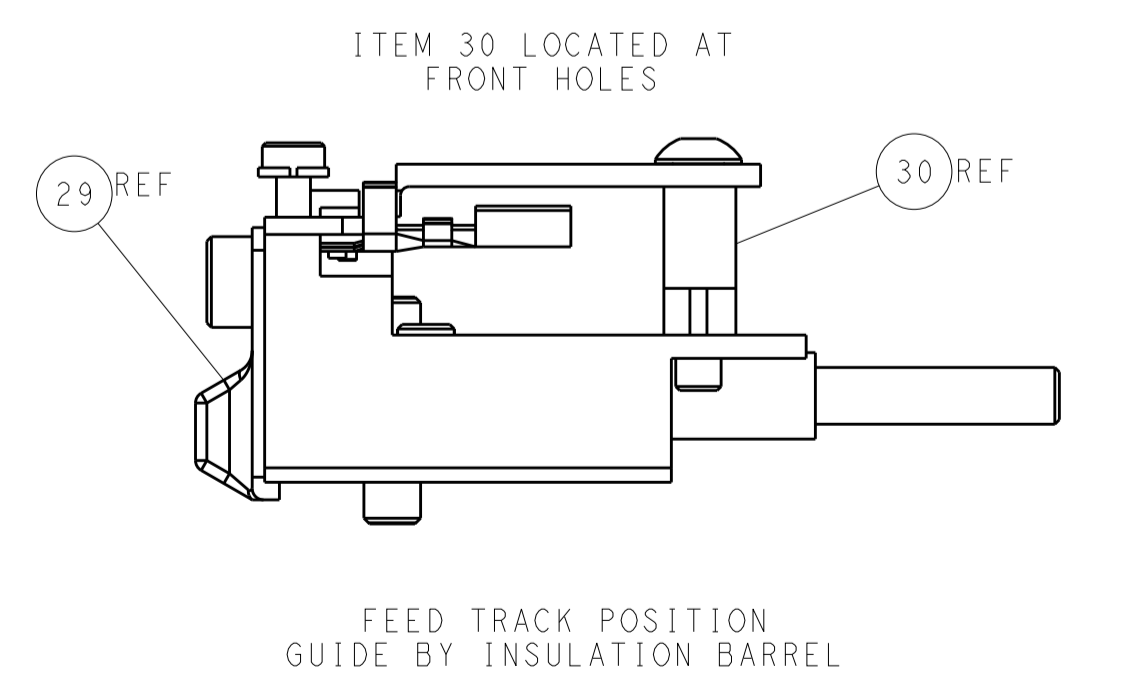
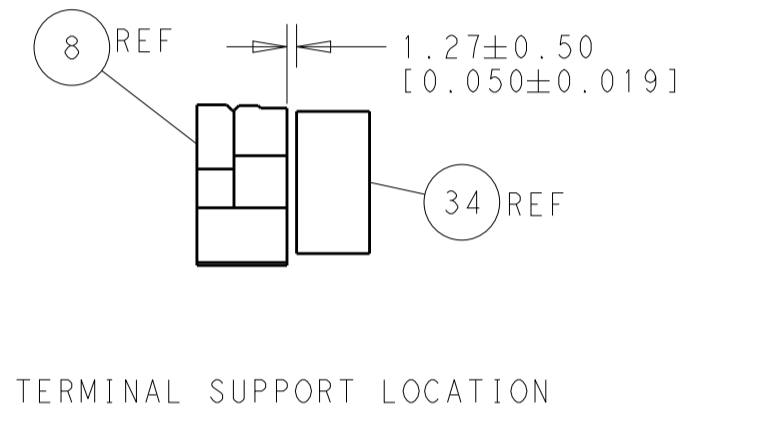
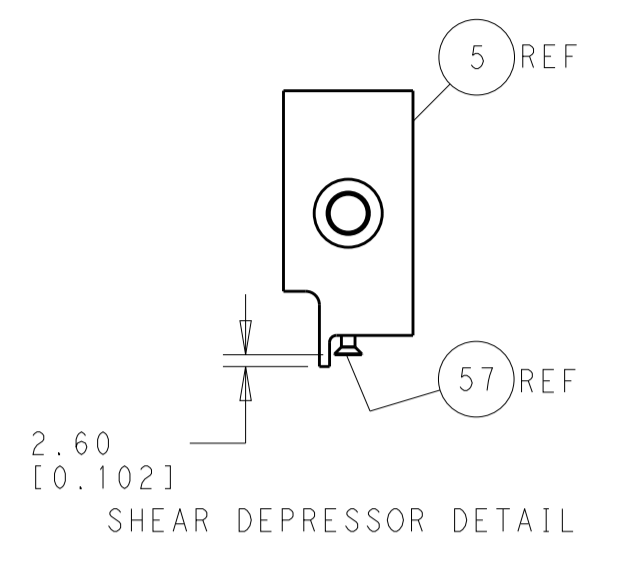
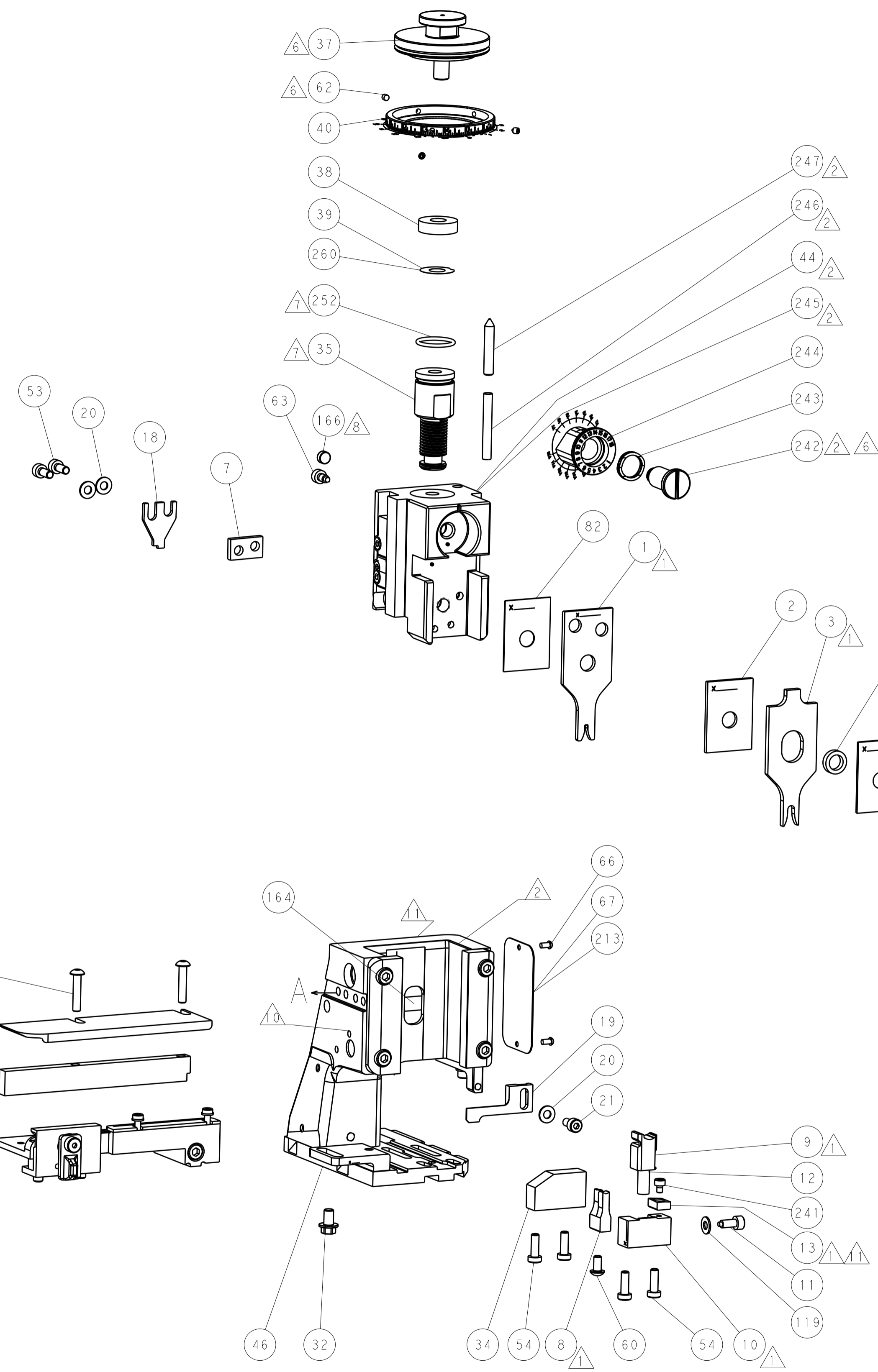
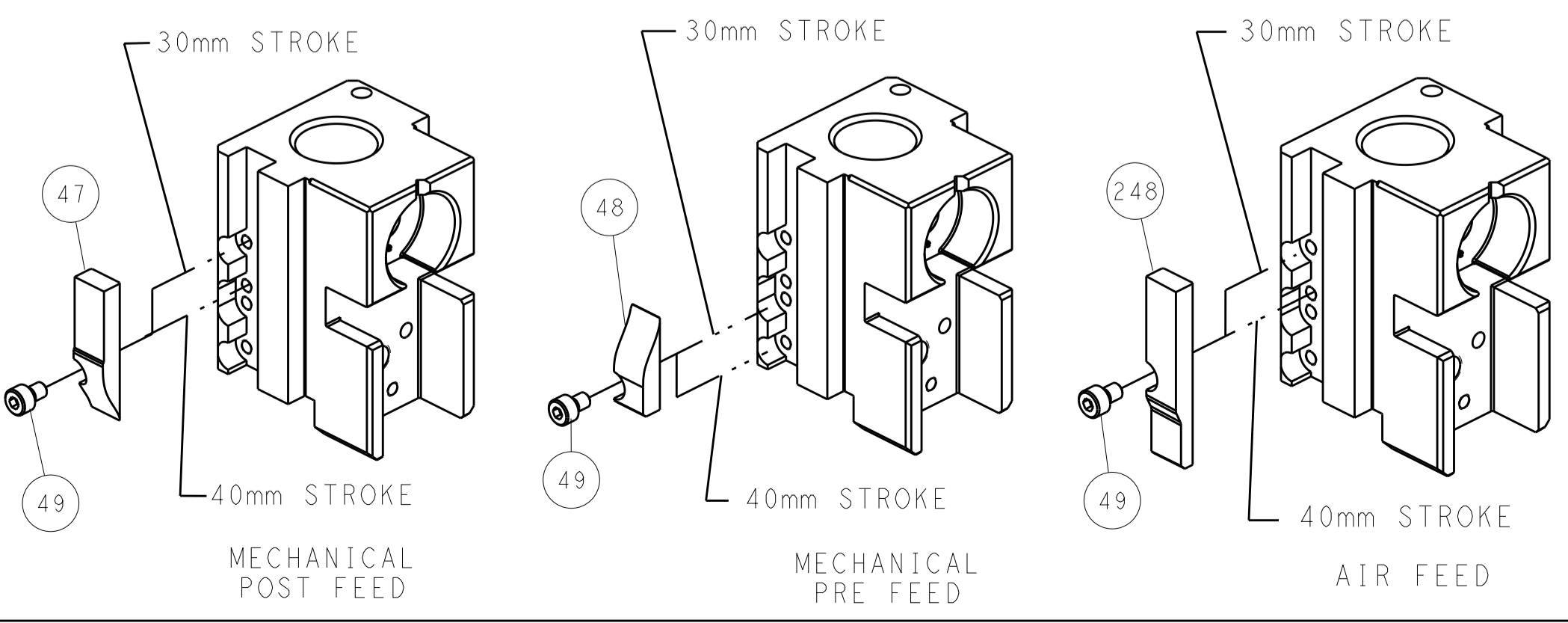
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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

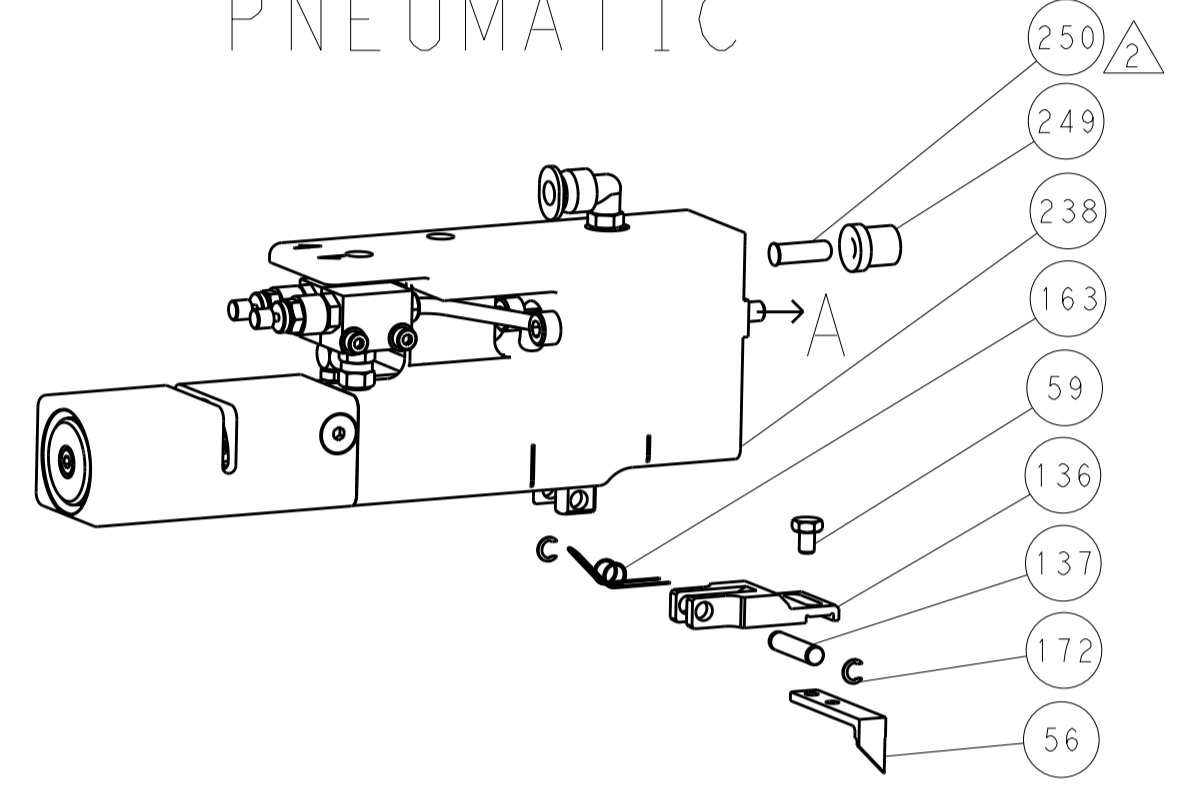
