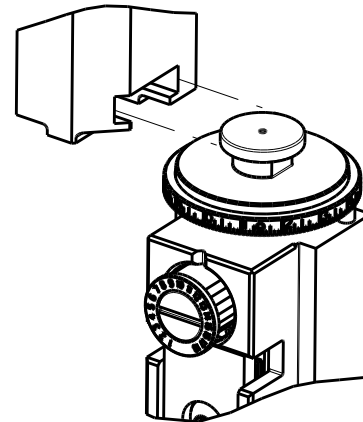
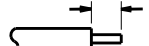


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150013-1	B	FINE CRIMP HEIGHT ADJUST
	2150013-2	B	FINE CRIMP HEIGHT ADJUST
	2150013-5	B	FINE CRIMP HEIGHT ADJUST
	2150013-6	B	NON-CRIMP HEIGHT ADJUST
	2150013-7	B	FINE CRIMP HEIGHT ADJUST
	7-2150013-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION
TERMINAL NAME: .250 SERIES FASTON REC				
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE	
3.80-4.60 mm [.150-.181 IN]			Ø2.00-3.30 mm [.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-	-
TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	
880683-1	880683-2	880683-3	880683-6	

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
1.00mm2			1.62+/-0.05 [.064+/- .002]		8.6
0.75mm2			1.52+/-0.05 [.060+/- .002]		9.6
0.50mm2			1.45+/-0.05 [.057+/- .002]		10.3



- 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: 8-2150013-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150013-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150013-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150013-6
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 50, 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50.
- 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 CUT TO LENGTH AT ASSEMBLY

*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
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

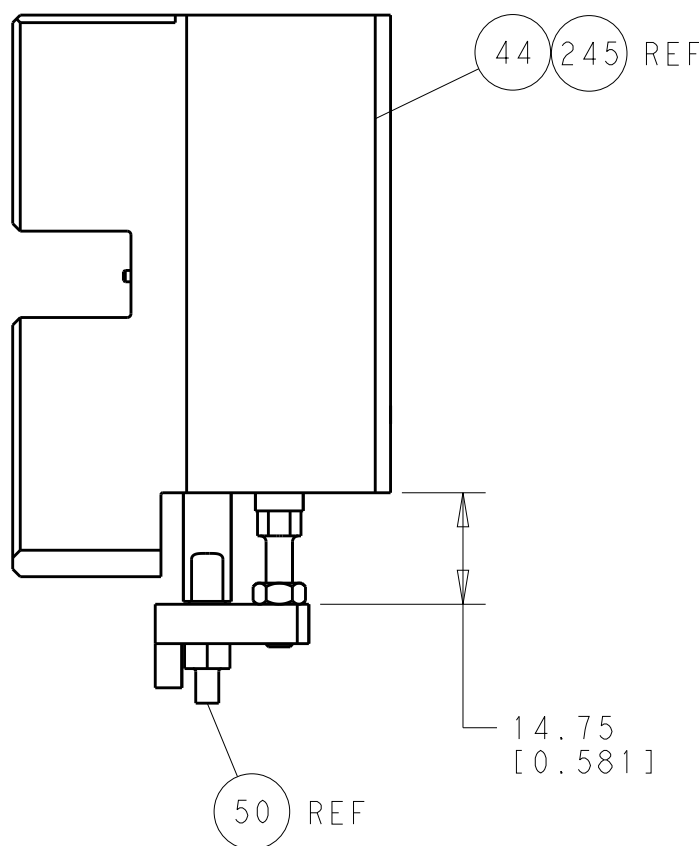
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2		LOC A	DIST 66	REVISIONS				
		P	LTR	DESCRIPTION	DATE	DWN	APVD	
		A		RELEASE	24APR2012	L.Z	S.X	
		B		ECR-15-010374	10JUL2015	JH	CT	

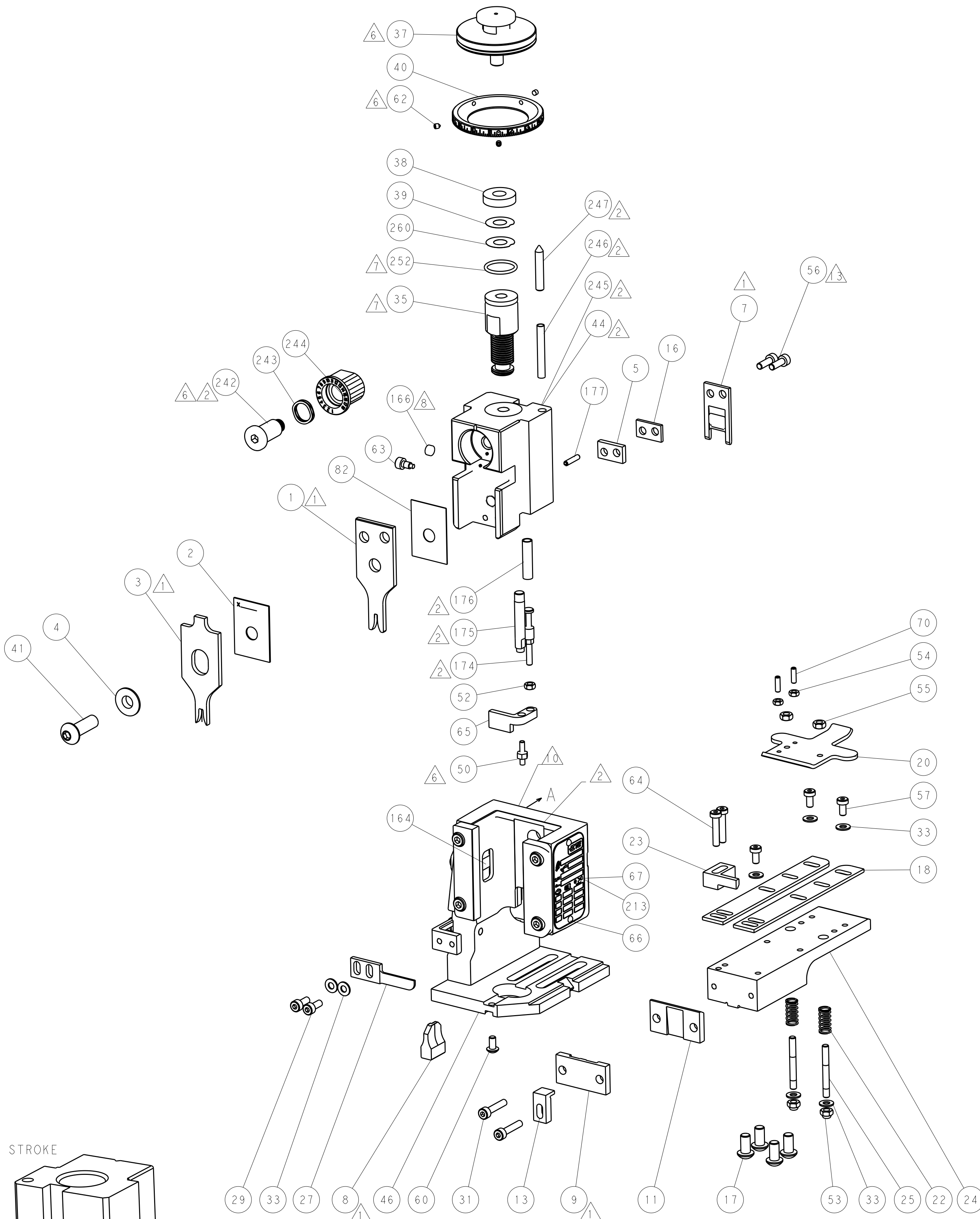
	-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
6	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
	-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
	-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
	-	-	-	-	-	1	2063440-1	AIR FEED MODULE	238	
	-	-	1	1	-	-	2119740-2	TAG,IDENTIFICATION	213	
	-	-	REF	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	
	-	REF	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	1	455888-3	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	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	1901681-5	HOLDDOWN, TERMINAL	65	
	-	2	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	
	-	-	-	-	-	-	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	2119792-1	PAWL, EF, AIR	51	
	-	1	1	1	1	1	1-1976055-6	STANDOFF, HOLD-DOWN	50	
	-	-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48	
	-	-	-	-	-	-	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	
6	-	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	240639-4	STRIPPER (MACHINING)	27	
	-	2	2	2	2	2	1320906-1	STUD, THREADED	25	
	-	1	1	1	1	1	1752371-2	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	1752373-1	DRAG	20	
	-	2	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18	
	-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
	-	1	1	1	1	1	1-240641-1	SPACER	16	
	-	1	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	1	1	1	1	240833-2	PLATE, REAR SHEAR	11	
	-	-	-	-	-	-	-	-	10	
1	-	1	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9	
1	1	1	1	1	1	1	1803001-1	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	1	1	690474-3	BLADE, SLUG	7	
	-	1	1	1	1	1	240641-8	SPACER	5	
	-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4	
1	1	1	1	1	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3	
	-	1	1	1	1	1	455888-6	SPACER, CRIMPER	2	
1	1	1	1	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1	
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO	

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE DIMENSIONS AND TOLERANCES OF THE PARTS USED IN THE ASSEMBLY. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE DIMENSIONS AND TOLERANCES OF THE PARTS USED IN THE ASSEMBLY.				DWN L.ZHANG 19DEC2011	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK L.ZHANG 19DEC2011	NAME Ocean End Feed Applicator			
				APVD S.XI 19DEC2011	PRODUCT SPEC			
					APPLICATION SPEC			
					WEIGHT			
MATERIAL -					FINISH -			
					Customer Accessible Production Drawing			
					SCALE 1:1			
					SHEET 1 of 4			
					REV B			

