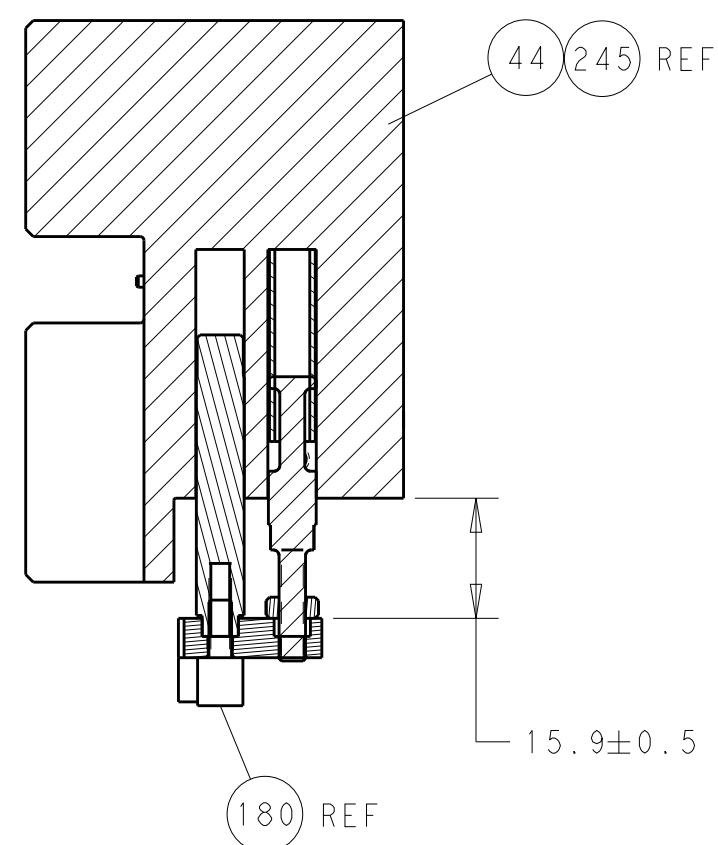
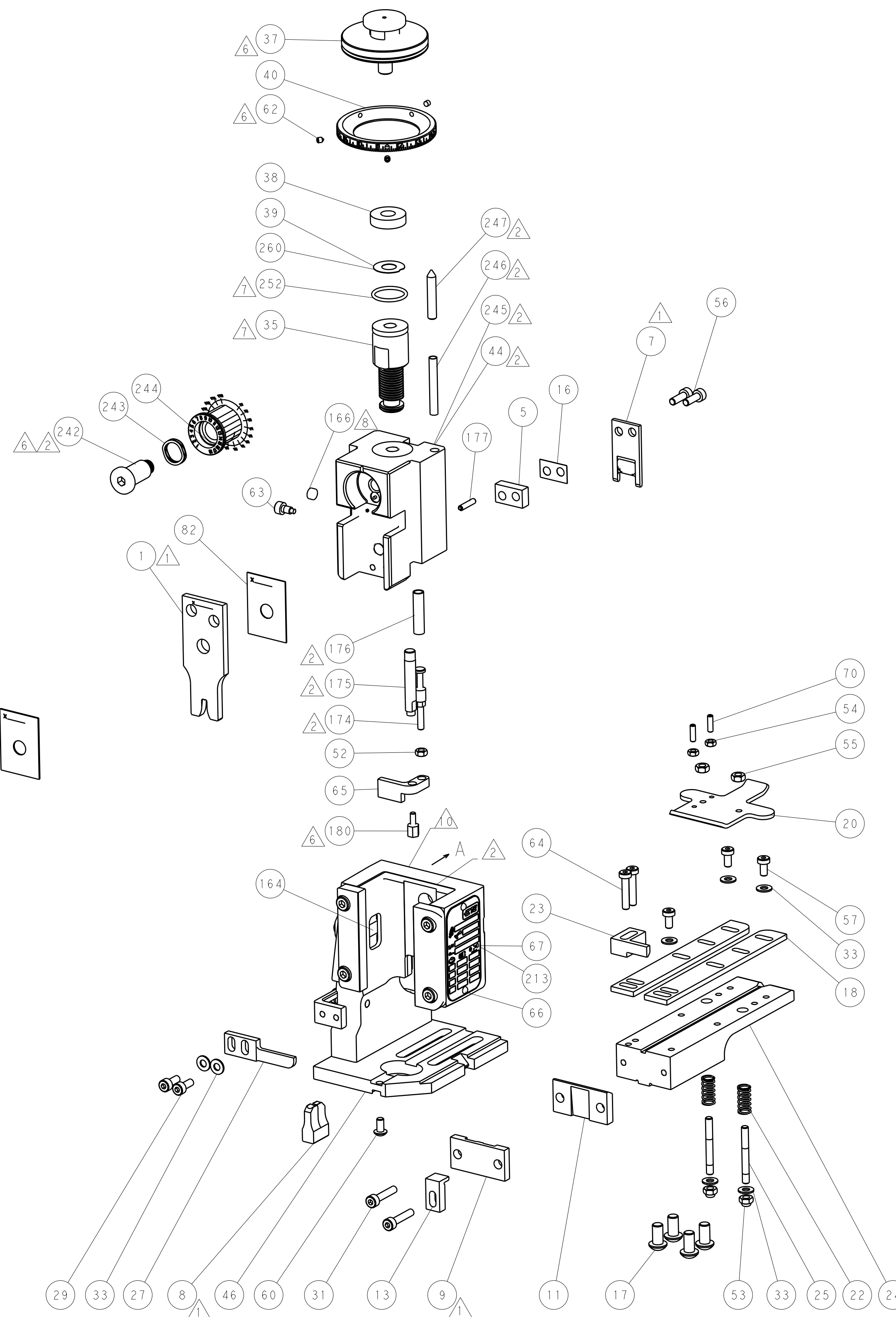
