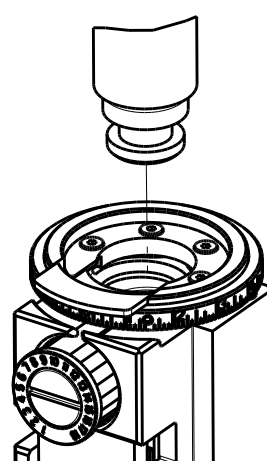
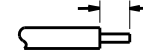


8		7		6		5		4		3	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		28							
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.									
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150315-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150315-5	-	-	2168400-7 (QUANTITY 2)
	2-2150315-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SMART APPLICATOR	2161326-1	-	8-2150315-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150315-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150315-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150315-4	-	-	-
	2-2150315-7	A	FINE CRIMP HEIGHT ADJUST	NONE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
7-2150315-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.01 mm [.158]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: G&H TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE 6, 3x0,8			
WIRE STRIP LENGTH 5.50-6.00 mm [.217-.236 IN]		INSULATION DIAMETER RANGE Ø2.20-3.00 mm [.087-.118 IN]	
			
TERMINAL APPLICATION SPECIFICATION		25985 Rev 2	
		-	
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572845-1	25914.201.011	1572845-7	25985.123.211
1572845-2	25914.201.004	1572845-8	25985.123.204
1572845-3	25914.123.211	1572845-9	25985.123.242
1572845-4	25914.123.204	1-1572845-0	25985.201.042
1572845-5	25985.201.011	1-1572845-1	25914.123.242
1572845-6	25985.201.004	1-1572845-2	25914.201.042

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
1.00+1.50		1.95+/-0.05 [0.77+/- .002]		6.4	
2.50		1.85+/-0.05 [0.73+/- .002]		7.8	
2X1.00		1.80+/-0.05 [0.71+/- .002]		8.3	
0.50+1.50		1.80+/-0.05 [0.71+/- .002]		8.3	
2.00		1.80+/-0.05 [0.71+/- .002]		8.3	
0.50+1.00		1.65+/-0.05 [0.65+/- .002]		9.8	
1.50		1.65+/-0.05 [0.65+/- .002]		9.8	

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: 8-2150315-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150315-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150315-5
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 ITEM 50 & 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

TERMINAL DATA: G&H TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE 6,3x0,8			
WIRE STRIP LENGTH 5.50-6.00 mm [.217-.236 IN]		INSULATION DIAMETER RANGE Ø2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION 		NONE	
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572845-1	25914.201.011	1572845-7	25985.123.211
1572845-2	25914.201.004	1572845-8	25985.123.204
1572845-3	25914.123.211	1572845-9	25985.123.242
1572845-4	25914.123.204	1-1572845-0	25985.201.042
1572845-5	25985.201.011	1-1572845-1	25914.123.242
1572845-6	25985.201.004	1-1572845-2	25914.201.042

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2X16			1.90 +/- 0.05 [.075 +/- .002]		6.8
1-14			1.75 +/- 0.05 [.069 +/- .002]		8.7
2X18			1.75 +/- 0.05 [.069 +/- .002]		8.7
1-16			1.55 +/- 0.05 [.061 +/- .002]		10.6
1-18			1.48 +/- 0.05 [.058 +/- .002]		11.2

*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.

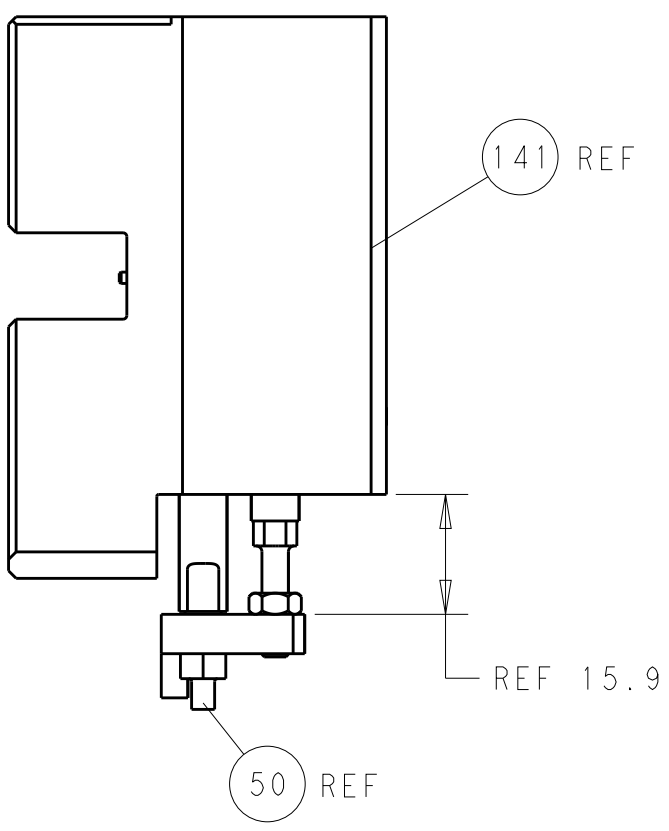
-	-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1	1-22279-3	SPRING, COMPRESSON	246
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
- 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)

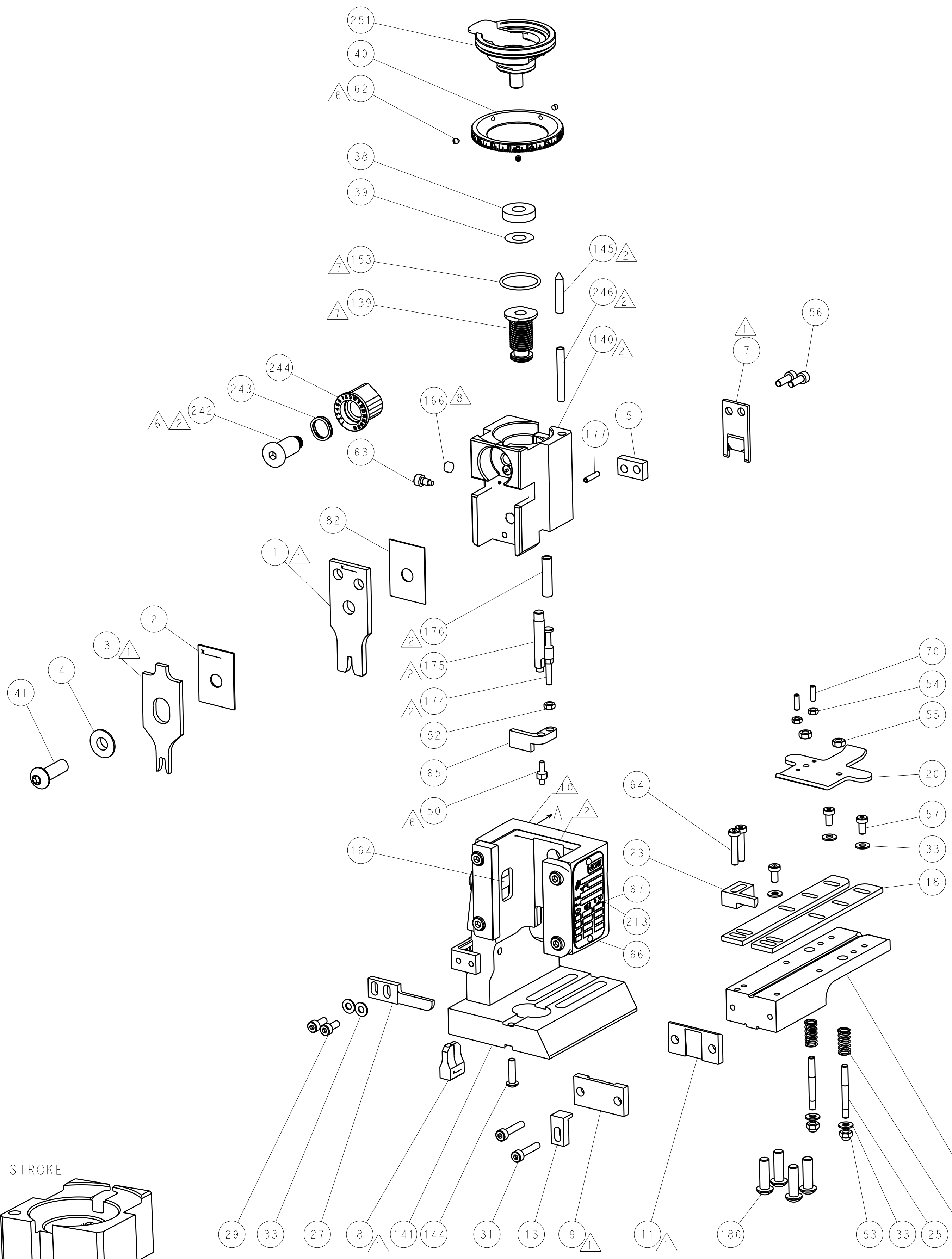
[illegible]

SHEET 1 OF 2 - 2 COVERED DOCUMENTS FOR INFORMATION AND RECORDATION UNLESS OTHERWISE NOTED, THE FOLLOWING INFORMATION IS FOR INFORMATION ONLY UNLESS OTHERWISE NOTED, THE FOLLOWING INFORMATION IS FOR INFORMATION ONLY		DWN 15 FEB 2013 R. O. WILSON		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLE: 10°		CDR 20 FEB 2013 K. J. STAKEM	
MATERIAL: -		FINISH: -		NAME: Ocean End Feed Applicator	
WEIGHT: -		SIZE: A		CAGE CODE: 00779	
CUSTOMER DRAWING:		DRAWING NO: C-2150315		RESTRICTED TO: -	
SCALE: 1:1		SHEET: 3		OF 4 REV: A	

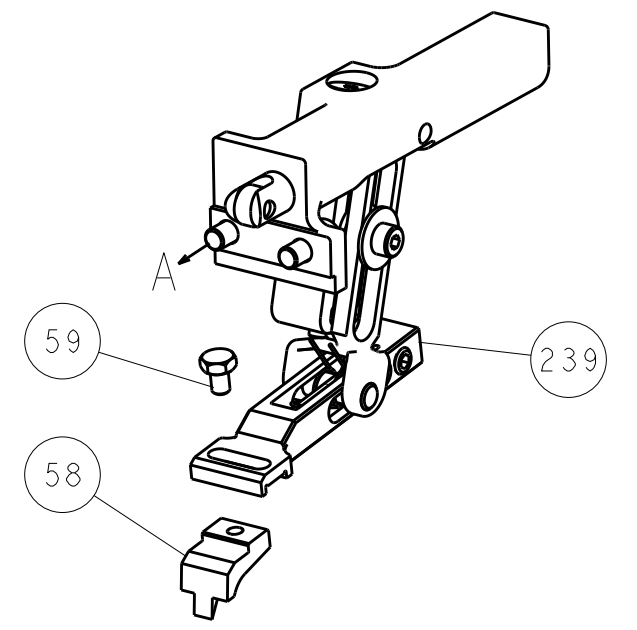
LOC		DIST		REVISONS			
A		66		DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1	-	-	-



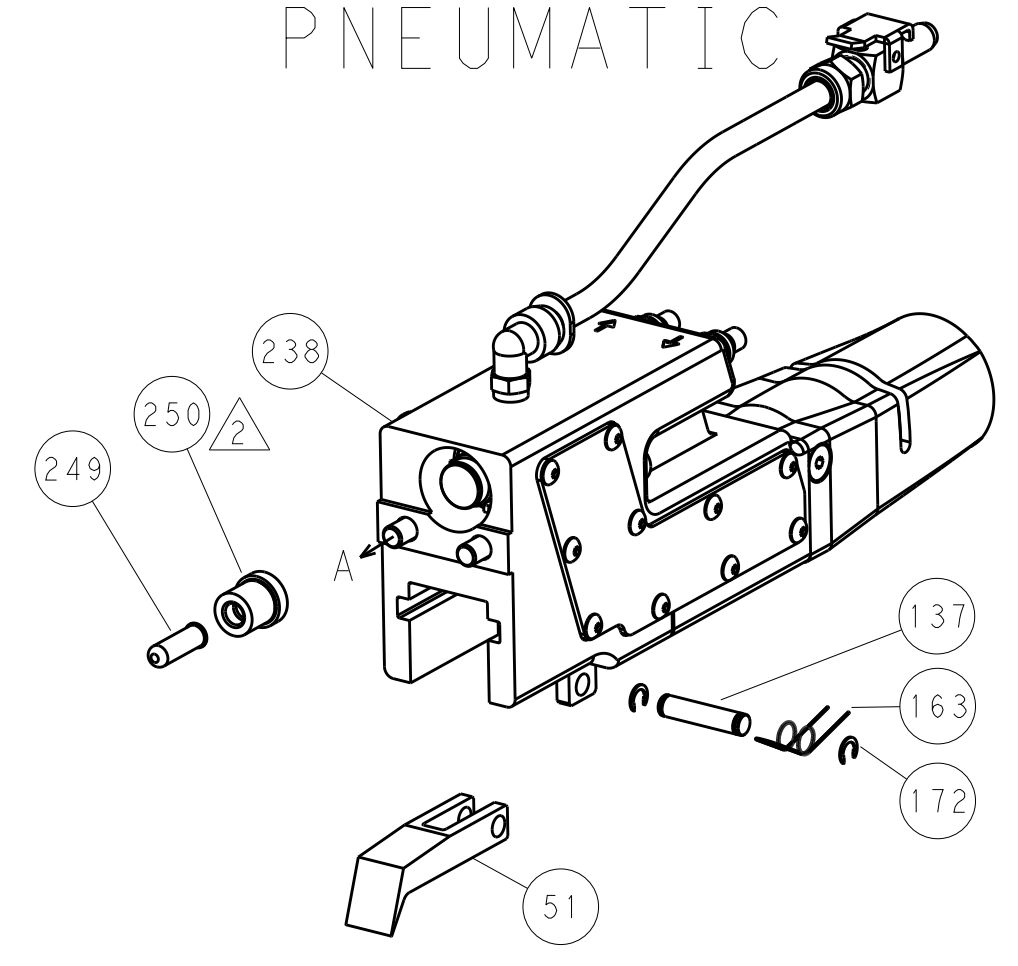
HOLDDOWN SET-UP



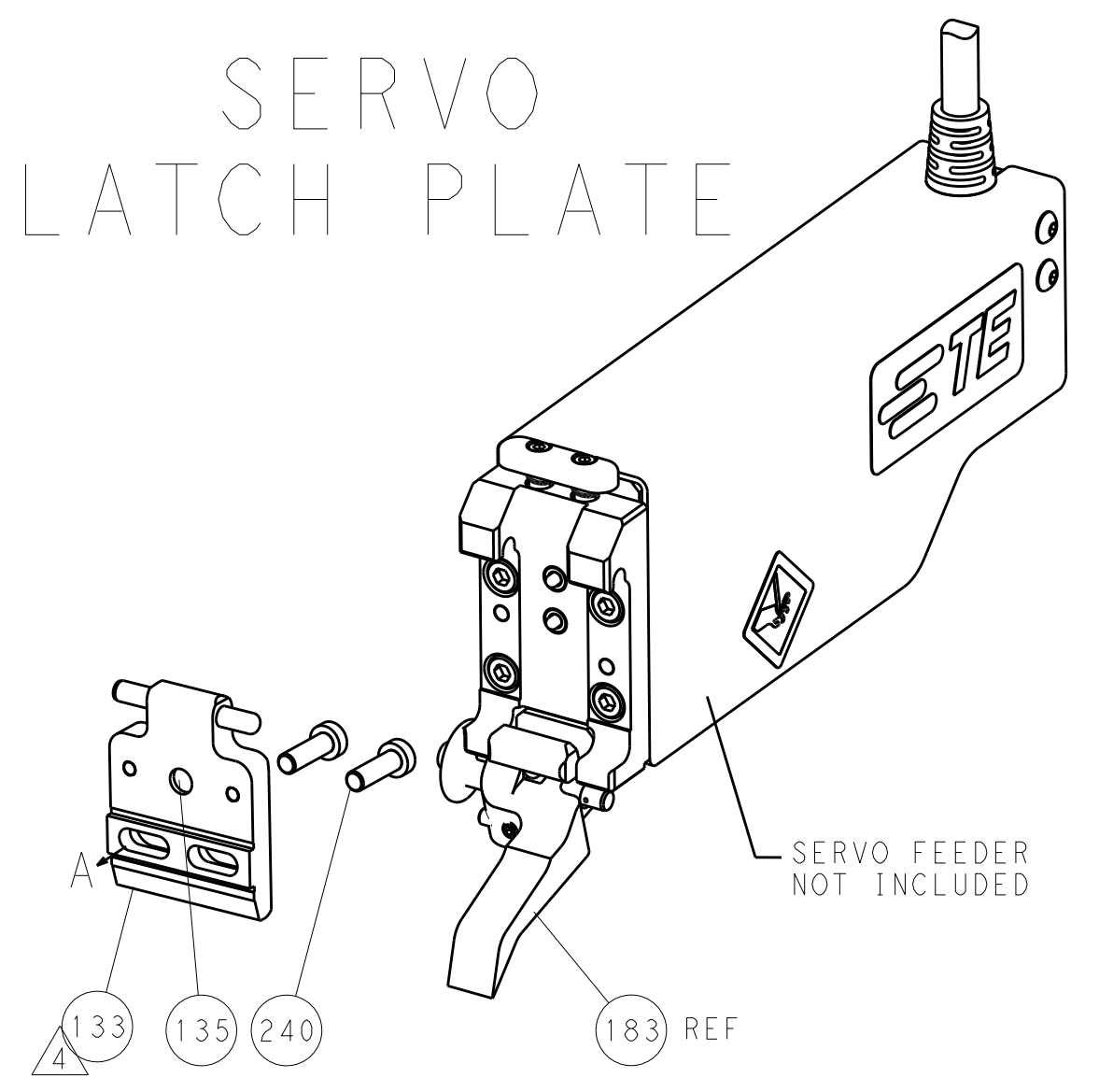
FEED TYPE
MECHANICAL



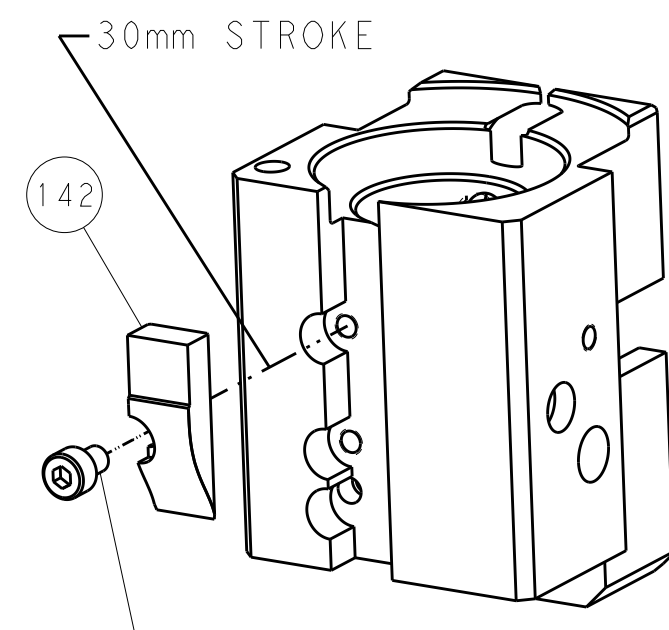
PNEUMATIC



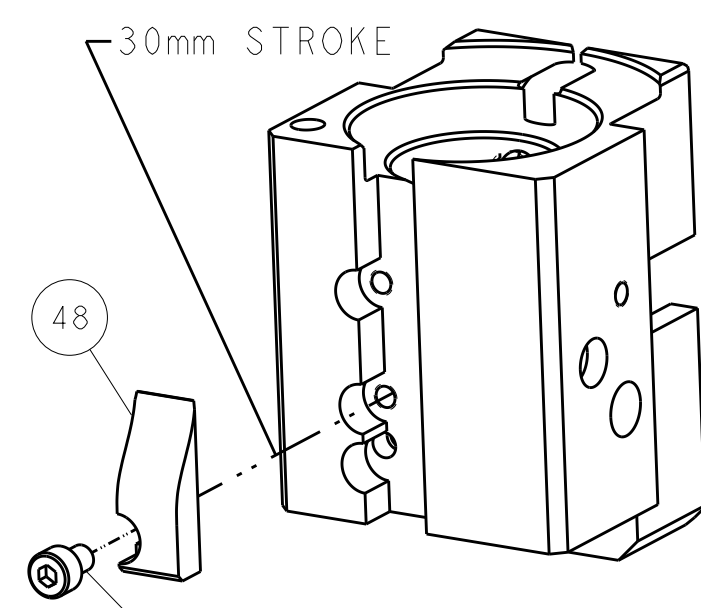
SERVO
LATCH PLATE



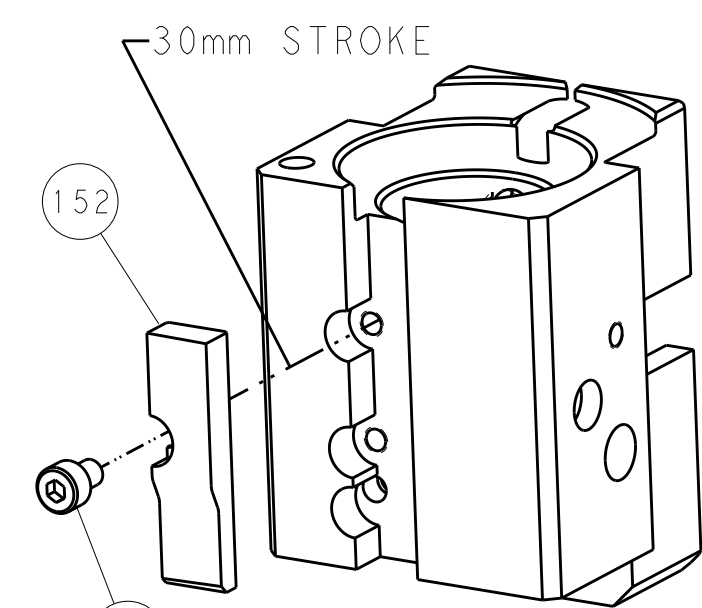
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST VERSION OF THE DRAWING.		DWN R. Q. WILSON 15FEB2013		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK K. J. STAKEM 20FEB2013		NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.001 ANGLES FINISH		APVD T. L. ELGIN 20FEB2013		SIZE A1	
MATERIAL		PRODUCT SPEC		CAGE CODE 00779	
		APPLICATION SPEC		DRAWING NO C=2150315	
		WEIGHT		RESTRICTED TO	
		CUSTOMER DRAWING		SCALE 1:1	
				SHEET 4 OF 4	
				REV A2	