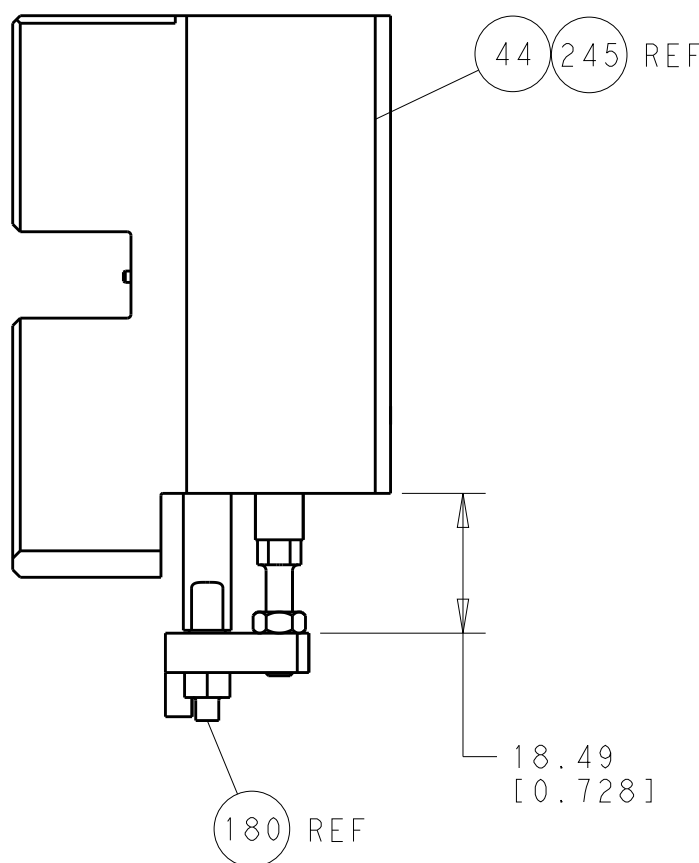
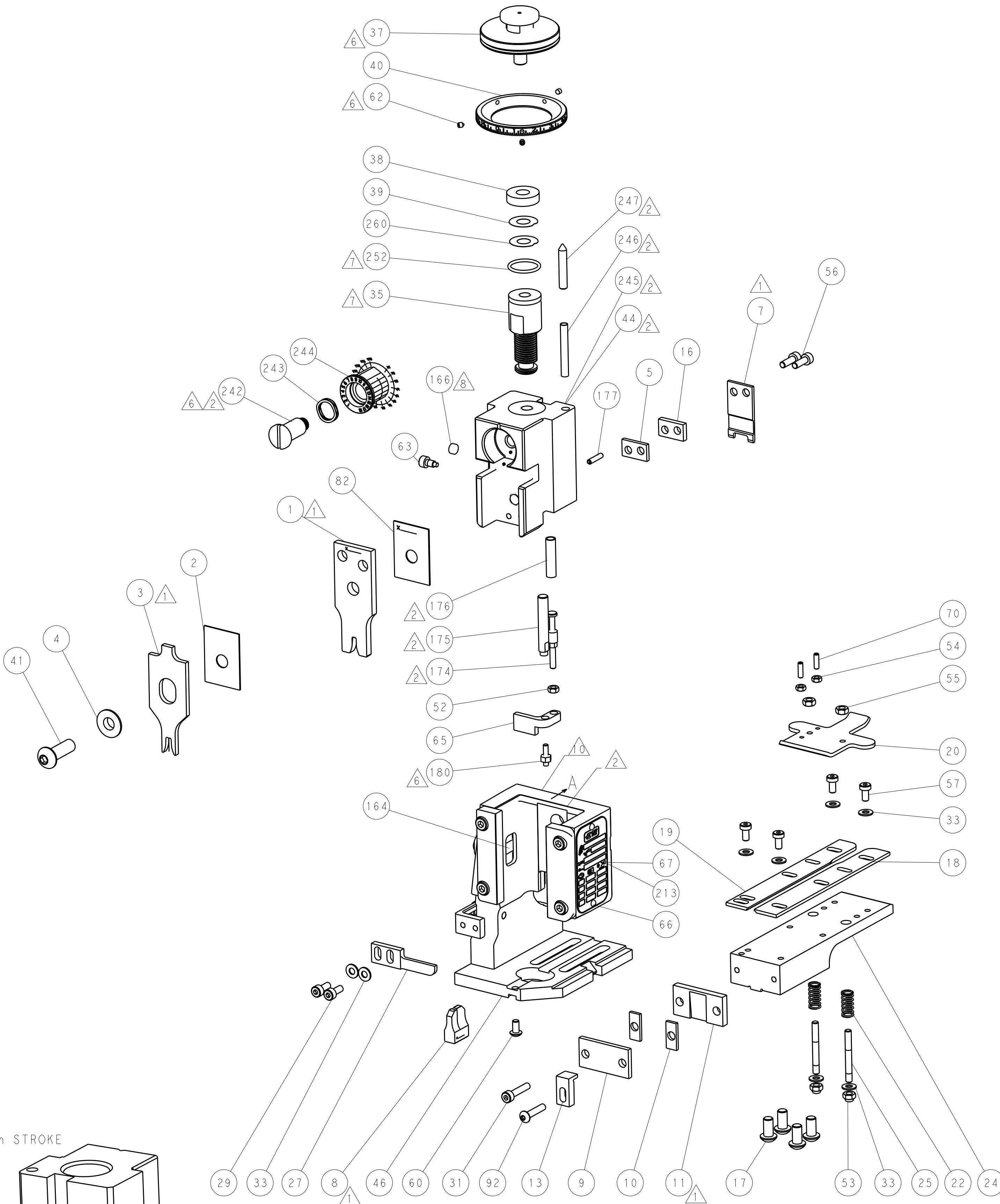


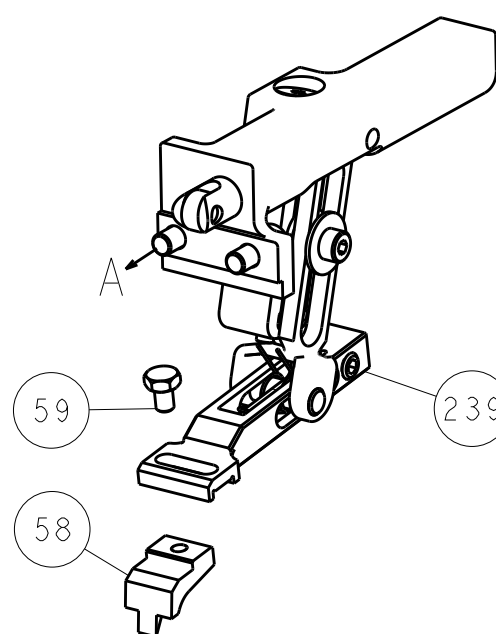
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A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



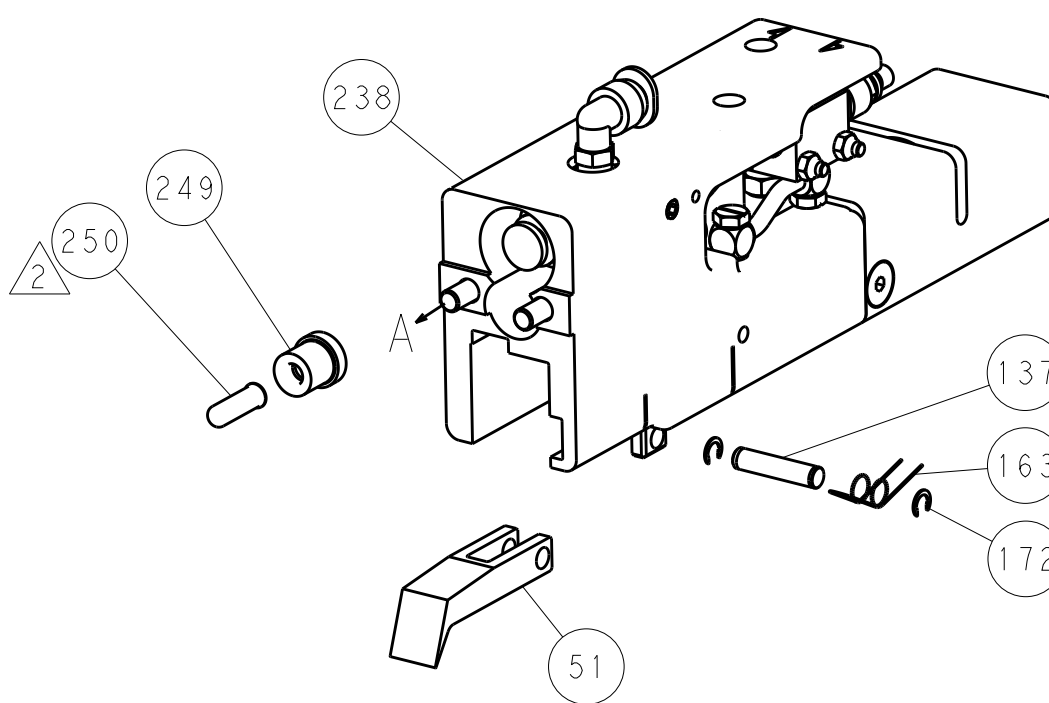
HOLDDOWN SET-UP



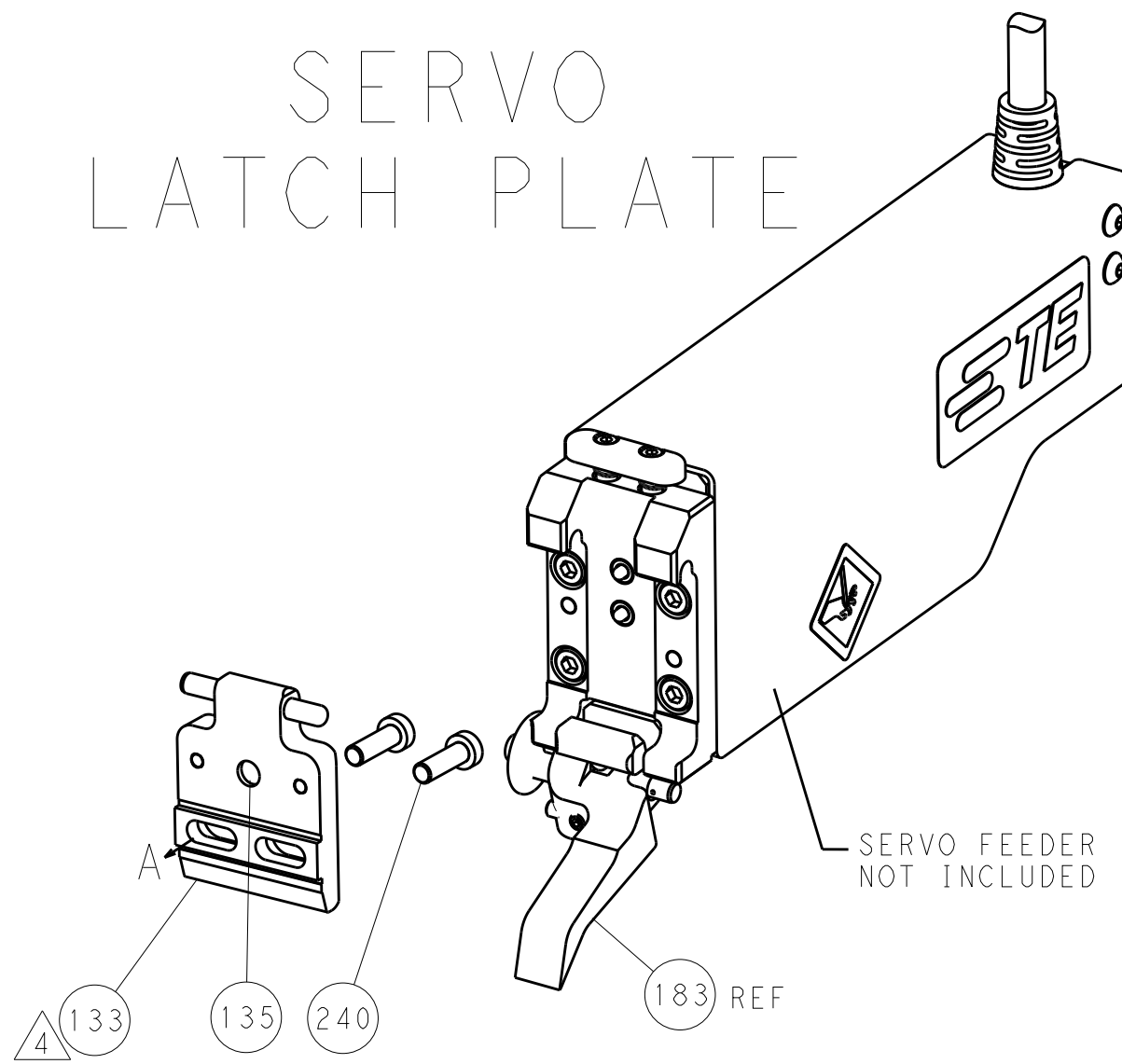
FEED TYPE
MECHANICAL



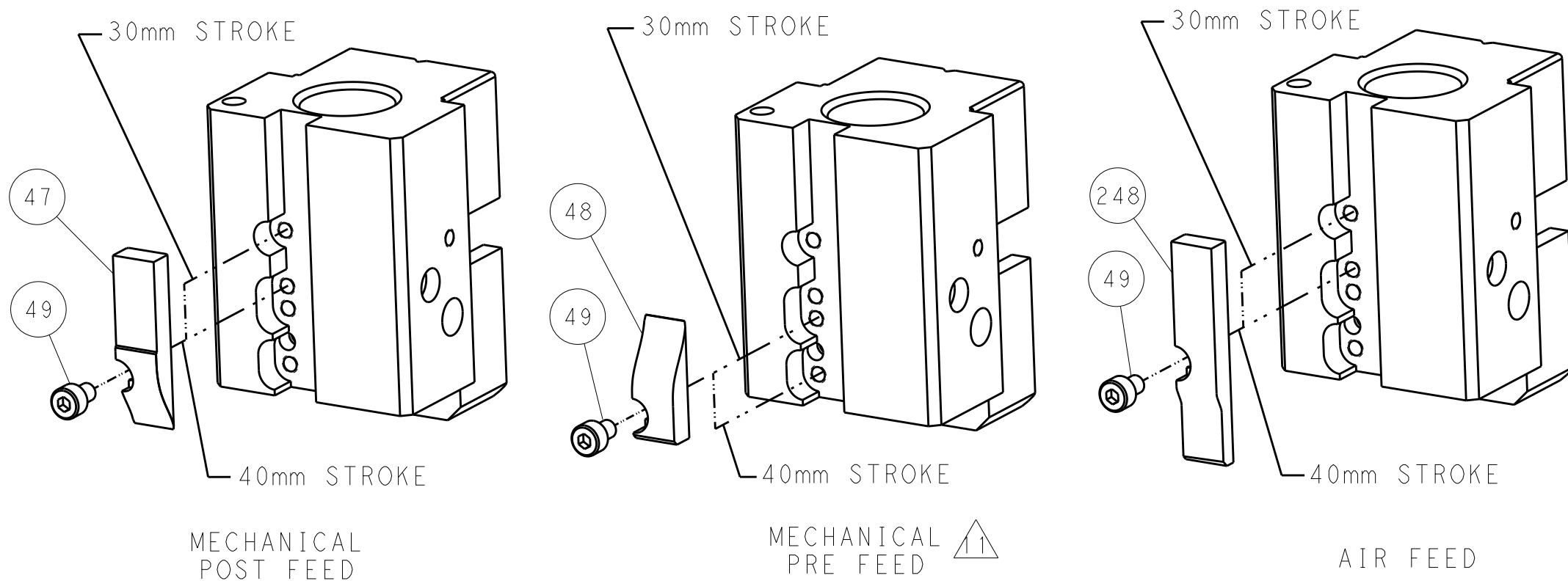
PNEUMATIC



SERVO
LATCH PLATE

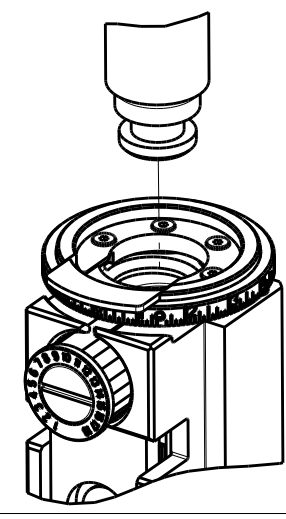


CAM POSITIONS



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:		DWN		TE Connectivity	
mm		0 PLC ±.5		01JUN2011		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		01JUN2011		NAME	
H		2 PLC ±0.13		01JUN2011		PRODUCT SPEC	
L		3 PLC ±0.013		01JUN2011		APPLICATION SPEC	
W		4 PLC ±0.0001		01JUN2011		SIZE	
A		ANGLES ±.0001		01JUN2011		CAGE CODE	
FINISH		FINISH		01JUN2011		DRAWING NO	
MATERIAL		MATERIAL		01JUN2011		RESTRICTED TO	
Customer Accessible Production Drawing		Customer Accessible Production Drawing		01JUN2011		SCALE	
1:1		1:1		01JUN2011		SHEET	
2 of 4		2 of 4		01JUN2011		REV	
C		C		01JUN2011		REV	

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2150380-1	C	FINE CRIMP HEIGHT ADJUST
	2-2150380-2	C	FINE CRIMP HEIGHT ADJUST
	2-2150380-5	C	FINE CRIMP HEIGHT ADJUST
	2-2150380-7	C	FINE CRIMP HEIGHT ADJUST
	7-2150380-7	A	CRIMP TOOLING KIT
APPLICATOR DATA			
CRIMP	SIZE	TYPE	
WIRE	2.79 mm [.110]	F	
INSUL	4.06 mm [.160]	F	
APPLICATOR INSTRUCTIONS			
408-10390			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 5.08-5.97 mm [.200-.235 IN]		INSULATION DIAMETER RANGE Ø2.54-3.56 mm [.100-.140 IN]	
TERMINAL APPLICATION SPECIFICATION			
114-2084			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60770-1	60770-2	60771-1	60771-2
60771-3	60772-1	60772-2	60773-2
60774-1	60774-2	60775-1	60775-2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
14 AWG		1.88+/-0.05 [.074+/- .002]		4.5
16 AWG		1.70+/-0.05 [.067+/- .002]		6.4
1.00mm2		1.60+/-0.05 [.063+/- .002]		7.4
18 AWG		1.52+/-0.05 [.060+/- .002]		8.3

- 
- 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: 8-2150380-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150380-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150380-5
- 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 62, 180 & 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

SPADE TERMINALS ARE NOT FLANGED DURING APPLICATION IN THIS APPLICATOR.

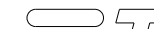
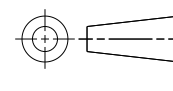
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	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	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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)

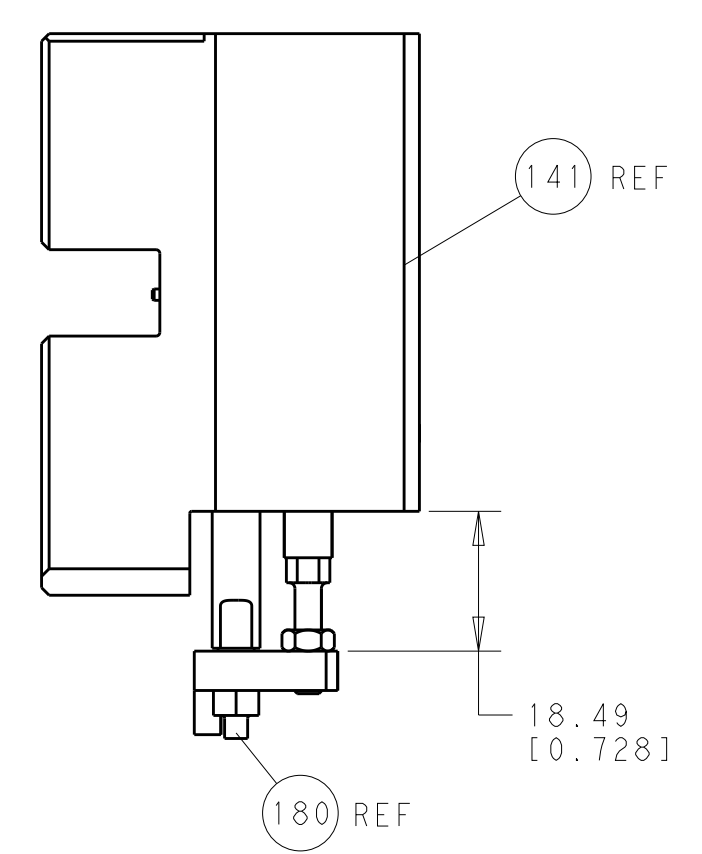
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
			-	-	SEE SHEET 1	-

-	-	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	1-1976055-0	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	2079383-5	SCR, BHSC, RoHS (M4 X 20)	92
-	1	1	1	1	455888-6	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	1901681-1	HOLDDOWN, TERMINAL	65
-	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
-	4	4	4	4	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	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	1-2119644-2	RAM WASHER, PRECISION	38
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	1	1	1	1	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	1-1752371-2	PLATE, STRIP GUIDE	24
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4	DRAG	20
-	1	1	1	1	1901696-1	STRIP GUIDE, REAR	19
-	1	1	1	1	1901695-1	STRIP GUIDE, FRONT	18
-	1	1	1	1	4-240641-6	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-5	PLATE, REAR SHEAR	11
-	2	2	2	2	240645-8	SPACER, SHEAR PLATE	10
-	1	1	1	1	2-240642-6	PLATE, FRONT SHEAR	9
-	1	1	1	1	4-1633383-6	ANVIL, COMBINATION	8
-	1	1	1	1	4-240651-2	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	4-240641-0	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	6-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	1	1	3-456408-8	CRIMPER, WIRE PREMIUM	1
-77-27-25-22-21					PART NO	DESCRIPTION	ITEM NO

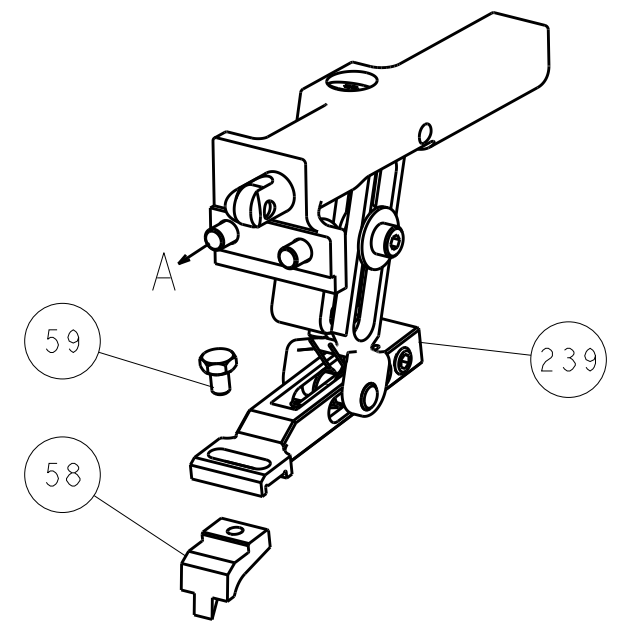
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION. NO CONTACT FOR THE LATEST REVISION.		DWN	01JUN2011	 TE Connectivity Harrisburg, PA 17105-3608	
		CHK	01JUN2011		
DIMENSIONS:		APVD	01JUN2011	NAME	
mm				Ocean End Feed Applicator	
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
		0 PLC $\pm .1$		-	
		1 PLC ± 0.5		-	
		2 PLC ± 0.13		-	
		3 PLC ± 0.13		-	
		4 PLC ± 0.0001		-	
		ANGLES $\pm .1$		-	
MATERIAL		FINISH		SIZE	
-		-		CAGE CODE	
				DRAWING NO	
				RESTRICTED TO	
				A1 00779 C=2150380	
				-	
		Customer Accessible Production Drawing		SCALE 1:1 SHEET 3 OF 4 REV C	

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

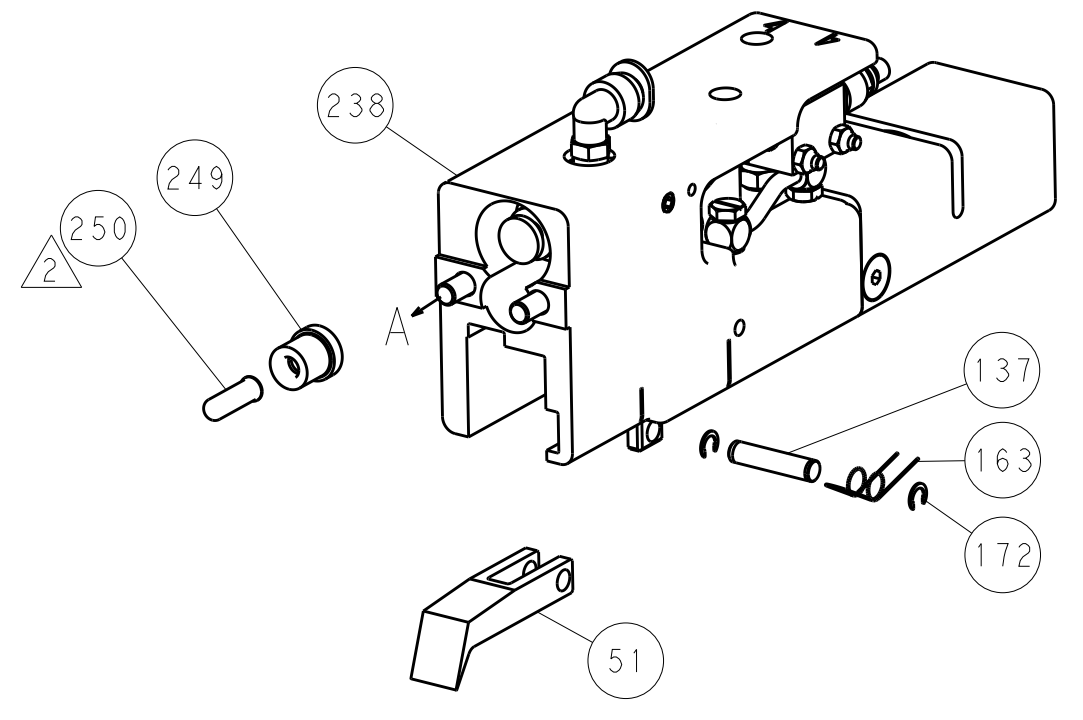
HOLDDOWN SET-UP



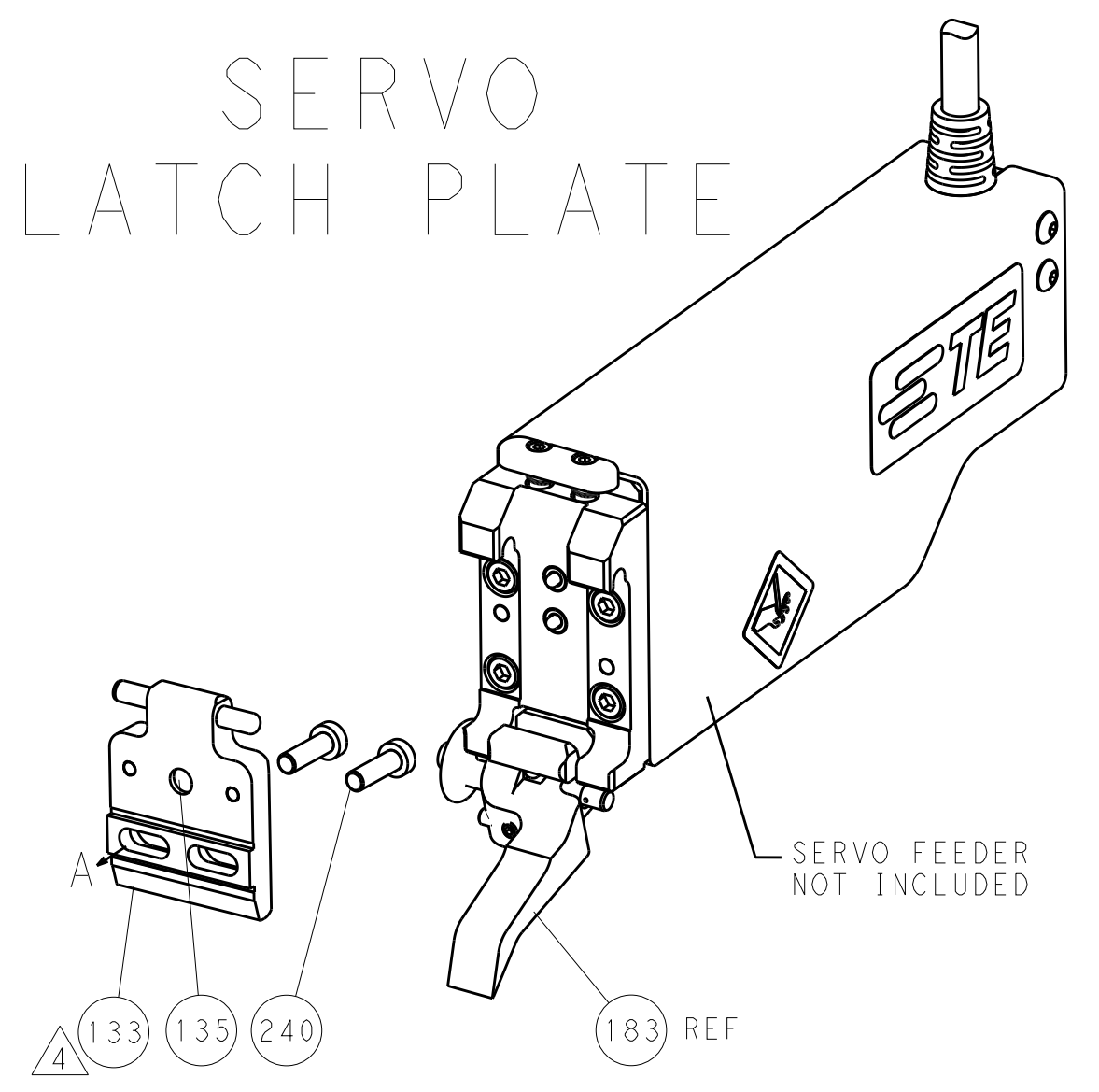
FEED TYPE
MECHANICAL



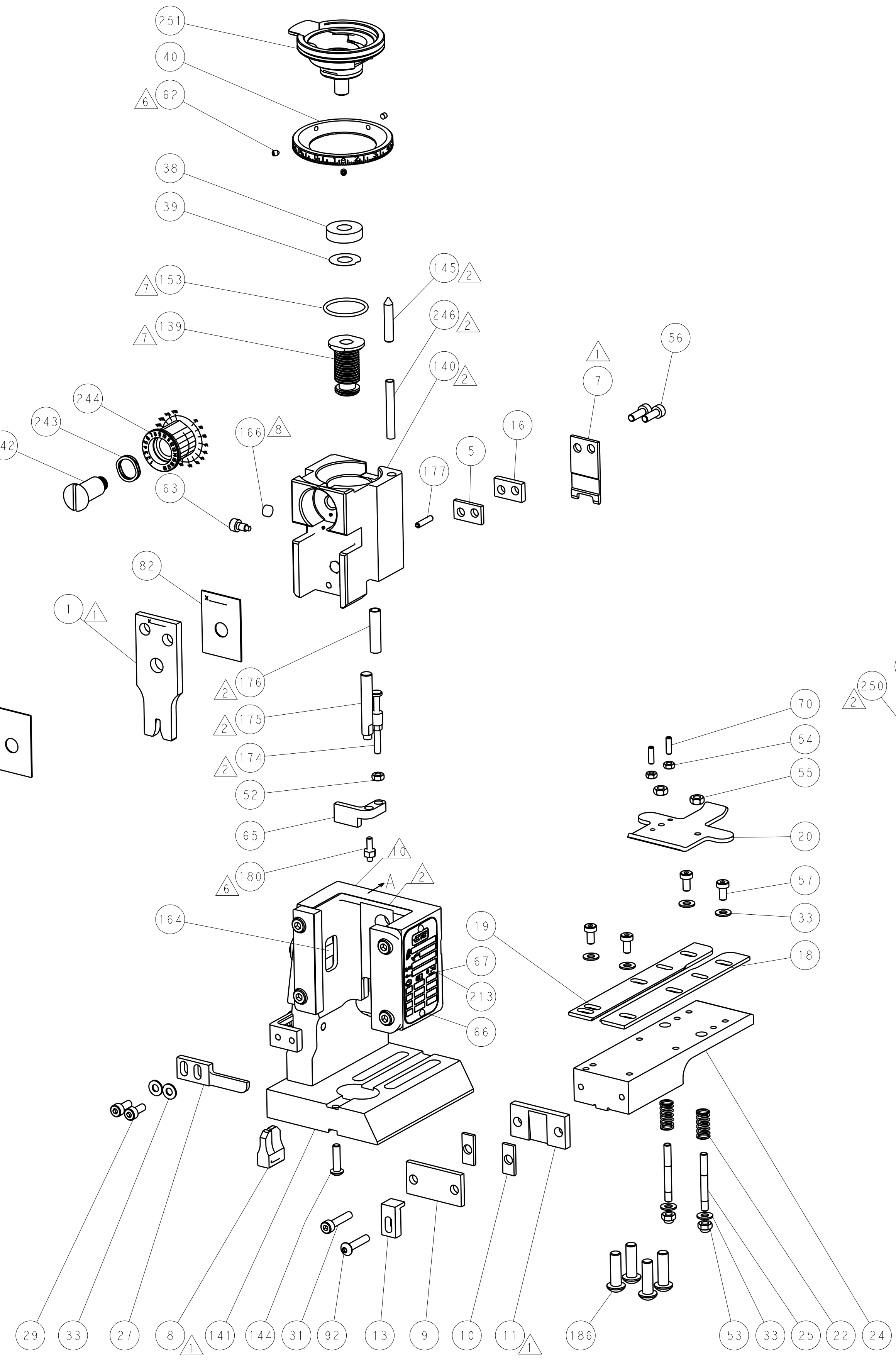
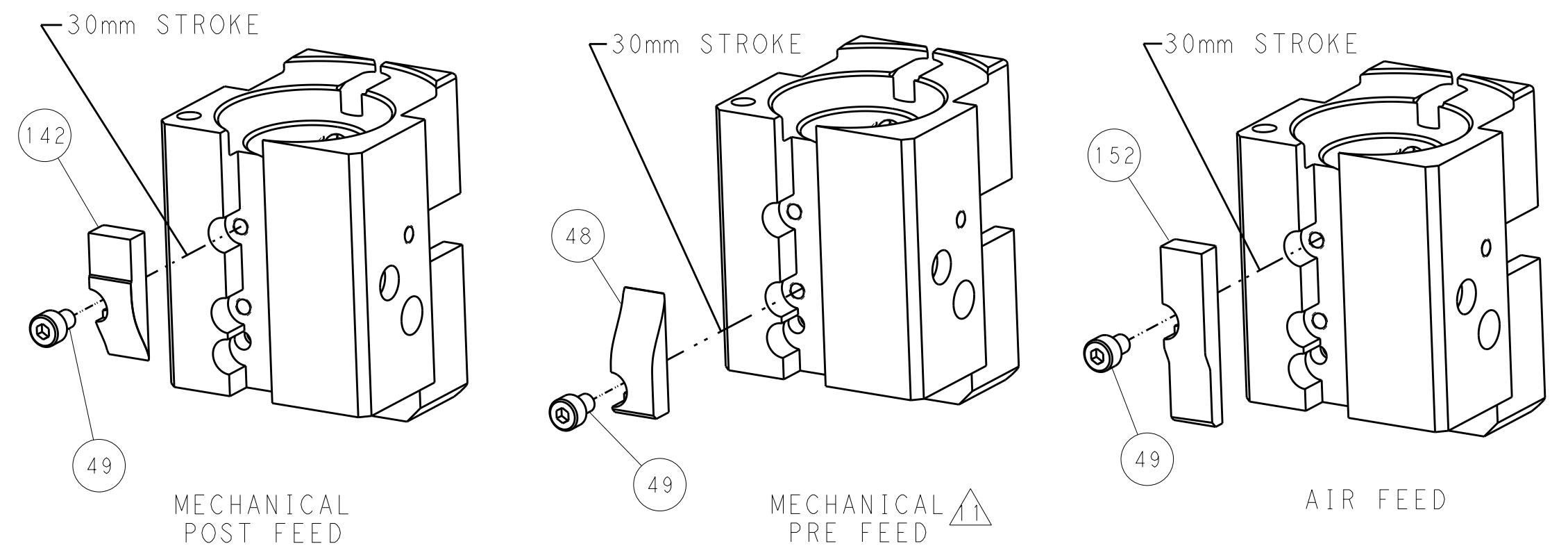
PNEUMATIC



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:		DWN 01JUN2011		STE Connectivity	
mm		0 PLC ±0.5		CHK 01JUN2011		Harrisburg, PA 17105-3608	
		1 PLC ±0.13		APVD 01JUN2011		NAME Ocean End Feed	
MATERIAL		2 PLC ±0.13		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
		3 PLC ±0.013		APPLICATION SPEC		A1 00779 C=2150380	
		4 PLC ±0.0001		WEIGHT		Customer Accessible Production Drawing	
		FINISH		SCALE 1:1		SHEET 4 OF 4	
						REV C	