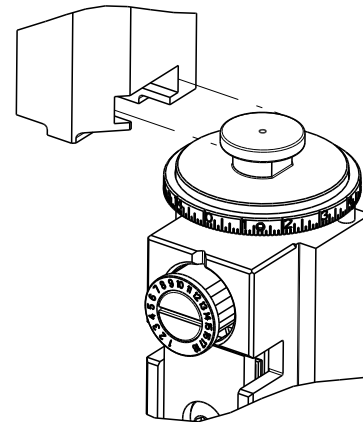


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
COPYRIGHT 20		20	
BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150257-1	B	FINE CRIMP HEIGHT ADJUST
	2150257-2	B	FINE CRIMP HEIGHT ADJUST
	2150257-5	B	FINE CRIMP HEIGHT ADJUST
	2150257-6	B	NON-CRIMP HEIGHT ADJUST
	2150257-7	B	FINE CRIMP HEIGHT ADJUST
	7-2150257-7	A	CRIMP TOOLING KIT

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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH .207-.223 IN [5.27-5.65 mm]		 INSULATION DIAMETER RANGE Ø.080-.120 IN [2.03-3.05 mm]	
TERMINAL APPLICATION SPECIFICATION 	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
640271-1	640271-3	640204-1	640204-2
640204-3	640271-4	1217018-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.75+/-0.05 [1.069+/- .002]	9.6
20 AWG	1.65+/-0.05 [1.065+/- .002]	10.8
22 AWG	1.60+/-0.05 [1.063+/- .002]	11.4

- 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: 8-2150257-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150257-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150257-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150257-6
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

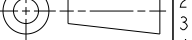
2	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
7	-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
	-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
	-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	-	1	1	1	2119798-1	DETENT PIN	247
	-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-77	-7	-6	-5	-2	-1		PART NO	DESCRIPTION	ITEM NO

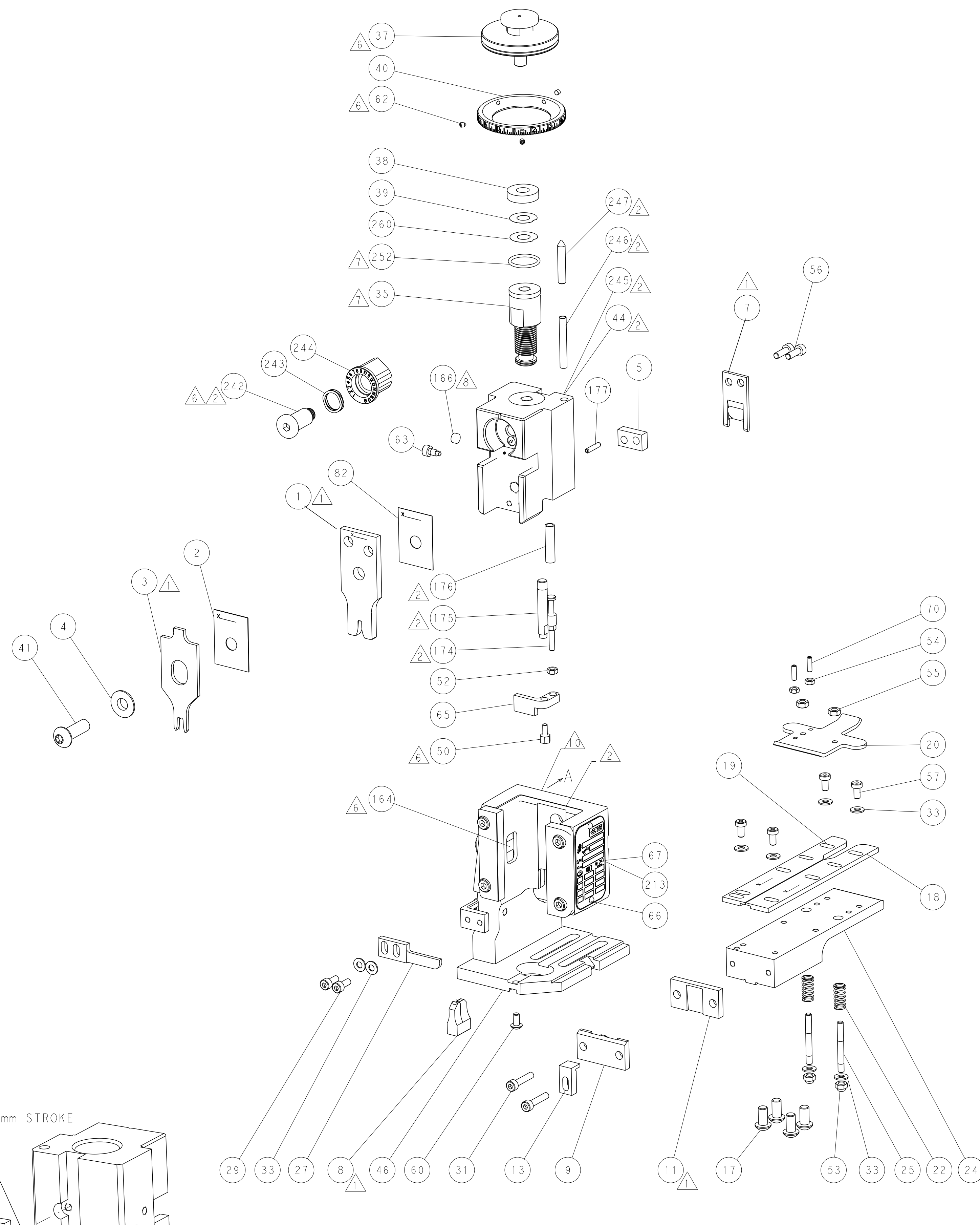
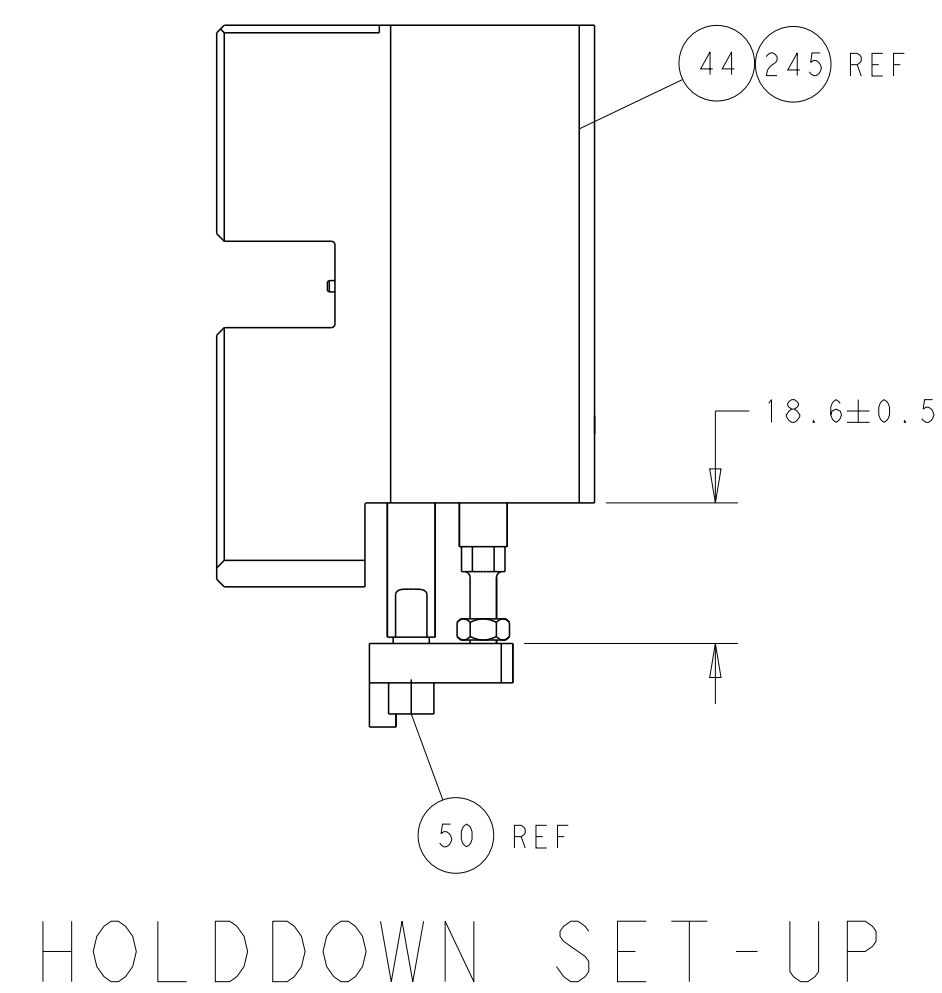
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS				
			P	LTR	DESCRIPTION	DATE	DWN
				B	ECR-16-001269	27JAN2016	MR
							TE

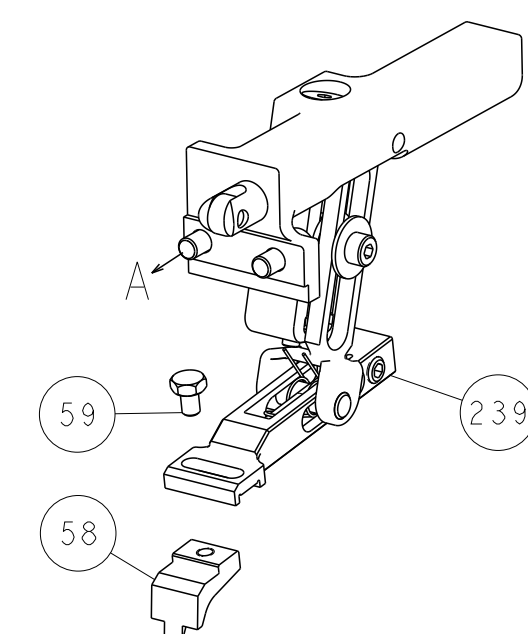
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	-	REF	REF	-	-	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
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	455888-2	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
-	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	2063961-3	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	1752354-3	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
-	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1	1752373-4	DRAG	20
-	1	1	1	1	1	1-1901696-5	STRIP GUIDE, REAR	19
-	1	1	1	1	1	1-1901695-5	STRIP GUIDE, FRONT	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	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	-	10
-	1	1	1	1	1	690496-7	PLATE, FRONT SHEAR	9
1	1	1	1	1	1	1-1803000-6	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1	2217206-4	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	6-240641-5	SPACER	5
-	1	1	1	1	1	1-238009-0	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	2-1633961-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	1	1	1	2-456407-5	CRIMPER, WIRE PREMIUM	1
-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)

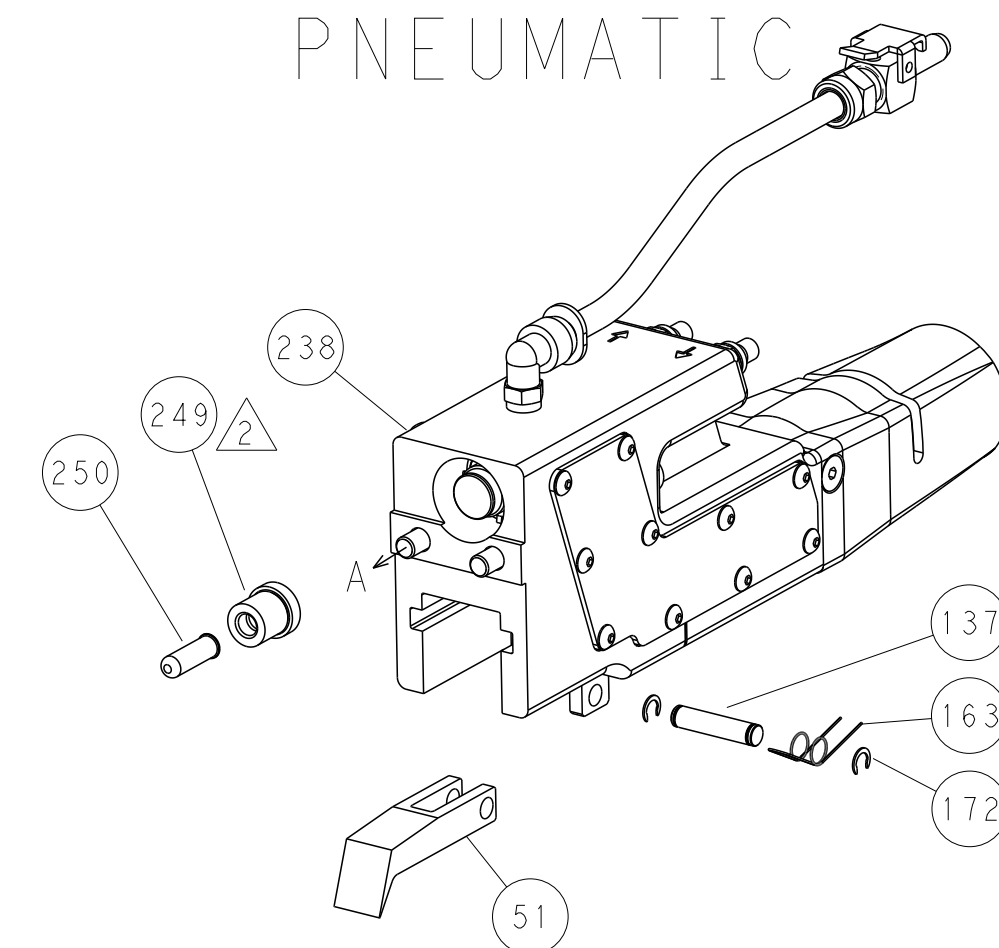
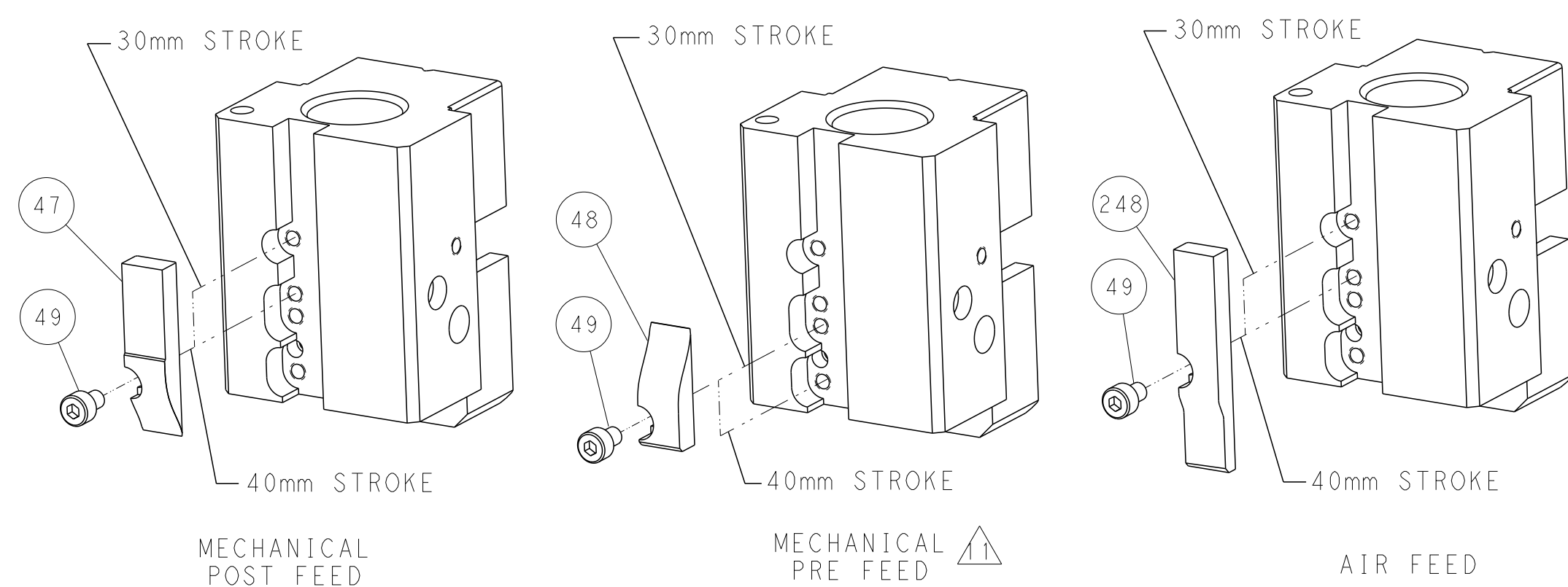
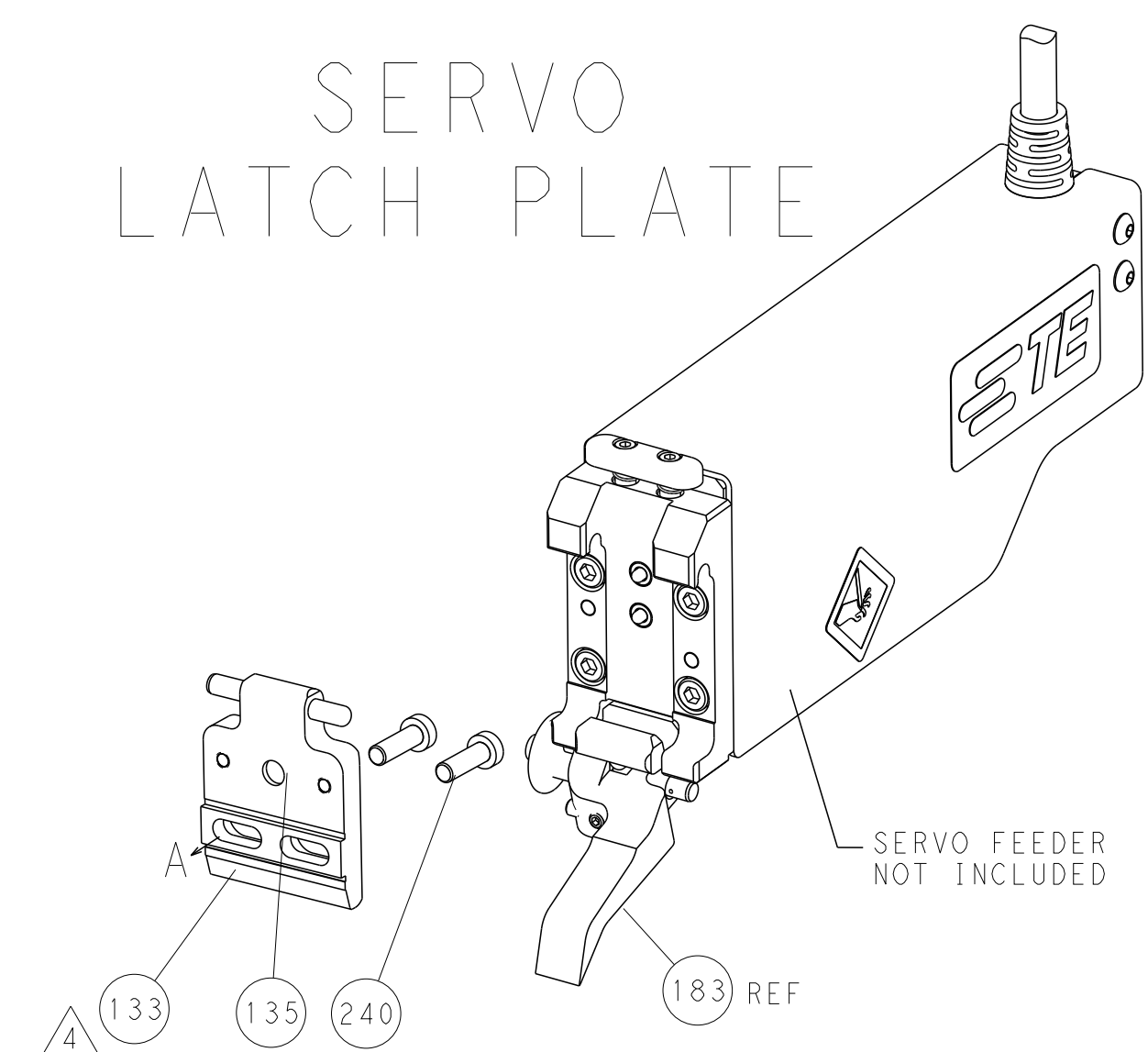
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS OF THIS DRAWING. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN K. STAKEM 13FEB2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN 13FEB2013	NAME	Ocean End Feed Applicator -
		APVD G. BAILEY 13FEB2013	PRODUCT SPEC	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APPLICATION SPEC	SIZE	RESTRICTED TO
MATERIAL	FINISH	WEIGHT	CASE CODE	
-	-	-	A1 00779	
		C=2150257		
		Customer Accessible Production Drawing		
		SCALE	SHEET	REV
		1:1	1 OF 4	B



