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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150331-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150331-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
2150331-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE
2150331-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE
2150331-7	A	FINE CRIMP HEIGHT ADJUST	NONE
7-2150331-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.79 mm [.110]	OV

APPL INSTRUCTIONS 408-10390

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .250 SER. FASTIN-ON REC.

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.80-5.60 mm [.189-.220 IN]	Ø1.19-2.41 mm [.047-.095 IN]

TERMINAL APPLICATION SPECIFICATION 114-3118

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
338052-4	160844-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.57 +/- 0.05 [.062 +/- .002]	8.7
1.00mm2	1.52 +/- 0.05 [.060 +/- .002]	9.1
0.75mm2	1.47 +/- 0.05 [.058 +/- .002]	9.7
0.50mm2	1.42 +/- 0.05 [.056 +/- .002]	10.1

- 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: 8-2150331-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150331-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150331-5
 - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150331-6
- 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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
- 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.

-77	-7	-6	-5	-2	-1	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)

LOC	DIST	REVISIONS
A	66	
		DESCRIPTION
		DATE
		OWN
		APPV

QTY	LTN	DESCRIPTION	DATE	OWN	APPV
-	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252	
-	-	2119640-1	PUSH ROD, AIR FEED	250	
-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249	
-	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	2119798-1	DETENT PIN	247	
-	1	1-22279-3	SPRING, COMPRESSION	246	
-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245	
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	2063440-1	AIR FEED MODULE	238	
-	-	2119740-2	TAG, IDENTIFICATION	213	
-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183	
-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
-	-	994970-2	COUNTER, MAGNETIC	164	
-	-	240638-1	SPRING, FEED FINGER	163	
-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
-	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	455888-4	SPACER, CRIMPER	82	
-	1	2119791-9	DEPRESSOR, WIRE	73	
-	1	2119956-2	DOCUMENTATION PACKAGE	71	
-	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
-	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62	
-	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60	
-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	2063961-1	FEED FINGER	58	
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56	
-	2	5018030-2	NUT, HEX, REG, RoHS, M4	55	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	-	2119792-2	PAWL, EF, AIR	51	
-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	2119652-1	FEED CAM, PRE FEED	48	
-	-	2119653-1	FEED CAM, POST FEED	47	
-	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	2119369-1	RAM, AMP STYLE, END FEED	44	
-	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1-2119644-2	RAM WASHER, PRECISION	38	
-	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
-	1	2119092-1	BOLT, ADJUSTMENT	35	
-	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-	1	240639-1	STRIPPER (MACHINING)	27	
-	2	1320906-1	STUD, THREADED	25	
-	1	1752371-3	PLATE, STRIP GUIDE	24	
-	1	240825-4	PLATE, STRIP HOLD DOWN	23	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1752373-4	DRAG	20	
-	2	1901259-4	GUIDE, LOWER STRIP	18	
-	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	240833-2	PLATE, REAR SHEAR	11	
-	-	-	-	10	
-	1	2-690482-9	PLATE, FRONT SHEAR	9	
-	1	4-1333217-1	ANVIL, EF .090	8	
-	1	1-2217206-4	BLADE, SLUG	7	
-	-	-	-	6	
-	1	6-240641-5	SPACER	5	
-	1	238009-1	BLOCK, FL CRIMPER SPACER	4	
-	1	1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	455888-2	SPACER, CRIMPER	2	
-	1	4-456406-5	CRIMPER, WIRE PREMIUM	1	

