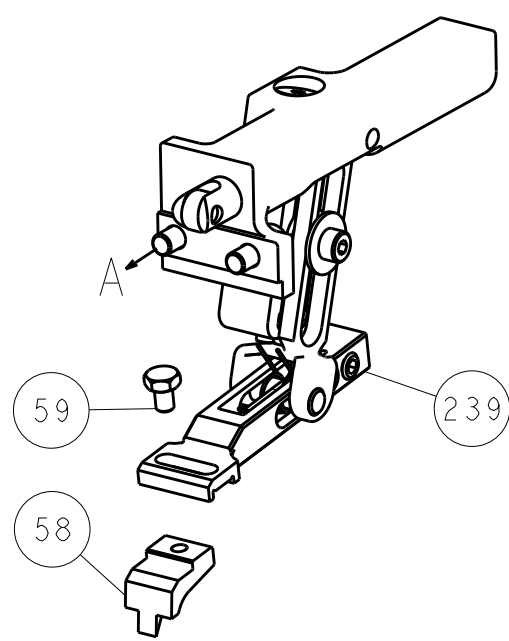
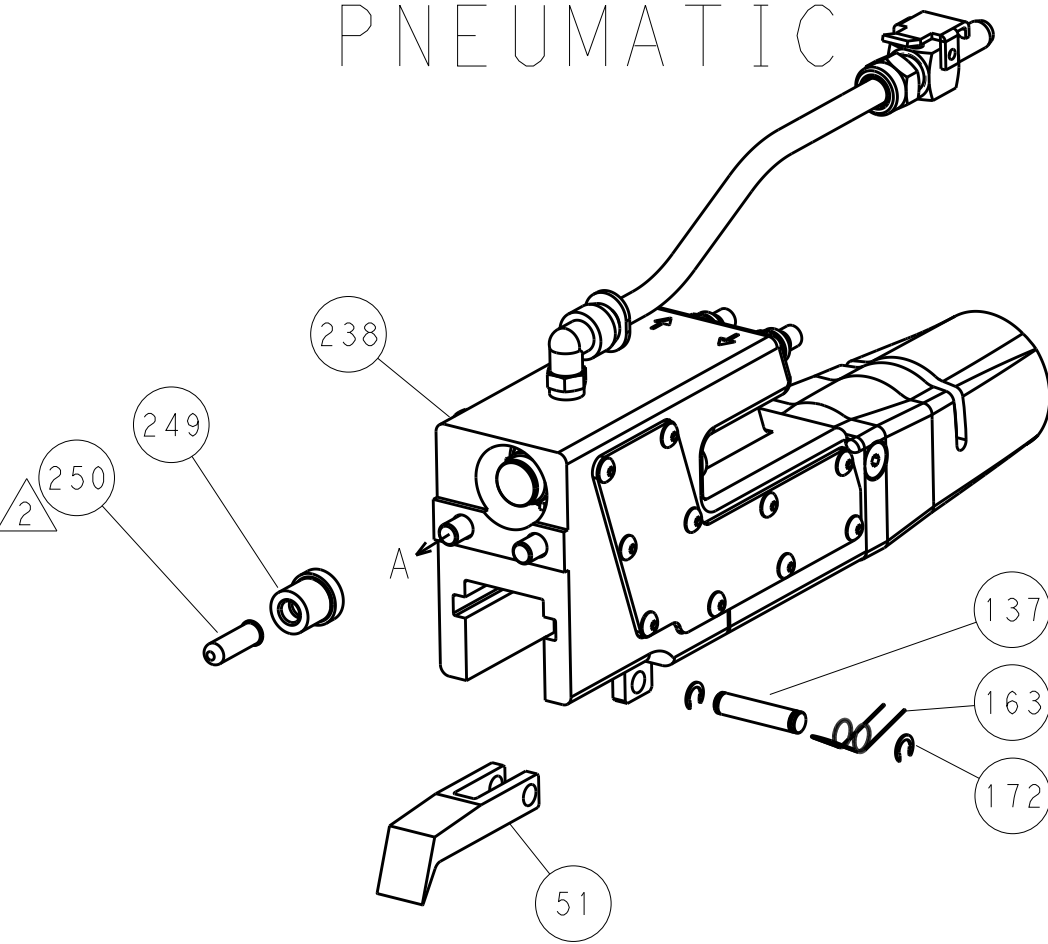


LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

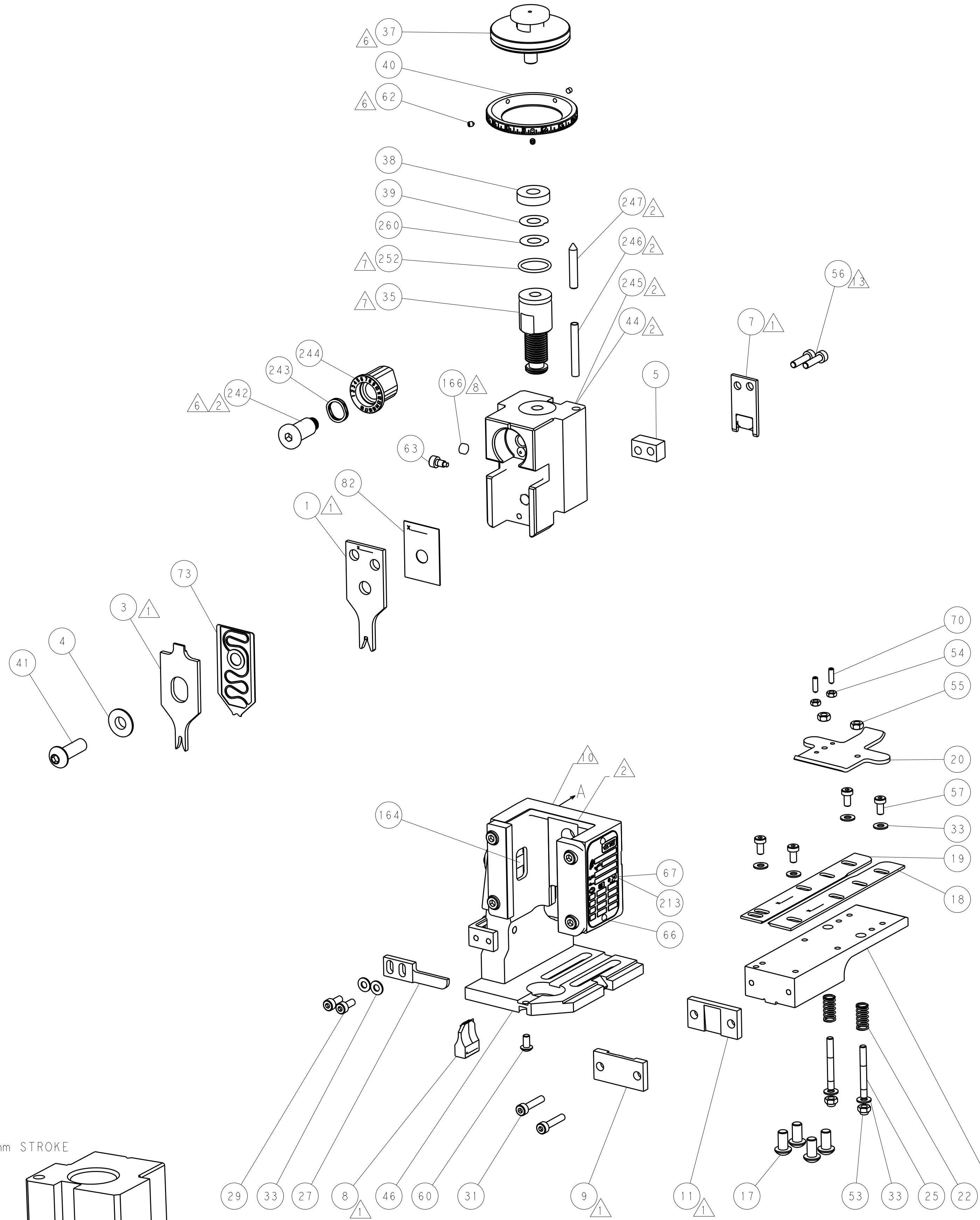
