

8

7

6

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4

3

2

1

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION  
TERMINATOR  
INTERFACE ADAPTER

2150186-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

2150186-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2150186-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE<sup>4</sup>

2150186-6

A

NON-CRIMP HEIGHT ADJUST

4

SERVO LATCH PLATE

12

2150186-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2150186-7

A

CRIMP TOOLING KIT

-

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

2119950-1

2119792-2

-

2119641-1

-

2063440-1

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150186-5

-

-

2168400-7 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2150186-4

-

-

-

MECHANICAL FEED

2119949-1

2063961-1

5-18022-5

2119653-1

-

-

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150186-5

-

-

2168400-7 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2150186-4

-

-

-

MECHANICAL FEED

2119949-1

2063961-1

5-18022-5

2119653-1

-

-

PNEUMATIC FEED

2119950-1

2119792-2

-

2119641-1

-

2063440-1

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-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.29 mm [.090]

F

INSUL

4.57 mm [.180]

F

APPLICATOR INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .187 SERIES POST-LOCK RECEPTACLE

WIRE STRIP LENGTH

3.68-4.45 mm [.145-.175 IN]

INSULATION DIAMETER RANGE

Ø2.29-3.30 mm [.090-.130 IN]

TERMINAL APPLICATION SPECIFICATION

114-2074

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

63195-1

63195-2

63232-1

63313-1

63520-1

1217580-1

1217715-1

WIRE SIZE

CRIMP HEIGHT

mm [INCH]

CRIMP HEIGHT

REFERENCE SETTING

<sup>9</sup>

16 AWG

1.45+/-0.000 [.057+/- .000]

4.2

18 AWG

1.27+/-0.000 [.050+/- .000]

6.1

20 AWG

1.14+/-0.000 [.045+/- .000]

7.7

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: 8-2150186-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150186-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150186-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150186-6

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

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

-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

A

RELEASE

DATE

18FEB2013

DWN

L. Z

APVD

S. X

-

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

-

1

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

-

-

REFREF

-

-

-

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

-

REFREF

REFREF

REFREF

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

1

455888-4

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

66

-

1

1

1

1

1

1901681-9

HOLDDOWN, TERMINAL

65

-

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

-

4

4

4

4

4

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

2

2

2

2

2168083-3

SCR, SKT HD CAP, RoHS, M4 X 12.0

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

1752354-8

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

2119644-1

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

-

8

8

8

8

8

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

2-1752371-1

PLATE, STRIP GUIDE

24

-

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

1901259-4

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

240833-7

PLATE, REAR SHEAR

11

-

-

-

-

-

-

-

-

10

-

1

1

1

1

1

690482-5

PLATE, FRONT SHEAR

9

-

1

1

1

1

1

3-1333217-6

ANVIL, EF .090

8

-

1

1

1

1

1

2217206-7

BLADE, SLUG

7

-

1

1

1

1

1

6-240641-8

SPACER

5

-

1

1

1

1

1

238009-4

BLOCK, FL CRIMPER SPACER

4

-

1

1

1

1

1

4-2119582-1

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

1

455888-5

SPACER, CRIMPER

2

-

1

1

1

1

1

2-456406-3

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.29 mm [.090]

F

INSUL

4.57 mm [.180]

F

APPLICATOR INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .187 SERIES POST-LOCK RECEPTACLE

WIRE STRIP LENGTH

3.68-4.45 mm [.145-.175 IN]

INSULATION DIAMETER RANGE

Ø2.29-3.30 mm [.090-.130 IN]

TERMINAL APPLICATION SPECIFICATION

114-2074

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

63195-1

63195-2

63232-1

63313-1

63520-1

1217580-1

1217715-1

WIRE SIZE

CRIMP HEIGHT

mm [INCH]

CRIMP HEIGHT

REFERENCE SETTING

<sup>9</sup>

16 AWG

1.45+/-0.000 [.057+/- .000]

4.2

18 AWG

1.27+/-0.000 [.050+/- .000]

6.1

20 AWG

1.14+/-0.000 [.045+/- .000]

7.7

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: 8-2150186-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150186-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150186-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150186-6

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

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.

-

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1

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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

-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

A

RELEASE

DATE

18FEB2013

DWN

L. Z

APVD

S. X

-

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

-

1

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

-

-

REFREF

-

-

-

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, RET

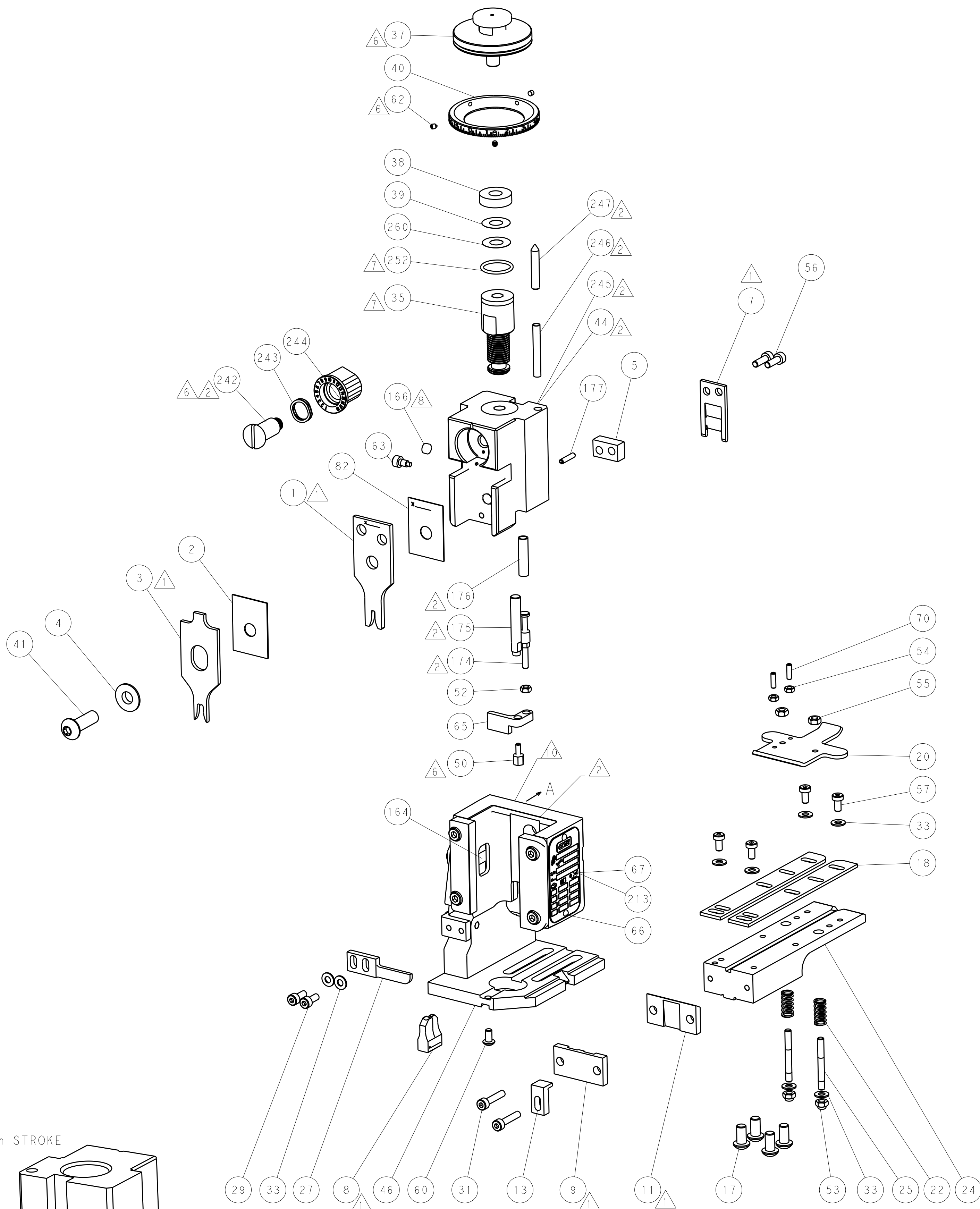
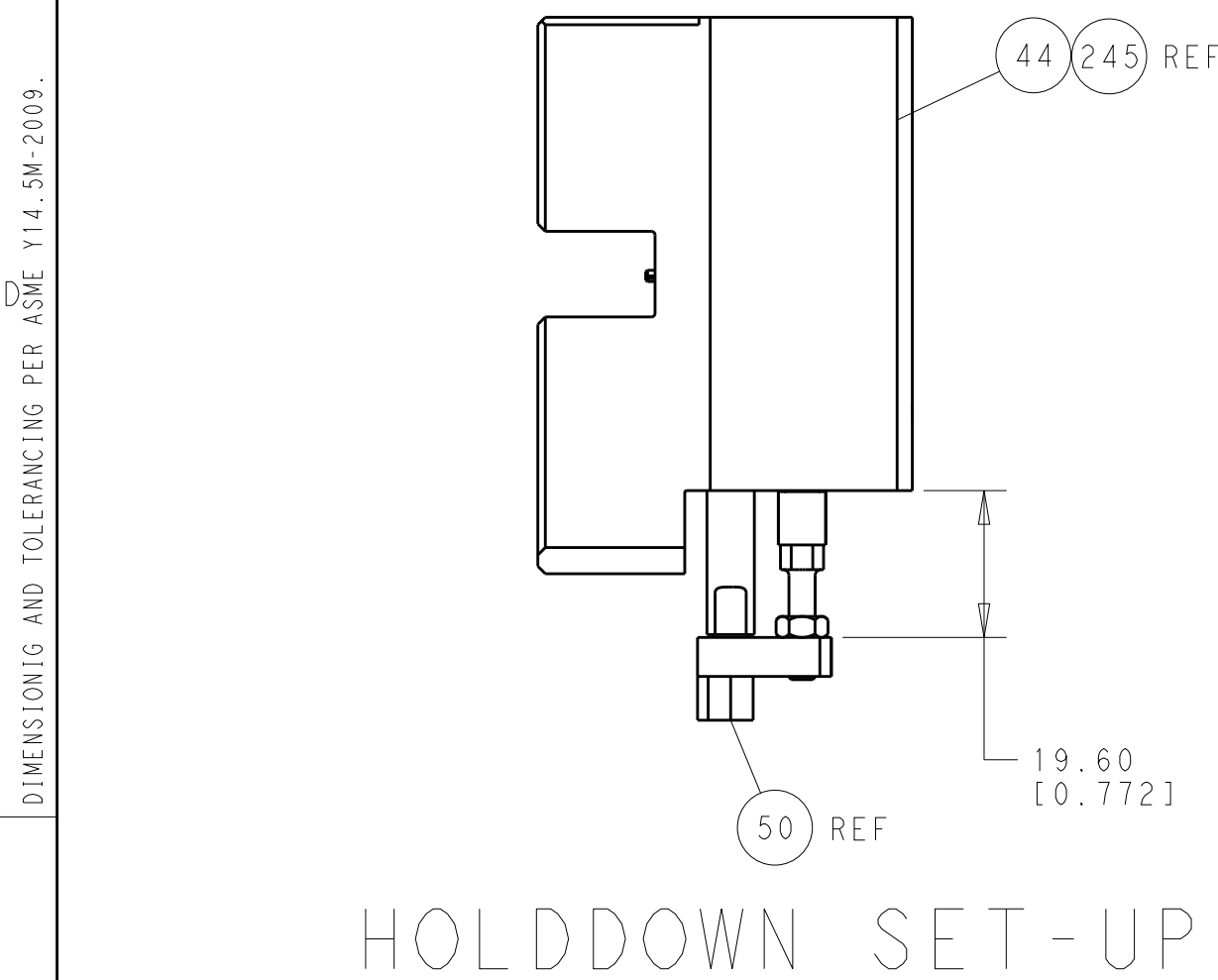
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    | -   | SEE SHEET 1 | -    | -   | -    |
|     |    |      |     |             |      |     |      |
|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

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009.

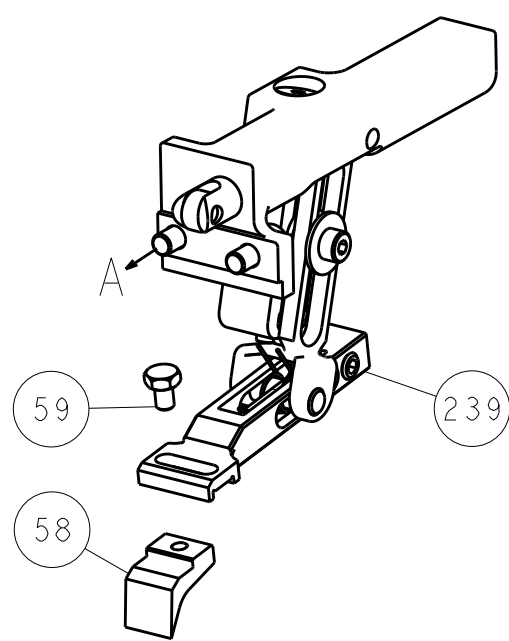
C

B

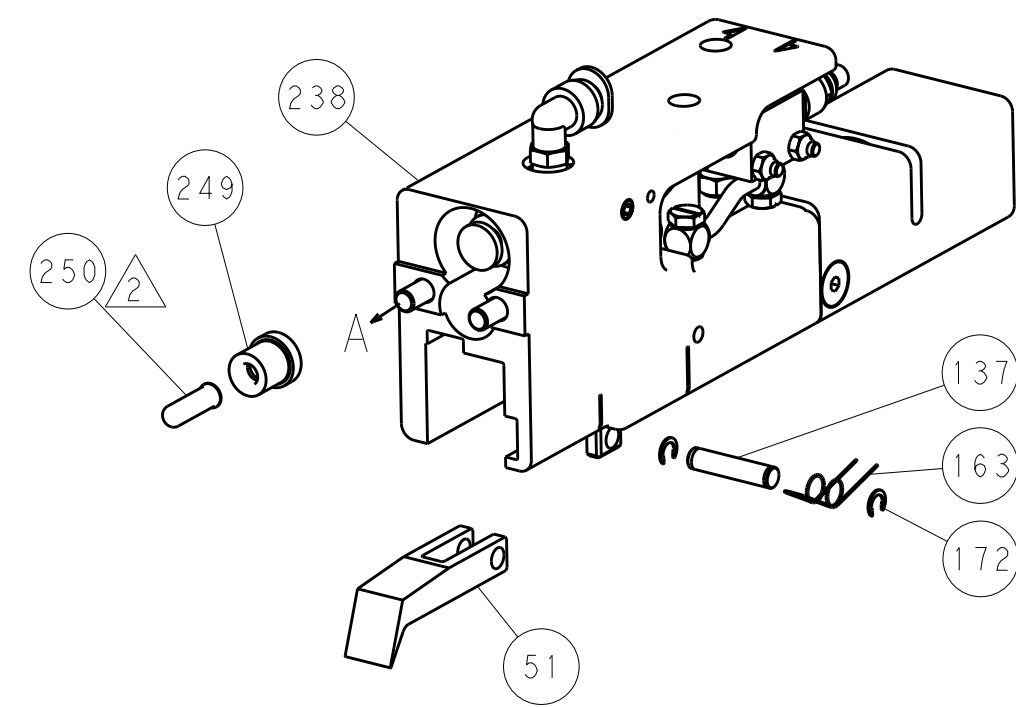
A



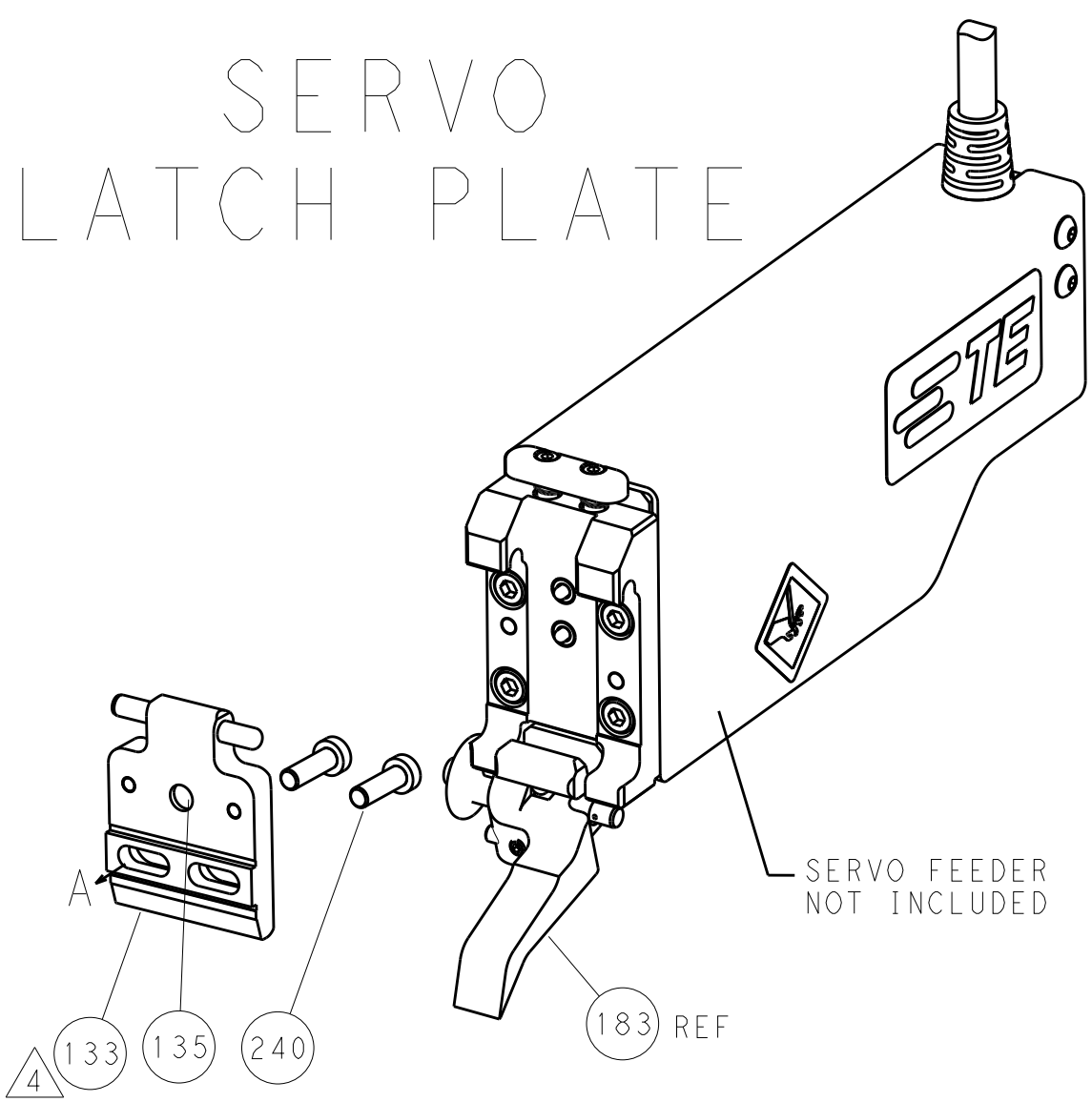
FEED TYPE  
MECHANICAL



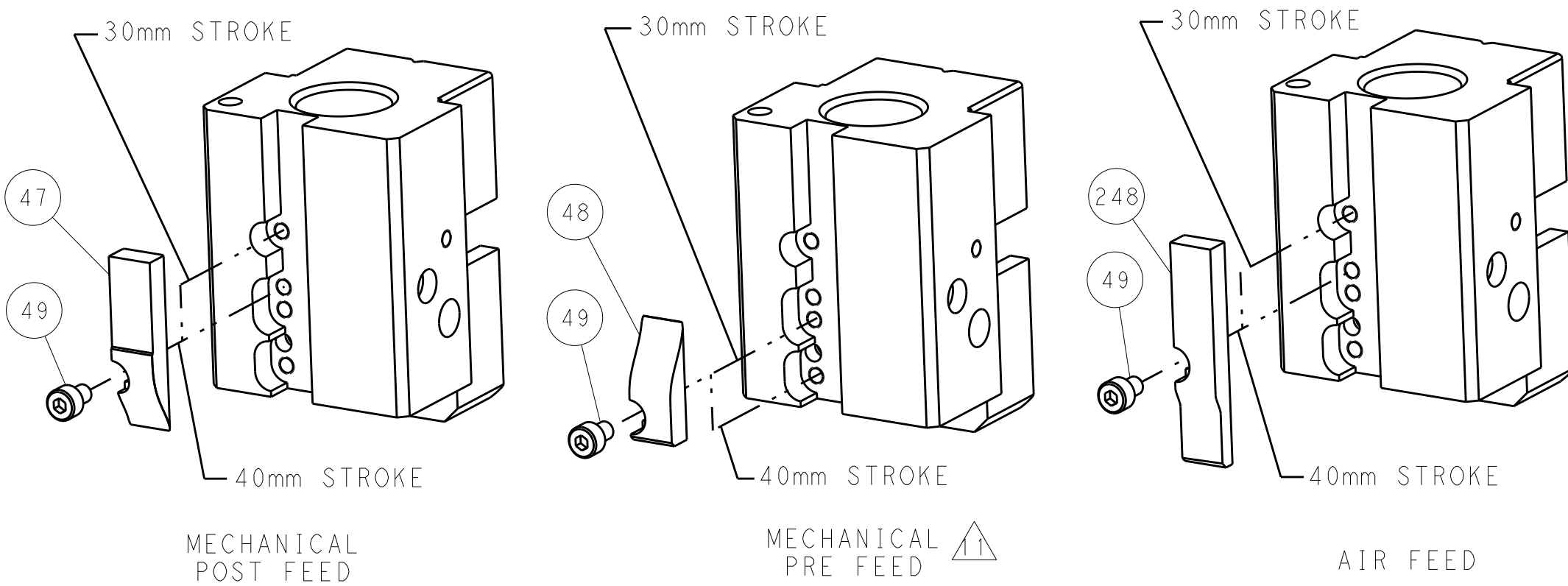
PNEUMATIC



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                             |  | L. ZHANG                               |  | Harrisburg, PA 17105-3608 |  |
|             |  | 1 PLC ±0.13                            |  | L. ZHANG                               |  |                           |  |
|             |  | 2 PLC ±0.13                            |  | S. XI                                  |  |                           |  |
|             |  | 3 PLC ±0.013                           |  | APVD                                   |  |                           |  |
|             |  | 4 PLC ±0.0001                          |  | 17SEP2012                              |  |                           |  |
| MATERIAL    |  | FINISH                                 |  | PRODUCT SPEC                           |  | NAME                      |  |
|             |  |                                        |  | APPLICATION SPEC                       |  | Ocean End Feed Applicator |  |
|             |  |                                        |  | WEIGHT                                 |  | SIZE                      |  |
|             |  |                                        |  |                                        |  | 00779                     |  |
|             |  |                                        |  | CUSTOMER ACCESSIBLE PRODUCTION DRAWING |  | SCALE                     |  |
|             |  |                                        |  |                                        |  | 1:1                       |  |
|             |  |                                        |  |                                        |  | SHEET 2 OF 4              |  |
|             |  |                                        |  |                                        |  | REV A                     |  |



DIMENSIONS AND TOLERANCING PER ASME Y14.5M-2009.

C

B

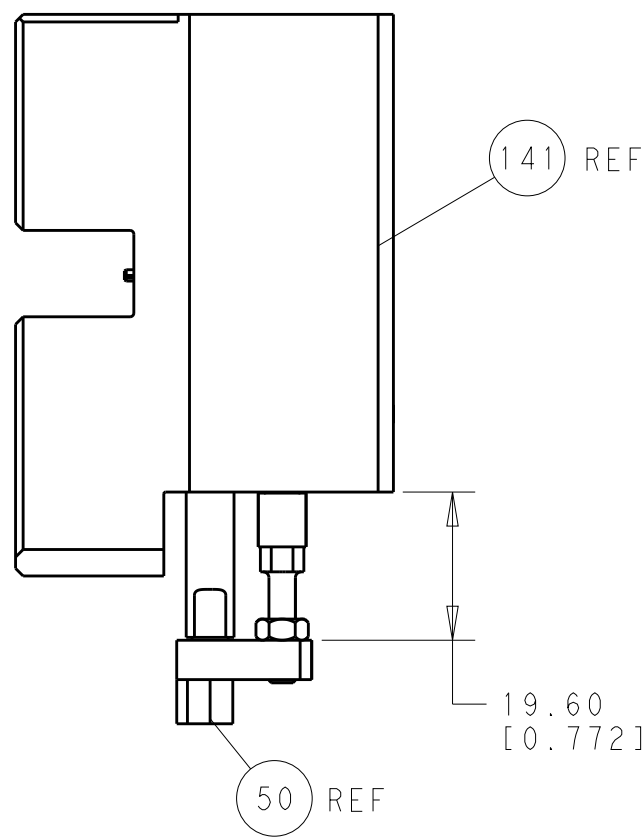
A

AMP 4805 REV 31MAR2000

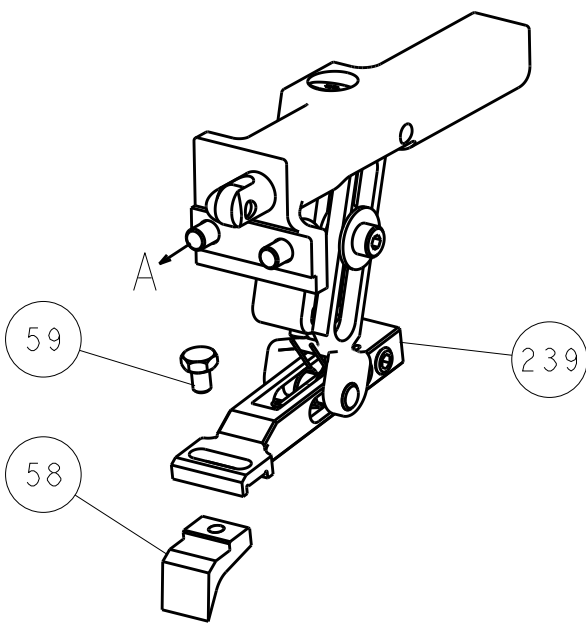
|                              |   |                                                       |   |    |   |   |   |
|------------------------------|---|-------------------------------------------------------|---|----|---|---|---|
| 8                            | 7 | 6                                                     | 5 | 4  | 3 | 2 | 1 |
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| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    | -   | SEE SHEET 1 | -    | -   | -    |
|     |    |      |     |             |      |     |      |
|     |    |      |     |             |      |     |      |

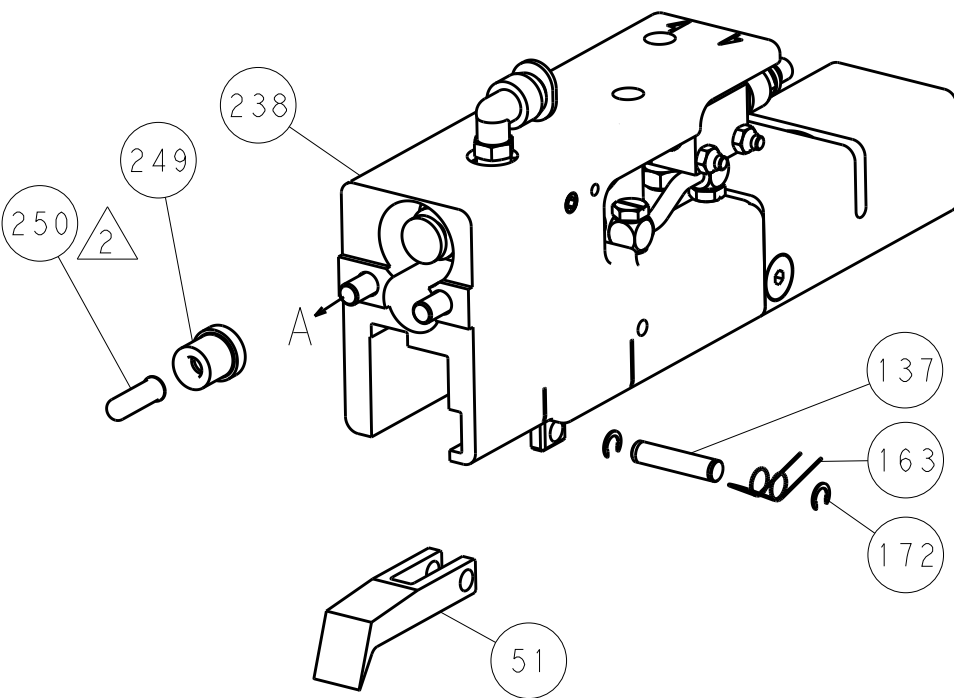
## HOLDDOWN SET-UP



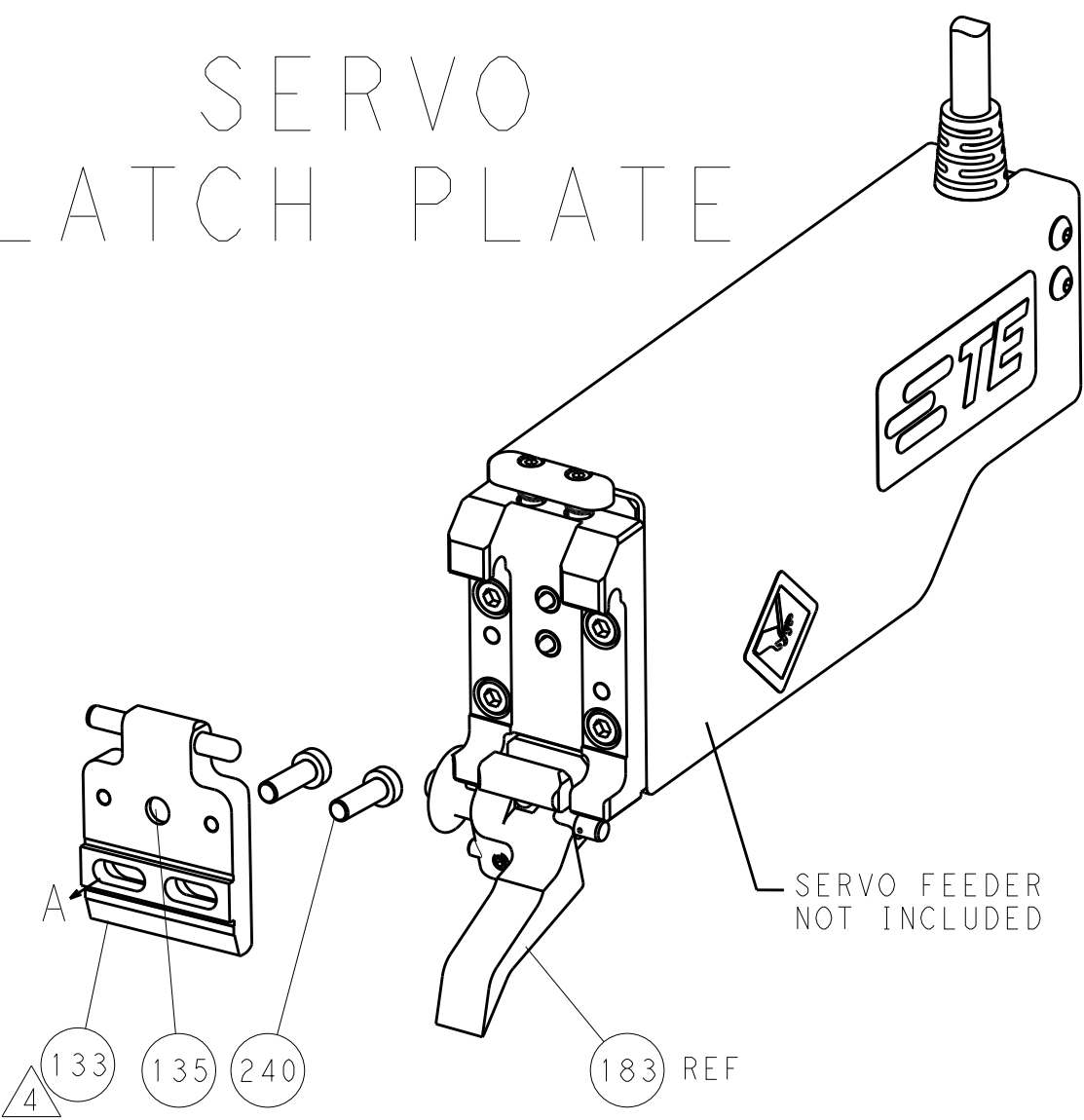
## FEED TYPE MECHANICAL



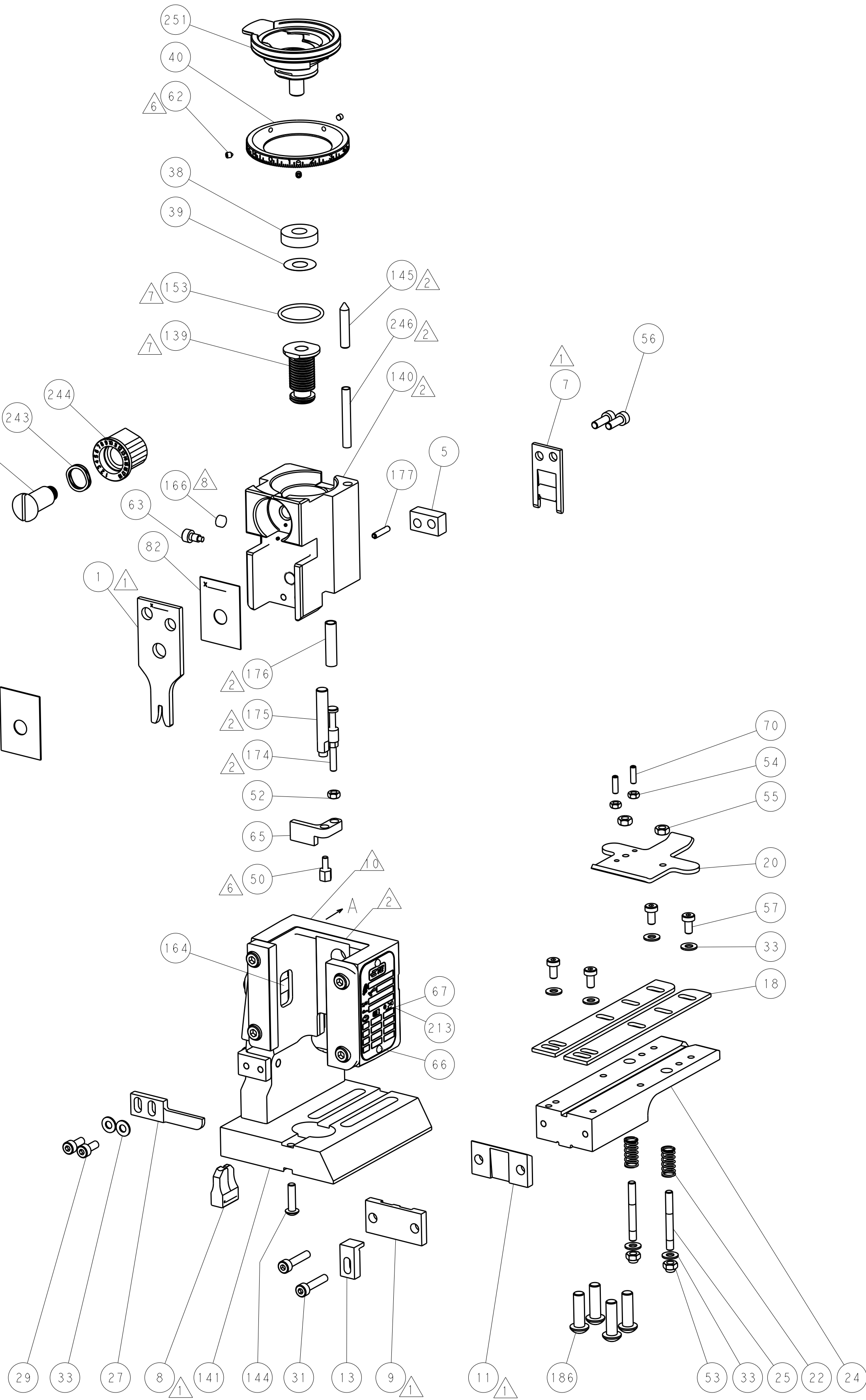
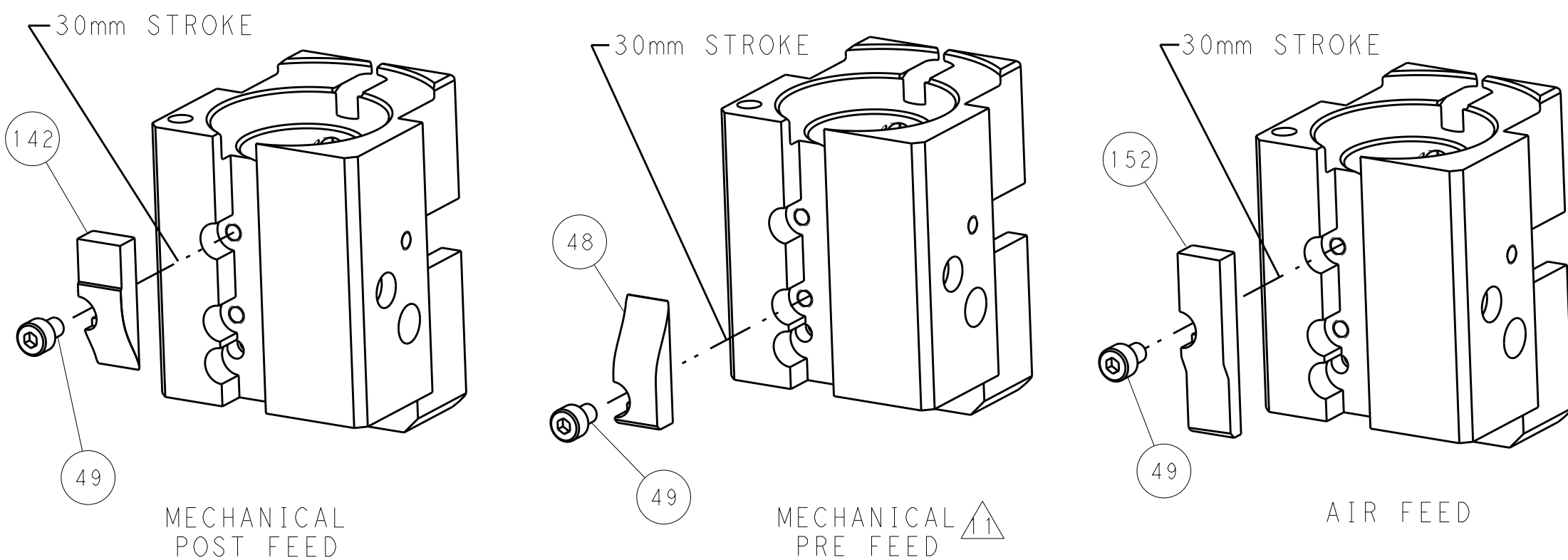
## PNEUMATIC



## SERVO LATCH PLATE



## CAM POSITIONS



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  | L. ZHANG | 17SEP2012 | NAME                                          |  |  |
|                                                                                                                               |  | APVD | S. XI    | 17SEP2012 | PRODUCT SPEC                                  |  |  |
|                                                                                                                               |  |      |          |           | APPLICATION SPEC                              |  |  |
|                                                                                                                               |  |      |          |           | WEIGHT                                        |  |  |
|                                                                                                                               |  |      |          |           | CUSTOMER ACCESSIBLE PRODUCTION DRAWING        |  |  |
|                                                                                                                               |  |      |          |           | SCALE 1:1 SHEET 4 OF 4 REV A                  |  |  |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION