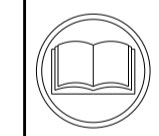


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150336-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1-1338683-0	5-18022-5	2119653-1	-	-
	2150336-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150336-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.57 mm [.180]	SP
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS FLAG F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-5.30 mm [.169-.209 IN]		Ø2.70-3.80 mm [.106-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-64027		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178439-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	1.96+/-0.05 [.077+/-0.002]	5.1
14 AWG	1.85+/-0.05 [.073+/-0.002]	6.4
16 AWG	1.64+/-0.05 [.065+/-0.002]	8.5



- 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: 8-2150336-4
- 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 ITEM 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 50.
- 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.
- TERMINAL DESIGN IS NOT COMPATIBLE WITH SERVO FEED AND 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.

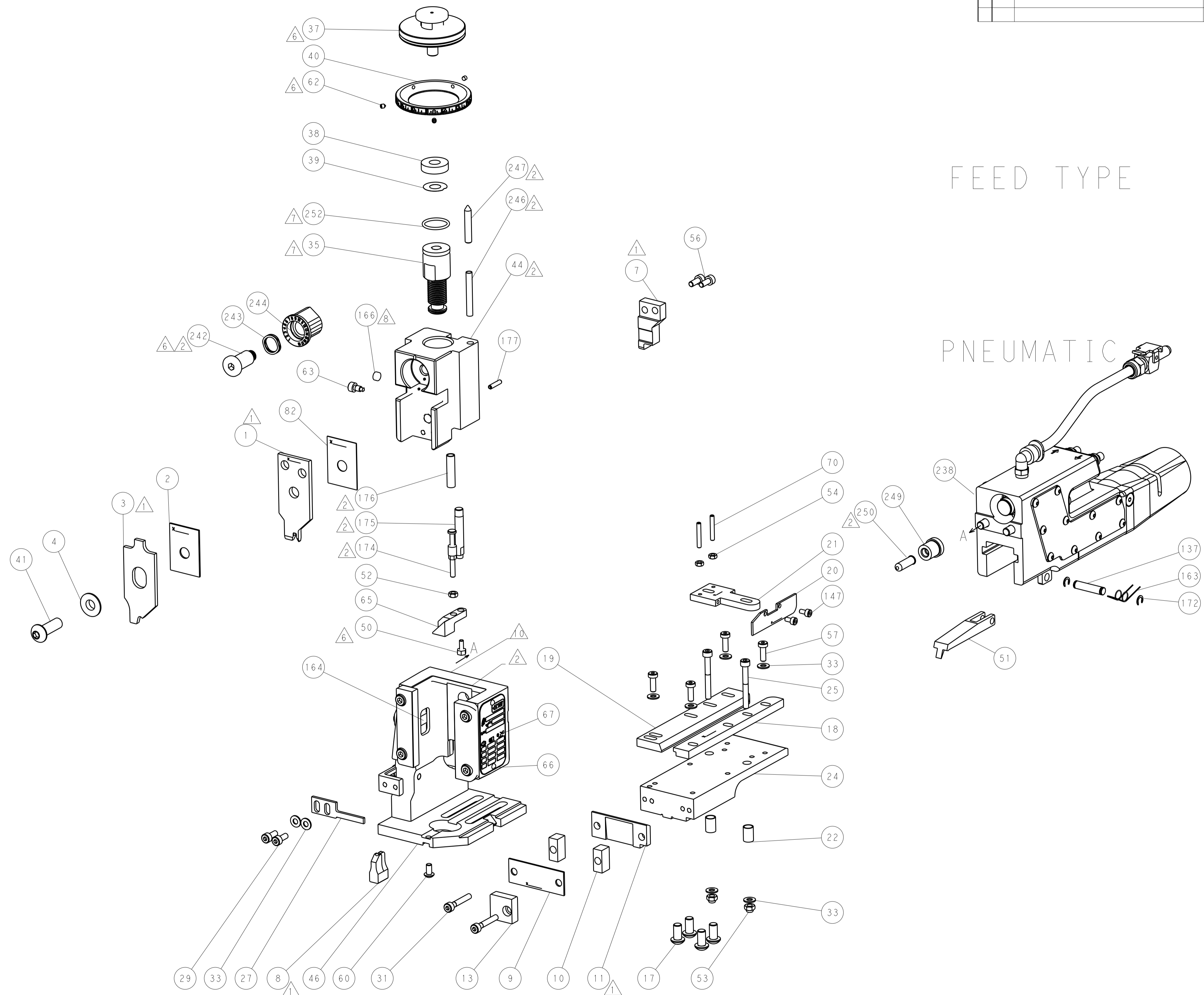
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			REV	DATE	BY	APPV
	A		RELEASED	22JUL2014	RK	TE
	A1		ECR-15-004977	30MAR2015	JH	JT
	A2		ECR-15-006528	28APR2015	RS	LZ
	B		ECR-15-013159	06SEP2015	YY	KZ

