

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE         | CONVERT TO        | PART NUMBERS REQUIRED |           |             |             |           |                        |
|---|-------------|--------------------------|--------------------------|-------------------|-------------------|-----------------------|-----------|-------------|-------------|-----------|------------------------|
|   | 2151541-1   | D                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1   | 2119799-1 | 2063440-1              |
|   | 2151541-2   | D                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | SERVO LATCH PLATE | 2119951-1             | -         | 8-2151541-5 | 1901094-3   | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2151541-4 | -           | -         |                        |
|   |             |                          |                          |                   | MECHANICAL FEED   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1   | -         | -                      |
|   | 2151541-5   | D                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED   | 2119951-1             | -         | 8-2151541-5 | 1901094-3   | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                   |                   | SMART APPLICATOR      | 2161326-1 | -           | 8-2151541-4 | -         | -                      |
|   |             |                          |                          |                   |                   | PNEUMATIC FEED        | 2119949-1 | 1338685-1   | 5-18022-5   | 2119653-1 | -                      |
| 2151541-6                                     | D           | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE        | -                 | -                 | -                     | -         | -           | -           | -         |                        |
| 2151541-7                                     | D           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                 | -                 | -                     | -         | -           | -           | -         |                        |
| 7-2151541-7                                   | C           | CRIMP TOOLING KIT        | -                        | -                 | -                 | -                     | -         | -           | -           | -         |                        |

| APPLICATOR DATA |                 |      |
|-----------------|-----------------|------|
| CRIMP WIRE      | SIZE            | TYPE |
| 1.27 mm [0.050] |                 | F    |
| INSUL           | 1.83 mm [0.072] | O    |

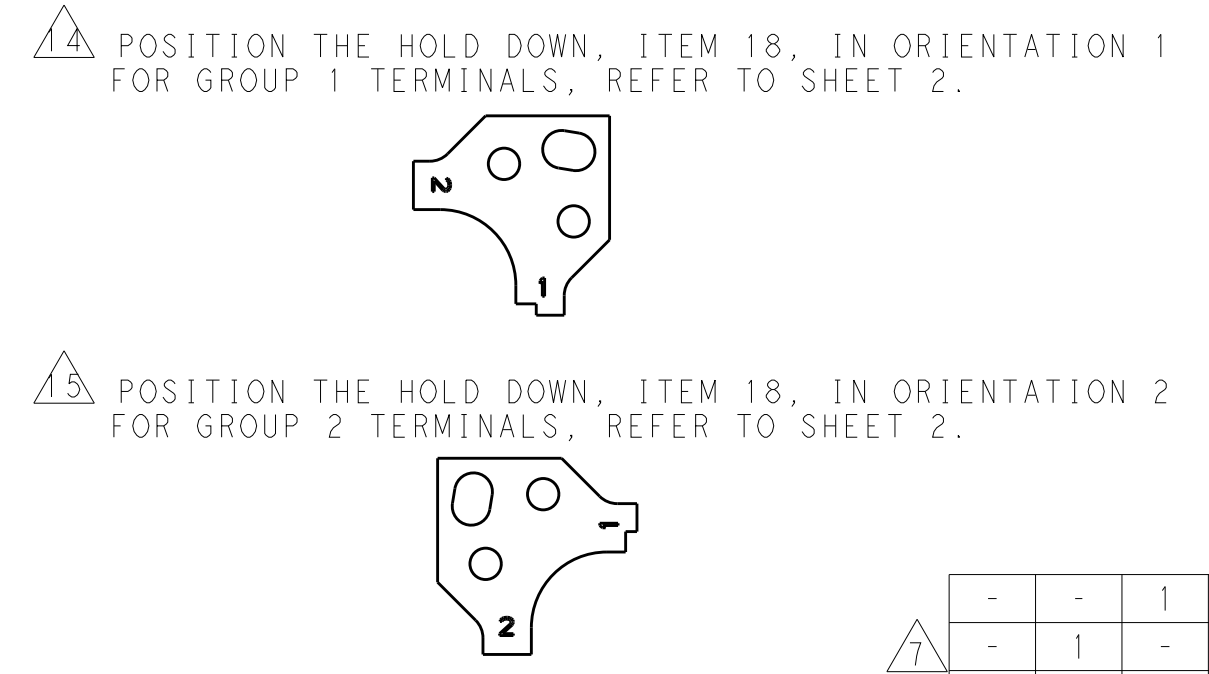
| TERMINAL DATA: TE TERMINAL          |                 | TE SPECIFICATION               |
|-------------------------------------|-----------------|--------------------------------|
| TERMINAL NAME: MICRO QUADLOK SYSTEM |                 |                                |
| WIRE STRIP LENGTH                   |                 | INSULATION DIAMETER RANGE      |
| 3.05-3.35 mm [0.120-.132 IN]        |                 | Ø 1.15-1.60 mm [0.045-.063 IN] |
| TERMINAL APPLICATION SPECIFICATION  | (A)114-18021    | -                              |
|                                     | (B)114-61024    | -                              |
| TERMINALS APPLIED                   |                 |                                |
| GROUP 1                             |                 | GROUP 2                        |
| TE TERMINAL                         | TE TERMINAL     | TE TERMINAL                    |
| (A) 928999-1                        | (A) 5-928918-2  | (A) 968220-1                   |
| (A) 928999-5                        | (A) 5-928918-1  | (A) 968220-5                   |
| (A) 928999-6                        | (A) 6-928918-1  | (A) 968220-6                   |
| (A) 5-928999-1                      | (A) 6-928918-2  | (A) 5-968220-1                 |
| (A) 5-928999-5                      | (A) 6-928918-3  | (A) 5-968220-5                 |
| (A) 5-928999-6                      | (A) 1394702-1   | (A) 5-968220-6                 |
| (A) 6-928999-5                      | (A) 1394702-2   | (B) 2005119-1                  |
| (A) 928918-1                        | (A) 5-1394702-1 |                                |
| (A) 928918-2                        | (A) 5-1394702-2 |                                |
| (A) 1-928918-1                      | (A) 968893-1    |                                |
| (A) 1-928918-2                      |                 |                                |

| WIRE SIZE           | CRIMP HEIGHT mm [INCH]         | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|--------------------------------|--------------------------------|
| 0.35mm <sup>2</sup> | 0.82 +/- 0.03 [0.032 +/- .001] | 9.3                            |
| 0.25mm <sup>2</sup> | 0.76 +/- 0.03 [0.030 +/- .001] | 10.0                           |
| 0.20mm <sup>2</sup> | 0.72 +/- 0.03 [0.028 +/- .001] | 10.4                           |

- 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: 8-2151541-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151541-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151541-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151541-6
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- 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 ACHIEVE A NOMINAL SHIM HEIGHT OF 1.00 mm.
- 13 REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm<sup>2</sup> WIRE.

| TERMINAL DATA: TE TERMINAL          |                 | TE SPECIFICATION               |
|-------------------------------------|-----------------|--------------------------------|
| TERMINAL NAME: MICRO QUADLOK SYSTEM |                 |                                |
| WIRE STRIP LENGTH                   |                 | INSULATION DIAMETER RANGE      |
| 3.05-3.35 mm [0.120-.132 IN]        |                 | Ø 1.15-1.60 mm [0.045-.063 IN] |
| TERMINAL APPLICATION SPECIFICATION  | (A)114-18021    | -                              |
|                                     | (B)114-61024    | -                              |
| TERMINALS APPLIED                   |                 |                                |
| GROUP 1                             |                 | GROUP 2                        |
| TE TERMINAL                         | TE TERMINAL     | TE TERMINAL                    |
| (A) 928999-1                        | (A) 5-928918-2  | (A) 968220-1                   |
| (A) 928999-5                        | (A) 5-928918-1  | (A) 968220-5                   |
| (A) 928999-6                        | (A) 6-928918-1  | (A) 968220-6                   |
| (A) 5-928999-1                      | (A) 6-928918-2  | (A) 5-968220-1                 |
| (A) 5-928999-5                      | (A) 6-928918-3  | (A) 5-968220-5                 |
| (A) 5-928999-6                      | (A) 1394702-1   | (A) 5-968220-6                 |
| (A) 6-928999-5                      | (A) 1394702-2   | (A) 1241918-1                  |
| (A) 928918-1                        | (A) 5-1394702-1 |                                |
| (A) 928918-2                        | (A) 5-1394702-2 |                                |
| (A) 1-928918-1                      | (A) 968893-1    |                                |
| (A) 1-928918-2                      |                 |                                |

| WIRE SIZE           | CRIMP HEIGHT mm [INCH]         | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|--------------------------------|--------------------------------|
| 0.50mm <sup>2</sup> | 0.92 +/- 0.03 [0.036 +/- .001] | 8.3                            |



**\*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     |
| -   | 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  | 2119082-5 | 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     |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO   | DESCRIPTION                         | ITEM NO |

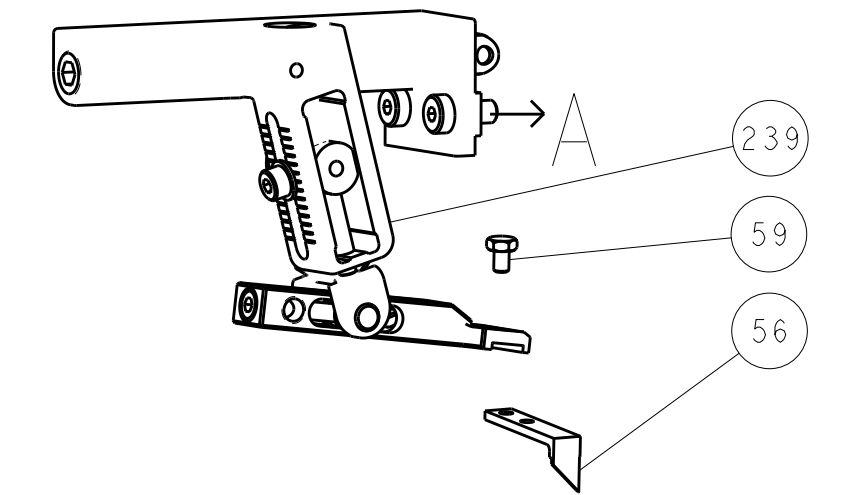
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS |               |           |        |
|--------------|-----|------|-----------|---------------|-----------|--------|
| 2119599-1    | A   | 66   | #         | DATE          | BY        | APP'D  |
|              |     |      | D1        | ECR-15-012960 | 7SEP2015  | RS UG  |
|              |     |      | D2        | ECR-15-013464 | 23SEP2015 | YY UG  |
|              |     |      | D3        | ECR-16-005398 | 13APR2016 | JH JDG |
|              |     |      | D4        | ECR-16-009395 | 30JUN2016 | YY JT  |

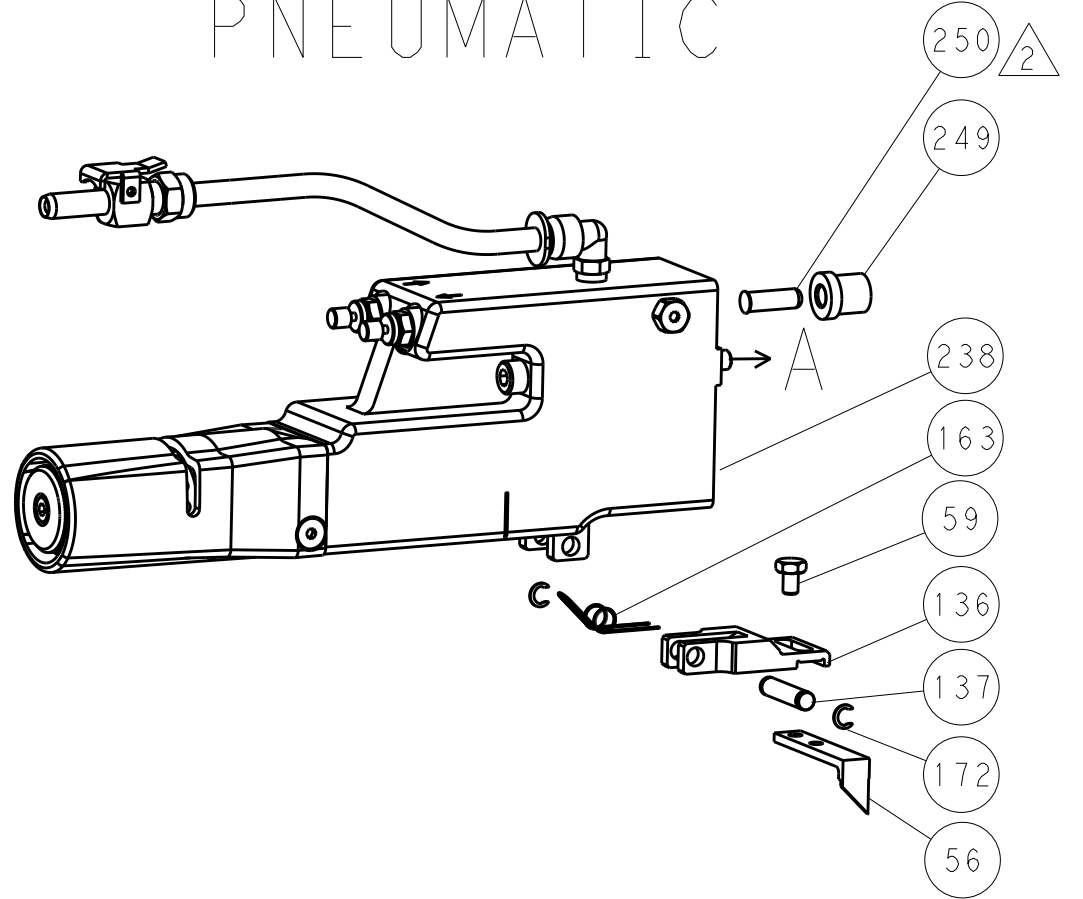
|   |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | 1   | 1   | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241 |
| - | -   | 2   | 2   | -   | -   | 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   | 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   | 1-690438-0  | FRONT STRIP GUIDE                   | 96  |
| - | 2   | 2   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95  |
| - | 1   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 1-240641-3  | SPACER                              | 81  |
| - | 2   | 2   | 2   | 2   | 2   | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)            | 79  |
| - | 1   | 1   | 1   | 1   | 1   | 1633782-2   | FENCE                               | 78  |
| - | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
| - | 1   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69  |
| - | 1   | -   | -   | 1   | 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  |
| - | 2   | 2   | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61  |
| - | 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  |
| - | 2   | 2   | 2   | 2   | 2   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 53  |
| - | -   | -   | -   | 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   | 1752356-6   | 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   | 2119959-3   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| - | 2   | 2   | 2   | 2   | 2   | 22283-1     | SPRING, COMPRESSION                 | 27  |
| - | 1   | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26  |
| - | 1   | 1   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25  |
| - | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23  |
| - | 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   | 2217529-1   | TERMINAL HOLD DOWN                  | 18  |
| - | 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   | 1332333-1   | ANVIL, COMBINATION, SPECIAL         | 8   |
| - | 1   | 1   | 1   | 1   | 1   | 4-240641-2  | SPACER                              | 7   |
| - | 1   | 1   | 1   | 1   | 1   | 2119757-4   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 238011-8    | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 1   | 1   | 1   | 1   | 1   | 2119784-2   | CRIMPER, INSULATION O PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     |     |

| REVISONS    |    | DATE | OWN | APVD |
|-------------|----|------|-----|------|
| A           | 66 |      |     |      |
| DESCRIPTION |    |      |     |      |
| SEE SHEET 1 |    |      |     |      |

### FEED TYPE MECHANICAL



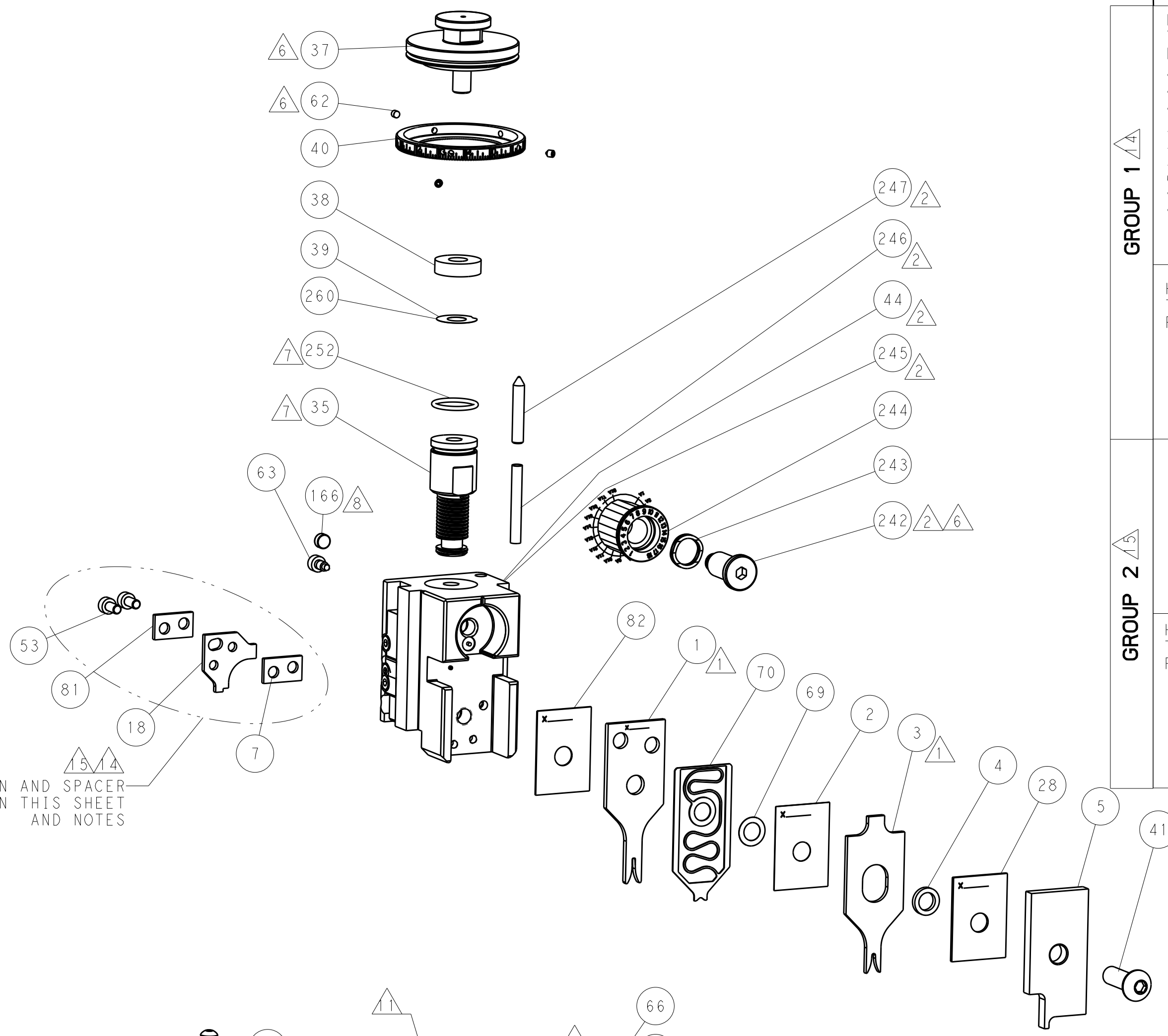
### PNEUMATIC



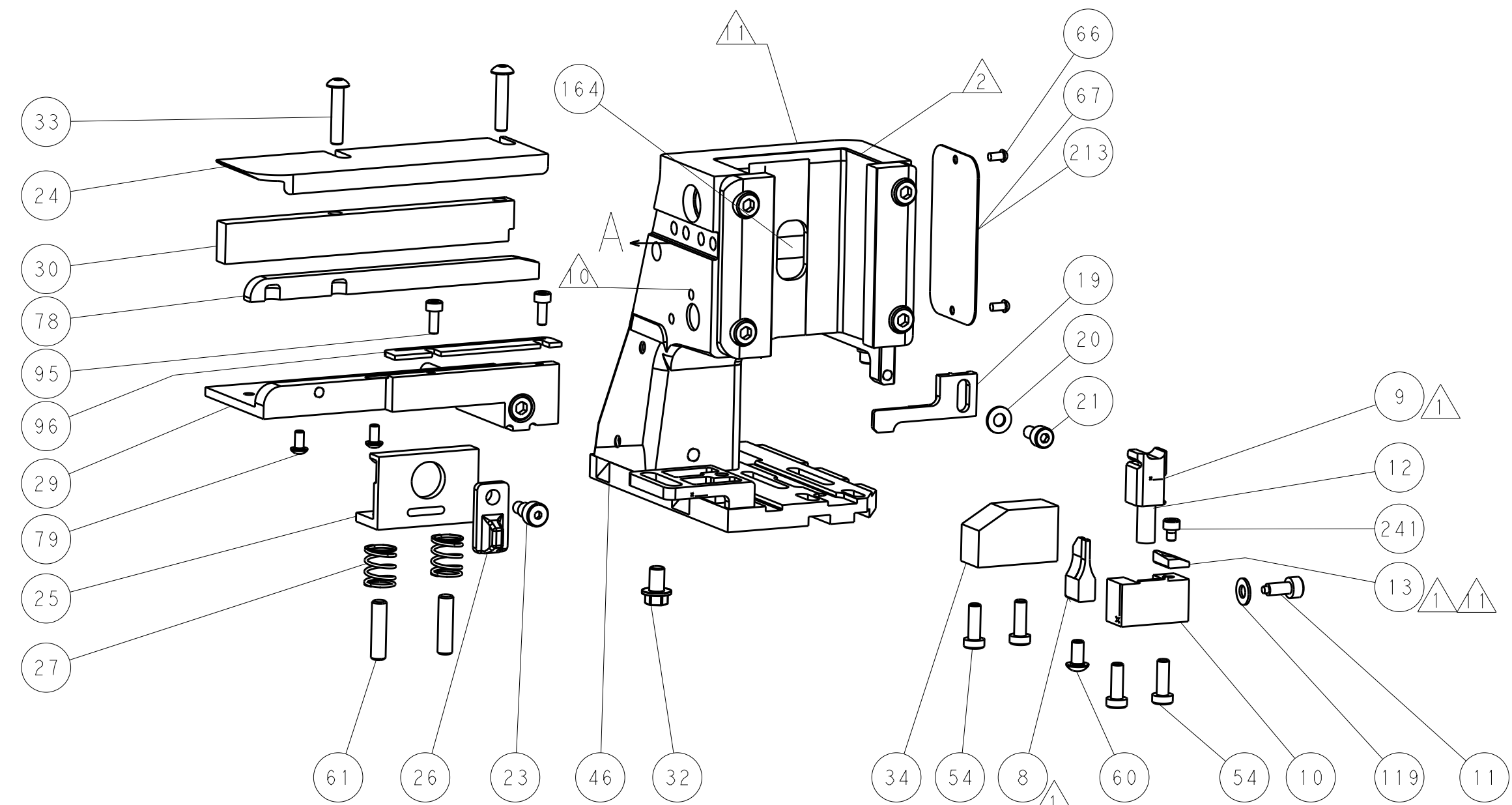
### SERVO LATCH PLATE



### CAM POSITIONS



SEE TERMINAL HOLD DOWN AND SPACER SETUP CHART ON THIS SHEET AND NOTES

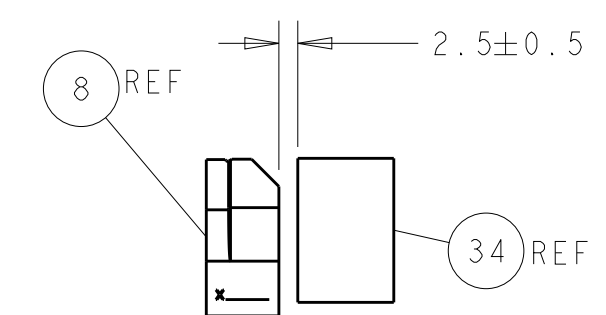


### TERMINAL HOLD DOWN & SPACER SETUP CHART

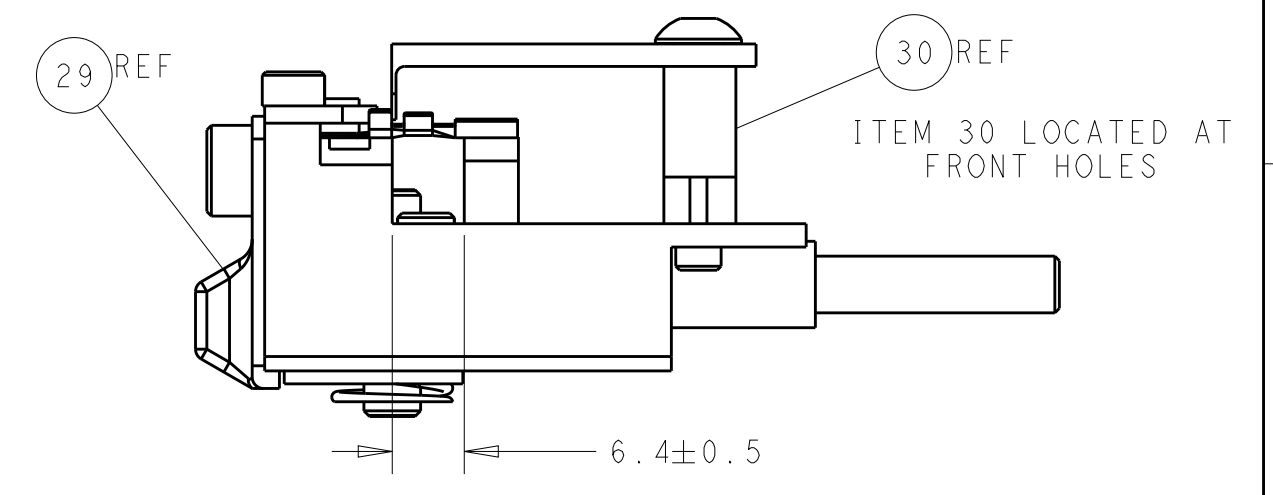
| GROUP   | HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:  | POSITION   |
|---------|--|------------|
| GROUP 1 | 928999-1 2-928918-2<br>928999-5 3-928918-2<br>928999-6 5-928918-1<br>5-928999-1 6-928918-2<br>5-928999-5 6-928918-2<br>5-928999-6 6-928918-3<br>6-928999-5 1394702-1<br>928918-1 1394702-2<br>928918-2 1394702-2<br>1-928918-1 5-1394702-1<br>1-928918-2 5-1394702-2 | POSITION 1 |
|         | HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:<br>968893-1  | POSITION 1 |
| GROUP 2 | HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:<br>968220-1 5-968220-6<br>968220-5 1703296-1<br>968220-6 1703296-5<br>5-968220-1 1534116-1<br>5-968220-5 1534116-2<br>5-968220-5 5-1534116-1   | POSITION 2 |
|         | HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:<br>1241918-1   | POSITION 2 |



HOLD DOWN SETUP



TERMINAL SUPPORT LOCATION



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: HOFFNER 07DEC2001   |         | TE Connectivity                  |                           |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                  | 4 PLC ± | 5 PLC ±                          | Harrisburg, PA 17105-3608 |
|             | FINISH  |  |         | CHK: T. ELBIN 08DEC2011  |         | NAME: Ocean Side Feed Applicator |                           |
| MATERIAL:   |         |  |         | APVD: T. ELBIN 08DEC2011 |         | PRODUCT SPEC:                    |                           |
|             |         |  |         | APPLICATION SPEC:        |         | SIZE: CAGE CODE: DRAWING NO:     |                           |
|             |         |  |         | WEIGHT:                  |         | RESTRICTED TO:                   |                           |
|             |         |  |         | CUSTOMER DRAWING:        |         | SCALE: 5:1 SHEET 2 OF 4 REV: 4   |                           |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|  |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|  | 2-2151541-1 | D        | 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             | -         | 8-2151541-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151541-4 | -         | -         | -                      |
|  | 2-2151541-2 | D        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151541-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151541-4 | -         | -         | -                      |
|  | 2-2151541-5 | D        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 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              |
|  | 2-2151541-7 | D        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | -         | -                      |
|  | 7-2151541-7 | C        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP WIRE      | SIZE           | TYPE |
|                 | 1.27 mm [.050] | F    |
| INSUL           | 1.83 mm [.072] | O    |

APPLICATOR INSTRUCTIONS 408-10389

| TERMINAL DATA: TE TERMINAL          |              | TE SPECIFICATION              |  |
|-------------------------------------|--------------|-------------------------------|--|
| TERMINAL NAME: MICRO QUADLOK SYSTEM |              |                               |  |
| WIRE STRIP LENGTH                   |              | INSULATION DIAMETER RANGE     |  |
| 3.05-3.35 mm [1.20-.132 IN]         |              | Ø1.15-1.60 mm [1.045-.063 IN] |  |
| TERMINAL APPLICATION SPECIFICATION  | (A)114-18021 |                               |  |
|                                     | (B)114-61024 |                               |  |

| TERMINALS APPLIED |                 |                |                 |
|-------------------|-----------------|----------------|-----------------|
| GROUP 1           |                 | GROUP 2        |                 |
| TE TERMINAL       | TE TERMINAL     | TE TERMINAL    | TE TERMINAL     |
| (A) 928999-1      | (A) 5-928918-2  | (A) 968220-1   | (A) 1703296-1   |
| (A) 928999-5      | (A) 5-928918-1  | (A) 968220-5   | (A) 1703296-5   |
| (A) 928999-6      | (A) 6-928918-1  | (A) 968220-6   | (A) 1534116-1   |
| (A) 5-928999-1    | (A) 6-928918-2  | (A) 5-968220-1 | (A) 1534116-2   |
| (A) 5-928999-5    | (A) 6-928918-3  | (A) 5-968220-5 | (A) 5-1534116-1 |
| (A) 5-928999-6    | (A) 1394702-1   | (A) 5-968220-6 | (A) 5-1534116-2 |
| (A) 6-928999-5    | (A) 1394702-2   | (B) 2005119-1  | (A) 1241918-1   |
| (A) 928918-1      | (A) 5-1394702-1 |                |                 |
| (A) 928918-2      | (A) 5-1394702-2 |                |                 |
| (A) 1-928918-1    | (A) 968893-1    |                |                 |
| (A) 1-928918-2    |                 |                |                 |

| WIRE SIZE           | CRIMP HEIGHT mm [INCH]         | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|--------------------------------|--------------------------------|
| 0.35mm <sup>2</sup> | 0.82 +/- 0.03 [0.032 +/- .001] | 9.3                            |
| 0.25mm <sup>2</sup> | 0.76 +/- 0.03 [0.030 +/- .001] | 10.0                           |
| 0.20mm <sup>2</sup> | 0.72 +/- 0.03 [0.028 +/- .001] | 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: 8-2151541-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151541-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151541-5
- 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 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
- REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm<sup>2</sup> WIRE.

| TERMINAL DATA: TE TERMINAL          |              | TE SPECIFICATION              |  |
|-------------------------------------|--------------|-------------------------------|--|
| TERMINAL NAME: MICRO QUADLOK SYSTEM |              |                               |  |
| WIRE STRIP LENGTH                   |              | INSULATION DIAMETER RANGE     |  |
| 3.05-3.35 mm [1.20-.132 IN]         |              | Ø1.15-1.60 mm [1.045-.063 IN] |  |
| TERMINAL APPLICATION SPECIFICATION  | (A)114-18021 |                               |  |
|                                     | (B)114-61024 |                               |  |

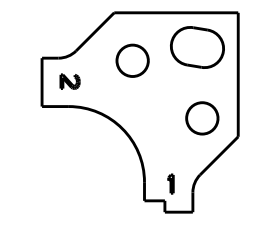
  

| TERMINALS APPLIED |                 |                |                 |
|-------------------|-----------------|----------------|-----------------|
| GROUP 1           |                 | GROUP 2        |                 |
| TE TERMINAL       | TE TERMINAL     | TE TERMINAL    | TE TERMINAL     |
| (A) 928999-1      | (A) 5-928918-2  | (A) 968220-1   | (A) 1703296-1   |
| (A) 928999-5      | (A) 5-928918-1  | (A) 968220-5   | (A) 1703296-5   |
| (A) 928999-6      | (A) 6-928918-1  | (A) 968220-6   | (A) 1534116-1   |
| (A) 5-928999-1    | (A) 6-928918-2  | (A) 5-968220-1 | (A) 1534116-2   |
| (A) 5-928999-5    | (A) 6-928918-3  | (A) 5-968220-5 | (A) 5-1534116-1 |
| (A) 5-928999-6    | (A) 1394702-1   | (A) 5-968220-6 | (A) 5-1534116-2 |
| (A) 6-928999-5    | (A) 1394702-2   |                | (A) 1241918-1   |
| (A) 928918-1      | (A) 5-1394702-1 |                |                 |
| (A) 928918-2      | (A) 5-1394702-2 |                |                 |
| (A) 1-928918-1    | (A) 968893-1    |                |                 |
| (A) 1-928918-2    |                 |                |                 |

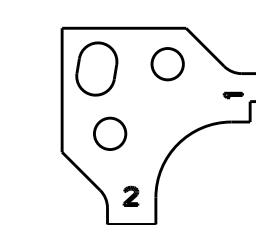
| WIRE SIZE           | CRIMP HEIGHT mm [INCH]         | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|--------------------------------|--------------------------------|
| 0.50mm <sup>2</sup> | 0.92 +/- 0.03 [0.036 +/- .001] | 8.3                            |

**\*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.

POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS, REFER TO SHEET 2.



POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS, REFER TO SHEET 2.



|     |     |     |     |     |           |                                     |         |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |
| -   | -   | -   | 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   | 2119082-5 | 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     |
| -77 | -27 | -25 | -22 | -21 | PART NO   | DESCRIPTION                         | ITEM NO |

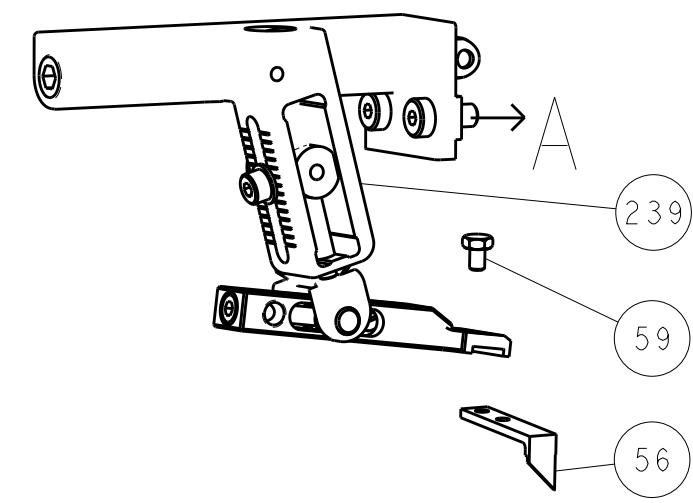
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS |             |    |      |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-1    | A   | 66   | REV       | DATE        | BY | APPV |
|              |     |      | -         | SEE SHEET 1 |    |      |

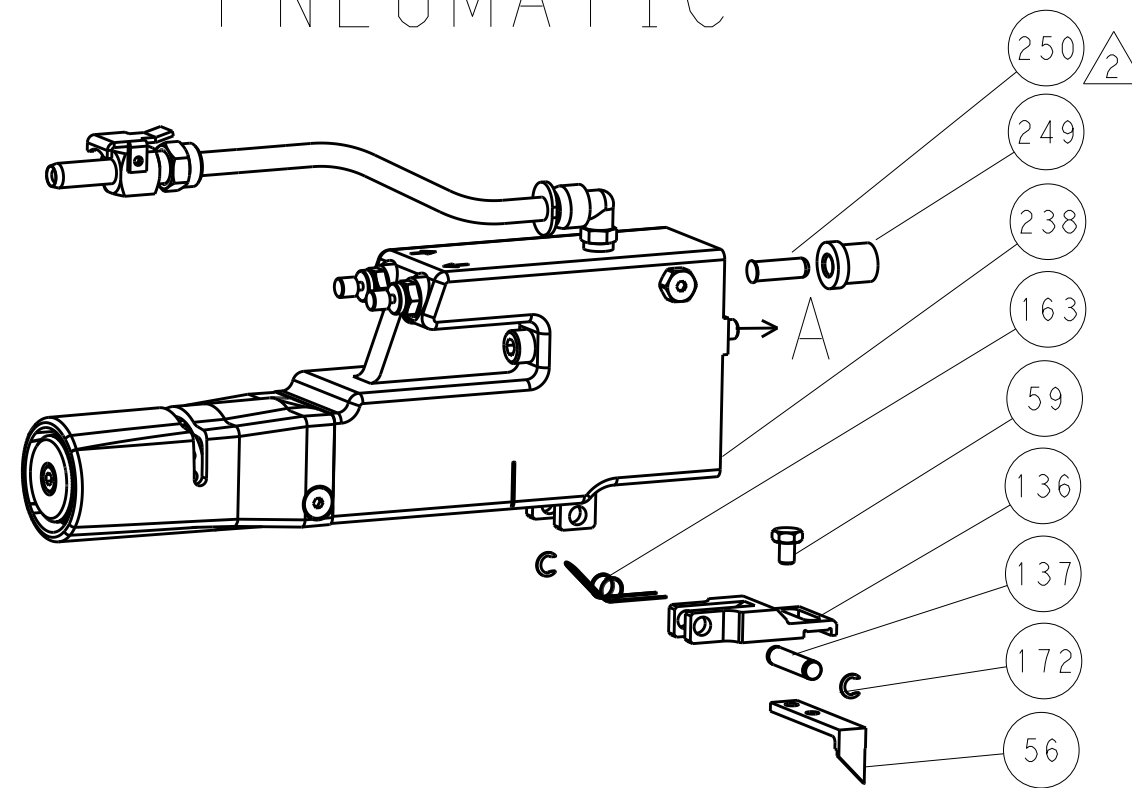
|     |     |     |     |     |             |                                     |     |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| -   | -   | 2   | -   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240 |
| -   | -   | -   | -   | 1   | 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 |
| -   | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
|     | -   | 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   | 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   | 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   | 1-690438-0  | FRONT STRIP GUIDE                   | 96  |
| -   | 2   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95  |
| -   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82  |
|     | -   | 1   | 1   | 1   | 1-240641-3  | SPACER                              | 81  |
| -   | 2   | 2   | 2   | 2   | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)            | 79  |
| -   | 1   | 1   | 1   | 1   | 1633782-2   | FENCE                               | 78  |
| -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| -   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
| -   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69  |
| -   | 1   | -   | 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   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62  |
| -   | 2   | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61  |
| -   | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| -   | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| -   | 2   | 2   | 2   | 2   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 53  |
| -   | -   | -   | 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   | 2119644-1   | RAM WASHER, PRECISION               | 38  |
| -   | 1   | 1   | 1   | 1   | 1752356-6   | 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   | 1320908-6   | SPACER, STRIP GUIDE                 | 30  |
| -   | 1   | 1   | 1   | 1   | 2119959-3   | ASSEMBLY, STRIP GUIDE               | 29  |
| -   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| -   | 2   | 2   | 2   | 2   | 22283-1     | SPRING, COMPRESSION                 | 27  |
| -   | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26  |
| -   | 1   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25  |
| -   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| -   | 1   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23  |
| -   | 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   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
|     | -   | 1   | 1   | 1   | 2217529-1   | TERMINAL 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   | 462006-6    | FLOATING SHEAR, FRONT               | 9   |
|     | 1   | 1   | 1   | 1   | 1333233-1   | ANVIL, COMBINATION, SPECIAL         | 8   |
|     | -   | 1   | 1   | 1   | 4-240641-2  | SPACER                              | 7   |
| -   | 1   | 1   | 1   | 1   | 2119757-4   | DEPRESSOR, SHEAR                    | 5   |
| -   | 1   | 1   | 1   | 1   | 238011-8    | BLOCK, CRIMPER SPACER               | 4   |
|     | 1   | 1   | 1   | 1   | 2119784-2   | CRIMPER, INSULATION O PREMIUM       | 3   |
| -   | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2   |
|     | 1   | 1   | 1   | 1   | 5-568176-3  | CRIMPER, WIRE                       | 1   |
| -77 | -27 | -25 | -22 | -21 | PART NO     | DESCRIPTION                         |     |



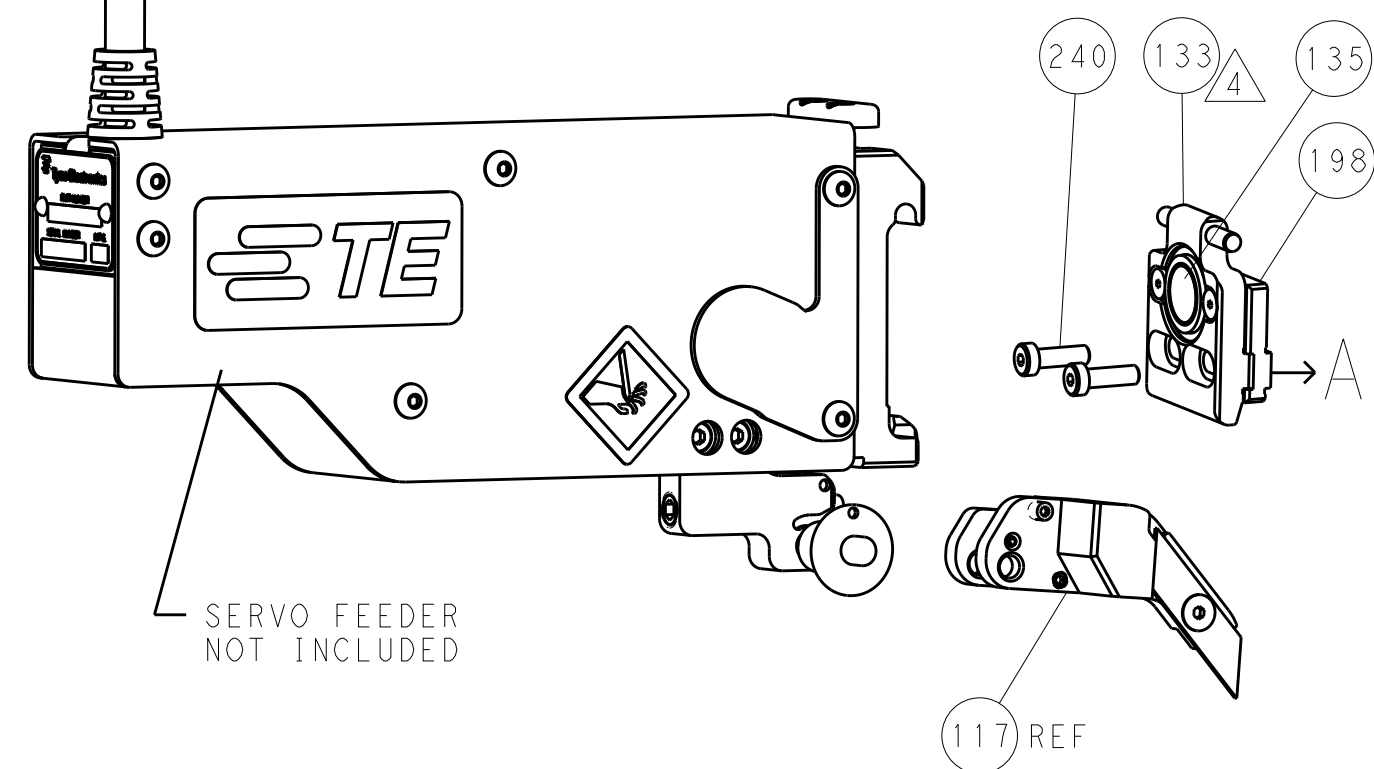
# FEED TYPE MECHANICAL



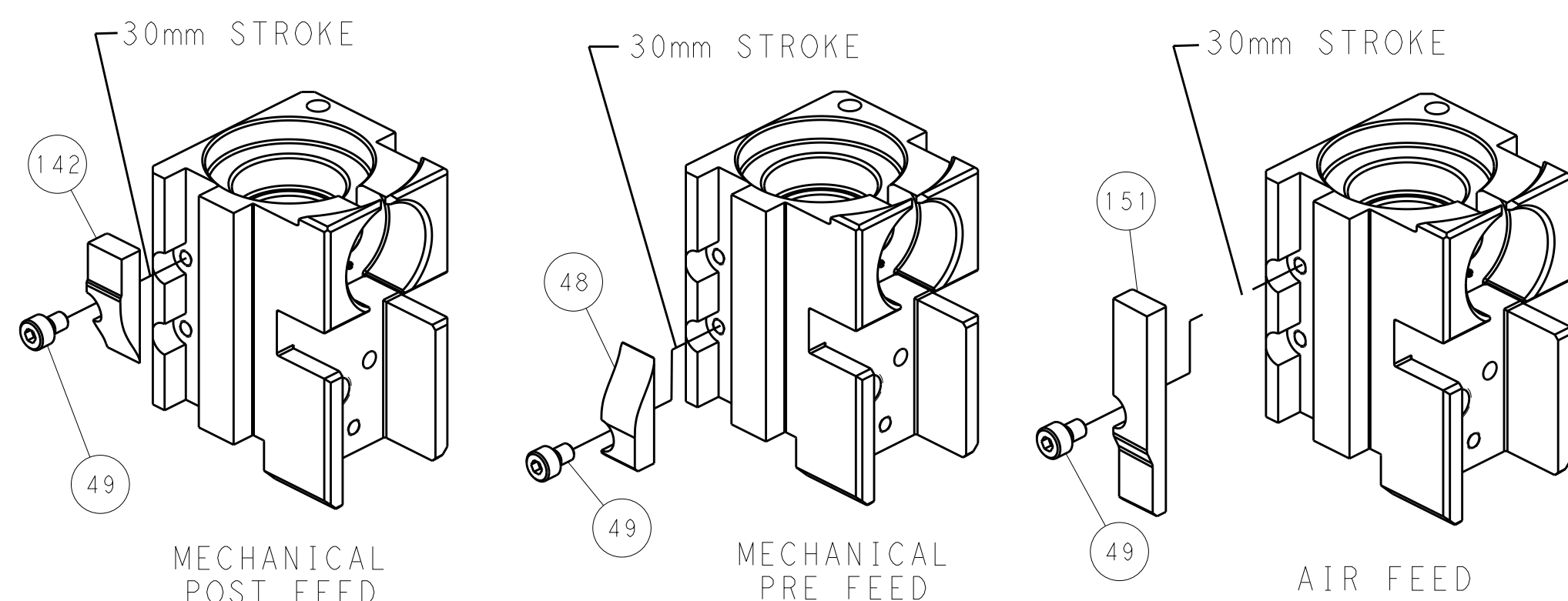
# PNEUMATIC



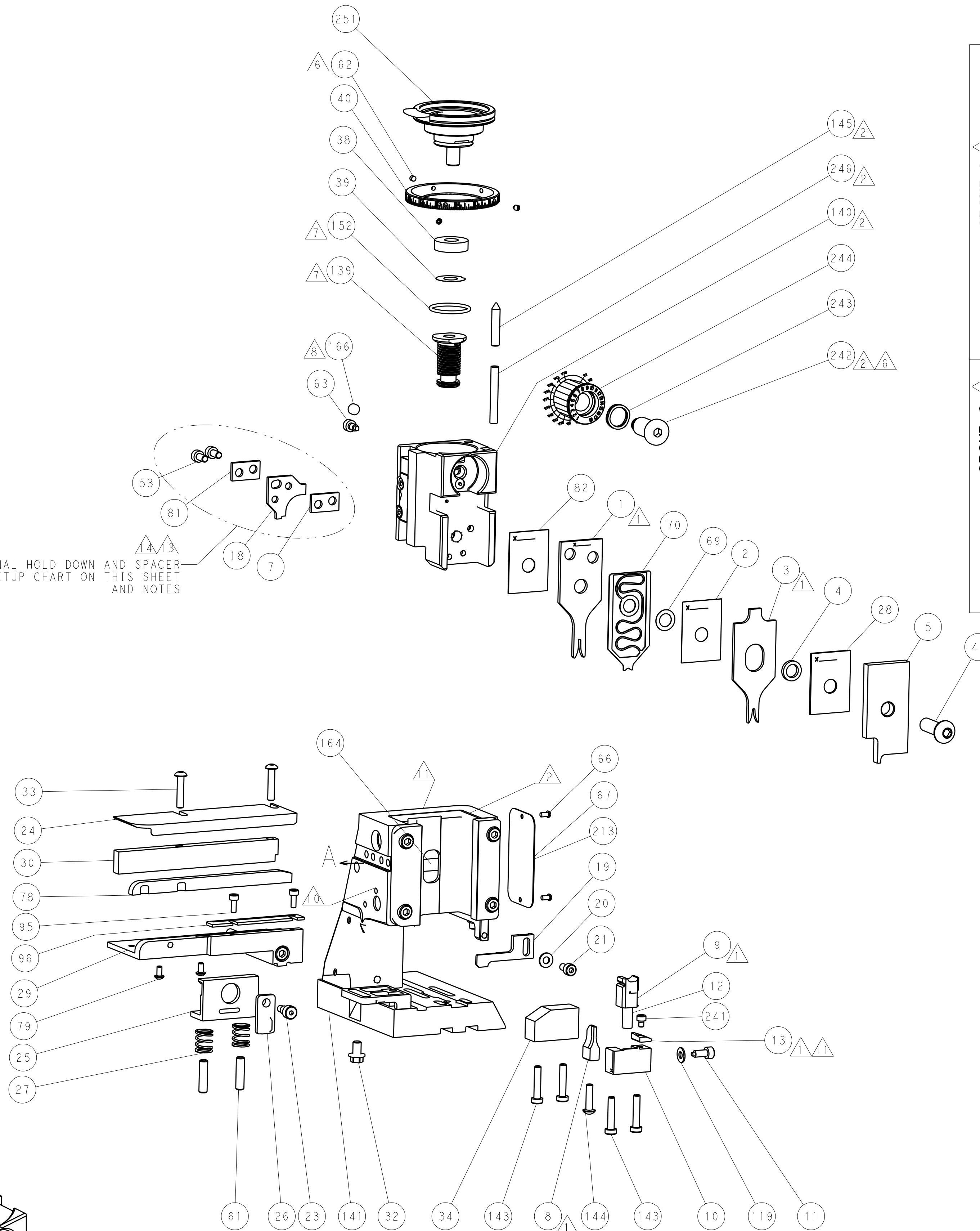
# SERVO LATCH PLATE



# CAM POSITIONS



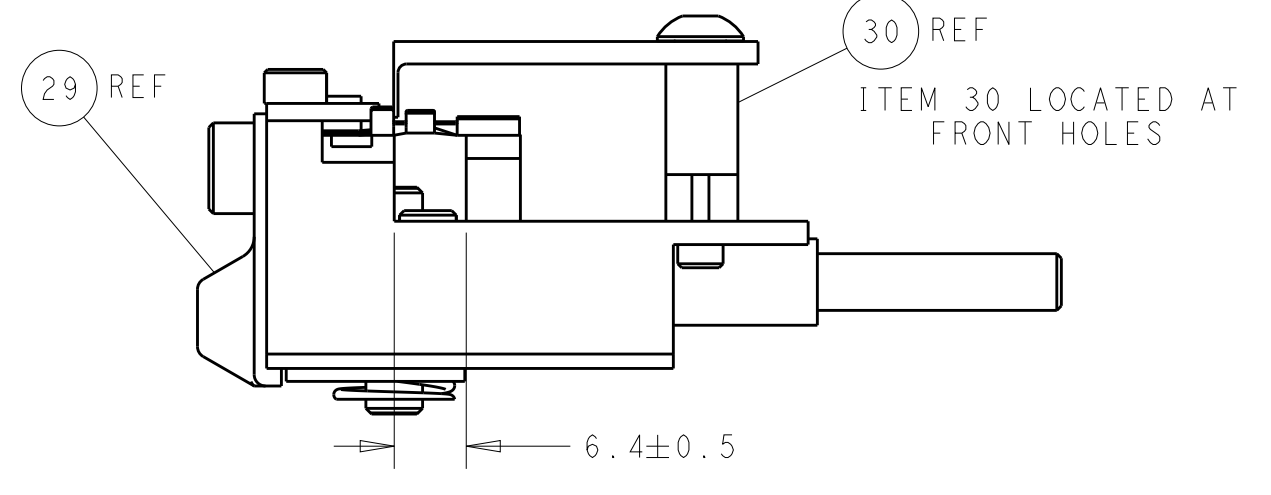
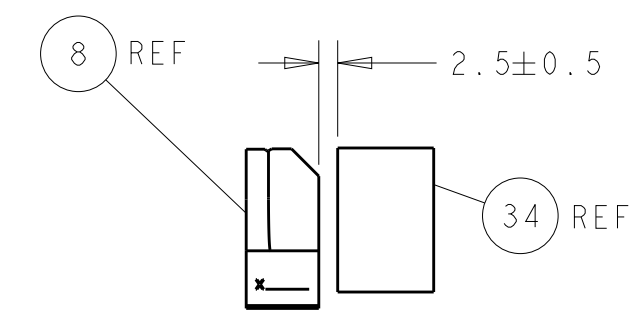
SEE TERMINAL HOLD DOWN AND SPACER SETUP CHART ON THIS SHEET AND NOTES



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

## TERMINAL HOLD DOWN & SPACER SETUP CHART

| GROUP   | HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: | POSITION   |
|---------|---|------------|
| GROUP 1 | 928999-1 2-928918-2                             | POSITION 1 |
|         | 928999-5 3-928918-2                             |            |
|         | 928999-6 5-928918-1                             |            |
|         | 5-928999-1 6-928918-1                           |            |
|         | 5-928999-5 6-928918-2                           |            |
|         | 5-928999-6 6-928918-3                           |            |
| GROUP 2 | 928918-1 1394702-1                              | POSITION 2 |
|         | 928918-2 5-1394702-1                            |            |
|         | 1-928918-1 1394702-2                            |            |
|         | 1-928918-2 5-1394702-2                          |            |
|         | 968220-1 5-968220-6                             |            |
|         | 968220-5 1703296-1                              |            |
| GROUP 2 | 968220-6 1703296-5                              | POSITION 2 |
|         | 5-968220-1 1534116-1                            |            |
|         | 5-968220-5 1534116-2                            |            |
| GROUP 2 | 1241918-1                                       | POSITION 2 |



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

|                    |  |   |  |   |  |   |  |
|--------------------|--|---|--|---|--|---|--|
| DIMENSIONS: mm<br> |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ± |  | DWN: HOFFNER 07DEC2001<br>CHK: T. ELBIN 08DEC2011<br>APVD: T. ELBIN 08DEC2011<br>PRODUCT SPEC:<br>APPLICATION SPEC:<br>WEIGHT:<br>CUSTOMER DRAWING: |  | NAME: Ocean Side Feed Applicator<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2151541<br>SCALE: 5:1<br>SHEET: 4 OF 4<br>REV: D4 |  |
|--------------------|--|---|--|---|--|---|--|