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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

2150483-1

C

FINE CRIMP HEIGHT ADJUST

MECHANICAL

2150483-2

C

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2150483-5

C

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE^{△4}

2150483-6

C

NON-CRIMP HEIGHT ADJUST

△4

SERVO
LATCH PLATE^{△12}

2150483-7

C

FINE CRIMP HEIGHT ADJUST

NONE

7-2150483-7

A

CRIMP TOOLING KIT

-

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

2119950-1

2119792-6

-

2119641-1

-

2063440-1

SERVO LATCH PLATE

2119951-1

1901697-3

8-2150483-5

-

-

2168400-7 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2150483-4

-

-

-

MECHANICAL FEED

2119949-1

2063961-6

5-18022-5

2119653-1

-

-

SERVO LATCH PLATE

2119951-1

1901697-3

8-2150483-5

-

-

2168400-7 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2150483-4

-

-

-

MECHANICAL FEED

2119949-1

2063961-6

5-18022-5

2119653-1

-

-

PNEUMATIC FEED

2119950-1

2119792-6

-

2119641-1

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2063440-1

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.40 mm (.0551)

F

INSUL

-

-

APPL INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .110 SERIES FASTON RECEPTACLE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

3.58-4.34 mm (.141-.171 IN)

Ø1.02-1.52 mm (.040-.060 IN)

TERMINAL APPLICATION SPECIFICATION

114-2036

-

-

-

-

-

-

TERMINALS APPLIED^{△4}

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

61818-1

61818-2

61818-3

63837-1

63924-1

1742656-1

1217198-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING^{△9}

22 AWG

0.79+/-0.05 [.031+/- .002]

5.5

24 AWG

0.71+/-0.05 [.028+/- .002]

6.4

26 AWG

0.69+/-0.05 [.027+/- .002]

6.7

△1

RECOMMENDED SPARE PARTS

△2

GREASE BEARING SURFACES LIGHTLY

3.

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

△4

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150483-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150483-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150483-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150483-6

5.

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

△6

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 180.

△7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

△8

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

△9

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.

△10

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

△11

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.

△12

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

△13

FEED OFF OF RECEPTACLE.

△14

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.

△2

△7

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1

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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

2119599-2

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

DWN

APVD

A

RELEASED

30MAR2015

KH

GB

B

ECR-17-008387

09JUNE2017

TB

GB

C

ECR-18-000066

03JAN2018

JAH

CT

-

-

1

-

-

-

2119759-1

RAM, AMP STYLE, END FEED, NON-ADJUST

245

-

-

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

-

-

1

1

-

-

1901697-3

FEED FINGER ASSEMBLY, EF

183

-

1

1

1

1

1

1752354-4

STANDOFF, HOLD-DOWN

180

-

1

1

1

1

1

6-9931111-6

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

-

REF

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

1

2119955-2

ASSY, LUBRICATOR, END FEED

84

-

1

1

1

1

1

455888-4

SPACER, CRIMPER

82

-

1

1

1

1

1

2119791-9

DEPRESSOR, WIRE

73

-

1

1

1

1

1

2119956-2

DOCUMENTATION PACKAGE

71

-

2

2

2

2

2

2-18032-2

SCR, SET, FLT PNT, M3 X 10.0

70

-

1

1

1

1

1

2119943-1

WASHER, SPACER

69

-

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

1803653-1

HOLDDOWN, TERMINAL

65

-

2

2

2

2

2

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

64

-

1

-

1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

-

3

-

3

3

3

992763-5

SCR, SET, SOC, CONE PNT, 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

2063961-6

FEED FINGER

58

-

3

3

3

3

3

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

2

2

2

2

1-2168083-4

SCR, SKT HD CAP, RoHS, M4 X 5

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

-

2119792-6

PAWL, EF, AIR

51

-

-

-

-

1

2

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

2079383-6

SCR, BHSC, RoHS (M8 X 12)

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

1-2119644-4

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

240639-7

STRIPPER (MACHINING)

27

-

2

2

2

2

2

1320906-1

STUD, THREADED

25

-

1

1

1

1

1

1-1752371-2

PLATE, STRIP GUIDE

24

-

1

1

1

1

1

1-240825-2

PLATE, STRIP HOLD DOWN

23

-

2

2

2

2

2

2-22281-3

SPRING, COMPRESSION

22

-

1

1

1

1

1

1752373-4

DRAG

20

-

2

2

2

2

2

1901259-2

GUIDE, LOWER STRIP

18

-

4

4

4

4

4

1-2079383-1

SCR, BHSC, RoHS (M6 X 12)

17

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1

1

1

1

1

240644-5

PLATE, REAR SHEAR

11

-

-

-

-

-

-

-

-

10

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1

1

1

1

1

4-690495-9

PLATE, FRONT SHEAR

9

△1

1

1

1

1

1

1333224-9

ANVIL, COMBINATION (E.F. WIRE/B ONLY)

8

△1

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1

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1

1

690474-5

BLADE, SLUG

7

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1

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1803203-1

BLOCK, FRONT DEPRESSOR

6

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455888-1

SPACER, CRIMPER

2

△1

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1

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1

1

5-1633860-7

CRIMPER, WIRE

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

1715 BRAKING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION
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DWN

X ZHAO

29SEP2014

CHE

ELBIN

29SEP2014

APD

U GUO

29SEP2014

NAME

Ocean End Feed
Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

DIMENSIONS:

mm

0 PLC ±

1 PLC ±

2 PLC ±

3 PLC ±

4 PLC ±

ANGLES

FINISH

MATERIAL

:

:

TOLERANCES UNLESS OTHERWISE SPECIFIED:

WEIGHT

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

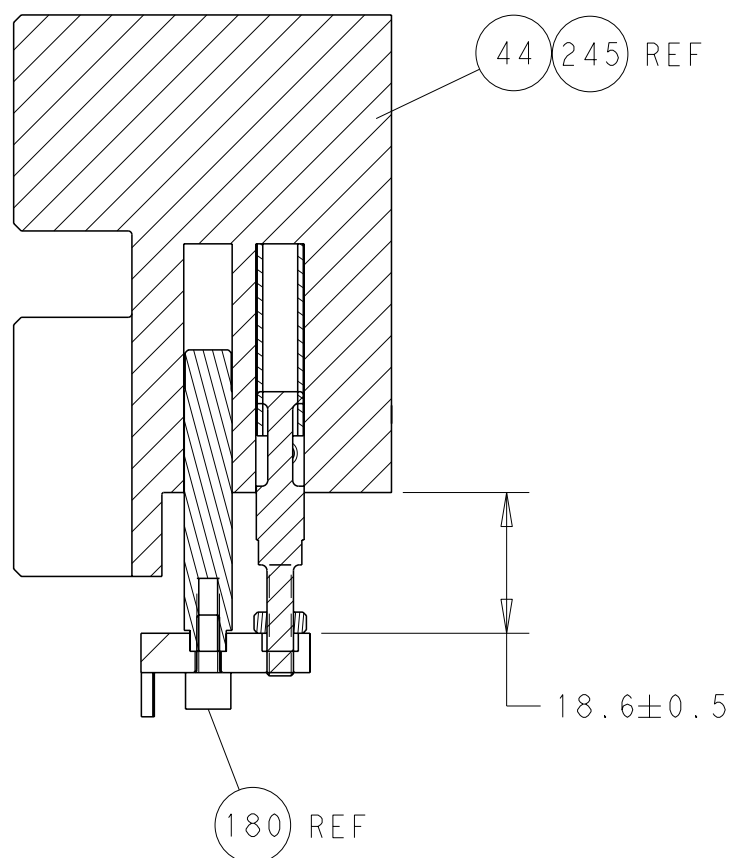
OF

4

REV

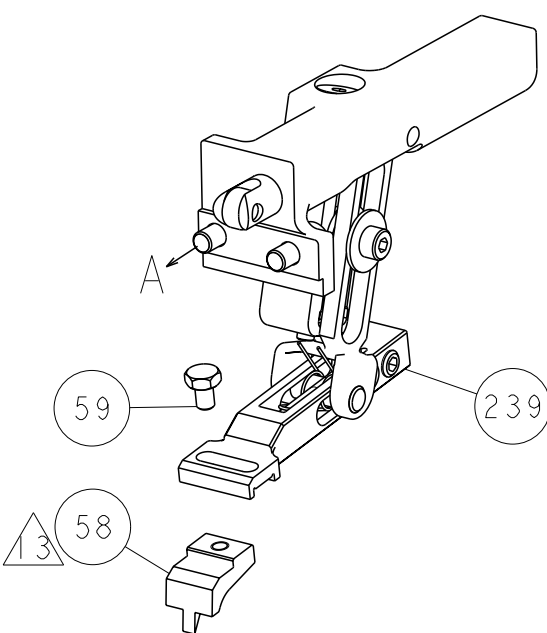
C

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

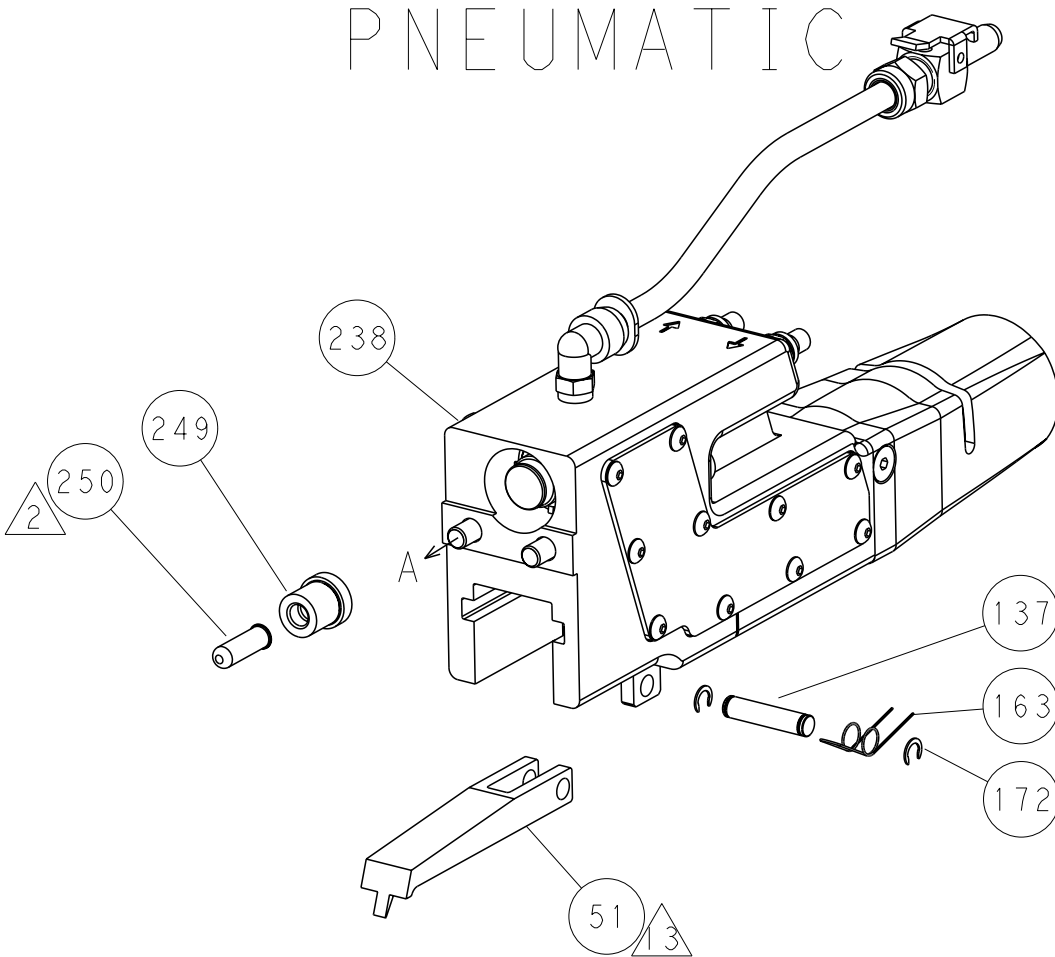


HOLDDOWN SET-UP

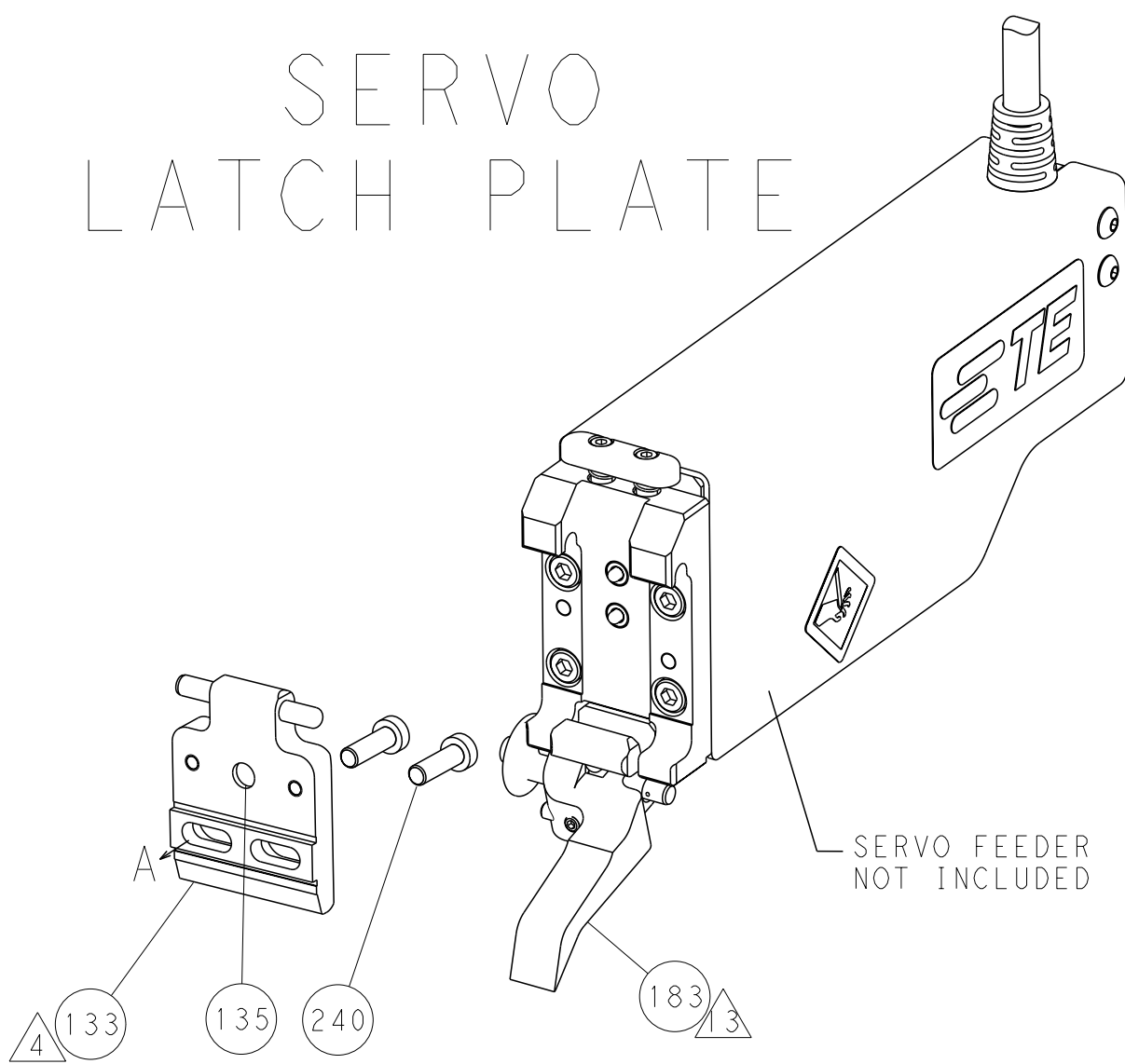
FEED TYPE
MECHANICAL



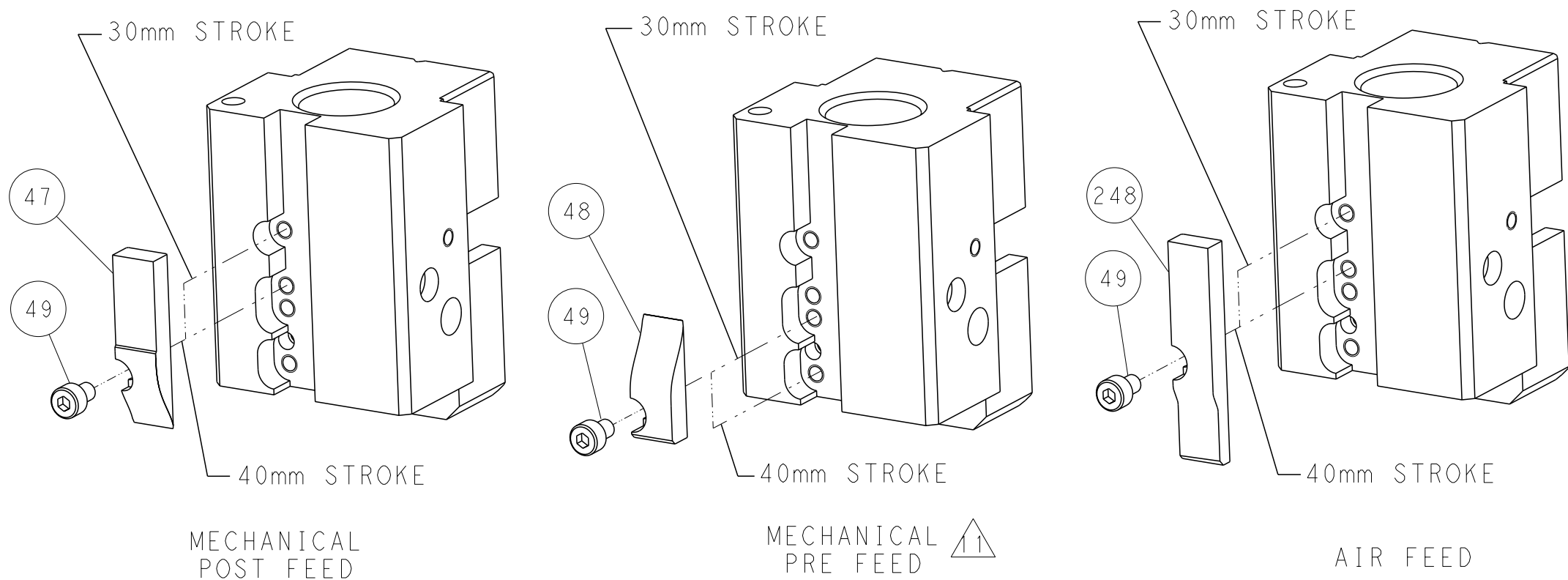
PNEUMATIC



SERVO
LATCH PLATE



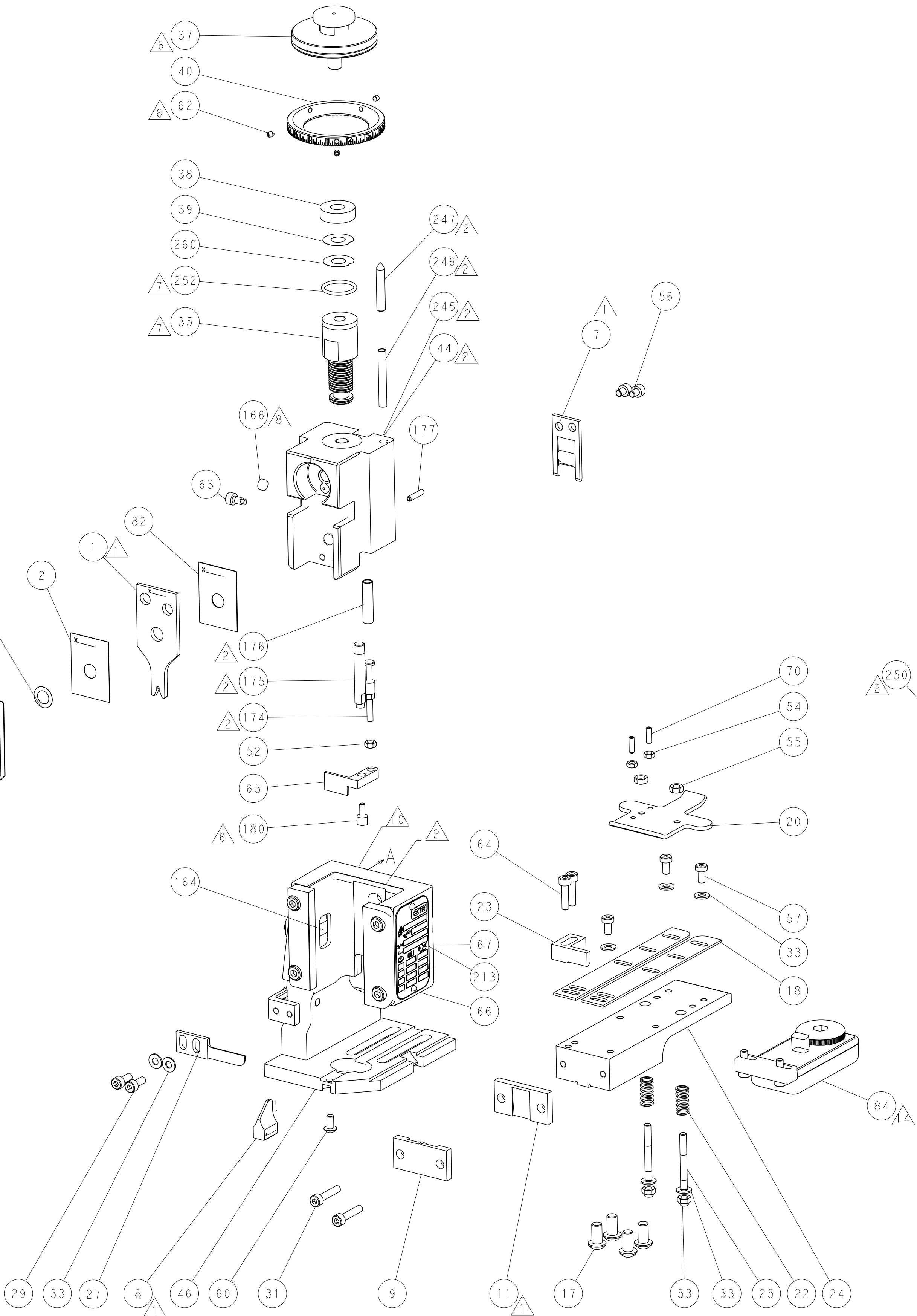
CAM POSITIONS



MECHANICAL
POST FEED

MECHANICAL
PRE FEED

AIR FEED

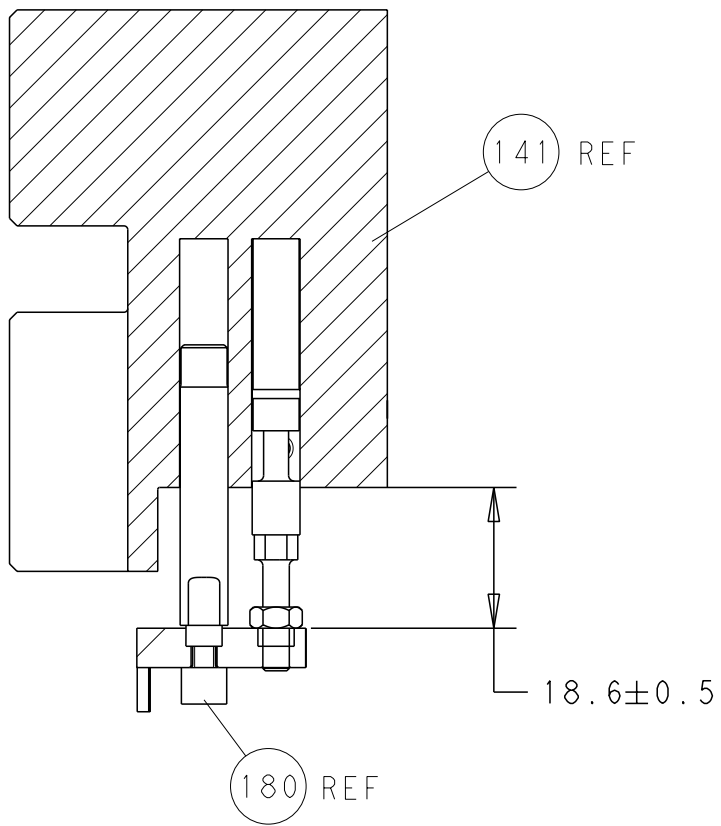


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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CMR T. ELBIN 29SEP2014		29SEP2014	29SEP2014	NAME Ocean End Feed Applicator			
APVD U. GUO 29SEP2014		29SEP2014	29SEP2014	SIZE A1			
PRODUCT SPEC		PRODUCT SPEC	PRODUCT SPEC	CAGE CODE 00779			
APPLICATION SPEC		APPLICATION SPEC	APPLICATION SPEC	DRAWING NO C=2150483			
MATERIAL		MATERIAL	MATERIAL	RESTRICTED TO			
FINISH		FINISH	FINISH	Customer Accessible Production Drawing			
SCALE		SCALE	SCALE	1:1			
SHEET		SHEET	SHEET	2 of 4			
REV		REV	REV	C			

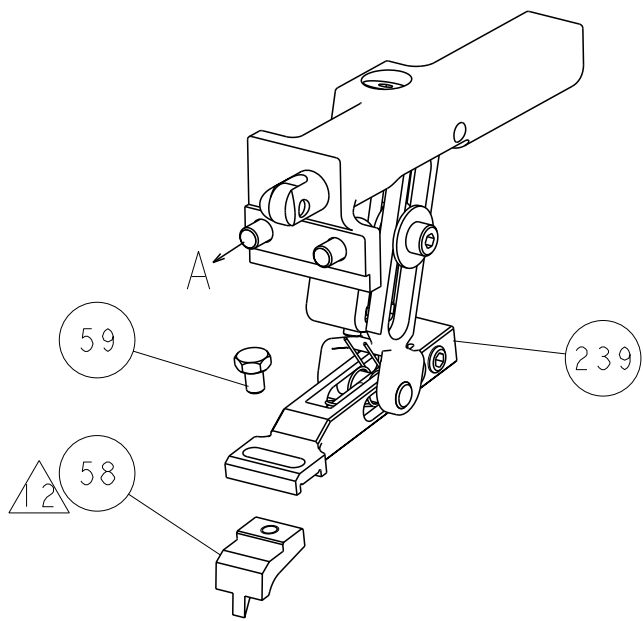
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

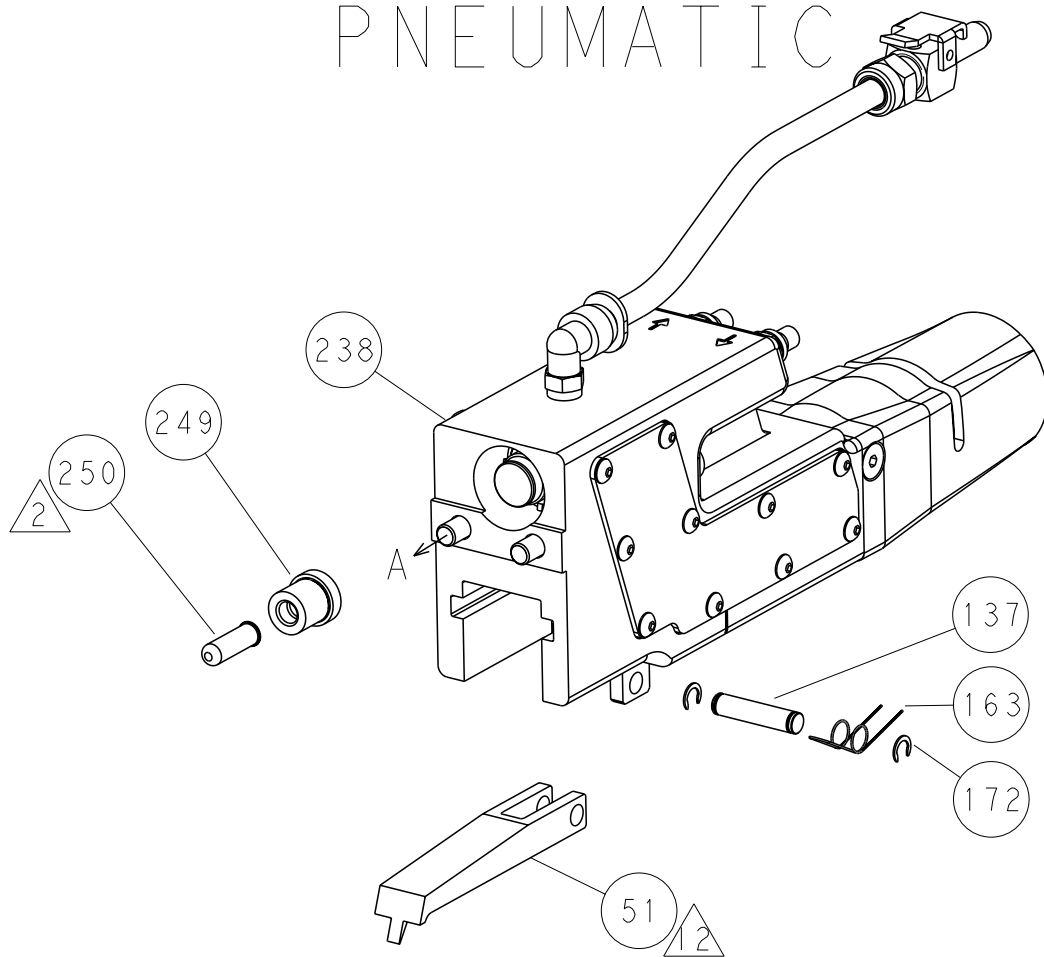


HOLDDOWN SET-UP

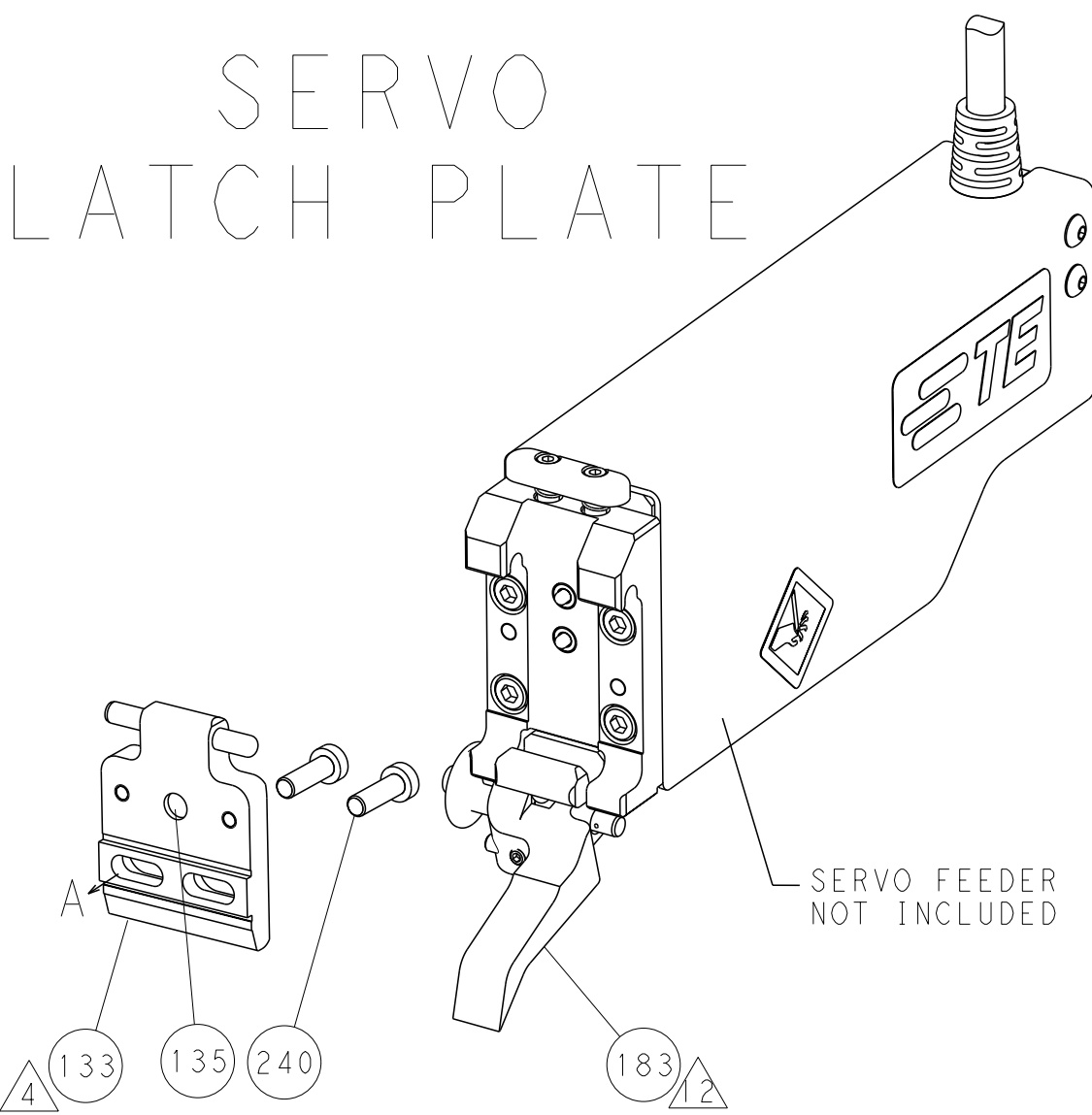
FEED TYPE
MECHANICAL



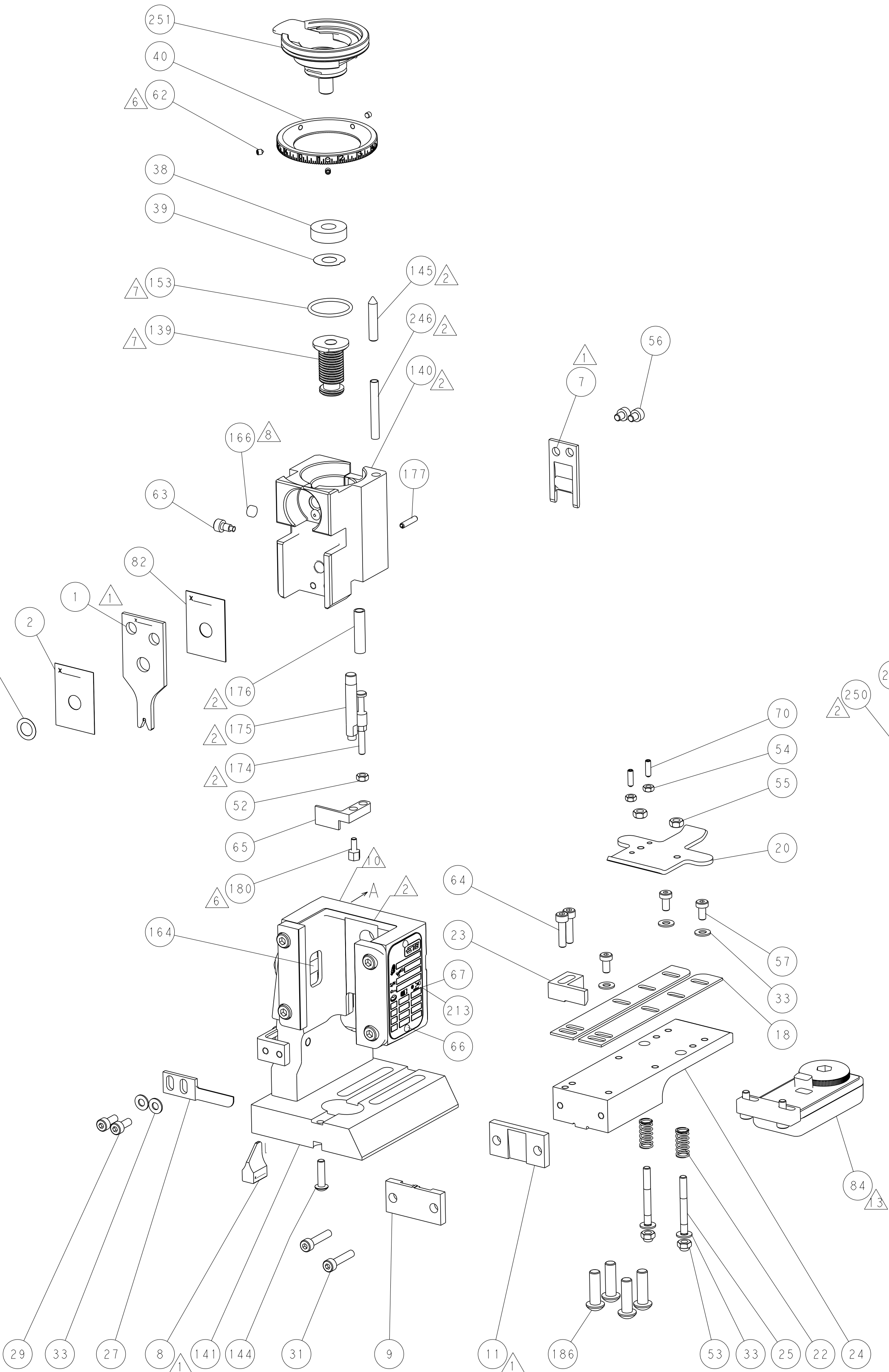
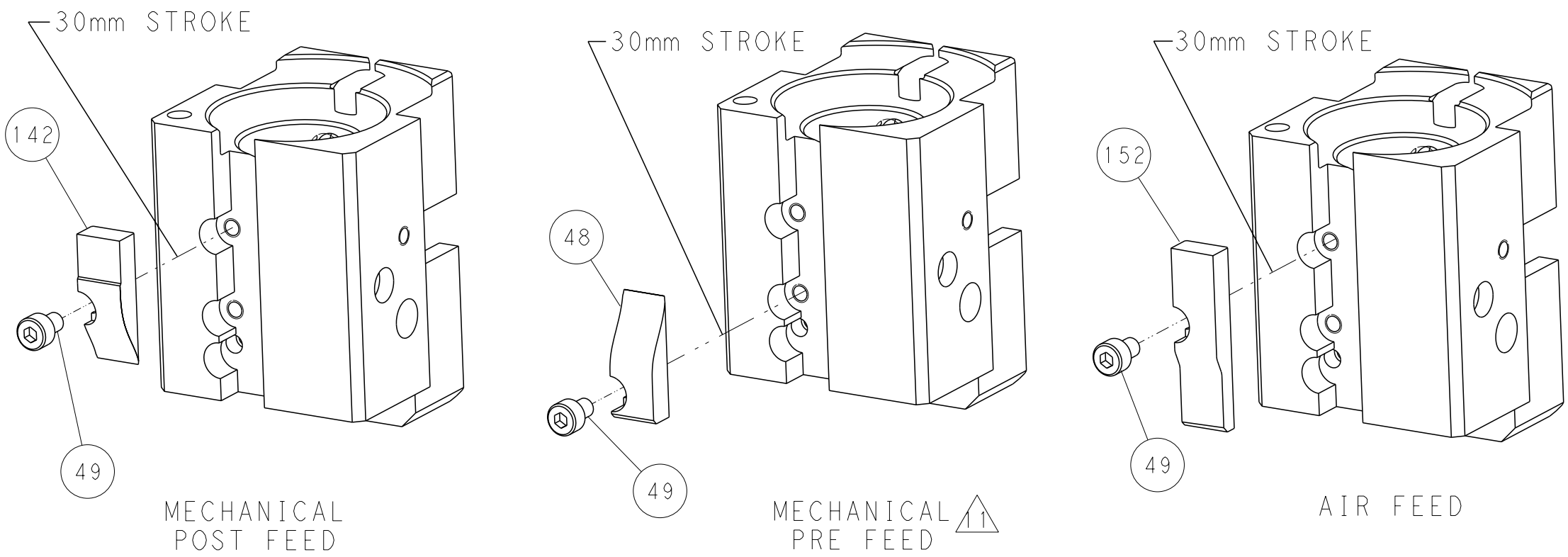
PNEUMATIC



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION. CHANGES BE CONTACTED FOR THE LATEST REVISION.		DWN X. ZHAO	29SEP2014	STE TE Connectivity Harrisburg, PA 17105-3608			
		CHK T. ELBIN	29SEP2014	NAME Ocean End Feed Applicator			
		APVD U. GUO	29SEP2014	SIZE A1			
		PRODUCT SPEC		CAGE CODE 00779		DRAWING NO. C=2150483	
		APPLICATION SPEC		RESTRICTED TO		REV C	
		WEIGHT		SCALE 1:1		SHEET 4	
		Customer Accessible Production Drawing		OF 4		REV C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION