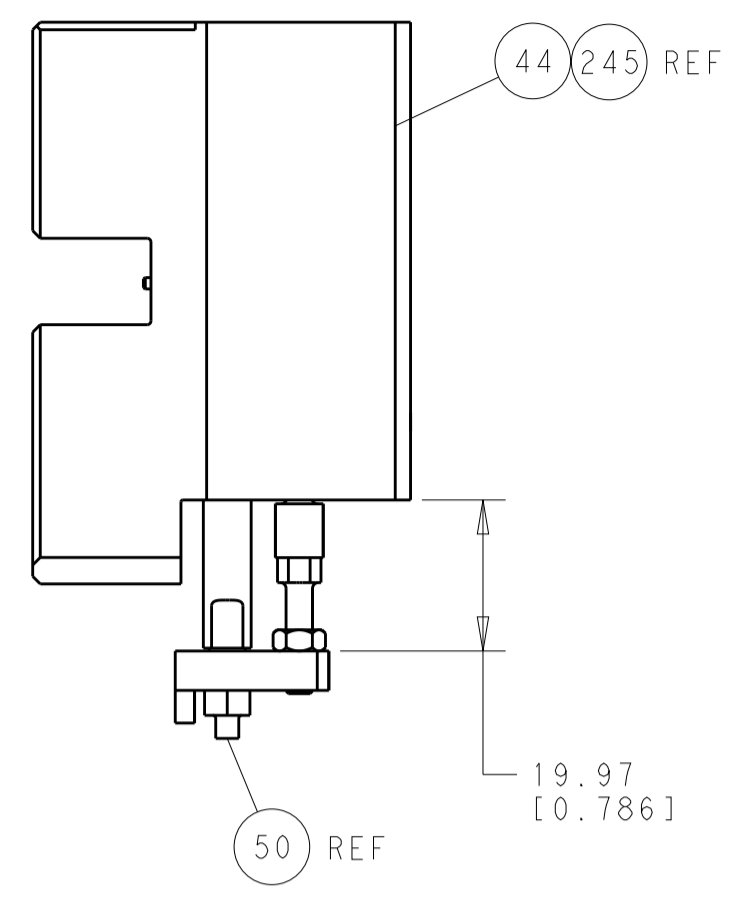


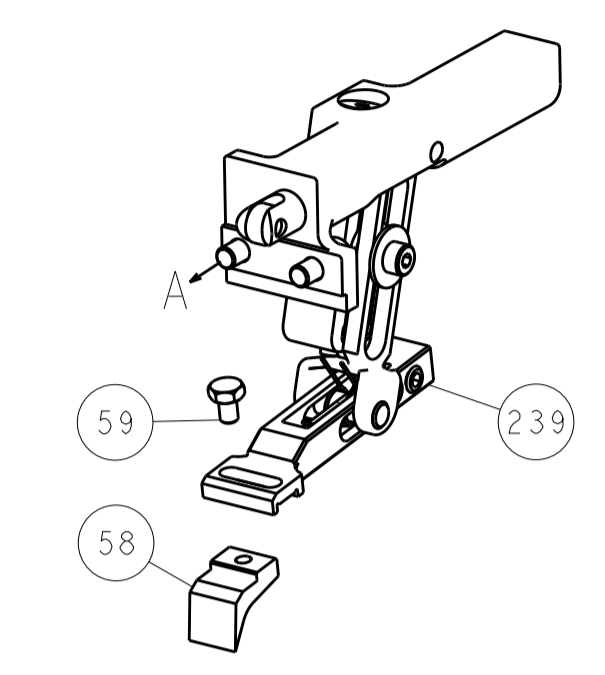


LOC		DIST		REVISONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

