

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
	2150369-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	2063961-1	-	-	-	-	
	2150369-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150369-5	-	-	2168400-7 (QUANTITY 2)	
	2150369-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	-	-	2063961-1	-	-	-	
	2150369-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
	7-2150369-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTIN-FASTON RECEPTACLE SERIE 9.5			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.80-5.60 mm [.189-.220 IN]		Ø2.40-3.70 mm [.094-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
962835-1	962835-2	962835-3	8-962835-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.18 +/- 0.05 [.086 +/- .002]	4.8
2.00mm2	2.05 +/- 0.05 [.081 +/- .002]	6.4
1.50mm2	1.92 +/- 0.05 [.076 +/- .002]	7.8

- 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: 8-2150369-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150369-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150369-6
- 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. 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 ITEMS 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.
- 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.

***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.

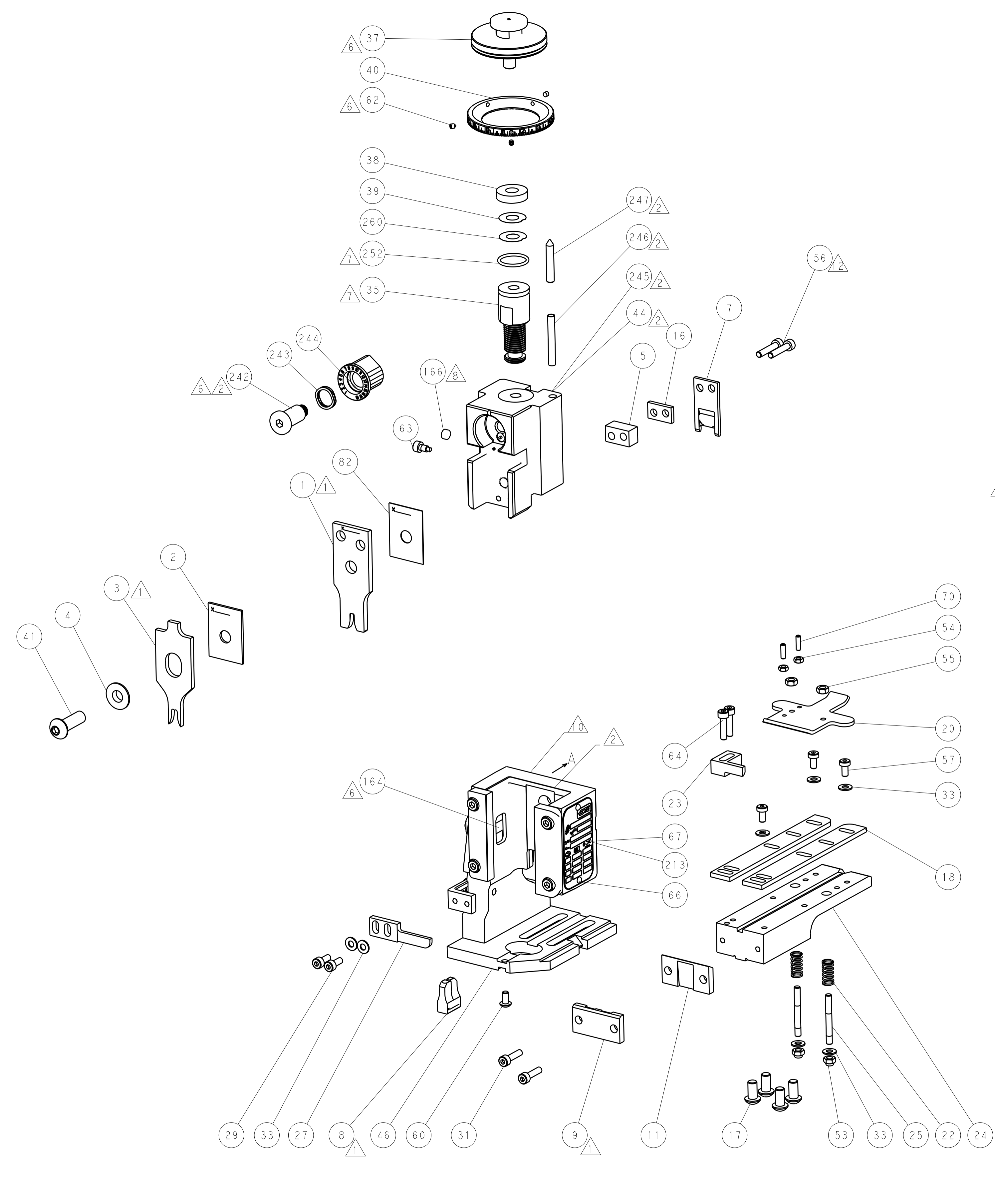
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-2		A	66	REV	DATE	BY	APPV
A	RELEASED				05NOV2013	BH	GB
B	ECR-16-001409				29JAN2016	JH	CT

