

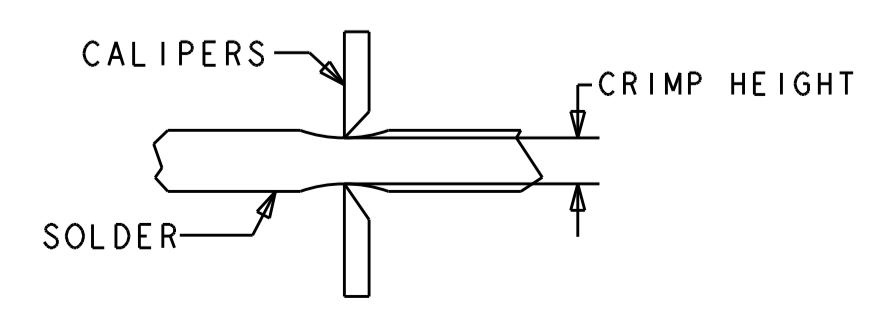
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150252-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-2	8-2150252-5	-	-	2168400-7 (QUANTITY 2)
	2150252-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	SMART APPLICATOR	2161326-1	-	8-2150252-4	-	-	-
	2150252-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1
	2150252-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150252-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.11 mm [1.201]	D
INSUL	-	-
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT, ULTRA-FAST FLAG, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.51-8.33 mm [1.296-.328 IN]		Ø0.00-4.19 mm [1.000-.165 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2123		
TERMINALS APPLIED <sup>9</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520128-2	2-521164-2	9-521164-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
18 OR (2) 22	1.79+/-0.05 [1.070+/-0.002]	5.7	.19 in [4.83mm]
22 OR 20	1.65+/-0.05 [1.065+/-0.002]	7.0	.19 in [4.83mm]

- <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:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150252-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150252-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150252-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>7</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>8</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>9</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>10</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
- <sup>11</sup> TO CHECK CRIMP HEIGHT. CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			1	ORIGINAL	11APRIL2012	GH TE
			A	RELEASED	18JAN2013	GH TE

-	-	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
-	-	2	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	2119644-6	RAM WASHER, PRECISION	221
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	1	1	1	1	467281-1	RETAINER, SHEAR, FLOATING	207
-	1	1	1	1	2161936-1	HOLDER, SHEAR, FLOATING	206
-	1	1	1	1	467500-1	SHEAR, FLOATING	205
-	-	REFREF	-	-	1901697-2	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	REFREF	REFREF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	2161937-1	STABILIZER	154
-	-	-	-	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	2119956-2	DOCUMENTATION PACKAGE	71
-	1	1	1	1	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	1	1	1	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	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
-	3	3	3	3	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	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	2161952-1	PAWL, EF, AIR	51
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	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	2119644-7	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	2	2	2	2	5-22278-1	SPRING, COMPRESSION	36
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1	2161941-1	PLATE, GUIDE, STRIP	24
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	2161948-1	DRAG	20
-	1	1	1	1	683736-1	GUIDE, STRIP, REAR	19
-	1	1	1	1	683737-1	FRONT STRIP GUIDE	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	4-22280-7	SPRING, COMPRESSION	13
-	1	1	1	1	2161935-1	ANVIL, RIGHT HAND	8
-	1	1	1	1	2161957-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
-	1	1	1	1	467342-1	CRIMPER, RIGHT HAND	1

**\*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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±0.5	1 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0001	ANGLES ±0.0001	FINISH	
MATERIAL		FINISH		WEIGHT		SCALE	
				A1 00779		C=2150252	

