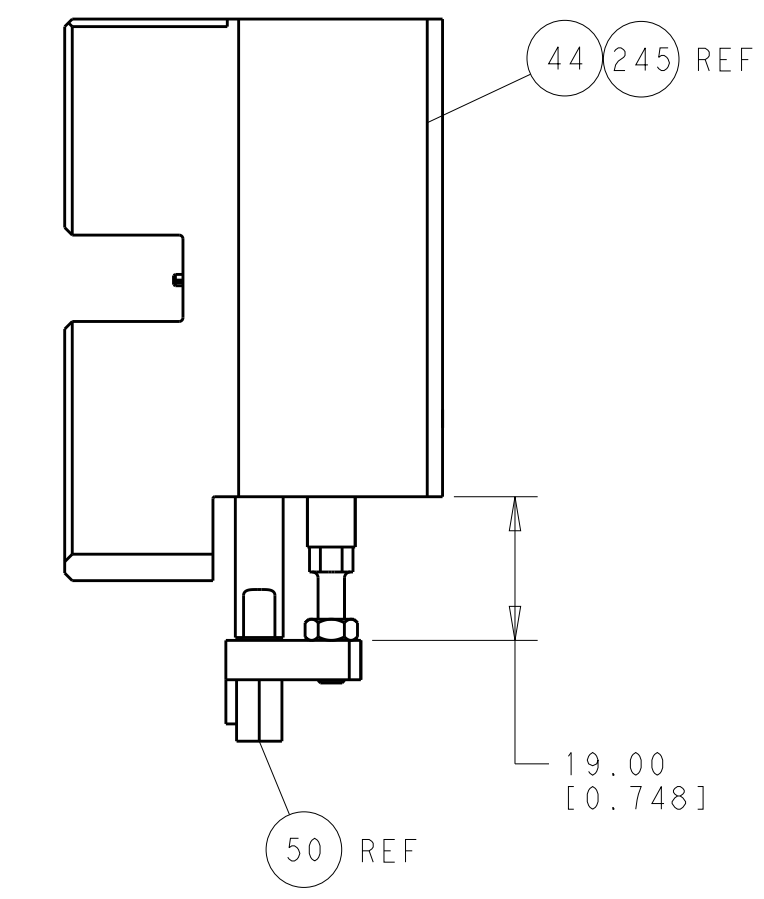
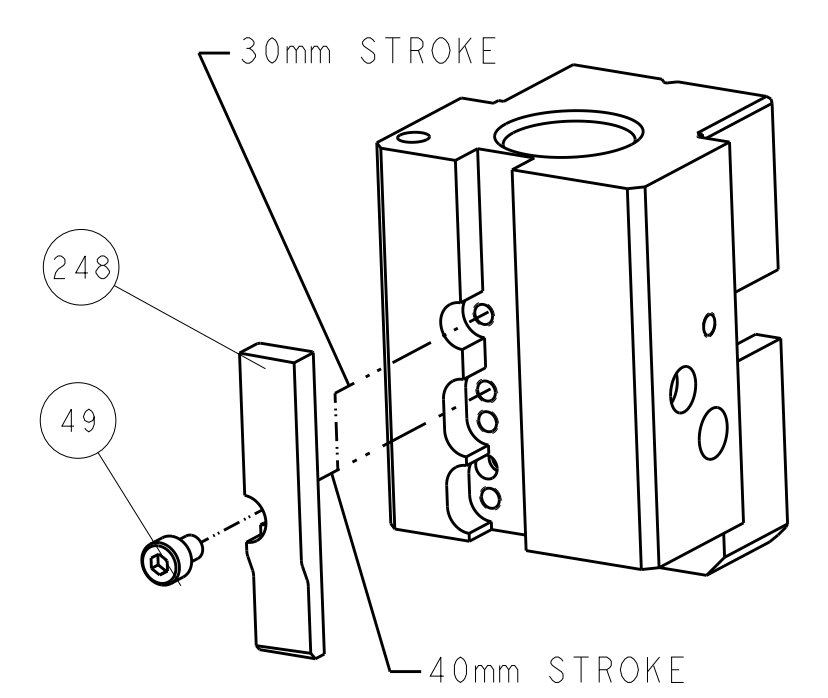


DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

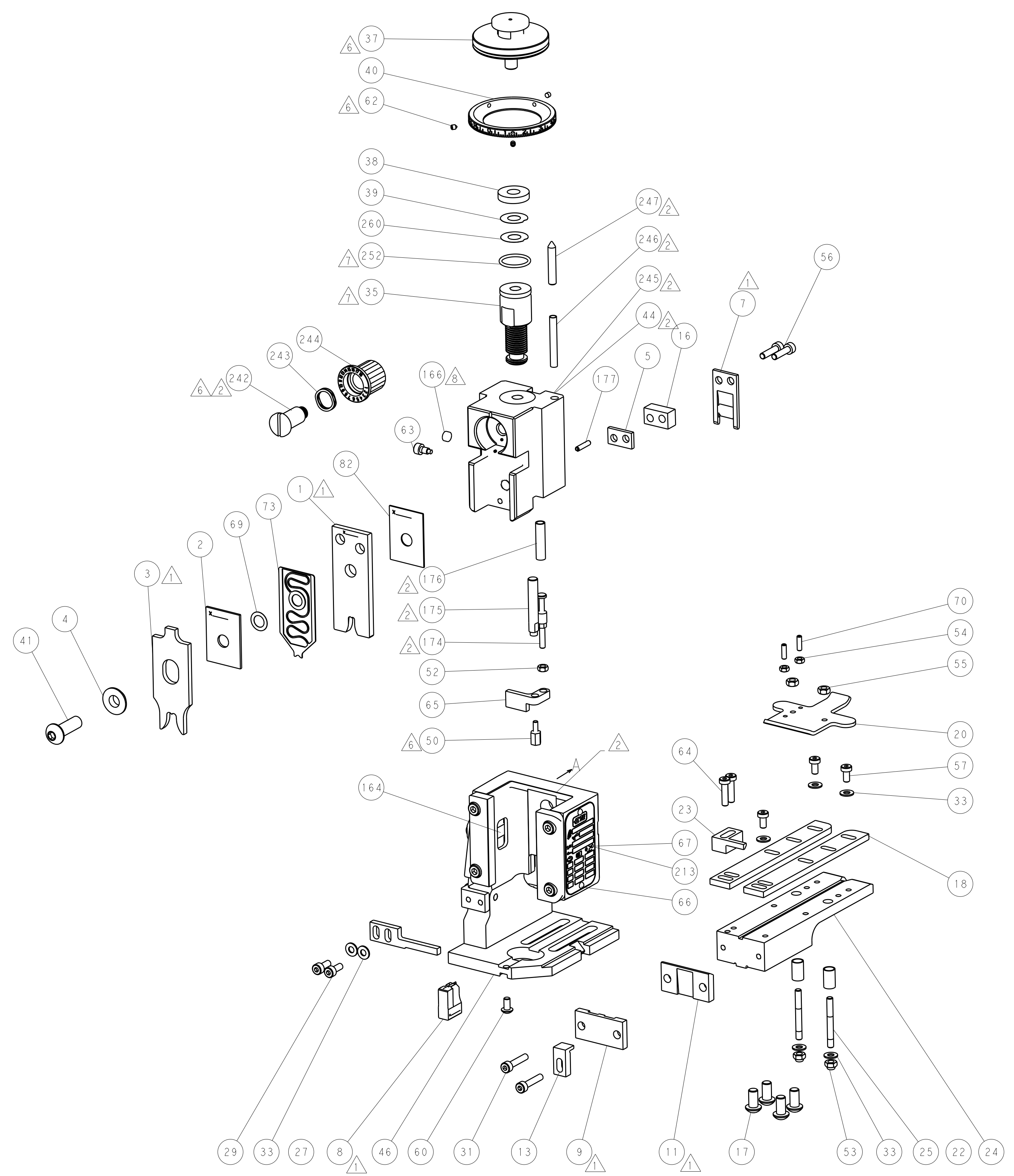


HOLDDOWN SET-UP

CAM POSITION

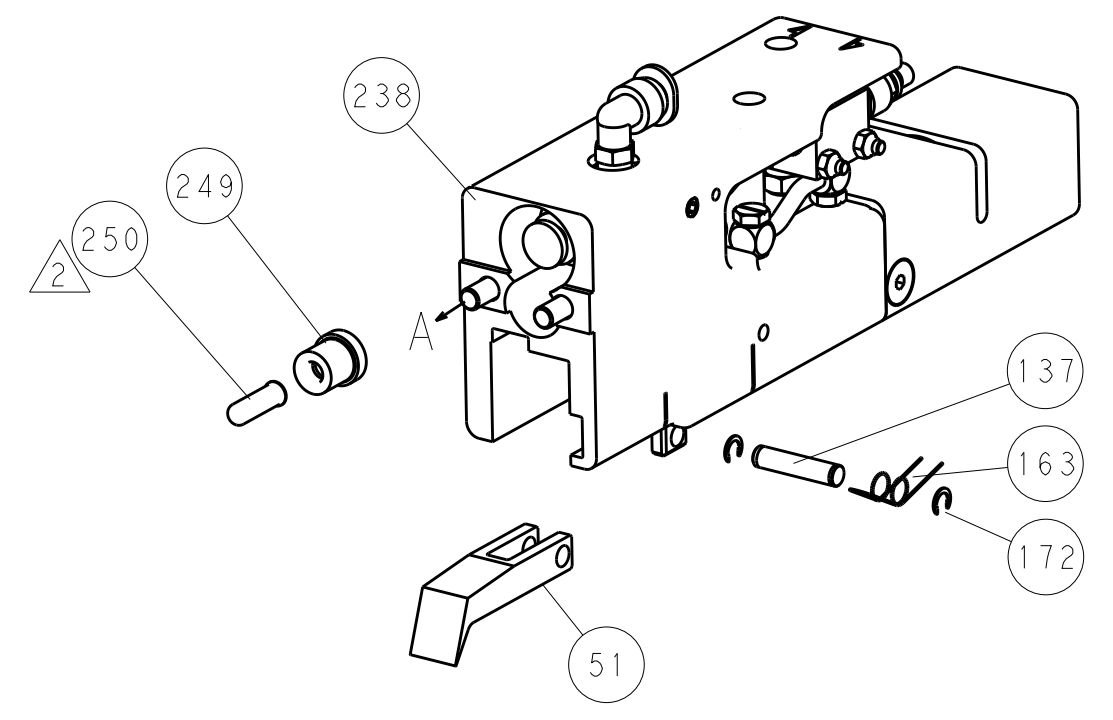


AIR FEED

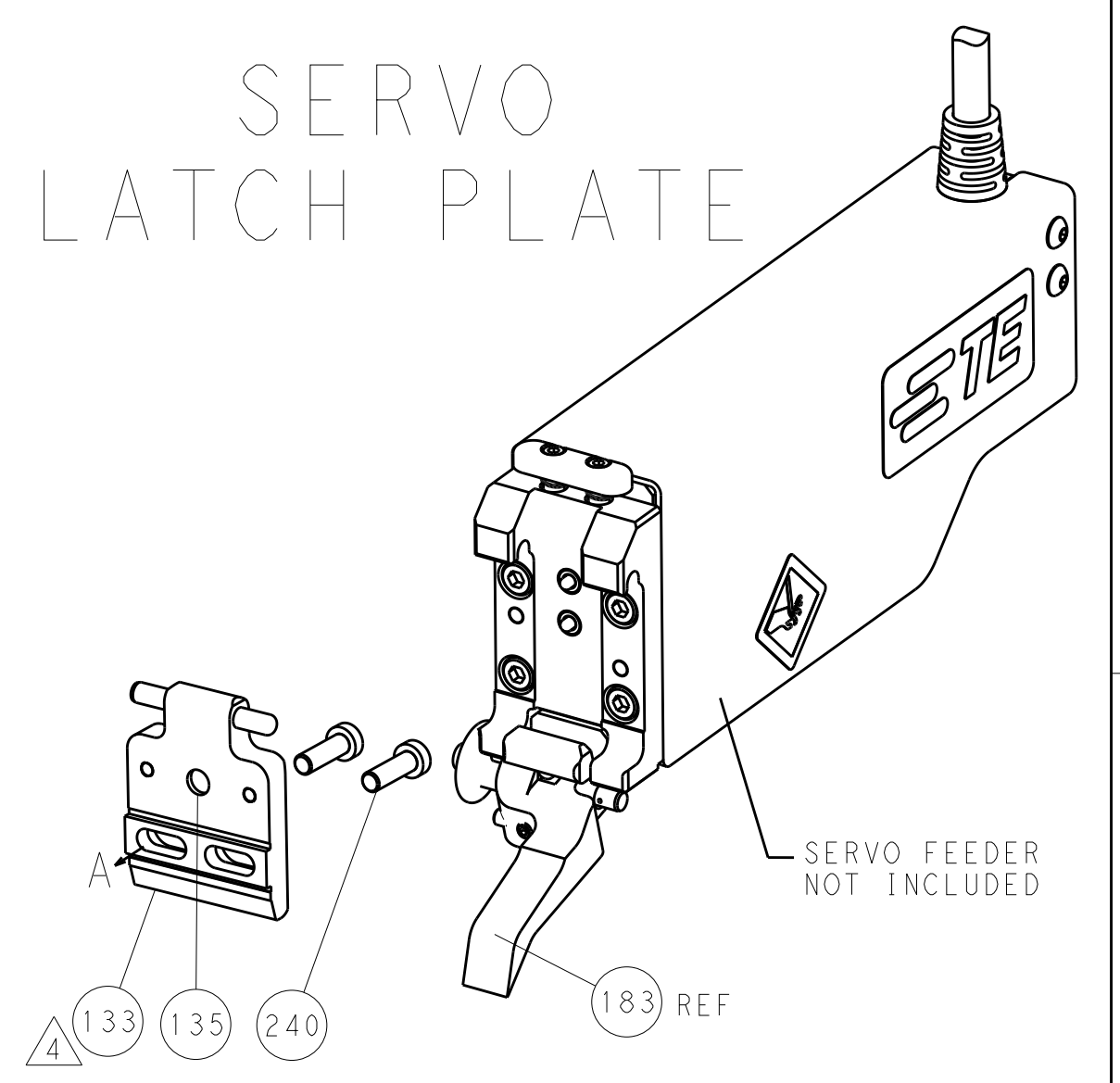


FEED TYPE

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THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		DWN K. HUANG 25MAR2013 CHK L. ZHANG 25MAR2013 APVD J. GUO 25MAR2013		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		NAME Ocean End Feed Applicator	
MATERIAL		FINISH		SIZE CAGE CODE DRAWING NO. 00779 C-2150321	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 2 OF 4 REV A	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8

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THIS DRAWING IS UNPUBLISHED.

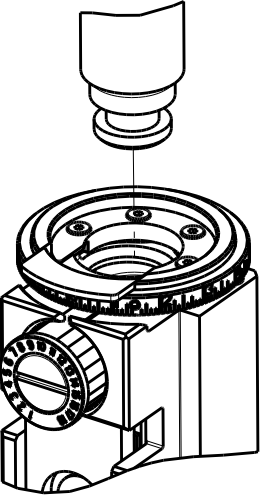
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20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2150321-2

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

PNEUMATIC

CONVERT TO

SERVO LATCH PLATE

PART NUMBERS REQUIRED

2119951-11901697-18-2150321-5-2168400-7 (QUANTITY 2)

-

-

-

-

-

-

SERVO LATCH PLATE

2161326-1

-

8-2150321-4

-

-

-

-

-

-

-

-

-

PNEUMATIC FEED

2119950-1

2119792-2

-

2119641-2

-

2063440-2

2-2150321-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2-2150321-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2150321-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	7.62 mm [.300]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .375 SERIES FASTIN-FASTON RECEPTACLE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

114-20021

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

10.00mm2

3.63+/-0.05 [.143+/- .002]

4.9

6.0+2.5 or 8.50mm2

3.51+/-0.05 [.138+/- .002]

6.3

8.00mm2

3.43+/-0.05 [.135+/- .002]

7.4

6.00mm2

3.23+/-0.05 [.127+/- .002]

8.6

RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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: 8-2150321-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150321-5

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 50, 62 & 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.

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

REVISONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 1	-	-	-

-

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

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

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1

1

1

455888-6

SPACER, CRIMPER

82

-

1

1

1

2119791-5

DEPRESSOR, WIRE

73

-

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

1

2119943-1

WASHER, SPACER

69

-

1

-

1

2119740-1

TAG, IDENTIFICATION

67

-

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

1

1

1901681-9

HOLDDOWN, TERMINAL

65

-

2

2

2

2168400-8

SHCS, LOW HEAD, RoHS, M4 X 16

64

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1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

-

3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

-

3

3

3

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

2

2

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

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

1-1752354-7

STANDOFF, HOLD-DOWN

50

-

-

-

1

18023-9

SCR, SKT HD CAP M4 X 6.0

49

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1

1

1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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1

1

1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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1

1

1

2119957-1

APPLICATOR SHIM PACK

39

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1

1

1

2119644-4

RAM WASHER, PRECISION

38

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7

7

7

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

690455-1

STRIPPER, FRONT CASTING

27

-

2

2

2

1320906-1

STUD, THREADED

25

-

1

1

1

1-1752371-4

PLATE, STRIP GUIDE

24

-

1

1

1

240825-5

PLATE, STRIP HOLD DOWN

23

-

2

2

2

22281-7

SPRING, COMPRESSION

22

-

1

1

1

1752373-4

DRAG

20

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2

2

2

1901259-7

GUIDE, LOWER STRIP

18

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1

1

1

4-240641-7

SPACER

16

-

1

1

1

1752360-1

SPACER, HOLD-DOWN

13

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1

1

1

1-240833-3

PLATE, REAR SHEAR

11

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-

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10

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1

1

1

5-690482-4

PLATE, FRONT SHEAR

9

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1

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1333223-3

ANVIL, COMBINATION

8

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2217206-4

BLADE, SLUG

7

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1-240641-6

SPACER

5

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1-238009-1

BLOCK, FL CRIMPER SPACER

4

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1

2-1633961-2

CRIMPER, INSULATION F PREMIUM

3

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1

1

1-455888-2

SPACER, CRIMPER

2

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1

456428-3

CRIMPER, WIRE

1

-77-27-25-22

PART NO

DESCRIPTION

ITEM NO

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114

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

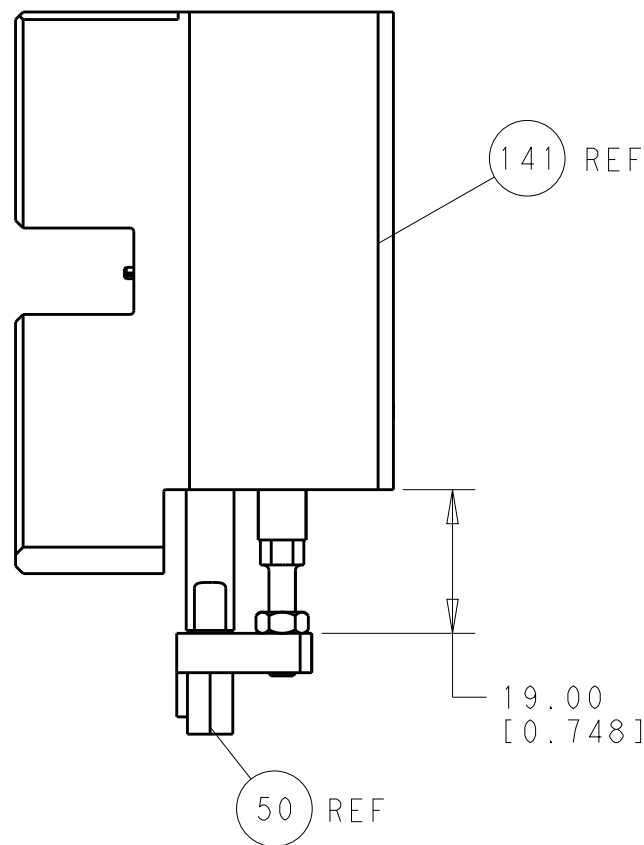
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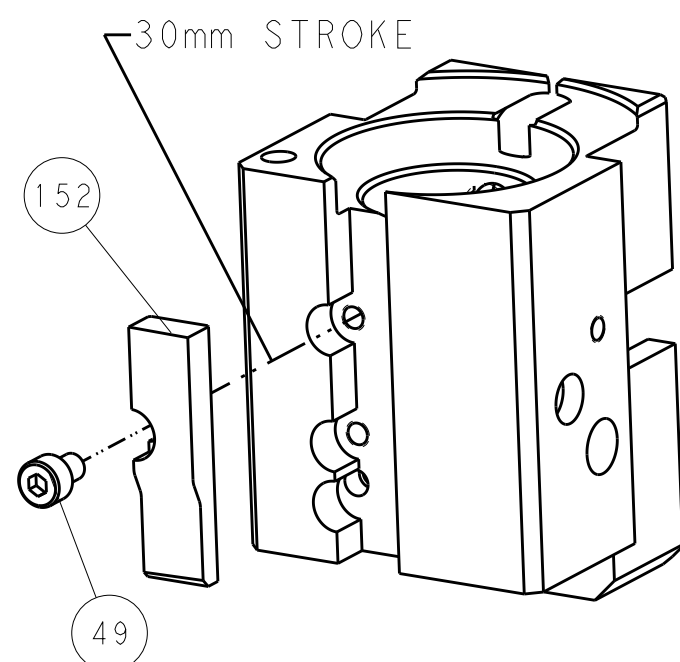
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LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

HOLDDOWN SET-UP



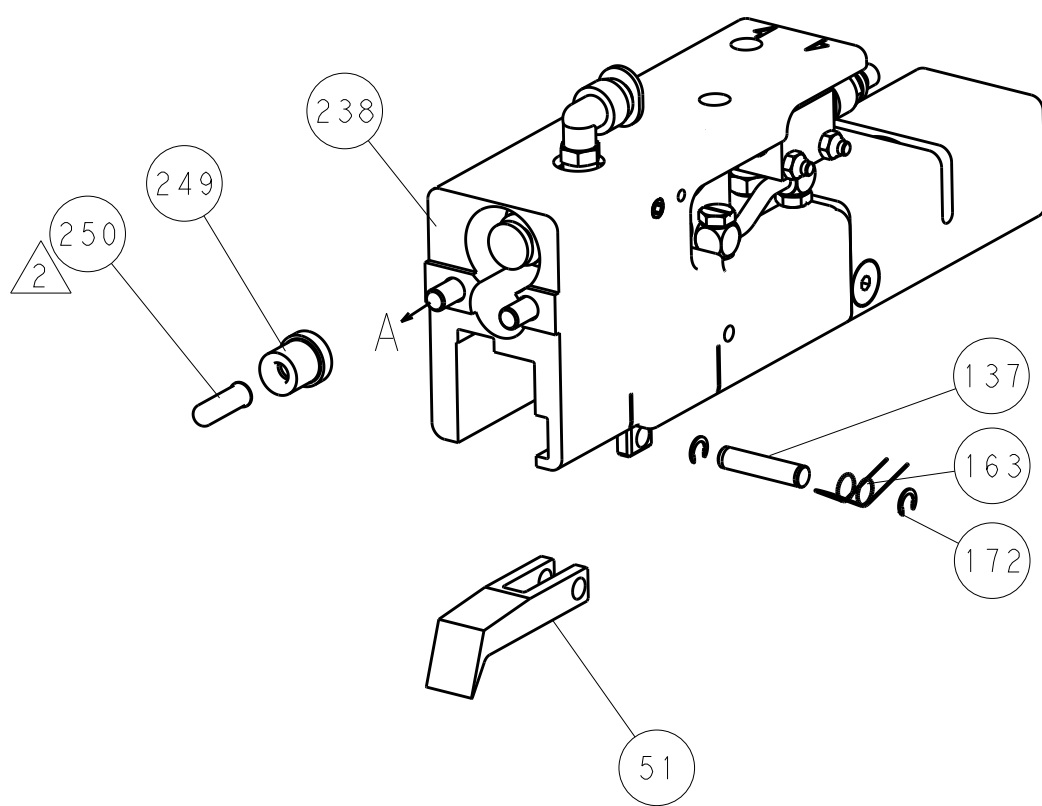
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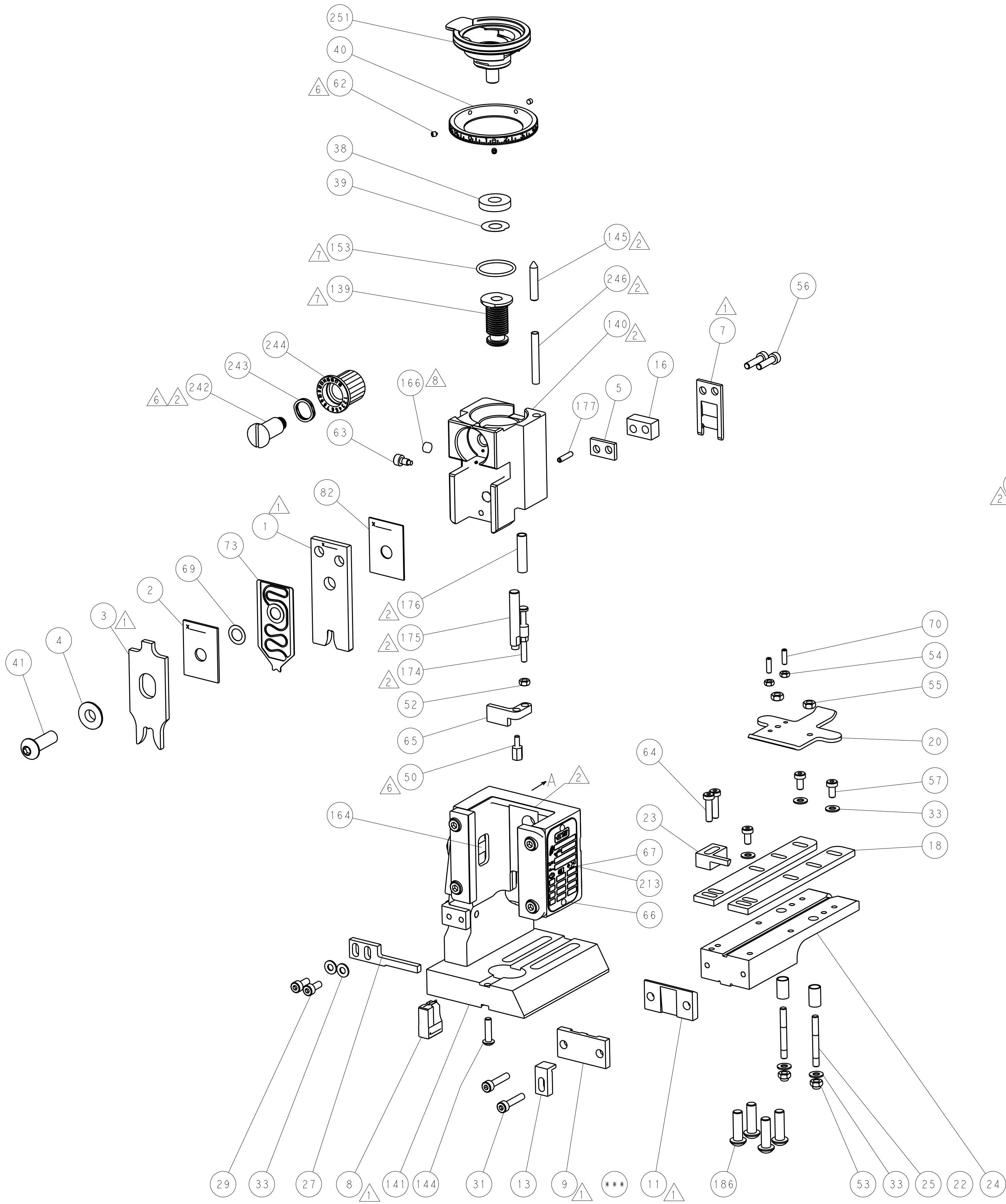
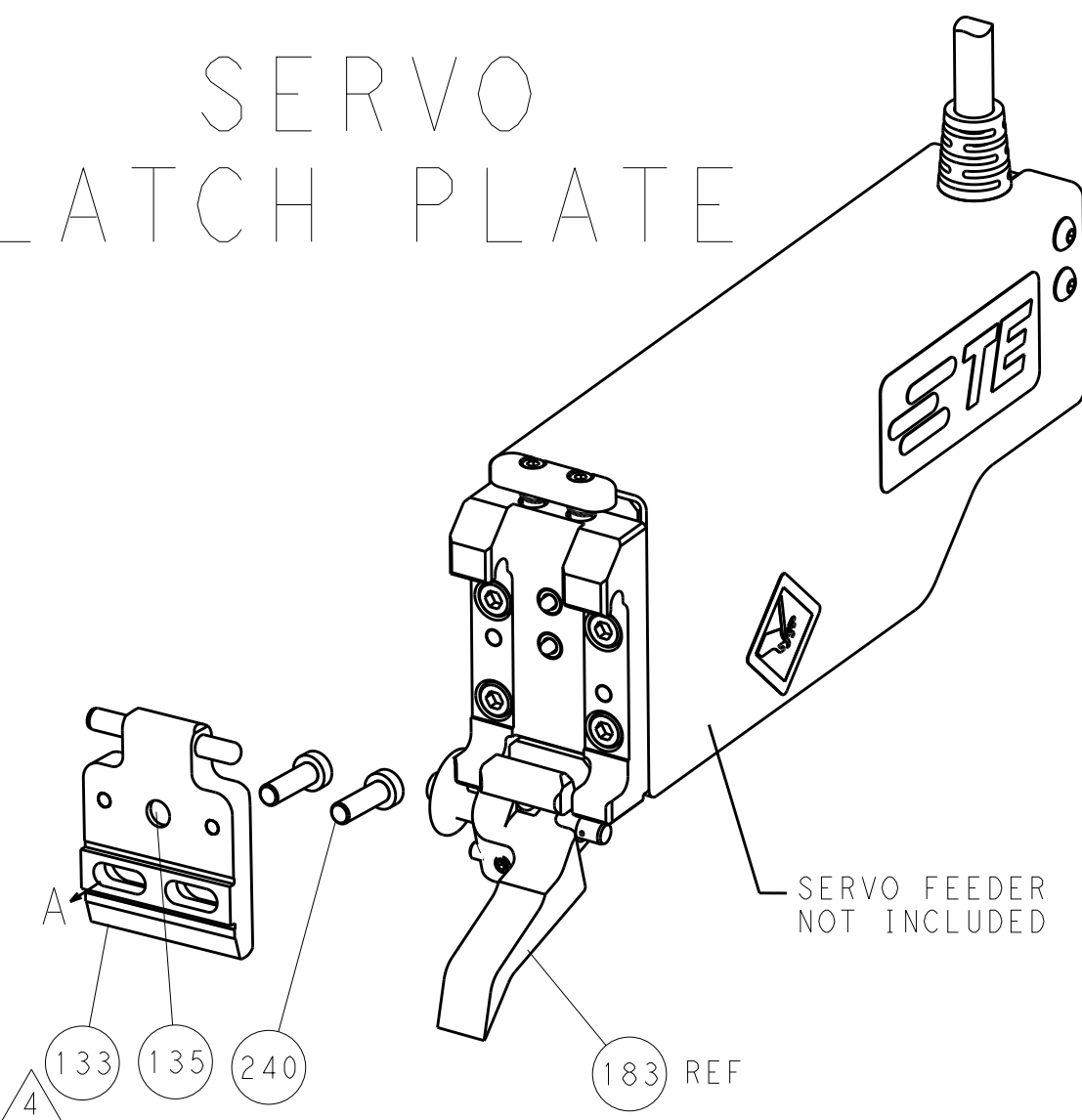
AIR FEED

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)

1ST PUBLISHED BY: COMPANY'S TOOLING FOR THE ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST NOTATION.		DWN K. HUANG 25MAR2013	STE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 25MAR2013	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		APVD J. GUO 25MAR2013	PRODUCT SPEC	
MATERIAL			APPLICATION SPEC	
			WEIGHT	
			Customer Accessible Production Drawing	
			SCALE 1:1	
			SHEET 4 OF 4	
			REV A	