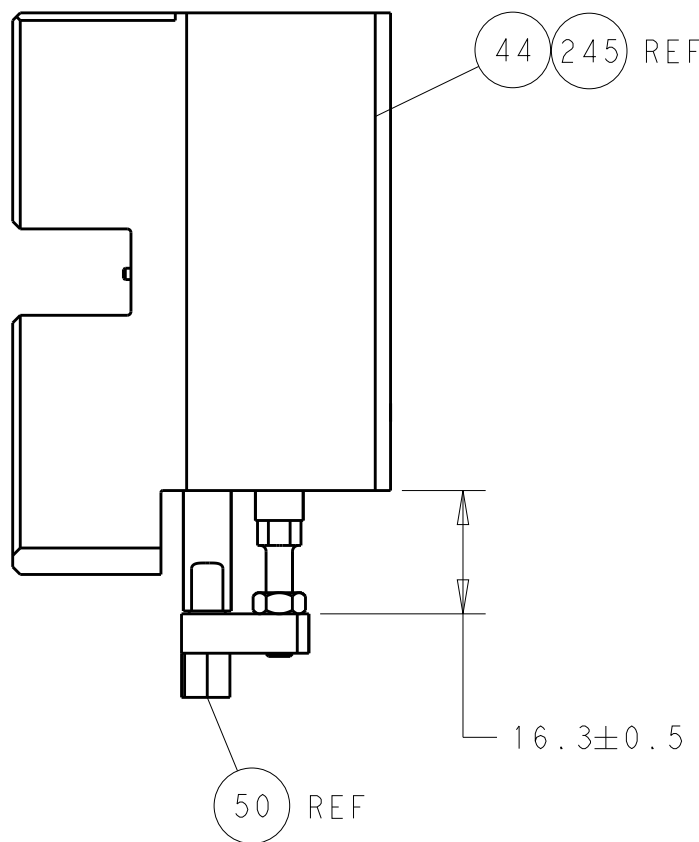
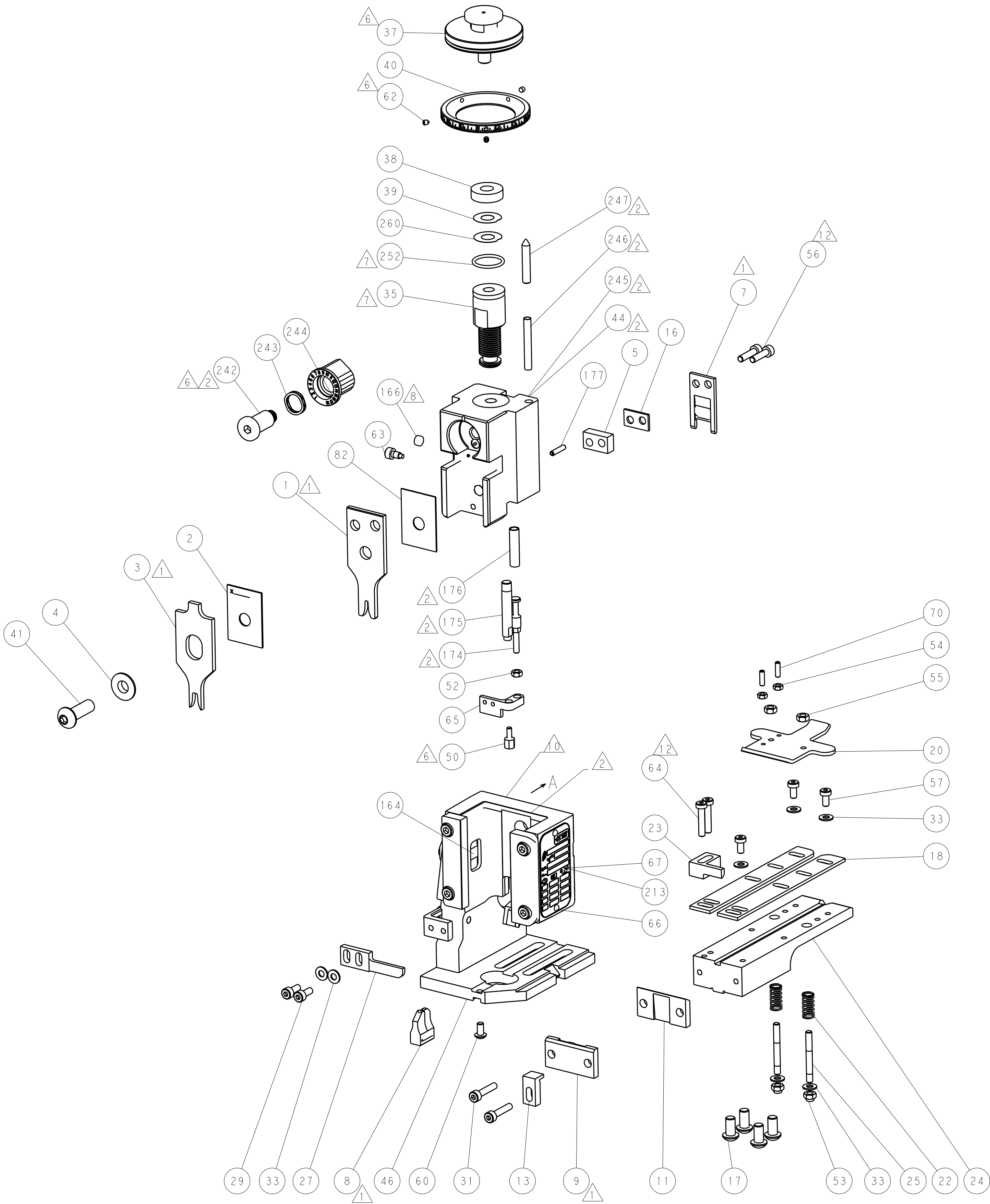


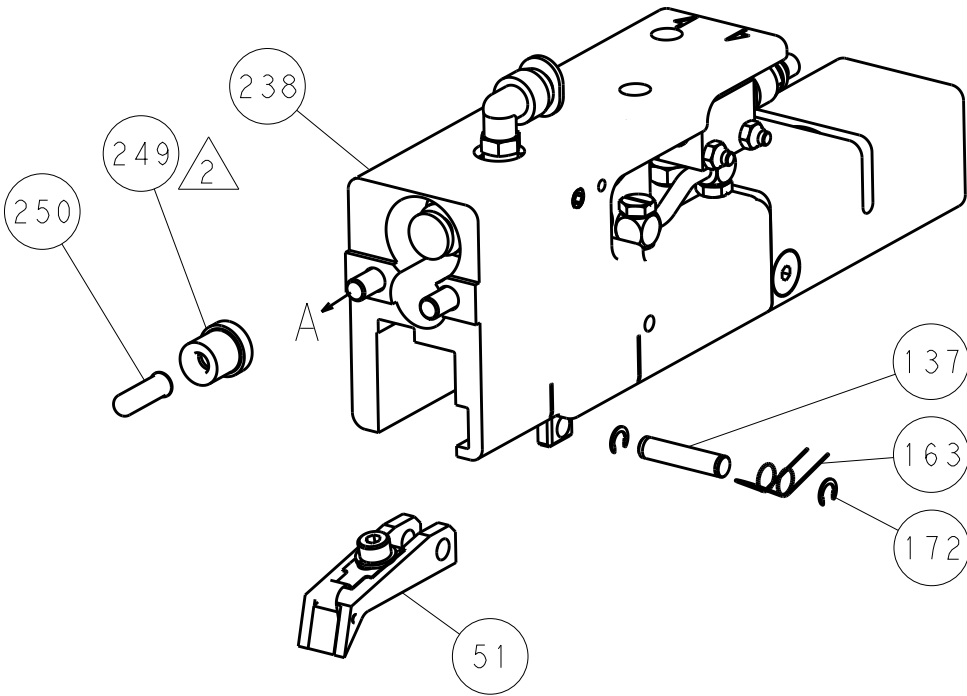
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		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-



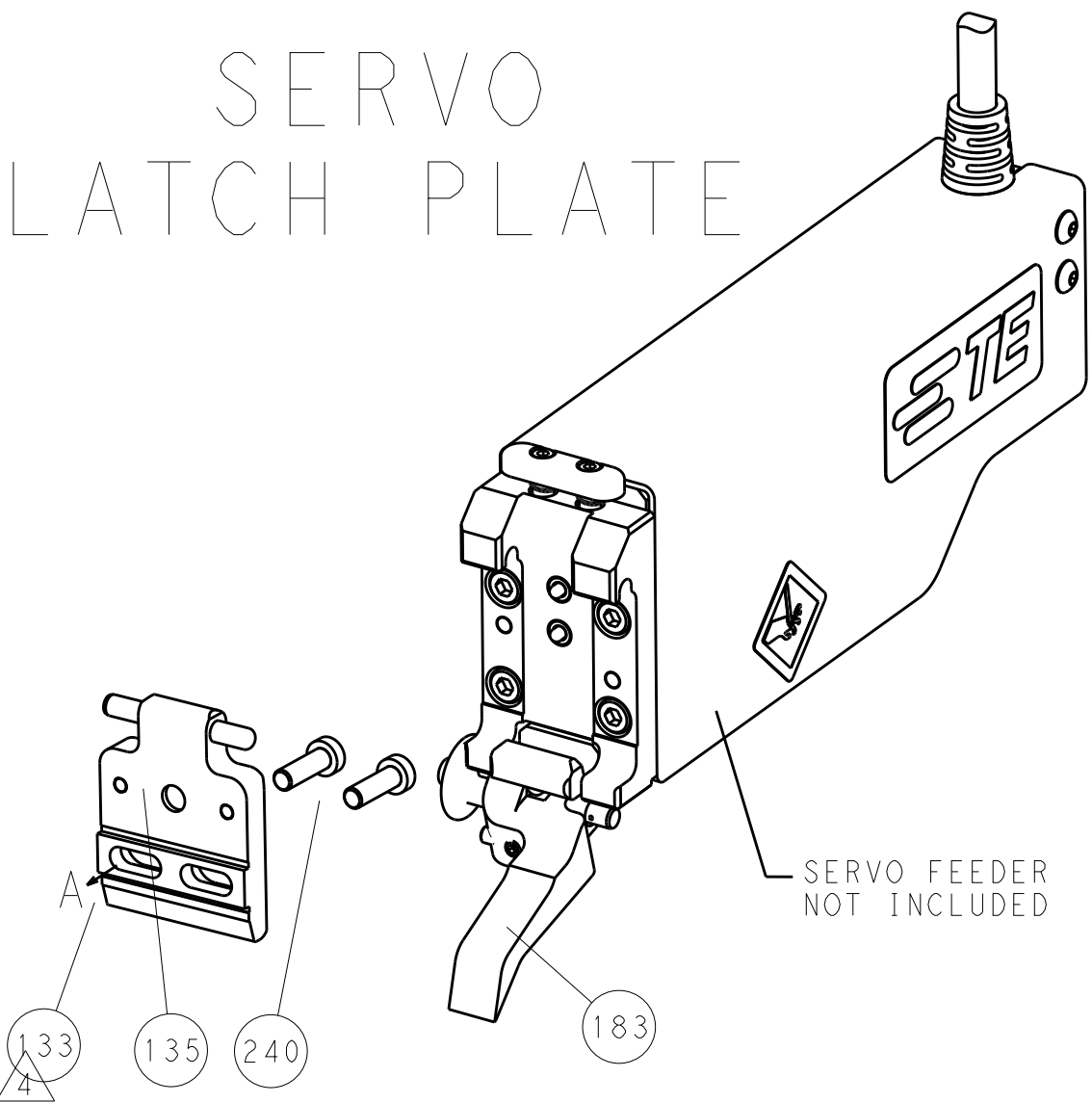
HOLDDOWN SET-UP



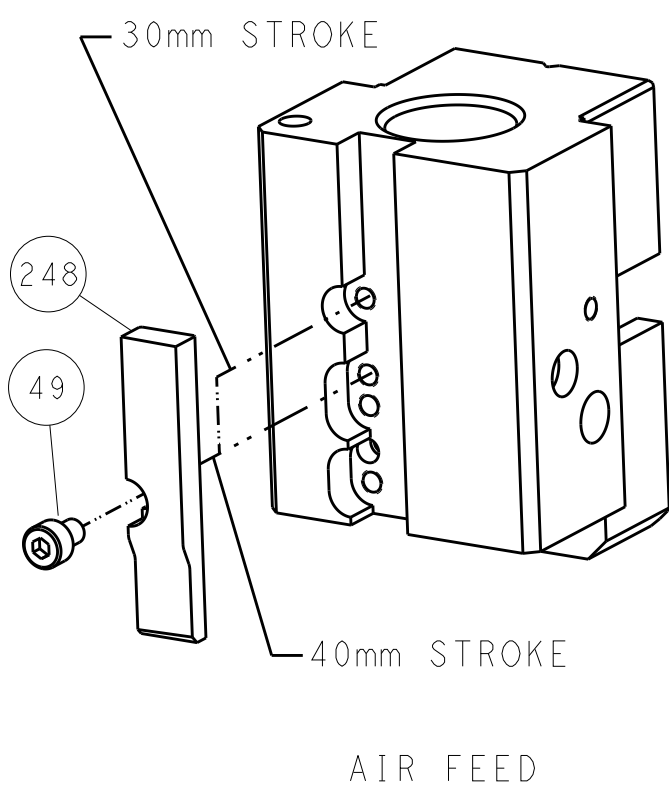
FEED TYPE
PNEUMATIC



SERVO
LATCH PLATE



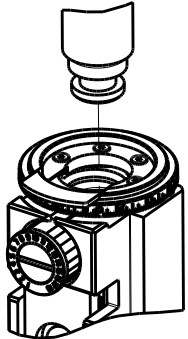
CAM POSITION



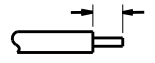
AIR FEED

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

1ST PUBLISHED BY: COMPANY/ISSUE/DATE FOR THIS ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE/REVISION/REWORK/REWORKING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN R. KNEPPER 26MAR2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN 26MAR2012	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD W. CLIFFORD 26MAR2012	SIZE CAGE CODE DRAWING NO.	
0 PLC ±.0005		PRODUCT SPEC	RESTRICTED TO	
1 PLC ±.0005		APPLICATION SPEC	A1 00779 ©=2150032	
2 PLC ±.0005		WEIGHT	SCALE	
3 PLC ±.0005		Customer Accessible Production Drawing	1:1	
4 PLC ±.0005		Customer Accessible Production Drawing	SHEET 2 OF 4	
ANGLES		Customer Accessible Production Drawing	REV B1	
FINISH		Customer Accessible Production Drawing	REV B1	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						-	-	-	-	-	-
	2-2150032-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE SMART APPLICATOR	2119951-1	1803052-1	8-2150032-5	-	-	2168400-7 (QUANTITY 2)
	2-2150032-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	-	-	-	-	-	-	-
	2-2150032-7	B	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2031314-1	-	2119641-2	-	2063440-2
	7-2150032-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

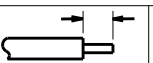
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.94 mm [.155]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 187 SERIES POSITIVE LOCK MK-II			
WIRE STRIP LENGTH 4.20-5.20 mm [.165-.205 IN]		INSULATION DIAMETER RANGE Ø1.90-3.40 mm [.075-.134 IN]	
TERMINAL APPLICATION SPECIFICATION 	114-5041	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170325-1	170325-5	173691-1	175179-1
170325-3	170325-6	173691-2	175179-2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
1.25mm2		1.50+/-0.05 [.059+/- .002]		4.2
0.75mm2		1.32+/-0.05 [.052+/- .002]		6.3
0.50mm2		1.19+/-0.05 [.047+/- .002]		7.7



