

8

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1

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

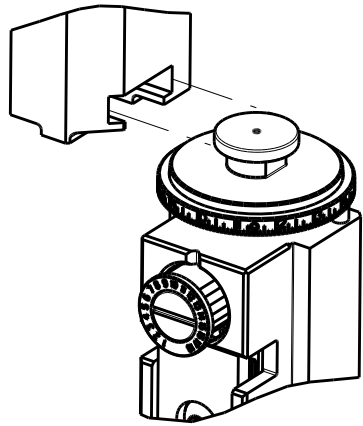
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150502-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

2119792-1

1901697-1

-

-

-

8-2150502-5

2119641-1

-

-

2063440-1

2168400-7 (QUANTITY 2)

-

2150502-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

2063961-1

1901697-1

8-2150502-5

2119653-1

-

-

-

-

2168400-7 (QUANTITY 2)

2150502-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

2119792-1

5-18022-5

-

-

2119653-1

-

-

-

-

2063440-1

2150502-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

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-

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-

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-

2150502-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

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-

7-2150502-7

A

CRIMP TOOLING KIT

-

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-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.79 mm [.110]

F

INSUL

5.33 mm [.210]

F

APPL INSTRUCTIONS

408-10390



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: FASTON RECEPTACLE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

6.10-6.70 mm [.240-.264 IN]

Ø3.81-5.33 mm [.150-.210 IN]

TERMINAL APPLICATION SPECIFICATION

114-2036

-

-

TERMINALS APPLIED

TE TERMINAL

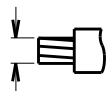
TE TERMINAL

TE TERMINAL

TE TERMINAL

42692-2

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



14 AWG

1.85+/-0.05 [.073+/- .002]

4.8

16 AWG

1.65+/-0.05 [.065+/- .002]

7.0

18 AWG

1.50+/-0.05 [.059+/- .002]

8.5



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: 8-2150502-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150502-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150502-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150502-6

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.
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 ITEMS 37 & 180.

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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2119957-2

APPLICATOR SHIM PACK

260

-

1

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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

REVISIONS

P

LTR

DESCRIPTION

DATE

DWN

APVD

1

DEVELOPMENT

23OCT2014

JH

UG

A

RELEASED

17DEC2014

JH

TE

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1

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1

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1

2119082-2

CAM, SNAIL, INSULATION ADJUSTMENT

244

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1

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

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1

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

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2

2

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2168400-7

SHCS, LOW HEAD, RoHS, M5 X 10

240

-

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

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-

-

-

-

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

1-1752354-0

STANDOFF,HOLD-DOWN

180

-

1

1

1

1

1

6-9931111-6

PIN, SLOTTED SPRING 3.0 X 14.0

177

-

1

1

1

1

1

8-22280-7

SPRING, COMPRESSION

176

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1

1

1

1

1

1752353-2

GUIDE PIN,HOLDDOWN

175

-

1

1

1

1

1

1901680-2

GUIDE PIN,HOLDDOWN

174

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-

-

-

2

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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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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1

240638-1

SPRING, FEED FINGER

163

-

-

-

-

-

1

3-23627-7

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

137

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-

REF

REF

-

-

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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-

1

1

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1633743-1

SERVO FEED LATCH ASM

133

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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

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1

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-

1

1

2119740-1

TAG,IDENTIFICATION

67

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2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

1

1

1

1

1901681-5

HOLDDOWN, TERMINAL

65

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2

2

2

2

2

2168400-5

SHCS, LOW HEAD, RoHS, M4 X 20

64

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1

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1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

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3

-

3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

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1

1

1

1

1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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-

-

-

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1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

-

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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

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

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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

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1

1

1

1

1

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

-

-

-

-

1

-

2119792-1

PAWL, EF, AIR

51

-

-

-

-

1

2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

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-

-

-

-

1

2119652-1

FEED CAM, PRE FEED

48

-

-

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-

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1

2119653-1

FEED CAM, POST FEED

47

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1

1

1

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1

2119655-5

APPLICATOR BASIC ASSEMBLY, EF

46

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1

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1

1

1

2119369-1

RAM,AMP STYLE, END FEED

44

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1

1

1

1

1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

-

1

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1

1

1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

-

1

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1

1

1

2119957-1

APPLICATOR SHIM PACK

39

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1

1

1

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1

1-2119644-2

RAM WASHER, PRECISION

38

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1

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

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1

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1

1

1

2119092-1

BOLT, ADJUSTMENT

35

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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

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1

1

1

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1

240639-1

STRIPPER (MACHINING)

27

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2

2

2

2

2

1320906-1

STUD, THREADED

25

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1

1

1

1

1

1752371-5

PLATE, STRIP GUIDE

24

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1

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1

1

1

240825-8

PLATE, STRIP HOLD DOWN

23

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2

2

2

2

2

2-22281-3

SPRING, COMPRESSION

22

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1

1

1

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1

1752373-4

DRAG

20

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2

2

2

2

2

1901259-5

GUIDE, LOWER STRIP

18

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4

4

4

4

4

1-2079383-1

SCR, BHSC, RoHS (M6 X 12)

17

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1

1

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1

1

1752360-1

SPACER,HOLD-DOWN

13

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1

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240644-1

PLATE, REAR SHEAR

11

-

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10

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1

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1

690482-1

PLATE, FRONT SHEAR

9

1

1

1

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1

1

6-1803000-3

ANVIL, COMBINATION, END FEED

8

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2217206-1

BLADE, SLUG

7

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6

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7-240641-1

SPACER

5

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1

238009-7

BLOCK, FL CRIMPER SPACER

4

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9-2119582-7

CRIMPER, INSULATION F PREMIUM

3

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2-459736-8

CRIMPER, WIRE

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

171 IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT RESPONSIBILITY TO THE USER. THE USER SHALL BE CONTACTED FOR THE LATEST REVISION.

DWN J. HOU 23OCT2014

CHK Y. YIN 23OCT2014

APVD U. GUO 23OCT2014

NAME Ocean End Feed Applicator

SIZE A1

CAGE CODE 00779

DRAWING NO. C=2150502

RESTRICTED TO -

Customer Accessible Production Drawing

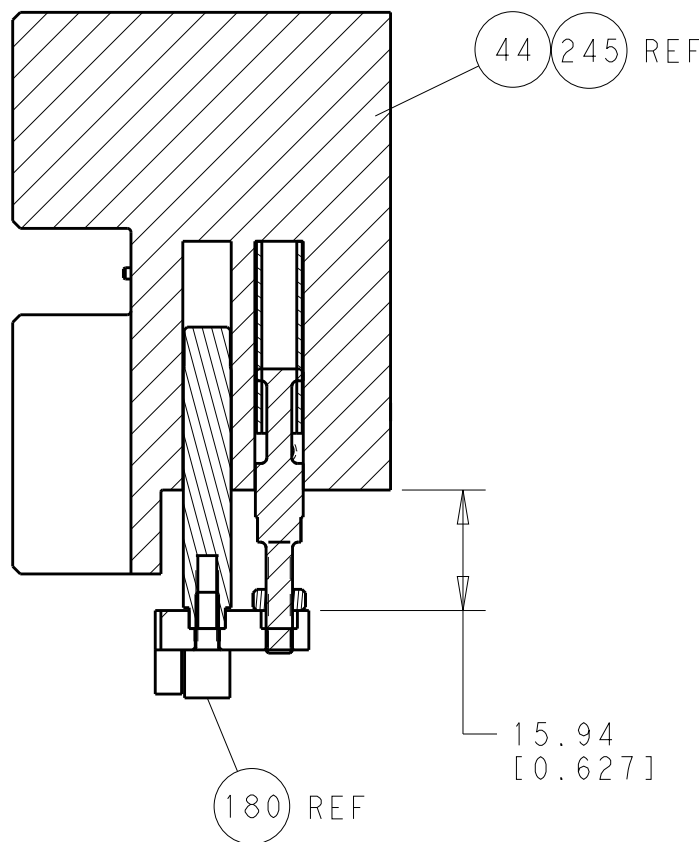
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SHEET 1 OF 4

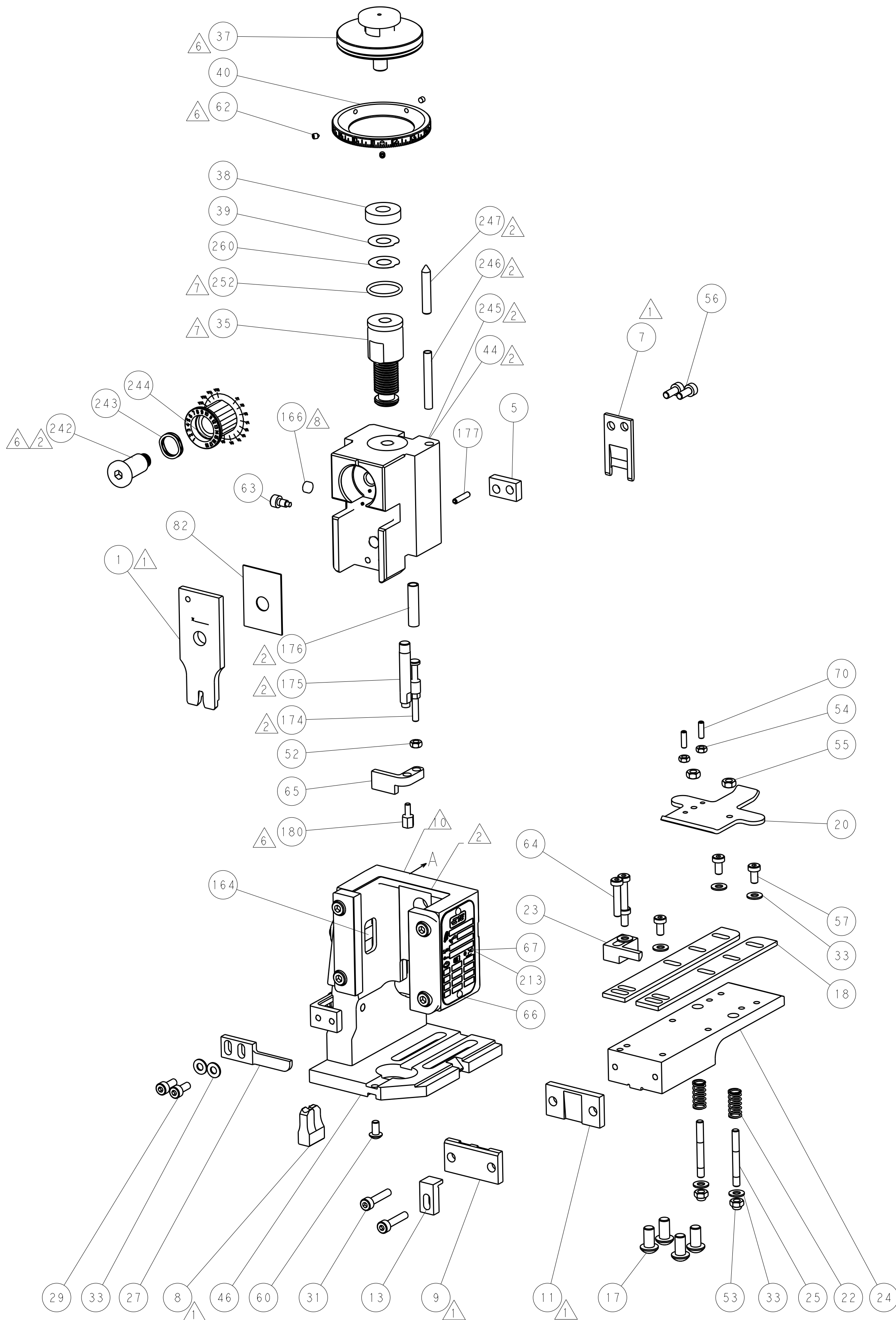
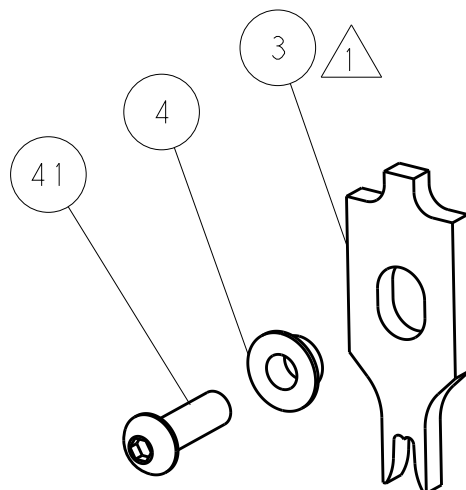
REV A

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

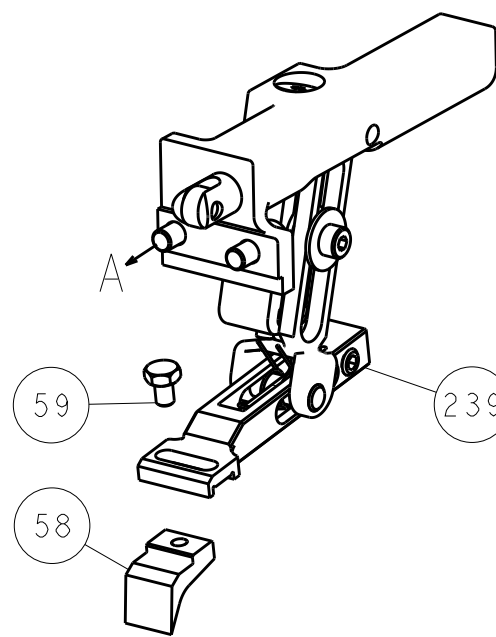
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A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-



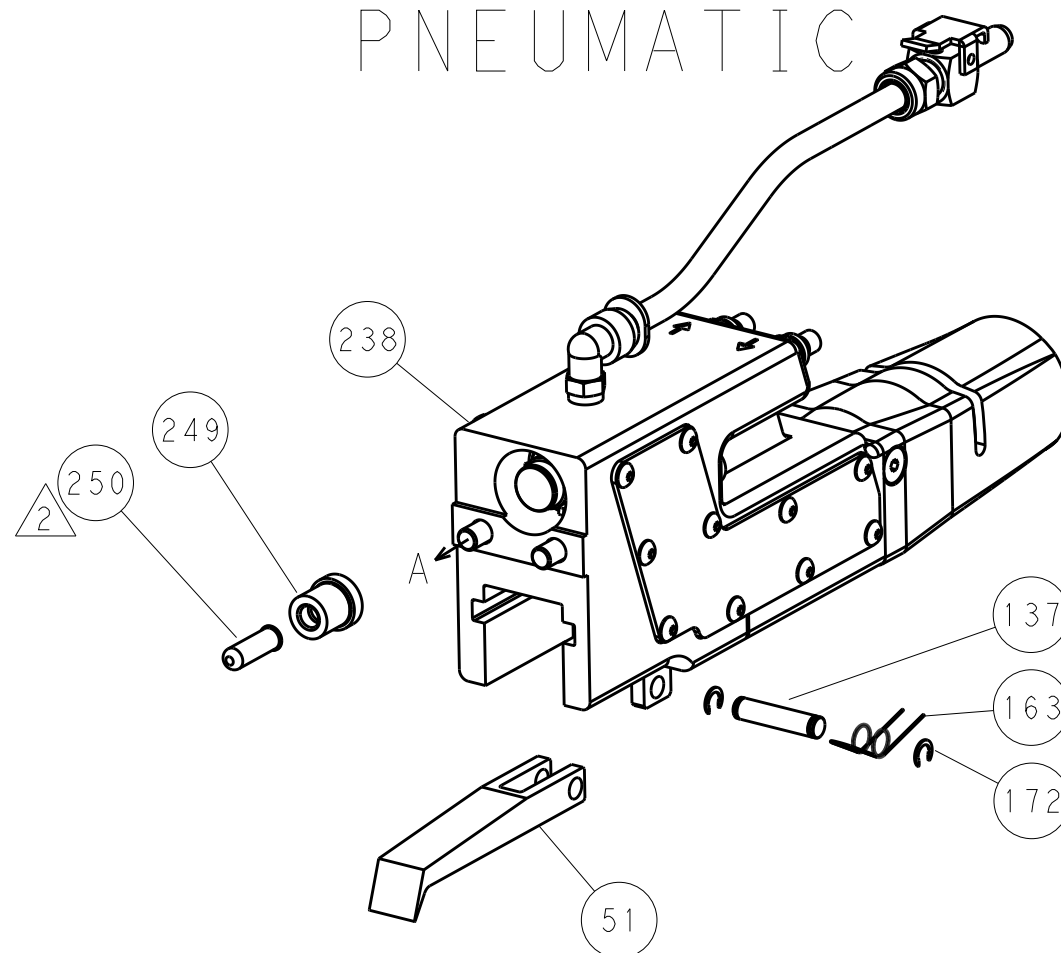
HOLDDOWN SET-UP



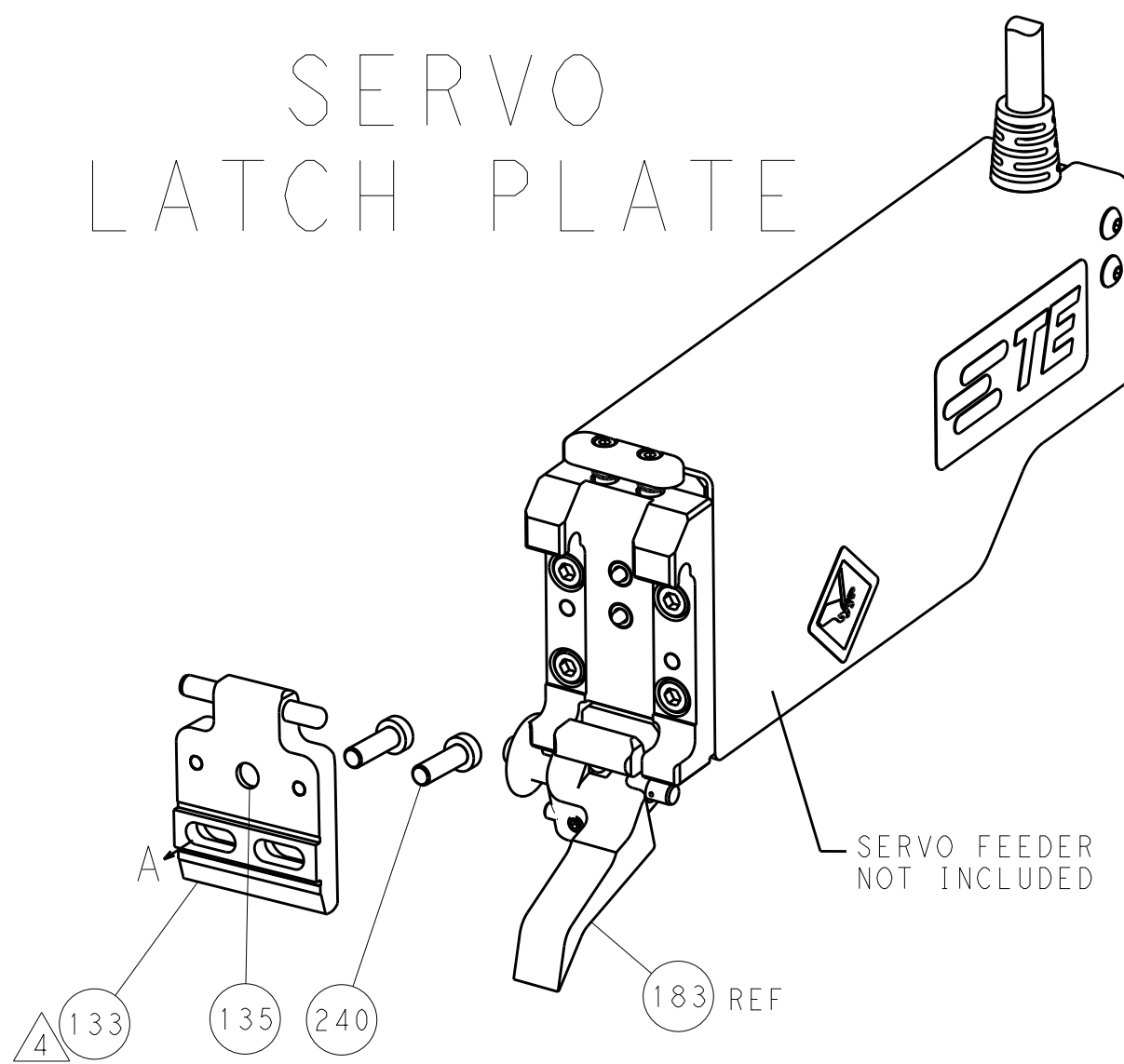
FEED TYPE
MECHANICAL



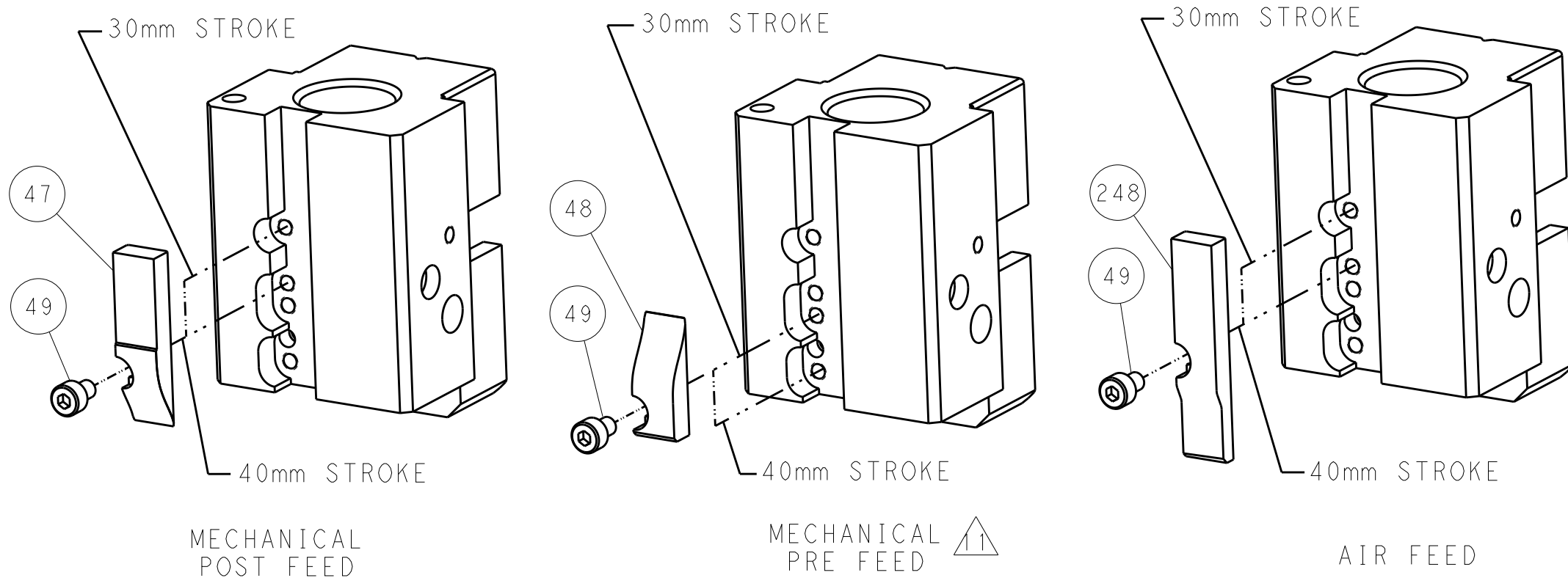
PNEUMATIC



SERVO
LATCH PLATE



