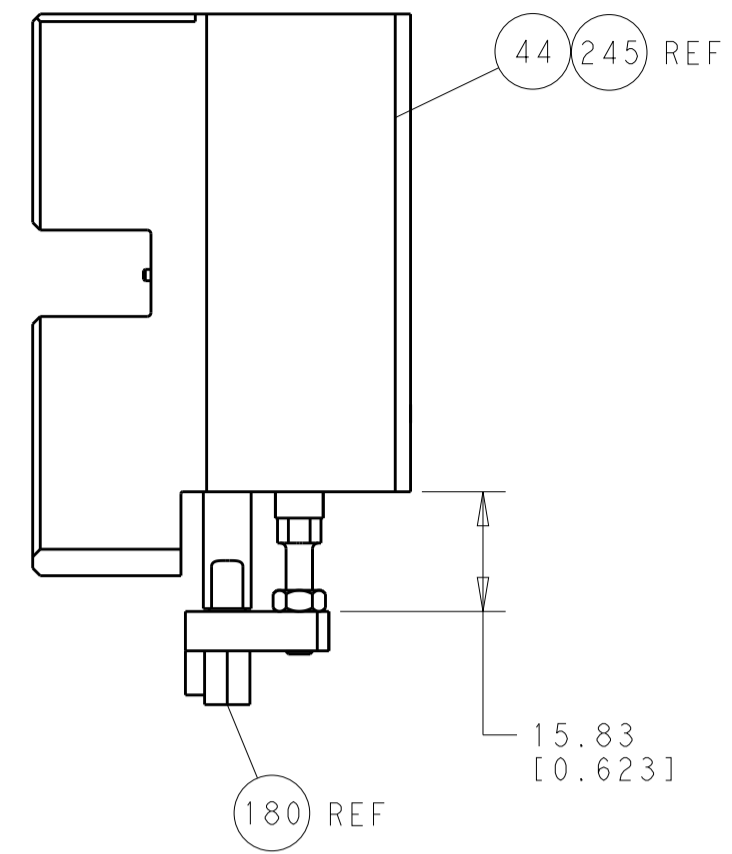
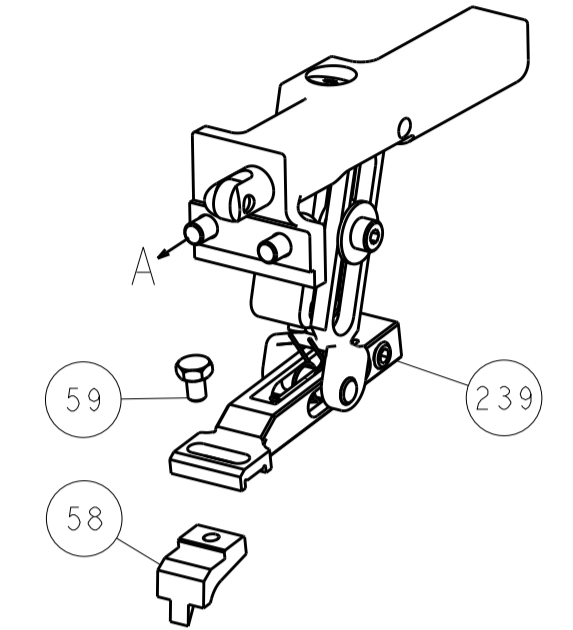


LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
-			SEE SHEET 1	-	-

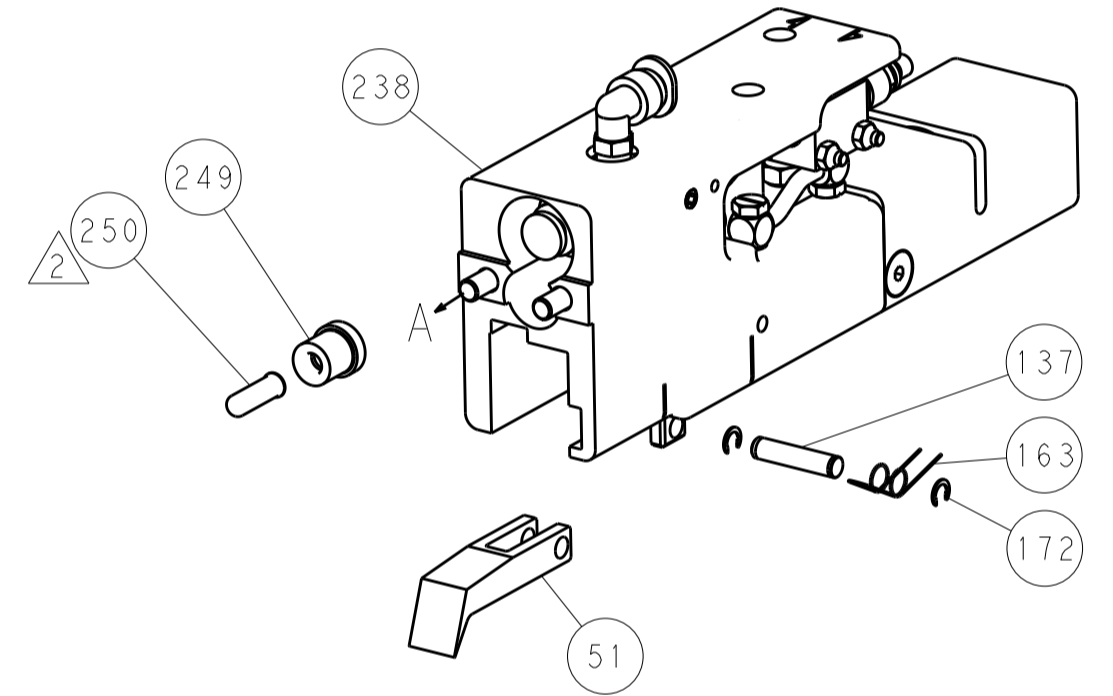


HOLDDOWN SET-UP

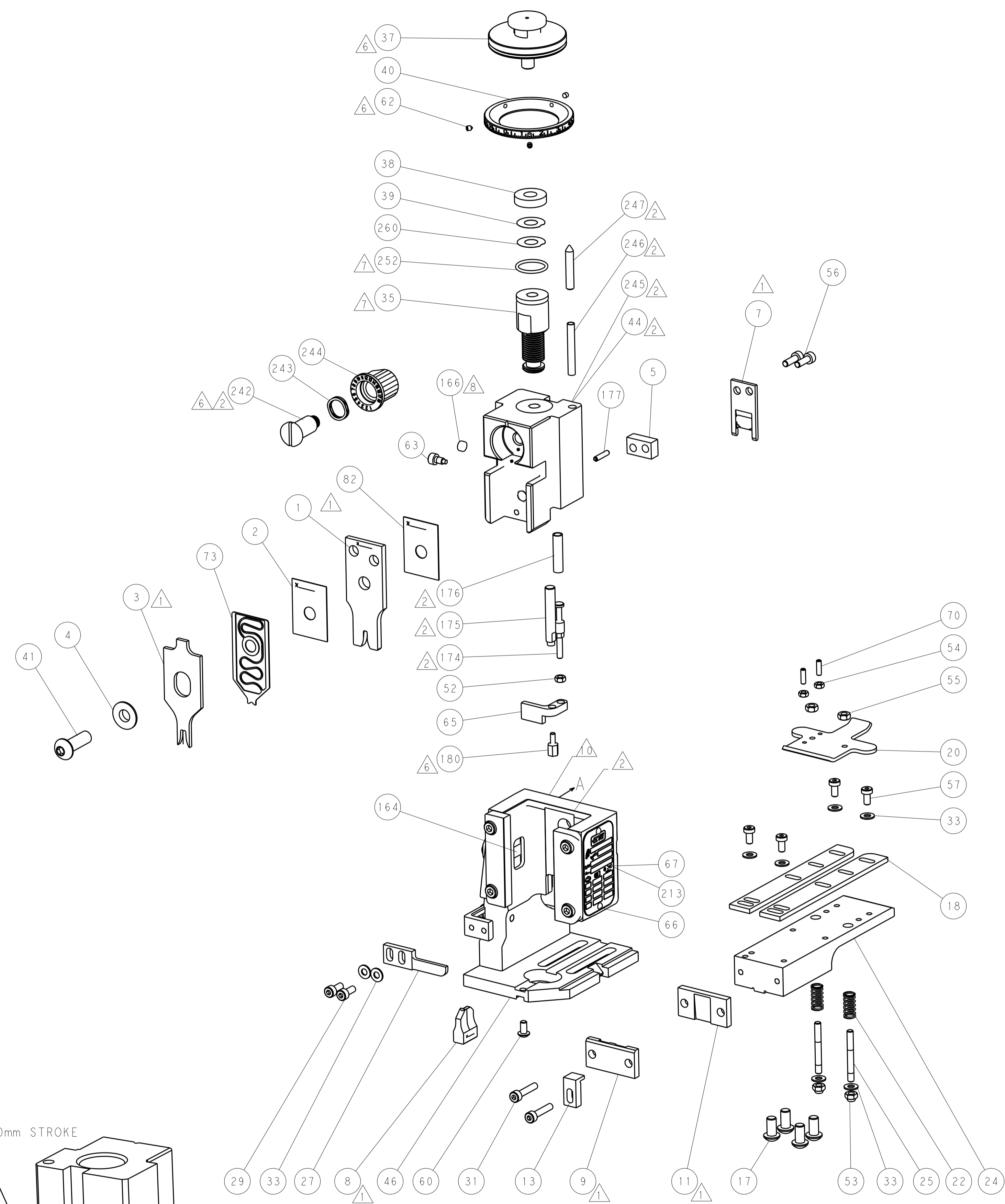
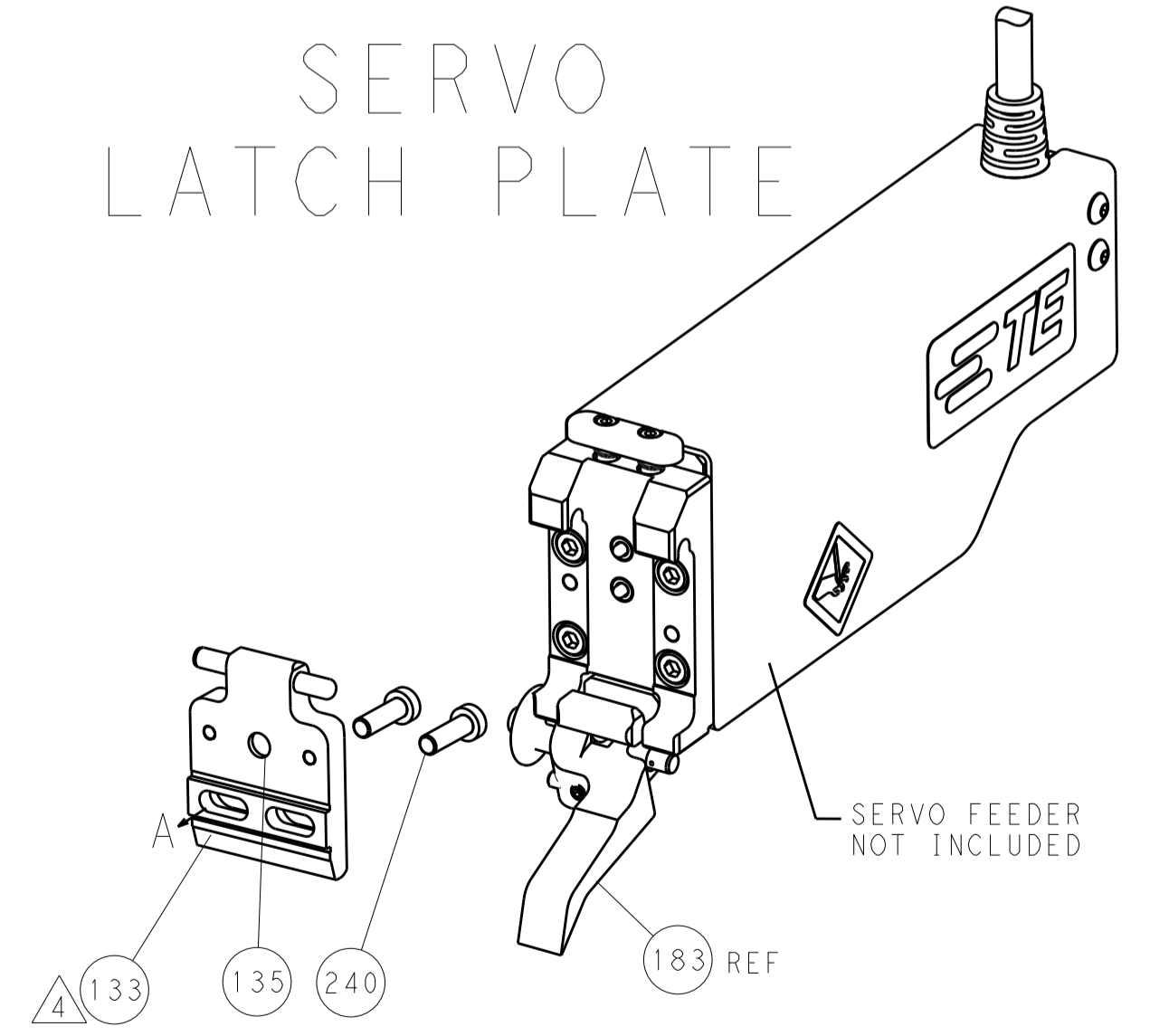
FEED TYPE
MECHANICAL



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:		OWN: K. HUANG 26FEB2014	TE Connectivity
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	CHK: L. ZHANG 26FEB2014	Harrisburg, PA 17105-3608
	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.001	APPV: H. GUO 26FEB2014	
MATERIAL:	FINISH:	WEIGHT:	SCALE:	NAME: Ocean End Feed Applicator	RESTRICTED TO:
			1:1	SIZE: A1 00779 ©=2150422	
Customer Accessible Production Drawing				SHEET 2 OF 4	REV A

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	#	LTN	DESCRIPTION	DATE	OWN	APPD
			-	-	SEE SHEET 1	-	-	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150422-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150422-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150422-4	-	-	
	2-2150422-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150422-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150422-4	-	-	
	2-2150422-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150422-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150422-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.54 mm [.100]	F	
INSUL 4.06 mm [.160]	F	
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: G&H(LEAR) TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: SIKO 2-FSH. 6,3-0,8	
WIRE STRIP LENGTH 4.70-5.30 mm [.185-.209 IN]	INSULATION DIAMETER RANGE \varnothing 3.10-3.70 mm [1.22-.146 IN]
TERMINAL APPLICATION SPECIFICATION NONE	
TERMINALS APPLIED	
TE TERMINAL 2113439-1	G&H(LEAR) TERMINAL 26112.123.178
2113439-2	2113439-3
	G&H(LEAR) TERMINAL 26112.201.178
	TERM403-CK9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.02+/-0.05 [.080+/-0.002]	7.1
2.00mm2	1.86+/-0.05 [.073+/-0.002]	8.9
1.50mm2	1.70+/-0.05 [.067+/-0.002]	10.5



- 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: 8-2150422-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150422-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150422-5
- 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.

***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.

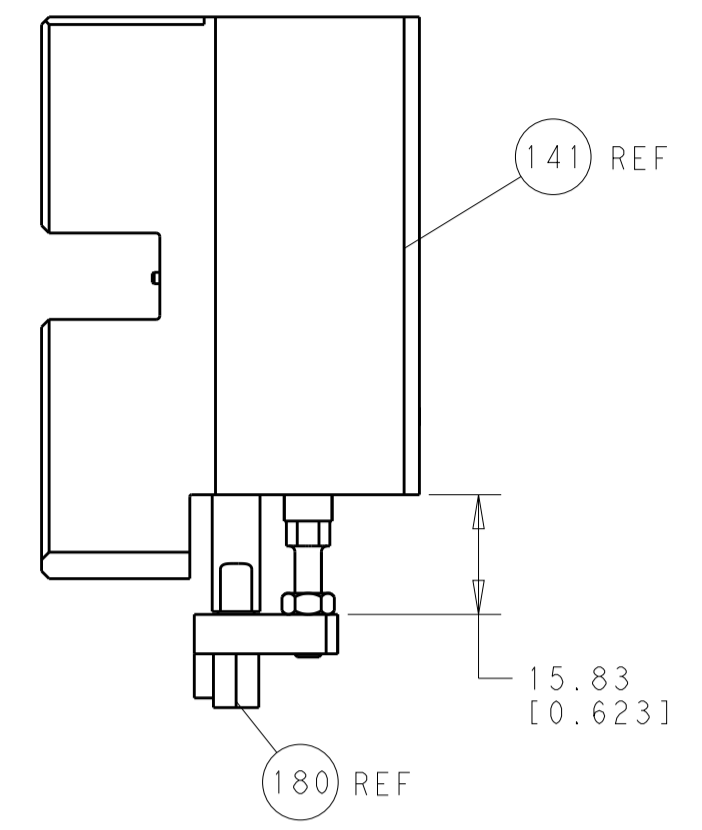
	ITEM NO	DESCRIPTION	ITEM NO
- 1 1 1 1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- - 1 -	2119640-1	PUSH ROD, AIR FEED	250
- - 1 -	2079988-1	BUSHING, LCH5-12, MISUMI	249
- 1 1 1 1	1-22279-3	SPRING, COMPRESSION	246
- 1 1 1 1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77-27-25-22-21	PART NO	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)

#	LTN	DESCRIPTION	DATE	OWN	APPD
- 1 1 1 1		2079764-1			243
- 1 1 1 1		2119083-1			242
- - 2 - -		2168400-7			240
- - - - 1		2119580-1			239
- - - 1 -		2063440-1			238
- - 1 - -		2119740-2			213
- 4 4 4 4		2079383-9			186
- - REF - -		1901697-1			183
- 1 1 1 1		1-1752354-3			180
- 1 1 1 1		6-993111-6			177
- 1 1 1 1		8-22280-7			176
- 1 1 1 1		1752353-2			175
- 1 1 1 1		1901680-2			174
- - - 2 -		21045-3			172
- 1 1 1 1		994969-1			166
- REFREFREFREF		994970-2			164
- - - 1 -		240638-1			163
- 1 1 1 1		8-21084-1			153
- - - 1 -		2119641-2			152
- 1 1 1 1		2119798-2			145
- 1 1 1 1		2079383-8			144
- - - - 1		2119653-2			142
- 1 1 1 1		2119655-6			141
- 1 1 1 1		2119651-1			140
- 1 1 1 1		2119092-2			139
- - - 1 -		3-23627-7			137
- - REF - -		SEE NOTE 4			135
- - 1 - -		1633743-1			133
- 1 1 1 1		455888-4			82
- 1 1 1 1		2119791-5			73
- 1 1 1 1		2119956-2			71
- 2 2 2 2		2-18032-2			70
- 1 - 1 1		2119740-1			67
- 2 2 2 2		2168078-1			66
- 1 1 1 1		1901681-1			65
- 1 1 1 1		2119793-1			63
- 3 3 3 3		992763-5			62
- - - - 1		5-18022-5			59
- - - - 1		2063961-1			58
- 4 4 4 4		2168400-4			57
- 2 2 2 2		2168083-3			56
- 2 2 2 2		5018030-2			55
- 2 2 2 2		5018030-1			54
- 2 2 2 2		986965-8			53
- 1 1 1 1		1-5018030-0			52
- - - 1 -		2119792-2			51
- - - 1 2		18023-9			49
- - - - 1		2119652-1			48
- 1 1 1 1		2079383-7			41
- 1 1 1 1		2119645-1			40
- 1 1 1 1		2119957-1			39
- 1 1 1 1		2119644-2			38
- 8 8 8 8		1-18028-2			33
- 2 2 2 2		2168083-9			31
- 2 2 2 2		1-2168083-0			29
- 1 1 1 1		240639-1			27
- 2 2 2 2		1320906-1			25
- 1 1 1 1		1752371-5			24
- 2 2 2 2		2-22281-3			22
- 1 1 1 1		1752373-4			20
- 2 2 2 2		1901259-6			18
- 1 1 1 1		1752360-1			13
- 1 1 1 1		240644-1			11
- - - - -		-			10
- 1 1 1 1		1-690482-2			9
- 1 1 1 1		1803060-6			8
- 1 1 1 1		2217206-7			7
- - - - -		-			6
- 1 1 1 1		7-240641-5			5
- 1 1 1 1		238009-4			4
- 1 1 1 1		1-1633961-4			3
- 1 1 1 1		455888-3			2
- 1 1 1 1		3-456407-5			1

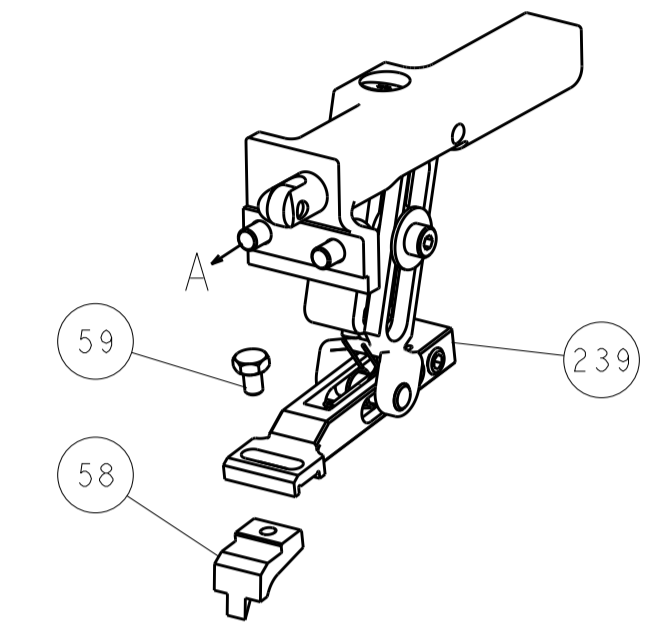
DATE: 26 FEB 2014 CHK: H. HUANG L. ZHANG APVD: H. GUO	DATE: 26 FEB 2014 NAME: H. GUO PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	DATE: 26 FEB 2014 NAME: H. GUO SIZE: 3 OF 4 SHEET: 3 OF 4 REV: A	DATE: 26 FEB 2014 NAME: H. GUO SIZE: 3 OF 4 SHEET: 3 OF 4 REV: A
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LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1			

