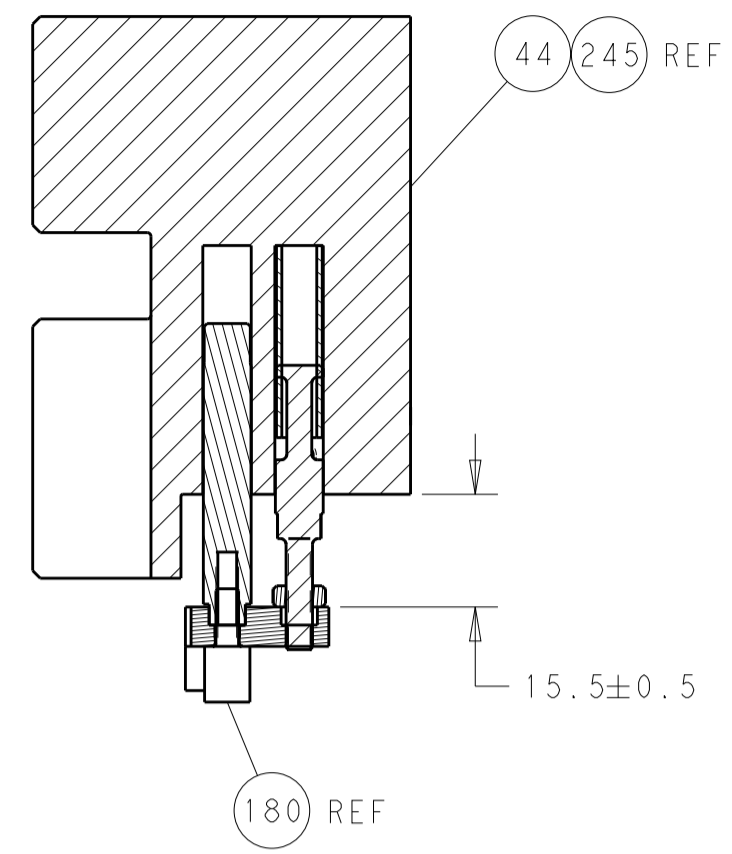
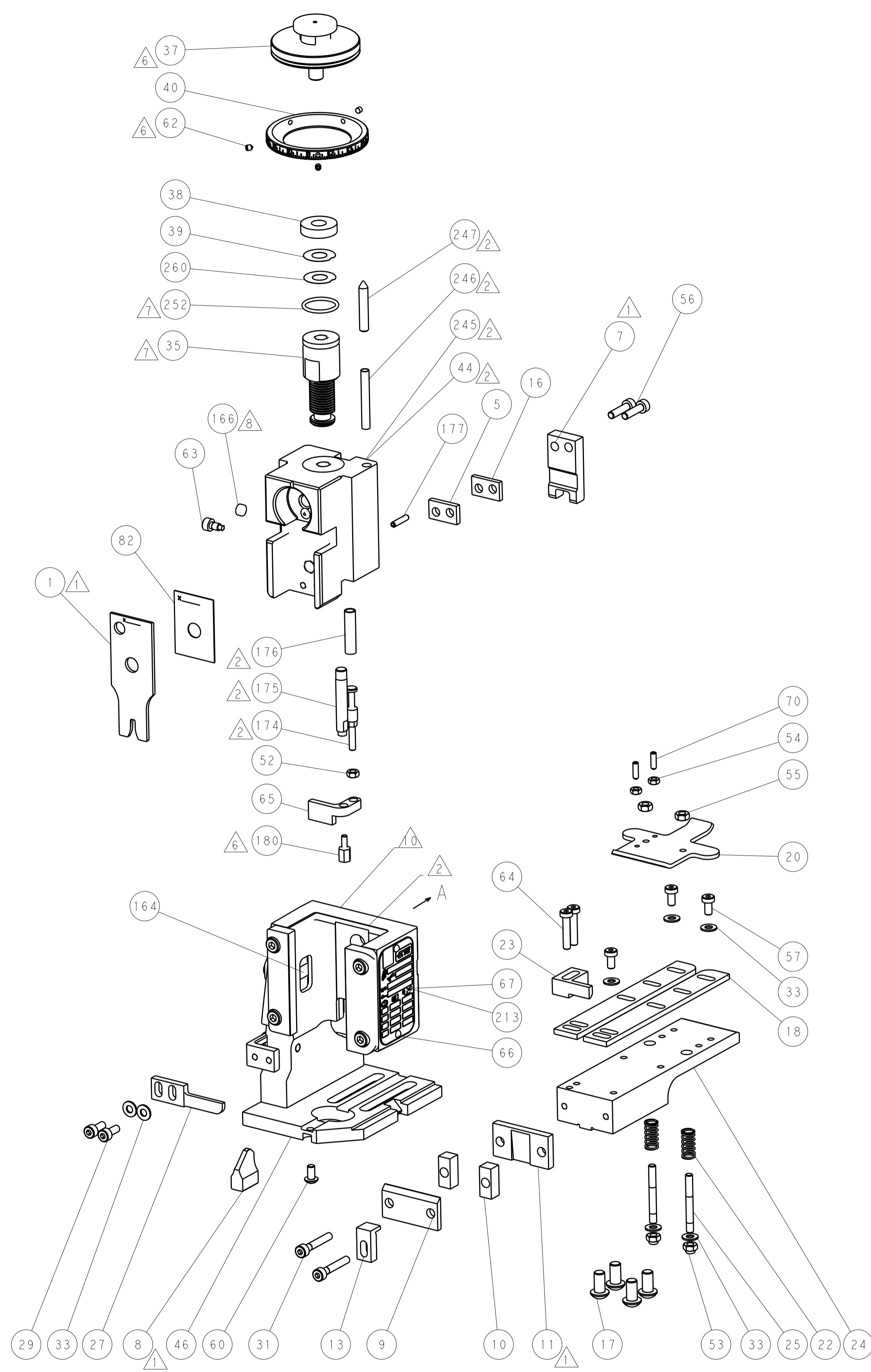


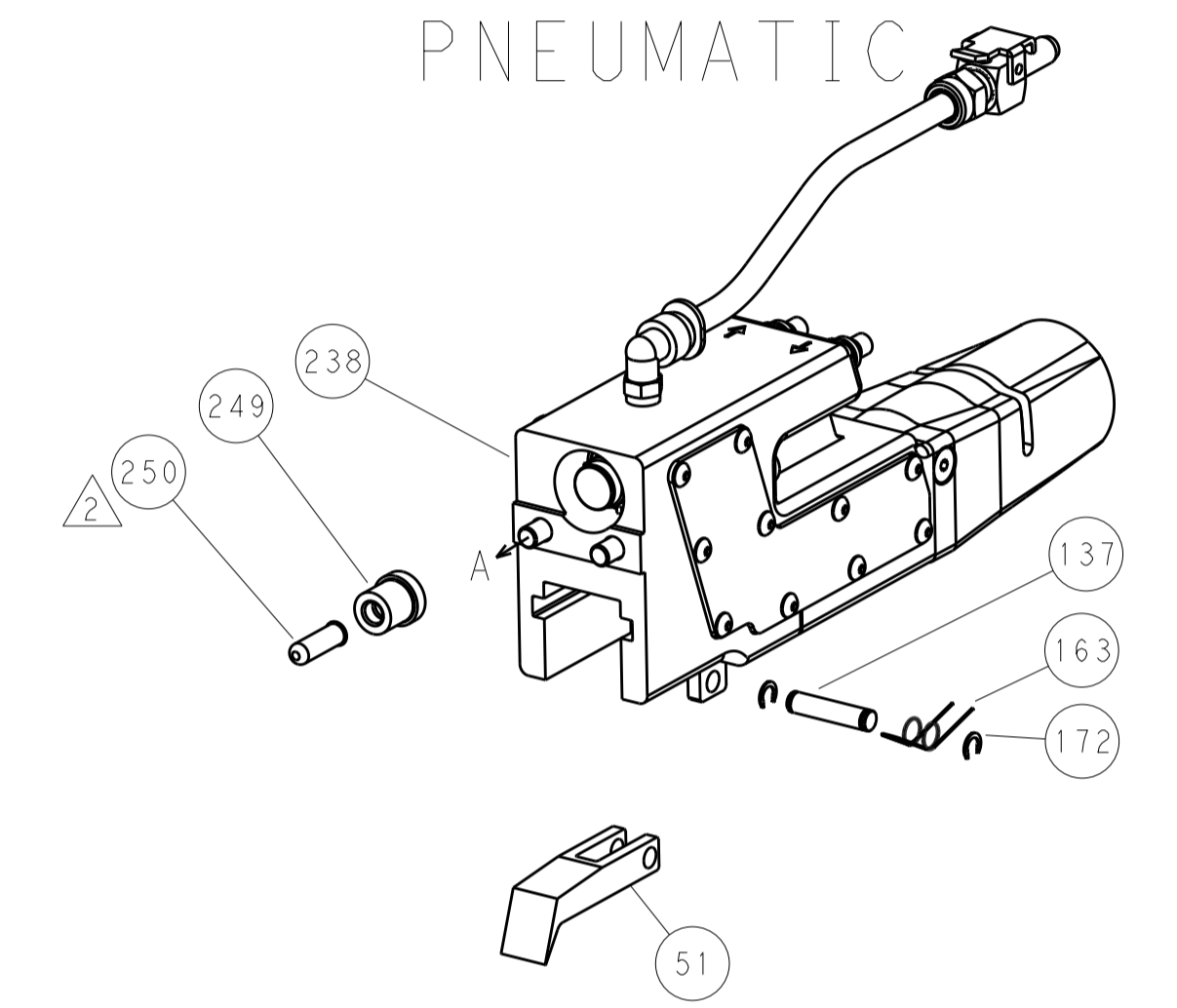
LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					
REVISIONS			DESCRIPTION	DATE	BY	APPV
-			SEE SHEET 1	-	-	-



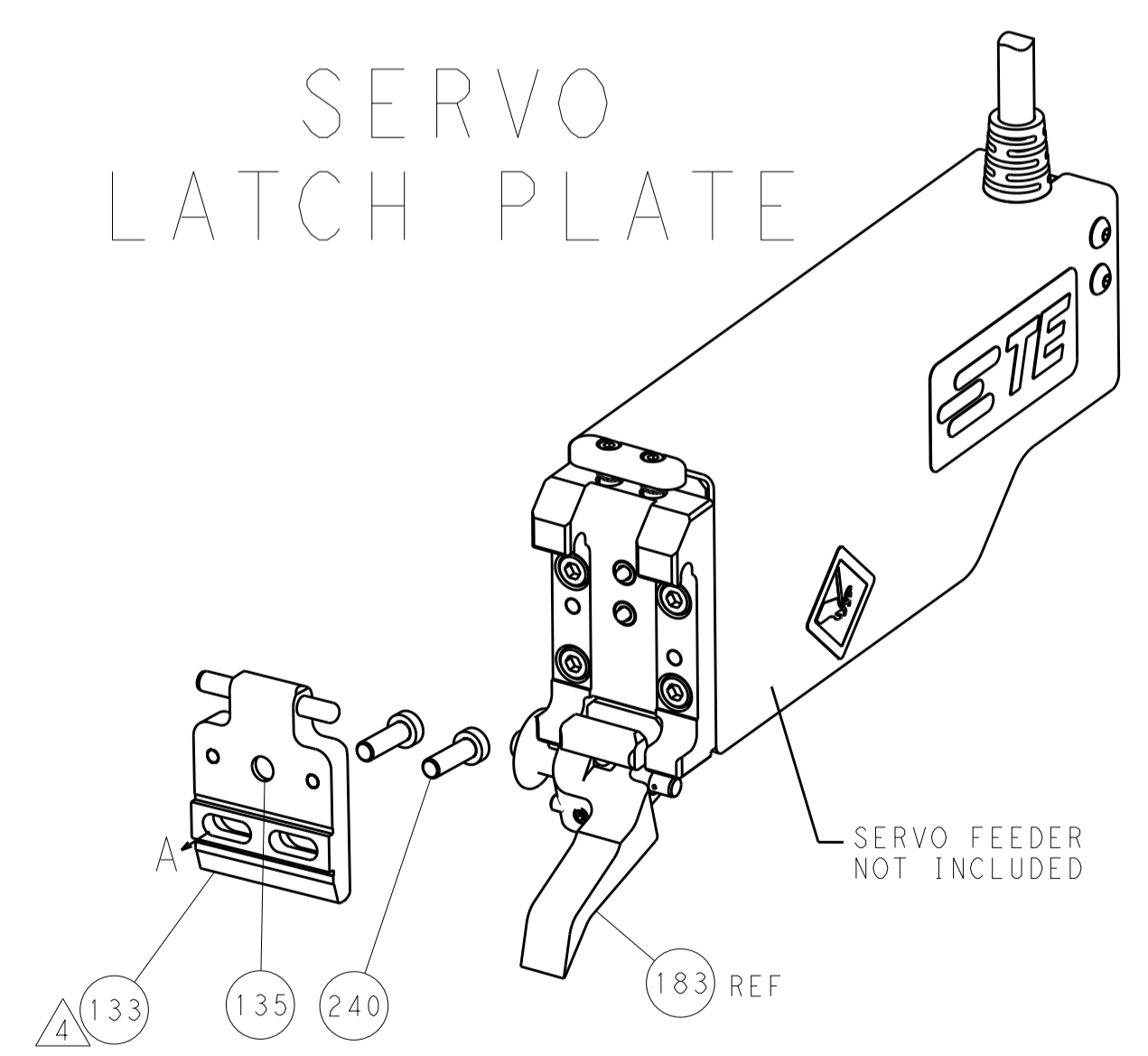
HOLDDOWN SET-UP



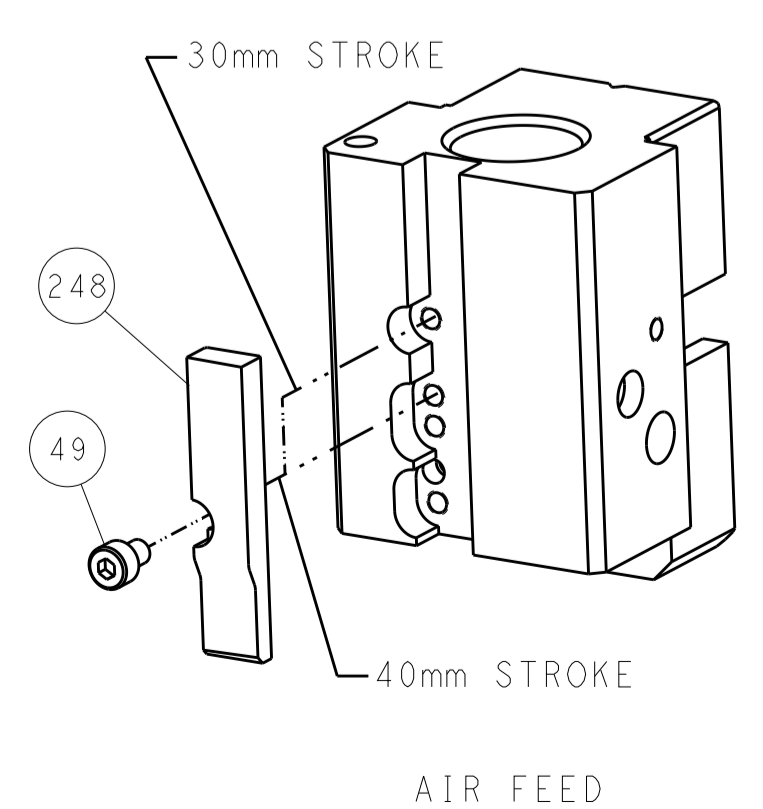
FEED TYPE
PNEUMATIC



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: Y. YIN 14MAR2014		TE Connectivity	
mm	0 PLC	±		CHK: G. BAILEY 14MAR2014	NAME: Ocean End Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APPV: H. GUO 14MAR2014	SIZE: A1		CAGE CODE: 00779
	2 PLC	±			DRAWING NO: 2150426		REV: 2
	3 PLC	±			SCALE: 1:1		SHEET 2 OF 4
	4 PLC	±			RESTRICTED TO:		REV: A2
	ANGLES	±			Customer Accessible Production Drawing		
MATERIAL:	FINISH:			WEIGHT:			

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150426-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150426-5	-	-
	2-2150426-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-
2-2150426-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150426-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.110]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-10390

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: SHUR PLUG .156 DIA		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
2.88-3.48 mm [1.113-.137 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2042	
TERMINALS APPLIED ¹⁰		
TE TERMINAL	TE TERMINAL	TE TERMINAL
1217606-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
14 AWG	2.01 +/- 0.05 [1.079 +/- .002]	4.4
16 AWG	1.75 +/- 0.05 [1.069 +/- .002]	7.0
18 AWG	1.63 +/- 0.05 [1.064 +/- .002]	8.3

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- ⁴ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150426-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150426-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- ⁶ 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.
- ⁹ 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.
