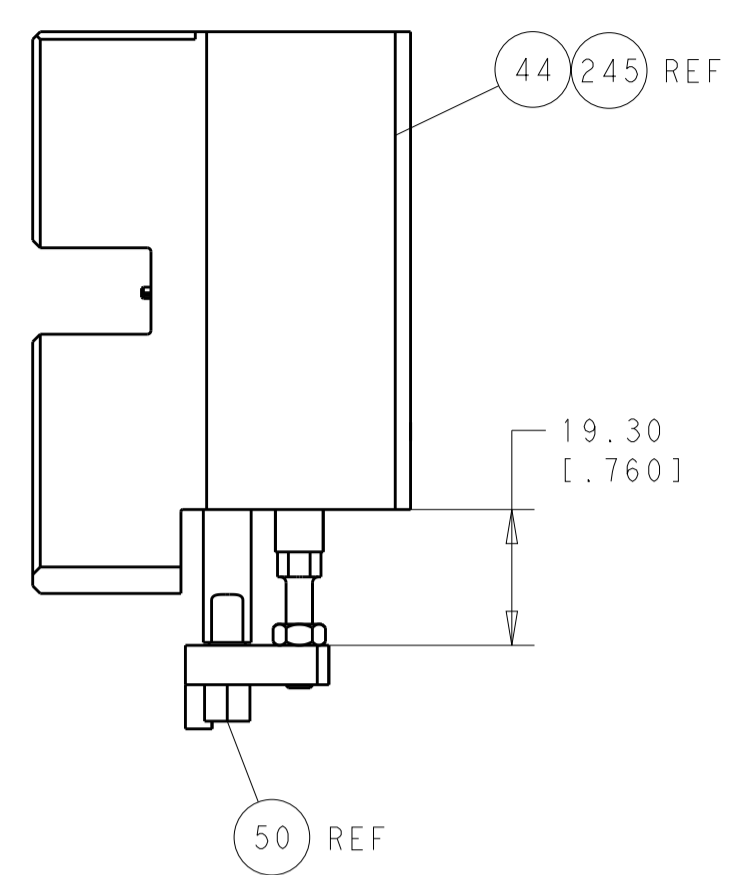
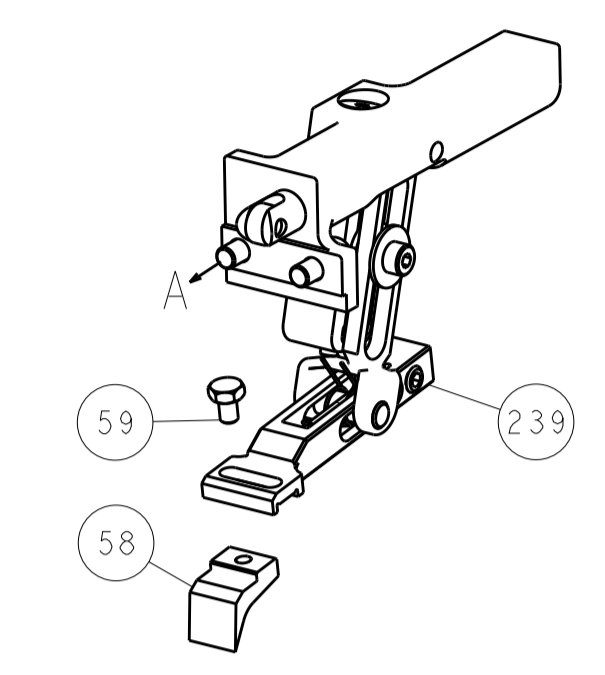


LOC		DIST		REVISONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

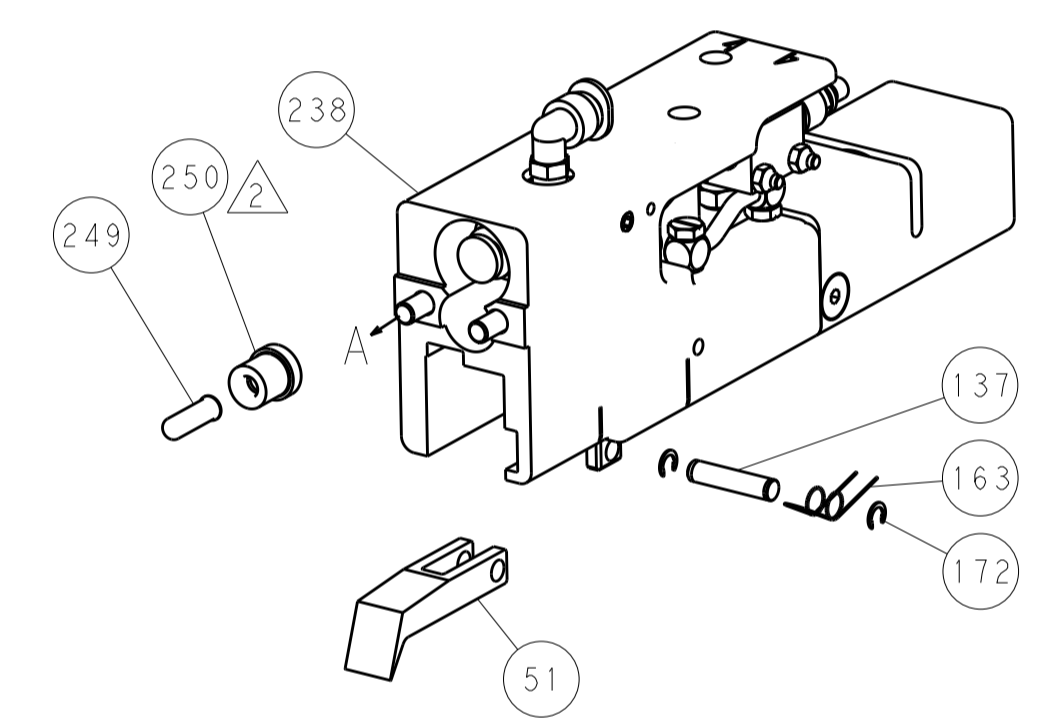


HOLDDOWN SET-UP

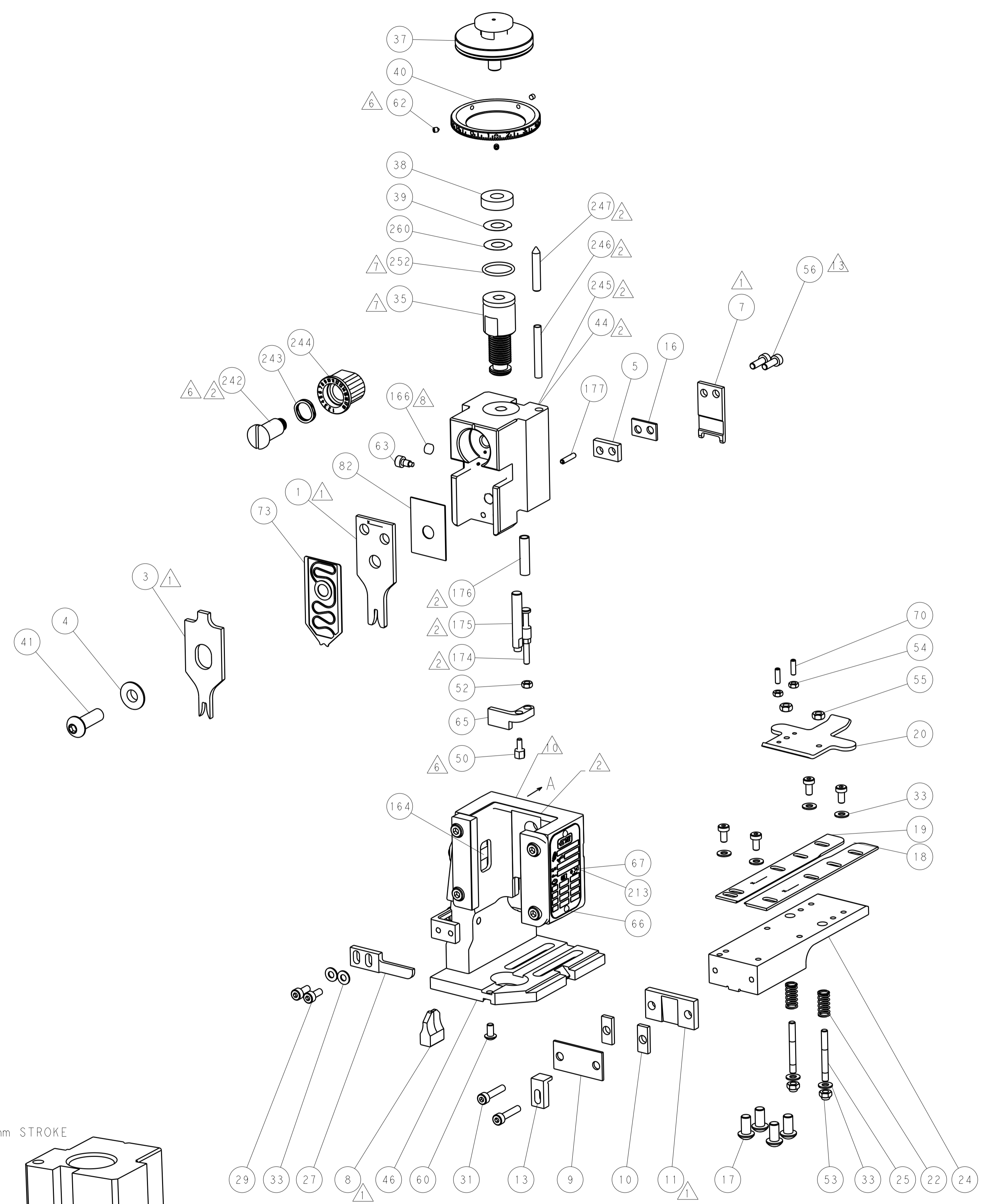
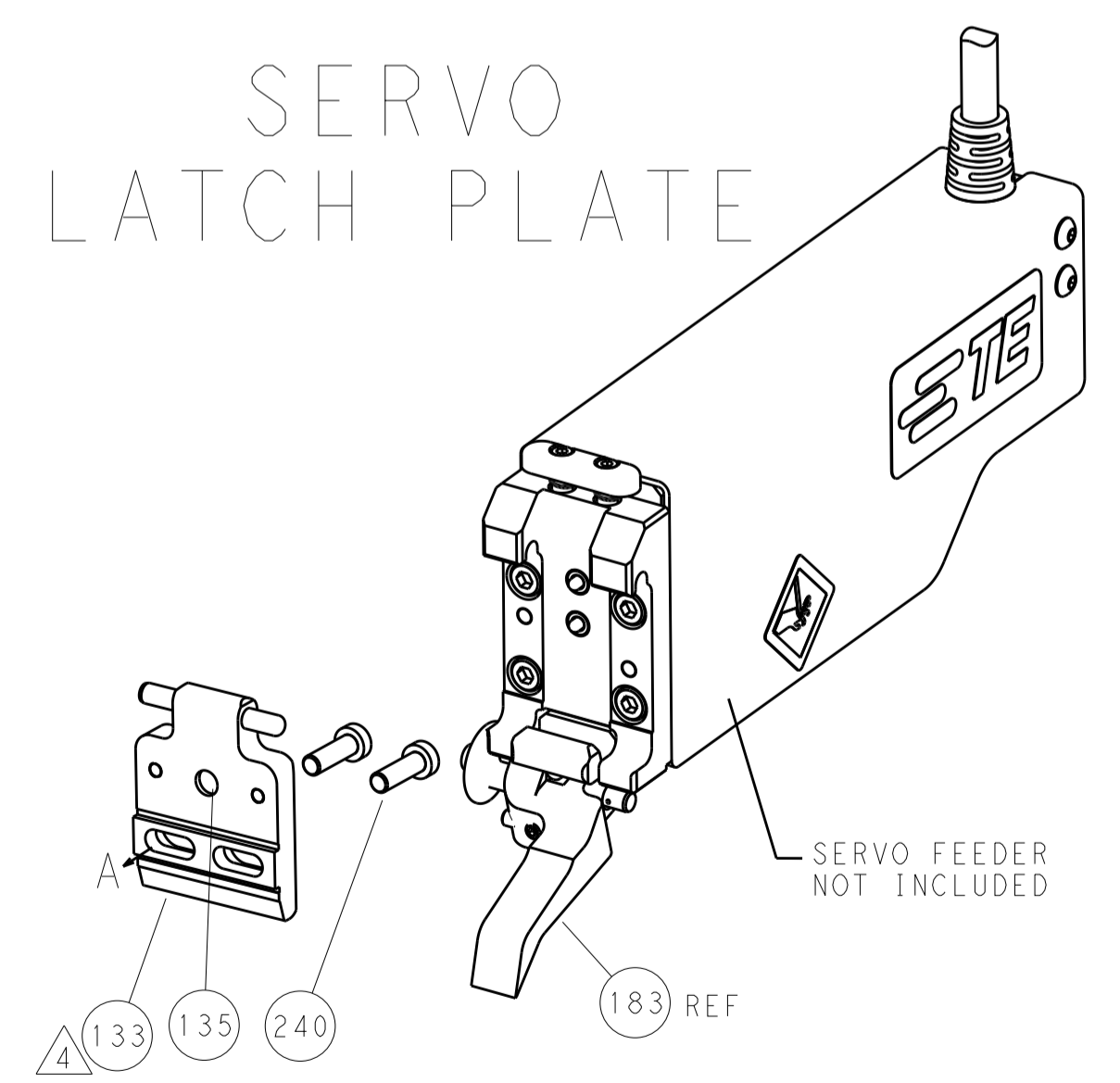
FEED TYPE
MECHANICAL



PNEUMATIC



SERVO
LATCH PLATE

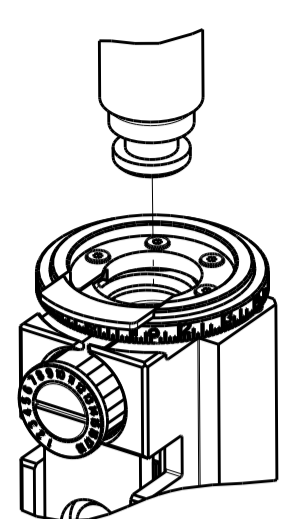


CAM POSITIONS

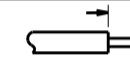



ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)


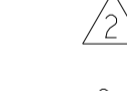

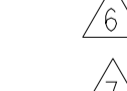


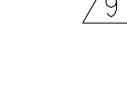



DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		TE Connectivity	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	L.C. CHEN	14AUG2012	Harrisburg, PA 17105-3608	
	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±.1	S.X.I	14AUG2012	NAME	
MATERIAL	FINISH	WEIGHT	SCALE	I. CRUZ	14AUG2012	Ocean End Feed Applicator	
			1:1	PRODUCT SPEC		RESTRICTED TO	
				APPLICATION SPEC		Customer Accessible Production Drawing	
				SIZE	CAGE CODE	DRAWING NO	REV
				A1	00779	2150283	A1
				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						
	2-2150283-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1	
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150283-5	-	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150283-4	-	-	-	
	2-2150283-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150283-5	-	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150283-4	-	-	-	
	2-2150283-5	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	
	2-2150283-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
	7-2150283-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.03 mm [.080]	F	
INSUL 3.30 mm [.130]	F	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL RING			
WIRE STRIP LENGTH 3.58-3.96 mm [.141-.156 IN]		INSULATION DIAMETER RANGE ∅2.03-2.54 mm [.080-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41582	41576	41579	41580
41581	41589	41590	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.45+/-0.05 [.057+/-0.002]	9.6
(2)24 AWG	1.37+/-0.05 [.054+/-0.002]	10.4
22 AWG	1.37+/-0.05 [.054+/-0.002]	10.4
24 AWG	1.32+/-0.05 [.052+/-0.002]	10.9

-  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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150283-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150283-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150283-5
- 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 ITEMS 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.
-  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.
-  CUT TO LENGTH AT ASSEMBLY.

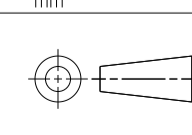
***WARNING**
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

ITEM NO	DESCRIPTION	ITEM NO
- 1 1 1 1 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	1-22279-3 SPRING, COMPRESSION	246
- 1 1 1 1 1	2119082-9 CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-77-27-25-22-21	PART NO	DESCRIPTION

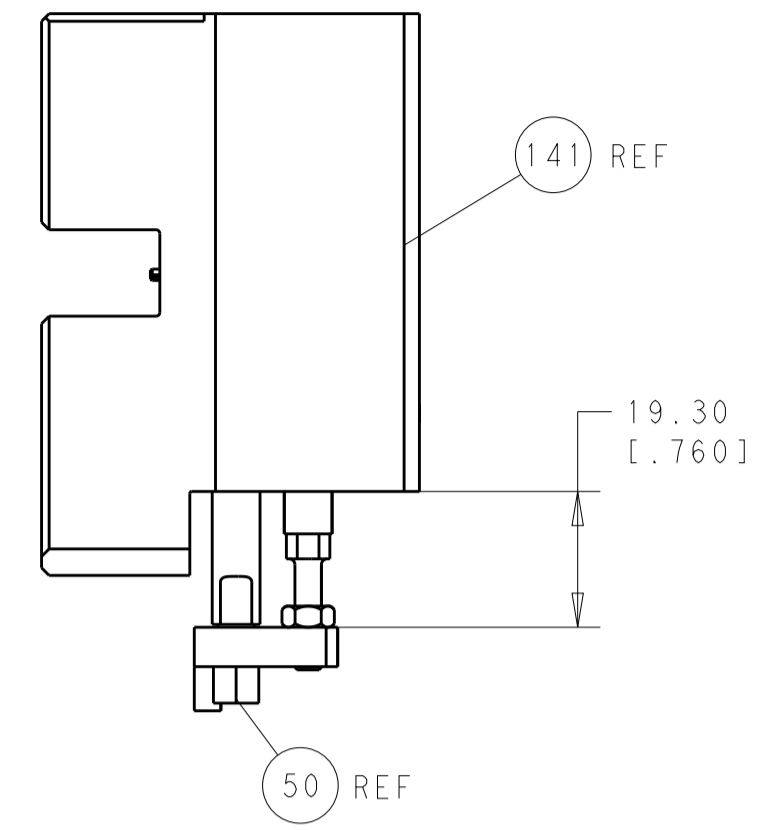
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

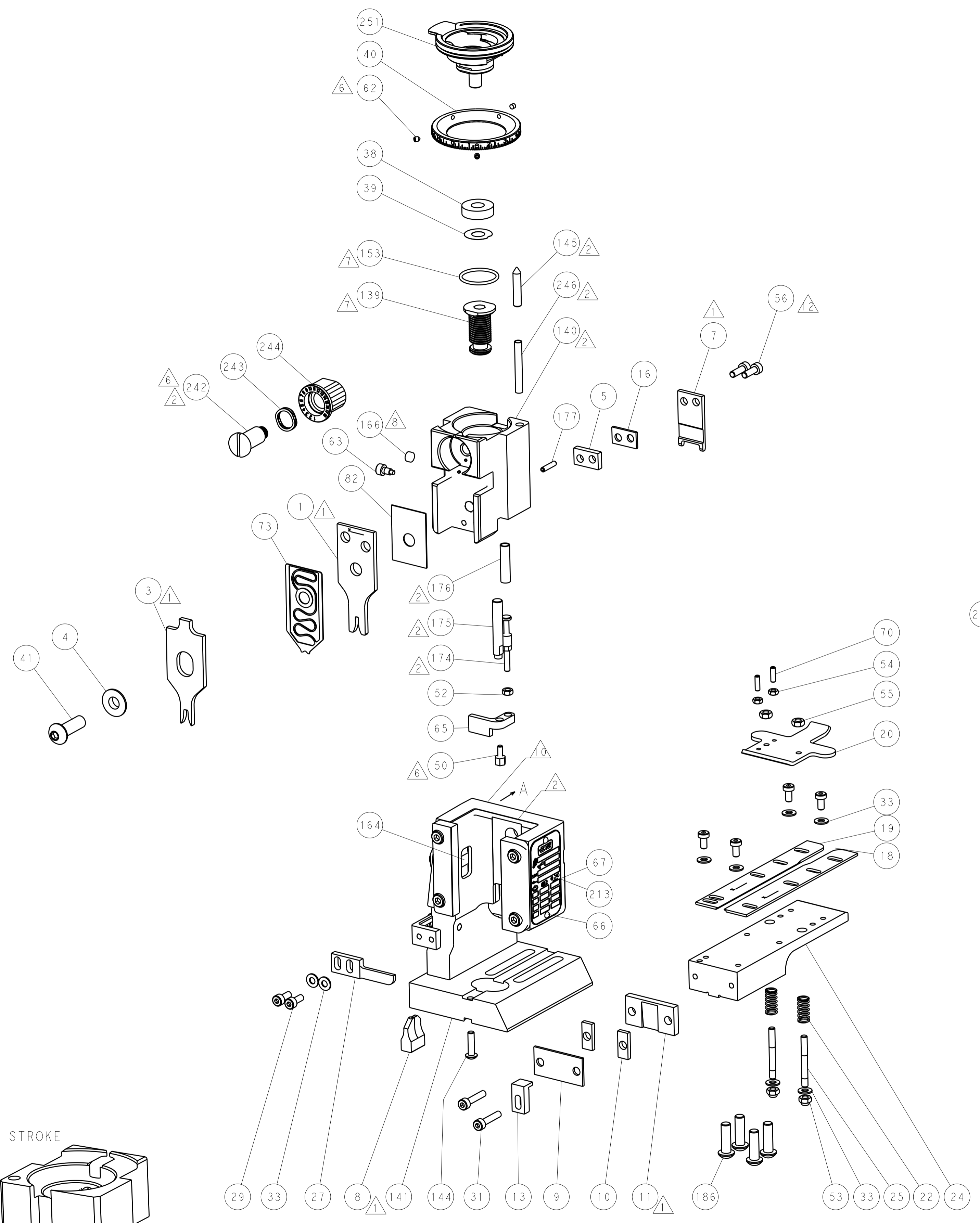
- 1 1 1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
- - 2 - -	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
- - - 1 -	2119580-1	MECHANICAL FEED ASSEMBLY	239
- - - 1 -	2063440-1	AIR FEED MODULE	238
- - 1 - -	2119740-2	TAG, IDENTIFICATION	213
- 4 4 4 4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
- - REF - -	1901697-1	FEED FINGER ASSEMBLY, EF	183
- 1 1 1 1 1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
- 1 1 1 1 1	8-22280-7	SPRING, COMPRESSION	176
- 1 1 1 1 1	1752353-2	GUIDE PIN, HOLDDOWN	175
- 1 1 1 1 1	1901680-2	GUIDE PIN, HOLDDOWN	174
- - - 2 -	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
- 1 1 1 1 1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
- REFREFREFREF	994970-2	COUNTER, MAGNETIC	164
- - - 1 -	240638-1	SPRING, FEED FINGER	163
- 1 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 1	2119798-2	DETENT PIN	145
- 1 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 1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
- 1 1 1 1 1	2119651-1	RAM, ASIAN STYLE, END FEED	140
- 1 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 1	455888-5	SPACER, CRIMPER	82
- 1 1 1 1 1	2119791-9	DEPRESSOR, WIRE	73
- 1 1 1 1 1	2119956-2	DOCUMENTATION PACKAGE	71
- 2 2 2 2 2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
- 1 - 1 1 1	2119740-1	TAG, IDENTIFICATION	67
- 2 2 2 2 2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
- 1 1 1 1 1	1901681-1	HOLDDOWN, TERMINAL	65
- 1 1 1 1 1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
- 3 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 4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
- 2 2 2 2 2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
- 2 2 2 2 2	5018030-2	NUT, HEX, REG, RoHS, M4	55
- 2 2 2 2 2	5018030-1	NUT, HEX, REG, RoHS, M3	54
- 2 2 2 2 2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
- 1 1 1 1 1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
- - - 1 -	2119792-2	PAWL, EF, AIR	51
- 1 1 1 1 1	1752354-4	STANDOFF, HOLD-DOWN	50
- - - 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 1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
- 1 1 1 1 1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
- 1 1 1 1 1	2119957-1	APPLICATOR SHIM PACK	39
- 1 1 1 1 1	2119644-1	RAM WASHER, PRECISION	38
- 8 8 8 8 8	1-18028-2	WASHER, FLAT, REG M4	33
- 2 2 2 2 2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
- 2 2 2 2 2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
- 1 1 1 1 1	240639-1	STRIPPER (MACHINING)	27
- 2 2 2 2 2	1320906-1	STUD, THREADED	25
- 1 1 1 1 1	1752371-5	PLATE, STRIP GUIDE	24
- 2 2 2 2 2	2-22281-3	SPRING, COMPRESSION	22
- 1 1 1 1 1	1752373-1	DRAG	20
- 1 1 1 1 1	1901696-2	STRIP GUIDE, REAR	19
- 1 1 1 1 1	1901695-2	STRIP GUIDE, FRONT	18
- 1 1 1 1 1	6-240641-4	SPACER	16
- 1 1 1 1 1	1752360-1	SPACER, HOLD-DOWN	13
- 1 1 1 1 1	240644-9	PLATE, REAR SHEAR	11
- 2 2 2 2 2	1-240645-2	SPACER, SHEAR PLATE	10
- 1 1 1 1 1	2-240642-2	PLATE, FRONT SHEAR	9
1 1 1 1 1 1	1-1803001-0	ANVIL, COMBINATION, END FEED	8
- 1 1 1 1 1	2-240651-0	BLADE, SLUG	7
- 1 1 1 1 1	4-240641-1	SPACER	5
- 1 1 1 1 1	238009-1	BLOCK, FL CRIMPER SPACER	4
1 1 1 1 1 1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
- - - - -	-	-	2
1 1 1 1 1 1	1-456405-5	CRIMPER, WIRE PREMIUM	1

DIMENSIONS: 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.0001	DWN C. CHEN 14AUG2012 CHK S. XI 14AUG2012 APVD J. CRUZ 14AUG2012	NAME Ocean End Feed Applicator
MATERIAL	FINISH	WEIGHT	SIZE CAGE CODE DRAWING NO RESTRICTED TO
			A1 00779 C=2150283
Customer Accessible Production Drawing			SCALE 1:1 SHEET 3 OF 4 REV A1

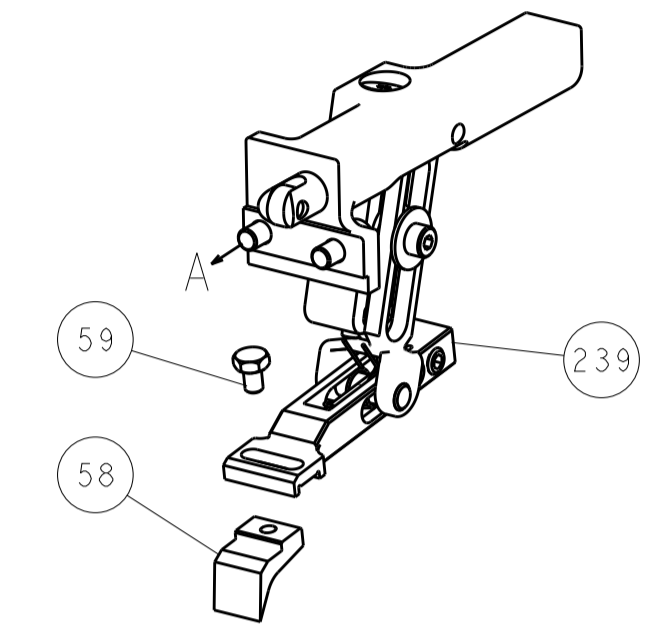
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			



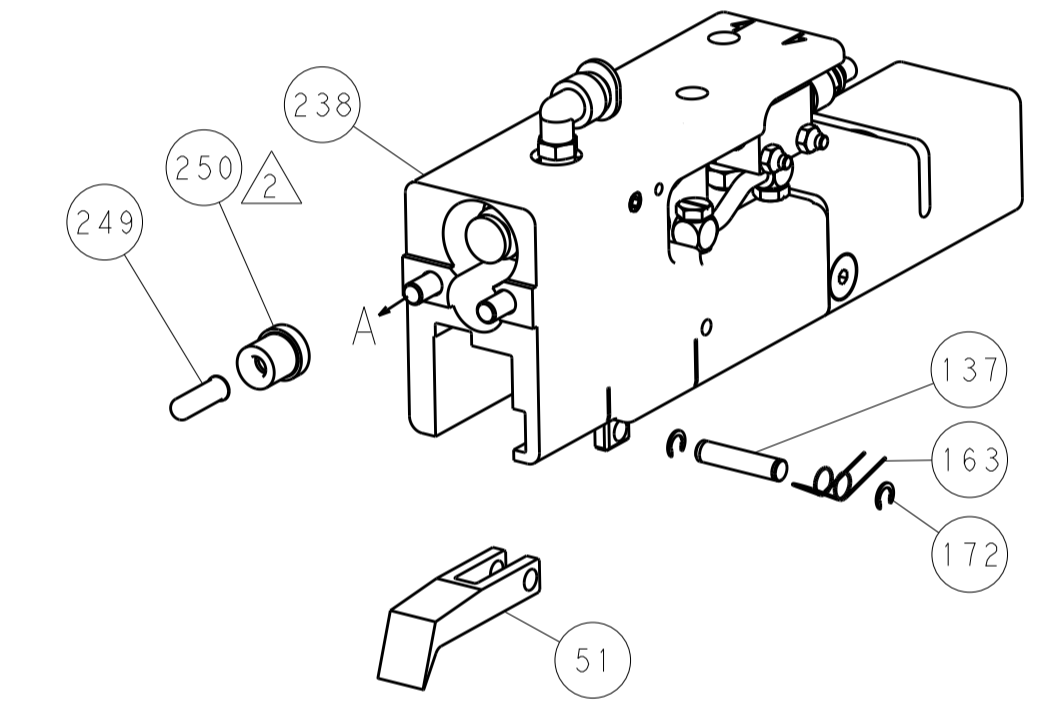
HOLDDOWN SET-UP



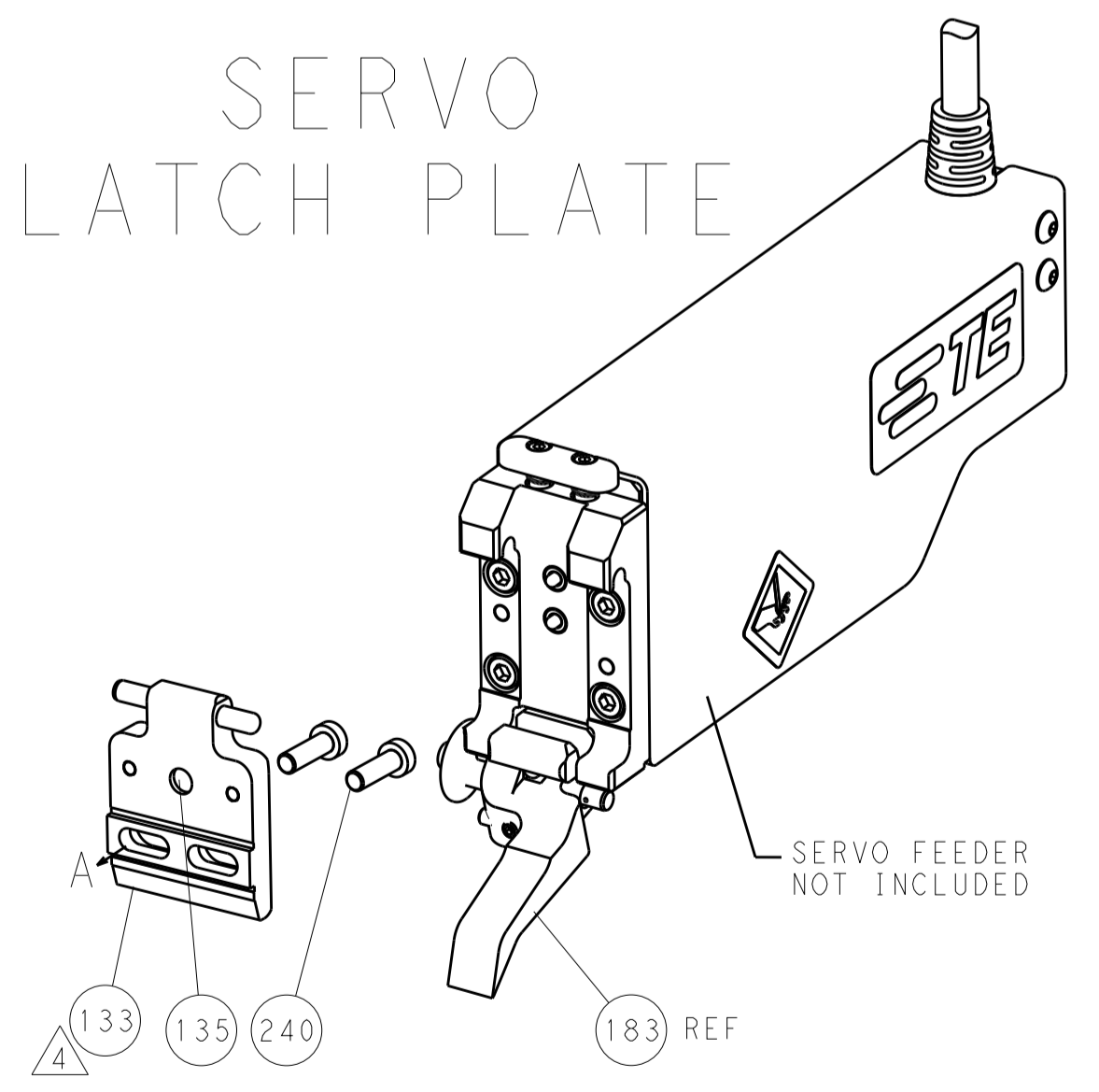
FEED TYPE
MECHANICAL



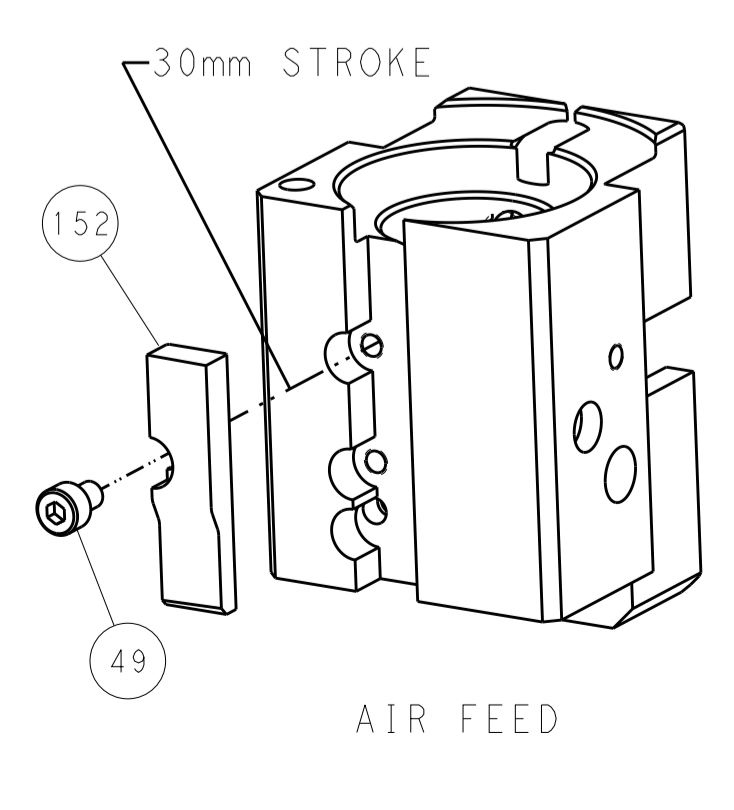
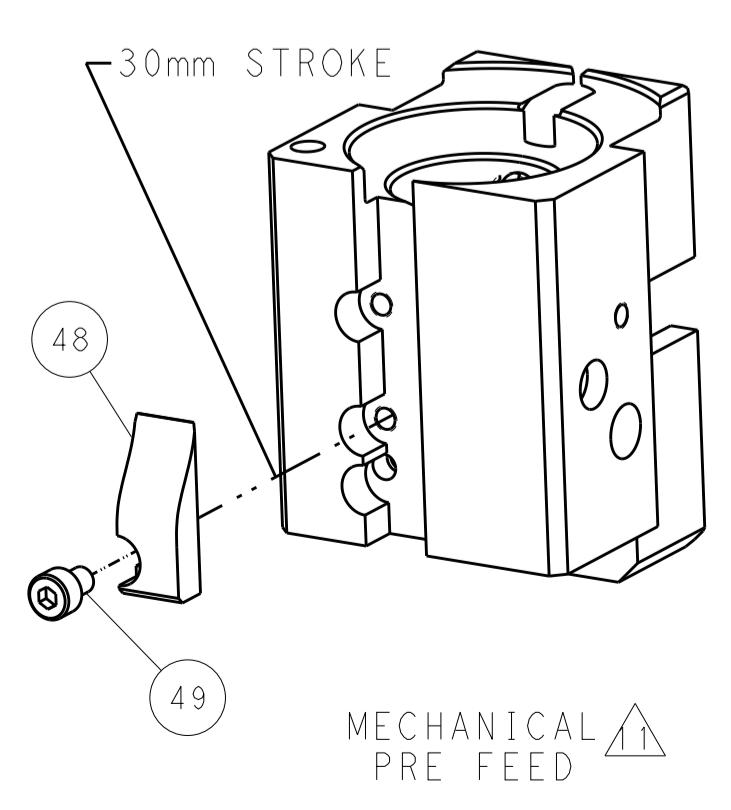
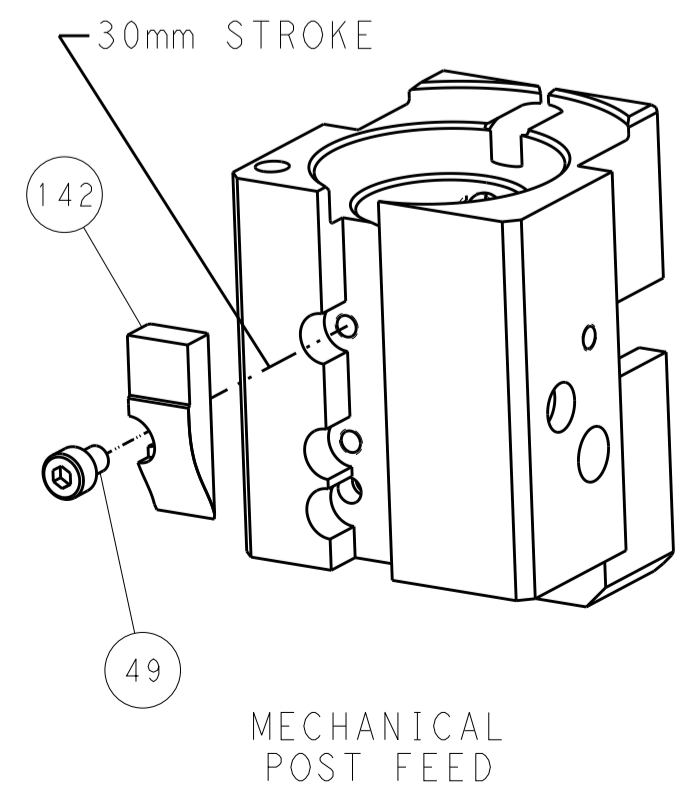
PNEUMATIC



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 14AUG2012		STE TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	4 PLC ±0.013	5 PLC ±0.001	Harrisburg, PA 17105-3608
	ANGLES ±0.001			CHK S.XI 14AUG2012	NAME		
				APVD J. CRUZ 14AUG2012	PRODUCT SPEC		
					APPLICATION SPEC		
MATERIAL	FINISH	WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	C=2150283	
Customer Accessible Production Drawing				SCALE	1:1	SHEET	4 OF 4
				REV	A1		