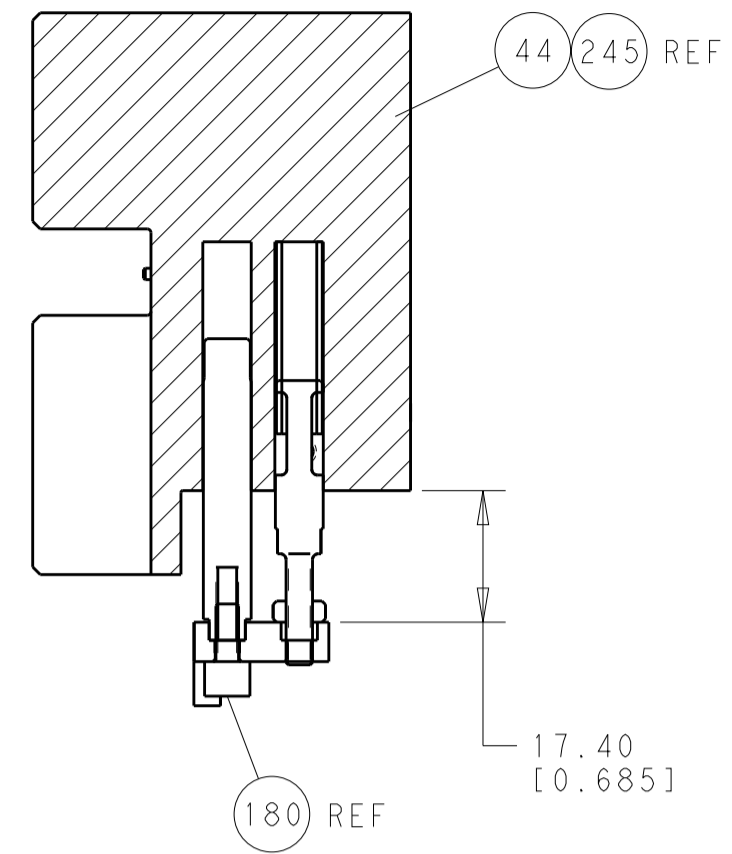
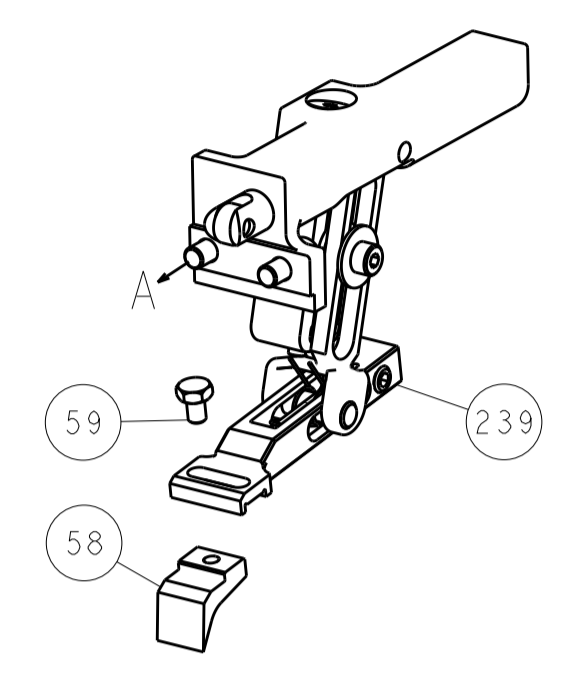


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

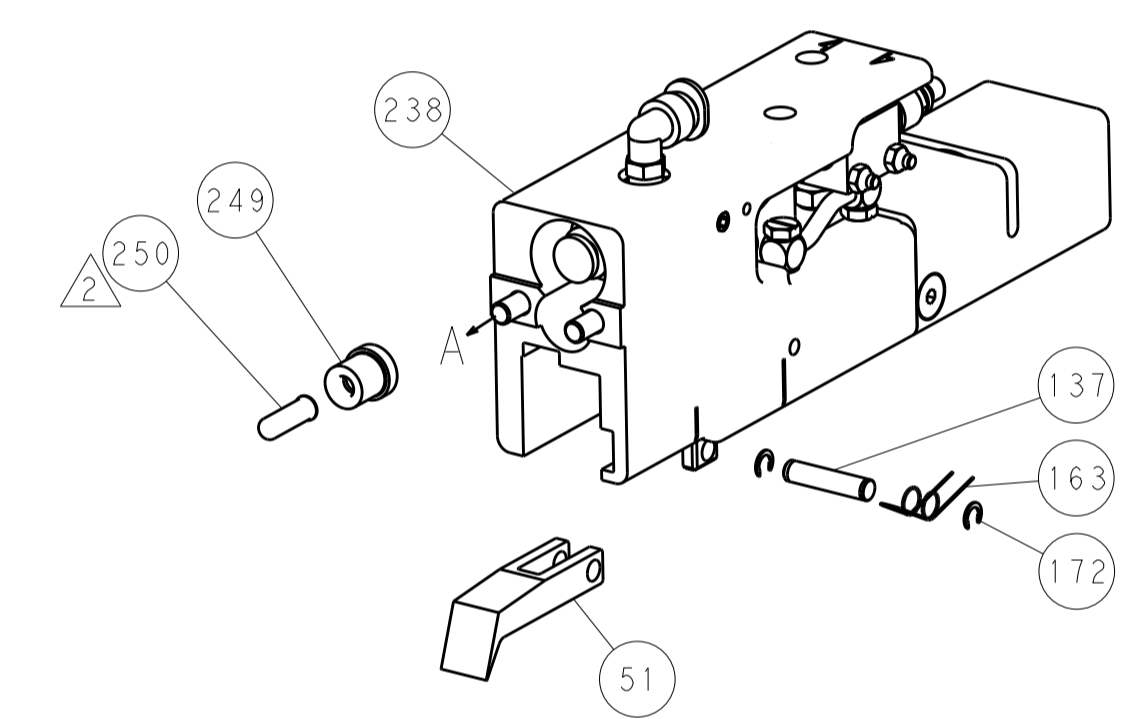


HOLDDOWN SET-UP

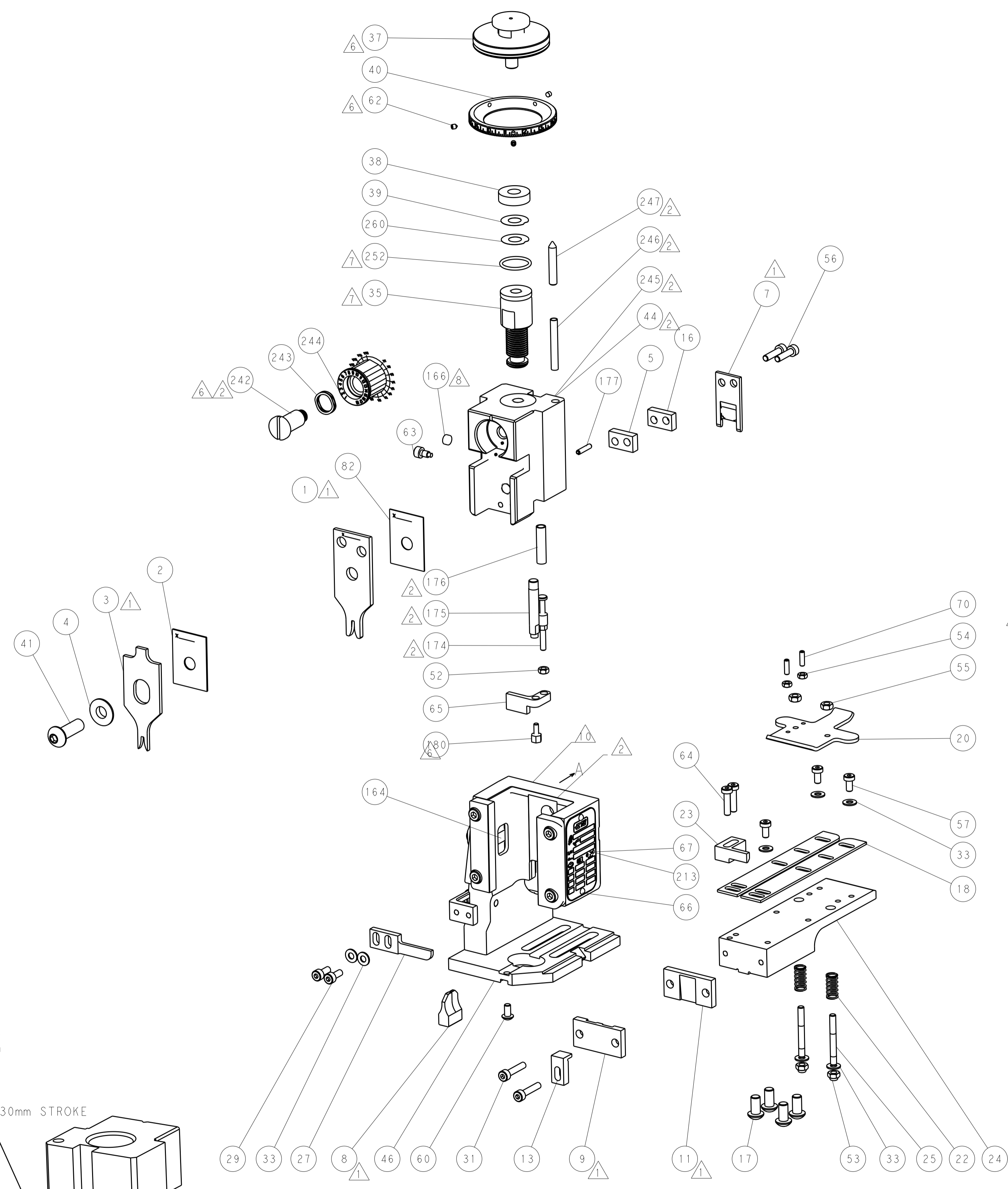
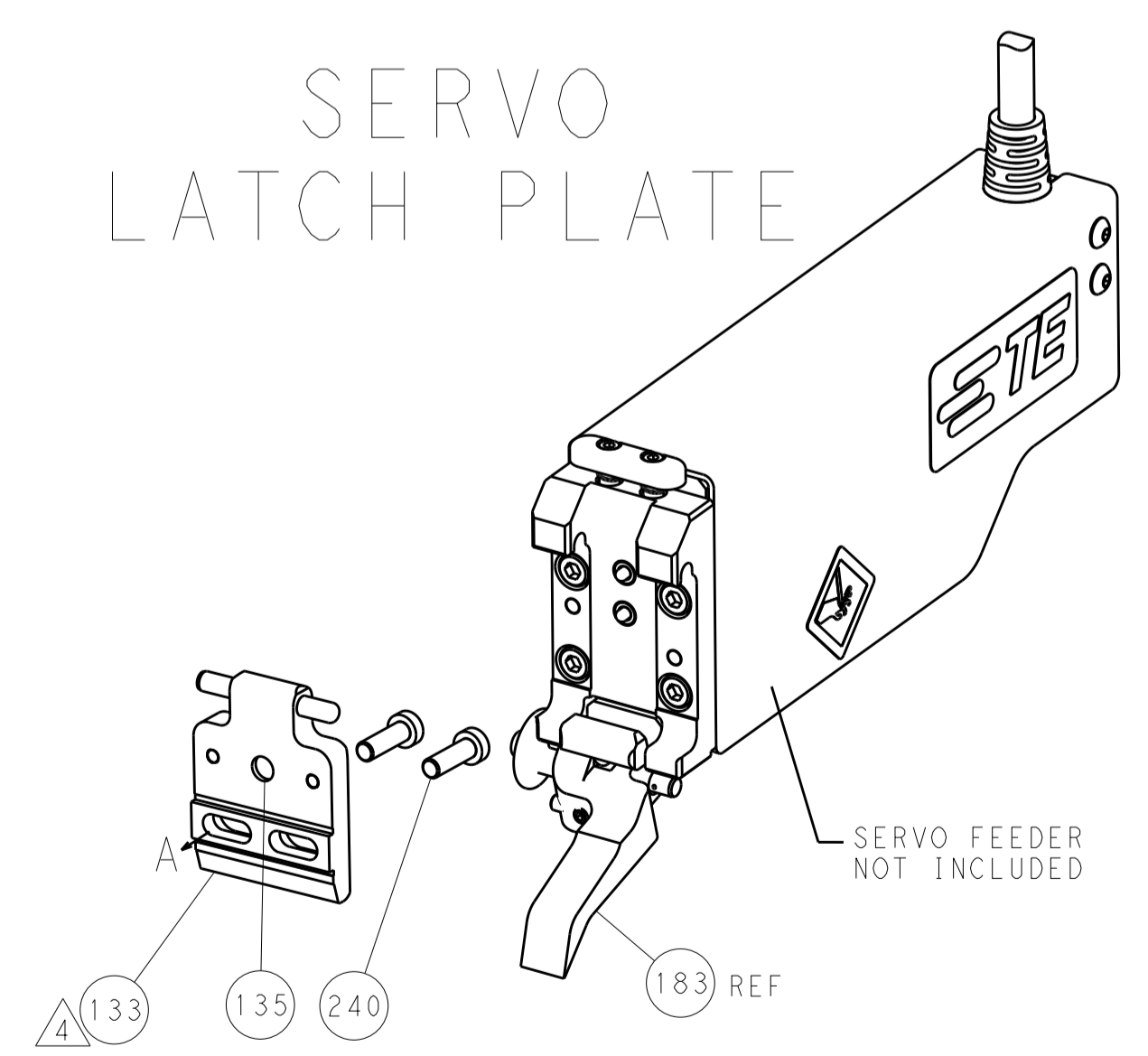
FEED TYPE
MECHANICAL



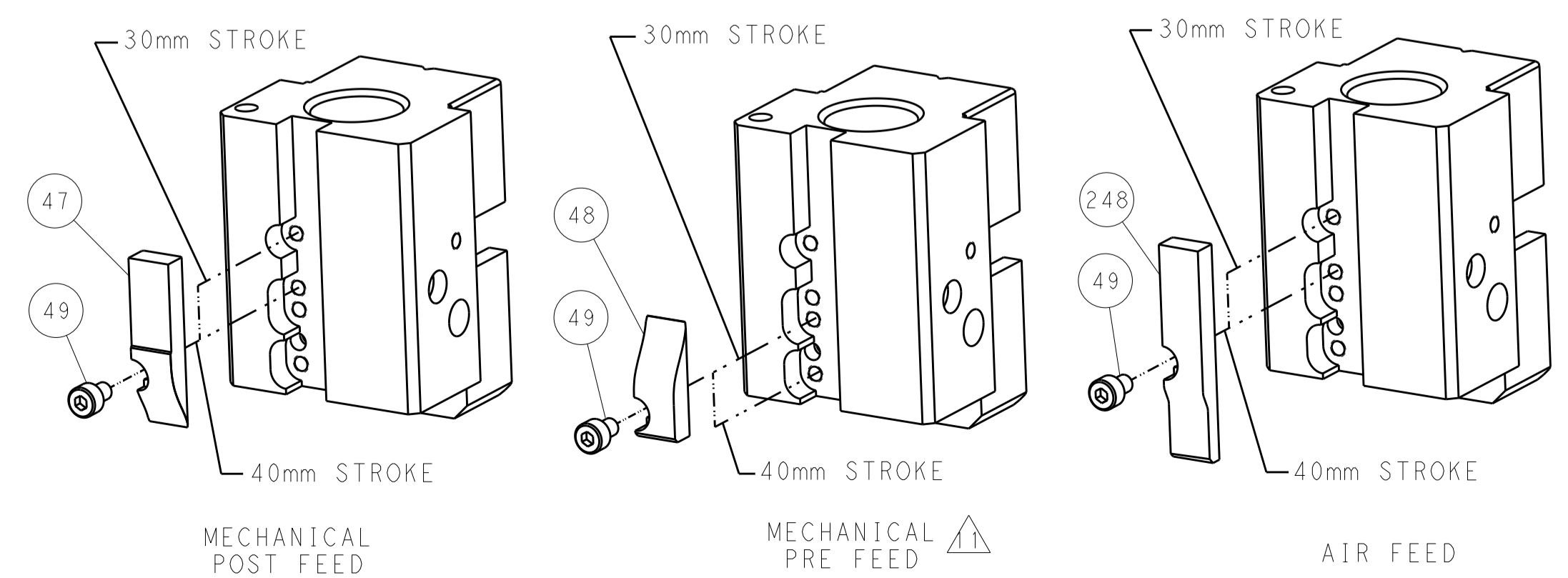
PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB_HIGMAN 02JUL2014		TE Connectivity	
mm		0 PLC ±0.5		CHK: T.ELBIN 02JUL2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APVD: D. STOUGH 02JUL2014		NAME: Ocean End Feed Applicator	
H		2 PLC ±0.013		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
ANGLES		3 PLC ±0.001		APPLICATION SPEC		RESTRICTED TO	
FINISH		4 PLC ±0.001		WEIGHT		A1 00779 ©=2150456	
MATERIAL		5 PLC ±0.001		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					
2-2150456-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-2
				SERVO LATCH PLATE	2119951-1	1901697-1	8-2150456-5	-	2168400-7 (QUANTITY 2)	
				SMART APPLICATOR	2161326-1	-	8-2150456-4	-	-	
2-2150456-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
				SERVO LATCH PLATE	2119951-1	1901697-1	8-2150456-5	-	2168400-7 (QUANTITY 2)	
				SMART APPLICATOR	2161326-1	-	8-2150456-4	-	-	
2-2150456-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	
2-2150456-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150456-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 1.78 mm (.070)	F	
INSUL 2.29 mm (.090)	F	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: .110 SERIES FASTIN-FASTON TAB		
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	
4.19-4.95 mm (.165-.195 IN)	Ø1.01-1.60 mm (.040-.063 IN)	
TERMINAL APPLICATION SPECIFICATION	114-20021	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
160923-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.24 +/- 0.05 (.049 +/- .002)	6.4
0.35mm2	1.17 +/- 0.05 (.046 +/- .002)	7.1
0.25mm2	1.13 +/- 0.05 (.044 +/- .002)	7.7
0.20mm2	1.09 +/- 0.05 (.043 +/- .002)	8.1

- 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: 8-2150456-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150456-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150456-5
- 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 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

- 1 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	1-22279-3	SPRING, COMPRESSION	246
- 1 1 1 1 1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
- 1 1 1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
- 77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO

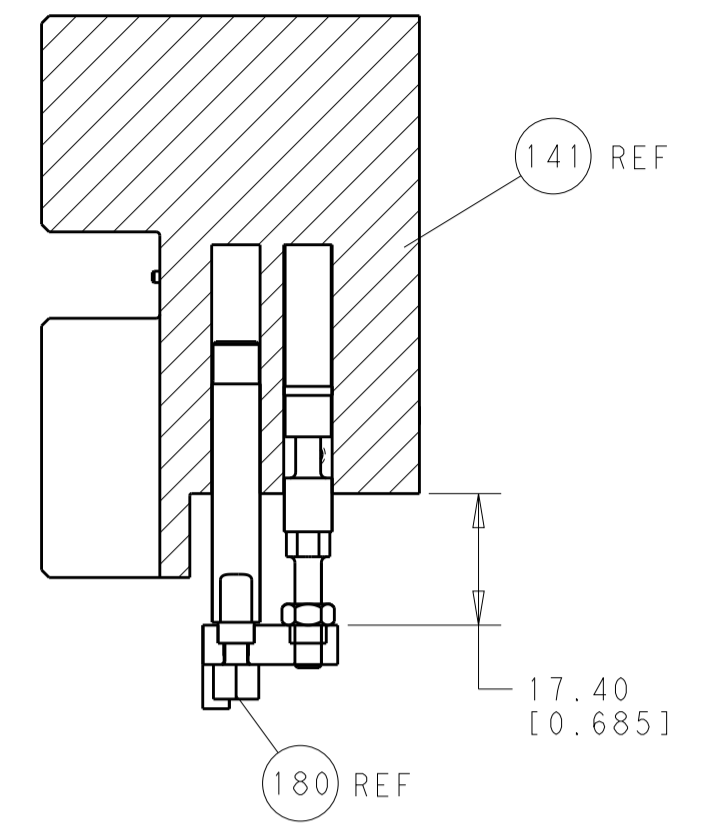
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

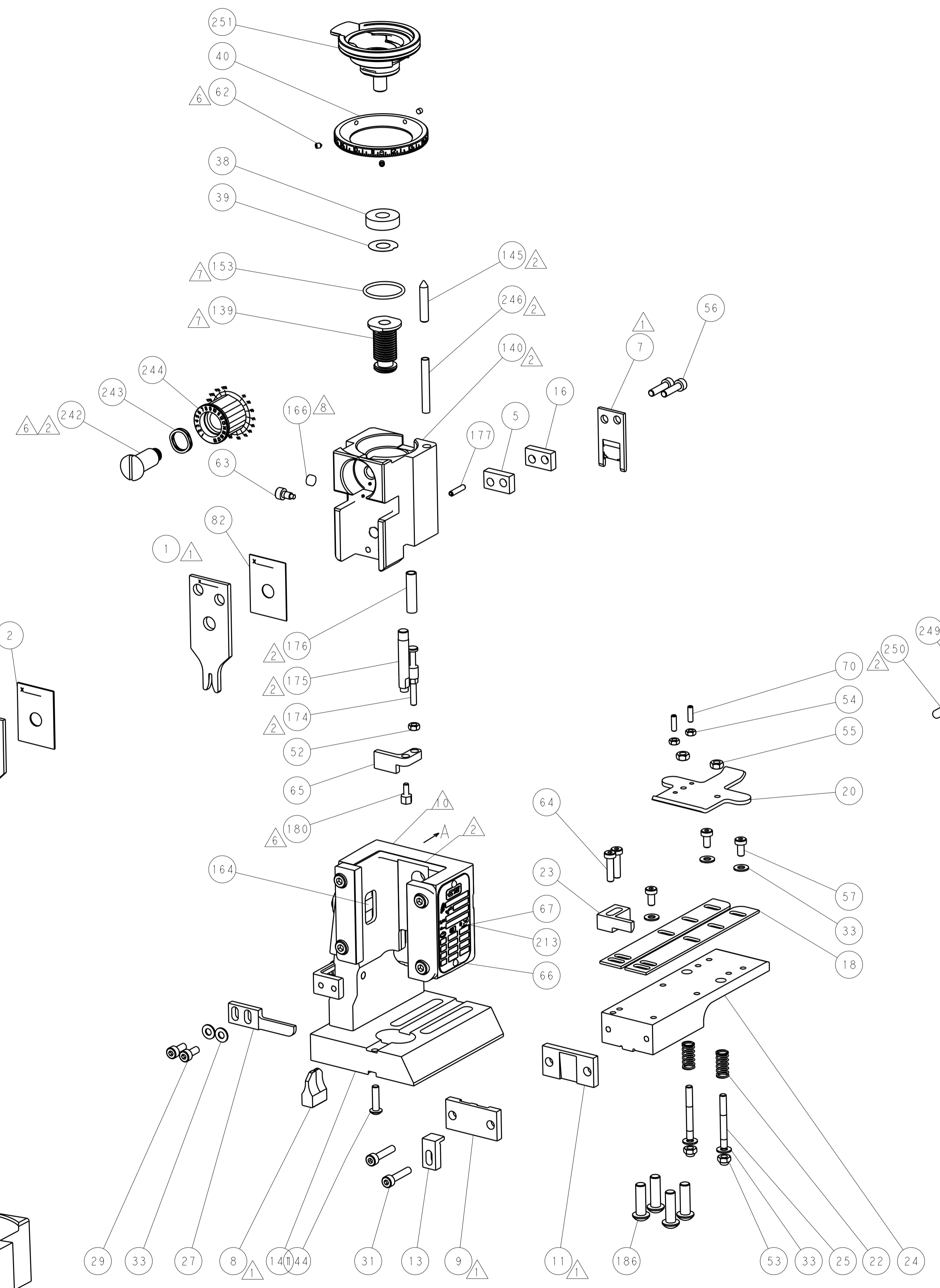
- - 2 - -	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
- - - - 1	2119580-1	MECHANICAL FEED ASSEMBLY	239
- - - 1 -	2063440-2	AIR FEED MODULE	238
- - 1 - -	2119740-2	TAG, IDENTIFICATION	213
- 4 4 4 4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
- - REF - -	1901697-1	FEED FINGER ASSEMBLY, EF	183
- 1 1 1 1	1752354-3	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
- 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	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	1901681-9	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
- 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	2063961-1	FEED FINGER	58
- 3 3 3 3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
- 2 2 2 2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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
- - - 1 -	2119792-2	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	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	2119644-1	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	240825-1	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	1901259-3	GUIDE, LOWER STRIP	18
- 1 1 1 1	3-240641-2	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	690482-5	PLATE, FRONT SHEAR	9
1 1 1 1 1	1803074-9	ANVIL, COMBINATION, END FEED	8
- 1 1 1 1	2217206-7	BLADE, SLUG	7
- - - - -	-	-	6
- 1 1 1 1	3-240641-5	SPACER	5
- 1 1 1 1	238009-4	BLOCK, FL CRIMPER SPACER	4
1 1 1 1 1	1803016-9	CRIMPER, INSULATION F	3
- 1 1 1 1	455888-7	SPACER, CRIMPER	2
1 1 1 1 1	1-456404-8	CRIMPER, WIRE PREMIUM	1
- 77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 02JUL2014		CHK: T. ELBIN 02JUL2014		APVD: D. STOUGH 02JUL2014		NAME: Ocean End Feed Applicator	
0 PLC	± .5	1 PLC	± .13	2 PLC	± .13	3 PLC	± .013	4 PLC	± .0001	ANGLES	± .0001
MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
-		-		-		A 00779		3 OF 4		A	

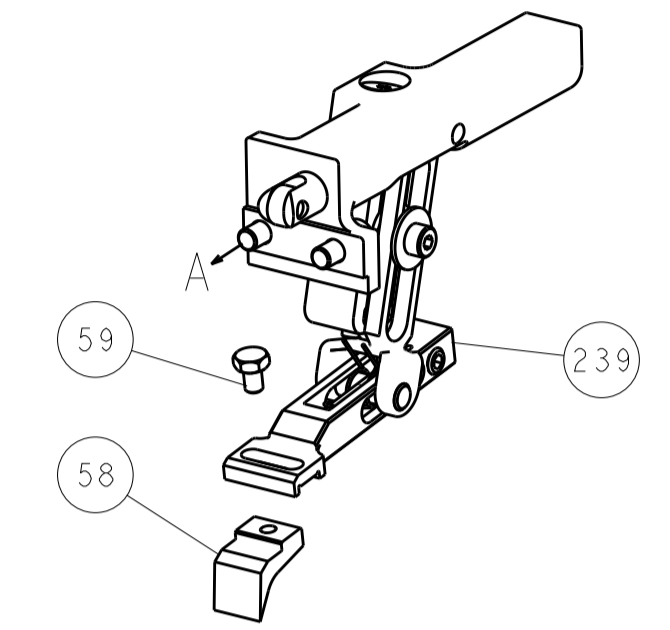
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



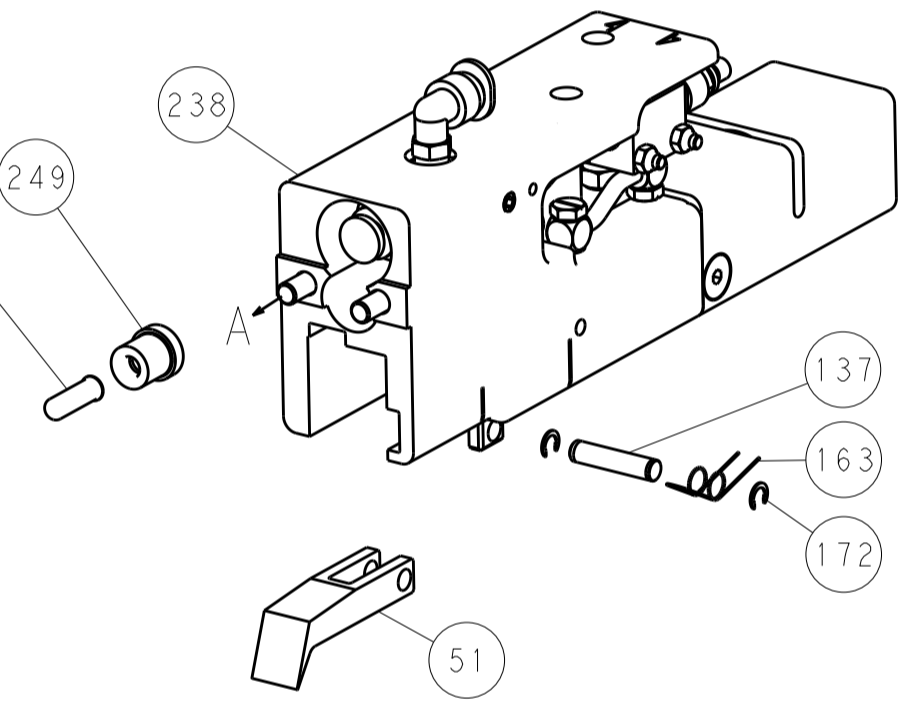
HOLDDOWN SET-UP



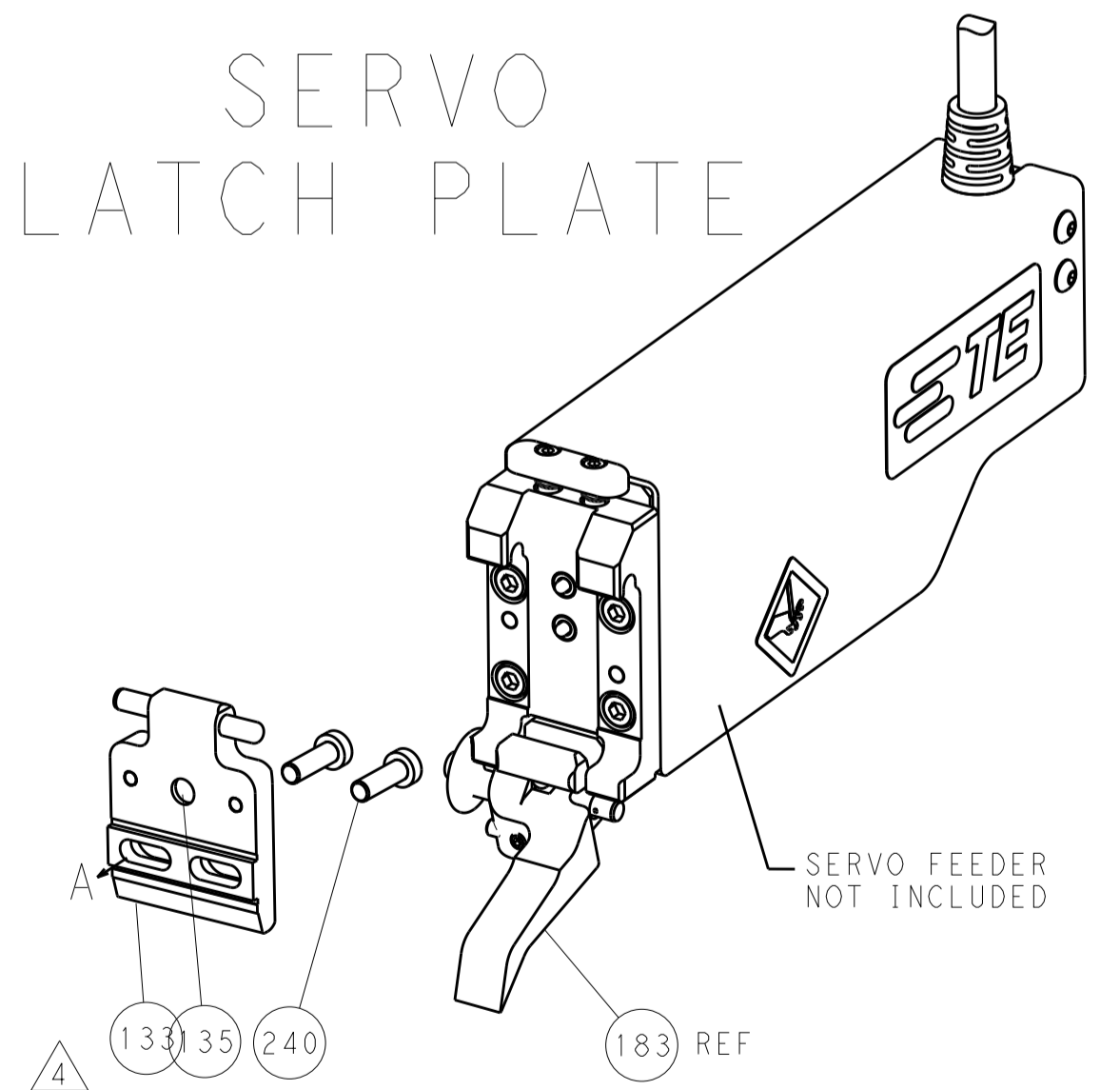
FEED TYPE
MECHANICAL



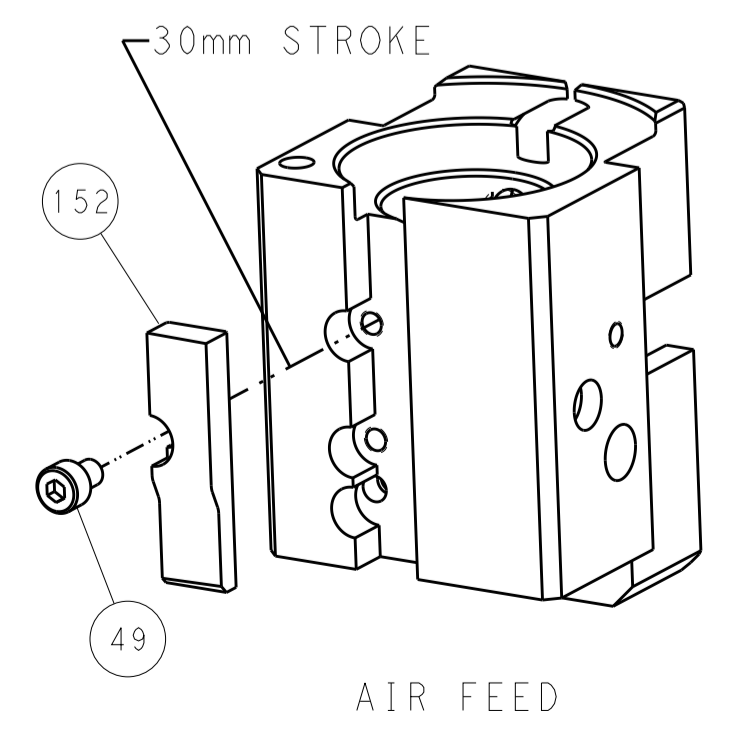
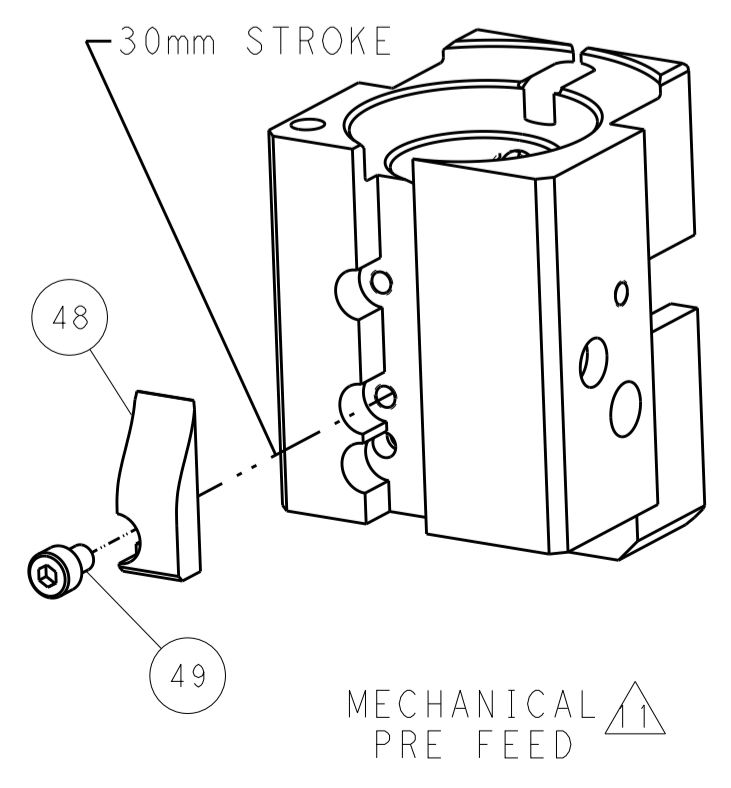
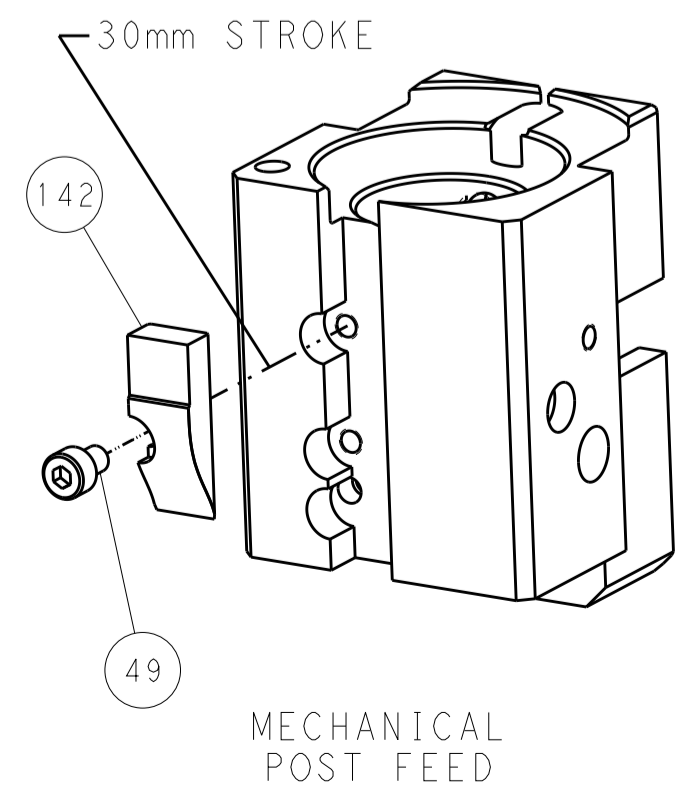
PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 02JUL2014		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	5 PLC ±0.0013	Harrisburg, PA 17105-3608
	ANGLES ±0.0013	FINISH		CHK: T. ELBIN 02JUL2014		NAME: Ocean End Feed Applicator	
MATERIAL:				APVD: D. STOUGH 02JUL2014		PRODUCT SPEC	
				APPLICATION SPEC		SIZE: CAGE CODE: DRAWING NO: A11 00779 C=2150456	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 4 OF 4 REV A	