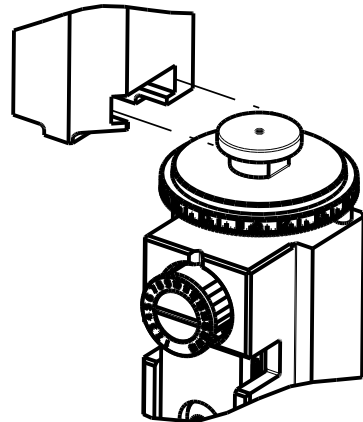


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20		20	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150396-2	A	FINE CRIMP HEIGHT ADJUST
	2150396-5	A	FINE CRIMP HEIGHT ADJUST
	2150396-6	A	NON-CRIMP HEIGHT ADJUST
	2150396-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150396-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.06 mm [.160]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: KET TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 312 CONNECTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.24-5.25 mm [.206-.207 IN]		Ø1.80-2.18 mm [.071-.086 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
1949545-1	ST730371-1	1949545-2	ST730371-3

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
2.00mm2		1.93+/-0.05 [.076+/- .002]		3.6
1.50mm2		1.78+/-0.05 [.070+/- .002]		5.0
1.00mm2		1.63+/-0.05 [.064+/- .002]		6.6
0.75mm2		1.56+/-0.05 [.061+/- .002]		7.5
0.50mm2		1.48+/-0.05 [.058+/- .002]		8.2



- 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: 8-2150396-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150396-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150396-6
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.
- 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

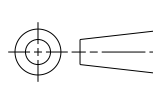
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

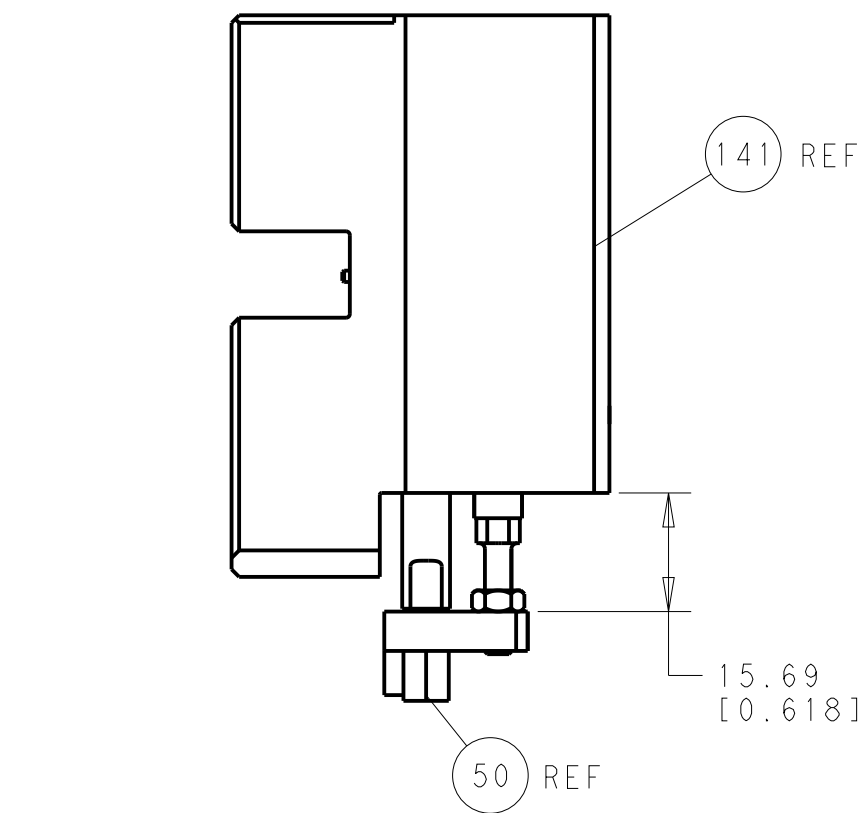
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS				
			P	LTR	DESCRIPTION	DATE	OWN
				A	RELEASED	20DEC2013	LG
				A1	ECR-14-001140	26JAN2014	YY
							UG

6	-	-	-	-	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
	-	-	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
	-	REFREFREFREFREF	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	1901681-1	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	
6	-	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	1-1752354-1	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	1-2119644-2	RAM WASHER, PRECISION	38	
6	-	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	1752371-5	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	1901259-6	GUIDE, LOWER STRIP	18
-	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	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10	
1	-	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9
	1	1	1	1	1	3-1803000-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	-	-	-	6
-	1	1	1	1	1	5-240641-3	SPACER	5
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	3-2119582-4	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	1-455888-4	SPACER, CRIMPER	2
1	1	1	1	1	1	3-456408-1	CRIMPER, WIRE PREMIUM	1
	-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE INFORMATION SHOWN BE CONFIRMED FOR THE LATEST REVISION.		OWN Y. YIN	05NOV2013	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm		CHK G. BAILEY	05NOV2013	NAME Ocean End Feed Applicator			
		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		PRODUCT SPEC			
				APPLICATION SPEC			
		FINISH		WEIGHT			
MATERIAL				Customer Accessible Production Drawing			
				SCALE 1:1			
				SHEET 1 OF 4			
				REV A1			

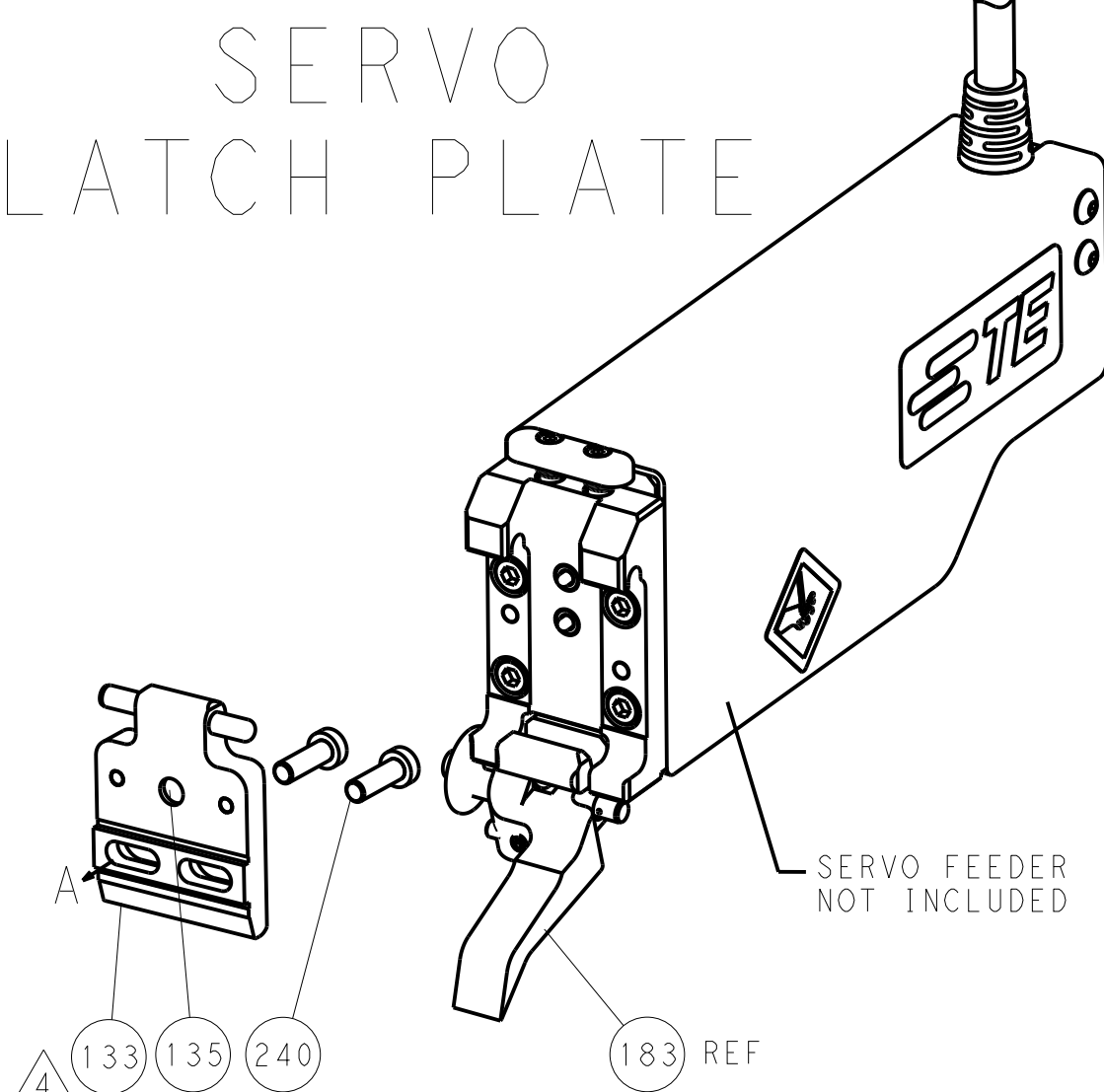
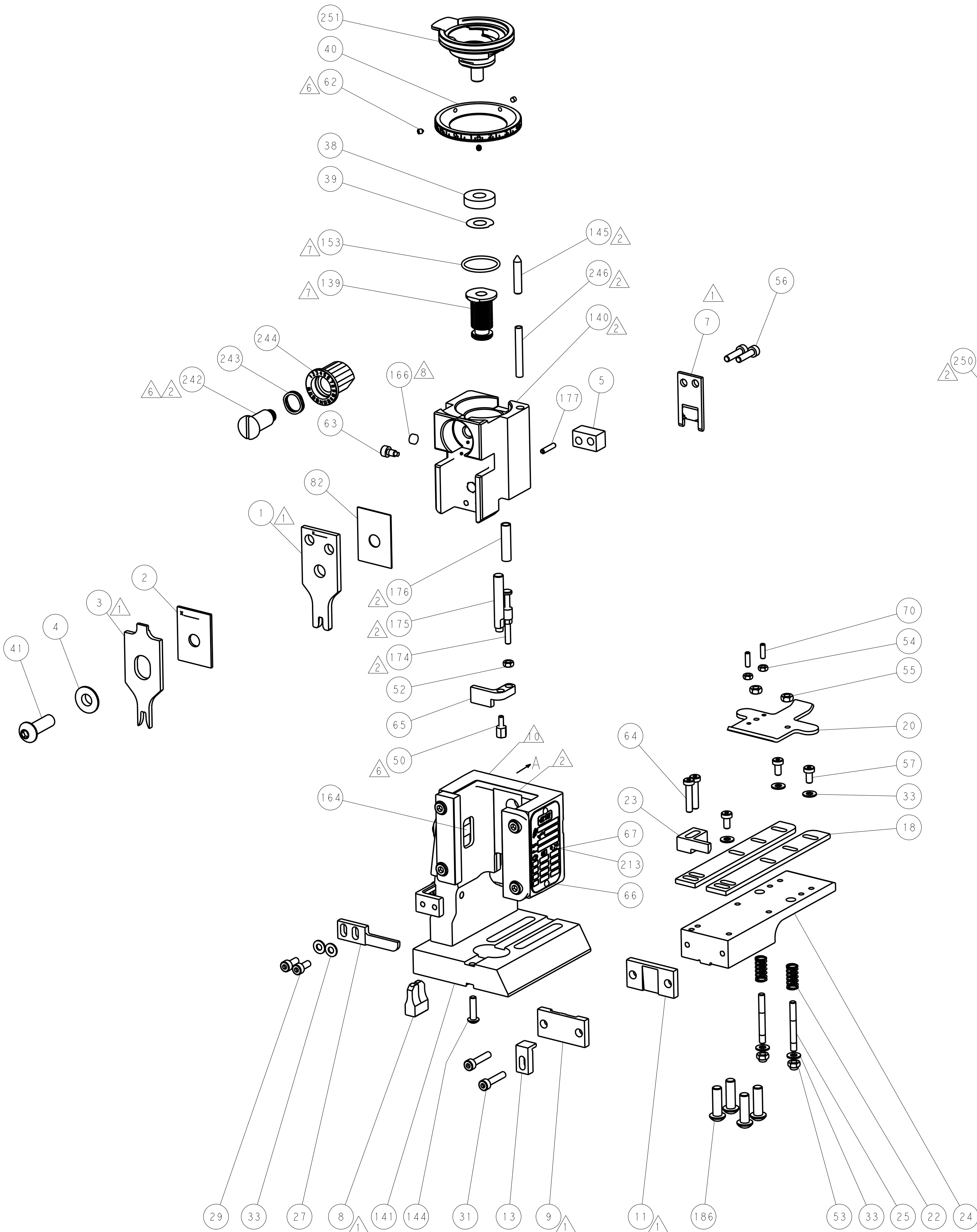
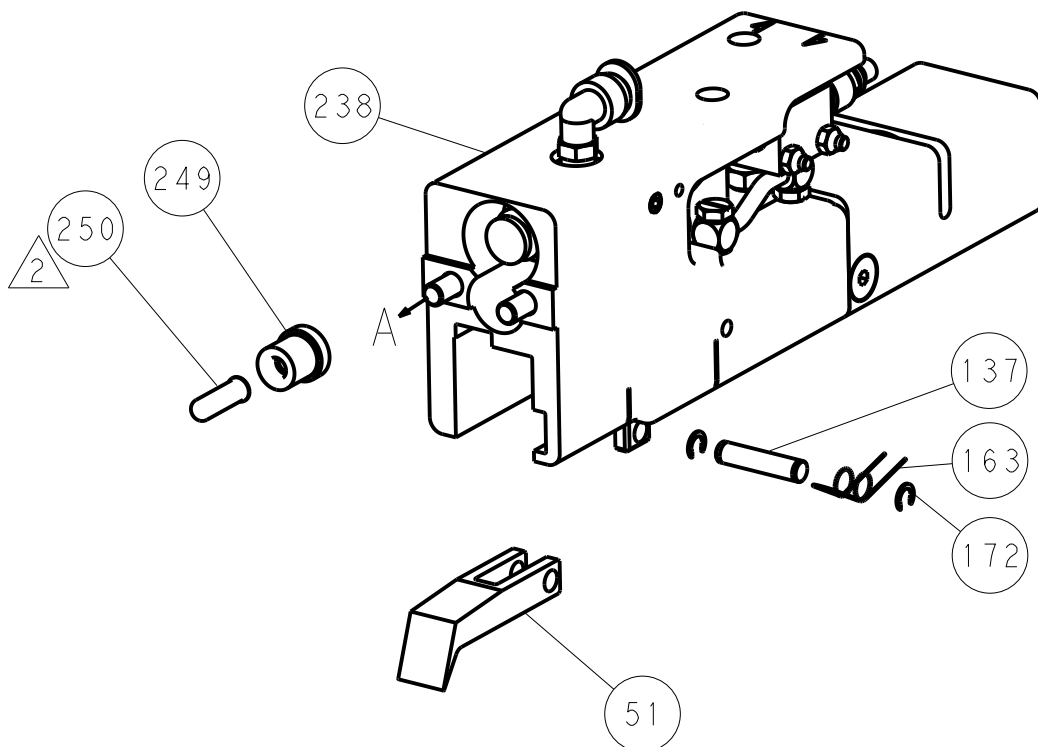
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



