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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150293-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
2150293-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
2150293-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ¹¹
2150293-7	A	FINE CRIMP HEIGHT ADJUST	NONE
7-2150293-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.94 mm [.155]	F

APPLICATOR INSTRUCTIONS 408-10390

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RING

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.59-6.35 mm [.220-.250 IN]	∅2.54-3.56 mm [.100-.140 IN]

TERMINAL APPLICATION SPECIFICATION 114-2084

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63518-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.16 +/- 0.05 [.085 +/- .002]	5.9
16 AWG	1.93 +/- 0.05 [.076 +/- .002]	8.2
18 AWG	1.80 +/- 0.05 [.071 +/- .002]	9.7

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150293-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150293-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150293-6
- 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 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 11 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.

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

REVISIONS

REV	DATE	DESCRIPTION	BY	CHK	APPV
A	07FEB2013	RELEASED	RBK		GB

REV	DATE	DESCRIPTION	BY	CHK	APPV
-	-	1 - -	2119957-2	APPLICATOR SHIM PACK	260
-	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	2119798-1	DETENT PIN	247
-	1	- 1 1	1-22279-3	SPRING, COMPRESSION	246
-	-	1 - -	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1 1 1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2 2 -	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	- - -	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	- - 1	2063440-2	AIR FEED MODULE	238
-	-	1 1 -	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF -	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	-	- - 2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1 1 1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	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	455888-4	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 1	2119943-1	WASHER, SPACER	69
-	1	- - 1	2119740-1	TAG, IDENTIFICATION	67
-	2	2 2 2	2168078-1	SCREW, DRIVE, RH, RoHS	66
-	1	- 1 1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	- 3 3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	1	1 1 1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	- - -	2063961-1	FEED FINGER	58
-	4	4 4 4	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	2119792-1	PAWL, EF, AIR	51
-	-	- - 1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1 1 1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	- 1 1	2119369-1	RAM, AMP STYLE, END FEED	44
-	1	1 1 1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	- 1 1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	- 1 1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1 1 1	2119644-2	RAM WASHER, PRECISION	38
-	1	1 1 1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	- 1 1	2119092-1	BOLT, ADJUSTMENT	35
-	8	8 8 8	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
-	2	2 2 2	2-22281-3	SPRING, COMPRESSION	22
-	1	1 1 1	1752373-4	DRAG	20
-	1	1 1 1	1901696-3	STRIP GUIDE, REAR	19
-	1	1 1 1	1901695-3	STRIP GUIDE, FRONT	18
-	4	4 4 4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1 1 1	240641-6	SPACER	16
-	1	1 1 1	240644-1	PLATE, REAR SHEAR	11
-	2	2 2 2	240645-1	SPACER, SHEAR PLATE	10
-	1	1 1 1	690482-5	PLATE, FRONT SHEAR	9
-	1	1 1 1	2-1803000-2	ANVIL, COMBINATION, END FEED	8
-	1	1 1 1	2217206-7	BLADE, SLUG	7
-	1	1 1 1	2-240641-0	SPACER	5
-	1	1 1 1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1 1 1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1 1 1	1-455888-0	SPACER, CRIMPER	2
-	1	1 1 1	1-456408-9	CRIMPER, WIRE PREMIUM	1
-77-7	-6	-5 -2	PART NO	DESCRIPTION	ITEM NO

TE Connectivity
Harrisburg, PA 17105-3608

Product Name: Ocean End Feed Applicator

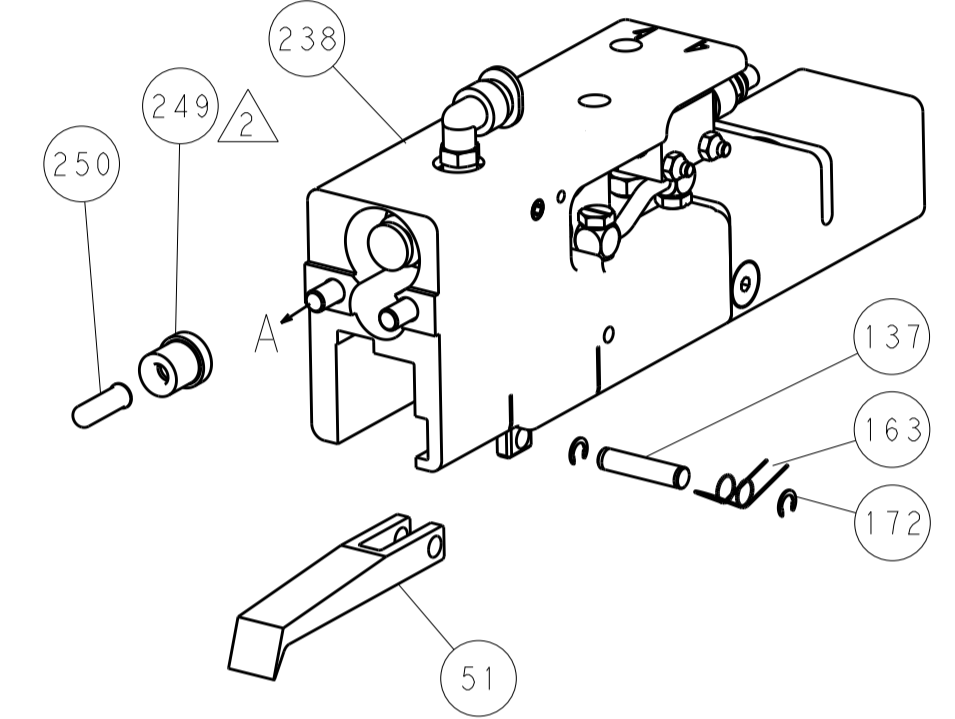
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Customer Accessible Production Drawing | Scale: 1:1 | Sheet: 1 of 4 | Rev: A

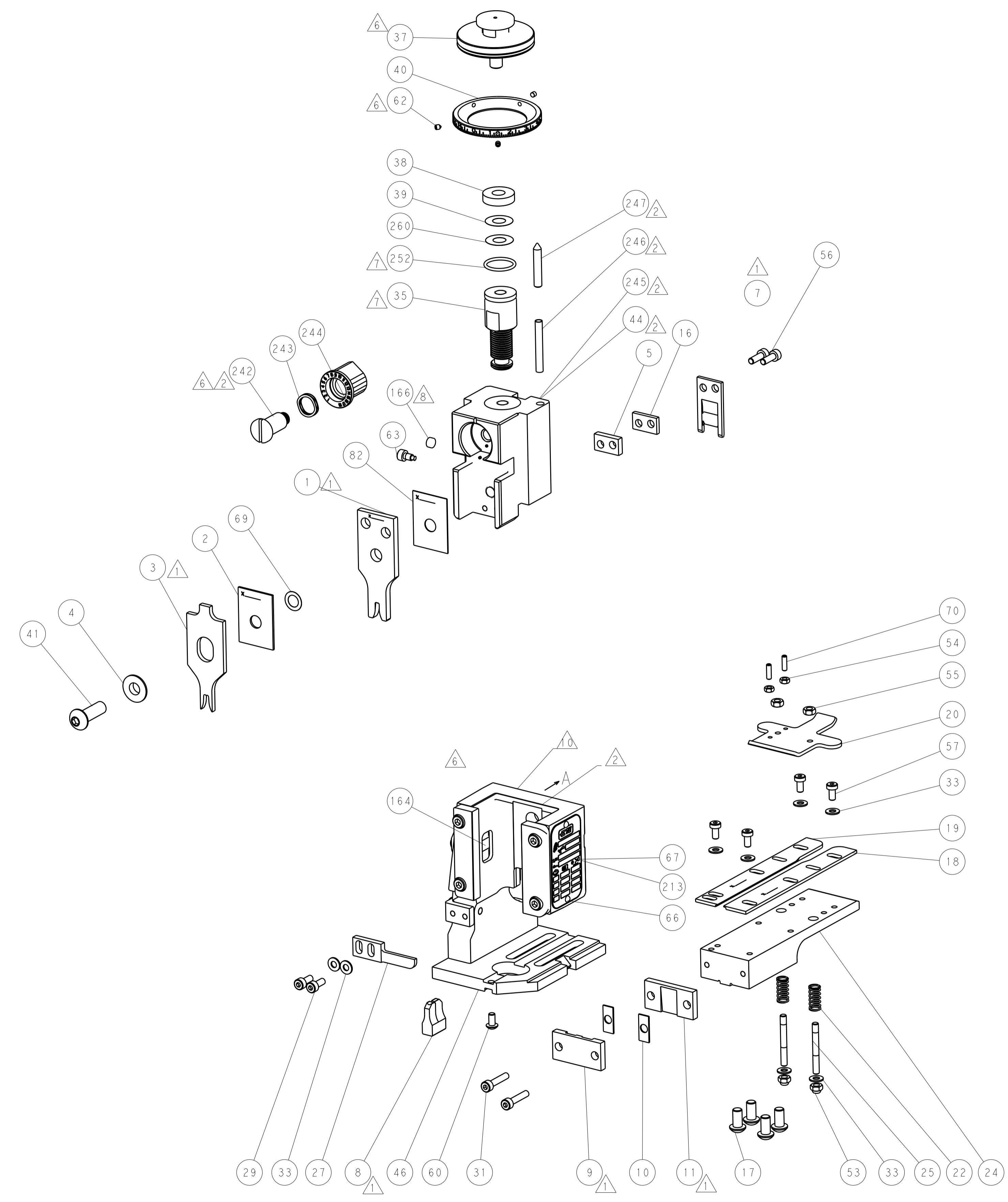
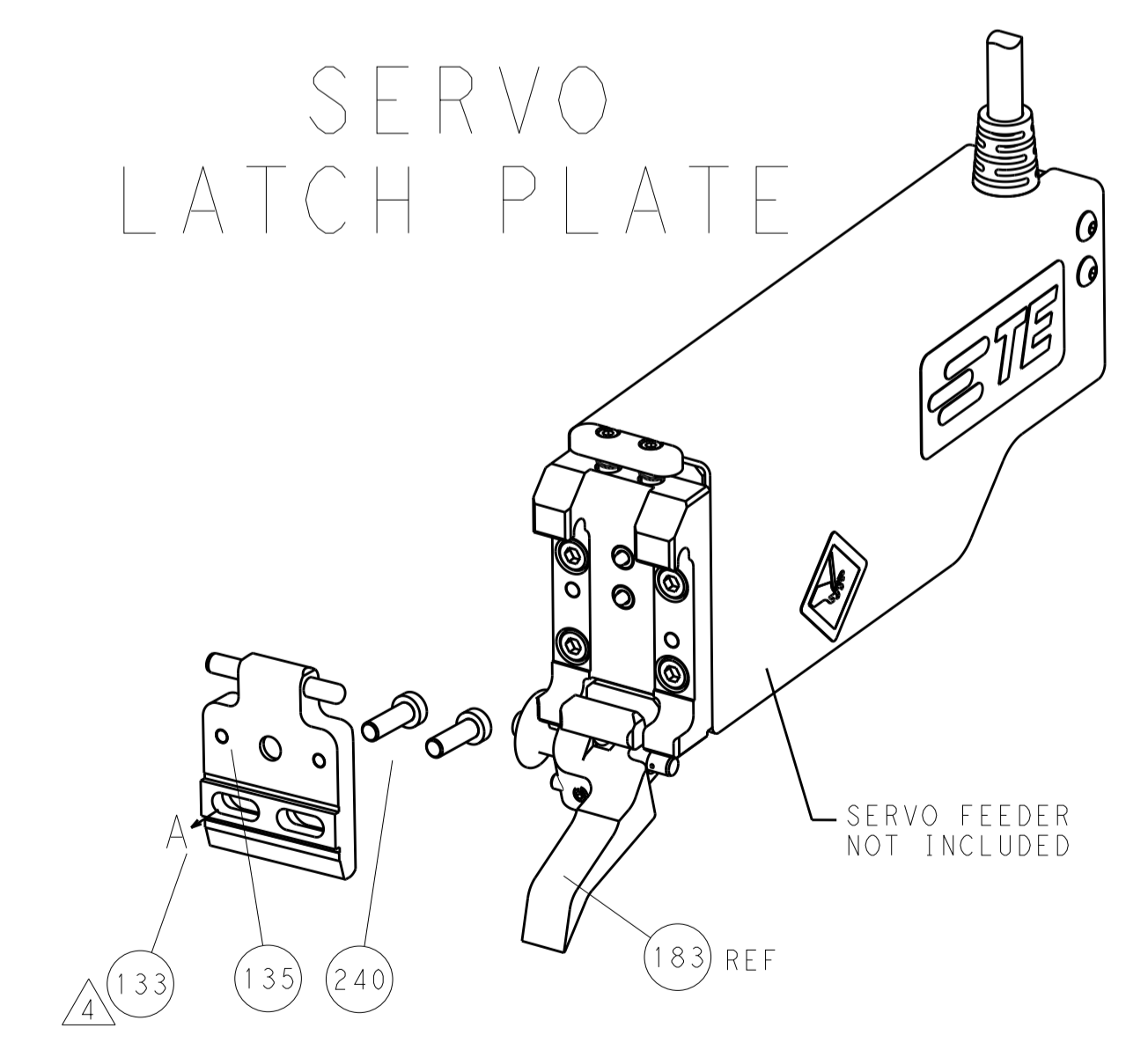
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

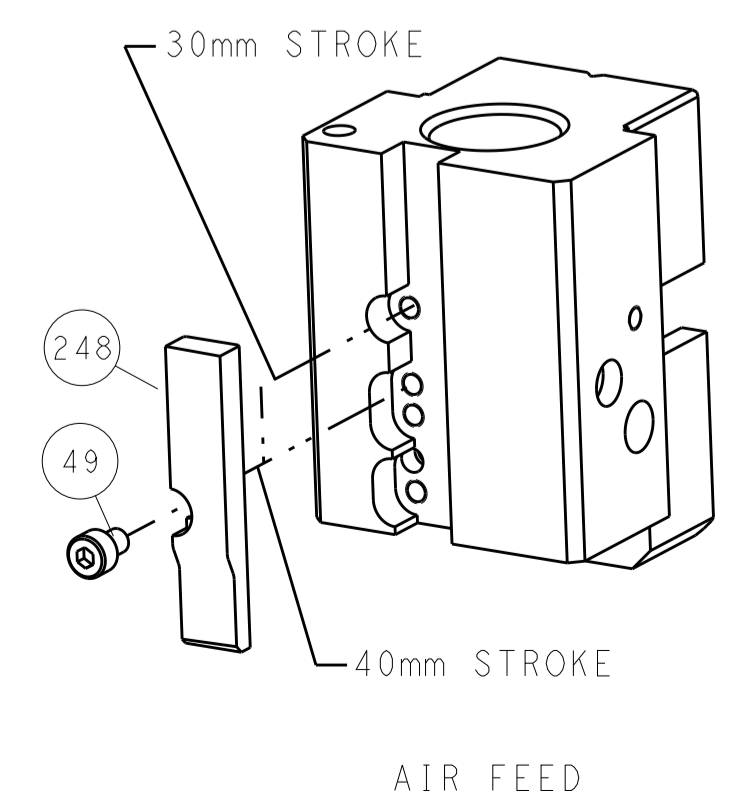
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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:		DWN		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	Y. YIN	24OCT2012	TE Connectivity Harrisburg, PA 17105-3608
	4 PLC ±0.001	5 PLC ±0.001	ANGLES ±0.001	FINISH	CHK	G. BAILEY	24OCT2012
MATERIAL					APVD	S. XI	24OCT2012
					NAME	Ocean End Feed Applicator	
					PRODUCT SPEC		
					APPLICATION SPEC		
					SIZE	CAGE CODE	DRAWING NO
					WEIGHT	A11 00779	©=2150293
					Customer Accessible Production Drawing	SCALE	1:1 SHEET 2 OF 4 REV A

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150293-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150293-5	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150293-4	-	-
	2-2150293-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-
2-2150293-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150293-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	3.94 mm (.155)	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RING		
WIRE STRIP LENGTH 5.59-6.35 mm (.220-.250 IN)		INSULATION DIAMETER RANGE Ø2.54-3.56 mm (.100-.140 IN)
TERMINAL APPLICATION SPECIFICATION 114-2084		-
TERMINALS APPLIED		
TE TERMINAL 63518-1	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
14 AWG	2.16+/-0.05 [.085+/-0.002]	5.9
16 AWG	1.93+/-0.05 [.076+/-0.002]	8.2
18 AWG	1.80+/-0.05 [.071+/-0.002]	9.7

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150293-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150293-5
- 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 62 & 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

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

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	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	2119798-2	DETENT PIN	145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	1	1	1	2119943-1	WASHER, SPACER	69
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	-	2063961-1	FEED FINGER	58
-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
-	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	1	2119792-1	PAWL, EF, AIR	51
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	2119644-2	RAM WASHER, PRECISION	38
-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1752373-4	DRAG	20
-	1	1	1	1901696-3	STRIP GUIDE, REAR	19
-	1	1	1	1901695-3	STRIP GUIDE, FRONT	18
-	1	1	1	240641-6	SPACER	16
-	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	240645-1	SPACER, SHEAR PLATE	10
-	1	1	1	690482-5	PLATE, FRONT SHEAR	9
-	1	1	1	2-1803000-2	ANVIL, COMBINATION, END FEED	8
-	1	1	1	2217206-7	BLADE, SLUG	7
-	1	1	1	2-240641-0	SPACER	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	1	1-456408-9	CRIMPER, WIRE PREMIUM	1

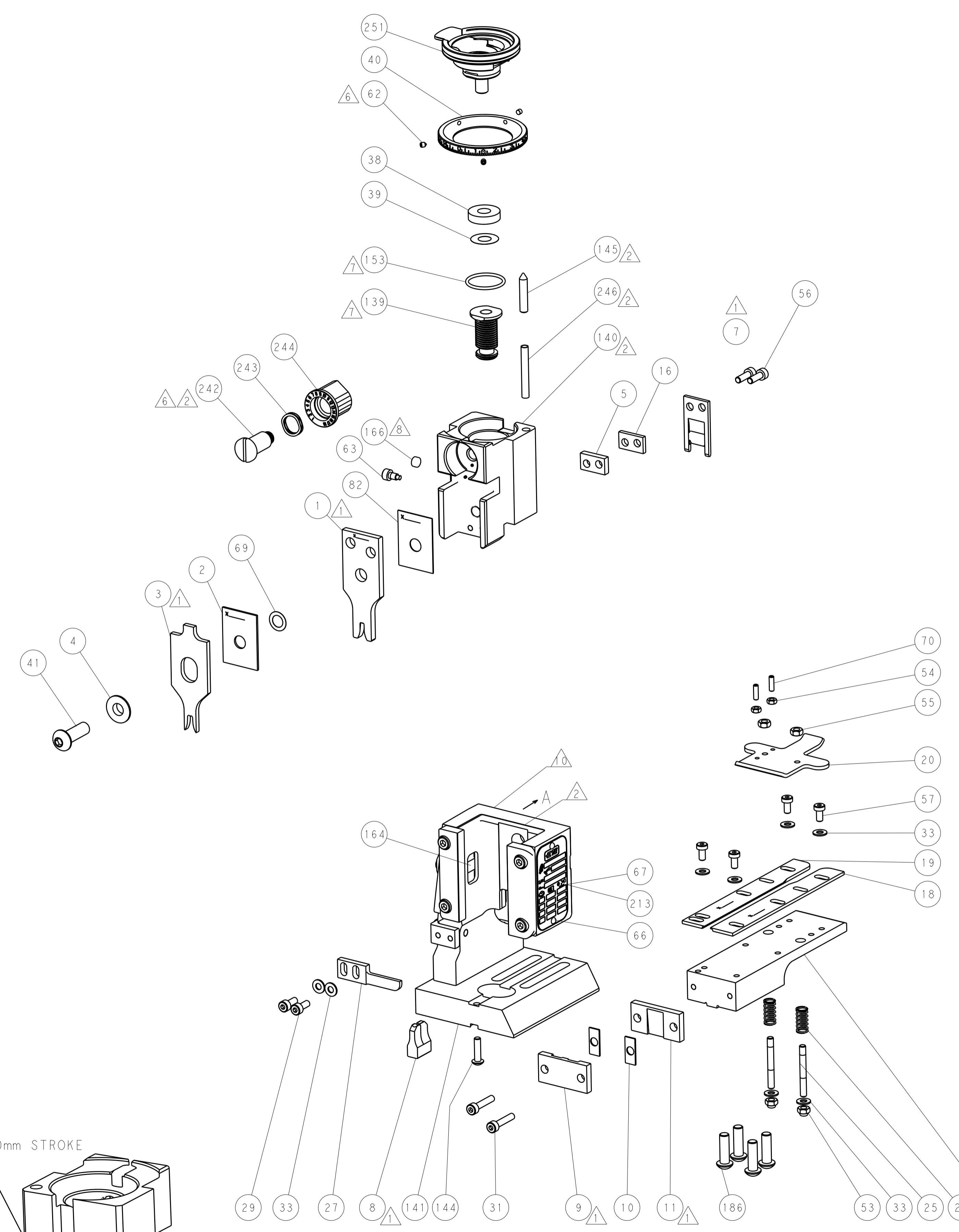
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013
	ANGLES ±.0001				
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV
			1:1	3 OF 4	A



TE Connectivity
 Harrisburg, PA 17105-3608
 Ocean End Feed
 Applicator

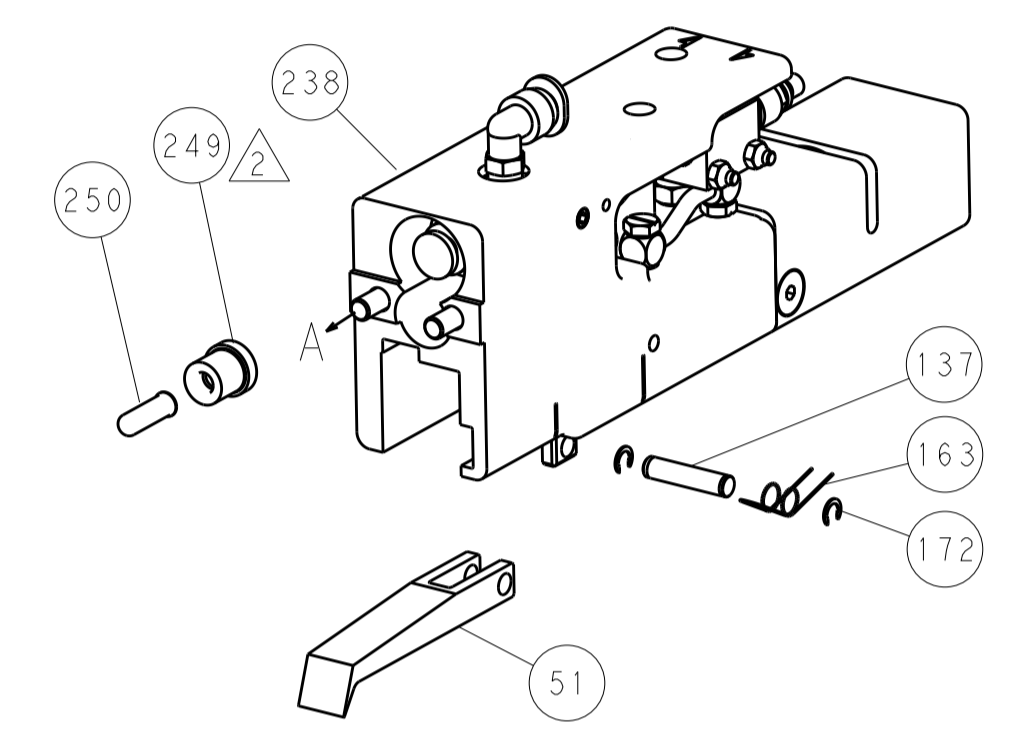
SIZE: A1
 CAGE CODE: 00779
 DRAWING NO: 2150293

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

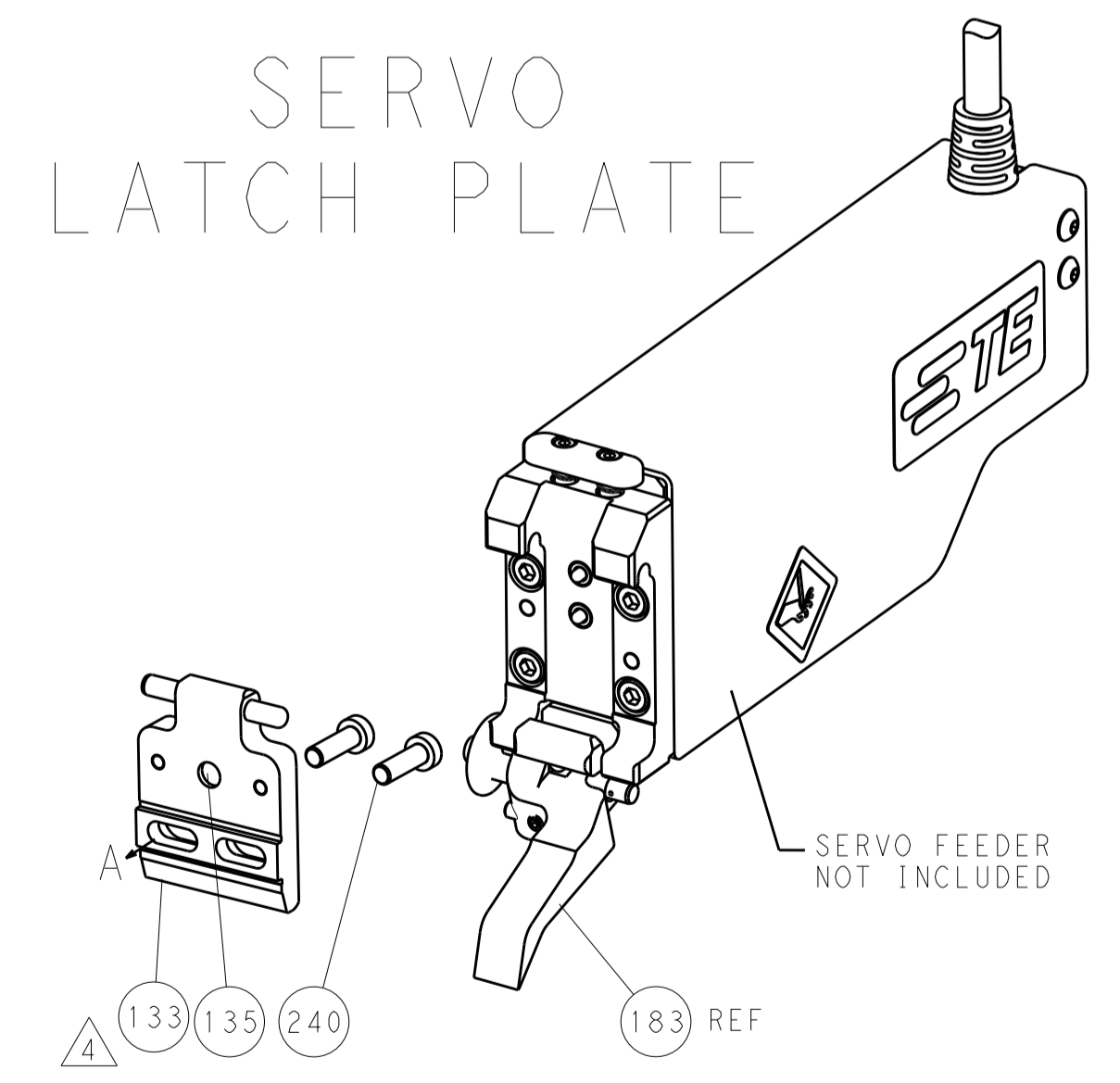


FEED TYPE

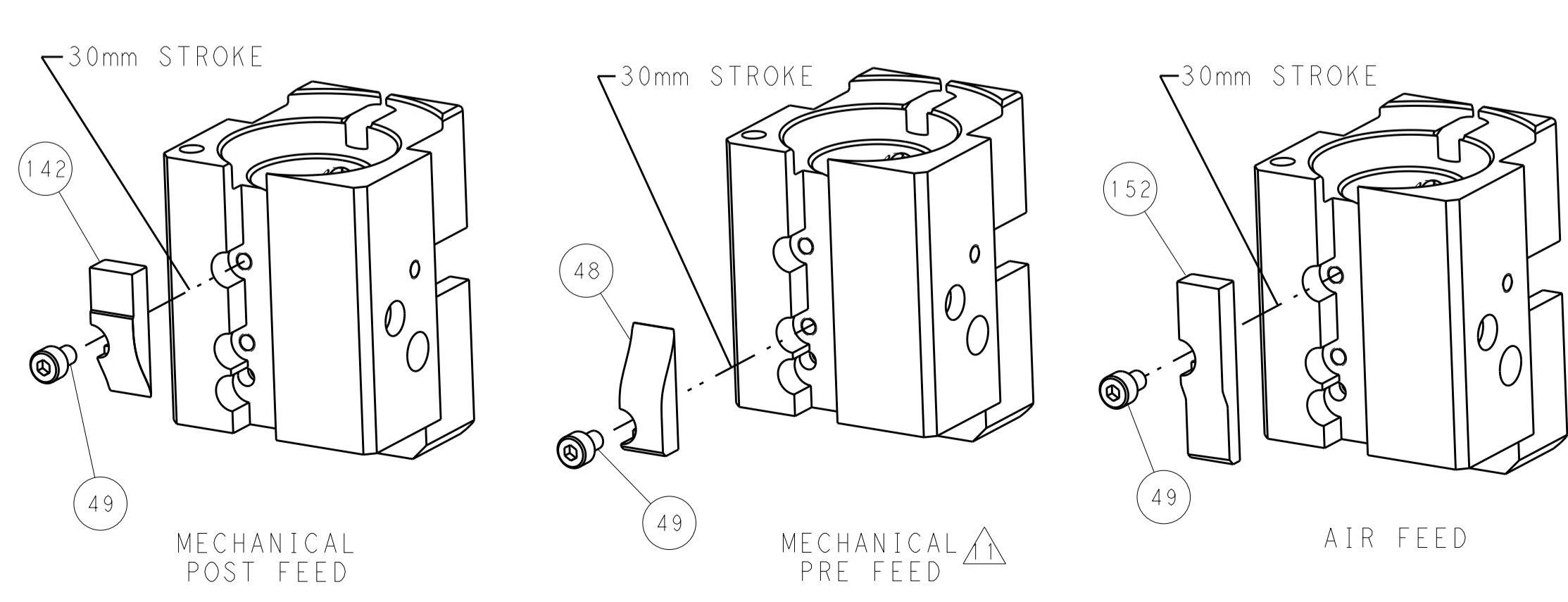
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 24OCT2012		CHK: G. BAILEY 24OCT2012		APVD: S. XI 24OCT2012		NAME: Ocean End Feed Applicator	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.0001	MATERIAL:		SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2150293
MATERIAL:		FINISH:		WEIGHT:		Customer Accessible Production Drawing		SCALE: 1:1		SHEET 4 OF 4 REV A	