

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|---|-------------|--------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   |             |                          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|   | 2150082-1   | D                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-1 | -         | 2063440-1              |
|   | 2150082-2   | D                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150082-5 | -         | -         | 2168400-7 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150082-4 | -         | -         | -                      |
|   |             |                          |                          |                   | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-1 | -         | -                      |
|   | 2150082-5   | D                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150082-5 | -         | -         | 2168400-7 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150082-4 | -         | -         | -                      |
|   | 2150082-6   | D                        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-1 | -         | -                      |
| 2150082-7                                     | D           | FINE CRIMP HEIGHT ADJUST | PNEUMATIC FEED           |                   | 2119950-1                         | 2119792-2             | -         | 2119641-1   | -         | 2063440-1 |                        |
| 7-2150082-7                                   | A           | CRIMP TOOLING KIT        | -                        | -                 | -                                 | -                     | -         | -           | -         | -         |                        |

| APPLICATOR DATA             |                |      |
|-----------------------------|----------------|------|
| CRIMP                       | SIZE           | TYPE |
| WIRE                        | 2.29 mm [.090] | F    |
| INSUL                       | 3.30 mm [.130] | F    |
| APPL INSTRUCTIONS 408-10390 |                |      |

| TERMINAL DATA: TE TERMINAL                          |                              | TE CRIMP SPECIFICATION |                |
|---|------------------------------|------------------------|----------------|
| TERMINAL NAME: FASTON CONNECTOR .250 SR REC CONTACT |                              |                        |                |
| WIRE STRIP LENGTH                                   | INSULATION DIAMETER RANGE    |                        |                |
| SEE APPL. SPEC.                                     | Ø2.30-3.30 mm [.091-.130 IN] |                        |                |
| TERMINAL APPLICATION SPECIFICATION                  | (A)114-19025                 | -                      | -              |
|   | (B)114-20023                 | -                      | -              |
| TERMINALS APPLIED                                   |                              |                        |                |
| TE TERMINAL   | TE TERMINAL                  | TE TERMINAL            | TE TERMINAL    |
| (A) 100495-1  | (A) 100495-2                 | (A) 100495-4           | (B) 5-160432-3 |
| (B) 5-160432-4                                      | (B) 5-160432-5               | (B) 5-160432-7         | (B) 6-160432-0 |
| (B) 6-160432-3                                      | (B) 6-160432-4               | (B) 7-160432-0         | (B) 160744-1   |
| (B) 160769-1  | (B) 160807-2                 |                        |                |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 1.50mm2   | 1.65 +/- 0.05 [.065 +/- .002] | 3.2                            |
| 1.00mm2   | 1.60 +/- 0.05 [.063 +/- .002] | 3.7                            |
| 0.75mm2   | 1.50 +/- 0.05 [.059 +/- .002] | 4.7                            |
| 0.50mm2   | 1.45 +/- 0.05 [.057 +/- .002] | 5.2                            |

- 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: 8-2150082-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150082-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150082-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150082-6
- 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 ONLLY 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

**\*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     |

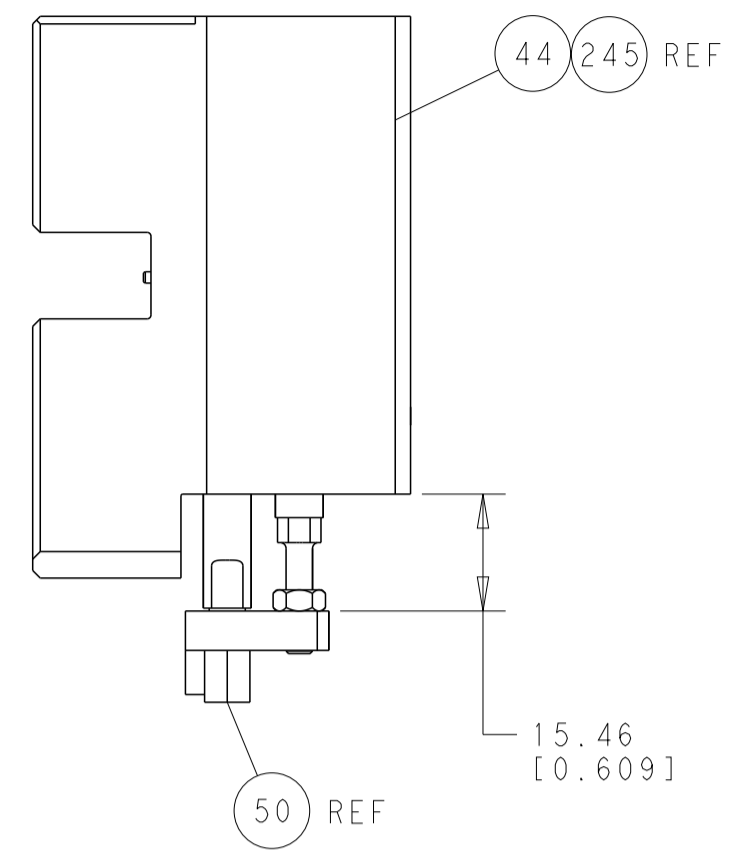
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS |     |               |           |     |      |
|--------------|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-2    | A   | 66   | P         | LTN | DESCRIPTION   | DATE      | DWN | APVD |
|              |     |      | D         |     | ECR-15-000168 | 06JAN2015 | MR  | GB   |

