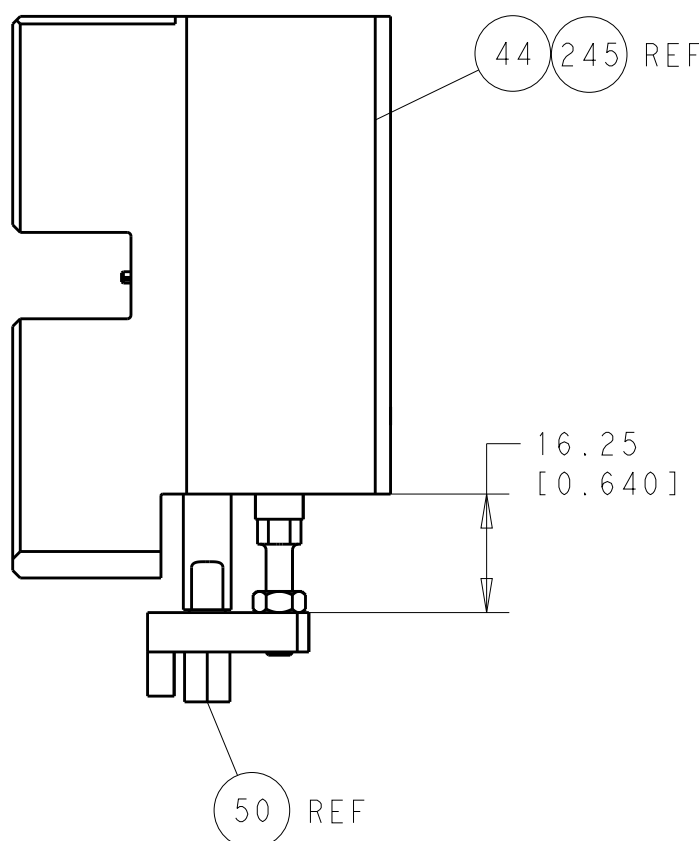


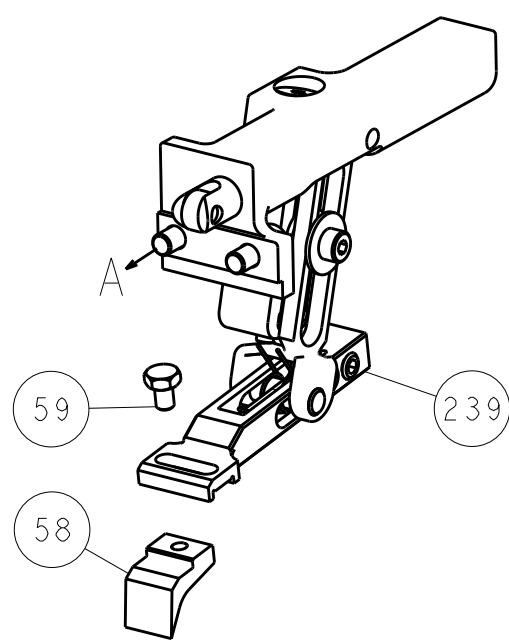
LOC		DIST		REVISONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

