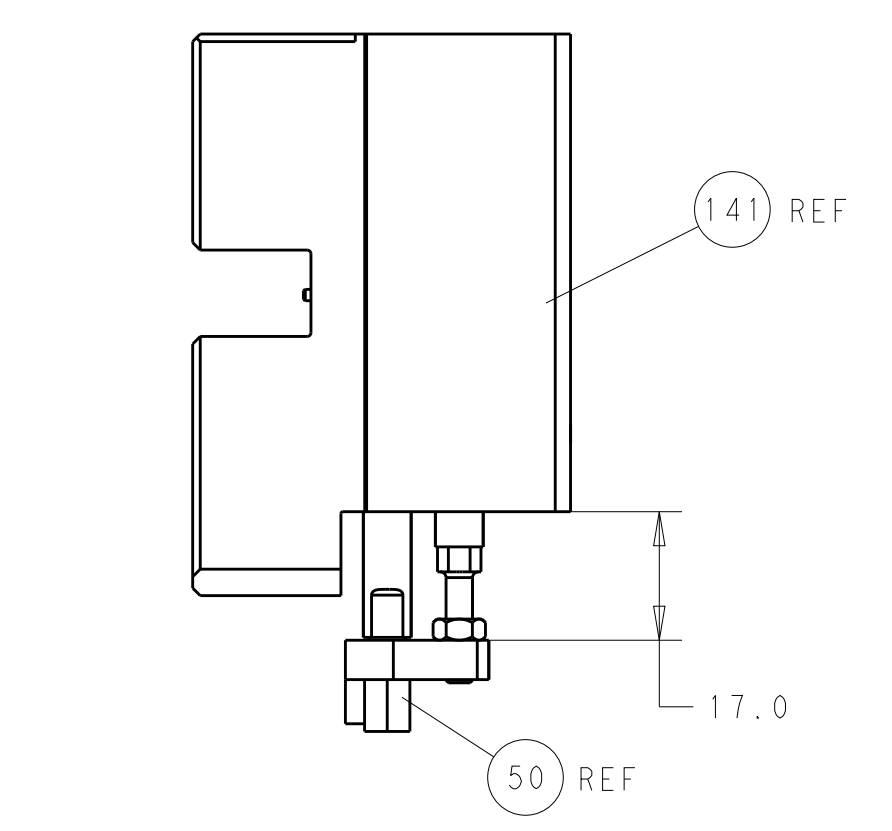
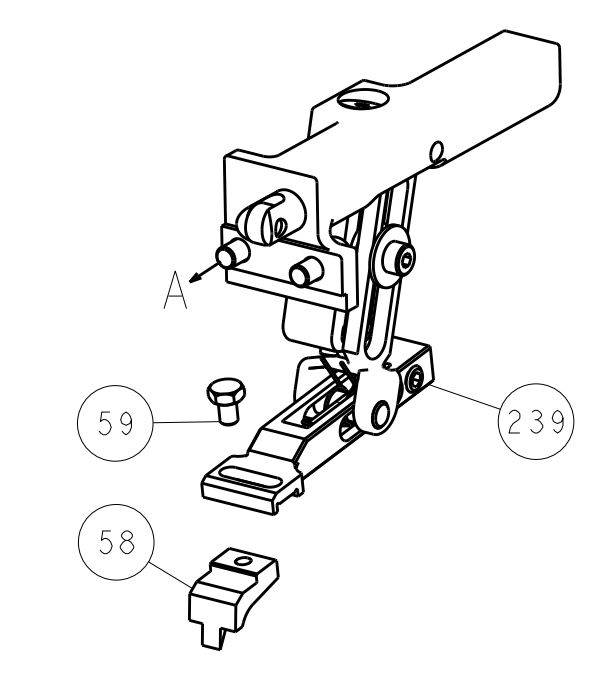


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

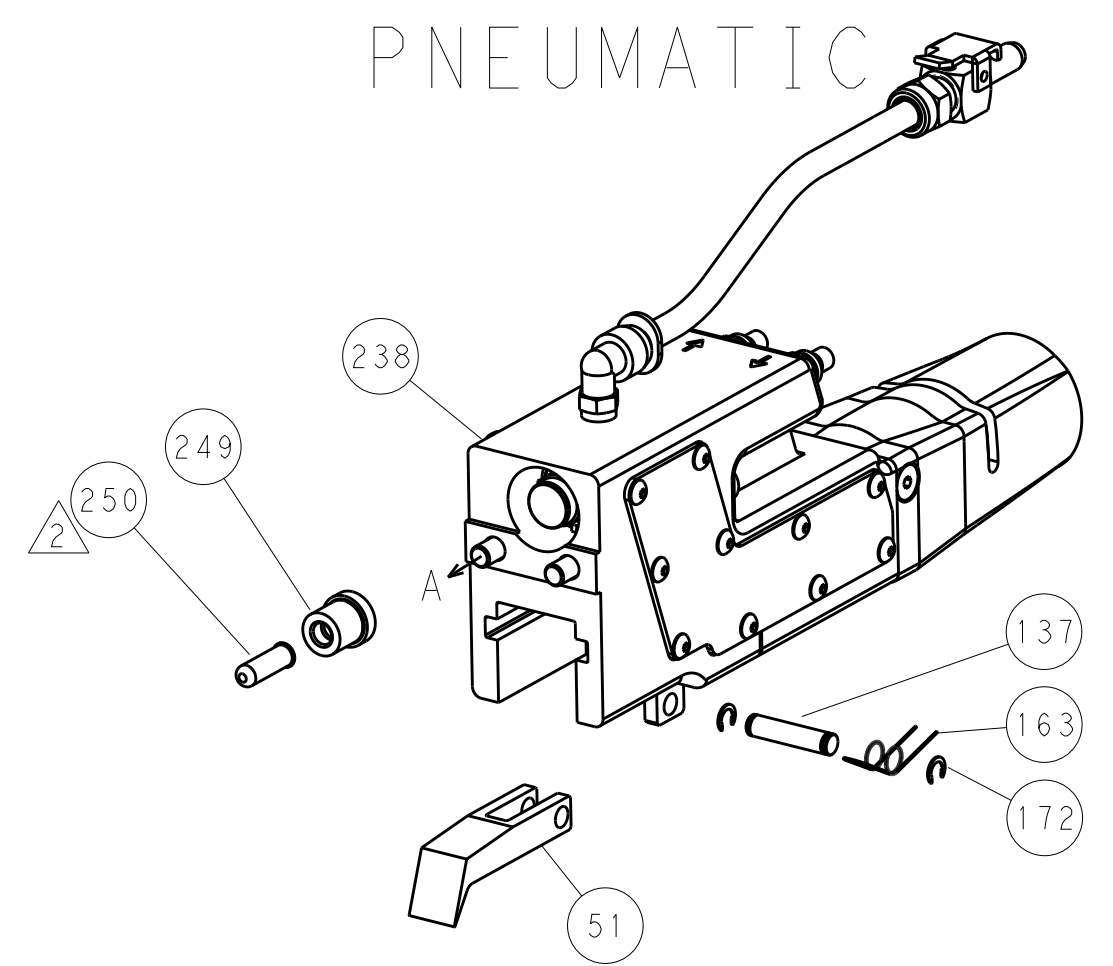


HOLDDOWN SET-UP

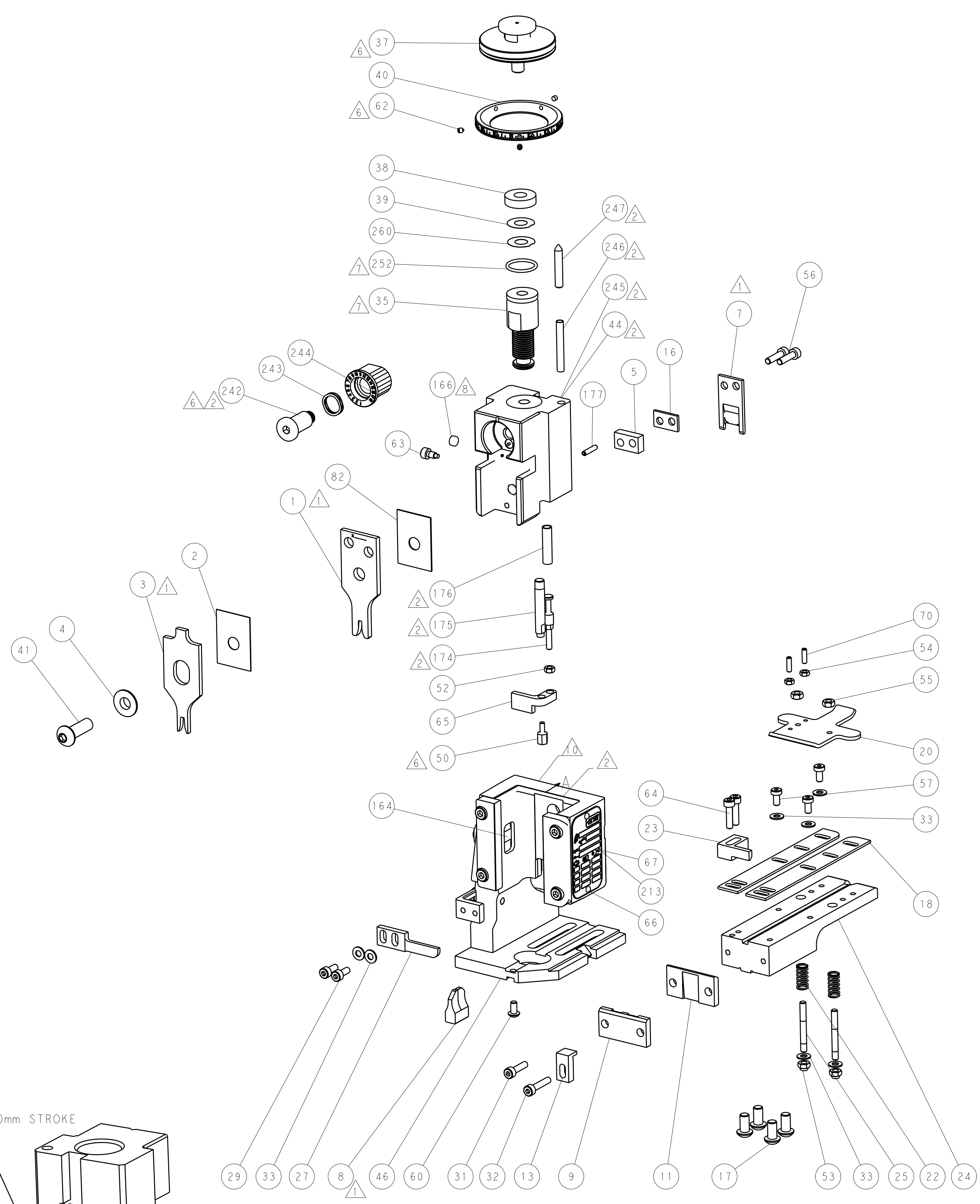
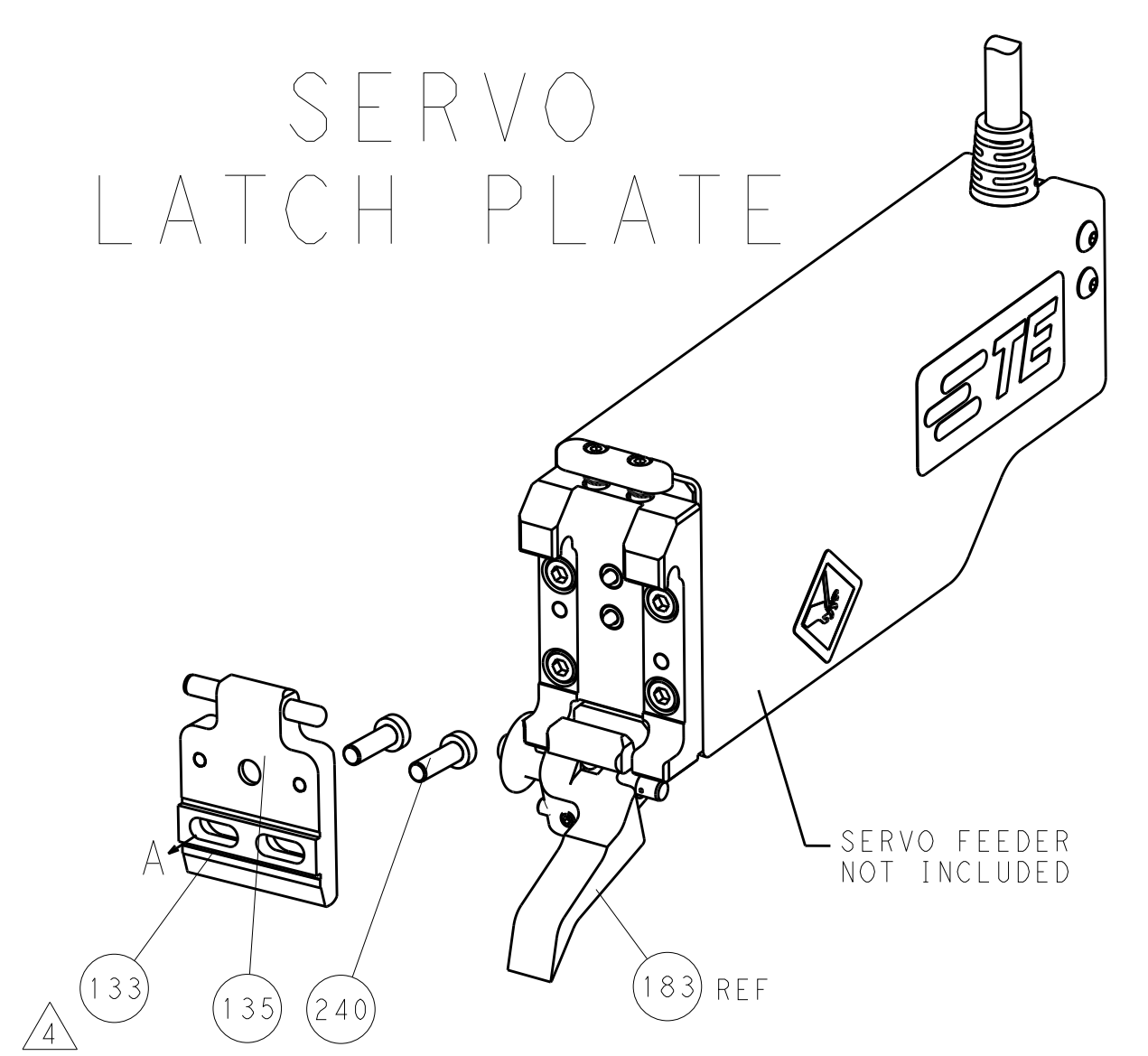
FEED TYPE
MECHANICAL



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:		OWN: BOB HIGMAN 03OCT2013		TE Connectivity	
mm	0 PLC	±		CHK: T. ELBIN 03OCT2013	NAME: Ocean End Feed Applicator		RESTRICTED TO
	1 PLC	±		APVD: M. CLIFFORD 03OCT2013	SIZE: CAGE CODE: DRAWING NO: A11 00779 ©=2150376		
	2 PLC	±		PRODUCT SPEC:	SCALE: 1:1		SHEET 2 OF 4
	3 PLC	±		APPLICATION SPEC:	REV: B		
	4 PLC	±		WEIGHT:	Customer Accessible Production Drawing		
	ANGLES	±					
	FINISH:						

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-
	2-2150376-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150376-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150376-4	-	-	-
	2-2150376-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150376-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150376-4	-	-	-
	2-2150376-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150376-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150376-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.28 mm [.090]	F
INSUL	3.00 mm [.118]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: L.I.F. POSITIVE LOCK CONTACT 5MM SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.50 mm [.138-.177 IN]		1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	114-15008	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
141991-1	141991-3	1-141991-2	142685-3
141991-2	1-141991-1	2-141991-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
0.6+0.35	1.42+/-0.05 [.056+/- .002]	8.5
1.00mm2	1.42+/-0.05 [.056+/- .002]	8.5
0.35+0.35	1.35+/-0.05 [.053+/- .002]	9.4
0.60mm2	1.29+/-0.05 [.051+/- .002]	10.1
0.35mm2	1.19+/-0.05 [.047+/- .002]	11.4

- 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: 8-2150376-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150376-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150376-5
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

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

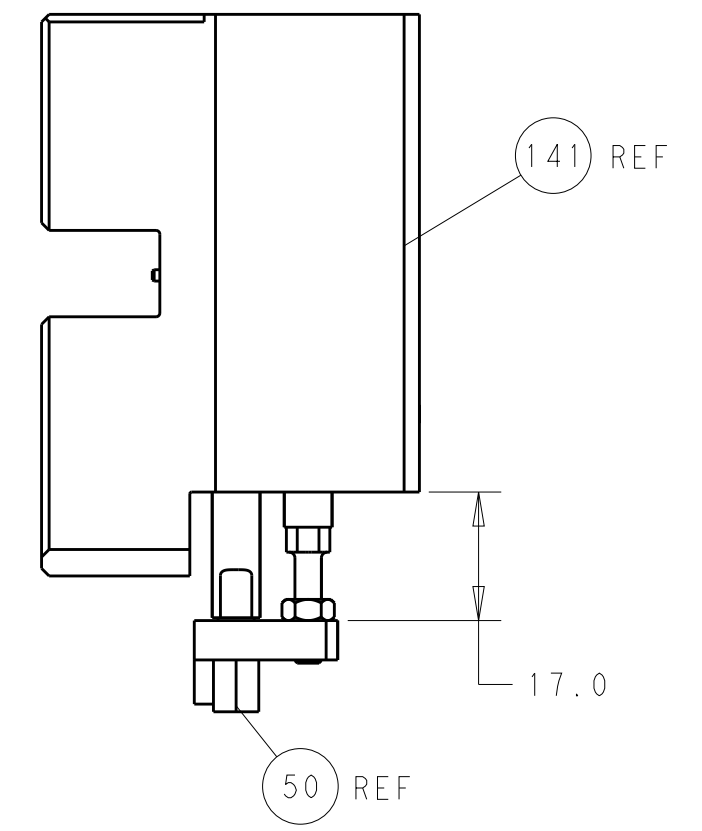
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	-	-	-	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	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	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	64	
-	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	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1	1	1	1-1752354-2	STANDOFF, HOLD-DOWN	50	
-	-	-	-	1	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	1-2119644-2	RAM WASHER, PRECISION	38	
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	1	1	1	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	32	
-	1	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752371-6	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1752373-4	DRAG	20	
-	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	18	
-	1	1	1	1	4-240641-2	SPACER	16	
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	1	1	240833-2	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690496-6	PLATE, FRONT SHEAR	9	
-	1	1	1	1	3-1803001-1	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	2217206-2	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	6-240641-5	SPACER	5	
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4	
-	1	1	1	1	2-1803016-5	CRIMPER, INSULATION F	3	
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
-	1	1	1	1	1-456406-5	CRIMPER, WIRE PREMIUM	1	
-	77	27	25	22	21	PART NO	DESCRIPTION	ITEM NO

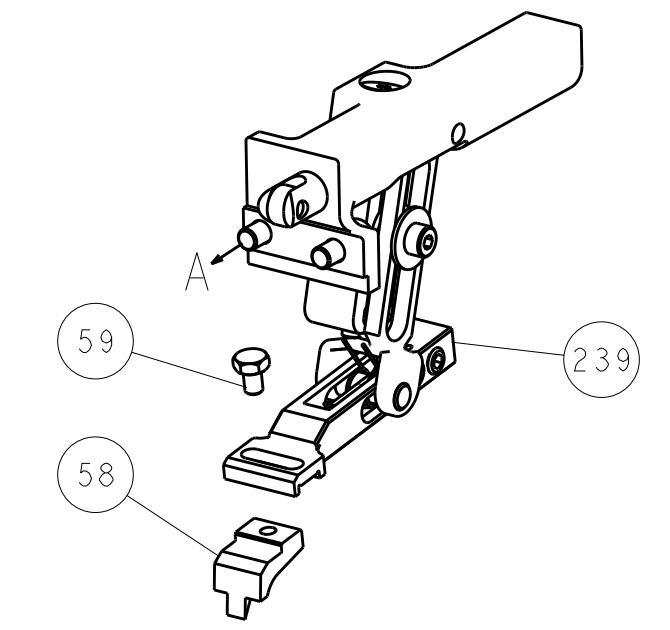
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	1 PLC	±	03OCT2013	T. ELBIN	03OCT2013	Harrisburg, PA 17105-3608	
	2 PLC	±		M. CLIFFORD	03OCT2013	NAME	
	3 PLC	±				Ocean End Feed	
	4 PLC	±				Applicator	
	ANGLES	±				SIZE	CAGE CODE
	FINISH	±				DRAWING NO	RESTRICTED TO
MATERIAL						A1	00779
						Customer Accessible Production Drawing	SCALE
						1:1	SHEET 3 OF 4
						REV	B

