

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2150433-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1
	2150433-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150433-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150433-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
	2150433-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150433-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150433-4	-	-	-
	2150433-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
2150433-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1	
7-2150433-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.70 mm [.106]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: KOITO TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.42-3.46 mm [.095-.136 IN]		Ø1.98-2.49 mm [.078-.098 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	KOITO TERMINAL	TE TERMINAL	KOITO TERMINAL
2113452-1	99260-00128		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	1.40 +/- 0.05 [.055 +/- .002]	8.0

- 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: 8-2150433-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150433-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150433-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150433-6
- 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.
- 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 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	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	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	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

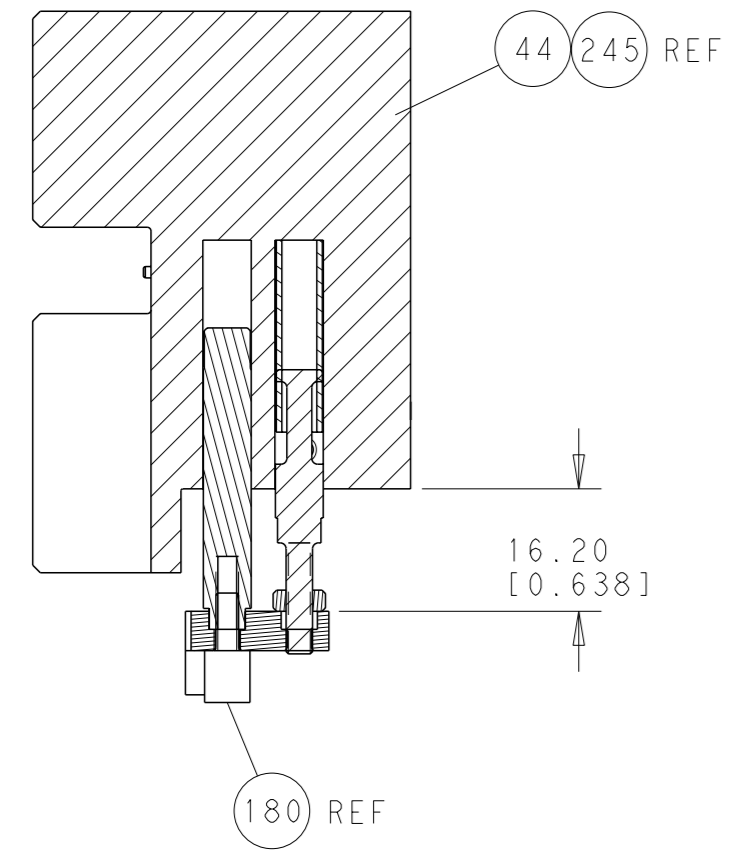
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LYH	DESCRIPTION	DATE	OWN	APVD
			1		ORIGINAL	23APR2014	GH	GB
			A		RELEASED	01AUG2014	GH	GB

-	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	
-	1	1	1	1	1	1-1752354-2	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	
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	73	
-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	2	2-18032-2	SCR, SET, FLT POINT 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	
-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, 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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56	
-	2	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55	
-	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	2119792-1	PAWL, EF, AIR	51	
-	-	-	-	-	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	1-2119644-2	RAM WASHER, PRECISION	38	
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
-	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	1320906-1	STUD, THREADED	25	
-	1	1	1	1	1	1752371-3	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1	1752373-4	DRAG	20	
-	2	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18	
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1	3-240641-1	SPACER	16	
-	1	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	1	1	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	-	10	
-	1	1	1	1	1	1-690482-8	PLATE, FRONT SHEAR	9	
-	1	1	1	1	1	4-1803001-5	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	-	-	-	6	
-	1	1	1	1	1	5-240641-0	SPACER	5	
-	1	1	1	1	1	1-238009-2	BLOCK, FL CRIMPER SPACER	4	
-	1	1	1	1	1	3-1803017-9	CRIMPER, INSULATION F	3	
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2	
-	1	1	1	1	1	3-456405-4	CRIMPER, WIRE PREMIUM	1	
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO	

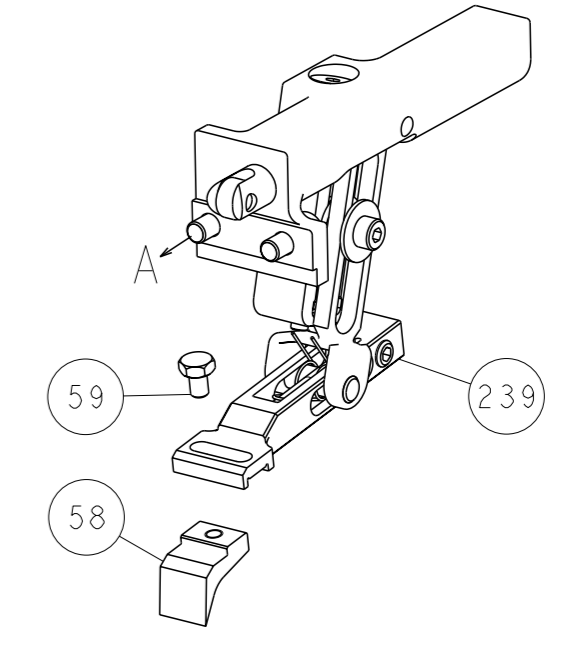
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5	5 PLC ±.5	6 PLC ±.5
	ANGLES ±.0001	FINISH		DATE	21APRIL2014	22APRIL2014	23APRIL2014
MATERIAL		WEIGHT		APPROVED	G. BAILEY	G. BAILEY	G. BAILEY
		SCALE	1:1	NAME	Ocean End Feed Applicator		
		SHEET	1 of 4	SIZE	A		
		REV	A	CAGE CODE	00779		
		DRAWING NO	2150433	RESTRICTED TO	Customer Accessible Production Drawing		

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

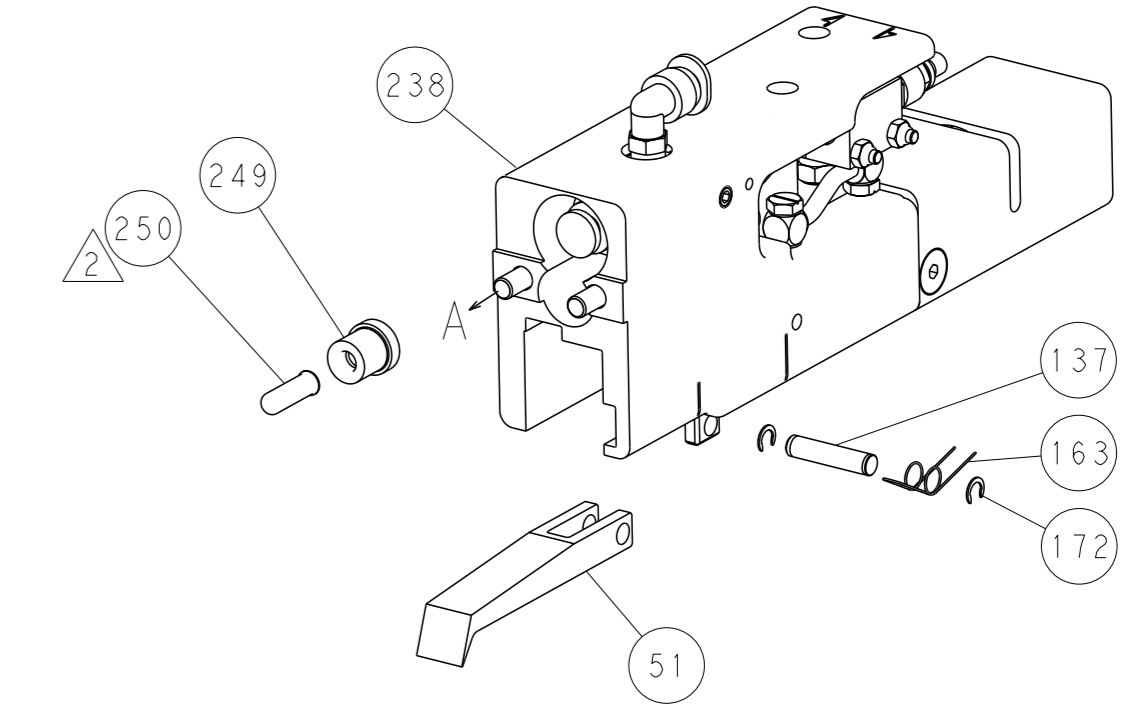


HOLDDOWN SET-UP

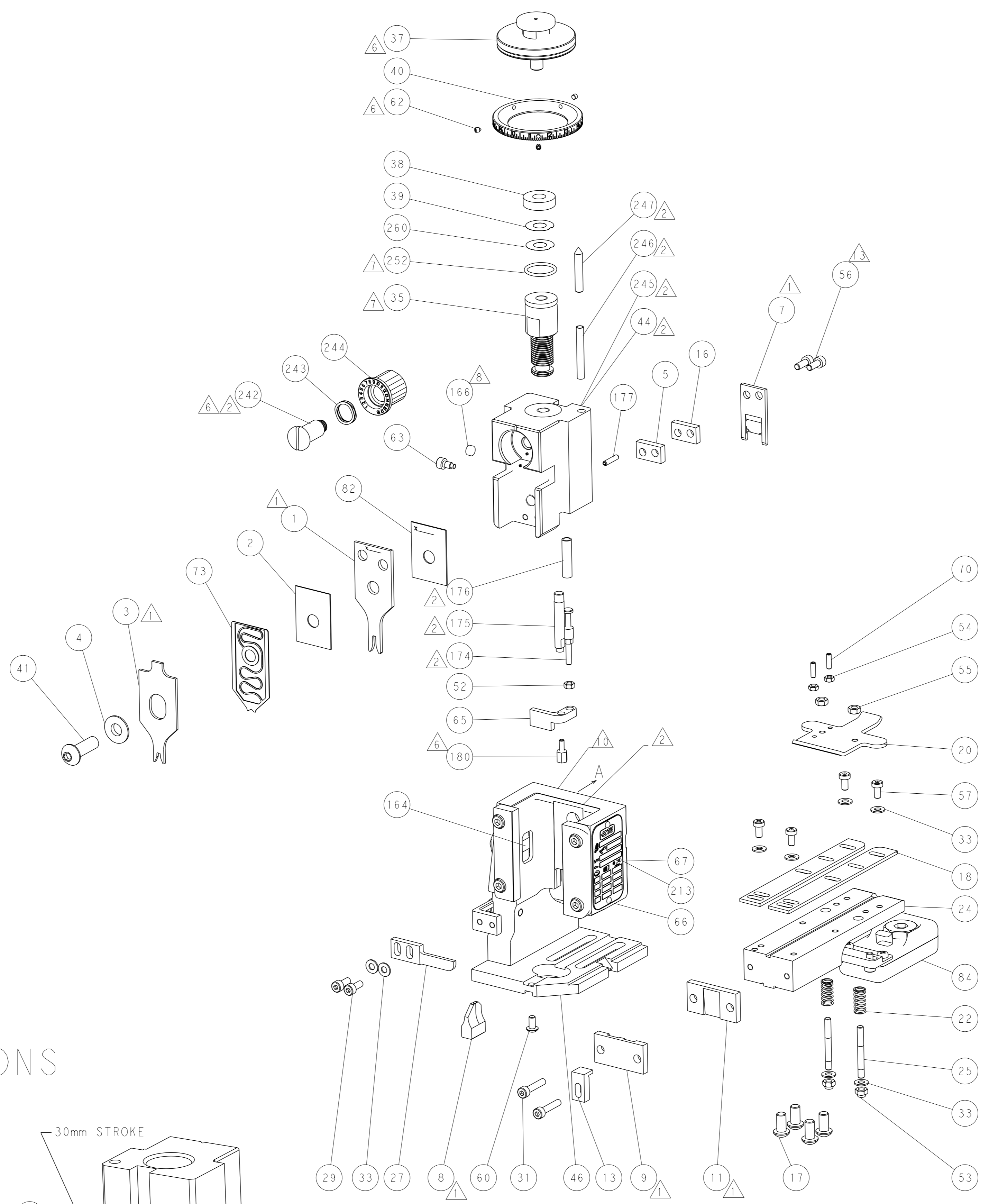
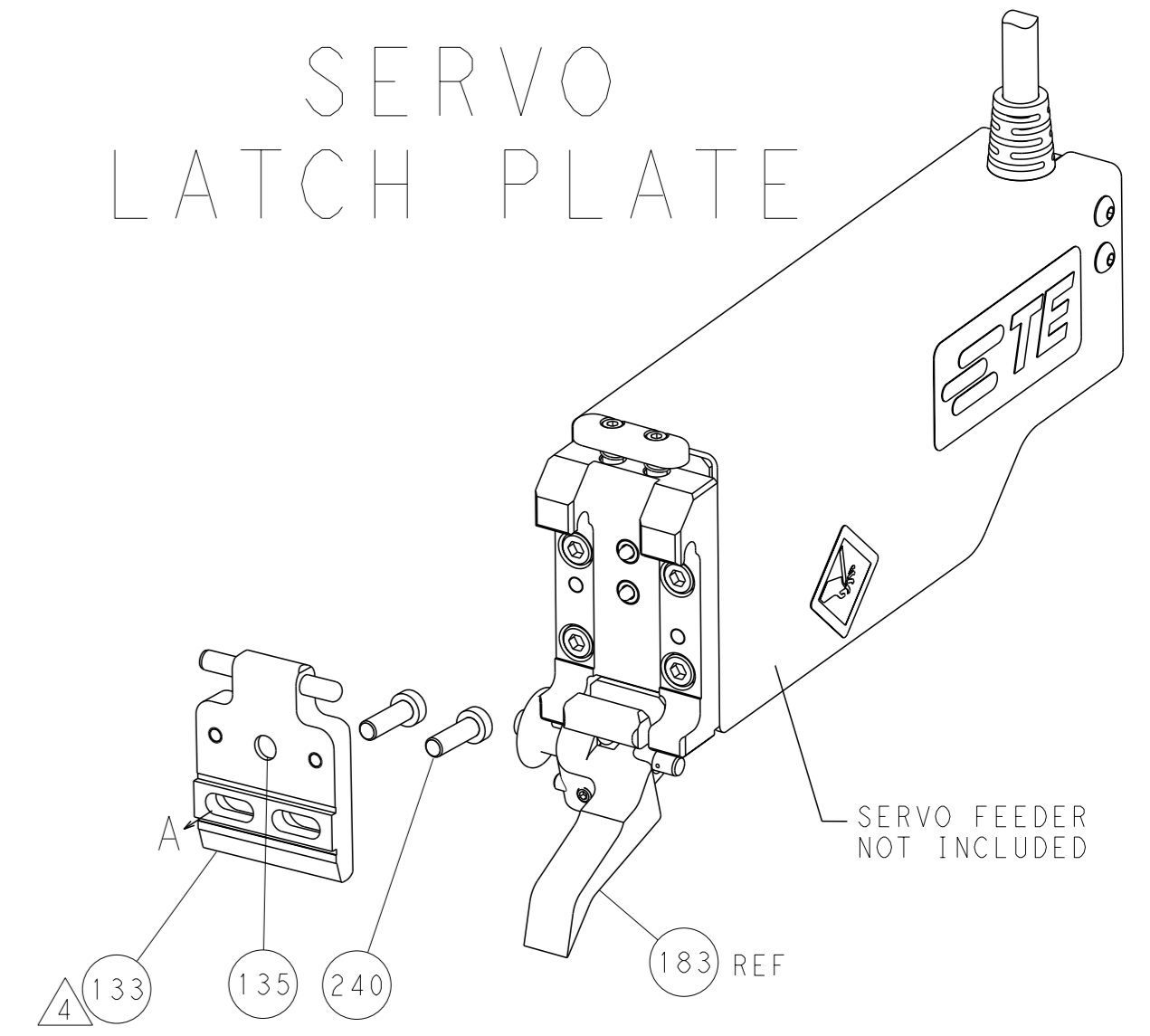
FEED TYPE
MECHANICAL



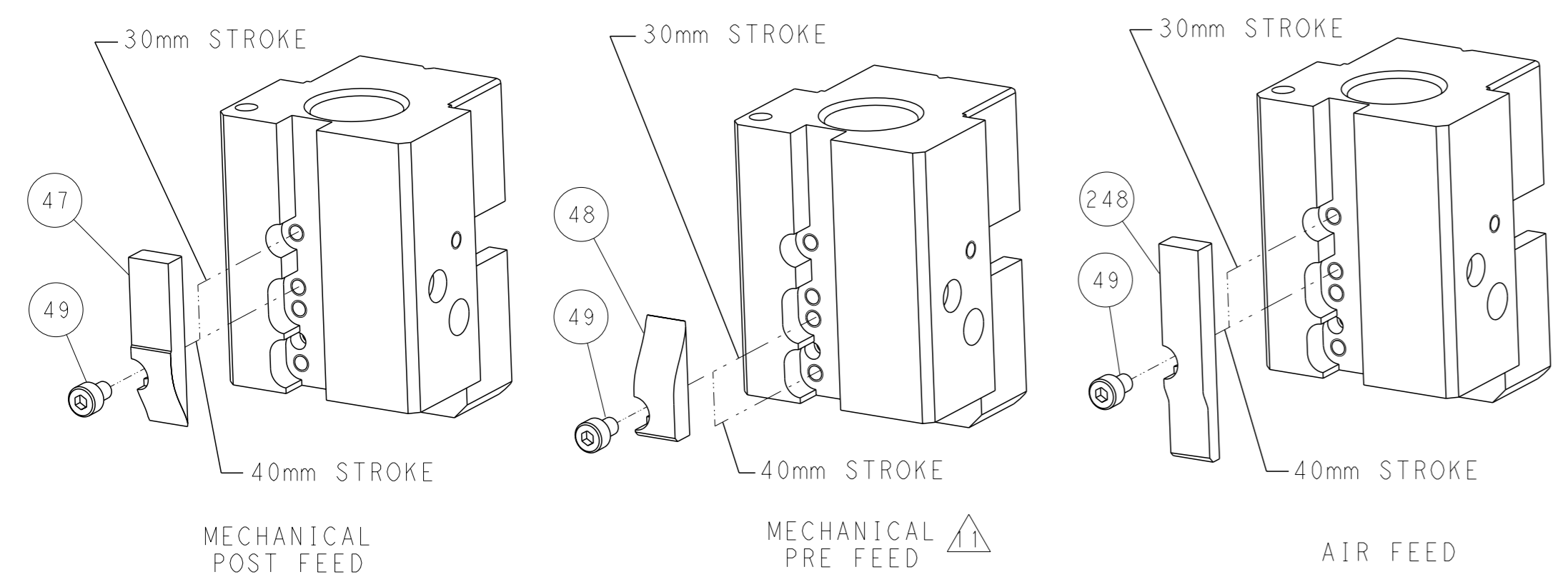
PNEUMATIC



SERVO
LATCH PLATE



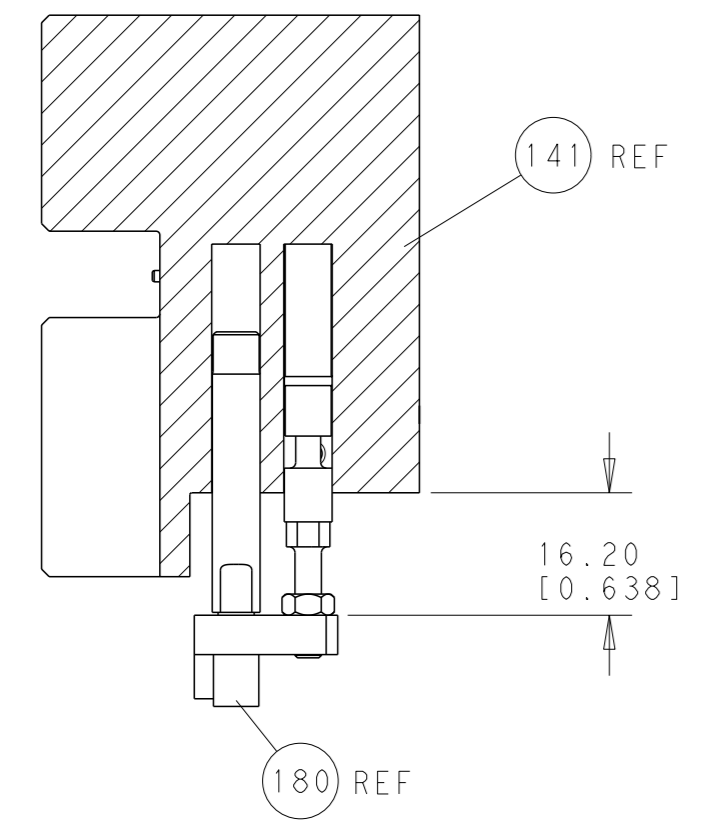
CAM POSITIONS



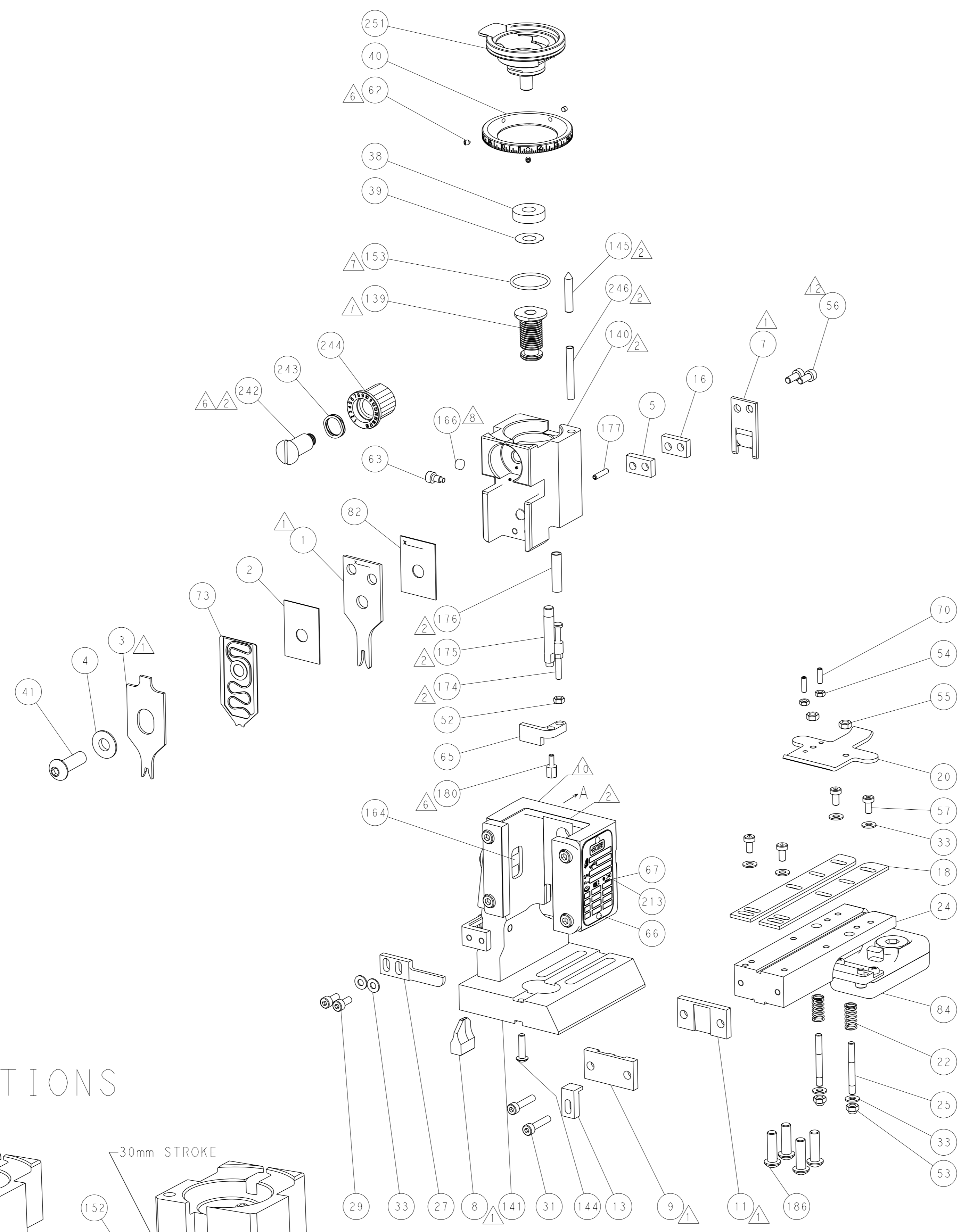
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: HOFFNER 21APRIL2014 CHK: G. BAILEY 22APRIL2014 APVD: G. BAILEY 23APRIL2014 PRODUCT SPEC	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150433	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: A
MATERIAL: - FINISH: -		WEIGHT: - APPLICATION SPEC: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

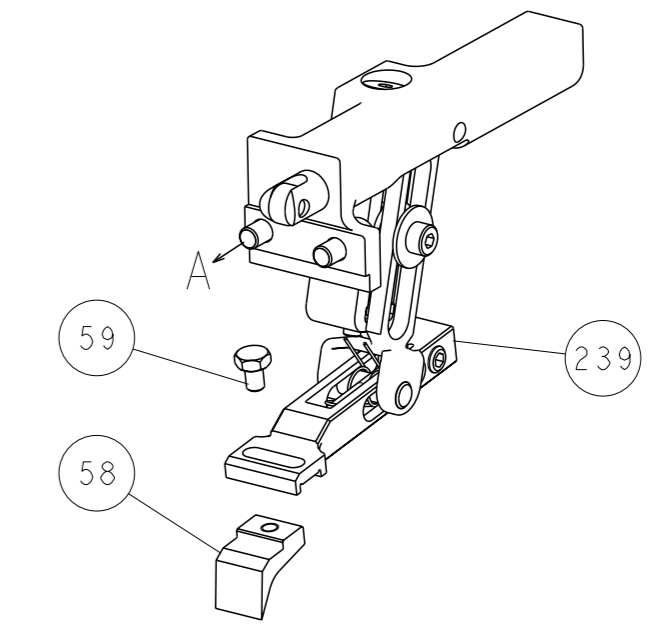
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



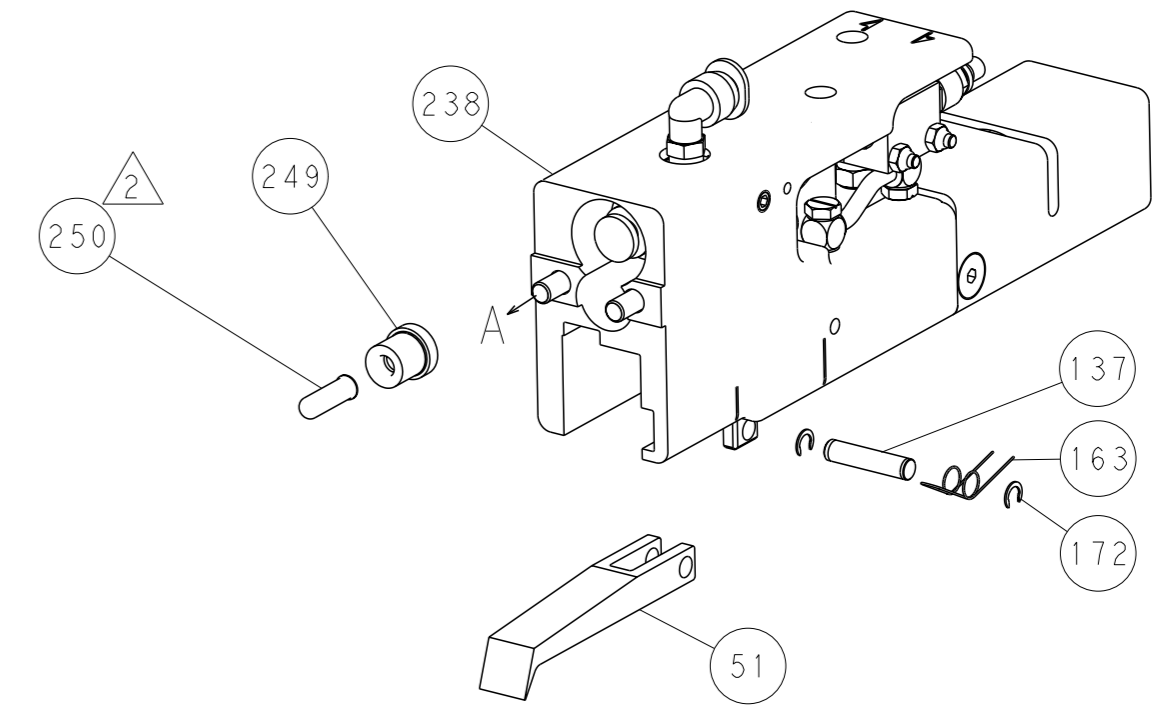
HOLDDOWN SET-UP



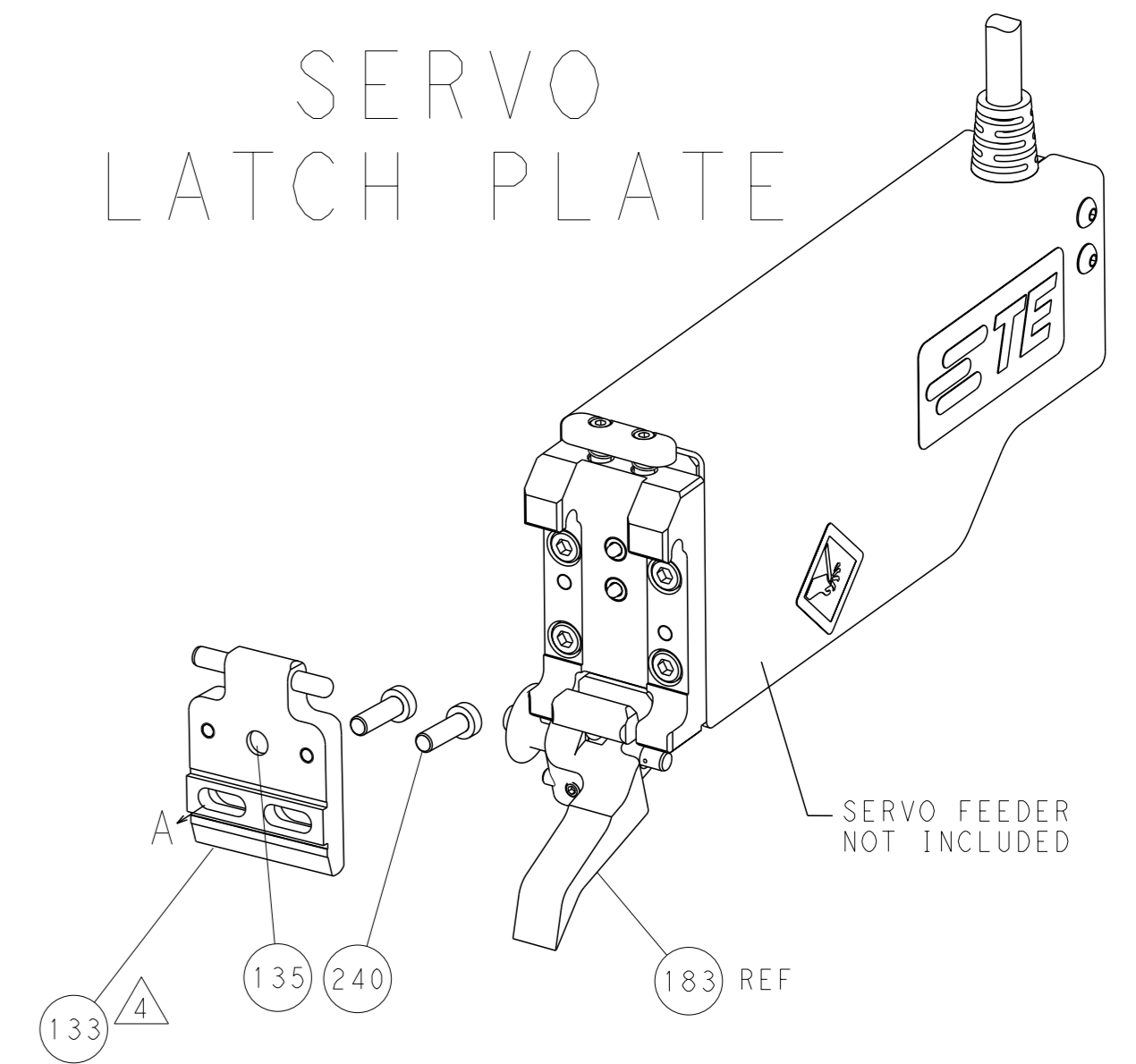
FEED TYPE
MECHANICAL



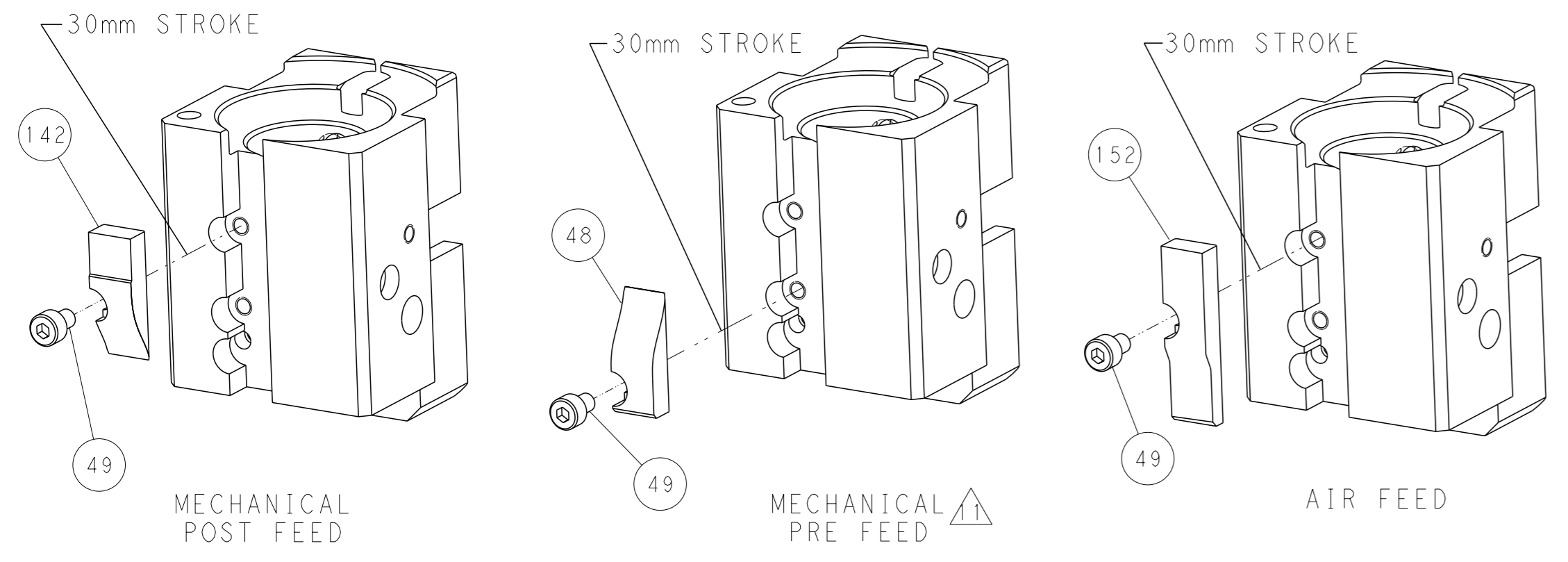
PNEUMATIC



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0013 ANGLES FINISH: *		APPLICATION SPEC: - WEIGHT: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION