



- 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: 8-2150425-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150425-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150425-3
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150425-6
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 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 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.
- 12 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
- 13 ITEM #261 FOR (2)18 AWG WIRE SIZES. ITEM #3 FOR ALL OTHER WIRE SIZES

6		5		4			3	
FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
	CONVERT TO	PART NUMBERS REQUIRED						
MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1	
	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150425-5	-	-	2168400-7 (QUANTITY 2)	
	SMART APPLICATOR	2161326-1	-	8-2150425-4	-	-	-	
PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-	
	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150425-5	-	-	2168400-7 (QUANTITY 2)	
	SMART APPLICATOR	2161326-1	-	8-2150425-4	-	-	-	
SERVO LATCH PLATE ₄	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-	
	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1	
₄ SERVO LATCH PLATE ₁₂	-	-	-	-	-	-	-	
	-	-	-	-	-	-	-	
NONE	-	-	-	-	-	-	-	
-	-	-	-	-	-	-	-	

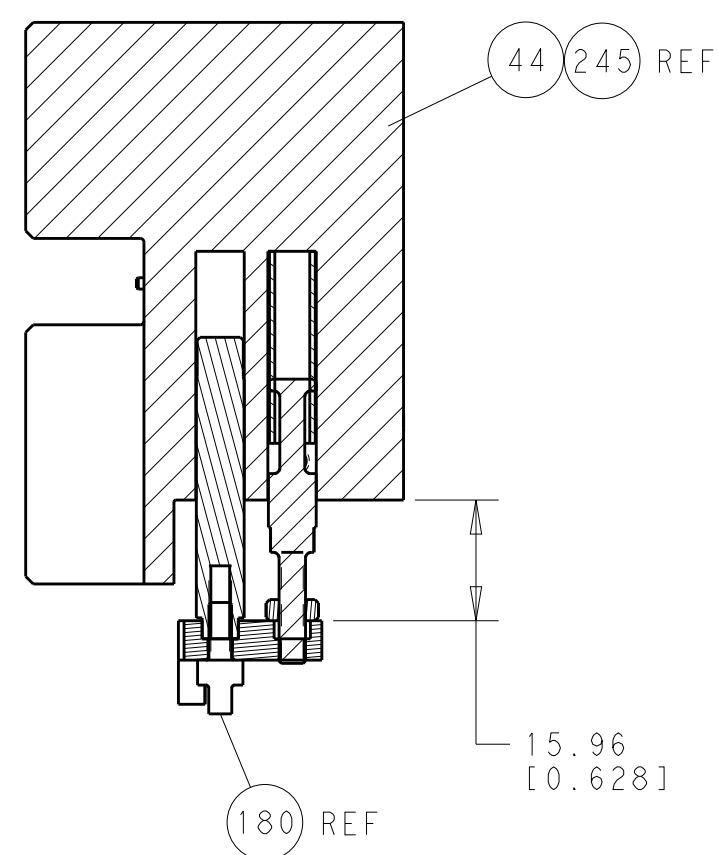
*WARNING ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.									
4 10 5 37. 4 RATION. ES.	13 1						3-1803016-1	CRIMPER, INSULATION F	261
	-						2119957-2	APPLICATOR SHIM PACK	260
	-						8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
	-						2119640-1	PUSH ROD, AIR FEED	250
	-						2079988-1	BUSHING, LCH5-12, MISUMI	249
	-						2119641-1	FEED CAM, AIR FEED	248
	-						2119798-1	DETENT PIN	247
	-						1-22279-3	SPRING, COMPRESSION	246
	-						2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
	-						2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-						2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

ATLANTIC VERSION

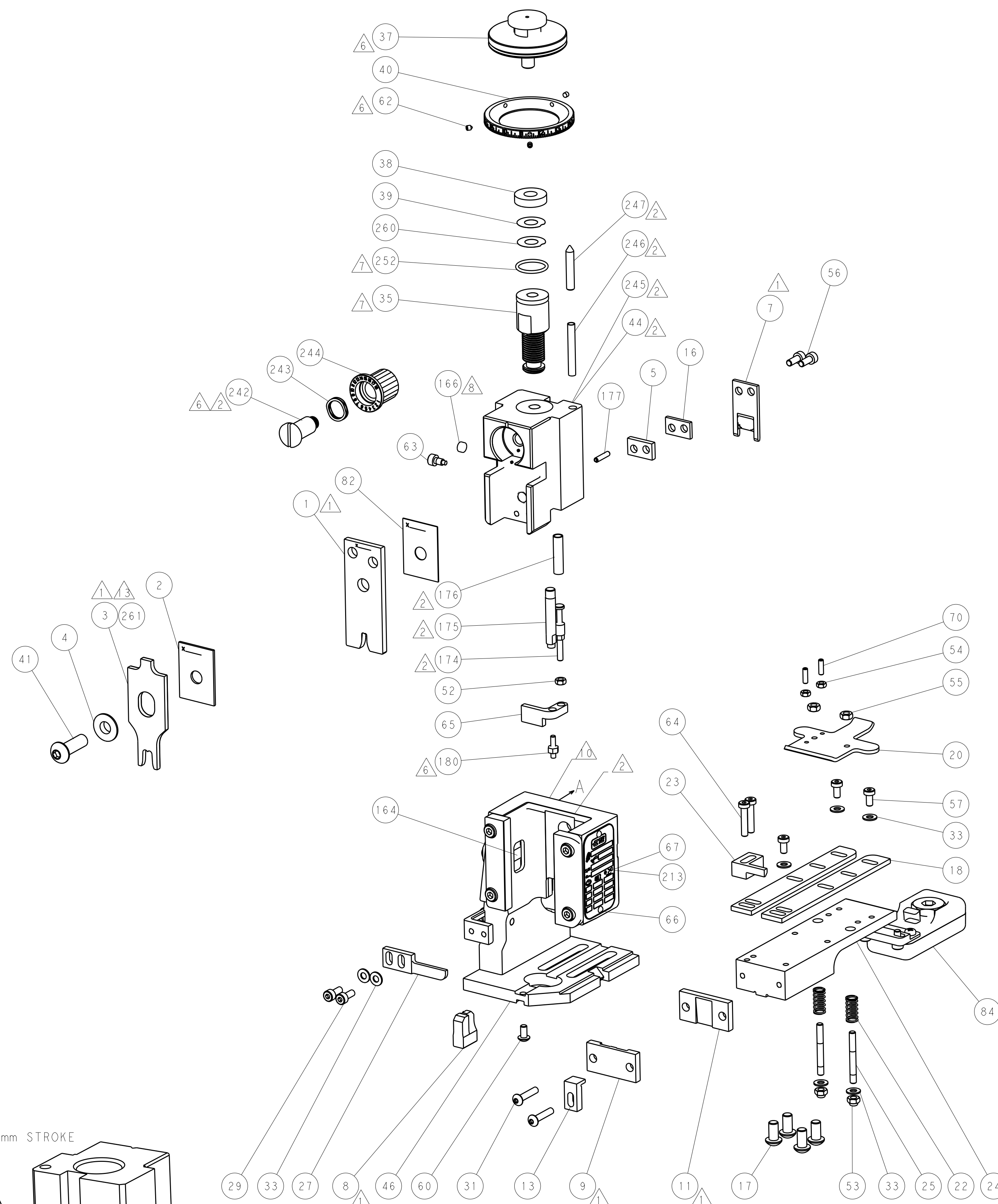
Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

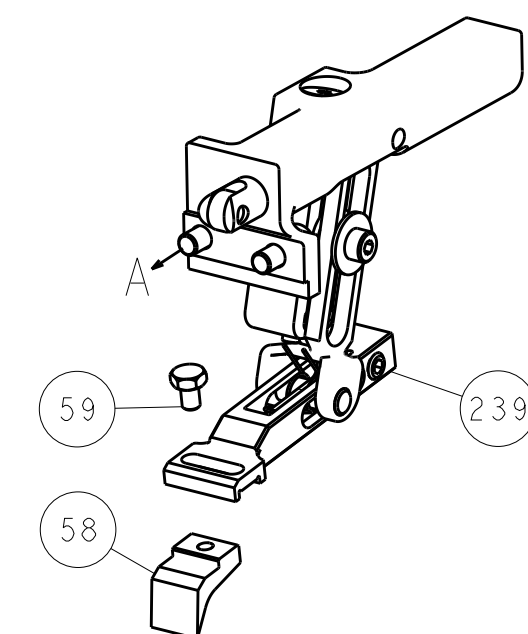
SET UP GAUGE 2119599-2										LOC A	DIST 66	REVISIONS				
P		LTR		DESCRIPTION						DATE	DWN	APVD				
		A		RELEASE						14MAR2014	XZ	GB				
		B		ECR-14-013283						05SEP2014	XZ	JT				
6	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL				242				
	-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10				240				
	-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY				239				
	-	-	-	-	1	-	2063440-1	AIR FEED MODULE				238				
-	-	1	1	-	-	-	2119740-2	TAG, IDENTIFICATION				213				
6	-	-	REF	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF				183				
	-	1	1	1	1	1	1-1976055-3	STANDOFF, HOLD-DOWN				180				
	-	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0				177				
	-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION				176				
-	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN				175					
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN				174					
-	-	-	-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT				172				
-	1	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY				166				
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC				164				
-	-	-	-	1	-	-	240638-1	SPRING, FEED FINGER				163				
-	-	-	-	1	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854				137				
-	-	REF	REF	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED				135				
-	-	1	1	-	-	-	1633743-1	SERVO FEED LATCH ASM				133				
-	1	1	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED				84				
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER				82				
-	1	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE				71				
-	2	2	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0				70				
-	1	-	-	1	1	1	2119740-1	TAG, IDENTIFICATION				67				
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188				66				
-	1	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL				65				
-	2	2	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20				64				
-	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	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)				60				
	-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0				59				
	-	-	-	-	-	1	2063961-1	FEED FINGER				58				
-	3	3	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8				57				
-	2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10				56				
-	2	2	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4				55				
-	2	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3				54				
-	2	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)				53				
-	1	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5				52				
-	-	-	-	1	-	-	2119792-2	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	-	2119653-1	FEED CAM, POST FEED				47				
-	1	1	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF				46				
-	1	-	1	1	1	1	2119369-1	RAM, AMP STYLE, END FEED				44				
-	1	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)				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				
6	-	1	1	1	1	1	2119644-2	RAM WASHER, PRECISION				38				
	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE				37				
	-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT				35				
	-	7	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4				33				
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)				31				
-	2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10				29				
-	1	1	1	1	1	1	240639-1	STRIPPER (MACHINING)				27				
-	2	2	2	2	2	2	1320906-1	STUD, THREADED				25				
-	1	1	1	1	1	1	1752371-5	PLATE, STRIP GUIDE				24				
-	1	1	1	1	1	1	240825-8	PLATE, STRIP HOLD DOWN				23				
-	2	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION				22				
-	1	1	1	1	1	1	1752373-4	DRAG				20				
-	2	2	2	2	2	2	1901259-6	GUIDE, LOWER STRIP				18				
-	4	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)				17				
-	1	1	1	1	1	1	240641-9	SPACER				16				
1	-	1	1	1	1	1	1752360-1	SPACER, HOLD-DOWN				13				
	-	1	1	1	1	1	240644-9	PLATE, REAR SHEAR				11				
-	-	-	-	-	-	-	-	-				10				
1	-	1	1	1	1	1	5-690482-9	PLATE, FRONT SHEAR				9				
	1	1	1	1	1	1	4-1803000-6	ANVIL, COMBINATION, END FEED				8				
1	-	1	1	1	1	1	1-2217206-3	BLADE, SLUG				7				
	-	-	-	-	-	-	-	-				6				
-	1	1	1	1	1	1	240641-8	SPACER				5				
-	1	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER				4				
1	1	1	1	1	1	1	3-1803016-4	CRIMPER, INSULATION F				3				
	-	1	1	1	1	1	1-455888-2	SPACER, CRIMPER				2				
1	1	1	1	1	1	1	456425-8	CRIMPER, WIRE .140 F PREMIUM				1				
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION				ITEM NO				
PLOT OR PRINT IN A CONTROLLED ENVIRONMENT FOR FINE ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE AND THE CUSTOMER/INT. ENGINEERING ORGANIZATION SHOULD BE ADVISED OF ANY OF THE LATEST REVISION																
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X_ZHAO 14MAR2014		CHK X_ZHANG 14MAR2014		NAME TE Connectivity Harrisburg, PA 17105-3608		APVD T_FLIRIN 14MAR2014						
mm		0 PLC ±.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001		PRODUCT SPEC -		APPLICATION SPEC -		Ocean End Feed Applicator -		RESTRICTED TO						
MATERIAL -		FINISH -		WEIGHT -		SIZE A1		CAGE CODE 00779		DRAWING NO C-2150425						
Customer Accessible Production Drawing								SCALE 1:1		SHEET 1 of 4						
REV B																



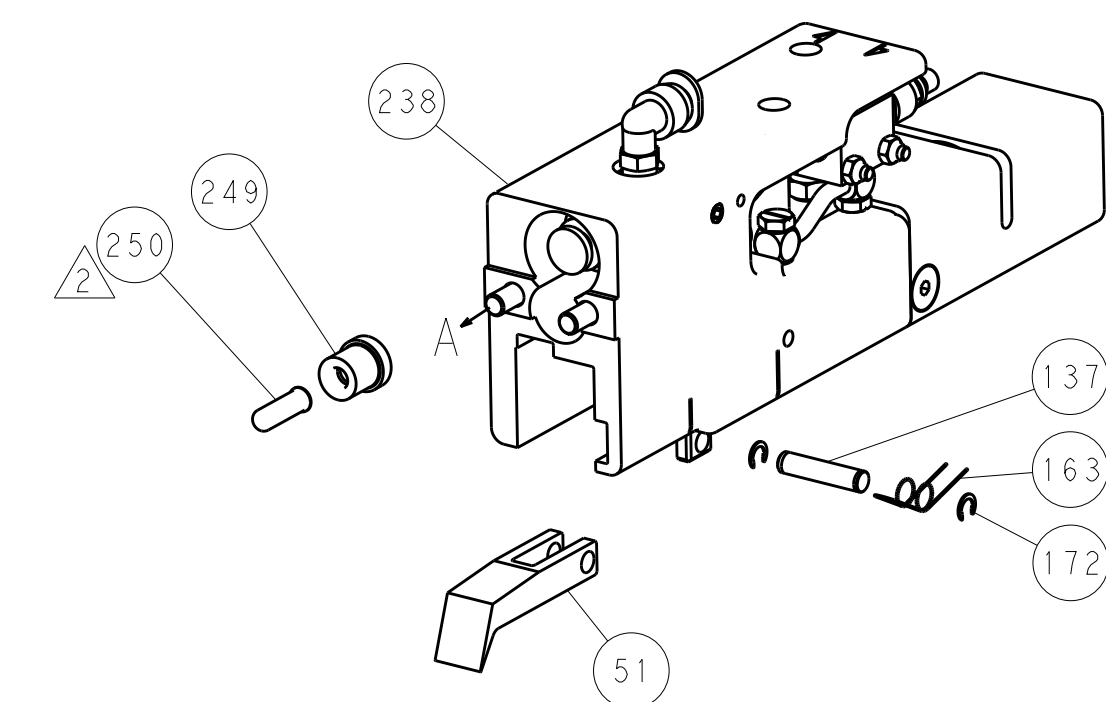
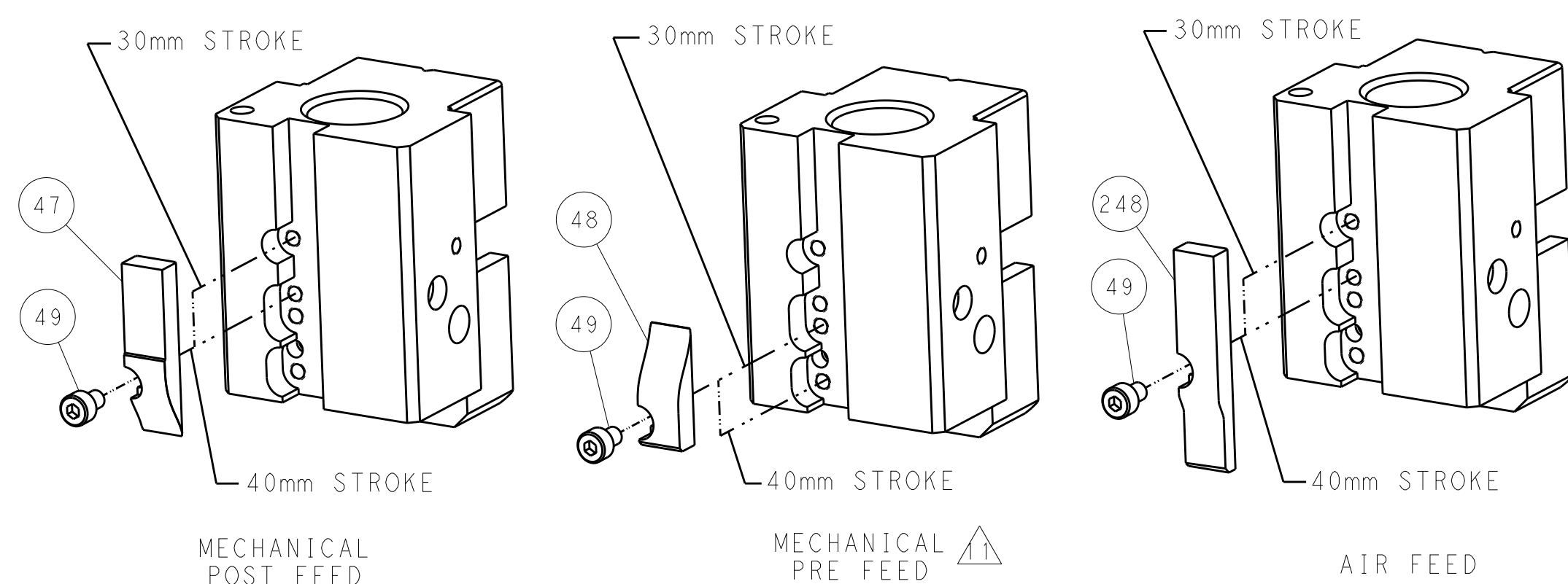
