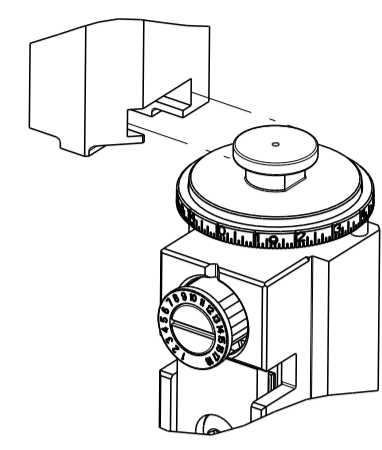




ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2150384-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1-2119792-2	-	2119641-1	-	2063440-1
	2150384-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150384-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150384-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-6	5-18022-5	2119653-1	-	-
	2150384-5	E	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150384-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150384-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-6	5-18022-5	2119653-1	-	-
	2150384-6	E	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	PNEUMATIC FEED	2119950-1	1-2119792-2	-	2119641-1	-	2063440-1
					-	-	-	-	-	-	-
	2150384-7	E	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150384-7	E	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS 408-10390 

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, 110 SERIES FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.155-.170 IN [3.94-4.32 mm]		Ø.120-.140 IN [3.05-3.56 mm]	
TERMINAL APPLICATION SPECIFICATION	114-2036		
TERMINALS APPLIED ¹³			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62050-1	61400-1	63703-1	
62050-2	61400-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.52 +/- 0.050 [.060 +/- .002]	5.7
18 AWG	1.30 +/- 0.050 [.051 +/- .002]	8.1
20 AWG	1.17 +/- 0.050 [.046 +/- .002]	9.3

- 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: 8-2150384-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150384-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150384-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150384-6
- 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 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
- ¹³ TERMINAL LUBRICANT IS RECOMMENDED.

***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.

¹²	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
⁷	-	1	-	1	1		8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
	-	-	-	1	1		2119640-1	PUSH ROD, AIR FEED	250
	-	-	-	1	-		1803259-1	BUSHING, FLANGED	249
	-	-	-	1	-		2119641-1	FEED CAM, AIR FEED	248
	-	1	-	1	1		2119798-1	DETENT PIN	247
	-	1	-	1	1		1-22279-3	SPRING, COMPRESSION	246
	-	-	1	-	-		2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
	-	1	1	1	1		2119082-9	CAM, SWAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1		2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
⁶	-	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					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			C		ECR-15-010699	17JUL2015	MR	TE
			D		ECR-17-001905	09FEB2017	TB	TE
			E		ECR-17-005788	21APR2017	TB	TE

-	-	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		6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	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
⁸	-	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
¹³	-	1	1	1	1		2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1		1-455888-0	SPACER, CRIMPER	82
	-	1	1	1	1		2119791-5	DEPRESSOR, WIRE	73
	-	1	1	1	1		2119956-2	DOCUMENTATION PACKAGE	71
	-	2	2	2	2		2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
	-	1	1	1	1		2119943-1	WASHER, SPACER	69
	-	1	-	-	1		2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2		2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1		1-1901681-8	HOLDDOWN, TERMINAL	65
⁶	-	1	-	1	1		2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	-	3	3		992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
	-	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		2063961-6	FEED FINGER	58
	-	4	4	4	4		2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2		2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
	-	2	2	2	2		5018030-2	NUT, HEX, REG, RoHS, M4	55
	-	2	2	2	2		5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	2	2		986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1	1		1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	-	-	-	1		1-2119792-2	PAWL, EF, AIR	51
⁶	-	1	1	1	1		1752354-6	STANDOFF, HOLD-DOWN	50
	-	-	-	-	1		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		2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
	-	1	-	1	1		2119369-1	RAM, AMP STYLE, END FEED	44
	-	1	1	1	1		2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	-	1	1		2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	-	1	1		2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	1		1-2119644-2	RAM WASHER, PRECISION	38
⁶	-	1	1	1	1		2119085-1	FA HEAD, ATLANTIC STYLE	37
⁷	-	1	-	1	1		2119092-1	BOLT, ADJUSTMENT	35
	-	8	8	8	8		1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2		2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	-	2	2	2	2		1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	1	1	1		240639-1	STRIPPER (MACHINING)	27
	-	2	2	2	2		1320906-1	STUD, THREADED	25
	-	1	1	1	1		1752371-5	PLATE, STRIP GUIDE	24
	-	2	2	2	2		2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1		1752373-4	DRAG	20
	-	2	2	2	2		1901259-5	GUIDE, LOWER STRIP	18
	-	4	4	4	4		1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1		1752360-1	SPACER, HOLD-DOWN	13
¹	-	1	1	1	1		240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-		-	-	10
¹	-	1	1	1	1		690482-5	PLATE, FRONT SHEAR	9
¹	1	1	1	1	1		3-1803001-4	ANVIL, COMBINATION, END FEED	8
¹	-	1	1	1	1		2217206-7	BLADE, SLUG	7
	-	-	-	-	-		-	-	6
	-	1	1	1	1		240641-6	SPACER	5
	-	1	1	1	1		238009-1	BLOCK, FL CRIMPER SPACER	4
¹	1	1	1	1	1		3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1		455888-4	SPACER, CRIMPER	2
¹	1	1	1	1	1		1803482-4	CRIMPER, WIRE	1
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

