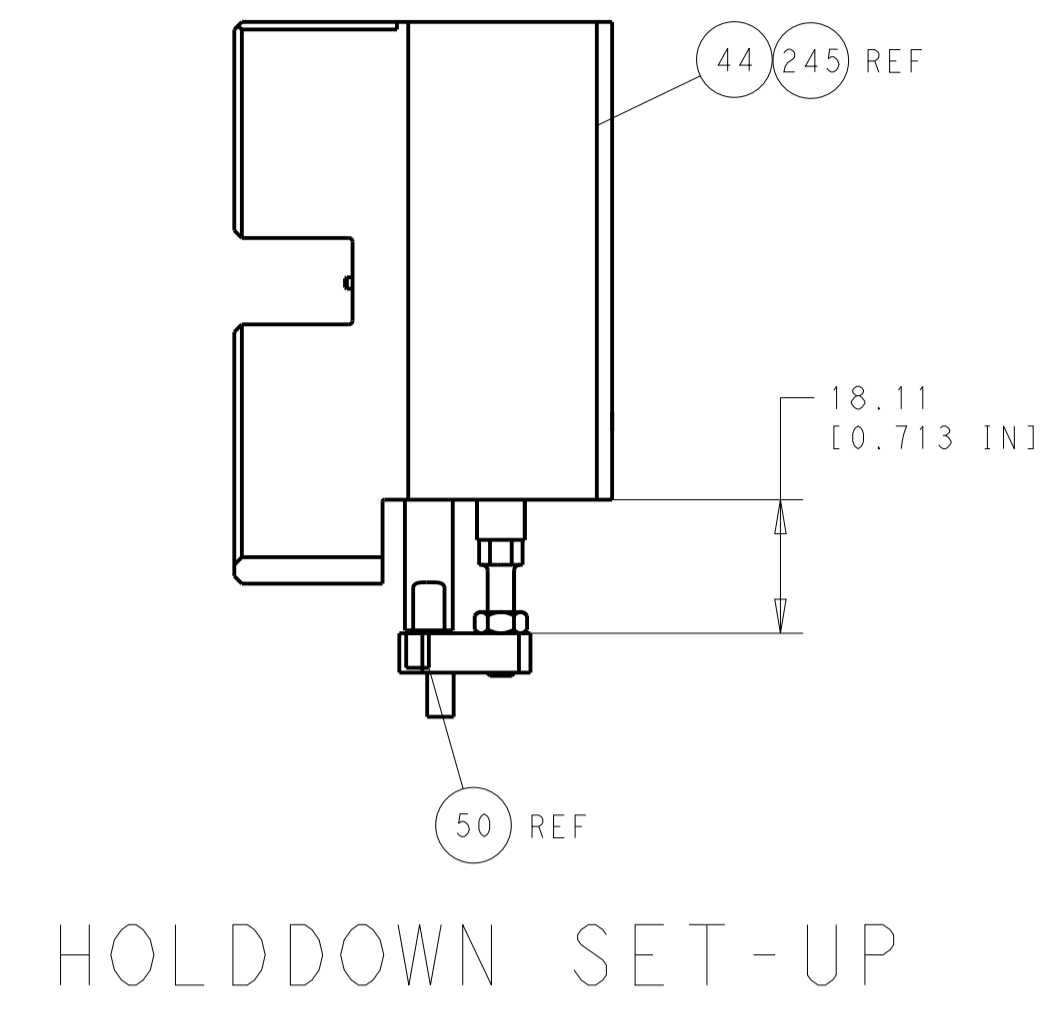
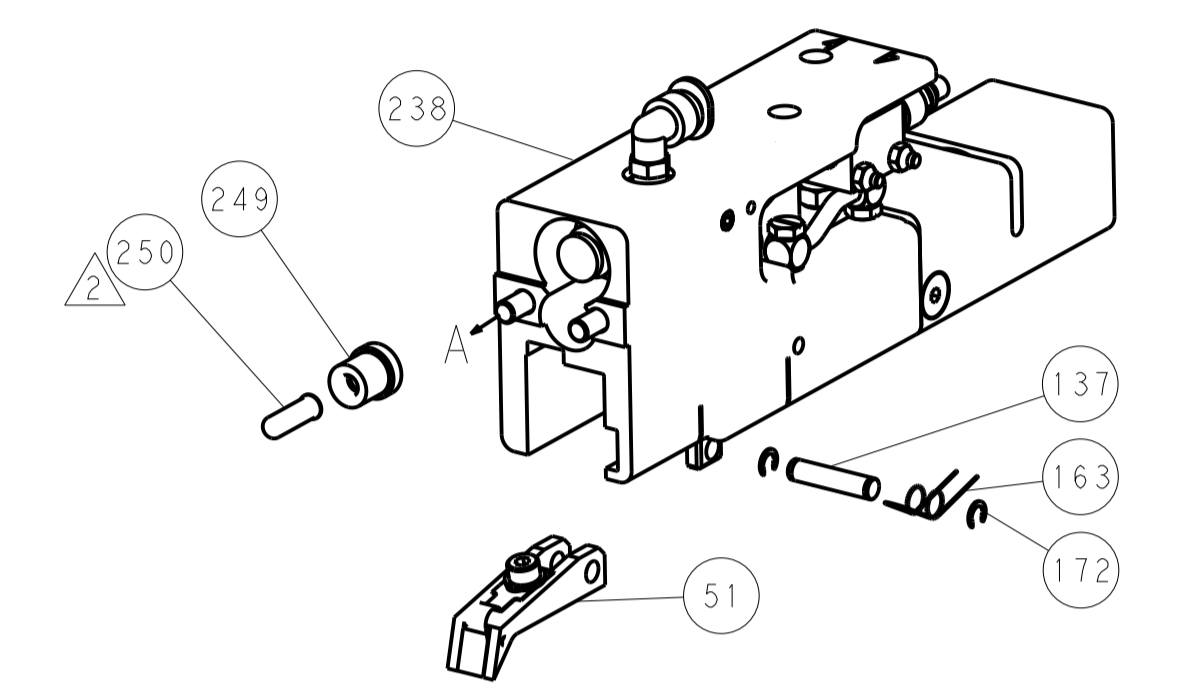