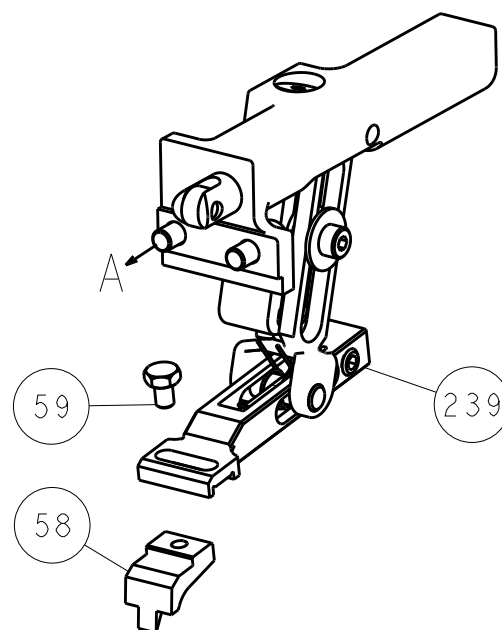
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		-		SEE SHEET 1	-	-	-



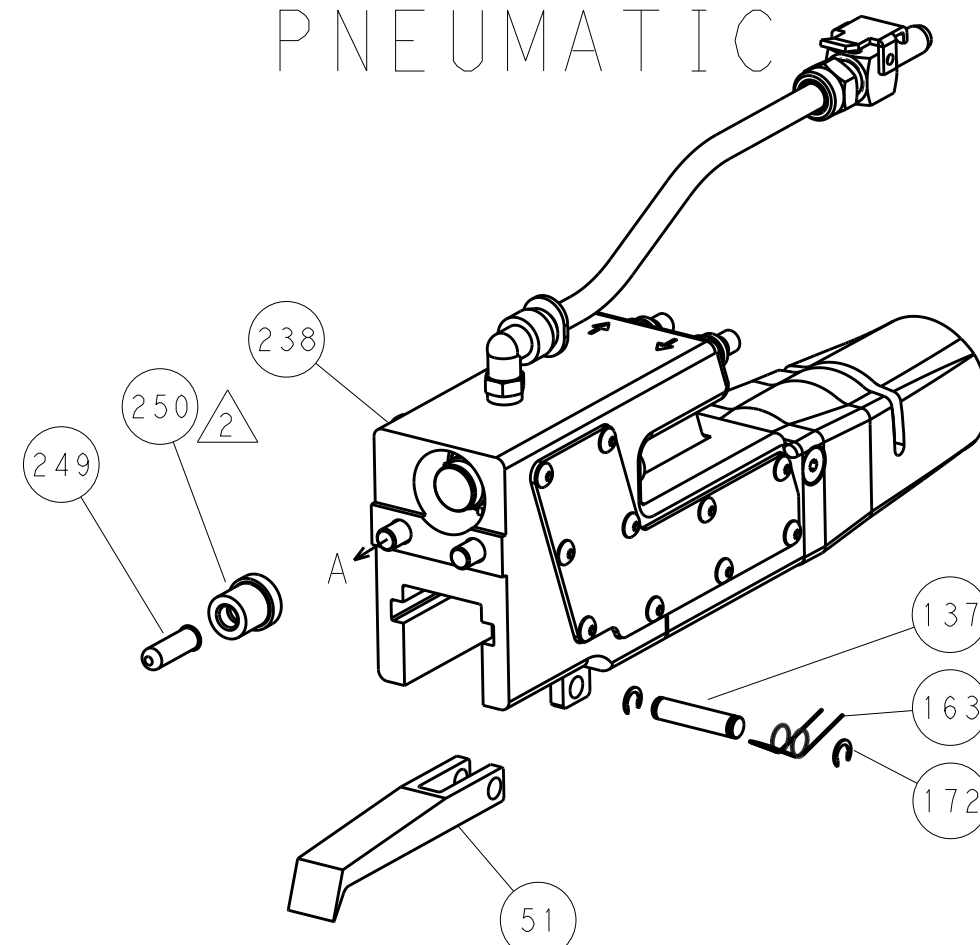
HOLDDOWN SET-UP



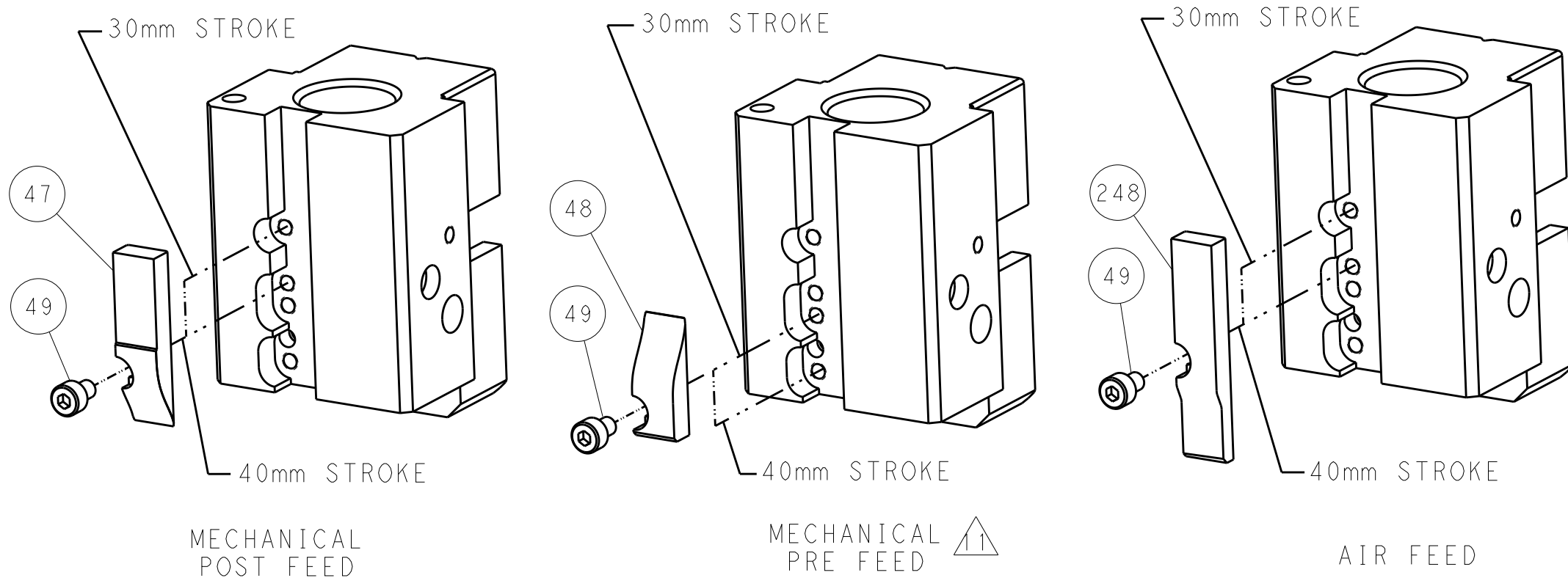
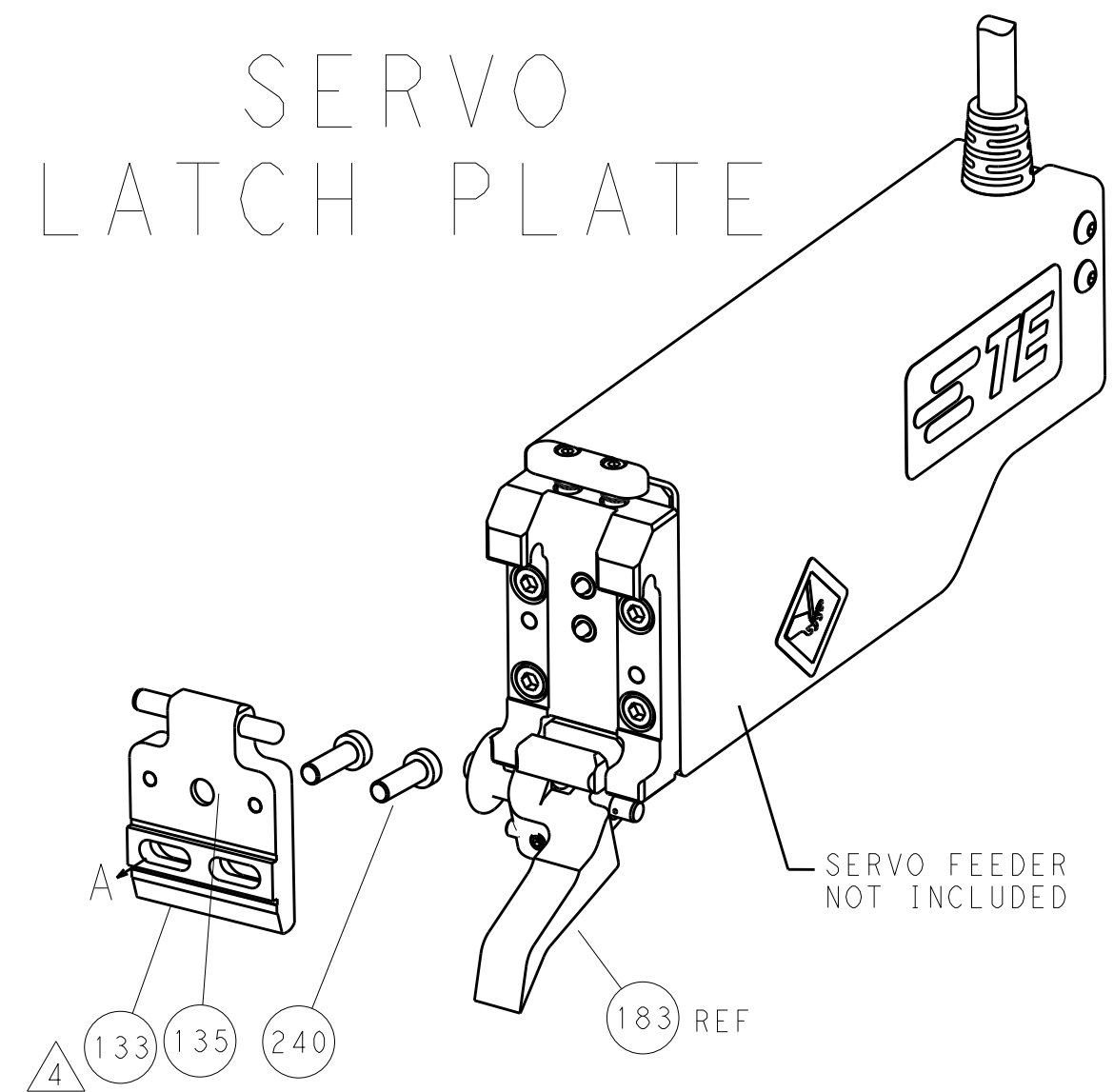
FEED TYPE
MECHANICAL



PNEUMATIC



SERVO
LATCH PLATE

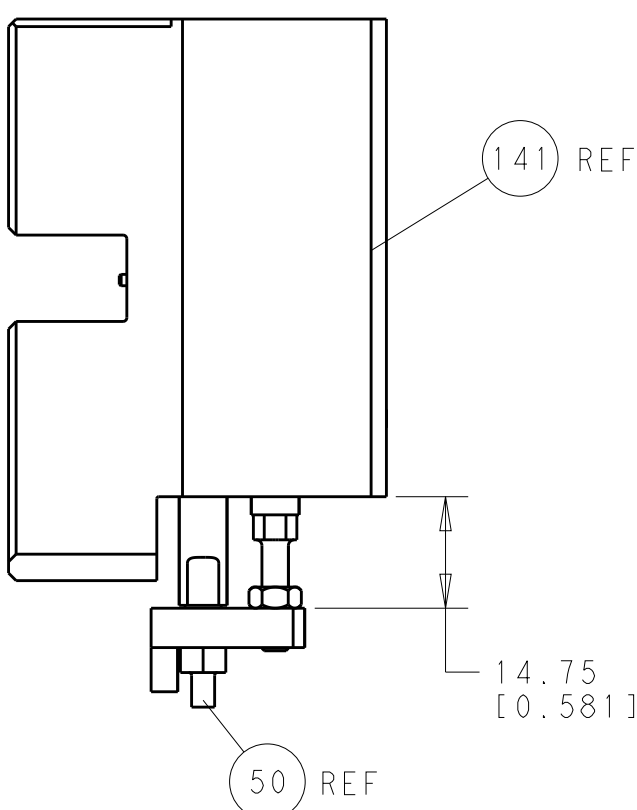


CAM POSITIONS

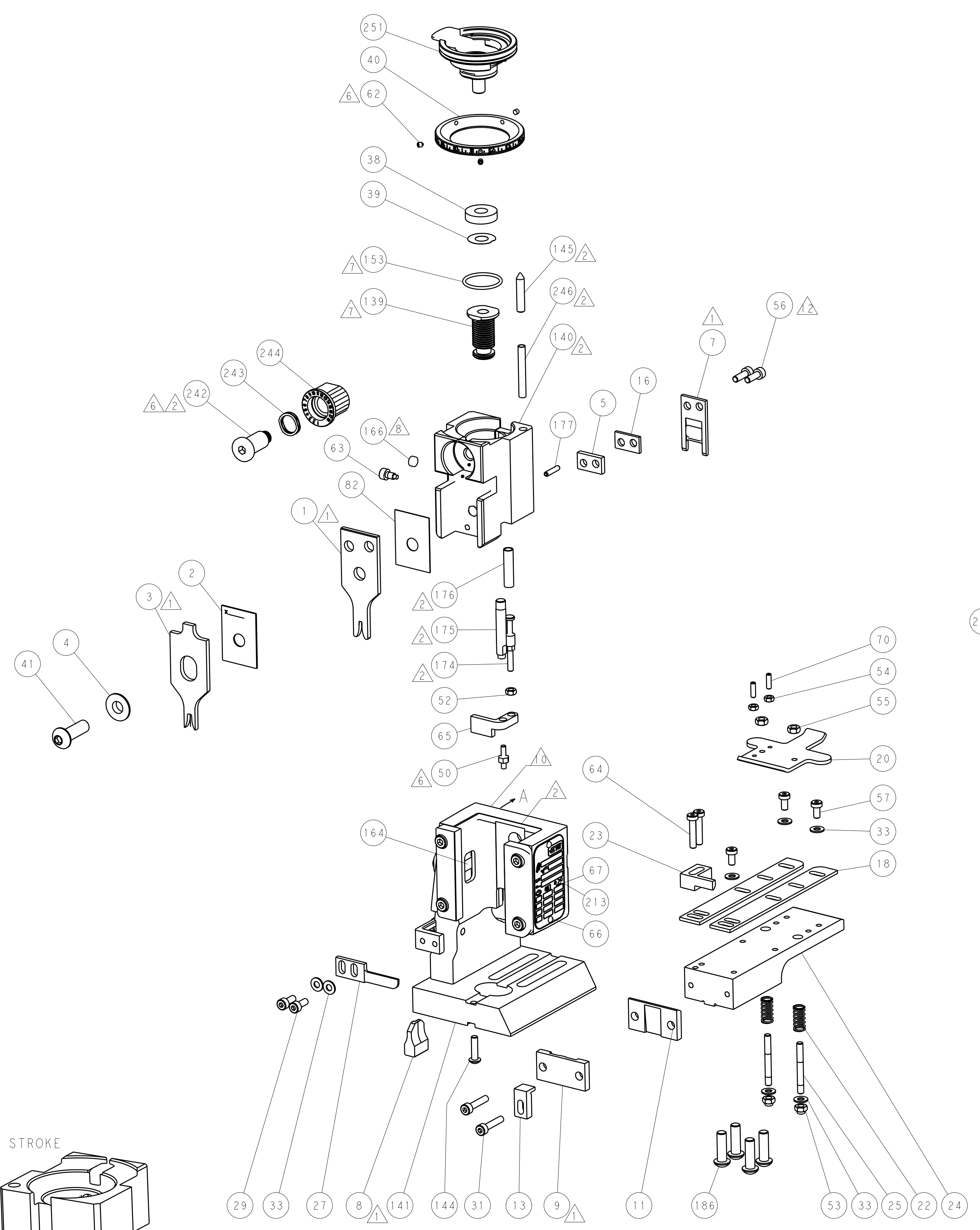
ATLANTIC VERSION
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THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.				OWN L. ZHANG 19DEC2011				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK L. ZHANG 19DEC2011				NAME Ocean End Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.001 ANGLES ±0.001				PRODUCT SPEC - APPLICATION SPEC -				SIZE A1			
MATERIAL -				WEIGHT -				CAGE CODE 00779			
FINISH -				Customer Accessible Production Drawing				SCALE 1:1			
				SHEET 2				REV B			

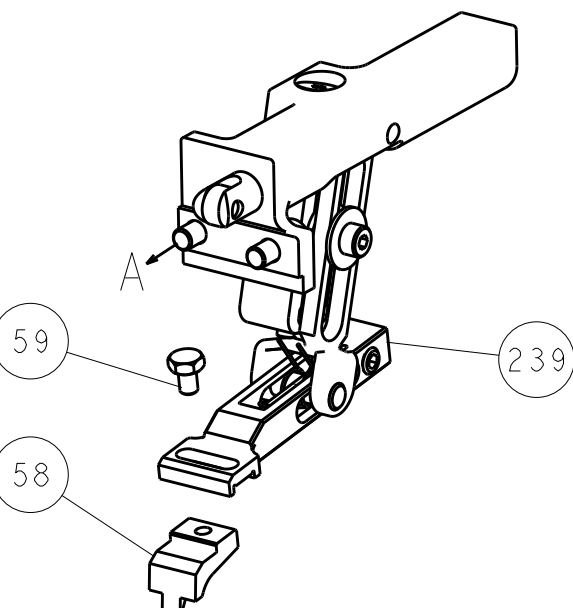
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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



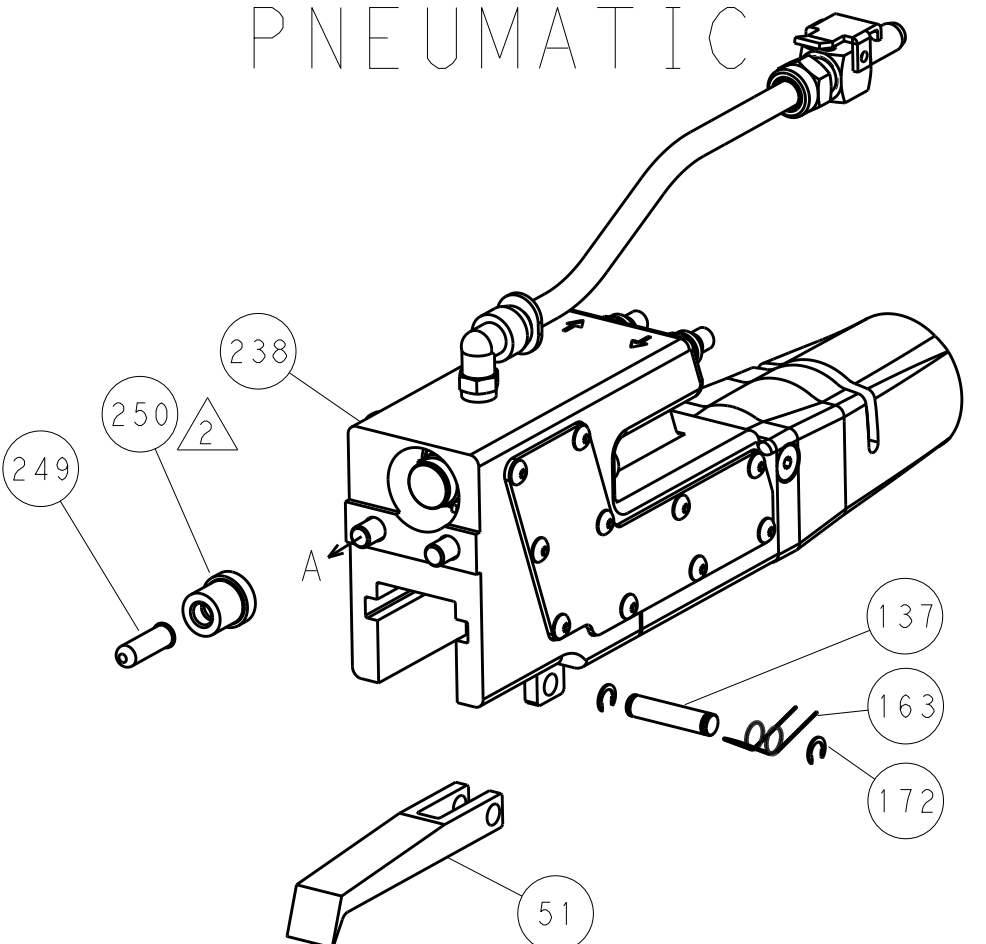
HOLDDOWN SET-UP



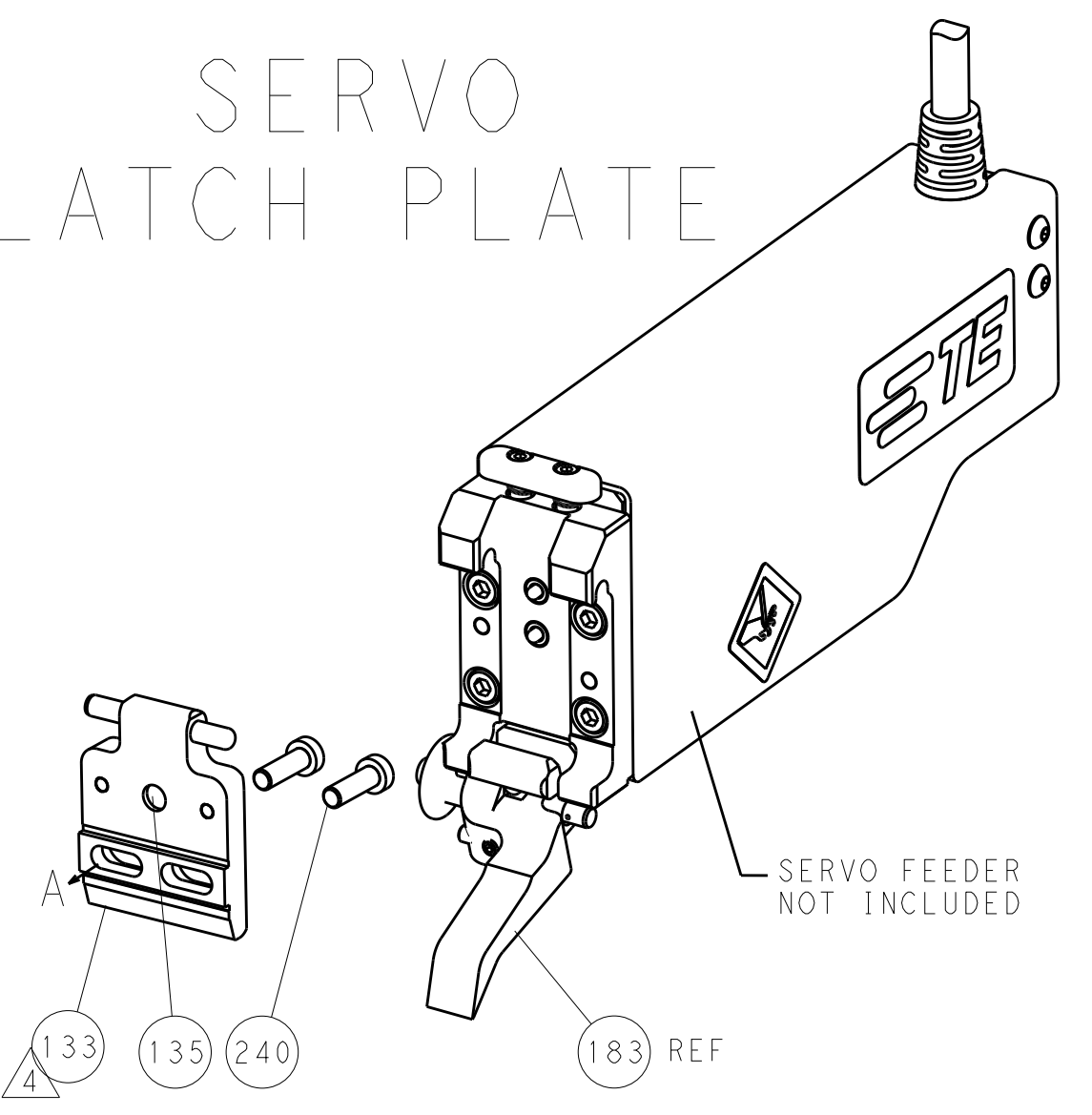
FEED TYPE
MECHANICAL



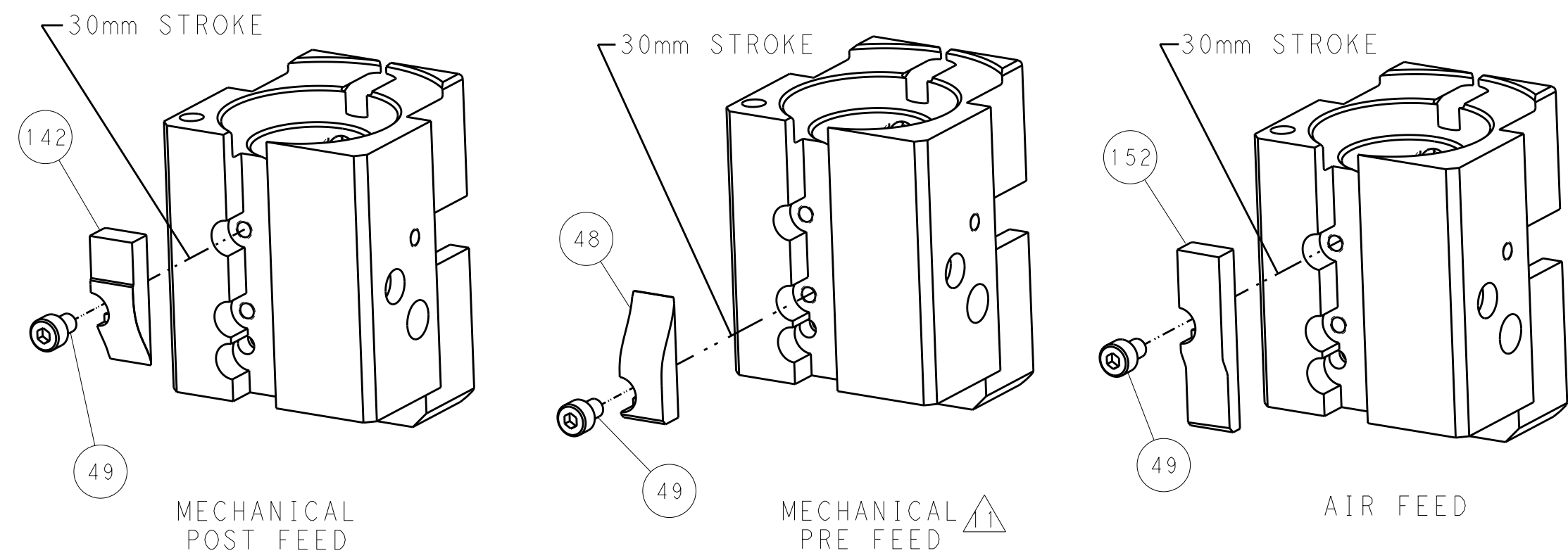
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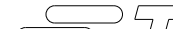
SERVO
LATCH PLATE



CAM POSITIONS



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

TE CONNECTIVITY CORPORATION 11-15 SUBJECT TO CHANGE WITHOUT NOTICE, UNLESS OTHERWISE INDICATED TE CONNECTIVITY IS A REGISTERED TRADEMARK OF TE CONNECTIVITY CORPORATION										DWN		19DEC2011		 TE Connectivity Harrisburg, PA 17105-3608											
DIMENSIONS:										L. ZHANG		19DEC2011													
mm										APVD		S. XI		NAME											
										PRODUCT SPEC		Ocean End Feed Applicator -													
										0 PLC ±0.5															
										1 PLC ±0.5															
										2 PLC ±0.13															
										3 PLC ±0.13															
MATERIAL										WEIGHT		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO							
-										-		A		00779		C=2150013		-							
-										-		Customer Accessible Production Drawing													
-										-		SCALE		1:1		SHEET		4		OF		REV		B	