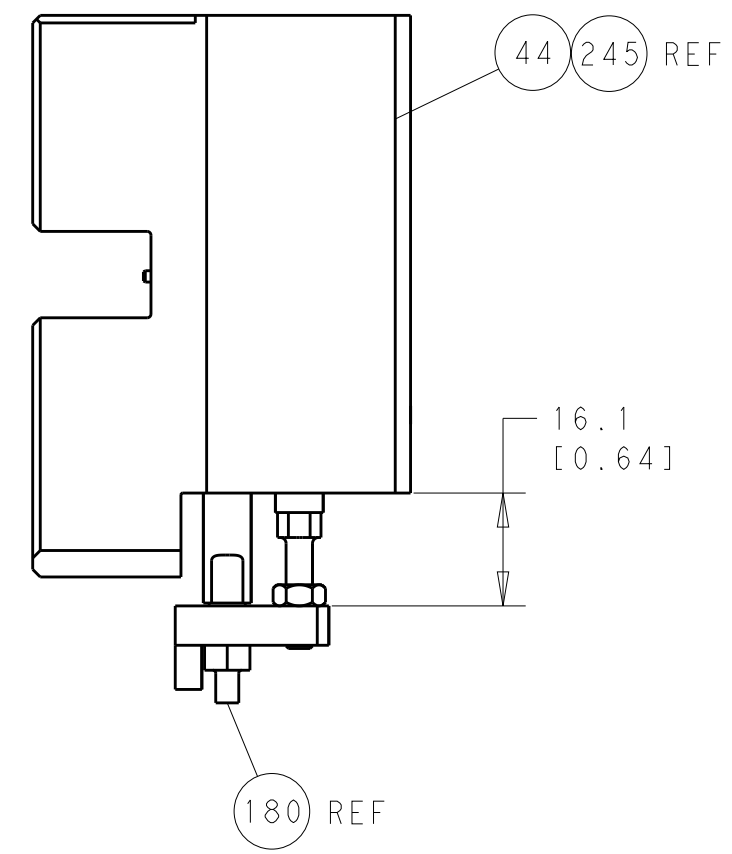
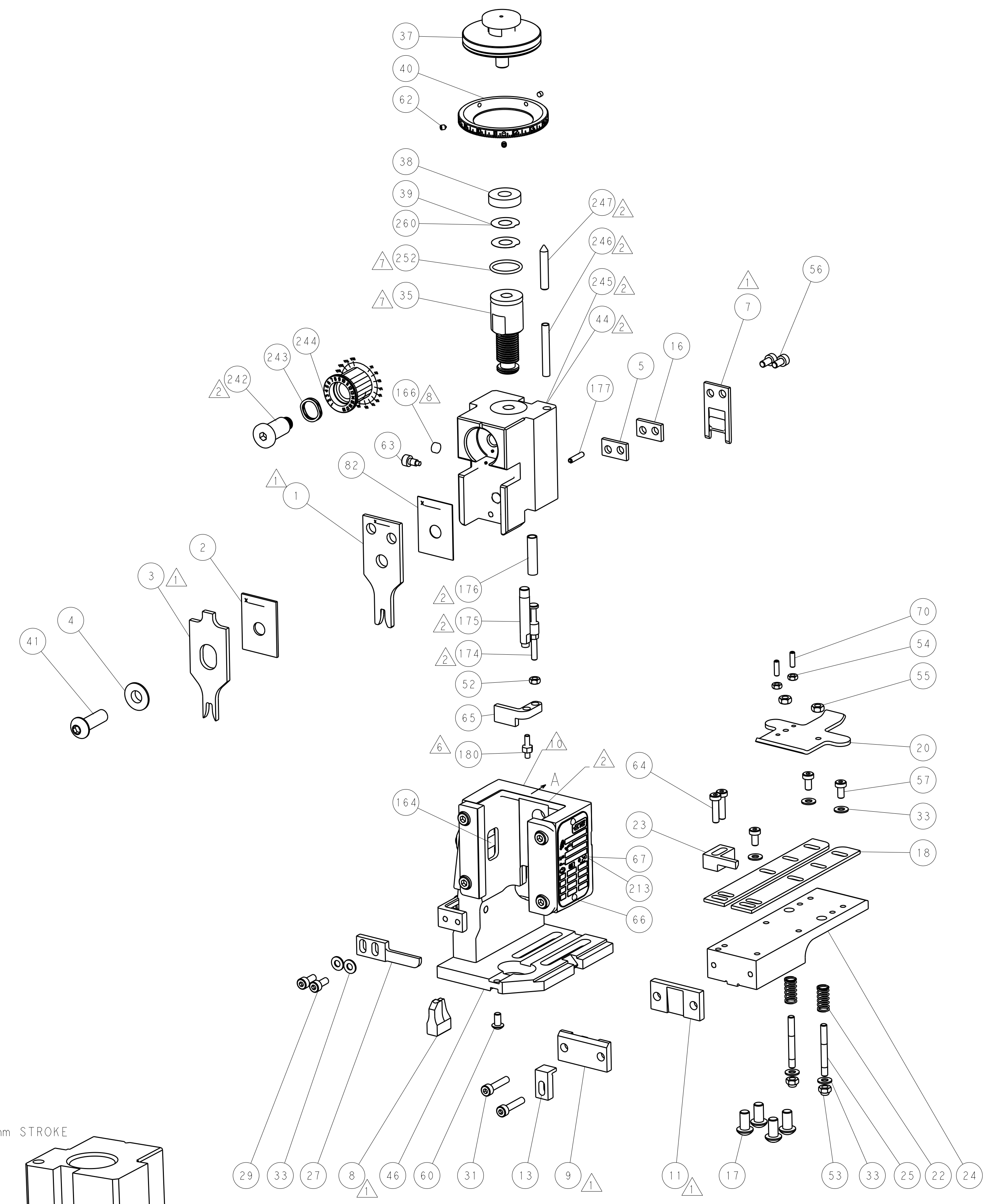




