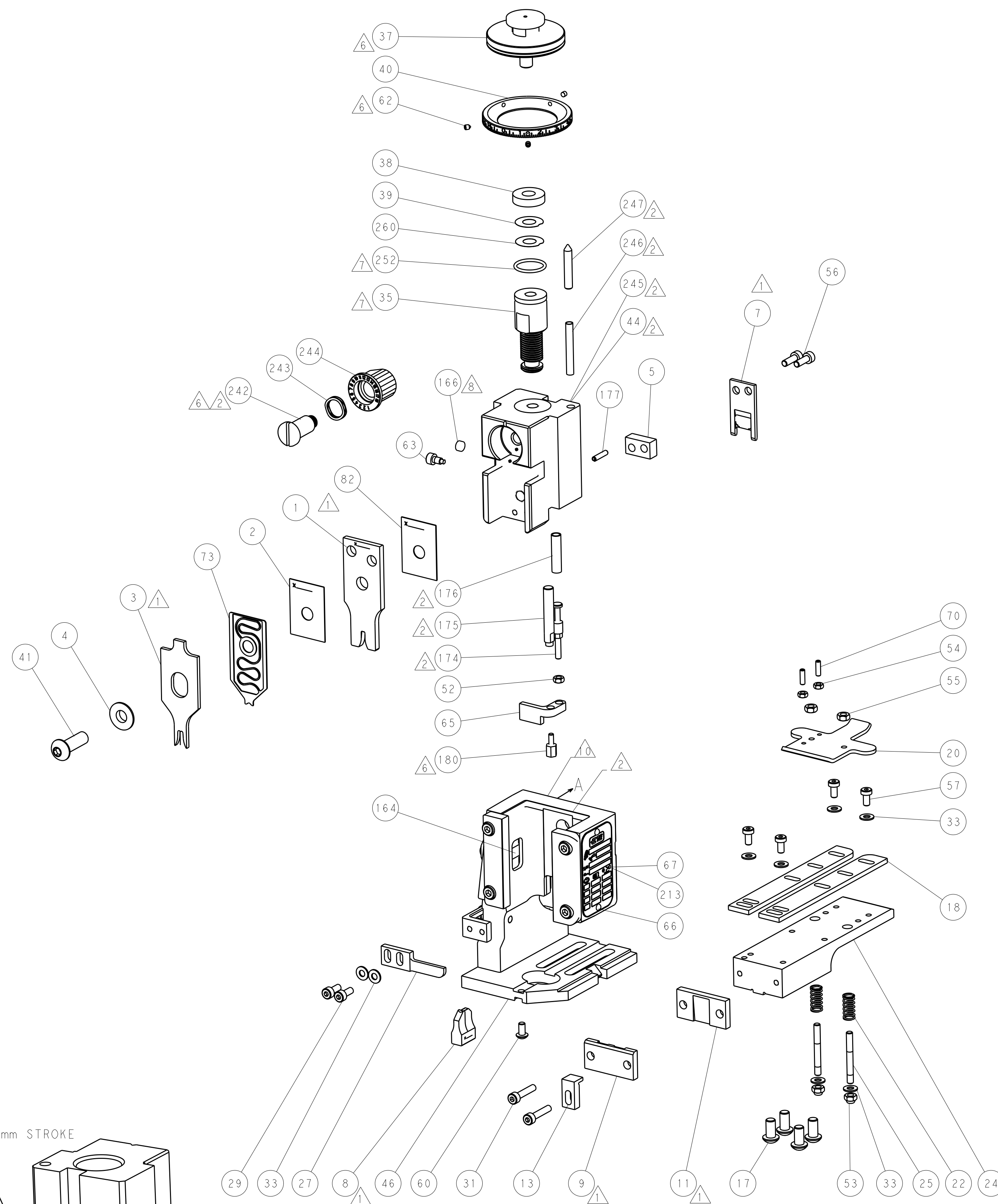
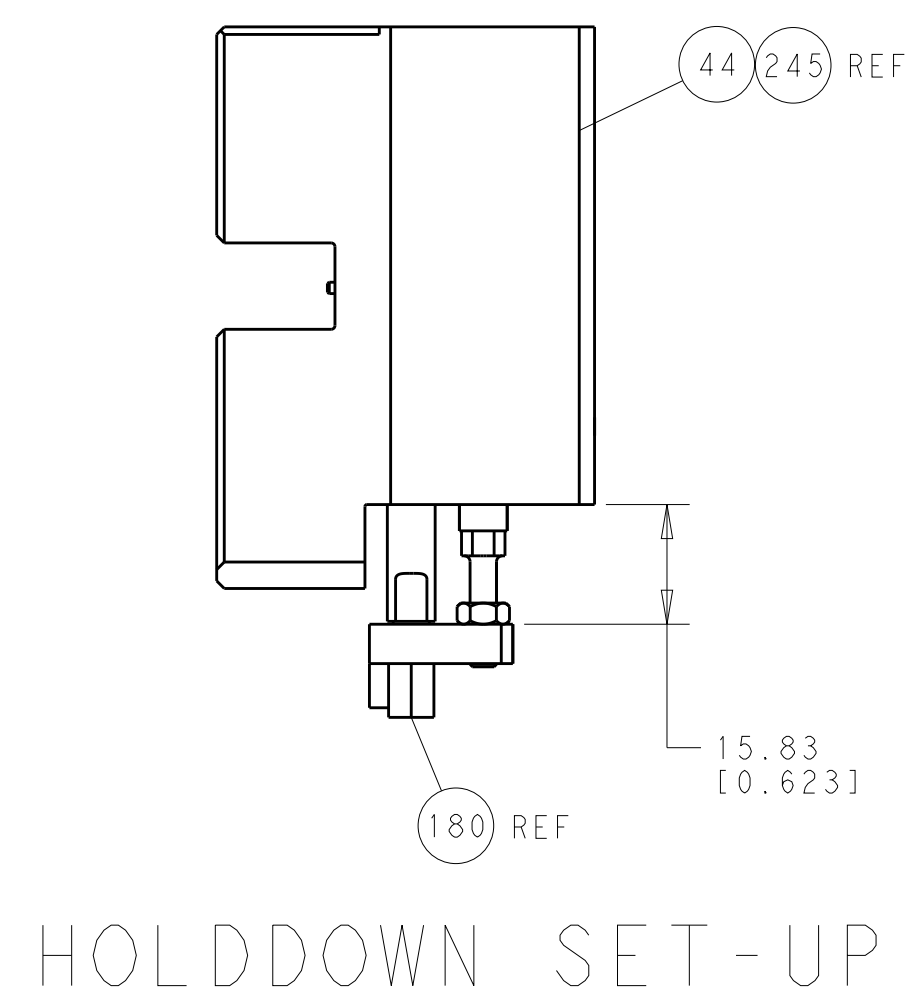
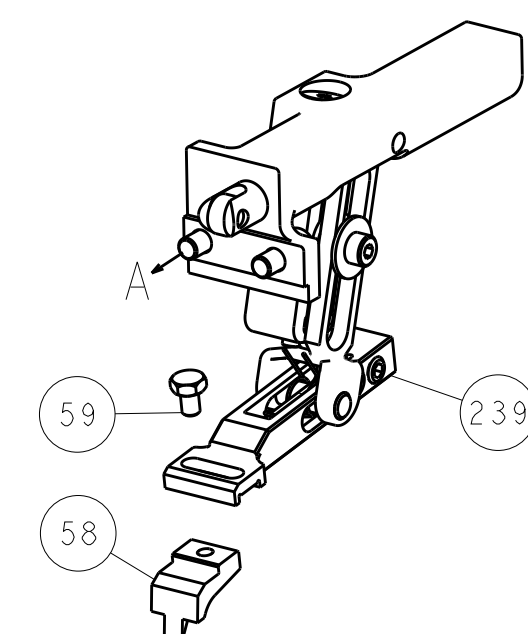
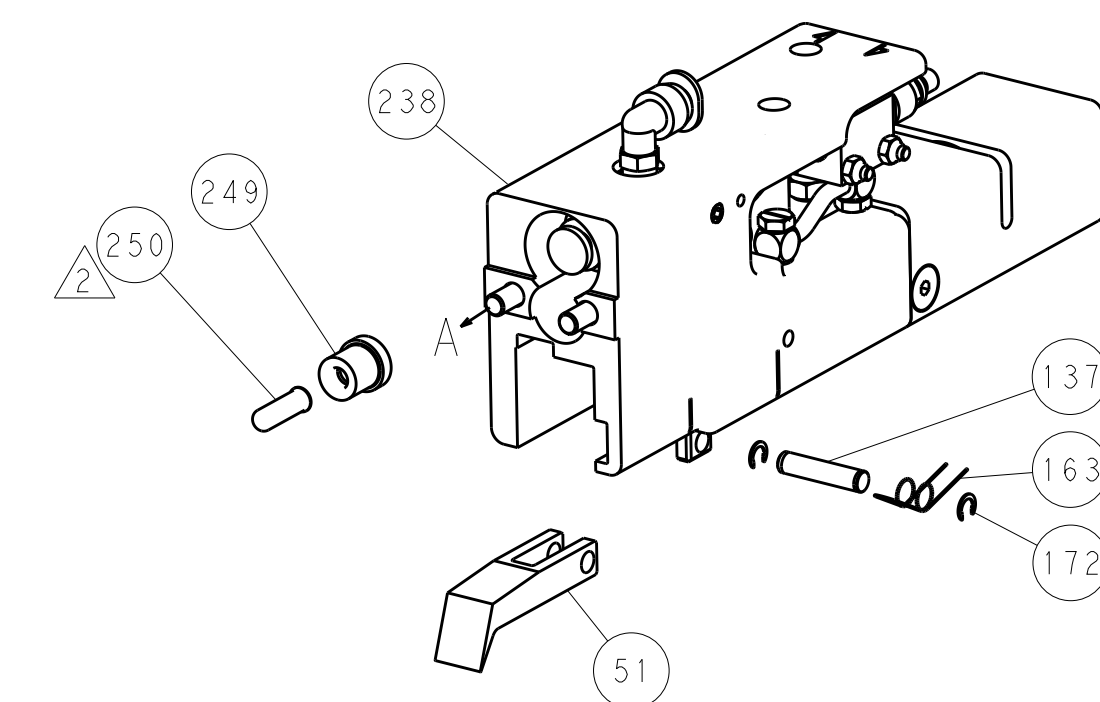
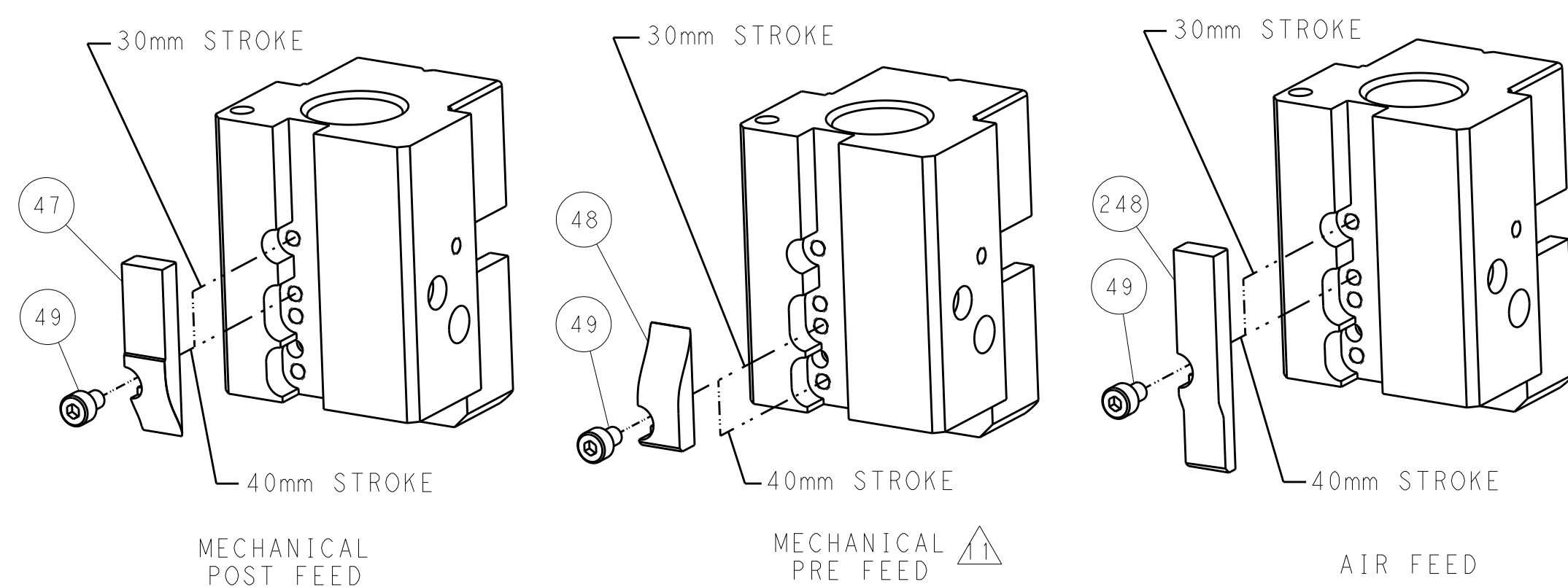
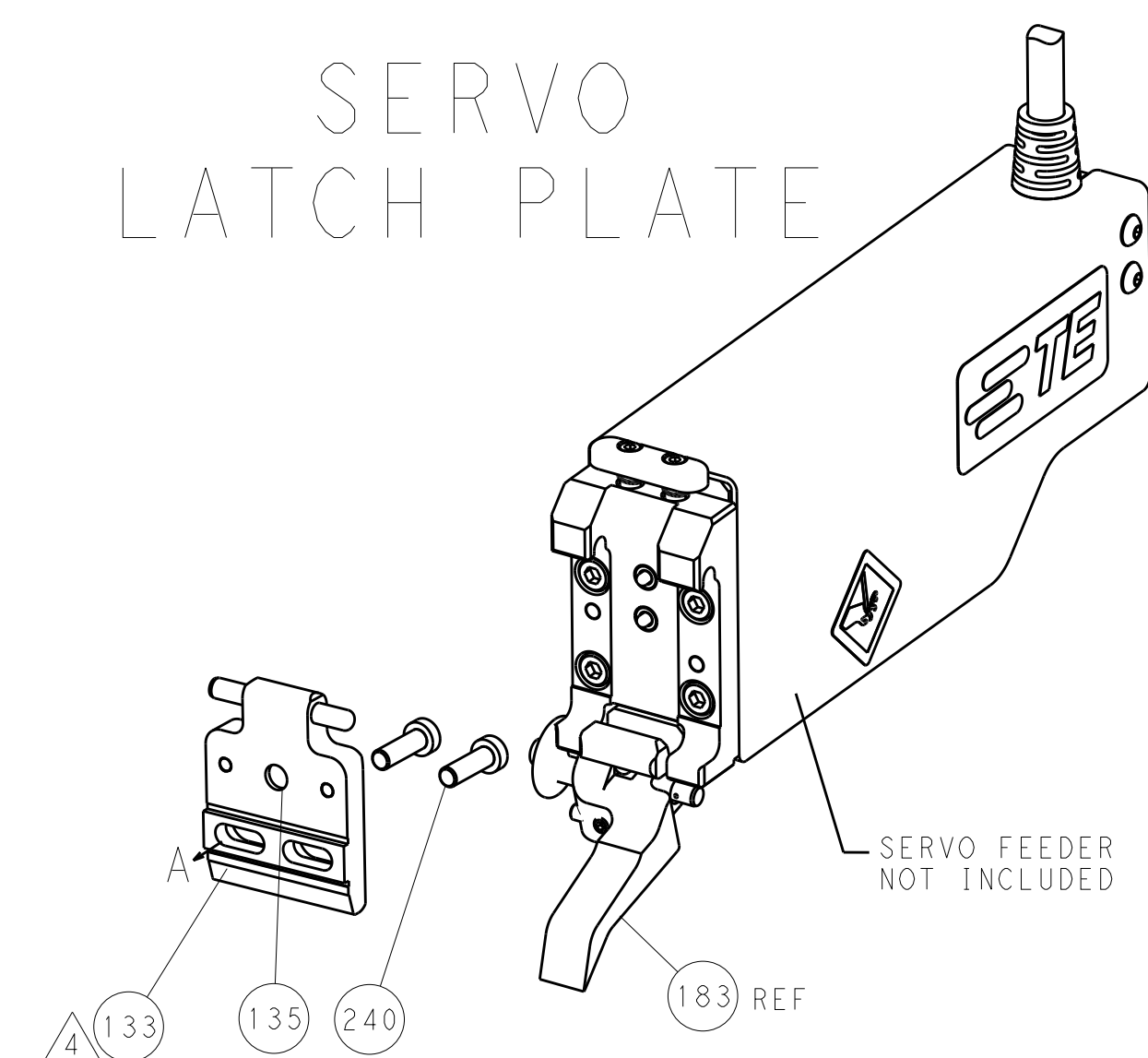




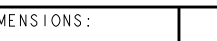
FEED TYPE
MECHANICAL



PNEUMATIC

SERVO
LATCH PLATE

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 A CONTROLLED DOCUMENT FOR TPO. ANY REVISIONS OR MODIFICATIONS TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN K HUANG 26FEB2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK L ZHANG 26FEB2014			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		U GUO 26FEB2014		NAME	
mm		PRODUCT SPEC		Ocean End Feed Applicator	
		APPLICATION SPEC		-	
MATERIAL		FINISH		RESTRICTED TO	
-		-		-	
		WEIGHT		-	
		Customer Accessible Production Drawing		SIZE A CAGE CODE 00779 DRAWING NO. C=2150422	
				SCALE 1:1 SHEET 2 of 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150422-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150422-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150422-4	-	-	-
	2-2150422-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150422-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150422-4	-	-	-
	2-2150422-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150422-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150422-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: G&H(LEAR) TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SIKO 2-FSH. 6,3-0,8			
WIRE STRIP LENGTH 4.70-5.30 mm [.185-.209 IN]		INSULATION DIAMETER RANGE Ø3.10-3.70 mm [.122-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED	-	-	-
TE TERMINAL	G&H(LEAR) TERMINAL	TE TERMINAL	G&H(LEAR) TERMINAL
2113439-1	26112.123.178	2113439-3	26112.201.178
2113439-2	26112.123.009	2113439-4	TERM403-CK9

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
2.50mm2		2.02+/-0.05 [.080+/- .002]		7.1
2.00mm2		1.86+/-0.05 [.073+/- .002]		8.9
1.50mm2		1.70+/-0.05 [.067+/- .002]		10.5



- 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: 8-2150422-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150422-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150422-5
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 & 242.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- 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.

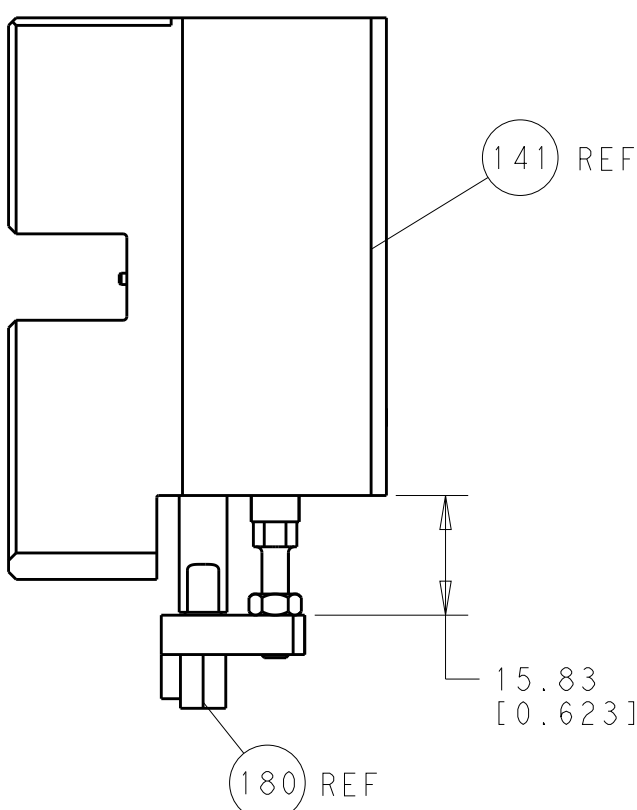
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77-27-25-22-21					PART NO	DESCRIPTION	ITEM NO

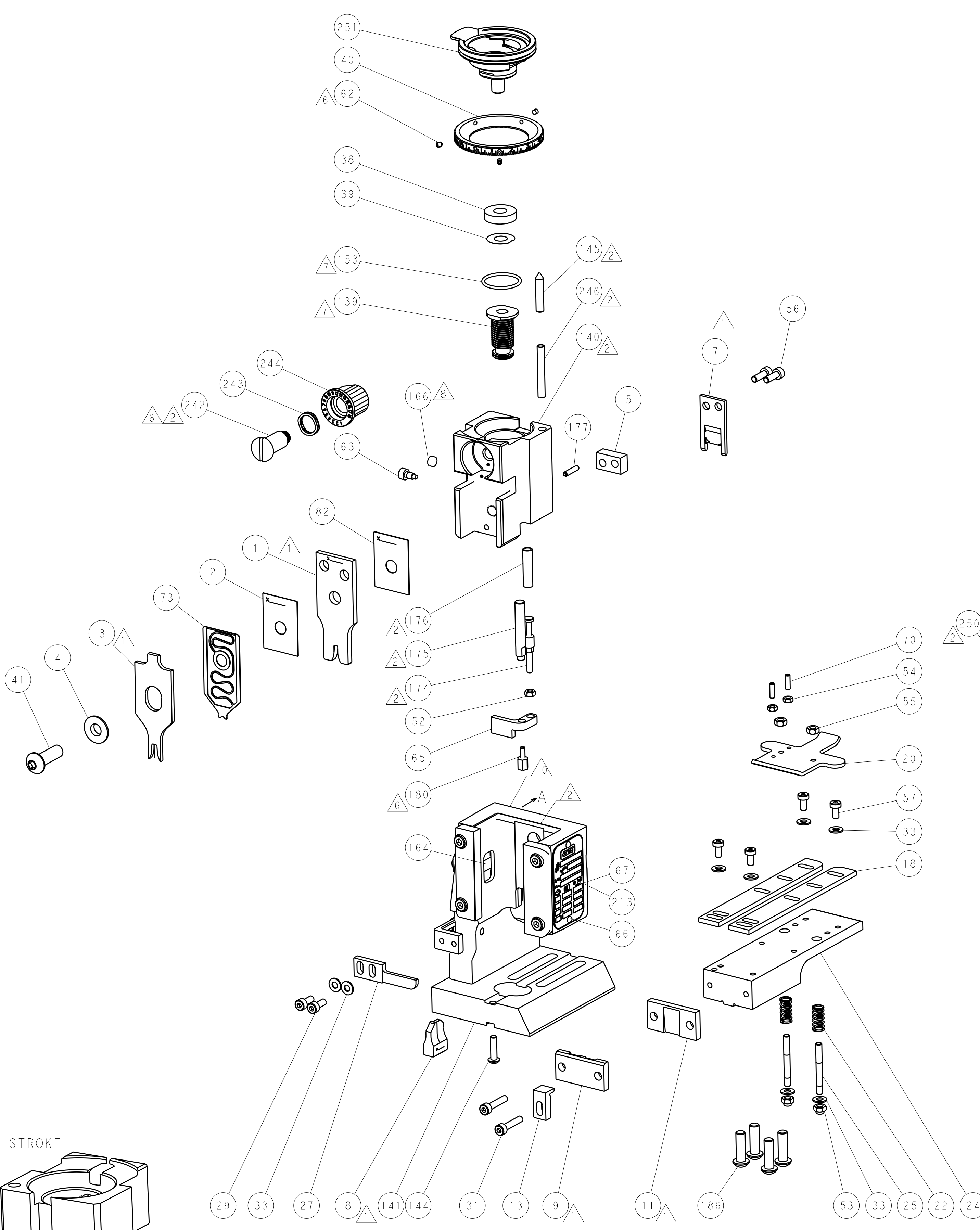
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

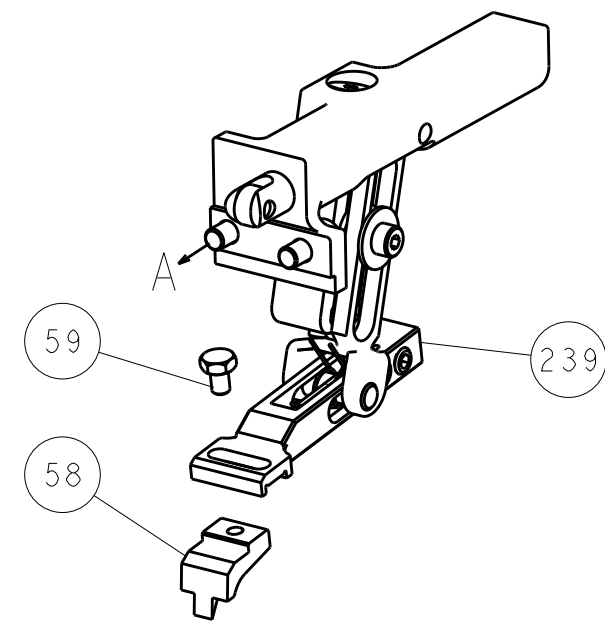
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



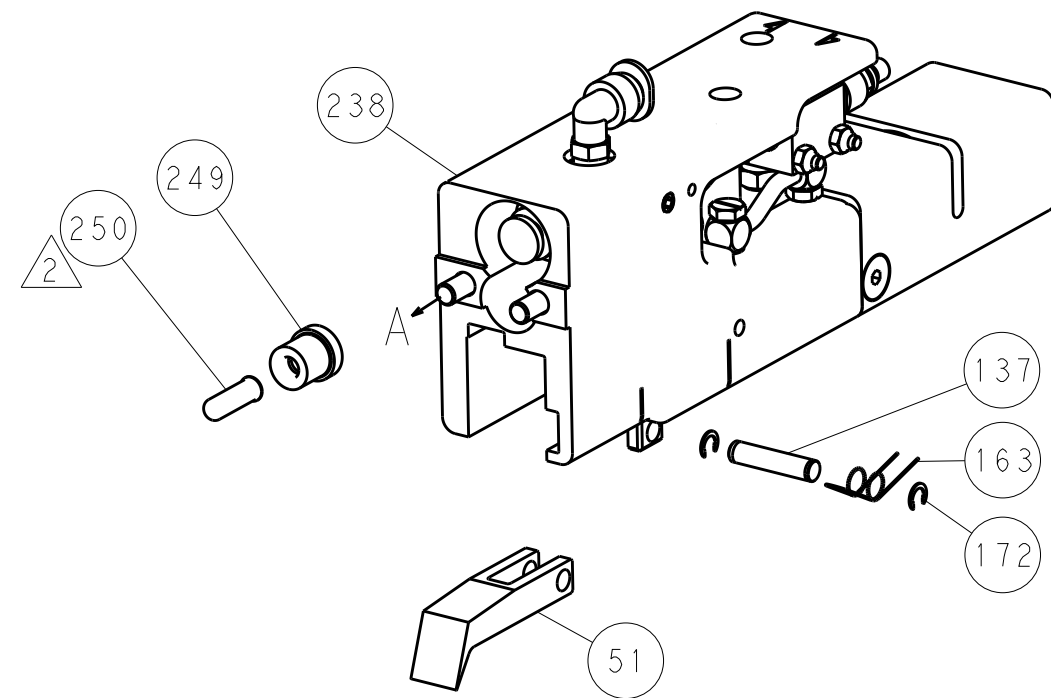
HOLDDOWN SET-UP



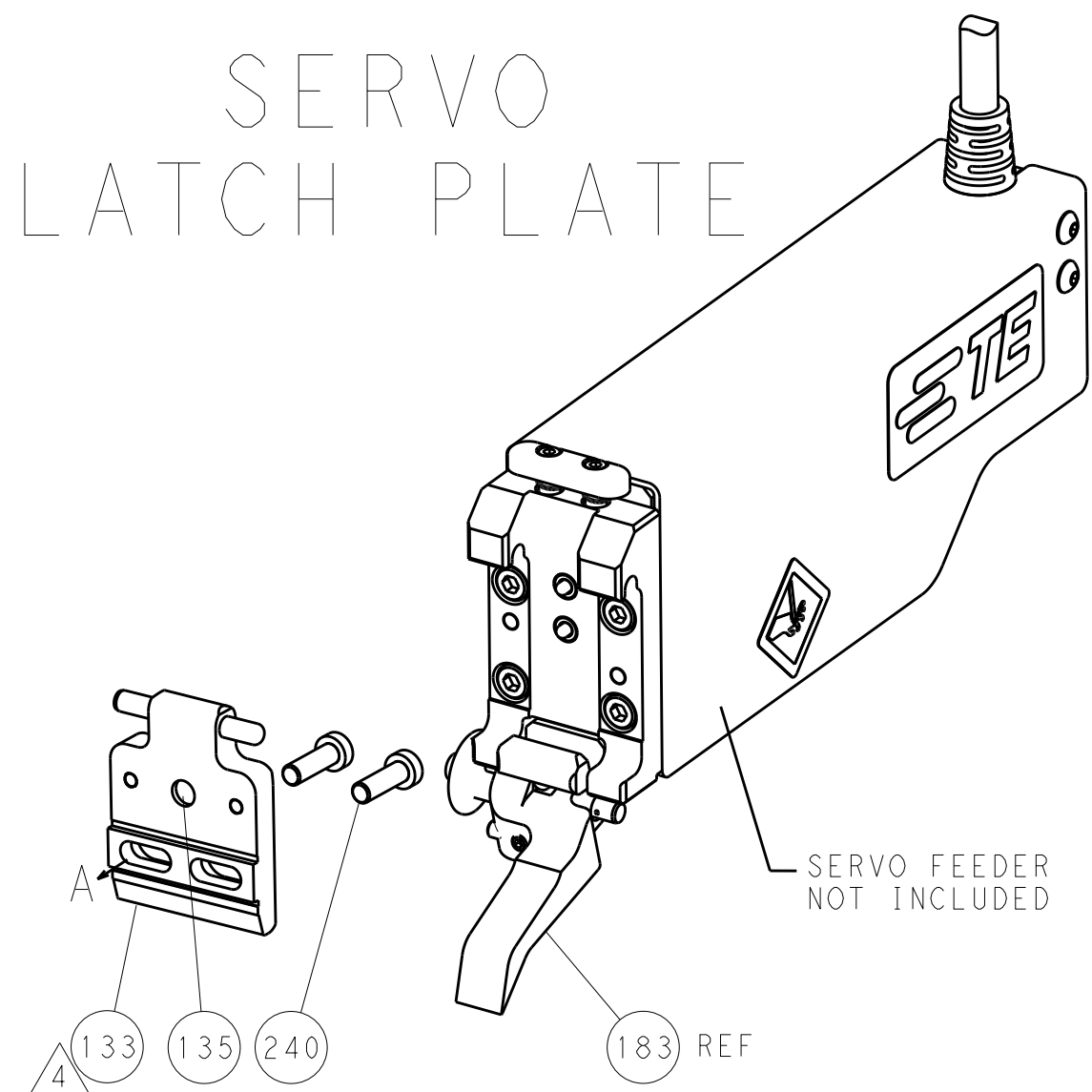
FEED TYPE
MECHANICAL



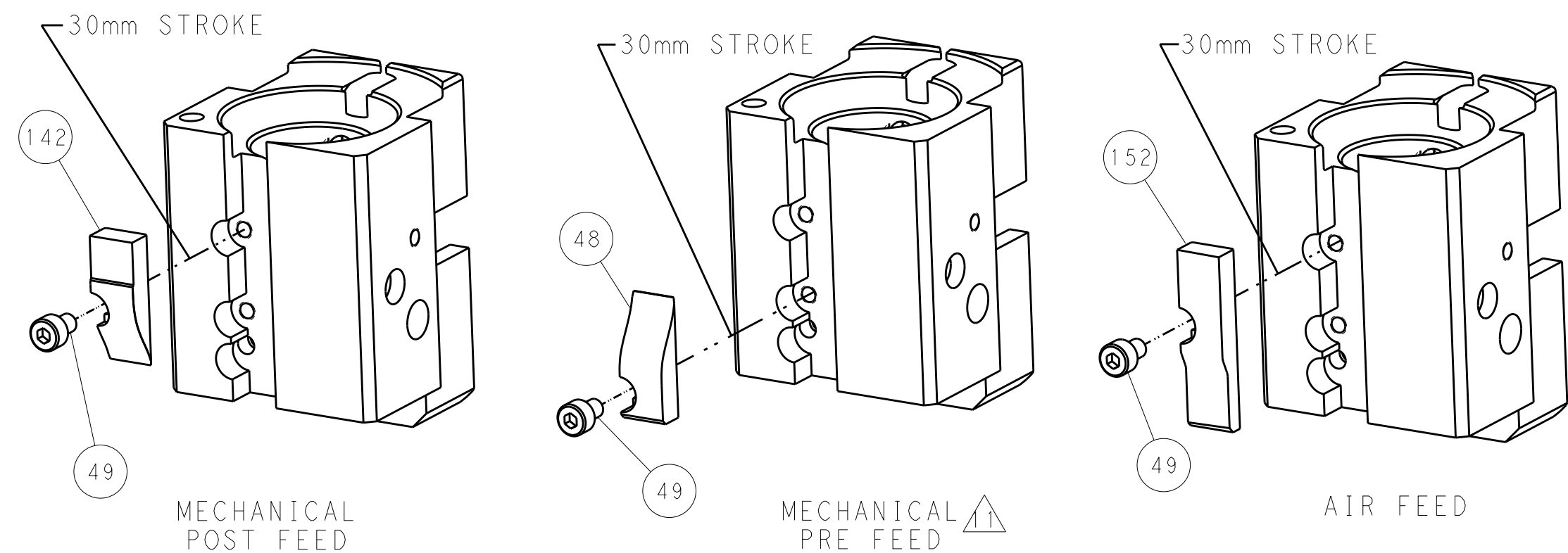
PNEUMATIC



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)

1ST PUBLISHED BY: COMPANY/ISSUED FOR: BY: DATE: 26FEB2014 1ST IS SUBJECT TO COMPANY/ISSUED FOR: BY: DATE: 26FEB2014 2ND IS SUBJECT TO COMPANY/ISSUED FOR: BY: DATE: 26FEB2014				DWN: K. HUANG 26FEB2014 CHK: L. ZHANG 26FEB2014 APVD: J. GUO 26FEB2014			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME	
mm		0 PLC ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.001		APPLICATION SPEC		SIZE	
MATERIAL		FINISH		WEIGHT		CAGE CODE	
				Customer Accessible Production Drawing		DRAWING NO	
				SCALE		RESTRICTED TO	
				1:1		SHEET 4 OF 4	
						REV A	