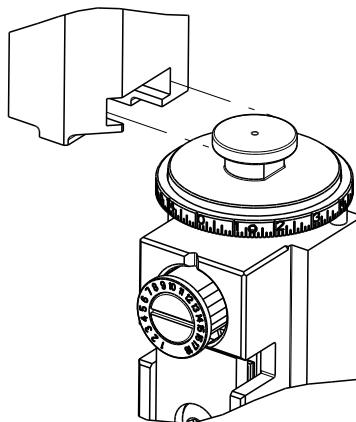


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION
		2150932-2	A
		2150932-5	A
		2150932-6	A
		2150932-7	A
		7-2150932-7	A
		DESCRIPTION	
		FINE CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		NON-CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		CRIMP TOOLING KIT	

TERMINAL DATA: ESCUBEDO TERMINAL		ESCUBEDO CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SERIES TERMINAL			
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]		INSULATION DIAMETER RANGE Ø3.00-4.30 mm [.118-.169 IN]	
TERMINAL APPLICATION SPECIFICATION		2732.XX Rev 11/3	
TERMINALS APPLIED			
TE TERMINAL	ESCUBEDO TERMINAL	TE TERMINAL	ESCUBEDO TERMINAL
3311242-1	4732.02	3311242-5	4732.31
3311242-2	4732.01	3311242-6	4732.30
3311242-3	4732.00	3311242-7	4732.04
3311242-4	4732.32		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		1.95+/-0.05 [0.077+/-0.002]		5.1
1.50mm2		1.65+/-0.05 [0.065+/-0.002]		8.2
1.00mm2		1.50+/-0.05 [0.059+/-0.002]		9.9



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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150932-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150932-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150932-6
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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
11. 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
12. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.

-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-77	-7	-6	-5	-2	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)

2		1	
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS
P	LTR	DESCRIPTION	DATE
A	RELEASED	02AUG2018	TD
			TE

-	-	-	1	1803259-1	BUSHING, FLANGED	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	2119082-3	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	2	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	2119740-2	TAG, IDENTIFICATION	213
-	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	-	REFREF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1-1752354-0	STANDOFF, HOLD-DOWN	18
-	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
-	-	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREFREFREF	-	-	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	-	-	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	1	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	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
-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
-	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
-	-	-	-	2119792-1	PAWL, EF, AIR	51
-	-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	1	2119369-1	RAM, AMP STYLE, END FEED	44
-	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	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	2119092-1	BOLT, ADJUSTMENT	35
-	8	8	8	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	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1803292-4	DRAG	20
-	1	1	1	1803152-2	STRIP GUIDE, REAR	19
-	1	1	1	1803151-2	STRIP GUIDE, FRONT	18
-	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	3-240641-9	SPACER	16
-	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
-	1	1	1	6-690482-0	PLATE, FRONT SHEAR	9
1	1	1	1	1-1803426-9	ANVIL, COMBINATION, END FEED	8
-	1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	1-240641-4	SPACER	5
-	1	1	1	7-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1	6-1803017-0	CRIMPER, INSULATION F	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	7-1490019-4	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	ITEM NO

[illegible]

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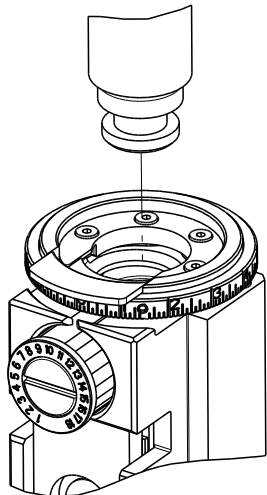
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2150932-2	A	FINE CRIMP HEIGHT ADJUST
	2-2150932-5	A	FINE CRIMP HEIGHT ADJUST
	2-2150932-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150932-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.97 mm [.117]	F
INSUL	3.96 mm [.156]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: ESCUBEDO TERMINAL ESCUBEDO CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 SERIES TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-6.00 mm [.197-.236 IN]		Ø3.00-4.30 mm [.118-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	4732.XX Rev 11/3	-	-
-	-	-	-
TERMINALS APPLIED			
TE TERMINAL	ESCUBEDO TERMINAL	TE TERMINAL	ESCUBEDO TERMINAL
3311242-1	4732.02	3311242-5	4732.31
3311242-2	4732.01	3311242-6	4732.30
3311242-3	4732.00	3311242-7	4732.04
3311242-4	4732.32		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.95+/-0.05 [.077+/- .002]	5.1
1.50mm2	1.65+/-0.05 [.065+/- .002]	8.2
1.00mm2	1.50+/-0.05 [.059+/- .002]	9.9



- 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: 8-2150932-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150932-5
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 & 180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.
- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.

*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.

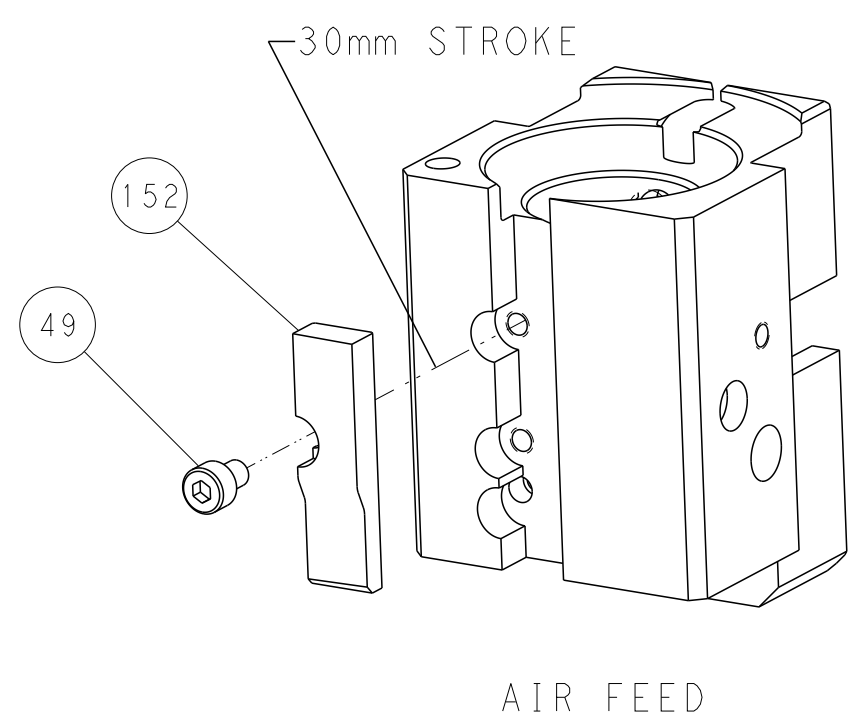
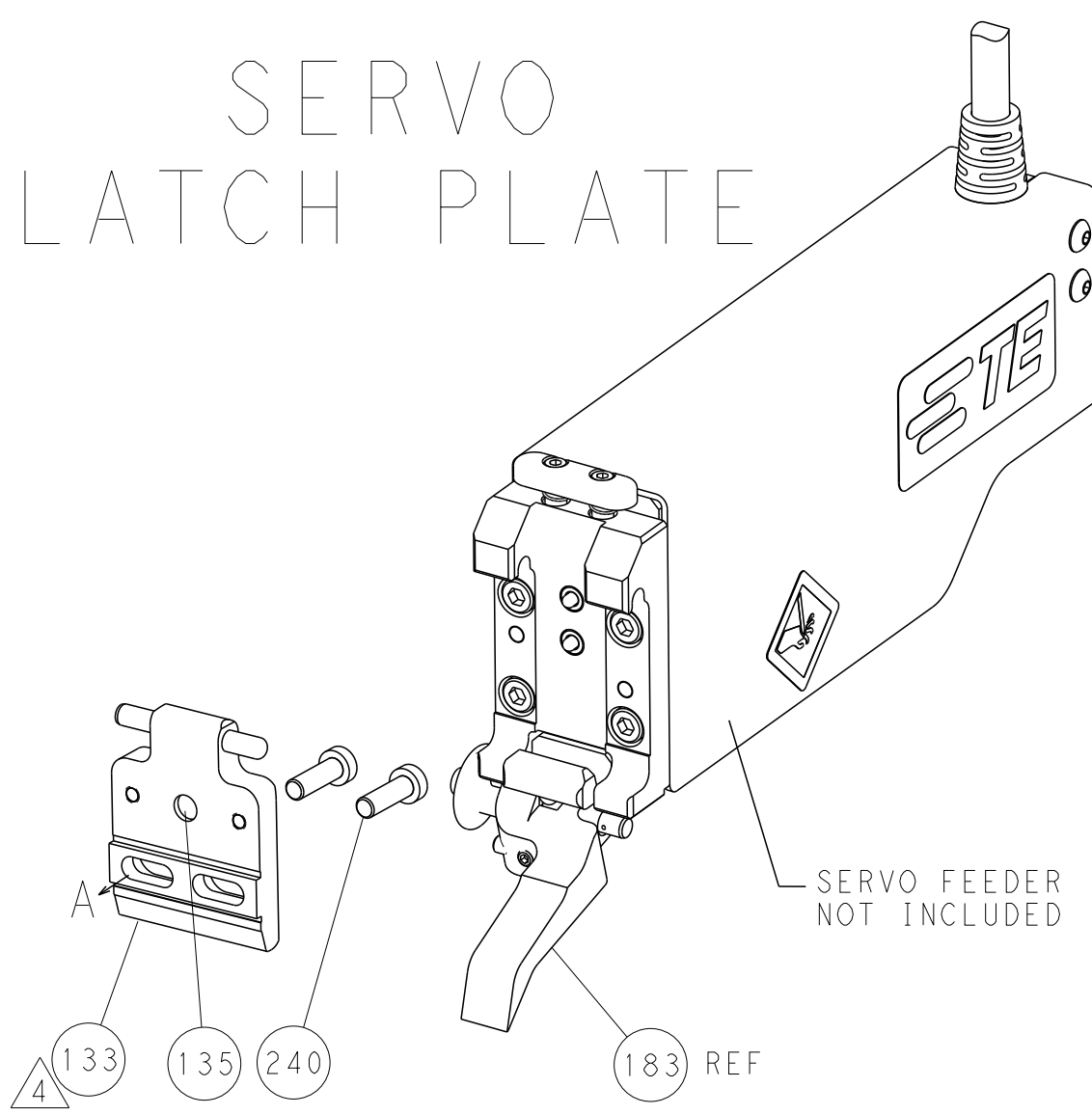
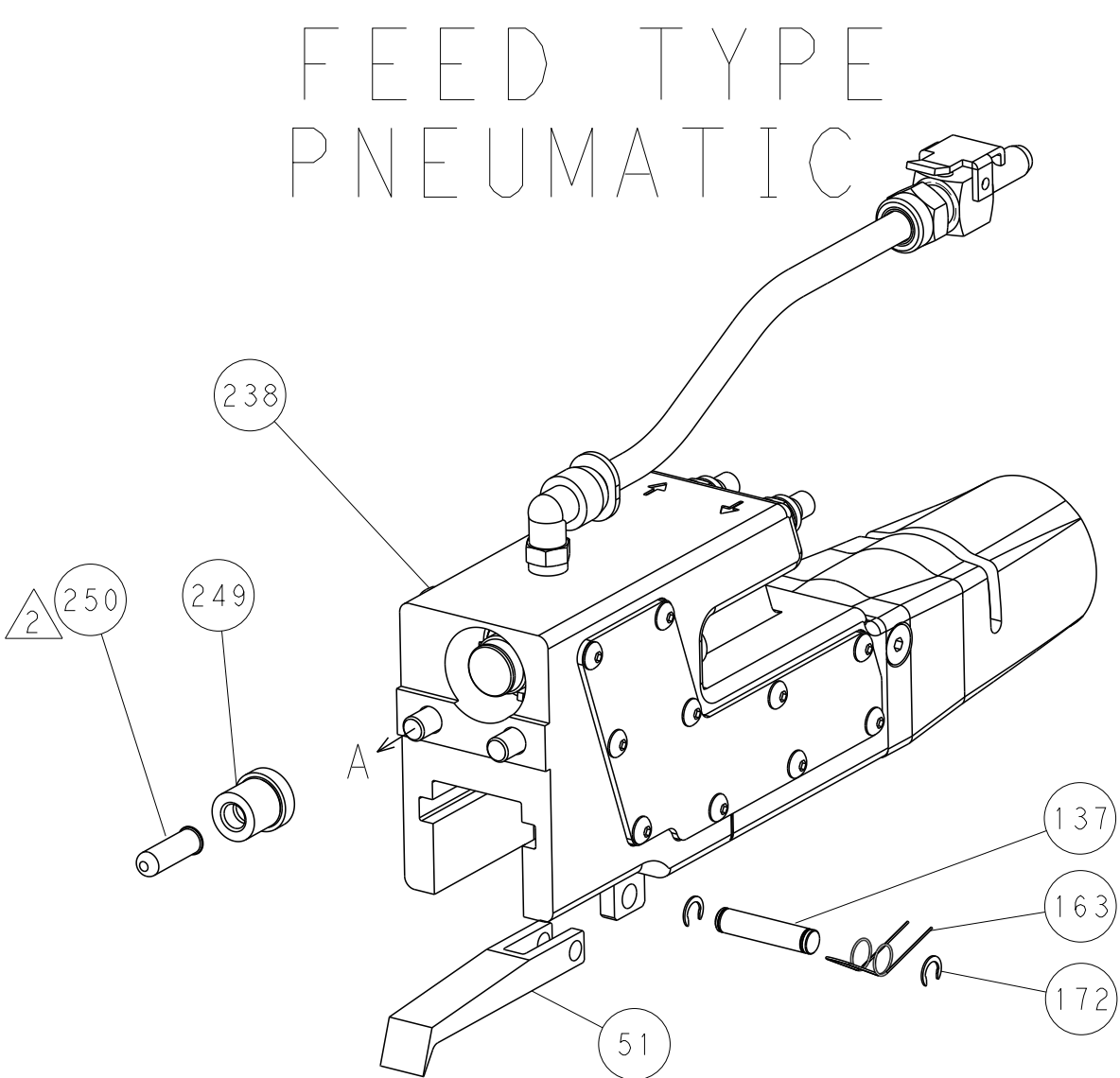
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