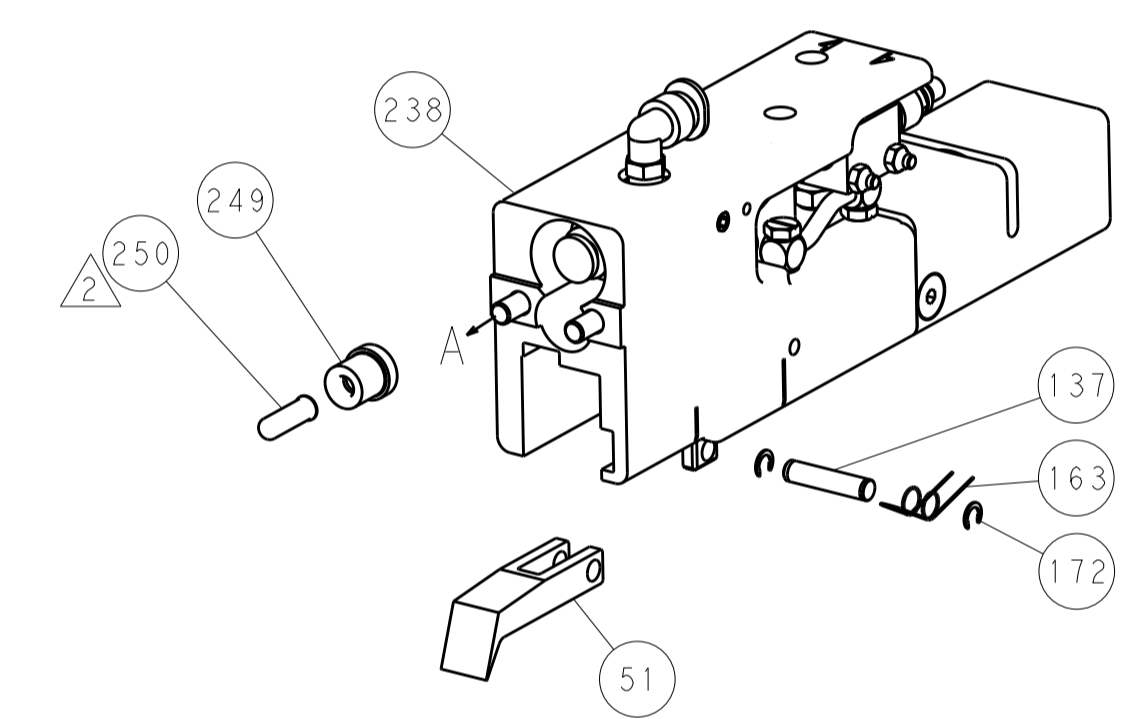


HOLDDOWN SET-UP

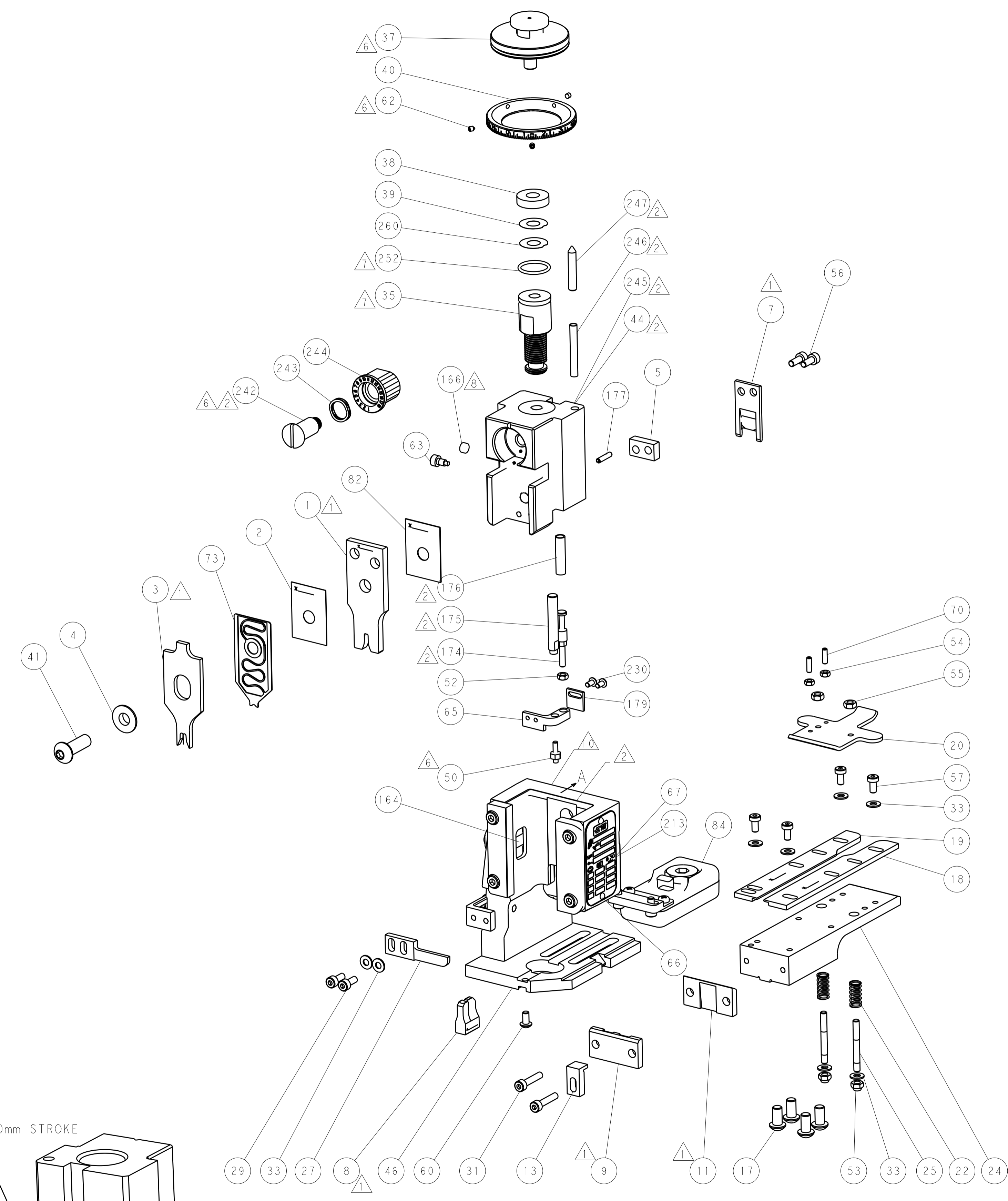
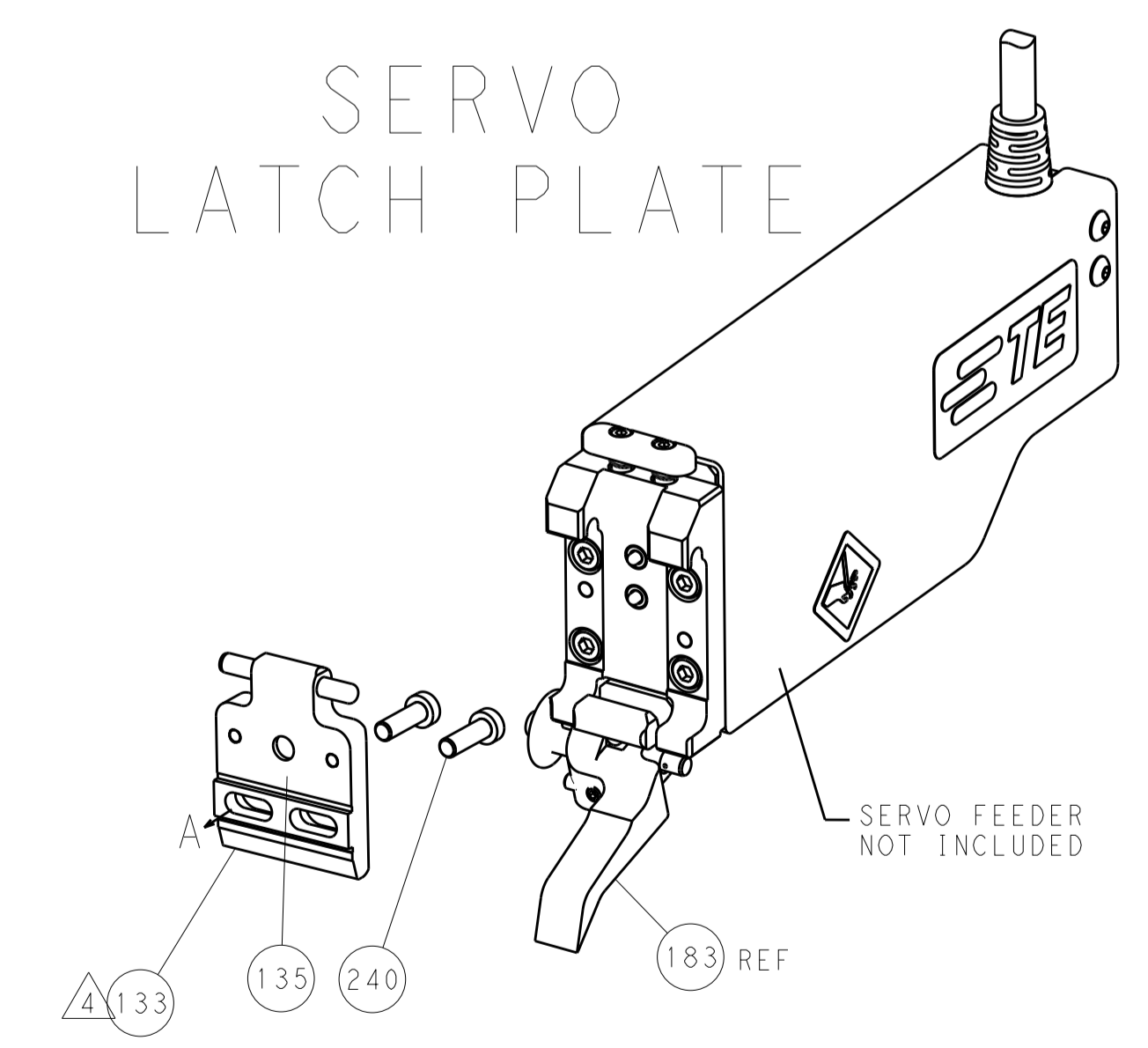
FEED TYPE  
MECHANICAL