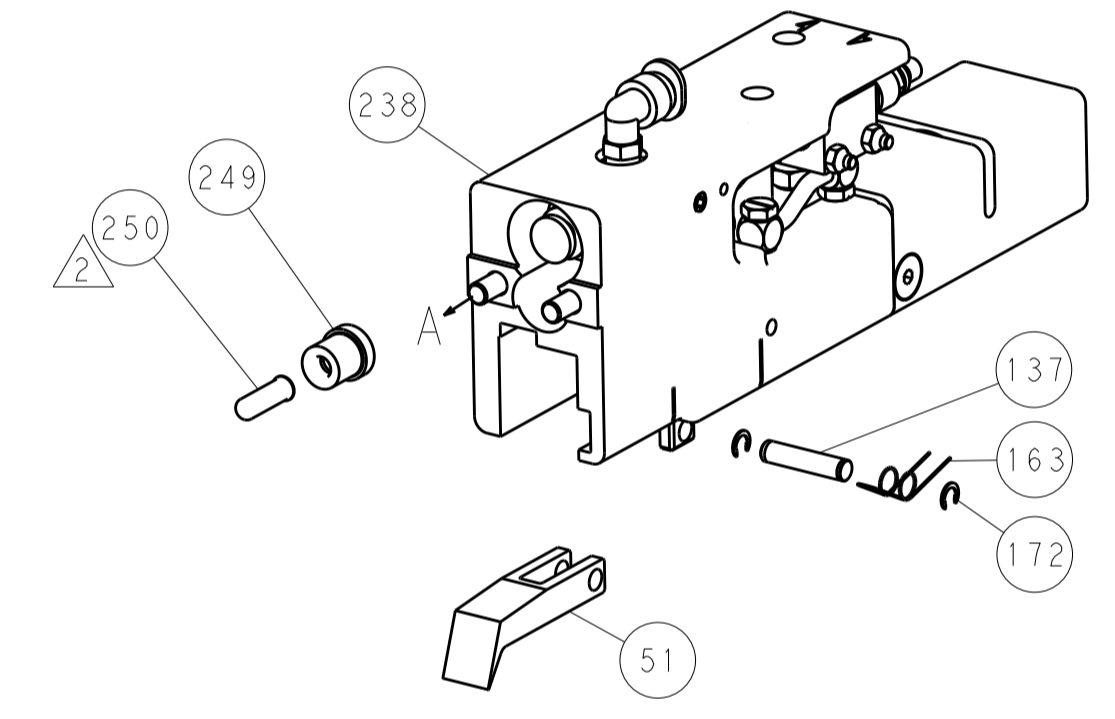


HOLDDOWN SET-UP

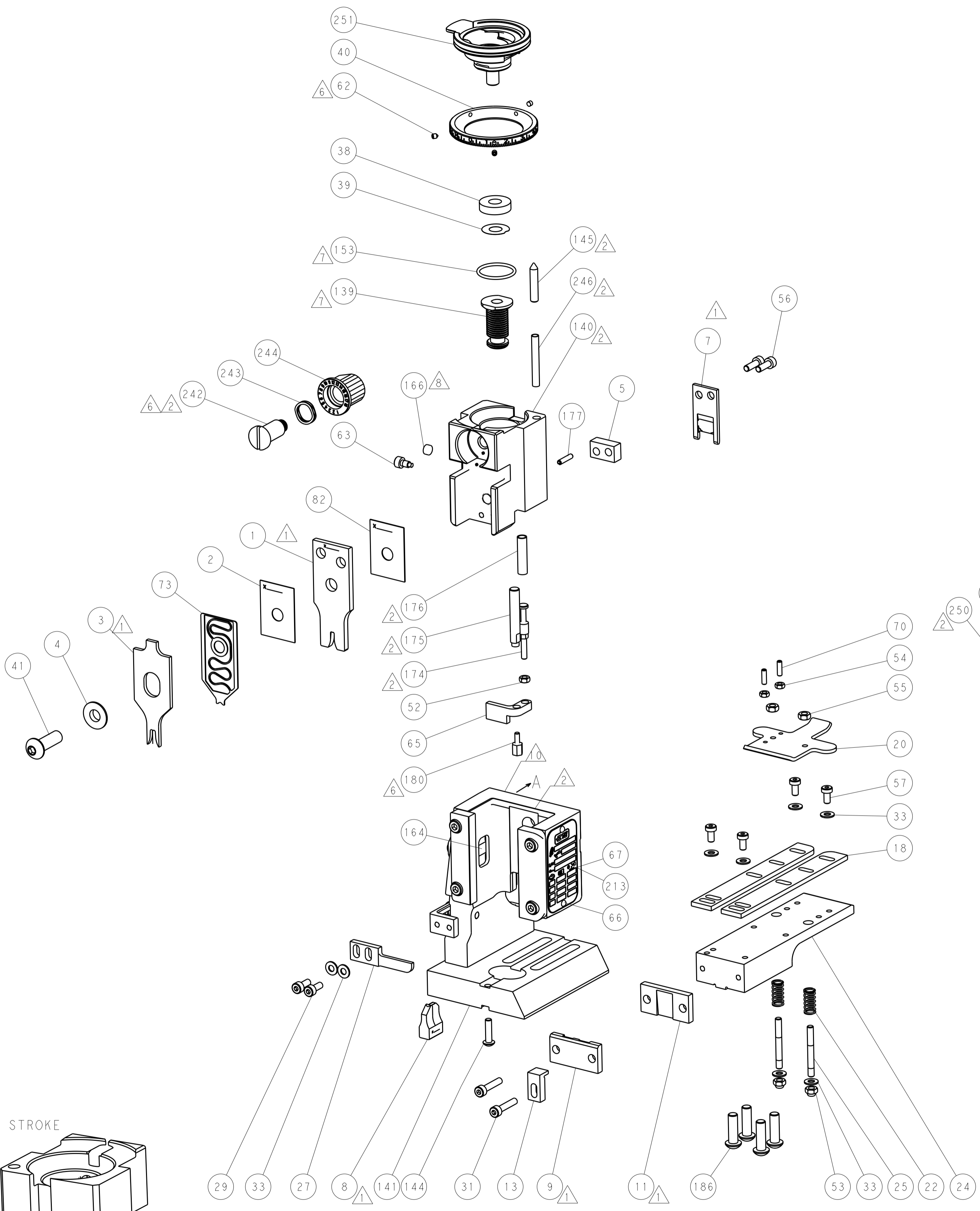
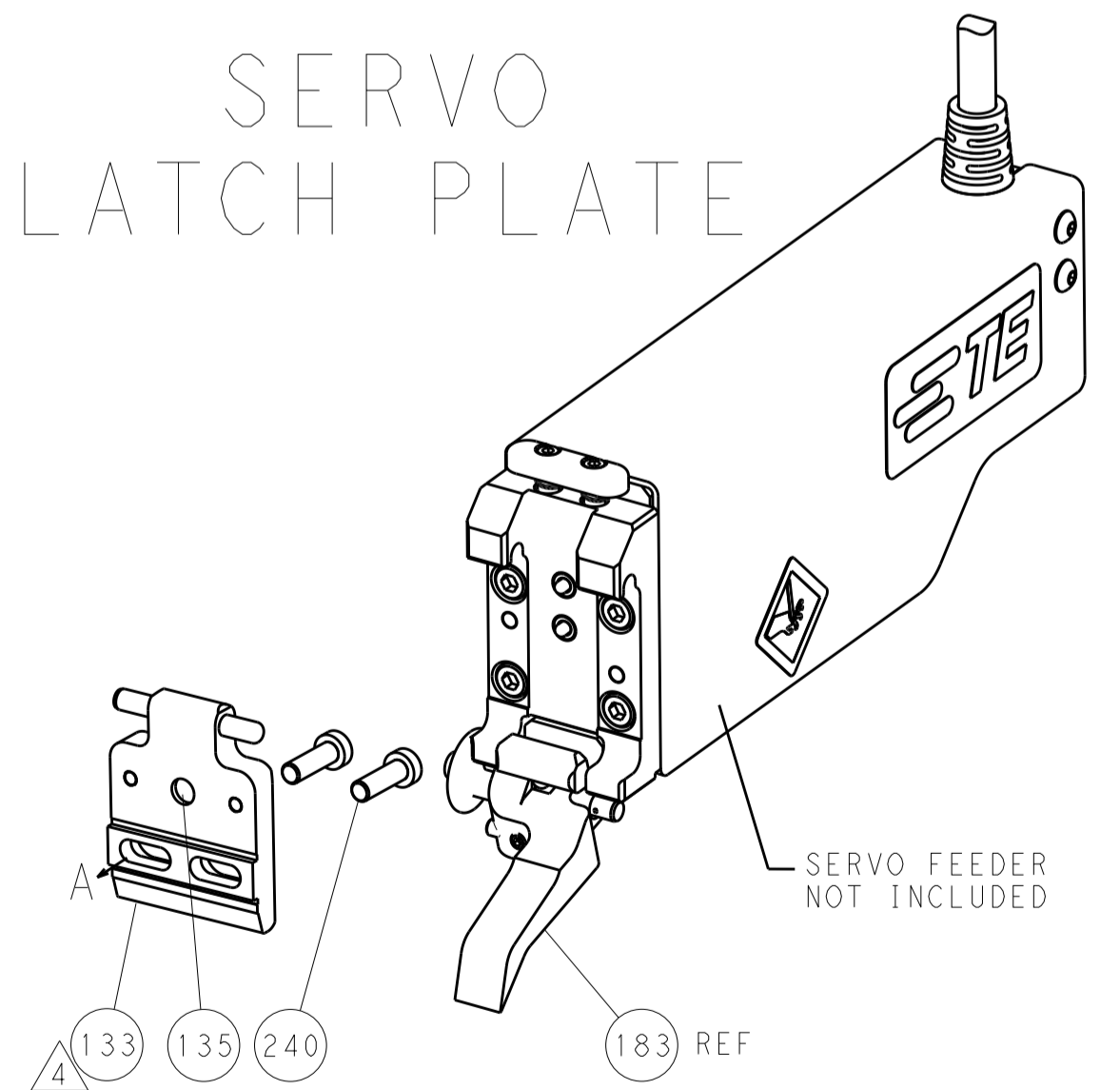
FEED TYPE
MECHANICAL



