

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150060-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150060-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150060-4	-	-	-
	2150060-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150060-5	-	-	2168400-7 (QUANTITY 2)
	2150060-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
	2150060-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
2150060-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150060-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE	
WIRE STRIP LENGTH 4.51-5.28 mm [.178-.208 IN]	INSULATION DIAMETER RANGE Ø2.54-4.32 mm [.100-.170 IN]
TERMINAL APPLICATION SPECIFICATION 114-5084	
TERMINALS APPLIED	
TE TERMINAL 170213-1	TE TERMINAL 170213-2
TE TERMINAL 170213-3	TE TERMINAL 170213-5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.96 +/- 0.05 [.077 +/- .002]	4.1
1.25mm2	1.70 +/- 0.05 [.067 +/- .002]	7.0
0.75mm2	1.60 +/- 0.05 [.063 +/- .002]	8.1

- 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: 8-2150060-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150060-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150060-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150060-6
- 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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.
- 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 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.

-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
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244

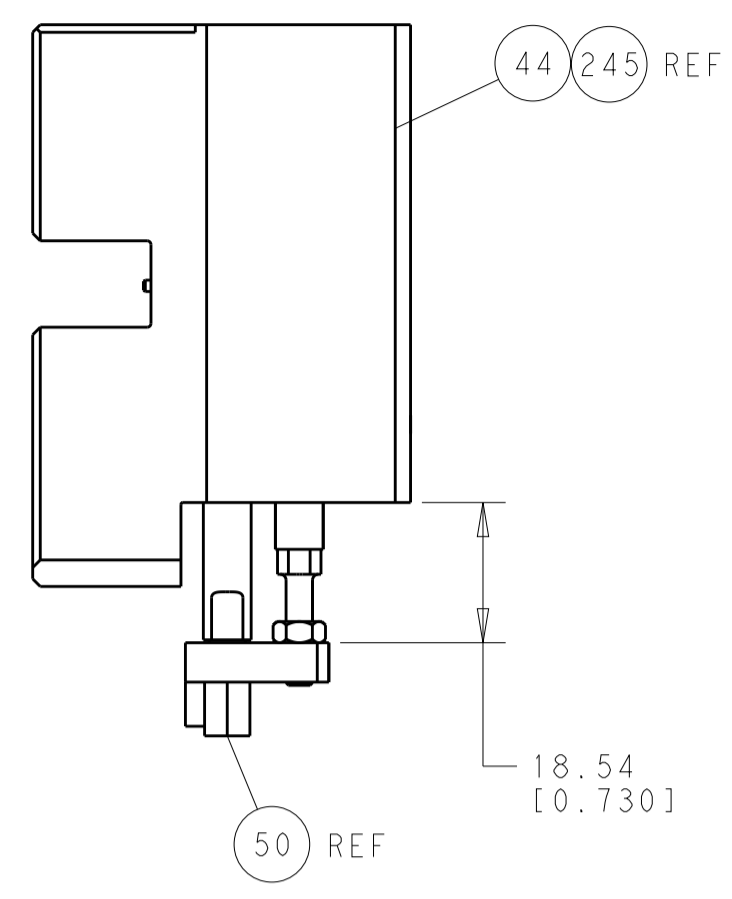
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			A	RELEASED	07JAN2014	LG GB

1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
2	2	2	2	2	2	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF	-	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
1	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
1	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
1	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
1	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	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	-	REFREF	REFREF	REFREF	REFREF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REFREF	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
1	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
1	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
2	2	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
1	-	-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
1	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
1	-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
3	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
1	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	2063961-1	FEED FINGER	58
4	4	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
2	2	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
2	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
2	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
1	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	-	1	-	2119792-2	PAWL, EF, AIR	51
1	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	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
1	-	1	1	1	1	2119369-1	RAM, AMP STYLE, END FEED	44
1	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
1	-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
1	-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
1	1	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
1	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
1	-	1	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
8	8	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
2	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
1	1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
2	2	2	2	2	2	1320906-1	STUD, THREADED	25
1	1	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
2	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
1	1	1	1	1	1	1752373-4	DRAG	20
2	2	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18
4	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
1	1	1	1	1	1	240641-9	SPACER	16
1	1	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	1	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
2	2	2	2	2	2	1-240645-1	SPACER, SHEAR PLATE	10
1	1	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	1	1	1	5-1729419-0	ANVIL	8
1	1	1	1	1	1	8-240651-7	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
1	1	1	1	1	1	4-240641-6	SPACER	5
1	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	4-1633962-1	CRIMPER, INSULATION F PREMIUM	3
1	1	1	1	1	1	455888-8	SPACER, CRIMPER	2
1	1	1	1	1	1	2-456408-0	CRIMPER, WIRE PREMIUM	1

