

4

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2


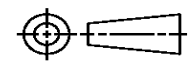
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LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
			A2	ECR-15-003735	9MAR2015	RS	LZ

THIS PART NUMBER IS OBSOLETE (NO LONGER ACTIVE OR PRODUCED).  
 THE CUSTOMER SHOULD CONTACT THEIR SALES REPRESENTATIVE OR TAC  
 TO IDENTIFY THE APPLICATOR THAT WILL PROCESS THE TERMINAL TO BE APPLIED.  
 IF ONE DOES NOT EXIST, A REQUEST TO QUOTE A NEW APPLICATOR WILL NEED TO  
 BE PROCESSED.

FOR REPLACEMENT PARTS FOR APPLICATOR 2151630  
 REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)  
 WILL REMAIN AVAILABLE.

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R.SHEN	 <b>TE Connectivity</b>			
DIMENSIONS:		CHK LJ.ZHANG				
		APVD U.GUO	NAME OCEAN SIDE FEED APPLICATOR			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	APPLICATION SPEC			
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		WEIGHT	SIZE A3	CAGE CODE	DRAWING NO C-2151630	RESTRICTED TO
MATERIAL		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	SHEET 1 OF 5	REV A2

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SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-1		A	66	P	LR	DATE	OWN
A	RELEASED					23MAR2012	BH
A1	ECR-14-000620					15JAN2014	UG

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151630-1	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	-	8-2151630-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151630-4	-	-	-
	2151630-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151630-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151630-4	-	-	-
	2151630-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	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
	2151630-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
	2151630-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151630-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.68 mm [.145]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: DELPHI TERMINAL		DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.20-6.00 mm [.205-.236 IN]	0.00-3.45 mm [.000-.136 IN]		
TERMINAL APPLICATION SPECIFICATION	NONE		

TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	CABLE DIAMETER
286866-1	12048074	286867-1	12048086	2.85-2.03
286866-2	15326225	286867-2	15324973	2.85-2.03
286866-3	15366078	286867-5	15324976	2.15-1.60
		828905-1	NA	
		1949554-1	15393249	2.15-1.60
		1949554-2	15324979	2.15-1.60
		1572277-2	15324974	1.70-1.20

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.35+/-0.05 [.053+/- .002]	3.1
0.80mm2	1.20+/-0.05 [.047+/- .002]	5.4
0.75mm2	1.15+/-0.05 [.045+/- .002]	5.8
0.50mm2	1.10+/-0.05 [.043+/- .002]	6.5

- 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: 8-2151630-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151630-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151630-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151630-6
- 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 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.

- THE INSULATION RANGE LISTED IS FOR THE TERMINAL. REFER TO THE CHART FOR RANGE OF SEALS LISTED ON APPLICATOR DRAWING.
- 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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	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
-	-	-	-	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

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

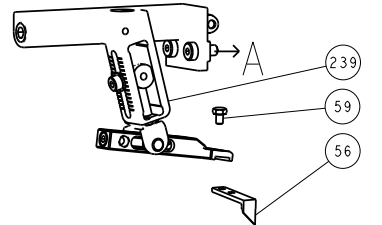
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245	
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	1	18023-1	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	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	2	-	-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	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	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	-	-	-	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	1901681-1	HOLDDOWN, TERMINAL	51	
-	1	1	1	1	1	2-1752354-1	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	2119644-1	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	3-1752356-4	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	455888-4	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	318707-1	FLOATING SHEAR, FRONT	9	
-	1	1	1	1	1	2-1633138-7	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	-	6	
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	1	1	1	1	3-1633965-1	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1	1	455888-8	SPACER, CRIMPER	2	
-	1	1	1	1	1	4-568176-6	CRIMPER, WIRE	1	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		TE Connectivity	
mm		0 PLC	±.05	BOB HIGMAN	23MAR2012	Harrisburg, PA 17105-3608	
		1 PLC	±0.13	ELBIN	23MAR2012		
		2 PLC	±0.13	M CLIFFORD	23MAR2012		
		3 PLC	±0.013				
		4 PLC	±0.001				
		ANGLES	±.01				
		FINISH					
MATERIAL:				APPLICATOR SPEC		SIZE CAGE CODE DRAWING NO	
						A1 00779 ©=2151630	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 1 OF 4 REV A1	

