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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2151779-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151779-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151779-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151779-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2151779-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151779-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151779-4	-	-	
	2151779-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151779-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
7-2151779-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [1.00]	F
INSUL	5.08 mm [2.00]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: DELPHI TERMINAL	TE CRIMP SPECIFICATION		
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH 4.90-5.70 mm [1.93-.224 IN]	INSULATION DIAMETER RANGE Ø 4.25 mm MAX [1.67 IN MAX]		
TERMINAL APPLICATION SPECIFICATION	TE SPEC		
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL
1572923-1	15396902	1572759-1	15366067
		1572759-2	12191234

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm <sup>2</sup>	1.90+/-0.05 [1.075+/-0.002]	6.7
2.00mm <sup>2</sup>	1.73+/-0.05 [1.068+/-0.002]	8.8
1.50mm <sup>2</sup>	1.58+/-0.05 [1.062+/-0.002]	10.0

- 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: 8-2151779-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151779-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151779-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151779-6
- 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 50, 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, 50.
- 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 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.

- 13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION DIA RANGE QUOTED IS OUTSIDE DIAMETER OF SEAL. WIRE INSULATION DIA IS DEPENDENT ON SEAL BEING APPLIED. SEAL PN 1572759-1/2 INS. DIA RANGE IS 2.5-3.2
- 14 APPLY TORO-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)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	#	DATE	BY	APPV
			1	DEVELOPMENT	25SEP2012	YY SX
			A	RELEASED	11DEC2012	YY SX
			A1	ECR-16-005615	18APR2016	JH CT

#	DATE	DESCRIPTION	DATE	BY	APPV			
-	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	2119082-7	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	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
-	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, 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	2-1752354-0	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	1752356-3	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	1320908-7	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	2-1633133-5	ANVIL, COMBINATION .100	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	7-2119784-4	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1-455888-5	SPACER, CRIMPER	2
-	1	1	1	1	1	2-1752057-8	CRIMPER, WIRE PREMIUM, STEPPED	1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	DATE	NAME
mm	0 PLC ±	Y. YIN	25SEP2012	Y. YIN
	1 PLC ±	G. BAILEY	25SEP2012	G. BAILEY
	2 PLC ±			
	3 PLC ±			
	4 PLC ±			
	ANGLES			
	FINISH			
MATERIAL				

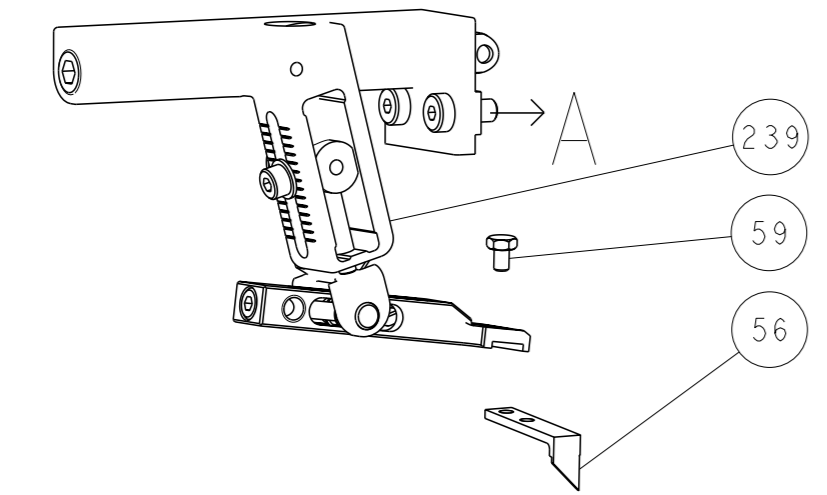
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Customer Accessible Production Drawing SCALE 1:2 SHEET 1 of 4 REV A1

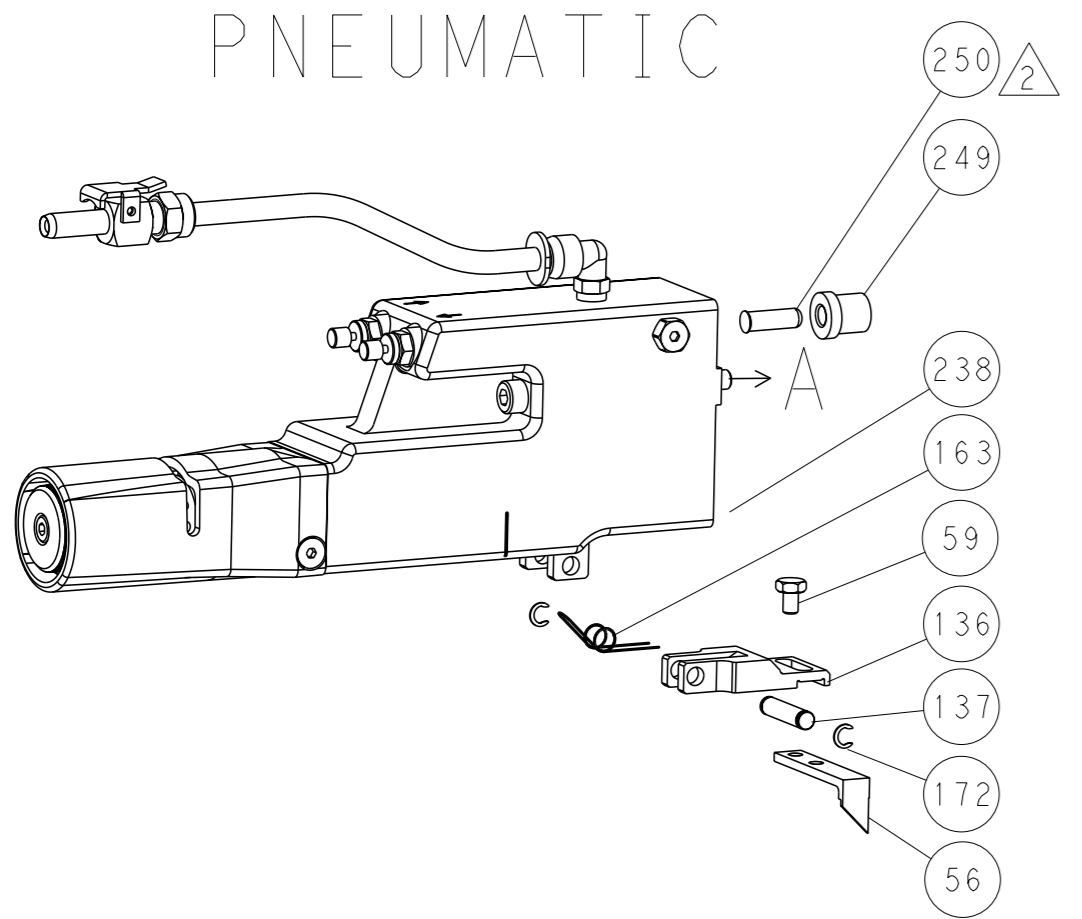


REVISONS		DATE	OWN	APVD
P	LYH			
- SEE SHEET 1				

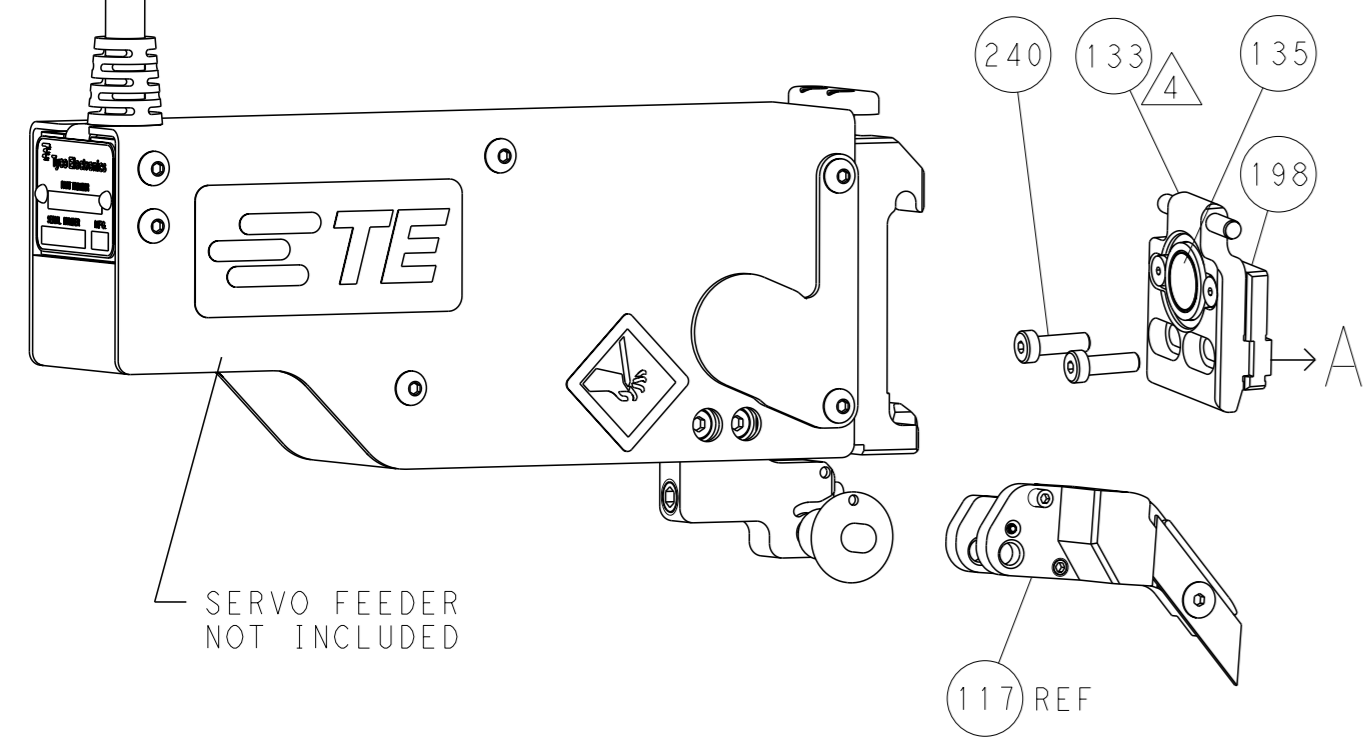
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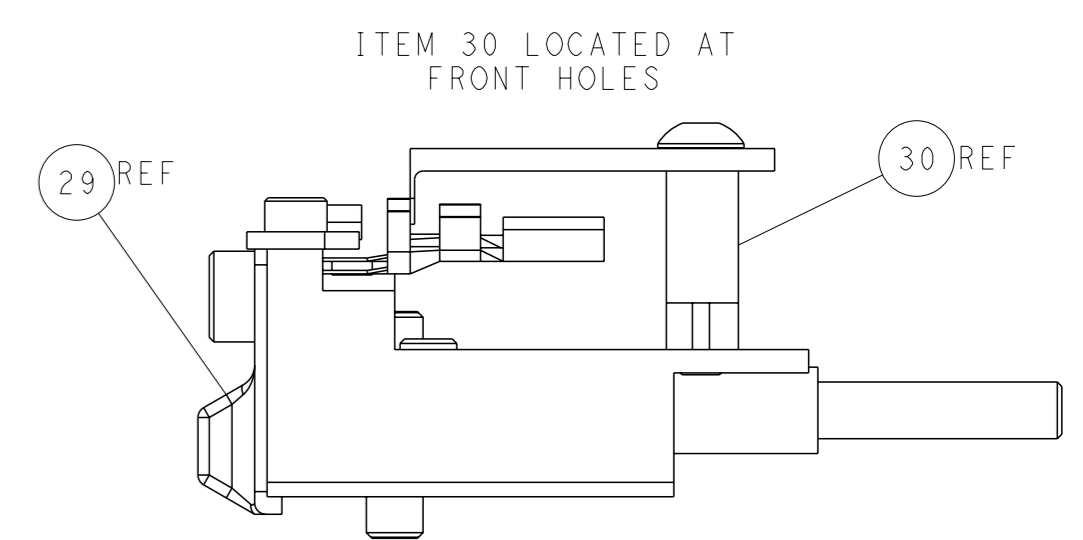
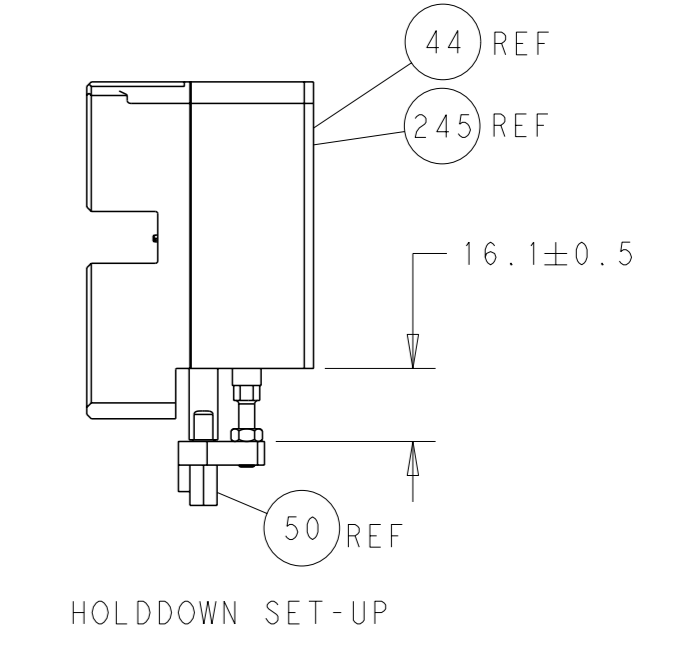
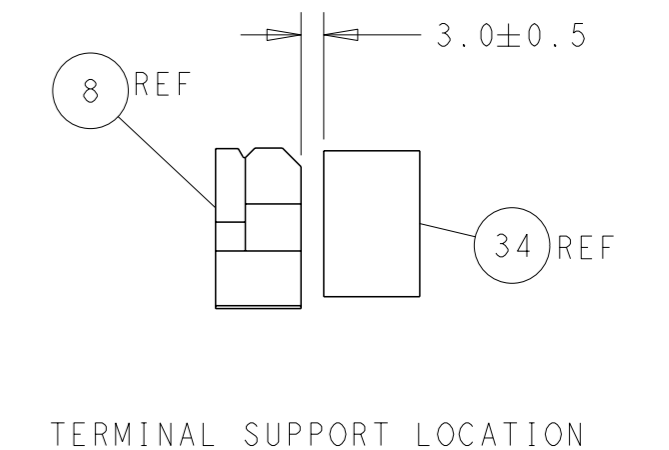
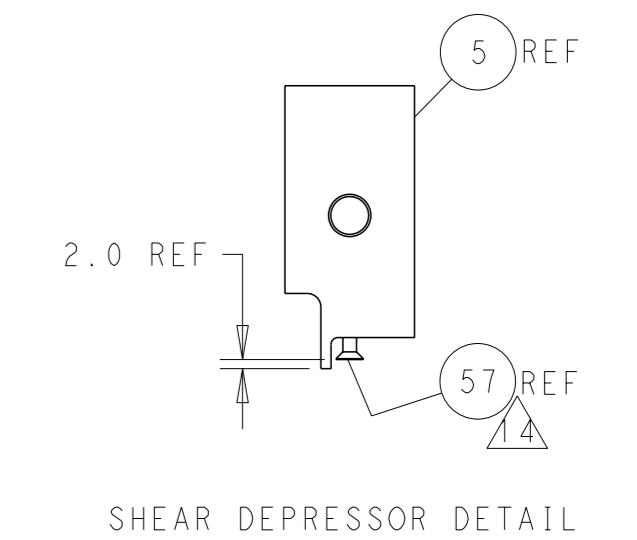
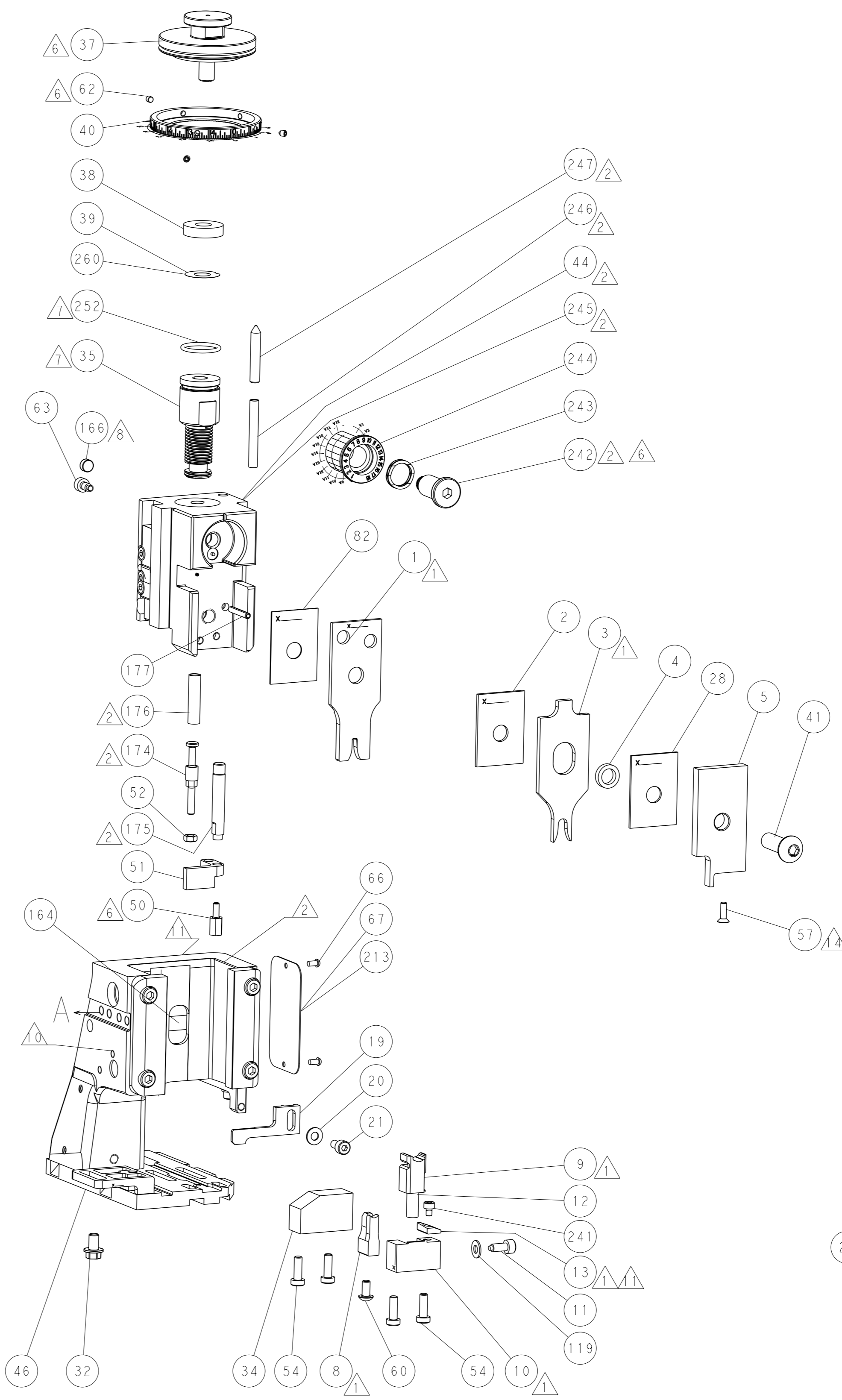
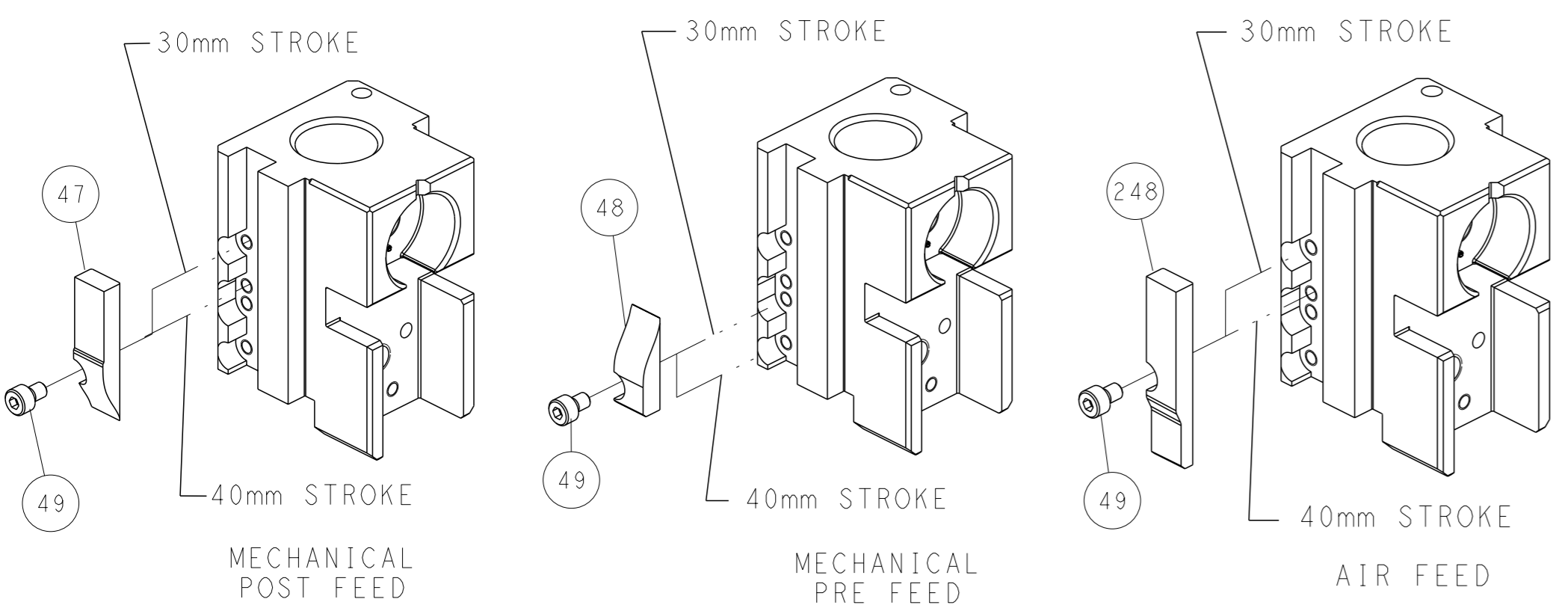
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ±		DWG Y.YIN 25SEP2012 CHK G.BAILEY 25SEP2012 APVD S.XI 25SEP2012 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean Side Feed Applicator SIZE A1 CAGE CODE 00779 DRAWING NO. ©=2151779 SCALE 1:2 SHEET 2 of 4 REV A1		TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 2 of 4		REV A1	

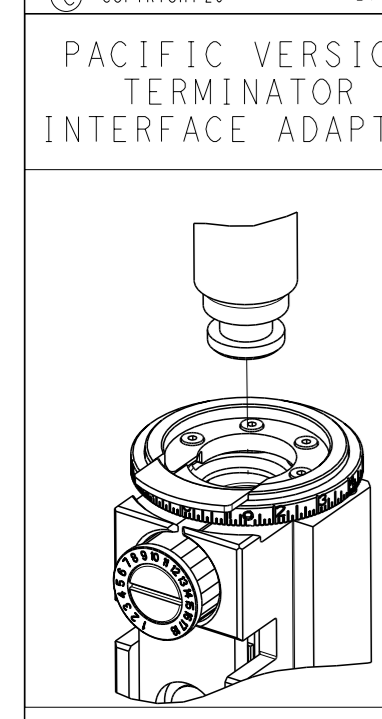


Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes rows for PNEUMATIC FEED, SERVO LATCH PLATE, MECHANICAL FEED, SMART APPLICATOR, and CRIMP TOOLING KIT.

APPLICATOR DATA table with columns: CRIMP SIZE, WIRE, INSUL, APPLICATOR INSTRUCTIONS. Values include 2.54 mm, 5.08 mm, and 408-10389.

Terminal Data and Application Specification table. Includes sections for TERMINAL DATA, WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED.

Wire Size and Crimp Height Reference Setting table. Columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- 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...

\*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists items like FINE ADJUST HEAD ASM, PUSH ROD, AIR FEED, BUSHING, SPRING, COMPRESSION.

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

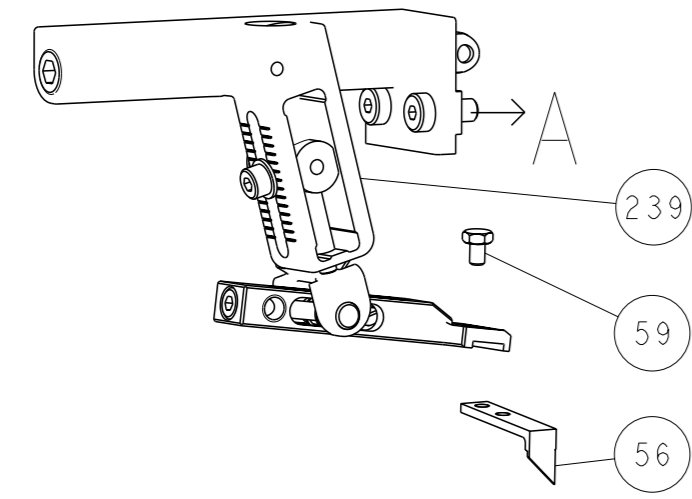
SET UP GAUGE, REVISIONS table. Includes columns for REVISIONS, DATE, and APPROVAL.

Large table listing various components and their quantities. Columns include QTY, PART NUMBER, DESCRIPTION, and ITEM NO. Lists items like CAM, SNAIL, WASHER, RETAINER, SCR, SHCS, MAGNET, SPRING, FEED FINGER, O-RING, FEED CAM, DETENT PIN, etc.

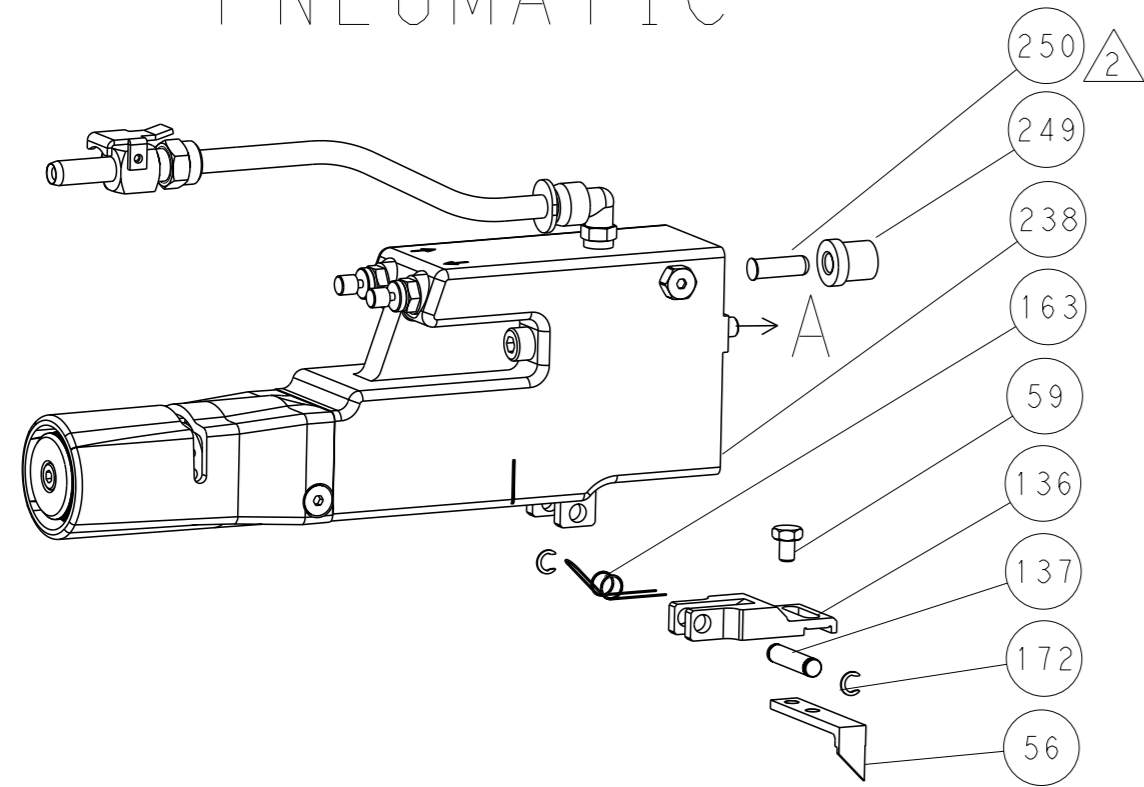
Technical drawing information block including dimensions, tolerances, material, weight, and customer accessible production drawing details.

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

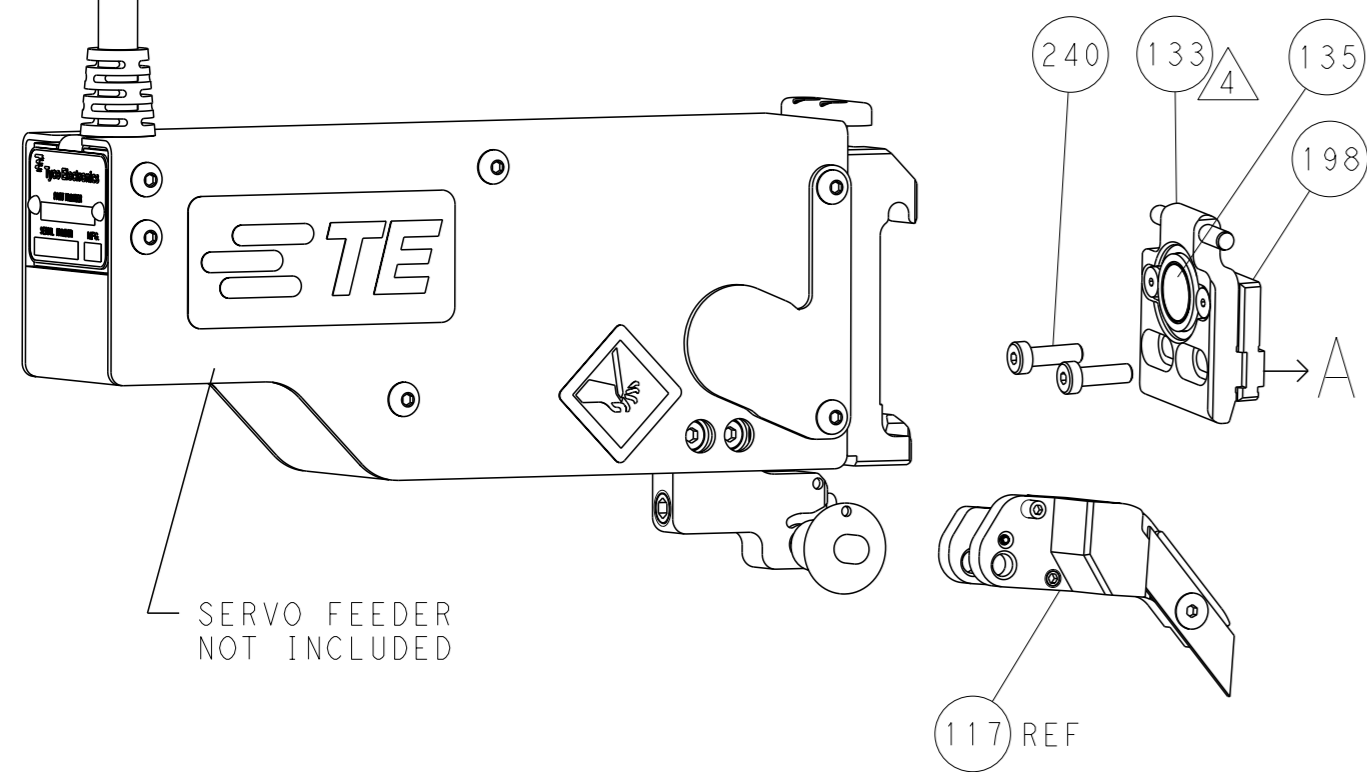
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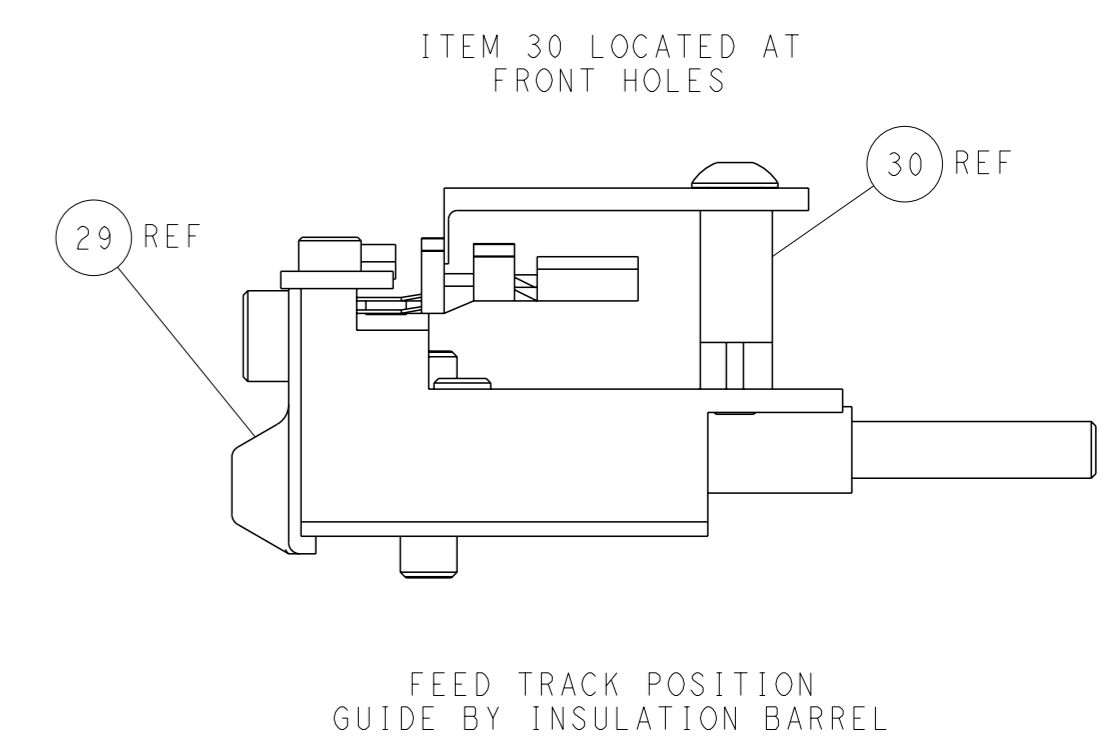
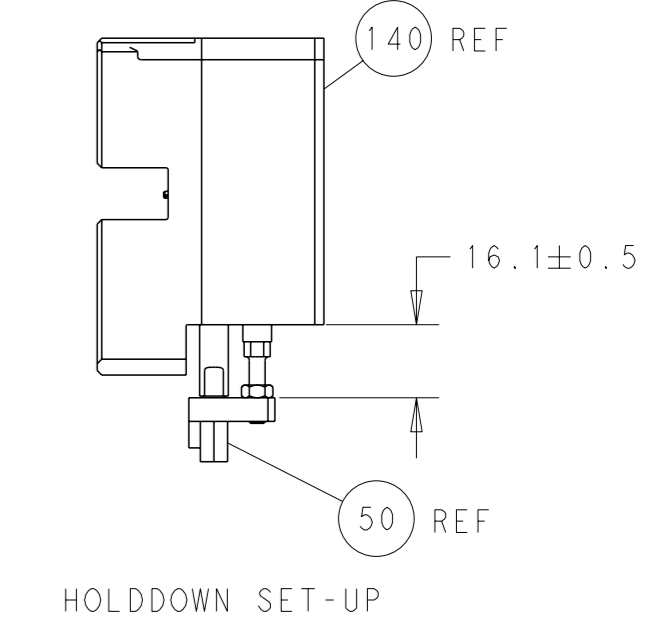
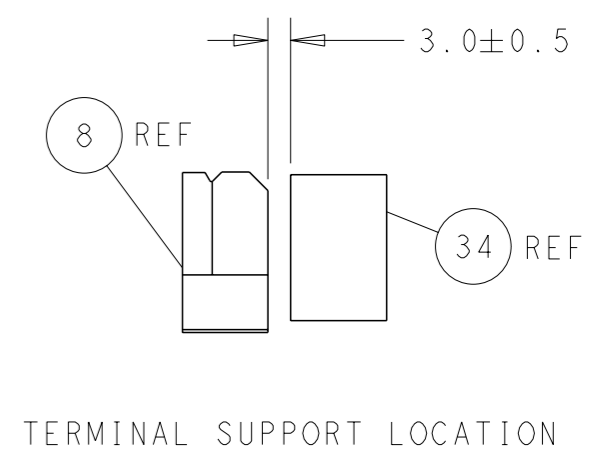
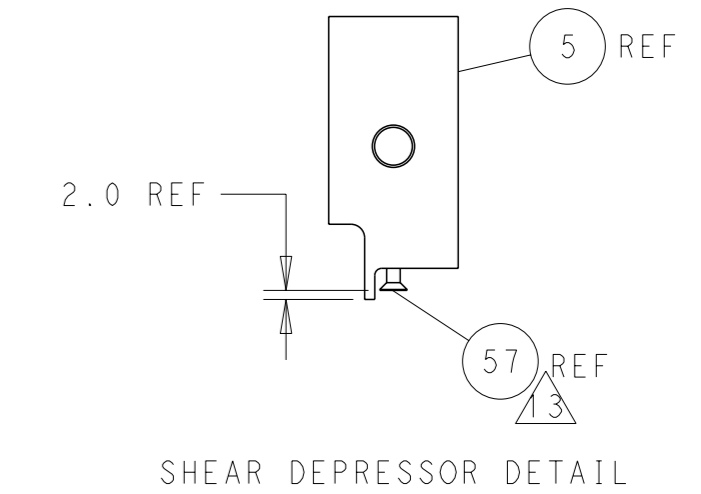
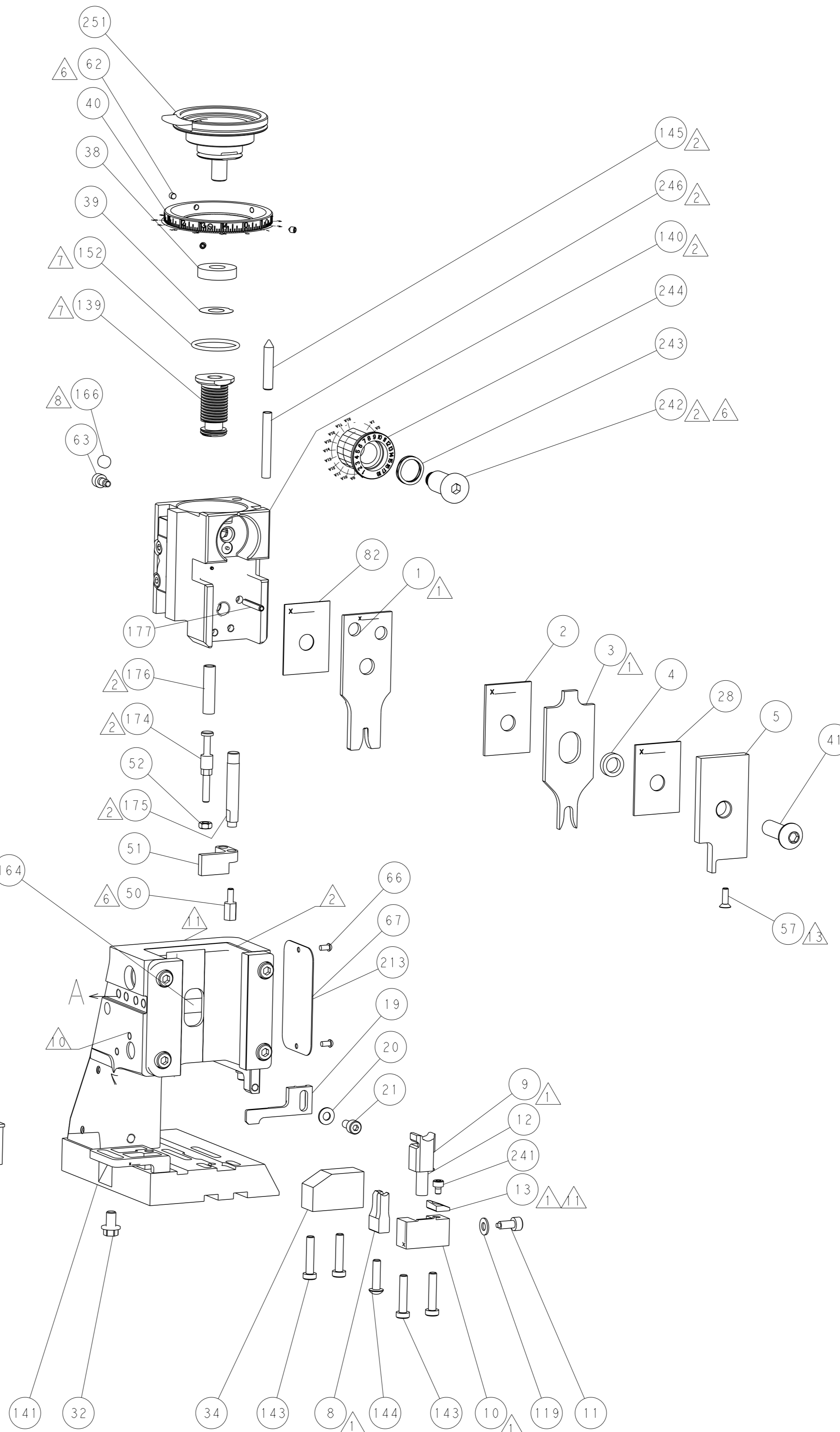
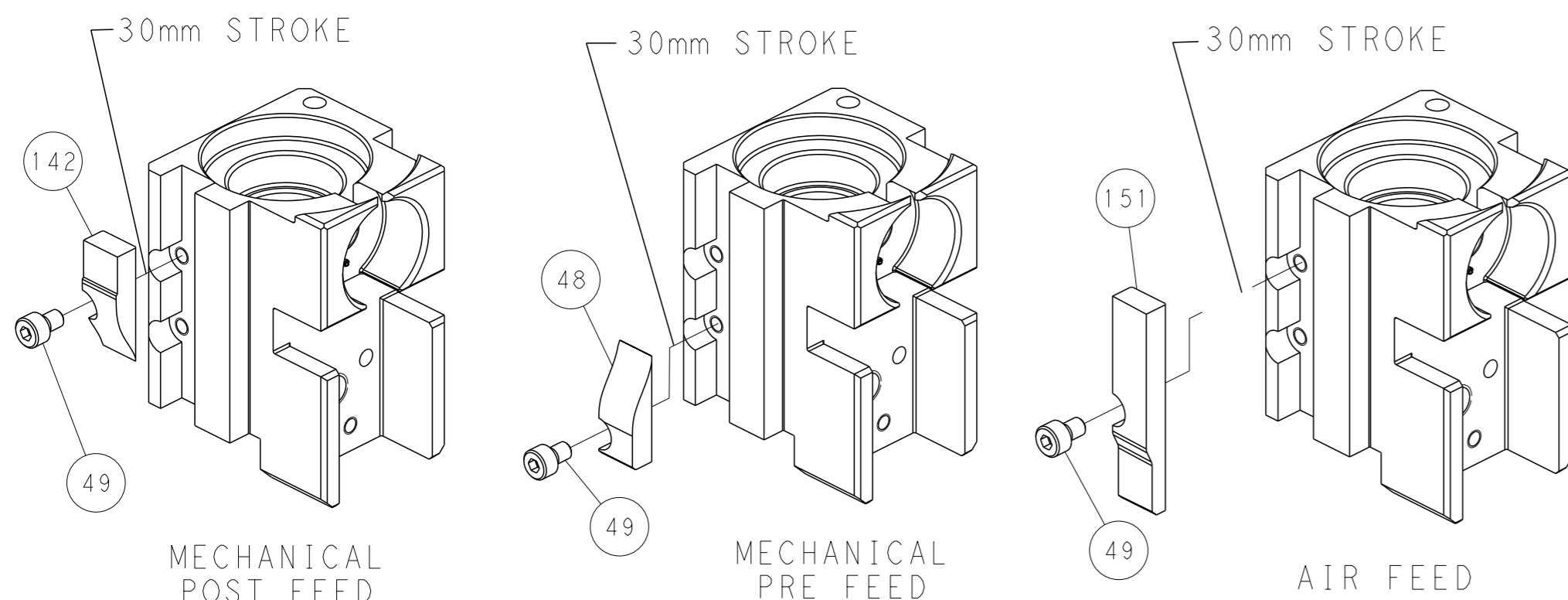
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN CHK: G. BAILEY APVD: S. XI PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:	25SEP2012 25SEP2012 25SEP2012 NAME: SIZE: A1 SCALE: 1:2 SHEET: 4 of 4 REV: A1	TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator ©=2151779
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