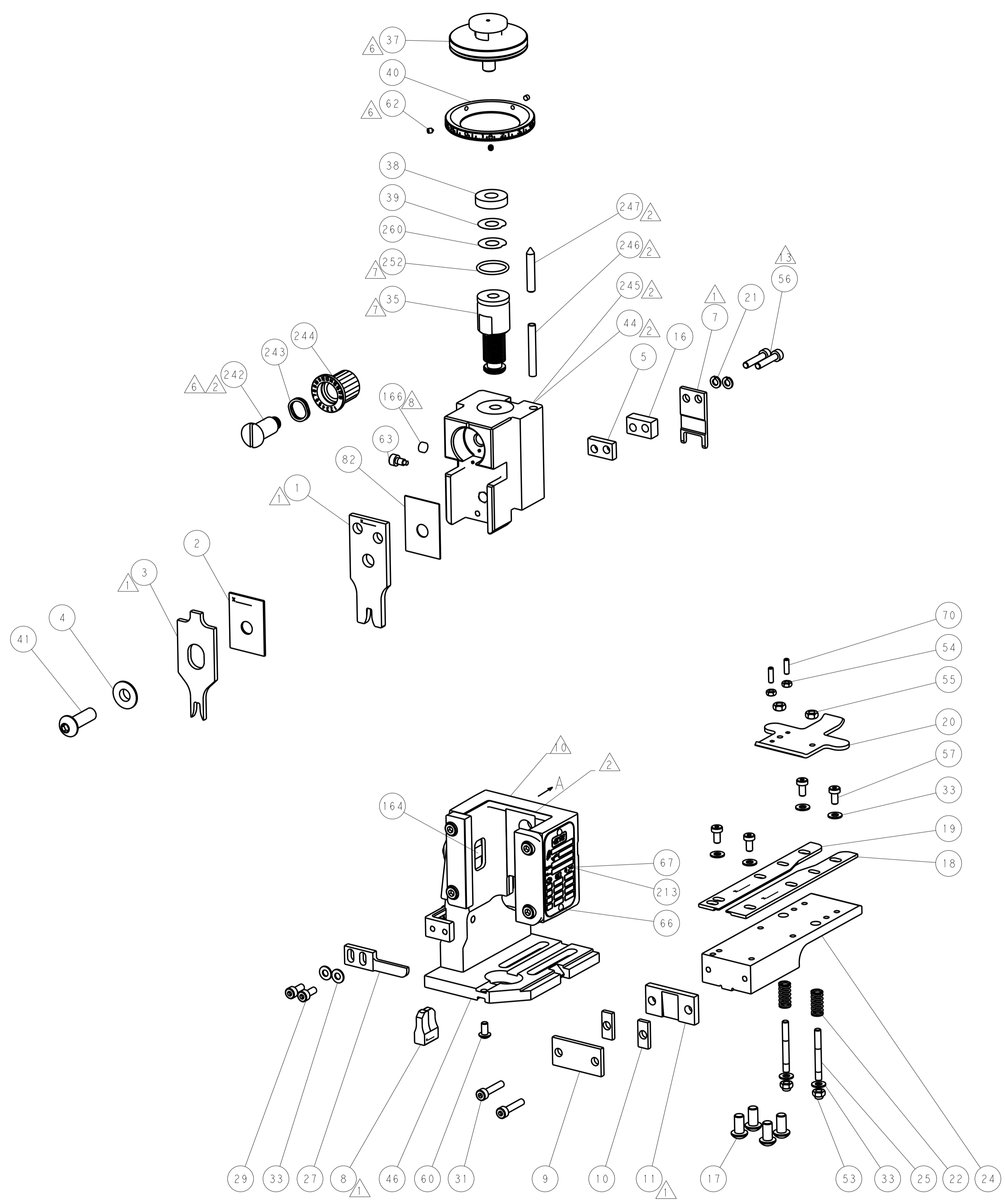
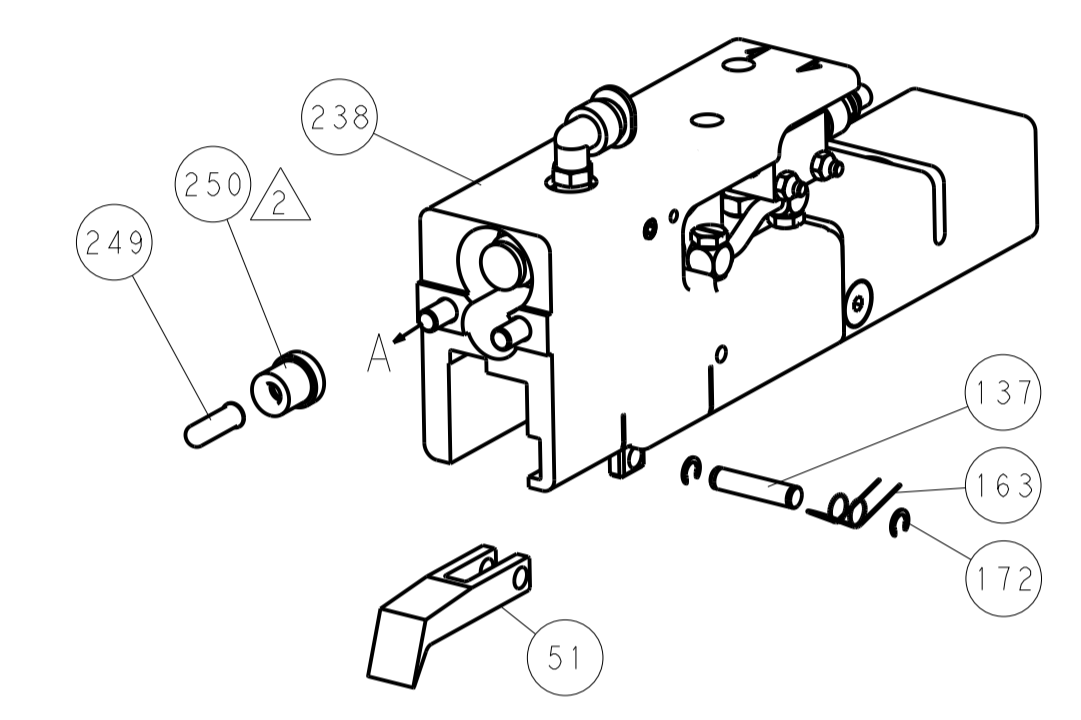


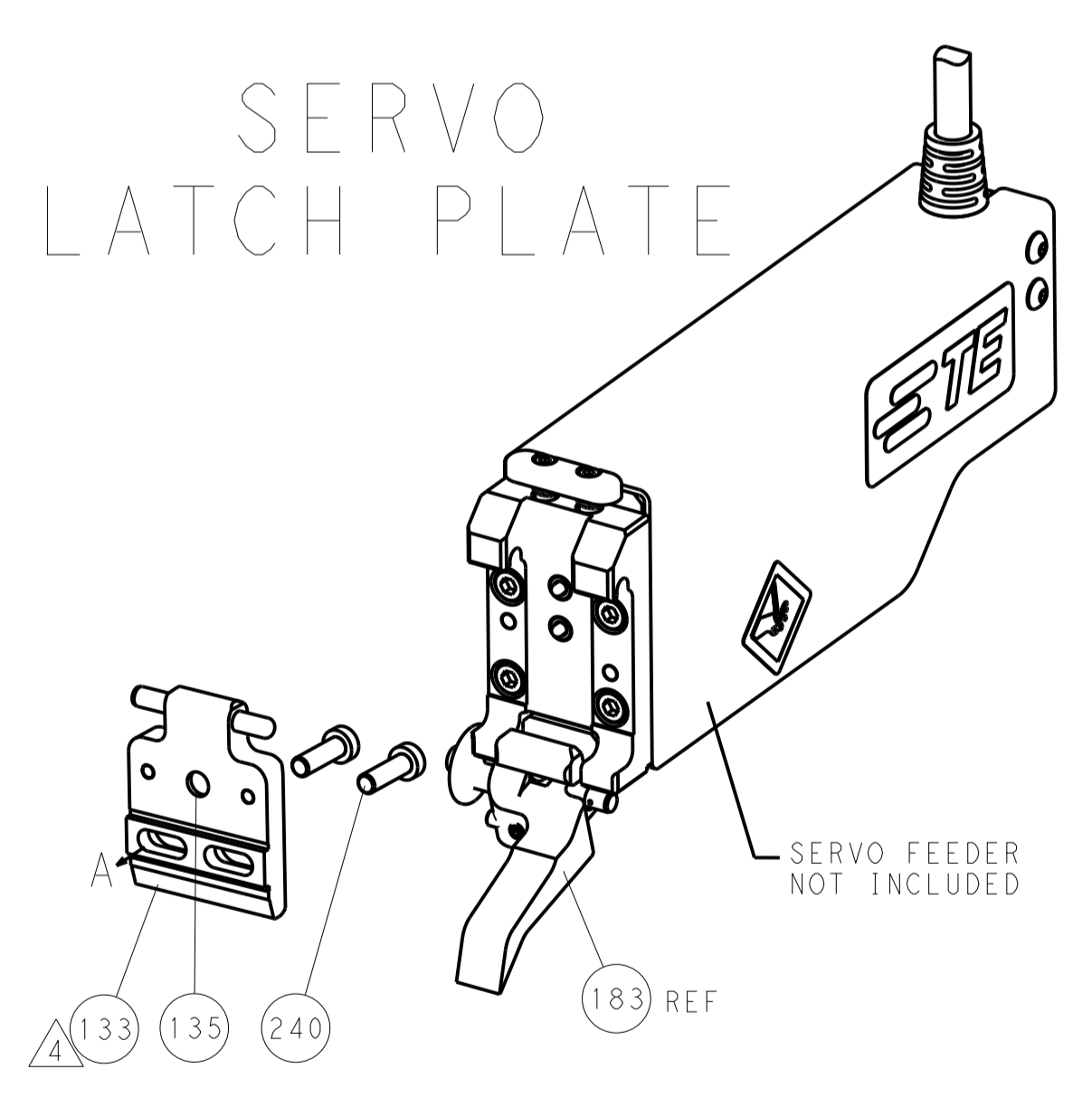
LOC	DIST	REV	DATE	BY	APPV
A	66				



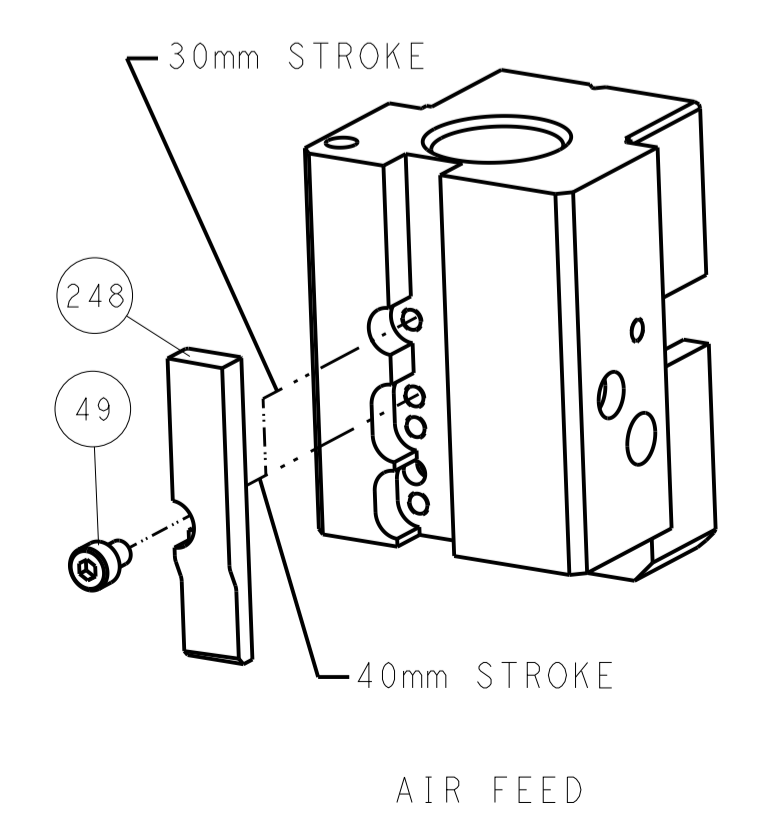
FEED TYPE
PNEUMATIC



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		DWN L. ZHANG 10OCT2012 CHK L. ZHANG 10OCT2012 APVD S. XI 10OCT2012		NAME Ocean End Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150296	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 2 OF 4 REV C	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150296-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE SMART APPLICATOR	2119951-1	1901697-1	8-2150296-5	-	-	2168400-7 (QUANTITY 2)
	2-2150296-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-2
	2-2150296-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150296-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RINGTONGUE WITH INS SUPPORT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.80-5.60 mm [.189-.220 IN]		∅2.54-3.81 mm [.100-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160789-2	160789-3	160789-5	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.29 +/- 0.05 [.090 +/- .002]	4.4
2.00mm2	2.18 +/- 0.05 [.086 +/- .002]	5.7
1.50mm2	2.06 +/- 0.05 [.081 +/- .002]	7.0
1.00mm2	1.96 +/- 0.05 [.077 +/- .002]	8.0

- 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: 8-2150296-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150296-5
- 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 & 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.

***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)

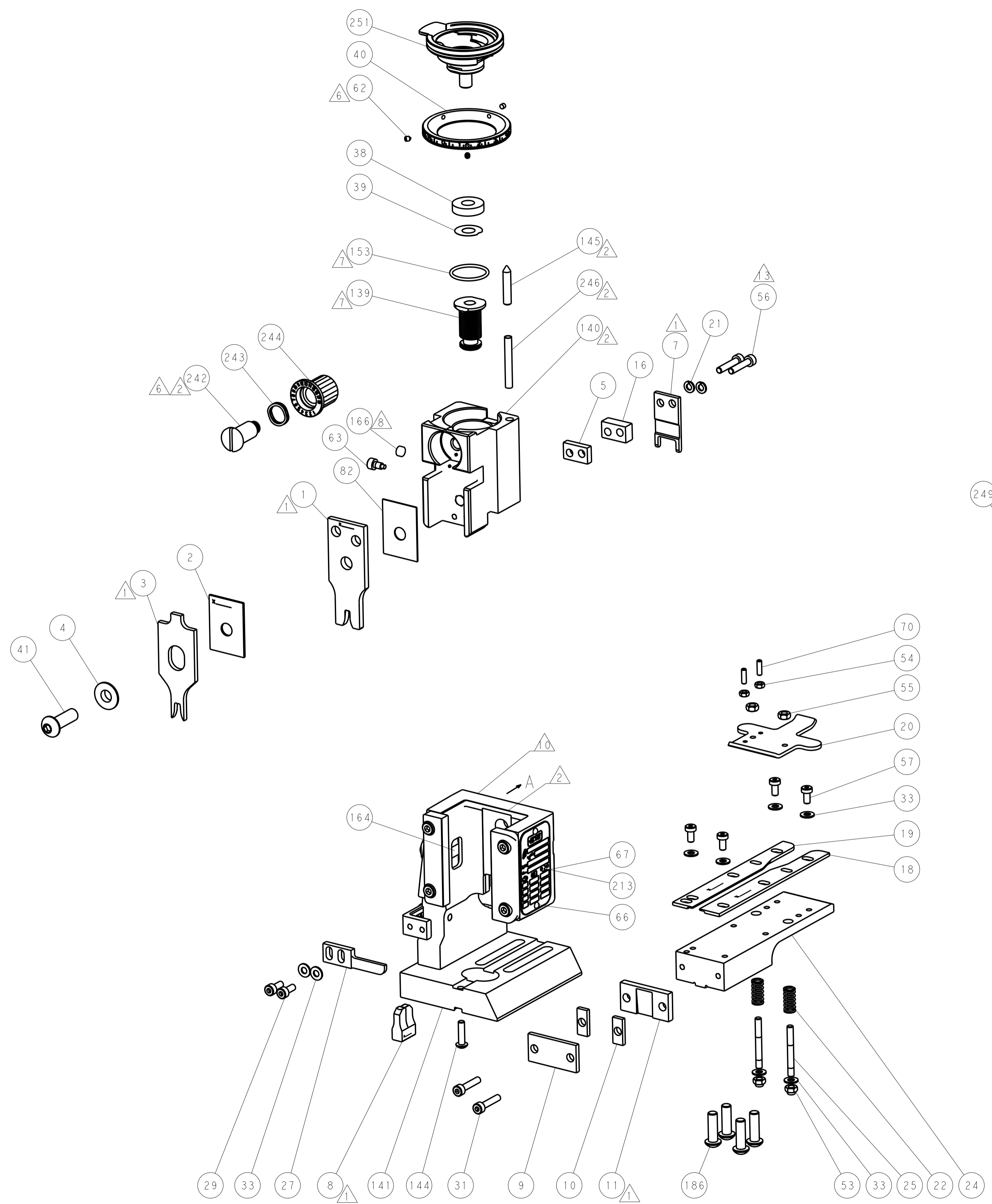
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

-	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	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	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
-	-	-	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	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	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
-	8	8	8	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	1752371-1	PLATE, STRIP GUIDE	24
-	2	2	2	3-22281-8	SPRING, COMPRESSION	22
-	2	2	2	18025-2	WASHER, SPRG LOCK, REG M4	21
-	1	1	1	1752373-1	DRAG	20
-	1	1	1	2-1901696-7	STRIP GUIDE, REAR	19
-	1	1	1	2-1901695-7	STRIP GUIDE, FRONT	18
-	1	1	1	7-240641-5	SPACER	16
	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	2	2	1-240645-2	SPACER, SHEAR PLATE	10
	-	1	1	240642-1	PLATE, FRONT SHEAR	9
	1	1	1	1333222-8	ANVIL, COMBINATION	8
	-	1	1	2-240651-1	BLADE, SLUG	7
	-	1	1	1-240641-0	SPACER	5
	-	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
	1	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1-455888-0	SPACER, CRIMPER	2
	1	1	1	456411-9	CRIMPER, WIRE PREMIUM	1

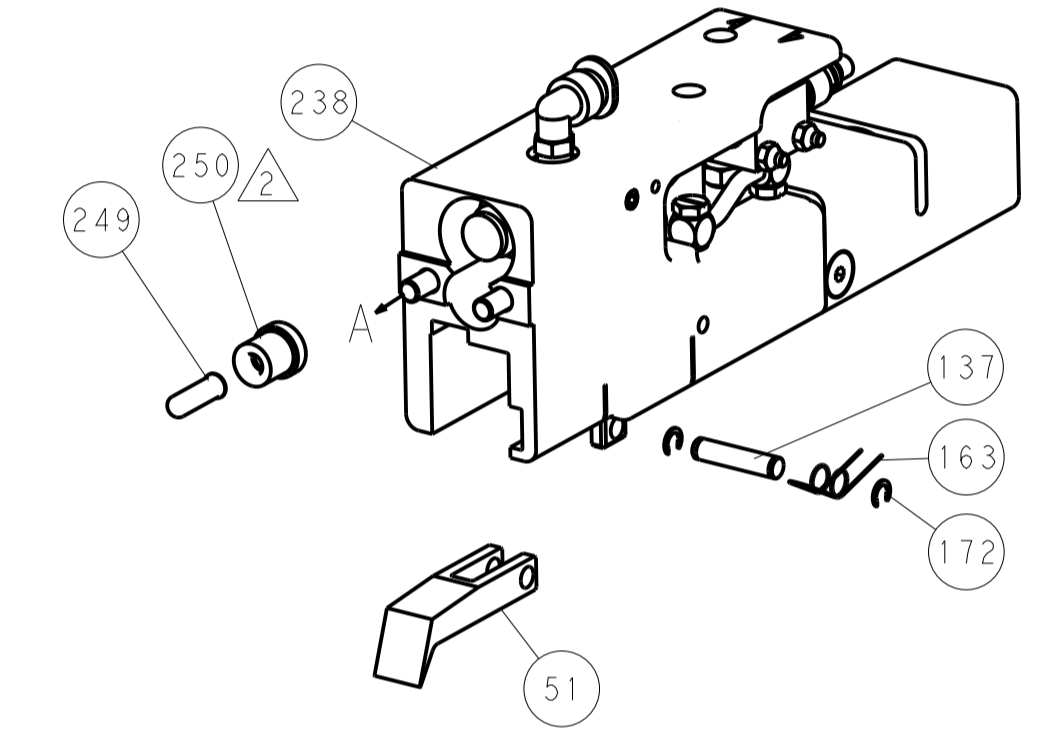
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APPV		NAME	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.13	3 PLC ±.013	4 PLC ±.0001	ANGLES ±.0001	FINISH	DATE	10OCT2012	DATE	10OCT2012
MATERIAL		FINISH		SCALE		SHEET		3		OF	
Customer Accessible Production Drawing		SCALE		1:1		SHEET		3		OF	

LOC	DIST	REV	DATE	BY	APPV
A	66				

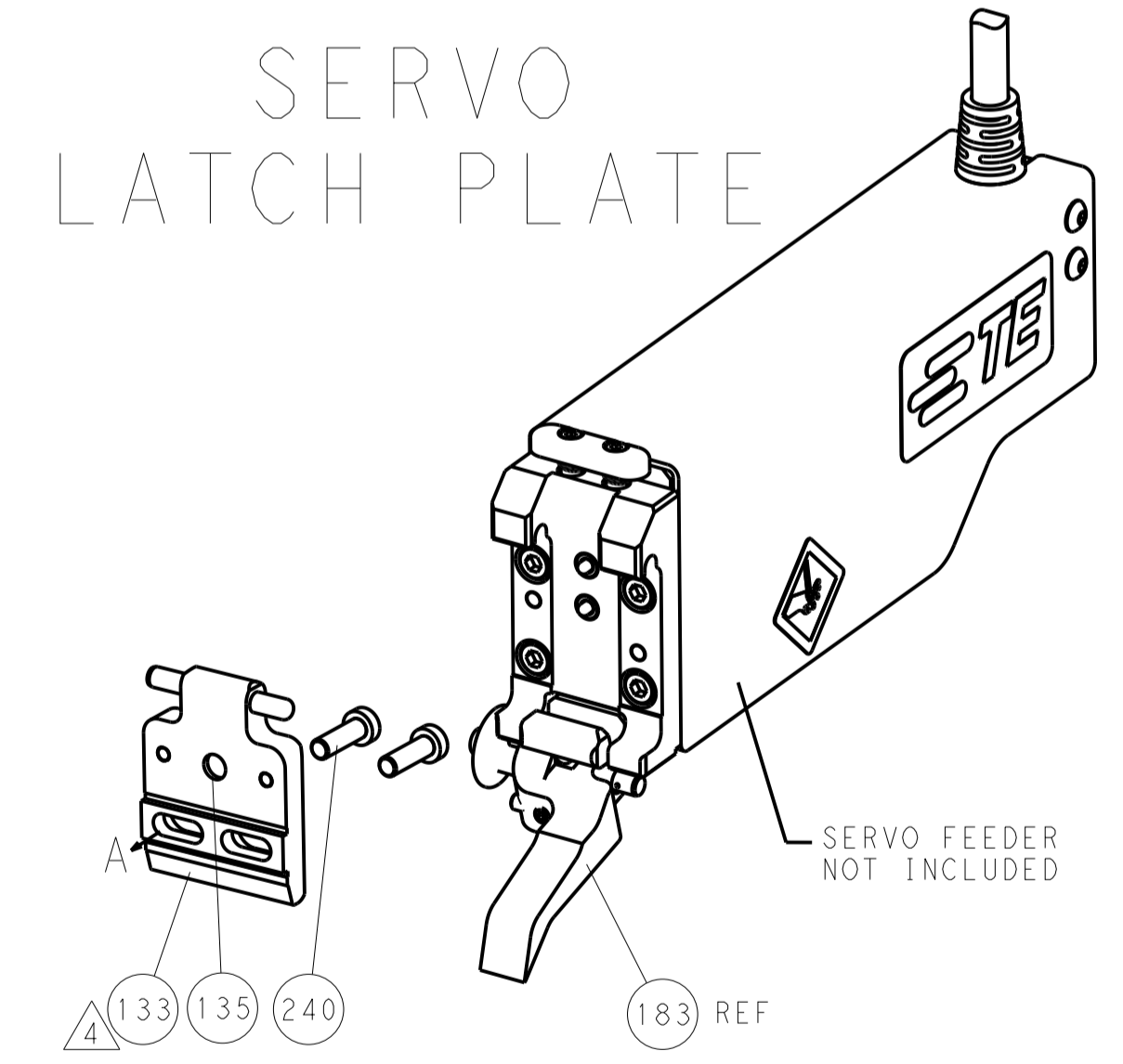
REVISIONS			
REV	DATE	BY	APPV
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-	-	-	-



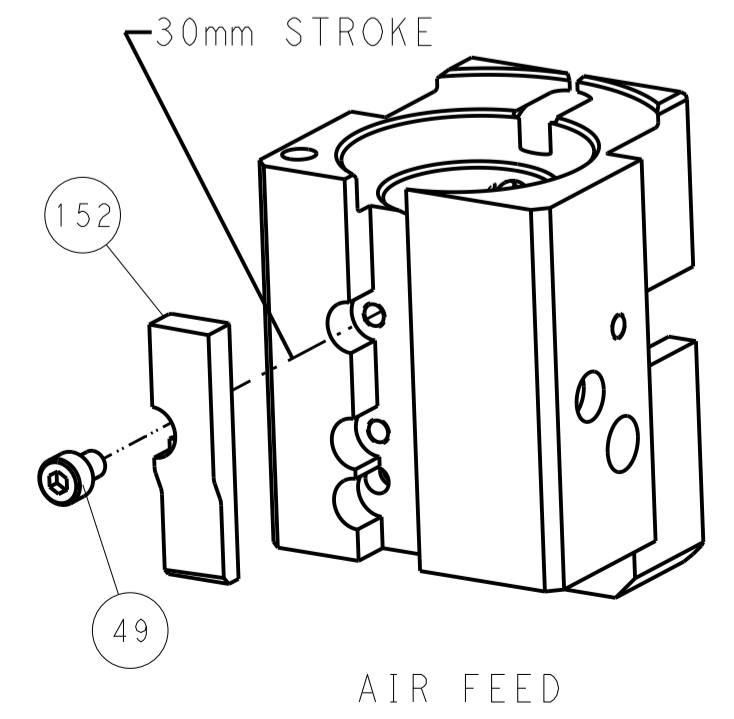
FEED TYPE
 PNEUMATIC



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. ZHANG 10OCT2012		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 S. XI 10OCT2012	NAME Ocean End Feed Applier
MATERIAL:		FINISH:		WEIGHT:		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150296	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 4 OF 4 REV C	