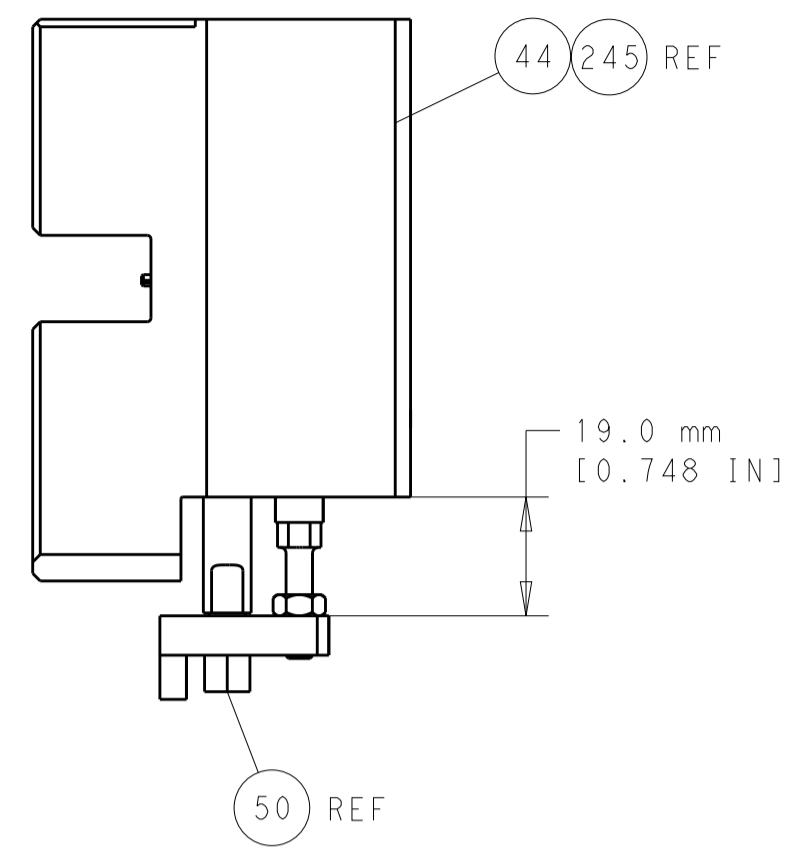
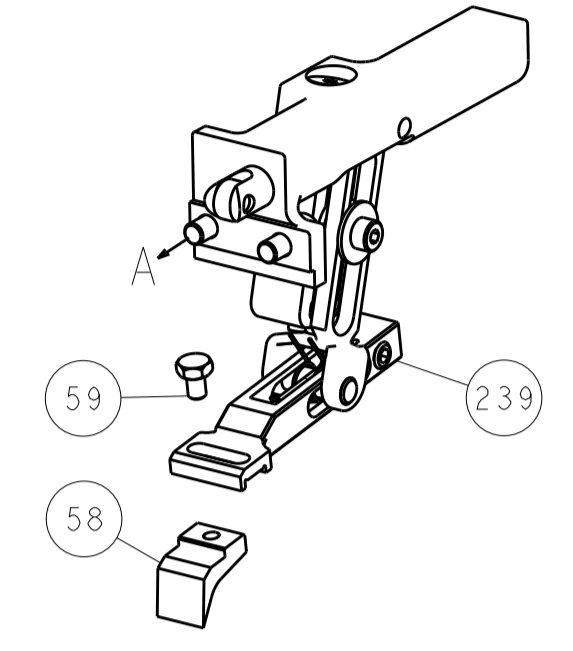


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

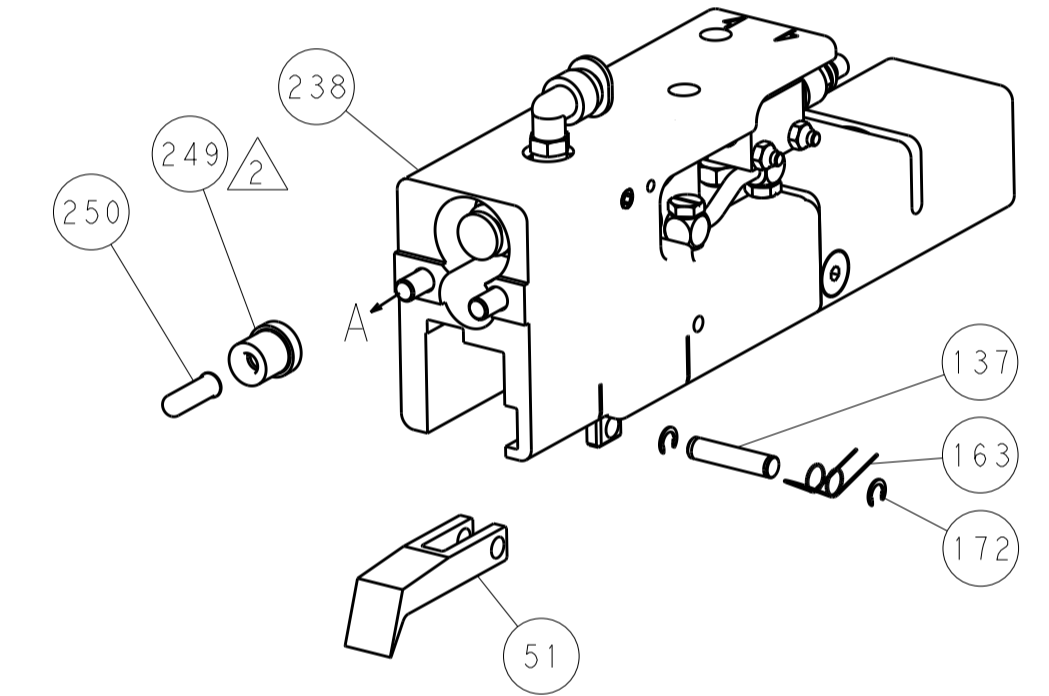


HOLDDOWN SET-UP

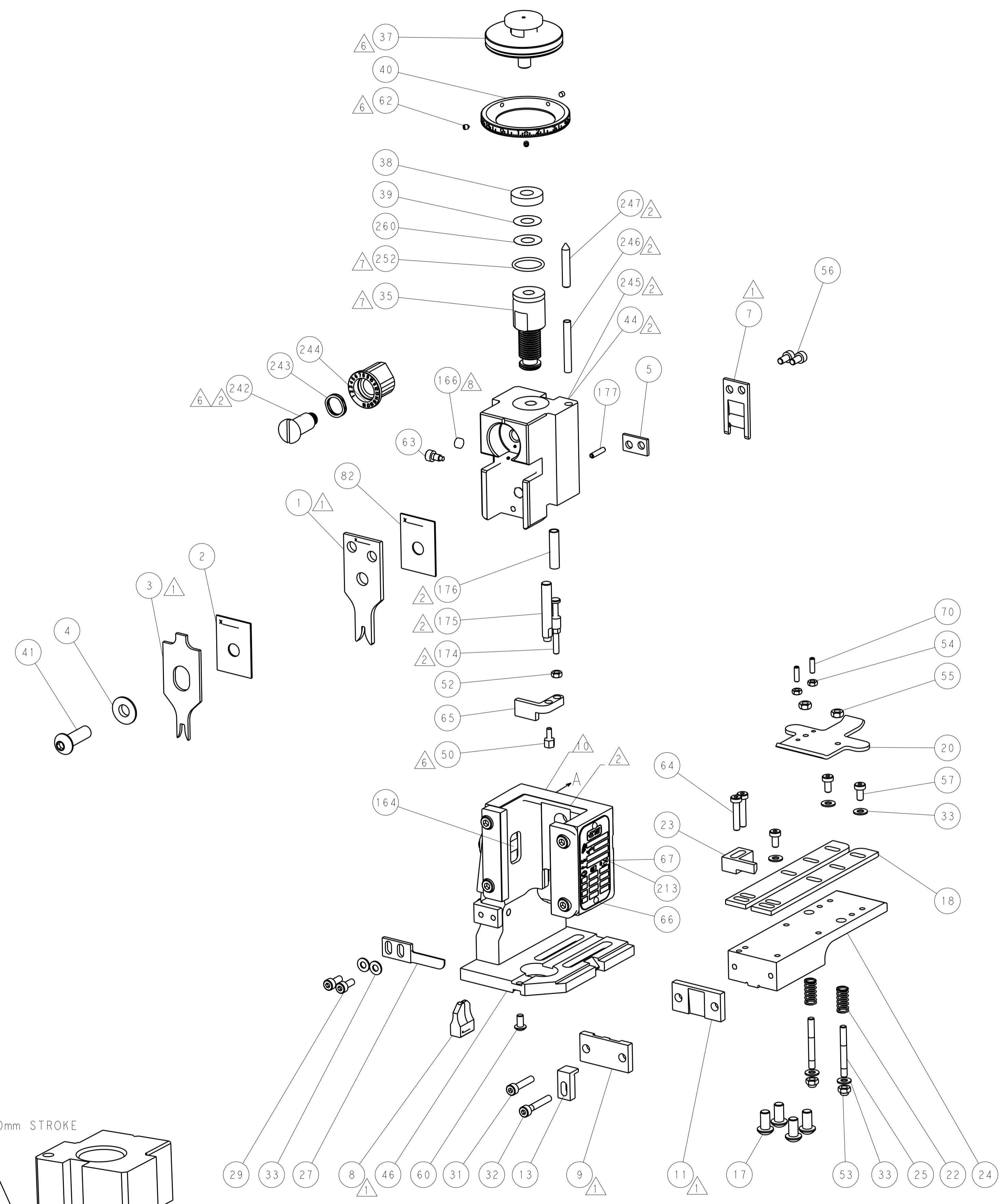
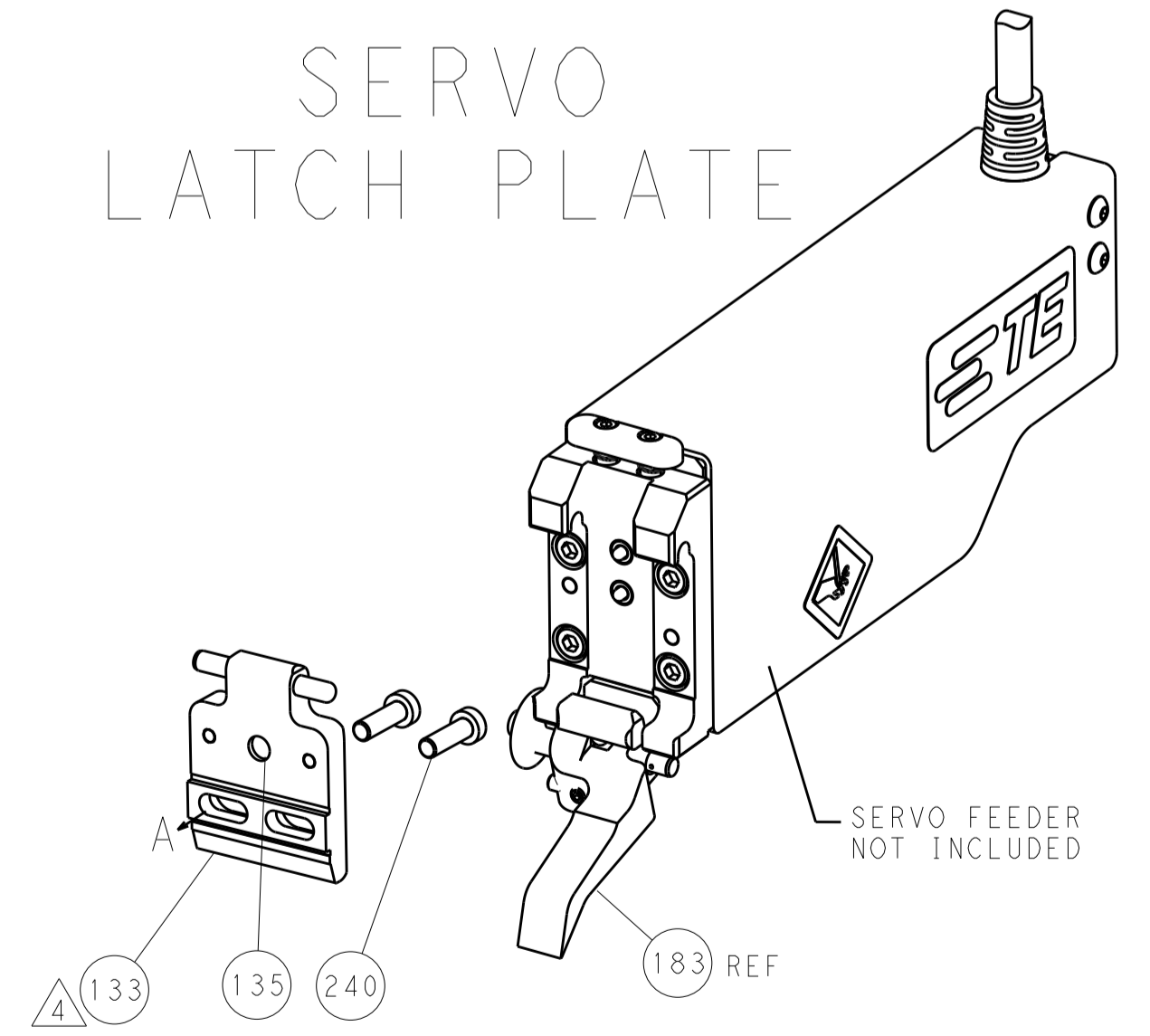
FEED TYPE
MECHANICAL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	APVD	Harrisburg, PA 17105-3608
	ANGLES ±0.0013			NAME		Ocean End Feed Applicator	
MATERIAL		FINISH		WEIGHT		RESTRICTED TO	
				A1 00779 ©=2150317		SCALE 1:1 SHEET 2 OF 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150317-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150317-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150317-4	-	-	
	2-2150317-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150317-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150317-4	-	-	
	2-2150317-5	A	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
	2-2150317-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150317-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm (.080)	F
INSUL	3.56 mm (.140)	F
APPLICATION INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: SOCKET CONTACT		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
3.62-4.83 mm (.143-.190 IN)		Ø2.40-3.00 mm (.094-.118 IN)
TERMINAL APPLICATION SPECIFICATION	114-18022	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
964112-1	964112-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.64 +/- 0.05 [.065 +/- .002]	8.5
1.00mm2	1.45 +/- 0.05 [.057 +/- .002]	10.4

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150317-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150317-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150317-5
- 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 & 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.

-	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				
-	77	-	27	-	25	-	22	21	PART NO	DESCRIPTION	ITEM NO

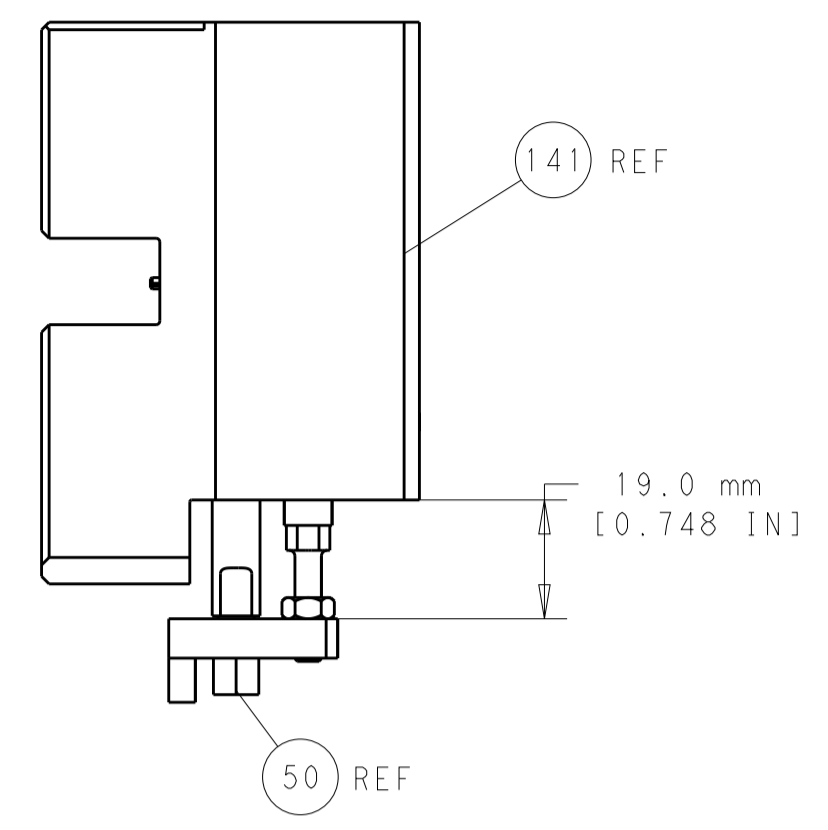
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	-	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				
-	1	1	1	1	6-9931111-6	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				
-	-	-	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	455888-7	SPACER, CRIMPER	82				
-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71				
-	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70				
-	1	-	1	1	2119740-1	TAG, IDENTIFICATION	67				
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66				
-	1	1	1	1	1-1901681-3	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				
-	3	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	2063961-1	FEED FINGER	58				
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57				
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	1	1	1752354-4	STANDOFF, HOLD-DOWN	50				
-	-	-	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	2119644-2	RAM WASHER, PRECISION	38				
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33				
-	1	1	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	32				
-	1	1	1	1	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	240639-2	STRIPPER (MACHINING)	27				
-	2	2	2	2	1320906-1	STUD, THREADED	25				
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24				
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23				
-	2	2	2	2	2-22281-3	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	1752360-1	SPACER, HOLD-DOWN	13				
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11				
-	-	-	-	-	-	-	10				
-	1	1	1	1	690482-6	PLATE, FRONT SHEAR	9				
-	1	1	1	1	9-1633383-5	ANVIL, COMBINATION	8				
-	1	1	1	1	2217206-4	BLADE, SLUG	7				
-	-	-	-	-	-	-	6				
-	1	1	1	1	1-240641-1	SPACER	5				
-	1	1	1	1	2-238009-3	BLOCK, FL CRIMPER SPACER	4				
-	1	1	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3				
-	1	1	1	1	455888-8	SPACER, CRIMPER	2				
-	1	1	1	1	5-456405-0	CRIMPER, WIRE PREMIUM	1				
-	77	-	27	-	25	-	22	21	PART NO	DESCRIPTION	ITEM NO

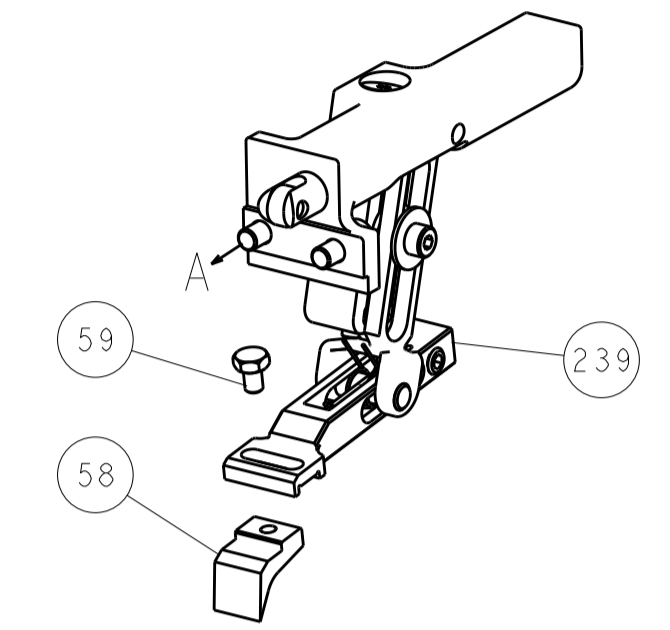
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE		REVISED	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	ANGLES ±.0001	FINISH	Y. YIN	22FEB2013
								G. BAILEY	22FEB2013
								S. XI	22FEB2013
MATERIAL:				WEIGHT:		SCALE:		SHEET 3 OF 4	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 3 OF 4		REV A	

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

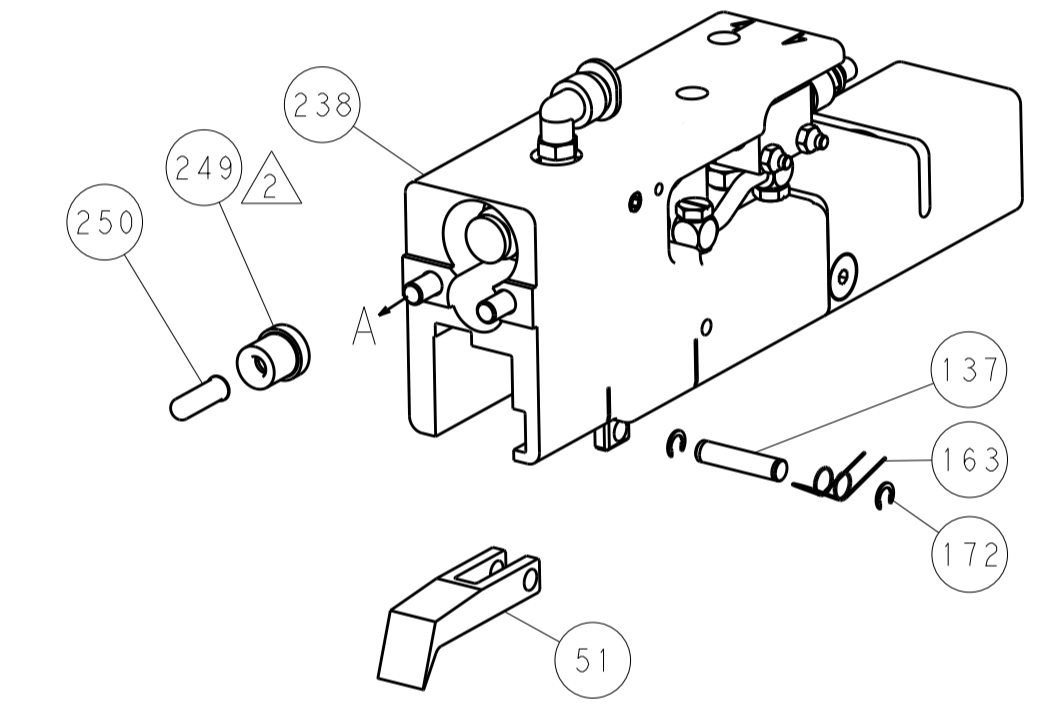


HOLDDOWN SET-UP

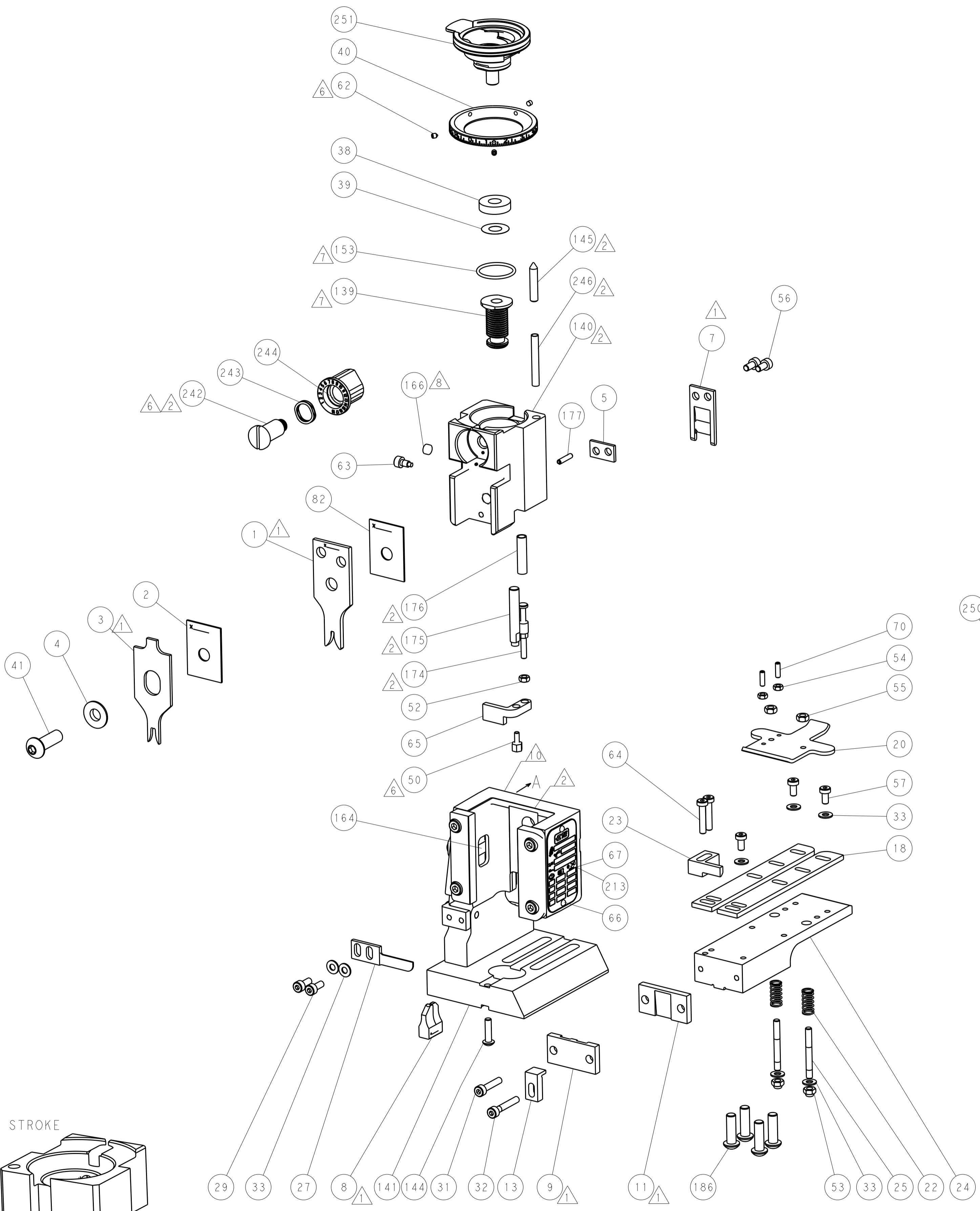
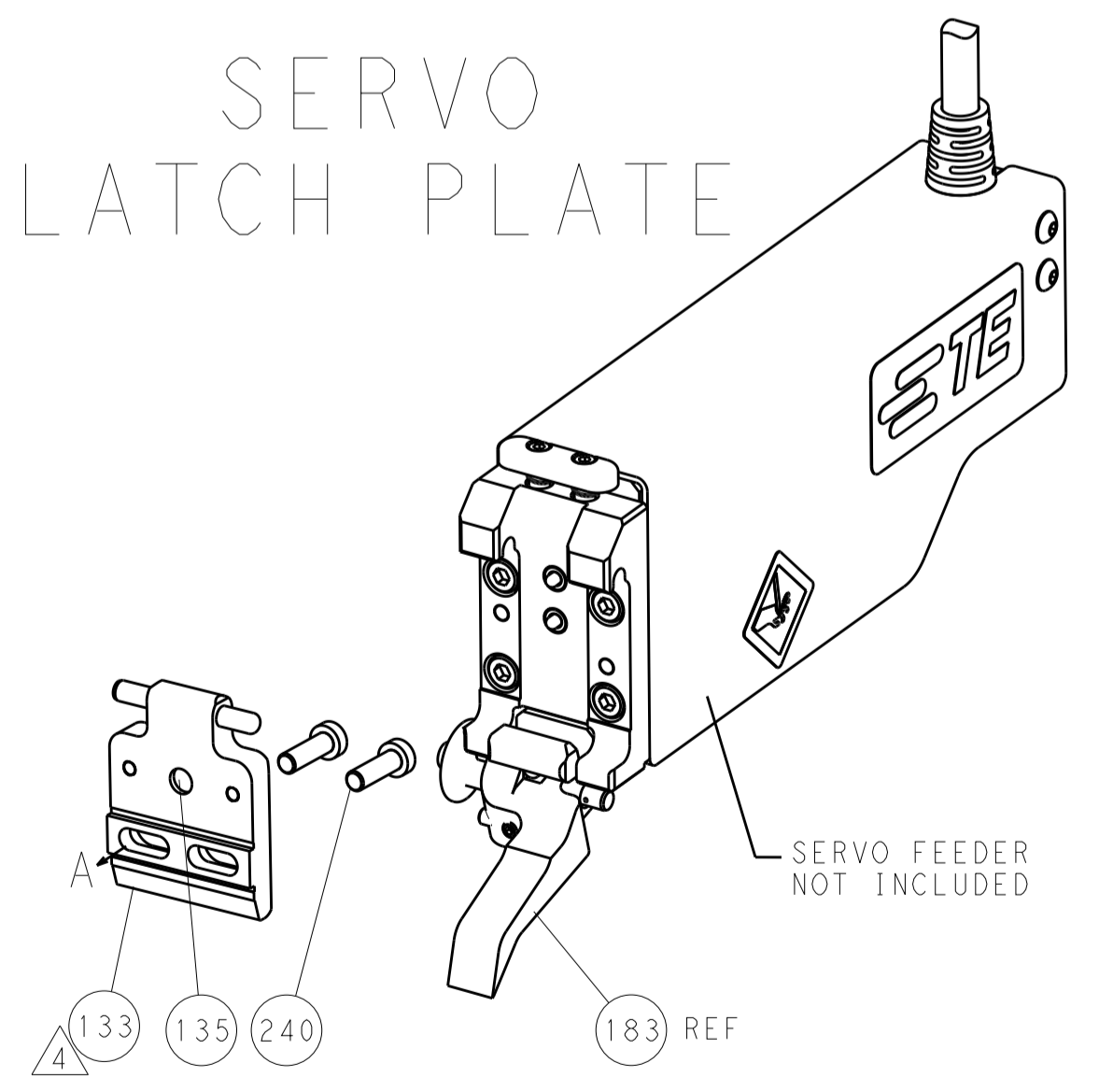
FEED TYPE
MECHANICAL



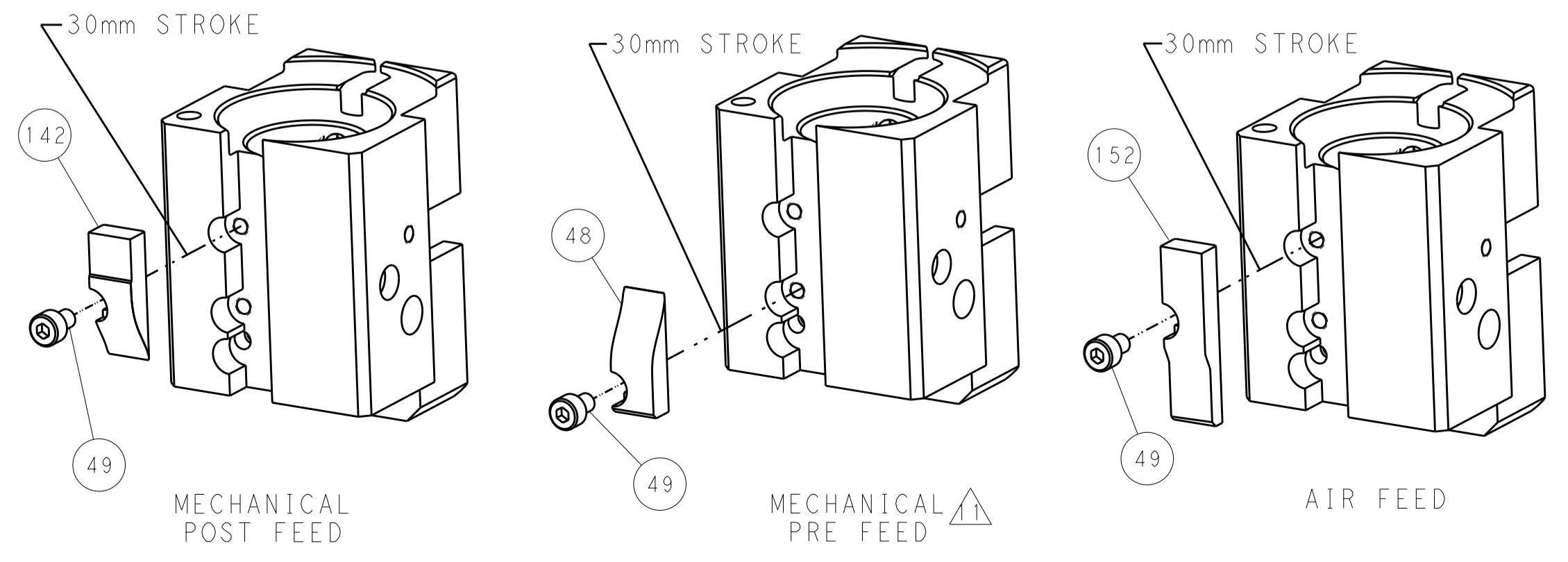
PNEUMATIC



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 Y. YIN 22FEB2013		STE TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	CHK G. BAILEY 22FEB2013	Harrisburg, PA 17105-3608	
	4 PLC ±0.013	5 PLC ±0.013	6 PLC ±0.001	APVD JJ. GUO 22FEB2013	NAME		
	ANGLES			PRODUCT SPEC			
MATERIAL	FINISH			APPLICATION SPEC			
				WEIGHT			
				A 00779 C=2150317			
Customer Accessible Production Drawing				SCALE 1:1	SHEET 4	OF 4	REV A