

8

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

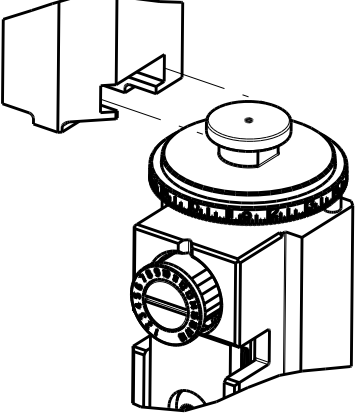
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150689-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE
SMART APPLICATOR

2119951-1
2161326-1

1901697-1
-

8-2150689-5
8-2150689-4

-
-

-
-

2168400-7 (QUANTITY 2)
-

2150689-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119950-1

2119792-1

-

2119641-1

-

2063440-1

2150689-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

-

-

-

-

-

-

2150689-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2150689-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.03 mm [.080]

○

INSUL

0.00 mm [.000]

-

APPL INSTRUCTIONS

408-10390



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: SPADE, INSULATION PIERCING

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

N/A

Ø1.14-1.27 mm [.045-.050 IN]

TERMINAL APPLICATION SPECIFICATION

114-2084

-

-

TERMINALS APPLIED

△

TE TERMINAL

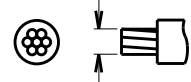
TE TERMINAL

TE TERMINAL

TE TERMINAL

60234-2

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



22 AWG

2.03+/-0.05 [.080+/- .002]

7.0

24 AWG

2.03+/-0.05 [.080+/- .002]

6.8

26 AWG

2.03+/-0.05 [.080+/- .002]

6.8

△

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: 8-2150689-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150689-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150689-6

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.
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

*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.

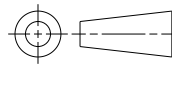
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

REVISIONS							
P	LTR	DESCRIPTION	DATE	OWN	APVD		
	1	DEVELOPMENT	01JUL2016	JH	LZ		
	A	RELEASED	19AUG2016	JH	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
-	-	2	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF	-	-	1901697-1	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
-	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	455888-5	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	1901681-5	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	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	1-2119644-3	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	8-1901696-5	STRIP GUIDE, REAR	19
-	1	1	1	1	8-1901695-6	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-6	SPACER, SHEAR PLATE	10
-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	1	1	2-1803002-4	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	9-240651-0	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-8	SPACER	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
1	1	1	1	1	459492-8	CRIMPER, WIRE O	1
-	77	-	7	-	6	-	5
-	5	-	2	-	-	-	-
PART NO				DESCRIPTION			ITEM NO

THE FOLLOWING IS A SUMMARY OF THE INFORMATION CONTAINED IN THIS DRAWING. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY TO THE ORGANIZATION THAT IS THE SOURCE OF THE INFORMATION. IT IS THE RESPONSIBILITY OF THE USER TO CONTACT THE ORGANIZATION FOR THE LATEST REVISION.

DIMENSIONS:

mm



TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.01
1 PLC ±.01
2 PLC ±.01
3 PLC ±.01
4 PLC ±.01
ANGLES ±.01
FINISH -

MATERIAL

-

OWN J. HOU 01JUL2016
CHK L. ZHANG 01JUL2016
APVD L. ZHANG 01JUL2016

NAME

Ocean End Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2150689

-

Customer Accessible Production Drawing

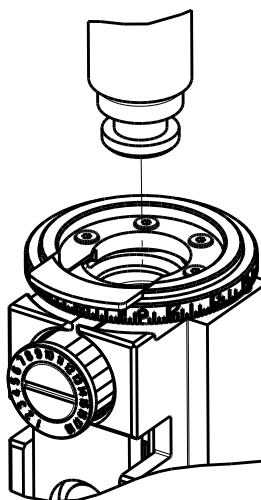
SCALE 1:1

SHEET 1 OF 4

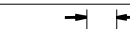
REV A

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

AMP 4805 REV 31MAR2000

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2150689-2	A	FINE CRIMP HEIGHT ADJUST
	2-2150689-5	A	FINE CRIMP HEIGHT ADJUST
	2-2150689-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150689-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	○
INSUL	0.00 mm [.000]	-
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPADE, INSULATION PIERCING			
WIRE STRIP LENGTH N/A			INSULATION DIAMETER RANGE Ø1.14-1.27 mm [.045-.050 IN]
TERMINAL APPLICATION SPECIFICATION	 114-2084	-	-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60234-2			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
22 AWG		2.03+/-0.05 [.080+/- .002]		7.0
24 AWG		2.03+/-0.05 [.080+/- .002]		6.8
26 AWG		2.03+/-0.05 [.080+/- .002]		6.8



- △ 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: 8-2150689-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150689-5
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 & 180.
- △ 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.

*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.

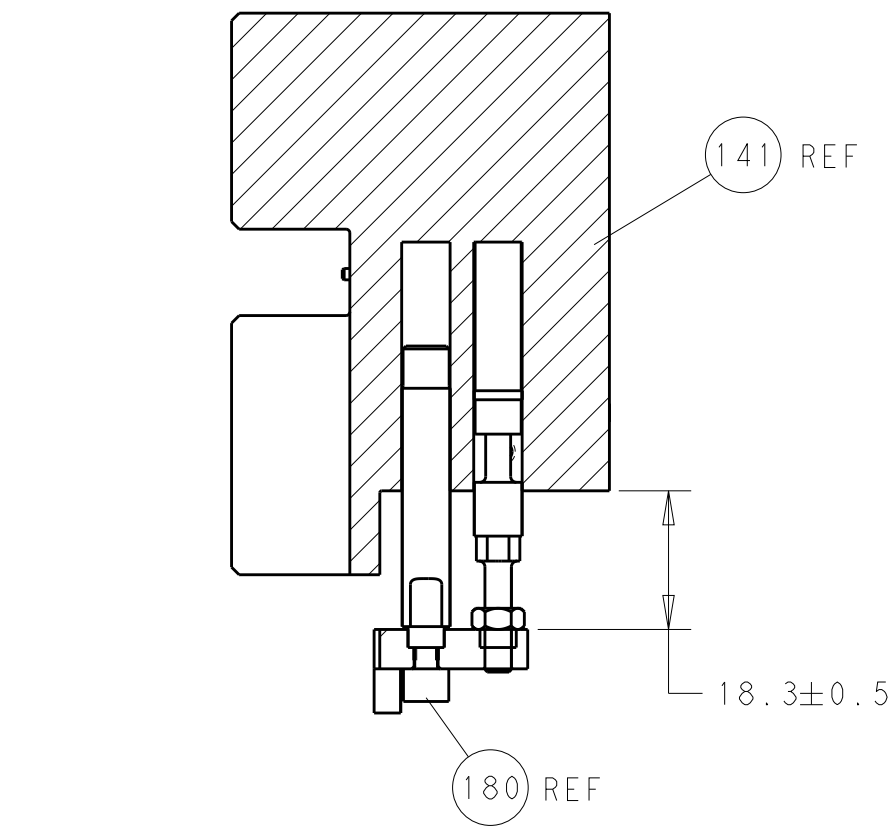
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
			-	-	SEE SHEET 1	-

6	-	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			
	-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240			
	-	-	-	1	2063440-1	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			
	-	1	1	1	1752354-2	STANDOFF,HOLD-DOWN	180			
	-	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177			
	-	1	1	1	8-22280-7	SPRING, COMPRESSION	176			
	-	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175			
	-	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174			
	-	-	-	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	455888-5	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	2119740-1	TAG,IDENTIFICATION	67			
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66			
	-	1	1	1	1901681-5	HOLDDOWN, TERMINAL	65			
	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63			
	6	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62		
		-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57		
		-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	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	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	1-2119644-3	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	1752371-1	PLATE, STRIP GUIDE	24			
-		2	2	2	2-22281-3	SPRING, COMPRESSION	22			
-		1	1	1	1752373-4	DRAG	20			
-		1	1	1	8-1901696-5	STRIP GUIDE, REAR	19			
-		1	1	1	8-1901695-6	STRIP GUIDE, FRONT	18			
1		-	1	1	1	240644-1	PLATE, REAR SHEAR	11		
		-	2	2	2	1-240645-6	SPACER, SHEAR PLATE	10		
		-	1	1	1	240642-1	PLATE, FRONT SHEAR	9		
		1	1	1	1	1	2-1803002-4	ANVIL, COMBINATION, END FEED	8	
			-	1	1	1	9-240651-0	BLADE, SLUG	7	
			-	-	-	-	-	-	6	
			-	1	1	1	240641-8	SPACER	5	
			-	-	-	-	-	-	4	
			-	-	-	-	-	-	3	
			-	-	-	-	-	-	2	
			1	1	1	1	1	459492-8	CRIMPER, WIRE O	1
				-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

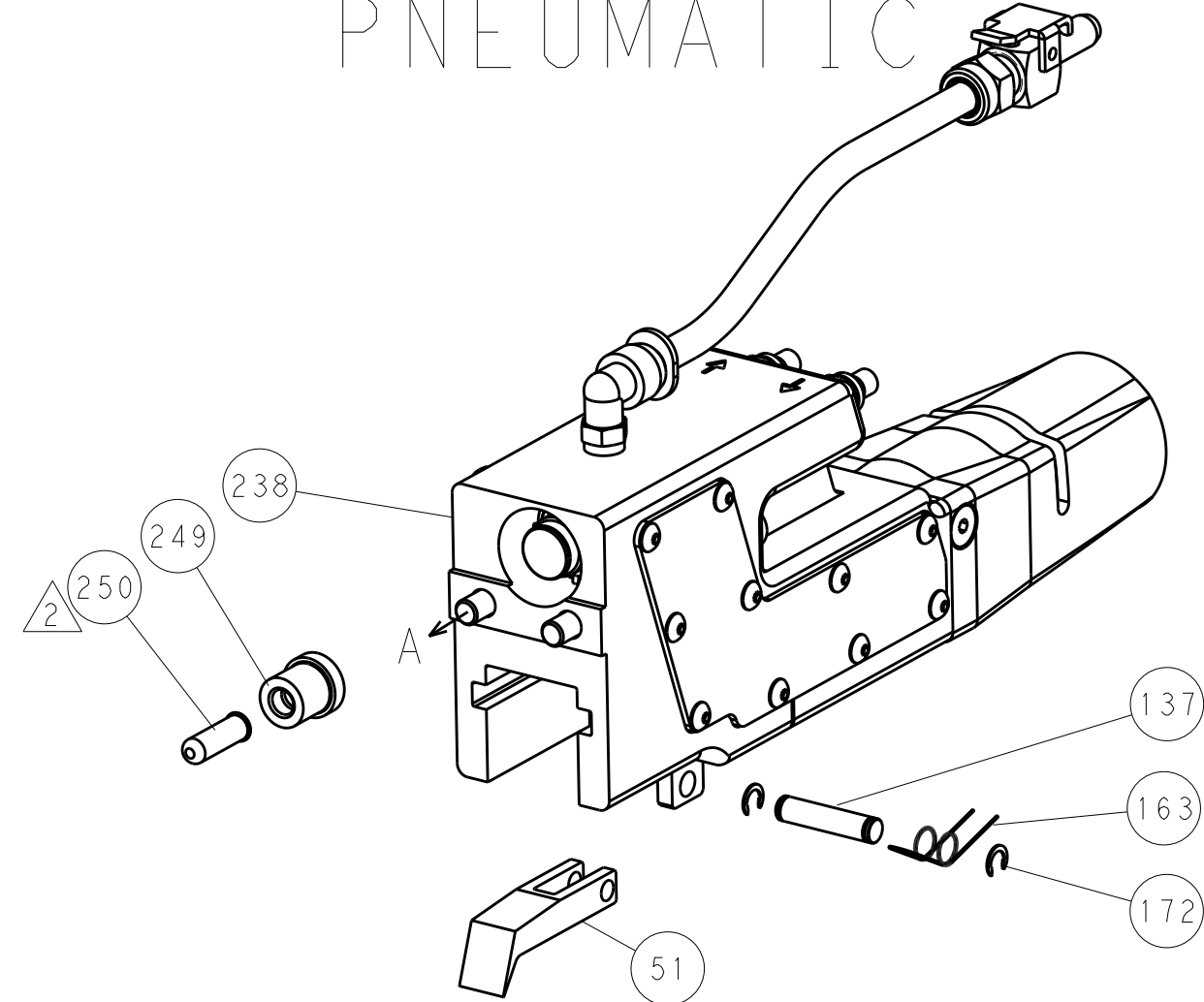
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. NO OTHER ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.		OWN J. HOU CHK L. ZHANG APVD L. ZHANG 01JUL2016		01JUL2016		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01		NAME Ocean End Feed Applicator		RESTRICTED TO	
		FINISH		SIZE A1		CAGE CODE 00779	
MATERIAL -		FINISH -		WEIGHT -		DRAWING NO C=2150689	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 3 OF 4	

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

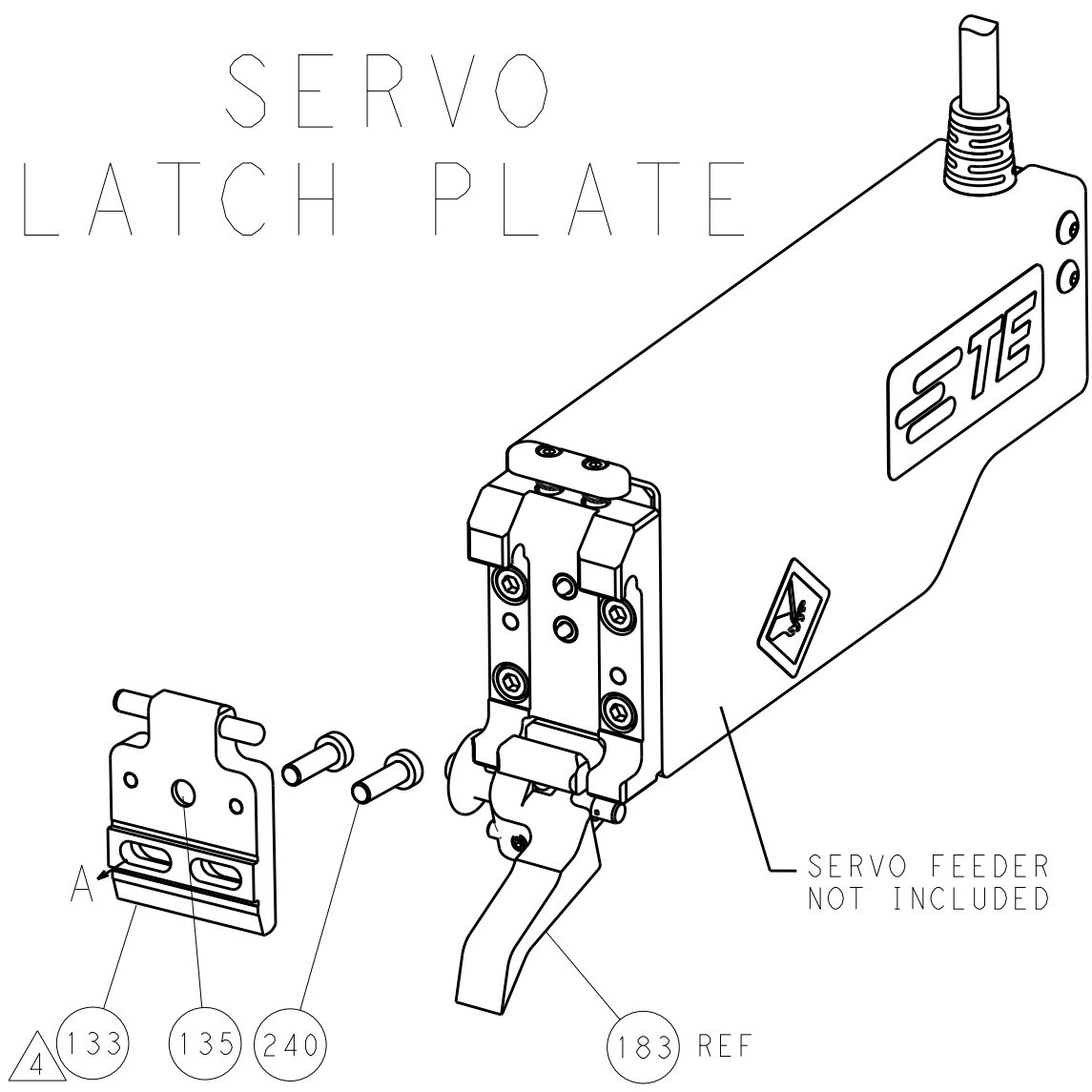


HOLDDOWN SET-UP

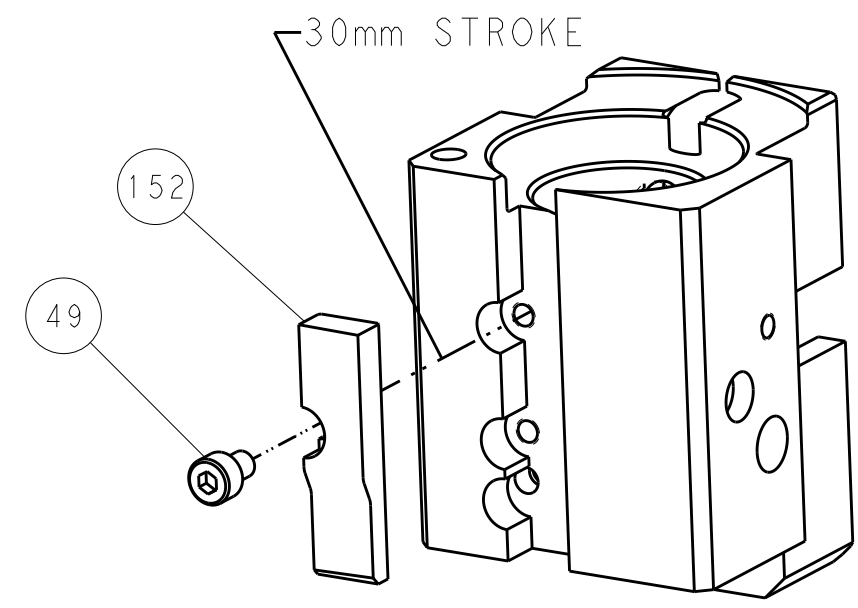
FEED TYPE
PNEUMATIC



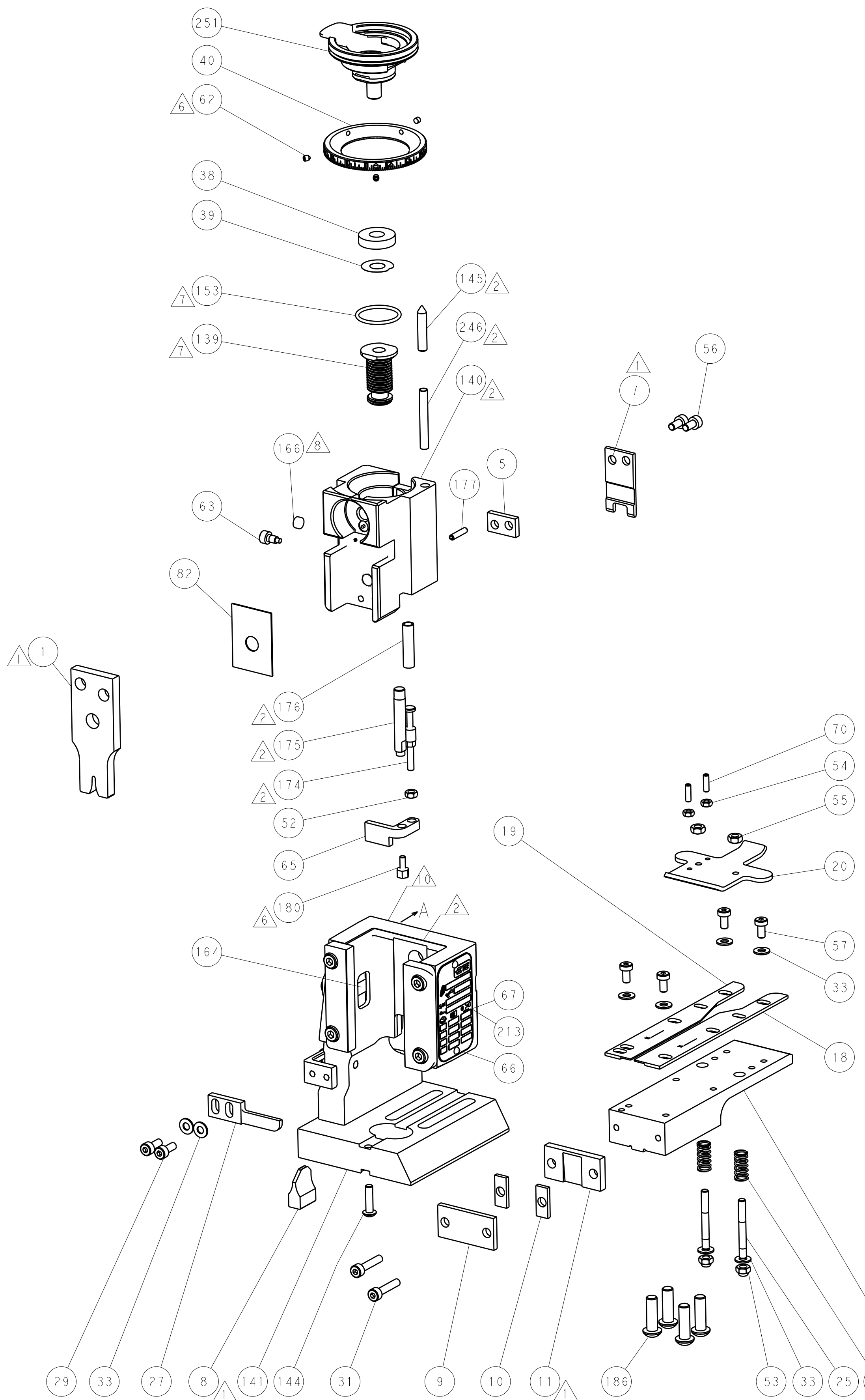
SERVO
LATCH PLATE



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN J. HOU 01JUL2016	STE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 01JUL2016	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD L. ZHANG 01JUL2016	PRODUCT SPEC	
MATERIAL			APPLICATION SPEC	
			WEIGHT	
			Customer Accessible Production Drawing	
			SCALE 1:1 SHEET 4 OF 4 REV A	

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