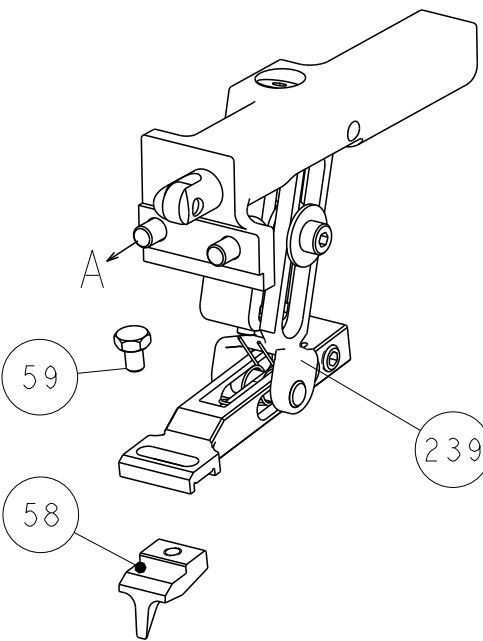
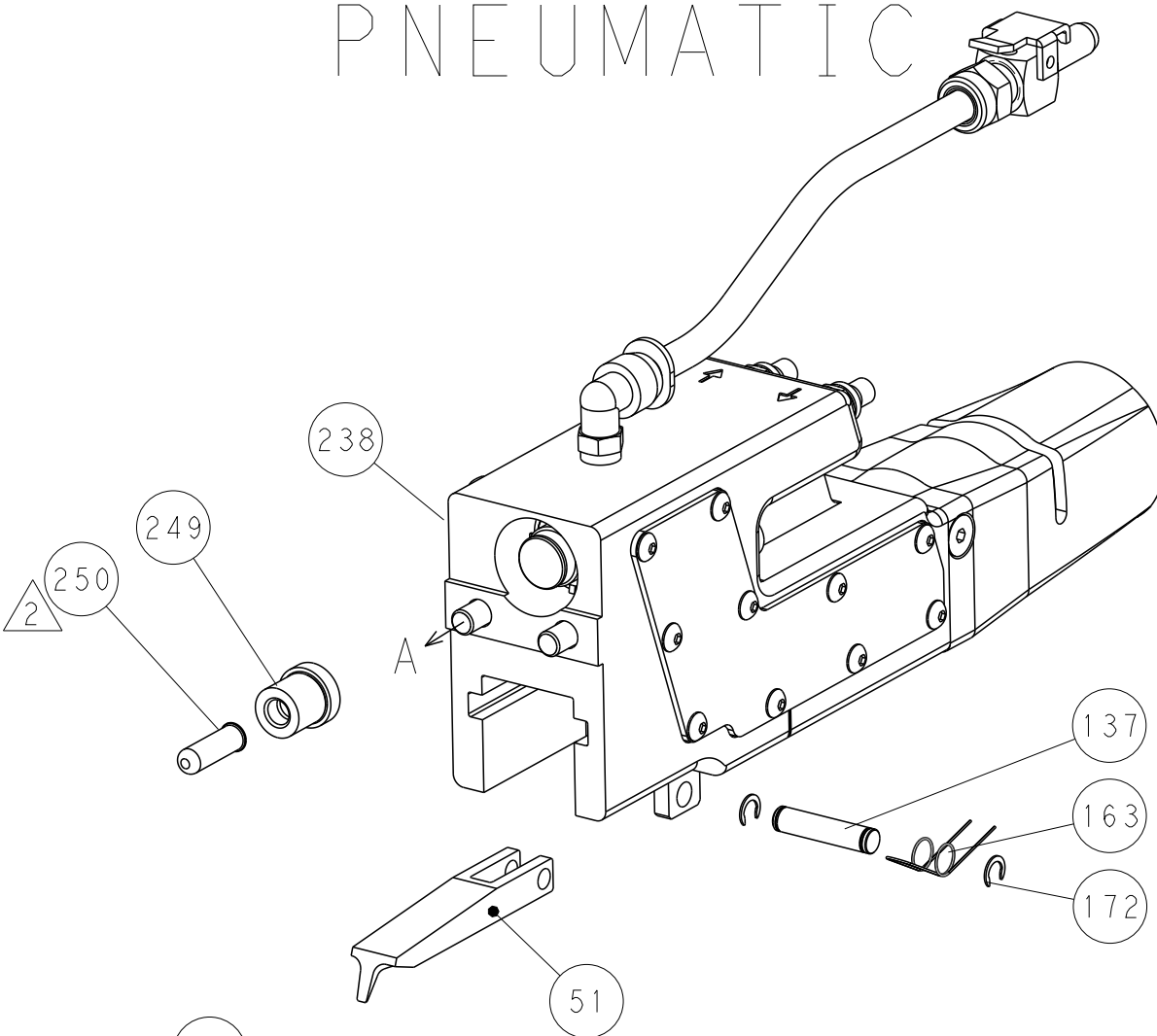


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		P	LTR	DESCRIPTION	DATE	DWN	APVD
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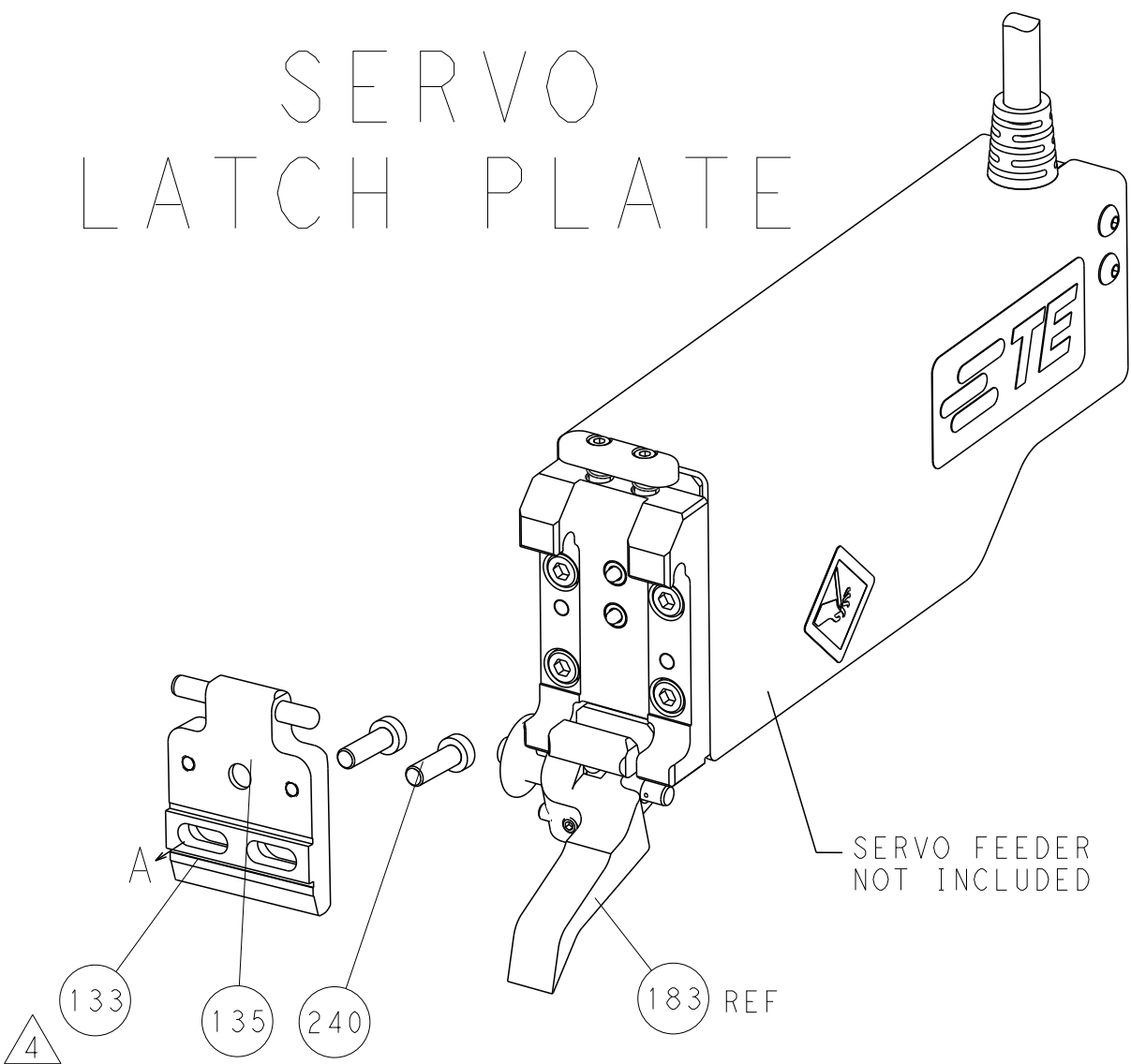
FEED TYPE
MECHANICAL



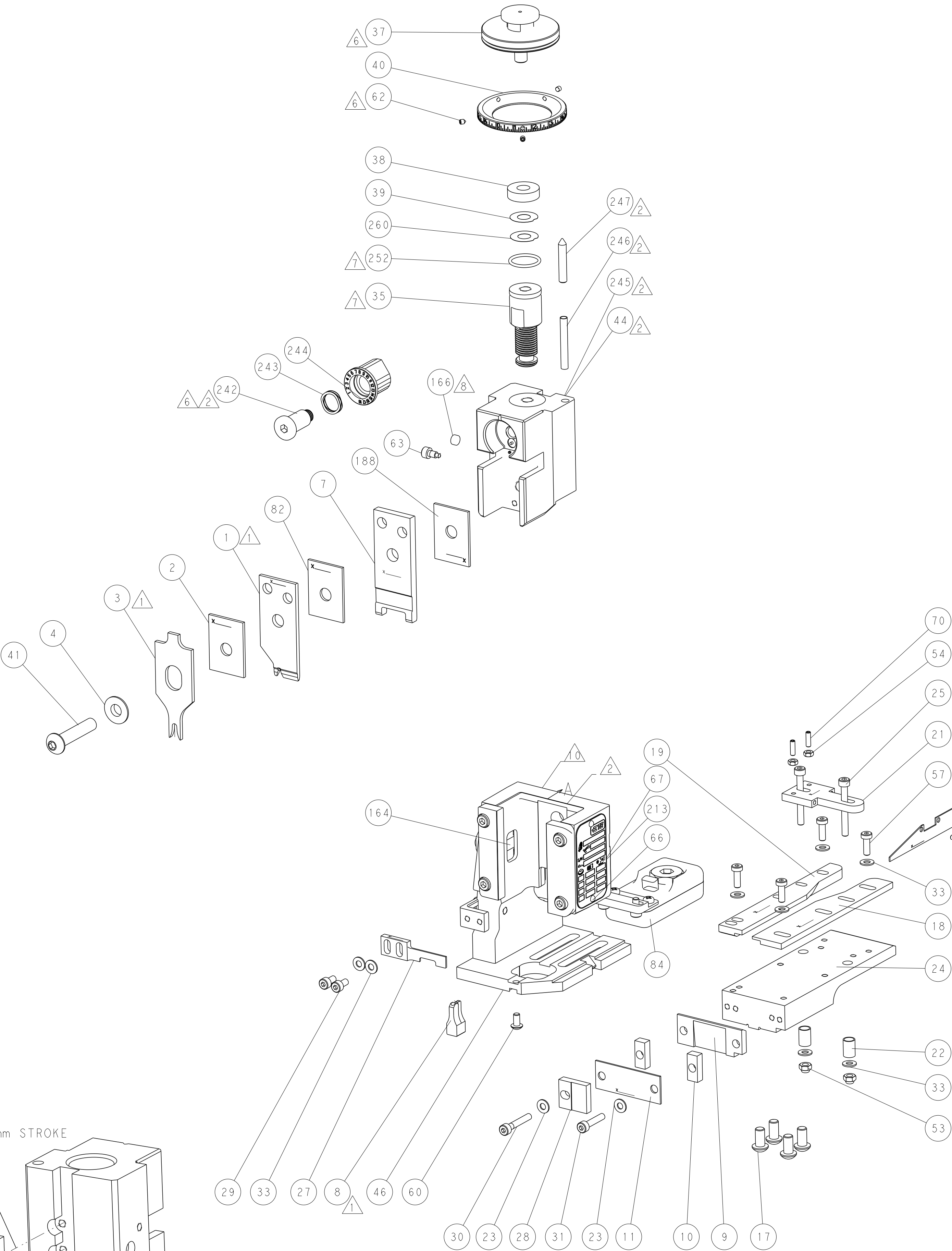
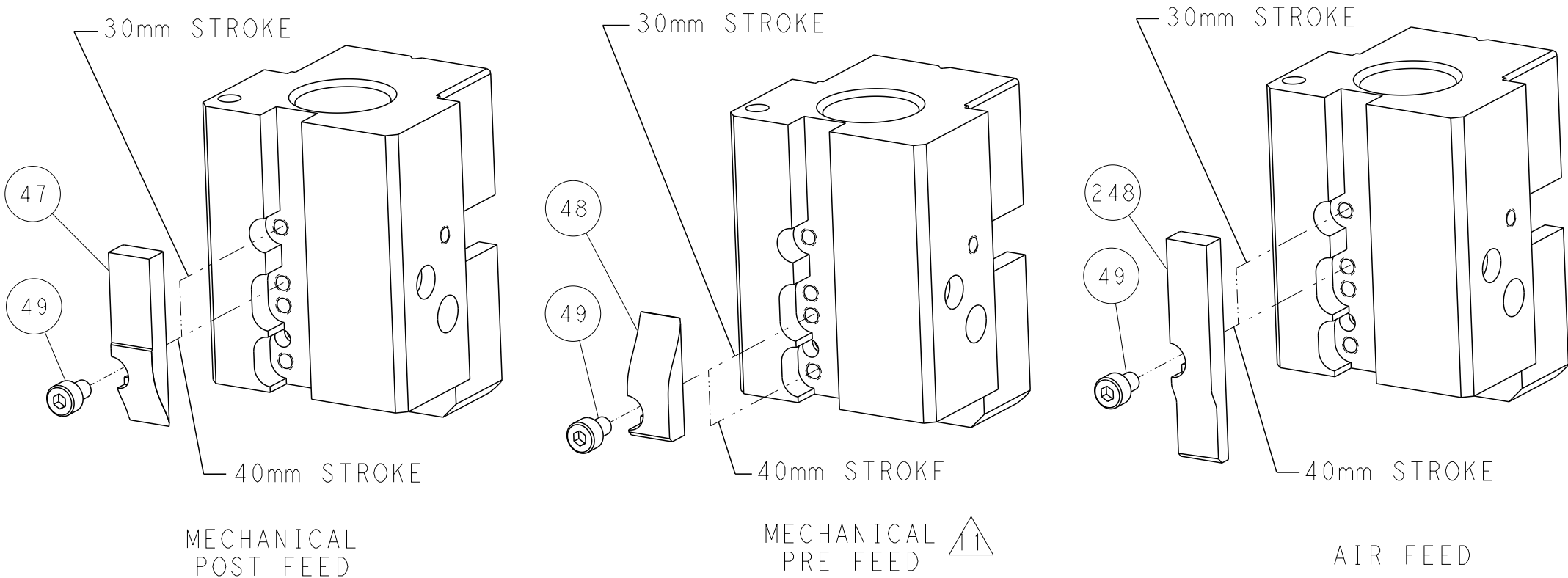
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS

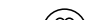


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.				OWN: BOB HIGMAN 09DEC2013 CHK: T.ELBIN 09DEC2013 APVD: M.CILFORD 09DEC2013 PRODUCT SPEC APPLICATION SPEC WEIGHT: - Customer Accessible Production Drawing				NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150397 SCALE: 1:1 SHEET: 2 OF 4 REV: B			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				TE Connectivity Harrisburg, PA 17105-3608			
RESTRICTED TO				RESTRICTED TO				RESTRICTED TO			

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION
		2-2150397-1	B
		2-2150397-2	B
		2-2150397-5	B
		2-2150397-7	B
		7-2150397-7	A
DESCRIPTION		FINE CRIMP HEIGHT ADJUST	
DESCRIPTION		FINE CRIMP HEIGHT ADJUST	
DESCRIPTION		FINE CRIMP HEIGHT ADJUST	
DESCRIPTION		FINE CRIMP HEIGHT ADJUST	
DESCRIPTION		CRIMP TOOLING KIT	
APPLICATOR DATA			
CRIMP	SIZE	TYPE	
WIRE	1.78 mm [.070]	F	
INSUL	3.56 mm [1.40]	O	
APPLICATOR INSTRUCTIONS 408-10390			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON FLAG .187 SERIES			
WIRE STRIP LENGTH 4.39-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø1.52-2.79 mm [.060-.110 IN]	
TERMINAL APPLICATION SPECIFICATION		114-2079	
-		-	
-		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742086-1	1742086-2	1742087-1	1742087-2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.27+/-0.05 [0.050+/-0.002]		4.7
20 AWG		1.14+/-0.05 [0.045+/-0.002]		6.2
22 AWG		1.06+/-0.05 [0.042+/-0.002]		7.1



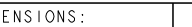
1. RECOMMENDED SPARE PARTS
2. GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150397-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150397-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150397-5
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 ITEM 62.
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.
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.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-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)

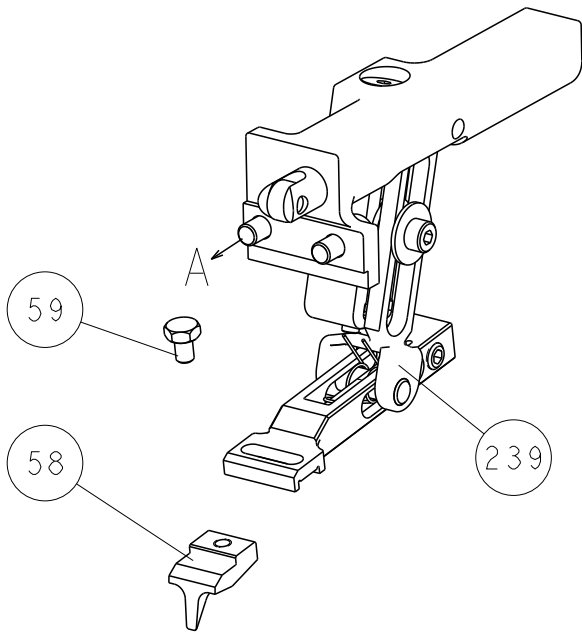
2		1	
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISONS
P	LTR	DESCRIPTION	DATE
-	-	SEE SHEET 1	-

6	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249	
	-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246	
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
	-	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	
	-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	189	
-	1	1	1	1	1-455888-5	SPACER, CRIMPER	188		
-	-	REF	-	-	1901697-3	FEED FINGER ASSEMBLY,EF	183		
-	-	-	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	1-2119655-8	APPLICATOR BASIC ASSEMBLY, EF	141		
-	1	1	1	1	2161313-1	RAM, STEPPED, ASIAN STYLE, END FEED	40		
-	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	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	1	1-455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71	
-	2	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	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
6	-	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	2161924-1	FEED FINGER	58	
	-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
	-	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	-	2161920-1	NARROW PAWL, EF, AIR	51
	-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38	
-	8	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	1	1	1	1	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	1	1	1	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	30	
-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	1	469633-1	BLOCK, SUPPORT	28	
-	1	1	1	1	1	468281-8	STRIPPER	27	
-	2	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1	1	1	2161922-4	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	23	
-	2	2	2	2	2	22281-6	SPRING, COMPRESSION	22	
-	1	1	1	1	1	1633168-2	ARM, STOCK DRAG	21	
-	1	1	1	1	1	464452-4	DRAG, STOCK	20	
-	1	1	1	1	1	5-1901696-7	STRIP GUIDE, REAR	19	
-	1	1	1	1	1	3-1901695-1	STRIP GUIDE, FRONT	18	
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
1	-	1	1	1	1	455961-5	PLATE, FRONT SHEAR	11	
	-	2	2	2	2	1-240645-9	SPACER, SHEAR PLATE	10	
1	-	1	1	1	1	461160-3	PLATE, REAR SHEAR	9	
	1	1	1	1	1	4-1803000-0	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	1	2161927-1	BLADE, SLUG	7	
	-	-	-	-	-	-	-	6	
-	-	-	-	-	-	-	-	5	
-	1	1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4	
1	1	1	1	1	1	1803018-8	CRIMPER, INSULATION O	3	
	-	1	1	1	1	1-455888-7	SPACER, CRIMPER	2	
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	-77-27-25-22-21	PART NO					DESCRIPTION		ITEM NO

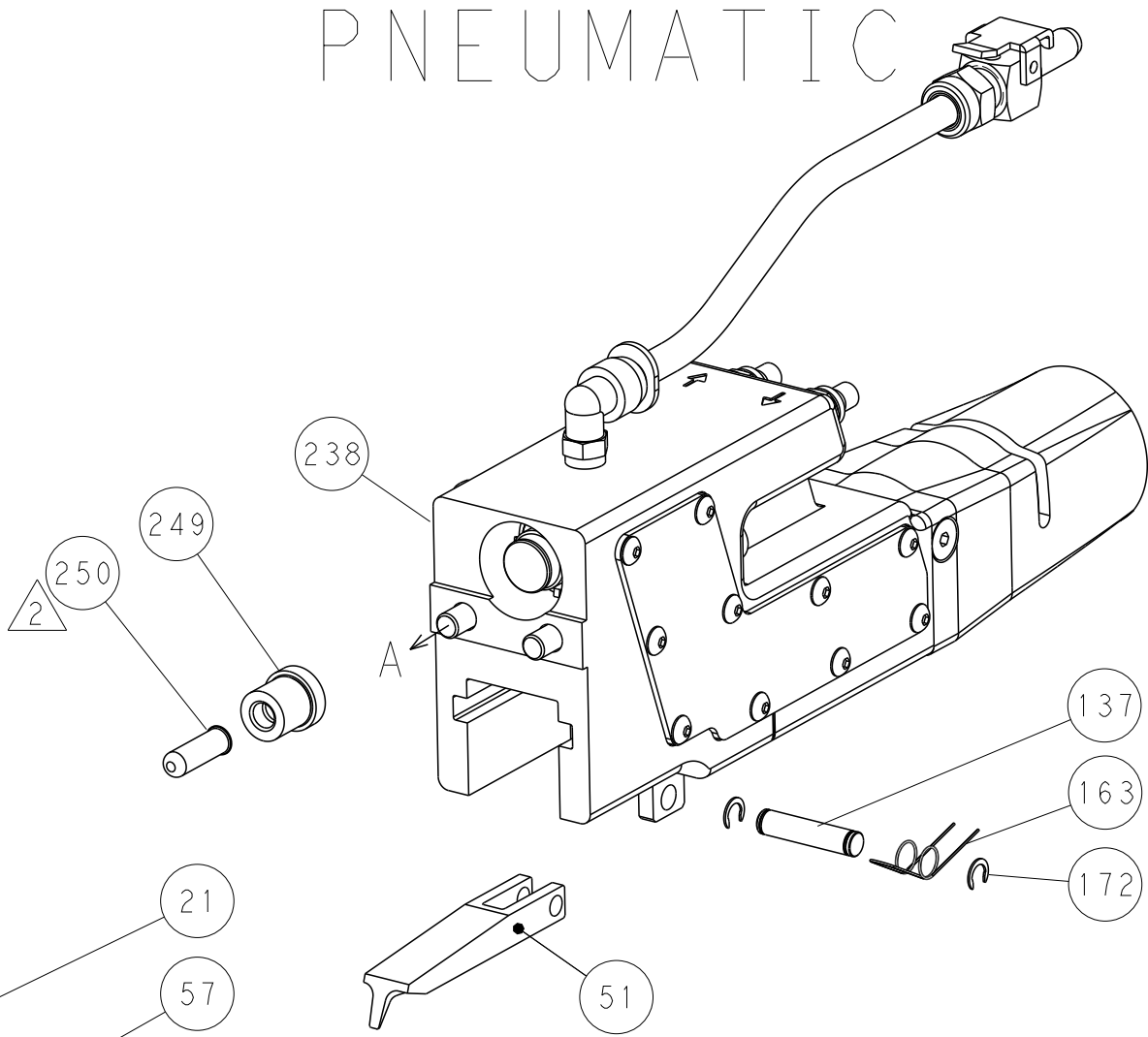
THIS IS A STANDARD 1/2 CONDUIT END VIEW. ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED.		DRAWN BY: BOB HIGMAN 09DEC2013 CHECKED BY: ELBIN 09DEC2013 APPROVED BY: M CLIFFORD 09DEC2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
		PRODUCT SPEC APPLICATION SPEC		SIZE A	
MATERIAL -		WEIGHT -		CAGE CODE 00779	
FINISH -		RESTRICTED TO -		DRAWING NO. C=2150397	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 3 of 4 REV B	

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

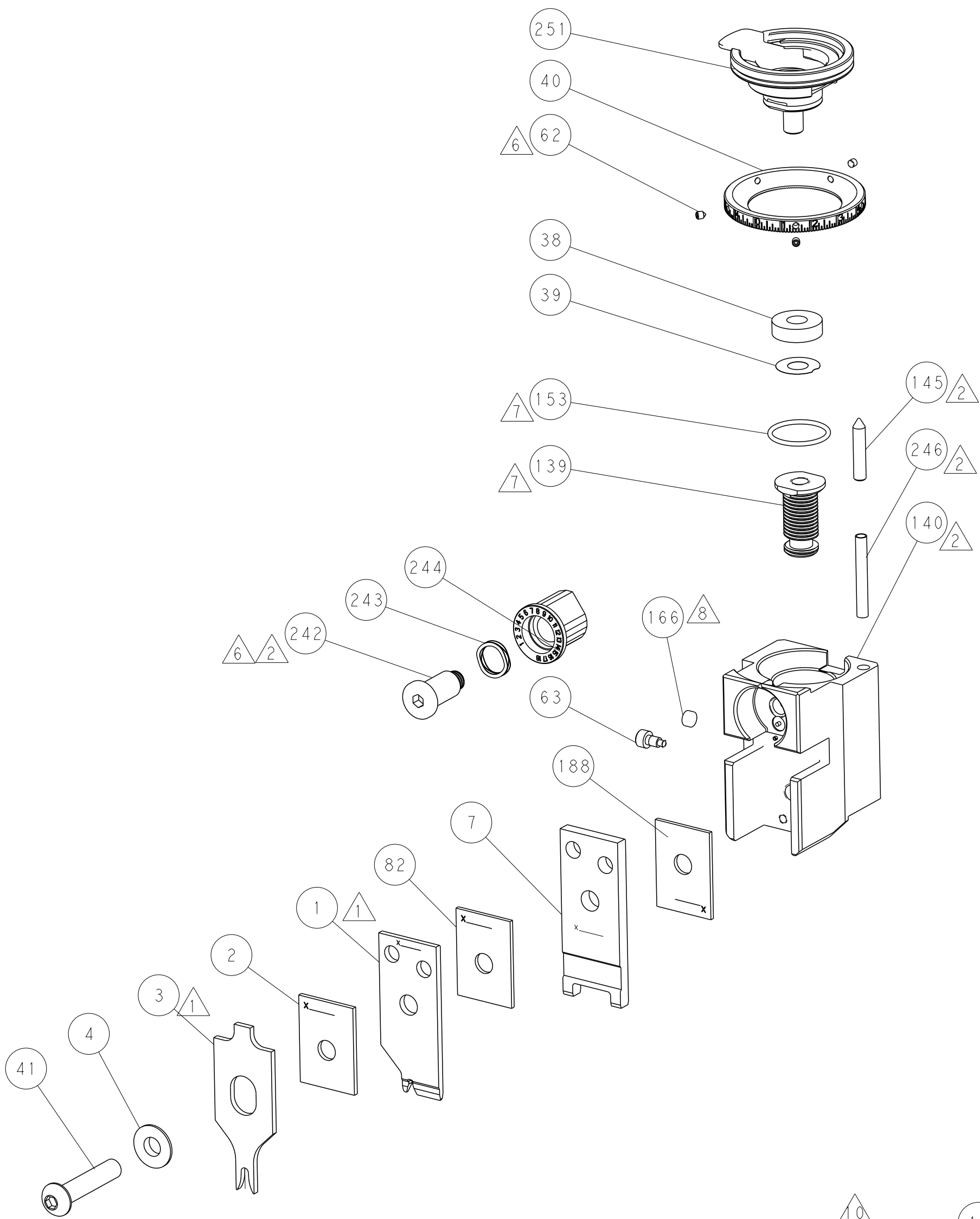
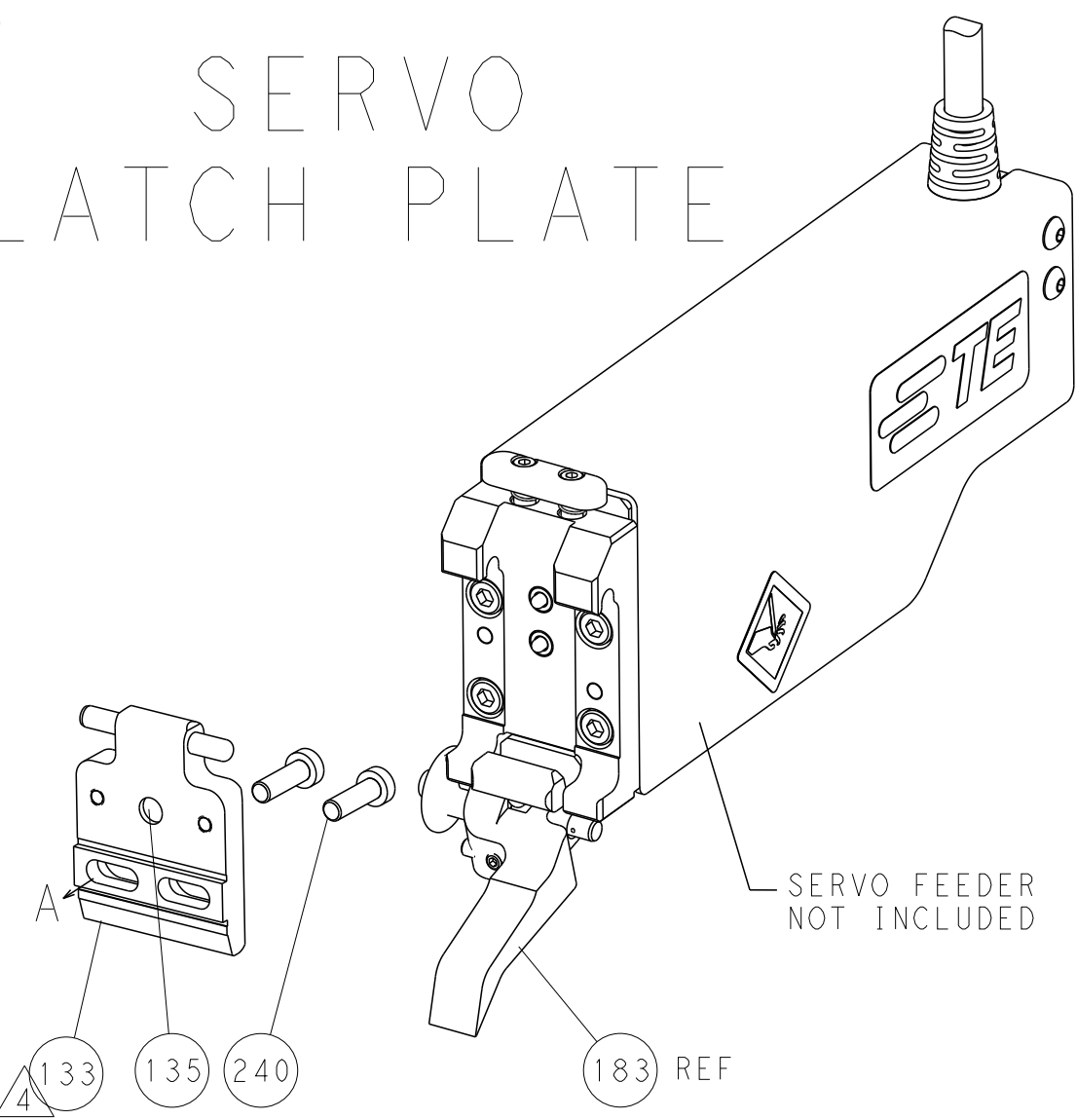
FEED TYPE
MECHANICAL



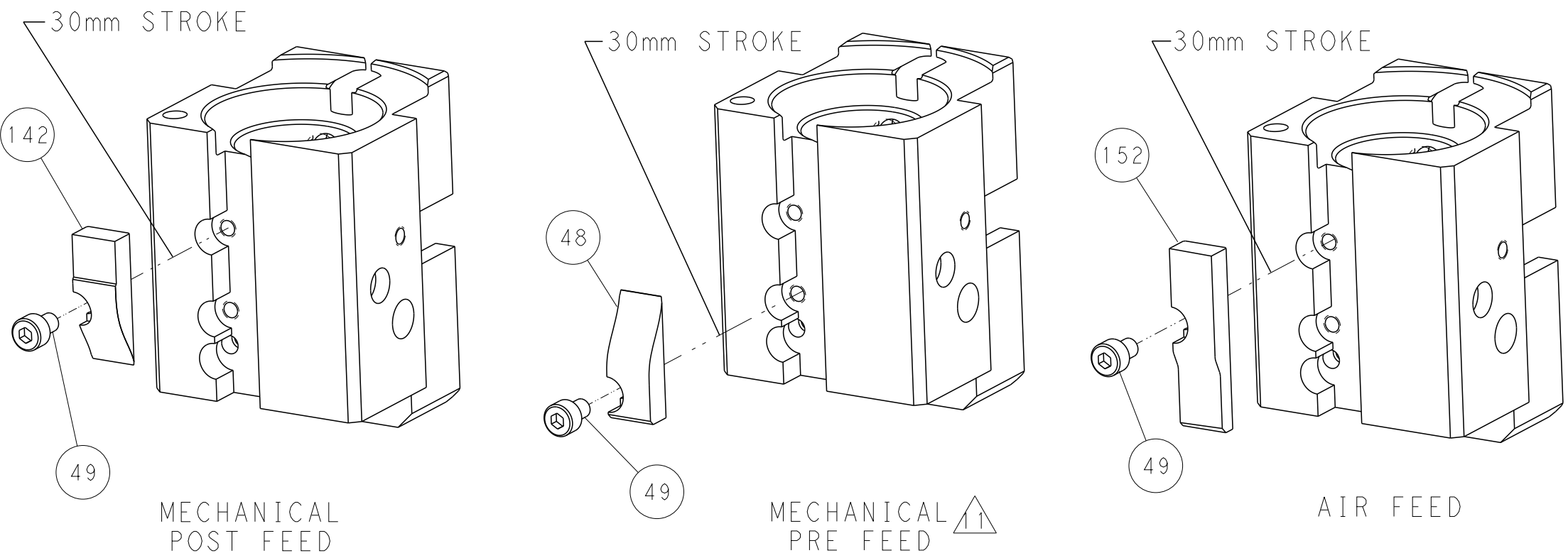
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO VERIFY THE DIMENSIONS AND TOLERANCES OF THE PARTS AND ASSEMBLY BEFORE USE.				DWN: BOB HIGMAN 09DEC2013 CHK: T. ELBIN 09DEC2013 APVD: M. CLIFFORD 09DEC2013				STE TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				NAME: Ocean End Feed Applicator			
MATERIAL: -				WEIGHT: -				SIZE: A1 00779 C=2150397			
				Customer Accessible Production Drawing				SCALE: 1:1 SHEET 4 OF 4 REV B			