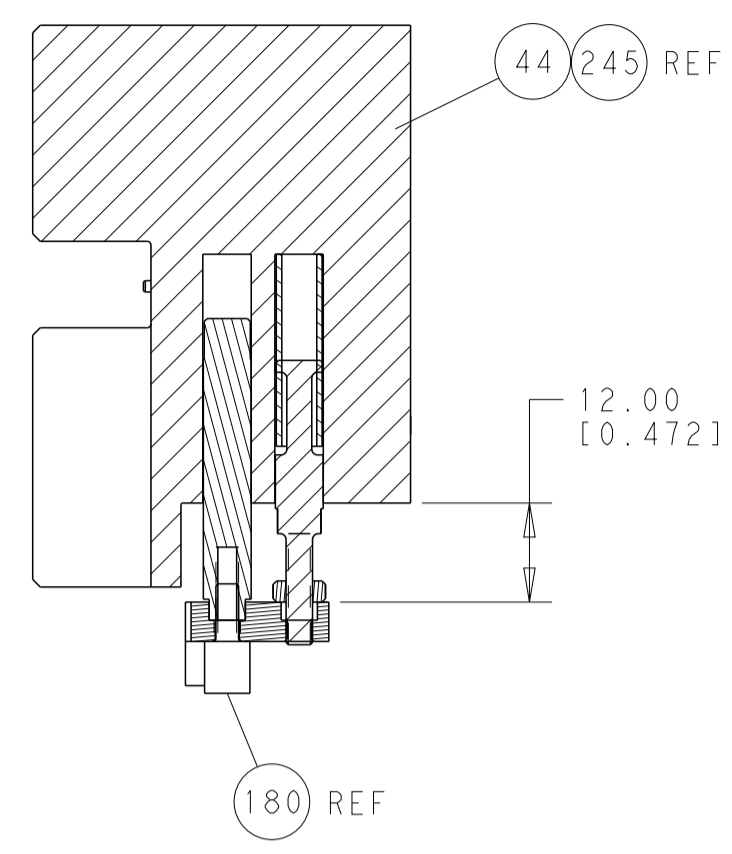
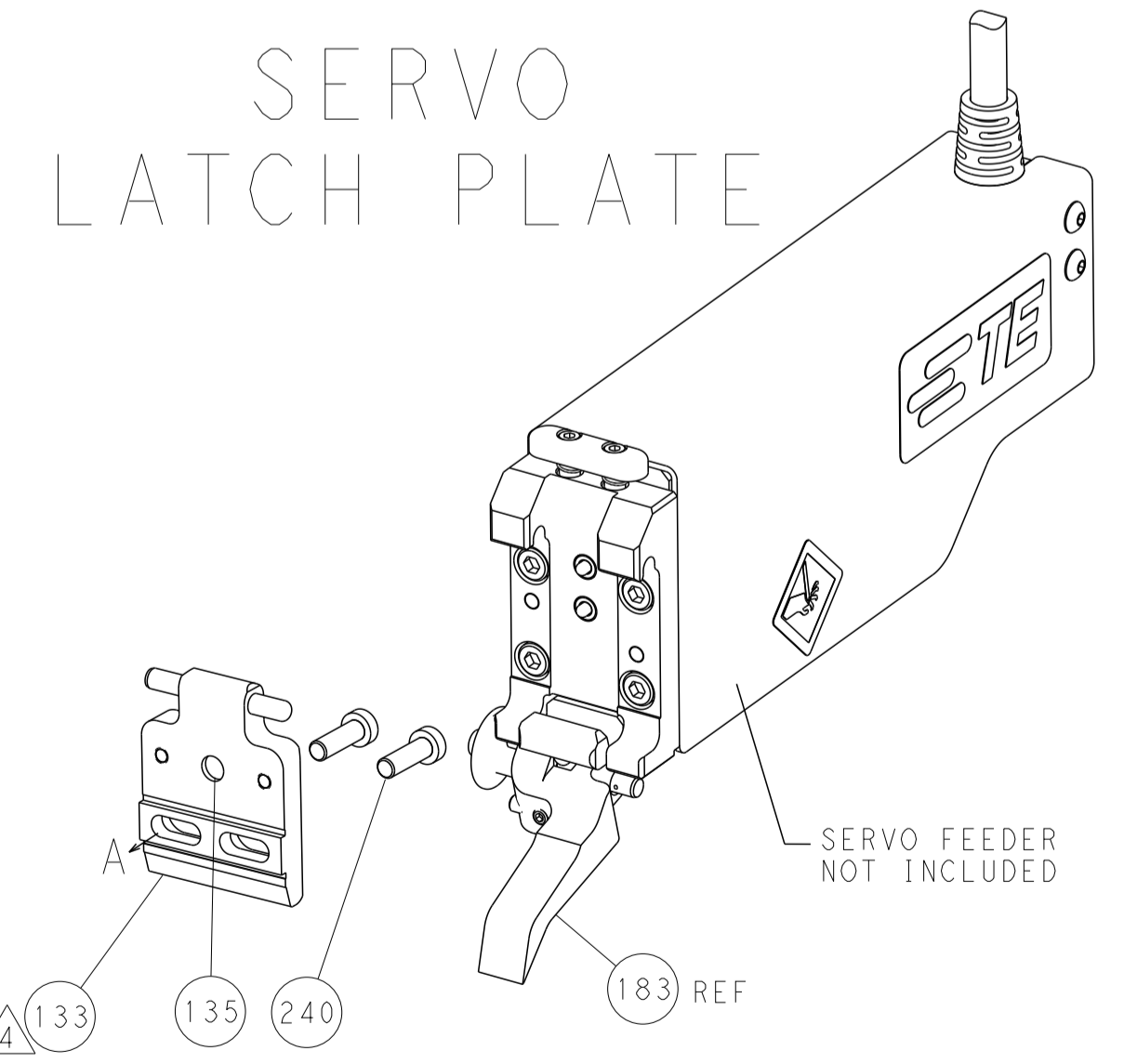
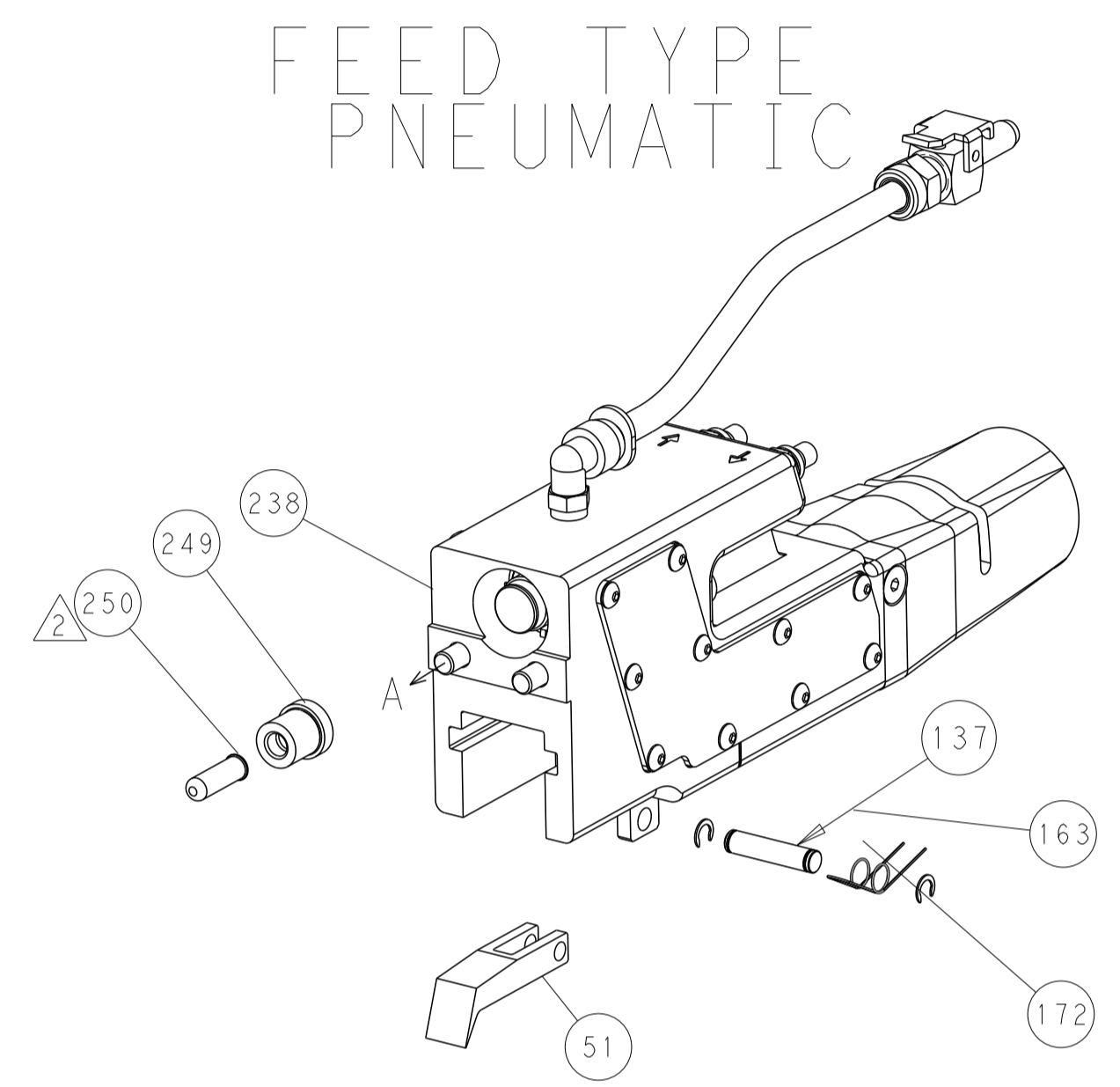
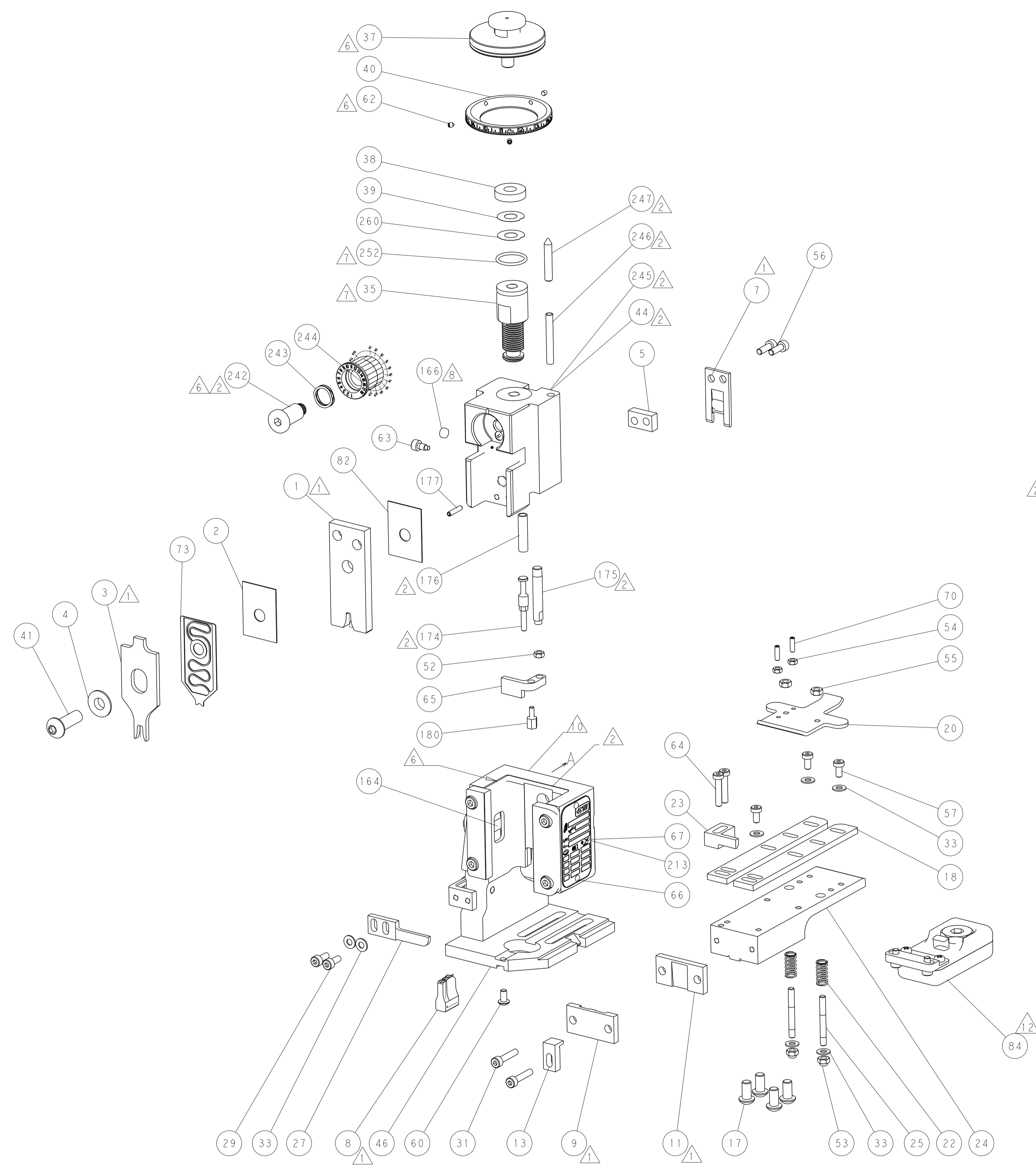


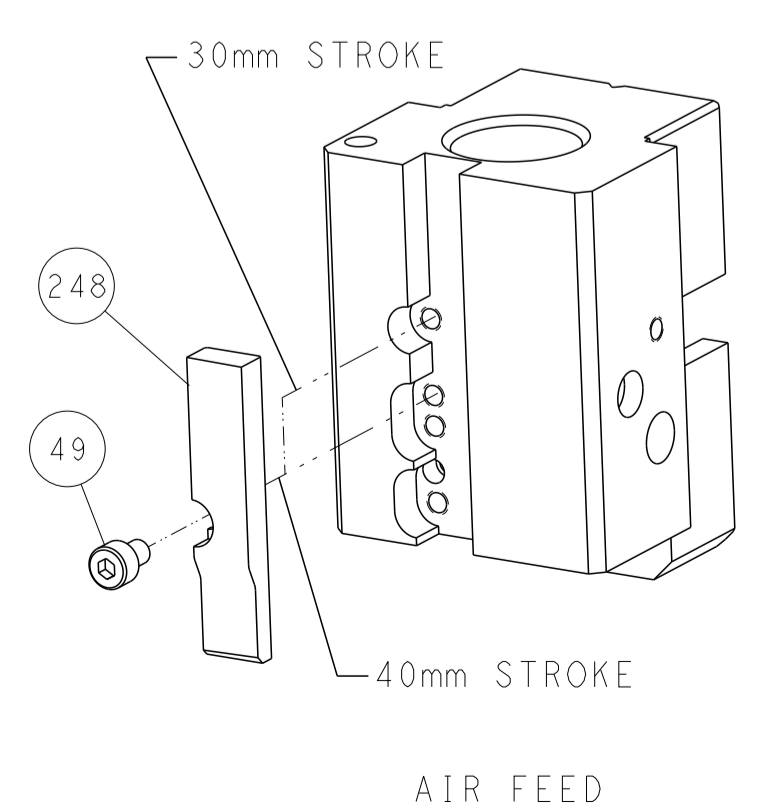
LOC	DIST	REVISIONS					
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1			



HOLDDOWN SET-UP



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001 FINISH:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150544	RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:1	SHEET 2 OF 4 REV B

APPLICATOR STYLE CONVERSION CHART

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150544-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150544-5	-	-
	2-2150544-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-
	2-2150544-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-
7-2150544-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-10390		

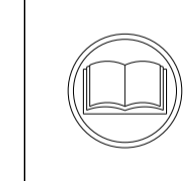
TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR	WIRE STRIP LENGTH 3.58-4.34 mm [.141-.171 IN]	INSULATION DIAMETER RANGE Ø2.29-4.32 mm [.090-.170 IN]
TERMINAL APPLICATION SPECIFICATION 114-2019	TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL	TE TERMINAL
63455-1		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR	WIRE STRIP LENGTH 3.58-4.34 mm [.141-.171 IN]	INSULATION DIAMETER RANGE Ø0.00-3.81 mm [.000-.150 IN]
TERMINAL APPLICATION SPECIFICATION 114-2019	TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL	TE TERMINAL
1217173-1	1217173-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
7600-8500 CMA	2.36 +/- 0.05 [.093 +/- .002]	5.6
4000-4800 CMA	1.98 +/- 0.05 [.078 +/- .002]	9.3



- 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: 8-2150544-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150544-5
- 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 & 180.
 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- TERMINAL LUBRICANT 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	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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)

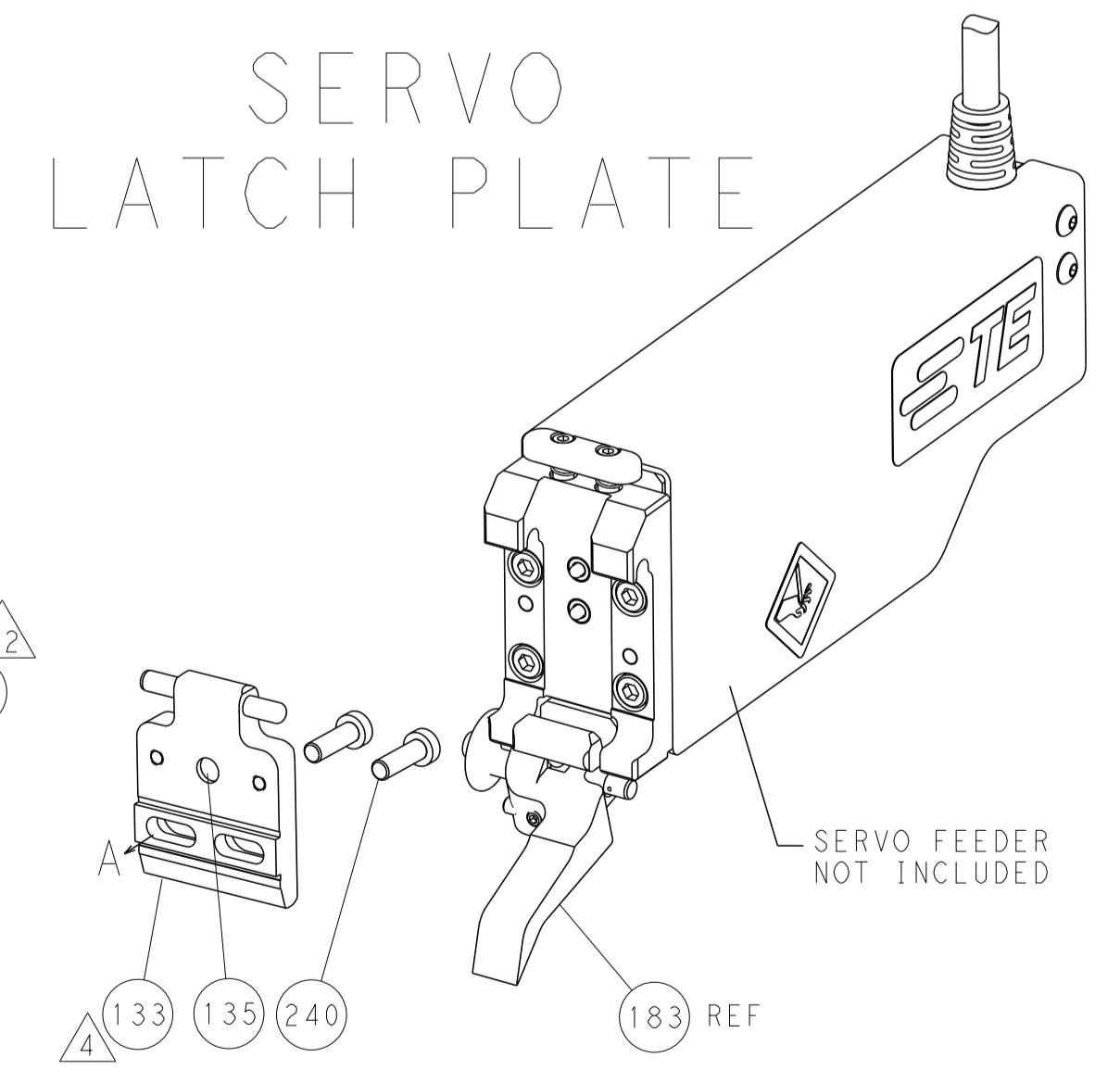
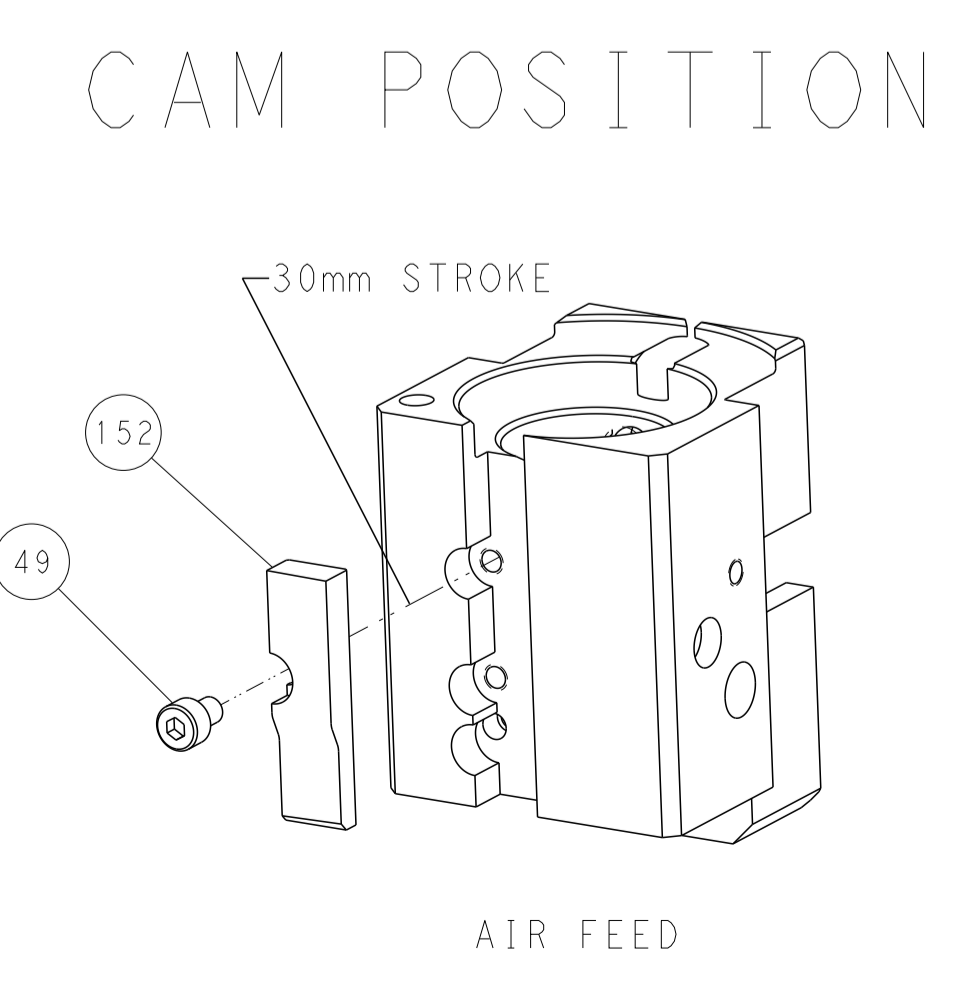
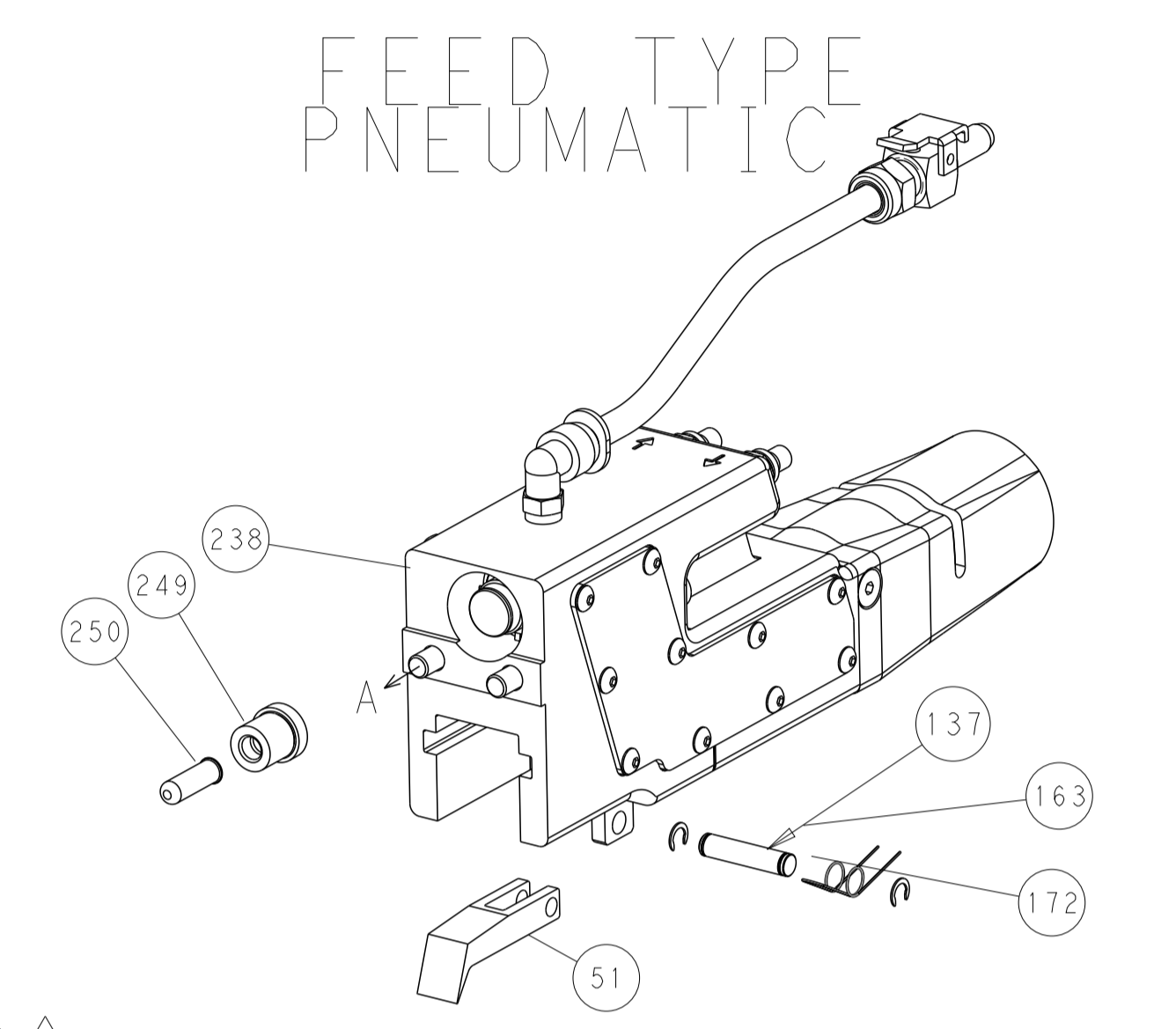
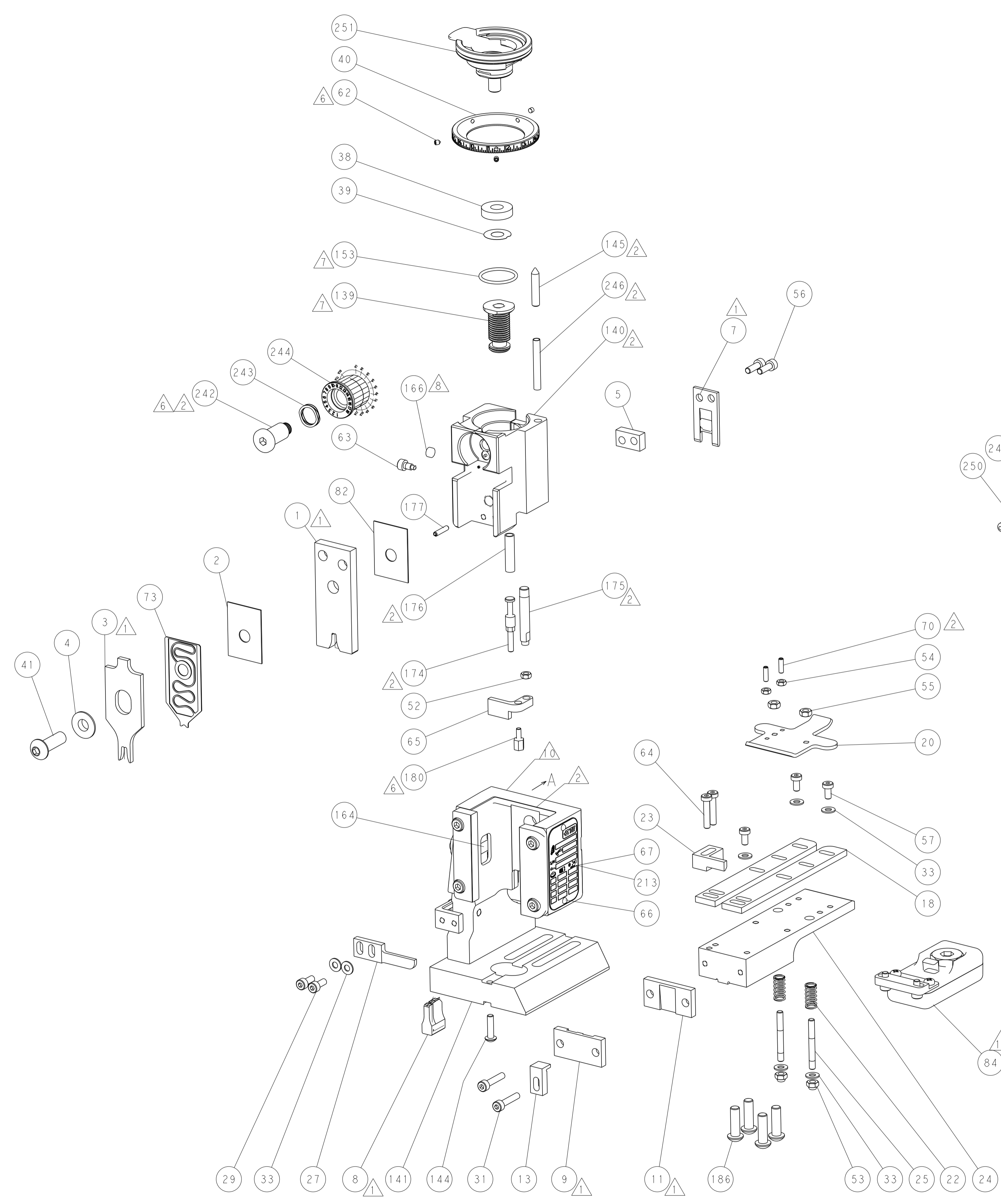
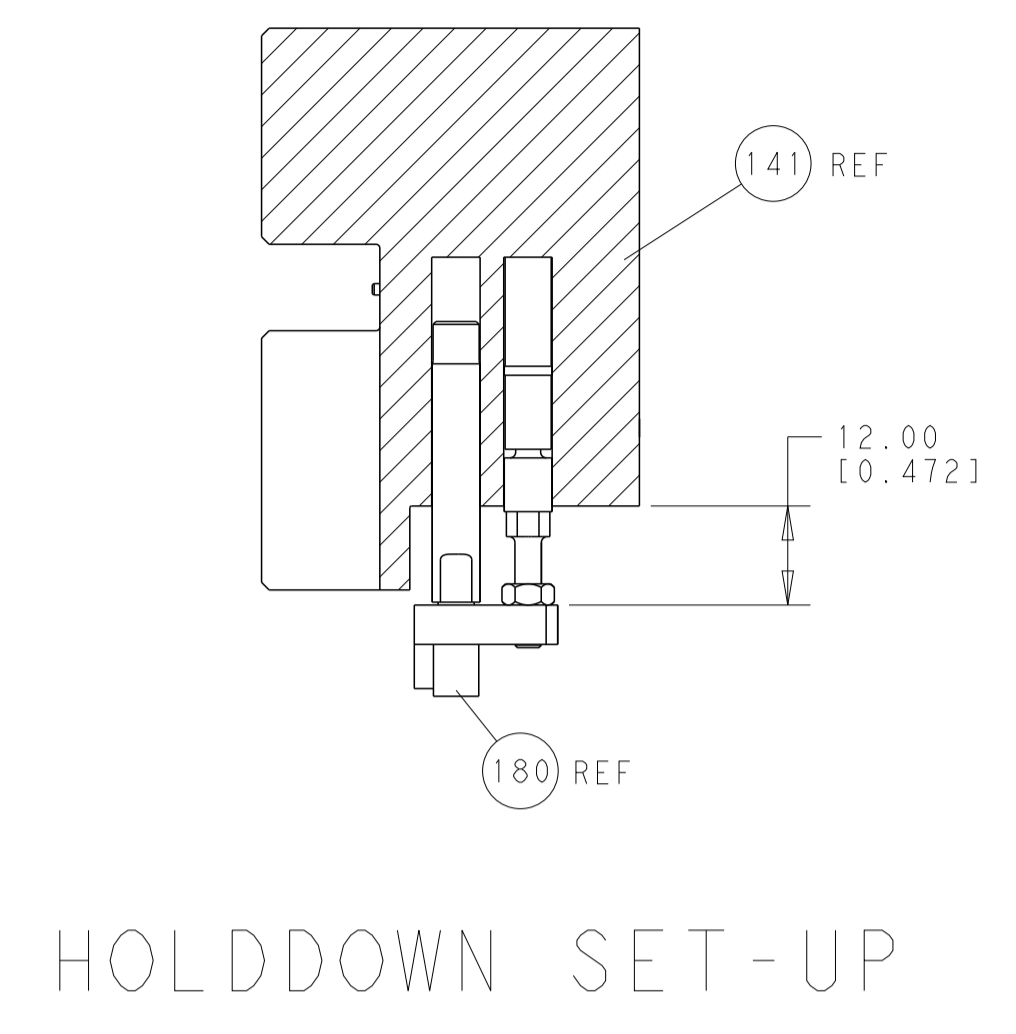
SET UP GAUGE 2119599-2 LOC A DIST 66

REV	DATE	BY	DESCRIPTION
1			SEE SHEET 1

REV	DATE	BY	DESCRIPTION	DATE	OWN	APVD
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	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
-	1	1	1	1-1752354-2	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	2119791-5	DEPRESSOR, WIRE	73
-	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
-	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
-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1752373-4	DRAG	20
-	2	2	2	1901259-7	GUIDE, LOWER STRIP	18
-	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	1	1	1	690482-4	PLATE, FRONT SHEAR	9
-	1	1	1	1803064-8	ANVIL, COMBINATION	8
-	1	1	1	690474-4	BLADE, SLUG	7
-	1	1	1	8-240641-8	SPACER	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	7-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	1	462808-7	CRIMPER, BLUNT F	1

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1		DWG. STAKEM APRIL 2015 CHK. G. BAILEY APRIL 2015 APVD. T. ELBIN APRIL 2015		NAME Ocean End Feed Applicator	
MATERIAL		FINISH		WEIGHT		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				A1 00779 ©=2150544		Customer Accessible Production Drawing SCALE 1:1 SHEET 3 OF 4 REV B	

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



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±		NAME: Ocean End Feed Applier APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150544 SHEET 4 OF 4 REV B
MATERIAL: - FINISH: -		RESTRICTED TO: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION