

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

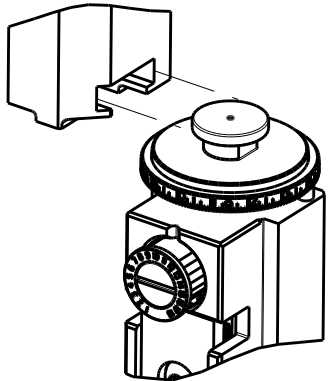
RELEASED FOR PUBLICATION

20

© COPYRIGHT 20

BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

ATLANTIC VERSION  
TERMINATOR  
INTERFACE ADAPTER



PART  
NUMBER

2150041-2

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

PNEUMATIC

PART  
NUMBER

2150041-5

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

SERVO  
LATCH PLATE<sup>4</sup>

PART  
NUMBER

2150041-6

REVISION

A

DESCRIPTION

NON-CRIMP HEIGHT ADJUST

FEED TYPE

SERVO  
LATCH PLATE<sup>4</sup><sup>11</sup>

PART  
NUMBER

2150041-7

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

NONE

PART  
NUMBER

7-2150041-7

REVISION

A

DESCRIPTION

CRIMP TOOLING KIT

FEED TYPE

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.79 mm [.110]

F

INSUL

4.57 mm [.180]

F

APPL INSTRUCTIONS

408-10390

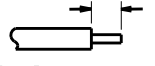


TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: 250 SERIES TAB WITH LATCH

WIRE STRIP LENGTH



INSULATION DIAMETER RANGE



4.80-5.60 mm [.189-.220 IN]

Ø2.10-3.40 mm [.083-.134 IN]

TERMINAL APPLICATION SPECIFICATION



114-5052

-

-

TERMINALS APPLIED



|             |             |             |             |
|-------------|-------------|-------------|-------------|
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 170030-1    | 170030-2    | 170030-3    | 170030-4    |
| 170030-5    | 170030-9    | 170340-1    | 170340-3    |
| 1-170340-3  |             |             |             |

WIRE SIZE





CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING<sup>9</sup>

14 AWG OR 2.00mm2

1.68+/-0.05 [.066+/- .002]

6.8

1.50mm2

1.63+/-0.05 [.064+/- .002]

7.0

16 AWG OR 1.25mm2

1.55+/-0.05 [.061+/- .002]

8.1

18 AWG OR 0.85mm2

1.42+/-0.05 [.056+/- .002]

9.4



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: 8-2150041-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150041-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150041-6

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 & 242.  
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 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

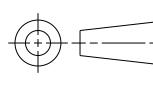
WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119951-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

\*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  | 1  | 1  | 1  | 455888-3  | SPACER, CRIMPER                 | 261     |
| -   | -  | 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)

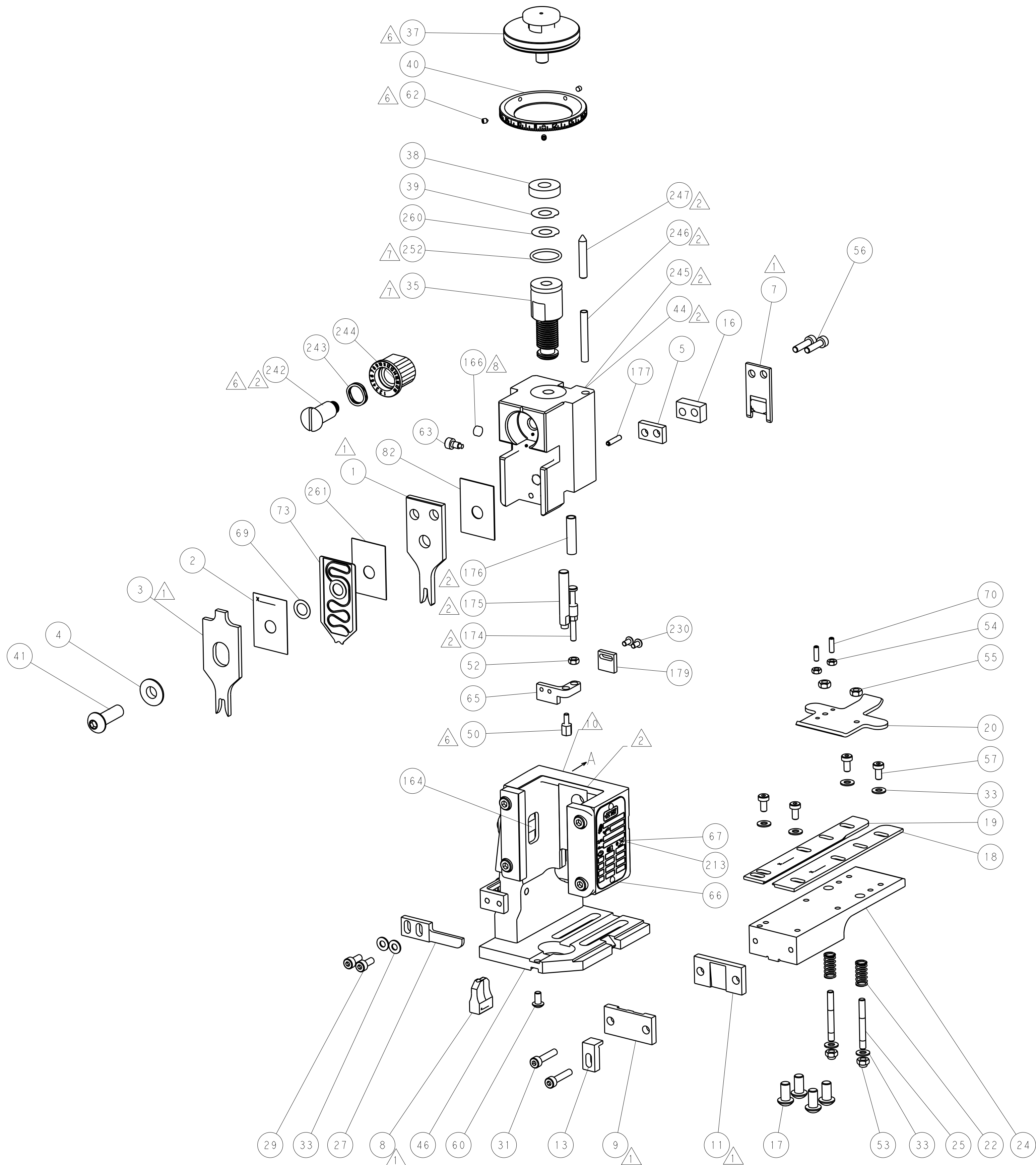
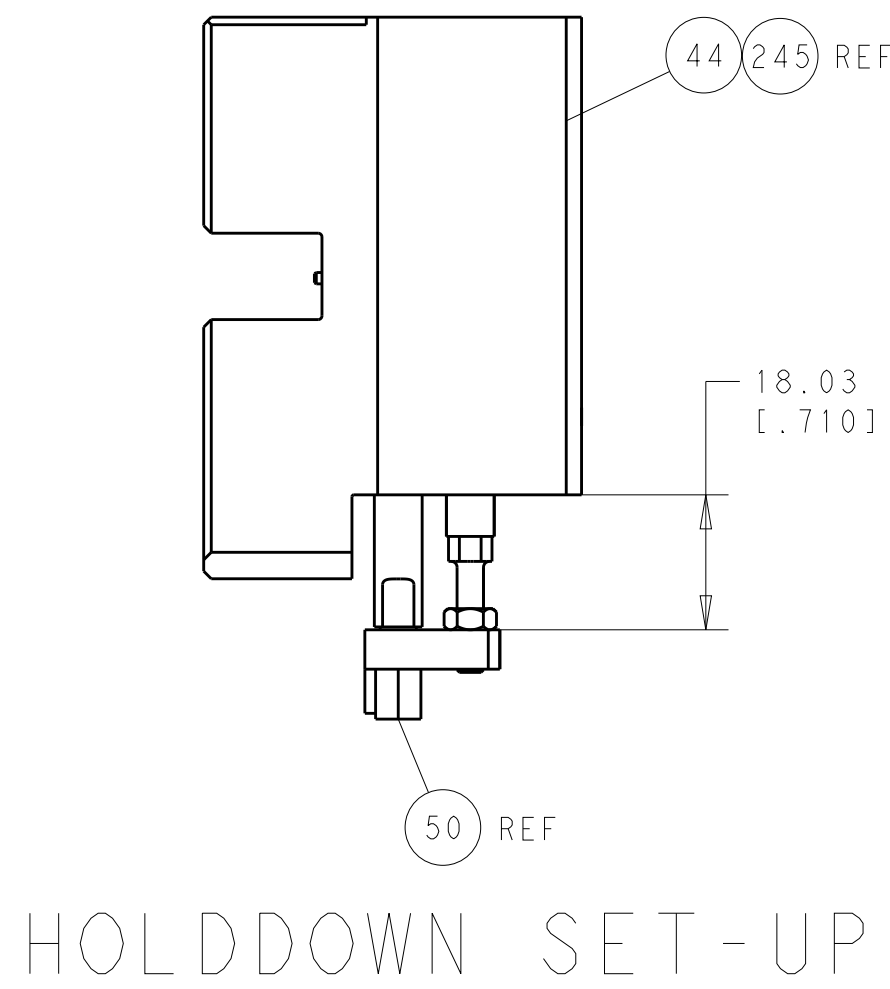
| SET UP GAUGE<br>2119599-2 |              | LOC<br>A | DIST<br>66 | REVISIONS     |             |                                      |         |
|---------------------------|--------------|----------|------------|---------------|-------------|--------------------------------------|---------|
|                           |              | P        | LTR        | DESCRIPTION   | DATE        | DWN                                  | APVD    |
|                           |              |          | 1          | DEVELOPMENT   | 13JAN2012   | KH                                   | SX      |
|                           |              |          | 2          | UPDATE        | 08MAY2013   | CC                                   | UG      |
|                           |              | A        |            | RELEASED      | 06AUG2013   | YY                                   | UG      |
|                           |              | A1       |            | ECR-14-007662 | 22MAY2014   | JH                                   | 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             | 2063440-2   | AIR FEED MODULE                      | 238     |
| -                         | 2            | 2        | 2          | 2             | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)             | 230     |
| -                         | -            | 1        | 1          | -             | 2119740-2   | TAG, IDENTIFICATION                  | 213     |
| -                         | -            | REFREF   | -          | -             | 1901697-1   | FEED FINGER ASSEMBLY,EF              | 183     |
| -                         | 1            | 1        | 1          | 1             | 1-1976053-7 | LOCATER BLOCK,TERMINAL               | 179     |
| -                         | 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            | 1        | 1          | 1             | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY       | 166     |
| -                         | REFREFREFREF |          |            |               | 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             | 455888-5    | SPACER, CRIMPER                      | 82      |
| -                         | 1            | 1        | 1          | 1             | 2119791-9   | 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, 2 x .188     | 66      |
| -                         | 1            | 1        | 1          | 1             | 1-1901681-5 | HOLDDOWN, TERMINAL                   | 65      |
| -                         | 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      |
| -                         | 4            | 4        | 4          | 4             | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8         | 57      |
