

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2150315-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
	2150315-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150315-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150315-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
	2150315-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150315-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150315-4	-	-	-
	2150315-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
2150315-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1	
7-2150315-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.01 mm [.158]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: G&H TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE 6, 3x0, 8			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-6.00 mm [.217-.236 IN]		Ø2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	25985 Rev 2	-	-
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572845-1	25914.201.011	1572845-7	25985.123.211
1572845-2	25914.201.004	1572845-8	25985.123.204
1572845-3	25914.123.211	1572845-9	25985.123.242
1572845-4	25914.123.204	1-1572845-0	25985.201.042
1572845-5	25985.201.011	1-1572845-1	25914.123.242
1572845-6	25985.201.004	1-1572845-2	25914.201.042

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00+1.50	1.95+/-0.05 [.077+/- .002]	6.4
2.50	1.85+/-0.05 [.073+/- .002]	7.8
2X1.00	1.80+/-0.05 [.071+/- .002]	8.3
0.50+1.50	1.80+/-0.05 [.071+/- .002]	8.3
2.00	1.80+/-0.05 [.071+/- .002]	8.3
0.50+1.00	1.65+/-0.05 [.065+/- .002]	9.8
1.50	1.65+/-0.05 [.065+/- .002]	9.8

- 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: 8-2150315-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150315-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150315-5
 - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150315-6
- 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 50 & 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

TERMINAL DATA: G&H TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE 6, 3x0, 8			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-6.00 mm [.217-.236 IN]		Ø2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572845-1	25914.201.011	1572845-7	25985.123.211
1572845-2	25914.201.004	1572845-8	25985.123.204
1572845-3	25914.123.211	1572845-9	25985.123.242
1572845-4	25914.123.204	1-1572845-0	25985.201.042
1572845-5	25985.201.011	1-1572845-1	25914.123.242
1572845-6	25985.201.004	1-1572845-2	25914.201.042

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2X16	1.90+/-0.05 [.075+/- .002]	6.8
1-14	1.75+/-0.05 [.069+/- .002]	8.7
2X18	1.75+/-0.05 [.069+/- .002]	8.7
1-16	1.55+/-0.05 [.061+/- .002]	10.6
1-18	1.48+/-0.05 [.058+/- .002]	11.2

***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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	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

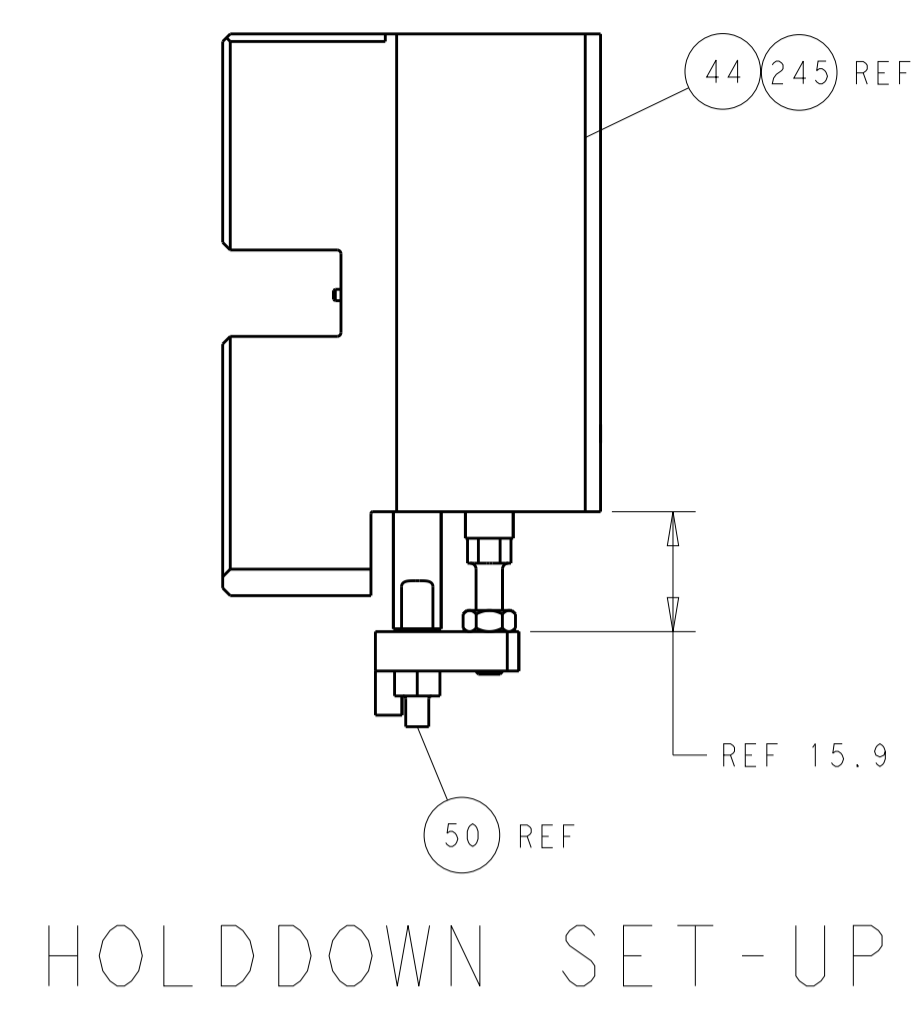
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
			A		RELEASED	13MAR2013	RW	TE
			A1		ECR-15-014841	09OCT2015	XZ	UG
			A2		ECR-15-015949	30OCT2015	JH	TE

P	LTM	DESCRIPTION	DATE	DWN	APVD			
-	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	455888-5	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	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	1-1976055-4	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	1752371-3	PLATE, STRIP GUIDE	24
-	1	1	1	1	1	240825-3	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	1901259-6	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	240833-4	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	-	10
-	1	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9
-	1	1	1	1	1	1803060-3	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	3-240641-5	SPACER	5
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	4-2119582-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-8	SPACER, CRIMPER	2
-	1	1	1	1	1	3-456408-0	CRIMPER, WIRE PREMIUM	1

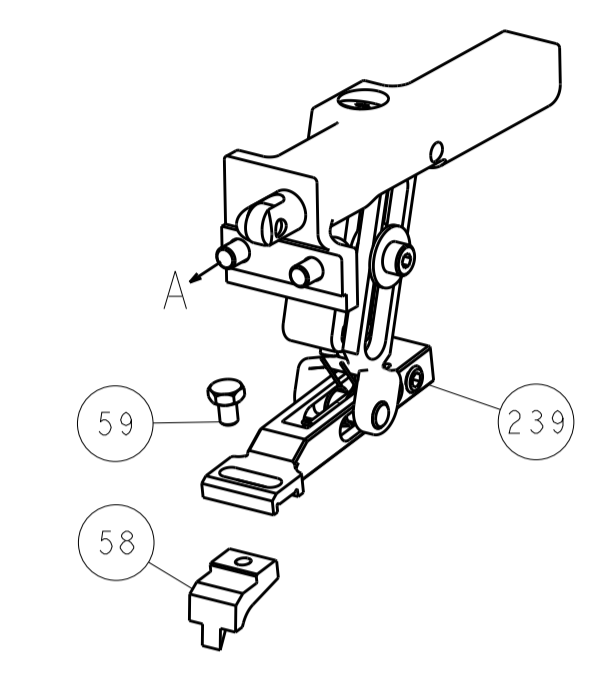
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DRAWN	DATE	CHK	DATE	APVD	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
mm	0 PLC ±.01 1 PLC ±.02 2 PLC ±.03 3 PLC ±.04 4 PLC ±.05 ANGLES ±.0001	R. O. WILSON	15FEB2013	K. J. STAKEM	20FEB2013	T. L. ELBIN	20FEB2013	TE Connectivity Harrisburg, PA 17105-3608	A1	00779	©=2150315	-
MATERIAL:		FINISH:		WEIGHT:		CUSTOMER DRAWING		SCALE		SHEET 1 OF 4		REV A2

