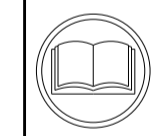


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150336-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1-1338683-0	5-18022-5	2119653-1	-	-
	2150336-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150336-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.57 mm [.180]	SP
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS FLAG F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-5.30 mm [.169-.209 IN]		Ø2.70-3.80 mm [.106-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-64027	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178439-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	1.96+/-0.05 [.077+/-0.002]	5.1
14 AWG	1.85+/-0.05 [.073+/-0.002]	6.4
16 AWG	1.64+/-0.05 [.065+/-0.002]	8.5



- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150336-4
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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 ITEMS 37 & 50.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.
- TERMINAL DESIGN IS NOT COMPATIBLE WITH SERVO FEED AND MECHANICAL FEED.

***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.

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			
			REV	DATE	BY	APPV
	A		RELEASED	22JUL2014	RK	TE
	A1		ECR-15-004977	30MAR2015	JH	JT
	A2		ECR-15-006528	28APR2015	RS	LZ
	B		ECR-15-013159	06SEP2015	YY	KZ

-	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	2119798-1	DETENT PIN	247
-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2063440-1	AIR FEED MODULE	238
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	-	1	240638-1	SPRING, FEED FINGER	163
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1803176-1	HOLDDOWN, TERMINAL	65
-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	1	2161920-2	NARROW PAWL, EF, AIR	51
-	1	1	3-1752354-9	STANDOFF,HOLD-DOWN	50
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	2119369-1	RAM,AMP STYLE, END FEED	44
-	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1-690455-0	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161922-1	PLATE, STRIP GUIDE	24
-	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1-464452-7	DRAG, STOCK	20
-	1	1	1803086-2	GUIDE, REAR STRIP	19
-	1	1	3-1901695-3	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1803175-1	SUPPORT, TERMINAL	13
-	1	1	461160-3	PLATE, REAR SHEAR	11
-	2	2	6-240645-1	SPACER, SHEAR PLATE	10
-	1	1	455961-5	PLATE, FRONT SHEAR	9
-	1	1	1803074-8	ANVIL, COMBINATION, END FEED	8
-	1	1	1803186-1	BLADE, SLUG	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	3-238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1803108-6	CRIMPER, INSULATION O	3
-	1	1	455888-9	SPACER, CRIMPER	2
-	1	1	1-1803015-2	CRIMPER, WIRE	1
-	77	-7	-2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5
	ANGLES ±.0001				
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV
			1:1	1 OF 4	B

STE TE Connectivity
 Harrisburg, PA 17105-3608

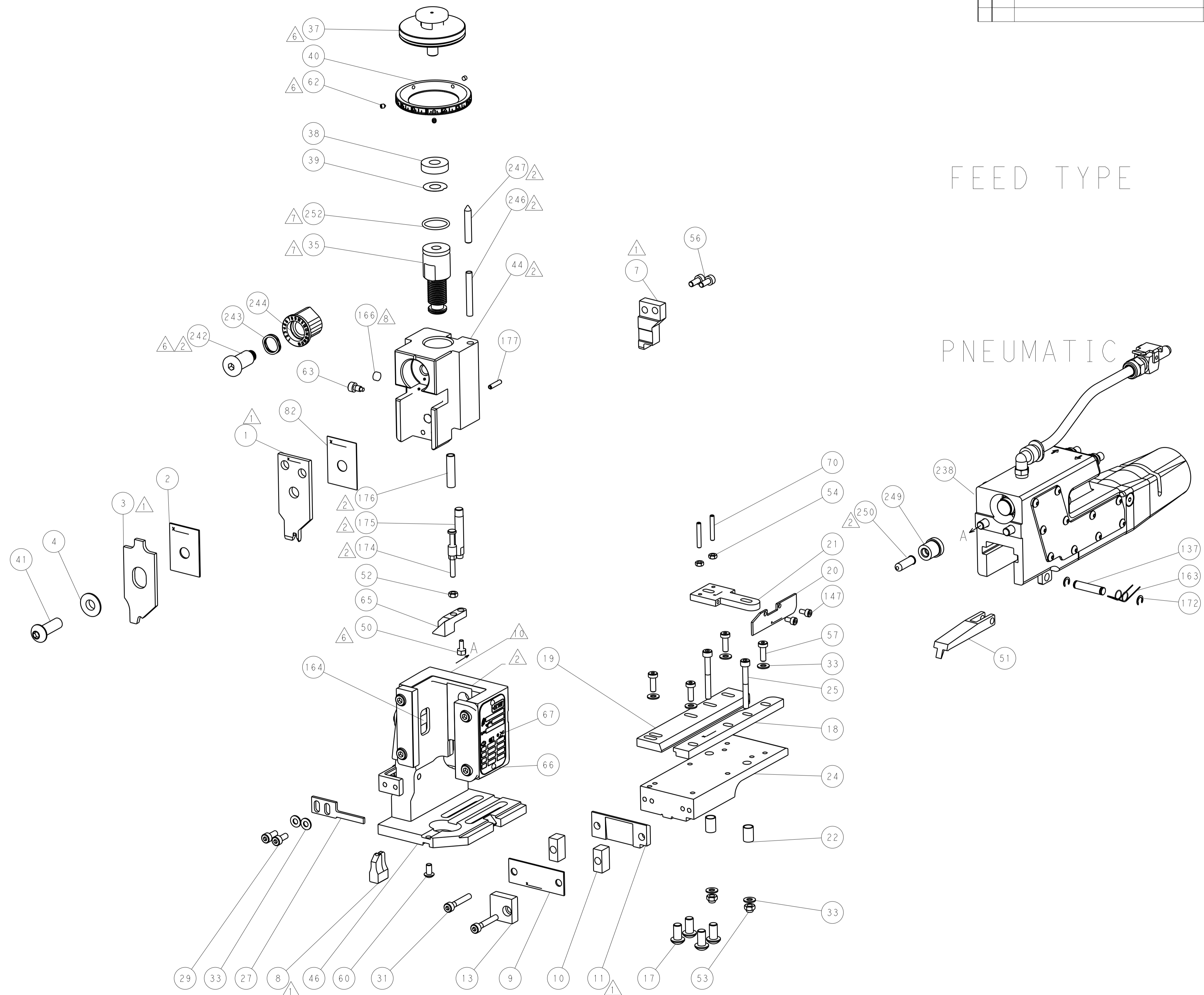
NAME: Ocean End Feed Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150336

Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APPV
A	66				

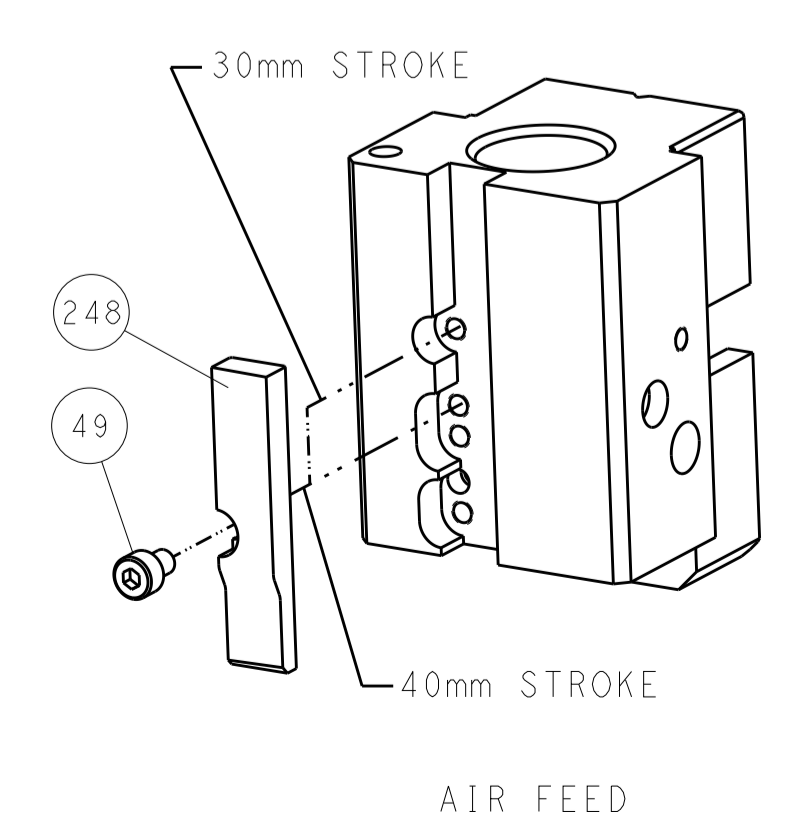
REVISIONS			
REV	DATE	BY	APPV
-	SEE SHEET 1	-	-



FEED TYPE

PNEUMATIC

CAM POSITION



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

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		DWN R. KNEPPER 06JUN2013 CHK T. ELBIN 06JUN2013 APVD M. CLIFFORD 06JUN2013		NAME Ocean End Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150336	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 2 OF 4 REV B	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150336-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1-1338683-0	5-18022-5	2119653-2	-	-
	2-2150336-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150336-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.57 mm [.180]	SP
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS FLAG F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-5.30 mm [.169-.209 IN]		Ø2.70-3.80 mm [.106-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-64027	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178439-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	1.96+/-0.05 [.077+/-0.002]	5.1
14 AWG	1.85+/-0.05 [.073+/-0.002]	6.4
16 AWG	1.64+/-0.05 [.065+/-0.002]	8.5

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER: PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150336-4
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.
- TERMINAL DESIGN IS NOT COMPATIBLE WITH SERVO FEED AND MECHANICAL FEED.

***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.

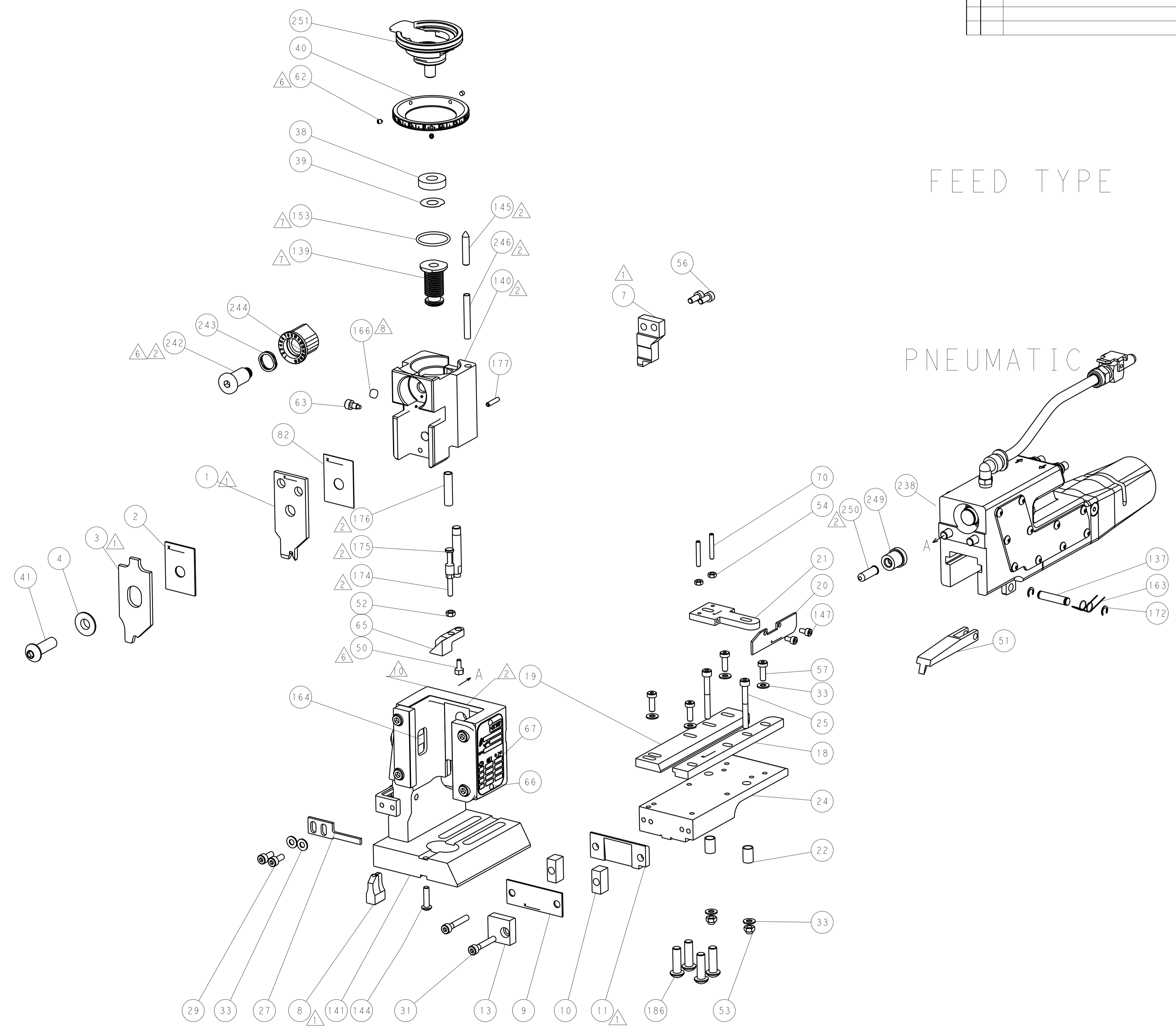
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

-	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2063440-1	AIR FEED MODULE	238
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	-	1	240638-1	SPRING, FEED FINGER	163
-	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
-	-	1	2119641-2	FEED CAM, AIR FEED	152
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
-	1	1	2119798-2	DETENT PIN	145
-	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	-	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1803176-1	HOLDDOWN, TERMINAL	65
-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	1	2161920-2	NARROW PAWL, EF, AIR	51
-	1	1	3-1752354-9	STANDOFF,HOLD-DOWN	50
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1-690455-0	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161922-1	PLATE, STRIP GUIDE	24
-	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1-464452-7	DRAG, STOCK	20
-	1	1	1803086-2	GUIDE, REAR STRIP	19
-	1	1	3-1901695-3	STRIP GUIDE, FRONT	18
-	1	1	1803175-1	SUPPORT, TERMINAL	13
-	1	1	461160-3	PLATE, REAR SHEAR	11
-	2	2	6-240645-1	SPACER, SHEAR PLATE	10
-	1	1	455961-5	PLATE, FRONT SHEAR	9
-	1	1	1803074-8	ANVIL, COMBINATION, END FEED	8
-	1	1	1803186-1	BLADE, SLUG	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	3-238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1803108-6	CRIMPER, INSULATION O	3
-	1	1	455888-9	SPACER, CRIMPER	2
-	1	1	1-1803015-2	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV		DATE	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5	5 PLC ±.5	6 PLC ±.5	7 PLC ±.5	8 PLC ±.5
	ANGLES ±.0001								
MATERIAL	FINISH	WEIGHT	SCALE	APPROVED	DATE	BY	DATE	BY	DATE
			1:1	M. KNEPPER	06JUN2013	T. ELBIN	06JUN2013	M. CLIFFORD	06JUN2013
Customer Accessible Production Drawing				SHEET 3 OF 4		REV B		SCALE	

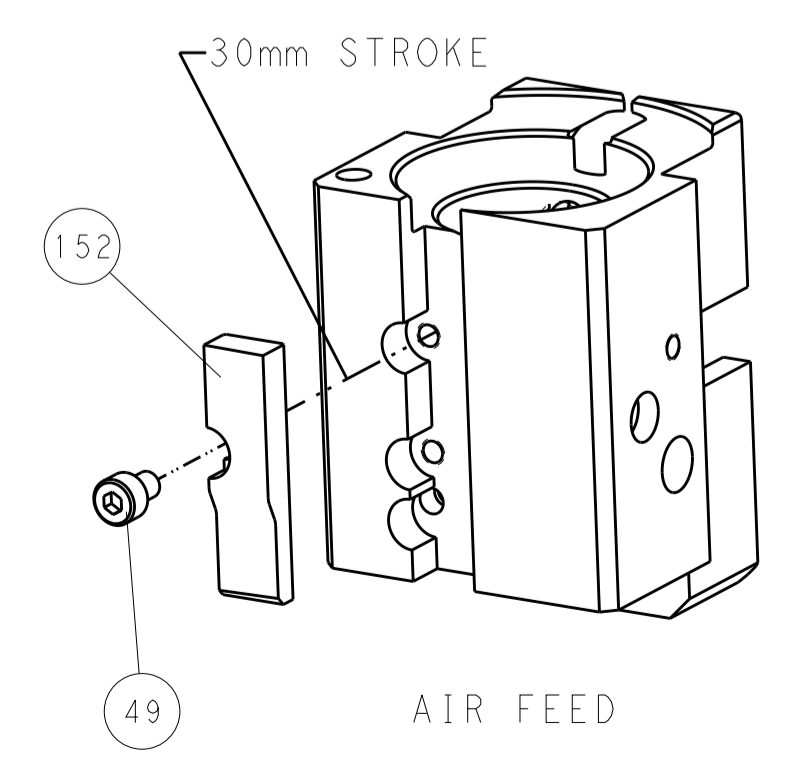
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



FEED TYPE

PNEUMATIC

CAM POSITION



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:		DWG: R. KNEPPER 06JUN2013		REV: T. ELBIN 06JUN2013		NAME: M. CLIFFORD 06JUN2013		STE 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	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		SHEET: 4 of 4		REV: B	
Customer Accessible Production Drawing				A11 00779 ©=2150336		RESTRICTED TO:					