

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2150405-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2150405-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2150405-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>
	2150405-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>
	2150405-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2150405-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SLICE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.70-5.33 mm [.303-.210 IN]		-	
TERMINAL APPLICATION SPECIFICATION	114-2088	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927969-1	927969-3	927969-5	927969-7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.39 +/- 0.05 [.055 +/- .002]	5.4
0.50mm2	1.27 +/- 0.05 [.050 +/- .002]	6.9
0.38mm2	1.21 +/- 0.05 [.048 +/- .002]	7.2

- <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:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150405-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150405-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150405-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150405-6
- 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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- <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> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</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
- <sup>13</sup> REFER TO TERMINAL CUSTOMER DRAWING FOR SPECIFIC CRIMP HEIGHT.
- <sup>14</sup> POSITION ITEM 27 IN FRONT OF ITEM 3 (TOWARD OPERATOR).

**\*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)

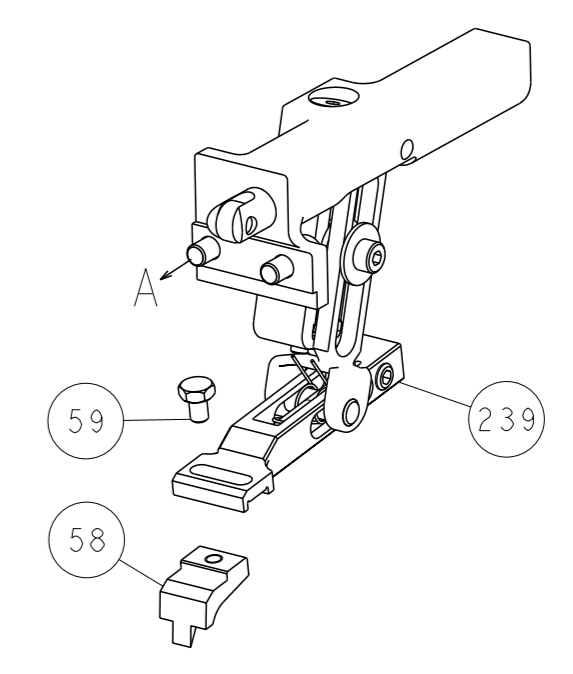
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LYH	DESCRIPTION	DATE	OWN	APVD
			A		RELEASED	26FEB2014	RW	TE

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	1	1	1	1	1803078-1	SPACER, PRECISION	259
-	-	1	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, MISMUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	1	1	1	2119798-1	DETENT PIN	247
-	-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	1	-	-	2161315-1	RAM, STEPPED, AMP STYL, EF, NON-ADJUST	245
-	-	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
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	-	1	1	1	1	1803078-1	SPACER, PRECISION	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
-	-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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
-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	2063961-1	FEED FINGER	58
-	-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	-	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	2119792-2	PAWL, EF, AIR	51
-	-	-	-	-	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	1-2119655-7	APPLICATOR BASIC ASSEMBLY, EF	46
-	-	1	-	1	1	2161310-1	RAM, STEPPED, 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	1-2119644-4	RAM WASHER, PRECISION	38
-	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	-	1	-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	-	1	1	1	1	690455-2	STRIPPER, FRONT CASTING	27
-	-	2	2	2	2	1320906-1	STUD, THREADED	25
-	-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	-	1	1	1	1	240825-6	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	1901259-3	GUIDE, LOWER STRIP	18
-	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	2	2	2	2	240645-1	SPACER, SHEAR PLATE	10
-	-	1	1	1	1	6-690618-7	ANVIL, SPLICE TYPE	8
-	-	1	1	1	1	1-459722-0	BLADE, SHEAR	7
-	-	-	-	-	-	-	-	6
-	-	1	1	1	1	690619-4	PLATE, RETAINING	5
-	-	-	-	-	-	-	-	4
-	-	1	1	1	1	3-459736-5	CRIMPER, WIRE	3
-	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	-	1	1	1	1	2-459736-4	CRIMPER, WIRE	1

