

8

7

6

5

4

3

2

1

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20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

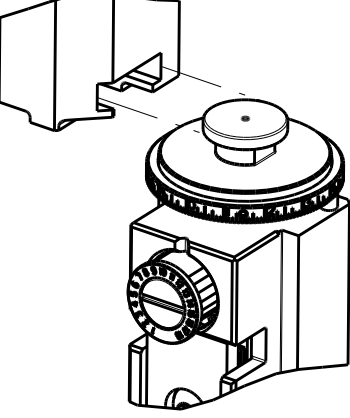
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150408-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE
SMART APPLICATOR

2119951-1
2161326-1

1901697-1
-

8-2150408-5
8-2150408-4

-
-

-
-

2168400-7 (QUANTITY 2)
-

2150408-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

PNEUMATIC FEED

2119950-1
2119792-1

-
-

-
-

-
2119641-1

-
-

-
2063440-2

2150408-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE¹

-

-

-

-

-

-

2150408-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2150408-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.79 mm [.110]

F

INSUL

5.00 mm [.197]

F

APPLICATOR INSTRUCTIONS

408-10390



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: 3.2ø CLUSTER REC. "L" TYPE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

7.70-8.70 mm [.303-.343 IN]

Ø2.20-3.20 mm [.087-.126 IN]

TERMINAL APPLICATION SPECIFICATION

114-5215

-

-

TERMINALS APPLIED



TE TERMINAL

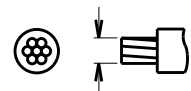
TE TERMINAL

TE TERMINAL

TE TERMINAL

316292-1

WIRE SIZE



CRIMP HEIGHT

mm [INCH]



CRIMP HEIGHT

REFERENCE SETTING



1.104ø+1.104ø+0.97ø

2.12+/-0.05 [.083+/- .002]

6.2

0.97ø+0.97ø+0.87ø

1.97+/-0.05 [.078+/- .002]

8.2

1.02ø+1.02ø

1.84+/-0.05 [.072+/- .002]

9.7

0.92ø+0.72ø

1.70+/-0.05 [.067+/- .002]

11.0



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: 8-2150408-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150408-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150408-6

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 62,180 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 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

12

CUT TO LENGTH AT ASSEMBLY.

13

TERMINAL LUBRICANT IS 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.

-	-	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
-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)

SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-2		A	66	P	LTR	DESCRIPTION	DATE
				A		RELEASE	03MAR2014
							XZ
							TE

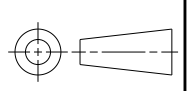
-	1	-	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	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
-	1	1	1	1	2-1752354-7	STANDOFF, HOLD-DOWN	180
-	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	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	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	1901681-1	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	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	690455-3	STRIPPER, FRONT CASTING	27
-	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	2-1752371-0	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-3	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	22281-8	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	2-240641-0	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240833-6	PLATE, REAR SHEAR	11
-	2	2	2	2	7-240645-4	SPACER, SHEAR PLATE	10
-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	1	1	3-1803001-9	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	9-240651-2	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-4	SPACER	5
-	1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	2-1803016-9	CRIMPER, INSULATION F	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1	1	409414-3	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

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DWN
X. ZHAO
CHK
L. ZHANG
APVD
T. ELBIN

14JAN2014
14JAN2014
14JAN2014

DIMENSIONS:
mm



0 PLC ±.5
1 PLC ±0.13
2 PLC ±0.13
3 PLC ±0.013
4 PLC ±0.0001
ANGLES ±.5
FINISH

TOLERANCES UNLESS OTHERWISE SPECIFIED:

WEIGHT

Customer Accessible Production Drawing

NAME
Ocean End Feed
Applicator

SIZE
A

CAGE CODE
00779

DRAWING NO
©=2150408

RESTRICTED TO

SCALE
1:1

SHEET
1

OF
4

REV
A

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

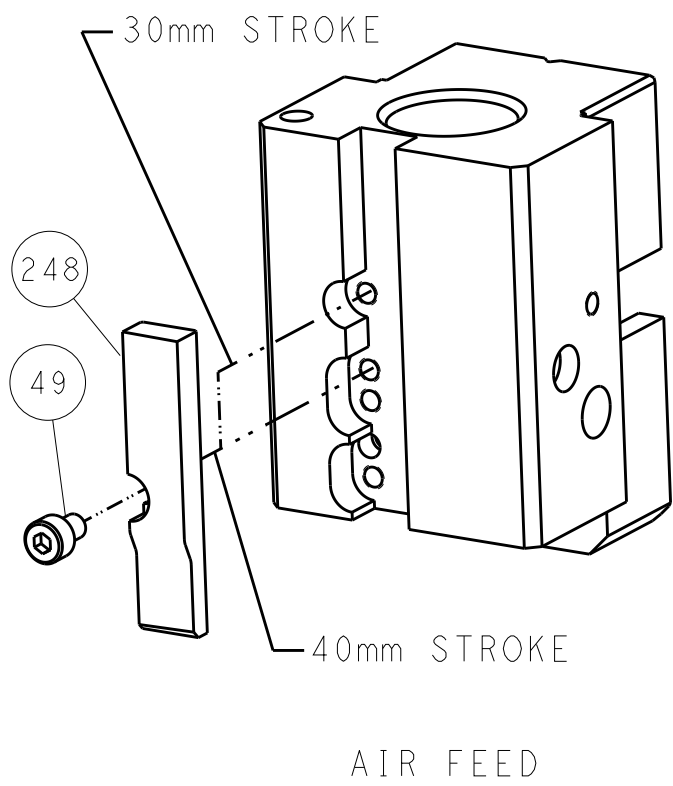
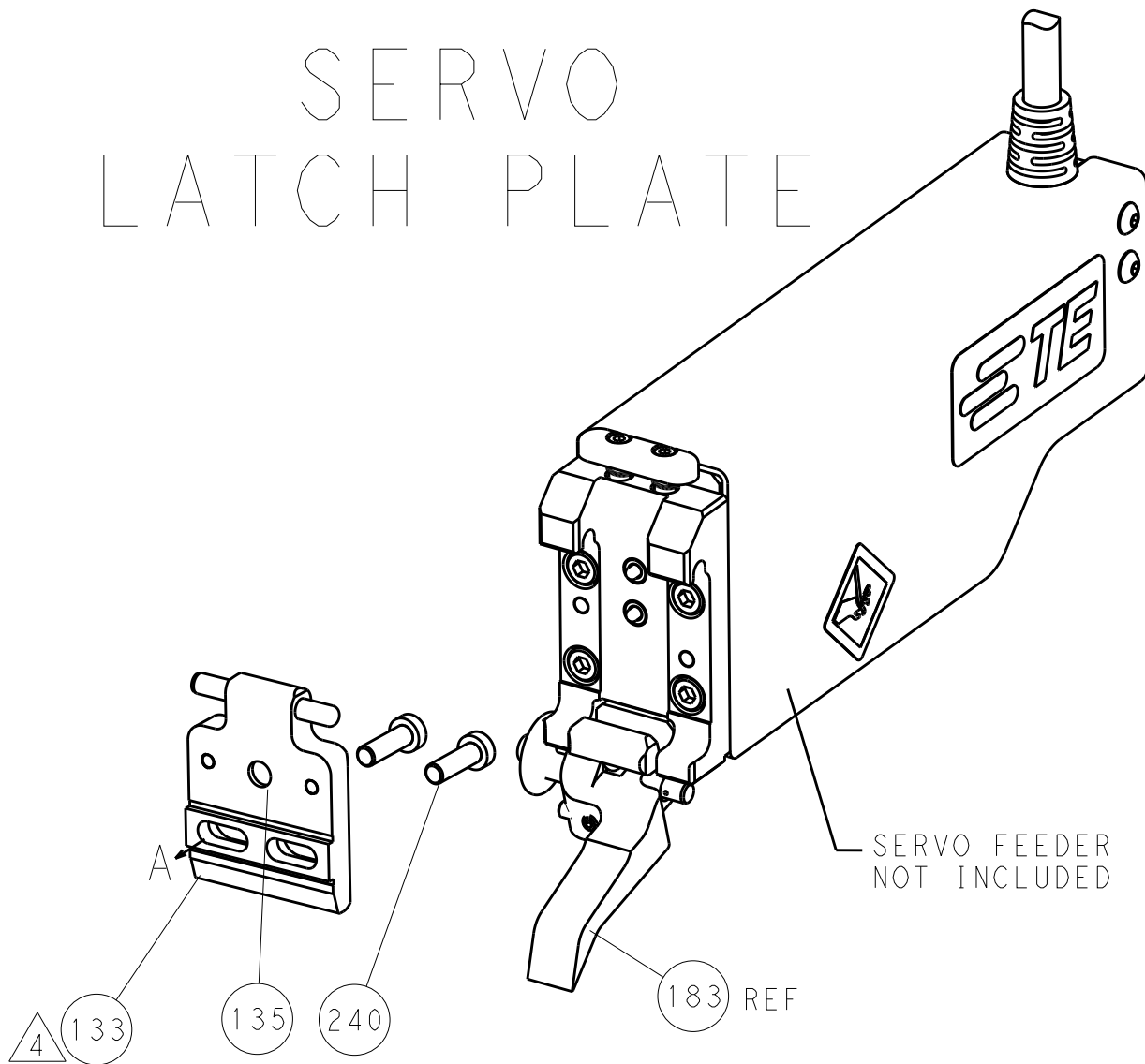
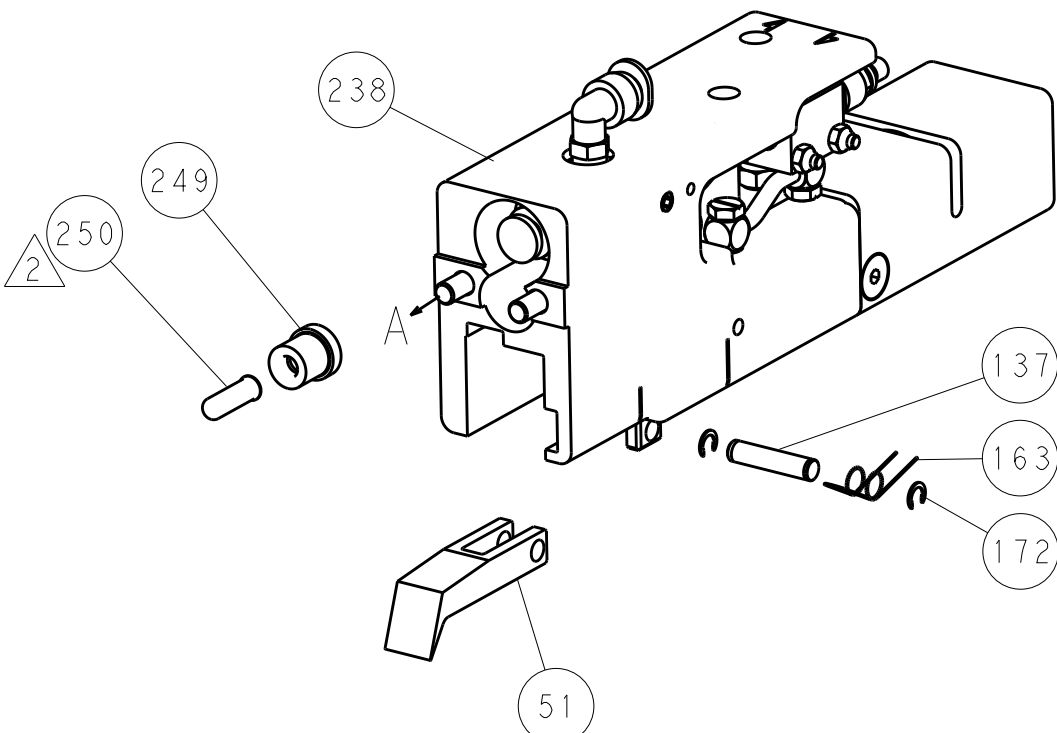
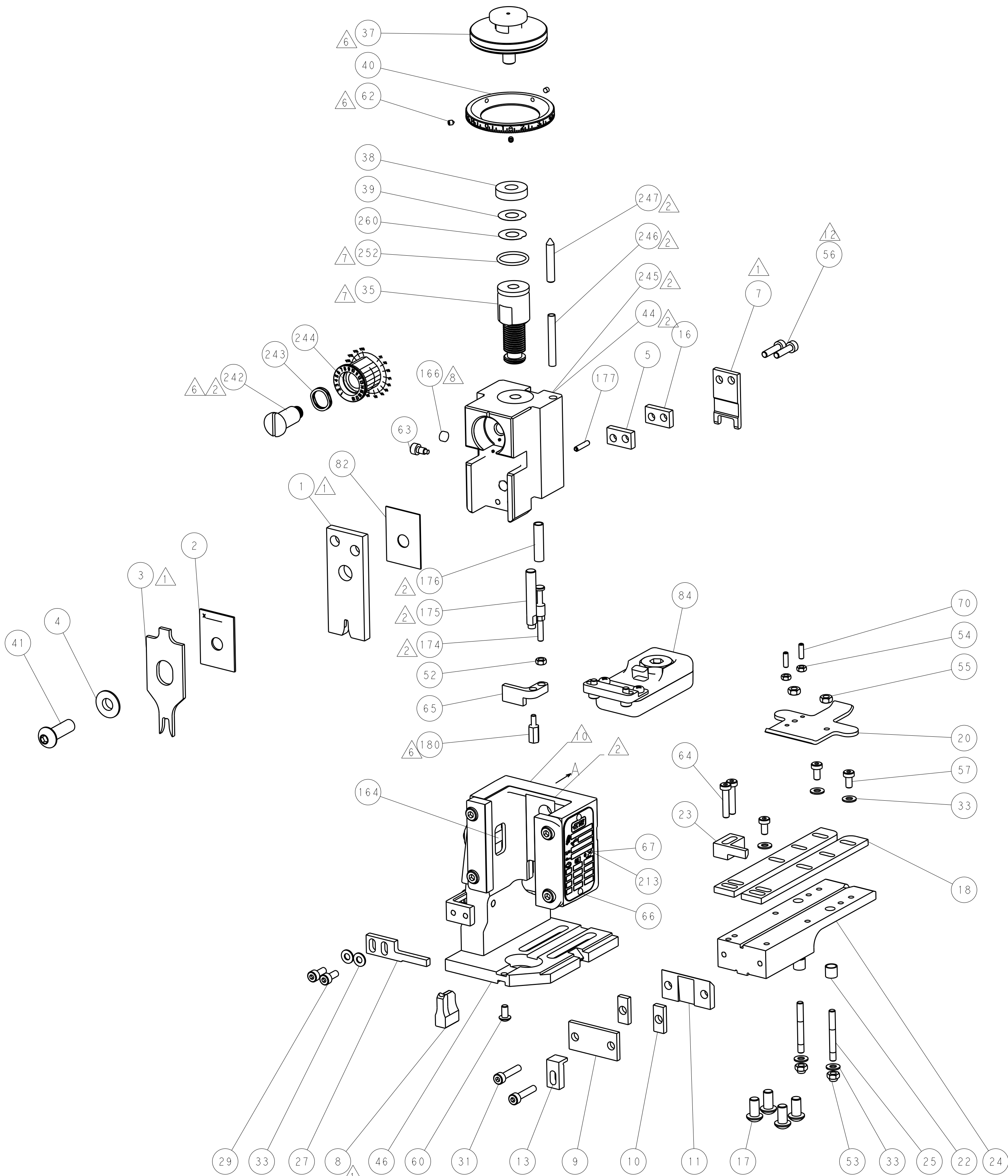
FEED TYPE

PNEUMATIC

SERVO LATCH PLATE

HOLDDOWN SET-UP

CAM POSITION



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

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. 2. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. 3. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION.										DWN		X. ZHAO	14JAN2014	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm															

[illegible]

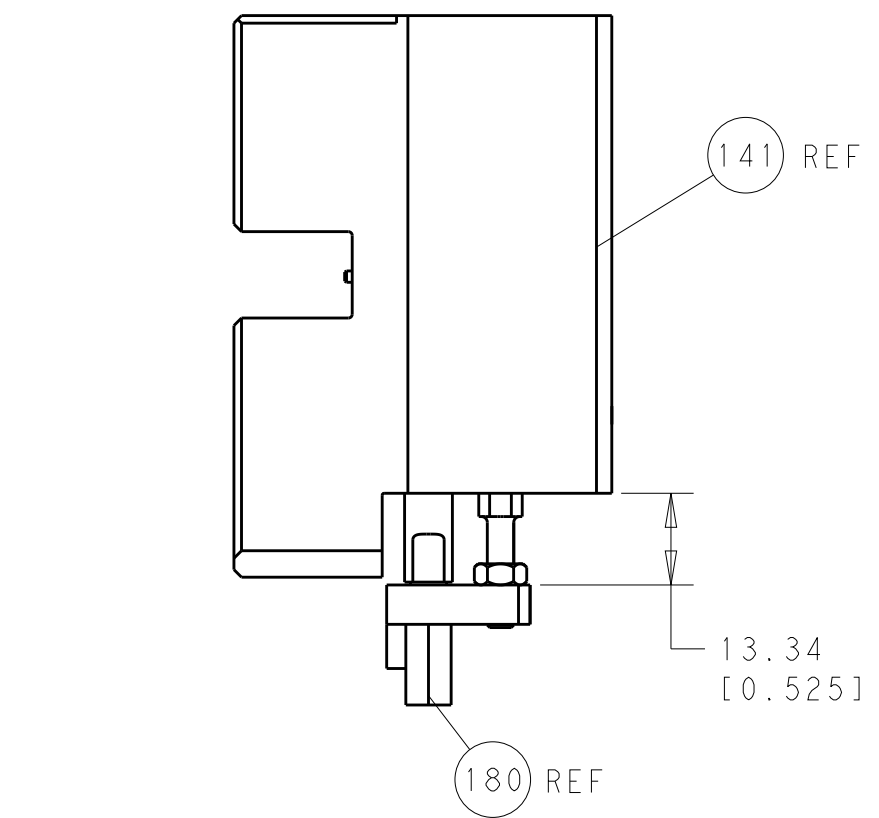
6	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	1	2119082-7	CAM SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	1	2063440-2	AIR FEED MODULE	238	
-	-	-	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	
6	-	1	1	1	2-1752354-7	STANDOFF, HOLD-DOWN	180
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-	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	-	2119741-2	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
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-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
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-	1	-	1	-	2119740-1	TAG, IDENTIFICATION	67
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-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
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-	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	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
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-	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	690455-3	STRIPPER, FRONT CASTING	27
-	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	2-1752371-0	PLATE, STRIP GUIDE	24
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-	2	2	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4	DRAG	20
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-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	1	1	3-1803001-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	9-240651-2	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-4	SPACER	5
-	1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	2-1803016-9	CRIMPER, INSULATION F	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1	1	409414-3	CRIMPER, WIRE	1
-77-27-25-22	PART NO				DESCRIPTION		ITEM NO

THIS IS A CONTROLLED DOCUMENT FOR PRO ELECTRONICS CORPORATION NO CHANGES OR REVISIONS ARE TO BE MADE WITHOUT THE CONTROL AND TESTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN : 14JAN2014 CHG : X_ZHAO 14JAN2014 L_ZHANG 14JAN2014 APVD : T_FILBIN 14JAN2014		 TE Connectivity Morrisburg, PA 17105-3608	
DIMENSIONS: (mm)		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±- 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.1° FINISH -		NAME Ocean End Feed Applicator -	
		PRODUCT SPEC APPLICATION SPEC		SIZE CAGE CODE DRAWING NO A1 00779 C-2150408	
RESTRICTED TO -		SCALE 1:1 SHEET 3 OF 4 REV A		Customer Accessible Production Drawing	

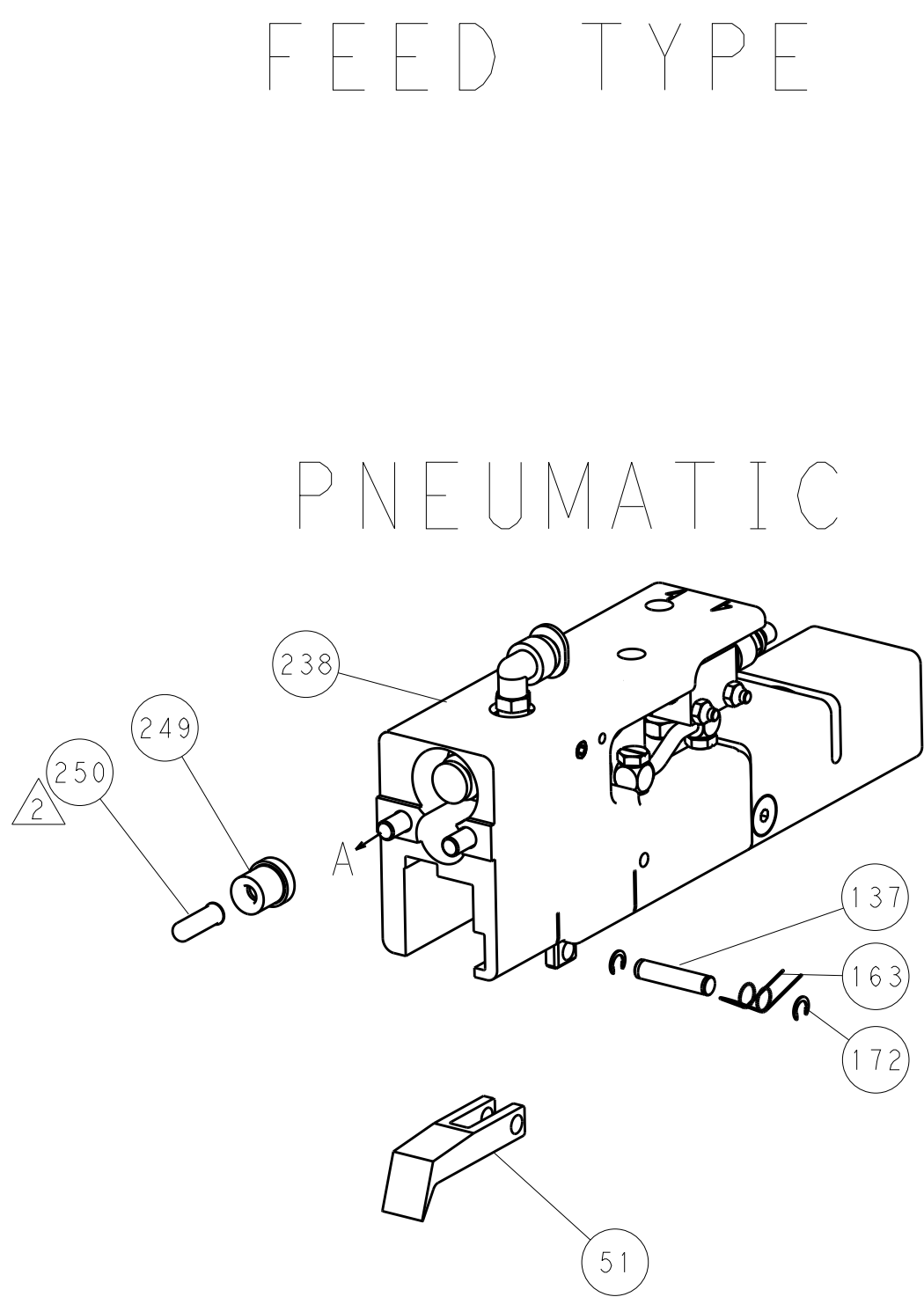
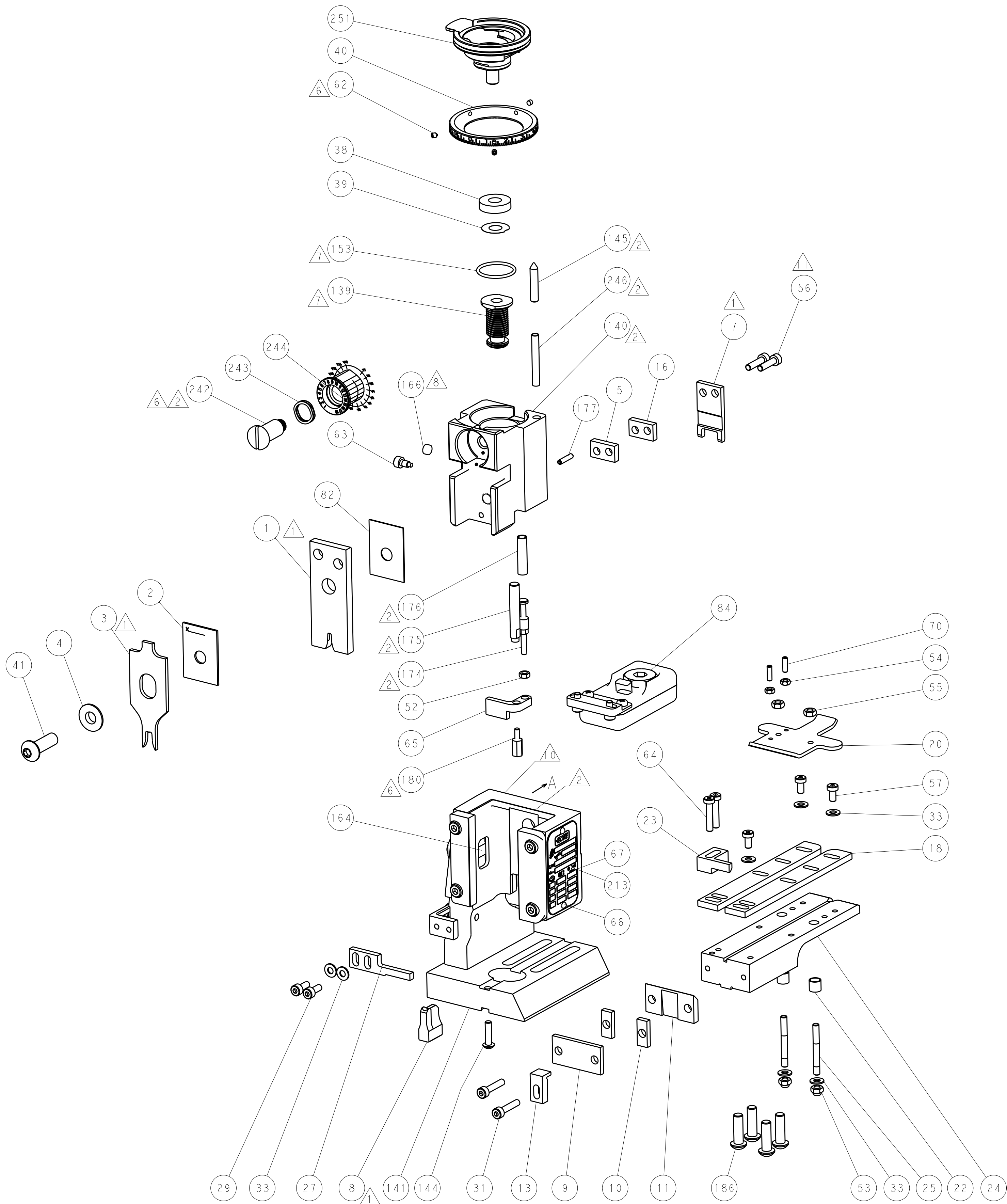
```
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO
LARGEST WIRE SIZE SETTING. USE OF SETTINGS
BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING
WILL CAUSE DAMAGE TO CRIMP TOOLING.
```



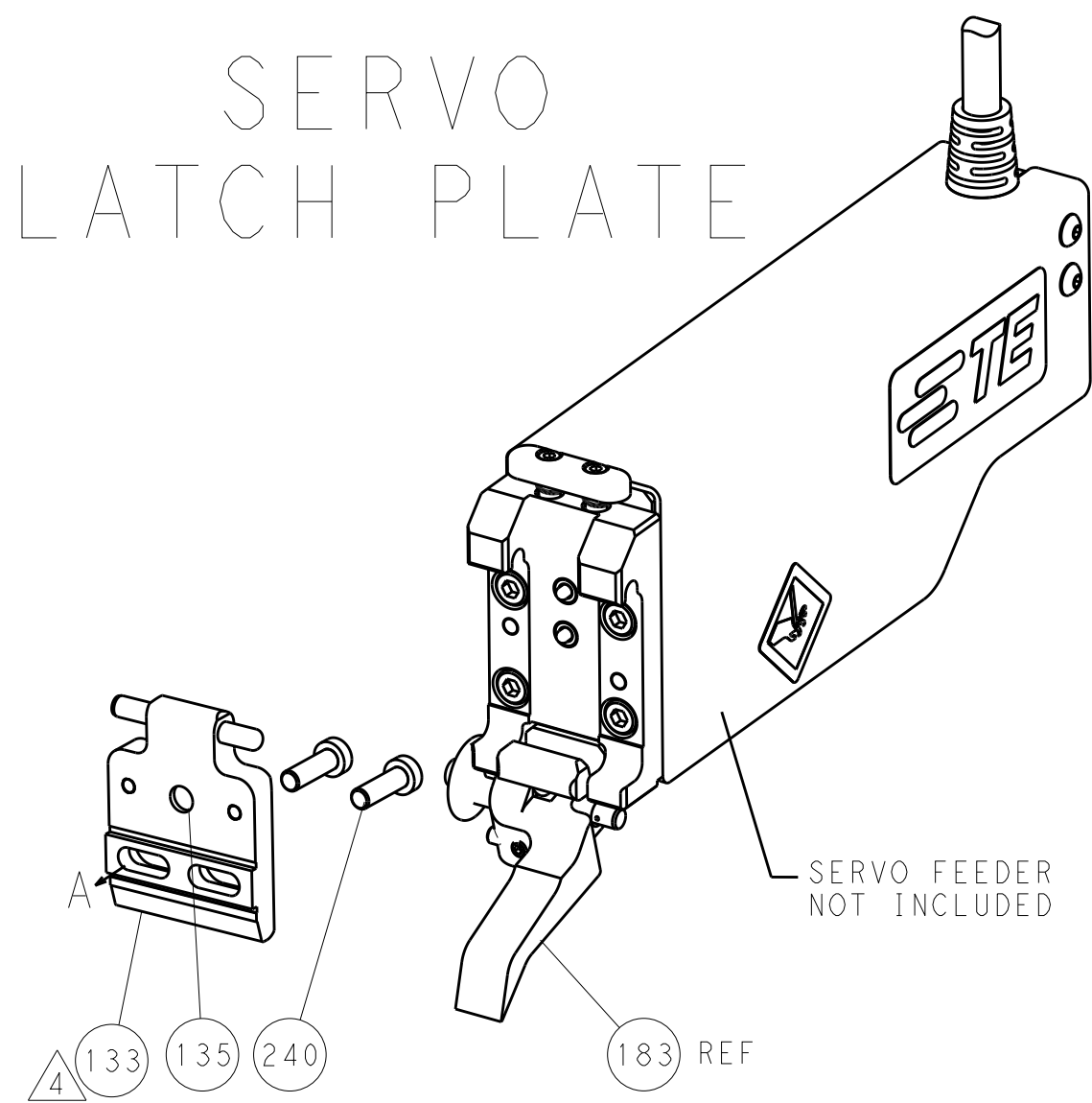
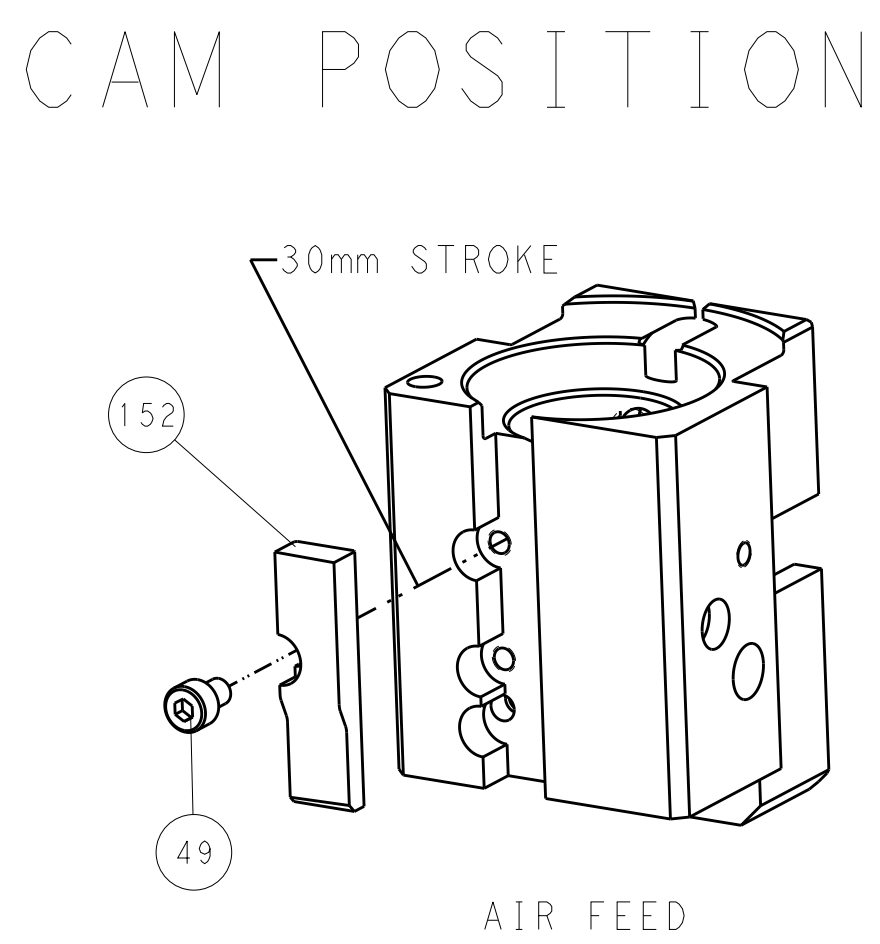
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



HOLDDOWN SET-UP



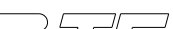
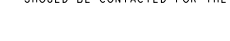
PNEUMATIC

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)

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DIMENSIONS: mm 		TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±°		NAME Ocean End Feed Applicator PRODUCT SPEC - APPLICATION SPEC -	
MATERIAL - FINISH -		WEIGHT -		SIZE A 00779 C=2150408 CAGE CODE - DRAWING NO - RESTRICTED TO -	
Customer Accessible Product Drawing				SCALE 1:1 SHEET 4 OF 4 REV A	