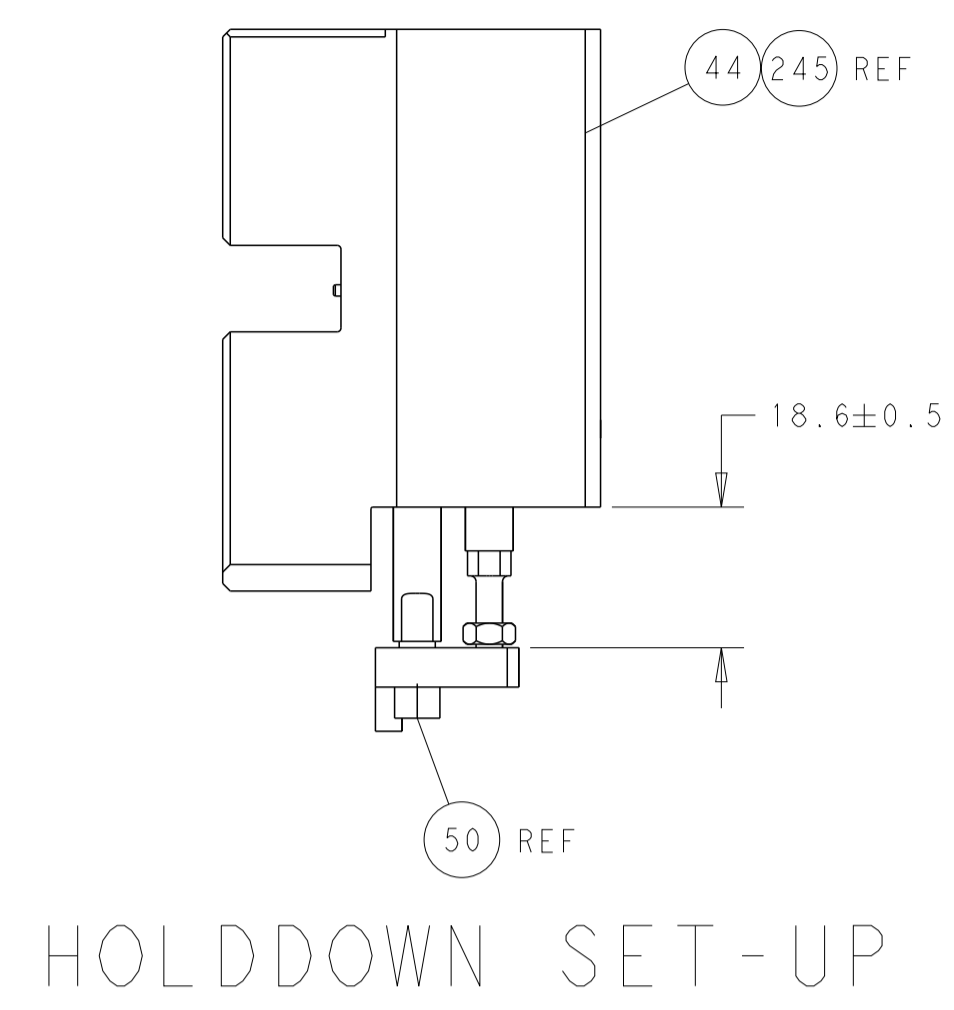
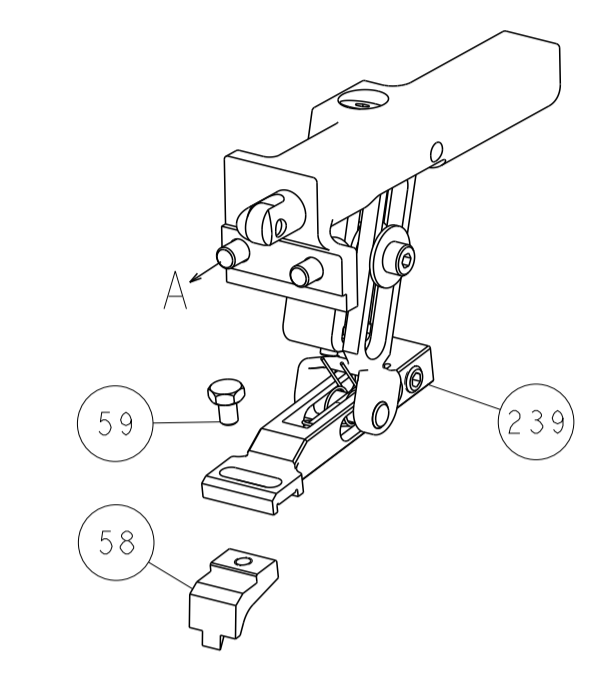


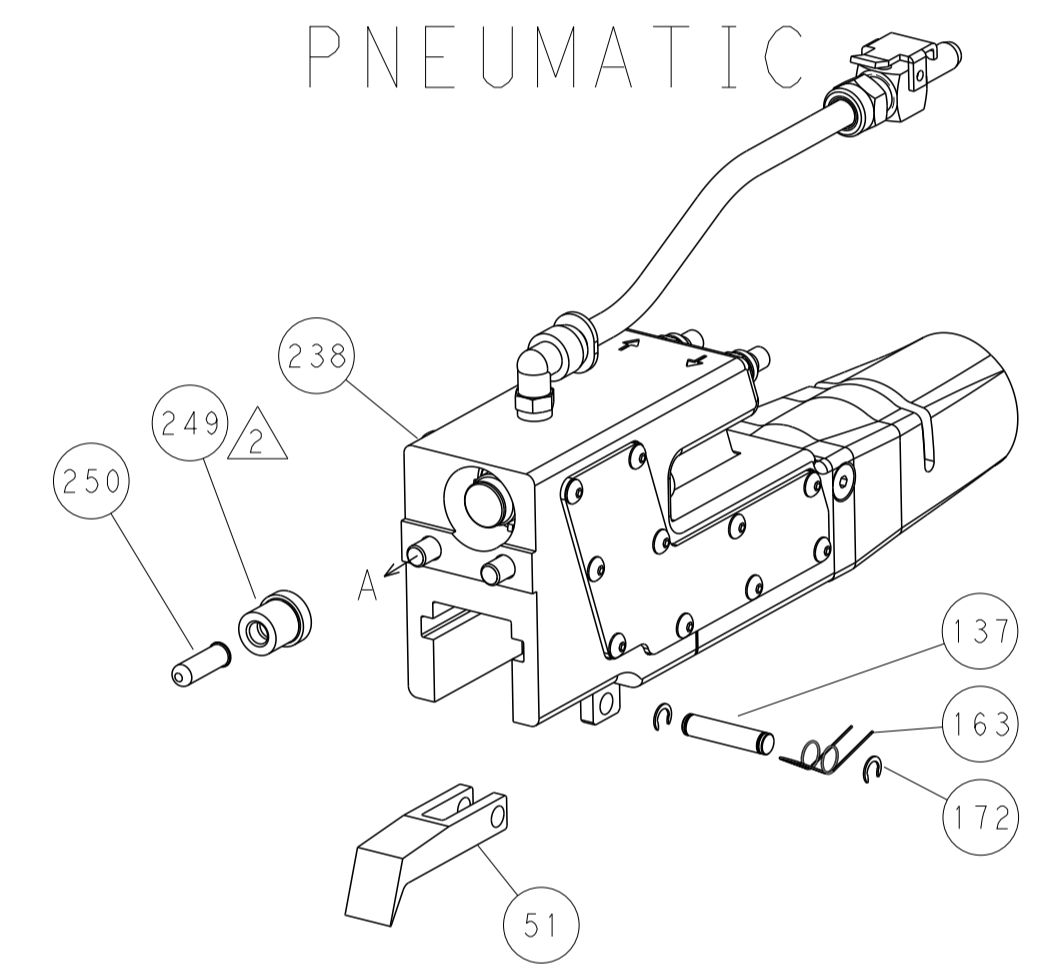
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



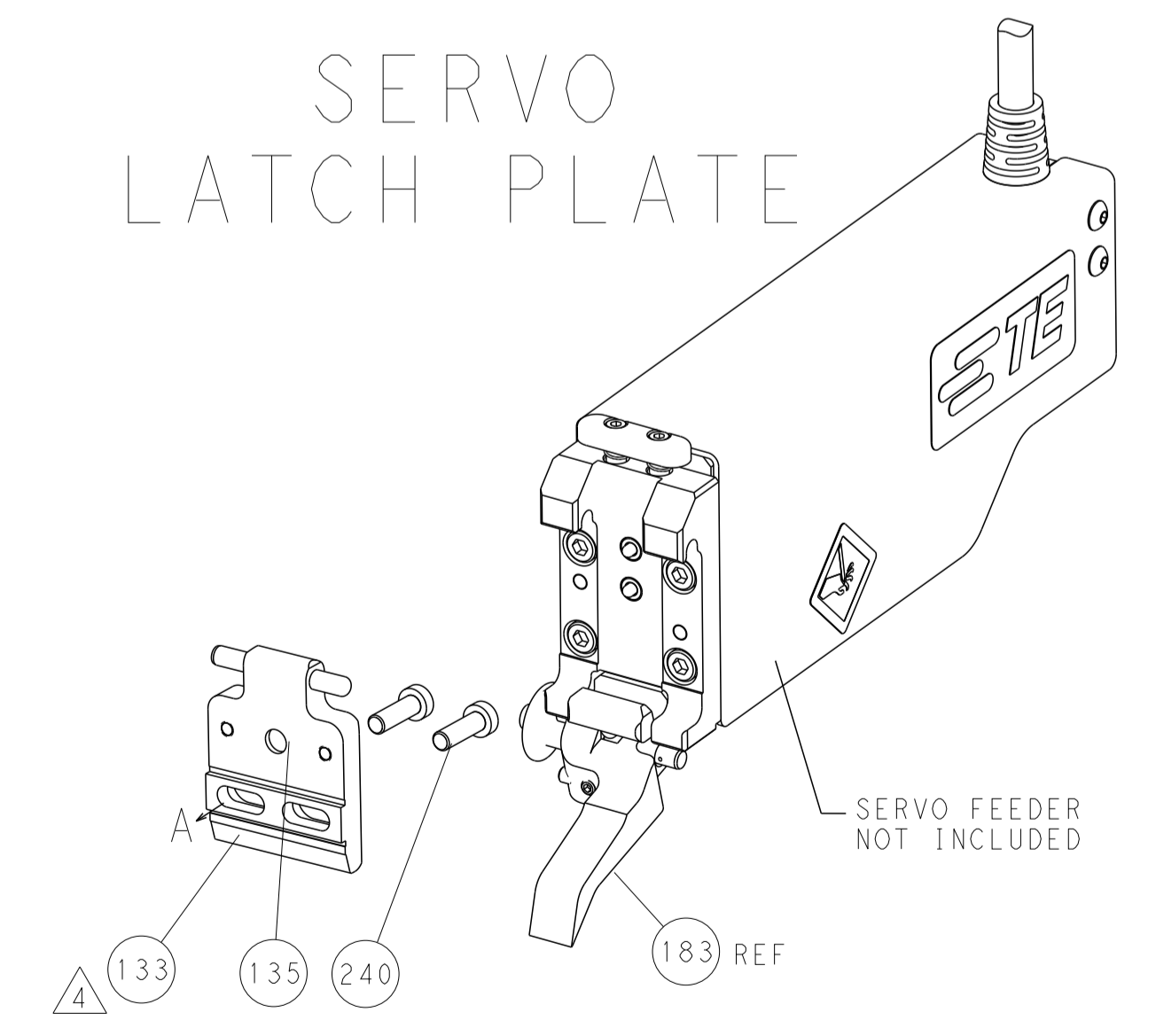
FEED TYPE
MECHANICAL



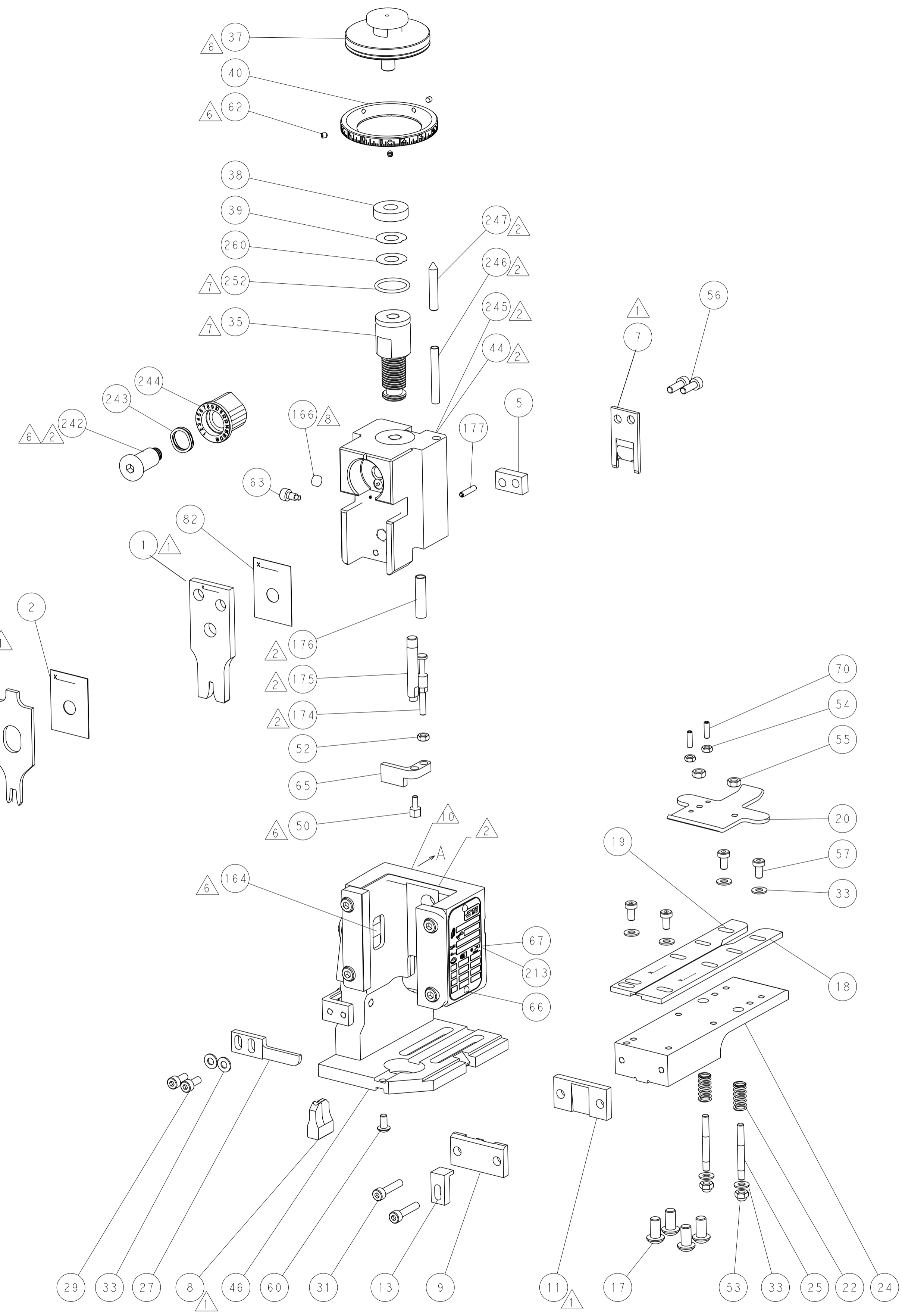
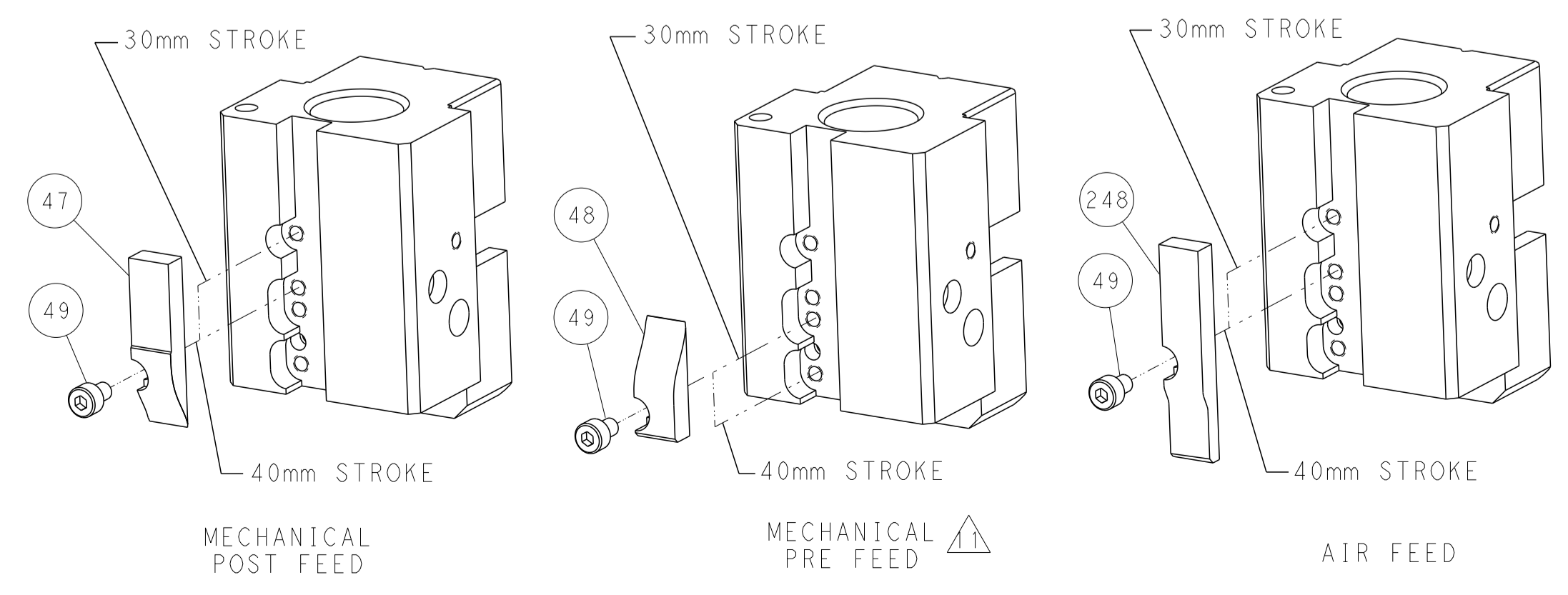
PNEUMATIC



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:		OWN	K. STAKEM	13FEB2013	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	T. ELBIN	13FEB2013	
MATERIAL:		FINISH:		APVD	G. RILEY	13FEB2013	NAME
				PRODUCT SPEC			Ocean End Feed Applicator
				APPLICATION SPEC			SIZE
