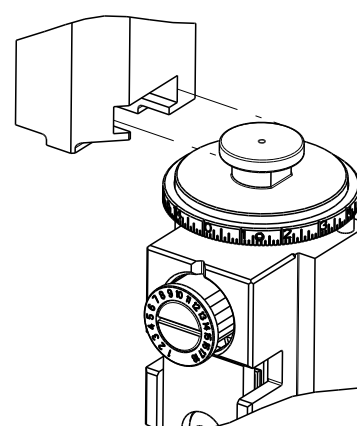


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION
	2150630-2	A	FINE CRIMP HEIGHT ADJUST
	2150630-5	A	FINE CRIMP HEIGHT ADJUST
	2150630-6	A	NON-CRIMP HEIGHT ADJUST
	2150630-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150630-7	A	CRIMP TOOLING KIT
DESCRIPTION			
APPLICATOR DATA			
CRIMP	SIZE	TYPE	
WIRE	4.50 mm [.177]	F	
INSUL	6.45 mm [.254]	F	
APPL INSTRUCTIONS 408-10390			

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 6.10-6.90 mm [.240-.272 IN]		INSULATION DIAMETER RANGE Ø3.70-5.00 mm [.146-.197 IN]	
TERMINAL APPLICATION  25806 Rev 13		-	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113917-1	25806.214.012	2113917-2	25806.417.011

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
FLY 6mm ²			3.15+/-0.10 [.124+/- .004]		7.1
FLY 4mm ²			2.95+/-0.10 [.116+/- .004]		8.7



- 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: 8-2150630-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150630-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150630-6
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.
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.
- 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.

		2					I
SET UP GAUGE 2119599-2		LOC A	DIST 66	REVISIONS			
P	LTR	DESCRIPTION			DATE	DWN	APVD
	A	RELEASED			14DEC2015	RK	GB

-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	1	1	1803078-3	SPACER, PRECISION	259
-	1	-	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	2079988-1	BUSHING, LCH5-12, MISMUMI	249
-	-	-	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	2119798-1	DETENT PIN	247
-	1	-	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	2161315-1	RAM, STEPPED, AMP STYL, EF, NON-ADJUST	245
-	1	1	1	2119082-2	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	24
-	-	-	-	2063440-2	AIR FEED MODULE	238
-	-	1	1	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	-	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREFREFREFREF	-	-	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	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	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	-	-	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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
-	-	-	-	2119792-2	PAWL, EF, AIR	51
-	-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	1	2161310-1	RAM, STEPPED, AMP STYLE, END FEED	44
-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	2119092-1	BOLT, ADJUSTMENT	35
-	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	690455-1	STRIPPER, FRONT CASTING	27
-	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1752373-4	DRAG	20
-	1	1	1	1901696-6	STRIP GUIDE, REAR	19
-	1	1	1	1901695-6	STRIP GUIDE, FRONT	18
-	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	240641-2	SPACER	16
-	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
-	1	1	1	7-690482-9	PLATE, FRONT SHEAR	9
1	1	1	1	3-1803059-3	ANVIL, COMBINATION, END FEED	8
-	1	1	1	2217206-9	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	1-240641-5	SPACER	5

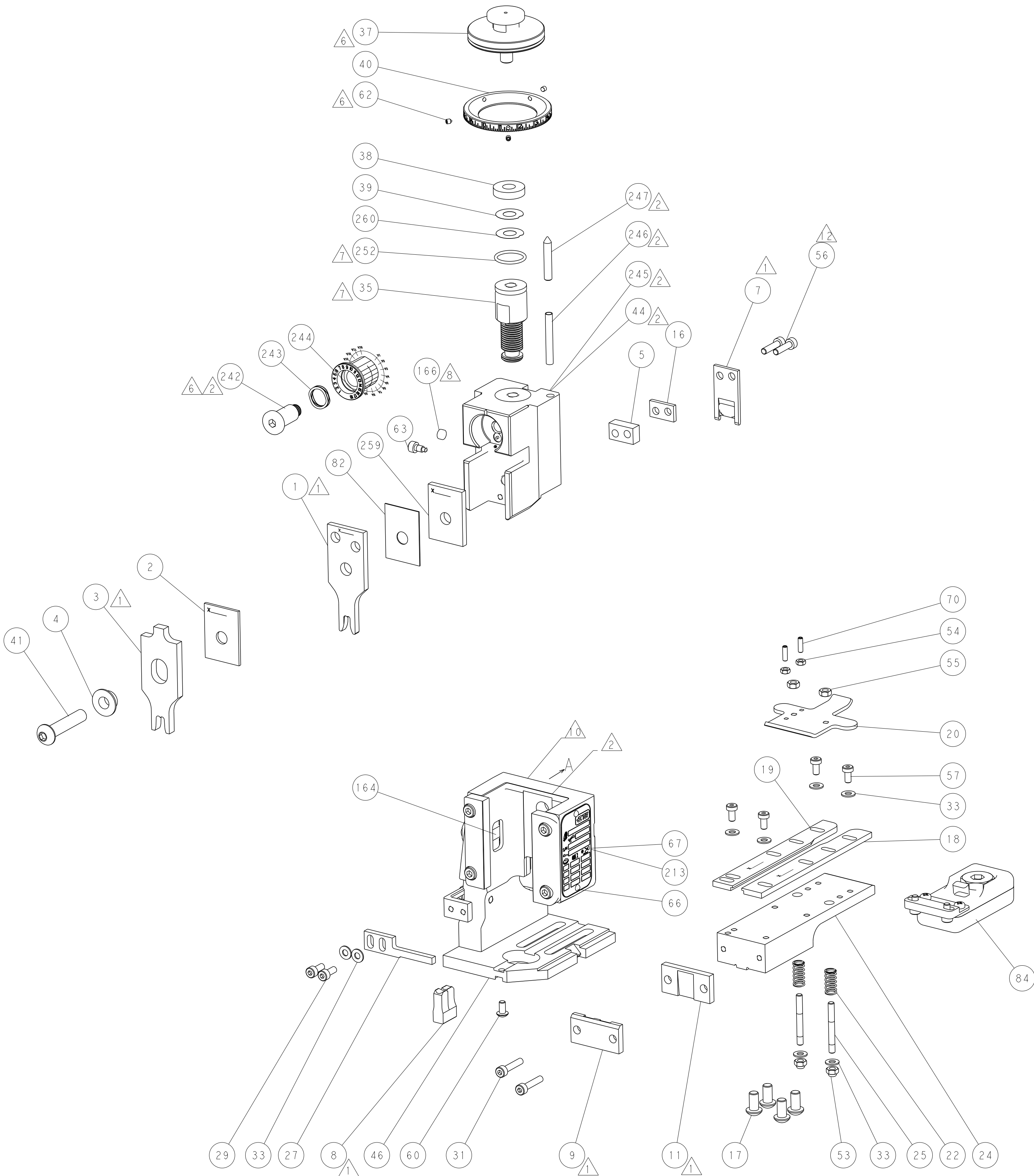
(1) STANDARD 1-2 CONVERSION TABLE FOR USE FOR THE CONVERSION OF DIMENSIONS FROM INCHES TO MILLIMETERS (2) DIMENSIONS IN PARENTHESES ARE FOR INFORMATION ONLY AND SHOULD BE CHECKED FOR THE LATEST REVISION		DWN C. HUANG 06NOV2015 CHN L. ZHANG 06NOV2015 APD H. GUO 06NOV2015		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

*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)

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

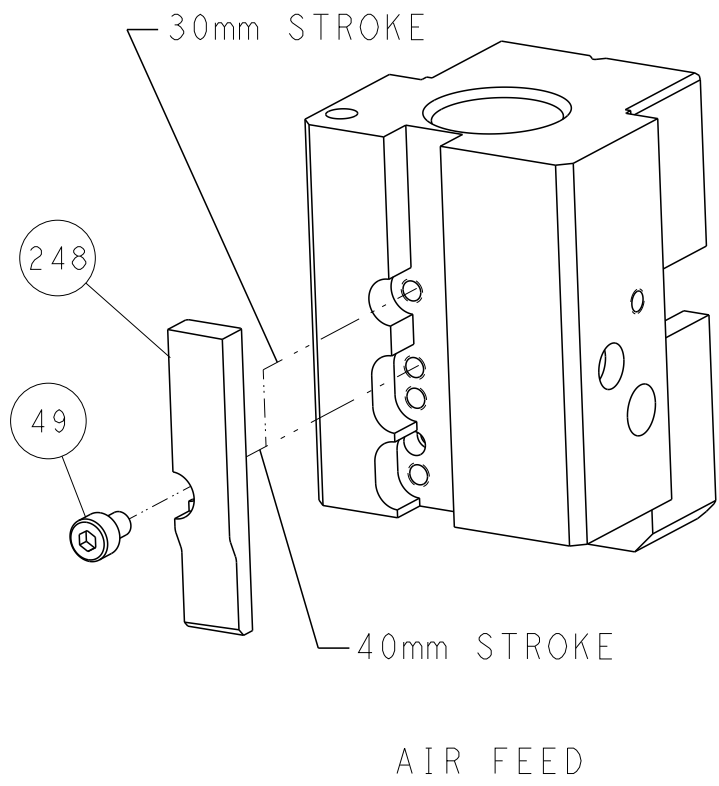


FEED TYPE

PNEUMATIC

SERVO
LATCH PLATE

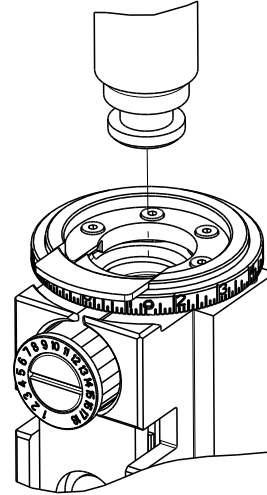
CAM POSITION



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

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DIMENSIONS: mm		CHK L. ZHANG 06NOV2015	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD J. GUO 06NOV2015	SIZE CAGE CODE DRAWING NO 00779 C=2150630	
MATERIAL -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	RESTRICTED TO -	
Customer Accessible Production Drawing		SCALE 1:1	SHEET 2 OF 4	REV A

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2150630-2	A	FINE CRIMP HEIGHT ADJUST
	2-2150630-5	A	FINE CRIMP HEIGHT ADJUST
	2-2150630-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150630-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.50 mm [.177]	F
INSUL	6.45 mm [.254]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 6.10-6.90 mm [.240-.272 IN]		INSULATION DIAMETER RANGE Ø3.70-5.00 mm [.146-.197 IN]	
TERMINAL APPLICATION SPECIFICATION	25806 Rev 13	-	-
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113917-1	25806.214.012	2113917-2	25806.417.011

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
FLY 6mm²		3.15+/-0.10 [.124+/- .004]		7.1
FLY 4mm²		2.95+/-0.10 [.116+/- .004]		8.7



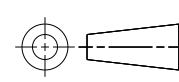
-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150630-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150630-5
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 ITEM 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.
-  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.

