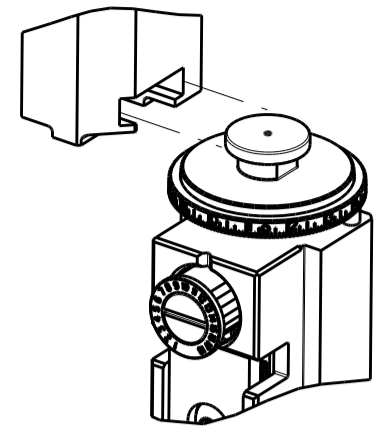





ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART								
					CONVERT TO	PART NUMBERS REQUIRED							
	2150495-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	-	-	-
	2150495-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150495-5	-	-	-	-	2168400-7 (QUANTITY 2)
	2150495-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	-	-	2063440-2
	2150495-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-	-
	7-2150495-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-	-


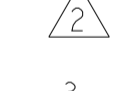

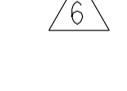
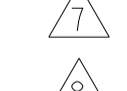



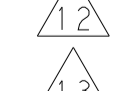


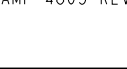
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.90 mm [.114]	F
INSUL	4.10 mm [.161]	F
APPL INSTRUCTIONS 408-10390 		

TERMINAL DATA: STOCKO TERMINAL STOCKO CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 5.17-5.93 mm [.203-.233 IN]		INSULATION DIAMETER RANGE Ø1.45-2.35 mm [.057-.093 IN]	
TERMINAL RSB 7206/7206.001/7207 A Rev A APPLICATION SPECIFICATION			
TERMINALS APPLIED 			
TE TERMINAL	STOCKO TERMINAL	TE TERMINAL	STOCKO TERMINAL
2113600-1	RSB 7206 A 3-1		

TERMINAL DATA: STOCKO TERMINAL STOCKO CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 5.17-5.93 mm [.203-.233 IN]		INSULATION DIAMETER RANGE Ø1.45-2.35 mm [.057-.093 IN]	
TERMINAL RSB 7206/7206.001/7207 A Rev A APPLICATION SPECIFICATION			
TERMINALS APPLIED 			
TE TERMINAL	STOCKO TERMINAL	TE TERMINAL	STOCKO TERMINAL
2113600-2	RSB 7206 A 3.5-1		
2113600-3	RSB 7206 A 4-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.95+/-0.02 [.077+/- .001]	8.2
0.82mm <sup>2</sup> or 18AWG	1.88+/-0.02 [.074+/- .001]	9.4
0.75mm2	1.85+/-0.02 [.073+/- .001]	9.5
0.68mm2	1.82+/-0.02 [.072+/- .001]	9.7
0.50mm2	1.75+/-0.02 [.069+/- .001]	10.7
0.34mm <sup>2</sup> or 22AWG	1.69+/-0.02 [.067+/- .001]	11.4

WIRE SIZE	CRIMP HEIGHT W1_CRIMP_UNIT	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.95+/-0.02 [.077+/- .001]	8.2
0.82mm <sup>2</sup> or 18AWG	1.88+/-0.02 [.074+/- .001]	9.4
0.75mm2	1.85+/-0.02 [.073+/- .001]	9.5
0.68mm2	1.82+/-0.02 [.072+/- .001]	9.7
0.50mm2	1.75+/-0.02 [.069+/- .001]	10.7
0.34mm <sup>2</sup> or 22AWG	1.69+/-0.02 [.067+/- .001]	11.4
0.22mm <sup>2</sup> or 24AWG	1.64+/-0.02 [.065+/- .001]	11.8












-  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: 8-2150495-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150495-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150495-6
- 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
-  TERMINALS USED WITH 0.25mm<sup>2</sup>-1mm<sup>2</sup>, 22AWG-18AWG.
-  TERMINALS USED WITH 0.25mm<sup>2</sup>-1mm<sup>2</sup>, 24AWG-18AWG.
-  CUT 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
-	-	-	-	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
-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)

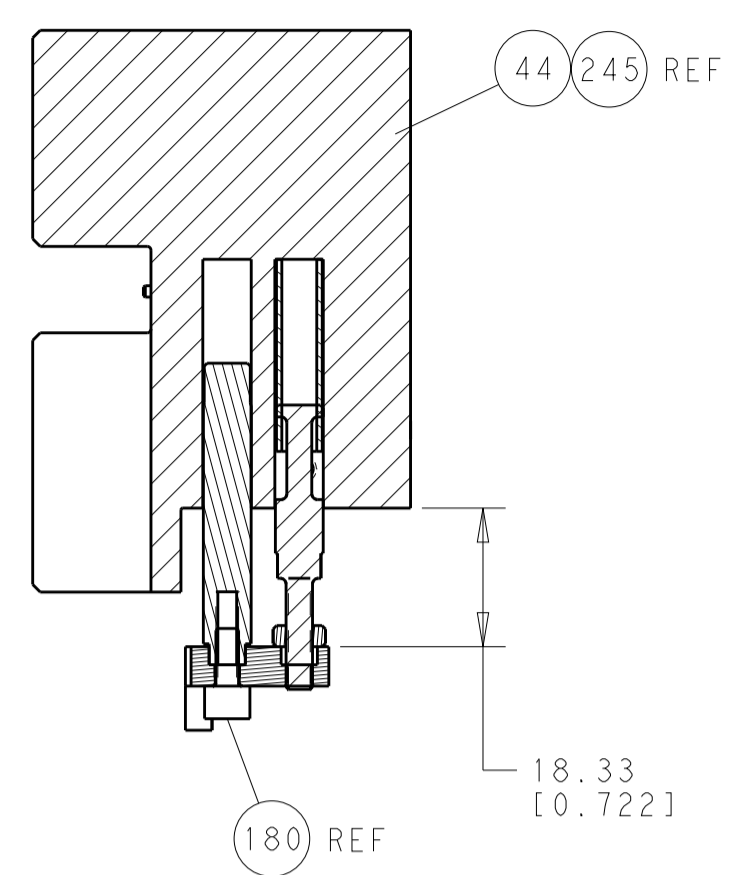
SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-2		A	66	REV	DATE	BY	APP'D
1	ORIGINAL				10OCT2014	BW	GB
A	RELEASED				06NOV2014	BW	GB

-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	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
-	-	-	-	-	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
-	1	1	1	1	1752354-2	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	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREF	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	455888-5	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	1901681-1	HOLDDOWN, TERMINAL	65
	-	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
-	-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	2063961-1	FEED FINGER	58
-	4	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	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
-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	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	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	1-1901696-8	STRIP GUIDE, REAR	19
-	1	1	1	1	1-1901695-8	STRIP GUIDE, FRONT	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	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
	-	1	1	1	690482-7	PLATE, FRONT SHEAR	9
	1	1	1	1	6-1803000-0	ANVIL, COMBINATION, END FEED	8
	-	1	1	1	1-2217206-7	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2-240641-7	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
	1	1	1	1	5-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
	1	1	1	1	4-1633588-1	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

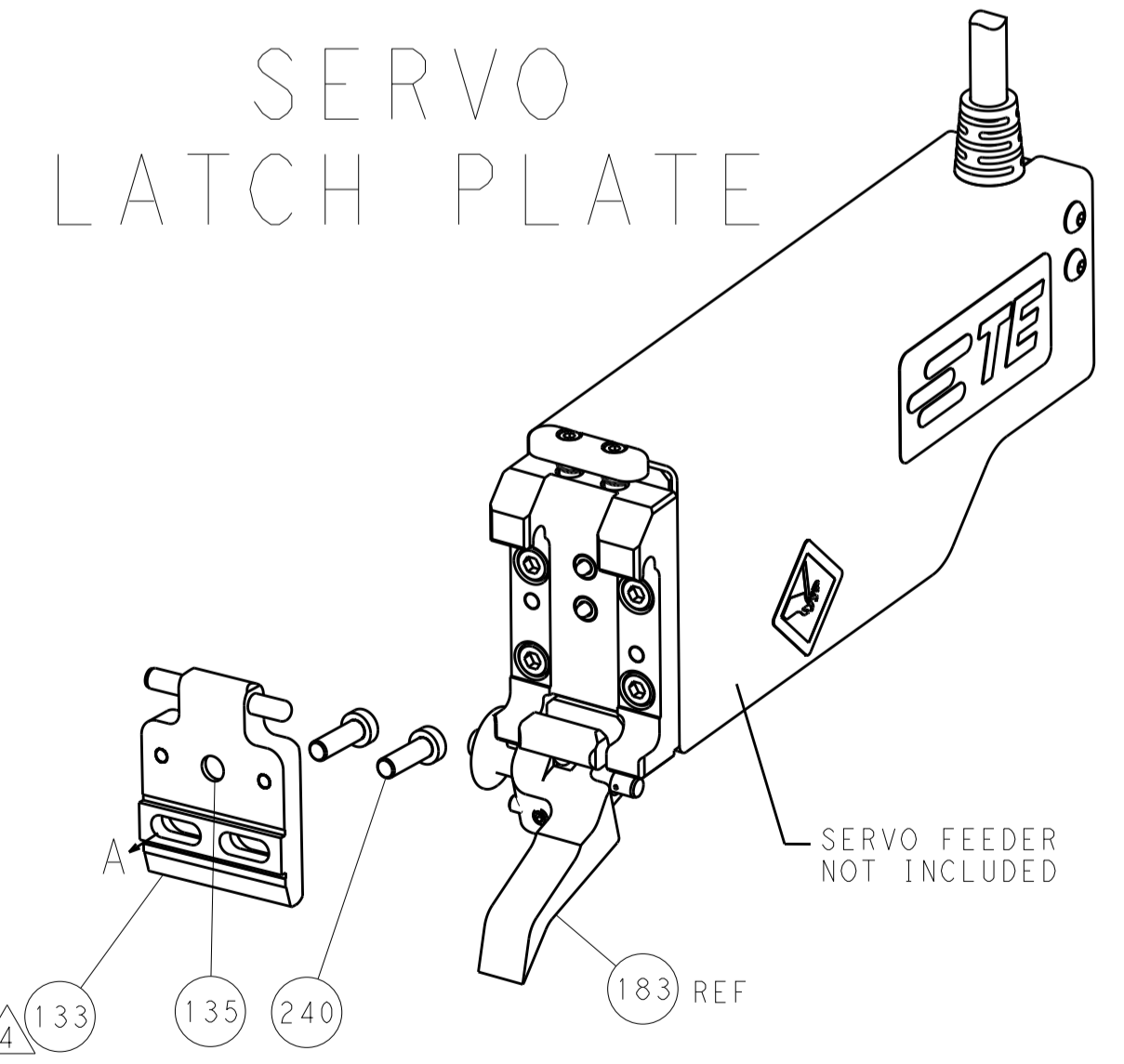
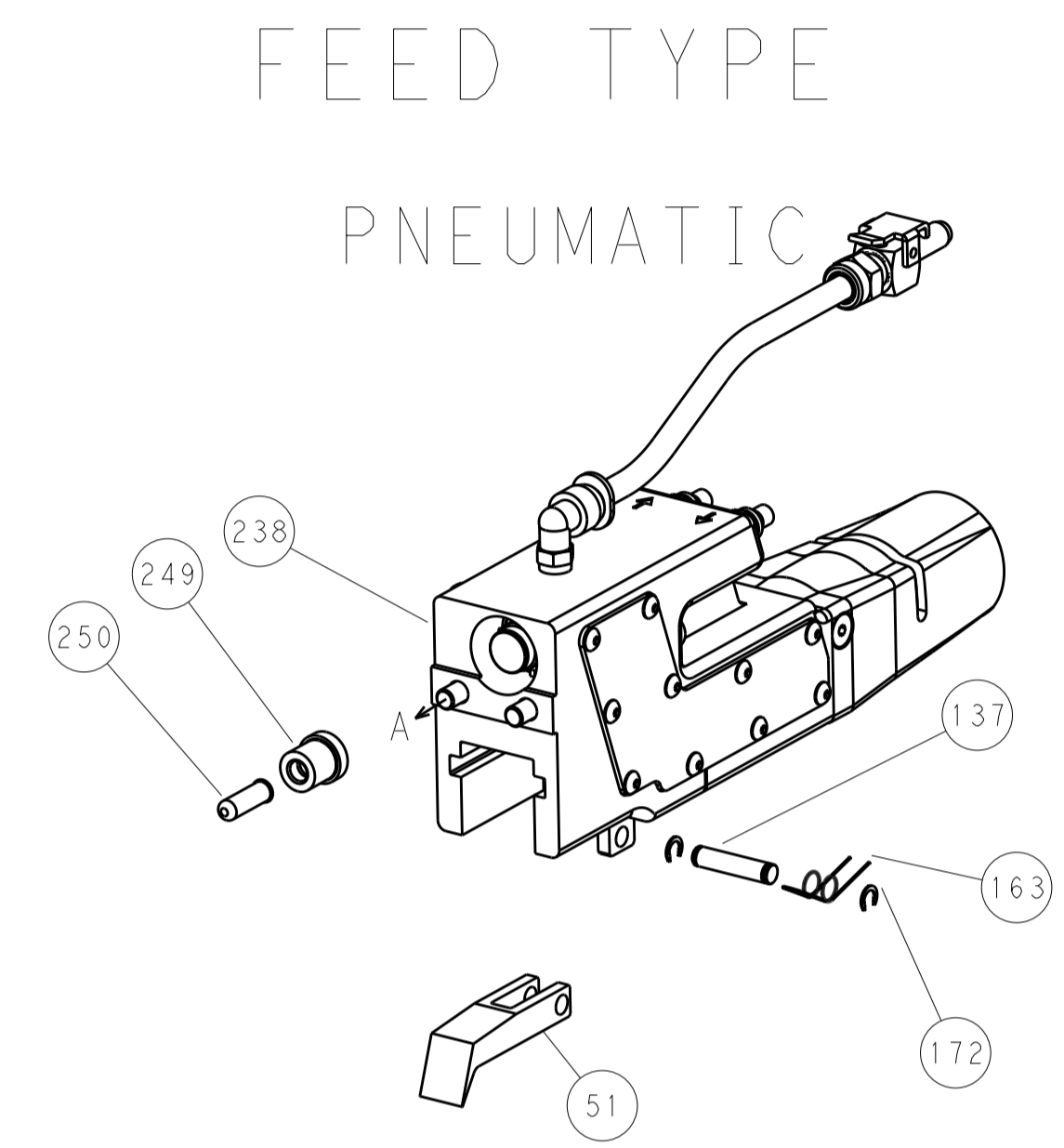
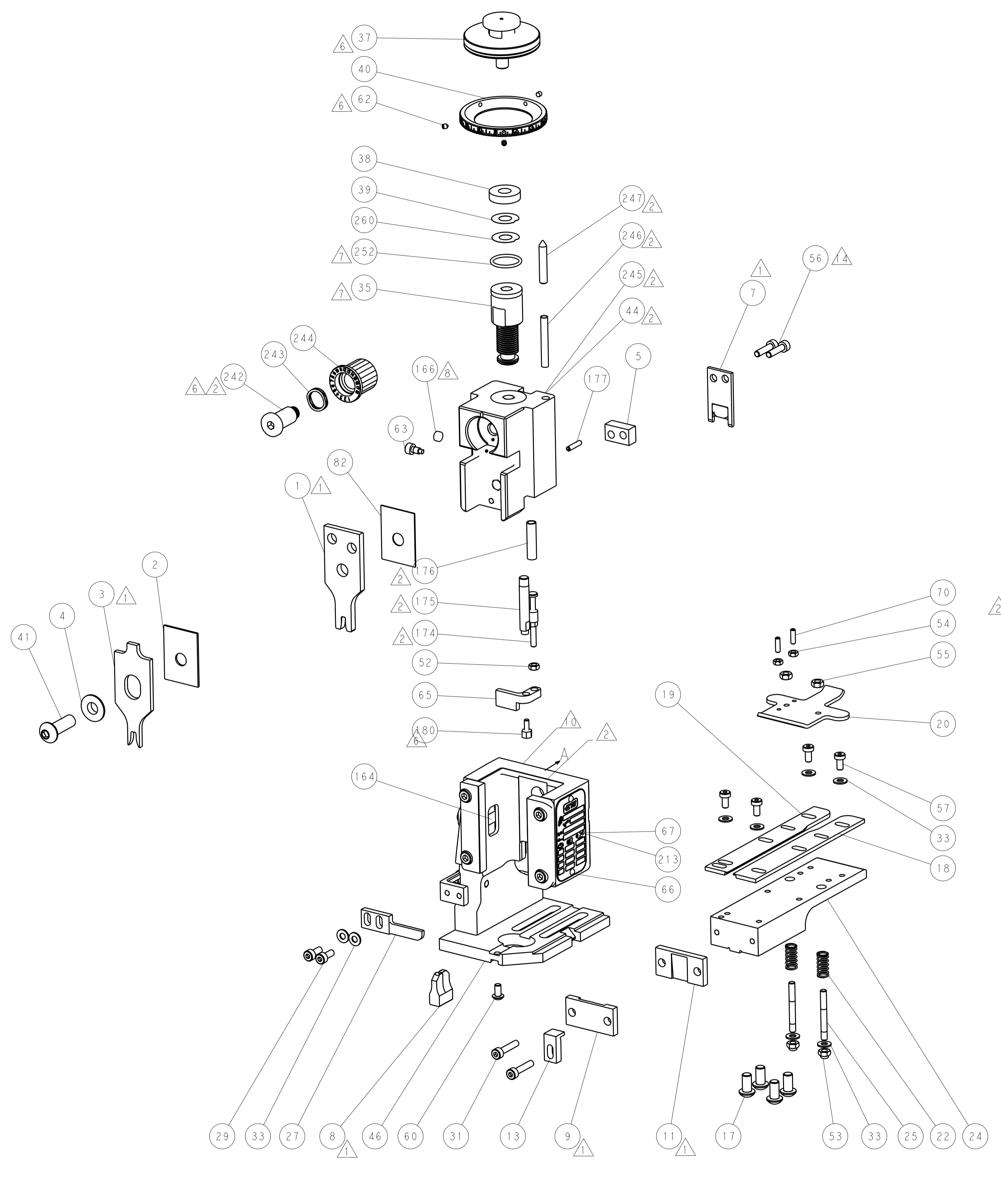
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	REV
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	10OCT2014	B
	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±.0001	10OCT2014	G
				10OCT2014	A
MATERIAL:	FINISH:	WEIGHT:	SCALE:	Customer Accessible Production Drawing	
			1:1	SHEET 1 OF 4	

LOC	DIST	REV	DATE	BY	APPD
A	66				

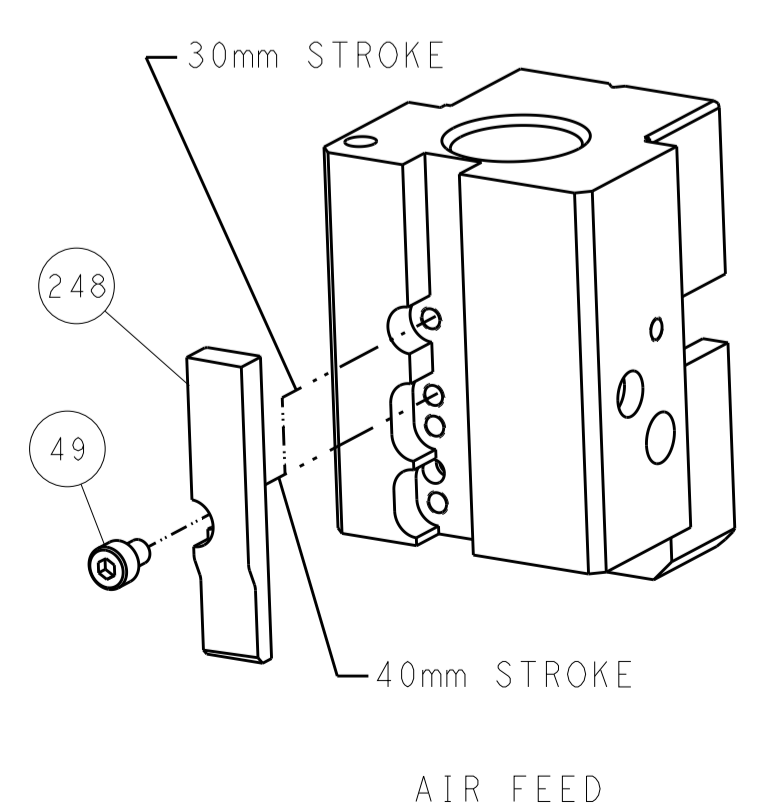
REVISIONS			
REV	DATE	BY	APPD
-	-	-	-
-	-	-	-



HOLDDOWN SET-UP



CAM POSITION



AIR FEED

**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		DWN B. WEAVER 10OCT2014 CHK G. BAILEY 10OCT2014 APVD G. BAILEY 10OCT2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 ©=2150495 SCALE 1:1 SHEET 2 OF 4 REV A		RESTRICTED TO TE Connectivity Harrisburg, PA 17105-3608	
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APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED. Rows include SERVO LATCH PLATE, SMART APPLICATOR, PNEUMATIC FEED.

APPLICATOR DATA. Table with columns: CRIMP SIZE, WIRE, INSUL, APPL INSTRUCTIONS.

TERMINAL DATA: STOCKO TERMINAL STOCKO CRIMP SPECIFICATION. Table with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TE TERMINAL, STOCKO TERMINAL.

TERMINAL DATA: STOCKO TERMINAL STOCKO CRIMP SPECIFICATION. Table with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TE TERMINAL, STOCKO TERMINAL.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

WIRE SIZE, CRIMP HEIGHT WIRE CRIMP UNIT, CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT WIRE CRIMP UNIT, CRIMP HEIGHT REFERENCE SETTING.

- 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.
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.
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.
TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1.
TERMINALS USED WITH 0.25mm2-1mm2, 22AWG-18AWG.
TERMINALS USED WITH 0.25mm2-1mm2, 24AWG-18AWG.
CUT 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.

Table with columns: ITEM NO, DESCRIPTION, PART NO. Rows include FINE ADJUST HEAD ASM, PUSH ROD, BUSHING, SPRING, CAM, PART NO.

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

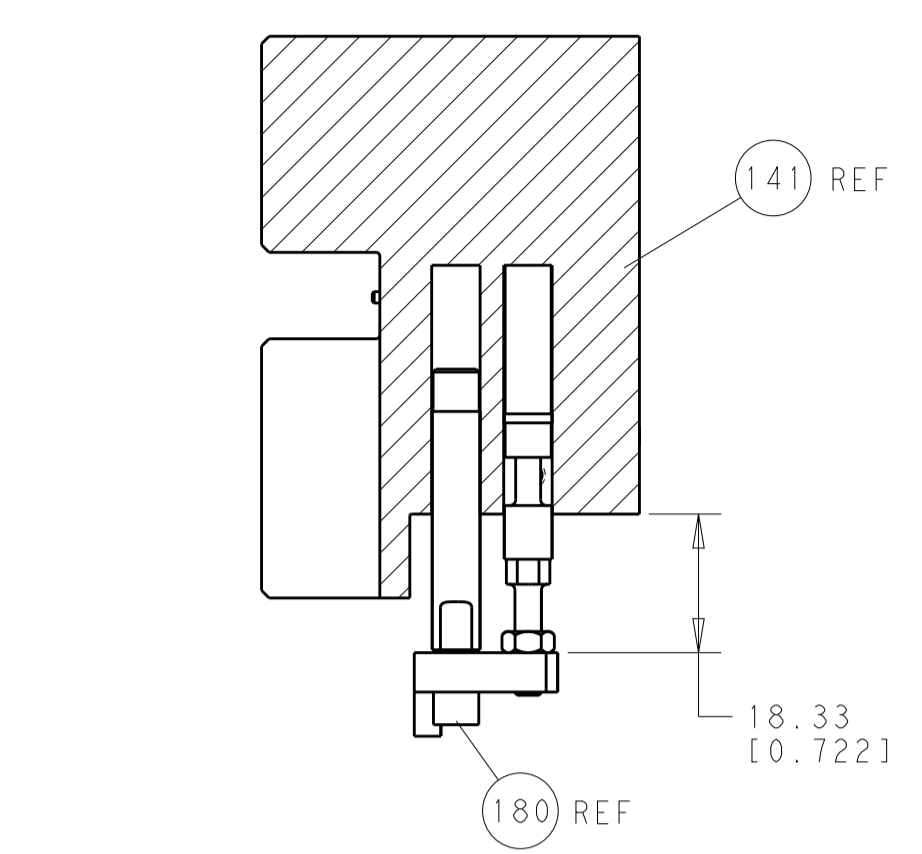
REVISIONS. Table with columns: REVISIONS, DESCRIPTION, DATE, DWN, APVD.

Table with columns: ITEM NO, DESCRIPTION, PART NO, ITEM NO. Rows include WASHER, WAVE SPRING, RETAINER, INSULATION DIAL, SHCS, LOW HEAD, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, TAG, IDENTIFICATION, SCR, BHSC, RoHS, FEED FINGER ASSEMBLY, STANDOFF, HOLD-DOWN, SPRING, COMPRESSION, GUIDE PIN, HOLDDOWN, RING, RETAIN, EXTERN, MAGNET, RARE EARTH HIGH ENERGY, COUNTER, MAGNETIC, SPRING, FEED FINGER, O-RING, FEED CAM, DETENT PIN, SCR, BHSC, RoHS, APPLICATOR BASIC ASSEMBLY, RAM, ASIAN STYLE, BOLT, ADJUSTMENT, PIN, RETAIN, GRVD, MEMORY CHIP, PROGRAMMED, SERVO FEED LATCH ASM, SPACER, CRIMPER, DOCUMENTATION PACKAGE, SCR, SET, FLT POINT, TAG, IDENTIFICATION, SCREW, DRIVE, RH, RoHS, HOLDDOWN, TERMINAL, LIMITER, ADJUSTMENT BOLT, SCR, SET, SOC, CONE POINT, FEED FINGER, SHCS, LOW HEAD, RoHS, SCR, SKT HD CAP, RoHS, NUT, HEX, REG, RoHS, NUT, LOCK, HEX, TORQUE, NUT, HEX, REG, RoHS, PAWL, EF, AIR, SCR, SKT HD CAP, FEED CAM, PRE FEED, SCR, BHSC, RoHS, DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, PRECISION, WASHER, FLAT, REG M4, SCR, SKT HD CAP, RoHS, SCR, SKT HD CAP, RoHS, STRIPPER (MACHINING), STUD, THREADED, PLATE, STRIP GUIDE, SPRING, COMPRESSION, DRAG, STRIP GUIDE, REAR, STRIP GUIDE, FRONT, SPACER, HOLD-DOWN, PLATE, REAR SHEAR, PLATE, FRONT SHEAR, ANVIL, COMBINATION, END FEED, BLADE, SLUG, SPACER, BLOCK, FL CRIMPER SPACER, CRIMPER, INSULATION F PREMIUM, SPACER, CRIMPER, CRIMPER, WIRE.

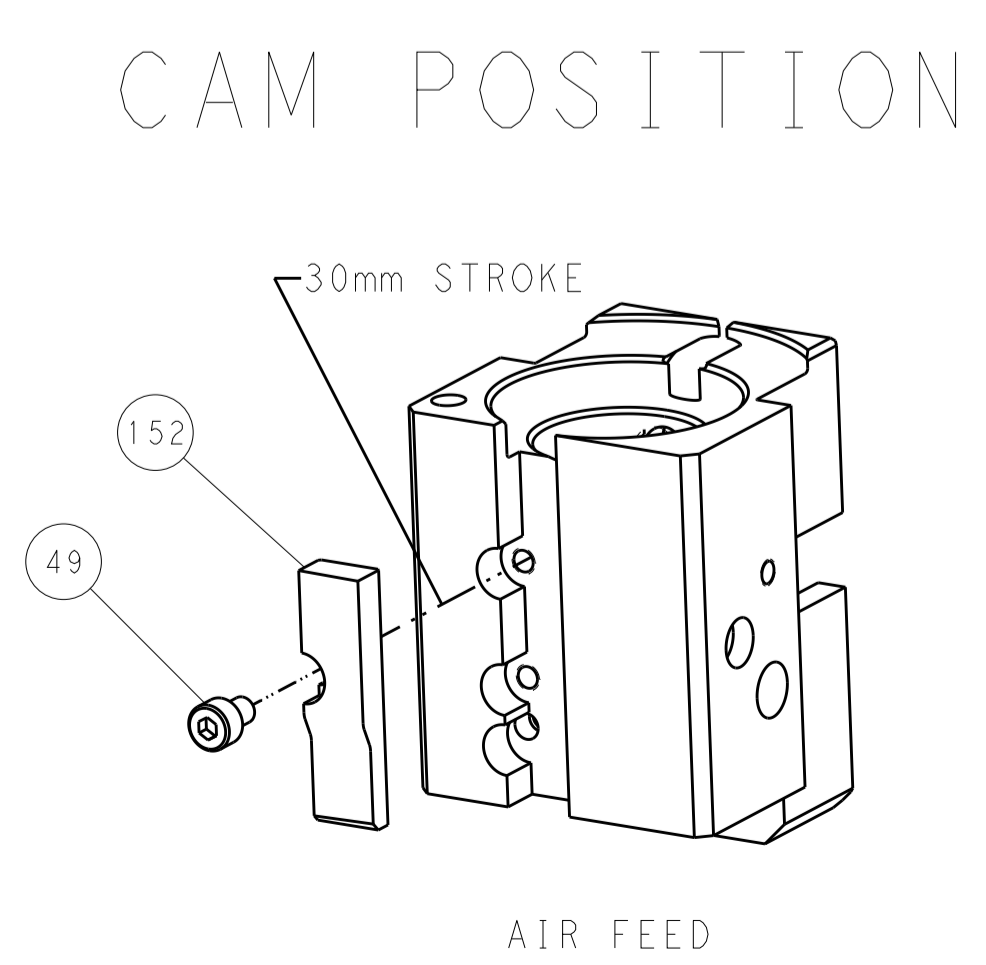
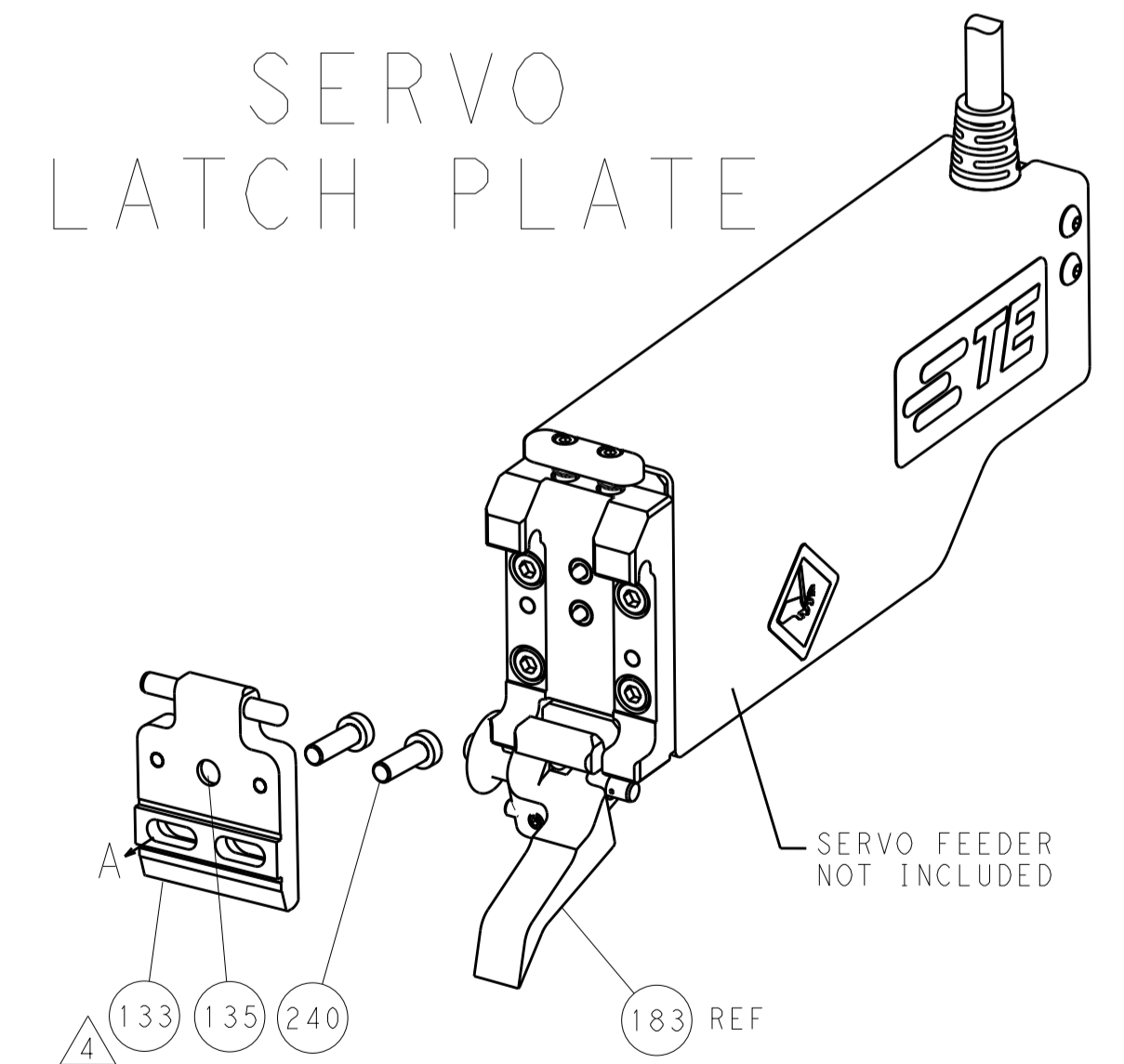
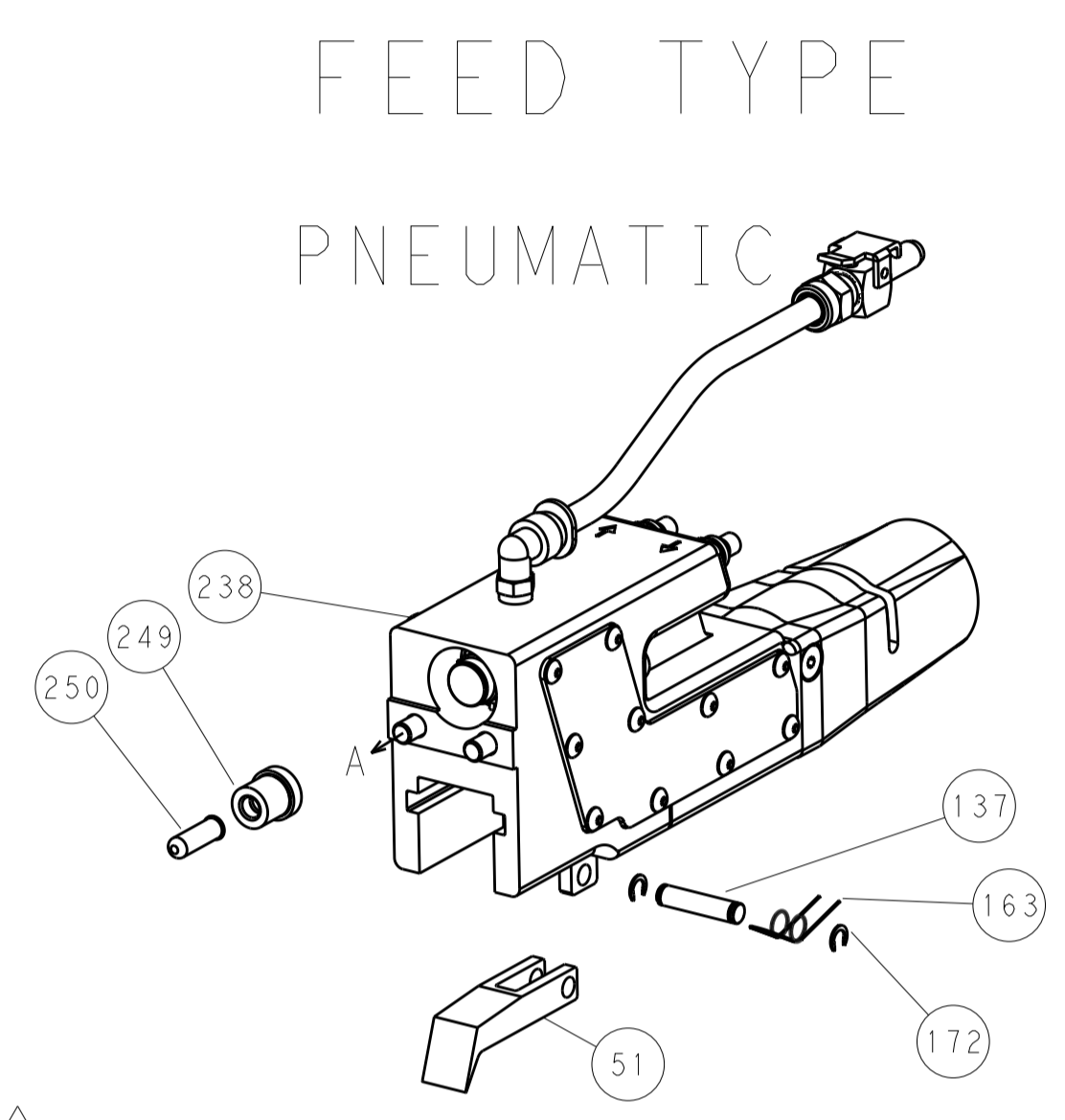
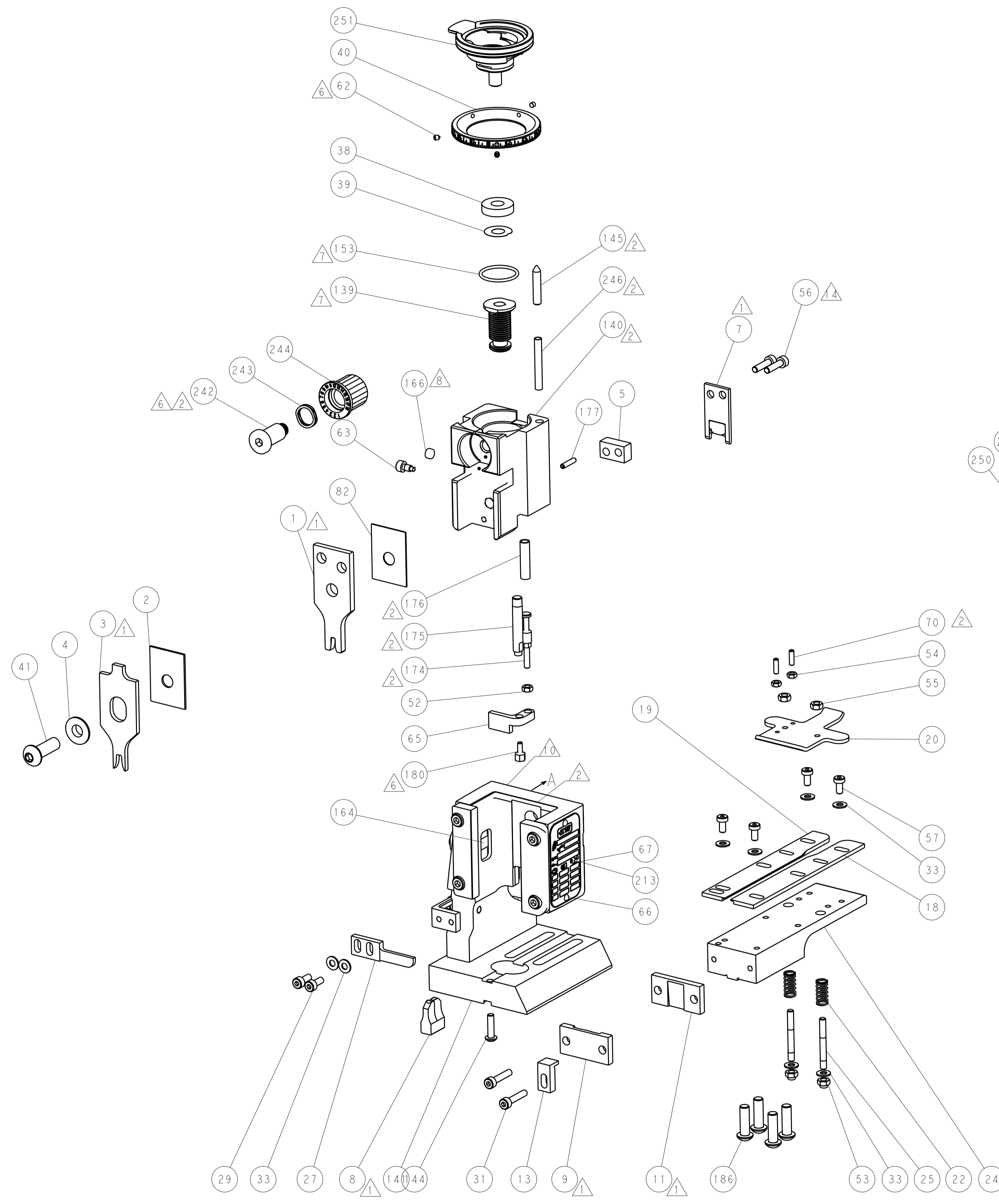
Customer Accessible Production Drawing. Includes dimensions, tolerances, dimensions, material, finish, weight, scale, sheet information.

LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS			
NO.	DESCRIPTION	DATE	BY
1	SEE SHEET 1		



HOLDDOWN SET-UP



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		NAME: Ocean End Feed Applier PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:1	RESTRICTED TO: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150495 SHEET 4 OF 4 REV A