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

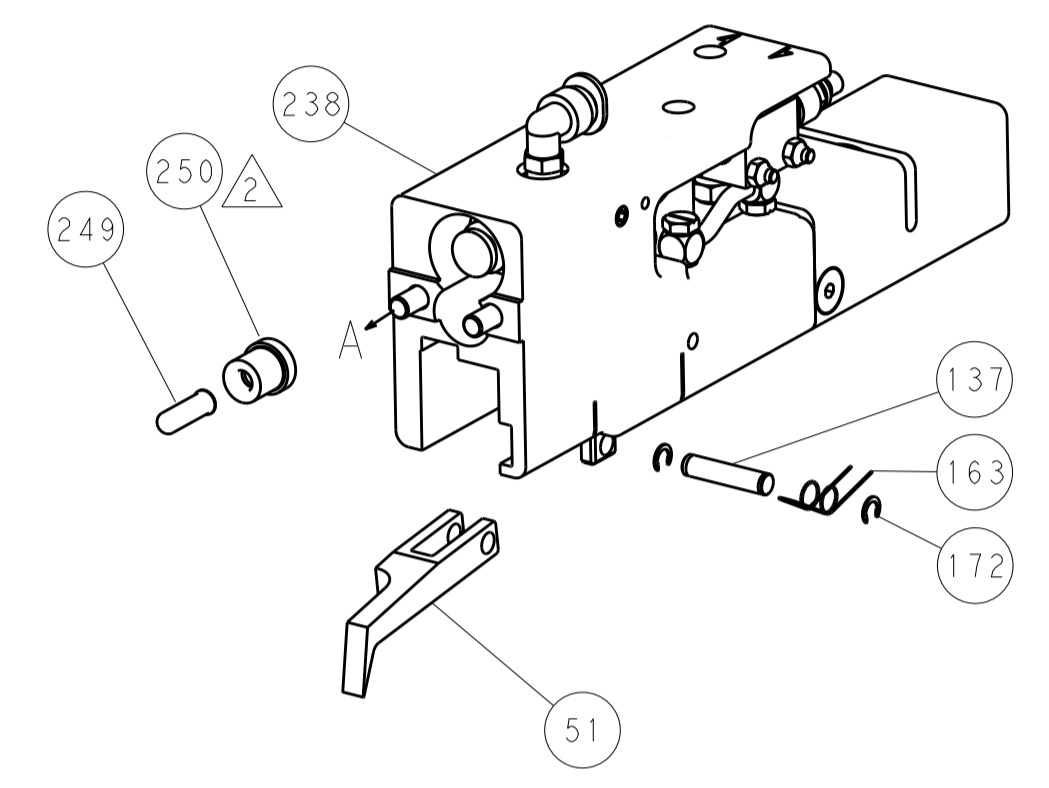
**Product Name:** Ocean End Feed Applicator

**Customer Accessible Production Drawing** SCALE 1:1 SHEET 1 of 4 REV A

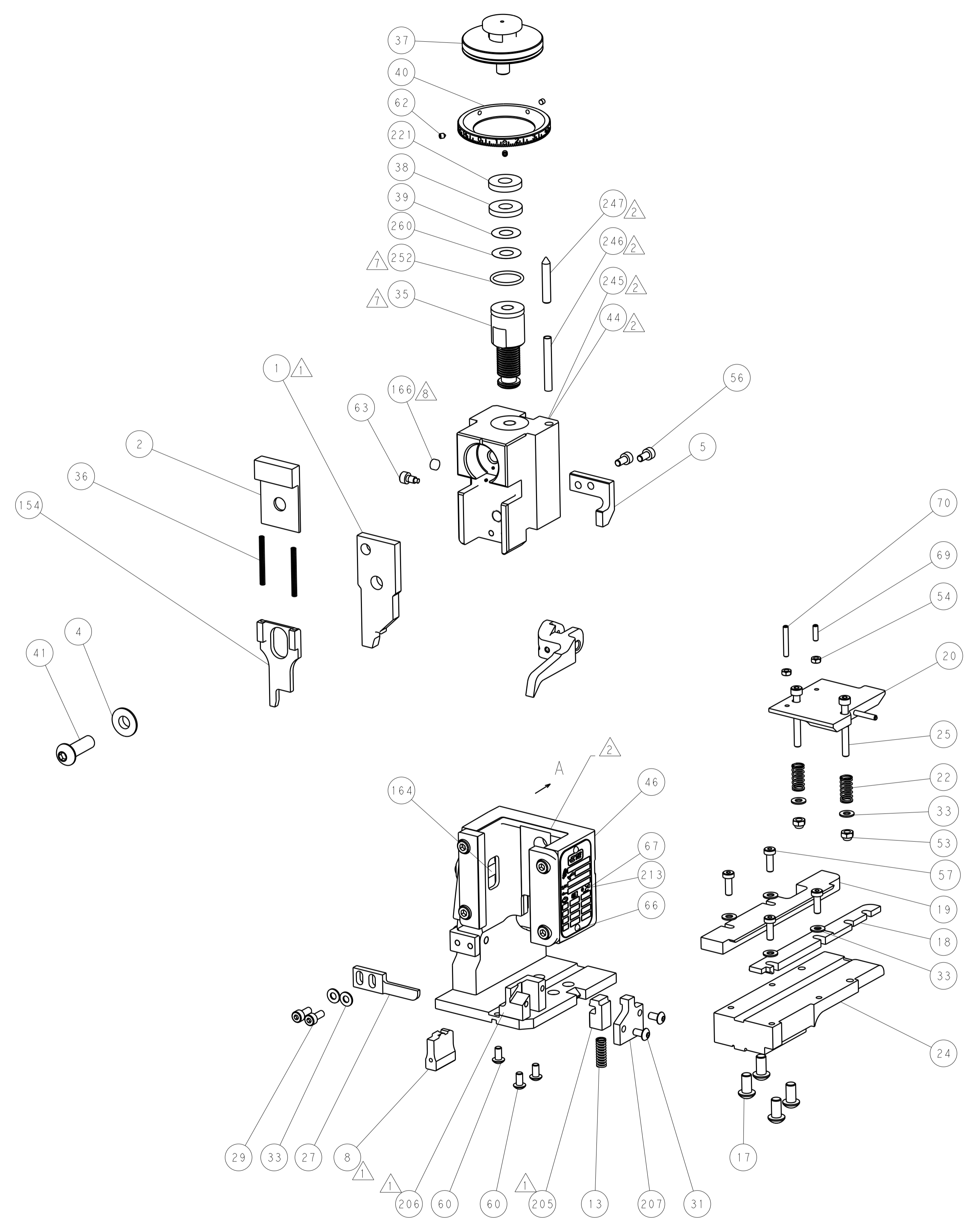
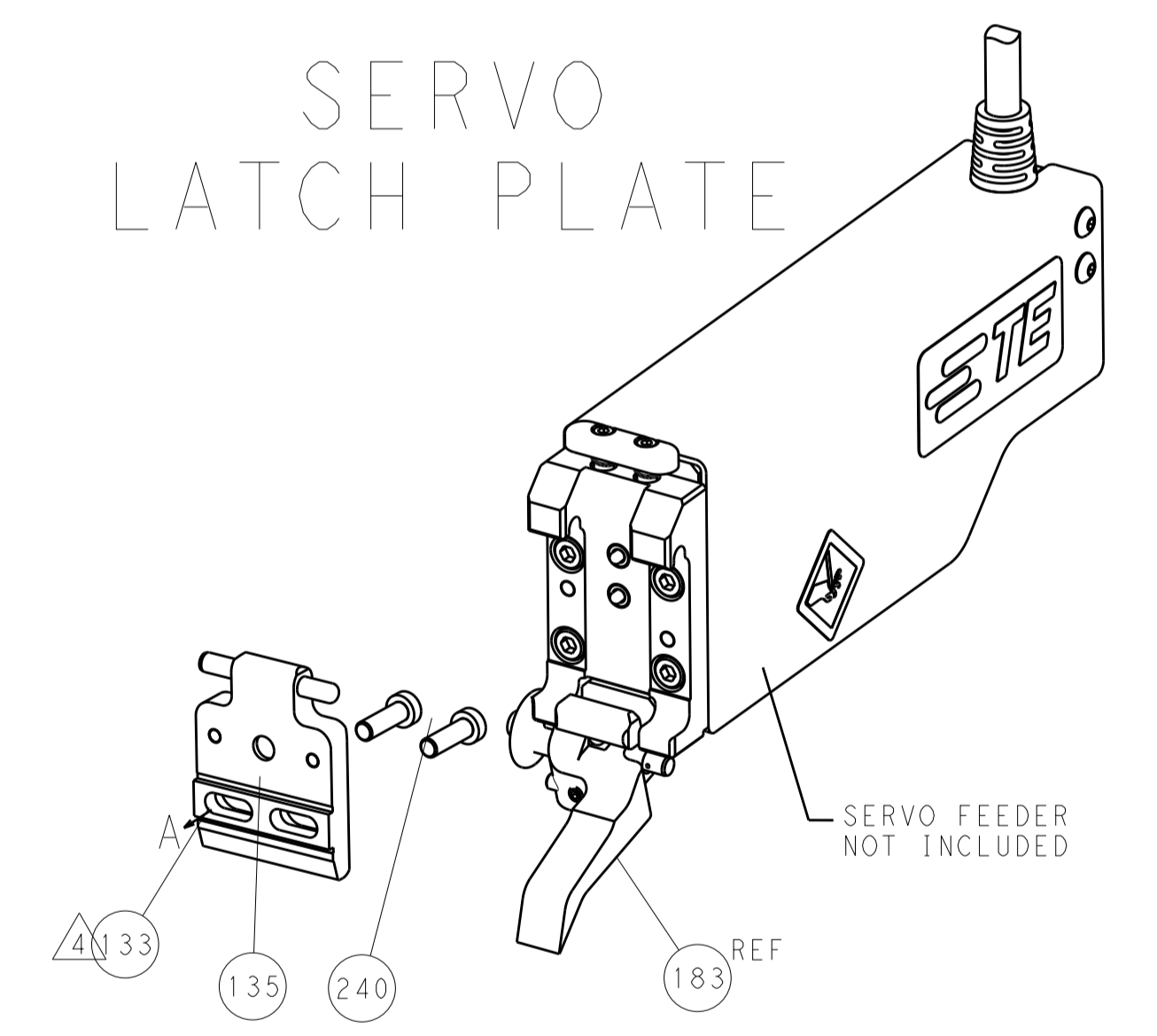
LOC	DIST	REV	DATE	BY	APPV
A	66				

### FEED TYPE

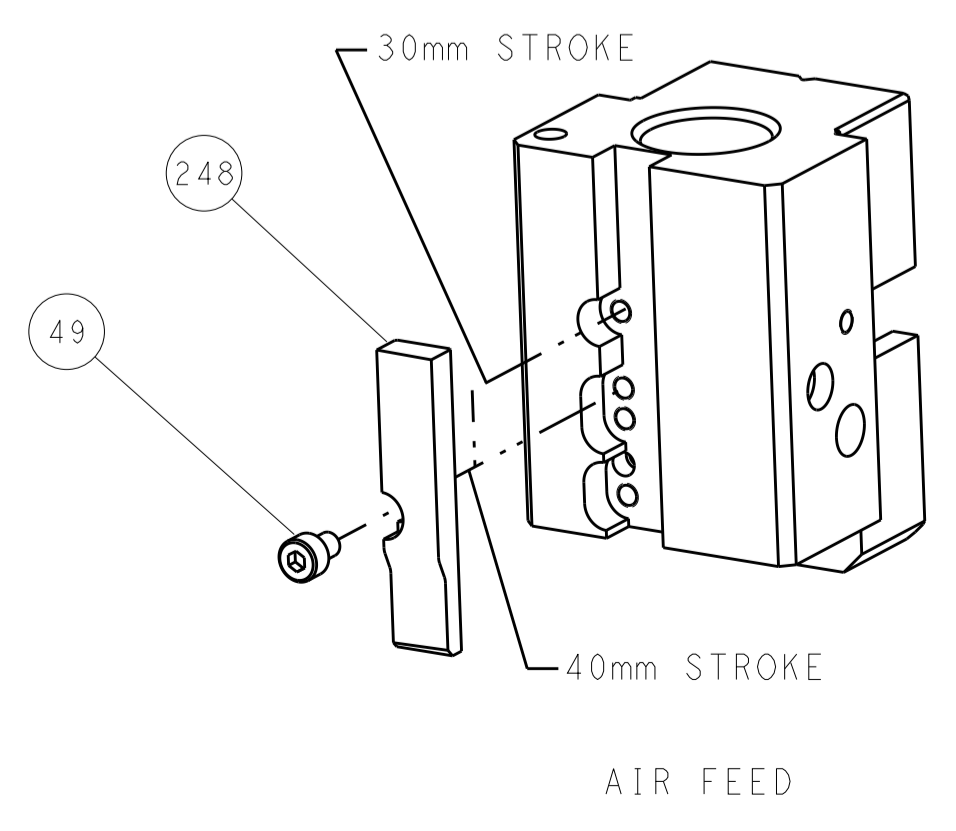
### PNEUMATIC



### 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: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		DWN: HOFFNER 11APRIL2012 CHK: T. ELBIN 12APRIL2012 APPV: T. ELBIN 12APRIL2012	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150252	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: A
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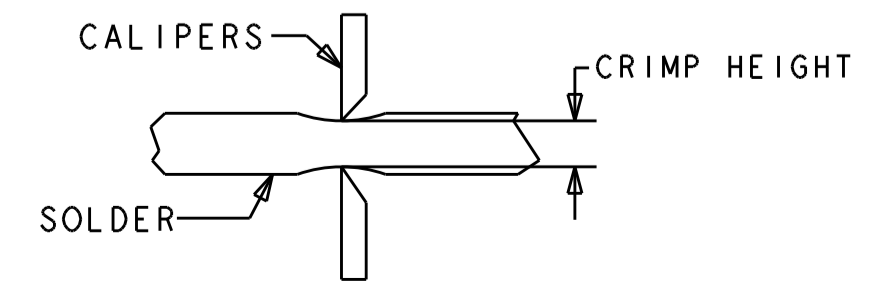
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150252-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-2	8-2150252-5	-	-	2168400-7 (QUANTITY 2)
	2-2150252-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	SMART APPLICATOR	2161326-1	-	8-2150252-4	-	-	-
	2-2150252-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
	7-2150252-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
INSUL	5.11 mm [ .201 ]	D
APPL INSTRUCTIONS		
408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT, ULTRA-FAST FLAG, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.51-8.33 mm [ .296-.328 IN ]		Ø 0.00-4.19 mm [ 0.00-.165 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED <sup>9</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520128-2	2-521164-2	9-521164-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>8</sup>	Ø SOLDER <sup>10</sup>
18 OR (2) 22	1.79+/-0.05 [ .070+/- .002 ]	5.7	.19 in [ 4.83mm ]
22 OR 20	1.65+/-0.05 [ .065+/- .002 ]	7.0	.19 in [ 4.83mm ]

- 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: 8-2150252-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150252-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 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.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø .19 IN [ 4.83mm ] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



**\*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	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 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	1-22279-3	SPRING, COMPRESSION	246
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	1	2063440-1	AIR FEED MODULE	238
-	1	1	1	2119644-6	RAM WASHER, PRECISION	221
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
-	1	1	1	467281-1	RETAINER, SHEAR, FLOATING	207
-	1	1	1	2161936-1	HOLDER, SHEAR, FLOATING	206
-	1	1	1	467500-1	SHEAR, FLOATING	205
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	1901697-2	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	2161937-1	STABILIZER	154
-	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	1-2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1	2119651-1	RAM, 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	2119956-2	DOCUMENTATION PACKAGE	71
-	1	1	1	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	1	1	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	69
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	1	2161952-1	PAWL, EF, AIR	51
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	2119644-7	RAM WASHER, PRECISION	38
-	2	2	2	5-22278-1	SPRING, COMPRESSION	36
-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	31
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	2161941-1	PLATE, GUIDE, STRIP	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	2161948-1	DRAG	20
-	1	1	1	683736-1	GUIDE, STRIP, REAR	19
-	1	1	1	683737-1	FRONT STRIP GUIDE	18
-	1	1	1	4-22280-7	SPRING, COMPRESSION	13
-	1	1	1	2161935-1	ANVIL, RIGHT HAND	8
-	1	1	1	2161957-1	DEPRESSOR, SHEAR	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
-	1	1	1	467342-1	CRIMPER, RIGHT HAND	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.13	3 PLC ±.013	4 PLC ±.0001
ANGLES	±.0001		FINISH		
MATERIAL	FINISH		WEIGHT	SCALE	REV
			Customer Accessible Production Drawing	1:1	3 of 4

