

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION                    | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|---|-------------|--------------------------|--------------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   |             |                          |                                |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|   |             |                          |                                |                                |                                   |                       |           |             |           |           |                        |
|   | 2151155-1   | A                        | FINE CRIMP HEIGHT ADJUST       | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |
|   |             |                          |                                |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151155-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                                |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151155-4 | -         | -         | -                      |
|   | 2151155-2   | A                        | FINE CRIMP HEIGHT ADJUST       | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -         | -                      |
|   |             |                          |                                |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151155-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                                |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151155-4 | -         | -         | -                      |
|   | 2151155-5   | A                        | FINE CRIMP HEIGHT ADJUST       | SERVO LATCH PLATE <sup>4</sup> | 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 |                        |
| -   |             |                          |                                |                                | -                                 | -                     | -         | -           | -         | -         |                        |
| 2151155-6                                     | A           | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | -                              | -                                 | -                     | -         | -           | -         | -         |                        |
|   |             |                          |                                | -                              | -                                 | -                     | -         | -           | -         | -         |                        |
| 2151155-7                                     | A           | FINE CRIMP HEIGHT ADJUST | NONE                           | -                              | -                                 | -                     | -         | -           | -         | -         |                        |
| 7-2151155-7                                   | A           | CRIMP TOOLING KIT        | -                              | -                              | -                                 | -                     | -         | -           | -         | -         |                        |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 2.03 mm [.080] | F    |
| INSUL           | 3.05 mm [.120] | F    |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: TE TERMINAL             |             | TE CRIMP SPECIFICATION       |             |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: 2.8mm FASTIN FASTON TAB |             |                              |             |
| WIRE STRIP LENGTH                      |             | INSULATION DIAMETER RANGE    |             |
| 4.00-4.60 mm [.157-.181 IN]            |             | Ø1.60-2.20 mm [.063-.087 IN] |             |
| TERMINAL APPLICATION SPECIFICATION     | 114-18014   | -                            | -           |
| TERMINALS APPLIED                      |             |                              |             |
| TE TERMINAL                            | TE TERMINAL | TE TERMINAL                  | TE TERMINAL |
| 927892-1                               | 927892-2    | 927892-4                     | 927892-5    |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 1.00mm2   | 1.56 +/- 0.05 [.061 +/- .002] | 8.6                            |
| 0.75mm2   | 1.47 +/- 0.05 [.058 +/- .002] | 9.4                            |
| 0.50mm2   | 1.38 +/- 0.05 [.054 +/- .002] | 10.4                           |

- 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151155-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151155-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151155-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151155-6
- 5. 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 ITEMS 50, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.
- 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.

|     |    |    |    |    |    |           |                                 |         |
|-----|----|----|----|----|----|-----------|---------------------------------|---------|
| -   | -  | 1  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| -   | 1  | -  | 1  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252     |
| -   | -  | -  | -  | 1  | -  | 2119640-1 | PUSH ROD, AIR FEED              | 250     |
| -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)

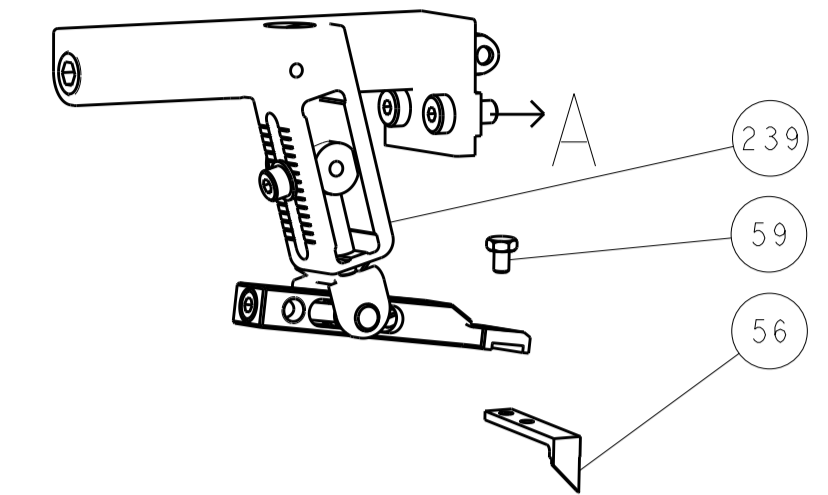
| SET UP GAUGE | LOC | DIST | REVISIONS |          |           |       |
|--------------|-----|------|-----------|----------|-----------|-------|
| 2119599-1    | A   | 66   | REV       | DATE     | BY        | APPV  |
|              |     |      | 2         | REVISED  | 120CT2011 | XZ SX |
|              |     |      | A         | RELEASED | 090CT2012 | YY SX |

|   |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | -   | -   | 1   | -   | 2079988-1   | BUSHING, LCH5-12, MISUMI            | 249 |
| - | -   | -   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
| - | 1   | -   | 1   | 1   | 1   | 2119798-1   | DETENT PIN                          | 247 |
| - | 1   | -   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| - | -   | 1   | -   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| - | 1   | 1   | 1   | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1   | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 1   | 1   | 1   | 1   | 18023-1     | SCR, SKT HD CAP M3 X 5.0            | 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 |
| - | 1   | 1   | 1   | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177 |
| - | 1   | 1   | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176 |
| - | 1   | 1   | 1   | 1   | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 | 175 |
| - | 1   | 1   | 1   | 1   | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 | 174 |
| - | -   | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 1   | 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   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117 |
| - | 1   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | -   | -   | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| - | 2   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS              | 66  |
| - | 1   | -   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |
| - | 3   | -   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62  |
| - | 1   | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60  |
| - | -   | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | -   | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54  |
| - | 1   | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52  |
| - | 1   | 1   | 1   | 1   | 1   | 2-1901681-2 | HOLDDOWN, TERMINAL                  | 51  |
| - | 1   | 1   | 1   | 1   | 1   | 1-1752354-3 | STANDOFF, HOLD-DOWN                 | 50  |
| - | -   | -   | -   | 1   | 2   | 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   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46  |
| - | 1   | -   | 1   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44  |
| - | 1   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | -   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
| - | 1   | -   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
| - | 1   | 1   | 1   | 1   | 1   | 2119644-2   | RAM WASHER, PRECISION               | 38  |
| - | 1   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37  |
| - | 1   | -   | 1   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35  |
| - | 1   | 1   | 1   | 1   | 1   | 1-1752356-9 | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 1   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 X 8mm LONG    | 32  |
| - | 1   | 1   | 1   | 1   | 1   | 1-1320908-0 | SPACER, STRIP GUIDE                 | 30  |
| - | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1   | 1   | 1   | 462006-6    | FLOATING SHEAR, FRONT               | 9   |
| 1 | 1   | 1   | 1   | 1   | 1   | 5-1333204-8 | ANVIL, COMBINATION                  | 8   |
| - | 1   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 4-238011-7  | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 1   | 1   | 1   | 1   | 1   | 1-1633961-1 | CRIMPER, INSULATION F PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 455888-7    | SPACER, CRIMPER                     | 2   |
| 1 | 1   | 1   | 1   | 1   | 1   | 1-456405-5  | CRIMPER, WIRE PREMIUM               | 1   |

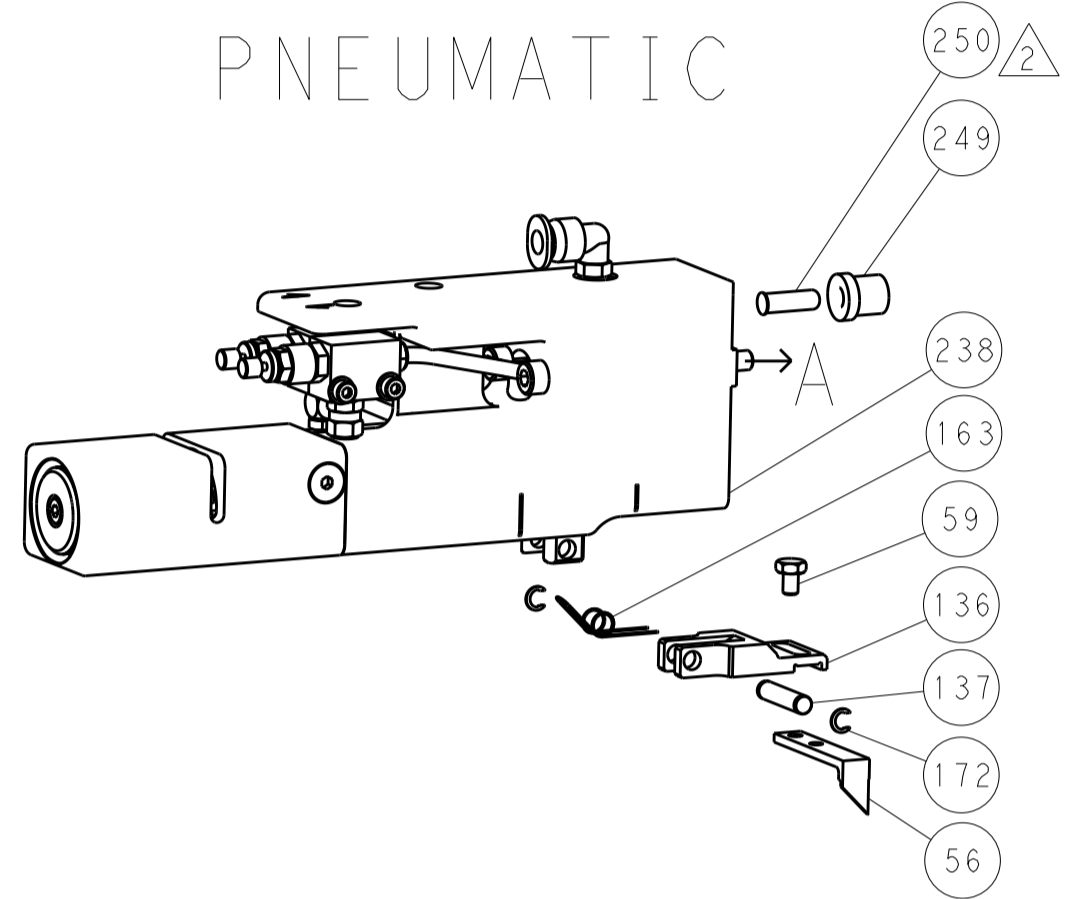
| DIMENSIONS: |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |            | OWN       | DATE      | TE Connectivity            |  |
|-------------|------------|--|------------|-----------|-----------|----------------------------|--|
| mm          | 0 PLC ±.5  | 1 PLC ±.5                              | 2 PLC ±.5  | Y. YIN    | 07JUL2011 | Harrisburg, PA 17105-3608  |  |
|             | 3 PLC ±.5  | 4 PLC ±.5                              | 5 PLC ±.5  | G. BAILEY | 07JUL2011 | Ocean Side Feed Applicator |  |
|             | 6 PLC ±.5  | 7 PLC ±.5                              | 8 PLC ±.5  | S. XI     | 07JUL2011 | SIZE: A1                   |  |
|             | 9 PLC ±.5  | 10 PLC ±.5                             | 11 PLC ±.5 |           |           | CAGE CODE: 00779           |  |
|             | 12 PLC ±.5 | 13 PLC ±.5                             | 14 PLC ±.5 |           |           | DRAWING NO: 2151155        |  |
|             | 15 PLC ±.5 | 16 PLC ±.5                             | 17 PLC ±.5 |           |           | RESTRICTED TO: -           |  |
|             | 18 PLC ±.5 | 19 PLC ±.5                             | 20 PLC ±.5 |           |           | SCALE: 1:2                 |  |
|             | 21 PLC ±.5 | 22 PLC ±.5                             | 23 PLC ±.5 |           |           | SHEET 1 OF 4               |  |
|             | 24 PLC ±.5 | 25 PLC ±.5                             | 26 PLC ±.5 |           |           | REV: A                     |  |