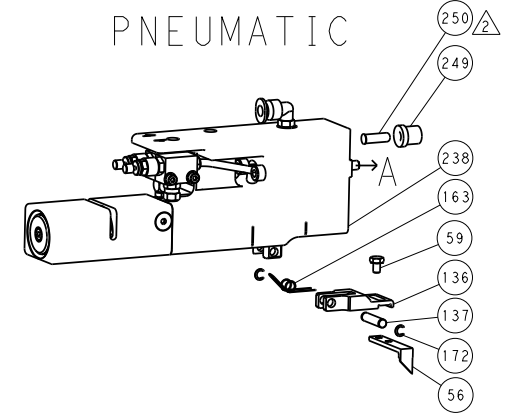
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

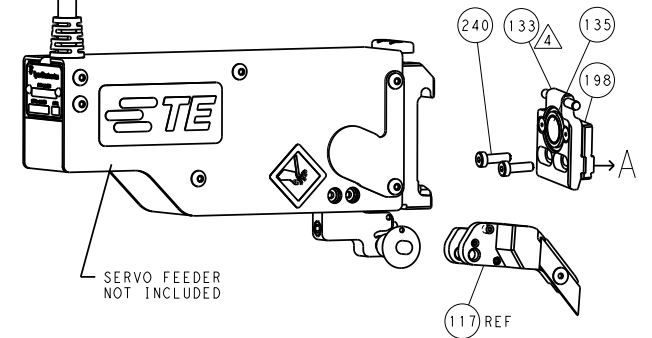
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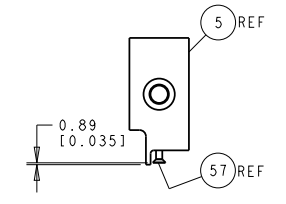
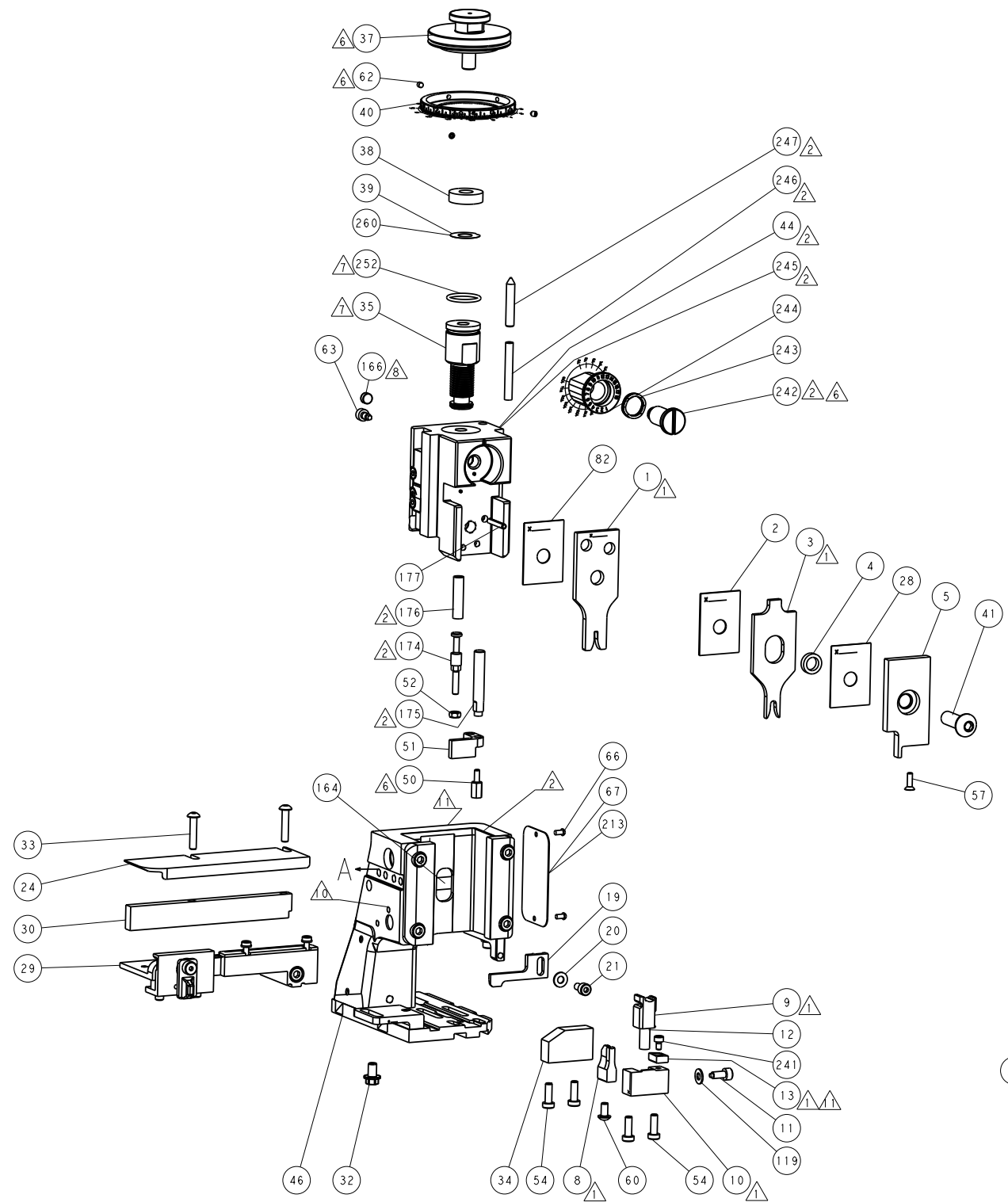
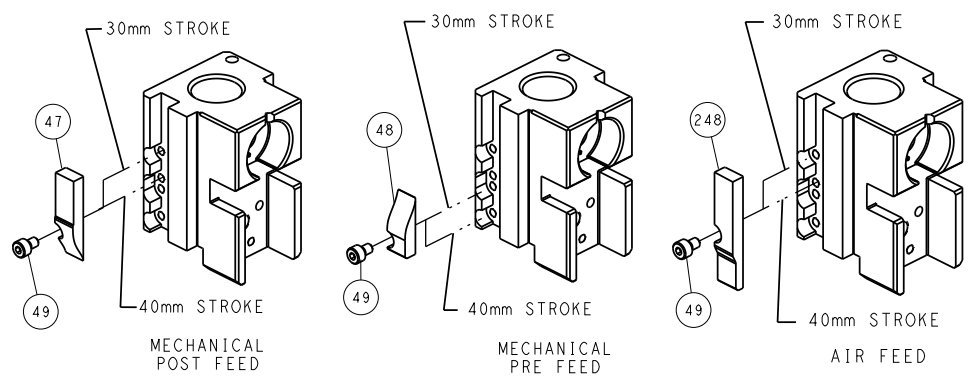
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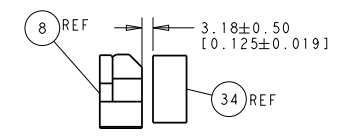
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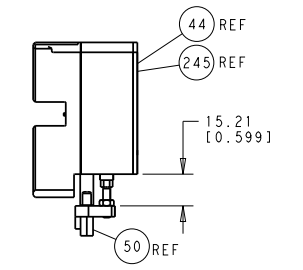
### CAM POSITIONS



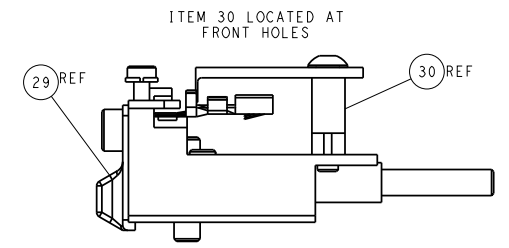
SHEAR DEPRESSOR DETAIL



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)

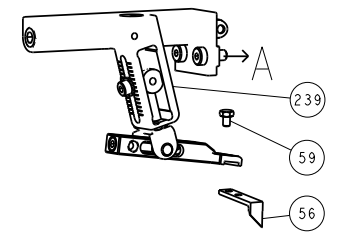
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 23MAR2012	TE Connectivity
mm	0 PLC ±0.13	1 PLC ±0.13	2 PLC ±0.13	CHK: T. ELBIN 23MAR2012	Harrisburg, PA 17105-3608
	3 PLC ±0.013	4 PLC ±0.0001		APVD: M. CLIFFORD 23MAR2012	
	ANGLE: ±0.0001			NAME: Ocean Side Feed Applicator	
MATERIAL:	FINISH:	WEIGHT:	SIZE: A	CAGE CODE: 00779	DRAWING NO: 2151630
			Customer Accessible Production Drawing	SCALE: 1:2	SHEET 2 OF 4

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

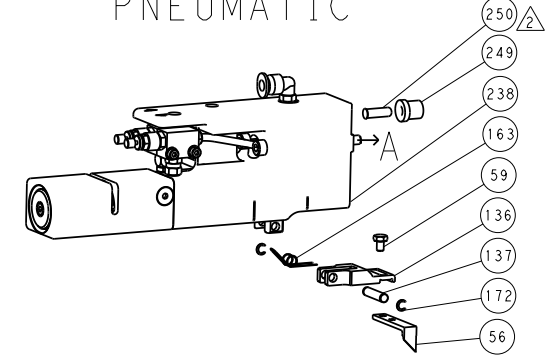


LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

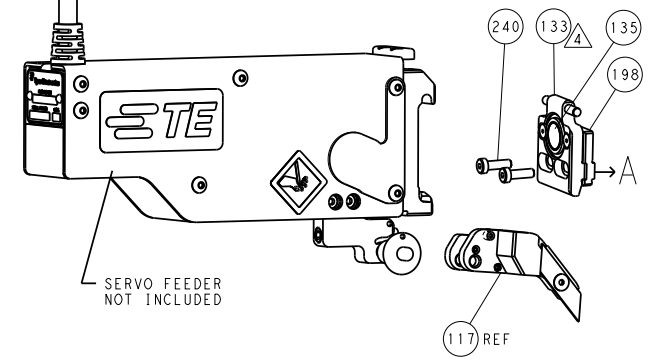
### FEED TYPE MECHANICAL



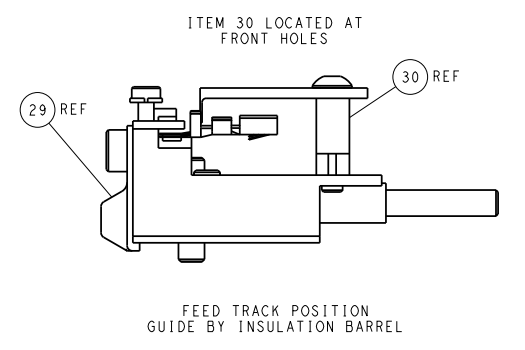
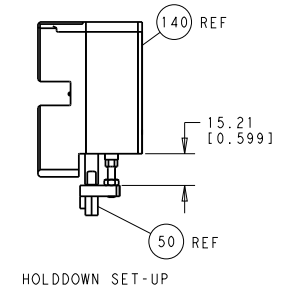
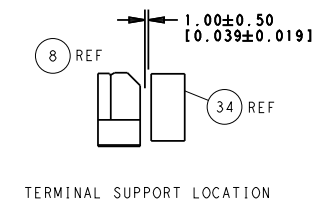
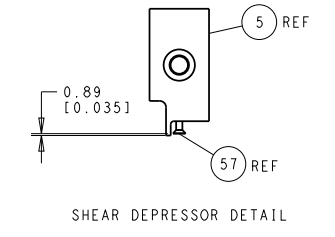
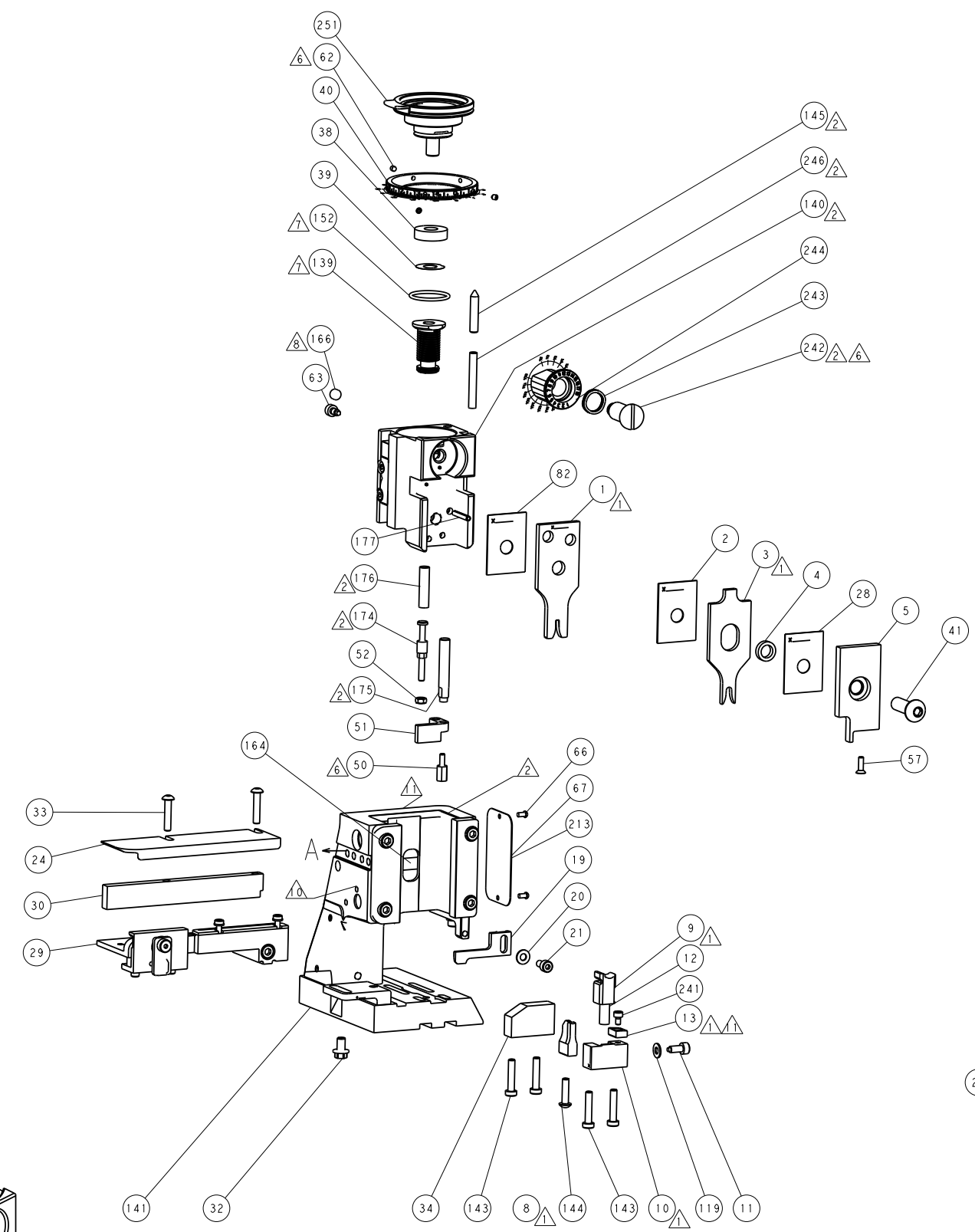
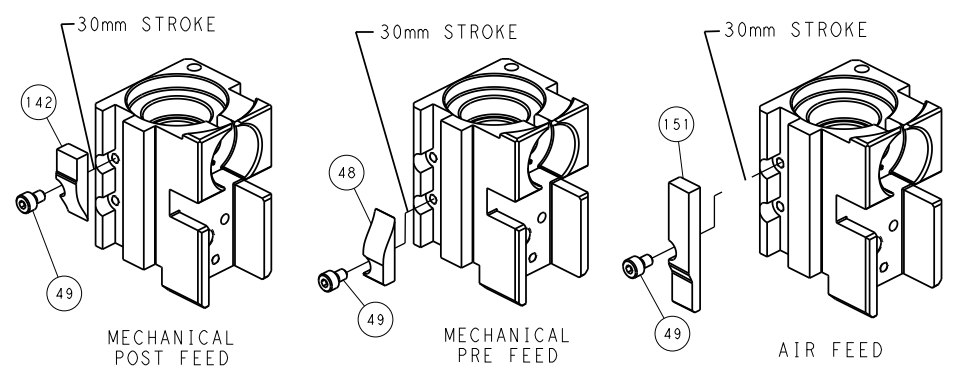
### PNEUMATIC



### 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:		OWN: BOB HIGMAN 23MAR2012	TE Connectivity
mm	0 PLC ±0.5	1 PLC ±0.13	2 PLC ±0.013	CHK: J. ELBIN 23MAR2012	Harrisburg, PA 17105-3608
	3 PLC ±0.013	4 PLC ±0.0001		APVD: M. CLIFFORD 23MAR2012	
	ANGLE: ±0.001			PRODUCT SPEC:	
	FINISH:			APPLICATION SPEC:	
MATERIAL:		WEIGHT:		SIZE: A	CAGE CODE: 00779
				DRAWING NO: ©-2151630	RESTRICTED TO:
				Customer Accessible Production Drawing	SCALE: 1:2 SHEET 4 OF 4 REV: A1

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION