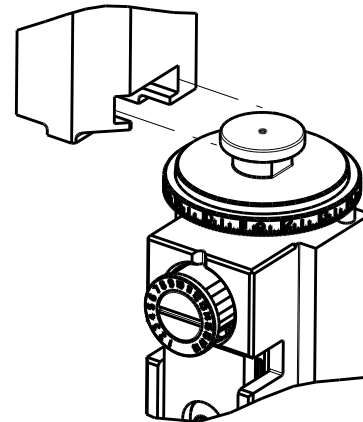


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2011

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150349-1	A	FINE CRIMP HEIGHT ADJUST
	2150349-2	A	FINE CRIMP HEIGHT ADJUST
	2150349-5	A	FINE CRIMP HEIGHT ADJUST
	2150349-6	A	NON-CRIMP HEIGHT ADJUST
	2150349-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150349-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.30 mm [.091]	F
INSUL	3.30 mm [.130]	OV
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 5.21-5.97 mm [.205-.235 IN]		INSULATION DIAMETER RANGE Ø2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		-	
114-2036		-	
TERMINALS APPLIED		-	
TE TERMINAL		TE TERMINAL	
63609-1		63609-2	
TE TERMINAL		TE TERMINAL	
63609-3		63609-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
18 AWG or 0.80mm ²	1.42+/-0.05 [.056+/- .002]	6.6
20 AWG or 0.50mm ²	1.30+/-0.05 [.051+/- .002]	8.0
22 AWG or 0.30mm ²	1.24+/-0.05 [.049+/- .002]	8.5



- 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: 8-2150349-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150349-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150349-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150349-6
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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREAODS 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 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

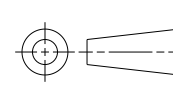
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	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

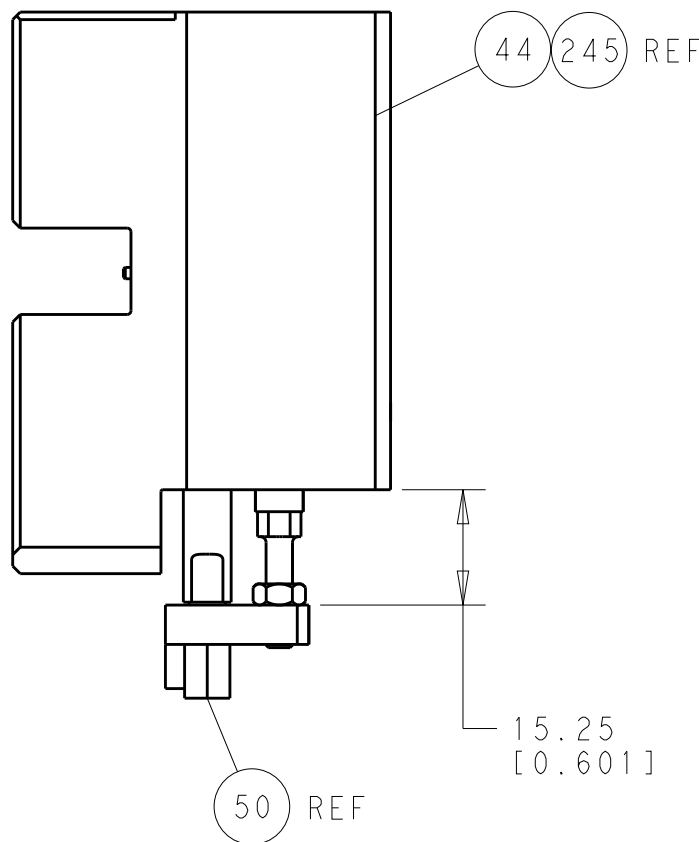
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIS 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	DWN	APVD
				A1	ECR-13-018515	26NOV2013	KH	TE

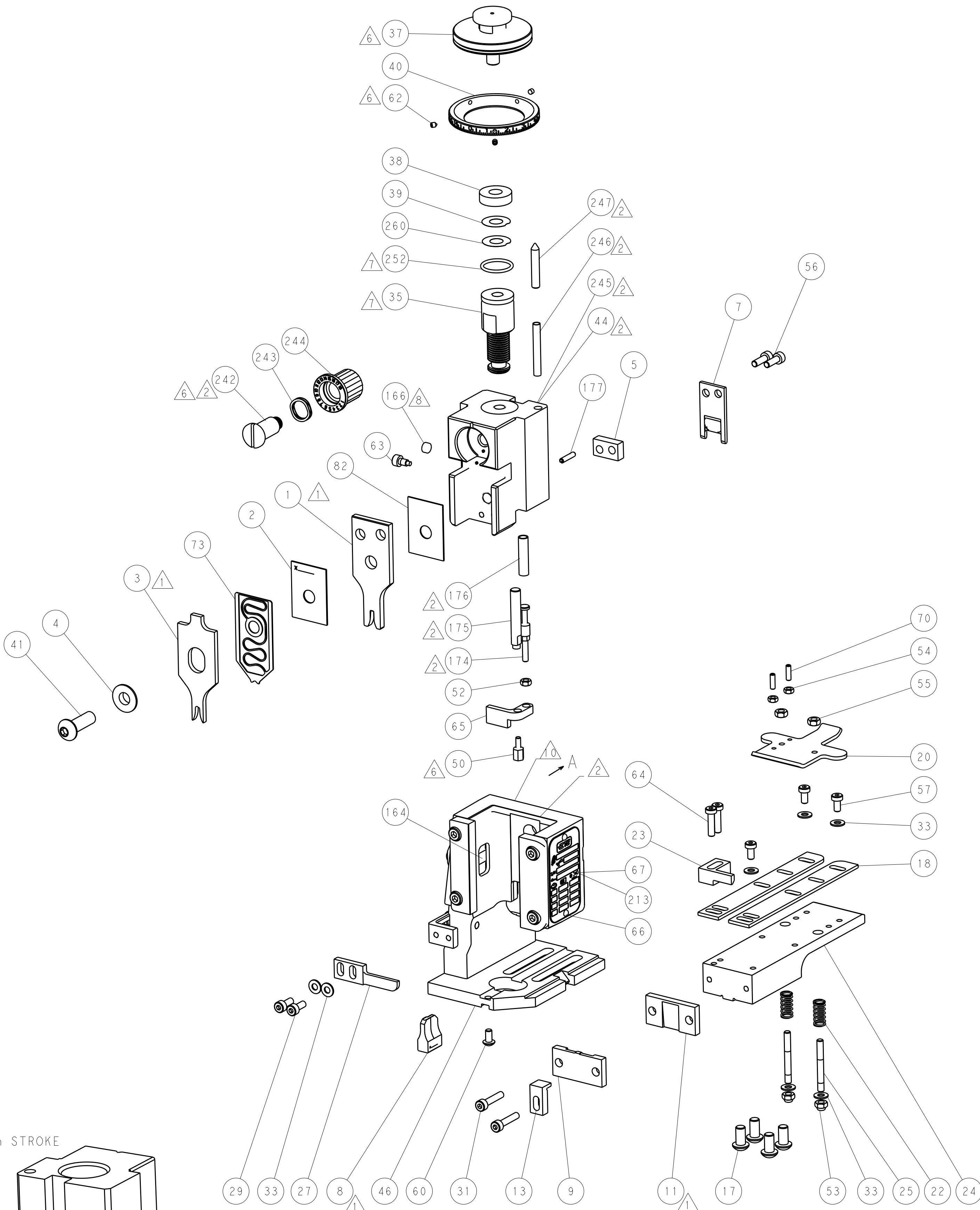
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119791-9	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	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	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	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
-	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	-	2119792-2	PAWL, EF, AIR	51
-	1	1	1	1	1	1-1752354-3	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
-	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
-	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	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	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	1752373-4	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	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	-	10
-	1	1	1	1	1	690495-4	PLATE, FRONT SHEAR	9
1	1	1	1	1	1	1338673-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	1	1	1	1	1	6-240641-5	SPACER	5
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	4-2119785-4	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1	1	1	1-456406-2	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER SHALL BE RESPONSIBLE FOR VERIFYING THE DIMENSIONS OF THE PARTS AND THE ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.				DWN C. CHEN	02JUL2013	 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				CHK U. GUO	02JUL2013				
mm				APVD J. CRUZ	02JUL2013	NAME		Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE A1			
				APPLICATION SPEC					
MATERIAL -				FINISH -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 1 of 4		REV A	
				DRAWING NO 00779		C=2150349			

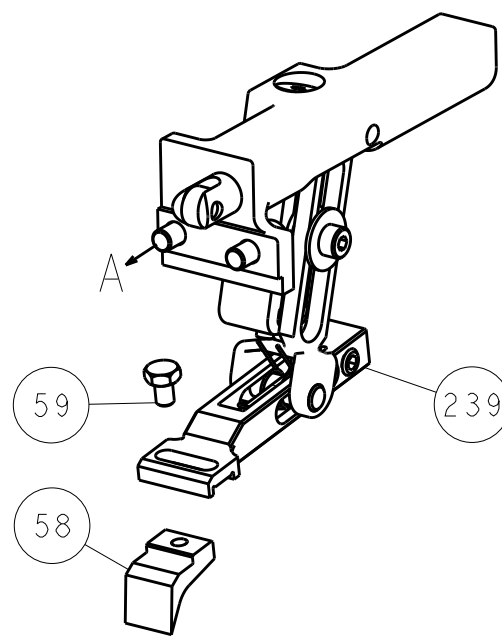
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



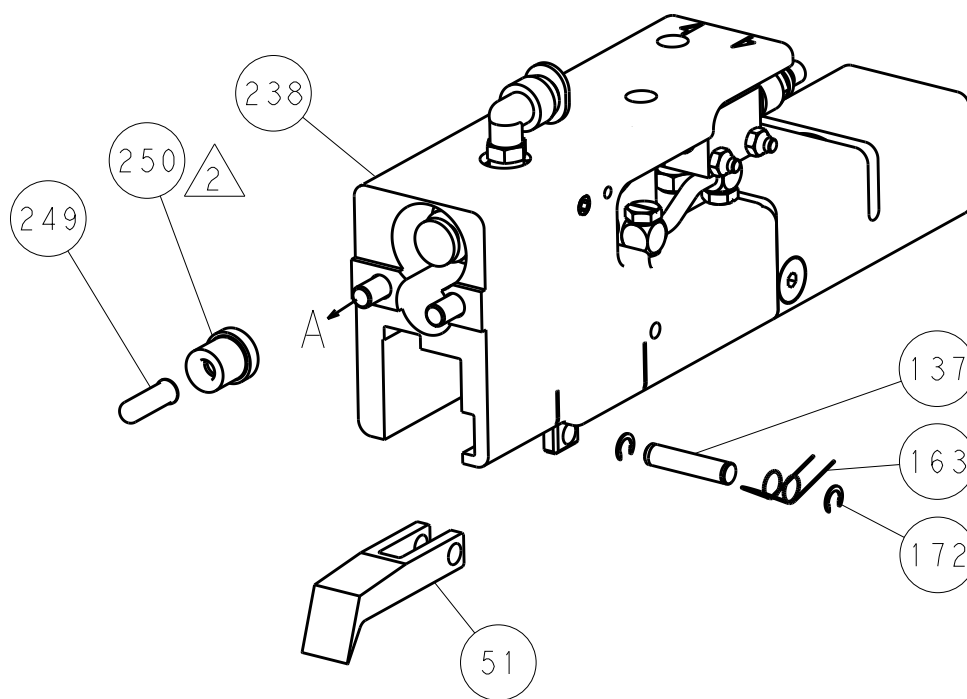
HOLDDOWN SET-UP



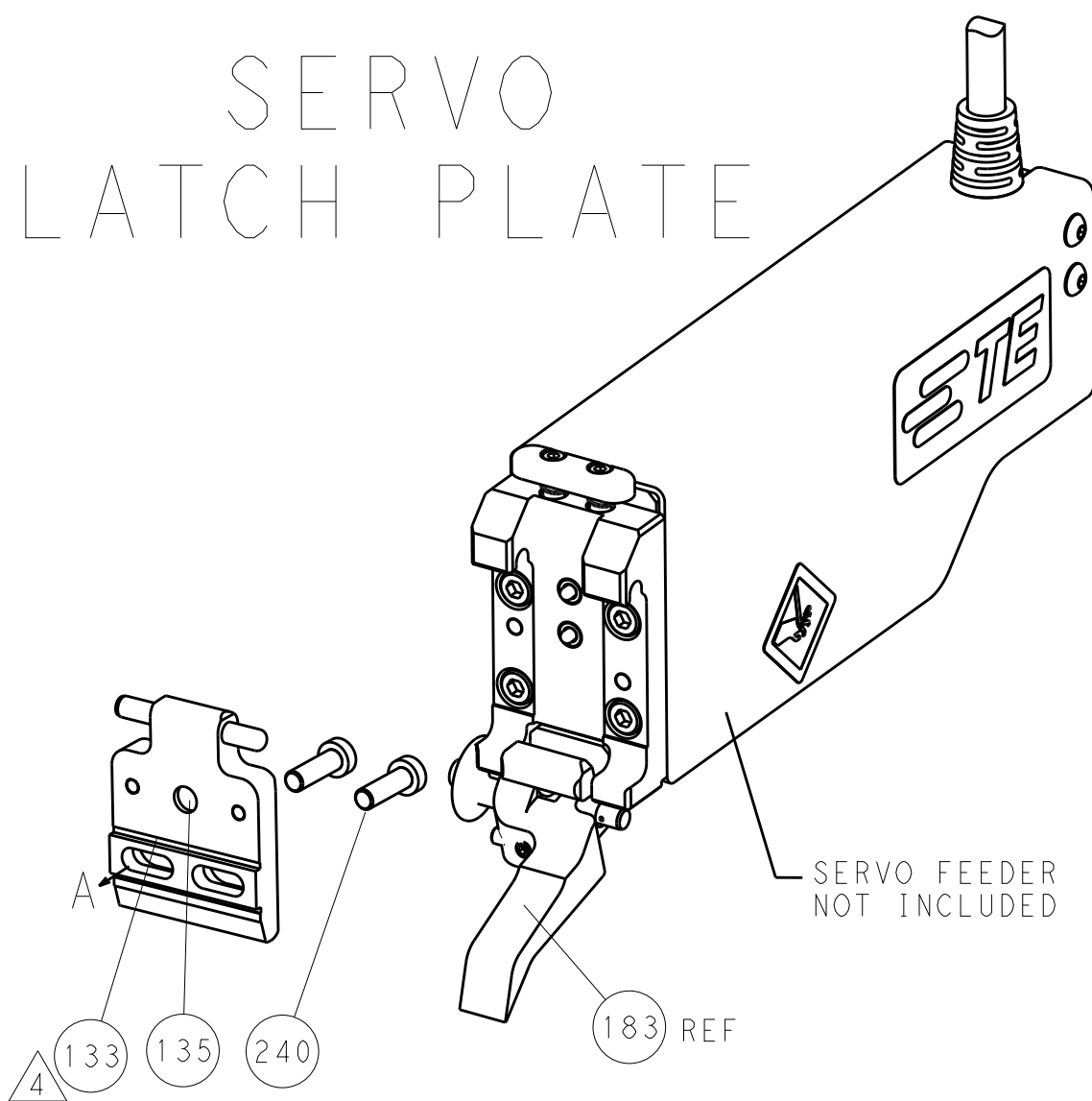
FEED TYPE
MECHANICAL



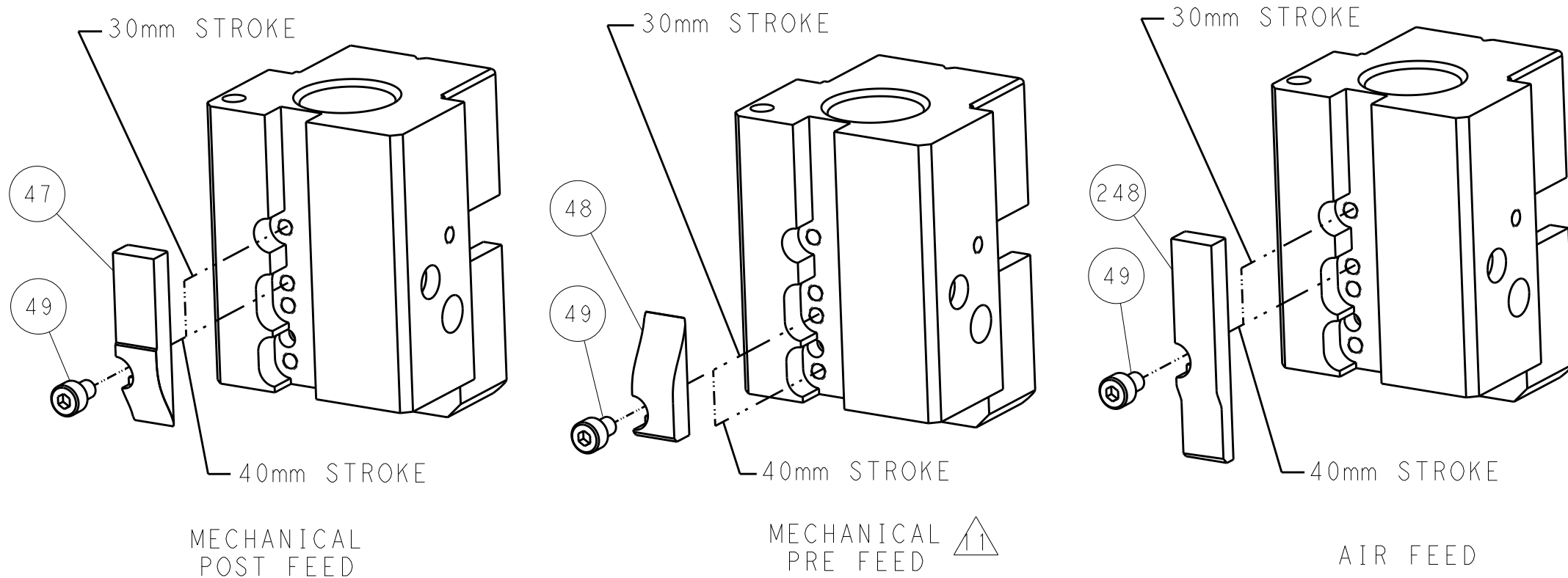
PNEUMATIC



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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.				OWN: C. CHEN 02JUL2013 CHK: U. GUO 02JUL2013 APVD: J. CRUZ 02JUL2013				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±0.0001				NAME: Ocean End Feed Applicator			
MATERIAL: -				FINISH: -				SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150349			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET 2 OF 4 REV A1			

8

7

6

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3

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1

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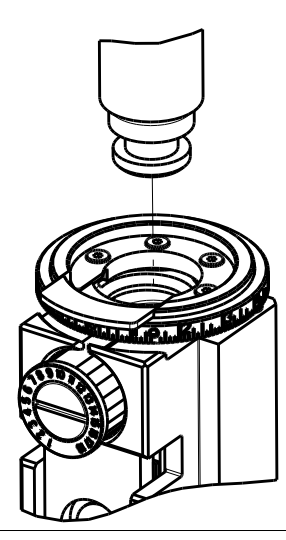
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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2150349-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119792-2

-

2119641-2

-

2063440-1

SERVO LATCH PLATE

2119951-1

SMART APPLICATOR

2161326-1

-

8-2150349-5

-

2168400-7 (QUANTITY 2)

MECHANICAL FEED

2119949-1

SERVO LATCH PLATE

2119951-1

SMART APPLICATOR

2161326-1

-

8-2150349-5

-

2168400-7 (QUANTITY 2)

MECHANICAL FEED

2119949-1

PNEUMATIC FEED

2119950-1

-

2119792-2

-

2119641-2

-

2063440-1

2-2150349-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2-2150349-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2-2150349-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2150349-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.30 mm [.091]

F

INSUL

3.30 mm [.130]

OV

APPLICATOR INSTRUCTIONS

408-10390



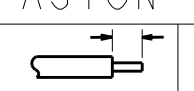
TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .250 FASTON RECEPTACLE

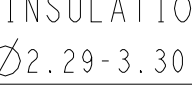
WIRE STRIP LENGTH

5.21-5.97 mm [1.205-.235 IN]



INSULATION DIAMETER RANGE

Ø2.29-3.30 mm [.090-.130 IN]



TERMINAL APPLICATION SPECIFICATION

114-2036

-

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

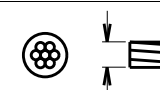
63609-1

63609-2

63609-3

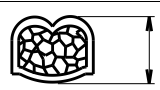
63609-4

WIRE SIZE



CRIMP HEIGHT

mm [INCH]



CRIMP HEIGHT

REFERENCE SETTING



18 AWG or 0.80mm²

1.42+/-0.05 [1.056+/-0.002]

6.0

20 AWG or 0.50mm²

1.30+/-0.05 [1.051+/-0.002]

8.0

22 AWG or 0.30mm²

1.24+/-0.05 [1.049+/-0.002]

8.5



RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150349-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150349-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150349-5

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50, 62 & 242.

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.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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.

-

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

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

-77-27-25-22-21

PART NO

DESCRIPTION

ITEM NO

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

DIST

66

REVISIONS

P

LTR

DESCRIPTION

DATE

OWN

APVD

-

-

SEE SHEET 1

-

-

-

6

-

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

-

-

-

1

-

2063440-1

AIR FEED MODULE

238

-

-

1

-

-

2119740-2

TAG, IDENTIFICATION

213

-

4

4

4

4

2079383-9

SCR, BHSC, RoHS (M6 X 20)

186

-

-

REF

-

-

1901697-1

FEED FINGER ASSEMBLY, EF

183

-

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

-

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

-

-

-

1

-

240638-1

SPRING, FEED FINGER

163

-

1

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

1

2119798-2

DETENT PIN

145

-

1

1

1

1

2079383-8

SCR, BHSC, RoHS (M4 X 16)

144

-

-

-

-

1

2119653-2

FEED CAM, POST FEED

142

-

1

1

1

1

2119655-6

APPLICATOR BASIC ASSEMBLY, EF

141

-

1

1

1

1

2119651-1

RAM, ASIAN STYLE, END FEED

140

-

1

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

4

-

-

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

2119740-1

TAG, IDENTIFICATION

67

-

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

-

1

1

1

1

1901681-1

HOLDDOWN, TERMINAL

65

-

2

2

2

2

2168400-8

SHCS, LOW HEAD, RoHS, M4 X 16

64

-

1

1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

6

-

3

3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

-

-

-

-

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

-

1

2063961-1

FEED FINGER

58

-

3

3

3

3

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

2

2

2

2168083-3

SCR, SKT HD CAP, RoHS, M4 X 12.0

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

6

-

-

-

1

-

2119792-2

PAWL, EF, AIR

51

-

1

1

1

1

1-1752354-3

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

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

2119644-1

RAM WASHER, PRECISION

38

-

7

7

7

7

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

1752371-5

PLATE, STRIP GUIDE

24

-

1

1

1

1

240825-2

PLATE, STRIP HOLD DOWN

23

-

2

2

2

2

2-22281-3

SPRING, COMPRESSION

22

-

1

1

1

1

1752373-4

DRAG

20

-

2

2

2

2

1901259-4

GUIDE, LOWER STRIP

18

-

1

1

1

1

1752360-1

SPACER, HOLD-DOWN

13

1

-

1

1

1

1

240644-1

PLATE, REAR SHEAR

11

-

-

-

-

-

-

-

-

10

1

-

1

1

1

1

690495-4

PLATE, FRONT SHEAR

9

1

1

1

1

1

1

1338673-1

ANVIL, COMBINATION

8

1

-

1

1

1

1

1-2217206-3

BLADE, SLUG

7

-

1

1

1

1

1

6-240641-5

SPACER

5

-

1

1

1

1

1

238009-1

BLOCK, FL CRIMPER SPACER

4

1

1

1

1

1

1

4-2119785-4

CRIMPER, INSULATION OVERLAP PREMIUM

3

-

1

1

1

1

1

455888-6

SPACER, CRIMPER

2

1

1

1

1

1

1

1-456406-2

CRIMPER, WIRE PREMIUM

1

-77-27-25-22-21

PART NO

DESCRIPTION

ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS.

OWN

02JUL2013

CHK

C. CHEN

02JUL2013

U. GUO

02JUL2013

APVD

J. CRUZ

02JUL2013

NAME

TE Connectivity

Harrisburg, PA 17105-3608

PRODUCT SPEC

-

APPLICATION SPEC

-

SIZE

A1

CAGE CODE

00779

DRAWING NO

©=2150349

RESTRICTED TO

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

3

OF

4

REV

A1

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

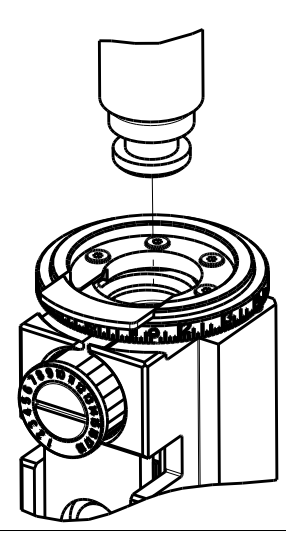
RELEASED FOR PUBLICATION

2011

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2150349-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119792-2

-

2119641-2

-

2063440-1

SERVO LATCH PLATE

2119951-1

SMART APPLICATOR

2161326-1

-

8-2150349-5

-

2168400-7 (QUANTITY 2)

MECHANICAL FEED

2119949-1

SERVO LATCH PLATE

2119951-1

SMART APPLICATOR

2161326-1

-

8-2150349-5

-

2168400-7 (QUANTITY 2)

MECHANICAL FEED

2119949-1

PNEUMATIC FEED

2119950-1

-

2119792-2

-

2119641-2

-

2063440-1

2-2150349-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2-2150349-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2-2150349-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2150349-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.30 mm [.091]

F

INSUL

3.30 mm [.130]

OV

APPLICATOR INSTRUCTIONS

408-10390



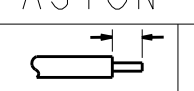
TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .250 FASTON RECEPTACLE

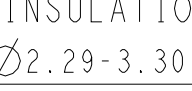
WIRE STRIP LENGTH

5.21-5.97 mm [1.205-.235 IN]



INSULATION DIAMETER RANGE

Ø2.29-3.30 mm [.090-.130 IN]



TERMINAL APPLICATION SPECIFICATION

114-2036

-

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-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

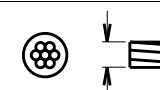
63609-1

63609-2

63609-3

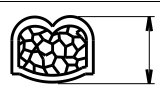
63609-4

WIRE SIZE



CRIMP HEIGHT

mm [INCH]



CRIMP HEIGHT

REFERENCE SETTING



18 AWG or 0.80mm²

1.42+/-0.05 [1.056+/-0.002]

6.0

20 AWG or 0.50mm²

1.30+/-0.05 [1.051+/-0.002]

8.0

22 AWG or 0.30mm²

1.24+/-0.05 [1.049+/-0.002]

8.5



RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150349-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150349-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150349-5

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50, 62 & 242.

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.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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.

-

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

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

-77-27-25-22-21

PART NO

DESCRIPTION

ITEM NO

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

DIST

66

REVISIONS

P

LTR

DESCRIPTION

DATE

OWN

APVD

-

-

SEE SHEET 1

-

-

-

6

-

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

-

-

-

1

-

2063440-1

AIR FEED MODULE

238

-

-

1

-

-

2119740-2

TAG, IDENTIFICATION

213

-

4

4

4

4

2079383-9

SCR, BHSC, RoHS (M6 X 20)

186

-

-

REF

-

-

1901697-1

FEED FINGER ASSEMBLY, EF

183

-

1

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6-993111-6

PIN, SLOTTED SPRING 3.0 X 14.0

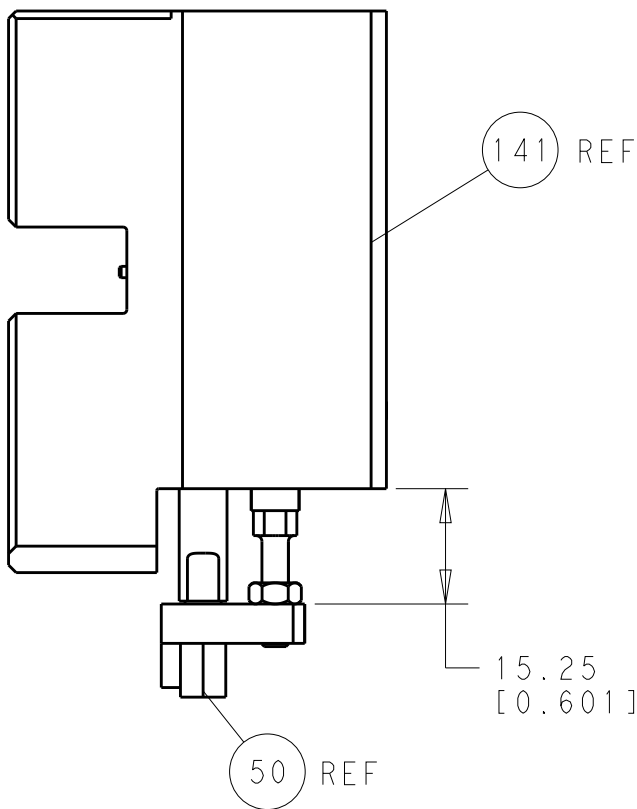
177

-

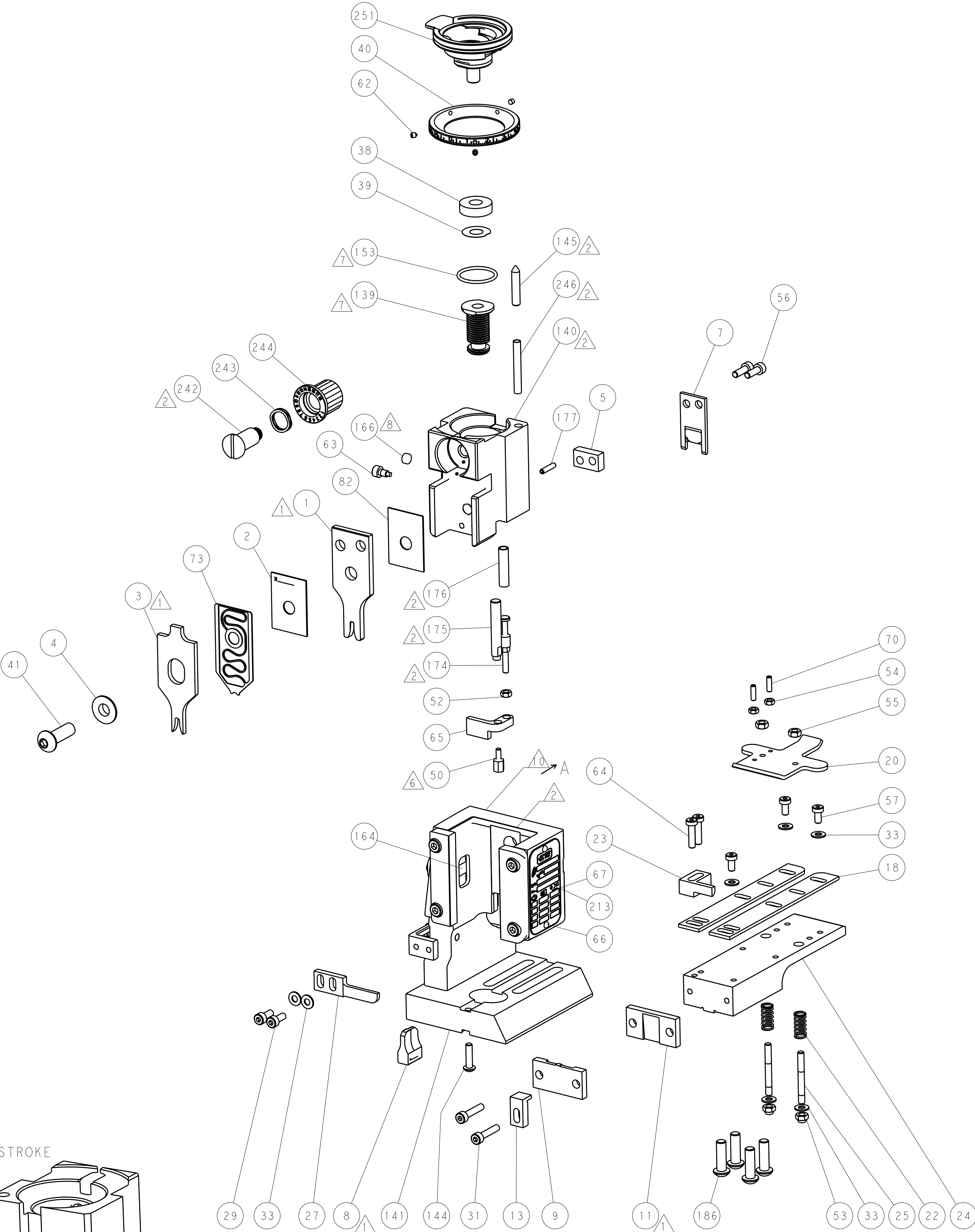
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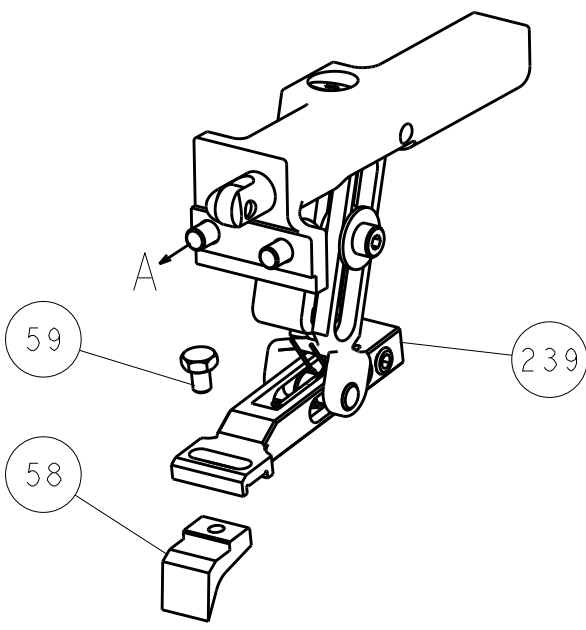
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



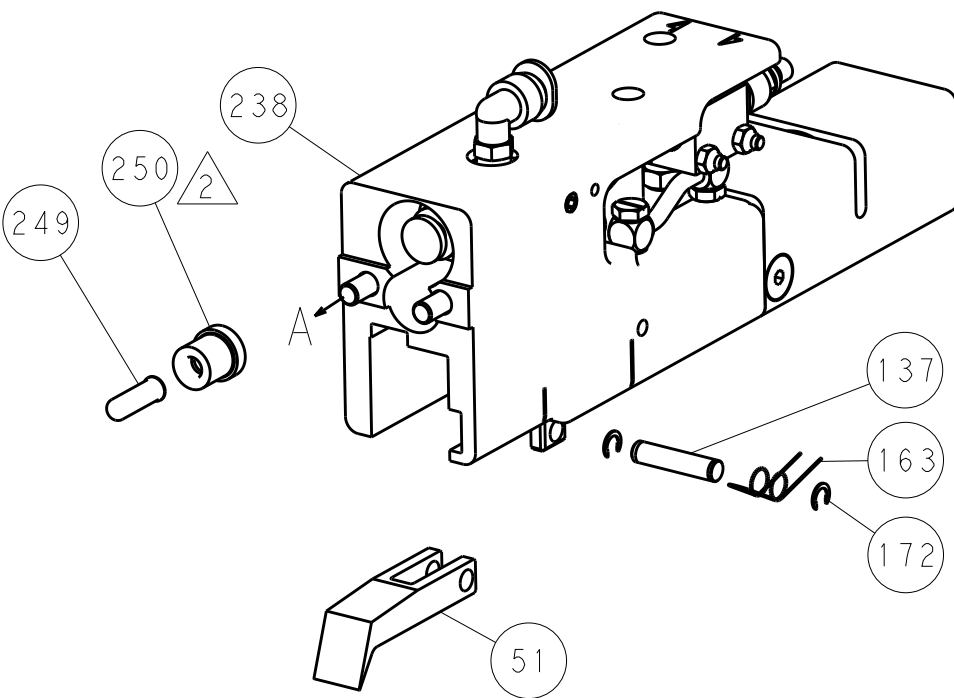
HOLDDOWN SET-UP



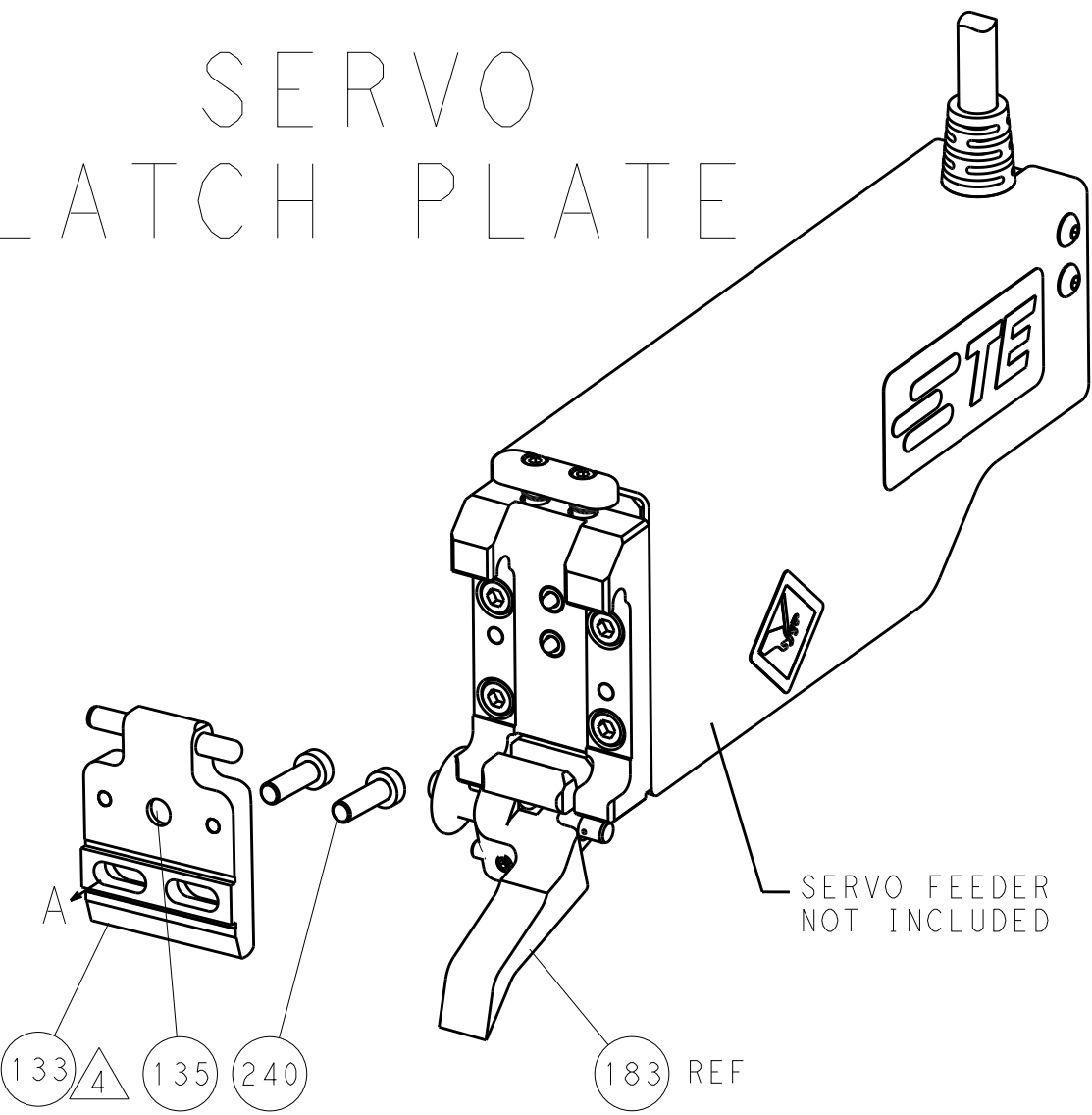
FEED TYPE
MECHANICAL



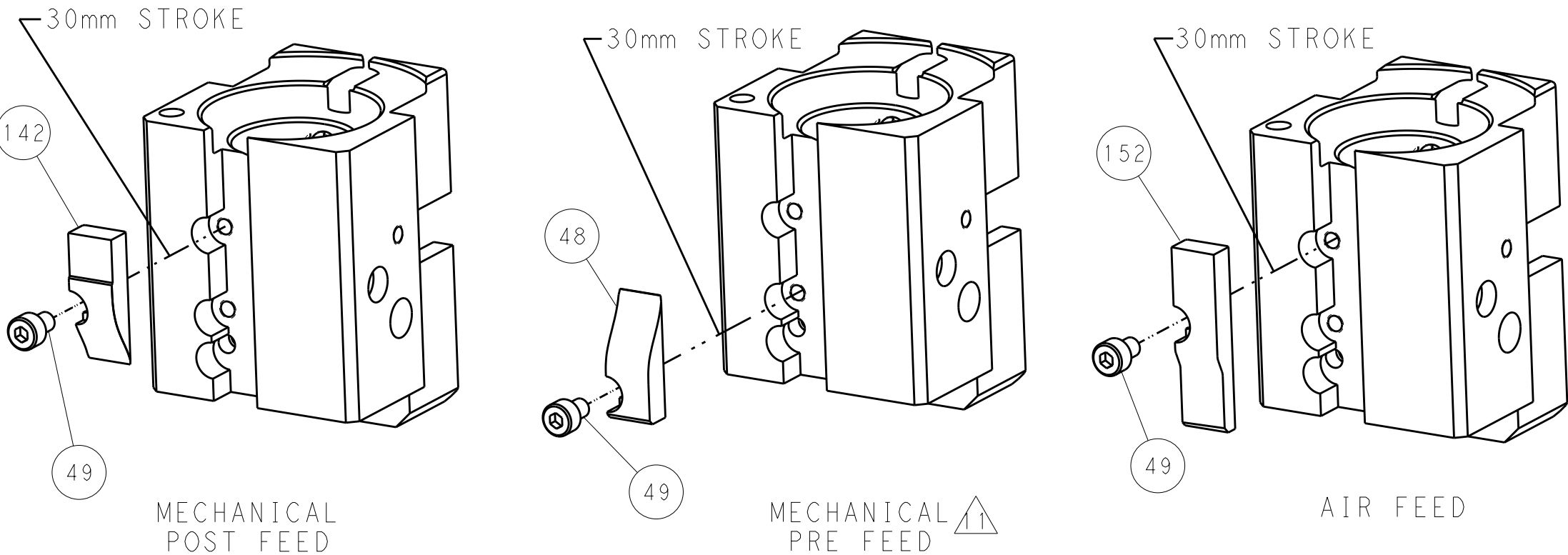
PNEUMATIC



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)

1. THE PROPERTY OF TYCO ELECTRONICS CORPORATION IS RESERVED. ANY REPRODUCTION OR TRANSMISSION OF THIS DRAWING WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION IS PROHIBITED.				DWN: C. CHEN 02JUL2013 CHK: U. GUO 02JUL2013 APVD: J. CRUZ 02JUL2013				STE TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±0.0001				NAME: Ocean End Feed Applicator			
MATERIAL: -				FINISH: -				SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150349			
				WEIGHT: -				Customer Accessible Production Drawing			
				SCALE: 1:1				SHEET 4 OF 4 REV A1			