TE Connectivity
Harrisburg, PA 17105-3608

STE

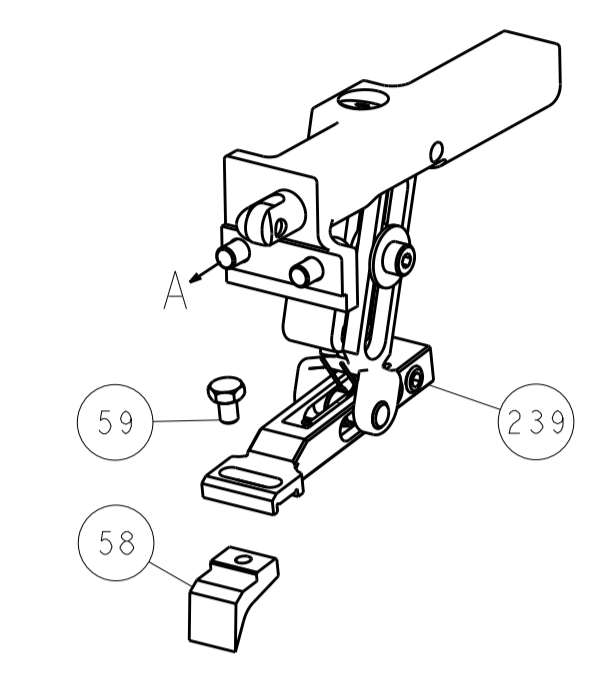
Ocean End Feed Applicator

Customer Accessible Production Drawing

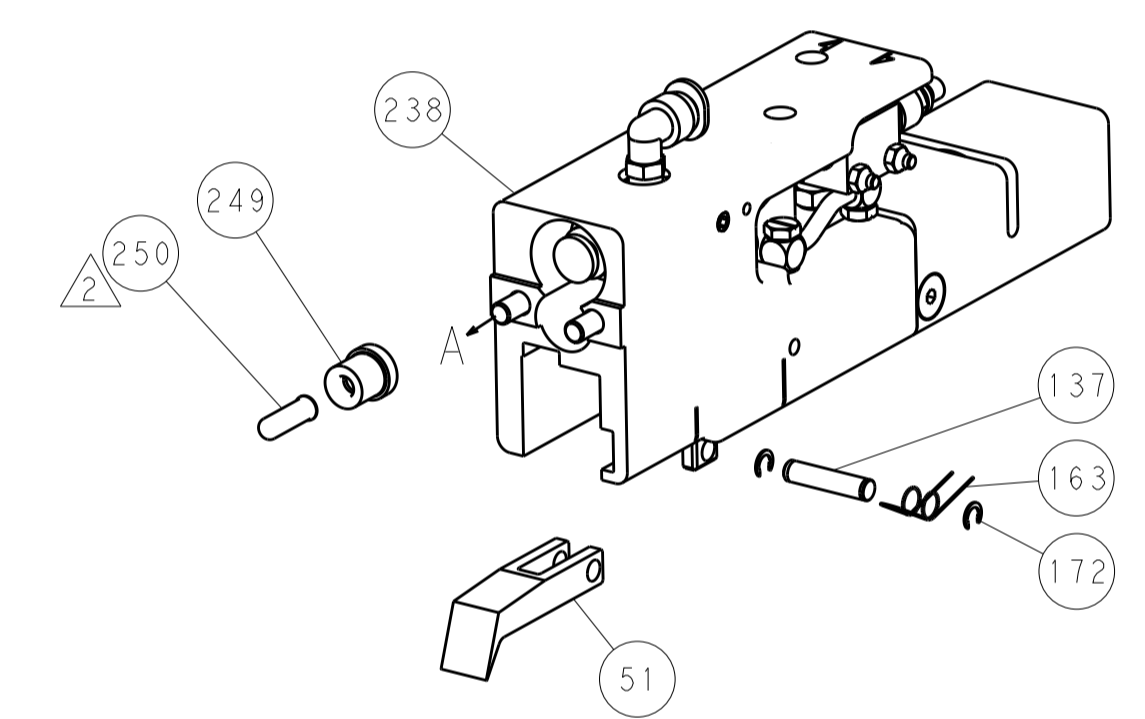
