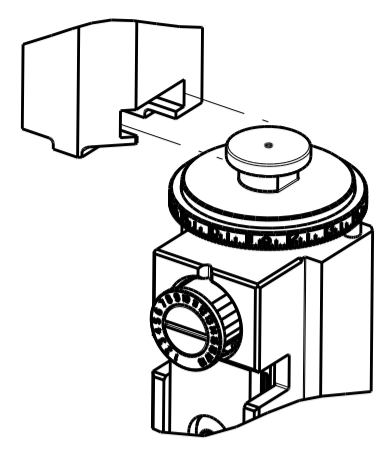

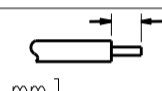


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150282-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	2063961-1	-	-	-	-
	2150282-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150282-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150282-4	-	-	-
	2150282-6	B	NON-CRIMP HEIGHT ADJUST ⁴	SERVO LATCH PLATE ⁴	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-2
					-	-	-	-	-	-	-
	2150282-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150282-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	O

APPLICATOR INSTRUCTIONS 
408-10390

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.204-.234 IN [5.18-5.94 mm]		Ø.070-.100 IN [1.78-2.54 mm]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED ⁴			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41711	41013	140517	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
18 AWG OR 0.75mm2	1.96 +/- 0.05 [.077 +/- .002]	8.7
20 AWG OR 0.50mm2	1.88 +/- 0.05 [.074 +/- .002]	9.5
22 AWG OR 0.35mm2	1.83 +/- 0.05 [.072 +/- .002]	10.0

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150282-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150282-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150282-6
- 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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ¹¹ 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
- ¹² CUT TO LENGTH AT ASSEMBLY.

