

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150454-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	
	2150454-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150454-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150454-4	-	-	-
	2150454-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	
	2150454-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150454-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	6.10 mm [.240]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: HULANE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.85-5.61 mm [.191-.221 IN]		Ø 5.46mm [.215 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	HULANE TERMINAL	TE TERMINAL	HULANE TERMINAL
2113490-1	6616301B55	2113490-3	6616301B50
2113490-2	6616301B50		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	2.21+/-0.05 [.087+/- .002]	5.0
2.00mm2	2.00+/-0.05 [.079+/- .002]	7.0
1.50mm2	1.87+/-0.05 [.074+/- .002]	8.5
1.25mm2	1.80+/-0.05 [.071+/- .002]	9.0

- 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: 8-2150454-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150454-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150454-6
- 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 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 180.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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
- GRIND TO LENGTH AT ASSEMBLY.

***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	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-77	-7	-6	-5	-2	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	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
	A		RELEASED	15OCT2014	KH	UG
	A1		ECR-15-002038	06FEB2015	KH	TE

-	-	-	-	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	1	2119082-3	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
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REF	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1752354-9	STANDOFF, HOLD-DOWN	180
-	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	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	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	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2-1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	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
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	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	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	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	-	1	2119092-1	BOLT, ADJUSTMENT	35
-	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	1-1752371-4	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-3	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	1901259-6	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240833-7	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	7-690482-4	PLATE, FRONT SHEAR	9
-	1	1	1	1	1-1803060-2	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	7-240641-3	SPACER	5
-	1	1	1	1	238009-3	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	4-2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1	1	456409-3	CRIMPER, WIRE .120 "F" PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME		
mm	0 PLC ±.5	1 PLC ±.3	2 PLC ±.2	3 PLC ±.15	4 PLC ±.1	5 PLC ±.08	6 PLC ±.05	7 PLC ±.03	8 PLC ±.02	9 PLC ±.01	ANGLES ±.0001	FINISH
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV		
Customer Accessible Production Drawing		SCALE 1:1		SHEET 1 OF 4		REV A1		DATE 14AUG2014		NAME Ocean End Feed Applicator		

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2150454-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2150454-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
	2-2150454-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2150454-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	6.10 mm [.240]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: HULANE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.85-5.61 mm [.191-.221 IN]		∅ 5.46mm [.215 IN] MAX	
TERMINAL APPLICATION SPECIFICATION			
NONE			
TERMINALS APPLIED			
TE TERMINAL	HULANE TERMINAL	TE TERMINAL	HULANE TERMINAL
2113490-1	6616301BSS	2113490-3	6616301BWO
2113490-2	6616301BS0		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
3.00mm2		2.21+/-0.05 [.087+/- .002]		5.0
2.00mm2		2.00+/-0.05 [.079+/- .002]		7.0
1.50mm2		1.87+/-0.05 [.074+/- .002]		8.5
1.25mm2		1.80+/-0.05 [.071+/- .002]		9.0

- 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: 8-2150454-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150454-5
- 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 & 180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.
- GRIND TO LENGTH AT ASSEMBLY.

***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	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- 77-27-25-22	PART NO	DESCRIPTION	ITEM NO

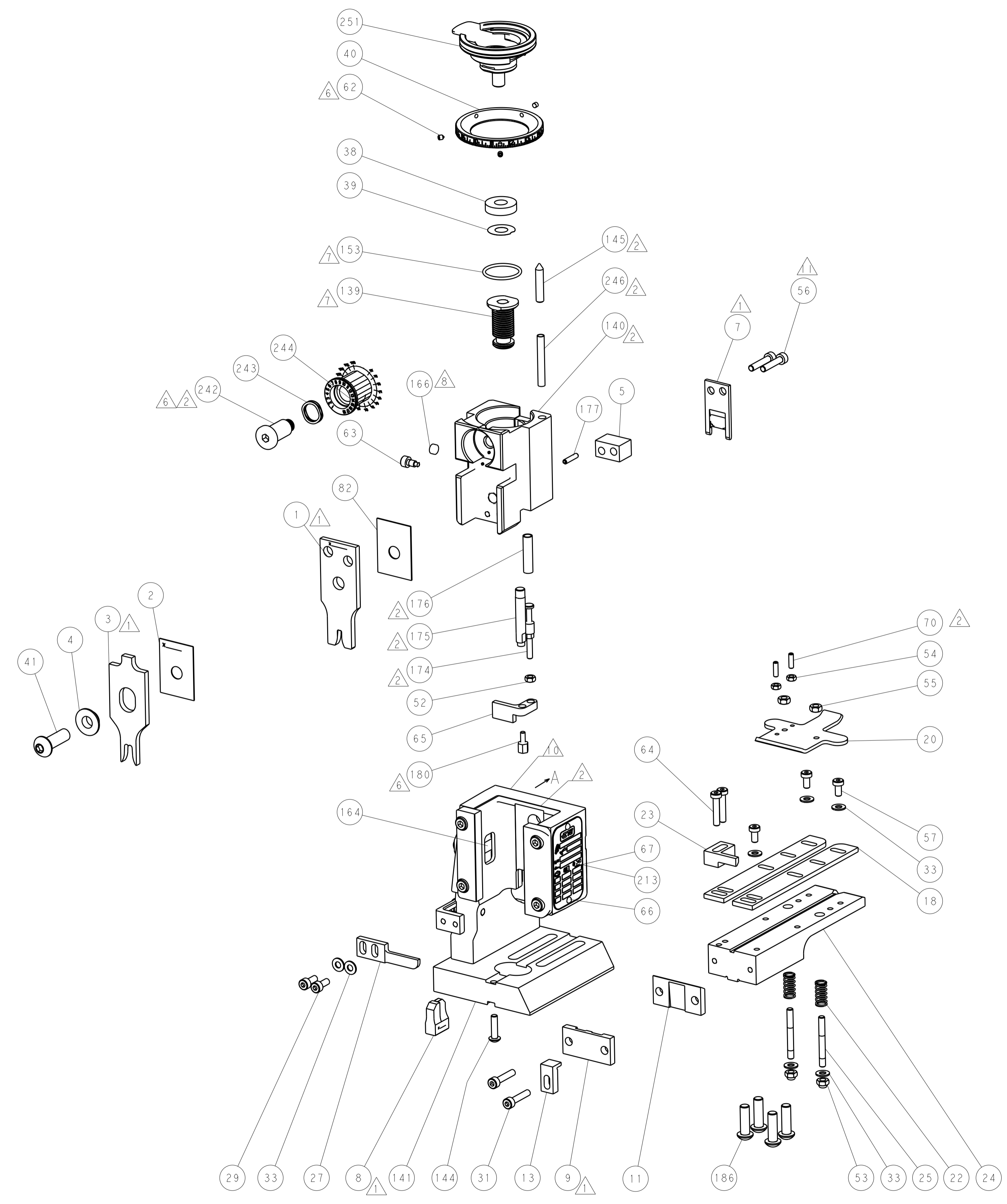
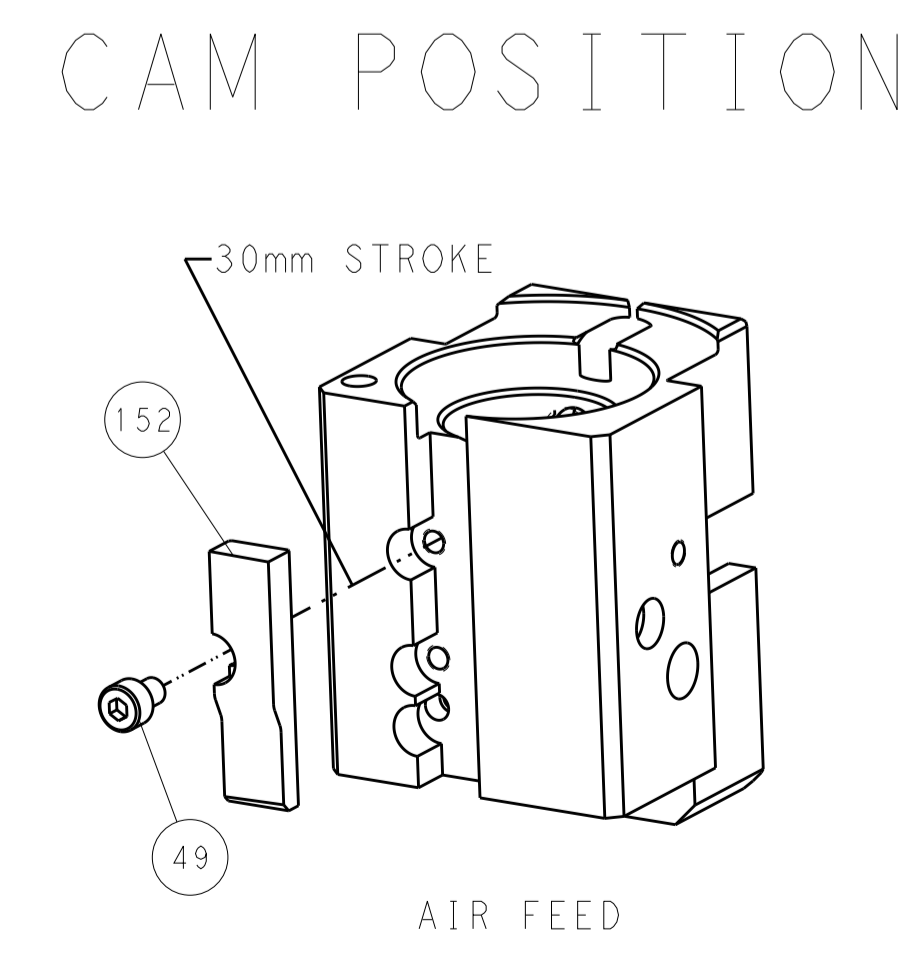
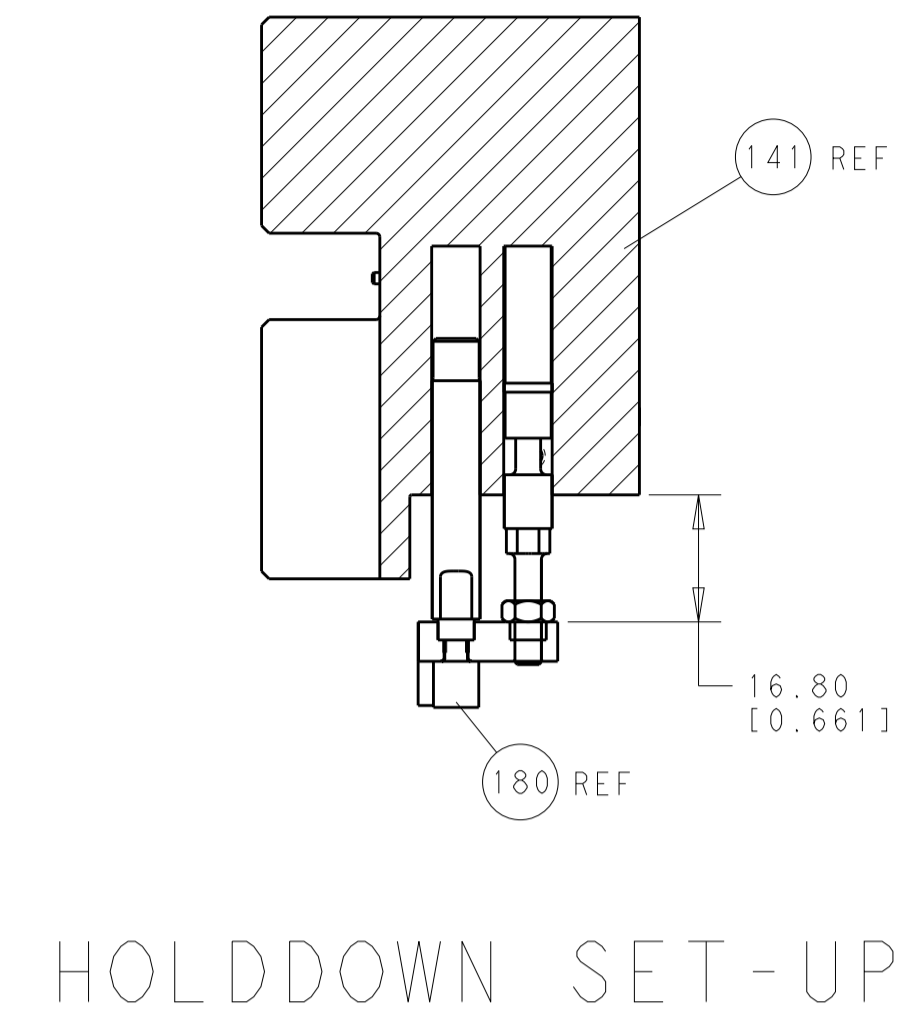
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

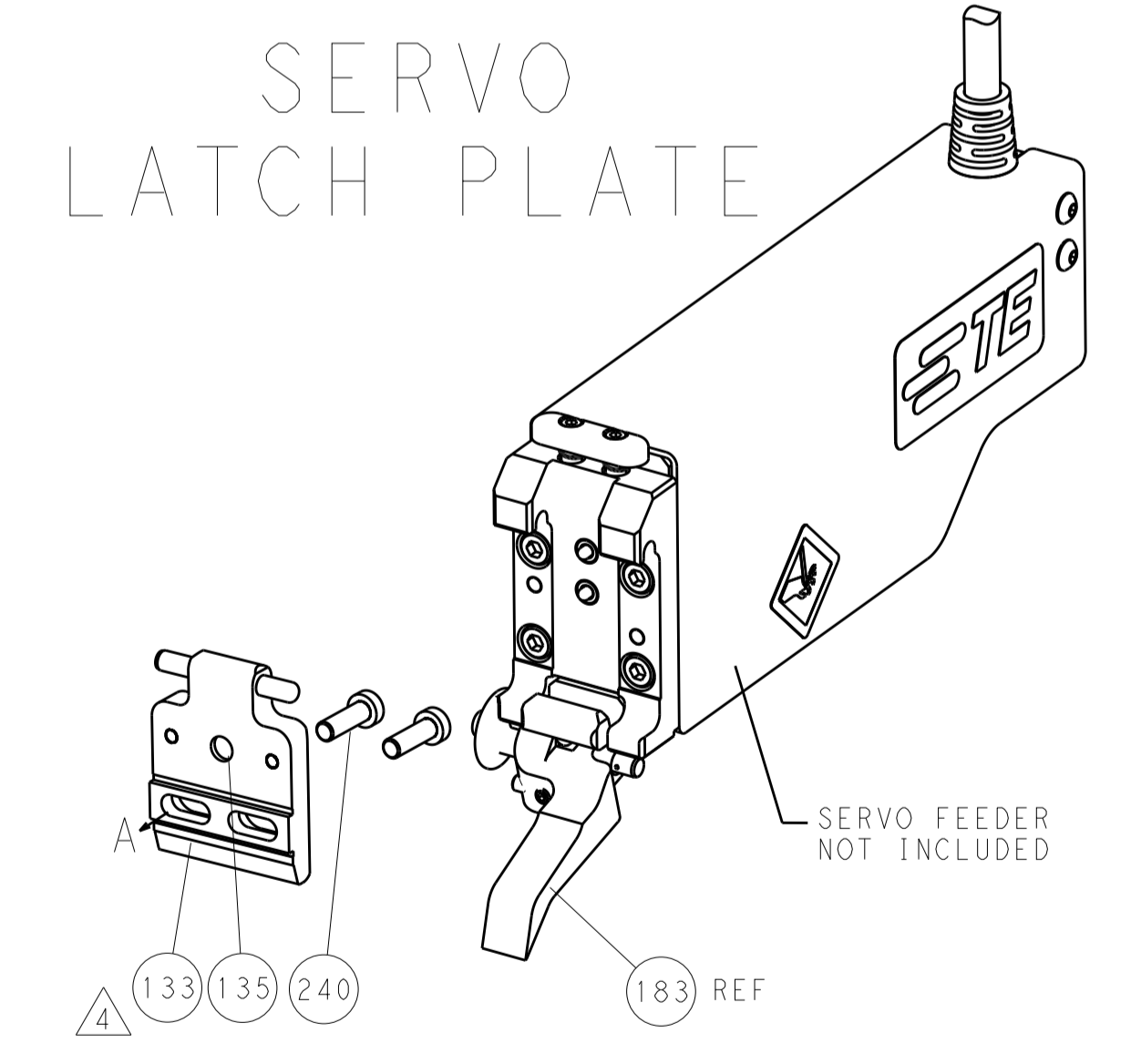
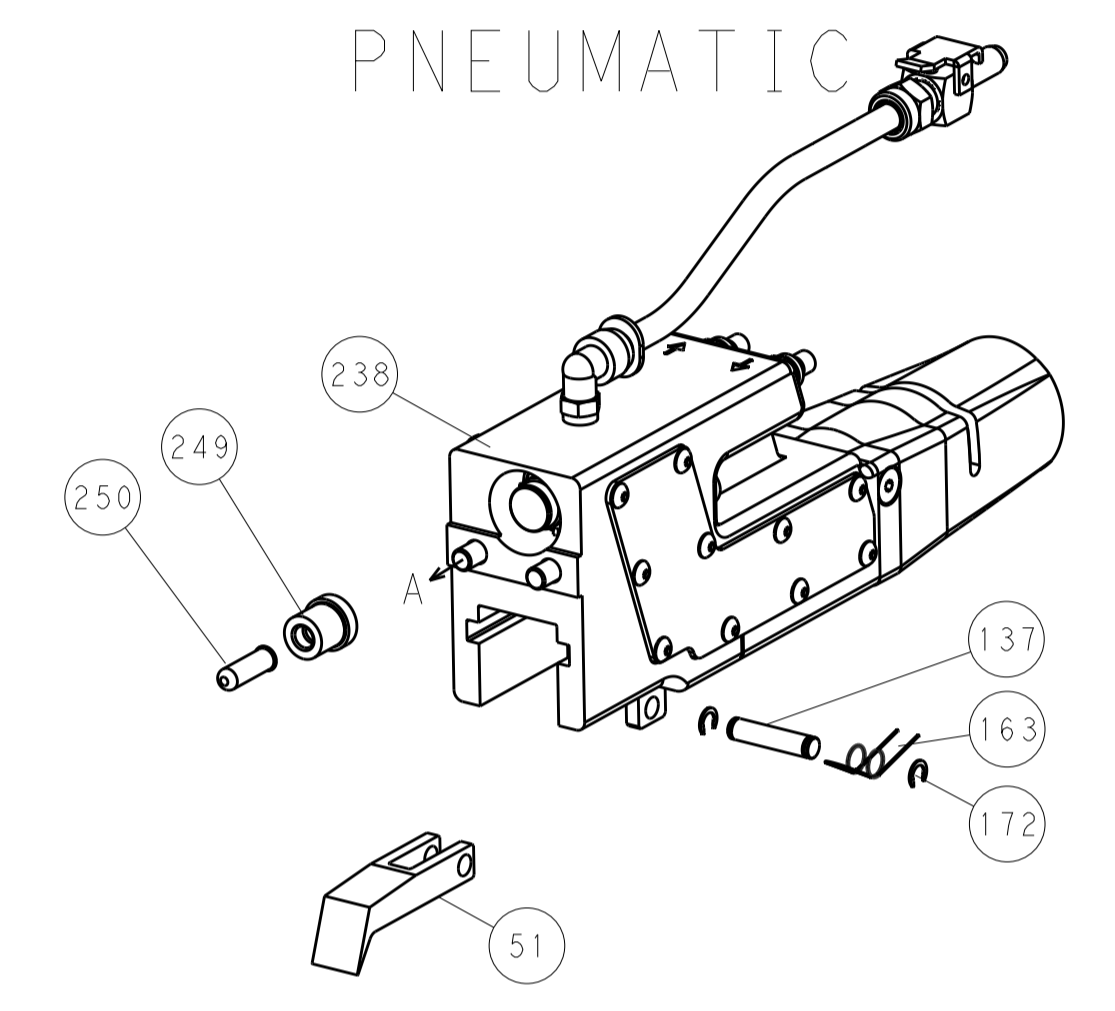
REV	DATE	BY	APPV	DESCRIPTION	DATE	QTY	ITEM NO
-	-	-	1	2119640-1	PUSH ROD, AIR FEED		250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI		249
-	1	1	1	1-22279-3	SPRING, COMPRESSION		246
-	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
	1	1	1	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
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)		186
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF		183
	1	1	1	1752354-9	STANDOFF, HOLD-DOWN		180
-	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0		177
-	1	1	1	8-22280-7	SPRING, COMPRESSION		176
-	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN		175
-	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN		174
-	-	-	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	455888-5	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	2-1901681-1	HOLDDOWN, TERMINAL		65
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20		64
	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT		63
	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0		62
	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8		57
	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		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	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5		52
-	-	-	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	2119644-2	RAM WASHER, PRECISION		38
-	7	7	7	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	1-1752371-4	PLATE, STRIP GUIDE		24
-	1	1	1	240825-3	PLATE, STRIP HOLD DOWN		23
-	2	2	2	2-22281-3	SPRING, COMPRESSION		22
-	1	1	1	1752373-4	DRAG		20
-	2	2	2	1901259-6	GUIDE, LOWER STRIP		18
-	1	1	1	1752360-1	SPACER, HOLD-DOWN		13
	1	1	1	240833-7	PLATE, REAR SHEAR		11
-	-	-	-	-	-		10
	1	1	1	7-690482-4	PLATE, FRONT SHEAR		9
	1	1	1	1-1803060-2	ANVIL, COMBINATION, END FEED		8
	1	1	1	2217206-7	BLADE, SLUG		7
-	-	-	-	-	-		6
-	1	1	1	7-240641-3	SPACER		5
-	1	1	1	238009-3	BLOCK, FL CRIMPER SPACER		4
	1	1	1	4-2119582-3	CRIMPER, INSULATION F PREMIUM		3
	1	1	1	455888-4	SPACER, CRIMPER		2
	1	1	1	456409-3	CRIMPER, WIRE .120 "F" PREMIUM		1
- 77-27-25-22	PART NO	DESCRIPTION	ITEM NO				

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		CHK		APV		NAME	
mm	0 PLC ±.5	1 PLC ±.3	2 PLC ±.13	3 PLC ±.013	4 PLC ±.0001	ANGLES ±.0001	FINISH	H. HUANG	14AUG2014	L. ZHANG	14AUG2014
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
						A1		00779		C=2150454	
Customer Accessible Production Drawing				SCALE		SHEET		OF		REV	
				1:1		3		4		A1	

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



FEED TYPE



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:		OWN: R. HUANG 14AUG2014	STE TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	CHK: L. ZHANG 14AUG2014	
MATERIAL:		FINISH:		APVD: H. GUO 14AUG2014	NAME: Ocean End Feed Applier
				PRODUCT SPEC:	SIZE: CAGE CODE DRAWING NO:
				APPLICATION SPEC:	RESTRICTED TO:
				WEIGHT:	A1 00779 C=2150454
				ANGLES:	Customer Accessible Production Drawing
				SCALE: 1:1	SHEET 4 OF 4 REV A1