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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

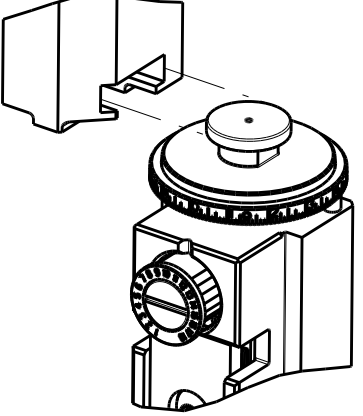
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150519-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150519-5

-

-

2168400-7 (QUANTITY 2)

2150519-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2161326-1

-

-

8-2150519-4

-

-

-

2150519-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

-

-

-

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-

2150519-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

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-

-

7-2150519-7

A

CRIMP TOOLING KIT

-

-

-

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-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.54 mm [.100]

F

INSUL

3.94 mm [.155]

F

APPL INSTRUCTIONS

408-10390



TERMINAL DATA: GMG TERMINAL

GMG CRIMP SPECIFICATION

TERMINAL NAME: FASTIN-ON 6.3 X 0.8

WIRE STRIP LENGTH

5.20-5.96 mm [.205-.235 IN]

INSULATION DIAMETER RANGE

Ø 4.00 mm MAX [.157 IN MAX]

TERMINAL APPLICATION SPECIFICATION

31002.52.08.1 Rev 01

-

-

TERMINALS APPLIED

TE TERMINAL

GMG TERMINAL

TE TERMINAL

GMG TERMINAL

2113640-1

31002.52.00.1

2113640-3

31002.52.08.1

2113640-2

31002.52.02.1

WIRE SIZE





CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

2.50mm2

1.85+/-0.05 [.073+/- .002]

3.9

1.00mm2

1.75+/-0.05 [.069+/- .002]

4.5

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: 8-2150519-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150519-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150519-6

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.
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

APPLICATOR STYLE CONVERSION CHART

6

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242

243

244

245

246

247

248

SET UP GAUGE

2119599-2

LOC

A

DIST

66

REV

1

DATE

02FEB2015

MR

GB

DESCRIPTION

RELEASED

FEED CAM, AIR FEED

DETENT PIN

SPRING, COMPRESSION

RAM, AMP STYLE, END FEED, NON-ADJUST

CAM, SNAIL, INSULATION ADJUSTMENT

WASHER, WAVE SPRING, CREST-TO-CREST

RETAINER, INSULATION DIAL

SHCS, LOW HEAD, RoHS, M5 X 10

AIR FEED MODULE

TAG, IDENTIFICATION

FEED FINGER ASSEMBLY, EF

STANDOFF, HOLD-DOWN

PIN, SLOTTED SPRING 3.0 X 14.0

SPRING, COMPRESSION

GUIDE PIN, HOLDDOWN

GUIDE PIN, HOLDDOWN

RING, RETAIN, EXTERN, 3/16 CRESCENT

MAGNET, RARE EARTH HIGH ENERGY

COUNTER, MAGNETIC

SPRING, FEED FINGER

PIN, RETAIN, GRVD, 3/16 X .854

MEMORY CHIP, PROGRAMMED

SERVO FEED LATCH ASM

SPACER, CRIMPER

DEPRESSOR, WIRE

DOCUMENTATION PACKAGE

SCR, SET, FLT POINT M3 X 10.0

TAG, IDENTIFICATION

SCREW, DRIVE, RH, RoHS, 2 x .188

HOLDDOWN, TERMINAL

LIMITER, ADJUSTMENT BOLT

SCR, SET, SOC, CONE POINT, M3 x 4.0

SCR, BHSC, RoHS (M4 X 8)

SHCS, LOW HEAD, RoHS, M4 X 8

SCR, SKT HD CAP, RoHS, M4 X 20

NUT, HEX, REG, RoHS, M4

NUT, HEX, REG, RoHS, M3

NUT, LOCK, HEX, TORQUE (M4)

NUT, HEX, REG, RoHS, M3.5

PAWL, EF, AIR

SCR, SKT HD CAP M4 X 6.0

APPLICATOR BASIC ASSEMBLY, EF

RAM, AMP STYLE, END FEED

SCR, BHSC, RoHS (M8 X 25)

DISC, NUMBERED FA WIRE ADJUSTMENT

APPLICATOR SHIM PACK

RAM WASHER, PRECISION

FA HEAD, ATLANTIC STYLE

BOLT, ADJUSTMENT

WASHER, FLAT, REG M4

SCR, SKT HD CAP, RoHS, M4 X 20

SCR, SKT HD CAP, RoHS, M4 X 10

STRIPPER (MACHINING)

STUD, THREADED

PLATE, STRIP GUIDE

SPRING, COMPRESSION

DRAG

STRIP GUIDE, REAR

STRIP GUIDE, FRONT

SCR, BHSC, RoHS (M6 X 12)

SPACER

SPACER, HOLD-DOWN

PLATE, REAR SHEAR

-

PLATE, FRONT SHEAR

ANVIL, COMBINATION, END FEED

BLADE, SLUG

-

SPACER

BLOCK, FL CRIMPER SPACER

CRIMPER, INSULATION F PREMIUM

SPACER, CRIMPER

CRIMPER, WIRE PREMIUM

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)

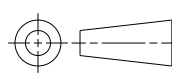
1st FORMULATED TO COMPLY WITH THE ROHS DIRECTIVE

IT IS SUBJECT TO CHANGE AND WITHOUT ANY WARRANTY OR GUARANTEE

SHALL BE CONTACTED FOR THE LATEST EDITION

DIMENSIONS:

mm



0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

±0.5

±0.13

±0.013

±0.0001

±0.0001

±0.0001

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±0.5

±0.13

±0.013

±0.0001

±0.0001

±0.0001

MATERIAL

-

FINISH

-

OWN

R. HUANG

07JAN2015

CHK

L. ZHANG

07JAN2015

APVD

H. GUO

07JAN2015

NAME

Ocean End Feed Applicator

SIZE

A1

CAGE CODE

00779

DRAWING NO

©=2150519

RESTRICTED TO

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

A

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

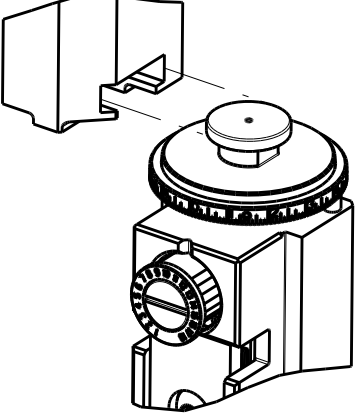
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150519-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150519-5

-

-

2168400-7 (QUANTITY 2)

2150519-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2161326-1

-

-

8-2150519-4

-

-

-

2150519-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

-

-

-

-

-

-

2150519-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

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-

-

-

7-2150519-7

A

CRIMP TOOLING KIT

-

-

-

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-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.54 mm [.100]

F

INSUL

3.94 mm [.155]

F

APPL INSTRUCTIONS

408-10390



TERMINAL DATA: GMG TERMINAL

GMG CRIMP SPECIFICATION

TERMINAL NAME: FASTIN-ON 6.3 X 0.8

WIRE STRIP LENGTH

5.20-5.96 mm [.205-.235 IN]

INSULATION DIAMETER RANGE

Ø 4.00 mm MAX [.157 IN MAX]

TERMINAL APPLICATION SPECIFICATION

31002.52.08.1 Rev 01

-

-

TERMINALS APPLIED

TE TERMINAL

GMG TERMINAL

TE TERMINAL

GMG TERMINAL

2113640-1

31002.52.00.1

2113640-3

31002.52.08.1

2113640-2

31002.52.02.1

WIRE SIZE





CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

2.50mm2

1.85+/-0.05 [.073+/- .002]

3.9

1.00mm2

1.75+/-0.05 [.069+/- .002]

4.5

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: 8-2150519-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150519-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150519-6

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.
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

APPLICATOR STYLE CONVERSION CHART

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246

247

248

SET UP GAUGE

2119599-2

LOC

A

DIST

66

REV

1

DATE

02FEB2015

MR

GB

DESCRIPTION

RELEASED

FEED CAM, AIR FEED

DETENT PIN

SPRING, COMPRESSION

RAM, AMP STYLE, END FEED, NON-ADJUST

CAM, SNAIL, INSULATION ADJUSTMENT

WASHER, WAVE SPRING, CREST-TO-CREST

RETAINER, INSULATION DIAL

SHCS, LOW HEAD, RoHS, M5 X 10

AIR FEED MODULE

TAG, IDENTIFICATION

FEED FINGER ASSEMBLY, EF

STANDOFF, HOLD-DOWN

PIN, SLOTTED SPRING 3.0 X 14.0

SPRING, COMPRESSION

GUIDE PIN, HOLDDOWN

GUIDE PIN, HOLDDOWN

RING, RETAIN, EXTERN, 3/16 CRESCENT

MAGNET, RARE EARTH HIGH ENERGY

COUNTER, MAGNETIC

SPRING, FEED FINGER

PIN, RETAIN, GRVD, 3/16 X .854

MEMORY CHIP, PROGRAMMED

SERVO FEED LATCH ASM

SPACER, CRIMPER

DEPRESSOR, WIRE

DOCUMENTATION PACKAGE

SCR, SET, FLT POINT M3 X 10.0

TAG, IDENTIFICATION

SCREW, DRIVE, RH, RoHS, 2 x .188

HOLDDOWN, TERMINAL

LIMITER, ADJUSTMENT BOLT

SCR, SET, SOC, CONE POINT, M3 x 4.0

SCR, BHSC, RoHS (M4 X 8)

SHCS, LOW HEAD, RoHS, M4 X 8

SCR, SKT HD CAP, RoHS, M4 X 20

NUT, HEX, REG, RoHS, M4

NUT, HEX, REG, RoHS, M3

NUT, LOCK, HEX, TORQUE (M4)

NUT, HEX, REG, RoHS, M3.5

PAWL, EF, AIR

SCR, SKT HD CAP M4 X 6.0

APPLICATOR BASIC ASSEMBLY, EF

RAM, AMP STYLE, END FEED

SCR, BHSC, RoHS (M8 X 25)

DISC, NUMBERED FA WIRE ADJUSTMENT

APPLICATOR SHIM PACK

RAM WASHER, PRECISION

FA HEAD, ATLANTIC STYLE

BOLT, ADJUSTMENT

WASHER, FLAT, REG M4

SCR, SKT HD CAP, RoHS, M4 X 20

SCR, SKT HD CAP, RoHS, M4 X 10

STRIPPER (MACHINING)

STUD, THREADED

PLATE, STRIP GUIDE

SPRING, COMPRESSION

DRAG

STRIP GUIDE, REAR

STRIP GUIDE, FRONT

SCR, BHSC, RoHS (M6 X 12)

SPACER

SPACER, HOLD-DOWN

PLATE, REAR SHEAR

-

PLATE, FRONT SHEAR

ANVIL, COMBINATION, END FEED

BLADE, SLUG

-

SPACER

BLOCK, FL CRIMPER SPACER

CRIMPER, INSULATION F PREMIUM

SPACER, CRIMPER

CRIMPER, WIRE PREMIUM

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)

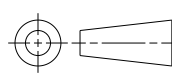
1st FORMULATED TO COMPLY WITH THE ROHS DIRECTIVE

IT IS SUBJECT TO CHANGE AND WITHOUT ANY WARRANTY OR GUARANTEE

SHALL BE CONTACTED FOR THE LATEST EDITION

DIMENSIONS:

mm



0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

±0.5

±0.13

±0.013

±0.0001

±0.0001

±0.0001

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±0.5

±0.13

±0.013

±0.0001

±0.0001

±0.0001

MATERIAL

-

FINISH

-

OWN

R. HUANG

07JAN2015

CHK

L. ZHANG

07JAN2015

APVD

H. GUO

07JAN2015

NAME

Ocean End Feed Applicator

SIZE

A1

CAGE CODE

00779

DRAWING NO

©=2150519

RESTRICTED TO

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

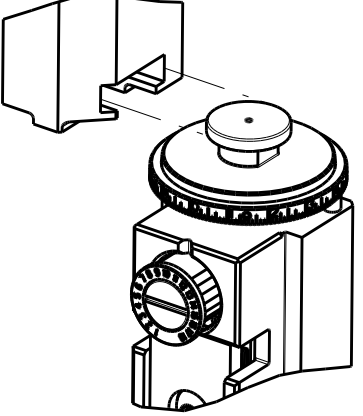
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150519-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119951-1

1901697-1

8-2150519-5

-

-

2168400-7 (QUANTITY 2)

2150519-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2161326-1

-

-

8-2150519-4

-

-

-

2150519-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

-

-

-

-

-

-

2150519-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2150519-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.54 mm [.100]

F

INSUL

3.94 mm [.155]

F

APPL INSTRUCTIONS

408-10390



TERMINAL DATA: GMG TERMINAL

GMG CRIMP SPECIFICATION

TERMINAL NAME: FASTIN-ON 6.3 X 0.8

WIRE STRIP LENGTH

5.20-5.96 mm [.205-.235 IN]

INSULATION DIAMETER RANGE

Ø 4.00 mm MAX [.157 IN MAX]

TERMINAL APPLICATION SPECIFICATION

31002.52.08.1 Rev 01

-

-

TERMINALS APPLIED

TE TERMINAL

GMG TERMINAL

TE TERMINAL

GMG TERMINAL

2113640-1

31002.52.00.1

2113640-3

31002.52.08.1

2113640-2

31002.52.02.1

WIRE SIZE





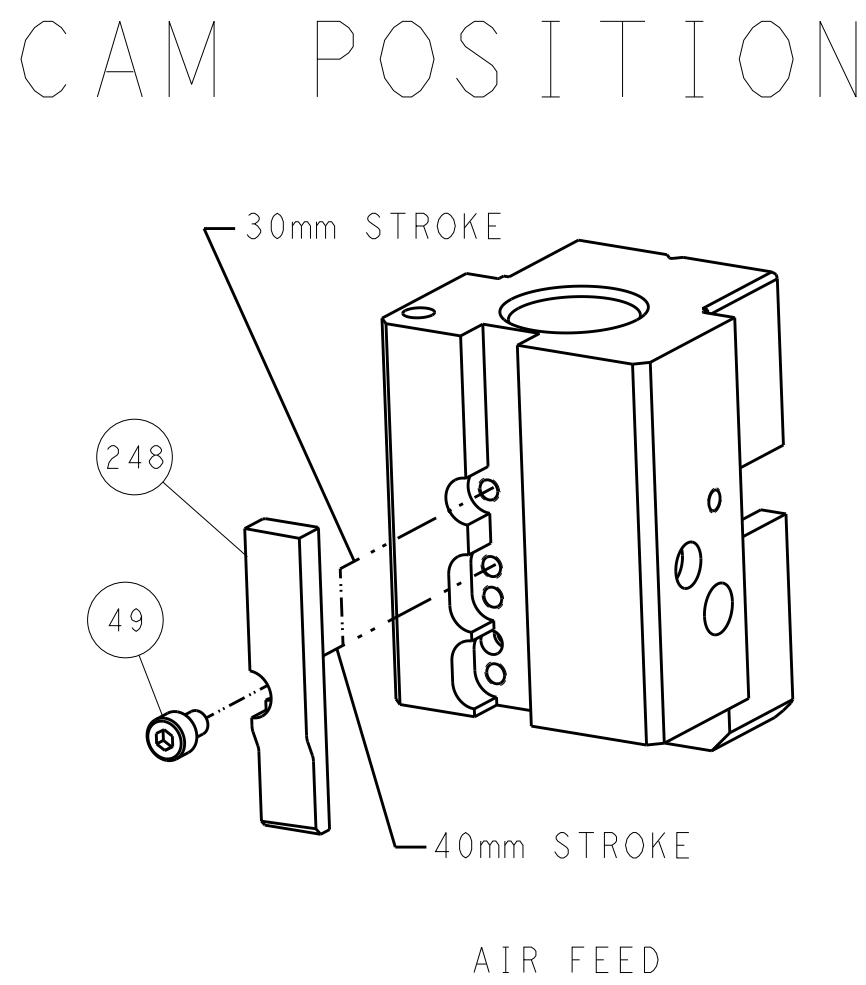
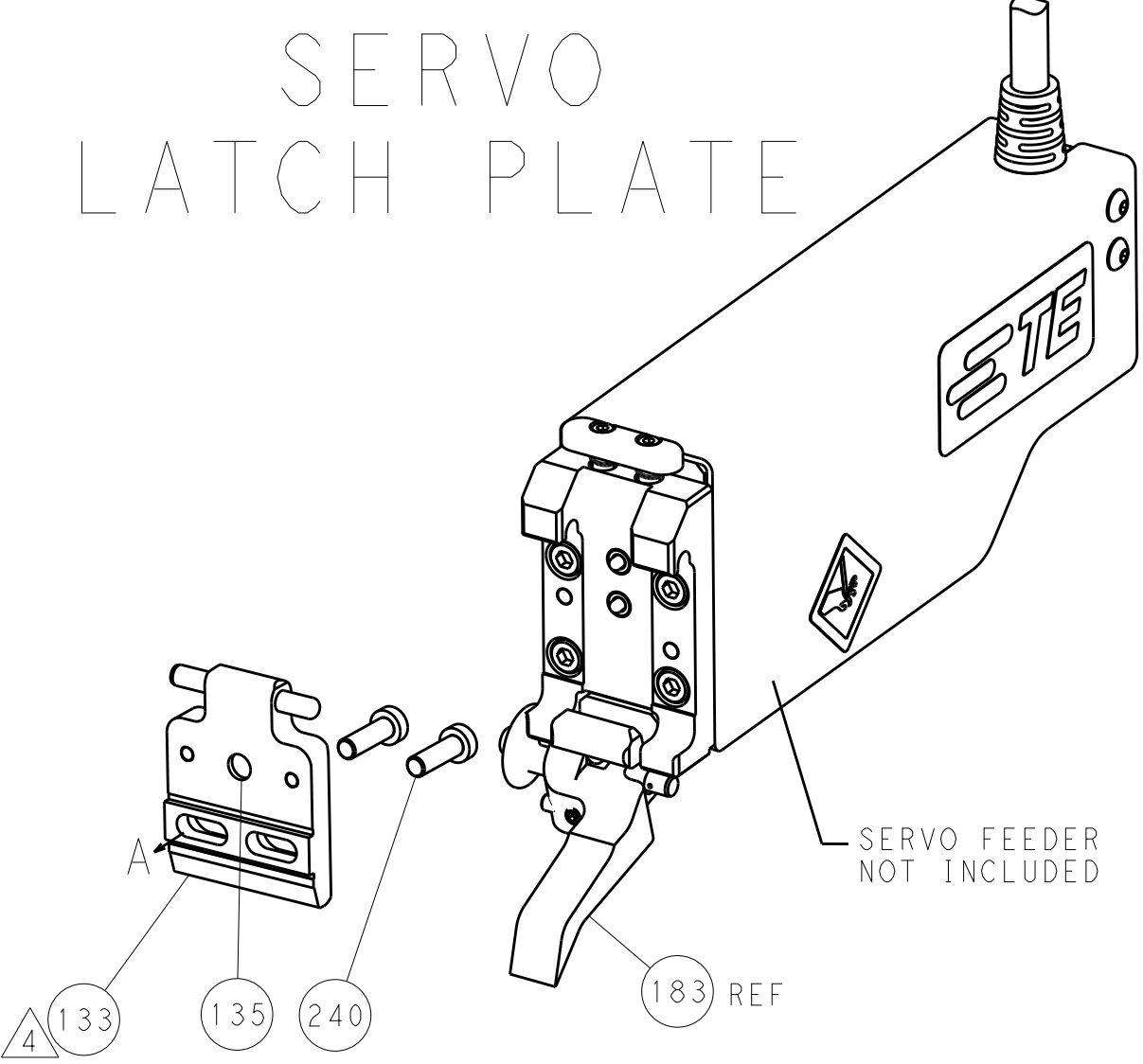
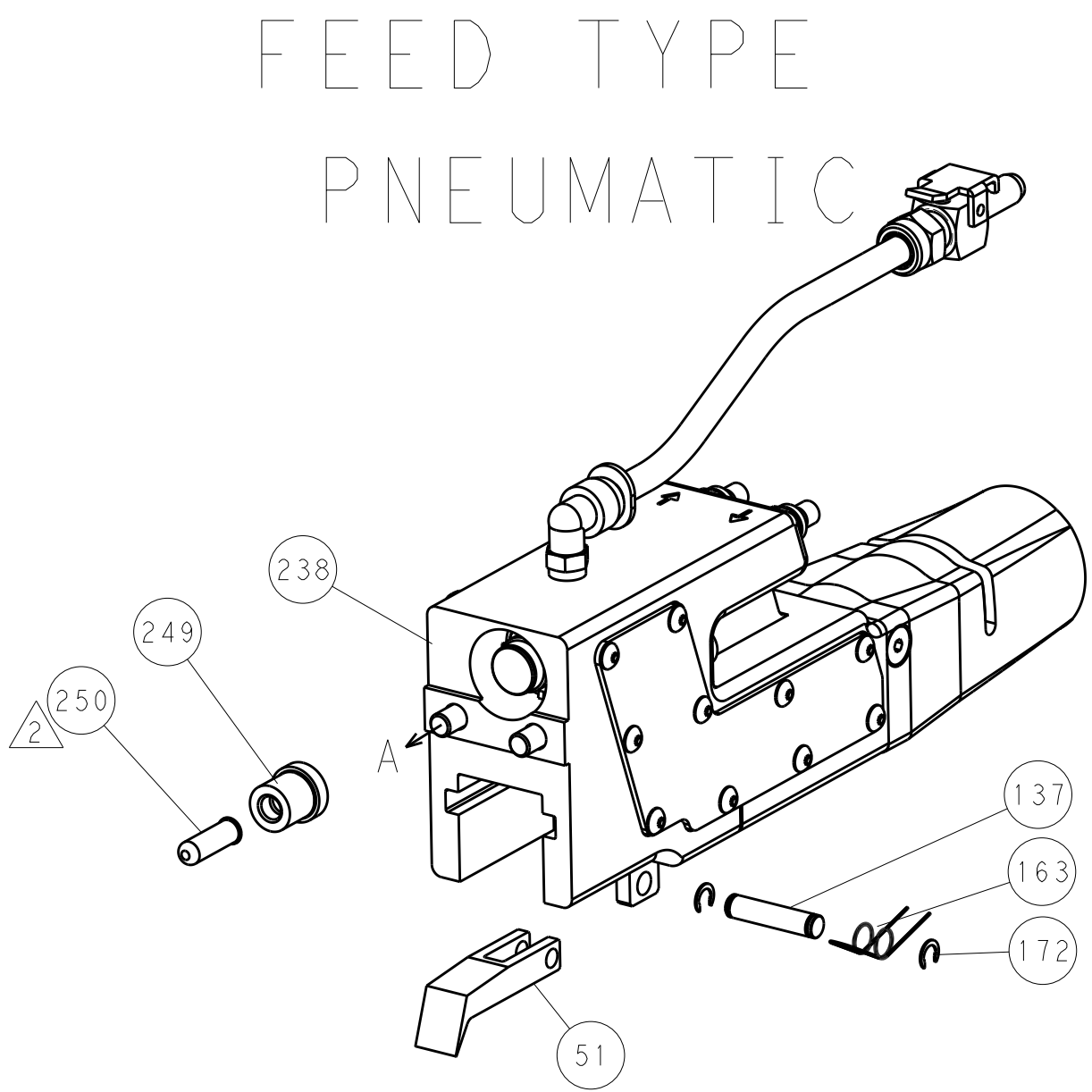
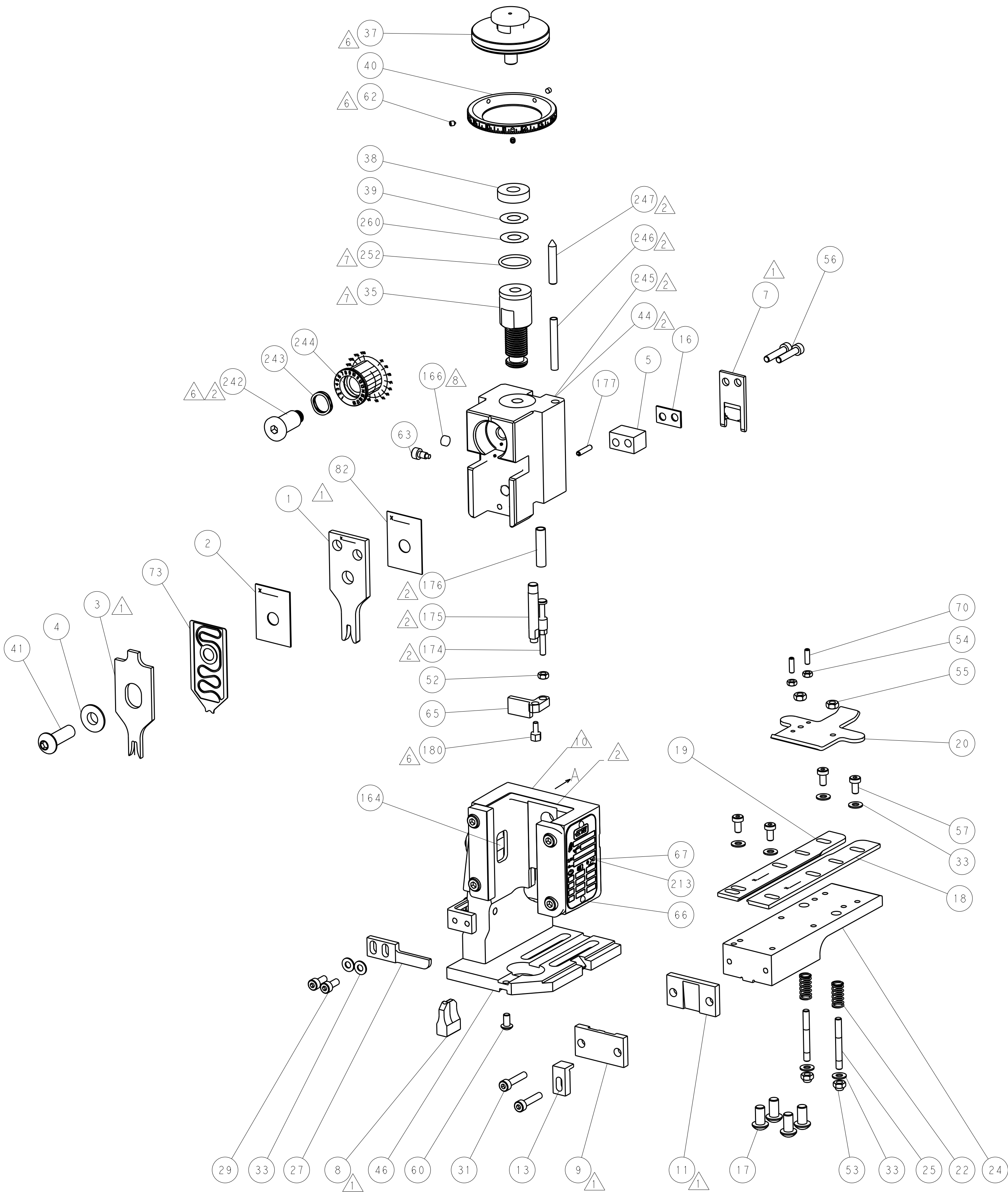
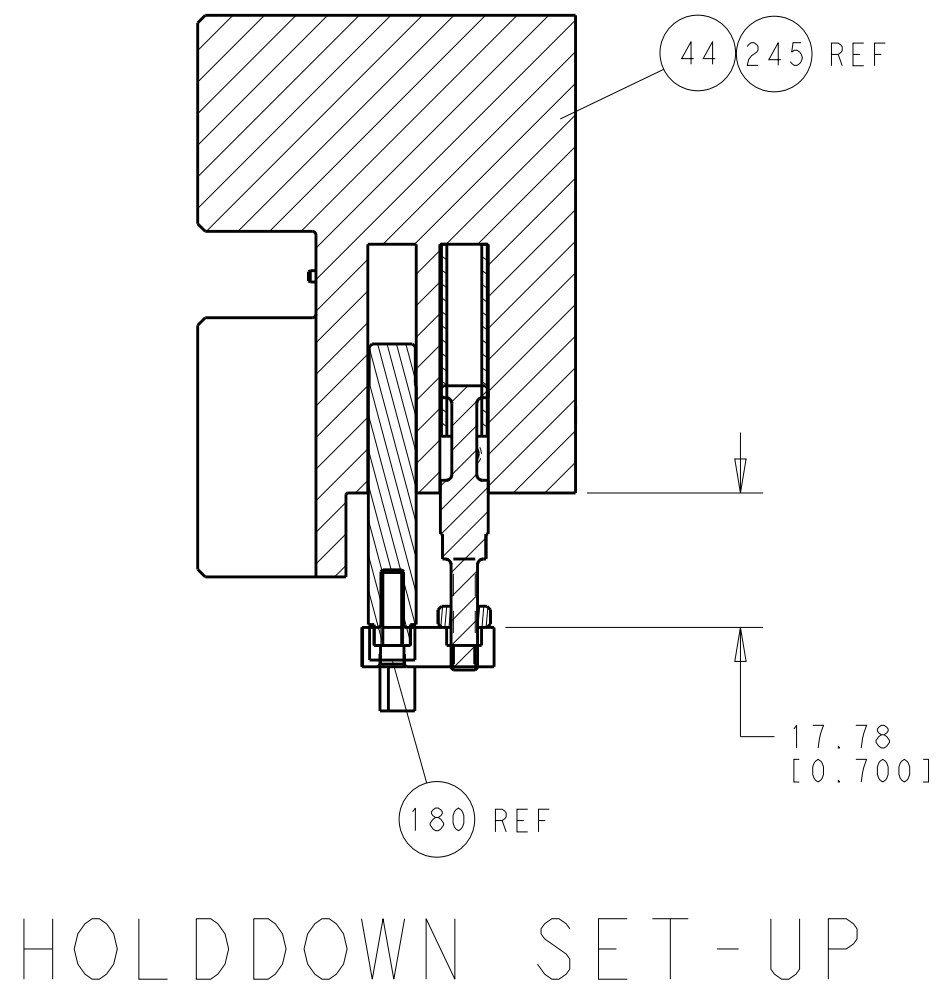
CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

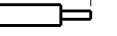
2.50mm2</

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



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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN K. HUANG 07JAN2015	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 07JAN2015	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		APVD J. GUO 07JAN2015	PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -	SIZE A1 00779 ©=2150519	
		Customer Accessible Production Drawing		RESTRICTED TO -
		SCALE 1:1	SHEET 2 OF 4	REV A

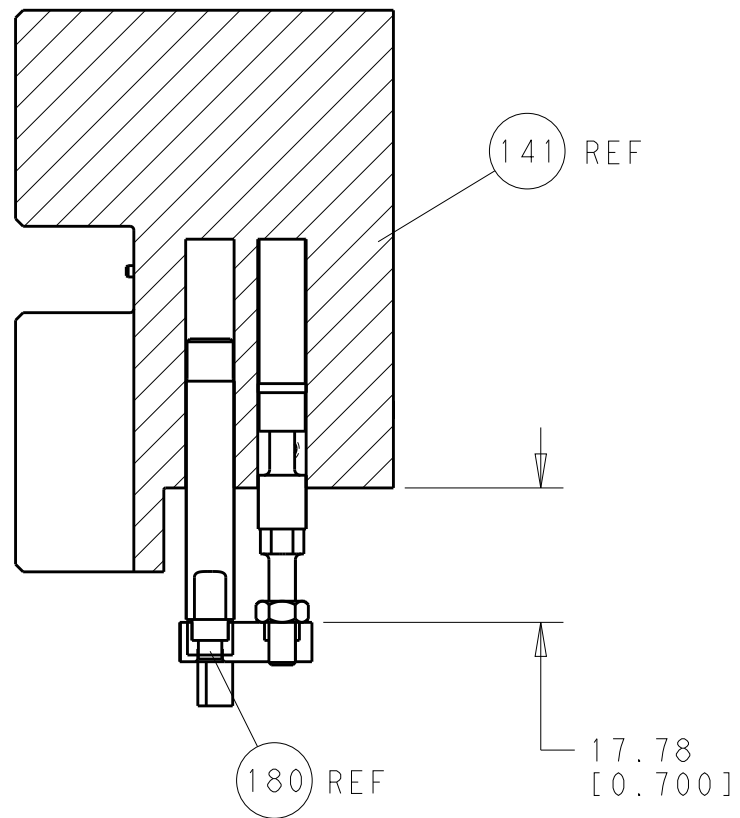
TERMINAL DATA: GMG TERMINAL		GMG CRIMP SPECIFICATION	
TERMINAL NAME: FAST-IN-ON 6.3 X 0.8			
WIRE STRIP LENGTH 5.20-5.96 mm [.205-.235 IN]		 INSULATION DIAMETER RANGE $\varnothing$ 4.00 mm MAX [.157 IN MAX]	
TERMINAL APPLICATION SPECIFICATION		31002.52.08.1 Rev 01	
-		-	
TERMINALS APPLIED			
TE TERMINAL	GMG TERMINAL	TE TERMINAL	GMG TERMINAL
2113640-1	31002.52.00.1	2113640-3	31002.52.08.1
2113640-2	31002.52.02.1		

AMP 4805 REV 31MAR2000

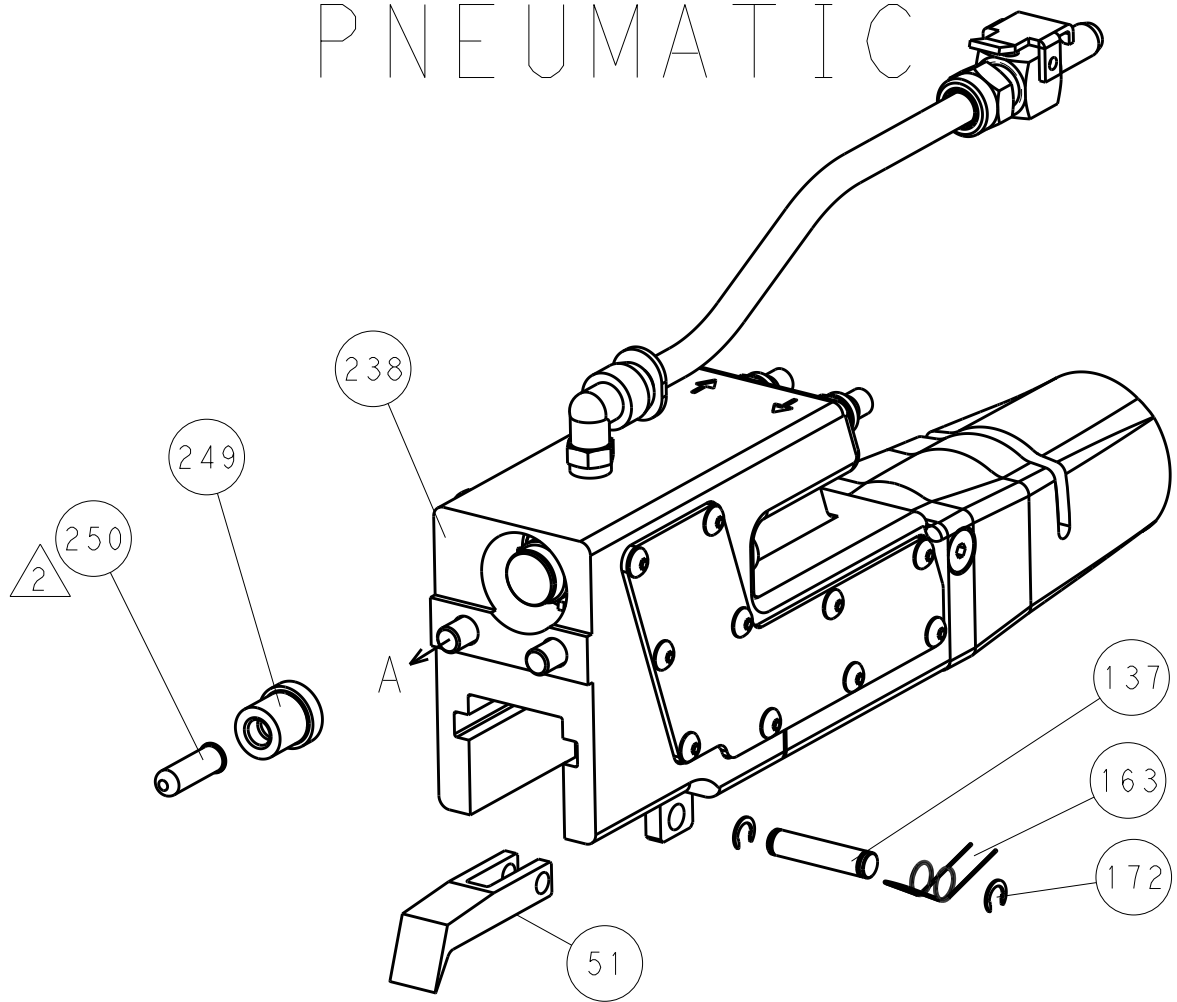
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

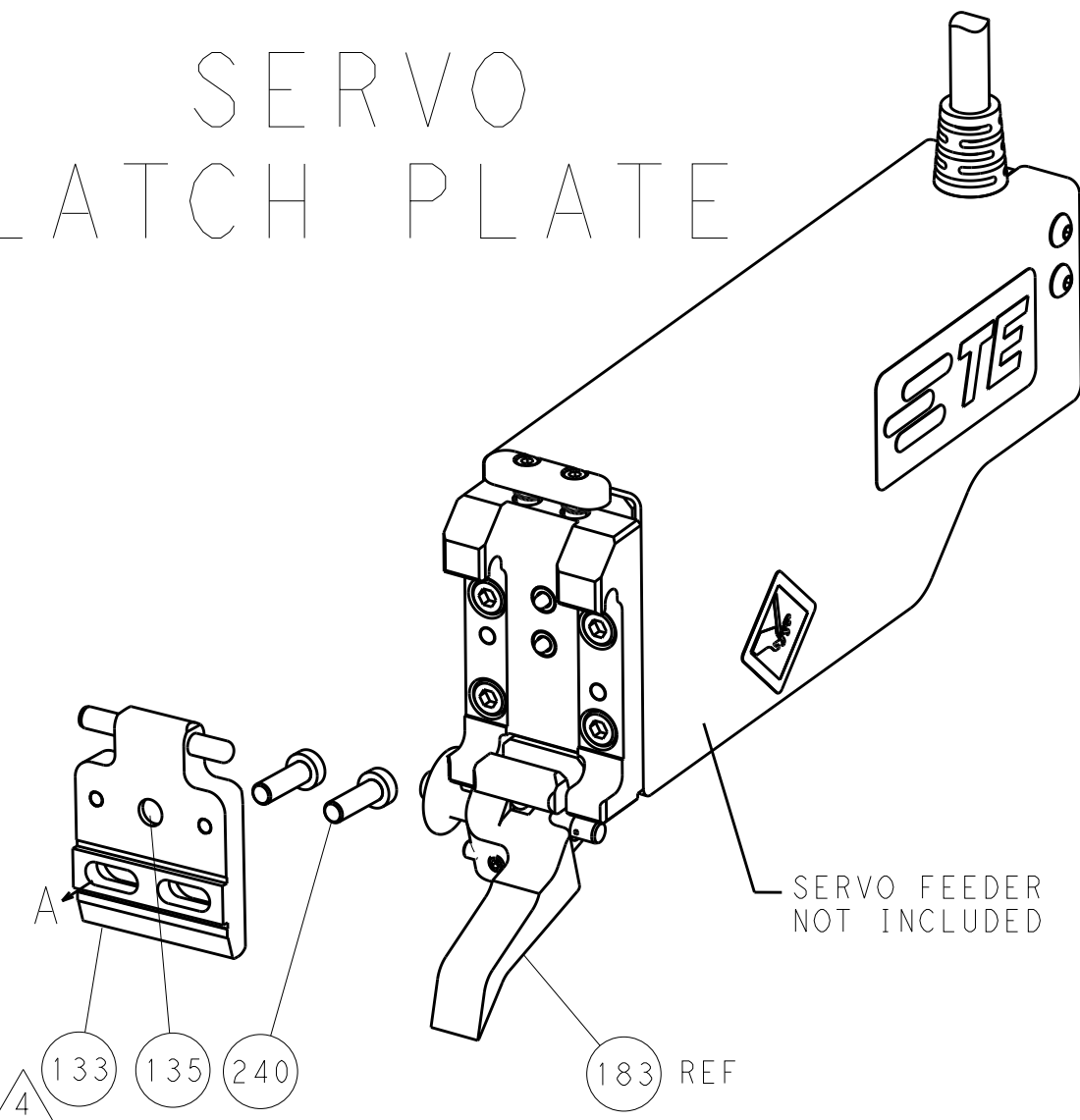
HOLDDOWN SET-UP



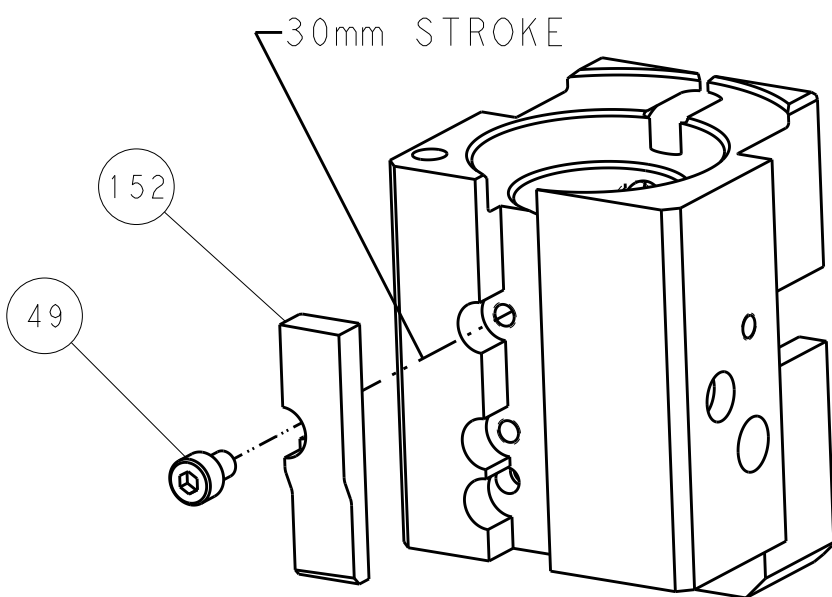
FEED TYPE PNEUMATIC



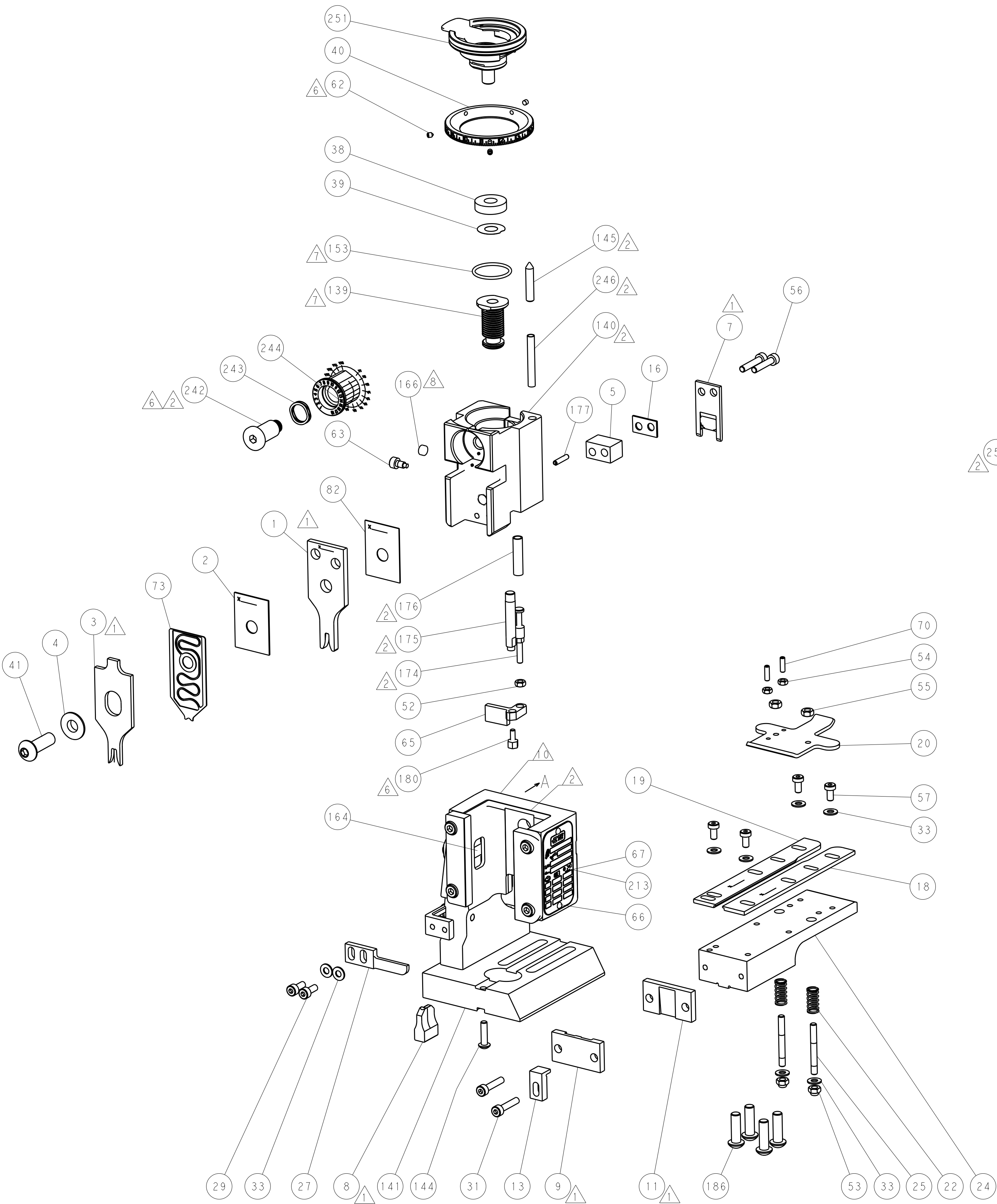
SERVO LATCH PLATE



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 L. ZHANG 07JAN2015	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		APVD J. GUO 07JAN2015	PRODUCT SPEC	
MATERIAL			APPLICATION SPEC	
			WEIGHT	
			Customer Accessible Production Drawing	
			SCALE 1:1 SHEET 4 OF 4 REV A	

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