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

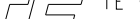
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS						
			P	LTR	DESCRIPTION	DATE	DWN	APVD	
				-	SEE SHEET 1	-	-	-	

-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	1803259-1	BUSHING, FLANGED	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-3	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	2063440-1	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG,IDENTIFICATION	213
-	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY,EF	183
-	1	1	1	1-1752354-0	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	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	455888-5	SPACER, CRIMPER	82
-	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	1901681-1	HOLDDOWN, TERMINAL	65
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 X 4.0	62
-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
-	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	2119792-1	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	1-2119644-2	RAM WASHER, PRECISION	38
-	8	8	8	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	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1803292-4	DRAG	20
-	1	1	1	1803152-2	STRIP GUIDE, REAR	19
-	1	1	1	1803151-2	STRIP GUIDE, FRONT	18
-	1	1	1	3-240641-9	SPACER	16
-	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
-	1	1	1	6-690482-0	PLATE, FRONT SHEAR	9
1	1	1	1	1-1803426-9	ANVIL, COMBINATION, END FEED	8
-	1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	1-240641-4	SPACER	5
-	1	1	1	7-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1	6-1803017-0	CRIMPER, INSULATION F	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	7-1490019-4	CRIMPER, WIRE PREMIUM	1
-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. NO OTHER ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN T. BROOKENS 05JUL2018	 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				CHK M. HERR 05JUL2018	NAME Ocean End Feed Applicator -			
mm				APVD C. TOPPER 05JUL2018				
				PRODUCT SPEC				
				APPLICATION SPEC				
MATERIAL				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
-				WTGHT	-	A1 00779 ©=2150932	-	
-				Customer Accessible Production Drawing				
				SCALE	1:1	SHEET 3 of 4	REV A	



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 COMPLETE DOCUMENT FOR THE ELECTRICAL CONNECTION OF THIS PRODUCT TO OTHER EQUIPMENT. IT MUST BE USED IN CONJUNCTION WITH THE INSTALLATION AND WIRING GUIDE OR CABLES FOR THE LATEST VERSION. DWN 05/JUL/2018 BROOKENS						 TE Connectivity Harrisburg, PA 17105-3608					
DIMENSIONS: mm						TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±° FINISH					
						CHG M_HERR 05/JUL/2018 APD C_TOPPER PRODUCT SPEC - APPLICATION SPEC					
MATERIAL						NAME Ocean End Feed Applicator					
						SIZE CASE CODE DRAWING NO RESTRICTED TO					
WEIGHT						A 00779 C=2150932					
Customer Accessible Porting Drawing						SCALE 1:1 SHEET 4 of 4 REV A					