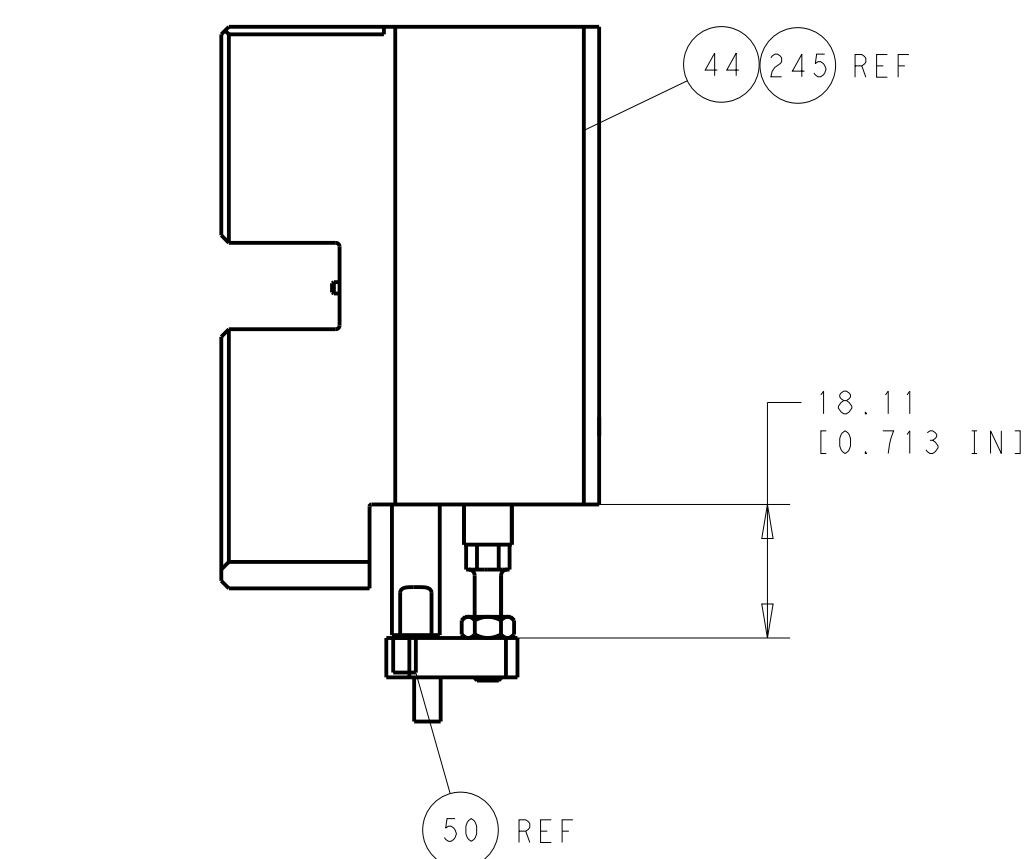
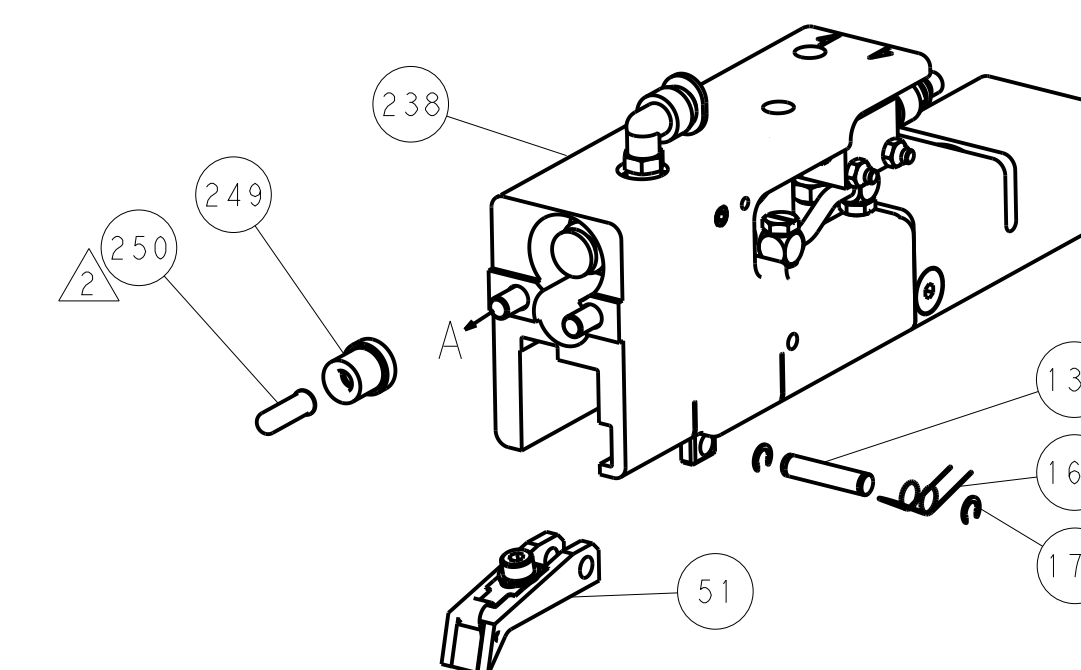
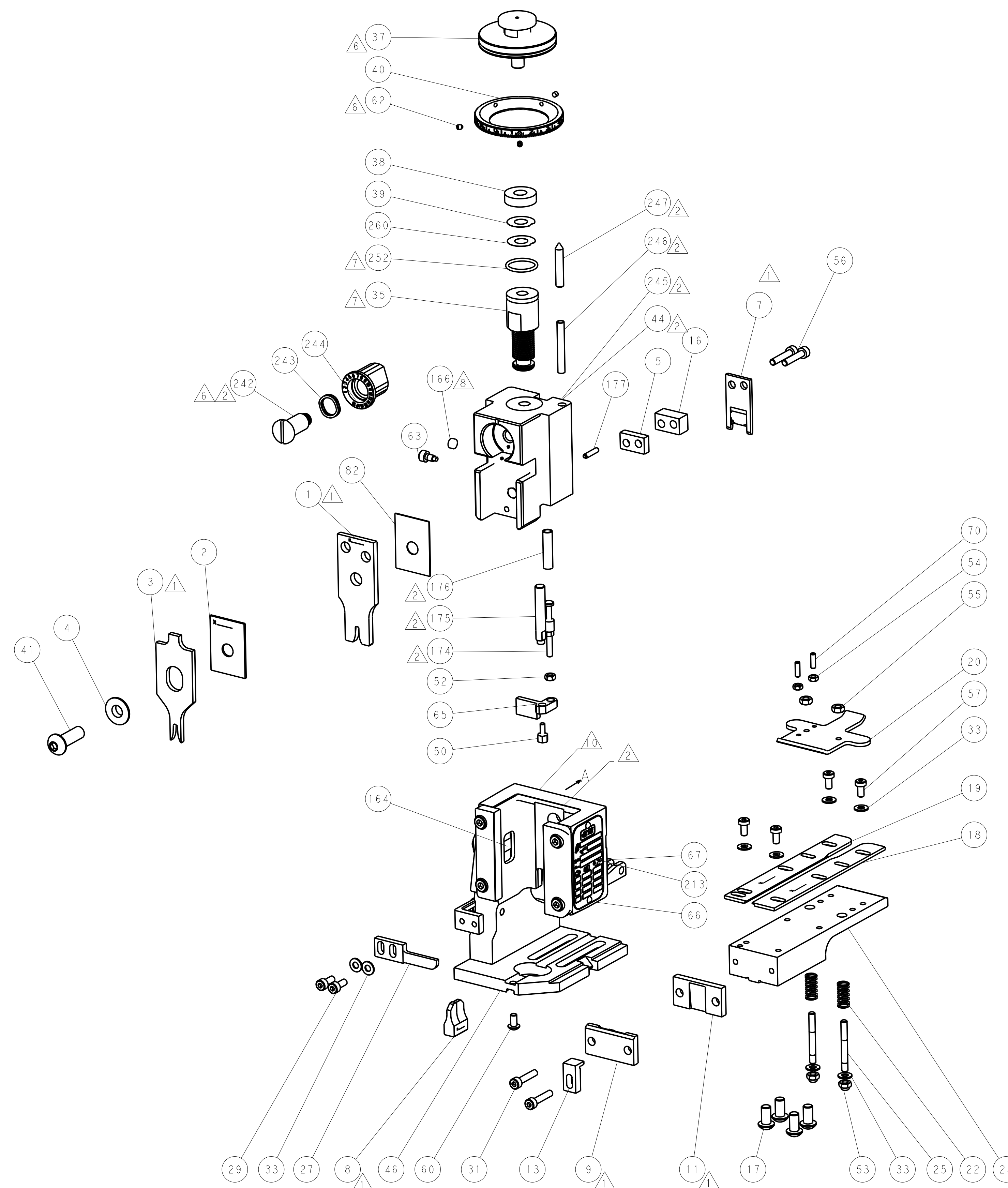


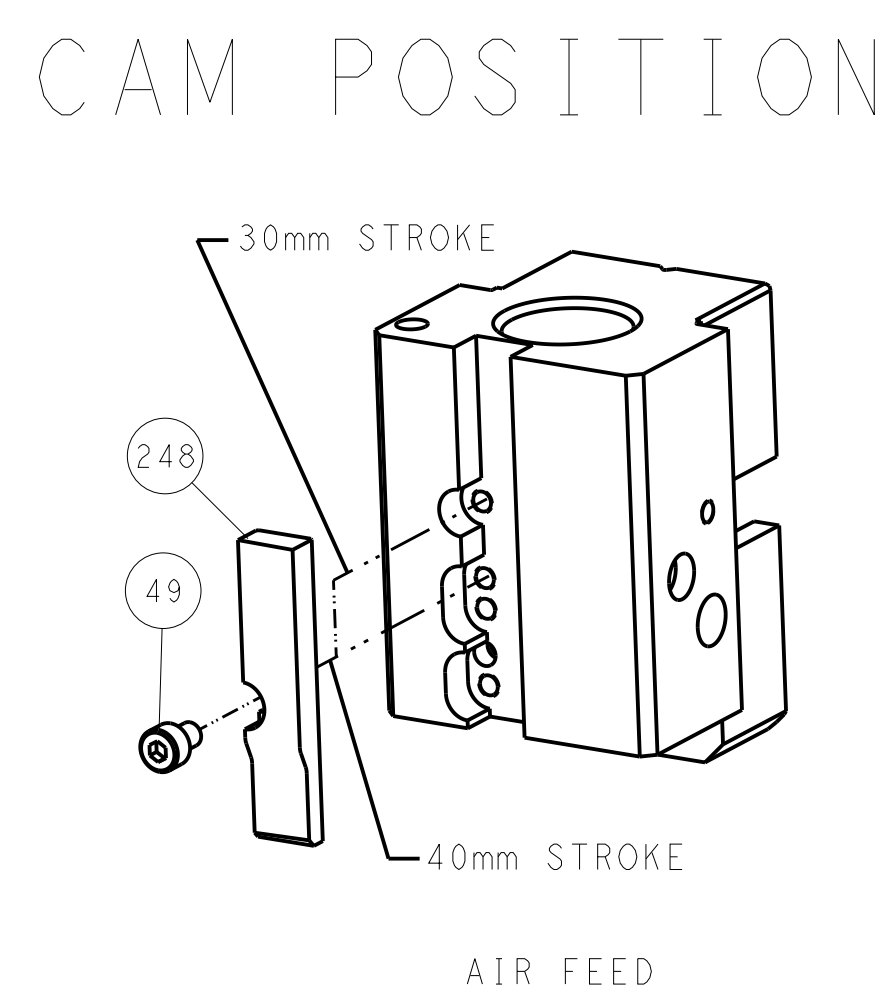


HOLDDOWN SET-UP



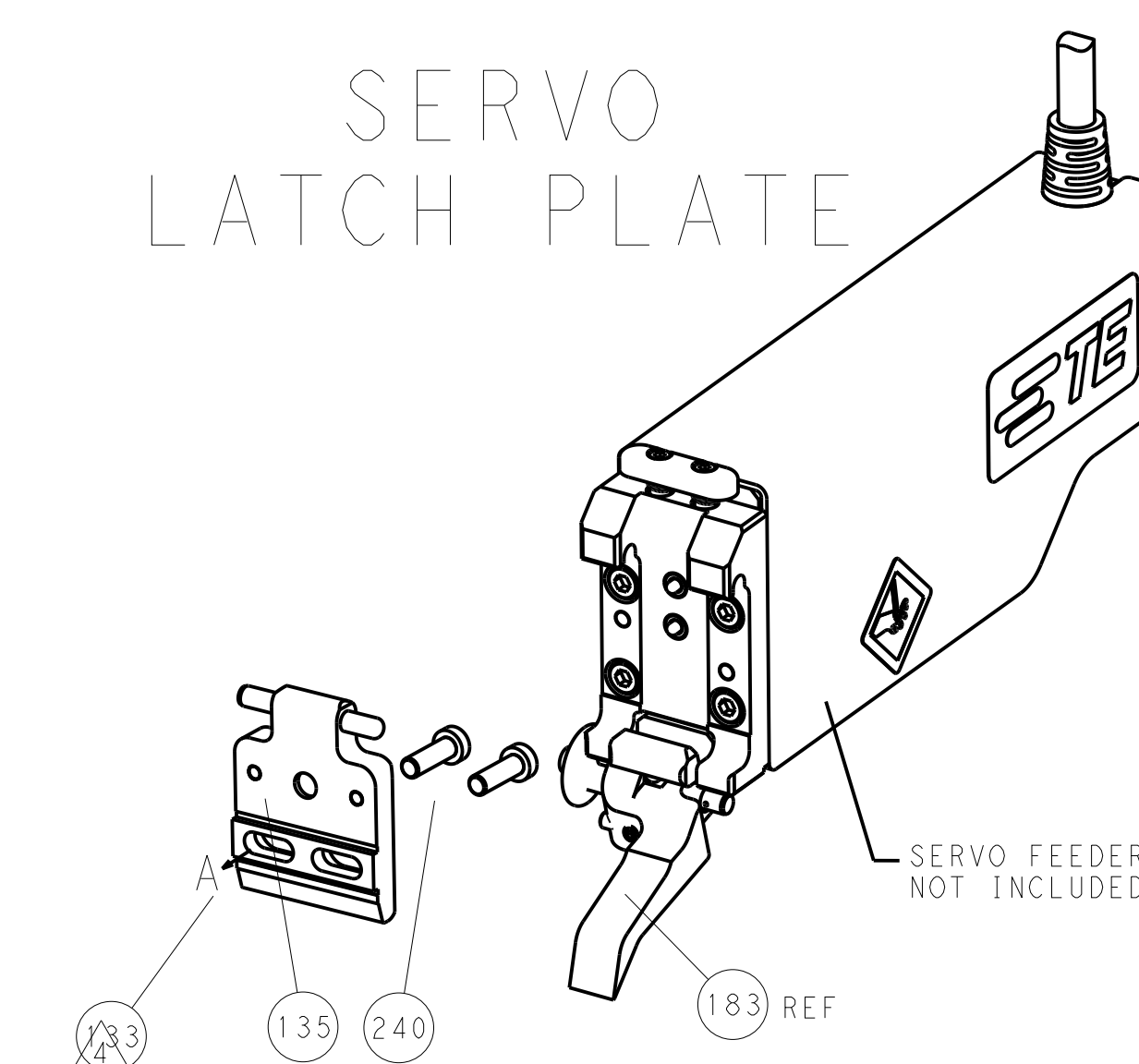
FEED TYPE

PNEUMATIC



CAM POSITION

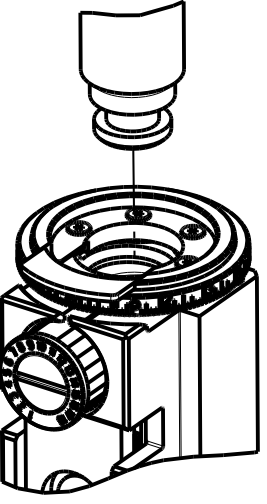
AIR FEED

SERVO
LATCH PLATE

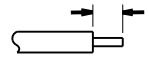
✓ SERVO FEEDER
NOT INCLUDED

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR YOUR COMPANY'S PROPRIETARY INFORMATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION MUST BE NOTIFIED FOR THE LATEST REVISION.		DWN Y YIN 160C2103 CHK G BAILEY 160C2103 APVD W GUO 160C2103		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH		NAME Ocean End Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO RESTRICTED TO A 00779 C=2150389 -	
MATERIAL -		WEIGHT -		SCALE 1:1 SHEET 2 OF 4 REV A	
Customer Accessible Production Drawing					

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150389-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
	2-2150389-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150389-5	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150389-4	-	-
	2-2150389-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-
	7-2150389-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.36 mm [.093]	F
INSUL	3.20 mm [.126]	OV
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: G&H TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 X 0.8 TAB			
WIRE STRIP LENGTH 5.20-5.80 mm [.205-.228 IN]		 INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	LEAR Rev 1	-	-
TERMINALS APPLIED	-	-	-
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1949263-1	26512.201.179	1949263-2	26512.126.009

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
0.5+0.5		1.45+/-0.05 [.057+/- .002]		5.7
1.00mm2		1.45+/-0.05 [.057+/- .002]		5.7
0.75mm2		1.35+/-0.05 [.053+/- .002]		6.8
0.50mm2		1.30+/-0.05 [.051+/- .002]		7.2



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150389-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150389-5
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 ITEMS 50, 62 & 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

-	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	PART NO	DESCRIPTION				ITEM NO

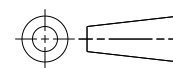
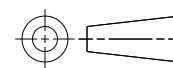
PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

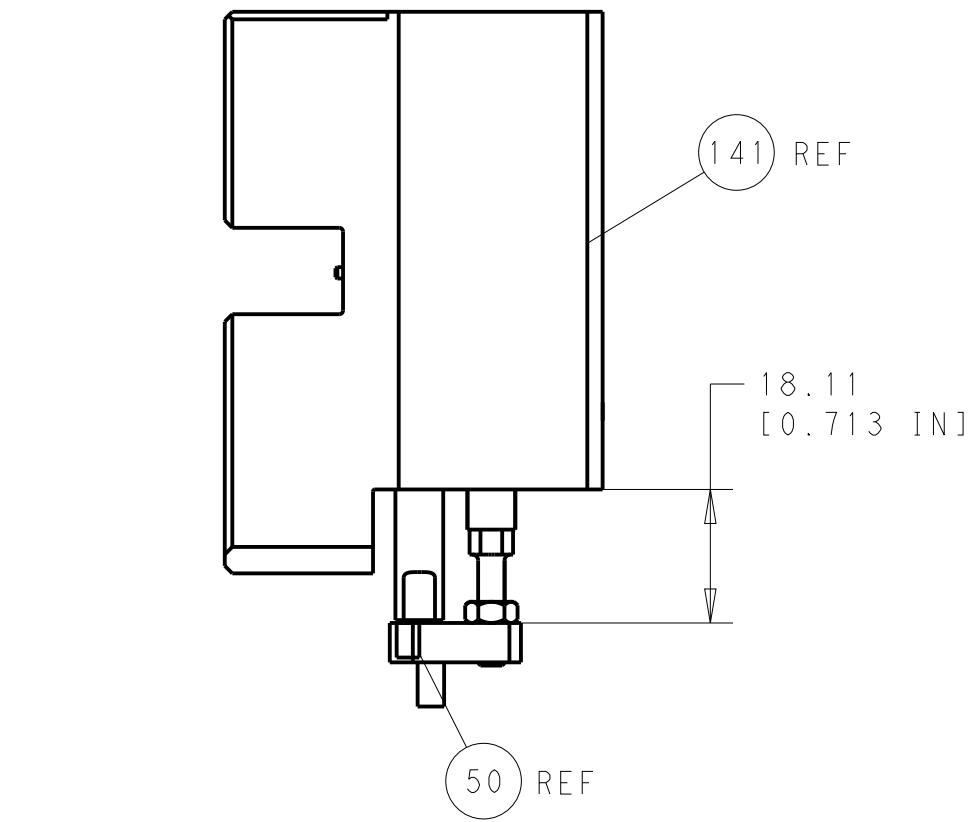
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS						
			P	LTR	DESCRIPTION	DATE	OWN	APVD	
			-	-	SEE SHEET 1	-	-	-	-

-	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
⁶ -	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	2063440-2	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG,IDENTIFICATION	213
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	1901697-1	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, .801 ID, .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	455888-5	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	1976052-1	HOLDDOWN,TERMINAL	65
⁶ -	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
-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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
⁶ -	-	-	1	2031314-1	FEED FINGER SUBASSEMBLY	51
-	1	1	1	1752354-3	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	2119644-1	RAM WASHER, PRECISION	38
-	8	8	8	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1752373-4	DRAG	20
-	1	1	1	1901696-3	STRIP GUIDE, REAR	19
-	1	1	1	1901695-3	STRIP GUIDE, FRONT	18
-	1	1	1	5-240641-6	SPACER	16
-	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
¹ -	1	1	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
¹ -	1	1	1	3-690482-2	PLATE, FRONT SHEAR	9
¹ -	1	1	1	1803060-4	ANVIL, COMBINATION, END FEED	8
¹ -	1	1	1	1-2217206-1	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	2-240641-9	SPACER	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
¹ -	1	1	1	4-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1-455888-0	SPACER, CRIMPER	2
¹ -	1	1	1	5-1673600-2	CRIMPER, WIRE	1
-77-27-25-22	PART NO	DESCRIPTION				ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ORGANIZATION WHICH IT IS ISSUED BY. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ORGANIZATION WHICH IT IS ISSUED BY.				OWN Y. YIN	16OCT2013	 TE Connectivity Harrisburg, PA 17105-3608	
				CHK G. BAILEY	16OCT2013		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD H. GUO	16OCT2013	NAME Ocean End Feed Applicator	
		6 PLC ±.1		PRODUCT SPEC		SIZE A1	
		2 PLC ±0.5		APPLICATION SPEC			
		2 PLC ±0.13		WEIGHT		CAGE CODE	
		4 PLC ±0.0001		-		DRAWING NO	
MATERIAL		FINISH		Customer Accessible Production Drawing		RESTRICTED TO	
-		-		SCALE 1:1		SHEET 3 OF 4	
				REV A			

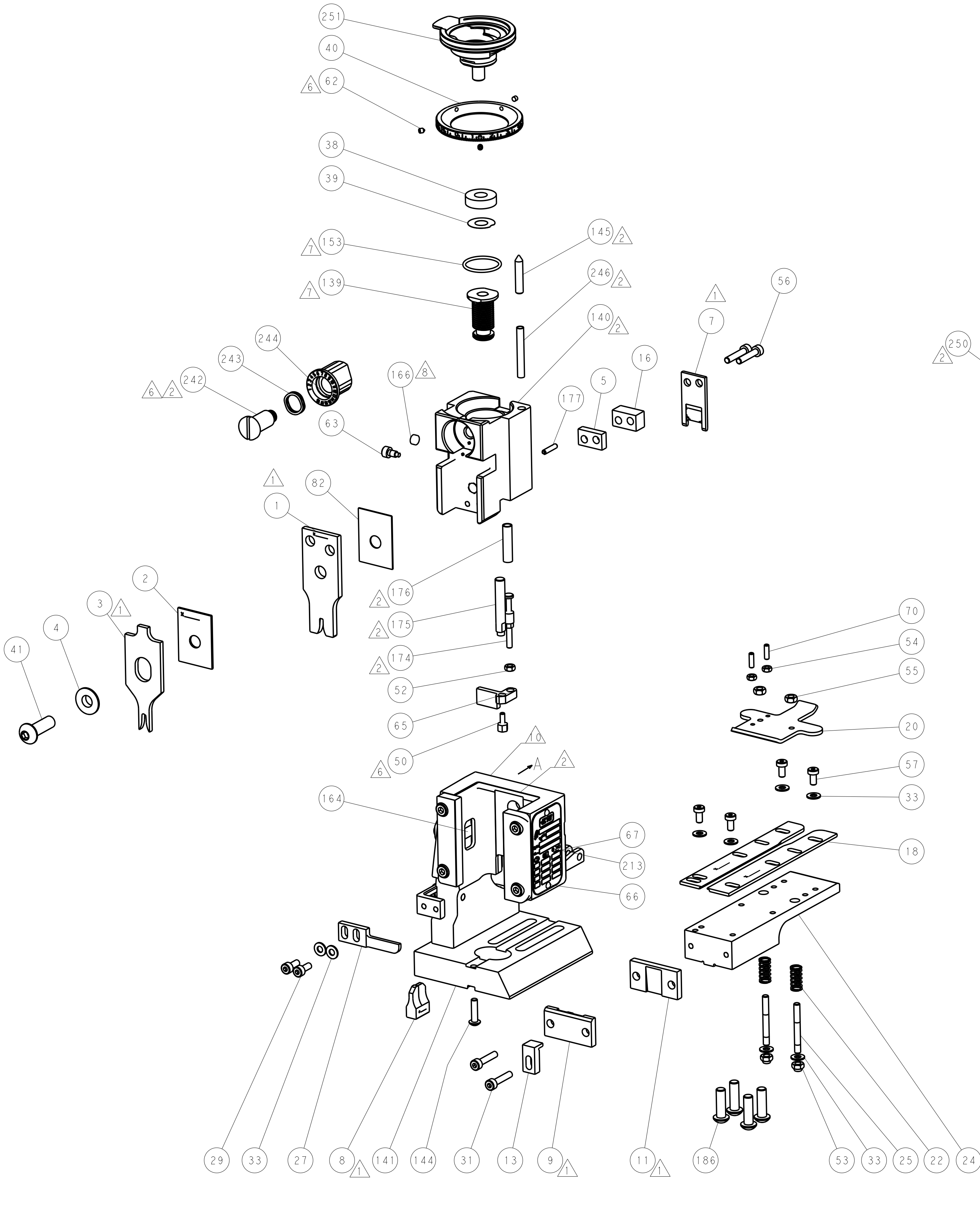
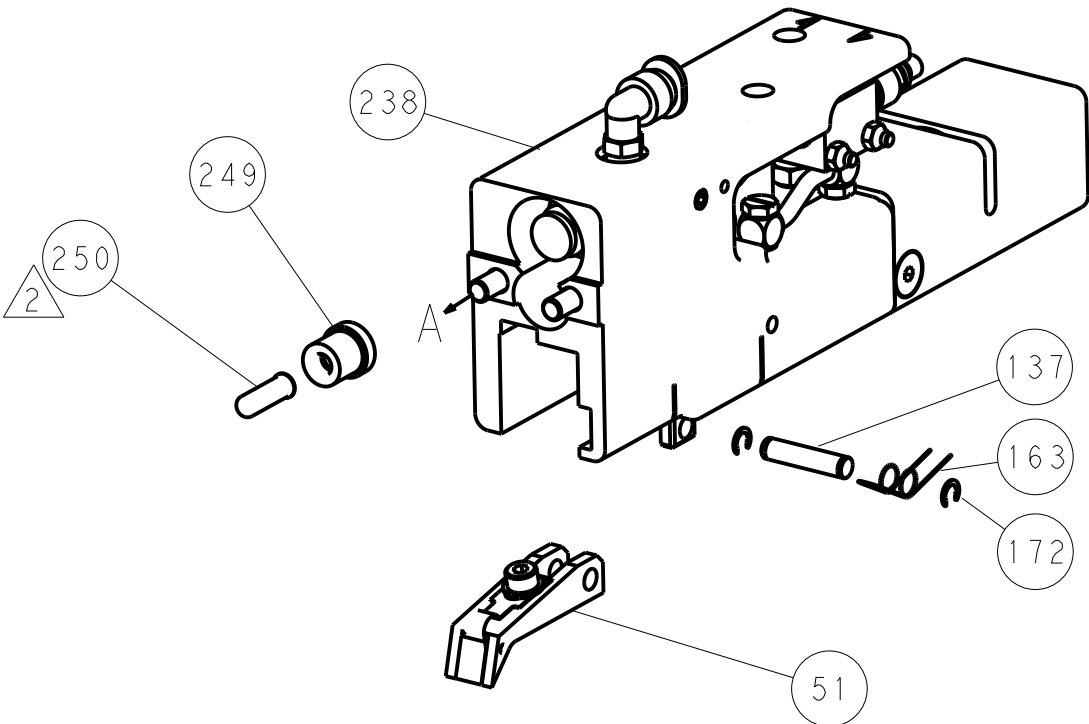
LOC	DIST	REVISIONS			
		P	LTR	DESCRIPTION	DATE
A	66	-	-	SEE SHEET 1	-



HOLDDOWN SET-UP

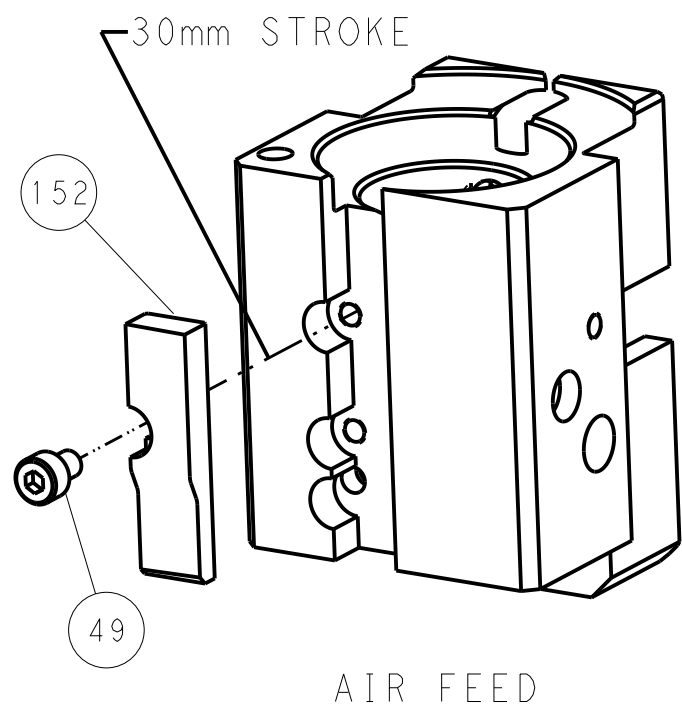
FEED TYPE

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 Y. YIN 16OCT2013		STE TE Connectivity	
mm		0 PLC ±.5		CHK G. BAILEY 16OCT2013		Harrisburg, PA 17105-3608	
		1 PLC ±0.13		APVD H. GUO 16OCT2013		NAME Ocean End Feed Applicator	
MATERIAL		FINISH		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=2150389	
				WEIGHT		Customer Accessible Production Drawing	
				SCALE 1:1		SHEET 4 OF 4	
						REV A	