| -                         | 2            | 2        | 2          | 2             | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16       | 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            | 1        | 1          | 1             | 1-1752354-1 | STANDOFF,HOLD-DOWN                   | 50      |
| -                         | -            | -        | -          | 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             | 1-2119644-2 | 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             | 1752371-1   | 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             | 1901696-3   | STRIP GUIDE, REAR                    | 19      |
| -                         | 1            | 1        | 1          | 1             | 1901695-3   | STRIP GUIDE, FRONT                   | 18      |
| -                         | 4            | 4        | 4          | 4             | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12)            | 17      |
| -                         | 1            | 1        | 1          | 1             | 1-240641-5  | SPACER                               | 16      |
| -                         | 1            | 1        | 1          | 1             | 1752360-1   | SPACER,HOLD-DOWN                     | 13      |
| -                         | 1            | 1        | 1          | 1             | 240644-1    | PLATE, REAR SHEAR                    | 11      |
| -                         | -            | -        | -          | -             | -           | -                                    | 10      |
| -                         | 1            | 1        | 1          | 1             | 2-690482-7  | PLATE, FRONT SHEAR                   | 9       |
| -                         | 1            | 1        | 1          | 1             | 1-1333219-1 | ANVIL, COMBINATION                   | 8       |
| -                         | 1            | 1        | 1          | 1             | 1-2217206-1 | BLADE, SLUG                          | 7       |
| -                         | 1            | 1        | 1          | 1             | 1-240641-0  | SPACER                               | 5       |
| -                         | 1            | 1        | 1          | 1             | 238009-1    | BLOCK, FL CRIMPER SPACER             | 4       |
| -                         | 1            | 1        | 1          | 1             | 2119582-3   | CRIMPER, INSULATION F PREMIUM        | 3       |
| -                         | 1            | 1        | 1          | 1             | 455888-1    | SPACER, CRIMPER                      | 2       |
| -                         | 1            | 1        | 1          | 1             | 456408-6    | CRIMPER, WIRE PREMIUM                | 1       |
| -77                       | -7           | -6       | -5         | -2            | PART NO     | DESCRIPTION                          | ITEM NO |

