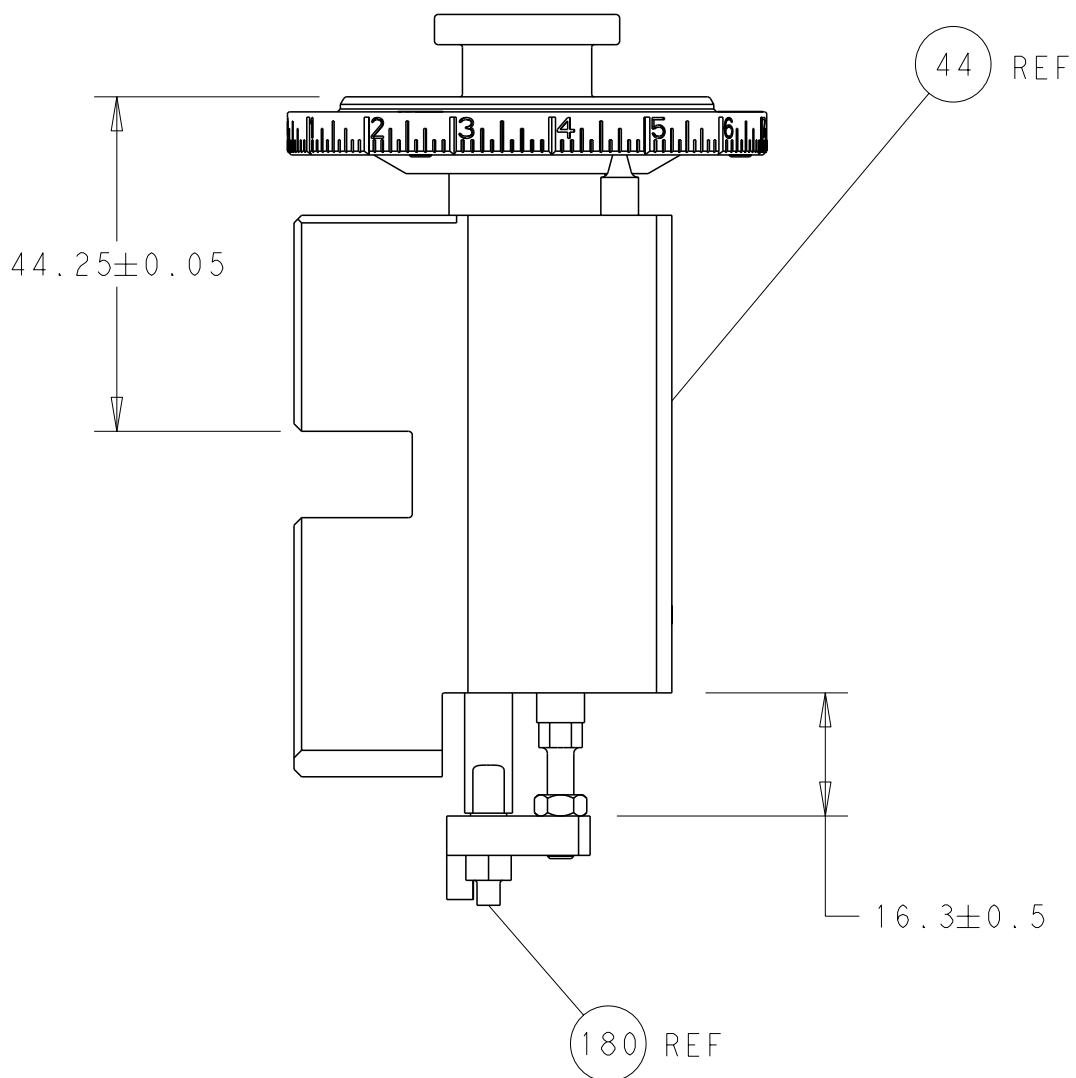
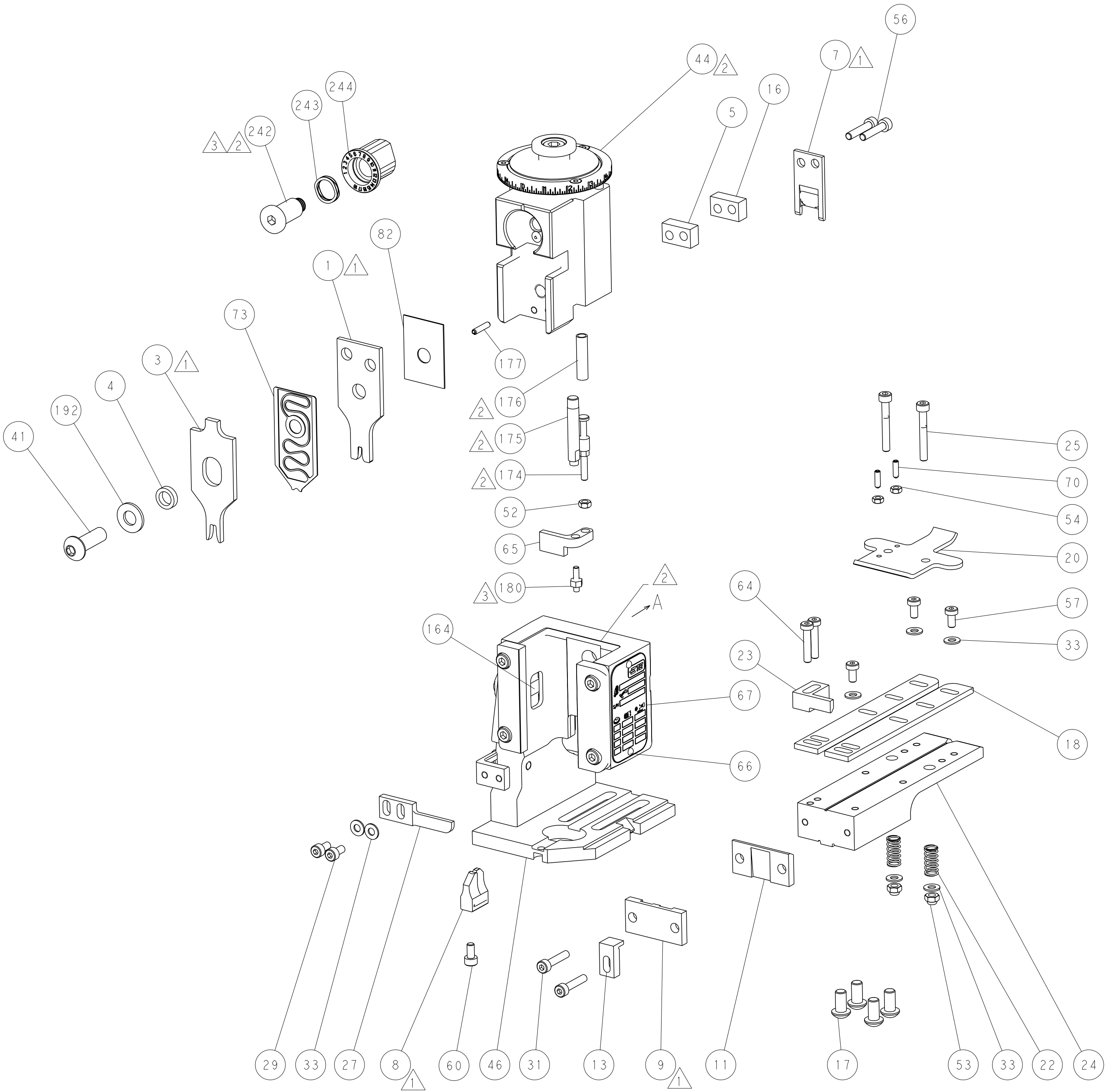


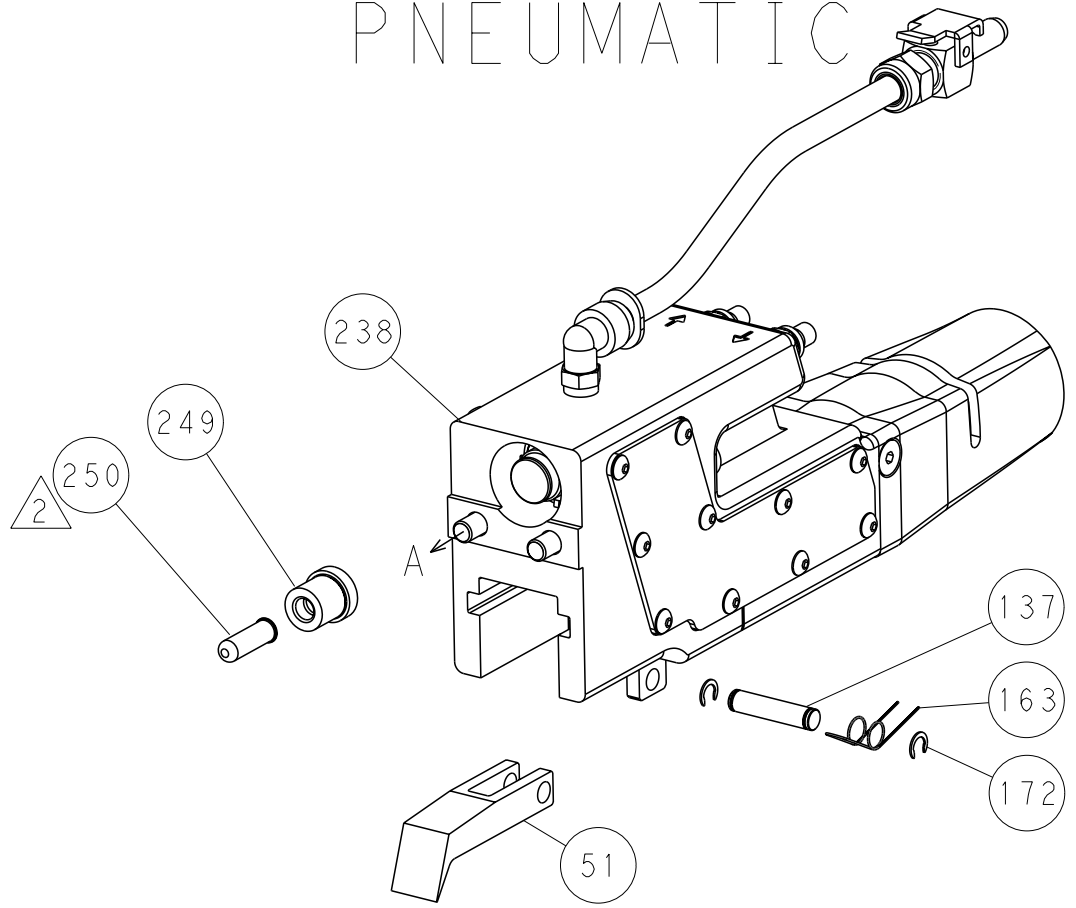
LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



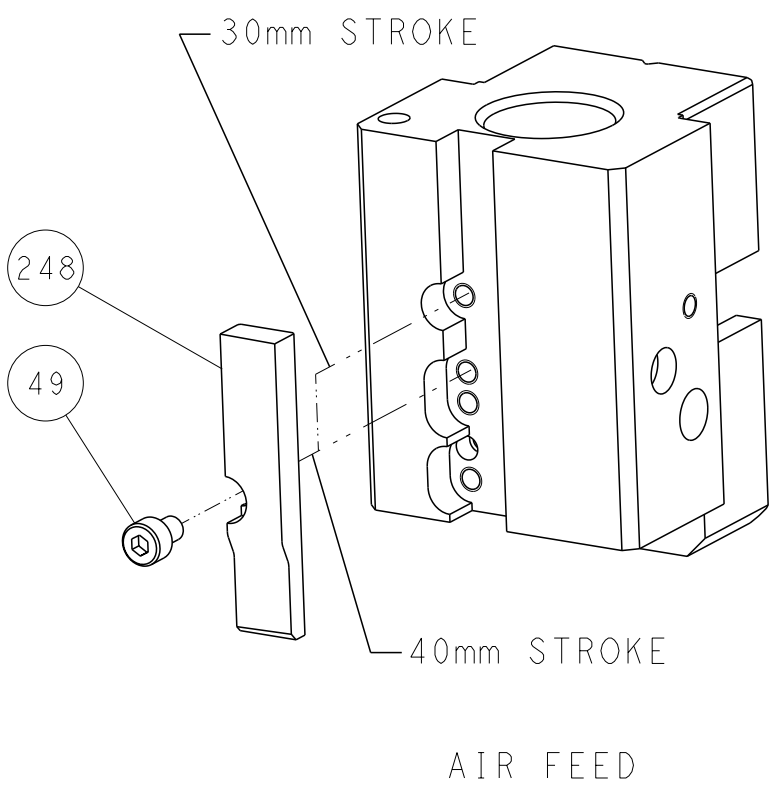
RAM AND HOLDDOWN SET-UP



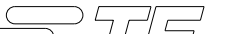
FEED TYPE
PNEUMATIC



CAM POSITION

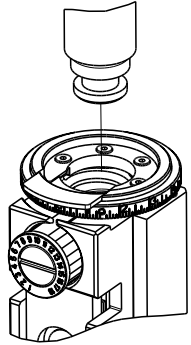


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TFC ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.			DWN L. GROSS 04OCT2013	 TE Connectivity Harrisburg, PA 17105-3608
			CHK G. BAILEY 04OCT2013	
DIMENSIONS:			APVD M. CLIFFORD 04OCT2013	
mm			NAME	
	TOLERANCES UNLESS OTHERWISE SPECIFIED:			Ocean End Feed Applicator -
	0 PLC	±		
	1 PLC	±		
	2 PLC	±		
	3 PLC	±		PRODUCT SPEC
	4 PLC	±		
	ANGLES			APPLICATION SPEC
	FINISH	-		WEIGHT
MATERIAL	-	-		SIZE CAGE CODE DRAWING NO RESTRICTED TO
			A 00779 C=2150377	-
CUSTOMER DRAWING				SCALE 1:1 SHEET 2 OF 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150377-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150377-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.06 mm [.160]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION
TERMINAL NAME: TAB MIC MK II				
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE	
3.50-4.50 mm [.138-.177 IN]			Ø2.16-3.43 mm [.085-.135 IN]	
TERMINAL APPLICATION SPECIFICATION		114-5072	-	-
		-	-	-
TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	
172777-1	172777-2	172777-3	172777-4	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2		1.78+/-0.05 [.070+/- .002]		4.4
16 AWG OR 1.25mm2		1.50+/-0.05 [.059+/- .002]		7.3
0.5+0.85mm2 OR 20+18 AWG		1.50+/-0.05 [.059+/- .002]		7.4
0.5+0.5mm2 OR 20+20 AWG		1.50+/-0.05 [.059+/- .002]		7.2
18 AWG OR 0.85mm2		1.34+/-0.05 [.053+/- .002]		9.2
20 AWG OR 0.50mm2		1.30+/-0.05 [.051+/- .002]		9.4



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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 WITH MECHANICAL FEED.

6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.

*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

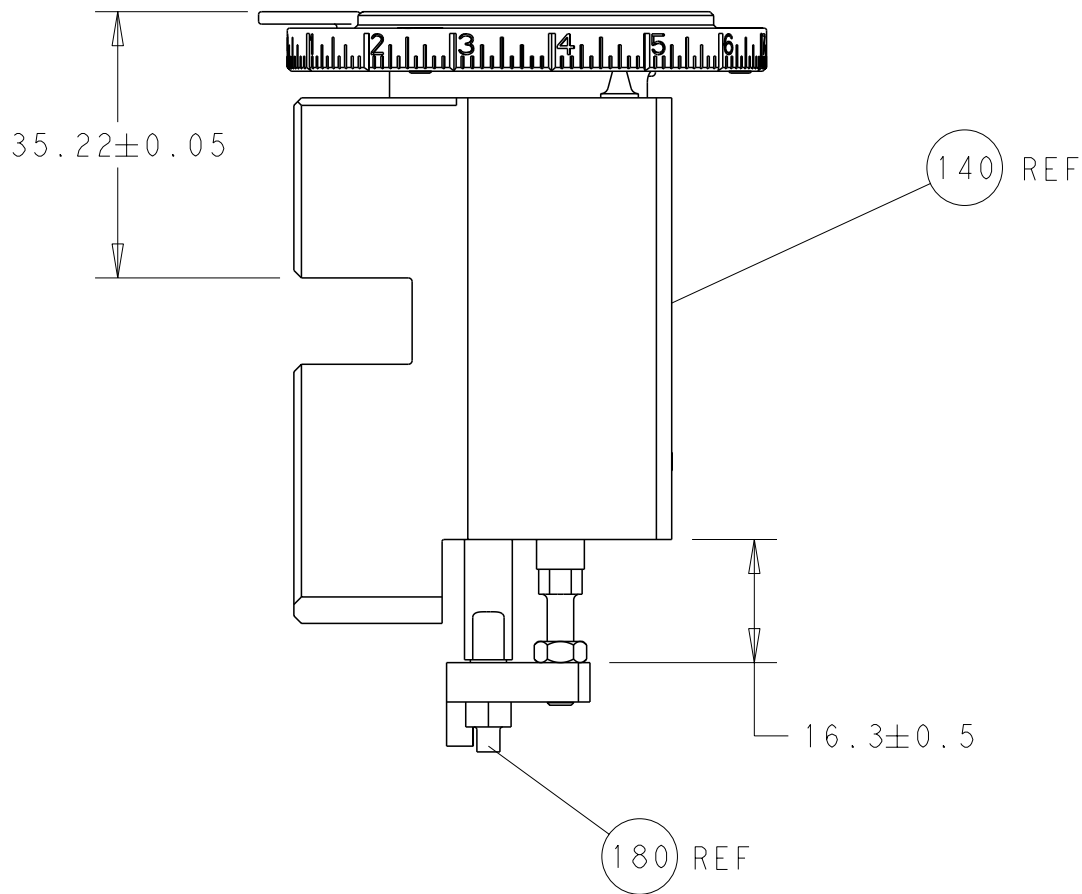
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	OWN	APVD
A	66		-	SEE SHEET 1	-	-	-

3	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1803259-1	BUSHING, FLANGED	249
	-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2063440-2	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
3	-	1	1-1976055-1	STANDOFF, HOLD-DOWN	180
	-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1752353-2	GUIDE PIN,HOLDDOWN	175
3	-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	240638-1	SPRING, FEED FINGER	163
3	-	1	2119641-2	FEED CAM, AIR FEED	152
	-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
3	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	455888-5	SPACER, CRIMPER	82
	-	1	2119791-9	DEPRESSOR, WIRE	73
	-	1	1803607-2	DOCUMENTATION PACKAGE	71
3	-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
	-	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1901681-1	HOLDDOWN, TERMINAL	65
3	-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
	-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
3	-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	2119792-2	PAWL, EF, AIR	51
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
3	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	7	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
3	-	1	240639-1	STRIPPER (MACHINING)	27
	-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1752371-8	PLATE, STRIP GUIDE	24
	-	1	240825-6	PLATE, STRIP HOLD DOWN	23
3	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	2	1901259-6	GUIDE, LOWER STRIP	18
	-	1	6-240641-8	SPACER	16
3	-	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	240833-1	PLATE, REAR SHEAR	11
	-	-	-	-	10
	-	1	690482-5	PLATE, FRONT SHEAR	9
3	1	1	1-1333217-3	ANVIL, EF .090	8
	-	1	2217206-7	BLADE, SLUG	7
	-	-	-	-	6
	-	1	6-240641-8	SPACER	5
3	-	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	7-1633961-6	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	2
	1	1	4-456406-7	CRIMPER, WIRE PREMIUM	1
3	-	77-22	PART NO	DESCRIPTION	ITEM NO

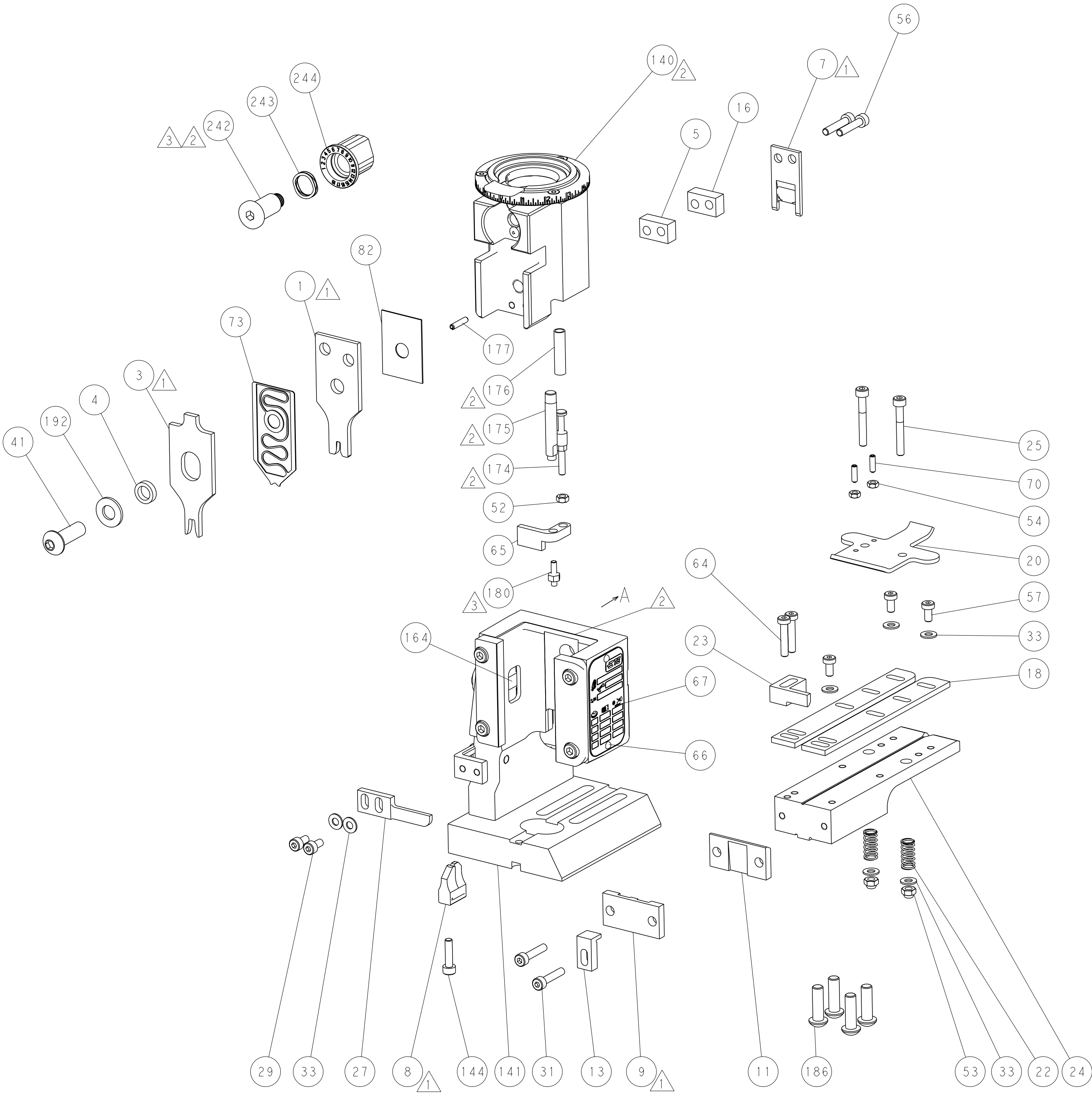


THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRICAL CONNECTIONS IT IS SUBJECT TO CHANGE AND TO BE KEPT UNDER THE ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION				OWN L. GROSS	04OCT2013	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK G. BAILEY	04OCT2013				
				APVD M. CLIFFORD	04OCT2013	NAME			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:		Ocean End Feed Applicator			
mm									
				0 PLC ±		PRODUCT SPEC			
				1 PLC ±					
				2 PLC ±		APPLICATION SPEC			
				3 PLC ±					
				4 PLC ±		SIZE			
				ANGLES	±				
MATERIAL				FINISH		DRAWING NO			
						SCALE			
						OF			
						C			

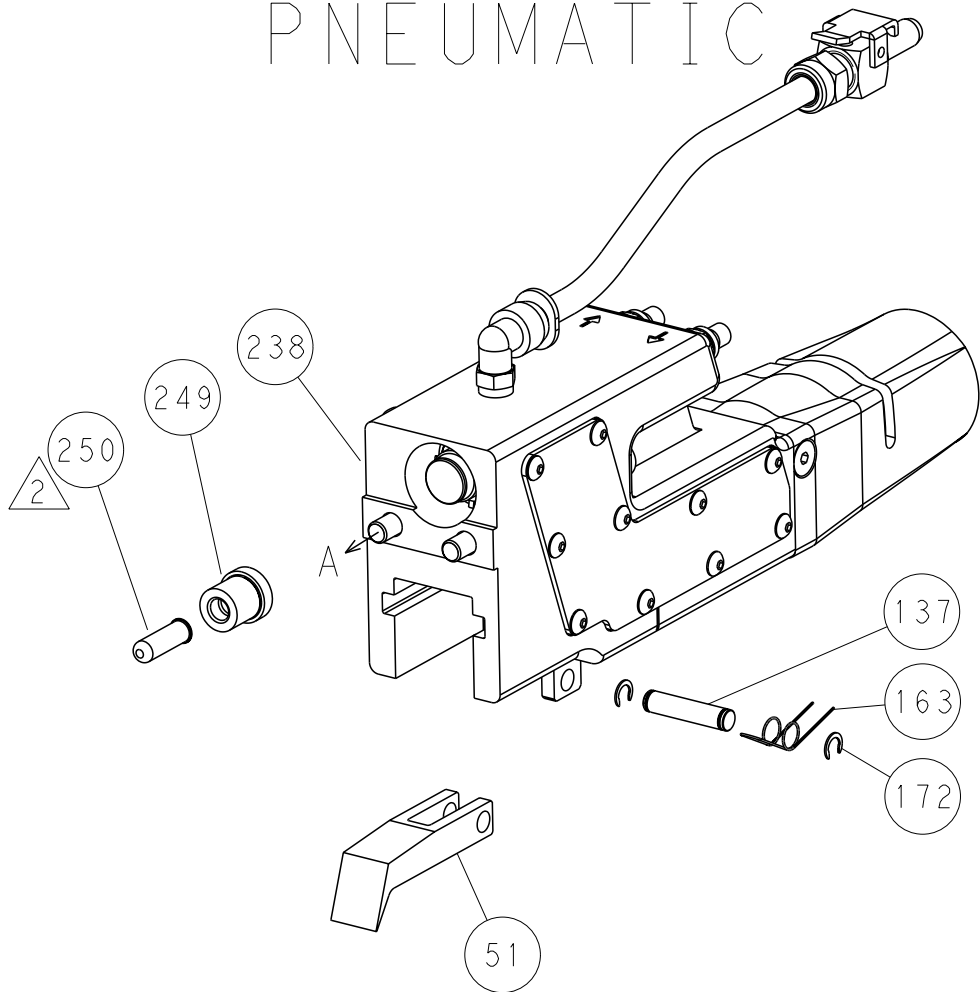
LOC	DIST	REVISIONS				
		P	LYR	DESCRIPTION	DATE	APVD
A	66	-	-	SEE SHEET 1	-	-



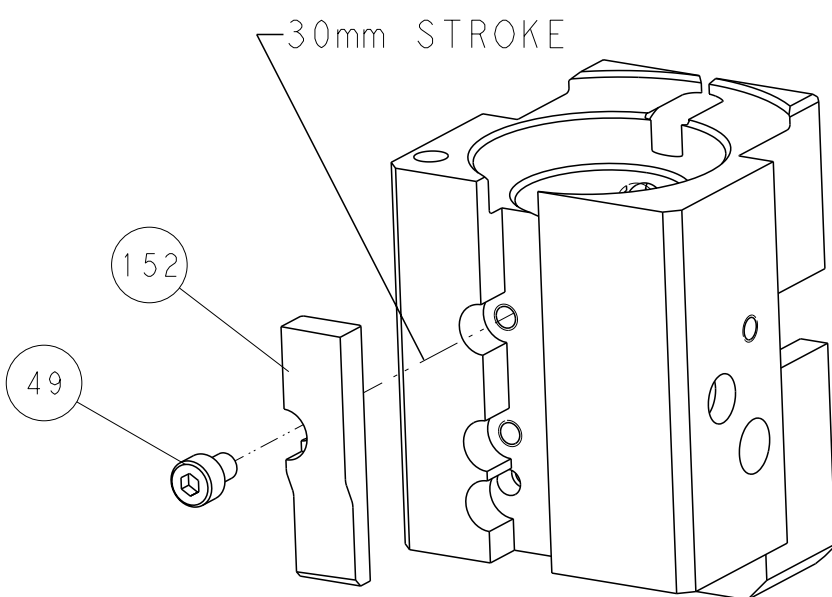
RAM AND HOLDDOWN SET-UP



FEED TYPE
PNEUMATIC



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN L. GROSS	04OCT2013	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm		CHK G. BAILEY	04OCT2013			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		APVD M. CLIFFORD	04OCT2013	NAME Ocean End Feed Applicator		
MATERIAL -		PRODUCT SPEC		SIZE A1		RESTRICTED TO -
		APPLICATION SPEC		CAGE CODE 00779		REV C
		WEIGHT -		DRAWING NO C=2150377		
		CUSTOMER DRAWING		SCALE 1:1		SHEET 4 OF 4