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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150182-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150182-5	-	-	2168400-7 (QUANTITY 2)
	2150182-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150182-5	-	-	2168400-7 (QUANTITY 2)
	2150182-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
	2150182-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
	2150182-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150182-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.29 mm [.090]	F
APPLICATION INSTRUCTIONS		
408-10390		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: .110 SER.FASTON REC.			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.90-4.70 mm [.154-.185 IN]	Ø1.30-2.00 mm [.051-.079 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)114-3118	-	-
	(B)114-20109	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 160724-1	(B) 5-160303-1	(B) 6-160303-2	(A)160366-1
(A) 160724-2	(B) 5-160303-2	(B) 6-160303-4	(A)160366-2
(B) 5-160315-2	(B) 5-160303-3	(B) 5-160316-1	(A)160366-4
(A) 881505-1	(B) 5-160303-6	(B) 5-160316-2	(A)160366-6
(A) 881505-5	(B) 5-160303-7	(B) 5-160316-3	(A) 881504-1
	(B) 5-160303-9	(B) 6-160316-4	(A) 881504-5

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: .110 SER.FASTON REC.			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.90-4.70 mm [.154-.185 IN]	Ø1.30-2.00 mm [.051-.079 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)114-3118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 160173-1	(A) 160173-2	(A) 160173-4	(A) 160173-6
(A) 160173-7			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.09+/-0.05 [.043+/- .002]	5.2
0.40mm2	0.97+/-0.05 [.038+/- .002]	6.3
0.30mm2	0.91+/-0.05 [.036+/- .002]	7.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.09+/-0.05 [.043+/- .002]	5.2
0.40mm2	0.97+/-0.05 [.038+/- .002]	6.3
0.35mm2	0.94+/-0.05 [.037+/- .002]	6.6
0.30mm2	0.91+/-0.05 [.036+/- .002]	7.0

- 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. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150182-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150182-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150182-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150182-6
- 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 50,62
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
 FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.
- 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.

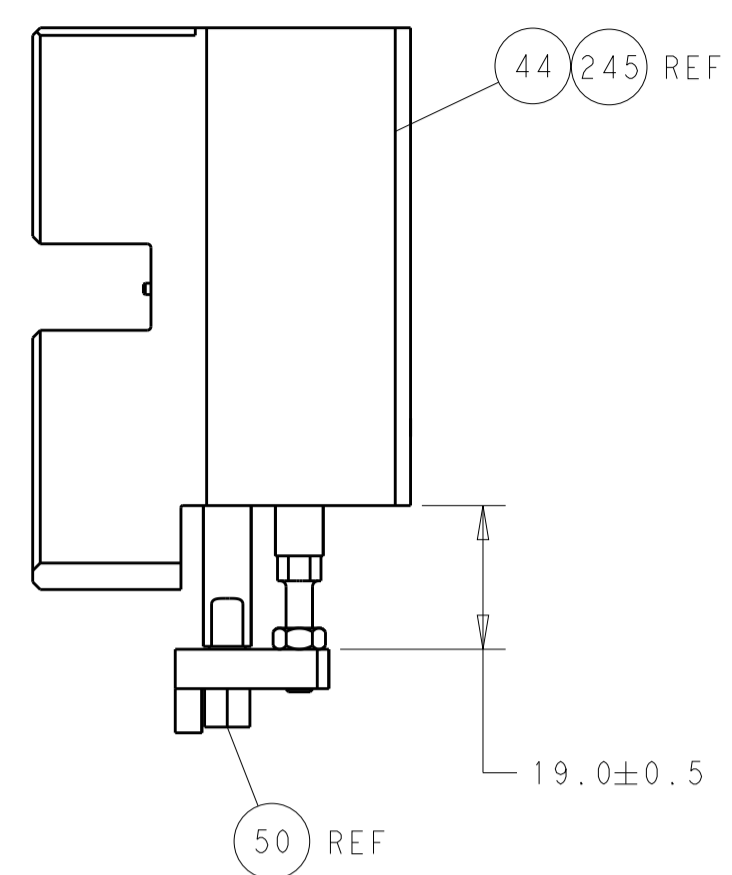
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260										
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252										
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250										
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249										
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248										
-	1	-	1	1	1	2119798-1	DETENT PIN	247										
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246										
-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	#	LTN	DESCRIPTION	DATE	OWN	APPD
			B2		ECR-14-018112	04DEC2014	KH	JT
			C		ECR-16-017466	09DEC2016	KH	CT

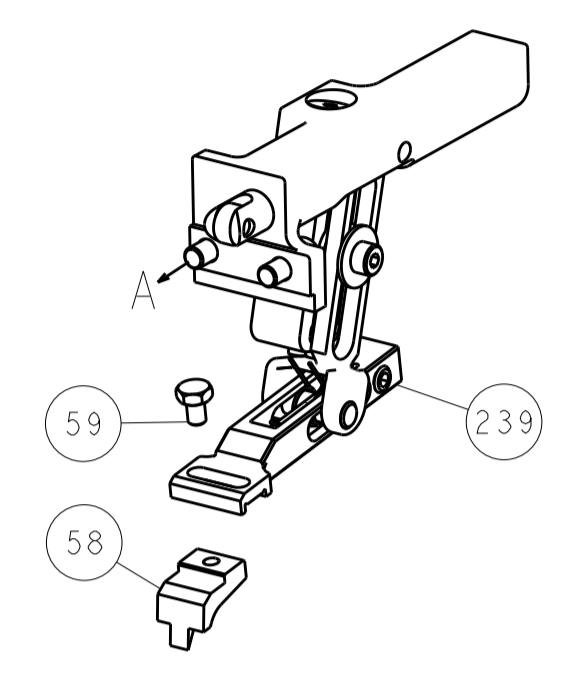
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245										
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244										
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243										
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242										
-	-	2	2	-	-	2168400-7	SHCS, 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	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	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	455888-9	SPACER, CRIMPER	82										
-	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	1901681-5	HOLDDOWN, TERMINAL	65										
-	2	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64										
-	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										
-	3	3	3	3	3	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	2119792-2	PAWL, EF, AIR	51										
-	1	1	1	1	1	1752354-5	STANDOFF, HOLD-DOWN	50										
-	-	-	-	-	1	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										
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35										
-	7	7	7	7	7	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	1752371-9	PLATE, STRIP GUIDE	24										
-	1	1	1	1														

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

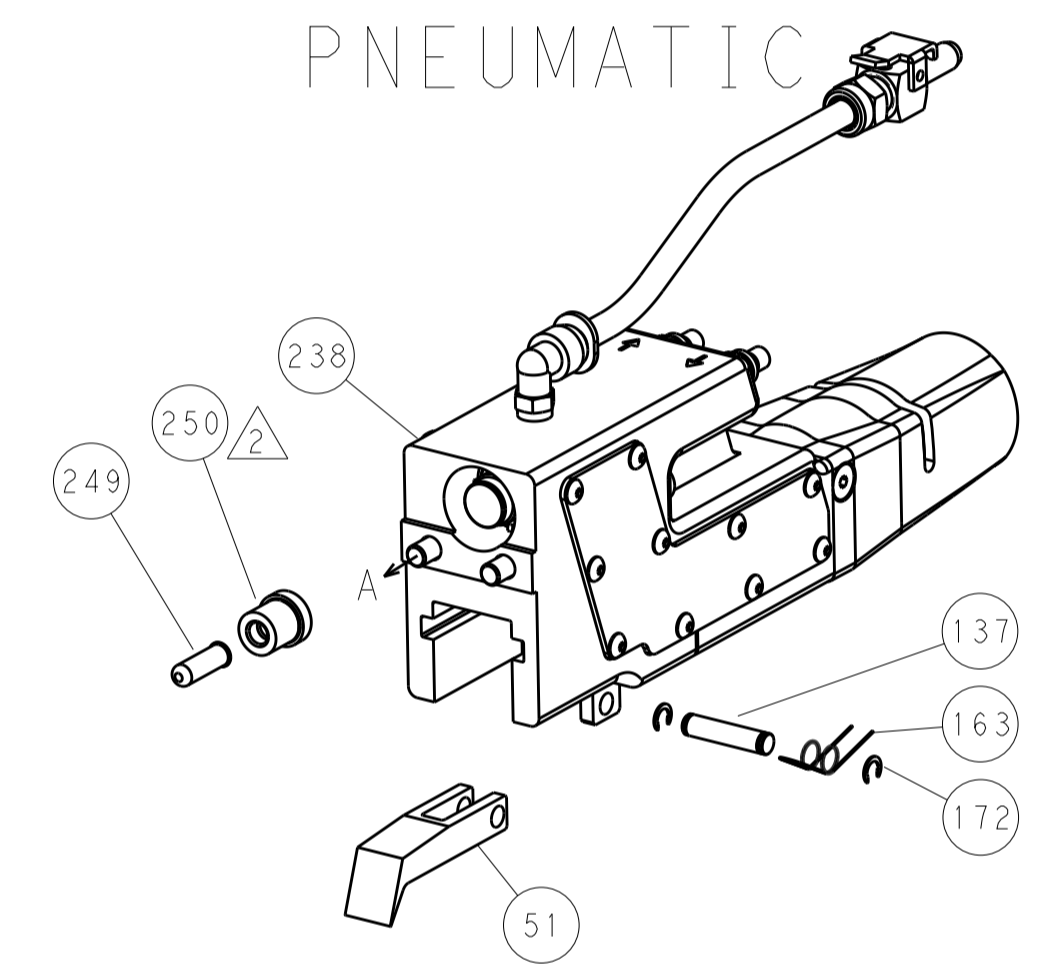


HOLDDOWN SET-UP

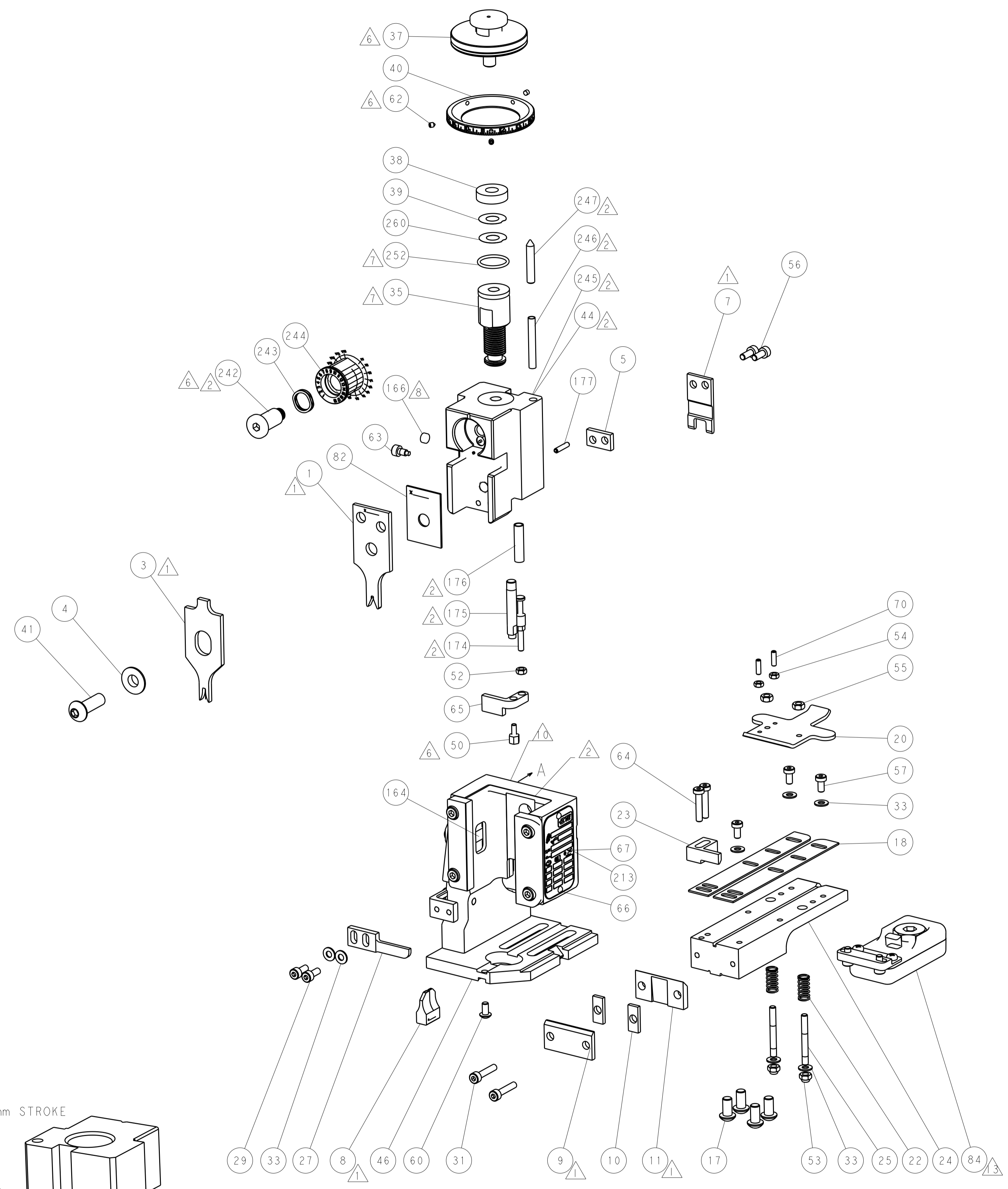
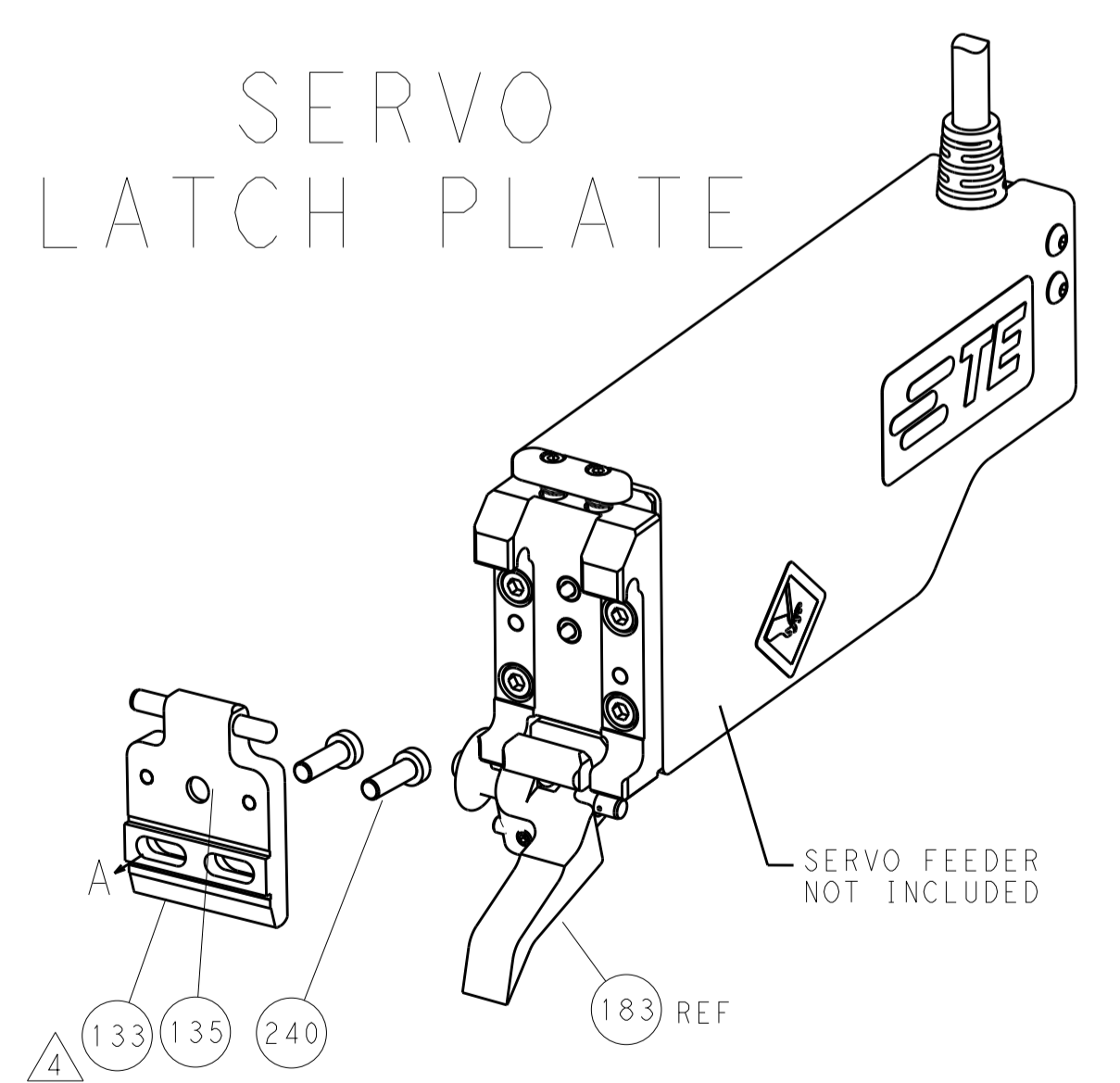
FEED TYPE
MECHANICAL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: K. HUANG 29FEB2012		TE Connectivity	
mm	0 PLC	±		CHK: S. XI 29FEB2012	NAME: Ocean End Feed Applicator		TE Connectivity Harrisburg, PA 17105-3608
	1 PLC	±		APVD: S. XI 29FEB2012	SIZE: A1		RESTRICTED TO
	2 PLC	±		PRODUCT SPEC	CAGE CODE: 00779		Customer Accessible Production Drawing
	3 PLC	±		APPLICATION SPEC	DRAWING NO: 2150182		SCALE: 1:1
	4 PLC	±		WEIGHT	SHEET 2 OF 4		REV C
MATERIAL:	FINISH:			Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED, FEED TYPE, DESCRIPTION, REVISION, PART NUMBER.

APPLICATOR DATA. Table with columns: CRIMP SIZE, WIRE SIZE, INSUL SIZE, APPLICATION INSTRUCTIONS.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Table with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Table with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

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- 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 50,62.
GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
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.
SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1.

*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.

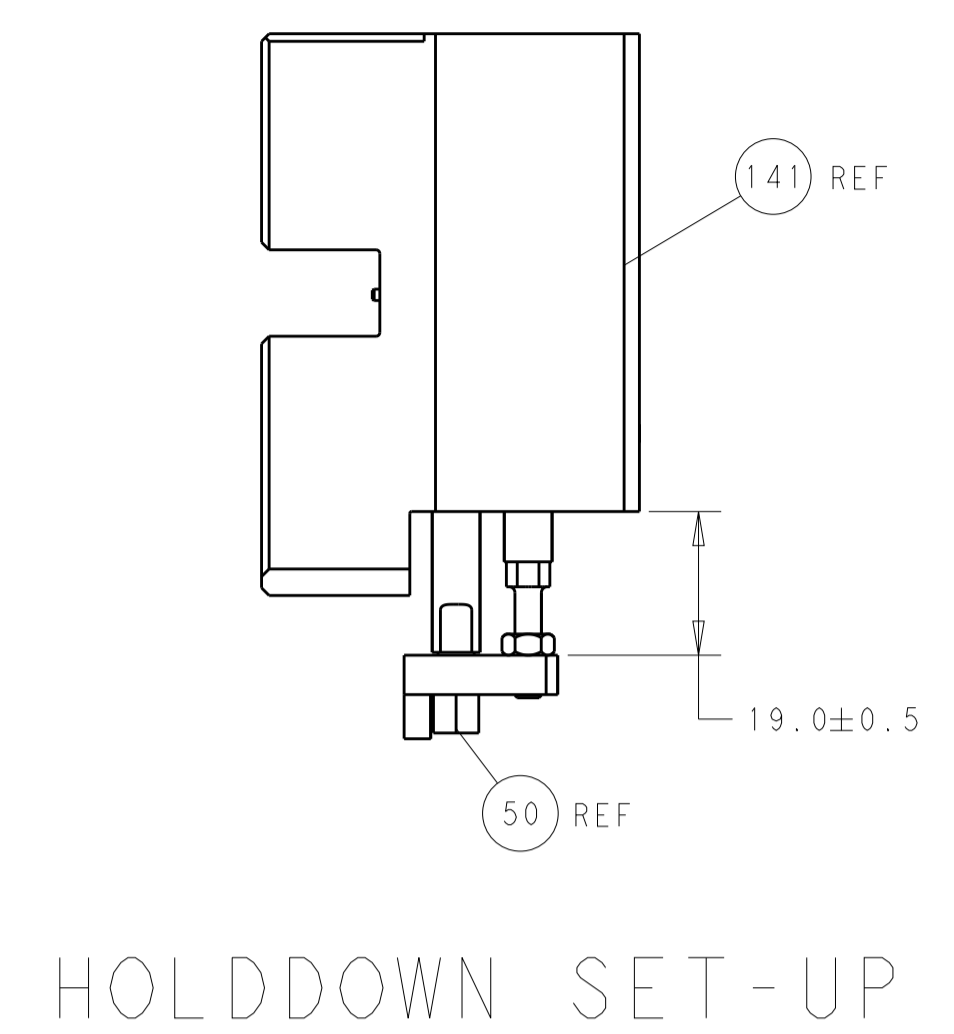
Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various parts like FINE ADJUST HEAD ASM, PUSH ROD, BUSHING, SPRING, CAM.

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

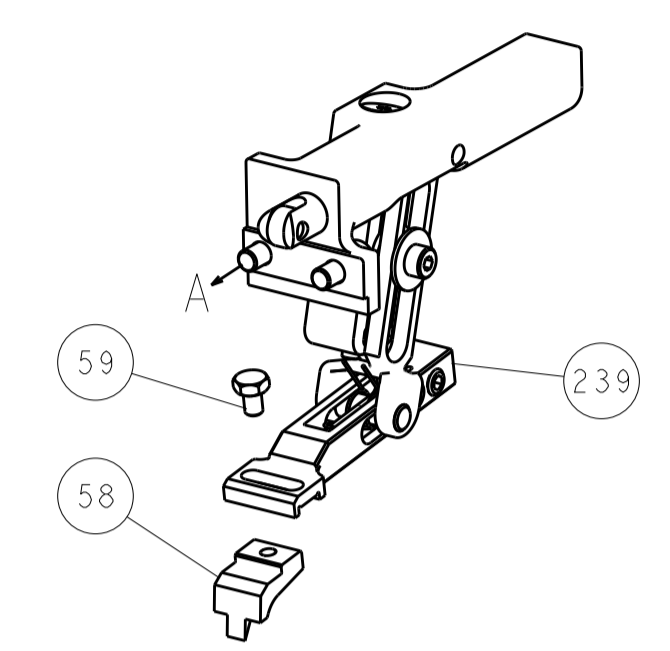
REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Lists numerous revisions and descriptions of parts.

Product information block including dimensions, tolerances, material, weight, and customer accessible production drawing details.

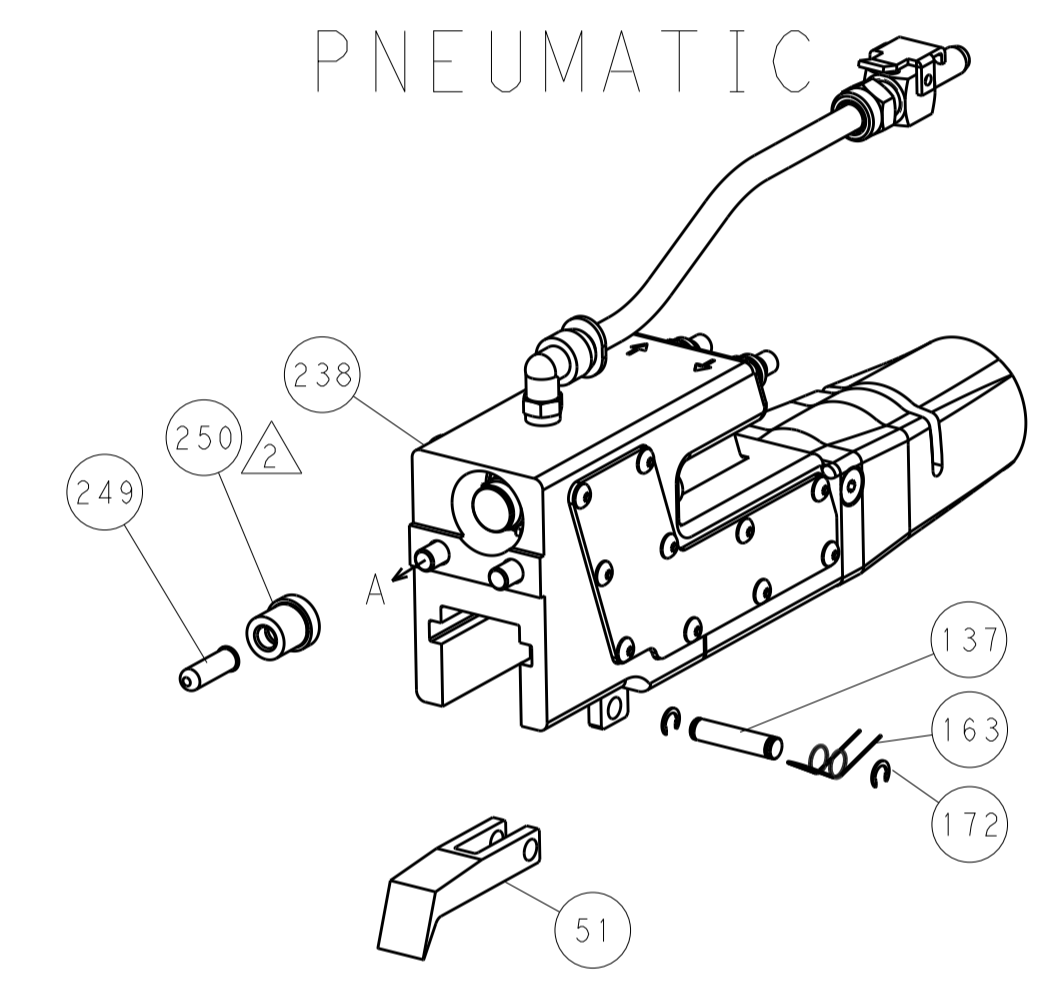
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1			



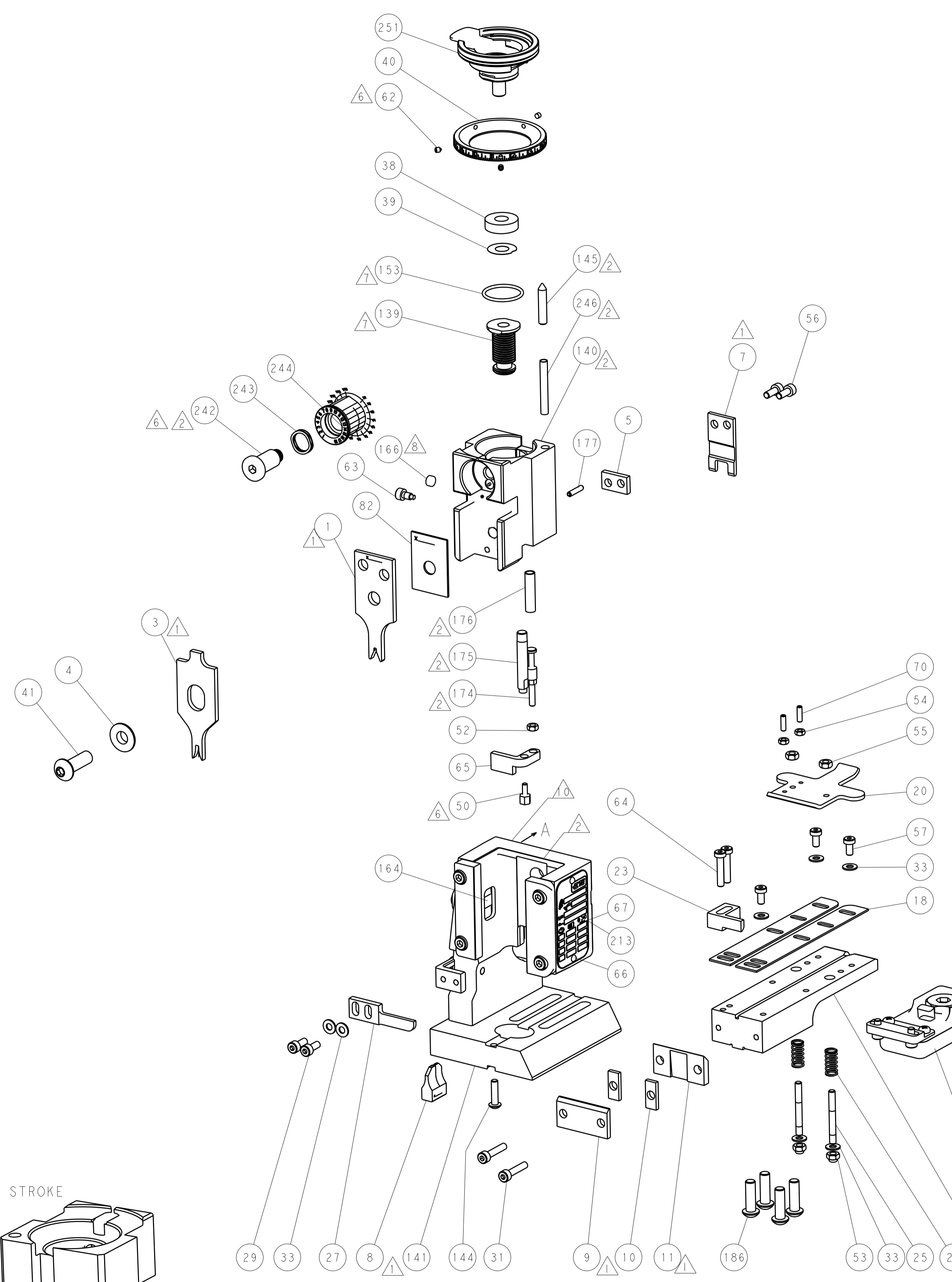
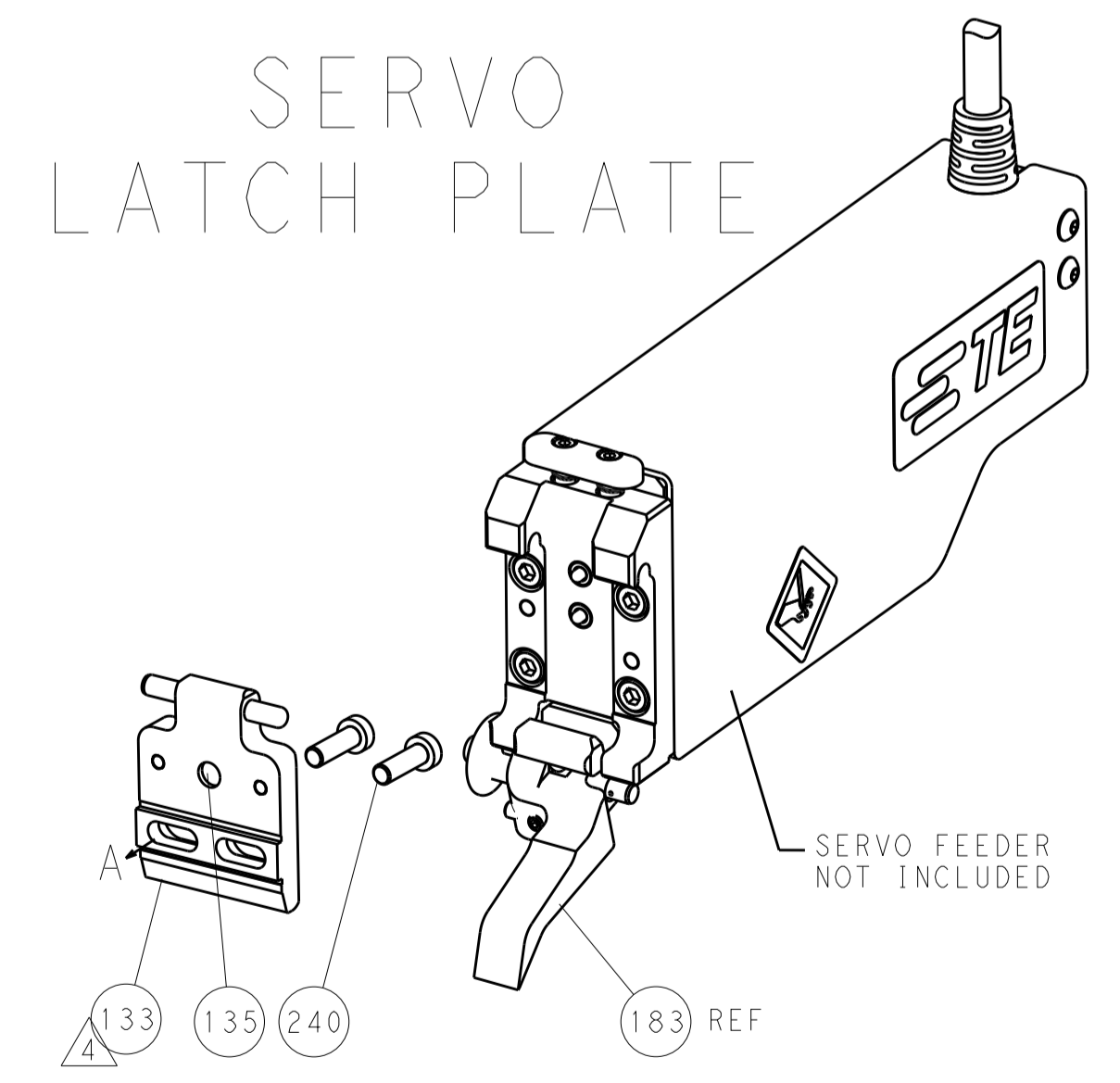
FEED TYPE
MECHANICAL



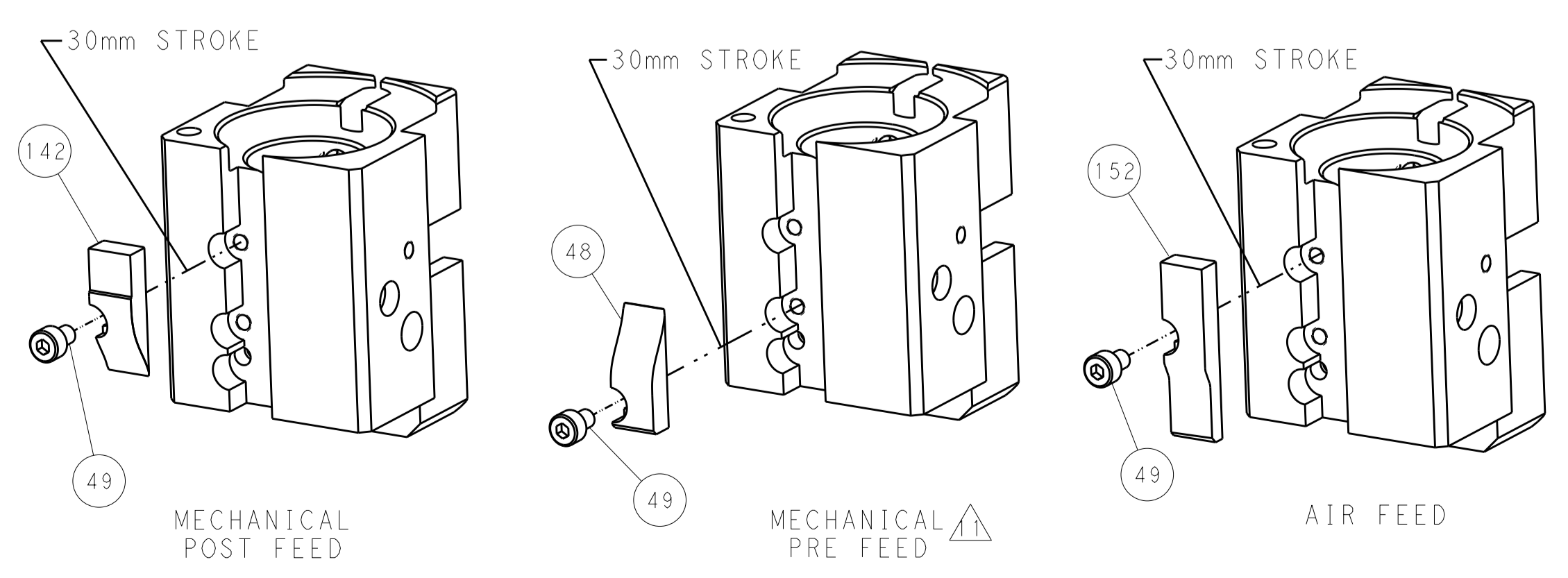
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: H. HUANG 29FEB2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±
	ANGLES	FINISH		CHK: S. XI 29FEB2012	NAME: Ocean End Feed Applicator	SIZE: A1	CAGE CODE: 00779
MATERIAL:				APVD: S. XI 29FEB2012	PRODUCT SPEC:	SCALE: 1:1	SHEET 4 OF 4
				WEIGHT:	APPLICATION SPEC:	RESTRICTED TO:	REV C
				Customer Accessible Production Drawing			