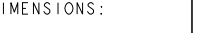
FEED TYPE
MECHANICAL



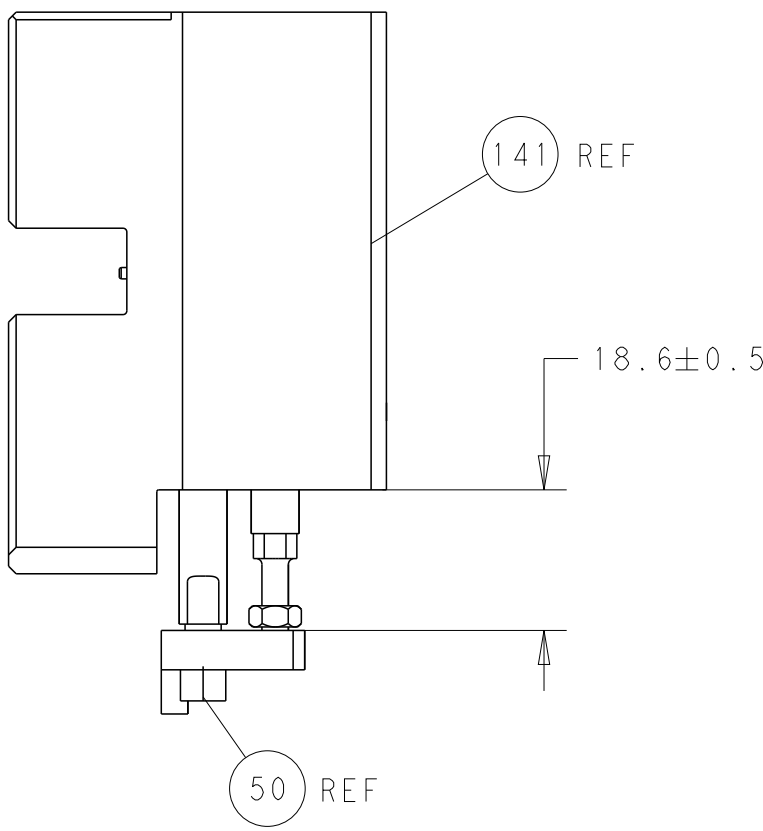
PNEUMATIC

SERVO
LATCH PLATE

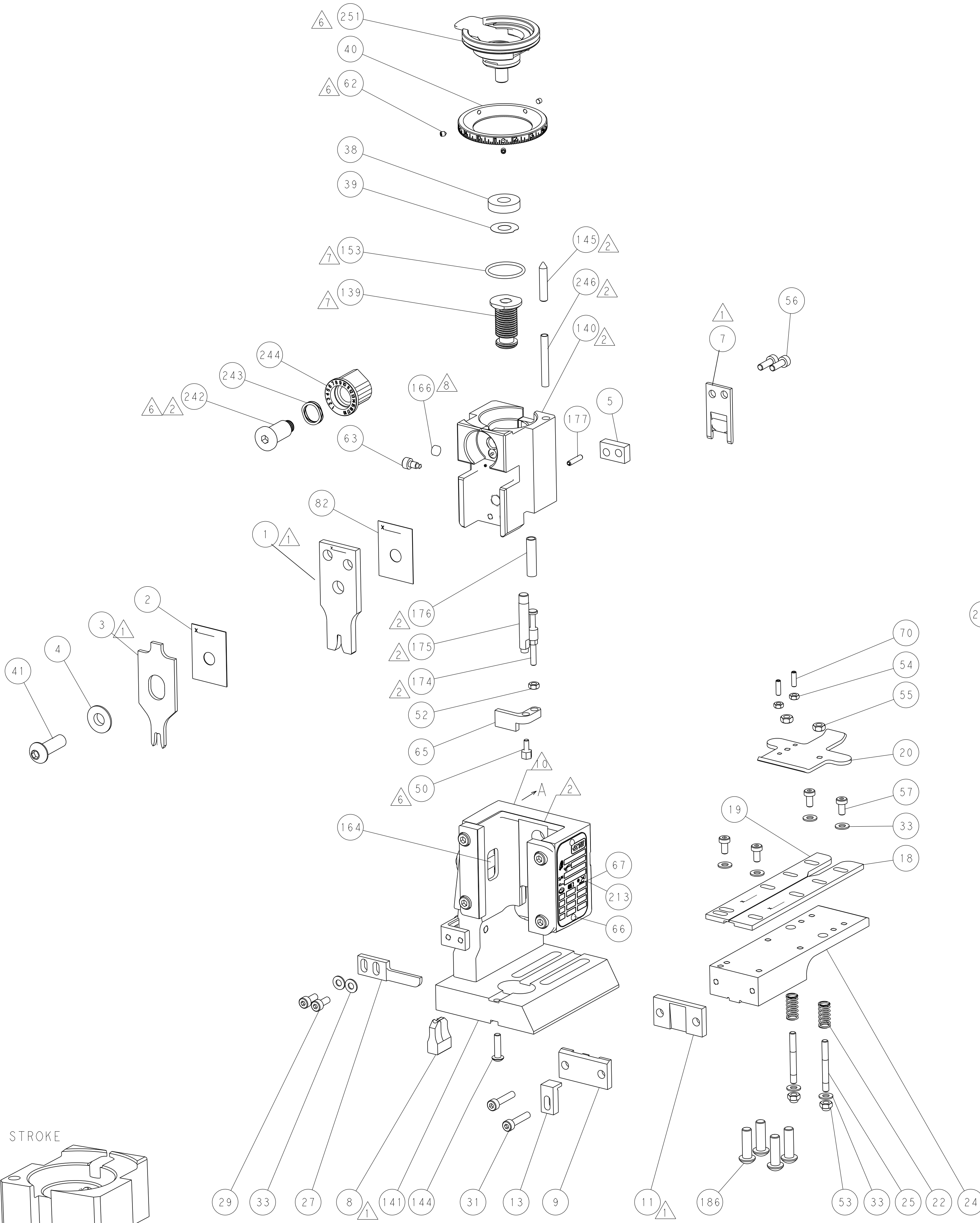
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FROM TFCO ELECTRONICS CORPORATION IT IS SUBJECT TO THE TERMS AND CONDITIONS OF THE PURCHASE ORDERIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 13FEB2013 CHK K. STAKEM 13FEB2013 ELBN 13FEB2013 APVD G. BAILEY 13FEB2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 2 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±.		NAME Ocean End Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL FINISH - -		WEIGHT -		CAGE CODE 00779	
		DRAWING NO C-2150257		RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:1 SHEET 2 OF 4 REV B	

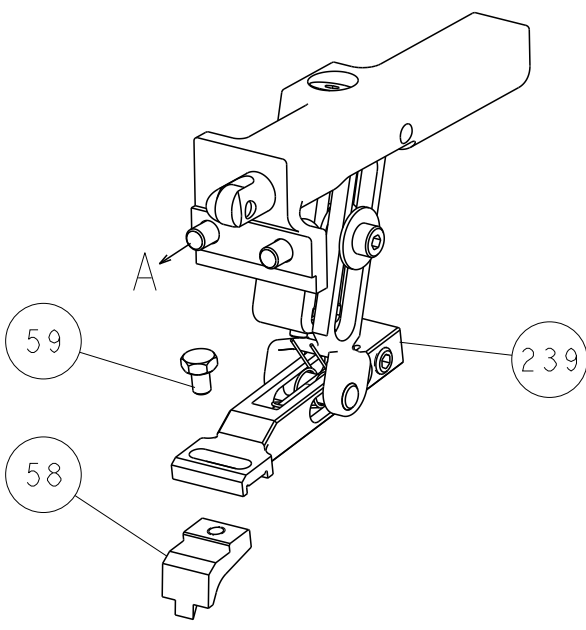
LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



