

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151932-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE SMART APPLICATOR	2119951-1	-	8-2151932-5	1901094-3	2-1752354-3	2168400-6 (QUANTITY 2)
	2151932-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151932-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>12</sup>	-	-	-	-	-	-	-
	2151932-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151932-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
INSUL	2.45 mm [.096]	OV
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: 2.8 FEMALE TERMINAL SICMA 3			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-4.70 mm [.169-.185 IN]		Ø1.30-2.10 mm [.051-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	FCI SPEC Rev F		
TERMINALS APPLIED <sup>10</sup>			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
2113335-1	211CC3S1160	2113335-2	211CC3S1150
2113335-3	211CC3S1460	2113335-4	211CC3S1190

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35±0.35	1.25+/-0.04 [.049+/- .002]	6.0
0.50mm2	1.17+/-0.04 [.046+/- .002]	7.1
0.35mm2	1.09+/-0.04 [.043+/- .002]	7.8

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151932-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151932-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151932-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 180.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> 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.
- <sup>12</sup> WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.55.

**\*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 NO	DESCRIPTION	ITEM NO
-77	APPLICATOR SHIM PACK	260
-1	O-RING, .676 ID, .070 DIA. MAT.	252
-	PUSH ROD, AIR FEED	250
-77	PART NO	DESCRIPTION

**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	OWN	APVD
			A	RELEASED	10OCT2014	LG TE

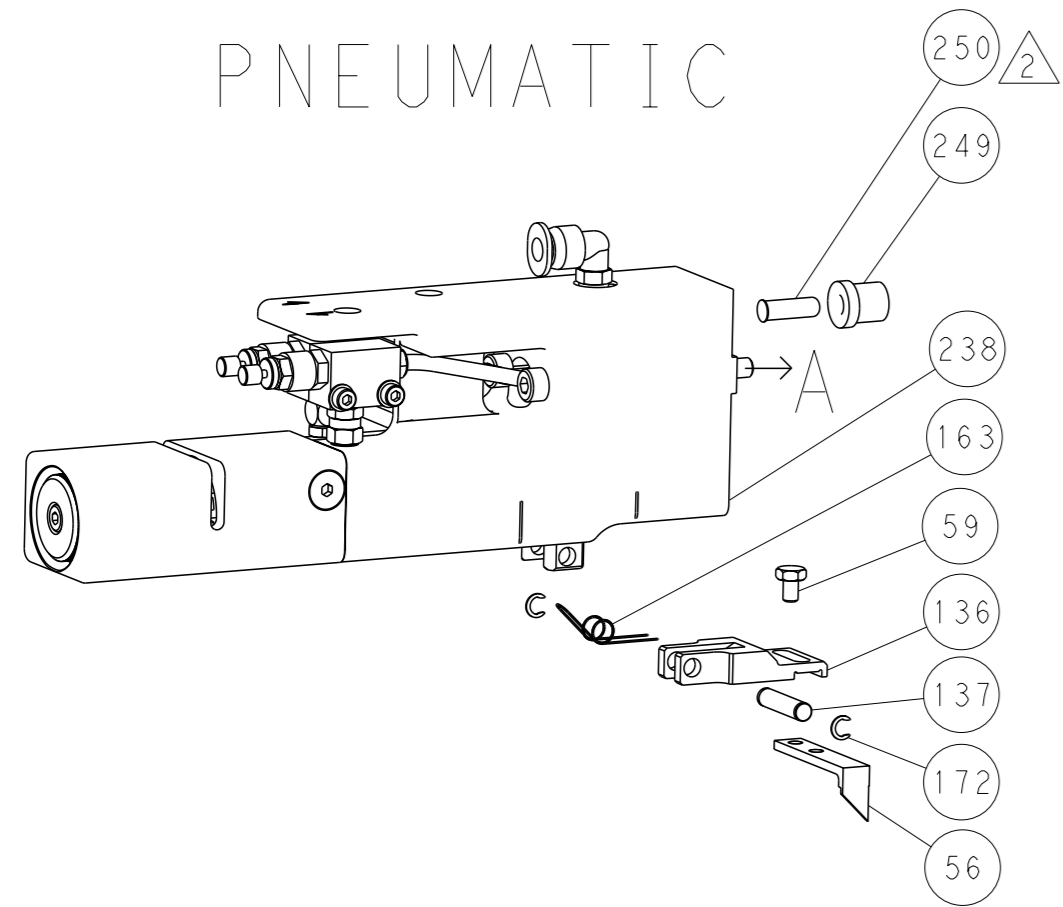
REV	DATE	OWN	APVD	DESCRIPTION	ITEM NO
-	-	-	-	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	FEED CAM, AIR FEED	248
-	1	-	1	DETENT PIN	247
-	1	-	1	SPRING, COMPRESSION	246
-	-	1	-	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	RETAINER, INSULATION DIAL	242
-	1	1	1	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	2	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	AIR FEED MODULE	238
-	-	1	1	TAG, IDENTIFICATION	213
-	-	1	1	SPACER, FEEDER	198
-	1	1	1	STANDOFF, HOLD-DOWN	180
-	1	1	1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	SPRING, COMPRESSION	176
-	1	1	1	GUIDE PIN, HOLDDOWN	175
-	1	1	1	GUIDE PIN, HOLDDOWN	174
-	-	-	2	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	COUNTER, MAGNETIC	164
-	-	-	-	SPRING, FEED FINGER	163
-	-	-	-	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	HOLDER, FEED FINGER, AF	136
-	-	REF	REF	SEE NOTE 4	135
-	-	1	1	SERVO FEED LATCH ASM	133
-	1	1	1	WASHER, FLAT, REG M4	119
-	-	REF	REF	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	SPACER, CRIMPER	82
-	1	1	1	DOCUMENTATION PACKAGE	71
-	1	1	1	DEPRESSOR, WIRE	70
-	1	-	-	TAG, IDENTIFICATION	67
-	2	2	2	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	-	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	1	1	1	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	PAWL, FEED	56
-	4	4	4	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	1	1	1	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	HOLDDOWN, TERMINAL	51
-	-	-	-	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	-	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	-	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	-	APPLICATOR SHIM PACK	39
-	1	1	1	RAM WASHER, PRECISION	38
-	1	1	1	FA HEAD, ATLANTIC STYLE	37
-	1	-	-	BOLT, ADJUSTMENT	35
-	1	1	1	SUPPORT, TERMINAL	34
-	2	2	2	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	1	1	1	SPACER, STRIP GUIDE	30
-	1	1	1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	SPACER, CRIMPER	28
-	1	1	1	STRIP GUIDE	24
-	1	1	1	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	WASHER, FLAT, REG M4	20
-	1	1	1	STRIPPER, SIDE FEED	19
-	1	1	1	INSERT, SHEAR	13
-	1	1	1	SPRING, COMPRESSION	12
-	1	1	1	STOP, SHEAR	11
-	1	1	1	SHEAR HOLDER, FRONT	10
-	1	1	1	FLOATING SHEAR, FRONT	9
-	1	1	1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1	DEPRESSOR, SHEAR	5
-	1	1	1	BLOCK, CRIMPER SPACER	4
-	1	1	1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	-	-	-	-	2
-	1	1	1	CRIMPER, WIRE	1
-77	-7	-6	-5	PART NO	DESCRIPTION

DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH	OWN S. ALVES 09APR2013 CHK P. BARLETTA 09APR2013 APVD C. LIMA 09APR2013 PRODUCT SPEC APPLICATION SPEC	NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151932 RESTRICTED TO
MATERIAL		WEIGHT	Customer Accessible Production Drawing SCALE 1:2 SHEET 1 of 4 REV A

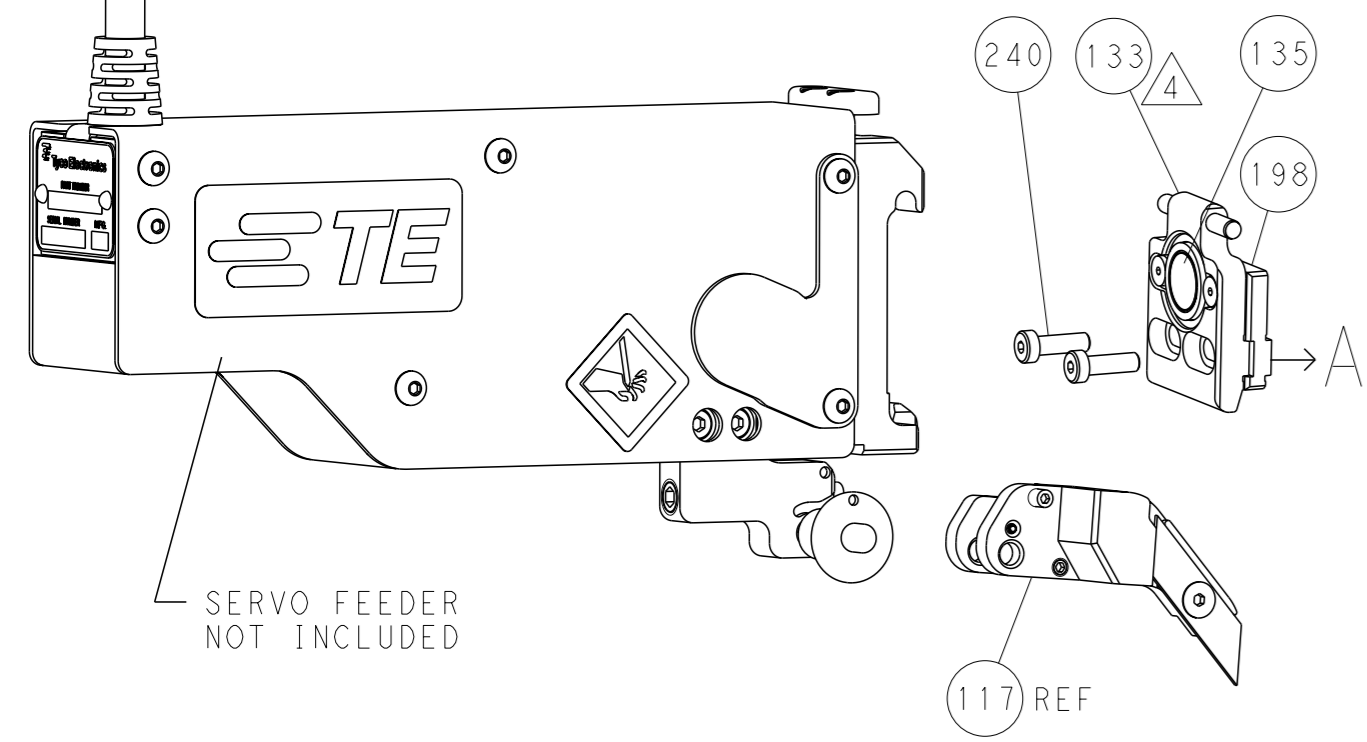
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