- ¹⁰ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ¹¹ 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.

***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	
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
-	-	-	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	
⁶	-	1	1	1	1-1752354-4	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	455888-4	SPACER, CRIMPER	82	
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71	
-	2	2	2	2-18032-2	SCR, SET, FLT PNT, 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	
⁶	-	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, 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	2079383-6	SCR, BHSC, RoHS (M8 X 12)	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1-1752371-6	PLATE, STRIP GUIDE	24	
-	1	1	1	240825-6	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	240641-6	SPACER	16	
-	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
¹	-	1	1	1	240644-5	PLATE, REAR SHEAR	11
¹	-	2	2	2	8-240645-5	SPACER, SHEAR PLATE	10
¹	-	1	1	1	690796-1	PLATE-FRONT SHEAR MINI APPLICATOR	9
¹	1	1	1	1	1803002-5	ANVIL, COMBINATION, END FEED	8
¹	-	1	1	1	9-240651-5	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-5	SPACER	5
-	-	-	-	-	-	-	4
¹	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
¹	1	1	1	1	7-456408-7	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE	
mm	0 PLC	±	14MAR2014	Y. YIN	14MAR2014	TE Connectivity	
	1 PLC	±	14MAR2014	G. BAILEY	14MAR2014	Harrisburg, PA 17105-3608	
	2 PLC	±	14MAR2014	J. GUO	14MAR2014	NAME	
	3 PLC	±				PRODUCT SPEC	
	4 PLC	±				APPLICATION SPEC	
	ANGLES	±				SIZE	
	FINISH	±				CAGE CODE	
MATERIAL						DRAWING NO	
						RESTRICTED TO	
						WEIGHT	
						SCALE	
						SHEET	
						OF	
						REV	
						A2	