|                                                                                                                                                                                                                              |  |                                                                                                                                  |           |                                                                                                                                    |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------------------------------------------------------------------------------------------------|-----------|------------------------------------------------------------------------------------------------------------------------------------|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND DOES NOT CONSTITUTE AN ENDORSEMENT. IT IS SUBJECT TO CHANGE AND DOES NOT CONSTITUTE AN ENDORSEMENT. IT IS SUBJECT TO CHANGE AND DOES NOT CONSTITUTE AN ENDORSEMENT. |  | DWN<br>K. HUANG                                                                                                                  | 13JAN2012 |  TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| CHK<br>S. XI                                                                                                                                                                                                                 |  | APVD<br>J. CRUZ                                                                                                                  | 13JAN2012 | NAME<br>Ocean End Feed<br>Applicator                                                                                               |  |
| DIMENSIONS:<br>mm                                                                                                                                                                                                            |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.5<br>1 PLC ±0.13<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.0001<br>ANGLES ±.5 |           | PRODUCT SPEC                                                                                                                       |  |
|                                                                                                                                         |  | APPLICATION SPEC                                                                                                                 |           | SIZE<br>A1                                                                                                                         |  |
| MATERIAL<br>-                                                                                                                                                                                                                |  | FINISH<br>-                                                                                                                      |           | WEIGHT<br>-                                                                                                                        |  |
|                                                                                                                                                                                                                              |  |                                                                                                                                  |           | Customer Accessible Production Drawing                                                                                             |  |
|                                                                                                                                                                                                                              |  |                                                                                                                                  |           | SCALE<br>1:1                                                                                                                       |  |
|                                                                                                                                                                                                                              |  |                                                                                                                                  |           | SHEET<br>1 OF 4                                                                                                                    |  |
|                                                                                                                                                                                                                              |  |                                                                                                                                  |           | REV<br>A1                                                                                                                          |  |

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

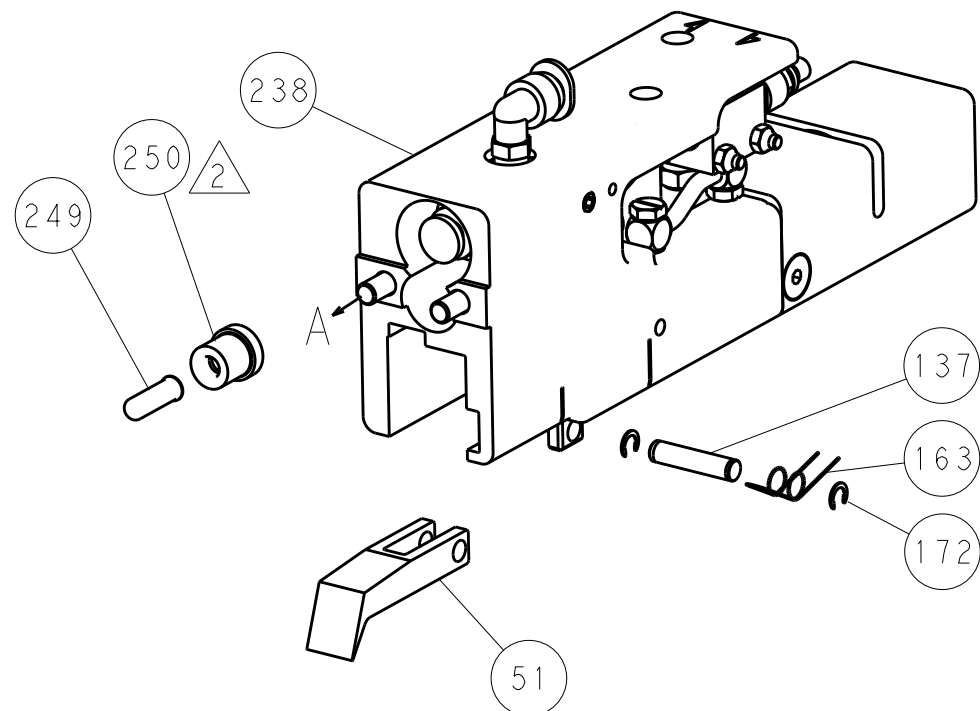
AMP 4805 REV 31MAR2000

| LOC | DIST | REVISIONS |     |             |      |     |
|-----|------|-----------|-----|-------------|------|-----|
|     |      | P         | LTR | DESCRIPTION | DATE | DWN |
| A   | 66   | -         | -   | SEE SHEET 1 | -    | -   |
|     |      |           |     |             |      |     |
|     |      |           |     |             |      |     |
|     |      |           |     |             |      |     |

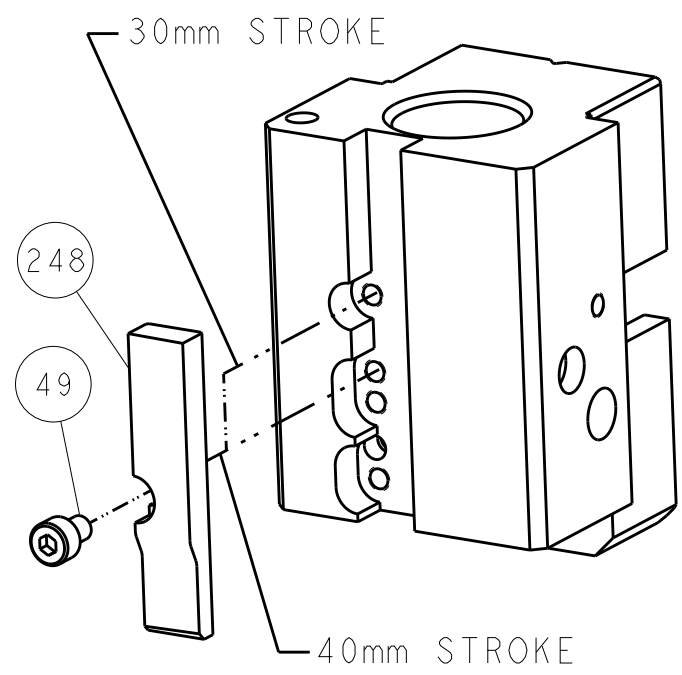


FEED TYPE

PNEUMATIC

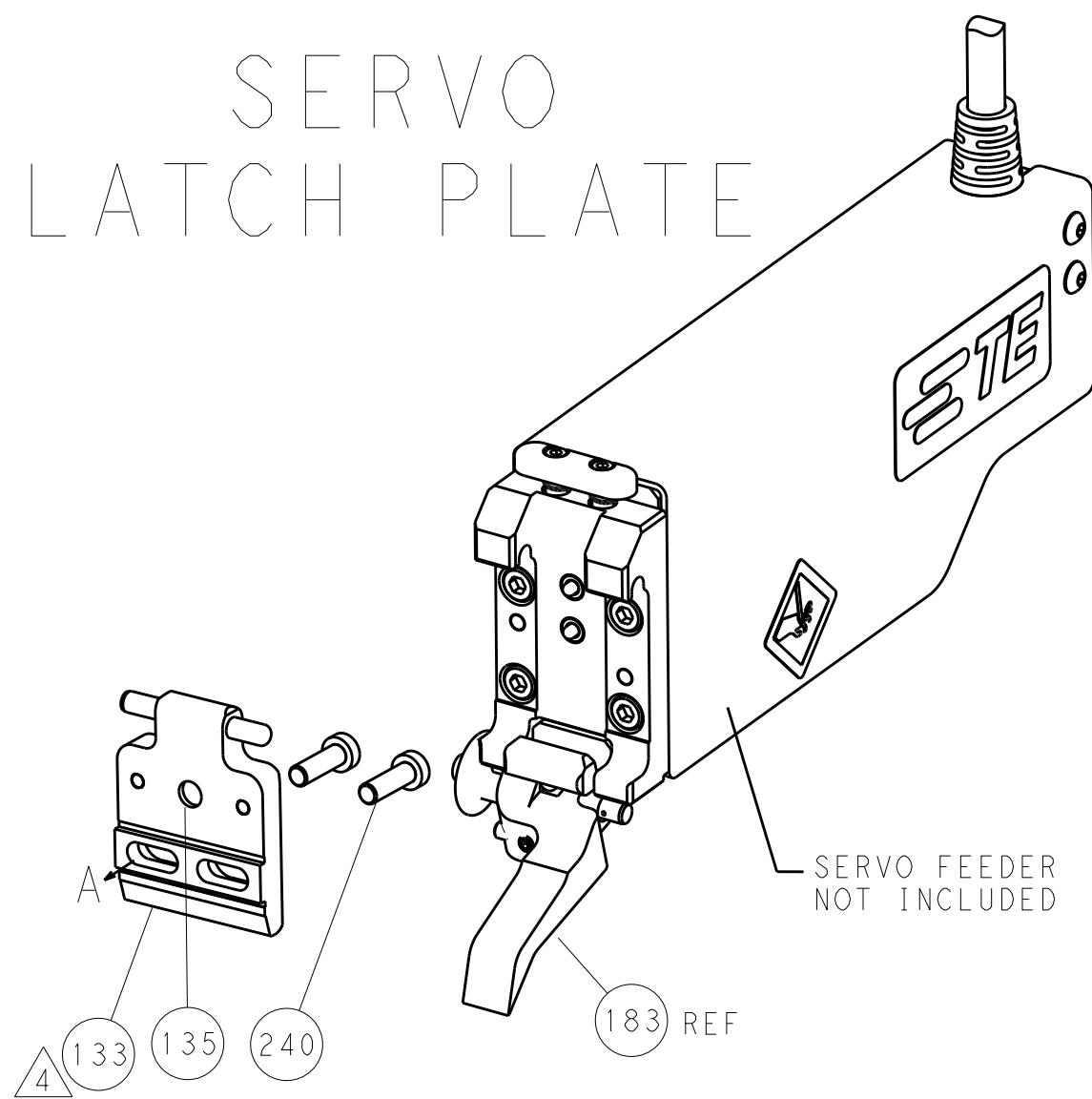


CAM POSITION



AIR FEED

SERVO LATCH PLATE



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 K. HUANG 13JAN2012 |  | STE                                    |  | TE Connectivity |  |
| mm          |  | 0 PLC ±.5                              |  | CHK S. XI 13JAN2012    |  | Harrisburg, PA 17105-3608              |  | NAME            |  |
|             |  | 1 PLC ±0.13                            |  | APVD J. CRUZ 13JAN2012 |  | PRODUCT SPEC                           |  | SIZE            |  |
|             |  | 2 PLC ±0.13                            |  |                        |  | APPLICATION SPEC                       |  | CAGE CODE       |  |
|             |  | 3 PLC ±0.013                           |  |                        |  |                                        |  | DRAWING NO      |  |
|             |  | 4 PLC ±0.0001                          |  |                        |  |                                        |  | 00779           |  |
| MATERIAL    |  | FINISH                                 |  | WEIGHT                 |  | Customer Accessible Production Drawing |  | RESTRICTED TO   |  |
|             |  |                                        |  |                        |  | SCALE 1:1                              |  | SHEET 2 OF 4    |  |
|             |  |                                        |  |                        |  |                                        |  | REV A1          |  |



