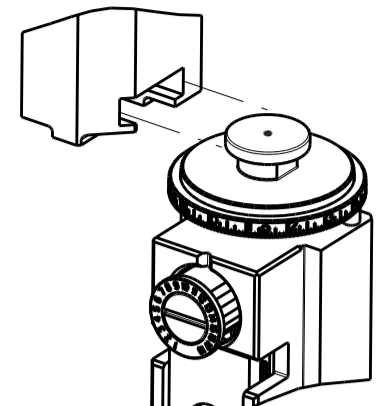



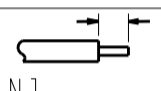














ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2150162-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
	2150162-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150162-5	-	2168400-7 (QUANTITY 2)
	2150162-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	2063440-2
	2150162-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-
	7-2150162-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.32 mm [.170]	OV
APPL INSTRUCTIONS 408-10390 		

TERMINAL DATA: G&H TERMINAL		G&H CRIMP SPECIFICATION	
TERMINAL NAME: G&H TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.32-6.09 mm [.210-.240 IN]		Ø1.90-3.00 mm [.075-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	G&H LEAR SPEC 25221 Rev 9		
TERMINALS APPLIED 			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572900-1	25221.123.011	1572499-1	25219.213.004
1572900-2	25221.213.011	1572499-2	25219.213.320
1572900-3	25221.212.179	1572499-3	25219.123.014
1572900-4	25221.214.009	1572499-4	25219.123.011
1572900-5	25221.214.321	1572499-5	25219.123.322
1572900-6	25221.122.323	1572499-6	25219.123.009
1572900-7	25221.123.014	1572499-7	25219.411.031
1572900-8	25221.123.009		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.25+/-0.05 [.089+/- .002]	7.8
1.0+1.5	2.25+/-0.05 [.089+/- .002]	7.8
2X1.00	2.15+/-0.05 [.085+/- .002]	8.9
1.00+0.75	2.10+/-0.05 [.083+/- .002]	9.2
1.50mm2	2.10+/-0.05 [.083+/- .002]	9.2













-  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: 8-2150162-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150162-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150162-6
- 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 & 180.
 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 ITEMS 37 & 180.
-  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
-  CUT TO LENGTH AT ASSEMBLY.
-  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.

-	-	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	PART NO	DESCRIPTION	ITEM NO

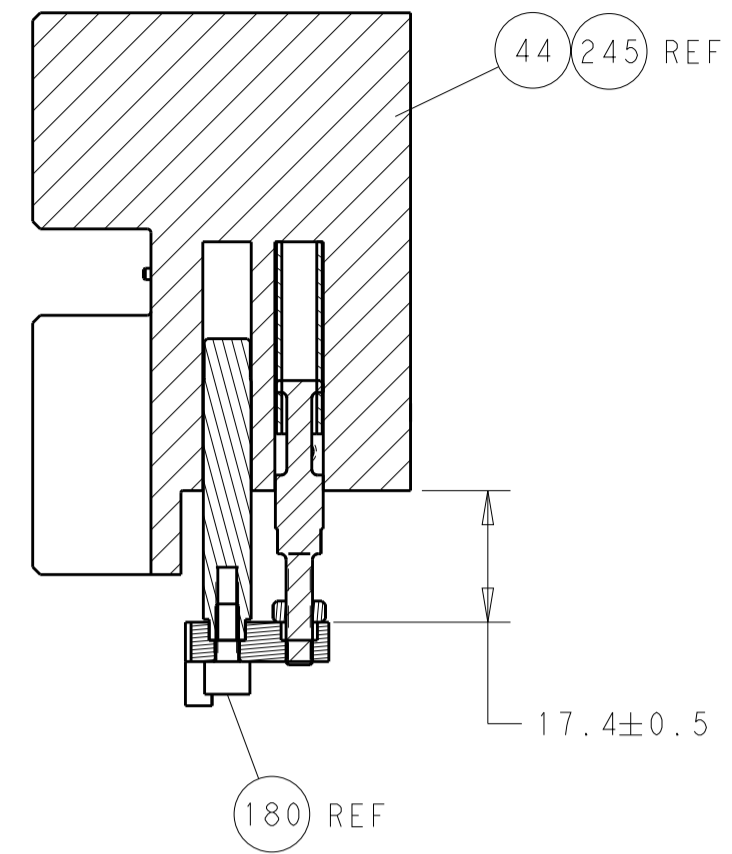
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			1	DEVELOPMENT	17OCT2014	XZ TE
			A	RELEASED	09DEC2014	JH TE
			A1	ECR-16-005598	18APR2016	KH LZ
			B	ECR-17-005417	13APR2017	AW CT

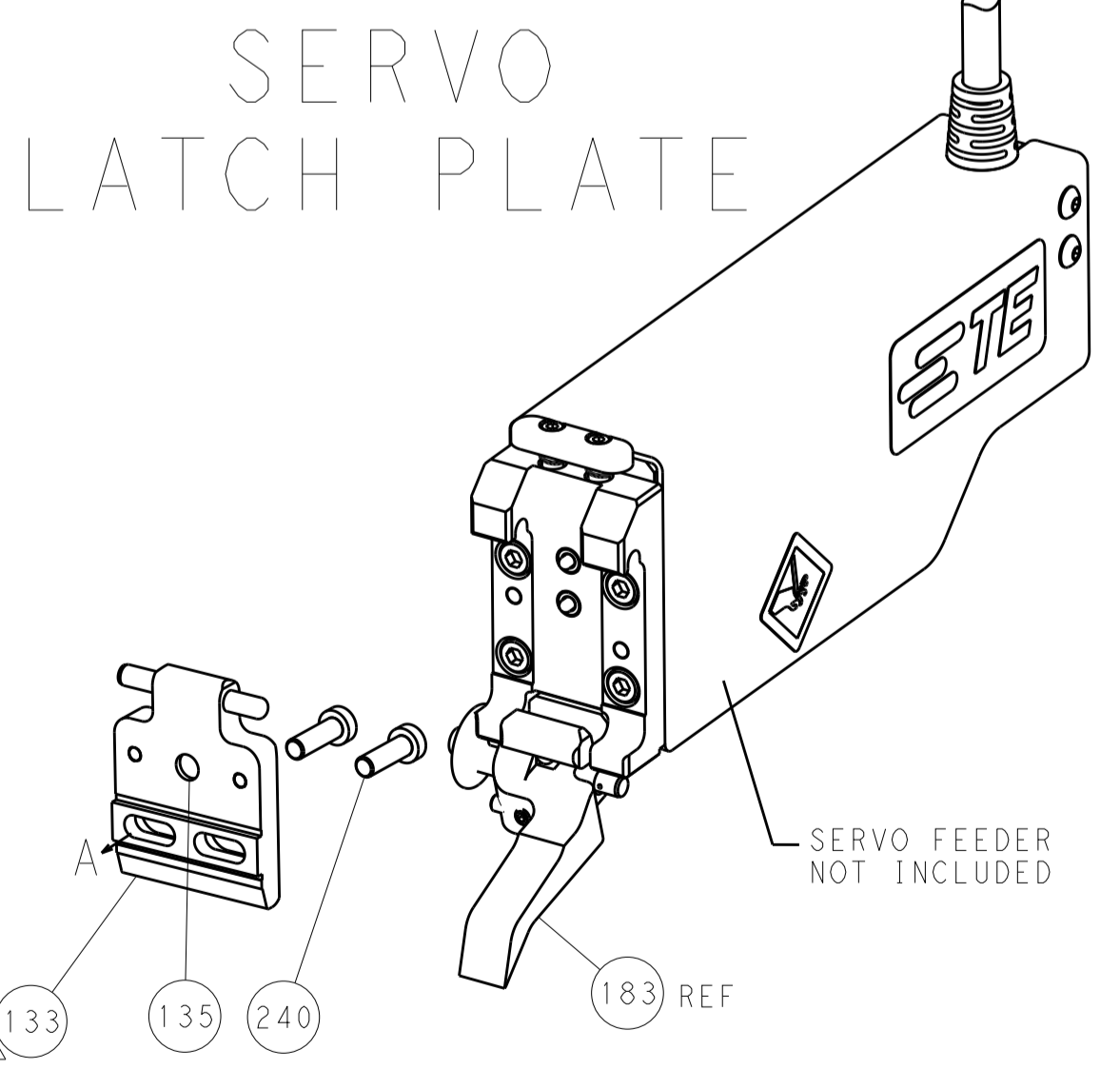
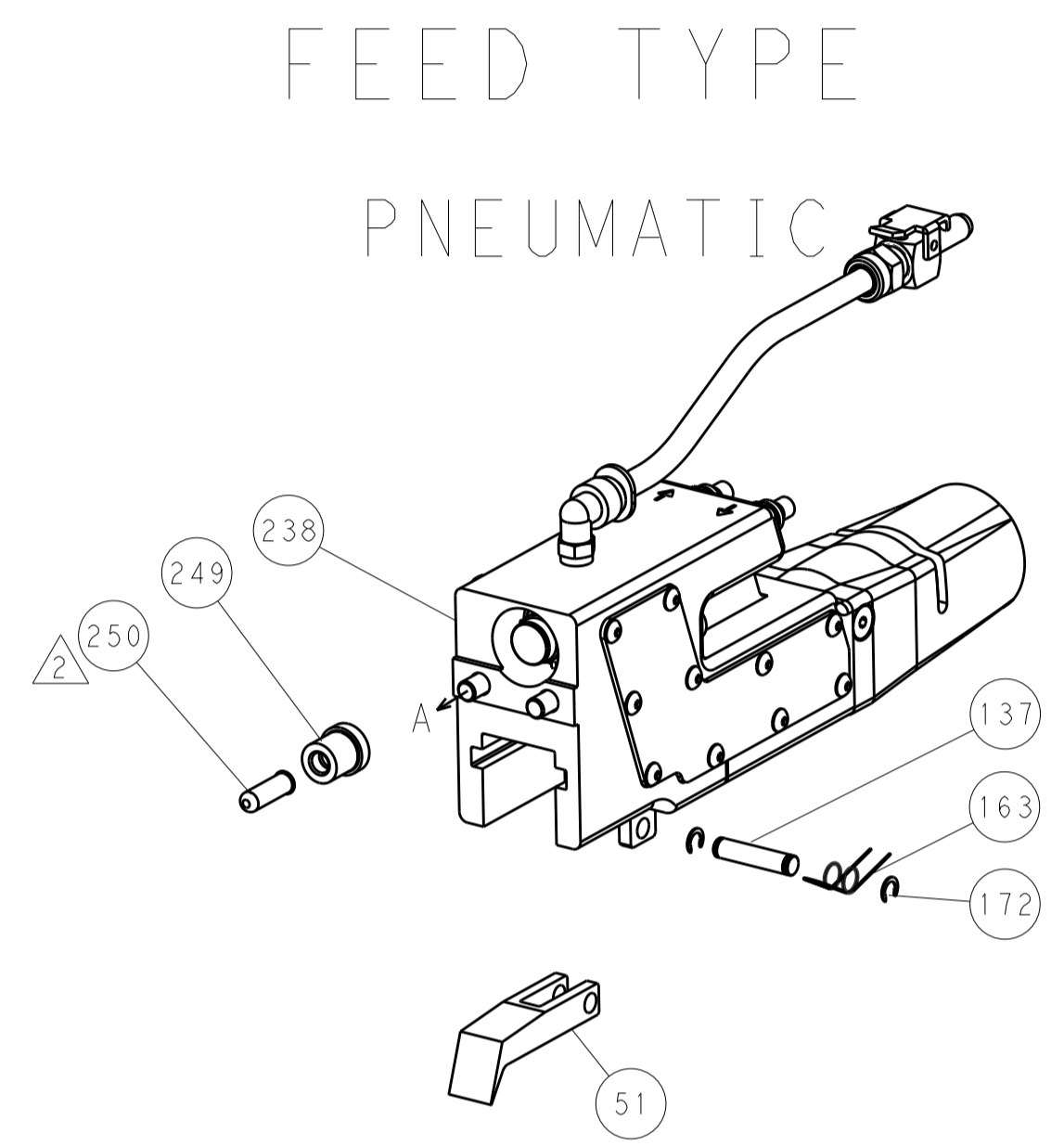
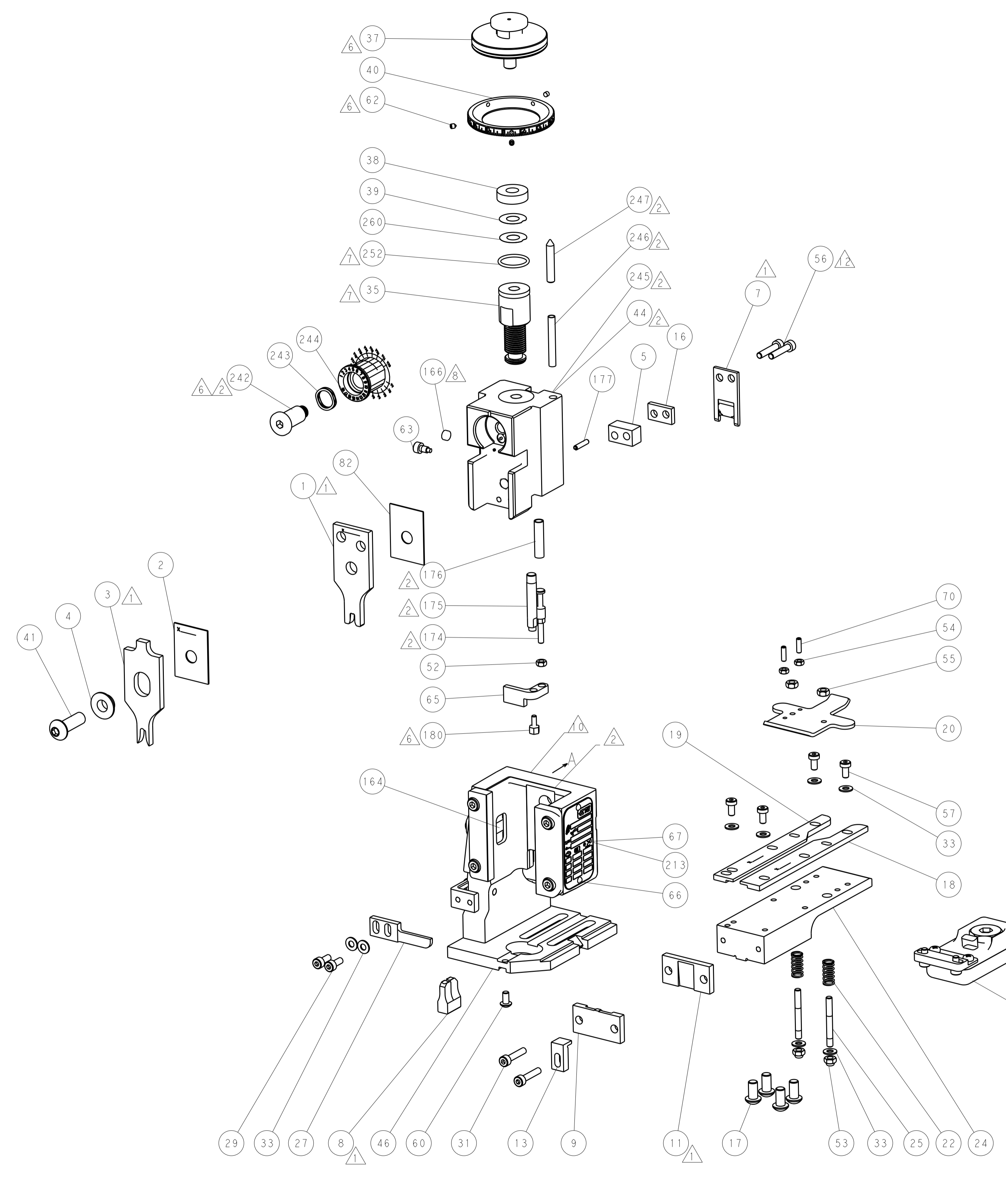
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	-	1	1	2119798-1	DETENT PIN	247	
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245	
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
-	-	-	-	1	2063440-2	AIR FEED MODULE	238	
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213	
-	-	REFREF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183	
	-	1	1	1	1752354-2	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	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	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65	
	-	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	
	-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	2119792-2	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	2119644-1	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	1752371-1	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	2-1901696-2	STRIP GUIDE, REAR	19	
-	1	1	1	1	2-1901695-2	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240641-8	SPACER	16	
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	-	1	1	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
	-	1	1	1	3-690495-6	PLATE, FRONT SHEAR	9	
	1	1	1	1	1	6-1803000-1	ANVIL, COMBINATION, END FEED	8
	-	1	1	1	1	1-2217206-1	BLADE, SLUG	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	1	5-240641-7	SPACER	5
-	1	1	1	1	1	3-238009-9	BLOCK, FL CRIMPER SPACER	4
	1	1	1	1	1	6-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
	1	1	1	1	1	3-456410-2	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC	±		CHK	X. ZHAO	17OCT2014	
	1 PLC	±		CHK	L. ZHANG	17OCT2014	
	2 PLC	±		APPV	J. ELBIN	17OCT2014	
	3 PLC	±		NAME			
	4 PLC	±		Ocean End Feed			
	ANGLES	±		Applicator			
	FINISH	±		SIZE			
				A1 00779 C=2150162			
MATERIAL				WEIGHT		Customer Accessible Production Drawing	
				SCALE		SHEET 1 of 4	
				REV		B	

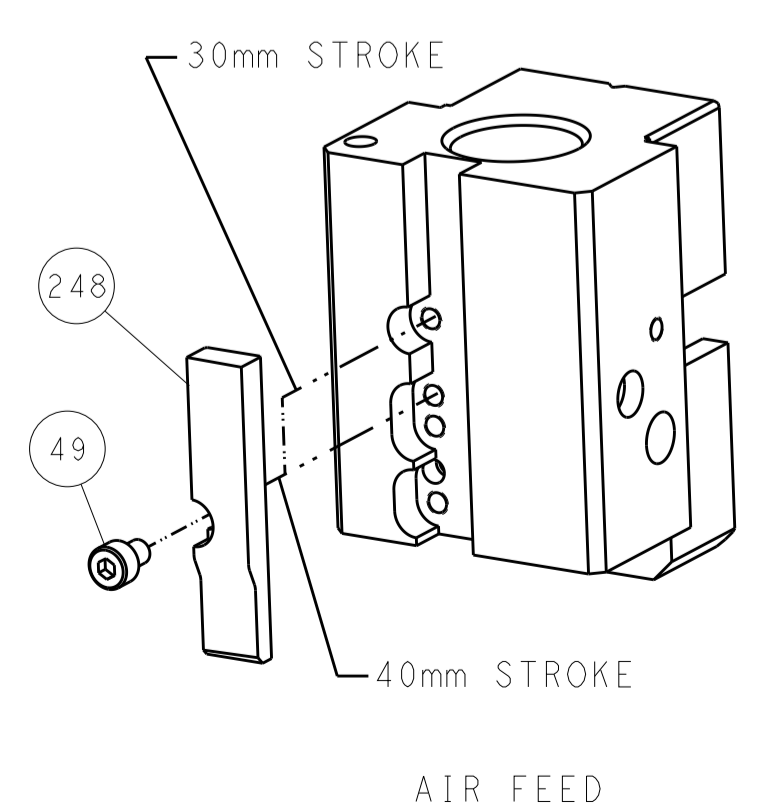
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
		-	-	SEE SHEET 1	-	-	-



HOLDDOWN SET-UP



CAM POSITION

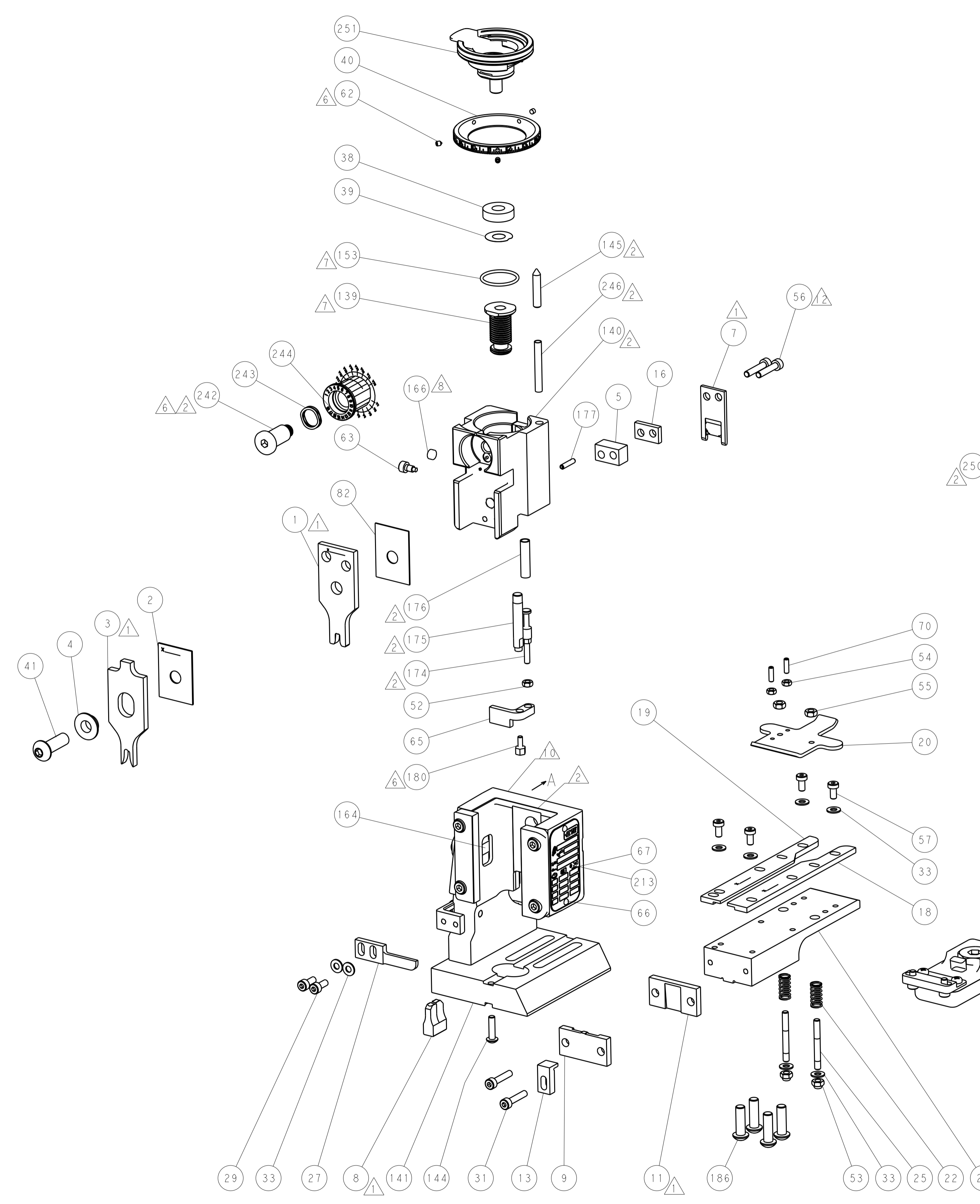
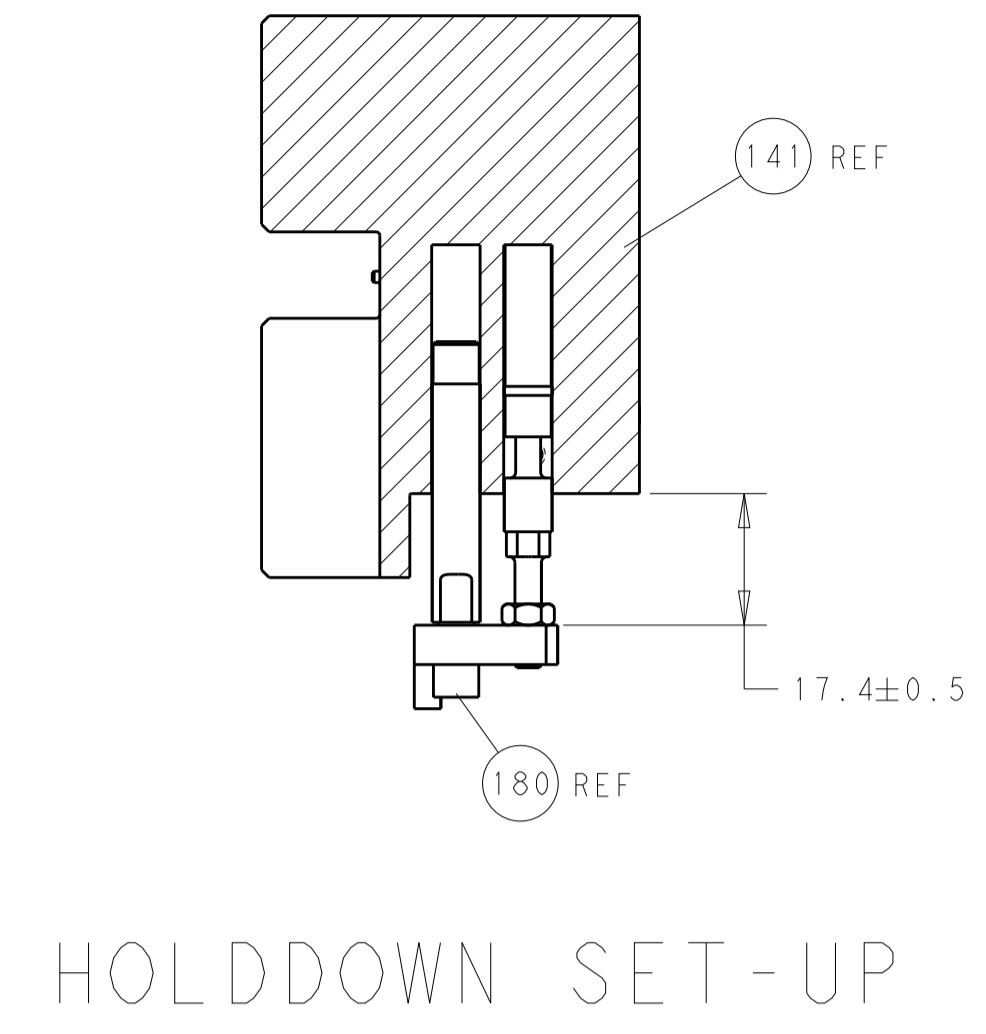