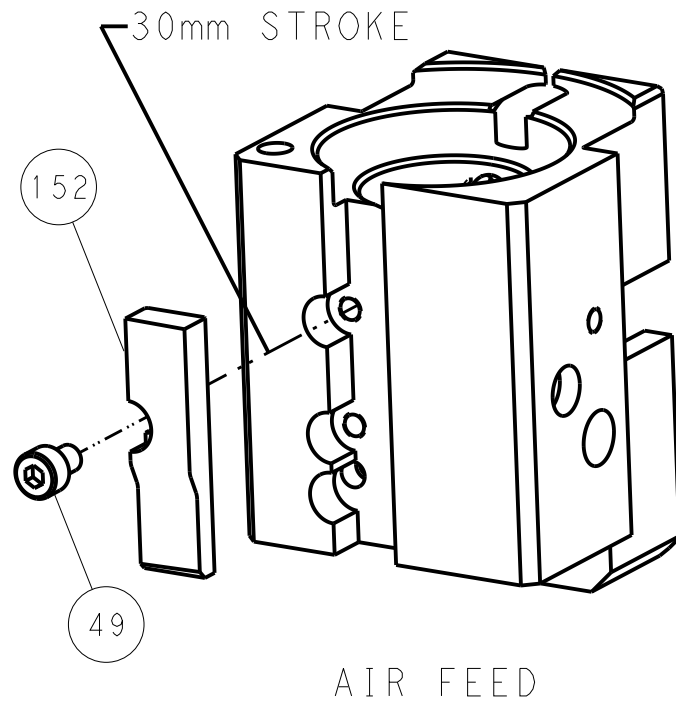
HOLDDOWN SET-UP

FEED TYPE

PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		TE Connectivity	
mm		0 PLC ±0.5		Y. YIN		Harrisburg, PA 17105-3608	
		1 PLC ±0.13		CHK			
		2 PLC ±0.13		G. BAILEY			
		3 PLC ±0.013		APVD			
		4 PLC ±0.0001		H. GUO			
		ANGLES ±0.0001		PRODUCT SPEC			
		FINISH		APPLICATION SPEC			
MATERIAL				WEIGHT			