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	1 PLC	±	0.5	APPV	S. XI	29JUN2012	29JUN2012
	3 PLC	±	0.13	NAME			
	4 PLC	±	0.013	PRODUCT SPEC			
	ANGLES	±	0.0001	APPLICATION SPEC			
MATERIAL	FINISH			WEIGHT	A1 00779		C=2151692
Customer Accessible Production Drawing				SCALE	1:2	SHEET	2 of 4

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

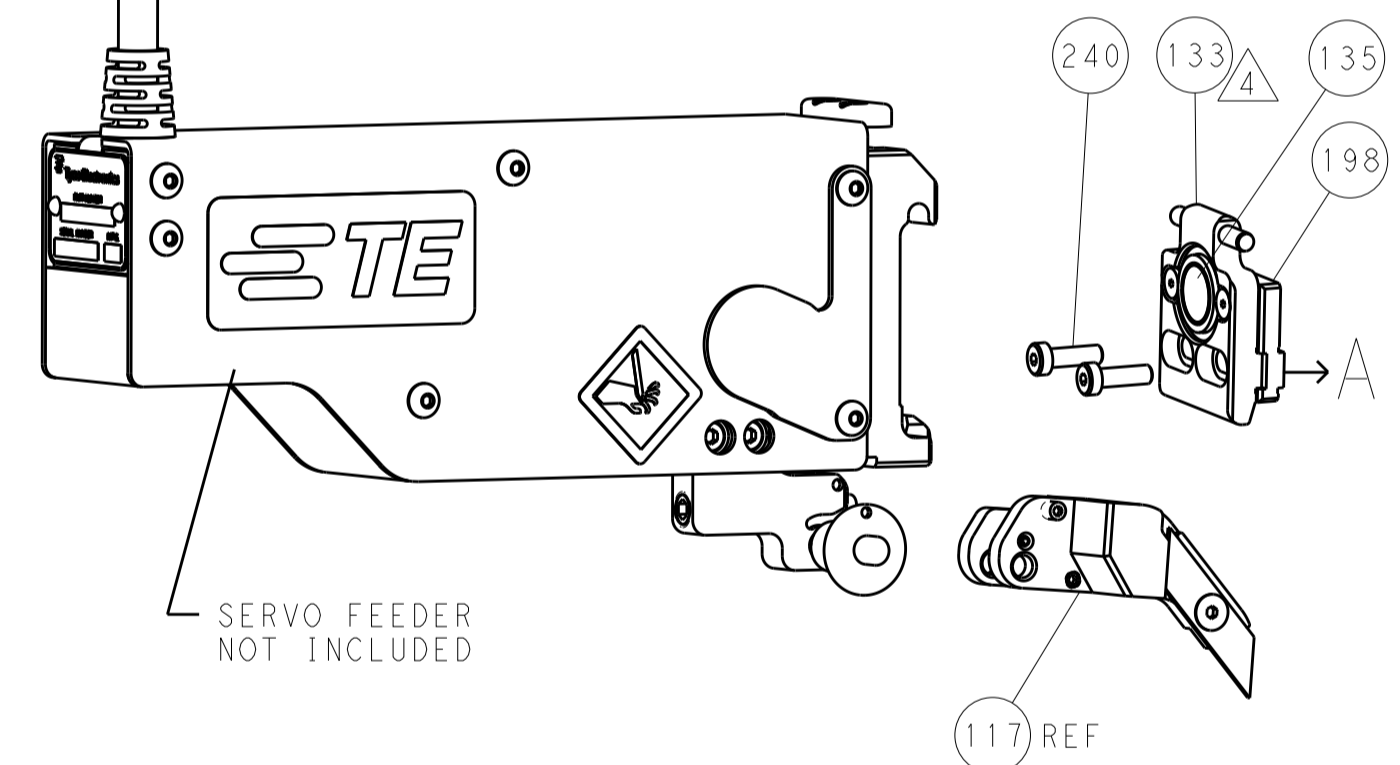
FEED TYPE MECHANICAL



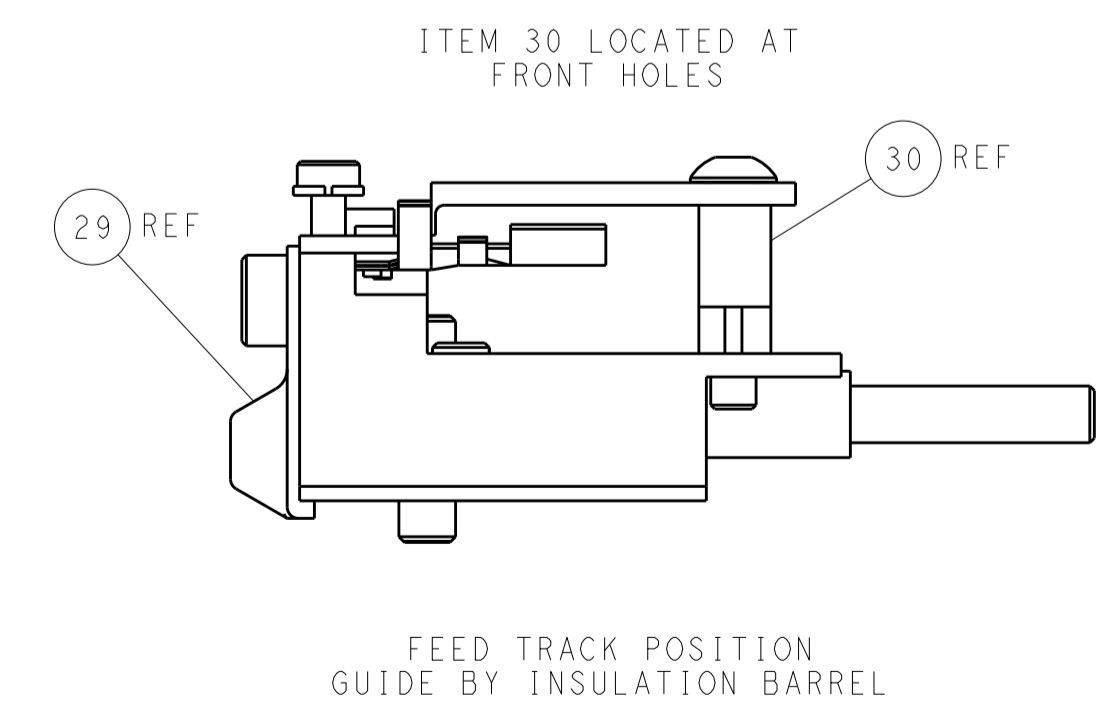
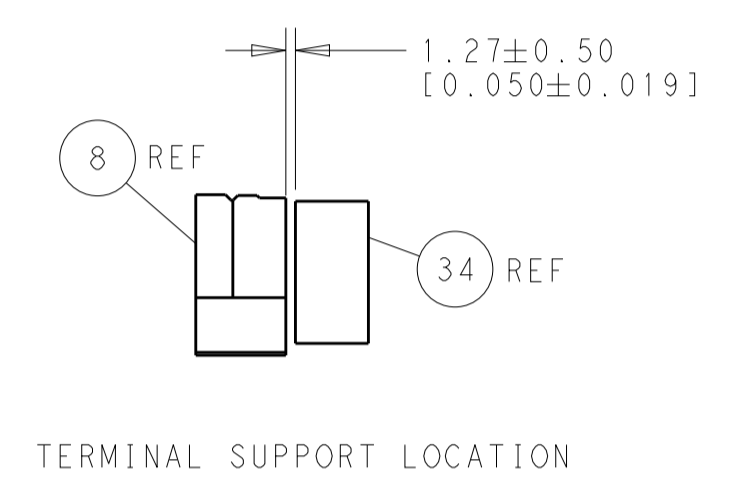