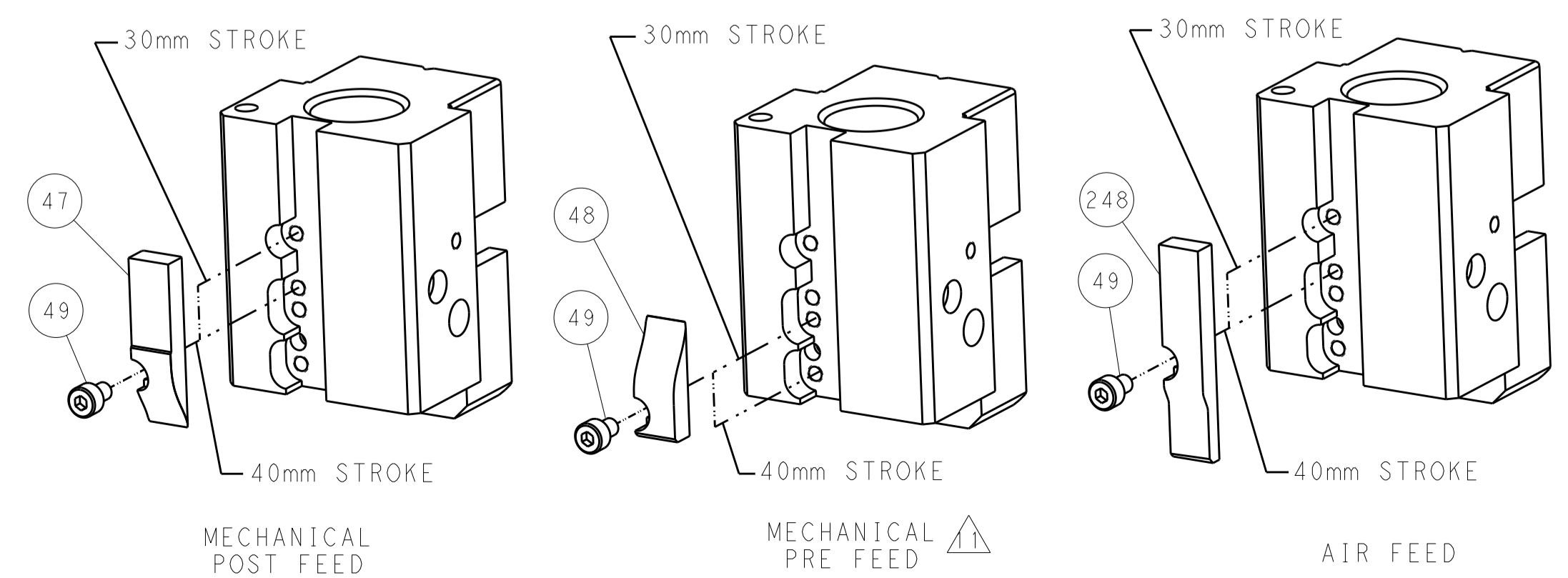
PNEUMATIC



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:		DWN: HOFFNER 20AUG2013		TE Connectivity	
mm		0 PLC ±0.5		CHK: T. ELBIN 21AUG2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APVD: T. ELBIN 21AUG2013		NAME: Ocean End Feed Applicator	
H		2 PLC ±0.013		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
A		3 PLC ±0.001		APPLICATION SPEC		RESTRICTED TO	
ANGLES		4 PLC ±0.001		WEIGHT		A1 00779 ©=2150363	
FINISH		5 PLC ±0.001		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:1 SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
				CONVERT TO	PART NUMBERS REQUIRED						
	2-2150363-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150363-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150363-4	-	-	-
	2-2150363-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150363-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150363-4	-	-	-
2-2150363-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	-
2-2150363-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
7-2150363-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