-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260	
-	-	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	2119798-1	DETENT PIN	247	
-	1	-	-	1	1-22279-3	SPRING, COMPRESSION	246	
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245	
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
-	-	-	-	1	2063440-2	AIR FEED MODULE	238	
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213	
-	-	REFREF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183	
-	-	-	-	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	-	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 POINT 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	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	64	
-	1	-	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
-	3	-	-	3	992763-5	SCR, SET, SOC, CONE POINT, 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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	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	2079383-7	SCR, BHSC, RoHS (M8 X 25)	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752371-6	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-1	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	240641-7	SPACER	16	
-	1	1	1	1	240833-7	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	1-690482-2	PLATE, FRONT SHEAR	9	
-	1	1	1	1	1333220-4	ANVIL, COMBINATION, .120	8	
-	1	1	1	1	2217206-8	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	5-240641-7	SPACER	5	
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4	
-	1	1	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	1-455888-4	SPACER, CRIMPER	2	
-	1	1	1	1	456409-3	CRIMPER, WIRE .120 "F" PREMIUM	1	
-	77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

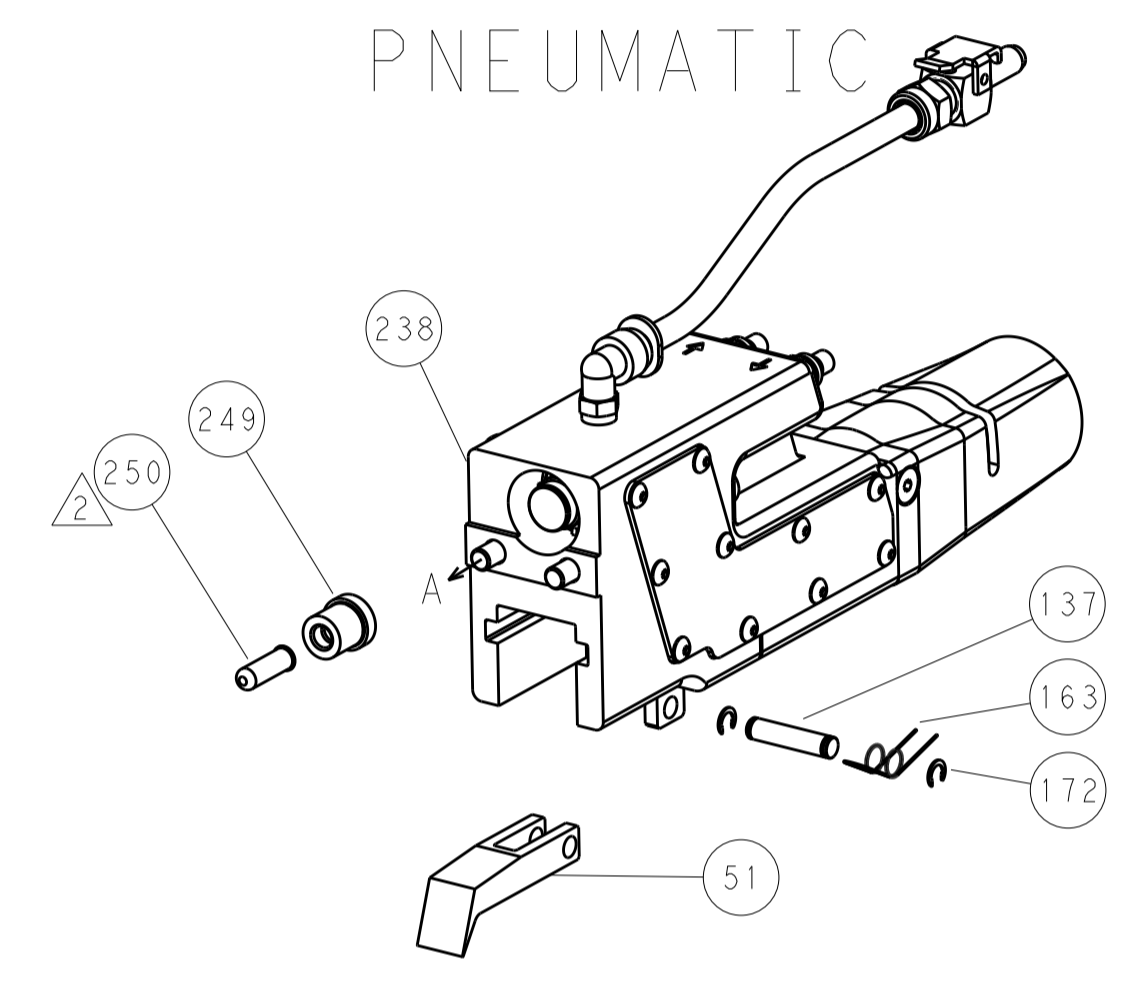
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Customer Accessible Production Drawing		SCALE 1:1		SHEET 1 OF 4		REV B					

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

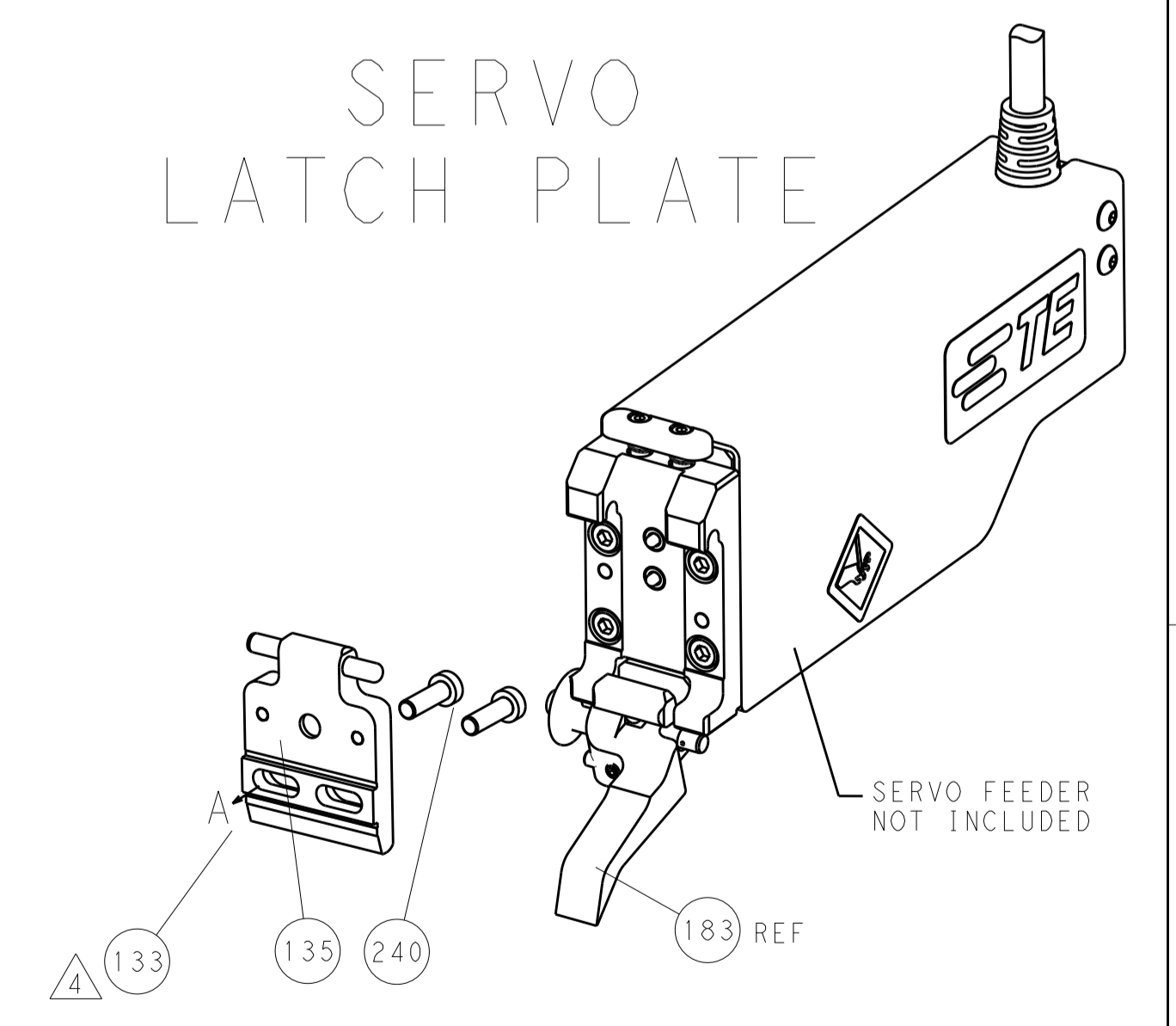


FEED TYPE

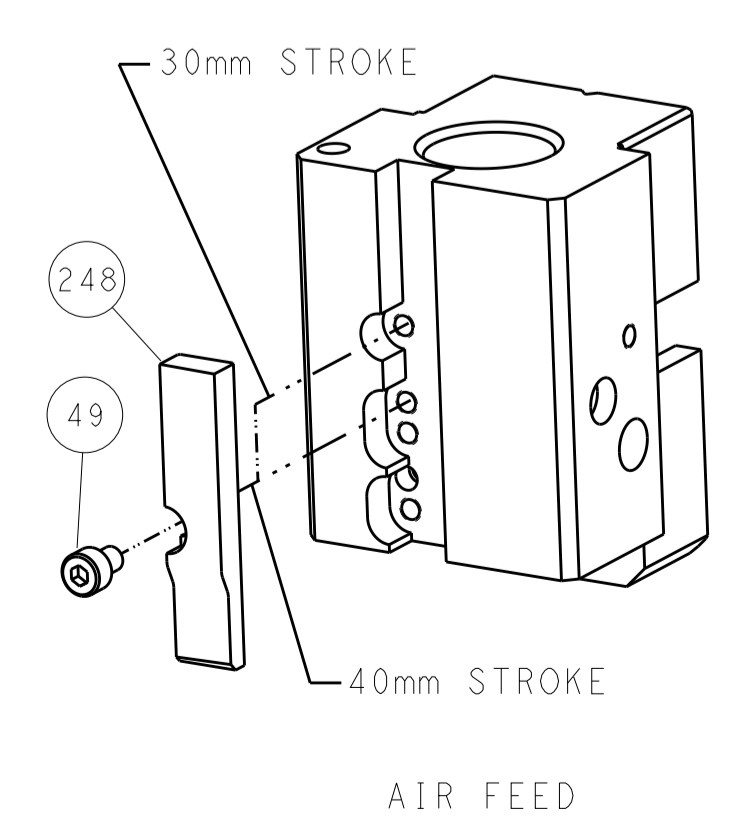
PNEUMATIC



SERVO LATCH PLATE

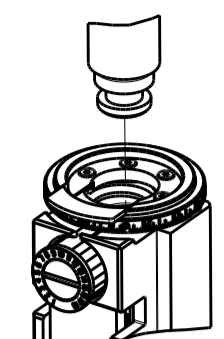


CAM POSITIONS

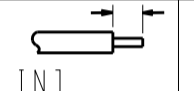


ATLANTIC VERSION
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 (Pacific version shown on sheets 3 of 4 & 4 of 4)







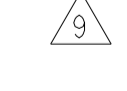


DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: K. STAKEM 27SEPT2013		TE Connectivity	
mm	0 PLC	±		CHK: G. BAILEY 27SEPT2013	NAME: Ocean End Feed Applier		TE Connectivity Harrisburg, PA 17105-3608
	1 PLC	±		APPV: T. ELBIN 27SEPT2013	RESTRICTED TO		
	2 PLC	±		PRODUCT SPEC	SCALE: 1:1		SHEET 2 OF 4
	3 PLC	±		APPLICATION SPEC	REV: B		
	4 PLC	±		WEIGHT	CAGE CODE: A1100779		DRAWING NO: C-2150369
MATERIAL:	FINISH:			Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV B	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150369-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	2063961-1	-	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150369-5	-	2168400-7 (QUANTITY 2)
	2-2150369-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	2063961-1	-	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	2063440-2
2-2150369-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150369-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm (.120)	F
INSUL	4.57 mm (.180)	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FASTIN-FASTON RECEPTACLE SERIE 9.5			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.80-5.60 mm (.189-.220 IN)		∅2.40-3.70 mm (.094-.146 IN)	
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
TERMINALS APPLIED ⁹			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
962835-1	962835-2	962835-3	8-962835-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
2.50mm2	2.18+/-0.05 [.086+/-0.002]	4.8
2.00mm2	2.05+/-0.05 [.081+/-0.002]	6.4
1.50mm2	1.92+/-0.05 [.076+/-0.002]	7.8

-  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: 8-2150369-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150369-5
- 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.
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
-  CUT TO LENGTH AT ASSEMBLY.

***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.

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

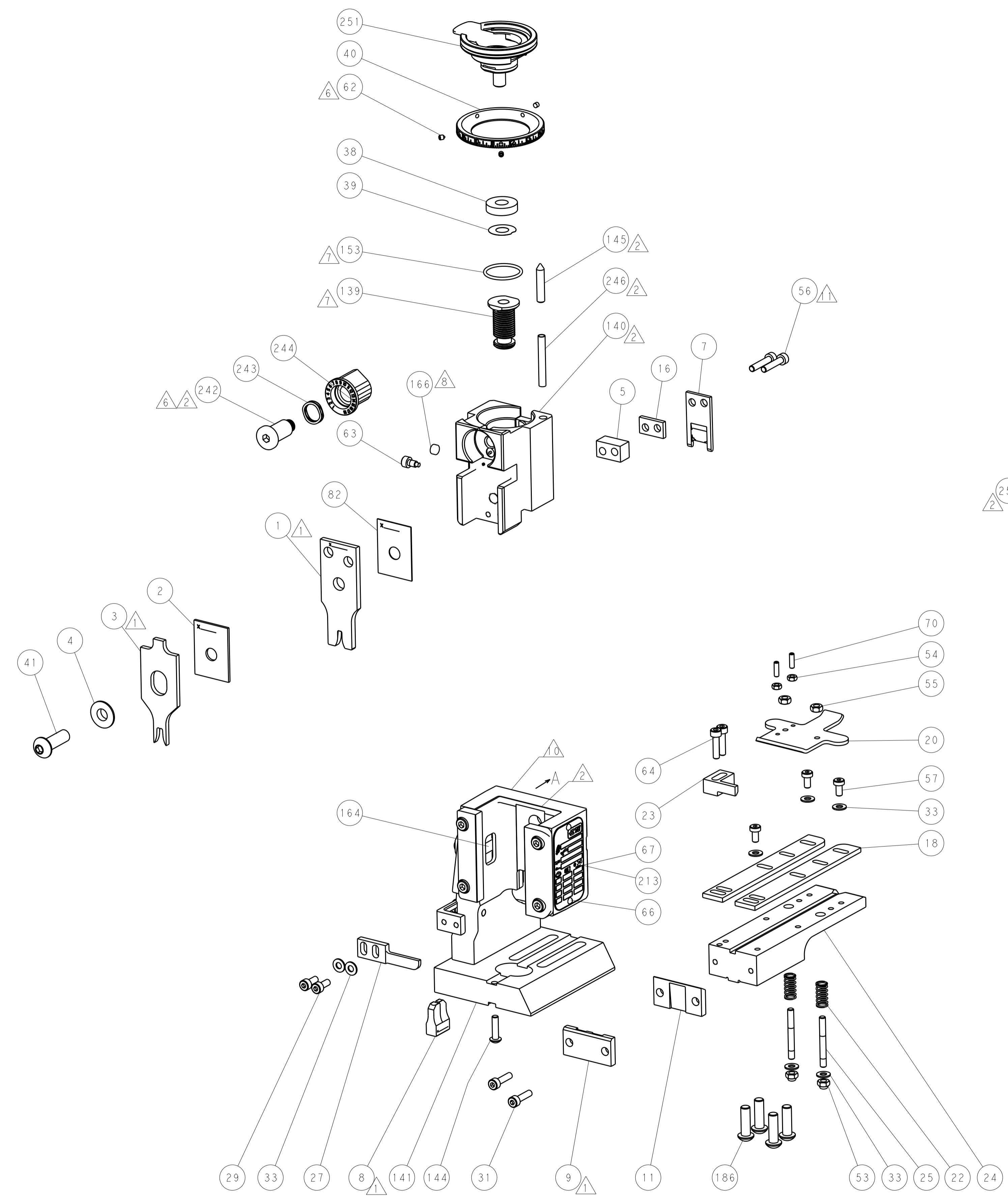
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
-	-	-	SEE SHEET 1	-	-	-

-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251	
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250	
-	-	-	1	2079988-1	BUSHING, LCHS-12, MISUMI	249	
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
-	-	-	1	2063440-2	AIR FEED MODULE	238	
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213	
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183	
-	-	-	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	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153	
-	-	-	1	2119641-2	FEED CAM, AIR FEED	152	
-	1	1	1	2119798-2	DETENT PIN	145	
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140	
-	1	1	1	2119092-2	BOLT, ADJUSTMENT	139	
-	-	-	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	455888-4	SPACER, CRIMPER	82	
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71	
-	2	2	2	2-18032-2	SCR, SET, FLT POINT 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	
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	64	
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62	
-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	2119792-2	PAWL, EF, AIR	51	
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	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	2119644-2	RAM WASHER, PRECISION	38	
-	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752371-6	PLATE, STRIP GUIDE	24	
-	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1752373-4	DRAG	20	
-	2	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	1	1	1	240641-7	SPACER	16	
-	1	1	1	240833-7	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	10	
-	1	1	1	1-690482-2	PLATE, FRONT SHEAR	9	
1	1	1	1	1333220-4	ANVIL, COMBINATION, .120	8	
-	1	1	1	2217206-8	BLADE, SLUG	7	
-	-	-	-	-	-	6	
-	1	1	1	5-240641-7	SPACER	5	
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4	
1	1	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1-455888-4	SPACER, CRIMPER	2	
1	1	1	1	456409-3	CRIMPER, WIRE .120 "F" PREMIUM	1	
-	77	27	25	22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	STAKEM	27SEPT2013	G. BAILEY	27SEPT2013	TE Connectivity	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
-		-		-		A1		00779		C=2150369	
Customer Accessible Production Drawing										SCALE 1:1 SHEET 3 OF 4 REV B	

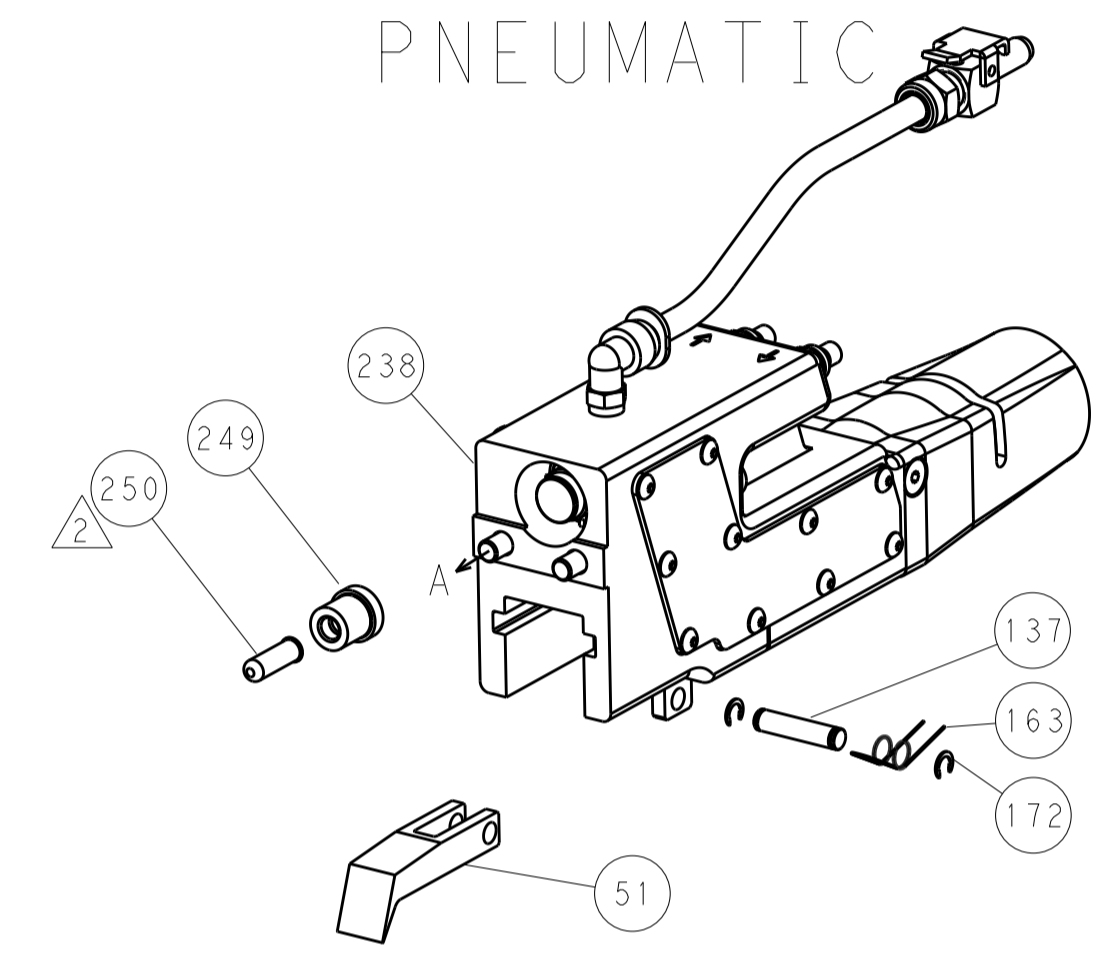
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A	66				

REVISIONS			
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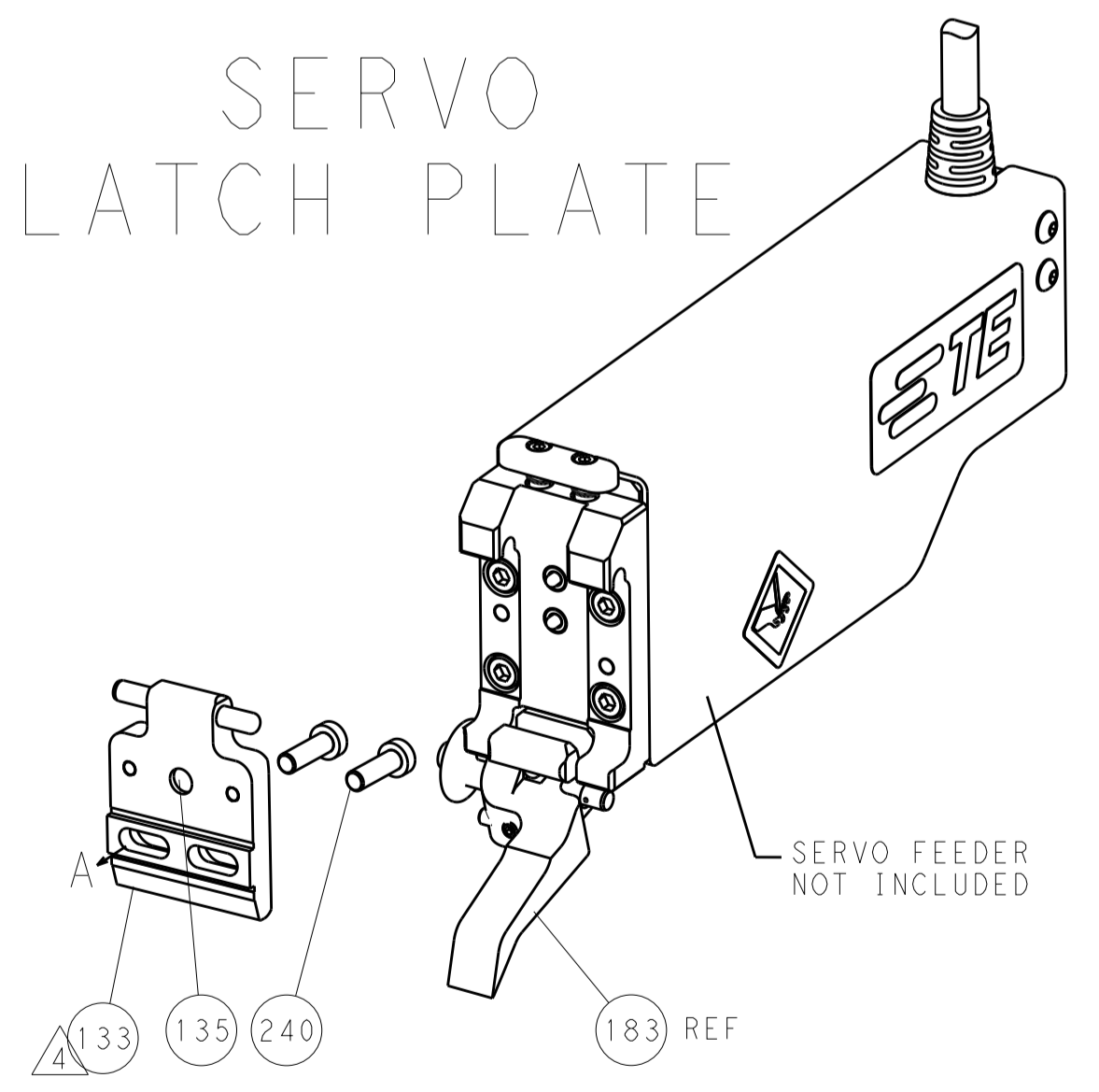


FEED TYPE

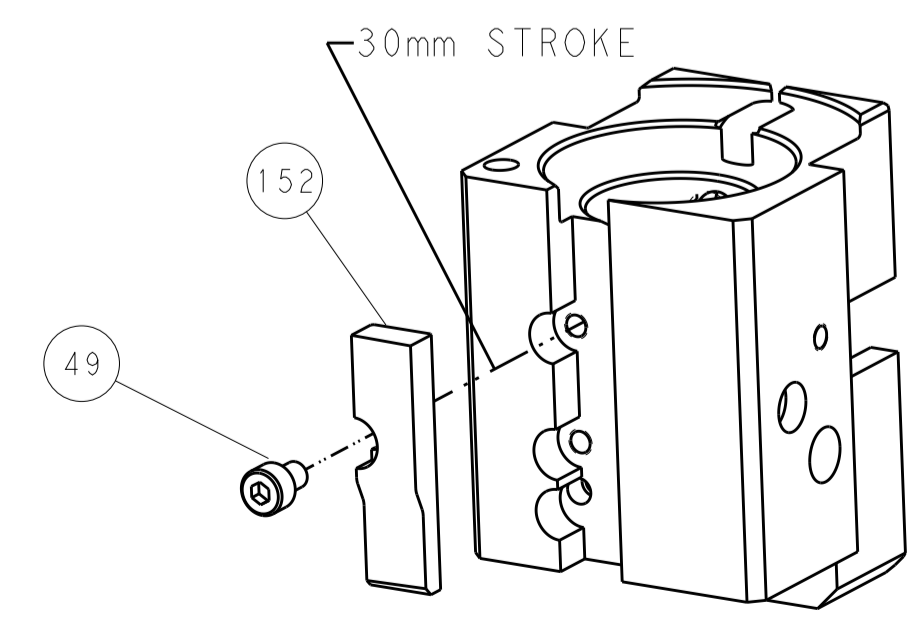
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



AIR FEED

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:		OWN: STAKEM 27SEPT2013	STE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: G. BAILEY 27SEPT2013	
MATERIAL:	FINISH:	3 PLC ±	4 PLC ±	APVD: T. ELBIN 27SEPT2013	NAME: Ocean End Feed Applier
		ANGLES ±		PRODUCT SPEC:	
		WEIGHT:	SCALE: 1:1	SHEET: 4	REV: B
		Customer Accessible Production Drawing		RESTRICTED TO:	