***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
-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)

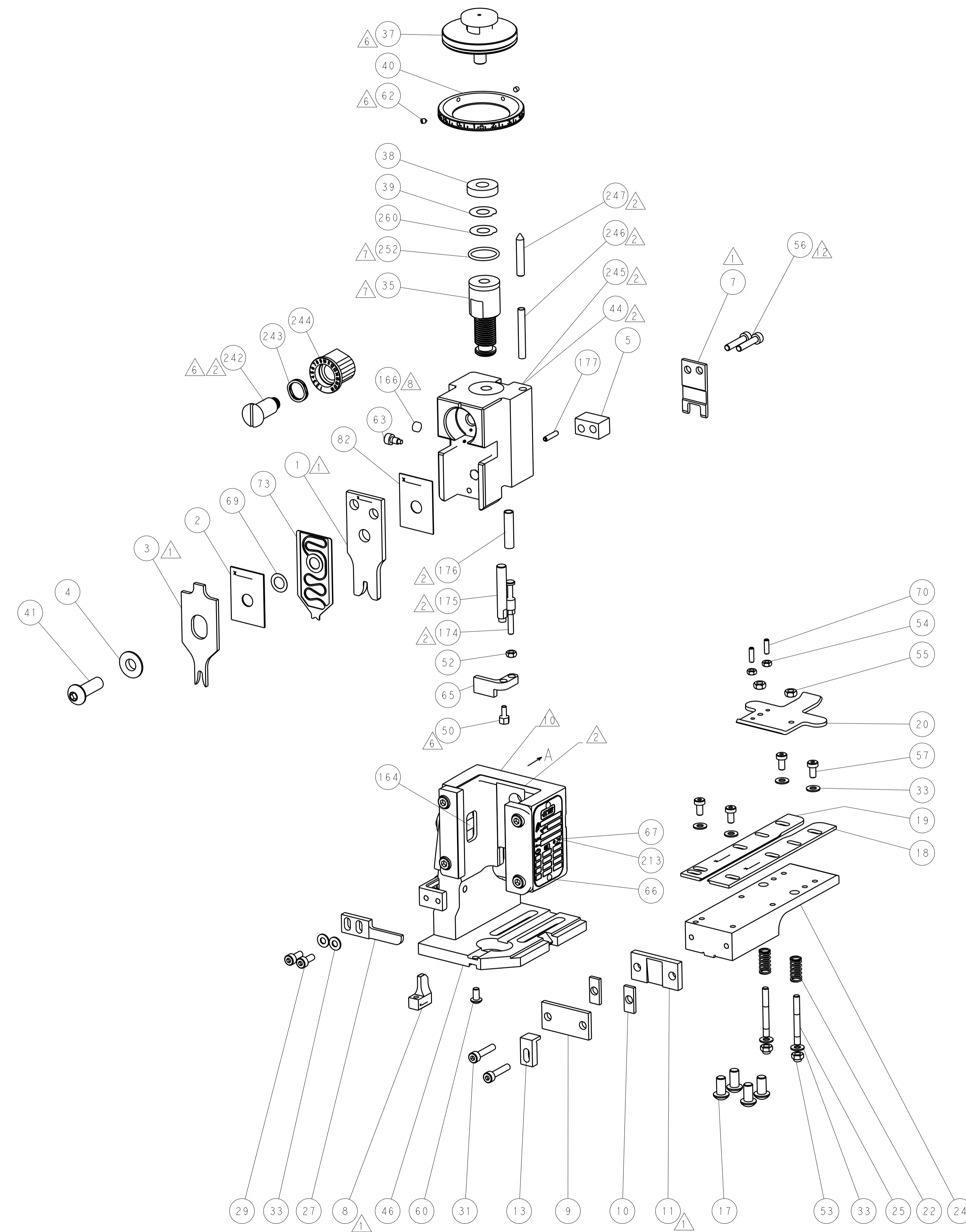
