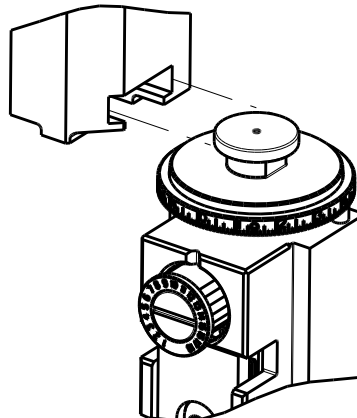
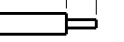


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150401-1	A	FINE CRIMP HEIGHT ADJUST
	2150401-2	A	FINE CRIMP HEIGHT ADJUST
	2150401-5	A	FINE CRIMP HEIGHT ADJUST
	2150401-6	A	NON-CRIMP HEIGHT ADJUST
	2150401-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150401-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 (6.3) SERIES FLAG POS. LOCK			
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]		 INSULATION DIAMETER RANGE Ø2.20-3.30 mm [.087-.130 IN]	
TERMINAL APPLICATION SPECIFICATION 	(A) 114-20083	-	-
	(B) 114-20080	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 926820-1	(A) 926820-4	(A) 926820-7	
(A) 926820-2	(A) 926820-5	(A) 926820-8	
(A) 926820-3	(A) 926820-6	(B) 282349-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.50mm2		1.60+/-0.03 [.063+/- .001]		5.7
1.00mm2		1.45+/-0.03 [.057+/- .001]		7.3
0.75mm2		1.35+/-0.03 [.053+/- .001]		9.0
0.50mm2		1.27+/-0.03 [.050+/- .001]		10.3



- 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. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150401-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150401-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150401-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150401-6
- 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 62 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
- 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.
- 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.

-	-	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
-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)

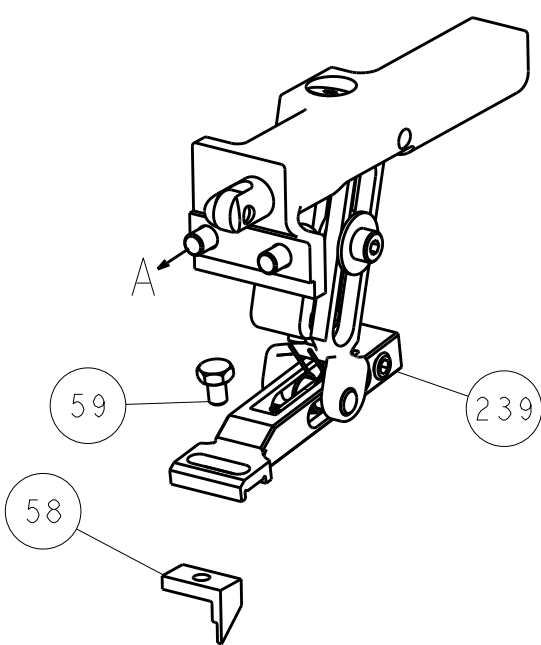
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS				
			P	LTR	DESCRIPTION	DATE	OWN
				A	RELEASED	09MAT2014	LG

-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2161315-1	RAM, STEPPED, AMP STYL, EF, NON-ADJUST	245
-	1	1	1	1	1	2119082-7	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
-	-	-	-	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
-	3	3	3	3	3	1-18028-2	WASHER, FLAT, REG M4	109
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	105
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	104
-	2	2	2	2	2	1-2079383-6	SCR, BHSC, RoHS (M4 X 10)	93
-	2	2	2	2	2	2168083-4	SCR, SKT HD CAP, RoHS, M5 X 10.0	89
-	2	2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	86
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	85
-	1	1	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	83
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 25	80
-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	224716-6	PAWL, FEED	58
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	51
-	-	-	-	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	1-2119655-9	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	1	1	1	2161310-1	RAM, STEPPED, 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	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
-	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	33
-	1	1	1	1	1	2217981-1	BLOCK, BASE	32
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	28
-	1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	1	1	1	1	1	2217982-1	PLATE, STRIP GUIDE	24
-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1	240792-1	DRAG, TERMINAL	20
-	1	1	1	1	1	662657-1	STRIP, GUIDE, REAR	19
-	1	1	1	1	1	690438-1	FRONT STRIP GUIDE	18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	14
-	1	1	1	1	1	2217983-1	PLATE, SHEAR	13
-	1	1	1	1	1	6-22279-4	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-6	STOP, SHEAR	11
-	-	-	-	-	-	-	-	10
-	1	1	1	1	1	662631-1	SHEAR, FLOATING	9
-	1	1	1	1	1	2217984-1	ANVIL	8
-	1	1	1	1	1	662630-1	BLADE, FRONT SLUG	7
-	1	1	1	1	1	662632-2	DEPRESSOR, SHEAR	6
-	1	1	1	1	1	662630-2	BLADE, FRONT SLUG	5
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1	1	1	456407-8	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

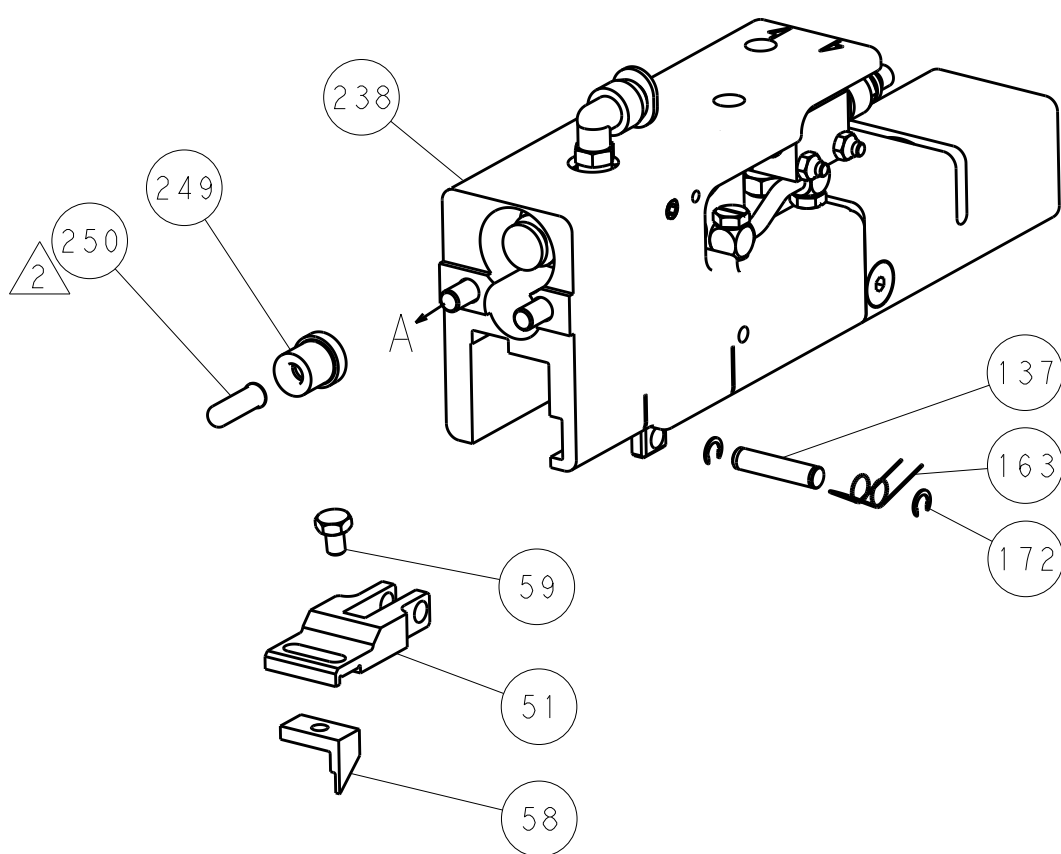
THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS OF THIS DRAWING.				OWN A. STAKEM 20JAN2014	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK G. BAILEY 20JAN2014	NAME Ocean End Feed Applicator			
				APVD T. ELBIN 20JAN2014	PRODUCT SPEC			
					APPLICATION SPEC			
MATERIAL :					WEIGHT :			
					Customer Accessible Production Drawing			
					SCALE 1:1			
					SHEET 1 OF 4			
					REV A			

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

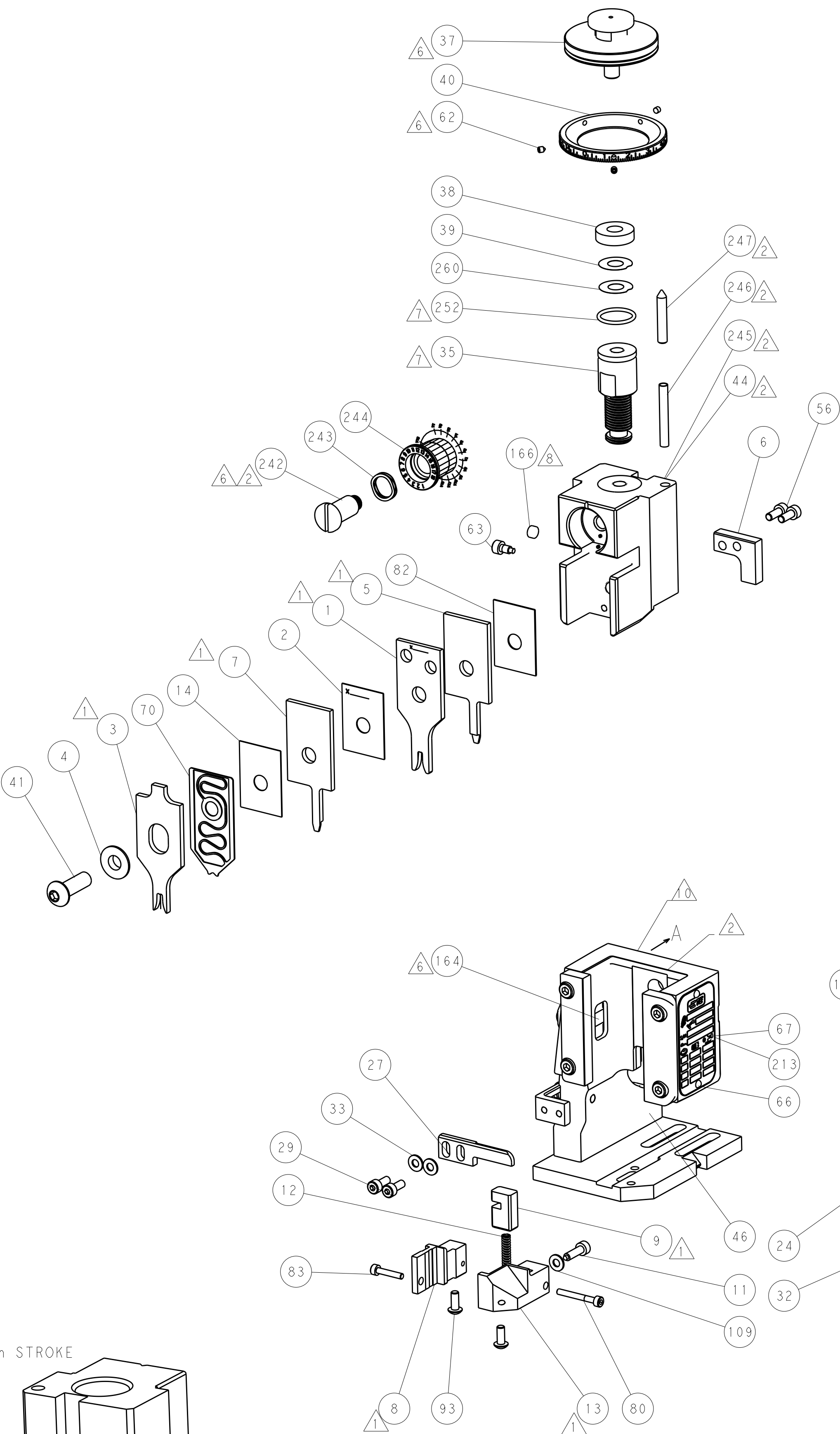
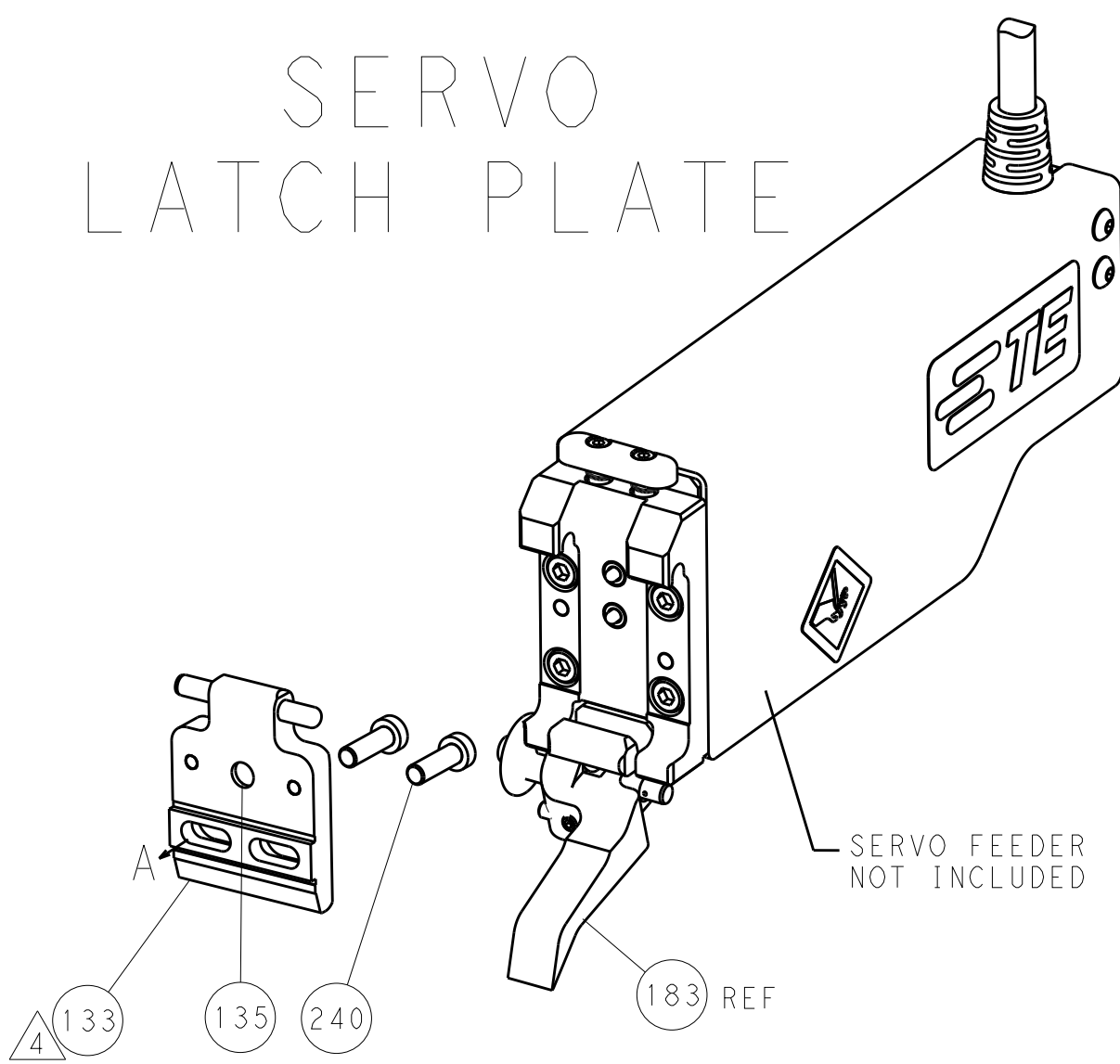
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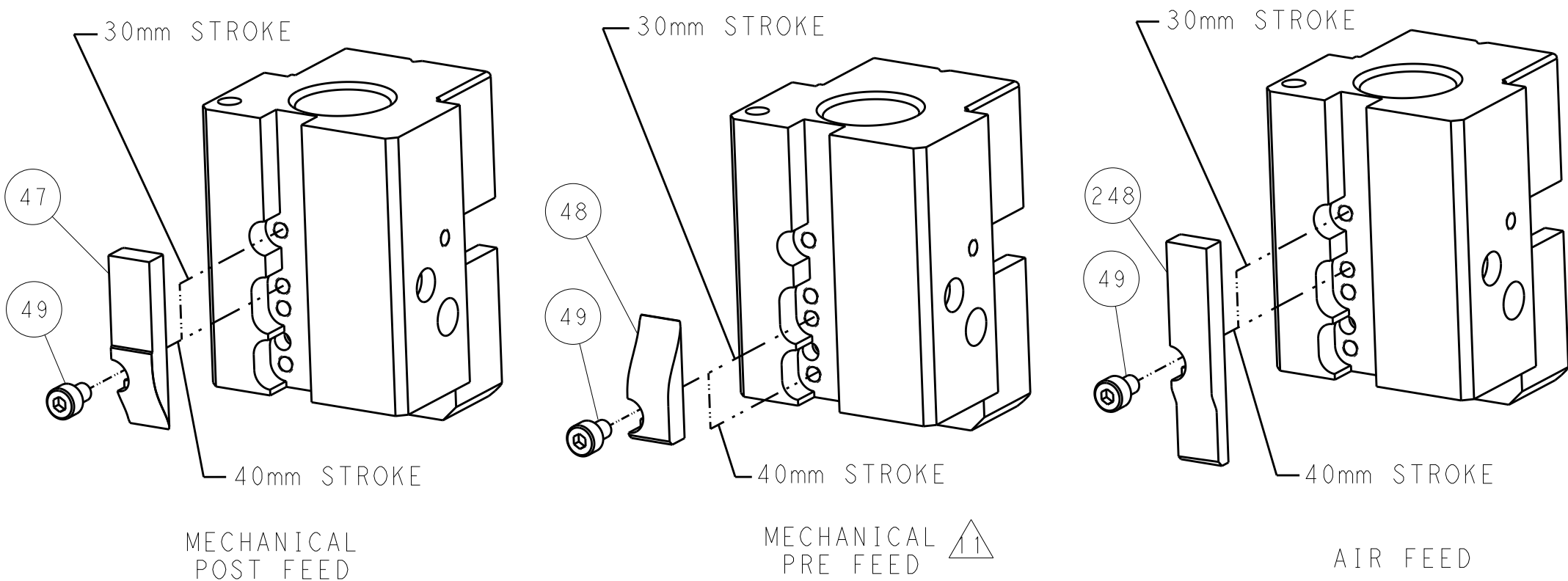
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS

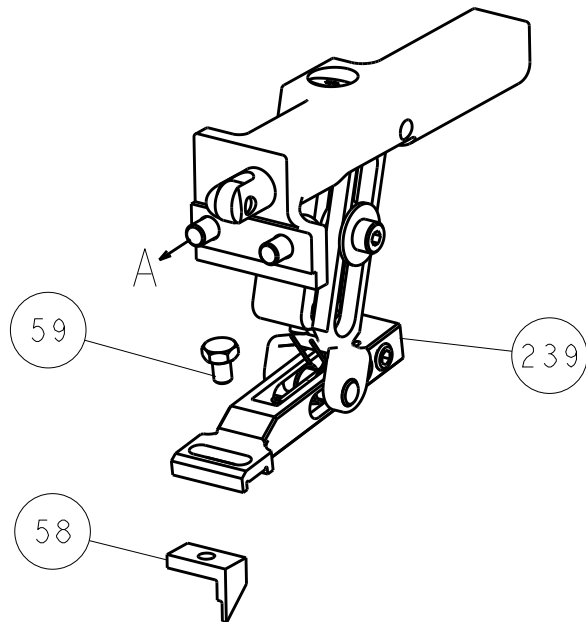


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

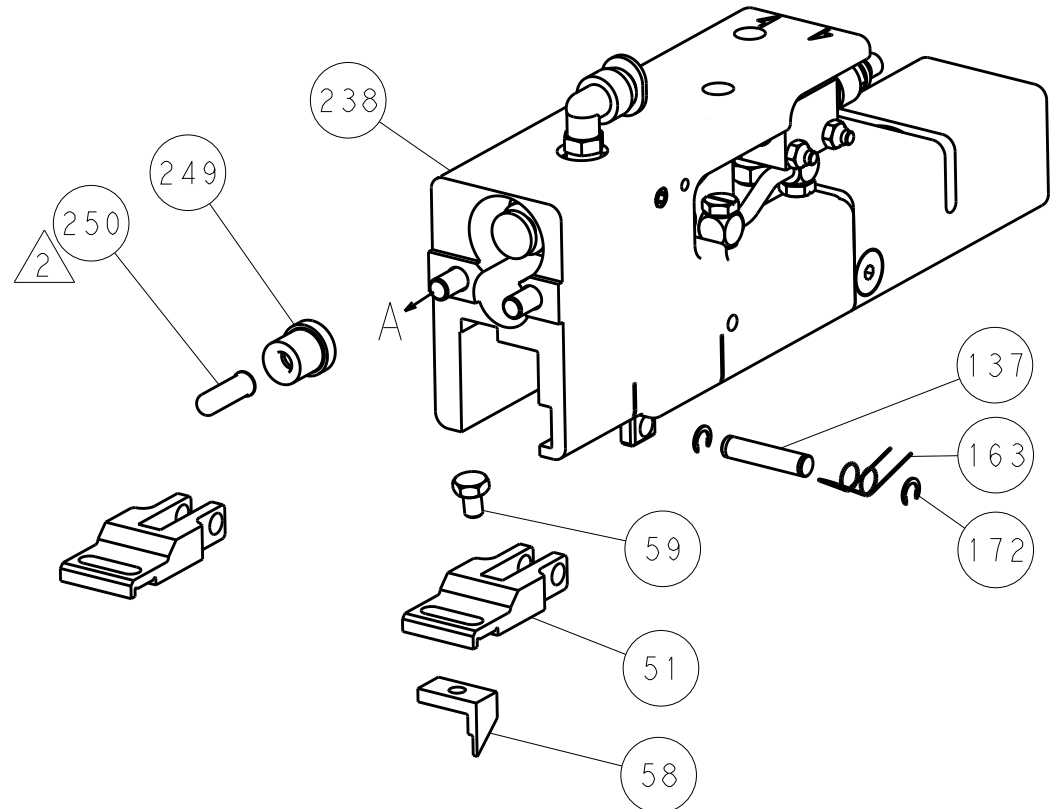
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.				OWN: K. STANEM 20JAN2014 CHK: G. BAILEY 20JAN2014 APVD: T. ELBIN 20JAN2014				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.0001				NAME: Ocean End Feed Applicator			
MATERIAL: -				FINISH: -				SIZE: A11 00779 C=2150401			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET 2 OF 4 REV A			

LOC		DIST		REVISIONS			
A		66		REV	DESCRIPTION	DATE	APPROV
				-	SEE SHEET 1	-	-

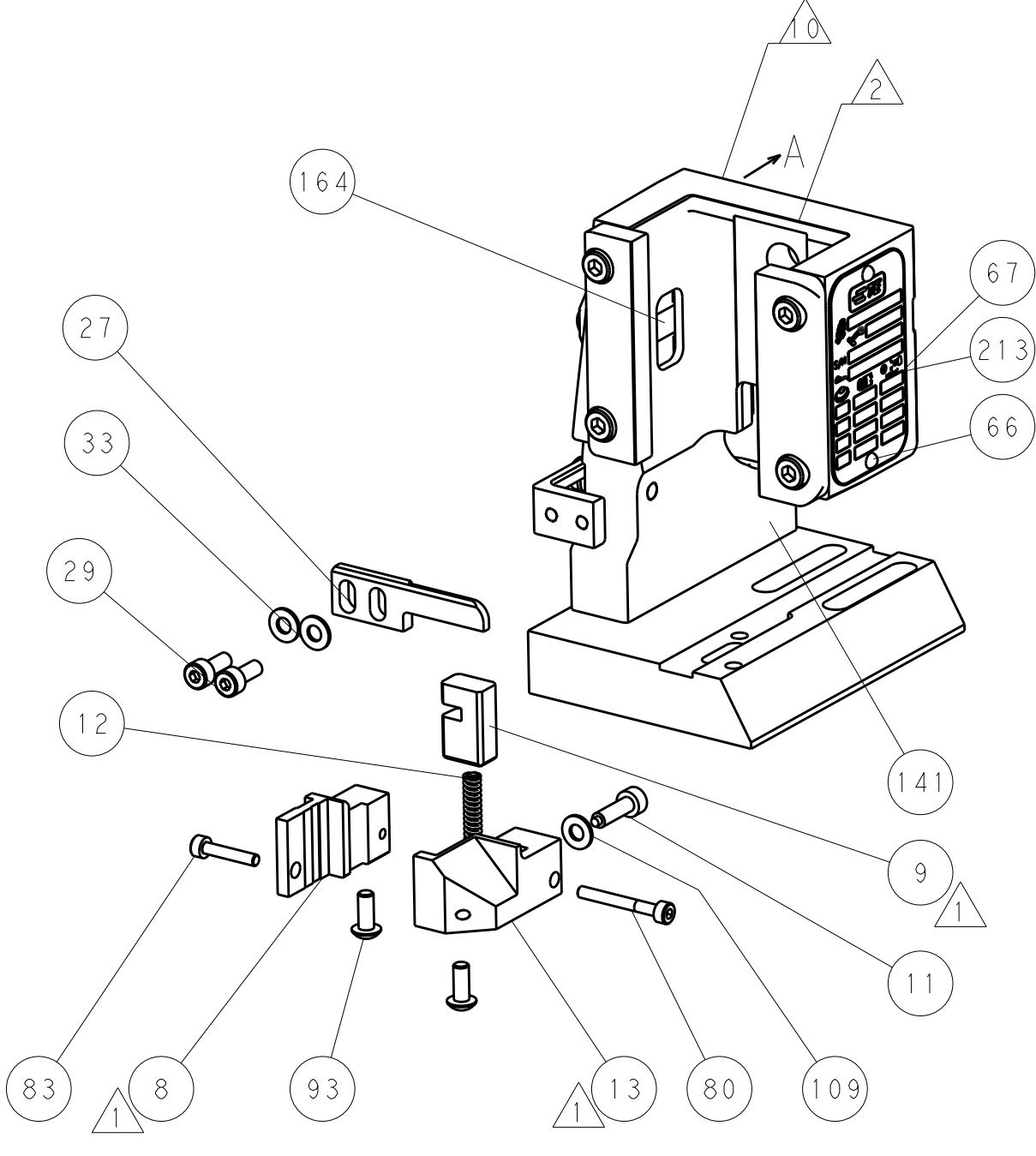
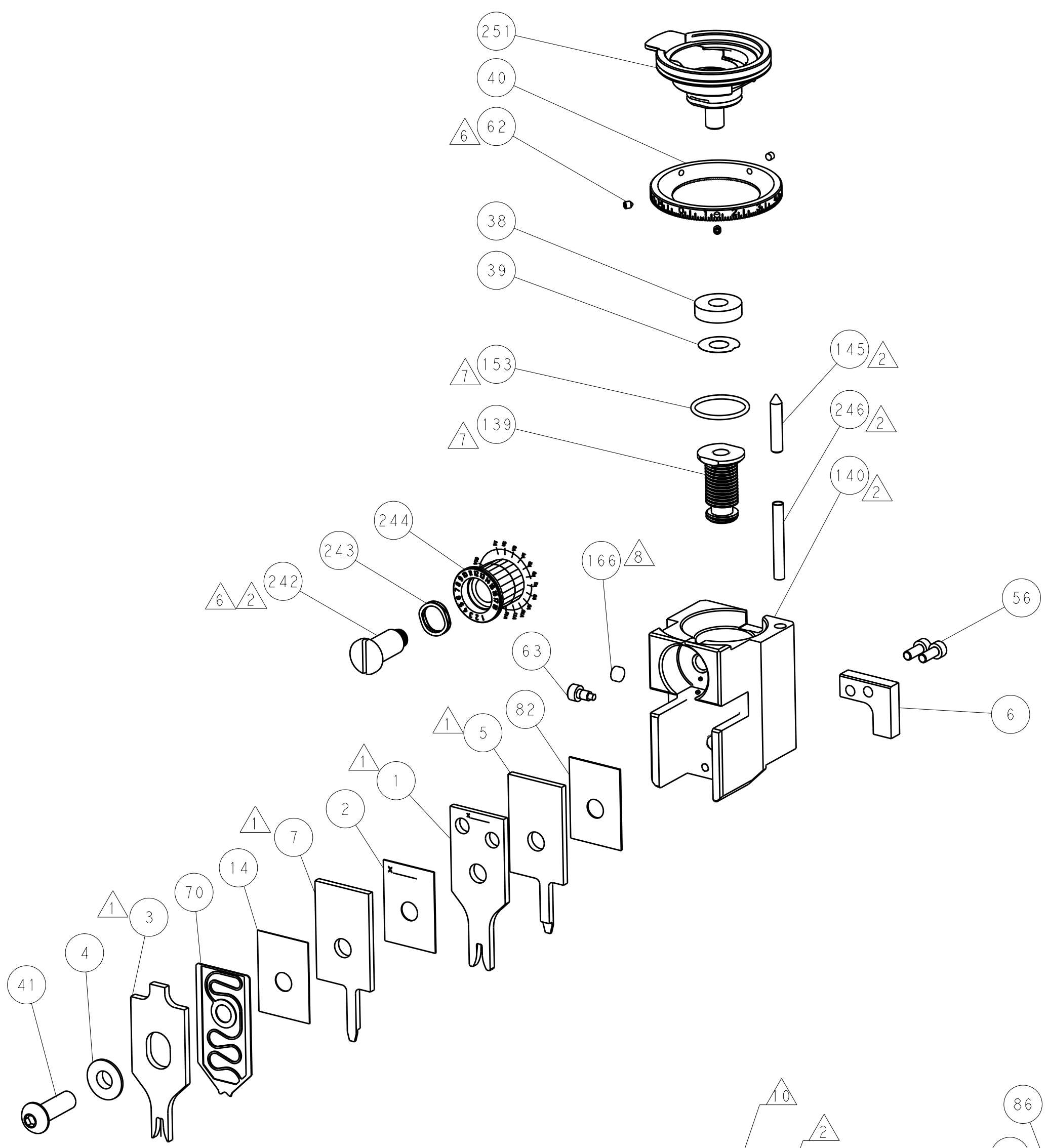
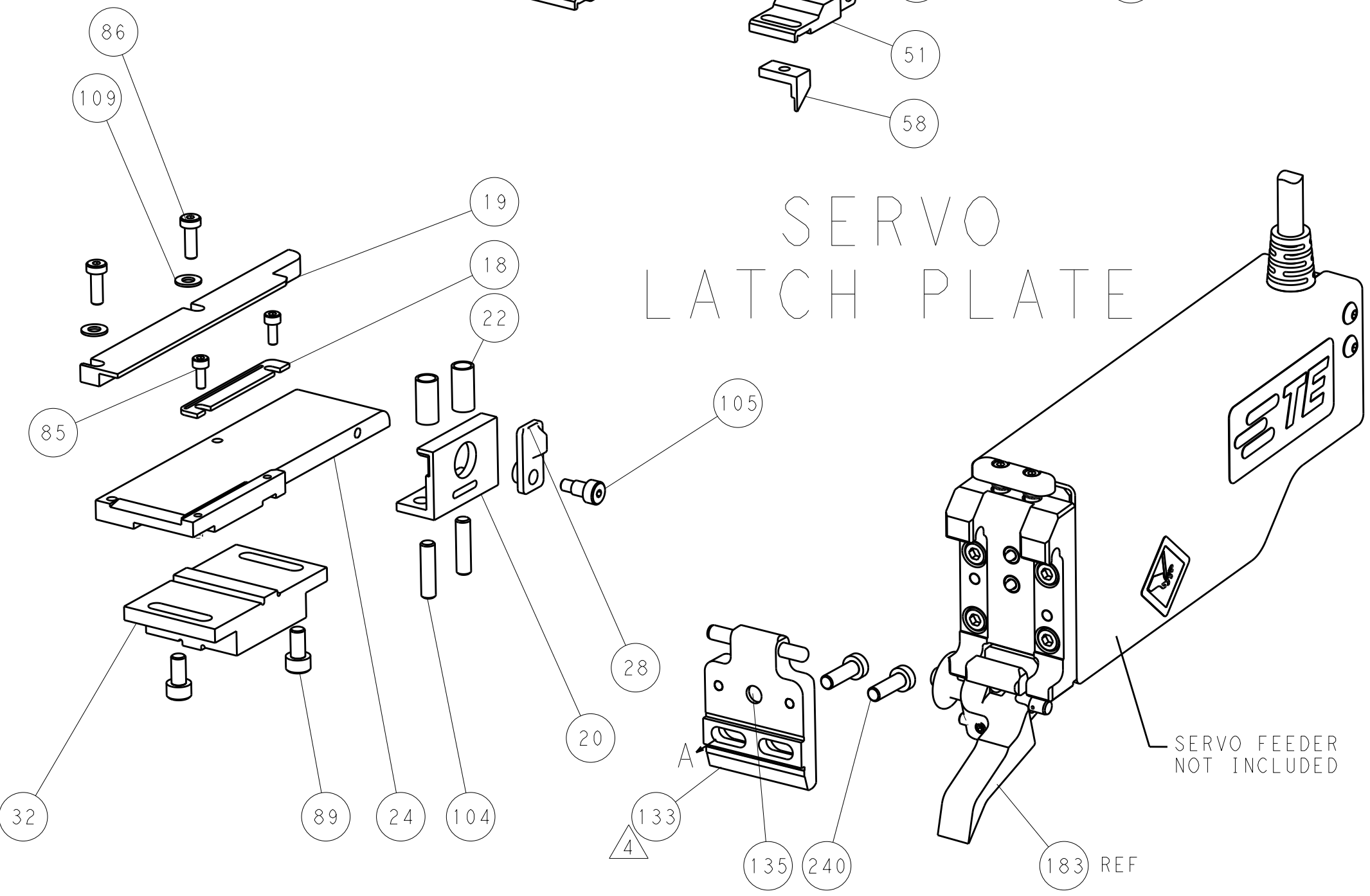
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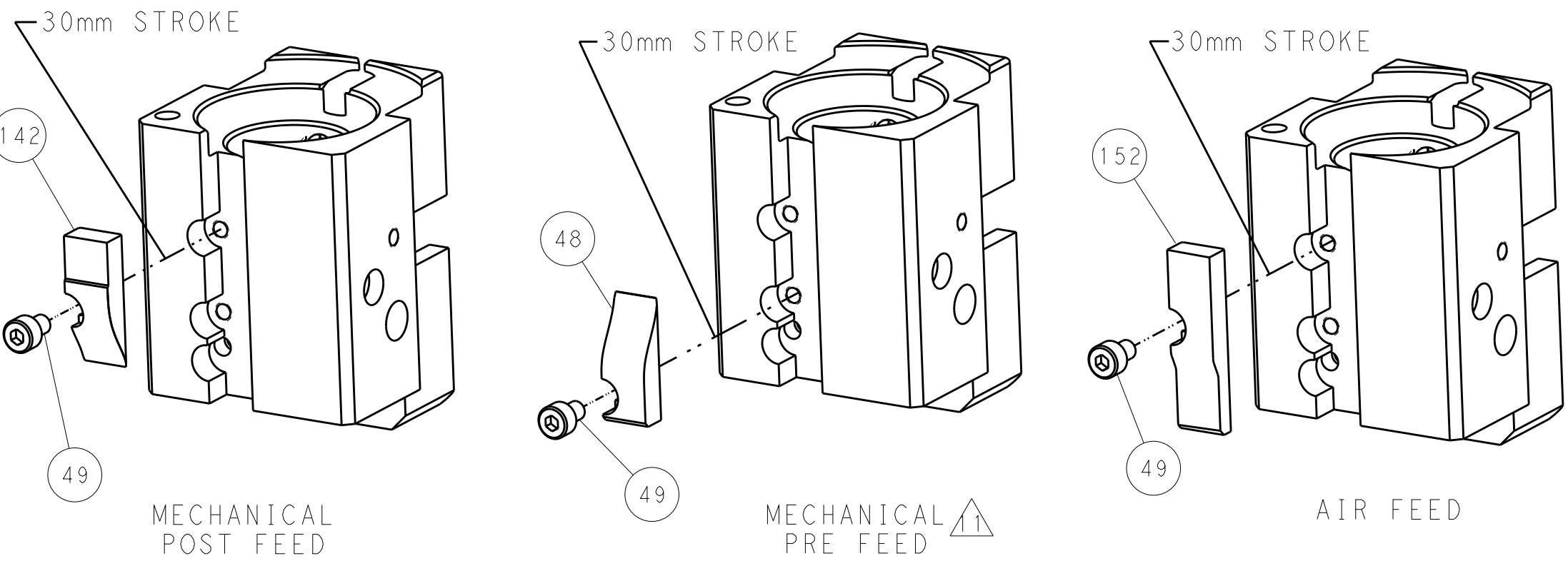
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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

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				CHK	G. BAILEY	20JAN2014		
				APVD	T. ELLIN	20JAN2014	NAME	
				PRODUCT SPEC			Ocean End Feed Applicator	
				APPLICATION SPEC			SIZE	
				WEIGHT			CAGE CODE	
				Customer Accessible Production Drawing			DRAWING NO	
				SCALE			REV	
				1:1			A	