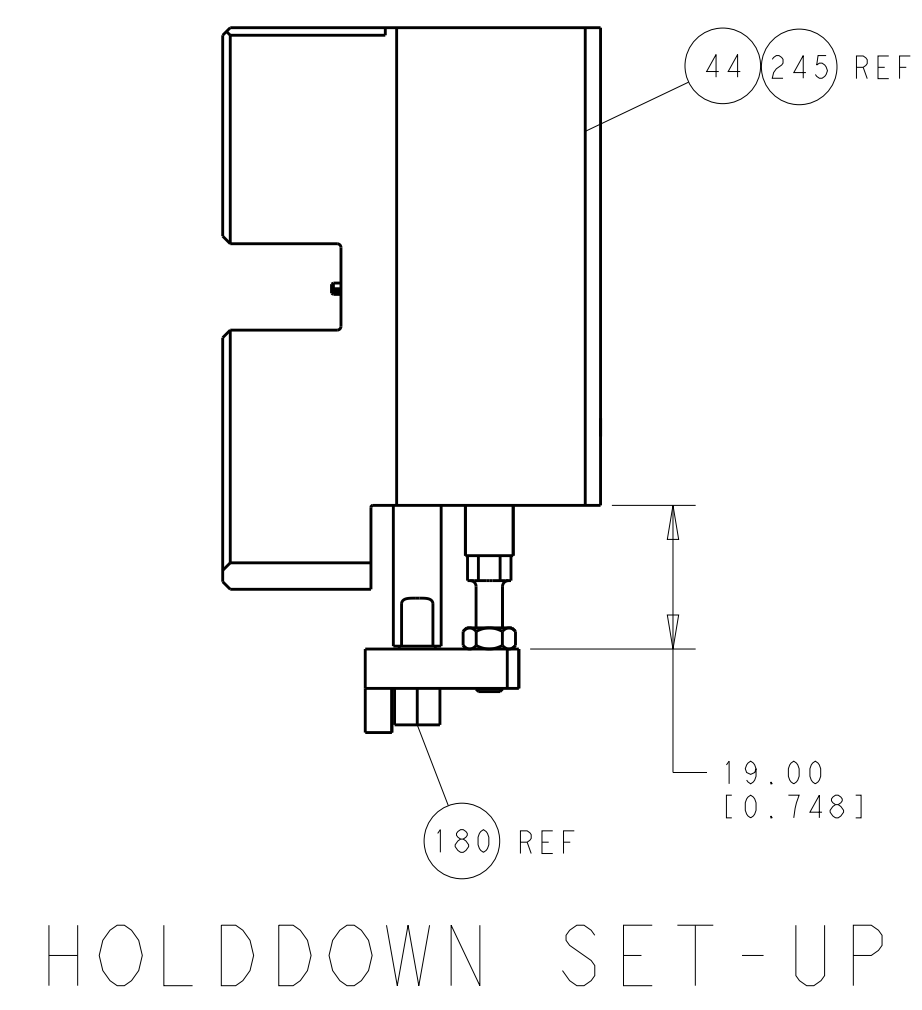
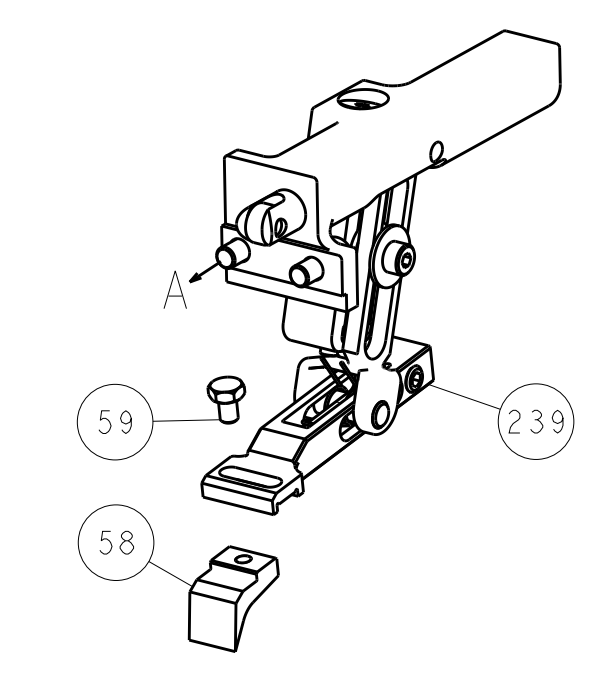




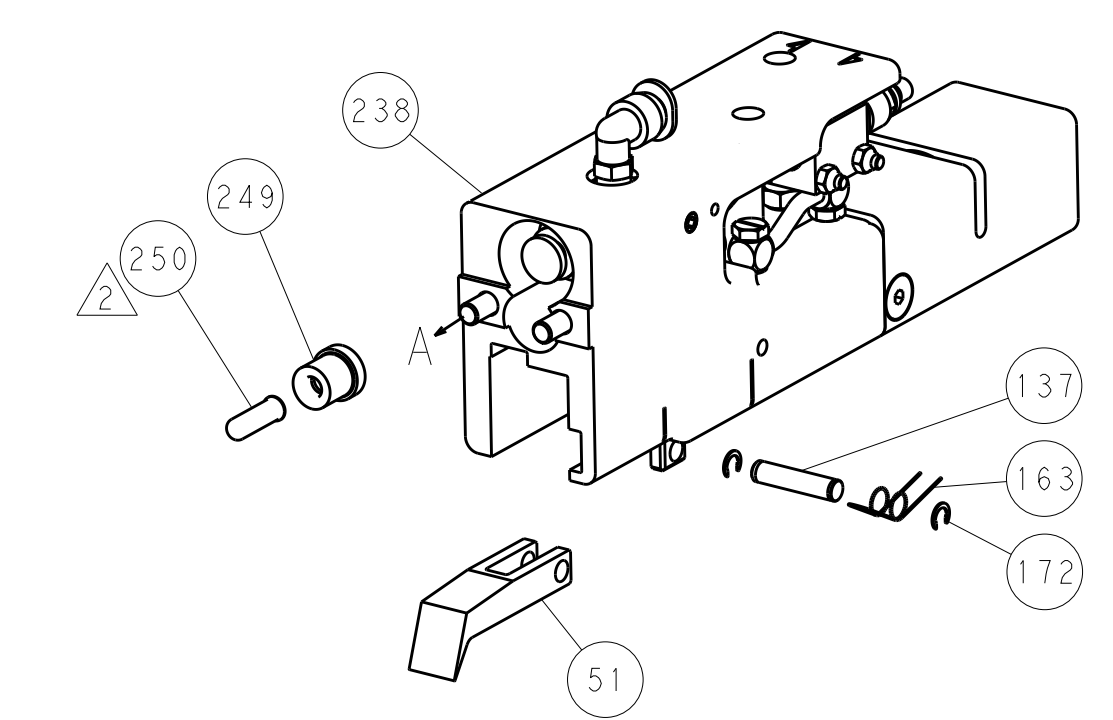
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
-			SEE SHEET 1	-	-



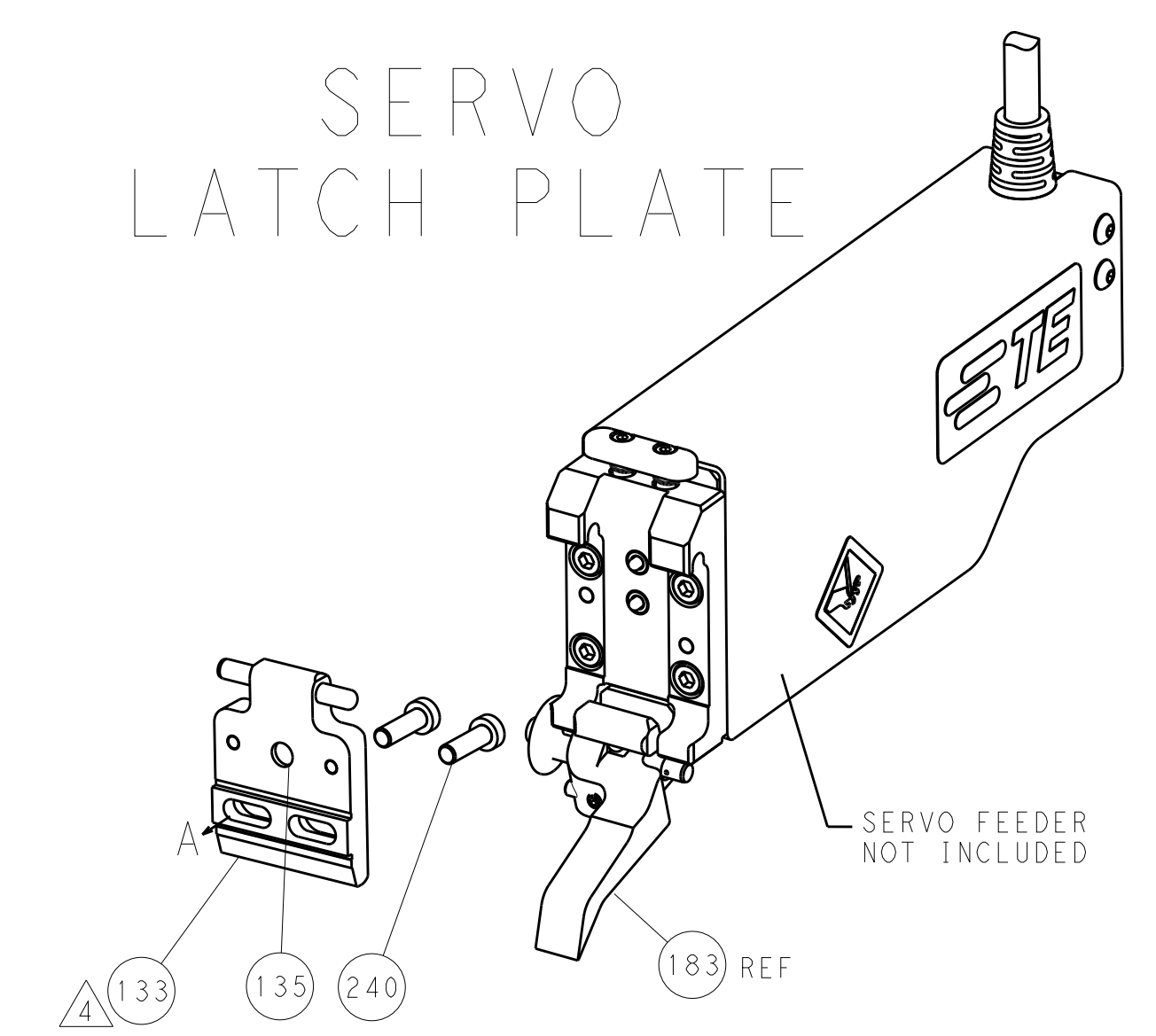
FEED TYPE  
MECHANICAL



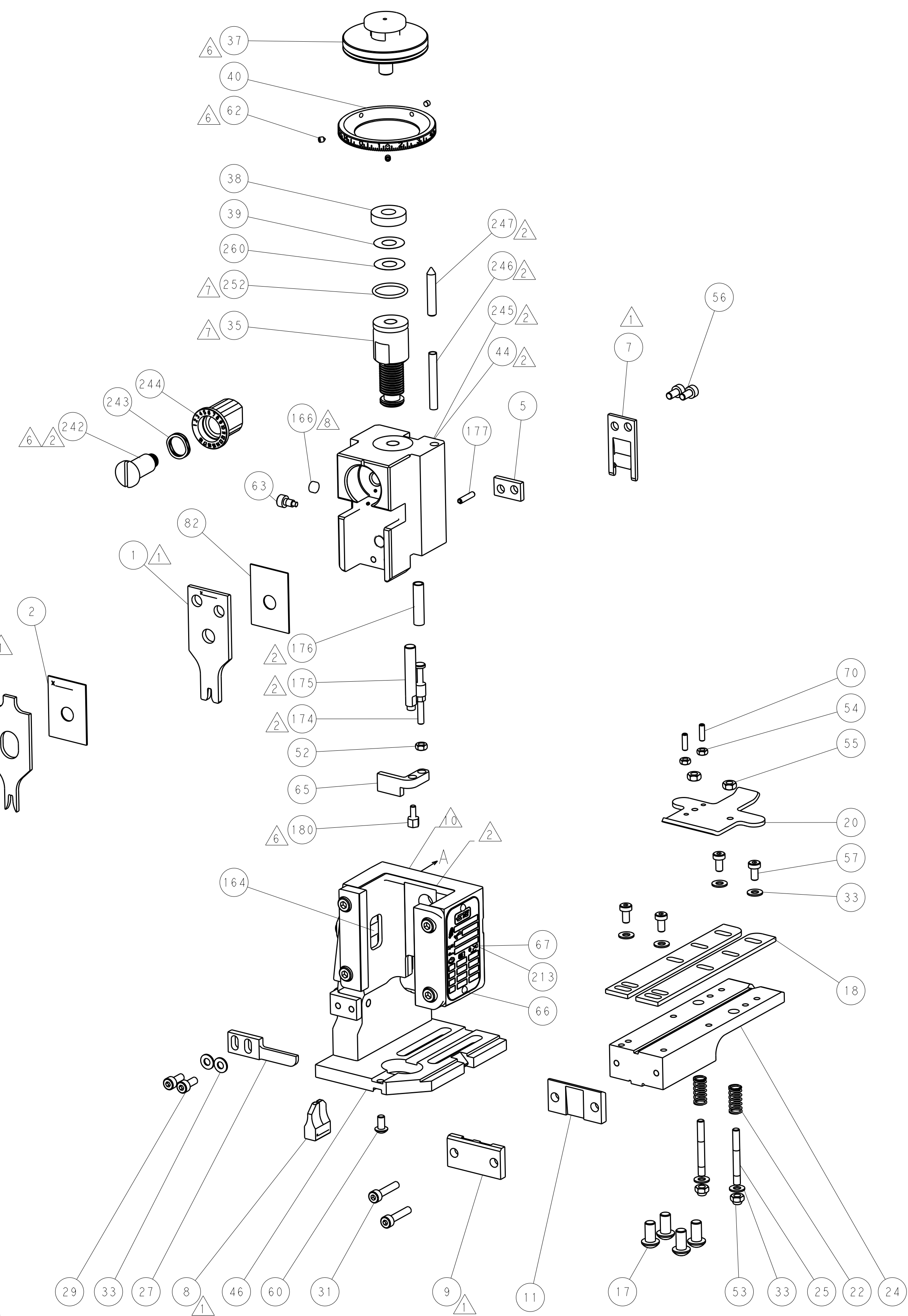
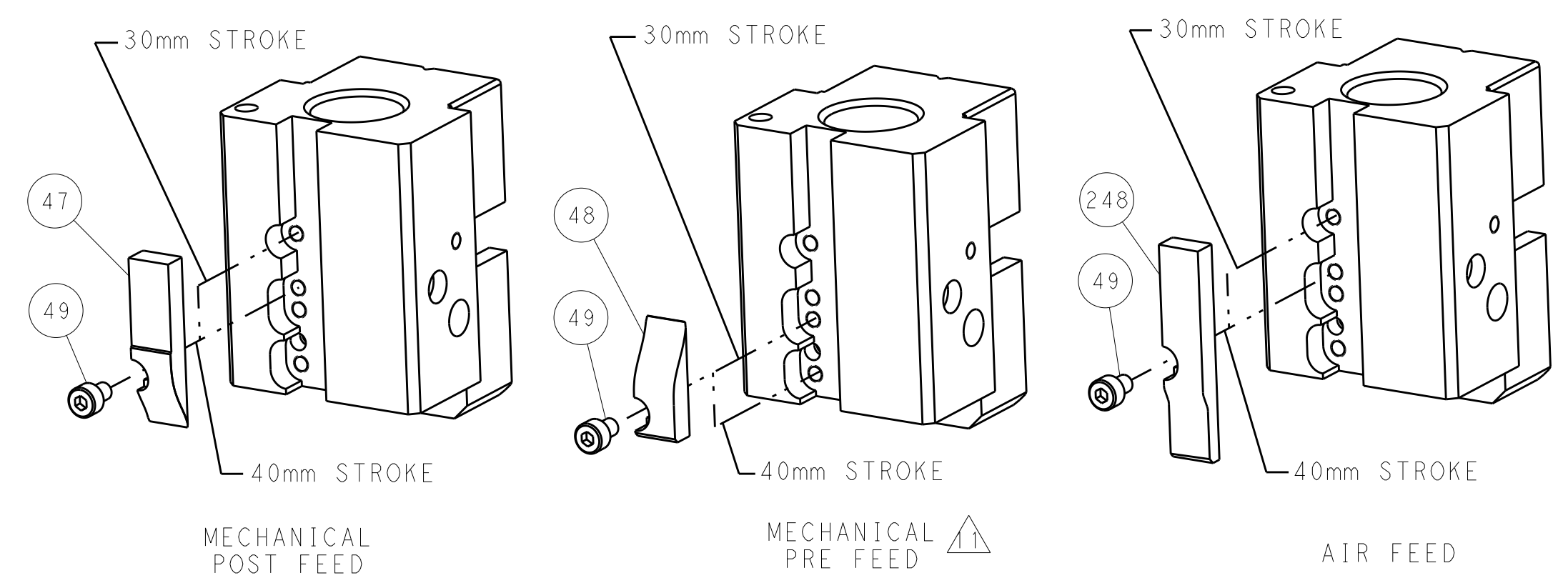
PNEUMATIC



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:		DWG: 30NOV2012		TE Connectivity	
mm		0 PLC ±0.5		CHK: S.XI 30NOV2012		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APPV: J. CRUZ 30NOV2012		NAME: Ocean End Feed Applicator	
H		2 PLC ±0.013		PRODUCT SPEC:		SIZE: CAGE CODE DRAWING NO. RESTRICTED TO	
ANGLES		4 PLC ±0.001		APPLICATION SPEC:		A11 00779 ©=2150303	
FINISH:		5 PLC ±0.001		WEIGHT:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
SCALE: 1:1		SHEET 2 OF 4		REV A		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150303-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150303-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150303-4	-	-	
	2-2150303-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150303-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150303-4	-	-	
	2-2150303-5	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
	2-2150303-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150303-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.29 mm [.090]	F	
INSUL 3.05 mm [1.20]	F	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: .187 SR FASTIN/FASTON		
WIRE STRIP LENGTH 3.90-4.70 mm [1.54-.185 IN]		INSULATION DIAMETER RANGE 1.50-2.40 mm [1.059-.094 IN]
TERMINAL APPLICATION SPECIFICATION	114-20011	-
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
282180-1	282180-2	282180-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.49 +/- 0.030 [.059 +/- .001]	7.9
1.00mm2	1.44 +/- 0.030 [.057 +/- .001]	8.3
0.75mm2	1.39 +/- 0.030 [.055 +/- .001]	8.9
0.50mm2	1.34 +/- 0.030 [.053 +/- .001]	9.3

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150303-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150303-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150303-5
- 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 ITEMS 62, 180 & 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.

-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO
- 1 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

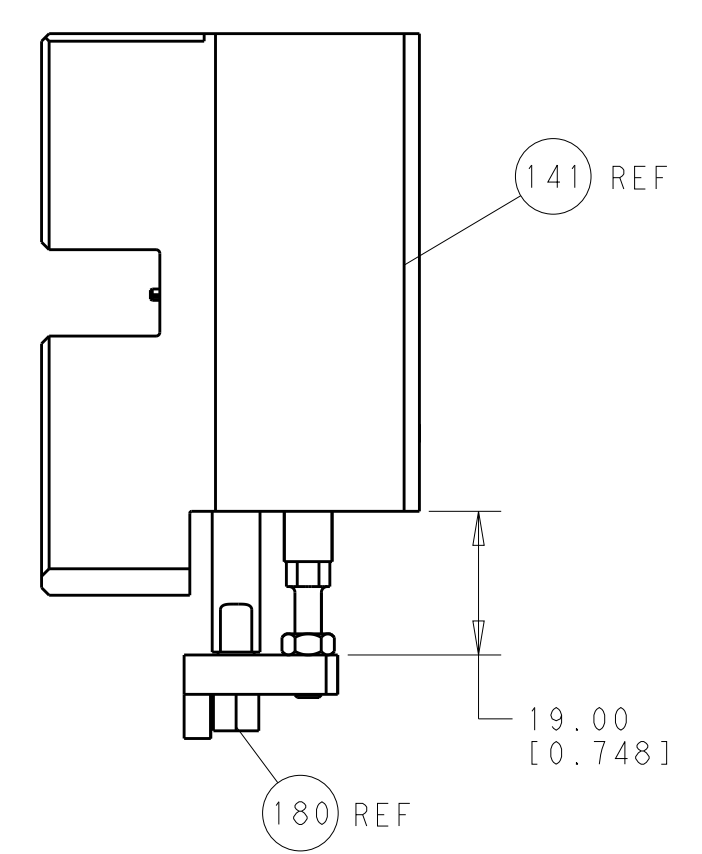
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
-	-	-	SEE SHEET 1	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
- 1 1 1 1	1-22279-3			SPRING, COMPRESSION	246
- 1 1 1 1	2119082-9			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
- - 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	1752354-4			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	455888-5			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	66
- 1 1 1 1	1901681-5			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	2168083-2			SCR, SKT HD CAP, RoHS, M4 X 8.0	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	2119644-2			RAM WASHER, PRECISION	38
- 8 8 8 8	1-18028-2			WASHER, FLAT, REG M4	33
- 2 2 2 2	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	1-1752371-4			PLATE, STRIP GUIDE	24
- 2 2 2 2	2-22281-3			SPRING, COMPRESSION	22
- 1 1 1 1	1752373-4			DRAG	20
- 2 2 2 2	1901259-5			GUIDE, LOWER STRIP	18
- 1 1 1 1	240833-3			PLATE, REAR SHEAR	11
- - - - -	-			-	10
- 1 1 1 1	2-690482-1			PLATE, FRONT SHEAR	9
1 1 1 1 1	3-1333217-7			ANVIL, EF .090	8
- 1 1 1 1	2217206-4			BLADE, SLUG	7
- - - - -	-			-	6
- 1 1 1 1	240641-5			SPACER	5
- 1 1 1 1	1-238009-0			BLOCK, FL CRIMPER SPACER	4
1 1 1 1 1	1-1633961-1			CRIMPER, INSULATION F PREMIUM	3
- 1 1 1 1	455888-6			SPACER, CRIMPER	2
1 1 1 1 1	4-456406-7			CRIMPER, WIRE PREMIUM	1

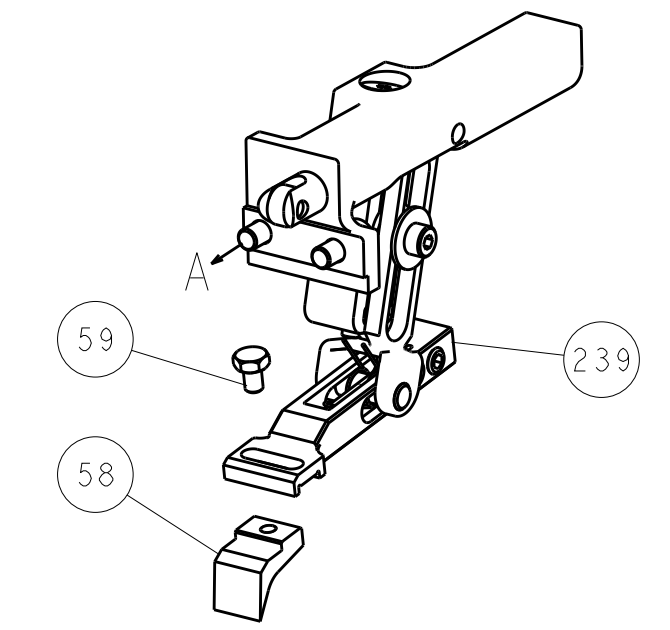
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.3 2 PLC ±.13 3 PLC ±.013 4 PLC ±.001 ANGLES ±.001	DWN: C. CHEN 30NOV2012 CHK: S. XI 30NOV2012 APVD: J. CRUZ 30NOV2012 PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL: FINISH:	NAME: Ocean End Feed Applicator SIZE: A1 CASE CODE: 00779 DRAWING NO: C=2150303 SCALE: 1:1 SHEET: 3 OF 4 REV: A
-----------------------	--	--	---

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

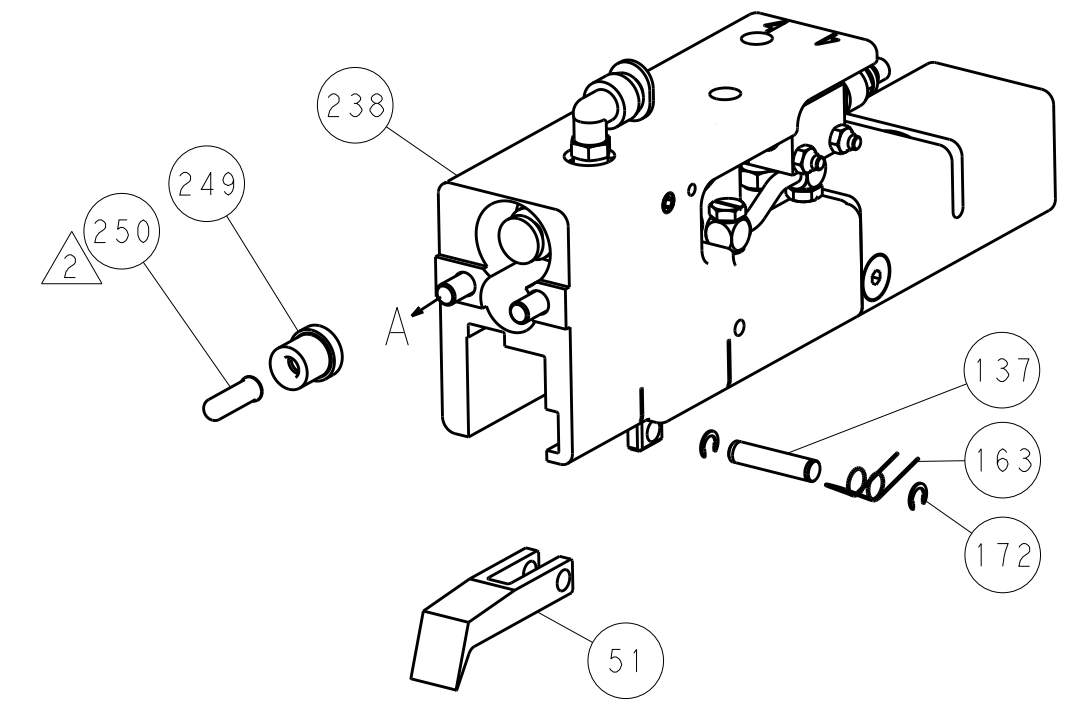


HOLDDOWN SET-UP

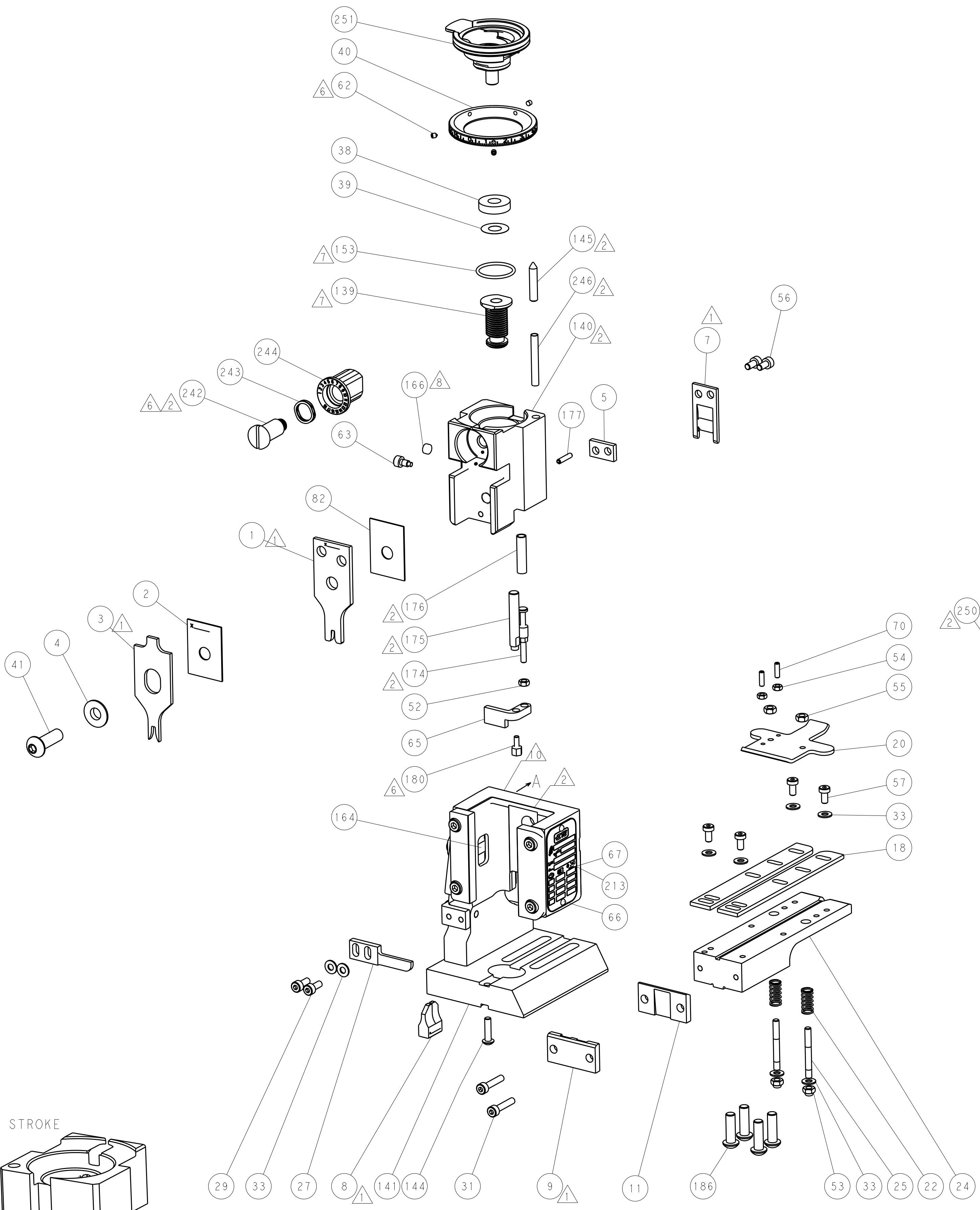
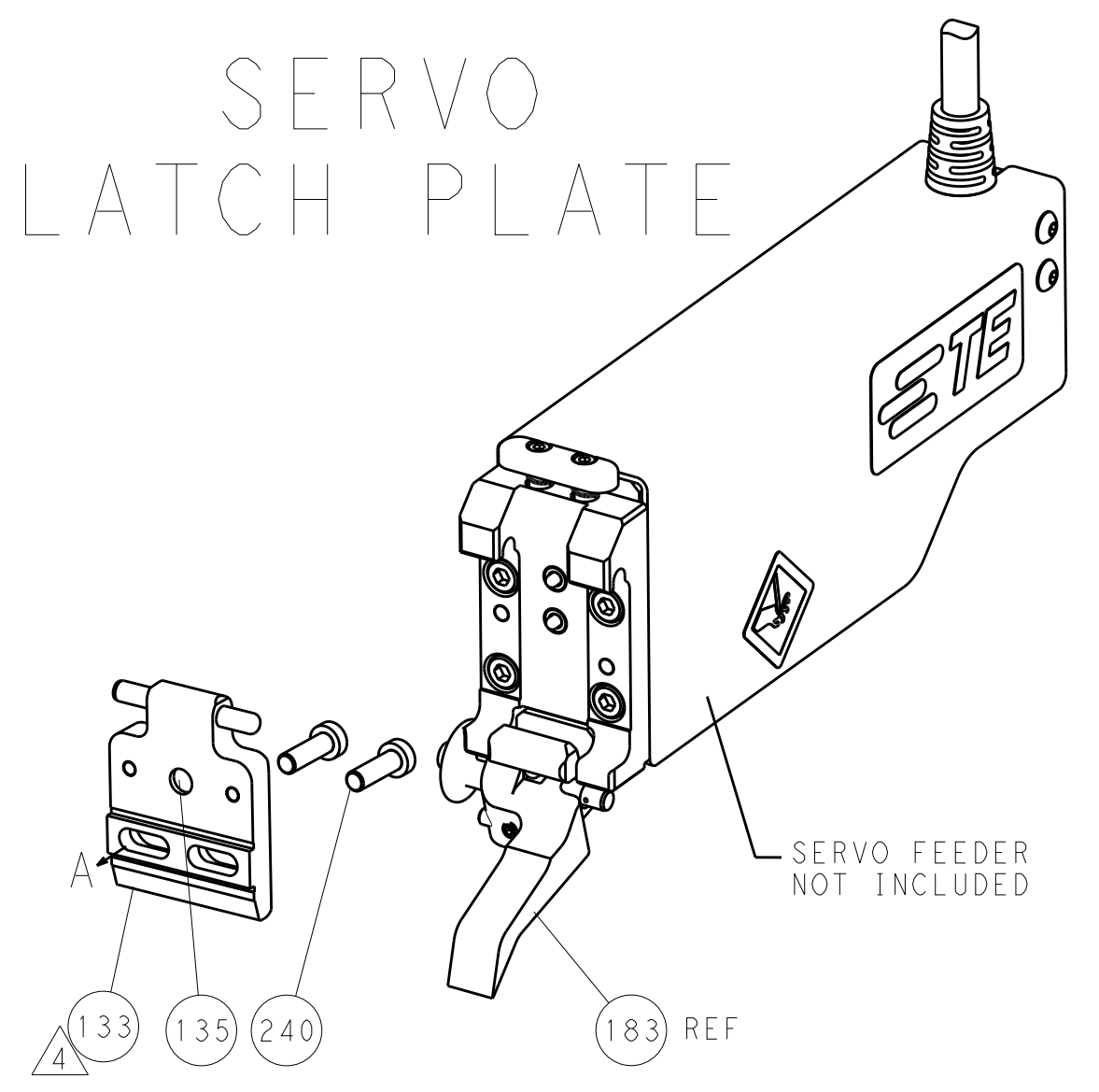
FEED TYPE  
MECHANICAL



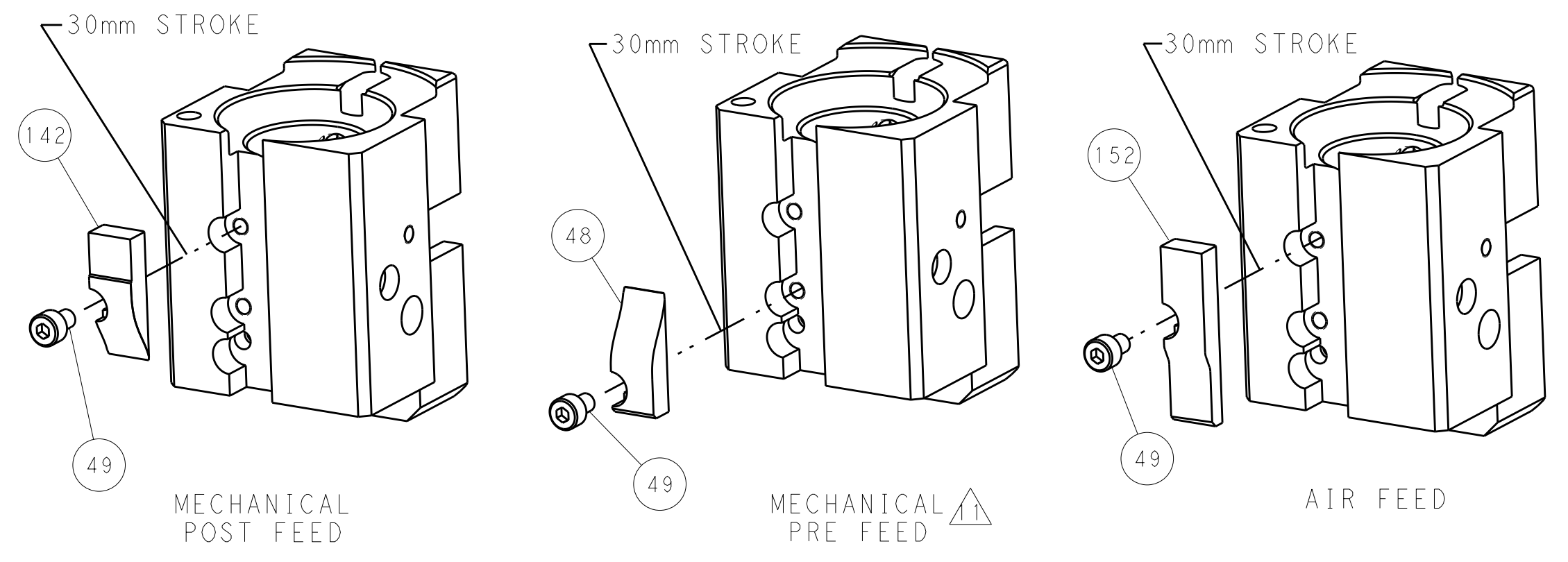
PNEUMATIC



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 L.C. CHEN 30NOV2012		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	CHK S.XI 30NOV2012	Harrisburg, PA 17105-3608	
	4 PLC ±0.013	5 PLC ±0.013	6 PLC ±0.001	7 PLC ±0.001	APVD J. CRUZ 30NOV2012	NAME	
	ANGLES			PRODUCT SPEC		Ocean End Feed	
MATERIAL	FINISH			APPLICATION SPEC		Applicator	
				WEIGHT		SIZE CAGE CODE DRAWING NO	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		A1 00779 C=2150303	
				SCALE 1:1		SHEET 4 OF 4 REV A	