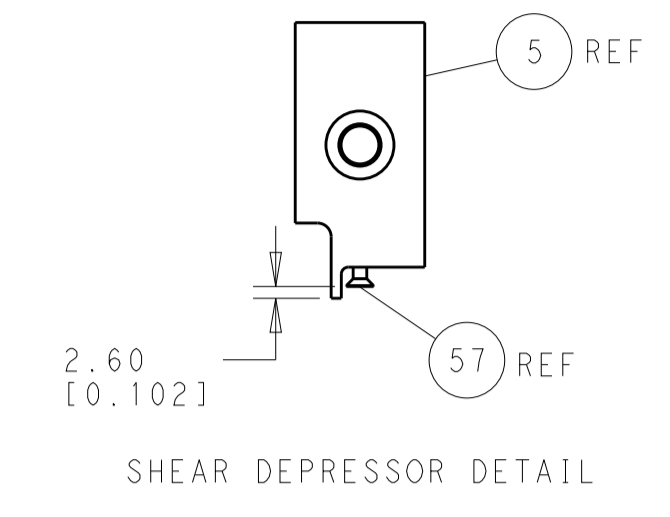
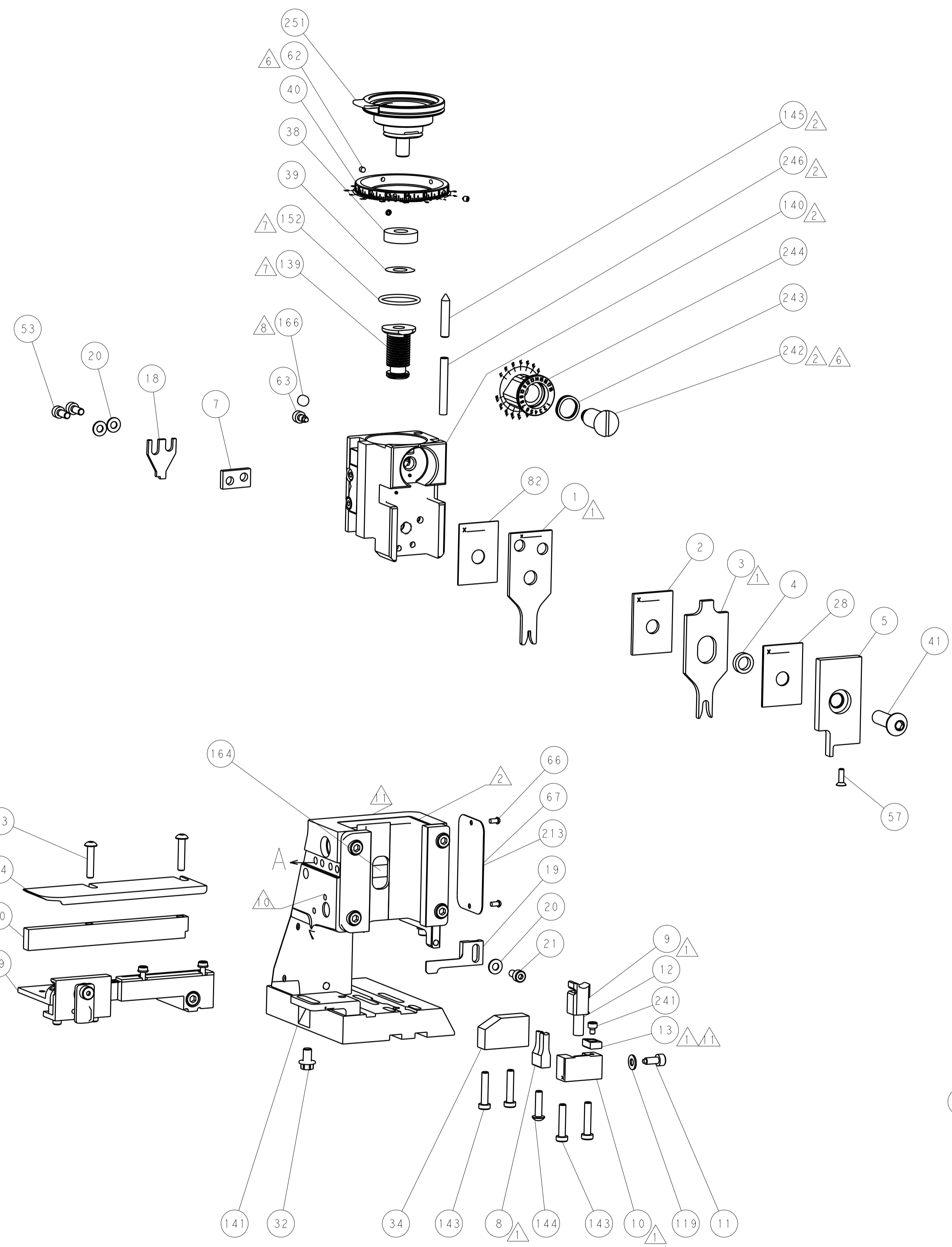
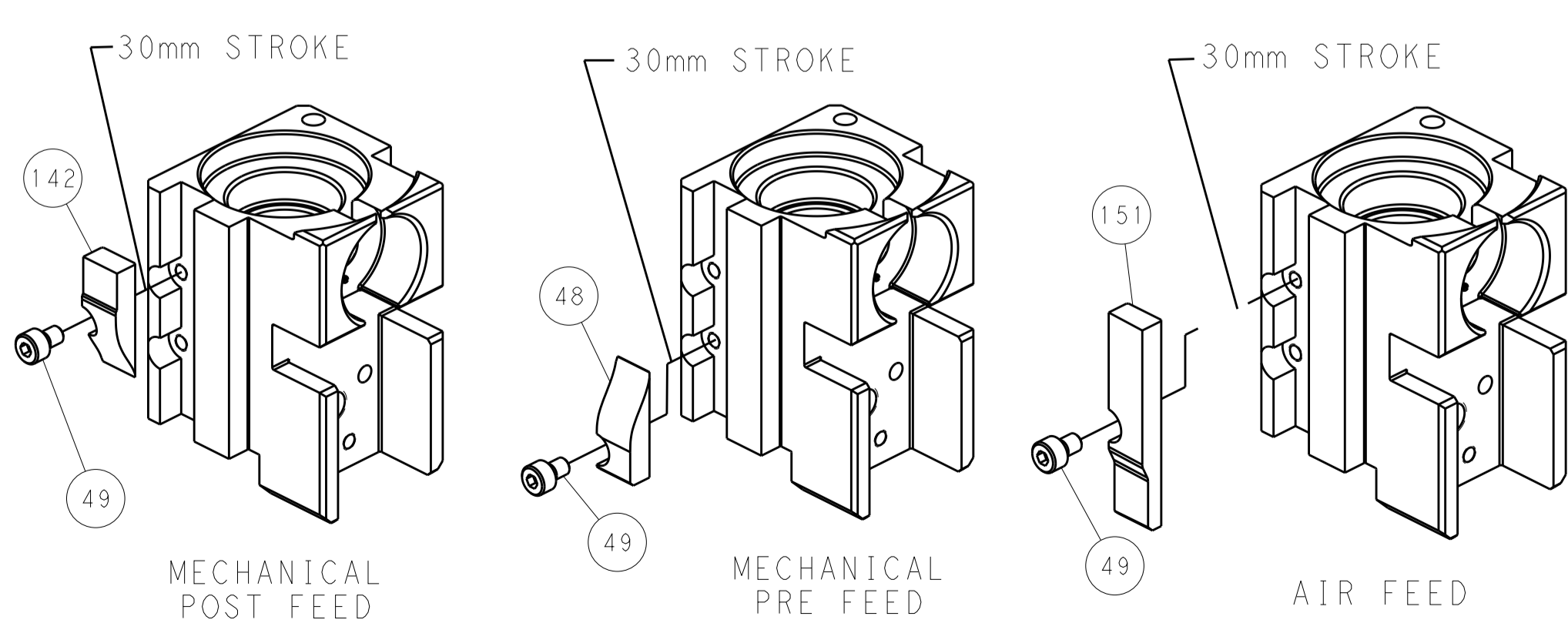
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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 Y. YIN 29JUN2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD S. XI 29JUN2012	NAME Ocean Side Feed Applicator
MATERIAL	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
-	-	-	1:2	A1	00779	©=2151692	-
Customer Accessible Production Drawing				SHEET 4 OF 4 REV A1			