				WEIGHT			CAGE CODE
				Customer Accessible Production Drawing			DRAWING NO
				SCALE			RESTRICTED TO
				1:1			REV
				SHEET 2 OF 4			B

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO		PART NUMBERS REQUIRED			
					PNEUMATIC FEED	SERVO LATCH PLATE	SMART APPLICATOR	MECHANICAL FEED	SERVO LATCH PLATE	SMART APPLICATOR
	2-2150257-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150257-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	2119951-1	1901697-1	8-2150257-5	-	-	2168400-7 (QUANTITY 2)
					2161326-1	-	8-2150257-4	-	-	-
	2-2150257-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119949-1	2063961-3	5-18022-5	2119653-2	-	-
2-2150257-7	B	FINE CRIMP HEIGHT ADJUST	NONE	2119951-1	1901697-1	8-2150257-5	-	-	2168400-7 (QUANTITY 2)	
7-2150257-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.100 [2.54 mm]	F
INSUL	.180 [4.57 mm]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.207-.223 IN [5.27-5.65 mm]		Ø.080-.120 IN [2.03-3.05 mm]	
TERMINAL APPLICATION SPECIFICATION		TERMINALS APPLIED	
114-2084			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
640271-1	640271-3	640204-1	640204-2
640204-3	640271-4	1217018-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.75 +/- 0.05 [0.069 +/- .002]	9.6
20 AWG	1.65 +/- 0.05 [0.065 +/- .002]	10.8
22 AWG	1.60 +/- 0.05 [0.063 +/- .002]	11.4

- 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:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150257-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150257-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150257-5
- 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 ITEM 62.
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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 2119653-2. 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.

-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO
- 1 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	1-22279-3	SPRING, COMPRESSION	246
- 1 1 1 1 1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244

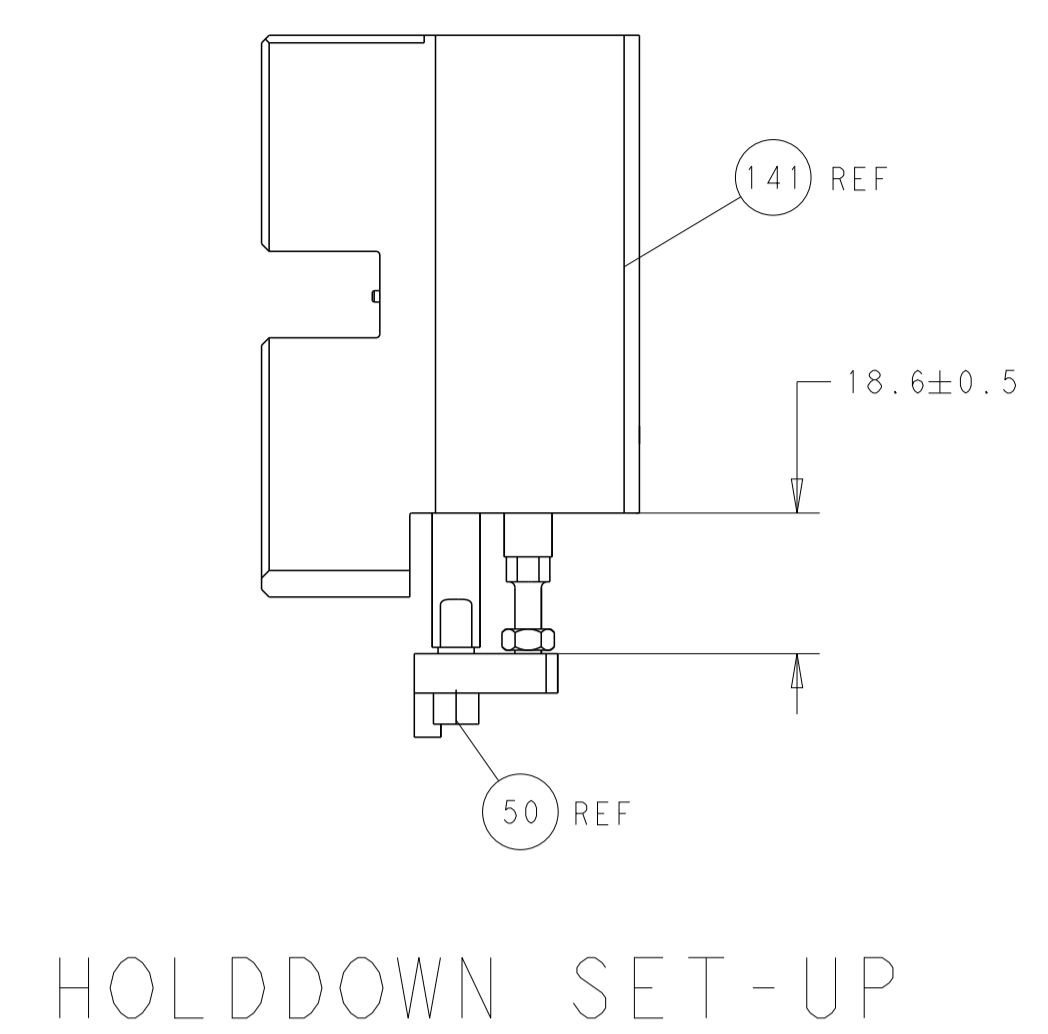
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-		SEE SHEET 1	-	-	-

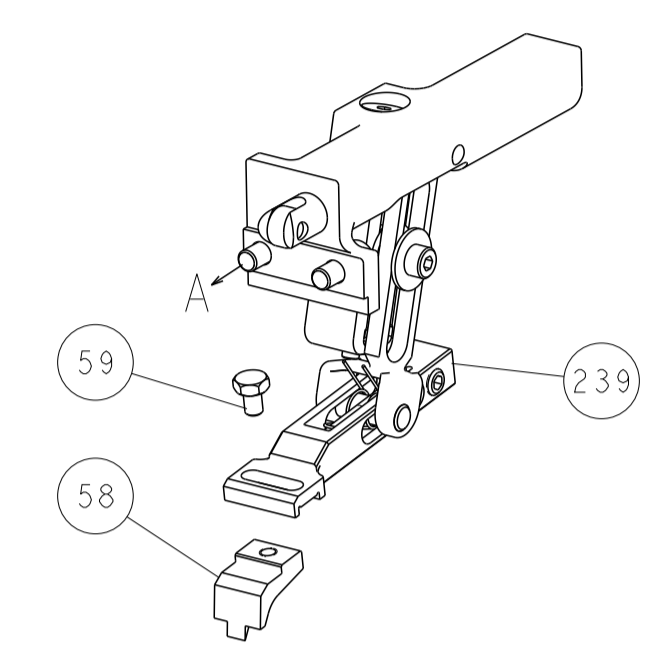
P	LTN	DESCRIPTION	DATE	OWN	APVD
- 1 1 1 1 1		2079764-1			243
- 1 1 1 1 1		2119083-1			242
- - 2 - -		2168400-7			240
- - - - 1		2119580-1			239
- - - 1 -		2063440-1			238
- - 1 - -		2119740-2			213
- 4 4 4 4		2079383-9			186
- REF - -		1901697-1			183
- 1 1 1 1		6-993111-6			177
- 1 1 1 1		8-22280-7			176
- 1 1 1 1		1752353-2			175
- 1 1 1 1		1901680-2			174
- - - 2 -		21045-3			172
- 1 1 1 1		994969-1			166
- REFREFREFREF		994970-2			164
- - - 1 -		240638-1			163
- 1 1 1 1		8-21084-1			153
- - - 1 -		2119641-2			152
- 1 1 1 1		2119798-2			145
- 1 1 1 1		2079383-8			144
- - - - 1		2119653-2			142
- 1 1 1 1		2119655-6			141
- 1 1 1 1		2119651-1			140
- 1 1 1 1		2119092-2			139
- - - 1 -		3-23627-7			137
- REF - -		SEE NOTE 4			135
- - 1 - -		1633743-1			133
- 1 1 1 1		455888-2			82
- 1 1 1 1		2119956-2			71
- 2 2 2 2		2-18032-2			70
- 1 - 1 1		2119740-1			67
- 2 2 2 2		2168078-1			66
- 1 1 1 1		1901681-1			65
- 1 1 1 1		2119793-1			63
- 3 3 3 3		992763-5			62
- - - - 1		5-18022-5			59
- - - - 1		2063961-3			58
- 4 4 4 4		2168400-4			57
- 2 2 2 2		2168083-3			56
- 2 2 2 2		5018030-2			55
- 2 2 2 2		5018030-1			54
- 2 2 2 2		986965-8			53
- 1 1 1 1		1-5018030-0			52
- - - 1 -		2119792-2			51
- 1 1 1 1		1752354-3			50
- - - 1 2		18023-9			49
- - - - 1		2119652-1			48
- 1 1 1 1		2079383-7			41
- 1 1 1 1		2119645-1			40
- 1 1 1 1		2119957-1			39
- 1 1 1 1		2119644-2			38
- 8 8 8 8		1-18028-2			33
- 2 2 2 2		2168083-9			31
- 2 2 2 2		1-2168083-0			29
- 1 1 1 1		240639-1			27
- 2 2 2 2		1320906-1			25
- 1 1 1 1		1752371-5			24
- 2 2 2 2		2-22281-3			22
- 1 1 1 1		1752373-4			20
- 1 1 1 1		1-1901696-5			19
- 1 1 1 1		1-1901695-5			18
- 1 1 1 1		1752360-1			13
- 1 1 1 1		240644-9			11
- - - - -		-			10
- 1 1 1 1		690496-7			9
- 1 1 1 1		1-1803000-6			8
- 1 1 1 1		2217206-4			7
- - - - -		-			6
- 1 1 1 1		6-240641-5			5
- 1 1 1 1		1-238009-0			4
- 1 1 1 1		2-1633961-7			3
- 1 1 1 1		455888-4			2
- 1 1 1 1		2-456407-5			1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	CHK	STAKEM	DATE	NAME
mm	0 PLC ±	1 PLC ±	2 PLC ±	13FEB2013	T. ELBIN	13FEB2013		TE Connectivity Harrisburg, PA 17105-3608
	3 PLC ±	4 PLC ±	ANGLES ±	13FEB2013	G. RALLEY	13FEB2013		Ocean End Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:	
			1:1	A1	00779	2150257		

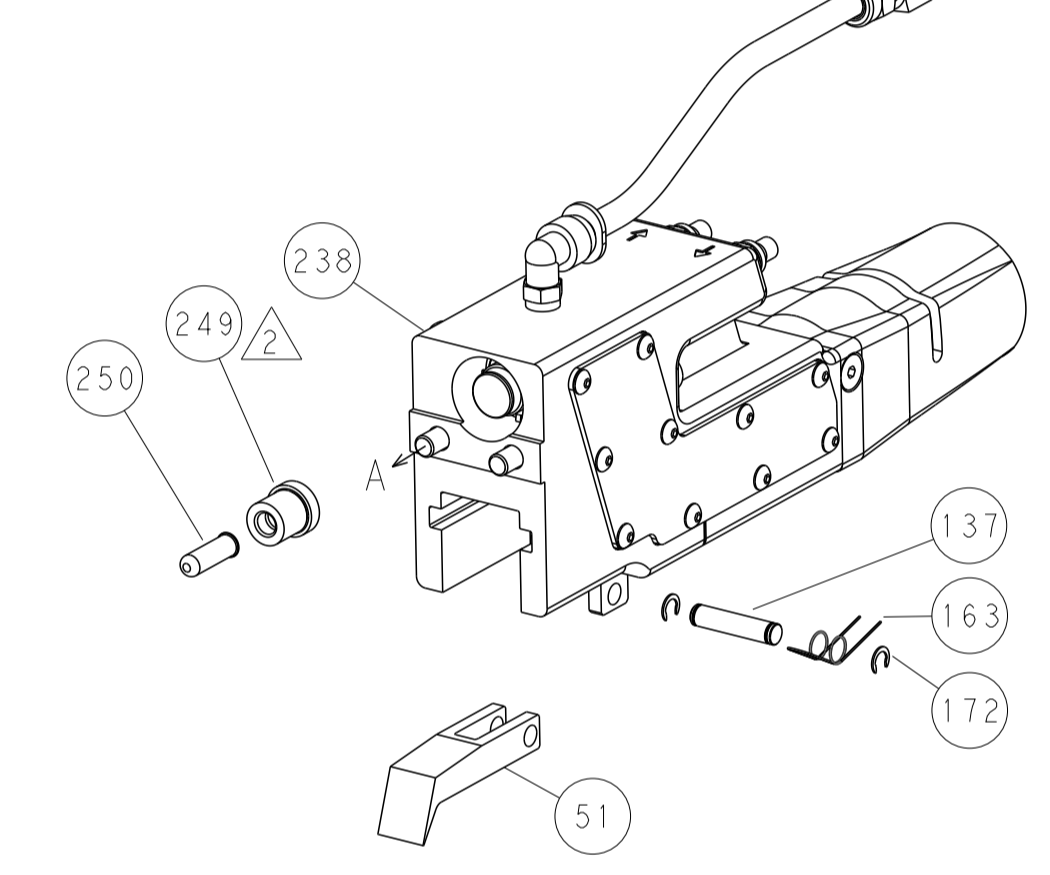
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



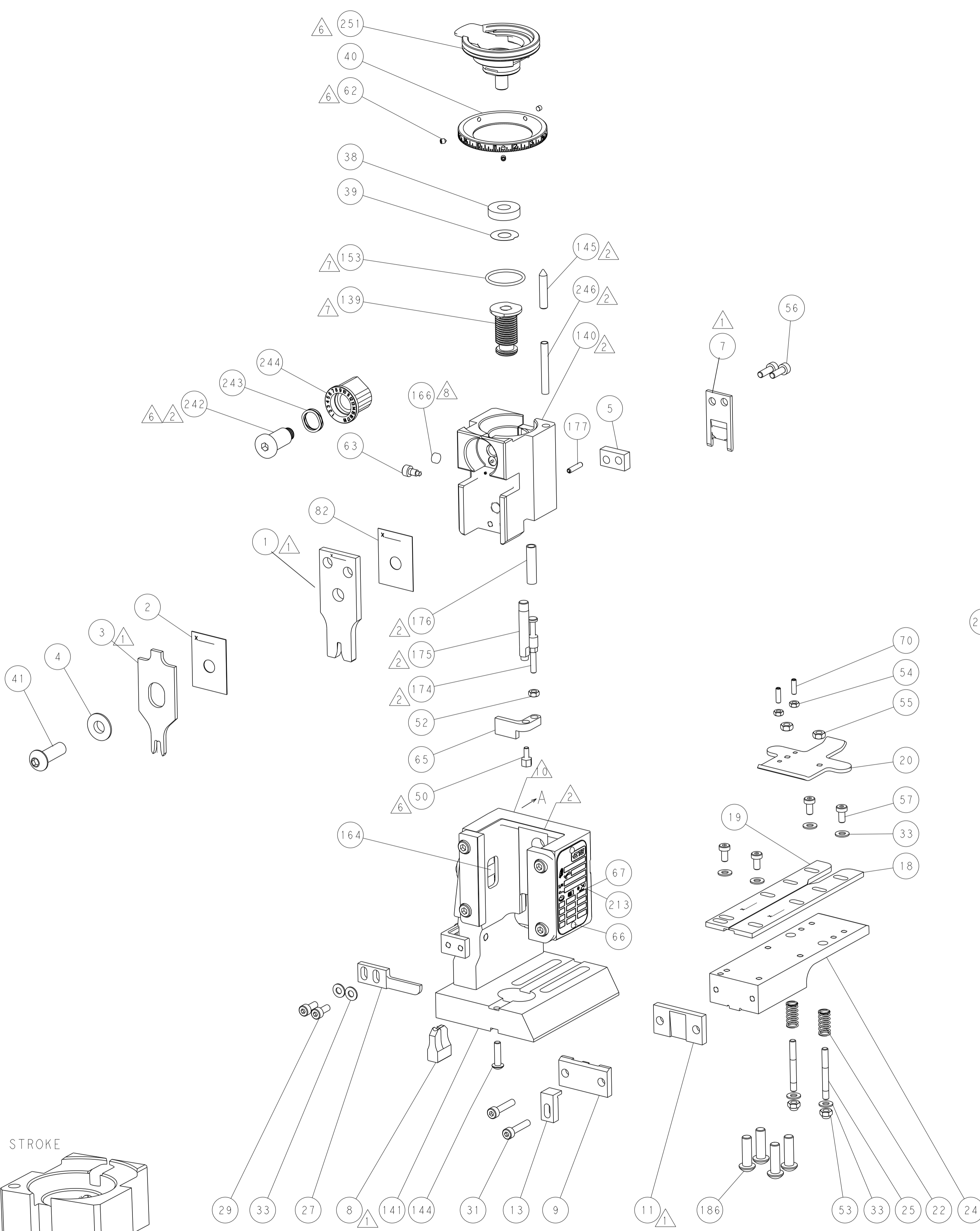
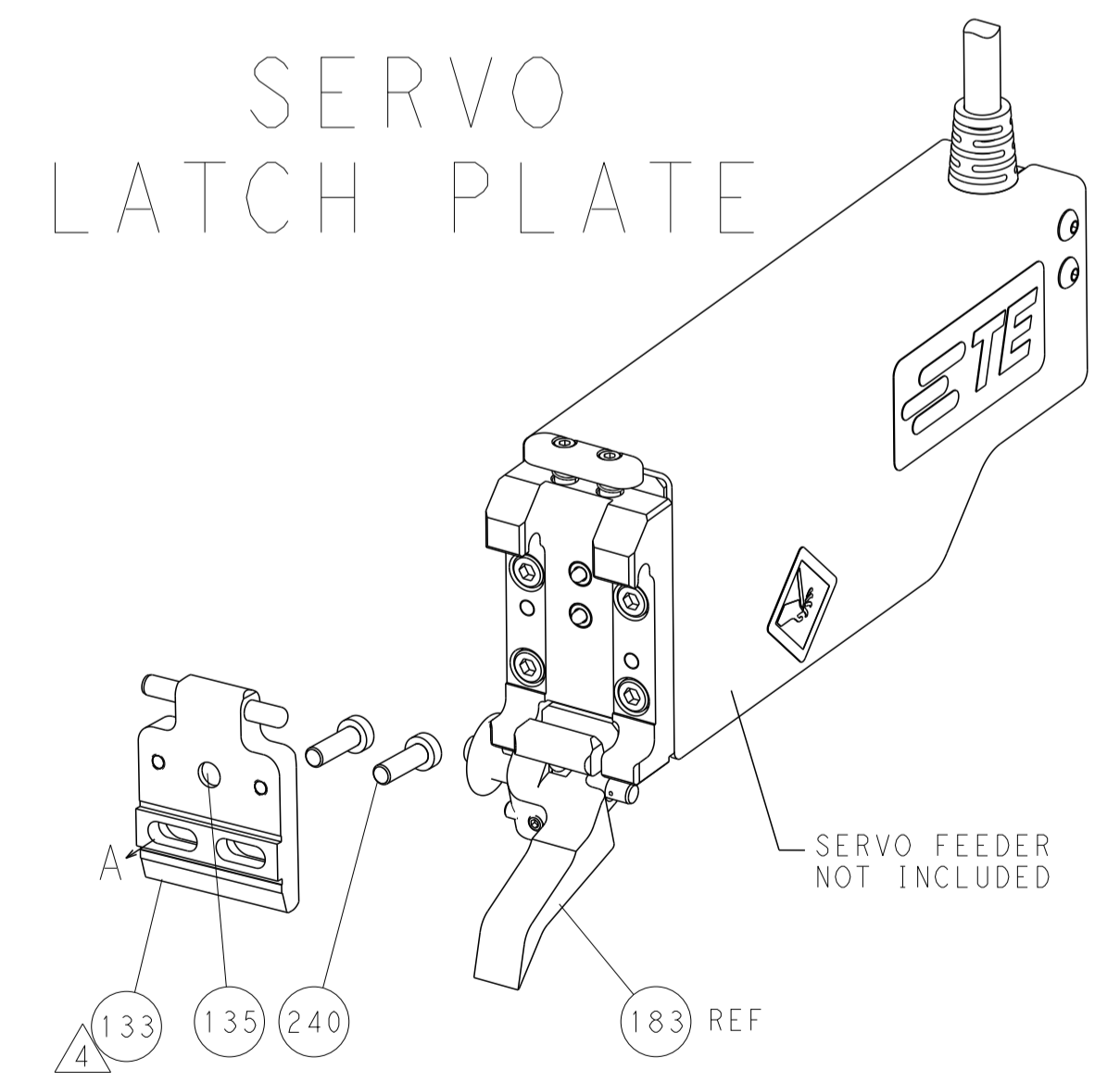
FEED TYPE
MECHANICAL



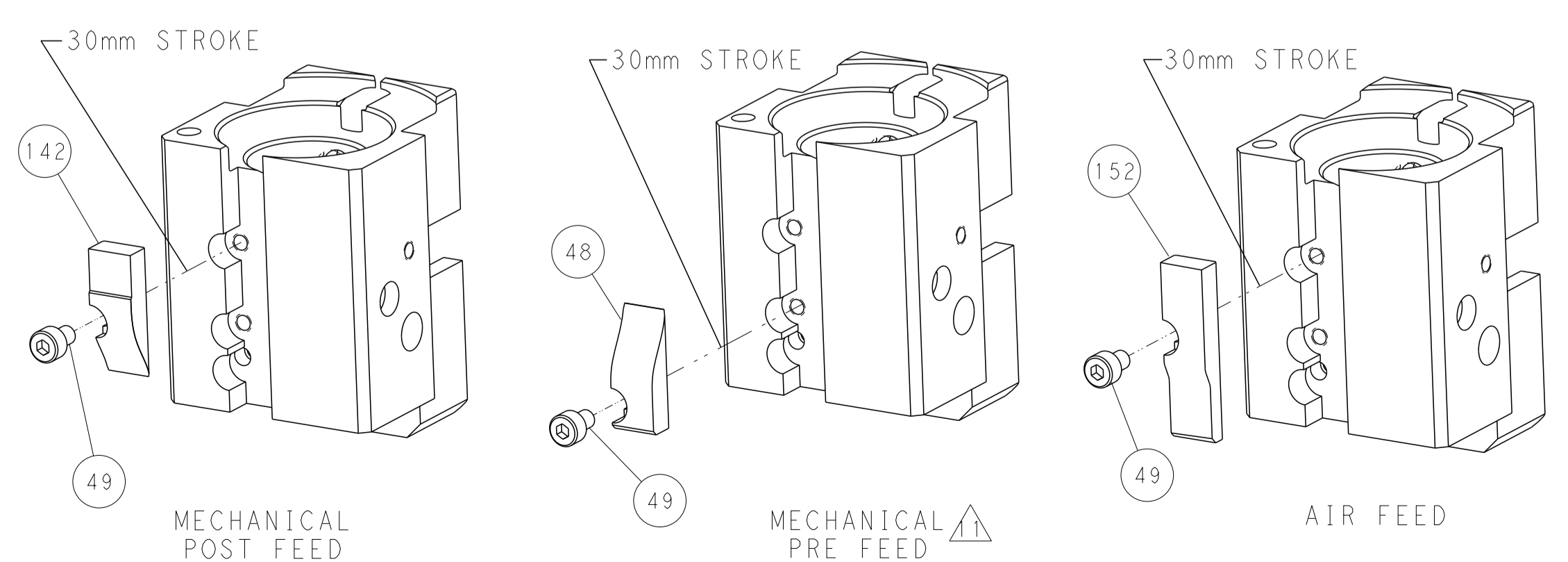
PNEUMATIC



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:		DWG: H. STAKEM 13FEB2013		CHK: T. ELBIN 13FEB2013		APVD: G. BAILEY 13FEB2013		NAME: Ocean End Feed Applier	
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	STE TE Connectivity Harrisburg, PA 17105-3608			
	1 PLC	±		SCALE	00779	©=2150257		Customer Accessible Production Drawing			
	2 PLC	±		SCALE	1:1	SHEET 4 OF 4	REV B				
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									
	FINISH	±									