

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
				CONVERT TO	PART NUMBERS REQUIRED						
				PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
2151647-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2151647-5	1901094-3	-	2168400-6 (QUANTITY 2)	
2151647-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
2151647-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151647-5	1901094-3	-	2168400-6 (QUANTITY 2)	
2151647-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
2151647-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
7-2151647-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	1.58 mm [.062]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: CONEXCON TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME:	2653 SERIES,	2.54mm	LATERAL LATCH
WIRE STRIP LENGTH	3.05-3.06 mm [.120-.121 IN]	INSULATION DIAMETER RANGE	Ø0.00-1.70 mm [.000-.067 IN]
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	CONEXCON TERMINAL	TE TERMINAL	CONEXCON TERMINAL
2113270-1	2653-T000		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.83+/-0.05 [.033+/- .002]	8.1
24 AWG	0.75+/-0.05 [.030+/- .002]	8.9
26 AWG	0.70+/-0.05 [.027+/- .002]	9.4
28 AWG	0.66+/-0.05 [.026+/- .002]	9.9

- 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: 8-2151647-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151647-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151647-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151647-6
- 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 ITEM 50.**
- 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
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-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)

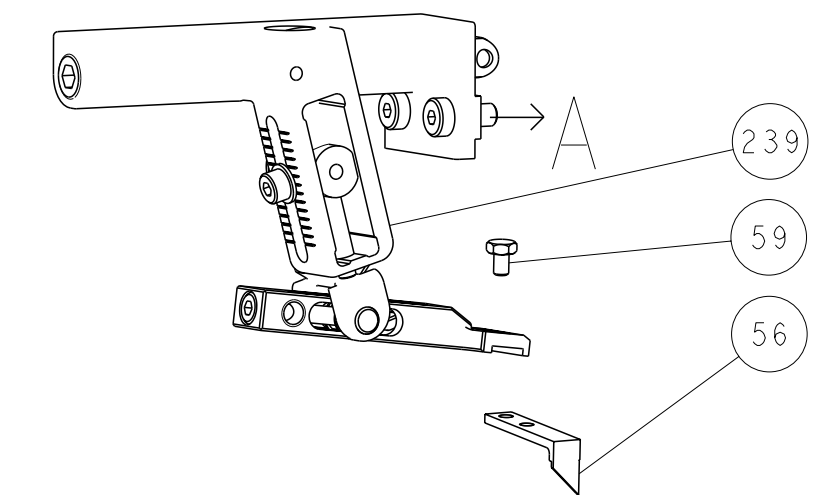
SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-1		A	66	P	DATE	BY	APPROV
				A	RELEASED	08JUN2012	RW GB

-	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	455888-6	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	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1	1-1752354-4	STANDOFF, HOLD-DOWN	50
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	-	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	1752356-1	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	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-2	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	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	1-1633932-0	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1-2119784-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1	1	5-568176-2	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

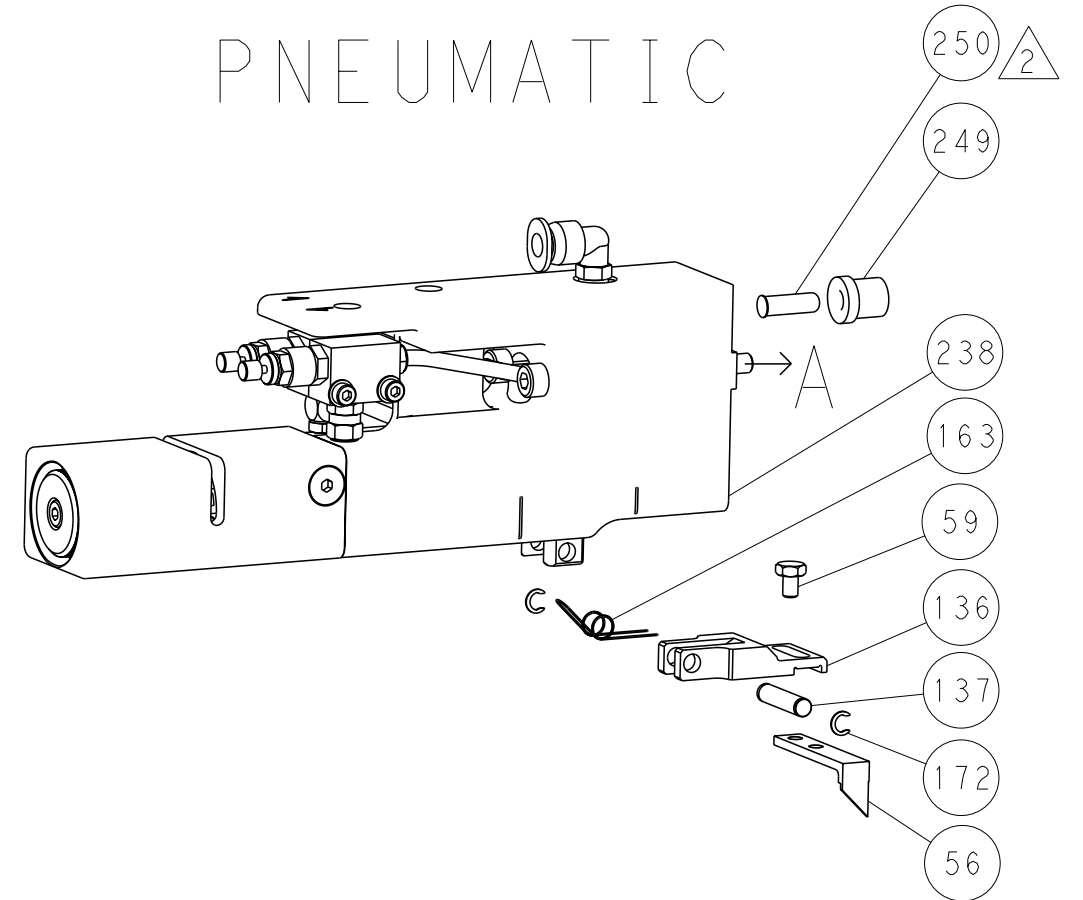
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mm	9 PLC ±0.1	3 PLC ±0.02	5 PLC ±0.005	4 PLC ±0.0005	FINISH
MATERIAL		FINISH		WEIGHT	
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REVOLUTION		REVISIONS			
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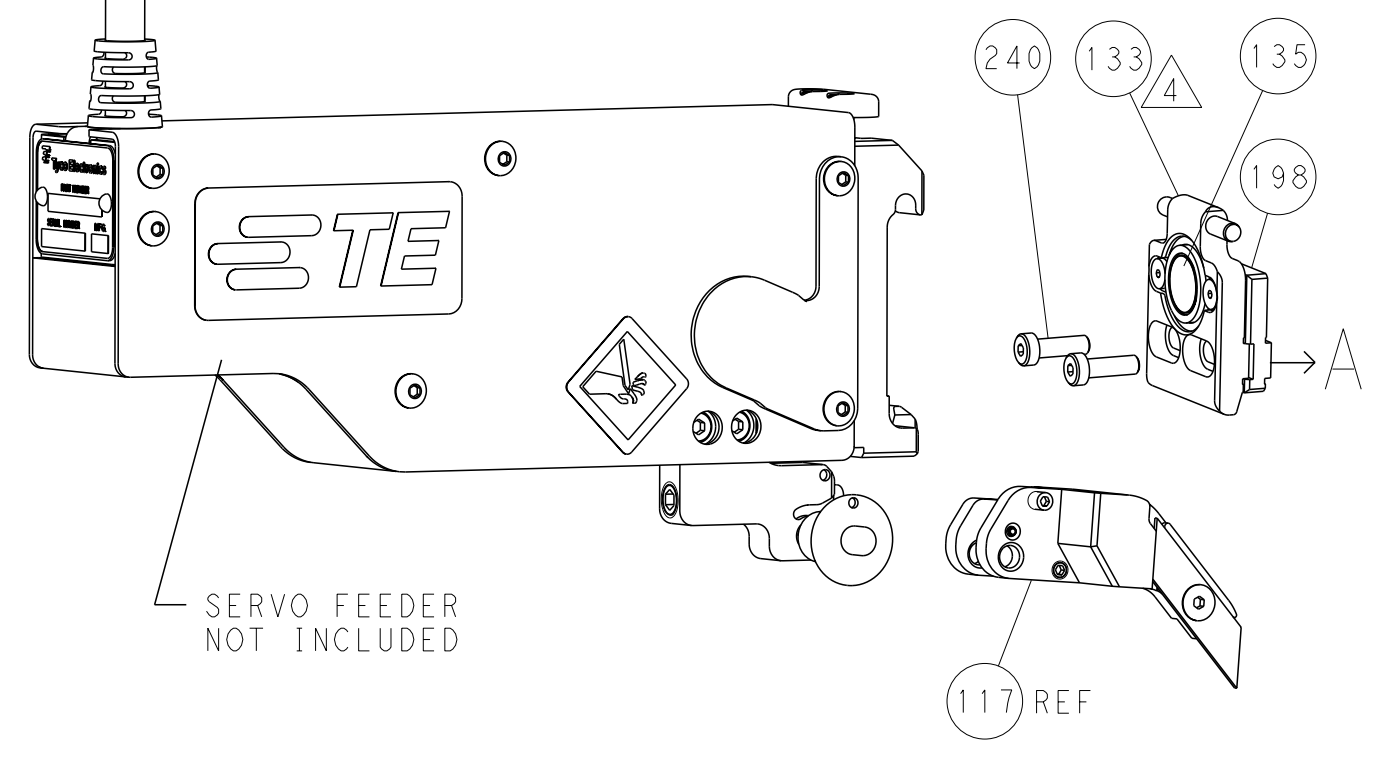
FEED TYPE MECHANICAL



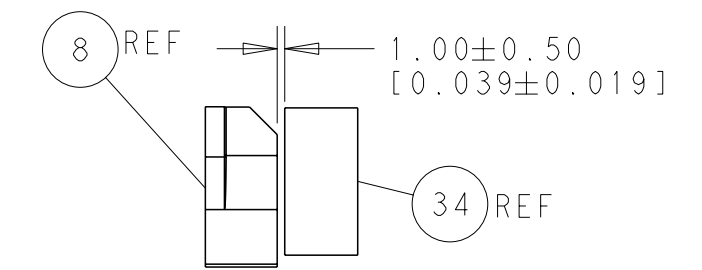
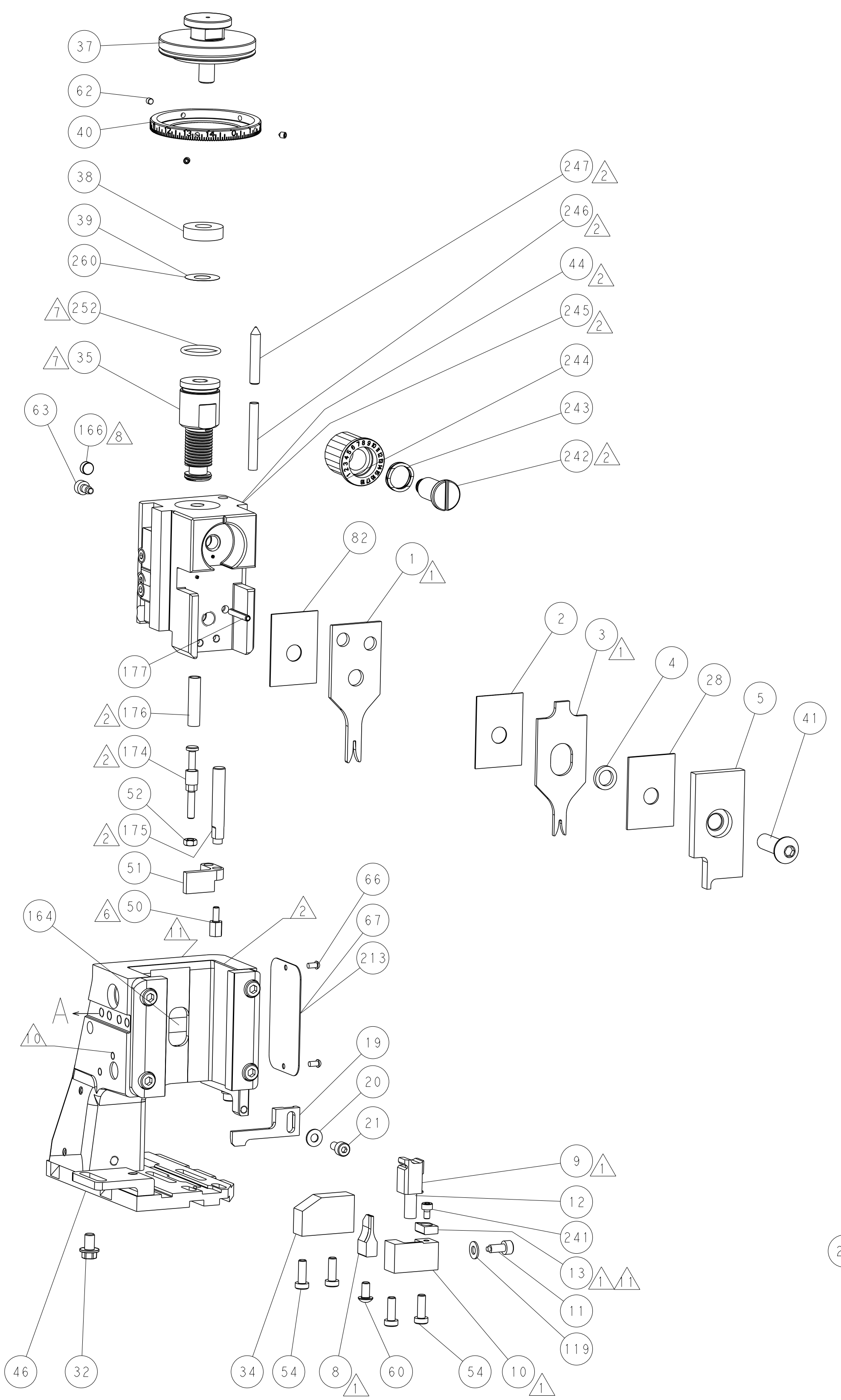
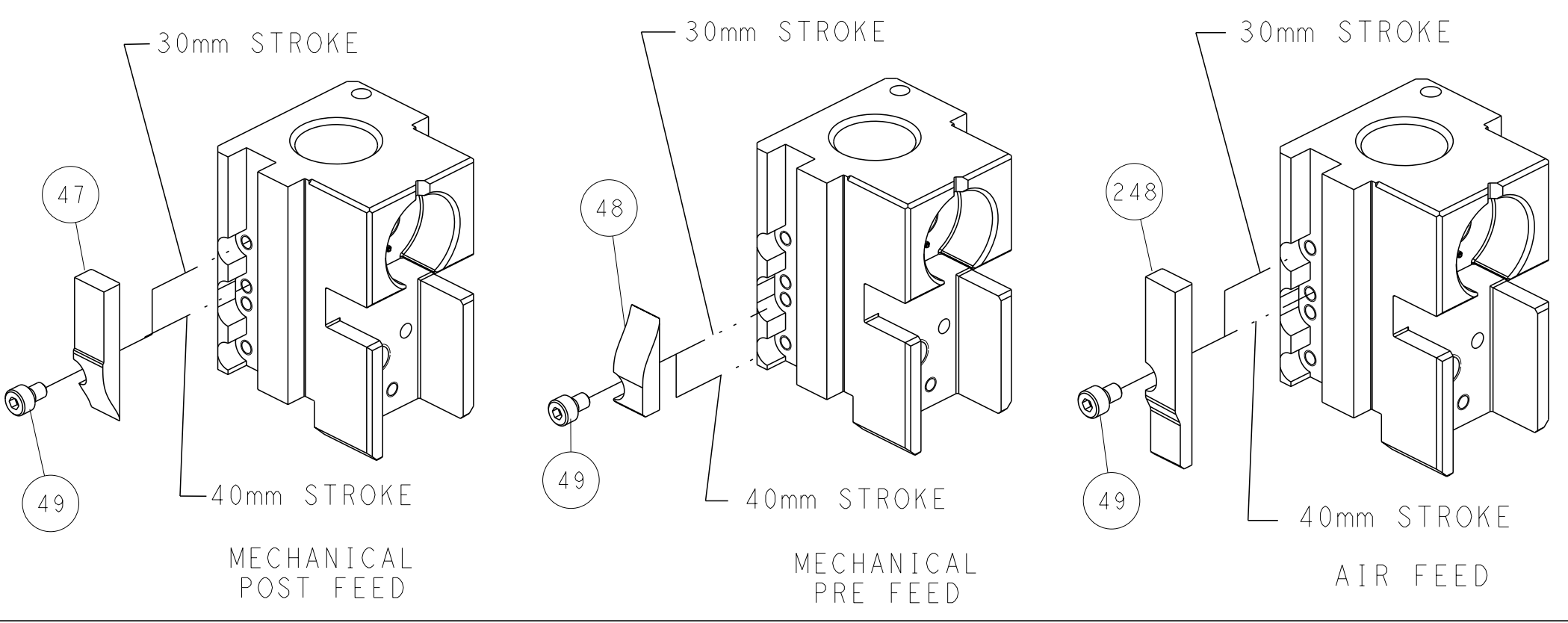
PNEUMATIC



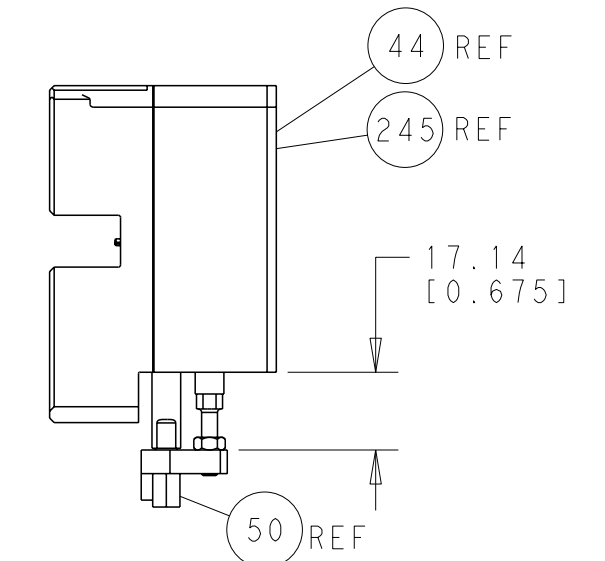
SERVO LATCH PLATE



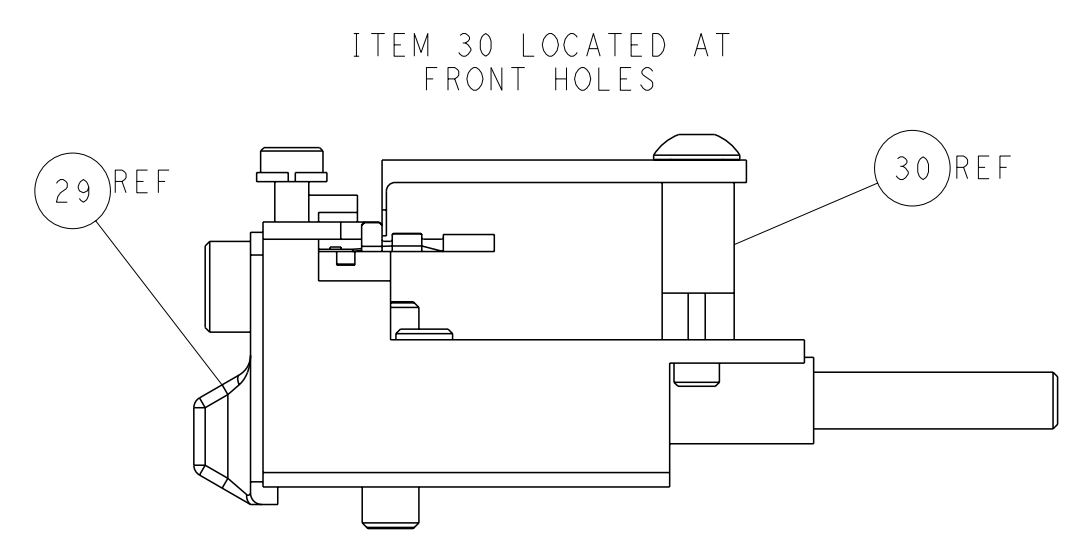
CAM POSITIONS



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 R. O. WILSON 14MAY2012		TE Connectivity	
mm	9 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.005	5 PLC ±0.005	Harrisburg, PA 17105-3608
	ANGLES	FINISH					
MATERIAL							
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:1	SHEET 2 OF 4	REV A	

Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a diagram of the Pacific Version Terminator Interface Adapter.

APPLICATOR DATA table with columns: CRIMP SIZE, WIRE SIZE, INSUL SIZE, TYPE.

Terminal data and application specifications table including wire strip length, insulation diameter, and terminal types.

Table showing crimp height and reference settings for various wire sizes (22 AWG to 28 AWG).

- 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...
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 ITEM 50.
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...
SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE...

*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.

Summary table with columns: 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)

REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD.

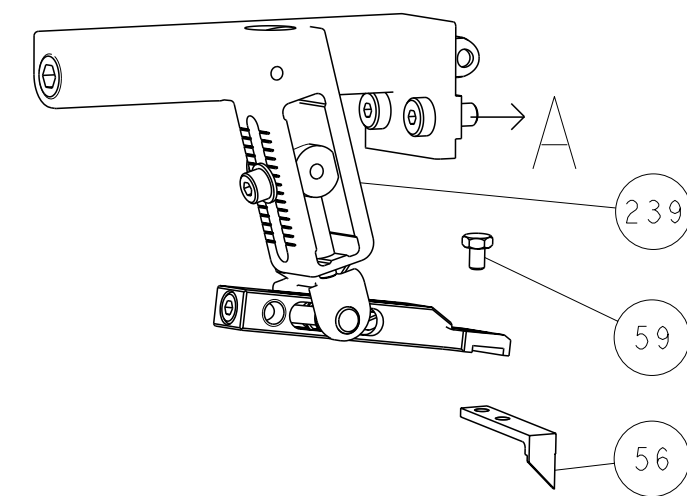
Main parts list table with columns: QTY, PART NO, DESCRIPTION, ITEM NO.

Product information block including dimensions, tolerances, material, weight, and customer accessible production drawing details.

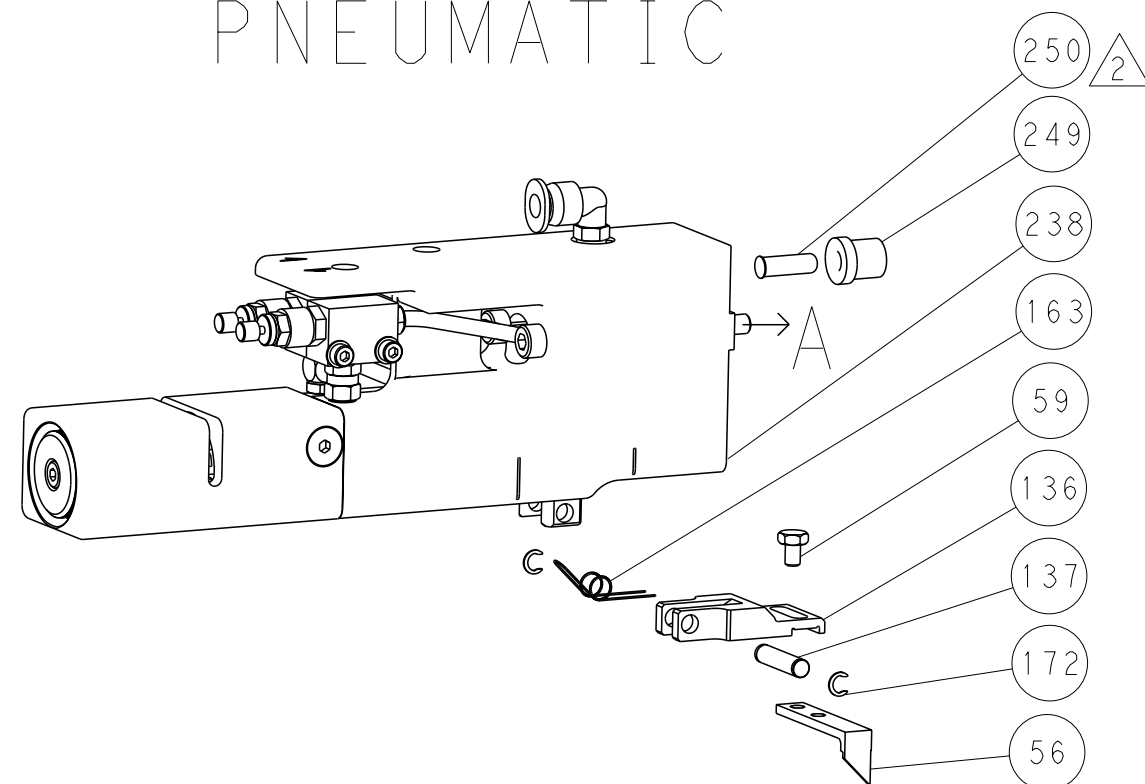
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

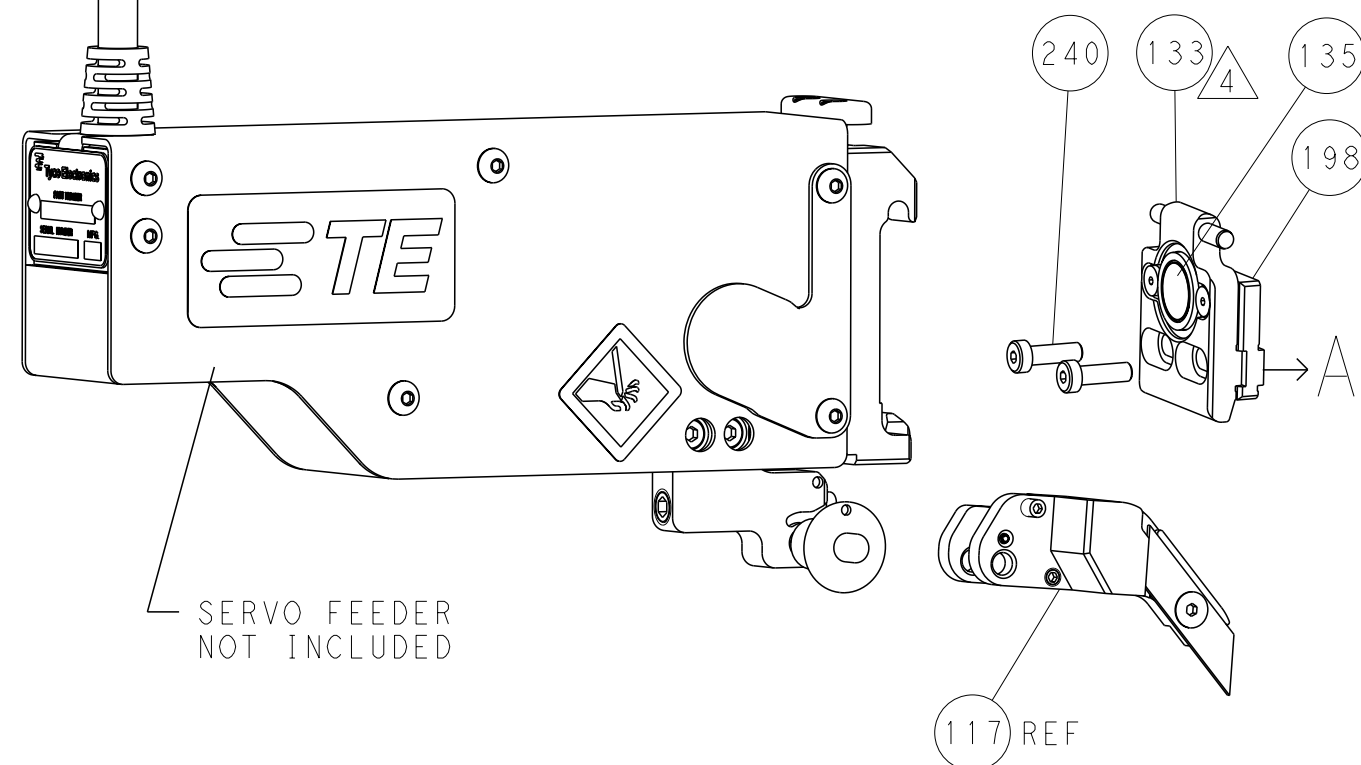
FEED TYPE MECHANICAL



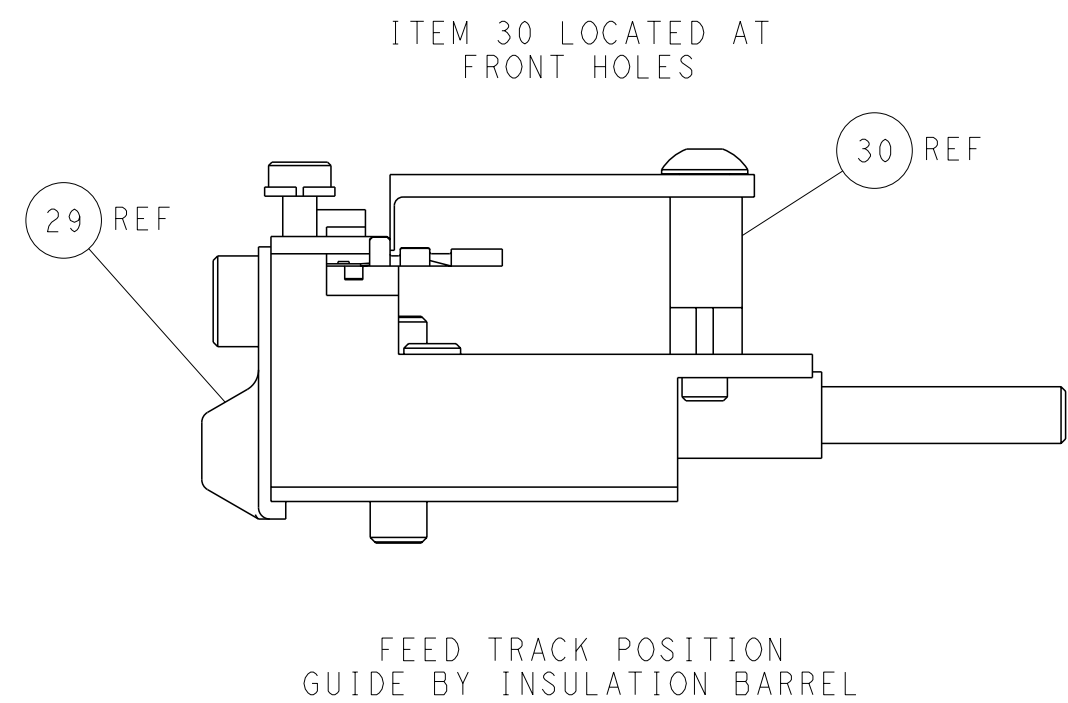
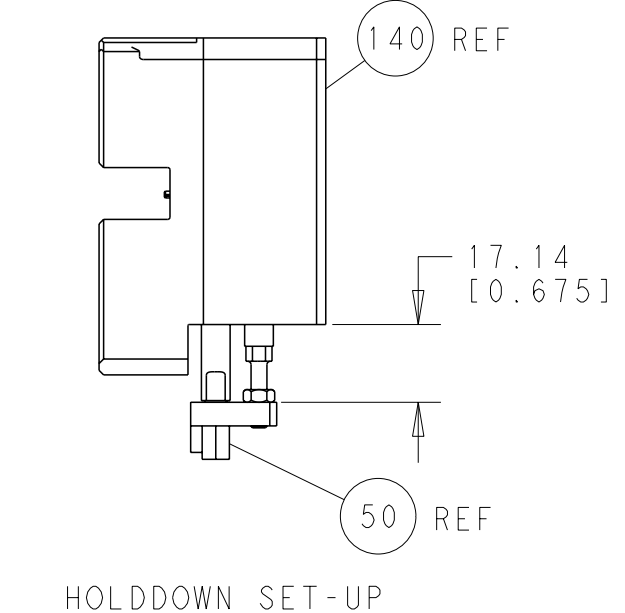
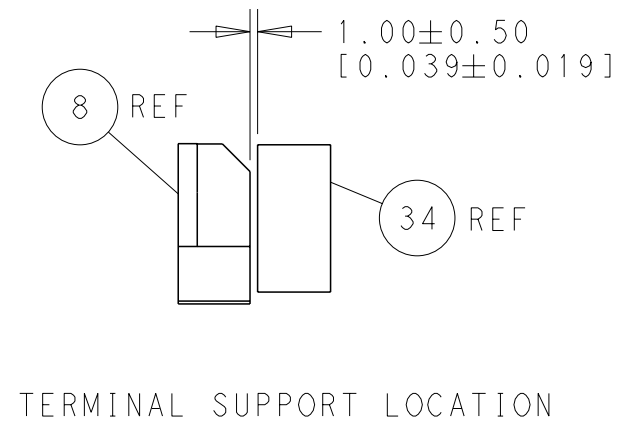
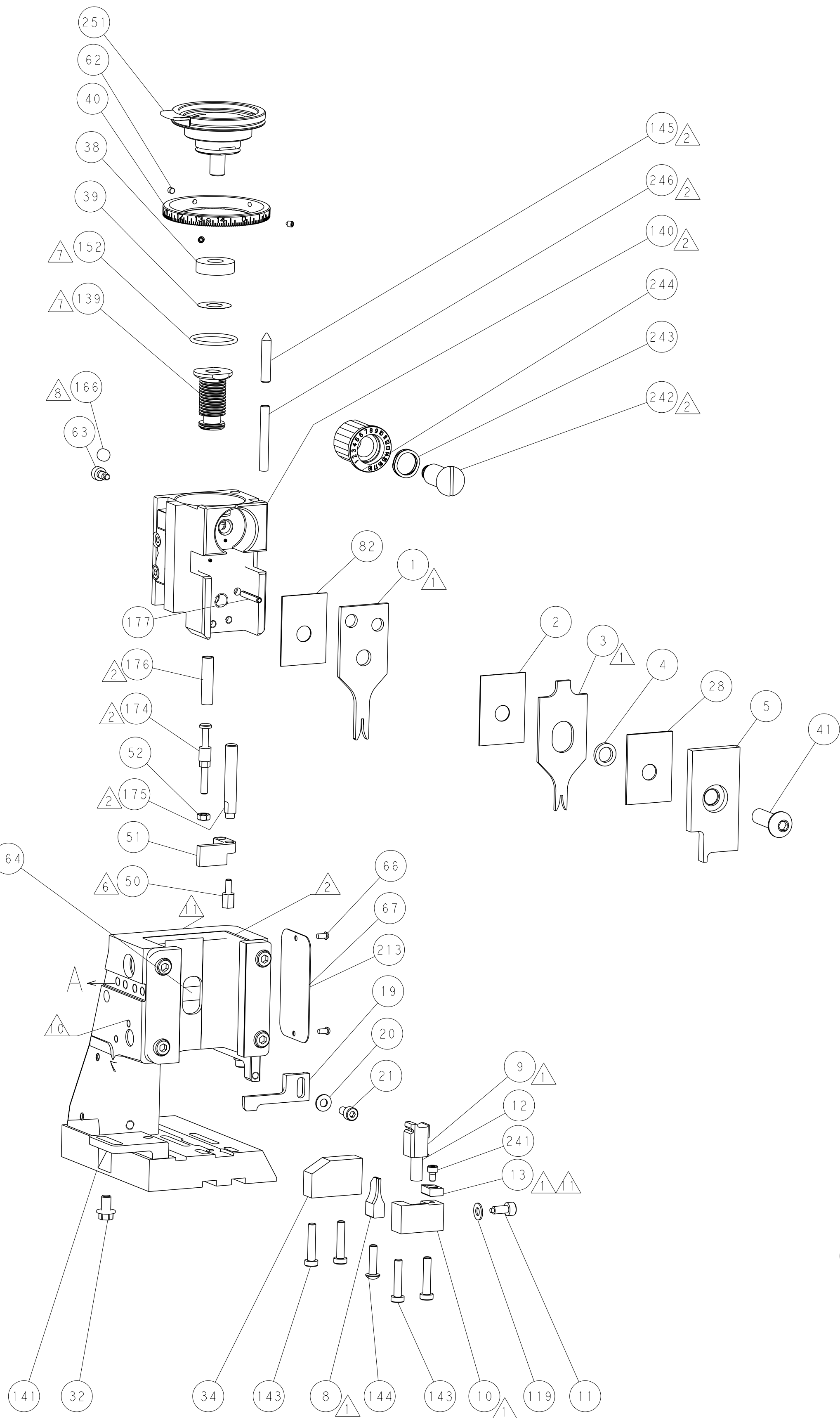
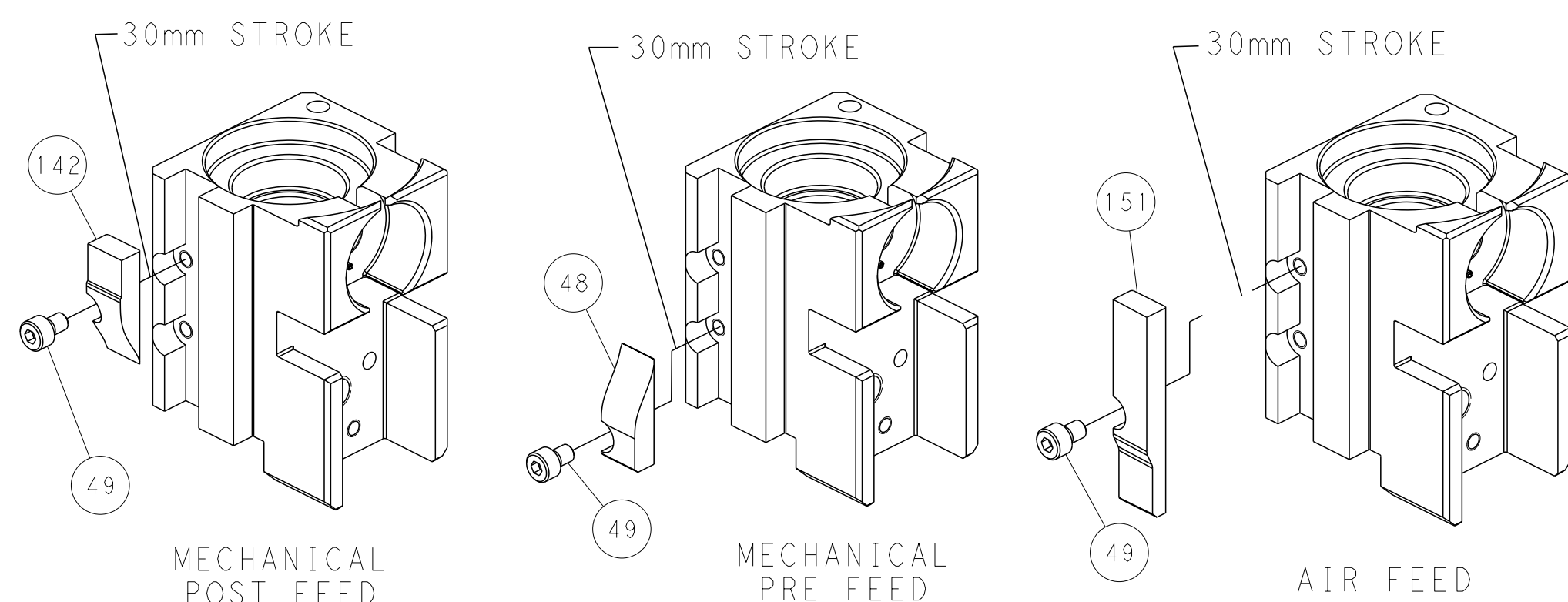
PNEUMATIC



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 R. O. WILSON 14MAY2012		TE Connectivity	
mm	9 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.005	5 PLC ±0.005	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK K. J. STAKEM 14MAY2012		NAME Ocean Side Feed Applicator	
APVD T. L. ELBIN 15MAY2012		PRODUCT SPEC:		APPLICATION SPEC:		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
WEIGHT:		SCALE 1:1		A1 00779 C-2151647		SHEET 4 OF 4 REV A	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1		SHEET 4 OF 4		REV A	