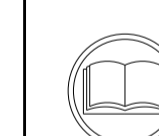
CRIMP	SIZE	TYPE
WIRE	2.54 mm (.100)	F
INSUL	4.57 mm (.180)	F
APPLICATOR INSTRUCTIONS		
408-10390		

TERMINAL NAME: RING TERMINAL	
WIRE STRIP LENGTH 5.50-6.50 mm (.217-.256 IN)	INSULATION DIAMETER RANGE ∅2.54-3.56 mm (.100-.140 IN)
TERMINAL APPLICATION SPECIFICATION (A) 114-5106	-
TERMINALS APPLIED	
TE TERMINAL (A) 173635-1	TE TERMINAL (A) 173636-1

TERMINAL NAME: RING TERMINAL	
WIRE STRIP LENGTH 5.44-5.69 mm (.214-.224 IN)	INSULATION DIAMETER RANGE ∅2.54-3.56 mm (.100-.140 IN)
TERMINAL APPLICATION SPECIFICATION (B) 114-2084	-
TERMINALS APPLIED	
TE TERMINAL (B) 61588-1	TE TERMINAL (B) 61436-2
TE TERMINAL (B) 61436-1	TE TERMINAL (B) 61436-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	2.06 +/- 0.05 [0.081 +/- .002]	7.1
18 AWG	1.91 +/- 0.05 [0.075 +/- .002]	8.7
20 AWG	1.80 +/- 0.05 [0.071 +/- .002]	9.8
22 AWG	1.75 +/- 0.05 [0.069 +/- .002]	10.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	2.11 +/- 0.05 [0.083 +/- .002]	6.5
18 AWG	1.96 +/- 0.05 [0.077 +/- .002]	8.1
20 AWG	1.85 +/- 0.05 [0.073 +/- .002]	9.2
22 AWG	1.80 +/- 0.05 [0.071 +/- .002]	9.8



- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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: 8-2150363-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150363-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150363-5
- 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 50, 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.
- 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 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATORS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 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.

ITEM 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
- 1 1 1 1 1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
- 1 1 1 1 1	2119083-1 RETAINER, INSULATION DIAL	242
- - 2 - -	2168400-7 SHCS, LOW HEAD, RoHS, M5 X 10	240
- - - - 1	2119580-1 MECHANICAL FEED ASSEMBLY	239
-77-27-25-22-21	PART NO DESCRIPTION	ITEM NO

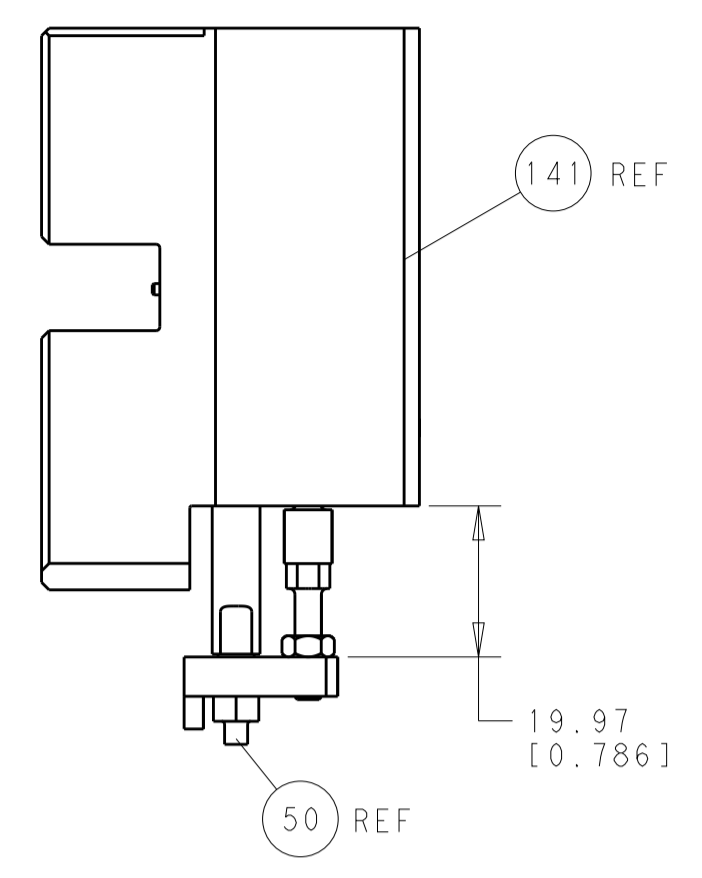
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS				
2119599-2	A	66	P. LTR	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

ITEM NO	DESCRIPTION	ITEM NO
- - - 1 -	2063440-1 AIR FEED MODULE	238
- 2 2 2 2	1-2079383-0 SCR, BHSC, RoHS (M3 X 6)	230
- - 1 - -	2119740-2 TAG, IDENTIFICATION	213
- 4 4 4 4	2079383-9 SCR, BHSC, RoHS (M6 X 20)	186
- REF - - -	1901697-1 FEED FINGER ASSEMBLY, EF	183
- 1 1 1 1	3-1976053-1 LOCATER BLOCK, TERMINAL	179
- 1 1 1 1	6-993111-6 PIN, SLOTTED SPRING 3.0 X 14.0	177
- 1 1 1 1	8-22280-7 SPRING, COMPRESSION	176
- 1 1 1 1	1752353-2 GUIDE PIN, HOLDDOWN	175
- 1 1 1 1	1901680-2 GUIDE PIN, HOLDDOWN	174
- - - 2 -	21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172
- 1 1 1 1	994969-1 MAGNET, RARE EARTH HIGH ENERGY	166
- REF REF REF REF	994970-2 COUNTER, MAGNETIC	164
- - - 1 -	240638-1 SPRING, FEED FINGER	163
- 1 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 1	2119798-2 DETENT PIN	145
- 1 1 1 1	2079383-8 SCR, BHSC, RoHS (M4 X 16)	144
- - - - 1	2119653-2 FEED CAM, POST FEED	142
- 1 1 1 1	2119655-6 APPLICATOR BASIC ASSEMBLY, EF	141
- 1 1 1 1	2119651-1 RAM, ASIAN STYLE, END FEED	140
- 1 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 1	2119955-2 ASSY, LUBRICATOR, END FEED	84
- 1 1 1 1	455888-4 SPACER, CRIMPER	82
- 1 1 1 1	2119791-5 DEPRESSOR, WIRE	73
- 1 1 1 1	2119956-2 DOCUMENTATION PACKAGE	71
- 2 2 2 2	2-18032-2 SCR, SET, FLT POINT M3 X 10.0	70
- 1 - 1 1	2119740-1 TAG, IDENTIFICATION	67
- 2 2 2 2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66
- 1 1 1 1	2-1901681-3 HOLDDOWN, TERMINAL	65
- 1 1 1 1	2119793-1 LIMITER, ADJUSTMENT BOLT	63
- 3 3 3 3	992763-5 SCR, SET, SOC, CONE POINT, M3 X 4.0	62
- - - 1 -	5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
- - - - 1	2063961-1 FEED FINGER	58
- 4 4 4 4	2168400-4 SHCS, LOW HEAD, RoHS, M4 X 8	57
- 2 2 2 2	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	56
- 2 2 2 2	5018030-2 NUT, HEX, REG, RoHS, M4	55
- 2 2 2 2	5018030-1 NUT, HEX, REG, RoHS, M3	54
- 2 2 2 2	986965-8 NUT, LOCK, HEX, TORQUE (M4)	53
- 1 1 1 1	1-5018030-0 NUT, HEX, REG, RoHS, M3.5	52
- - - 1 -	2119792-2 PAWL, EF, AIR	51
- 1 1 1 1	1-1976055-0 STANDOFF, HOLD-DOWN	50
- - - 1 2	18023-9 SCR, SKT HD CAP M4 X 6.0	49
- - - - 1	2119652-1 FEED CAM, PRE FEED	48
- 1 1 1 1	2079383-7 SCR, BHSC, RoHS (M8 X 25)	41
- 1 1 1 1	2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT	40
- 1 1 1 1	2119957-1 APPLICATOR SHIM PACK	39
- 1 1 1 1	2119644-2 RAM WASHER, PRECISION	38
- 8 8 8 8	1-18028-2 WASHER, FLAT, REG M4	33
- 2 2 2 2	2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	31
- 2 2 2 2	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	29
- 1 1 1 1	240639-1 STRIPPER (MACHINING)	27
- 2 2 2 2	1320906-1 STUD, THREADED	25
- 1 1 1 1	1752371-5 PLATE, STRIP GUIDE	24
- 2 2 2 2	2-22281-3 SPRING, COMPRESSION	22
- 1 1 1 1	1752373-4 DRAG	20
- 1 1 1 1	2-1901696-1 STRIP GUIDE, REAR	19
- 1 1 1 1	2-1901695-1 STRIP GUIDE, FRONT	18
- 1 1 1 1	1752360-1 SPACER, HOLD-DOWN	13
- 1 1 1 1	240833-7 PLATE, REAR SHEAR	11
- - - - -	-	10
- 1 1 1 1 1	690496-6 PLATE, FRONT SHEAR	9
- 1 1 1 1 1	1333218-6 ANVIL, COMBINATION	8
- 1 1 1 1 1	2217206-1 BLADE, SLUG	7
- - - - -	-	6
- 1 1 1 1 1	1-240641-4 SPACER	5
- 1 1 1 1 1	238009-1 BLOCK, FL CRIMPER SPACER	4
- 1 1 1 1 1	4-1633962-1 CRIMPER, INSULATION F PREMIUM	3
- 1 1 1 1 1	455888-1 SPACER, CRIMPER	2
- 1 1 1 1 1	2-456407-5 CRIMPER, WIRE PREMIUM	1
-77-27-25-22-21	PART NO DESCRIPTION	ITEM NO

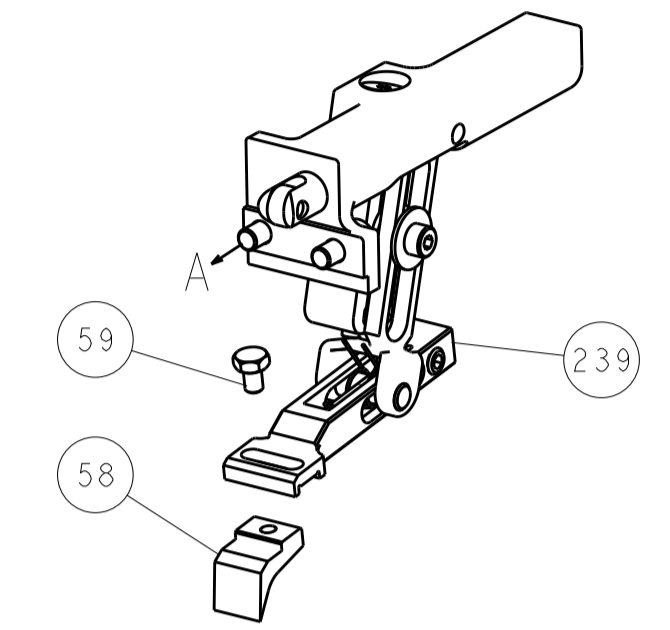
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	DATE	TE Connectivity
mm	0 PLC ±.13 1 PLC ±.13 2 PLC ±.075 3 PLC ±.075 4 PLC ±.075 ANGLES ±.0001	HOFFNER	20AUG2013	Harrisburg, PA 17105-3608
		CHK T. ELBIN	21AUG2013	Ocean End Feed Applier
MATERIAL: . FINISH:		APVD T. ELBIN	21AUG2013	
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
A1	00779	2150363		
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	SHEET	REV
		1:1	3 OF 4	B

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

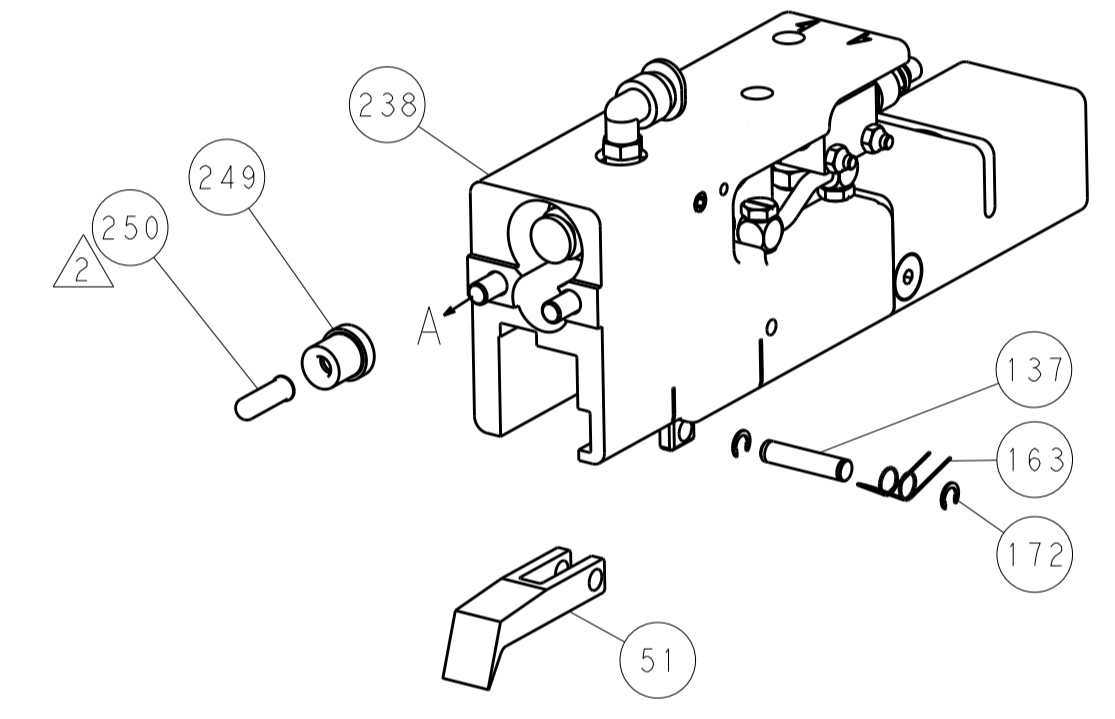


HOLDDOWN SET-UP

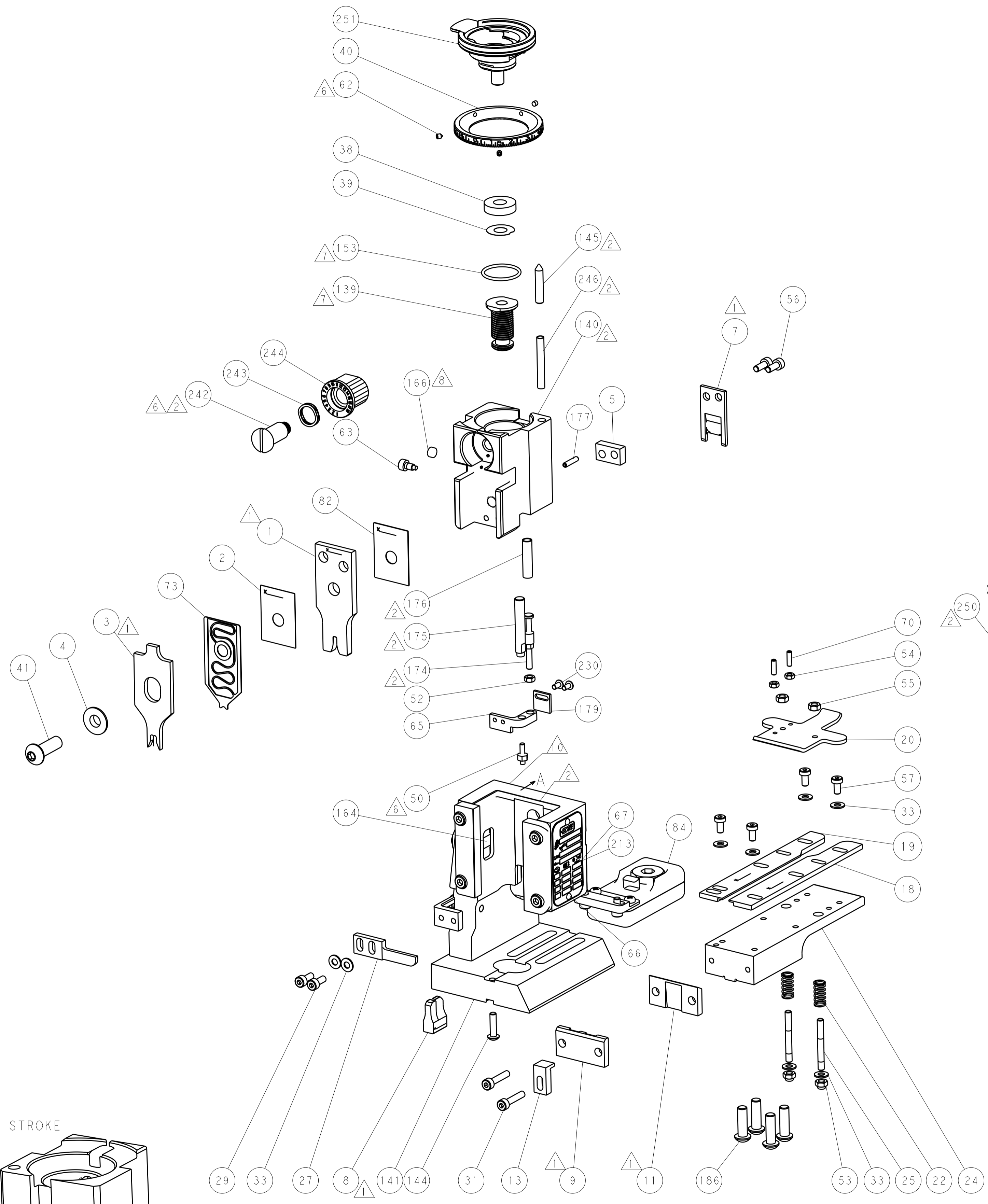
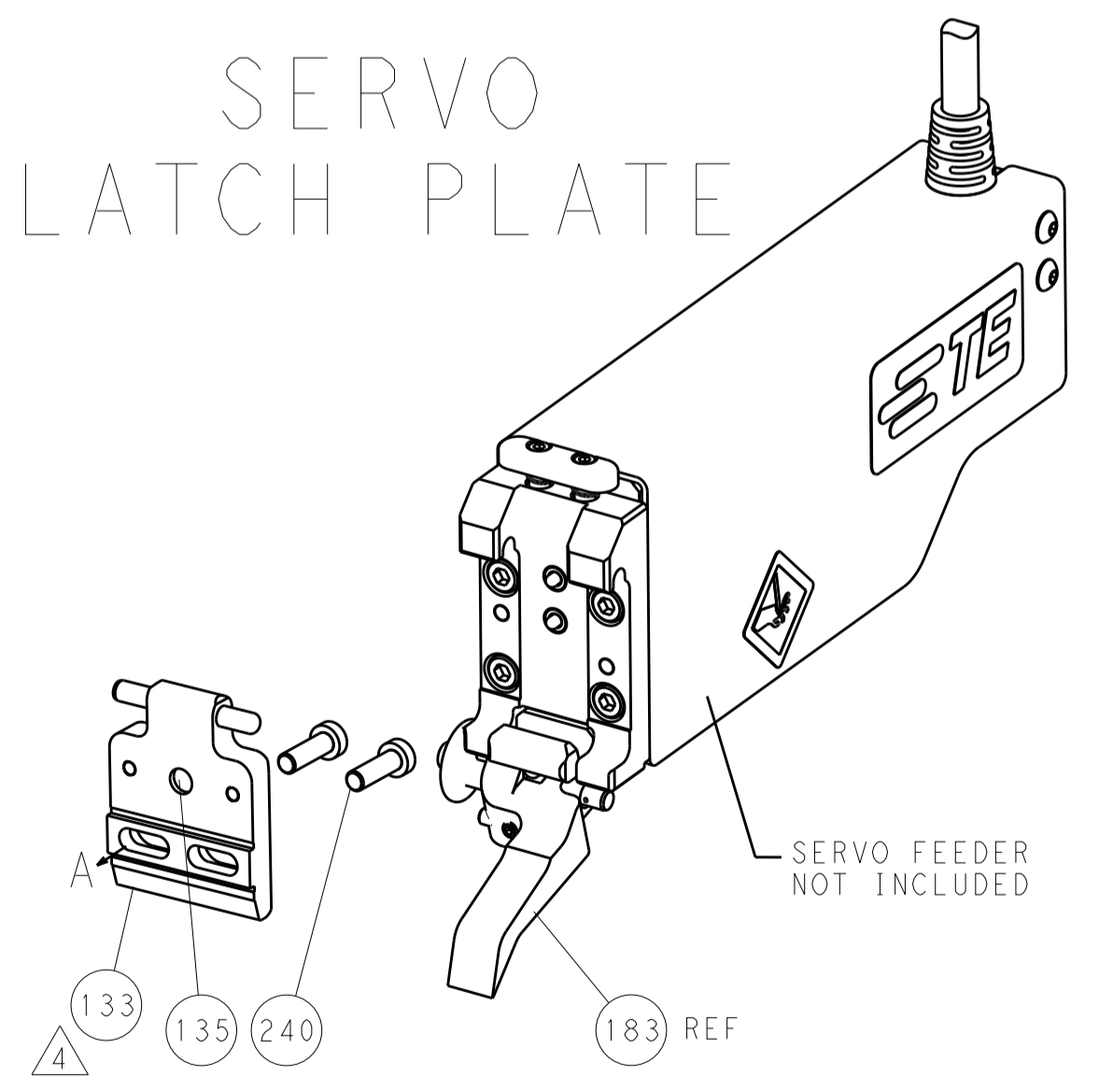
FEED TYPE  
MECHANICAL



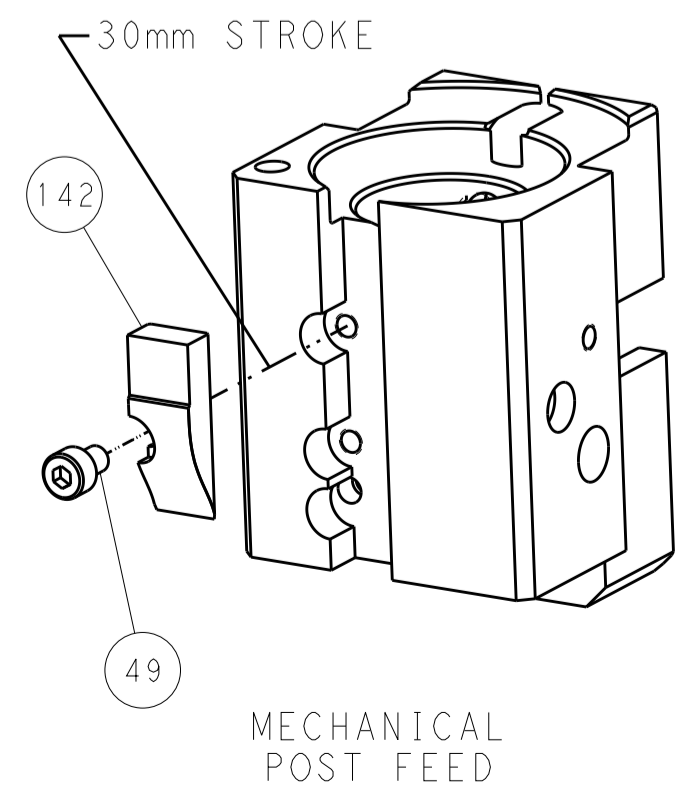
PNEUMATIC



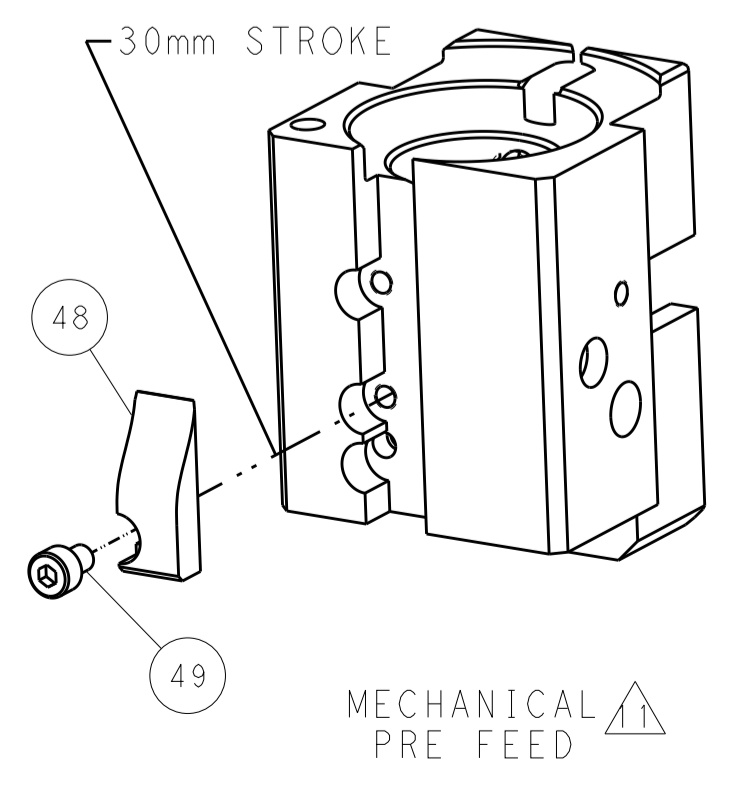
SERVO  
LATCH PLATE



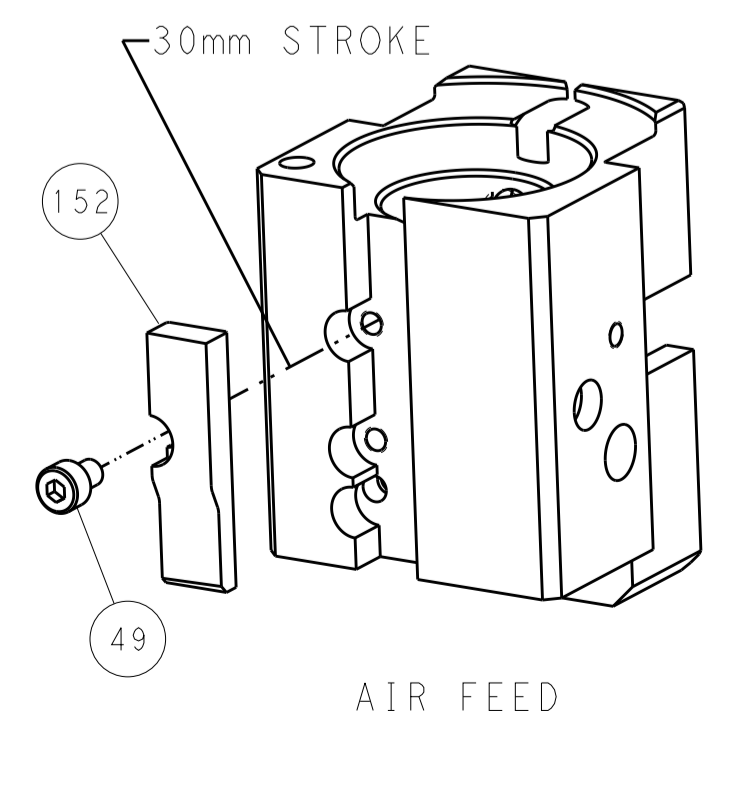
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



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: HOFFNER 20AUG2013		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	4 PLC ±0.013	5 PLC ±0.001	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE: 1:1	SHEET 4 OF 4	REV B	RESTRICTED TO