

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

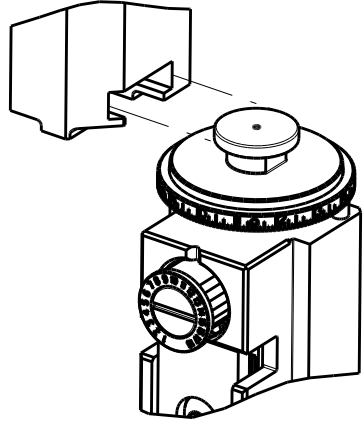
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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2150062-2

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

PNEUMATIC

CONVERT TO

SERVO LATCH PLATE
SMART APPLICATOR

PART NUMBERS REQUIRED

2119951-1
2161326-1

2150062-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

2150062-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

11

2150062-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2150062-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

3.81 mm [.150]

F

INSUL

5.59 mm [.220]

F

APPL INSTRUCTIONS

408-10390



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: 250 POSITIVE LOCK EX2 REC

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

5.50-6.50 mm [.217-.256 IN]

Ø3.00-5.10 mm [.118-.201 IN]

TERMINAL APPLICATION SPECIFICATION

(A)114-5119

-

-

(B)114-5195

-

-

TERMINALS APPLIED



TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

(A) 175024-1

(B) 179975-1

WIRE SIZE





CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



5.00mm2

2.58+/-0.05 [.102+/- .002]

2.0

3.00mm2

2.20+/-0.05 [.087+/- .002]

6.1

2.00mm2

1.83+/-0.05 [.072+/- .002]

10.2



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: 8-2150062-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150062-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150062-6

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

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

-

-

2119957-2

APPLICATOR SHIM PACK

260

-

1

-

1

1

8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

-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)

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LOC

DIST

REV

SET UP GAUGE

2119599-2

A

66

DESCRIPTION

DATE

DWN

APVD

RELEASED

28JAN2014

KH

UG

-

-

-

-

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

-

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

2063440-1

AIR FEED MODULE

238

-

-

1

1

-

2119740-2

TAG, IDENTIFICATION

213

-

-

REFREF

-

-

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

-

REFREF

REFREF

-

-

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

2119956-2

DOCUMENTATION PACKAGE

71

-

2

2

2

2

2-18032-2

SCR, SET, FLT POINT M3 X 10.0

70

-

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

1901681-9

HOLDDOWN, TERMINAL

65

-

2

2

2

2

2168400-5

SHCS, LOW HEAD, RoHS, M4 X 20

64

-

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

-

3

3

3

3

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

1-1752354-2

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

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

-

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

1-1752371-7

PLATE, STRIP GUIDE

24

-

1

1

1

1

240825-1

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

1901259-7

GUIDE, LOWER STRIP

18

-

4

4

4

4

1-2079383-1

SCR, BHSC, RoHS (M6 X 12)

17

-

1

1

1

1

1752360-1

SPACER, HOLD-DOWN

13

-

1

1

1

1

240833-1

PLATE, REAR SHEAR

11

-

-

-

-

-

-

-

10

-

1

1

1

1

690482-4

PLATE, FRONT SHEAR

9

1

1

1

1

1

2-1333223-3

ANVIL, COMBINATION

8

-

1

1

1

1

1-2217206-0

BLADE, SLUG

7

-

1

1

1

1

2-240641-7

SPACER

5

-

1

1

1

1

238009-1

BLOCK, FL CRIMPER SPACER

4

-

1

1

1

1

3-1633961-6

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

1-455888-0

SPACER, CRIMPER

2

-

1

1

1

1

3-1633609-8

CRIMPER, WIRE

1

-77

-7

-6

-5

-2

PART NO

DESCRIPTION

ITEM NO

Customer Accessible Production Drawing

SCALE 1:1

SHEET 1 OF 4

REV A

AMP 4805 REV 31MAR2000

1

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150062-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150062-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150062-4	-	-	-
	2-2150062-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE  4	-	-	-	-	-	-	-
	2-2150062-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150062-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.81 mm [.150]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 POSITIVE LOCK EX2 REC			
WIRE STRIP LENGTH 5.50-6.50 mm [.217-.256 IN]		INSULATION DIAMETER RANGE Ø3.00-5.10 mm [.118-.201 IN]	
TERMINAL APPLICATION 		(A)114-5119 - -	
SPECIFICATION (B)114-5195		- -	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 175024-1	(B) 179975-1		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
5.00mm2		2.58+/-0.05 [1.102+/- .002]		2.0
3.00mm2		2.20+/-0.05 [1.087+/- .002]		6.1
2.00mm2		1.83+/-0.05 [1.072+/- .002]		10.2



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: 8-2150062-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150062-5
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 50, 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

```
*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.
```

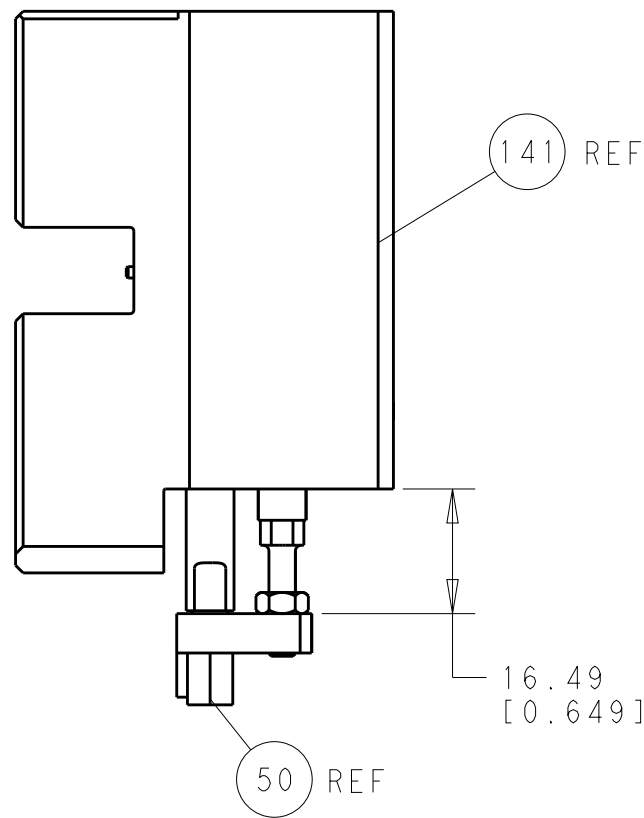
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE 2119599-2				LOC A	DIST 66	REVSIONS					
						P	LTR	DESCRIPTION	DATE	DWN	APVD
							-	SEE SHEET	-	-	-
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
1	1	1	1		2119083-1			RETAINER, INSULATION DIAL			242
-	-	-	2		2168400-7			SHCS, LOW HEAD, RoHS, M5 X 10			241
-	-	-	1		2063440-1			AIR FEED MODULE			239
-	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		6-9931111-6			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	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
-	1	-	-		1633743-1			SERVO FEED LATCH ASM			133
1	1	1	1		455888-5			SPACER, CRIMPER			82
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	-		2119740-1			TAG,IDENTIFICATION			67
2	2	2	2		2168078-1			SCREW, DRIVE, RH, RoHS, 2 x .188			66
1	1	1	1		1901681-9			HOLDDOWN, TERMINAL			65
2	2	2	2		2168400-5			SHCS, LOW HEAD, RoHS, M4 X 20			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
3	3	3	3		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		1-1752354-2			STANDOFF,HOLD-DOWN			50
-	-	-	1		18023-9			SCR, SKT HD CAP M4 X 6.0			49
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		2119644-2			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		1-1752371-7			PLATE, STRIP GUIDE			24
1	1	1	1		240825-1			PLATE, STRIP HOLD DOWN			23
2	2	2	2		2-22281-3			SPRING, COMPRESSION			22
1	1	1	1		1752373-4			DRAW			20
2	2	2	2		1901259-7			GUIDE, LOWER STRIP			18
1	1	1	1		1752360-1			SPACER,HOLD-DOWN			13
1	1	1	1		240833-1			PLATE, REAR SHEAR			11
-	-	-	-		-			-			10
1	1	1	1		690482-4			PLATE, FRONT SHEAR			9
1	1	1	1		2-1333223-3			ANVIL, COMBINATION			8
1	1	1	1		1-2217206-0			BLADE, SLUG			7
1	1	1	1		2-240641-7			SPACER			5
1	1	1	1		238009-1			BLOCK, FL CRIMPER SPACER			4
1	1	1	1		3-1633961-6			CRIMPER, INSULATION F PREMIUM			3
1	1	1	1		1-455888-0			SPACER, CRIMPER			2
1	1	1	1		3-1633609-8			CRIMPER, WIRE			1
7-27-25-22	PART NO					DESCRIPTION					ITEM NO

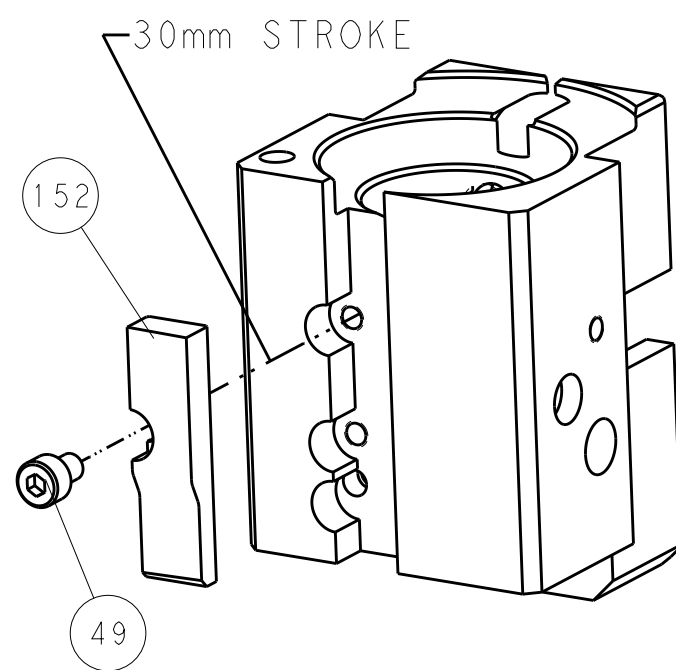
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±°		NAME Ocean End Feed Applicator -	
		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
MATERIAL -		APPLICATION SPEC		A 1 00779 C-2150062	
FINISH -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Product Drawing					
				SCALE 1:1	SHEET 3 OF 4
				REV A	

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

HOLDDOWN SET-UP



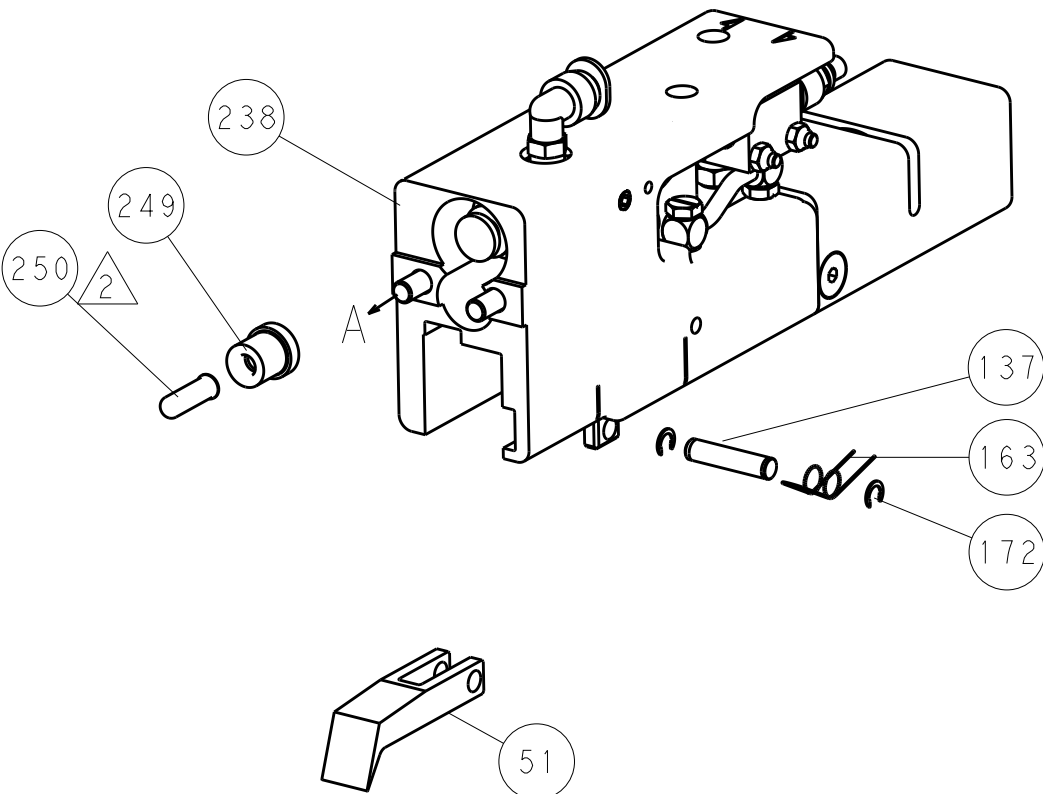
CAM POSITION



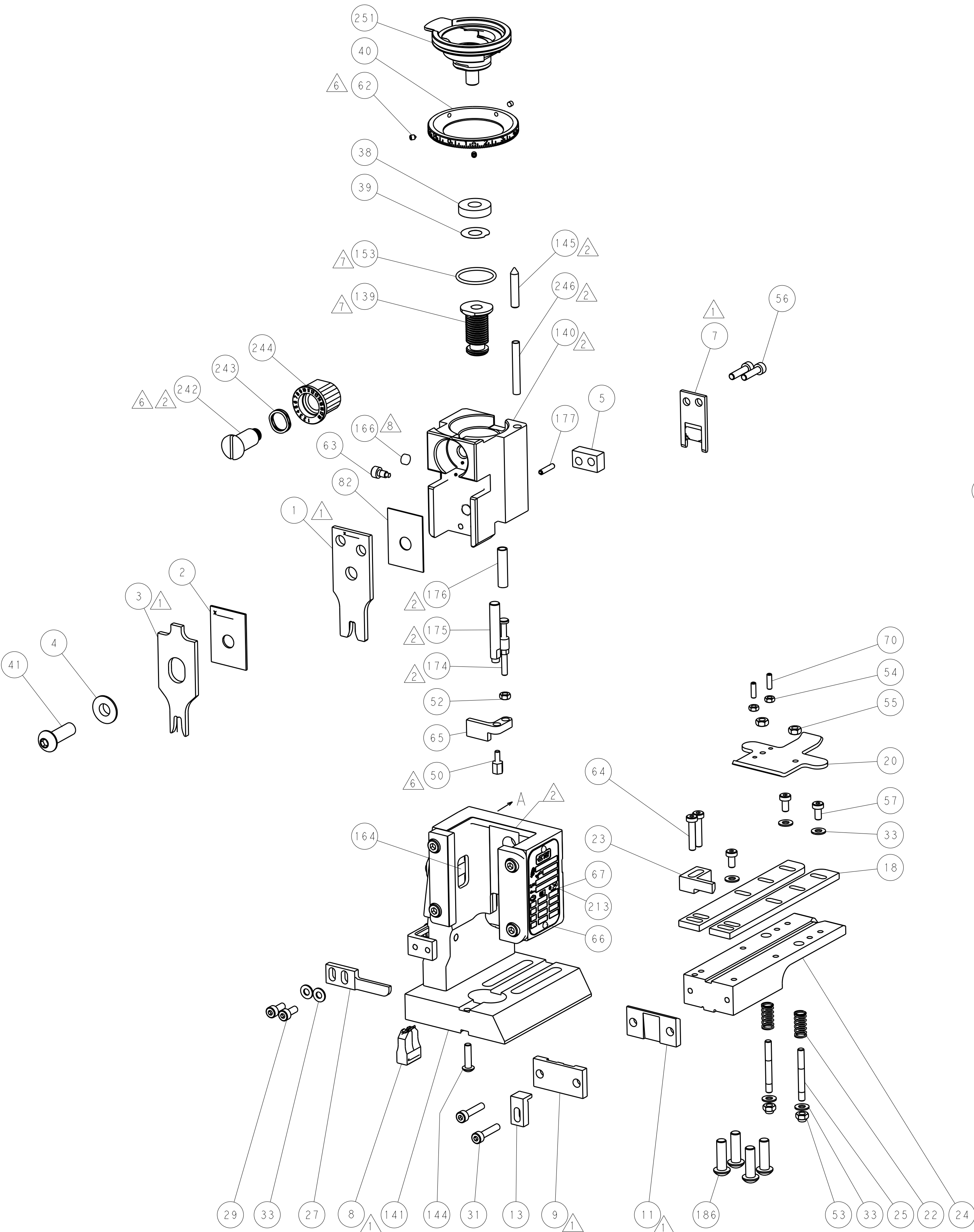
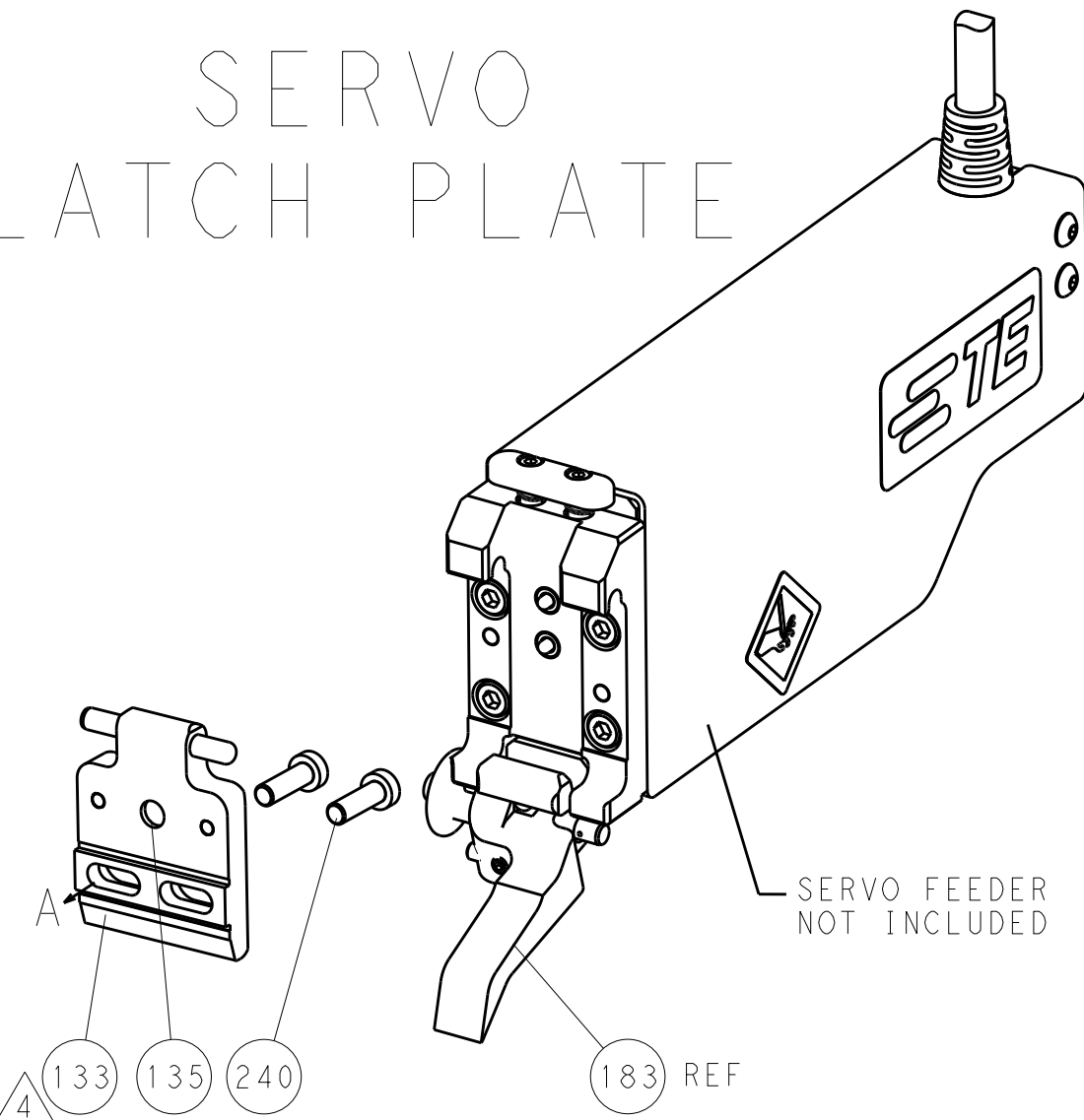
AIR FEED

FEED TYPE

PNEUMATIC



SERVO LATCH PLATE



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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CHK S. XI 13FEB2012		NAME	Ocean End Feed Applicator	
APVD S. XI 13FEB2012		PRODUCT SPEC	SIZE	
APPLICATION SPEC		APPLY SPEC	CAGE CODE	
MATERIAL		WEIGHT	DRAWING NO	
FINISH		Customer Accessible Production Drawing	©=2150062	
SCALE		1:1	SHEET	
SHEET		4	REV	
REV		A		