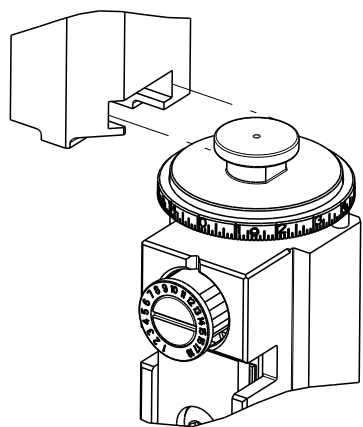
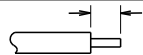


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
© COPYRIGHT 20		20	
BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION
		2151370-1	C
		2151370-2	C
		2151370-5	C
		2151370-6	C
		2151370-7	C
		7-2151370-7	A
		DESCRIPTION	
		FINE CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		NON-CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		CRIMP TOOLING KIT	
APPLICATOR DATA			
CRIMP	SIZE	TYPE	
WIRE	.130 [3.30 mm]	F	
INSUL	.180 [4.57 mm]	F	
APPLICATOR INSTRUCTIONS 408-10390			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH .172-.210 IN {4.37-5.33 mm}		 INSULATION DIAMETER RANGE $\varnothing$ 100-.140 IN {2.54-3.56 mm}	
TERMINAL APPLICATION SPECIFICATION	 114-2084 -	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40660	40724-3	40725-5	160701-2
40661	40725	42007	160211-1
40661-1	40725-1	63872-1	160211-2
40723	40725-2	63872-2	160337-2
40724	40725-3	160701-1	160699-1
42569-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
14 AWG		2.59+/-0.05 [.102+/- .002]		4.4
16 AWG		2.39+/-0.05 [.094+/- .002]		6.6
1.00mm2		2.31+/-0.05 [.091+/- .002]		7.6
20 AWG(1) + 22 AWG(1)		2.29+/-0.05 [.090+/- .002]		7.5
18 AWG		2.26+/-0.05 [.089+/- .002]		8.1



- 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: 8-2151370-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151370-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151370-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151370-6
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.
 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
- 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

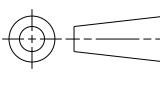
6		5		4		3	
FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
	CONVERT TO	PART NUMBERS REQUIRED					
MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
	SERVO LATCH PLATE	2119951-1	1901697-1	8-2151370-5	-	-	2168400-7 (QUANTITY 2)
	SMART APPLICATOR	2161326-1	-	8-2151370-4	-	-	-
PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
	SERVO LATCH PLATE	2119951-1	1901697-1	8-2151370-5	-	-	2168400-7 (QUANTITY 2)
	SMART APPLICATOR	2161326-1	-	8-2151370-4	-	-	-
SERVO LATCH PLATE 	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
SERVO LATCH PLATE 	-	-	-	-	-	-	-
	-	-	-	-	-	-	-
NONE	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-

13. TERMINAL LUBRICANT 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.

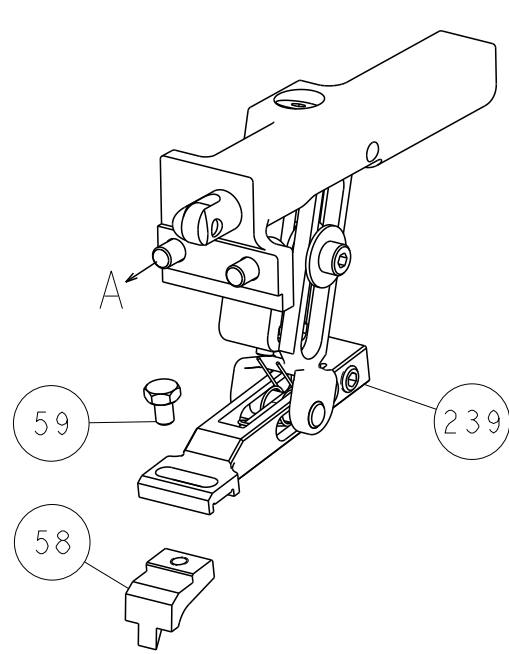
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2										LOC A	DIST 66	REVISIONS				
											P	LTR	DESCRIPTION	DATE	DWN	APVD
												B	ECR-13-012871	14AUG2013	CC	TE
												B1	ECR-13-016505	24OCT2013	KH	TE
												B2	ECR-16-014255	08OCT2016	JH	JDG
												C	ECR-17-000493	12JAN2017	TB	GB
7	-	1	-	1	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252						
	-	-	-	-	1	-		2119640-1	PUSH ROD, AIR FEED	250						
	-	-	-	-	1	-		1803259-1	BUSHING, FLANGED	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		2119082-9	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	REF	-	-		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	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						
13	-	-	REFREF	REF	-	-		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		2119791-9	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		2119793-1	LIMITER, ADJUSTMENT BOLT	63						
6	-	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		2168083-3	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	-		2119792-2	PAWL, EF, AIR	51						
6	-	-	-	-	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		2119644-2	RAM WASHER, PRECISION	38						
	-	1	1	1	1	1		2119085-1	FA HEAD, ATLANTIC STYLE	37						
7	-	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		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		1752371-1	PLATE, STRIP GUIDE	24						
	-	2	2	2	2	2		2-22281-3	SPRING, COMPRESSION	22						
	-	1	1	1	1	1		1752373-1	DRAG	20						
	-	1	1	1	1	1		1-1901696-9	STRIP GUIDE, REAR	19						
1	-	1	1	1	1	1		1-1901695-9	STRIP GUIDE, FRONT	18						
	-	4	4	4	4	4		1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17						
	-	1	1	1	1	1		3-240641-6	SPACER	16						
	-	1	1	1	1	1		240644-1	PLATE, REAR SHEAR	11						
	-	-	-	-	-	-		-	-	10						
	-	1	1	1	1	1		690482-4	PLATE, FRONT SHEAR	9						
	1	1	1	1	1	1		1333221-9	ANVIL, EF .130	8						
	1	1	1	1	1	1		1-690474-7	BLADE, SLUG	7						
	-	1	1	1	1	1		240641-3	SPACER	5						
	-	1	1	1	1	1		238009-1	BLOCK, FL CRIMPER SPACER	4						
1	1	1	1	1	1	1		2119582-3	CRIMPER, INSULATION F PREMIUM	3						
	-	1	1	1	1	1		455888-3	SPACER, CRIMPER	2						
	1	1	1	1	1	1		456410-3	CRIMPER, WIRE PREMIUM	1						
	-77-7	-6	-5	-2	-1			PART NO	DESCRIPTION	ITEM NO						

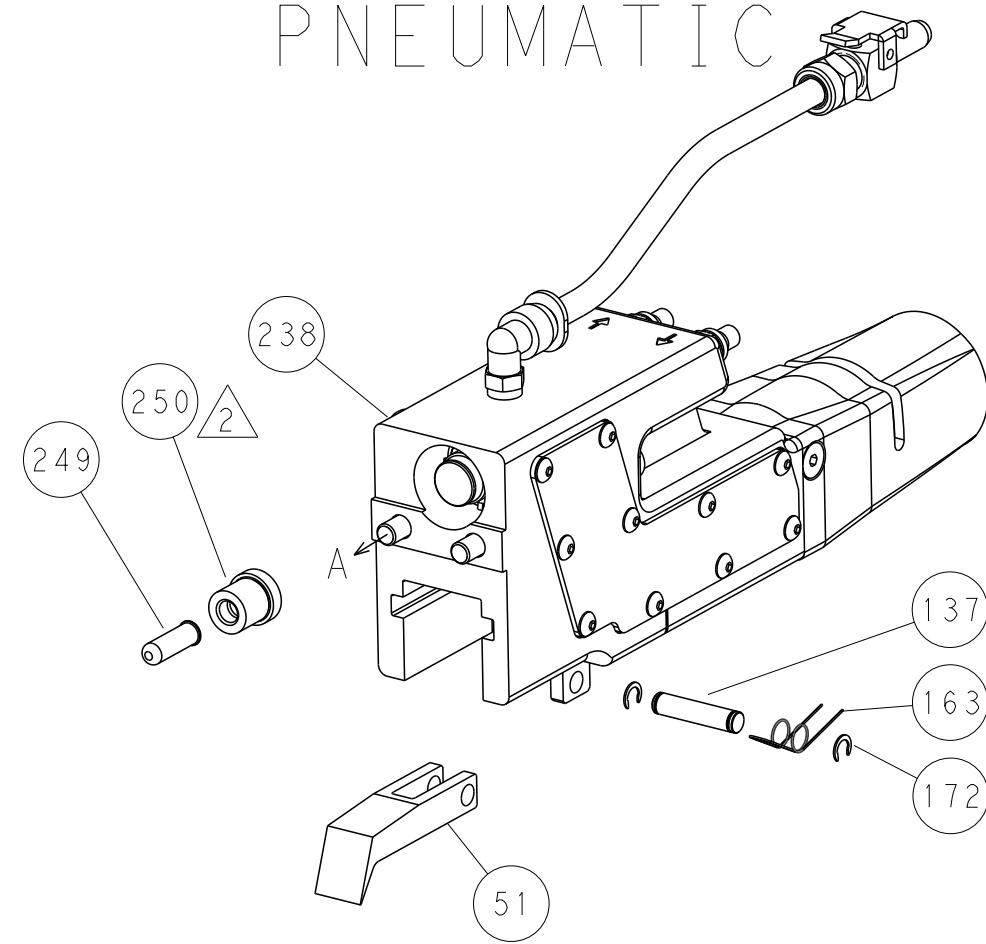
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC ORGANIZATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN L.ZHANG 09DEC2011	 TE Connectivity Harrisburg, PA 17105-3608	NAME OCEAN END FEED APPLICATOR		SIZE A	CAGE CODE 00779	DRAWING NO C-2151370	RESTRICTED TO
DIMENSIONS: mm		CHK L.ZHANG 09DEC2011		PRODUCT SPEC					
		APPLICATION SPEC							
MATERIAL -		WEIGHT -							
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES *		FINISH -							

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

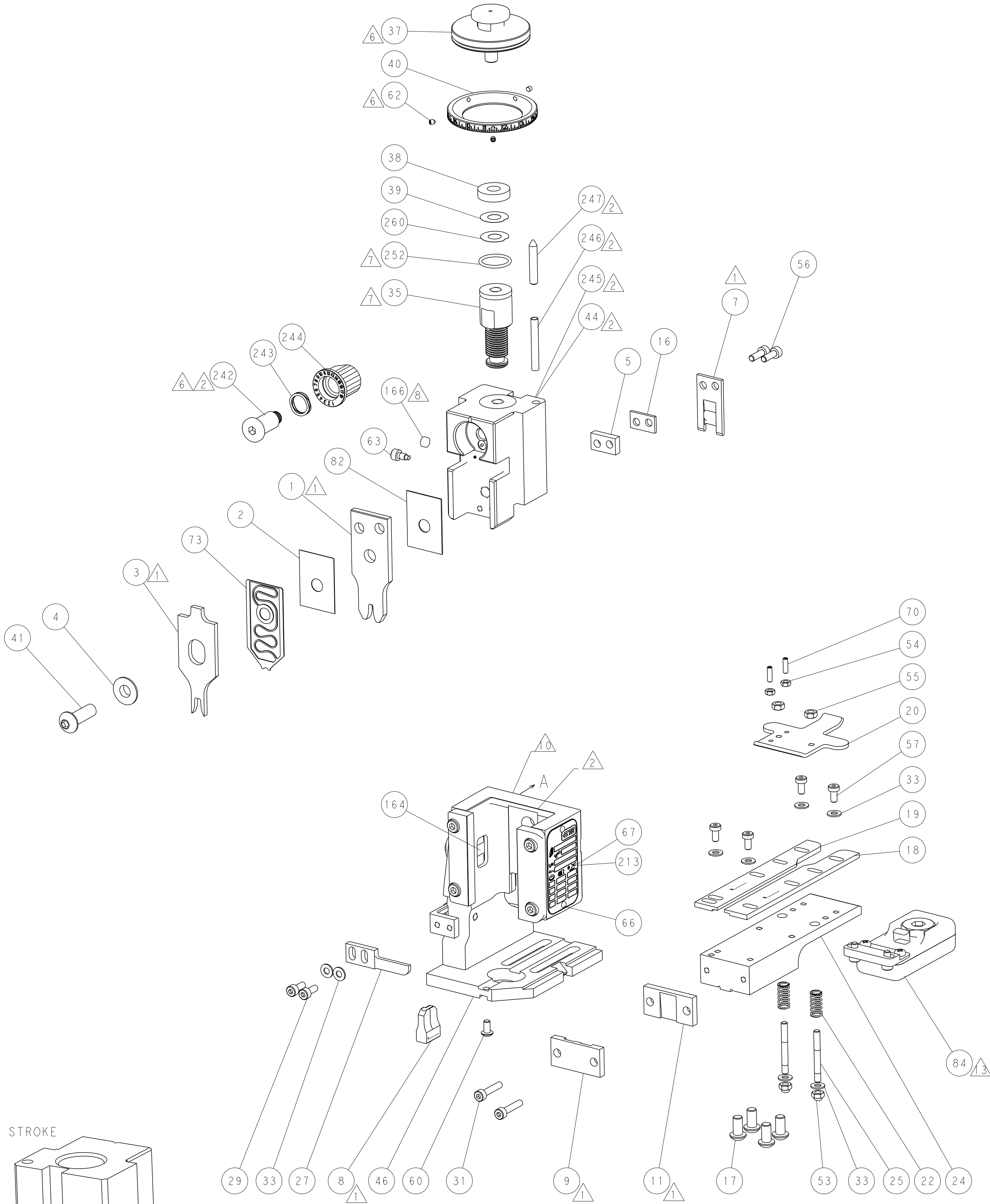