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

**Product Name:** Ocean End Feed Applicator

**Part No:** 00779

**Scale:** 1:1

**Sheet:** 3 of 4

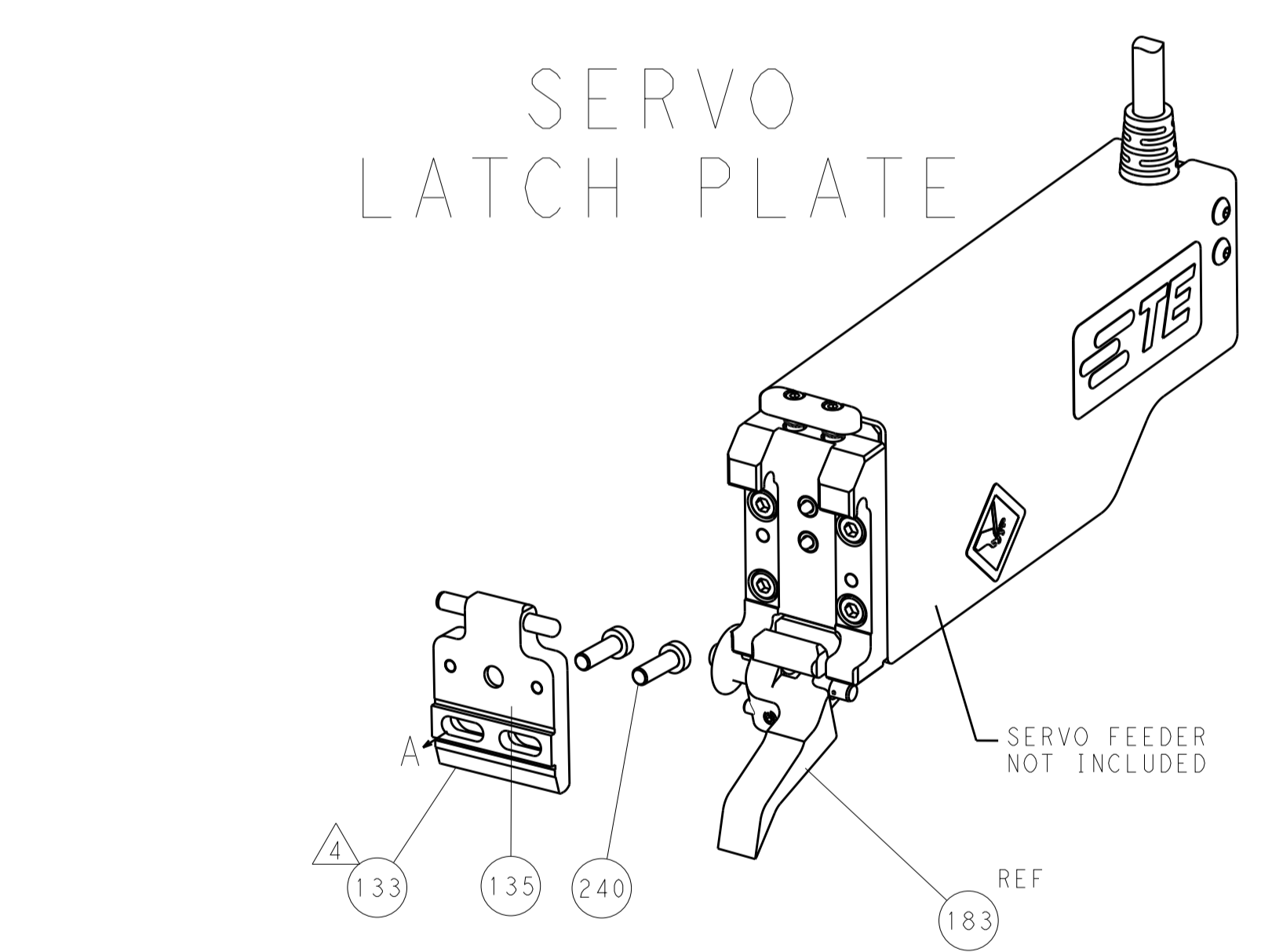
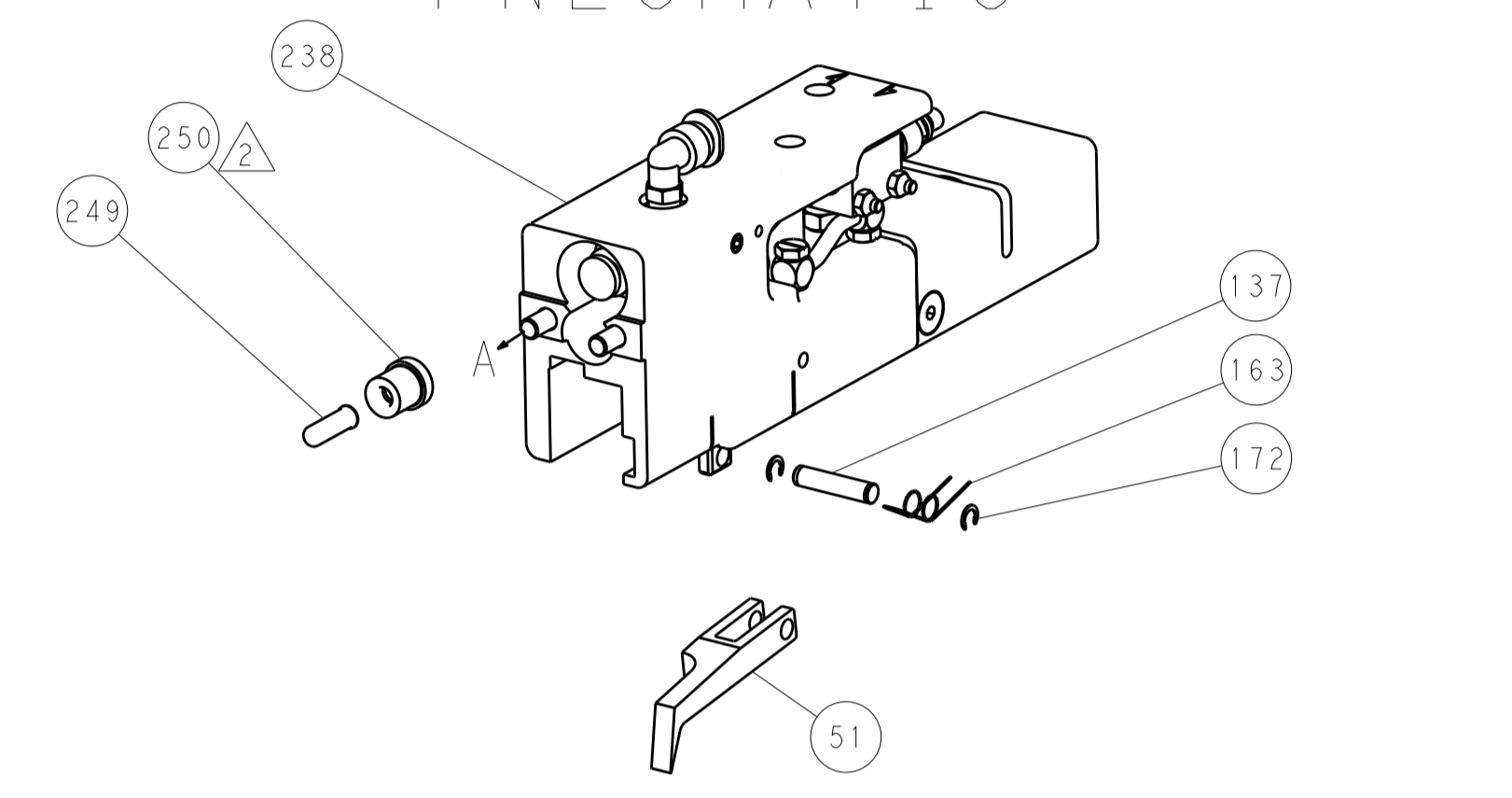
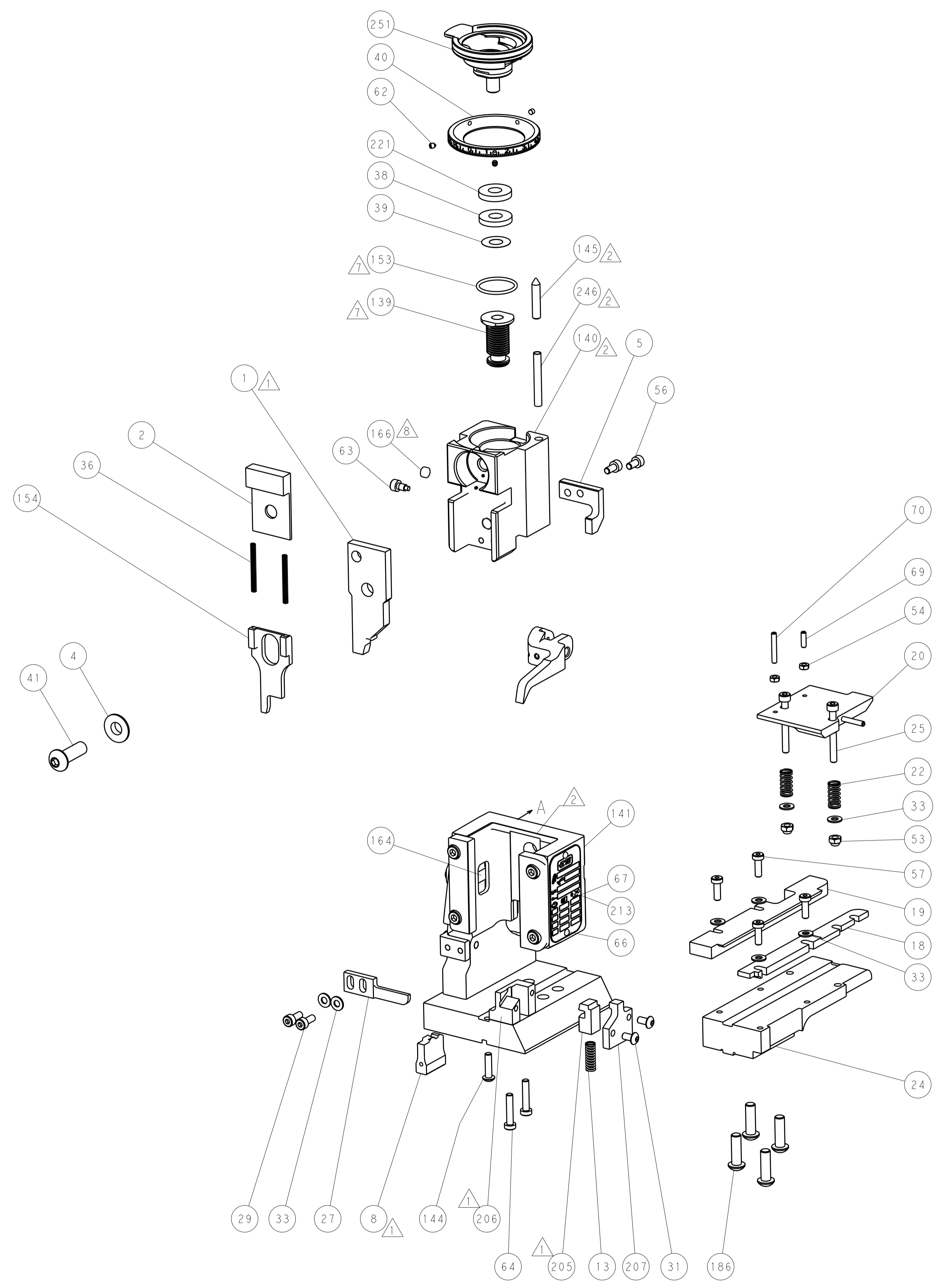
**Rev:** A

