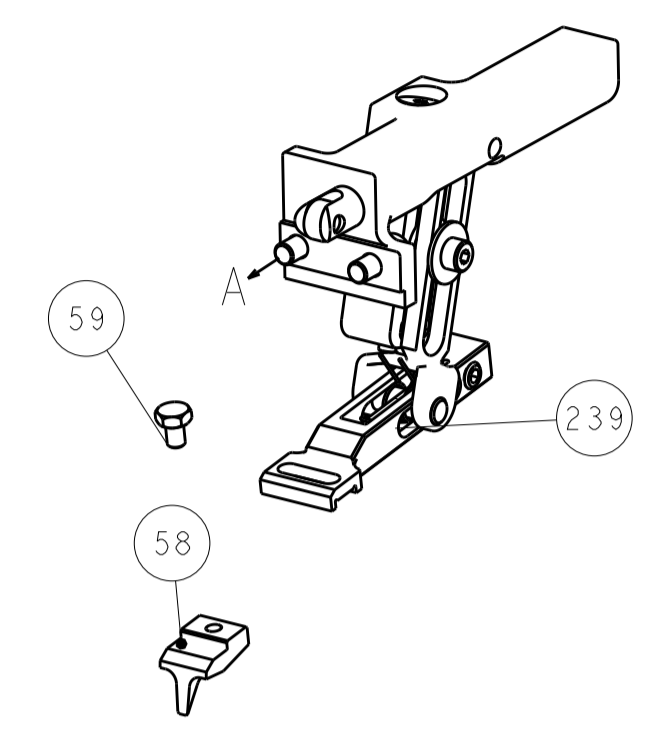
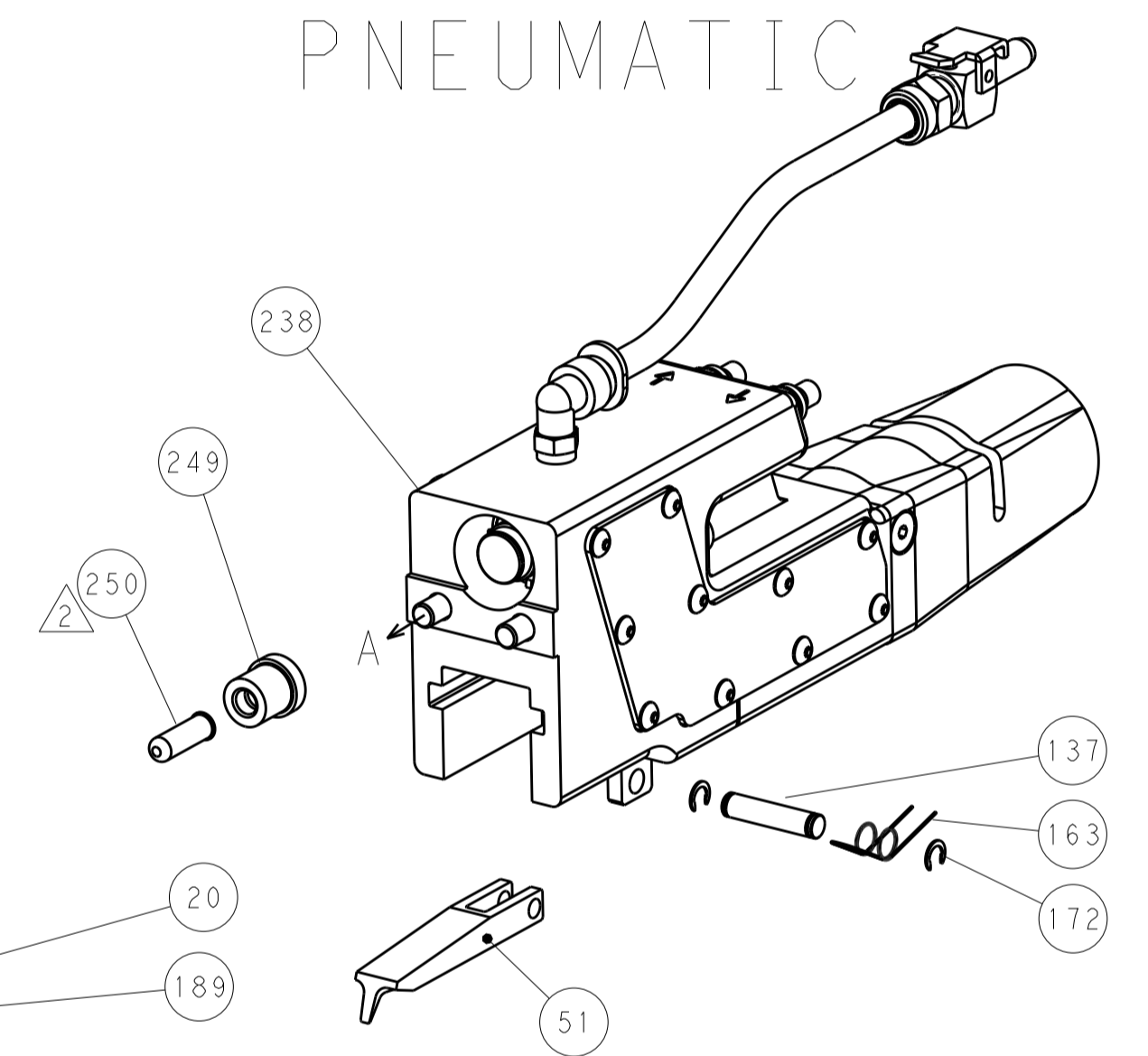


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A	66				

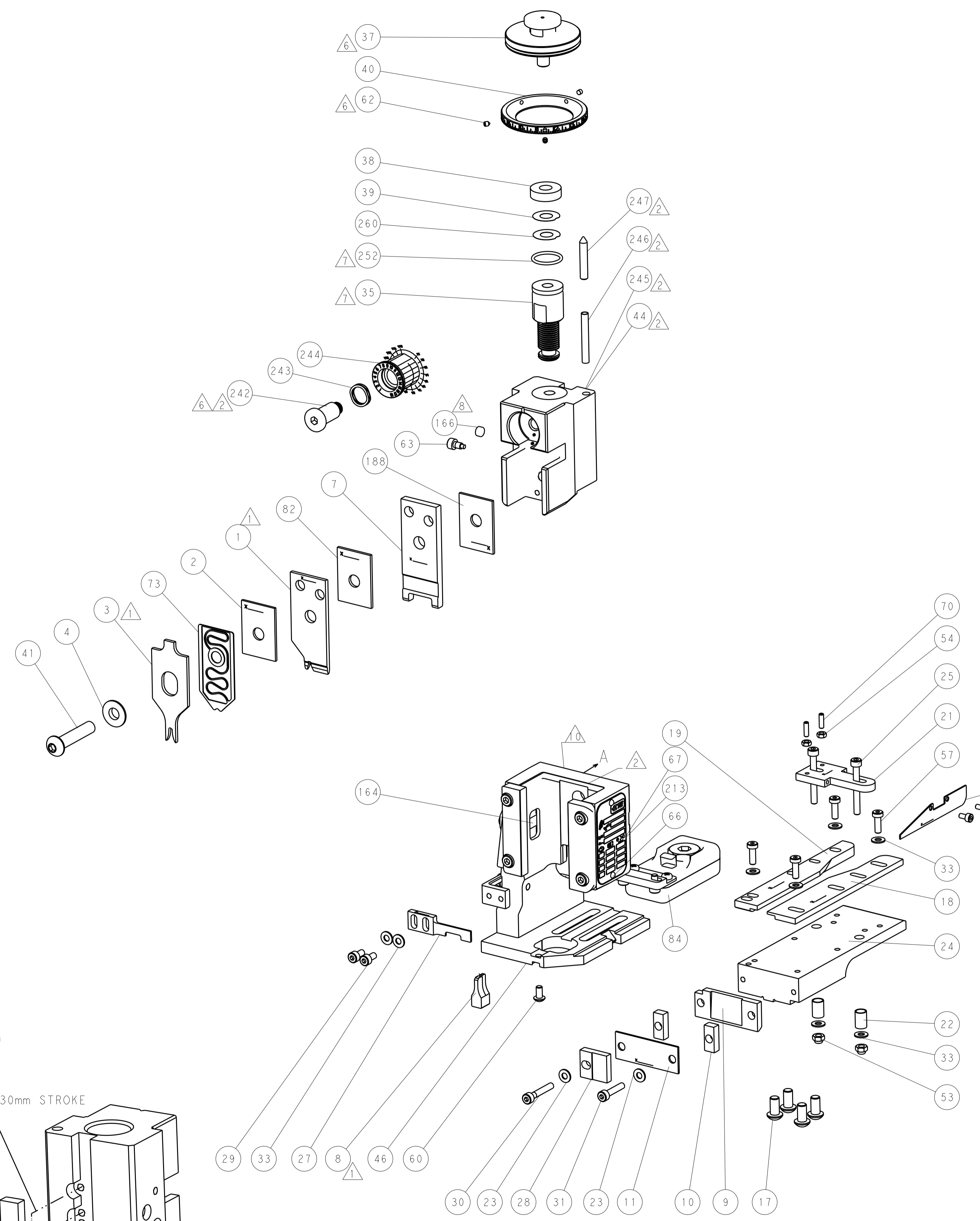
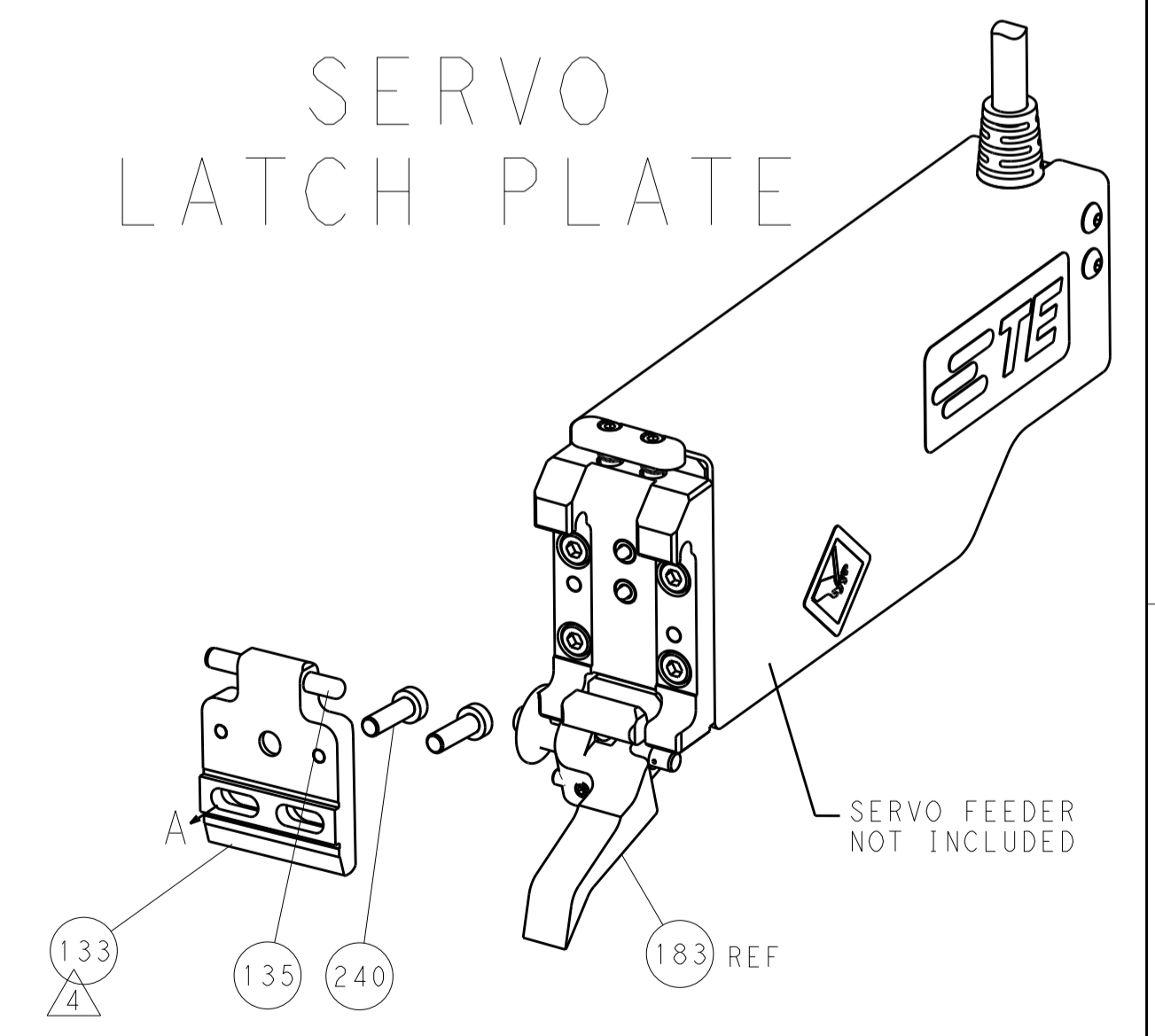
FEED TYPE MECHANICAL



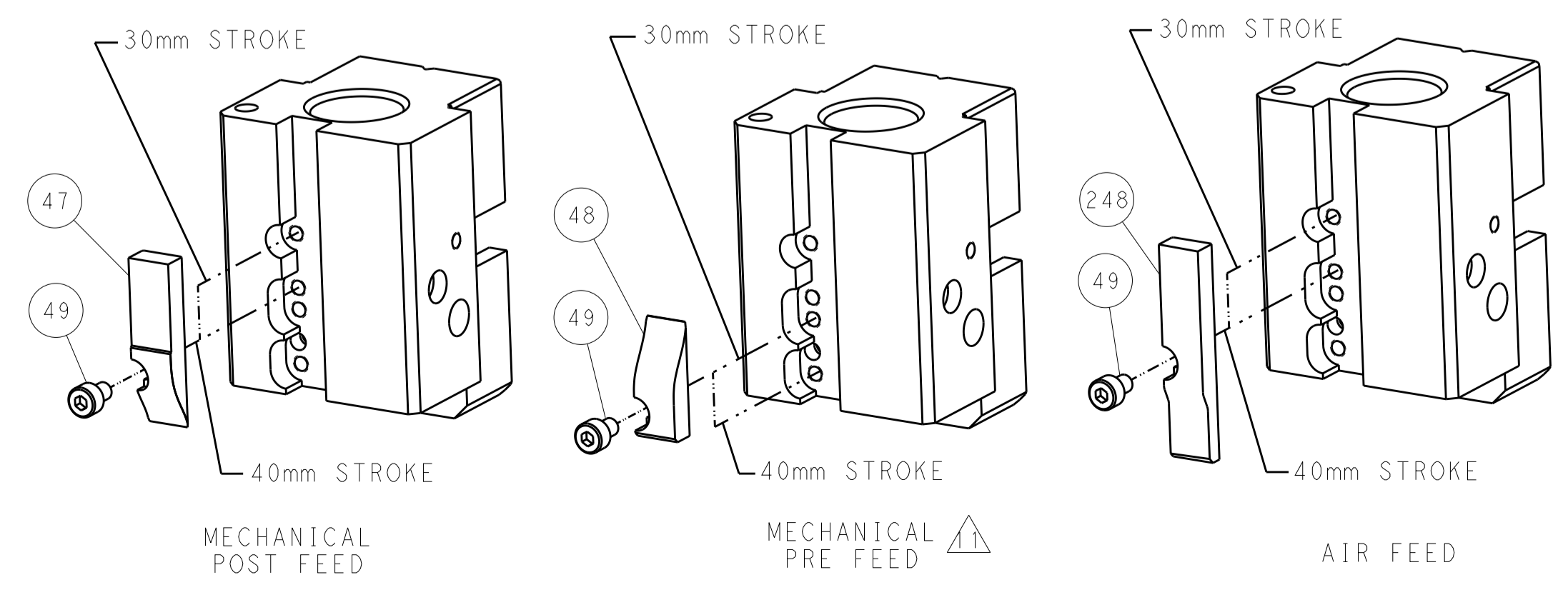
PNEUMATIC



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 ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.0001		DWN J. HOU 18JUNE 2014 CHK L. ZHANG 18JUNE 2014 APVD H. GUO 18JUNE 2014		NAME Ocean End Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: A11 00779 C=2150447	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 2 OF 4 REV B	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150447-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-3	8-2150447-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150447-4	-	-	-
	2-2150447-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-3	8-2150447-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150447-4	-	-	-
	2-2150447-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
	2-2150447-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150447-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm (.070)	F
INSUL	2.79 mm (.110)	OV
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON FLAG .187 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.39-5.16 mm (.173-.203 IN)		1.52-2.79 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 +/- .002]	5.4
20 AWG	1.14 +/- 0.05 [0.045 +/- .002]	6.7
22 AWG	1.06 +/- 0.05 [0.042 +/- .002]	7.6

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150447-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150447-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150447-5
- 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.
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.

***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.

	ITEM NO	DESCRIPTION	ITEM NO
- 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
-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)

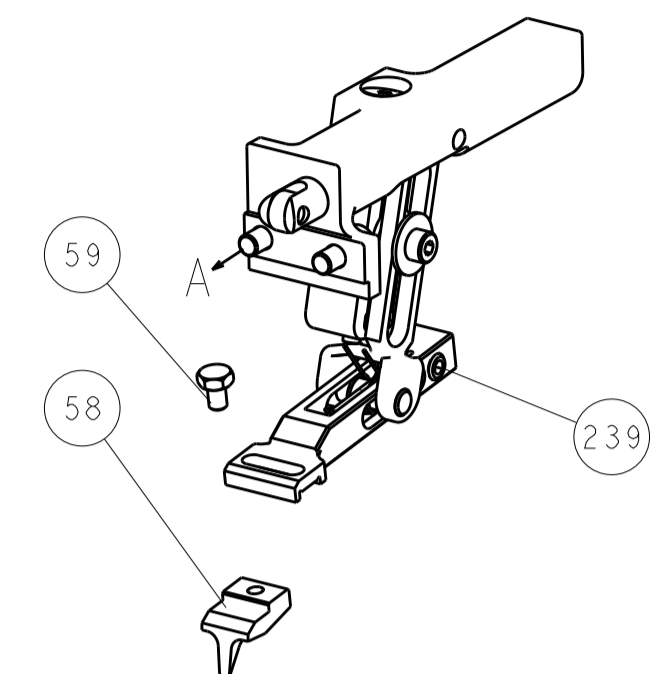
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPD
			-	SEE SHEET 1	-	-

- 1 1 1 1	1-22279-3	SPRING, COMPRESSION	246
- 1 1 1 1	2119082-4	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
- REFREFREFREF	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	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 1	2119955-2	ASSY, LUBRICATOR, END FEED	84
- 1 1 1 1	1-455888-6	SPACER, CRIMPER	82
- 1 1 1 1	2119791-9	DEPRESSOR, WIRE	73
- 1 1 1 1	2119956-2	DOCUMENTATION PACKAGE	71
- 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	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
- 1 1 1 1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
- 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	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	41
- 1 1 1 1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
- 1 1 1 1	2119957-1	APPLICATOR SHIM PACK	39
- 1 1 1 1	2119644-1	RAM WASHER, PRECISION	38
- 8 8 8 8	1-18028-2	WASHER, FLAT, REG M4	33
- 1 1 1 1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
- 1 1 1 1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	30
- 2 2 2 2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
- 1 1 1 1	469633-1	BLOCK, SUPPORT	28
- 1 1 1 1	468281-8	STRIPPER	27
- 2 2 2 2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
- 1 1 1 1	2161922-4	PLATE, STRIP GUIDE	24
- 2 2 2 2	1-18028-2	WASHER, FLAT, REG M4	23
- 2 2 2 2	22281-6	SPRING, COMPRESSION	22
- 1 1 1 1	1633168-2	ARM, STOCK DRAG	21
- 1 1 1 1	464452-4	DRAG, STOCK	20
- 1 1 1 1	5-1901696-7	STRIP GUIDE, REAR	19
- 1 1 1 1	3-1901695-1	STRIP GUIDE, FRONT	18
- 4 4 4 4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
- 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	461160-1	PLATE, REAR SHEAR	9
- 1 1 1 1	5-1803000-1	ANVIL, COMBINATION, END FEED	8
- 1 1 1 1	2161927-1	BLADE, SLUG	7
- - - - -	-	-	6
- - - - -	-	-	5
- 1 1 1 1	238009-8	BLOCK, FL CRIMPER SPACER	4
- 1 1 1 1	1-2119785-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
- 1 1 1 1	1-455888-4	SPACER, CRIMPER	2
- 1 1 1 1	1803006-6	CRIMPER, WIRE	1
-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO

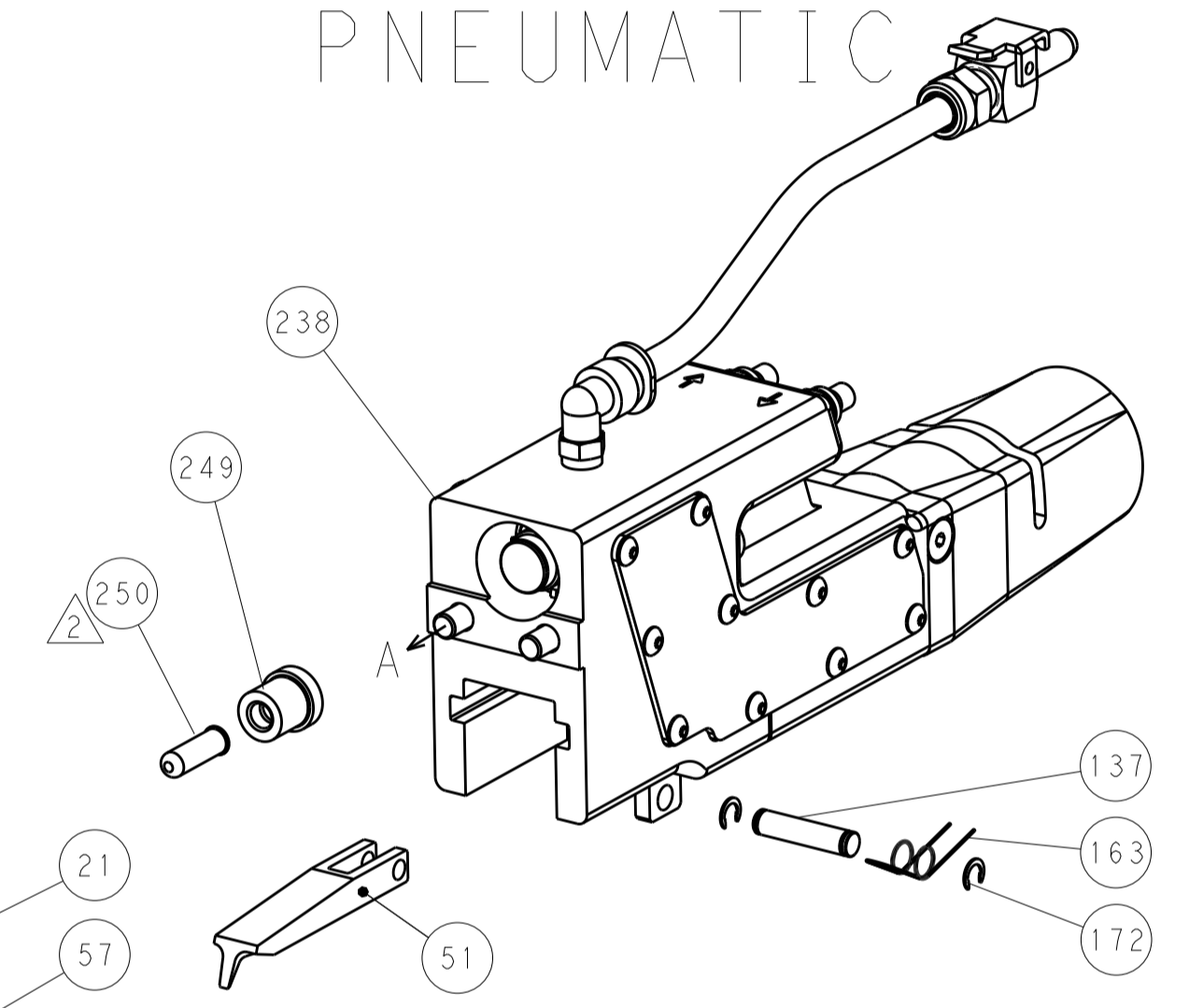
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APPD		NAME	
mm	0 PLC ±.5	1 PLC ±.3	2 PLC ±.2	3 PLC ±.1	4 PLC ±.05	ANGLES ±.0001	FINISH	J. HOU	18 JUNE 2014	L. ZHANG	18 JUNE 2014
MATERIAL:								U. GUO 18 JUNE 2014			
PRODUCT SPEC				APPLICATION SPEC				Customer Accessible Production Drawing			
WEIGHT				SCALE				SHEET 3 OF 4			

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
				SEE SHEET 1			

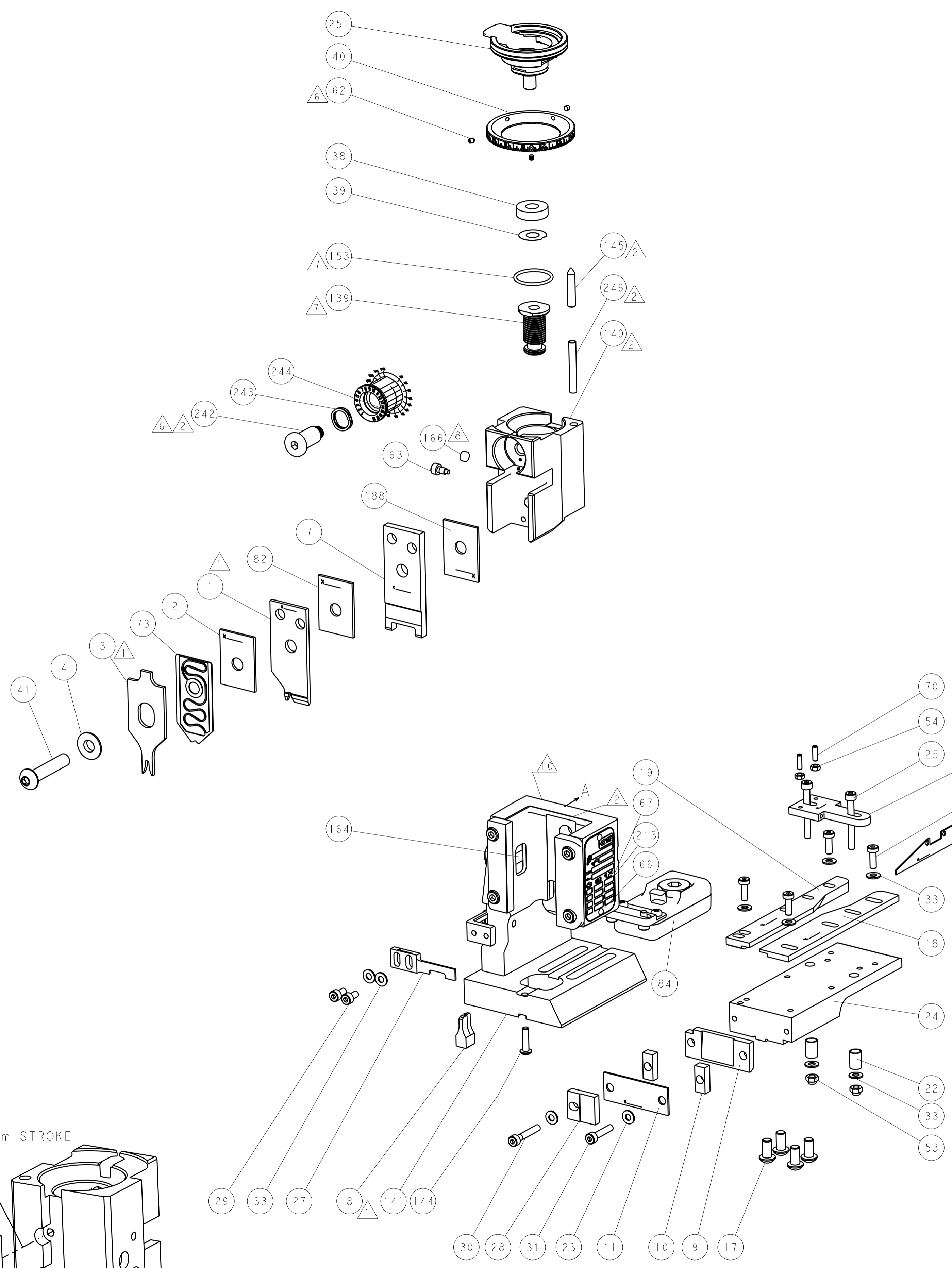
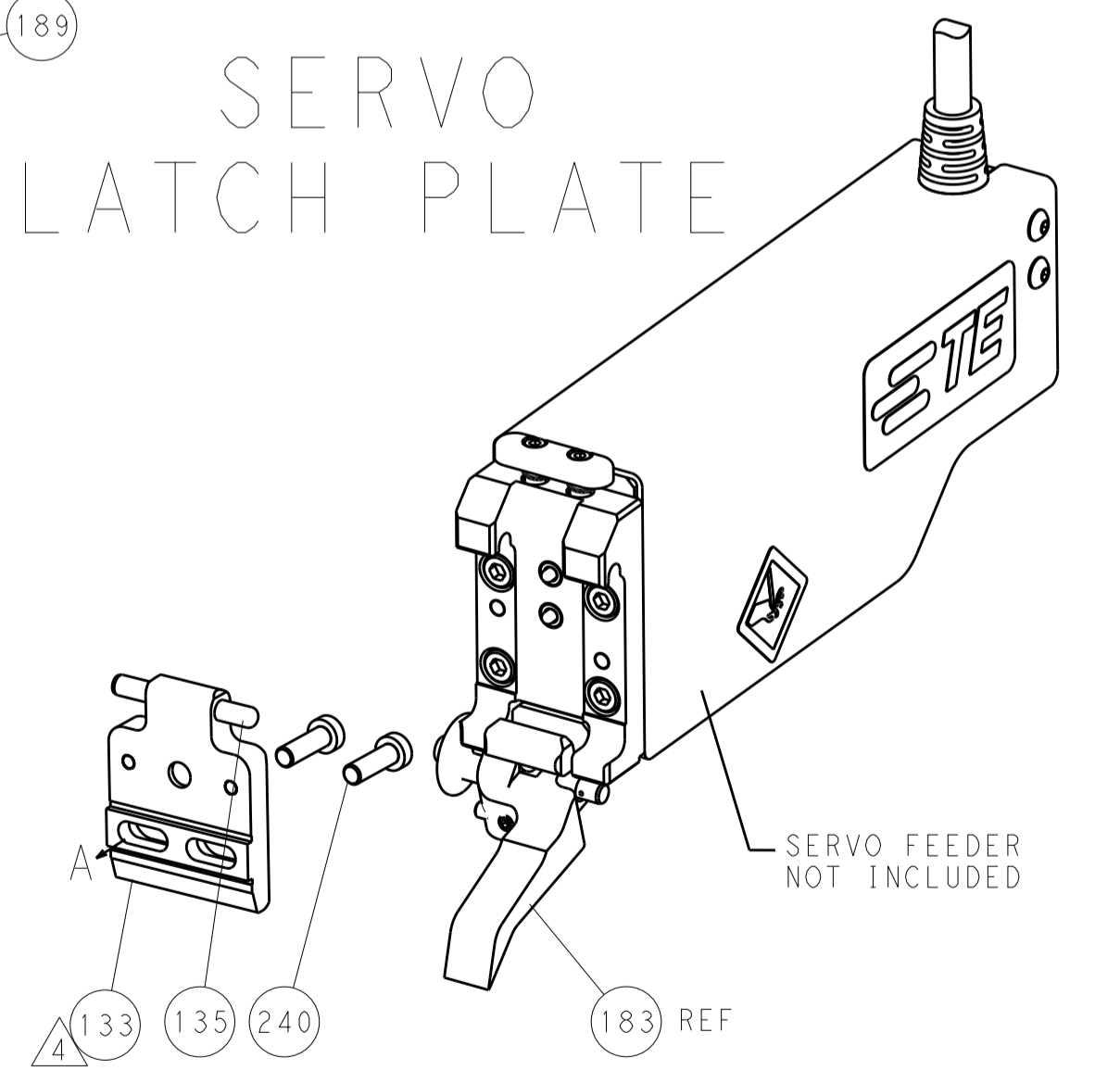
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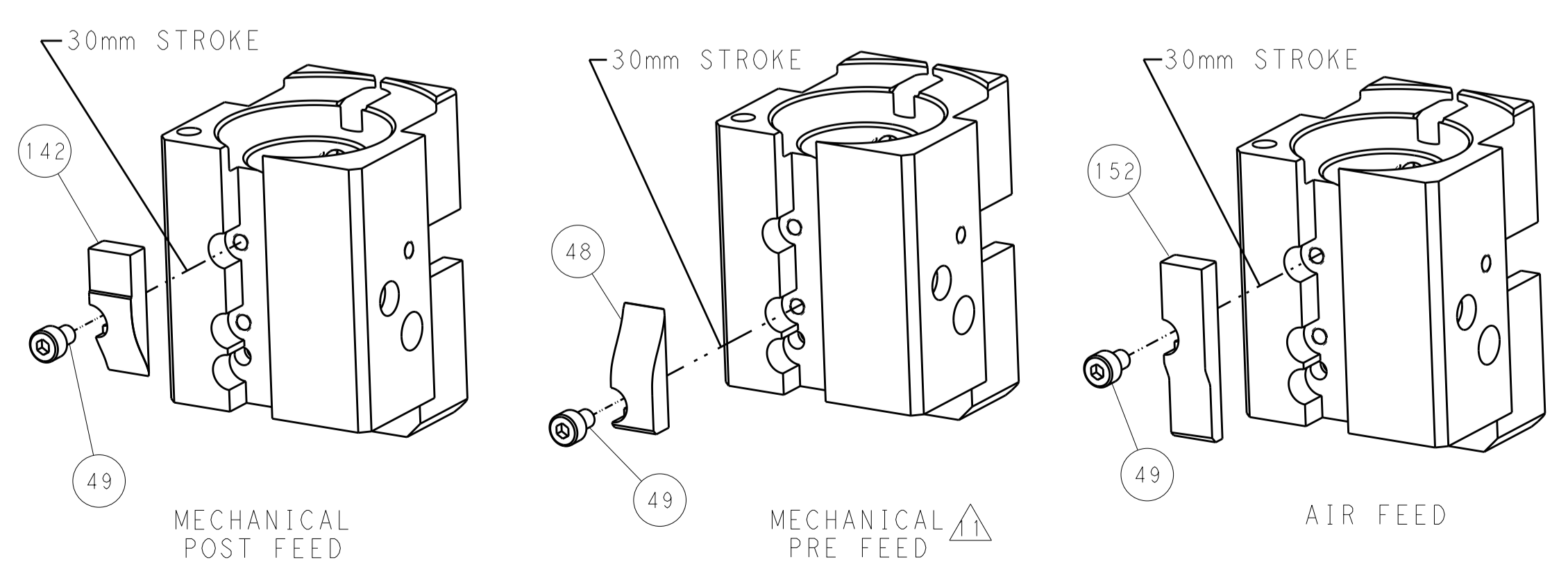
PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: J. HOU 18JUNE2014		STE TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	CHK: L. ZHANG 18JUNE2014	NAME: Ocean End Feed Applicator	
	4 PLC ±0.013	5 PLC ±0.001	6 PLC ±0.001	7 PLC ±0.001	APVD: H. GUO 18JUNE2014	PRODUCT SPEC	
MATERIAL:	FINISH:			APPLICATION SPEC		RESTRICTED TO	
				WEIGHT:		SIZE: CAGE CODE: DRAWING NO: A11 00779 ©=2150447	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 4 OF 4 REV B	