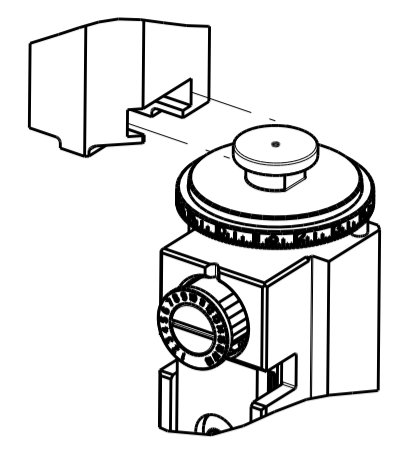


APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.



APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes wire and insulation specifications.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Table with columns: TE TERMINAL, TE CRIMP SPECIFICATION.

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING.

- 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.
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 50 & 62.
GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
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.
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.
WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT
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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various parts like applicator shim pack, o-ring, push rod, etc.

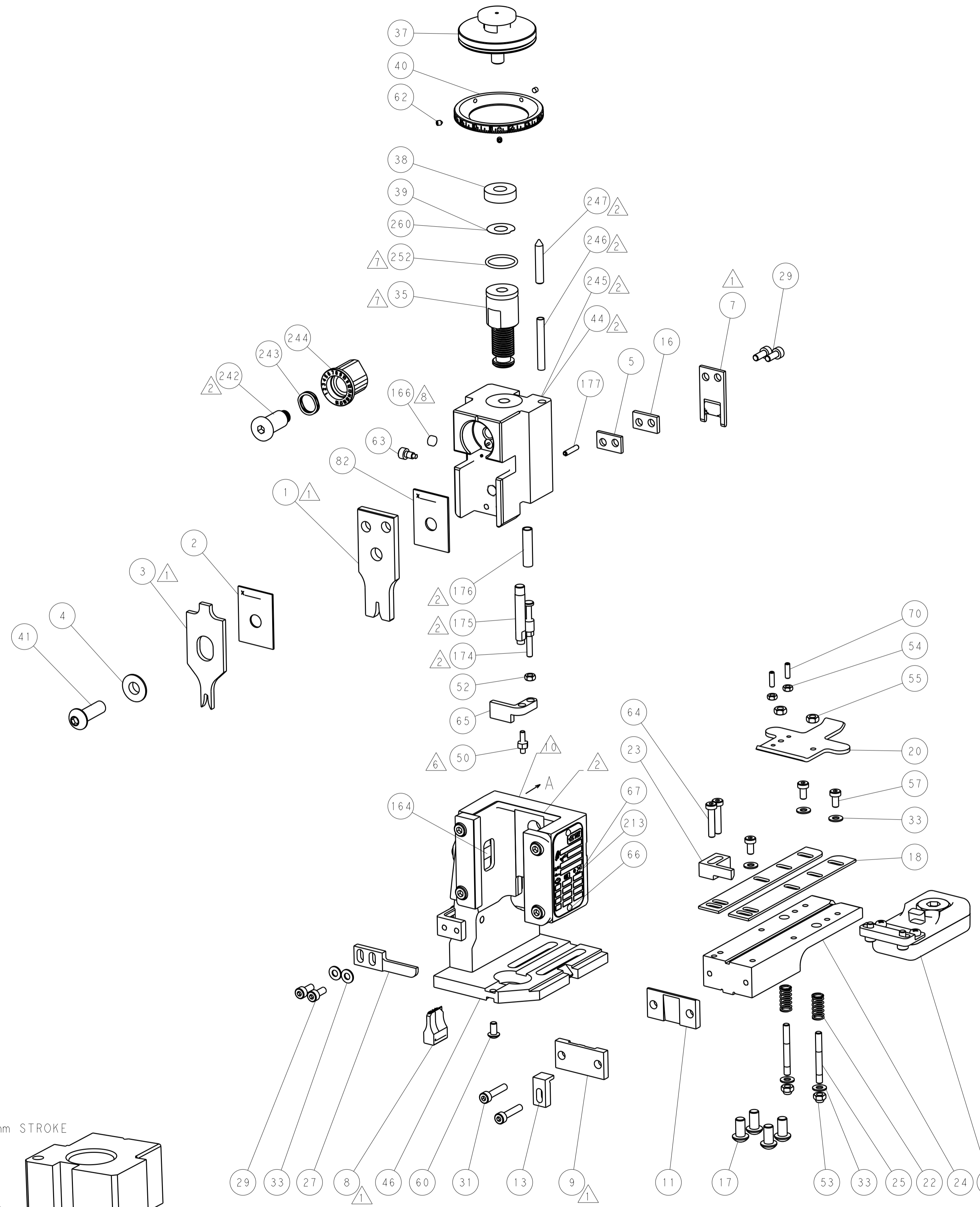
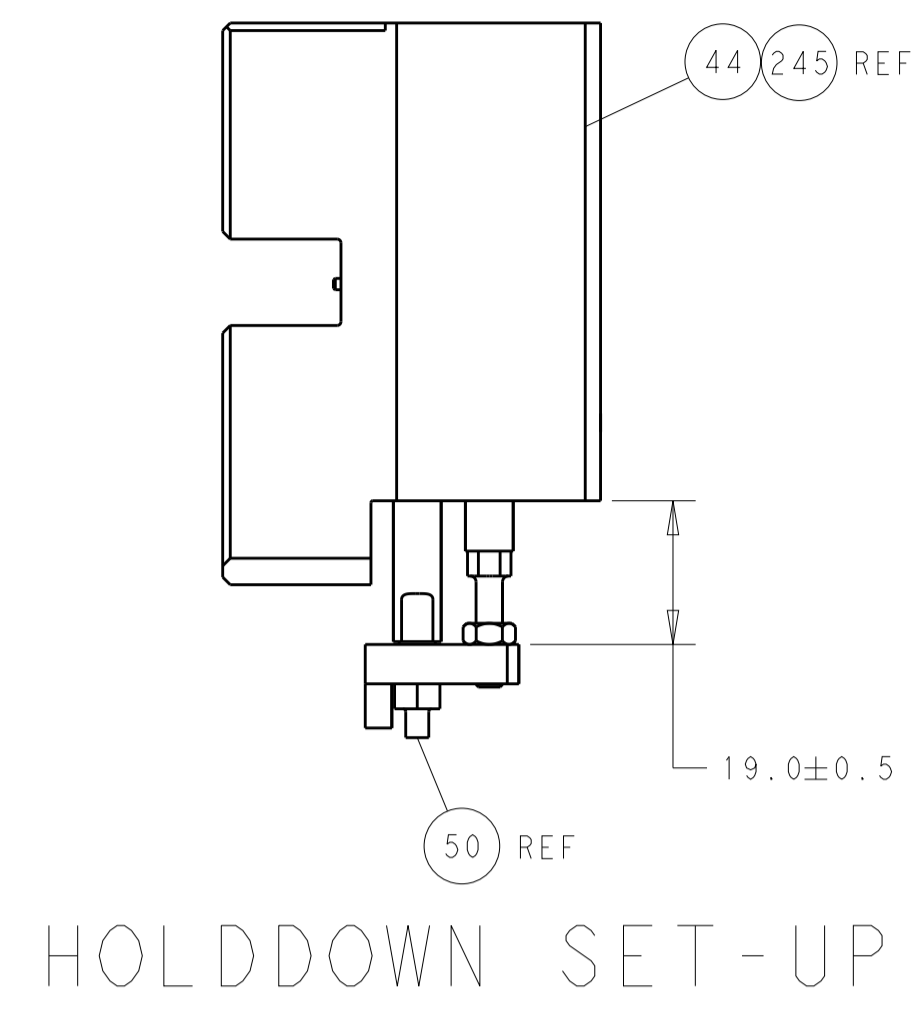
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

REVISIONS table with columns: REVISION, DATE, OWN, APVD. Lists revision details for ECR-16-009855 and ECR-16-012334.

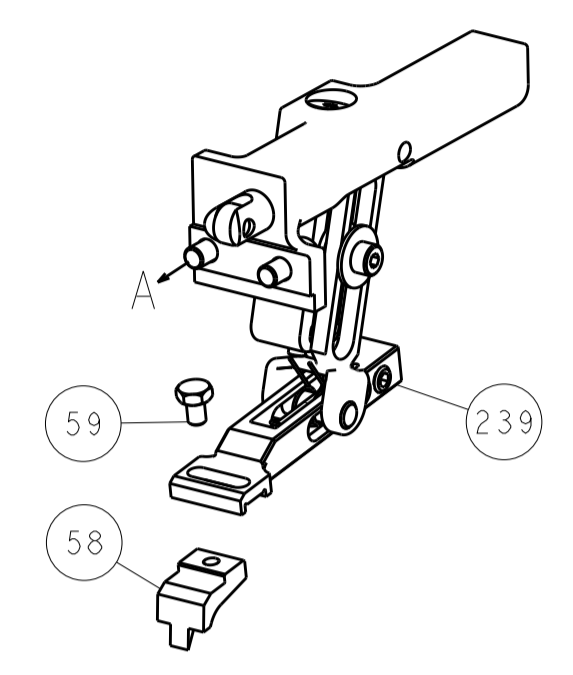
Main parts list table with columns: PART NUMBER, DESCRIPTION, DATE, OWN, APVD. Lists numerous components like CAM, SNAIL, INSULATION ADJUSTMENT, WASHER, WAVE SPRING, etc.

Customer Accessible Production Drawing table with columns: DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE, SHEET, REV. Includes drawing specifications and drawing ID A100779.

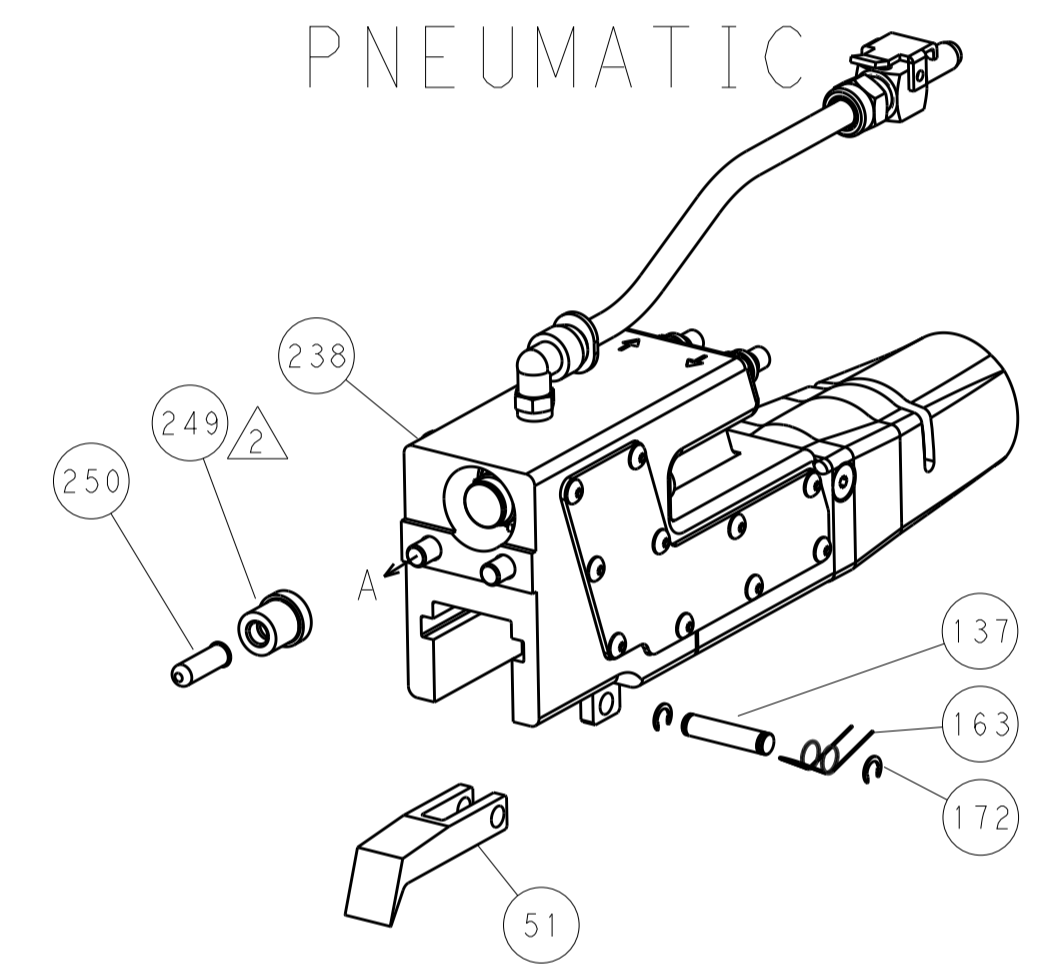
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A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
				SEE SHEET 1			



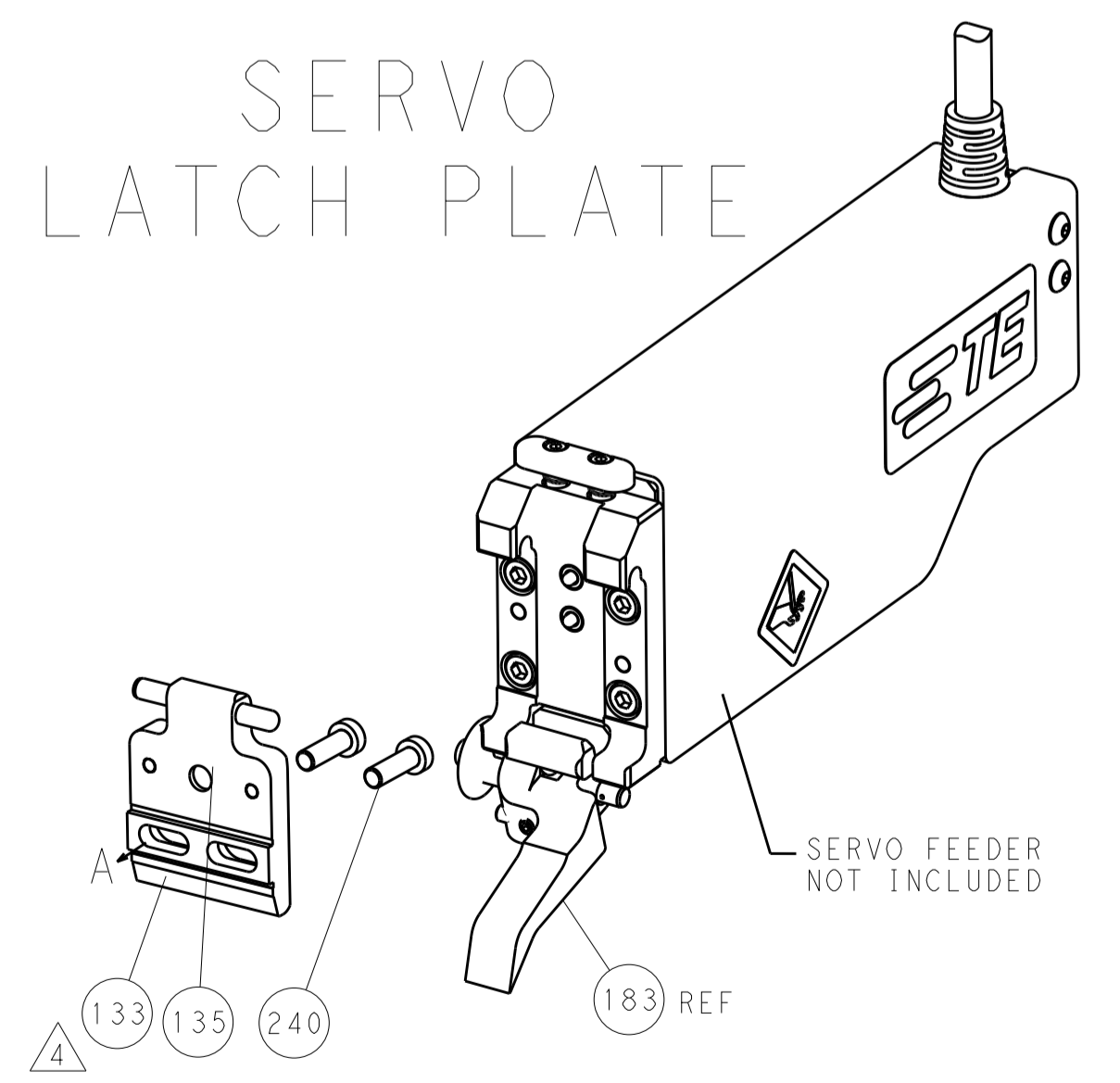
FEED TYPE
MECHANICAL



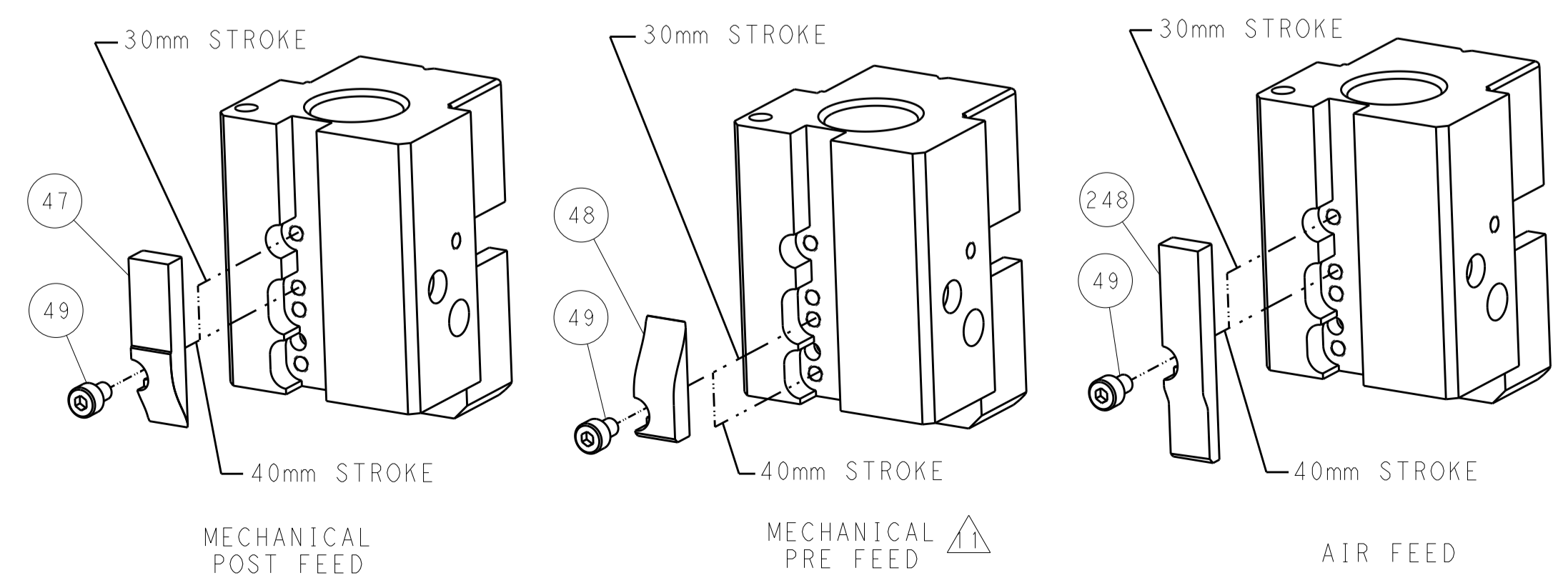
PNEUMATIC



SERVO
LATCH PLATE

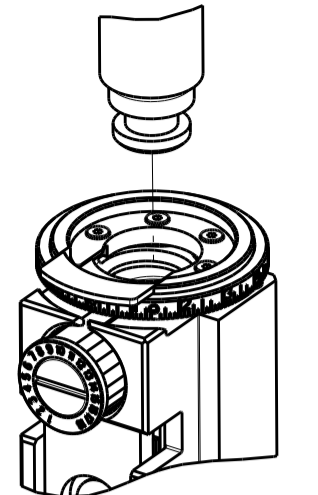


CAM POSITIONS

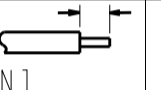


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

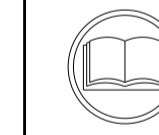
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: L. ZHANG 22FEB2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: L. ZHANG 22FEB2012		NAME: Ocean End Feed Applicator	
				APVD: S. XI 22FEB2012		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2150155	
				WEIGHT:		SCALE: 1:1	
				Customer Accessible Production Drawing		SHEET 2 OF 4	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO								
					PART NUMBERS REQUIRED								
	2-2150155-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1		
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150155-5	-	-	2168400-7 (QUANTITY 2)		
					SMART APPLICATOR	2161326-1	-	8-2150155-4	-	-	-		
	2-2150155-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	-	
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150155-5	-	-	2168400-7 (QUANTITY 2)		
					SMART APPLICATOR	2161326-1	-	8-2150155-4	-	-	-		
	2-2150155-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	-	
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1		
	2-2150155-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-	
	7-2150155-7	D	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE	WIRE	TYPE
2.03 mm [.080]	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: .250 SRS FASTIN-ON REC		
WIRE STRIP LENGTH 5.80-6.40 mm [.228-.252 IN]		INSULATION DIAMETER RANGE ∅1.40-2.29 mm [.055-.090 IN]
TERMINAL APPLICATION SPECIFICATION	114-2025	-
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
160928-1	160928-2	160928-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36 +/- 0.05 [.054 +/- .002]	6.0
0.75mm2	1.27 +/- 0.05 [.050 +/- .002]	6.9
0.50mm2	1.18 +/- 0.05 [.046 +/- .002]	7.9



1. RECOMMENDED SPARE PARTS
2. 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:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150155-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150155-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150155-5
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 ITEM 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
8. 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. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
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.
12. 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.

-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
- 1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243

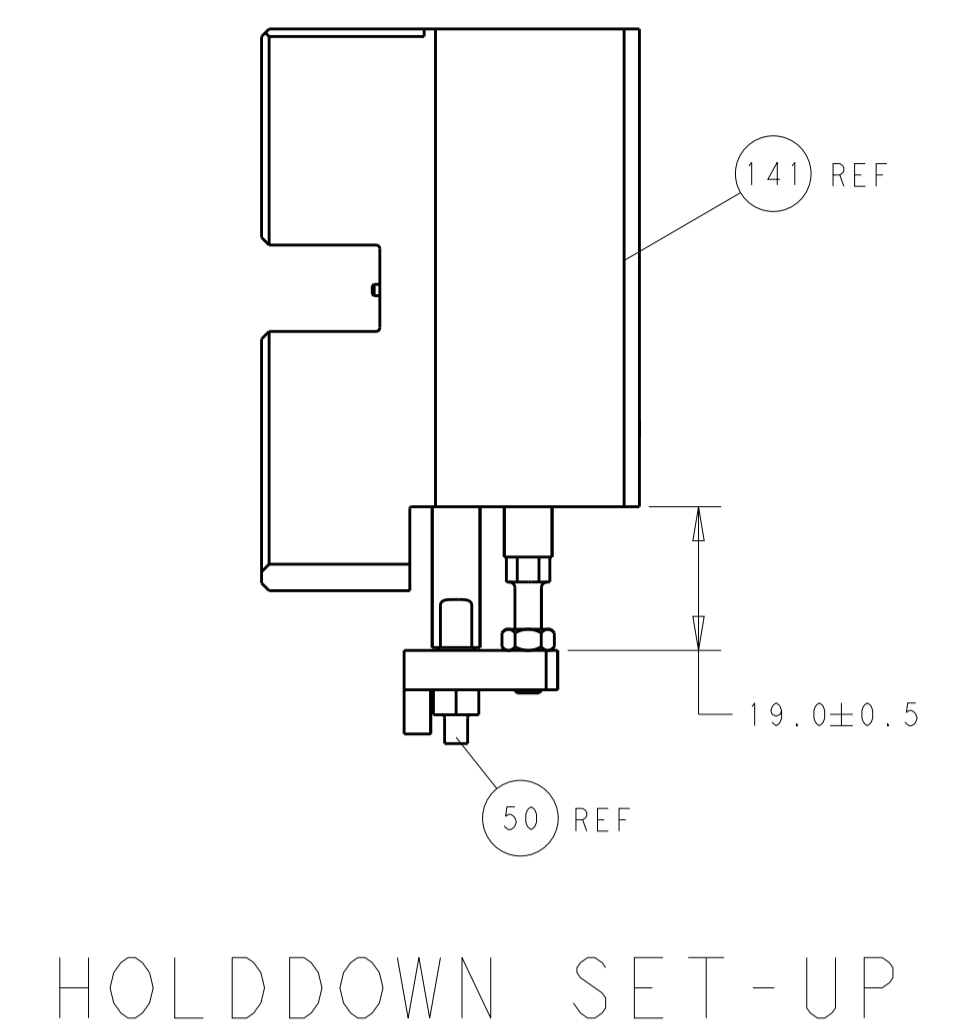
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

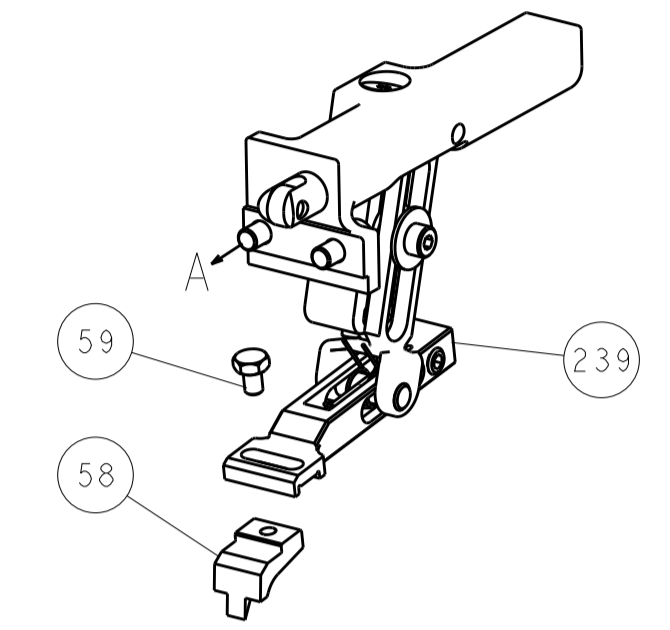
REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
- 1 1 1 1 1	2119083-1			RETAINER, INSULATION DIAL	242
- - 2 - -	2168400-7			SHCS, LOW HEAD, RoHS, M5 X 10	240
- - - 1 -	2119580-1			MECHANICAL FEED ASSEMBLY	239
- - - 1 -	2063440-1			AIR FEED MODULE	238
- - 1 - -	2119740-2			TAG, IDENTIFICATION	213
- 4 4 4 4	2079383-9			SCR, BHSC, RoHS (M6 X 20)	186
- - REF - -	1901697-1			FEED FINGER ASSEMBLY, EF	183
- 1 1 1 1 1	6-993111-6			PIN, SLOTTED SPRING 3.0 X 14.0	177
- 1 1 1 1 1	8-22280-7			SPRING, COMPRESSION	176
- 1 1 1 1 1	1752353-2			GUIDE PIN, HOLDDOWN	175
- 1 1 1 1 1	1901680-2			GUIDE PIN, HOLDDOWN	174
- - - 2 -	21045-3			RING, RETAIN, EXTERN, 3/16 CRESCENT	172
- 1 1 1 1 1	994969-1			MAGNET, RARE EARTH HIGH ENERGY	166
- REFREFREFREF	994970-2			COUNTER, MAGNETIC	164
- - - 1 -	240638-1			SPRING, FEED FINGER	163
- 1 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 1	2119798-2			DETENT PIN	145
- 1 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 1	2119655-6			APPLICATOR BASIC ASSEMBLY, EF	141
- 1 1 1 1 1	2119651-1			RAM, ASIAN STYLE, END FEED	140
- 1 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 1	2119955-2			ASSY, LUBRICATOR, END FEED	84
- 1 1 1 1 1	1-455888-0			SPACER, CRIMPER	82
- 1 1 1 1 1	2119956-2			DOCUMENTATION PACKAGE	71
- 2 2 2 2 2	2-18032-2			SCR, SET, FLT POINT M3 X 10.0	70
- 1 - 1 1 1	2119740-1			TAG, IDENTIFICATION	67
- 2 2 2 2 2	2168078-1			SCREW, DRIVE, RH, RoHS, 2 x .188	66
- 1 1 1 1 1	1901681-5			HOLDDOWN, TERMINAL	65
- 2 2 2 2 2	2168400-5			SHCS, LOW HEAD, RoHS, M4 X 20	64
- 1 1 1 1 1	2119793-1			LIMITER, ADJUSTMENT BOLT	63
- 3 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
- 3 3 3 3 3	2168400-4			SHCS, LOW HEAD, RoHS, M4 X 8	57
