

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2150426-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
	2150426-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150426-5	-	2168400-7 (QUANTITY 2)
	2150426-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	2063440-1
	2150426-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-
	7-2150426-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	WIRE	TYPE
2.79 mm [1.10]	2.79 mm [1.10]	F
INSUL		

APPLICATOR INSTRUCTIONS 408-10390

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SHUR PLUG .156 DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.88-3.48 mm [1.13-.137 IN]		-	
TERMINAL APPLICATION SPECIFICATION	114-2042	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217606-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.01 +/- 0.05 [1.079 +/- .002]	4.4
16 AWG	1.75 +/- 0.05 [1.069 +/- .002]	7.0
18 AWG	1.63 +/- 0.05 [1.064 +/- .002]	8.3

- 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: 8-2150426-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150426-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150426-6
- 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, 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 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.

-77-7	-6	-5	-2	2119957-2	APPLICATOR SHIM PACK	260
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)

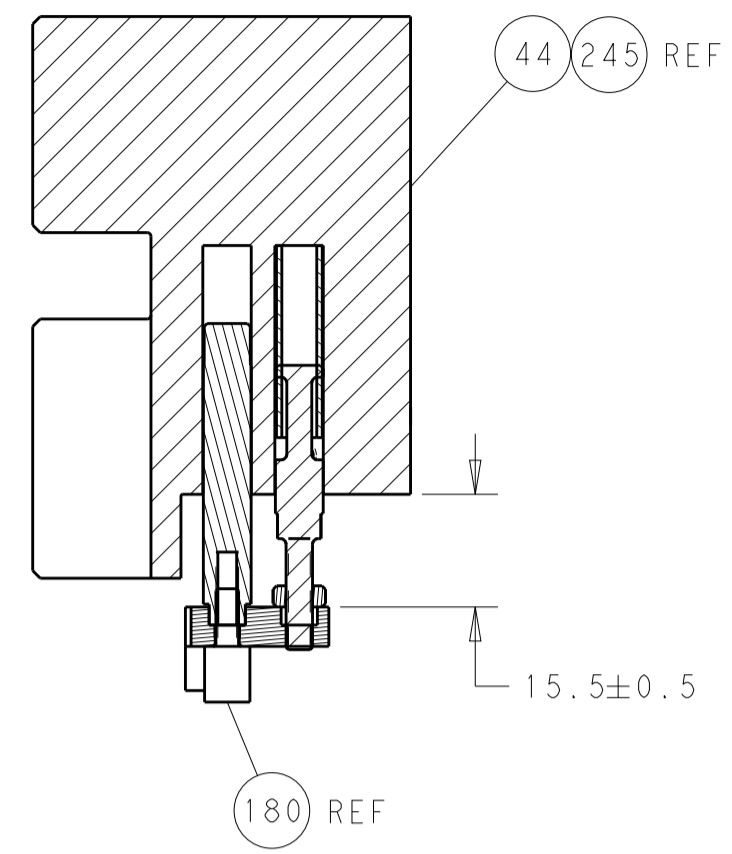
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			1	DEVELOPMENT	14MAR2014	YY UG
			A	RELEASED	09MAY2014	YY TE
			A1	ECR-16-009824	24JUL2017	GK SD
			A2	ECR-20-006606	08MAY2020	FJ TE

-	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	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1-1752354-4	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	-	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	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, 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	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	-	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 X 4.0	62
-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	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	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	-	1	2119369-1	RAM, AMP STYLE, END FEED	44
-	1	1	1	1	2079383-6	SCR, BHSC, RoHS (M8 X 12)	41
-	1	-	-	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	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	2119092-1	BOLT, ADJUSTMENT	35
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1-1752371-6	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-6	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4	DRAG	20
-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	240641-6	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-5	PLATE, REAR SHEAR	11
-	2	2	2	2	8-240645-5	SPACER, SHEAR PLATE	10
-	1	1	1	1	690796-1	PLATE-FRONT SHEAR MINI APPLICATOR	9
-	1	1	1	1	1803002-5	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	9-240651-5	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-5	SPACER	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
-	1	1	1	1	7-456408-7	CRIMPER, WIRE PREMIUM	1

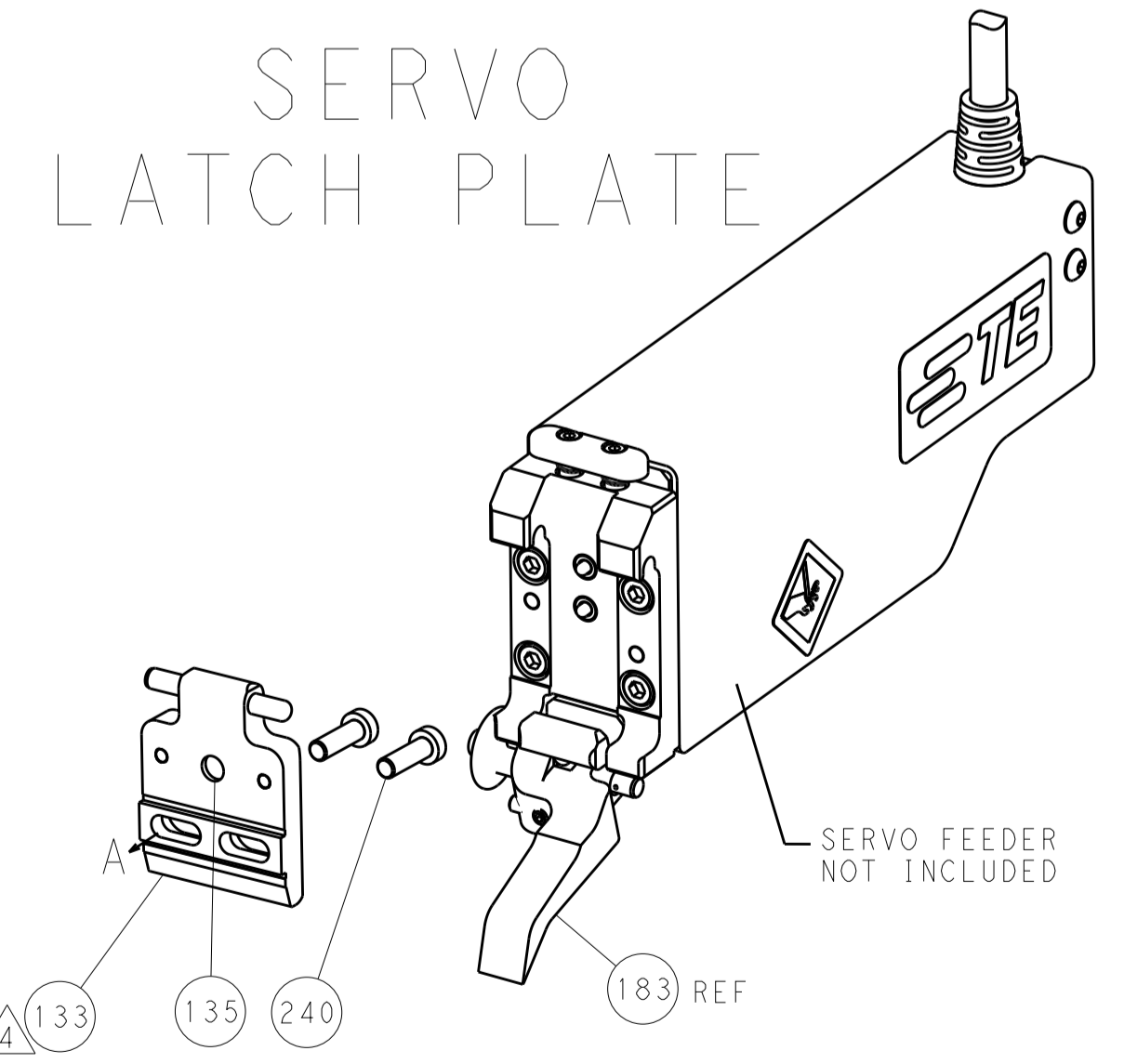
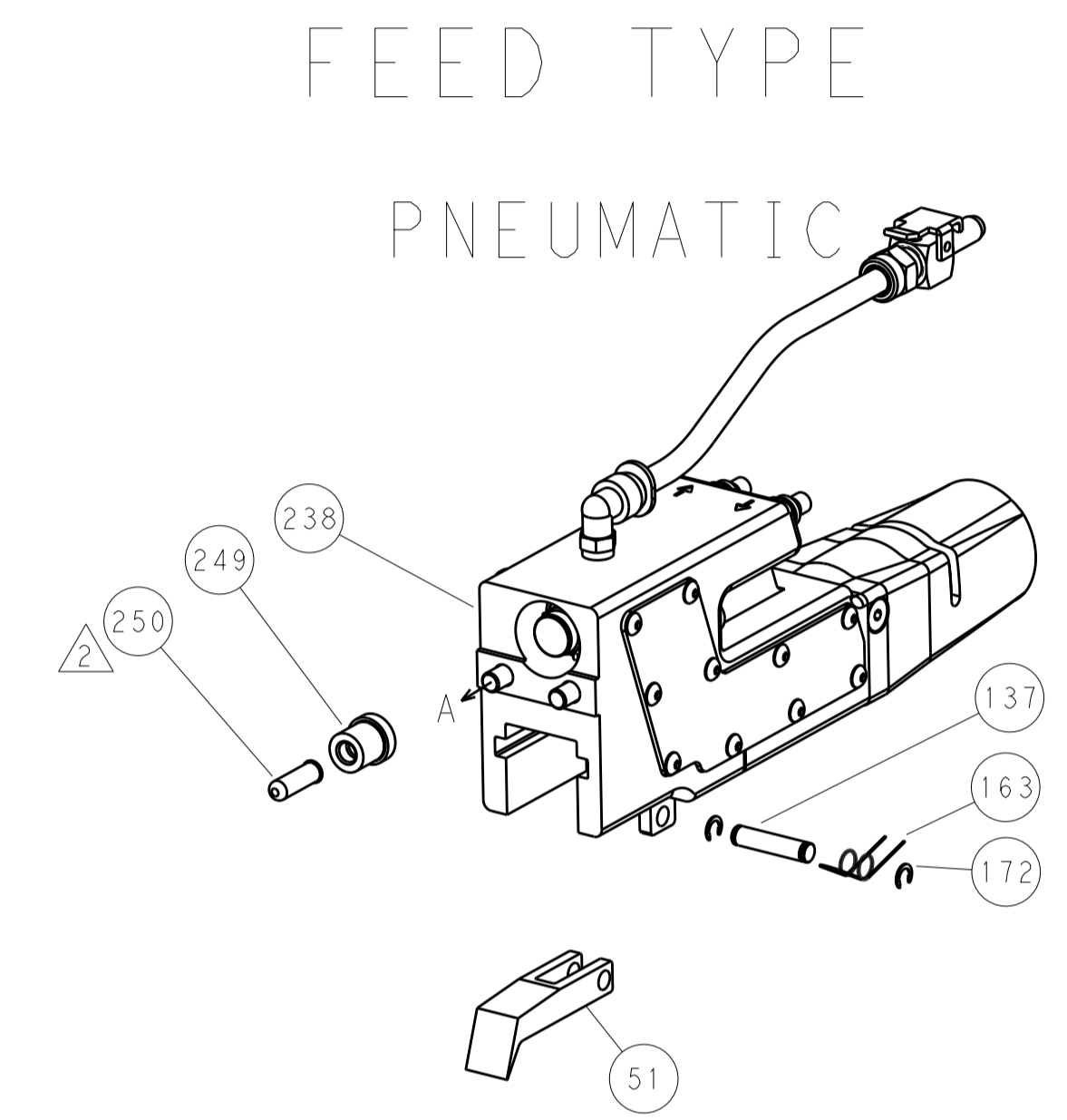
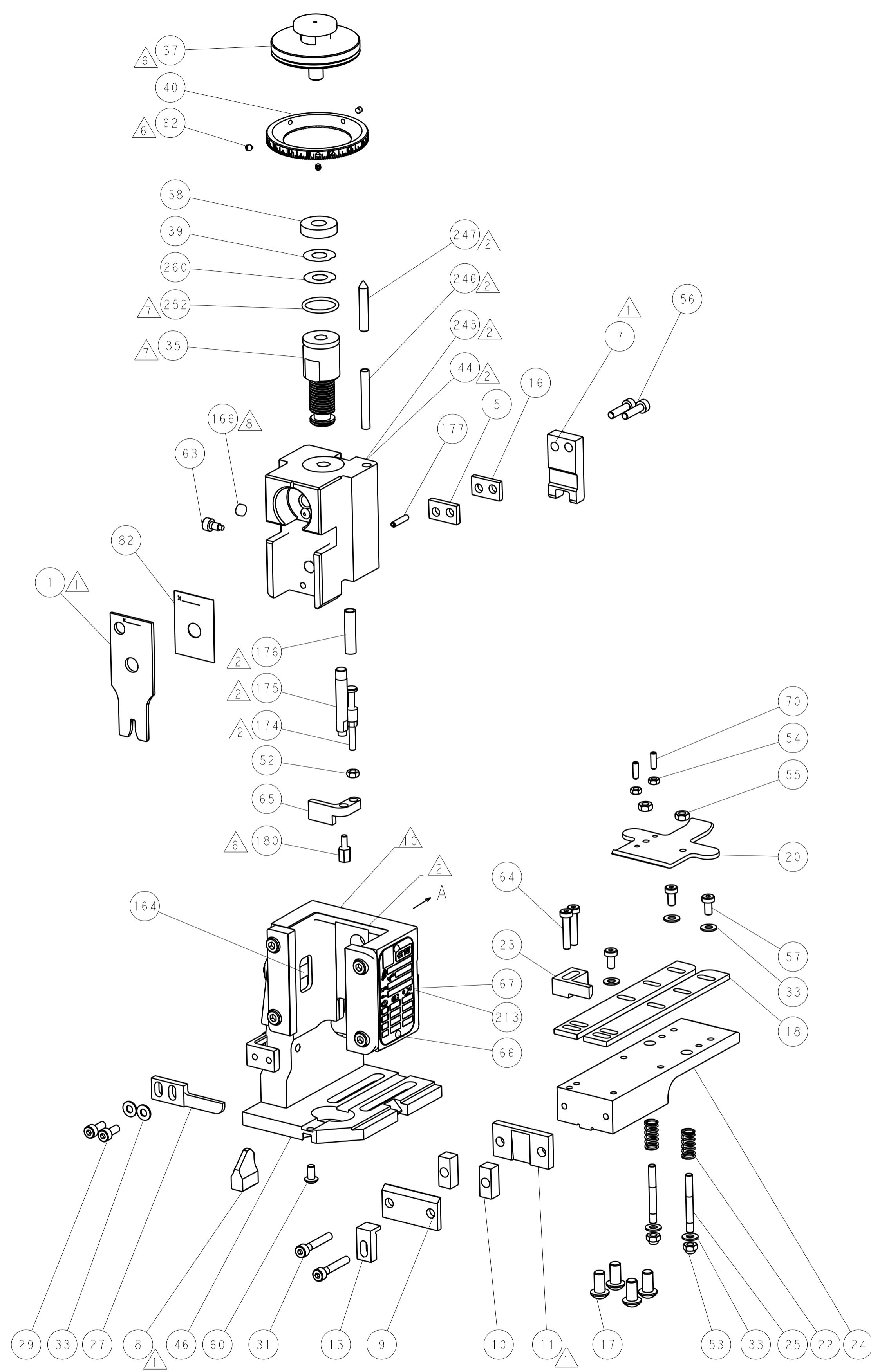
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mm	0 PLC	±		Y. YIN	14MAR2014	CHK	G. BAILEY	14MAR2014	
	1 PLC	±		APVD					
	2 PLC	±							
	3 PLC	±							
	4 PLC	±							
	ANGLES	±							
	FINISH	±							

Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV A2

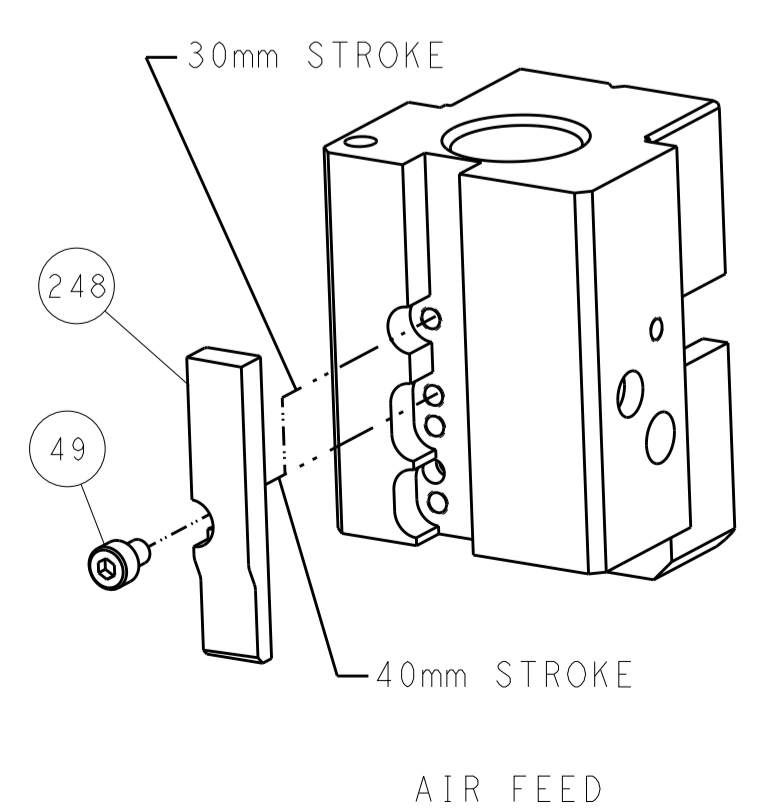
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
-			SEE SHEET 1	-	-



HOLDDOWN SET-UP



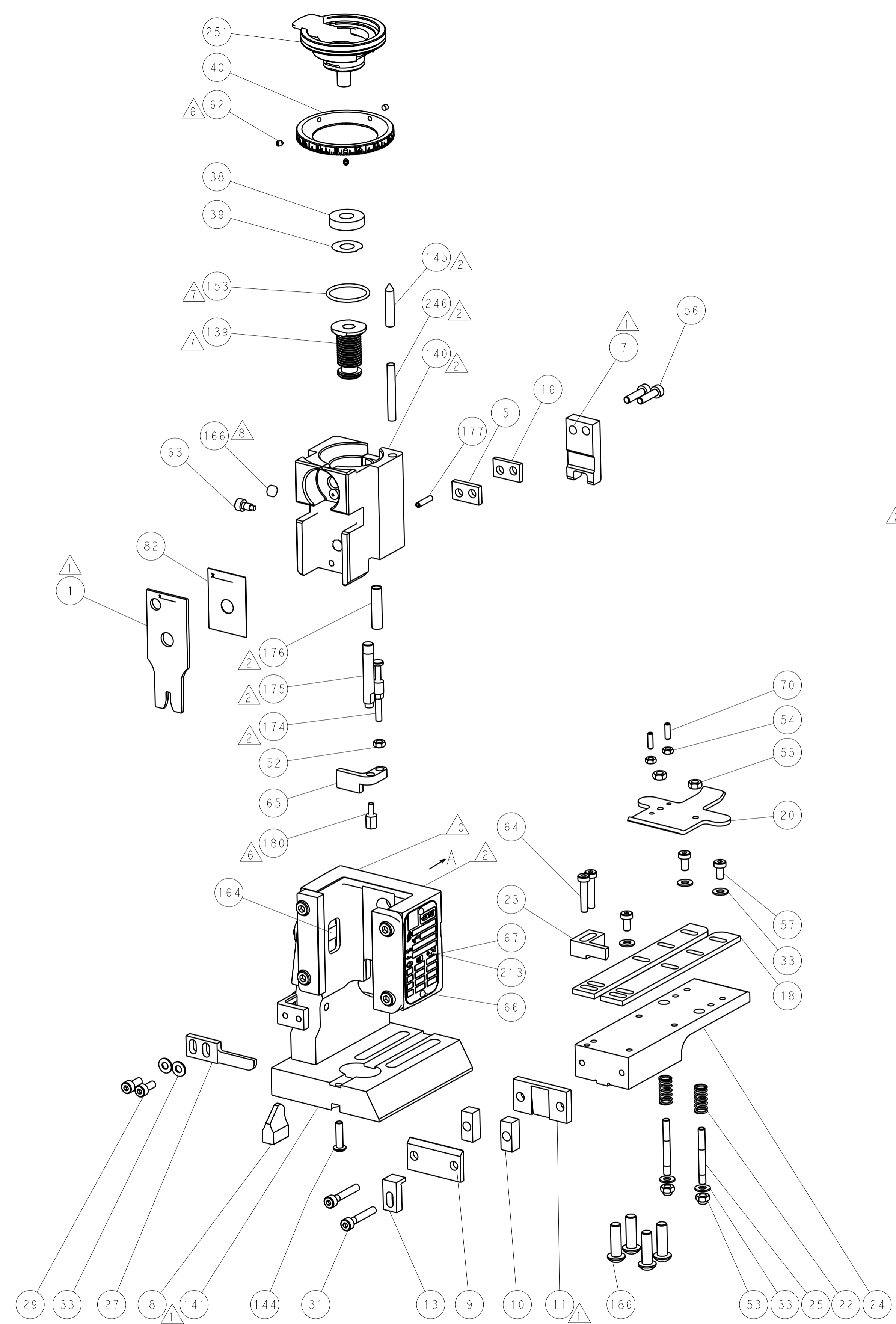
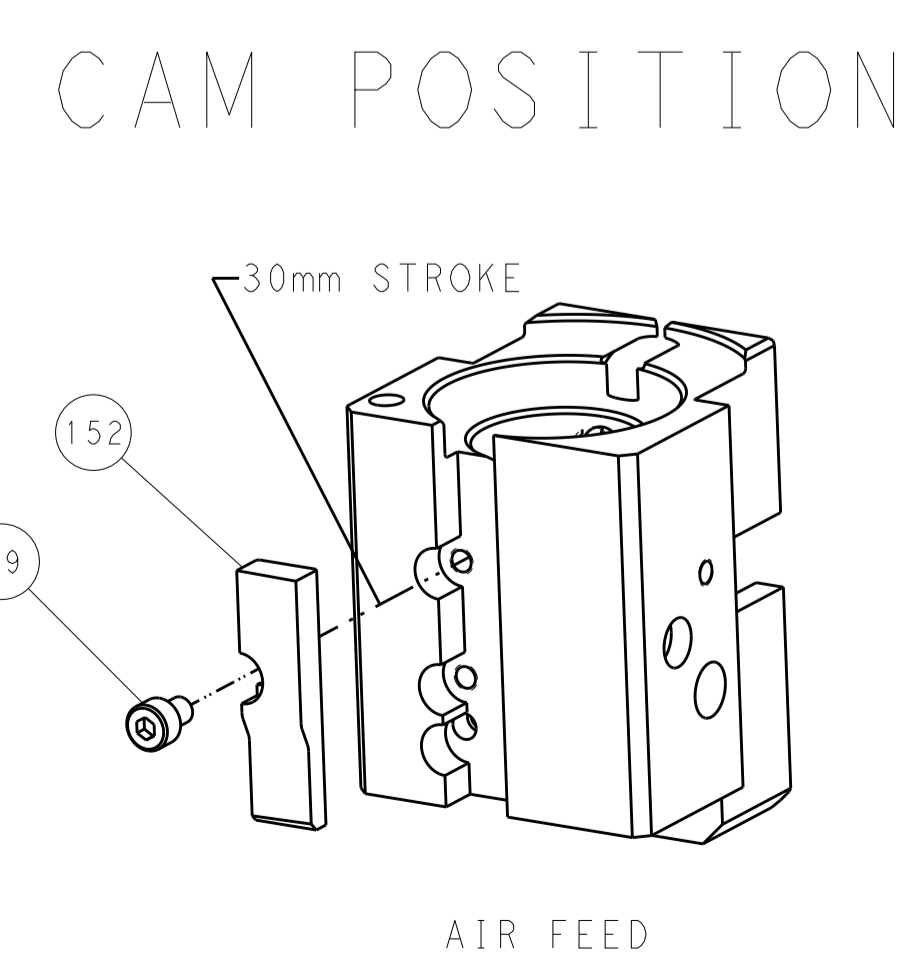
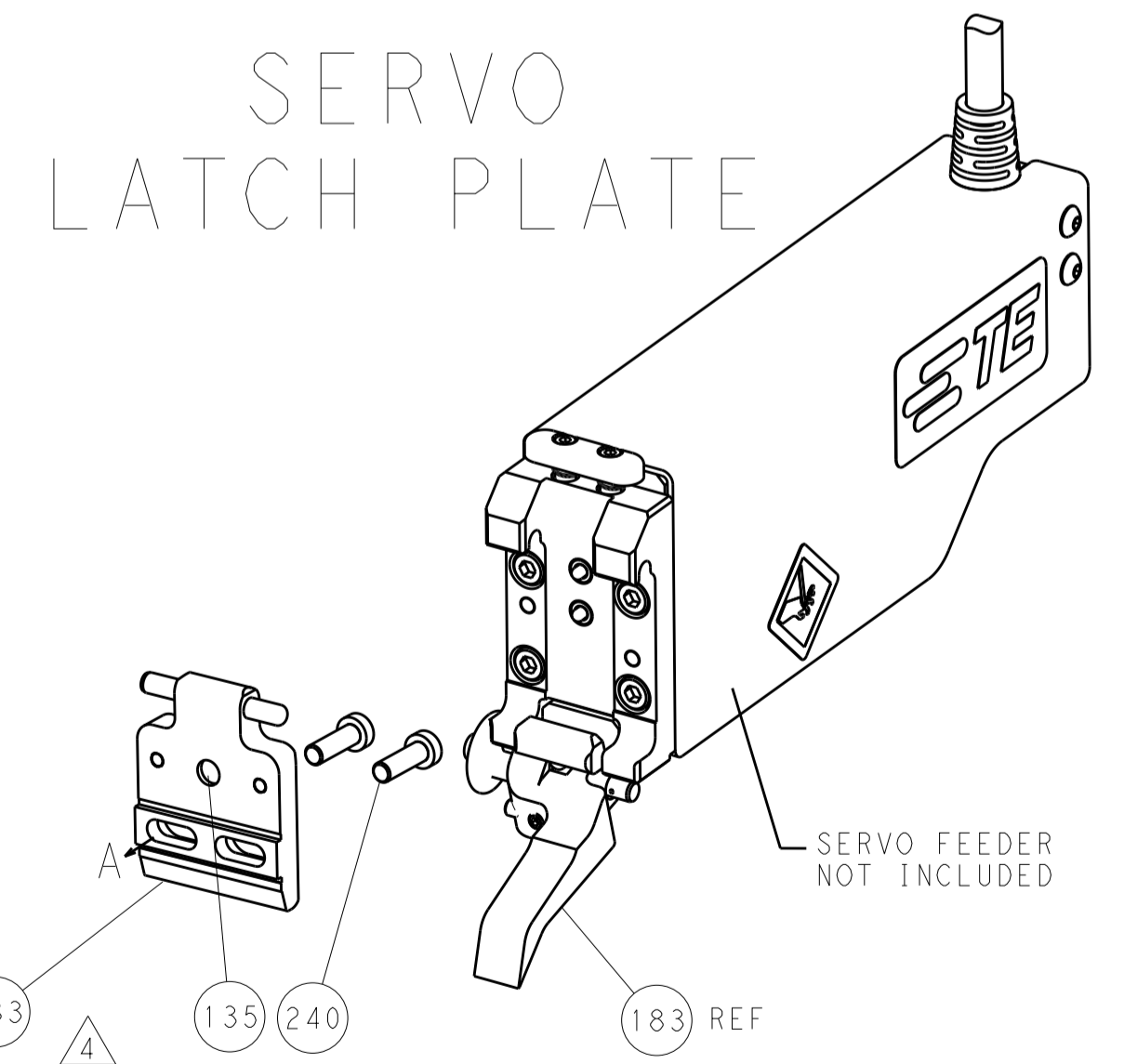
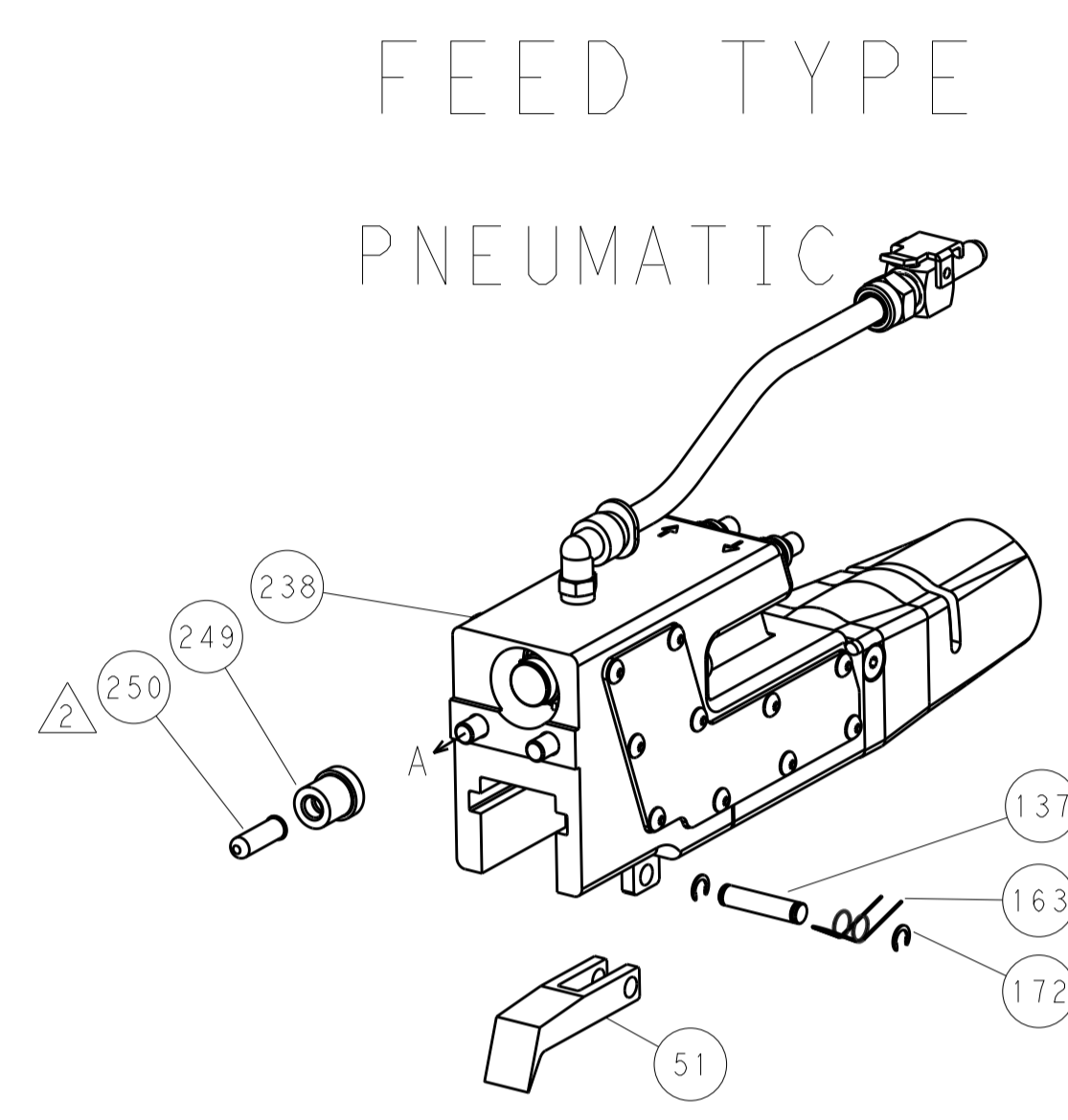
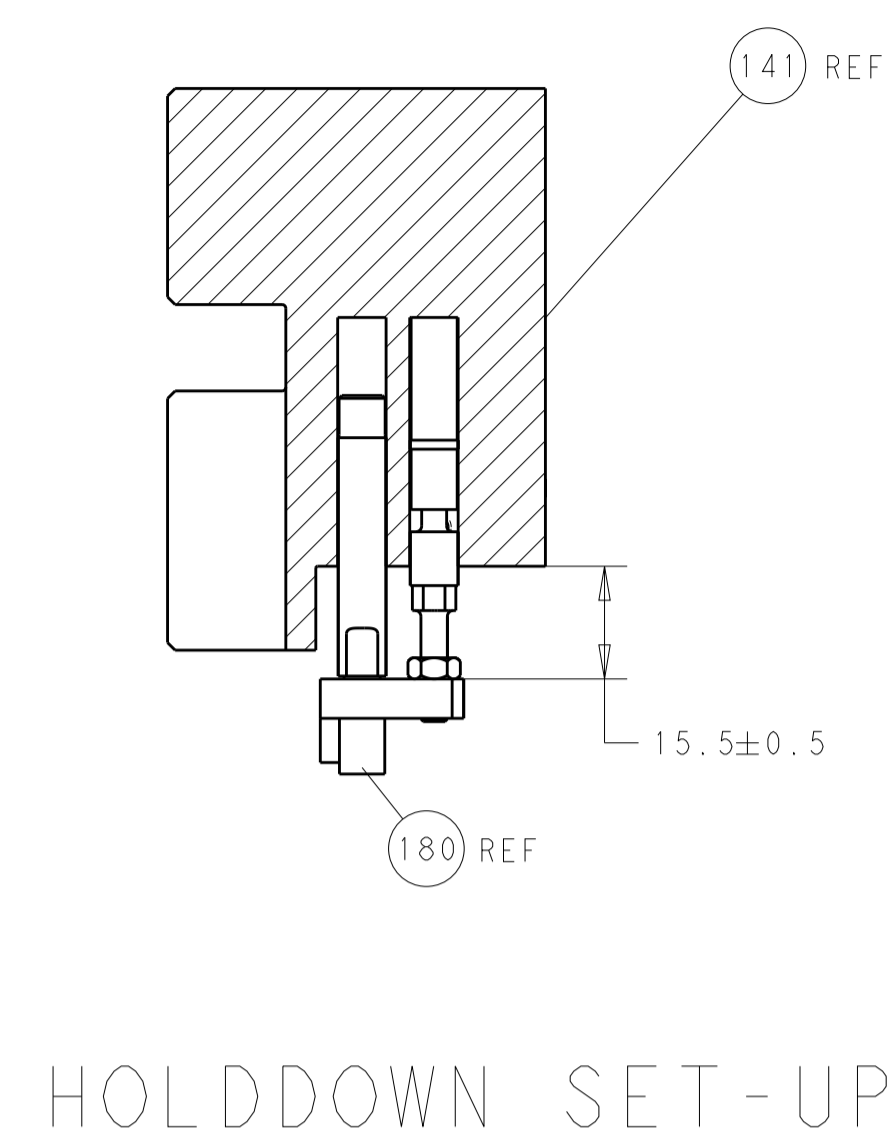
CAM POSITION



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 14MAR2014		TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 14MAR2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV: H. GUO 14MAR2014		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
D		3 PLC ±		APPLICATION SPEC		RESTRICTED TO:	
R		4 PLC ±		WEIGHT		A1 00779 ©=2150426	
ANGLES		FINISH		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV: A2	

LOC	DIST	REV	DATE	BY	CHK	APPV	DESCRIPTION	DATE	OWN	APVD
A	66						SEE SHEET 1			



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. YIN 14MAR2014		STE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME	
	ANGLES	FINISH		CHK G. BAILEY 14MAR2014	APPV H. GUO 14MAR2014	PRODUCT SPEC	
MATERIAL				APPLCATION SPEC		SIZE	CAGE CODE
				WEIGHT		00779	2150426
				Customer Accessible Production Drawing		SCALE	1:1
				SHEET		4	REV
				OF		4	A2