

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150300-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	
	2150300-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150300-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150300-4	-	-	-
	2150300-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-2
					-	-	-	-	-	-	-
2150300-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150300-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.70 mm [.185]	F
INSUL	5.50 mm [.217]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: LEAR TERMINAL	LEAR CRIMP SPECIFICATION		
TERMINAL NAME: RING TYPE CONNECT			
WIRE STRIP LENGTH 6.20-6.80 mm [.244-.268 IN]	INSULATION DIAMETER RANGE Ø3.80-5.10 mm [.150-.201 IN]		
TERMINAL APPLICATION SPECIFICATION	LEAR SPEC		
TERMINALS APPLIED ¹⁰			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572446-1	25233.331.011	1572446-6	25233.123.011
1572446-2	25233.331.322	1572446-7	25233.123.322
1572446-3	25233.213.004	1572446-8	25233.123.009
1572446-4	25233.213.320	1572446-9	25233.212.179
1572446-5	25233.123.014	1-1572446-0	25233.213.011

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
6.00mm2	3.10+0.1/-0.05 [.122+.004/- .002]	8.1
4.00mm2	2.85+0.1/-0.05 [.112+.004/- .002]	10.8

- 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: 8-2150300-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150300-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150300-6
- 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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 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 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

***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.

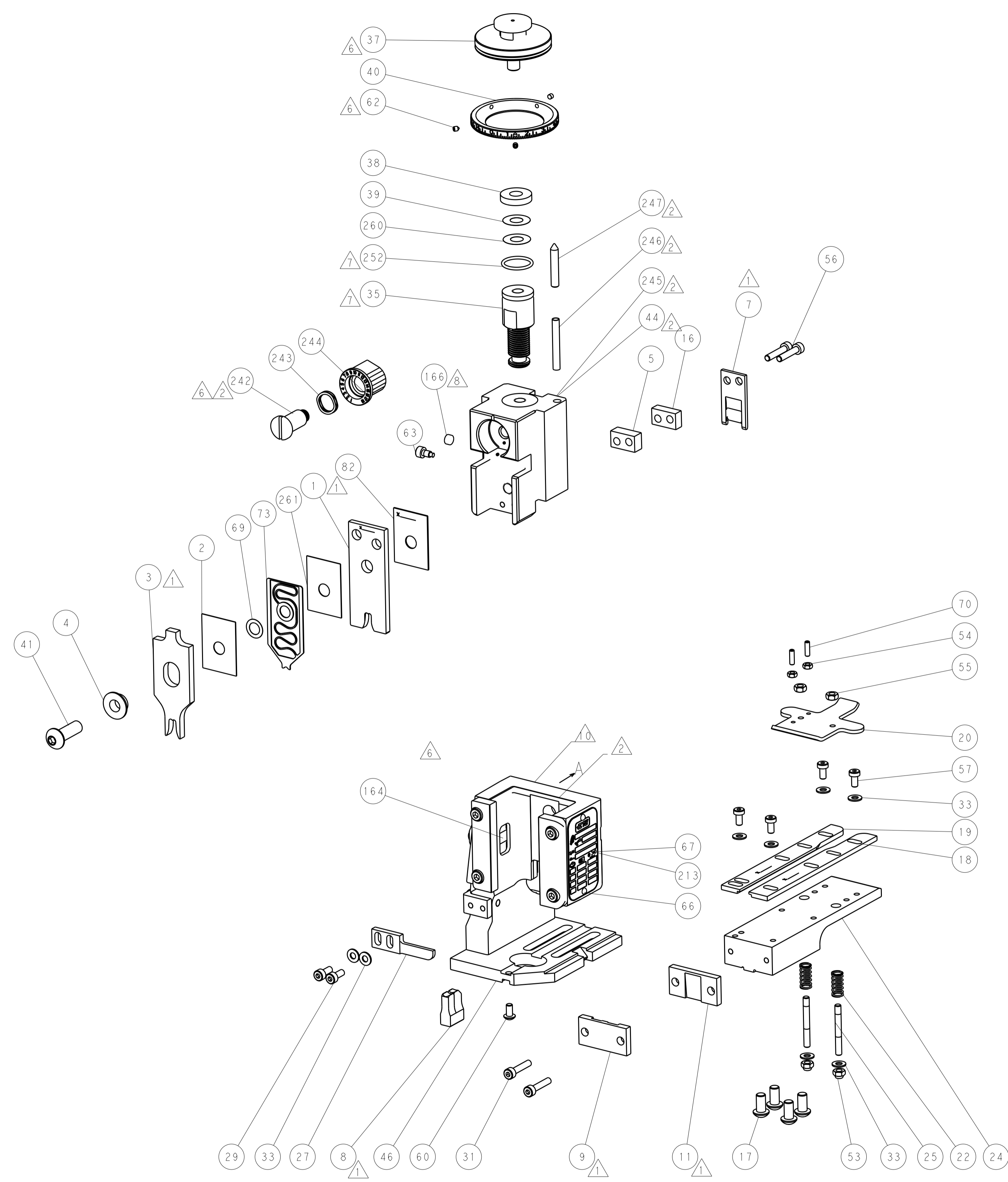
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			REV	DATE	BY	APPV
			A	RELEASED	12FEB2013	GB

ITEM NO	QTY	DESCRIPTION	DATE	BY	APPV	
- 1	1	1	1	455888-3	SPACER, CRIMPER	261
- 1	-	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
- 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
- -	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
- -	-	-	1	2063440-2	AIR FEED MODULE	238
- -	1	1	-	2119740-2	TAG, IDENTIFICATION	213
- -	REFREF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
- -	-	-	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	455888-6	SPACER, CRIMPER	82
- 1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
- 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	2119943-1	WASHER, SPACER	69
- 1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
- 2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66
- 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
- -	-	-	-	2063961-1	FEED FINGER	58
- 4	4	4	4	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	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	2119644-4	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	1752371-5	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	1-1901696-0	STRIP GUIDE, REAR	19
- 1	1	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
- 4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
- 1	1	1	1	2-240641-5	SPACER	16
- 1	1	1	1	240644-1	PLATE, REAR SHEAR	11
- -	-	-	-	-	-	10
- 1	1	1	1	690482-4	PLATE, FRONT SHEAR	9
- 1	1	1	1	2-1803000-4	ANVIL, COMBINATION, END FEED	8
- 1	1	1	1	1-2217206-2	BLADE, SLUG	7
- -	-	-	-	-	-	6
- 1	1	1	1	2-240641-7	SPACER	5
- 1	1	1	1	238009-5	BLOCK, FL CRIMPER SPACER	4
- 1	1	1	1	6-1633961-0	CRIMPER, INSULATION F PREMIUM	3
- 1	1	1	1	455888-3	SPACER, CRIMPER	2
- 1	1	1	1	4-1633664-8	CRIMPER, WIRE	1

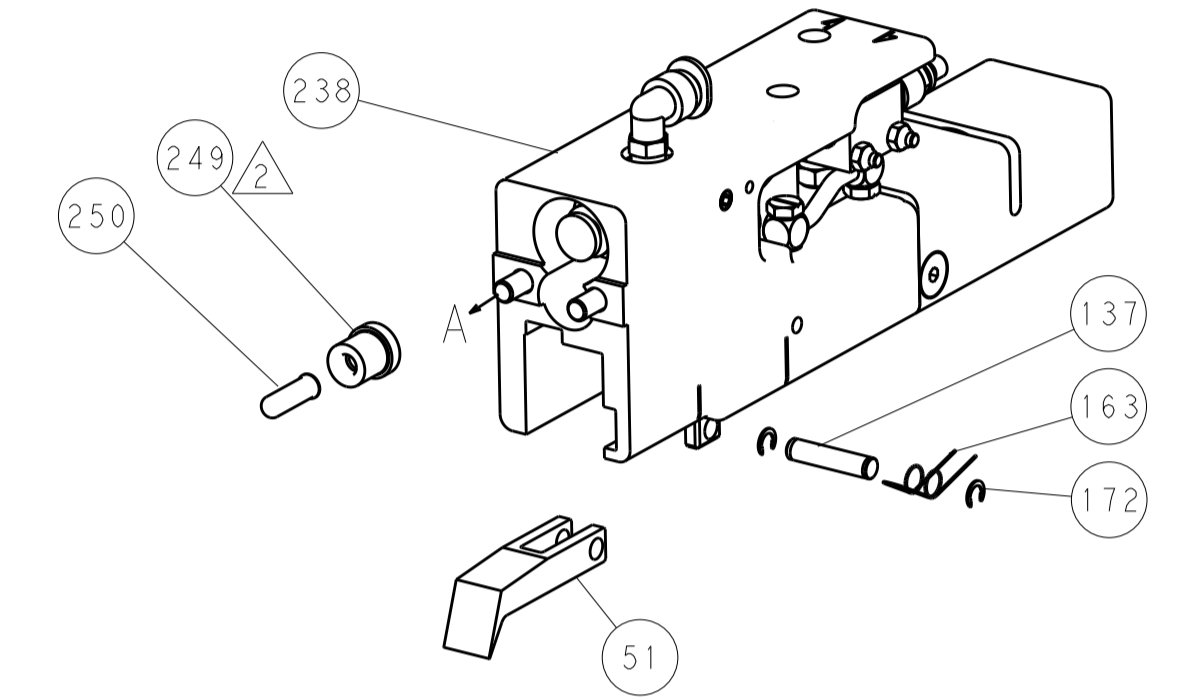
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mm		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		CHK G. BAILEY	05DEC2012		
		FINISH		APPV S. XI	05DEC2012	NAME Ocean End Feed Applicator	
MATERIAL		FINISH		PRODUCT SPEC	-	SIZE CASE CODE DRAWING NO RESTRICTED TO	
-		-		APPLICATION SPEC	-	A1 00779 ©=2150300	
-		-		WEIGHT	-	Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV A	

