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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2150397-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1
	2150397-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-3	8-2150397-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150397-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
	2150397-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	1901697-3	8-2150397-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150397-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
2150397-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-	
2150397-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150397-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

REVISIONS	DATE	OWN	APVD
A	14FEB2014	BH	TE
A1	17JUL2015	KH	UG
B	11APR2016	RK	GB

APPLICATOR DATA

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

APPLICATOR INSTRUCTIONS 408-10390

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, FASTON FLAG .187 SERIES

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.39-5.16 mm [.173-.203 IN]	Ø1.52-2.79 mm [.060-.110 IN]

TERMINAL APPLICATION SPECIFICATION 114-2079

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742086-1	1742086-2	1742087-1	1742087-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.27 +/- 0.05 [.050 +/- .002]	4.7
20 AWG	1.14 +/- 0.05 [.045 +/- .002]	6.2
22 AWG	1.06 +/- 0.05 [.042 +/- .002]	7.1

- 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: 8-2150397-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150397-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150397-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150397-6
- 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 ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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 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.

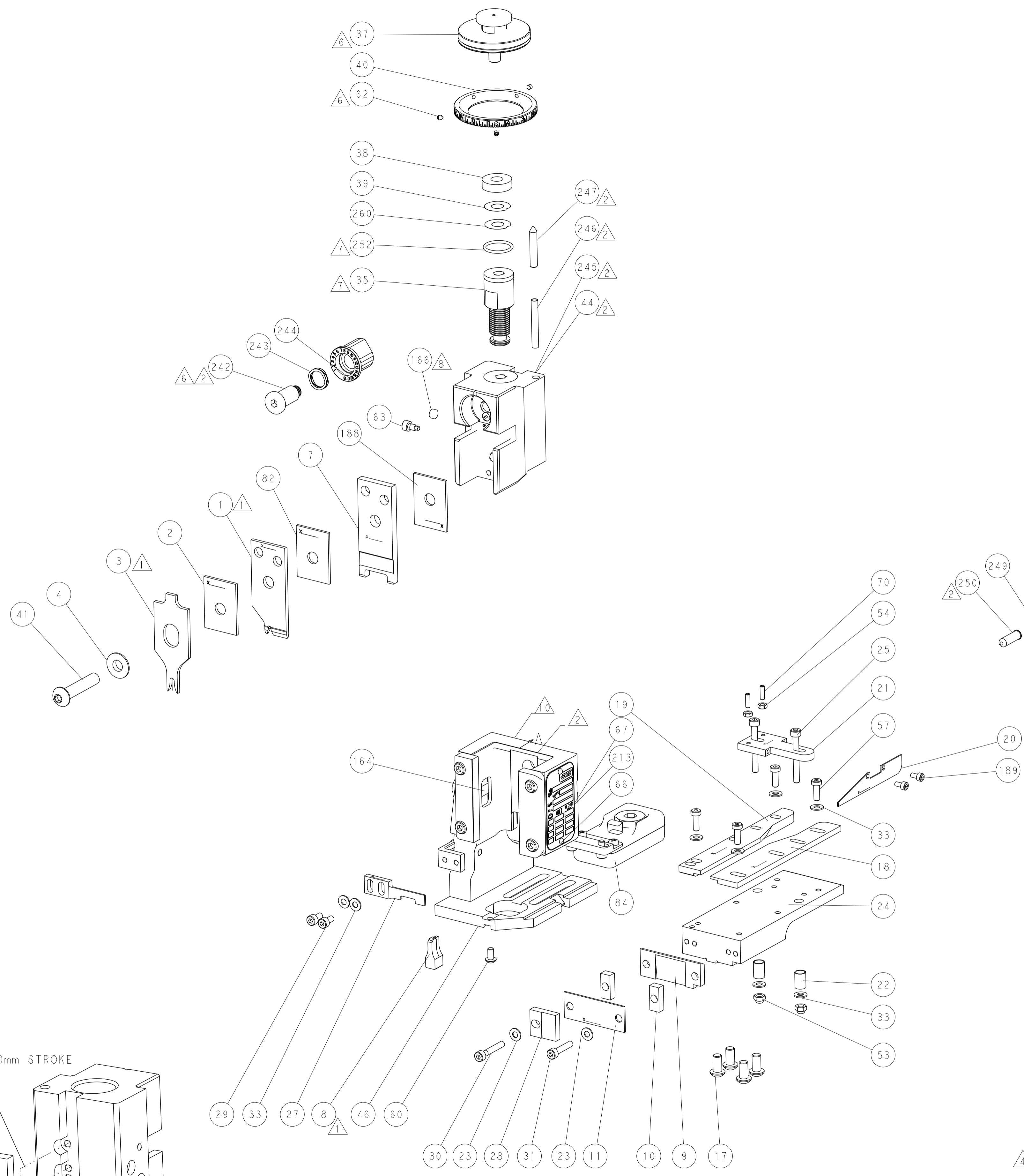
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

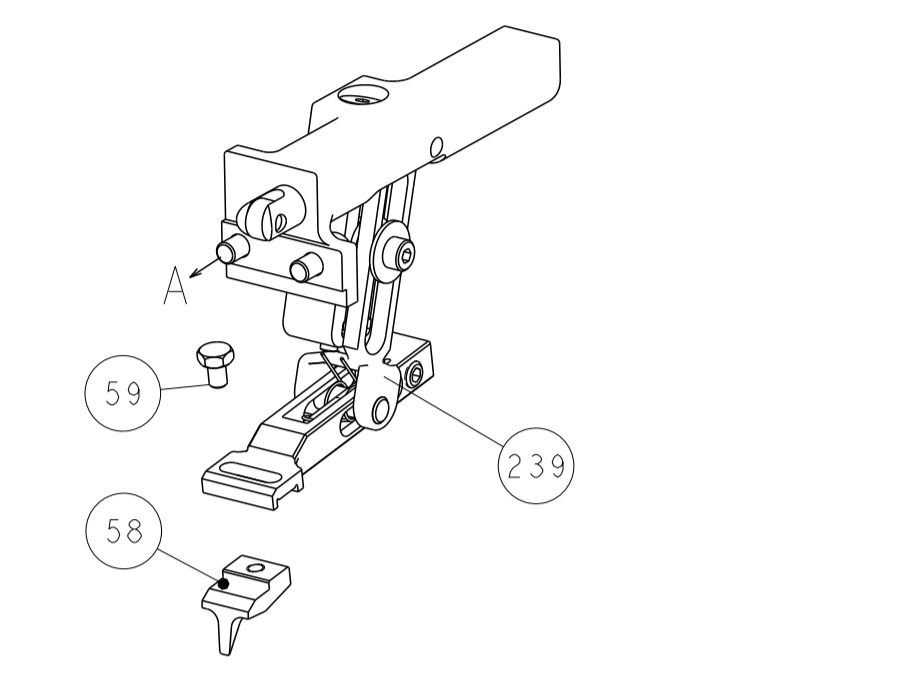
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2161315-1	RAM, STEPPED, AMP STYL, EF, NON-ADJUST	245
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	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
-	2	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	189
-	1	1	1	1	1	1-455888-5	SPACER, CRIMPER	188
-	-	REFREF	-	-	-	1901697-3	FEED FINGER ASSEMBLY, EF	183
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREFREFREFREFREF	-	-	-	-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	1	1-455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	1	-	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	2161924-1	FEED FINGER	58
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	-	-	1	2161920-1	NARROW PAWL, EF, AIR	51
-	-	-	-	-	1	218023-9	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	1-2119655-7	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	-	-	-	2161310-1	RAM, STEPPED, AMP STYLE, END FEED	44
-	1	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	41
-	1	-	-	-	-	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	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	-	-	-	-	2119092-1	BOLT, ADJUSTMENT	35
-	8	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	1	1	1	1	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	1	1	1	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	30
-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	1	1	469633-1	BLOCK, SUPPORT	28
-	1	1	1	1	1	468281-8	STRIPPER	27
-	2	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1	1	2161922-4	PLATE, STRIP GUIDE	24
-	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	23
-	2	2	2	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1	1	1	464452-4	DRAG, STOCK	20
-	1	1	1	1	1	5-1901696-7	STRIP GUIDE, REAR	19
-	1	1	1	1	1	3-1901695-1	STRIP GUIDE, FRONT	18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1	455961-5	PLATE, FRONT SHEAR	11
-	2	2	2	2	2	1-240645-9	SPACER, SHEAR PLATE	10
-	1	1	1	1	1	461160-3	PLATE, REAR SHEAR	9
-	1	1	1	1	1	4-1803000-0	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1	2161927-1	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	-	-	-	-	-	-	-	5
-	1	1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	1803018-8	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1-455888-7	SPACER, CRIMPER	2
-	1	1	1	1	1	1803006-6	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

<p>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</p>		<p>OWN: BOB HIGMAN CHE: T. ELBIN APVD: M. CLIFFORD DATE: 09DEC2013 PRODUCT SPEC</p>		<p>NAME: Ocean End Feed Applicator</p>
<p>DIMENSIONS: mm</p> <p>0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±</p>		<p>TOLERANCES UNLESS OTHERWISE SPECIFIED:</p> <p>WEIGHT: -</p>		<p>SIZE: A1</p> <p>CAGE CODE: 00779</p> <p>DRAWING NO: C=2150397</p> <p>RESTRICTED TO: -</p>
<p>MATERIAL: -</p>		<p>Customer Accessible Production Drawing</p>		<p>SCALE: 1:1</p> <p>SHEET: 1 OF 4</p> <p>REV: B</p>

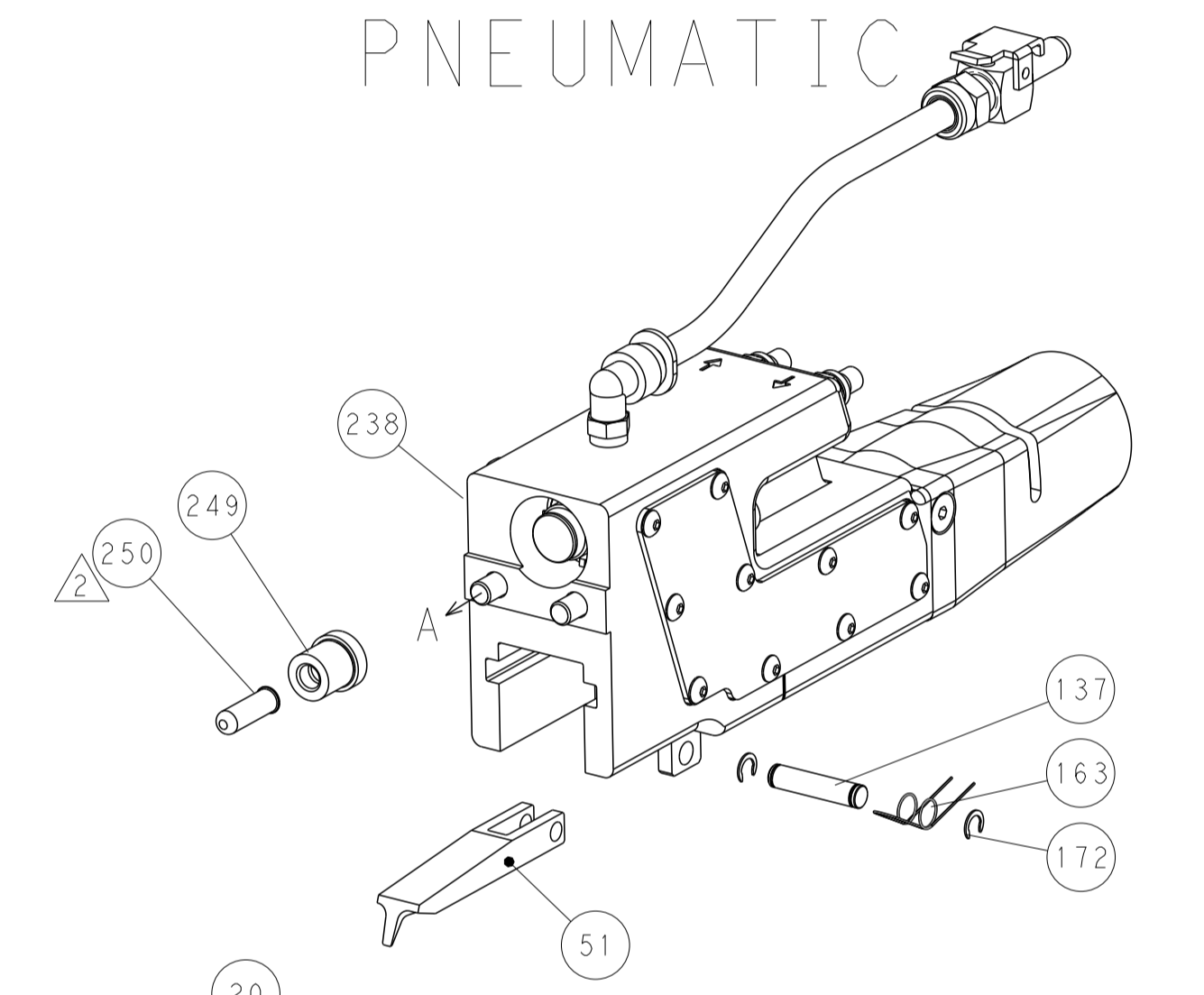
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



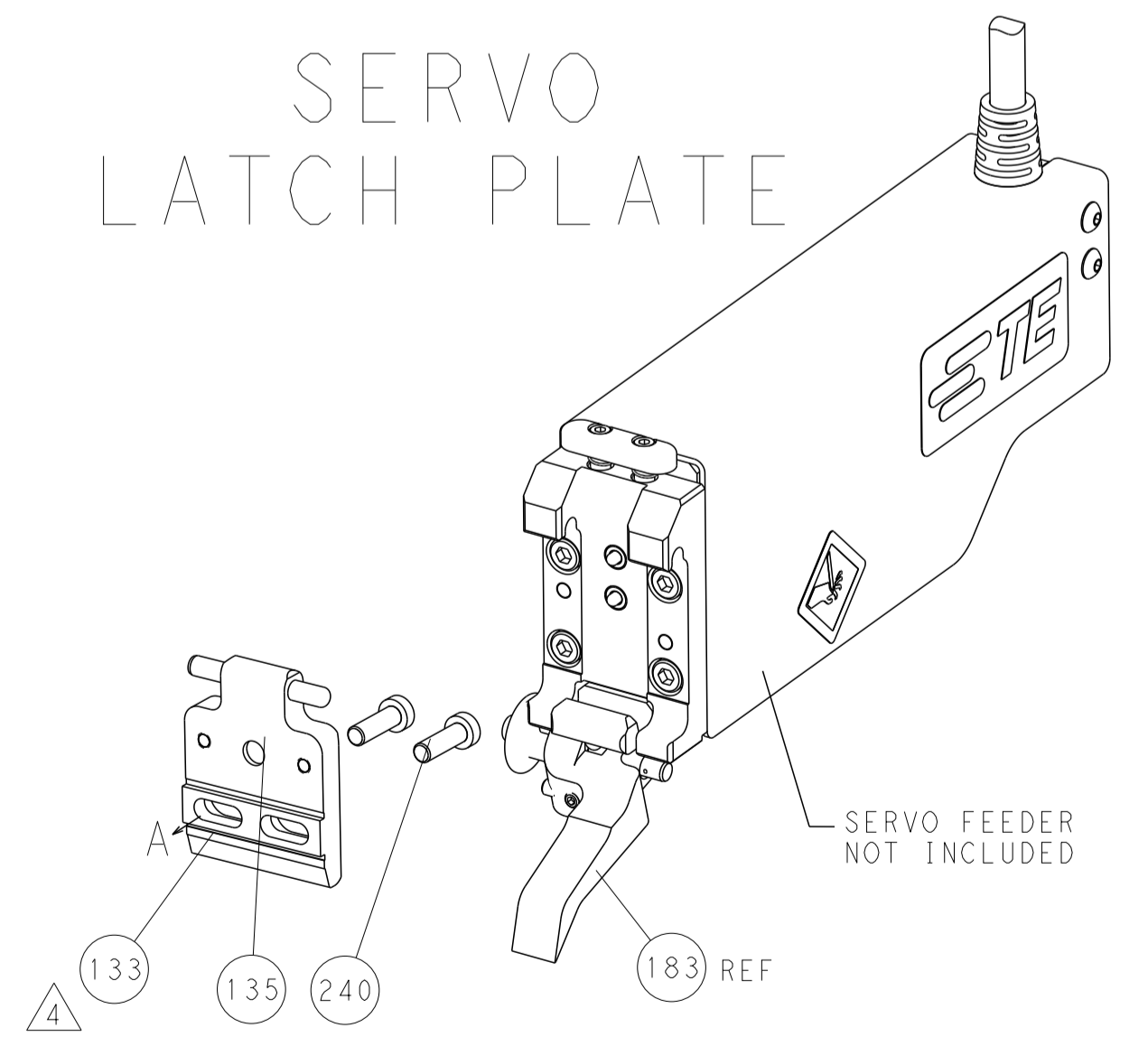
FEED TYPE
MECHANICAL



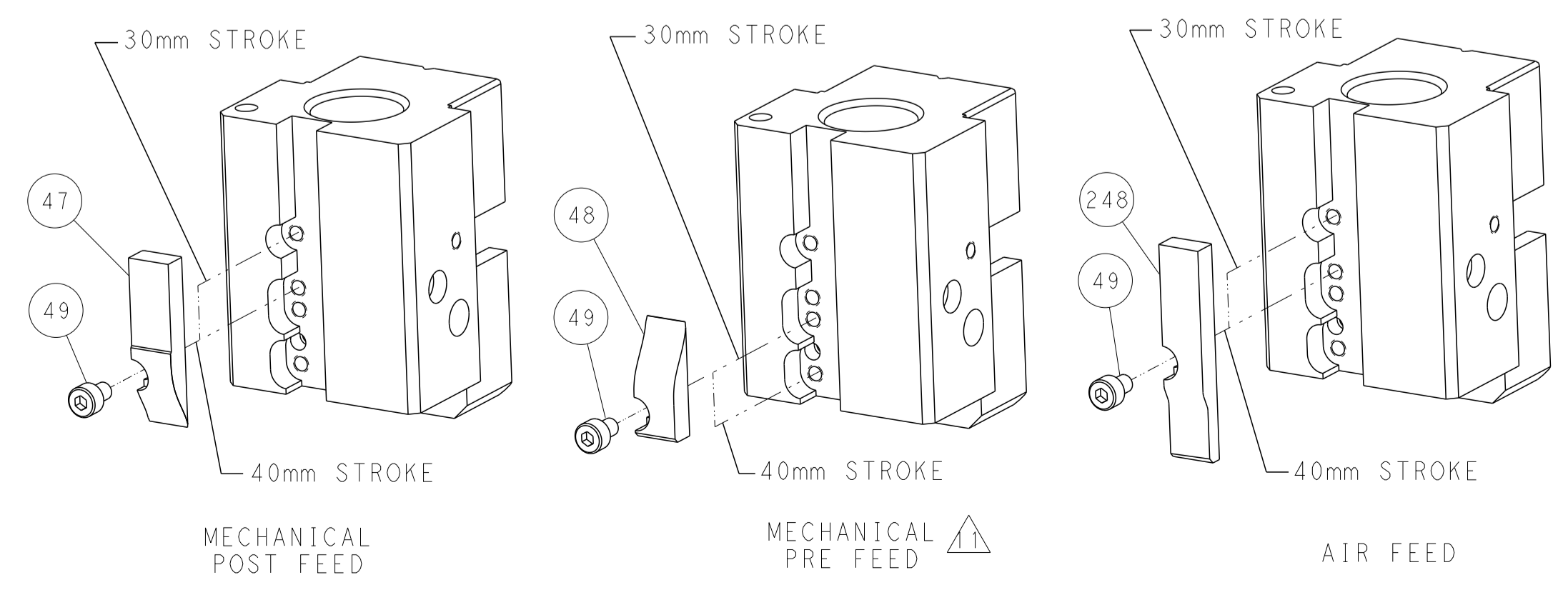
PNEUMATIC



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: BOB_HIGMAN 09DEC2013		TE Connectivity	
mm		0 PLC ±		CHK: T_ELFIN 09DEC2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: M_CLEFFORD 09DEC2013		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
D		3 PLC ±		APPLICATION SPEC:		RESTRICTED TO:	
R		4 PLC ±		WEIGHT:		A1 00779 ©=2150397	
S		5 PLC ±		MATERIAL:		SCALE: 1:1 SHEET 2 OF 4 REV B	
T		6 PLC ±		FINISH:		Customer Accessible Production Drawing	
F		7 PLC ±		APPROVAL:		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

Table with 5 columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO. It lists various part numbers and their corresponding descriptions for the Pacific Version Terminator Interface Adapter. Includes a drawing of the applicator on the left.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Lists wire and insulation specifications.

Terminal Data table with columns: TE TERMINAL, TE CRIMP SPECIFICATION, WIRE STRIP LENGTH, INSULATION DIAMETER RANGE. Includes a drawing of a terminal.

Wire Size table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Lists settings for 18 AWG, 20 AWG, and 22 AWG.

- RECOMMENDED SPARE PARTS
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: 8-2150397-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150397-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150397-5
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 ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
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.

*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	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-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)

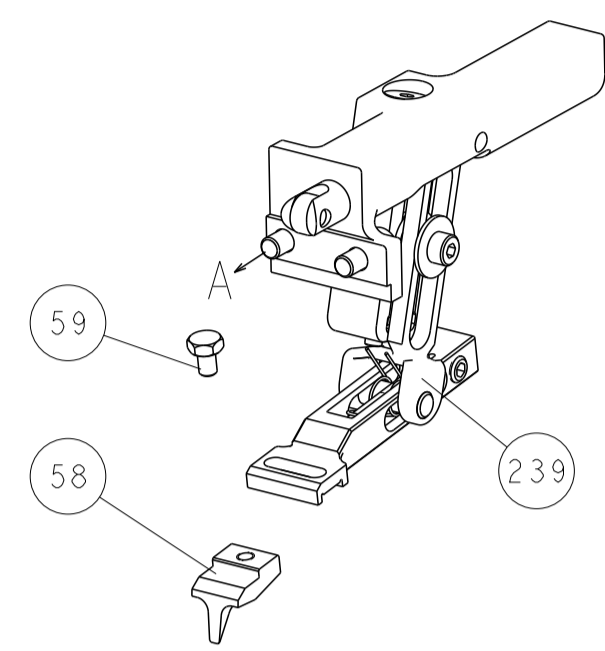
SET UP GAUGE 2119599-2, LOC A, DIST 66. Table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD.

Main parts list table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD. Lists numerous components like bushings, springs, washers, retainers, etc.

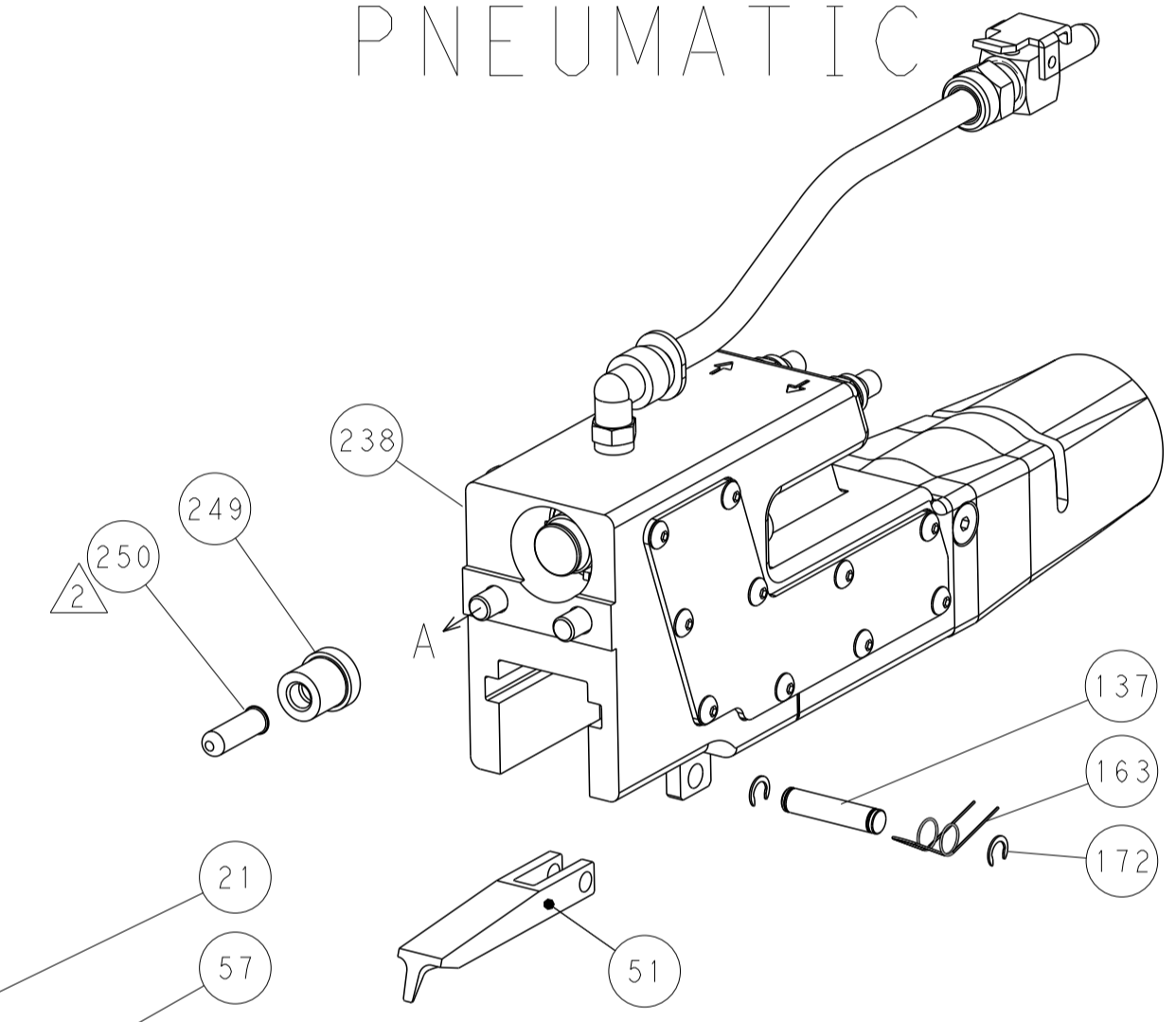
TE Connectivity Ocean End Feed Applicator drawing information including dimensions, tolerances, dimensions, weight, and application specifications.

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

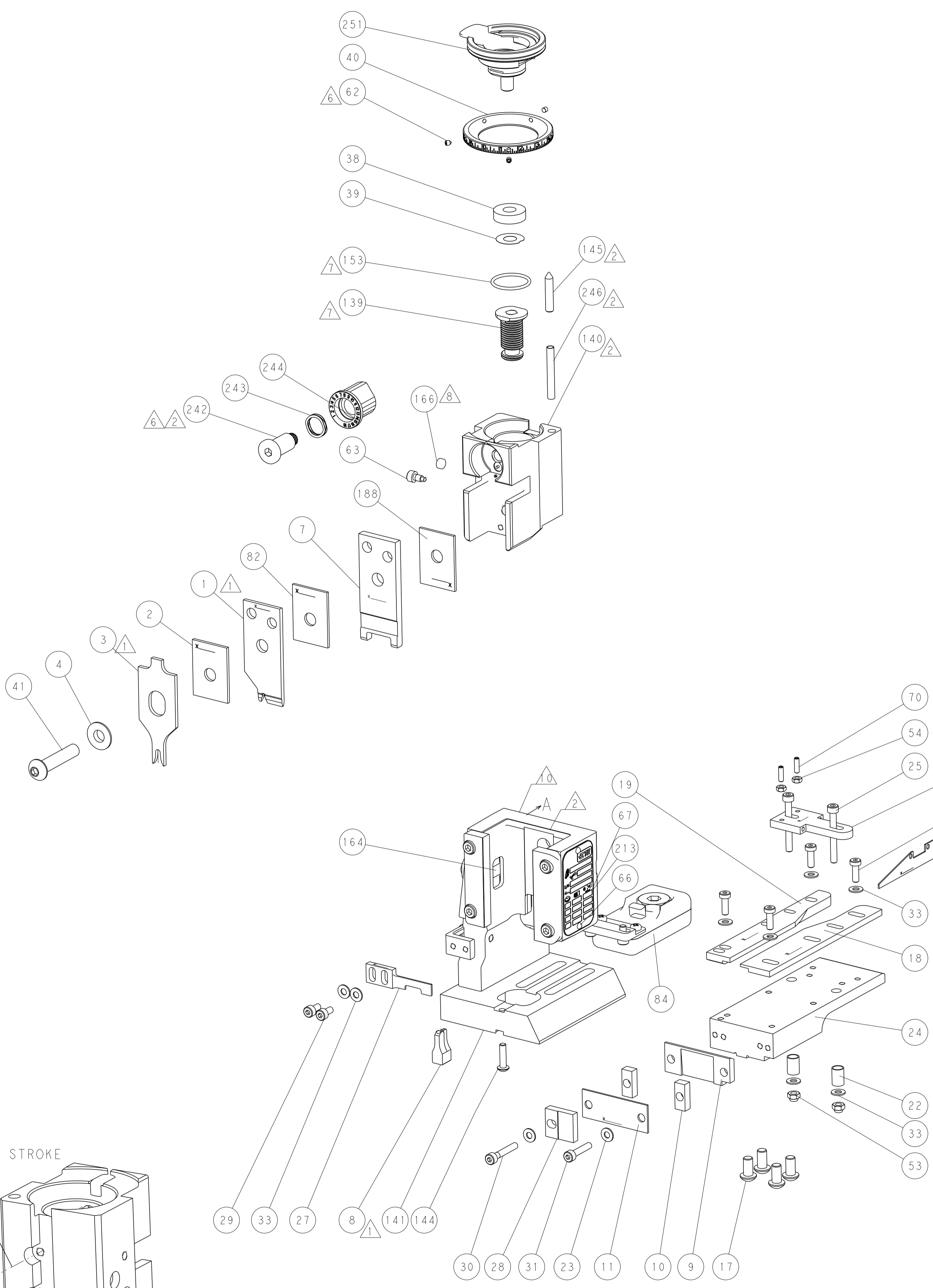
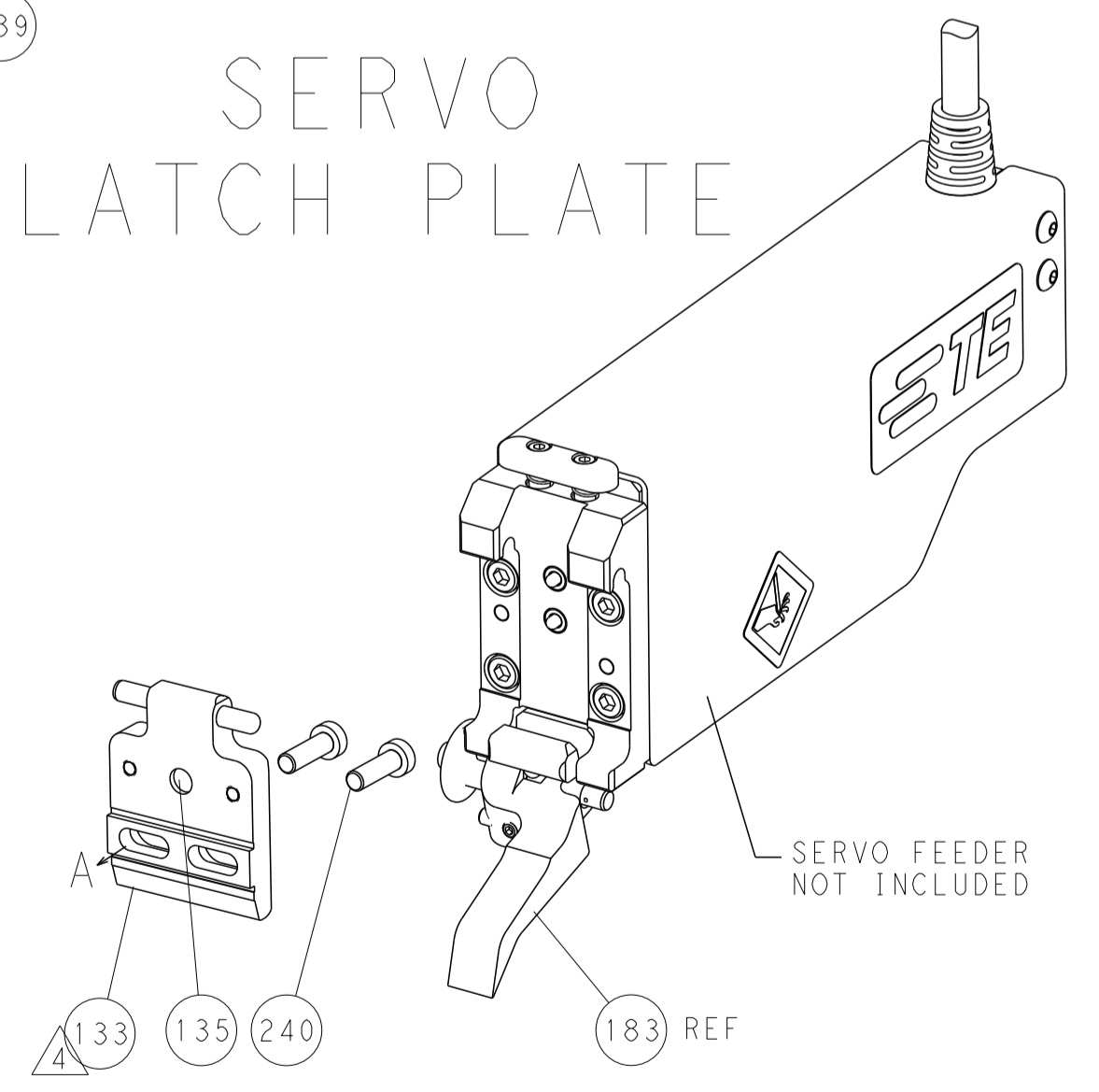
FEED TYPE MECHANICAL



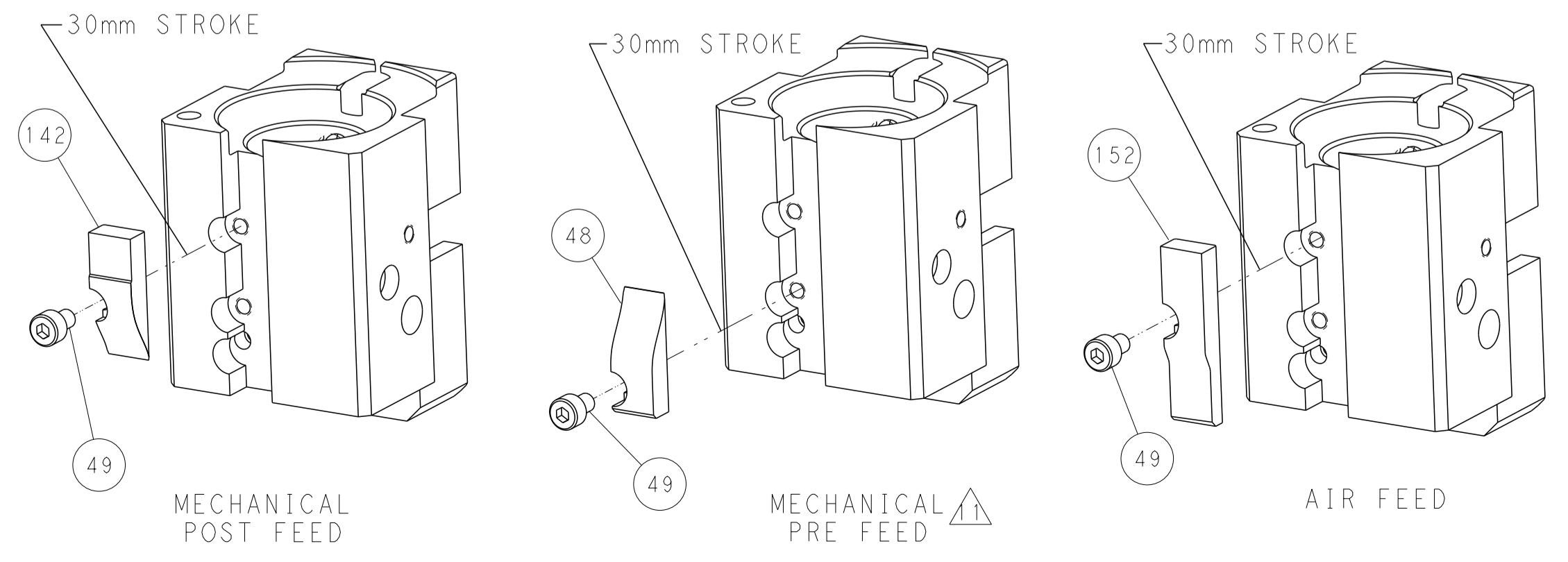
PNEUMATIC



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN BOB HIGMAN 09DEC2013 CHK T. ELBIN 09DEC2013 APVD M. CLIFFORD 09DEC2013 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150397 SCALE 1:1 SHEET 4 OF 4 REV B		RESTRICTED TO -	
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