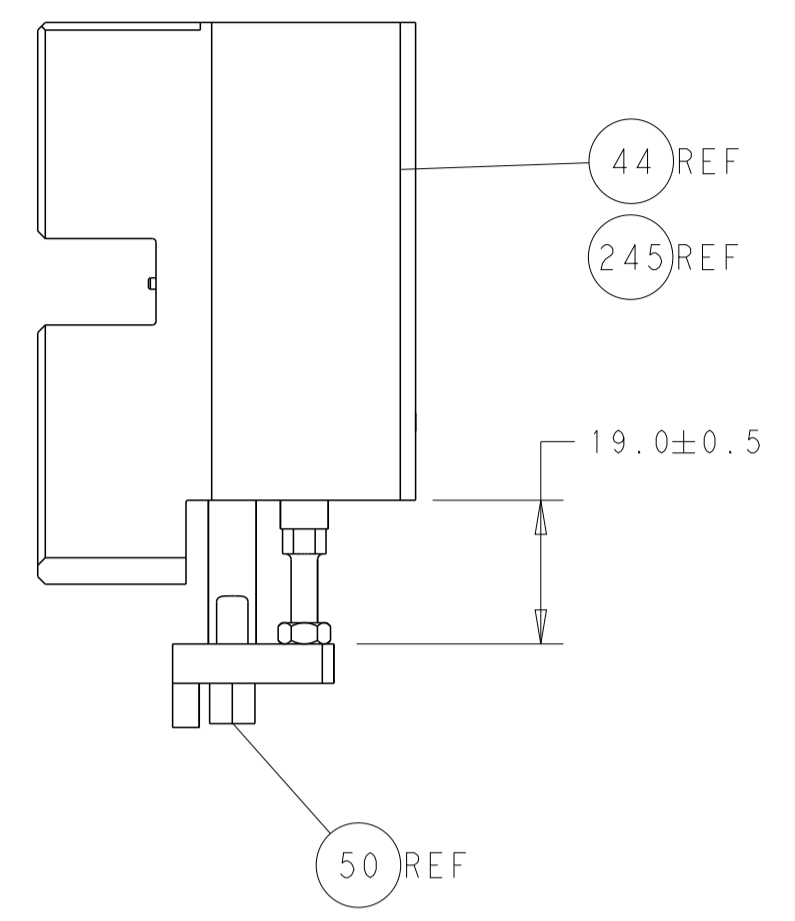
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		NAME	
mm	0 PLC	±		19OCT2013	OWN	19OCT2013	PL. STAKEM
	1 PLC	±		19OCT2013	CHK	19OCT2013	G. BAILEY
	2 PLC	±		19OCT2013	APPD	19OCT2013	T. ELBIN
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
	FINISH	±					

STE TE Connectivity
 Harrisburg, PA 17105-3608

Ocean End Feed
 Applicator

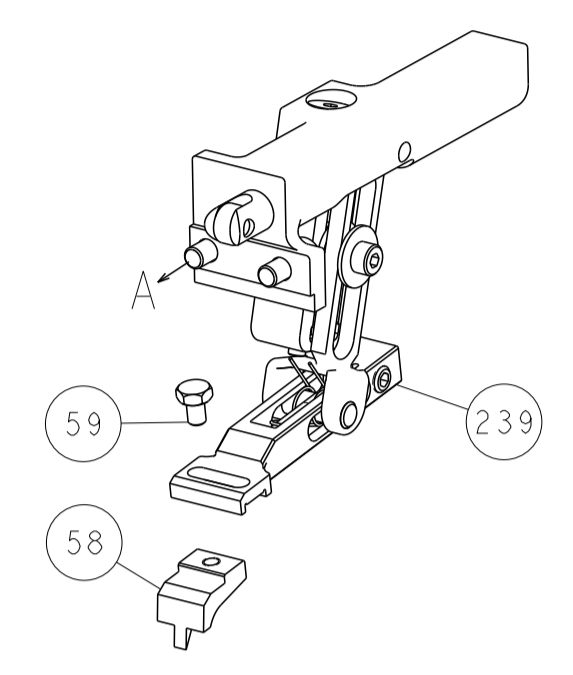
SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150384 RESTRICTED TO: -
 WEIGHT: -
 Customer Accessible Production Drawing SCALE: 1:1 SHEET 1 OF 4 REV E

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

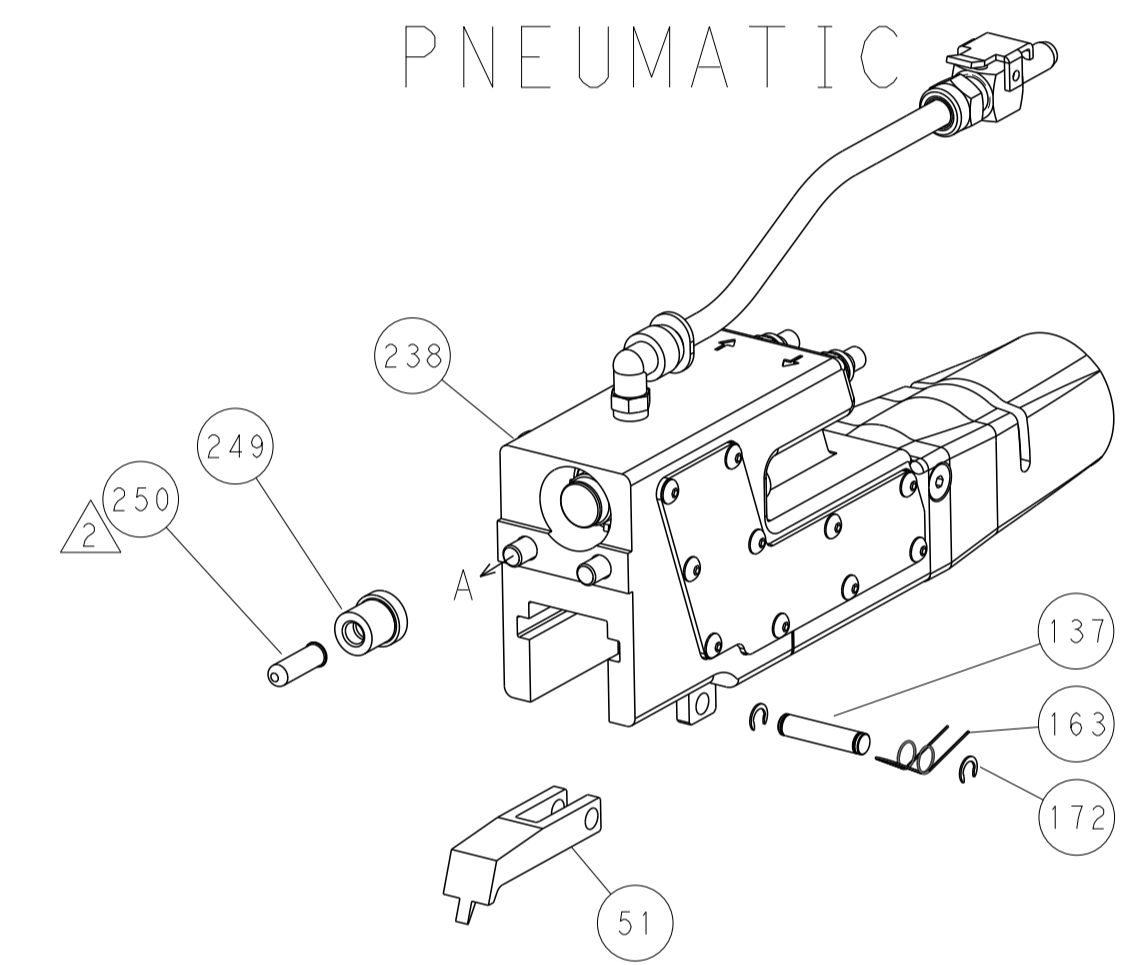


HOLD DOWN SET UP

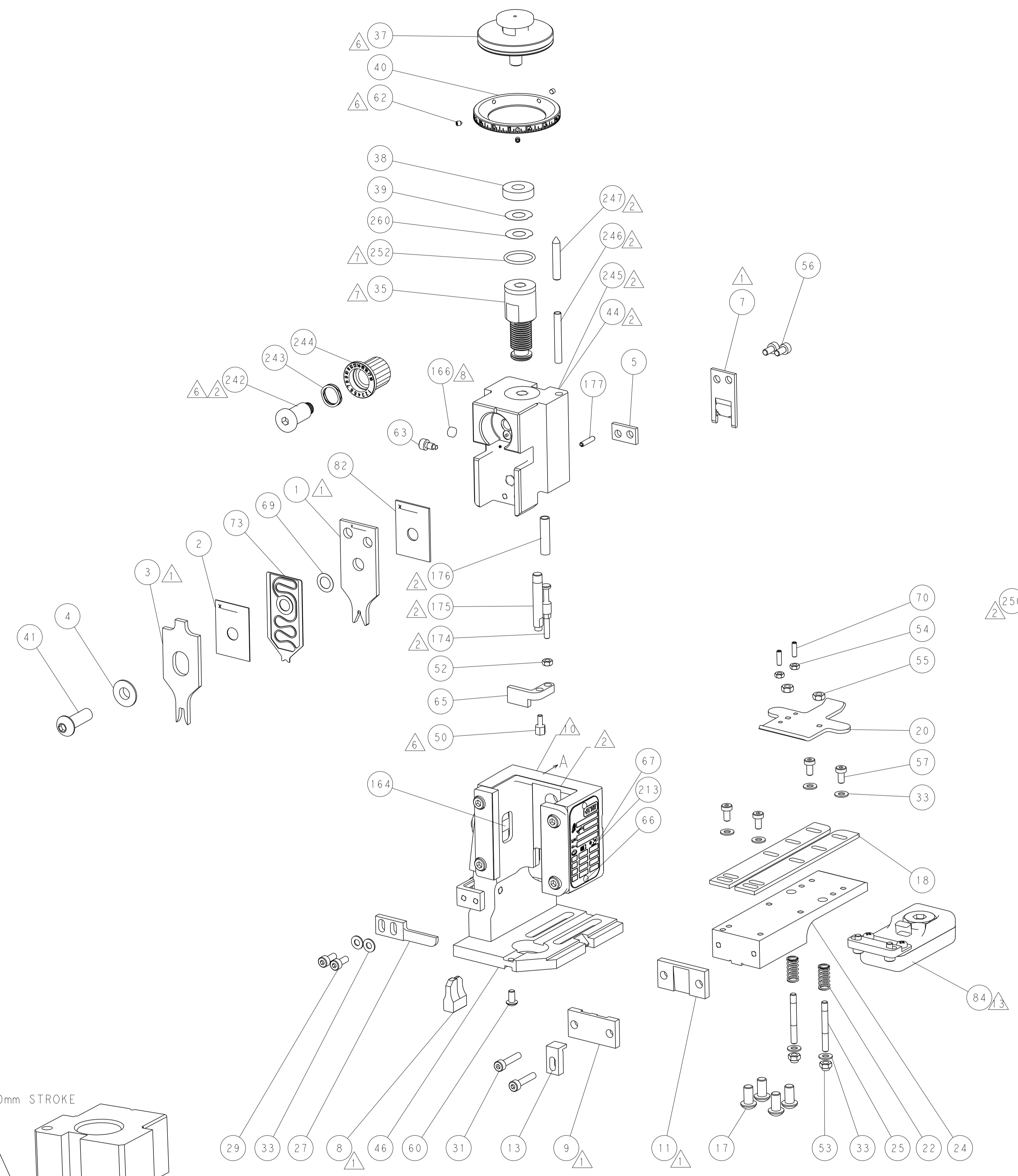
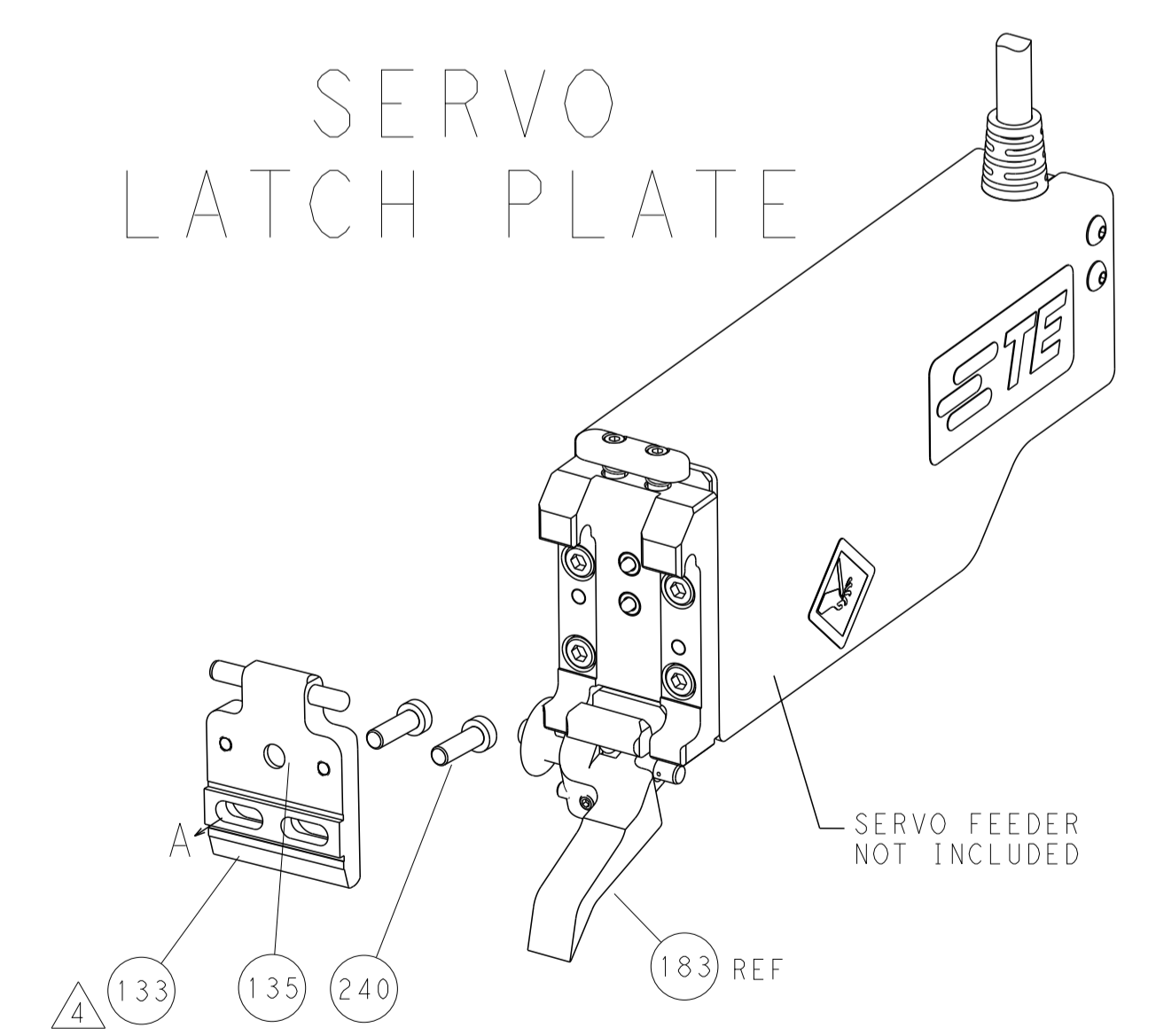
FEED TYPE MECHANICAL



