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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

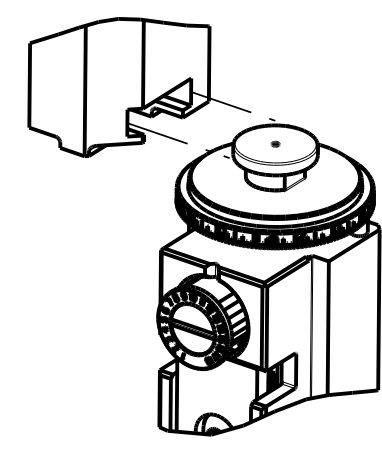
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150193-1

B

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

2119792-2

1901697-1

-

-

-

-

2119641-1

-

-

2063440-1

2168400-7 (QUANTITY 2)

-

2150193-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

2063961-1

1901697-1

8-2150193-5

5-18022-5

-

-

2119653-1

-

-

-

2168400-7 (QUANTITY 2)

-

2150193-5

B

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

2063961-1

2119792-2

5-18022-5

-

2119653-1

2119641-1

-

-

2063440-1

-

2150193-6

B

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

-

-

-

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-

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-

-

2150193-7

B

FINE CRIMP HEIGHT ADJUST

NONE

-

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7-2150193-7

A

CRIMP TOOLING KIT

-

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-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.03 mm [.080]

F

INSUL

2.79 mm [.110]

OV

APPL INSTRUCTIONS

408-10390



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .250 SERIES FASTIN-FASTON CONNECTOR

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

.189-.220 IN [4.80-5.59 mm]

Ø.055-.091 IN [1.40-2.31 mm]

TERMINAL APPLICATION SPECIFICATION

114-18022

-

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TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

160860-1

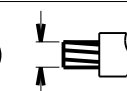
160860-2

160860-3

160860-4

WIRE SIZE





CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



1.00mm2

1.61+/-0.050 [.063+/- .002]

9.7

0.75mm2

1.52+/-0.050 [.060+/- .002]

10.5

0.50mm2

1.43+/-0.050 [.056+/- .002]

11.3



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: 8-2150193-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150193-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150193-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150193-6

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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.

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

APPLICATOR STYLE CONVERSION CHART

-	-	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
-	-	REF	REF	-	-	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
-	REF	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	1	455888-5	SPACER, CRIMPER	82
-	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	2168400-5	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
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1-1752354-1	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	2119644-2	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	1752371-9	PLATE, STRIP GUIDE	24
-	1	1	1	1	1	240825-1	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	1901259-3	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	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	-	10
-	1	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9
-	1	1	1	1	1	1333216-9	ANVIL, COMBINATION	8
-	1	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	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	1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	1	1	1	1-456405-3	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.03 mm [.080]

F

INSUL

2.79 mm [.110]

OV

APPL INSTRUCTIONS

408-10390



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .250 SERIES FASTIN-FASTON CONNECTOR

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

.189-.220 IN [4.80-5.59 mm]

Ø.055-.091 IN [1.40-2.31 mm]

TERMINAL APPLICATION SPECIFICATION

114-18022

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-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

160860-1

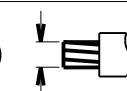
160860-2

160860-3

160860-4

WIRE SIZE





CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



1.00mm2

1.61+/-0.050 [.063+/- .002]

9.7

0.75mm2

1.52+/-0.050 [.060+/- .002]

10.5

0.50mm2

1.43+/-0.050 [.056+/- .002]

11.3



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: 8-2150193-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150193-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150193-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150193-6

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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.

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

DIST 66

P

LTR

DESCRIPTION

DATE

DWN

APVD

A

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ECR-14-011491

30JUL2014

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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

-

-

REF

REF

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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

-

REF

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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240638-1

SPRING, FEED FINGER

163

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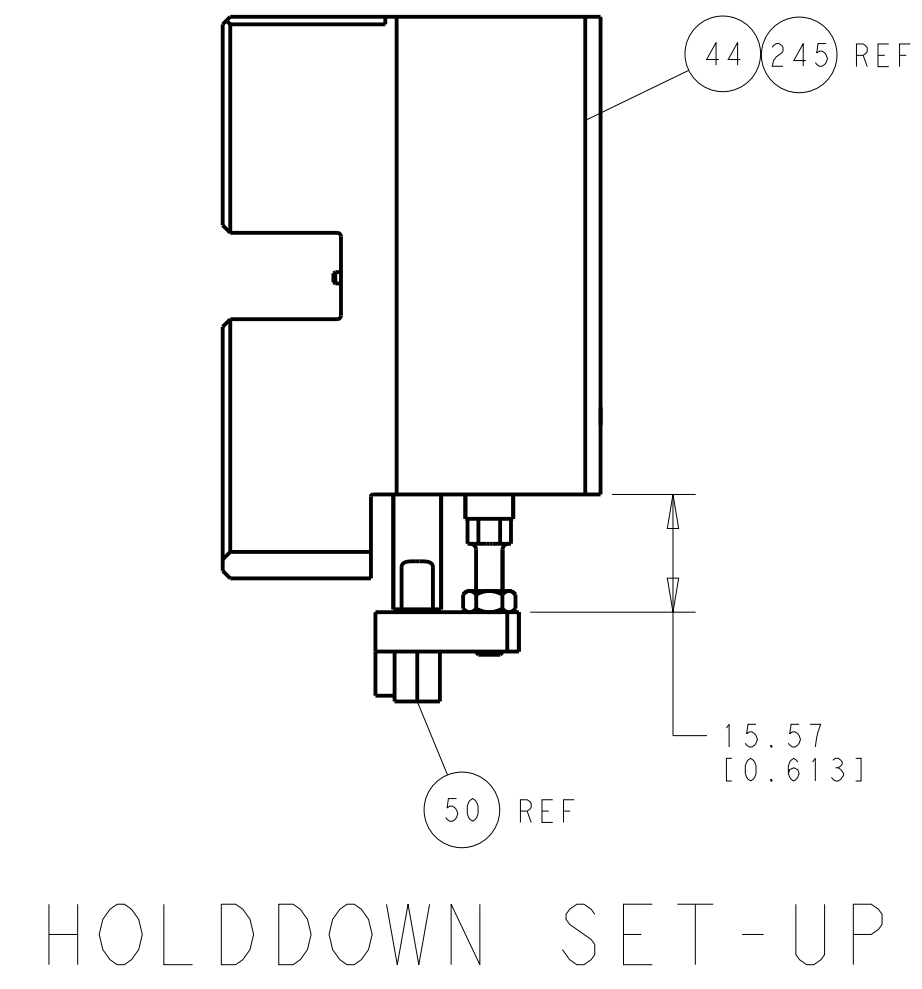
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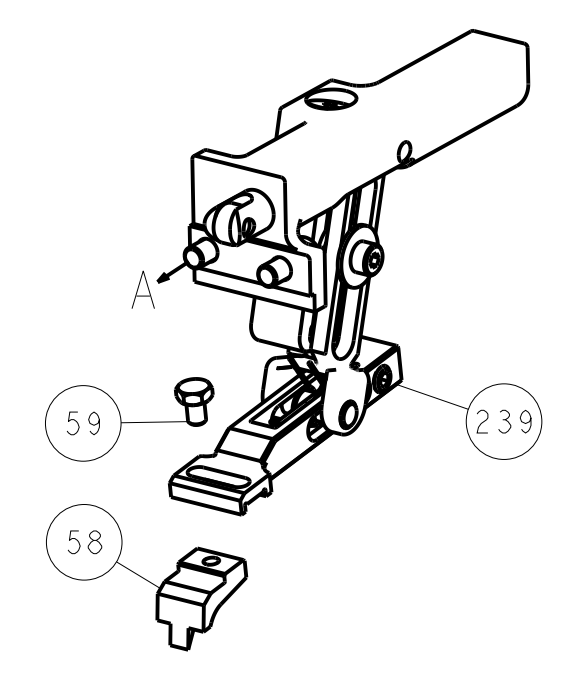
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PIN, RETAIN, GRVD, 3/

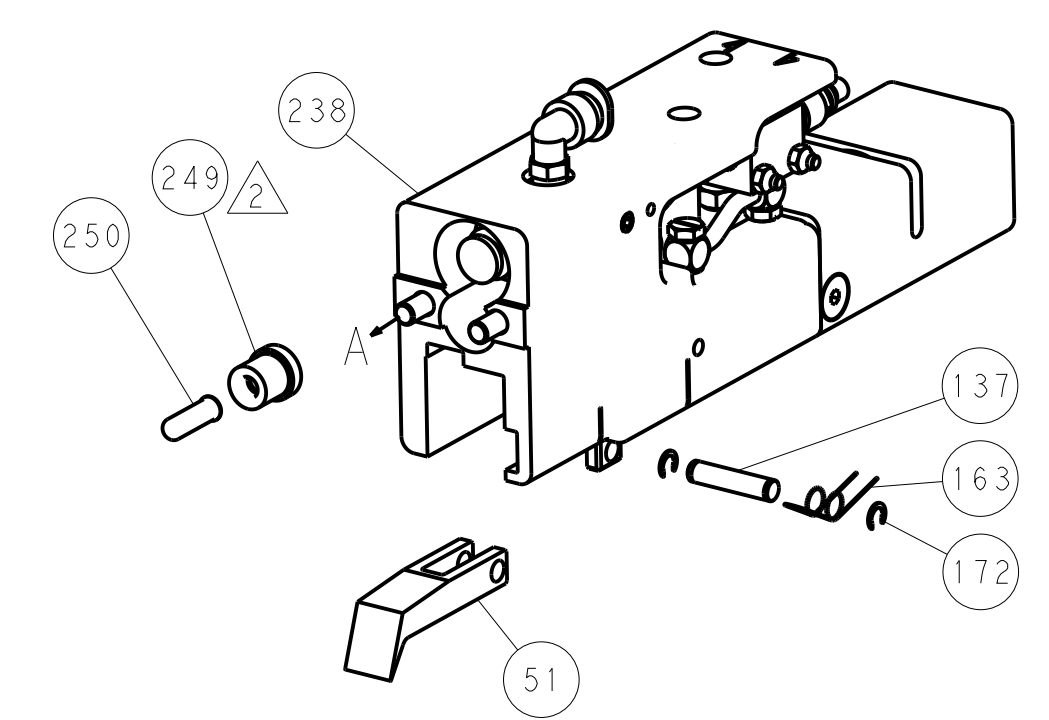
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		-		SEE SHEET 1	-	-	-



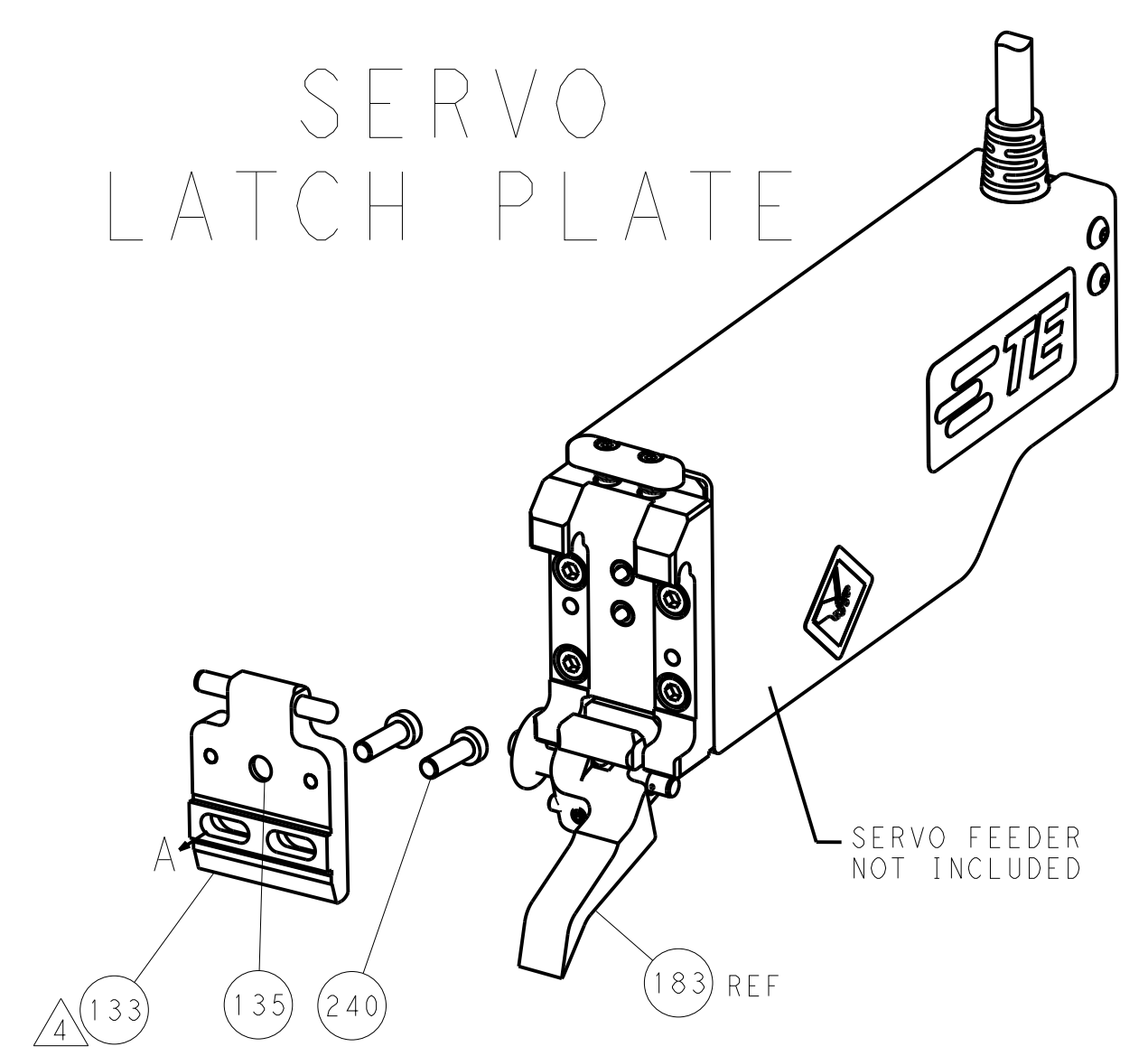
FEED TYPE
MECHANICAL



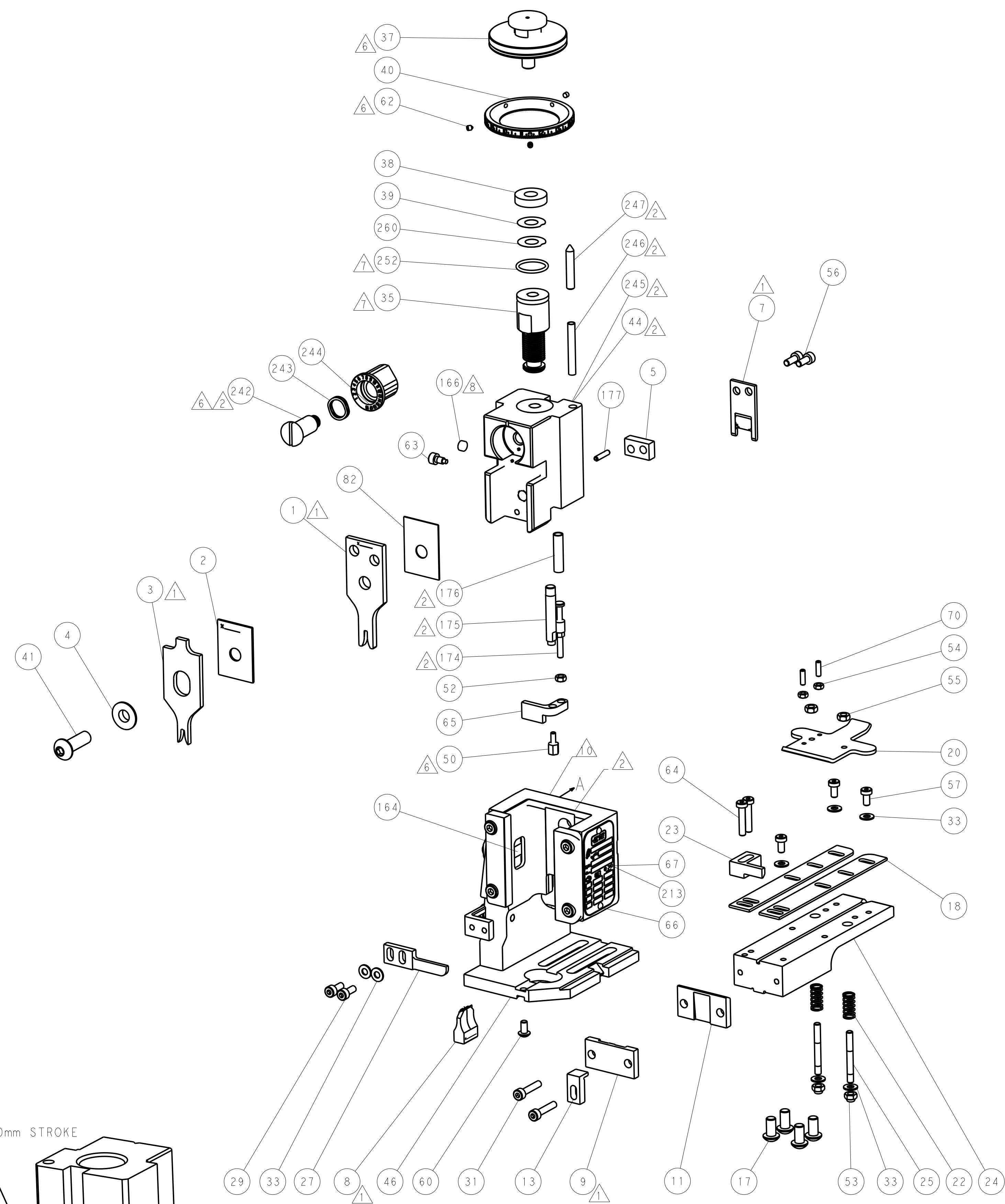
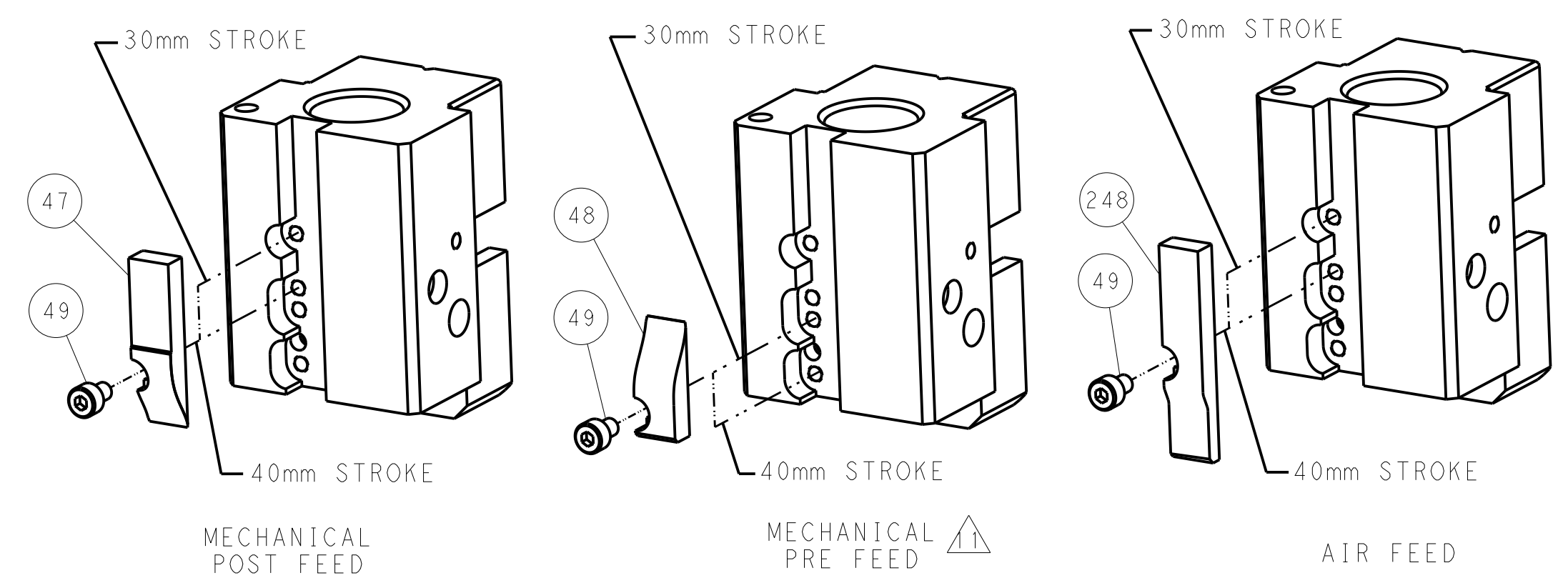
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		TE Connectivity	
mm		0 PLC ±0.5		C.K. CHEN		Harrisburg, PA 17105-3608	
		1 PLC ±0.13		S.XI			
		2 PLC ±0.013		I. CRUZ			
		3 PLC ±0.0001		APVD			
		ANGLES ±0.0001		PRODUCT SPEC			
		FINISH		APPLICATION SPEC			
				WEIGHT			
				Customer Accessible Production Drawing			
				SCALE			
				SHEET			
				2 of 4			
				REV			
				B			

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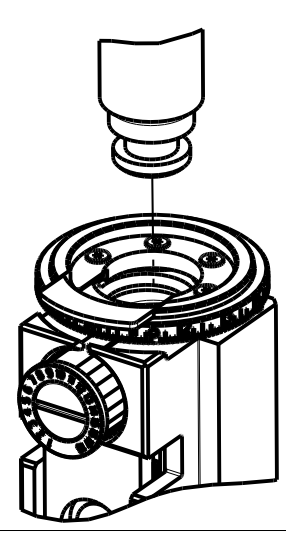
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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2150193-1

REVISION

B

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

2-2150193-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2-2150193-5

B

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2-2150193-7

B

FINE CRIMP HEIGHT ADJUST

NONE

7-2150193-7

A

CRIMP TOOLING KIT

-

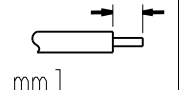
APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .250 SERIES FASTIN-FASTON CONNECTOR

WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
.189-.220 IN [4.80-5.59 mm]		Ø.055-.091 IN [1.40-2.31 mm]

TERMINAL APPLICATION SPECIFICATION

114-18022

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-

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160860-1	160860-2	160860-3	160860-4

WIRE SIZE





CRIMP HEIGHT
mm [INCH]



CRIMP HEIGHT
REFERENCE SETTING



1.00mm2	1.61+/-0.050 [.063+/- .002]	9.7
0.75mm2	1.52+/-0.050 [.060+/- .002]	10.5
0.50mm2	1.43+/-0.050 [.056+/- .002]	11.3



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: 8-2150193-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150193-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150193-5

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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED					
PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
SERVO LATCH PLATE	2119951-1	1901697-1	8-2150193-5	-	-	2168400-7 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2150193-4	-	-	-
MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
SERVO LATCH PLATE	2119951-1	1901697-1	8-2150193-5	-	-	2168400-7 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2150193-4	-	-	-
MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
-	-	-	-	-	-	-
-	-	-	-	-	-	-

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

REV

1

DATE

10JAN2013

CHK

S.XI

APVD

1.CRUZ

10JAN2013

NAME

Ocean End Feed
Applicator

SIZE

A1

CAGE CODE

00779

DRAWING NO

©=2150193

RESTRICTED TO

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

3

OF

4

REV

B

REVISIONS

REV	LYR	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 1	-	-	-

6

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

1

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

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

-

-

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	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	2168400-5	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
-	-	-	-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1-1752354-1	STANDOFF, HOLD-DOWN	50
-	-	-	-	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	2119644-2	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	1752371-9	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	1901259-3	GUIDE, LOWER STRIP	18
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9
-	1	1	1	1	1333216-9	ANVIL, COMBINATION	8
-	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	6-240641-5	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	1	1	1-456405-3	CRIMPER, WIRE PREMIUM	1

77-27-25-22-21

PART NO

DESCRIPTION

ITEM NO

AMP 4805 REV 31MAR2000

8

7

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5

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THIS DRAWING IS UNPUBLISHED.

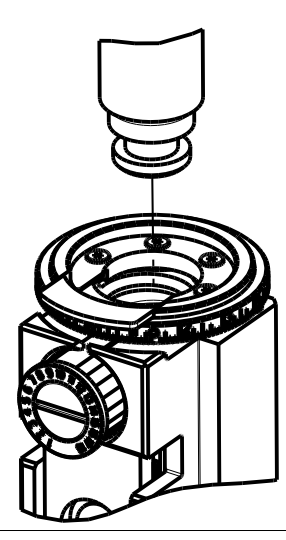
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2150193-1

REVISION

B

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

2-2150193-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2-2150193-5

B

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2-2150193-7

B

FINE CRIMP HEIGHT ADJUST

NONE

7-2150193-7

A

CRIMP TOOLING KIT

-

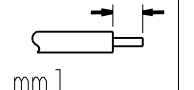
APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .250 SERIES FASTIN-FASTON CONNECTOR

WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
.189-.220 IN [4.80-5.59 mm]		Ø.055-.091 IN [1.40-2.31 mm]

TERMINAL APPLICATION SPECIFICATION

114-18022

-

-

-

-

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160860-1	160860-2	160860-3	160860-4

WIRE SIZE





CRIMP HEIGHT
mm [INCH]



CRIMP HEIGHT
REFERENCE SETTING



1.00mm2	1.61+/-0.050 [.063+/- .002]	9.7
0.75mm2	1.52+/-0.050 [.060+/- .002]	10.5
0.50mm2	1.43+/-0.050 [.056+/- .002]	11.3



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: 8-2150193-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150193-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150193-5

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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED					
PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
SERVO LATCH PLATE	2119951-1	1901697-1	8-2150193-5	-	-	2168400-7 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2150193-4	-	-	-
MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
SERVO LATCH PLATE	2119951-1	1901697-1	8-2150193-5	-	-	2168400-7 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2150193-4	-	-	-
MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
-	-	-	-	-	-	-
-	-	-	-	-	-	-

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

REV

1

DATE

10JAN2013

CHK

S.XI

APVD

1.CRUZ

10JAN2013

NAME

Ocean End Feed
Applicator

SIZE

A1

CAGE CODE

00779

DRAWING NO

©=2150193

RESTRICTED TO

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

3

OF

4

REV

B

REVISIONS

REV	LYR	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 1	-	-	-

6

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

1

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

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

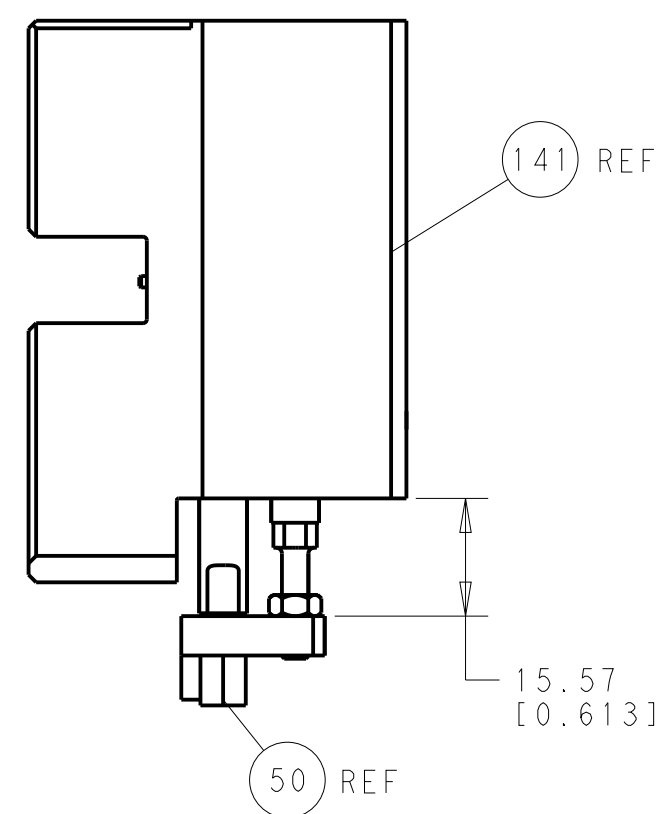
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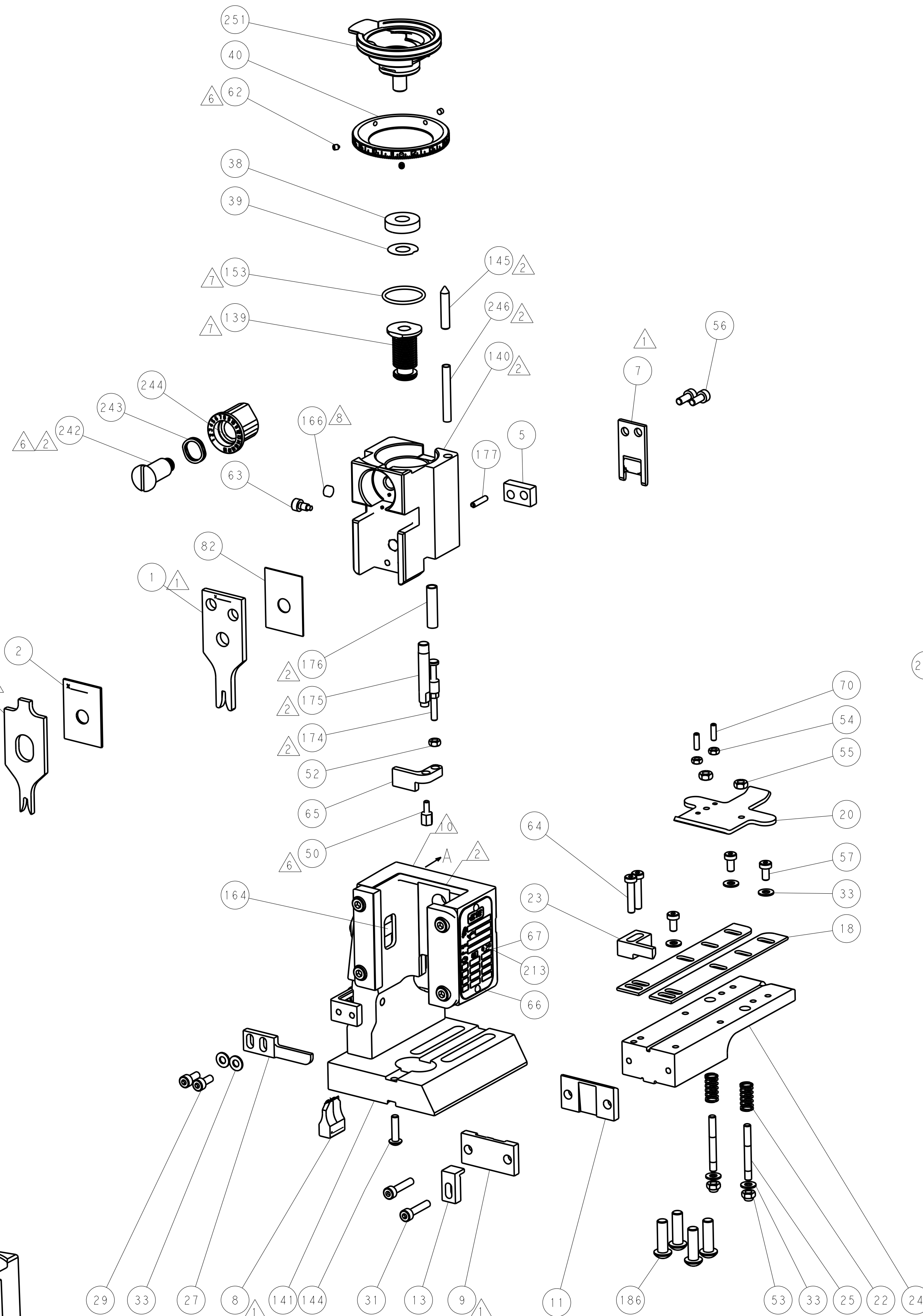
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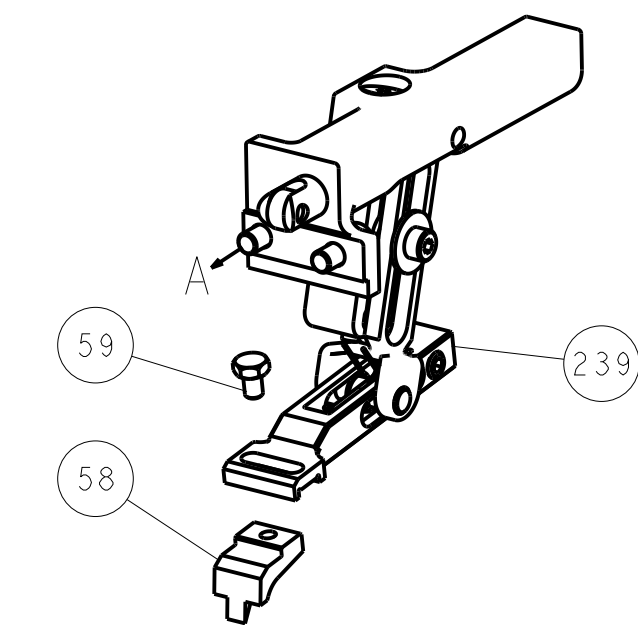
 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 || - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	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				



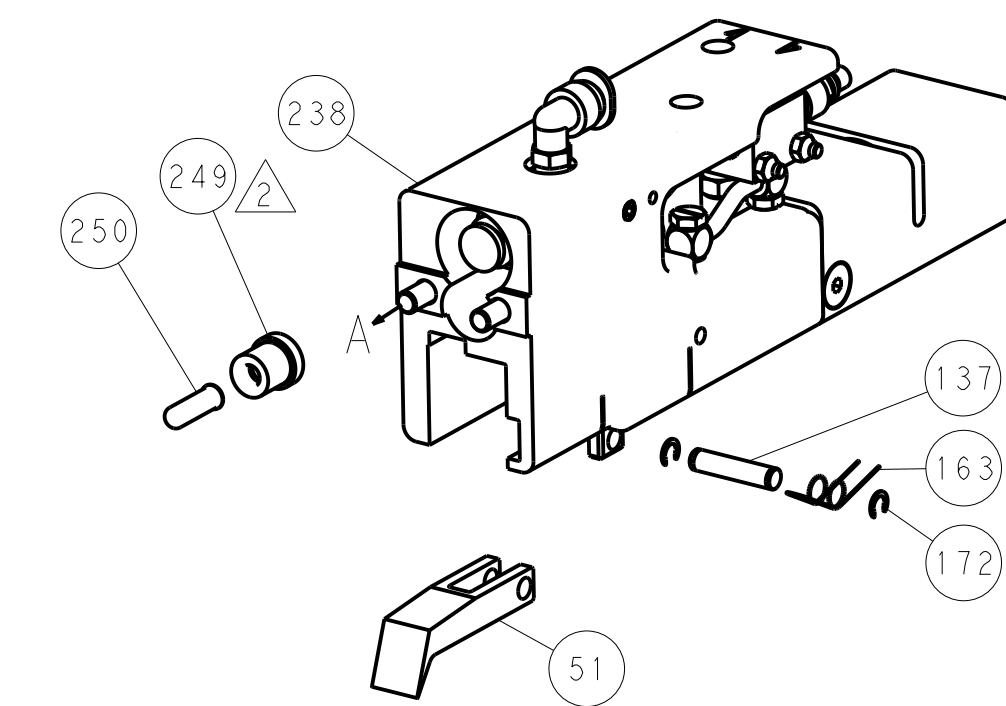
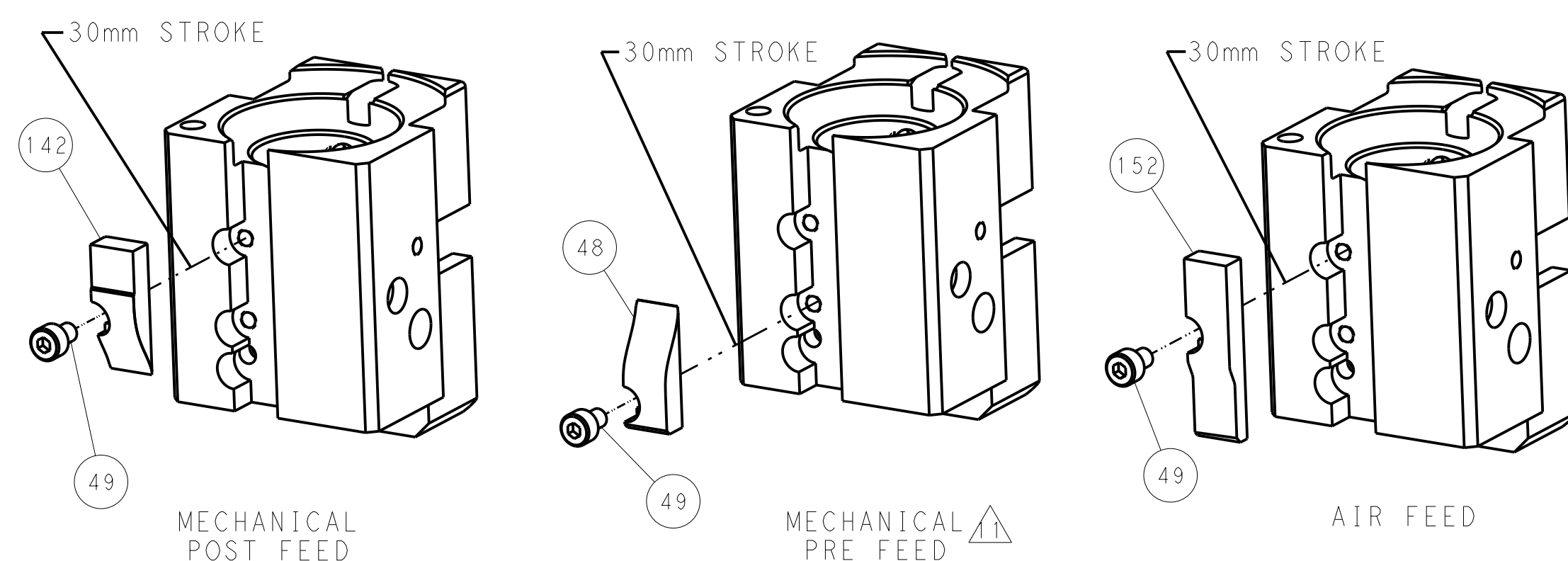
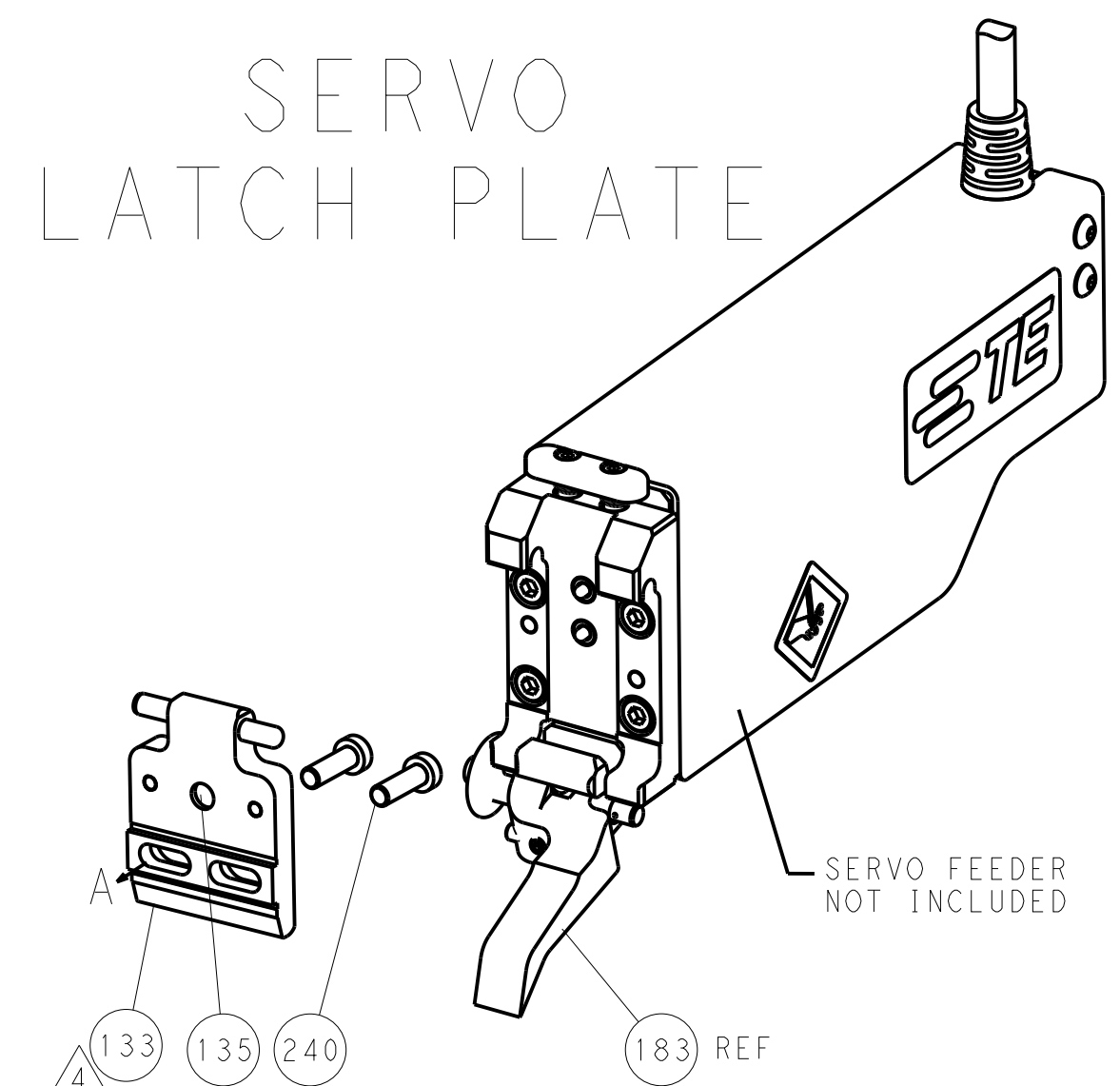
HOLDDOWN SET-UP



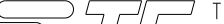
FEED TYPE
MECHANICAL



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)

FIG. 13: DRAWING 1-12 CONTAINS THE DOCUMENT FOR THE LATEST REVISION. CONSULT THE REVISIONS SECTION OF THE DRAWING FOR THE LATEST REVISION.		OWN C. CHEN	10JAN2013	 TE Connectivity Morrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:	CWN S. XI	10JAN2013	NAME Ocean End Feed Applicator
		APPLD CRUZ	10JAN2013	PRODUCT SPEC -	
MATERIAL -		FINISH -	WEIGHT -	APPLICATION SPEC -	
			SIZE A	CAGE CODE 00779	DRAWING NO C-2150193
			Customer Accessible Production Drawing		
			SCALE 1:1	SHEET 1 OF 1	REV B