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
				SEE SHEET 1			

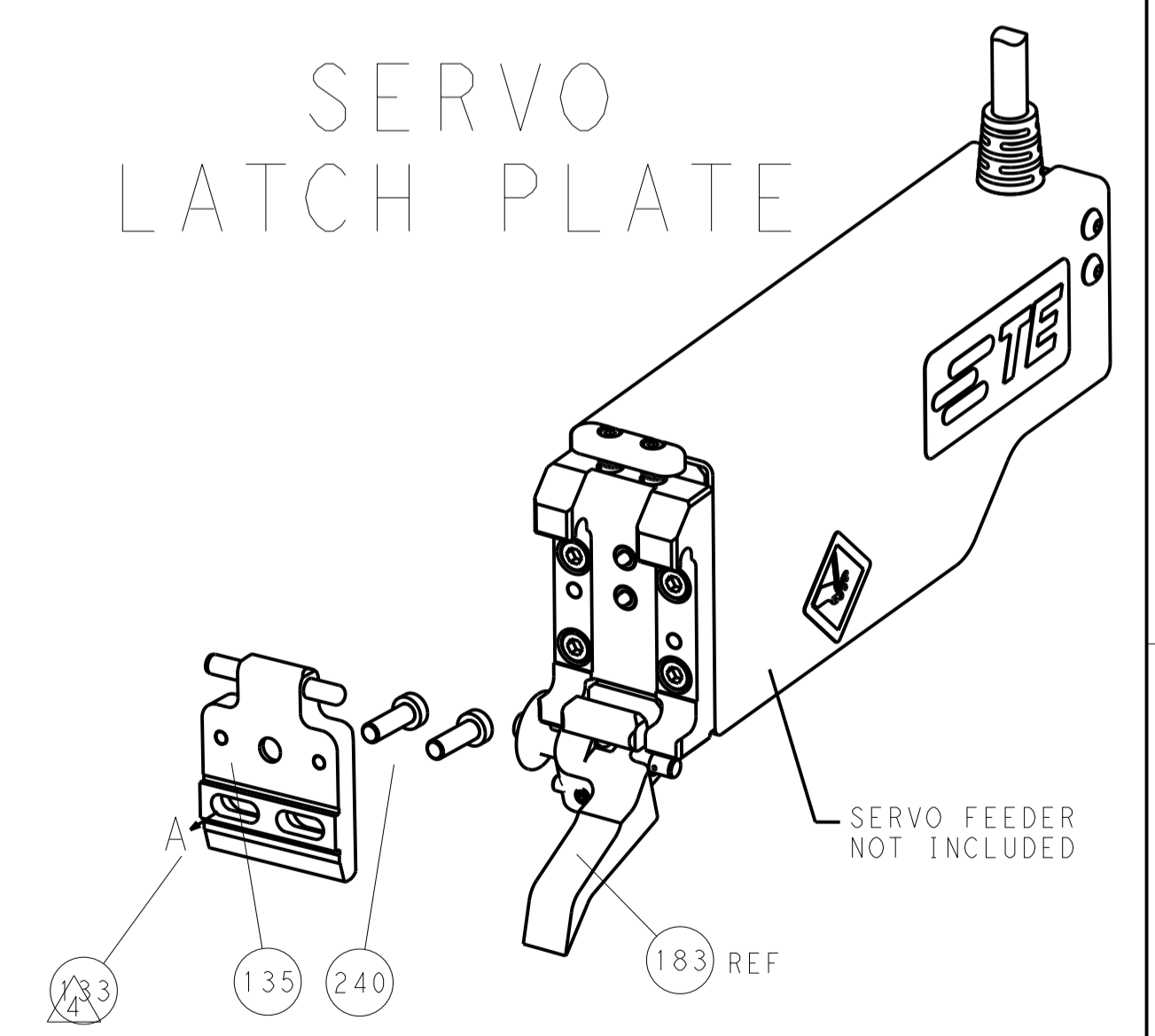


FEED TYPE

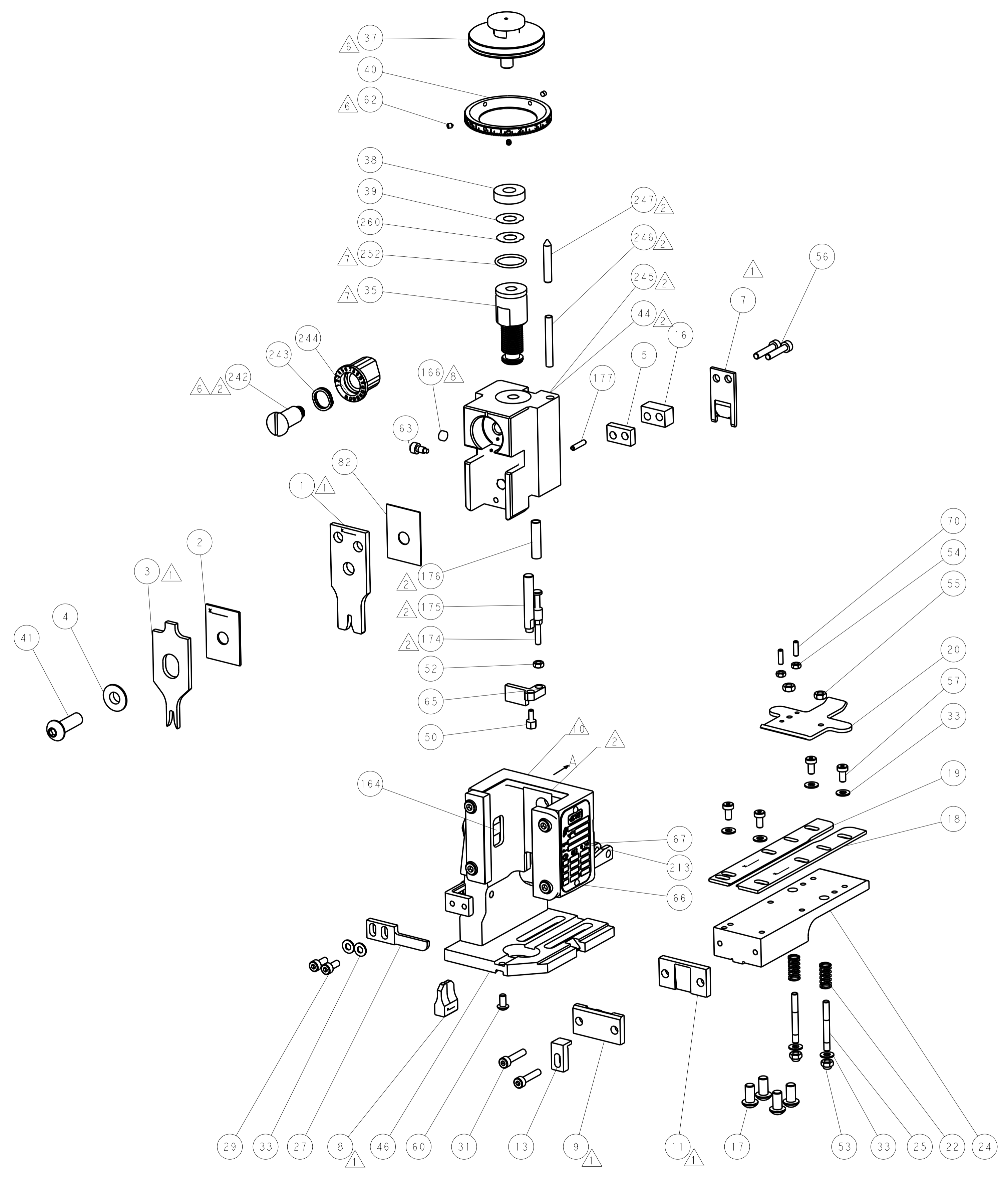
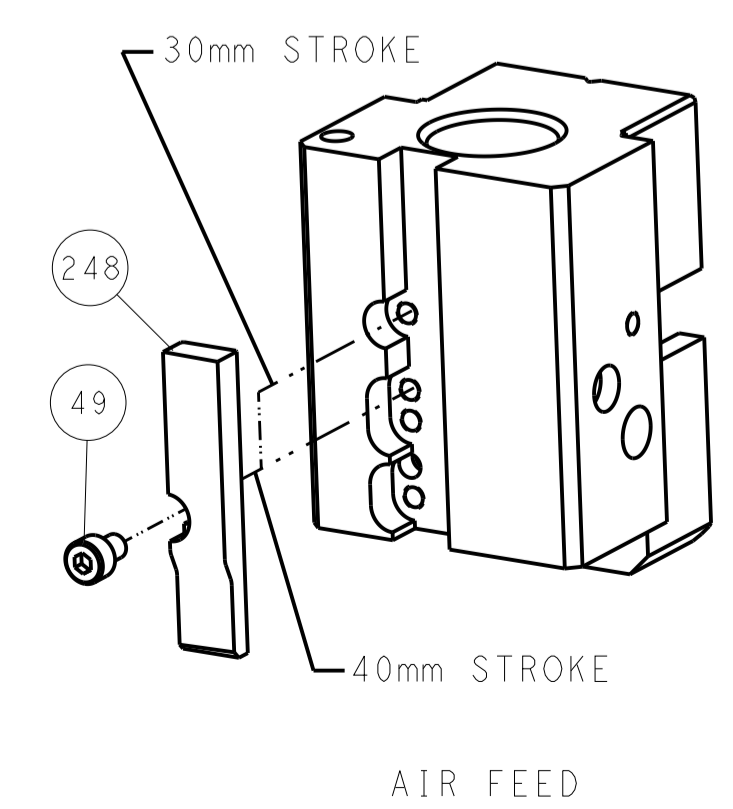
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	16OCT2013	Harrisburg, PA 17105-3608	
	4 PLC ±0.001	5 PLC ±0.001	6 PLC ±0.001	7 PLC ±0.001	16OCT2013	NAME	
	ANGLES ±0.001	FINISH		APVD		PRODUCT SPEC	
MATERIAL				H. GUO		Ocean End Feed Applicator	
				16OCT2013		APPLICATION SPEC	
				APVD		SIZE	
				G. BAILEY		CAGE CODE	
				Y. YIN		DRAWING NO	
				16OCT2013		A11 00779	
				16OCT2013		©=2150389	
				16OCT2013		RESTRICTED TO	
				16OCT2013		Customer Accessible Production Drawing	
				16OCT2013		SCALE 1:1 SHEET 2 OF 4 REV A	

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	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150389-5	-	-
	2-2150389-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2031314-1	-	2119641-2	-
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		INSULATION DIAMETER RANGE	
5.20-5.80 mm [.205-.228 IN]		1.40-2.10 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+/-0.002]	5.7
1.00mm2	1.45+/-0.05 [.057+/-0.002]	5.7
0.75mm2	1.35+/-0.05 [.053+/-0.002]	6.8
0.50mm2	1.30+/-0.05 [.051+/-0.002]	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.

-77-27-25-22	PART NO	DESCRIPTION	ITEM NO
- 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

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	-	-	-

- 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
- - - -	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
- 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
- - - 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	240644-5	PLATE, REAR SHEAR	11
- - - -	-	-	10
- 1 1 1	3-690482-2	PLATE, FRONT SHEAR	9
1 1 1 1	1803060-4	ANVIL, COMBINATION, END FEED	8
- 1 1 1	1-2217206-1	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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN BY		DATE		CHECKED BY		DATE	
mm	0 PLC ±.5	1 PLC ±.3	2 PLC ±.13	3 PLC ±.013	4 PLC ±.0001	ANGLES	±.0001	FINISH	AS SUPPLIED	Y. YIN	16OCT2013
				G. BAILLEY		16OCT2013		H. GUO		16OCT2013	
MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
						A1 00779		3 OF 4		A	

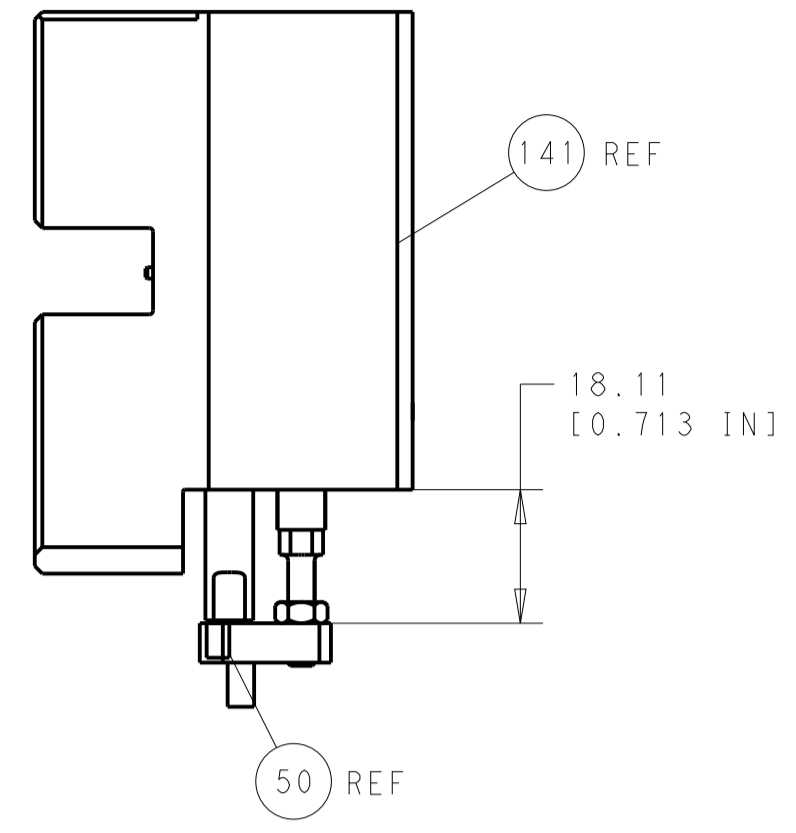


TE Connectivity
 Harrisburg, PA 17105-3608

Ocean End Feed
 Applicator

Customer Accessible Production Drawing

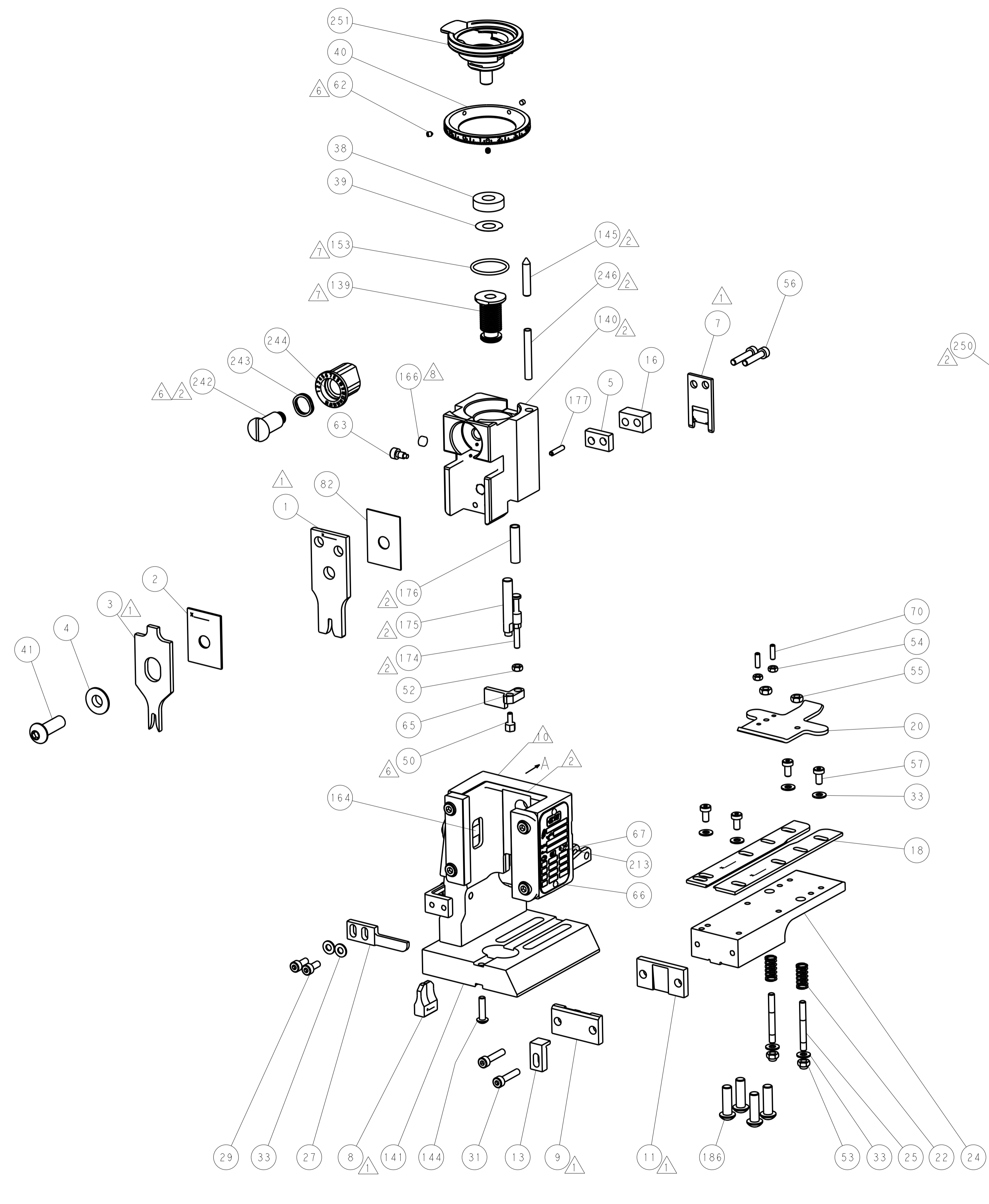
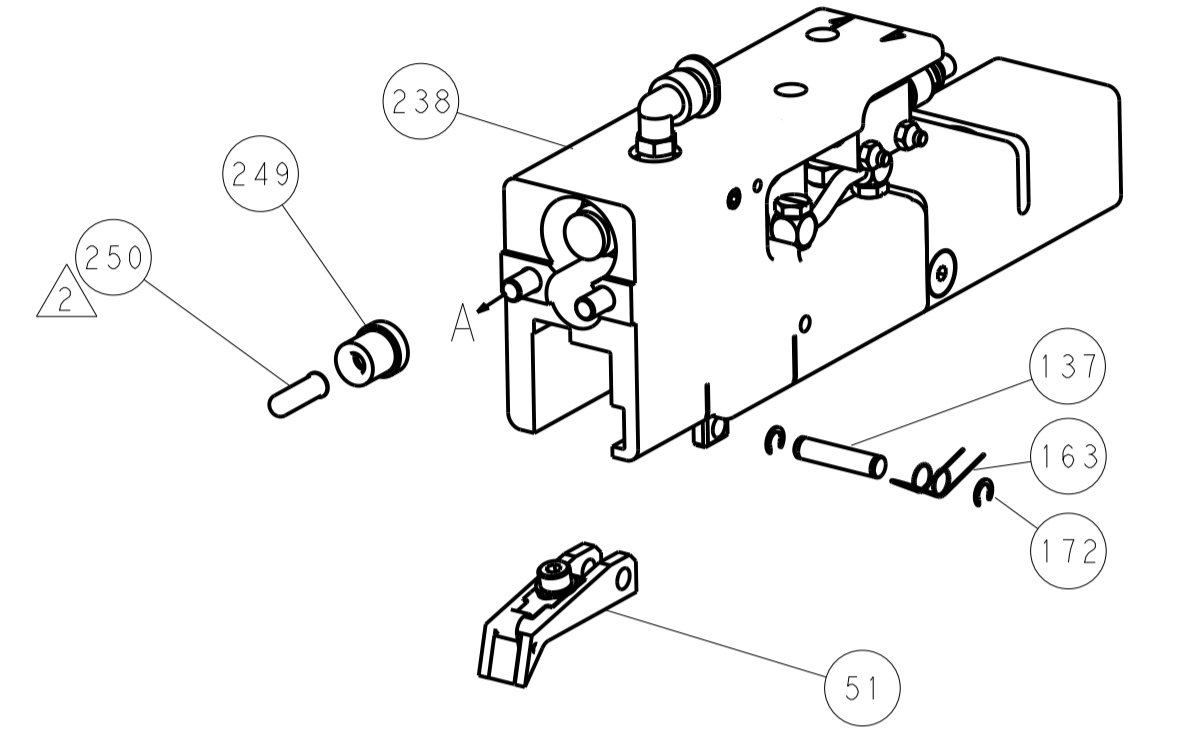
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1			



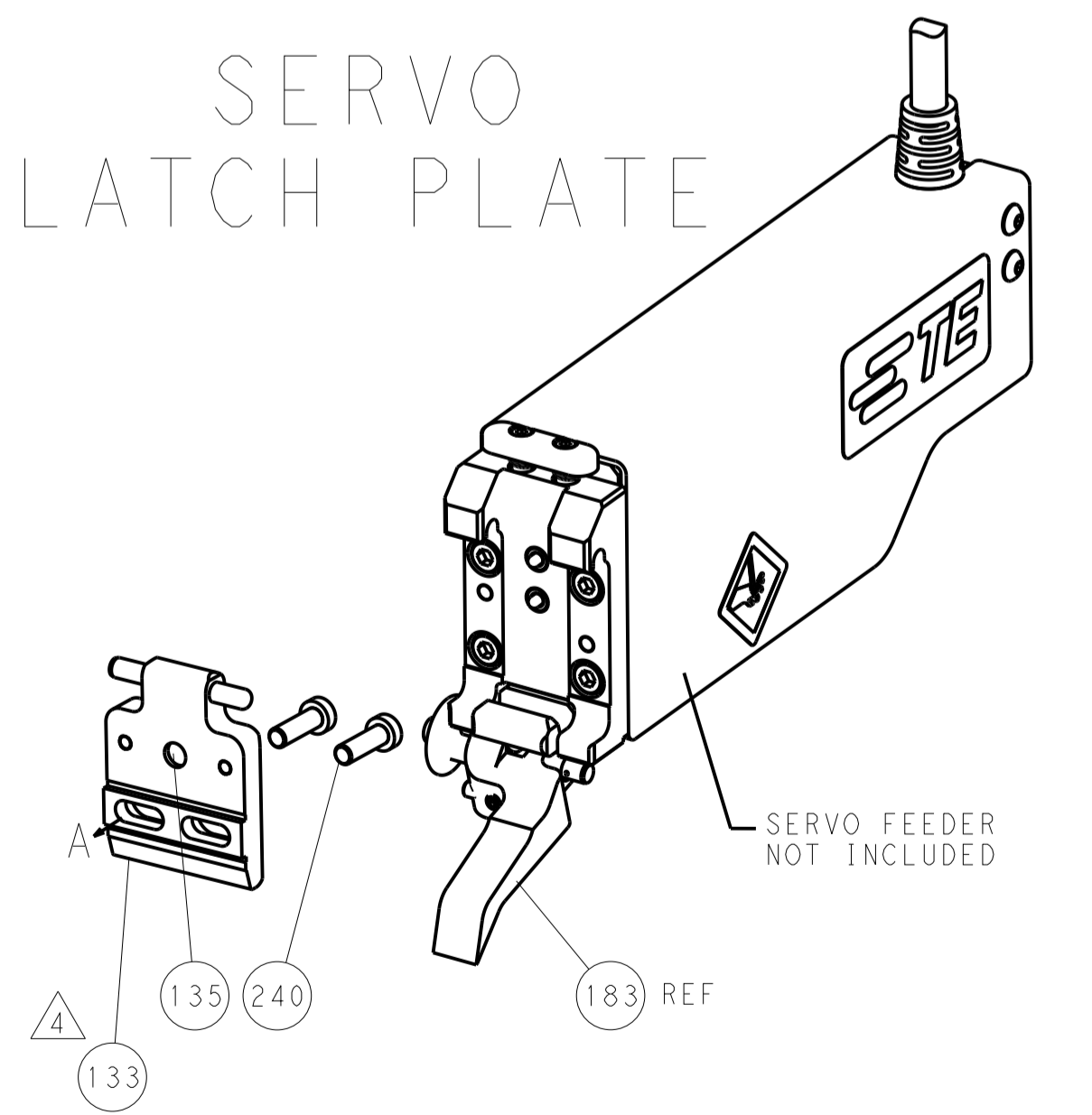
HOLDDOWN SET-UP

FEED TYPE

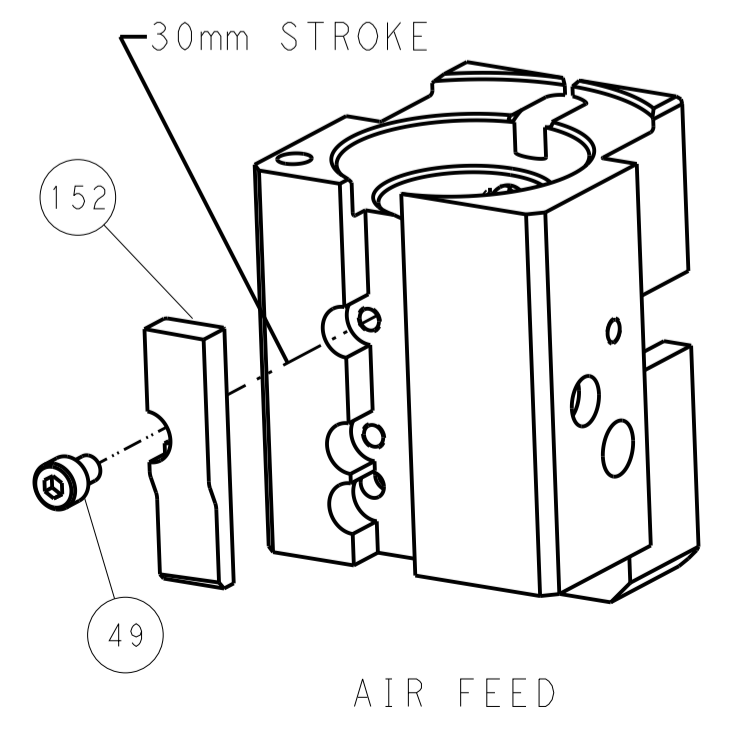
PNEUMATIC



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		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	16OCT2013	Harrisburg, PA 17105-3608	
	4 PLC ±0.001	5 PLC ±0.001	6 PLC ±0.001	APVD	16OCT2013	NAME	
MATERIAL:	FINISH:	WEIGHT:	ANGLES:	Customer Accessible Production Drawing	SCALE	1:1	SHEET 4 OF 4
				00779 ©=2150389		REV A	