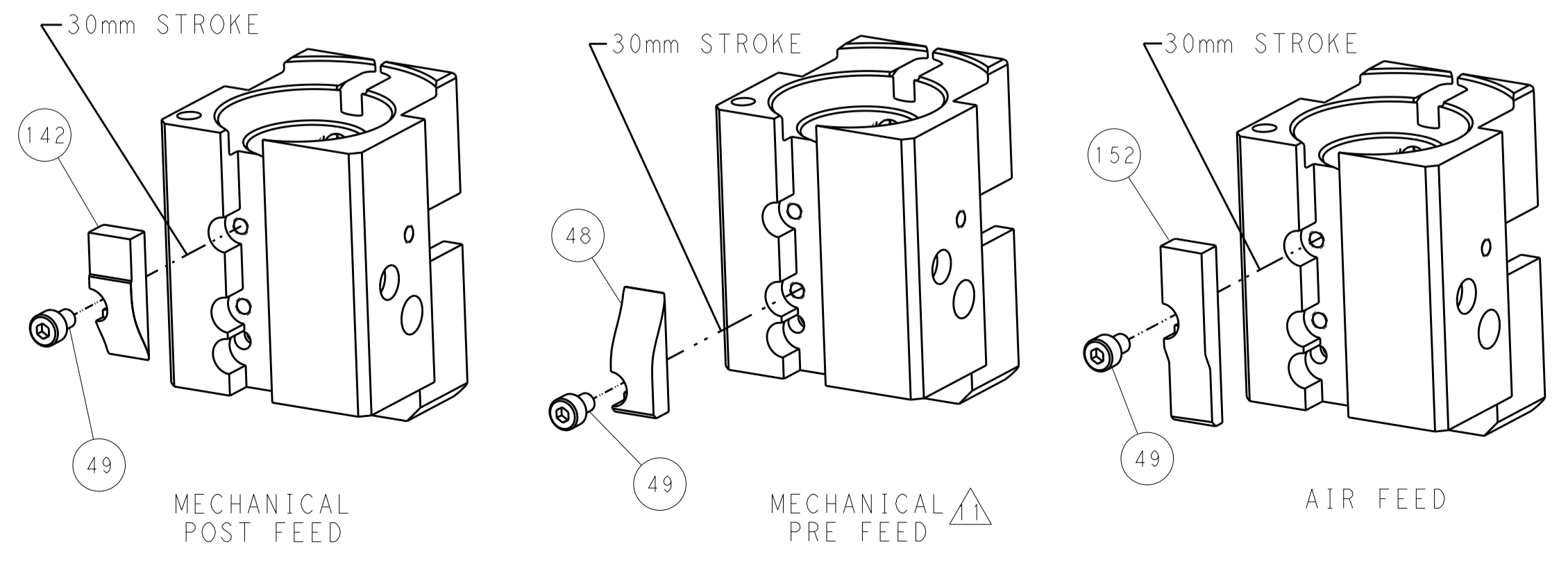
PNEUMATIC



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 H. HUANG 26FEB2014		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	CHK L. ZHANG 26FEB2014	NAME Ocean End Feed Applicator	
	4 PLC ±0.013	5 PLC ±0.001	ANGLES ±0.001	APVD H. GUO 26FEB2014	PRODUCT SPEC		RESTRICTED TO
MATERIAL	FINISH	WEIGHT		SCALE 1:1		SHEET 4 OF 4 REV A	
Customer Accessible Production Drawing		A1 00779 C=2150422		SIZE CAGE CODE DRAWING NO		REV	