|   |        |        |        |        |        |             |                                      |     |
|---|--------|--------|--------|--------|--------|-------------|--------------------------------------|-----|
| - | -      | 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      | 455888-5    | SPACER, CRIMPER                      | 82  |
| - | 1      | 1      | 1      | 1      | 1      | 2119791-9   | DEPRESSOR, WIRE                      | 73  |
| - | 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      | 2063961-1   | 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      | 1-1752354-2 | 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      | 1752371-5   | PLATE, STRIP GUIDE                   | 24  |
| - | 2      | 2      | 2      | 2      | 2      | 2-22281-3   | SPRING, COMPRESSION                  | 22  |
| - | 1      | 1      | 1      | 1      | 1      | 1752373-1   | DRAG                                 | 20  |
| - | 1      | 1      | 1      | 1      | 1      | 1803152-1   | STRIP GUIDE, REAR                    | 19  |
| - | 1      | 1      | 1      | 1      | 1      | 1803151-1   | 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      | 240644-1    | PLATE, REAR SHEAR                    | 11  |
| - | -      | -      | -      | -      | -      | -           | -                                    | 10  |
| - | 1      | 1      | 1      | 1      | 1      | 690482-3    | PLATE, FRONT SHEAR                   | 9   |
| - | 1      | 1      | 1      | 1      | 1      | 1333217-1   | ANVIL, EF .090                       | 8   |
| - | 1      | 1      | 1      | 1      | 1      | 690474-9    | BLADE, SLUG                          | 7   |
| - | 1      | 1      | 1      | 1      | 1      | 6-240641-5  | SPACER                               | 5   |
| - | 1      | 1      | 1      | 1      | 1      | 238009-1    | BLOCK, FL CRIMPER SPACER             | 4   |
| - | 1      | 1      | 1      | 1      | 1      | 2-1633961-6 | CRIMPER, INSULATION F PREMIUM        | 3   |
| - | 1      | 1      | 1      | 1      | 1      | 455888-6    | SPACER, CRIMPER                      | 2   |
| - | 1      | 1      | 1      | 1      | 1      | 4-456406-5  | CRIMPER, WIRE PREMIUM                | 1   |

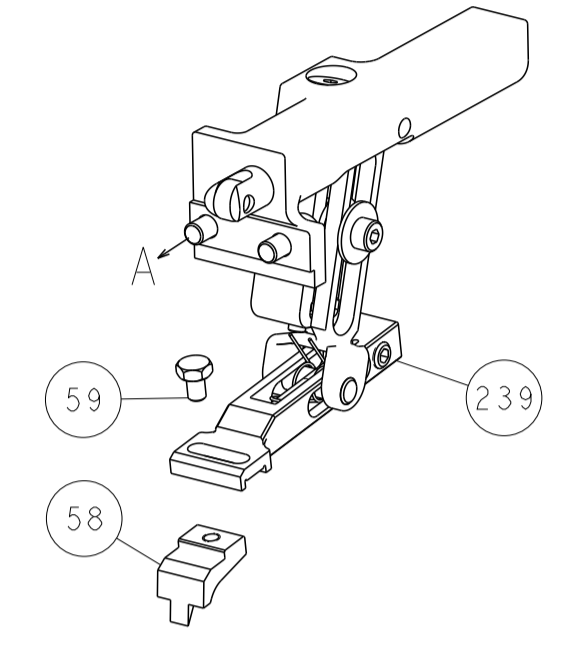
| DIMENSIONS: | TOLERANCES UNLESS OTHERWISE SPECIFIED:   | DWN          | DATE             | NAME   |
|-------------|--|--------------|------------------|--------|
| mm          | 0 PLC ±.5<br>1 PLC ±.5<br>2 PLC ±.5<br>3 PLC ±.5<br>4 PLC ±.5<br>ANGLES ±.0001 | C. CHEN      | 14FEB2012        | S. XI  |
|             |  | J. CRUZ      | 14FEB2012        |        |
| MATERIAL:   | FINISH:  | PRODUCT SPEC | APPLICATION SPEC | SIZE   |
|             |  |              |                  | 00779  |
|             |  | WEIGHT       | SCALE            | 1:1    |
|             |  |              | SHEET            | 1 of 4 |
|             |  |              | REV              | D      |

| LOC | DIST | REV | DESCRIPTION | DATE | OWN | APVD |
|-----|------|-----|-------------|------|-----|------|
| A   | 66   |     | SEE SHEET 1 |      |     |      |

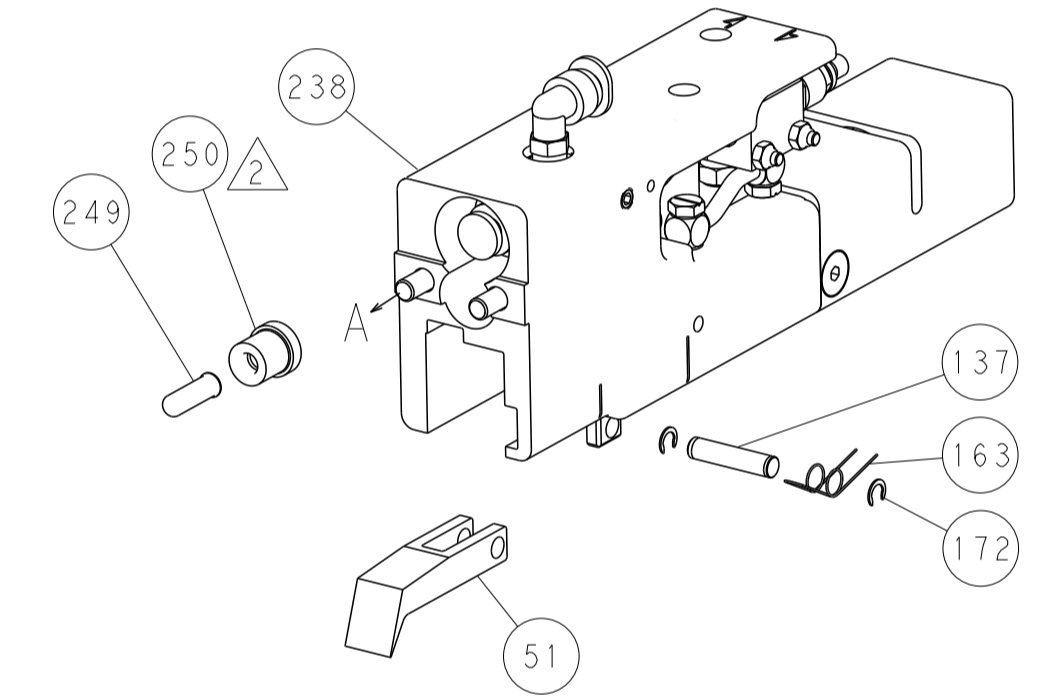


HOLDDOWN SET-UP

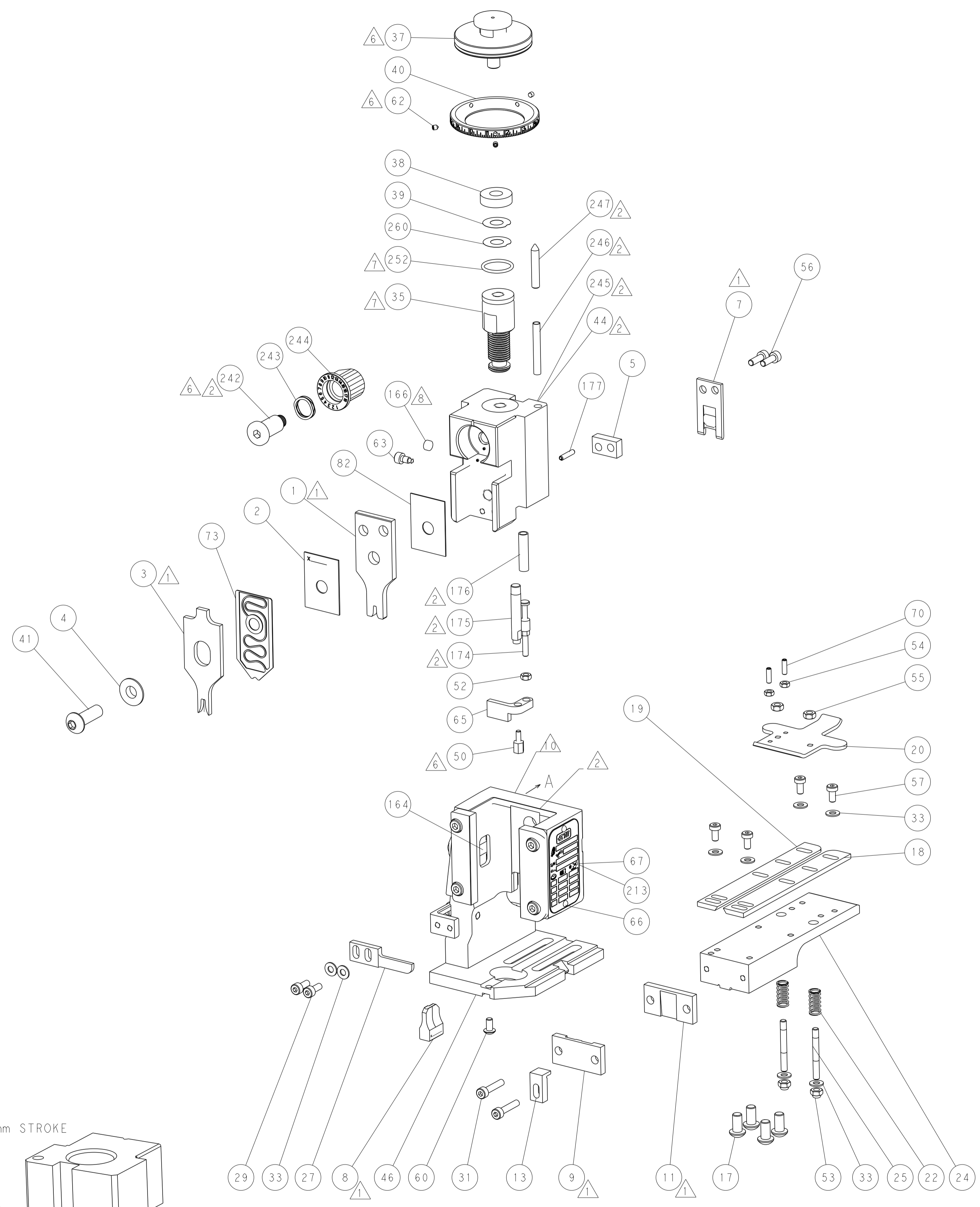
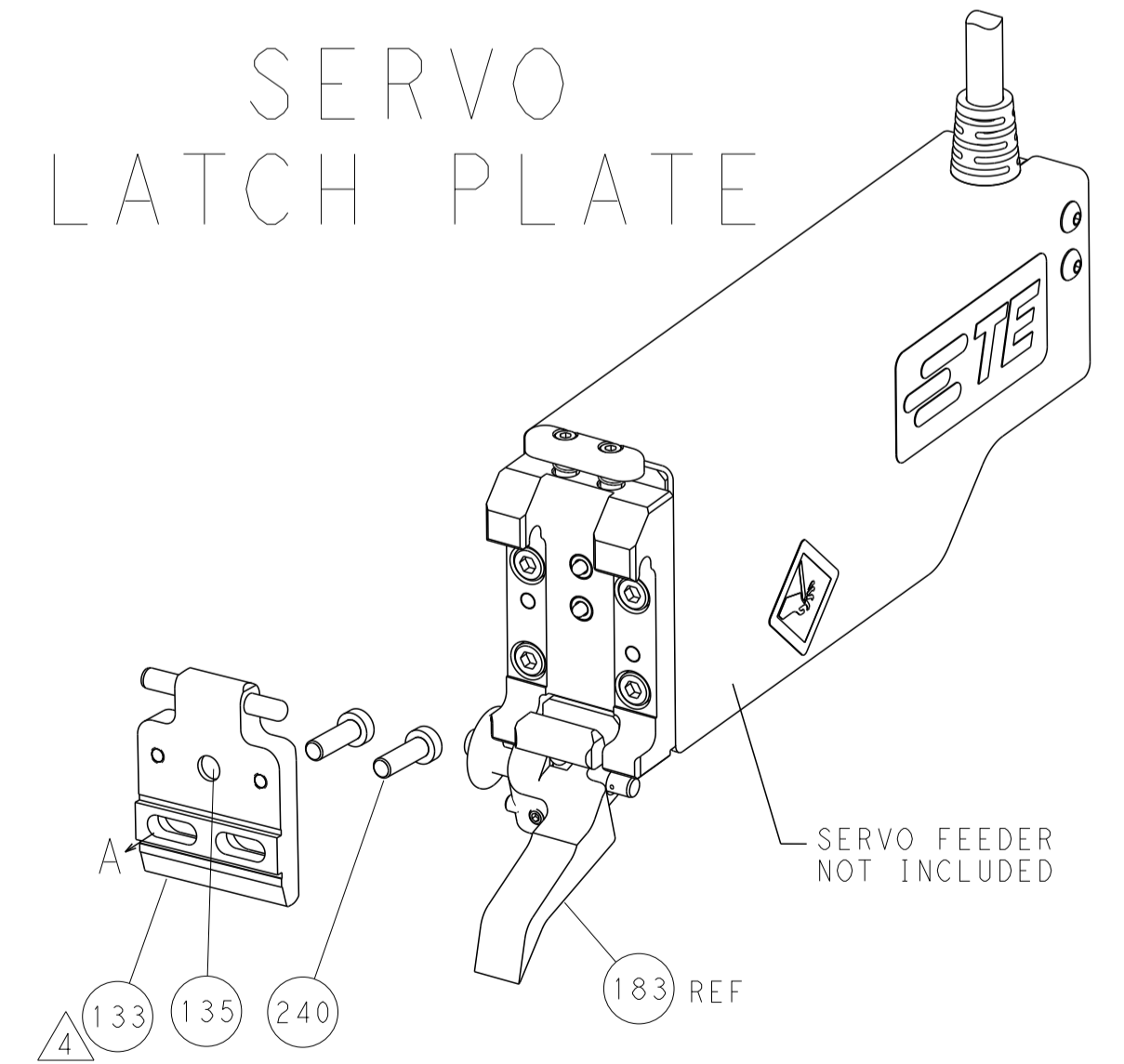
FEED TYPE  
MECHANICAL