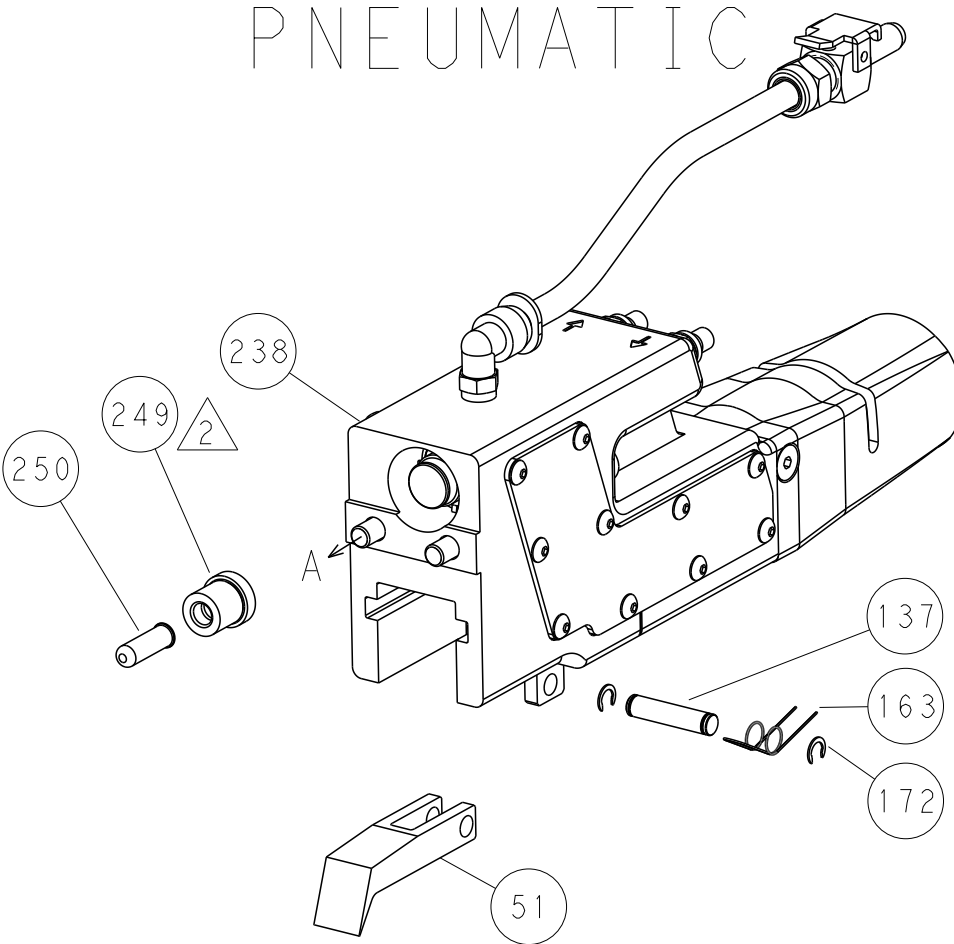
HOLDDOWN SET-UP



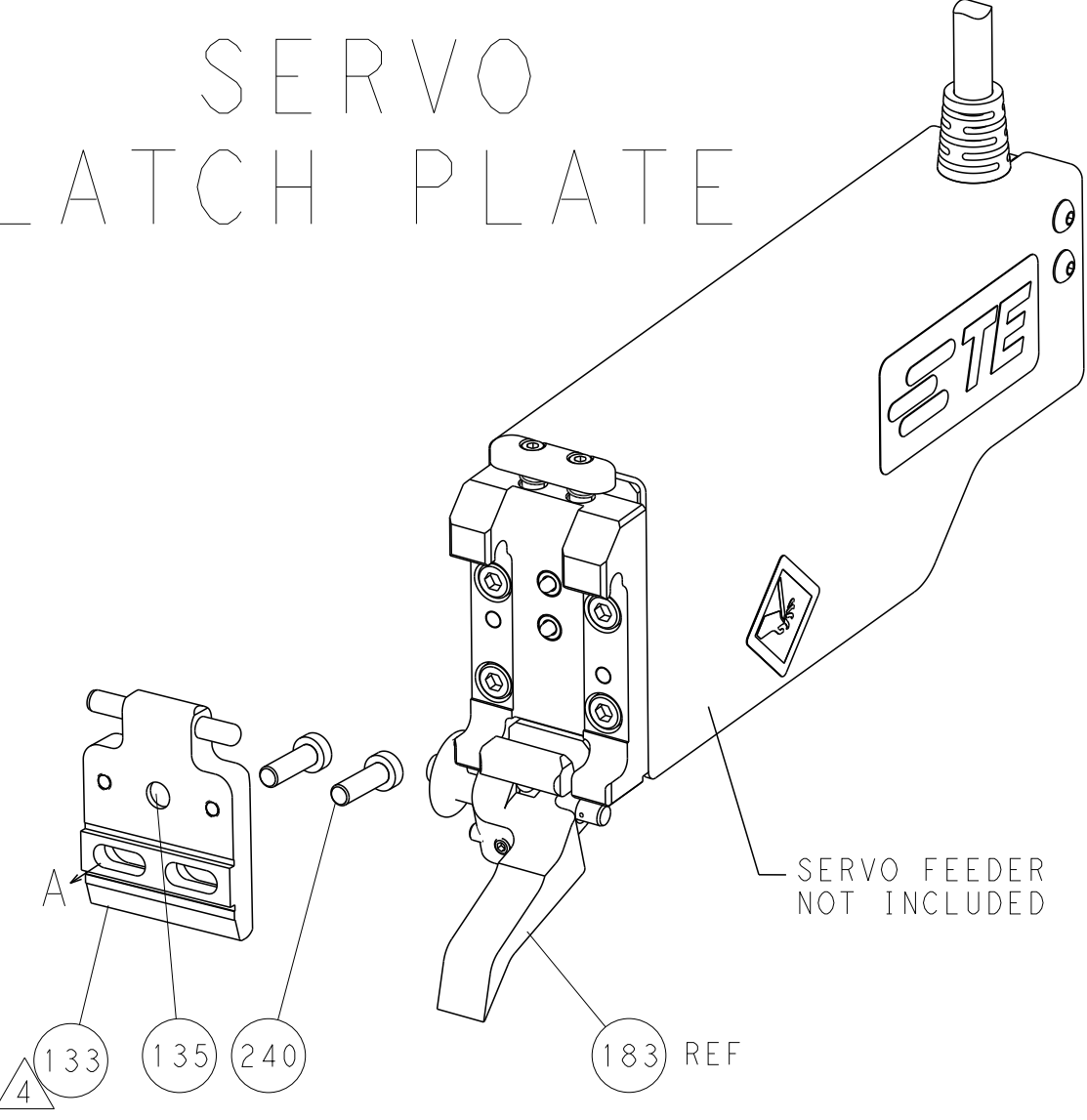
FEED TYPE
MECHANICAL



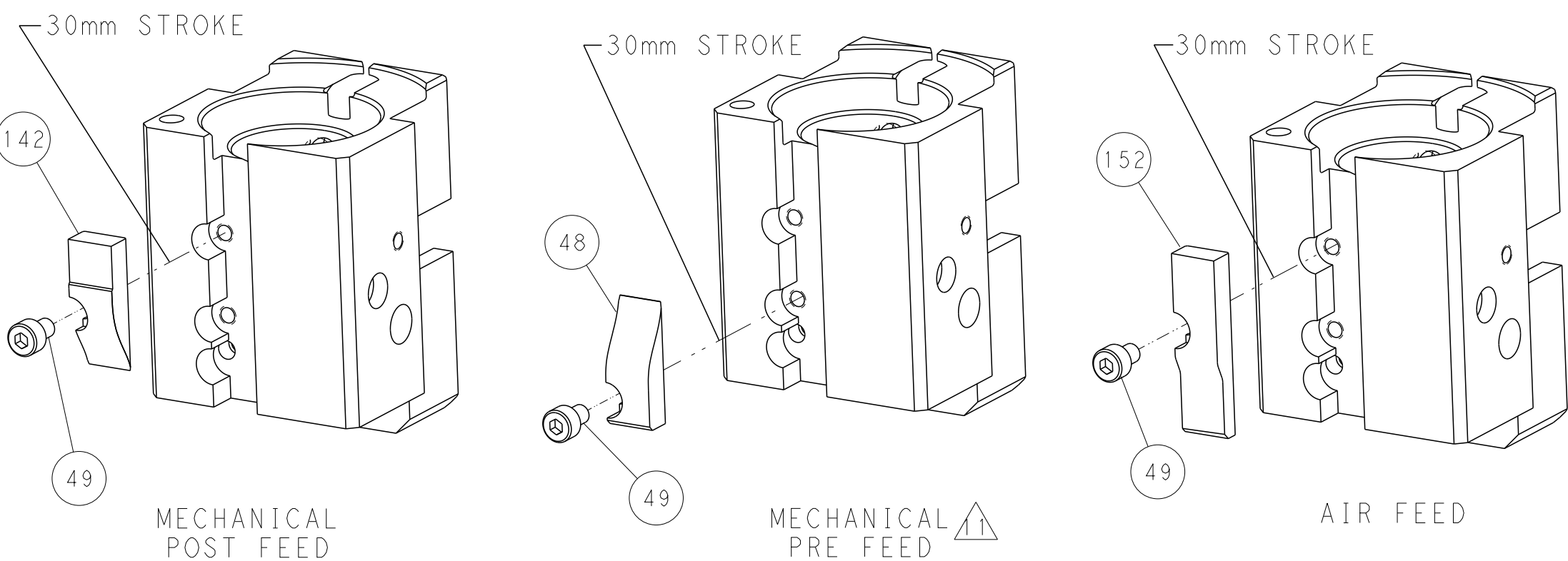
PNEUMATIC



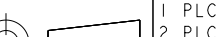
SERVO
LATCH PLATE



CAM POSITIONS



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

THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS LOANED TO YOUR COMPANY FOR YOUR COMPANY'S USE ONLY. IT IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED.										DWN		R. STANEM		13FEB2013		STE Connectivity Harrisburg, PA 17105-3608																	
										CHK		T. ELBIN		13FEB2013																			
										APVD		G. BAILEY		13FEB2013		NAME		Ocean End Feed Appliator															
										PRODUCT SPEC																							
										APPLICATION SPEC																							
										WEIGHT																							
										Customer Accessible Production Drawing																							
										SCALE																							
										SHEET																							
										REV																							
DIMENSIONS:										TOLERANCES UNLESS OTHERWISE SPECIFIED:										SIZE		A		CODE		DRAWING NO		RESTRICTED TO					
mm																																	
										0 P/LC ±.1																							
										1 P/LC ±.1																							
										2 P/LC ±.1																							
										3 P/LC ±.1																							
										4 P/LC ±.1																							
										ANGLES																							
MATERIAL										FINISH										A		00779		C=2150257		-							
-										-										-		-		-		-							
																				Customer Accessible Production Drawing		SCALE		1:1		SHEET		4 of 4		REV		B	