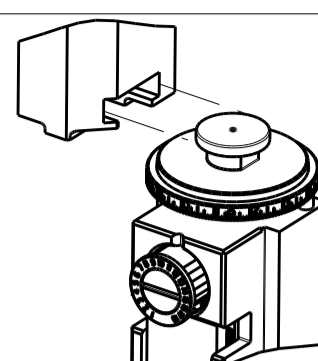
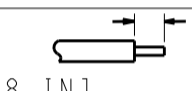


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150278-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-2	8-2150278-5	-	-	2168400-7 (QUANTITY 2)
	2150278-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	SMART APPLICATOR	2161326-1	-	8-2150278-4	-	-	-
	2150278-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1
	2150278-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150278-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.11 mm [ .201 ]	D
INSUL	-	-
APPL INSTRUCTIONS 408-10390		

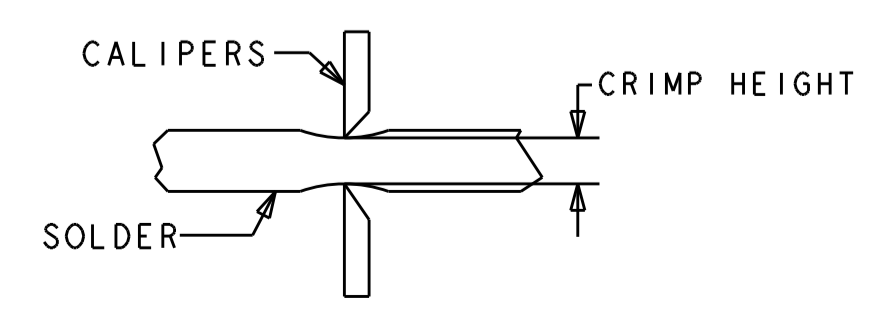
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT, ULTRA-FAST FLAG, .187 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.51-8.33 mm [ .296-.328 IN ]		∅.00-4.19 mm [ .000-.165 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED <sup>9</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520334-2	9-520334-2	5-520336-2	
5-520334-2	2-520336-2	9-520336-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
18 OR (2) 22	1.79+/-0.05 [ .070+/- .002 ]	5.0	.19 in [ 4.83mm ]
22 OR 20	1.65+/-0.05 [ .065+/- .002 ]	6.5	.19 in [ 4.83mm ]

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150278-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150278-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150278-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>7</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>8</sup> 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.
- <sup>9</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>10</sup> 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
- <sup>11</sup> TO CHECK CRIMP HEIGHT. CRIMP SOLDER (∅.19 IN [ 4.83mm ] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.

<sup>12</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62

**\*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	REV	DATE	BY	APPV
			A1	ECR-13-004890	19MAR2013	XZ TE
			A2	ECR-16-017369	08DEC2016	RS LZ

-	-	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
-	-	2	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	2119644-6	RAM WASHER, PRECISION	221
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	1	1	1	1	467281-1	RETAINER, SHEAR, FLOATING	207
-	1	1	1	1	2161936-1	HOLDER, SHEAR, FLOATING	206
-	1	1	1	1	467500-1	SHEAR, FLOATING	205
-	-	REFREF	-	-	1901697-2	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
-	REFREF	REFREF	REFREF	-	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	2161937-2	STABILIZER	154
-	-	-	-	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	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	1	1	1	1	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	1	1	1	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	69
-	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
-	3	3	3	3	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	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	2161952-1	PAWL, EF, AIR	51
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	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	2119644-7	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	2	2	2	2	5-22278-1	SPRING, COMPRESSION	36
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	31
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	690455-3	STRIPPER, FRONT CASTING	27
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1	2161941-1	PLATE, GUIDE, STRIP	24
-	2	2	2	2	2-22280-7	SPRING, COMPRESSION	22
-	1	1	1	1	2161948-1	DRAG	20
-	1	1	1	1	683736-1	GUIDE, STRIP, REAR	19
-	1	1	1	1	683737-1	FRONT STRIP GUIDE	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	4-22280-7	SPRING, COMPRESSION	13
-	1	1	1	1	2161935-4	ANVIL, RIGHT HAND	8
-	1	1	1	1	2161957-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
-	1	1	1	1	467342-3	CRIMPER, RIGHT HAND	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1	

OWN	HOFFNER	11APRIL2012	 TE Connectivity Harrisburg, PA 17105-3608			
CHK	T. ELBIN	12APRIL2012				
APPV	T. ELBIN	12APRIL2012				
NAME	Ocean End Feed Applicator					
PRODUCT SPEC	APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Customer Accessible Production Drawing			A1	00779	∅=2150278	REV A2



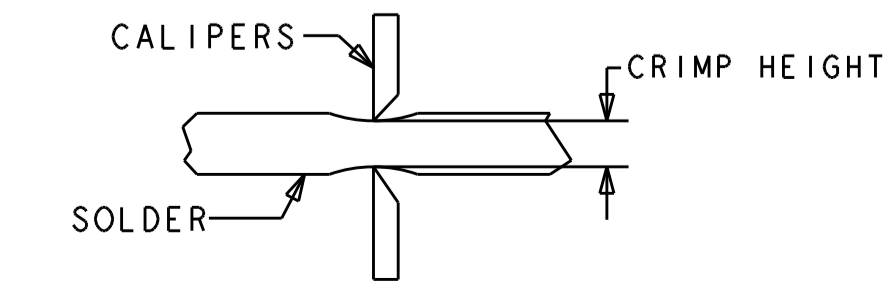
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150278-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-2	8-2150278-5	-	-	2168400-7 (QUANTITY 2)
	2-2150278-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\Delta$ 4	SMART APPLICATOR	2161326-1	-	8-2150278-4	-	-	-
	2-2150278-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
	7-2150278-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
INSUL	5.11 mm [ .201 ]	D
APPL INSTRUCTIONS	408-10390	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT, ULTRA-FAST FLAG, .187 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.51-8.33 mm [ .296-.328 IN ]		$\varnothing$ 0.00-4.19 mm [ .000-.165 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-2123		
TERMINALS APPLIED $\Delta$ 9			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520334-2	9-520334-2	5-520336-2	
5-520334-2	2-520336-2	9-520336-2	

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING $\Delta$ 8	$\varnothing$ SOLDER $\Delta$ 10
18 OR (2) 22	1.79+/-0.05 [ .070+/- .002 ]	5.0	.19 in [ 4.83mm ]
22 OR 20	1.65+/-0.05 [ .065+/- .002 ]	6.5	.19 in [ 4.83mm ]

- $\Delta$ 1 RECOMMENDED SPARE PARTS
- $\Delta$ 2 GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- $\Delta$ 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150278-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150278-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- $\Delta$ 6 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- $\Delta$ 7 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- $\Delta$ 8 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.
- $\Delta$ 9 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- $\Delta$ 10 TO CHECK CRIMP HEIGHT, CRIMP SOLDER ( $\varnothing$ .19 IN [ 4.83mm ] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



**\*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.

**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	APPD
			-	SEE SHEET 1	-	-

-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	1	2063440-1	AIR FEED MODULE	238
-	1	1	1	2119644-6	RAM WASHER, PRECISION	221
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
-	1	1	1	467281-1	RETAINER, SHEAR, FLOATING	207
-	1	1	1	2161936-1	HOLDER, SHEAR, FLOATING	206
-	1	1	1	467500-1	SHEAR, FLOATING	205
-	4	4	4	2079383-4	SCR, BHSC, RoHS (M4 X 8)	186
-	-	REF	-	1901697-2	FEED FINGER ASSEMBLY, EF	183
-	-	-	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	2161937-2	STABILIZER	154
-	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	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	455888-6	SPACER, CRIMPER	82
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	1	1	1	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	1	1	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	69
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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
-	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	1	2161952-1	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	2119644-7	RAM WASHER, PRECISION	38
-	2	2	2	5-22278-1	SPRING, COMPRESSION	36
-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	31
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	690455-3	STRIPPER, FRONT CASTING	27
-	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	2161941-1	PLATE, GUIDE, STRIP	24
-	2	2	2	2-22280-7	SPRING, COMPRESSION	22
-	1	1	1	2161948-1	DRAG	20
-	1	1	1	683736-1	GUIDE, STRIP, REAR	19
-	1	1	1	683737-1	FRONT STRIP GUIDE	18
-	1	1	1	4-22280-7	SPRING, COMPRESSION	13
-	1	1	1	2161935-4	ANVIL, RIGHT HAND	8
-	1	1	1	2161957-1	DEPRESSOR, SHEAR	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
-	1	1	1	467342-3	CRIMPER, RIGHT HAND	1

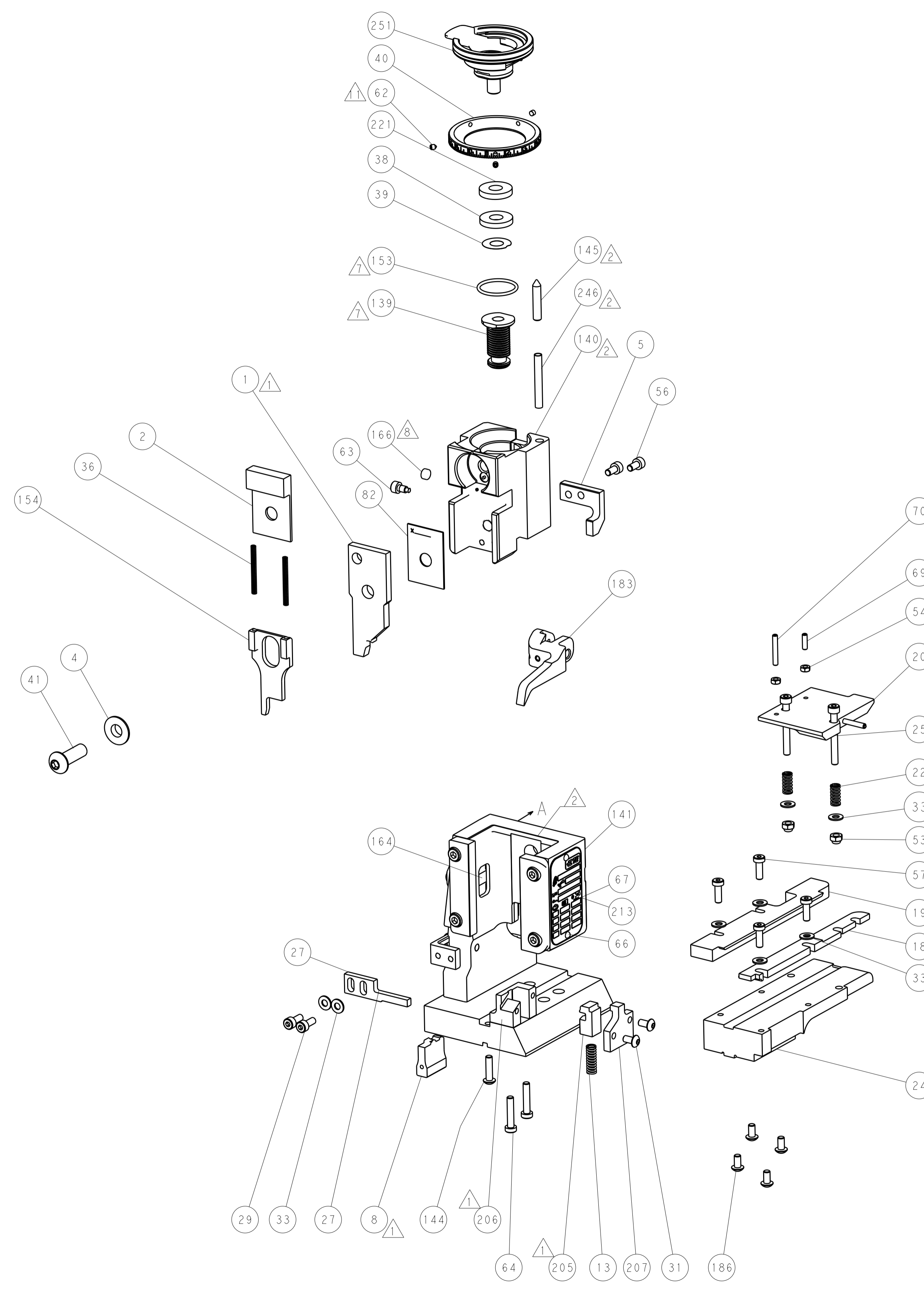
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC	±									
	1 PLC	±									
	2 PLC	±									
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									

LOC	DIST	REV	DATE	BY	APPV
A	66				

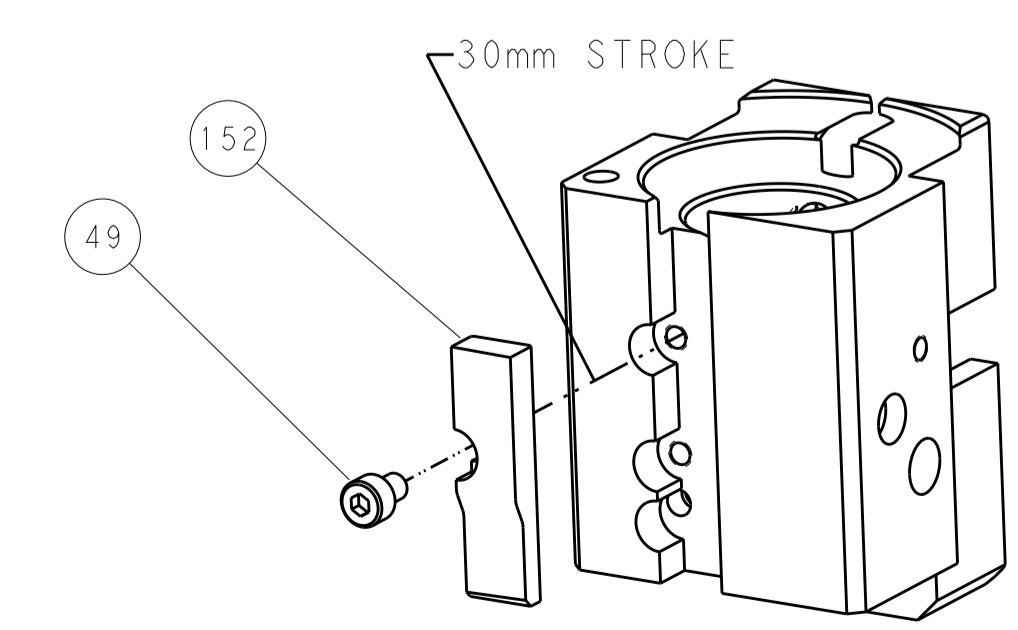
### FEED TYPE

### PNEUMATIC

### SERVO LATCH PLATE



### CAM POSITION



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN: HOFFNER 11APRIL2012 CHK: T. ELBIN 12APRIL2012 APVD: T. ELBIN 12APRIL2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150278 SCALE: 1:1 SHEET: 4 OF 4 REV: A2	
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