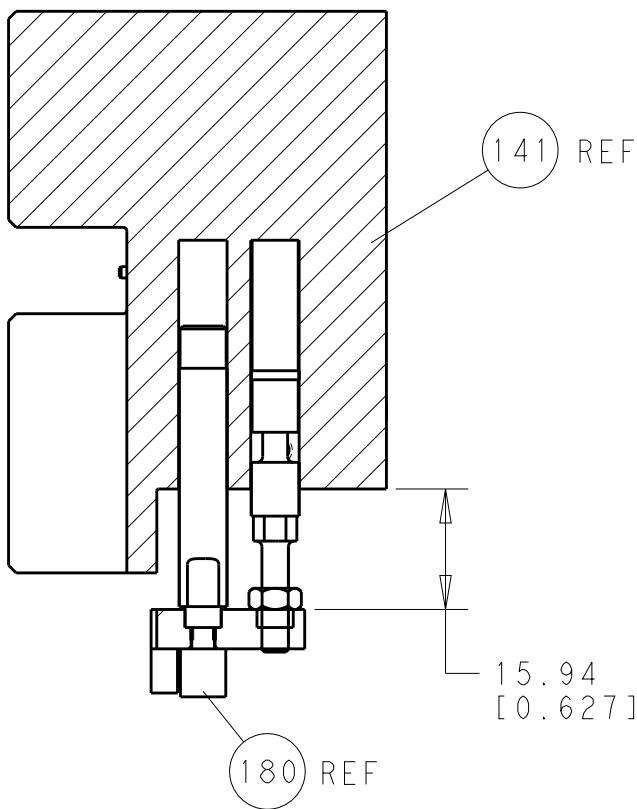
CAM POSITIONS



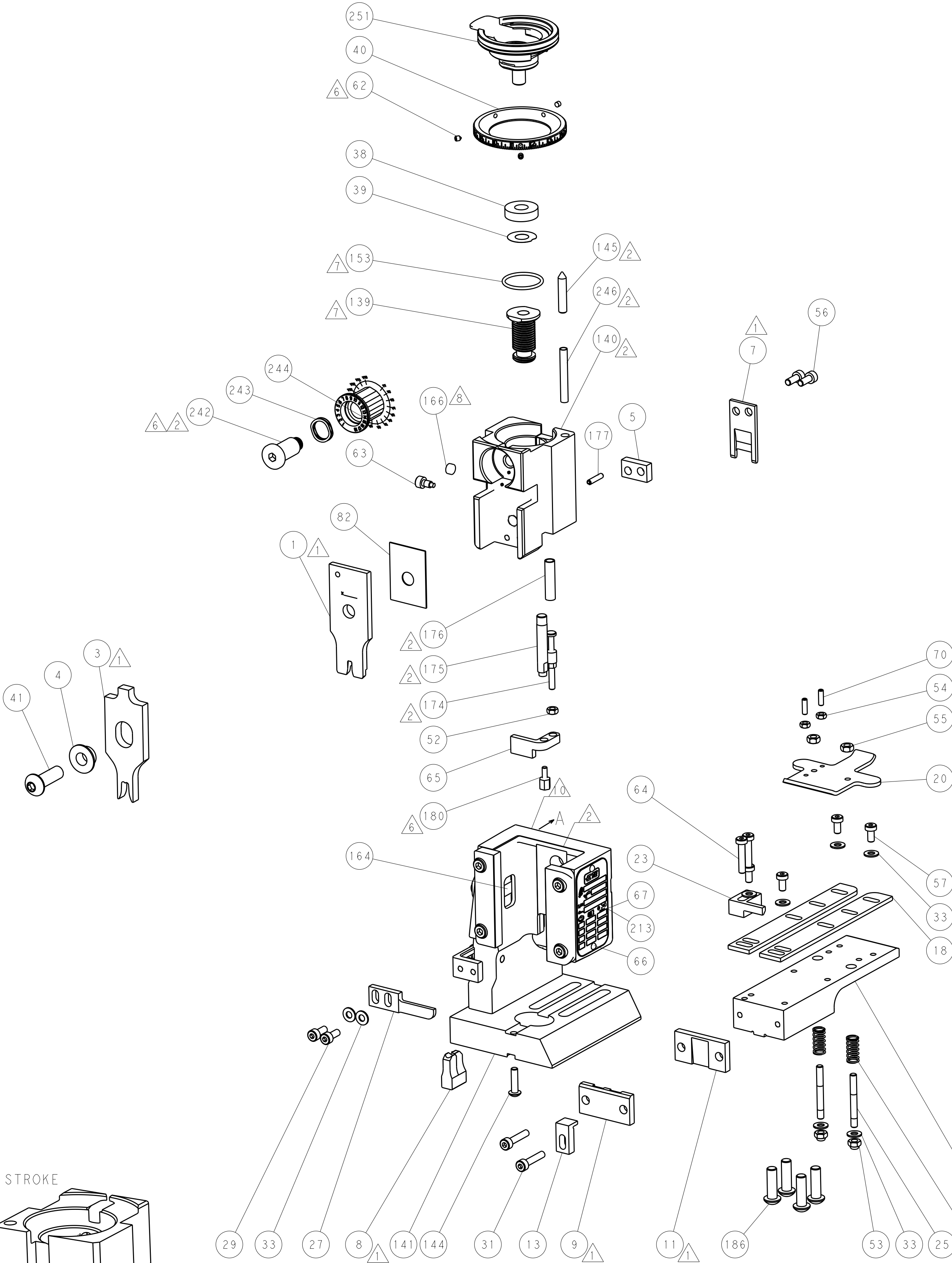
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

(1) FINISH: F-12 CONFORMS TO MIL-PRF-13120, TYPE II, CLASS 1, PER MIL-PR	
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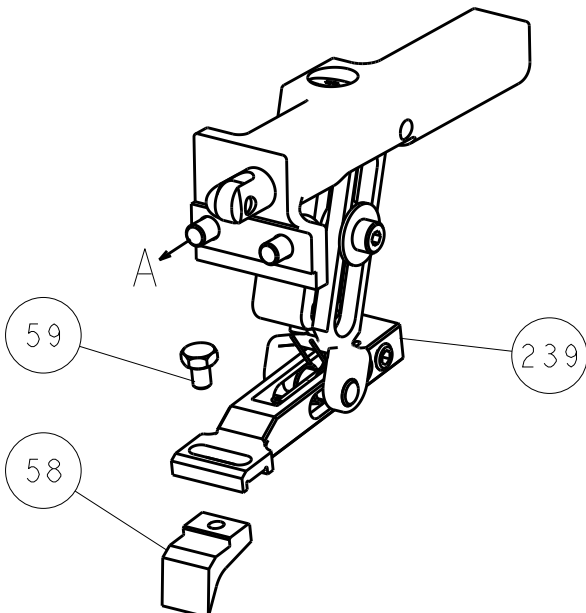
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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



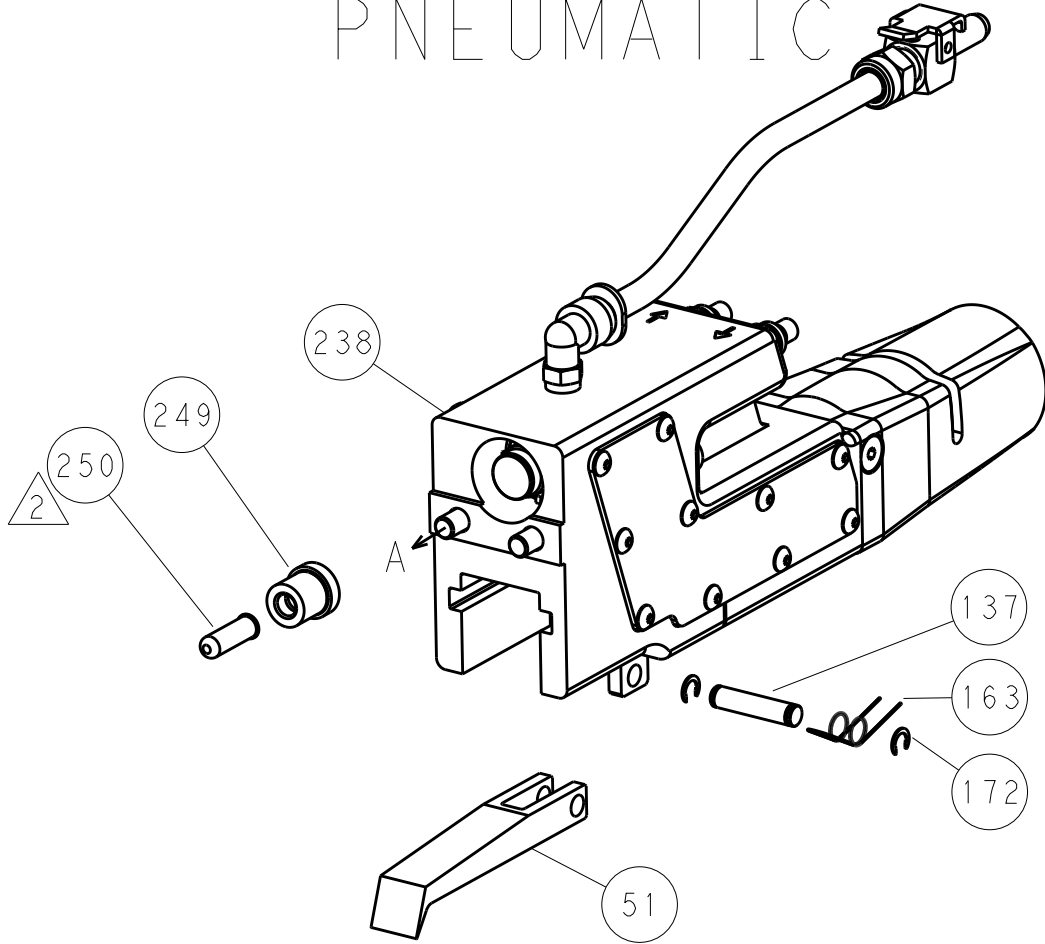
HOLDDOWN SET-UP



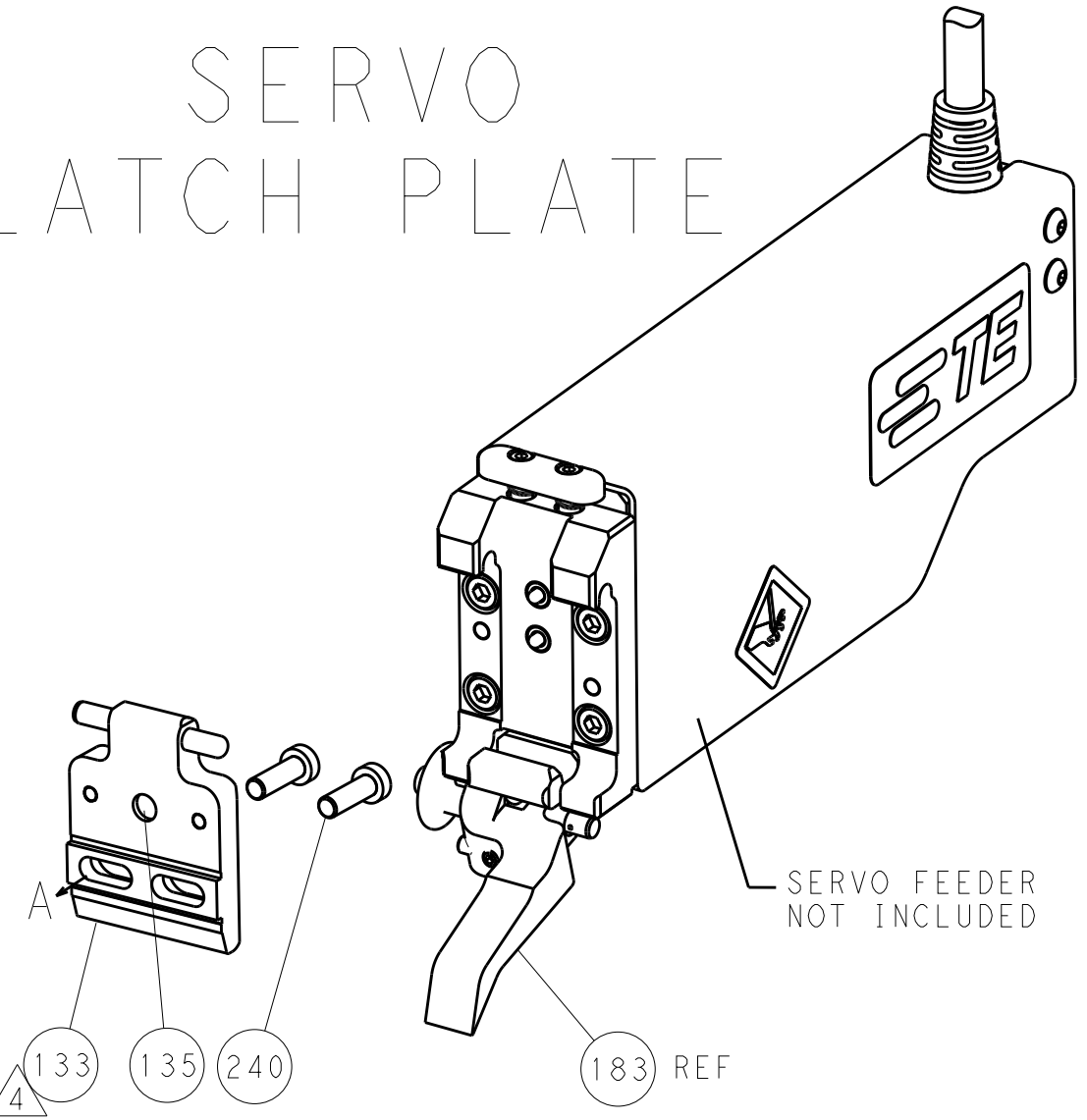
FEED TYPE
MECHANICAL



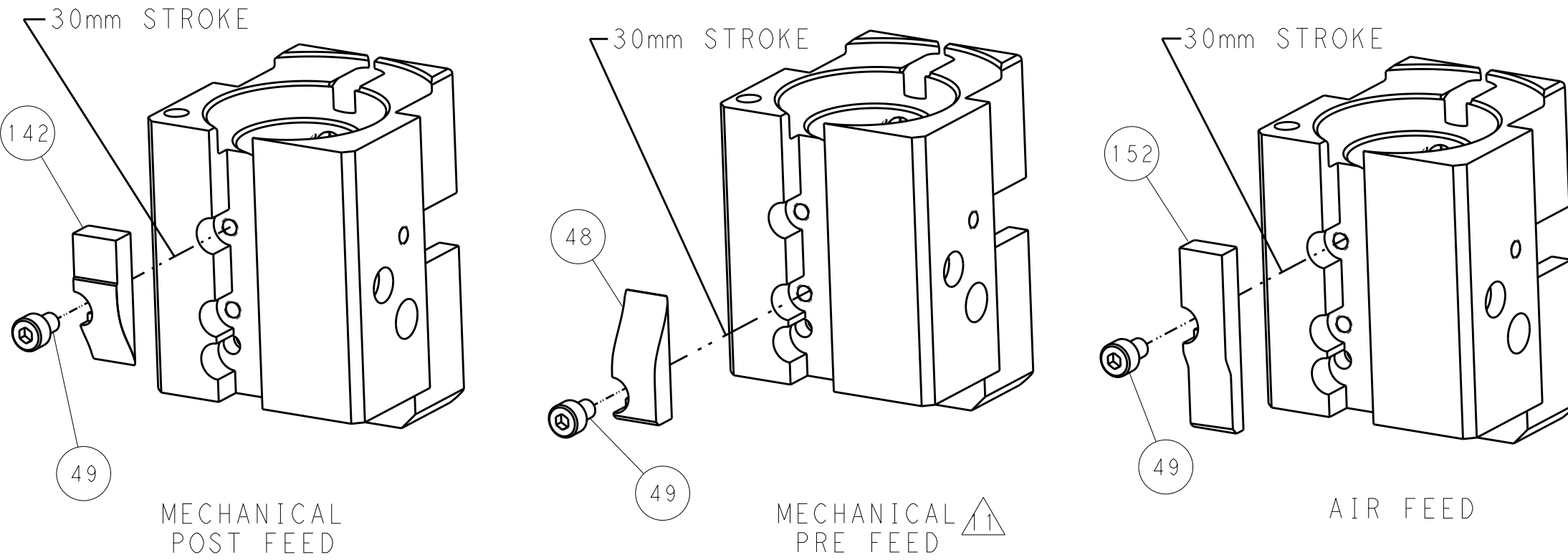
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HOW 23OCT2014		STE TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±.5		CHK Y. YIN 23OCT2014		NAME Ocean End Feed Applicator	
		1 PLC ±0.13		APVD U. GUO 23OCT2014		SIZE CAGE CODE DRAWING NO	
		2 PLC ±0.13		PRODUCT SPEC		A1 00779 C=2150502	
		3 PLC ±0.013		APPLICATION SPEC		RESTRICTED TO	
		4 PLC ±0.0001		WEIGHT		Customer Accessible Production Drawing	
MATERIAL		FINISH		SCALE 1:1		SHEET 4 OF 4	
						REV A	