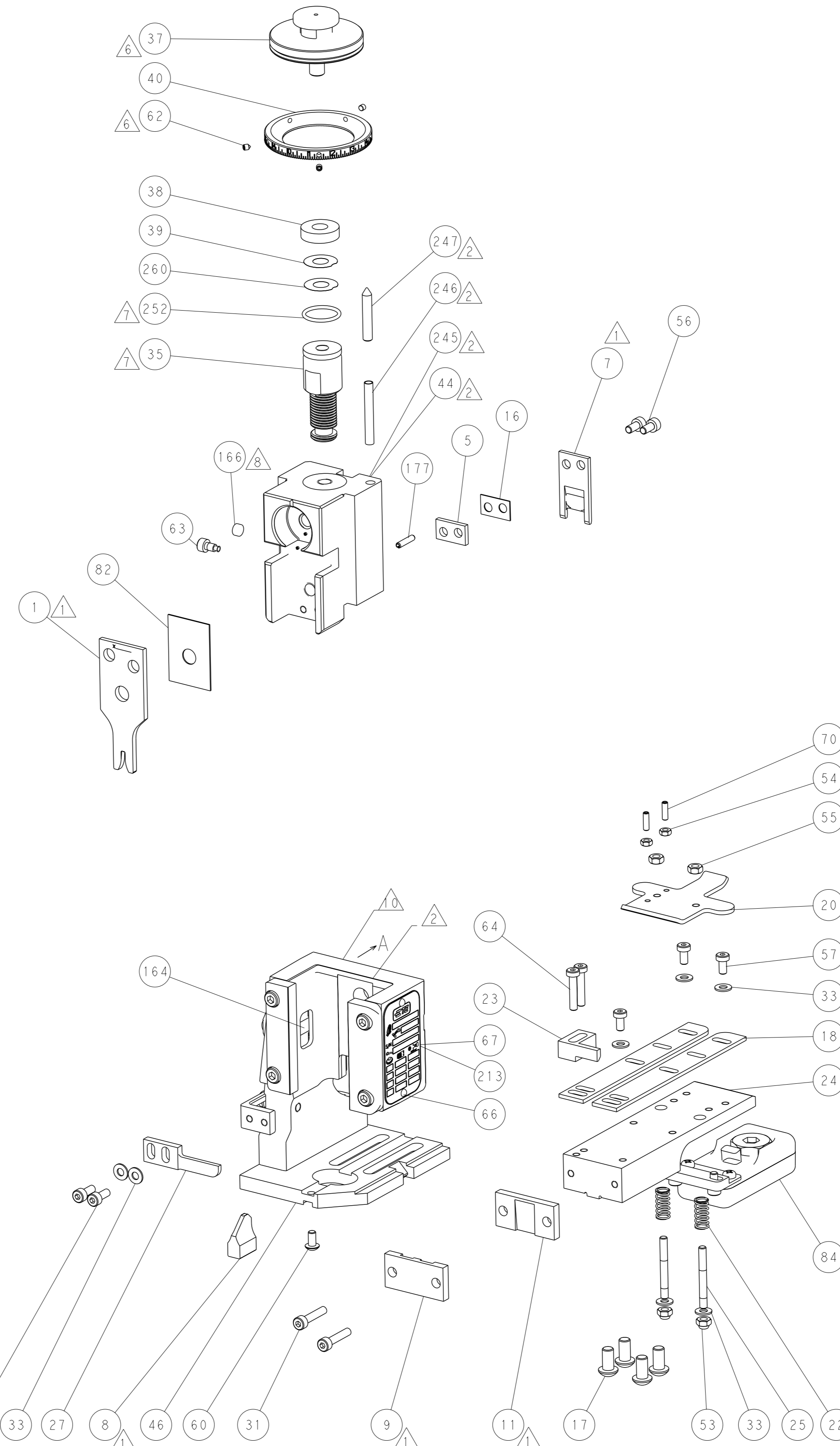
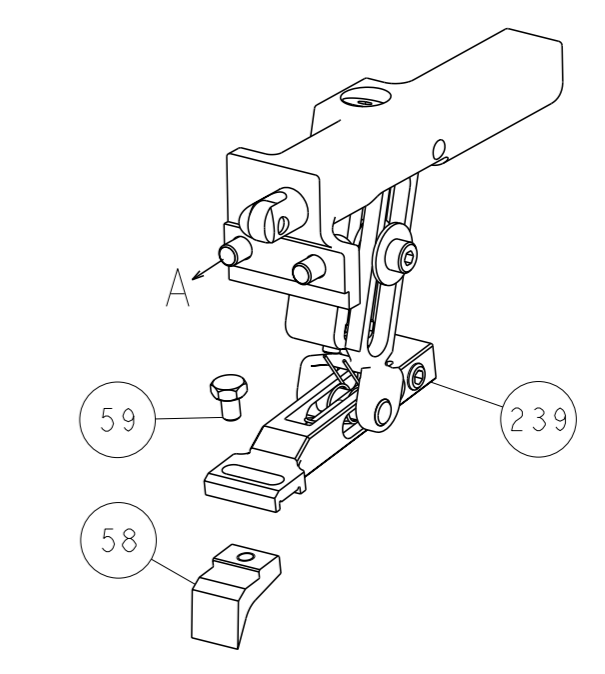


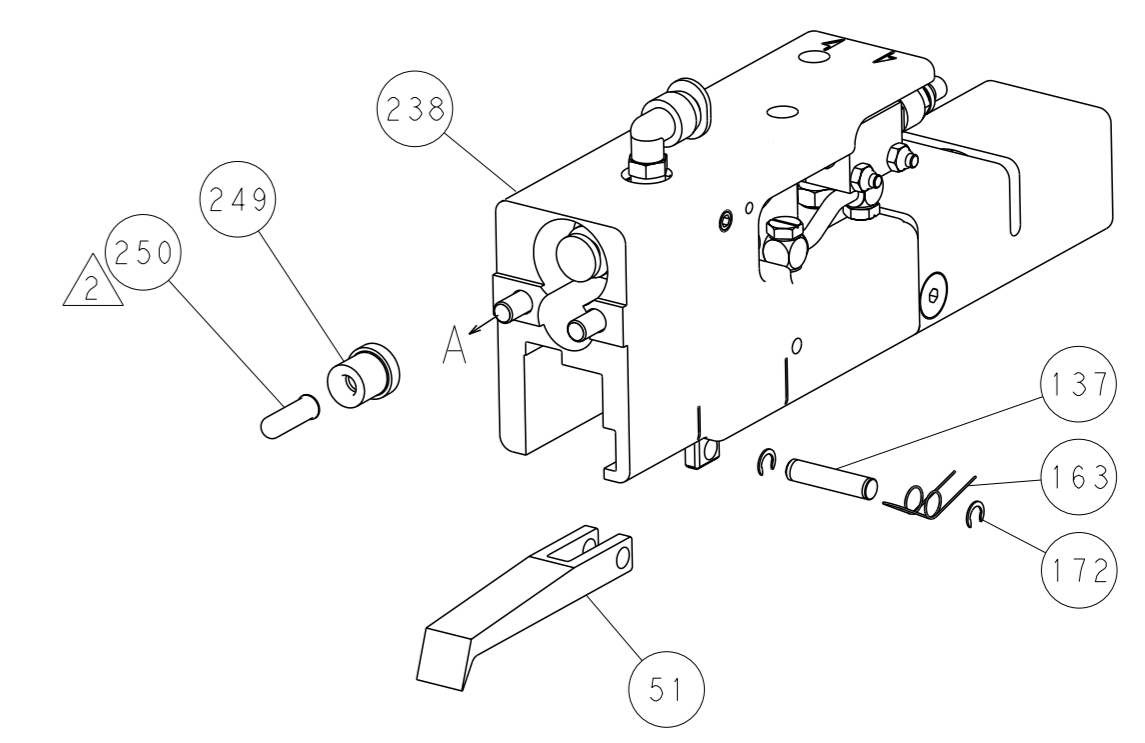
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|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LYR | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | | | |



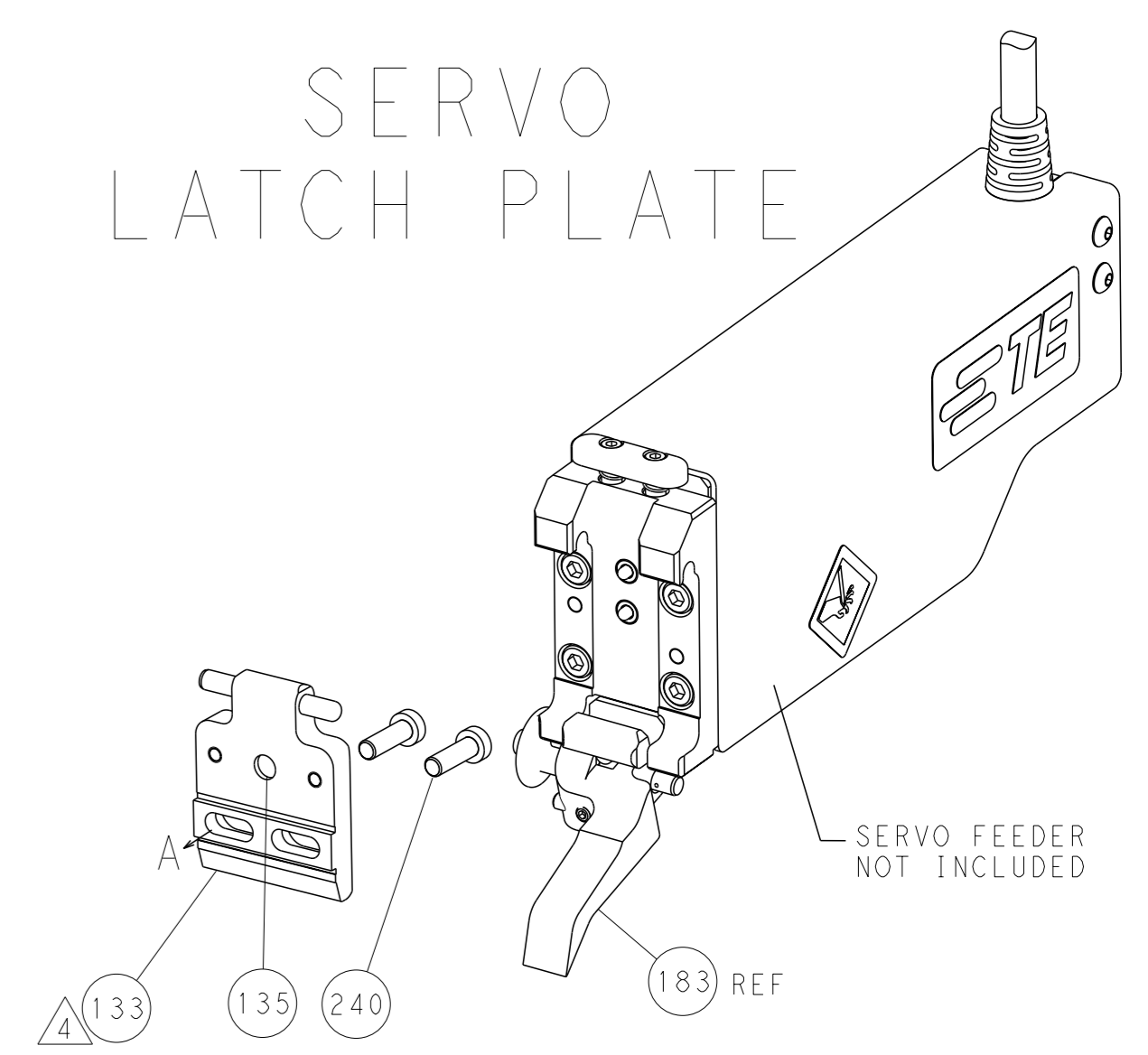
FEED TYPE MECHANICAL



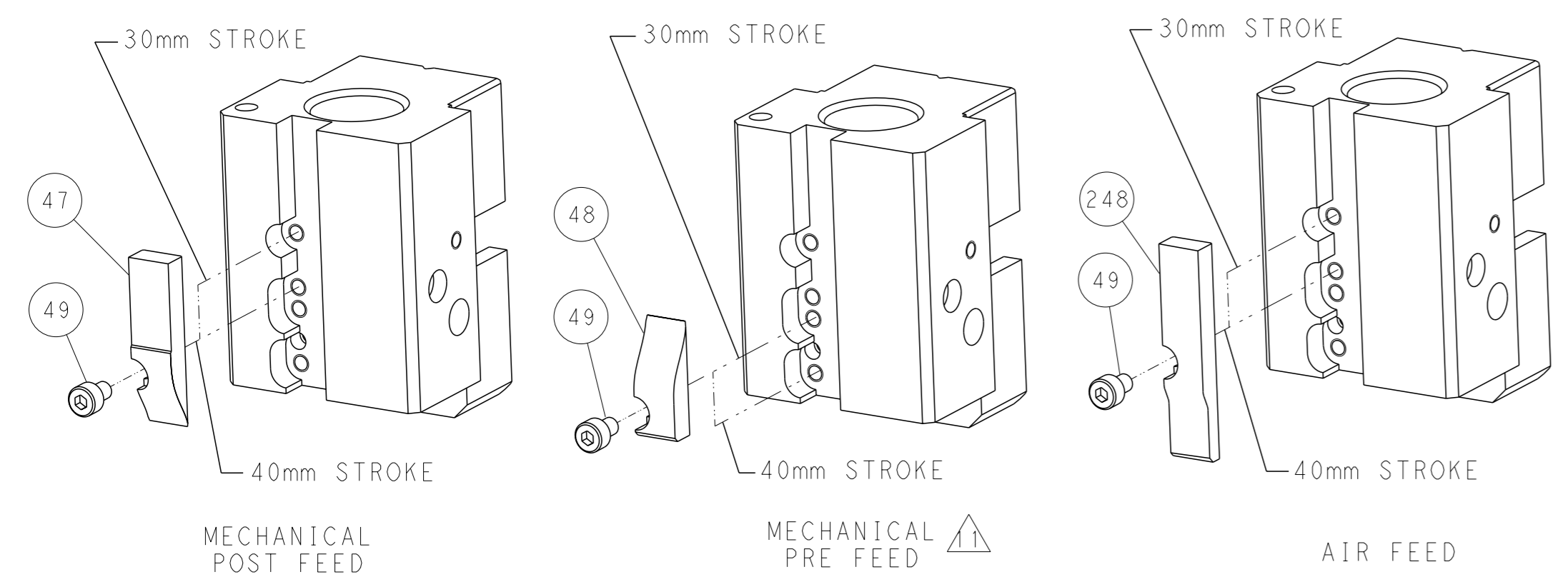
PNEUMATIC



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)

| | | | |
|--|---|--|---|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER MUST CONTACT THE DESIGNING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: HOFFNER 17JUNE2014 CHK: T.ELBIN 18JUNE2014 APVD: T.ELBIN 18JUNE2014 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.001 4 PLC ±0.001 ANGLES ±.1 | NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150452 | RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: A |
| MATERIAL: - FINISH: - | | APPLICATION SPEC: - WEIGHT: - Customer Accessible Production Drawing | Customer Accessible Production Drawing |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2150452-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-1 | - | 2119641-2 | - | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150452-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150452-4 | - | - | - |
| | 2-2150452-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150452-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150452-4 | - | - | - |
| | 2-2150452-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-1 | - | 2119641-2 | - | 2063440-1 |
| | 2-2150452-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2150452-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|-----------------------------|------|--|
| CRIMP SIZE | TYPE | |
| WIRE 2.29 mm [.090] | F | |
| INSUL 0.01 mm [.000] | - | |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: RECEPTACLE, FASTON, .187 SERIES | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.39-5.16 mm [.173-.203 IN] | | Ø2.25-3.00 mm [.089-.118 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-2036 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 42799-1 | 42373-2 | 42374-2 | 63785-1 |
| 42799-2 | 42373-3 | 61969-1 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 16 AWG | 1.52 +/- 0.05 [.060 +/- .002] | 4.9 |
| 18 AWG | 1.35 +/- 0.05 [.053 +/- .002] | 6.7 |
| 20 AWG | 1.25 +/- 0.05 [.049 +/- .002] | 7.7 |

- 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:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150452-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150452-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150452-5
- 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.
 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.
- 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 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.

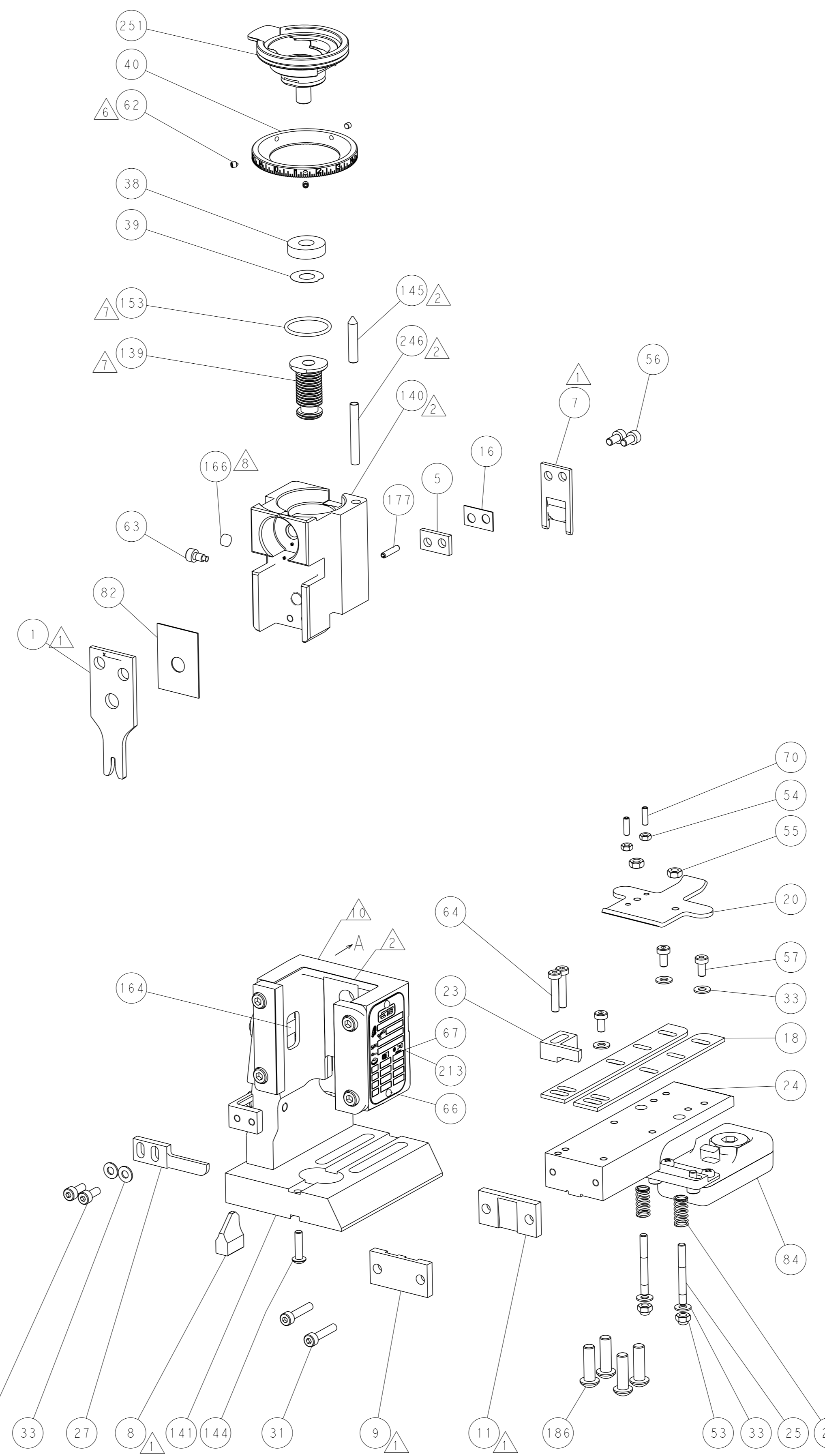
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

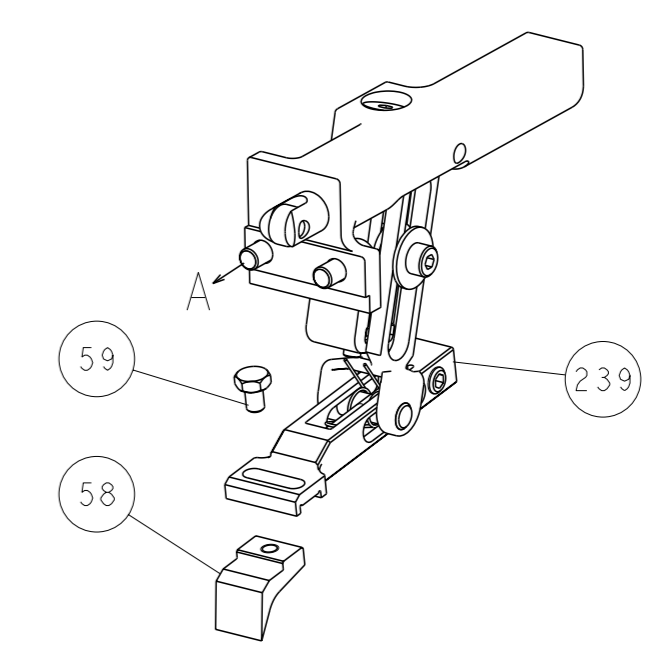
| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-------------|---------|
| - | 1 | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 | |
| - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 | |
| - | - | - | 1 | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 | |
| - | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 | |
| - | - | 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 | 6-993111-6 | PIN, SLOTTED SPRING 3.0 X 14.0 | 177 | |
| - | - | - | 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 | 455888-5 | SPACER, CRIMPER | 82 | |
| - | 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 | |
| - | 2 | 2 | 2 | 2 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 64 | |
| - | 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 | |
| - | 3 | 3 | 3 | 3 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 | |
