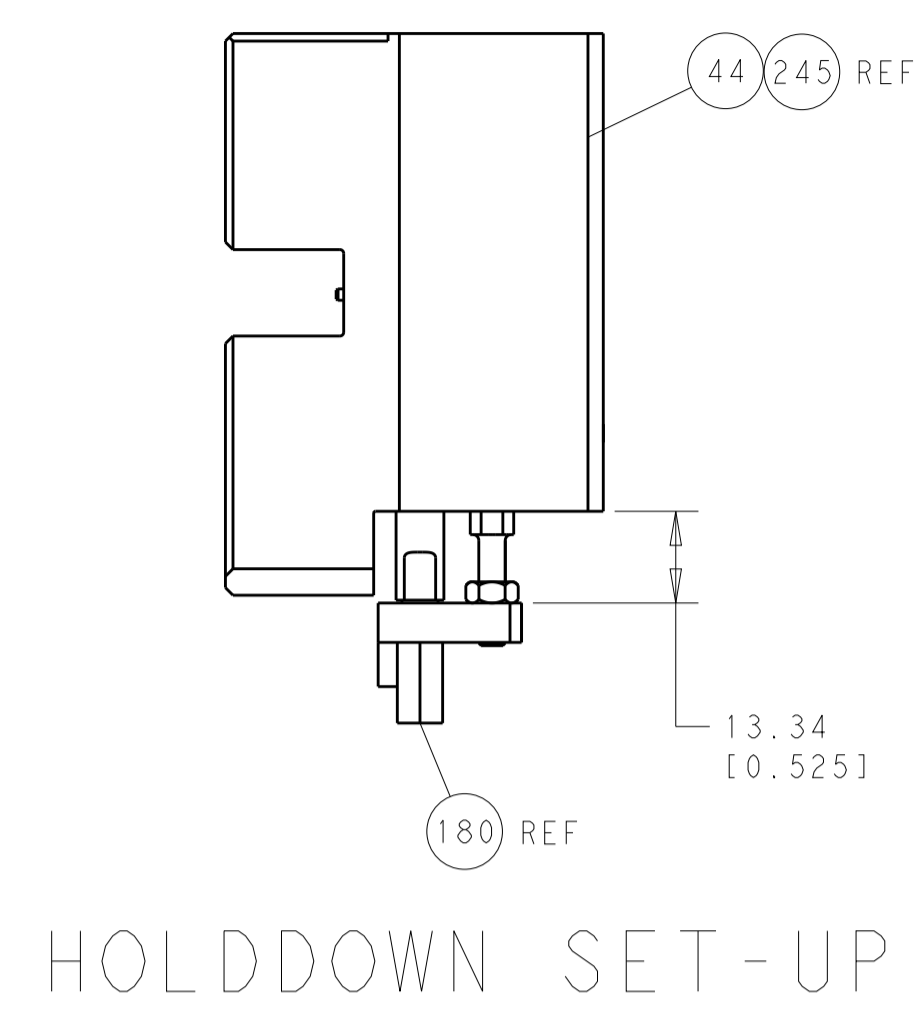


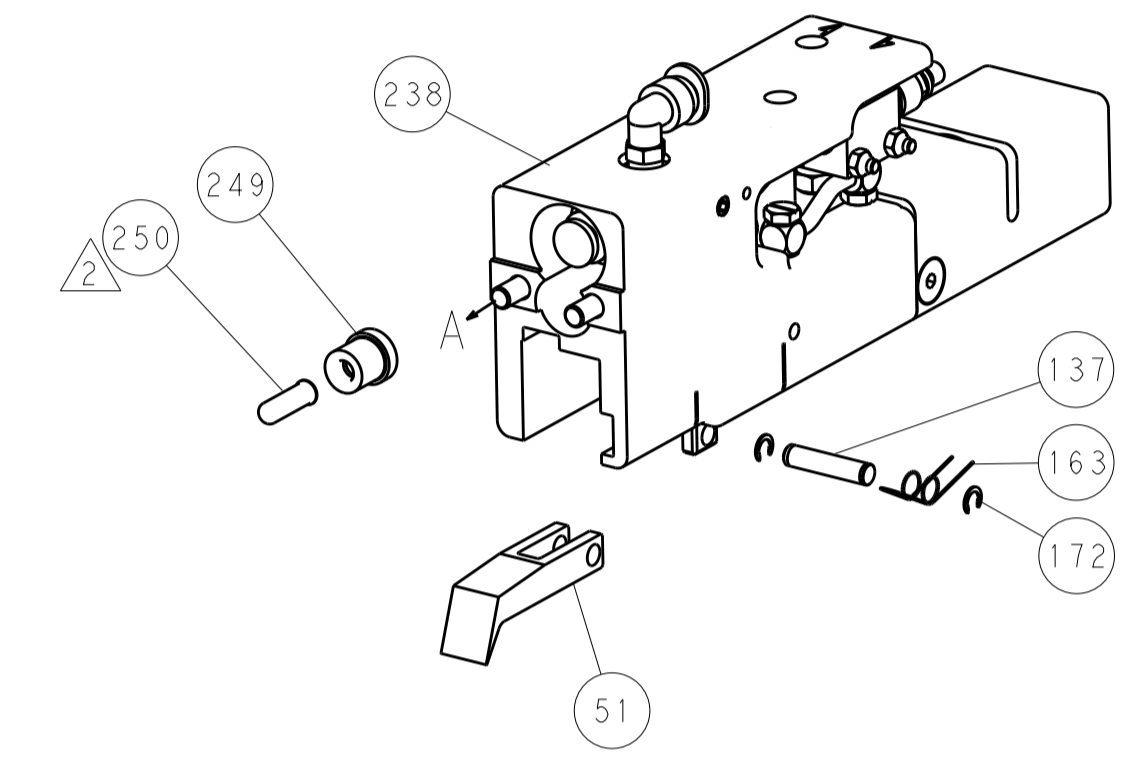


LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

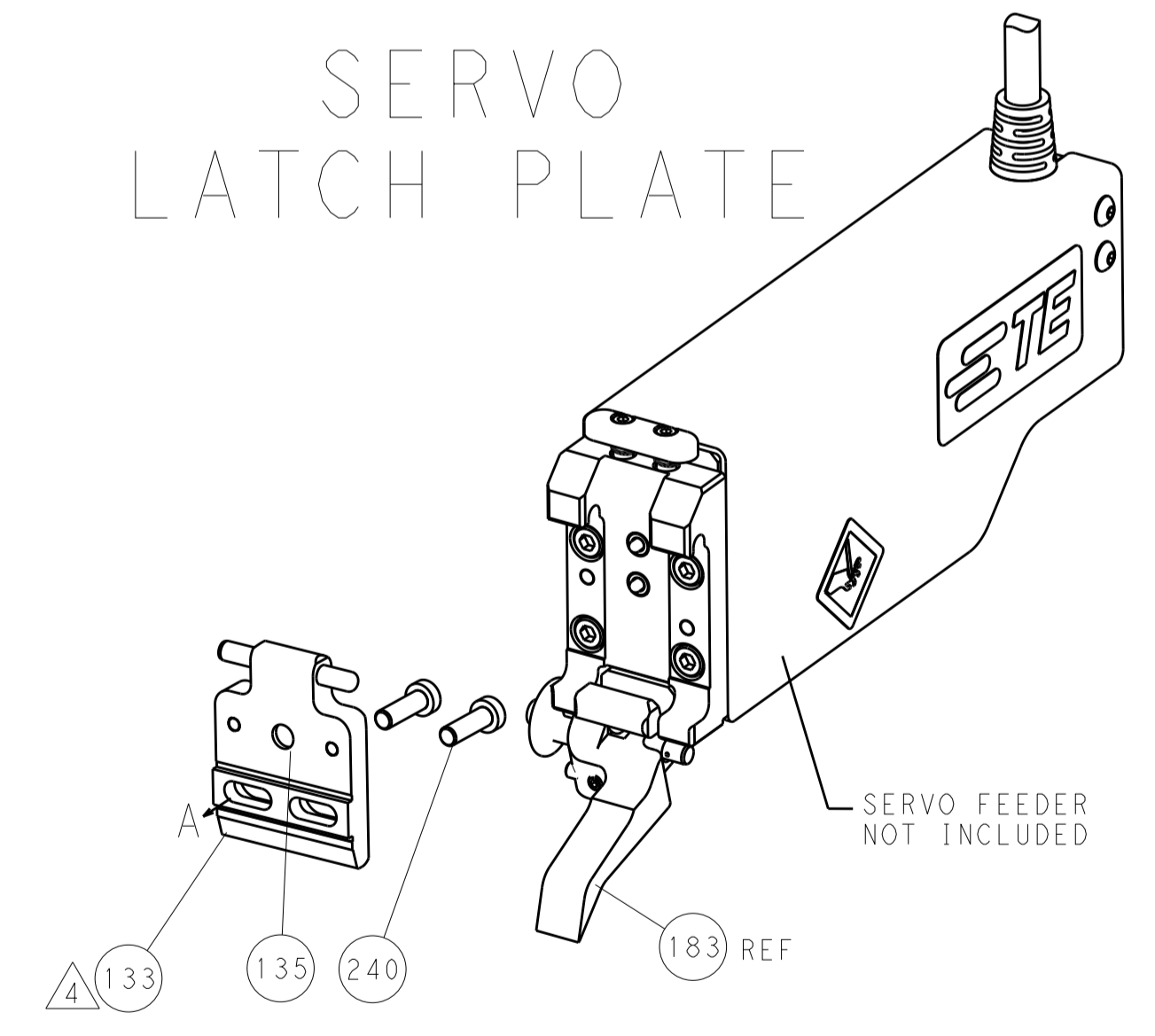


FEED TYPE

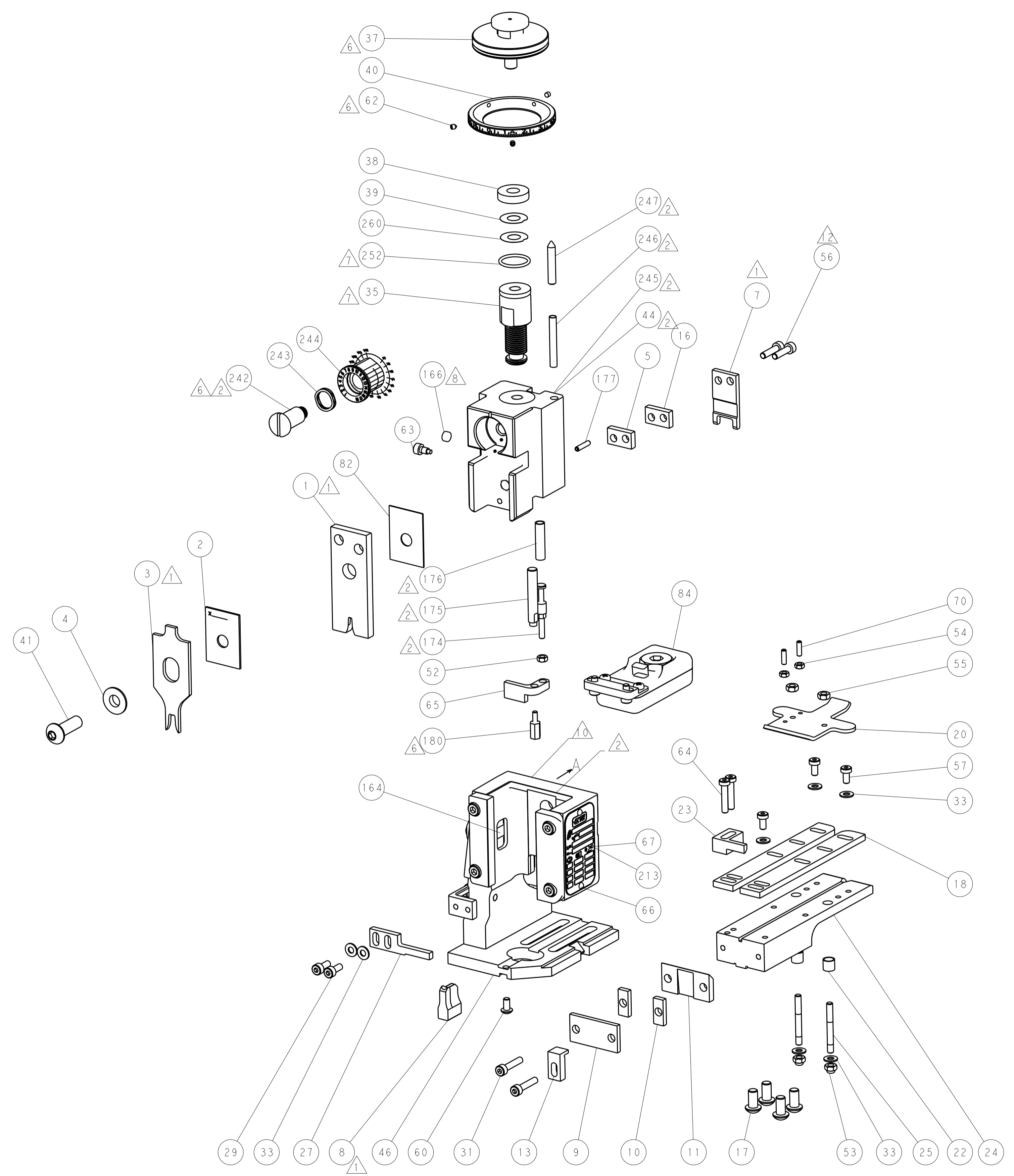
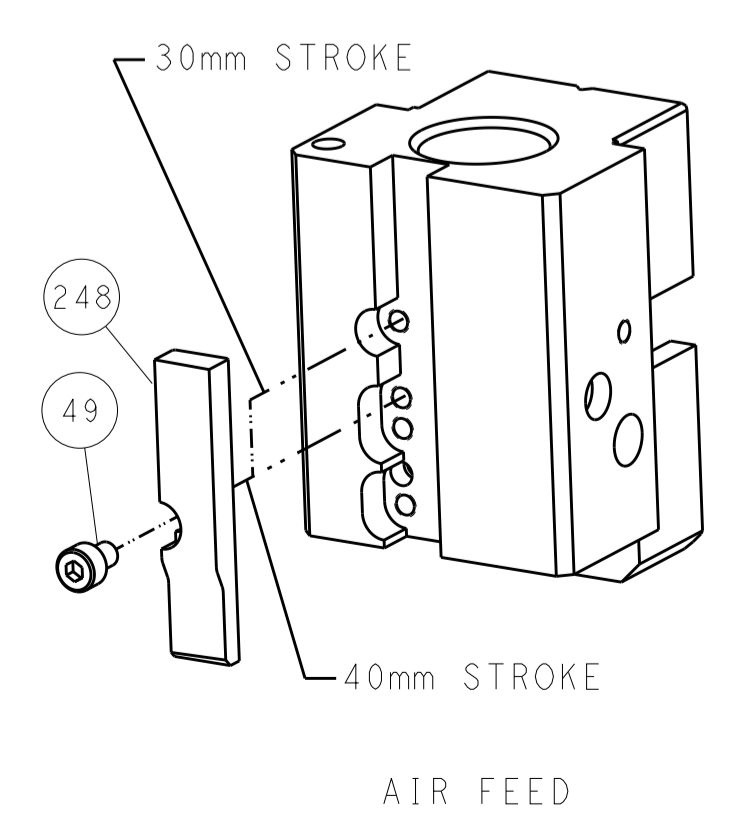
PNEUMATIC



SERVO LATCH PLATE

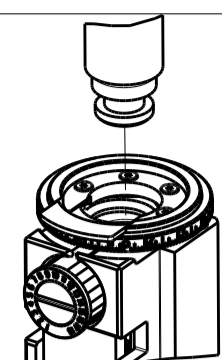


CAM POSITION

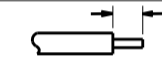


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)







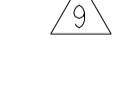


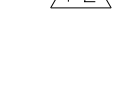
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	14JAN2014	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	CHK	14JAN2014	
	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.0001	APVD	14JAN2014	NAME
MATERIAL	FINISH	WEIGHT	SCALE	A1 00779 ©=2150408		RESTRICTED TO
			1:1	Customer Accessible Production Drawing		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				
	2-2150408-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150408-5	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150408-4	-	-
	2-2150408-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	-	-	-	-	-	-
2-2150408-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150408-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.10]	F
INSUL	5.00 mm [1.97]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: 3.2ø CLUSTER REC. "L" TYPE		
WIRE STRIP LENGTH 7.70-8.70 mm [1.303-.343 IN]		INSULATION DIAMETER RANGE ø2.20-3.20 mm [1.087-.126 IN]
TERMINAL APPLICATION SPECIFICATION 114-5215		
TERMINALS APPLIED <sup>10</sup>		
TE TERMINAL	TE TERMINAL	TE TERMINAL
316292-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>
1.104ø+1.104ø+0.97ø	2.12+/-0.05 [1.083+/-0.002]	6.2
0.97ø+0.97ø+0.87ø	1.97+/-0.05 [1.078+/-0.002]	8.2
1.02ø+1.02ø	1.84+/-0.05 [1.072+/-0.002]	9.7
0.92ø+0.72ø	1.70+/-0.05 [1.067+/-0.002]	11.0

-  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: 8-2150408-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150408-5
- 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, 180 & 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.
-  CUT TO LENGTH AT ASSEMBLY.
-  TERMINAL LUBRICANT IS RECOMMENDED.