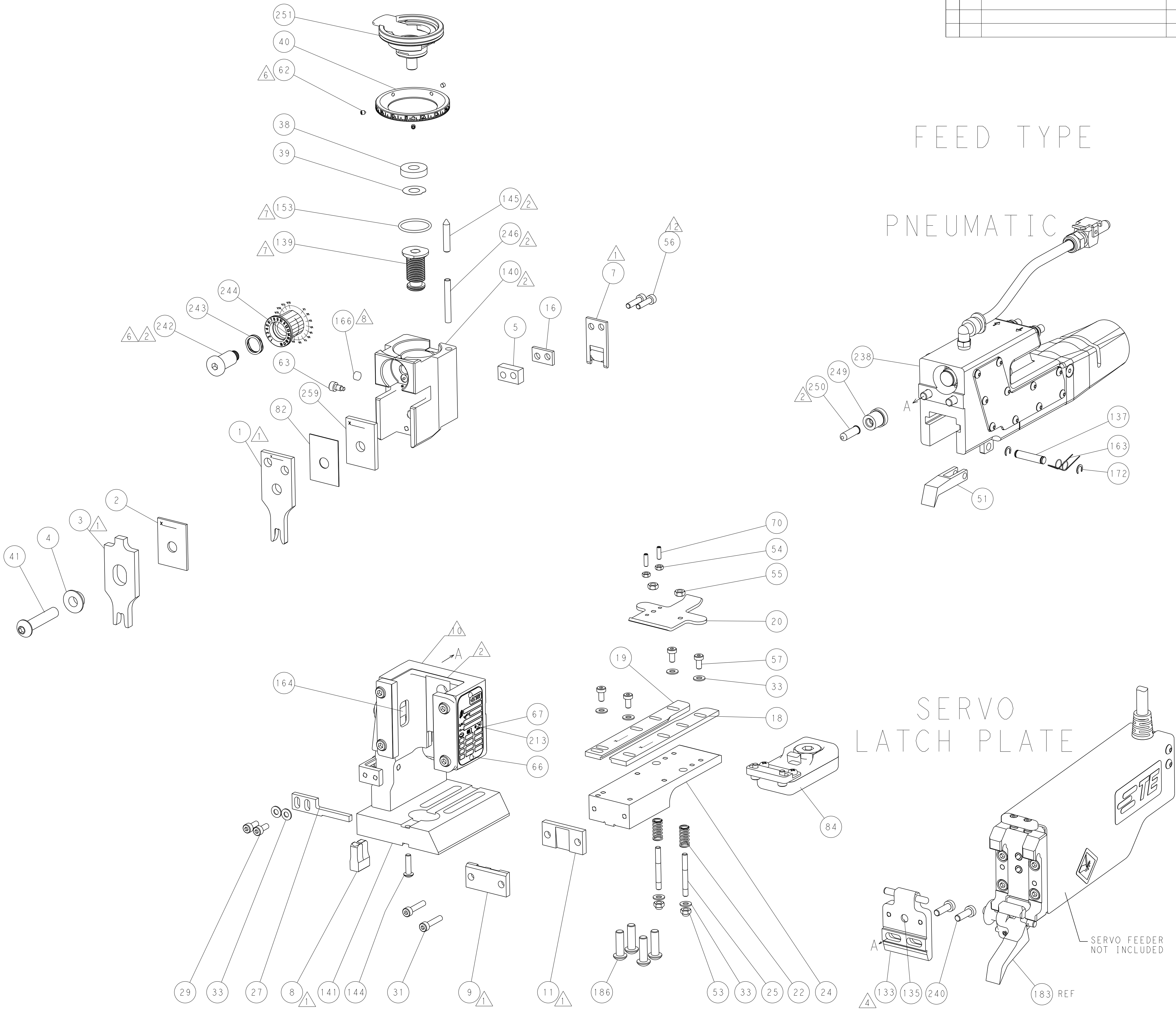
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	1	1803078-3	SPACER, PRECISION	259
-	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	2119082-2	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
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	-	-	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	2161313-1	RAM, STEPPED, 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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2119792-2	PAWL, EF, AIR	51
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	690455-1	STRIPPER, FRONT CASTING	27
-	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1752373-4	DRAG	20
-	1	1	1	1901696-6	STRIP GUIDE, REAR	19
-	1	1	1	1901695-6	STRIP GUIDE, FRONT	18
-	1	1	1	240641-2	SPACER	16
	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
	1	1	1	7-690482-9	PLATE, FRONT SHEAR	9
	1	1	1	3-1803059-3	ANVIL, COMBINATION, END FEED	8
	-	1	1	2217206-9	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	1-240641-5	SPACER	5
-	1	1	1	1-238009-8	BLOCK, FL CRIMPER SPACER	4
	1	1	1	9-1803016-0	CRIMPER, INSULATION F	3
-	1	1	1	1-455888-6	SPACER, CRIMPER	2
	1	1	1	5-1803188-6	CRIMPER, WIRE	1
-	77	27	25	22	PART NO	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE CONTACTED FOR THE LATEST REVISION.					DWN R. HUANG	06NOV2015	 TE Connectivity Harrisburg, PA 17105-3608						
					CHK L. ZHANG	06NOV2015							
					APVD J. GUO	06NOV2015							
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME		Ocean End Feed Applicator -					
mm		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		APPLICATION SPEC									
		FINISH		WEIGHT									
MATERIAL		-		-		-		SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO	
								A1		00779	C=2150630	-	
Customer Accessible Production Drawing								SCALE		1:1	SHEET 3 OF 4		REV A

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



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

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										CHK		L. ZHANG		06NOV2015							
										APVD		J. GUO		06NOV2015		NAME Ocean End Feed Applicator -					
										PRODUCT SPEC											
										APPLICATION SPEC											
										WEIGHT				SIZE							
										MATERIAL				CAGE CODE							
														DRAWING NO							
														RESTRICTED TO							
														SCALE							
														SHEET							
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