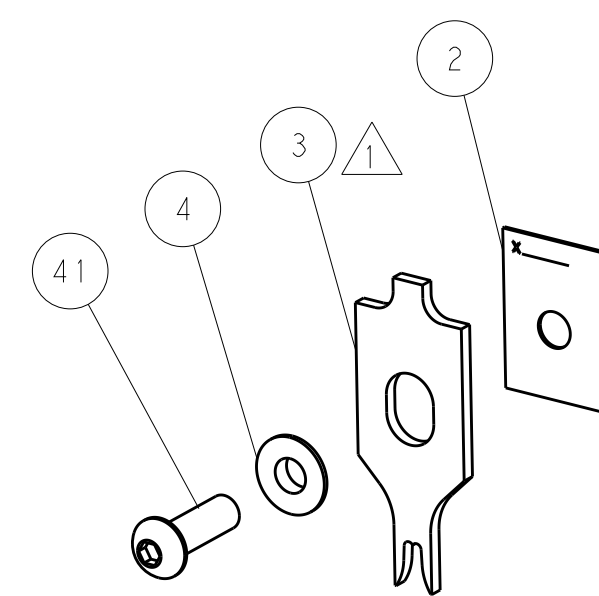
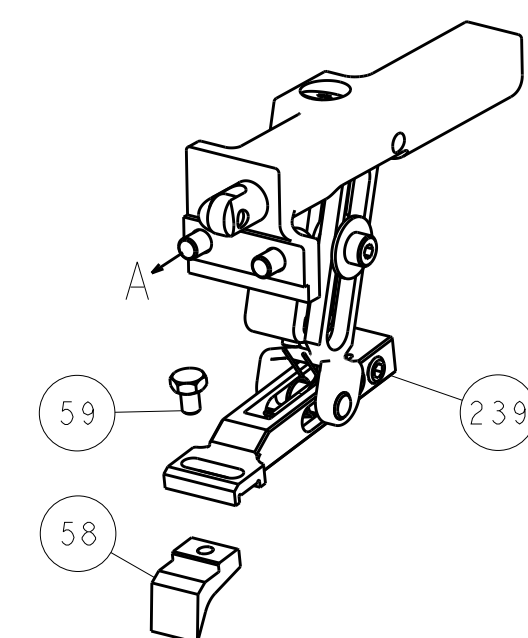




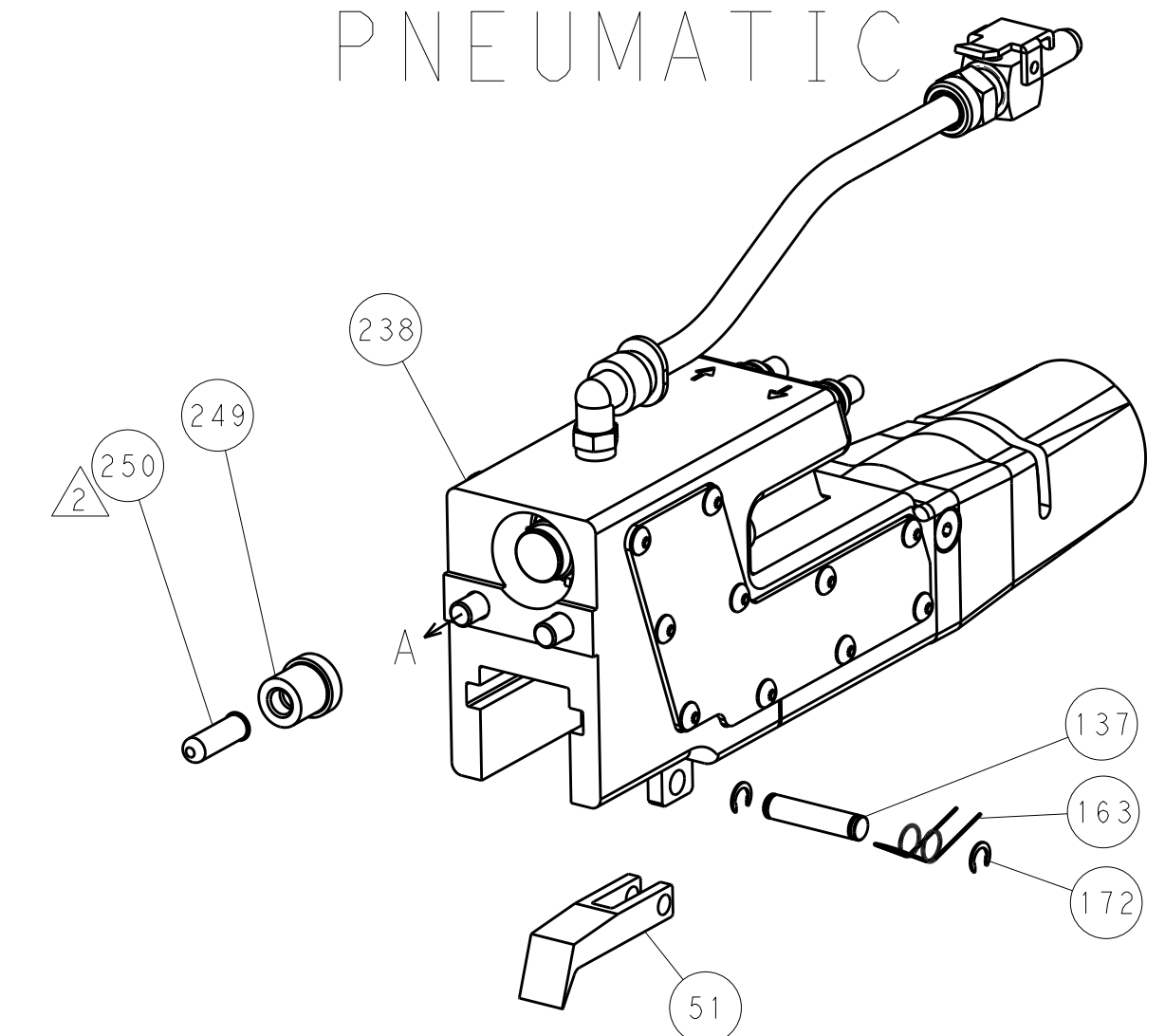
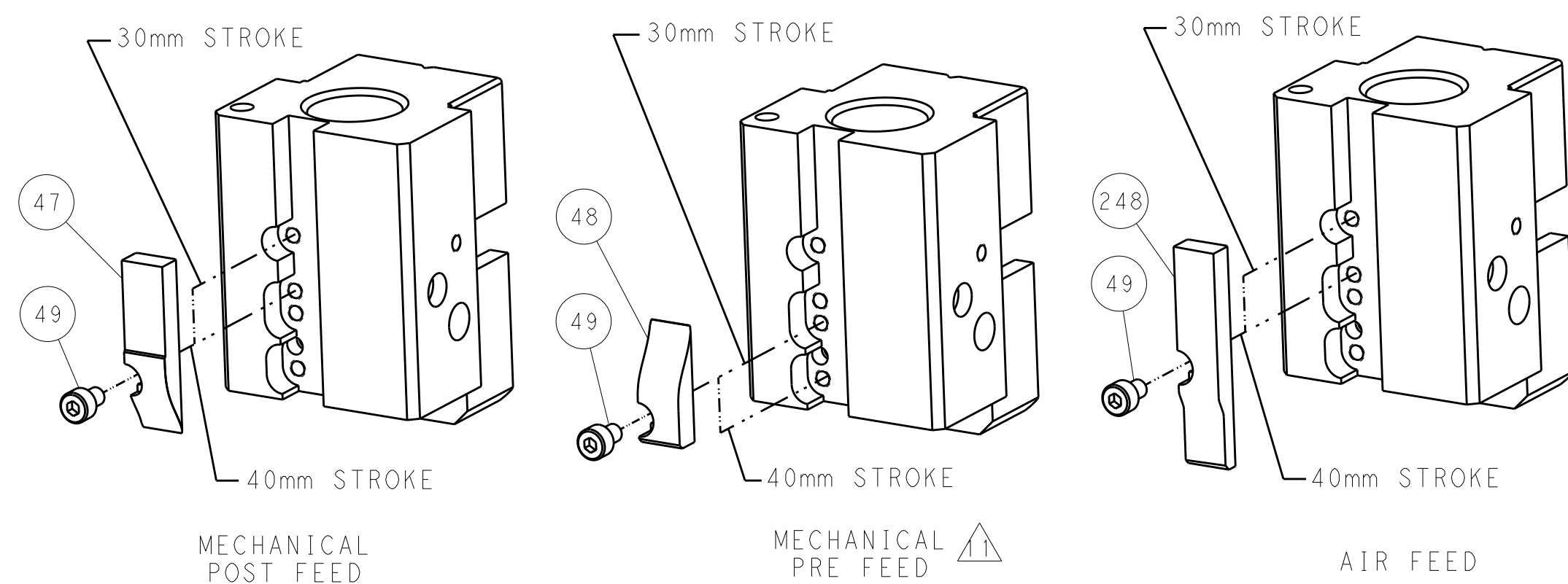