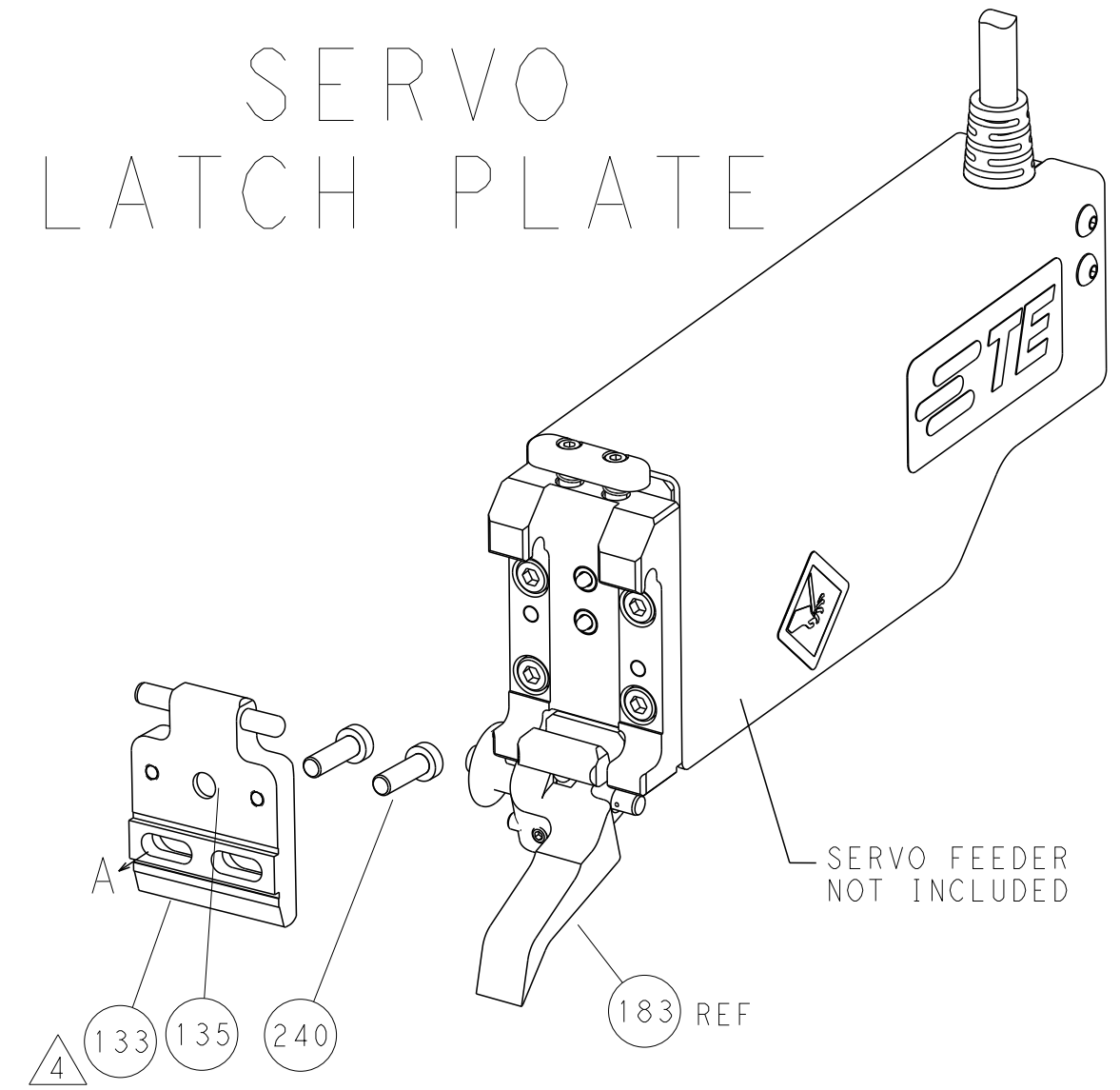
FEED TYPE
MECHANICAL



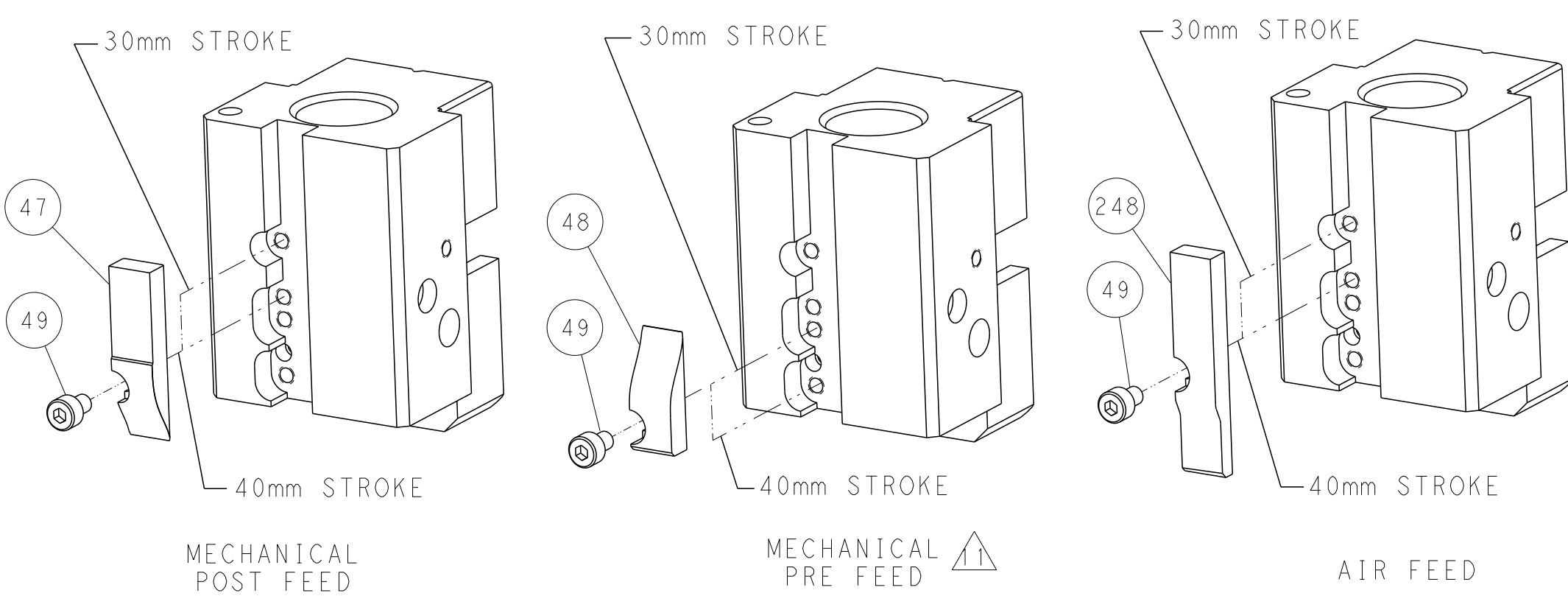
PNEUMATIC



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. IT IS THE RESPONSIBILITY OF THE USER TO CONTACT THE ORGANIZATION FOR THE LATEST REVISION.				DWN L. ZHANG 09DEC2011		TE Connectivity Harrisburg, PA 17105-3608	
CHK L. ZHANG 09DEC2011				NAME		OCEAN END FEED APPLICATOR	
S. XI 09DEC2011				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
APVD				APPLICATION SPEC		RESTRICTED TO	
MATERIAL				WEIGHT		REV	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 2 OF 4	



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

THIS DRAWING IS A CONTROLLED DOCUMENT AND ANY ELECTRICAL INFORMATION SHOULD BE CONTROLLED FOR THE LATEST VERSION.		DWN 01JUN2011 CHG 01JUN2011 APP 01JUN2011 S.XI		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	