- 2 2 2 2 2	5018030-2			NUT, HEX, REG, RoHS, M4	55
- 2 2 2 2 2	5018030-1			NUT, HEX, REG, RoHS, M3	54
- 2 2 2 2 2	986965-8			NUT, LOCK, HEX, TORQUE (M4)	53
- 1 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	1-1976055-3			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 1	2079383-7			SCR, BHSC, RoHS (M8 X 25)	41
- 1 1 1 1 1	2119645-1			DISC, NUMBERED FA WIRE ADJUSTMENT	40
- 1 1 1 1 1	2119957-1			APPLICATOR SHIM PACK	39
- 1 1 1 1 1	2119644-1			RAM WASHER, PRECISION	38
- 7 7 7 7 7	1-18028-2			WASHER, FLAT, REG M4	33
- 2 2 2 2 2	2168083-9			SCR, SKT HD CAP, RoHS, M4 X 20	31
- 4 4 4 4 4	1-2168083-0			SCR, SKT HD CAP, RoHS, M4 X 10	29
- 1 1 1 1 1	240639-1			STRIPPER (MACHINING)	27
- 2 2 2 2 2	1320906-1			STUD, THREADED	25
- 1 1 1 1 1	1752371-3			PLATE, STRIP GUIDE	24
- 1 1 1 1 1	240825-1			PLATE, STRIP HOLD DOWN	23
- 2 2 2 2 2	2-22281-3			SPRING, COMPRESSION	22
- 1 1 1 1 1	1752373-1			DRAG	20
- 2 2 2 2 2	1901259-3			GUIDE, LOWER STRIP	18
- 1 1 1 1 1	240641-2			SPACER	16
- 1 1 1 1 1	1752360-1			SPACER, HOLD-DOWN	13
- 1 1 1 1 1	240833-3			PLATE, REAR SHEAR	11
- - - - -	-			-	10
- 1 1 1 1 1	1-690482-0			PLATE, FRONT SHEAR	9
1 1 1 1 1 1	3-1333216-2			ANVIL, COMBINATION	8
- 1 1 1 1 1	1-2217206-3			BLADE, SLUG	7
- 1 1 1 1 1	3-240641-7			SPACER	5
- 1 1 1 1 1	238009-1			BLOCK, FL CRIMPER SPACER	4
1 1 1 1 1 1	1633963-1			CRIMPER, INSULATION OVERLAP PREMIUM	3
- 1 1 1 1 1	455888-8			SPACER, CRIMPER	2
1 1 1 1 1 1	456405-3			CRIMPER, WIRE PREMIUM	1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APPROVED:	DATE:	NAME:
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	APPROVED: [Signature] DATE: 22FEB2012	DATE: 22FEB2012	NAME: L. ZHANG
MATERIAL:		PRODUCT SPEC: [Blank]		
FINISH:		APPLICATION SPEC: [Blank]		
WEIGHT:		SIZE: A1 CASE CODE: 00779 DRAWING NO: C-2150155		
SCALE: 1:1		RESTRICTED TO: [Blank]		

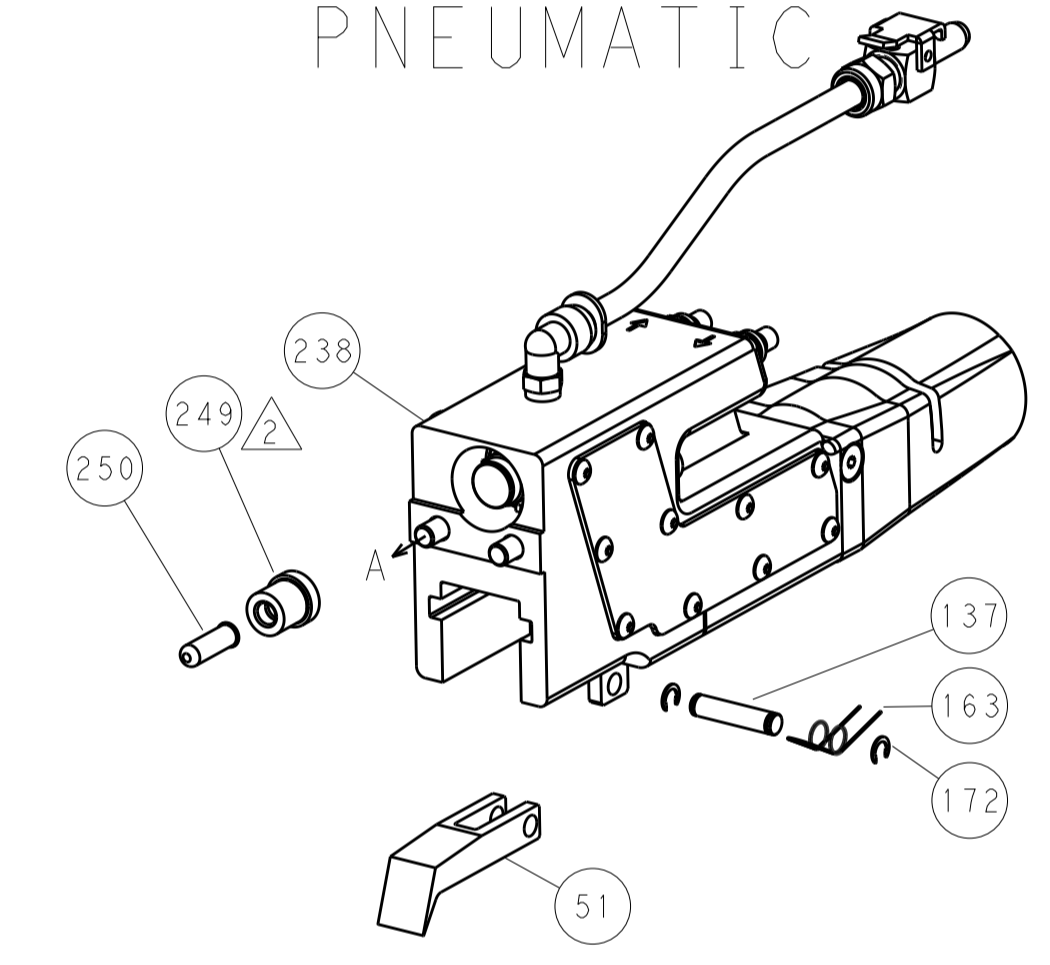
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1			



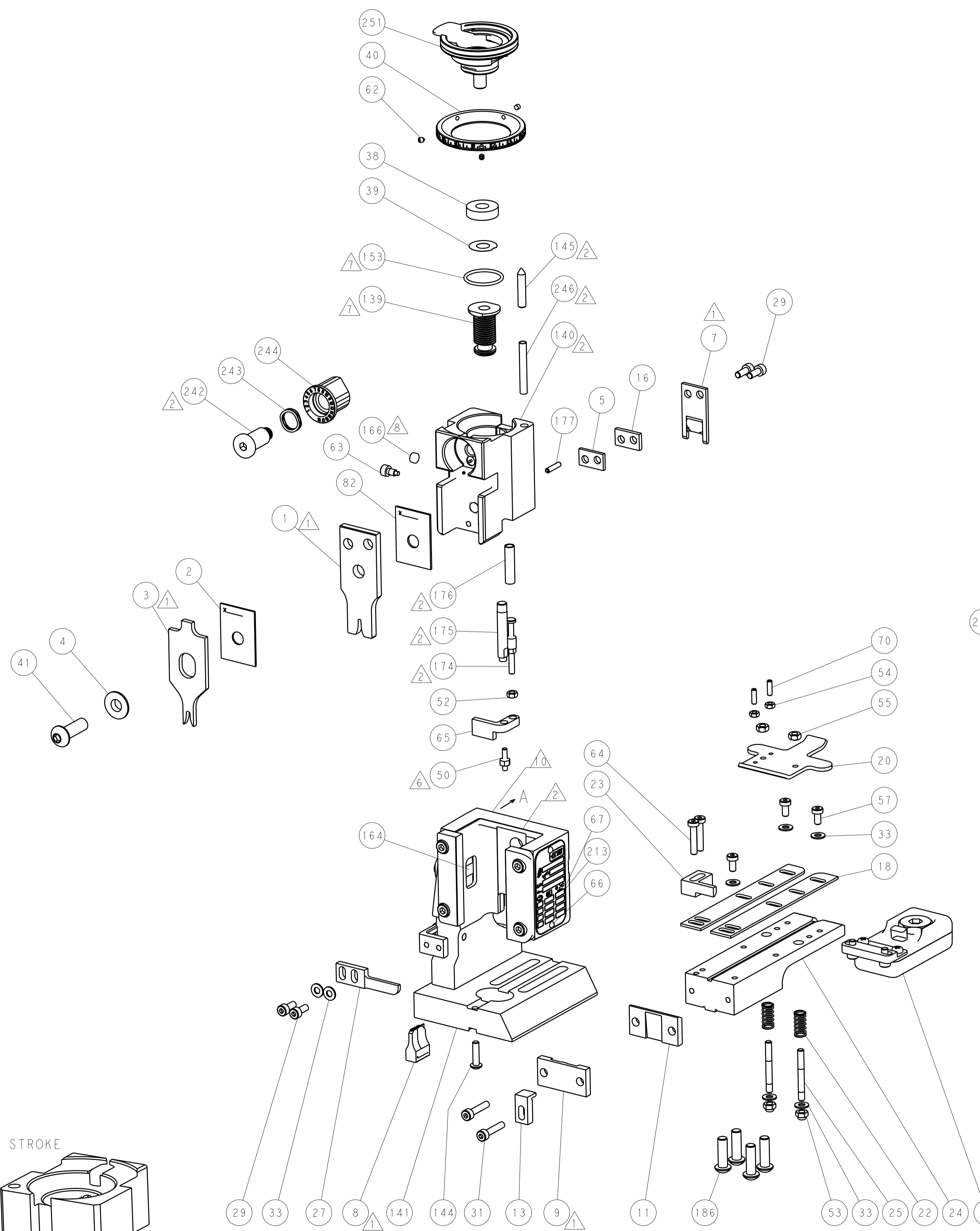
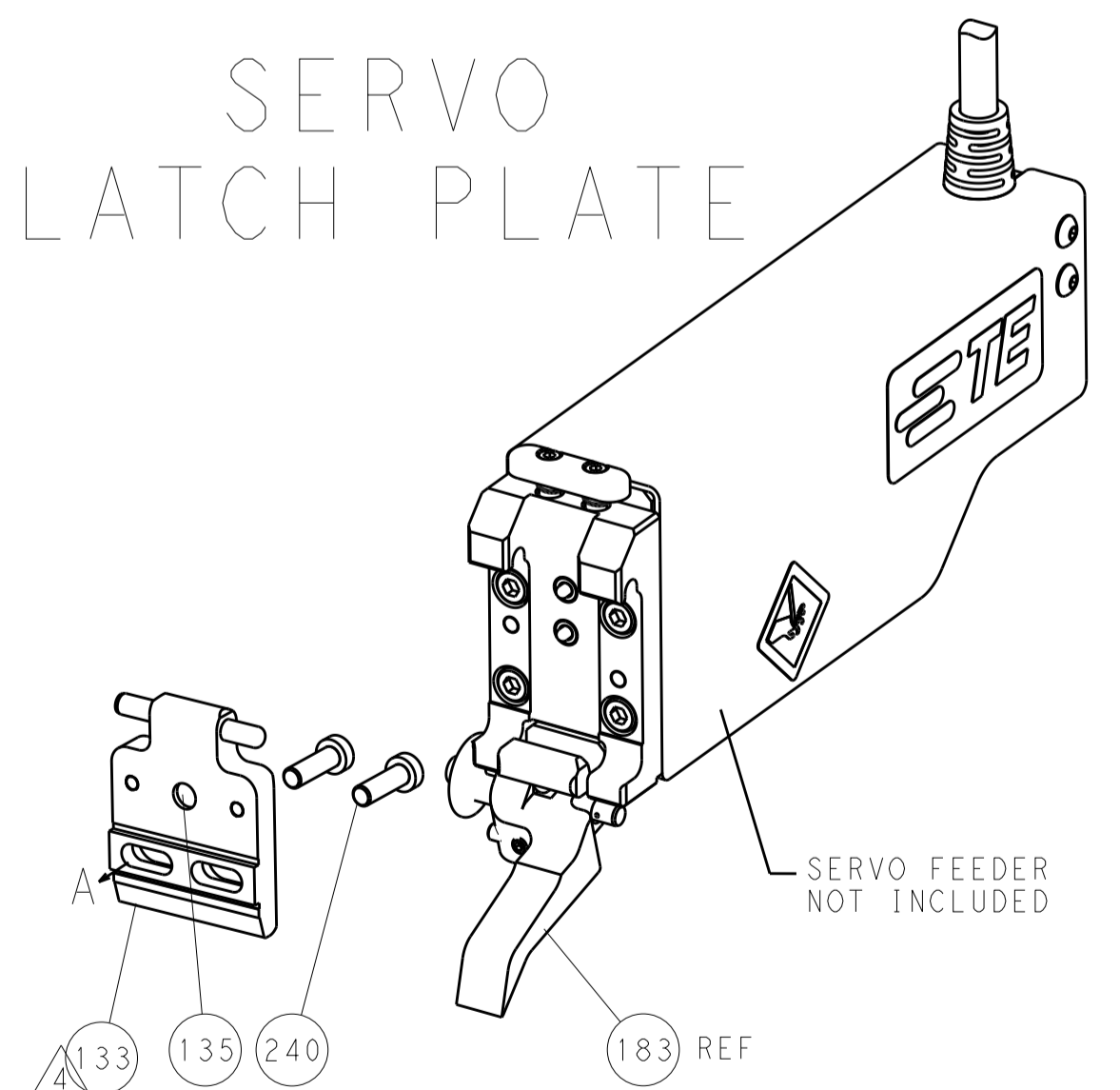
FEED TYPE
MECHANICAL