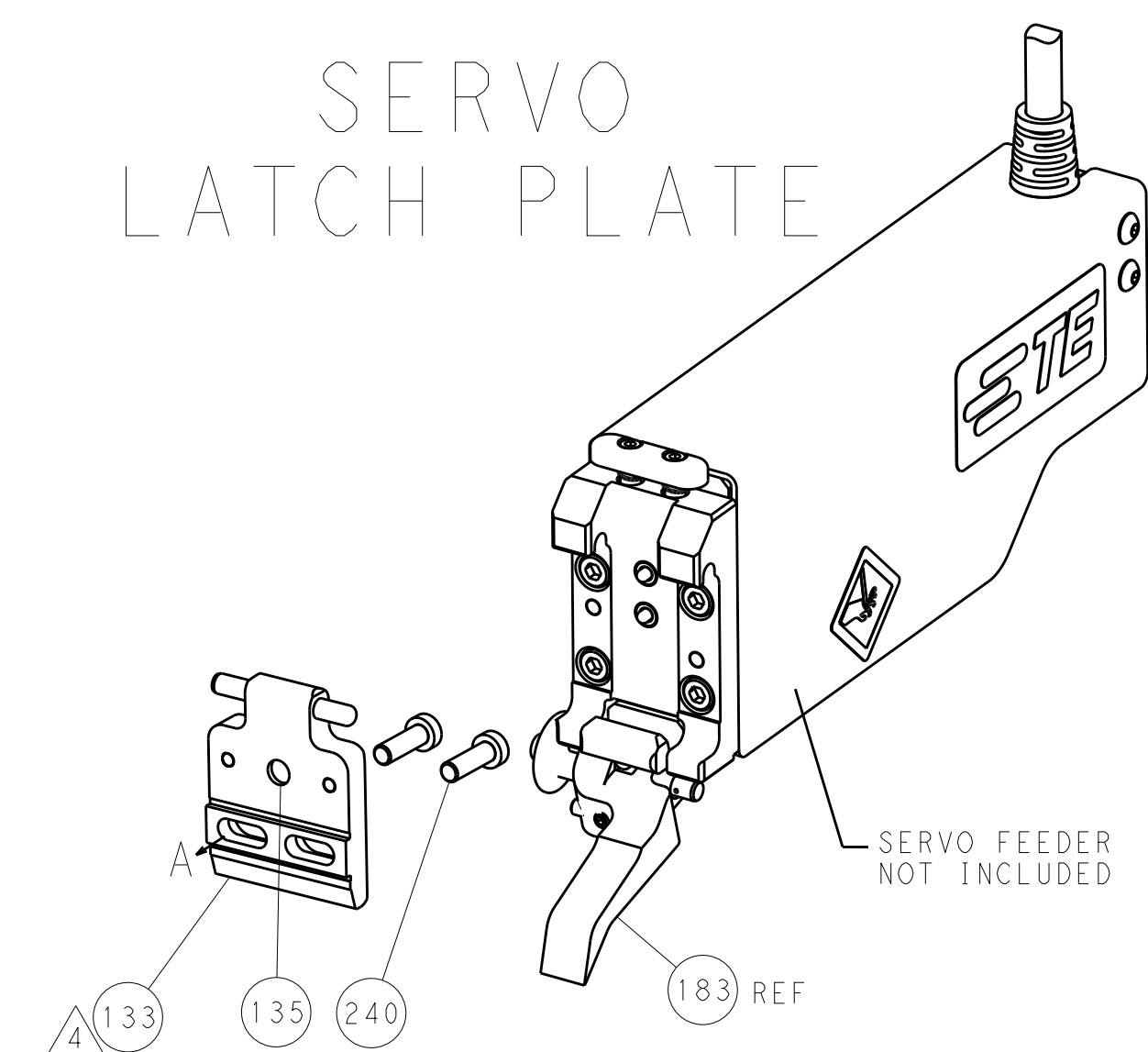
HOLDDOWN SET-UP



FEED TYPE
MECHANICAL

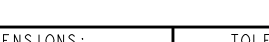


PNEUMATIC

SERVO
LATCH PLATE

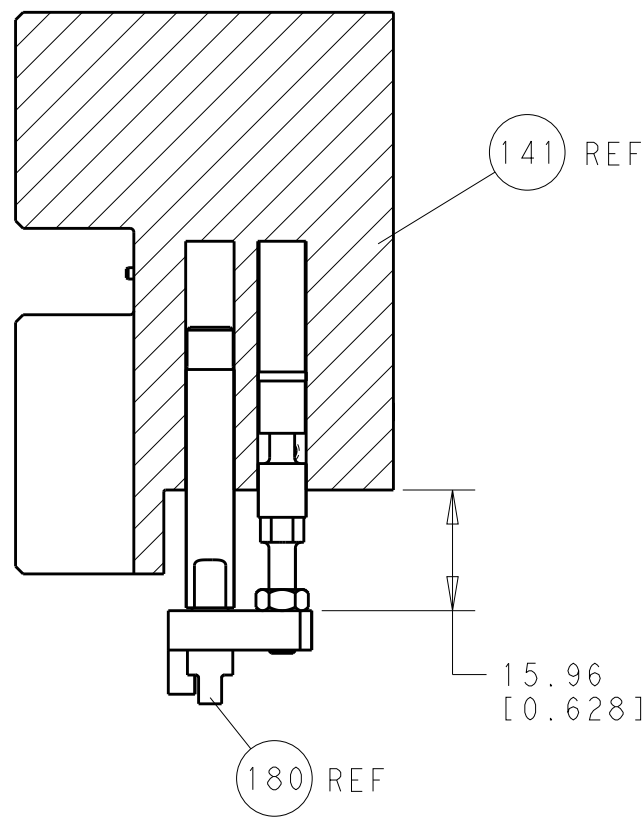
ATLANTIC VERSION

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

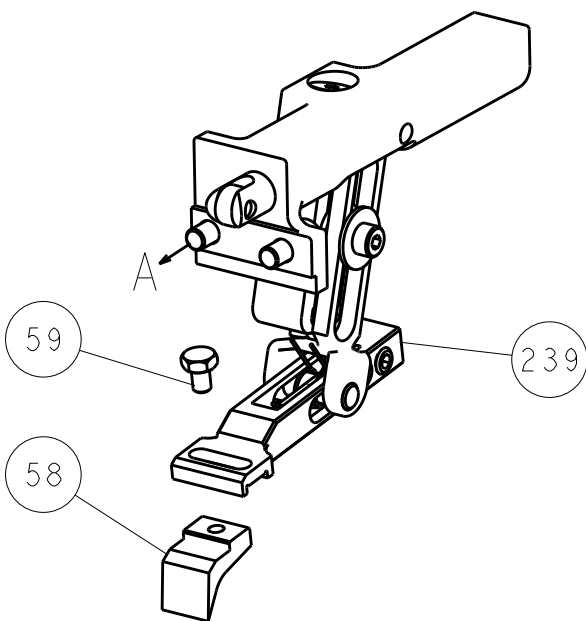
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DIMENSIONS: mm		TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.1	CDR L ZHANG 14MAR2014	NAME Ocean End Feed Applicator
		APVD T LIN 14MAR2014	PRODUCT SPEC -	
MATERIAL -		APPLICATION SPEC -	SIZE A1	
FINISH -		WEIGHT -	CAD CODE 00779	
Customer Accessible Production Drawing			DRAWING NO C-2150425	RESTRICTED TO -
SCALE 1:1			SHEET 2 OF 4	REV B

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

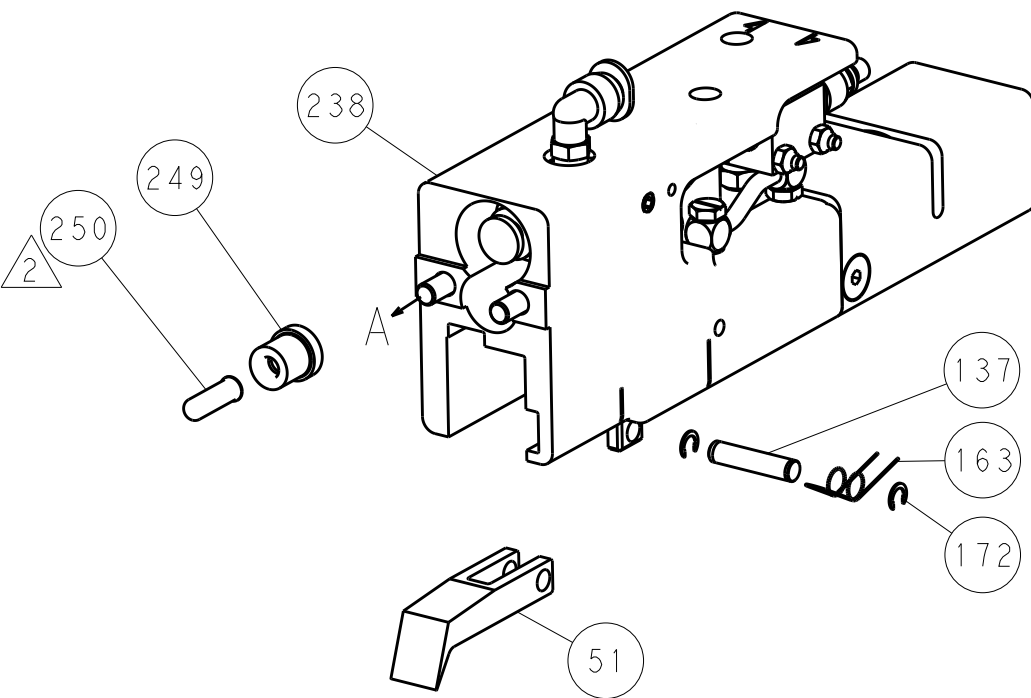
HOLDDOWN SET-UP



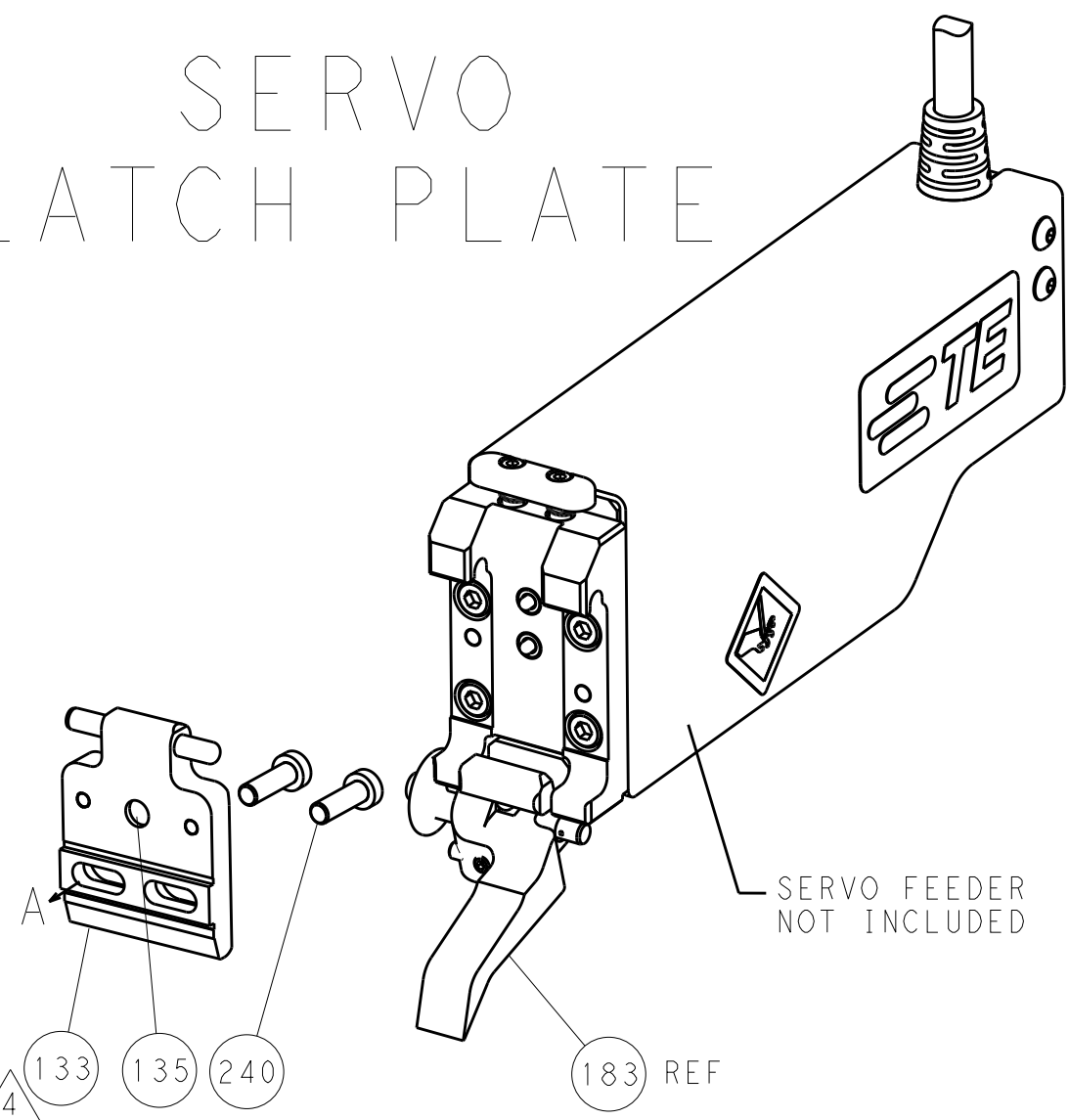
FEED TYPE
MECHANICAL



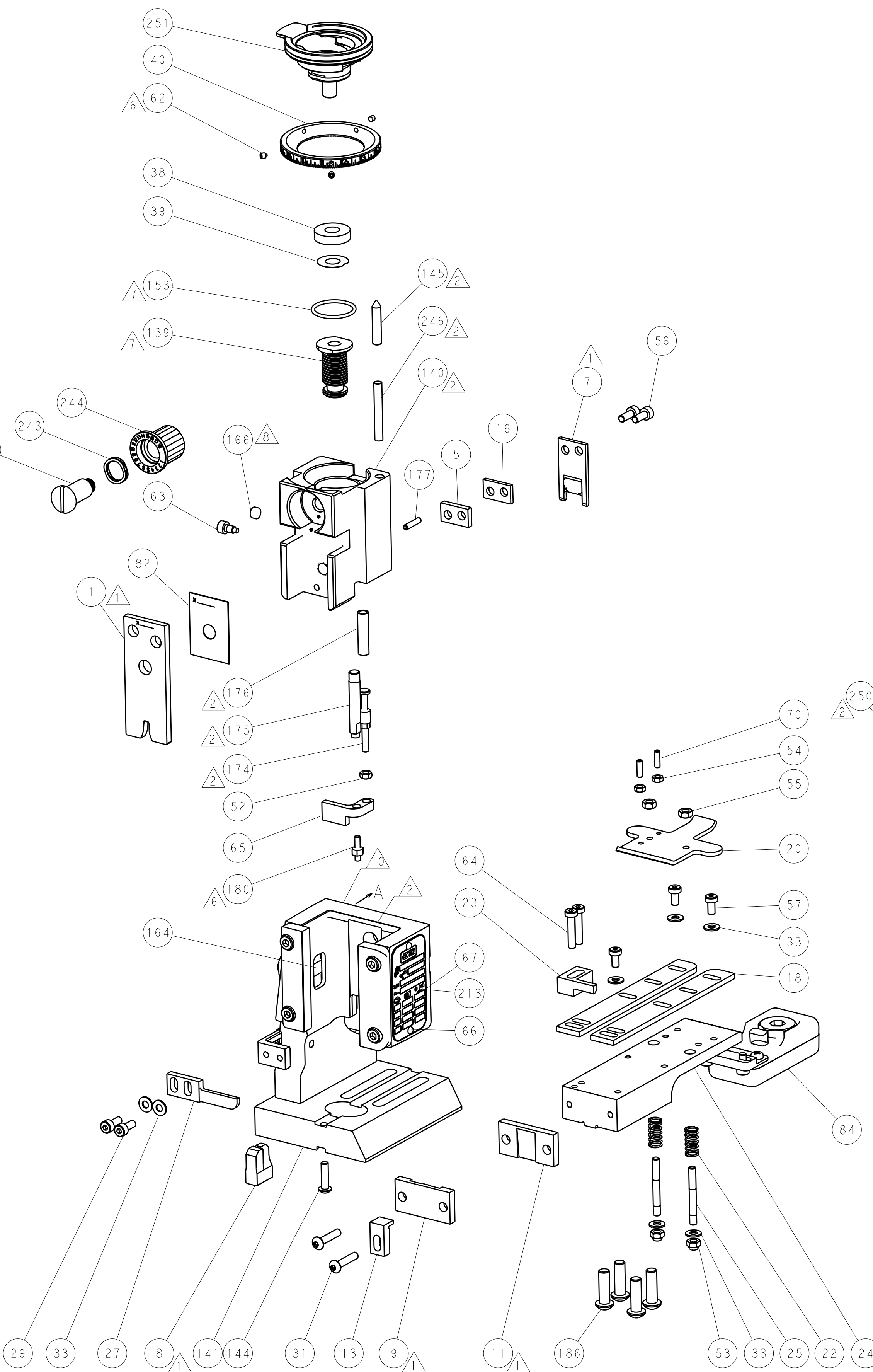
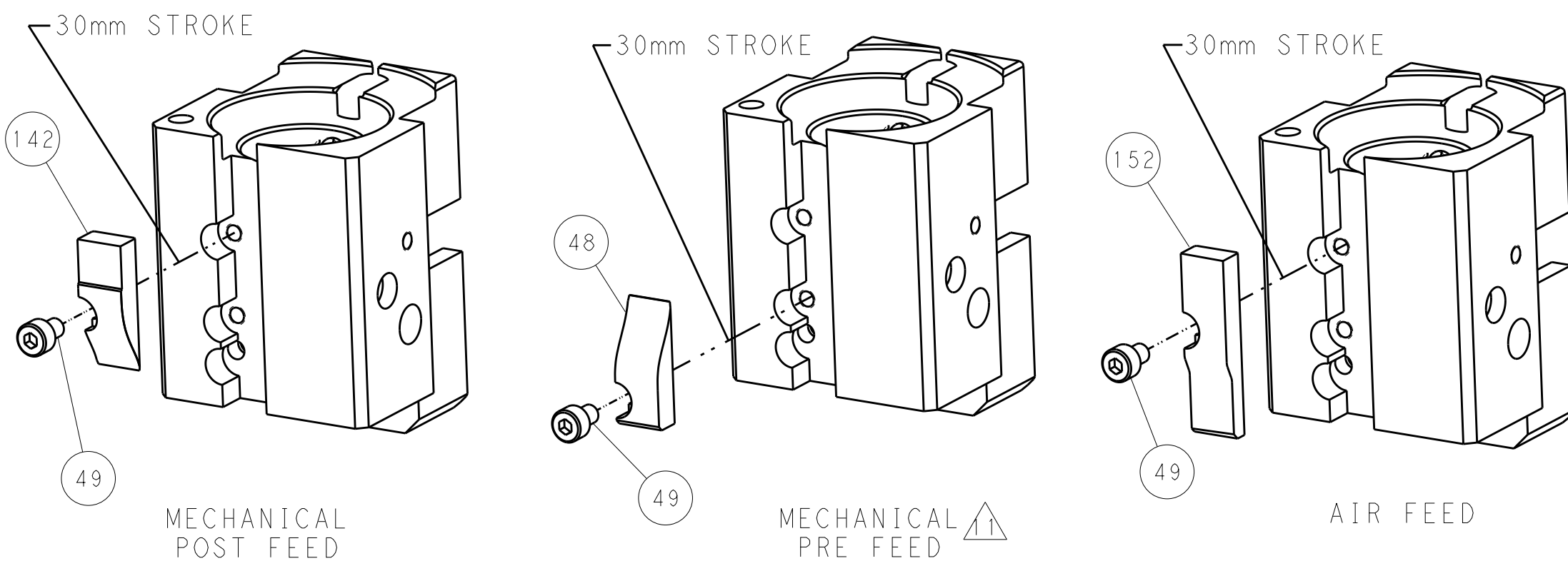
PNEUMATIC



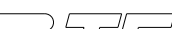
SERVO
LATCH PLATE



CAM POSITIONS



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

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.001				NAME Ocean End Feed Applicator	
		PRODUCT SPEC -				SIZE A1	
MATERIAL -		APPLICATION SPEC -			CAGE CODE 00779	DRAWING NO. C=2150425	RESTRICTED TO -
FINISH -		WEIGHT -			Customer Accessible Production Drawing		
		SCALE 1:1			SHEET 4	OF 4	REV B