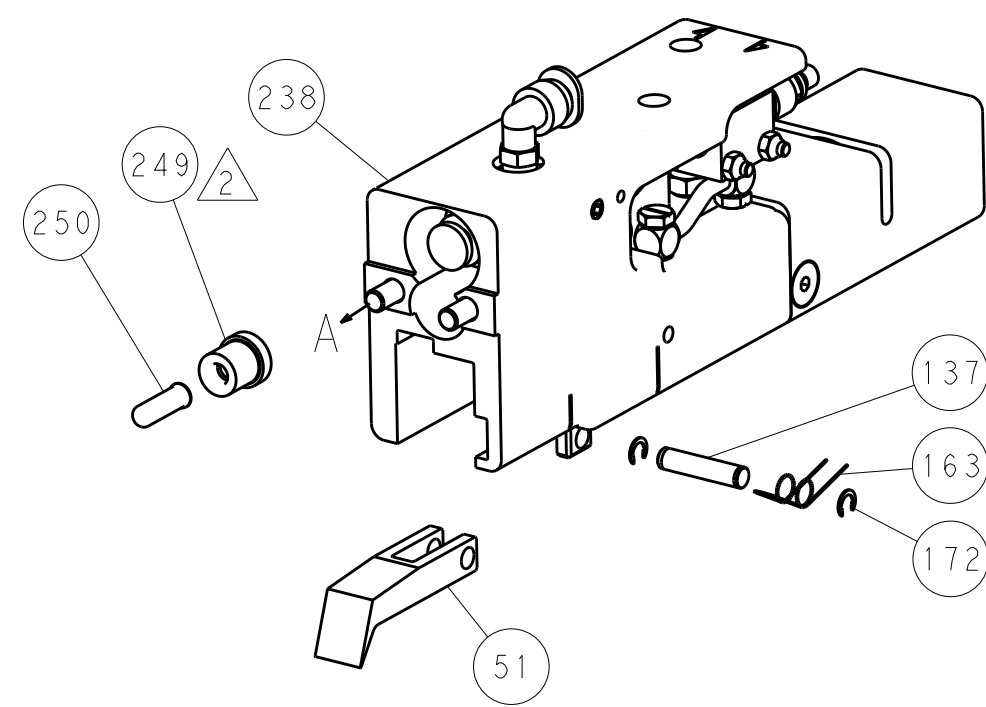


HOLDDOWN SET-UP

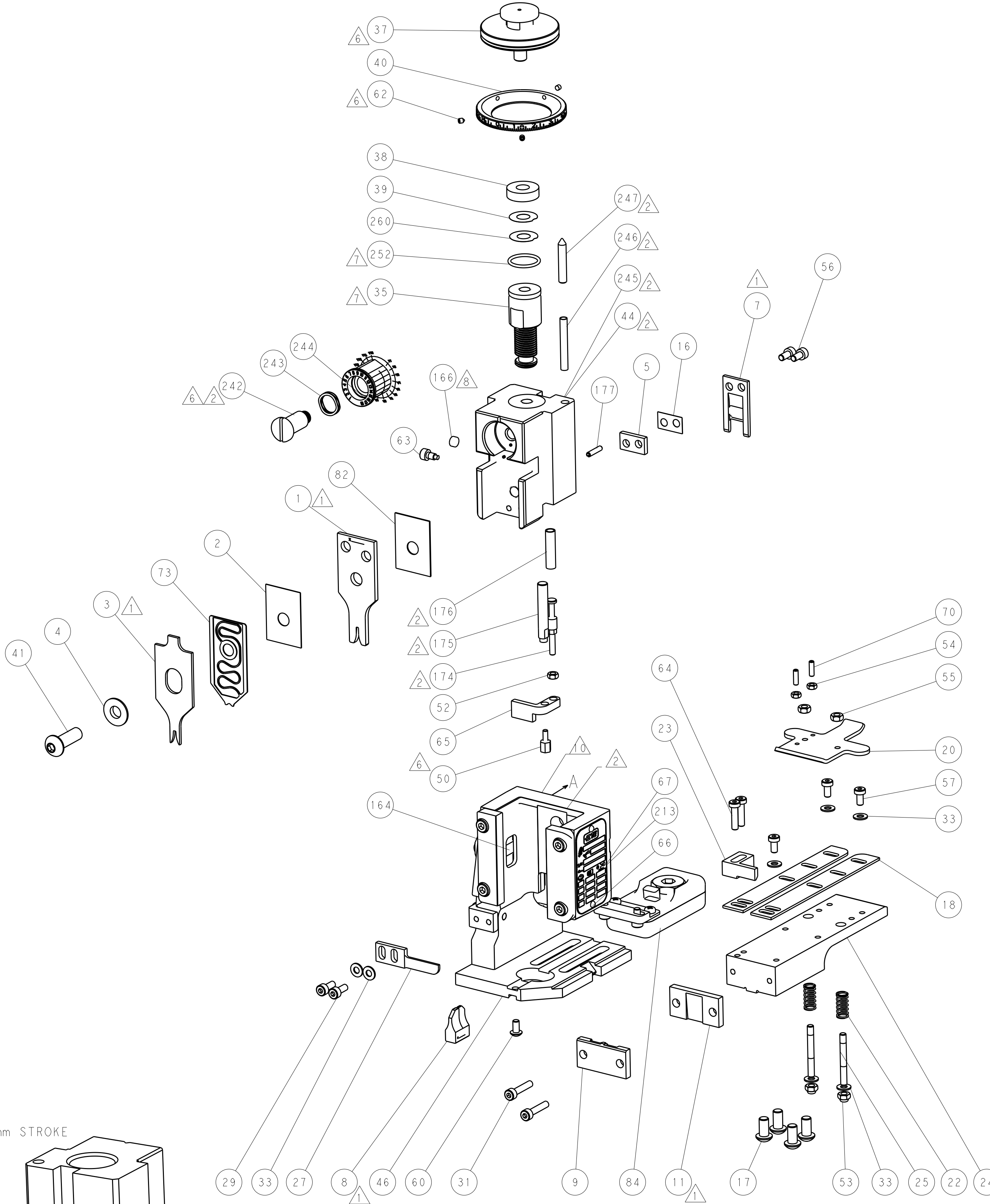
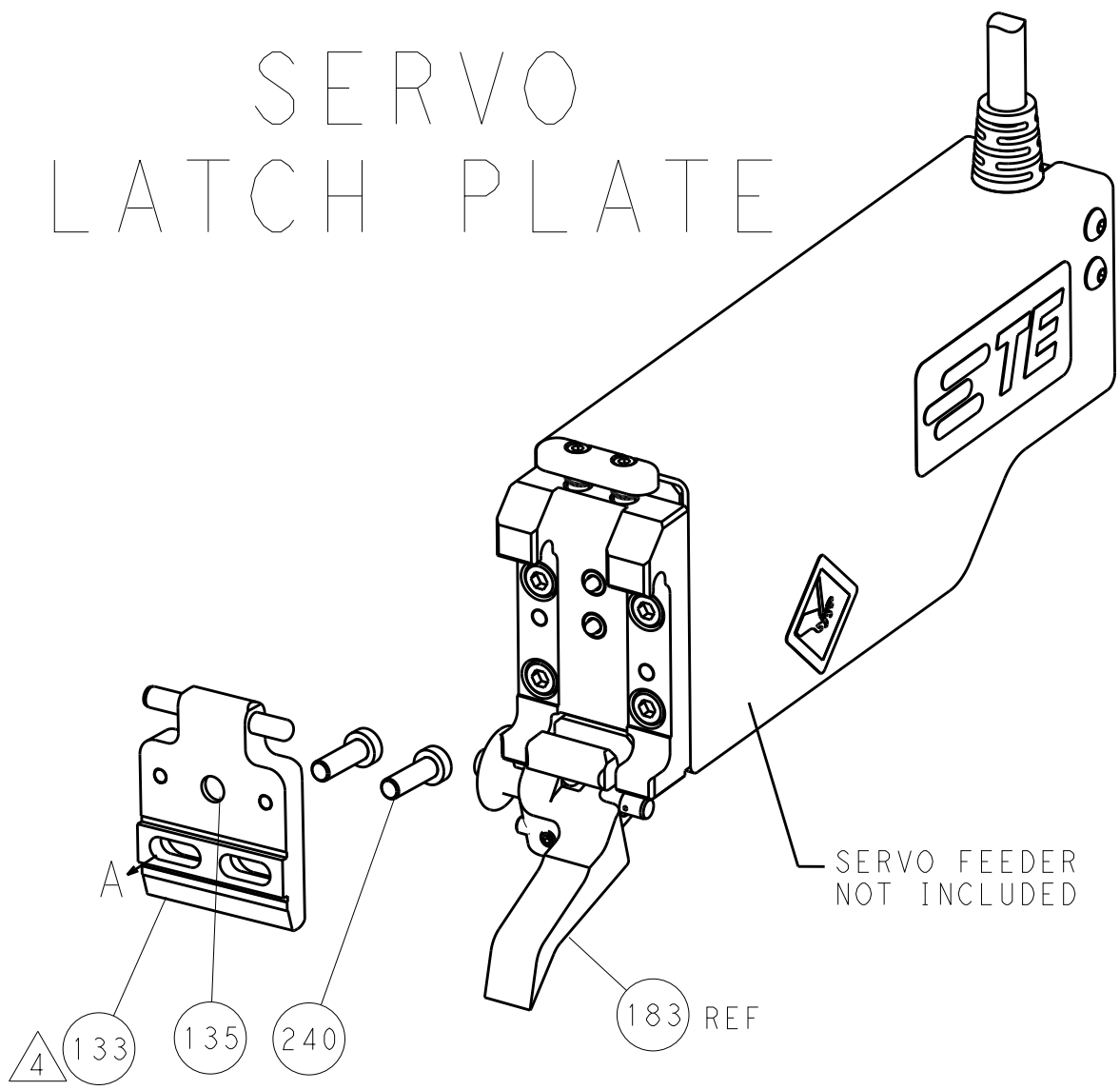
FEED TYPE
MECHANICAL



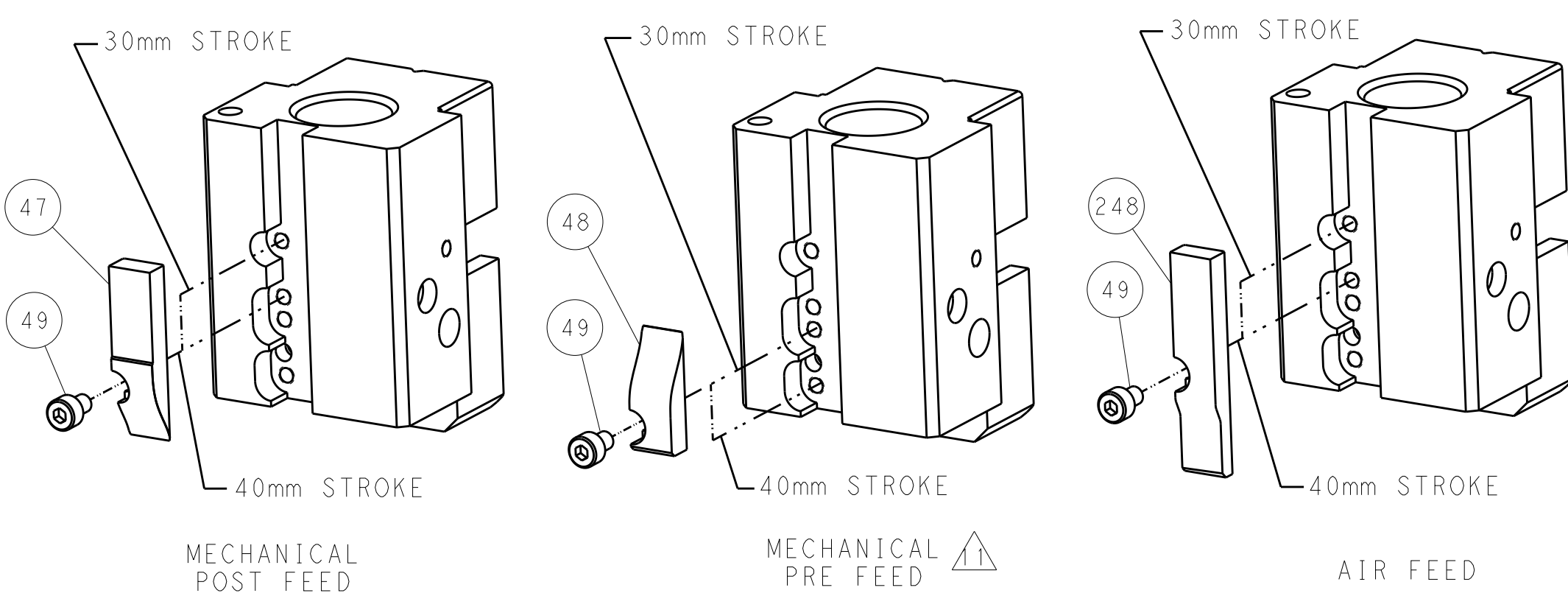
PNEUMATIC



SERVO
LATCH PLATE



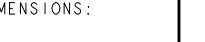
CAM POSITIONS



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

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		FINISH	
MATERIAL		-		-	
OWN Y. YIN CHK S. XI APVD G. BAILEY		16JAN2012 16JAN2012 16JAN2012		NAME -	
PRODUCT SPEC		APPLICATION SPEC		SIZE A1	
WEIGHT		-		CAGE CODE 00779	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 2 of 4	
				REV A	

SET UP GAUGE 2119599-2					LOC A	DIST 66	REVISIONS			
P		LTR		DESCRIPTION			DATE	OWN	APVD	
		-		SEE SHEET 1			-	-	-	
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY			239	
-	-	-	-	1	2063440-1	AIR FEED MODULE			238	
-	-	1	-	-	2119740-2	TAG,IDENTIFICATION			213	
-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)			186	
-	-	REF	-	-	1901697-1	FEED FINGER ASSEMBLY,EF			183	
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0			177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION			176	
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN			175	
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN			174	
-	-	-	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	2119655-6	APPLICATOR BASIC ASSEMBLY, EF			141	
-	1	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED			140	
-	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	2119955-2	ASSY, LUBRICATOR, END FEED			84	
	-	1	1	1	455888-5	SPACER, CRIMPER			82	
	-	1	1	1	2119791-9	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	2119740-1	TAG,IDENTIFICATION			67	
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS			66	
	-	1	1	1	1-1901681-8	HOLDDOWN, TERMINAL			65	
	-	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16			64	
	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT			63	
△	-	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	2063961-1	FEED FINGER			58	
	-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8			57	
	-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			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	1-1752354-1	STANDOFF,HOLD-DOWN			50	
	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0			49	
	-	-	-	1	2119652-1	FEED CAM, PRE FEED			48	
	-	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	
	-	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	240639-3	STRIPPER (MACHINING)			27	
	-	2	2	2	1320906-1	STUD, THREADED			25	
	-	1	1	1	1-1752371-2	PLATE, STRIP GUIDE			24	
	-	1	1	1	240825-9	PLATE, STRIP HOLD DOWN			23	
	-	2	2	2	2-22281-3	SPRING, COMPRESSION			22	
	-	1	1	1	1752373-4	DRAG			20	
	-	2	2	2	1901259-3	GUIDE, LOWER STRIP			18	
	-	1	1	1	4-240641-9	SPACER			16	
△	-	1	1	1	240644-5	PLATE, REAR SHEAR			11	
	-	-	-	-	-	-			10	
△	-	1	1	1	4-690495-7	PLATE, FRONT SHEAR			9	
△	1	1	1	1	1333213-4	ANVIL, COMBINATION			8	
△	-	1	1	1	4-690474-1	BLADE, SLUG			7	
	-	-	-	-	-	-			6	
	-	1	1	1	240641-5	SPACER			5	
	-	1	1	1	1-238009-2	BLOCK, FL CRIMPER SPACER			4	
△	1	1	1	1	6-1633961-5	CRIMPER, INSULATION F PREMIUM			3	
	-	1	1	1	455888-3	SPACER, CRIMPER			2	
△	1	1	1	1	1-456402-6	CRIMPER, WIRE PREMIUM			1	
-77-27-25-22-21					PART NO		DESCRIPTION		ITEM NO	

THIS DRAWING IS A CONTROL DRAWING FOR THE END USER (ELECTRONIC) CORPORATION IT IS DESIGNED TO BE USED FOR THE CONTROL OF THE END USER'S PRODUCTION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 16 JAN 2012 YIN 16 JAN 2012 G. BAILEY 16 JAN 2012 APVD 16 JAN 2012 S. XI PRODUCT SPEC - APPLICATION SPEC -		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC $\pm$. 1 PLC $\pm$ 0.5 2 PLC $\pm$ 0.13 3 PLC $\pm$ 0.013 4 PLC $\pm$ 0.0001 ANGLES $\pm$ °		NAME Ocean End Feed Applicator -	
MATERIAL -		FINISH -		SIZE CAGE CODE DRAWING NO A 00779 C=2150072 RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 3 OF 4 REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

[illegible]

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.03 mm [.080]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .187 SERIES		RECEPTACLE FASTON	
WIRE STRIP LENGTH 4.40-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø1.02-1.78 mm [.040-.070 IN]	
TERMINAL APPLICATION SPECIFICATION 	114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
342368-1	60573-1	62181-1	
342368-2	60573-2	62187-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
20 AWG		1.22+/-0.05 [0.048+/-0.002]		4.8
22 AWG		1.09+/-0.05 [0.043+/-0.002]		6.4
24 AWG		1.02+/-0.05 [0.040+/-0.002]		7.2



- 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: 8-2150072-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150072-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150072-5
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 ITEMS 50, 62 & 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.
- ① 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.
- ② TERMINAL LUBRICATOR IS RECOMMENDED.

*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.

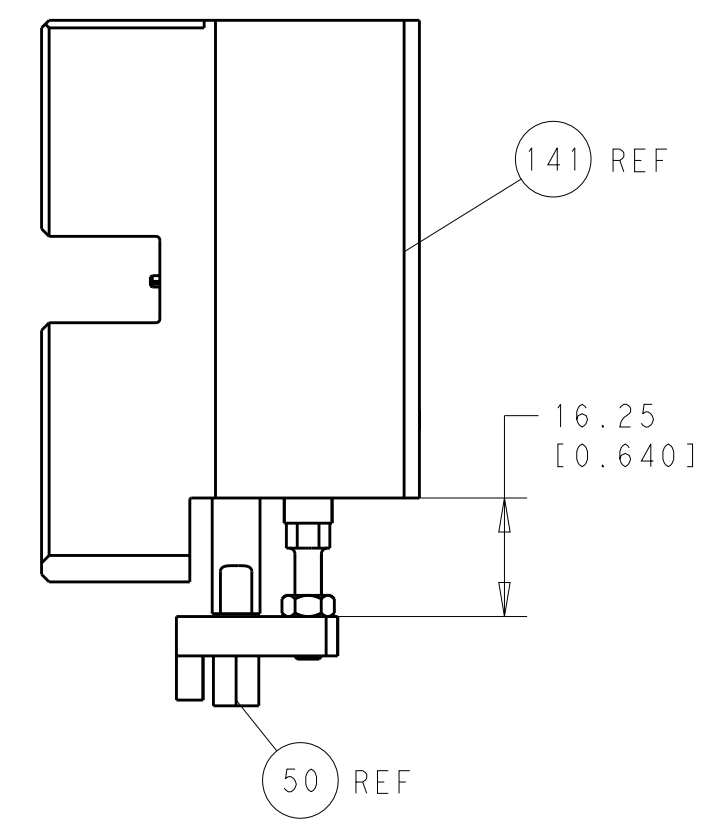
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-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)

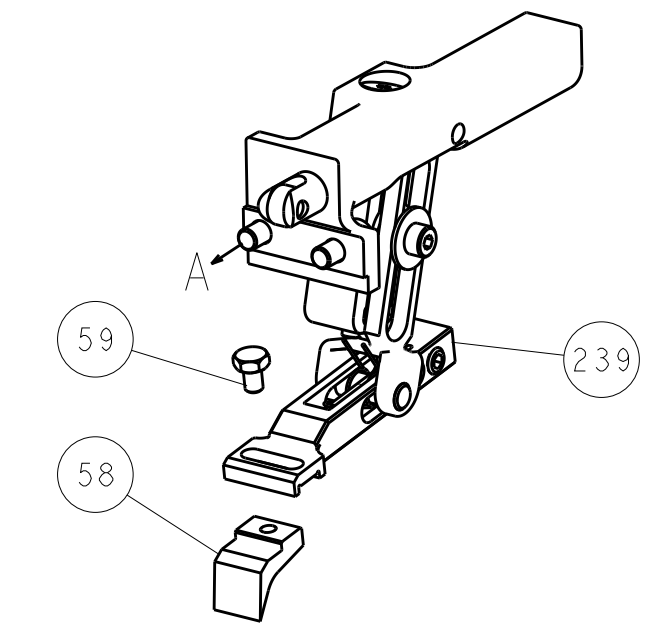
LOC		DIST		REVISONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

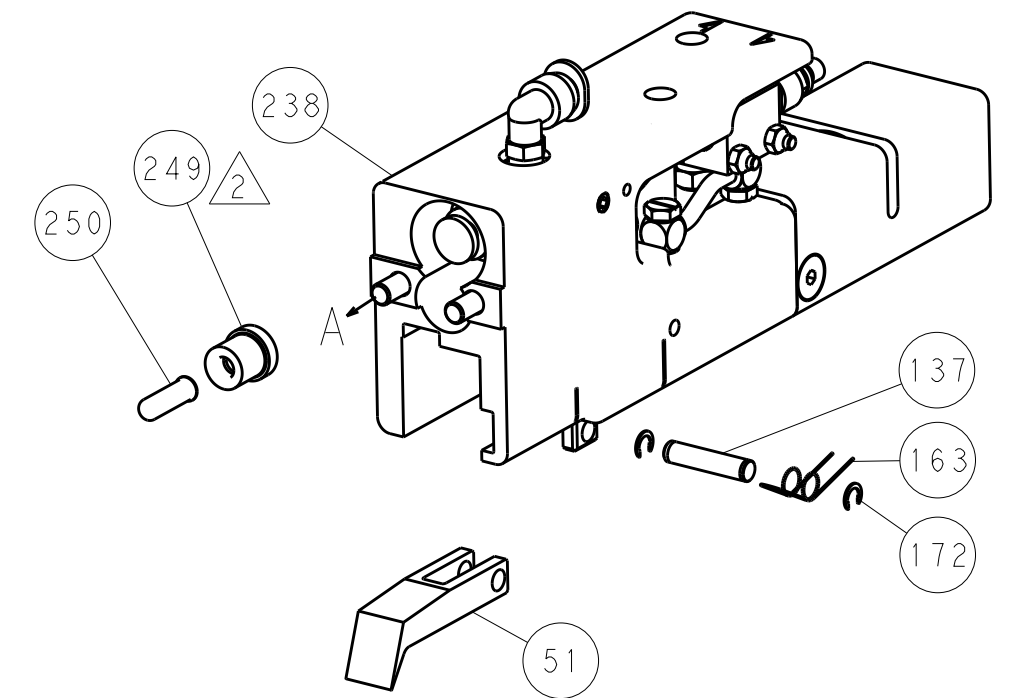
HOLDDOWN SET-UP



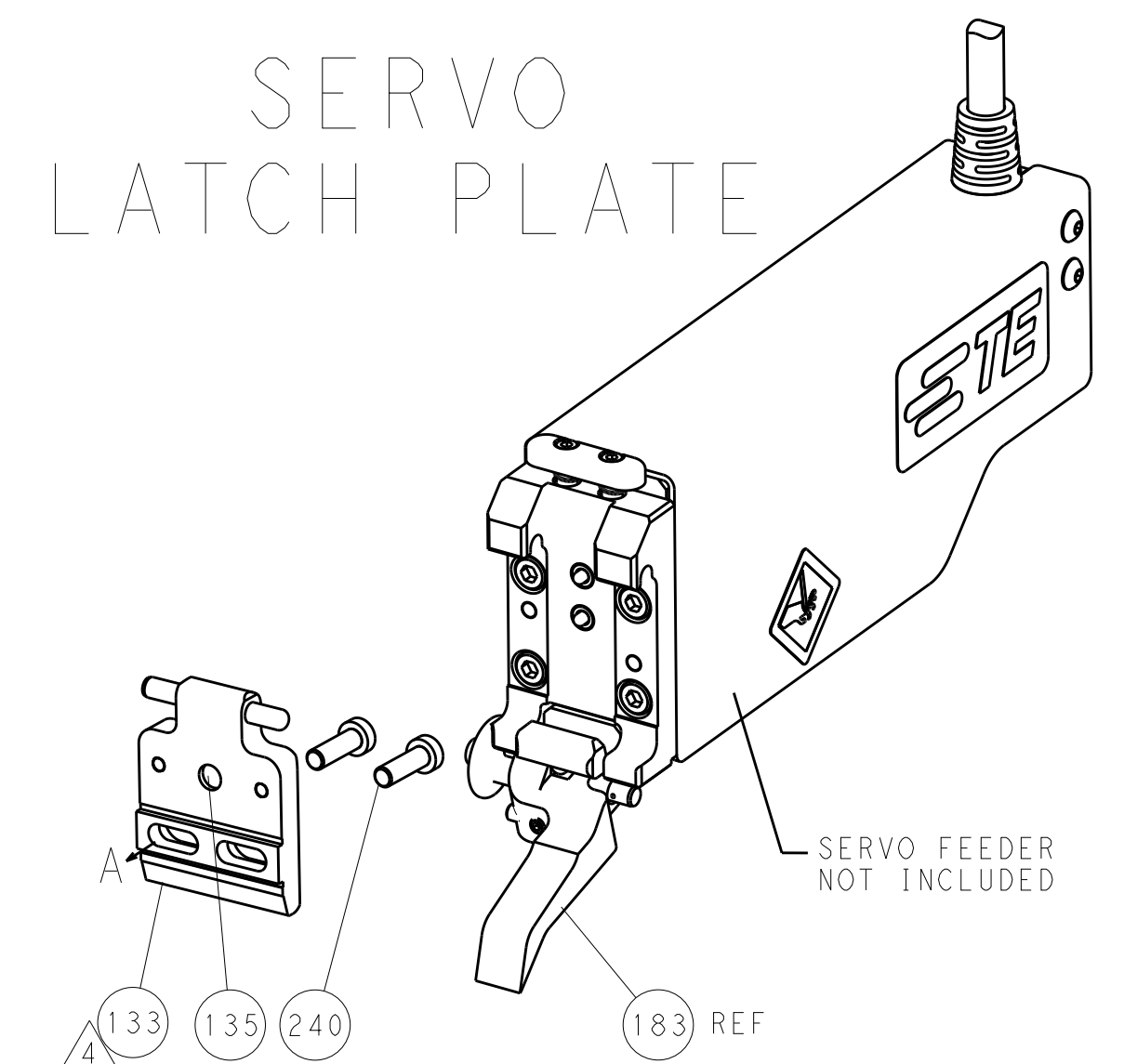
FEED TYPE
MECHANICAL



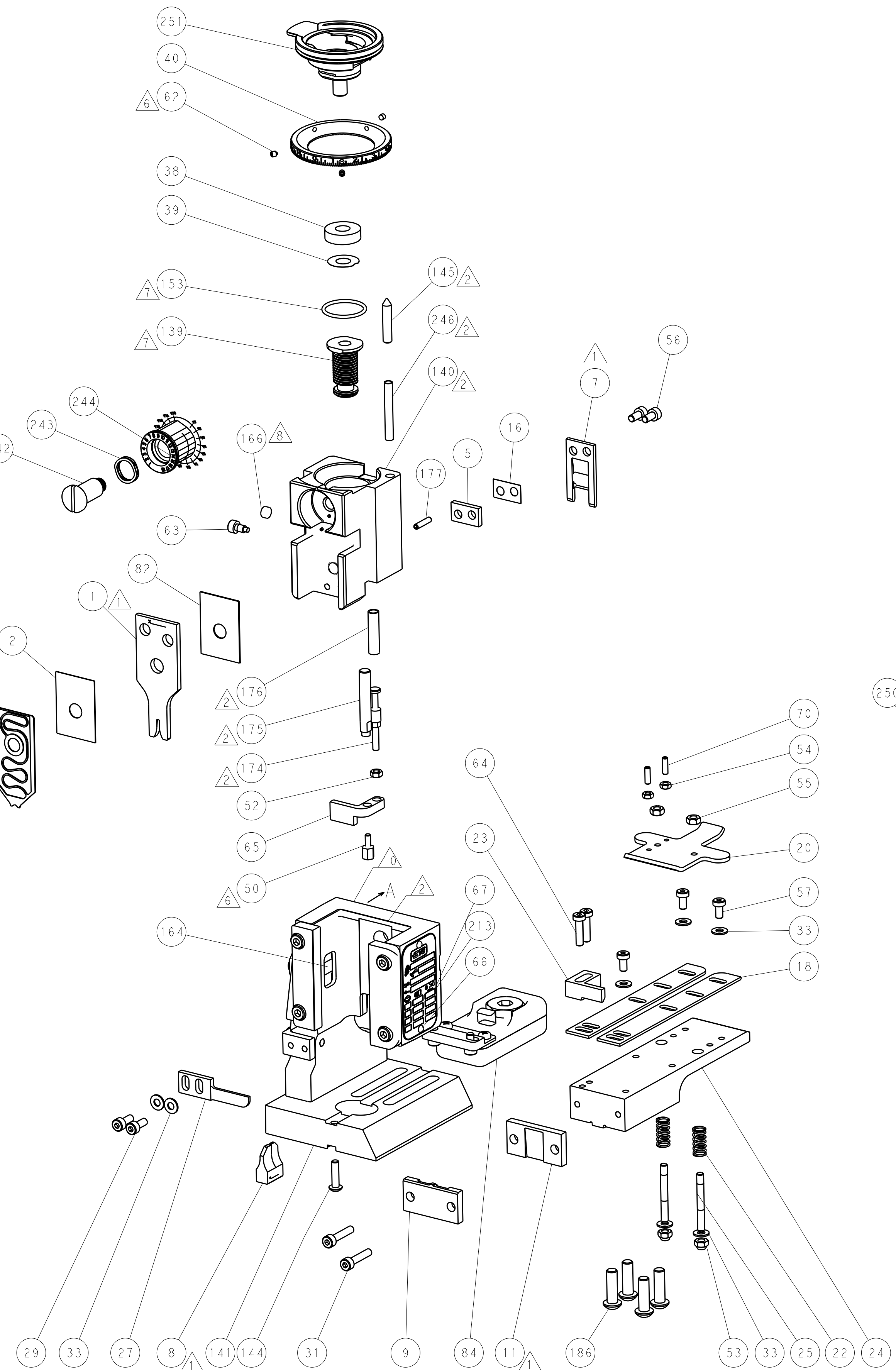
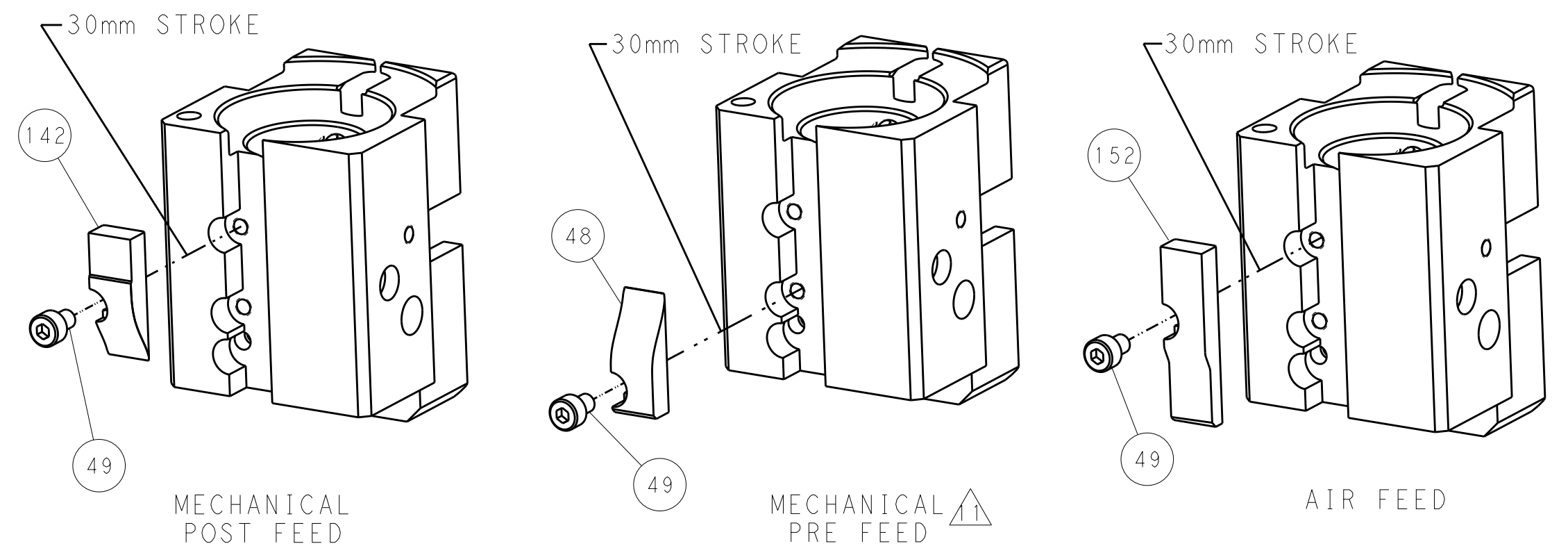
PNEUMATIC



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)

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 ±.5		FINISH	
MATERIAL		-		-	
DWN Y. YIN CHK G. BAILEY APVD S. XI		16JAN2012 16JAN2012 16JAN2012		NAME Ocean End Feed Applicator	
SIZE A		CAGE CODE 00779		DRAWING NO. C=2150072	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 4 OF 4	
				REV A	