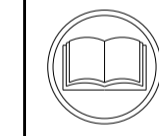


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2150915-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
	2150915-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150915-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150915-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
	2150915-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150915-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150915-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
2150915-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
2150915-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150915-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	3.20 mm [.126]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION	
TERMINAL NAME: 6.0 mm HSG Lance Terminal, Female	
WIRE STRIP LENGTH 4.10-4.90 mm [.161-.193 IN]	INSULATION DIAMETER RANGE Ø1.10-1.40 mm [.043-.055 IN]
TERMINAL APPLICATION SPECIFICATION 15000082 Rev 3/28/2018	
TERMINALS APPLIED	
TE TERMINAL 3311186-1	SUMITOMO TERMINAL 1500-0082

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.10+/-0.05 [.043+/-0.002]	7.3
0.30mm2	1.15+/-0.05 [.045+/-0.002]	6.3



- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
- 3 LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150915-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150915-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150915-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150915-6
- 5 ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 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.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 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.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 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.
- 12 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

13. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.

APPLICATOR STYLE CONVERSION CHART

2	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
7	-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
	-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	-	-	-	1	-	1803259-1	BUSHING, FLANGED	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	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
	-	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

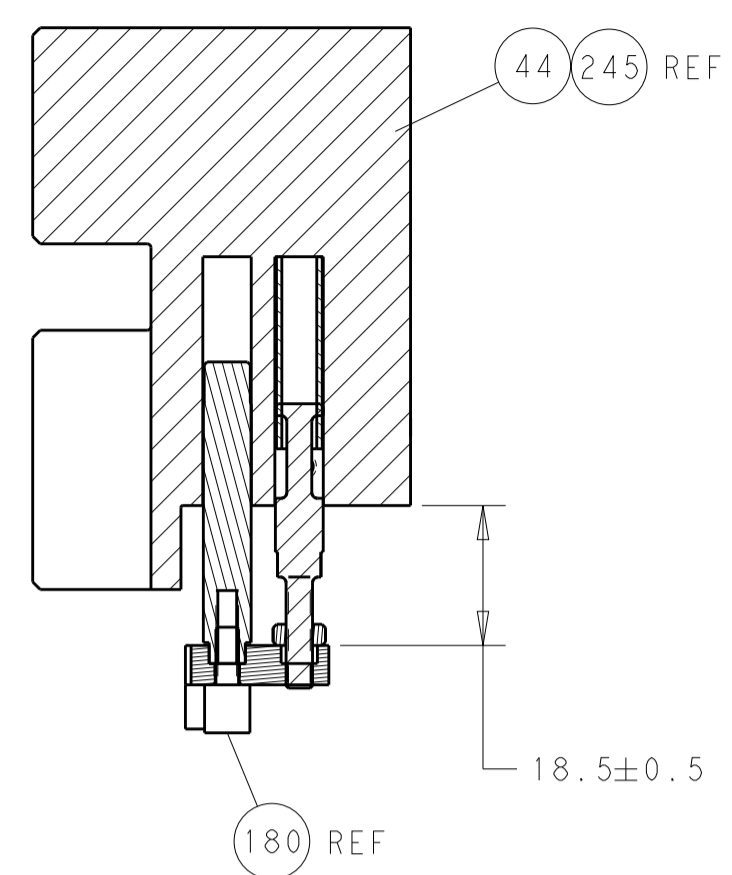
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			1		DEVELOPMENT	10APR2018	TB	TE
			A		RELEASE	18MAY2018	AW	CT

6	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	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
6	-	1	1	1	1	1	1-1752354-0	STANDOFF, HOLD-DOWN	180
	-	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
8	-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REFREF	REFREF	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	1	455888-7	SPACER, CRIMPER	82
	-	1	1	1	1	1	2119791-6	DEPRESSOR, WIRE	73
	-	1	1	1	1	1	2119791-6	DEPRESSOR, WIRE	72
	-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
	-	2	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
	-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
	-	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6	-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 X 4.0	62
	-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	-	-	-	1	2063961-1	FEED FINGER	58
	-	4	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
	-	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	-	-	-	1	-	2119792-2	PAWL, EF, AIR	51
	-	1	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	50
	-	-	-	-	1	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
	-	1	-	1	1	1	2119369-1	RAM, AMP STYLE, END FEED	44
	-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
7	-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	8	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
	-	2	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1	1	1803292-4	DRAG	20
	-	1	1	1	1	1	1803152-5	STRIP GUIDE, REAR	19
	-	1	1	1	1	1	1803151-5	STRIP GUIDE, FRONT	18
	-	1	1	1	1	1	3-240641-0	SPACER	16
	-	1	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
	-	1	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
	-	2	2	2	2	2	240645-7	SPACER, SHEAR PLATE	10
	-	1	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
	1	1	1	1	1	1	1-1803426-2	ANVIL, COMBINATION, END FEED	8
	-	1	1	1	1	1	1-240651-3	BLADE, SLUG	7
	-	-	-	-	-	-	-	-	6
	-	1	1	1	1	1	240641-4	SPACER	5
	-	1	1	1	1	1	7-238011-0	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	1	1-1803223-5	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
	1	1	1	1	1	1	2-1803454-4	CRIMPER, WIRE	1
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

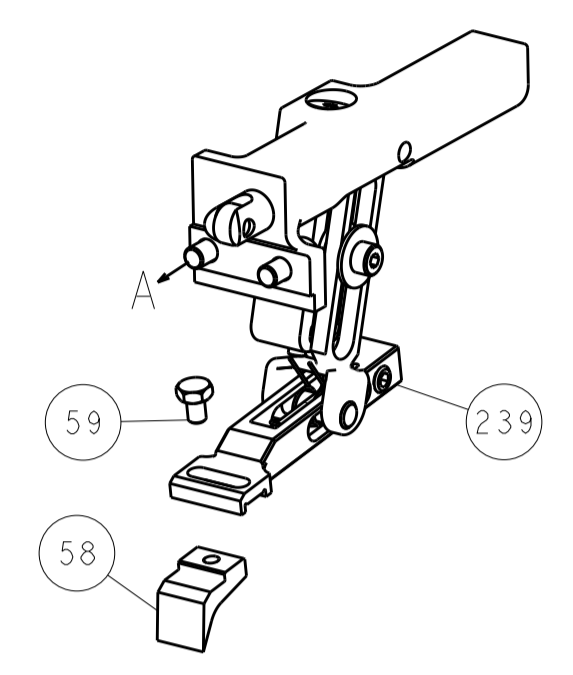
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	7 PLC ±	8 PLC ±	T. BROOKS	10APR2018							
	ANGLES ±	FINISH ±	NAME		R. KNEPPER		10APR2018		TE Connectivity Harrisburg, PA 17105-3608									
MATERIAL			PRODUCT SPEC		APPLICATION SPEC		SIZE		CASE CODE		DRAWING NO							
			WEIGHT		RESTRICTED TO		A1		00779		©=2150915							
Customer Accessible Production Drawing											SCALE	1:1	SHEET	1	OF	4	REV	A

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

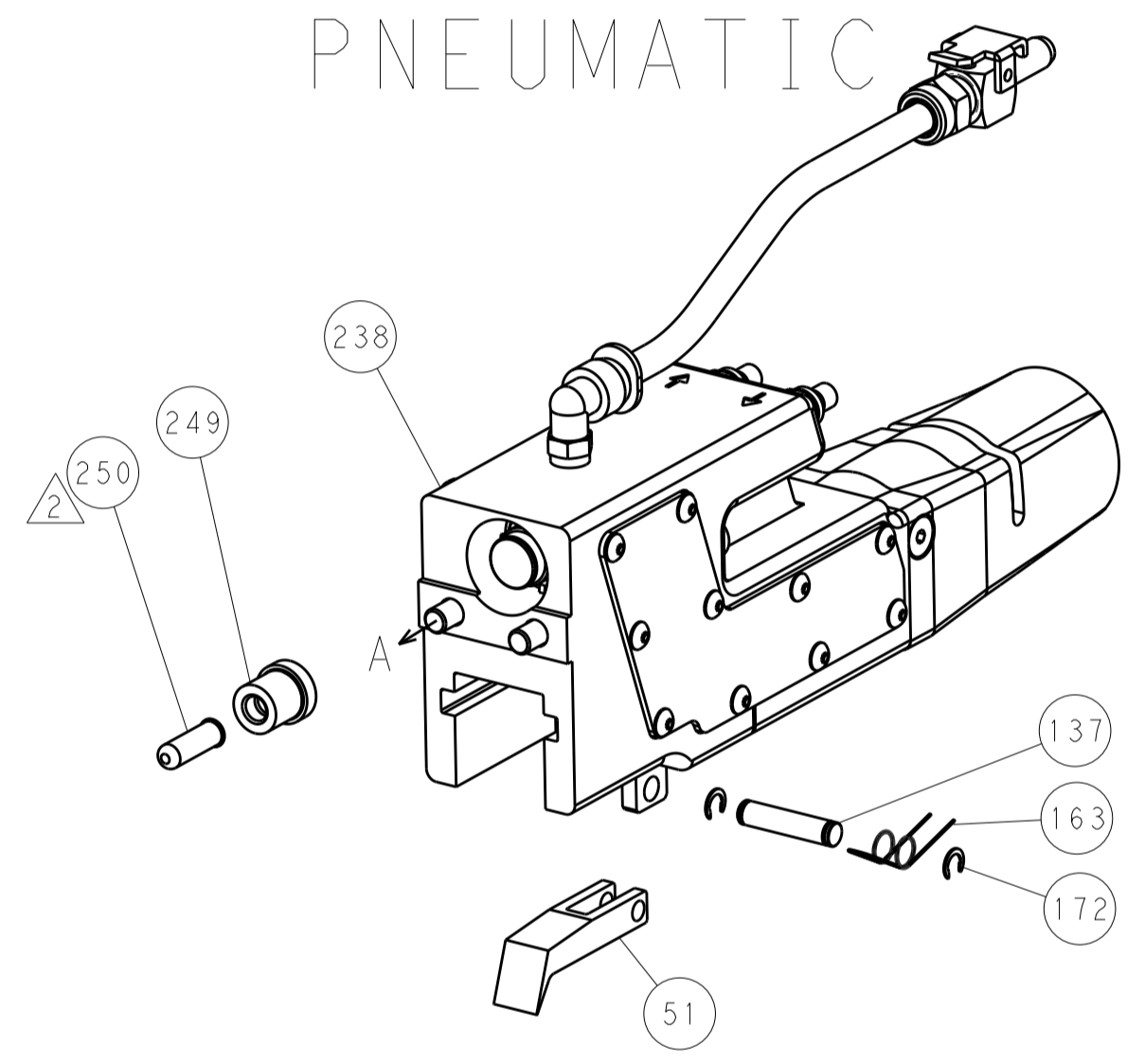


HOLDDOWN SET-UP

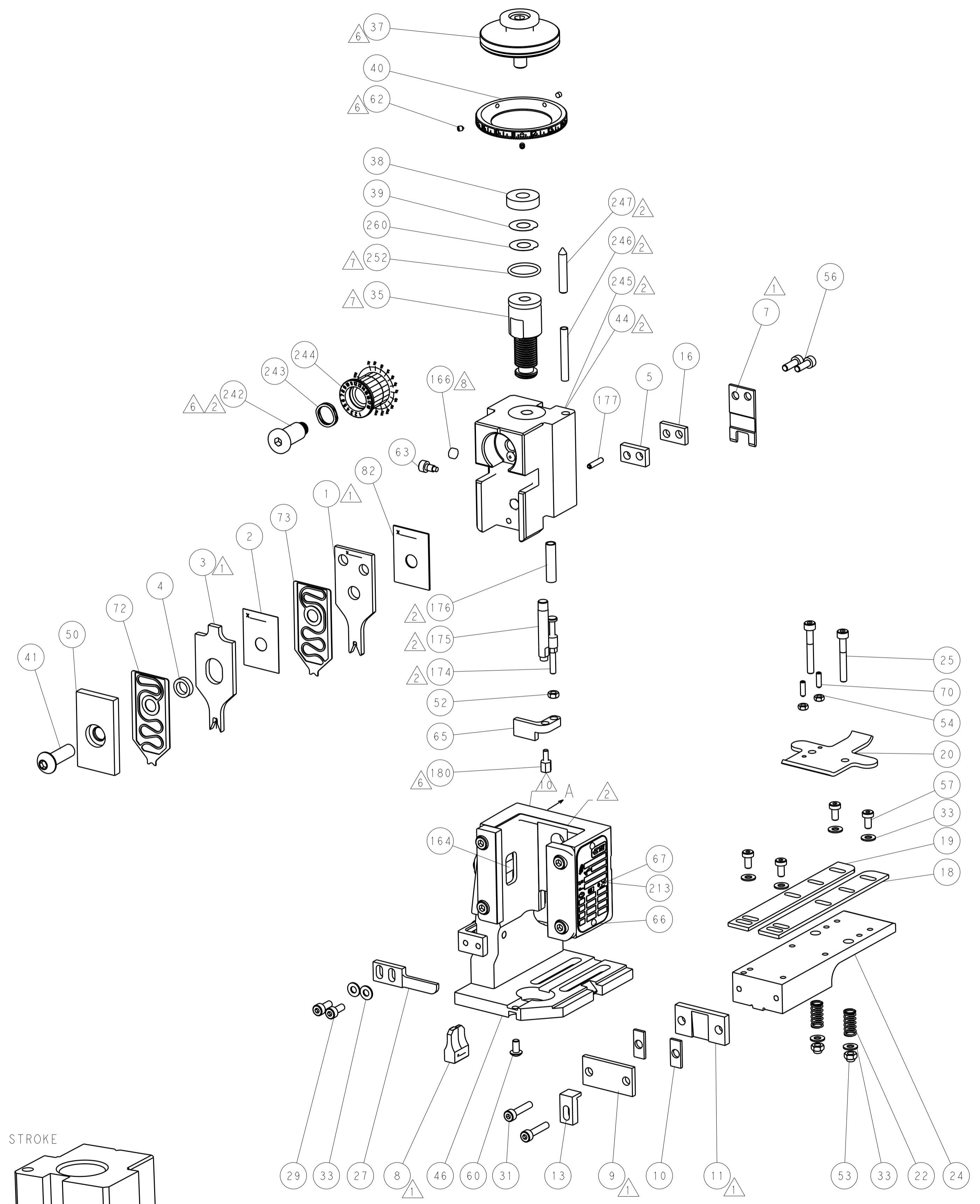
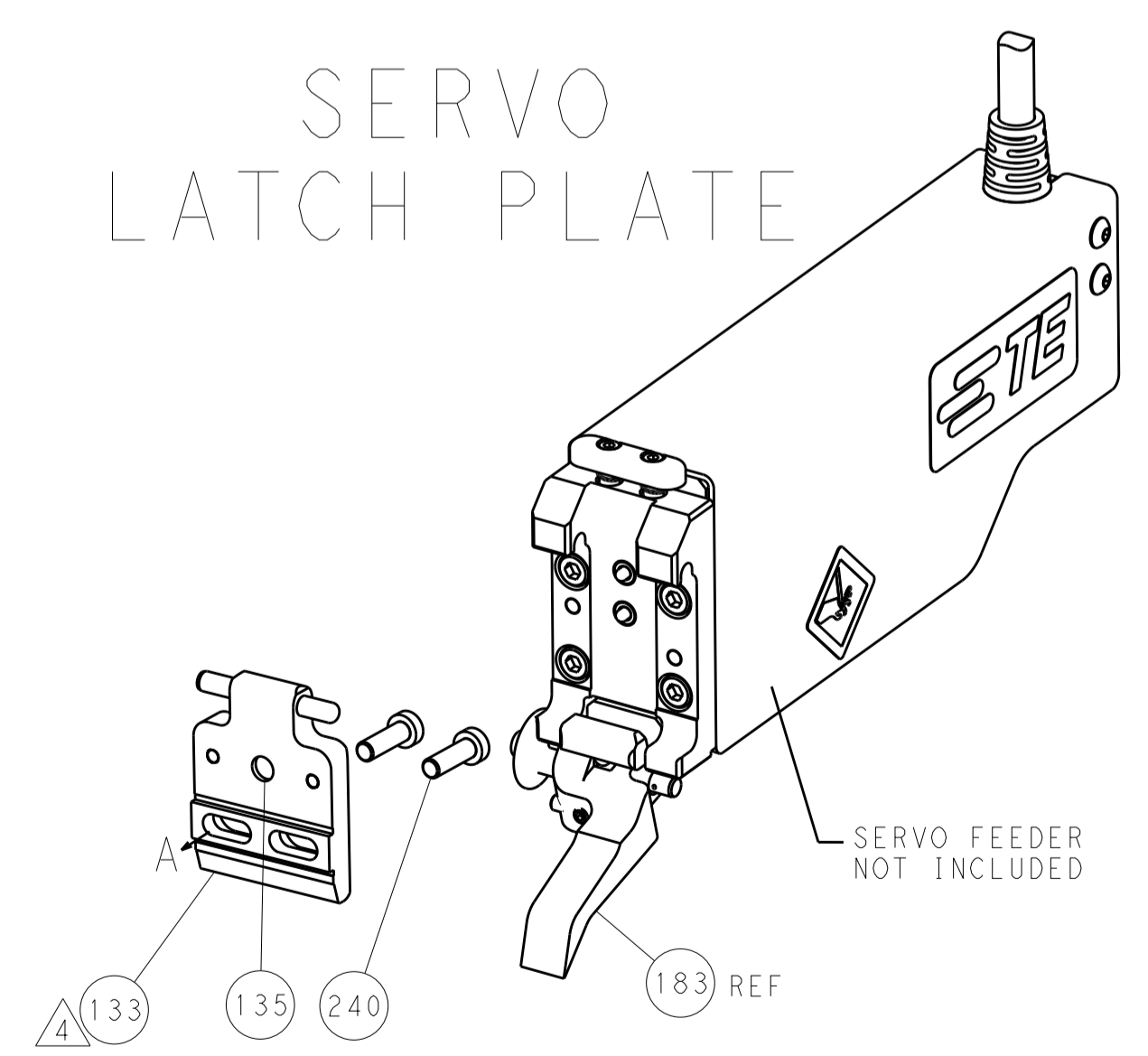
FEED TYPE
MECHANICAL



PNEUMATIC



SERVO
LATCH PLATE



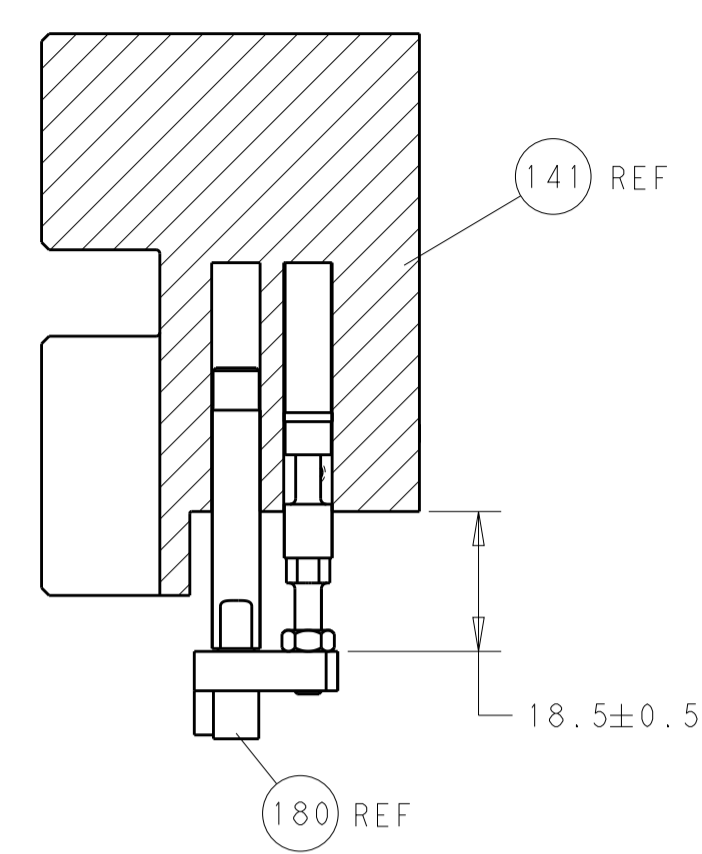
CAM POSITIONS



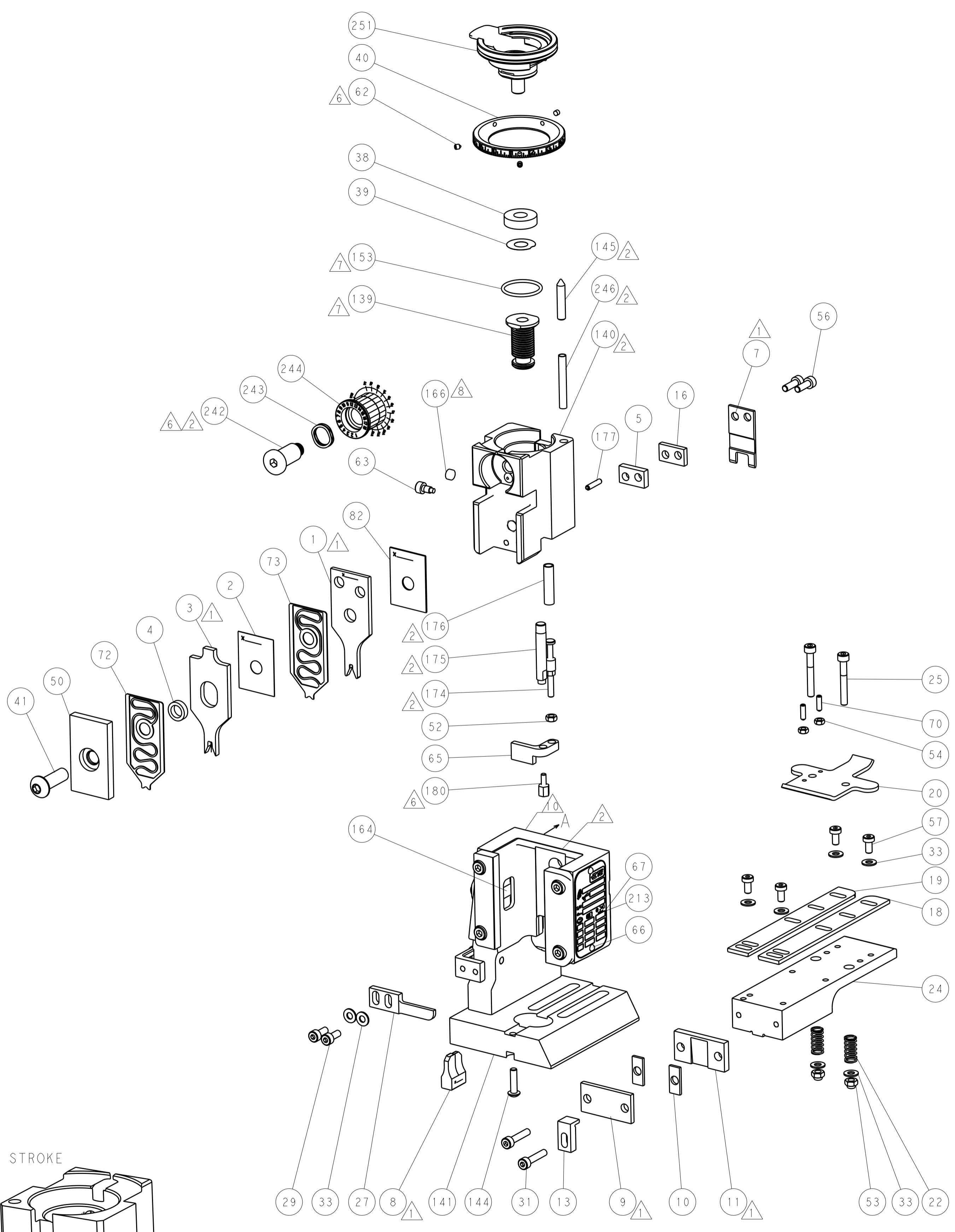
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. BROOKINS 10APR2018		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
ANGLES	FINISH	MATERIAL		CHK R. KNEPPER 10APR2018		NAME Ocean End Feed Applicator	
MATERIAL		FINISH		APVD T. ELBIN 10APR2018		PRODUCT SPEC	
MATERIAL		FINISH		APVD T. ELBIN 10APR2018		APPLICATION SPEC	
MATERIAL		FINISH		APVD T. ELBIN 10APR2018		SIZE CAGE CODE DRAWING NO	
MATERIAL		FINISH		APVD T. ELBIN 10APR2018		RESTRICTED TO	
MATERIAL		FINISH		APVD T. ELBIN 10APR2018		SCALE 1:1 SHEET 2 OF 4 REV A	
MATERIAL		FINISH		APVD T. ELBIN 10APR2018		Customer Accessible Production Drawing	

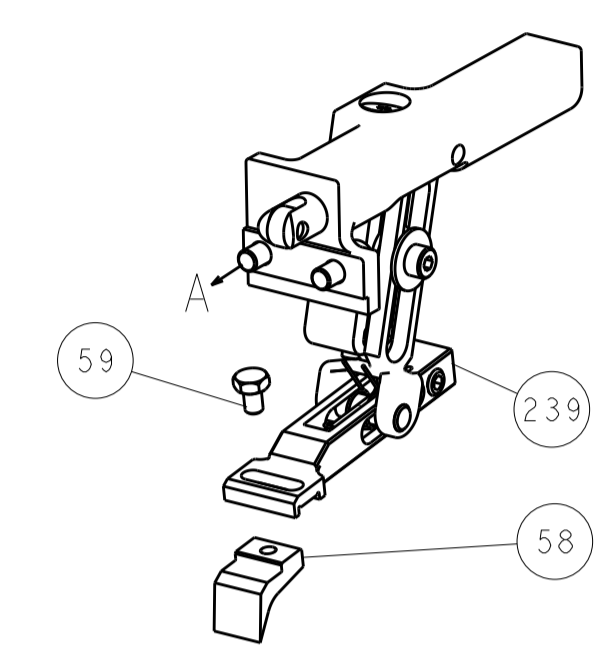
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



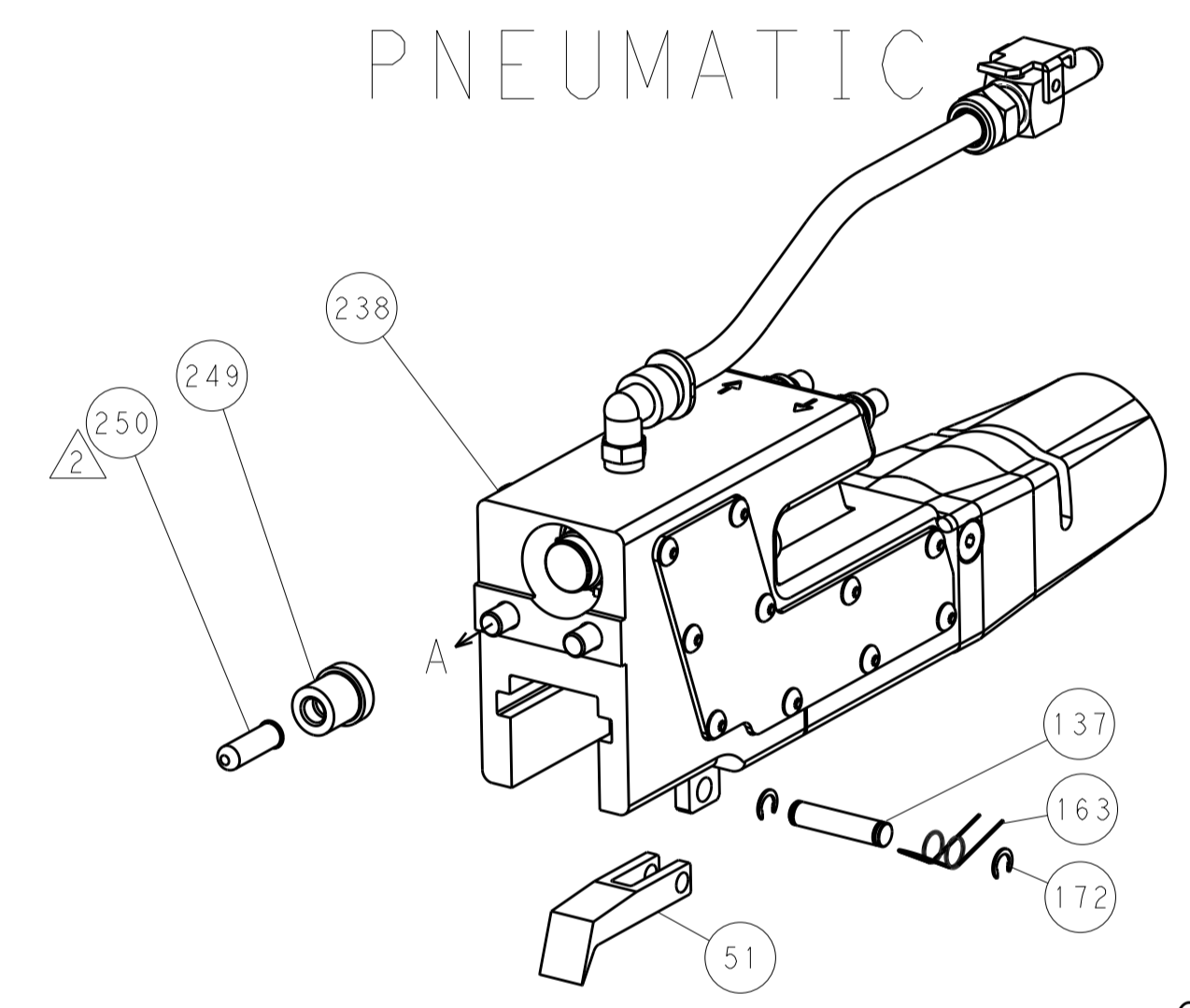
HOLDDOWN SET-UP



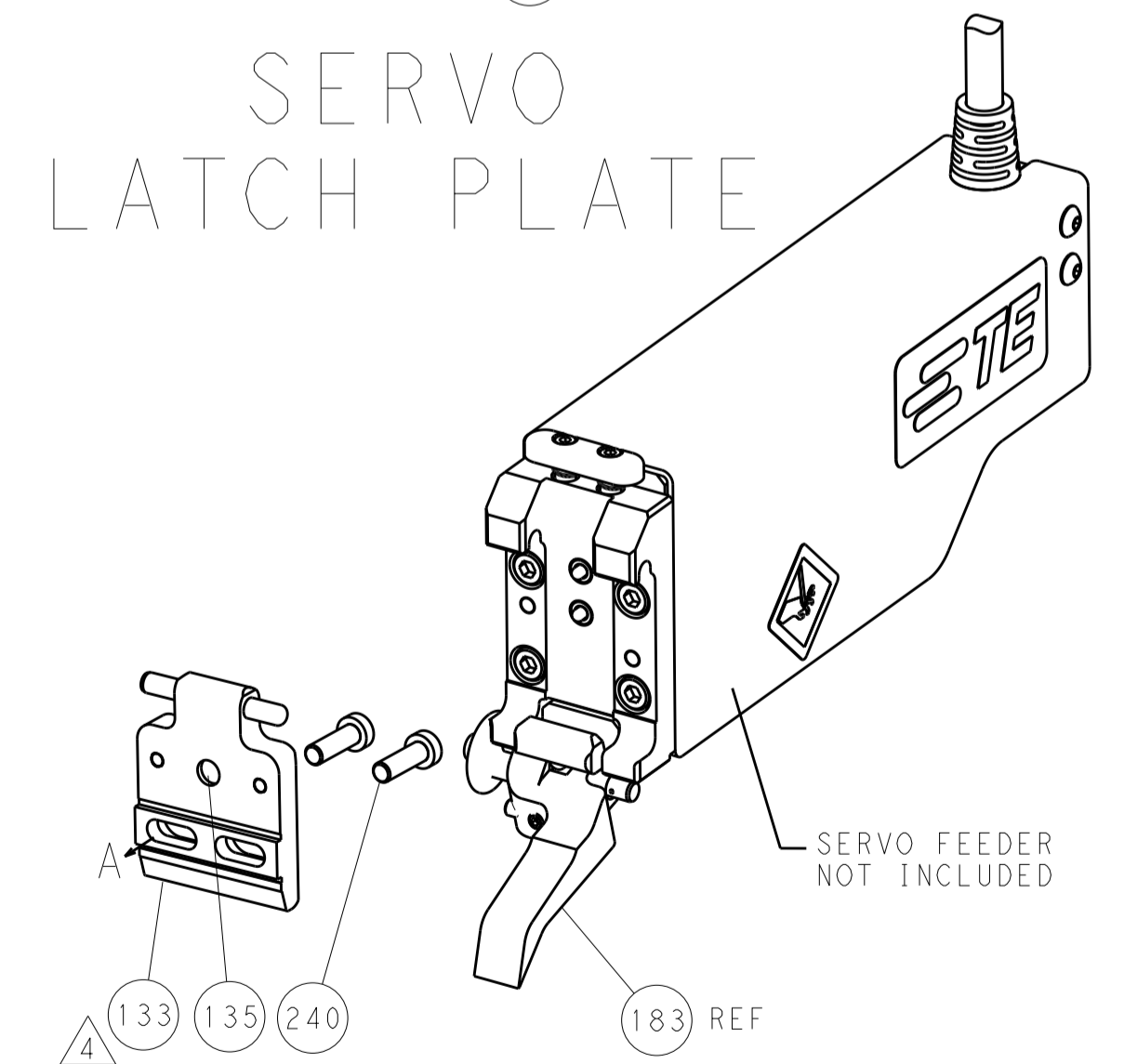
FEED TYPE
MECHANICAL



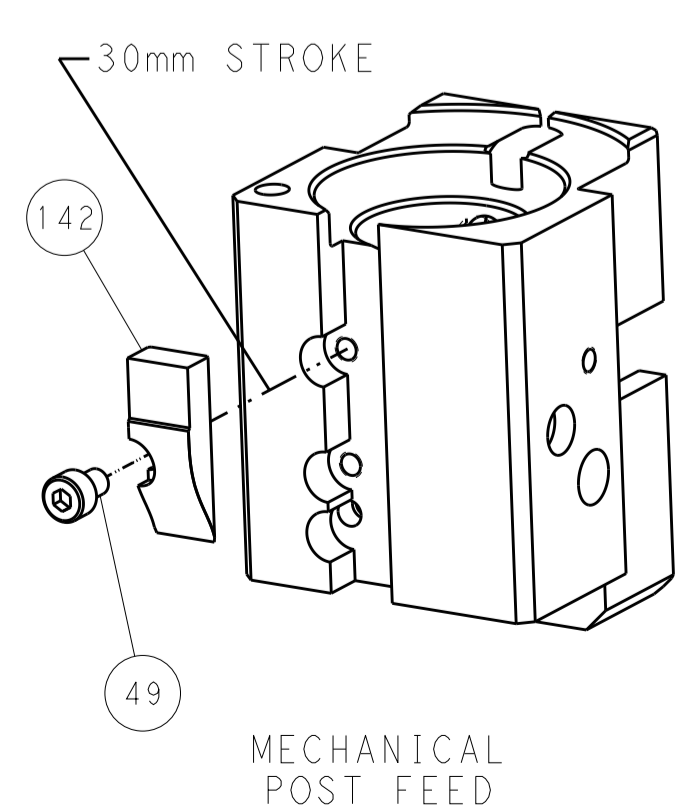
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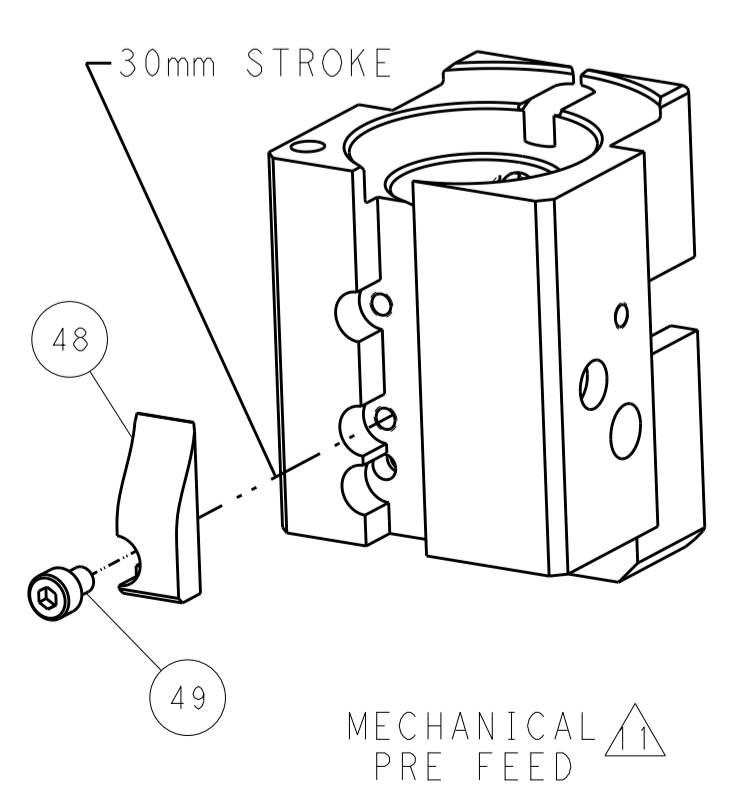
SERVO
LATCH PLATE



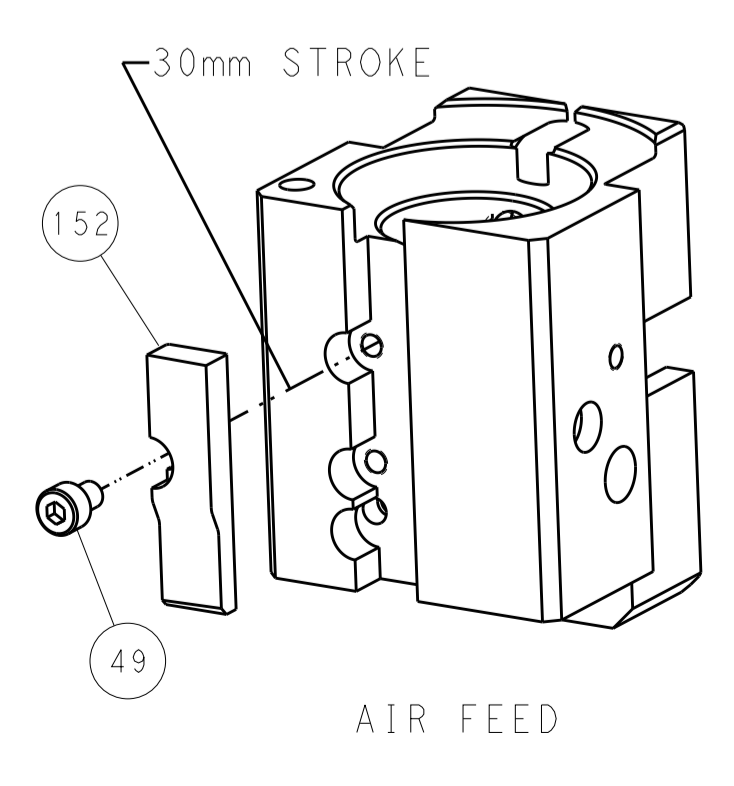
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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 T. BROOKENS 10APR2018		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK R. KNEPPER 10APR2018	NAME	Ocean End Feed Applicator	
	1 PLC	±		APVD J. ELBIN 10APR2018	PRODUCT SPEC	SIZE	CAGE CODE DRAWING NO
	2 PLC	±			APPLICATION SPEC	SCALE	RESTRICTED TO
	3 PLC	±				1:1	4 of 4
	4 PLC	±					REV A
	ANGLES	±					
MATERIAL	FINISH			WEIGHT			
				Customer Accessible Production Drawing			