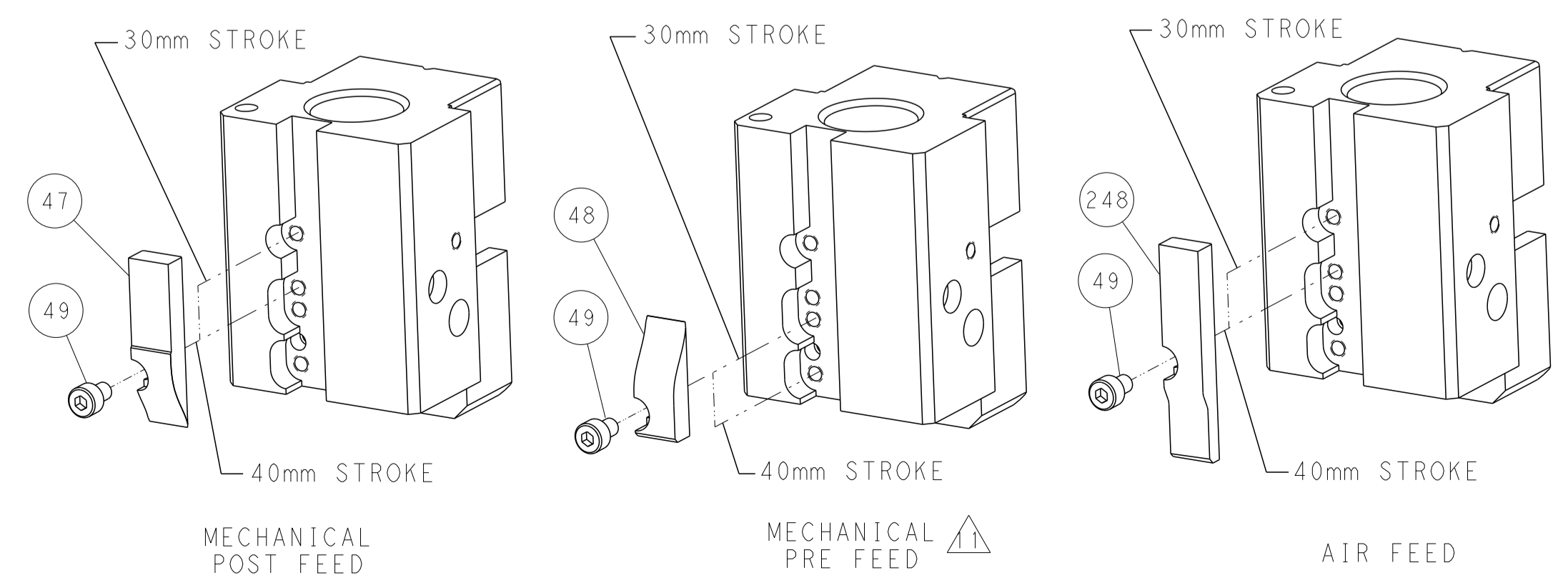
PNEUMATIC



SERVO  
LATCH PLATE



CAM POSITIONS

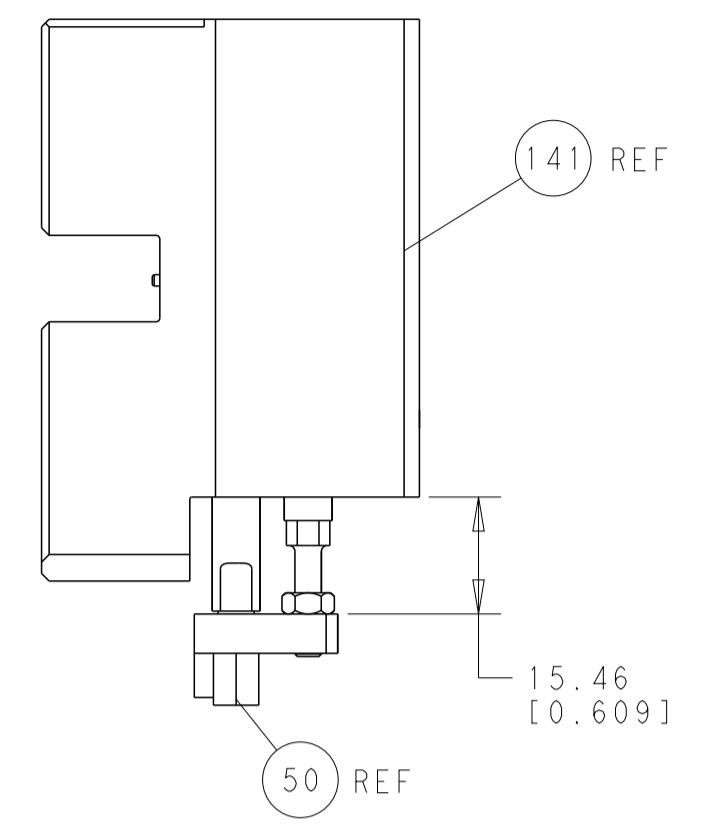


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

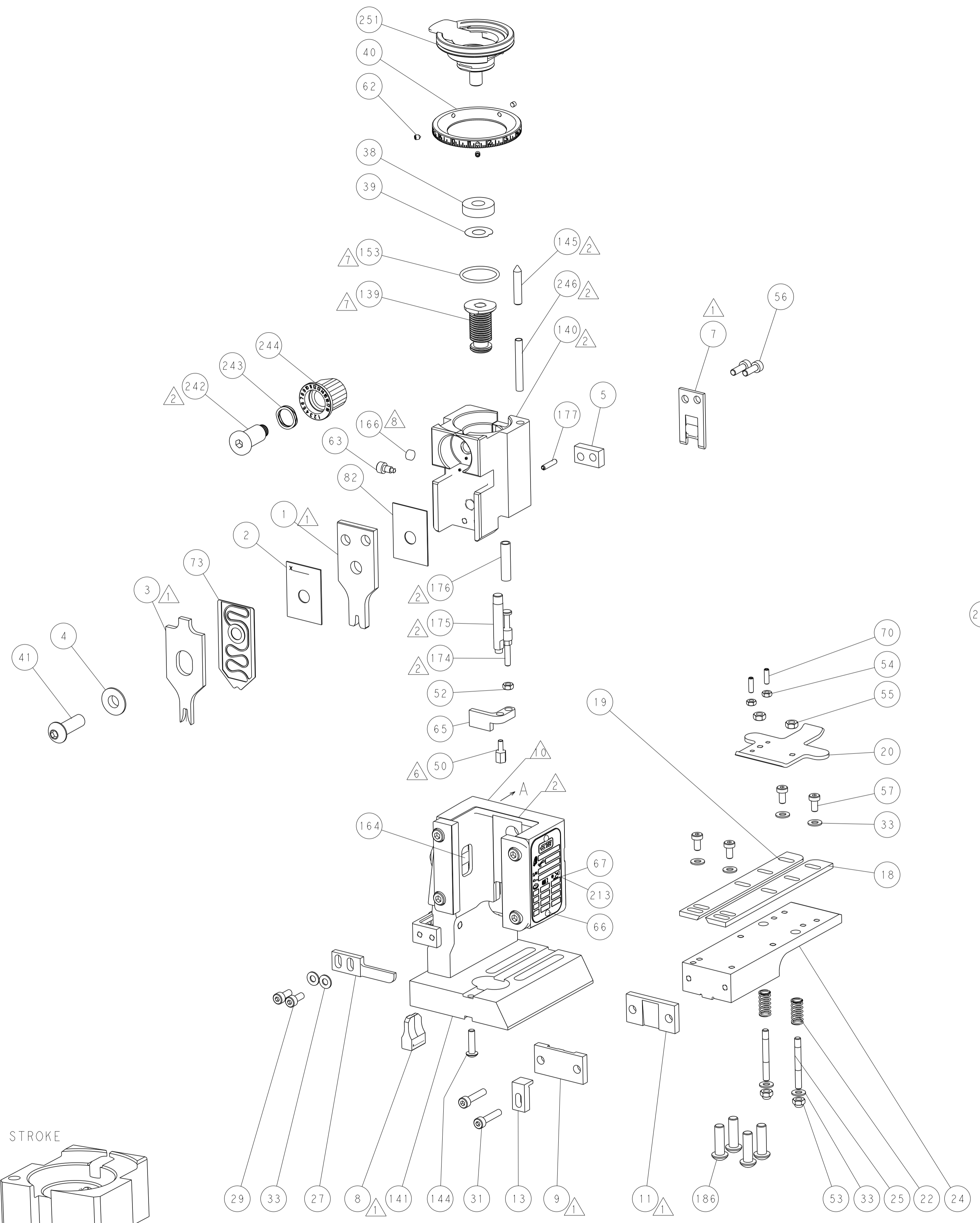
|                       |  |   |  |   |  |  |  |
|-----------------------|--|---|--|---|--|--|--|
| DIMENSIONS:<br>mm<br> |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.5<br>1 PLC ±0.5<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.001<br>ANGLES ±.0001<br>FINISH |  | DWN C. CHEN 14FEB2012<br>CHK S. XI 14FEB2012<br>APVD J. CRUZ 14FEB2012<br>PRODUCT SPEC<br>APPLICATION SPEC<br>WEIGHT<br>SCALE 1:1 |  | NAME Ocean End Feed Applicator<br>SIZE CAGE CODE DRAWING NO. A1 00779 C=2150082<br>RESTRICTED TO<br>SHEET 2 OF 4 REV D |  |
|-----------------------|--|---|--|---|--|--|--|



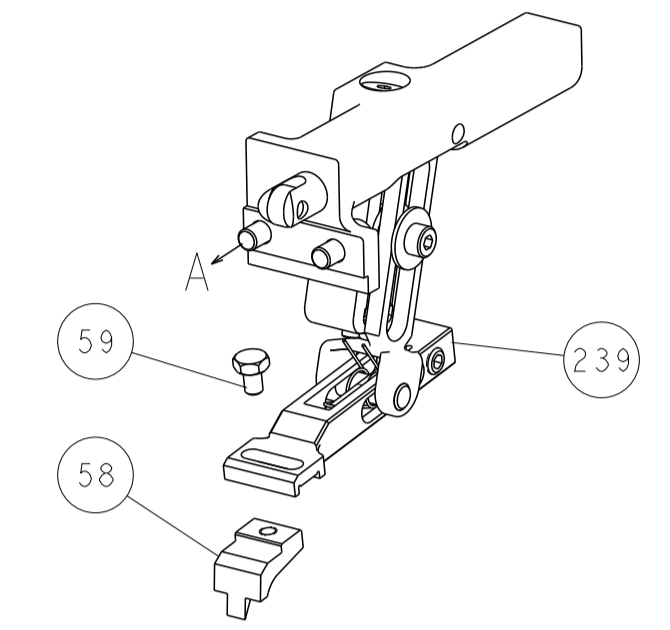
| LOC | DIST | REVISIONS   |      |    |      |
|-----|------|-------------|------|----|------|
| A   | 66   | REV         | DATE | BY | APPV |
|     |      | SEE SHEET 1 |      |    |      |



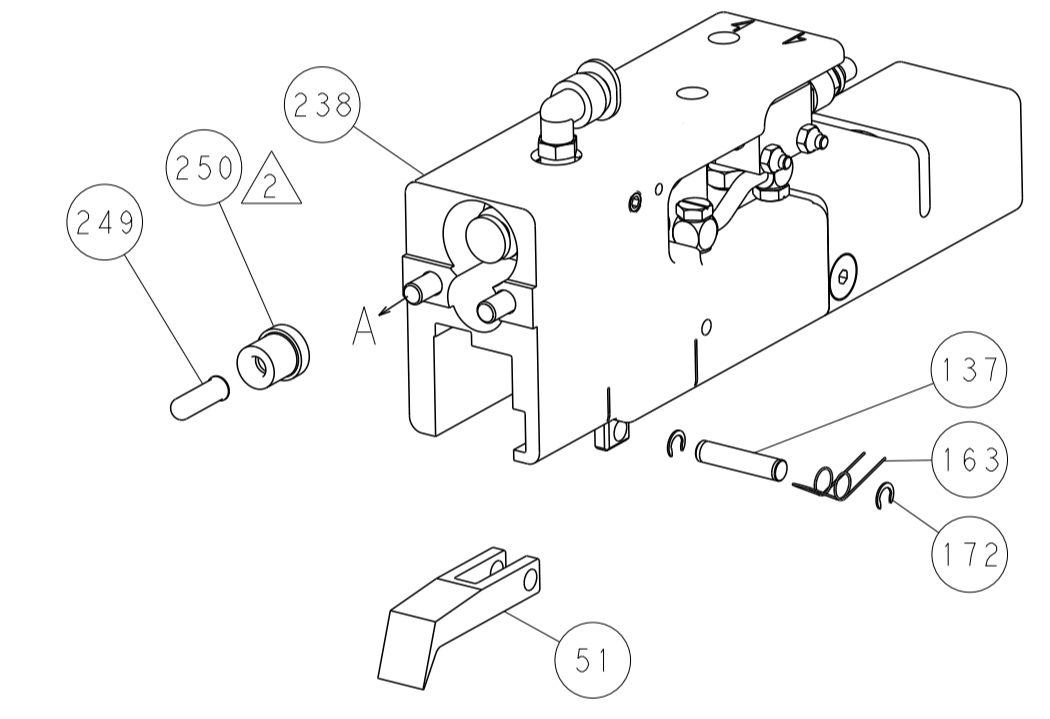
HOLDDOWN SET-UP



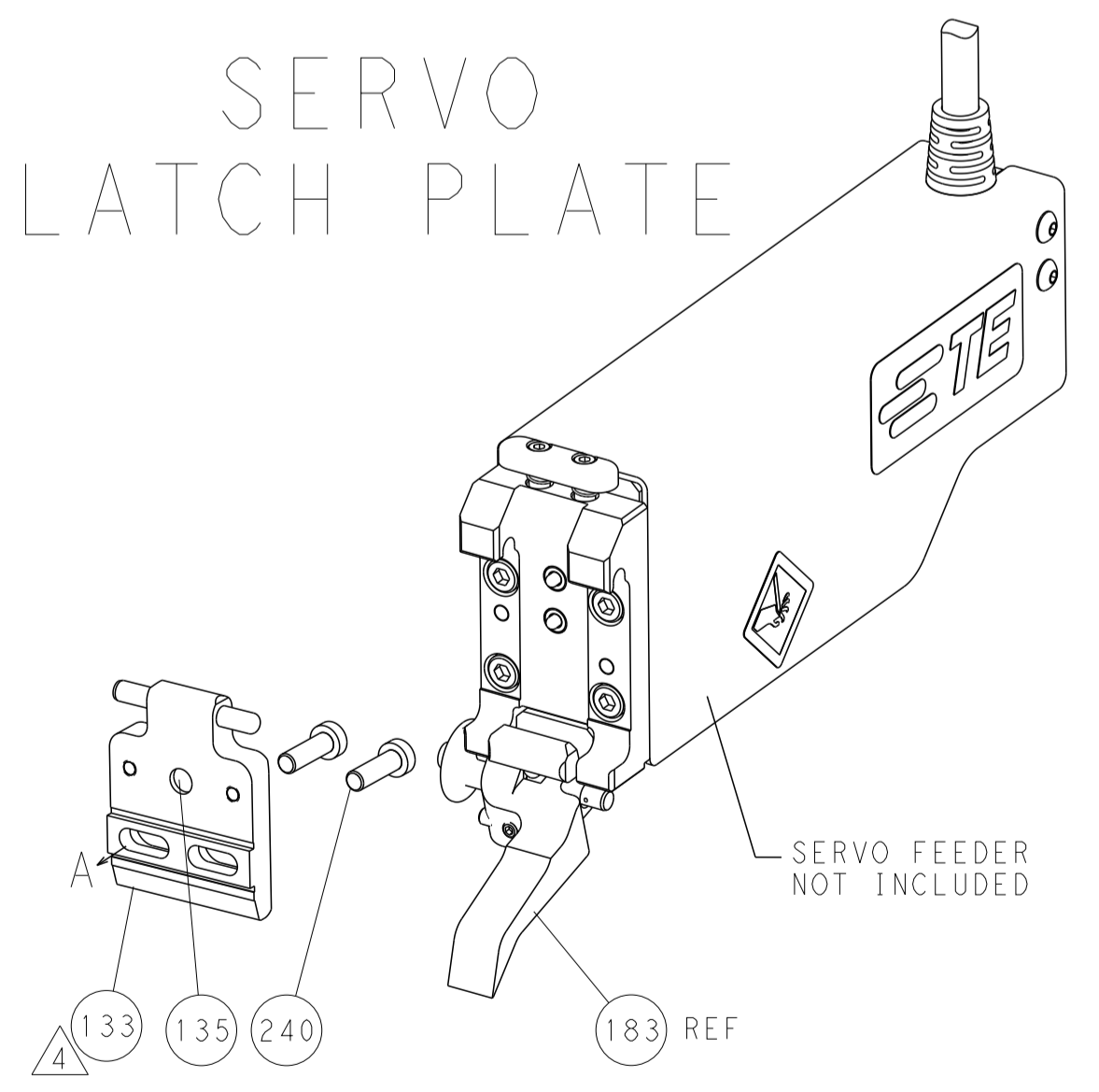
FEED TYPE  
MECHANICAL



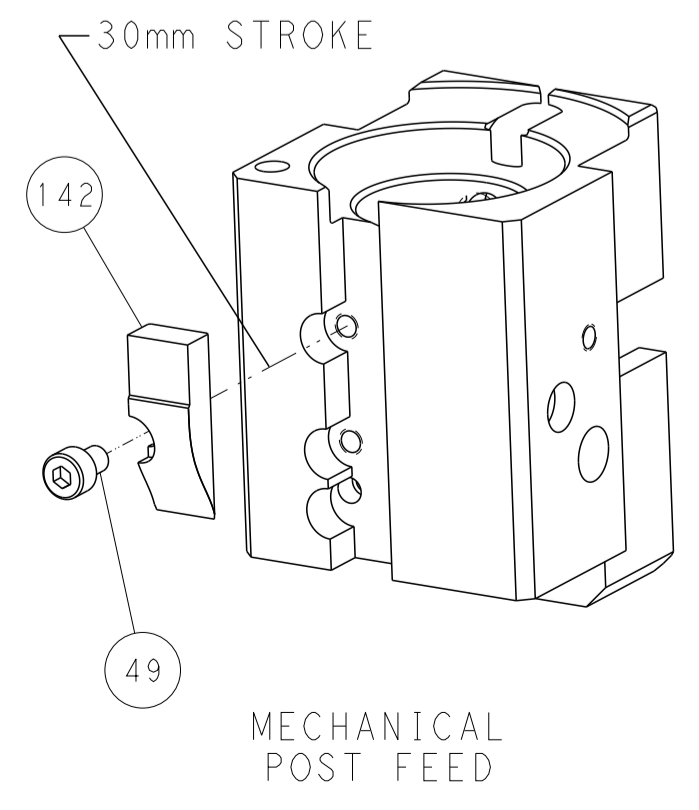
PNEUMATIC



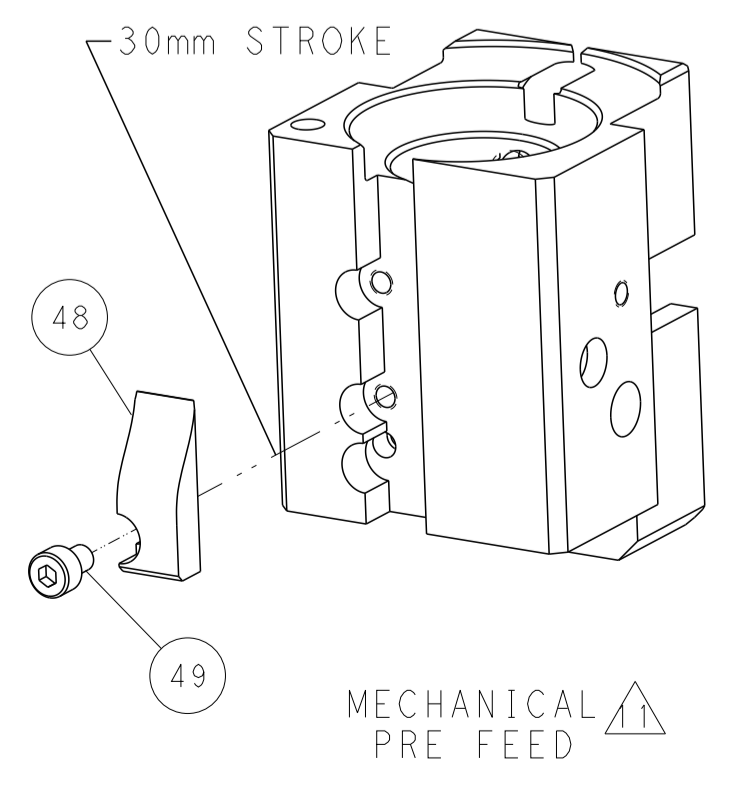
SERVO LATCH PLATE



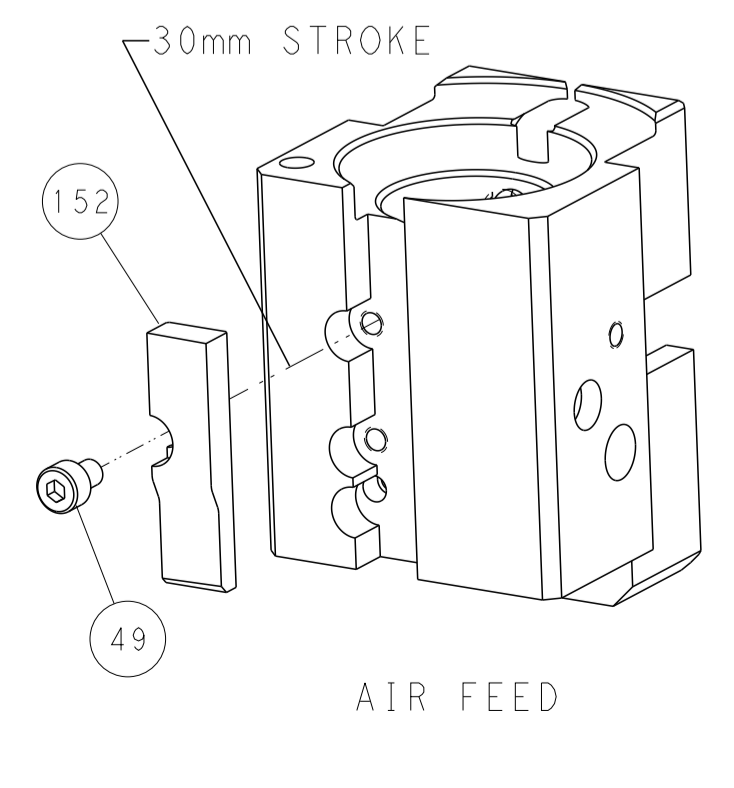
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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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| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±0.5<br>1 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.001<br>ANGLES FINISH ±0.001  |  | PRODUCT SPEC:<br>APPLICATION SPEC:<br>WEIGHT: | SCALE: 1:1<br>SHEET 4 OF 4<br>REV D                   | RESTRICTED TO:                                     |
| MATERIAL:  |  | CUSTOMER ACCESSIBLE PRODUCTION DRAWING        | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2150082 | CUSTOMER ACCESSIBLE PRODUCTION DRAWING             |