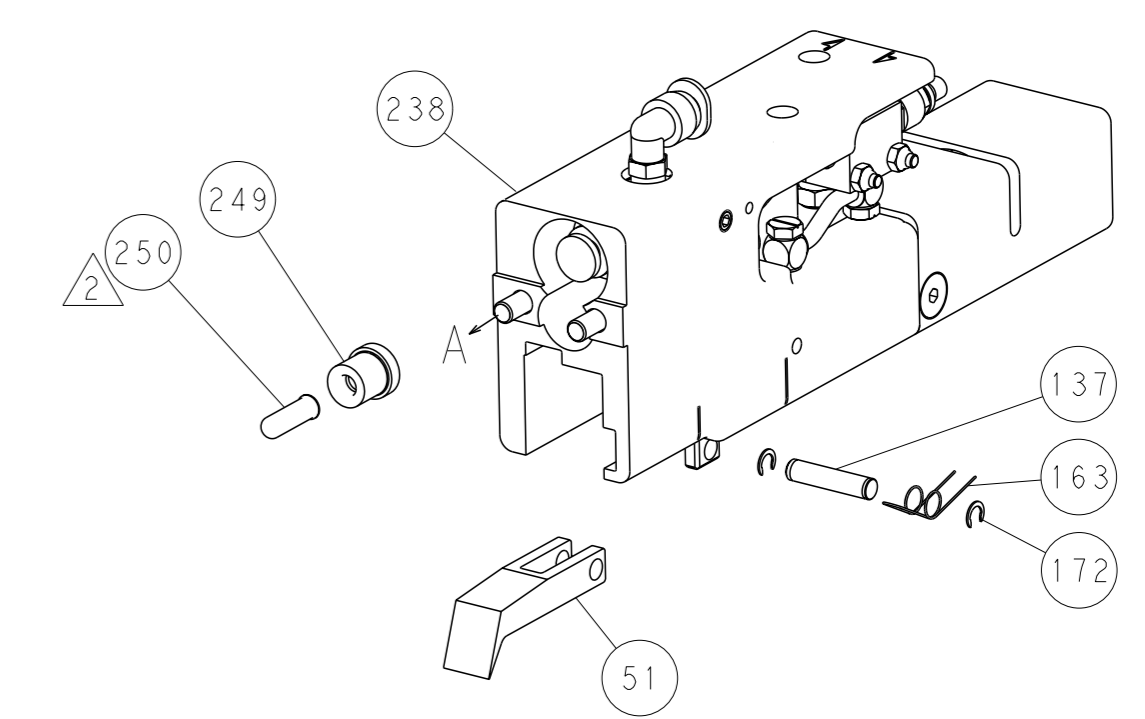
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mm	0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001	mm	±.5 ±0.13 ±0.013 ±0.0001	PLC	±.5 ±0.13 ±0.013 ±0.0001	mm	±.5 ±0.13 ±0.013 ±0.0001	mm	±.5 ±0.13 ±0.013 ±0.0001	mm	1:1

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

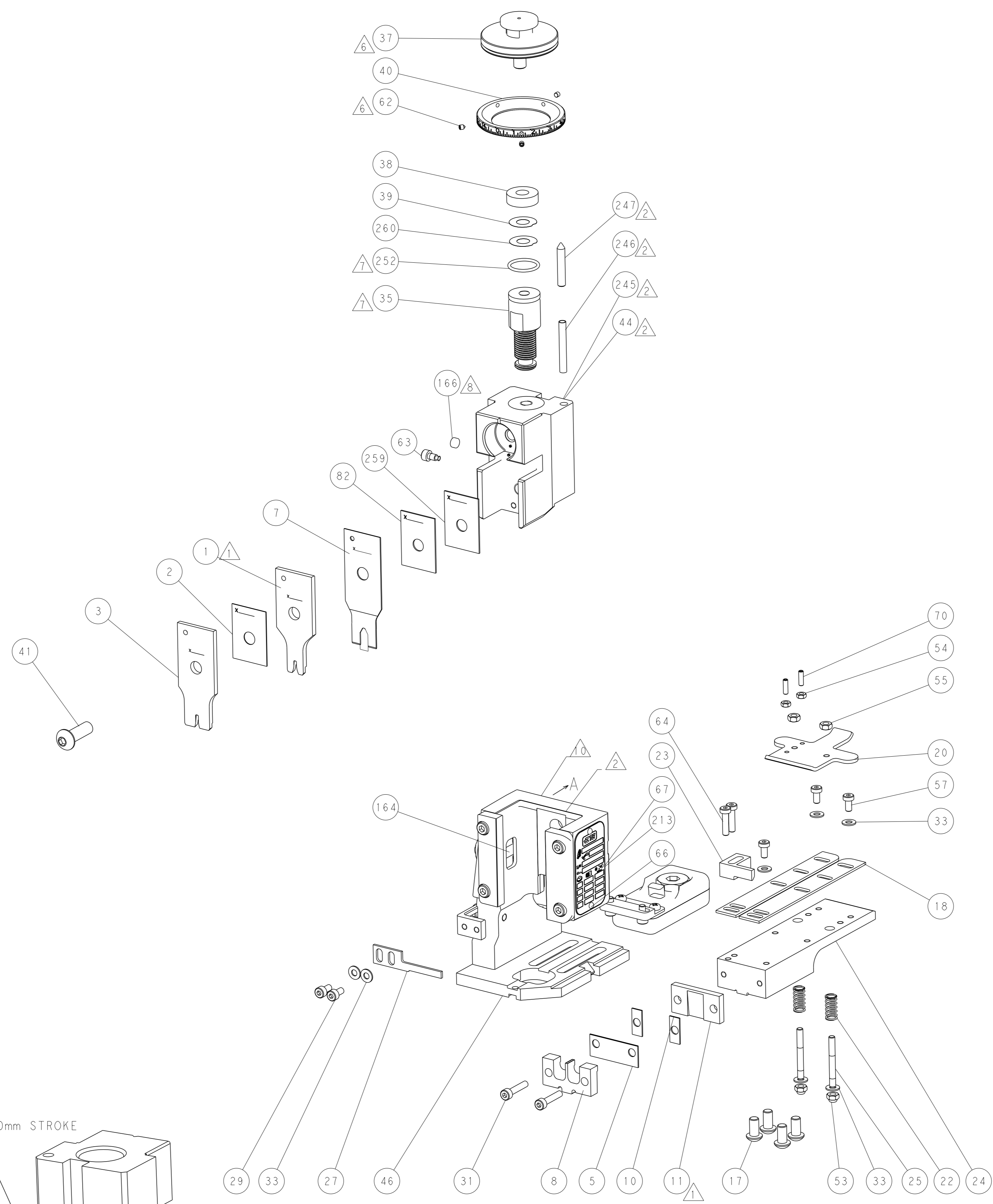
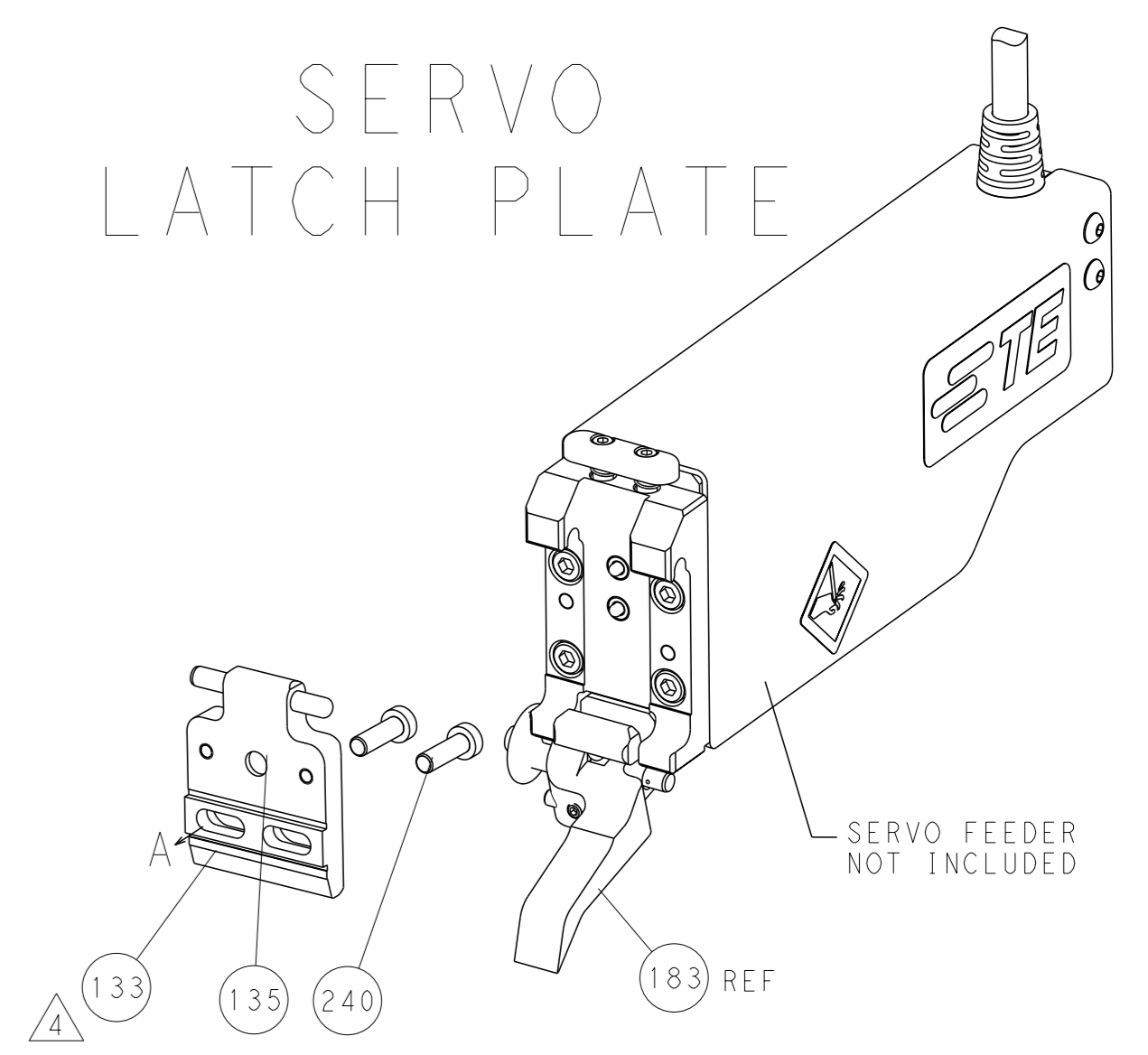
# FEED TYPE MECHANICAL



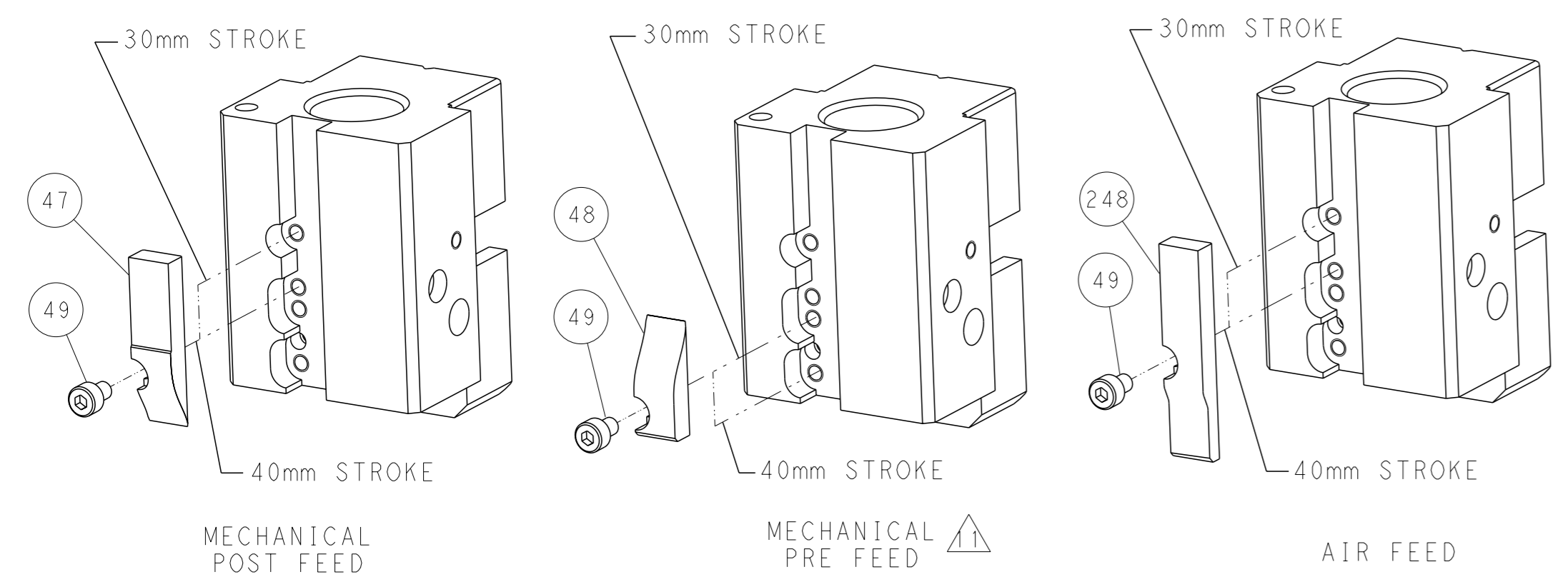
# PNEUMATIC



# 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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1°		OWN: R. O. WILSON 08JAN2014 CHK: K. J. STAKEM 22JAN2014 APVD: T. L. ELBIN 22JAN2014 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150405 SCALE: 1:1 SHEET: 2 of 4 REV: A		RESTRICTED TO: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
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Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a diagram of the Pacific Version Terminator Interface Adapter.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes wire size 1.78 mm and crimp type F.

Terminal data and application specification tables. Includes 'TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION' and 'TERMINALS APPLIED' table.

Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Lists settings for 0.75mm, 0.50mm, and 0.38mm wire.

- 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.

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

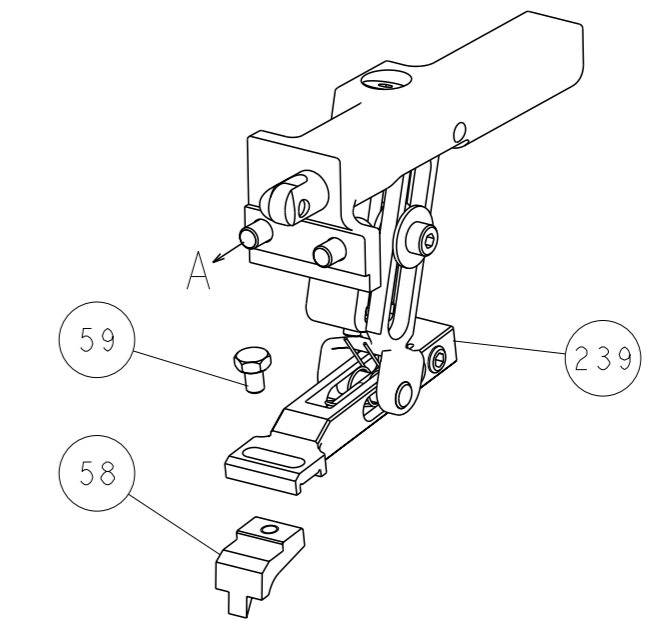
REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, QTN, APVD. Includes revision 1 with description 'SEE SHEET 1'.

Main parts list table with columns: QTY, PART NO, DESCRIPTION, ITEM NO. Lists various components like spacers, screws, springs, and crimpers.

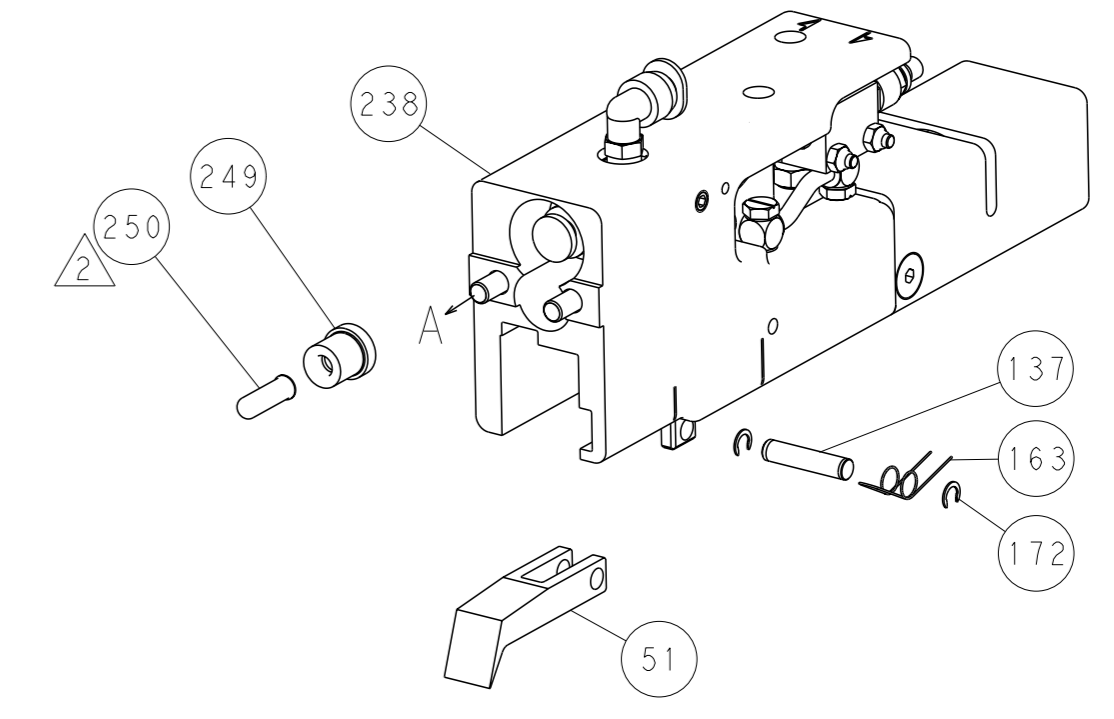
Customer Accessible Production Drawing form. Includes fields for dimensions, tolerances, material, weight, and drawing information.

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

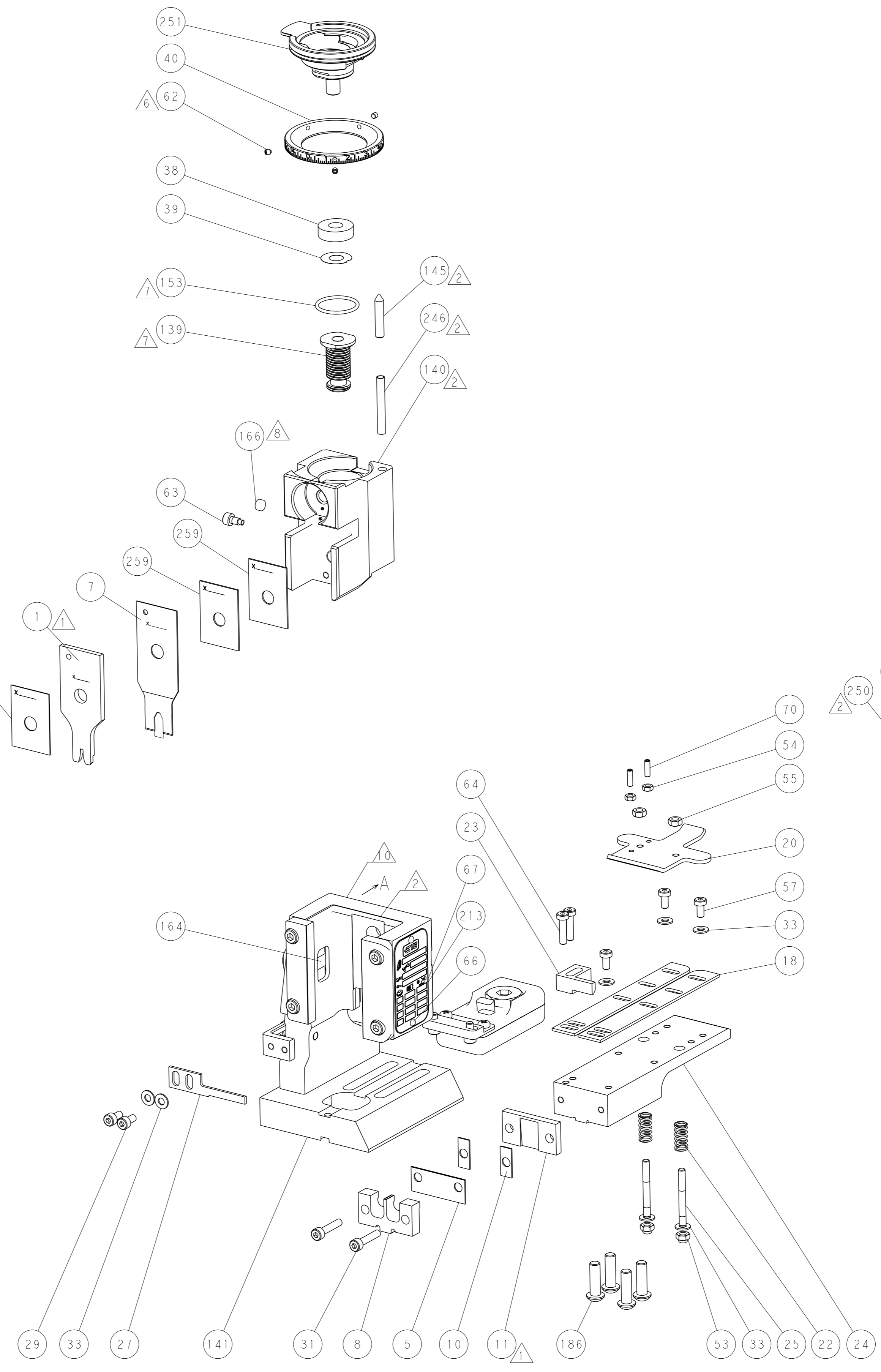
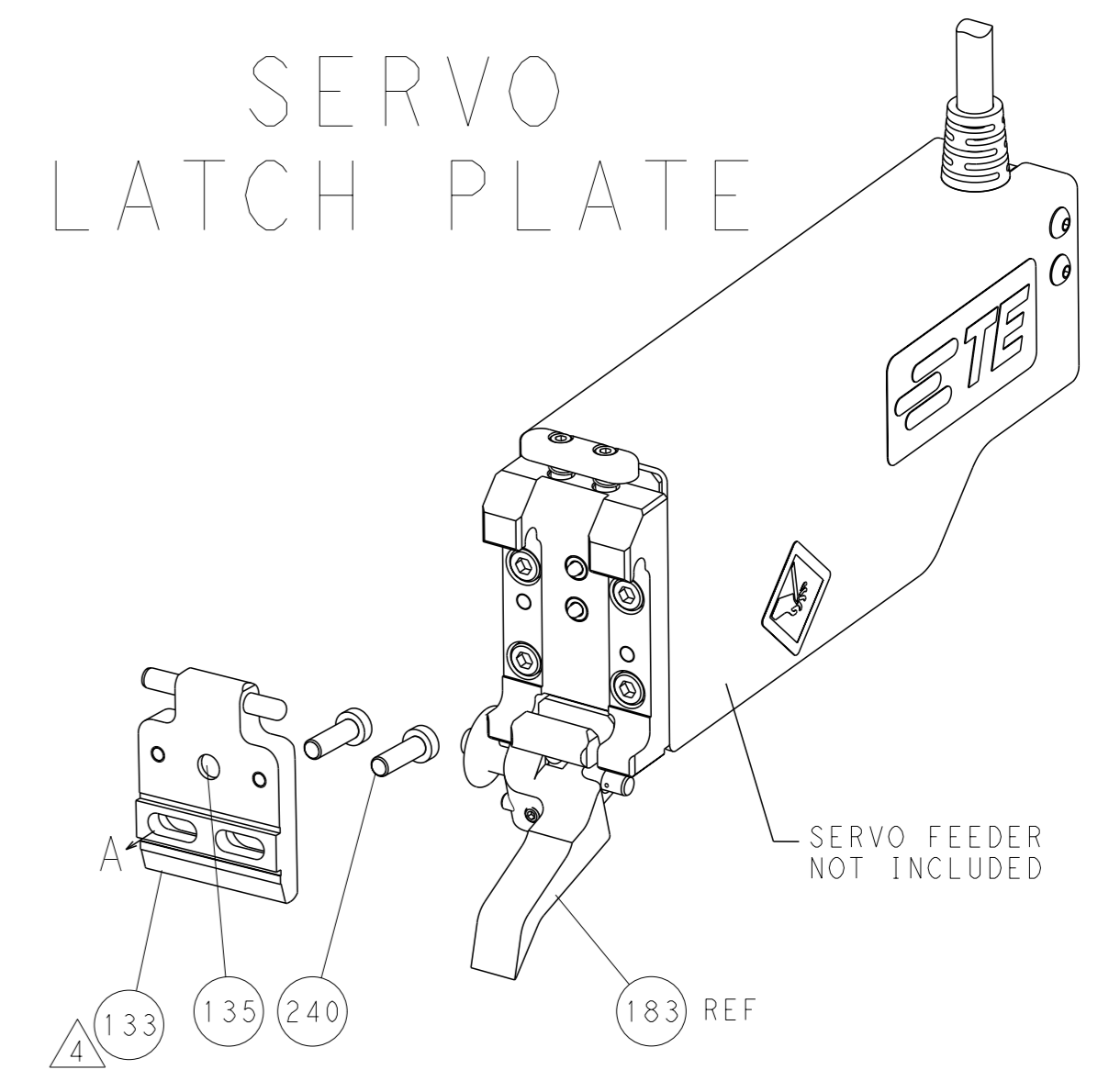
FEED TYPE  
MECHANICAL



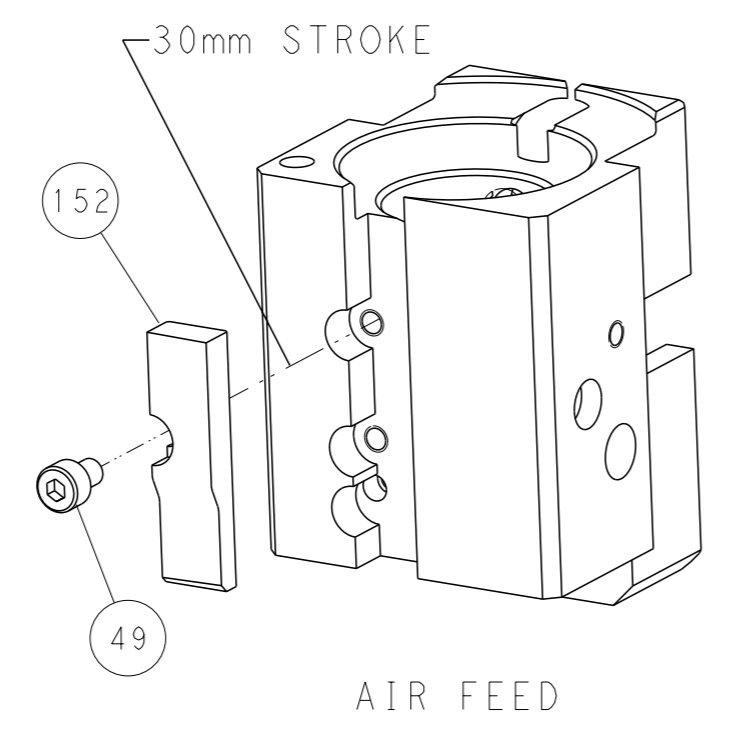
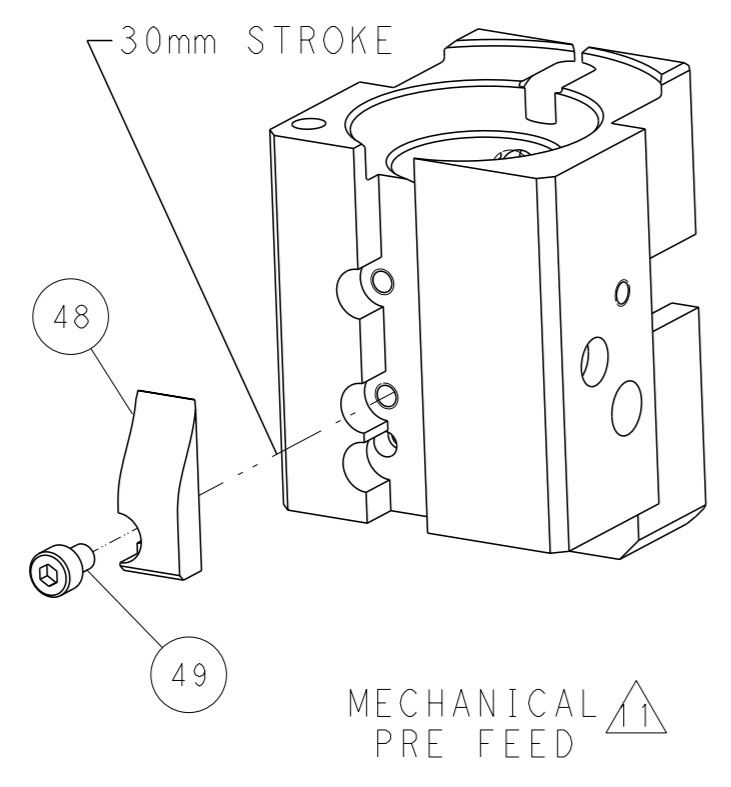
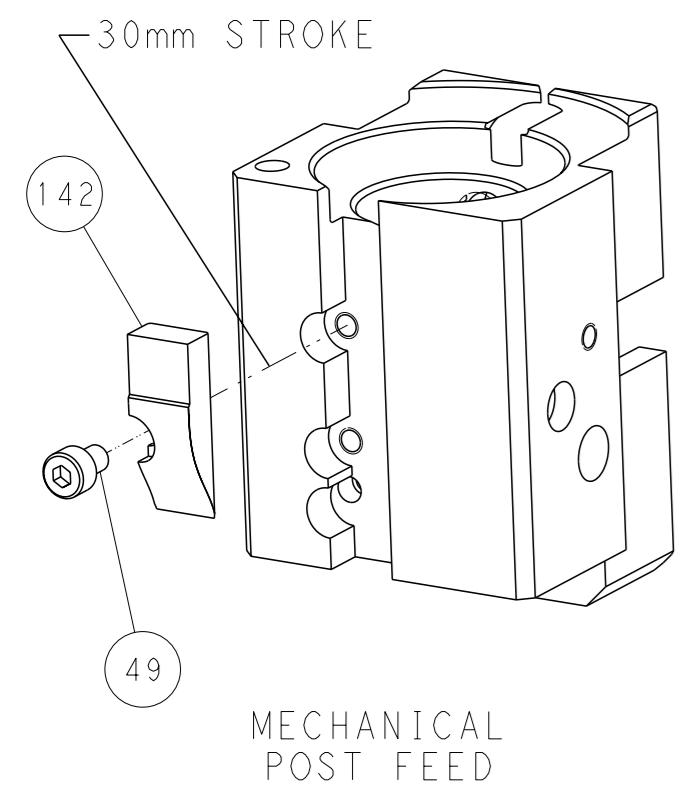
PNEUMATIC



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER MUST CONTACT THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. O. WILSON CHK: K. J. STAKEM APVD: J. L. ELBIN PRODUCT SPEC	08 JAN 2014 22 JAN 2014 22 JAN 2014	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150405 SCALE: 1:1 SHEET: 4 of 4 REV: A	RESTRICTED TO:
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.001 4 PLC ±0.001 ANGLES FINISH:	WEIGHT:	APPLICATION SPEC:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE: 1:1	SHEET: 4 of 4