

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2150270-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	-
	2150270-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150270-5	-	-	2168400-7 (QUANTITY 2)
	2150270-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ¹¹	SMART APPLICATOR	2161326-1	-	8-2150270-4	-	-	-
	2150270-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-2
	7-2150270-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.60 mm [.142]	OV
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: G&H TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.30 mm [.224-.248 IN]		Ø1.50-3.30 mm [.059-.130 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1572524-4	25201.XXX.YYY	1-1572631-2	25205.XXX.YYY
1572524-3	25203.XXX.YYY		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.95+/-0.05 [.077+/-0.002]	7.8
0.75mm2	1.85+/-0.05 [.073+/-0.002]	9.0
0.50mm2	1.75+/-0.05 [.069+/-0.002]	10.0

- 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: 8-2150270-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150270-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150270-6
- 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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
- 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

***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.

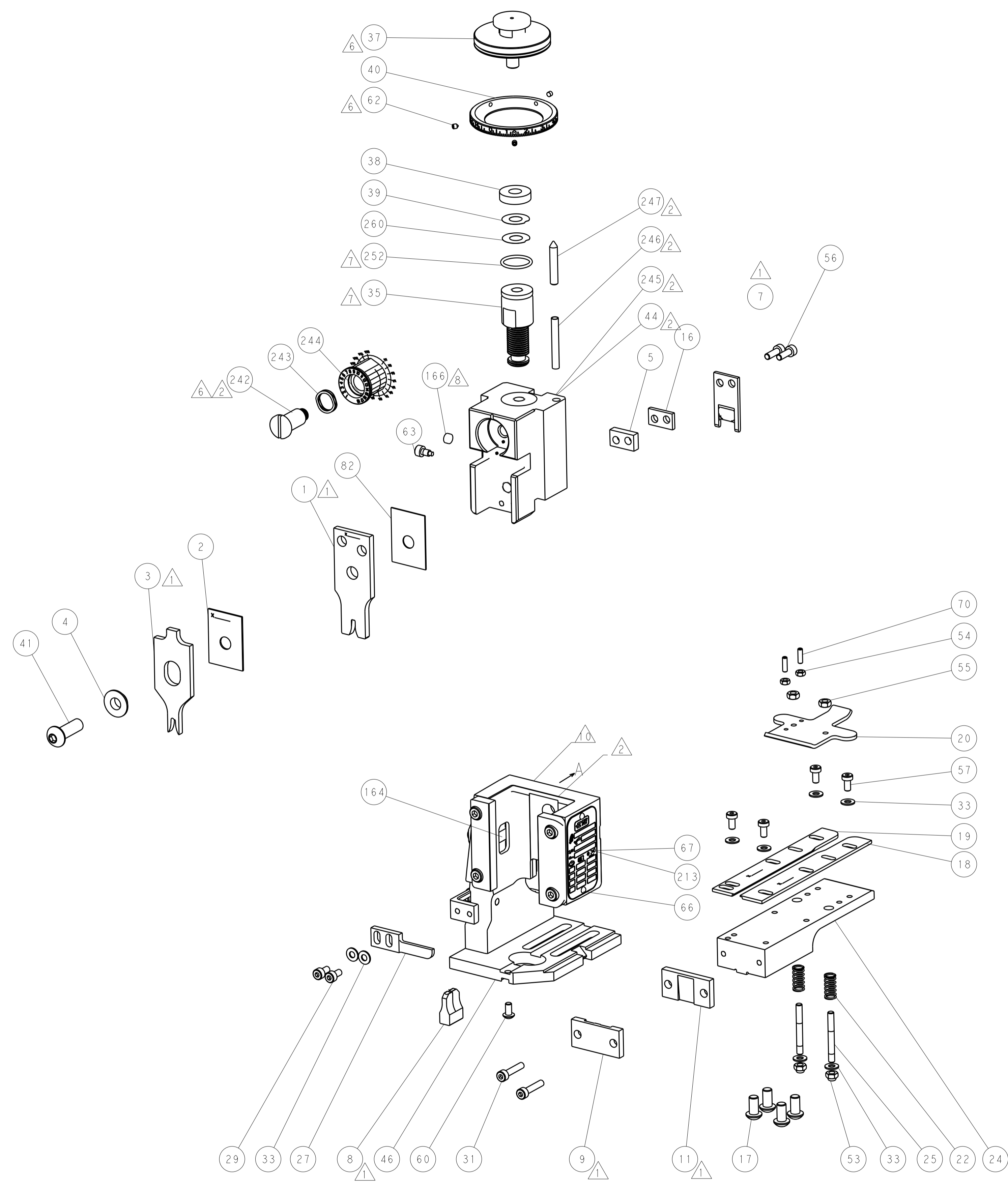
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			1		DEVELOPMENT	03JAN2014	YY	UG
			A		RELEASED	25FEB2014	YY	UG

