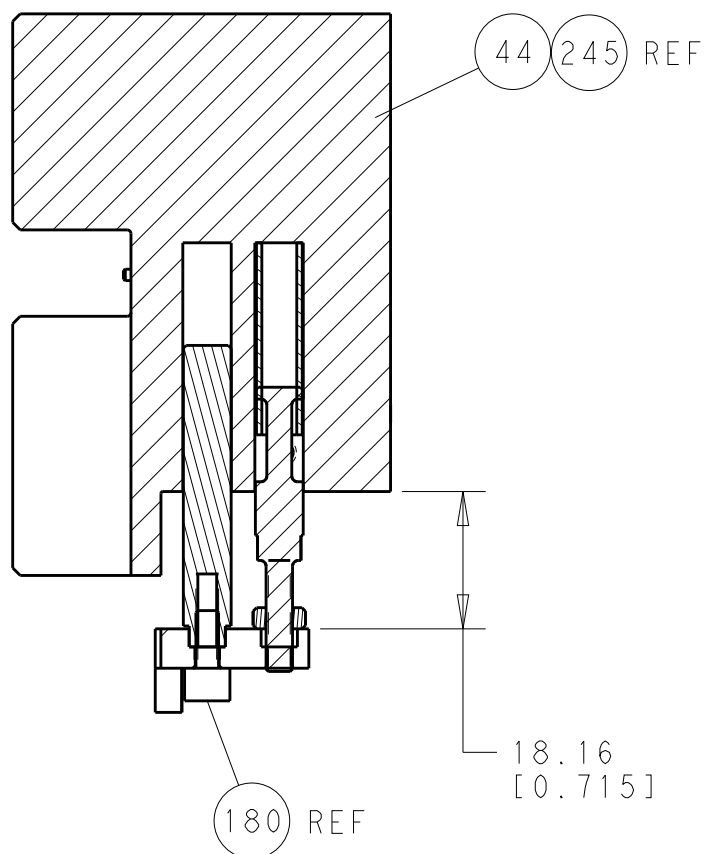
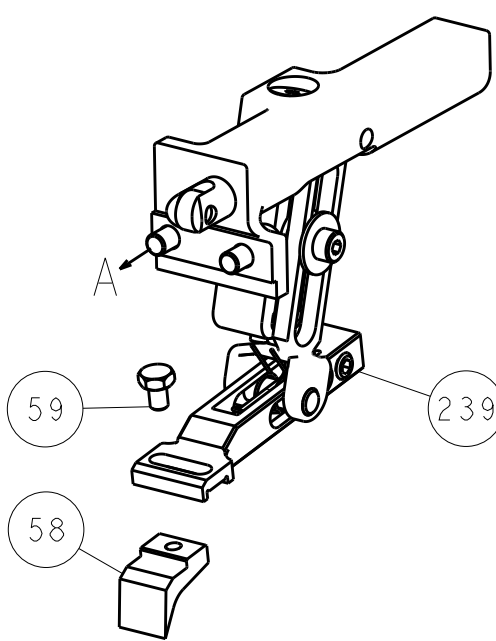


LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

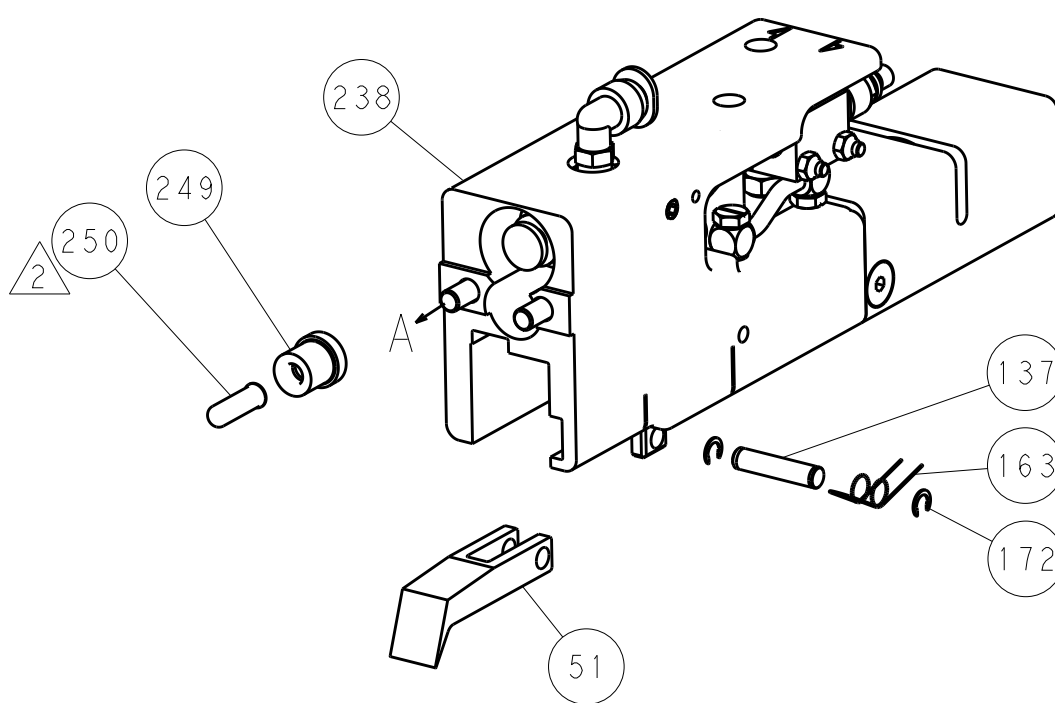


HOLDDOWN SET-UP

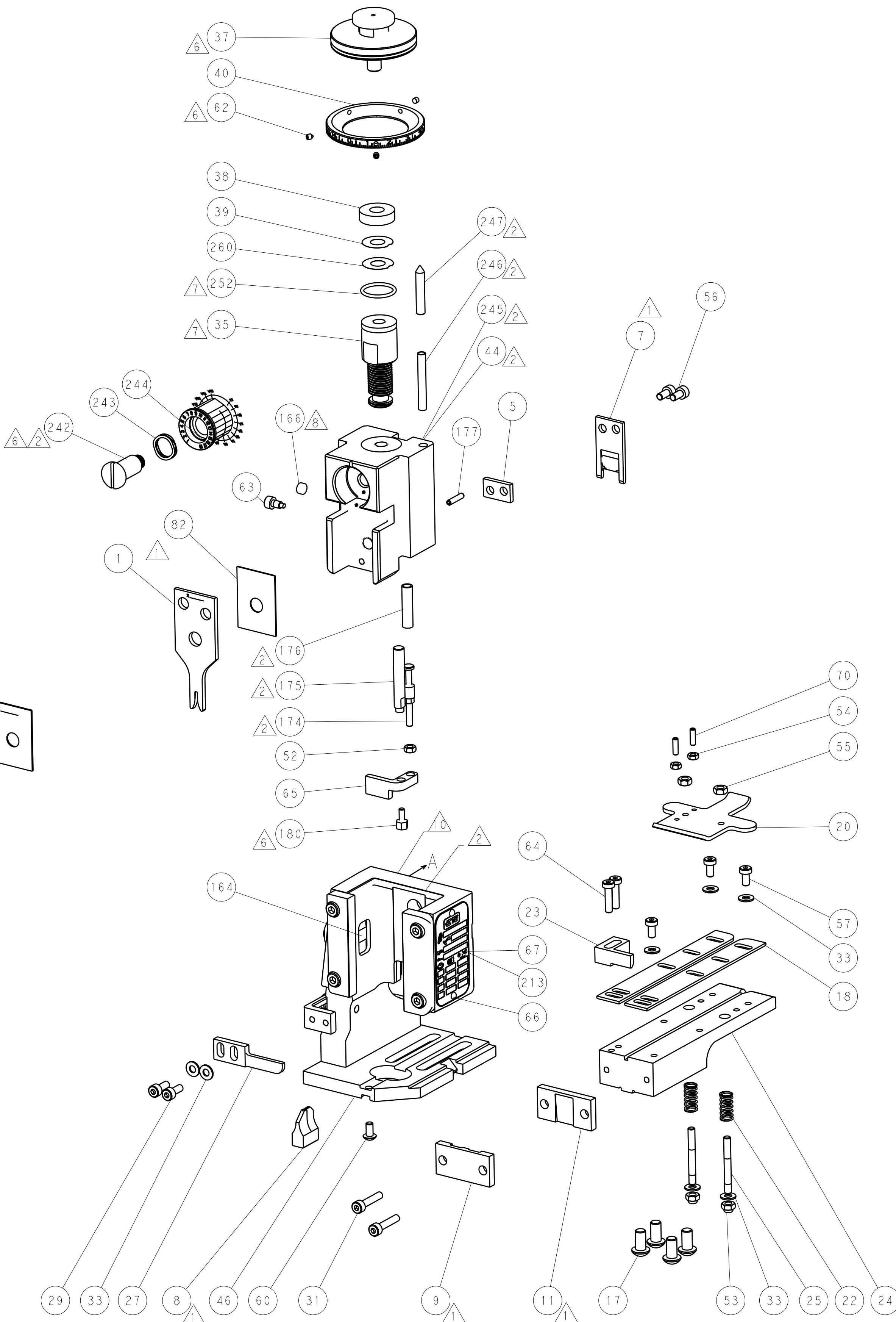
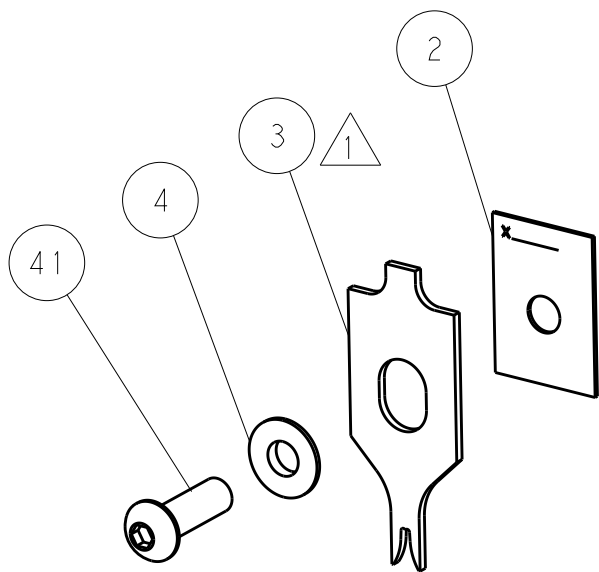
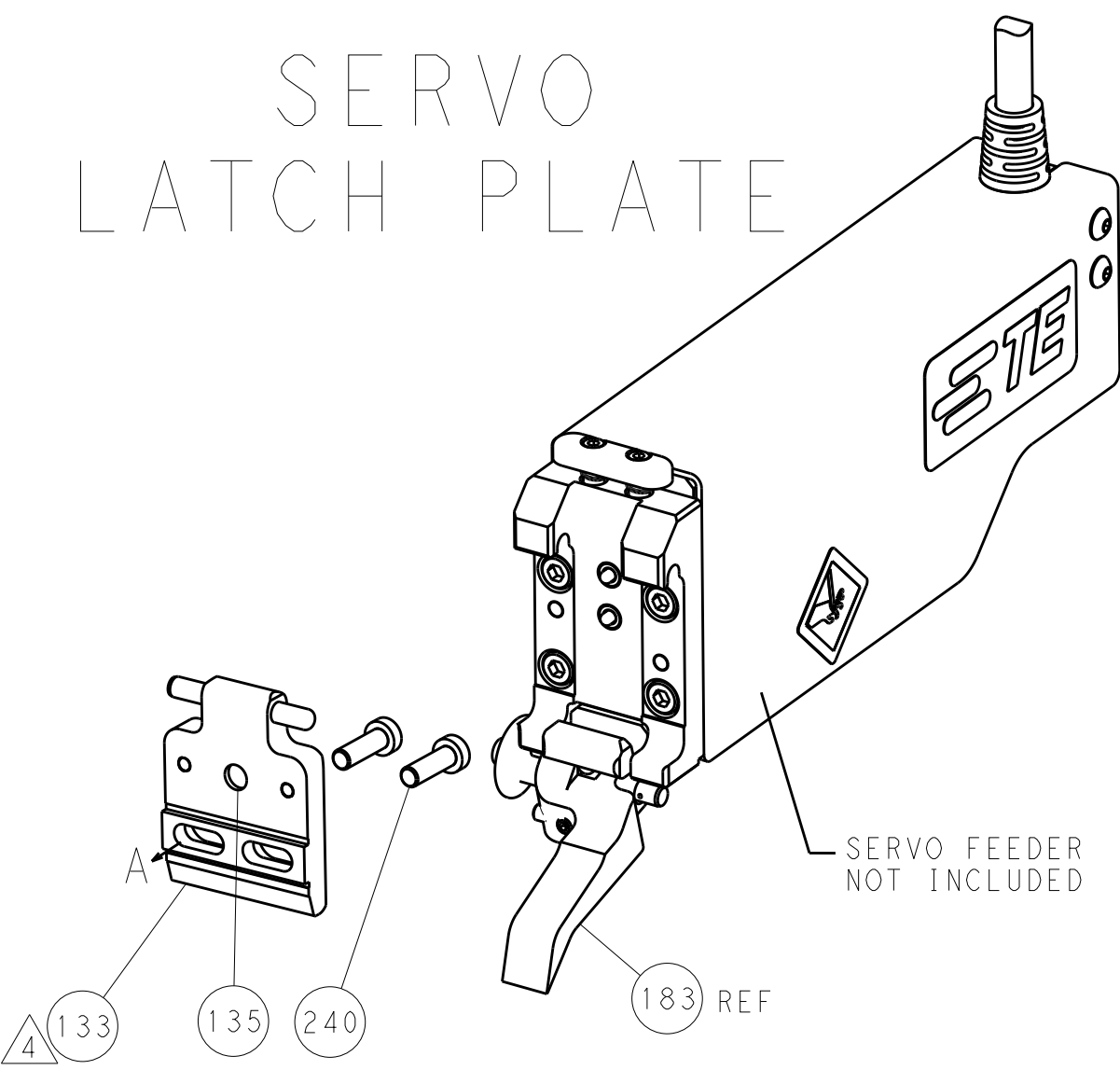
FEED TYPE
MECHANICAL



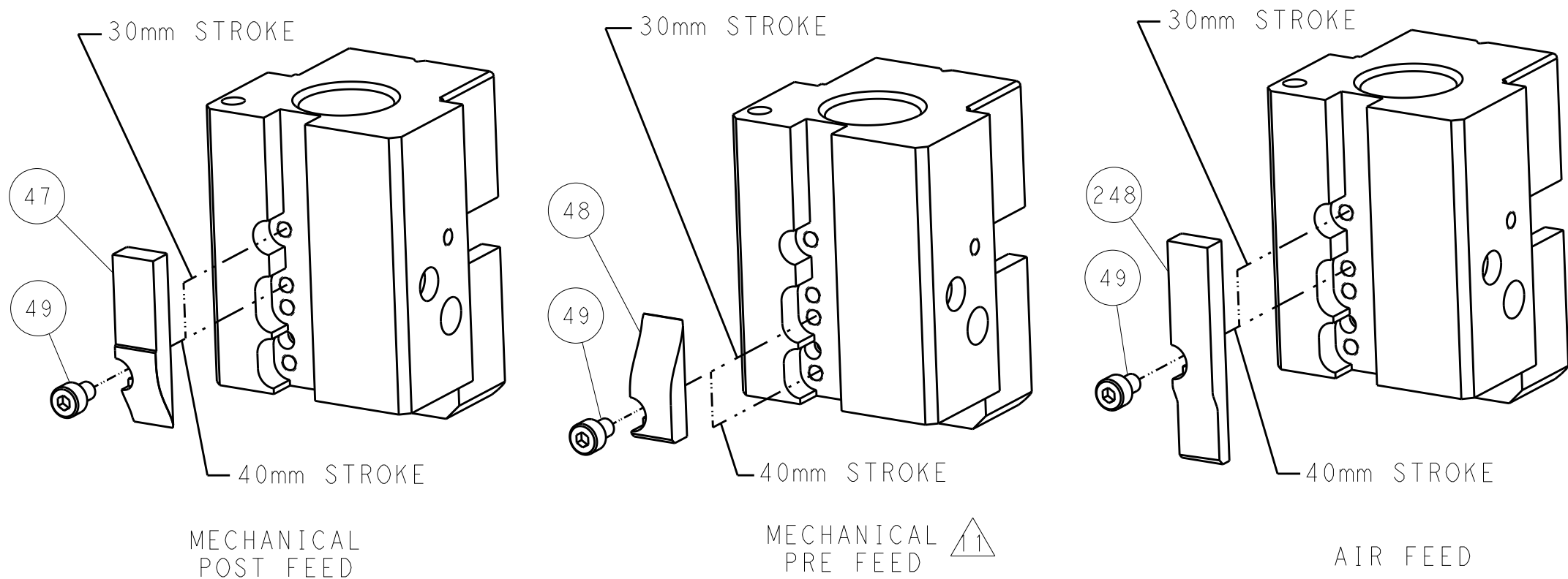
PNEUMATIC



SERVO
LATCH PLATE

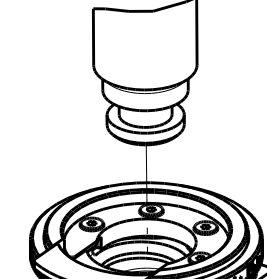


CAM POSITIONS

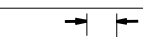


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1ST PUBLISHED BY: COMPANY/ISSUE FOR: THIS ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE/REVISION/REWORK/REWORKING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST POSITION.				DWN K. HUANG 27MAR2014	TE Connectivity Harrisburg, PA 17105-3608	
CHK L. ZHANG 27MAR2014				NAME U. GUO 27MAR2014	Ocean End Feed Applicator	
PRODUCT SPEC				APPLICATION SPEC	SIZE CAGE CODE DRAWING NO 00779 C=2150415	
MATERIAL				WEIGHT	RESTRICTED TO	
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					
						PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-
	2-2150415-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150415-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150415-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150415-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150415-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150415-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150415-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					-	-	-	-	-	-	-
	2-2150415-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2150415-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.29 mm [.090]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTIN-FASTON, .110 SERIES			
WIRE STRIP LENGTH 3.60-4.40 mm [.142-.173 IN]			INSULATION DIAMETER RANGE Ø1.27-2.03 mm [.050-.080 IN]
TERMINAL APPLICATION SPECIFICATION	114-2065	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217281-2	1217281-3		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
20 AWG		1.02+/-0.05 [.040+/- .002]		8.0
22 AWG		0.91+/-0.05 [.036+/- .002]		9.1
24 AWG		0.84+/-0.05 [.033+/- .002]		9.8



- 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: 8-2150415-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150415-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150415-5
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.

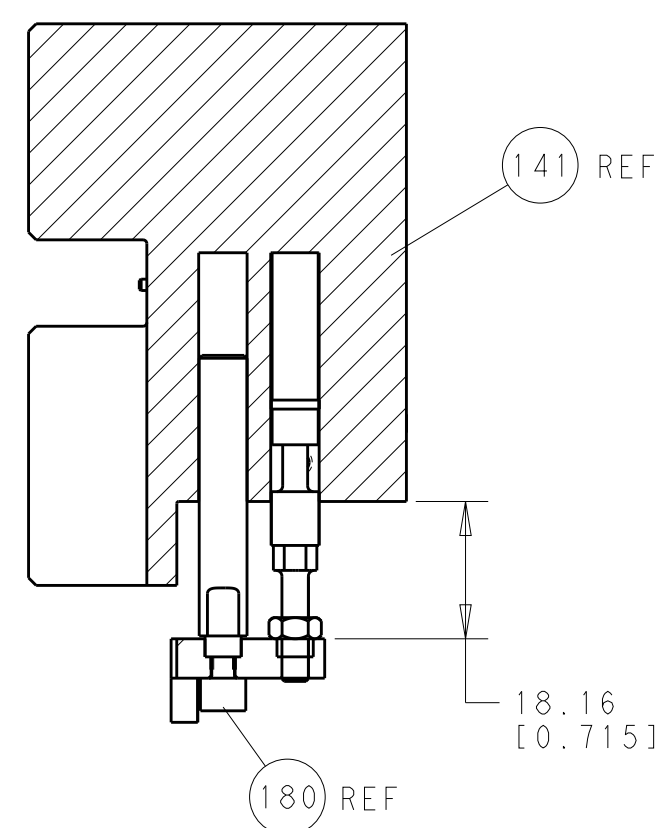
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77-	27-	25-	22-	21	PART NO	DESCRIPTION	ITEM NO

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

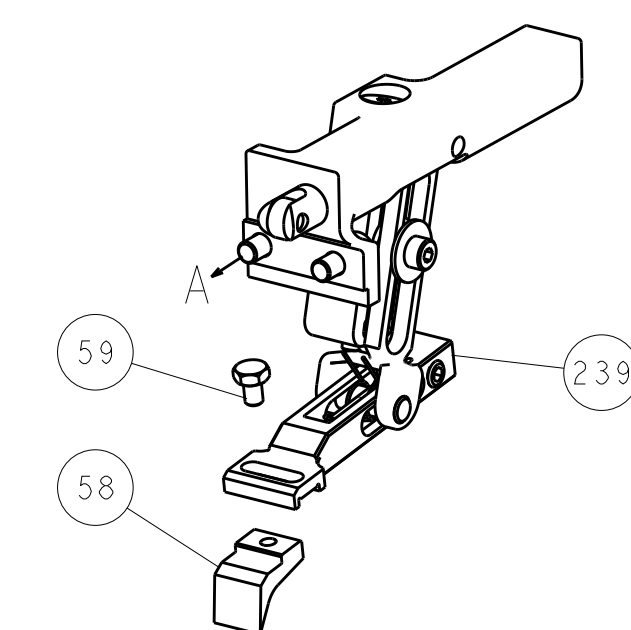
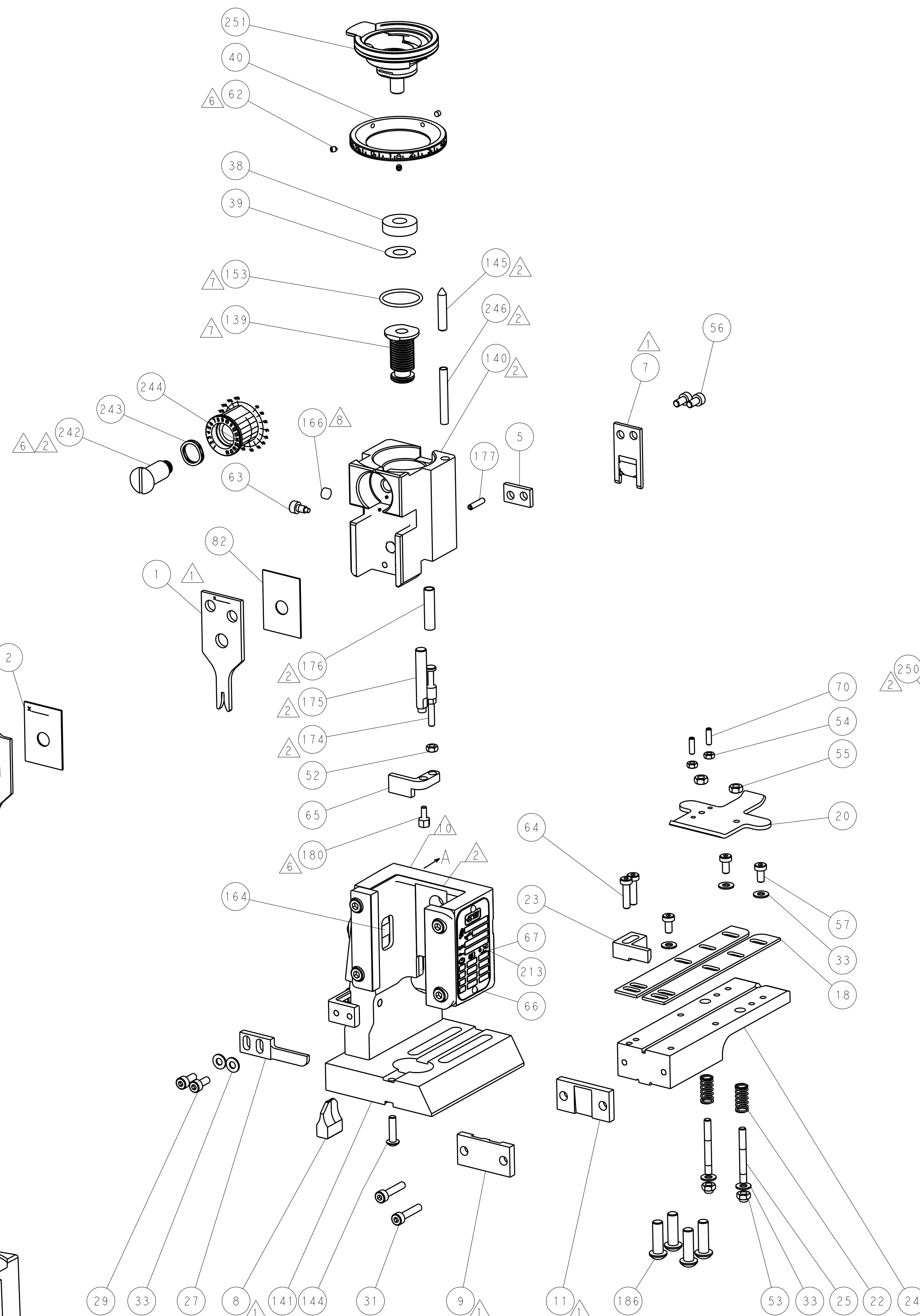
2			1					
SET UP GAUGE 2119599-2		LOC A	DIST 66	REVISIONS				
P	LTR	DESCRIPTION			DATE	DWN	APVD	
	-	SEE SHEET 1			-	-	-	

-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	-	1901697-1	FEED FINGER ASSEMBLY,EF	183
-	1	1	1	1	1752354-2	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	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	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	1	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	1	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	2063961-1	FEED FINGER	58
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	1	-	2119792-2	PAWL, EF, AIR	51
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1752371-9	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-9	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4	DRAG	20
-	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	18
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690482-5	PLATE, FRONT SHEAR	9
-	1	1	1	1	1803059-8	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-7	SPACER	5
-	1	1	1	1	1-238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	1	1	1-456402-7	CRIMPER, WIRE PREMIUM	1
-77-	27-	25-	22-	21	PART NO	DESCRIPTION	ITEM NO

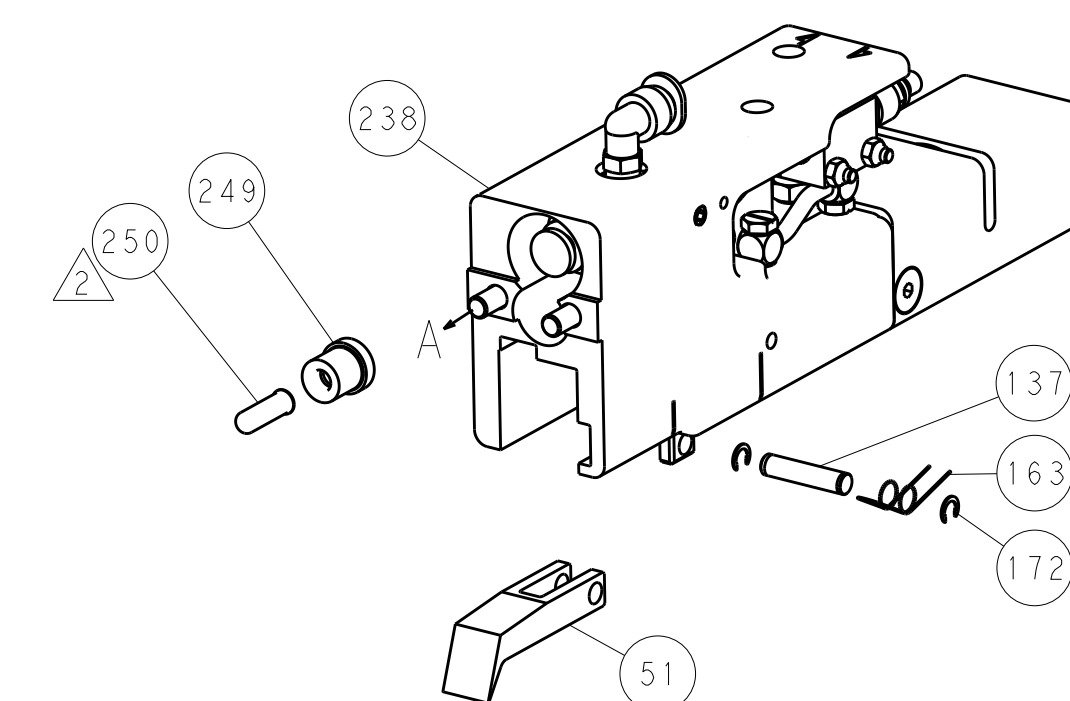
THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY. THE USER SHALL BE RESPONSIBLE FOR THE LATEST REVISION.				OWN K. HUANG 27MAR2014		 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				CHK L. ZHANG 27MAR2014					
mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD H. GUO 27MAR2014		NAME		Ocean End Feed Applicator	
		6 PLG ±.010		PRODUCT SPEC		SIZE		CAGE CODE	
		2 PLG ±0.5		APPLICATION SPEC					
		2 PLG ±0.13				DRAWING NO		RESTRICTED TO	
		2 PLG ±0.013				A1		00779	
		2 PLG ±0.0001				C=2150415		-	
		ANGLES							
MATERIAL		FINISH		WEIGHT					
-		-		-					
Customer Accessible Production Drawing						SCALE		1:1	
						SHEET		3	
						OF		4	
						REV		A	



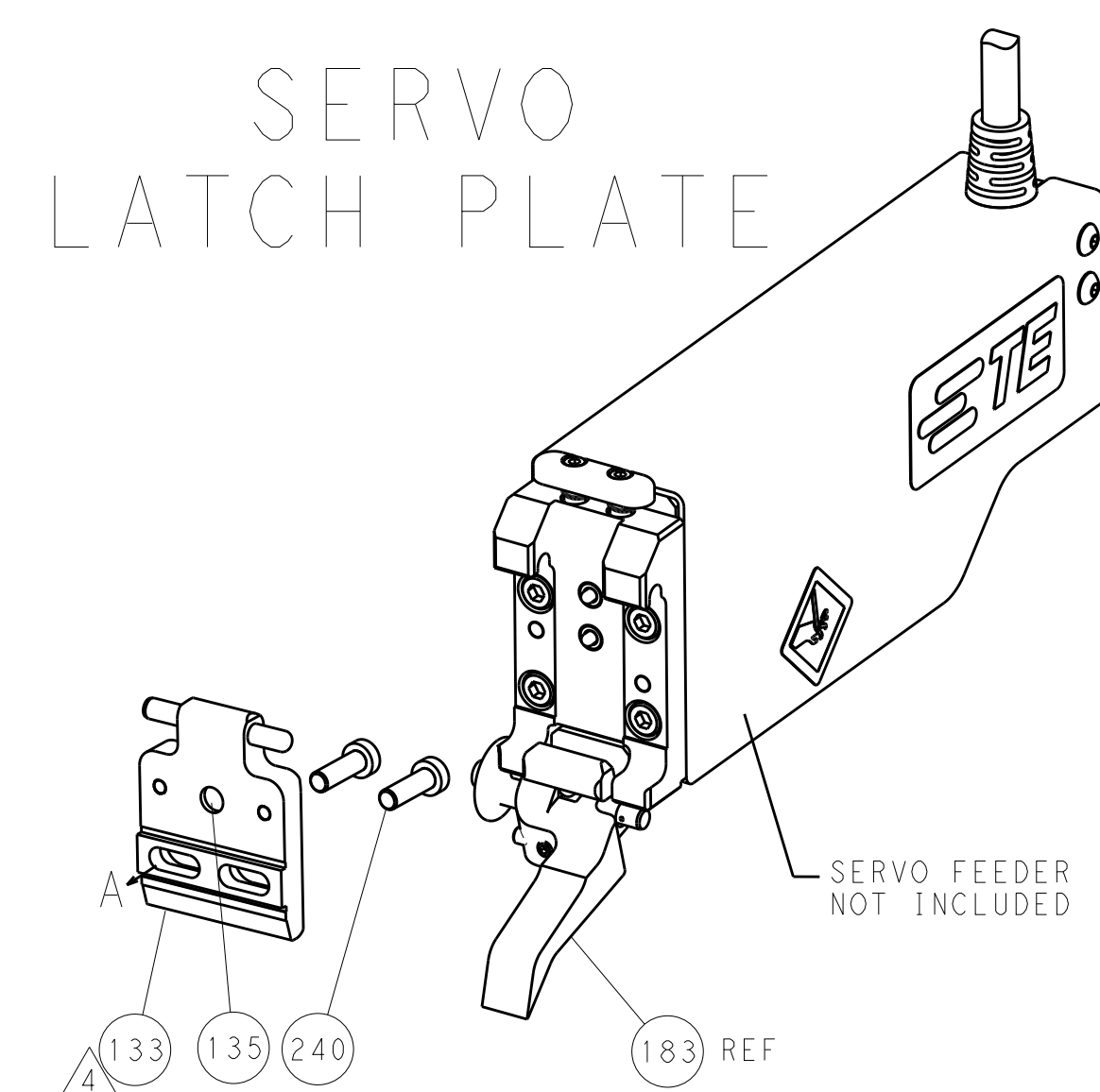
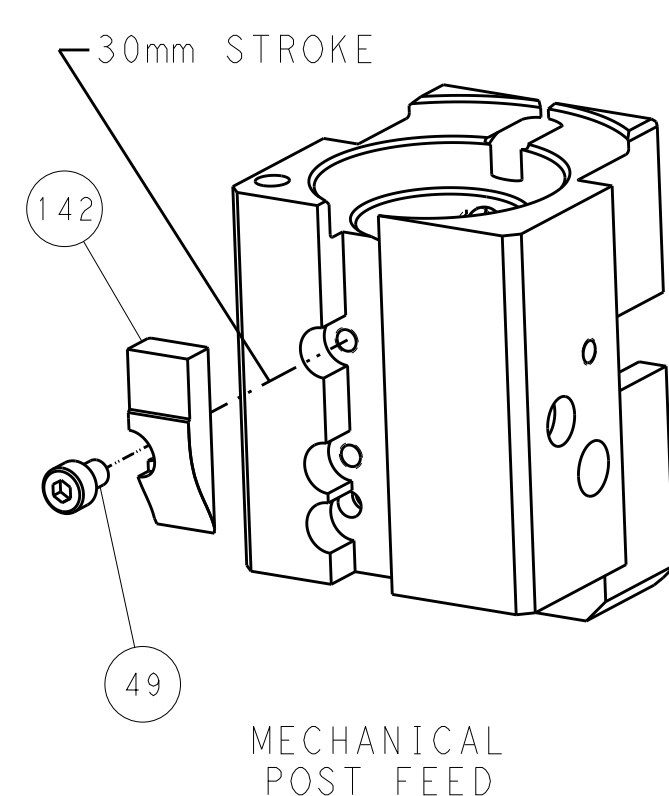
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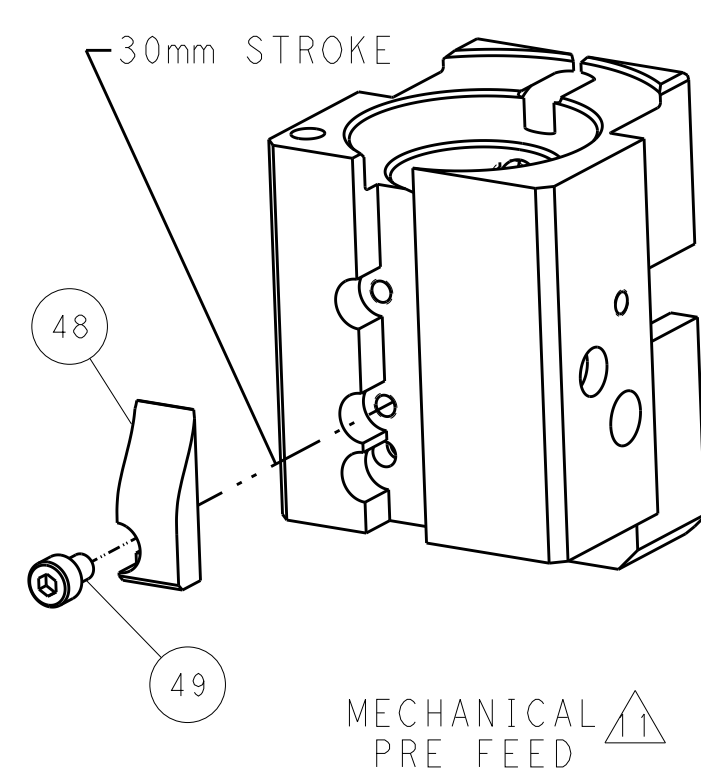
FEED TYPE
MECHANICAL