-	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	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2063440-1	AIR FEED MODULE	238
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	-	1	240638-1	SPRING, FEED FINGER	163
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1803176-1	HOLDDOWN, TERMINAL	65
-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	1	2161920-2	NARROW PAWL, EF, AIR	51
-	1	1	3-1752354-9	STANDOFF,HOLD-DOWN	50
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	2119369-1	RAM,AMP STYLE, END FEED	44
-	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	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1-690455-0	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161922-1	PLATE, STRIP GUIDE	24
-	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1-464452-7	DRAG, STOCK	20
-	1	1	1803086-2	GUIDE, REAR STRIP	19
-	1	1	3-1901695-3	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1803175-1	SUPPORT, TERMINAL	13
-	1	1	461160-3	PLATE, REAR SHEAR	11
-	2	2	6-240645-1	SPACER, SHEAR PLATE	10
-	1	1	455961-5	PLATE, FRONT SHEAR	9
-	1	1	1803074-8	ANVIL, COMBINATION, END FEED	8
-	1	1	1803186-1	BLADE, SLUG	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	3-238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1803108-6	CRIMPER, INSULATION O	3
-	1	1	455888-9	SPACER, CRIMPER	2
-	1	1	1-1803015-2	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±.1					

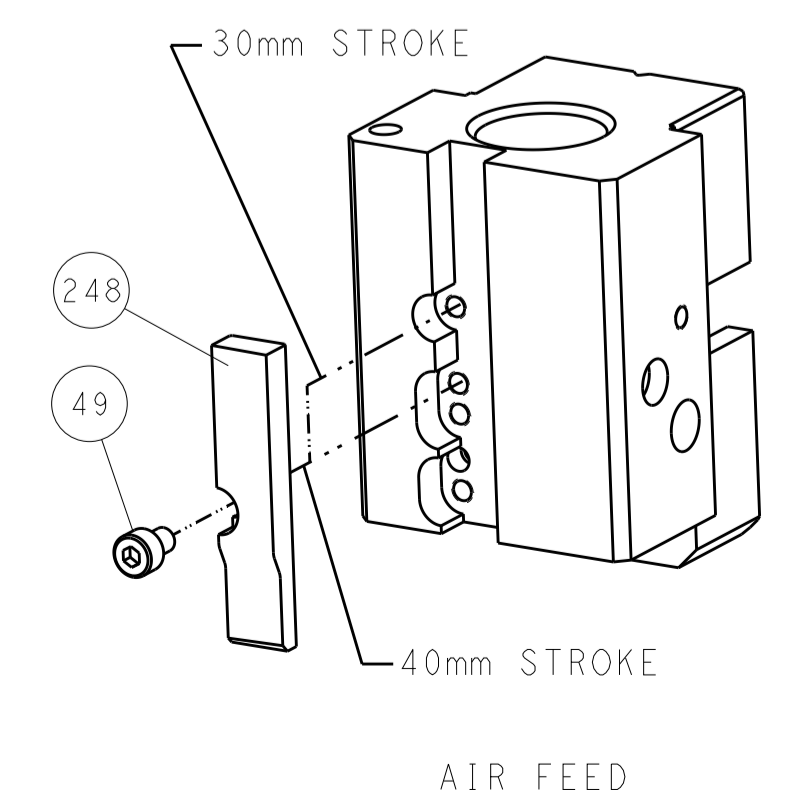
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



FEED TYPE

PNEUMATIC

CAM POSITION



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED IN THE ORDER. ANY OTHER USE OR REPRODUCTION WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION IS STRICTLY PROHIBITED.</small>		DWN: R. KNEPPER 06JUN2013 CHK: T. ELBIN 06JUN2013 APVD: M. CLIFFORD 06JUN2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150336 RESTRICTED TO:
MATERIAL:		SCALE: 1:1 SHEET: 2 of 4 REV: B	Customer Accessible Production Drawing

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150336-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1-1338683-0	5-18022-5	2119653-2	-	-
	2-2150336-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150336-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.57 mm [.180]	SP
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS FLAG F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-5.30 mm [.169-.209 IN]		Ø2.70-3.80 mm [.106-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-64027	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178439-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	1.96+/-0.05 [.077+/-0.002]	5.1
14 AWG	1.85+/-0.05 [.073+/-0.002]	6.4
16 AWG	1.64+/-0.05 [.065+/-0.002]	8.5

- 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: 8-2150336-4
- 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 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.
- 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.
- TERMINAL DESIGN IS NOT COMPATIBLE WITH SERVO FEED AND 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.

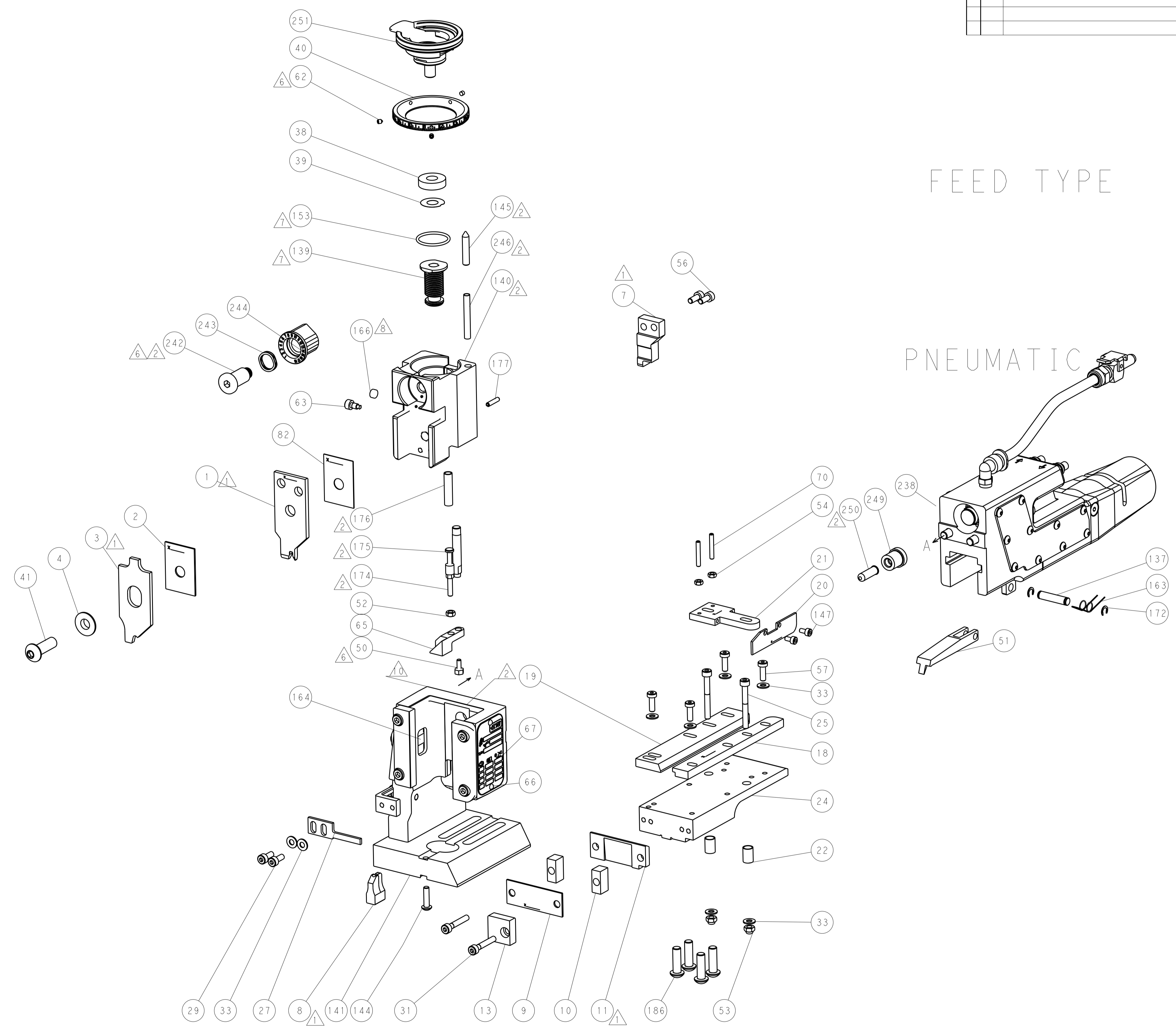
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2063440-1	AIR FEED MODULE	238
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	-	1	240638-1	SPRING, FEED FINGER	163
-	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
-	-	1	2119641-2	FEED CAM, AIR FEED	152
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
-	1	1	2119798-2	DETENT PIN	145
-	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	-	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1803176-1	HOLDDOWN, TERMINAL	65
-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	1	2161920-2	NARROW PAWL, EF, AIR	51
-	1	1	3-1752354-9	STANDOFF,HOLD-DOWN	50
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	1-2119644-2	RAM WASHER, PRECISION	38
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1-690455-0	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161922-1	PLATE, STRIP GUIDE	24
-	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1-464452-7	DRAG, STOCK	20
-	1	1	1803086-2	GUIDE, REAR STRIP	19
-	1	1	3-1901695-3	STRIP GUIDE, FRONT	18
-	1	1	1803175-1	SUPPORT, TERMINAL	13
-	1	1	461160-3	PLATE, REAR SHEAR	11
-	2	2	6-240645-1	SPACER, SHEAR PLATE	10
-	1	1	455961-5	PLATE, FRONT SHEAR	9
-	1	1	1803074-8	ANVIL, COMBINATION, END FEED	8
-	1	1	1803186-1	BLADE, SLUG	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	3-238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1803108-6	CRIMPER, INSULATION O	3
-	1	1	455888-9	SPACER, CRIMPER	2
-	1	1	1-1803015-2	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5	ANGLES ±.0001					

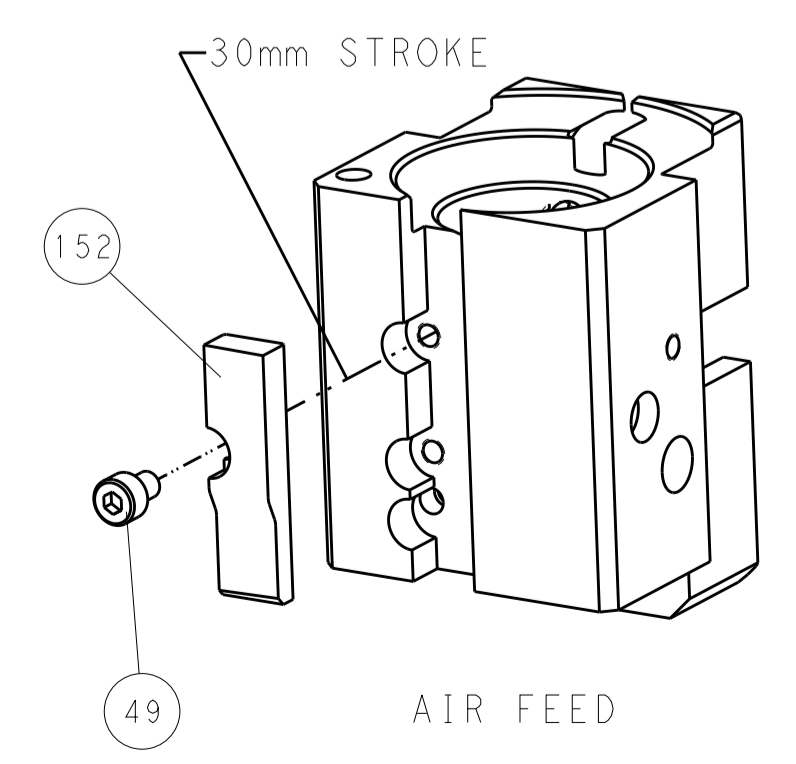
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



FEED TYPE

PNEUMATIC

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:		DWG: R. KNEPPER 06JUN2013		REV: T. ELBIN 06JUN2013		NAME: M. CLIFFORD 06JUN2013		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	ANGLES ±0.001	FINISH	PRODUCT SPEC	APPLICATION SPEC	SIZE: A1	CAGE CODE: 00779
MATERIAL:								WEIGHT:	Customer Accessible Production Drawing	SCALE: 1:1	SHEET: 4 of 4
Customer Accessible Production Drawing										REV: B	