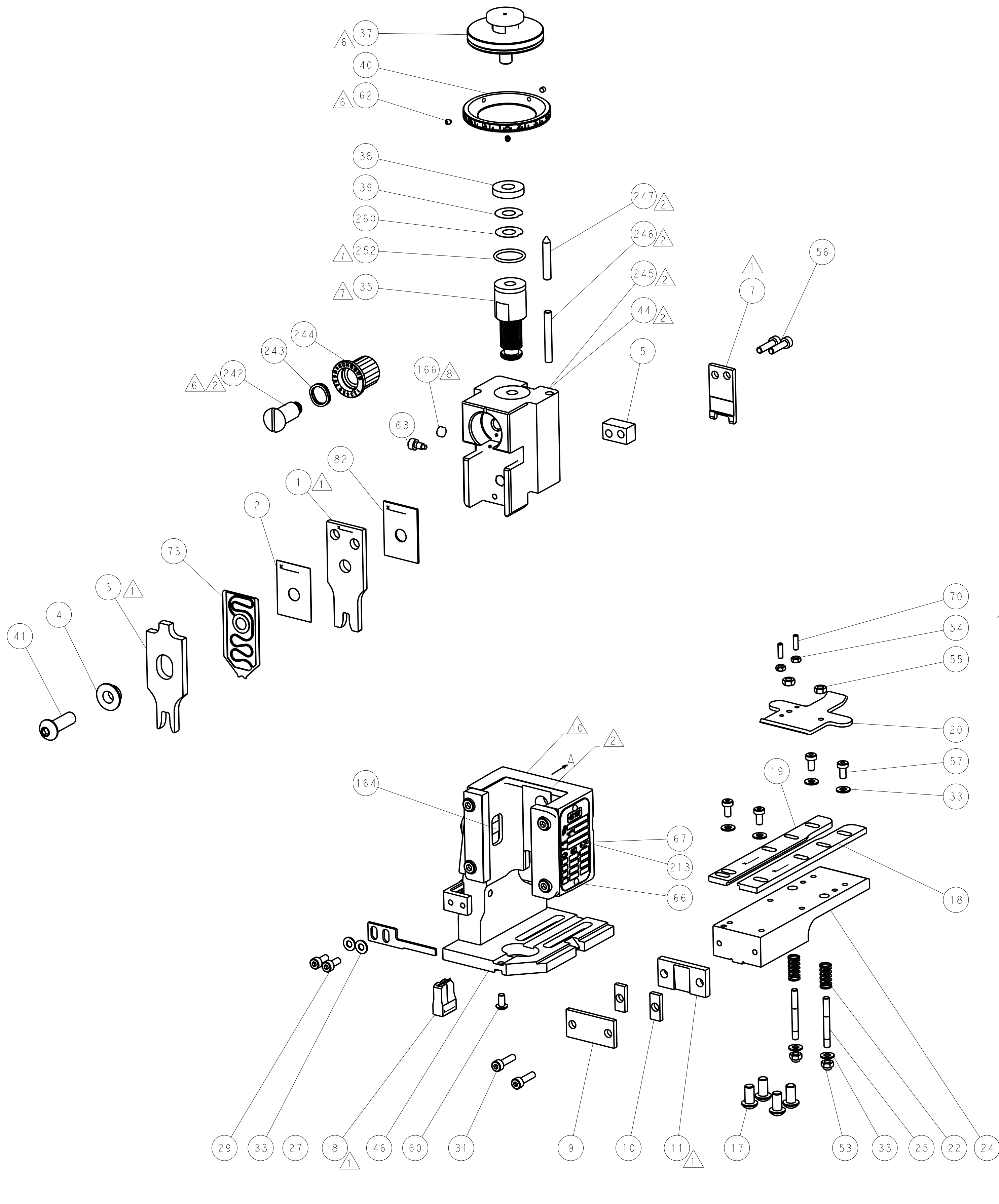


LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

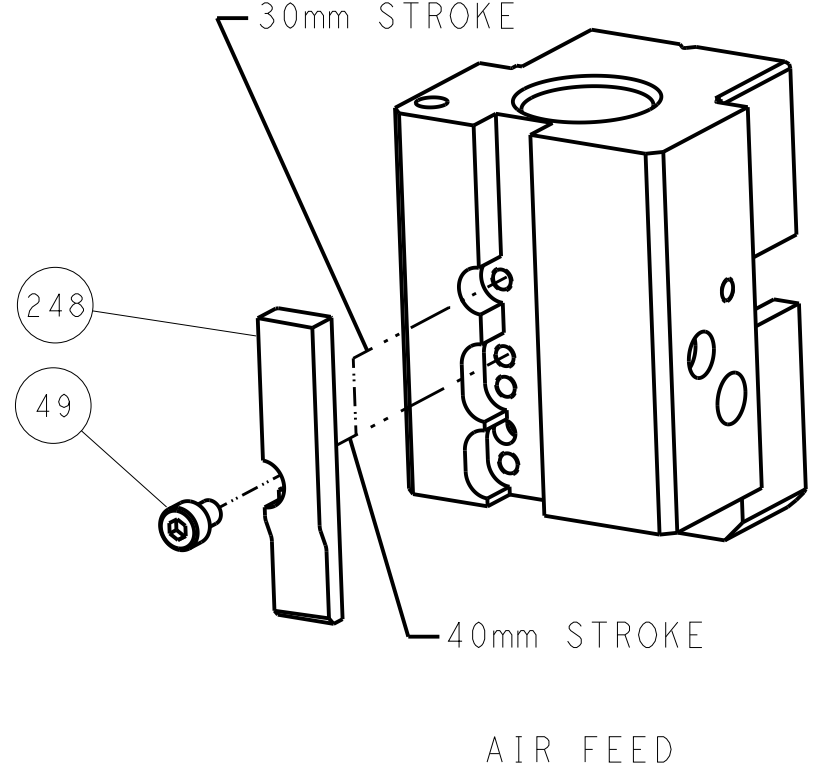


FEED TYPE

PNEUMATIC

SERVO
LATCH PLATE

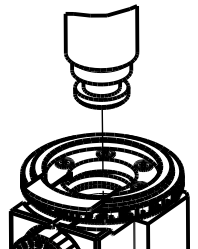
CAM POSITIONS



AIR FEED

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

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY REVISIONS TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN K. STANEM 12DEC2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 12DEC2013	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		APVD T. EIRIN 12DEC2013	SIZE A1 00779 C=2150391	
MATERIAL -		PRODUCT SPEC -	RESTRICTED TO -	
FINISH -		APPLICATION SPEC -	Customer Accessible Production Drawing	
WEIGHT -		SCALE 1:1	SHEET 2	REV B

8				6		5		4		3		
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20								
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	PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
						-	-	-	-	-	-	
		2-2150391-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150391-5	-	-	2168400-7 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2150391-4	-	-	-
		2-2150391-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-
						PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-2
		2-2150391-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150391-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

D

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	6.35 mm [.250]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION
TERMINAL NAME: RING TONGUE				
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE	
.204-.234 IN [5.18-5.94 mm]			Ø.150-.210 IN [3.81-5.33 mm]	
TERMINAL APPLICATION SPECIFICATION		114-2084	-	-
		-	-	-
TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	
160134-1	160134-2	160134-3		
160134-5	160163-1	160163-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
5.00mm2		3.14+/-0.05 [.124+/- .002]		5.4
4.00mm2		2.97+/-0.05 [.117+/- .002]		7.2
3.50mm2		2.88+/-0.05 [.114+/- .002]		8.1



- 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: 8-2150391-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150391-5
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 62.
- 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.
- REFER TO APPLICATION SPECIFICATION 114-3118 FOR TENSILE VALUES.

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*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.

SET UP GAUGE 2119599-2	LOC	DIST	REVISIONS						
	A	66	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
-	-	-	1	2063440-2	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
-	-	-	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
-	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	455888-9	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, 2 x .188	66
-	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	2119792-2	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	2119644-4	RAM WASHER, PRECISION	38
-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	690455-2	STRIPPER, FRONT CASTING	27
-	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1752371-2	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1752373-4	DRAG	20
-	1	1	1	1901696-6	STRIP GUIDE, REAR	19
-	1	1	1	1901695-6	STRIP GUIDE, FRONT	18
-	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	1-240645-4	SPACER, SHEAR PLATE	10
-	1	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	1	1333223-1	ANVIL, COMBINATION	8
-	1	1	1	9-240651-1	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	5-240641-7	SPACER	5
-	1	1	1	238009-5	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	6-2119582-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-2	SPACER, CRIMPER	2
1	1	1	1	2-456412-4	CRIMPER, WIRE .180 F PREMIUM	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

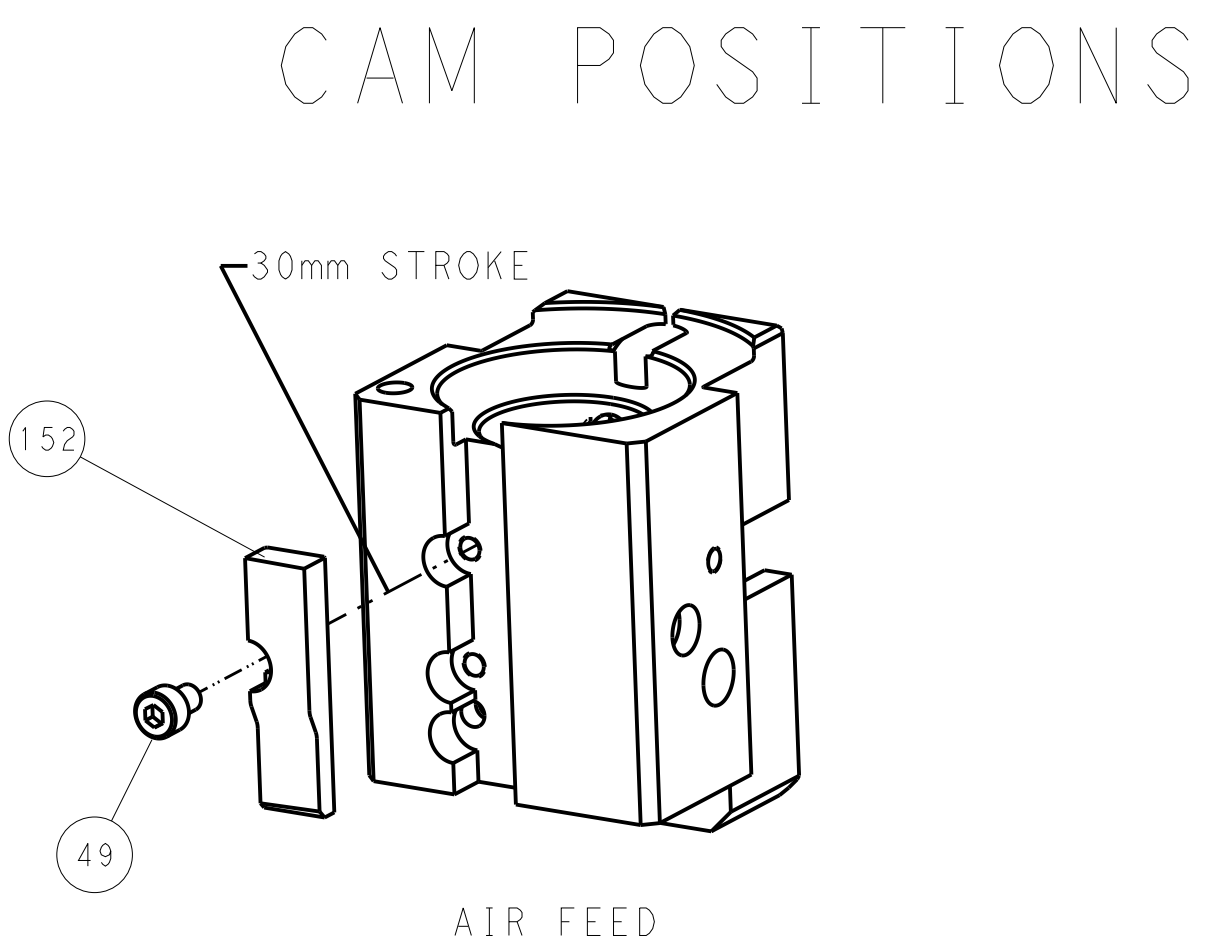
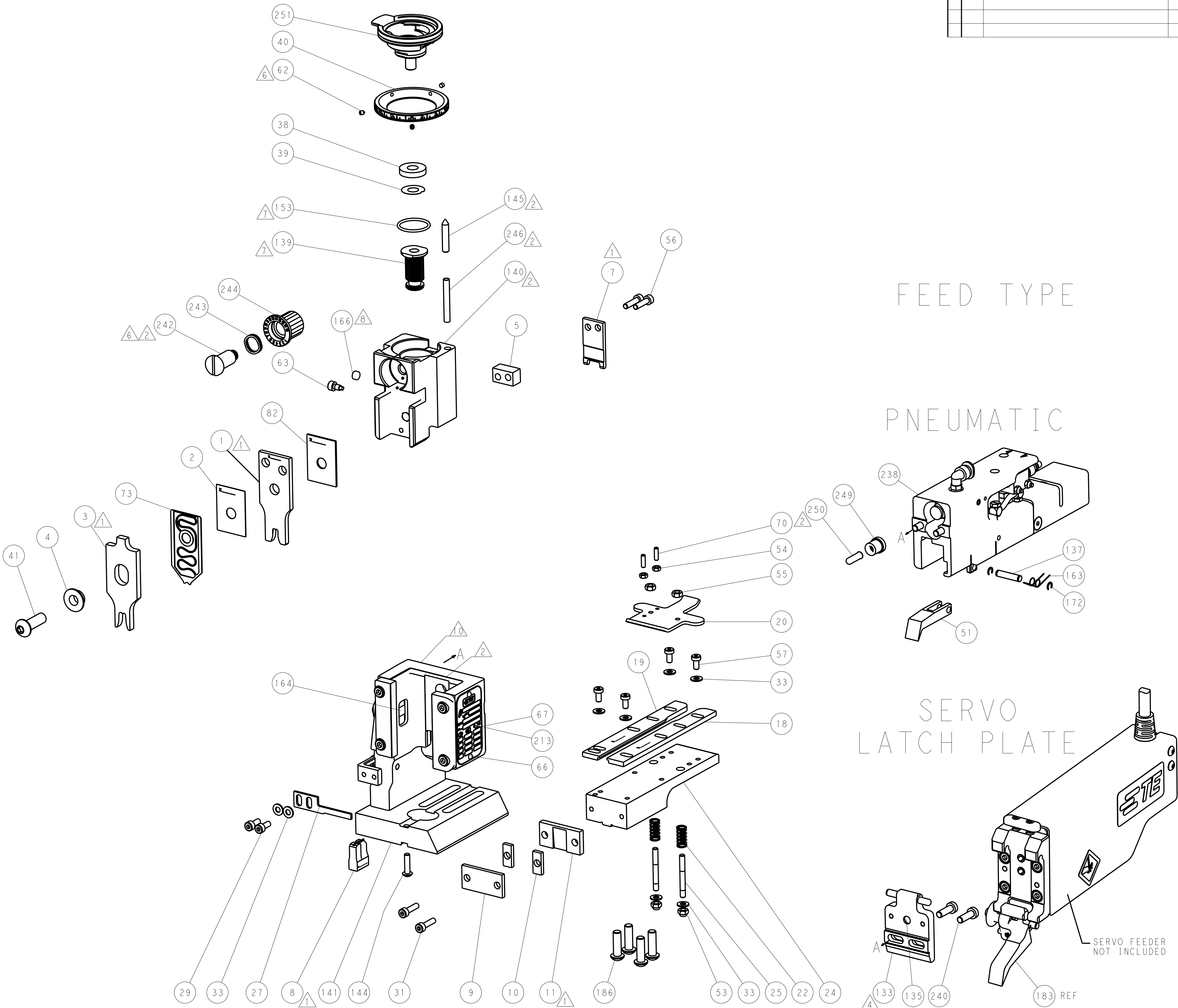
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		PRODUCT SPEC -		NAME Ocean End Feed Applicator -			
		APPLICATION SPEC -		SIZE A1		CAGE CODE 00779		DRAWING NO ©=2150391	
MATERIAL -		FINISH -		WEIGHT -		RESTRICTED TO -		-	
Customer Accessible Production Drawing						SCALE 1:1		SHEET 3 OF 4	
								REV B	

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

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



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		CHK		APVD		NAME	
mm		0 PLC ±.5		R. STANEM		G. BAILEY		T. EIRIN		TE Connectivity	
1 PLC ±0.13		2 PLC ±0.13		12DEC2013		12DEC2013		12DEC2013		Harrisburg, PA 17105-3608	
3 PLC ±0.13		4 PLC ±0.001		PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		A1 00779		DRAWING NO	
								C=2150391		RESTRICTED TO	
								SCALE		SHEET	
								1:1		4 OF 4	
										REV	
										B	