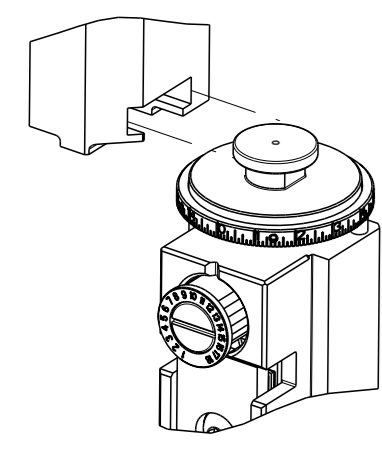


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150368-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150368-5	-	-	2168400-7 (QUANTITY 2)
	2150368-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	SMART APPLICATOR	2161326-1	-	8-2150368-4	-	-	-
	2150368-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>12</sup>	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-2
	2150368-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150368-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, 3.18[.125] DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.84-6.60 mm [.230-.260 IN]		∅3.05-4.32 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED <sup>10</sup> / <sub>15</sub>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217175-1	1217175-4	1217175-5	62243-3
62243-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>
10 AWG OR 5.20mm2	2.97+/-0.05 [.117+/- .002]	3.0
12 AWG OR 3.30mm2	2.54+/-0.05 [.100+/- .002]	7.6
14 AWG OR 2.00mm2	2.24+/-0.05 [.088+/- .002]	10.5

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150368-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150368-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150368-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> 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.
- <sup>12</sup> 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
- <sup>13</sup> FEED TERMINALS FROM RECEPTACLE END.
- <sup>14</sup> SET ITEM 16 TO DIMENSION SHOWN.
- <sup>15</sup> TERMINAL LUBRICANT IS RECOMMENDED.

<sup>6</sup> ITEM 27 MUST BE POSITIONED CLOSE ITEM 16 TO PROPERLY STRIP TERMINAL

-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	270	
-	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)

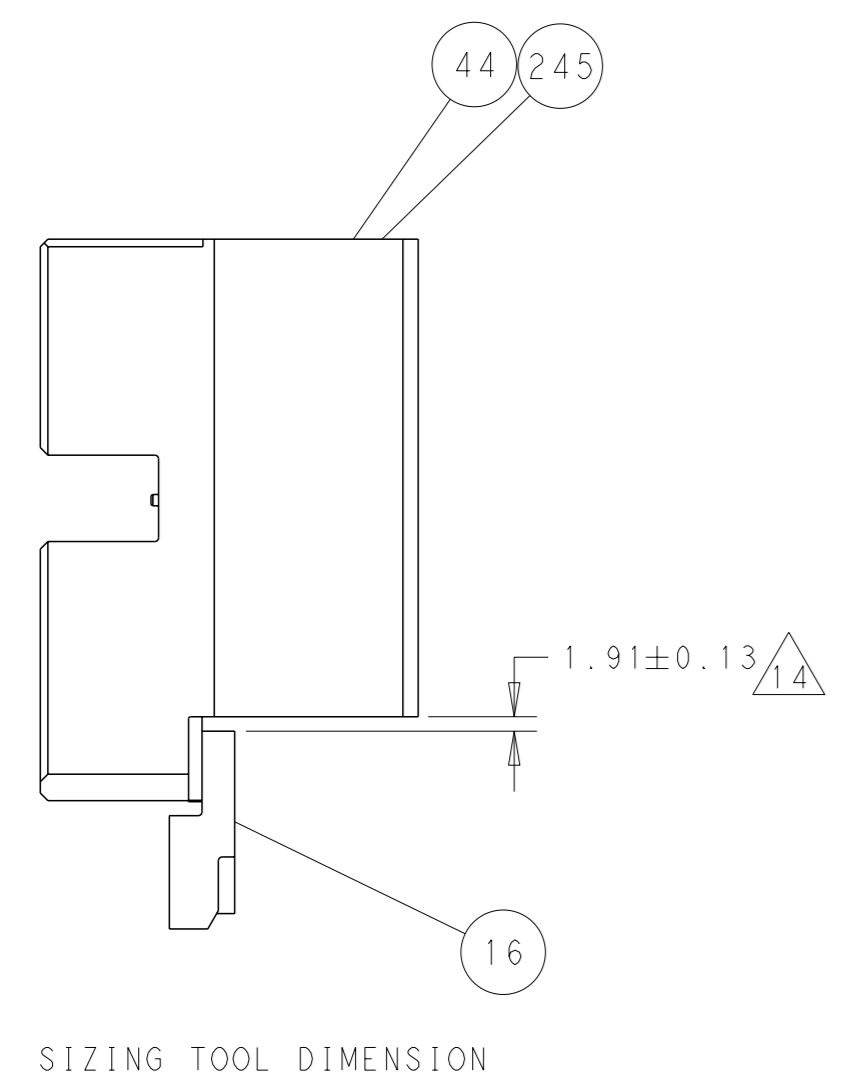
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SET UP GAUGE	LOC	DIST		
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REV	DESCRIPTION	DATE	OWN	APVD
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B	ECR-14-016019	03NOV2014	JH	TE
C	ECR-16-012215	25AUG2016	JH	CT

-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260	
-	-	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	2119798-1	DETENT PIN	247	
-	-	1	-	1	1-22279-3	SPRING, COMPRESSION	246	
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245	
-	-	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	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
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
-	-	-	-	-	REFREFREFREF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163	
-	1	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140	
-	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	-	-	-	REFREF	-	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-7	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-9	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	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	
-	3	3	3	3	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	2119792-2	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	2119369-1	RAM, AMP STYLE, END FEED	44	
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	-	-	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	-	-	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1	1	2119644-3	RAM WASHER, PRECISION	38	
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
-	1	-	-	1	2119092-1	BOLT, ADJUSTMENT	35	
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-	1	1	1	1	240639-4	STRIPPER (MACHINING)	27	
-	2	2	2	2	1320906-1	STUD, THREADED	25	
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1752373-4	DRAG	20	
-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	217573-1	TOOL, SIZING	16	
-	1	1	1	1	5-240641-8	SPACER	15	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9	
-	1	1	1	1	1633387-4	ANVIL, COMBINATION	8	
-	1	1	1	1	5-690474-4	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	4-240641-2	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	1	1	1	4-1633962-0	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	2-455888-1	SPACER, CRIMPER	2	
-	1	1	1	1	1-456425-0	CRIMPER, WIRE .140 F PREMIUM	1	
-	77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

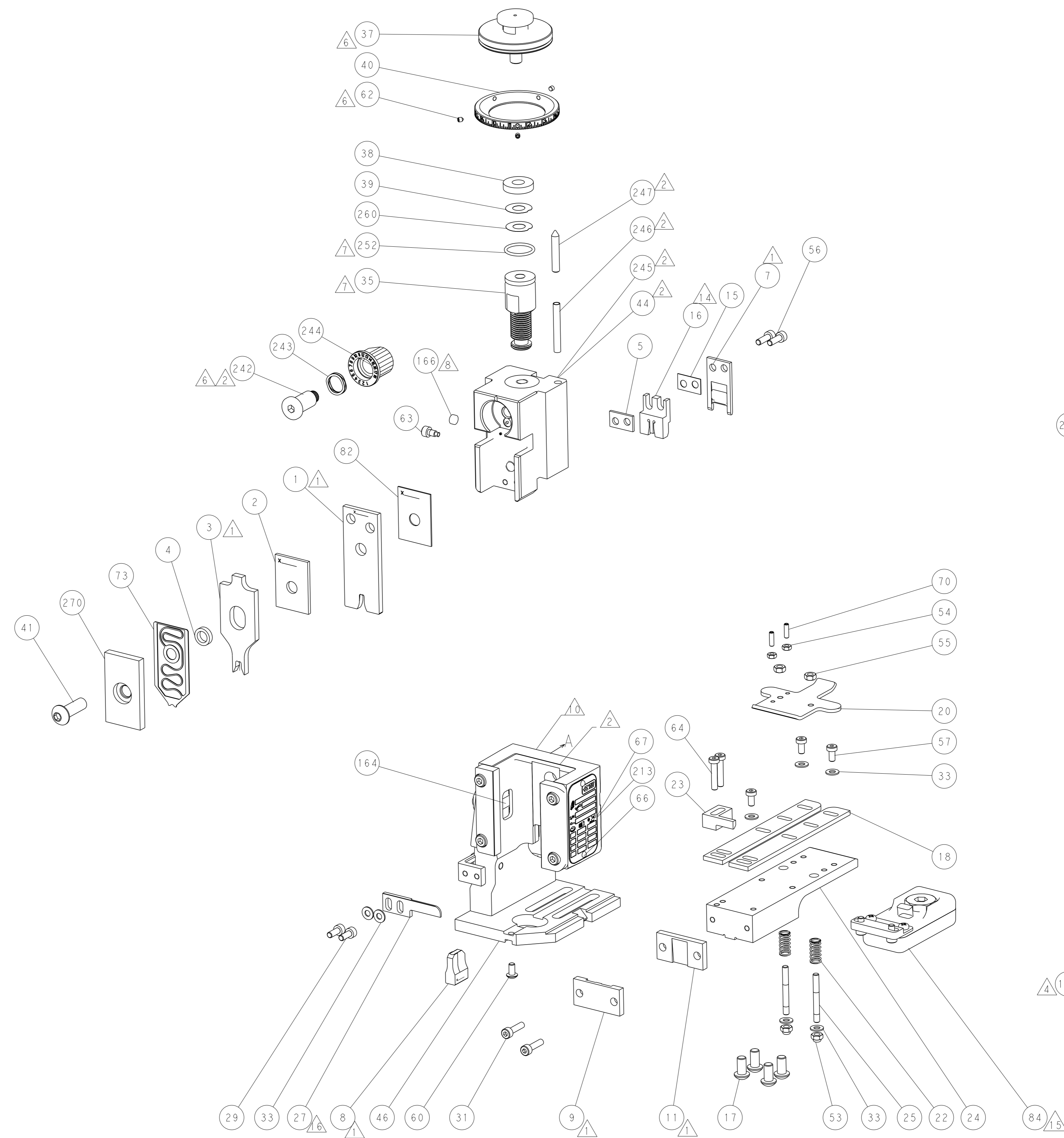
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH		MATERIAL	
STANDARD		CUSTOMER DRAWING		SCALE 1:1 SHEET 1 OF 4 REV C	

TE Connectivity	
Harrisburg, PA 17105-3608	
Ocean End Feed Applicator	
SIZE	CAGE CODE DRAWING NO
A1	00779 ©=2150368

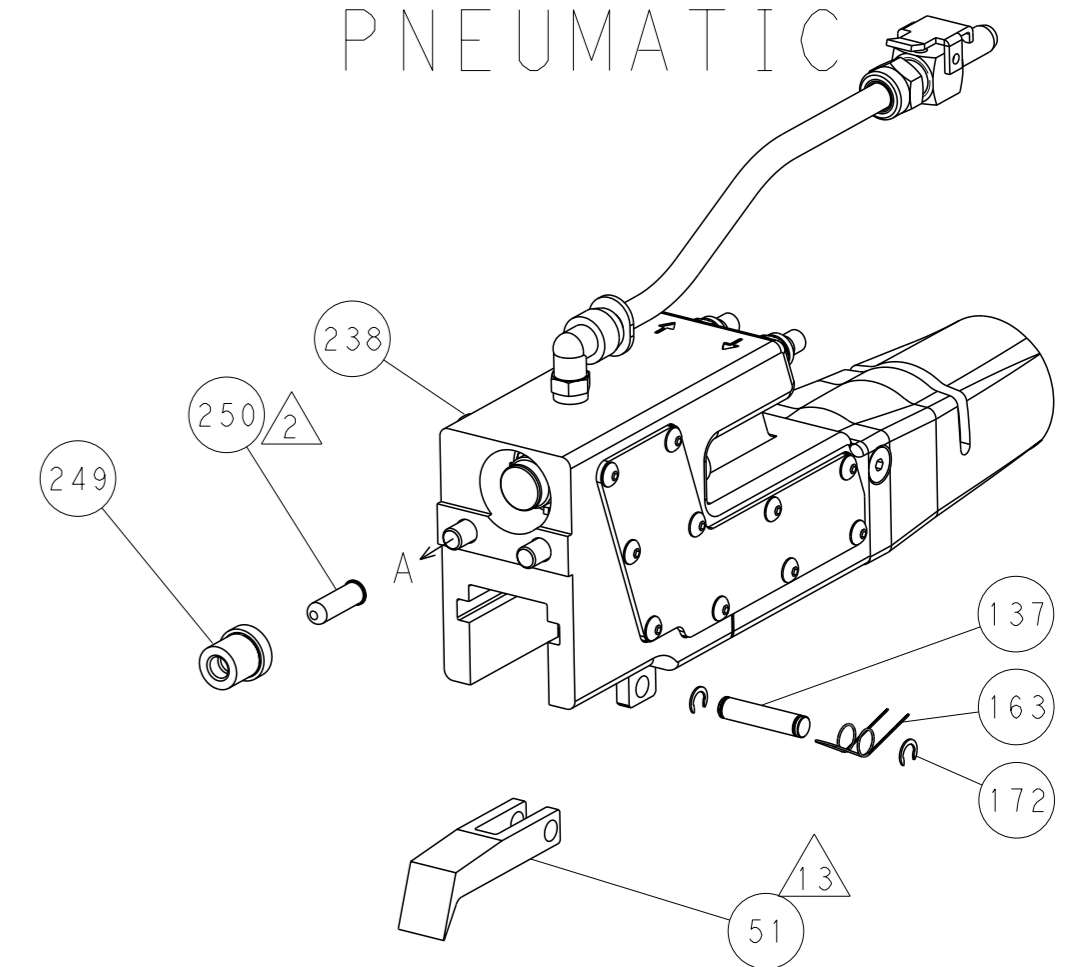
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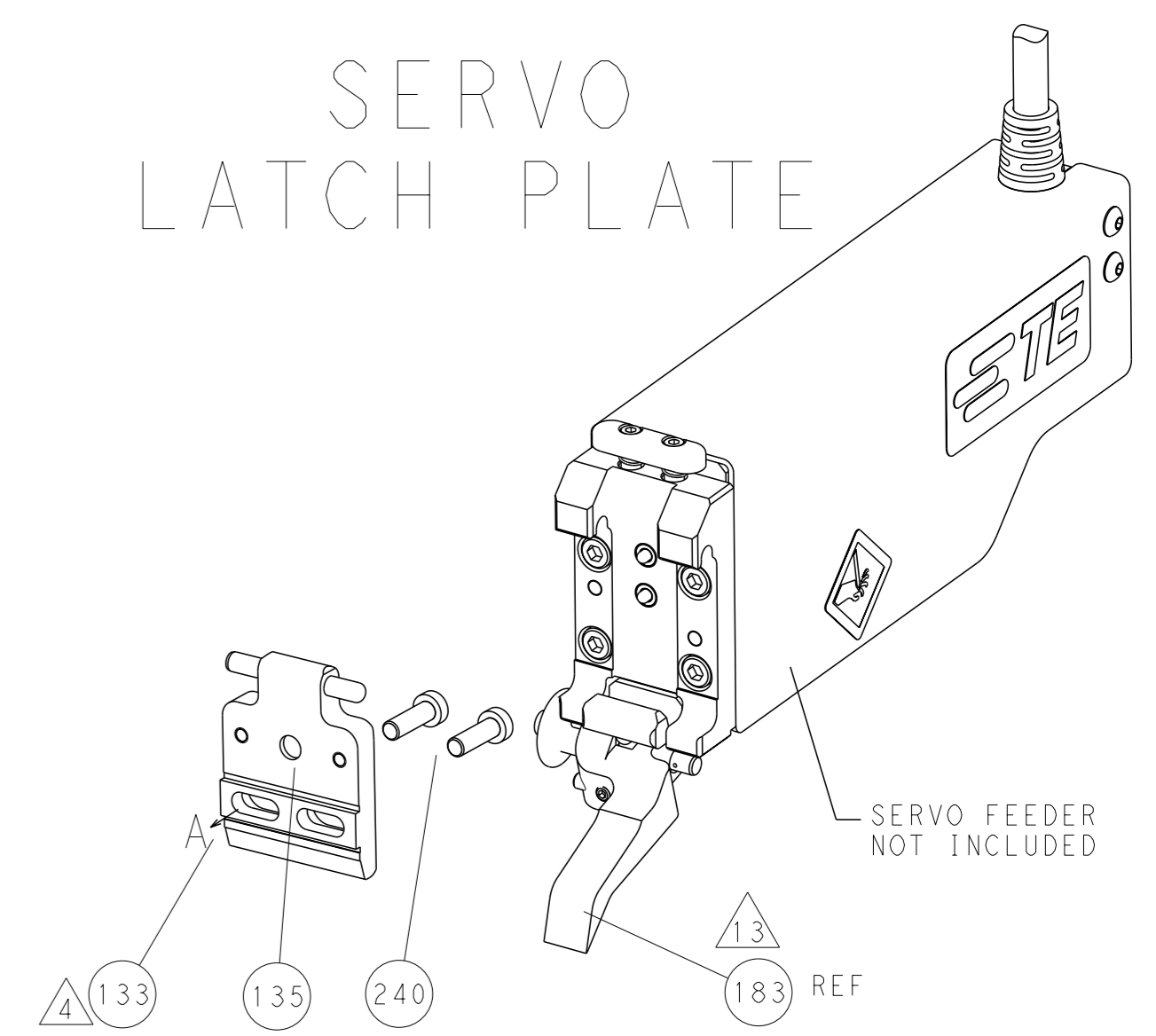
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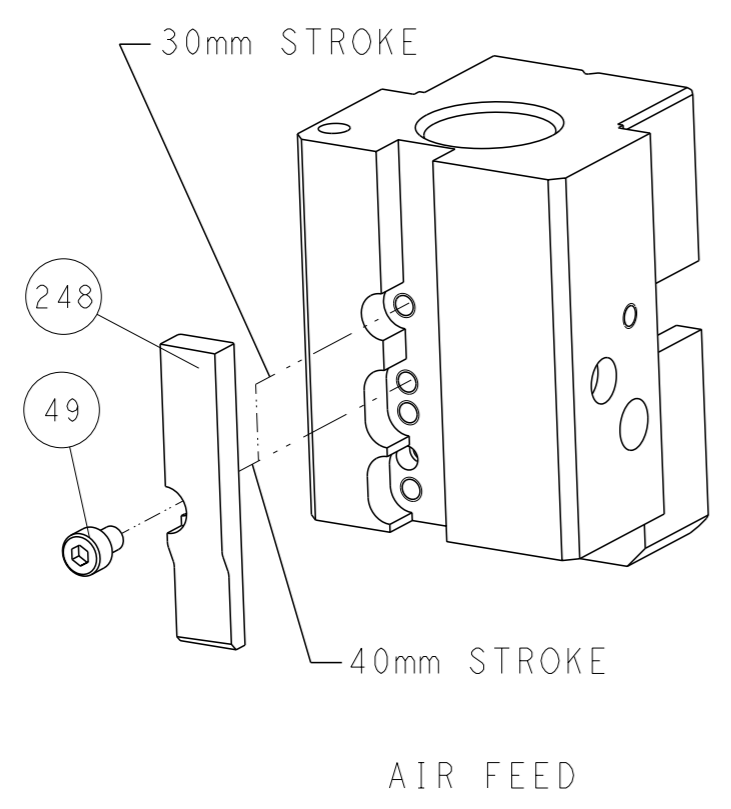
FEED TYPE  
PNEUMATIC



