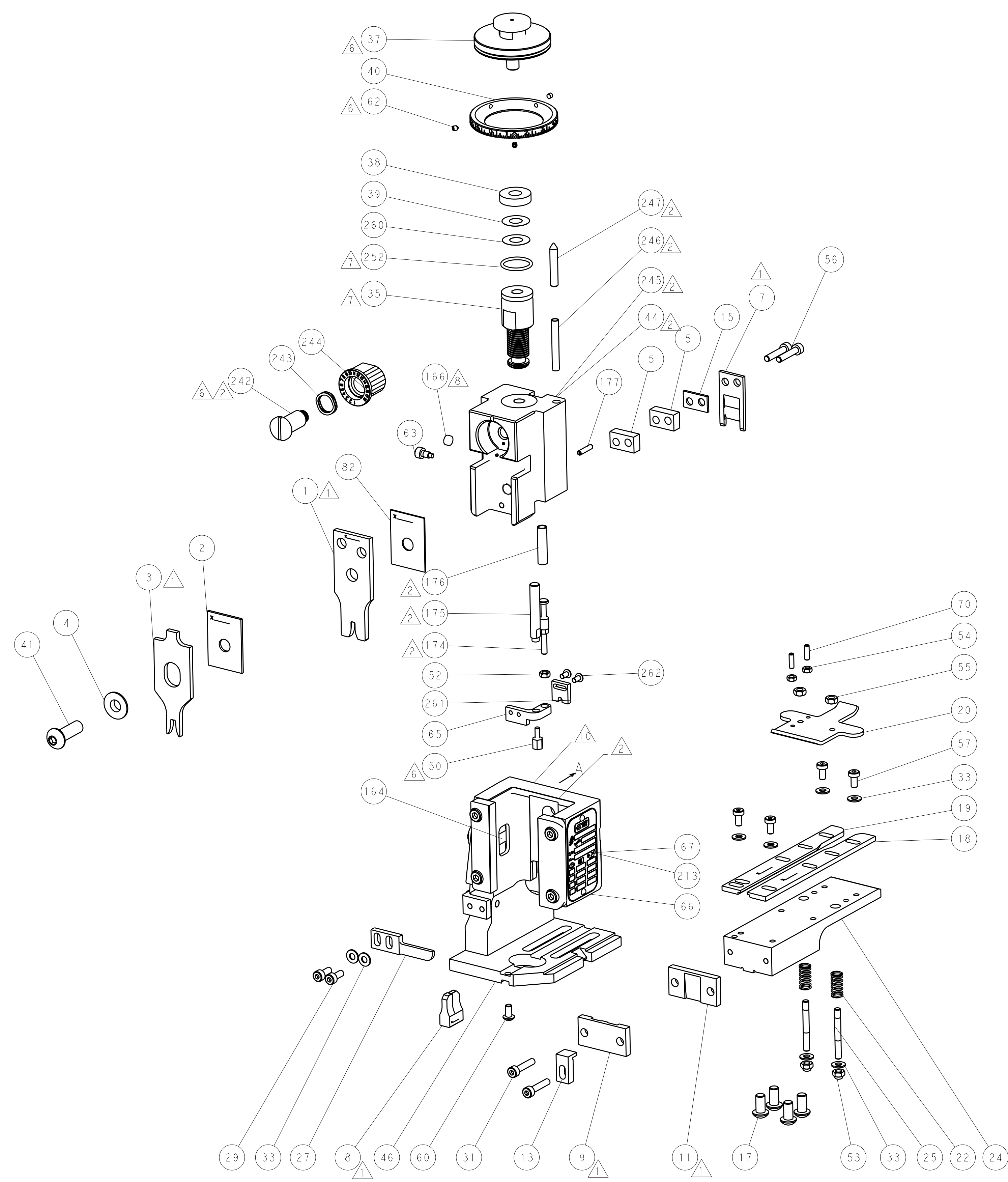
