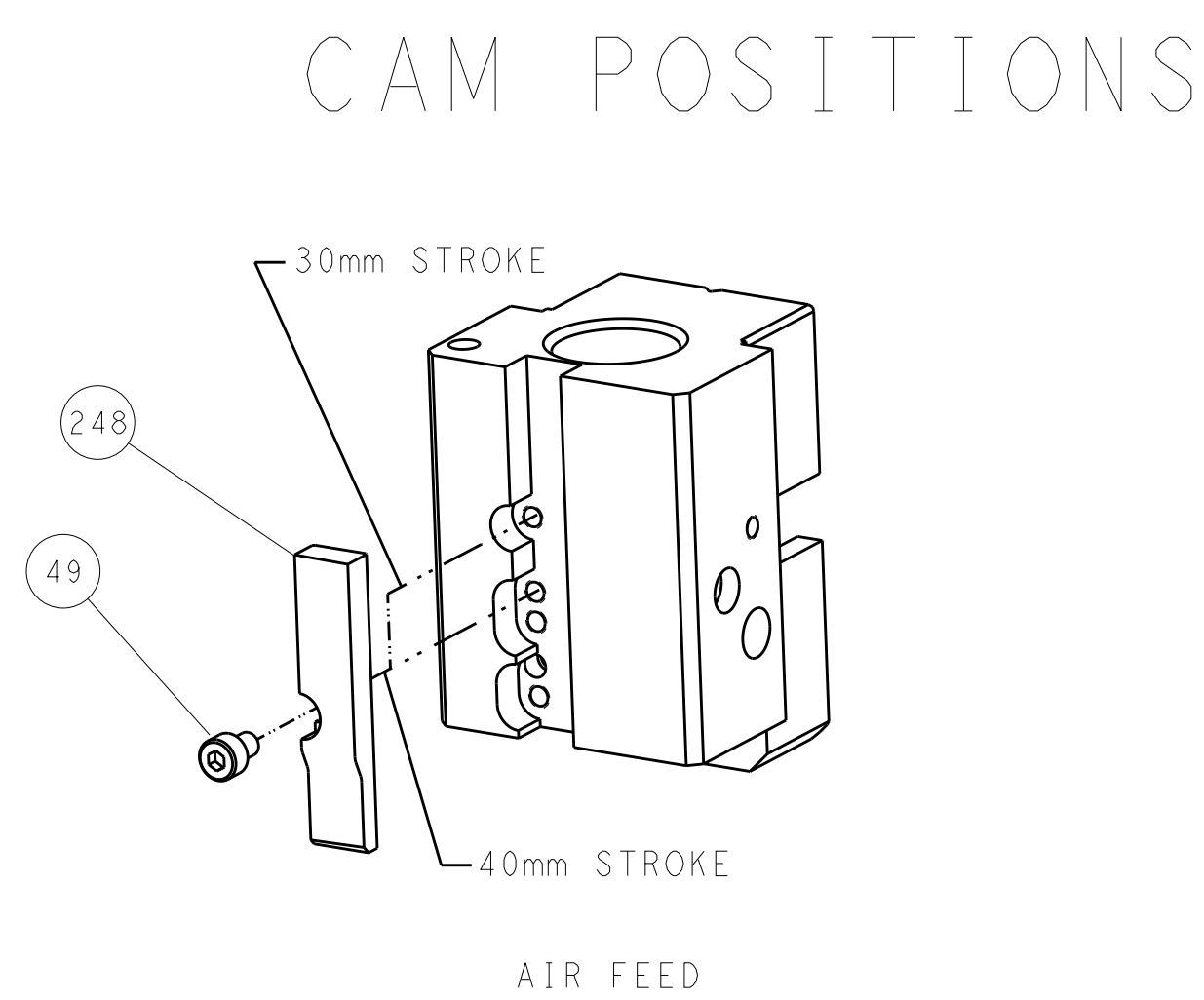
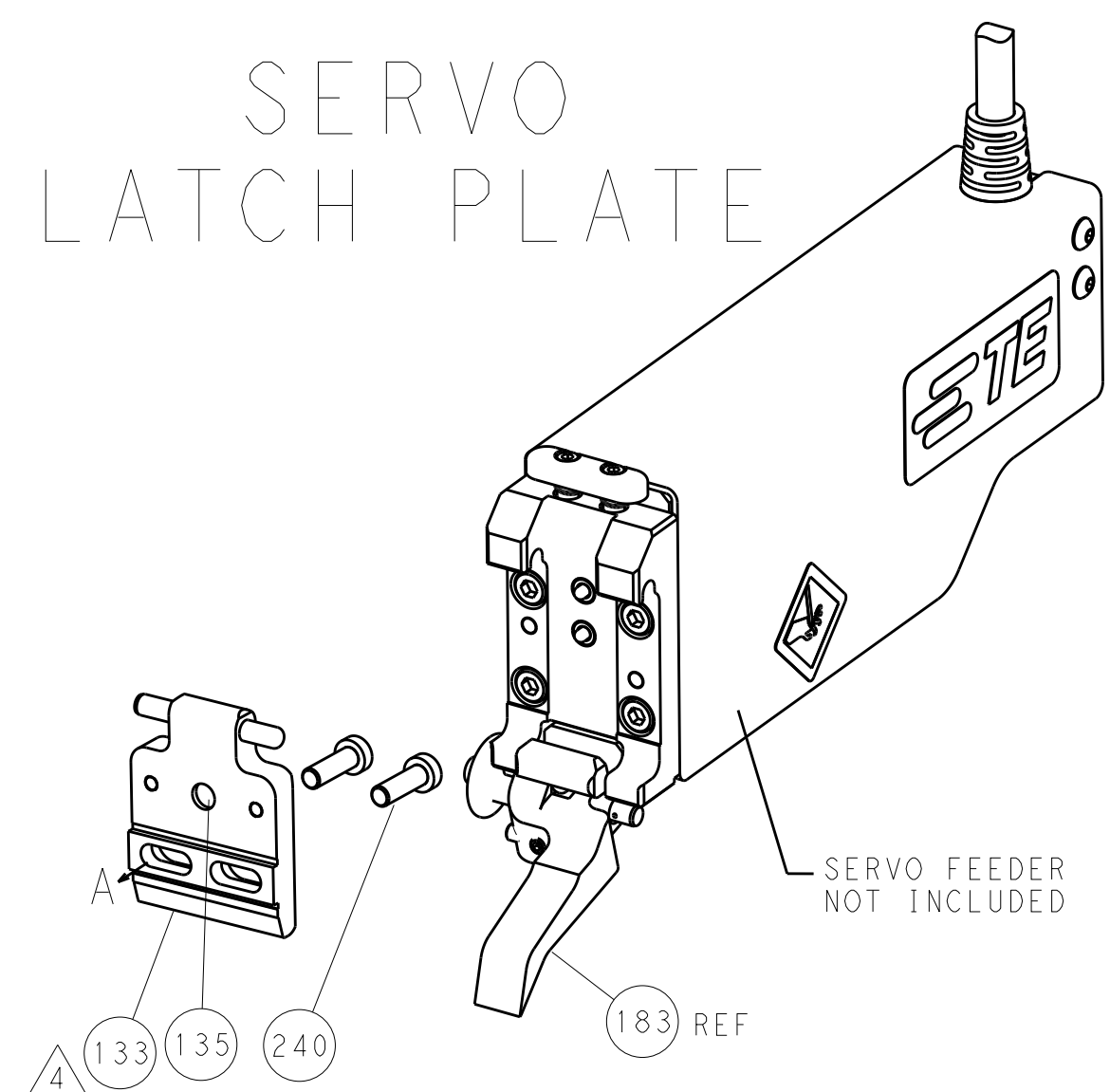
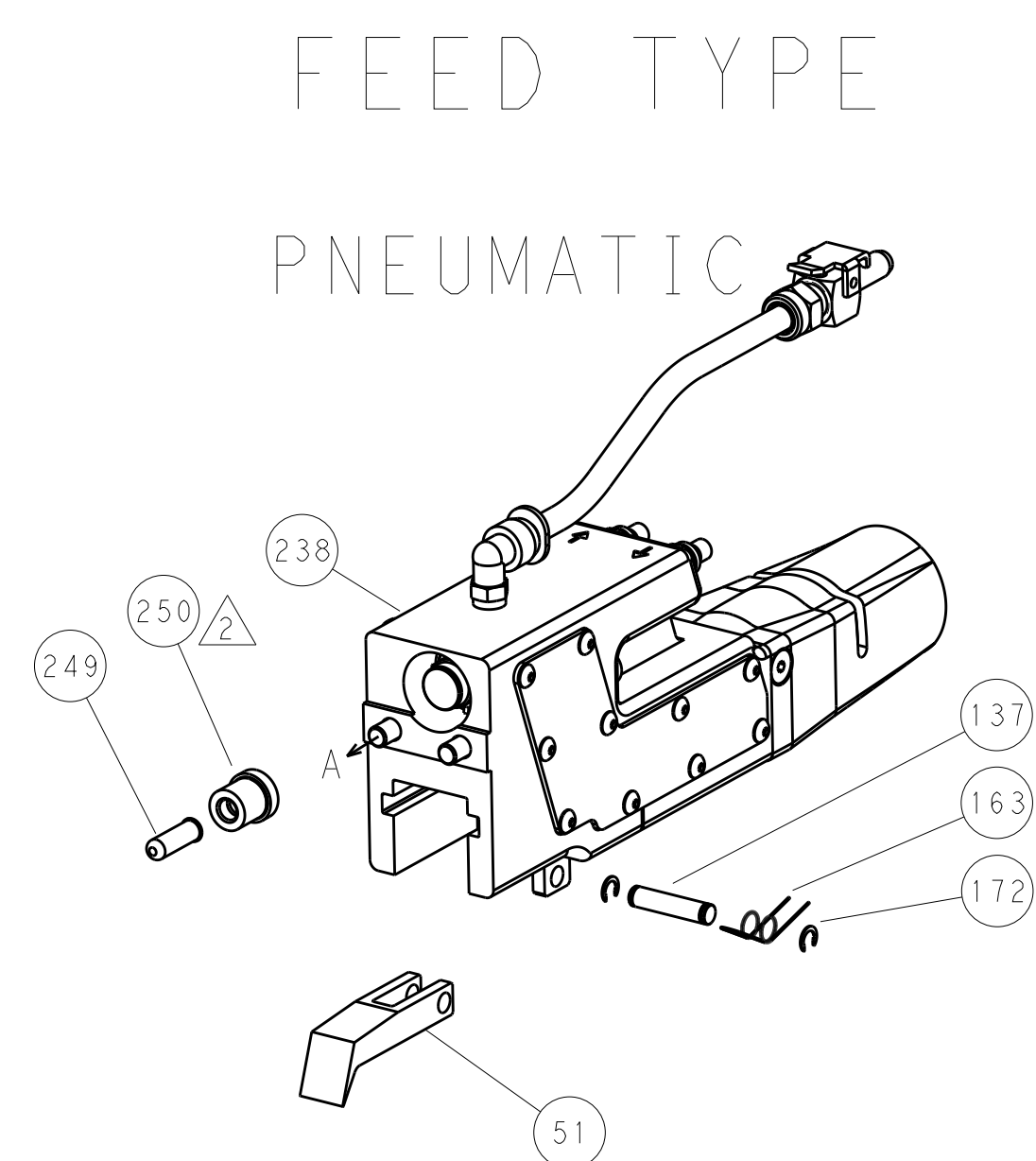
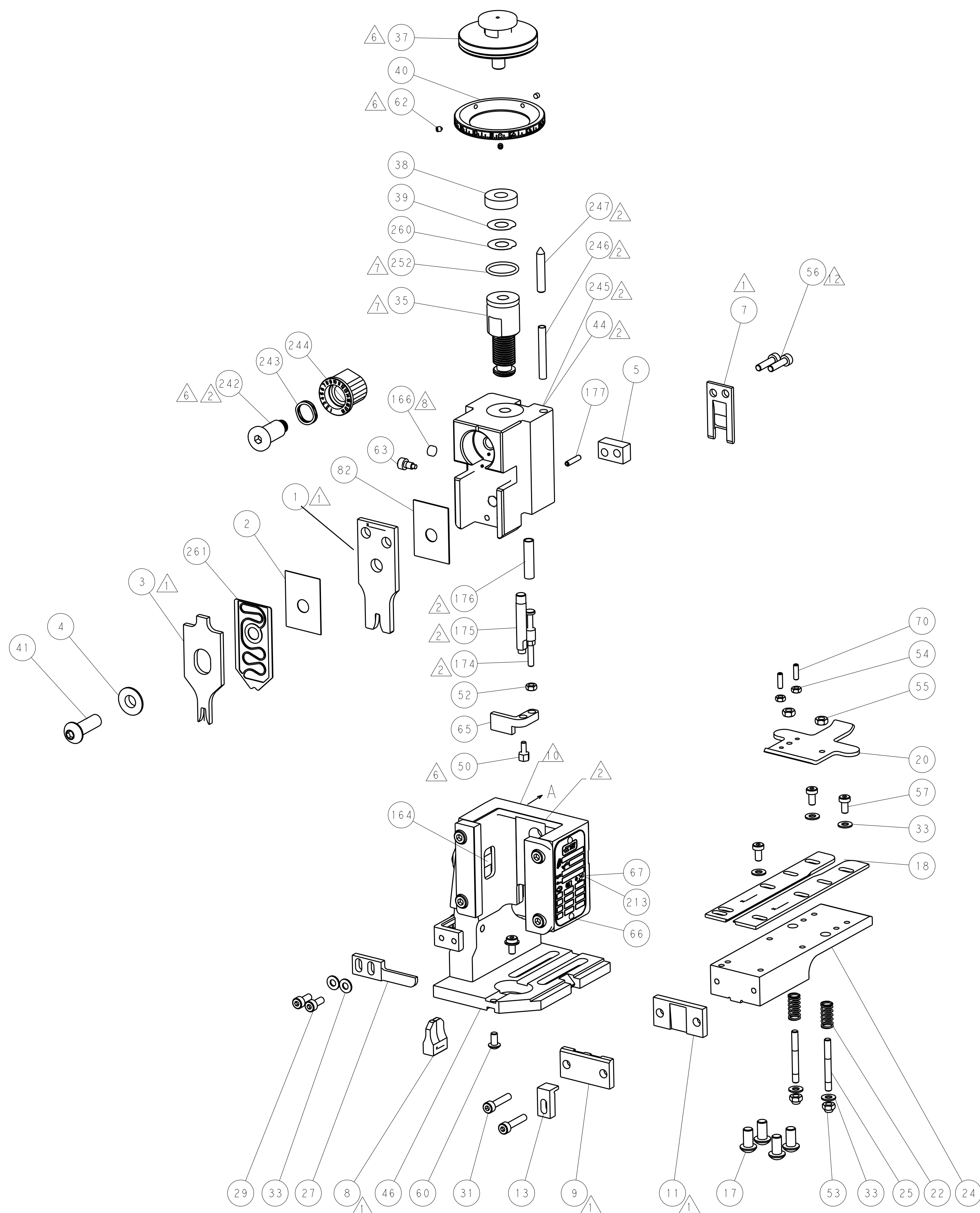
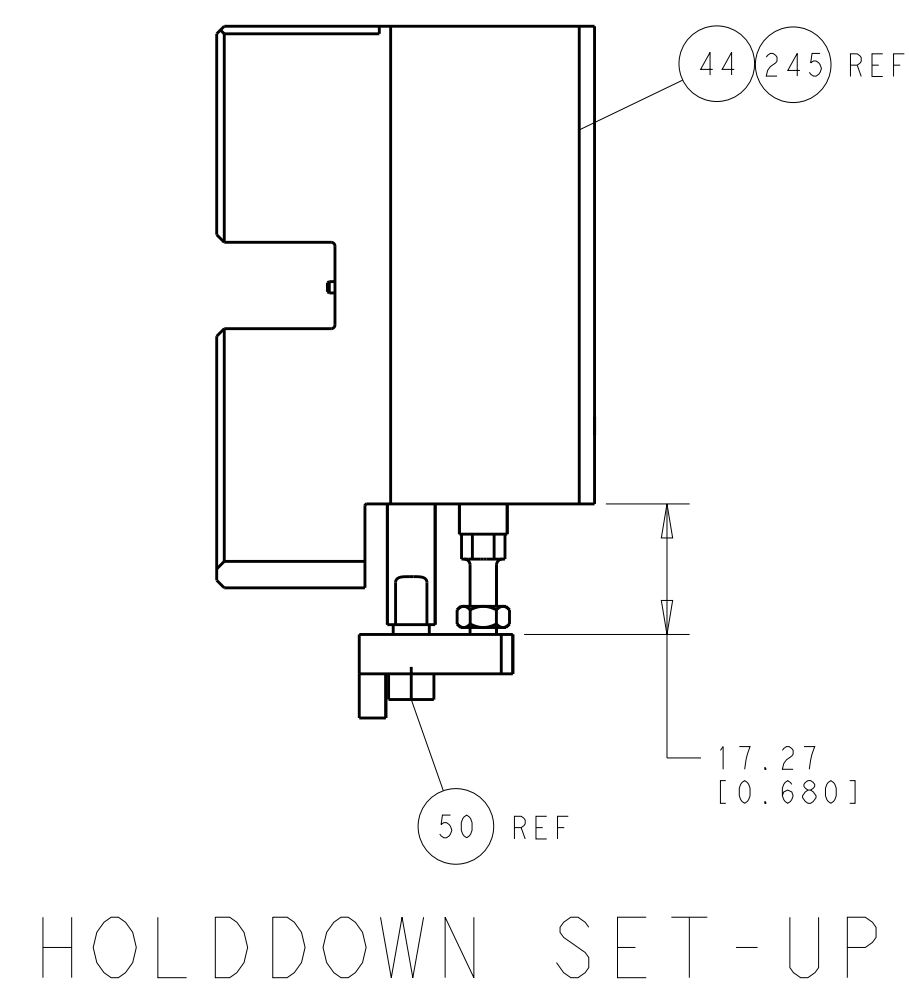
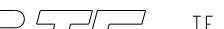
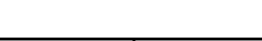
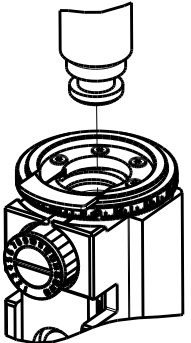


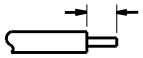


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS THE PROPERTY OF THE COMPANY AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE COMPANY. IT IS TO BE USED FOR THE MANUFACTURE OF THE PARTS SPECIFIED HEREON ONLY. IT IS TO BE DESTROYED WHEN THE PARTS ARE NO LONGER NEEDED.		DWN 03MAY2012 STAKEM CHK 03MAY2012 G. BAILEY APP'D 03MAY2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC +/- .005 1 PLC +/- .01 2 PLC +/- .013 3 PLC +/- .0001		NAME Ocean End Feed Applicator - -	
MATERIAL - FINISH -		WEIGHT - Customer Accessible Production Drawing		SIZE CAGE CODE DRAWING NO A 00779 C=2150256 RESTRICTED TO -	
		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					
						-	-	-	-	-	-
	2-2150256-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150256-5	-	-	2168400-7 (QUANTITY 2)
	2-2150256-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	SMART APPLICATOR	2161326-1	-	8-2150256-4	-	-	-
	2-2150256-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	7-2150256-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-10390 		

TERMINAL DATA: METALLON TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 4.70 - 5.08mm [.185-.200 IN] 		INSULATION DIAMETER RANGE Ø 1.52-2.87mm [.060 - .113]	
TERMINAL APPLICATION SPECIFICATION 	114-2065	-	-
TERMINALS APPLIED 			
TE TERMINAL	METALLON TERMINAL	TE TERMINAL	LEAR TERMINAL
2113265-1	139-6914	2113265-2	101614-K02
2113265-3	139-6913	2113265-4	101617-K02

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 
18 AWG	1.91+/-0.05 [.075+/- .002]	2.6
20 AWG	1.80+/-0.05 [.071+/- .002]	4.0



 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: 8-2150256-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150256-5

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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.

 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

 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.

 WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

 CUT TO LENGHT AT ASSEMBLY.

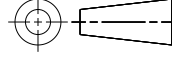
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	2119791-9	DEPRESSOR, WIRE	261
-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	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
-	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
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	2063440-1	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
-	-	-	-	2119653-2	FEED CAM, POST FEED	142
-	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
-	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	1901681-5	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	2168083-8	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	1752354-2	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	2119644-1	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	1752373-1	DRAG	20
-	1	1	1	1901696-3	STRIP GUIDE, REAR	18
-	1	1	1	1901695-3	STRIP GUIDE, FRONT	18
-	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	1	1	1	690482-1	PLATE, FRONT SHEAR	9
-	1	1	1	1803060-1	ANVIL, COMBINATION, END FEED	8
-	1	1	1	690474-2	BLADE, SLUG	7
-	1	1	1	7-240641-2	SPACER	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	1	456409-3	CRIMPER, WIRE .120 "F" PREMIUM	1
-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.				DWN R. STAKEM CHK G. BAILEY APVD T. ELBIN	03MAY2012 03MAY2012 03MAY2012	TE 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 ±.1		NAME Ocean End Feed Applicator		RESTRICTED TO	
		PRODUCT SPEC		SIZE		CAGE CODE	
MATERIAL		FINISH		APPLICATION SPEC		DRAWING NO	
-		-		WEIGHT		00779	
-		-		Customer Accessible Production Drawing		SCALE	
						1:1	
						SHEET 3 OF 4	
						REV A1	

