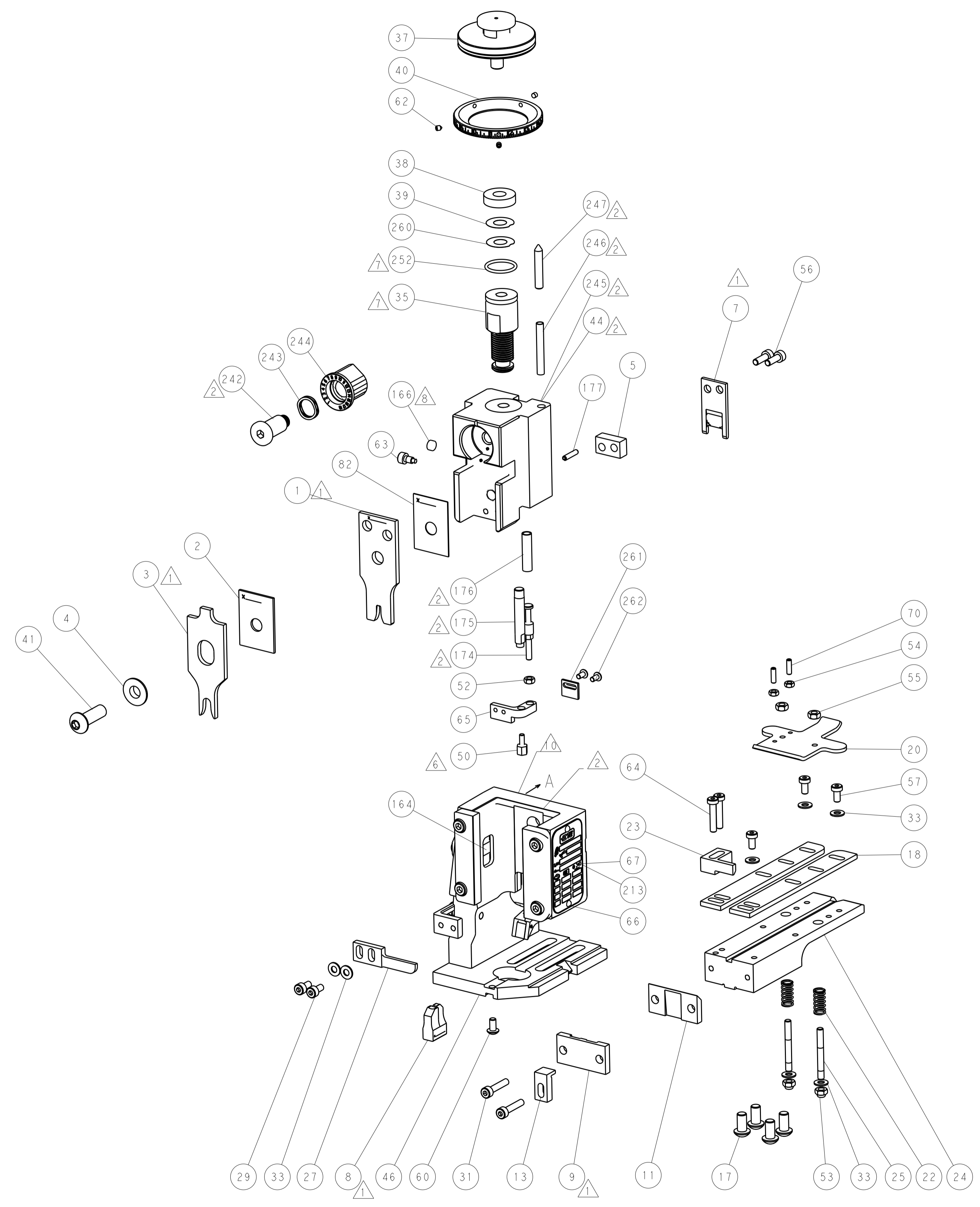
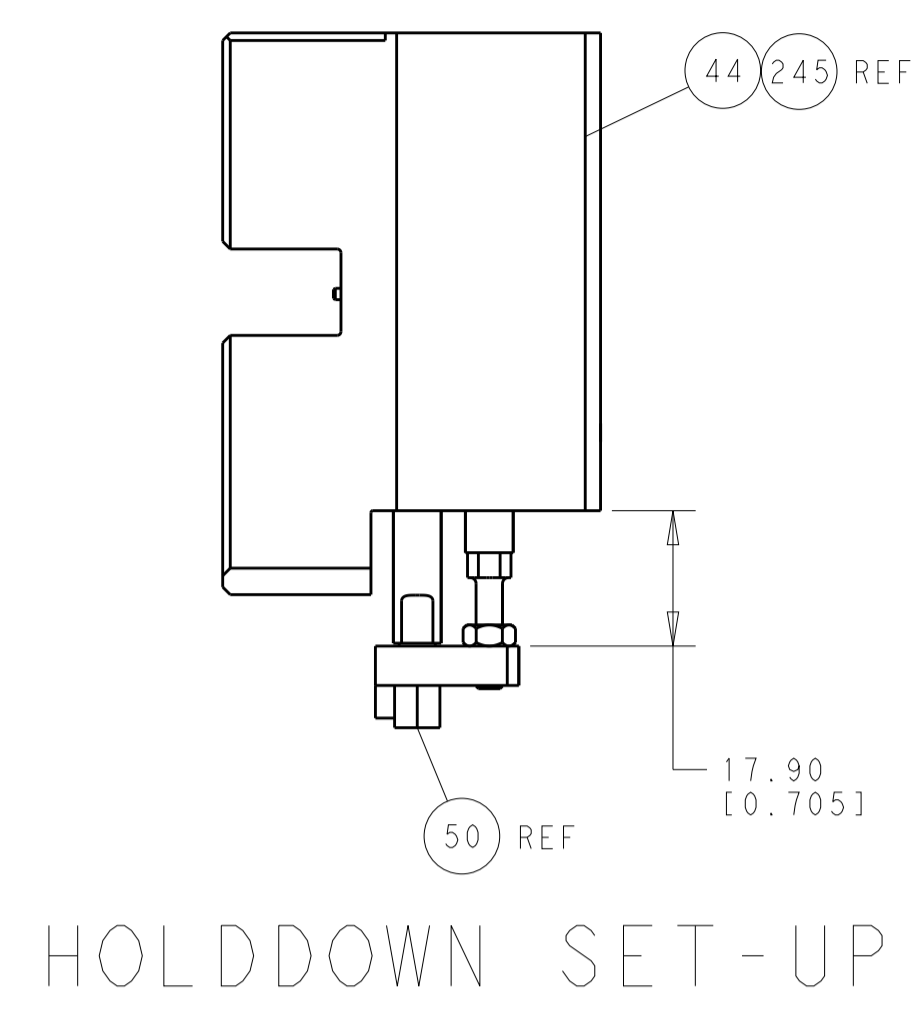


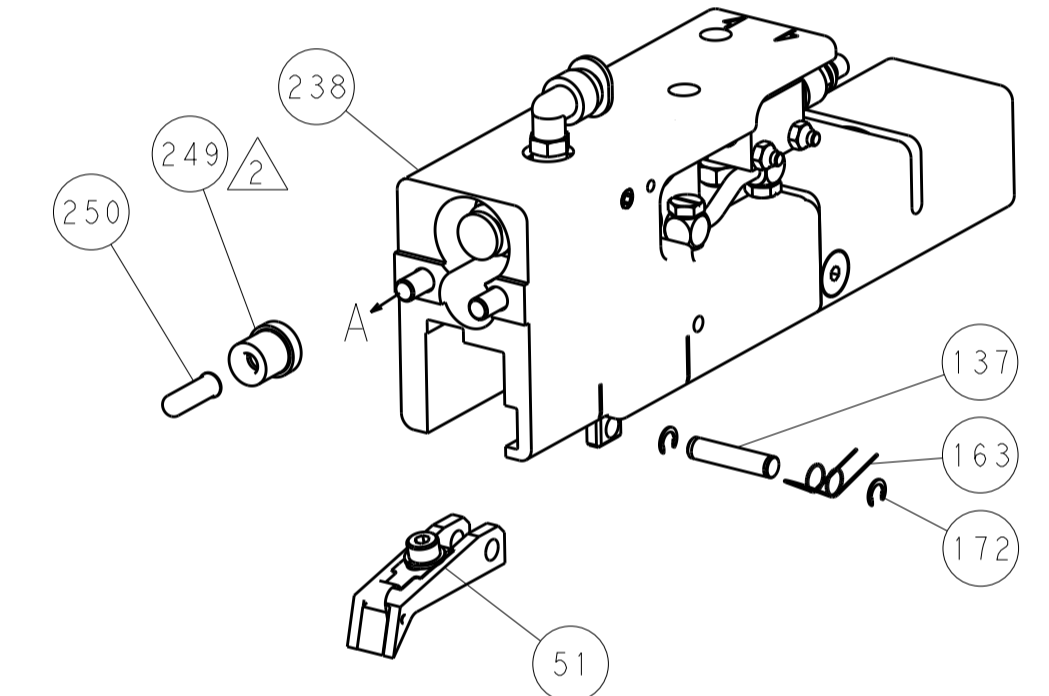
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS			
NO.	DESCRIPTION	DATE	BY
1	SEE SHEET 1		

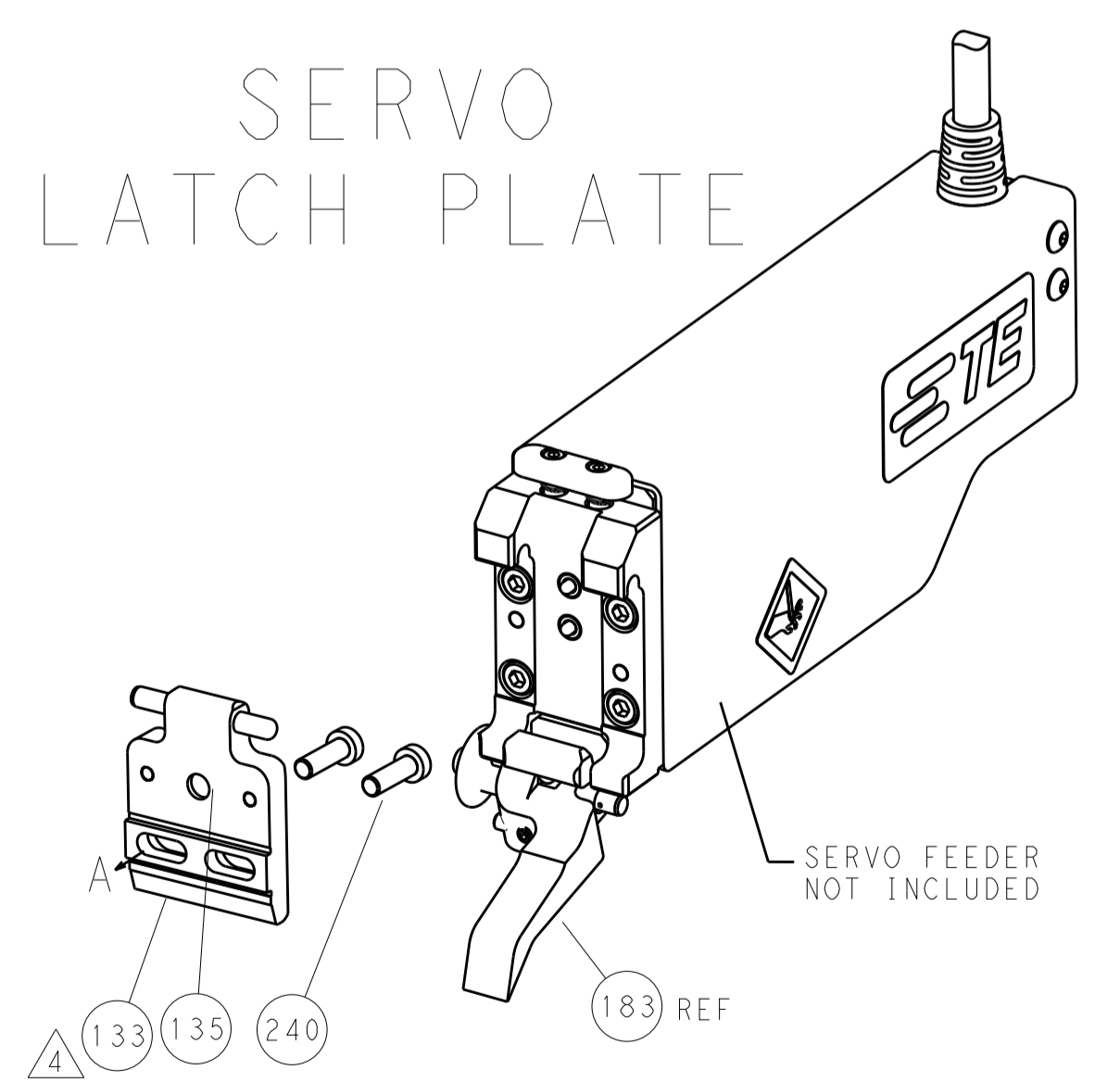


FEED TYPE

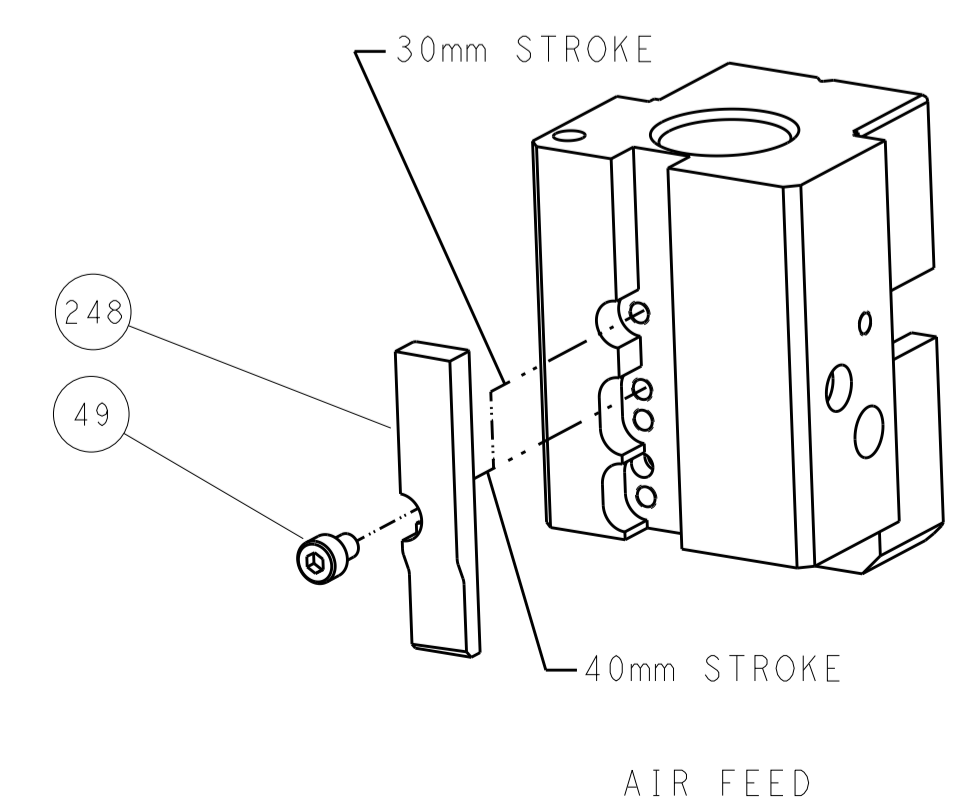
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2012. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS TO BE USED FOR THE EXCLUSIVE USE OF THE CUSTOMER. IT IS THE CUSTOMER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISIONS.</small>		DWN: L.C. CHEN 14MAY2012 CHK: S.XI 14MAY2012 APVD: J. CRUZ 14MAY2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150054	RESTRICTED TO: SCALE: 1:1 SHEET: 2 OF 4 REV: B
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150054-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	2063961-1	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1803052-1	8-2150054-5	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150054-4	-	-
	2-2150054-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE Δ	-	2063961-1	-	-	-	-
2-2150054-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150054-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	5.90 mm [.232]	O
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .187 SERIES POSITIVE LOCK RECEPTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.50 mm [.177-.217 IN]		\varnothing 2.10-3.60 mm [.083-.142 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5041	-	-
TERMINALS APPLIED Δ			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170326-1	170326-5		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .187 SERIES POSITIVE LOCK RECEPTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.50 mm [.177-.217 IN]		\varnothing 2.10-3.60 mm [.083-.142 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5041	-	-
TERMINALS APPLIED Δ			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1318306-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING Δ
1.72-2.08mm ²	1.57+/-0.05 [.062+/- .002]	7.0
1.12-1.68mm ²	1.40+/-0.05 [.055+/- .002]	8.7
0.70-1.02mm ²	1.24+/-0.05 [.049+/- .002]	10.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING Δ
2.36-2.55mm ²	1.64+/-0.05 [.065+/- .002]	6.3
1.72-2.08mm ²	1.57+/-0.05 [.062+/- .002]	7.0
1.12-1.68mm ²	1.40+/-0.05 [.055+/- .002]	8.7
0.70-1.02mm ²	1.24+/-0.05 [.049+/- .002]	10.5

***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.

- 2 2 2	1655785-9	SCR, BTN SKT HD CAP (M3 X 6)	262
- 1 1 1	1976053-6	LOCATER BLOCK, TERMINAL	261
- 1 1 1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- - - 1	2119640-1	PUSH ROD, AIR FEED	250
-77-27-25-22	PART NO	DESCRIPTION	ITEM NO

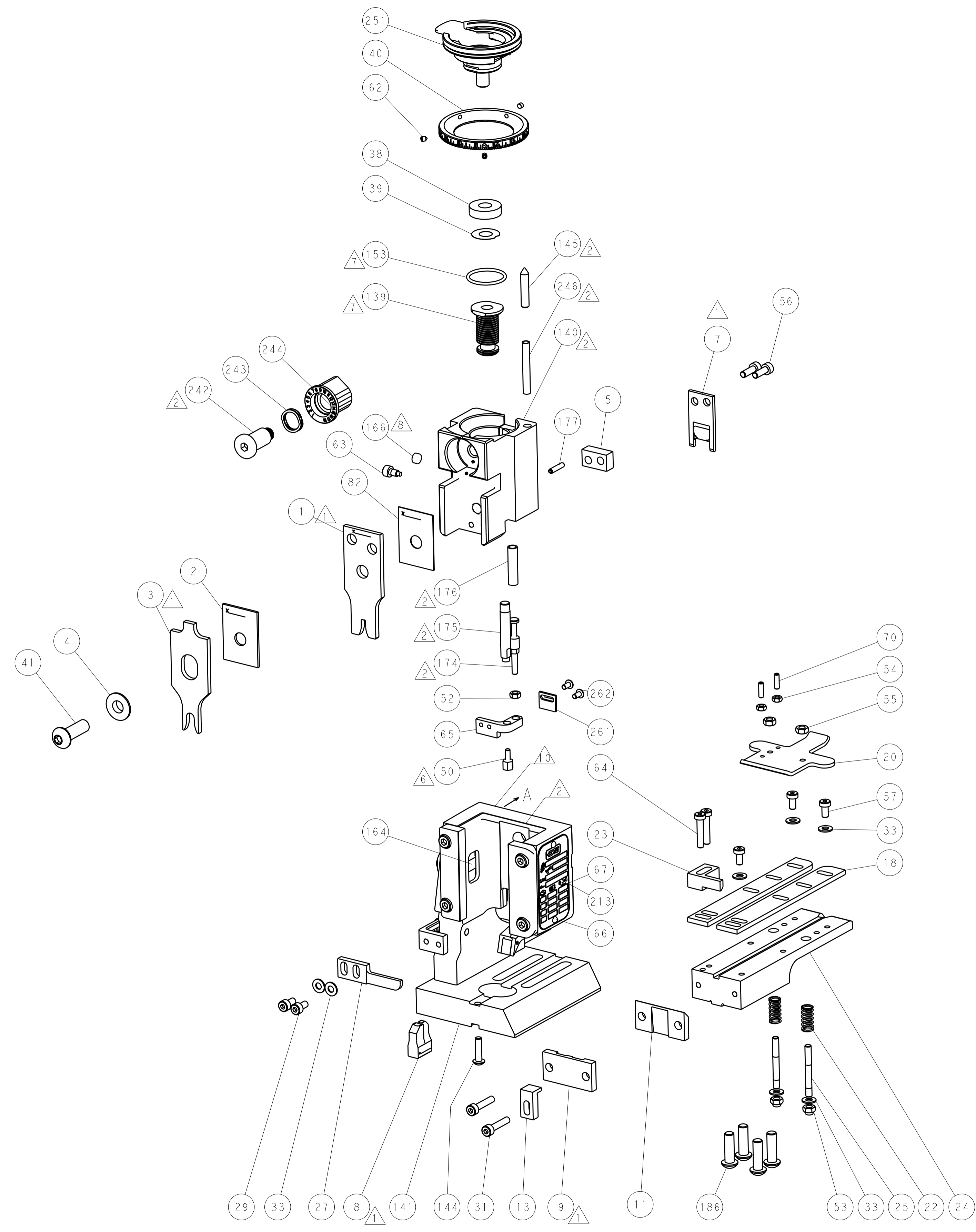
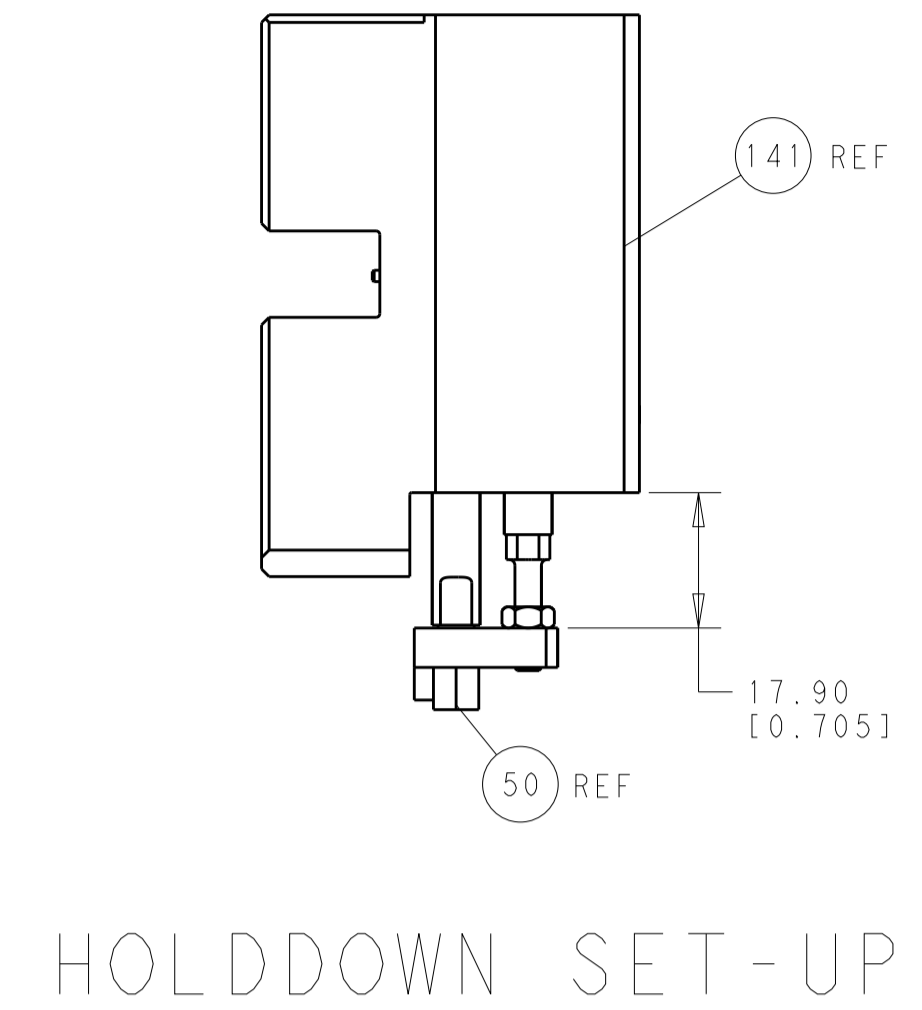
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

- - - 1	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
- - - -	2119580-1	MECHANICAL FEED ASSEMBLY	239
- - - 1	2063440-1	AIR FEED MODULE	238
- - 1 -	2119740-2	TAG, IDENTIFICATION	213
- 4 4 4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
- - REF -	1803052-1	FEED FINGER ASSEMBLY, EF	183
- 1 1 1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
- 1 1 1	8-22280-7	SPRING, COMPRESSION	176
- 1 1 1	1752353-2	GUIDE PIN, HOLDDOWN	175
- 1 1 1	1901680-2	GUIDE PIN, HOLDDOWN	174
- - - 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, .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	455888-4	SPACER, CRIMPER	82
- 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	1901681-8	HOLDDOWN, TERMINAL	65
- 2 2 2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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
- - - -	2063961-1	FEED FINGER	58
- 3 3 3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
- 2 2 2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2031314-1	FEED FINGER SUBASSEMBLY	51
- 1 1 1	1752354-7	STANDOFF, HOLD-DOWN	50
- - - 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	1-2119644-2	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
- 1 1 1	240639-1	STRIPPER (MACHINING)	27
- 2 2 2	1320906-1	STUD, THREADED	25
- 1 1 1	1-1752371-3	PLATE, STRIP GUIDE	24
- 1 1 1	240825-4	PLATE, STRIP HOLD DOWN	23
- 2 2 2	2-22281-3	SPRING, COMPRESSION	22
- 1 1 1	1752373-4	DRAG	20
- 2 2 2	1901259-6	GUIDE, LOWER STRIP	18
- 1 1 1	1752360-1	SPACER, HOLD-DOWN	13
- 1 1 1	240833-6	PLATE, REAR SHEAR	11
- - - -	-	-	10
- 1 1 1	6-690482-3	PLATE, FRONT SHEAR	9
1 1 1 1	2-1333220-6	ANVIL, COMBINATION, .120	8
- 1 1 1	1-2217206-0	BLADE, SLUG	7
- 1 1 1	7-240641-5	SPACER	5
- 1 1 1	238009-1	BLOCK, FL CRIMPER SPACER	4
1 1 1 1	5-2119784-2	CRIMPER, INSULATION O PREMIUM	3
- 1 1 1	1-455888-2	SPACER, CRIMPER	2
1 1 1 1	456409-4	CRIMPER, WIRE .120 "F" PREMIUM	1
-77-27-25-22	PART NO	DESCRIPTION	ITEM NO

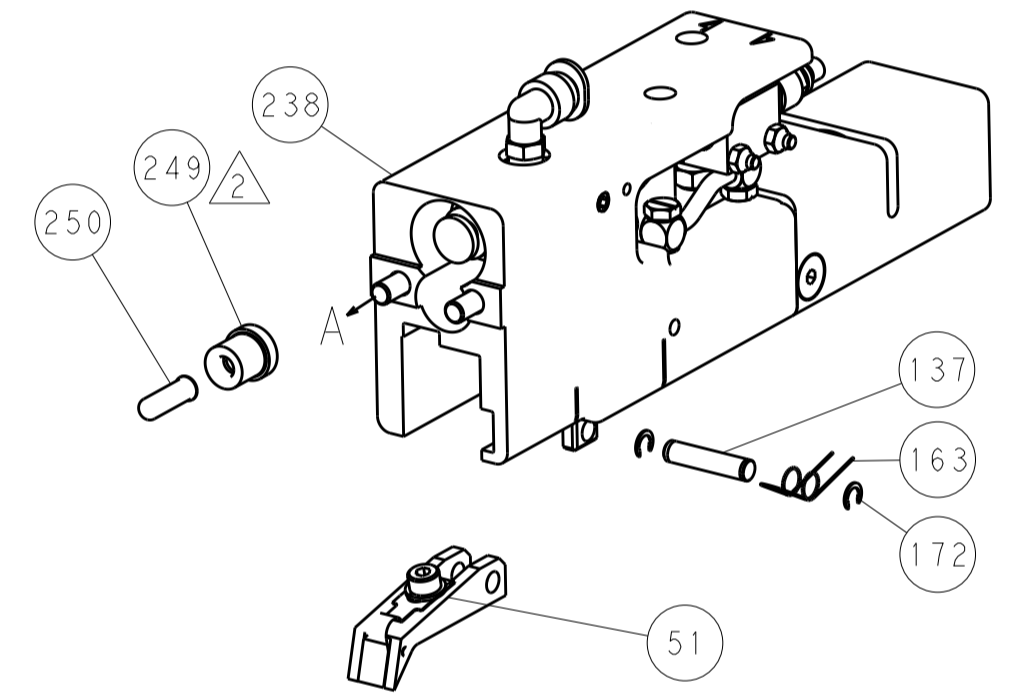
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: C. CHEN 14MAY2012	CHK: S. XI 14MAY2012	APVD: J. CRUZ 14MAY2012	NAME: TE Connectivity Harrisburg, PA 17105-3608
		0 PLC ±.5	1 PLC ±.5	PRODUCT SPEC		Ocean End Feed Applicator	
		2 PLC ±.13	3 PLC ±.013	APPLICATION SPEC		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150054	
		4 PLC ±.0001	ANGLES ±.0001	WEIGHT		RESTRICTED TO	
MATERIAL:		FINISH:		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 3 OF 4 REV B	

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

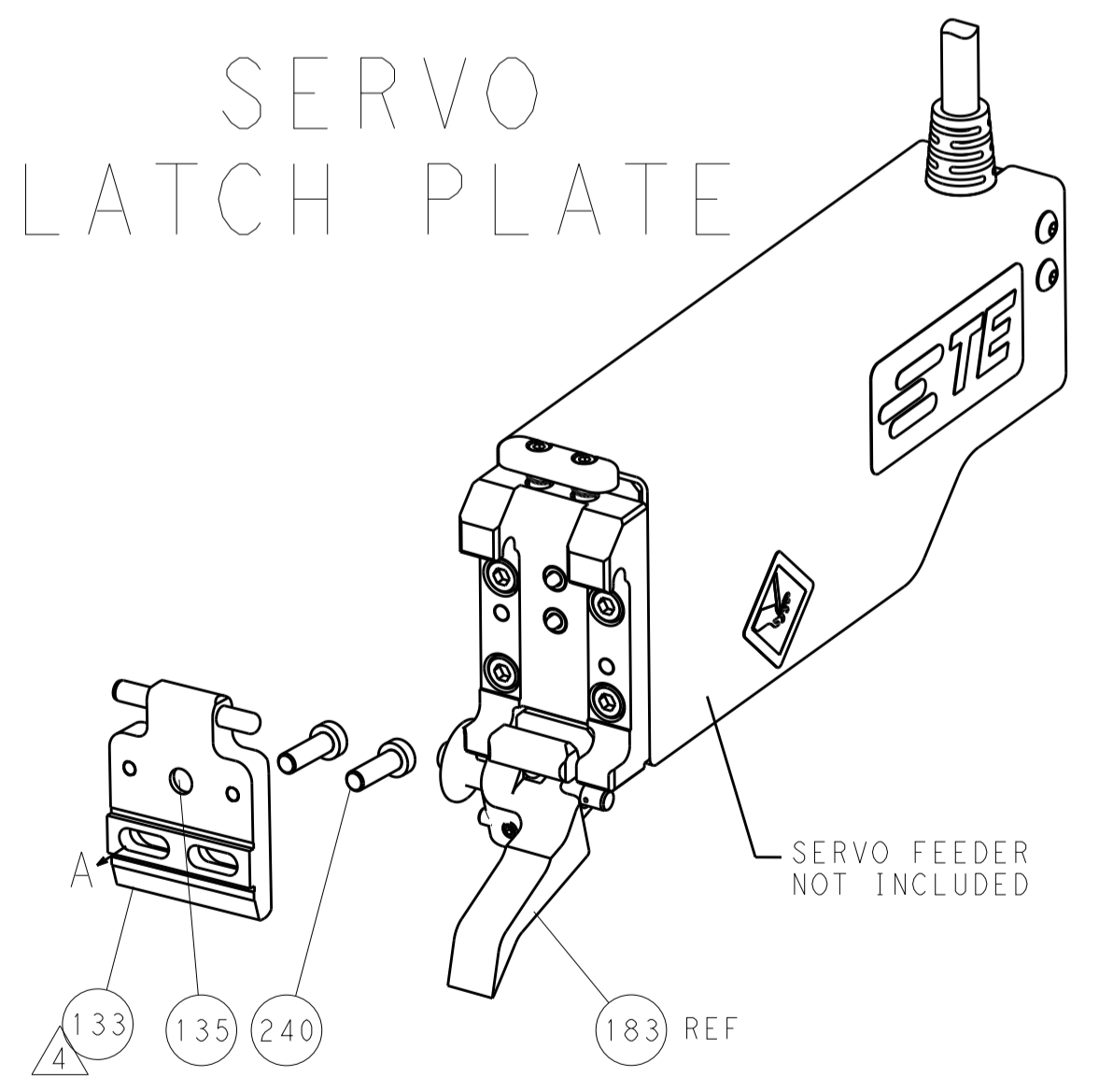


FEED TYPE

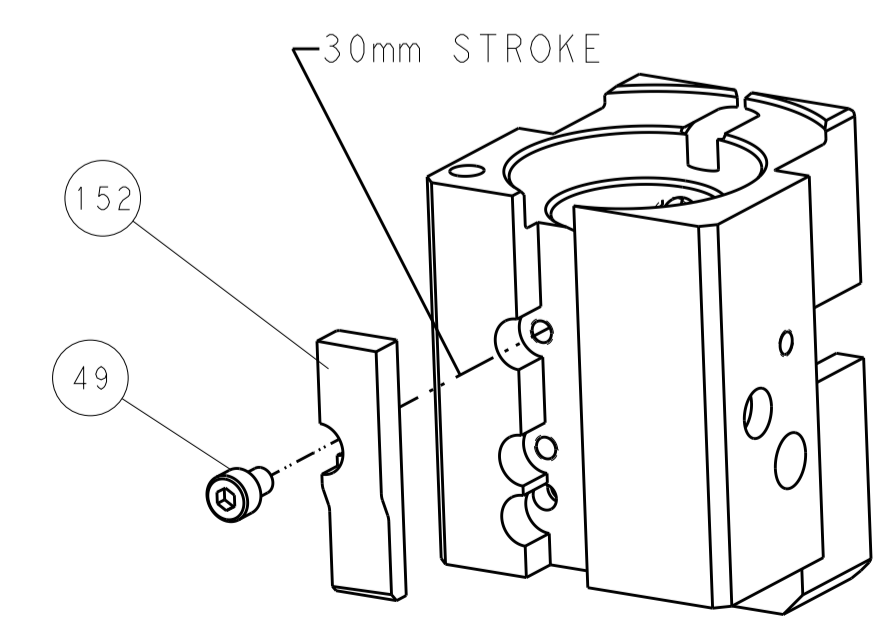
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



AIR FEED

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 L.C. CHEN 14MAY2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	APVD J. CRUZ 14MAY2012	NAME Ocean End Feed Applicator
MATERIAL:		FINISH:		WEIGHT:		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
						A1 00779 C=2150054	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 4 OF 4 REV B	