SERVO  
LATCH PLATE



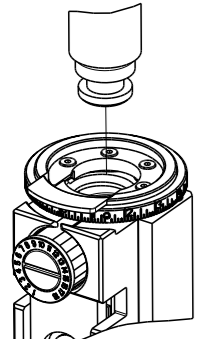

CAM POSITION




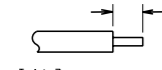


AIR FEED

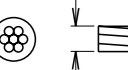


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)













<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. 20                  COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: R. KNEPPER 26-Sep-13 CHK: G. BAILEY 26-Sep-13 APVD: M. CLIFFORD 26-Sep-13	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH *	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150368	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: C
MATERIAL: - FINISH: -		WEIGHT: - CUSTOMER DRAWING: -	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150368-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	
	2-2150368-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150368-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150368-4	-	-	-
	2-2150368-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
	7-2150368-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, 3.18[.125] DIA			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE	
5.84-6.60 mm [.230-.260 IN]		∅ 4.32 mm [.170 IN] MAX	
TERMINAL APPLICATION SPECIFICATION 	114-2019	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217175-1	1217175-4	1217175-5	62243-3
62243-5			

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 
10 AWG OR 5.20mm2	2.97 +/- 0.05 [ .117 +/- .002 ]	3.0
12 AWG OR 3.30mm2	2.54 +/- 0.05 [ .100 +/- .002 ]	7.6
14 AWG OR 2.00mm2	2.24 +/- 0.05 [ .088 +/- .002 ]	10.5















-  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: 8-2150368-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150368-5
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
-  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.
-  FEED TERMINALS FROM RECEPTACLE END.
-  SET ITEM 16 TO DIMENSION SHOWN.
-  TERMINAL LUBRICANT IS RECOMMENDED.


 ITEM 27 MUST BE POSITIONED CLOSE ITEM 16 TO PROPERLY STRIP TERMINAL

**\*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.

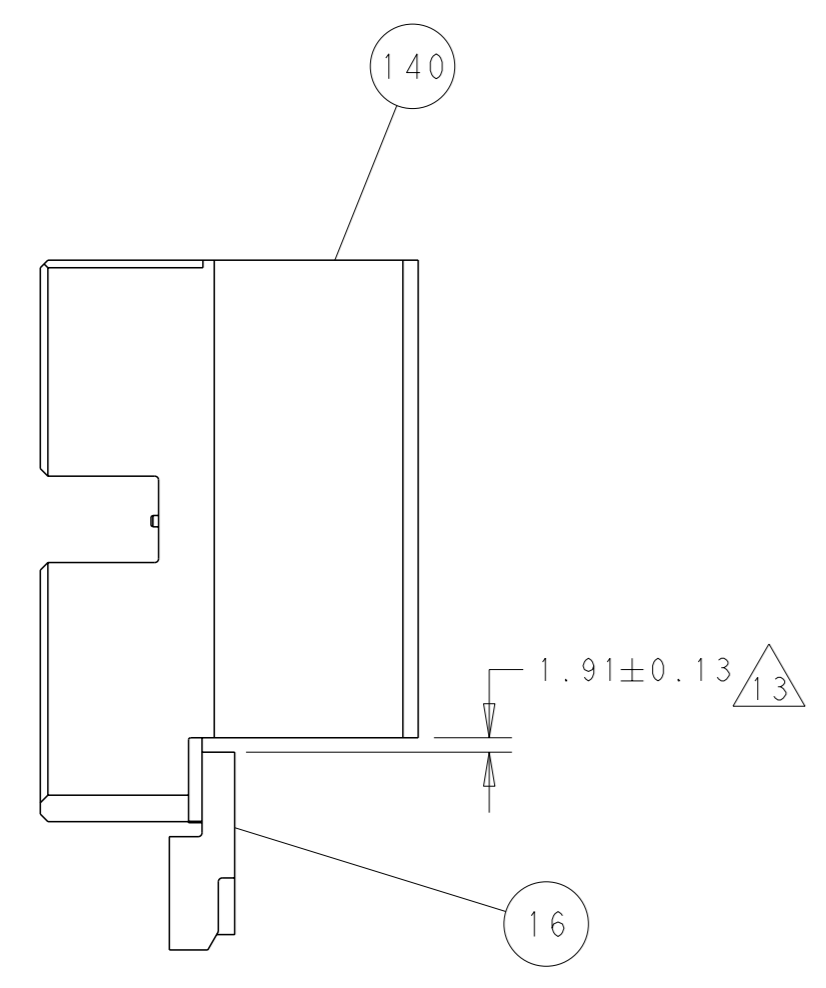
**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LT#	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

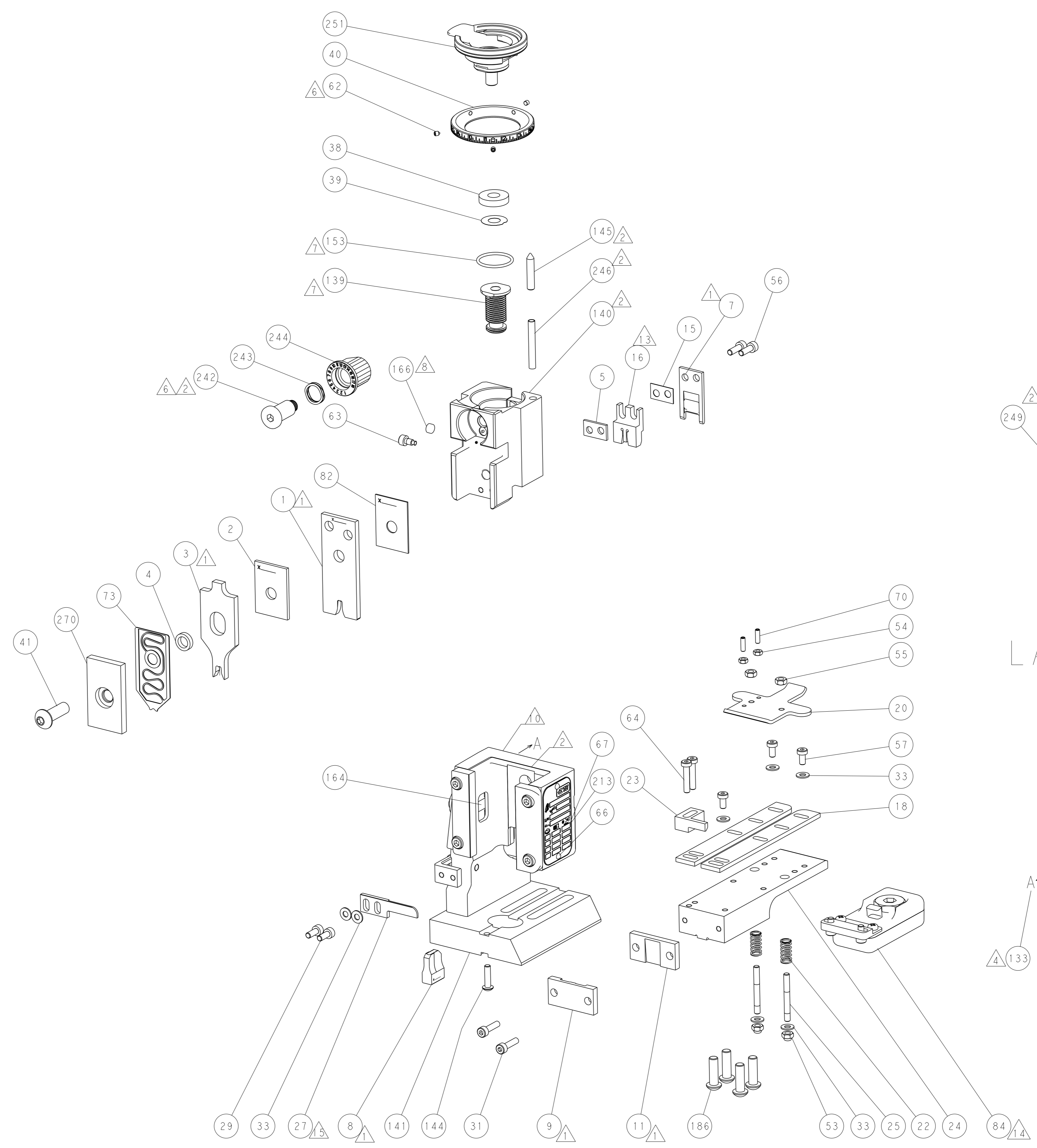
-	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	270
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	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
-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
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-	77	27	25	22	PART NO	
-					DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	R. KNEPPER	26-Sep-13		TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	±	±	CHK	G. BAILEY	26-Sep-13		
MATERIAL:		FINISH:		APVD	M. CLIFFORD	26-Sep-13	NAME Ocean End Feed Applicator	
CUSTOMER DRAWING				SCALE	1:1	SHEET	3	OF 4
				REV	C			

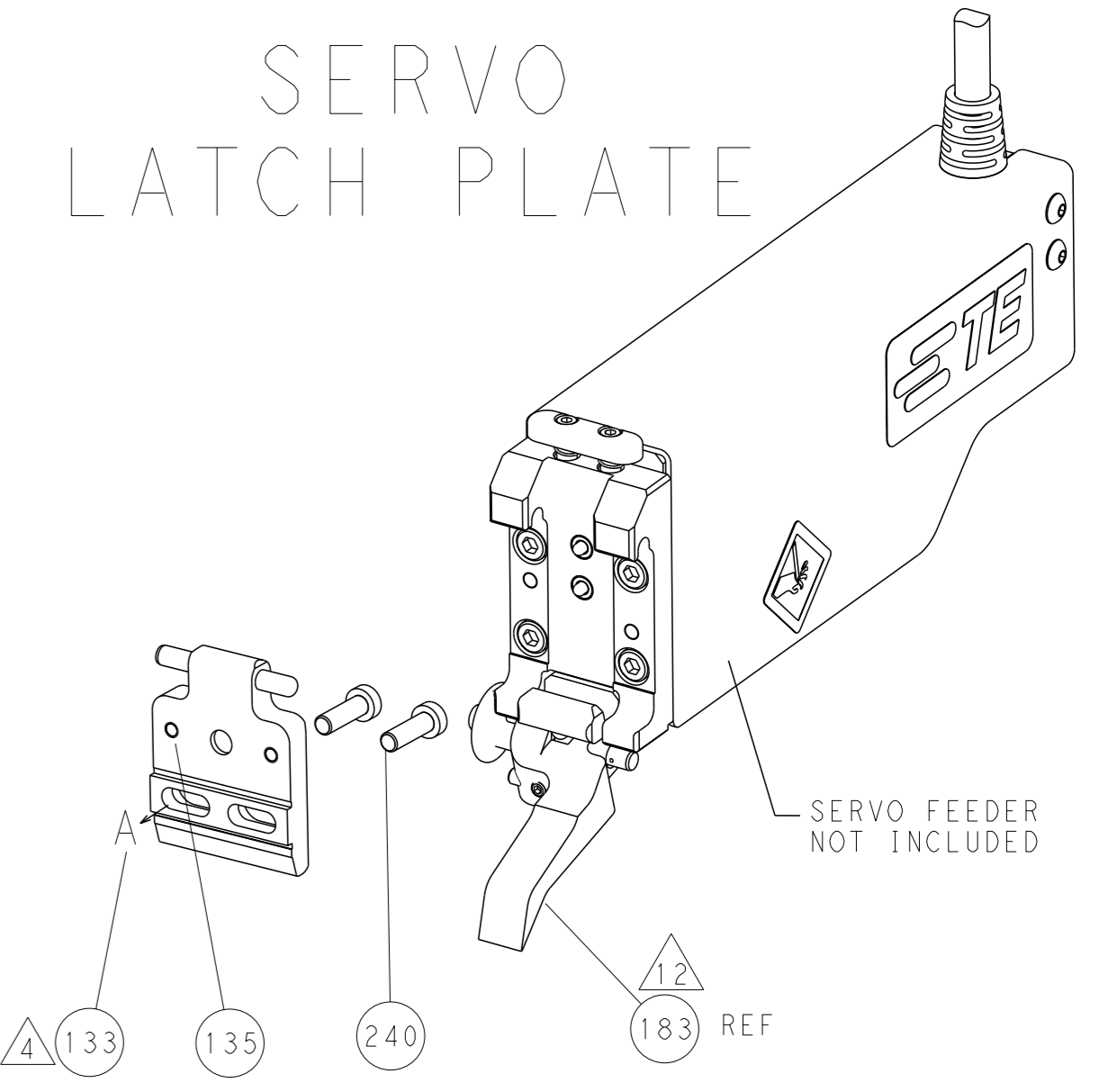
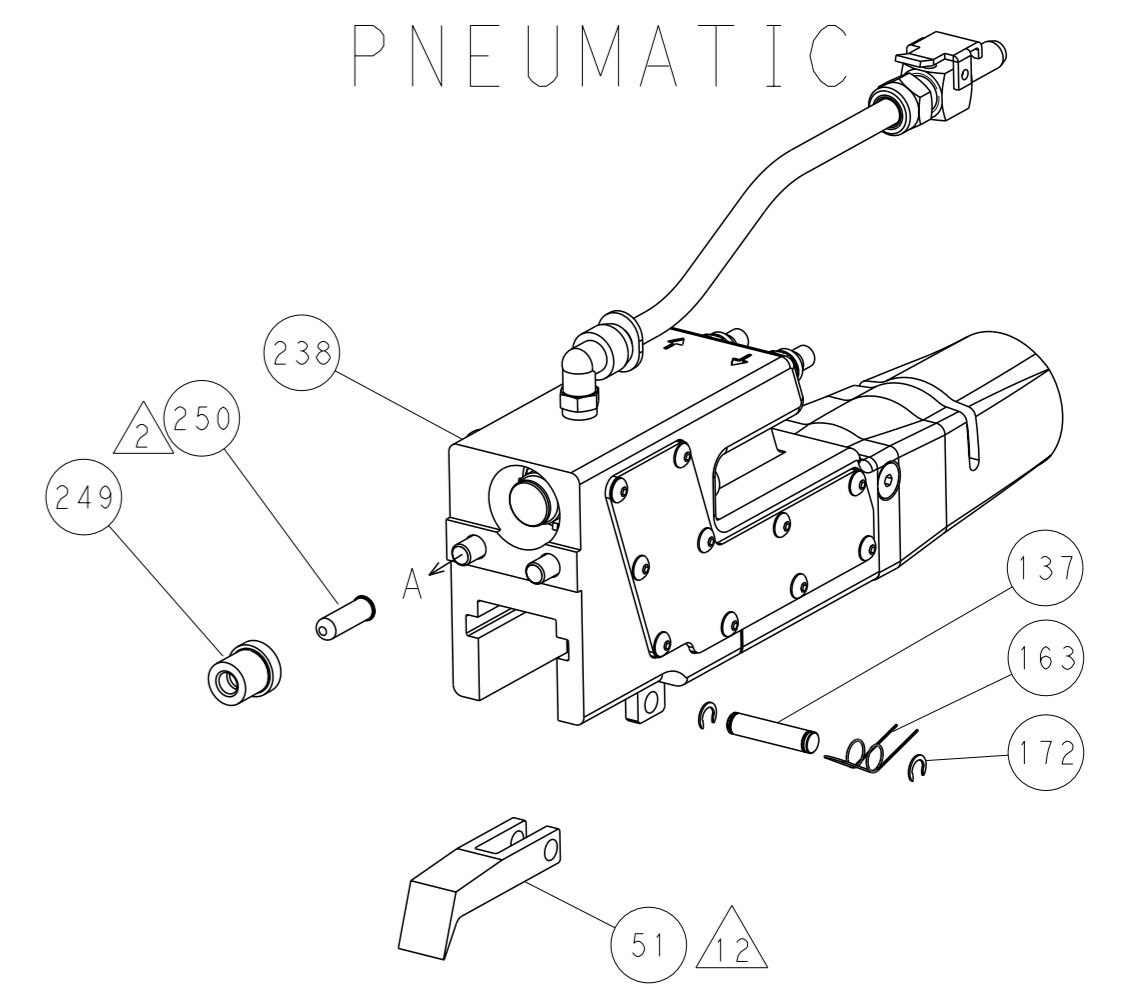
REVISONS		DATE	OWN	APVD
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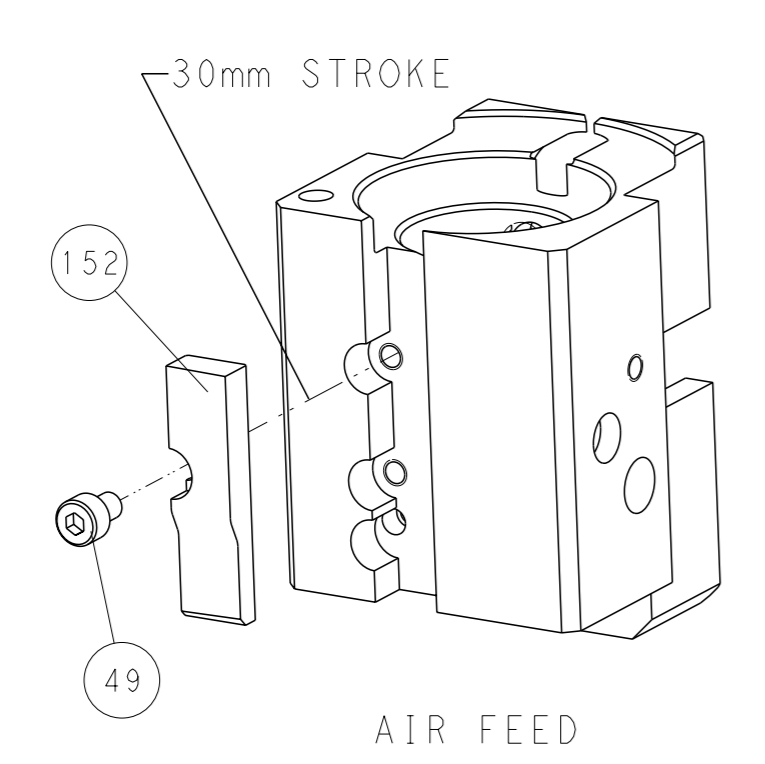
SIZING TOOL DIMENSION



FEED TYPE  
PNEUMATIC



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH *		OWN R. KNEPPER 26-Sep-13 CHK G. BAILEY 26-Sep-13 APVD M. CLIFFORD 26-Sep-13 PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER DRAWING		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150368 SCALE 1:1 SHEET 4 OF 4 REV C	
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