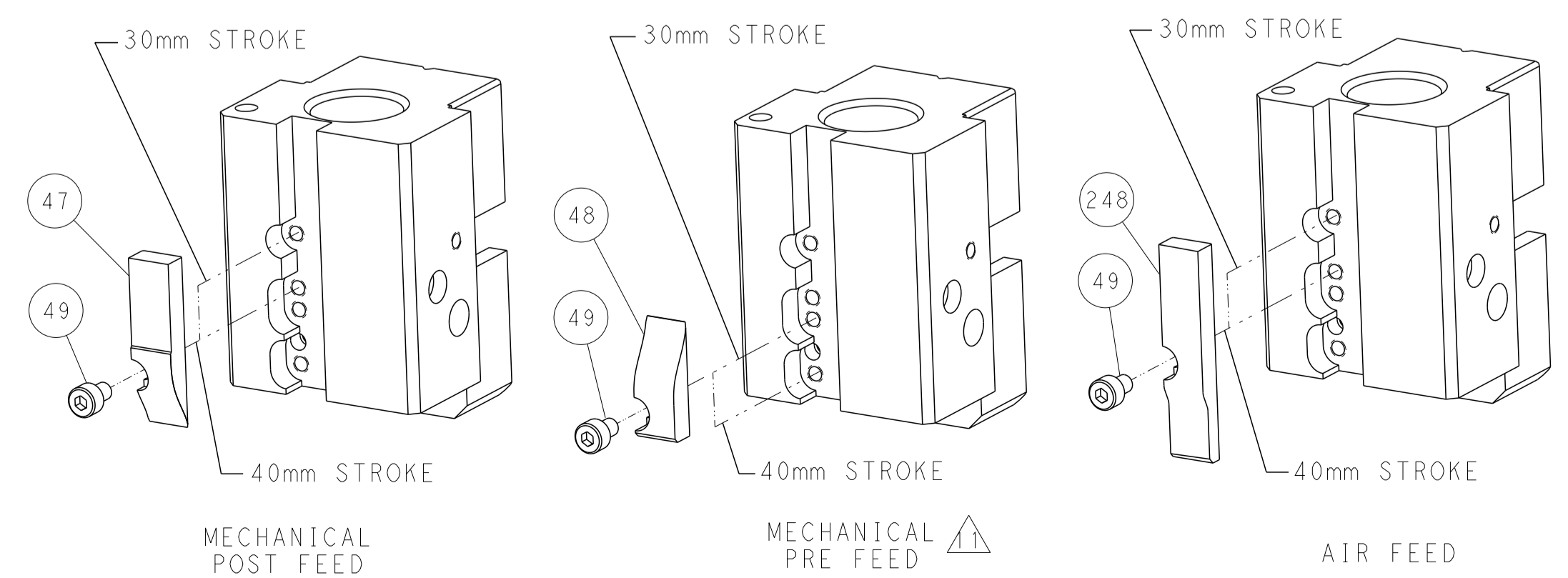
PNEUMATIC



SERVO LATCH PLATE



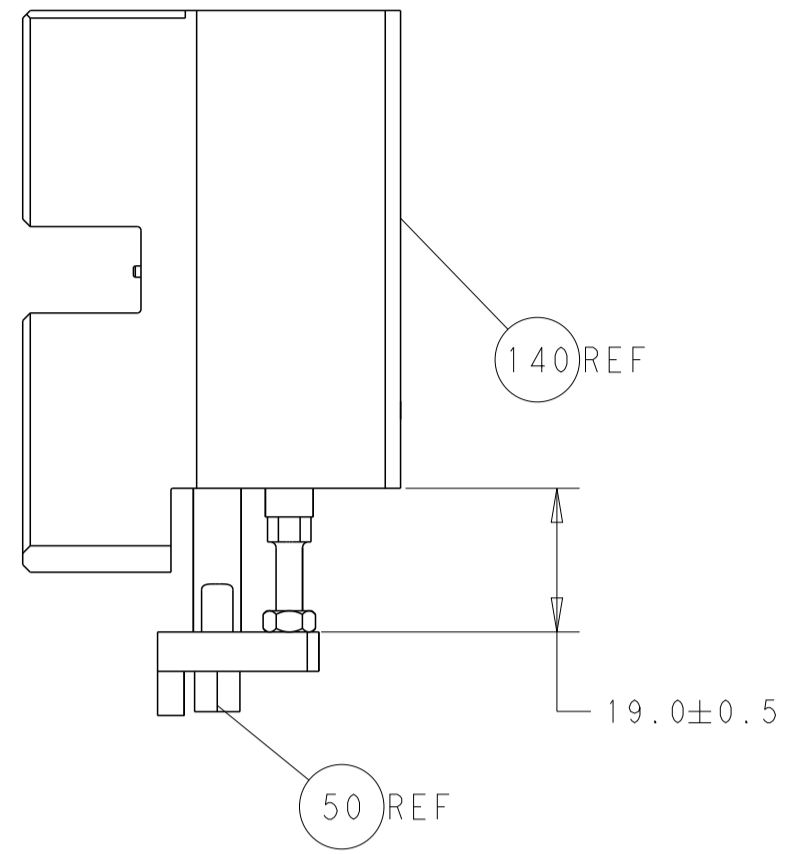
CAM POSITIONS



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

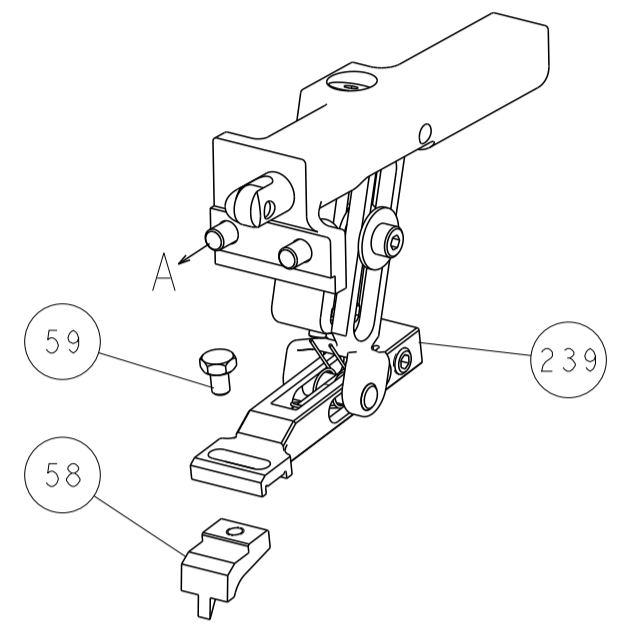
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN K. STAKEM 19OCT2013 CHK G. BAILEY 19OCT2013 APVD J. ELBIN 19OCT2013		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		NAME: Ocean End Feed Applicator		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150384	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 2 OF 4 REV E	

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

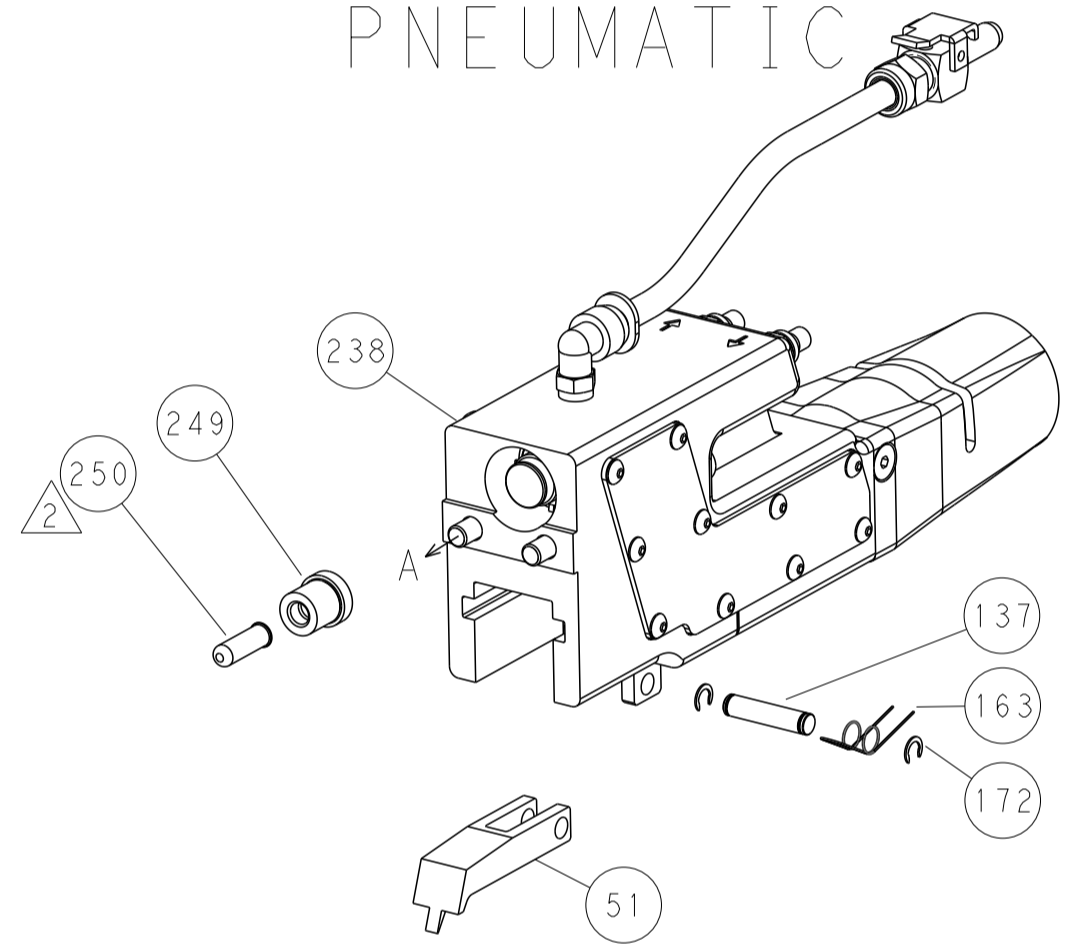


HOLD DOWN SET UP

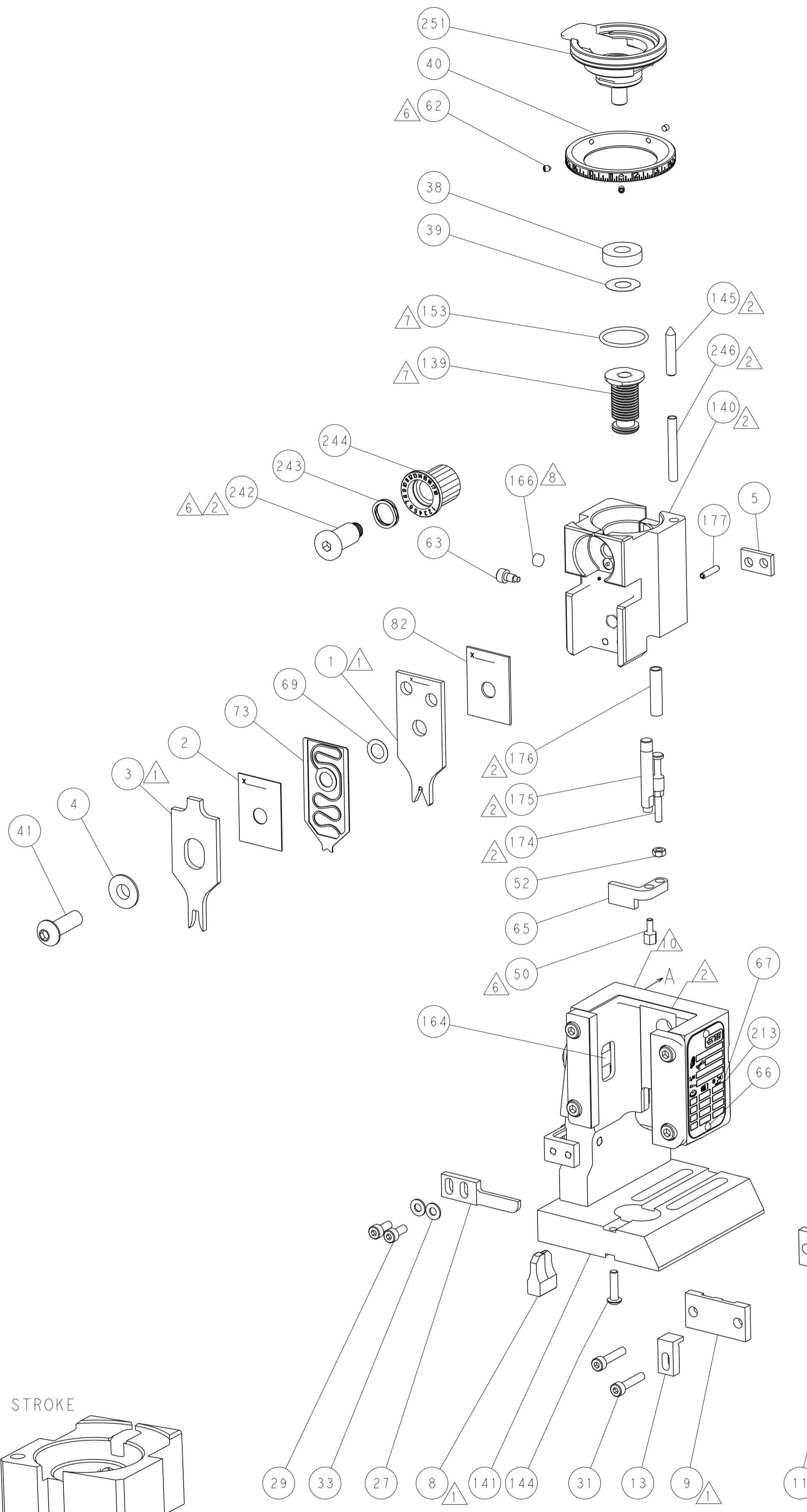
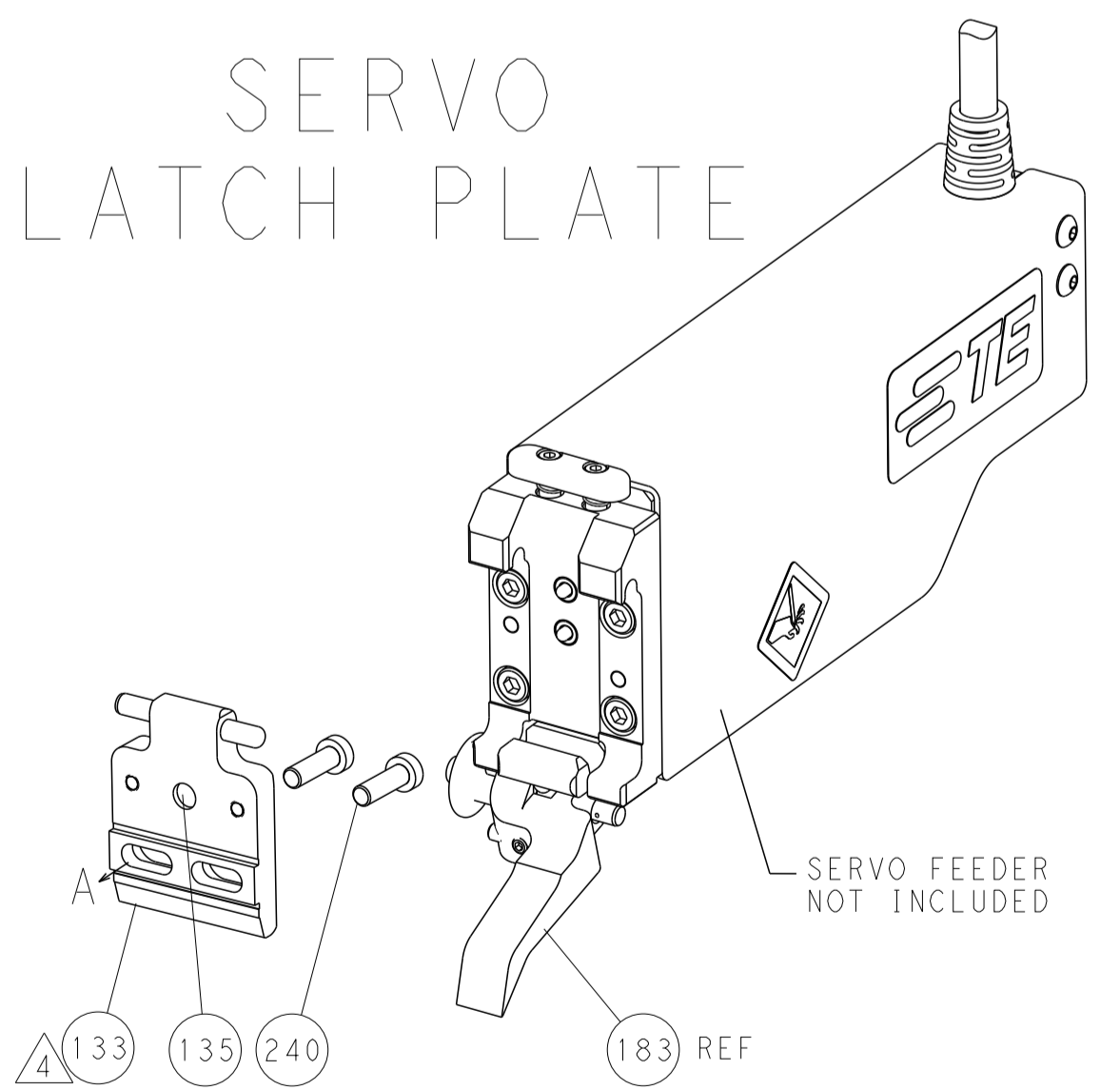
FEED TYPE
MECHANICAL



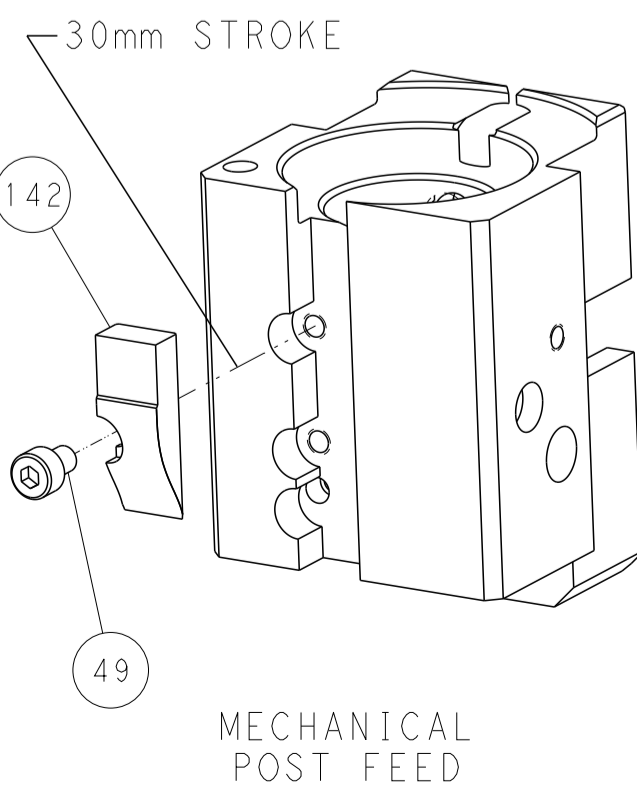
PNEUMATIC



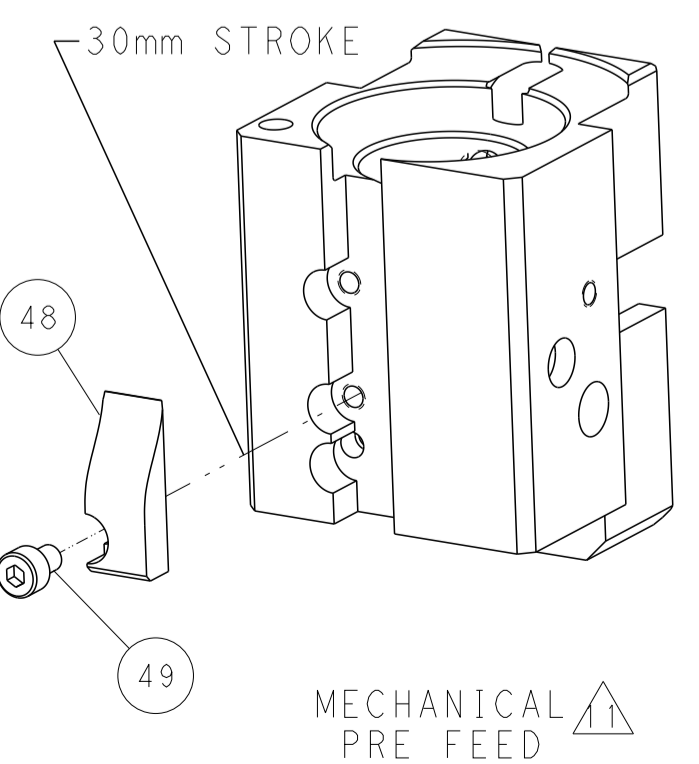
SERVO
LATCH PLATE



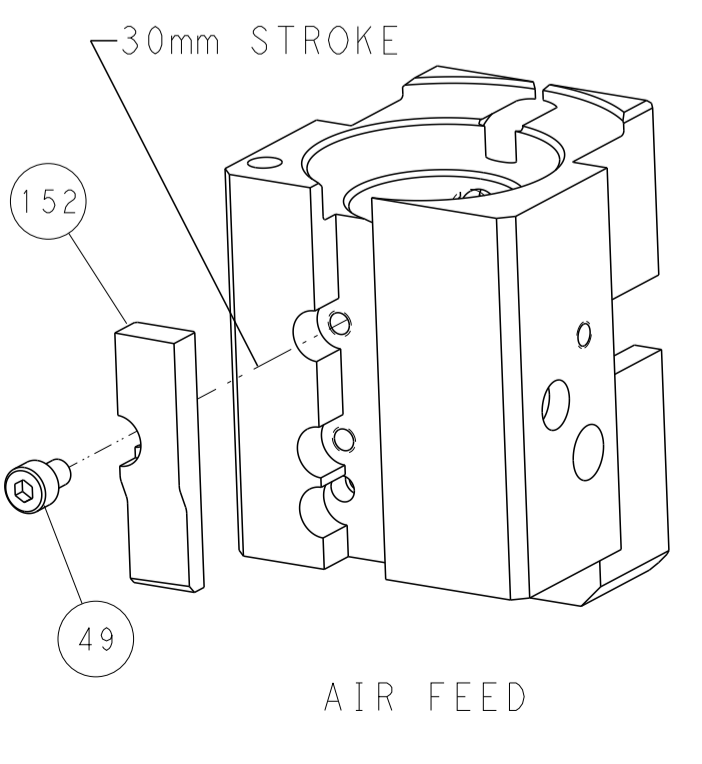
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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:		DWG: STAKEM 19OCT2013		CHK: G. BAILEY 19OCT2013		NAME: Ocean End Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: T. ELBIN 19OCT2013	PRODUCT SPEC	SIZE: A1	CAGE CODE: 00779
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:1	SHEET: 4	OF: 4	REV: E	Customer Accessible Production Drawing		