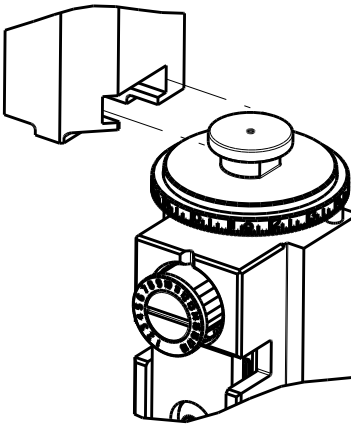
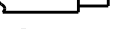
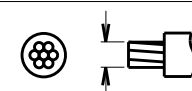
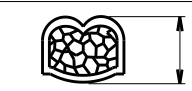


8			7
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150549-1	D	FINE CRIMP HEIGHT ADJUST
	2150549-2	D	FINE CRIMP HEIGHT ADJUST
	2150549-5	D	FINE CRIMP HEIGHT ADJUST
	2150549-6	D	NON-CRIMP HEIGHT ADJUST
	2150549-7	D	FINE CRIMP HEIGHT ADJUST
	7-2150549-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	8.64 mm [.340]	O
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE FASTON .250 SERIES			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.33-6.10 mm [.210-.240 IN]			Ø5.84-7.11 mm [.230-.280 IN]
TERMINAL APPLICATION SPECIFICATION	114-2036	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62998-2			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
8 AWG		3.05+/-0.05 [.120+/- .002]		3.6
2X 12 AWG		2.79+/-0.05 [.110+/- .002]		5.8
10 AWG		2.54+/-0.05 [.100+/- .002]		8.5

- 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: 8-2150549-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150549-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150549-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150549-6
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.
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.
- 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

*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.

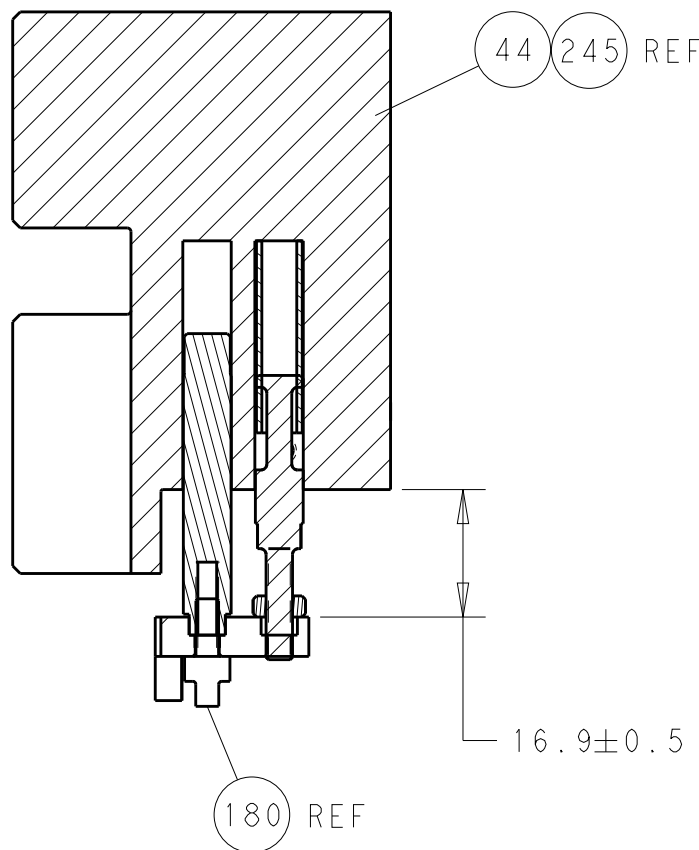
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	1803259-1	BUSHING, FLANGED	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-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)

