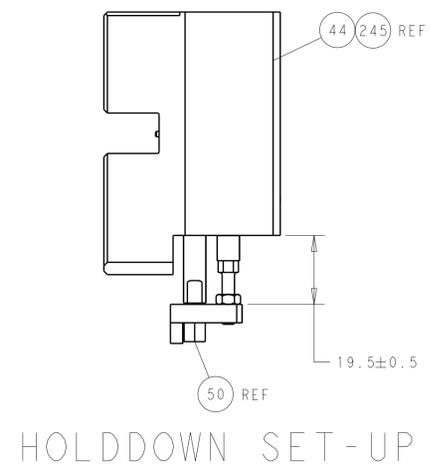
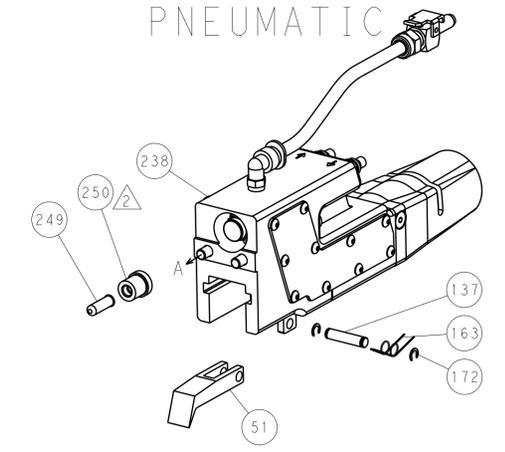


LOC		DIST		REVISONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

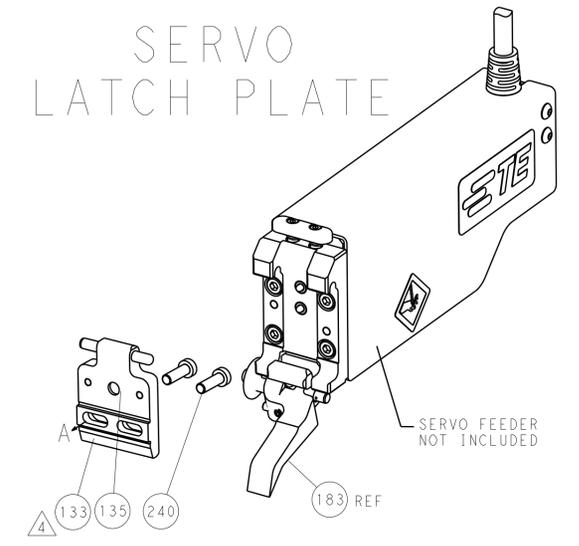


FEED TYPE

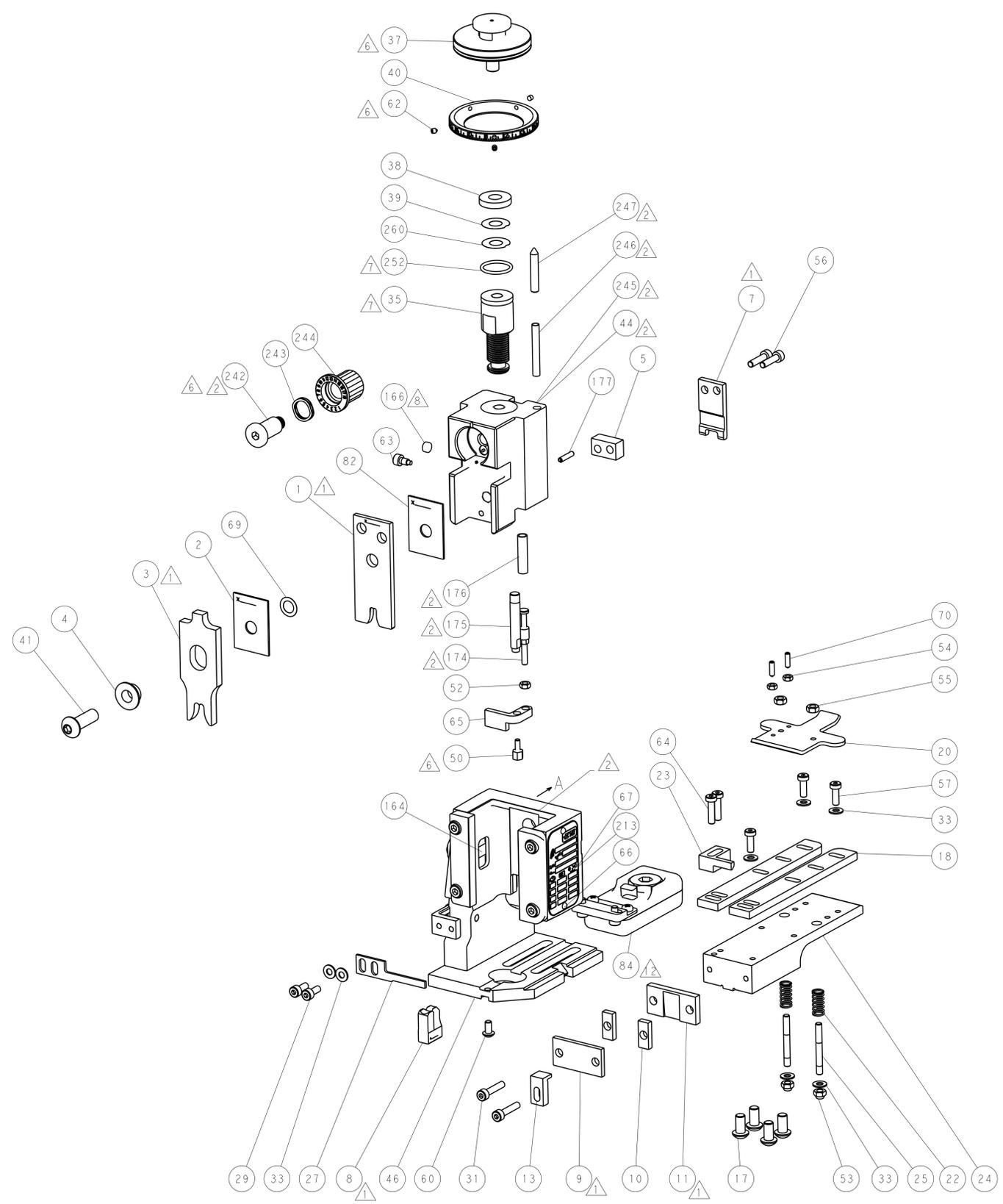
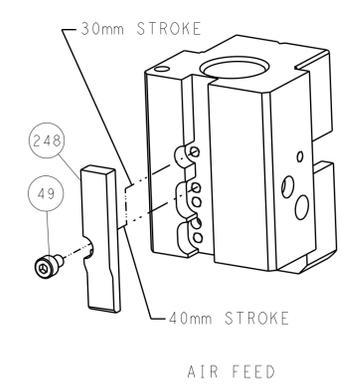
PNEUMATIC



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:		DWN R. HUANG 27SEP2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK S. XI 27SEP2012	NAME	Ocean End Feed Applicator	
	1 PLC	±		APVD S. XI 27SEP2012	PRODUCT SPEC	RESTRICTED TO	
	2 PLC	±			APPLICATION SPEC	SIZE	CAGE CODE DRAWING NO
	3 PLC	±				00779	©=2150286
	4 PLC	±			WEIGHT	Customer Accessible Production Drawing	
MATERIAL	FINISH				SCALE	1:1	SHEET 2 OF 4 REV C

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150286-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150286-5	-	-	2168400-7 (QUANTITY 2)
	2-2150286-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-2
2-2150286-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150286-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [1.80]	F
INSUL	7.62 mm [3.00]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.210-.225 IN [5.33-5.72 mm]		∅.170-.210 IN [4.32-5.33 mm]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42864-1	42864-2	42863-2	61424-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
10 AWG	3.76+/-0.05 [1.48+/-0.02]	3.8
12 AWG	3.40+/-0.05 [1.34+/-0.02]	7.9

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150286-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150286-5
- 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 ITEMS 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.
- TERMINAL PITCH NOT COMPATIBLE FOR MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.

-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	77	27	25-22	PART NO	DESCRIPTION	ITEM NO

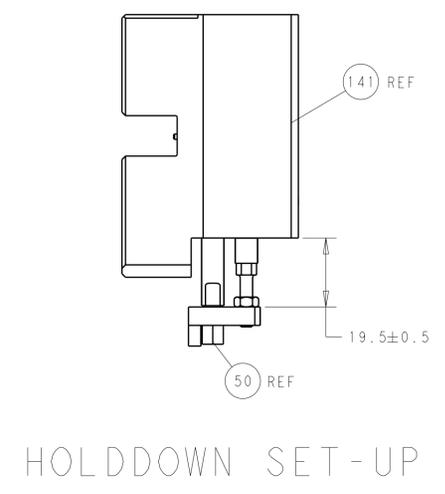
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	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
-	-	-	1	2119740-2	TAG, IDENTIFICATION	213
-	-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	-	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
-	-	-	1	2119641-2	FEED CAM, AIR FEED	152
-	-	1	1	2119798-2	DETENT PIN	145
-	-	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	-	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	-	1	1	455888-9	SPACER, CRIMPER	82
-	-	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	-	1	1	2119943-1	WASHER, SPACER	69
-	-	1	-	2119740-1	TAG, IDENTIFICATION	67
-	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	1	1	1901681-5	HOLDDOWN, TERMINAL	65
-	-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	-	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
-	-	3	3	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	-	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	1	2119792-2	PAWL, EF, AIR	51
-	-	1	1	1752354-6	STANDOFF, HOLD-DOWN	50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	-	1	1	2119644-5	RAM WASHER, PRECISION	38
-	-	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	-	1	1	690455-2	STRIPPER, FRONT CASTING	27
-	-	2	2	1320906-1	STUD, THREADED	25
-	-	1	1	1752371-1	PLATE, STRIP GUIDE	24
-	-	1	1	240825-8	PLATE, STRIP HOLD DOWN	23
-	-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	-	1	1	1752373-4	DRAG	20
-	-	2	2	1901259-8	GUIDE, LOWER STRIP	18
-	-	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	2	2	1-240645-7	SPACER, SHEAR PLATE	10
-	-	1	1	240642-1	PLATE, FRONT SHEAR	9
-	-	1	1	2-1633383-8	ANVIL, COMBINATION	8
-	-	1	1	8-240651-8	BLADE, SLUG	7
-	-	1	1	4-240641-7	SPACER	5
-	-	1	1	238009-7	BLOCK, FL CRIMPER SPACER	4
-	-	1	1	6-2119582-0	CRIMPER, INSULATION F PREMIUM	3
-	-	1	1	455888-9	SPACER, CRIMPER	2
-	-	1	1	1-456428-2	CRIMPER, WIRE	1

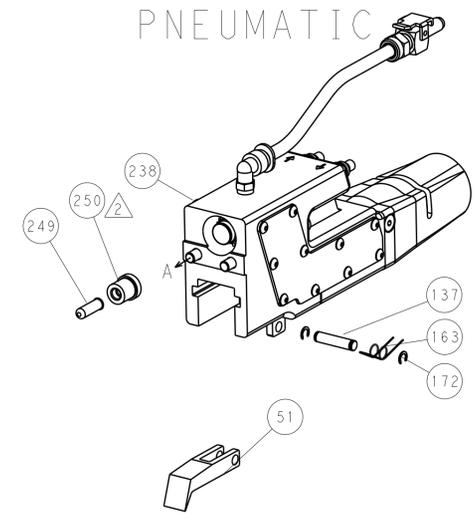
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mm	0 PLC	±									
	1 PLC	±									
	2 PLC	±									
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									

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

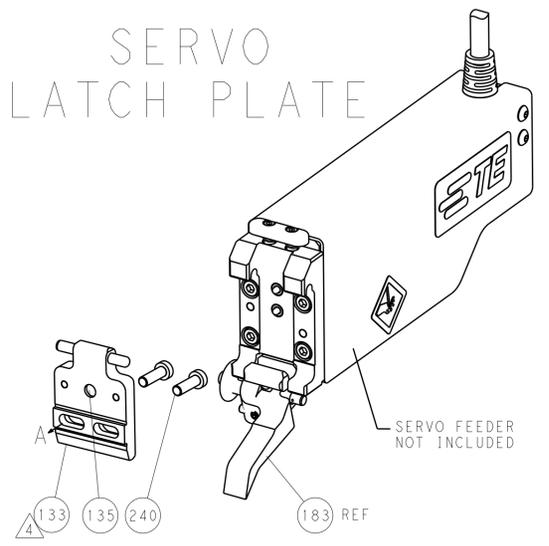


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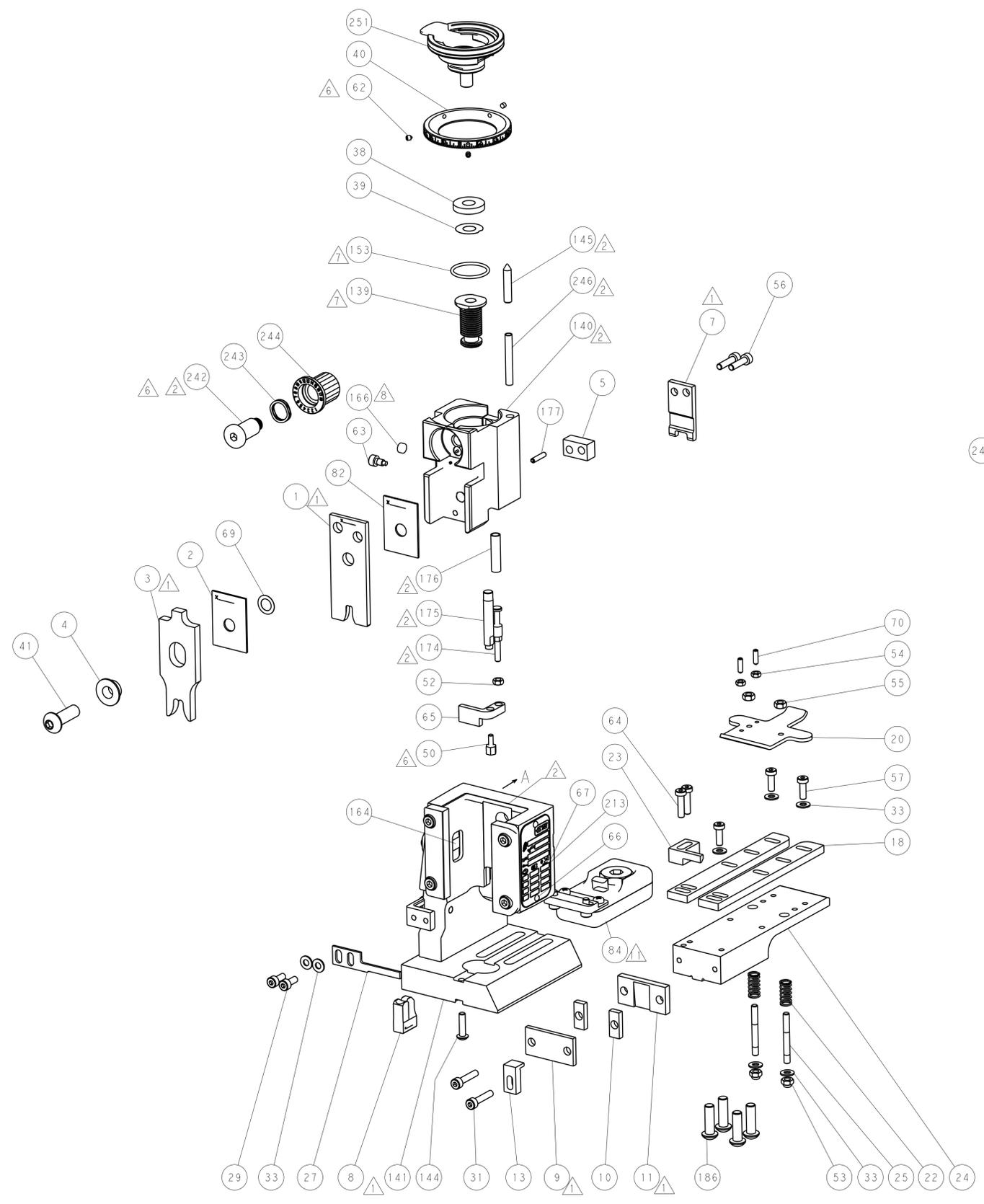
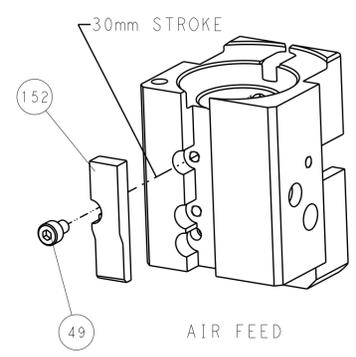
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	FINISH:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:1	SHEET 4 OF 4 REV C	CUSTOMER ACCESSIBLE PRODUCTION DRAWING