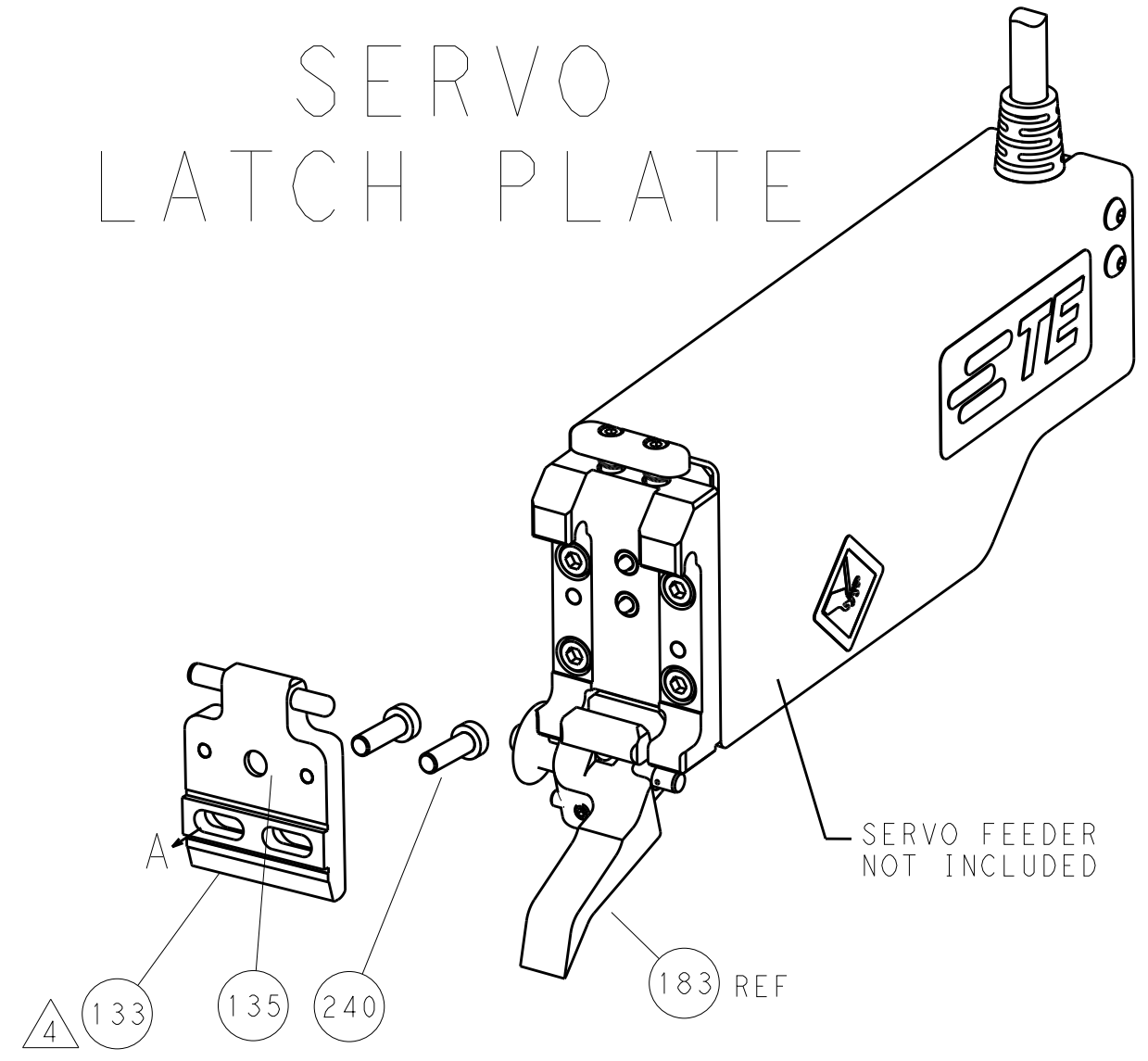
FEED TYPE
MECHANICAL



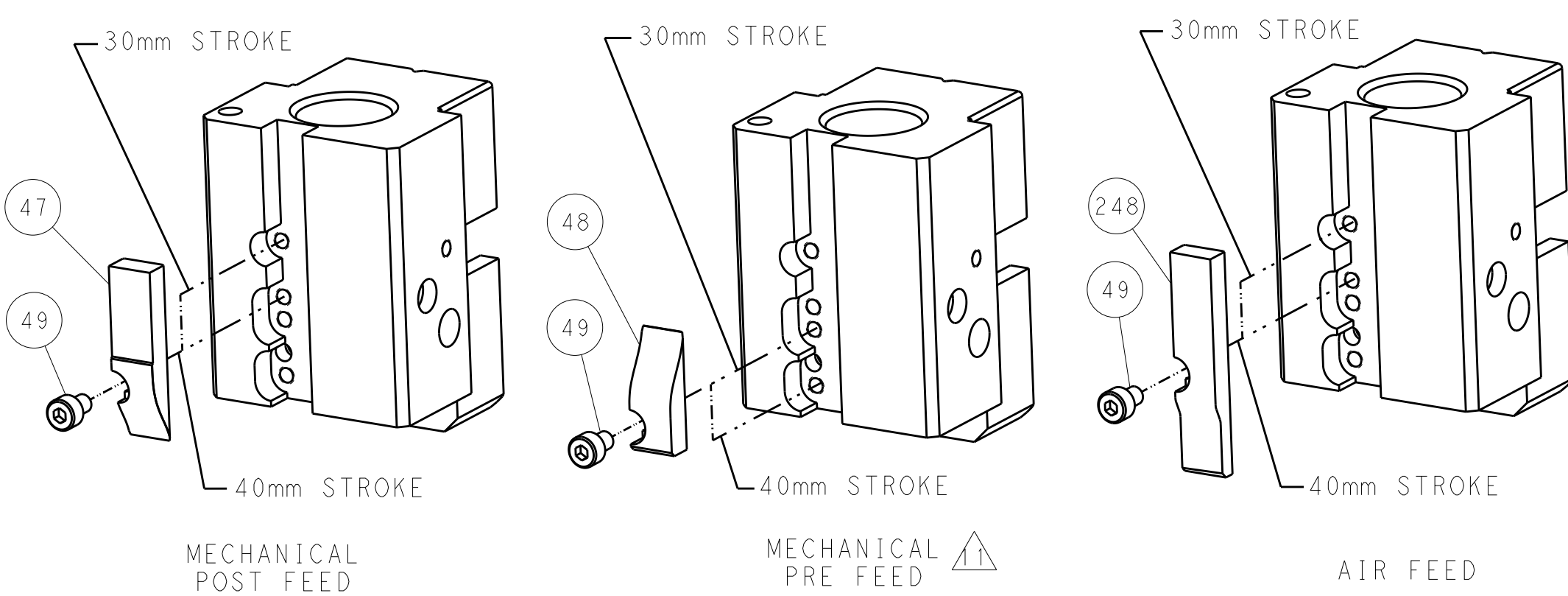
PNEUMATIC



SERVO
LATCH PLATE

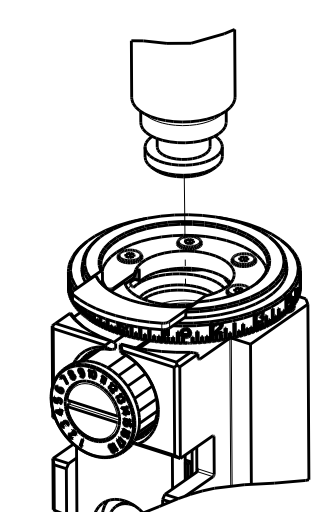


CAM POSITIONS



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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWG: Y. YIN 13JUN2013 CHK: G. BAILEY 13JUN2013 APVD: H. GUO 13JUN2013				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				NAME: Ocean End Feed Applicator			
MATERIAL: -				WEIGHT: -				SIZE: A11 CAGE CODE: 00779 DRAWING NO: C-2150343			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET 2 OF 4 REV C1			

8				6		5		4		3		
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20								
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.										
	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	-	2063440-1
						SERVO LATCH PLATE	2119951-1	1901697-1	8-2150343-5	-	-	2168400-7 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2150343-4	-	-	-
						MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
						SERVO LATCH PLATE	2119951-1	1901697-1	8-2150343-5	-	-	2168400-7 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2150343-4	-	-	-
						MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
						PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
						-	-	-	-	-	-	-
					-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 3.94-4.70 mm [.155-.185 IN]			INSULATION DIAMETER RANGE Ø1.22-1.98 mm [.048-.078 IN]
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42164-2	42508-2	63721-1	
42164-3	42508-3		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
20 AWG		1.40+/-0.05 [.055+/- .002]		7.6
22 AWG		1.35+/-0.05 [.053+/- .002]		8.2
24 AWG		1.27+/-0.05 [.050+/- .002]		9.0



- 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: 8-2150343-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150343-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150343-5
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 & 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.
- ¹² CUT TO LENGTH AT ASSEMBLY.

¹² THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

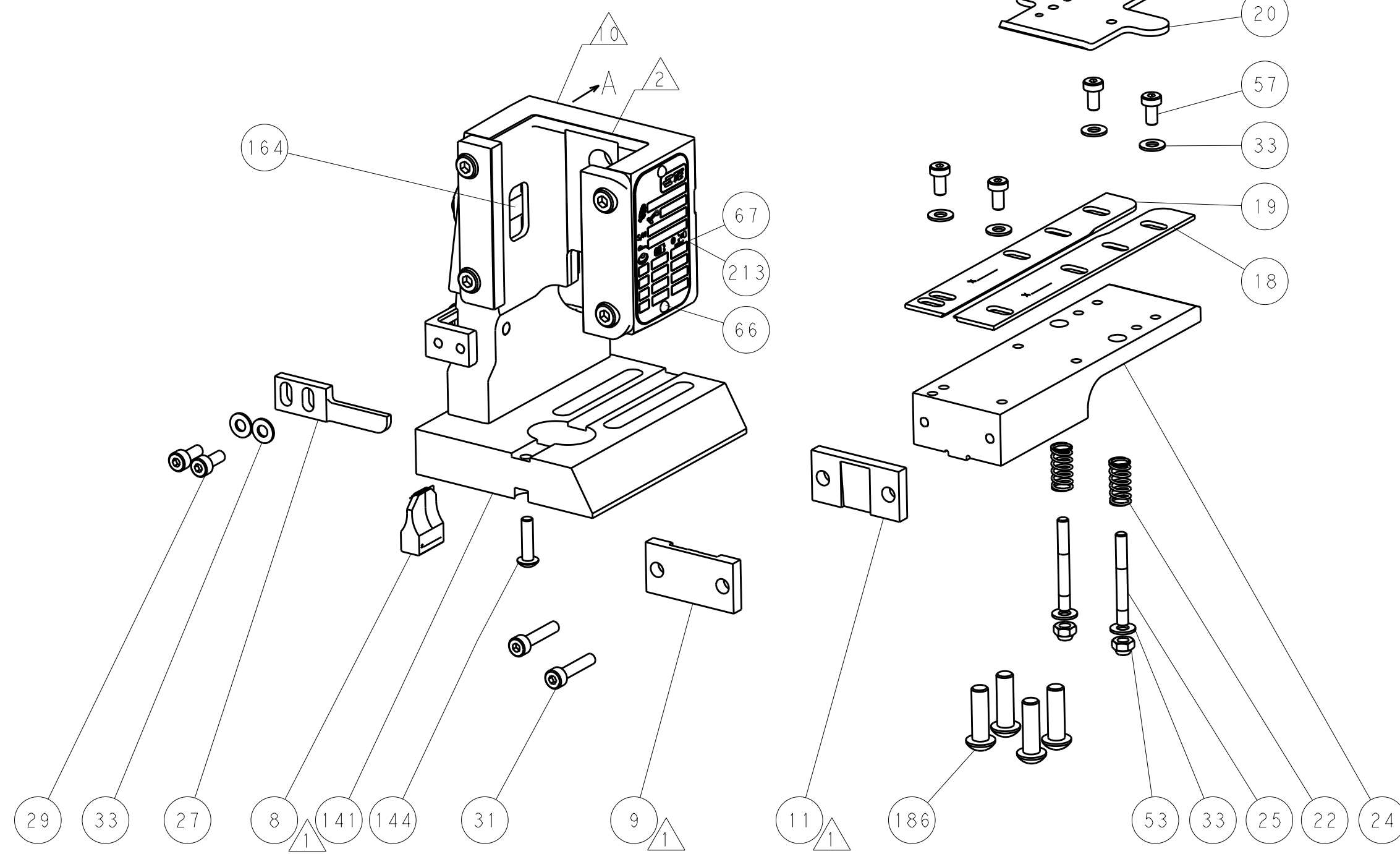
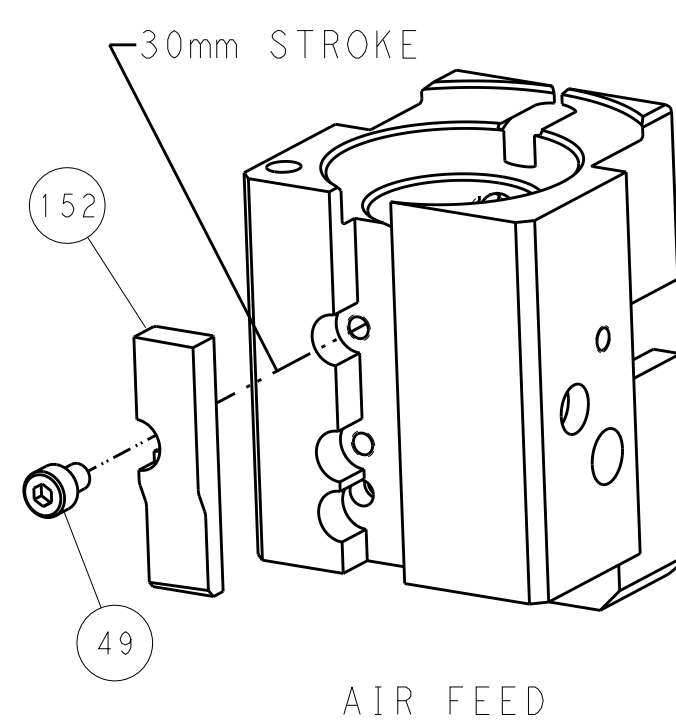
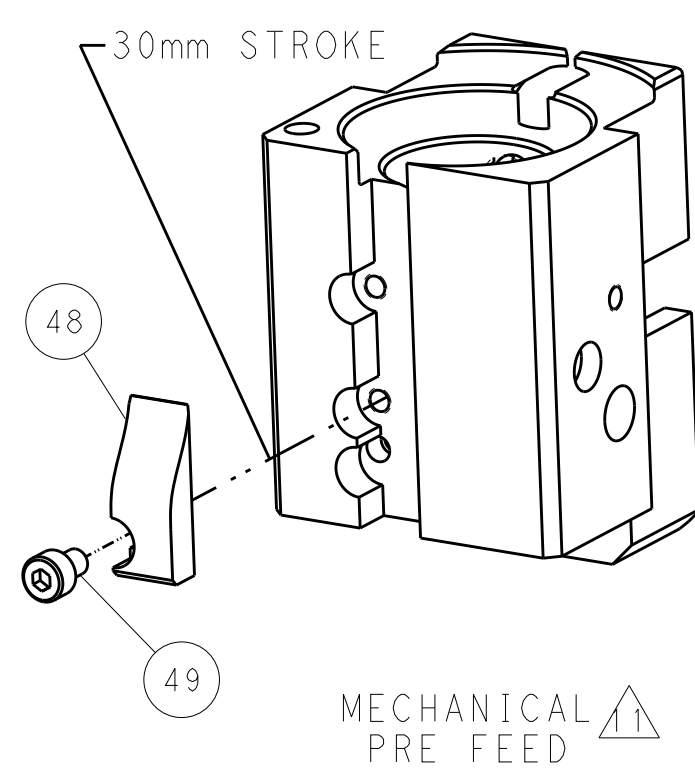
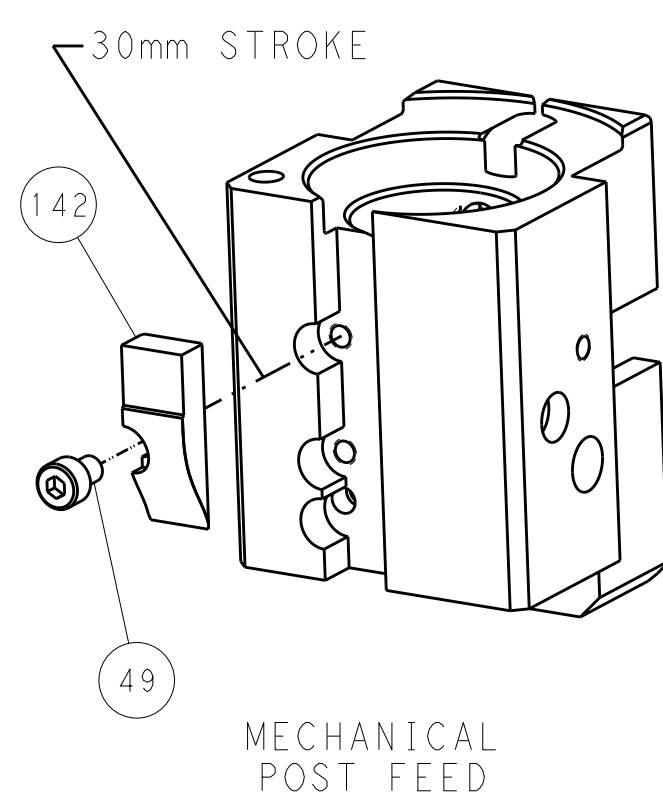
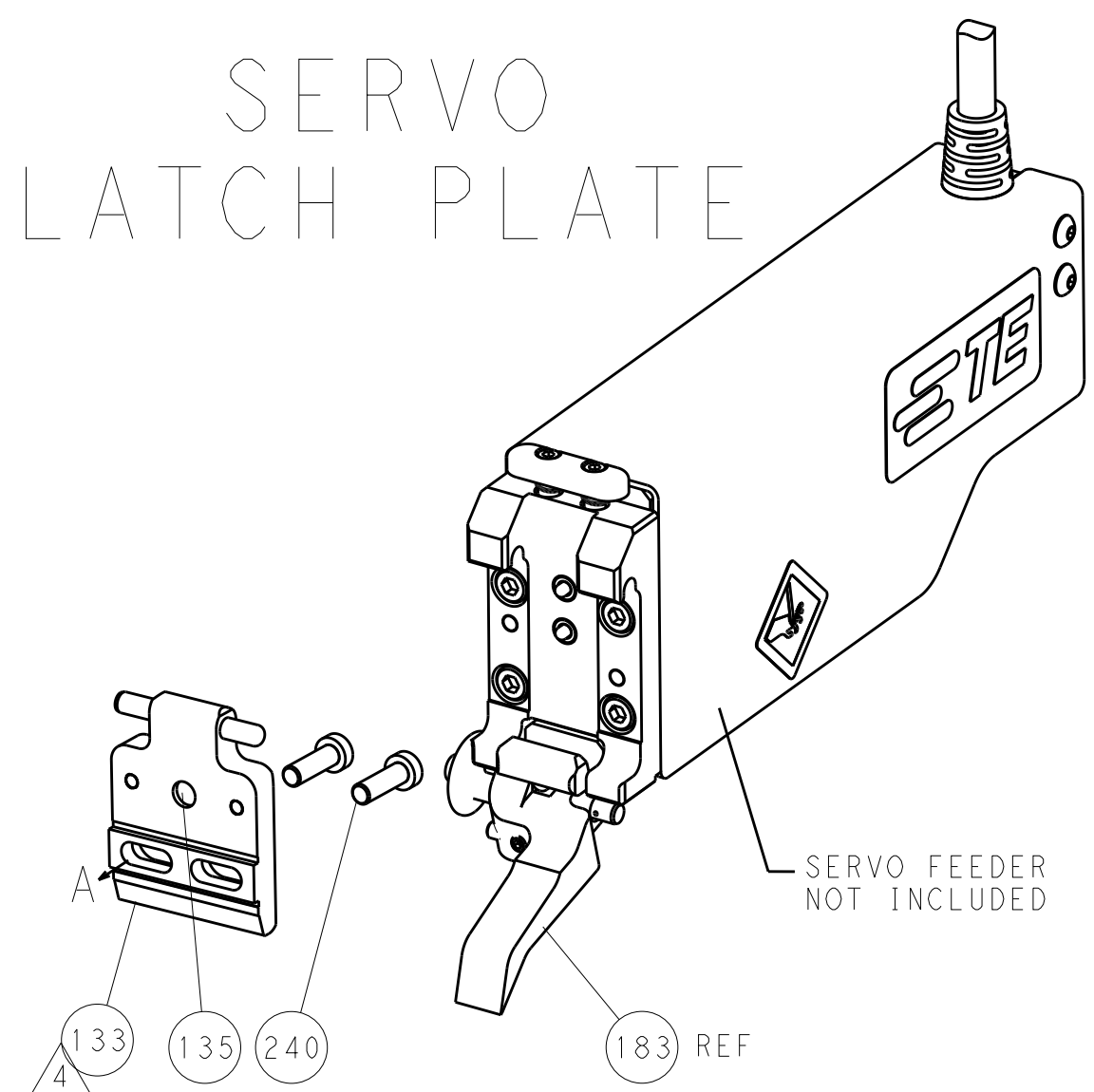
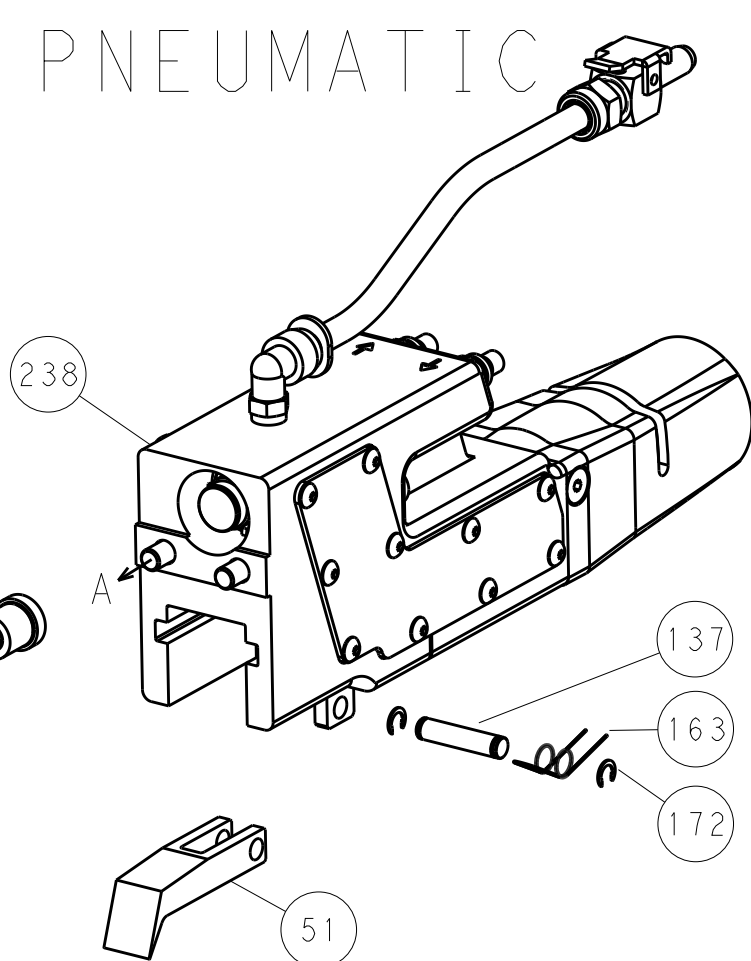
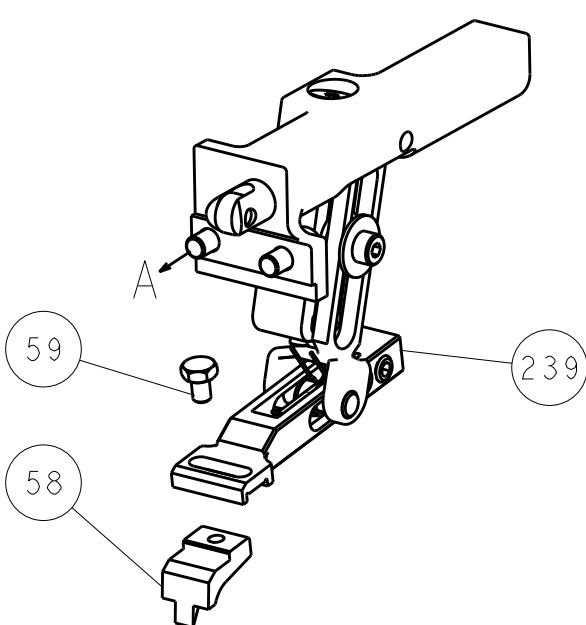
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

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

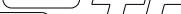
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
			-	-	SEE SHEET 1	-

-	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	1-22279-3	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
-	-	-	-	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
-	-	-	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	2119791-9	DEPRESSOR, WIRE	73
-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, 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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, 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	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	-	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
-	8	8	8	8	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4	DRAG	20
-	1	1	1	1	1901696-2	STRIP GUIDE, REAR	19
-	1	1	1	1	1901695-2	STRIP GUIDE, FRONT	18
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690482-7	PLATE, FRONT SHEAR	9
-	1	1	1	1	3-1333216-3	ANVIL, COMBINATION	8
-	1	1	1	1	1-2217206-8	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	6-240641-0	SPACER	5
-	1	1	1	1	3-238009-7	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	-	-	2
-	1	1	1	1	1633730-5	CRIMPER, WIRE	1
-	77-27-25-22-21	PART NO		DESCRIPTION			ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE CUSTOMER SHALL BE RESPONSIBLE FOR VERIFYING THE ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.				DWN Y. YIN CHK G. BAILEY APVD H. GUO	13JUN2013 13JUN2013 13JUN2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC		SIZE CASE CODE DRAWING NO	
		FINISH		APPLICATION SPEC		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		A1 00779 ©=2150343	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 3 OF 4 REV C			



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

THIS DRAWING IS A UNCLASSIFIED DOCUMENT FOR THE INFORMATION OF THE CUSTOMER. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM THE COMPANY. THE COMPANY ASSUMES NO LIABILITY FOR ANY ERRORS OR OMISSIONS. THE COMPANY SHALL BE CONTACTED FOR THE LATEST REVISION.		DWN: 13JUN2013 Y. YIN		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±.		NAME: Ocean End Feed Applicator -	
		APVD: 13JUN2013 G. BAILEY M. GUO		SIZE: CAGE CODE: DRAWING NO: 21503343 RESTRICTED TO:	
MATERIAL: FINISH:		WEIGHT:		A 00779 C	
		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 4 OF 4 REV: C	