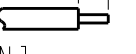


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						-	-	-	-	-	-
	2150394-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1803052-1	8-2150394-5	-	-	2168400-7 (QUANTITY 2)
	2150394-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SMART APPLICATOR	2161326-1	-	8-2150394-4	-	-	-
	2150394-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-2
	2150394-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150394-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.84 mm [.112]	F
INSUL	3.94 mm [.155]	OV
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: G&H TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: FLACHSTECKER 6.3X0.8-2.5			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.50-5.50 mm [.217-.217 IN]			Ø2.20-2.80 mm [.087-.110 IN]
TERMINAL APPLICATION SPECIFICATION		25696 Rev 7	- -
		-	-
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572634-1	25696.213.009	1572634-6	25696.126.113
1572634-2	25696.213.111	1572634-7	25696.126.141
1572634-3	25696.213.141	1572634-8	25696.126.142
1572634-4	25696.213.178	1572634-9	25696.126.143
1572634-5	25696.126.009	1-1572634-0	25696.126.178

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
2.50mm2		1.90+/-0.05 [.075+/- .002]		4.5
2X 1.00mm2		1.80+/-0.05 [.071+/- .002]		5.4
1.00 + 0.75mm2		1.70+/-0.05 [.067+/- .002]		6.5
1.50mm2		1.60+/-0.05 [.063+/- .002]		8.0



- 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: 8-2150394-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150394-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150394-6
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 62, 180 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 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

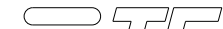
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	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 2119599-2	LOC A	DIST 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	OWN	APVD
				A	RELEASED	18DEC2013	LG	TE

-	-	-	-	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
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REF	REF	-	1803052-1	FEED FINGER ASSEMBLY, EF	183
-	1	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
-	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	455888-5	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	1976052-1	HOLDDOWN, TERMINAL	65
-	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
-	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	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	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	1-1752371-2	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	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	5-240641-6	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	3-690482-2	PLATE, FRONT SHEAR	9
-	1	1	1	1	3-1803001-7	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2-240641-9	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	1	1	1490019-7	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND WITHOUT NOTICE, THE MANUFACTURING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				OWN K. HUANG	04NOV2013	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK L. ZHANG	04NOV2013				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J. GUO	04NOV2013	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		PRODUCT SPEC -		SIZE A		CASE CODE 00779	
		FINISH -		APPLICATION SPEC -		DRAWING NO C=2150394		RESTRICTED TO -	
MATERIAL -				WEIGHT -		Customer Accessible Production Drawing		SCALE 1:1 SHEET 1 OF 4 REV A	

HOLDDOWN SET-UP

PNEUMATIC

SERVO
LATCH PLATE

CAM POSITION



- 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: 8-2150394-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150394-5
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 ITEMS 62, 180 &
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

6		5			4		3	
FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
	CONVERT TO	PART NUMBERS REQUIRED						
PNEUMATIC	-	-	-	-	-	-	-	
	SERVO LATCH PLATE	2119951-1	1803052-1	8-2150394-5	-	-	2168400-7 (QUANTITY 2)	
	SMART APPLICATOR	2161326-1	-	8-2150394-4	-	-	-	
SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-	
	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-2	
NONE	-	-	-	-	-	-	-	
-	-	-	-	-	-	-	-	

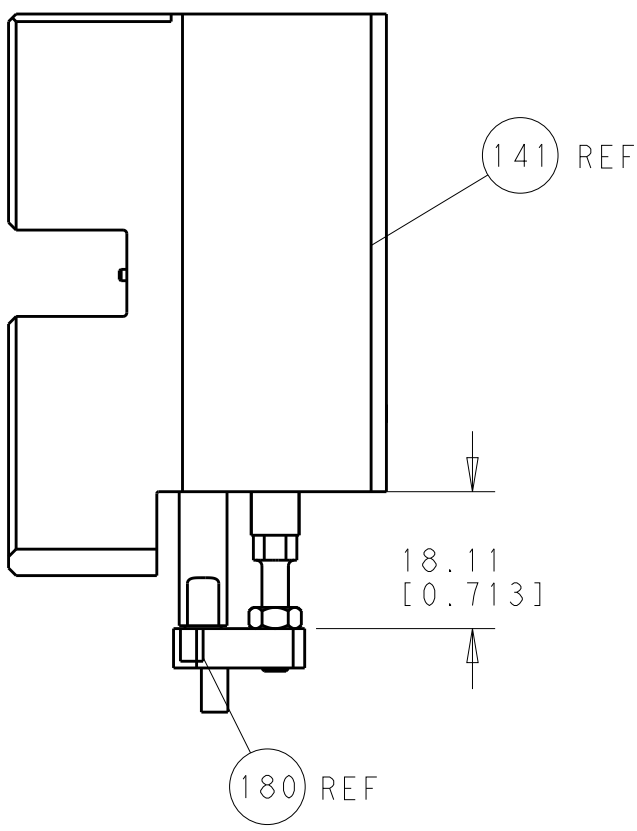
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*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO
LARGEST WIRE SIZE SETTING. USE OF SETTINGS
BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING
WILL CAUSE DAMAGE TO CRIMP TOOLING.
```

-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

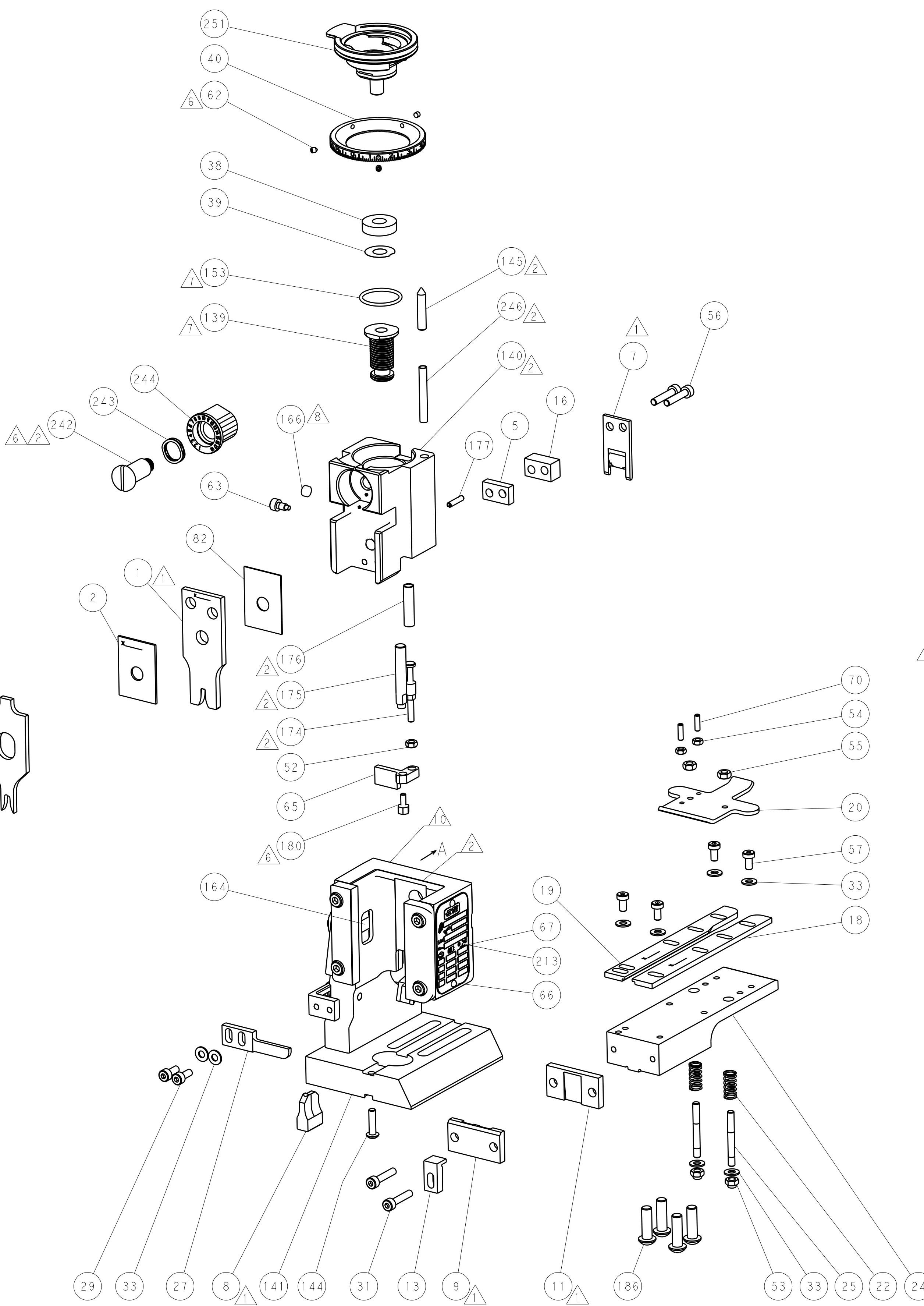
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

[illegible]

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



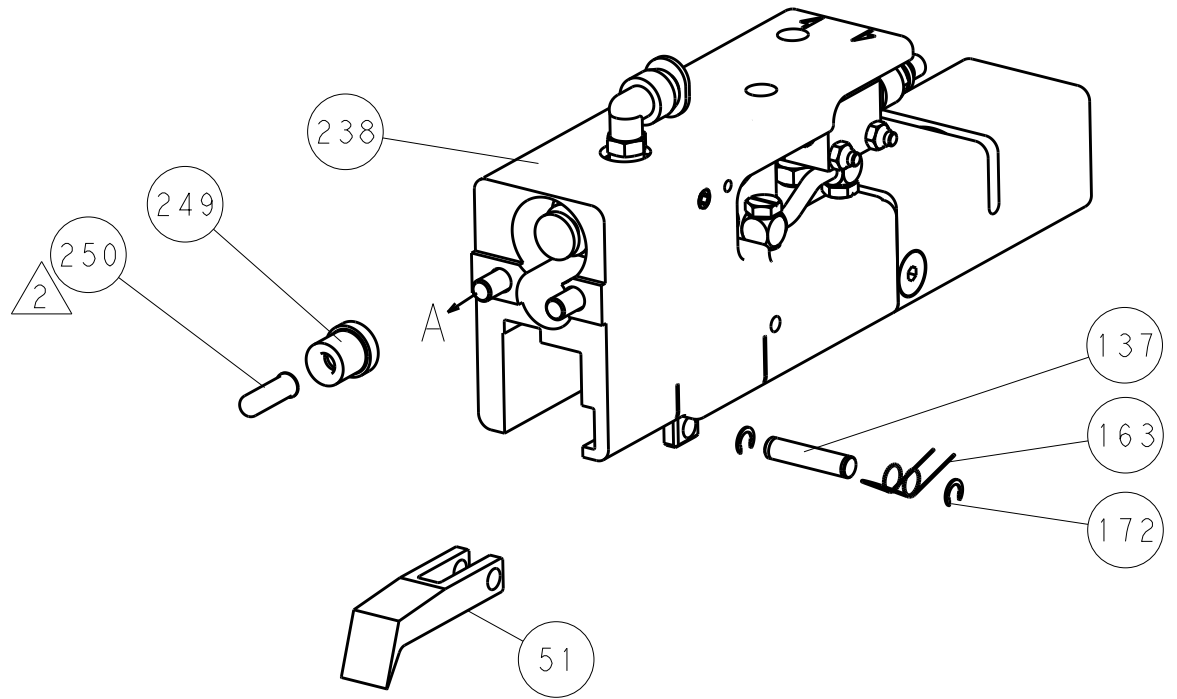
HOLDDOWN SET-UP



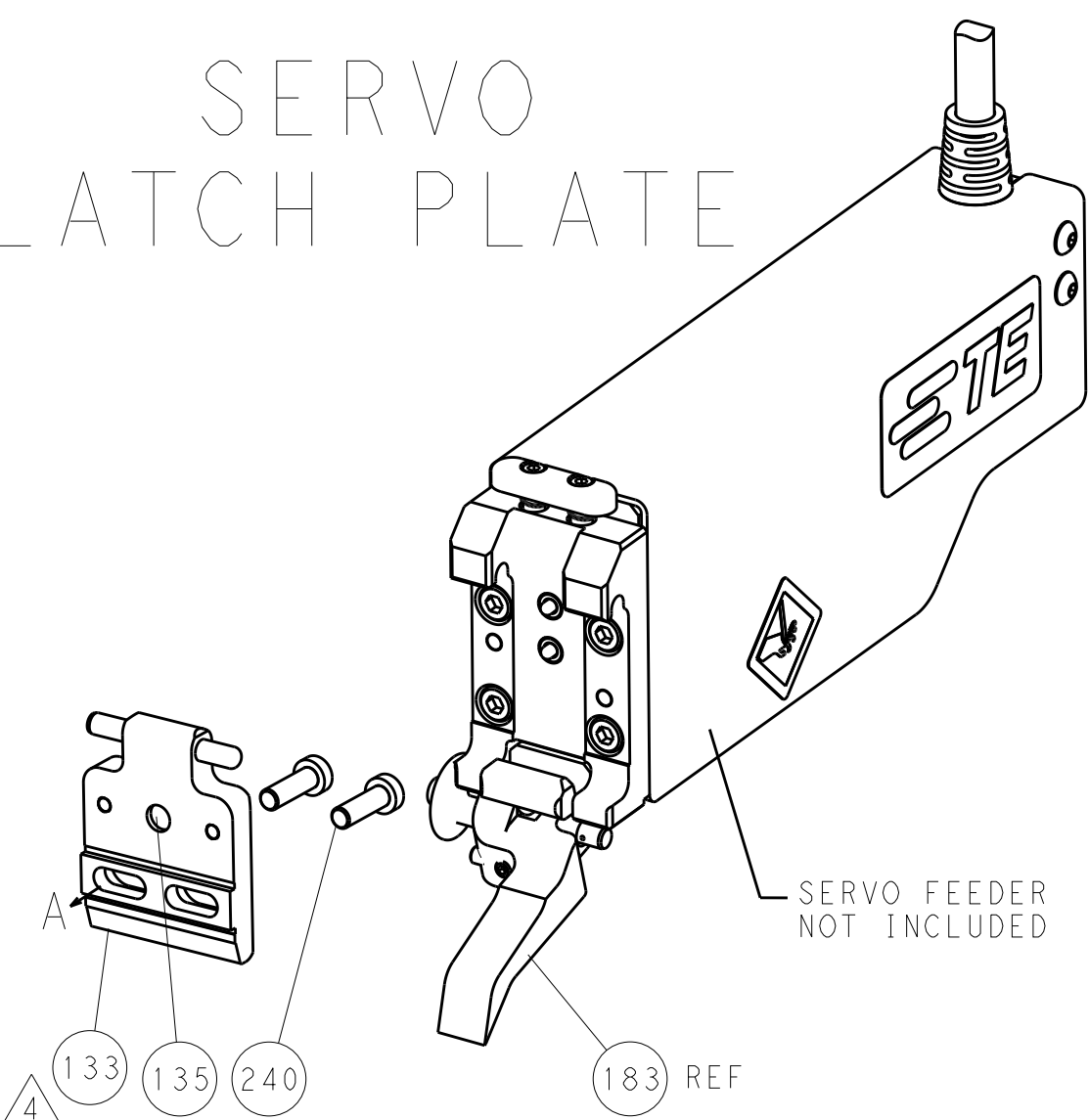
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

FEED TYPE

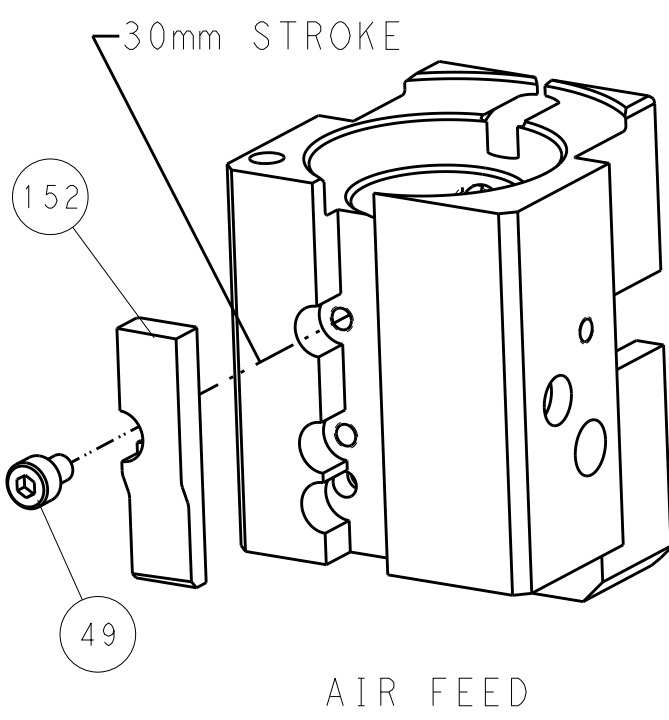
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



AIR FEED

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN K. HUANG 04NOV2013	STE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 04NOV2013	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.001 ANGLES ±0.001		APVD J. GUO 04NOV2013	PRODUCT SPEC APPLICATION SPEC	
MATERIAL		WEIGHT	SIZE A1	CAGE CODE 00779
			DRAWING NO C=2150394	RESTRICTED TO
		Customer Accessible Production Drawing	SCALE 1:1	SHEET 4 OF 4
			REV A	

Mouser Electronics

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[7-2150394-7](#)