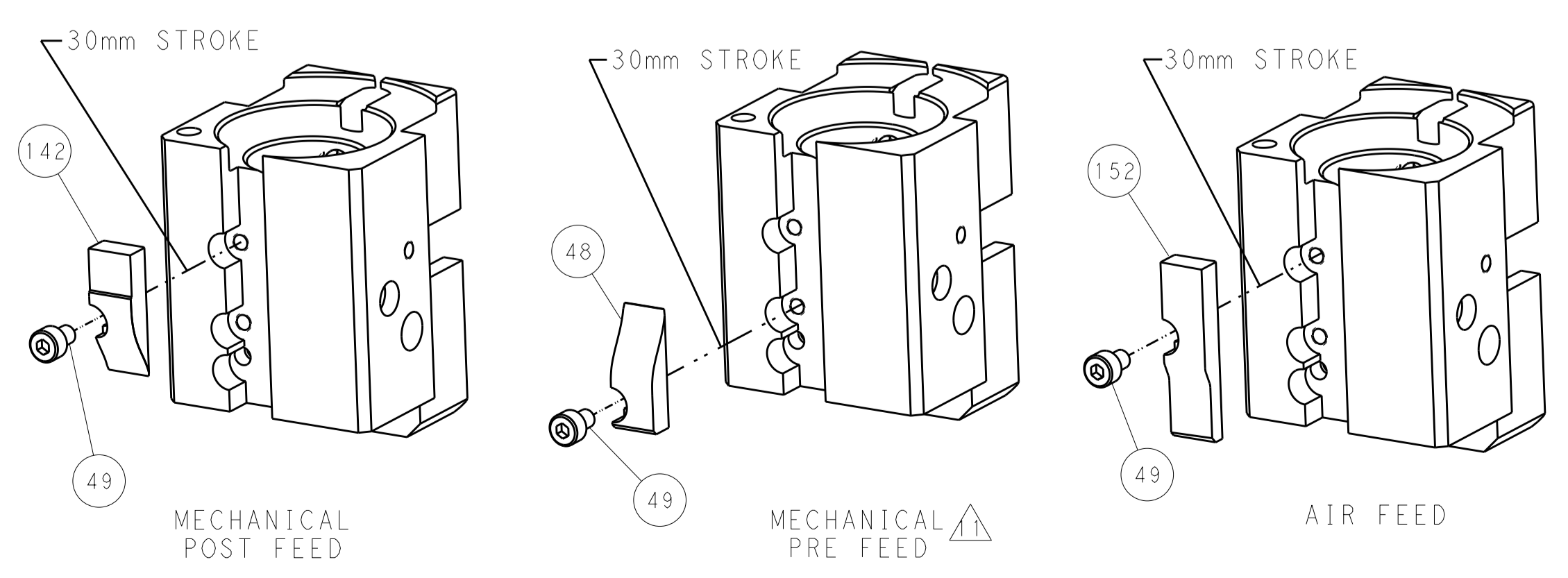
PNEUMATIC



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:		DWN L. ZHANG 22FEB2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	NAME Ocean End Feed Applicator
MATERIAL	FINISH	WEIGHT	APVD S. XI 22FEB2012	PRODUCT SPEC	APPLICATION SPEC	SIZE CAGE CODE DRAWING NO	RESTRICTED TO
			Customer Accessible Production Drawing	SCALE 1:1	SHEET 4 OF 4	REV D	