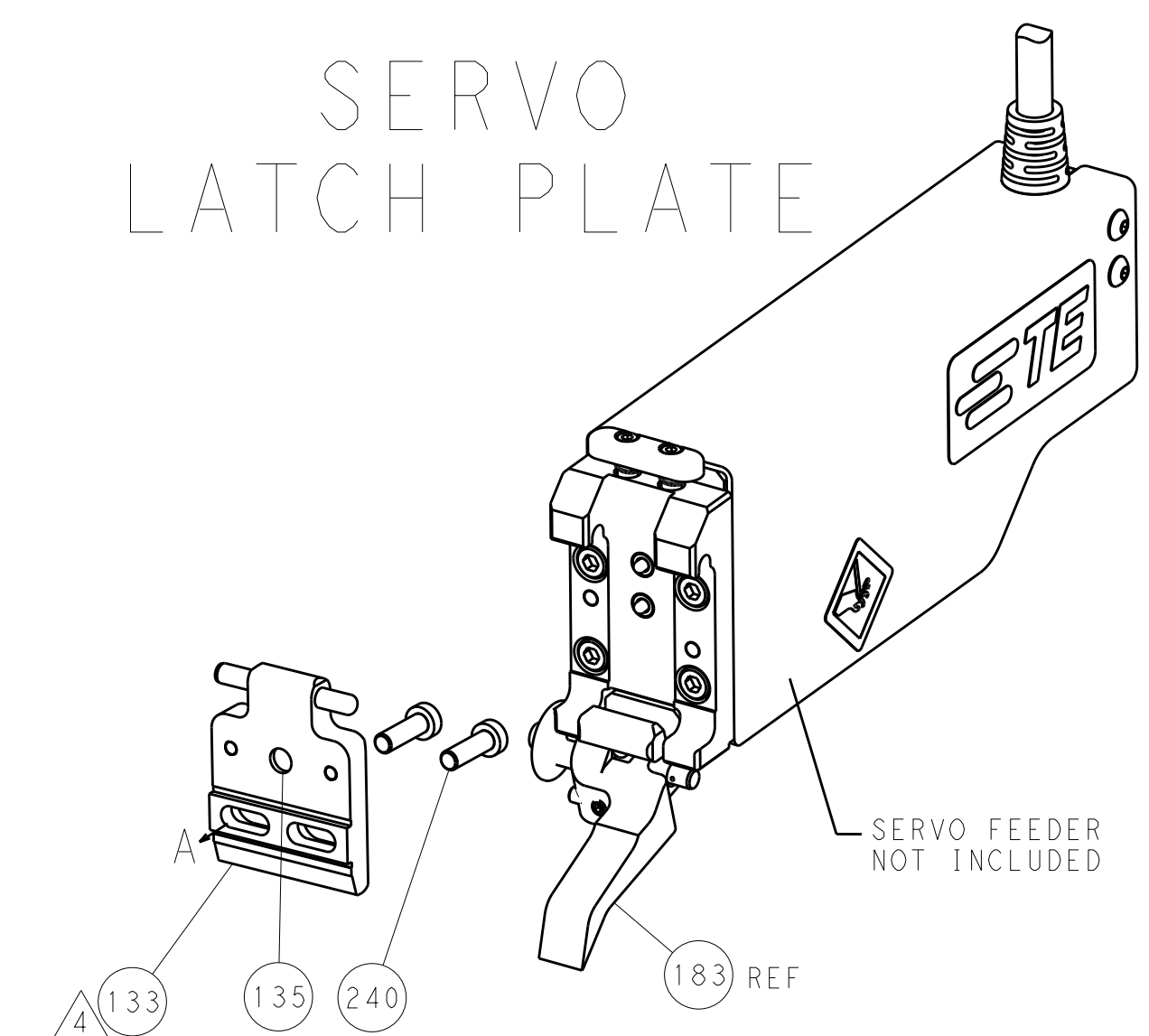
HOLDDOWN SET-UP



FEED TYPE
MECHANICAL

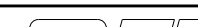


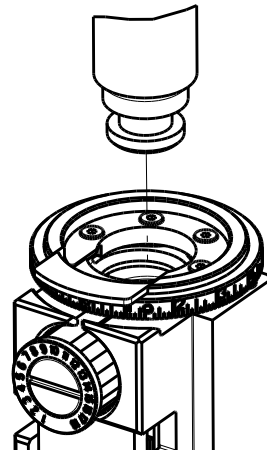
PNEUMATIC

SERVO
LATCH PLATE

ATLANTIC VERSION

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONSULTED FOR THE LATEST REVISION		DWN 25FEB2015 CHK WEAVER ELBIN 25FEB2015 APVD T. ELBIN 25FEB2015		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES, UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
		0. PLC ±. 1. PLC ±. 2. PLC ±. 3. PLC ±. 4. PLC ±. ANGLES ±. FINISH		PRODUCT SPEC APPLICATION SPEC SIZE CASE CODE DRAWING NO A1 00779 C-2150533	
MATERIAL -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing					
				SCALE 1:1 SHEET 2 OF 4 REV B	

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	-
	2-2150533-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150533-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150533-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150533-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150533-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150533-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150533-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					-	-	-	-	-	-	-
	2-2150533-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2150533-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, .250 FF RECEPTACLE W/O LATCH			
WIRE STRIP LENGTH 4.80-5.60 mm [.189-.220 IN]		INSULATION DIAMETER RANGE Ø 2.90-3.80 mm [.114-.150 IN]	
TERMINAL APPLICATION SPECIFICATION		114-5052	- -
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170258-1	170089-1	170089-4	
170258-2	170089-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
3.00mm2		1.78+/-0.05 [.070+/- .002]		5.5
2.00mm2		1.47+/-0.05 [.058+/- .002]		8.8



- 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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150533-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150533-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150533-5
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 62 & 180.
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 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.

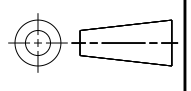
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	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	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
⁶ -	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-77-	27	25	22	21	PART NO	DESCRIPTION	ITEM NO

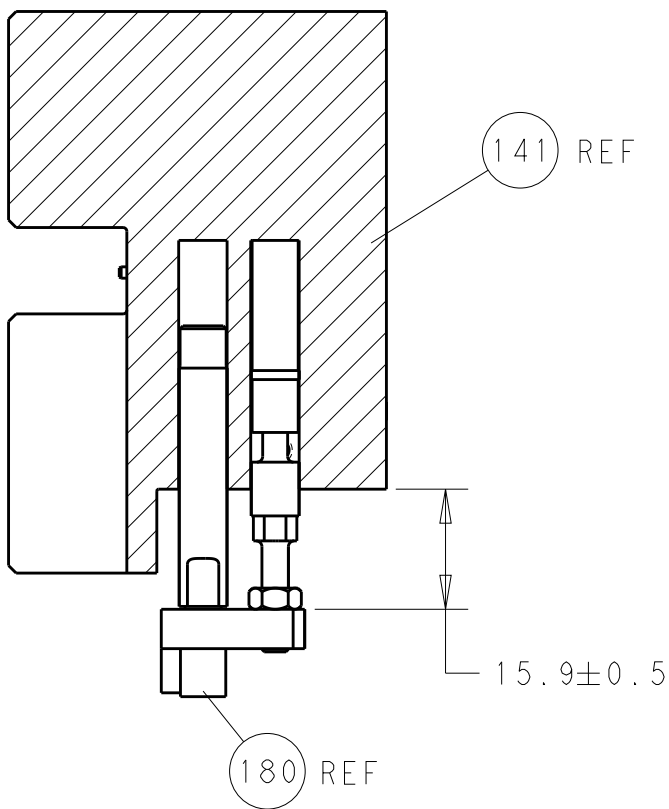
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

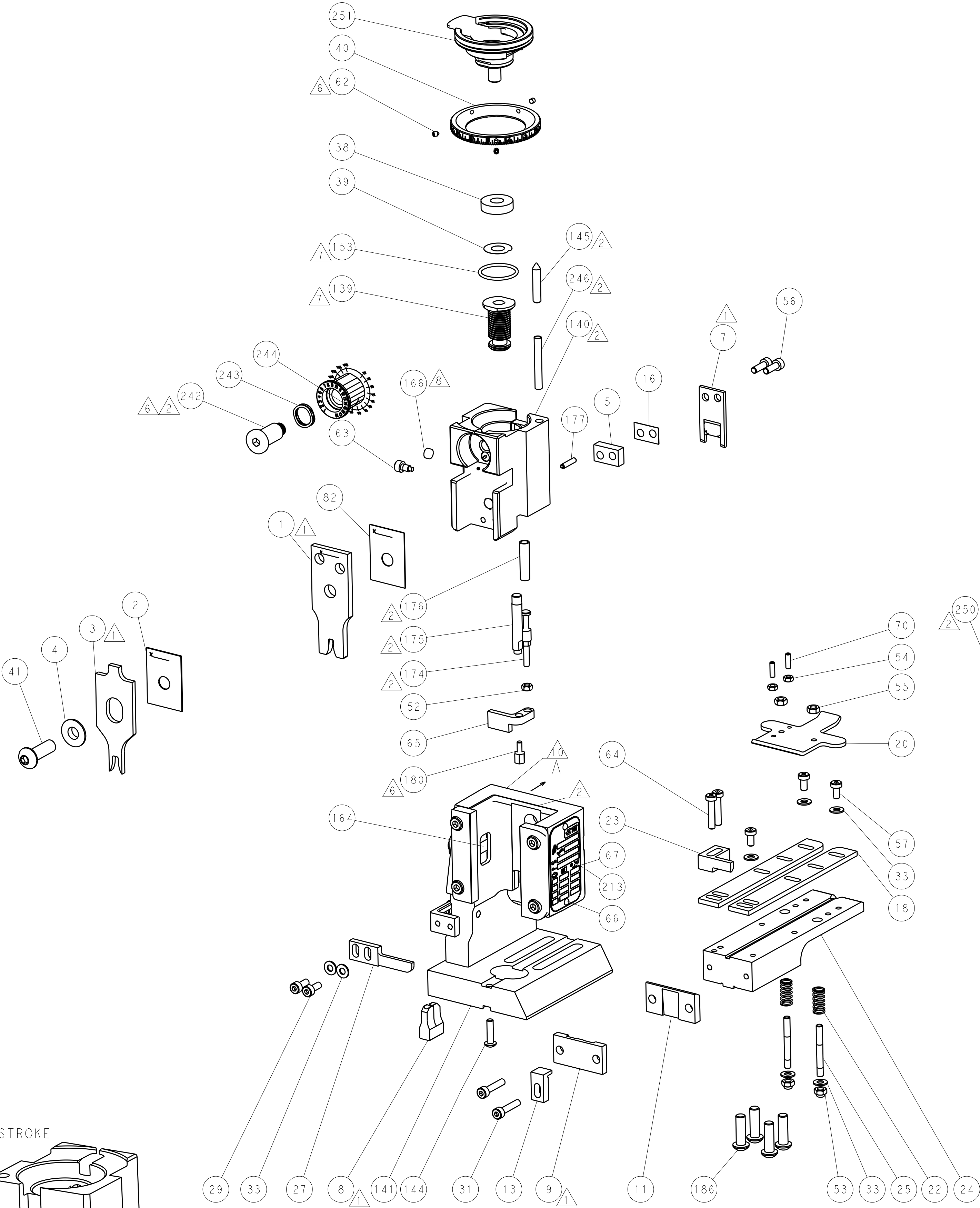
-	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
⁶ -	1	1	1	1	1-1752354-0	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	455888-4	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, 2 x .188	66
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
⁶ -	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-2119644-2	RAM WASHER, PRECISION	38
-	7	7	7	7	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
-	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	1901259-6	GUIDE, LOWER STRIP	18
-	1	1	1	1	4-240641-9	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
¹ -	1	1	1	1	1-240833-3	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
¹ -	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9
¹ -	1	1	1	1	6-1803000-7	ANVIL, COMBINATION, END FEED	8
¹ -	1	1	1	1	1-2217206-3	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	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
¹ -	1	1	1	1	455888-6	SPACER, CRIMPER	2
¹ -	1	1	1	1	3-456410-0	CRIMPER, WIRE PREMIUM	1
-77-	27	25	22	21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST EDITION.				OWN B. WEAVER	25FEB2015	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm				CHK T. ELBIN	25FEB2015		
				APVD T. ELBIN	25FEB2015	NAME Ocean End Feed Applicator	
				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -				WEIGHT -		SIZE A	
				Customer Accessible Production Drawing		SCALE 1:1	
						SHEET 3	
						OF 4	
						REV B	

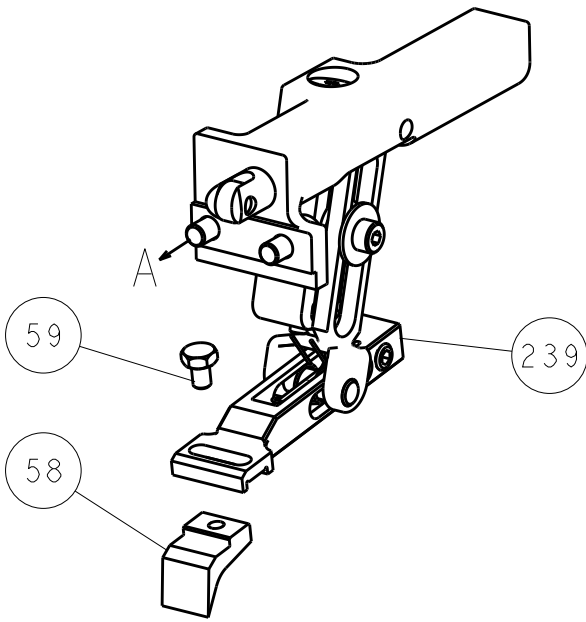
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



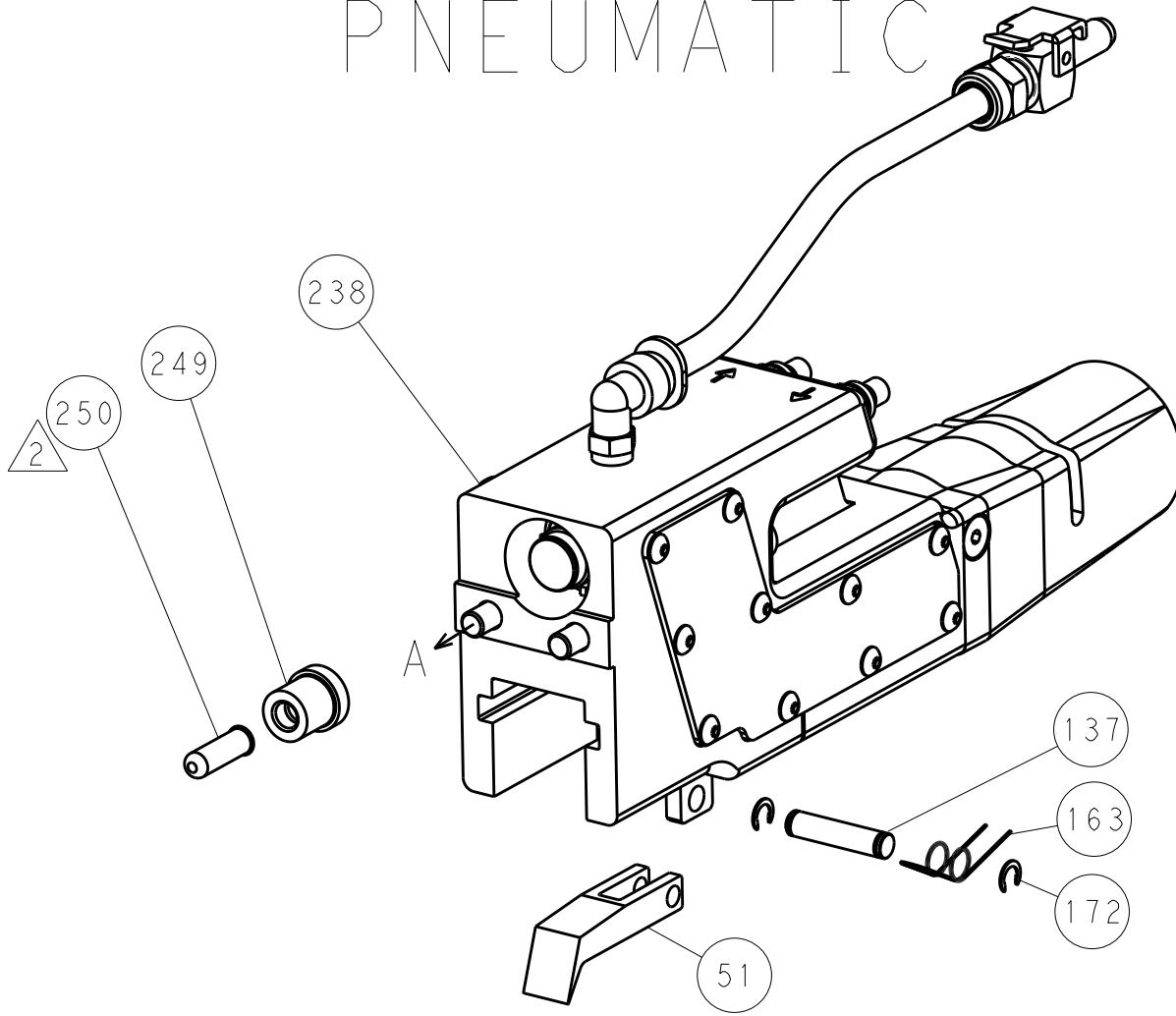
HOLDDOWN SET-UP



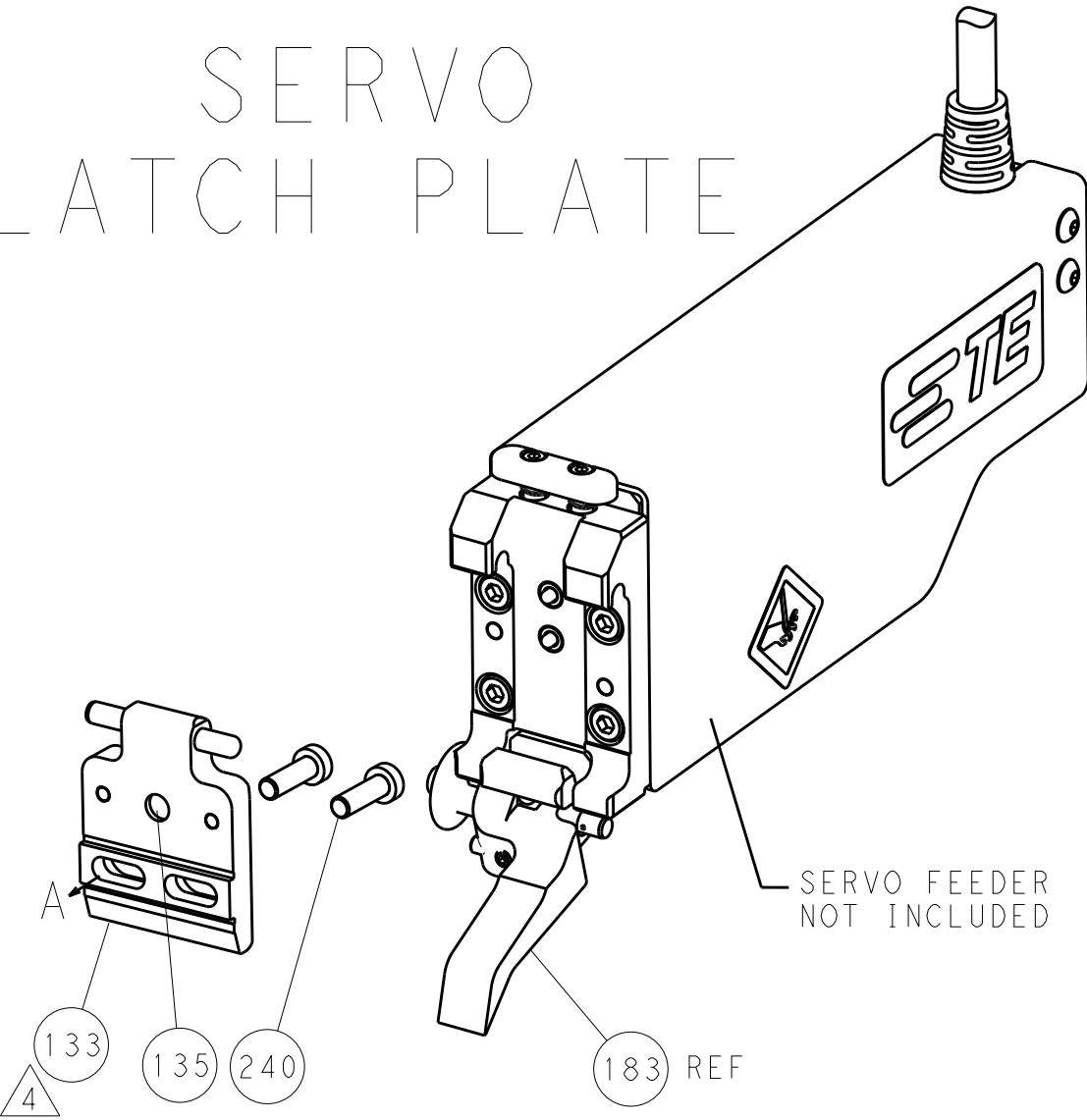
FEED TYPE
MECHANICAL



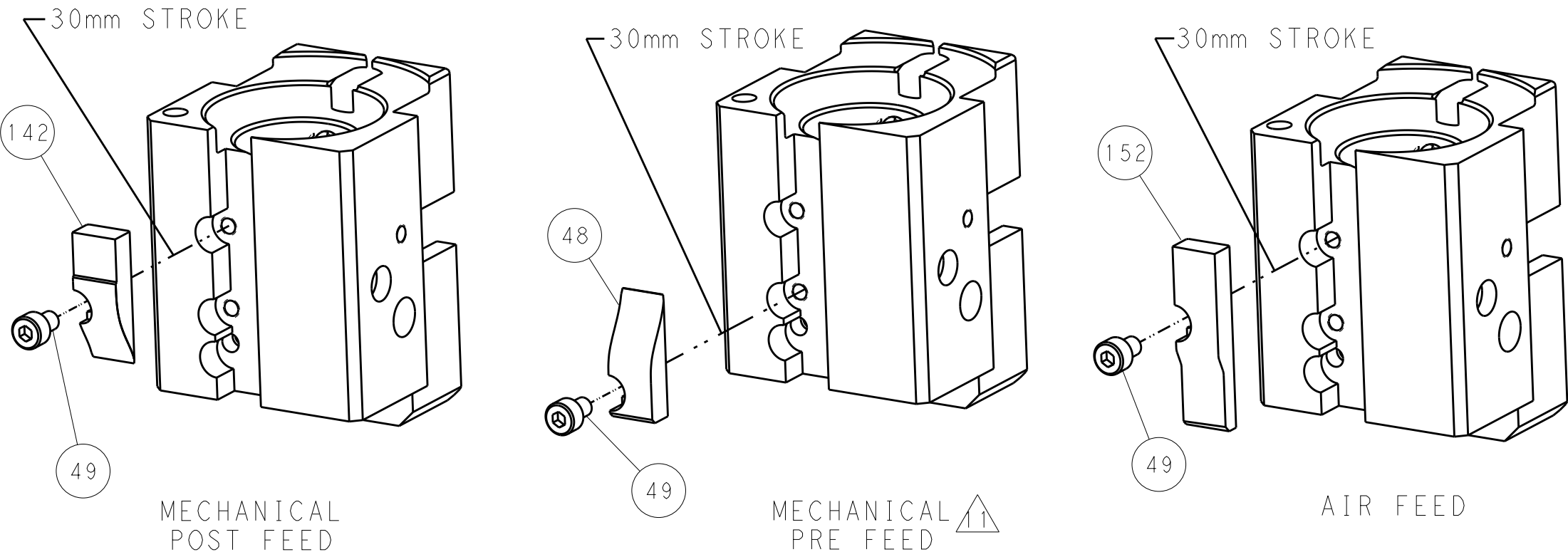
PNEUMATIC



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: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN B. WEAVER 25FEB2015		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL		FINISH		CHK T. ELBIN 25FEB2015		NAME Ocean End Feed Applicator	
				APVD T. ELBIN 25FEB2015		SIZE A1	
				PRODUCT SPEC		CAGE CODE 00779	
				APPLICATION SPEC		DRAWING NO C-2150533	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:1	
						SHEET 4	
						REV B	