-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150032-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150032-5
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 ITEM 50, 62 & 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.
-  TERMINAL DESIGN IS NOT COMPATIBLE WITH MECHANICAL FEED.
-  CUT TO LENGTH AT ASSEMBLY.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 187 SERIES POSITIVE LOCK MK-II			
WIRE STRIP LENGTH 4.20-5.20 mm [.165-.205 IN]		INSULATION DIAMETER RANGE Ø1.90-3.40 mm [.075-.134 IN]	
TERMINAL APPLICATION SPECIFICATION 		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170325-1			

WIRE SIZE		CRIMP HEIGHT WI_CRIMP_UNITS		CRIMP HEIGHT REFERENCE SETTING 
0.35 + 0.35 mm ²		1.25+/-0.05 [.049+/- .002]		7.0

*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.

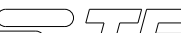
 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

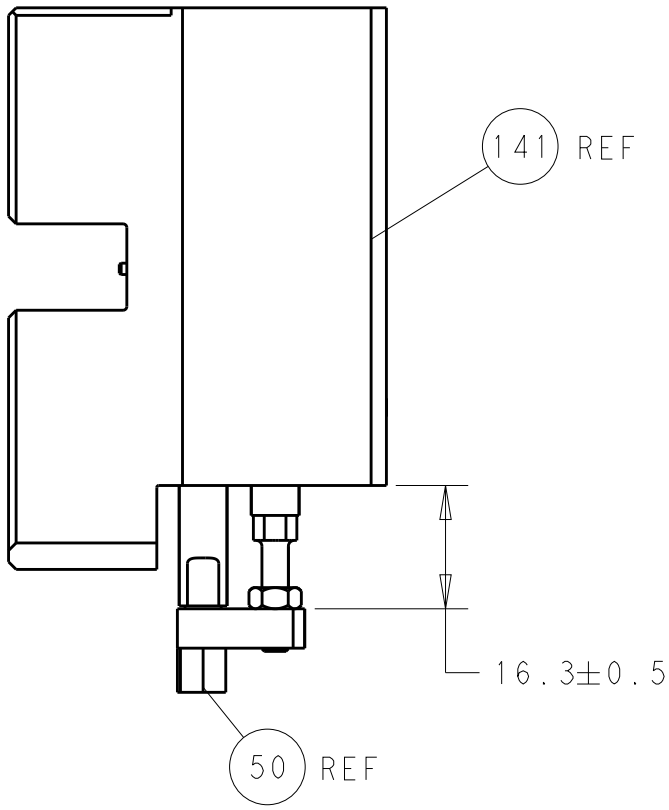
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

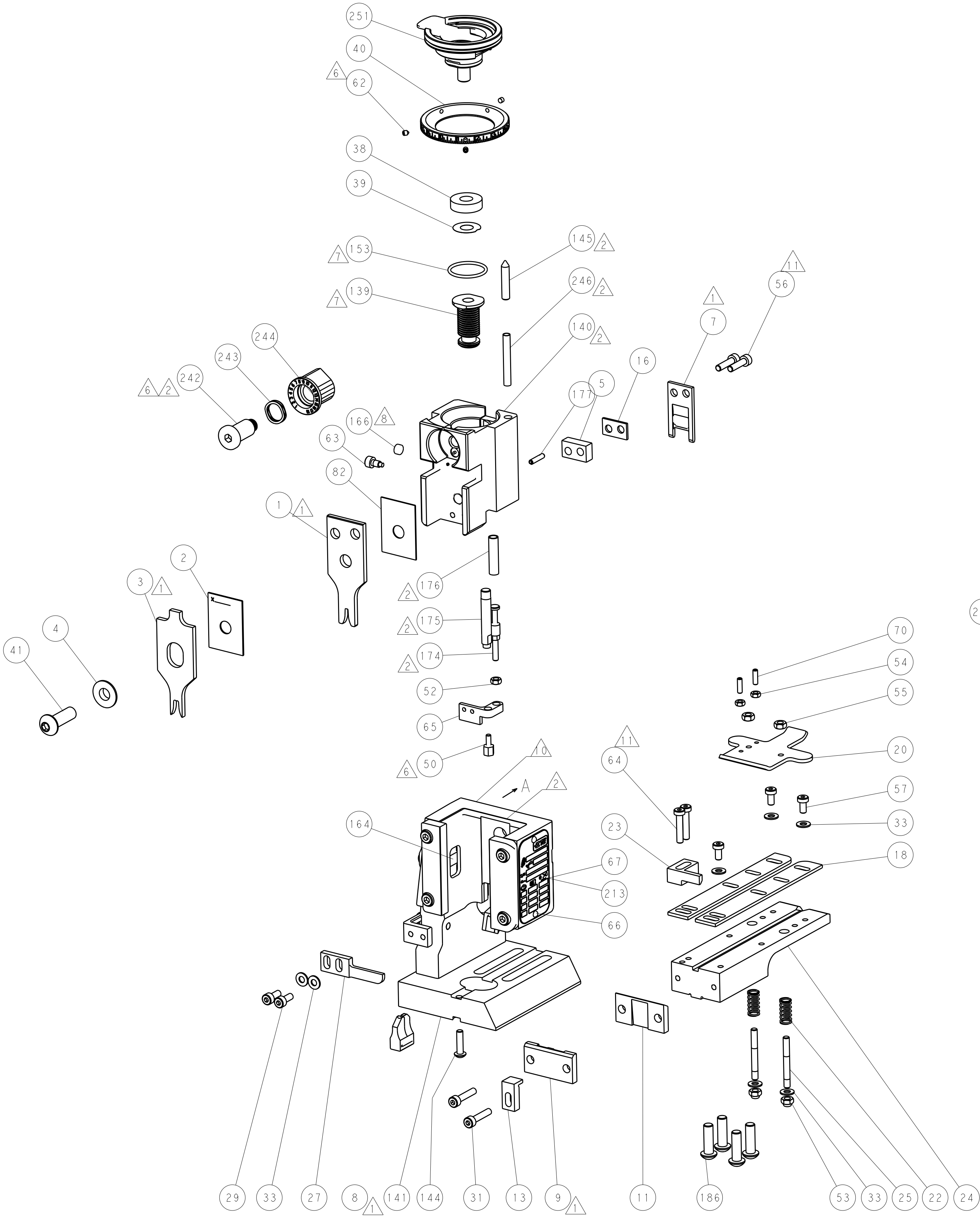
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	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
-	-	1	-	1803052-1	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	2-1901681-2	HOLDDOWN, TERMINAL	65
	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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
	-	-	1	2031314-1	FEED FINGER SUBASSEMBLY	51
	1	1	1	1752354-8	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
-	7	7	7	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	1752371-7	PLATE, STRIP GUIDE	24
-	1	1	1	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1752373-4	DRAG	20
-	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	1	1	1	6-240641-3	SPACER	16
-	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
	1	1	1	240833-7	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
	1	1	1	3-690482-2	PLATE, FRONT SHEAR	9
	1	1	1	2-1333217-1	ANVIL, EF .090	8
	1	1	1	4-690474-5	BLADE, SLUG	7
-	1	1	1	2-240641-3	SPACER	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
	1	1	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-7	SPACER, CRIMPER	2
	1	1	1	2-456406-3	CRIMPER, WIRE PREMIUM	1
-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN R. KNEPPER 26MAR2012	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK T. ELBIN 26MAR2012					
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD M. CLIFFORD 26MAR2012	NAME Ocean End Feed Applicator				
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC - APPLICATION SPEC -	SIZE A1				
MATERIAL -		FINISH -		WEIGHT -	CASE CODE 00779		DRAWING NO C=2150032		
Customer Accessible Production Drawing				SCALE 1:1		SHEET 3		OF 4	
				REV B1					

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

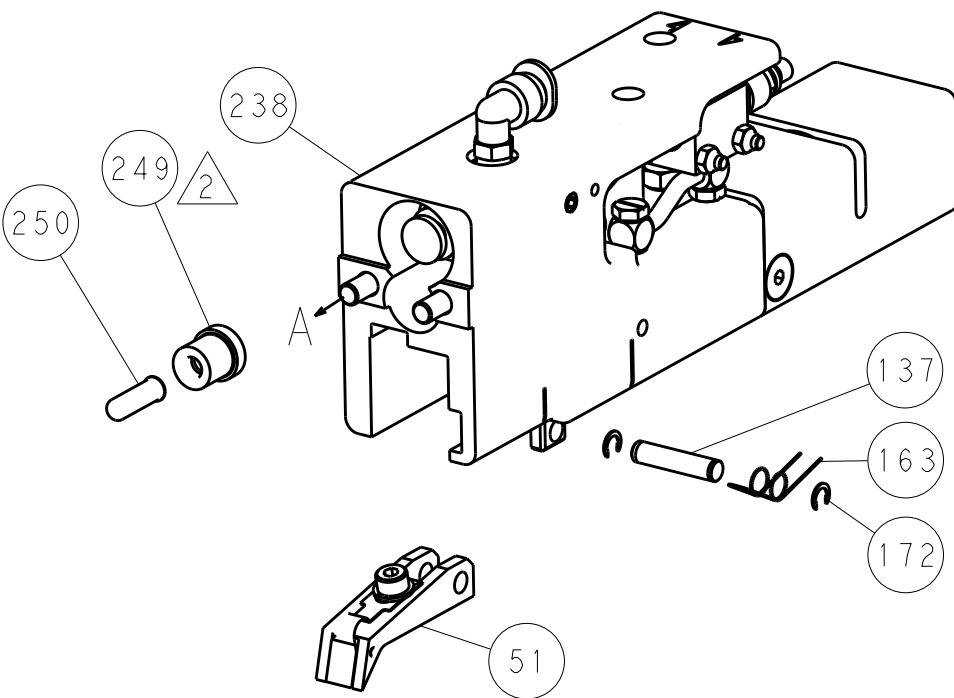


HOLDDOWN SET-UP

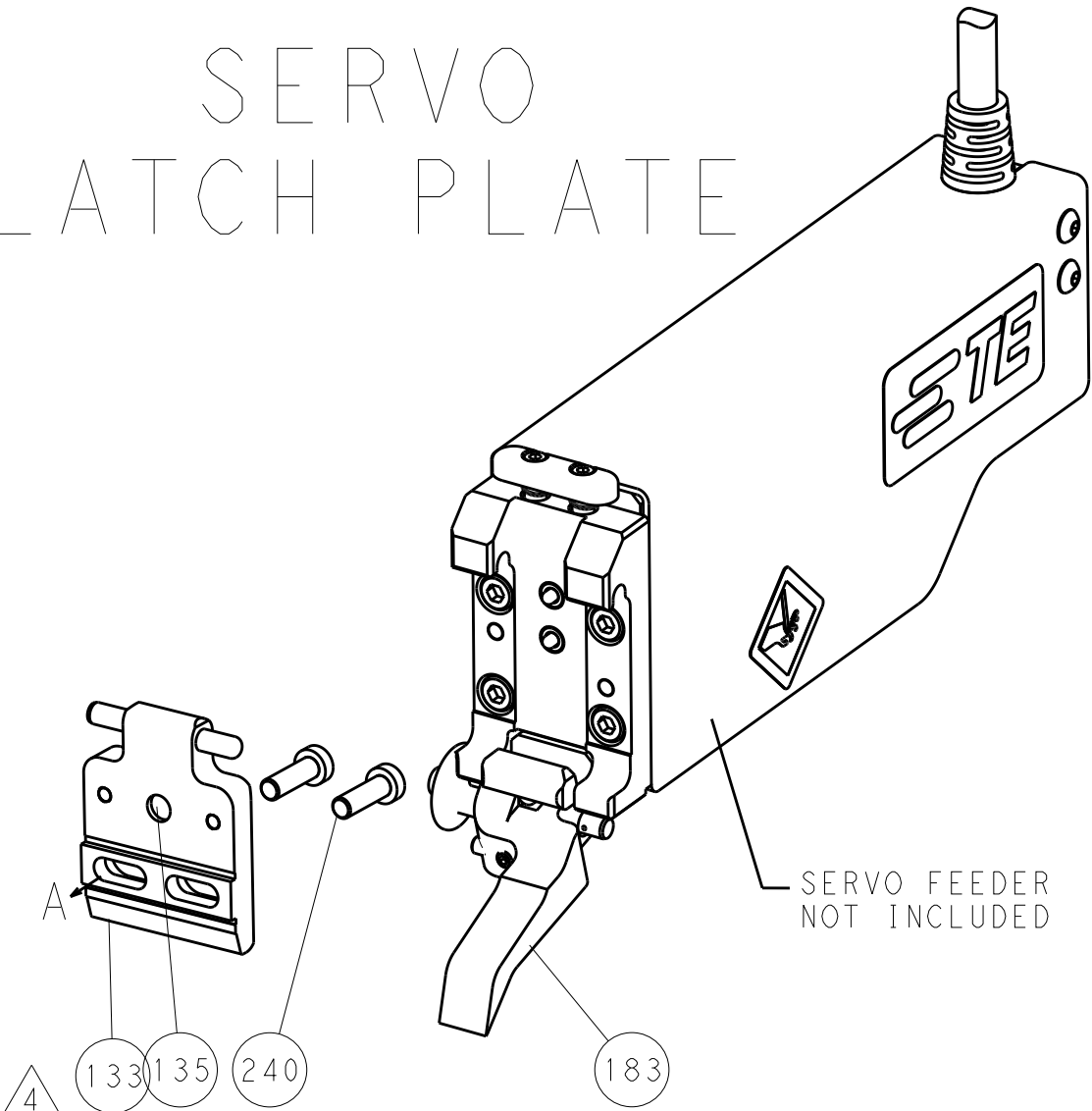


FEED TYPE

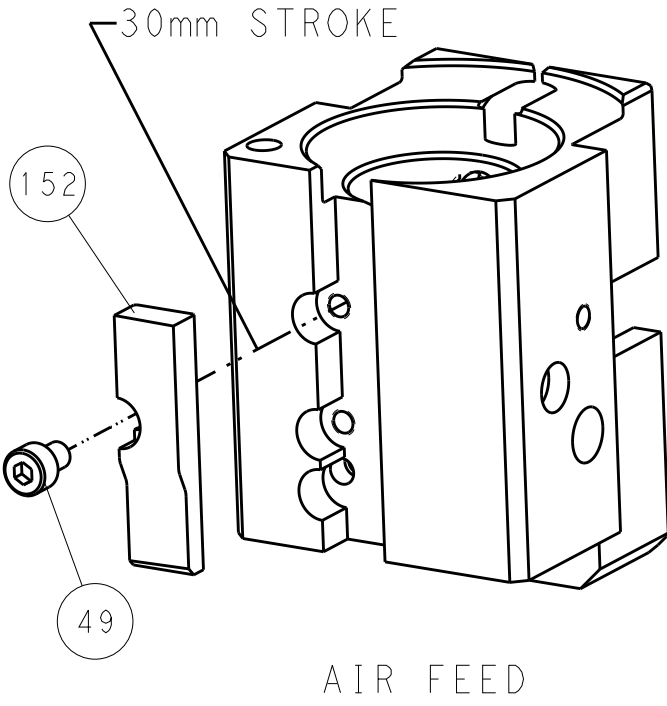
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN R. KNEPPER 26MAR2012	STE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN 26MAR2012	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD W. CLIFFORD 26MAR2012	SIZE A1	
MATERIAL		PRODUCT SPEC	CAGE CODE 00779	
		APPLICATION SPEC	DRAWING NO. C=2150032	
		WEIGHT	RESTRICTED TO	
		Customer Accessible Production Drawing	SCALE 1:1	
			SHEET 4 OF 4	
			REV B1	