

8

7

6

5

4

3

2

1

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20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

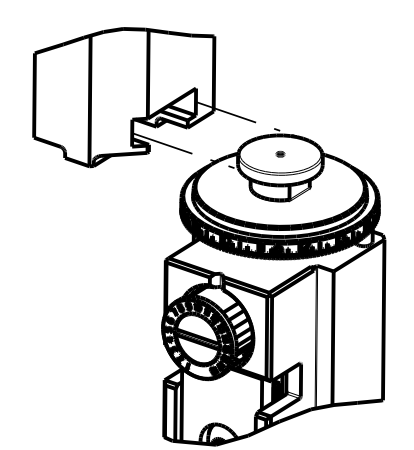
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150296-2

C

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE
SMART APPLICATOR

2119951-1
2161326-1

1901697-1
-

8-2150296-5
8-2150296-4

-
-

-
-

2168400-7 (QUANTITY 2)
-

2150296-5

C

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

PNEUMATIC FEED

2119950-1

2119792-1

-

2119641-1

-

2063440-2

2150296-6

C

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

1

-

-

-

-

2150296-7

C

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2150296-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

3.56 mm [.140]

F

INSUL

4.57 mm [.180]

F

APPLICATOR INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: RINGTONGUE WITH INS SUPPORT

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.80-5.60 mm [.189-.220 IN]

Ø2.54-3.81 mm [.100-.150 IN]

TERMINAL APPLICATION SPECIFICATION

114-3118

-

-

TERMINALS APPLIED

4

0

TE TERMINAL

TE TERMINAL

TE TERMINAL

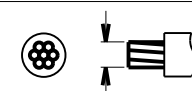
TE TERMINAL

160789-2

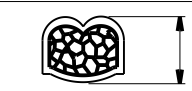
160789-3

160789-5

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

9

2.50mm2

2.29+/-0.05 [.090+/- .002]

4.4

2.00mm2

2.18+/-0.05 [.086+/- .002]

5.7

1.50mm2

2.06+/-0.05 [.081+/- .002]

7.0

1.00mm2

1.96+/-0.05 [.077+/- .002]

8.0



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: 8-2150296-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150296-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150296-6

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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

11 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

13 CUT TO LENGTH AT ASSEMBLY.

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

A

RELEASE

21NOV2012

L.Z

S.X

B

ECR-13-000120

04JAN2012

L.Z

S.X

C

ECR-14-002390

18FEB2014

X.Z

T.E

-

-

1

-

-

2119957-2

APPLICATOR SHIM PACK

260

-

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

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

2063440-2

AIR FEED MODULE

238

-

-

1

1

-

2119740-2

TAG, IDENTIFICATION

213

-

-

REF

REF

-

1901697-1

FEED FINGER ASSEMBLY, EF

183

-

-

-

-

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

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

-

-

REF

REF

-

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

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

-

4

4

4

4

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

2

2

2

2168083-9

SCR, SKT HD CAP, RoHS, M4 X 20

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

2119792-2

PAWL, EF, AIR

51

-

-

-

-

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

-

8

8

8

8

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

1752371-1

PLATE, STRIP GUIDE

24

-

2

2

2

2

3-22281-8

SPRING, COMPRESSION

22

-

2

2

2

2

18025-2

WASHER, SPRG LOCK, REG M4

21

-

1

1

1

1

1752373-1

DRAG

20

-

1

1

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1

2-1901696-7

STRIP GUIDE, REAR

19

-

1

1

1

1

2-1901695-7

STRIP GUIDE, FRONT

18

-

4

4

4

4

1-2079383-1

SCR, BHSC, RoHS (M6 X 12)

17

-

1

1

1

1

7-240641-5

SPACER

16

-

1

1

1

1

240644-1

PLATE, REAR SHEAR

11

-

2

2

2

2

1-240645-2

SPACER, SHEAR PLATE

10

-

1

1

1

1

240642-1

PLATE, FRONT SHEAR

9

-

1

1

1

1

1333222-8

ANVIL, COMBINATION

8

-

1

1

1

1

2-240651-1

BLADE, SLUG

7

-

1

1

1

1

1-240641-0

SPACER

5

-

1

1

1

1

238009-1

BLOCK, FL CRIMPER SPACER

4

-

1

1

1

1

2119582-3

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

1-455888-0

SPACER, CRIMPER

2

-

1

1

1

1

456411-9

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

PART NO

DESCRIPTION

ITEM NO

100CT2012

100CT2012

100CT2012

100CT2012

NAME

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±.5

±0.13

±0.013

±0.0001

±.1

100CT2012

100CT2012

100CT2012

100CT2012

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

C

OWN

CHK

CHK

APVD

S.X

TE Connectivity

Harrisburg, PA 17105-3608

Ocean End Feed

Applicator

00779

2150296

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

C

100CT2012

100CT2012

100CT2012

100CT2012

NAME

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±.5

±0.13

±0.013

±0.0001

±.1

100CT2012

100CT2012

100CT2012

100CT2012

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

C

OWN

CHK

CHK

APVD

S.X

TE Connectivity

Harrisburg, PA 17105-3608

Ocean End Feed

Applicator

00779

2150296

Customer Accessible Production Drawing

SCALE

1:1

SHEET

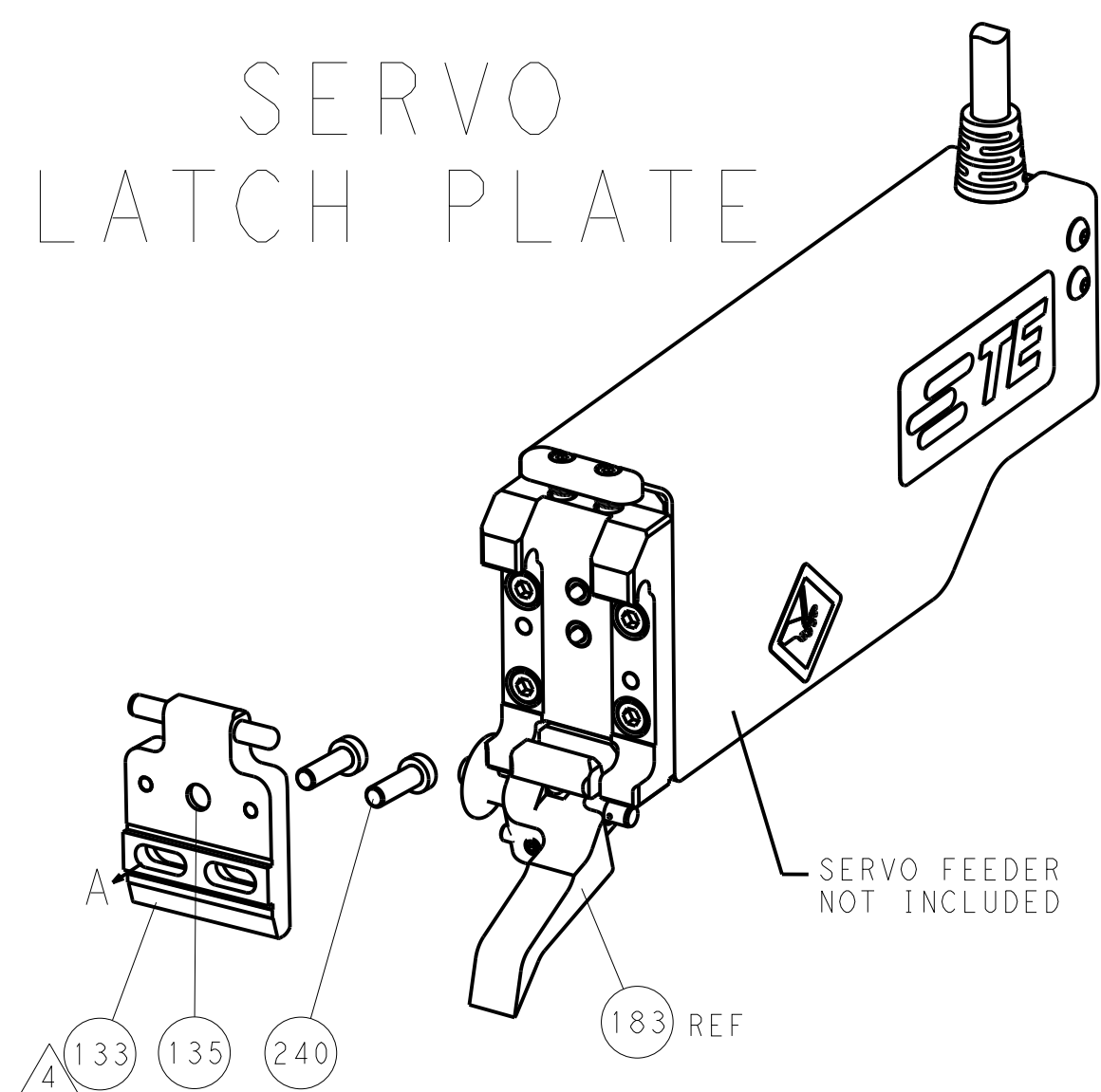
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OF

4

REV

C



SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

REVISIONS			
DESCRIPTION	DATE	BY	APP

DATE	TIME	LOC.	DESCRIPTION	DATE	DWN	APPR.
2-11-99	2	H	O	-	-	-
			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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243

-	1	1	1	219083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY,EF	183
-	-	-	2	21045-3	RING, RETAIN EXTERN 3/16 CRESCENT	172

-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	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	2119798-2	DETENT PIN	145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	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	455888-5	SPACER, CRIMPER	82

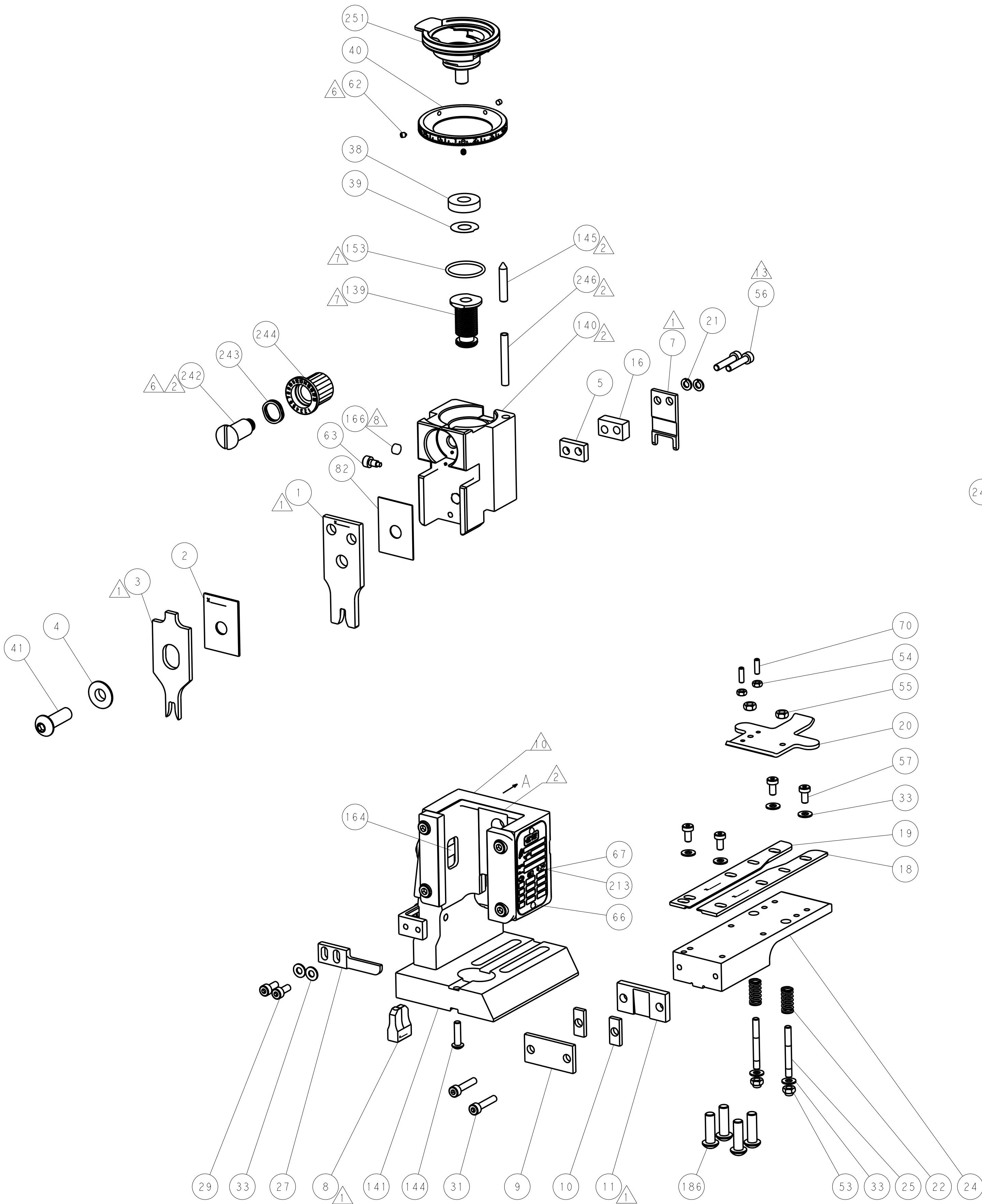
-	1	1	1	219956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2-18032-1	SCR, SET, FLT POINT M3 X 10.0	70
-	1	-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5	SCR, SET, SC, CONE POINT, M3 x 4.0	62
-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
-	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53

-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2079383-7	SCR, BHSC, ROHS (M8 X 25)	41
-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	2119644-2	RAM WASHER, PRECISION	38
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2168083-6	SCR, SKT HD CAP, ROHS, M4 X 20	31

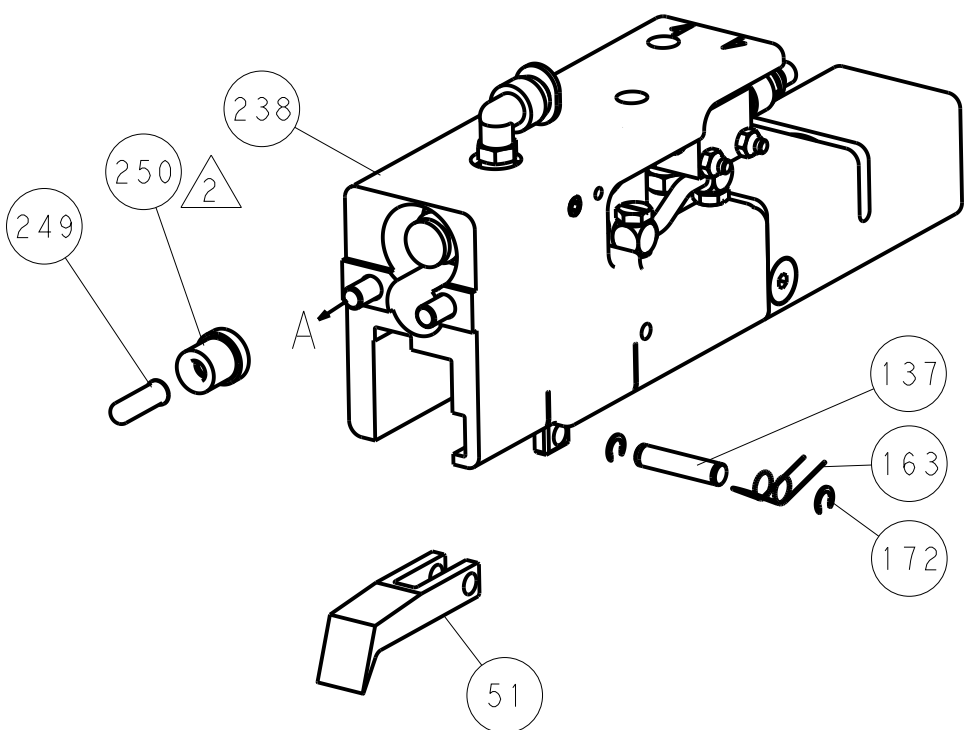
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|---|---|---|---|---|-------------|--------------------------------|----|
| - | 8 | 8 | 8 | 2 | 118028-2 | WASHER, FLAT, REG M4 | 33 |
| - | 2 | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 31 |
| - | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, 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 | 1752371-1 | PLATE, STRIP GUIDE | 24 |
| - | 2 | 2 | 2 | 2 | 3-22281-8 | SPRING, COMPRESSION | 22 |
| - | 2 | 2 | 2 | 2 | 18025-2 | WASHER, SPRG LOCK, REG M4 | 21 |
| - | 1 | 1 | 1 | 1 | 1752373-1 | DRAW | 20 |
| - | 1 | 1 | 1 | 1 | 2-1901696-7 | STRIP GUIDE, REAR | 19 |
| - | 1 | 1 | 1 | 1 | 2-1901695-7 | STRIP GUIDE, FRONT | 18 |
| - | 1 | 1 | 1 | 1 | 7-240641-5 | SPACER | 16 |
| - | 1 | 1 | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | 2 | 2 | 2 | 2 | 1-240645-2 | SPACER, SHEAR PLATE | 10 |
| - | 1 | 1 | 1 | 1 | 240642-1 | PLATE, FRONT SHEAR | 9 |
| 1 | 1 | 1 | 1 | 1 | 1333222-8 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 2-240651-1 | BLADE, SLUG | 7 |
| - | 1 | 1 | 1 | 1 | 1-240641-0 | SPACER | 5 |
| - | 1 | 1 | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1 | 2119582-3 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 1 | 1 | 456411-9 | CRIMPER, WIRE PREMIUM | 1 |

7-27-25-22		PART NO		DESCRIPTION		QTY		MATERIAL	
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		OWN		100CT2012		TE Connectivity Harrisburg, PA 17105-3608		NO	
		CHK		100CT2012					
		APVD		100CT2012					
		PRODUCT SPEC		NAME					
		APPLICATION SPEC		Ocean End Feed Applicator					
		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
		A1		00779		C-2150296		-	
		WEIGHT		-		Customer Accessible Production Drawing		SCALE	
						1:1		SHEET 3 of 4	
								REV C	

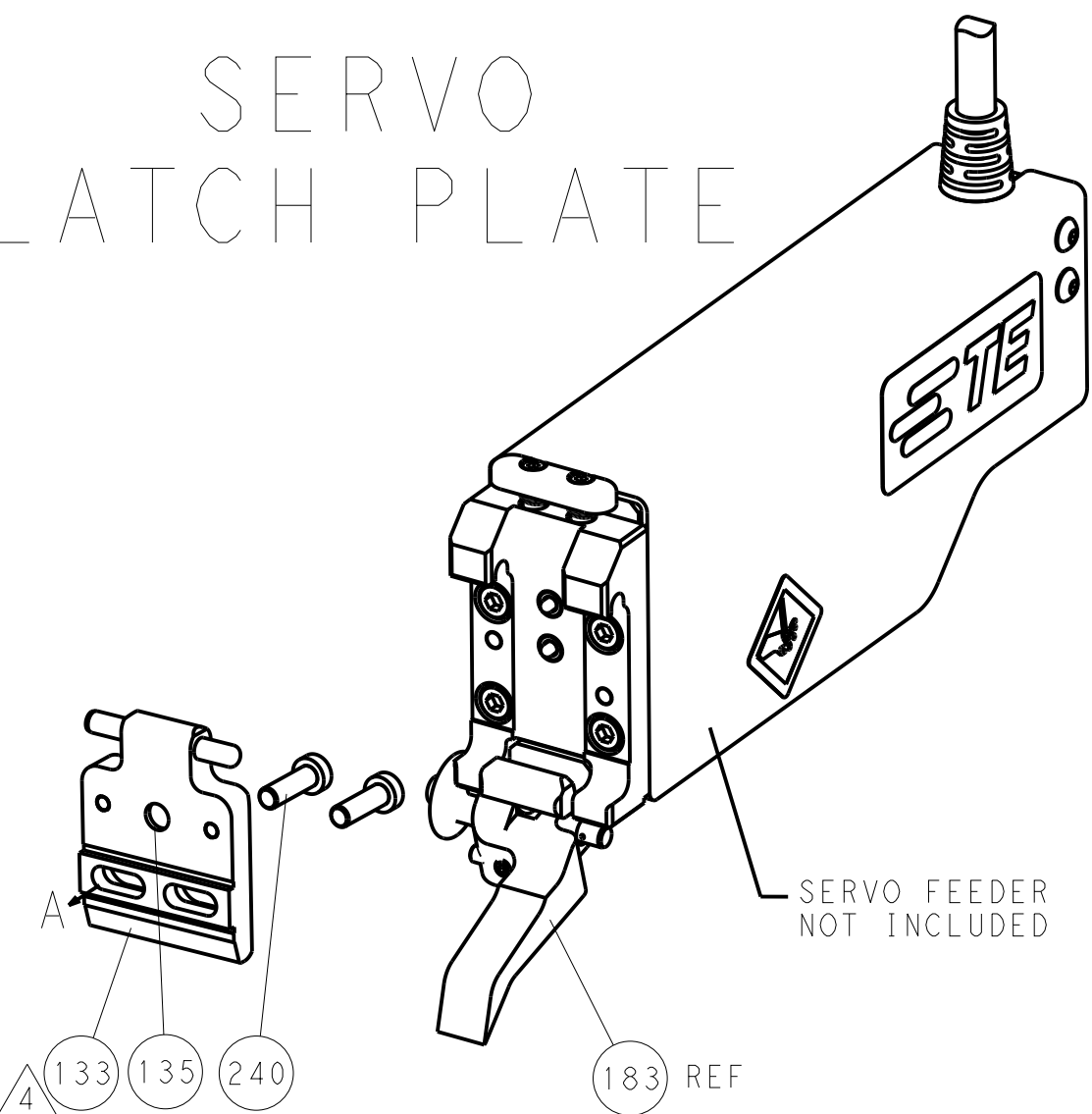
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



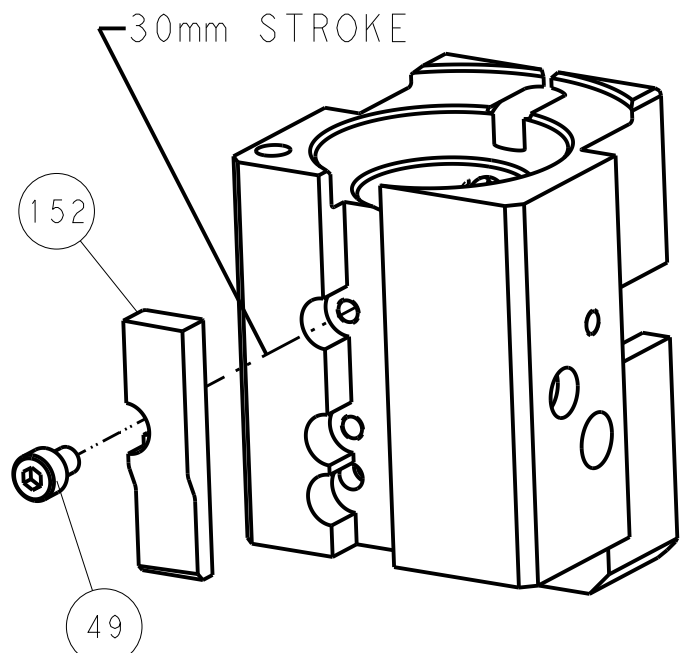
FEED TYPE
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITION



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. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN: L. ZHANG 10OCT2012 CHK: L. ZHANG 10OCT2012 APVD: S. XI 10OCT2012				STE TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				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				NAME: Ocean End Feed Applicator			
MATERIAL: -				FINISH: -				SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150296			
								RESTRICTED TO: -			
								Customer Accessible Production Drawing SCALE: 1:1 SHEET: 4 OF 4 REV: C			