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

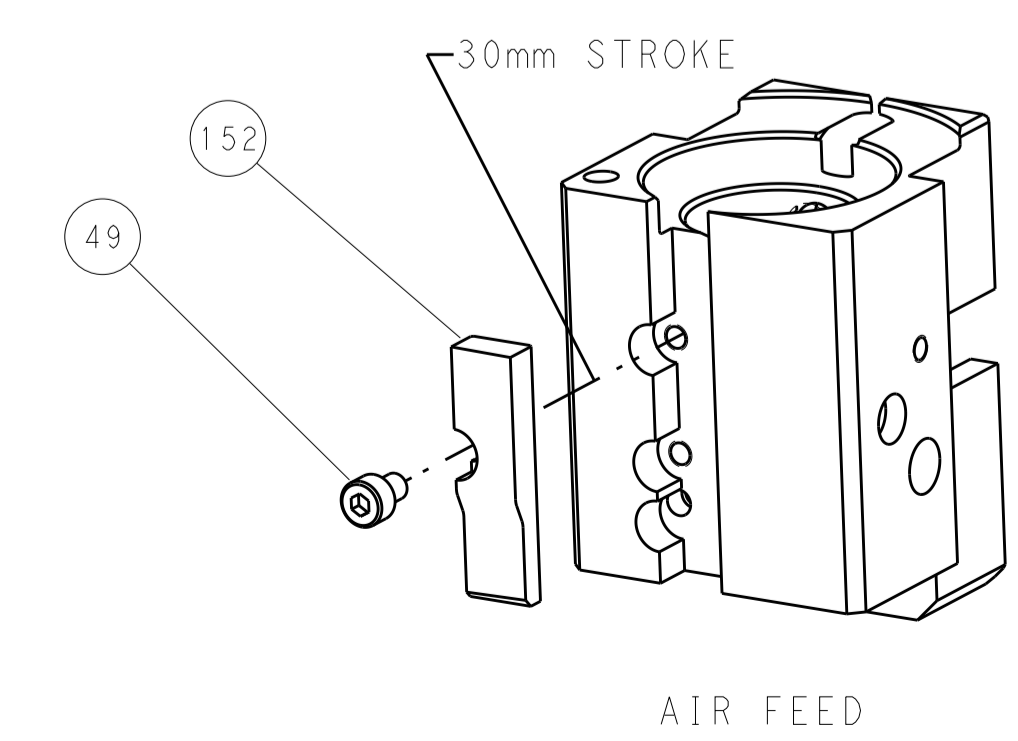
### FEED TYPE

### 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: HOFFNER 11APRIL2012		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 12APRIL2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1	
Customer Accessible Production Drawing		A1 00779 ©=2150252		SHEET 4 OF 4		REV A	