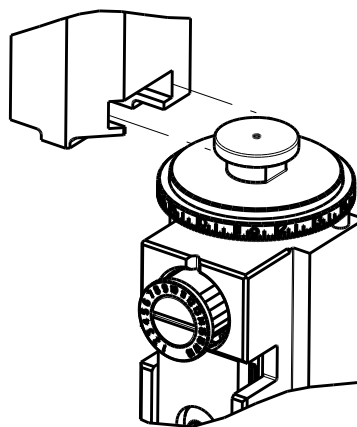
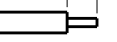


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150030-1	E	FINE CRIMP HEIGHT ADJUST
	2150030-2	E	FINE CRIMP HEIGHT ADJUST
	2150030-5	E	FINE CRIMP HEIGHT ADJUST
	2150030-6	E	NON-CRIMP HEIGHT ADJUST
	2150030-7	E	FINE CRIMP HEIGHT ADJUST
	7-2150030-7	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: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [.173-.252 IN]		 INSULATION DIAMETER RANGE Ø2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	 114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
 160389-3	42510-2	63609-3	140760-3
 160389-4	42510-5	63609-4	140760-4
41772	63127-1	63693-1	140760-5
41772-1	63609-1	140760-1	2238027-3
42510-1	63609-2	140760-2	2238027-4

WIRE SIZE	 	CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
18 AWG or 0.75mm ²		1.42+/-0.05 [.056+/- .002]		6.0
22 AWG x 2		1.37+/-0.05 [.054+/- .002]		6.5
20 AWG or 0.50mm ²		1.30+/-0.05 [.051+/- .002]		7.3
0.40mm2		1.27+/-0.05 [.050+/- .002]		7.6
22 AWG or 0.30mm ²		1.24+/-0.05 [.049+/- .002]		8.0



- 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: 8-2150030-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150030-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150030-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150030-6
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 ITEMS 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37 & 50.
- 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
- ¹³ WHEN RUNNING TERMINAL 160389, POSITION ITEM 261 IN PLACE OF ITEM 16.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-6.40 mm [.173-.252 IN]		INSULATION DIAMETER RANGE Ø2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		114-20023	-
TERMINALS APPLIED		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
280000-6	280000-7	41771	41771-1

WIRE SIZE	 	CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.80mm ²		1.30+/-0.03 [.051+/- .001]		7.8
0.75mm ²		1.30+/-0.03 [.051+/- .001]		7.8
0.65mm ²		1.27+/-0.03 [.050+/- .001]		7.6
0.50mm ²		1.22+/-0.03 [.048+/- .001]		7.8
0.30mm ²		1.14+/-0.03 [.045+/- .001]		8.4

*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	1	1	1	1	3-240641-4	SPACER	261
-	-	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
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

⁷

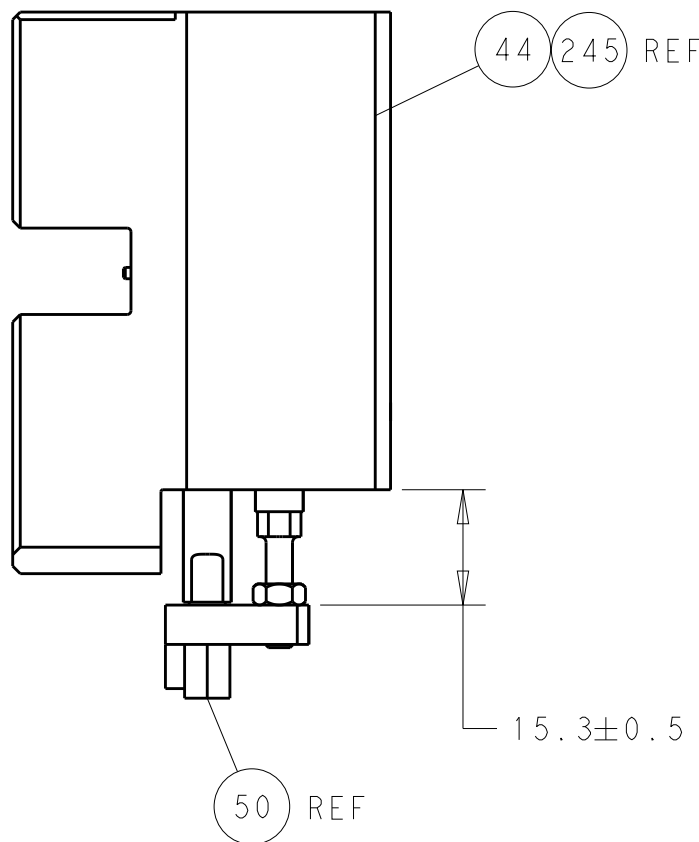
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				D	ECR-16-009120	23JUN2016
				E	ECR-16-009661	05JUL2016
				E1	ECR-16-014582	14OCT2016

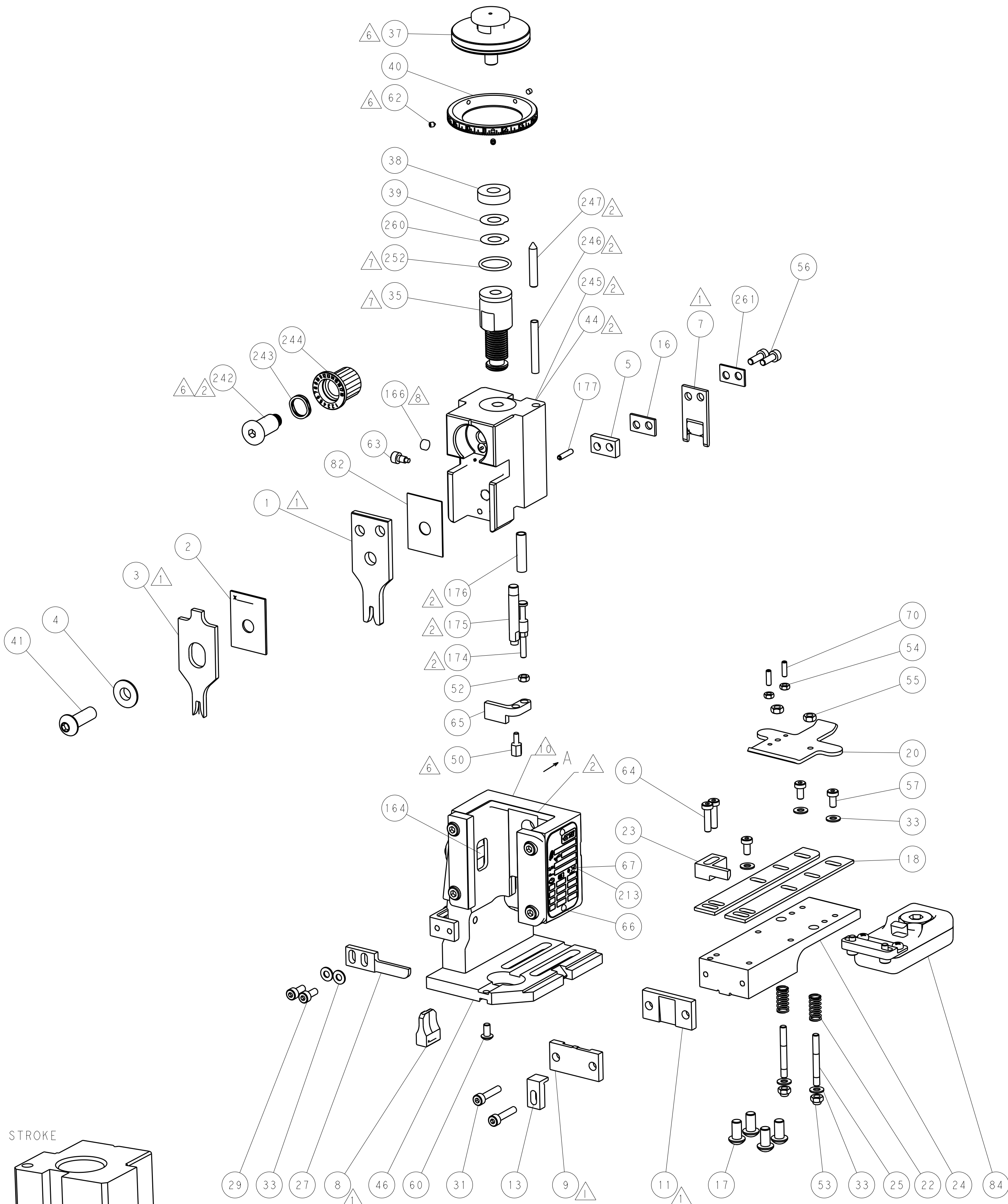
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	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	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	1-1752354-3	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	2119644-1	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
-	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	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	1	1	1	240825-2	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	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1	3-240641-3	SPACER	16
-	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	690495-4	PLATE, FRONT SHEAR	9
1	1	1	1	1	1	1338673-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	1	1	1	1	1	240641-3	SPACER	5
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1	1	1	1-456406-2	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHALL BE CONTACTED FOR THE LATEST EDITION.				DWN B. WEAVER CHK G. HOFFNER APVD G. RILEY	09DEC2011 09DEC2011 09DEC2011	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator			
		D P L C ± . P L C ± . A P L C ± . A P L C ± . ANGLE ± .		PRODUCT SPEC APPLICATION SPEC		SIZE		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		A 00779 C=2150030		-	
Customer Accessible Production Drawing						SCALE 1:1		SHEET 1 OF 4 REV E	

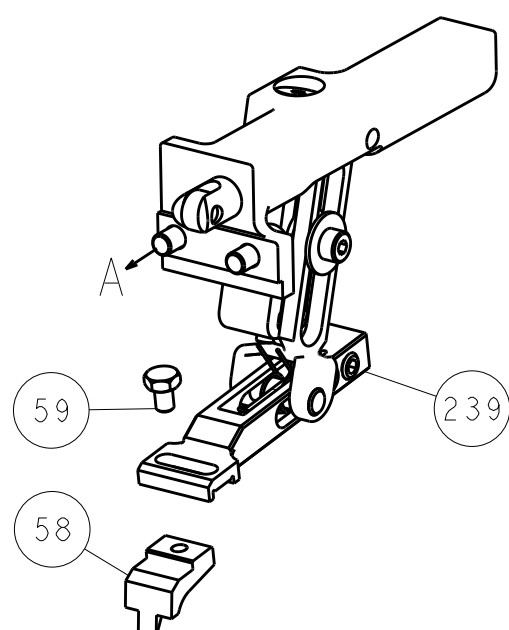
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



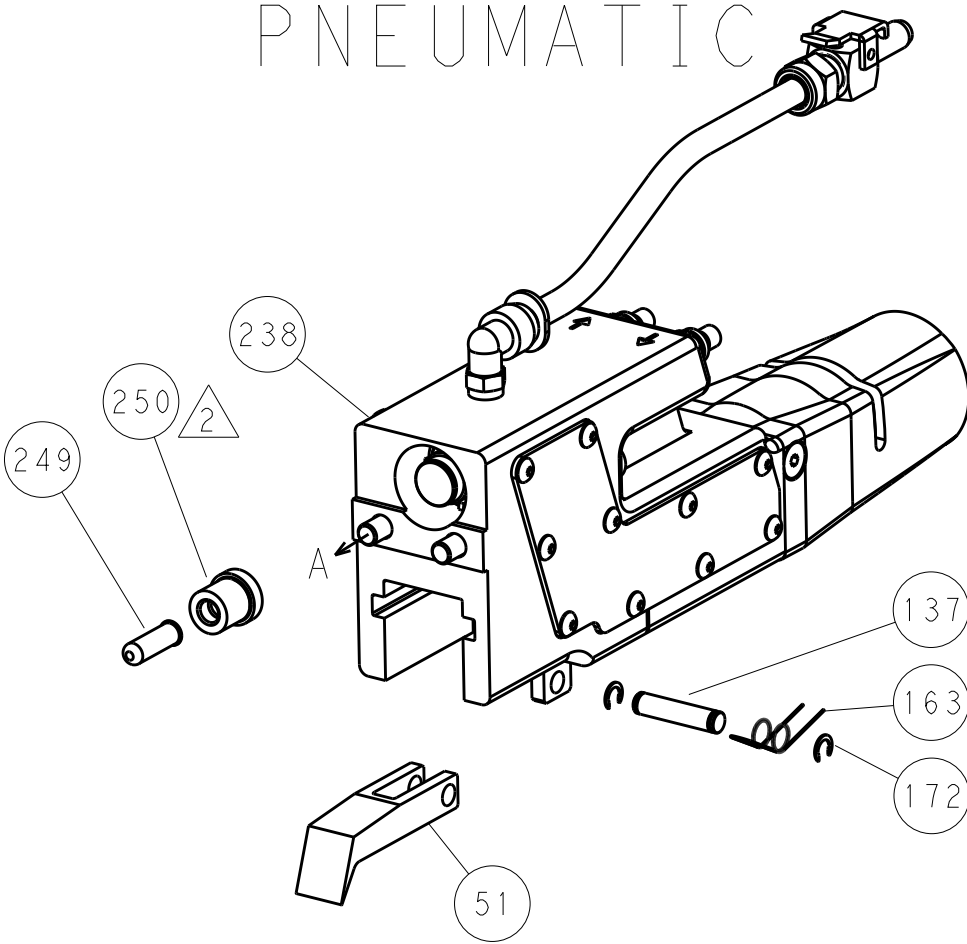
HOLDDOWN SET-UP



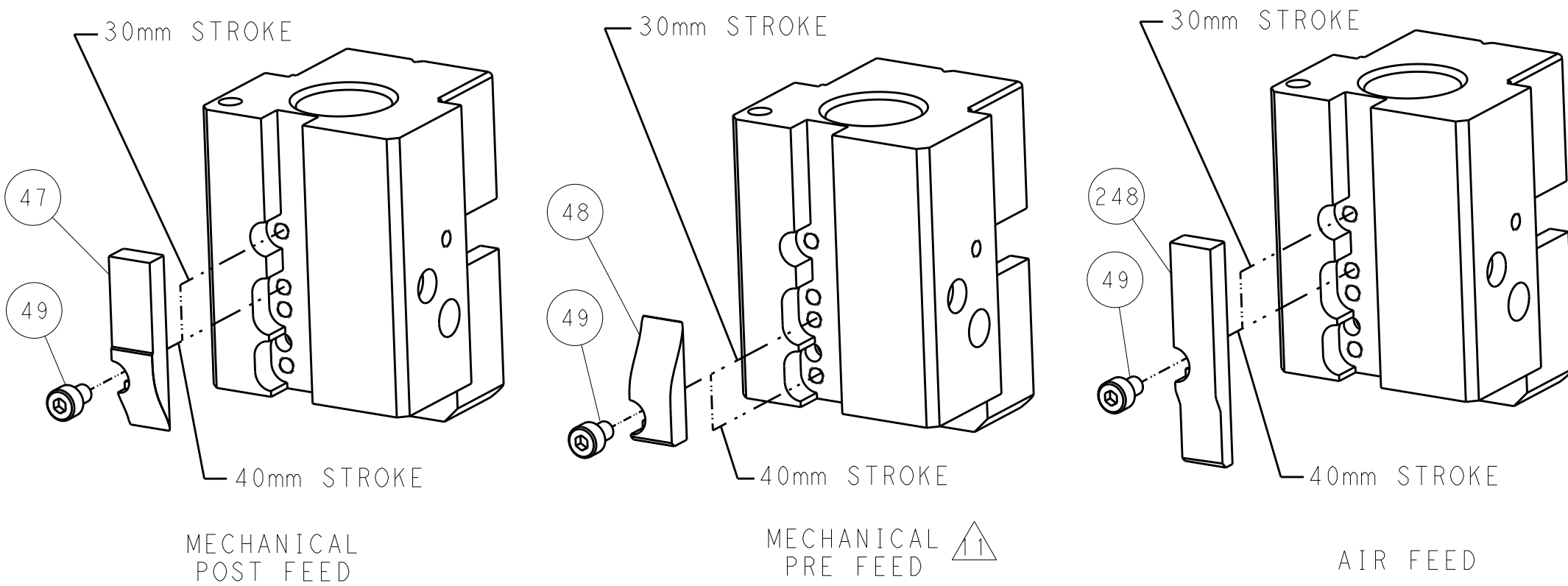
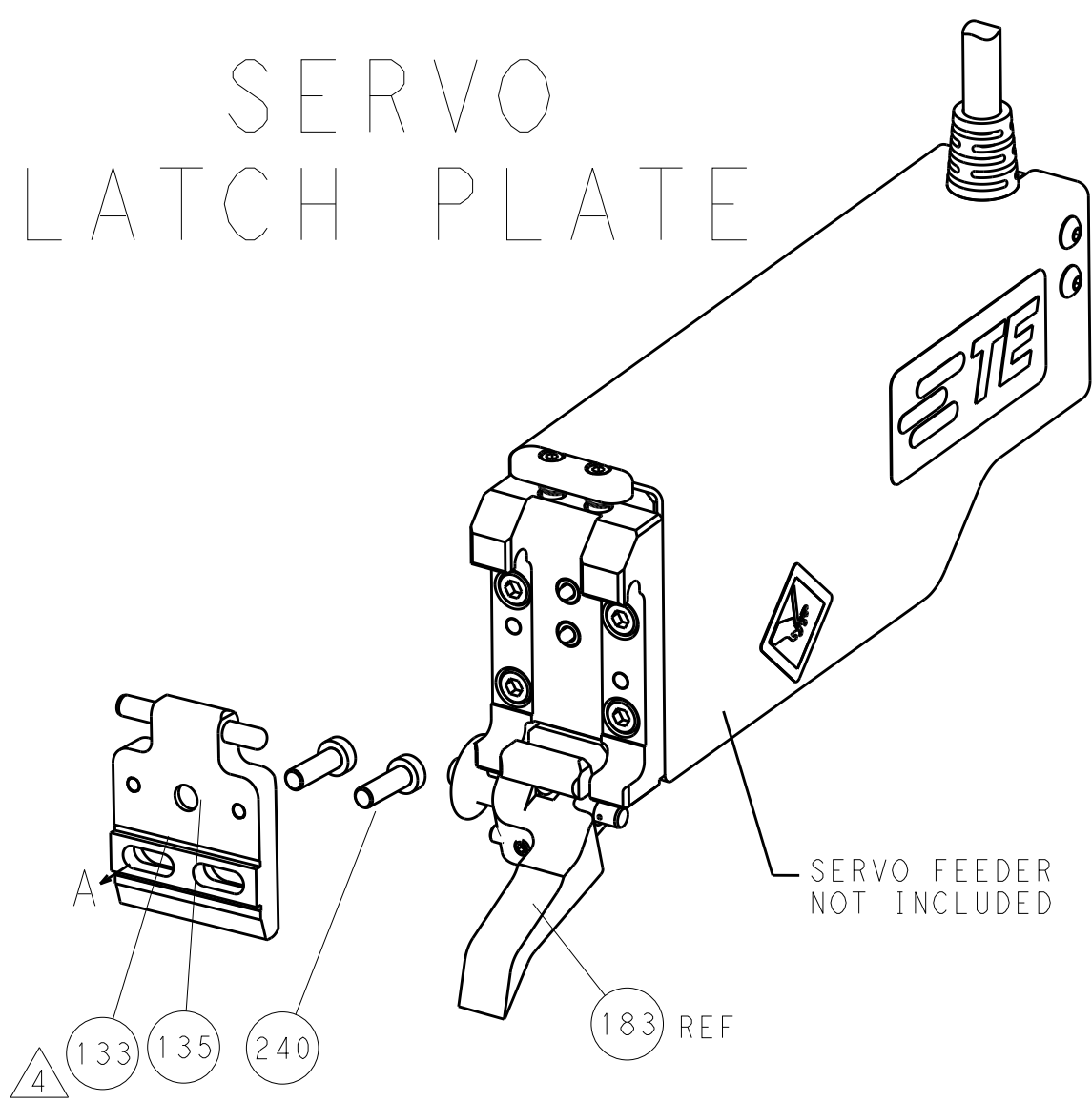
FEED TYPE
MECHANICAL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		TE Connectivity	
mm		0 PLC ±.1		B. WEAVER 09DEC2011		Harrisburg, PA 17105-3608	
		1 PLC ±.1		CHK G. HOFFNER 09DEC2011		NAME	
		2 PLC ±.1		APVD G. BAILEY 09DEC2011		Ocean End Feed Applicator	
		3 PLC ±.1		PRODUCT SPEC		SIZE	
		4 PLC ±.1		APPLICATION SPEC		CAGE CODE	
		ANGLES ±.1		WEIGHT		DRAWING NO	
		FINISH		Customer Accessible Production Drawing		00779	
				SCALE		1:1	
				SHEET		2 of 4	
				REV		E1	

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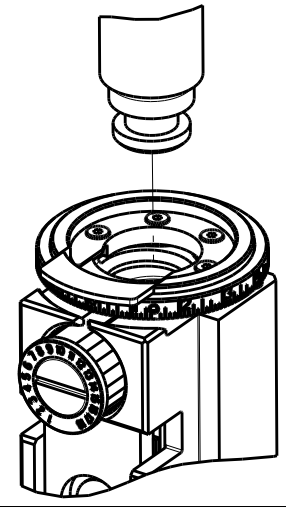
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2011

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2150030-1

REVISION

E

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119792-2

-

2119641-2

-

2063440-1

SERVO LATCH PLATE

2119951-1

SMART APPLICATOR

2161326-1

-

8-2150030-4

-

2168400-7 (QUANTITY 2)

MECHANICAL FEED

2119949-1

SERVO LATCH PLATE

2119951-1

SMART APPLICATOR

2161326-1

-

8-2150030-4

-

2168400-7 (QUANTITY 2)

MECHANICAL FEED

2119949-1

PNEUMATIC FEED

2119950-1

-

2119653-2

-

2063440-1

SERVO LATCH PLATE

4

-

-

-

-

-

CRIMP

SIZE

TYPE

WIRE

2.29 mm [.090]

F

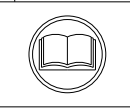
INSUL

3.30 mm [.130]

F

APPL INSTRUCTIONS

408-10390



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .250 FASTON RECEPTACLE

WIRE STRIP LENGTH

4.40-6.40 mm [.173-.252 IN]

INSULATION DIAMETER RANGE

Ø2.30-3.30 mm [.091-.130 IN]

TERMINAL APPLICATION SPECIFICATION

114-2036

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

160389-3

42510-2

63609-3

140760-3

160389-4

42510-5

63609-4

140760-4

41772

63127-1

63693-1

140760-5

41772-1

63609-1

140760-1

2238027-3

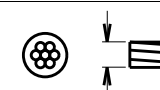
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63609-2

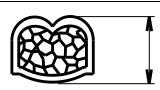
140760-2

2238027-4

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

18 AWG or 0.75mm²

1.42+/-0.05 [.056+/- .002]

6.0

22 AWG x 2

1.37+/-0.05 [.054+/- .002]

6.5

20 AWG or 0.50mm²

1.30+/-0.05 [.051+/- .002]

7.3

0.40mm2

1.27+/-0.05 [.050+/- .002]

7.6

22 AWG or 0.30mm²

1.24+/-0.05 [.049+/- .002]

8.0



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: 8-2150030-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150030-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150030-5

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 ITEMS 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.

WHEN RUNNING TERMINAL 160389, POSITION ITEM 261 IN PLACE OF ITEM 16.

TERMINAL DATA: TE TERMINAL

TE CRIMP SPERIFICATION

TERMINAL NAME: .250 FASTON RECEPTACLE

WIRE STRIP LENGTH

4.40-6.40 mm [.173-.252 IN]

INSULATION DIAMETER RANGE

Ø2.30-3.30 mm [.091-.130 IN]

TERMINAL APPLICATION SPECIFICATION

114-20023

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

280000-6

280000-7

41771

41771-1

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

0.80mm²

1.30+/-0.03 [.051+/- .001]

7.8

0.75mm²

1.30+/-0.03 [.051+/- .001]

7.8

0.65mm²

1.27+/-0.03 [.050+/- .001]

7.6

0.50mm2

1.22+/-0.03 [.048+/- .001]

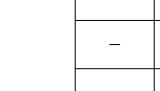
7.8

0.30mm²

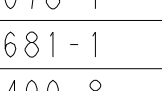
1.14+/-0.03 [.045+/- .001]

8.4

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

0.80mm²

1.30+/-0.03 [.051+/- .001]

7.8

0.75mm²

1.30+/-0.03 [.051+/- .001]

7.8

0.65mm²

1.27+/-0.03 [.050+/- .001]

7.6

0.50mm2

1.22+/-0.03 [.048+/- .001]

7.8

0.30mm²

1.14+/-0.03 [.045+/- .001]

8.4

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

2119950-1

2119792-2

-

2119641-2

-

2063440-1

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150030-5

-

-

2168400-7 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2150030-4

-

-

-

MECHANICAL FEED

2119949-1

2063961-1

5-18022-5

2119653-2

-

-

-

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150030-5

-

-

2168400-7 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2150030-4

-

-

-

MECHANICAL FEED

2119949-1

2063961-1

5-18022-5

2119653-2

-

-

-

PNEUMATIC FEED

2119950-1

2119792-2

-

2119641-2

-

2063440-1

-

-

-

-

-

-

-

-

-

-

-

-

-

-

SET UP GAUGE

2119599-2

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

OWN

APVD

-

-

SEE SHEET 1

-

-

-

-

-

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

-

-

2119740-2

TAG, IDENTIFICATION

213

-

4

4

4

4

2079383-9

SCR, BHSC, RoHS (M6 X 20)

186

-

-

REF

-

-

1901697-1

FEED FINGER ASSEMBLY,EF

183

-

1

1

1

1

6-993111-6

PIN, SLOTTED SPRING 3.0 X 14.0

177

-

1

1

1

1

8-22280-7

SPRING, COMPRESSION

176

-

1

1

1

1

1752353-2

GUIDE PIN,HOLDDOWN

175

-

1

1

1

1

1901680-2

GUIDE PIN,HOLDDOWN

174

-

-

-

2

-

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

-

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

-

-

-

1

-

240638-1

SPRING, FEED FINGER

163

-

1

1

1

1

8-21084-1

O-RING, .801 ID, .070 DIA. MAT.

153

-

-

-

1

-

2119641-2

FEED CAM, AIR FEED

152

-

1

1

1

1

2119798-2

DETENT PIN

145

-

1

1

1

1

2079383-8

SCR, BHSC, RoHS (M4 X 16)

144

-

-

-

-

1

2119653-2

FEED CAM, POST FEED

142

-

1

1

1

1

2119655-6

APPLICATOR BASIC ASSEMBLY, EF

141

-

1

1

1

1

2119651-1

RAM, ASIAN STYLE, END FEED

140

-

1

1

1

1

2119092-2

BOLT, ADJUSTMENT

139

-

-

-

1

-

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

-

-

REF

-

-

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

-

-

1

-

-

1633743-1

SERVO FEED LATCH ASM

133

-

1

1

1

1

2119955-2

ASSY, LUBRICATOR, END FEED

84

-

1

1

1

1

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

2119956-2

DOCUMENTATION PACKAGE

71

-

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

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

-

1

1

1

1

1901681-1

HOLDDOWN, TERMINAL

65

-

2

2

2

2

2168400-8

SHCS, LOW HEAD, RoHS, M4 X 16

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

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

-

1

2063961-1

FEED FINGER

58

-

3

3

3

3

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

2

2

2

2168083-3

SCR, SKT HD CAP, RoHS, M4 X 12.0

56

-

2

2

2

2

5018030-2

NUT, HEX, REG, RoHS, M4

55

-

2

2

2

2

5018030-1

NUT, HEX, REG, RoHS, M3

54

-

2

2

2

2

986965-8

NUT, LOCK, HEX, TORQUE (M4)

53

-

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

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

2119644-1

RAM WASHER, PRECISION

38

-

7

7

7

7

1-18028-2

WASHER, FLAT, REG M4

33

-

2

2

2

2

2168083-9

SCR, SKT HD CAP, RoHS, M4 X 20

31

-

2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

29

-

1

1

1

1

240639-1

STRIPPER (MACHINING)

27

-

2

2

2

2

1320906-1

STUD, THREADED

25

-

1

1

1

1

1752371-5

PLATE, STRIP GUIDE

24

-

1

1

1

1

240825-2

PLATE, STRIP HOLD DOWN

23

-

2

2

2

2

2-22281-3

SPRING, COMPRESSION

22

-

1

1

1

1

1752373-4

DRAG

20

-

2

2

2

2

1901259-4

GUIDE, LOWER STRIP

18

-

1

1

1

1

3-240641-3

SPACER

16

-

1

1

1

1

1752360-1

SPACER,HOLD-DOWN

13

-

1

1

1

1

240644-1

PLATE, REAR SHEAR

11

-

-

-

-

-

-

-

10

-

1

1

1

1

690495-4

PLATE, FRONT SHEAR

9

-

1

1

1

1

1338673-1

ANVIL, COMBINATION

8

-

1

1

1

1

1-2217206-3

BLADE, SLUG

7

-

1

1

1

1

240641-3

SPACER

5

-

1

1

1

1

238009-1

BLOCK, FL CRIMPER SPACER

4

-

1

1

1

1

1-1633961-6

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

1-455888-0

SPACER, CRIMPER

2

-

1

1

1

1

1-456406-2

CRIMPER, WIRE PREMIUM

1

-77-27-25-22-21

PART NO

DESCRIPTION

ITEM NO

-77-27-25-22-21

PART NO

DESCRIPTION

ITEM NO

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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2011

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.29 mm [.090]

F

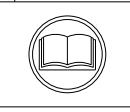
INSUL

3.30 mm [.130]

F

APPL INSTRUCTIONS

408-10390



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .250 FASTON RECEPTACLE

WIRE STRIP LENGTH

4.40-6.40 mm [.173-.252 IN]

INSULATION DIAMETER RANGE

Ø2.30-3.30 mm [.091-.130 IN]

TERMINAL APPLICATION SPECIFICATION

114-2036

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

160389-3

42510-2

63609-3

140760-3

160389-4

42510-5

63609-4

140760-4

41772

63127-1

63693-1

140760-5

41772-1

63609-1

140760-1

2238027-3

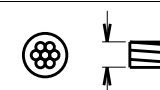
42510-1

63609-2

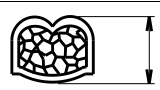
140760-2

2238027-4

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

18 AWG or 0.75mm²

1.42+/-0.05 [.056+/- .002]

6.0

22 AWG x 2

1.37+/-0.05 [.054+/- .002]

6.5

20 AWG or 0.50mm²

1.30+/-0.05 [.051+/- .002]

7.3

0.40mm2

1.27+/-0.05 [.050+/- .002]

7.6

22 AWG or 0.30mm²

1.24+/-0.05 [.049+/- .002]

8.0



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: 8-2150030-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150030-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150030-5

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 ITEMS 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.

WHEN RUNNING TERMINAL 160389, POSITION ITEM 261 IN PLACE OF ITEM 16.

TERMINAL DATA: TE TERMINAL

TE CRIMP SPERIFICATION

TERMINAL NAME: .250 FASTON RECEPTACLE

WIRE STRIP LENGTH

4.40-6.40 mm [.173-.252 IN]

INSULATION DIAMETER RANGE

Ø2.30-3.30 mm [.091-.130 IN]

TERMINAL APPLICATION SPECIFICATION

114-20023

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

280000-6

280000-7

41771

41771-1

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

0.80mm²

1.30+/-0.03 [.051+/- .001]

7.8

0.75mm²

1.30+/-0.03 [.051+/- .001]

7.8

0.65mm²

1.27+/-0.03 [.050+/- .001]

7.6

0.50mm2

1.22+/-0.03 [.048+/- .001]

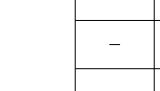
7.8

0.30mm²

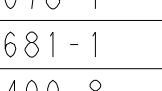
1.14+/-0.03 [.045+/- .001]

8.4

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

0.80mm²

1.30+/-0.03 [.051+/- .001]

7.8

0.75mm²

1.30+/-0.03 [.051+/- .001]

7.8

0.65mm²

1.27+/-0.03 [.050+/- .001]

7.6

0.50mm2

1.22+/-0.03 [.048+/- .001]

7.8

0.30mm²

1.14+/-0.03 [.045+/- .001]

8.4

SET UP GAUGE

2119599-2

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

OWN

APVD

-

-

SEE SHEET 1

-

-

-

-

-

2

-

-

2168400-7

SHCS, LOW HEAD, RoHS, M5 X 10

240

-

-

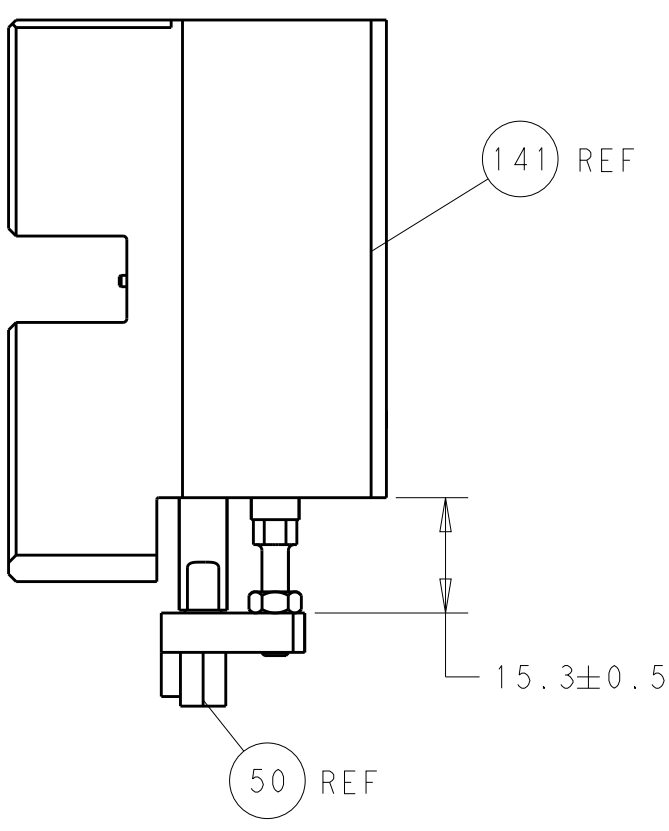
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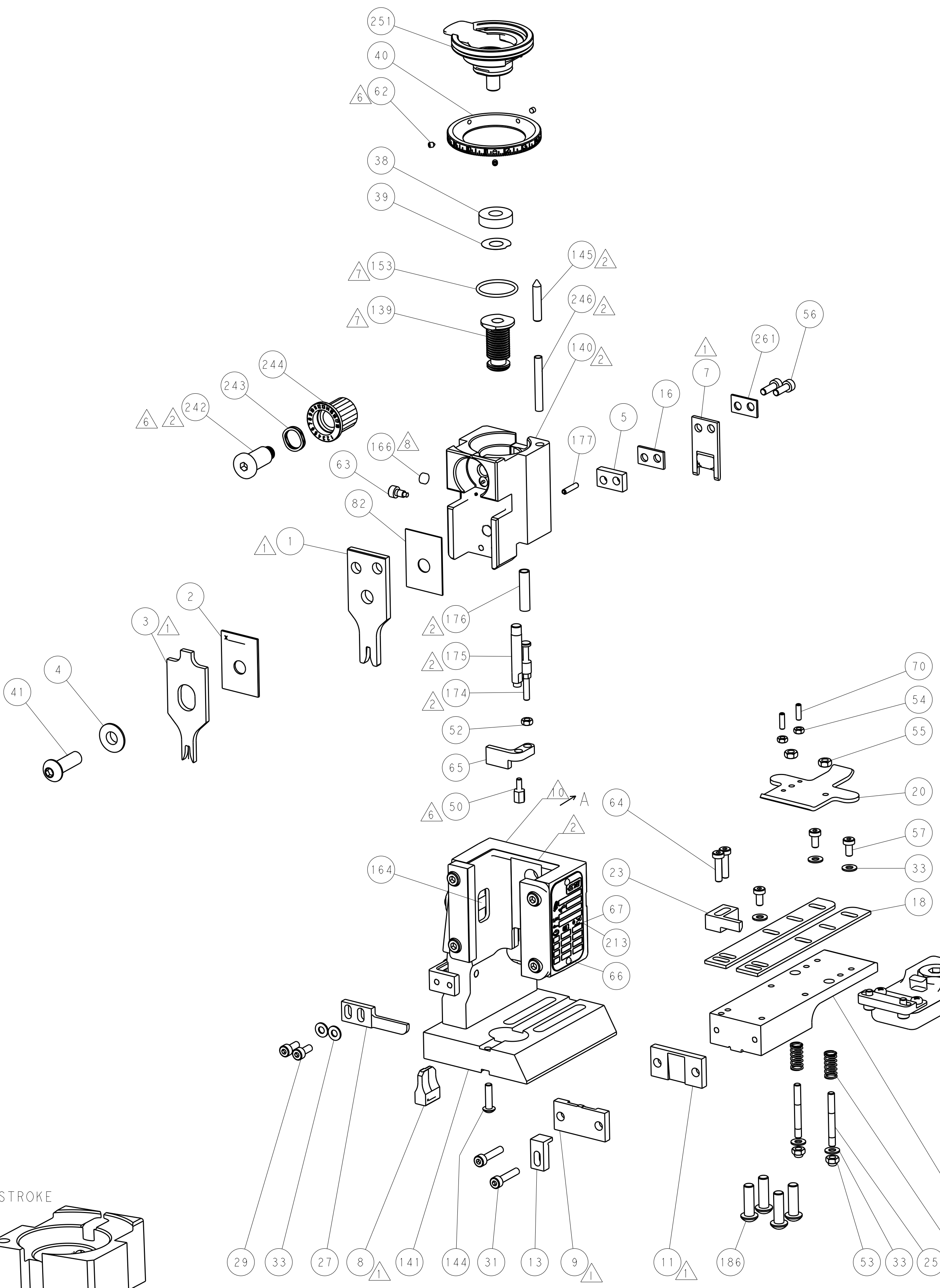
1

2119580-1

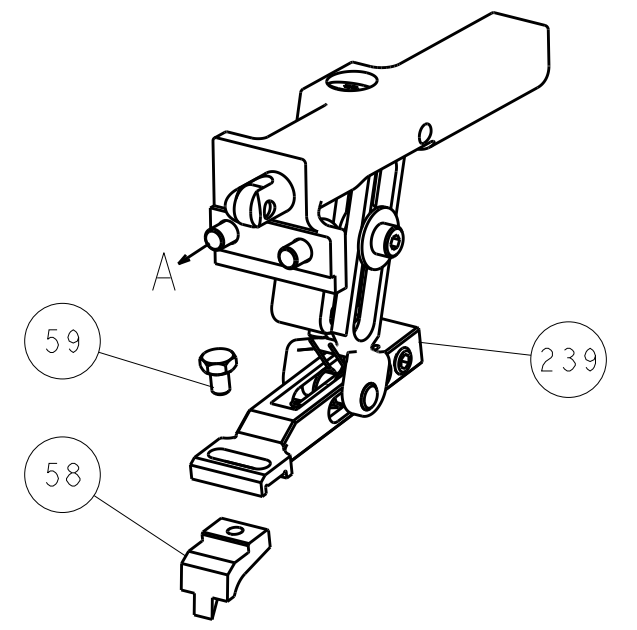
LOC		DIST		REVISIONS			
P	LTR	DATE	DWN	APVD	DESCRIPTION		
					DATE		
	-	SEE SHEET 1	-	-			



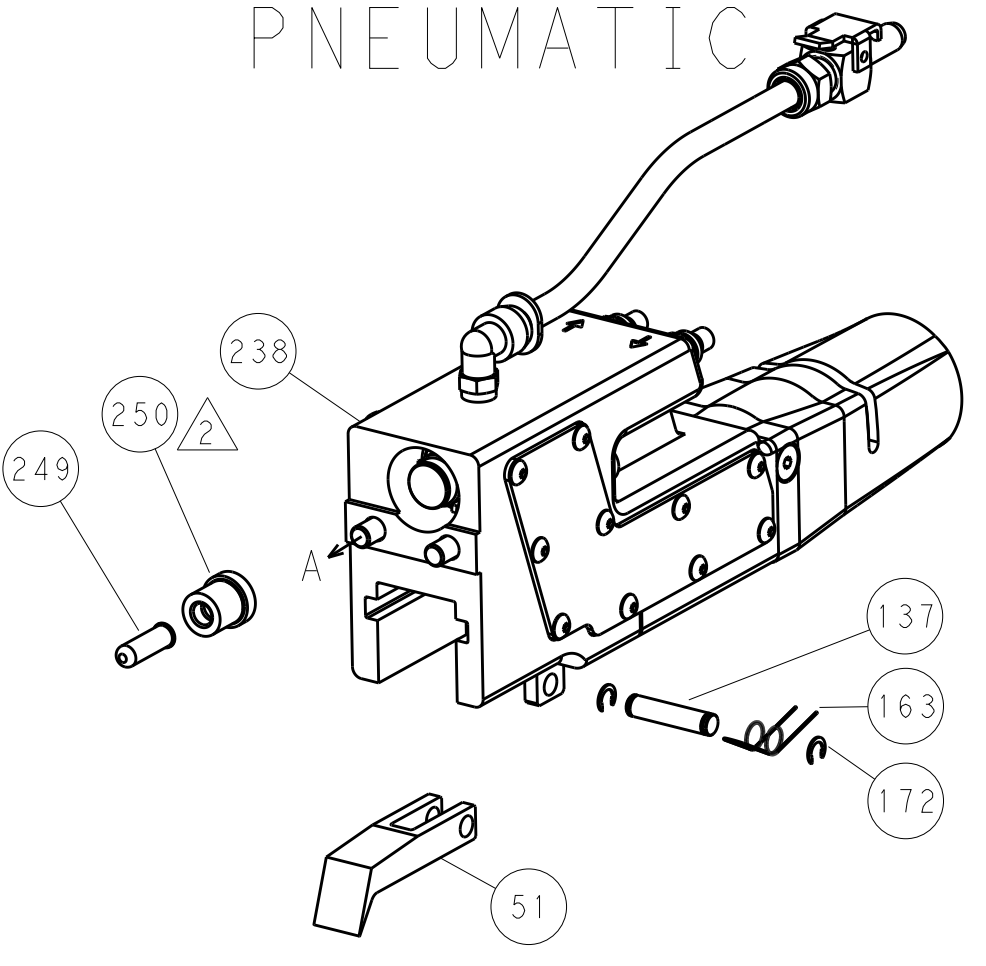
HOLDDOWN SET-UP



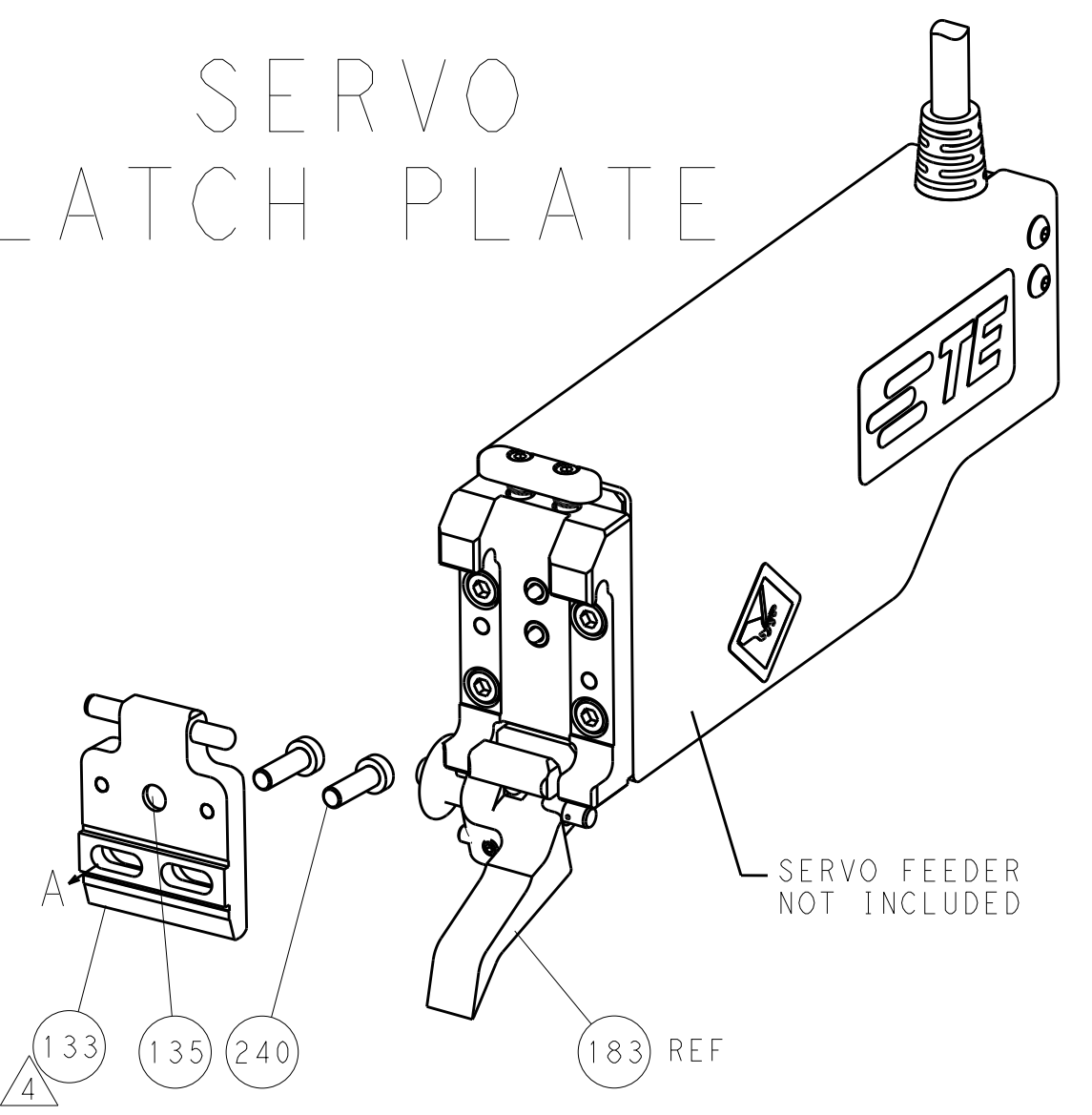
FEED TYPE
MECHANICAL



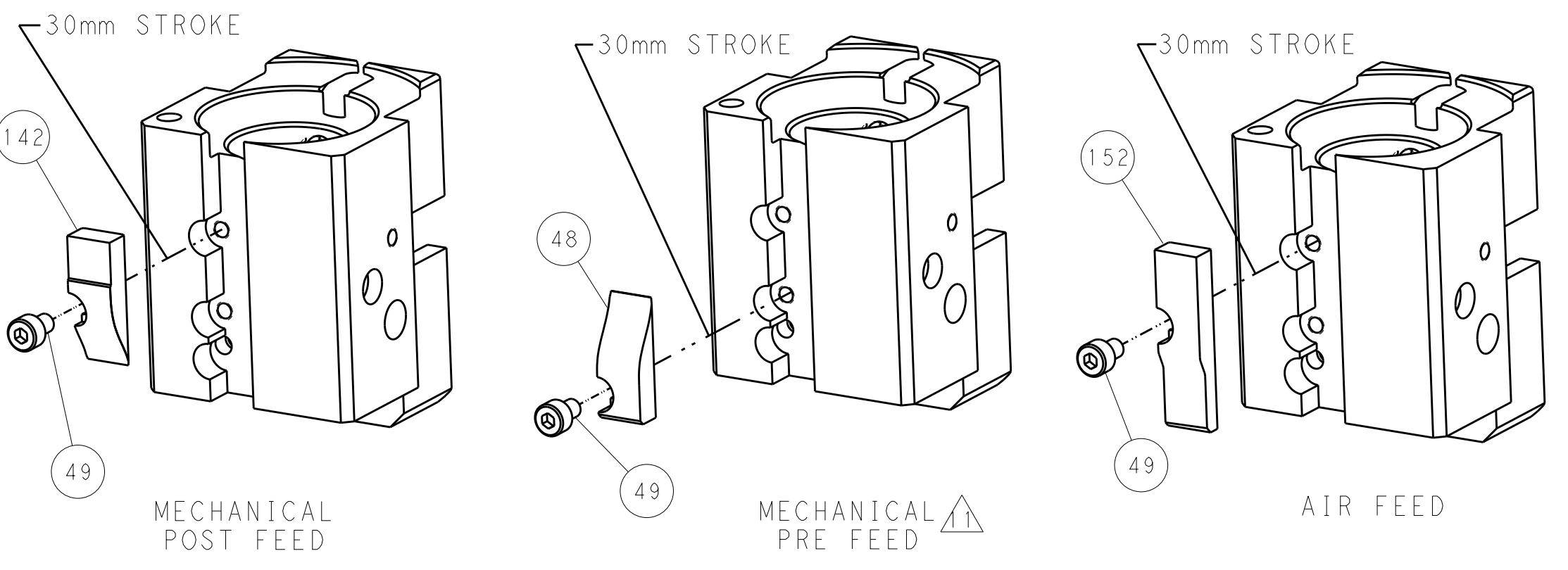
PNEUMATIC



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)

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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				NAME: Ocean End Feed Applicator			
MATERIAL: -				WEIGHT: -				SIZE: CAGE CODE: DRAWING NO: 00779 C=2150030			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET 4 OF 4 REV E1			