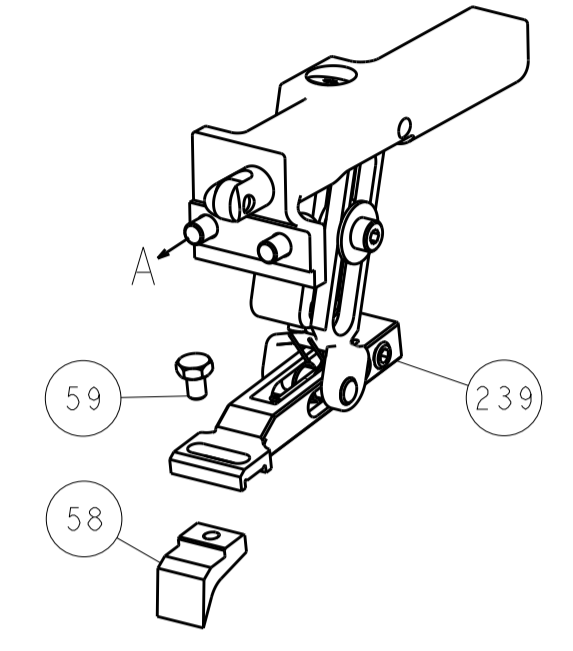
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5	09FEB2012	09FEB2012	Customer Accessible Production Drawing	SCALE 1:1 SHEET 1 OF 4 REV A
MATERIAL:				FINISH:		WEIGHT:		Customer Accessible Production Drawing	

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

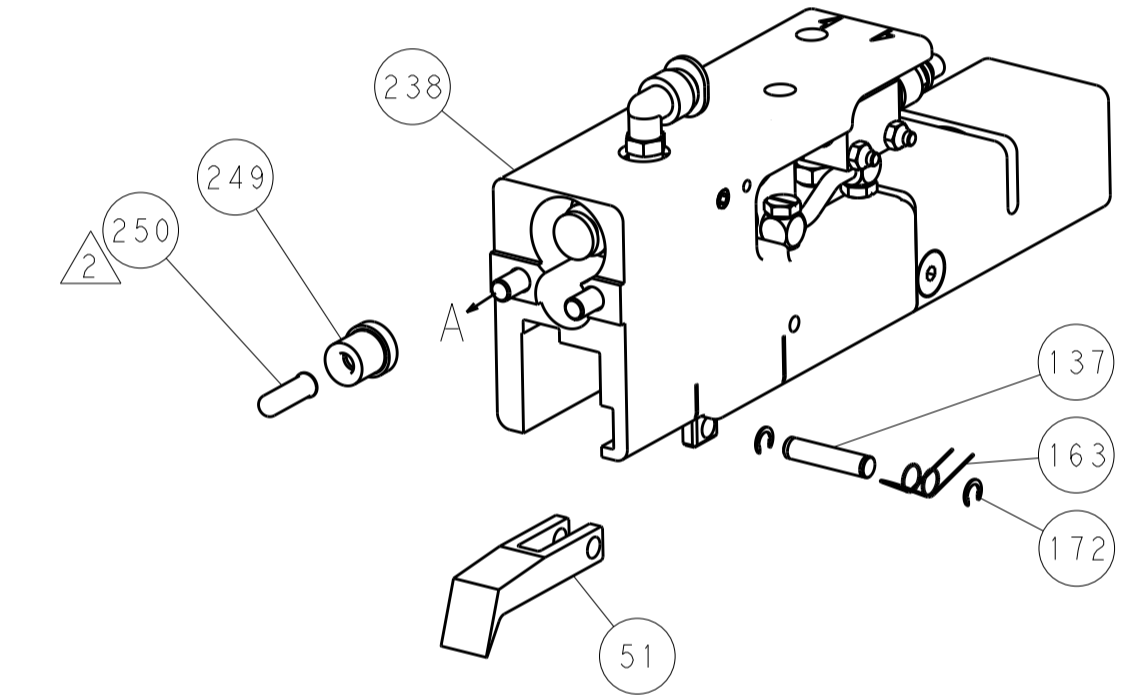


HOLDDOWN SET-UP

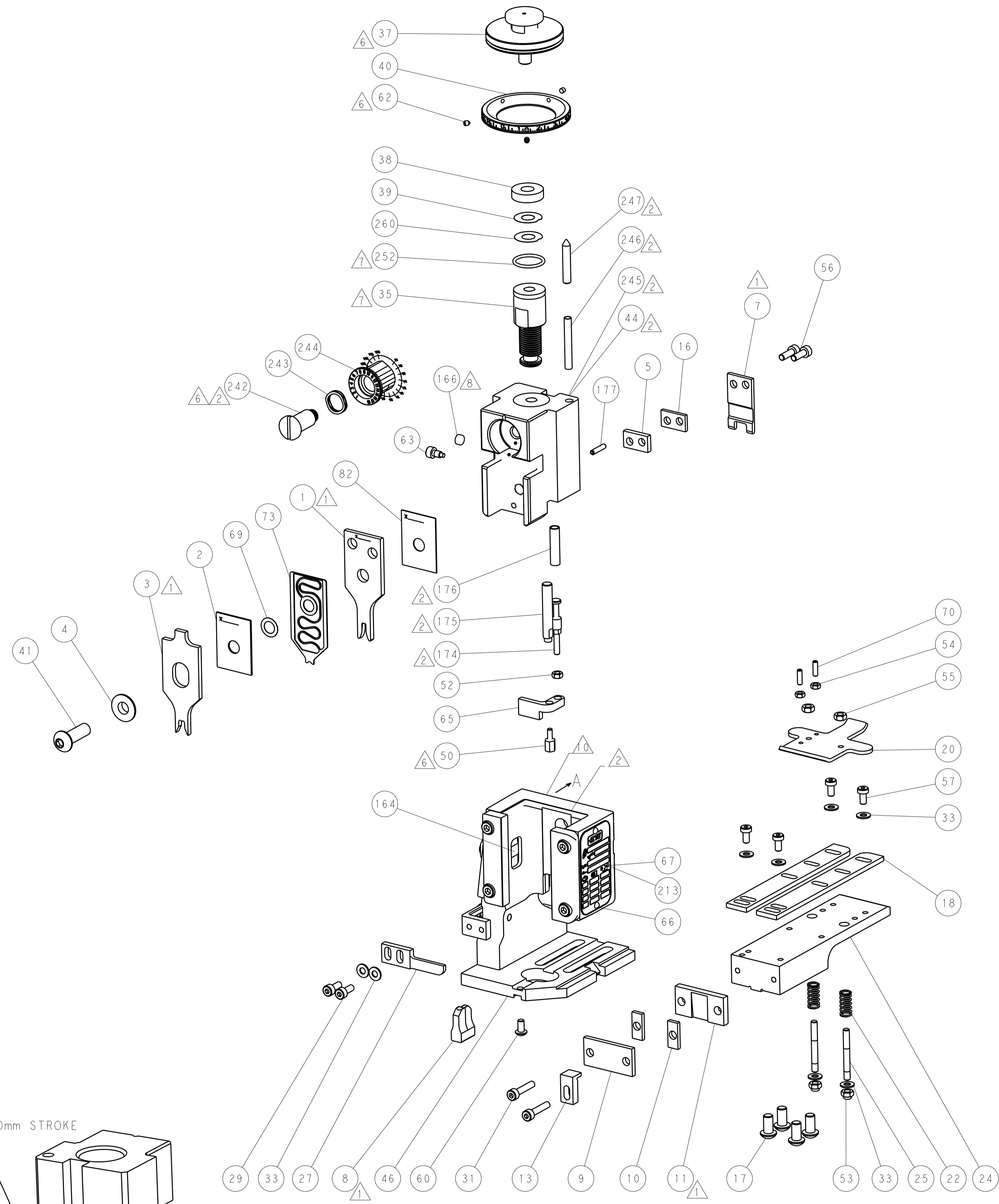
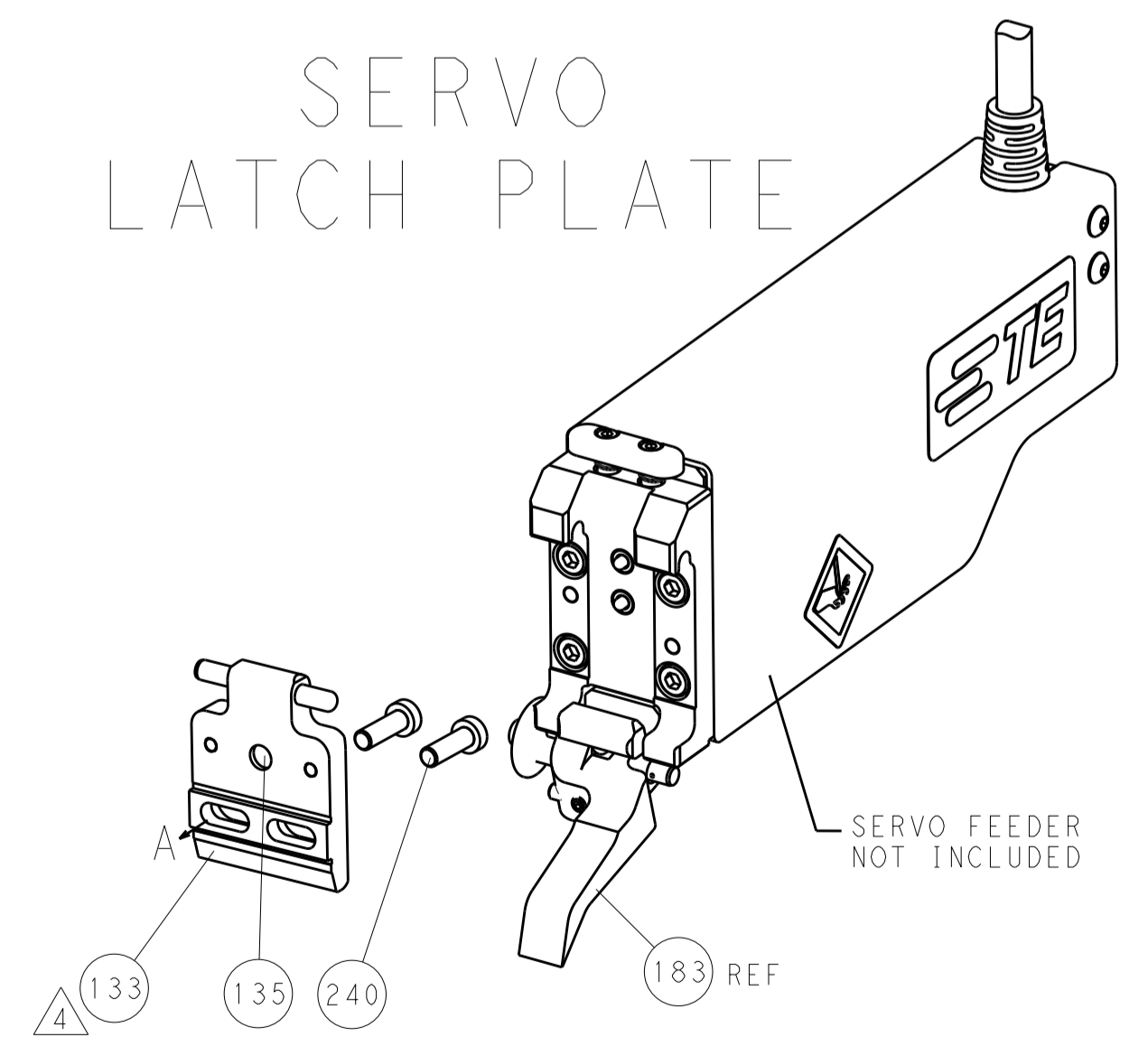
FEED TYPE
MECHANICAL



PNEUMATIC



SERVO
LATCH PLATE



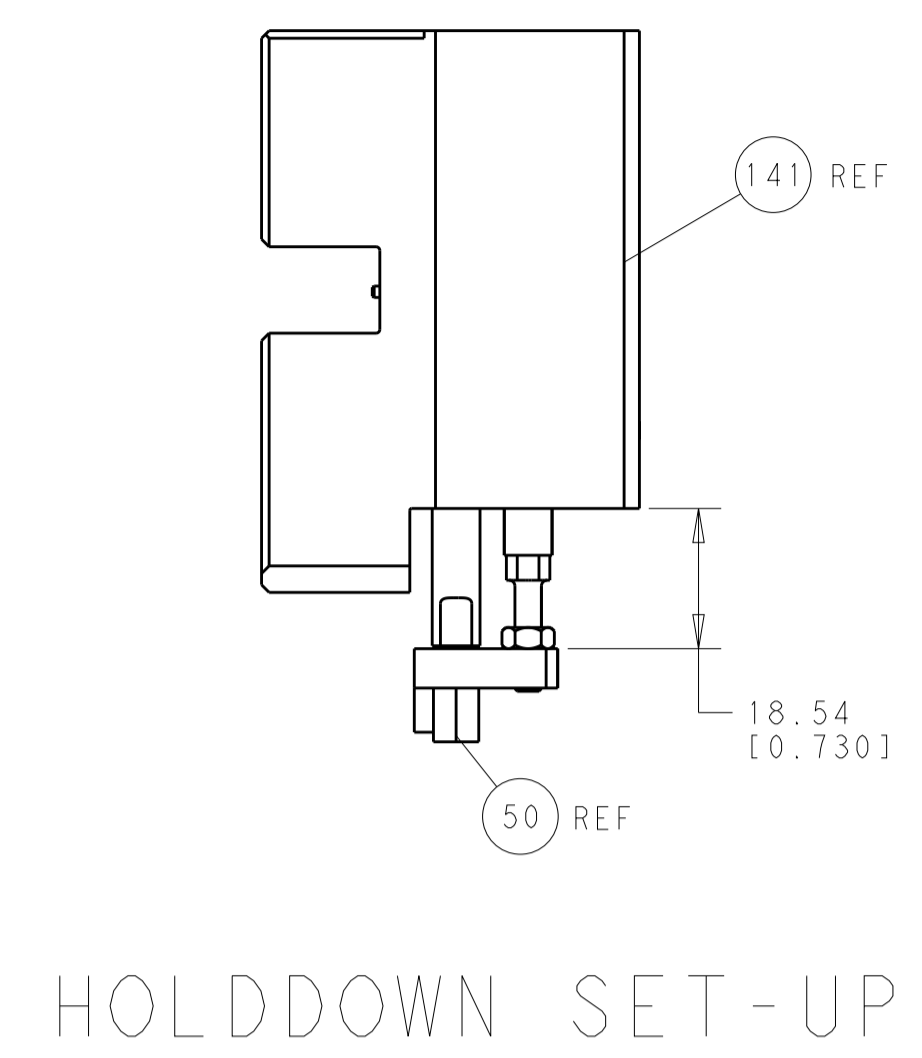
CAM POSITIONS



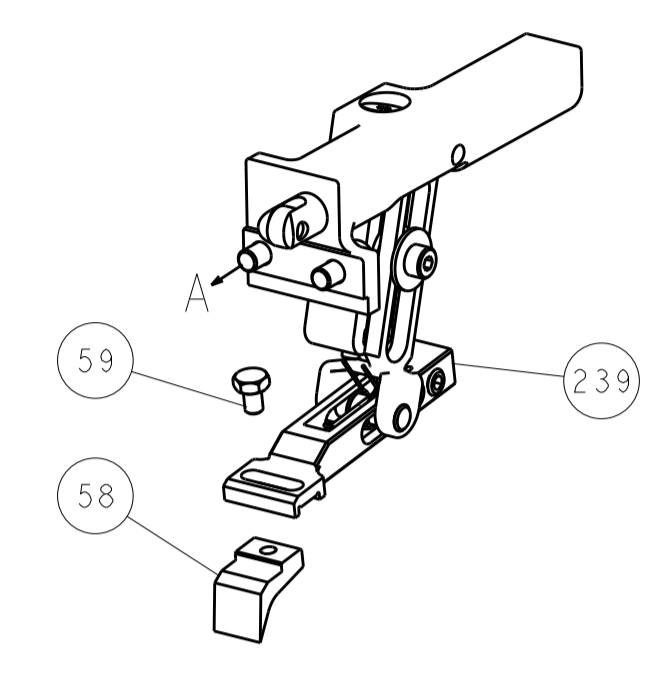
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 09FEB2012		TE Connectivity	
mm		0 PLC ±0.5		CHK: G. BAILEY 09FEB2012		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APPVD: S. XI 09FEB2012		NAME: Ocean End Feed Applicator	
FINISH:		2 PLC ±0.013		PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
MATERIAL:		3 PLC ±0.001		APPLICATION SPEC:		RESTRICTED TO:	
		4 PLC ±0.001		WEIGHT:		A11 00779 ©=2150060	
		ANGLES ±0.001		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV A	

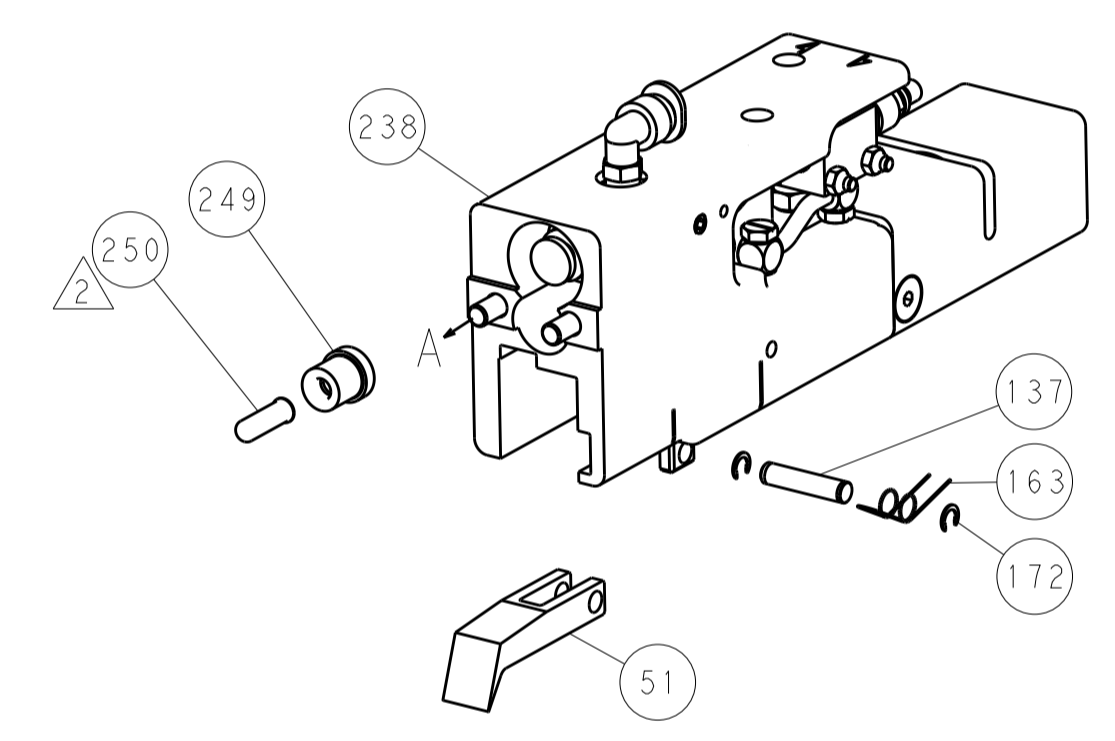
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			



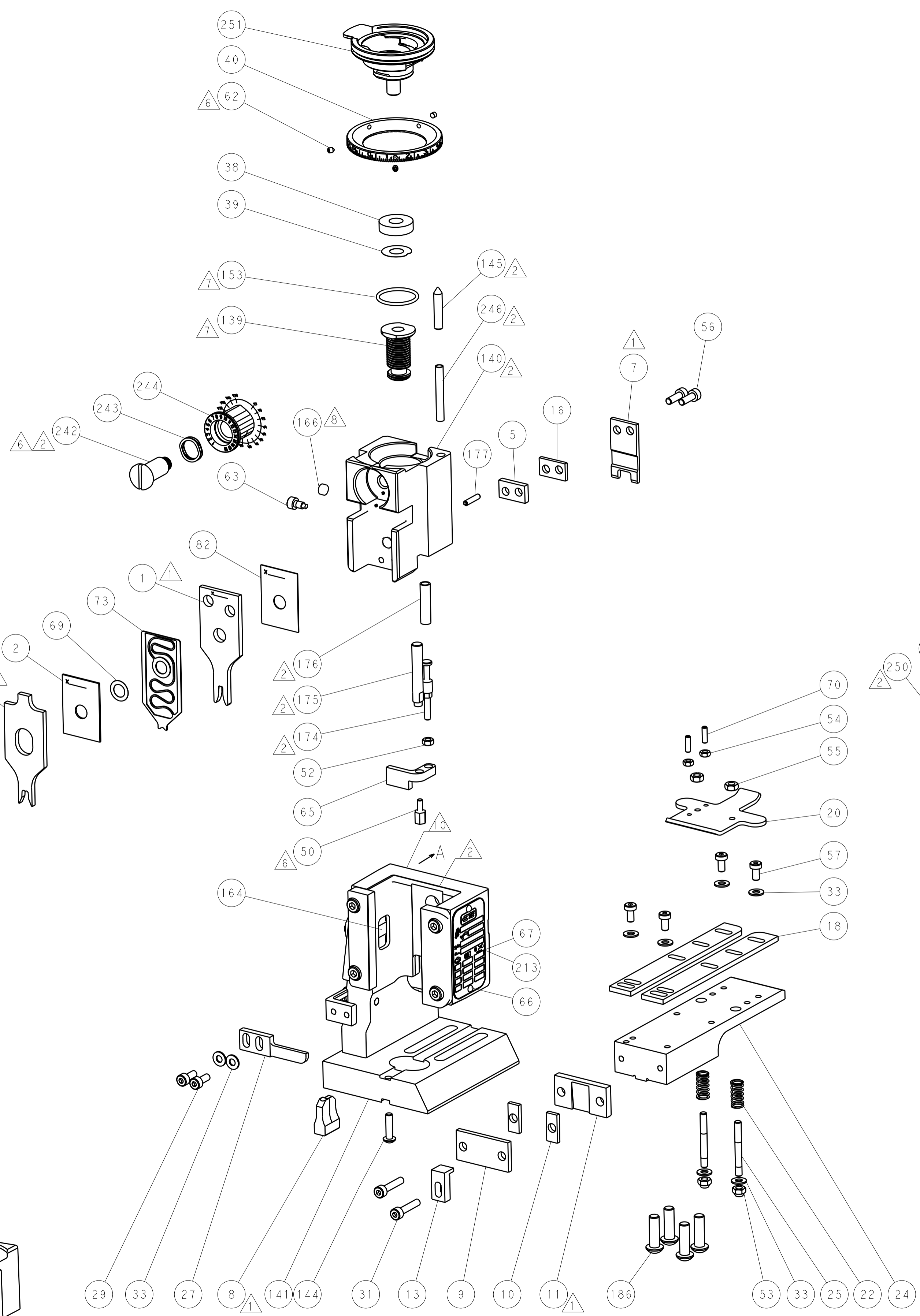
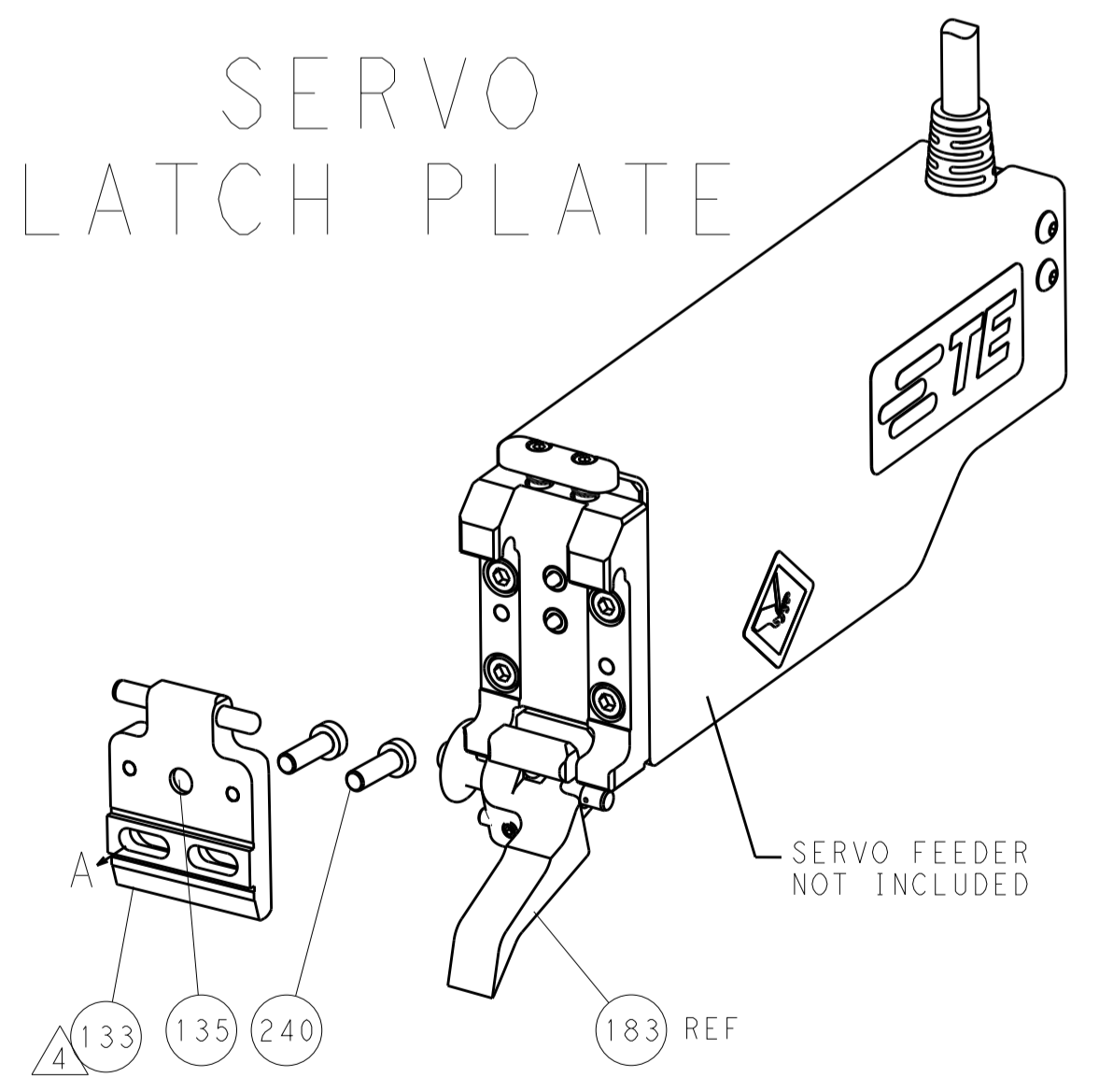
FEED TYPE
MECHANICAL



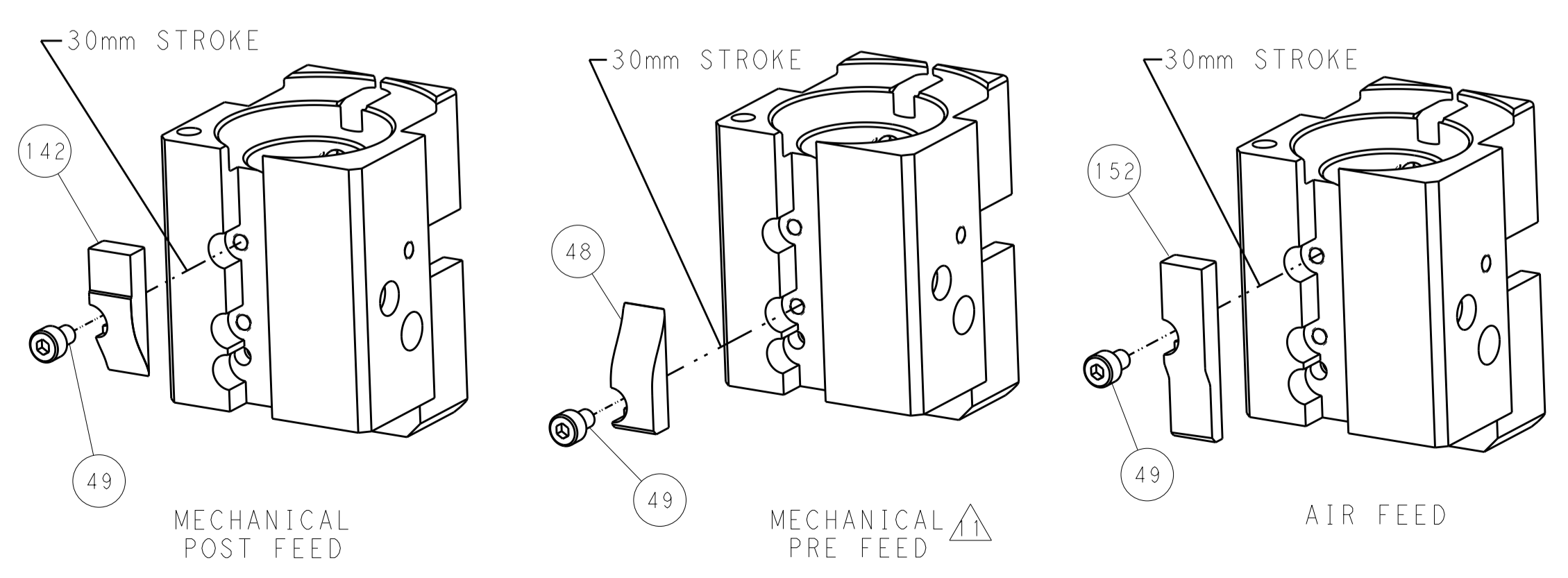
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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 Y. YIN 09FEB2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	APVD S. XI 09FEB2012	NAME
	ANGLES ±0.0013			PRODUCT SPEC		Ocean End Feed Applier	
MATERIAL	FINISH			APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A1 00779 C=2150060	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 4 OF 4 REV A	