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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED

2150318-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150318-5

-

-

2168400-7 (QUANTITY 2)

2150318-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2161326-1

-

-

8-2150318-4

-

-

-

2150318-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

-

-

-

-

-

-

2150318-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2150318-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.79 mm [.110]

F

INSUL

3.56 mm [.140]

Ø

APPL INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME:

RING TONGUE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

WIRE SIZE

CRIMP HEIGHT

CRIMP HEIGHT

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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150318-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150318-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150318-6

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 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 & 180.

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

CUT TO LENGTH AT ASSEMBLY.

TERMINAL LUBRICANT IS RECOMMENDED.

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

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REVISIONS

2119599-2

A

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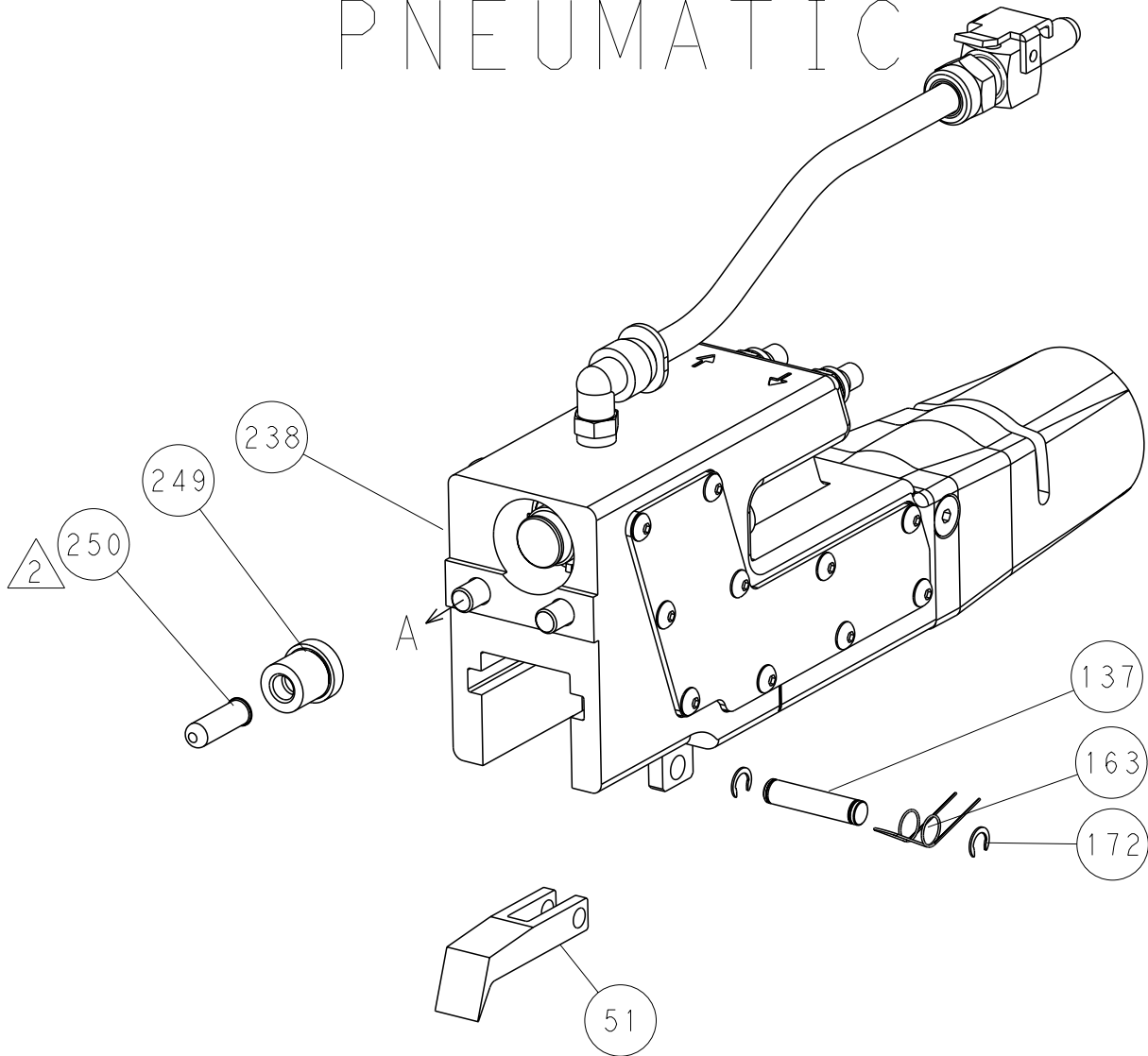
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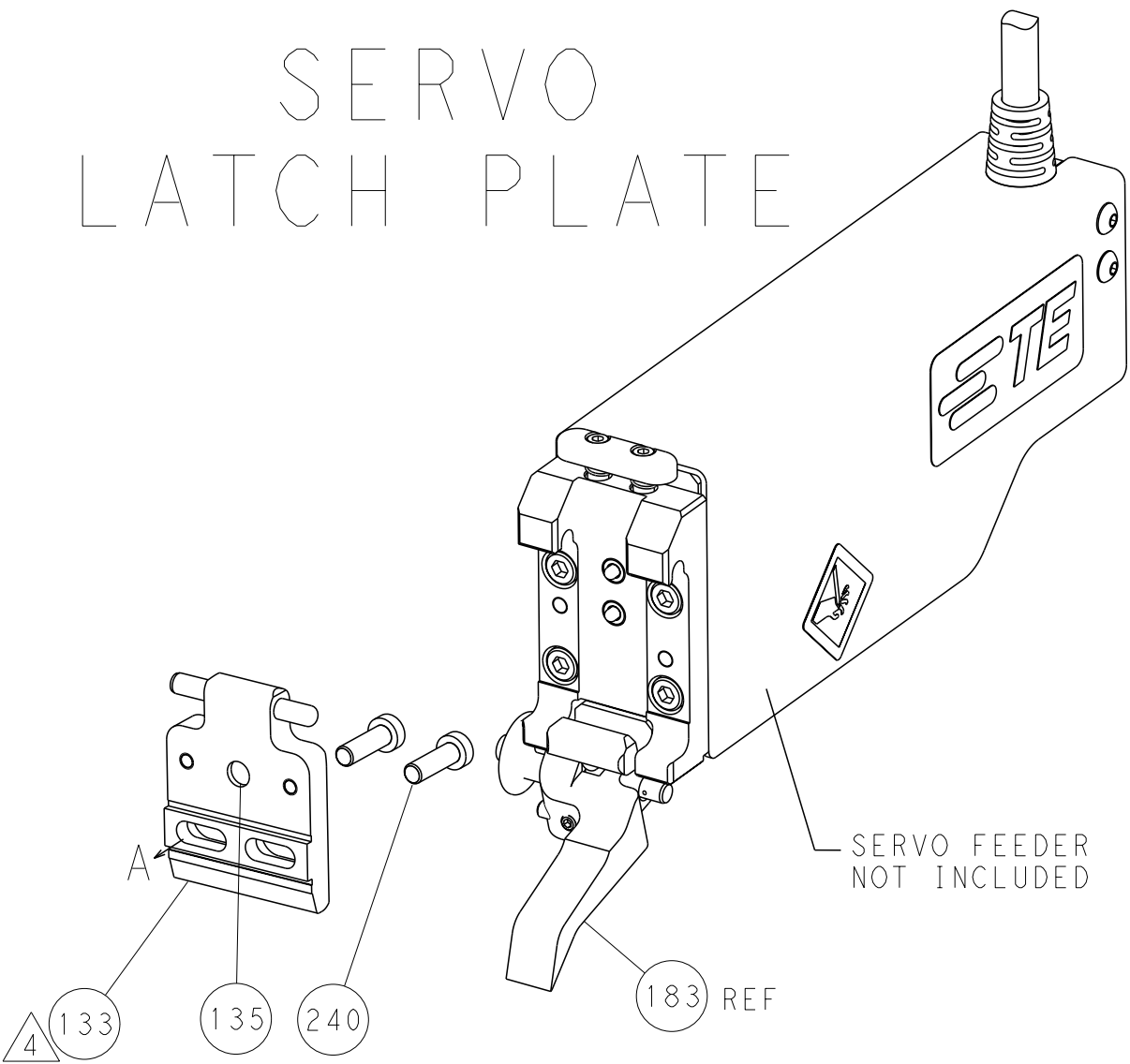
LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
				-	-	SEE SHEET 1	-	-	-