AIR FEED

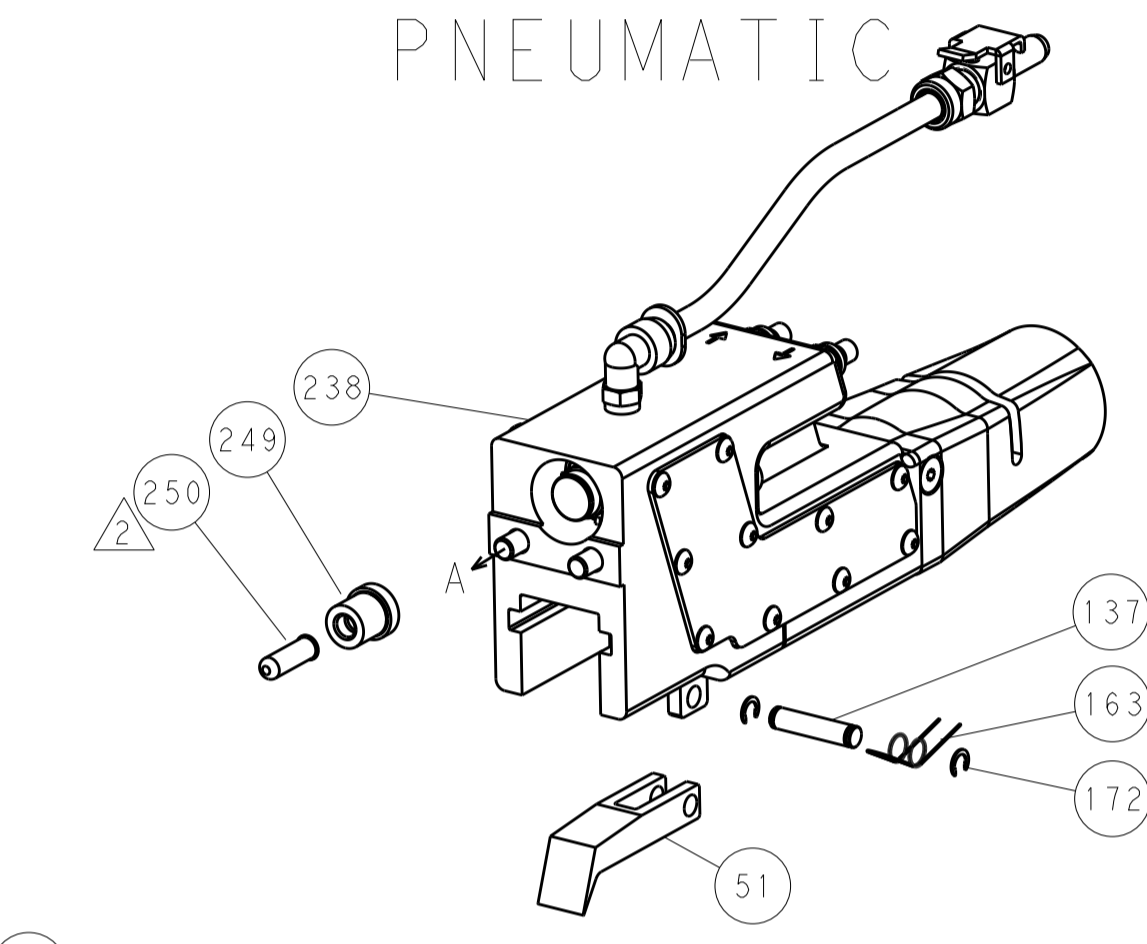
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X.ZHAO 17OCT2014		TE Connectivity	
mm	0 PLC	±		CHK: L.ZHANG 17OCT2014	NAME: Ocean End Feed Applicator		TE Connectivity Harrisburg, PA 17105-3608
	1 PLC	±		APVD: J.FLRIN 17OCT2014	RESTRICTED TO:		
	2 PLC	±		PRODUCT SPEC			
	3 PLC	±		APPLICATION SPEC			
	4 PLC	±		WEIGHT			
	ANGLES	±		SCALE			
MATERIAL:	FINISH:			A1 00779 ©=2150162		SHEET 2 OF 4 REV B	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 2 OF 4 REV B	

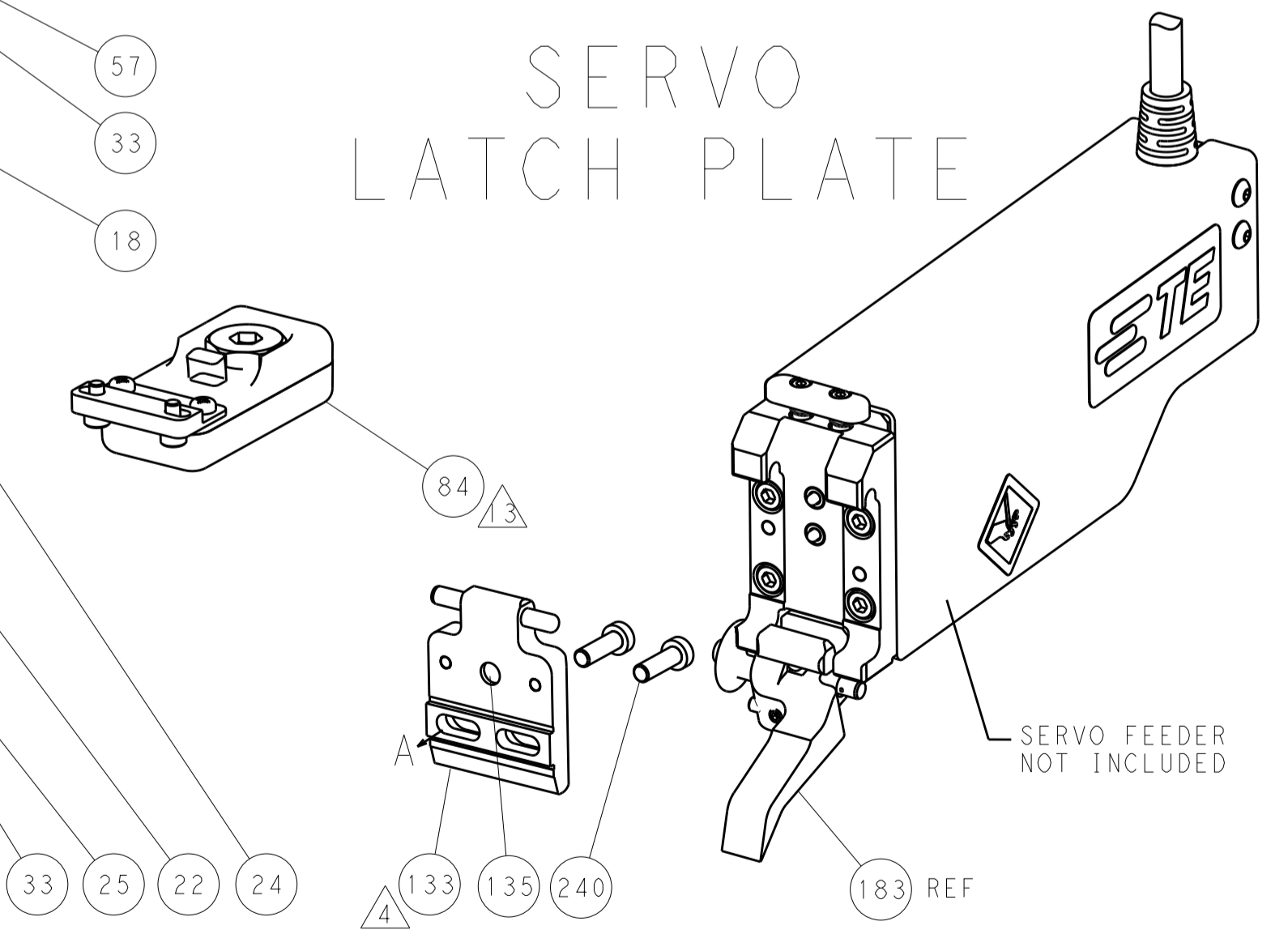
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



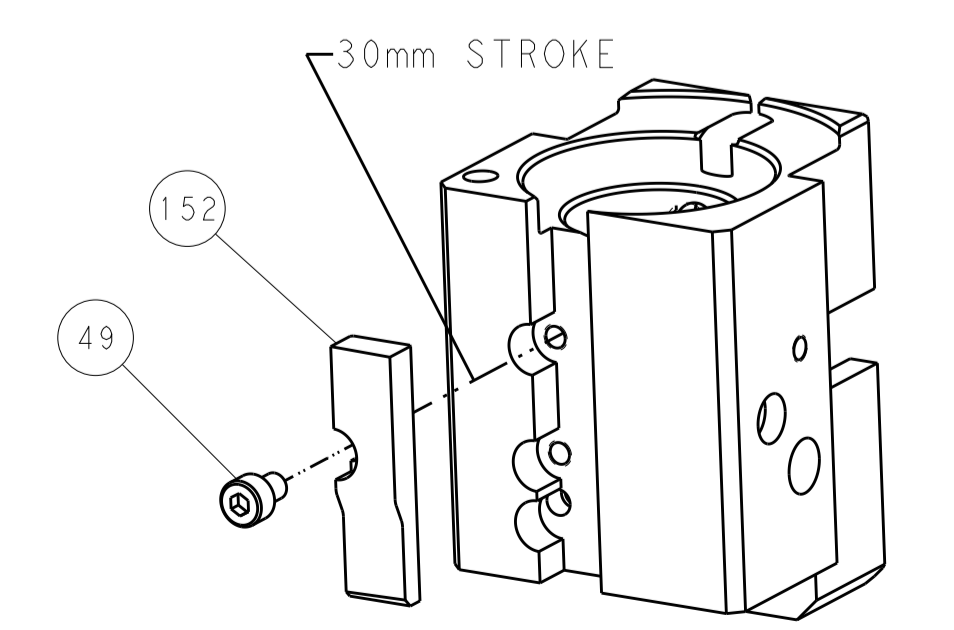
FEED TYPE
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITION



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:		DWN X. ZHAO 17OCT2014		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK L. ZHANG 17OCT2014	NAME Ocean End Feed Applier		
	3 PLC ±	4 PLC ±	ANGLES ±	APVD J. ELERN 17OCT2014	SIZE CAGE CODE DRAWING NO RESTRICTED TO		
MATERIAL	FINISH	WEIGHT	Customer Accessible Production Drawing	A1 00779 C=2150162		SCALE 1:1 SHEET 4 OF 4 REV B	