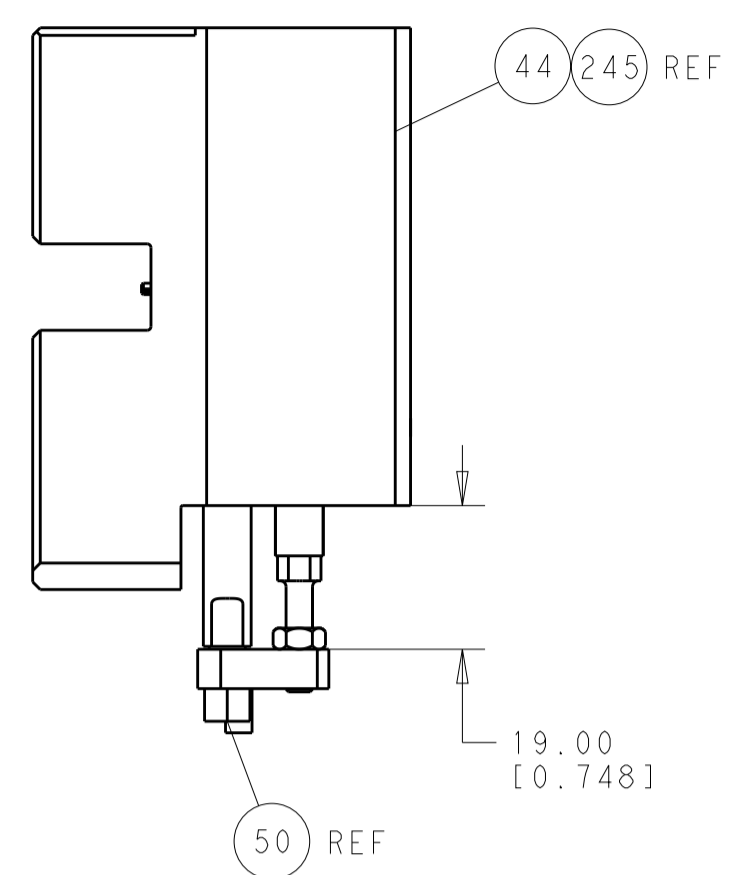


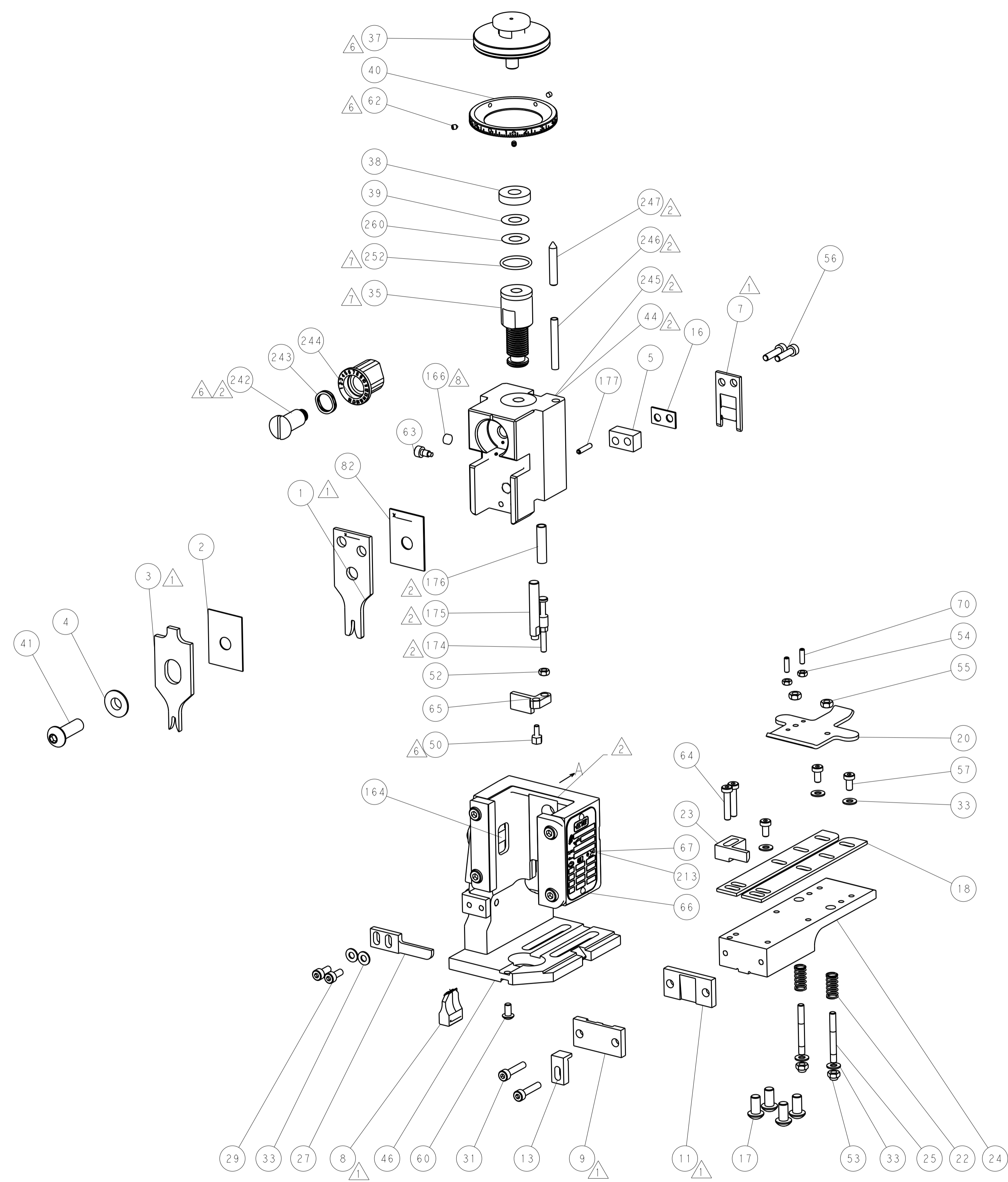


LOC	DIST	REV	DATE	BY	APPV
A	66				

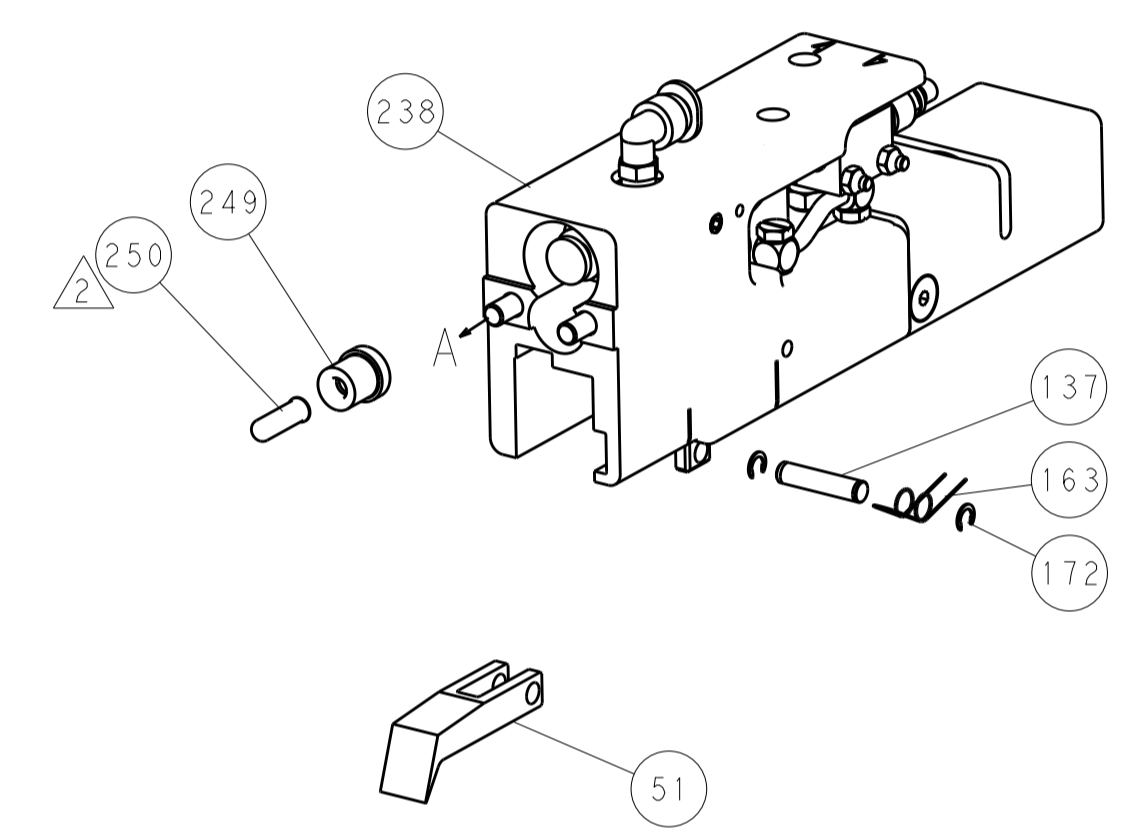
REVISIONS			
NO.	DESCRIPTION	DATE	BY
1	SEE SHEET 1		



HOLDDOWN SET-UP

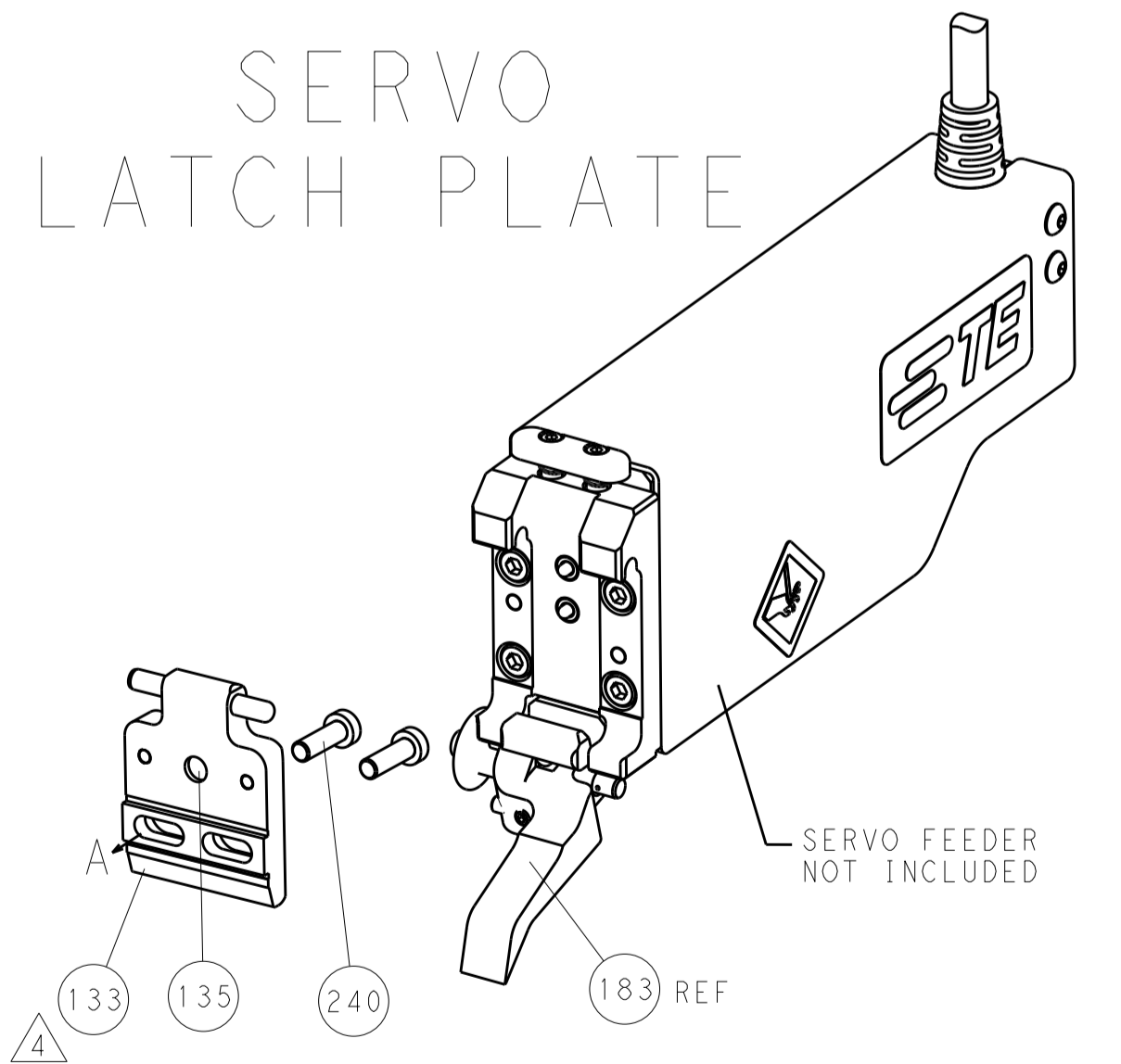


FEED TYPE

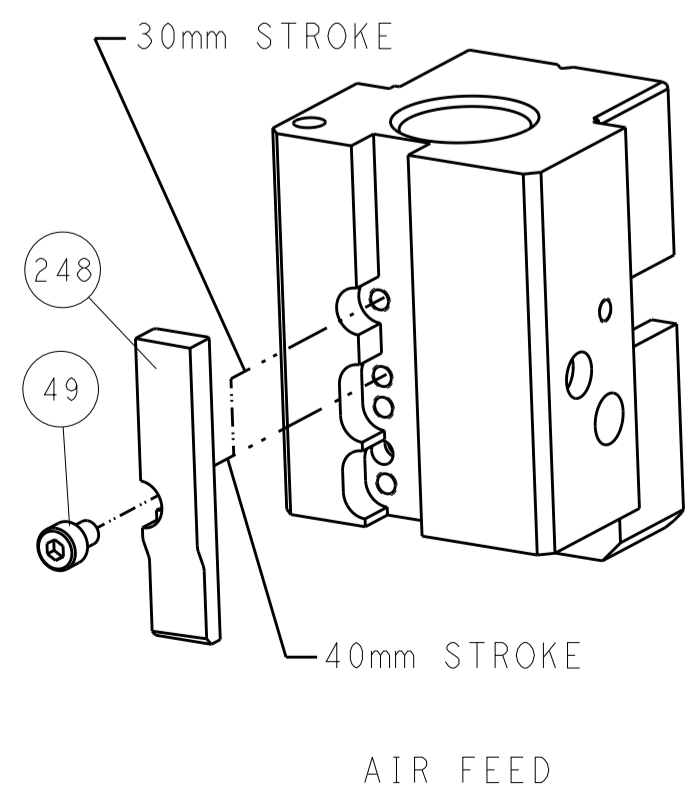


PNEUMATIC

SERVO LATCH PLATE



CAM POSITION



AIR FEED

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		DWN R. HUANG 12MAR2013 CHK L. ZHANG 12MAR2013 APVD H. GUO 12MAR2013		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME: Ocean End Feed Applier	
WEIGHT:		SCALE: 1:1		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150319		RESTRICTED TO:	
Customer Accessible Production Drawing				SHEET 2 OF 4		REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2150319-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2150319-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>
	2-2150319-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2150319-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm (.080)	F
INSUL	2.79 mm (.110)	OV
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: .110 SRS FAST-IN-ON TAB.		
WIRE STRIP LENGTH .154-.185 IN (3.90-4.70 mm)		INSULATION DIAMETER RANGE Ø.055-.091 IN (1.40-2.30 mm)
TERMINAL APPLICATION SPECIFICATION	114-20021	-
TERMINALS APPLIED <sup>10</sup>		
TE TERMINAL 160887-1	TE TERMINAL 160887-3	TE TERMINAL 160887-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>
1.00mm2	1.60 +/- 0.05 [0.063 +/- .002]	8.9
0.85mm2	1.55 +/- 0.05 [0.061 +/- .002]	9.4
0.75mm2	1.52 +/- 0.05 [0.060 +/- .002]	9.8
0.70mm2	1.50 +/- 0.05 [0.059 +/- .002]	10.0
0.50mm2	1.42 +/- 0.05 [0.056 +/- .002]	10.9

- 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: 8-2150319-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150319-5
- 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.

**\*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	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

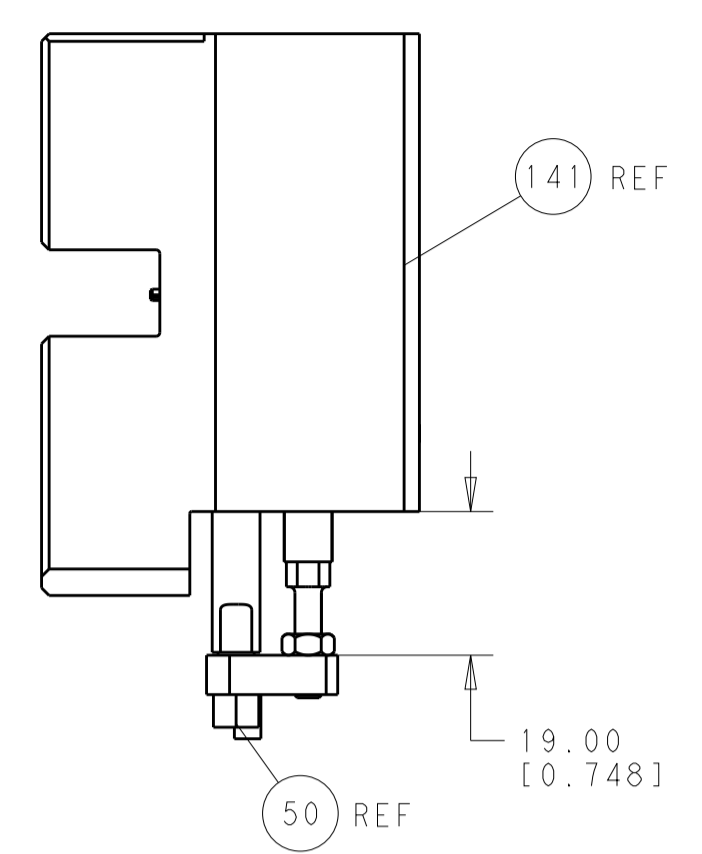
**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

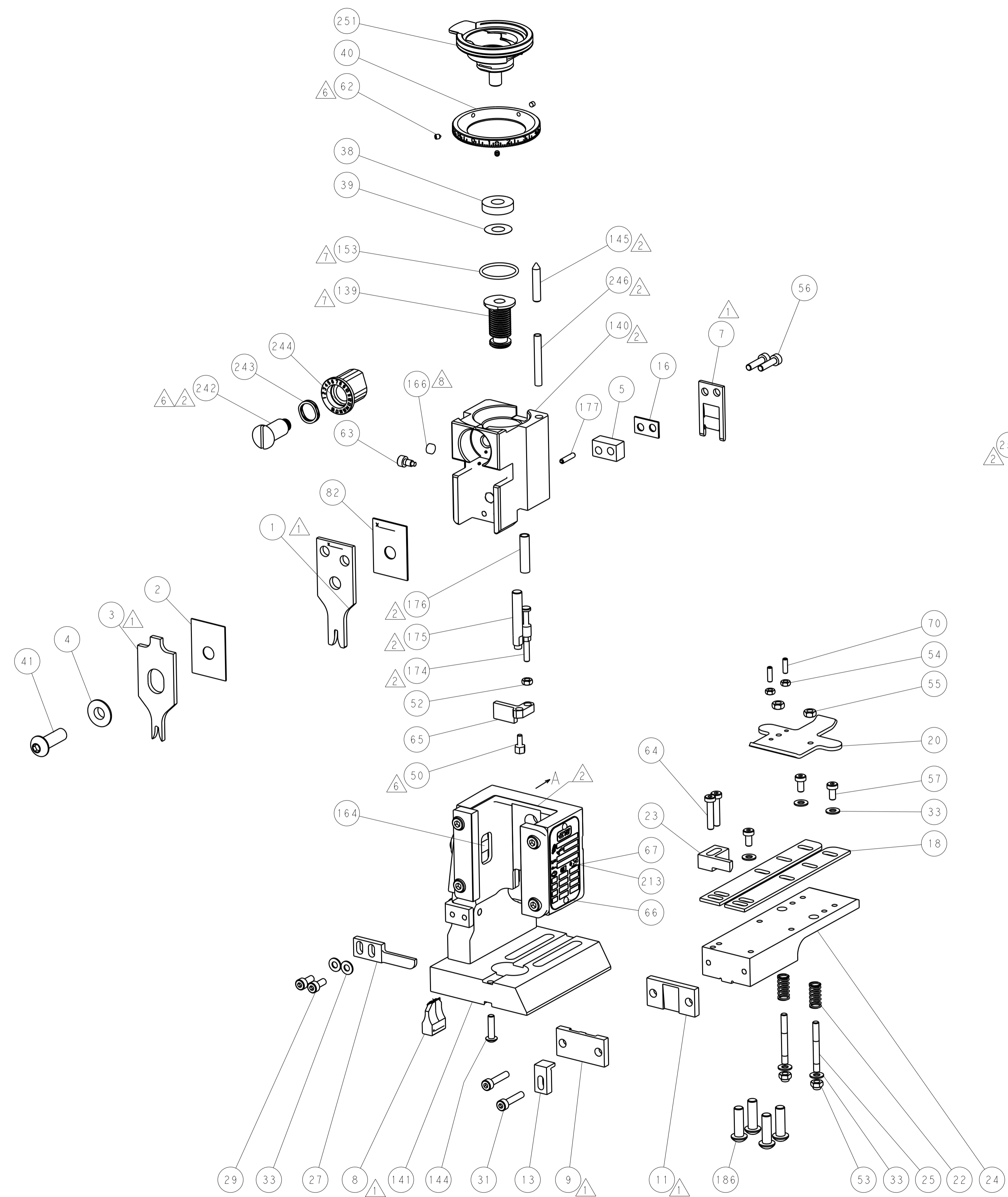
REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	-	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	-	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	-	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	-	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	-	242
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	-	240
-	-	-	1	2063440-2	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
-	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	455888-8	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	-	66
-	1	1	1	1976052-1	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
-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	-	57
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	-	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	2119792-2	PAWL, EF, AIR	-	51
-	1	1	1	1752354-2	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	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	240639-1	STRIPPER (MACHINING)	-	27
-	2	2	2	1320906-1	STUD, THREADED	-	25
-	1	1	1	1752371-5	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	1901259-4	GUIDE, LOWER STRIP	-	18
-	1	1	1	5-240641-9	SPACER	-	16
-	1	1	1	1752360-1	SPACER, HOLD-DOWN	-	13
-	1	1	1	240644-1	PLATE, REAR SHEAR	-	11
-	-	-	-	-	-	-	10
-	1	1	1	690482-5	PLATE, FRONT SHEAR	-	9
-	1	1	1	1333216-1	ANVIL, COMBINATION	-	8
-	1	1	1	2217206-7	BLADE, SLUG	-	7
-	-	-	-	-	-	-	6
-	1	1	1	5-240641-1	SPACER	-	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	-	4
-	1	1	1	1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	-	3
-	1	1	1	455888-5	SPACER, CRIMPER	-	2
-	1	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	-	1
-77-27-25-22	PART NO		DESCRIPTION			ITEM NO	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		CHK		APV		NAME	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.13	3 PLC ±.013	4 PLC ±.0001	ANGLES ±.1	FINISH	DATE	DATE	DATE	DATE
				H. HUANG 12MAR2013		L. ZHANG 12MAR2013		H. GUO 12MAR2013		TE Connectivity Harrisburg, PA 17105-3608	
				PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE DRAWING NO	
				MATERIAL		WEIGHT		A1 00779		C=2150319	
				RESTRICTED TO		SCALE		SHEET 3 OF 4		REV A	

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

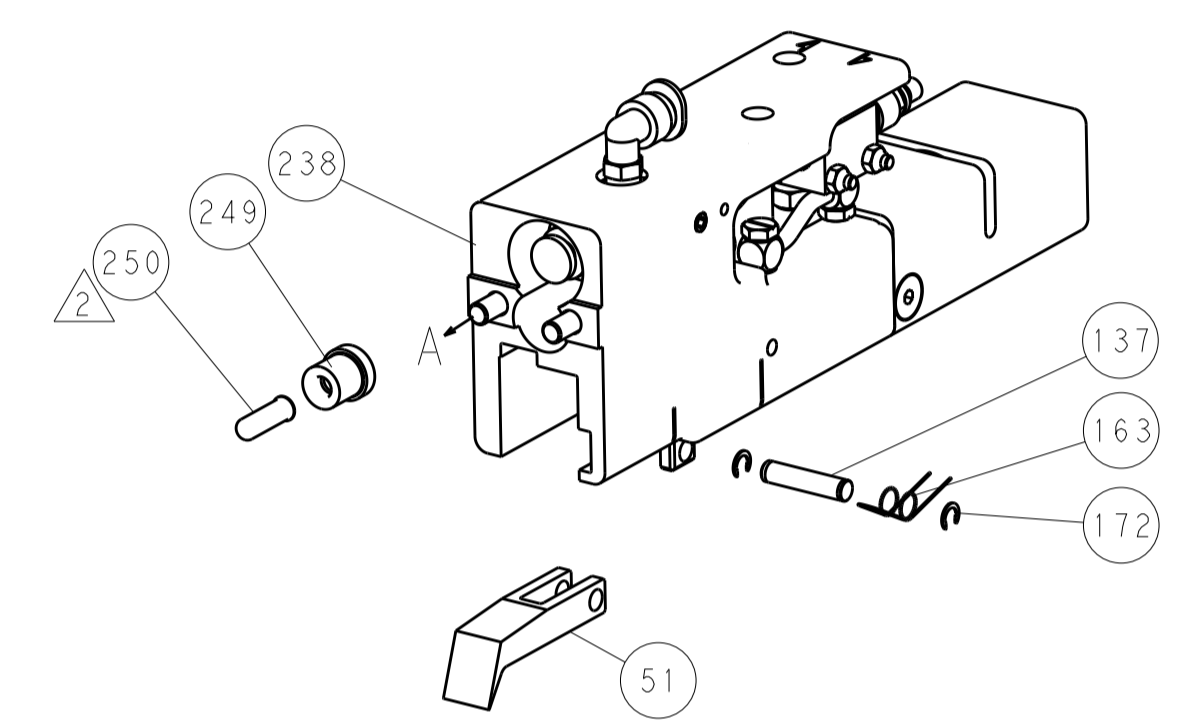


HOLDDOWN SET-UP

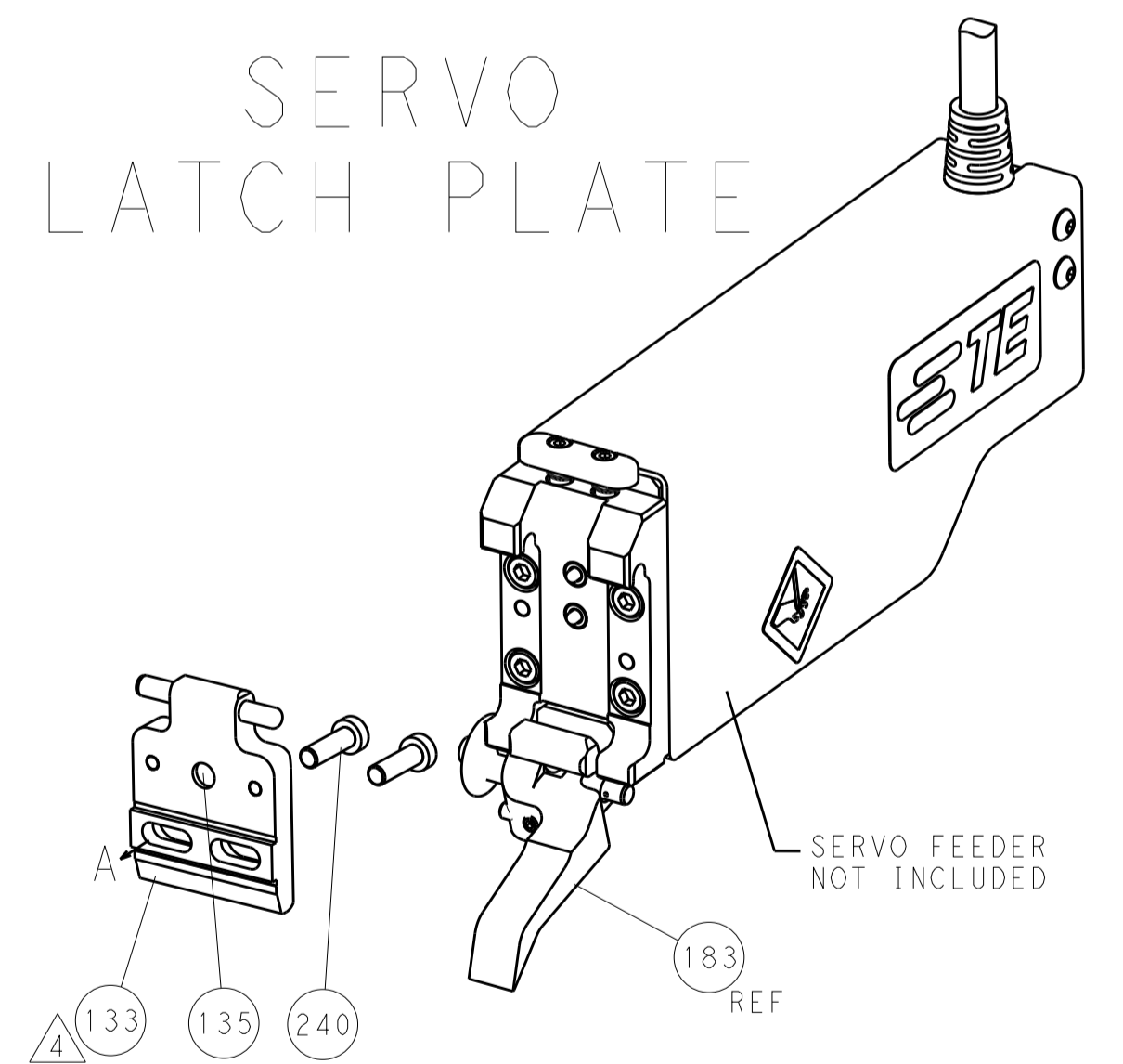


FEED TYPE

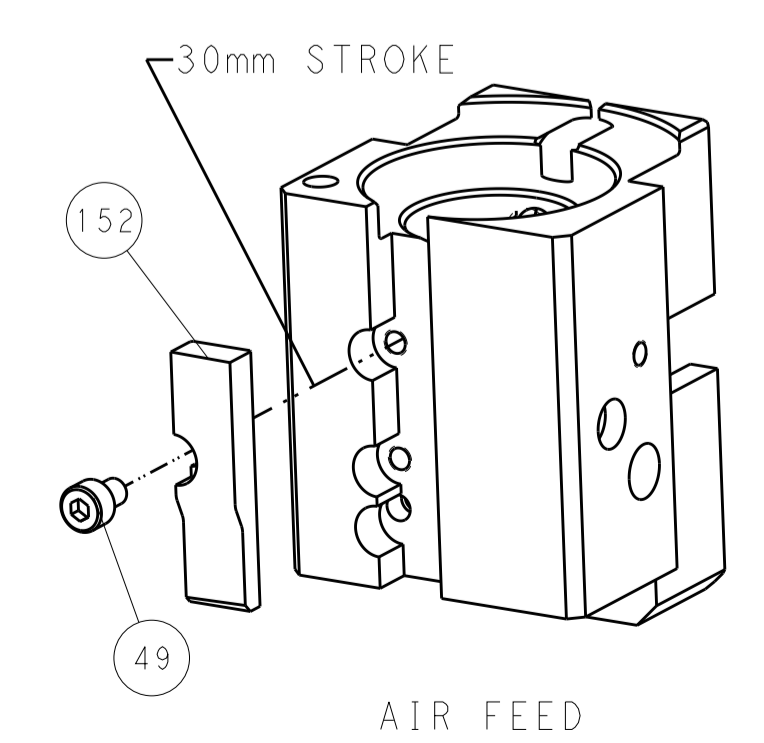
PNEUMATIC



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 H. HUANG 12MAR2013		STE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD L. ZHANG 12MAR2013	NAME Ocean End Feed Applicator
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	OF	REV	RESTRICTED TO
			1:1	4	4	A	