FEED TYPE

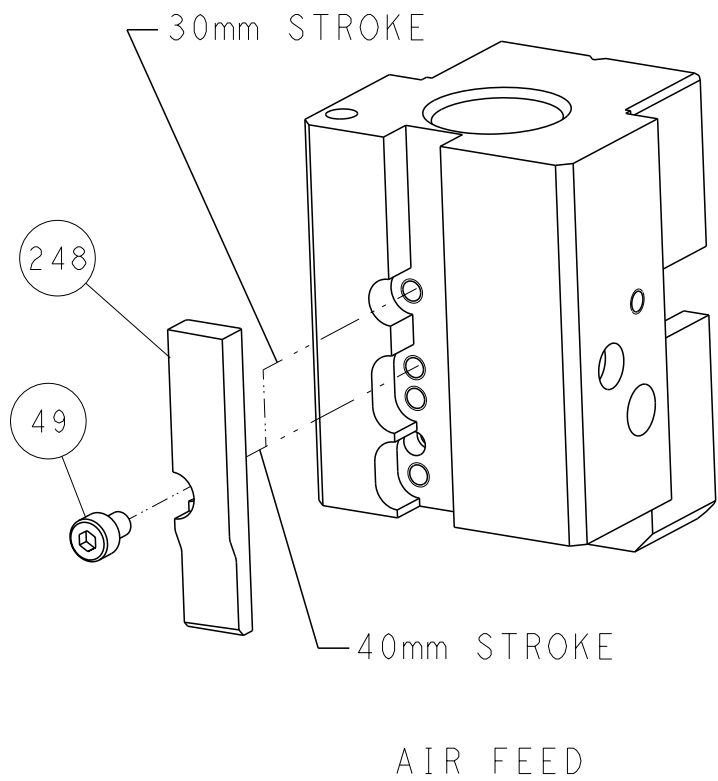
PNEUMATIC



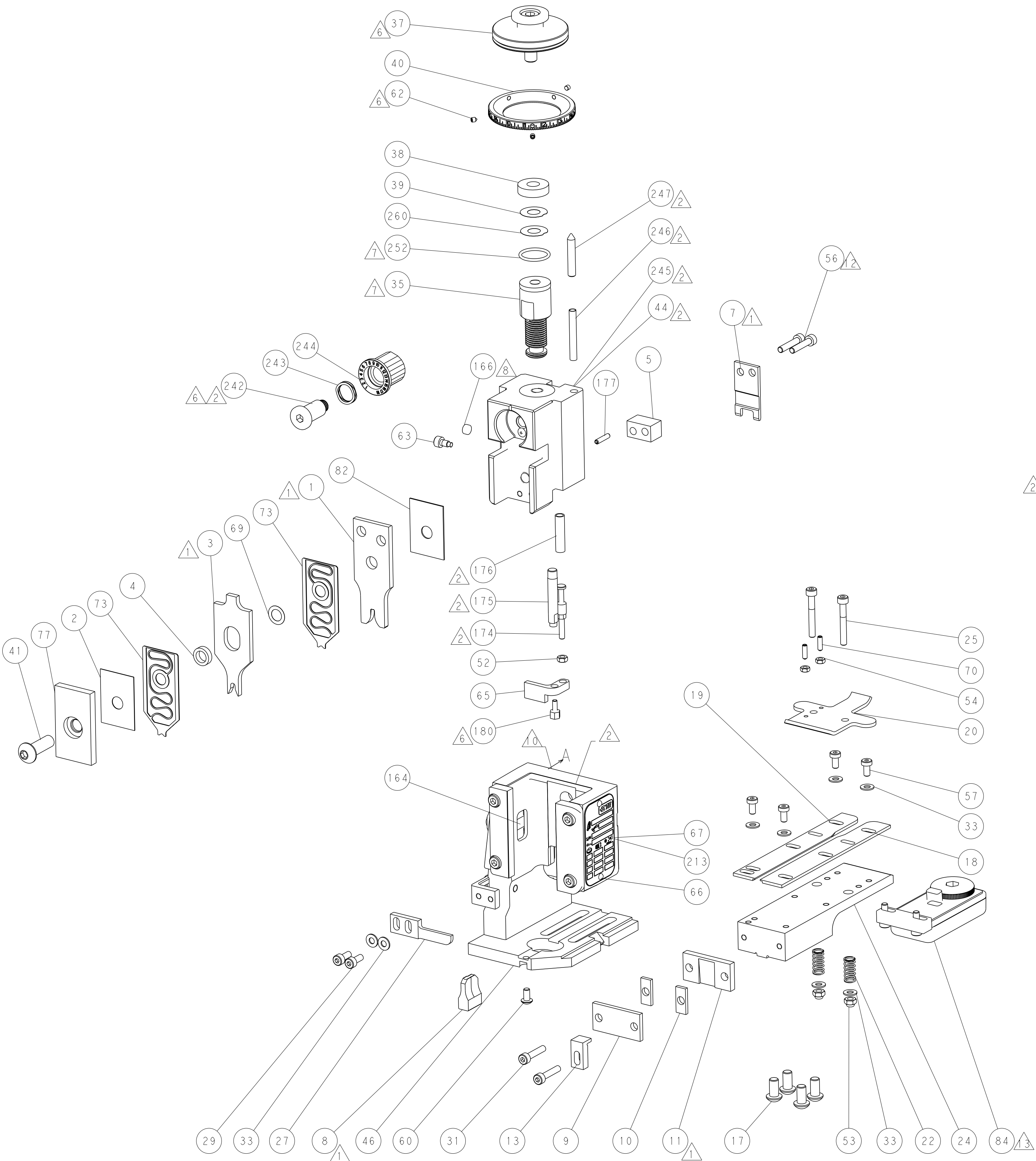
SERVO
LATCH PLATE



CAM POSITION



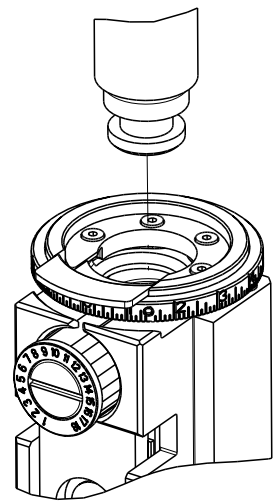
AIR FEED



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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG 09NOV2017		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm				CHK K. HUANG 09NOV2017		NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				APVD L. ZHANG 09NOV2017		SIZE 00779	
MATERIAL -				PRODUCT SPEC -		CAGE CODE 2150318	
				APPLICATION SPEC -		DRAWING NO 2150318	
				WEIGHT -		RESTRICTED TO -	
				Customer Accessible Production Drawing		SCALE 1:1	
						SHEET 2 of 4	
						REV A	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8				6		5		4		3	
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© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.									
	PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
						CONVERT TO	PART NUMBERS REQUIRED				
						-	-	-	-	-	-
	2-2150318-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150318-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150318-4	-	-	-
	2-2150318-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	-	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-2
2-2150318-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150318-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.110]	F
INSUL	3.56 mm [1.401]	O
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 4.80-5.60 mm [1.189-.220 IN]		INSULATION DIAMETER RANGE Ø1.52-3.05 mm [1.060-.120 IN]	
TERMINAL APPLICATION SPECIFICATION	114.2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
140787-2	140731-2	140731-3	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.30mm2		1.88+/-0.05 [1.074+/-0.002]		3.9
0.80mm2		1.73+/-0.05 [1.068+/-0.002]		5.3
0.50mm2		1.66+/-0.05 [1.065+/-0.002]		5.9
0.30mm2		1.52+/-0.05 [1.060+/-0.002]		7.4



- △ 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: 8-2150318-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150318-5
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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- △ 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. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- △ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- △ 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.
- △ CUT TO LENGTH AT ASSEMBLY.
- △ TERMINAL LUBRICANT IS RECOMMENDED.

