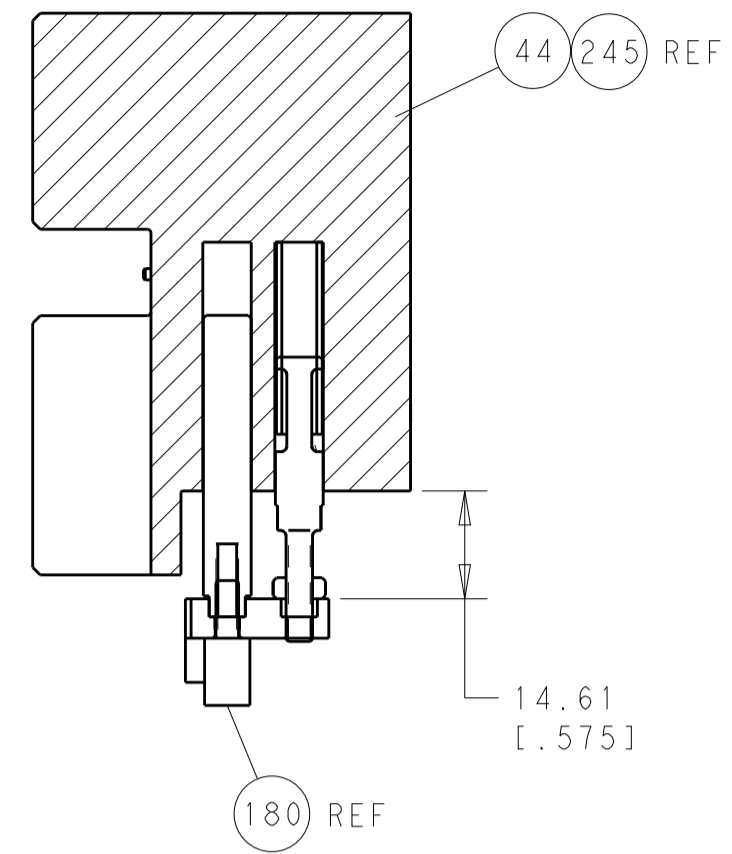
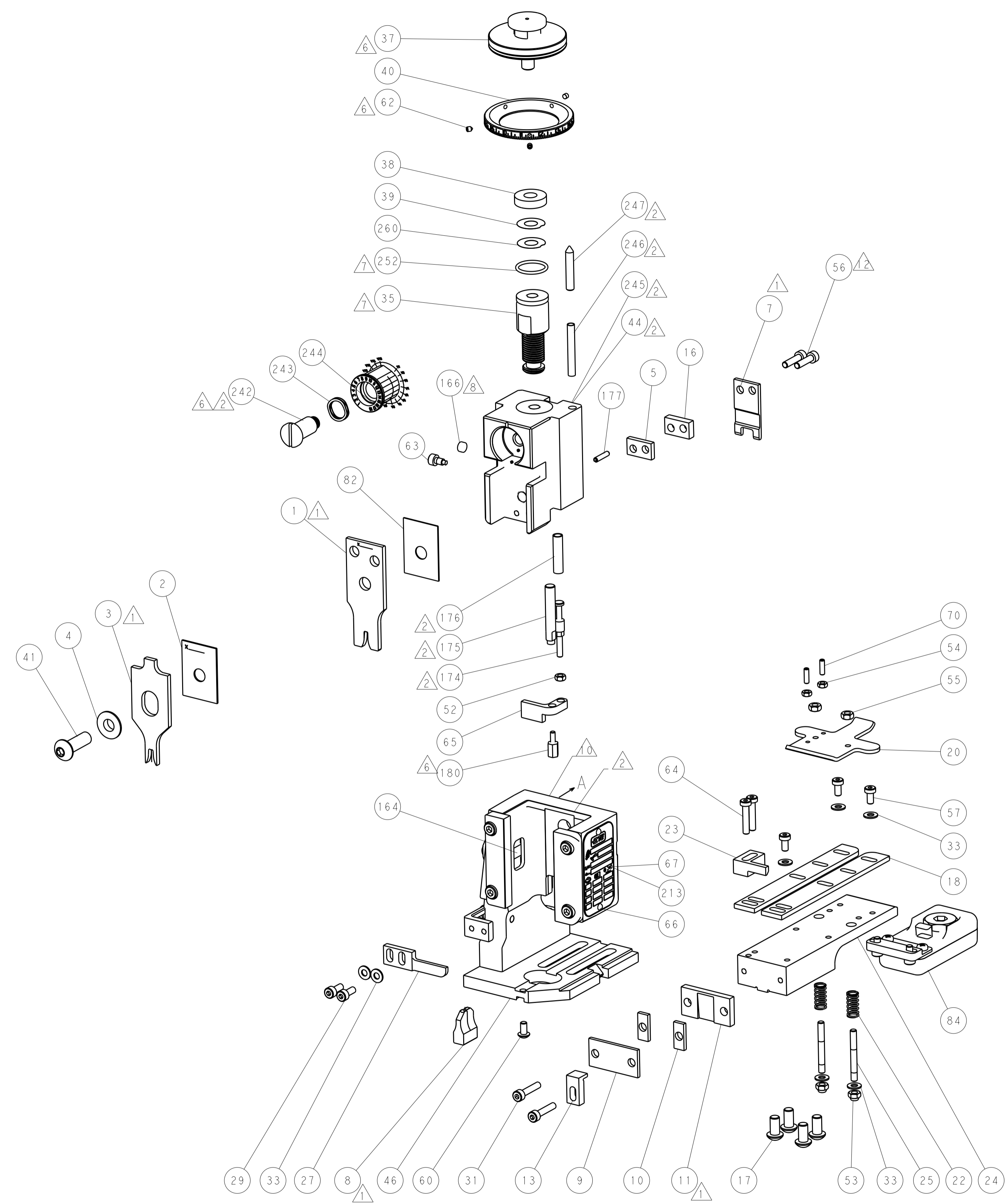




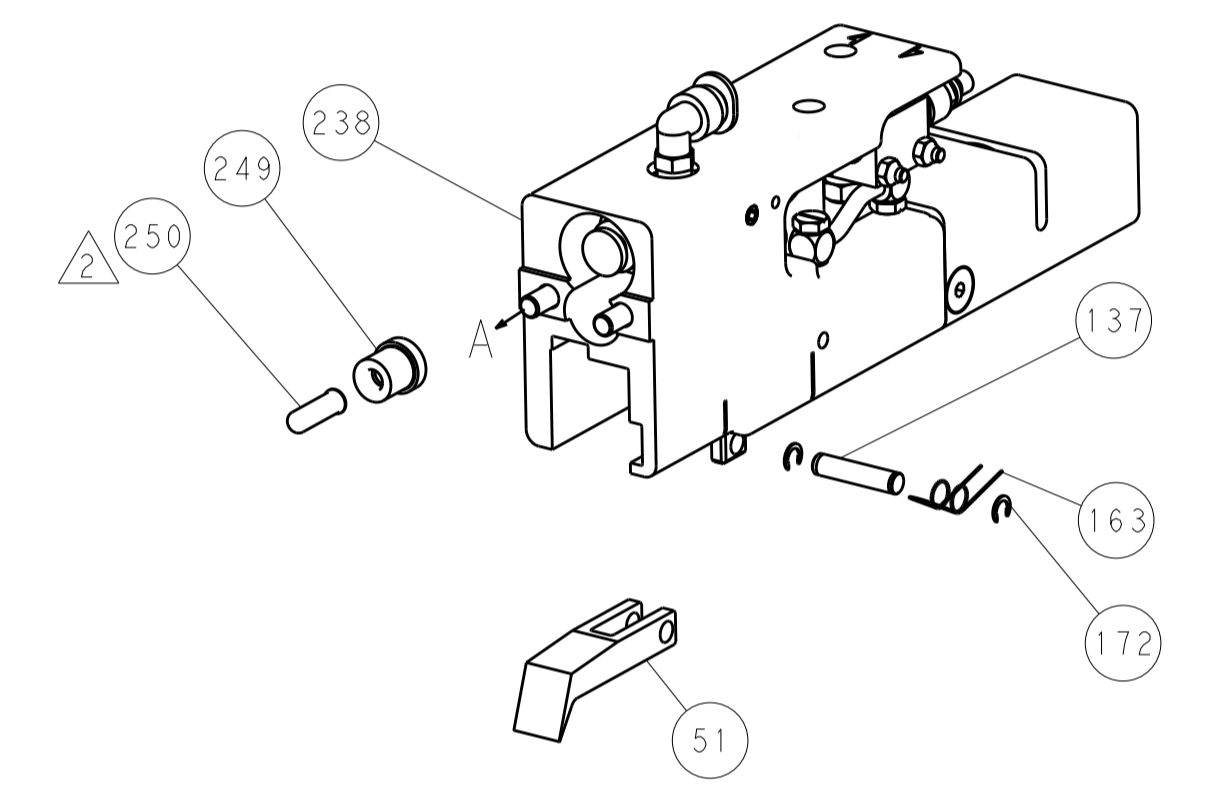
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			



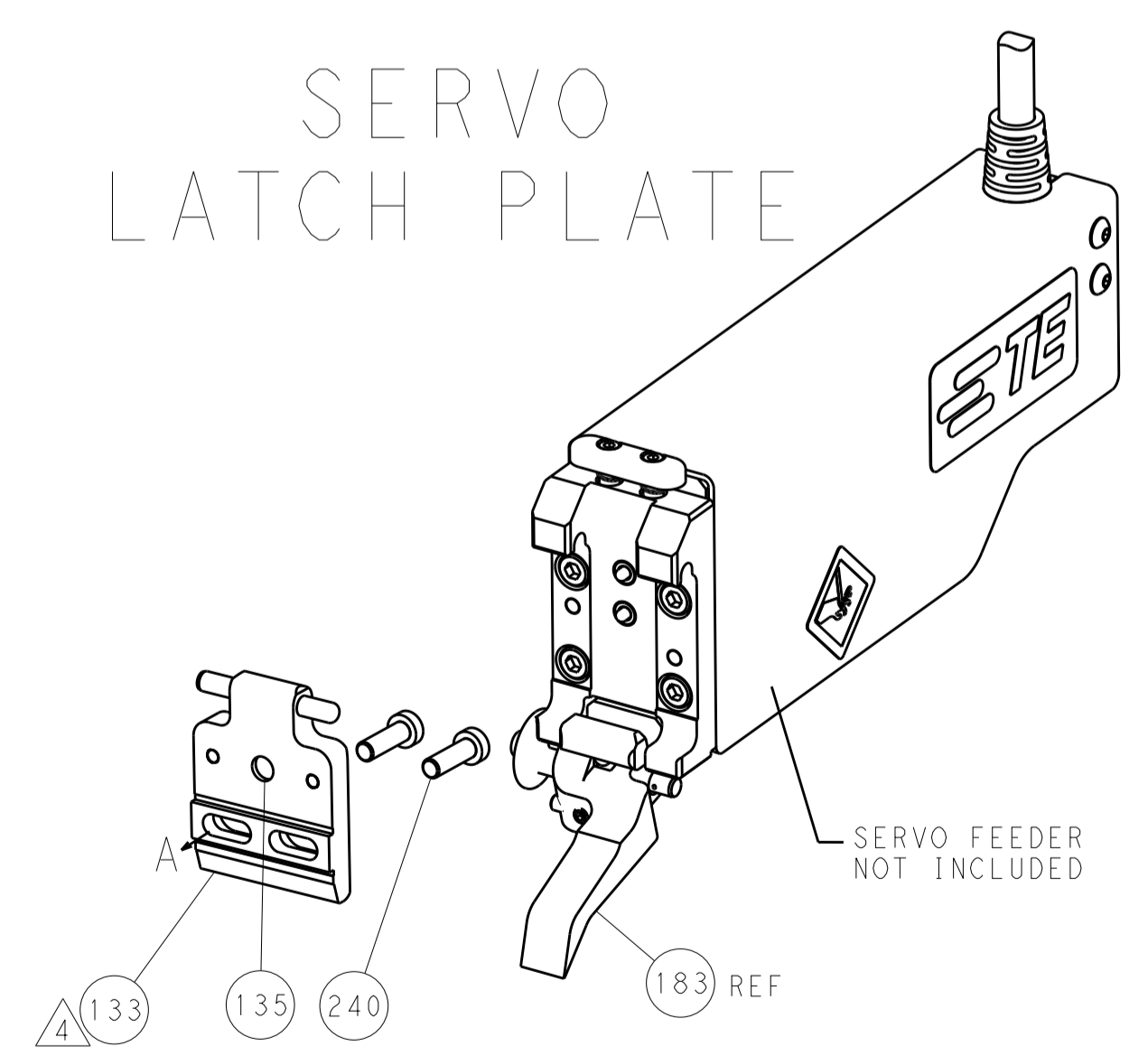
HOLDDOWN SET-UP



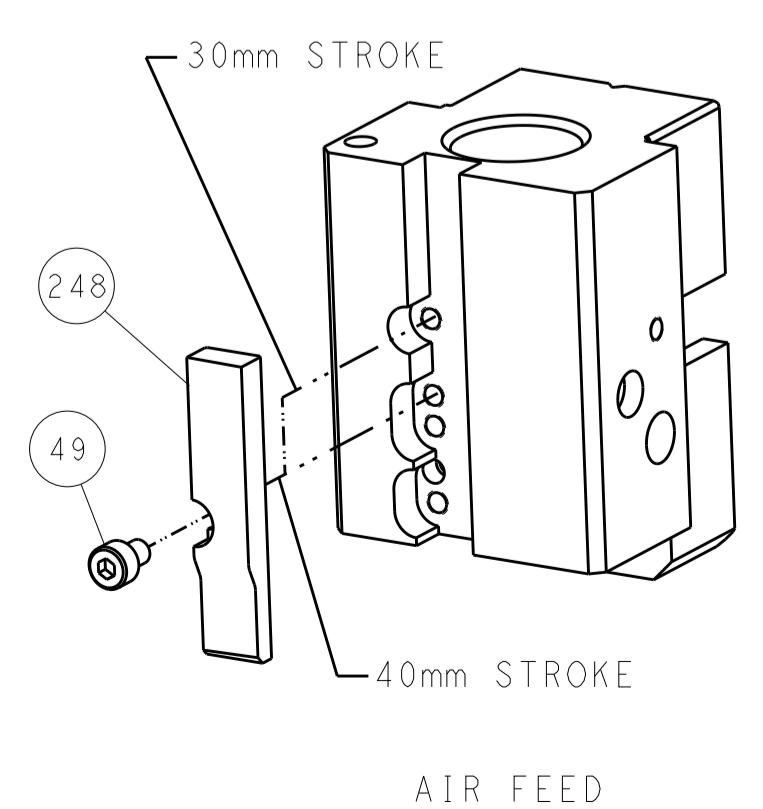
FEED TYPE  
 PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J.HOU 27MAY2014		TE Connectivity	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±.0001	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	NAME:	SIZE:	CAGE CODE:	DRAWING NO:
			1:1	Ocean End Feed Applicator	A11	00779	2150079
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				
	2-2150079-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150079-5	-	-
	2-2150079-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-
2-2150079-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150079-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLESHUR PLUG, .180 DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.66-4.26 mm [.144-.168 IN]		Ø2.29-3.17 mm [.090-.125 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2017	-	-
TERMINALS APPLIED <sup>10</sup> <sub>0,3</sub>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60798-2	60798-4	60798-6	60799-2
60799-4	60799-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>
14 AWG	1.96+/-0.05 [.077+/-0.002]	5.3
16 AWG	1.70+/-0.05 [.067+/-0.002]	8.5
18 AWG	1.55+/-0.05 [.061+/-0.002]	9.9

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150079-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150079-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. 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.
- <sup>12</sup> CUT TO LENGTH AT ASSEMBLY.
- <sup>13</sup> TERMINAL LUBRICANT IS RECOMMENDED.

-	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	2119082-8	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
-77-27-25-22	PART NO		DESCRIPTION		ITEM NO	

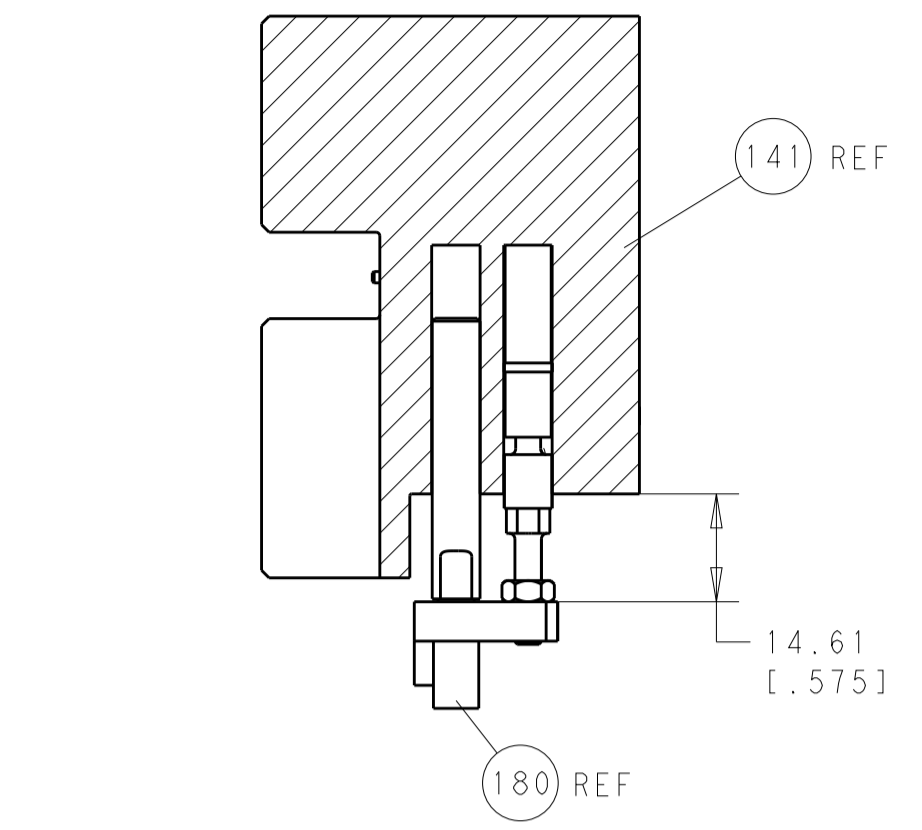
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

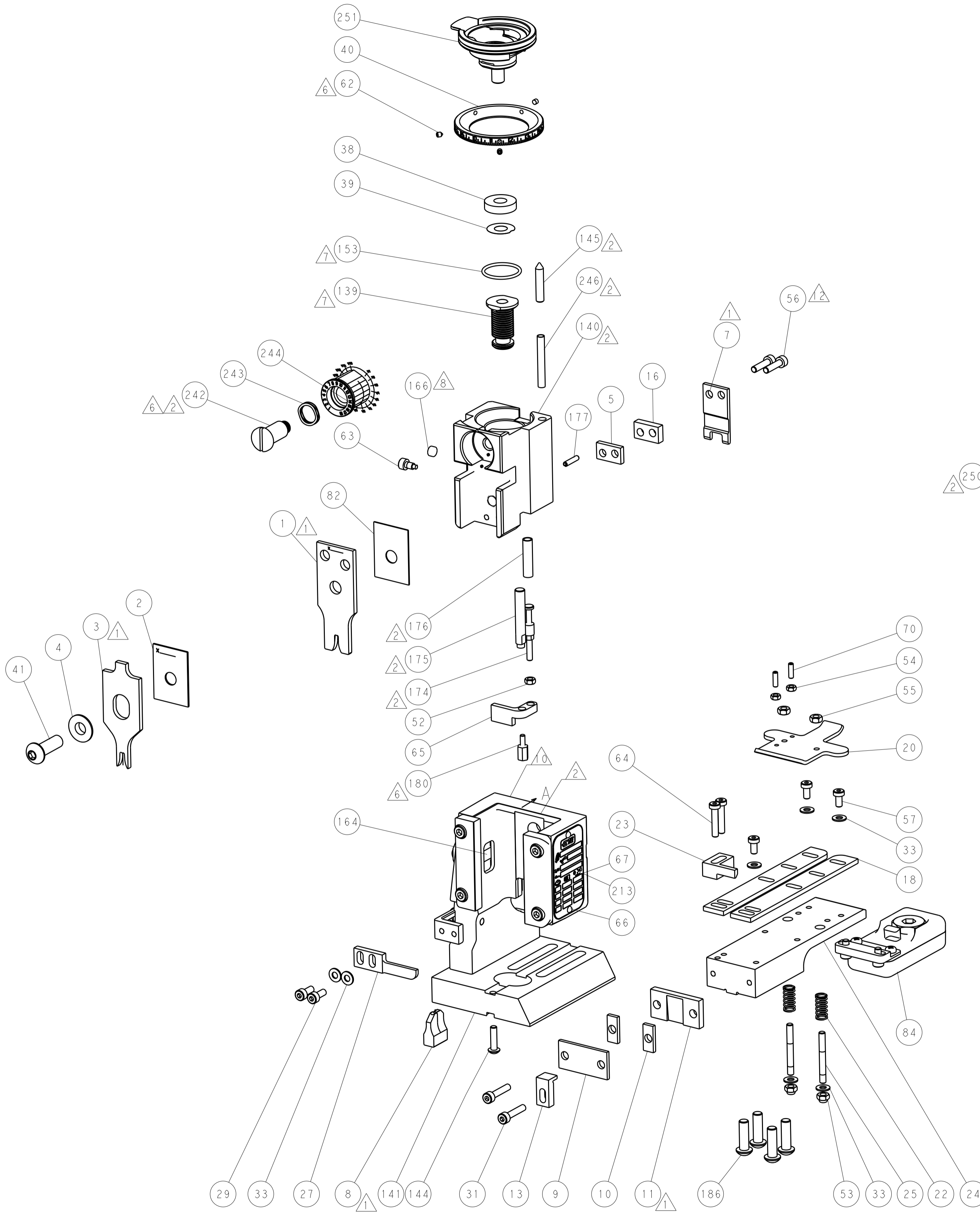
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	-	1	2063440-1	AIR FEED MODULE	238	
-	-	-	1	2119740-2	TAG, IDENTIFICATION	213	
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183	
<sup>6</sup>	-	1	1	1	2-1752354-0	STANDOFF, HOLD-DOWN	180
-	1	1	1	6-993111-6	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	
-	-	-	-	2119653-2	FEED CAM, POST FEED	142	
-	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	
<sup>6</sup>	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	-	-	2063961-1	FEED FINGER	58	
<sup>12</sup>	-	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	
-	-	-	-	2119652-1	FEED CAM, PRE FEED	48	
-	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	240825-3	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	2-240641-9	SPACER	16	
-	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
<sup>1</sup>	-	2	1	1	240644-1	PLATE, REAR SHEAR	11
<sup>1</sup>	-	2	2	2	1-240645-1	SPACER, SHEAR PLATE	10
<sup>1</sup>	-	1	1	1	240642-8	PLATE, FRONT SHEAR	9
<sup>1</sup>	1	1	1	1	5-1803000-3	ANVIL, COMBINATION, END FEED	8
<sup>1</sup>	-	1	1	1	8-240651-7	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-8	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
<sup>1</sup>	1	1	1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
<sup>1</sup>	-	1	1	1	455888-8	SPACER, CRIMPER	2
<sup>1</sup>	1	1	1	1	2-456407-9	CRIMPER, WIRE PREMIUM	1
-77-27-25-22	PART NO		DESCRIPTION		ITEM NO		

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J.HOU 27MAY2014		CHK: Y.YIN 27MAY2014		NAME: TE Connectivity Harrisburg, PA 17105-3608	
		0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5	APV: H.GUO 27MAY2014	PRODUCT SPEC	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		RESTRICTED TO:	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET 3 OF 4		REV A		APPLICATOR SPEC	

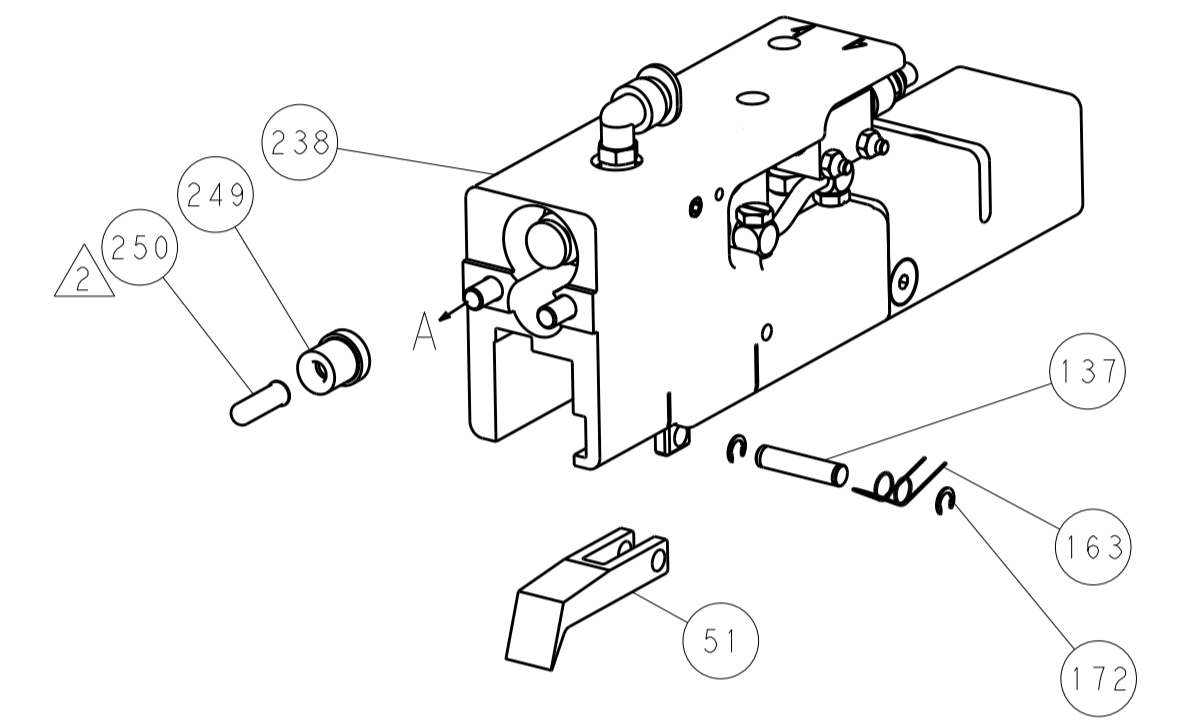
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



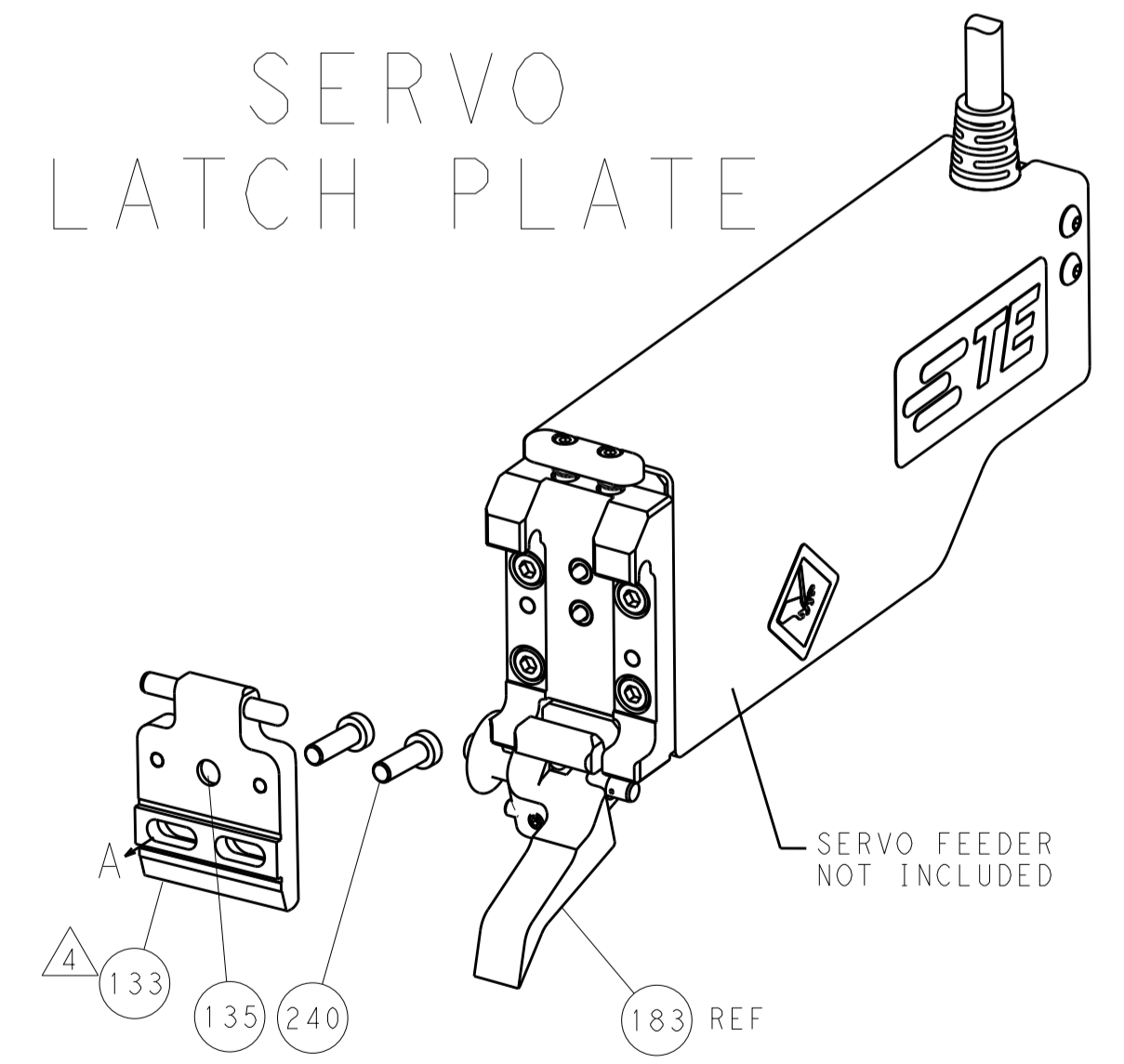
HOLDDOWN SET-UP



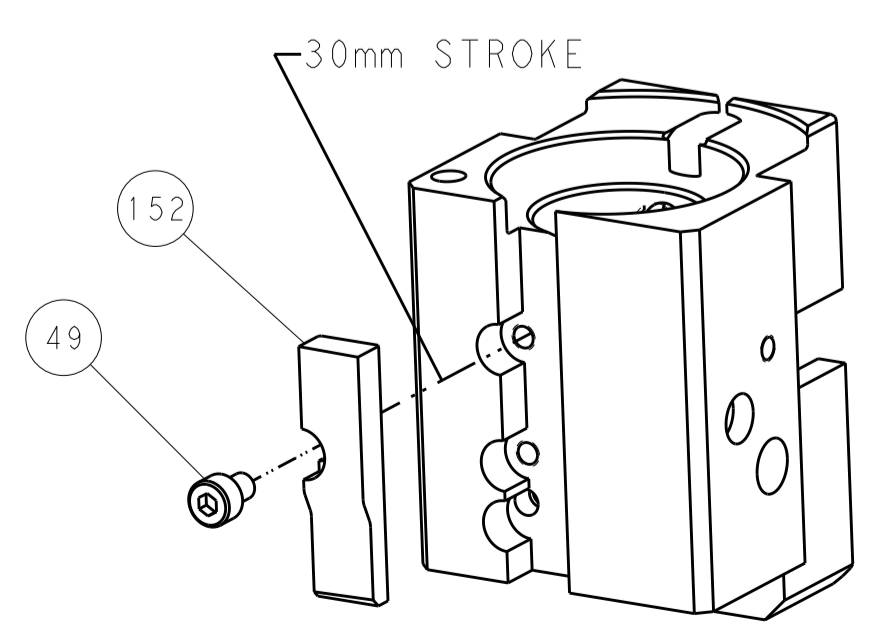
FEED TYPE  
 PNEUMATIC



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: J. HOU 27MAY2014		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD: Y. YIN 27MAY2014	NAME: Ocean End Feed Applier
MATERIAL:		FINISH:		WEIGHT:		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150079	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 4 OF 4 REV A	