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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2150014-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2150014-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2150014-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4
	2150014-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 12
	2150014-7	B	FINE CRIMP HEIGHT ADJUST	NONE
	7-2150014-7	A	CRIMP TOOLING KIT	-

APPLICATOR STYLE CONVERSION CHART										
CONVERT TO				PART NUMBERS REQUIRED						
PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1				
SERVO LATCH PLATE	2119951-1	1901697-1	8-2150014-5	-	-	2168400-7 (QUANTITY 2)				
SMART APPLICATOR	2161326-1	-	8-2150014-4	-	-					
MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-					
SERVO LATCH PLATE	2119951-1	1901697-1	8-2150014-5	-	-	2168400-7 (QUANTITY 2)				
SMART APPLICATOR	2161326-1	-	8-2150014-4	-	-					
MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-					
PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1				

SET UP GAUGE	LOC	DIST	REVISIONS
2119999-2	A	66	
P	LTN	DESCRIPTION	DATE
A	RELEASED		18APR2012
B	ECR-17-001828		09FEB2017

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL			
TERMINAL NAME:	TERMINAL		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.80-5.60 mm [.189-.220 IN]		Ø3.00-4.30 mm [.118-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
626082-1	626082-5	626095-4	735222-3
626082-2	626095-1	626095-5	880045-1
626082-3	626095-2	735222-1	880045-2
626082-4	626095-3	735222-2	880045-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.83 +/- 0.05 [.072 +/- .002]	7.3
2.00mm2	1.67 +/- 0.05 [.066 +/- .002]	9.0
1.50mm2	1.52 +/- 0.05 [.060 +/- .002]	10.7
1.00mm2	1.37 +/- 0.05 [.054 +/- .002]	12.3

- 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: 8-2150014-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150014-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150014-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150014-6
- 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 AND 50. APPLY PART NUMBER 2-23429-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23429-5 LOCTITE TO THREADS OF ITEM 37.
- 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.

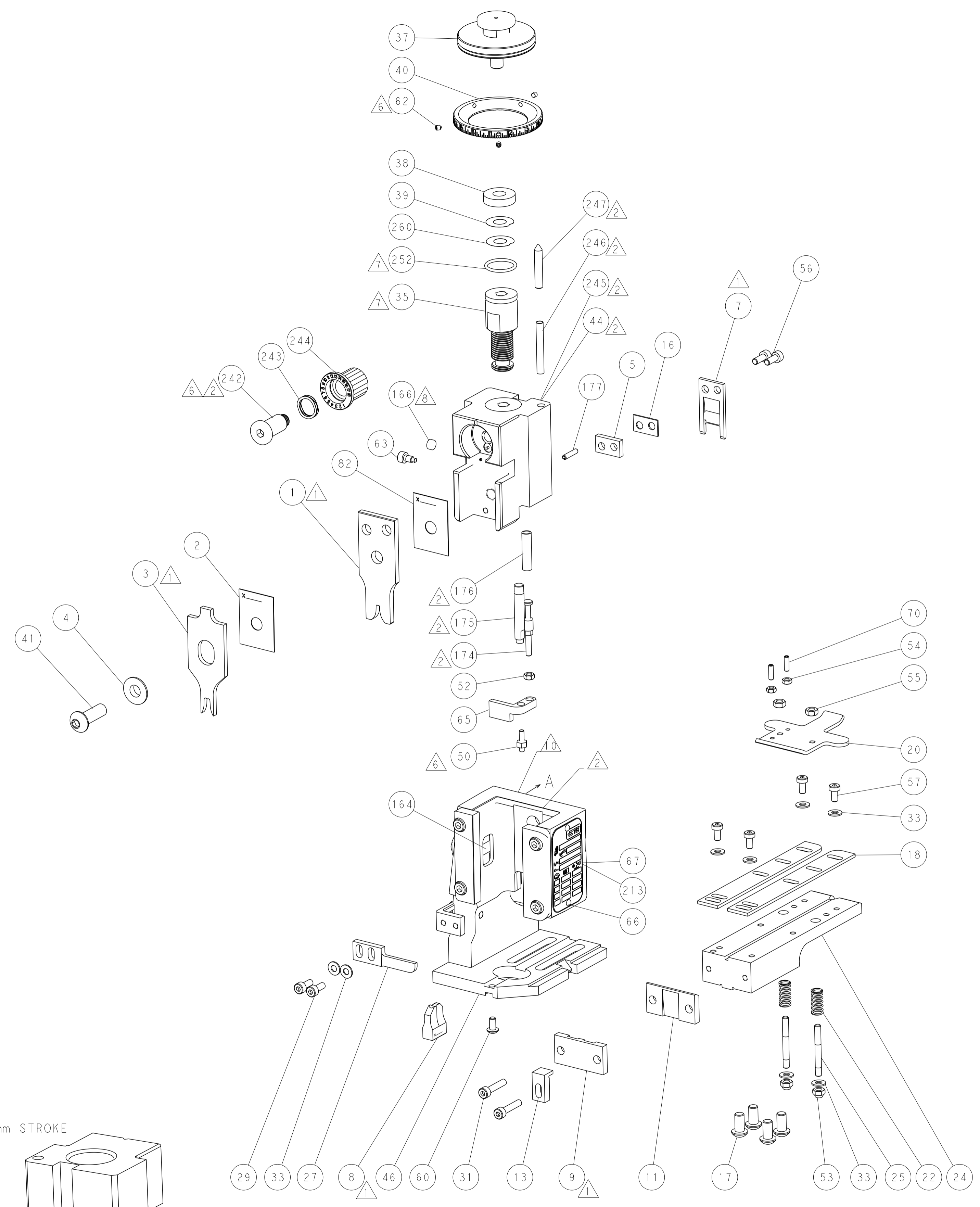
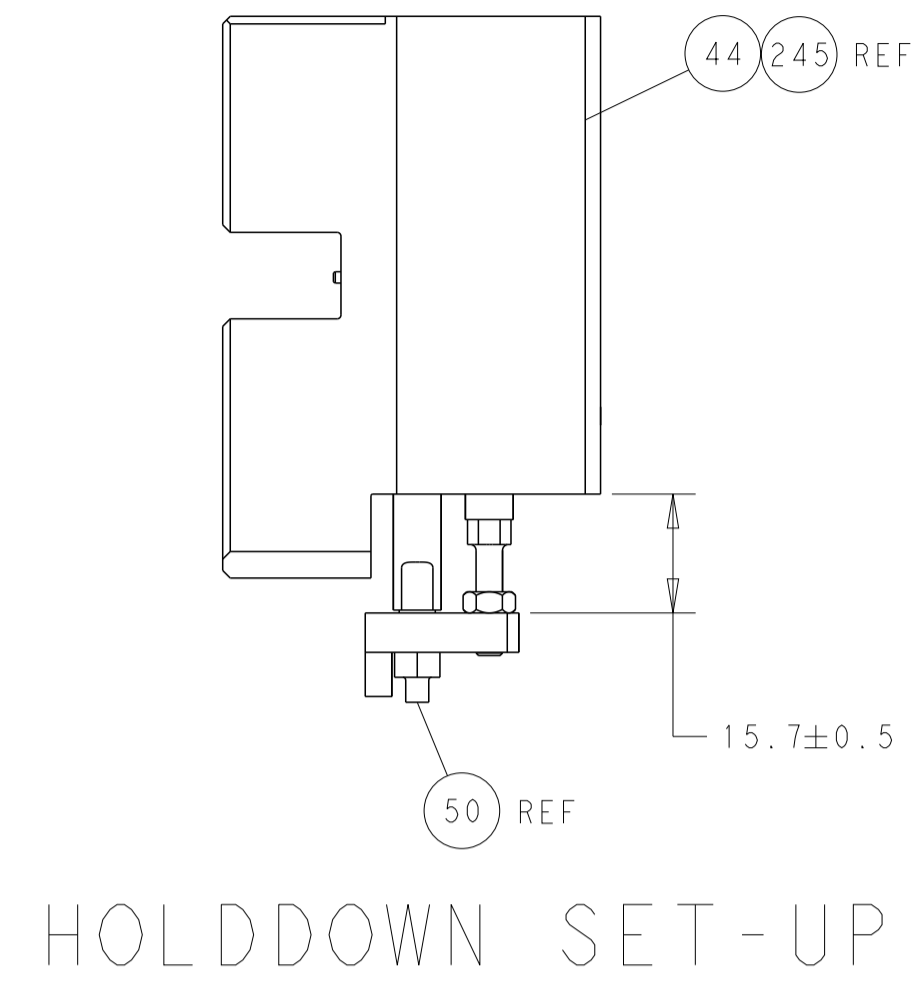
2119957-2	APPLICATOR SHIM PACK	260
8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
2119640-1	PUSH ROD, AIR FEED	250
1803259-1	BUSHING, FLANGED	249
2119641-1	FEED CAM, AIR FEED	248
-77 -7 -6 -5 -2 -1	PART NO	DESCRIPTION
		ITEM NO

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

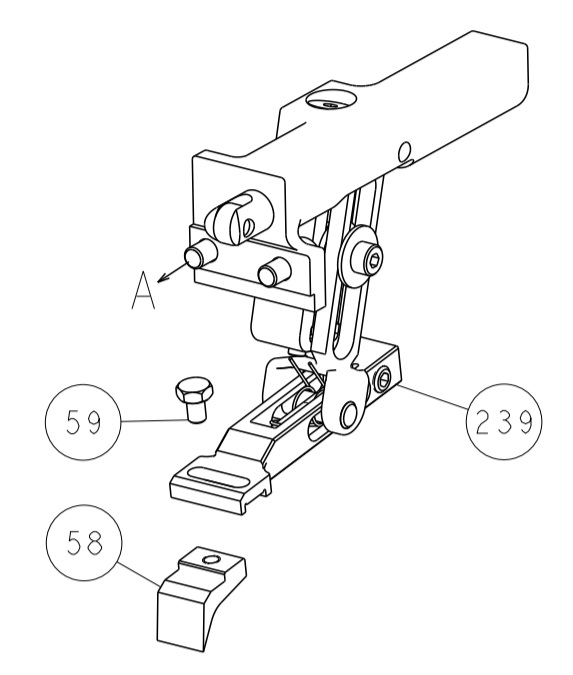
- 1 - 1 1 1	2119798-1	DETENT PIN	247
- 1 - 1 1 1	1-22279-3	SPRING, COMPRESSION	246
- - 1 - - -	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
- 1 1 1 1 1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
- 1 1 1 1 1	2119083-1	RETAINER, INSULATION 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
- REFREFREFREFREF	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	455888-4	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	1901681-5	HOLDDOWN, TERMINAL	65
- 1 - 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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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 -	2119792-1	PAWL, EF, AIR	51
- 1 1 1 1 1	1-1976055-1	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 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 1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
- 1 - 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 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	1752371-9	PLATE, STRIP GUIDE	24
- 2 2 2 2 2	2-22281-3	SPRING, COMPRESSION	22
- 1 1 1 1 1	1752373-1	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	2-240641-8	SPACER	16
- 1 1 1 1 1	1752360-1	SPACER, HOLD-DOWN	13
- 1 1 1 1 1	240833-4	PLATE, REAR SHEAR	11
- 1 1 1 1 1	5-690482-4	PLATE, FRONT SHEAR	9
1 1 1 1 1	7-1633383-1	ANVIL, COMBINATION	8
- 1 1 1 1 1	690474-6	BLADE, SLUG	7
- 1 1 1 1 1	240641-1	SPACER	5
- 1 1 1 1 1	238009-1	BLOCK, FL CRIMPER SPACER	4
1 1 1 1 1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
- 1 1 1 1 1	455888-4	SPACER, CRIMPER	2
1 1 1 1 1	1-456408-8	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	REV
mm	0 PLC ±	27DEC2011	1
Ø	1 PLC ±	27DEC2011	2
PLC	2 PLC ±	27DEC2011	3
3 PLC	3 PLC ±	27DEC2011	4
4 PLC	4 PLC ±		
ANGLES	±		
FINISH	±		

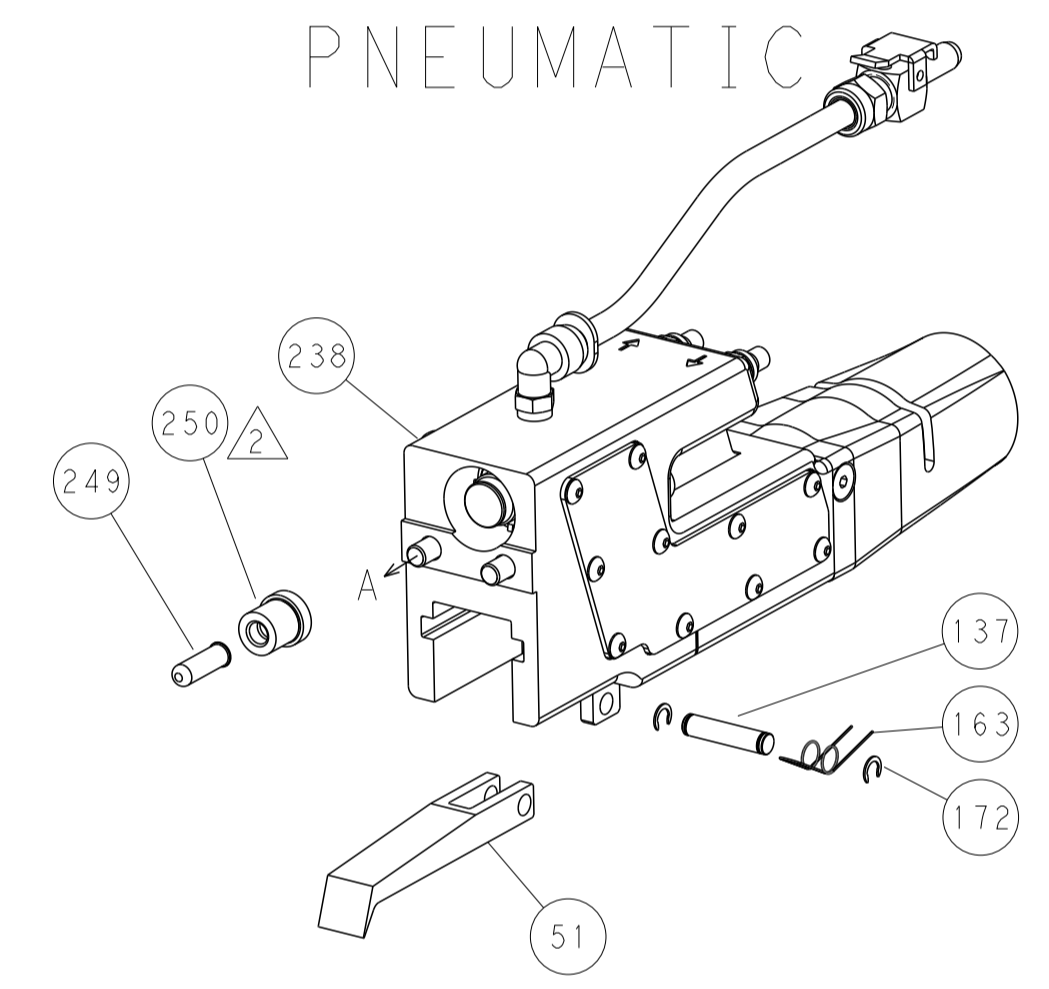
LOC	DIST	REVISIONS					
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



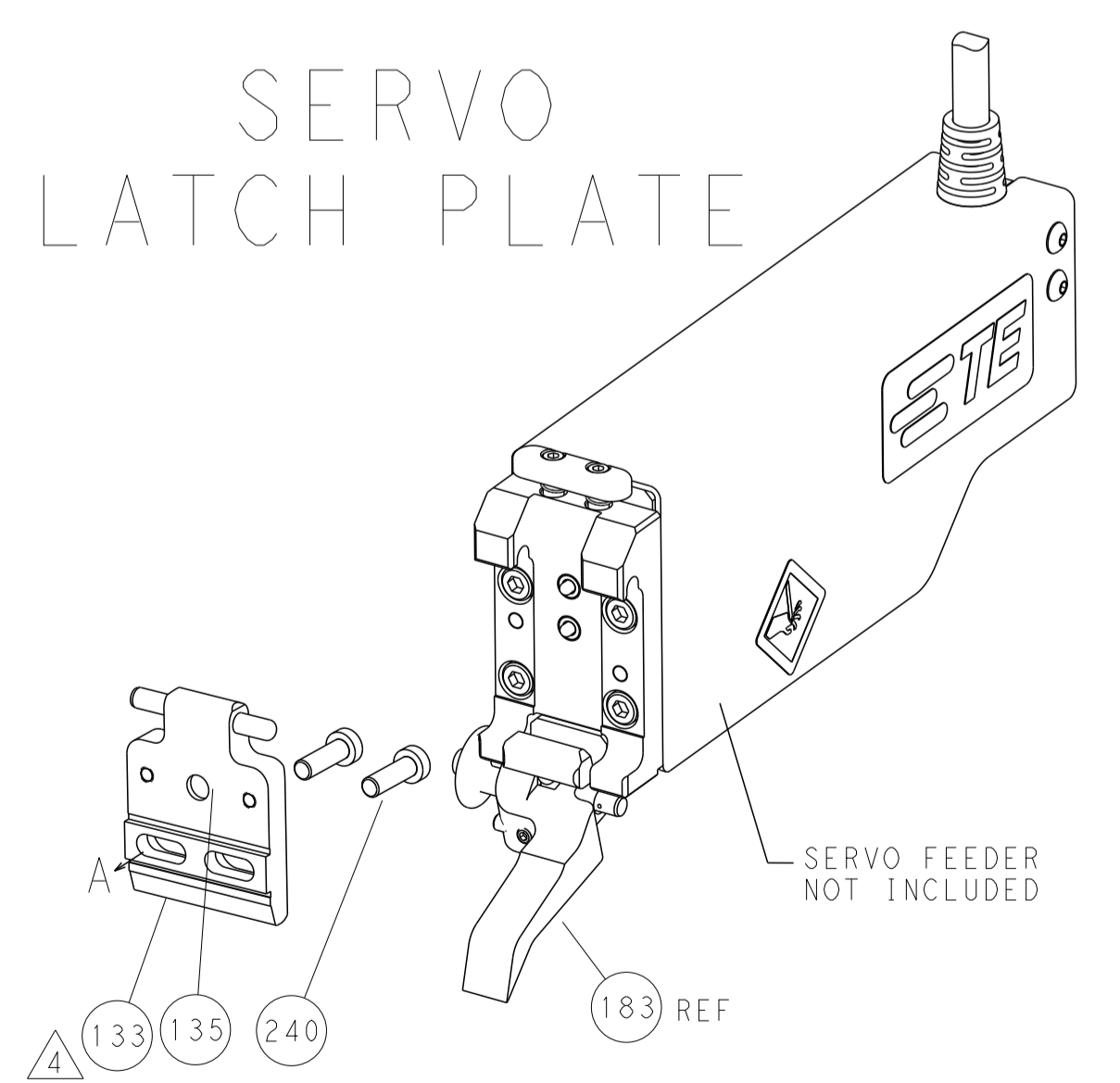
FEED TYPE  
MECHANICAL



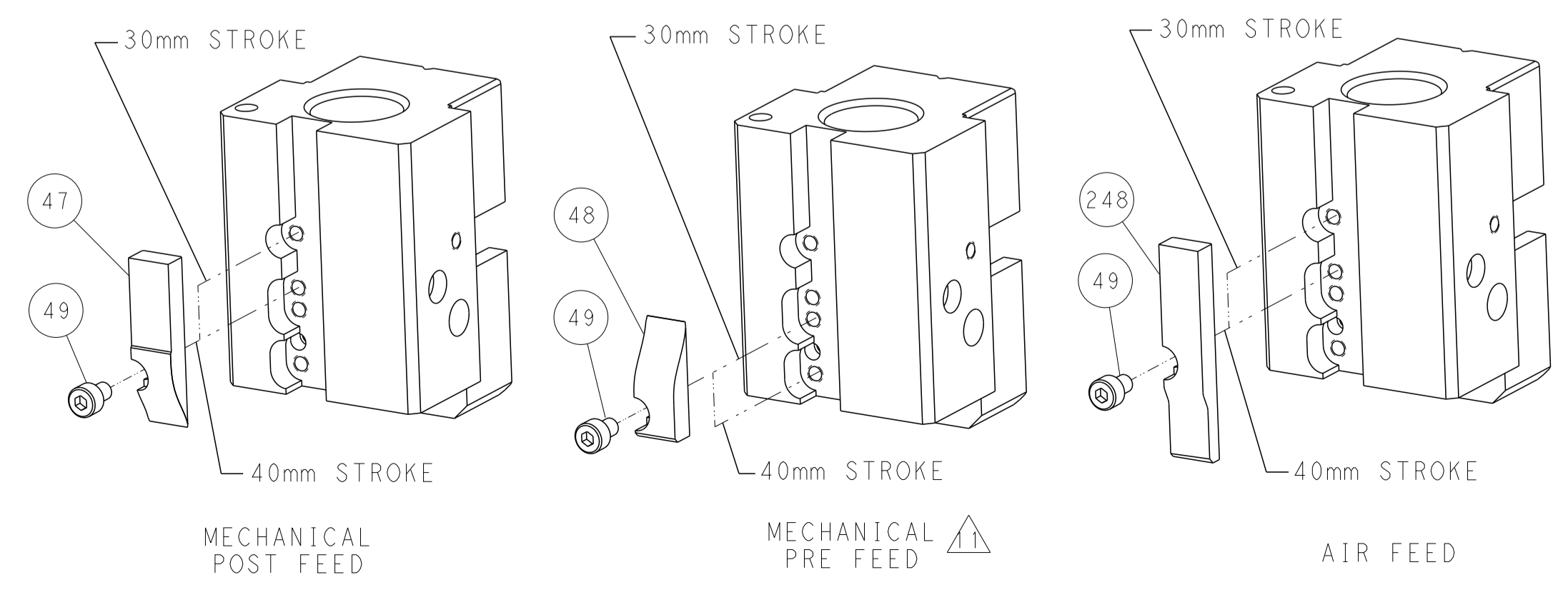
PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 27DEC2011		TE Connectivity	
mm	0 PLC	±		CHK: G. BAILEY 27DEC2011	NAME: Ocean End Feed Applicator		TE Connectivity Harrisburg, PA 17105-3608
	1 PLC	±		APVD: S. XI 27DEC2011	RESTRICTED TO:		
	2 PLC	±		PRODUCT SPEC	SIZE: A1		CAGE CODE: 00779
	3 PLC	±		APPLICATION SPEC	DRAWING NO: C-2150014		SCALE: 1:1
	4 PLC	±		WEIGHT	SHEET 2 OF 4		REV B
	ANGLES	±		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE: 1:1		SHEET 2 OF 4
	FINISH	±		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION			

APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED. Includes rows for PNEUMATIC FEED, SERVO LATCH PLATE, MECHANICAL FEED, SMART APPLICATOR, MECHANICAL FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, PNEUMATIC FEED.

APPLICATOR DATA. Table with columns: CRIMP, SIZE, TYPE. Includes rows for WIRE, INSUL, APPL INSTRUCTIONS.

TERMINAL DATA: TE TERMINAL, TE CRIMP SPECIFICATION. Includes rows for TERMINAL NAME, WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.



- 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.
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 AND 50.
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.
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.

\*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Includes rows for FINE ADJUST HEAD ASM, PUSH ROD, BUSHING, PART NO, DESCRIPTION, ITEM NO.

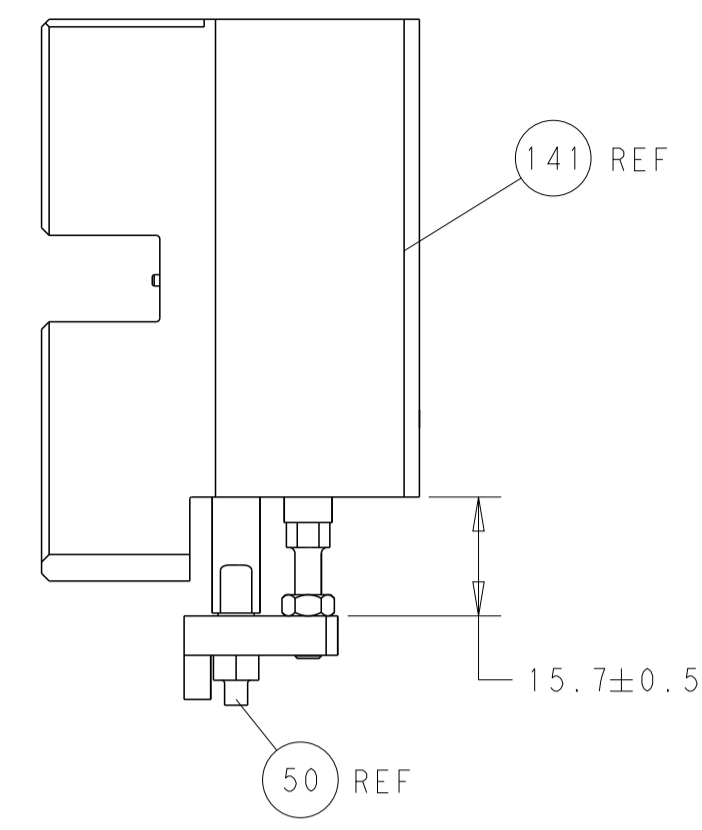
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

REVISIONS. Table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Includes row for SEE SHEET 1.

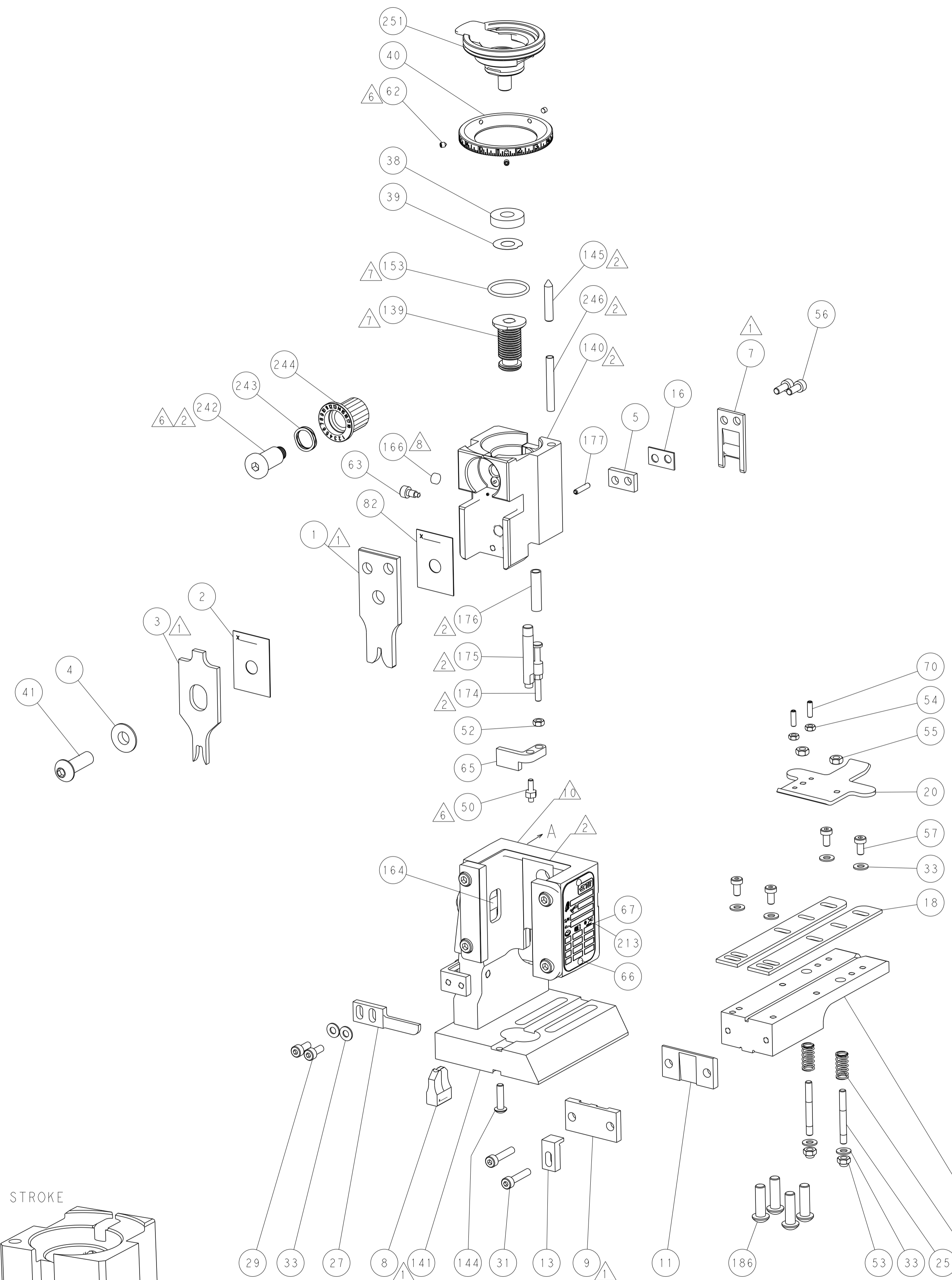
Main parts list table with columns: QTY, P, LTR, DESCRIPTION, DATE, DWN, APVD. Includes rows for SPRING, COMPRESSION; CAM, SNAIL, INSULATION ADJUSTMENT; WASHER, WAVE SPRING, CREST-TO-CREST; RETAINER, INSULATION DIAL; SHCS, LOW HEAD, RoHS, M5 X 10; MECHANICAL FEED ASSEMBLY; AIR FEED MODULE; TAG, IDENTIFICATION; SCR, BHSC, RoHS (M6 X 20); FEED FINGER ASSEMBLY, EF; PIN, SLOTTED SPRING 3.0 X 14.0; SPRING, COMPRESSION; GUIDE PIN, HOLDDOWN; GUIDE PIN, HOLDDOWN; RING, RETAIN, EXTERN, 3/16 CRESCENT; MAGNET, RARE EARTH HIGH ENERGY; COUNTER, MAGNETIC; SPRING, FEED FINGER; O-RING, .801 ID, .070 DIA. MAT.; FEED CAM, AIR FEED; DETENT PIN; SCR, BHSC, RoHS (M4 X 16); FEED CAM, POST FEED; APPLICATOR BASIC ASSEMBLY, EF; RAM, ASIAN STYLE, END FEED; BOLT, ADJUSTMENT; PIN, RETAIN, GRVD, 3/16 X .854; MEMORY CHIP, PROGRAMMED; SERVO FEED LATCH ASM; SPACER, CRIMPER; DOCUMENTATION PACKAGE; SCR, SET, FLT POINT M3 X 10.0; TAG, IDENTIFICATION; SCREW, DRIVE, RH, RoHS, 2 x .188; HOLDDOWN, TERMINAL; LIMITER, ADJUSTMENT BOLT; SCR, SET, SOC, CONE POINT, M3 x 4.0; SCR, HEX HD CAP, M4 X 6.0; FEED FINGER; SHCS, LOW HEAD, RoHS, M4 X 8; SCR, SKT HD CAP, RoHS, M4 X 10; NUT, HEX, REG, RoHS, M4; NUT, HEX, REG, RoHS, M3; NUT, LOCK, HEX, TORQUE (M4); NUT, HEX, REG, RoHS, M3.5; PAWL, EF, AIR; STANDOFF, HOLD-DOWN; SCR, SKT HD CAP M4 X 6.0; FEED CAM, PRE FEED; SCR, BHSC, RoHS (M8 X 25); DISC, NUMBERED FA WIRE ADJUSTMENT; APPLICATOR SHIM PACK; RAM WASHER, PRECISION; WASHER, FLAT, REG M4; SCR, SKT HD CAP, RoHS, M4 X 20; SCR, SKT HD CAP, RoHS, M4 X 10; STRIPPER (MACHINING); STUD, THREADED; PLATE, STRIP GUIDE; SPRING, COMPRESSION; DRAG; GUIDE, LOWER STRIP; SPACER; SPACER, HOLD-DOWN; PLATE, REAR SHEAR; PLATE, FRONT SHEAR; ANVIL, COMBINATION; BLADE, SLUG; SPACER; BLOCK, FL CRIMPER SPACER; CRIMPER, INSULATION F PREMIUM; SPACER, CRIMPER; CRIMPER, WIRE PREMIUM.

TE Connectivity logo and address: Harrisburg, PA 17105-3608. Includes fields for DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE, SHEET 3 OF 4, REV B.

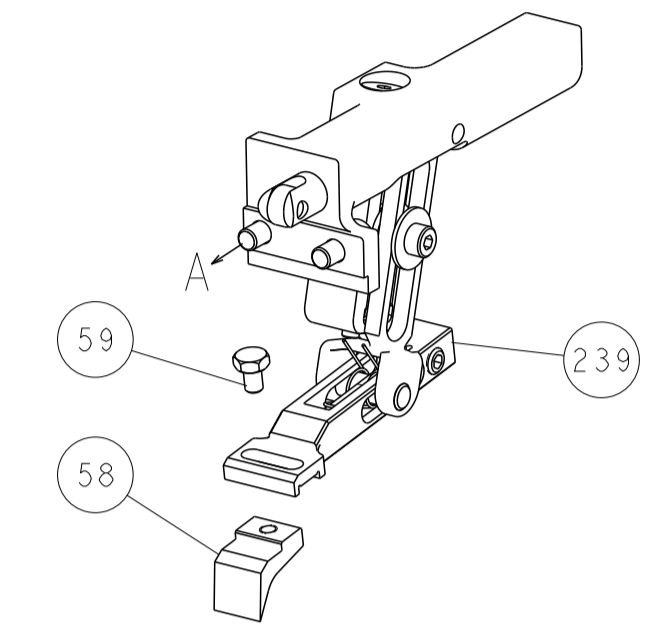
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
-			SEE SHEET 1	-	-



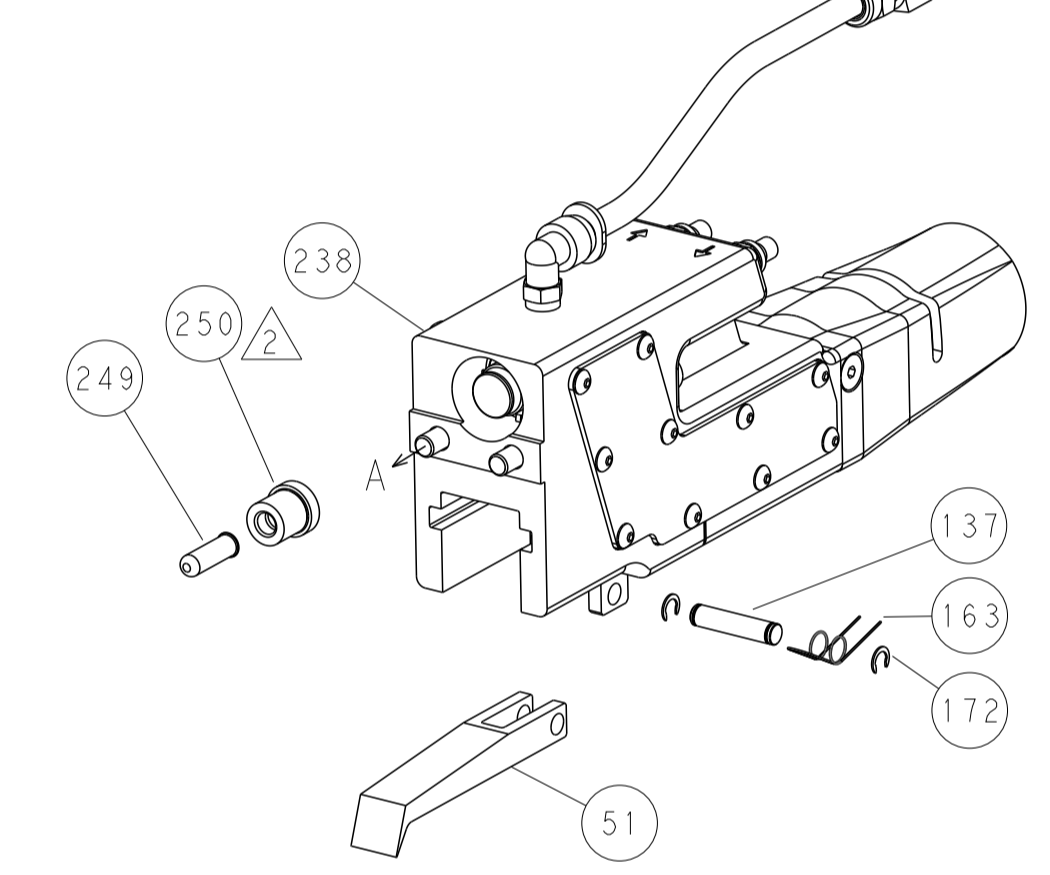
HOLDDOWN SET-UP



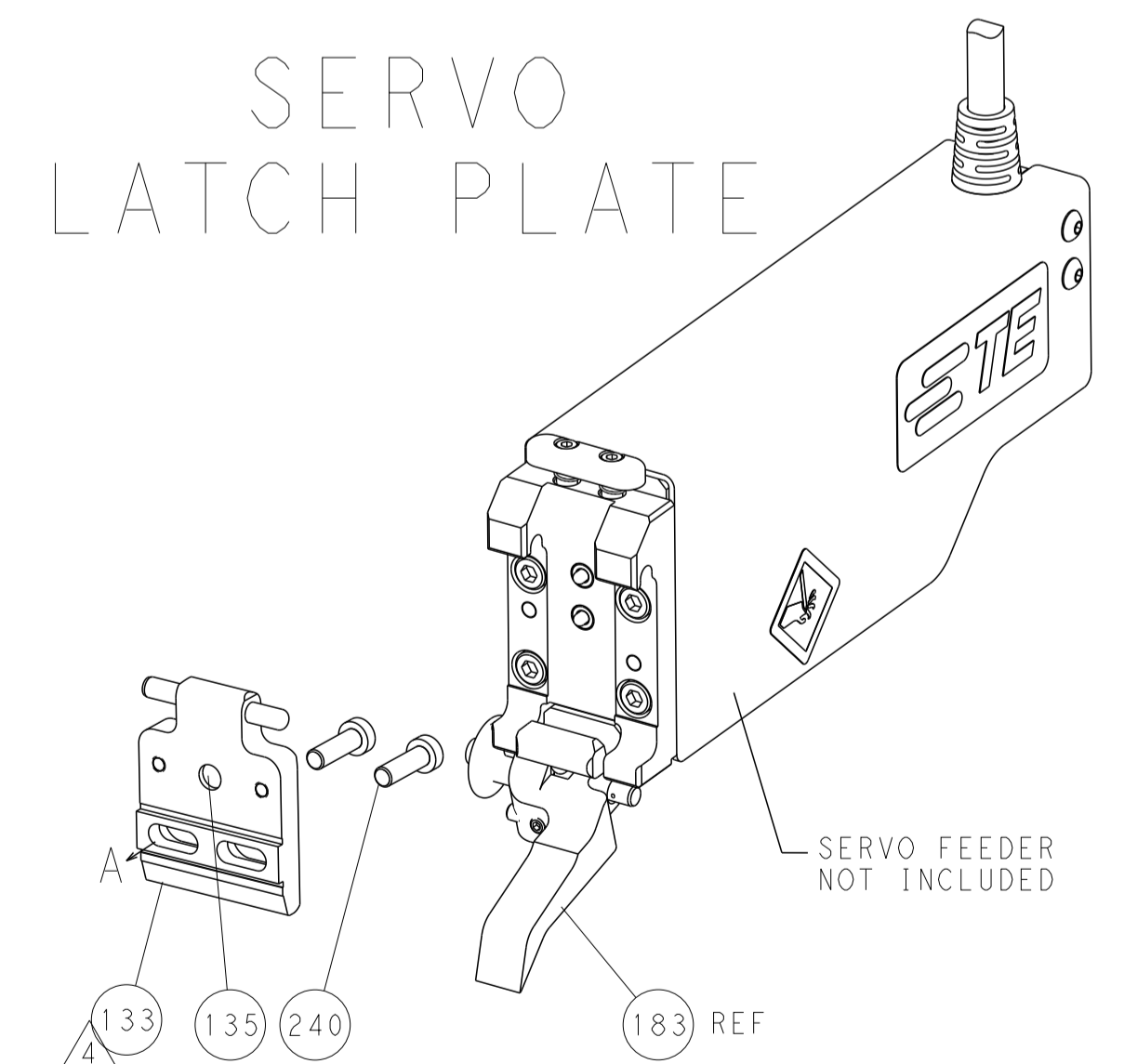
FEED TYPE  
MECHANICAL



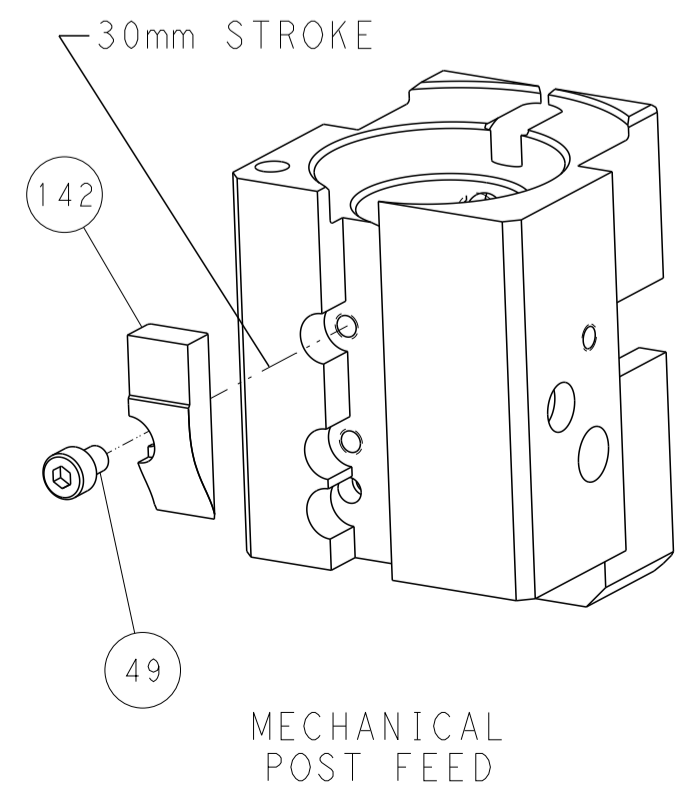
PNEUMATIC



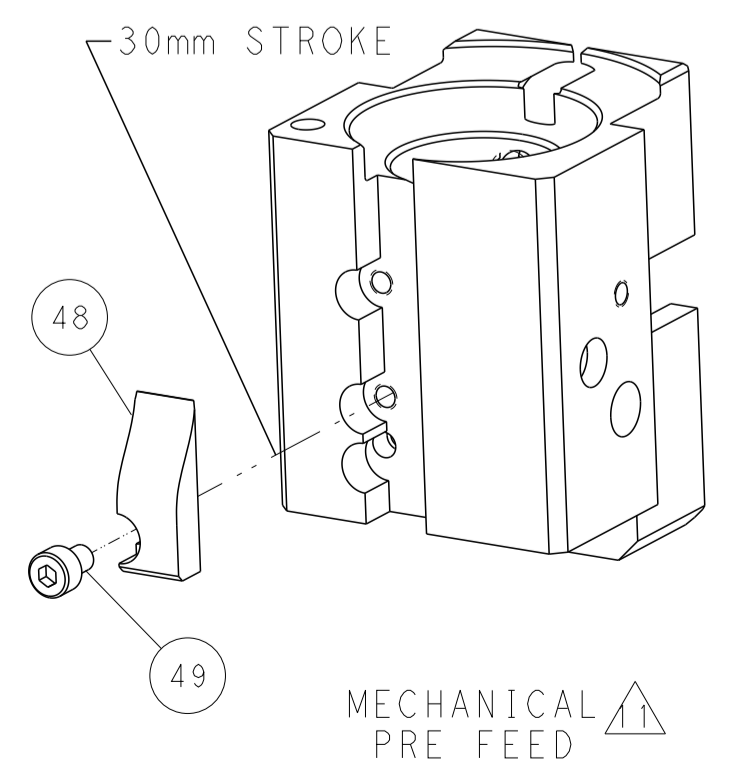
SERVO  
LATCH PLATE



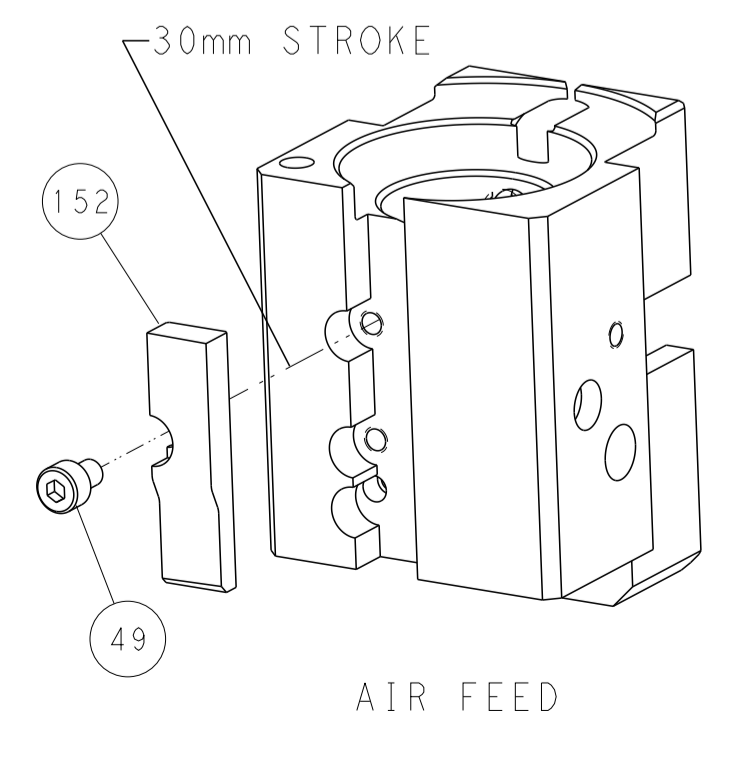
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 27DEC2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: G. BAILEY 27DEC2011		NAME: Ocean End Feed Applier	
-		-		S. XI 27DEC2011		SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2150014	
-		-		APVD: S. XI 27DEC2011		RESTRICTED TO:	
-		-		PRODUCT SPEC:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
-		-		APPLICATION SPEC:		SCALE: 1:1 SHEET 4 OF 4 REV B	
-		-		WEIGHT:		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	