-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	1803259-1	BUSHING, FLANGED	249
-77-27-25-22	PART NO	DESCRIPTION				ITEM NO

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

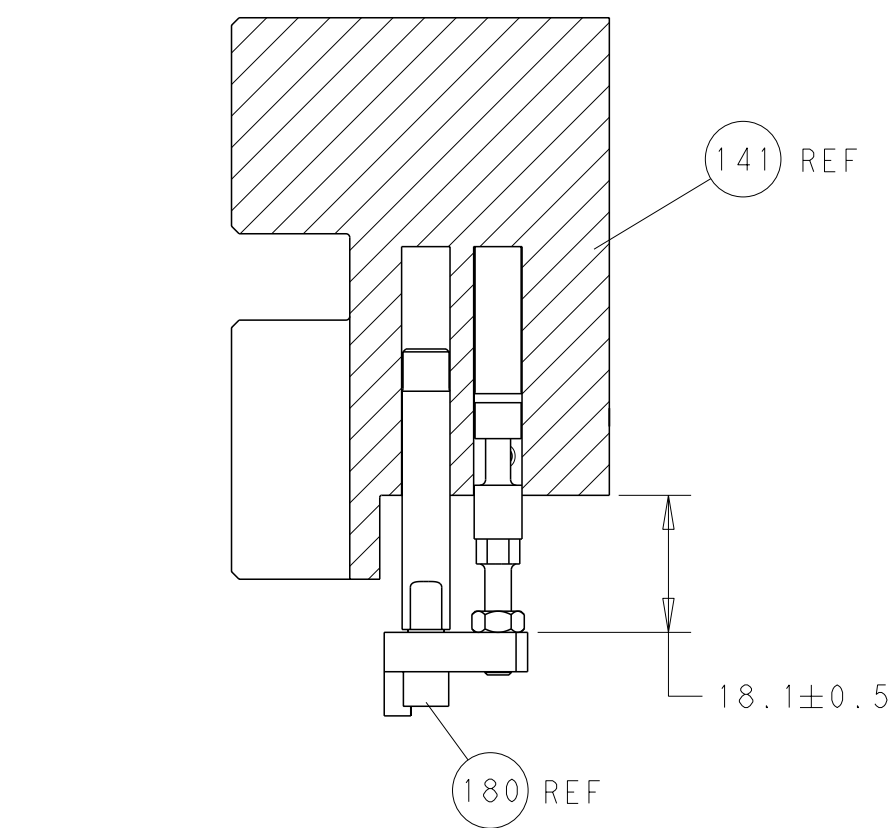
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LYR	DESCRIPTION	DATE
				-	SEE SHEET 1	-

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-77-27-25-22	PART NO	DESCRIPTION				ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN K. HUANG	09NOV2017	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK K. HUANG	09NOV2017	NAME	
		APVD L. ZHANG	09NOV2017	Ocean End Feed Applicator	
		PRODUCT SPEC		SIZE	
		APPLICATION SPEC		CASE CODE	
MATERIAL :		WEIGHT -		DRAWING NO 00779	
		Customer Accessible Production Drawing		RESTRICTED TO -	
		SCALE 1:1		SHEET 3	
				OF 4	
				REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

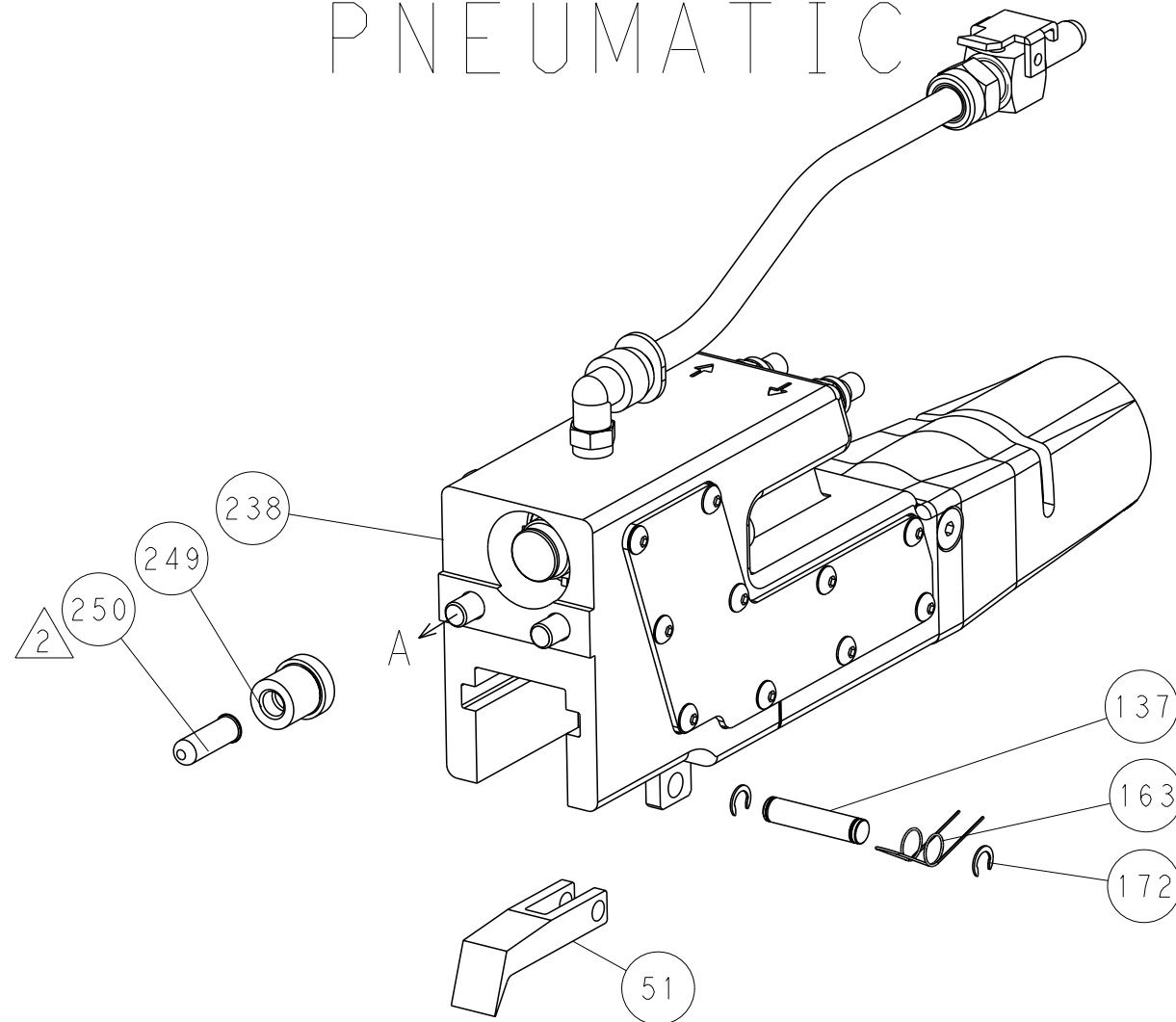
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



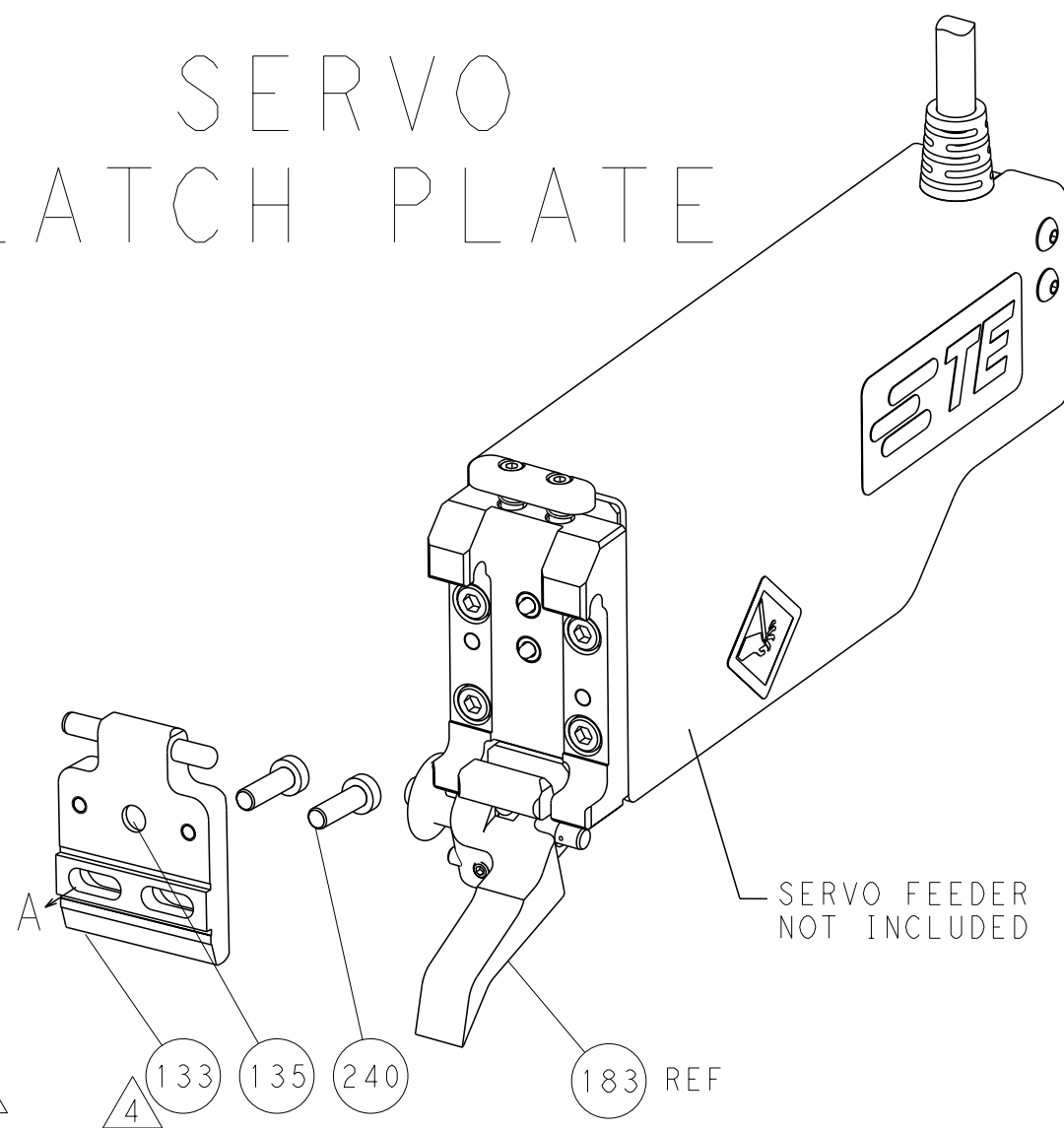
HOLDDOWN SET-UP

FEED TYPE

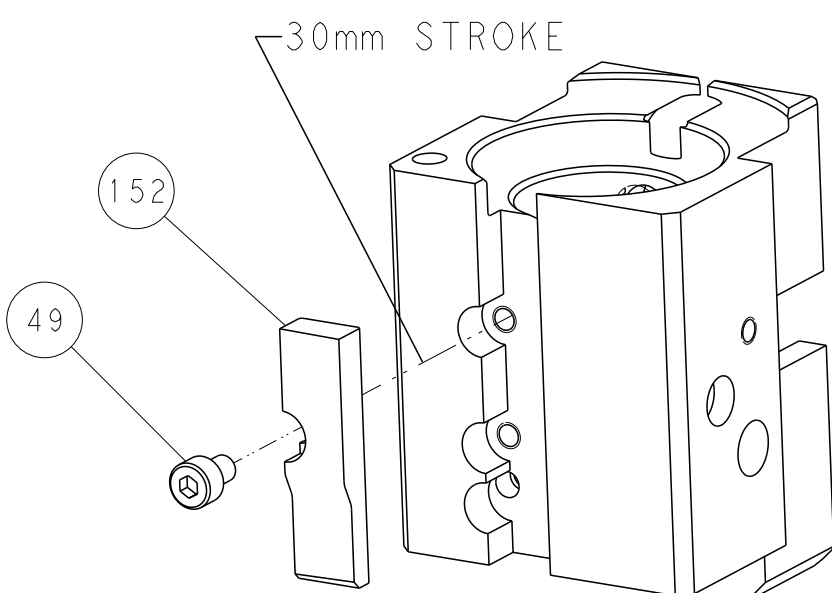
PNEUMATIC



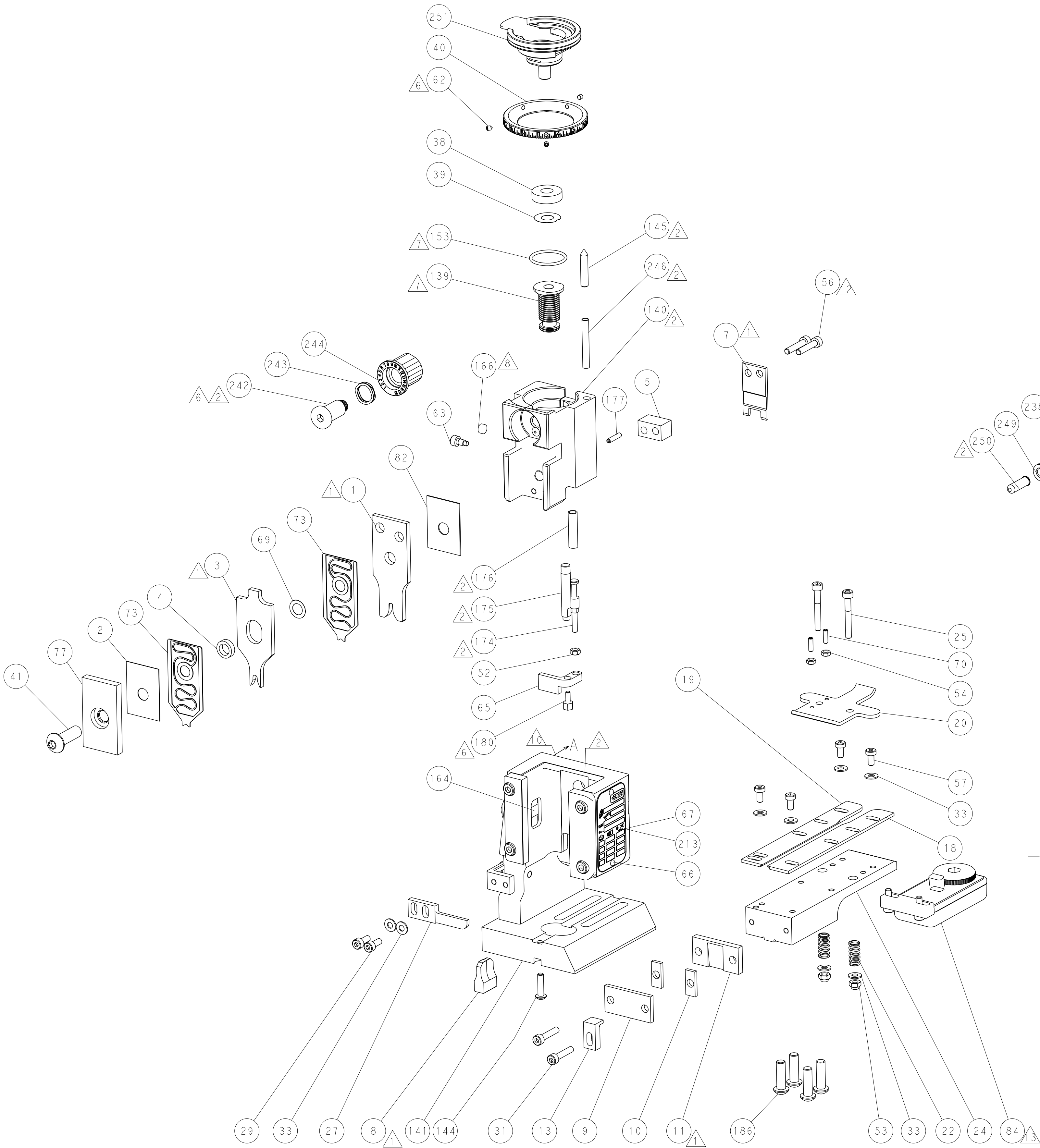
SERVO
LATCH PLATE



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)

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DIMENSIONS: mm		CHK K. HUANG 09NOV2017	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		APVD L. ZHANG 09NOV2017	SIZE A1	
MATERIAL -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	CAGE CODE 00779	
		Customer Accessible Production Drawing	SCALE 1:1	
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			OF 4	
			REV A	