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

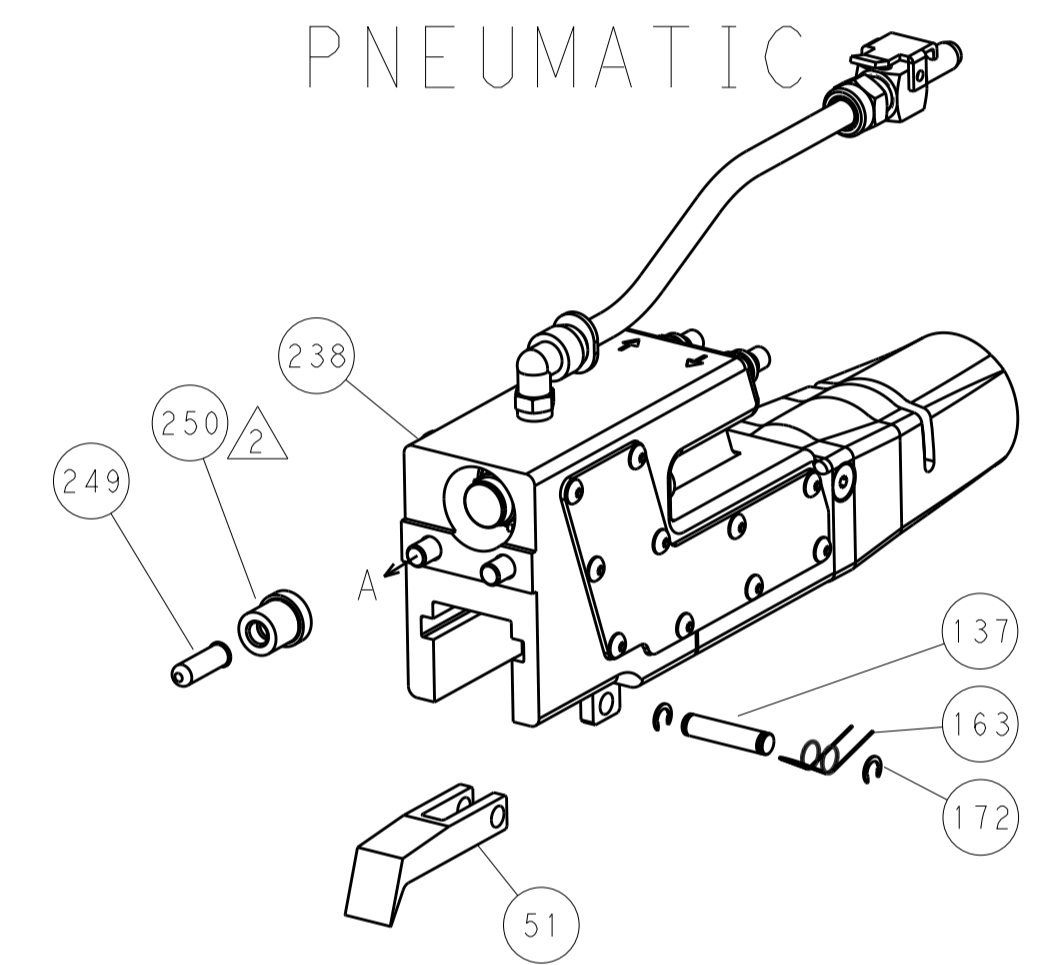


HOLDDOWN SET-UP

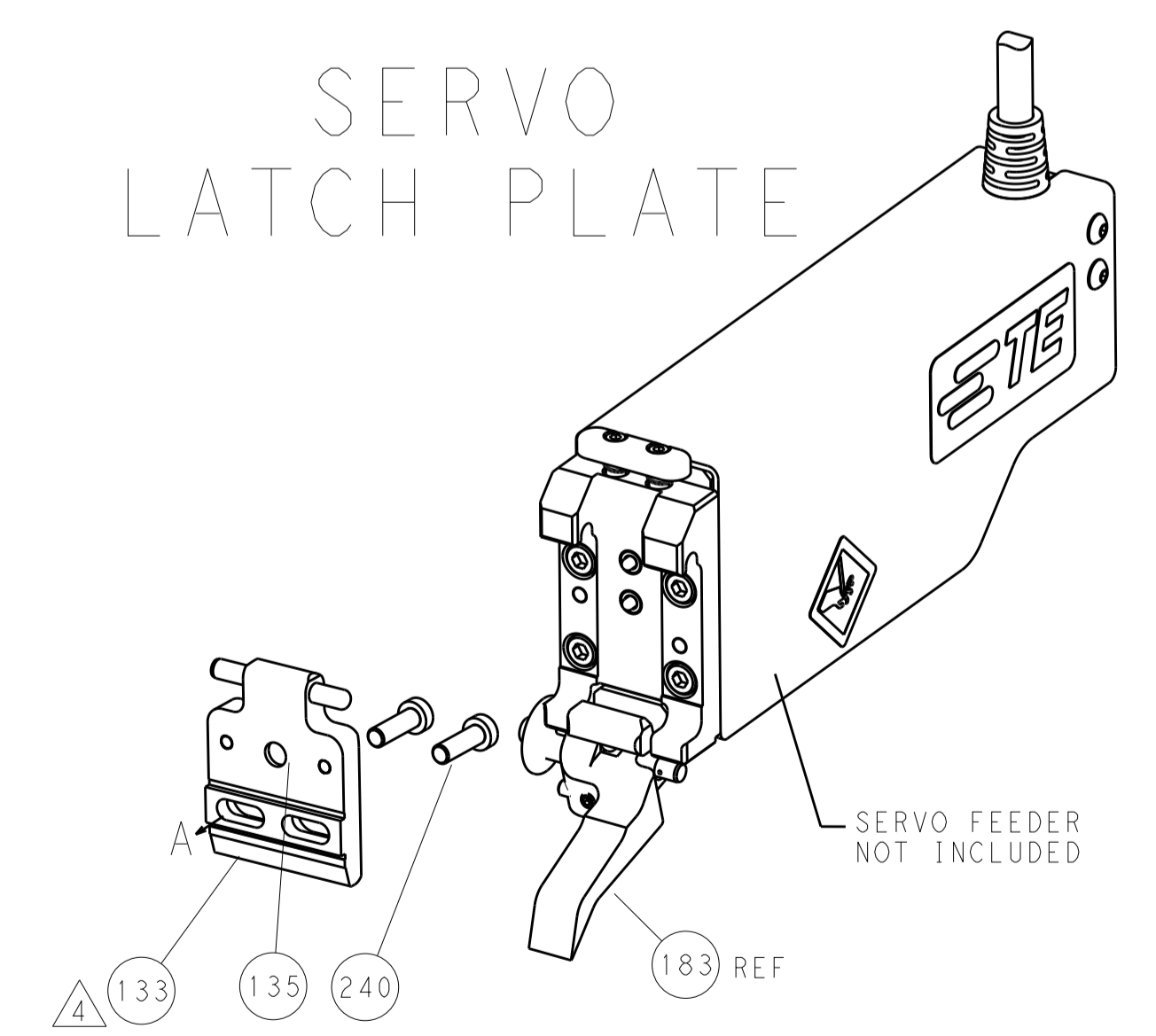
FEED TYPE
MECHANICAL



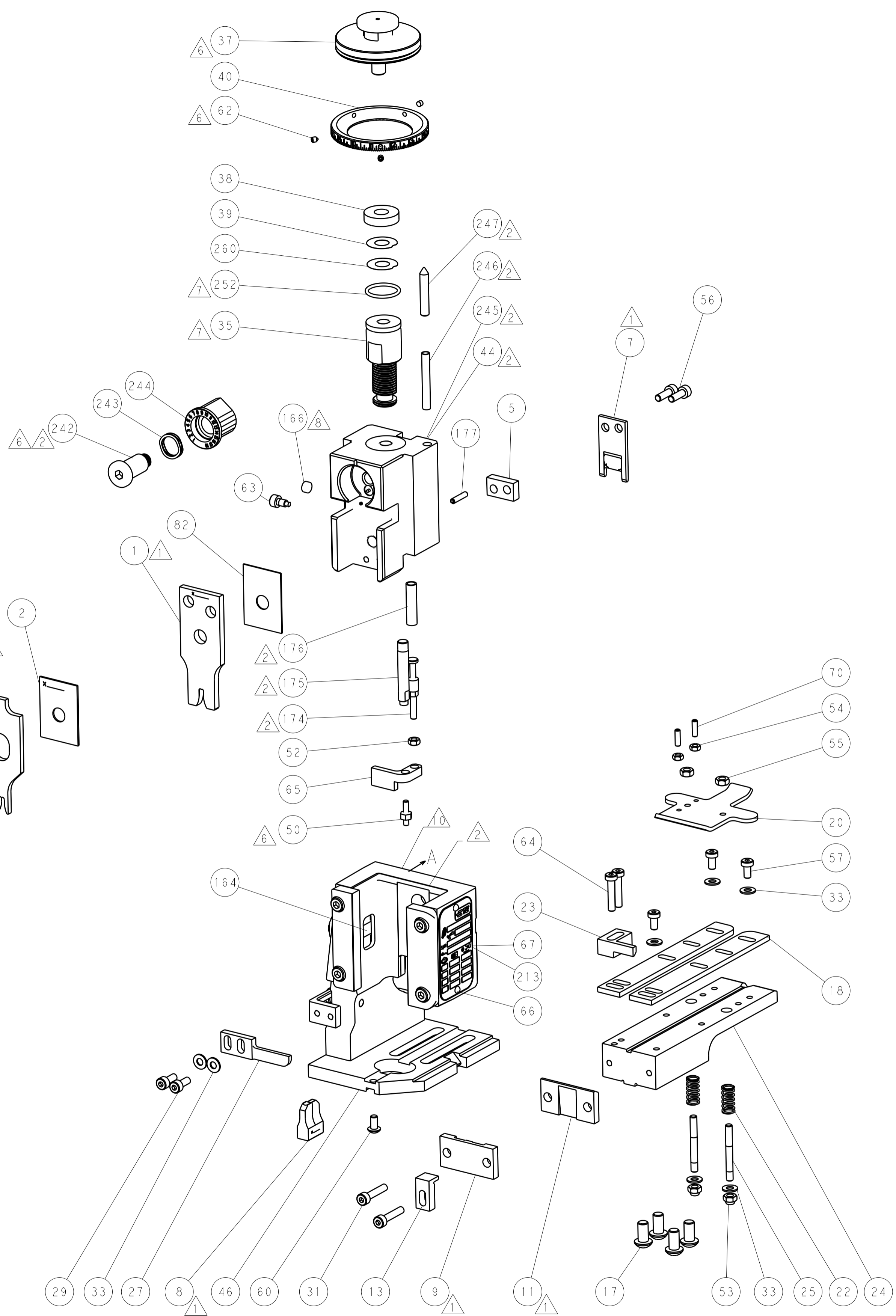
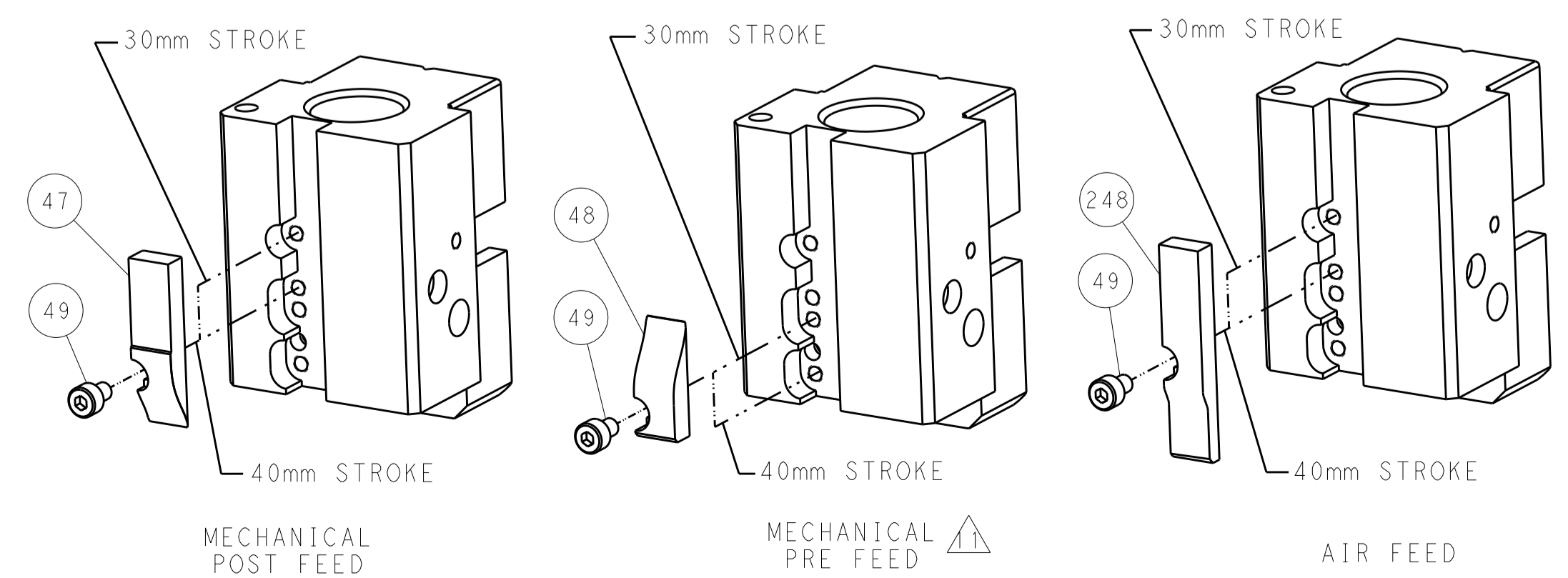
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: R. Q. WILSON 15FEB2013		TE Connectivity	
mm		0 PLC ±0.5		CHK: K. J. STAKEM 20FEB2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APVD: T. L. ELBIN 20FEB2013		NAME: Ocean End Feed Applicator	
H		3 PLC ±0.013		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
ANGLES		4 PLC ±0.0001		APPLICATION SPEC		A11 00779 ©=2150315	
FINISH		5 PLC ±0.0001		WEIGHT		SCALE: 1:1 SHEET 2 OF 4 REV A2	
MATERIAL		CUSTOMER DRAWING		CUSTOMER DRAWING		SCALE: 1:1 SHEET 2 OF 4 REV A2	

APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA. Table with columns: CRIMP SIZE, WIRE, INSUL, APPL INSTRUCTIONS.

TERMINAL DATA: G&H TERMINAL LEAR CRIMP SPECIFICATION. Table with columns: TE TERMINAL, G&H TERMINAL.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT.

- 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.

TERMINAL DATA: G&H TERMINAL TE CRIMP SPECIFICATION. Table with columns: TE TERMINAL, G&H TERMINAL.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP 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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various spare parts like FINE ADJUST HEAD ASM, PUSH ROD, BUSHING.

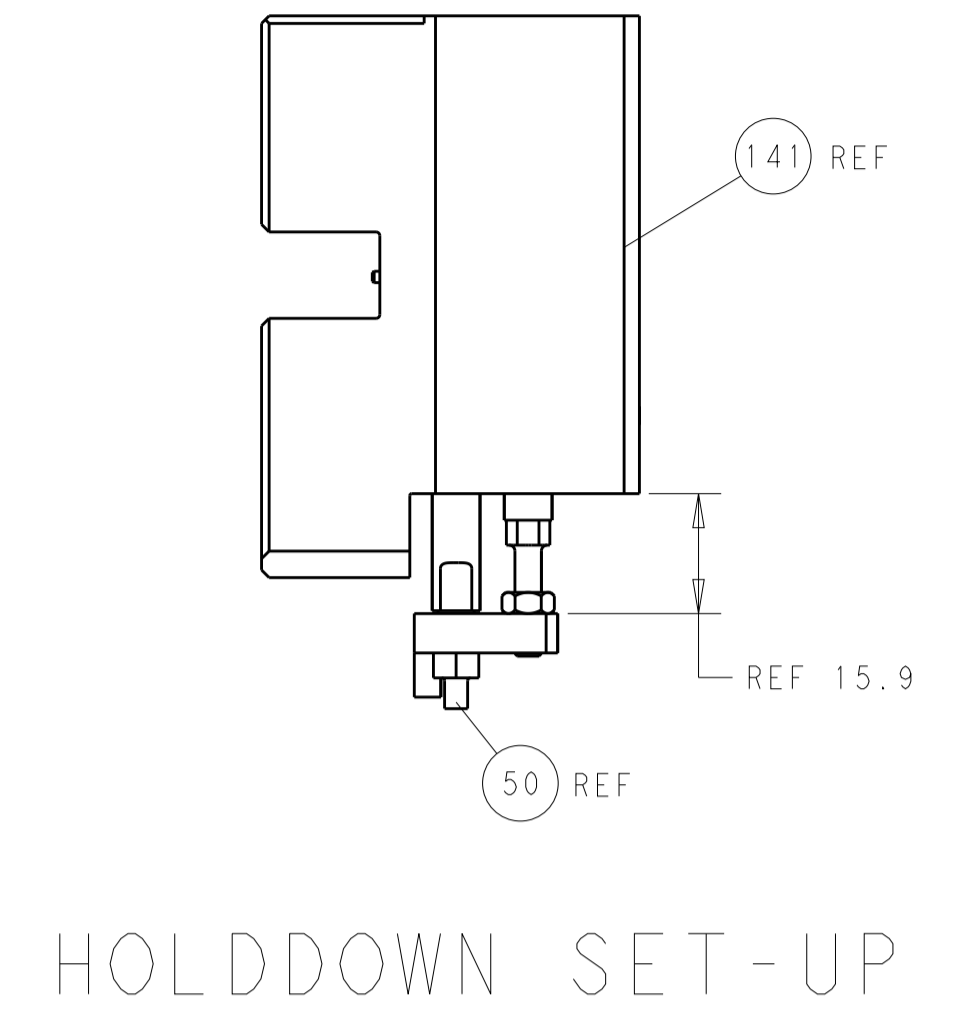
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE, REVISIONS. Table with columns: SET UP GAUGE, REVISIONS.

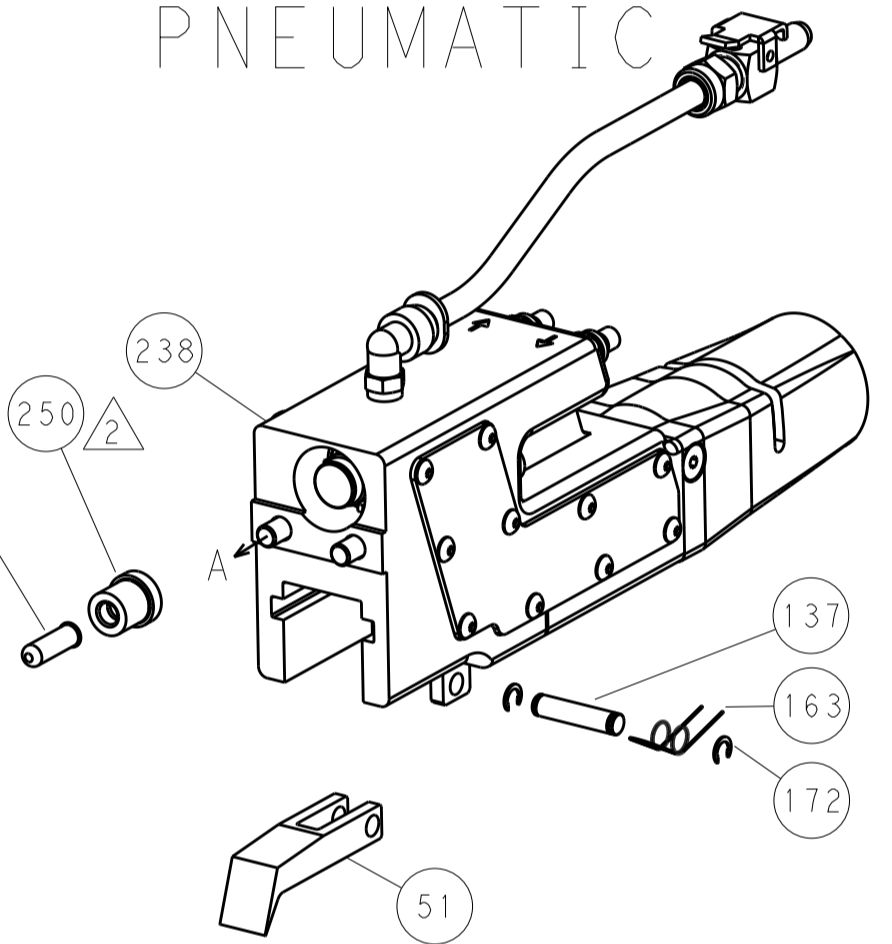
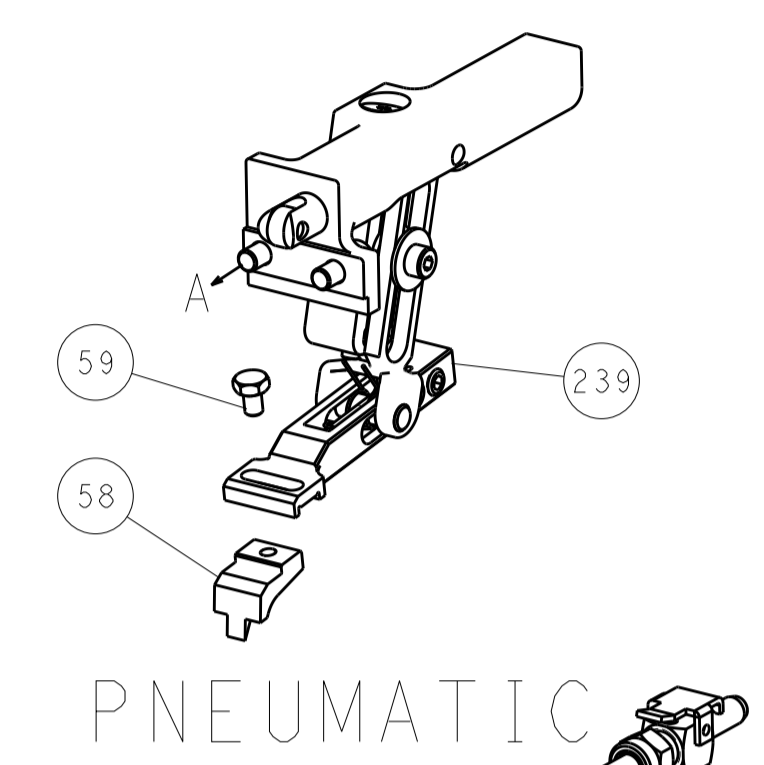
Large table listing various components like RETAINER, SHCS, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, TAG, IDENTIFICATION, etc. with quantities.

