

8

7

6

5

4

3

2

1

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

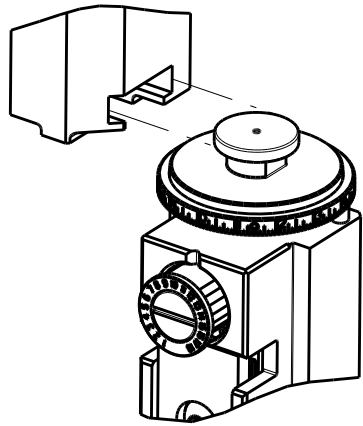
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150236-1

B

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119792-2

-

2119641-1

-

2063440-1

2150236-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2063961-1

5-18022-5

2119653-1

-

-

2150236-5

B

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2063961-1

5-18022-5

2119653-1

-

-

2150236-6

B

NON-CRIMP HEIGHT ADJUST

4

SERVO
LATCH PLATE¹²

-

-

-

-

-

-

2150236-7

B

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2150236-7

B

CRIMP TOOLING KIT

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.57 mm [.062]

F

INSUL

2.29 mm [.090]

F

APPL INSTRUCTIONS

408-10390



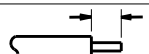
TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: RING

WIRE STRIP LENGTH

2.92-3.68 mm [.115-.145 IN]



INSULATION DIAMETER RANGE

Ø1.02-1.52 mm [.040-.060 IN]



TERMINAL APPLICATION SPECIFICATION

114-2084

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

42547-1

42547-2

60007-2

WIRE SIZE





CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING⁹

22 AWG

1.04+/-0.05 [.041+/- .002]

7.3

24 AWG

0.97+/-0.05 [.038+/- .002]

8.1

26 AWG

0.91+/-0.05 [.036+/- .002]

8.7



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: 8-2150236-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150236-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150236-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150236-6

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

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

SET UP GAUGE

2119599-2

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

DWN

APVD

B

ECR-13-002536

11FEB2013

LG

TE

-

-

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

-

1

1

1

1

1

2119082-6

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

-

-

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

-

-

-

-

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

455888-5

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

1

2119740-1

TAG, IDENTIFICATION

67

-

2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS

66

-

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

2168083-5

SCR, SKT HD CAP, RoHS, M4 X 6.0

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

-

2119792-2

PAWL, EF, AIR

51

-

-

-

-

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

-

1

1

1

1

1

2119644-1

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

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

31

-

2

2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

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

1752371-5

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

1901259-2

GUIDE, LOWER STRIP

18

-

4

4

4

4

4

1-2079383-1

SCR, BHSC, RoHS (M6 X 12)

17

-

1

1

1

1

1

240644-9

PLATE, REAR SHEAR

11

-

-

-

-

-

-

-

-

10

-

1

1

1

1

1

6-690482-0

PLATE, FRONT SHEAR

9

-

1

1

1

1

1

1-1333214-7

ANVIL, EF .062

8

-

1

1

1

1

1

2217206-7

BLADE, SLUG

7

-

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3-238009-5

BLOCK, FL CRIMPER SPACER

4

-

1

1

1

1

1

3-2119582-7

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

1

455888-4

SPACER, CRIMPER

2

-

1

1

1

1

1

1-456403-3

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

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DWN
G. MOYER
15NOV2011

CHK
G. BAILEY
15NOV2011

APVD
G. BAILEY
15NOV2011

DIMENSIONS:
mm

0 PLC
1 PLC
2 PLC
3 PLC
4 PLC
ANGLES

±
±0.5
±0.13
±0.013
±0.001
±

TOLERANCES UNLESS OTHERWISE SPECIFIED:

FINISH

MATERIAL

DWN
G. MOYER
15NOV2011

CHK
G. BAILEY
15NOV2011

APVD
G. BAILEY
15NOV2011

PRODUCT SPEC

APPLICATION SPEC

FINISH

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2150236

CUSTOMER ACCESSIBLE

PRODUCTION DRAWING

SCALE

1:1

SHEET

1

OF

4

REV

B

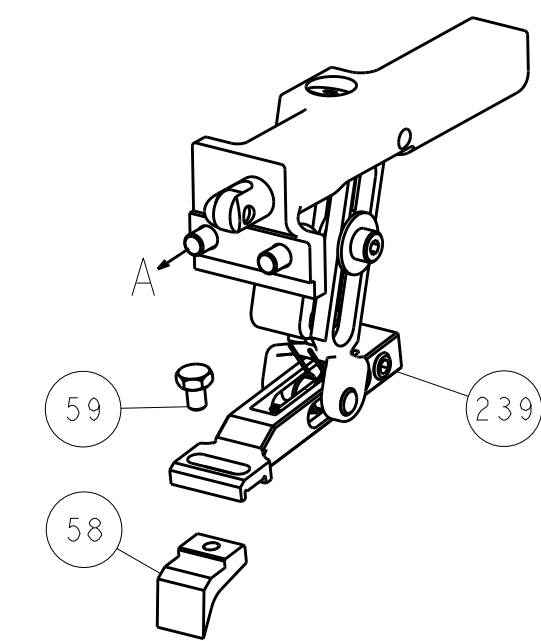
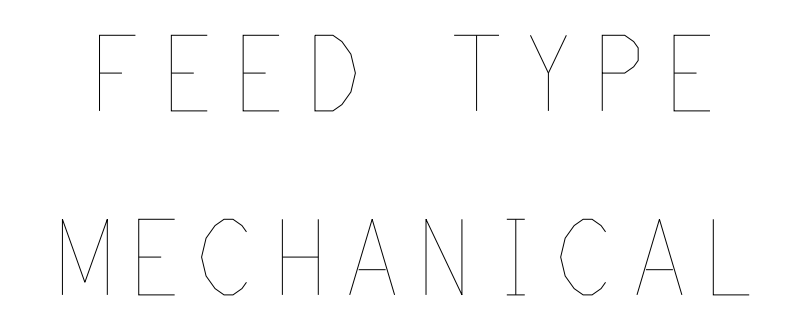
ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

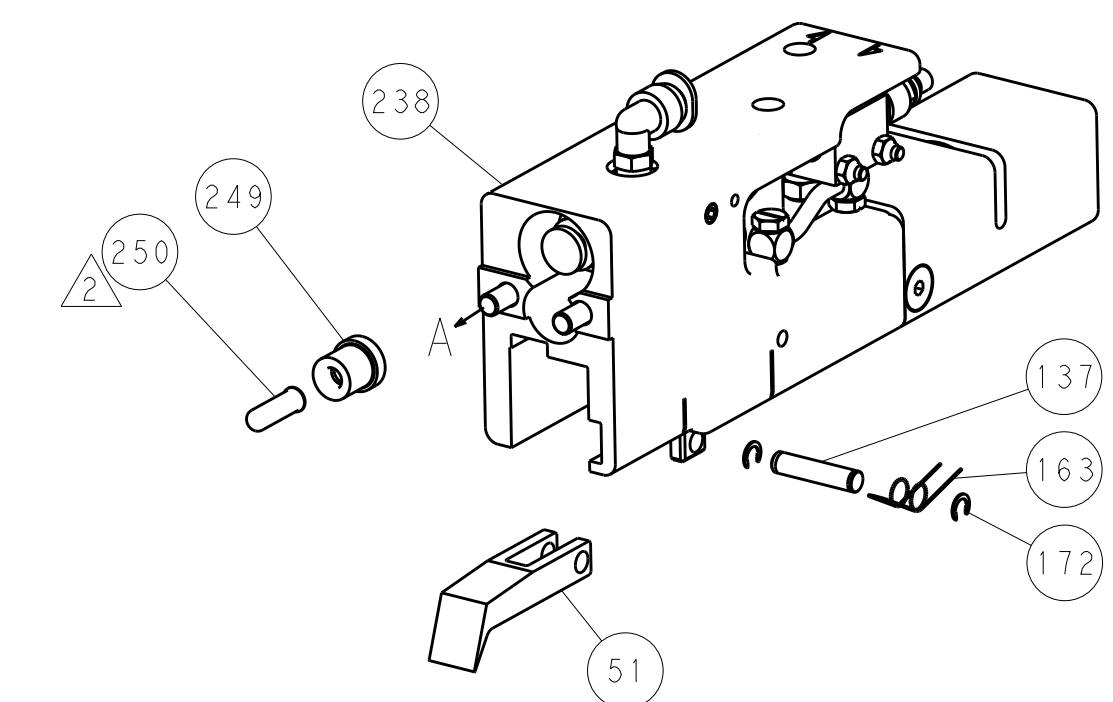
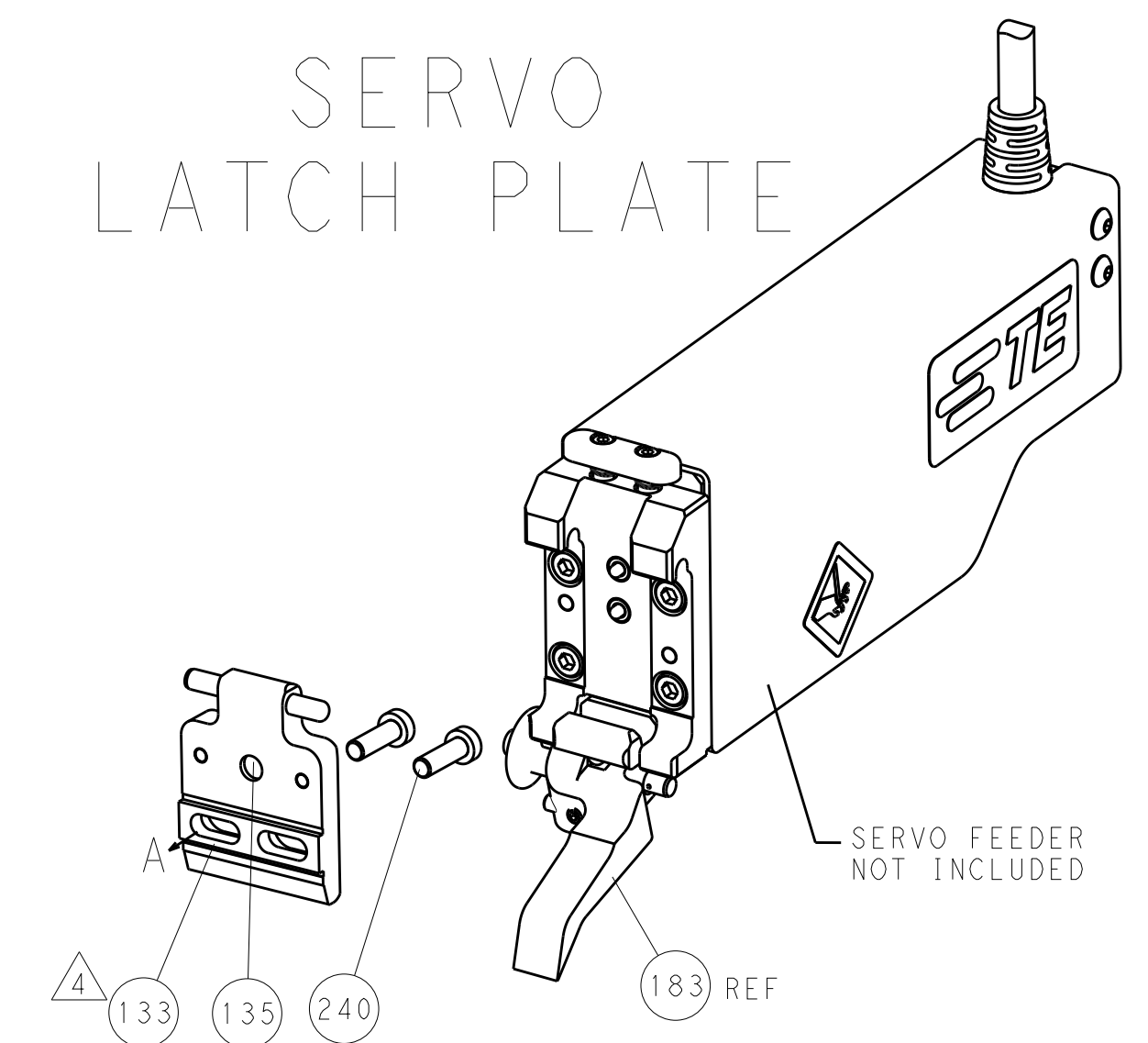
(Pacific version shown on sheets 3 of 4 & 4 of 4)

AMP 4805 REV 31MAR2000

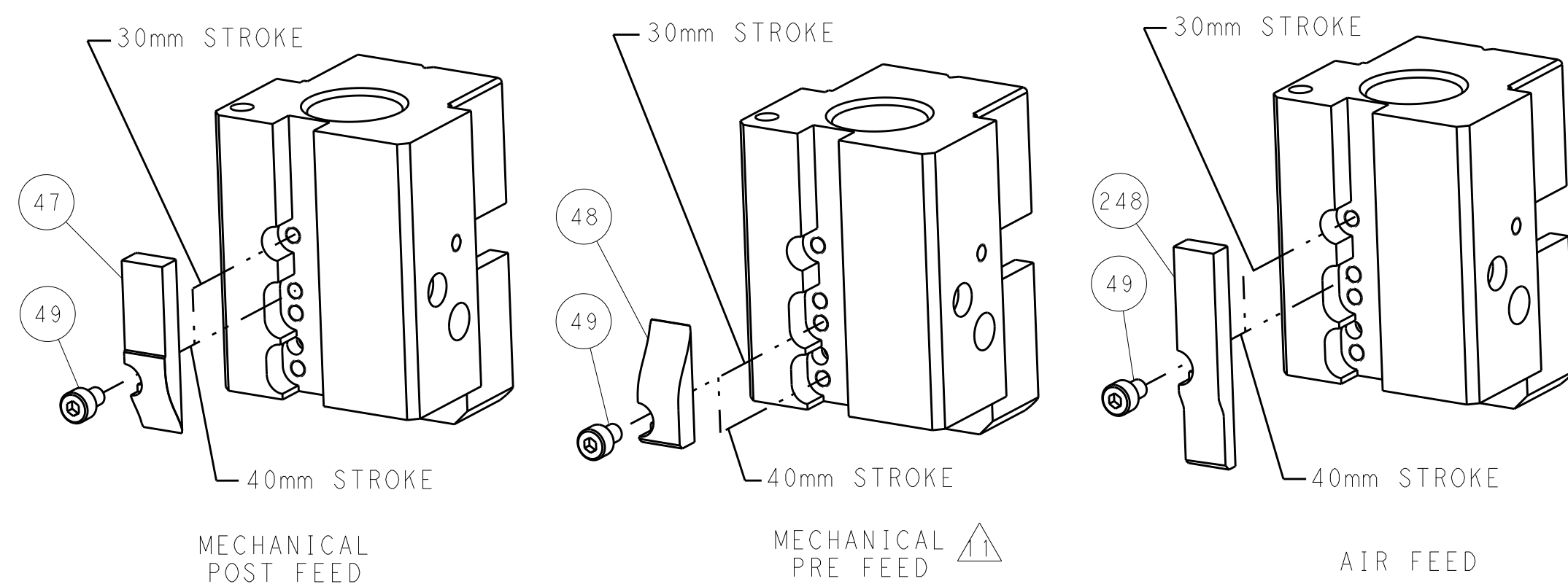
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



PNEUMATIC

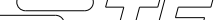
SERVO
LATCH PLATE

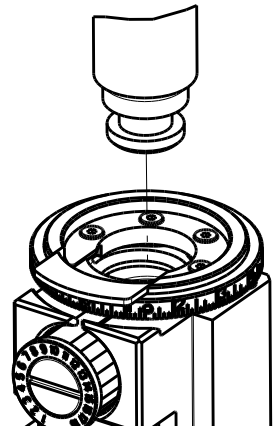
CAM POSITIONS



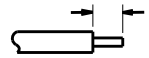
ATLANTIC VERSION

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR ISO 9001 CERTIFICATION APPLICATION IT IS SUBJECT TO THE TERMS AND CONDITIONS OF THE CERTIFICATION APPLICATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN C. MOYER 15NOV2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		NAME Ocean End Feed Applicator	
		CWN G. BAILEY 15NOV2011		SIZE A	
MATERIAL -		APVO G. BAILEY 15NOV2011		CADL CODE 00779	
FINISH -		PRODUCT SPEC -		DRAWING NO C-2150236	
WEIGHT -		APPLICATION SPEC -		RESTRICTED TO -	
CUSTOMER ACCESSIBLE PORTION DRAWING					
SCALE 1:1		SHEET 2 OF 4		REV B	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150236-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150236-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150236-4	-	-	-
	2-2150236-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150236-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150236-4	-	-	-
	2-2150236-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					-	-	-	-	-	-	-
	2-2150236-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2150236-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION
TERMINAL NAME: RING				
WIRE STRIP LENGTH 2.92-3.68 mm [.115-.145 IN]		 INSULATION DIAMETER RANGE Ø1.02-1.52 mm [.040-.060 IN]		
TERMINAL APPLICATION SPECIFICATION	 114-2084	-	-	-
TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	
42547-1	42547-2	60007-2		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
22 AWG			1.04+/-0.05 [.041+/- .002]		7.3
24 AWG			0.97+/-0.05 [.038+/- .002]		8.1
26 AWG			0.91+/-0.05 [.036+/- .002]		8.7



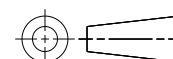
- ¹ RECOMMENDED SPARE PARTS
- ² GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- ⁴ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150236-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150236-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150236-5
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.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- 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.

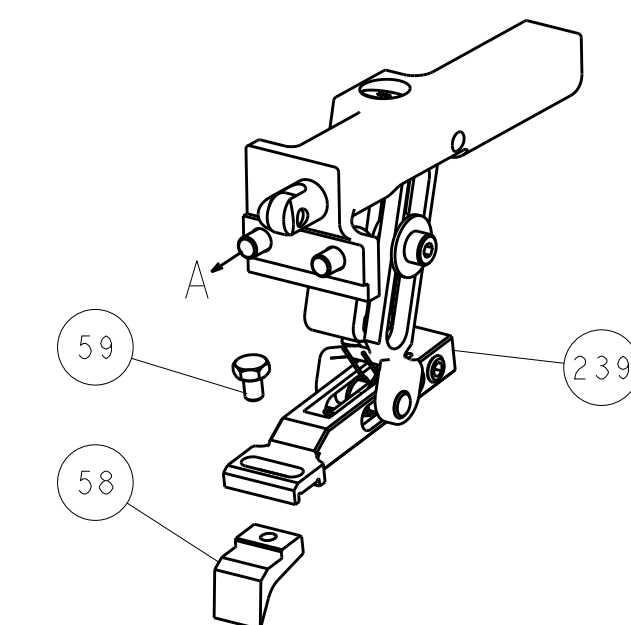
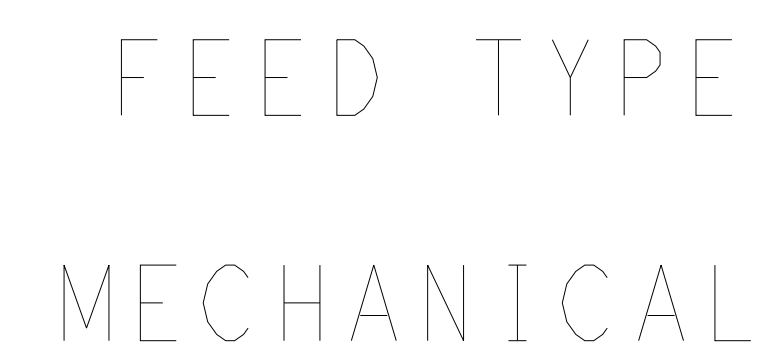
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

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

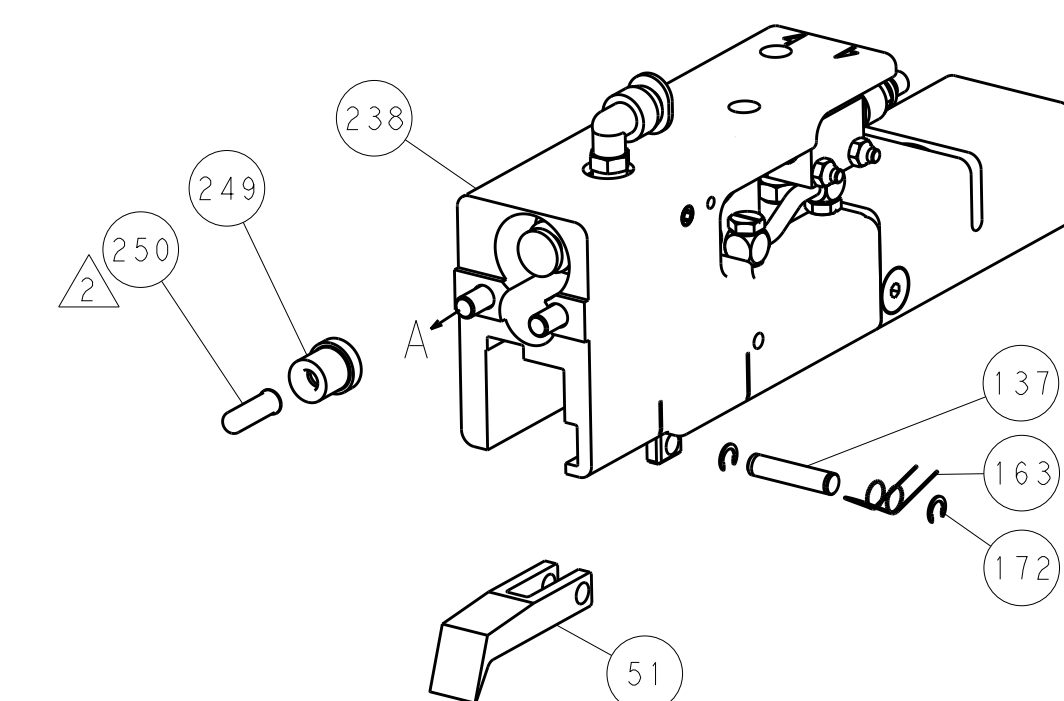
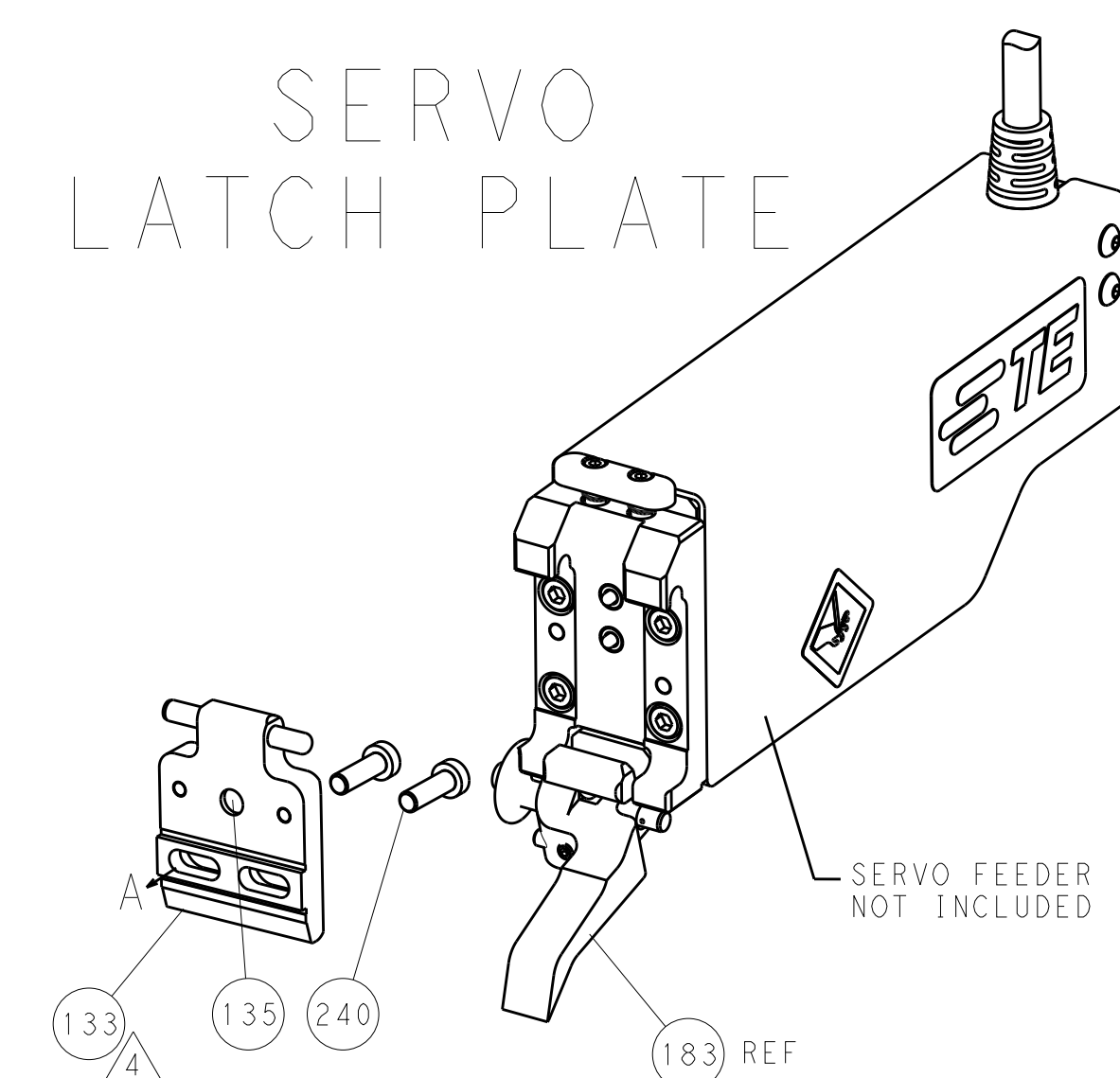
SET UP GAUGE 2119599-2	LOC A	DIS 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-6	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	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
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-	77-27-25-22-21	PART NO			DESCRIPTION		ITEM NO

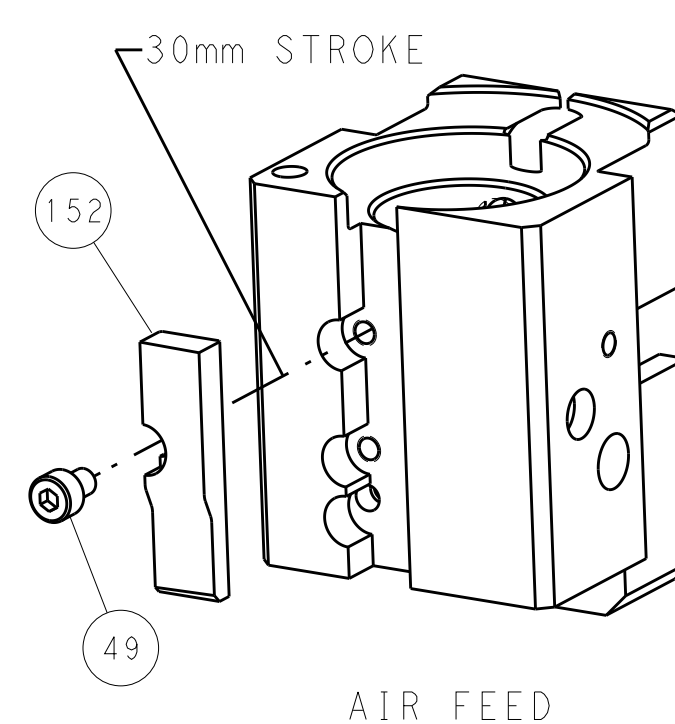
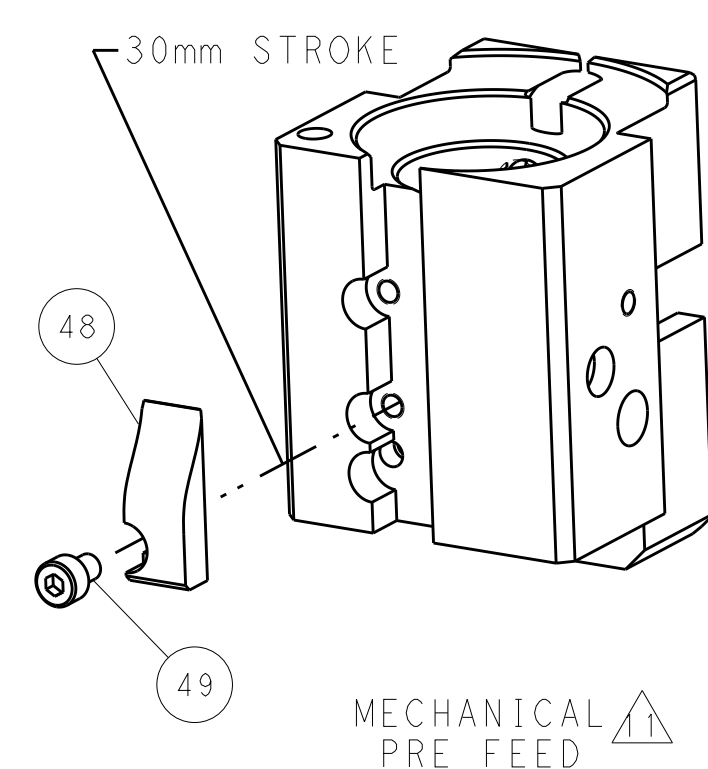
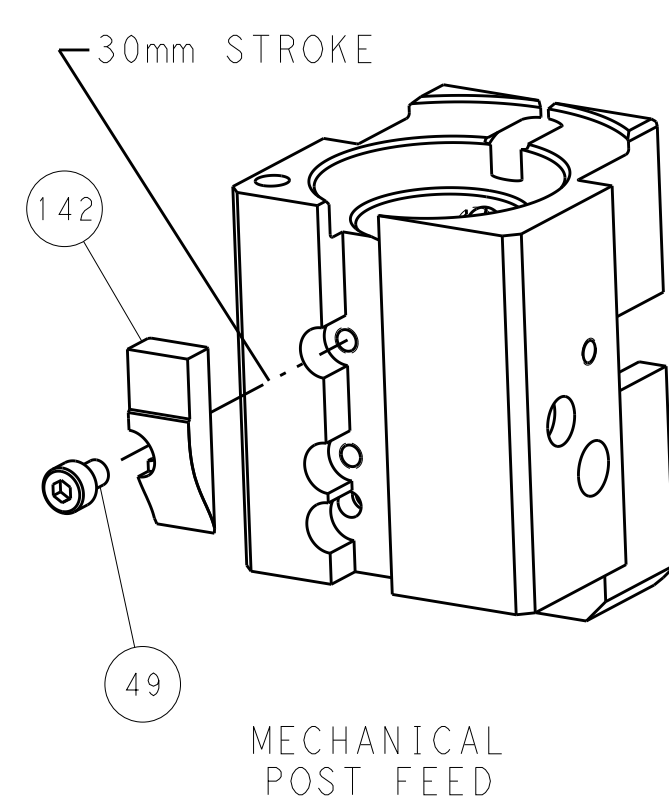
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DIMENSIONS: mm				CHK G. BAILEY 15NOV2011	NAME Ocean End Feed Applicator	SIZE A1 CAGE CODE 00779 DRAWING NO ©=2150236			RESTRICTED TO -			
				APVD G. BAILEY 15NOV2011								
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1												
MATERIAL -				FINISH -	PRODUCT SPEC -	APPLICATION SPEC -			WEIGHT -			
					CUSTOMER ACCESSIBLE PRODUCTION DRAWING							
					SCALE 1:1		SHEET 3		OF 4		REV B	



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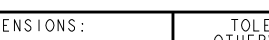
SERVO
LATCH PLATE

CAM POSITIONS



PACIFIC VERSION

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

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		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CASE CODE 00779	
WEIGHT -		DRAWING NO C-2150236		RESTRICTED TO -	
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