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SET UP GAUGE 2119599-2. REVISONS table with columns: REVISION, DESCRIPTION, DATE, OWN, APPR.

APPLICATOR STYLE CONVERSION CHART. Table with columns: ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes WIRE, INSUL, and APPLICATOR INSTRUCTIONS.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION table with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION.

TERMINALS APPLIED table with columns: TE TERMINAL, TE TERMINAL, TE TERMINAL, TE TERMINAL.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING table with columns: WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT.

- 1. RECOMMENDED SPARE PARTS
2. GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET...
4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY...
5. ADJUSTMENT OF THE STRIPPER...
6. APPLY PART NUMBER 1-23419-5 LOCTITE...
7. GREASE THREADS...
8. MAGNET...
9. CRIMP HEIGHT REFERENCE SETTING...
10. SPARE FEED CAM STORAGE...
11. THE RECOMMENDED SET-UP...
12. WHEN ASSEMBLING -6 NON-CRIMP...
13. LUBRICATION RECOMMENDED...

*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.

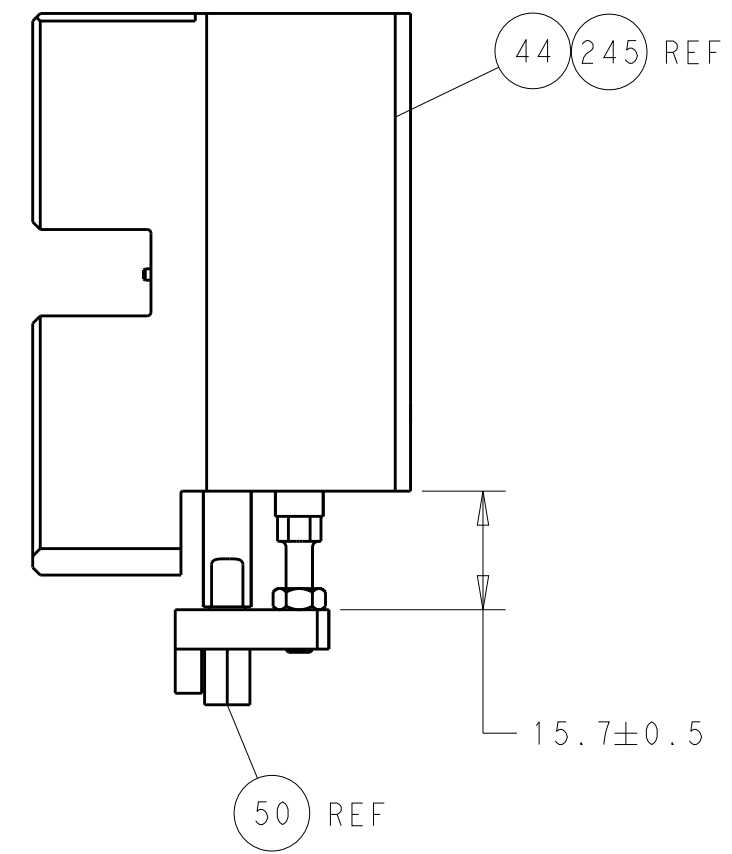
Table with columns: -77 -7 -6 -5 -2 -1 PART NO, DESCRIPTION, ITEM NO. Lists various components and their part numbers.

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

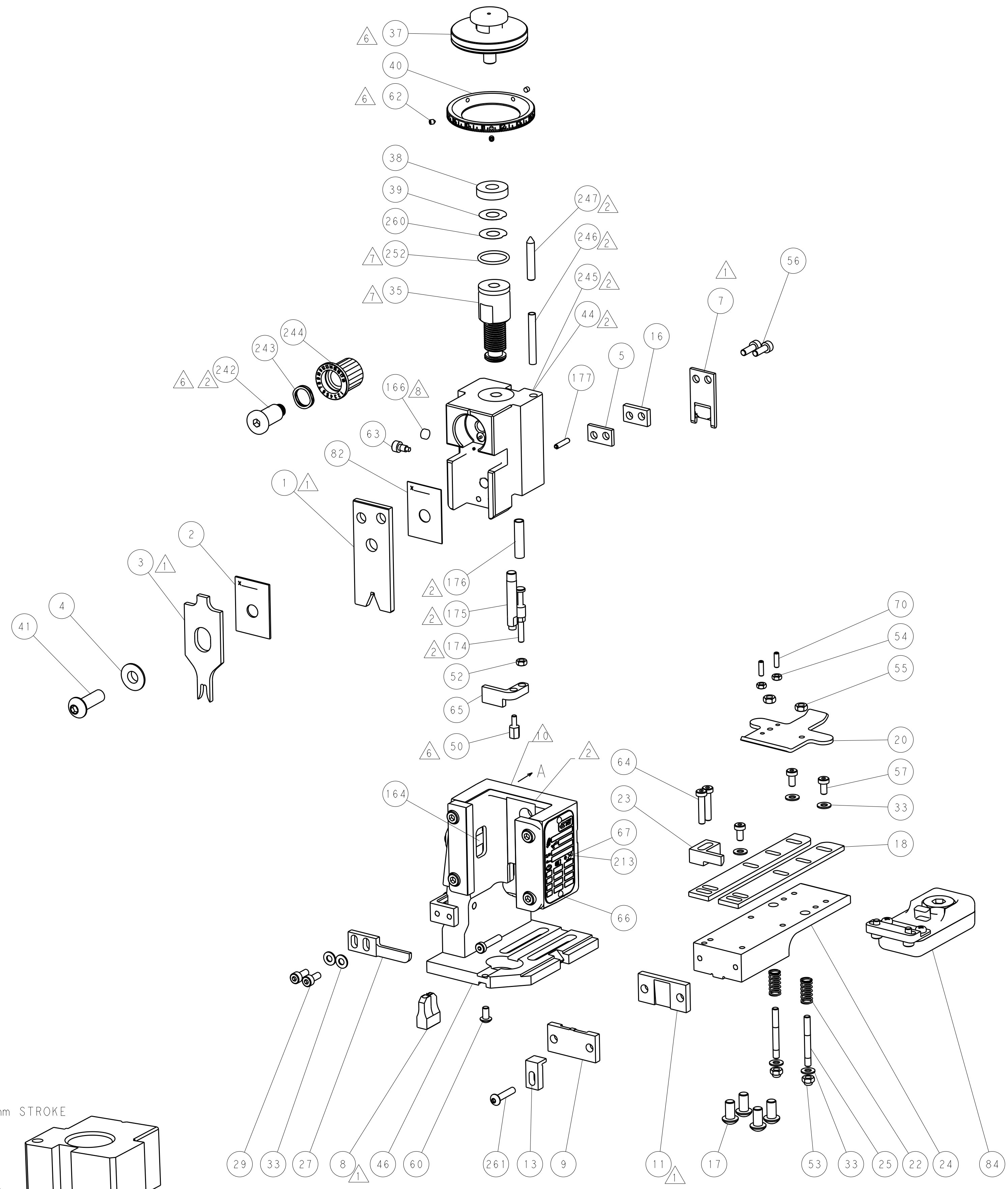
Large parts list table with columns: Part No, Description, Quantity, Item No. Lists various components like WASHER, RETAINER, SHCS, etc.

TE Connectivity logo and product information table including dimensions, tolerances, material, and finish.

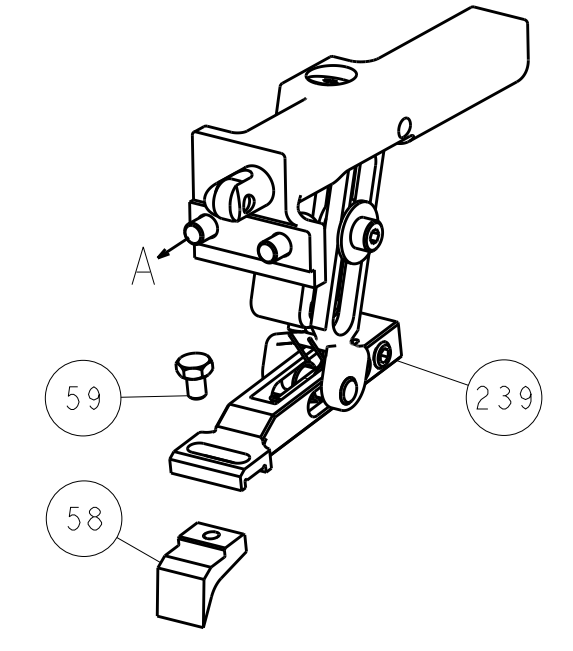
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



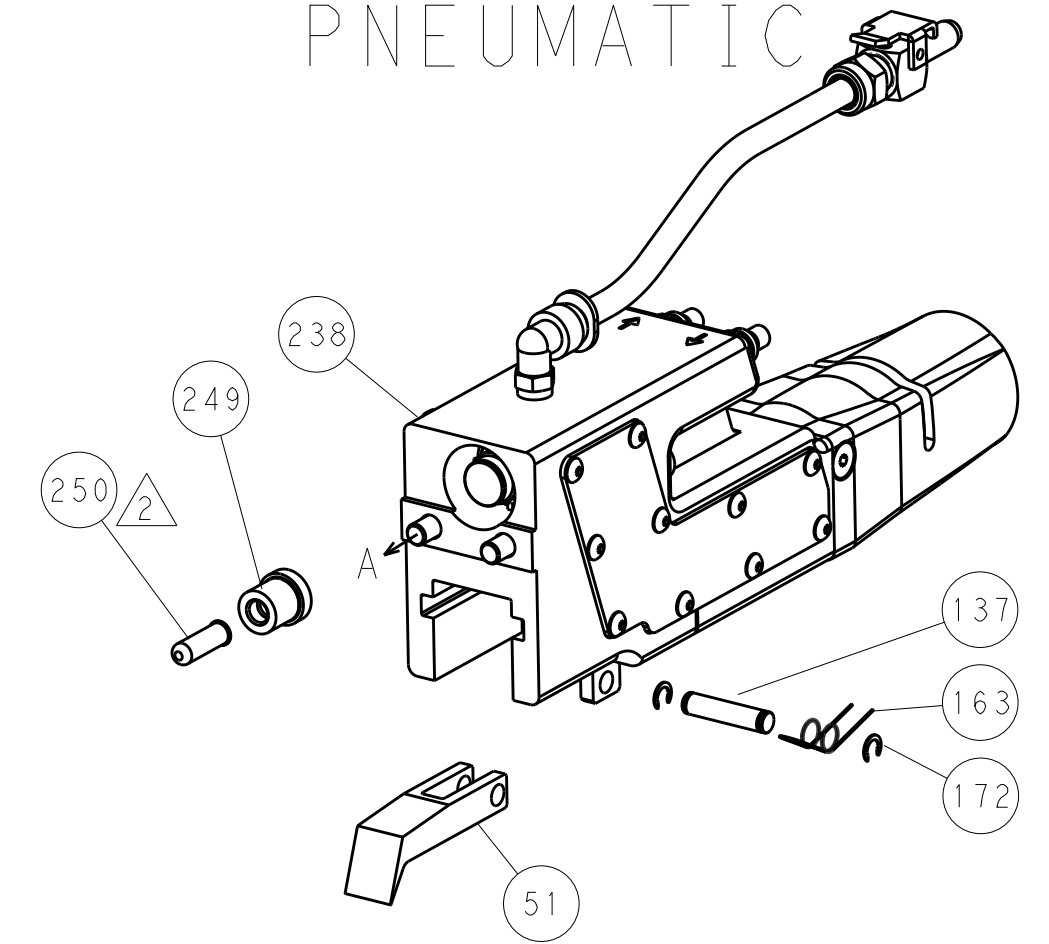
HOLDDOWN SET-UP



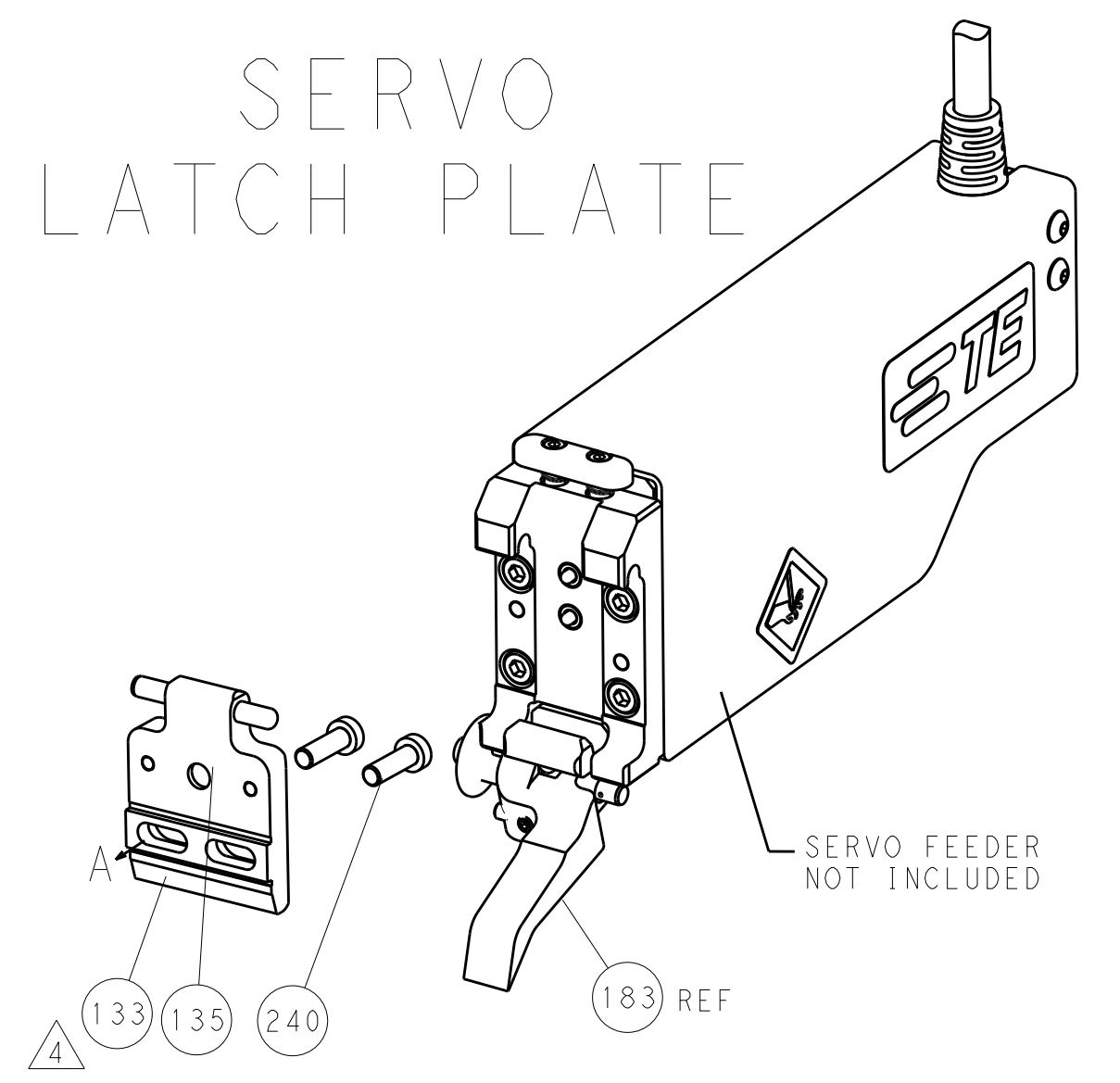
FEED TYPE
MECHANICAL



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 29NOV2011		TE Connectivity	
mm	0 PLC	±		CHK: G. HOFFNER 29NOV2011	NAME	Harrisburg, PA 17105-3608	
	1 PLC	±		APPV: T. ELBIN 29NOV2011	PRODUCT SPEC	Ocean End Feed Applicator	
	2 PLC	±			APPLICATION SPEC	-	
	3 PLC	±			SIZE	CAGE CODE	DRAWING NO
	4 PLC	±			ANGLES	A11 00779	©=2150016
MATERIAL	FINISH	WEIGHT		Customer Accessible Production Drawing	SCALE	1:1	SHEET 2 OF 4
							REV K

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150016-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150016-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150016-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150016-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150016-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150016-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150016-5	K	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					-	-	-	-	-	-	-
	2-2150016-7	K	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150016-7	H	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON .250 SERIES			
WIRE STRIP LENGTH 6.00-6.80 mm [.236-.268 IN]		INSULATION DIAMETER RANGE Ø3.05-4.31 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63306-1	60713-1	42660-1	1217393-1
63306-2	60713-2	42660-2	63985-1
42400-1	350981-2	60650-1	63674-1
42400-2	42219-1	60650-2	1742948-1
42400-3	42219-2	60650-3	1742971-4
1742198-1	154692-1	1217272-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85+/-0.05 [.073+/-0.002]	7.5
(1)18 & (1)16	1.85+/-0.05 [.073+/-0.002]	7.5
(2)18	1.73+/-0.05 [.068+/-0.002]	9.0
16 OR (1)20 & (1)18	1.63+/-0.05 [.064+/-0.002]	10.0
18 AWG	1.47+/-0.05 [.058+/-0.002]	11.7

- 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: 8-2150016-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150016-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150016-5
- 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 50, 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.
- LUBRICATION RECOMMENDED FOR ALL TERMINALS. REFER TO APPLICATOR INSTRUCTION SHEED FOR LUBRICATION INFORMATION.

***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 1	2079383-5 SCR, BHSC, RoHS (M4 X 20)	261
- 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	2119082-9 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
-77-27-25-22-21	PART NO	DESCRIPTION

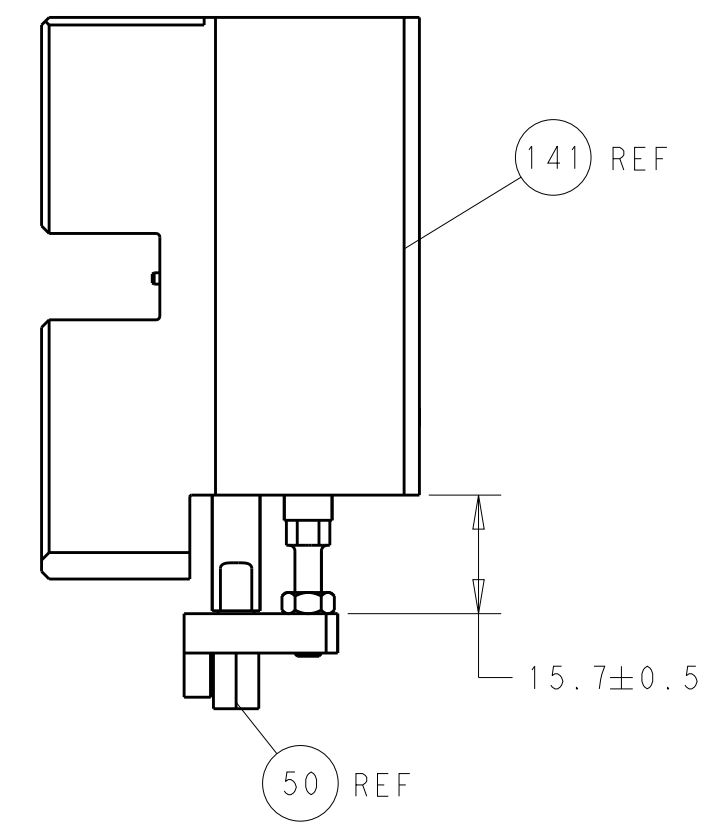
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

- - 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
- 1 1 1 1	6-9931111-6	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
- 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	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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
- - - 1 -	2119792-2	PAWL, EF, AIR	51
- 1 1 1 1	1-1752354-4	STANDOFF, HOLD-DOWN	50
- - - 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	2119644-2	RAM WASHER, PRECISION	38
- 7 7 7 7	1-18028-2	WASHER, FLAT, REG M4	33
- 1 1 1 1	2168400-5	SHCS, LOW HEAD, 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	1752371-1	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	1901259-6	GUIDE, LOWER STRIP	18
- 1 1 1 1	240641-1	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	690495-4	PLATE, FRONT SHEAR	9
- 1 1 1 1	3-1803000-1	ANVIL, COMBINATION, END FEED	8
- 1 1 1 1	1-2217206-4	BLADE, SLUG	7
- 1 1 1 1	1-240641-6	SPACER	5
- 1 1 1 1	238009-1	BLOCK, FL CRIMPER SPACER	4
- 1 1 1 1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
- 1 1 1 1	1-455888-0	SPACER, CRIMPER	2
- 1 1 1 1	1-1633730-9	CRIMPER, WIRE	1
-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO
-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO

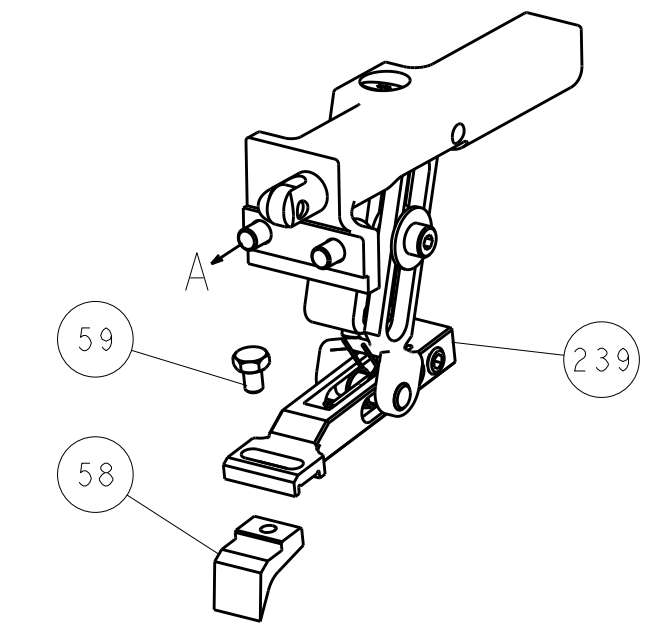
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	BY	APPV	NAME
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	29NOV2011	B. WEAVER	G. HOFFNER	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	SCALE	SHEET	OF	REV
		A1	00779	3	4 K

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

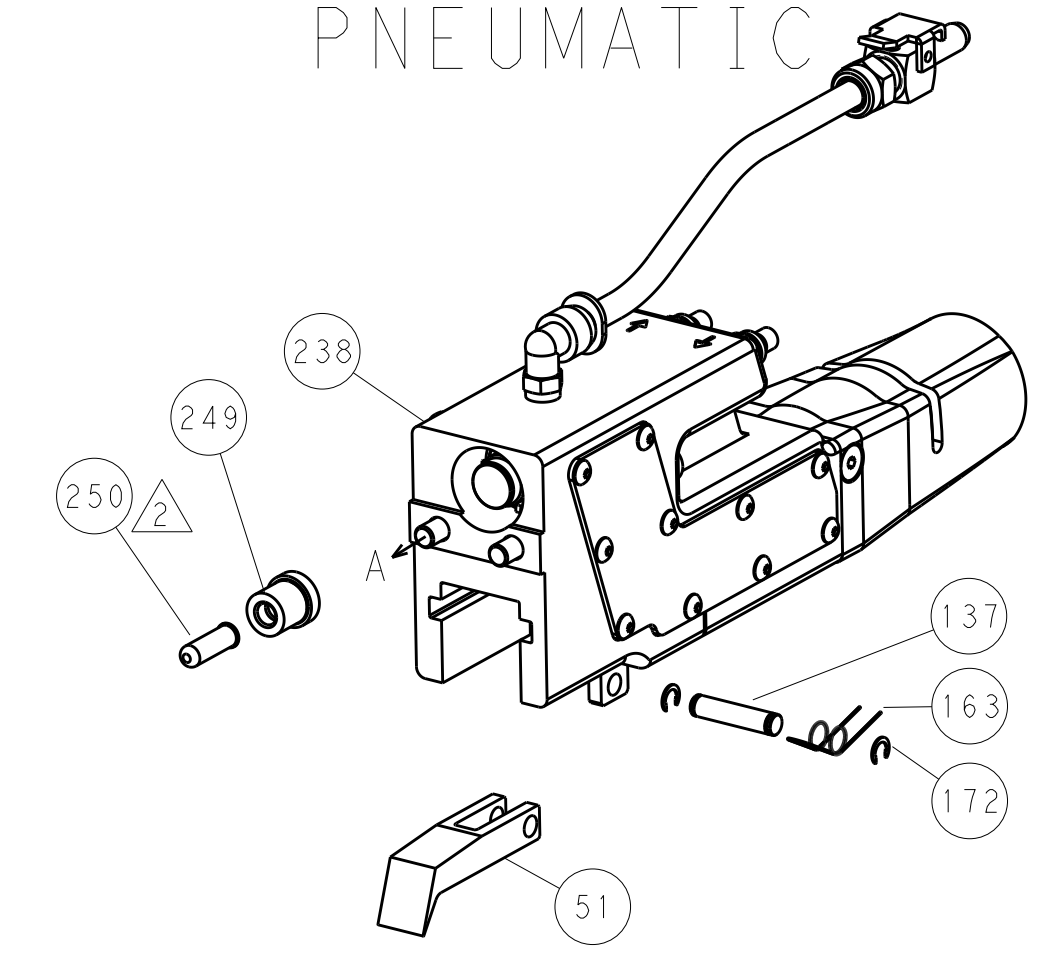


HOLDDOWN SET-UP

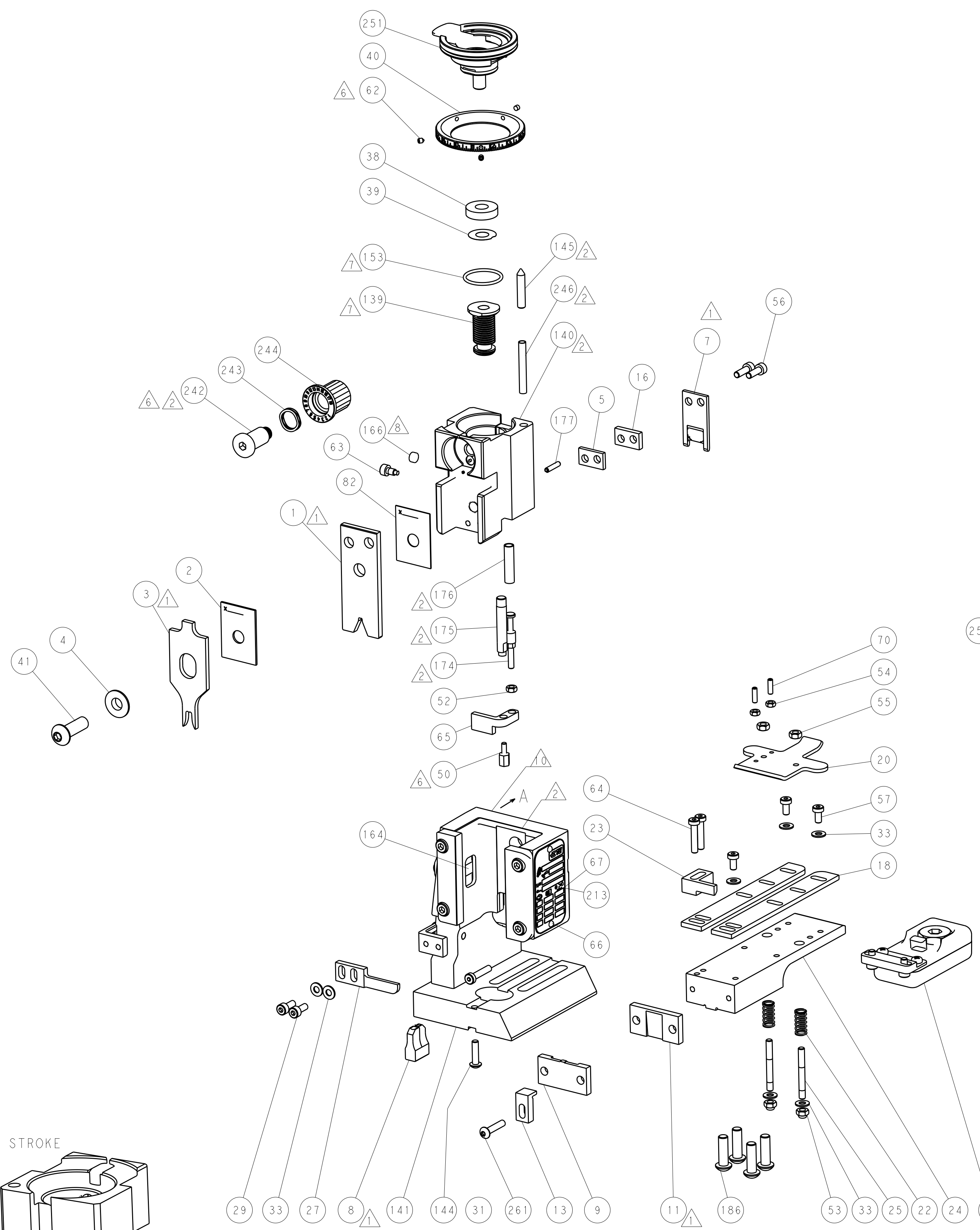
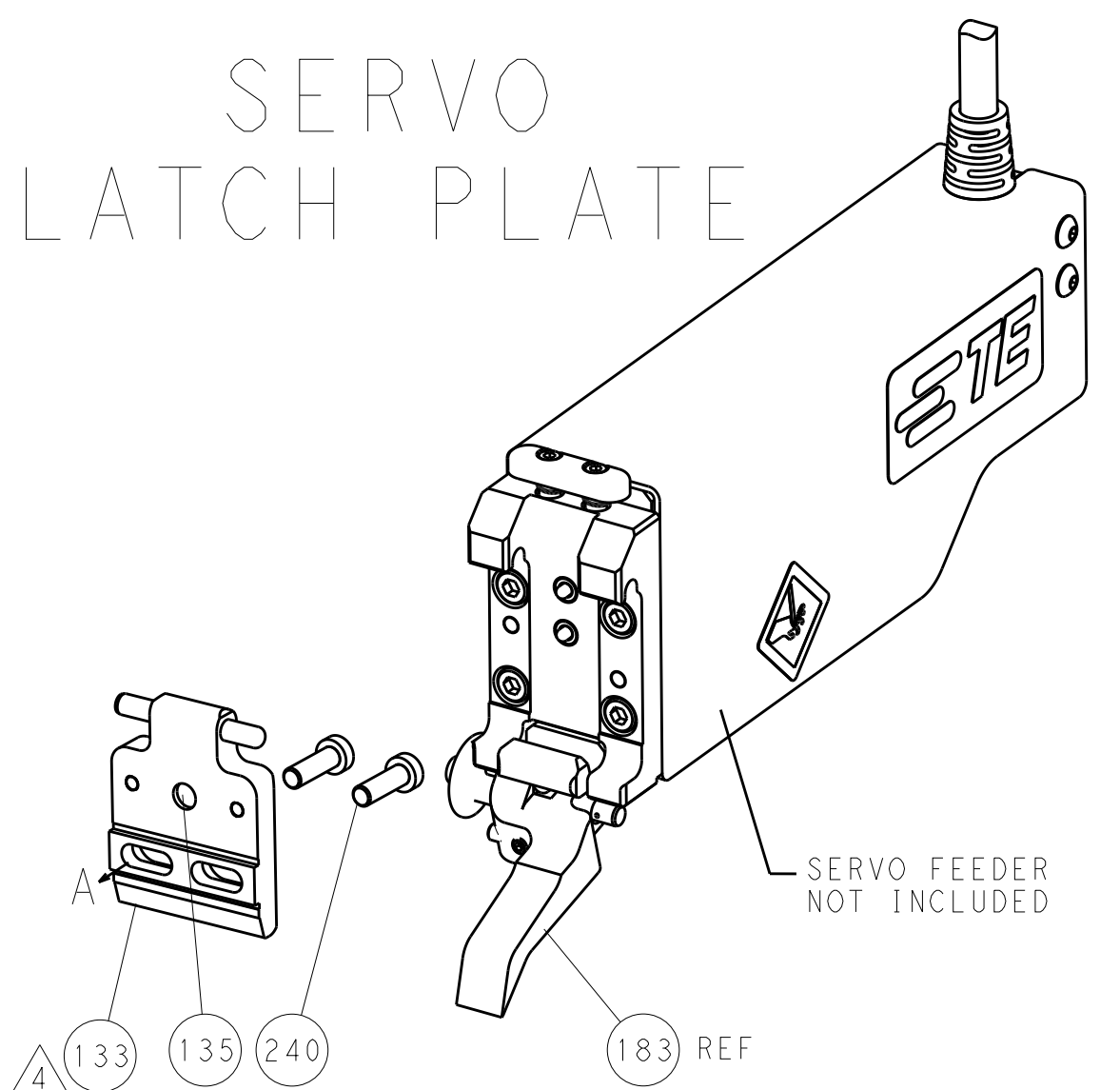
FEED TYPE
MECHANICAL



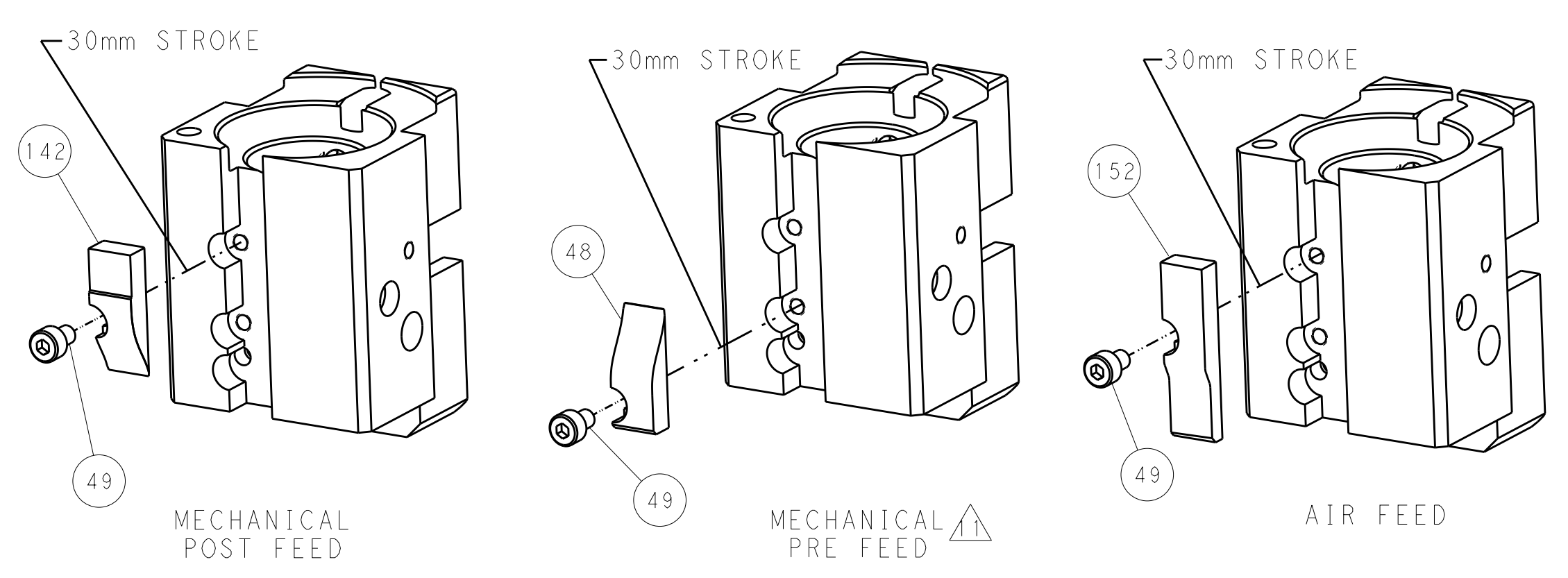
PNEUMATIC



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)

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mm	0 PLC	±		CHK: G. HOFFNER 29NOV2011	NAME: Ocean End Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: T. ELBIN 29NOV2011	SIZE: CAGE CODE: DRAWING NO:		RESTRICTED TO
	2 PLC	±			A11 00779 C=2150016		
	3 PLC	±			Customer Accessible Production Drawing		
	4 PLC	±			SCALE: 1:1 SHEET 4 OF 4 REV K		
MATERIAL:	FINISH:	WEIGHT:					