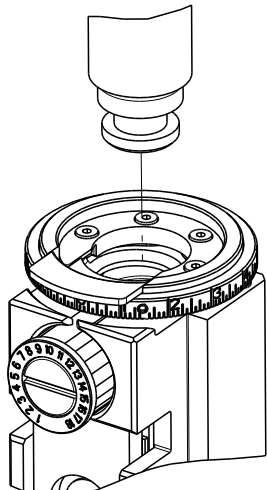


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
© COPYRIGHT 20		20	
BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2150524-2	B	FINE CRIMP HEIGHT ADJUST
	2-2150524-5	B	FINE CRIMP HEIGHT ADJUST
	2-2150524-7	B	FINE CRIMP HEIGHT ADJUST
	7-2150524-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	7.62 mm [.300]	O
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 4.39-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø3.81-5.59 mm [.150-.220 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2084		-	-
TERMINALS APPLIED		-	-
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61289-1	42947-2	42947-4	
42946-2	42947-3	640012-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
8 AWG		4.04+/-0.05 [.159+/- .002]		2.3
10 AWG		3.53+/-0.05 [.139+/- .002]		8.4
12 AWG		3.23+/-0.05 [.127+/- .002]		11.9



- 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: 8-2150524-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150524-5

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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

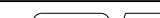
-  TERMINAL LUBRICANT IS RECOMMENDED.

-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-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	2079988-1	BUSHING, LCH5-12, MISUMI	249
	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	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
6	-	1	1	1	1752354-2	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
8	-	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
7	-	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
7	-	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	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	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, 2 x .188	66
	-	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
	-	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	2119792-3	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	2119644-5	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	4-1901696-1	STRIP GUIDE, REAR	19
	-	1	1	1	4-1901695-1	STRIP GUIDE, FRONT	18
	-	1	1	1	3-240641-0	SPACER	16
	-	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	1	1	240644-1	PLATE, REAR SHEAR	11
	-	2	2	2	1-240645-1	SPACER, SHEAR PLATE	10
	-	1	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	1	1	1-1803059-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	8-240651-2	BLADE, SLUG	7
	-	-	-	-	-	-	6
	-	1	1	1	7-240641-3	SPACER	5
	-	1	1	1	238009-5	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	8-1633965-4	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1-455888-4	SPACER, CRIMPER	2
1	1	1	1	1	1-456430-6	CRIMPER, WIRE	1
-77-27-25-22	PART NO					DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC CORPORATION 1710 IS DESIGNATED AS A CONTROLLED DOCUMENT FOR THE ELECTRONIC CORPORATION SHOULD BE CONTROLLED FOR THE LATEST VERSION.		OWN J. HOWE 12 JAN 2015		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±°		NAME Ocean End Feed Applicator -	
		APVD U. GUO 12 JAN 2015 PRODUCT SPEC - APPLICATION SPEC -		SIZE A1 CAGE CODE 00779 DRAWING NO C=2150524 RESTRICTED TO -	
MATERIAL FINISH		WEIGHT -		SCALE 1:1 SHEET 3 of 4 REV B	
Customer Accessible Production Drawing					