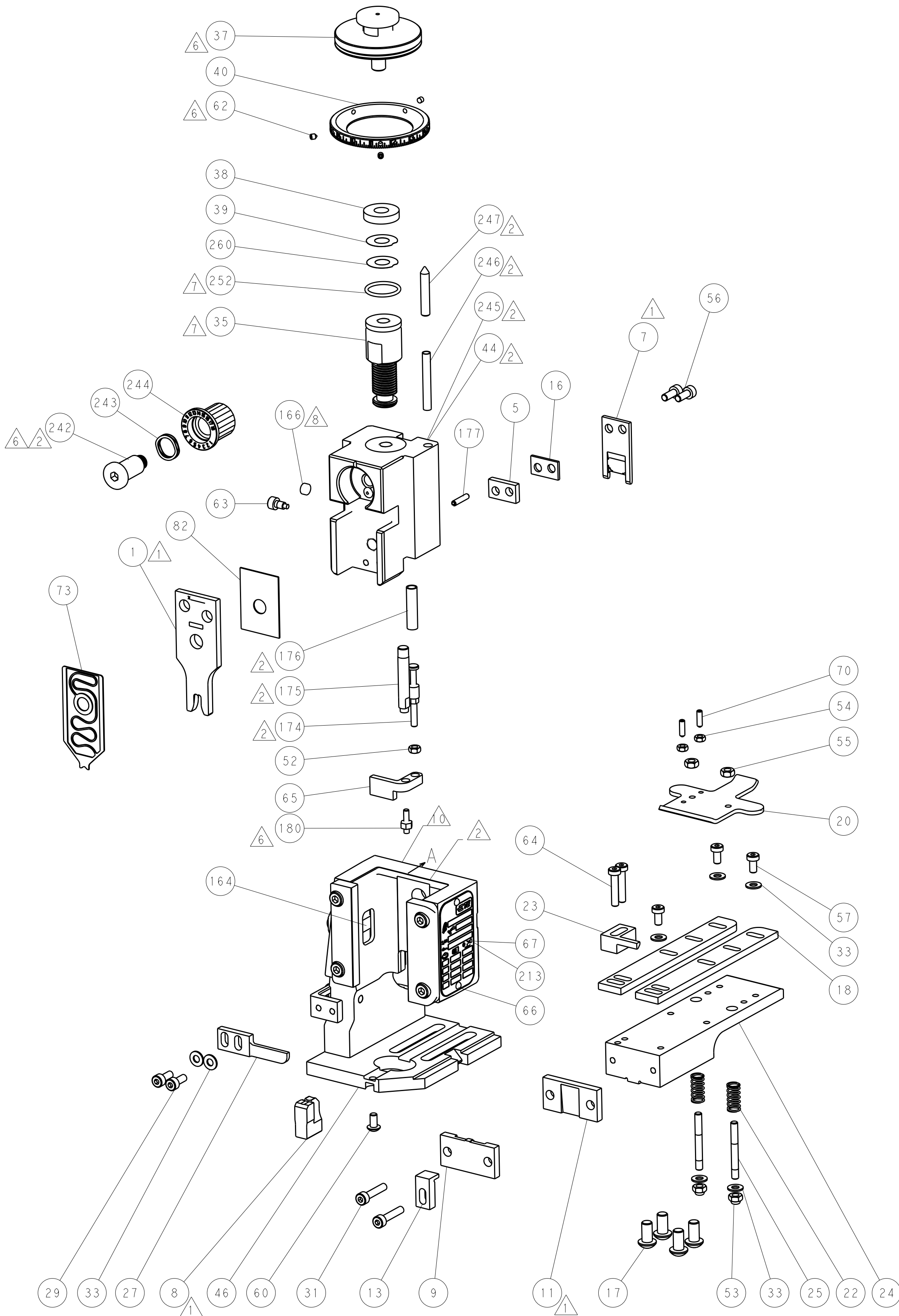
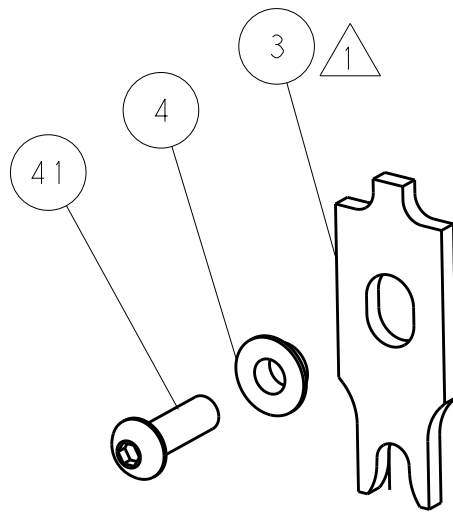
SET UP GAUGE 2119599-2				LOC A	DIST 66	REVISIONS					
		P	LTR	DESCRIPTION			DATE	DWN	APVD		
		A	RELEASED								
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		C	ECR-17-005866			24APR2017	TB	CT			
		D	ECR-18-007996			24MAY2018	AW	CT			
1	1	1	2119083-1			RETAINER, INSULATION DIAL		242			
2	-	-	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	-	-	2119740-2			TAG, IDENTIFICATION		213			
REF	-	-	1901697-1			FEED FINGER ASSEMBLY, EF		183			
1	1	1	1-1976055-1			STANDOFF, HOLD-DOWN		180			
1	1	1	6-993111-6			PIN, SLOTTED SPRING 3.0 X 14.0		177			
1	1	1	8-22280-7			SPRING, COMPRESSION		176			
1	1	1	1752353-2			GUIDE PIN, HOLDDOWN		175			
1	1	1	1901680-2			GUIDE PIN, HOLDDOWN		174			
-	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	-	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	455888-5			SPACER, CRIMPER		82			
1	1	1	2119791-5			DEPRESSOR, WIRE		73			
1	1	1	2119956-2			DOCUMENTATION PACKAGE		71			
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	2168078-1			SCREW, DRIVE, RH, RoHS, 2 x .188		66			
1	1	1	1901681-5			HOLDDOWN, TERMINAL		65			
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 PNT, M3 x 4.0		62			
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	2168400-4			SHCS, LOW HEAD, RoHS, M4 X 8		57			
2	2	2	1-2168083-0			SCR, SKT HD CAP, RoHS, M4 X 10		56			
2	2	2	5018030-2			NUT, HEX, REG, RoHS, M4		55			
2	2	2	5018030-1			NUT, HEX, REG, RoHS, M3		54			
2	2	2	986965-8			NUT, LOCK, HEX, TORQUE (M4)		53			
1	1	1	1-5018030-0			NUT, HEX, REG, RoHS, M3.5		52			
-	1	-	2119792-2			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	2119655-5			APPLICATOR BASIC ASSEMBLY, EF		46			
1	1	1	2119369-1			RAM, AMP STYLE, END FEED		44			
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	2119644-3			RAM WASHER, PRECISION		38			
1	1	1	2119085-1			FA HEAD, ATLANTIC STYLE		37			
1	1	1	2119092-1			BOLT, ADJUSTMENT		35			
7	7	7	1-18028-2			WASHER, FLAT, REG M4		33			
2	2	2	2168083-9			SCR, SKT HD CAP, RoHS, M4 X 20		31			
2	2	2	1-2168083-0			SCR, SKT HD CAP, RoHS, M4 X 10		29			
1	1	1	240639-1			STRIPPER (MACHINING)		27			
2	2	2	1320906-1			STUD, THREADED		25			
1	1	1	1752371-5			PLATE, STRIP GUIDE		24			
1	1	1	240825-5			PLATE, STRIP HOLD DOWN		23			
2	2	2	2-22281-3			SPRING, COMPRESSION		22			
1	1	1	1752373-4			DRAG		20			
2	2	2	1901259-7			GUIDE, LOWER STRIP		18			
4	4	4	1-2079383-1			SCR, BHSC, RoHS (M6 X 12)		17			
1	1	1	6-240641-4			SPACER		16			
1	1	1	1752360-1			SPACER, HOLD-DOWN		13			
1	1	1	240644-9			PLATE, REAR SHEAR		11			
-	-	-	-			-		10			
1	1	1	5-690495-1			PLATE, FRONT SHEAR		9			
1	1	1	1803003-3			ANVIL, COMBINATION, END FEED		8			
1	1	1	2217206-8			BLADE, SLUG		7			
-	-	-	-			-		6			
1	1	1	240641-1			SPACER		5			
1	1	1	3-238009-8			BLOCK, FL CRIMPER SPACER		4			
1	1	1	4-1803018-3			CRIMPER, INSULATION O		3			
-	-	-	-			-		2			
1	1	1	9-1633664-6			CRIMPER, WIRE		1			
-5	-2	-1	PART NO			DESCRIPTION		ITEM NO			

THIS IS SUBJECT TO CHANGE AND NOT BE USED FOR CONSTRUCTION PURPOSES. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. ALWAYS BE CONTACTED FOR THE LATEST REVISION.		DWN J. HOU 10JUN2015	STE TE Connectivity Harrisburg, PA 17105-3608	
CHK L. ZHANG 10JUN2015		NAME Ocean End Feed Applicator		
APVD U. GUO 10JUN2015		PRODUCT SPEC		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		
0 PLC ±		APPLICATION SPEC		
1 PLC ±		WEIGHT		
2 PLC ±		Customer Accessible Production Drawing		
3 PLC ±		SCALE 1:1		
4 PLC ±		SHEET 1 OF 4		
ANGLES FINISH		REV D		

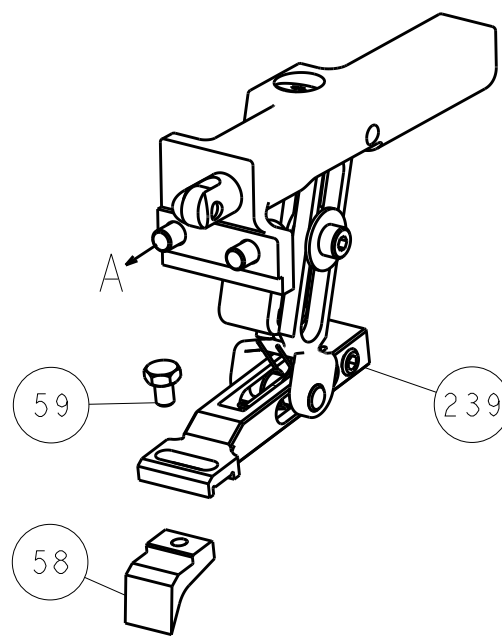
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A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



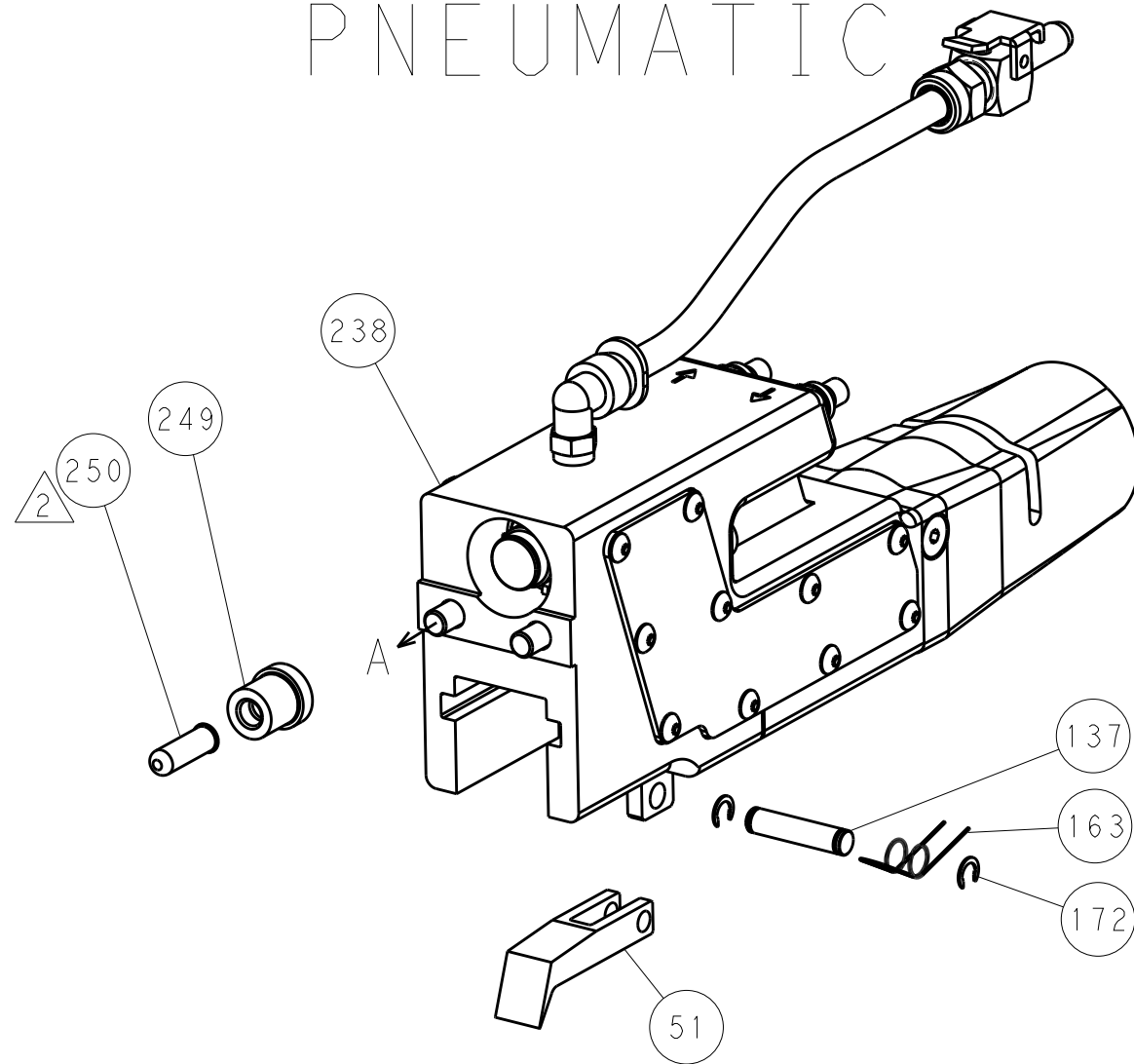
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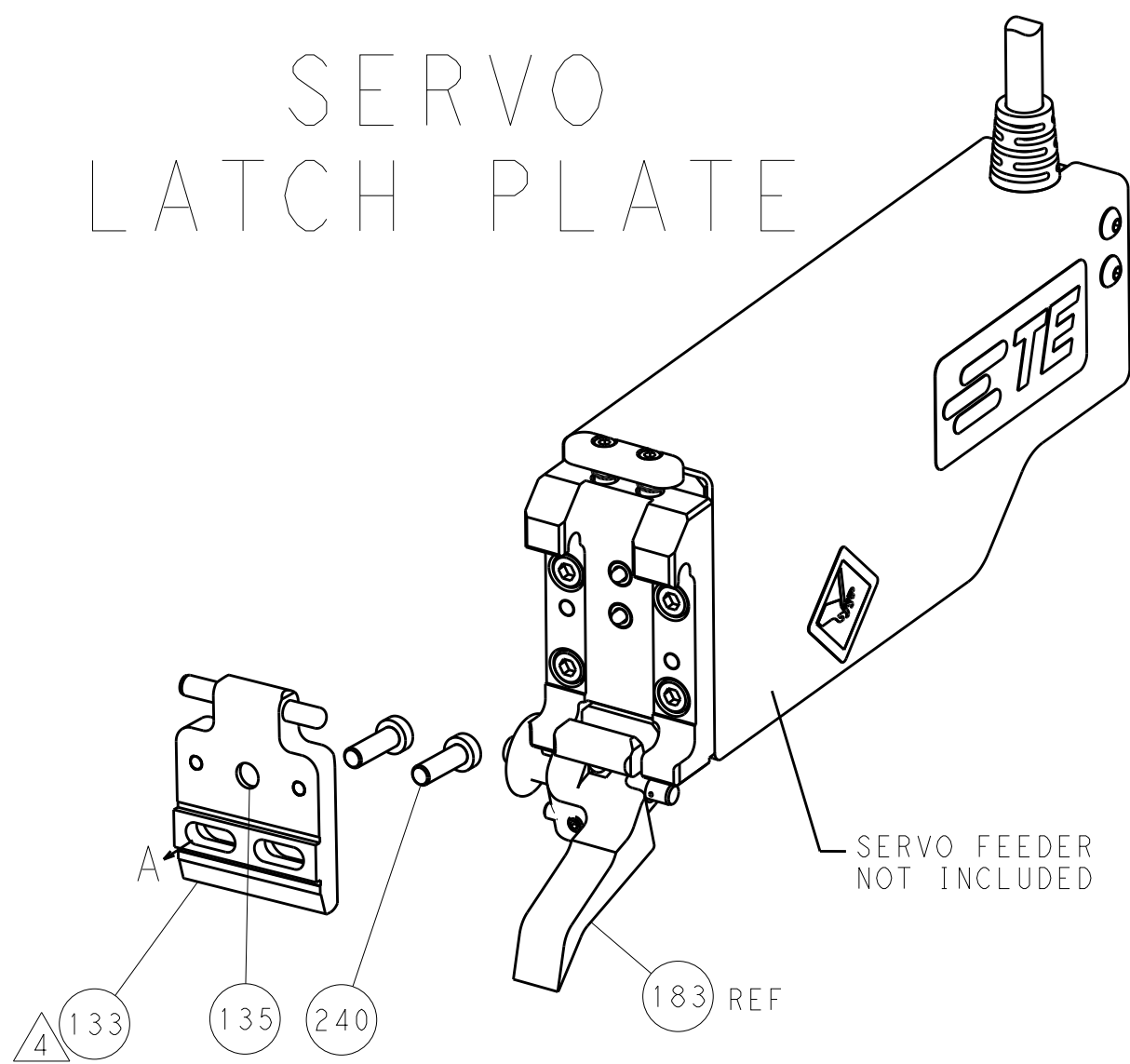
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MECHANICAL



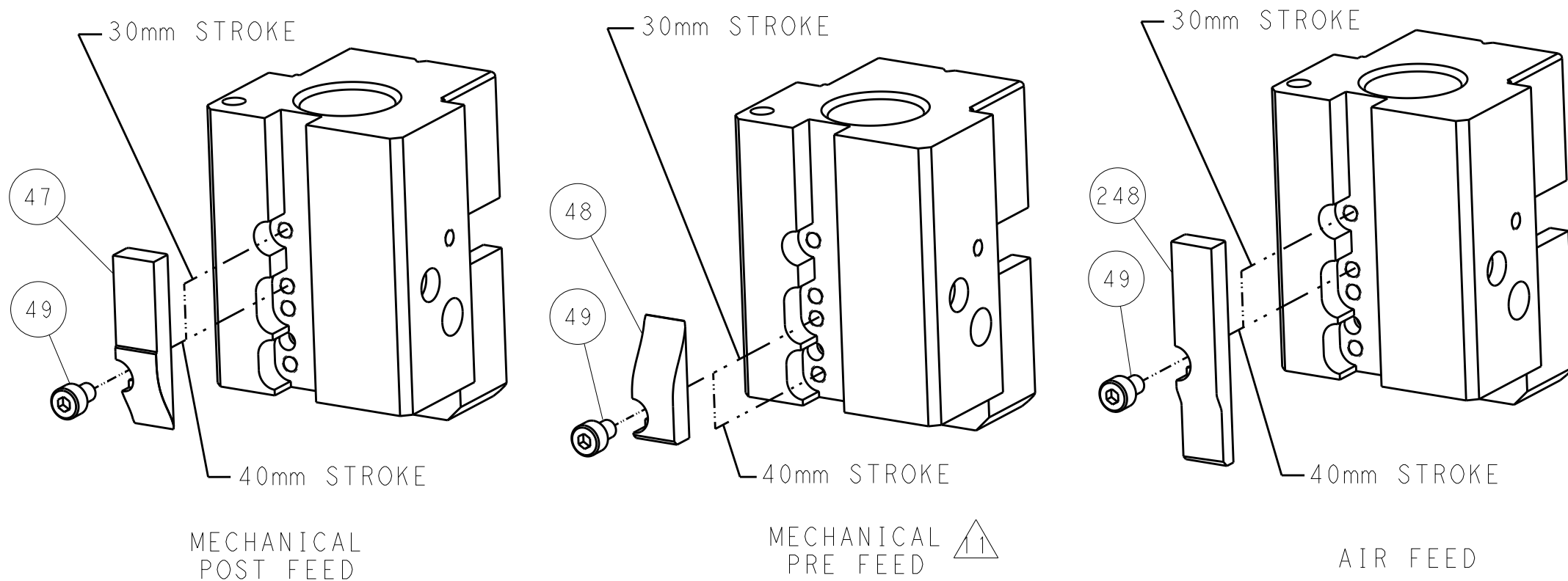
PNEUMATIC



SERVO
LATCH PLATE



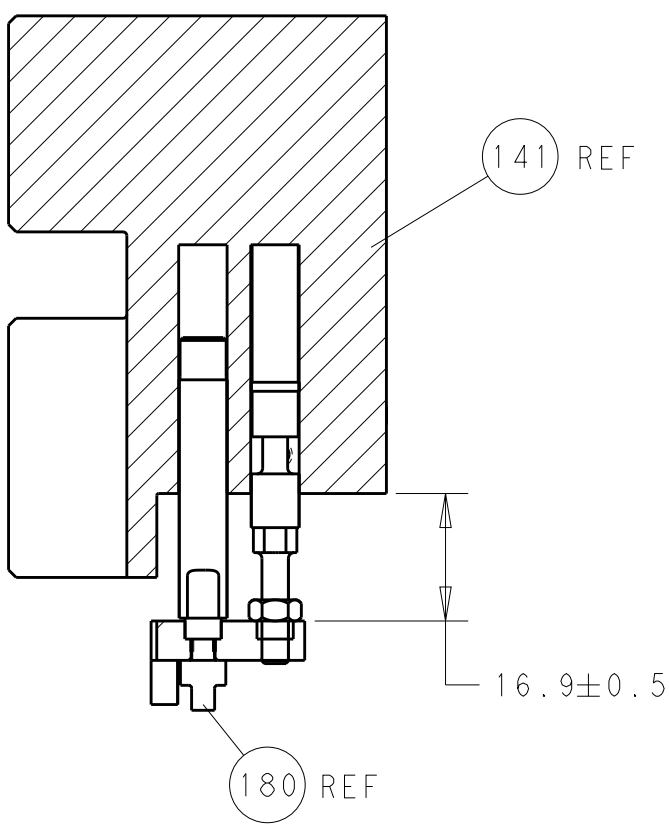
CAM POSITIONS



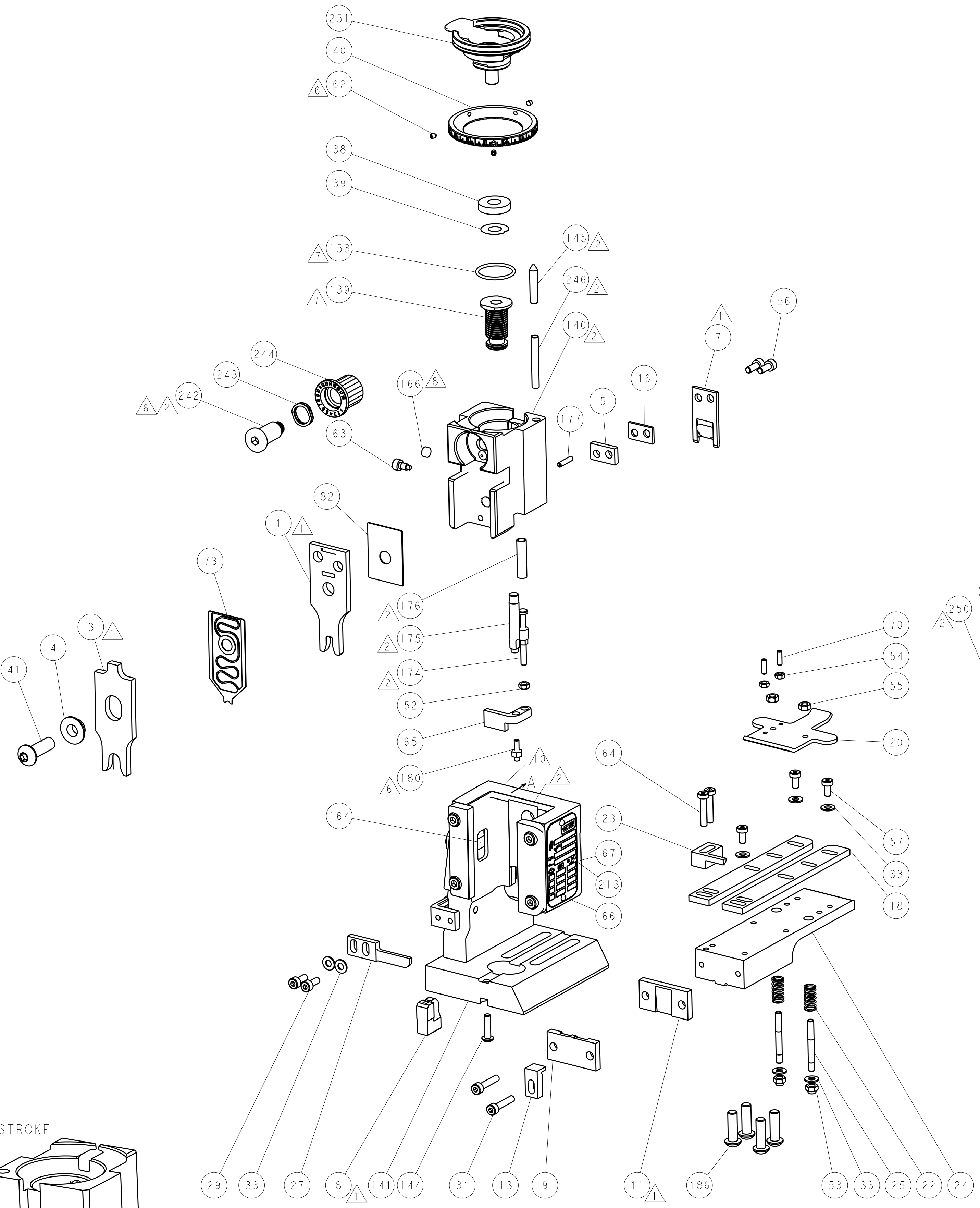
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.		OWN	J. HOU	10JUN2015	TE Connectivity		
		CHK	L. ZHANG	10JUN2015	Harrisburg, PA 17105-3608		
		APVD	J. GUO	10JUN2015	NAME Ocean End Feed Applicator -		
		PRODUCT SPEC					
		APPLICATION SPEC					
		WEIGHT					
		MATERIAL					
		FINISH					
		Customer Accessible Production Drawing		SCALE 1:1			
				SHEET 2 OF 4			
				REV D			

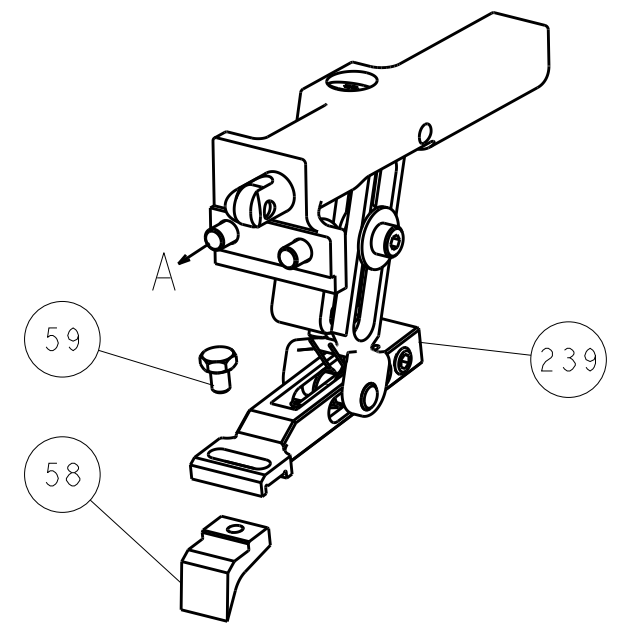
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



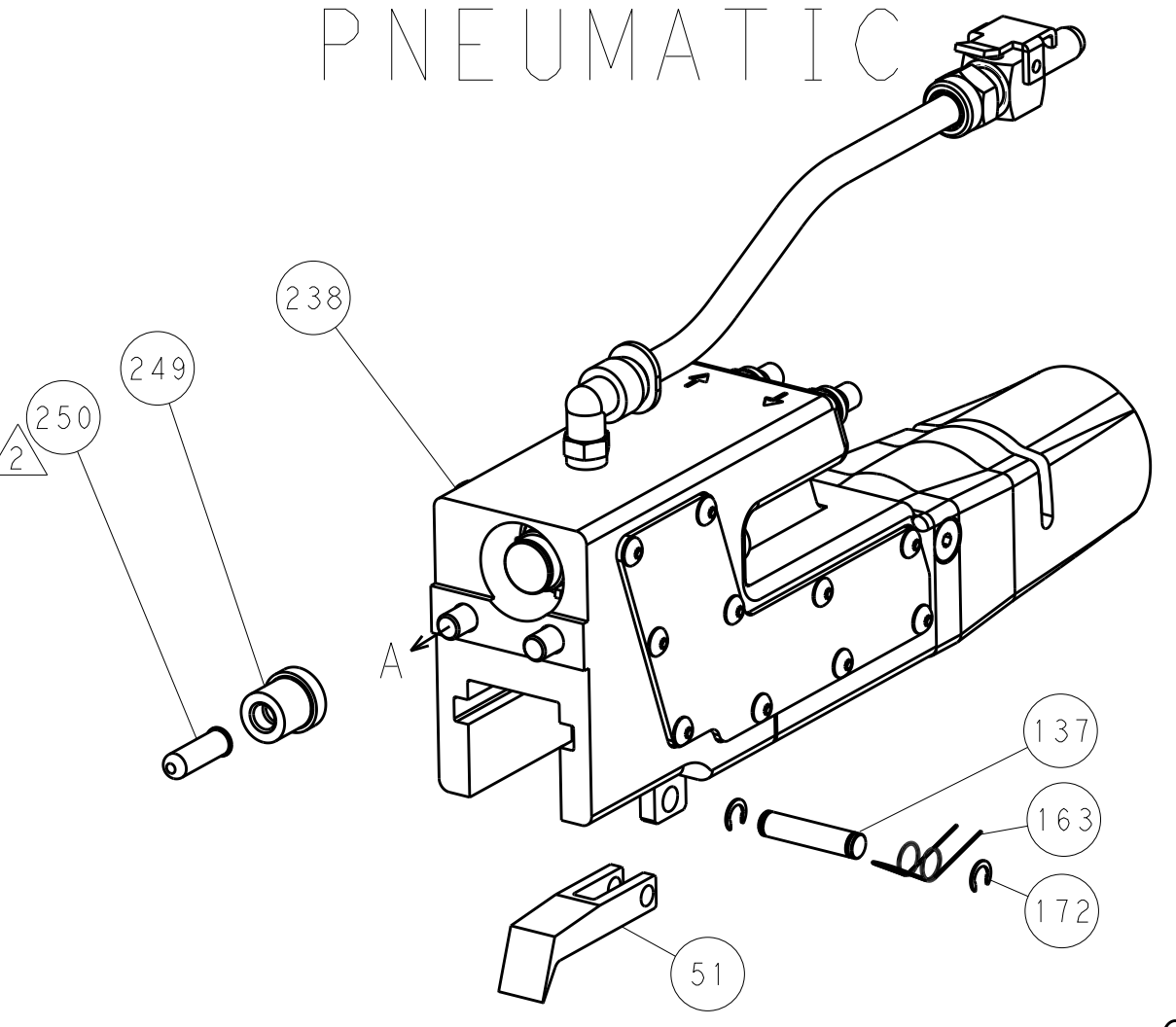
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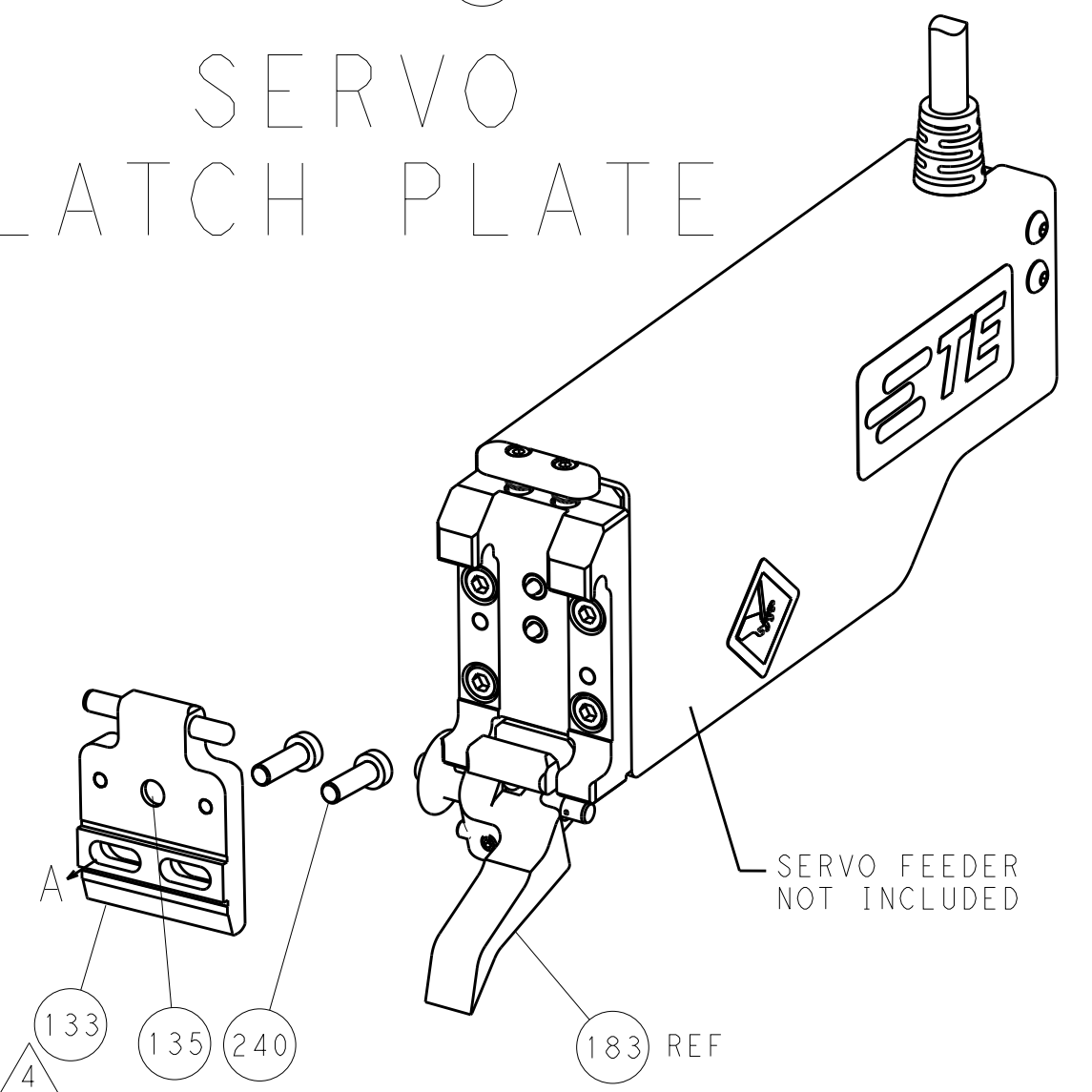
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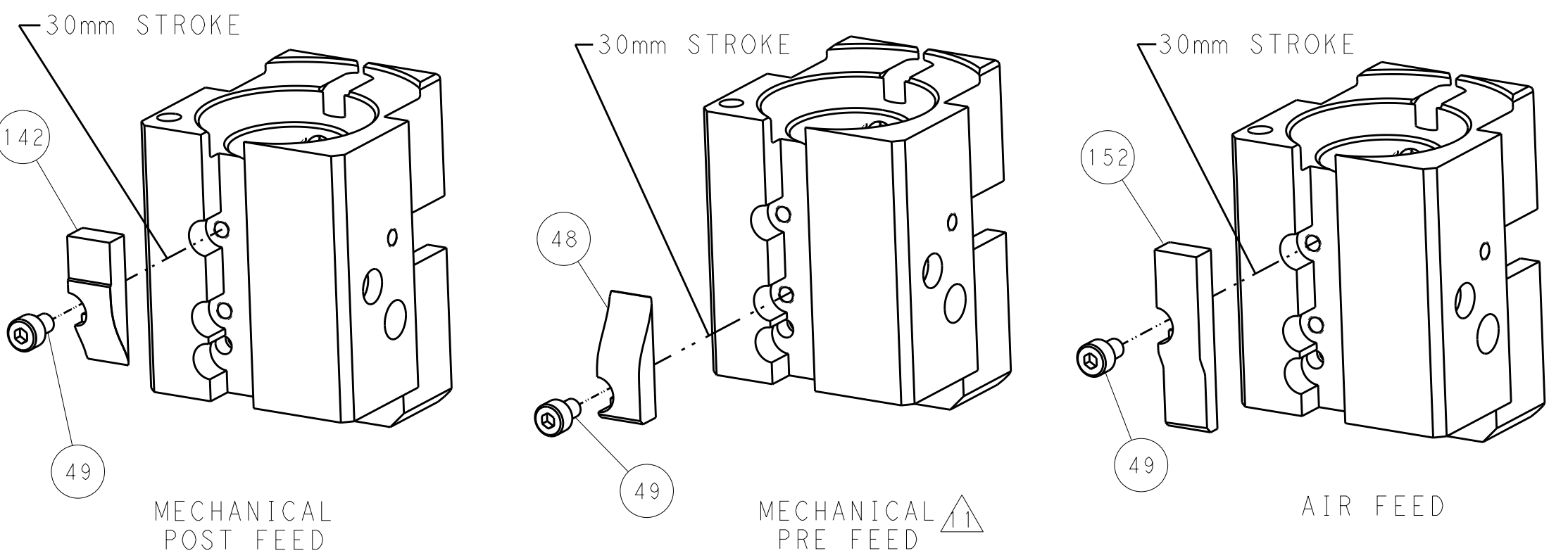
PNEUMATIC



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: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HOU 10JUN2015		CHK L. ZHANG 10JUN2015		APVD U. GUO 10JUN2015		NAME	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		ANGLES FINISH	
MATERIAL		WEIGHT		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 4 OF 4		REV D		00779		C=2150549	
TE Connectivity		Harrisburg, PA 17105-3608		Ocean End Feed		Applicator		-		-	