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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER
PART NUMBER REVISION DESCRIPTION FEED TYPE CONVERT TO PART NUMBERS REQUIRED

APPLICATOR DATA
CRIMP SIZE TYPE WIRE INSUL APPL INSTRUCTIONS

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION
TERMINAL NAME: FASTON
WIRE STRIP LENGTH INSULATION DIAMETER RANGE
TERMINAL APPLICATION SPECIFICATION
TERMINALS APPLIED

WIRE SIZE CRIMP HEIGHT mm [INCH] 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 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.
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.
TERMINAL LUBRICANT IS RECOMMENDED.

*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 3 columns: PART NO, DESCRIPTION, ITEM NO

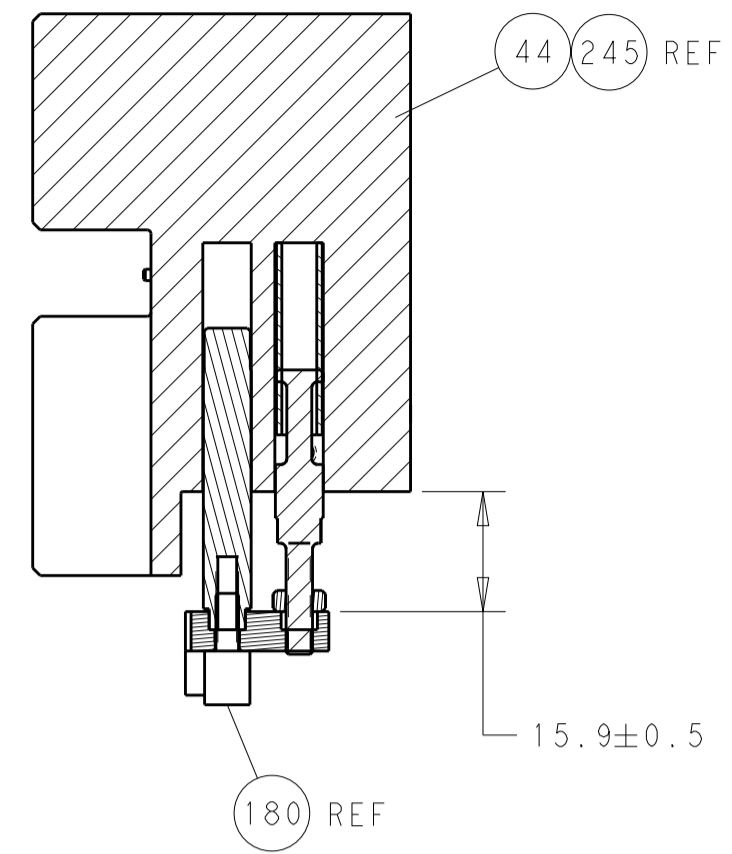
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2
REVISIONS: 1 DEVELOPMENT 26APR2010 JH LZ, 2 RELEASED 28JUN2016 JH TE

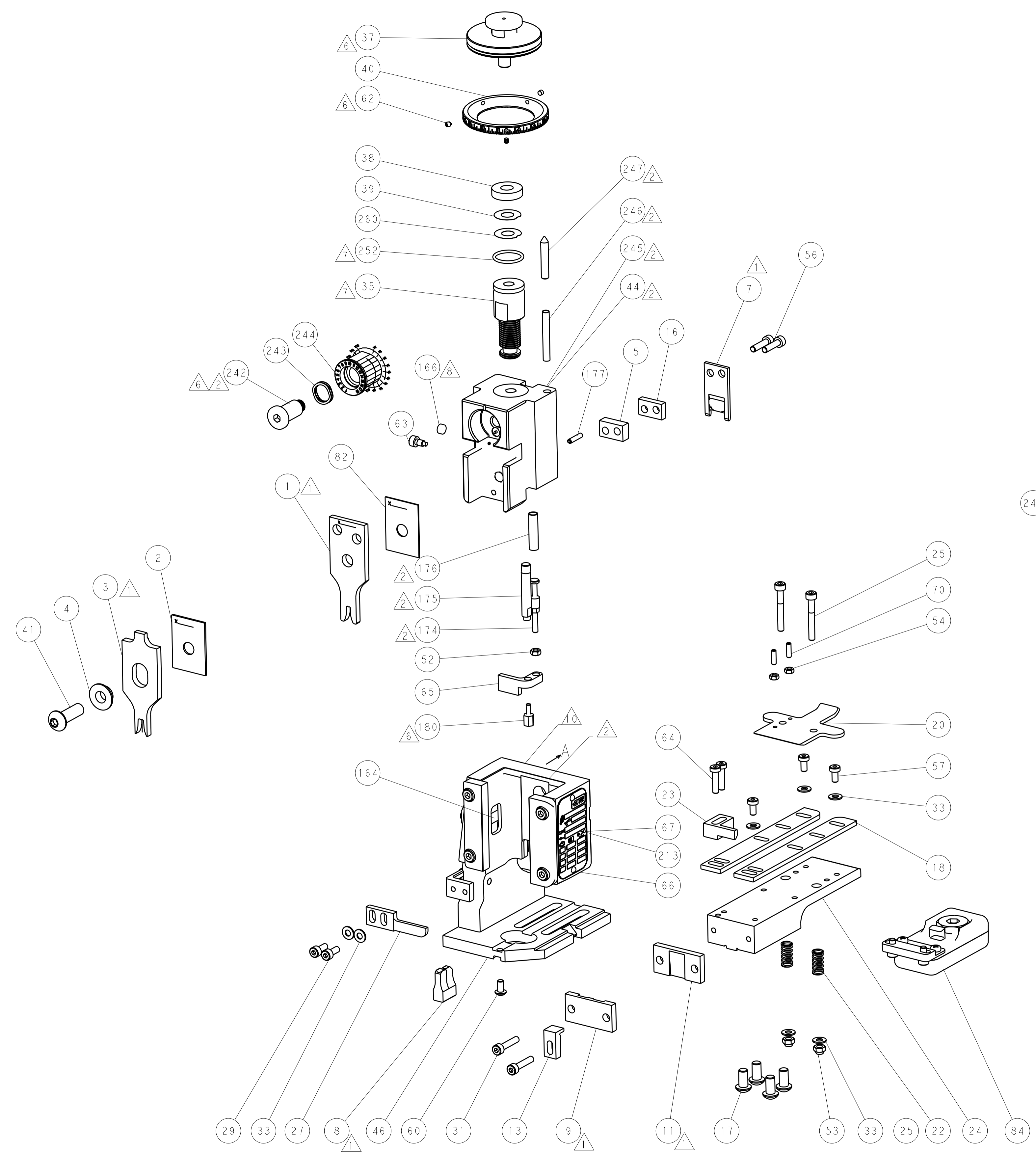
Main assembly table with 10 columns: Part No, Description, Quantity, etc. Includes parts like FEED CAM, DETENT PIN, SPRING, etc.

Customer Drawing details including dimensions, tolerances, material, weight, and customer drawing information.

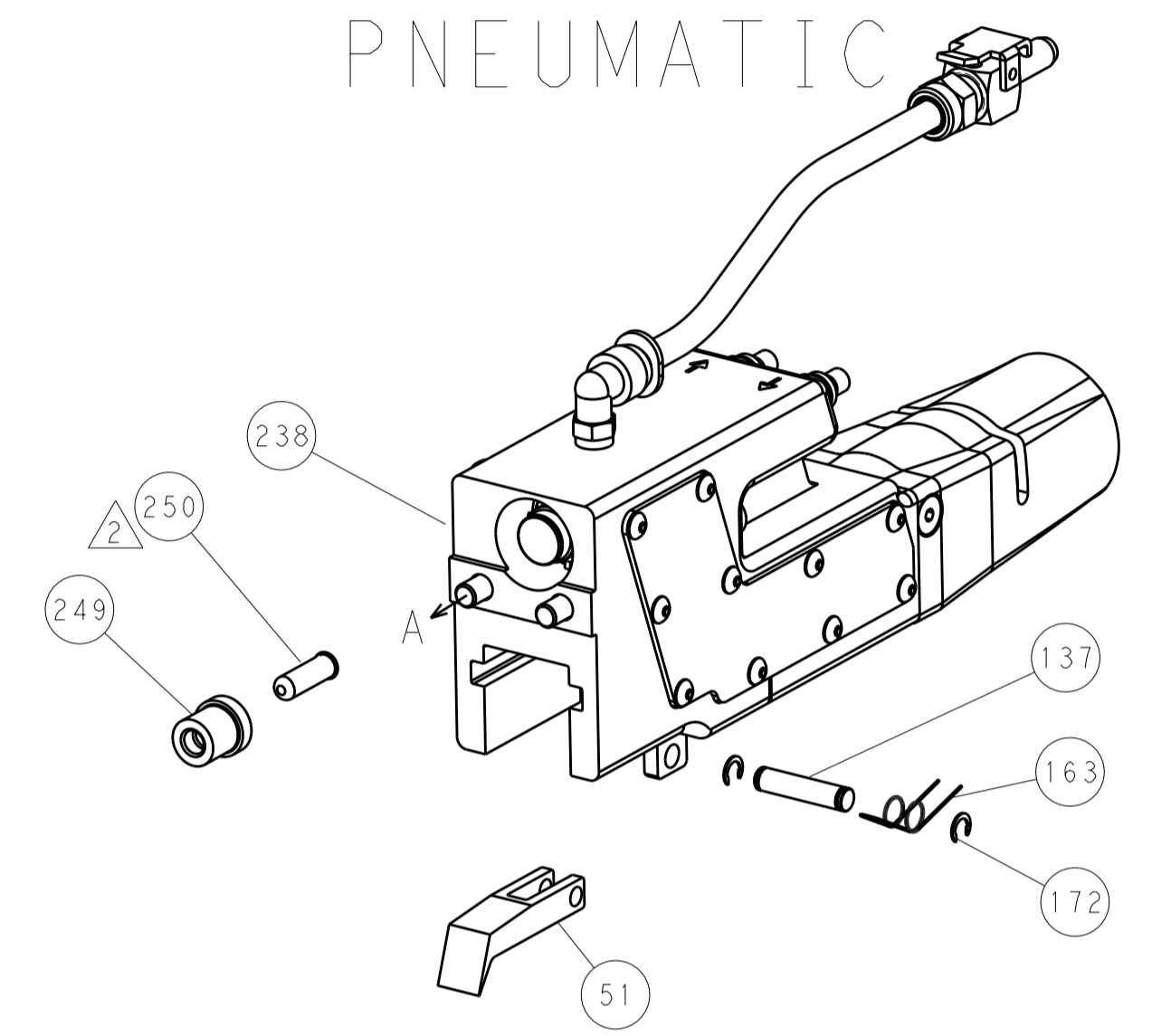
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



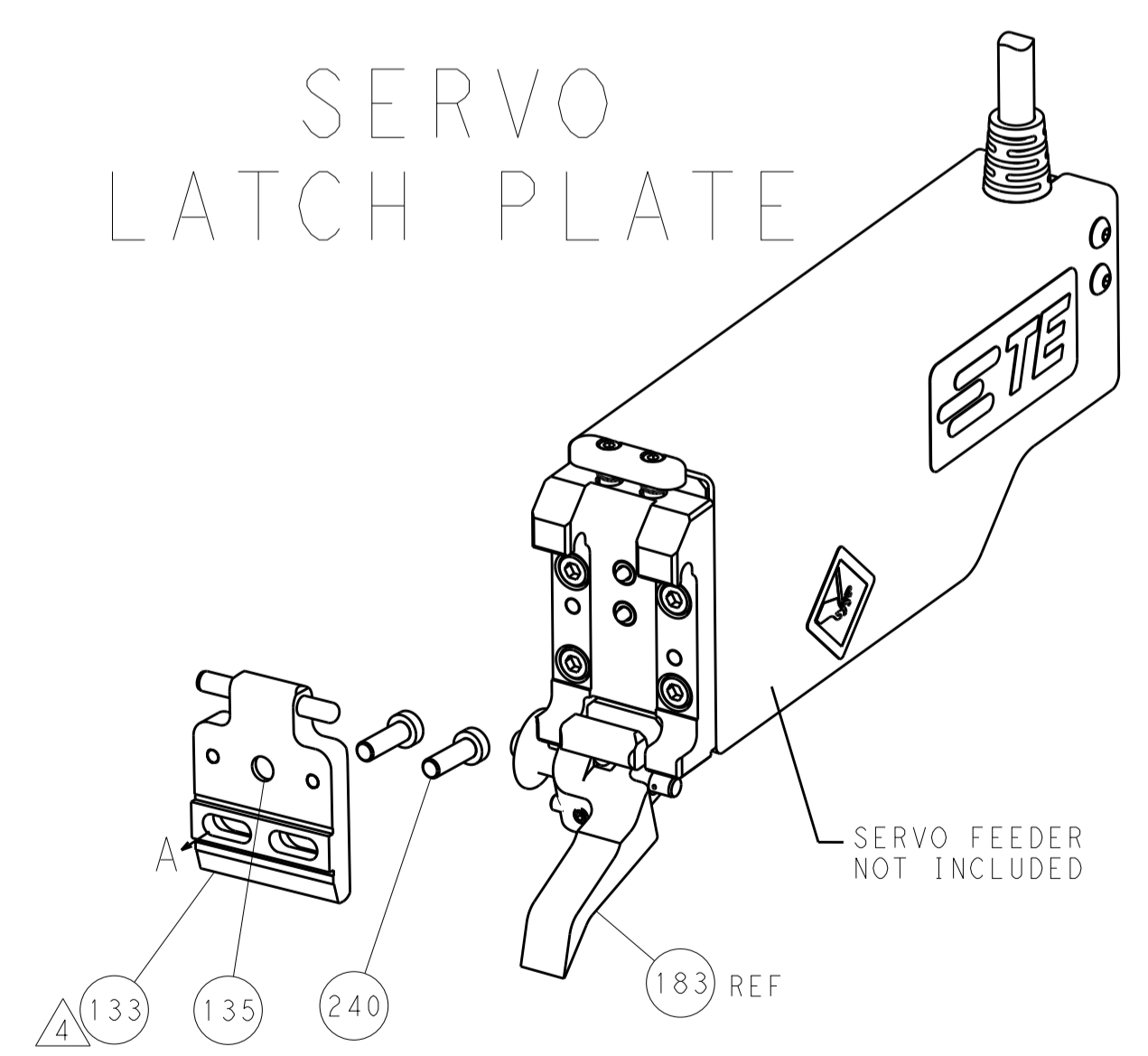
HOLDDOWN SET-UP



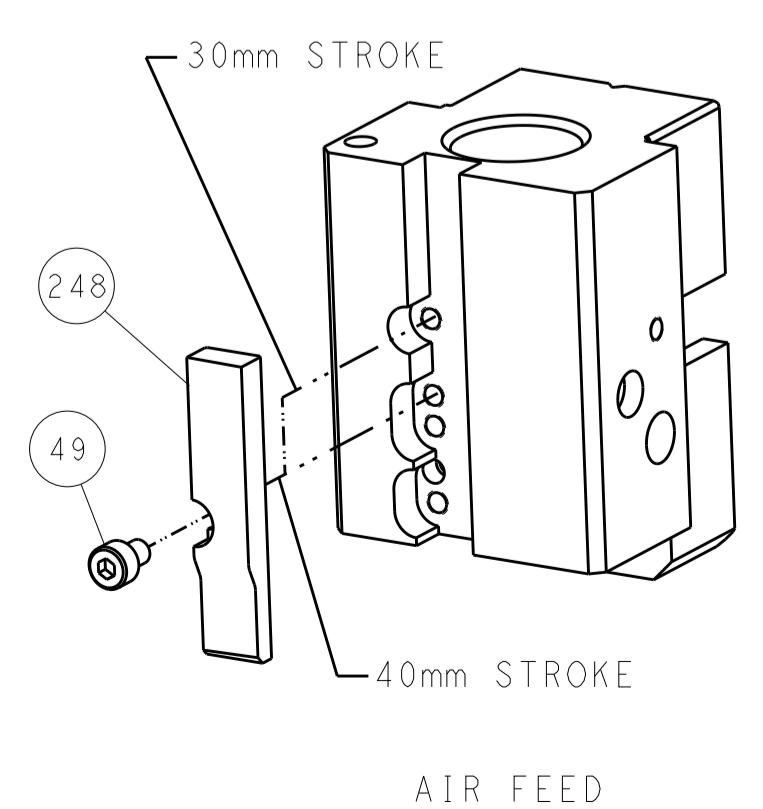
FEED TYPE
 PNEUMATIC



SERVO
 LATCH PLATE



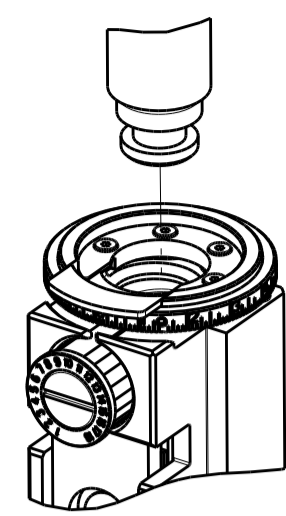
CAM POSITION




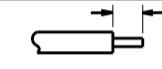

AIR FEED

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



DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HOU 19MAY2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL	FINISH	WEIGHT	CUSTOMER DRAWING	CHK L. ZHANG 19MAY2016	APVD L. ZHANG 19MAY2016	NAME Ocean End Feed Applicator	RESTRICTED TO
				PRODUCT SPEC	APPLICATION SPEC	SIZE CAGE CODE DRAWING NO A11 00779 C=2150678	SCALE 1:1 SHEET 2 OF 4 REV A

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150678-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150678-5	-	-
	2-2150678-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-
2-2150678-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150678-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-10390 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: FASTON		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
5.00-5.80 mm [.197-.228 IN]		Ø2.40-3.70 mm [.094-.146 IN]
TERMINAL APPLICATION SPECIFICATION	114-20108	-
TERMINALS APPLIED 		
TE TERMINAL	TE TERMINAL	TE TERMINAL
160866-2	160866-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
2.50mm2	2.26 +/- 0.05 [.089 +/- .002]	4.7
2.00mm2	2.12 +/- 0.05 [.083 +/- .002]	6.0
1.50mm2	1.99 +/- 0.05 [.078 +/- .002]	7.2
1.00mm2	1.85 +/- 0.05 [.073 +/- .002]	8.7

-  RECOMMENDED SPARE PARTS
-  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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150678-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150678-5
- 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.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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 TERMINAL LUBRICANT IS RECOMMENDED.

***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.

-77-27-25-22	PART NO	DESCRIPTION	ITEM NO
- 1 1 1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- - - 1	2119640-1	PUSH ROD, AIR FEED	250

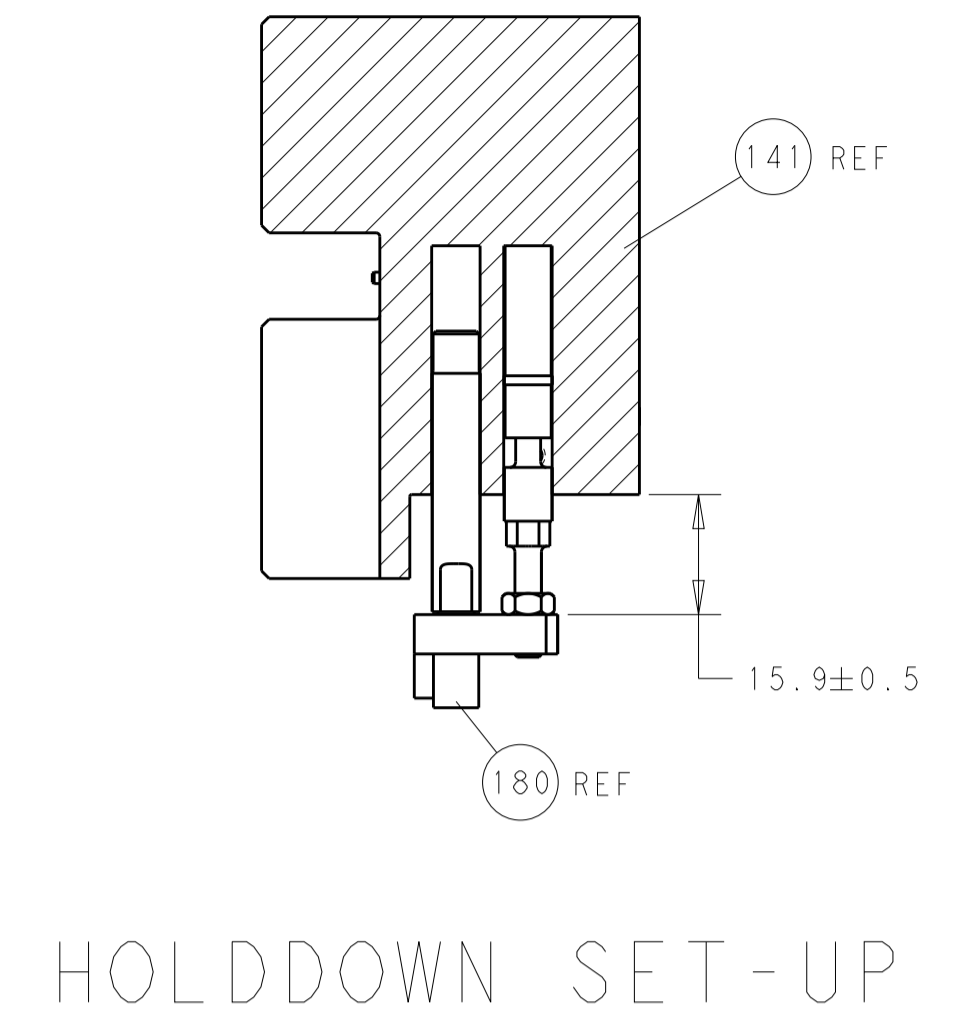
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

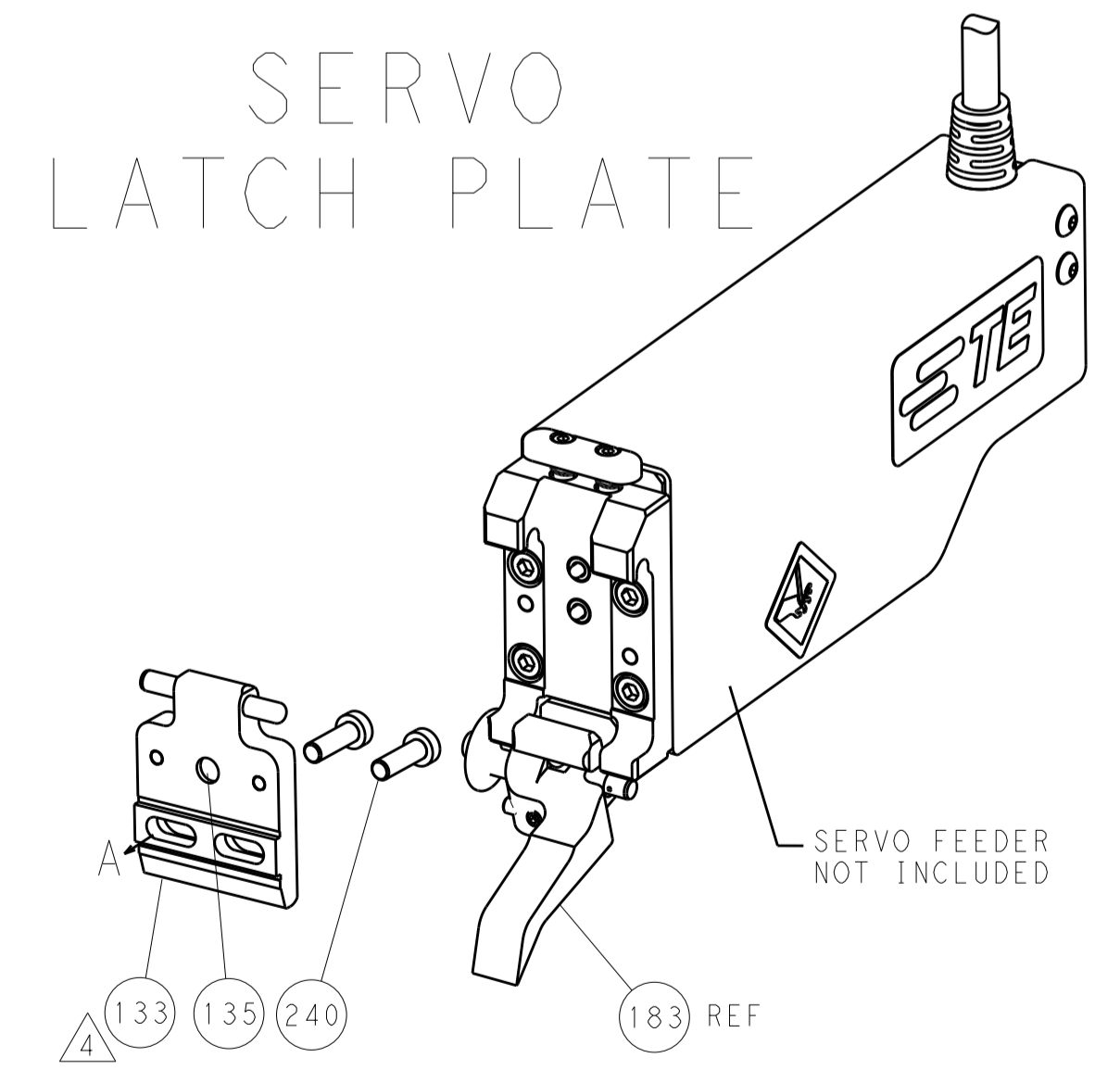
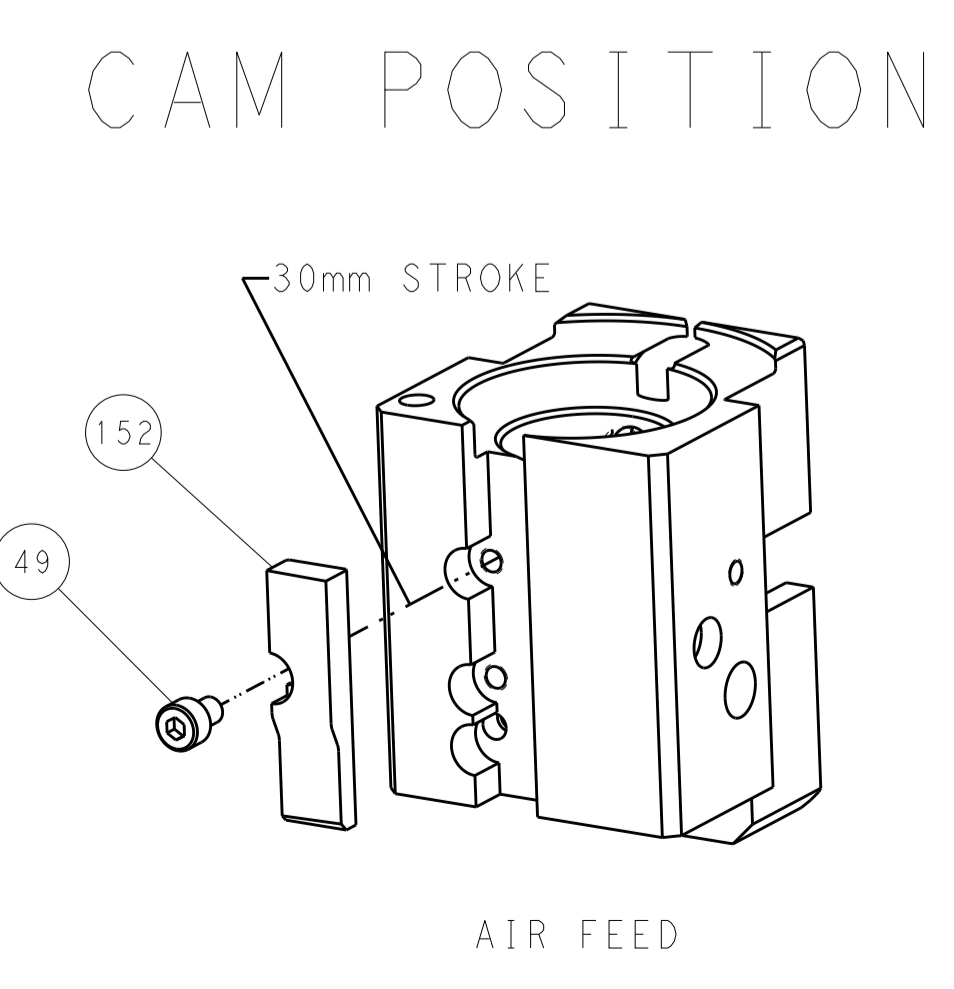
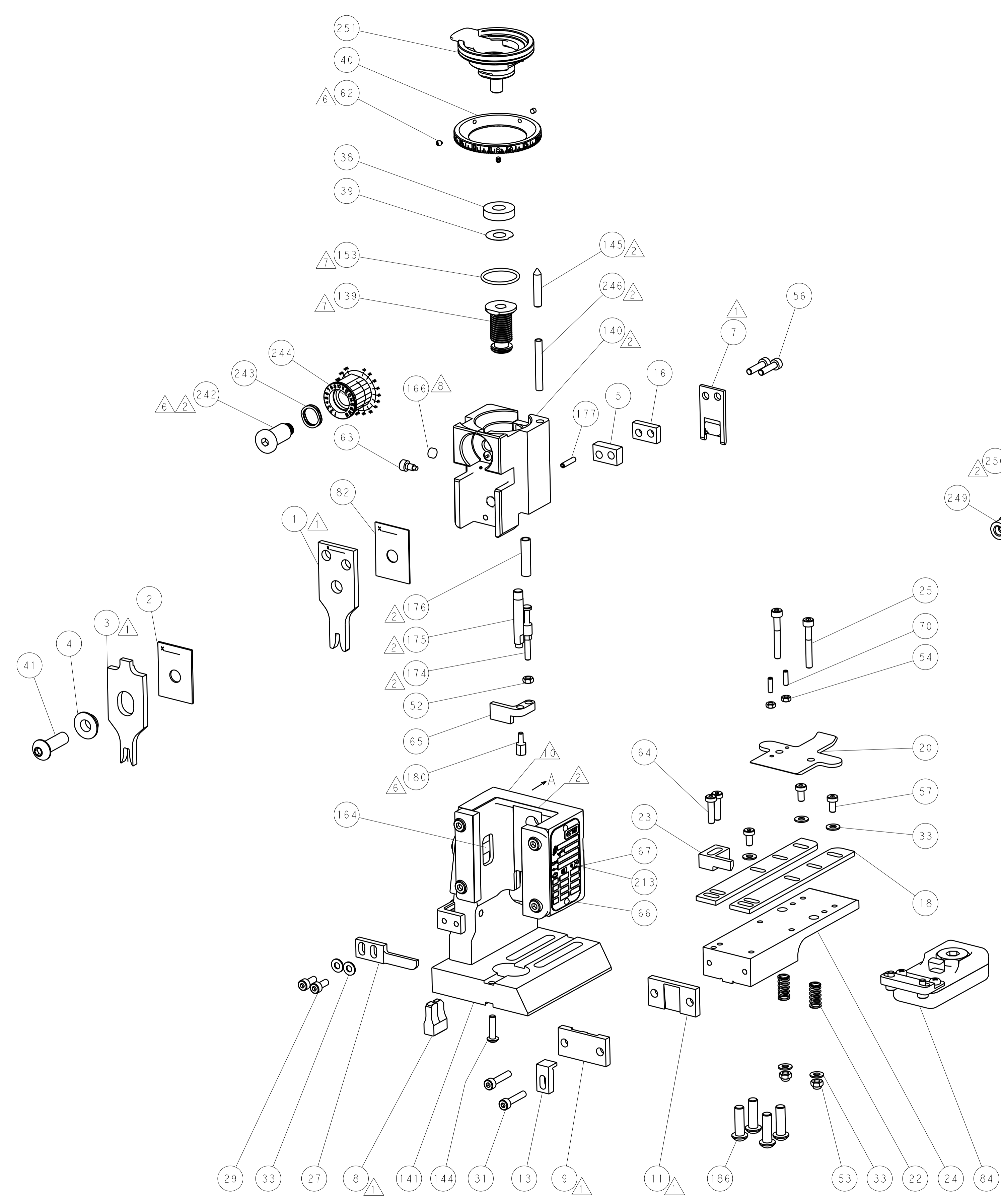
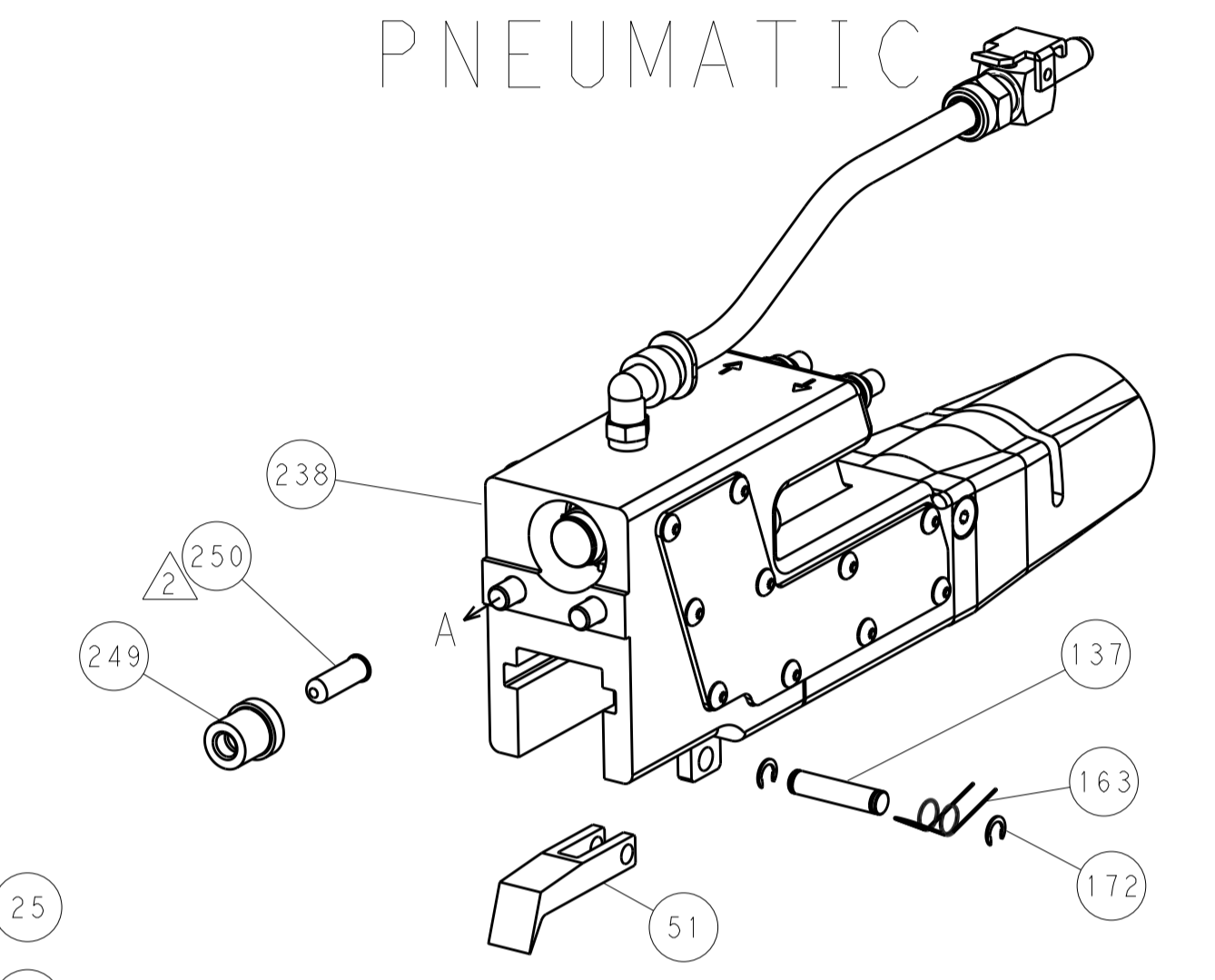
- - - 1	2079988-1	BUSHING, LCH5-12, MISUMI	249
- 1 1 1	1-22279-3	SPRING, COMPRESSION	246
- 1 1 1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
- 1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
- - 2 -	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
- - - 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	1-1752354-3	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
- 1 1 1	455888-6	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	1901681-1	HOLDDOWN, TERMINAL	65
- 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
- 3 3 3	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	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	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
- 1 1 1	1752371-5	PLATE, STRIP GUIDE	24
- 1 1 1	240825-1	PLATE, STRIP HOLD DOWN	23
- 2 2 2	2-22281-3	SPRING, COMPRESSION	22
- 1 1 1	1803292-4	DRAG	20
- 2 2 2	1901259-6	GUIDE, LOWER STRIP	18
- 1 1 1	5-240641-0	SPACER	16
- 1 1 1	1752360-1	SPACER, HOLD-DOWN	13
- 1 1 1	240644-9	PLATE, REAR SHEAR	11
- - - -	-	-	10
- 1 1 1	6-690482-3	PLATE, FRONT SHEAR	9
1 1 1 1	5-1803059-0	ANVIL, COMBINATION, END FEED	8
- 1 1 1	1-2217206-1	BLADE, SLUG	7
- - - -	-	-	6
- 1 1 1	2-240641-5	SPACER	5
- 1 1 1	3-238009-8	BLOCK, FL CRIMPER SPACER	4
1 1 1 1	7-1633961-2	CRIMPER, INSULATION F PREMIUM	3
- 1 1 1	1-455888-0	SPACER, CRIMPER	2
1 1 1 1	4-456409-1	CRIMPER, WIRE .120 "F" PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	19MAY2016	J. HOU	19MAY2016	J. HOU
	3 PLC ±	4 PLC ±	ANGLES ±		L. ZHANG		L. ZHANG
	FINISH						
MATERIAL		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	©=2150678	
CUSTOMER DRAWING				SCALE	1:1	SHEET 3 OF 4	REV A

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



FEED TYPE
PNEUMATIC



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: J. HOU 19MAY2016		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	ANGLES ±
MATERIAL:	FINISH:	WEIGHT:	APVD: L. ZHANG 19MAY2016	NAME:	PRODUCT SPEC:	APPLICATION SPEC:	RESTRICTED TO:
CUSTOMER DRAWING				SCALE: 1:1	SHEET 4 OF 4	REV A	