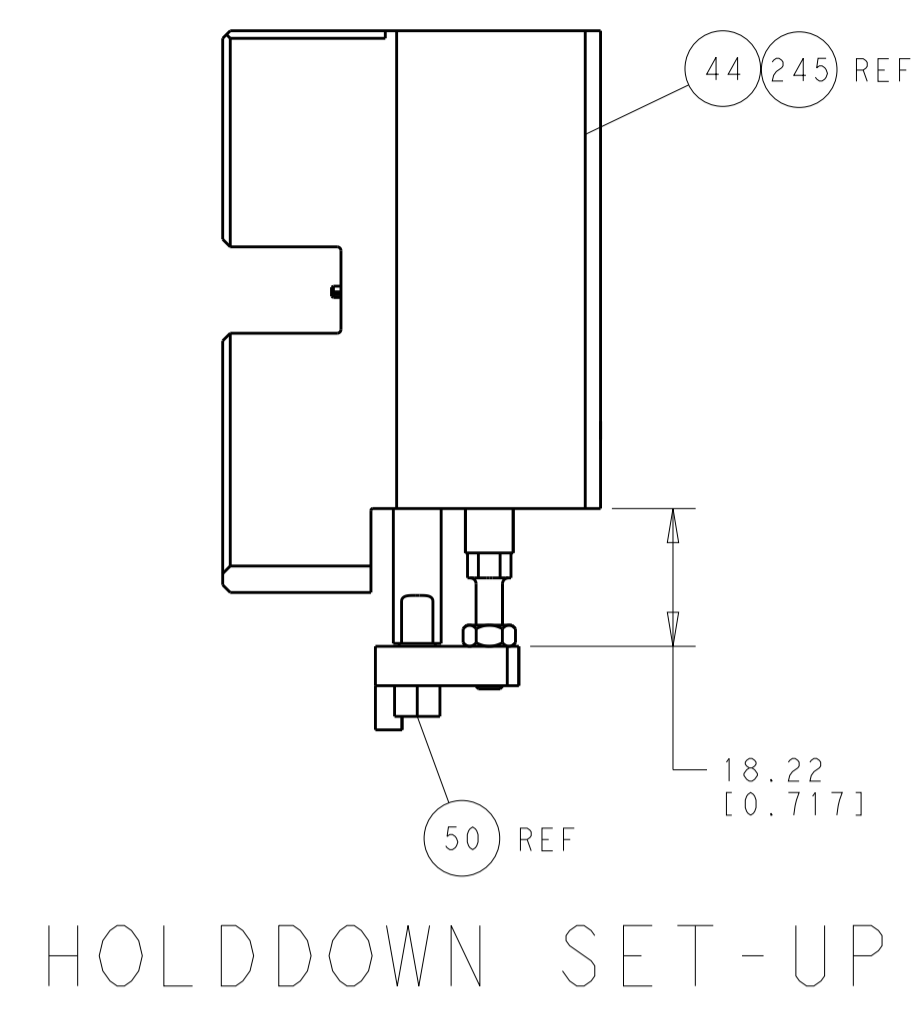
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			A		RELEASED	04OCT2012	LG	TE
			B		REVISED ECR-13-013665	29AUG2013	CC	GB

-	-	-	-	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	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
-	-	-	-	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	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	-	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	455888-4	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	1901681-1	HOLDDOWN, TERMINAL	65
-	1	-	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	2	-	-	2	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	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	1	1	1	1752354-1	STANDOFF, HOLD-DOWN	50
-	-	-	-	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	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	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	1752373-1	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	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-0	SPACER, SHEAR PLATE	10
-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
-	1	1	1	1	2-1333219-1	ANVIL, COMBINATION	8
-	1	1	1	1	1-240651-6	BLADE, SLUG	7
-	1	1	1	1	2-240641-6	SPACER	5
-	1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1803018-8	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	1	1	1-456408-8	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5
	ANGLES ±.0001				
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SHEET:	REV:
			1:1	1 OF 4	B

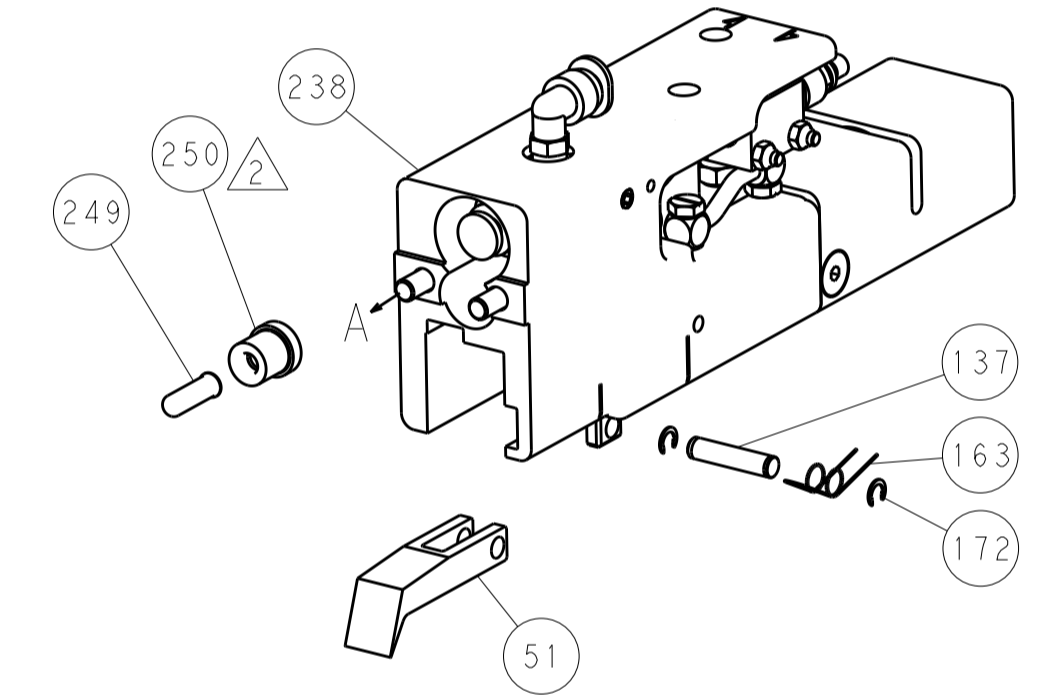
Customer Accessible Production Drawing

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
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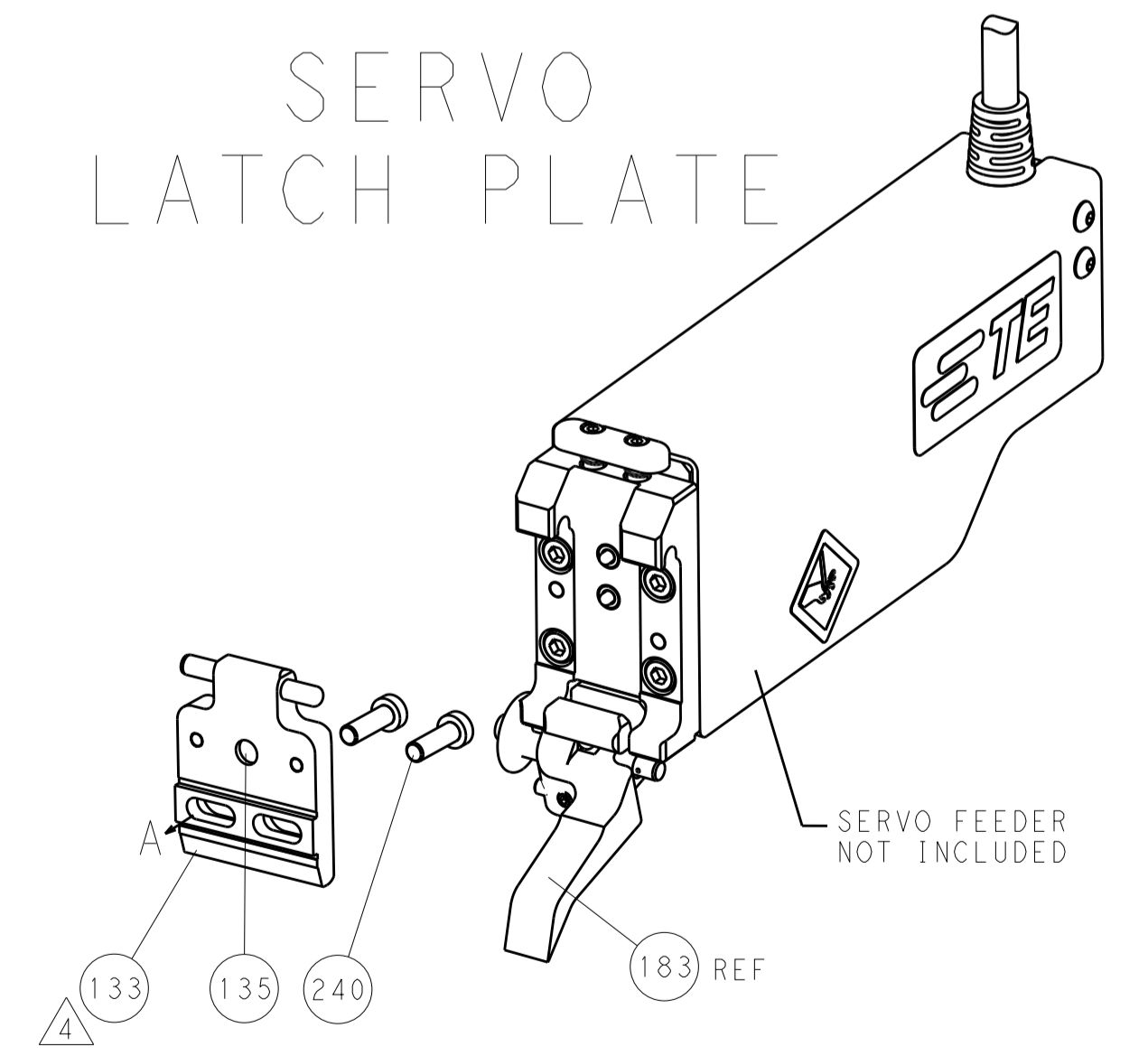


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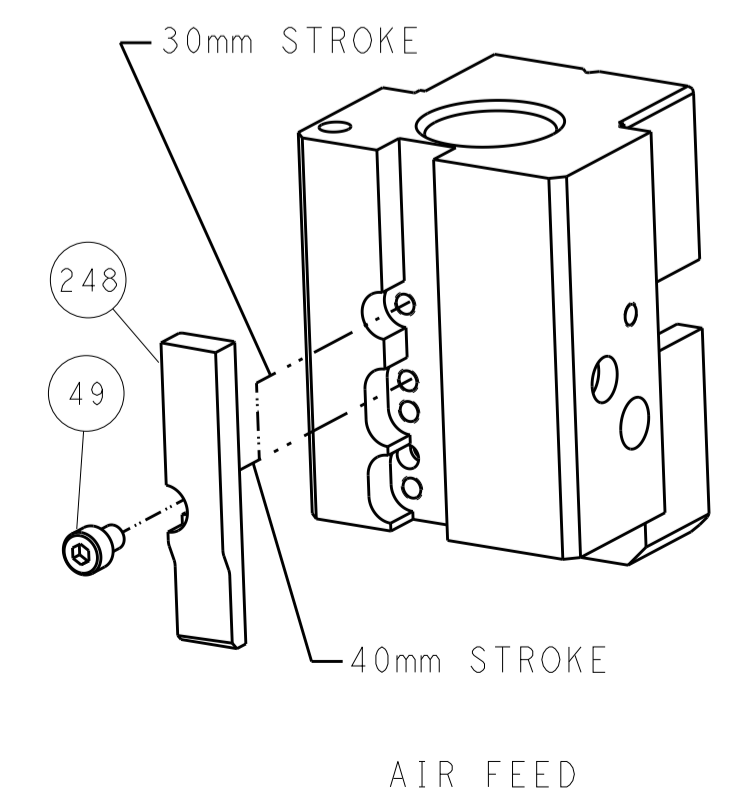
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION

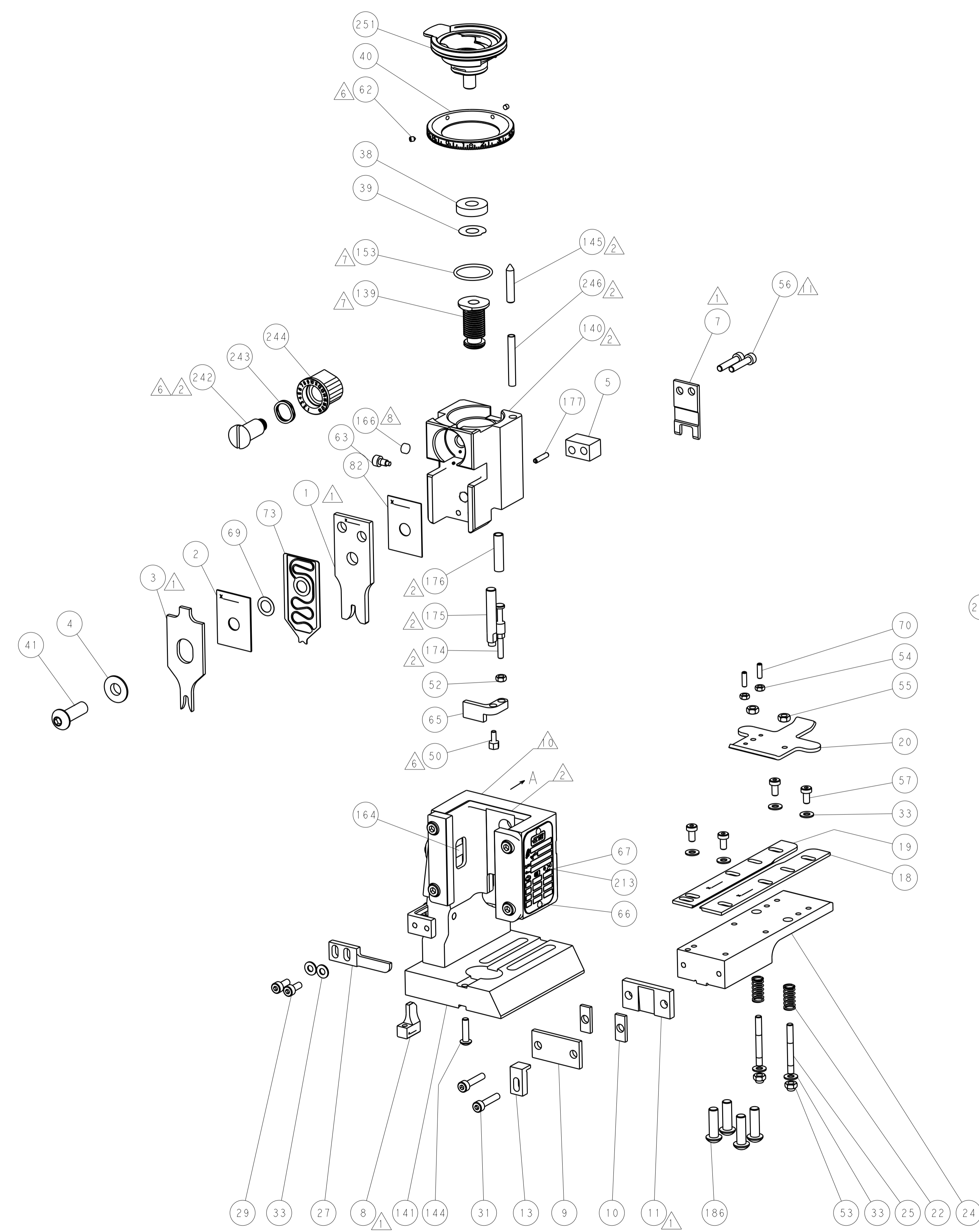
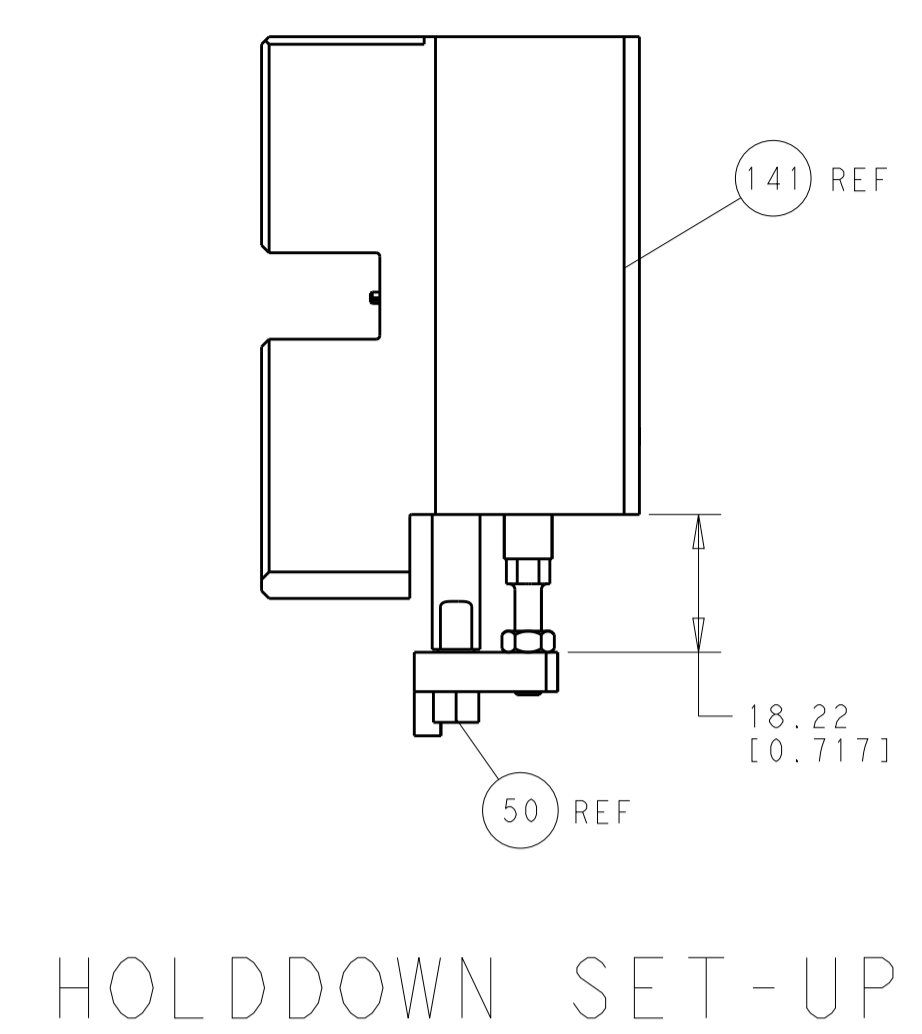


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: K. STAKEM 21AUG2012		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.13	2 PLC ±0.013	3 PLC ±0.001	4 PLC ±0.0001	CHK: G. BAILEY 21AUG2012	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: T. ELBIN 21AUG2012		NAME: Ocean End Feed Applicator	
-		-		WEIGHT: -		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150282	
-		-		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV B	

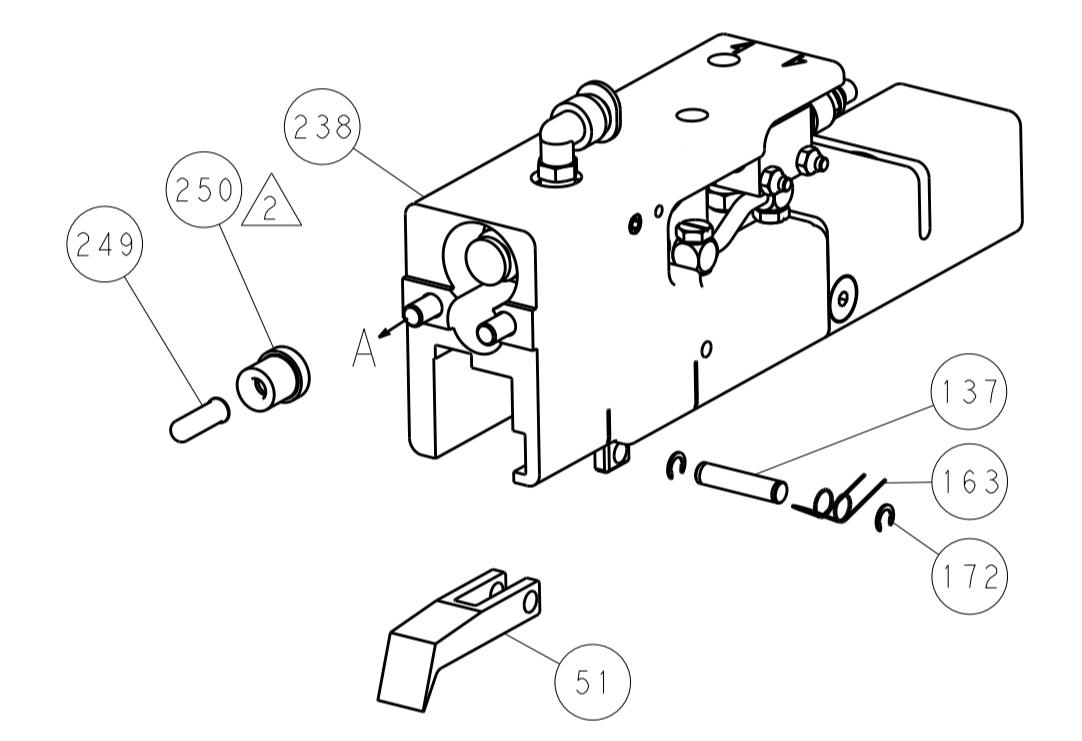
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS			
REV	DATE	BY	APPV
-	-	-	-
-	-	-	-

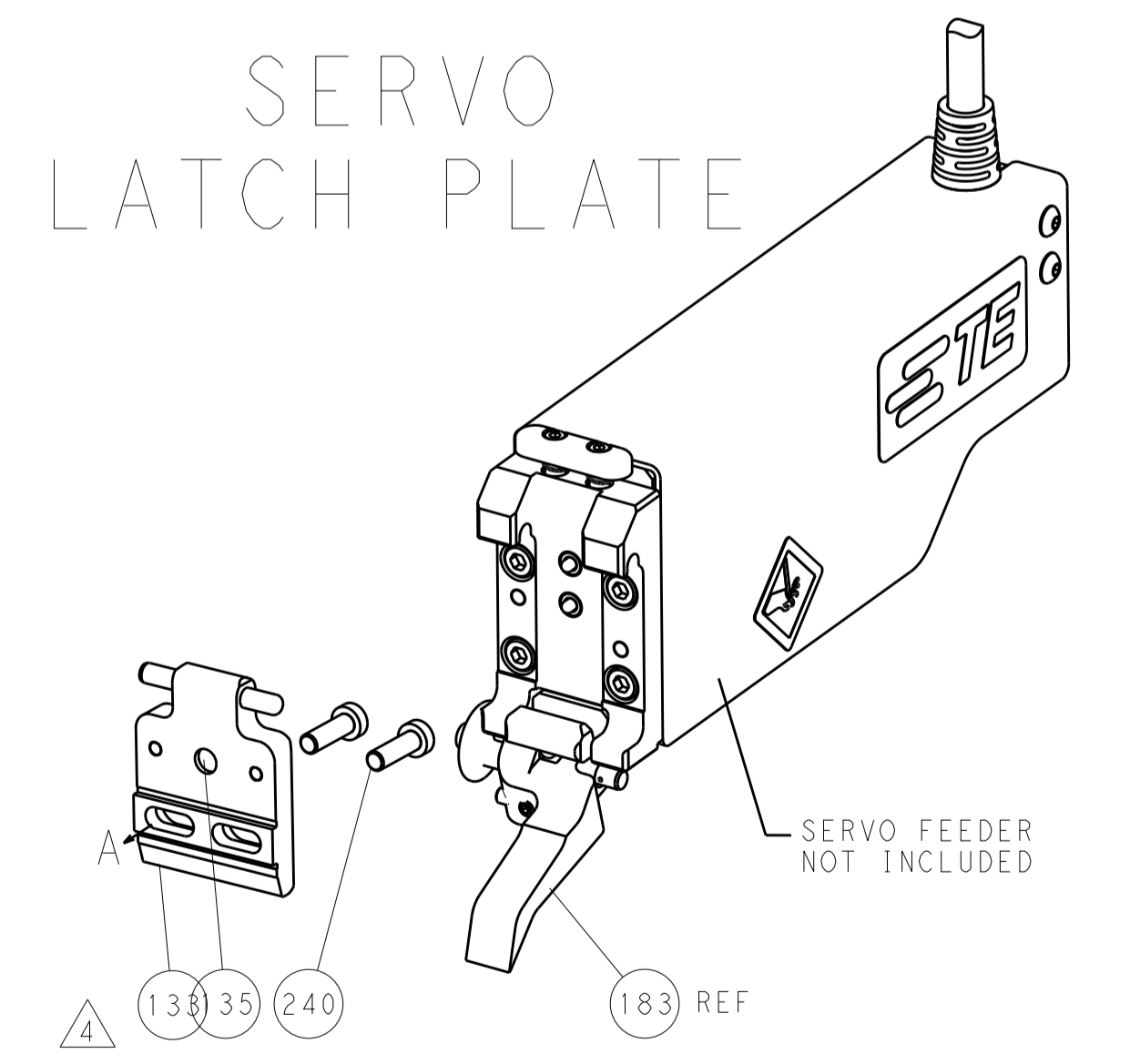


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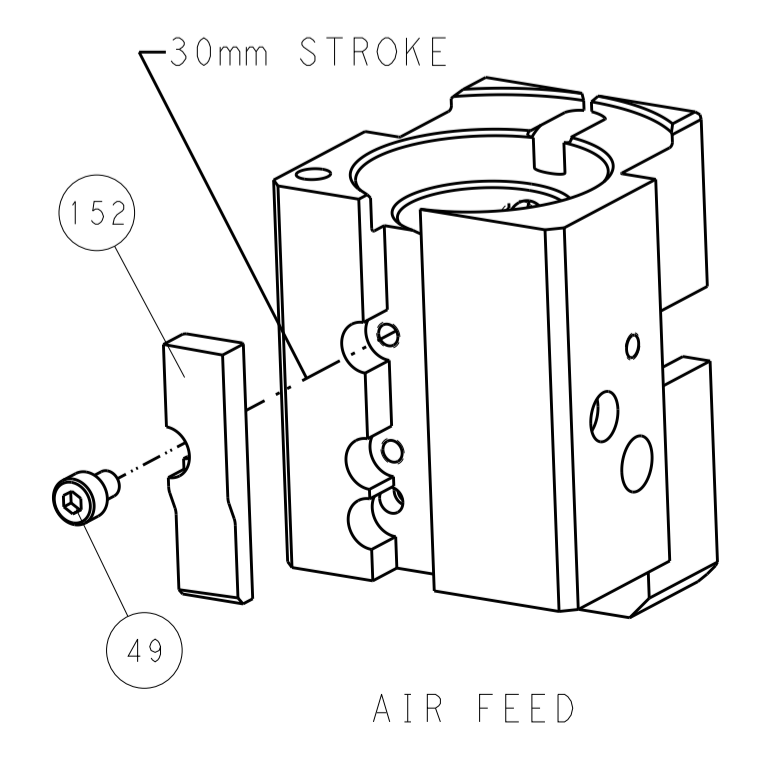
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF MERCHANTABILITY. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: STAKEM 21AUG2012 CHK: G. BAILEY 21AUG2012 APVD: T. ELBIN 21AUG2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.5 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1		NAME: Ocean End Feed Applier PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150282 SHEET 4 OF 4 REV B
MATERIAL: FINISH:		RESTRICTED TO:	