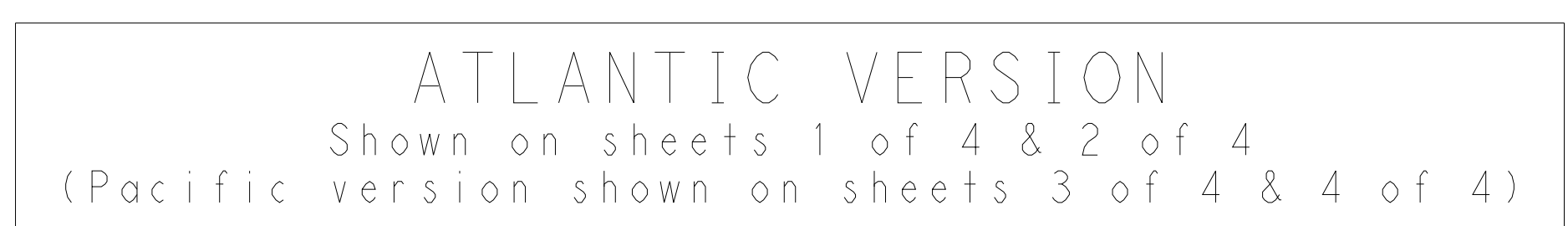


	A	RELEASED	11OCT2012	LG	MC
	A1	ECR-13-012598	08AUG2013	XZ	TE
	B	ECR-14-003864	14MAR2014	YY	UG

ALL DIMENSIONS ARE DIMENSIONS TO CENTER UNLESS OTHERWISE SPECIFIED. DIMENSIONS TO BE CORRECTED FOR THE LATCH POSITION.		DWG HOFFNER 10MAY2012 T. ELBIN 11MAY2012 T. ELBIN 11MAY2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC $\pm .01$ 1 PLC ± 0.5 2 PLC ± 0.13 3 PLC ± 0.013 4 PLC ± 0.0001 ANGLES $\pm .1$		NAME Ocean End Feed Applier -	
		PRODUCT SPEC APPLICATION SPEC		SIZE A1 00779	
MATERIAL FINISH		WEIGHT -		CASE CODE C-2150253	
RESTRICTED TO		DRAWING NO -		SCALE 1:1	
Customer Accessible Production Drawing		SHEET 1 OF 4		REV B	



SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

 PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150253-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-2	8-2150253-5	-	-	2168400-7 (QUANTITY 2)
	2-2150253-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	SMART APPLICATOR	2161326-1	-	8-2150253-4	-	-	-
	2-2150253-7	B	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
	7-2150253-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

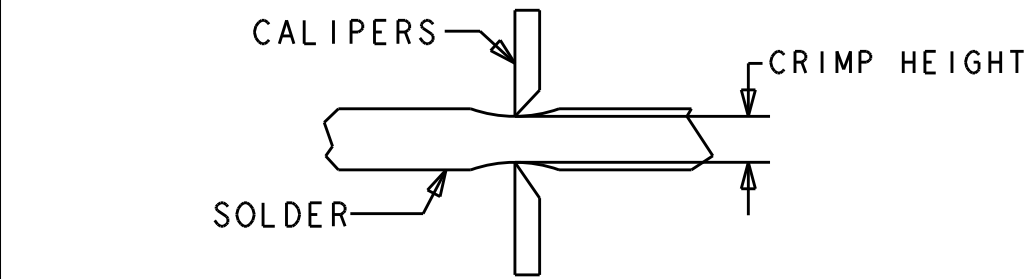
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.02 mm [.237]	D
INSUL	-	-
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINALTE CRIMP SPECIFICATION			
TERMINAL NAME: RECPT,ULTRA-FAST FLAG, .250 SERIES			
WIRE STRIP LENGTH 7.51-8.33 mm [.296-.328 IN]		INSULATION DIAMETER RANGE Ø 4.70mm MAX [.185 MAX]	
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-520132-2	9-520132-2	3-521127-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14		1.90+/-0.05 [.075+/- .002]		6.7	.19 in [4.83mm]
16		1.78+/-0.05 [.070+/- .002]		8.0	.19 in [4.83mm]



- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
3. 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: 8-2150253-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150253-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 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.
- TO CHECK CRIMP HEIGHT. CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.

*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.

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	OWN	APVD
				-	SEE SHEET 1			-	-	-

	-	1	1	1	2119644-8	RAM WASHER, PRECISION	261
	-	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	1-22279-3	SPRING, COMPRESSION	246
	-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
	-	-	-	1	2063440-1	AIR FEED MODULE	238
	-	-	1	-	2119740-2	TAG,IDENTIFICATION	213
1	-	1	1	1	467281-1	RETAINER, SHEAR, FLOATING	207
	-	1	1	1	2161936-1	HOLDER, SHEAR, FLOATING	206
	-	1	1	1	467500-1	SHEAR, FLOATING	205
	-	-	1	-	1976043-1	PIN, BALL LOCK, THREADED	187
	-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	-	1	-	1901697-2	FEED FINGER ASSEMBLY,EF	183
	-	-	-	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	2161937-1	STABILIZER	154
	-	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
	-	3	3	3	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	1	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	455888-5	SPACER, CRIMPER	82
	-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
	-	1	1	1	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
	-	1	1	1	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	69
	-	1	-	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
1	-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
	-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	-	-	1	2161952-1	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
	-	2	2	2	5-22278-1	SPRING, COMPRESSION	36
	-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
	-	1	1	1	2161941-1	PLATE, GUIDE, STRIP	24
	-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	2161948-1	DRAG	20
	-	1	1	1	683736-1	GUIDE, STRIP, REAR	19
	-	1	1	1	683737-1	FRONT STRIP GUIDE	18
	-	1	1	1	4-22280-7	SPRING, COMPRESSION	13
1	-	1	1	1	2161935-2	ANVIL, RIGHT HAND	8
	-	1	1	1	2161957-1	DEPRESSOR,SHEAR	5
	-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
	-	1	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
1	-	1	1	1	467342-2	CRIMPER, RIGHT HAND	1
	-	77	27	25	22	PART NO	DESCRIPTION

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DIMENSIONS: mm				CHK T.ELBIN	11MAY2012		
				APVD T.ELBIN	11MAY2012	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.0001				PRODUCT SPEC -		SIZE A1	
MATERIAL -				APPLICATION SPEC -		CASE CODE 00779	
FINISH -				WEIGHT -		DRAWING NO C=2150253	
				Customer Accessible Production Drawing		RESTRICTED TO -	
				SCALE 1:1		SHEET 3 OF 4	
						REV B	

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

FEED TYPE

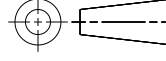
PNEUMATIC

SERVO
LATCH PLATE

CAM POSITION

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 AND SHEET FOR THIS ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE AND SUBJECT TO THE LATEST REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISIONS		DWN: HOFFNER 10MAY2012	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK: T.ELBIN 11MAY2012		
mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD: T.ELBIN 11MAY2012	NAME: Ocean End Feed Applicator	
	0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001	PRODUCT SPEC	SIZE: A1 00779 C=2150253	
MATERIAL: -	FINISH: -	APPLICATION SPEC	RESTRICTED TO: -	
		WEIGHT: -	Customer Accessible Production Drawing	
		SCALE: 1:1	SHEET 4 OF 4 REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION