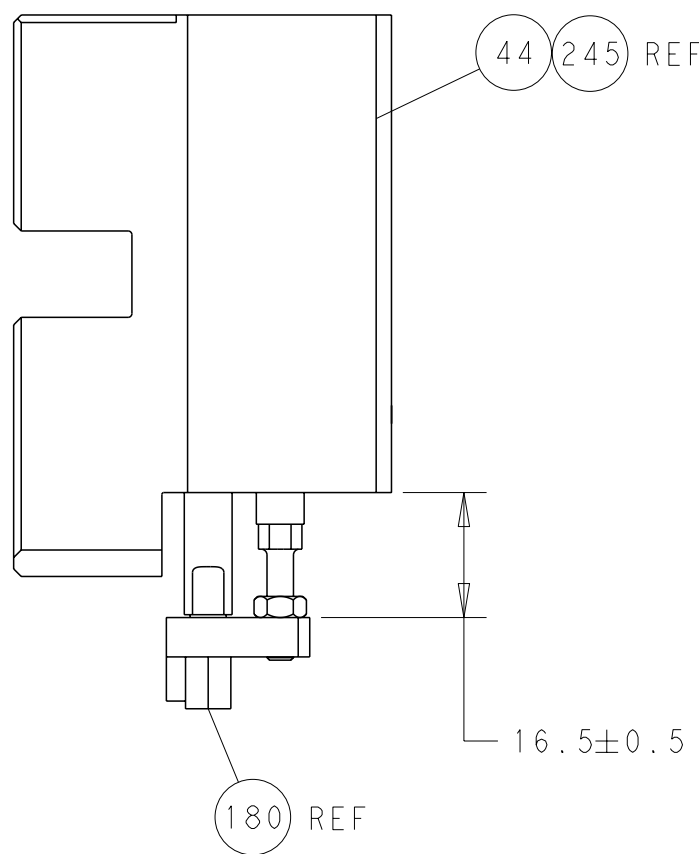
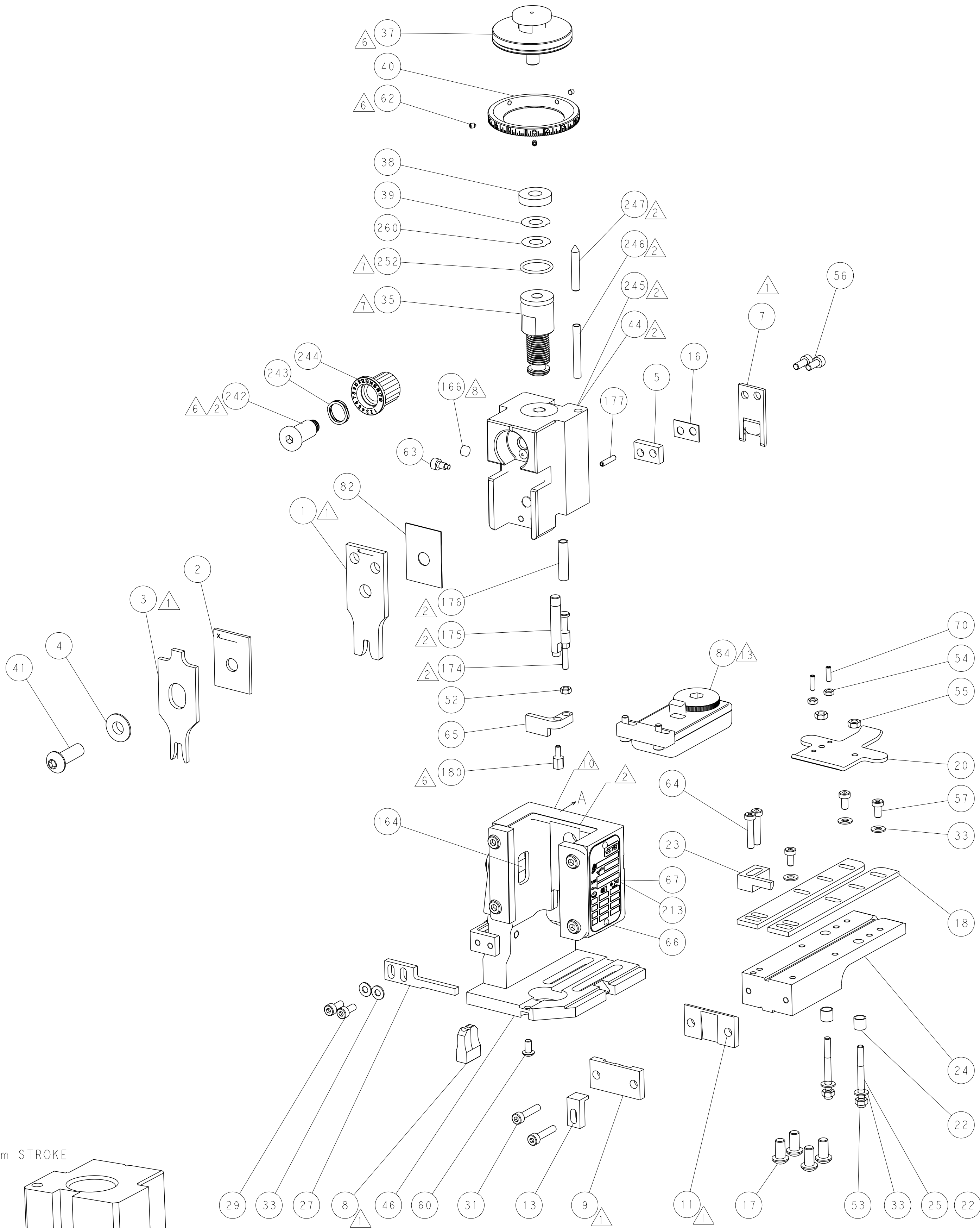


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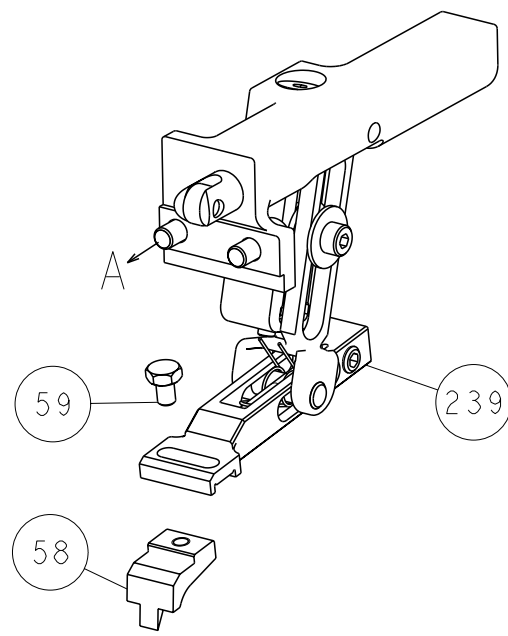
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



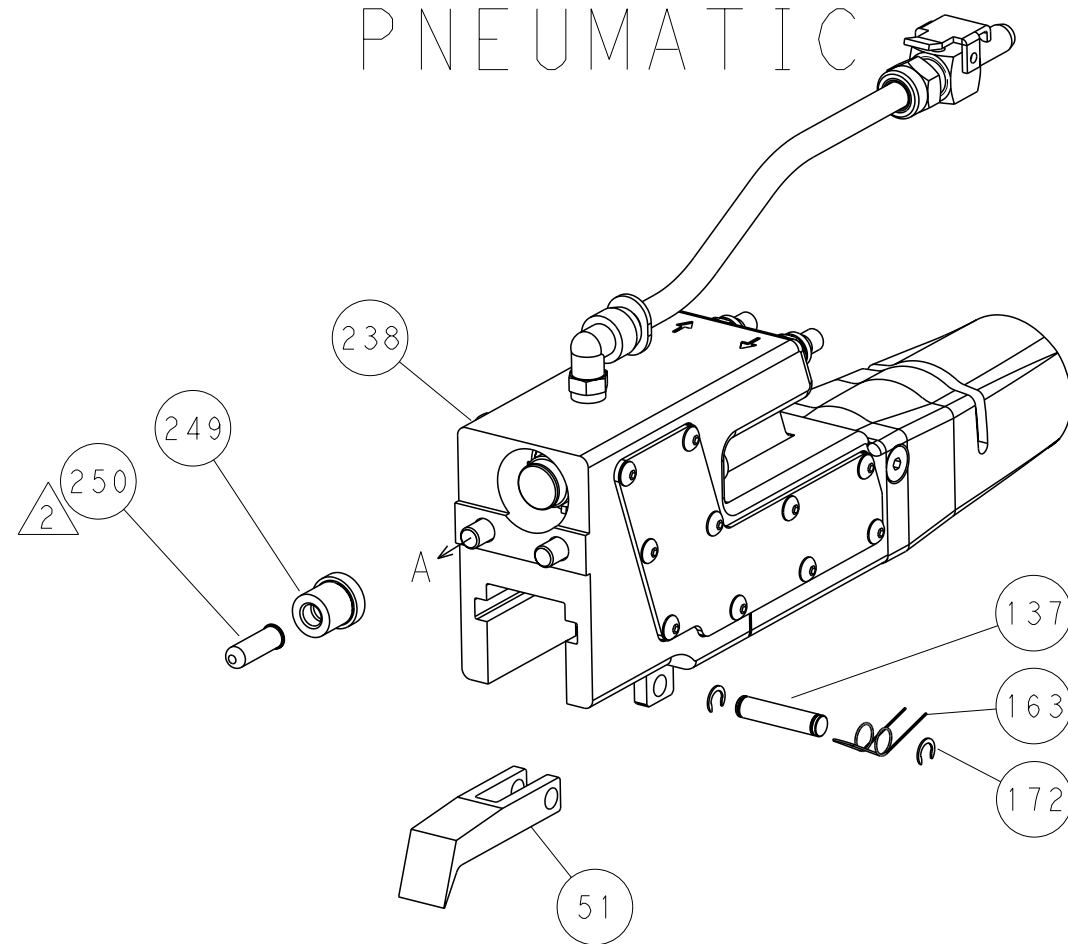
HOLDDOWN SET-UP



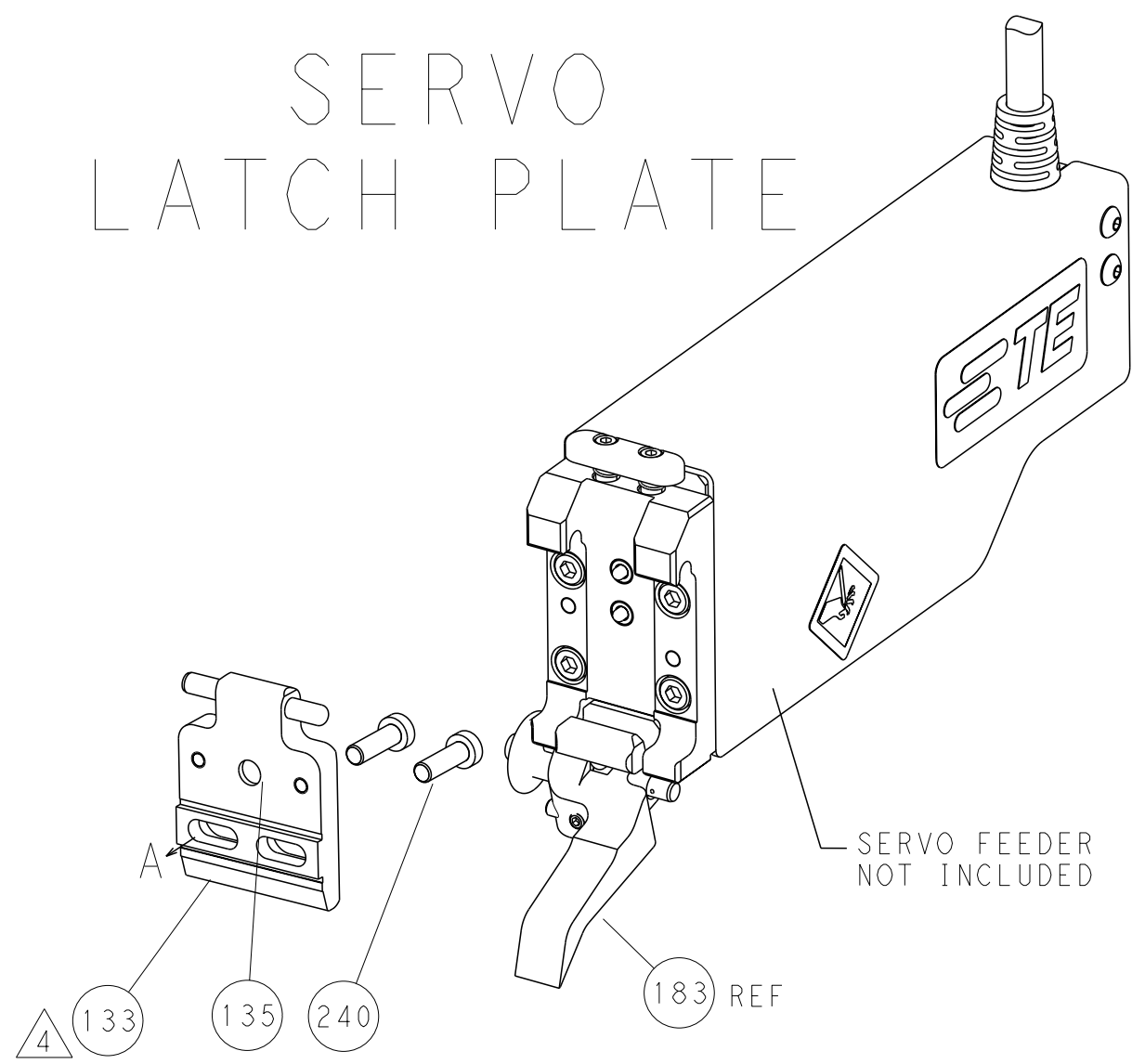
FEED TYPE
MECHANICAL



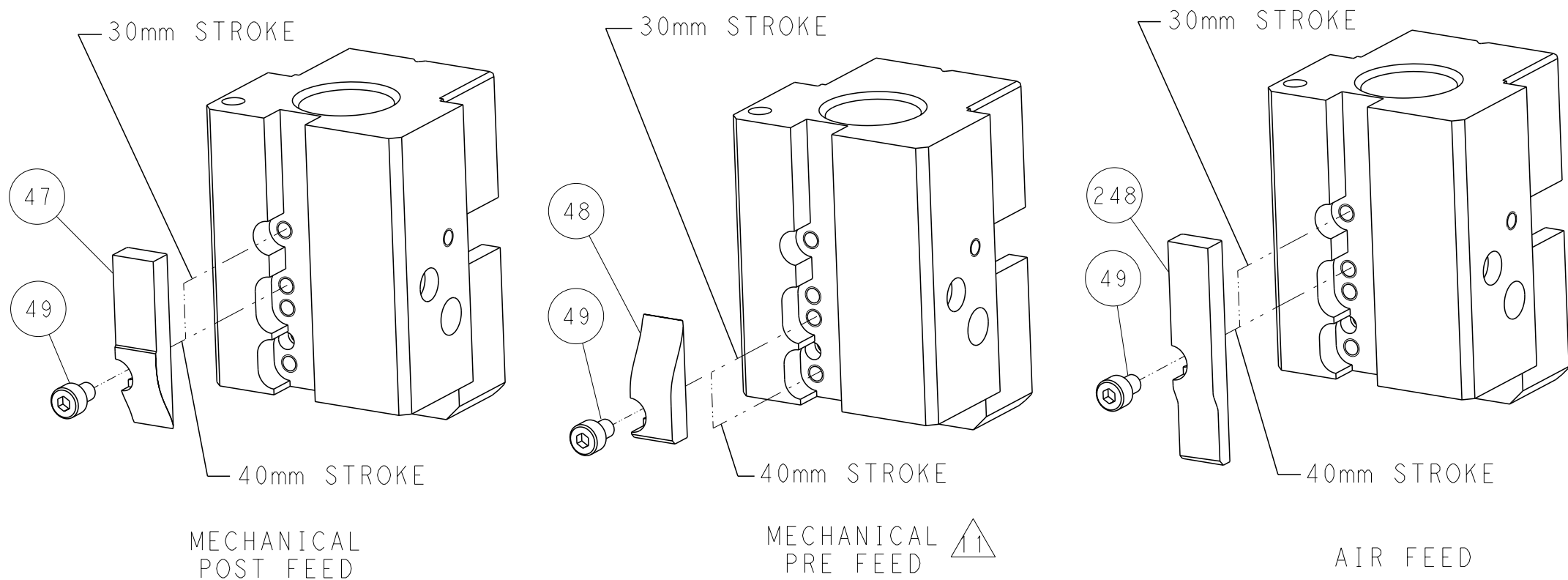
PNEUMATIC



SERVO
LATCH PLATE

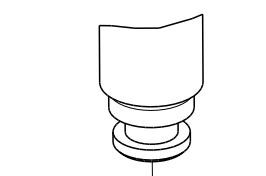


CAM POSITIONS



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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO BE USED ONLY FOR THE PURPOSES AND APPLICATIONS SPECIFIED IN THE DRAWING. ANY OTHER USE IS PROHIBITED. ANY REVISIONS SHALL BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG 16DEC2013	TE Connectivity Harrisburg, PA 17105-3608	
CHK L. ZHANG 16DEC2013				NAME	Ocean End Feed Applicator	
APVD J. GUO 16DEC2013				PRODUCT SPEC	-	
				APPLICATION SPEC	-	
				WEIGHT	-	
				SCALE	1:1	
				SHEET	2 of 4	
				REV	B	

8		7		6		5		4		3		
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20								
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
	2-2150402-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1	
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150402-5	-	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150402-4	-	-	-	
	2-2150402-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150402-5	-	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150402-4	-	-	-	
	2-2150402-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1	
	2-2150402-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
	7-2150402-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.59 mm [.220]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SRS FAST-IN-ON REC.			
WIRE STRIP LENGTH 5.80-6.60 mm [.228-.260 IN]		INSULATION DIAMETER RANGE Ø4.00-5.20 mm [.157-.205 IN]	
TERMINAL APPLICATION 		114-18022	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160914-1	160914-2	160914-3	160914-4

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
6.00mm2		2.58+/-0.05 [.102+/- .002]		5.6
4.00mm2 + 1.0mm2		2.39+/-0.05 [.094+/- .002]		7.9
4.00mm2 + 0.5mm2		2.29+/-0.05 [.090+/- .002]		8.9
4.00mm2		2.20+/-0.05 [.087+/- .002]		9.8



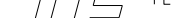
1. RECOMMENDED SPARE PARTS
2. GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150402-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150402-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150402-5
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 & 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 2119653-2. 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. TERMINAL LUBRICANT IS RECOMMENDED.

-	-	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)

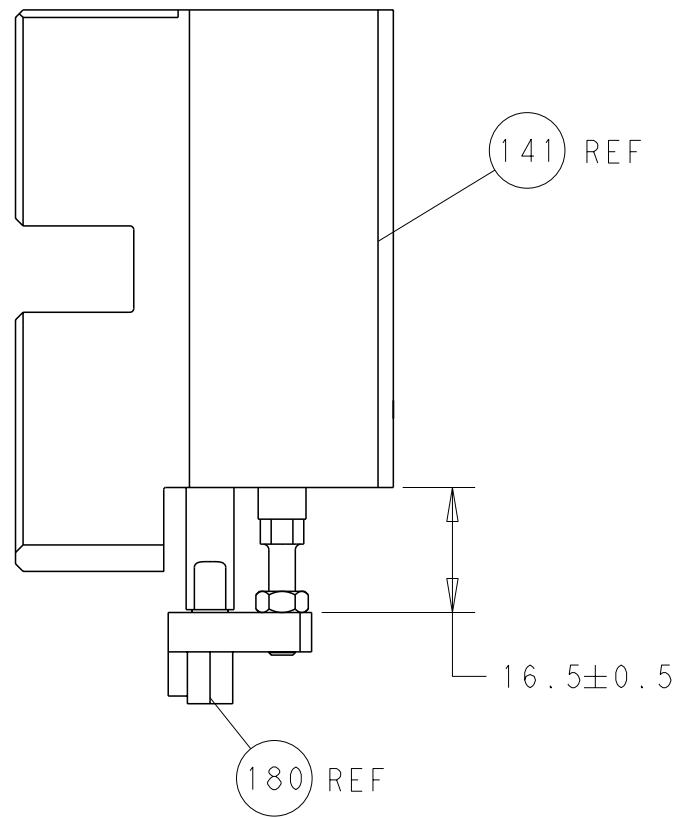
2		1				
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
P	LTR	DESCRIPTION		DATE	DNW	APVD
	-	SEE SHEET 1		-	-	-

	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
	-	-	-	1	2063440-1	AIR FEED MODULE	238	
	-	-	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	
6	-	1	1	1	1	1-1752354-2	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
8	-	-	-	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	16
7	-	-	-	1	-	240638-1	SPRING, FEED FINGER	16
	-	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	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
7	-	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
2	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	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 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	1901681-1	HOLDDOWN, TERMINAL	65
	-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6	-	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
	-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	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	1-2119644-3	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	690455-1	STRIPPER, FRONT CASTING	27
	-	2	2	2	2	1320906-1	STUD, THREADED	25
	-	1	1	1	1	1752371-3	PLATE, STRIP GUIDE	24
	-	1	1	1	1	240825-8	PLATE, STRIP HOLD DOWN	23
	-	2	2	2	2	22281-8	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	2-240641-1	SPACER	16
1	-	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	1	690482-3	PLATE, FRONT SHEAR	9
	1	1	1	1	1	1803059-7	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	240641-3	SPACER	5
1	-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
	1	1	1	1	1	3-1633961-6	CRIMPER, INSULATION F PREMIUM	3
1	-	1	1	1	1	1-455888-8	SPACER, CRIMPER	2
	1	1	1	1	1	456414-5	CRIMPER, WIRE	1
	-77-27-25-22-21	PART NO				DESCRIPTION		ITEM NO

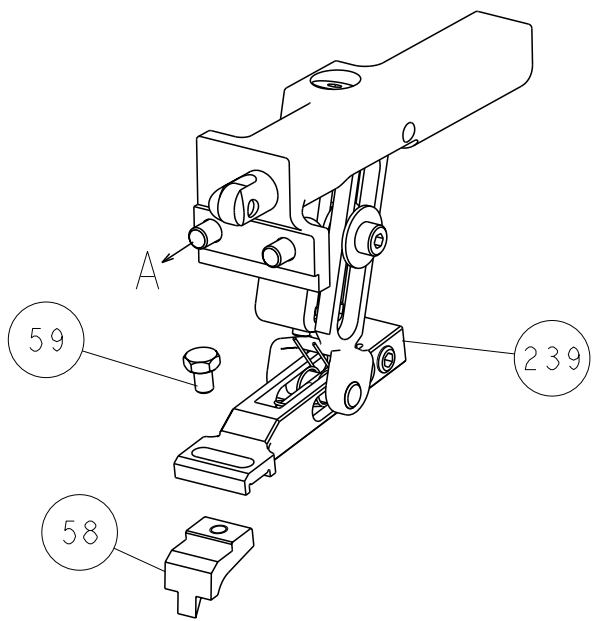
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DIMENSIONS: mm		CHK L. ZHANG 16DEC2013			

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

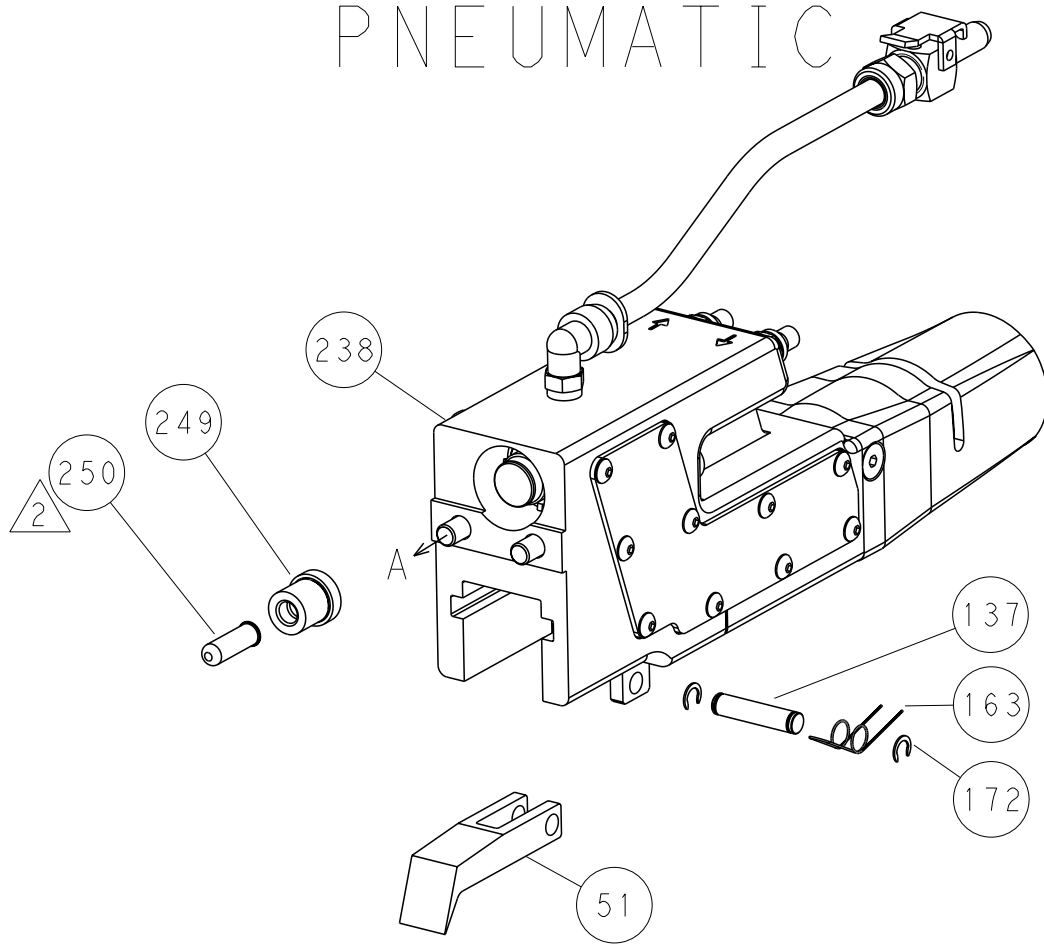
HOLDDOWN SET-UP



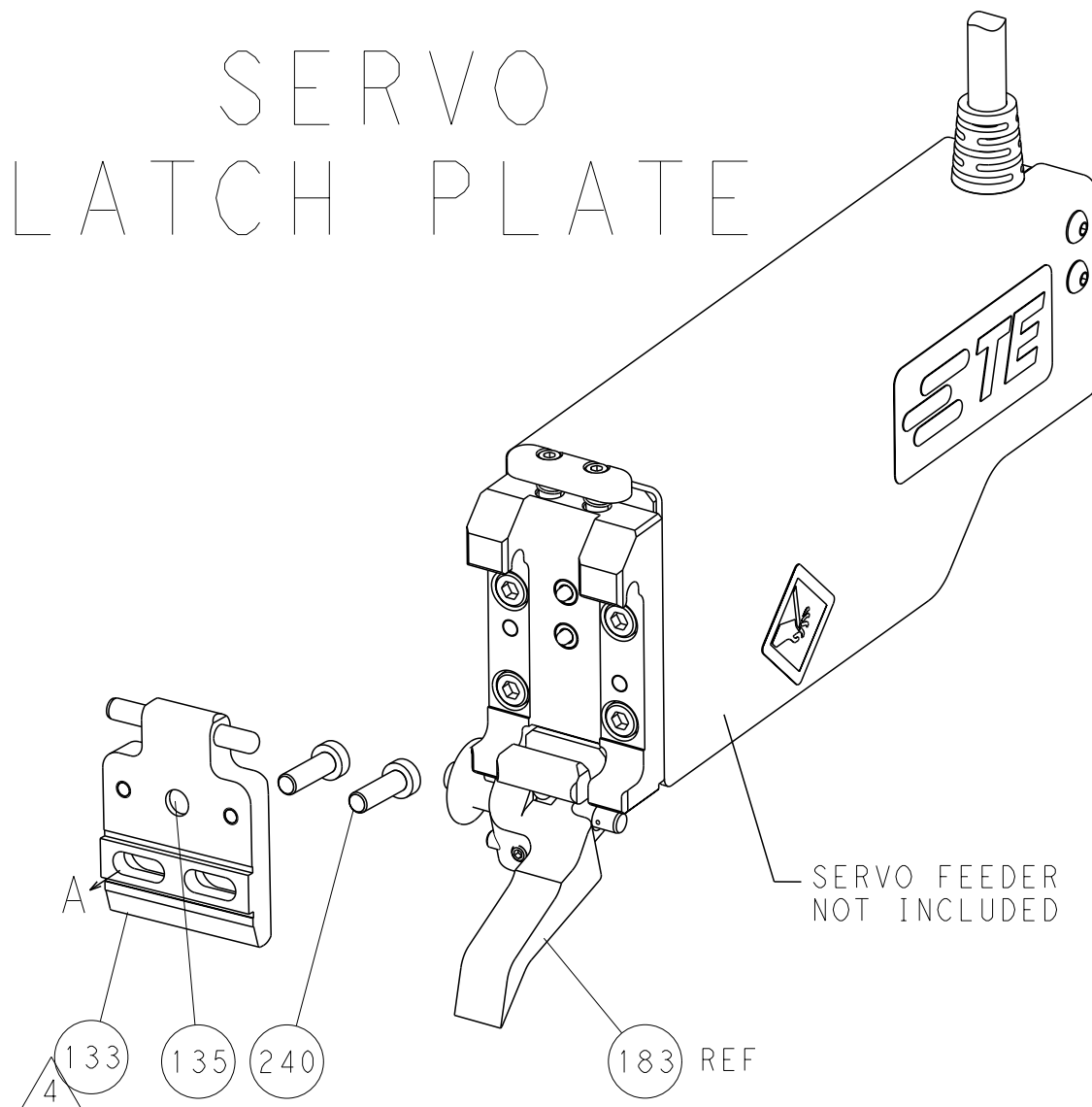
FEED TYPE
MECHANICAL



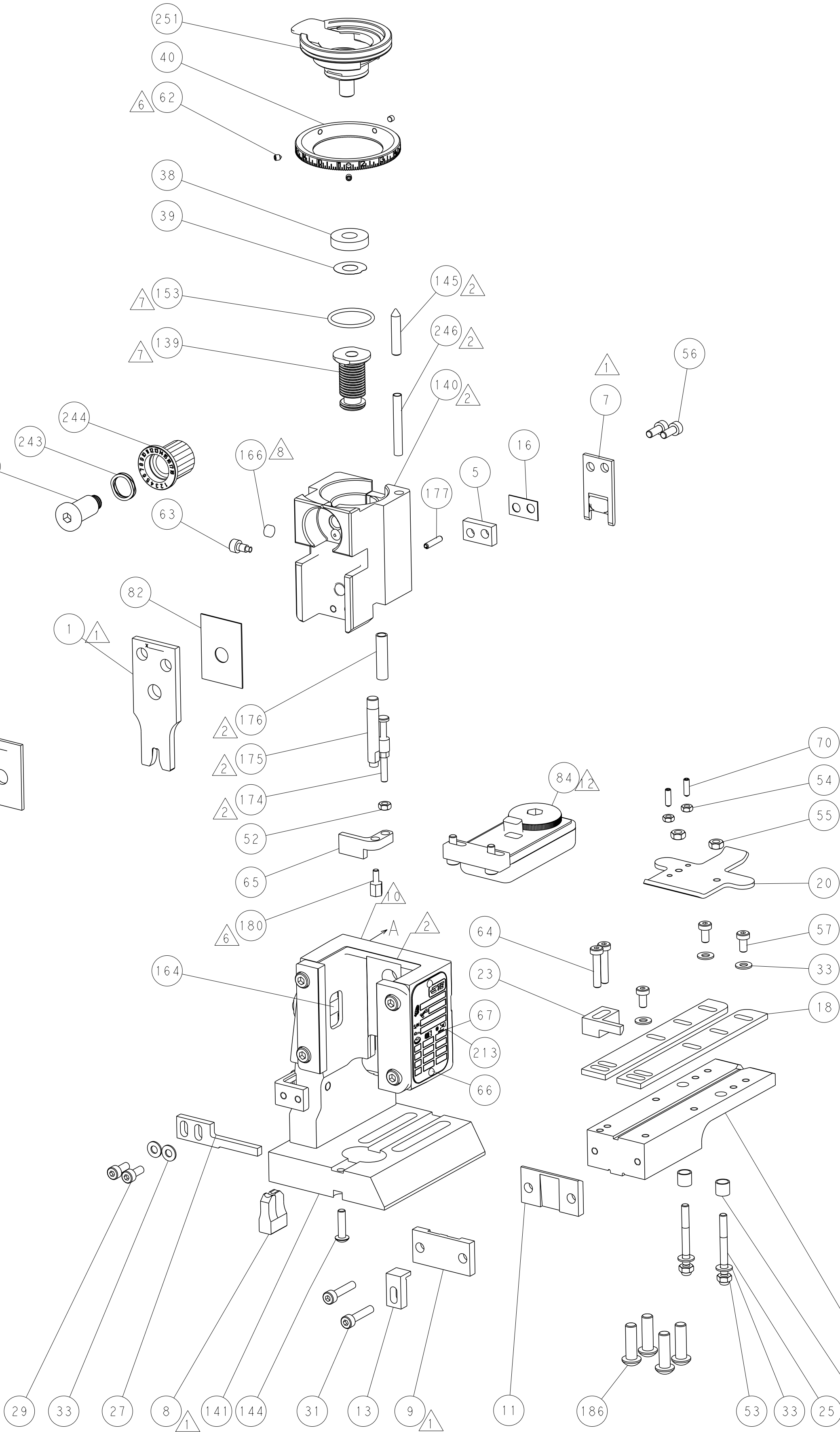
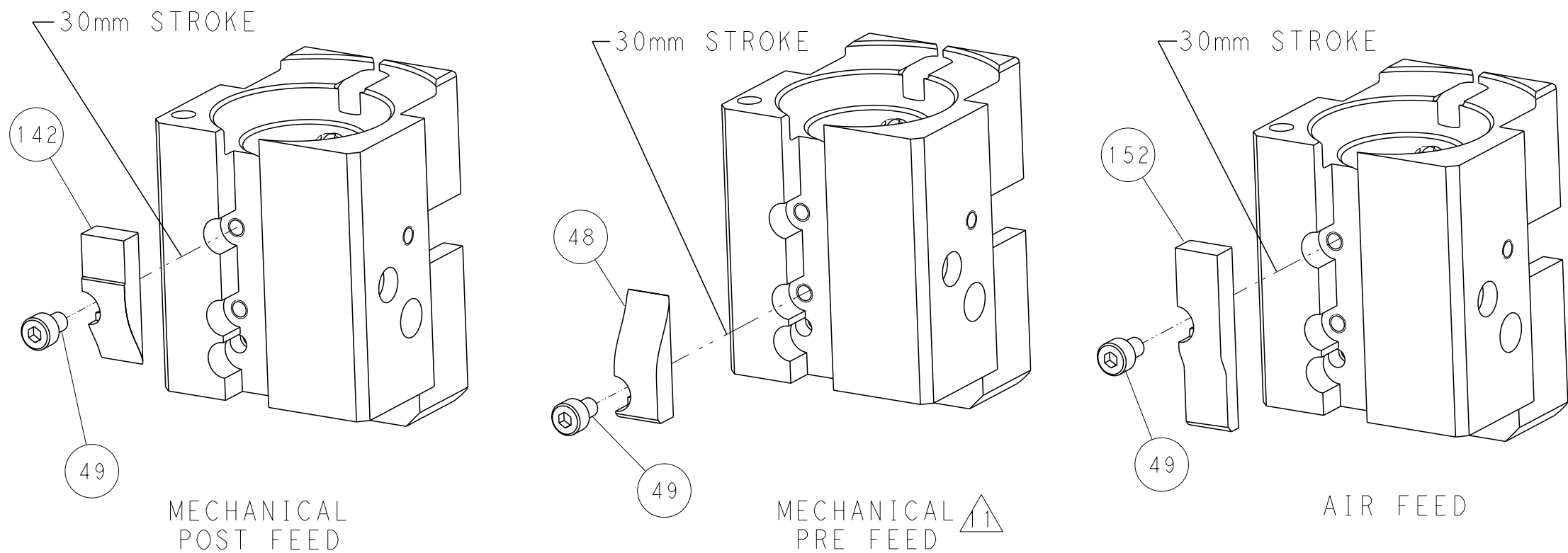
PNEUMATIC



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:		DWN K. HUANG 16DEC2013		STE TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		CHK L. ZHANG 16DEC2013		NAME Ocean End Feed Applicator	
MATERIAL		FINISH		APVD J. GUO 16DEC2013		SIZE A1	
				PRODUCT SPEC		CAGE CODE 00779	
				APPLICATION SPEC		DRAWING NO C=2150402	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:1	
						SHEET 4	
						OF 4	
						REV B	