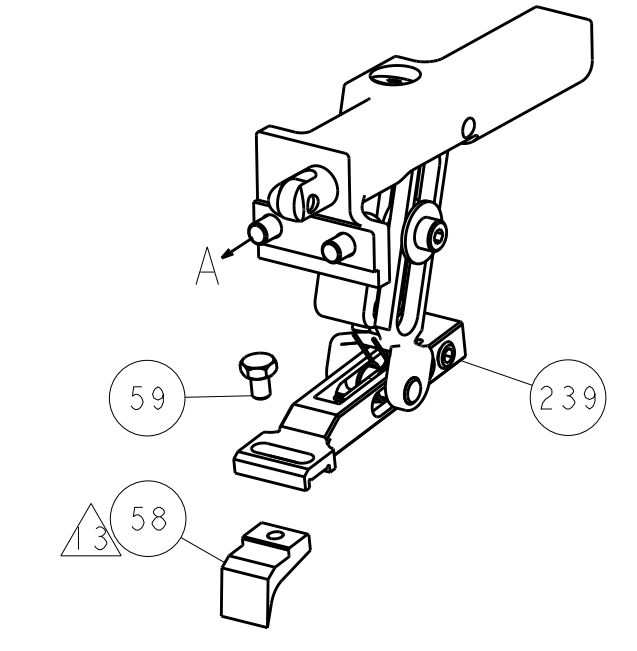
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A	66				
REVISIONS			DESCRIPTION	DATE	BY
-			SEE SHEET 1	-	-



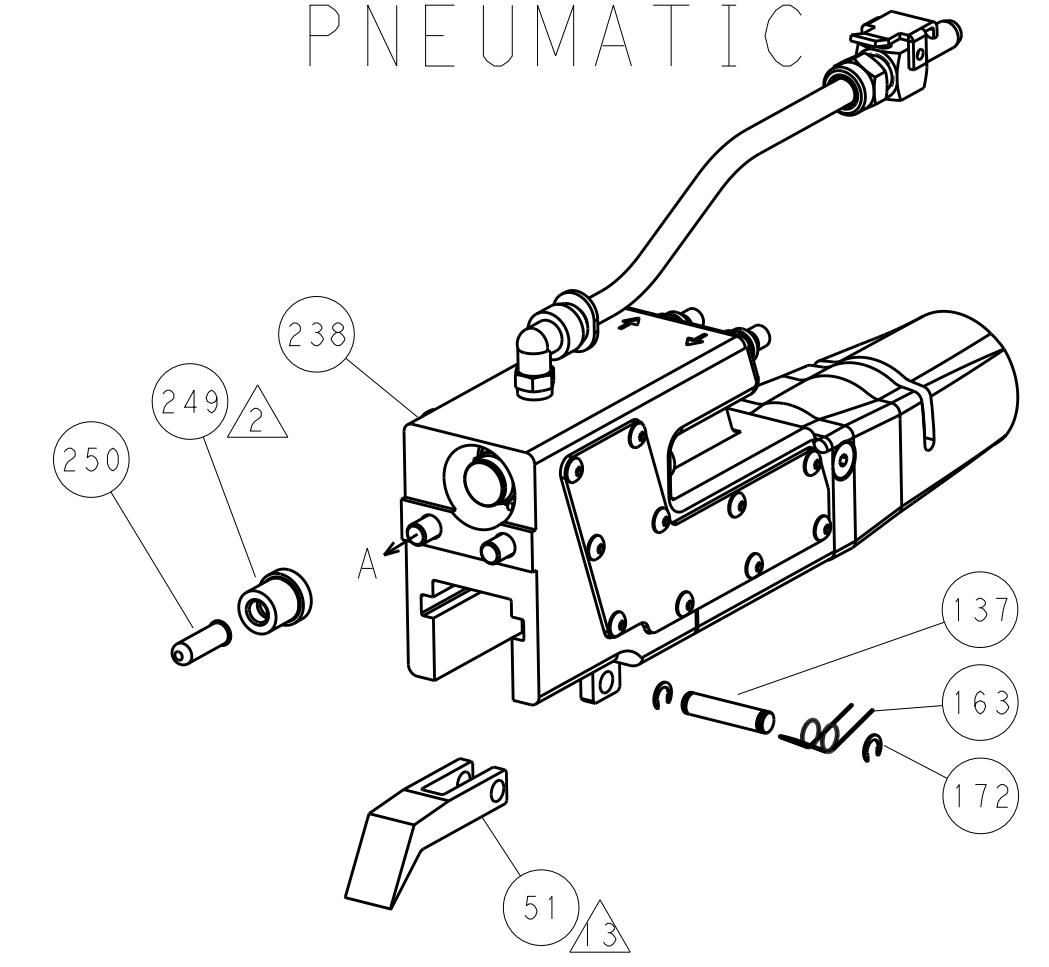
HOLDDOWN SET-UP



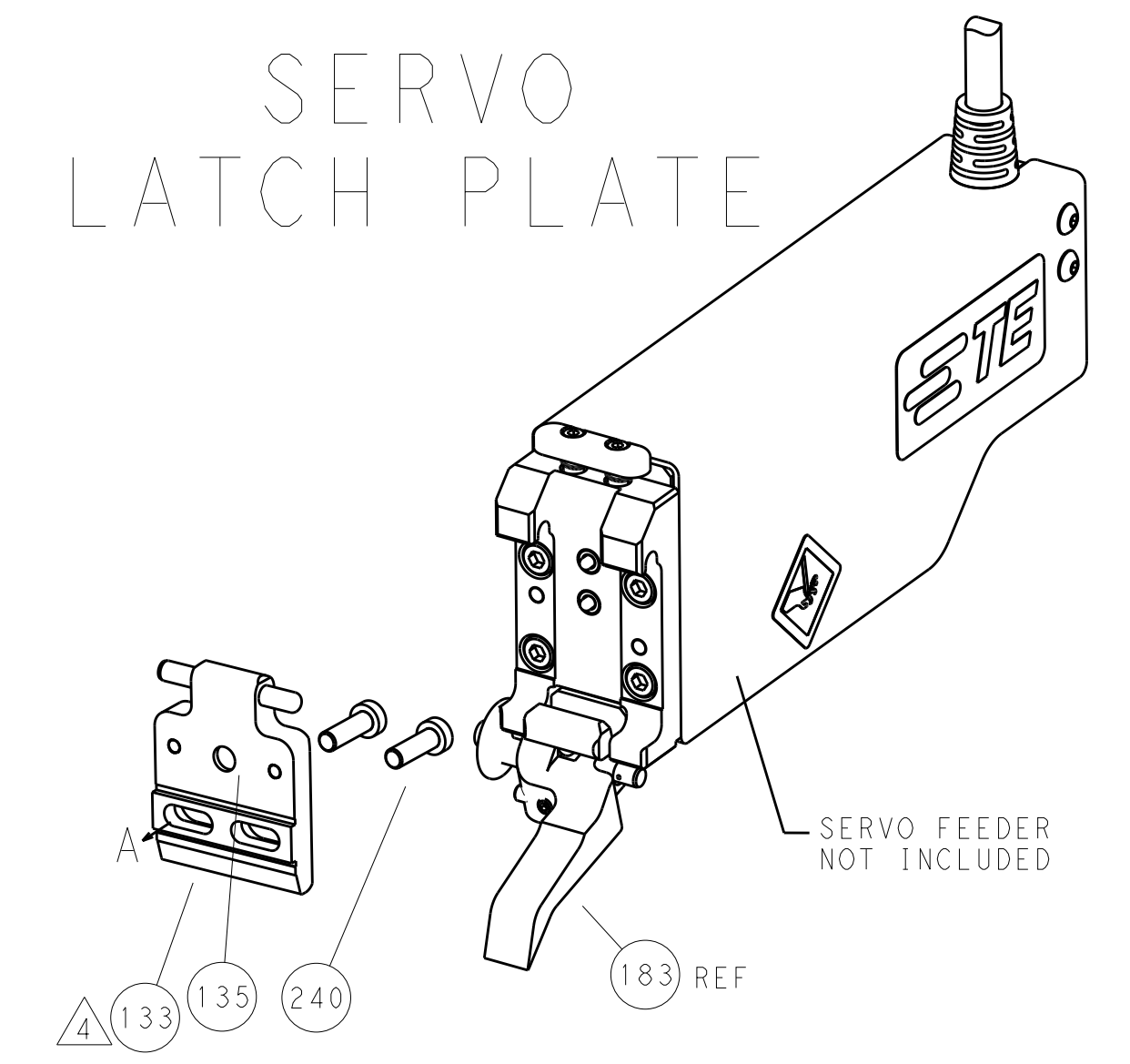
FEED TYPE  
MECHANICAL



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 ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001		DWN X_ZHAO 03JUN2012 CHK T_ELBIN 03JUN2012 APPV S_XI 03JUN2012		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL		FINISH		PRODUCT SPEC		NAME Ocean End Feed Applicator	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO A1 00779 C=2150012	
				WEIGHT		RESTRICTED TO Customer Accessible Production Drawing	
				SCALE 1:1		SHEET 2 OF 4 REV A	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART									
				CONVERT TO	PART NUMBERS REQUIRED								
2-2150012-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-4	-	2119641-2	-	2063440-1			
				SERVO LATCH PLATE	2119951-1	1901697-1	8-2150012-5	-	2168400-7 (QUANTITY 2)				
				SMART APPLICATOR	2161326-1	-	8-2150012-4	-	-				
				MECHANICAL FEED	2119949-1	2063961-4	5-18022-5	2119653-2	-	-			
2-2150012-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150012-5	-	2168400-7 (QUANTITY 2)				
				SMART APPLICATOR	2161326-1	-	8-2150012-4	-	-				
				MECHANICAL FEED	2119949-1	2063961-4	5-18022-5	2119653-2	-	-			
				PNEUMATIC FEED	2119950-1	2119792-4	-	2119641-2	-	2063440-1			
2-2150012-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	-	-	-
2-2150012-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-	-	-
7-2150012-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	WIRE	TYPE
2.79 mm (.110)	F	F
4.57 mm (.180)	F	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SHUR PLUG			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.90-4.70 mm (.154-.185 IN)	Ø2.54-3.68 mm (.100-.145 IN)		
TERMINAL APPLICATION SPECIFICATION	114-5208		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170002-3	170002-4	170002-5	170002-8
170002-9	3-170002-3	3-170002-4	6-170002-4
8-170002-4			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.88 +/- 0.05 [ 0.74 +/- .002 ]	3.9
1.25mm2	1.73 +/- 0.05 [ 0.68 +/- .002 ]	5.4
0.75mm2	1.63 +/- 0.05 [ 0.64 +/- .002 ]	6.6
0.50mm2	1.50 +/- 0.05 [ 0.59 +/- .002 ]	7.9



- 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: 8-2150012-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150012-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150012-5
- 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 ITEM 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.
- 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. POSITION ITEM 51 & 58 TO FEED TERMINAL FROM END OF RECEPTACLE.

**\*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.

-77-27-25-22-21	PART 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
-	1 1 1 1	1-22279-3 SPRING, COMPRESSION	246
-	1 1 1 1	2119082-3 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1 1 1 1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243

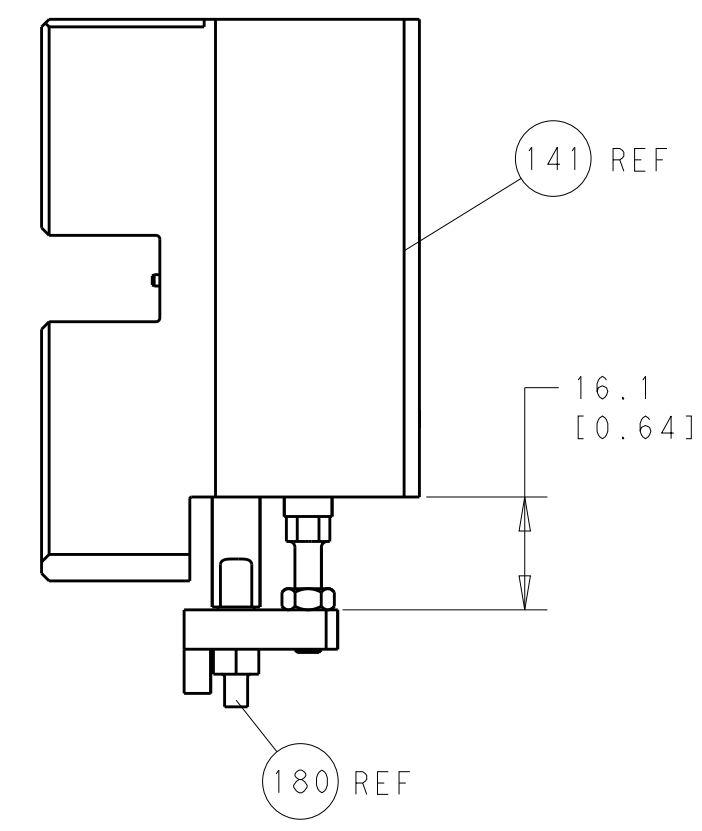
**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

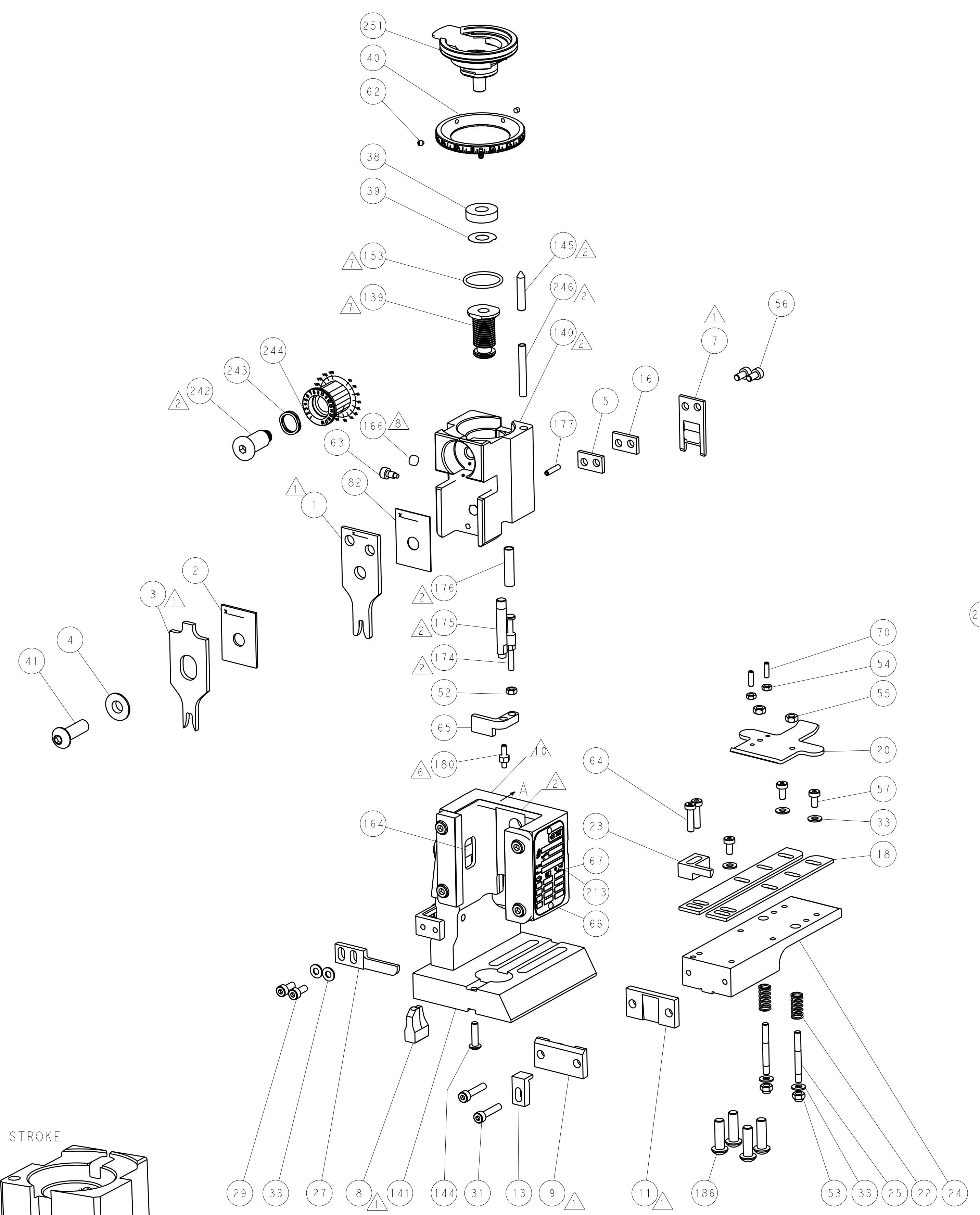
REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV	
-	-	-	-	SEE SHEET 1	-	-	-	
6	-	1	1	1	2119083-1		RETAINER, INSULATION DIAL	242
-	-	2	-	-	2168400-7		SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2119580-1		MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-1		AIR FEED MODULE	238
-	-	1	-	-	2119740-2		TAG, IDENTIFICATION	213
-	4	4	4	4	2079383-9		SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	-	1901697-1		FEED FINGER ASSEMBLY, EF	183
6	-	1	1	1	1-1976055-5		STANDOFF, HOLD-DOWN	180
-	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	1	455888-4		SPACER, CRIMPER	82
-	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	1901681-5		HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-8		SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	1	1	1	2119793-1		LIMITER, ADJUSTMENT BOLT	63
6	-	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
2	-	-	-	-	2063961-4		FEED FINGER	58
-	3	3	3	3	2168400-4		SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-2		SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	2	2	5018030-2		NUT, HEX, REG, RoHS, M4	55
-	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	1	1	1	1-5018030-0		NUT, HEX, REG, RoHS, M3.5	52
2	-	-	-	1	2119792-4		PAWL, EF, AIR	51
-	-	-	-	1	18023-9		SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1		FEED CAM, PRE FEED	48
-	1	1	1	1	2079383-7		SCR, BHSC, RoHS (M8 X 25)	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	1-2119644-2		RAM WASHER, PRECISION	38
-	7	7	7	7	1-18028-2		WASHER, FLAT, REG M4	33
-	2	2	2	2	2168083-9		SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	1-2168083-0		SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	240639-1		STRIPPER (MACHINING)	27
-	2	2	2	2	1320906-1		STUD, THREADED	25
-	1	1	1	1	1752371-5		PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-8		PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2-22281-3		SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4		DRAG	20
-	2	2	2	2	1901259-4		GUIDE, LOWER STRIP	18
-	1	1	1	1	240641-2		SPACER	16
-	1	1	1	1	1752360-1		SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-1		PLATE, REAR SHEAR	11
-	-	-	-	-	-		-	10
1	-	1	1	1	690496-4		PLATE, FRONT SHEAR	9
1	1	1	1	1	1803001-4		ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	2-690474-8		BLADE, SLUG	7
1	-	1	1	1	4-240641-0		SPACER	5
-	1	1	1	1	238009-1		BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	2119582-3		CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1-455888-3		SPACER, CRIMPER	2
1	1	1	1	1	456408-2		CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		DRAWING NO		SHEET	
mm	0 PLC ±.5	1 PLC ±.13	2 PLC ±.013	3 PLC ±.013	4 PLC ±.0001	ANGLES ±.0001	FINISH	DATE	DRAWING NO
								03JUN2012	2150012
								3	4

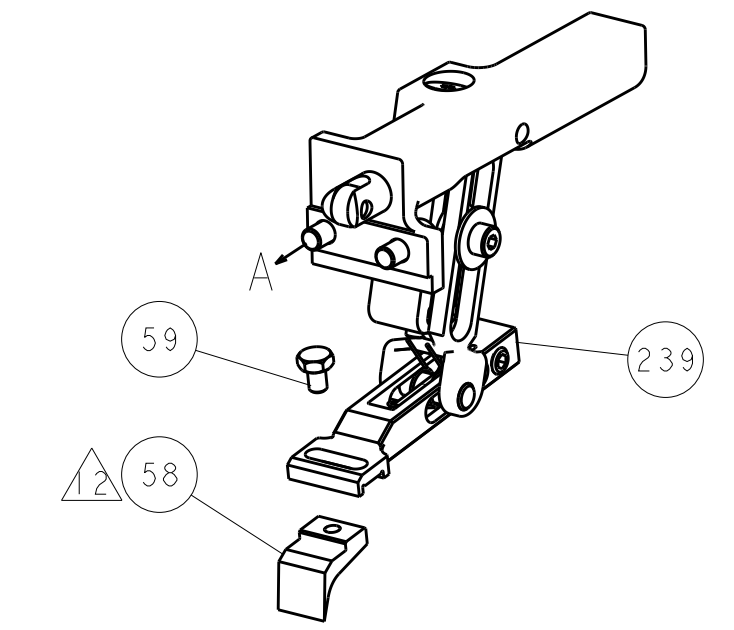
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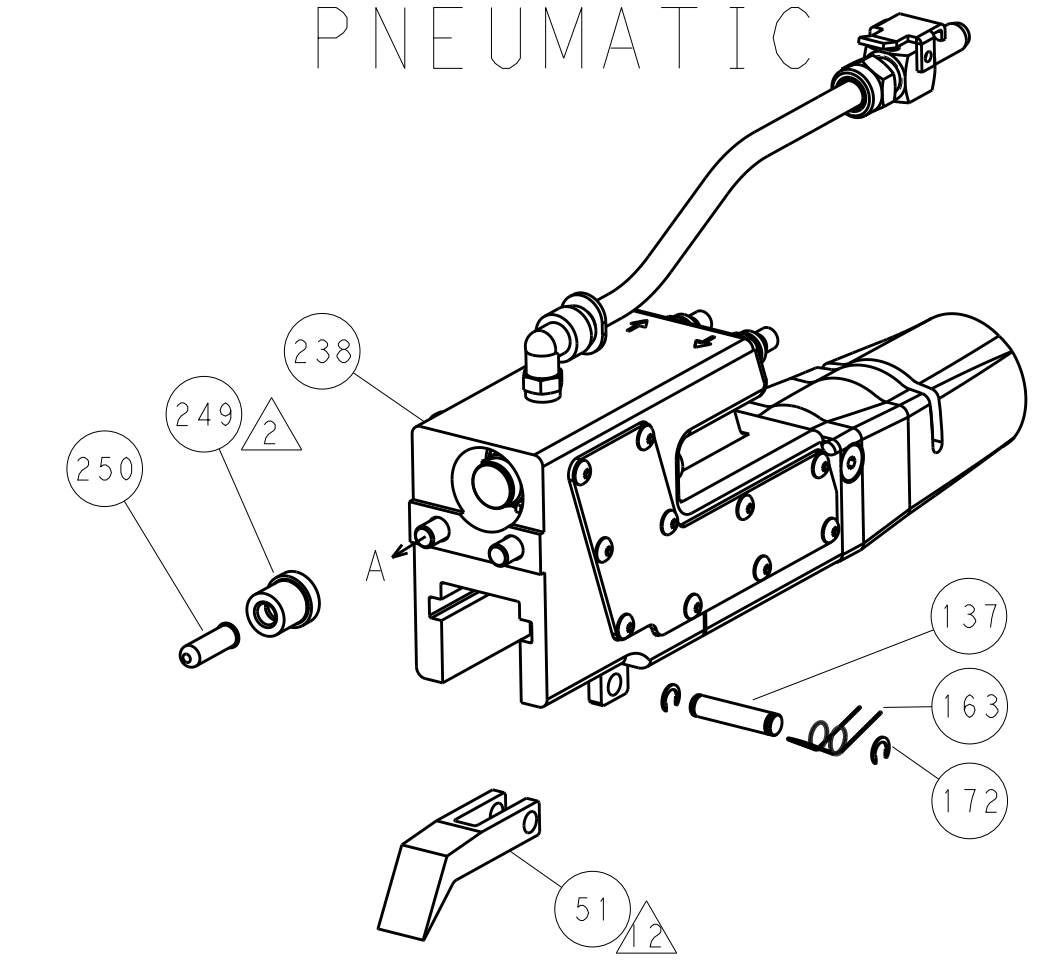
HOLDDOWN SET-UP



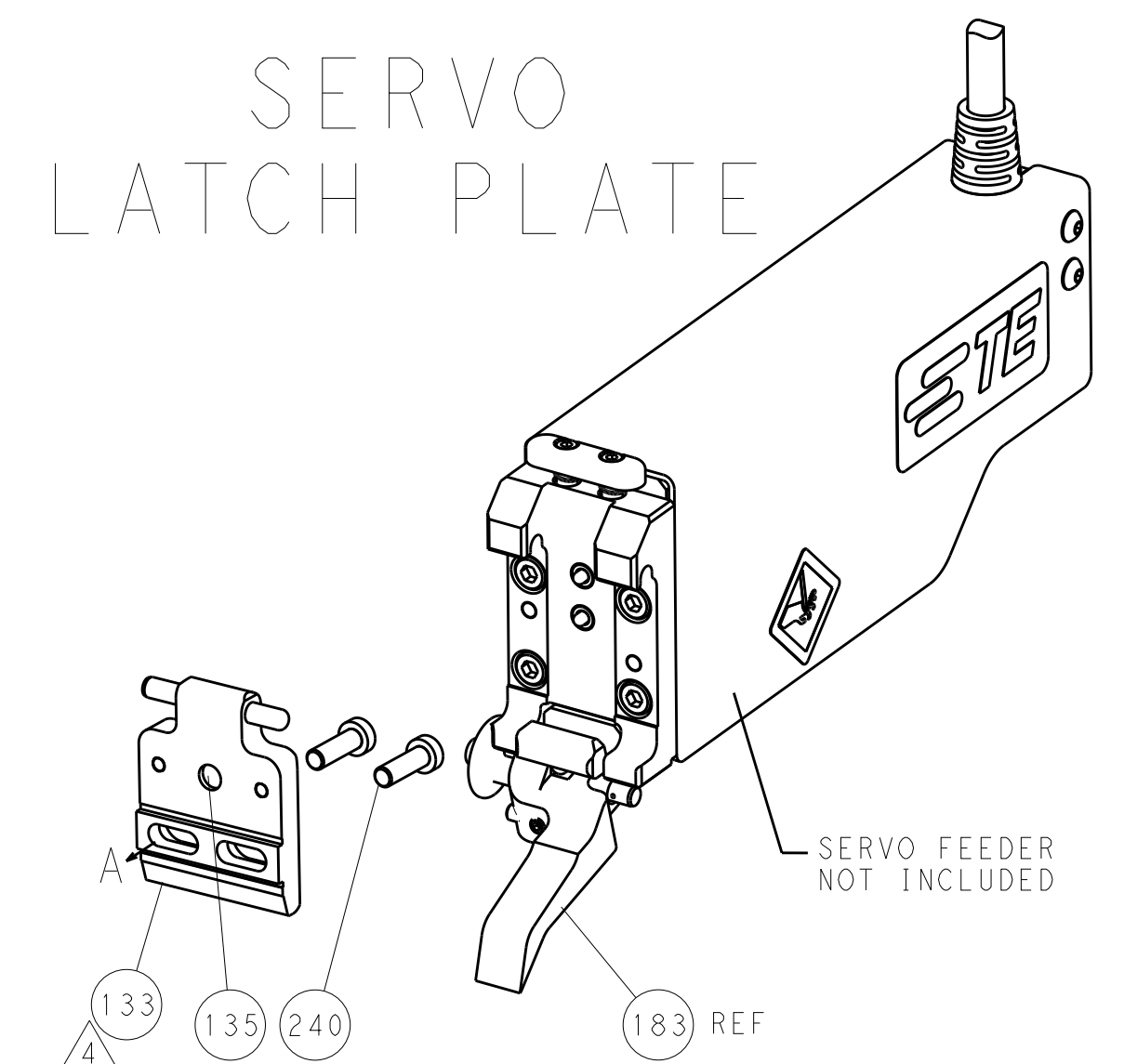
FEED TYPE  
MECHANICAL



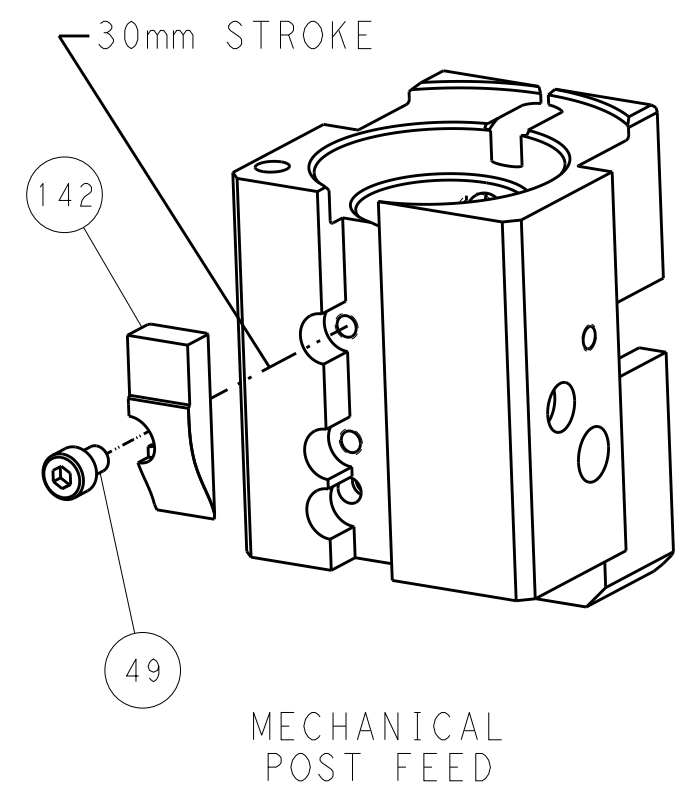
PNEUMATIC



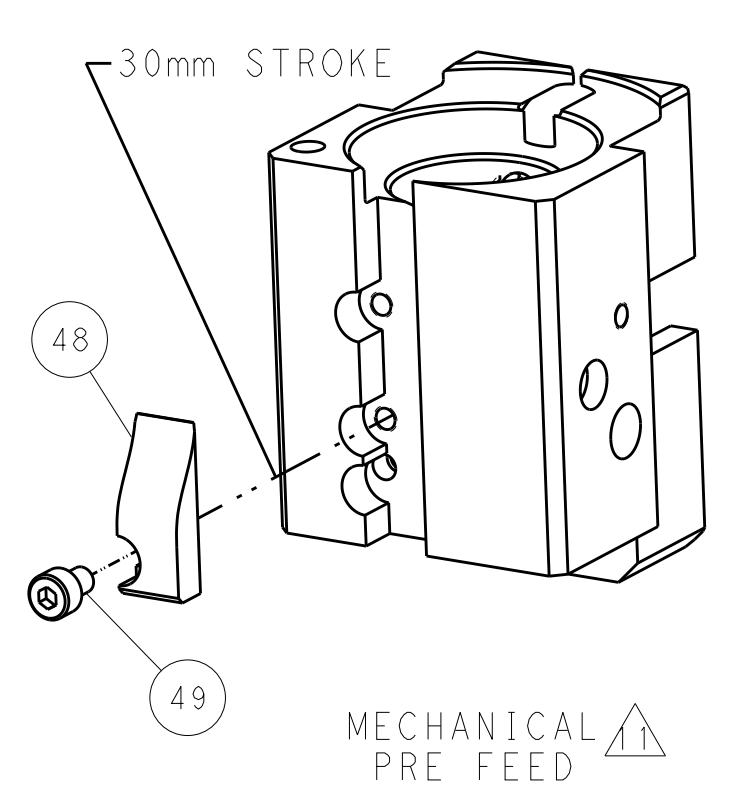
SERVO LATCH PLATE



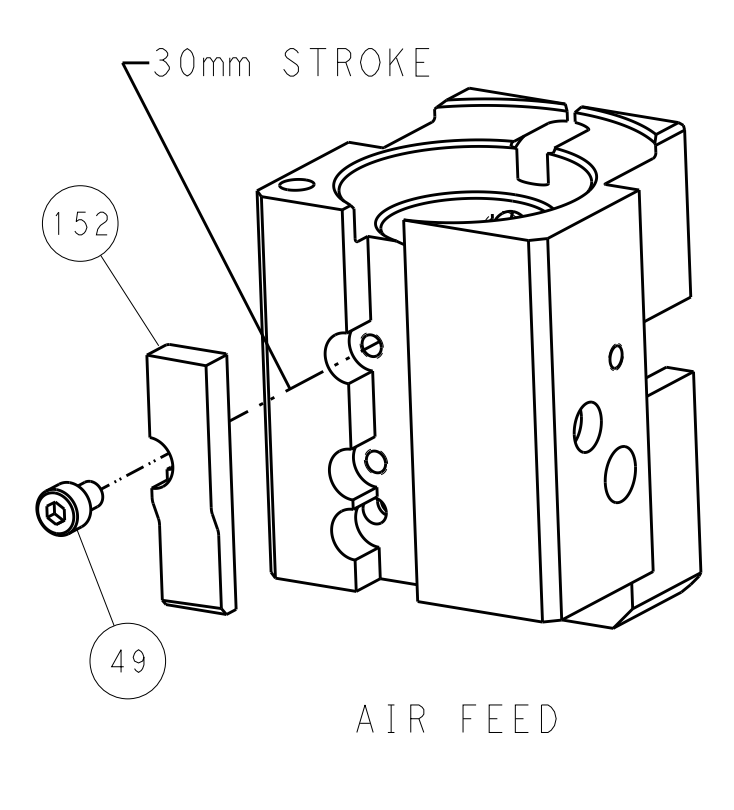
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



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 X_ZHAO 03JUN2012		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 ±0.001	APVD S_XI 03JUN2012	NAME
	ANGLES ±0.001			PRODUCT SPEC		Ocean End Feed Applicator	
MATERIAL	FINISH			APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A 00779 C=2150012	
				Customer Accessible Production Drawing		SCALE 1:1 SHEET 4 OF 4 REV A	