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

### FEED TYPE MECHANICAL



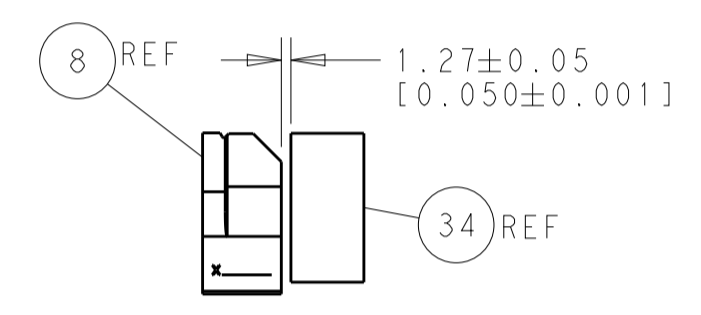
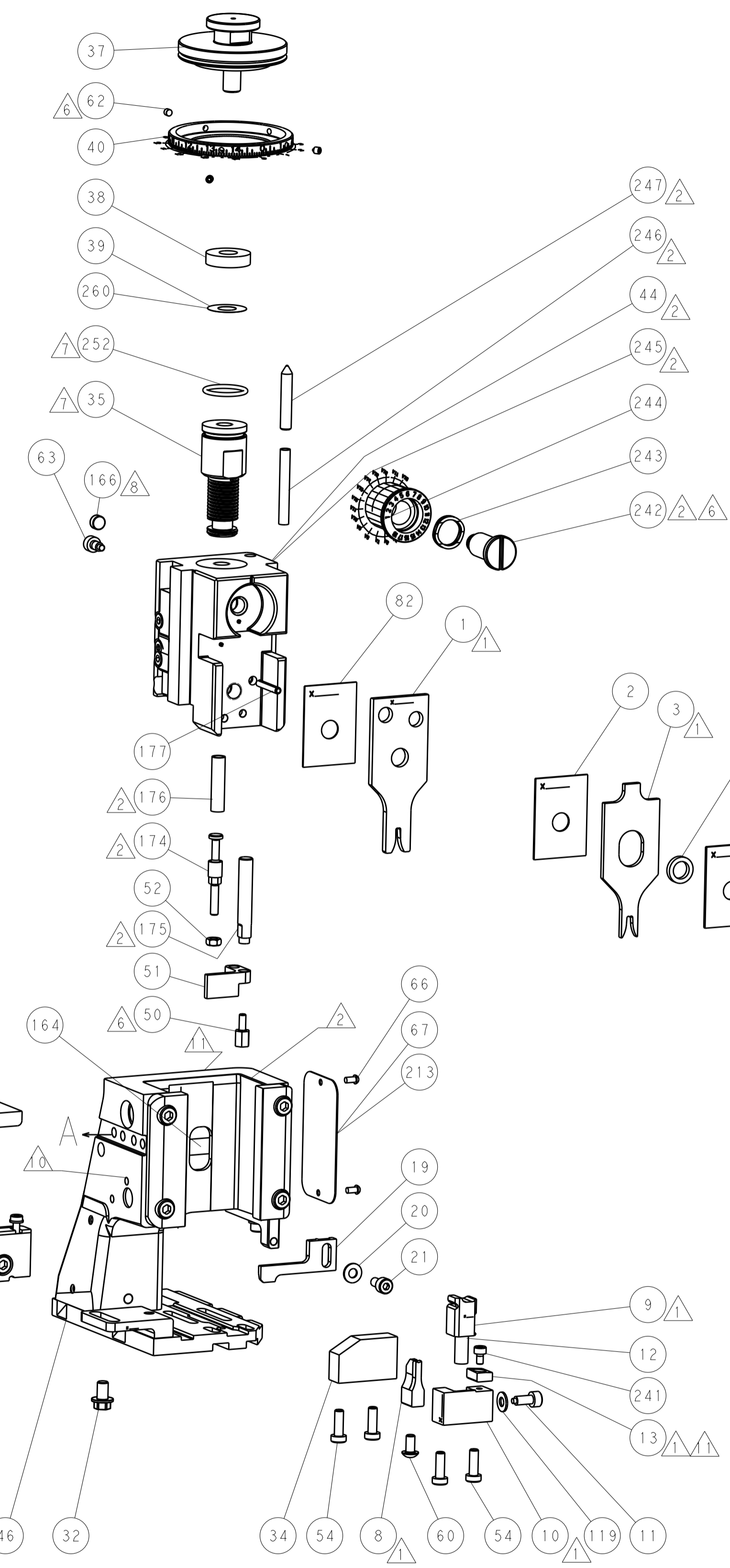
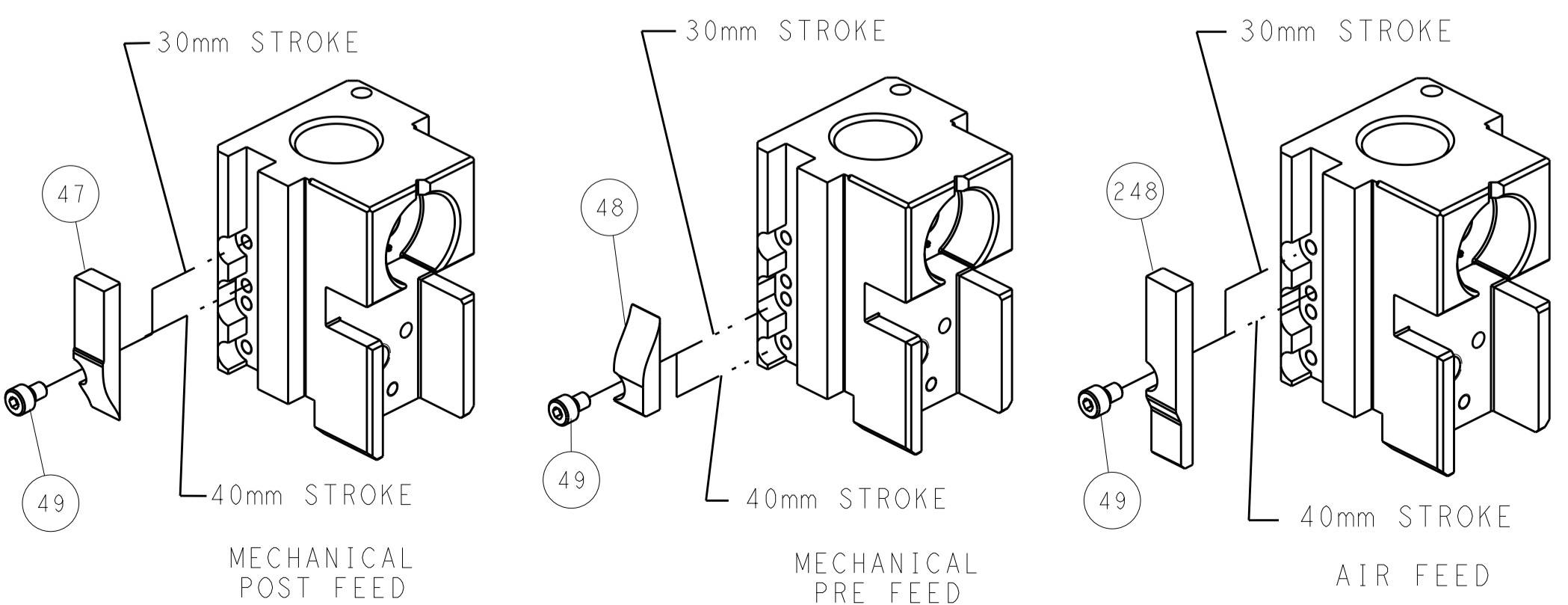
### PNEUMATIC



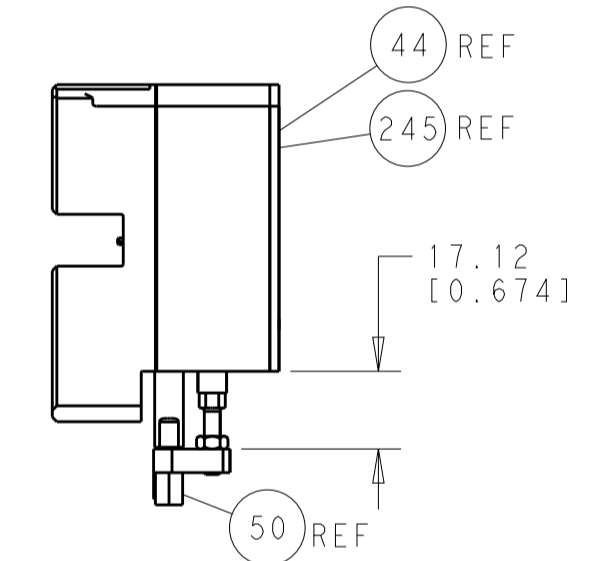
### SERVO LATCH PLATE



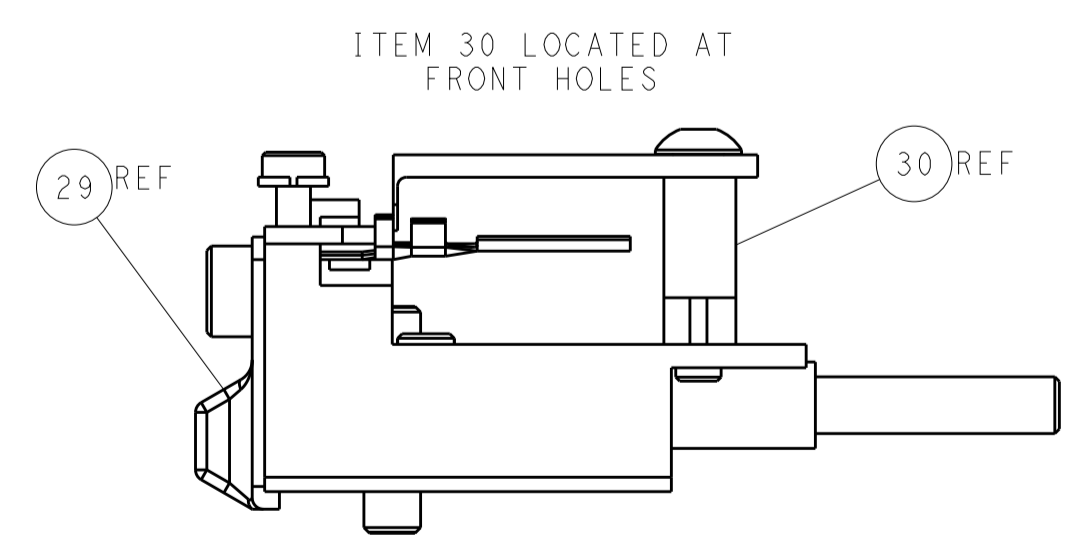
### CAM POSITIONS



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)

|  |                |  |              |              |           |                            |               |
|--|----------------|--|--------------|--------------|-----------|----------------------------|---------------|
| DIMENSIONS:                            |                | TOLERANCES UNLESS OTHERWISE SPECIFIED: |              | DWN          |           | TE Connectivity            |               |
| mm                                     | 0 PLC ±0.5     | 1 PLC ±0.13                            | 2 PLC ±0.013 | 3 PLC ±0.001 | 07JUL2011 | Harrisburg, PA 17105-3608  |               |
|  | ANGLES ±0.0001 |  |              | CHK          | 07JUL2011 | NAME                       |               |
|  |                |  |              | S. XI        | 07JUL2011 | Ocean Side Feed Applicator |               |
| MATERIAL                               | FINISH         | WEIGHT                                 | SCALE        | SIZE         | CAGE CODE | DRAWING NO                 | RESTRICTED TO |
|  |                |  | 1:2          | A1           | 00779     | ©=2151155                  |               |
| Customer Accessible Production Drawing |                |  |              | SHEET 2 OF 4 |           | REV A                      |               |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|  |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|  | 2-2151155-1 | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151155-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151155-4 | -         | -         |                        |
|  | 2-2151155-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151155-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151155-4 | -         | -         |                        |
|  | 2-2151155-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  | 2-2151155-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -         | -                      |
|  | 7-2151155-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                   |                  |      |
|-----------------------------------|------------------|------|
| CRIMP WIRE                        | SIZE             | TYPE |
| WIRE                              | 2.03 mm [ .080 ] | F    |
| INSUL                             | 3.05 mm [ .120 ] | F    |
| APPLICATOR INSTRUCTIONS 408-10389 |                  |      |

| TERMINAL DATA: TE TERMINAL             |             | TE CRIMP SPECIFICATION         |             |
|--|-------------|--------------------------------|-------------|
| TERMINAL NAME: 2.8mm FASTIN FASTON TAB |             |                                |             |
| WIRE STRIP LENGTH                      |             | INSULATION DIAMETER RANGE      |             |
| 4.00-4.60 mm [ .157-.181 IN ]          |             | Ø1.60-2.20 mm [ .063-.087 IN ] |             |
| TERMINAL APPLICATION SPECIFICATION     | 114-18014   | -                              | -           |
| TERMINALS APPLIED                      |             |                                |             |
| TE TERMINAL                            | TE TERMINAL | TE TERMINAL                    | TE TERMINAL |
| 927892-1                               | 927892-2    | 927892-4                       | 927892-5    |

| WIRE SIZE           | CRIMP HEIGHT mm [INCH]       | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|------------------------------|--------------------------------|
| 1.00mm <sup>2</sup> | 1.56+/-0.05 [ .061+/- .002 ] | 8.6                            |
| 0.75mm <sup>2</sup> | 1.47+/-0.05 [ .058+/- .002 ] | 9.4                            |
| 0.50mm <sup>2</sup> | 1.38+/-0.05 [ .054+/- .002 ] | 10.4                           |

- 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151155-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151155-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151155-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151155-6
- 5. 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 ITEMS 50, 62 & 242.
- 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.
- 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

**\*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.

| -77 | -27 | -25 | -22 | -21 | PART NO   | DESCRIPTION                         | ITEM NO |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |

**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

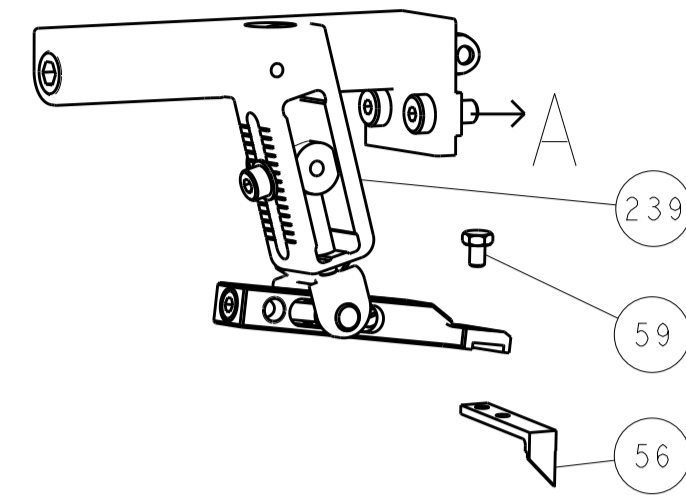
| SET UP GAUGE | LOC | DIST | REVISIONS |   |   |             |     |      |
|--------------|-----|------|-----------|---|---|-------------|-----|------|
| 2119599-1    | A   | 66   | P         | L | M | DATE        | OWN | APVD |
|              |     |      | -         | - | - | SEE SHEET 1 | -   | -    |

| P | L   | M   | DATE | OWN | APVD        |                                     |     |
|---|-----|-----|------|-----|-------------|-------------------------------------|-----|
| - | -   | -   | 1    | -   | 2119640-1   | PUSH ROD, AIR FEED                  | 250 |
| - | -   | -   | 1    | -   | 2079988-1   | BUSHING, LCH5-12, MISUMI            | 249 |
| - | 1   | 1   | 1    | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| - | 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   | 18023-1     | SCR, SKT HD CAP M3 X 5.0            | 241 |
| - | -   | 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   | -    | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213 |
| - | -   | 1   | -    | -   | 1901094-3   | SPACER, FEEDER                      | 198 |
| - | 1   | 1   | 1    | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177 |
| - | 1   | 1   | 1    | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176 |
| - | 1   | 1   | 1    | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 | 175 |
| - | 1   | 1   | 1    | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 | 174 |
| - | -   | -   | 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 | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | -   | -   | 1    | -   | 240638-1    | SPRING, FEED FINGER                 | 163 |
| - | 1   | 1   | 1    | 1   | 8-21084-1   | O-RING, .801 ID, .070 DIA. MAT.     | 152 |
| - | -   | -   | 1    | -   | 2119641-2   | FEED CAM, AIR FEED                  | 151 |
| - | 1   | 1   | 1    | 1   | 2119798-2   | DETENT PIN                          | 145 |
| - | 1   | 1   | 1    | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144 |
| - | 4   | 4   | 4    | 4   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       | 143 |
| - | -   | -   | -    | 1   | 2119653-2   | FEED CAM, POST FEED                 | 142 |
| - | 1   | 1   | 1    | 1   | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141 |
| - | 1   | 1   | 1    | 1   | 2119650-1   | RAM, ASIAN STYLE, SIDE FEED         | 140 |
| - | 1   | 1   | 1    | 1   | 2119092-2   | BOLT, ADJUSTMENT                    | 139 |
| - | -   | -   | 1    | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137 |
| - | -   | -   | 1    | -   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136 |
| - | -   | REF | -    | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135 |
| - | -   | 1   | -    | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133 |
| - | 1   | 1   | 1    | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | -   | 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    | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| - | 2   | 2   | 2    | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS              | 66  |
| - | 1   | 1   | 1    | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |
| - | 3   | 3   | 3    | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62  |
| - | -   | -   | 1    | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | -   | -   | 1    | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 1   | 1   | 1    | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52  |
| - | 1   | 1   | 1    | 1   | 2-1901681-2 | HOLDDOWN, TERMINAL                  | 51  |
| - | 1   | 1   | 1    | 1   | 1-1752354-3 | STANDOFF, HOLD-DOWN                 | 50  |
| - | -   | -   | 1    | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | -   | -   | -    | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48  |
| - | 1   | 1   | 1    | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | 1   | 1    | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
| - | 1   | 1   | 1    | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
| - | 1   | 1   | 1    | 1   | 2119644-2   | RAM WASHER, PRECISION               | 38  |
| - | 1   | 1   | 1    | 1   | 1-1752356-9 | 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   | 1-1320908-0 | SPACER, STRIP GUIDE                 | 30  |
| - | 1   | 1   | 1    | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1    | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| - | 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   | 2119533-1   | 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   | 462006-6    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1    | 1   | 5-1333204-8 | ANVIL, COMBINATION                  | 8   |
| - | 1   | 1   | 1    | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1    | 1   | 4-238011-7  | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1    | 1   | 1-1633961-1 | CRIMPER, INSULATION F PREMIUM       | 3   |
| - | 1   | 1   | 1    | 1   | 455888-7    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1    | 1   | 1-456405-5  | CRIMPER, WIRE PREMIUM               | 1   |

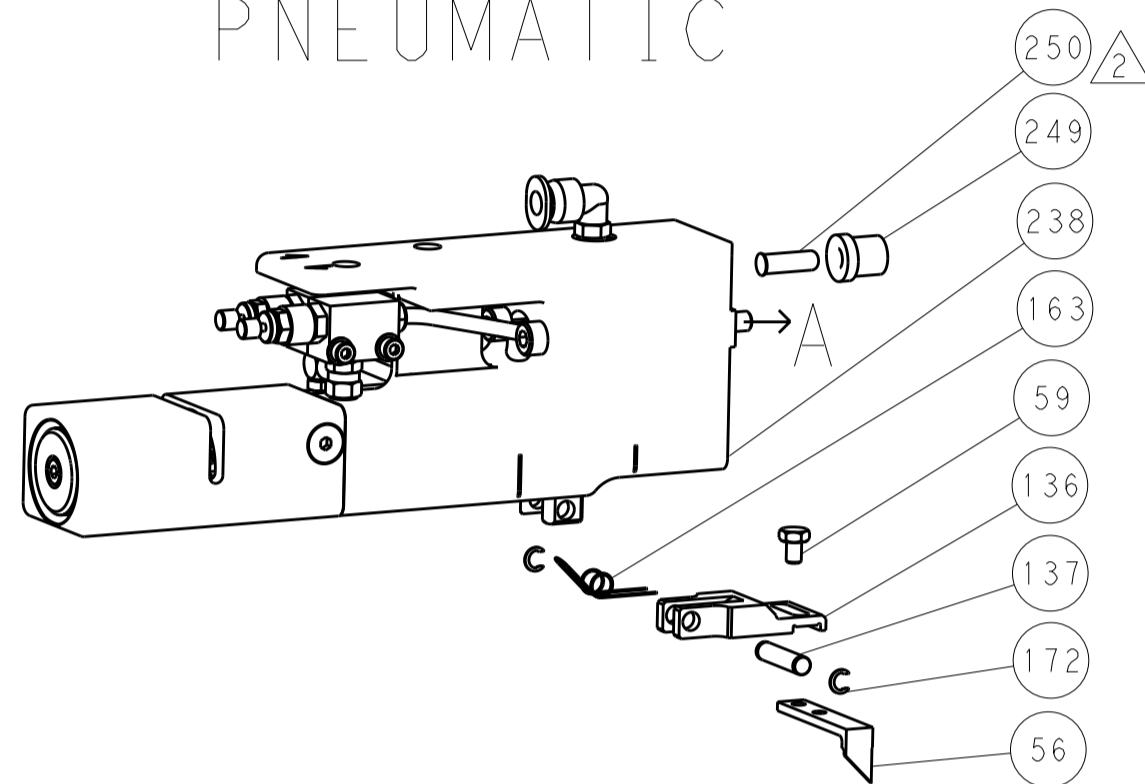
| DIMENSIONS: |              | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | OWN    | CHK       | DATE      | NAME                      |
|-------------|--------------|--|-------------|--------|-----------|-----------|---------------------------|
| mm          | 0 PLC ±.5    | 1 PLC ±0.5                             | 2 PLC ±0.13 | Y. YIN | G. BAILEY | 07JUL2011 | TE Connectivity           |
|             | 3 PLC ±0.013 | 4 PLC ±0.0001                          | ANGLES ±.5  |        |           |           | Harrisburg, PA 17105-3608 |
| MATERIAL    | FINISH       | WEIGHT                                 | SCALE       | APVD   | SHEET     | 3 OF 4    | RESTRICTED TO             |
|             |              |  | 1:2         |        |           |           |                           |

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

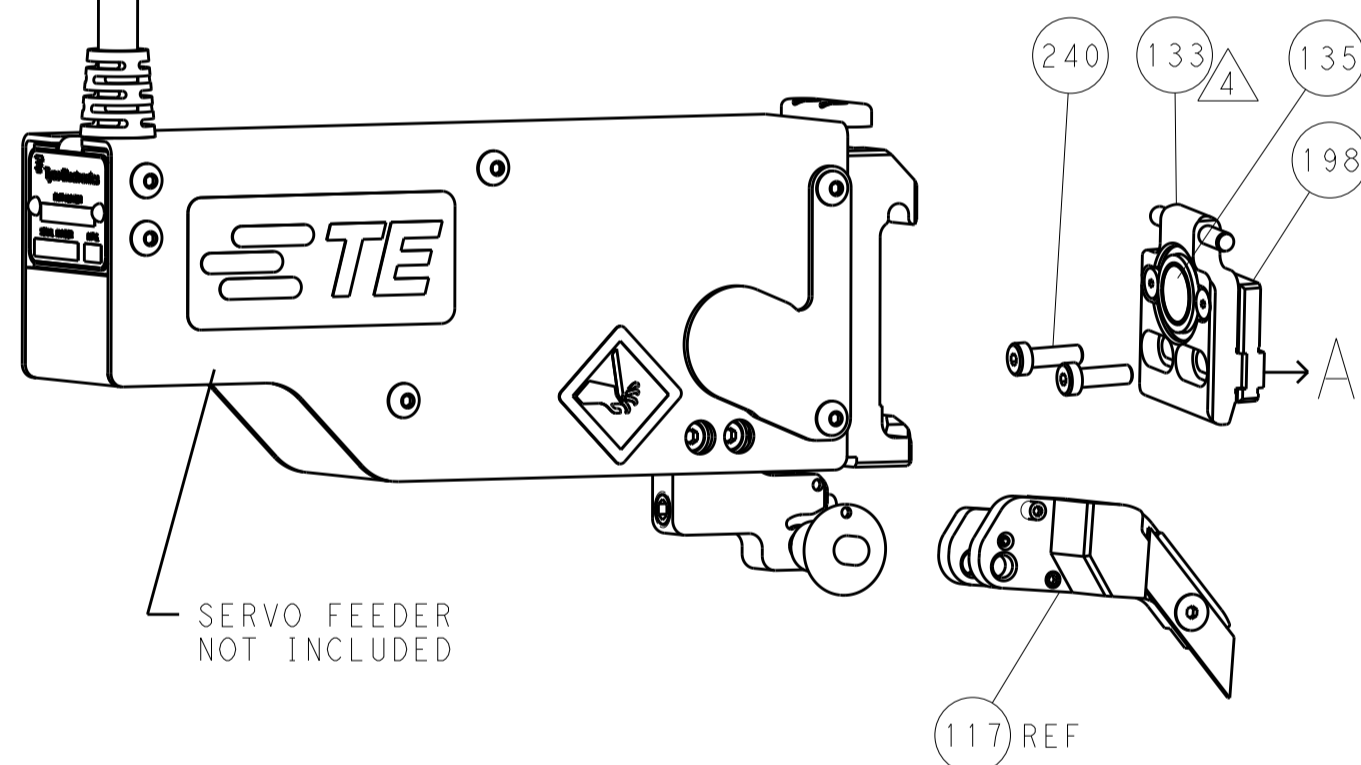
# FEED TYPE MECHANICAL



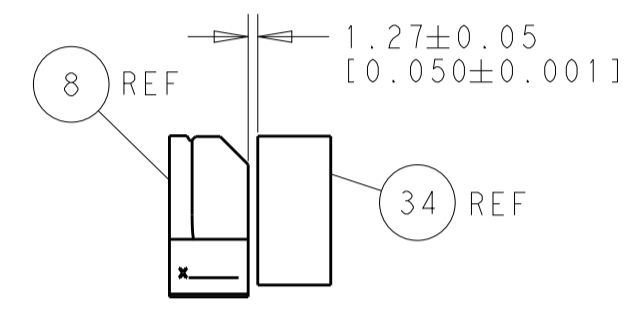
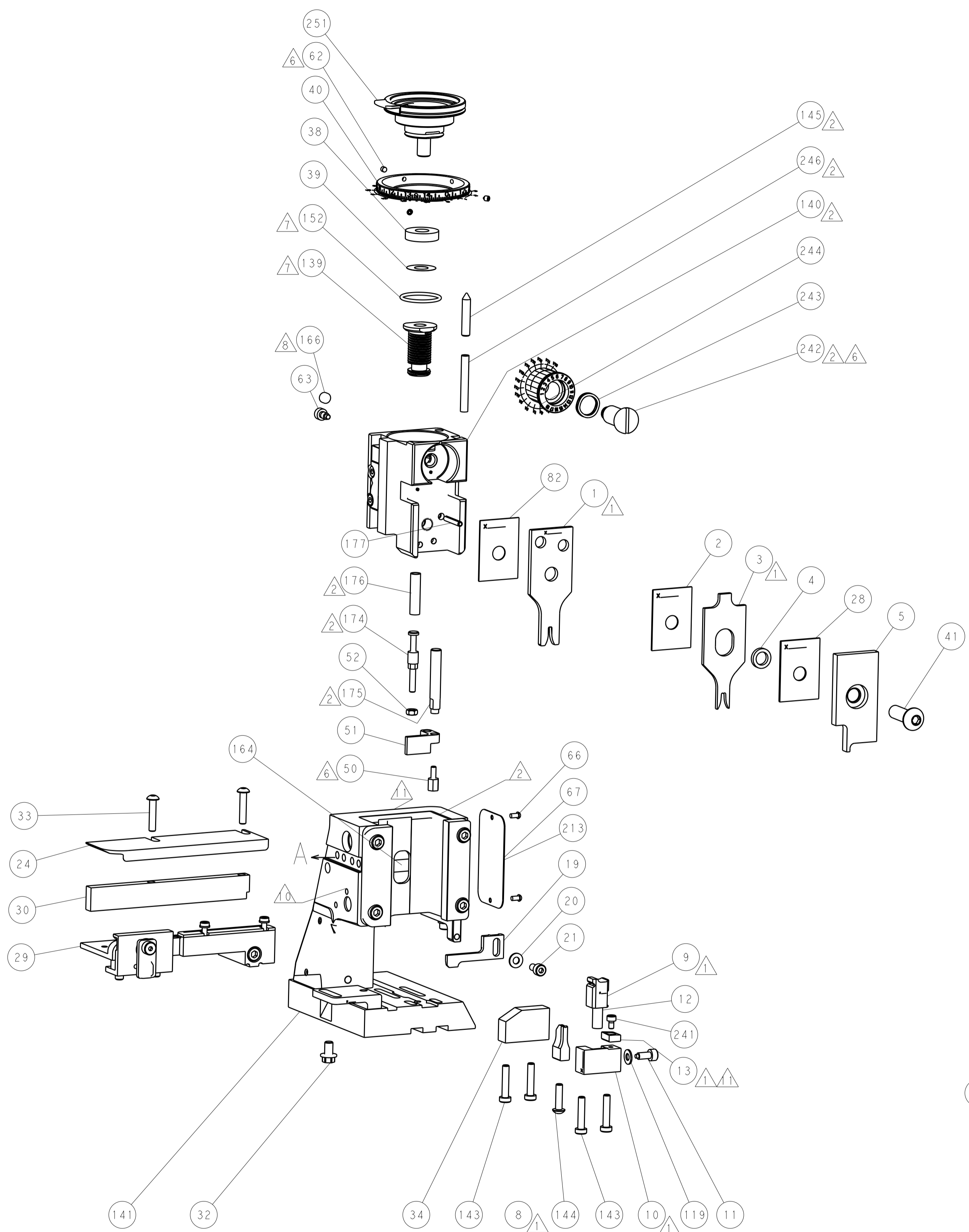
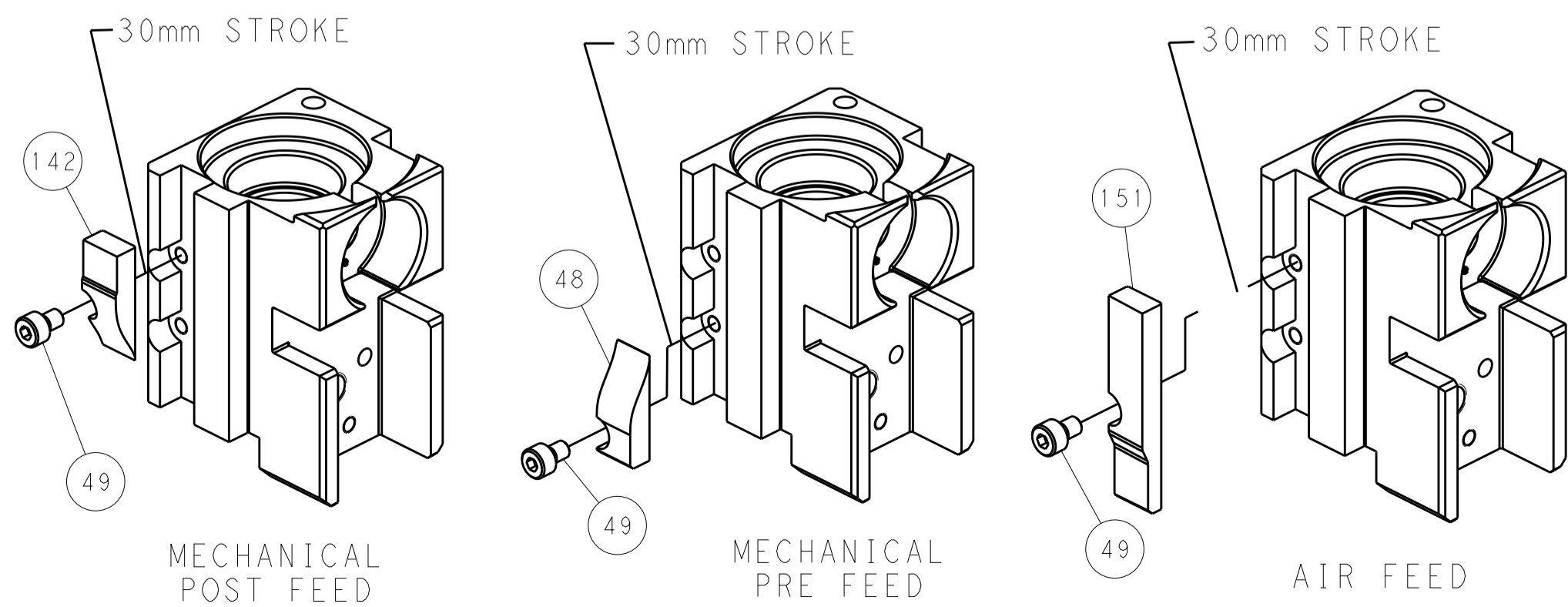
# PNEUMATIC



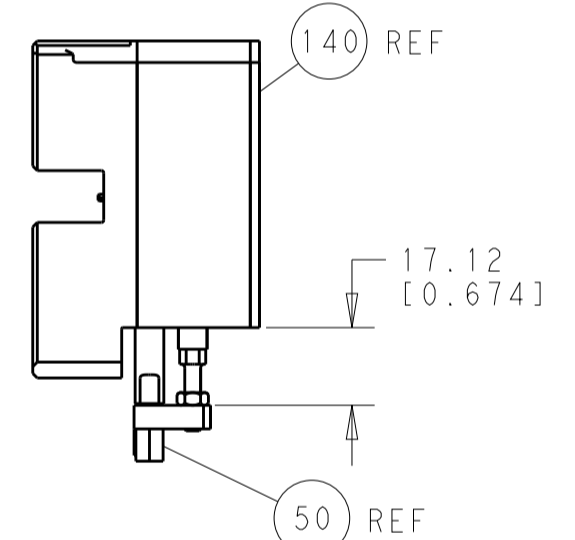
# SERVO LATCH PLATE



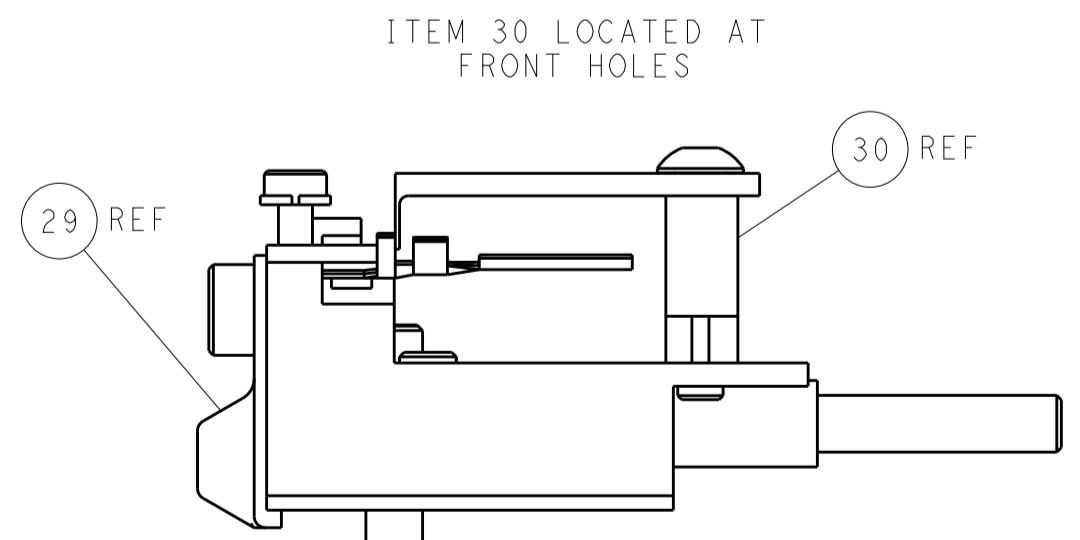
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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:<br>mm<br>                  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.5<br>1 PLC ±0.5<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.001<br>ANGLES ±.1 |  | DWN Y. YIN 07JUL2011<br>CHK G. BAILEY 07JUL2011<br>APVD S. XI 07JUL2011 |  | NAME<br>Ocean Side Feed Applicator              |  |
| MATERIAL:                              |  | FINISH:  |  | WEIGHT:   |  | SIZE CAGE CODE DRAWING NO<br>A1 00779 C=2151155 |  |
| Customer Accessible Production Drawing |  |  |  | SCALE 1:2   |  | SHEET 4 OF 4 REV A                              |  |

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009.

C

B

A