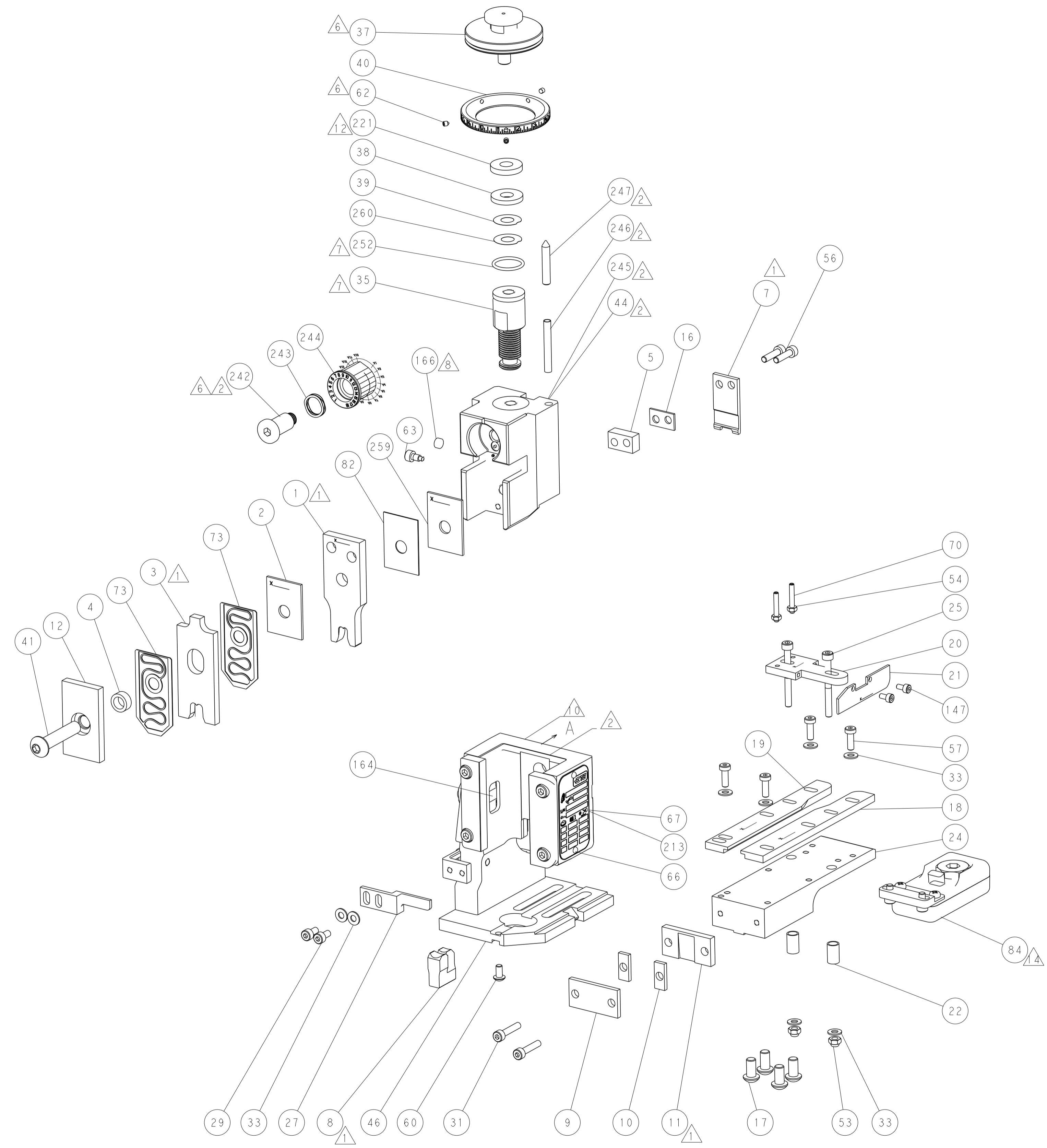
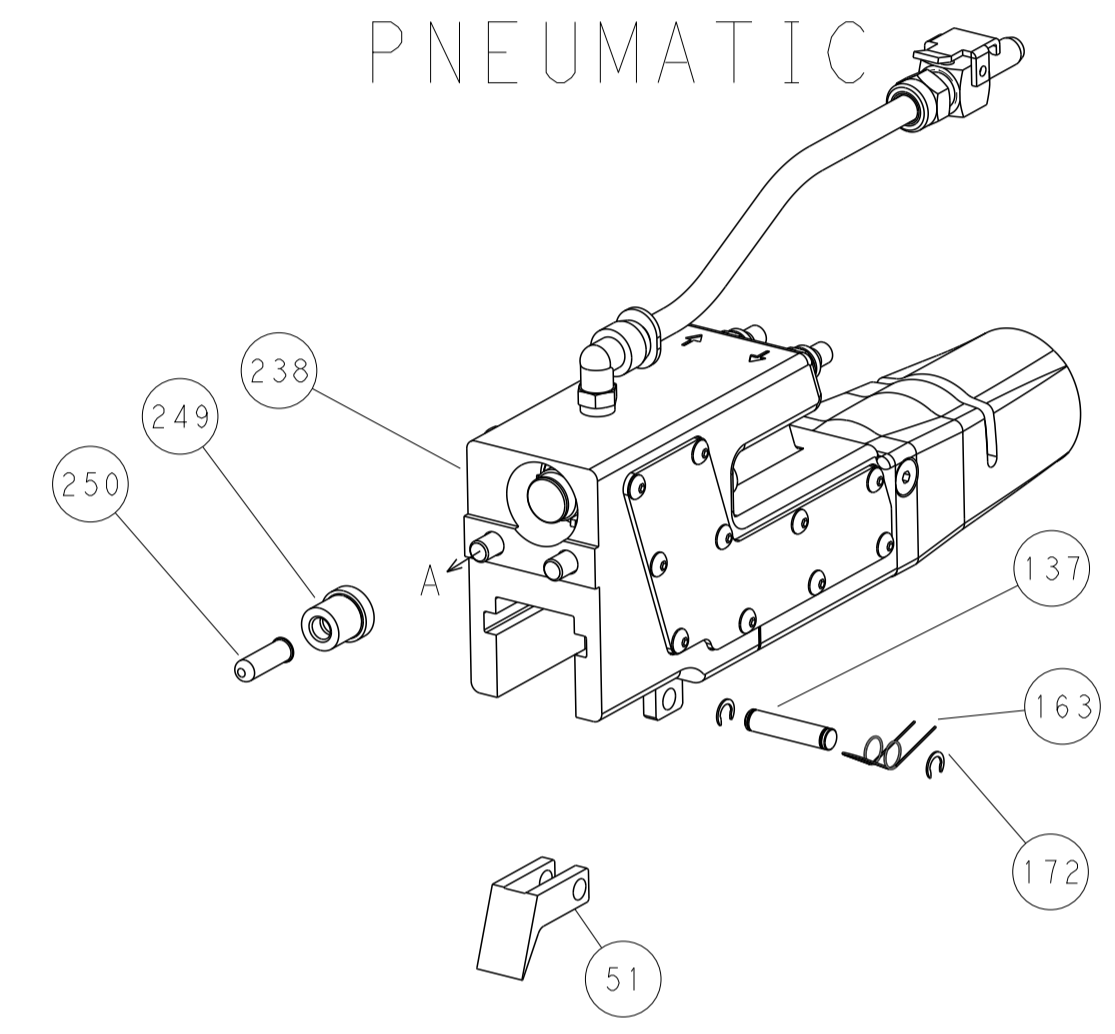


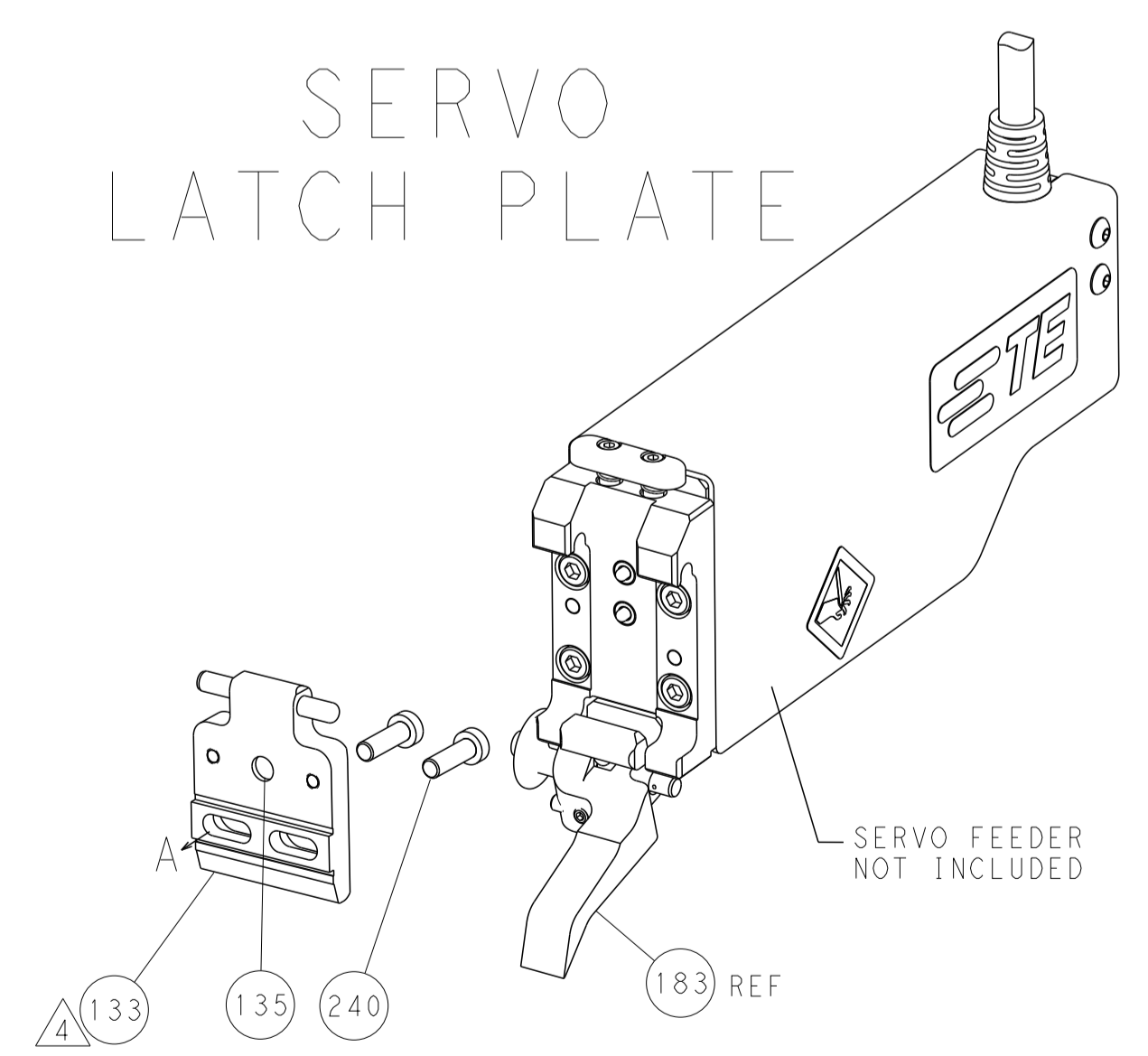
LOC	DIST	REV	DATE	BY	APPV
A	66				
		REVISIONS			
P	LTM	DESCRIPTION	DATE	OWN	APPV
-	-	SEE SHEET 1	-	-	-



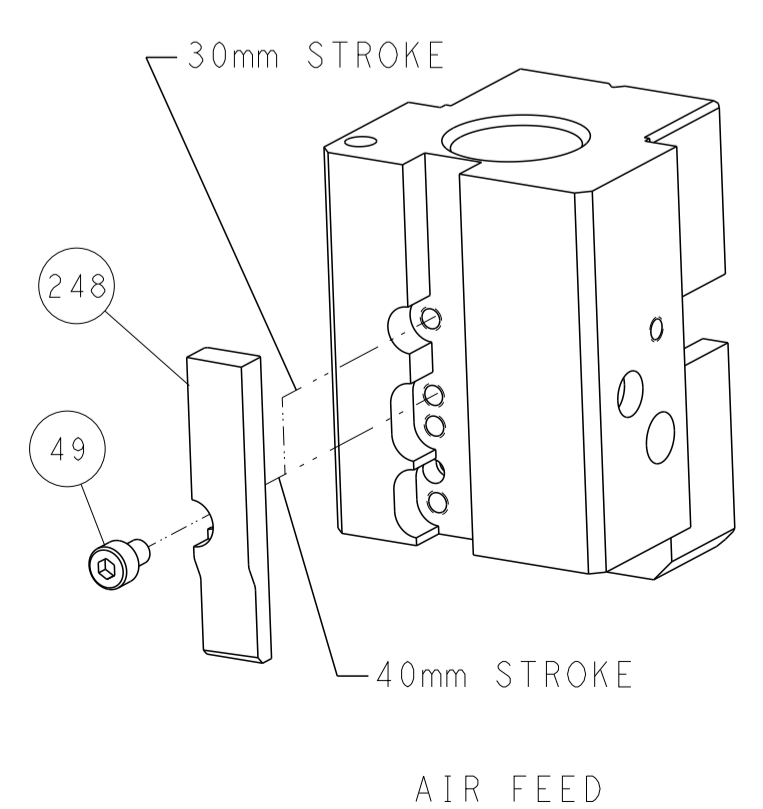
FEED TYPE
PNEUMATIC



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: K. STAKEM 20AUG2014		TE Connectivity	
mm	0 PLC	±		CHK: G. BAILEY 20AUG2014	NAME: Ocean End Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APPV: T. ELBIN 20AUG2014	SIZE: A1		CAGE CODE: 00779
	2 PLC	±		PRODUCT SPEC:	DRAWING NO: 2150472		REV: E
	3 PLC	±		APPLICATION SPEC:	SCALE: 1:1		SHEET 2 OF 4
	4 PLC	±		WEIGHT:	RESTRICTED TO:		
	ANGLES	±		Customer Accessible Production Drawing			
	FINISH	±					

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150472-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150472-5	-	-	2168400-7 (QUANTITY 2)
	2-2150472-5	E	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-3	-	2119641-2	-	2063440-2
2-2150472-7	E	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150472-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.35 mm [.250]	F
INSUL	9.53 mm [.375]	Q
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.18-5.94 mm [.204-.234 IN]		Ø5.59-8.00 mm [.220-.315 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED ¹⁰ ³			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42899-1	42913-1	61352-1	
42899-2	42913-2	61352-2	
42899-3	42913-3		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.18-5.94 mm [.204-.234 IN]		Ø5.59-8.00 mm [.220-.315 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED ¹⁰ ³			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41808	41808-1	41809	41809-1

WIRE SIZE		CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
6 AWG		4.85 +/- 0.05 [.191 +/- .002]	4.7
8 AWG		4.22 +/- 0.05 [.166 +/- .002]	11.7
10 AWG ¹²		3.81 +/- 0.05 [.150 +/- .002]	9.8

WIRE SIZE		CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
8 AWG		4.57 +/- 0.05 [.180 +/- .002]	5.7
10 AWG		4.24 +/- 0.05 [.167 +/- .002]	9.3

***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.



- 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: 8-2150472-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150472-5
- 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 ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.
- ¹² REPLACE ITEM 38 WITH ITEM 221 WHEN RUNNING THE 3.81mm CRIMP HEIGHT.
- ¹³ TERMINAL LUBRICANT IS RECOMMENDED.

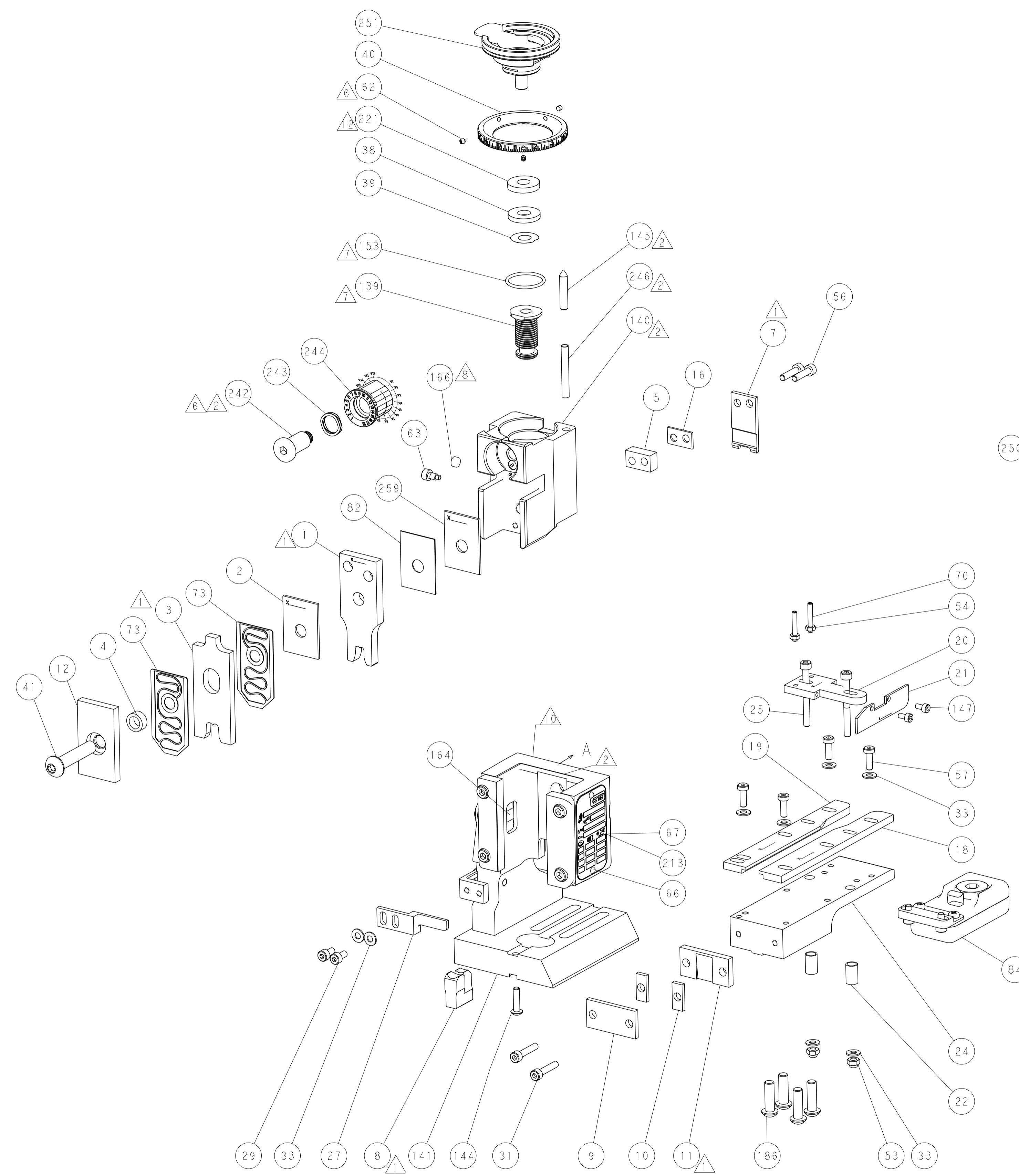
SET UP GAUGE	LOC	DIST	REVISIONS				
2119599-2	A	66	P	LTN	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-

-	1	1	1	1803078-5	SPACER, PRECISION	259
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	1803259-1	BUSHING, FLANGED	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
⁶	-	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
¹²	-	1	1	2119644-6	RAM WASHER, PRECISION	221
-	-	-	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
-	-	-	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
⁷	-	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
-	-	-	1	2119641-2	FEED CAM, AIR FEED	152
-	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
-	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	2161313-1	RAM, STEPPED, ASIAN STYLE, END FEED	140
⁷	-	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
¹³	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	2	1-2119791-4	DEPRESSOR, WIRE	73
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
⁶	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	1	2119792-3	PAWL, EF, AIR	51
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	2119644-8	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	2280534-1	STRIPPER, OFFSET	27
-	2	2	2	1-2168083-7	SCR, SKT HD CAP, RoHS, M4 X 40	25
-	1	1	1	2-1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-1	SPRING, COMPRESSION	22
-	1	1	1	1-464452-7	DRAG, STOCK	21
-	1	1	1	1633168-2	ARM, STOCK DRAG	20
-	1	1	1	3-1901696-5	STRIP GUIDE, REAR	19
-	1	1	1	3-1901695-5	STRIP GUIDE, FRONT	18
-	1	1	1	5-240641-4	SPACER	16
-	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	12
¹	-	1	1	240644-1	PLATE, REAR SHEAR	11
¹	-	2	2	8-240645-9	SPACER, SHEAR PLATE	10
¹	-	1	1	240642-1	PLATE, FRONT SHEAR	9
¹	1	1	1	1803003-1	ANVIL, COMBINATION, END FEED	8
¹	-	1	1	1803366-6	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	6-240641-8	SPACER	5
-	1	1	1	1-238011-4	BLOCK, CRIMPER SPACER	4
¹	1	1	1	7-1633962-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1-455888-4	SPACER, CRIMPER	2
¹	1	1	1	456432-3	CRIMPER, WIRE	1

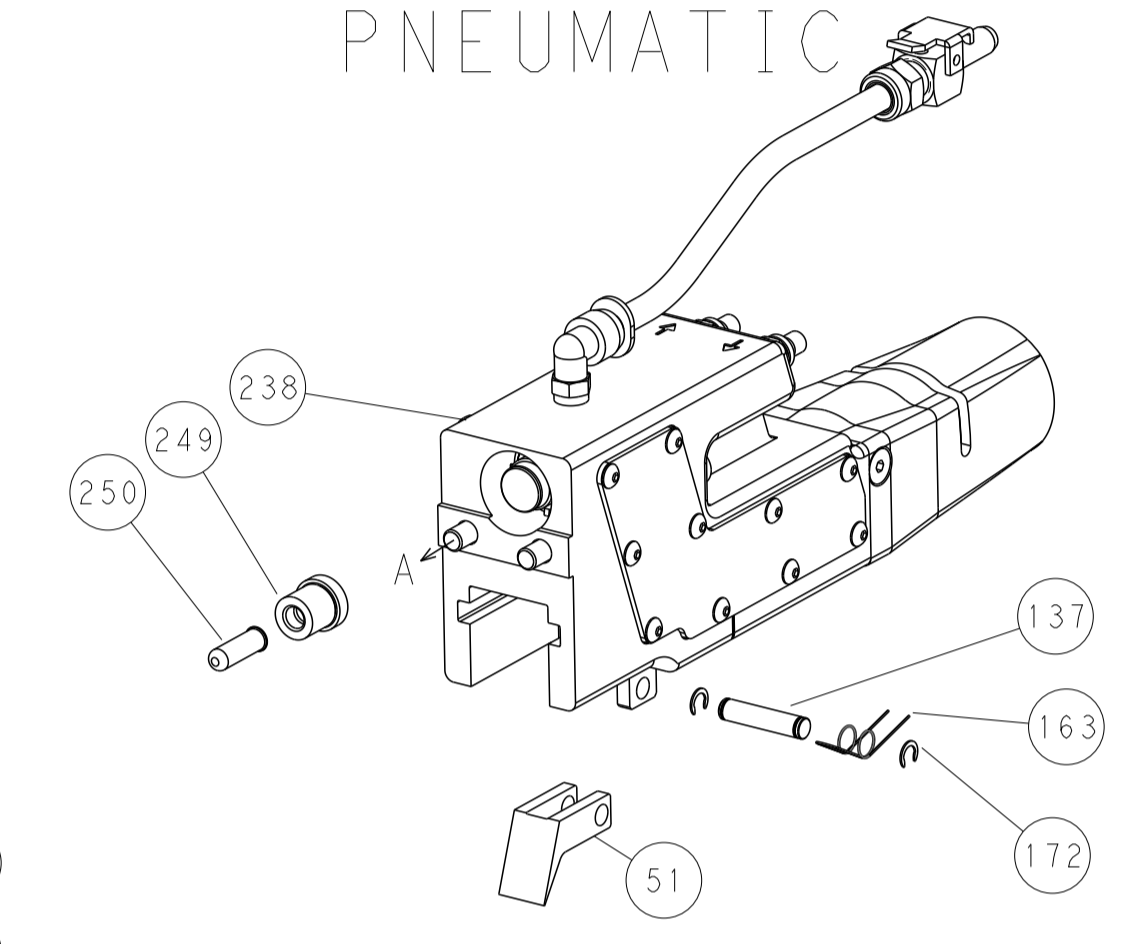
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DRAWN: L. STAKEM 20AUG2014 CHK: G. BAILEY 20AUG2014 APVD: T. ELBIN 20AUG2014		NAME: Ocean End Feed Applicator	
MATERIAL: .		FINISH: .		WEIGHT: .		SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150472	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 3 OF 4 REV: E	

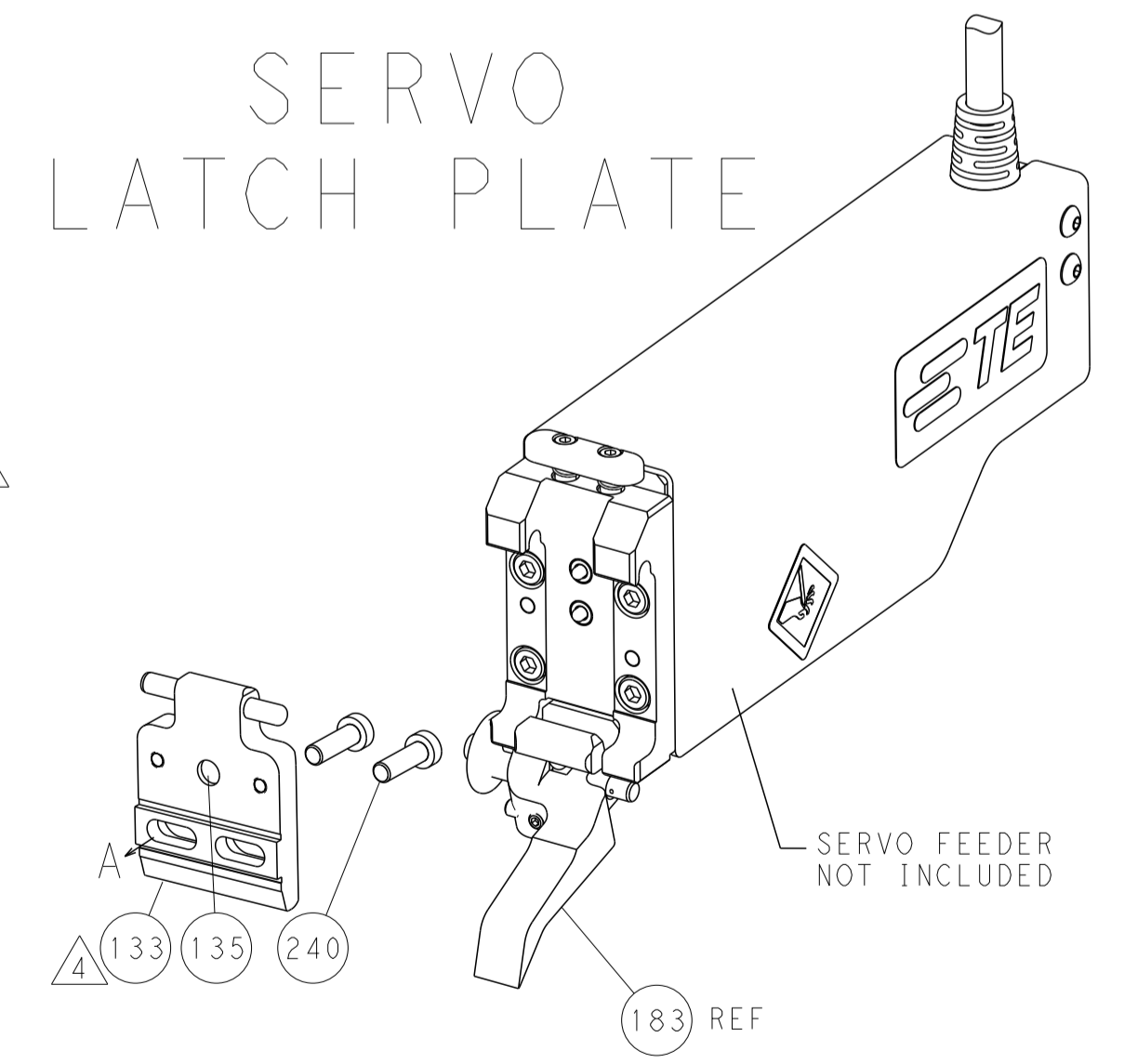
LOC	DIST	REVISIONS					
A	66	P	LTH	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			



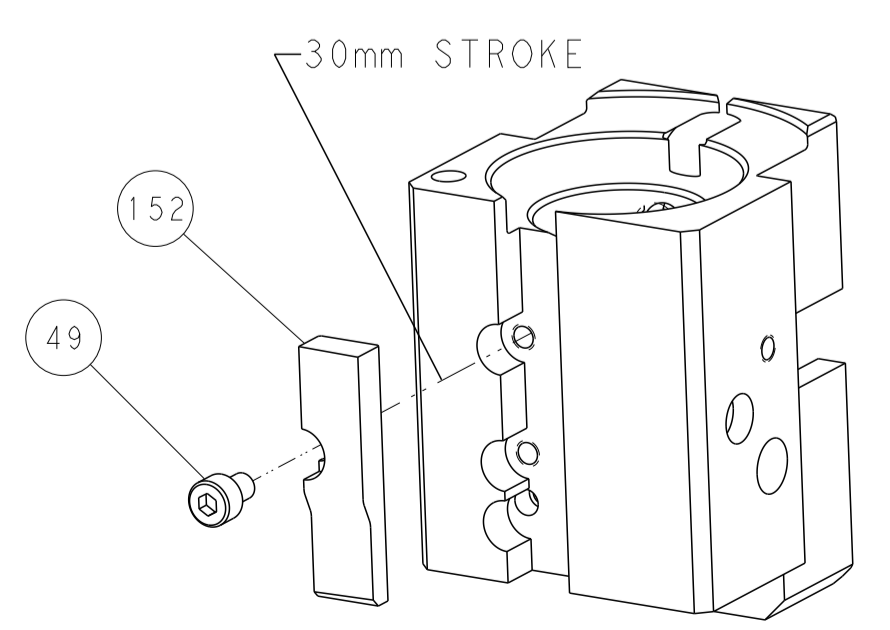
FEED TYPE
PNEUMATIC



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: STAKEM 20AUG2014		STE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	TE Connectivity Harrisburg, PA 17105-3608
	ANGLES ±	FINISH ±		CHK: G. BAILEY 20AUG2014	NAME: Ocean End Feed Applicator		
MATERIAL:				APVD: T. ELBIN 20AUG2014	PRODUCT SPEC:		
				APPLICATION SPEC:	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C-2150472
				WEIGHT:	SCALE: 1:1	SHEET: 4	OF: 4
				Customer Accessible Production Drawing	REV: E		