SCALE 1:1 SHEET 1 OF 4 REV A

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

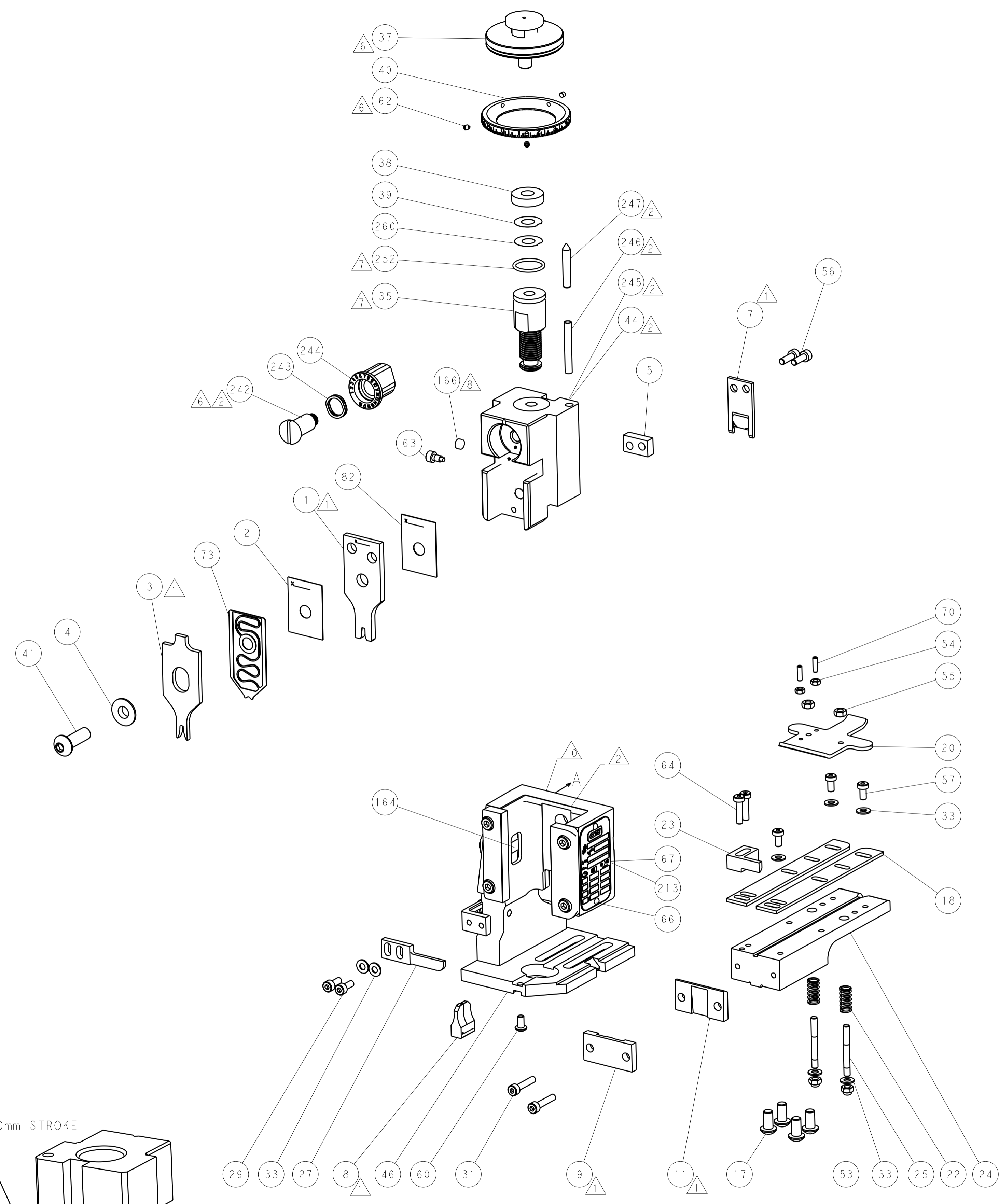
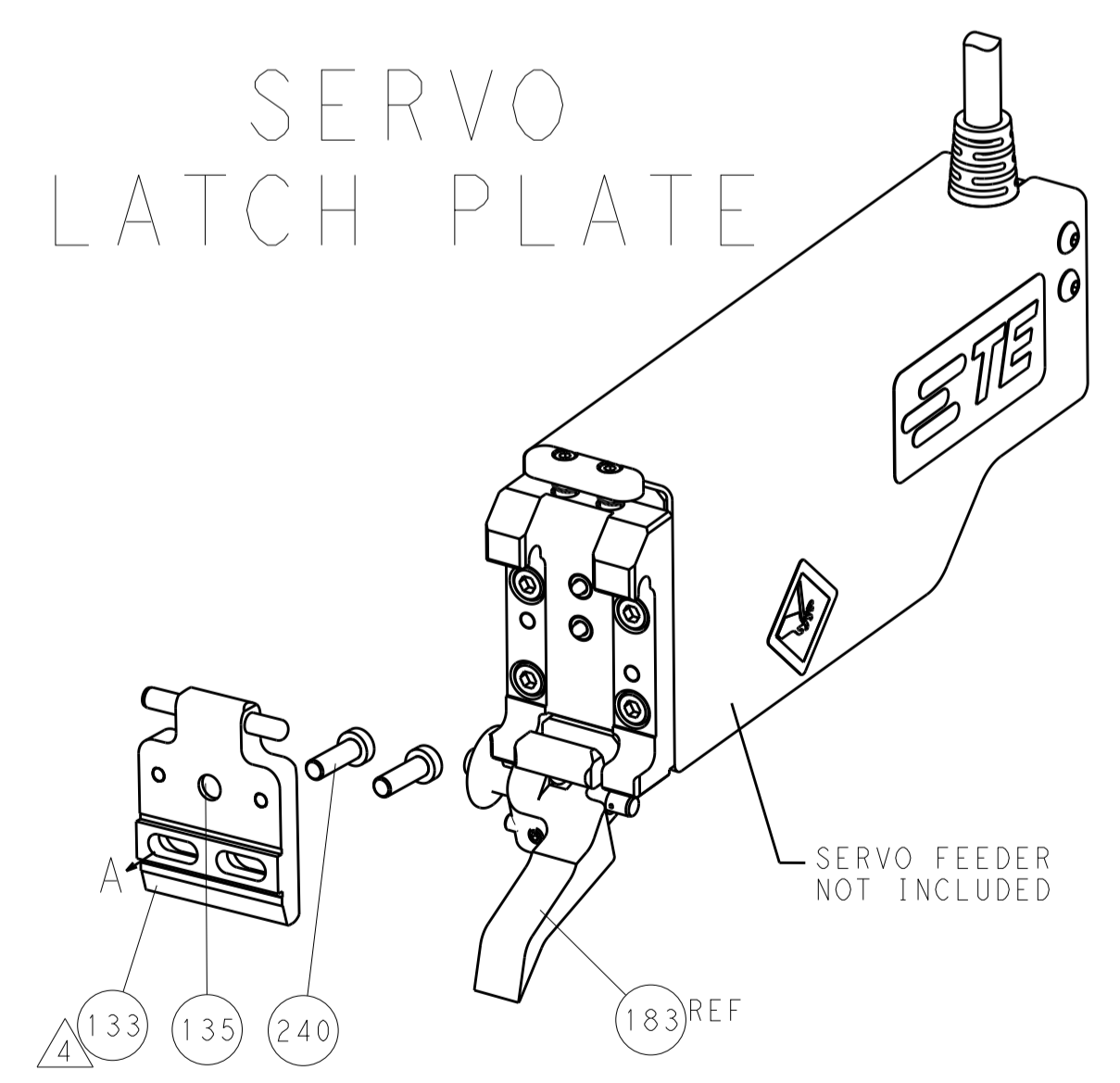
FEED TYPE MECHANICAL



PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS

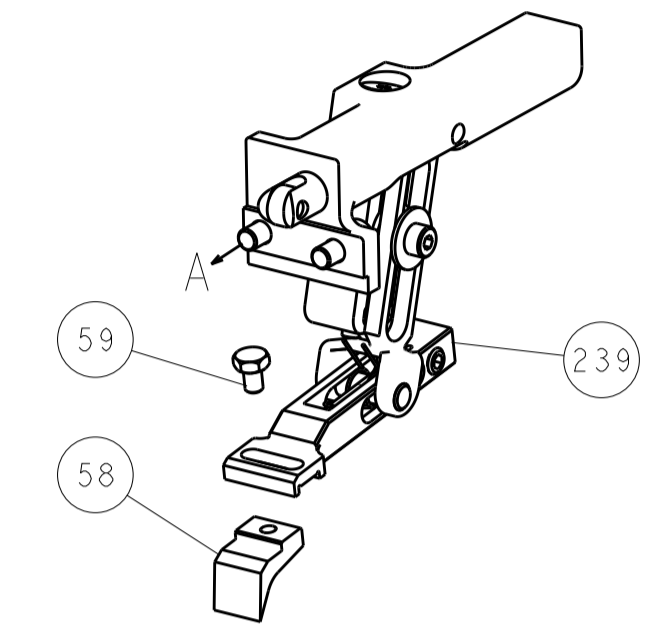


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

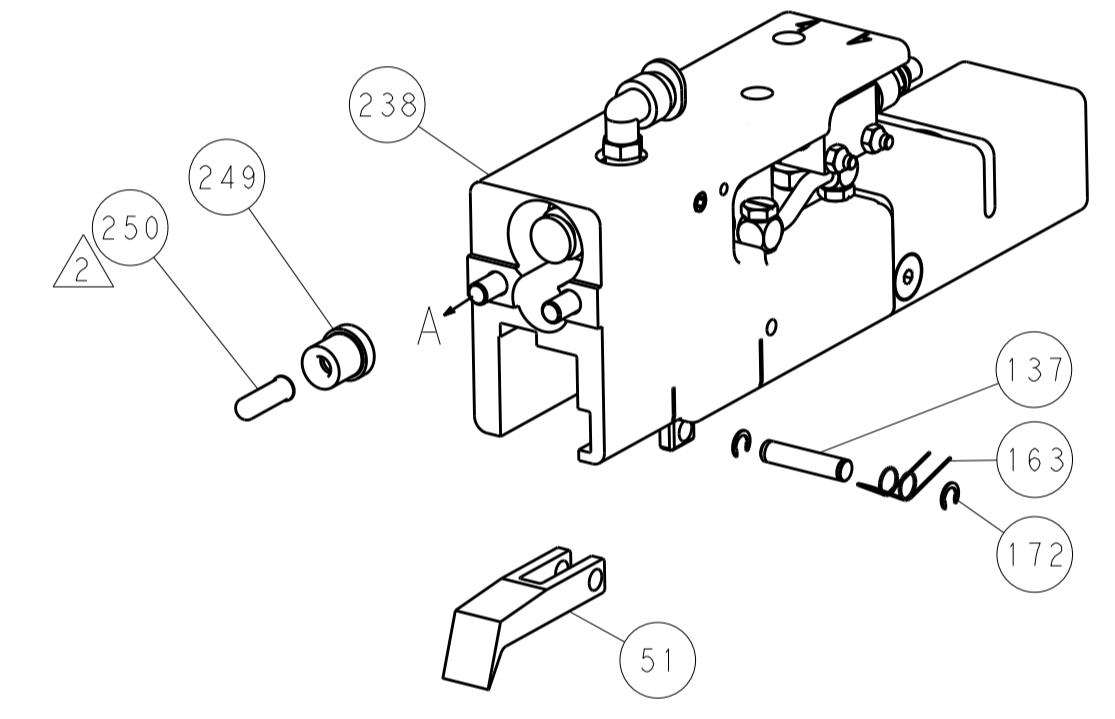
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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150331 RESTRICTED TO:
MATERIAL:		FINISH:	SCALE: 1:1 SHEET: 2 OF 4 REV: A

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

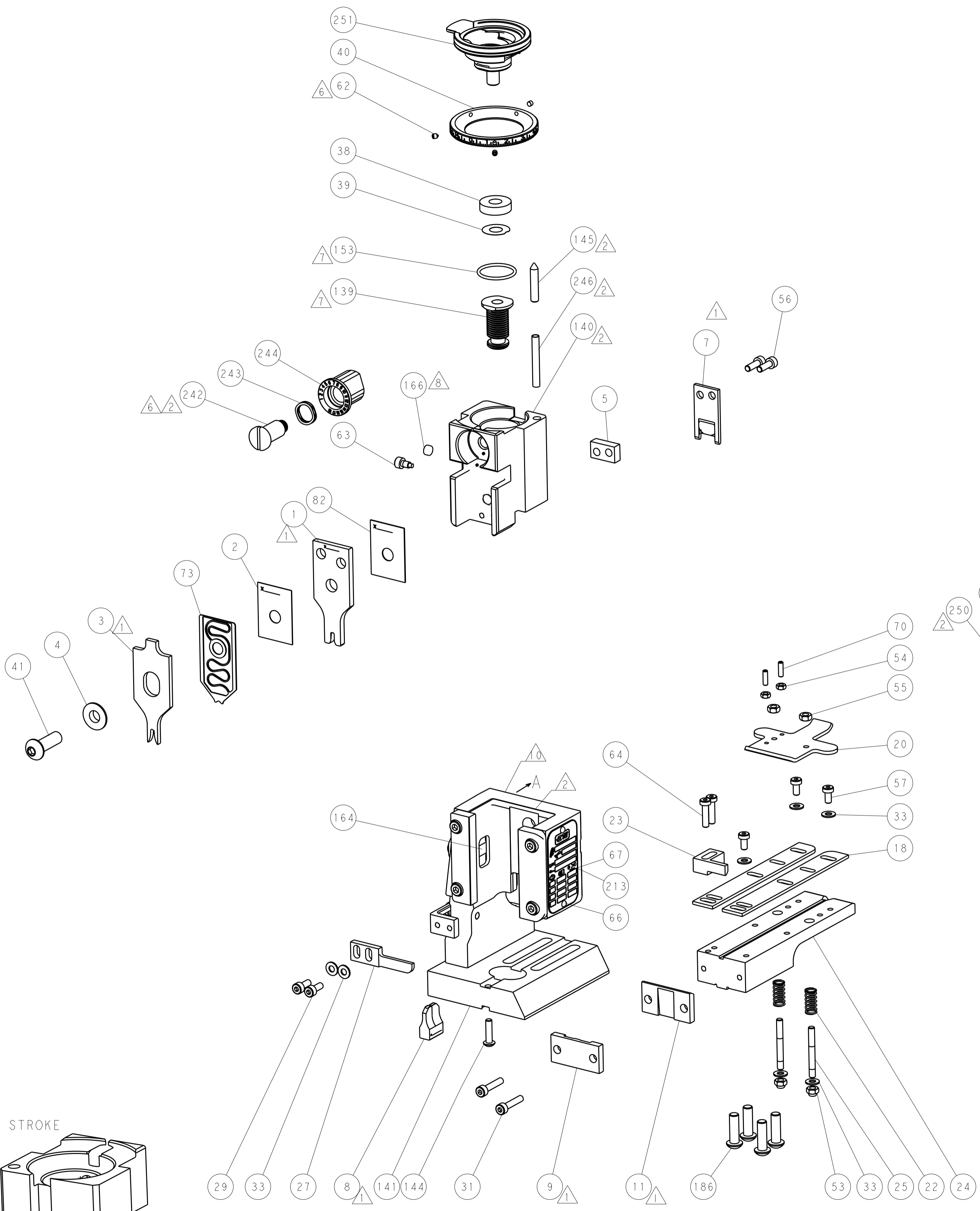
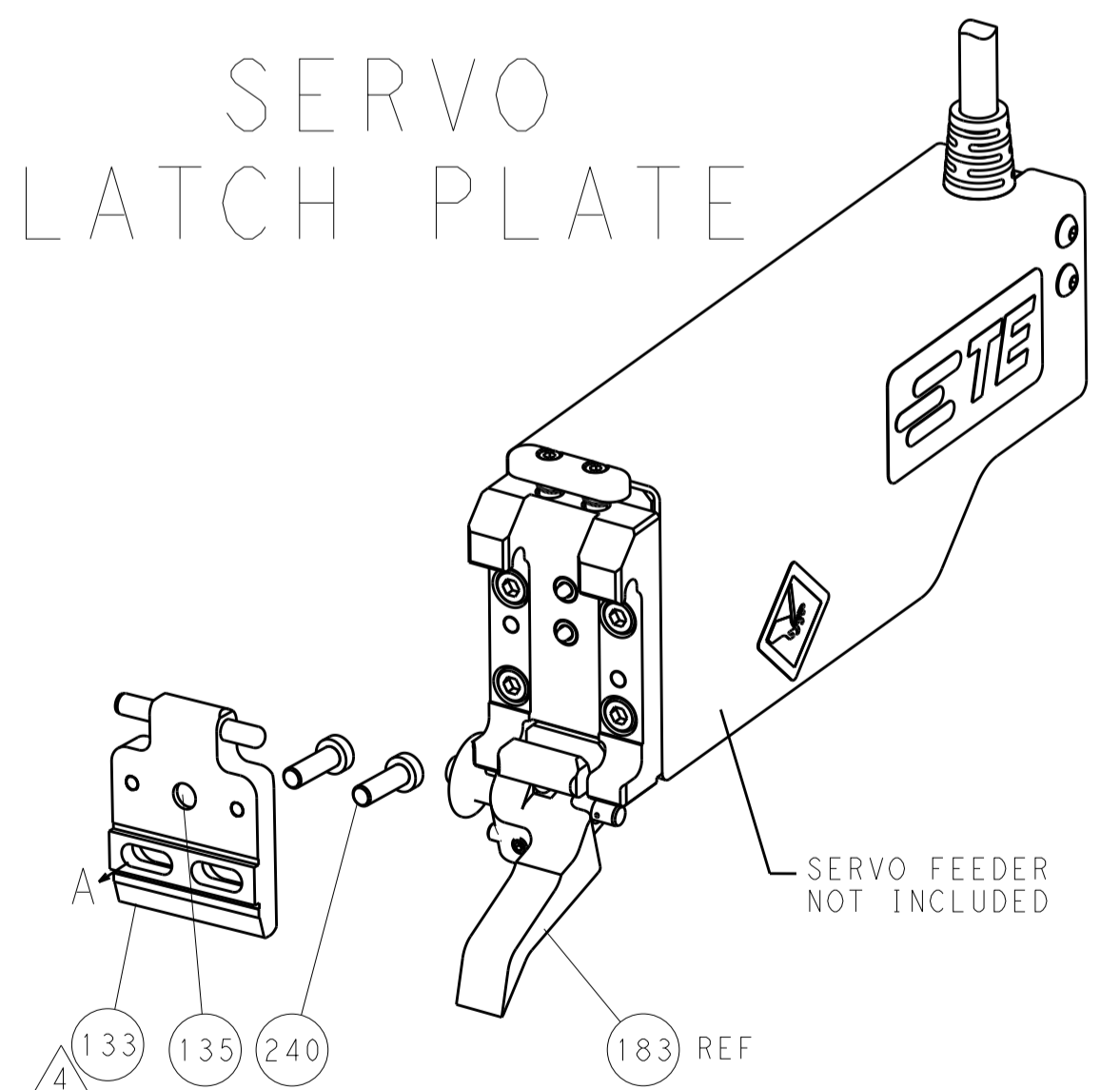
FEED TYPE
MECHANICAL



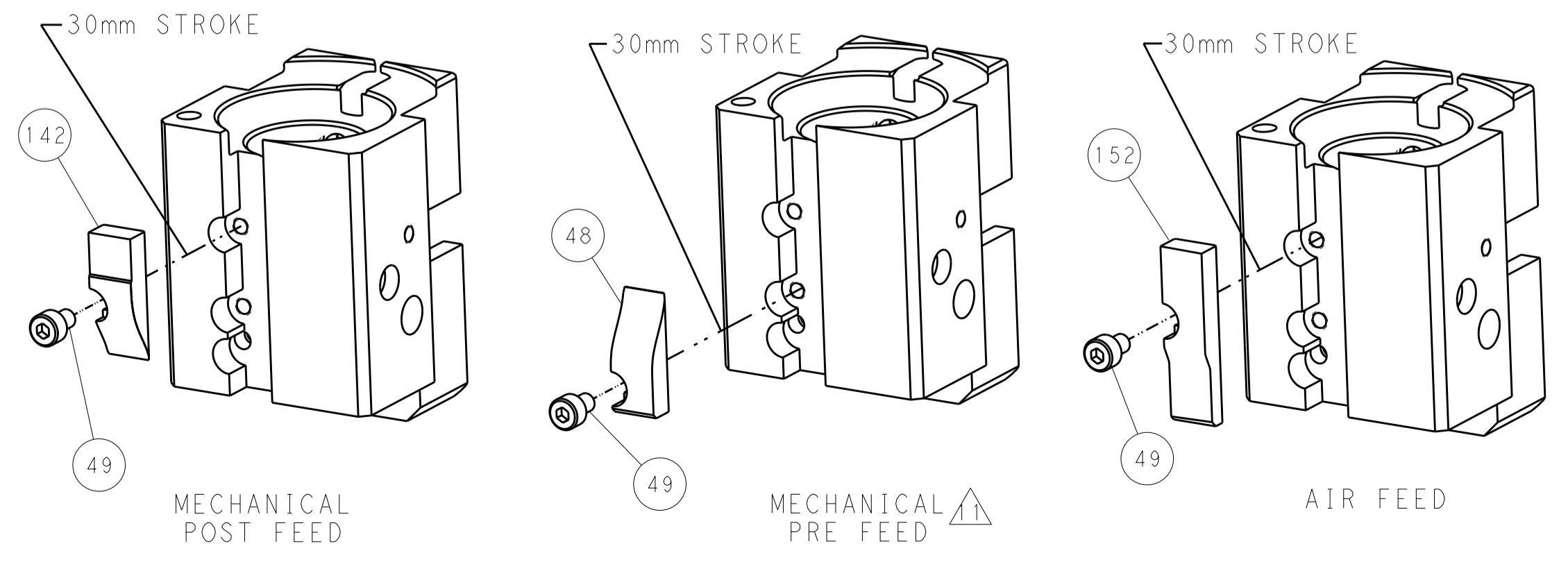
PNEUMATIC



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)

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MATERIAL:		SHEET 4 OF 4 REV A	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION