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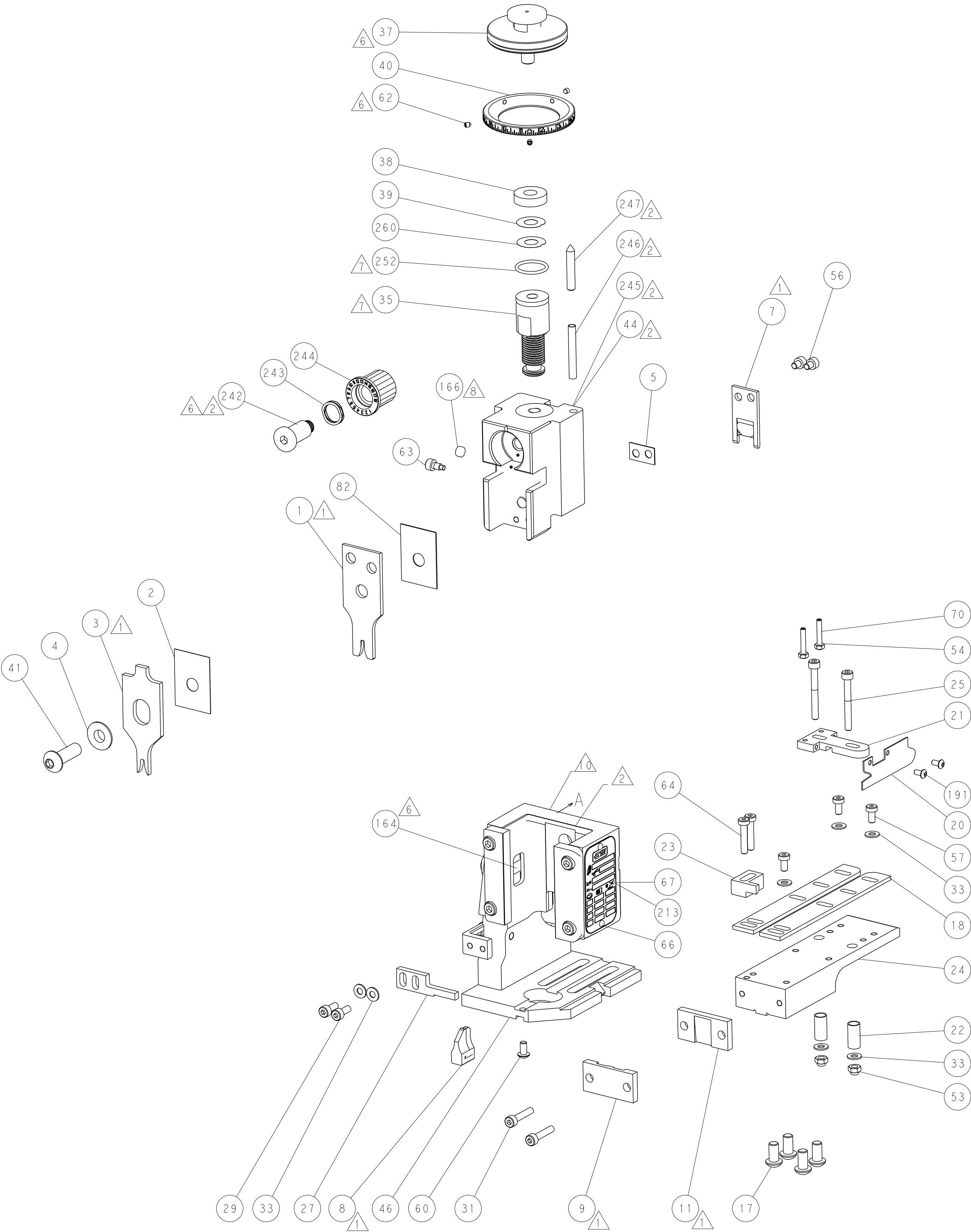
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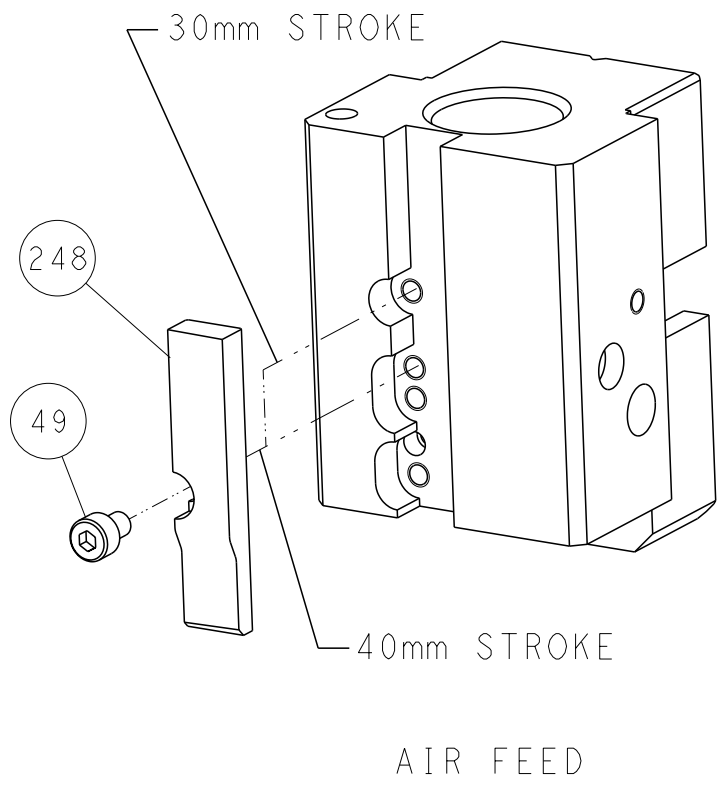
Address: A1208, Overseas Decoration Building, #122 Zhenhua RD., Futian, Shenzhen, China



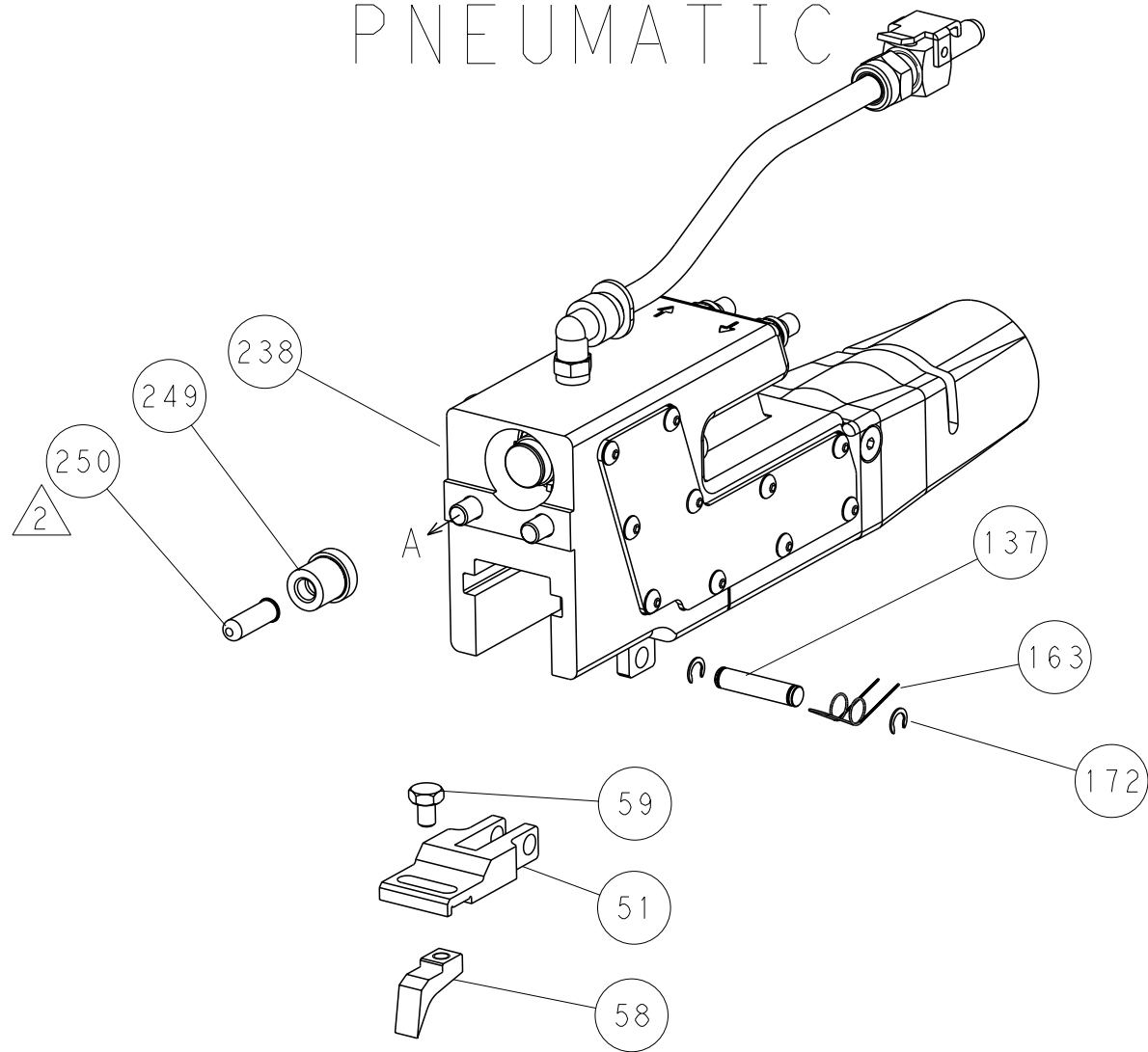
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
				-		SEE SHEET 1	-	-	-



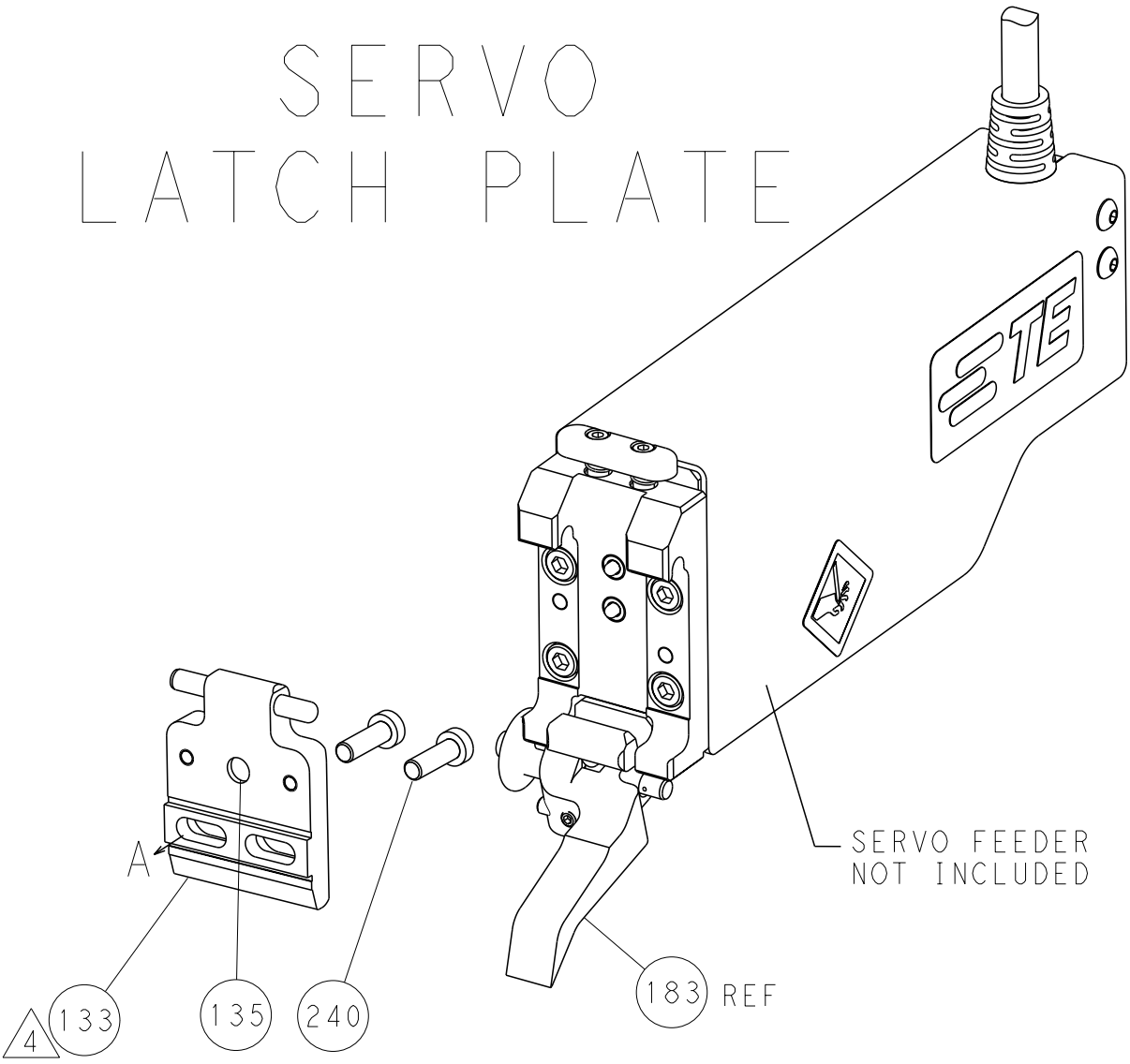
CAM POSITION



FEED TYPE PNEUMATIC

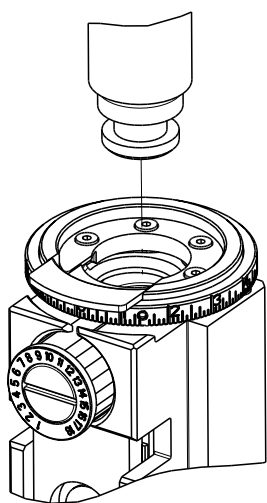


SERVO LATCH PLATE



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. STAKEM 08SEPT2014		STE TE Connectivity	
mm		0 PLC ±.5		CHK G. BAILEY 08SEPT2014		Harrisburg, PA 17105-3608	
1 PLC ±0.13		APVD T. ELBIN 08SEPT2014		NAME		Ocean End Feed Applicator	
2 PLC ±0.13		PRODUCT SPEC		SIZE		CAGE CODE DRAWING NO	
3 PLC ±0.013		APPLICATION SPEC		A1 00779		C=2150479	
4 PLC ±0.0001		WEIGHT		Customer Accessible Production Drawing		SCALE 1:1	
ANGLES FINISH		SHEET 2 of 4		REV A		RESTRICTED TO	
MATERIAL		Customer Accessible Production Drawing		SCALE 1:1		SHEET 2 of 4	

8				6		5		4		3		
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	PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
						-	-	-	-	-	-	-
		2-2150479-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150479-5	-	-	2168400-7 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2150479-4	-	-	-
		2-2150479-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	-	-	-	-	-	-	-
						PNEUMATIC FEED	2119950-1	1-2119792-0	-	2119641-2	-	2063440-1
		2-2150479-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
		7-2150479-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.28 mm [.090]	F
INSUL	3.05 mm [.120]	O
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: FLACHSTECKER TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 3.00-3.70 mm [.118-.146 IN]			INSULATION DIAMETER RANGE Ø 2.20-3.00 mm [.087-.118 IN]
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	FLACHSTECKER TERMINAL	TE TERMINAL	FLACHSTECKER TERMINAL
2113575-1	52855126001		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
20 AWG		1.32+/-0.05 [.052+/-0.002]		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: 8-2150479-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150479-5
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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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 WITH MECHANICAL FEED.
- 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.

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

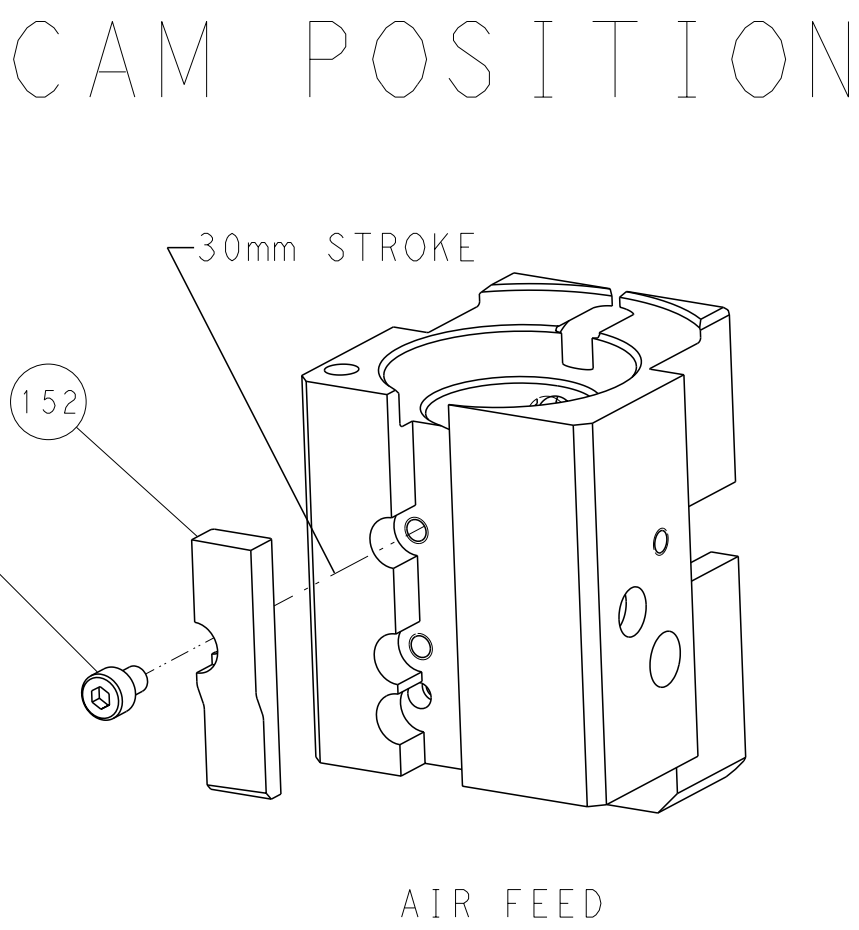
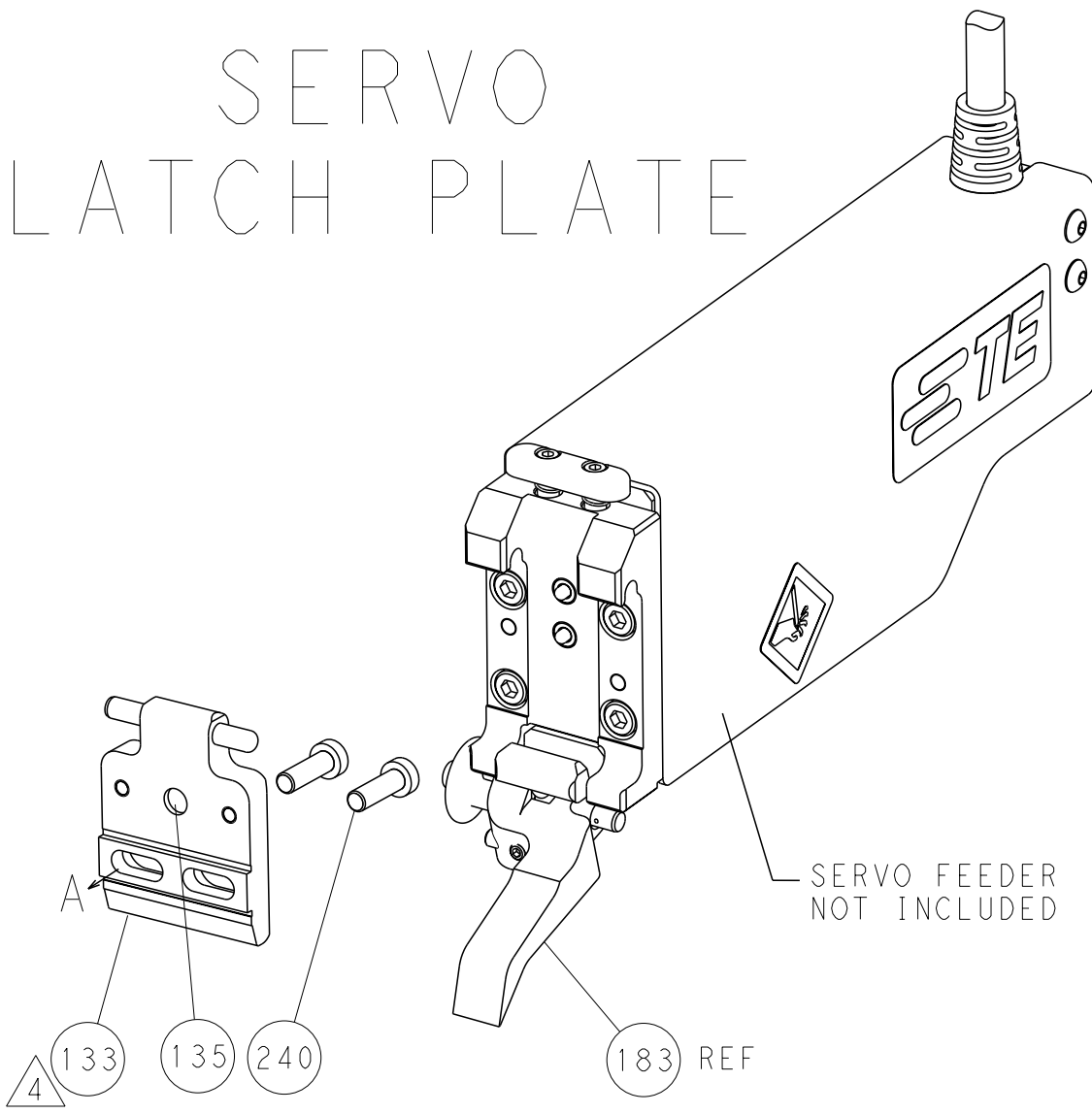
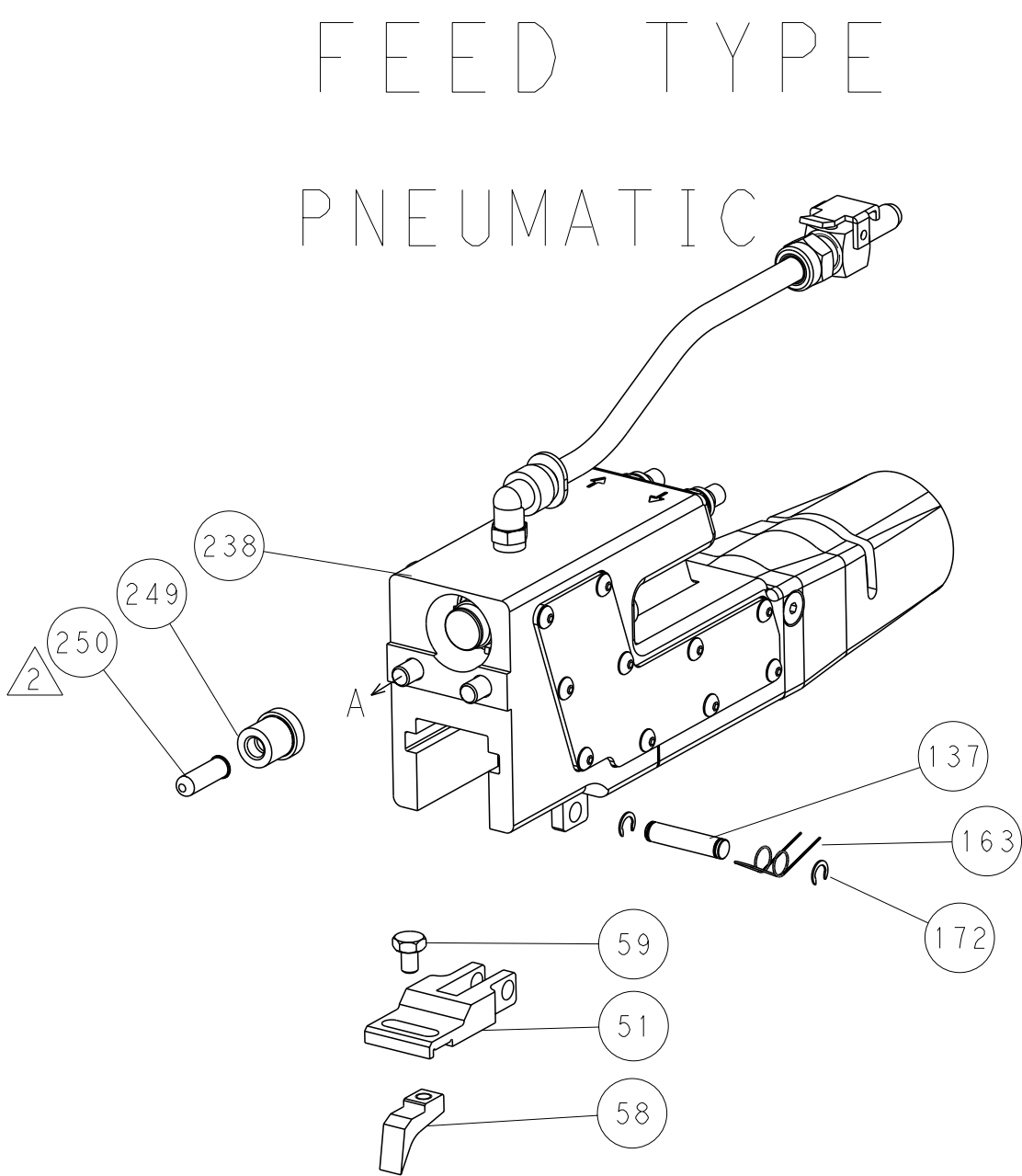
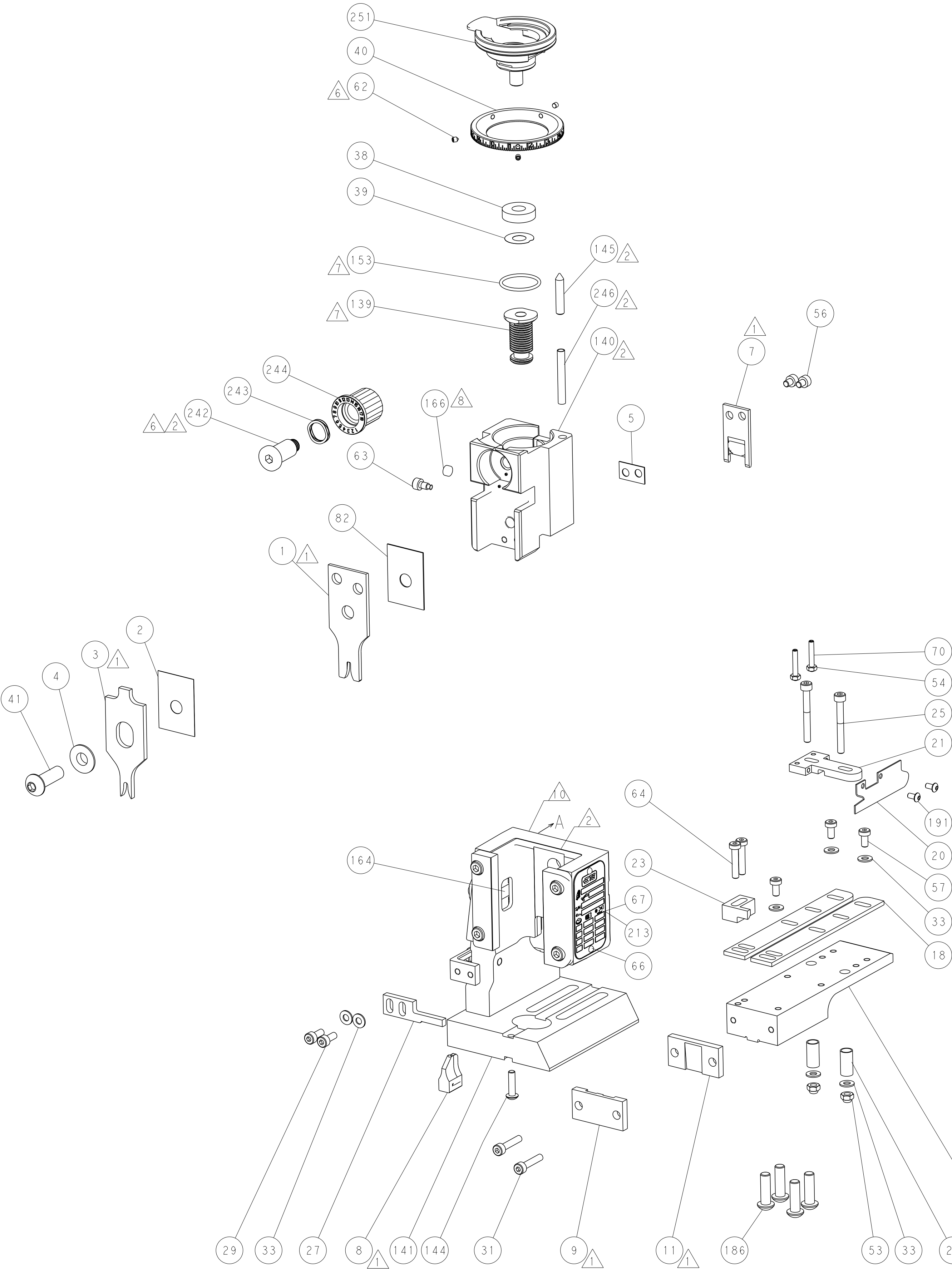
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
P	LYR	DESCRIPTION		DATE	OWN	APVD
	-	SEE SHEET 1		-	-	-

-	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG,IDENTIFICATION	213
-	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	191
-	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	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	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	2119798-2	DETENT PIN	145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	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	2063961-2	FEED FINGER	58
-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	56
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	1	2119799-1	HOLDER,FEED FINGER, AF	51
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1-690455-2	STRIPPER, FRONT CASTING	27
-	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	1	2-240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2	22281-9	SPRING, COMPRESSION	22
-	1	1	1	1-1633168-1	ARM, STOCK DRAG	21
-	1	1	1	2280330-1	DRAG, SKATE	20
-	2	2	2	1901259-5	GUIDE, LOWER STRIP	18
	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
	1	1	1	6-690482-3	PLATE, FRONT SHEAR	9
	1	1	1	1-1803060-5	ANVIL, COMBINATION, END FEED	8
	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	2-240641-1	SPACER	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
	1	1	1	5-1633965-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	455888-1	SPACER, CRIMPER	2
	1	1	1	2-456406-9	CRIMPER, WIRE PREMIUM	1
-	77	27	25	22	PART NO	ITEM NO
				DESCRIPTION		

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES FINISH ±.		PRODUCT SPEC		SIZE A1	
		APPLICATION SPEC		WEIGHT		00779 ©=2150479	
MATERIAL		FINISH		Customer Accessible Production Drawing		SCALE 1:1 SHEET 3 OF 4 REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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



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		CHK G. BAILEY 08SEPT2014		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.001 ANGLES ±.5		APVD T. ELBIN 08SEPT2014	NAME Ocean End Feed Applicator	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
		APPLICATION SPEC -	CAGE CODE 00779	
		WEIGHT -	DRAWING NO C=2150479	
		FINISH -	RESTRICTED TO -	
		Customer Accessible Production Drawing	SCALE 1:1	SHEET 4
			OF 4	REV A