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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED						
	2150054-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	2063961-1	-	-	-	-	
	2150054-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	1803052-1	8-2150054-5	-	-	2168400-7 (QUANTITY 2)	
	2150054-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ¹¹	-	-	2063961-1	-	-	-	-	
	2150054-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
	7-2150054-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA	
CRIMP SIZE	TYPE
WIRE 3.05 mm [.120]	F
INSUL 5.90 mm [.232]	O
APPL INSTRUCTIONS 408-10390	

TERMINAL DATA: TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: .187 SERIES POSITIVE LOCK RECEP	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.50-5.50 mm [.177-.217 IN]	Ø2.10-3.60 mm [.083-.142 IN]
TERMINAL APPLICATION SPECIFICATION	114-5041
TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL
170326-1	170326-5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
1.72-2.08mm ²	1.57+/-0.05 [.062+/- .002]	7.0
1.12-1.68mm ²	1.40+/-0.05 [.055+/- .002]	8.7
0.70-1.02mm ²	1.24+/-0.05 [.049+/- .002]	10.5

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150054-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150054-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150054-6
- 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 50, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ¹¹ WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

TERMINAL DATA: TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: .187 SERIES POSITIVE LOCK RECEP	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.50-5.50 mm [.177-.217 IN]	Ø2.10-3.60 mm [.083-.142 IN]
TERMINAL APPLICATION SPECIFICATION	114-5041
TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL
1318306-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
2.36-2.55mm ²	1.64+/-0.05 [.065+/- .002]	6.3
1.72-2.08mm ²	1.57+/-0.05 [.062+/- .002]	7.0
1.12-1.68mm ²	1.40+/-0.05 [.055+/- .002]	8.7
0.70-1.02mm ²	1.24+/-0.05 [.049+/- .002]	10.5

***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.

- 2	2	2	2	1655785-9	SCR, BTN SKT HD CAP (M3 X 6)	262	
- 1	1	1	1	1976053-6	LOCATER BLOCK, TERMINAL	261	
- -	-	-	-	2119957-2	APPLICATOR SHIM PACK	260	
- 1	-	-	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252	
- -	-	-	1	2119640-1	PUSH ROD, AIR FEED	250	
- -	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249	
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

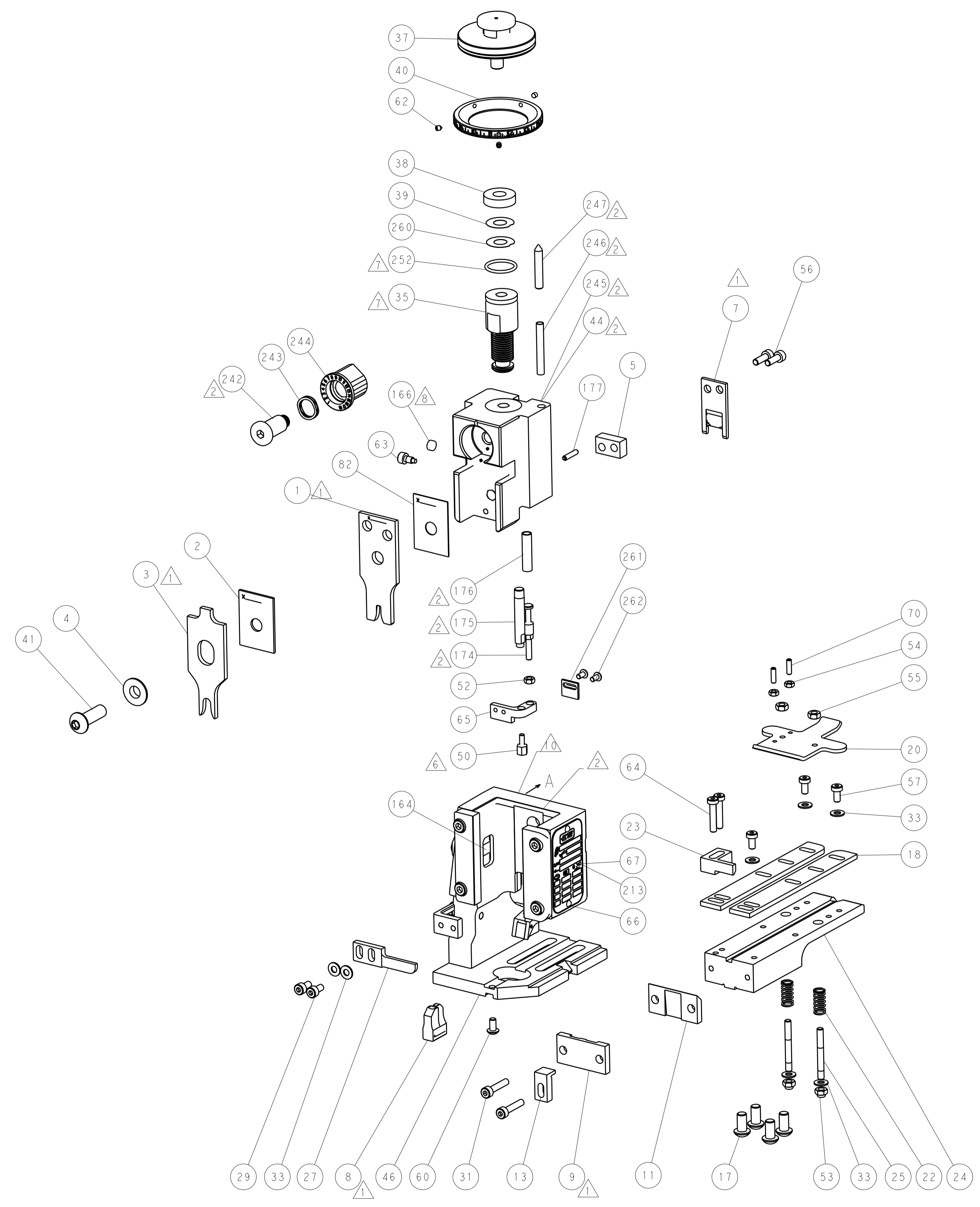
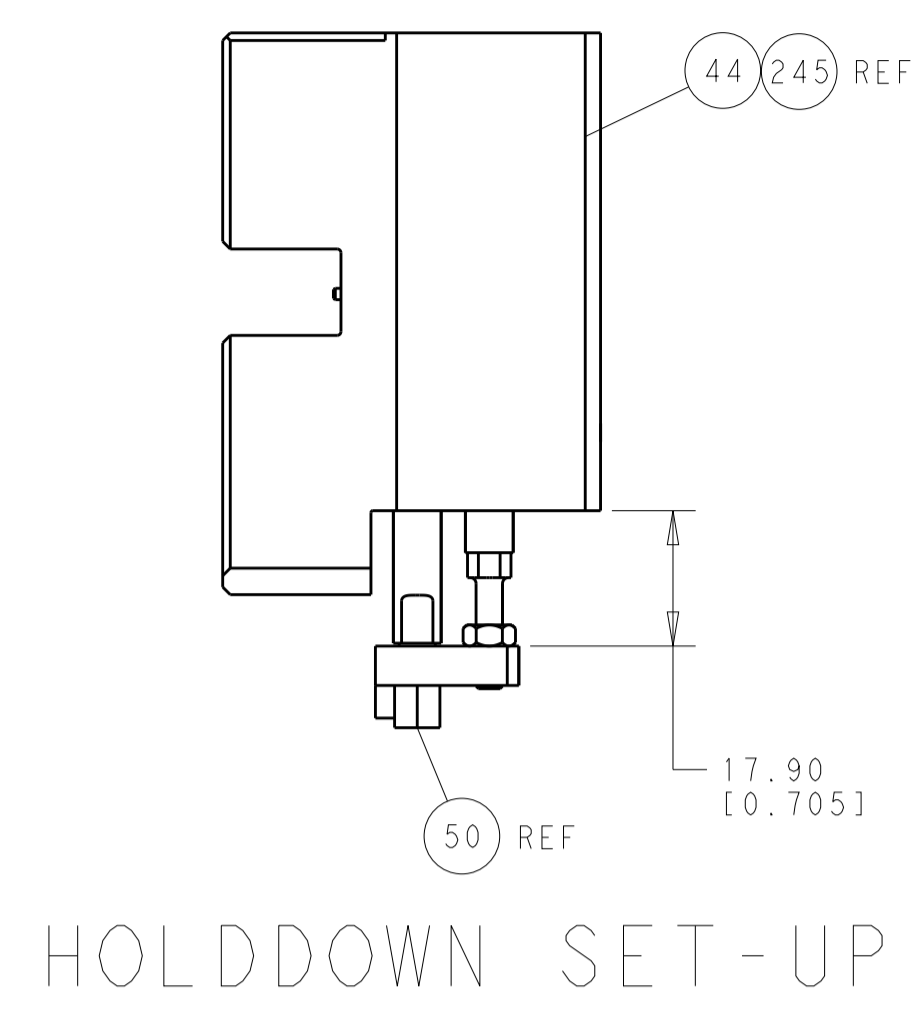
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			1	DEVELOPMENT	14MAY2012	CC SX
			2	UPDATE TO CORRECT PART LIST	23DEC2013	YY UG
			A	RELEASED	30JAN2014	YY UG
			B	ECR-15-002706	18FEB2015	BW JT

- - - - 1	2119641-1	FEED CAM, AIR FEED	248				
- 1 - 1 1	2119798-1	DETENT PIN	247				
- 1 - 1 1	1-22279-3	SPRING, COMPRESSION	246				
- - 1 - -	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245				
- 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 2 -	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240				
- - - - -	2119580-1	MECHANICAL FEED ASSEMBLY	239				
- - - - 1	2063440-1	AIR FEED MODULE	238				
- - 1 1 -	2119740-2	TAG, IDENTIFICATION	213				
- - REFREF -	1803052-1	FEED FINGER ASSEMBLY, EF	183				
- 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				
- - - - 2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172				
- 1 1 1 1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166				
- REFREFREFREF	994970-2	COUNTER, MAGNETIC	164				
- - - - 1	240638-1	SPRING, FEED FINGER	163				
- - - - 1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137				
- - REFREF -	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135				
- - 1 1 -	1633743-1	SERVO FEED LATCH ASM	133				
- 1 1 1 1	455888-4	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	2119740-1	TAG, IDENTIFICATION	67				
- 2 2 2 2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66				
- 1 1 1 1	1901681-8	HOLDDOWN, TERMINAL	65				
- 2 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 1 1 1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60				
- - - - -	2063961-1	FEED FINGER	58				
- 3 3 3 3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57				
- 2 2 2 2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2031314-1	FEED FINGER SUBASSEMBLY	51				
- 1 1 1 1	1752354-7	STANDOFF, HOLD-DOWN	50				
- - - - 1	18023-9	SCR, SKT HD CAP M4 X 6.0	49				
- 1 1 1 1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46				
- 1 - 1 1	2119369-1	RAM, AMP STYLE, END FEED	44				
- 1 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	1-2119644-2	RAM WASHER, PRECISION	38				
- 1 1 1 1	2119085-1	FA HEAD, ATLANTIC STYLE	37				
- 1 - 1 1	2119092-1	BOLT, ADJUSTMENT	35				
- 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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29				
- 1 1 1 1	240639-1	STRIPPER (MACHINING)	27				
- 2 2 2 2	1320906-1	STUD, THREADED	25				
- 1 1 1 1	1-1752371-3	PLATE, STRIP GUIDE	24				
- 1 1 1 1	240825-4	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				
- 4 4 4 4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17				
- 1 1 1 1	1752360-1	SPACER, HOLD-DOWN	13				
- 1 1 1 1	240833-6	PLATE, REAR SHEAR	11				
- - - - -	-	-	10				
- 1 1 1 1	6-690482-3	PLATE, FRONT SHEAR	9				
1 1 1 1 1	2-1333220-6	ANVIL, COMBINATION, .120	8				
- 1 1 1 1	1-2217206-0	BLADE, SLUG	7				
- 1 1 1 1	7-240641-5	SPACER	5				
- 1 1 1 1	238009-1	BLOCK, FL CRIMPER SPACER	4				
1 1 1 1 1	5-2119784-2	CRIMPER, INSULATION O PREMIUM	3				
- 1 1 1 1	1-455888-2	SPACER, CRIMPER	2				
1 1 1 1 1	456409-4	CRIMPER, WIRE .120 "F" PREMIUM	1				
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

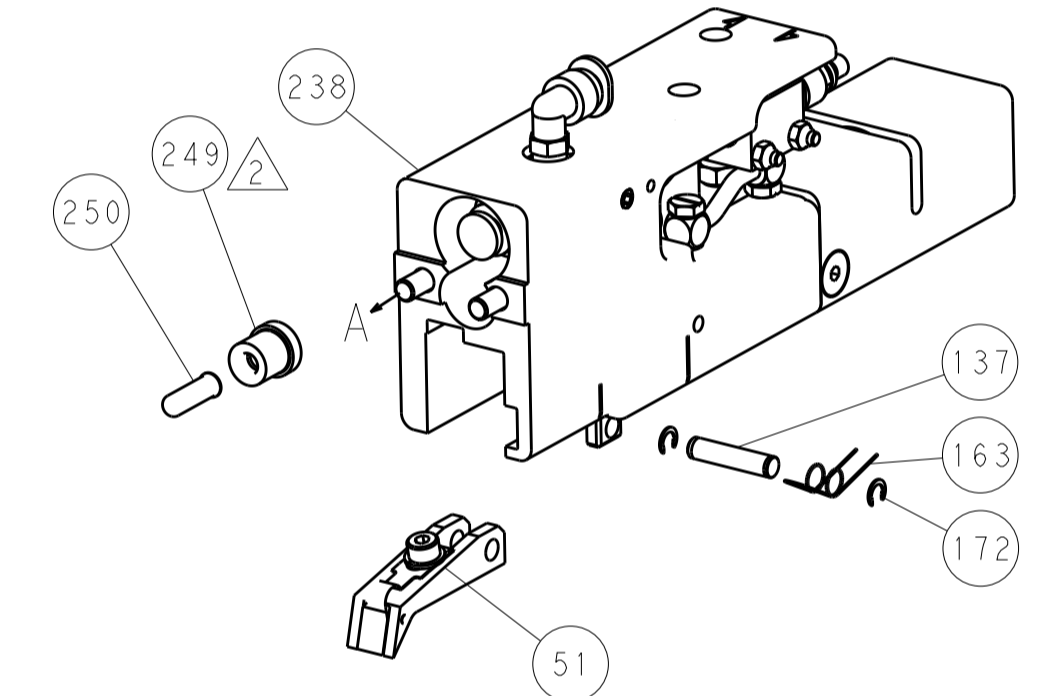
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001
	ANGLES ±.0001				
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV
			1:1	1 OF 4	B

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS					

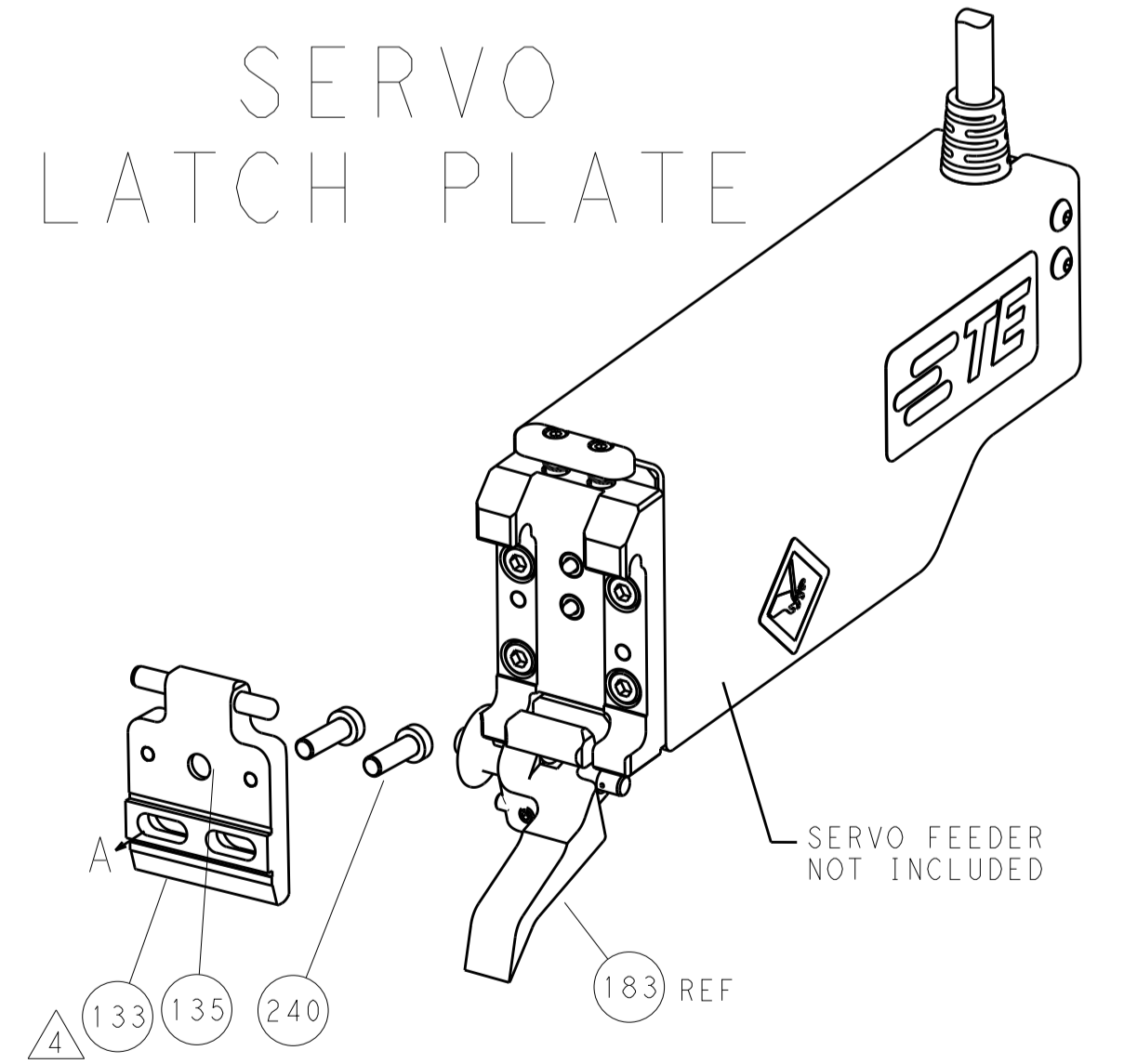


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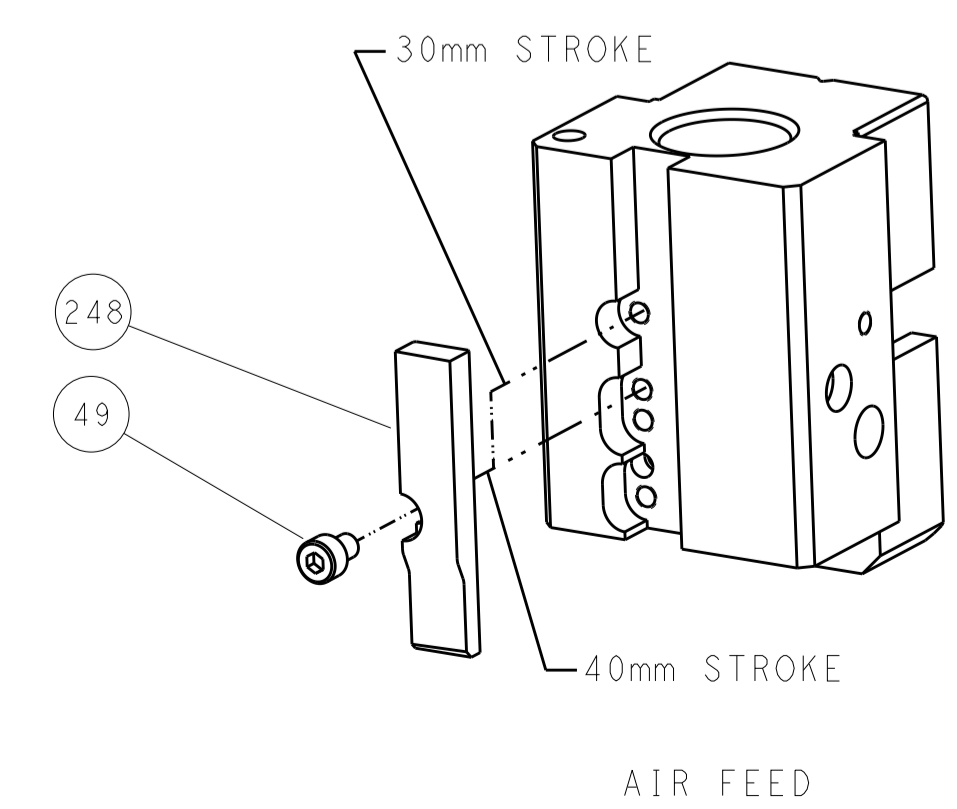
PNEUMATIC



SERVO LATCH PLATE

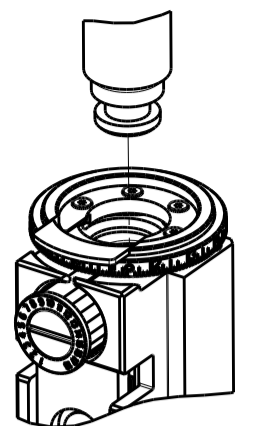




CAM POSITION

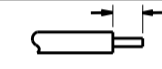







ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	L.C. CHEN	14MAY2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	CHK	S.XI	14MAY2012	
	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.001	APVD	J. CRUZ	14MAY2012	NAME
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing		SIZE	CAGE CODE
			1:1			A1	00779
			SHEET	2 of 4		REV	B

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150054-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	2063961-1	-	-	-	-	-
	2-2150054-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	SERVO LATCH PLATE	2119951-1	1803052-1	8-2150054-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150054-4	-	-	-
	2-2150054-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2150054-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [1.20]	F
INSUL	5.90 mm [2.32]	O
APPL INSTRUCTIONS 408-10390 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .187 SERIES POSITIVE LOCK RECP			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.50 mm [1.77-.217 IN]		Ø2.10-3.60 mm [1.083-.142 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5041	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170326-1	170326-5		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .187 SERIES POSITIVE LOCK RECP			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.50 mm [1.77-.217 IN]		Ø2.10-3.60 mm [1.083-.142 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5041	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1318306-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.72-2.08mm ²	1.57+/-0.05 [1.062+/-0.02]	7.0
1.12-1.68mm ²	1.40+/-0.05 [1.055+/-0.02]	8.7
0.70-1.02mm ²	1.24+/-0.05 [1.049+/-0.02]	10.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.36-2.55mm ²	1.64+/-0.05 [1.065+/-0.02]	6.3
1.72-2.08mm ²	1.57+/-0.05 [1.062+/-0.02]	7.0
1.12-1.68mm ²	1.40+/-0.05 [1.055+/-0.02]	8.7
0.70-1.02mm ²	1.24+/-0.05 [1.049+/-0.02]	10.5









***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.

- 2 2 2	1655785-9	SCR, BTN SKT HD CAP (M3 X 6)	262
- 1 1 1	1976053-6	LOCATER BLOCK, TERMINAL	261
- 1 1 1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- - - 1	2119640-1	PUSH ROD, AIR FEED	250
-77-27-25-22	PART NO	DESCRIPTION	ITEM NO

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

- - - 1	2079988-1	BUSHING, LCH5-12, MISUMI	249
- 1 1 1	1-22279-3	SPRING, COMPRESSION	246
- 1 1 1	2119082-9	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
- - - -	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 -	1803052-1	FEED FINGER ASSEMBLY, EF	183
- 1 1 1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
- 1 1 1	8-22280-7	SPRING, COMPRESSION	176
- 1 1 1	1752353-2	GUIDE PIN, HOLDDOWN	175
- 1 1 1	1901680-2	GUIDE PIN, HOLDDOWN	174
- - - 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	455888-4	SPACER, CRIMPER	82
- 1 1 1	2119956-2	DOCUMENTATION PACKAGE	71
- 2 2 2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
- 1 - 1	2119740-1	TAG, IDENTIFICATION	67
- 2 2 2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
- 1 1 1	1901681-8	HOLDDOWN, TERMINAL	65
- 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
- - - -	2063961-1	FEED FINGER	58
- 3 3 3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
- 2 2 2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
- 2 2 2	5018030-2	NUT, HEX, REG, RoHS, M4	55
- 2 2 2	5018030-1	NUT, HEX, REG, RoHS, M3	54
- 2 2 2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
- 1 1 1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
- - - 1	2031314-1	FEED FINGER SUBASSEMBLY	51
- 1 1 1	1752354-7	STANDOFF, HOLD-DOWN	50
- - - 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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
- 1 1 1	240639-1	STRIPPER (MACHINING)	27
- 2 2 2	1320906-1	STUD, THREADED	25
- 1 1 1	1-1752371-3	PLATE, STRIP GUIDE	24
- 1 1 1	240825-4	PLATE, STRIP HOLD DOWN	23
- 2 2 2	2-22281-3	SPRING, COMPRESSION	22
- 1 1 1	1752373-4	DRAG	20
- 2 2 2	1901259-6	GUIDE, LOWER STRIP	18
- 1 1 1	1752360-1	SPACER, HOLD-DOWN	13
- 1 1 1	240833-6	PLATE, REAR SHEAR	11
- - - -	-	-	10
- 1 1 1	6-690482-3	PLATE, FRONT SHEAR	9
- 1 1 1	2-1333220-6	ANVIL, COMBINATION, .120	8
- 1 1 1	1-2217206-0	BLADE, SLUG	7
- 1 1 1	7-240641-5	SPACER	5
- 1 1 1	238009-1	BLOCK, FL CRIMPER SPACER	4
- 1 1 1	5-2119784-2	CRIMPER, INSULATION O PREMIUM	3
- 1 1 1	1-455888-2	SPACER, CRIMPER	2
- 1 1 1	456409-4	CRIMPER, WIRE .120 "F" PREMIUM	1
-77-27-25-22	PART NO	DESCRIPTION	ITEM NO

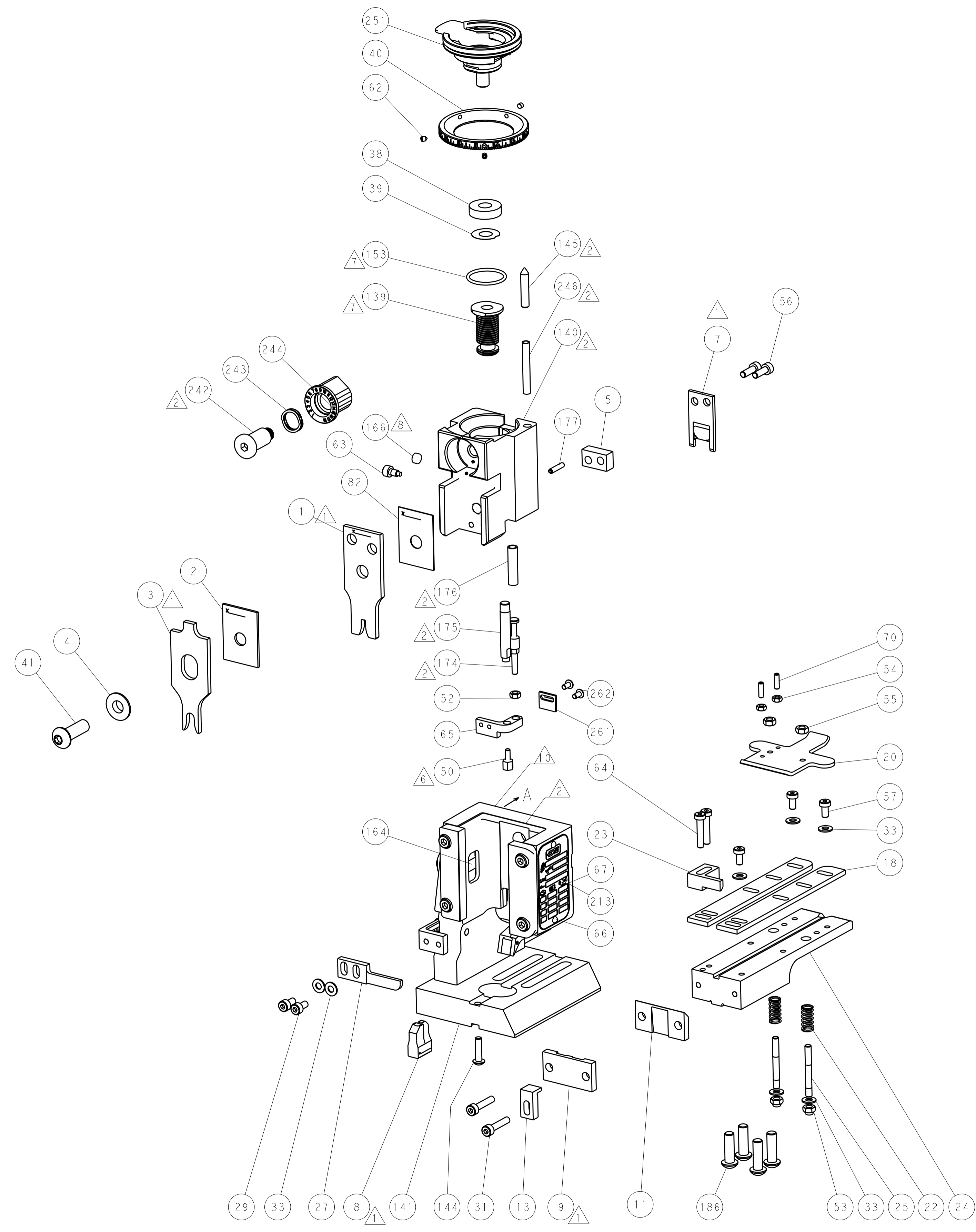
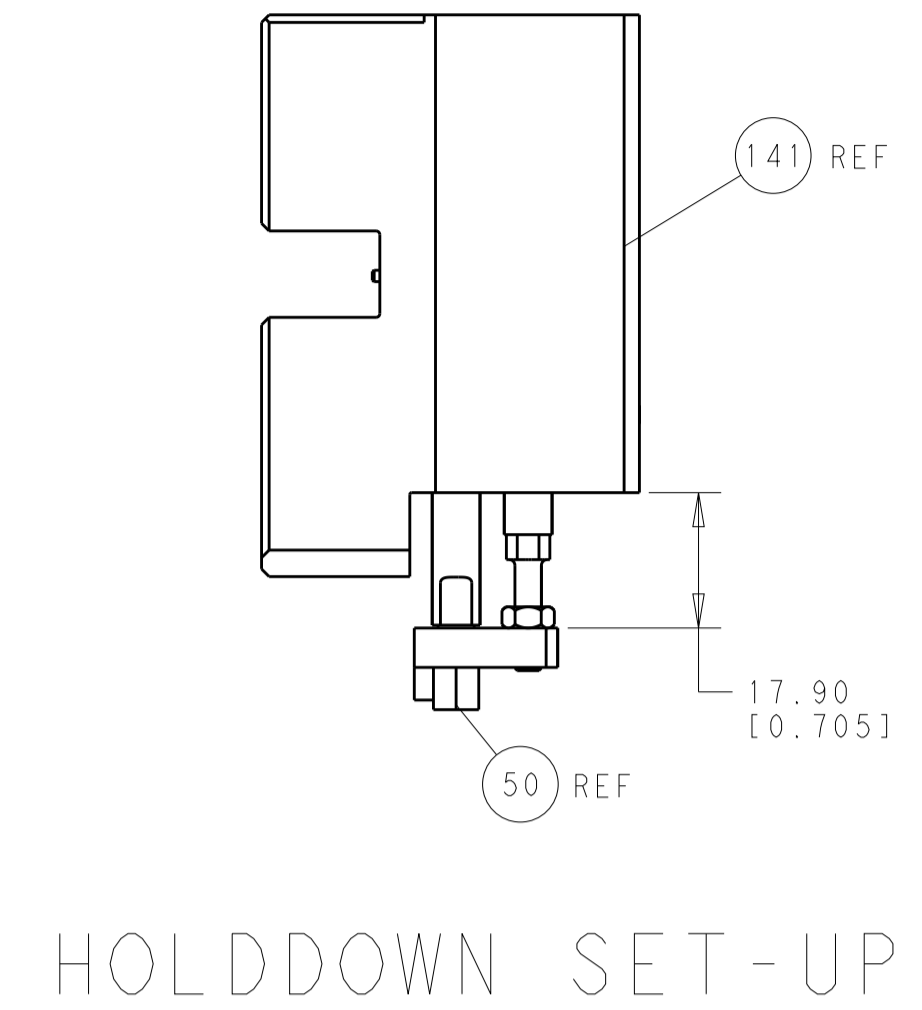


-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150054-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150054-5
- 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 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.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

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

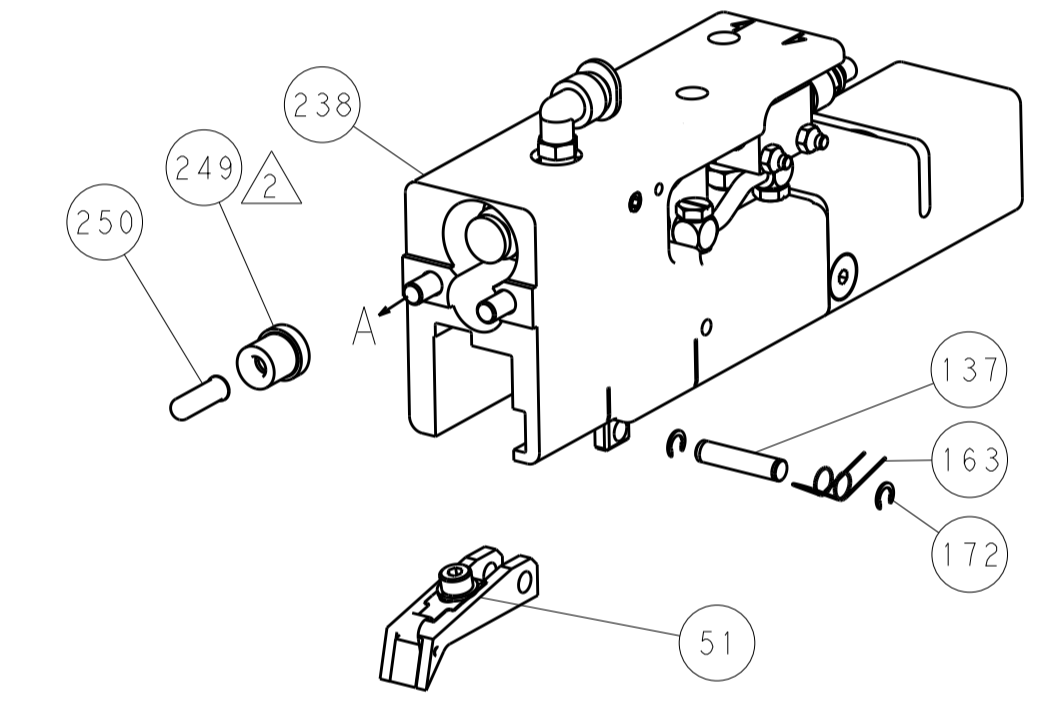
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±0.5	1 PLC ±0.13	2 PLC ±0.013	3 PLC ±0.001	4 PLC ±0.0001
MATERIAL:		FINISH:		WEIGHT:	SCALE:
				Customer Accessible Production Drawing	SCALE 1:1 SHEET 3 OF 4 REV B

LOC	DIST	REV	DATE	BY	APPV
A	66				

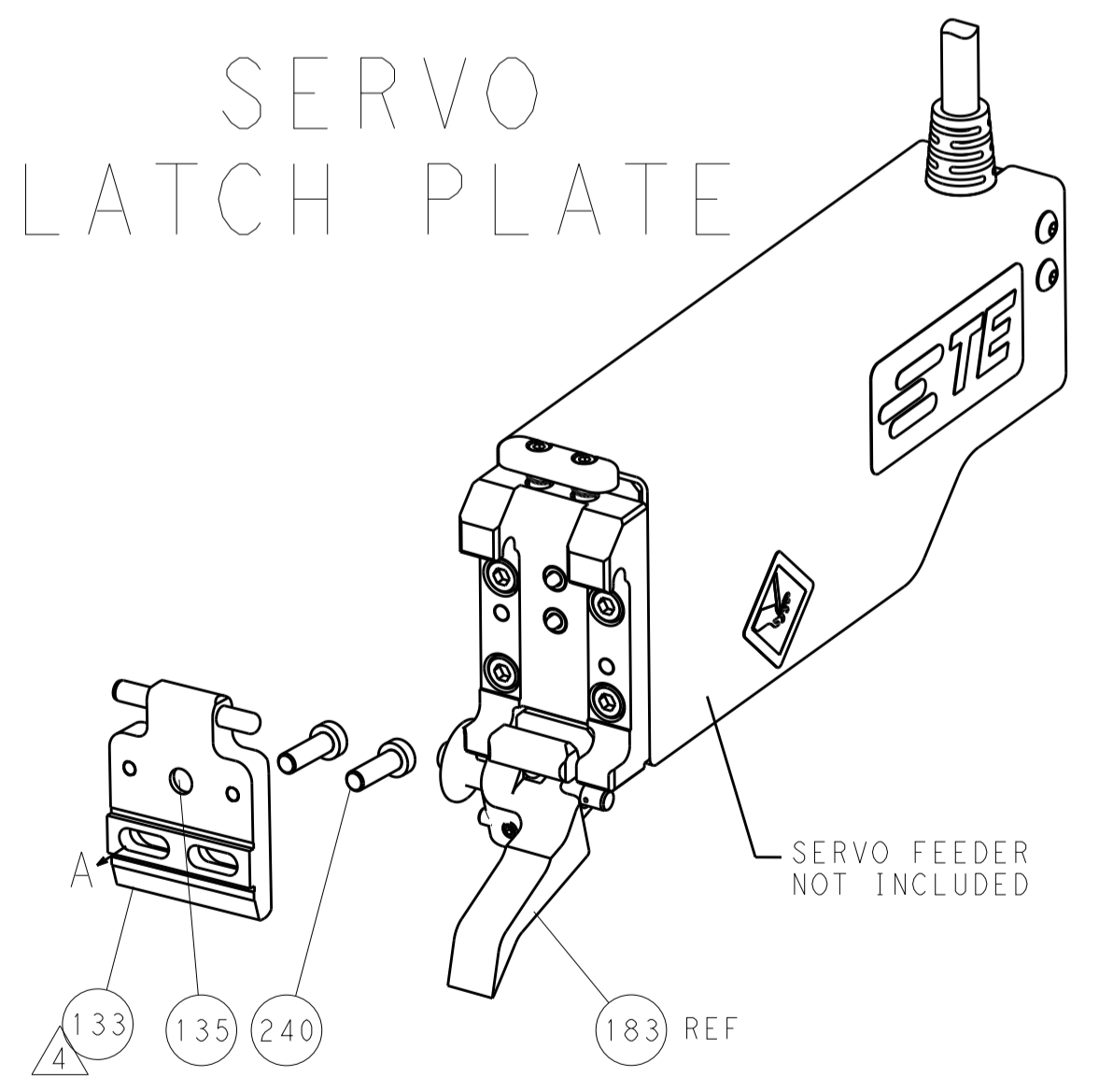


FEED TYPE

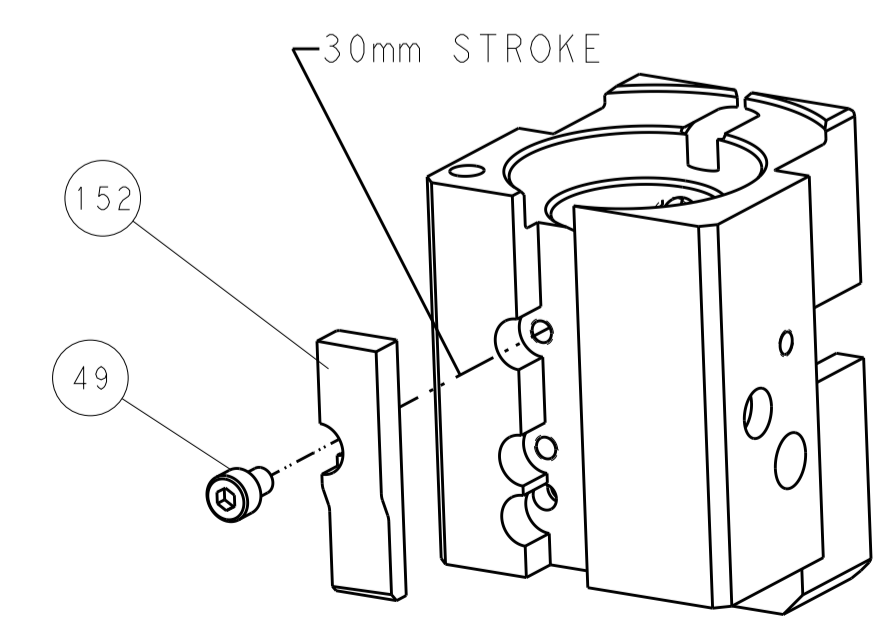
PNEUMATIC



SERVO LATCH PLATE



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L.C. CHEN 14MAY2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	APVD J. CRUZ 14MAY2012	NAME Ocean End Feed Applicator
MATERIAL:		FINISH:		WEIGHT:		SIZE CAGE CODE DRAWING NO. A11 00779 C=2150054	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 4 OF 4 REV B	