

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |   |                        |
|---|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
|   |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |   |                        |
|   | 2150199-1   | B        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-1 | - | 2063440-1              |
|   |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150199-5 | -         | - | 2168400-7 (QUANTITY 2) |
|   |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150199-4 | -         | - | -                      |
|   | 2150199-2   | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-1 | - | -                      |
|   |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150199-5 | -         | - | 2168400-7 (QUANTITY 2) |
|   |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150199-4 | -         | - | -                      |
|   | 2150199-5   | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-1 | - | -                      |
|   |             |          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-1 | - | 2063440-1              |
|   | 2150199-6   | B        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | -                                 | -                     | -         | -           | -         | - | -                      |
|   |             |          |                          |                                | -                                 | -                     | -         | -           | -         | - | -                      |
|   | 2150199-7   | B        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | - | -                      |
|   | 7-2150199-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | - | -                      |

| APPLICATOR DATA                   |                |      |
|-----------------------------------|----------------|------|
| CRIMP                             | SIZE           | TYPE |
| WIRE                              | 2.79 mm [.110] | F    |
| INSUL                             | 4.57 mm [.180] | F    |
| APPLICATOR INSTRUCTIONS 408-10390 |                |      |

| TERMINAL DATA: TE TERMINAL                            |             | TE CRIMP SPECIFICATION       |
|---|-------------|------------------------------|
| TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK, .250 SERIES |             |                              |
| WIRE STRIP LENGTH                                     |             | INSULATION DIAMETER RANGE    |
| 4.39-5.16 mm [.173-.203 IN]                           |             | Ø2.29-3.94 mm [.090-.155 IN] |
| TERMINAL APPLICATION SPECIFICATION                    | 114-2074    | -                            |
| TERMINALS APPLIED                                     |             |                              |
| TE TERMINAL   | TE TERMINAL | TE TERMINAL                  |
| 63854-1   | 63854-2     |                              |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 14 AWG    | 1.85 +/- 0.05 [.073 +/- .002] | 3.4                            |
| 16 AWG    | 1.63 +/- 0.05 [.064 +/- .002] | 5.6                            |
| 18 AWG    | 1.47 +/- 0.05 [.058 +/- .002] | 7.5                            |

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150199-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150199-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150199-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150199-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> 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.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> 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  | 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     |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO   | DESCRIPTION                     | ITEM NO |

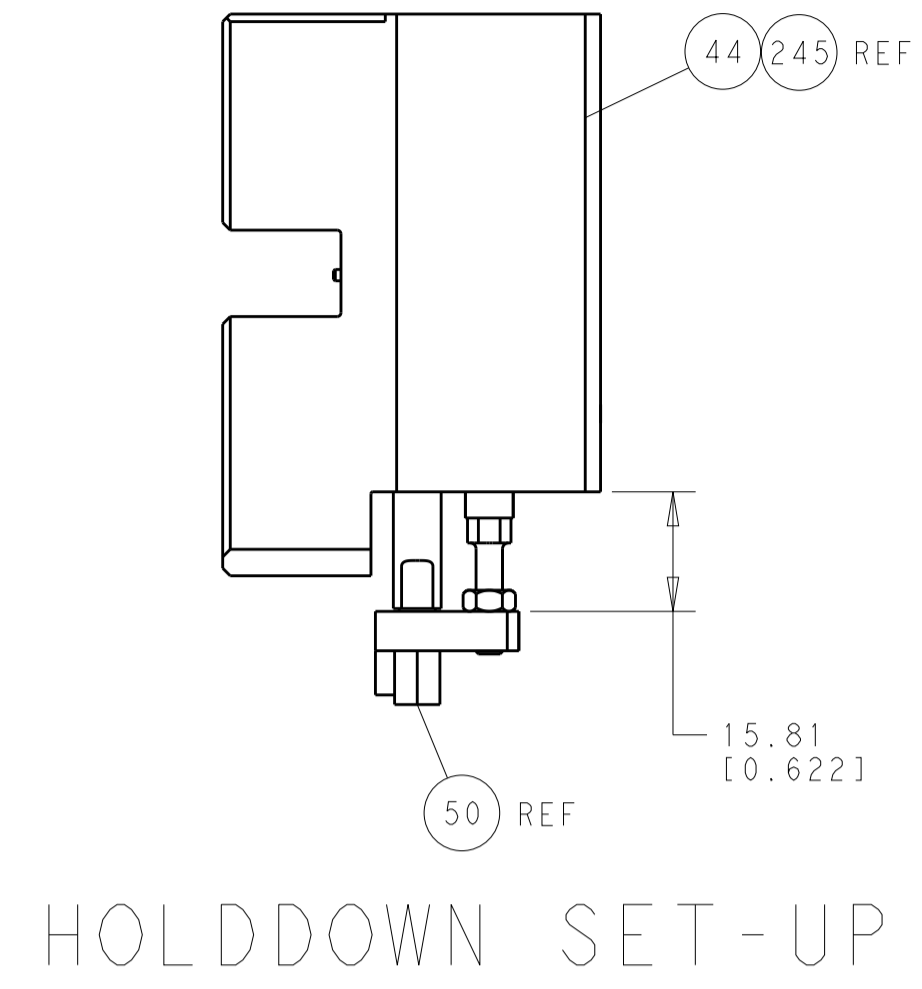
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS |     |               |           |     |      |
|--------------|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-2    | A   | 66   | P         | LTM | DESCRIPTION   | DATE      | OWN | APVD |
|              |     |      | A         |     | RELEASED      | 18MAR2012 | KH  | SX   |
|              |     |      | B         |     | ECR-14-003773 | 14MAR2014 | KH  | UG   |

|     |        |        |        |        |        |             |                                      |         |
|-----|--------|--------|--------|--------|--------|-------------|--------------------------------------|---------|
| -   | -      | 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     |
| -   | 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     |
| -   | 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     |
| -   | REFREF | REFREF | 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      | 1      | 455888-5    | SPACER, CRIMPER                      | 82      |
| -   | 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      | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20        | 64      |
| -   | 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      | 1      | 1      | 1      | 1      | 1-1752354-3 | STANDOFF, HOLD-DOWN                  | 50      |
| -   | -      | -      | -      | 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      | 1-2119644-2 | RAM WASHER, PRECISION                | 38      |
| -   | 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      | 1752371-1   | PLATE, STRIP GUIDE                   | 24      |
| -   | 1      | 1      | 1      | 1      | 1      | 240825-2    | 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      | 1901259-5   | GUIDE, LOWER STRIP                   | 18      |
| -   | 4      | 4      | 4      | 4      | 4      | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12)            | 17      |
| -   | 1      | 1      | 1      | 1      | 1      | 240641-6    | SPACER                               | 16      |
| -   | 1      | 1      | 1      | 1      | 1      | 1752360-1   | SPACER, HOLD-DOWN                    | 13      |
| -   | 1      | 1      | 1      | 1      | 1      | 240644-1    | PLATE, REAR SHEAR                    | 11      |
| -   | 1      | 1      | 1      | 1      | 1      | 690482-5    | PLATE, FRONT SHEAR                   | 9       |
| -   | 1      | 1      | 1      | 1      | 1      | 1-1803000-2 | ANVIL, COMBINATION, END FEED         | 8       |
| -   | 1      | 1      | 1      | 1      | 1      | 2217206-7   | BLADE, SLUG                          | 7       |
| -   | 1      | 1      | 1      | 1      | 1      | 4-240641-1  | SPACER                               | 5       |
| -   | 1      | 1      | 1      | 1      | 1      | 238009-4    | BLOCK, FL CRIMPER SPACER             | 4       |
| -   | 1      | 1      | 1      | 1      | 1      | 2-1633961-7 | CRIMPER, INSULATION F PREMIUM        | 3       |
| -   | 1      | 1      | 1      | 1      | 1      | 455888-8    | SPACER, CRIMPER                      | 2       |
| -   | 1      | 1      | 1      | 1      | 1      | 2-456408-8  | CRIMPER, WIRE PREMIUM                | 1       |
| -77 | -7     | -6     | -5     | -2     | -1     | PART NO     | DESCRIPTION                          | ITEM NO |

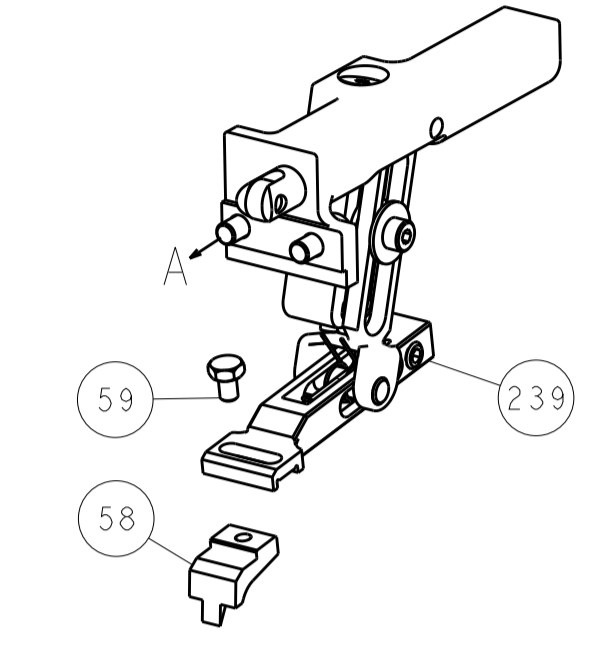
| DIMENSIONS: |              | TOLERANCES UNLESS OTHERWISE SPECIFIED: |               | OWN      | CHK        | DATE        | TE Connectivity                        |  |
|-------------|--------------|--|---------------|----------|------------|-------------|--|--|
| mm          | 0 PLC ±.5    | 1 PLC ±.3                              | 2 PLC ±.13    | H. HUANG | S. XI      | 07MAR2012   | Harrisburg, PA 17105-3608              |  |
|             | 3 PLC ±0.013 | 4 PLC ±0.001                           | ANGLES ±.0001 |          |            | 07MAR2012   | Ocean End Feed Applicator              |  |
| MATERIAL:   | FINISH:      | WEIGHT:                                | SCALE:        | SIZE:    | CAGE CODE: | DRAWING NO: | RESTRICTED TO:                         |  |
|             |              |  | 1:1           | A1       | 00779      | 2150199     | Customer Accessible Production Drawing |  |

| LOC       | DIST | REV | DATE        | BY   | APPV |
|-----------|------|-----|-------------|------|------|
| A         | 66   |     |             |      |      |
| REVISIONS |      |     | DESCRIPTION | DATE | BY   |
|           |      |     | SEE SHEET 1 |      |      |

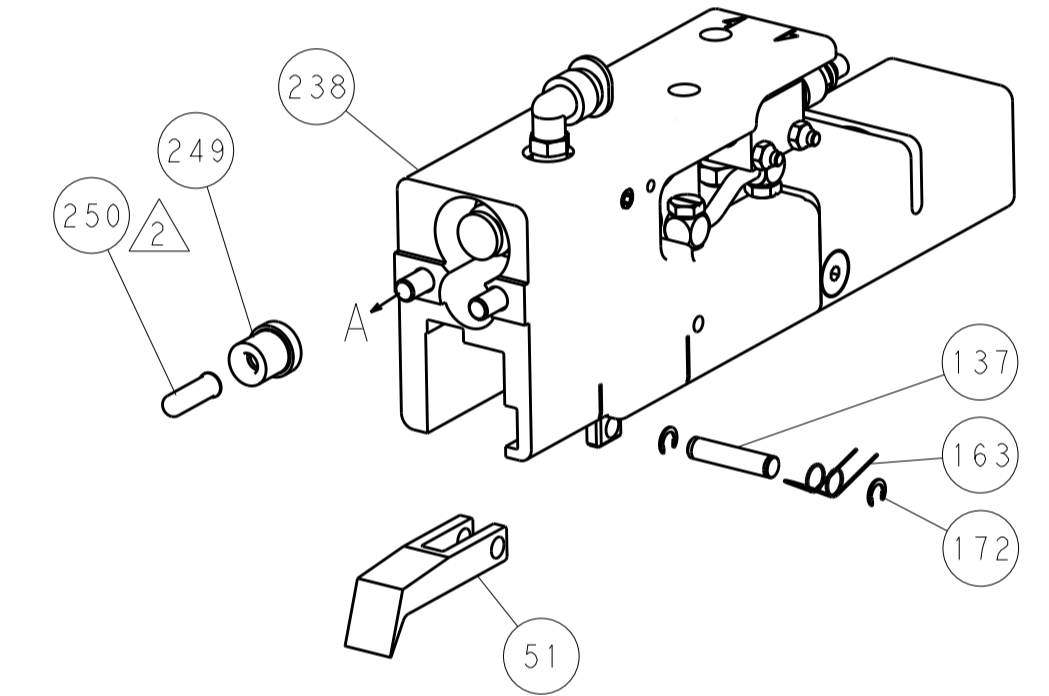


HOLDDOWN SET-UP

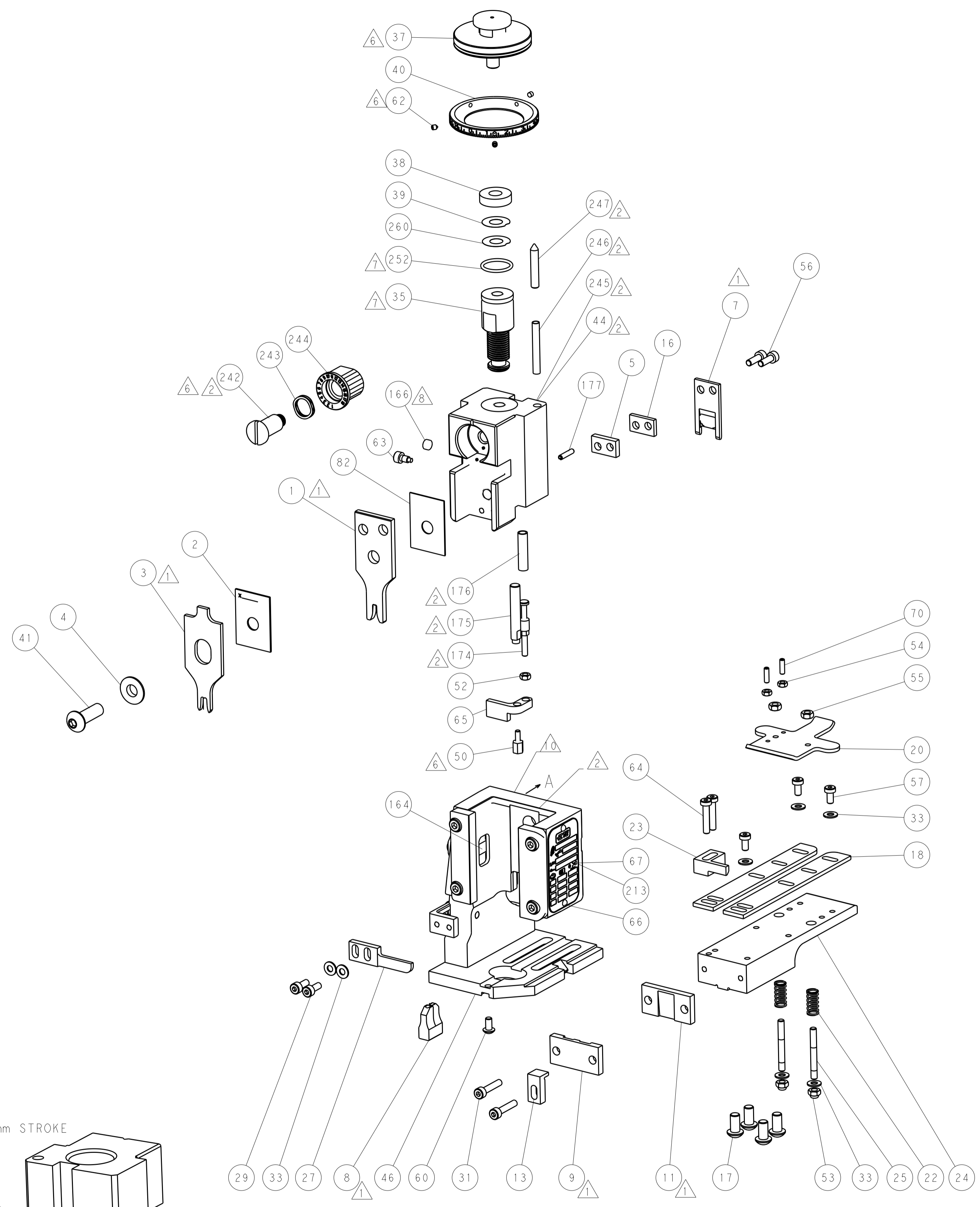
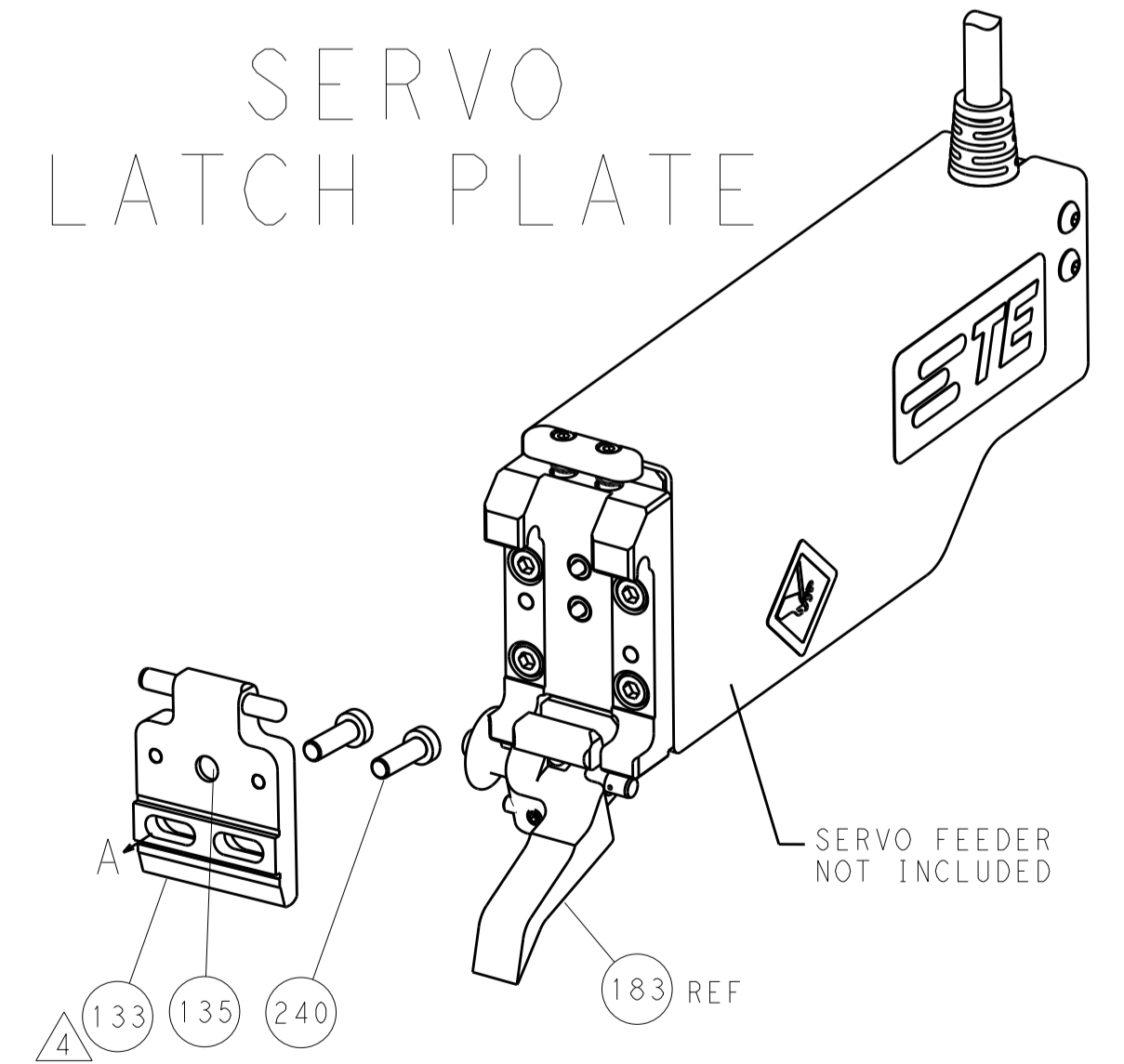
FEED TYPE  
 MECHANICAL



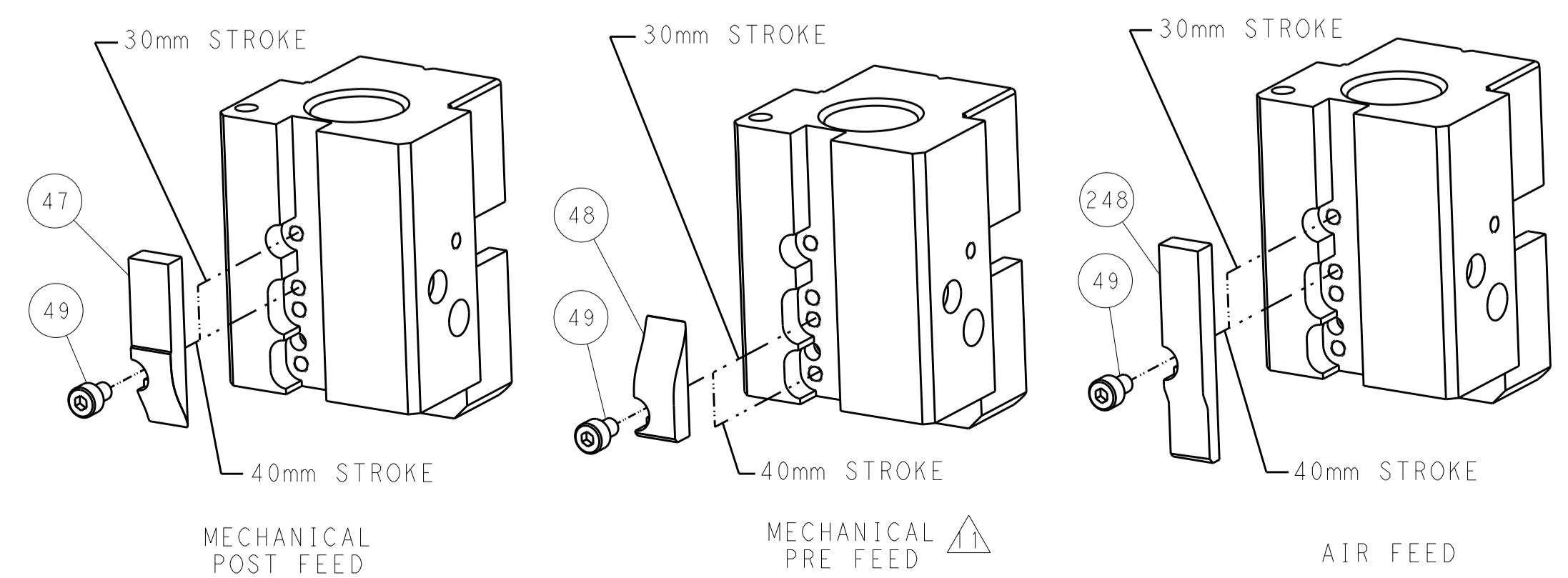
PNEUMATIC



SERVO  
 LATCH PLATE



CAM POSITIONS



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: |  | DWG: K. HUANG 07MAR2012                |  | TE Connectivity                 |  |
| mm          |  | 0 PLC ±0.5                             |  | CHK: S. XI 07MAR2012                   |  | Harrisburg, PA 17105-3608       |  |
| Ø           |  | 1 PLC ±0.13                            |  | APPV: S. XI 07MAR2012                  |  | NAME: Ocean End Feed Applicator |  |
| H           |  | 3 PLC ±0.013                           |  | PRODUCT SPEC                           |  | SIZE: CAGE CODE DRAWING NO      |  |
| ANGLES      |  | 4 PLC ±0.0001                          |  | APPLICATION SPEC                       |  | RESTRICTED TO                   |  |
| FINISH      |  | 5 PLC ±0.0001                          |  | WEIGHT                                 |  | A11 00779 ©=2150199             |  |
| MATERIAL    |  | 6 PLC ±0.0001                          |  | Customer Accessible Production Drawing |  | SCALE: 1:1 SHEET 2 OF 4 REV B   |  |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |   |                        |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
|  |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |   |                        |
|  | 2-2150199-1 | B        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-2 | - | 2063440-1              |
|  |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150199-5 | -         | - | 2168400-7 (QUANTITY 2) |
|  |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150199-4 | -         | - | -                      |
|  | 2-2150199-2 | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-2 | - | -                      |
|  |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150199-5 | -         | - | 2168400-7 (QUANTITY 2) |
|  |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150199-4 | -         | - | -                      |
|  | 2-2150199-5 | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-2 | - | -                      |
|  |             |          |                          |                   | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-2 | - | 2063440-1              |
|  | 2-2150199-7 | B        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | - | -                      |
|  | 7-2150199-7 | A        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -         | -           | -         | - | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.79 mm (.110) | F    |
| INSUL                                | 4.57 mm (.180) | F    |
| APPLICATOR INSTRUCTIONS<br>408-10390 |                |      |

| TERMINAL DATA: TE TERMINAL                            |                        | TE CRIMP SPECIFICATION                                    |
|---|------------------------|---|
| TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK, .250 SERIES |                        |   |
| WIRE STRIP LENGTH<br>4.39-5.16 mm (.173-.203 IN)      |                        | INSULATION DIAMETER RANGE<br>Ø2.29-3.94 mm (.090-.155 IN) |
| TERMINAL APPLICATION SPECIFICATION<br>114-2074        |                        |   |
| TERMINALS APPLIED                                     |                        |   |
| TE TERMINAL<br>63854-1                                | TE TERMINAL<br>63854-2 |   |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 14 AWG    | 1.85 +/- 0.05 [.073 +/- .002] | 3.4                            |
| 16 AWG    | 1.63 +/- 0.05 [.064 +/- .002] | 5.6                            |
| 18 AWG    | 1.47 +/- 0.05 [.058 +/- .002] | 7.5                            |

- 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150199-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150199-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150199-5
- 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 50, 62 & 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.

|                 | ITEM NO   | DESCRIPTION                         | ITEM NO |
|-----------------|-----------|-------------------------------------|---------|
| - 1 1 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 1     | 1-22279-3 | SPRING, COMPRESSION                 | 246     |
| - 1 1 1 1 1     | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -77-27-25-22-21 | 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)

| SET UP GAUGE | LOC | DIST | REVISIONS |             |    |      |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-2    | A   | 66   | REV       | DATE        | BY | APPV |
|              |     |      | -         | SEE SHEET 1 | -  | -    |

|                 |             |                                     |         |
|-----------------|-------------|-------------------------------------|---------|
| - 1 1 1 1 1     | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| - 1 1 1 1 1     | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
| - - 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 - -       | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| - 4 4 4 4       | 2079383-9   | SCR, BHSC, RoHS (M6 X 20)           | 186     |
| - - REF - -     | 1901697-1   | FEED FINGER ASSEMBLY, EF            | 183     |
| - 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     |
| - REFREFREFREF  | 994970-2    | COUNTER, MAGNETIC                   | 164     |
| - - - 1 -       | 240638-1    | SPRING, FEED FINGER                 | 163     |
| - 1 1 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 1 1     | 2119798-2   | DETENT PIN                          | 145     |
| - 1 1 1 1 1     | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144     |
| - - - - 1       | 2119653-2   | FEED CAM, POST FEED                 | 142     |
| - 1 1 1 1 1     | 2119655-6   | APPLICATOR BASIC ASSEMBLY, EF       | 141     |
| - 1 1 1 1 1     | 2119651-1   | RAM, ASIAN STYLE, END FEED          | 140     |
| - 1 1 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 1 1     | 455888-5    | SPACER, CRIMPER                     | 82      |
| - 1 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     | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| - 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       | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       | 64      |
| - 1 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       | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| - - - - 1       | 2063961-1   | FEED FINGER                         | 58      |
| - 3 3 3 3       | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8        | 57      |
| - 2 2 2 2       | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 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     | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52      |
| - - - 1 -       | 2119792-2   | PAWL, EF, AIR                       | 51      |
| - 1 1 1 1 1     | 1-1752354-3 | STANDOFF, HOLD-DOWN                 | 50      |
| - - - 1 2       | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| - - - - 1       | 2119652-1   | FEED CAM, PRE FEED                  | 48      |
| - 1 1 1 1 1     | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
| - 1 1 1 1 1     | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40      |
| - 1 1 1 1 1     | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
| - 1 1 1 1 1     | 1-2119644-2 | RAM WASHER, PRECISION               | 38      |
| - 7 7 7 7       | 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 1     | 240639-1    | STRIPPER (MACHINING)                | 27      |
| - 2 2 2 2       | 1320906-1   | STUD, THREADED                      | 25      |
| - 1 1 1 1 1     | 1752371-1   | PLATE, STRIP GUIDE                  | 24      |
| - 1 1 1 1 1     | 240825-2    | PLATE, STRIP HOLD DOWN              | 23      |
| - 2 2 2 2       | 2-22281-3   | SPRING, COMPRESSION                 | 22      |
| - 1 1 1 1 1     | 1752373-4   | DRAG                                | 20      |
| - 2 2 2 2       | 1901259-5   | GUIDE, LOWER STRIP                  | 18      |
| - 1 1 1 1 1     | 240641-6    | SPACER                              | 16      |
| - 1 1 1 1 1     | 1752360-1   | SPACER, HOLD-DOWN                   | 13      |
| - 1 1 1 1 1     | 240644-1    | PLATE, REAR SHEAR                   | 11      |
| - 1 1 1 1 1     | 690482-5    | PLATE, FRONT SHEAR                  | 9       |
| 1 1 1 1 1 1     | 1-1803000-2 | ANVIL, COMBINATION, END FEED        | 8       |
| - 1 1 1 1 1     | 2217206-7   | BLADE, SLUG                         | 7       |
| - 1 1 1 1 1     | 4-240641-1  | SPACER                              | 5       |
| - 1 1 1 1 1     | 238009-4    | BLOCK, FL CRIMPER SPACER            | 4       |
| 1 1 1 1 1 1     | 2-1633961-7 | CRIMPER, INSULATION F PREMIUM       | 3       |
| - 1 1 1 1 1     | 455888-8    | SPACER, CRIMPER                     | 2       |
| 1 1 1 1 1 1     | 2-456408-8  | CRIMPER, WIRE PREMIUM               | 1       |
| -77-27-25-22-21 | PART NO     | DESCRIPTION                         | ITEM NO |

| DIMENSIONS: |               | TOLERANCES UNLESS OTHERWISE SPECIFIED: |           | DATE                                   |           |
|-------------|---------------|--|-----------|--|-----------|
| mm          | 0 PLC ±.5     | 1 PLC ±.5                              | 2 PLC ±.5 | 3 PLC ±.5                              | 4 PLC ±.5 |
|             | ANGLES ±.0001 |  |           |  |           |
| MATERIAL:   |               | FINISH:                                |           | WEIGHT:                                |           |
|             |               |  |           | Customer Accessible Production Drawing |           |

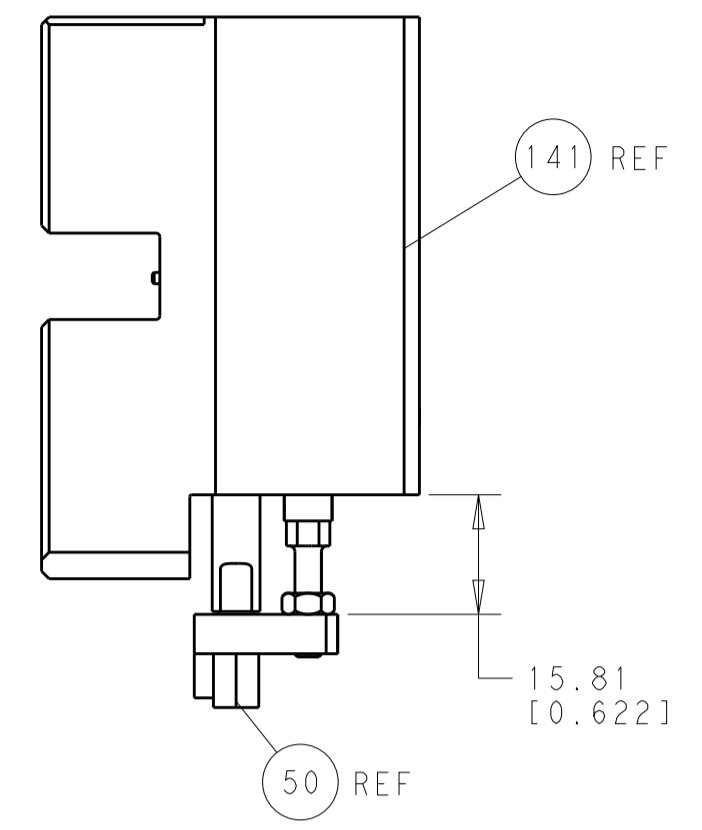
| CHK      | DATE      | NAME |
|----------|-----------|------|
| H. HUANG | 07MAR2012 |      |
| S. XI    | 07MAR2012 |      |
| S. XI    | 07MAR2012 |      |

**STE** TE Connectivity  
 Harrisburg, PA 17105-3608

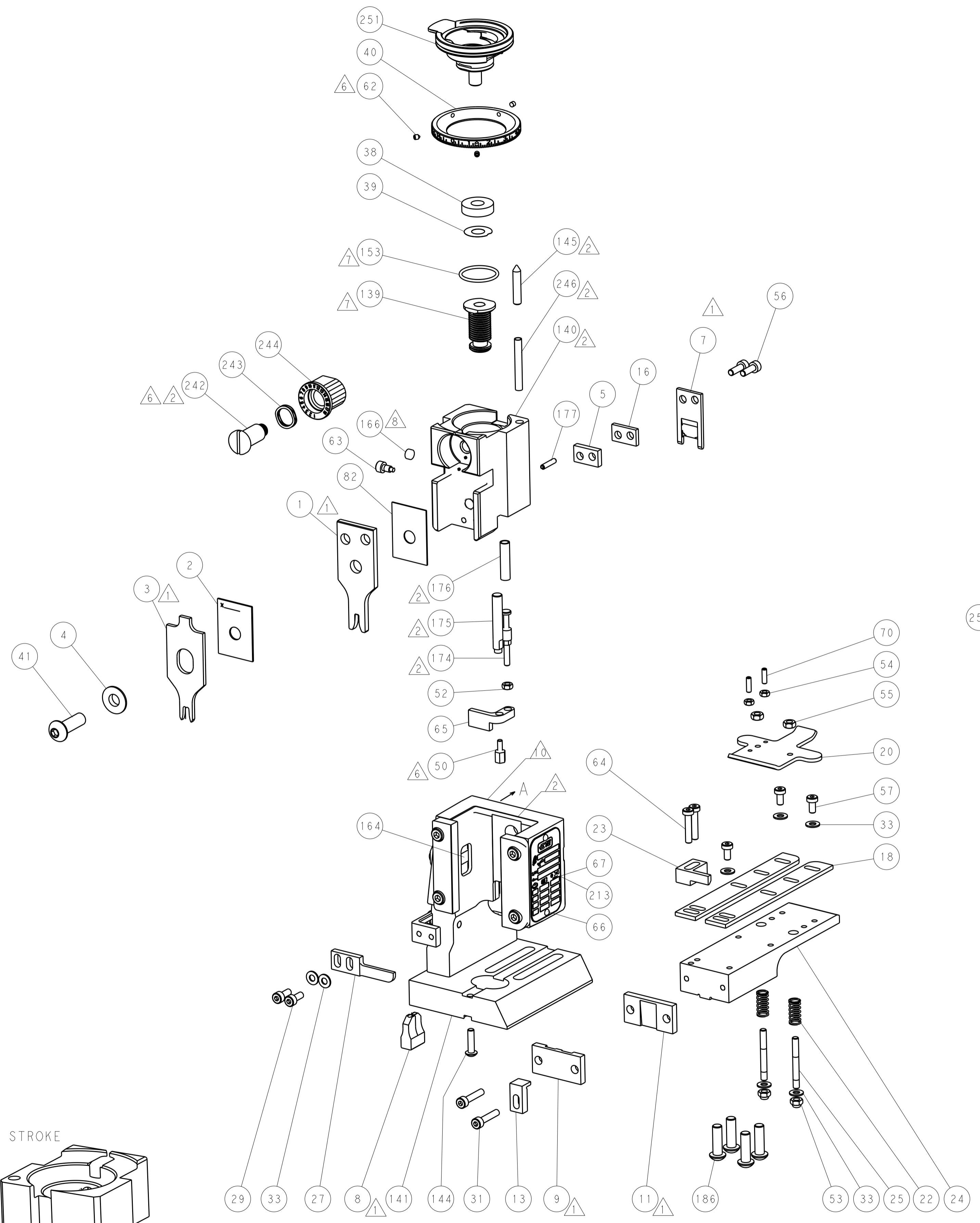
Ocean End Feed  
 Applicator

SIZE: A1 CASE CODE: 00779 DRAWING NO: C=2150199  
 RESTRICTED TO: B

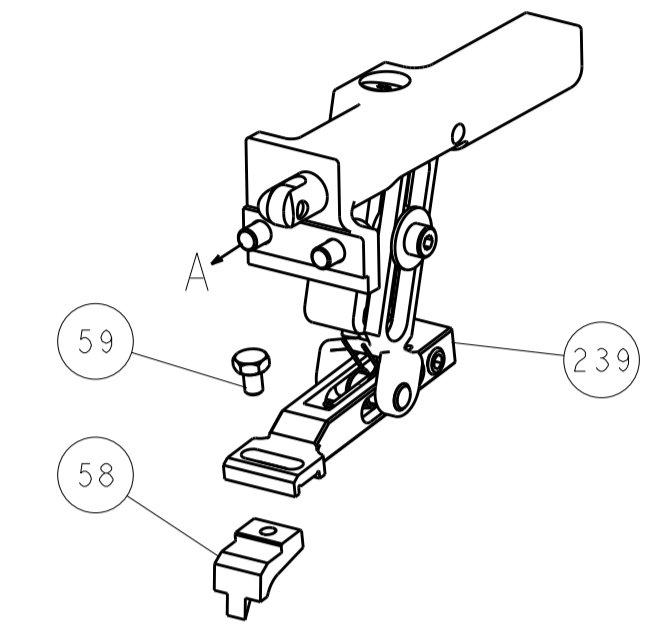
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | DWN | APVD |
|     |    |      |     | SEE SHEET 1 |      |     |      |



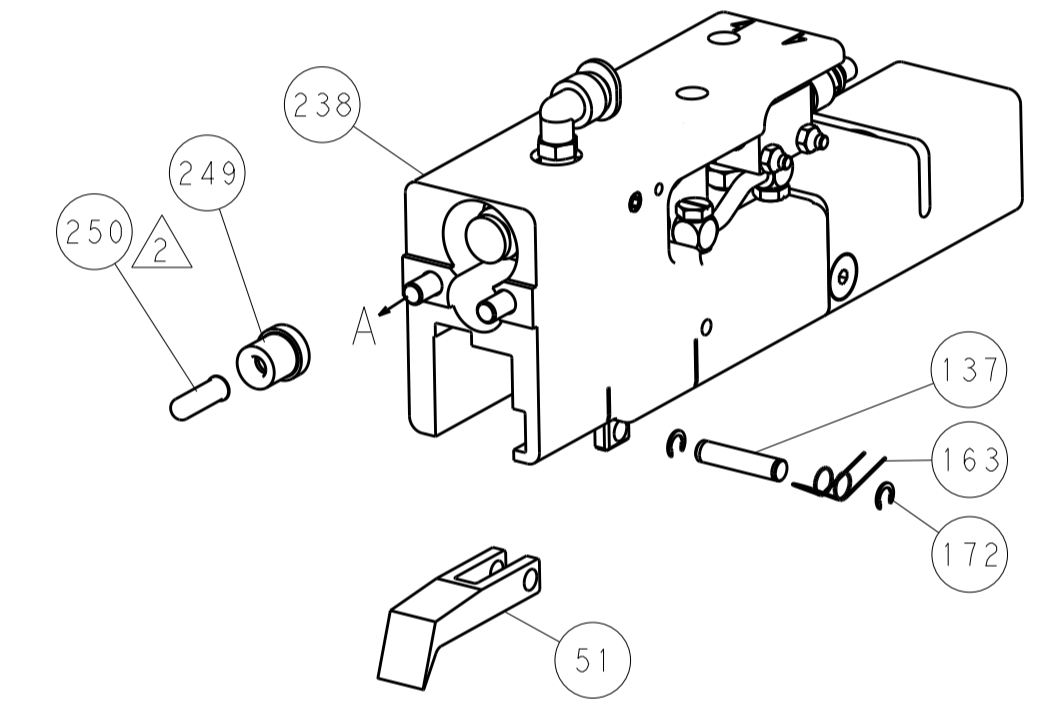
HOLDDOWN SET-UP



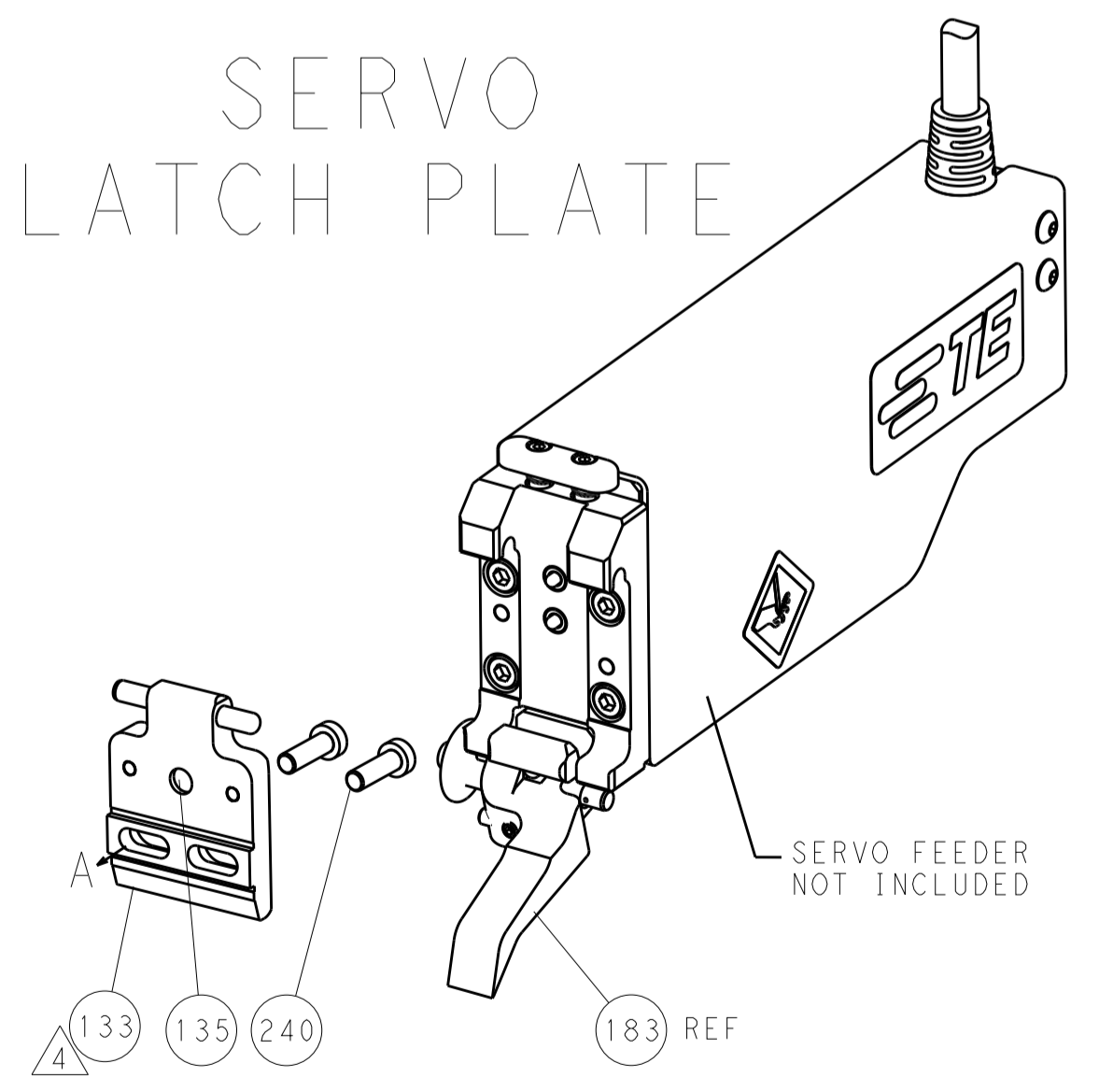
FEED TYPE  
MECHANICAL



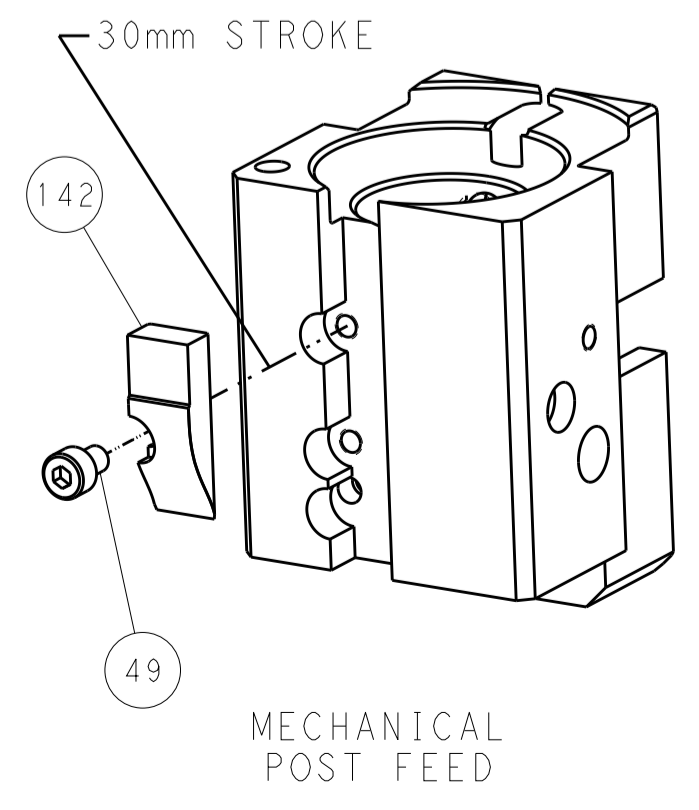
PNEUMATIC



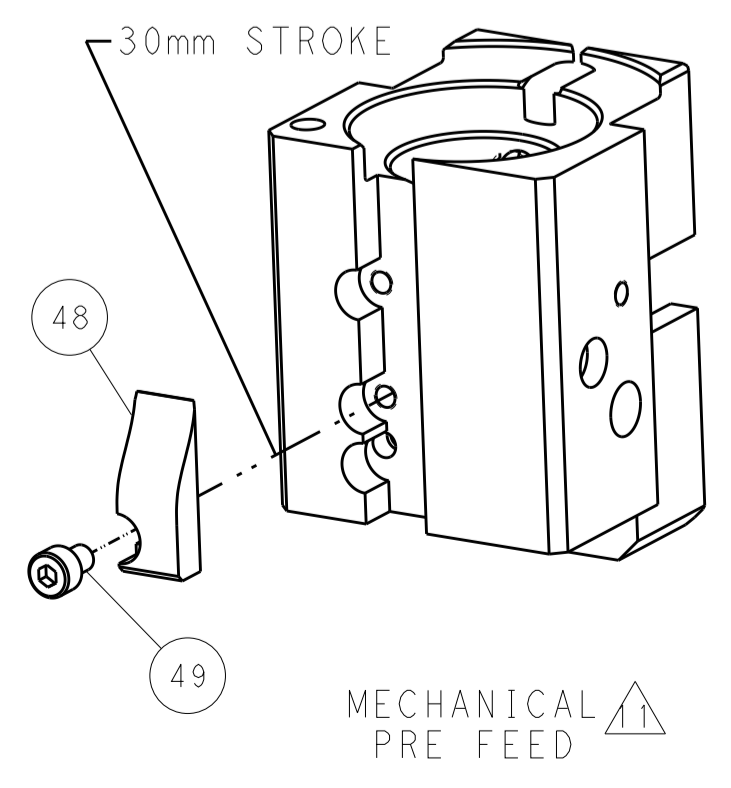
SERVO  
LATCH PLATE



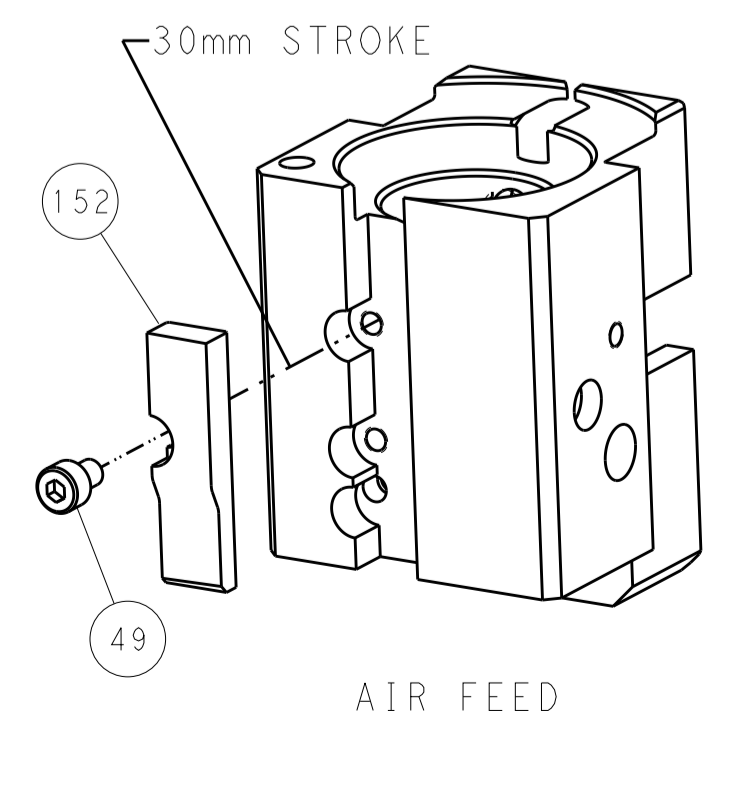
CAM POSITIONS



MECHANICAL  
POST FEED



MECHANICAL  
PRE FEED



AIR FEED

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

|             |            |  |             |  |                                 |                     |                           |
|-------------|------------|--|-------------|--|---------------------------------|---------------------|---------------------------|
| DIMENSIONS: |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DWN: L. HUANG 07MAR2012                |                                 | STE TE Connectivity |                           |
| mm          | 0 PLC ±0.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.13                            | 4 PLC ±0.013                    | 5 PLC ±0.001        | Harrisburg, PA 17105-3608 |
|             | ANGLES     |  |             | APVD: S. XI 07MAR2012                  | NAME: Ocean End Feed Applicator | SIZE: A1            | CAGE CODE: 00779          |
| MATERIAL:   | FINISH:    | WEIGHT:                                | SCALE: 1:1  | Customer Accessible Production Drawing | RESTRICTED TO:                  | SHEET 4 OF 4 REV B  |                           |

## Данный компонент на территории Российской Федерации

### Вы можете приобрести в компании MosChip.

Для оперативного оформления запроса Вам необходимо перейти по данной ссылке:

<http://moschip.ru/get-element>

Вы можете разместить у нас заказ для любого Вашего проекта, будь то серийное производство или разработка единичного прибора.

В нашем ассортименте представлены ведущие мировые производители активных и пассивных электронных компонентов.

Нашей специализацией является поставка электронной компонентной базы двойного назначения, продукции таких производителей как XILINX, Intel (ex.ALTERA), Vicor, Microchip, Texas Instruments, Analog Devices, Mini-Circuits, Amphenol, Glenair.

Сотрудничество с глобальными дистрибьюторами электронных компонентов, предоставляет возможность заказывать и получать с международных складов практически любой перечень компонентов в оптимальные для Вас сроки.

На всех этапах разработки и производства наши партнеры могут получить квалифицированную поддержку опытных инженеров.

Система менеджмента качества компании отвечает требованиям в соответствии с ГОСТ Р ИСО 9001, ГОСТ РВ 0015-002 и ЭС РД 009

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