### FEED TYPE

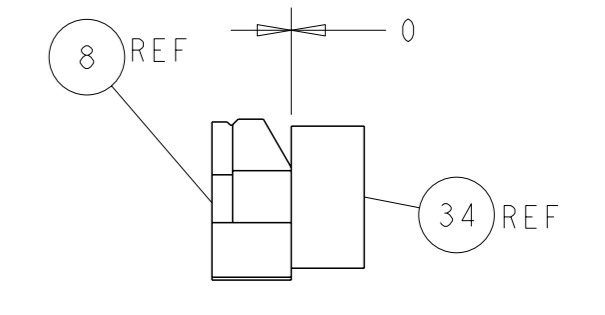
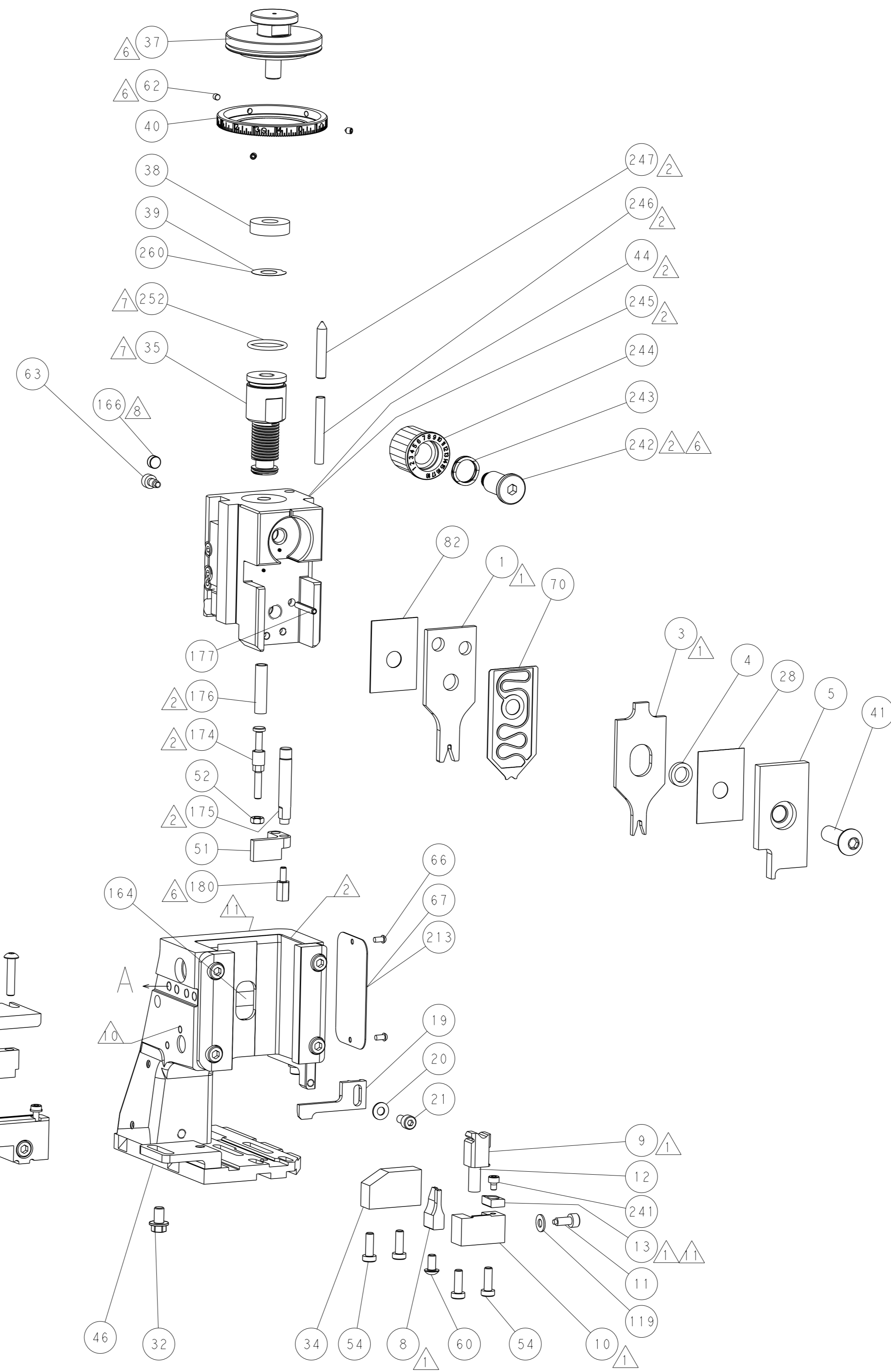
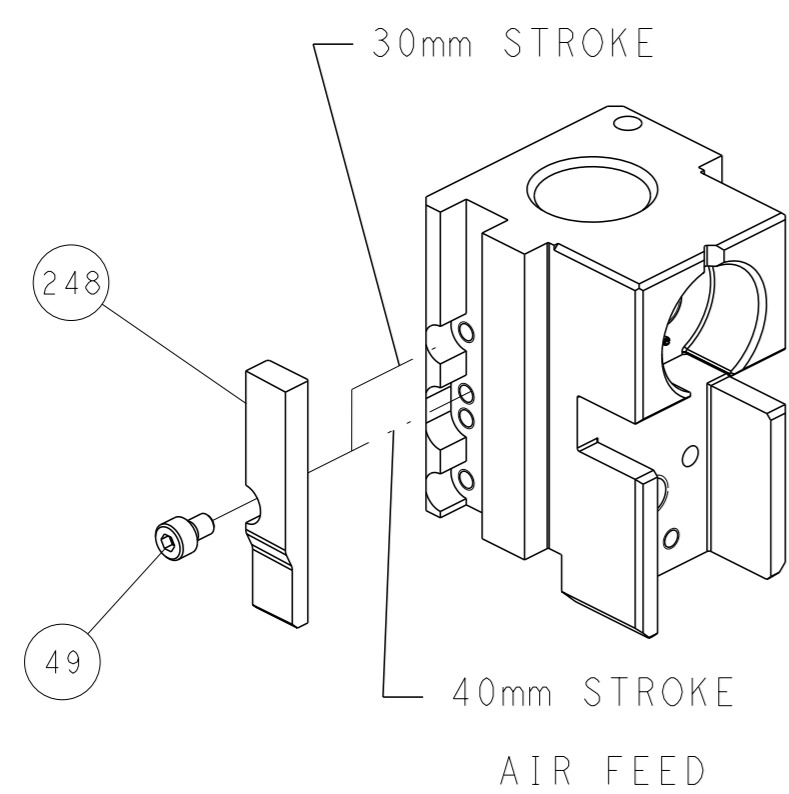
### PNEUMATIC



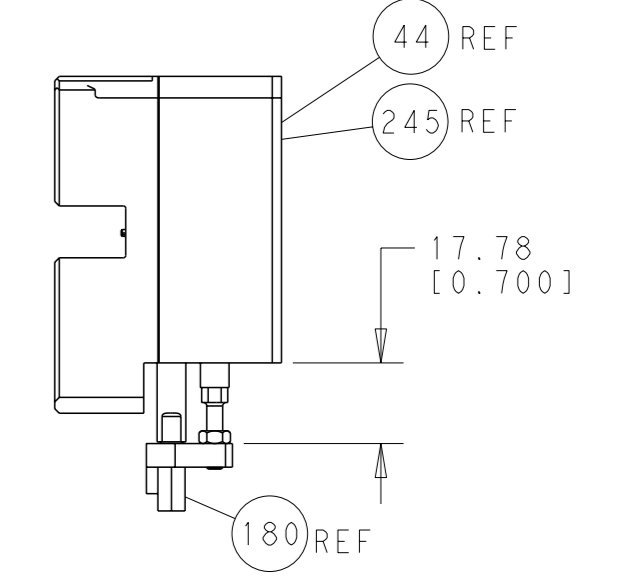
### SERVO LATCH PLATE



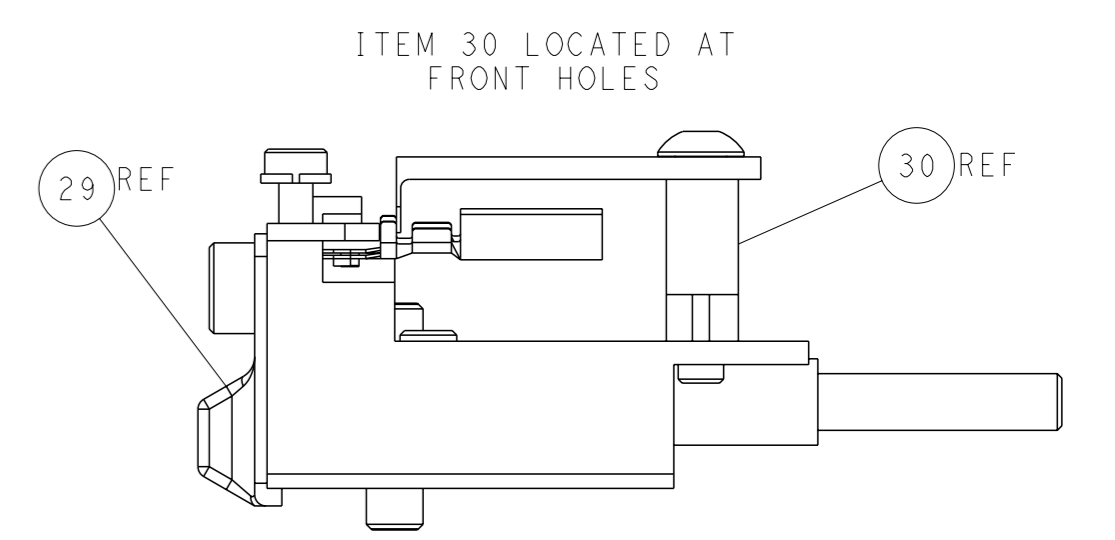
### CAM POSITIONS



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)

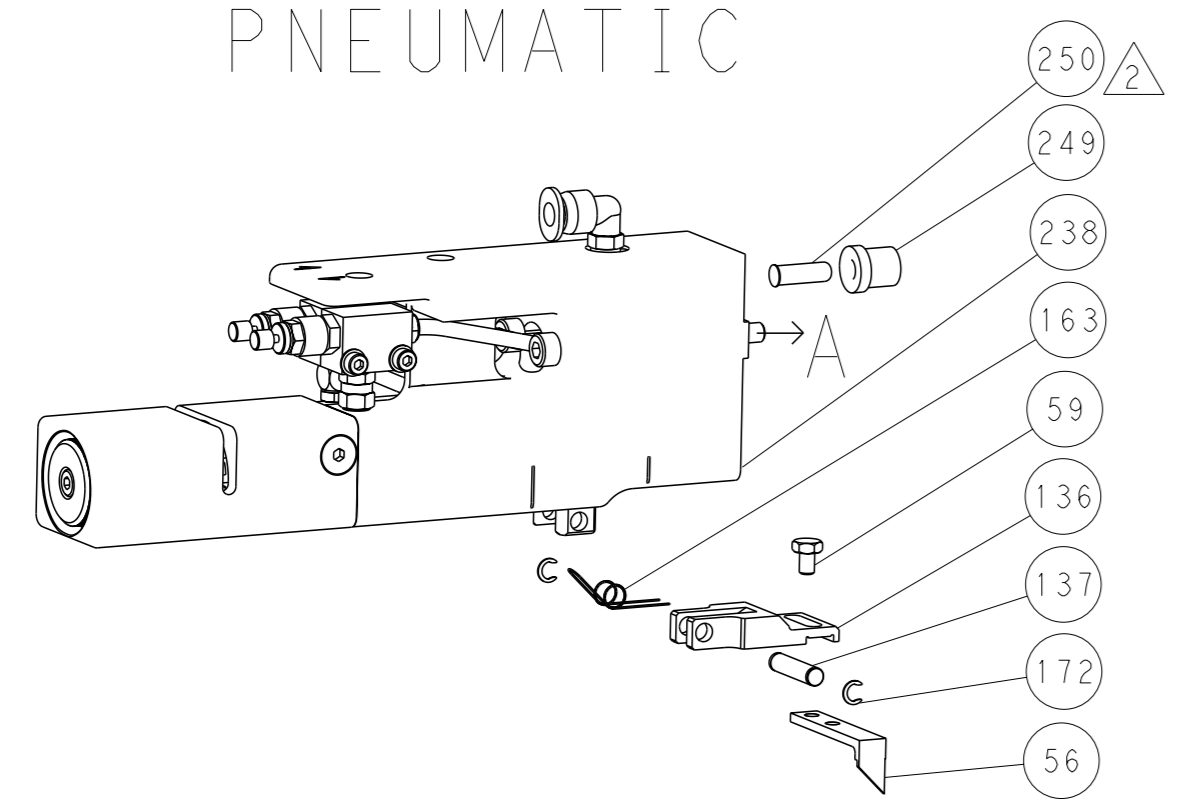
<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: S. ALVES 09APR2013 CHK: P. BARLETTA 09APR2013 APVD: C. LIMA 09APR2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH ±.	NAME: Ocean Side Feed Applicator APPLICATION SPEC:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151932 RESTRICTED TO:
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2 SHEET 2 OF 4 REV A



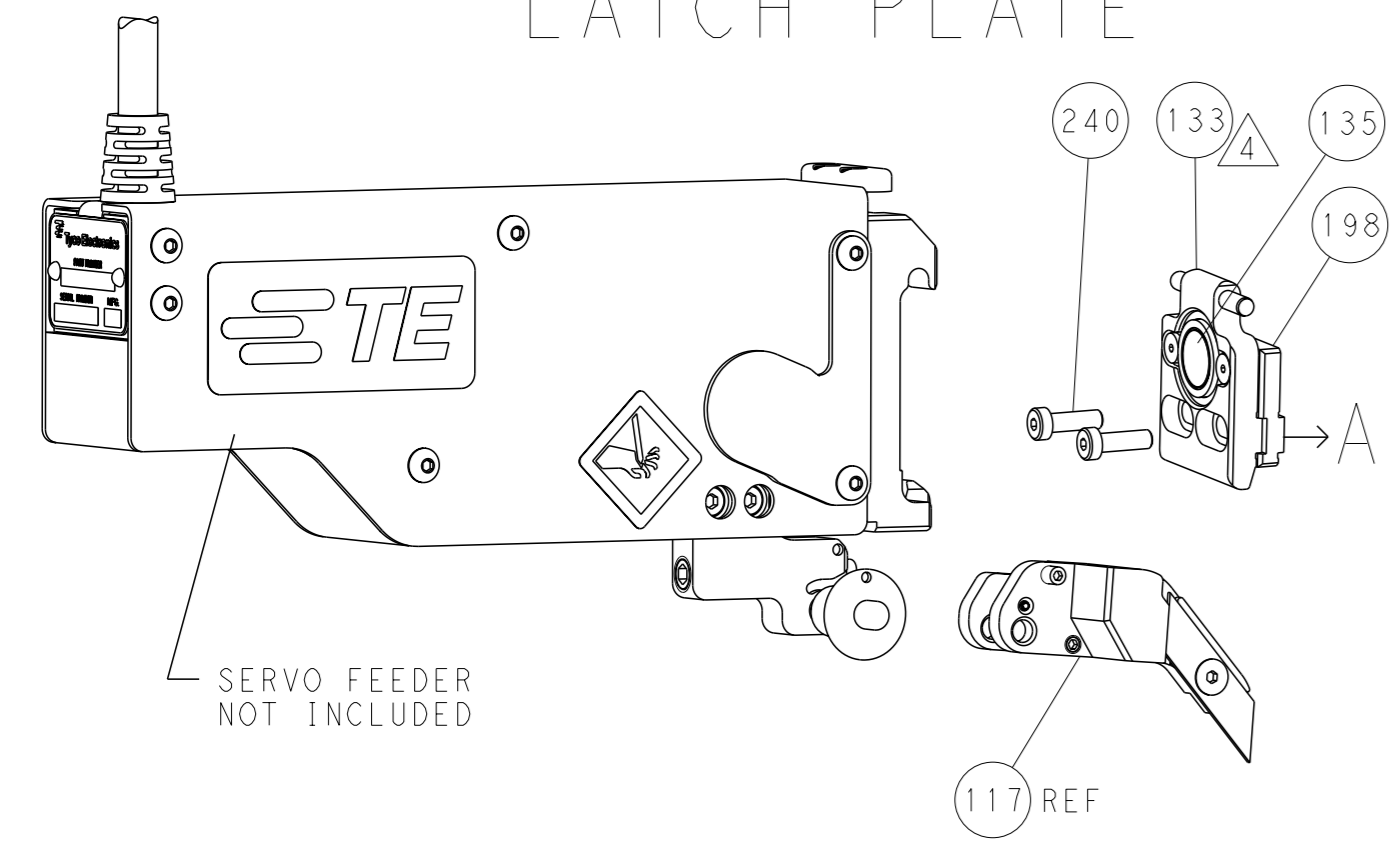
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-

### FEED TYPE

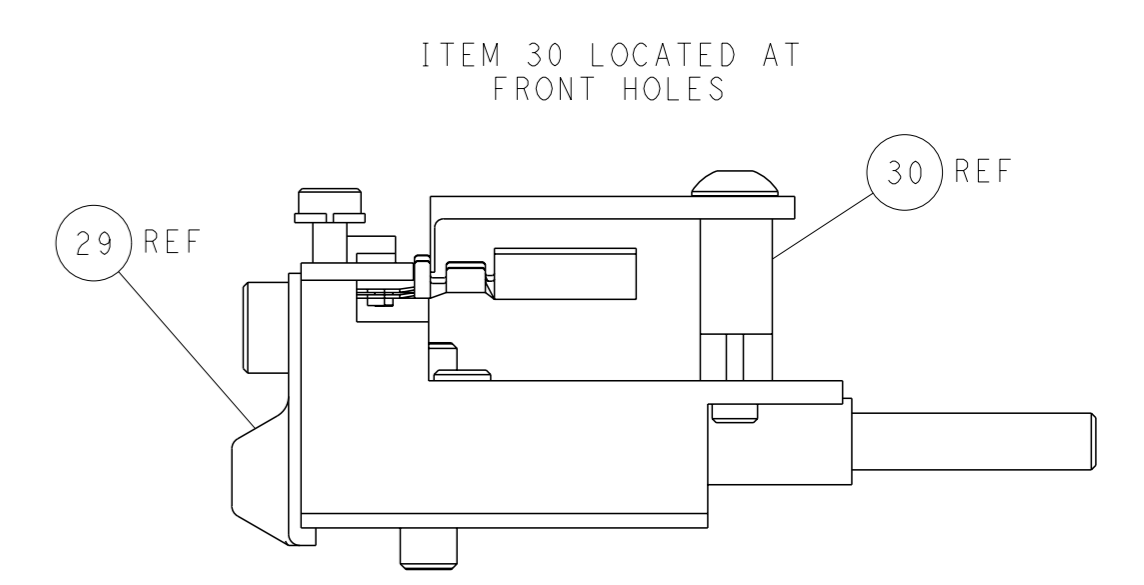
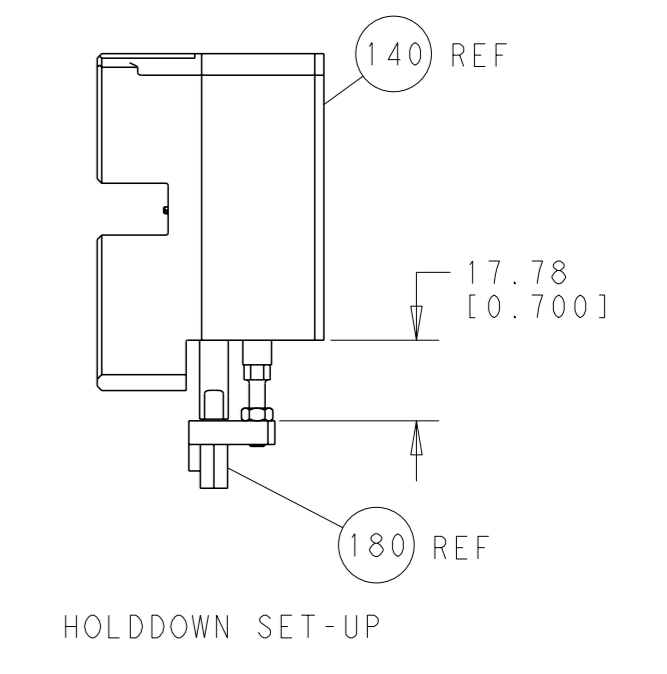
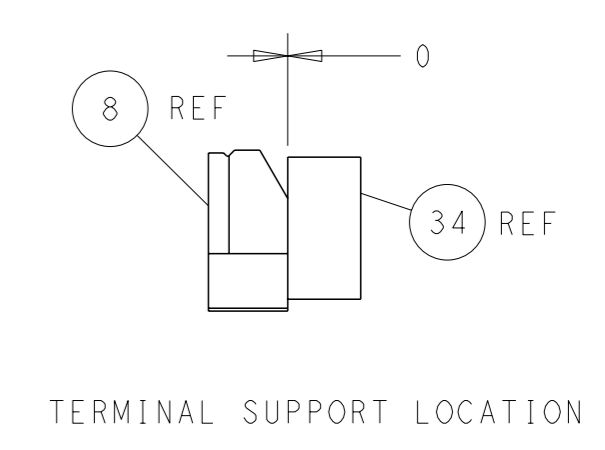
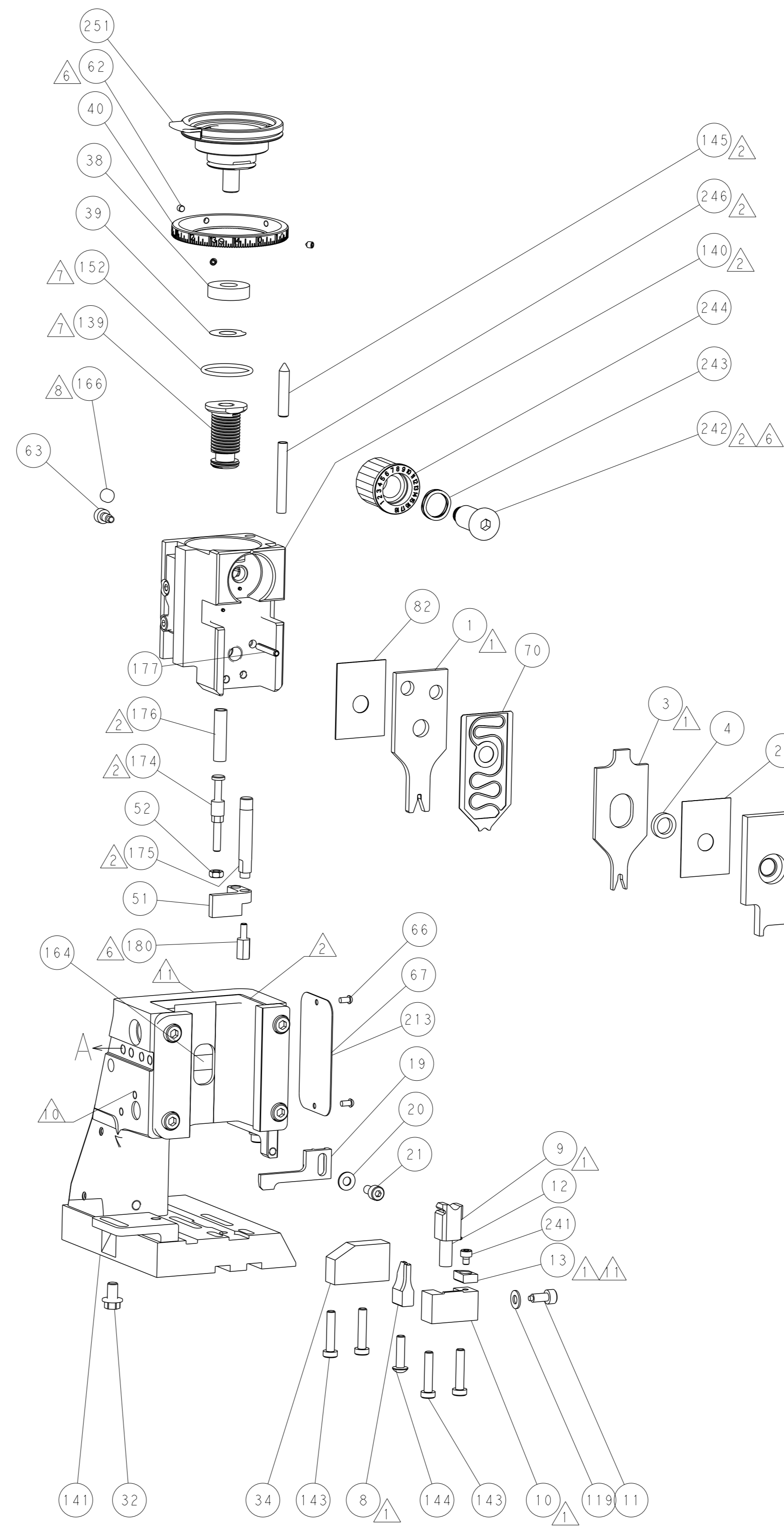
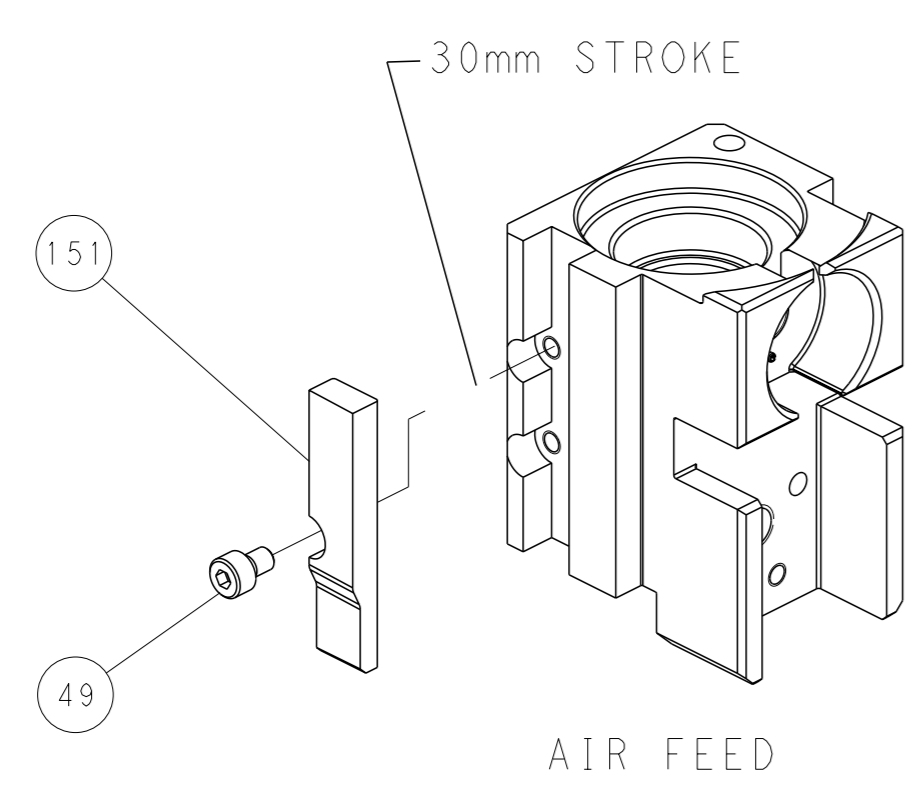
### PNEUMATIC



### 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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: S. ALVES 09APR2013 CHK: P. BARLETTA 09APR2013 APVD: C. LIMA 09APR2013	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151932	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: A
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH: *	MATERIAL: - FINISH: -	WEIGHT: - APPLICATION SPEC: - PRODUCT SPEC: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	