**\*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
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

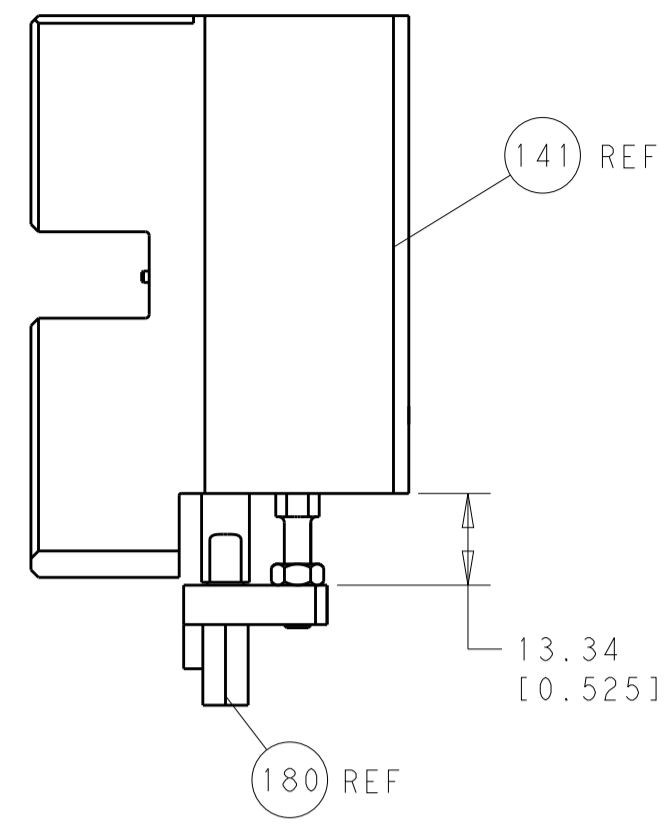
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

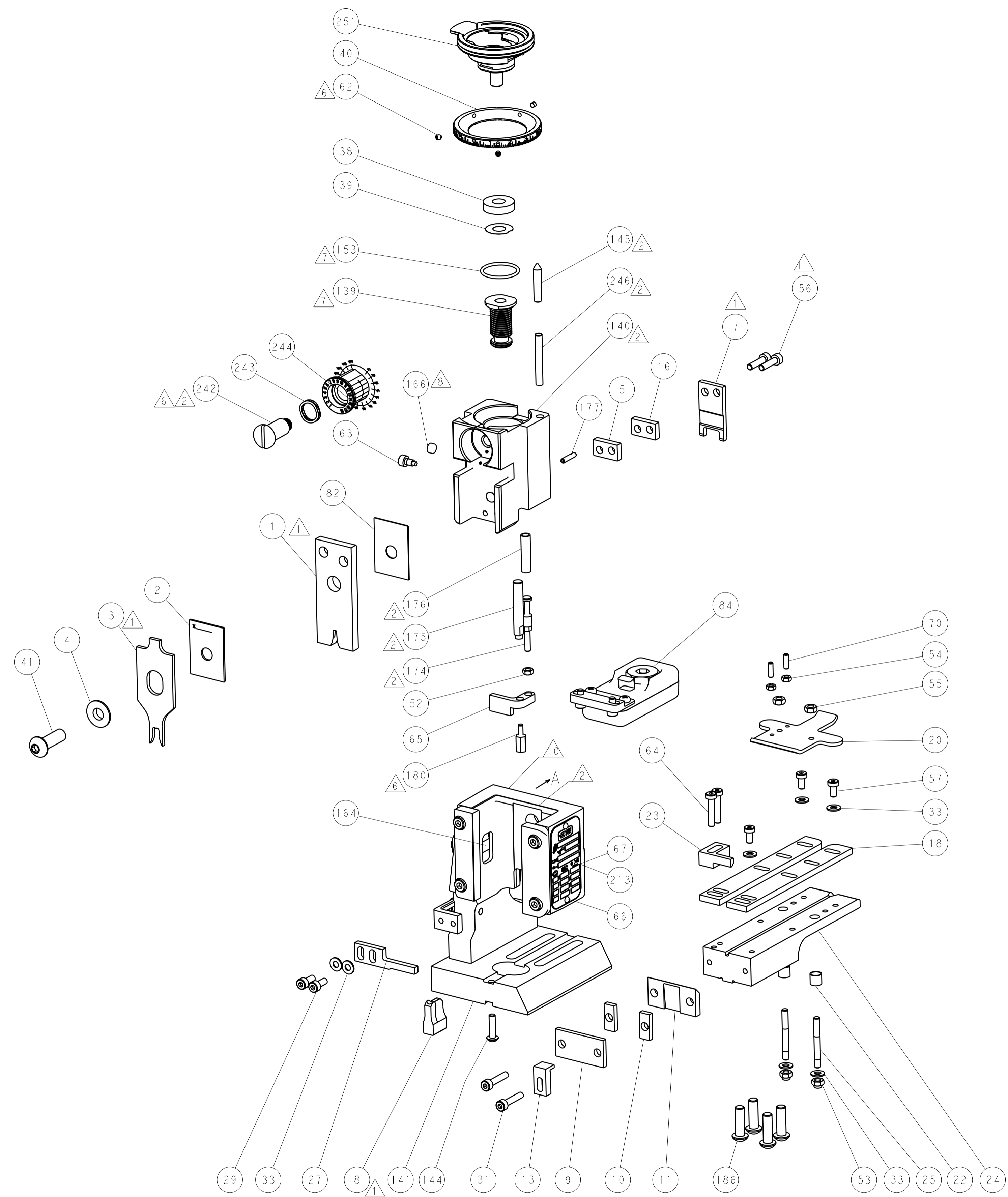
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	-	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	2-1752354-7	STANDOFF, HOLD-DOWN	180
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	455888-5	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	1901681-1	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	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	690455-3	STRIPPER, FRONT CASTING	27
-	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	2-1752371-0	PLATE, STRIP GUIDE	24
-	1	1	1	240825-3	PLATE, STRIP HOLD DOWN	23
-	2	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1	1752373-4	DRAG	20
-	2	2	2	1901259-7	GUIDE, LOWER STRIP	18
-	1	1	1	2-240641-0	SPACER	16
-	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	240833-6	PLATE, REAR SHEAR	11
-	2	2	2	7-240645-4	SPACER, SHEAR PLATE	10
-	1	1	1	240642-1	PLATE, FRONT SHEAR	9
-	1	1	1	3-1803001-9	ANVIL, COMBINATION, END FEED	8
-	1	1	1	9-240651-2	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	240641-4	SPACER	5
-	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	2-1803016-9	CRIMPER, INSULATION F	3
-	1	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	1	409414-3	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	BY	APPV	NAME
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.13	14JAN2014	X. ZHAO	L. ZHANG	TE Connectivity Harrisburg, PA 17105-3608
	3 PLC ±.013	4 PLC ±.0001	ANGLES ±.1	14JAN2014	T. ELBIN		Ocean End Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
			1:1	A1	00779	©=2150408	

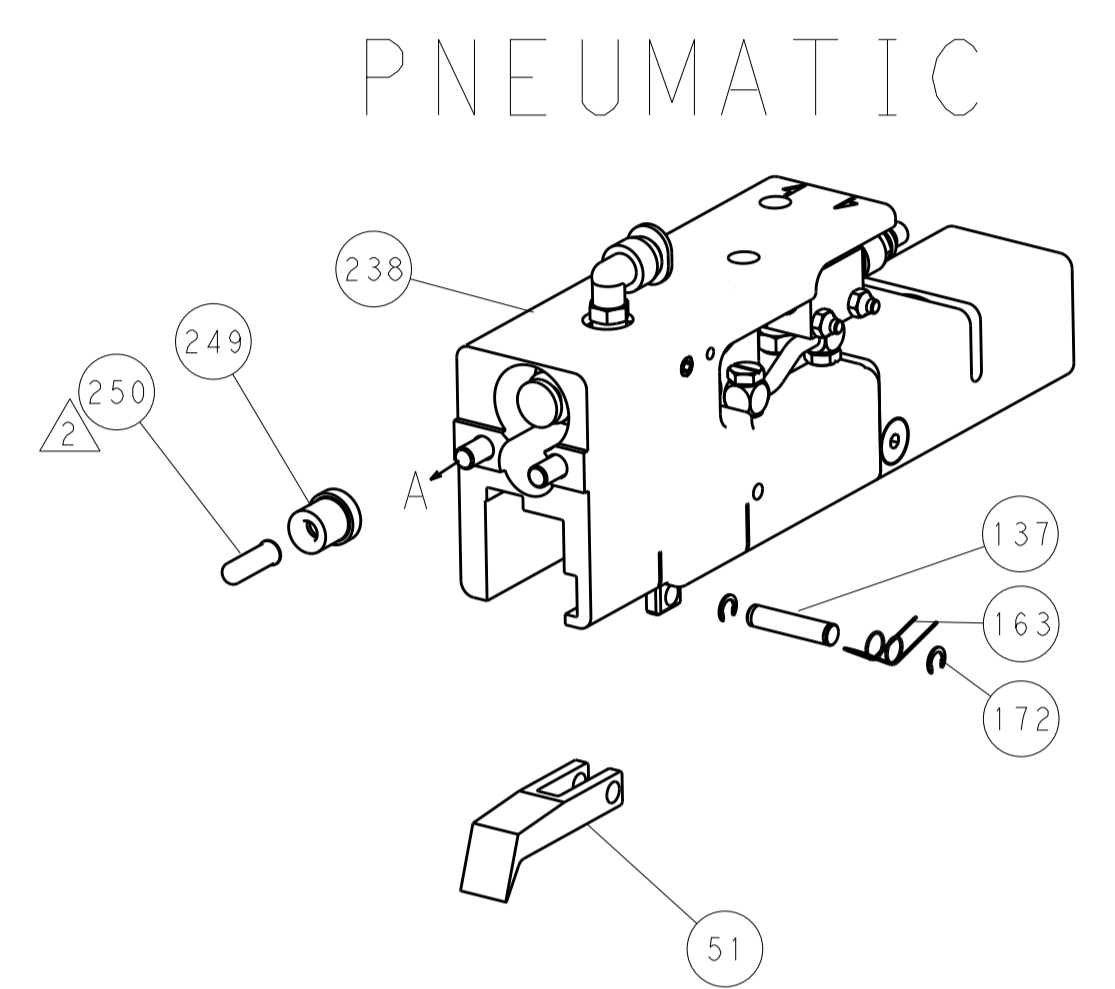
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



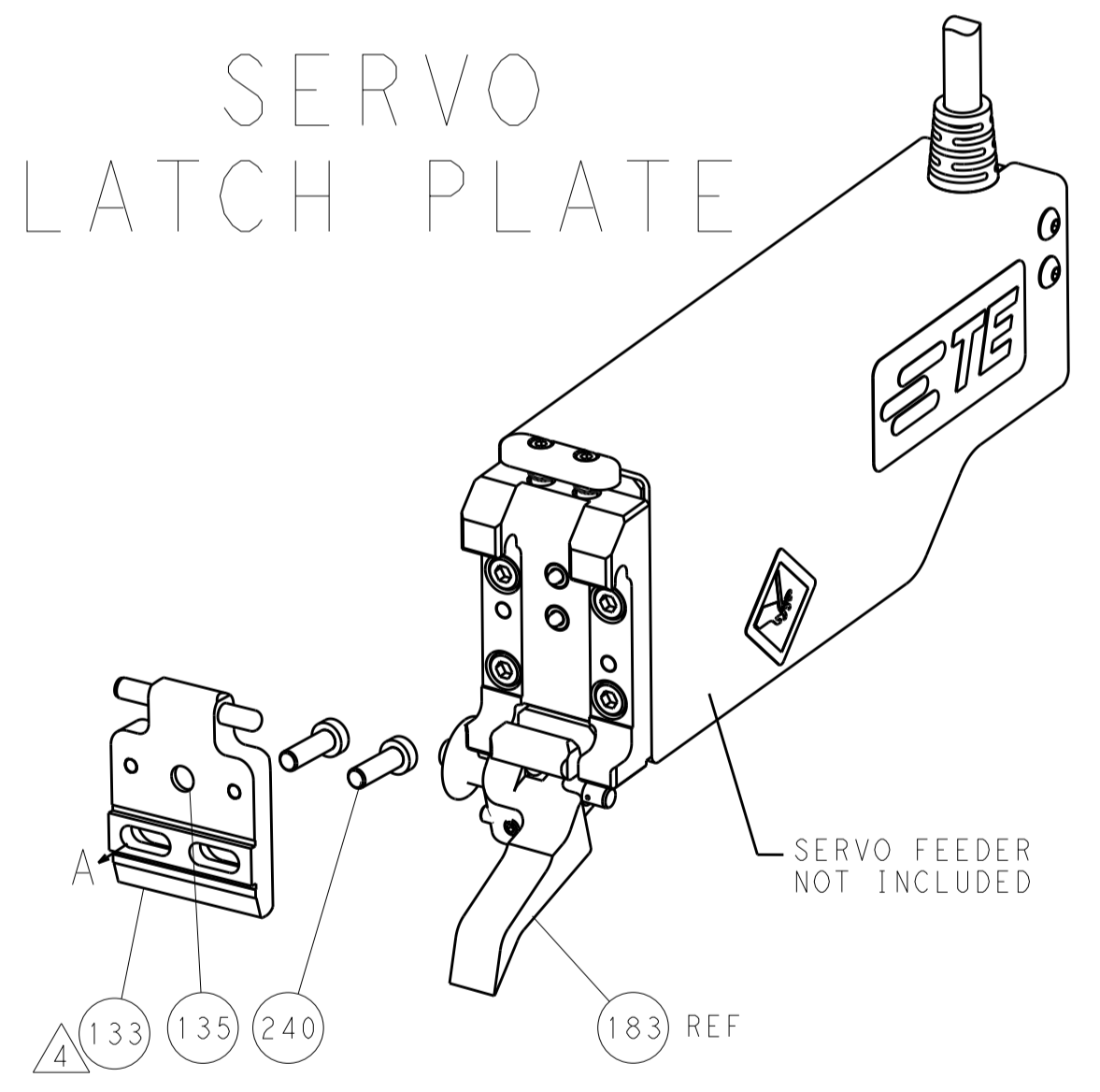
HOLDDOWN SET-UP



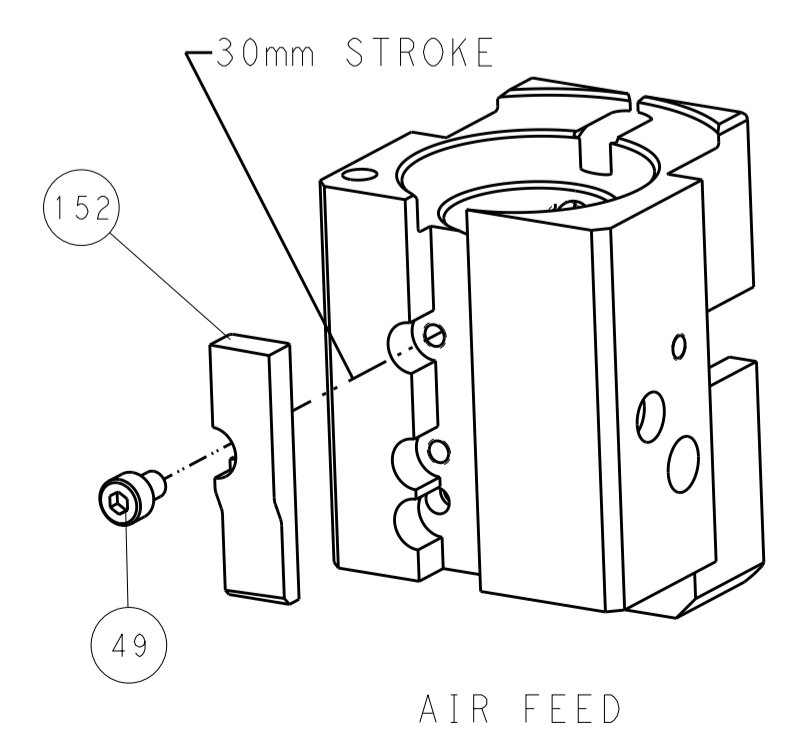
FEED TYPE



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: X.ZHAO 14JAN2014 CHK: L.ZHANG 14JAN2014 APVD: T.FELBIN 14JAN2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.0001		PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:1	NAME: Ocean End Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150408 SHEET 4 OF 4 REV A
MATERIAL: - FINISH: -		RESTRICTED TO: - Customer Accessible Production Drawing	