

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2150052-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
	2150052-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150052-5	-	2168400-7 (QUANTITY 2)
	2150052-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>11</sup>	SMART APPLICATOR	2161326-1	-	8-2150052-4	-	-
	2150052-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	2063440-2
7-2150052-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.05 mm [.120]	OV
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RING TONGUE		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
5.50-6.50 mm [.217-.256 IN]		Ø1.40-2.10 mm [.055-.083 IN]
TERMINAL APPLICATION SPECIFICATION	114-2084	
TERMINALS APPLIED <sup>10</sup>		
TE TERMINAL	TE TERMINAL	TE TERMINAL
346102-1	346102-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>
1.00mm <sup>2</sup>	1.89+/-0.05 [.074+/-0.002]	4.7
0.75mm <sup>2</sup>	1.82+/-0.05 [.072+/-0.002]	5.4
0.50mm <sup>2</sup>	1.75+/-0.05 [.069+/-0.002]	6.0

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150052-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150052-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150052-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> 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.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> 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.

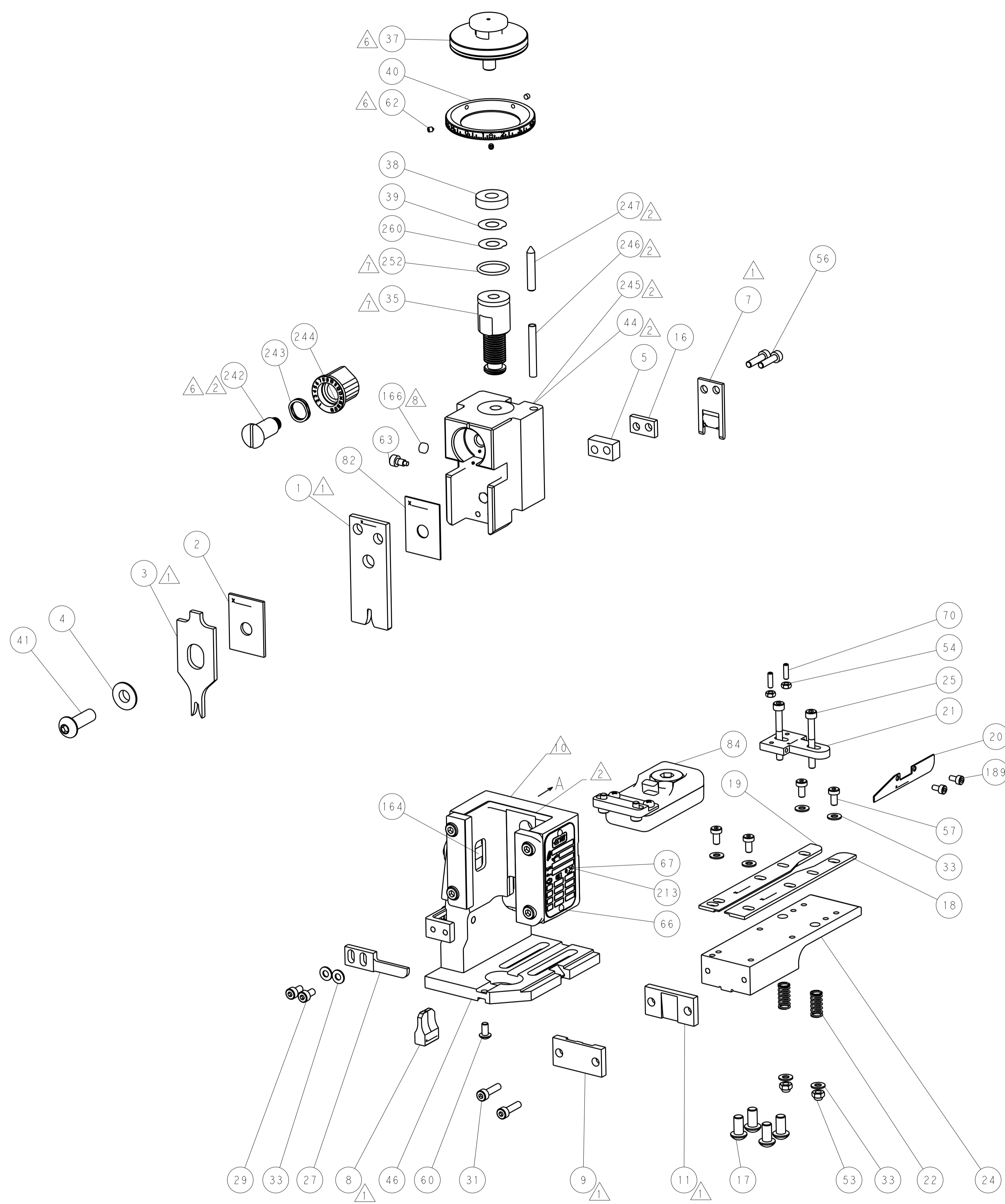
ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			A	RELEASED	24FEB2014	KH UG

-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	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	2119798-1	DETENT PIN	247
-	-	1	-	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	-	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	2	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	189
-	-	REF	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	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
-	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	-	1	1	1	455888-6	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	2119740-1	TAG, IDENTIFICATION	67
-	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	1	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	-	3	-	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	-	1	2119792-2	PAWL, EF, AIR	51
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	-	1	-	1	2119369-1	RAM, AMP STYLE, END FEED	44
-	-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	-	1	-	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	-	1	-	1	2119957-1	APPLICATOR SHIM PACK	39
-	-	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	-	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	-	1	-	1	2119092-1	BOLT, ADJUSTMENT	35
-	-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	-	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	-	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	-	1	1	1	1752371-1	PLATE, STRIP GUIDE	24
-	-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	-	1	1	1	1633168-1	ARM, STOCK DRAG	21
-	-	1	1	1	1-464452-6	DRAG, STOCK	20
-	-	1	1	1	2-1901696-7	STRIP GUIDE, REAR	19
-	-	1	1	1	2-1901695-7	STRIP GUIDE, FRONT	18
-	-	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	-	1	1	1	4-240641-6	SPACER	16
-	-	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	-	1	1	1	690482-4	PLATE, FRONT SHEAR	9
-	-	1	1	1	1333218-8	ANVIL, COMBINATION	8
-	-	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	1	1	1	2-240641-7	SPACER	5
-	-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	-	1	1	1	1803139-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	-	1	1	1	1-455888-6	SPACER, CRIMPER	2
-	-	1	1	1	456421-1	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

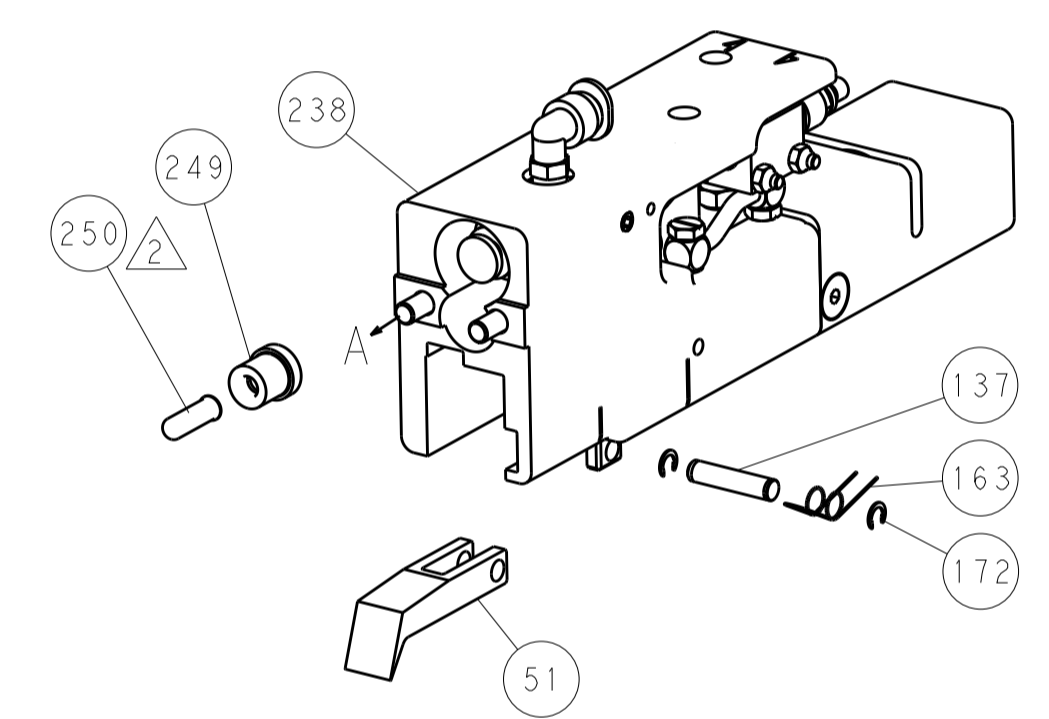
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mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.13	3 PLC ±.013	4 PLC ±.0001	ANGLES ±.0001	FINISH
				CHK H. HUANG 09FEB2012 S. XI 09FEB2012 APPV S. XI 09FEB2012		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150052 RESTRICTED TO: -	
MATERIAL: -				WEIGHT: -		Customer Accessible Production Drawing	
				SCALE: 1:1		SHEET 1 OF 4	

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

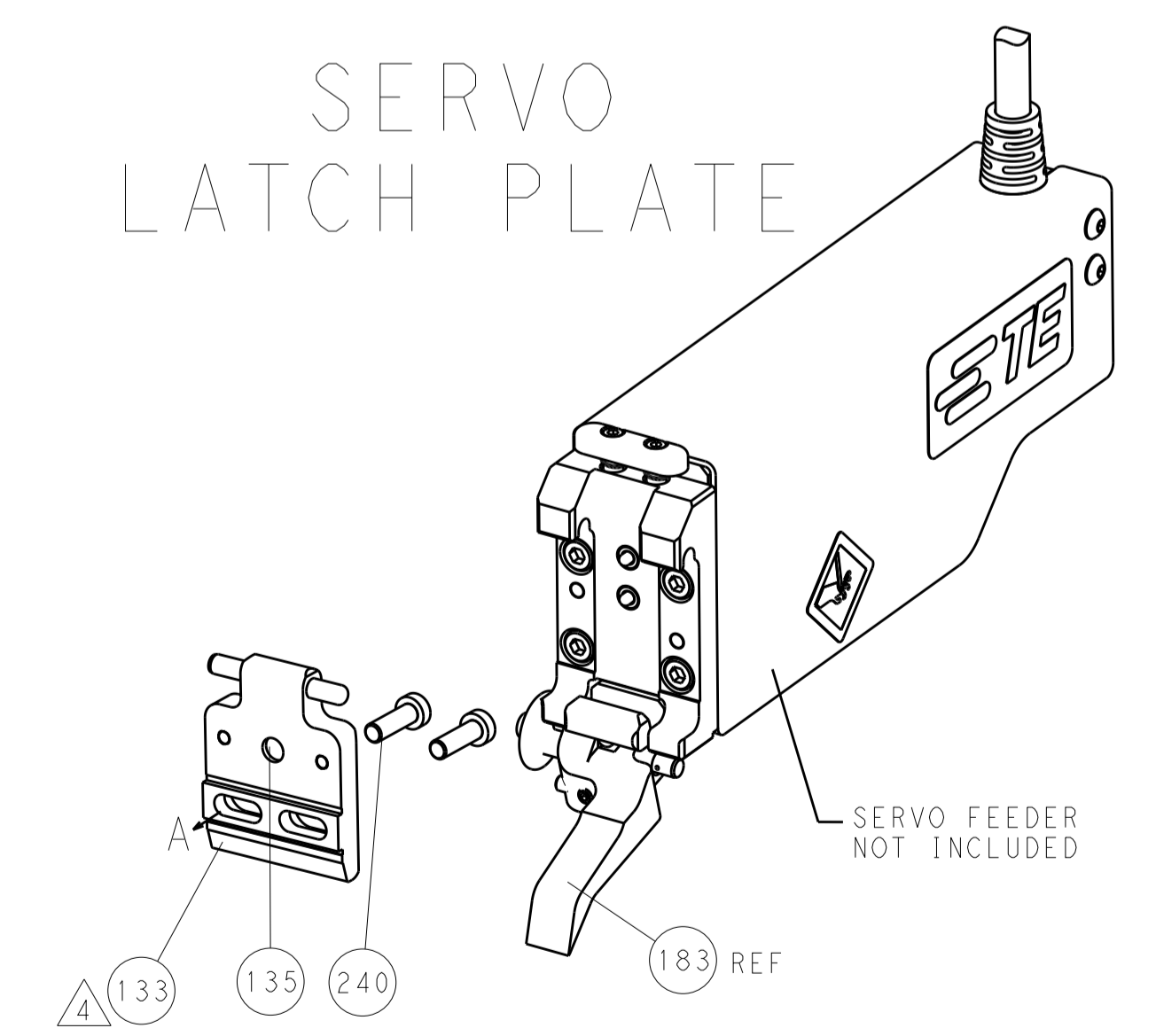


FEED TYPE

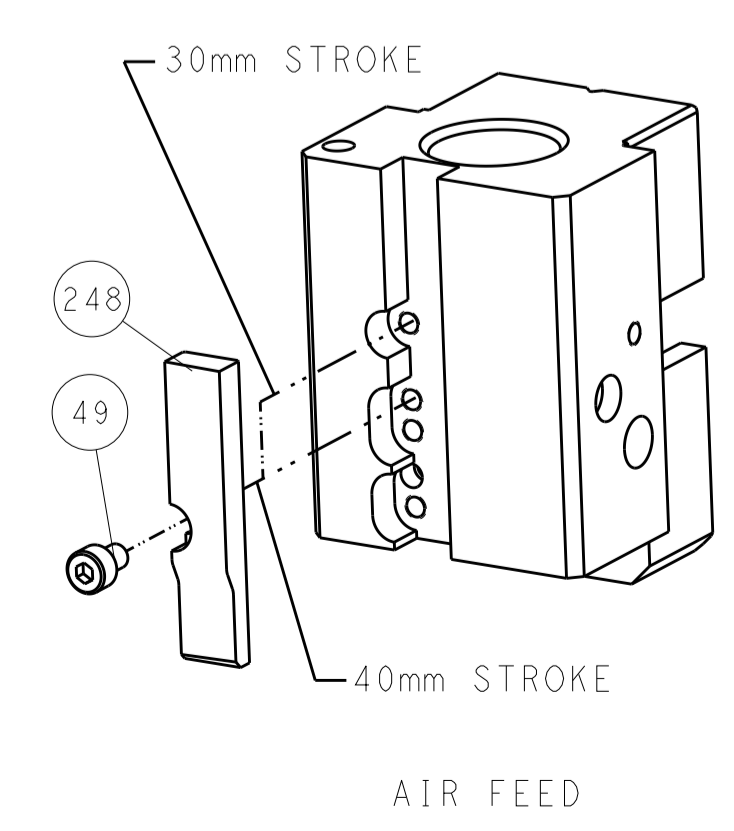
PNEUMATIC



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 K. HUANG 09FEB2012		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	APVD S. XI 09FEB2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME		Ocean End Feed Applicator	
				SIZE		RESTRICTED TO	
				A1 00779 ©=2150052			
				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				
	2-2150052-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150052-5	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150052-4	-	-
	2-2150052-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	-	-	-	-	-	-
2-2150052-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150052-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [ .100 ]	F
INSUL	3.05 mm [ .120 ]	OV
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RING TONGUE		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
5.50-6.50 mm [ .217-.256 IN ]		∅1.40-2.10 mm [ .055-.083 IN ]
TERMINAL APPLICATION SPECIFICATION	114-2084	-
TERMINALS APPLIED <sup>10</sup>		
TE TERMINAL	TE TERMINAL	TE TERMINAL
346102-1	346102-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>
1.00mm2	1.89 +/- 0.05 [ .074 +/- .002 ]	4.7
0.75mm2	1.82 +/- 0.05 [ .072 +/- .002 ]	5.4
0.50mm2	1.75 +/- 0.05 [ .069 +/- .002 ]	6.0

- 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: 8-2150052-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150052-5
- 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.

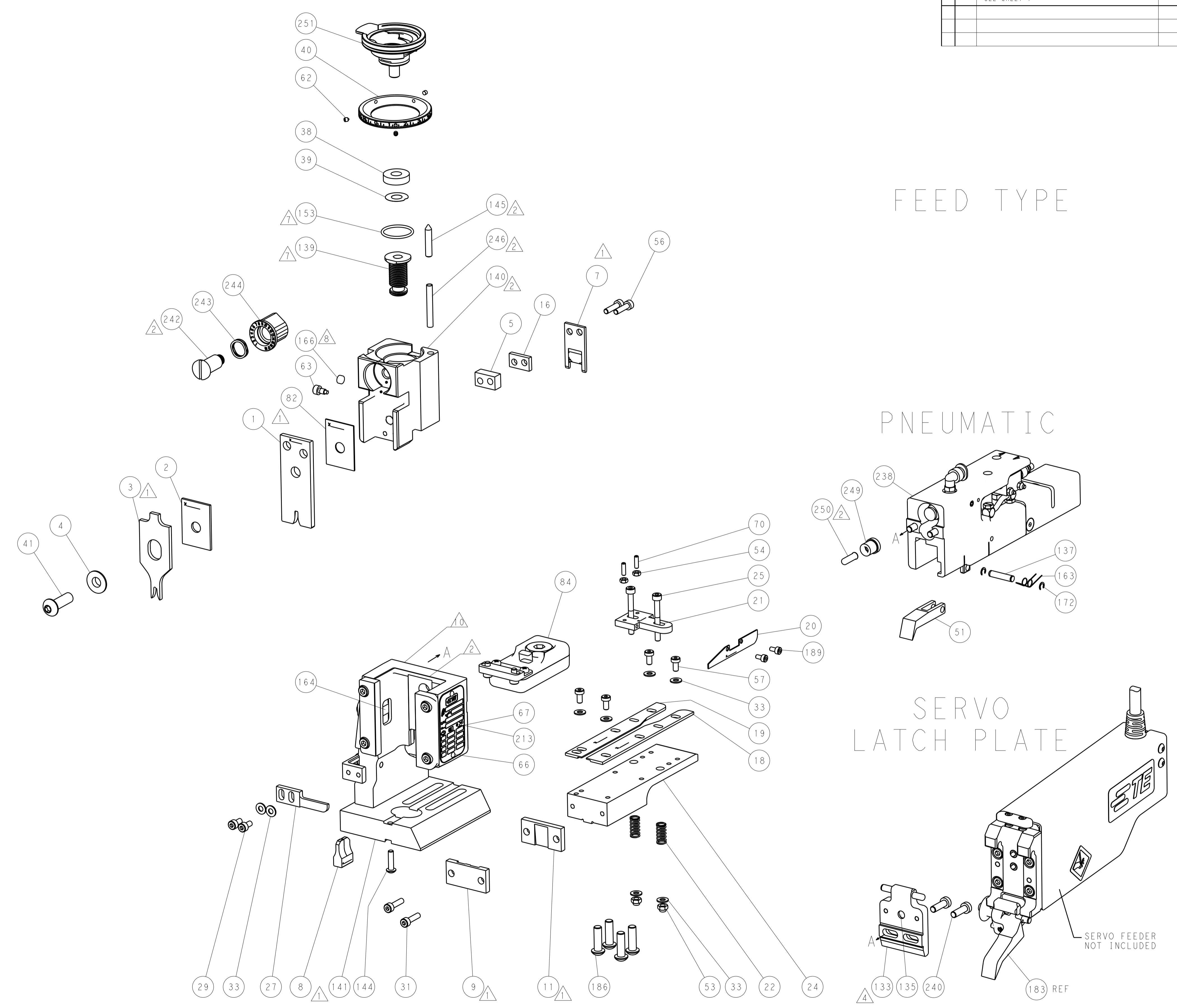
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

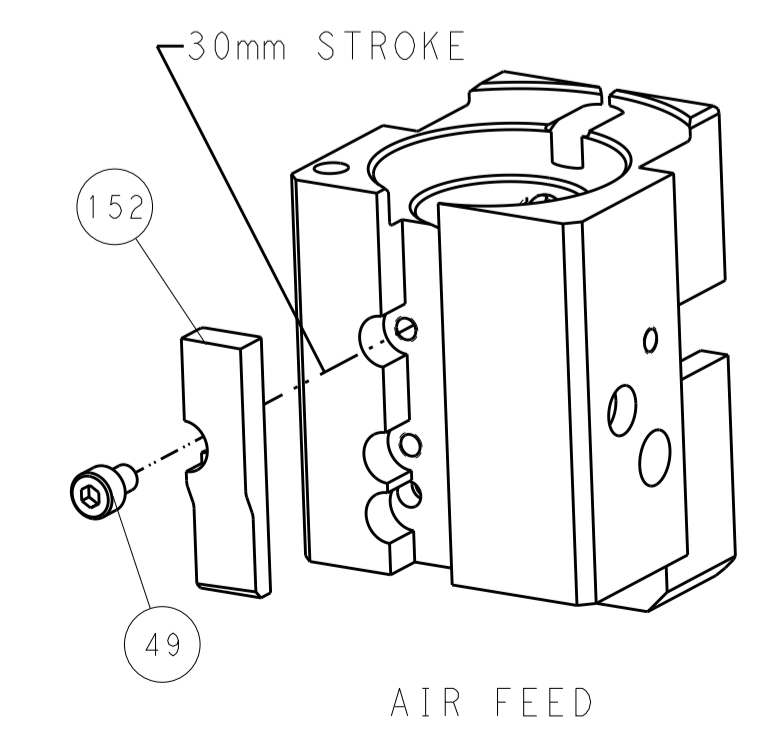
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
-	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	189
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	455888-6	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	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	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
-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	1	2119792-2	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	1-2119644-2	RAM WASHER, PRECISION	38
-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1752371-1	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1633168-1	ARM, STOCK DRAG	21
-	1	1	1	1-464452-6	DRAG, STOCK	20
-	1	1	1	2-1901696-7	STRIP GUIDE, REAR	19
-	1	1	1	2-1901695-7	STRIP GUIDE, FRONT	18
-	1	1	1	4-240641-6	SPACER	16
-	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
-	1	1	1	690482-4	PLATE, FRONT SHEAR	9
-	1	1	1	1333218-8	ANVIL, COMBINATION	8
-	1	1	1	1-2217206-0	BLADE, SLUG	7
-	1	1	1	2-240641-7	SPACER	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1803139-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1-455888-6	SPACER, CRIMPER	2
-	1	1	1	456421-1	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE		NAME	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	ANGLES ±.0001	FINISH	H. HUANG	09FEB2012
				S. XI		09FEB2012		S. XI	
MATERIAL		FINISH		PRODUCT SPEC		APPLICATION SPEC		WEIGHT	
								A1 00779 ©=2150052	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 3 OF 4		REV A	

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



CAM POSITION



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:		DWN L.H. HUANG 09FEB2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD S.XI 09FEB2012	NAME
	ANGLES ±0.0001	FINISH		PRODUCT SPEC			Ocean End Feed Applier
MATERIAL				APPLICATION SPEC			
				WEIGHT		SIZE CAGE CODE DRAWING NO	RESTRICTED TO
						A 00779 C=2150052	
				Customer Accessible Production Drawing	SCALE 1:1	SHEET 4 OF 4	REV A