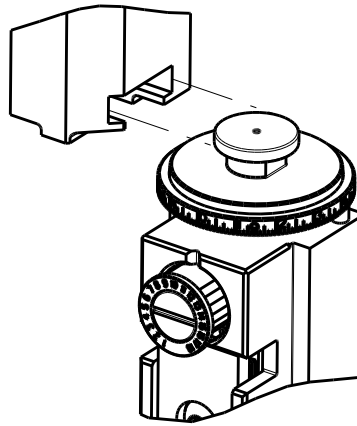
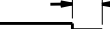


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150338-1	A	FINE CRIMP HEIGHT ADJUST
	2150338-2	A	FINE CRIMP HEIGHT ADJUST
	2150338-5	A	FINE CRIMP HEIGHT ADJUST
	2150338-6	A	NON-CRIMP HEIGHT ADJUST
	2150338-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150338-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.90-6.90 mm [.232-.272 IN]			Ø3.60-5.00 mm [.142-.197 IN]
TERMINAL APPLICATION	114-64027	-	-
SPECIFICATION		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178301-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
10 AWG		2.28+/-0.05 [.090+/- .002]		2.6
12 AWG		1.96+/-0.05 [.077+/- .002]		4.3
14 AWG		1.71+/-0.05 [.067+/- .002]		6



- RECOMMENDED SPARE PARTS
- 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: 8-2150338-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150338-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150338-5
 - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150338-6
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 ITEM 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 50 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- 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. TERMINAL LUBRICANT IS RECOMMENDED.

*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)

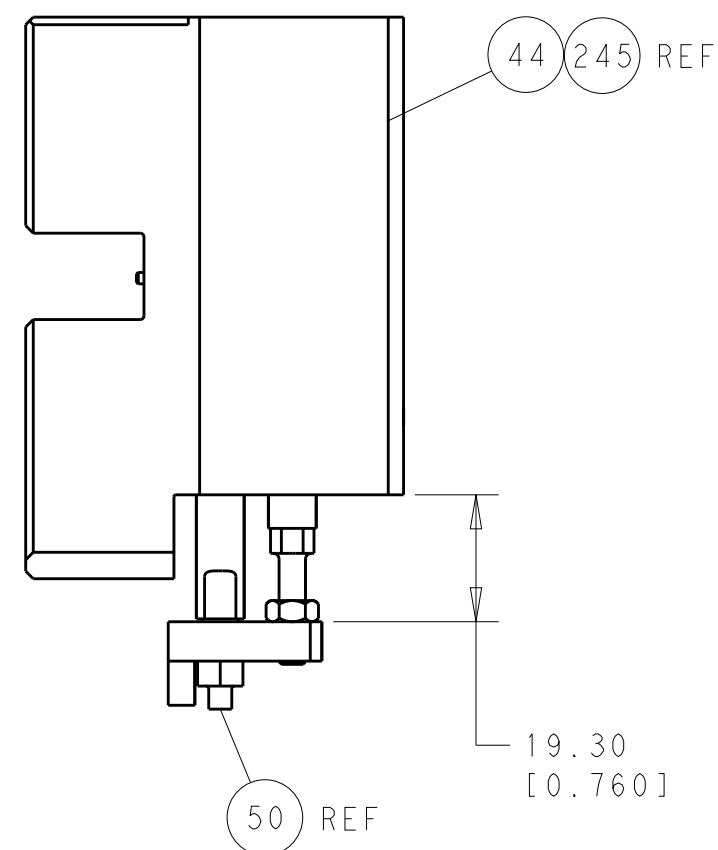
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS				
P	LTR	DESCRIPTION			DATE	DWN	APVD
	A	RELEASE			15JUL2014	XZ	TE
	A1	ECR-15-006528			28APR2015	RS	LZ

	-	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	
6	-	-	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	
	-	REFREFREFREFREFREF	-	-	-	-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84	
	-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82	
	-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
	-	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	1	1	2119943-1	WASHER, SPACER	69	
	-	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	
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	
	-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	-	-	-	-	1	2063961-1	FEED FINGER	58	
	-	4	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
	-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1-1976055-0	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	
6	-	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	
	-	8	8	8	8	8	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	1-1752371-2	PLATE, STRIP GUIDE	24	
	-	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	1901259-7	GUIDE, LOWER STRIP	18	
1	-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
	-	1	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	1	1	1	1	240644-5	PLATE, REAR SHEAR	11	
	-	1	1	1	1	1	6-690482-7	PLATE, FRONT SHEAR	9	
1	1	1	1	1	1	1	1803059-4	ANVIL, COMBINATION, END FEED	8	
	-	1	1	1	1	1	1-2217206-3	BLADE, SLUG	7	
	-	-	-	-	-	-	-	-	6	
	-	1	1	1	1	1	3-240641-5	SPACER	5	
	-	1	1	1	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER	4	
1	1	1	1	1	1	1	8-2119582-3	CRIMPER, INSULATION F PREMIUM	3	
	-	1	1	1	1	1	455888-3	SPACER, CRIMPER	2	
1	1	1	1	1	1	1	6-1633730-7	CRIMPER, WIRE	1	
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO	

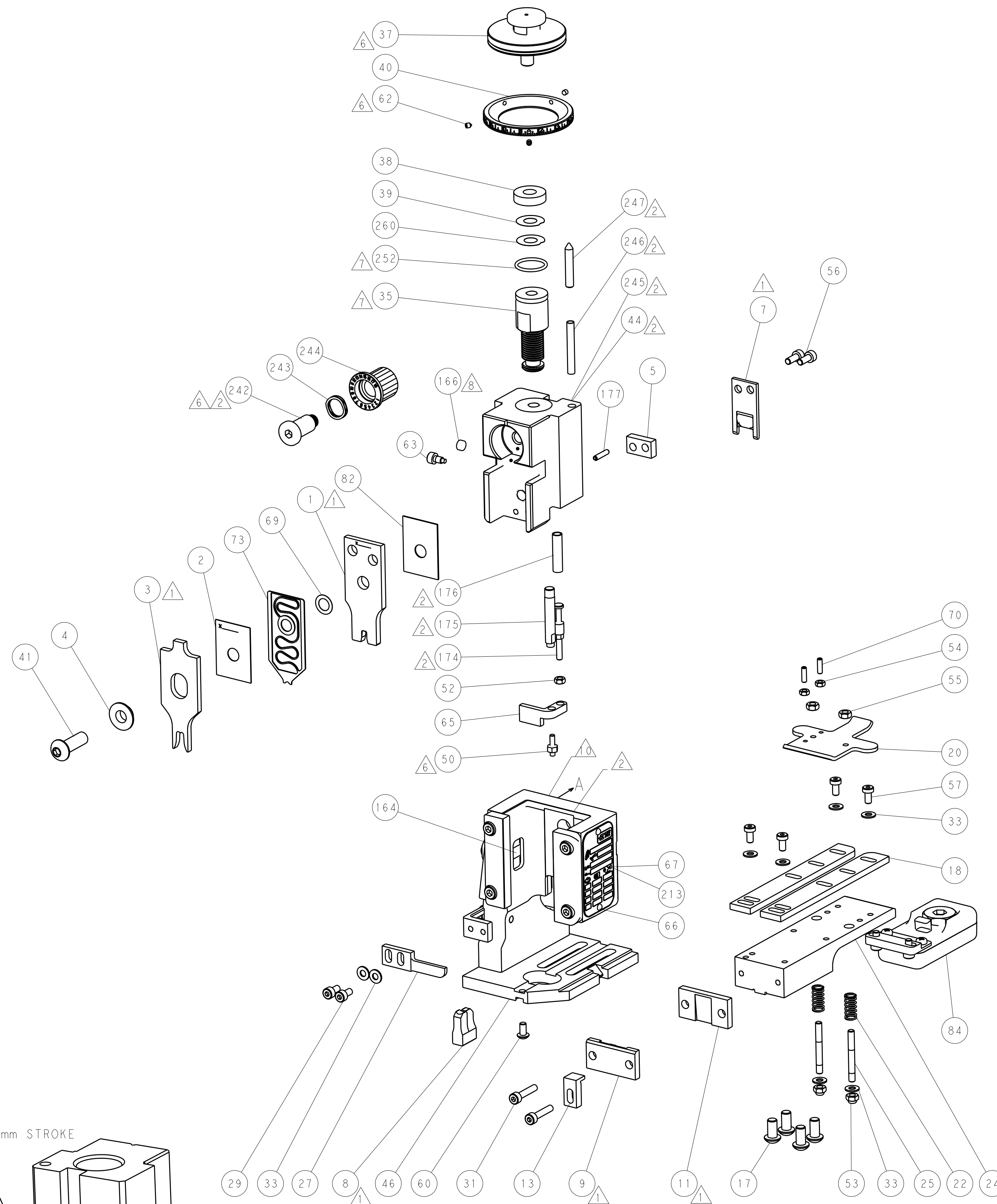
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN T.YIN CHK G.BAILLEY U.GUO APVD 08MAY2013 08MAY2013 08MAY2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		NAME Ocean End Feed Applicator
		PRODUCT SPEC		SIZE A1
MATERIAL -		APPLICATION SPEC		CAGE CODE 00779
FINISH -		WEIGHT -		DRAWING NO C=2150338
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		RESTRICTED TO -
		SCALE 1:1		SHEET 1 OF 4
				REV A1

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

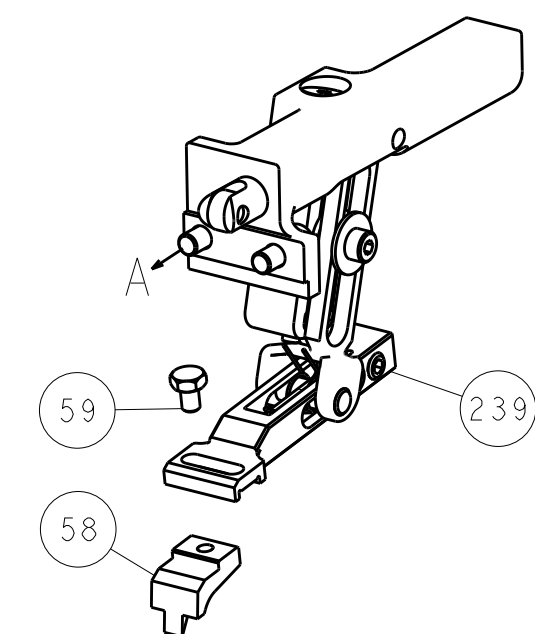
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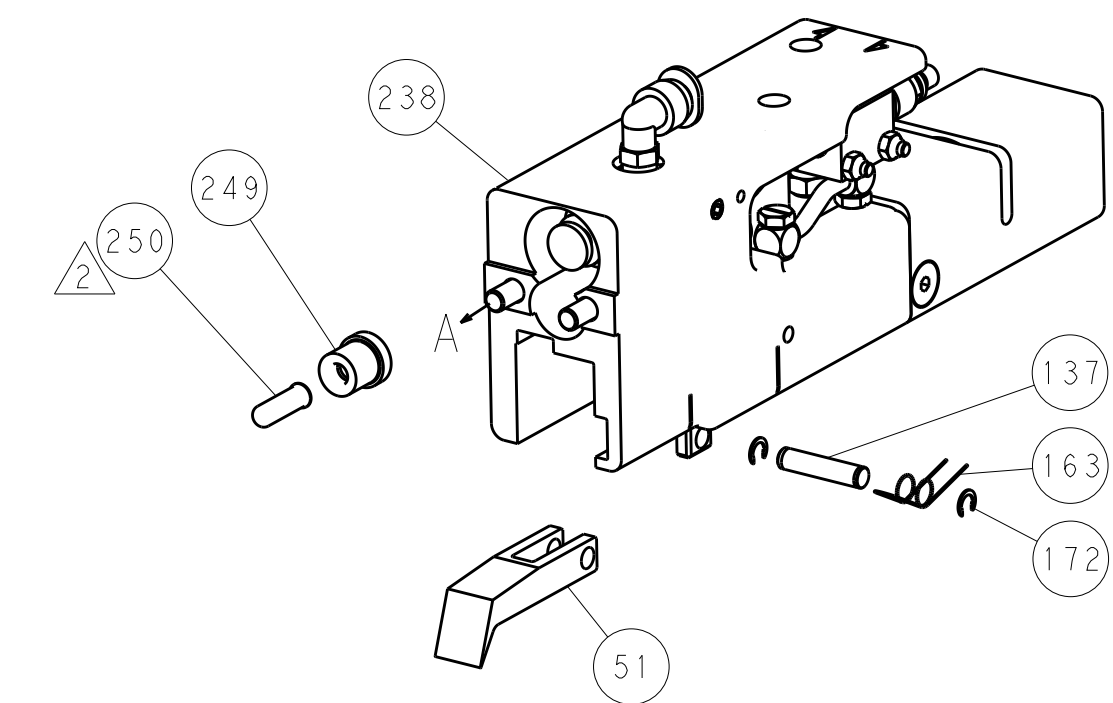
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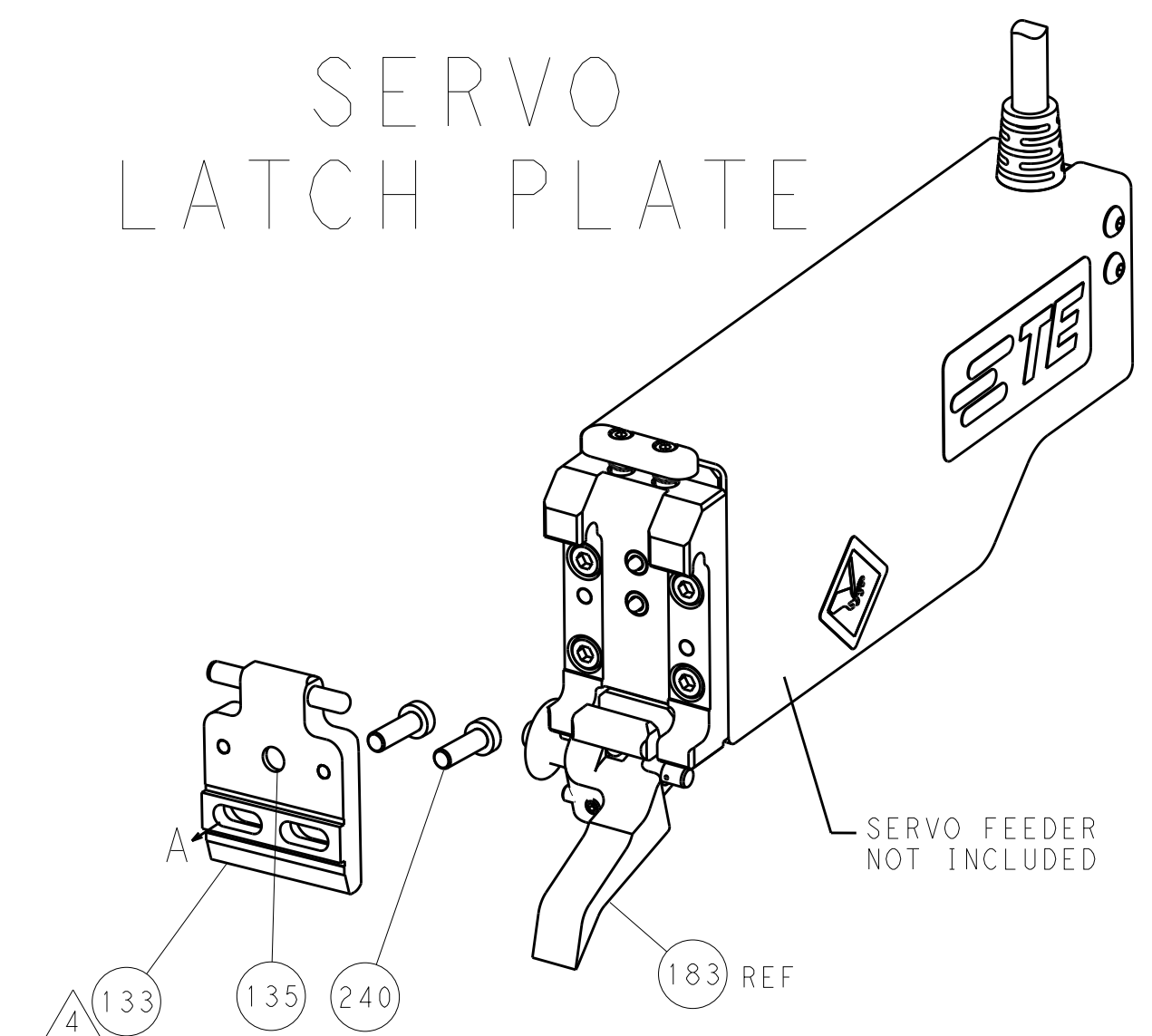
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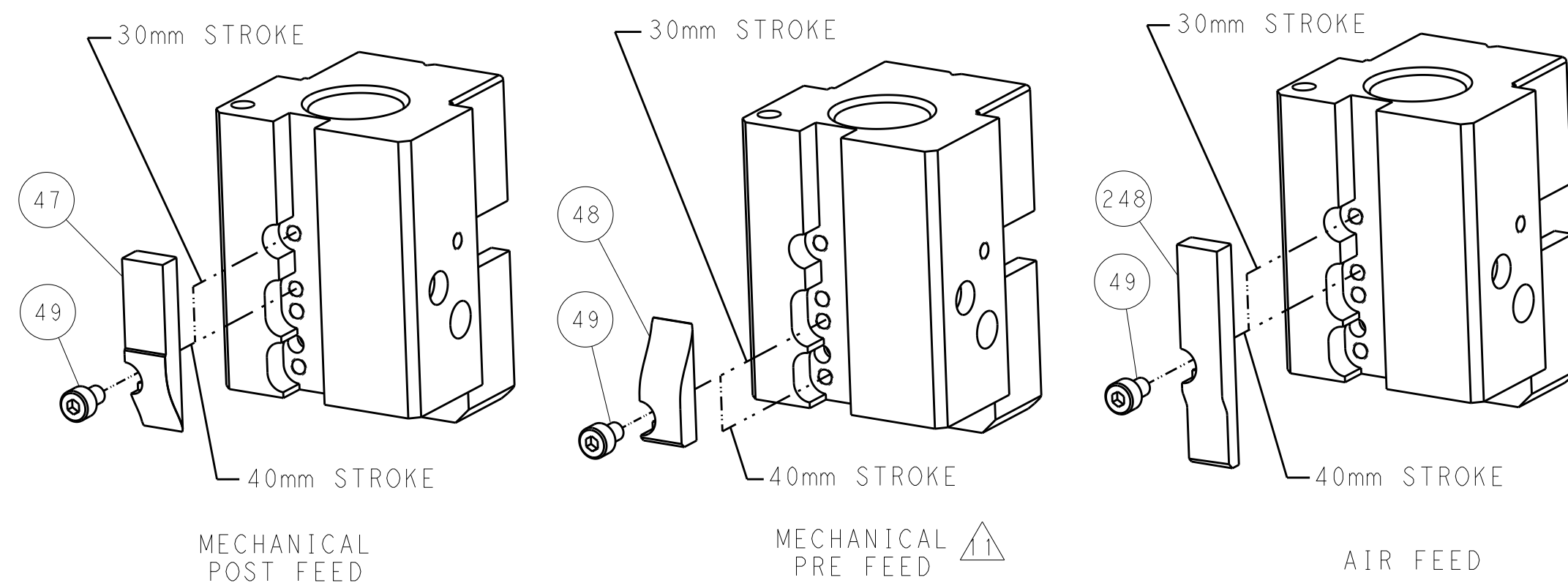
PNEUMATIC



SERVO
LATCH PLATE



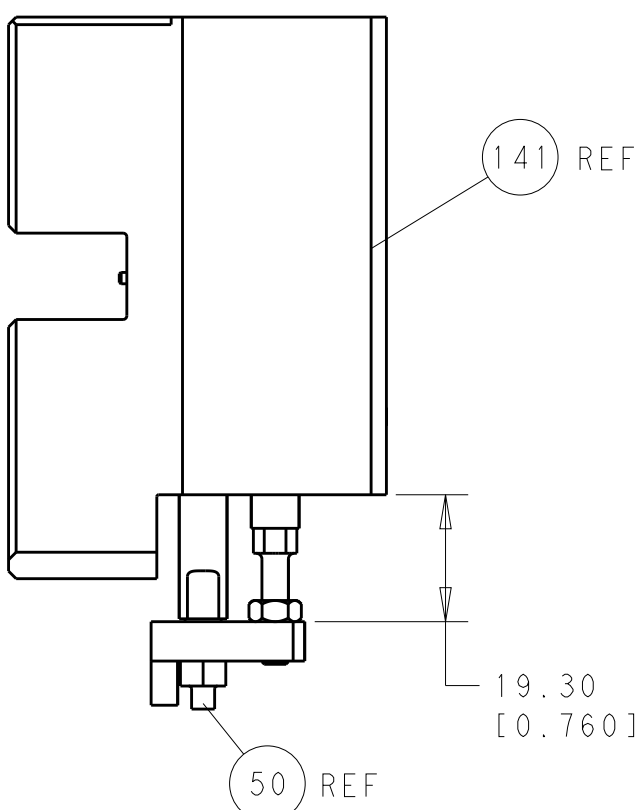
CAM POSITIONS



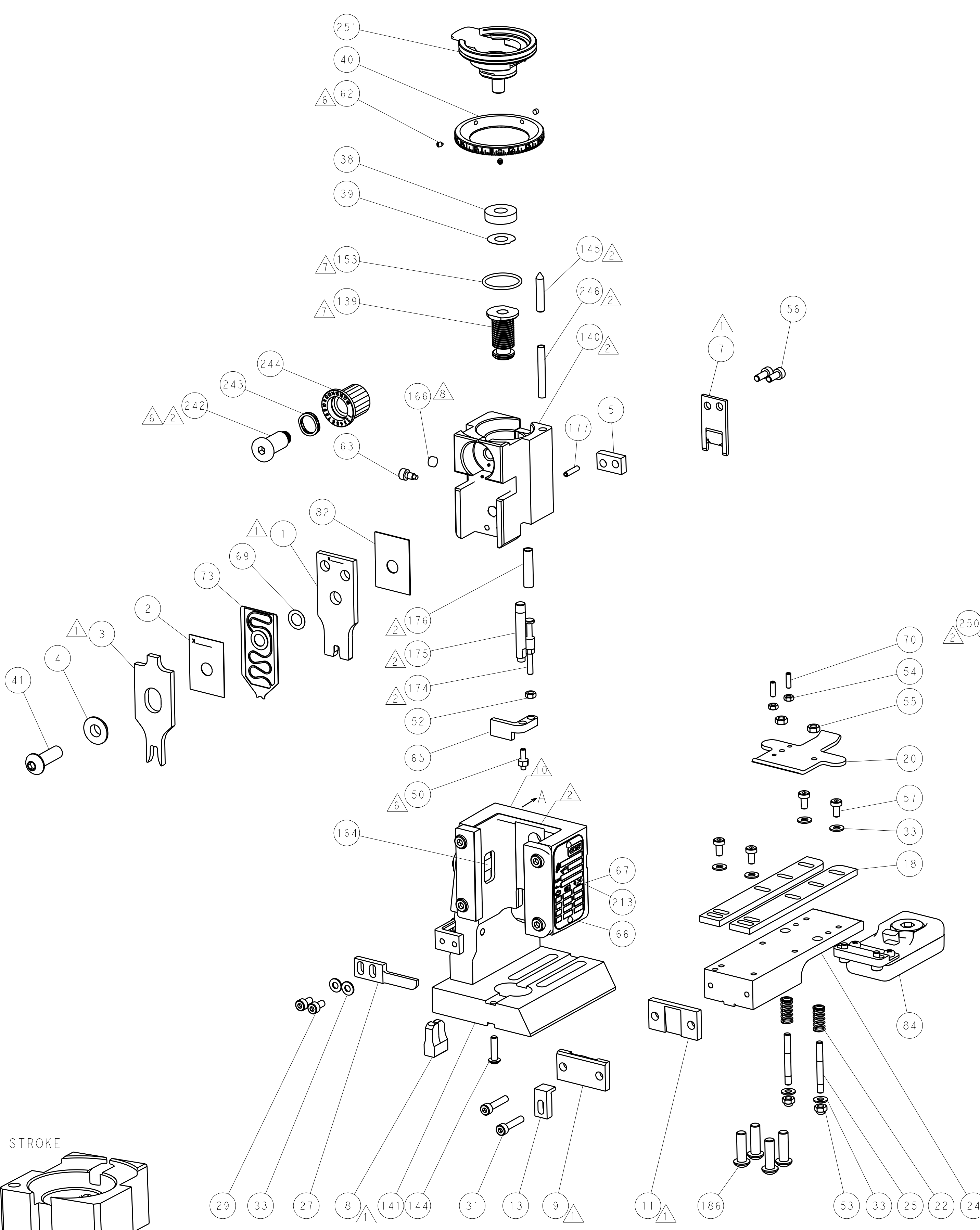
ATLANTIC VERSION
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DIMENSIONS:		CHK G. BAILEY 08MAY2013			
mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
		APVD H. GUO 08MAY2013		Ocean End Feed Applicator	
		PRODUCT SPEC		-	
		APPLICATION SPEC		-	
		SIZE		CAGE CODE	
		DRAWING NO		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT	
-		-		-	
				A1 00779 C=2150338	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
				SCALE 1:1 SHEET 2 of 4 REV A1	

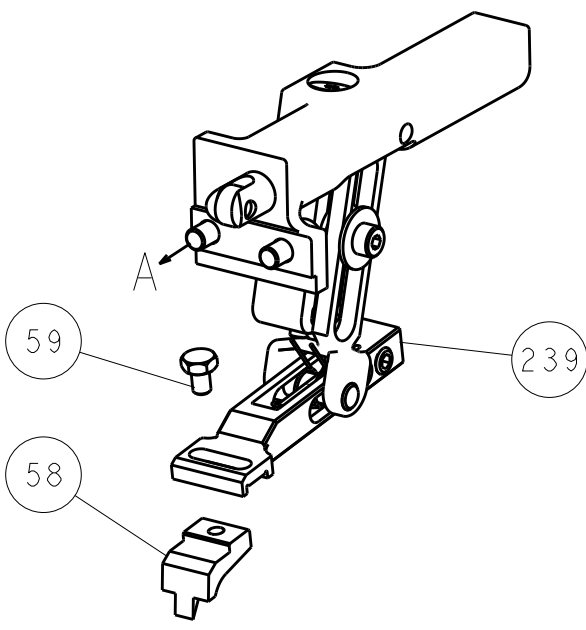
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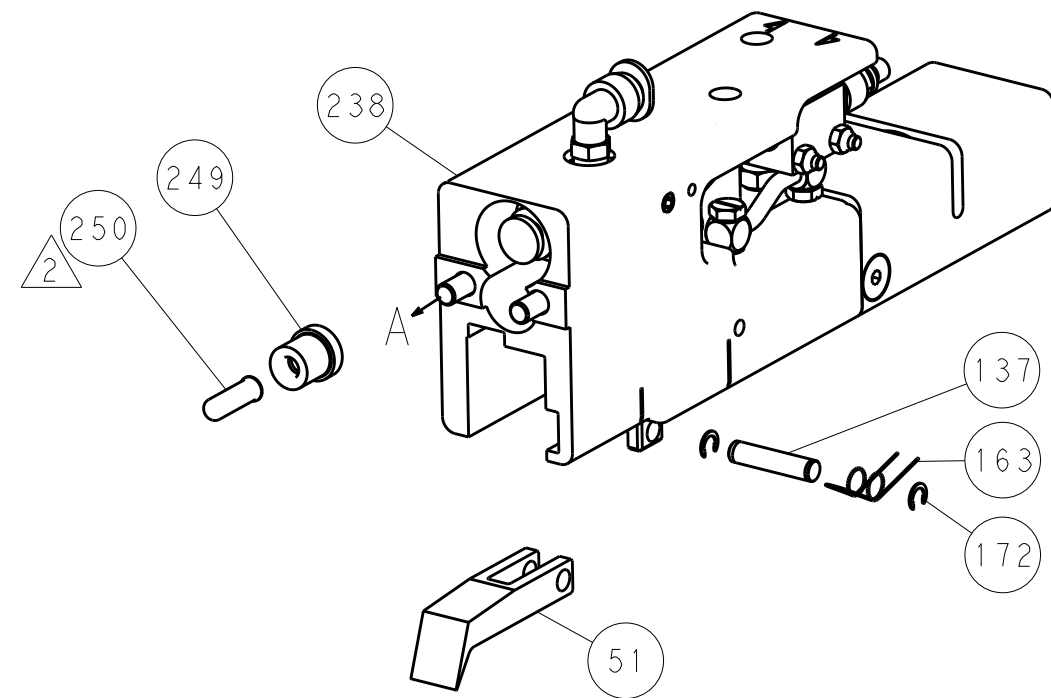
HOLDDOWN SET-UP



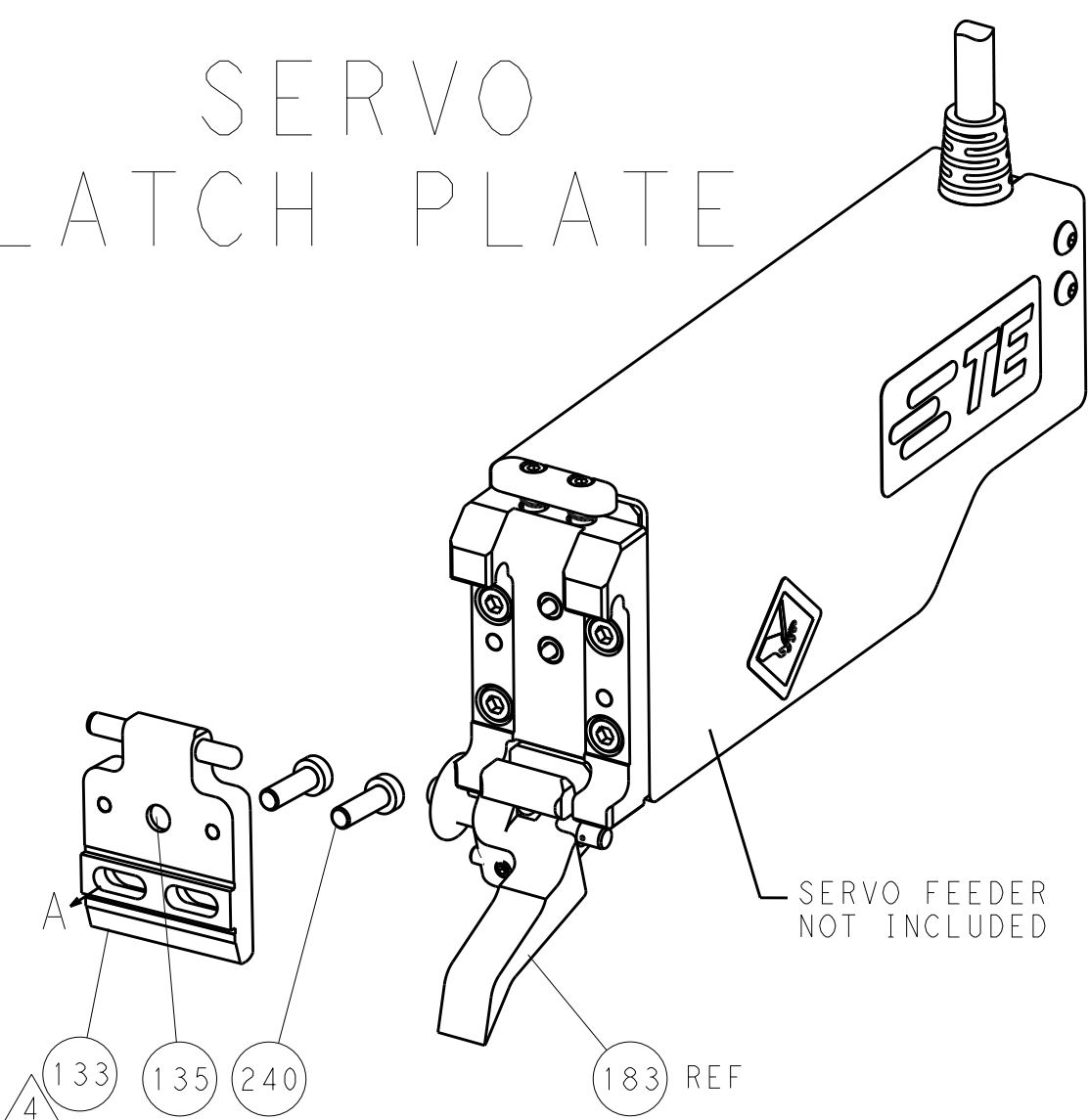
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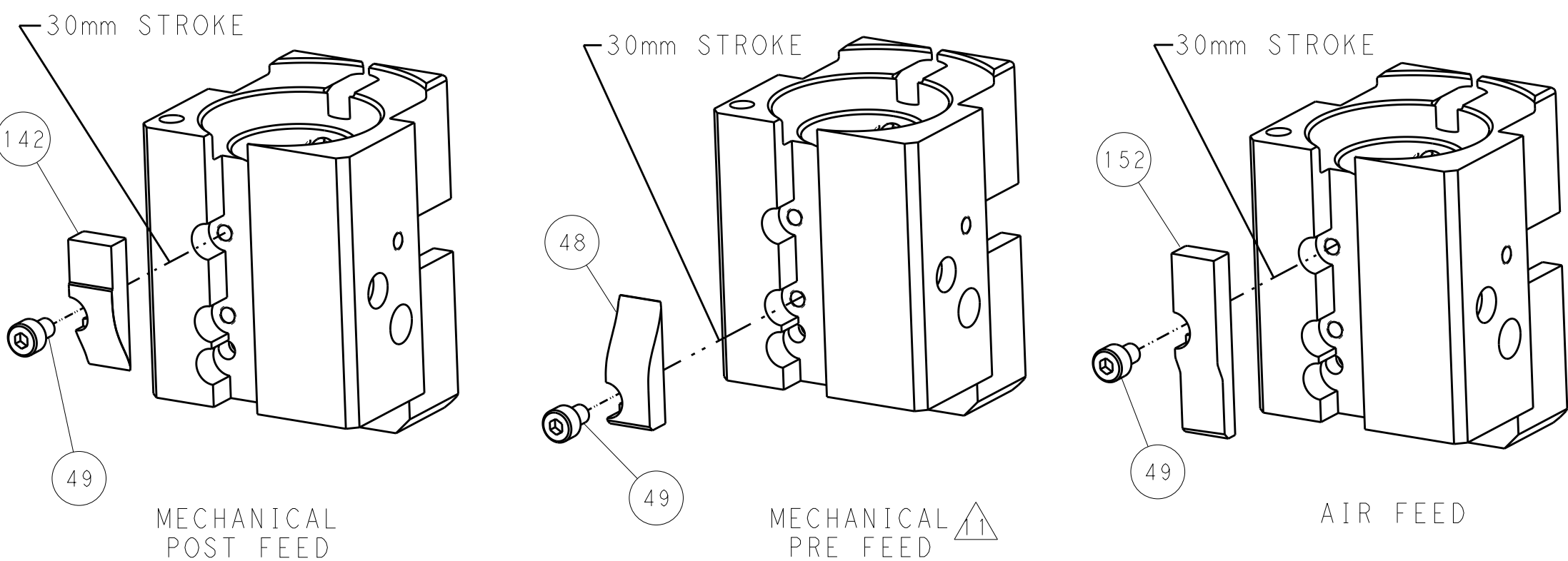
PNEUMATIC



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)

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DIMENSIONS: mm		CHK G. BAILEY 08MAY2013	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.13 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1		APVD J. GUO 08MAY2013	SIZE A1	
MATERIAL		PRODUCT SPEC	CAGE CODE 00779	
		APPLICATION SPEC	DRAWING NO. C=2150338	
		WEIGHT	RESTRICTED TO	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:1	
			SHEET 4 OF 4	
			REV A1	