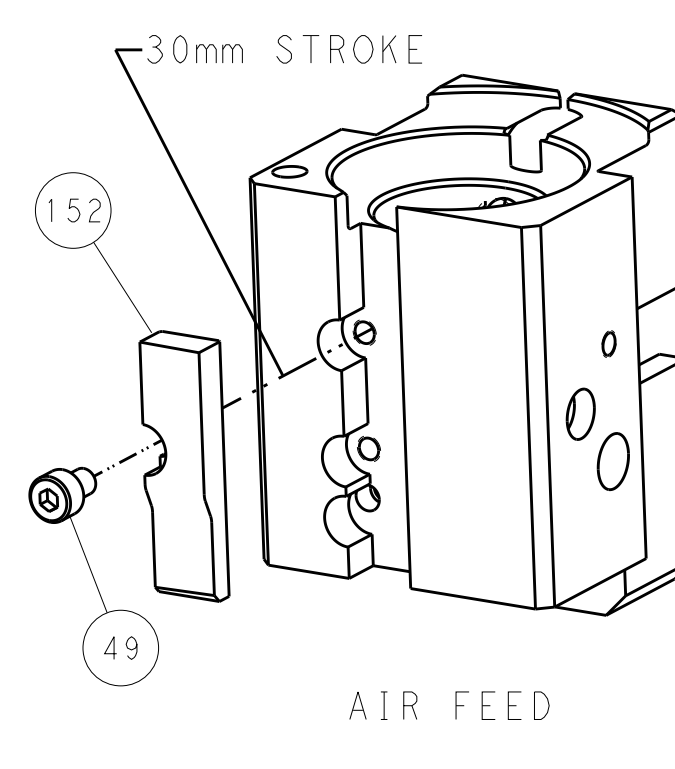
PNEUMATIC

SERVO
LATCH PLATE

MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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 CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLS AND ENGINEERING ORGANIZATION SHOULD BE NOTIFIED FOR THE LATEST REVISIONS.		DWN HUANG 2/17/2014 CHK ZHANG 2/17/2014 APVD U GUO 2/17/2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		NAME Ocean End Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
				DRAWING NO C=2150415	
				RESTRICTED TO -	
				SCALE 1:1 SHEET A OF A REV A	
Customer Accessible Production Drawing					