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

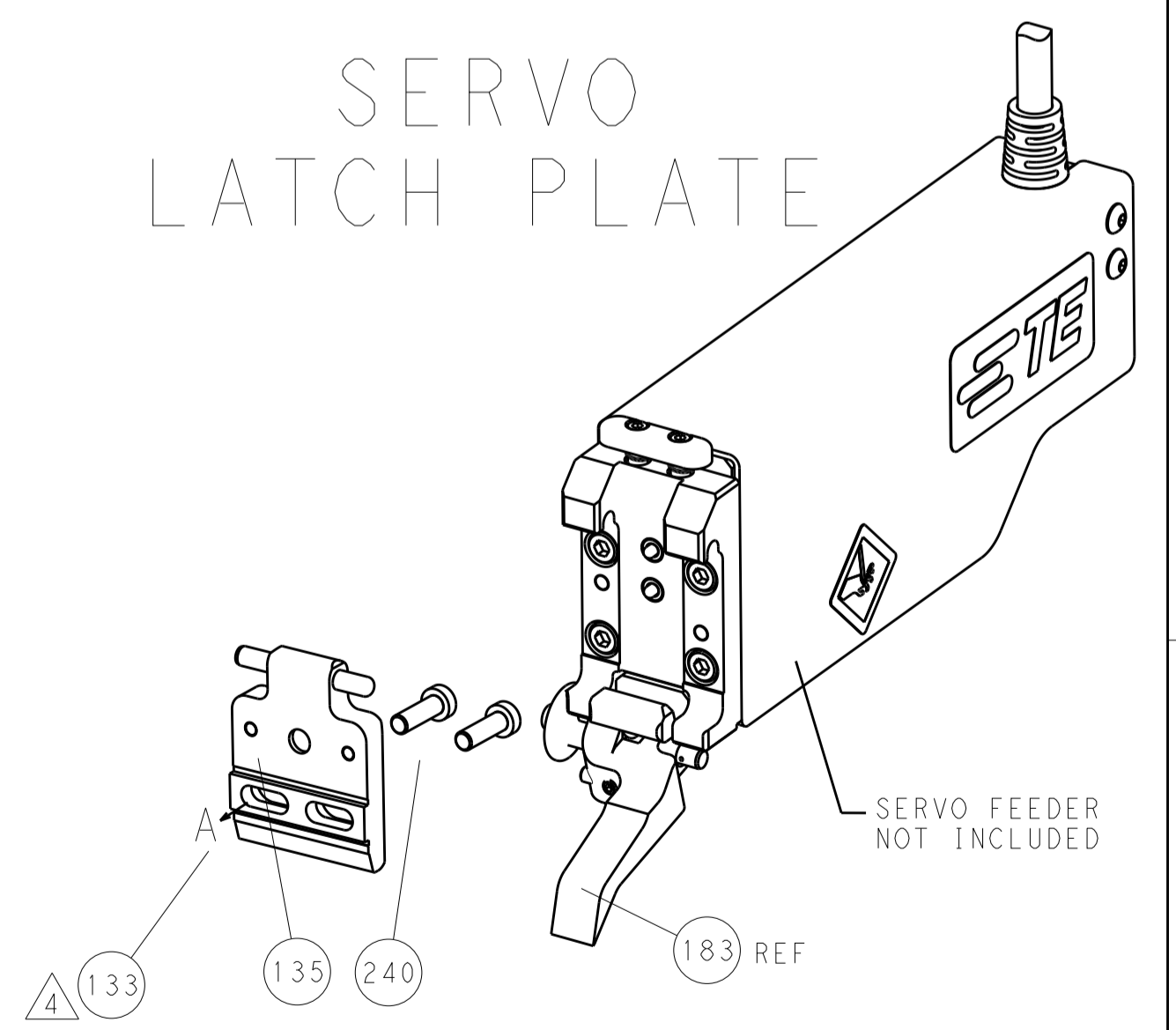


FEED TYPE

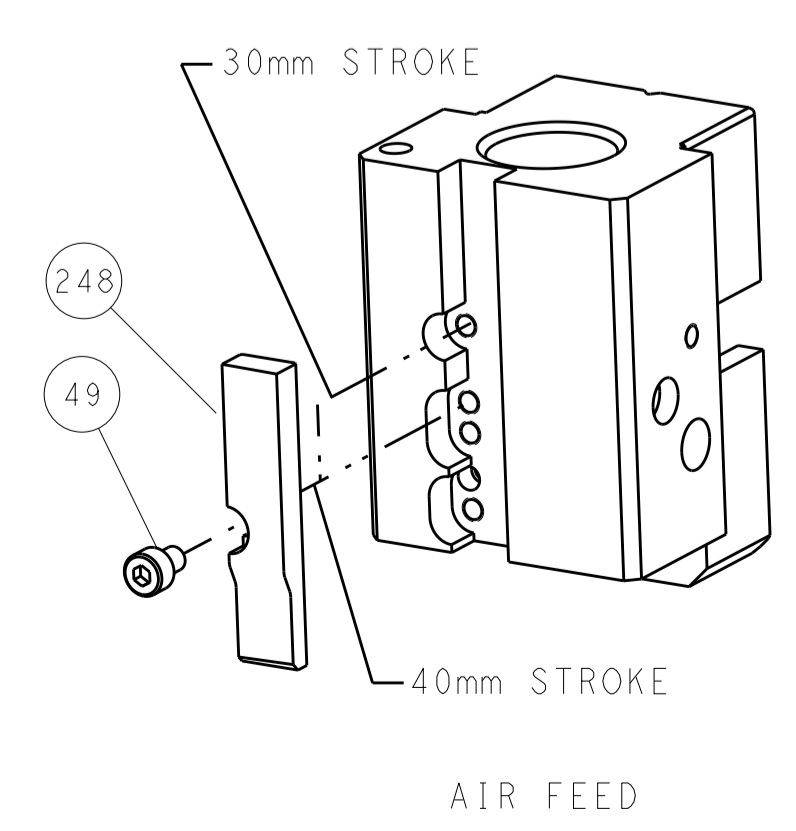
PNEUMATIC



SERVO LATCH PLATE



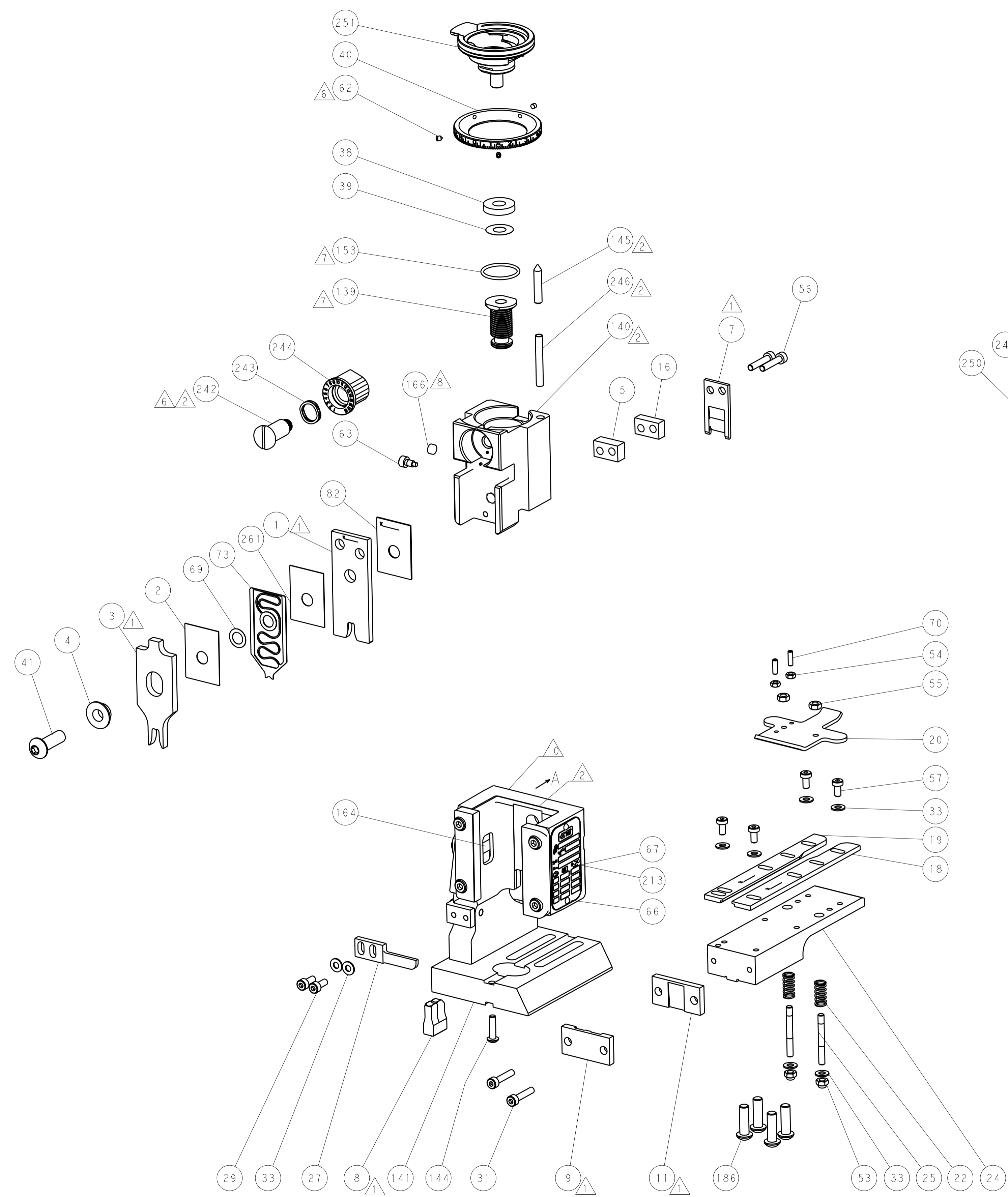
CAM POSITION



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 05DEC2012		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	ANGLES ±0.0001	FINISH
MATERIAL:				G. BAILEY 05DEC2012		NAME: Ocean End Feed Applicator	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 2 OF 4	

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

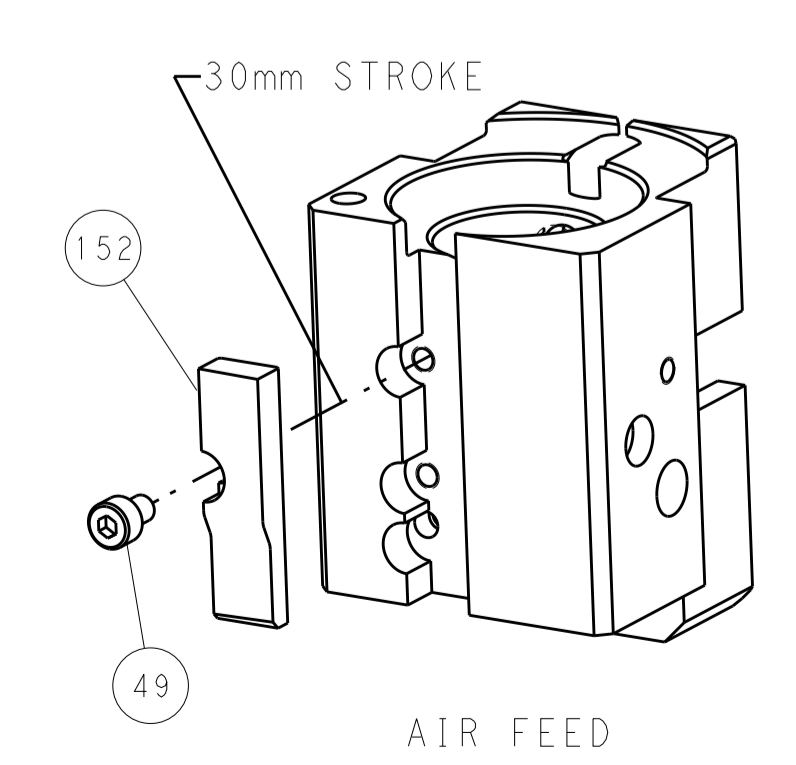


FEED TYPE

PNEUMATIC

SERVO LATCH PLATE

CAM POSITION



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 T.Y. YIN 05DEC2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD S. XI 05DEC2012	NAME Ocean End Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:1	SHEET 4 OF 4	REV A	RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 4 OF 4		REV A	