-	-	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	
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
-	-	-	-	1	2063440-2	AIR FEED MODULE	238	
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213	
-	-	REF	REF	-	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163	
-	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	REF	REF	-	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	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	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2119792-2	PAWL, EF, AIR	51	
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	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	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	1901696-3	STRIP GUIDE, REAR	19	
-	1	1	1	1	1901695-3	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240641-2	SPACER	16	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9	
-	1	1	1	1	4-1803000-1	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	1-2217206-3	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-240641-9	SPACER	5	
-	1	1	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER	4	
-	1	1	1	1	1803139-1	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	1	455888-8	SPACER, CRIMPER	2	
-	1	1	1	1	1-1633609-1	CRIMPER, WIRE	1	
-	77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

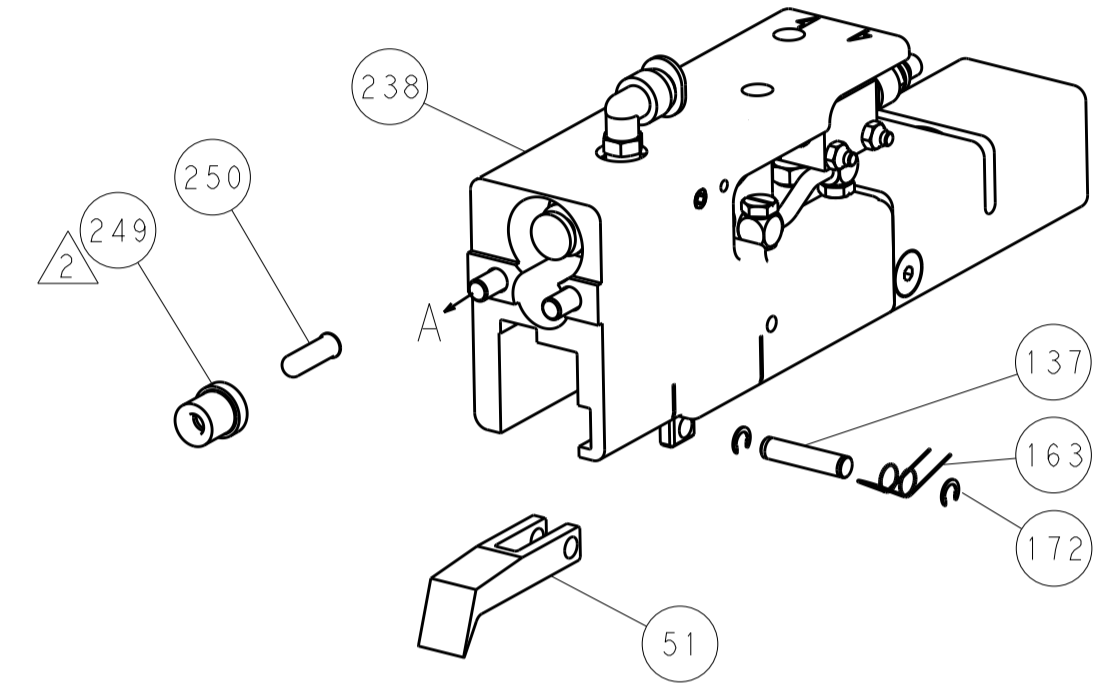
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0001	Y. YIN	03JAN2014	G. BAILEY	03JAN2014	U. GUO	03JAN2014
		FINISH		MATERIAL		WEIGHT		SCALE		SHEET	
						A1 00779		C=2150270		1 OF 4	

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

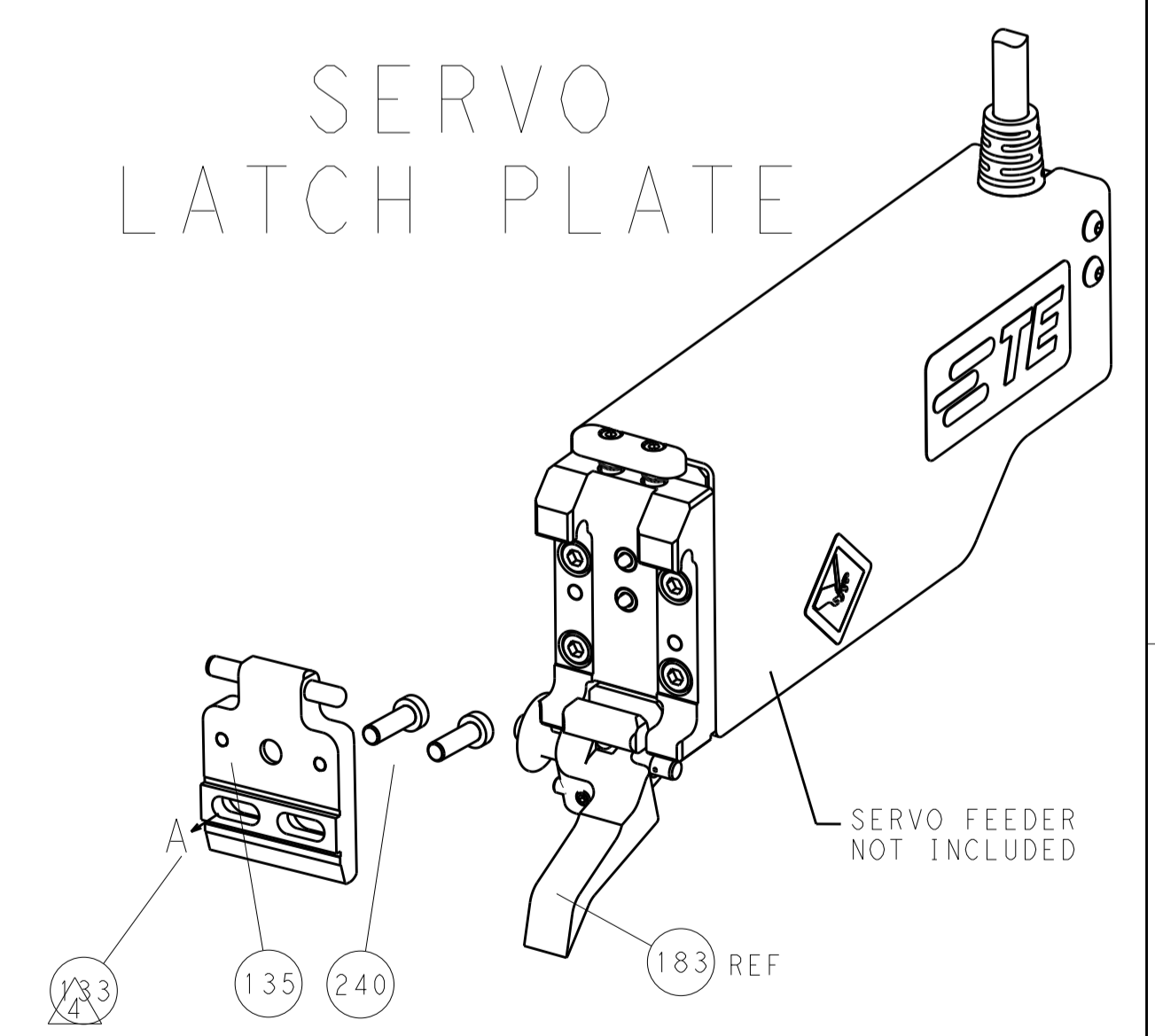


FEED TYPE

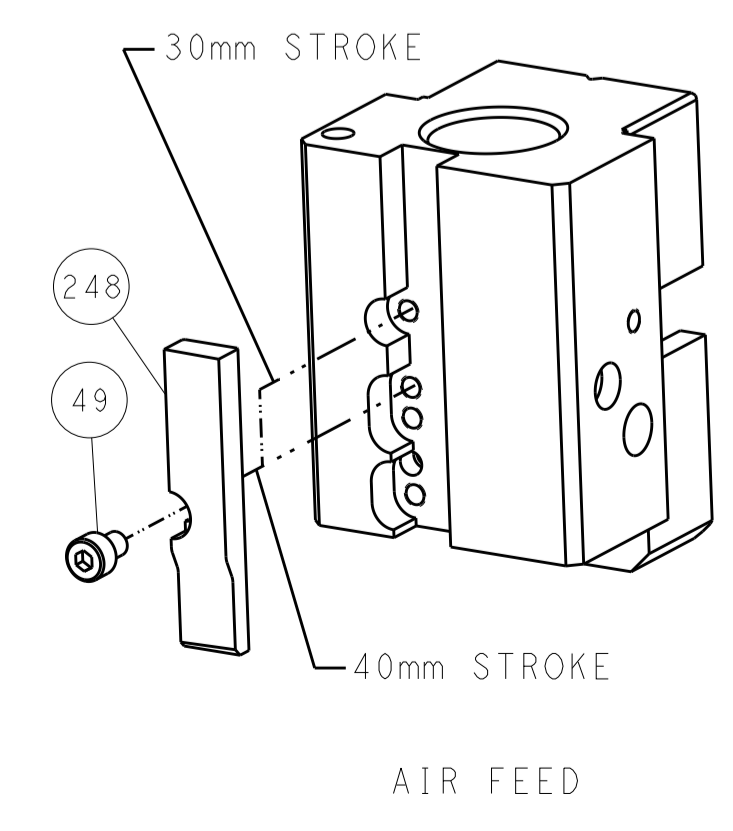
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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:		DWG: Y. YIN 03JAN2014		TE Connectivity	
mm		0 PLC ±0.5		CHK: G. BAILEY 03JAN2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APVD: H. GUO 03JAN2014		NAME: Ocean End Feed Applicator	
FINISH:		2 PLC ±0.013		PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
MATERIAL:		3 PLC ±0.001		APPLICATION SPEC:		RESTRICTED TO:	
		4 PLC ±0.0001		WEIGHT:		A11 00779 ©=2150270	
		ANGLES ±0.0001		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV A	

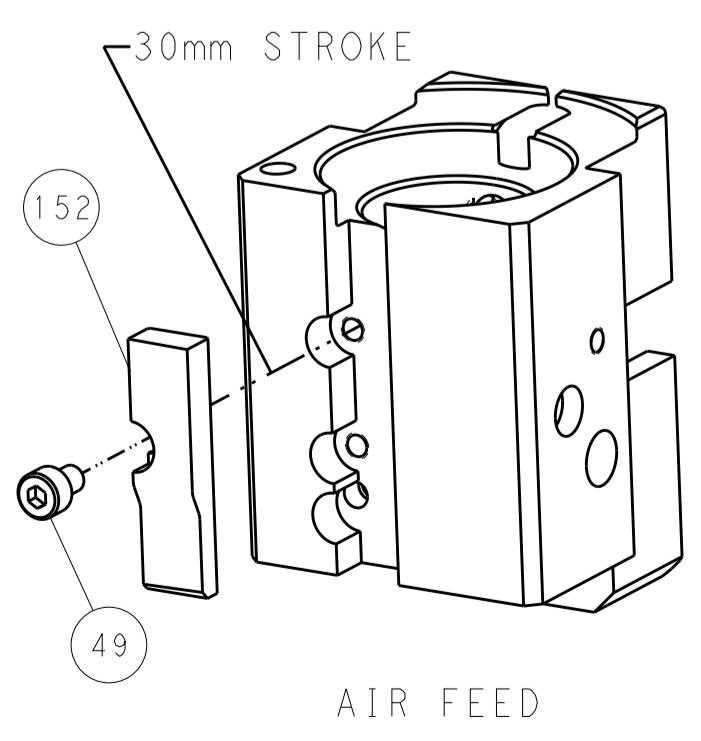
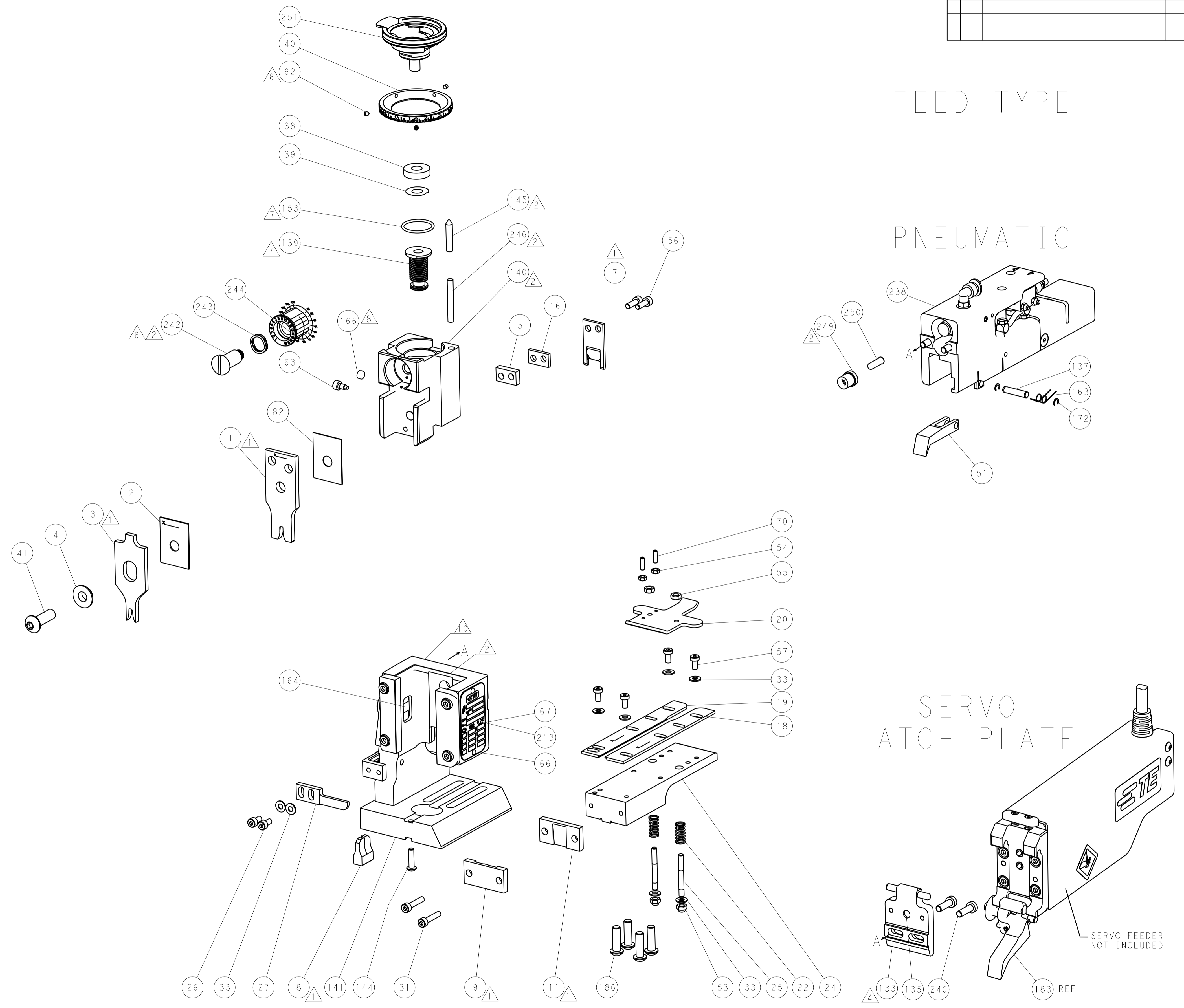
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

SERVO LATCH PLATE

CAM POSITION



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 ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.0001	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:1	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150270 SHEET 4 OF 4 REV A	RESTRICTED TO: Customer Accessible Production Drawing