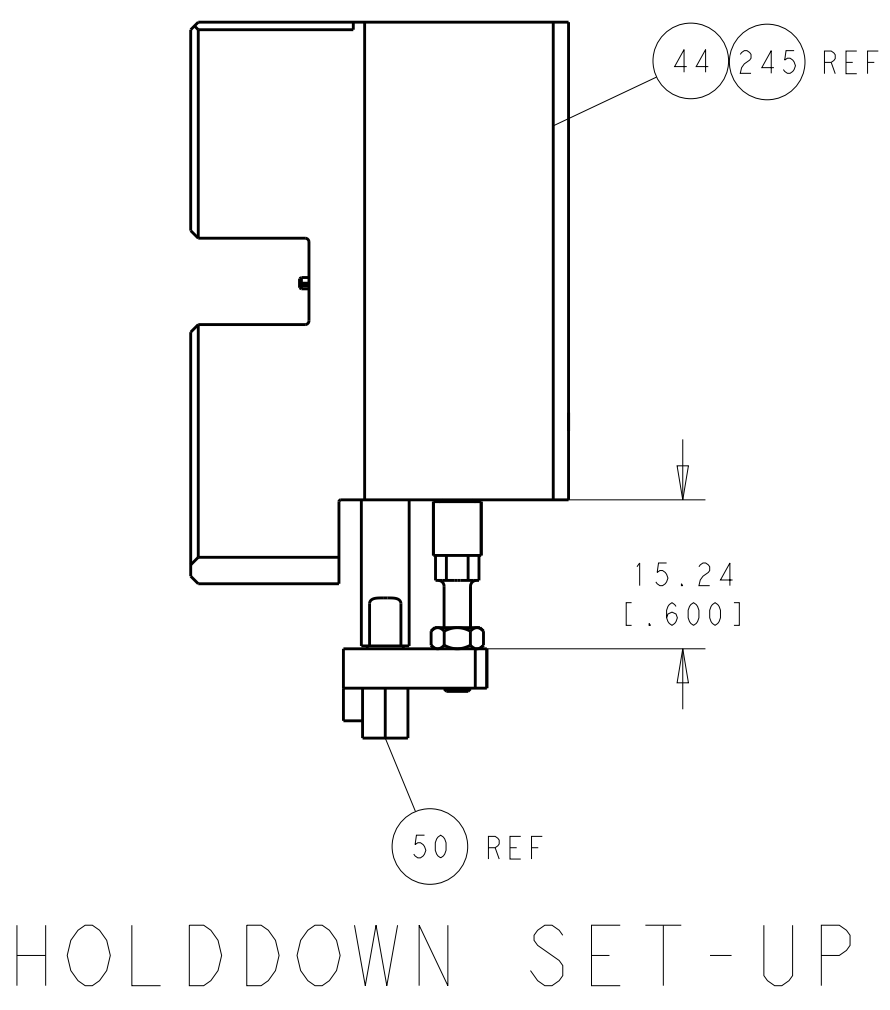


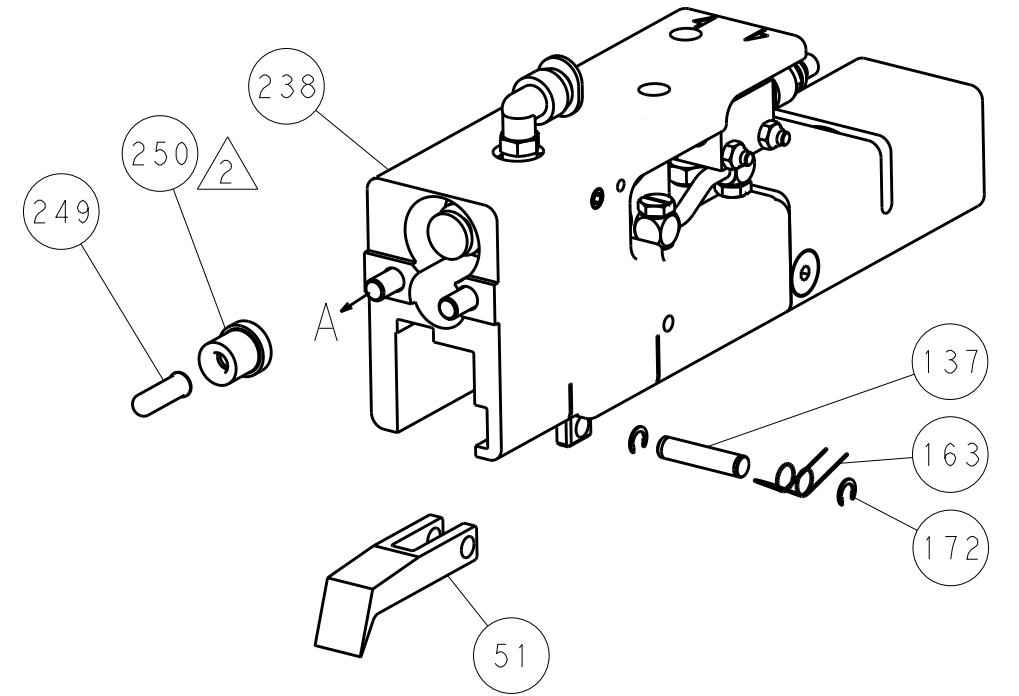
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION		DATE	OWN
		-	-	SEE SHEET 1		-	-

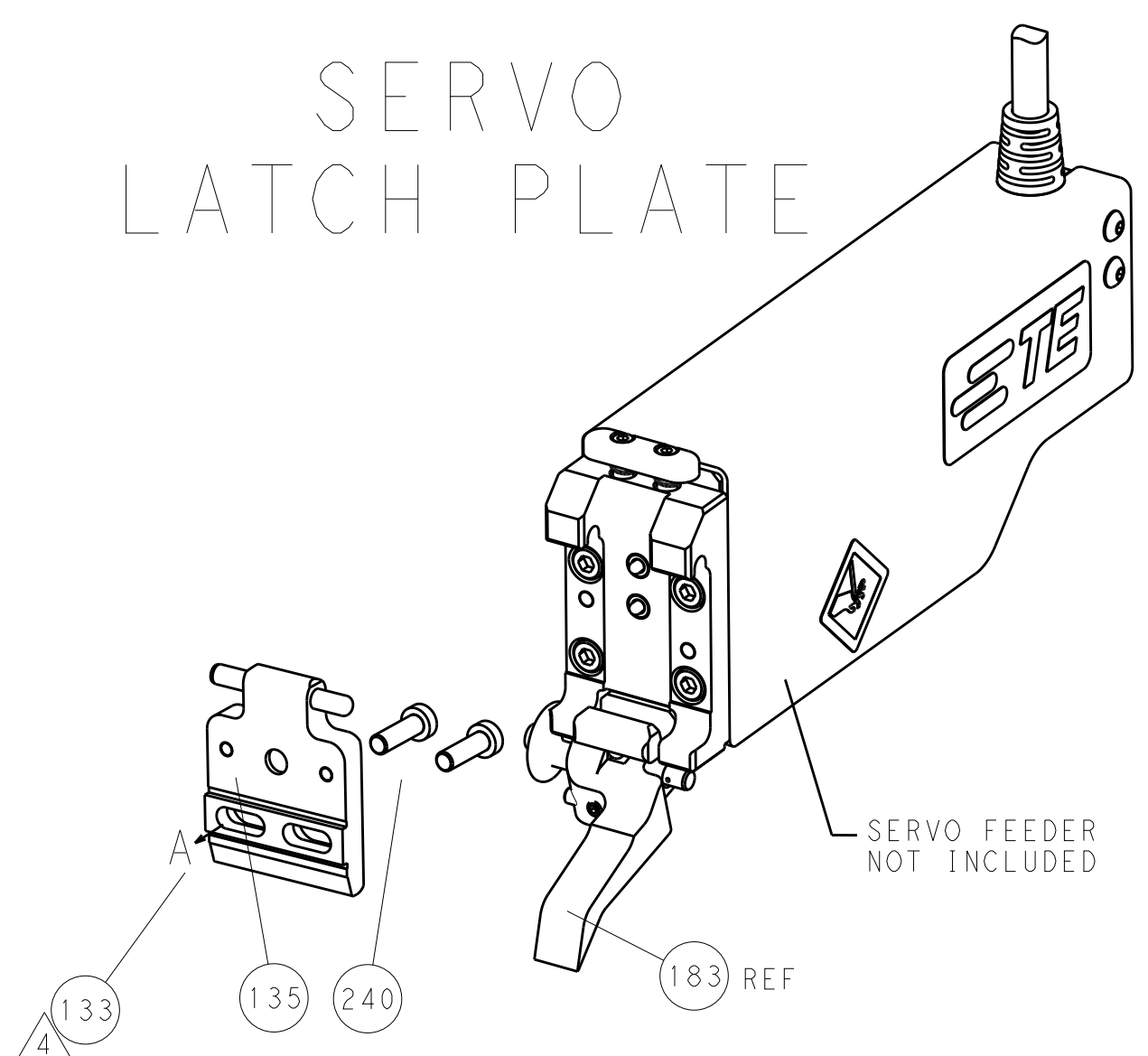
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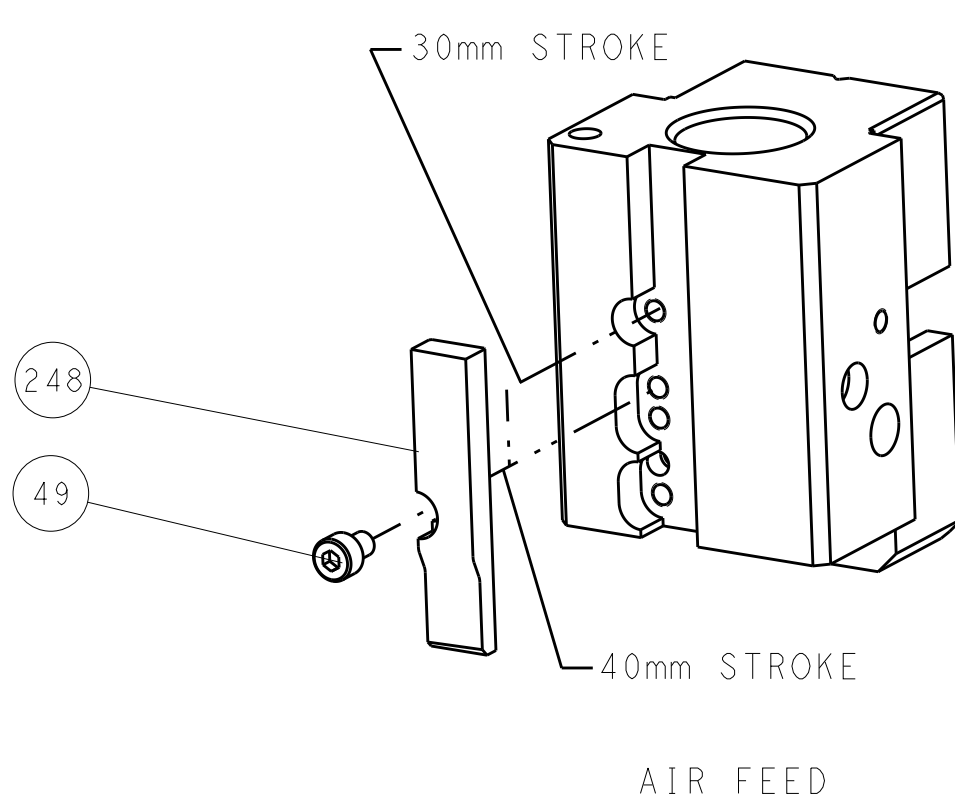
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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

1ST PUBLISHED BY: COMPANY LOGO FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE CONTACTED FOR THE LATEST REVISION.		OWN C. CHEN CHK S. XI APVD I. CRUZ	24JAN2013 24JAN2013 24JAN2013	NAME Ocean End Feed Applicator	SIZE A1	CAGE CODE 00779	DRAWING NO. 2150313	RESTRICTED TO -
DIMENSIONS: mm		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		PRODUCT SPEC -		APPLICATOR SPEC -		
MATERIAL -		FINISH -		WEIGHT -		Customer Accessible Production Drawing		
				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					
	2-2150313-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	2063961-1	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150313-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150313-4	-	-	-
	2-2150313-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	-	-	2063961-1	-	-	-	-
	2-2150313-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150313-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.06 mm [.160]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3MM FASTIN-FASTON TAB			
WIRE STRIP LENGTH 5.36-5.79 mm [.211-.228 IN]		INSULATION DIAMETER RANGE Ø2.40-3.70 mm [.094-.146 IN]	
TERMINAL APPLICATION 		-	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928947-1	928947-2	928947-3	928947-4
928947-5	928947-6	928947-7	928947-8

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2			1.97+/-0.05 [0.078+/-0.002]		6.5
2.00mm2			1.83+/-0.05 [0.072+/-0.002]		8.2
1.50mm2			1.69+/-0.05 [0.067+/-0.002]		9.6



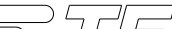
- ① RECOMMENDED SPARE PARTS
- ② GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- ④ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150313-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150313-5
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 50, 62 & 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

-	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	262
-	1	1	1	1976053-1	LOCATER BLOCK,TERMINAL	261
-	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	DIST	REVISIONS					
	A	66	P	LTR	DESCRIPTION	DATE	DNW	APVD
				-	SEE SHEET 1	-	-	-

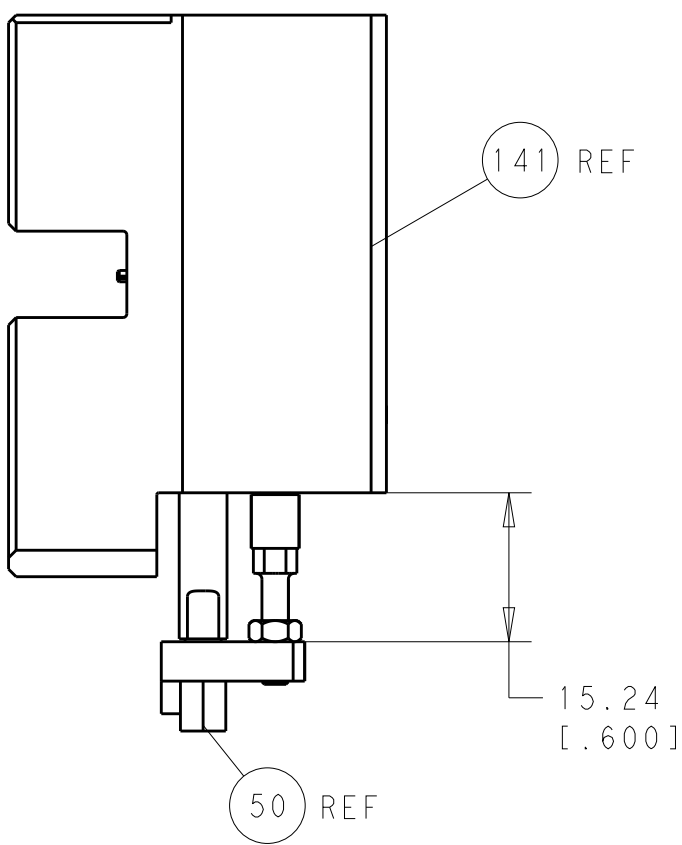
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-7	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
-	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	171
-	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	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	455888-7	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	66
-	1	1	1	1901681-8	HOLDDOWN, TERMINAL	65
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	4	4	4	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	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	1	2119792-2	PAWL, EF, AIR	51
-	1	1	1	1-1752354-1	STANDOFF, HOLD-DOWN	50
-	-	-	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
-	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	1320906-1	STUD, THREADED	25
-	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1752373-4	DRAW	20
-	1	1	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	1	1	1	6-240641-4	SPACER	15
-	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
-	1	1	1	3-690482-2	PLATE, FRONT SHEAR	9
1	1	1	1	1338673-8	ANVIL, COMBINATION	8
-	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	-	6
-	2	2	2	2-240641-5	SPACER	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	6-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1-455888-3	SPACER, CRIMPER	2
1	1	1	1	4-1633305-1	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION IT IS HEREBY DECLARED THAT THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED AND SHOULD BE CONTROLLED FOR THE LATEST EDITION.		DWN C CHEN 24JAN2013 CHK S XI 24JAN2013 APVD CRUZ 24JAN2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC $\pm .$ 1 PLC ± 0.5 2 PLC ± 0.13 3 PLC ± 0.013 4 PLC ± 0.0001 ANGLES $\pm .$		NAME Ocean End Feed Applicator -	
		PRODUCT SPEC APPLICATION SPEC -		SIZE CAGE CODE DRAWING NO A1 00779 C=2150313	
MATERIAL -		FINISH -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 3 OF 4 REV A	

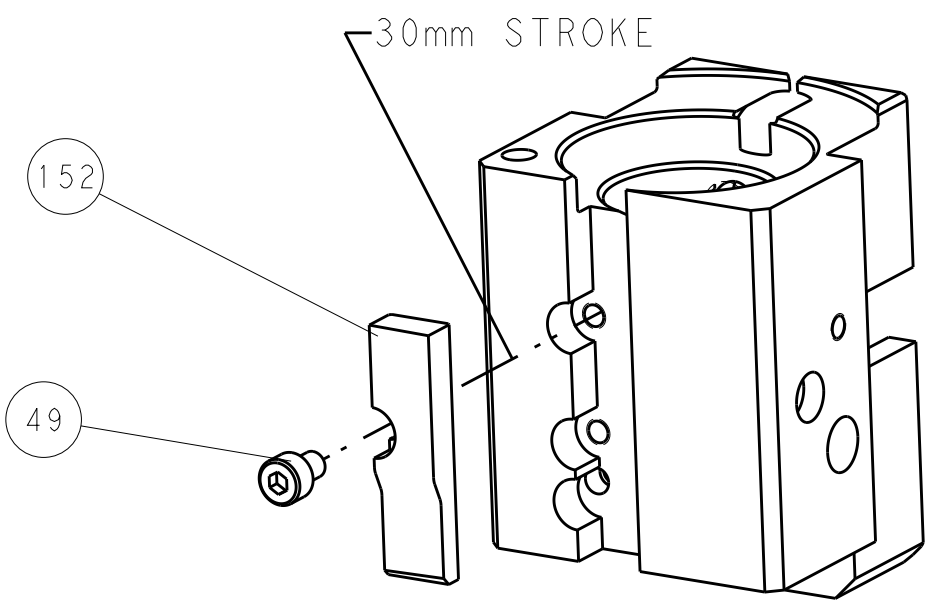
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

HOLDDOWN SET-UP



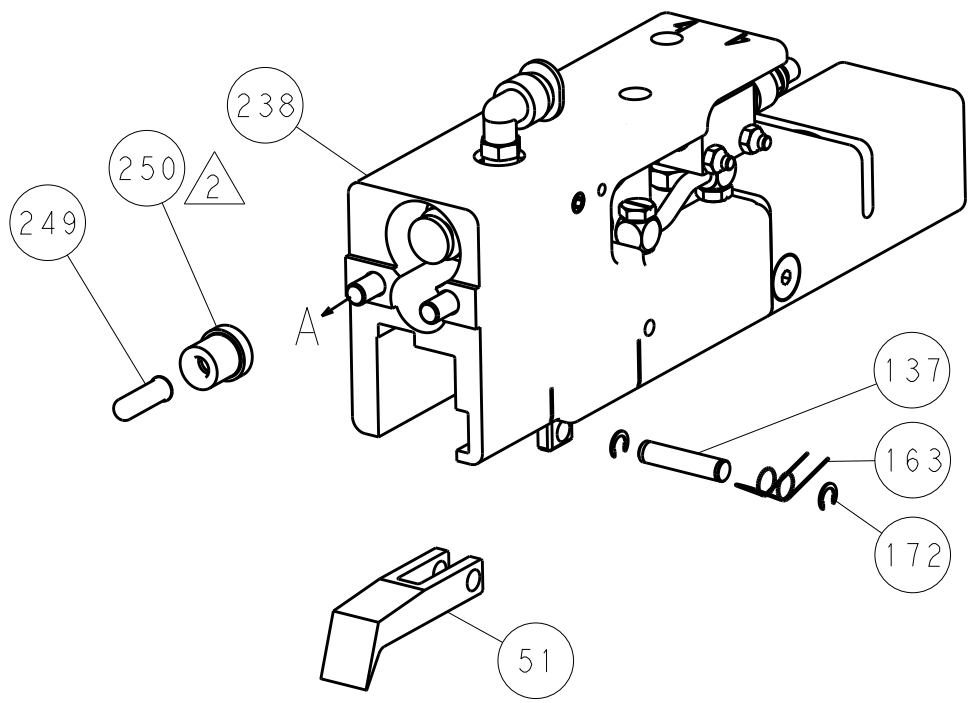
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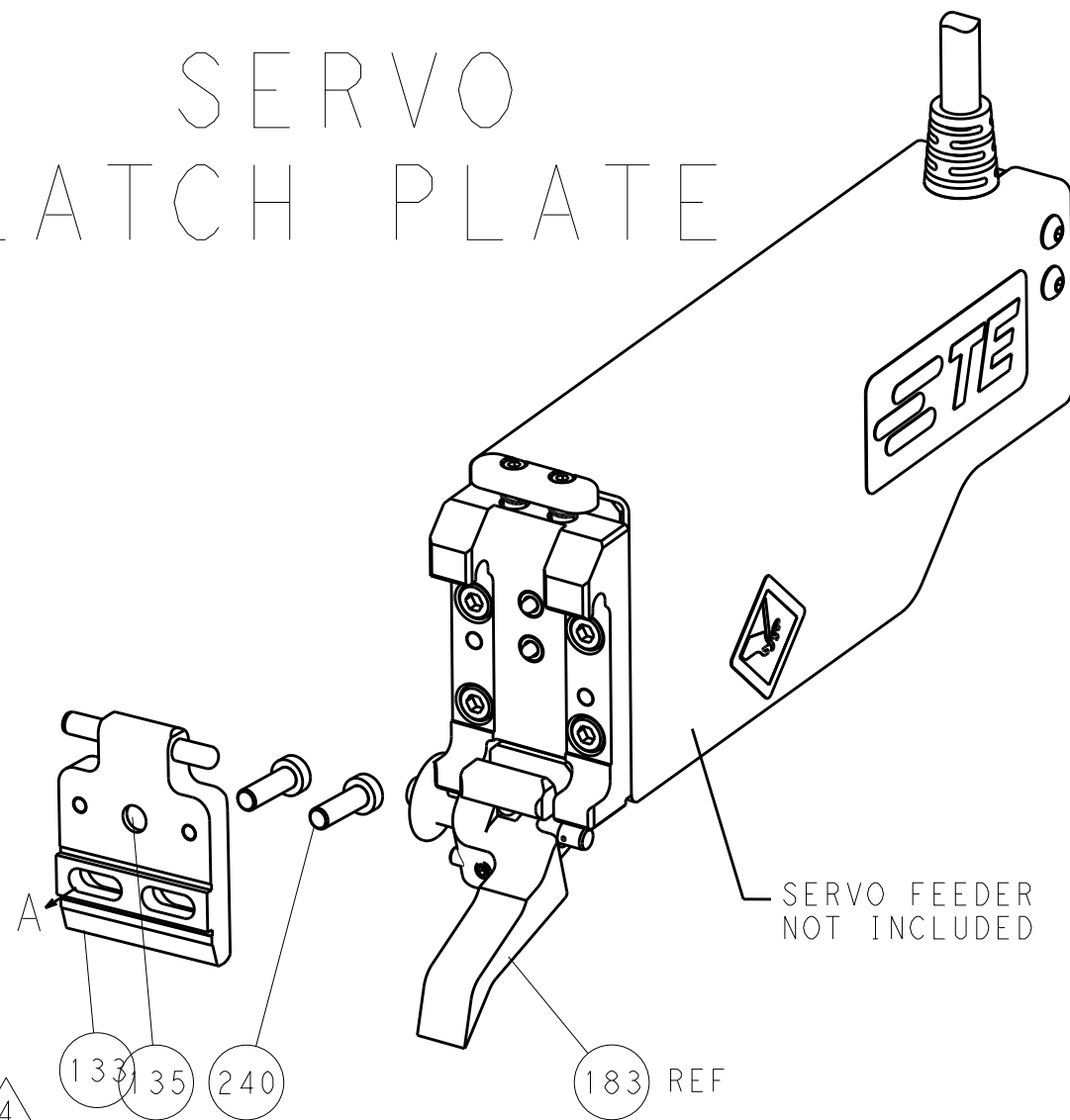
AIR FEED

FEED TYPE

PNEUMATIC



SERVO LATCH PLATE



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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.				DWN: C. CHEN 24JAN2013 CHK: S. XI 24JAN2013 APVD: J. CRUZ 24JAN2013				STE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.001 ANGLES FINISH				NAME: Ocean End Feed Applicator			
MATERIAL: -				PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -				SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150313			
				Customer Accessible Production Drawing				SCALE: 1:1 SHEET: 4 OF 4 REV: A			