

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2150293-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150293-5	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150293-4	-	-
	2150293-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	2063440-2
2150293-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	
2150293-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150293-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.94 mm [.155]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.59-6.35 mm [.220-.250 IN]		∅2.54-3.56 mm [.100-.140 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63518-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.16+/-0.05 [.085+/-0.002]	5.9
16 AWG	1.93+/-0.05 [.076+/-0.002]	8.2
18 AWG	1.80+/-0.05 [.071+/-0.002]	9.7

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150293-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150293-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150293-6
- 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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

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 2119599-2	LOC A	DIST 66	REVISIONS			
			REV	DATE	BY	APPV
			A	RELEASED	07FEB2013	RK GB

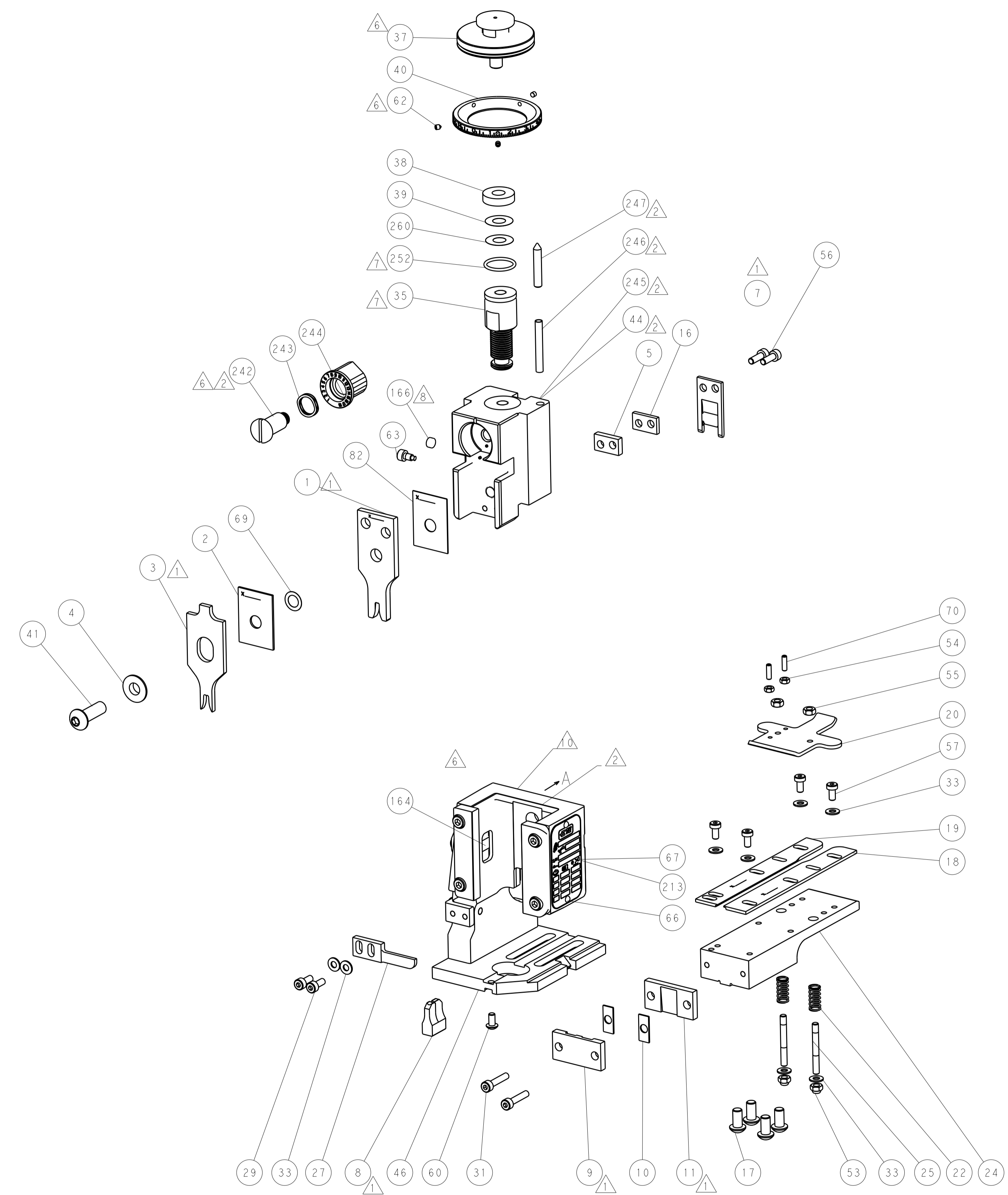
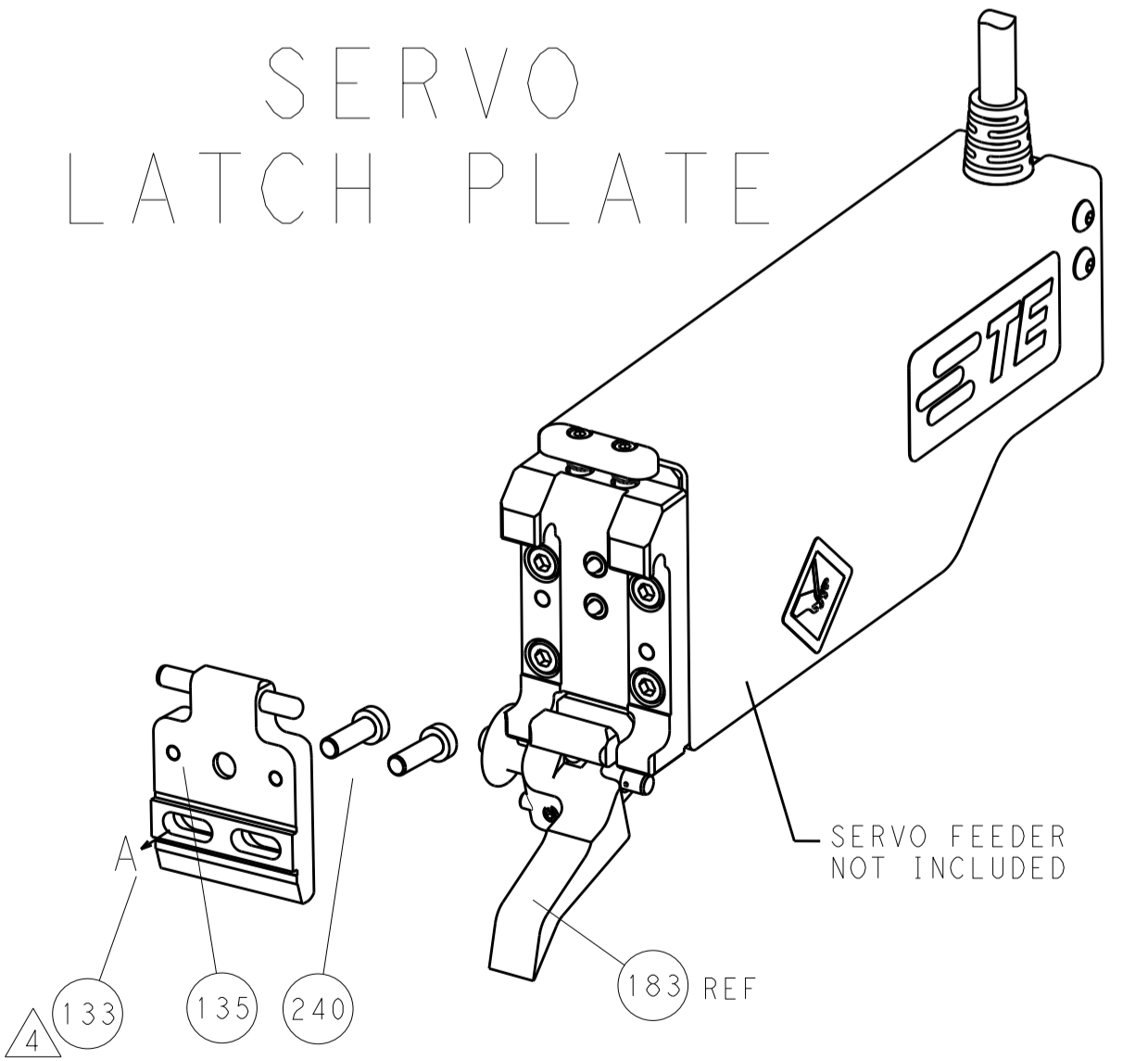
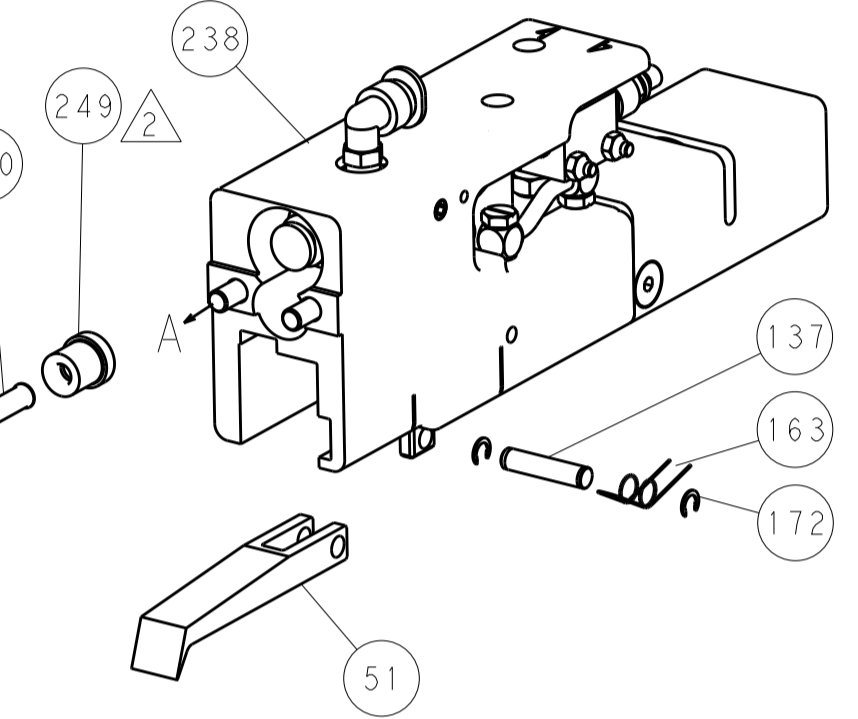
-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	2119082-9	CAM, 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
-	-	2	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REF	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REF	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	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	66
-	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
-	-	-	-	-	2063961-1	FEED FINGER	58
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2119792-1	PAWL, EF, AIR	51
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	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
-	1	1	1	1	1901696-3	STRIP GUIDE, REAR	19
-	1	1	1	1	1901695-3	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	240641-6	SPACER	16
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	2	240645-1	SPACER, SHEAR PLATE	10
-	1	1	1	1	690482-5	PLATE, FRONT SHEAR	9
-	1	1	1	1	2-1803000-2	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2217206-7	BLADE, SLUG	7
-	1	1	1	1	2-240641-0	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	1	1	1-456408-9	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG T. YIN 24OCT2012		CHK G. BAILEY 24OCT2012		APV S. XI 24OCT2012		NAME Ocean End Feed Applicator	
mm		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		PRODUCT SPEC		APPLICATION SPEC		SIZE A1		CAGE CODE DRAWING NO 00779 C=2150293	
MATERIAL		FINISH		WEIGHT		SCALE 1:1		SHEET 1 OF 4		REV A	

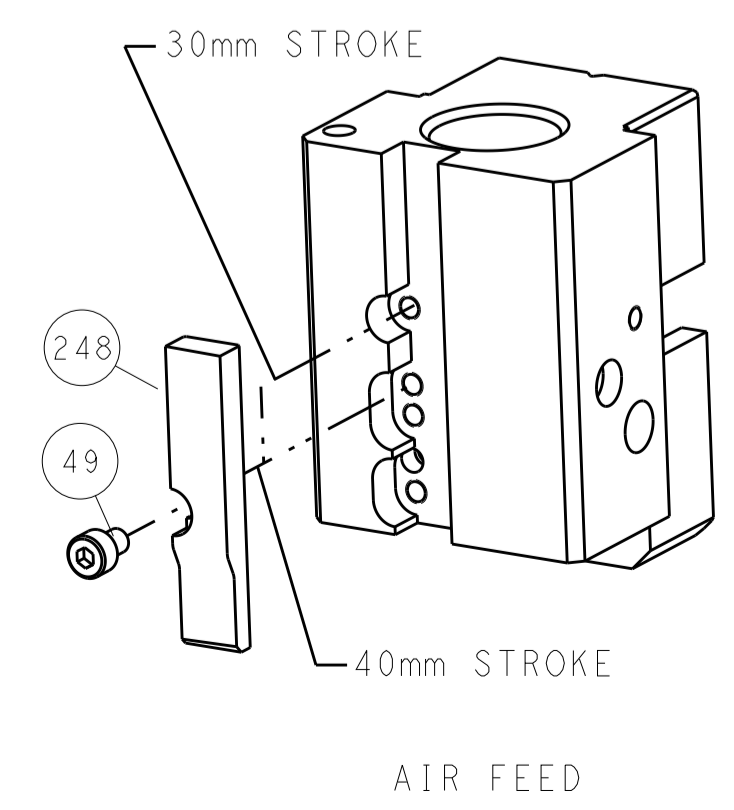
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

FEED TYPE

PNEUMATIC



CAM POSITION



AIR FEED

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:		DWN: Y. YIN 24OCT2012		TE Connectivity	
mm		0 PLC ±.5		CHK: G. BAILEY 24OCT2012		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.5		APVD: S. XI 24OCT2012		NAME: Ocean End Feed Applicator	
H		2 PLC ±0.13		PRODUCT SPEC: -		SIZE: CAGE CODE DRAWING NO: -	
L		3 PLC ±0.013		APPLICATION SPEC: -		RESTRICTED TO: -	
R		4 PLC ±0.001		WEIGHT: -		A11 00779 ©=2150293	
ANGLES		FINISH: -		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150293-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150293-5	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150293-4	-	-
	2-2150293-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-
2-2150293-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150293-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	3.94 mm (.155)	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RING		
WIRE STRIP LENGTH 5.59-6.35 mm (.220-.250 IN)		INSULATION DIAMETER RANGE ∅2.54-3.56 mm (.100-.140 IN)
TERMINAL APPLICATION SPECIFICATION 114-2084		-
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
63518-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
14 AWG	2.16+/-0.05 [.085+/-0.002]	5.9
16 AWG	1.93+/-0.05 [.076+/-0.002]	8.2
18 AWG	1.80+/-0.05 [.071+/-0.002]	9.7

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150293-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150293-5
- 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 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- MAGNET, ITEM 166 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

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			
2119599-2	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

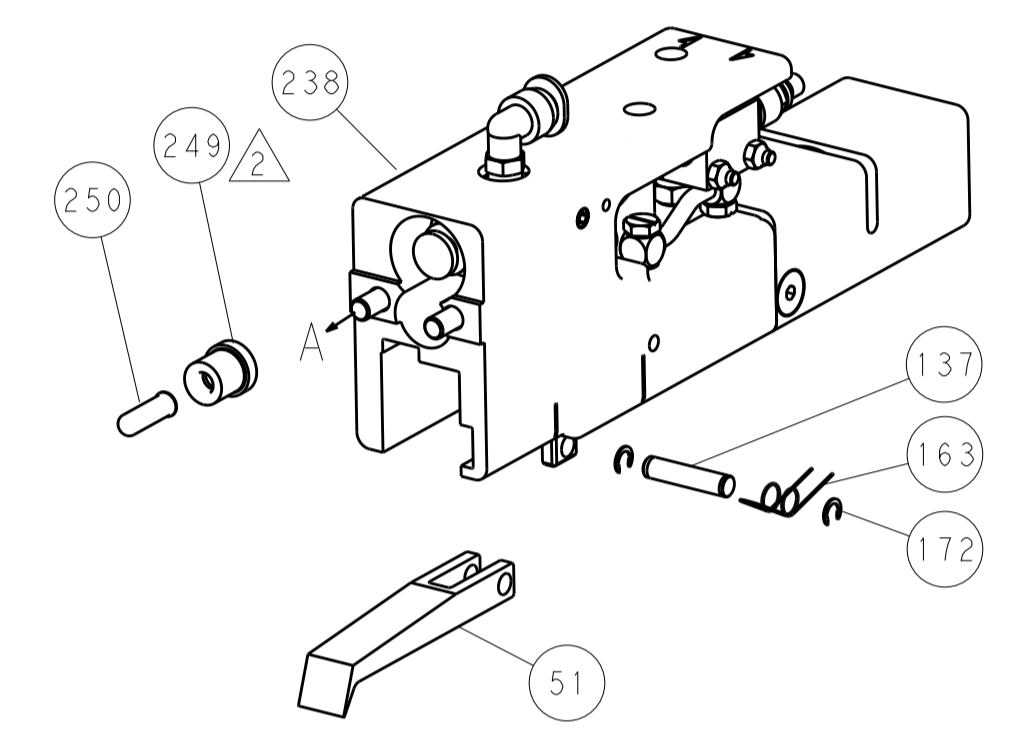
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251	
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250	
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249	
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	-	1	2063440-2	AIR FEED MODULE	238	
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213	
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183	
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
-	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.	153	
-	-	-	1	2119641-2	FEED CAM, AIR FEED	152	
-	1	1	1	2119798-2	DETENT PIN	145	
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140	
-	1	1	1	2119092-2	BOLT, ADJUSTMENT	139	
-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
-	-	1	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71	
-	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70	
-	1	1	1	2119943-1	WASHER, SPACER	69	
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66	
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62	
-	-	-	-	2063961-1	FEED FINGER	58	
-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56	
-	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55	
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	-	-	1	2119792-1	PAWL, EF, AIR	51	
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	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	2119644-2	RAM WASHER, PRECISION	38	
-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-	1	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	2	1320906-1	STUD, THREADED	25	
-	1	1	1	1752371-5	PLATE, STRIP GUIDE	24	
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1752373-4	DRAG	20	
-	1	1	1	1901696-3	STRIP GUIDE, REAR	19	
-	1	1	1	1901695-3	STRIP GUIDE, FRONT	18	
-	1	1	1	240641-6	SPACER	16	
-	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	2	2	2	240645-1	SPACER, SHEAR PLATE	10	
-	1	1	1	690482-5	PLATE, FRONT SHEAR	9	
-	1	1	1	2-1803000-2	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	2217206-7	BLADE, SLUG	7	
-	1	1	1	2-240641-0	SPACER	5	
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4	
-	1	1	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1-455888-0	SPACER, CRIMPER	2	
-	1	1	1	1-456408-9	CRIMPER, WIRE PREMIUM	1	
-	77	27	25	22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		CHK		APPV		NAME	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	Y. YIN	24OCT2012	G. BAILEY	24OCT2012	S. XI	24OCT2012
		FINISH		PRODUCT SPEC		APPLICATOR SPEC		SIZE		CAGE CODE DRAWING NO	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
						A1 00779		3		A	

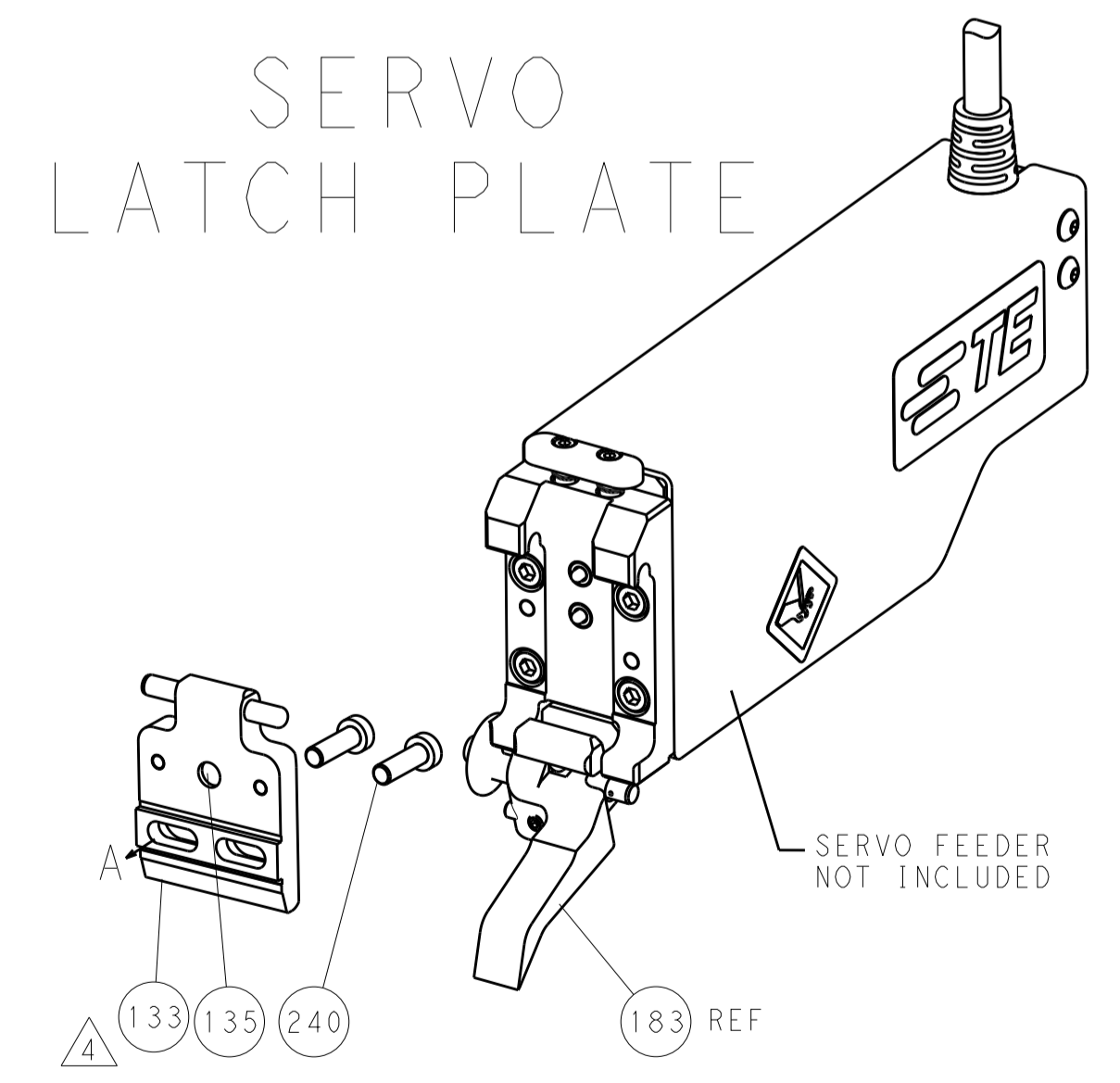
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

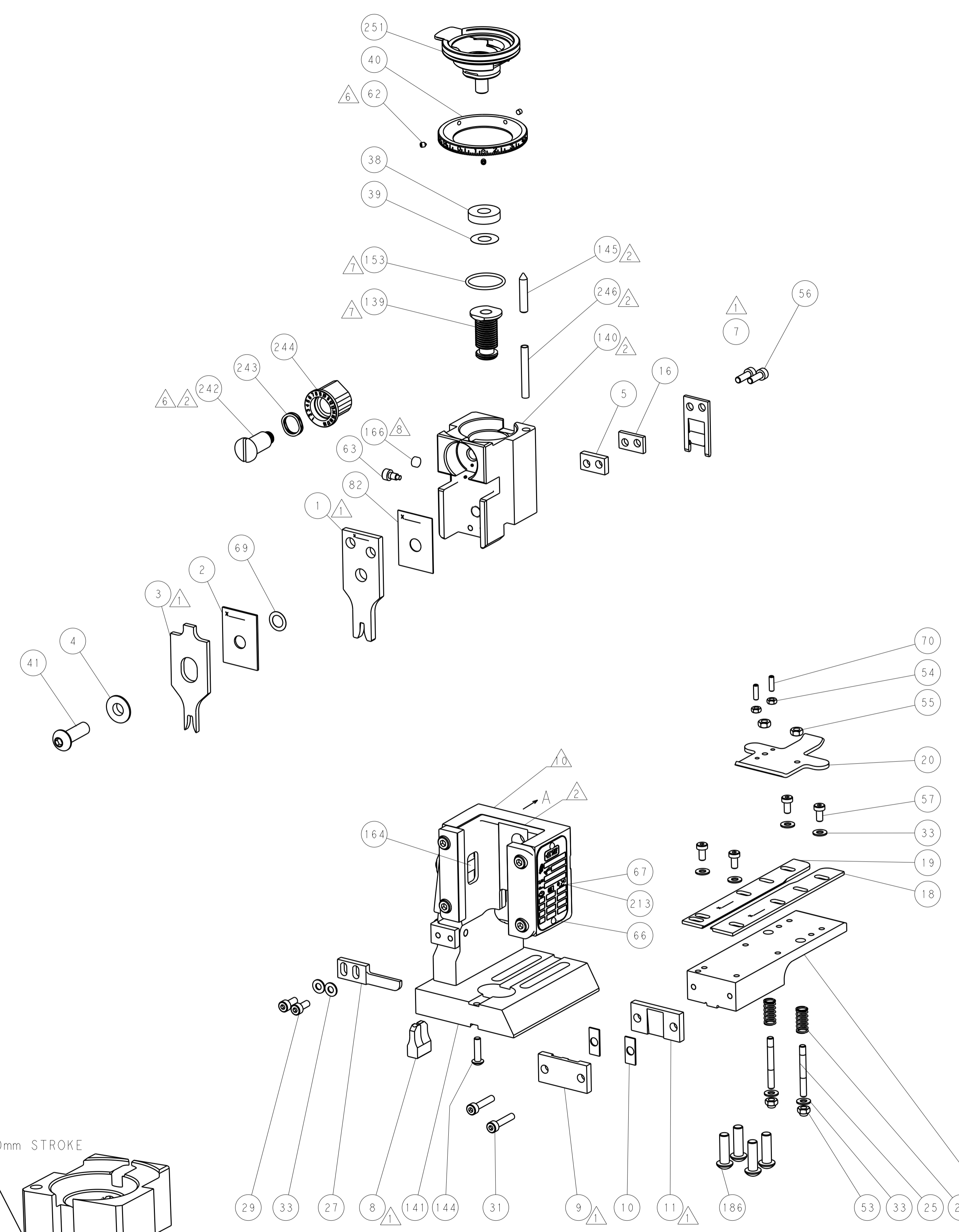
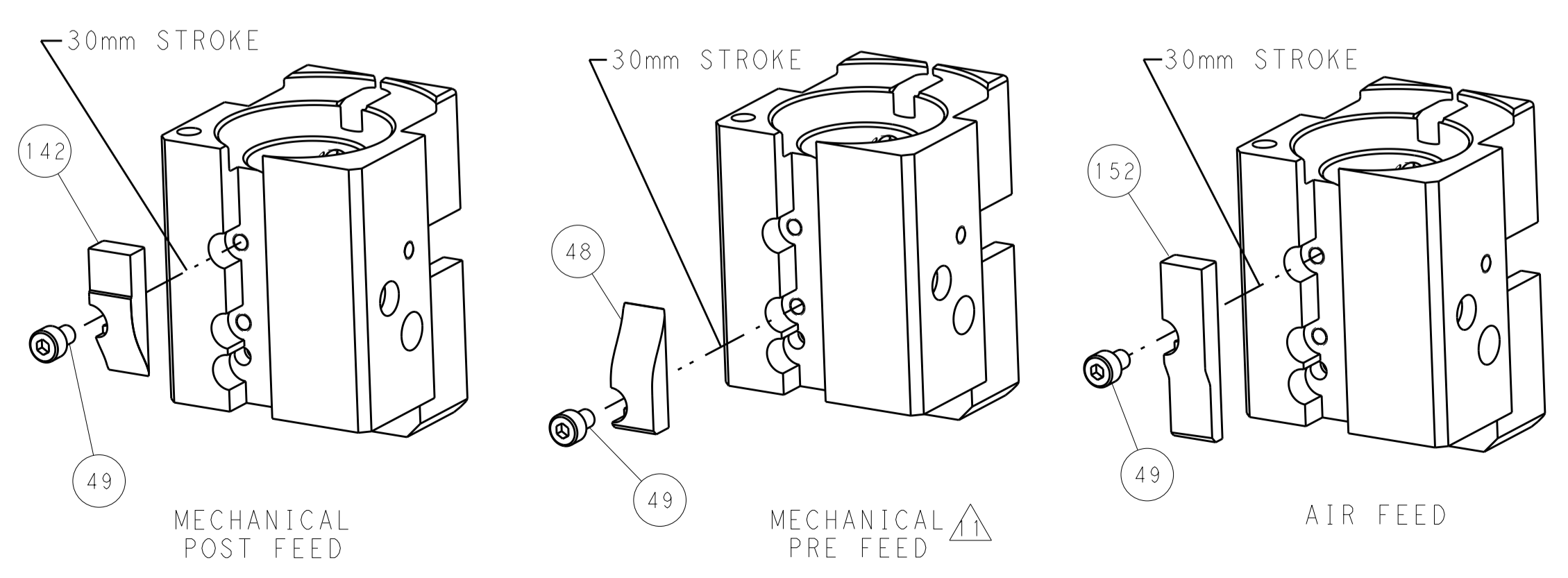
PNEUMATIC



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 24OCT2012		STE TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	5 PLC ±0.001	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD S. XI 24OCT2012	NAME	RESTRICTED TO	
			1:1	Customer Accessible Production Drawing	Ocean End Feed Applicator		
					SIZE CAGE CODE DRAWING NO		
					A1 00779 C=2150293		
					SHEET 4 OF 4		