STE logo, TE Connectivity, Ocean End Feed Applicator. Includes dimensions, tolerances, material, and drawing information.

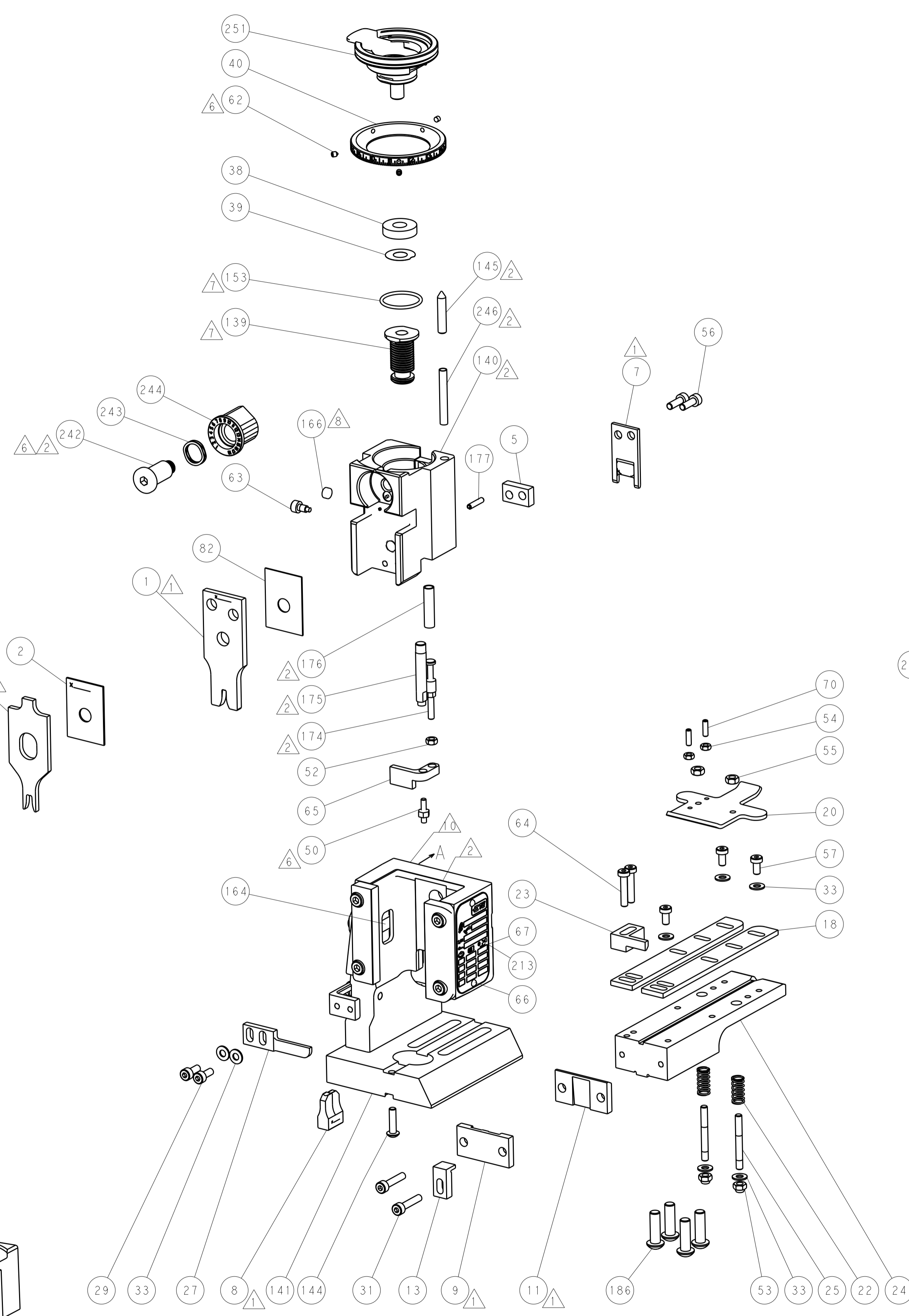
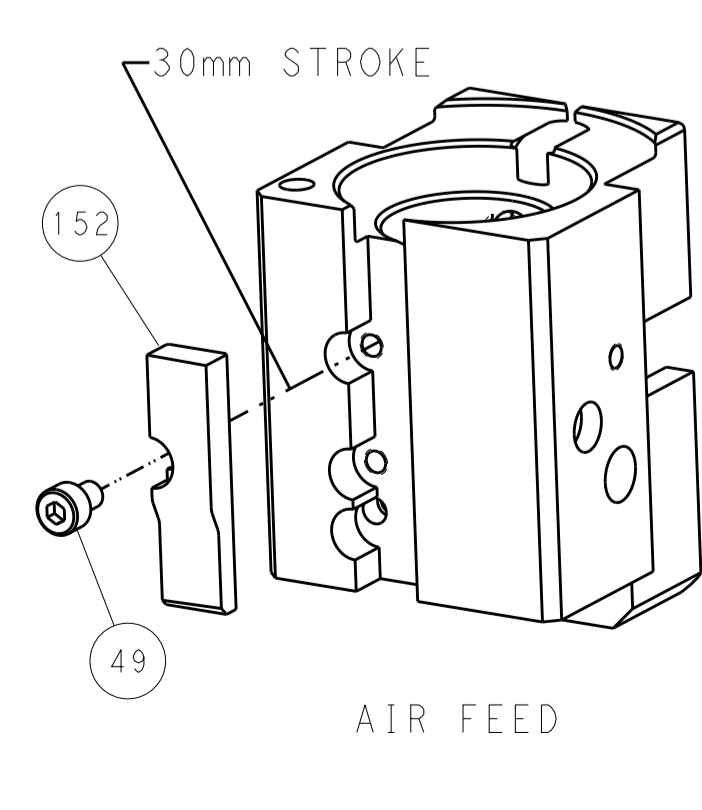
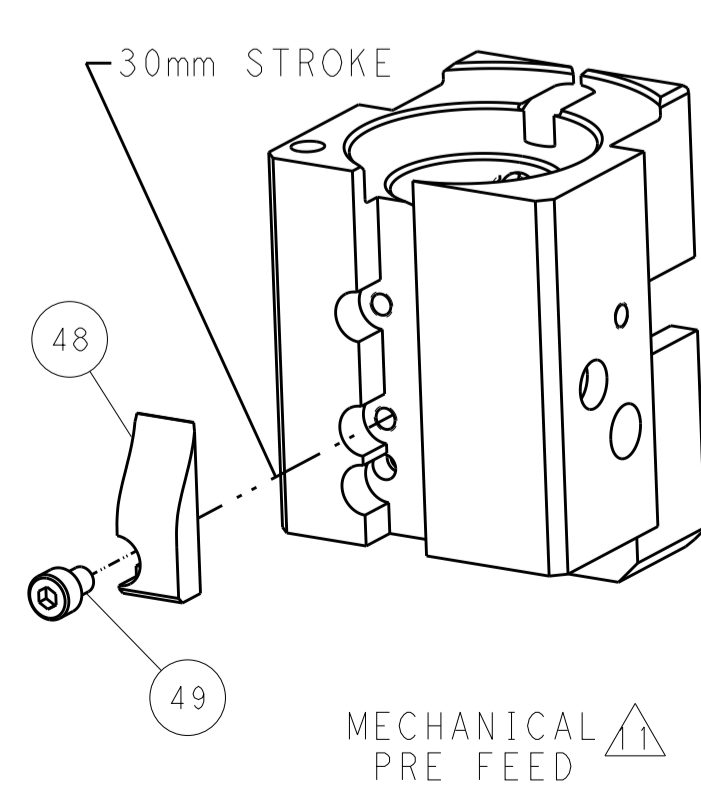
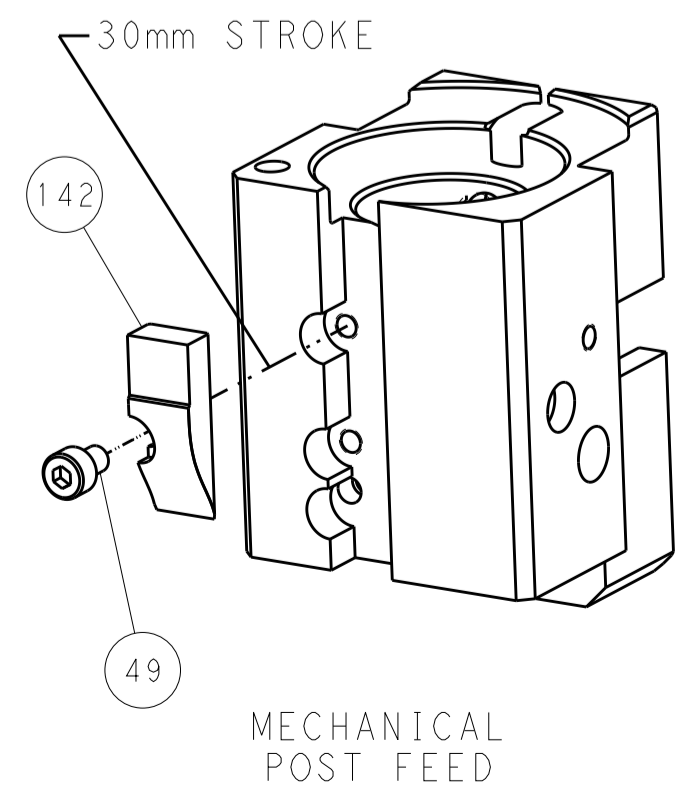
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



FEED TYPE
MECHANICAL



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 R.O. WILSON 15FEB2013 CHK K.J. STAKEM 20FEB2013 APVD T.L. ELBIN 20FEB2013		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.0001	NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. A11 00779 C=2150315 RESTRICTED TO
MATERIAL	FINISH	WEIGHT	CUSTOMER DRAWING	SCALE 1:1	SHEET 4 OF 4	REV A2	