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

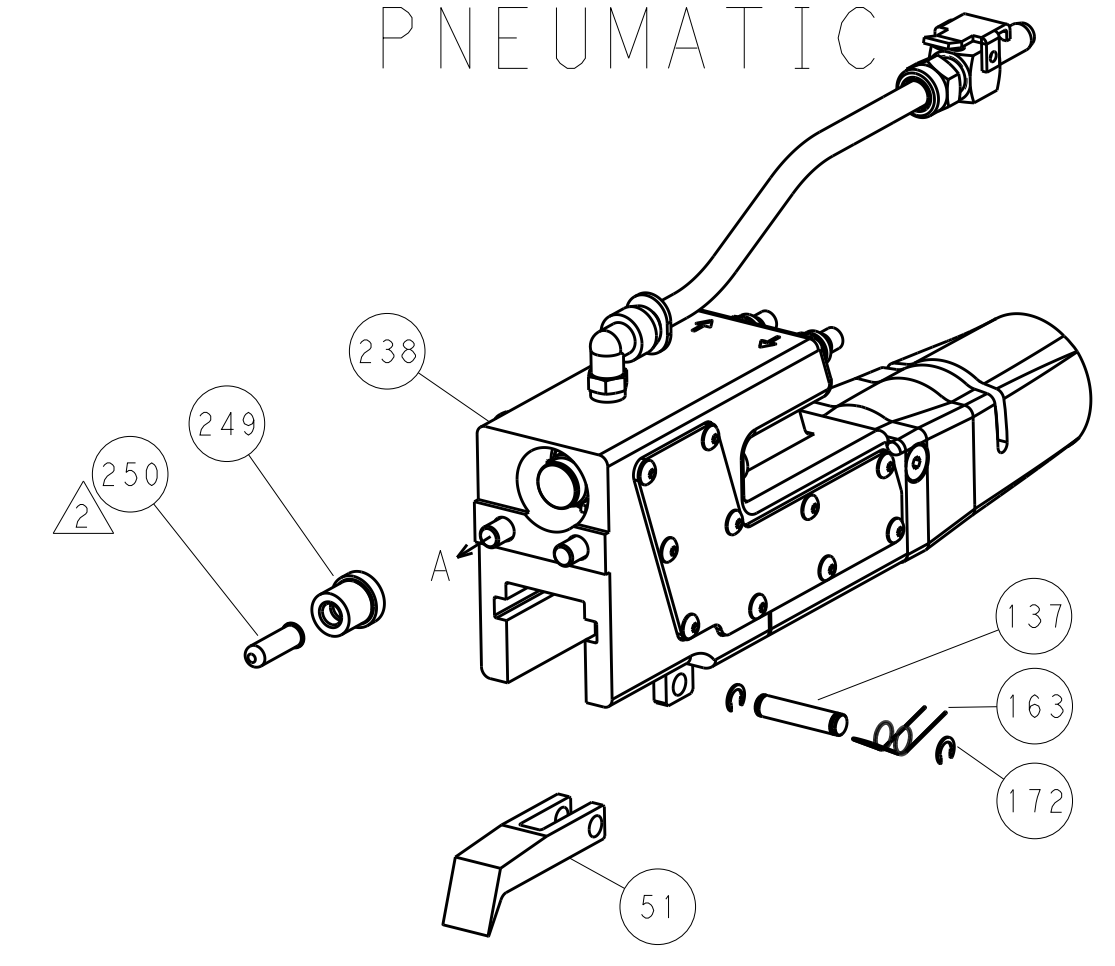


HOLDDOWN SET-UP

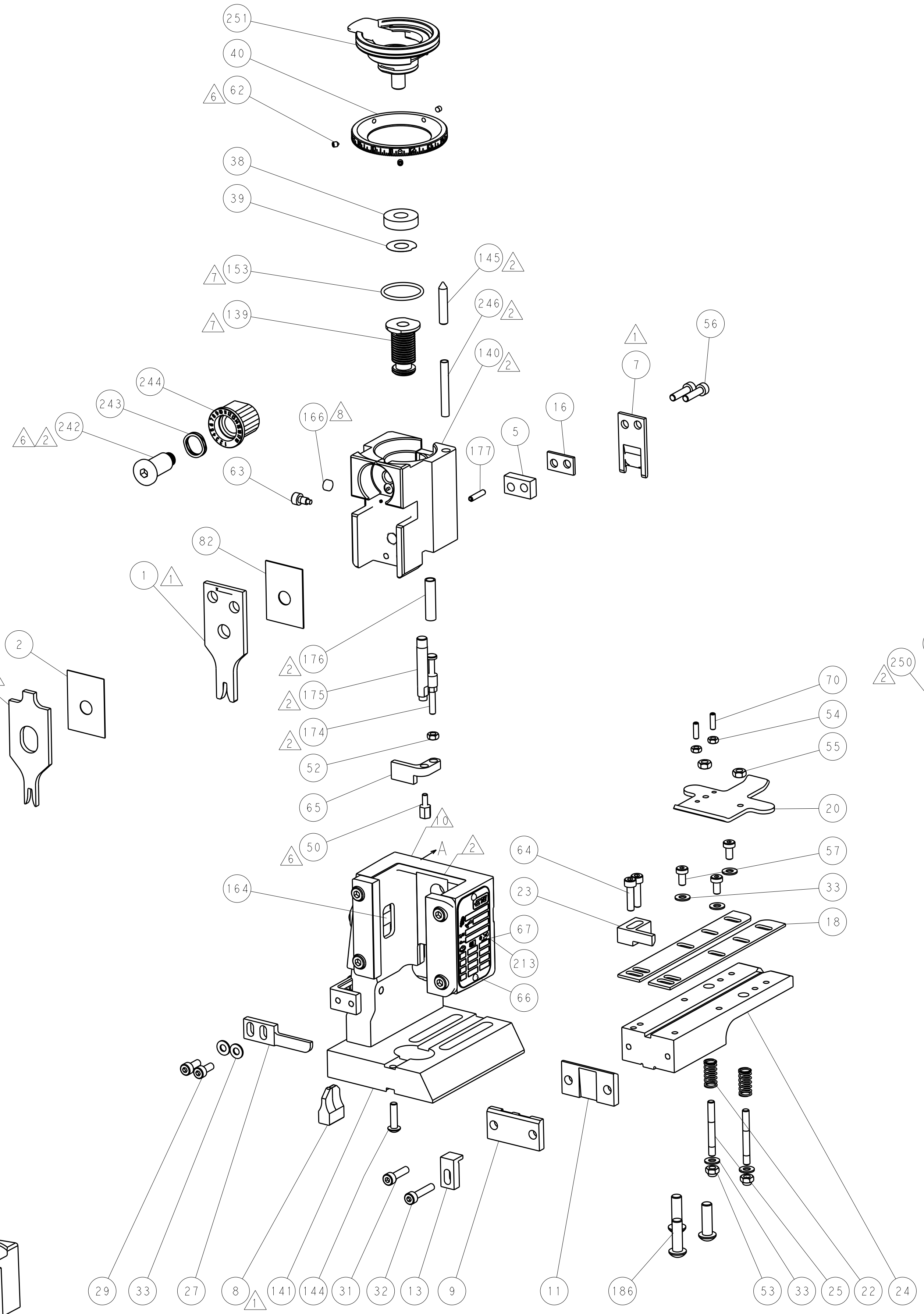
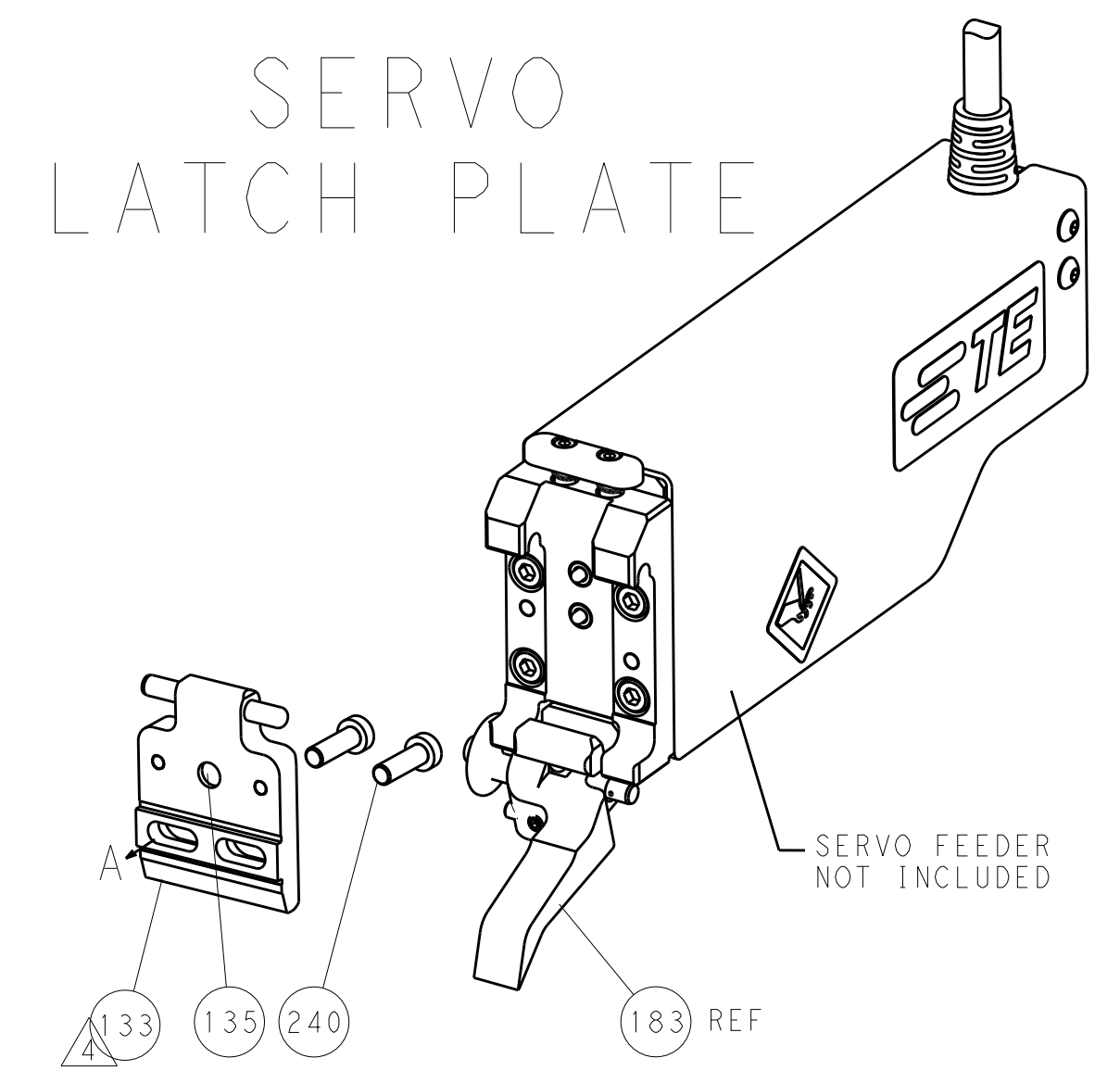
FEED TYPE
MECHANICAL



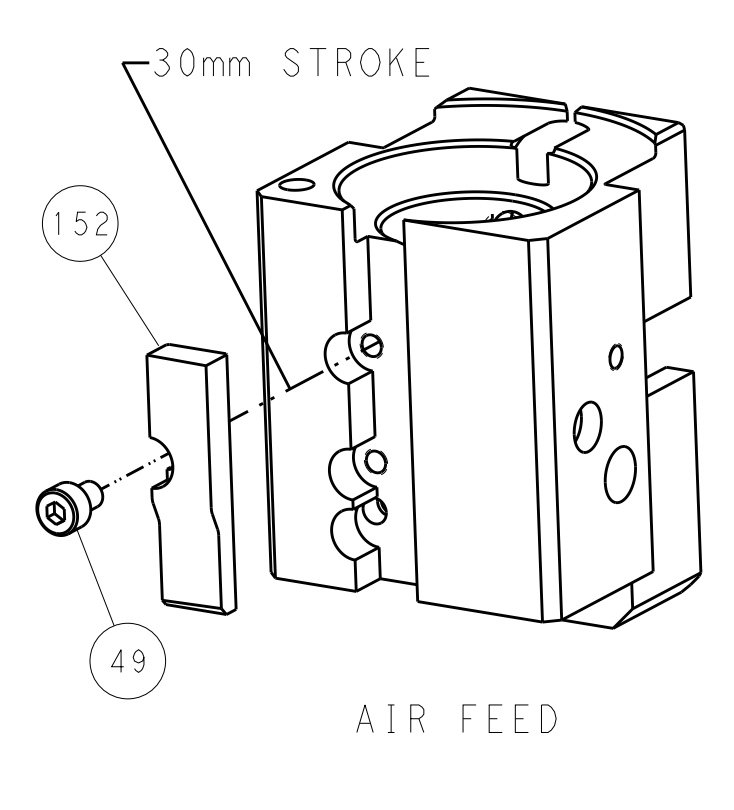
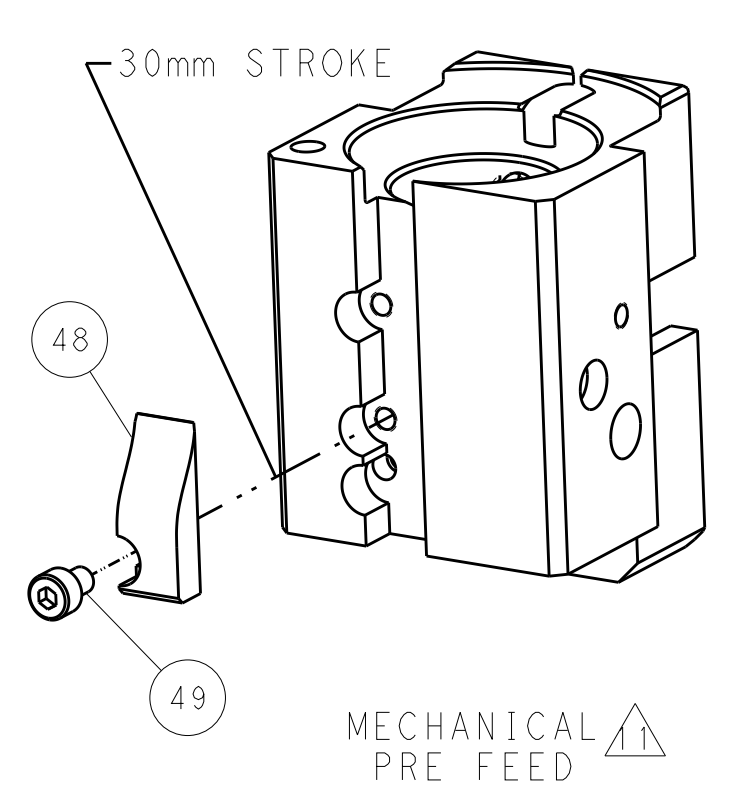
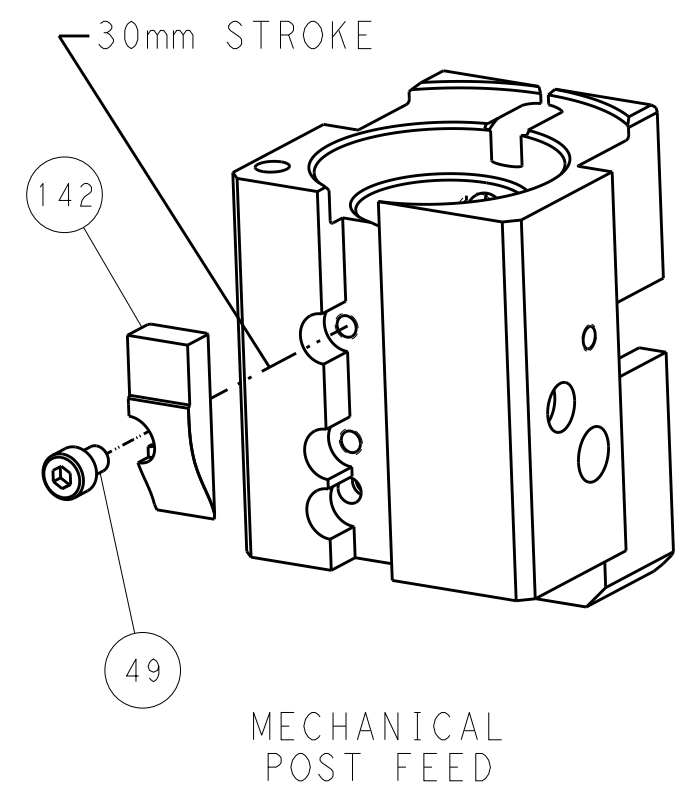
PNEUMATIC



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:		DWG: BOB_HIGMAN 03OCT2013		TE Connectivity	
mm	0 PLC	±		CHK: T_ELFIN 03OCT2013	NAME		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: M_CLEFFORD 03OCT2013	Ocean End Feed		
	2 PLC	±		PRODUCT SPEC	Applicator		
	3 PLC	±		APPLICATION SPEC	SIZE		RESTRICTED TO
	4 PLC	±		ANGLES	CAGE CODE		
	FINISH	±		WEIGHT	DRAWING NO		
MATERIAL					A1 00779		
					C=2150376		
					Customer Accessible Production Drawing		
					SCALE	SHEET	REV
					1:1	4 OF 4	B