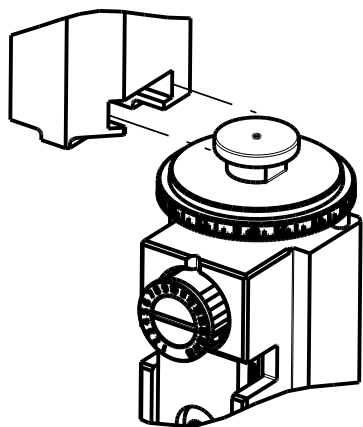
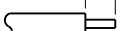


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150086-1	B	FINE CRIMP HEIGHT ADJUST
	2150086-2	B	FINE CRIMP HEIGHT ADJUST
	2150086-5	B	FINE CRIMP HEIGHT ADJUST
	2150086-6	B	NON-CRIMP HEIGHT ADJUST
	2150086-7	B	FINE CRIMP HEIGHT ADJUST
	7-2150086-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.54 mm [.100]	Ø
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH .205-.235 IN [5.21-5.97 mm]		 INSULATION DIAMETER RANGE Ø.060-.087 IN [1.52-2.21 mm]	
TERMINAL APPLICATION SPECIFICATION 	114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62866-1	42640-1	42640-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.42+/-0.05 [.056+/- .002]		4.3
20 AWG		1.30+/-0.05 [.051+/- .002]		5.6
22 AWG or 0.35mm2		1.24+/-0.05 [.049+/- .002]		6.3



- 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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150086-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150086-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150086-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150086-6
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 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.
- 12 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
- 13 LUBRICATION ON TERMINALS RECOMMENDED.

*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	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	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

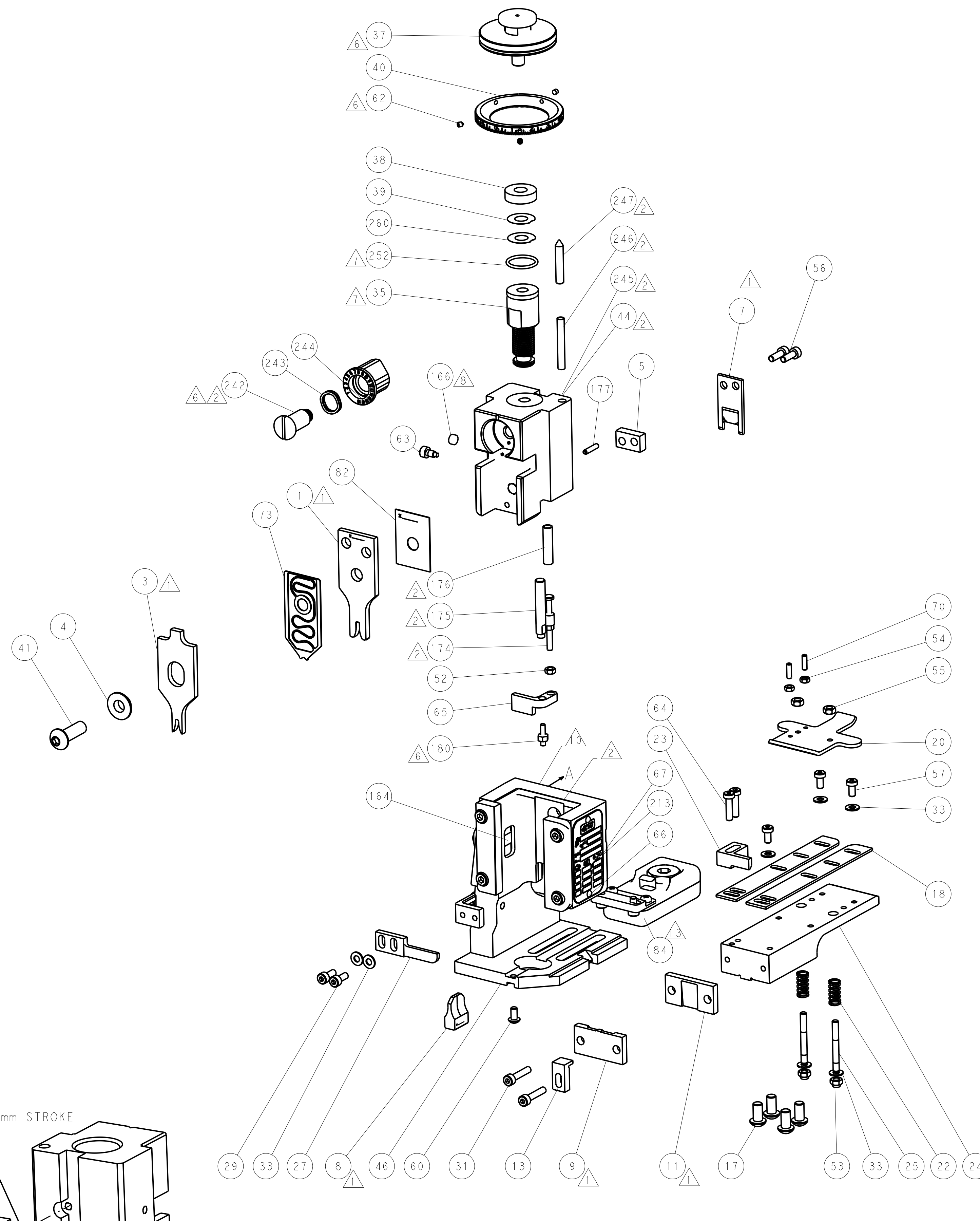
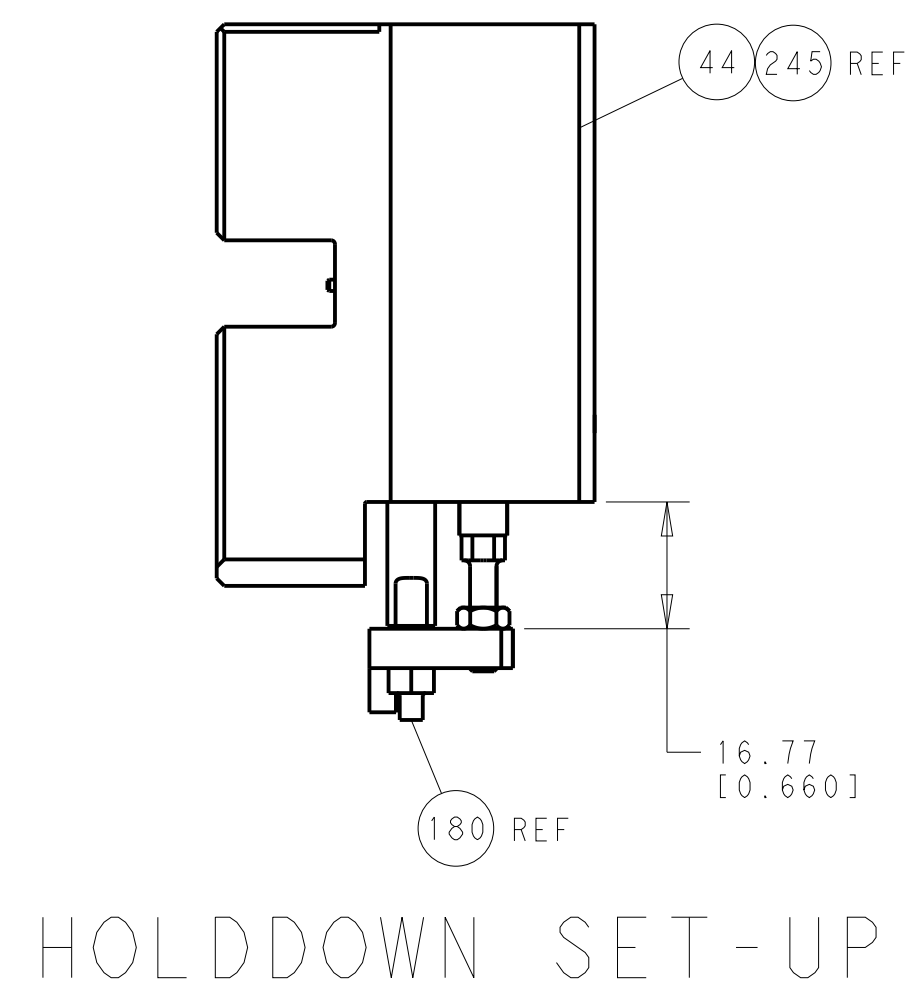
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2		LOC A	DIST 66	REVISIONS			
				P	LTR	DESCRIPTION	DATE
				A		RELEASED	05APR2013
				B		ECR-14-002777	26FEB2014

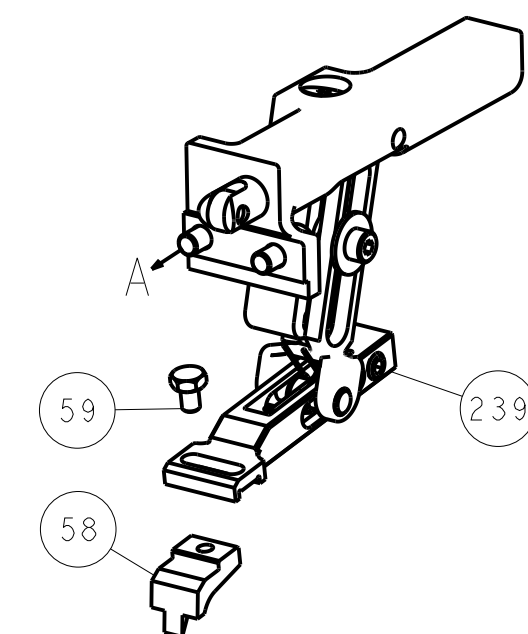
6	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
	-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
	-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
	-	-	REFREF	-	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
6	-	1	1	1	1	1	1-1976055-2	STANDOFF, HOLD-DOWN	180
	-	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REFREFREFREFREFREF					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
13	-	1	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	73
	-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
	-	2	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
	-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
	-	2	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
6	-	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	-	-	-	1	2063961-1	FEED FINGER	58
	-	3	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
	-	2	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
	-	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	-	-	-	1	-	2119792-2	PAWL, EF, AIR	51
	-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	-	-	-	-	1	2119653-1	FEED CAM, POST FEED	47
	-	1	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
	-	1	-	1	1	1	2119369-1	RAM, AMP STYLE, END FEED	44
	-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
6	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
	-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	7	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
	-	2	2	2	2	2	1320906-1	STUD, THREADED	25
	-	1	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	1	1	1	1	1	240825-7	PLATE, STRIP HOLD DOWN	23
	-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1	1	1752373-4	DRAG	20
	-	2	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	18
	-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	1	1	1	1	240644-9	PLATE, REAR SHEAR	11

1	-	-	-	-	-	-	-	-	10
1	-	1	1	1	1	1	2-690495-6	PLATE, FRONT SHEAR	9
1	1	1	1	1	1	1	1633384-5	ANVIL, COMBINATION	8
1	-	1	1	1	1	1	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	-	-	-	-	6
	-	1	1	1	1	1	8-240641-8	SPACER	5
	-	1	1	1	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	1	2-2119784-3	CRIMPER, INSULATION O PREMIUM	3
	-	-	-	-	-	-	-	-	2
1	1	1	1	1	1	1	1-456406-2	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO	

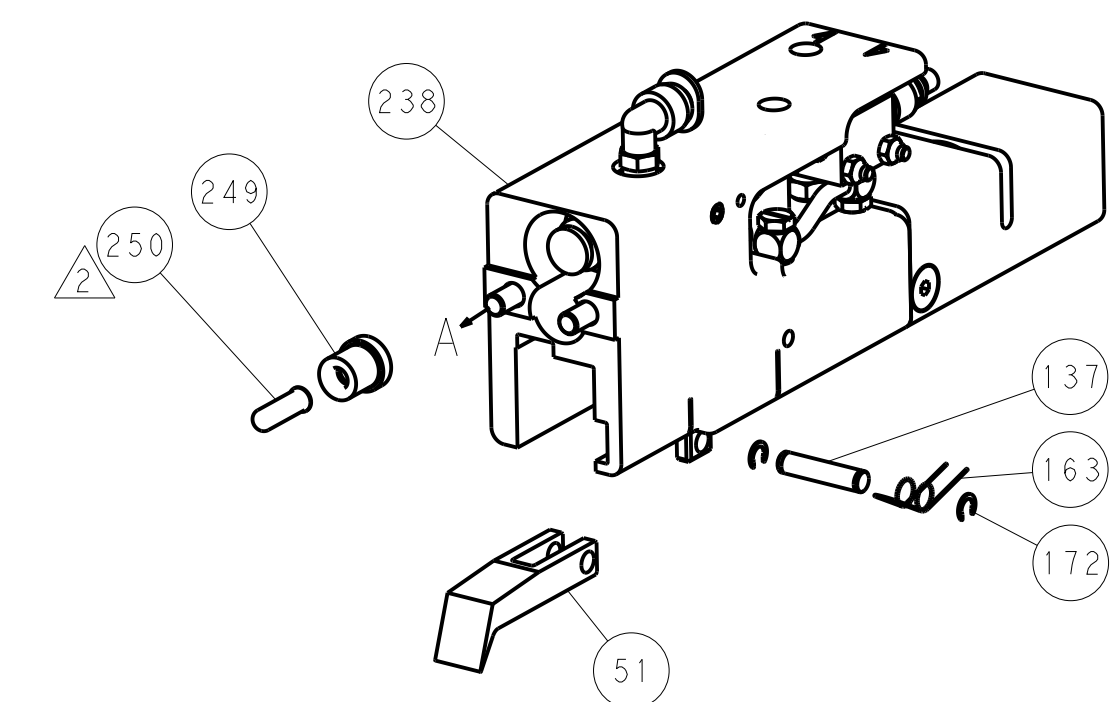
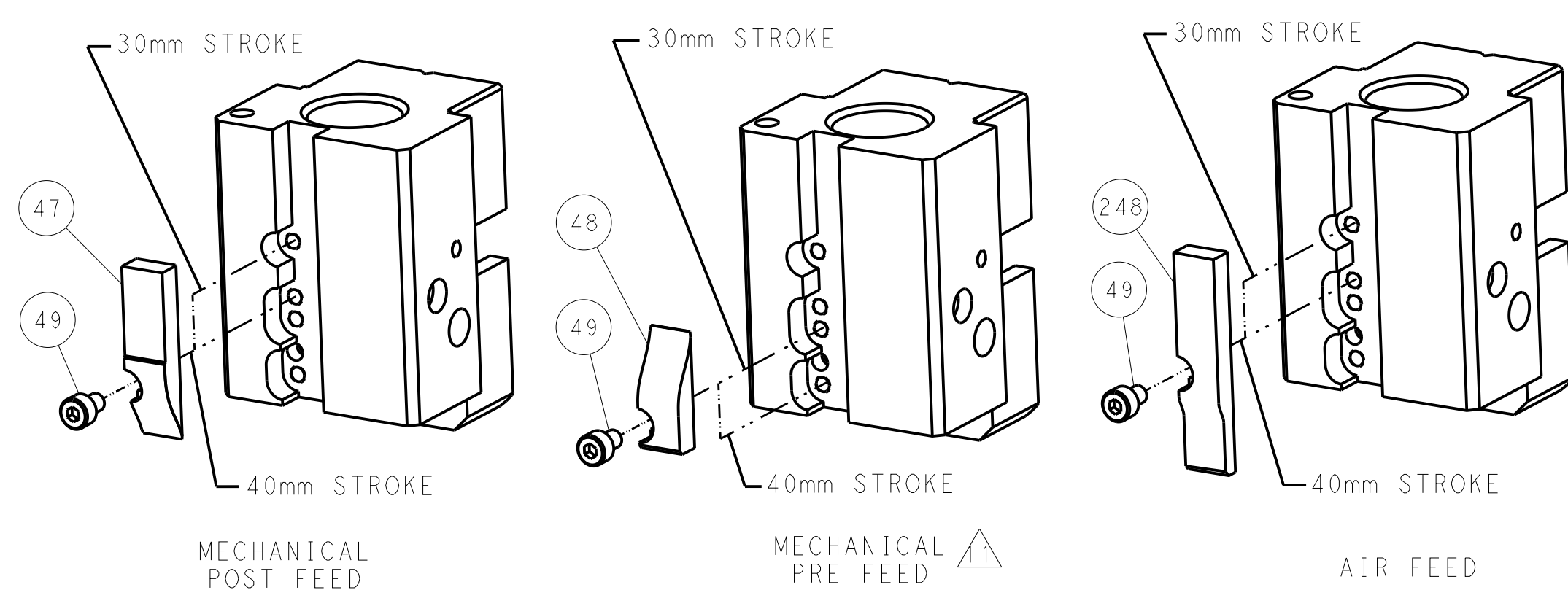
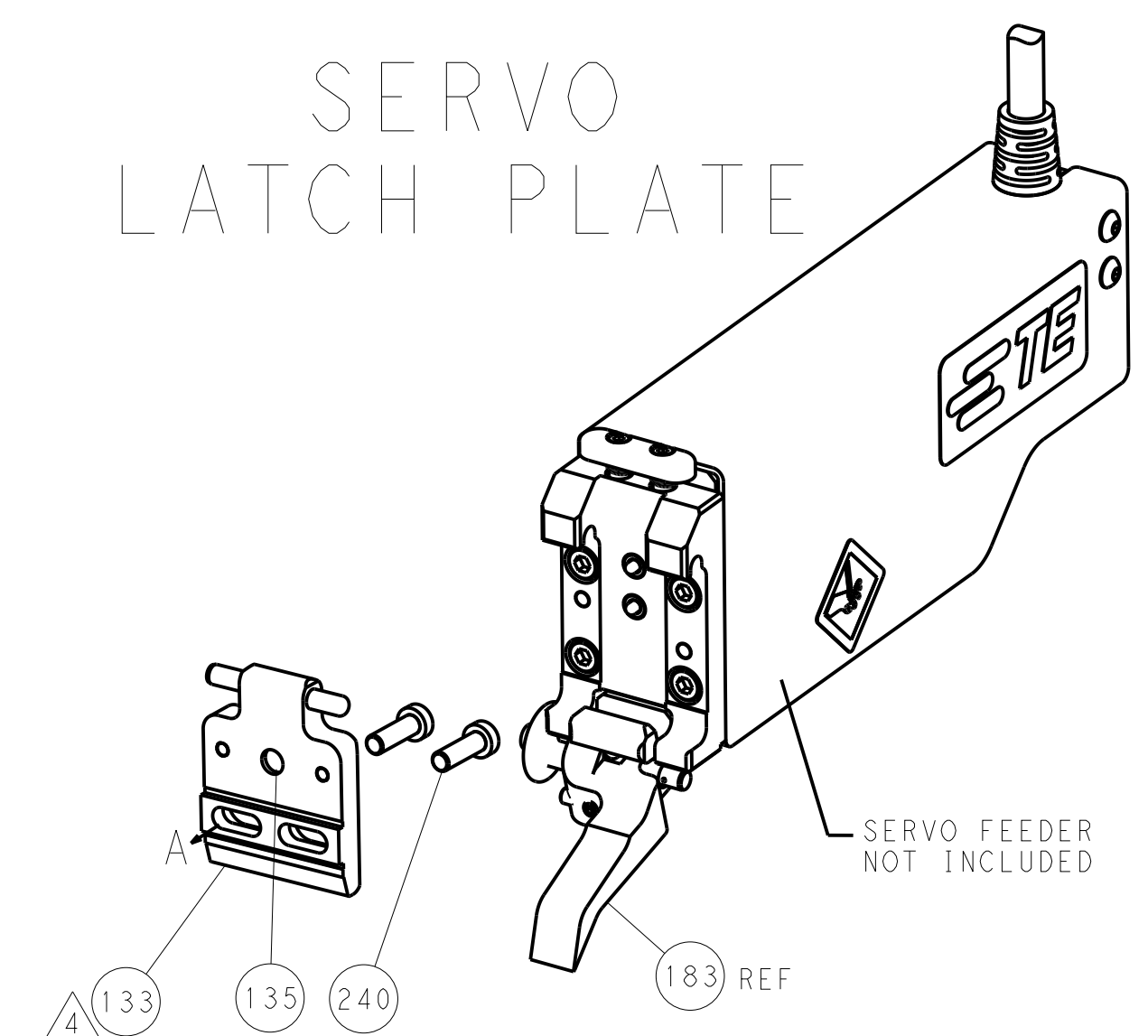
THIS IS SUBJECT TO CHANGE AND NOT BE USED FOR CONSTRUCTION PURPOSES. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.				DWN	C. CHEN	06MAR2013	TE Connectivity					
				CHK	U. GUO	06MAR2013	Harrisburg, PA 17105-3608					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	J. CRUZ	06MAR2013	NAME	Ocean End Feed Applicator				
mm		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.0001		PRODUCT SPEC								
				APPLICATION SPEC								
MATERIAL		FINISH		WEIGHT		SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO		
-		-		-		A		00779	C=2150086	-		
Customer Accessible Production Drawing						SCALE		1:1	SHEET	1 OF 4	REV	B



FEED TYPE
MECHANICAL



PNEUMATIC

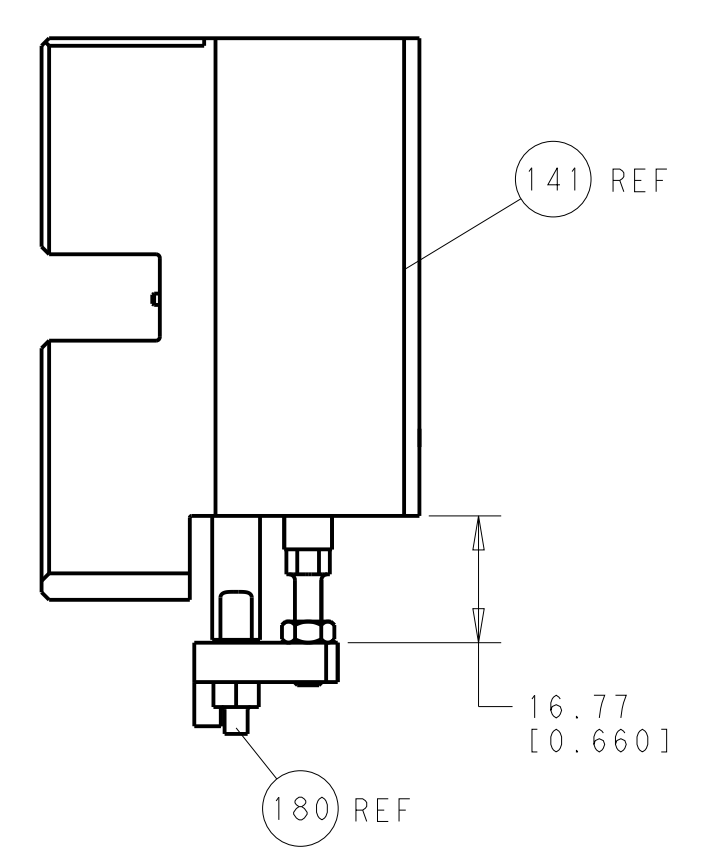
SERVO
LATCH PLATE

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

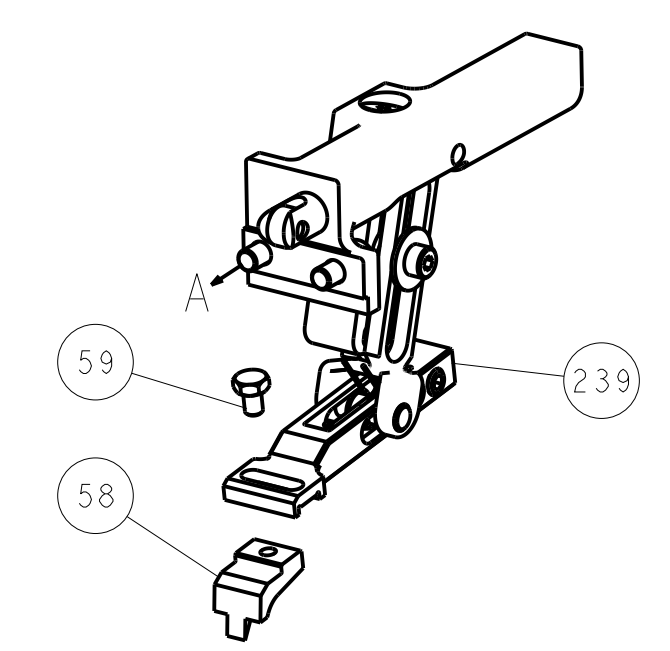
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1			
		APVD 06MAR2013 T.CRUZ		NAME Ocean End Feed Applicator	
MATERIAL -		FINISH -		SIZE A1 00779	
WEIGHT -		APPLICATION SPEC -		C-2150086	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1		SHEET 2 OF 4	
REV B		RESTRICTED TO		REV B	

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

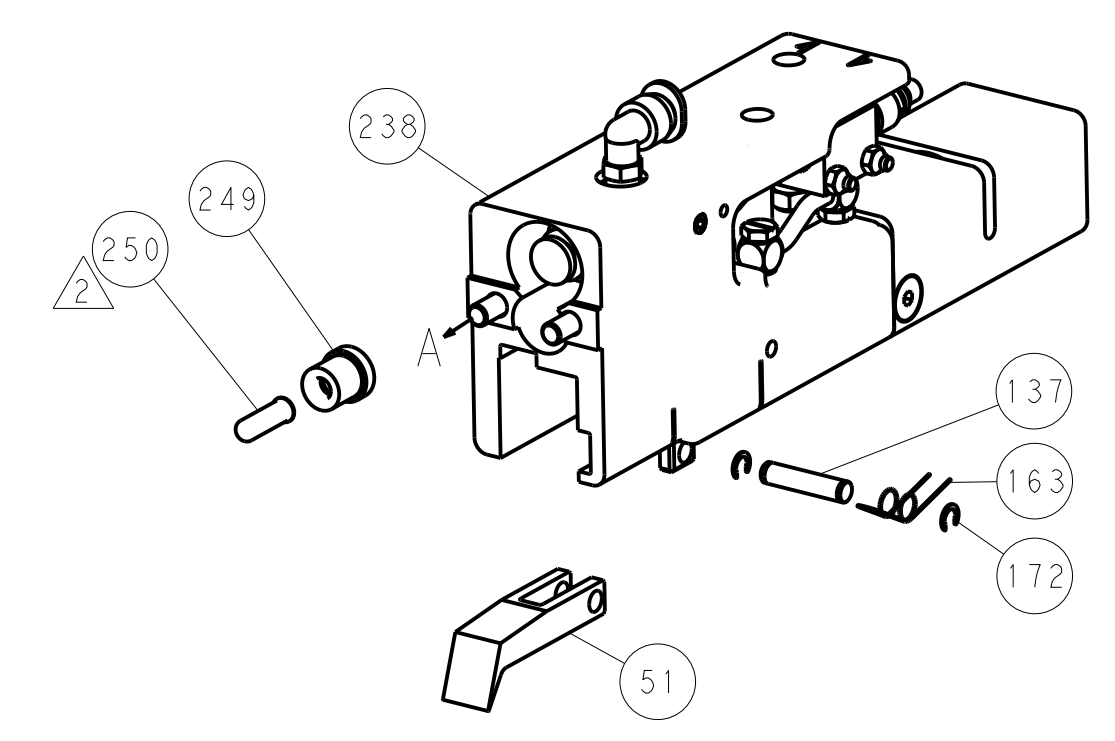
HOLDDOWN SET-UP



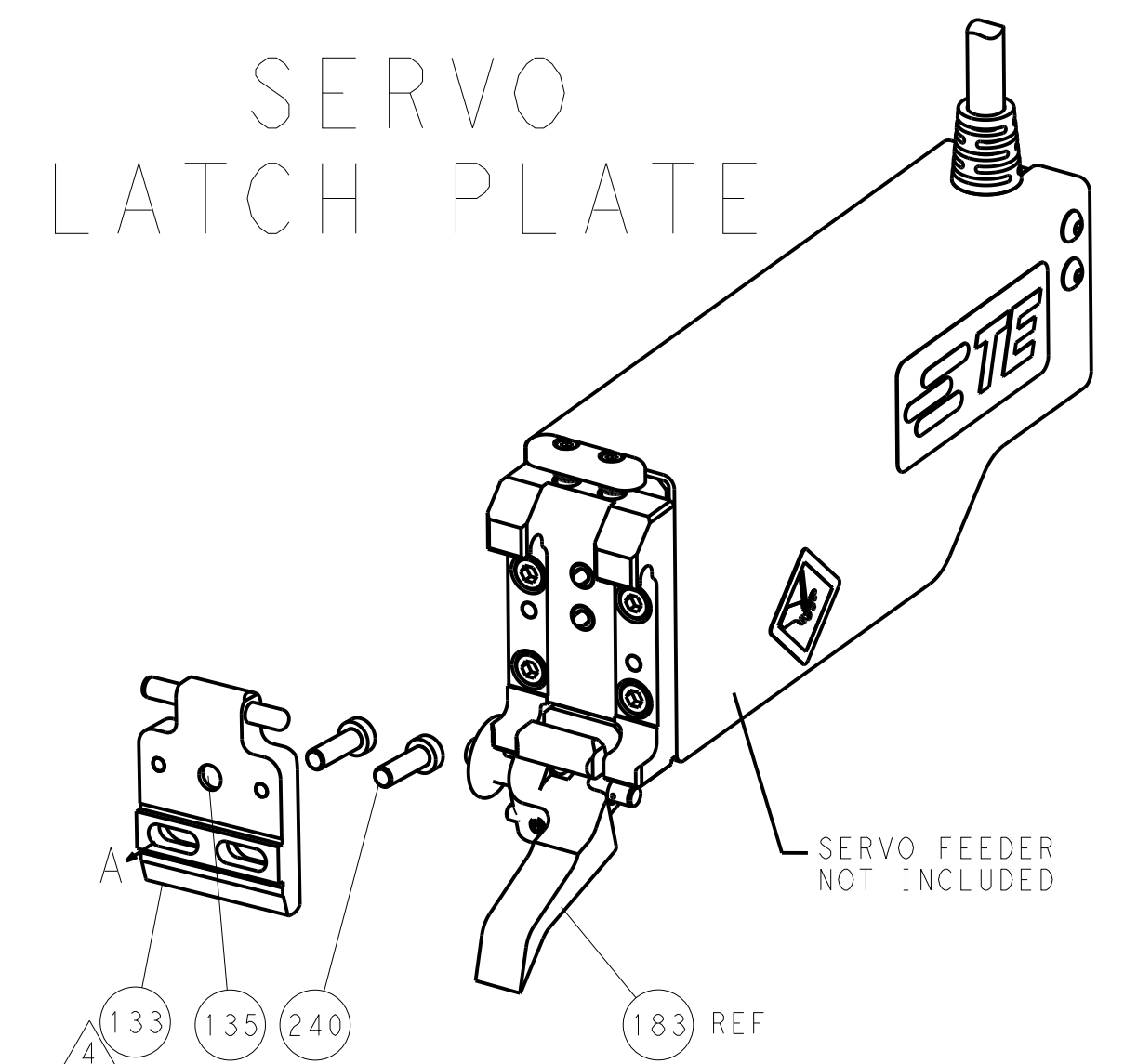
FEED TYPE
MECHANICAL



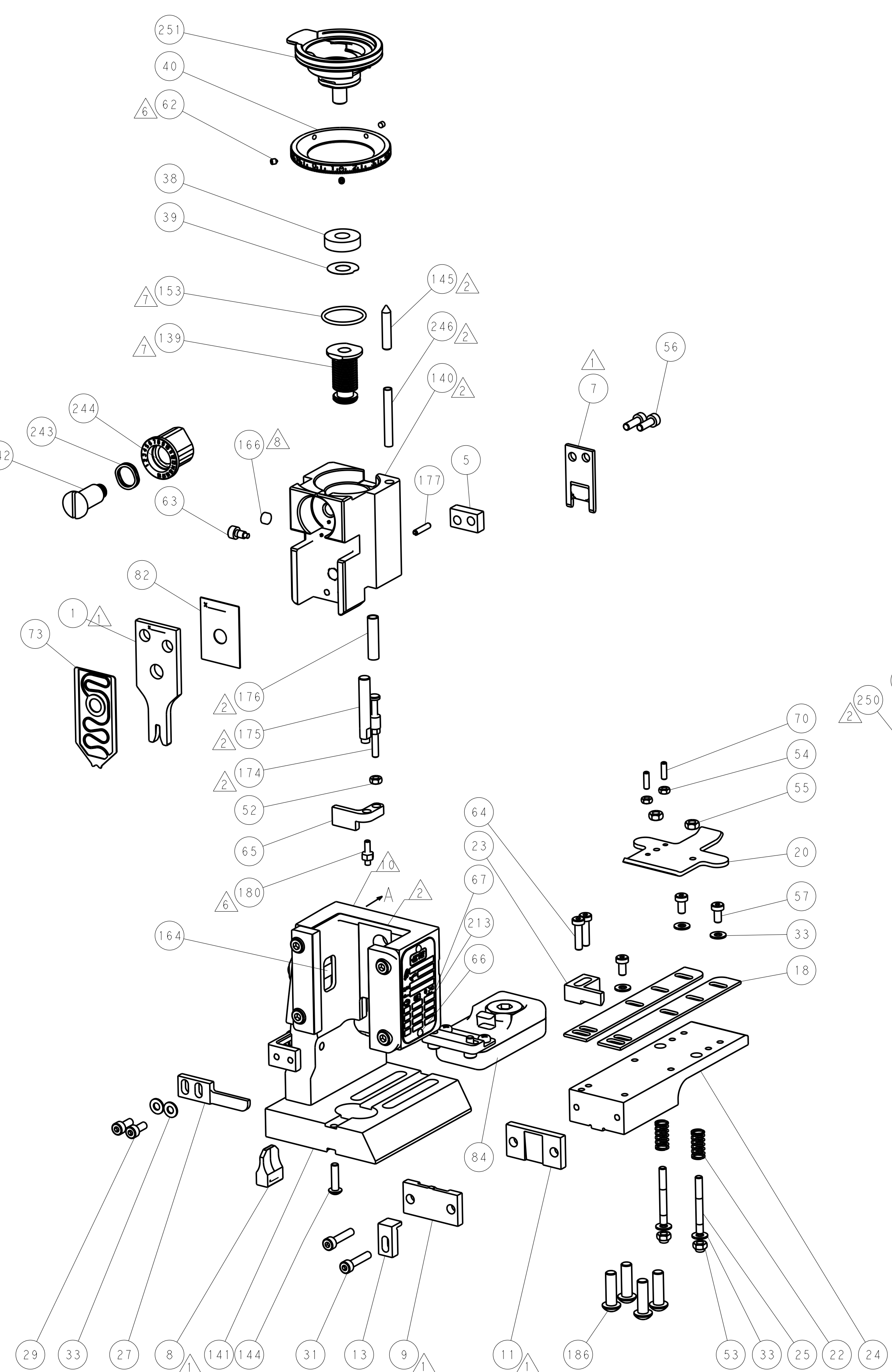
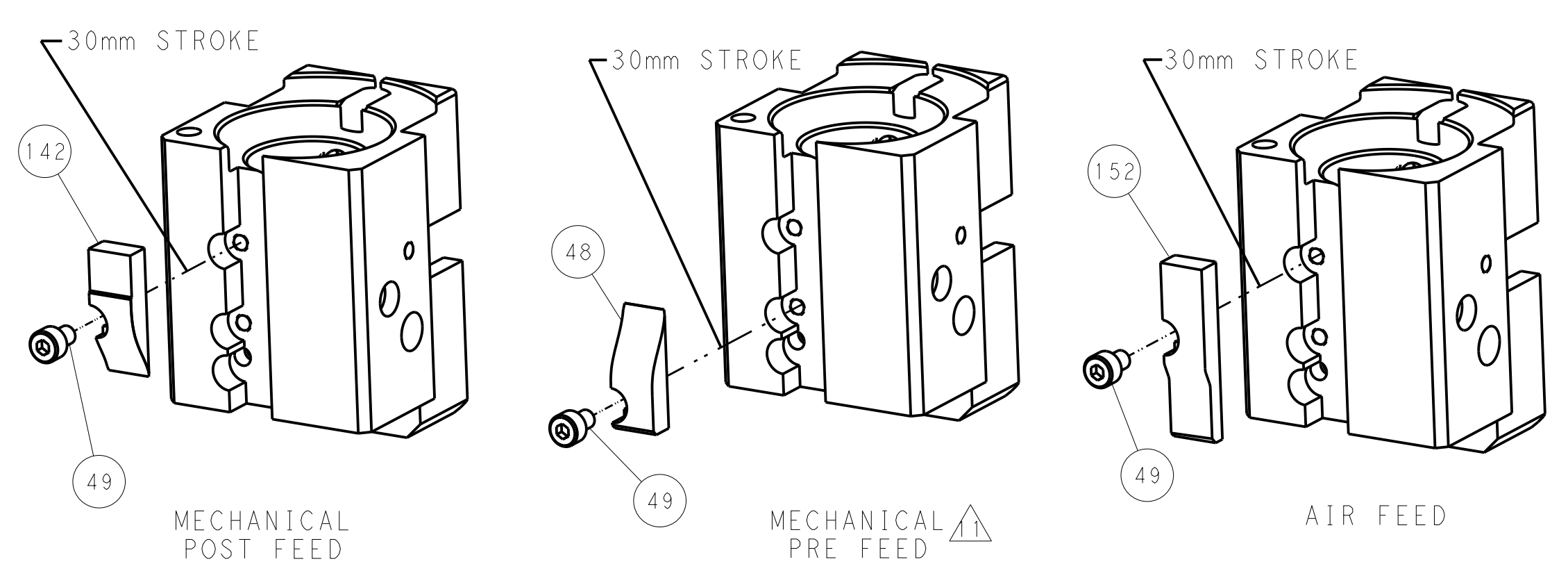
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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 ±.5 1 PLC ±.13 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES FINISH		DWN L.C. CHEN 06MAR2013 CHK U. GUO 06MAR2013 APVD J. CRUZ 06MAR2013		NAME Ocean End Feed Applicator	
MATERIAL		WEIGHT		SIZE A1		CAGE CODE 00779	
				DRAWING NO. C=2150086		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:1	
				SHEET 4 OF 4		REV B	

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