

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED						
	2150076-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	2063961-1	-	-	-	-	
	2150076-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150076-5	-	-	2168400-7 (QUANTITY 2)	
	2150076-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ¹¹	-	-	2063961-1	-	-	-	-	
	2150076-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
	7-2150076-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.79 mm [.110]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MIC IV TAB 2.8 X 0.8 CRIMP CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.00-6.00 mm [.197-.236 IN]	Ø1.20-2.10 mm [.047-.083 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)114-15034	-	-
	(B)114-15004	-	-
TERMINALS APPLIED ¹⁰			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 142754-1	(A) 142754-2	(B) 142184-1	(B) 142184-2
(B) 142184-3	(B) 142184-4	(B) 142184-5	(B) 1-142184-1
(B) 2-142184-1	(B) 3-142184-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.48+/-0.05 [.058+/-0.002]	4.0
0.75mm2	1.41+/-0.05 [.056+/-0.002]	4.5
0.60mm2	1.32+/-0.05 [.052+/-0.002]	5.7
0.50mm2	1.27+/-0.05 [.050+/-0.002]	6.2
0.35mm2	1.21+/-0.05 [.048+/-0.002]	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: 8-2150076-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150076-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150076-6
- 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 180, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- 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.

-	-	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
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

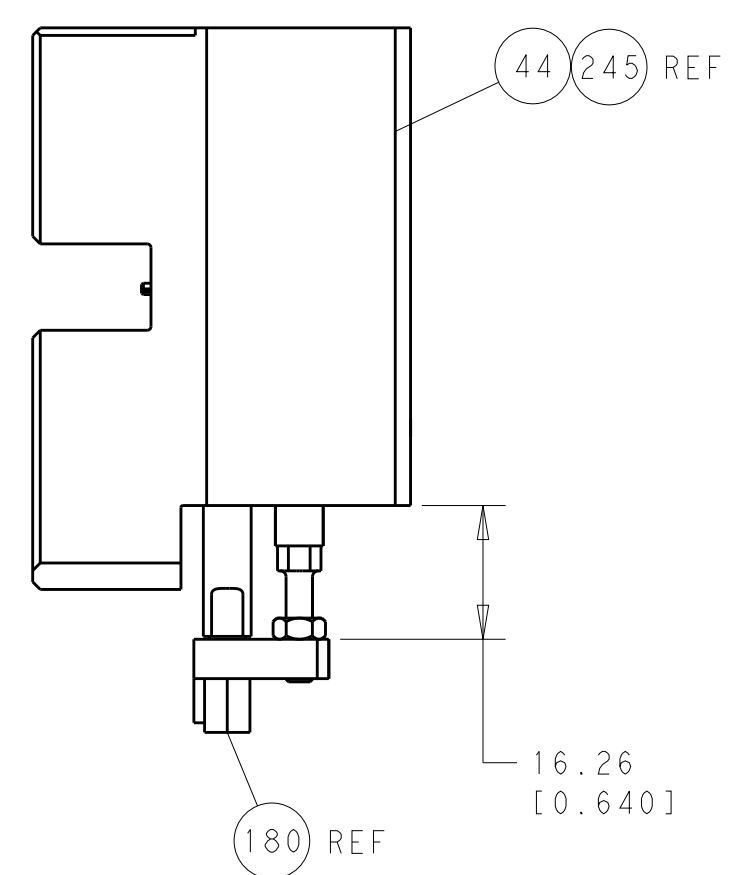
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
			A		RELEASE	15JUL2013	XZ	TE

-	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	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REF	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1-1752354-3	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	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	3-1976053-0	LOCATER BLOCK, TERMINAL	86
-	2	2	2	2	2079383-1	SCR, BHSC, RoHS (M3 X 8)	85
-	1	1	1	1	455888-7	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	1-1901681-5	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	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
-	3	3	3	3	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	2119369-1	RAM, AMP STYLE, END FEED	44
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	-	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	-	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	-	1	2119092-1	BOLT, ADJUSTMENT	35
-	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	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1752371-8	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4	DRAG	20
-	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	2-240641-2	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240833-7	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690482-5	PLATE, FRONT SHEAR	9
-	1	1	1	1	1338686-1	ANVIL, COMBINATION	8
-	1	1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-240641-5	SPACER	5
-	1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	1	1	3-456404-9	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5	5 PLC ±.5	6 PLC ±.5	7 PLC ±.5	8 PLC ±.5	9 PLC ±.5	10 PLC ±.5
	ANGLES ±.0001										
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	OF	REV	A	Customer Accessible Production Drawing			

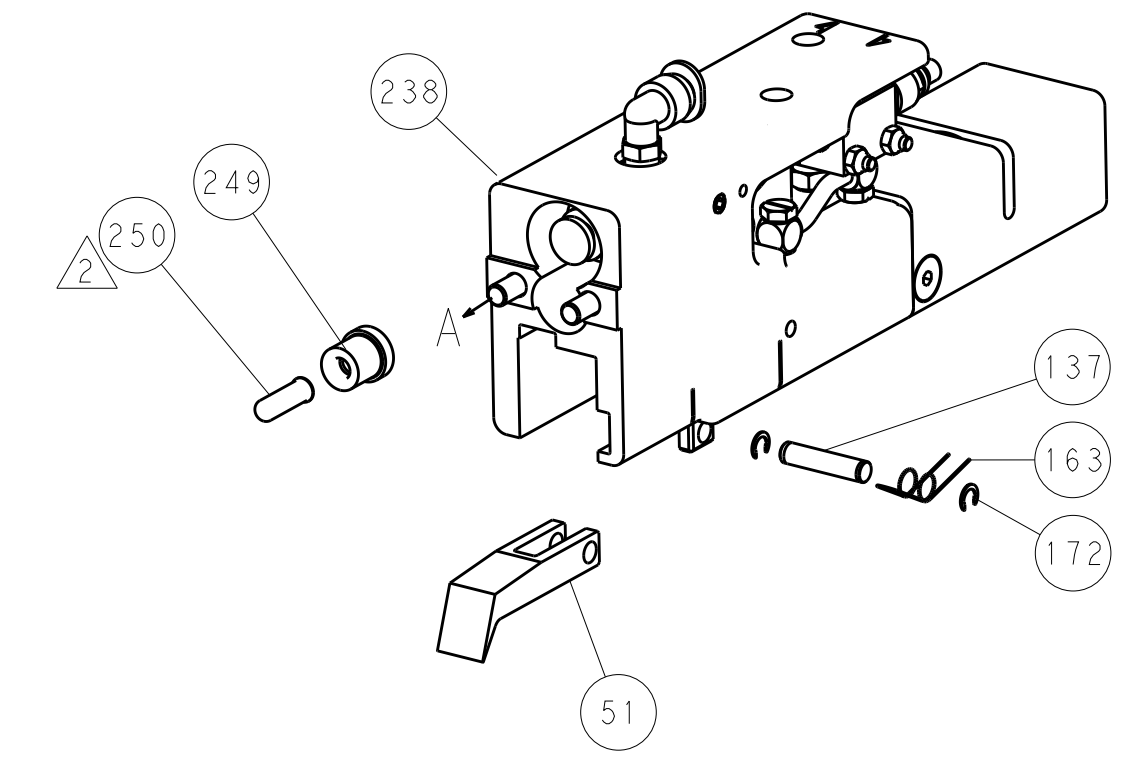
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A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



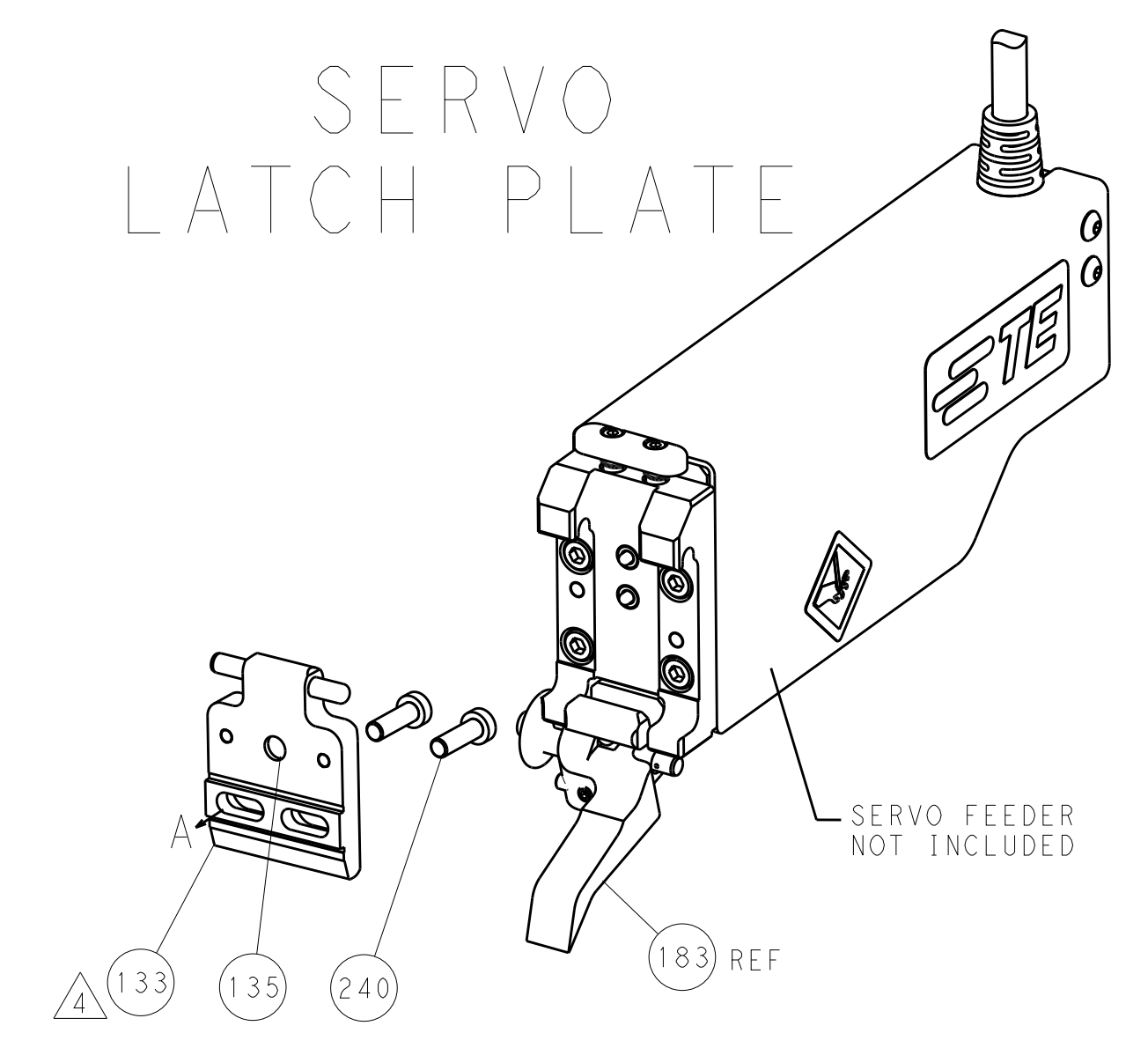
HOLDDOWN SET-UP

FEED TYPE

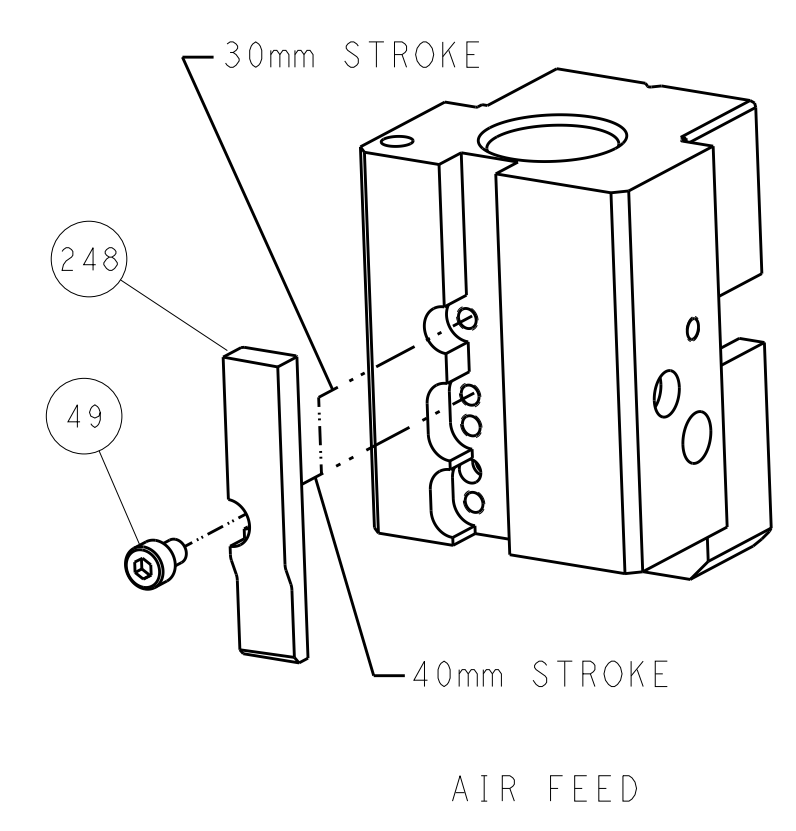
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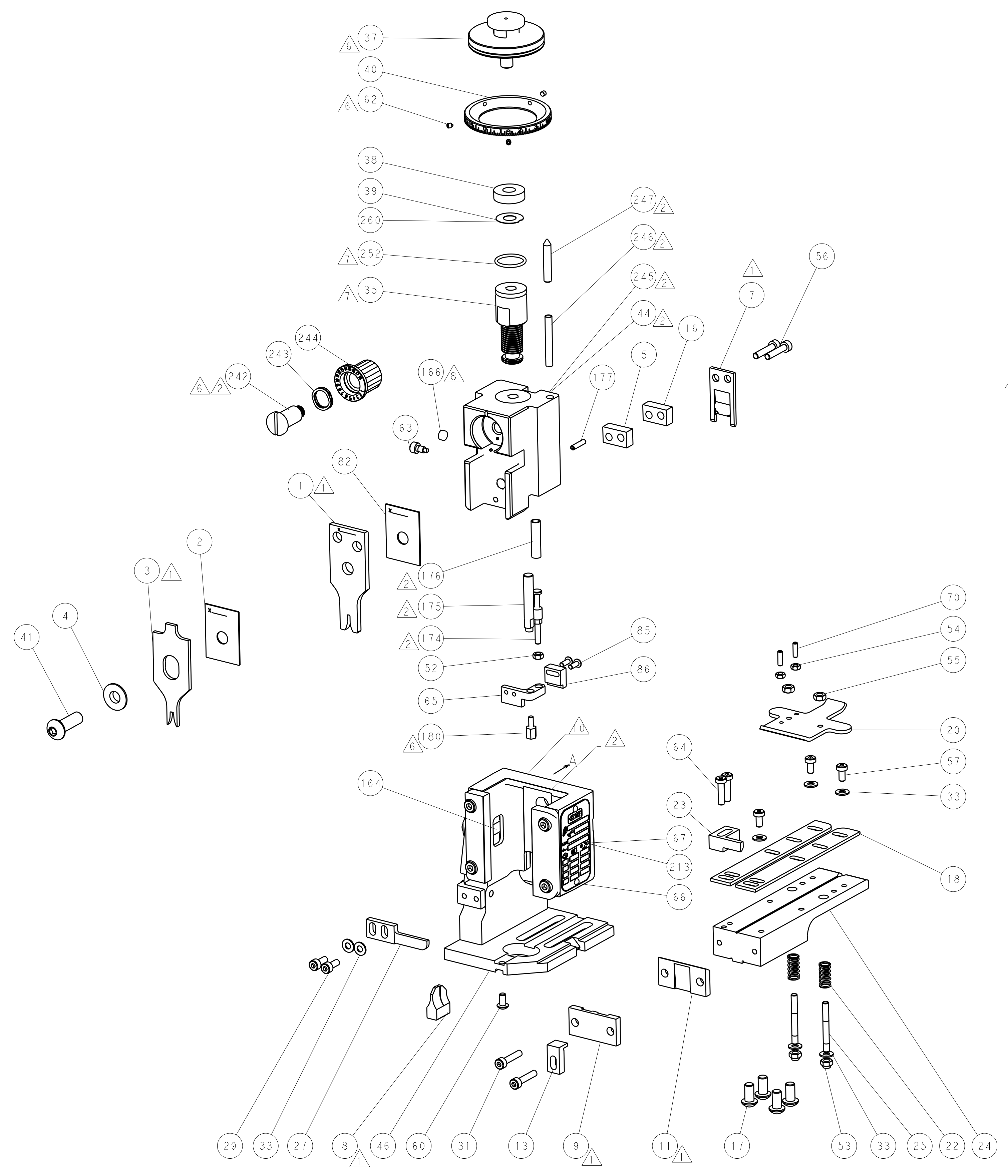
SERVO LATCH PLATE



CAM POSITION

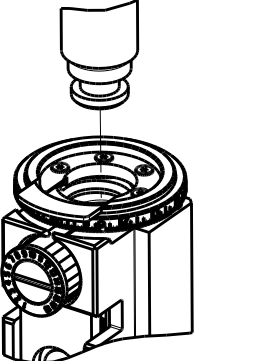



AIR FEED



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


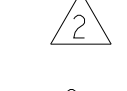

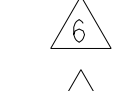

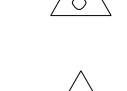
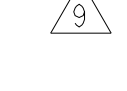

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X.ZHAO 23MAY2013		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD T.ELBIN 23MAY2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME		Ocean End Feed Applicator	
				SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
				A1 00779 C=2150076			
				Customer Accessible Production Drawing		SCALE 1:1 SHEET 2 OF 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150076-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	2063961-1	-	-	-	-
					SERVO LATCH PLATE SMART APPLICATOR	2119951-1	1901697-1	8-2150076-5	-	-
	2-2150076-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	2063961-1	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-
	2-2150076-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-
7-2150076-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm (.070)	F
INSUL	2.79 mm (.110)	F
APPL INSTRUCTIONS 408-10390 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MIC IV TAB 2.8 X 0.8 CRIMP CONTACT			
WIRE STRIP LENGTH 5.00-6.00 mm (.197-.236 IN)		INSULATION DIAMETER RANGE Ø1.20-2.10 mm (.047-.083 IN)	
TERMINAL APPLICATION SPECIFICATION	(A)114-15034	-	-
	(B)114-15004	-	-
TERMINALS APPLIED ¹⁰			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 142754-1	(A) 142754-2	(B) 142184-1	(B) 142184-2
(B) 142184-3	(B) 142184-4	(B) 142184-5	(B) 1-142184-1
(B) 2-142184-1	(B) 3-142184-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
1.00mm2	1.48+/-0.05 [.058+/-0.002]	4.0
0.75mm2	1.41+/-0.05 [.056+/-0.002]	4.5
0.60mm2	1.32+/-0.05 [.052+/-0.002]	5.7
0.50mm2	1.27+/-0.05 [.050+/-0.002]	6.2
0.35mm2	1.21+/-0.05 [.048+/-0.002]	6.8

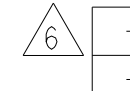
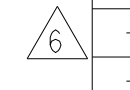
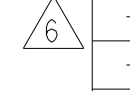
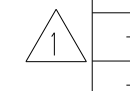
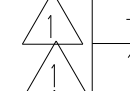
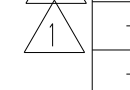
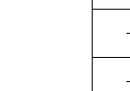
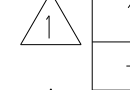
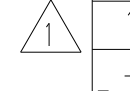
-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150076-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150076-5
- 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 180, 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.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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
-	-	-	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	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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)

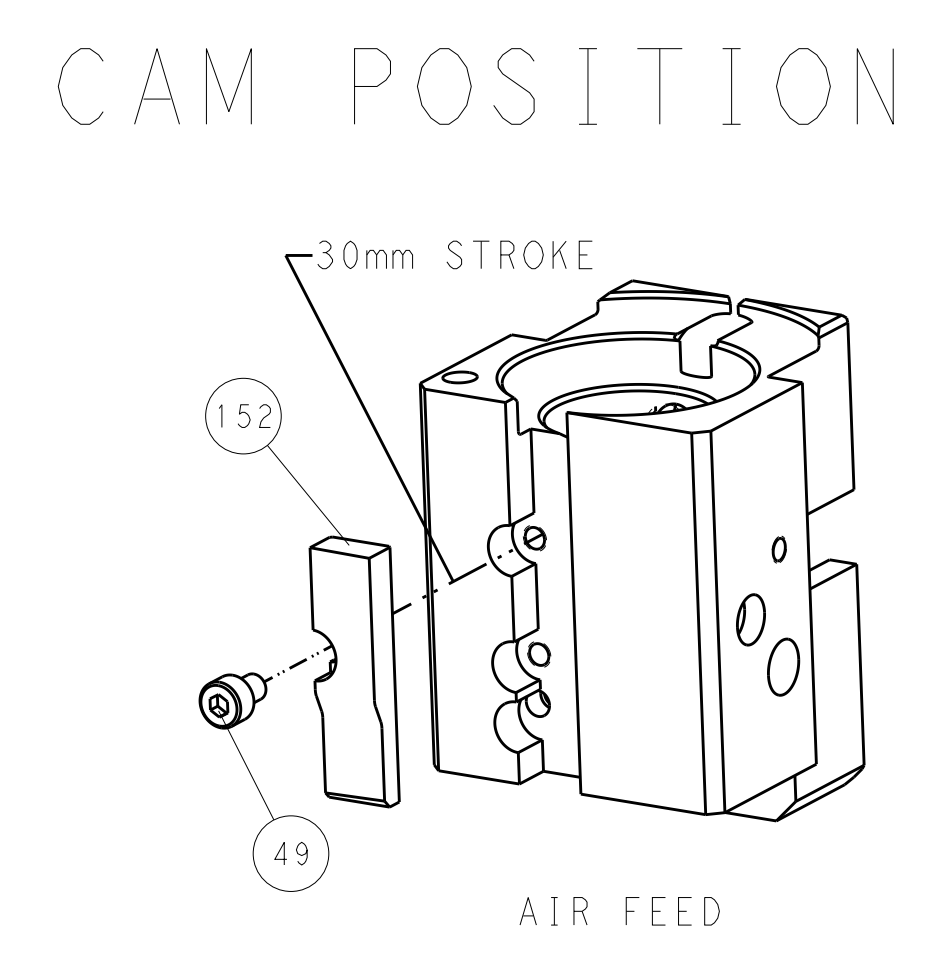
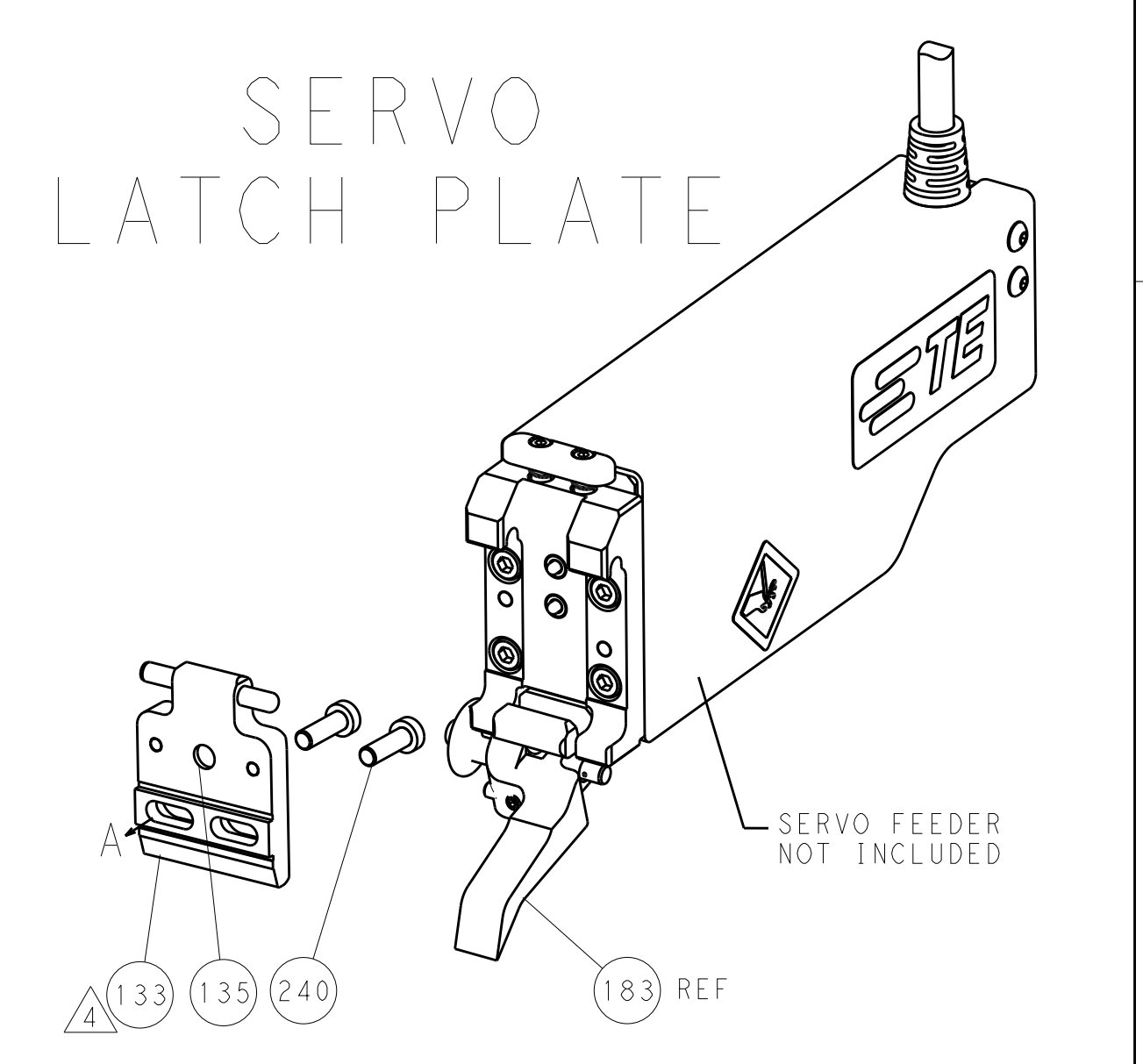
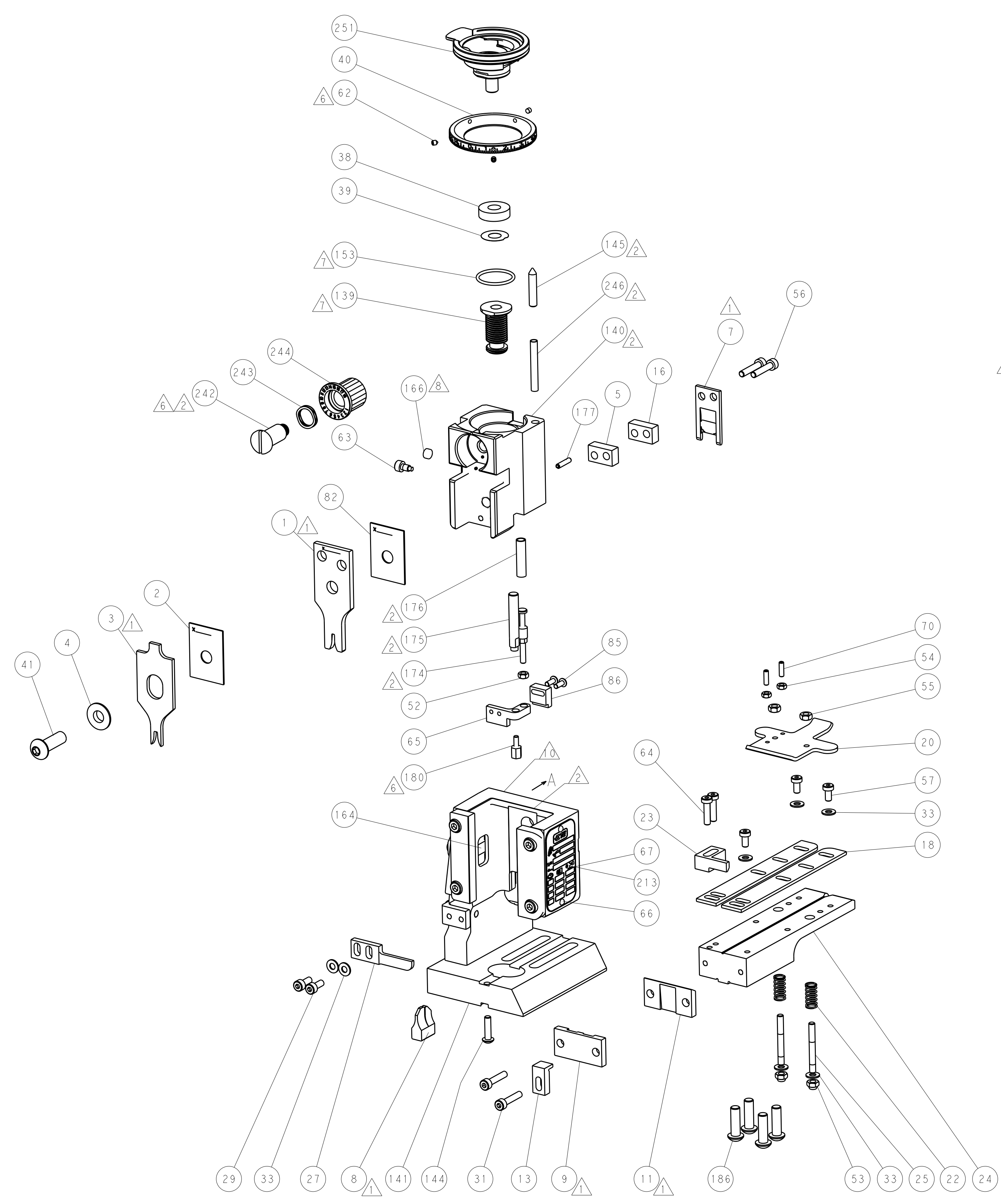
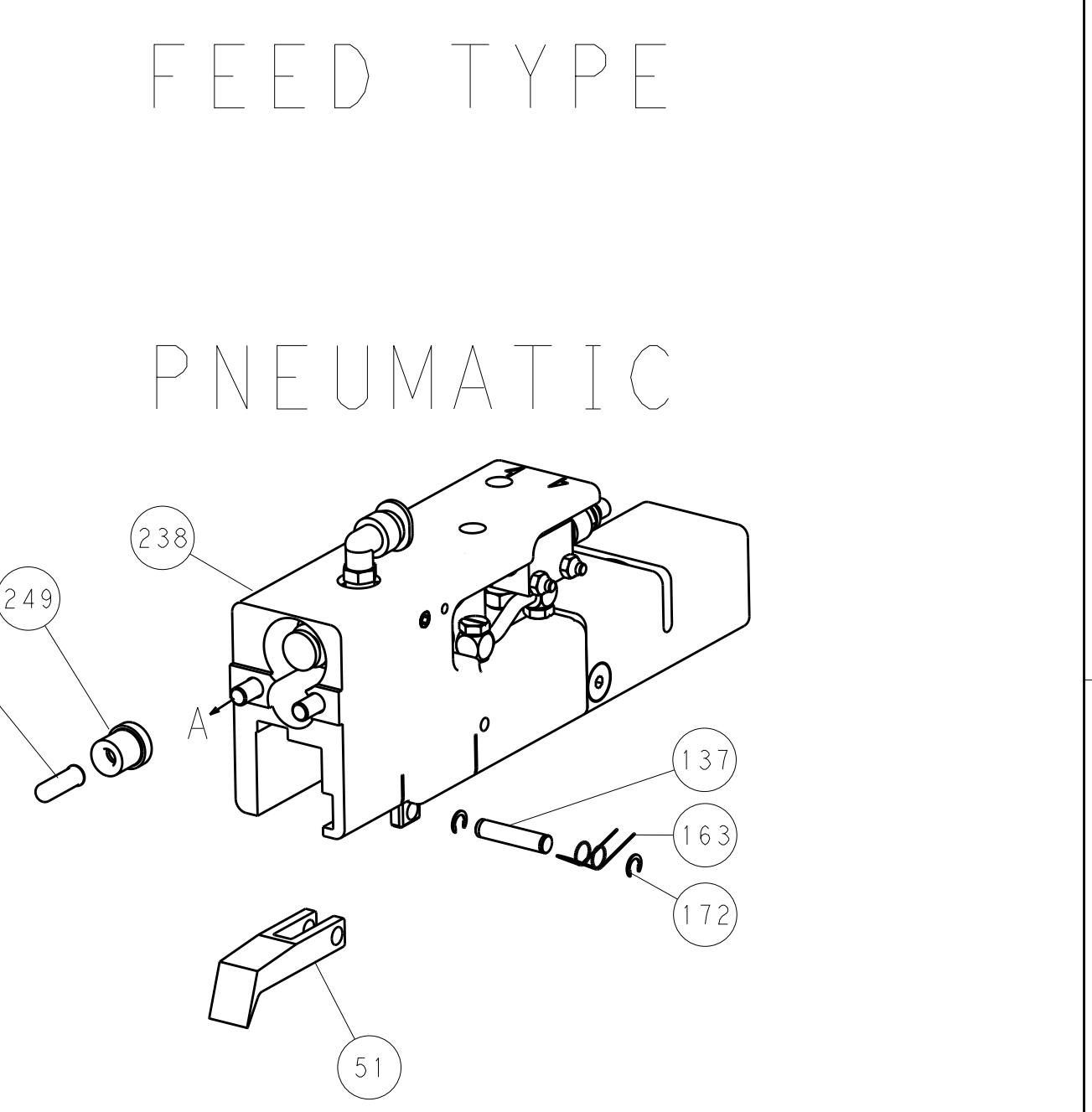
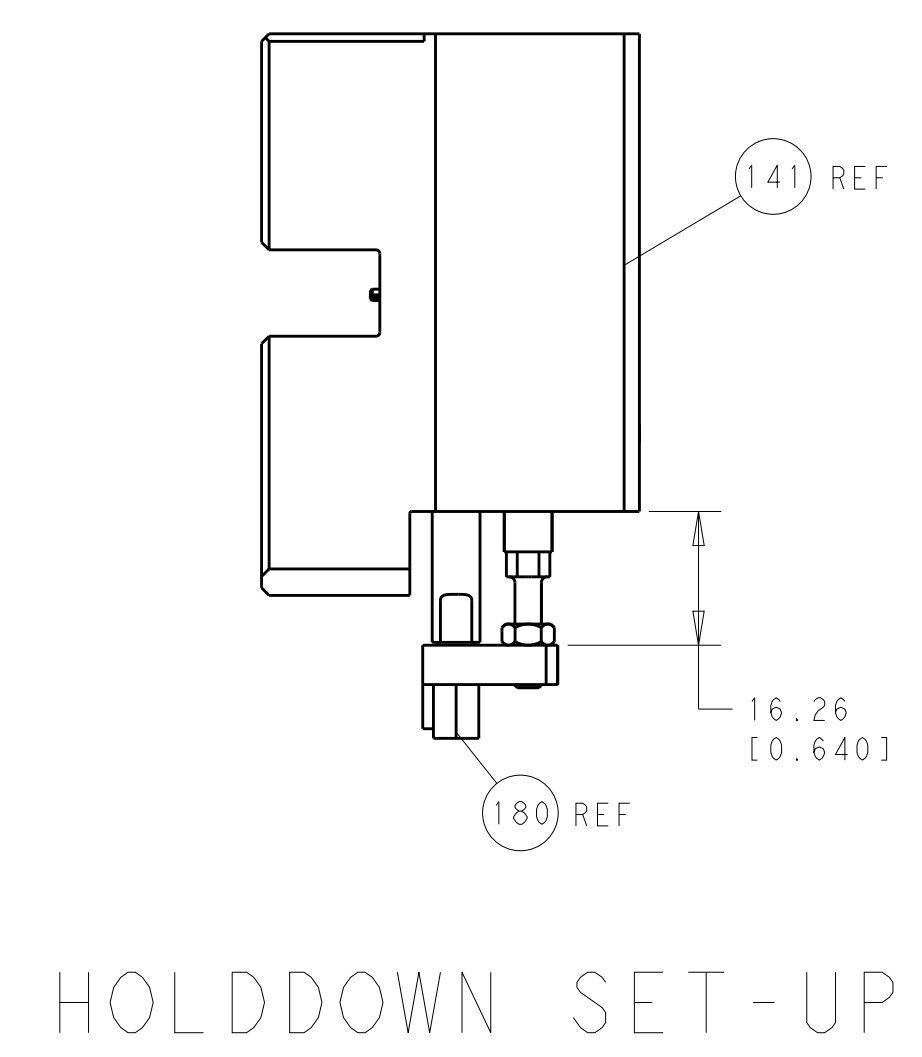
SET UP GAUGE	LOC	DIST	REVISIONS			
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			-	SEE SHEET 1	-	-

	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 x 10	240
	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	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
	-	1	1	1	1-1752354-3	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
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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5
	ANGLES ±.0001				
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV
			1:1	3 OF 4	A

LOC	DIST	REV	DATE	BY	APPV
A	66				

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003



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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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±0.0001		NAME: Ocean End Feed Applier PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150076 SCALE: 1:1 SHEET: 4 of 4 REV: A
MATERIAL:		Customer Accessible Production Drawing	