| - | 2 | 2 | 2 | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 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 | - | 2119792-1 | PAWL, EF, AIR | 51 | |
| - | - | - | 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 | 1-2119644-2 | RAM WASHER, PRECISION | 38 | |
| - | 7 | 7 | 7 | 7 | 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 | |
| - | 1 | 1 | 1 | 1 | 240825-1 | PLATE, STRIP HOLD DOWN | 23 | |
| - | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 | |
| - | 1 | 1 | 1 | 1 | 1752373-4 | DRAG | 20 | |
| - | 2 | 2 | 2 | 2 | 1901259-4 | GUIDE, LOWER STRIP | 18 | |
| - | 1 | 1 | 1 | 1 | 6-240641-6 | SPACER | 16 | |
| - | 1 | 1 | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 | |
| - | - | - | - | - | - | - | 10 | |
| - | 1 | 1 | 1 | 1 | 690482-6 | PLATE, FRONT SHEAR | 9 | |
| - | 1 | 1 | 1 | 1 | 1803002-6 | ANVIL, COMBINATION, END FEED | 8 | |
| - | 1 | 1 | 1 | 1 | 2217206-4 | BLADE, SLUG | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 240641-2 | SPACER | 5 | |
| - | - | - | - | - | - | - | 4 | |
| - | - | - | - | - | - | - | 3 | |
| - | - | - | - | - | - | - | 2 | |
| - | 1 | 1 | 1 | 1 | 2-456406-3 | CRIMPER, WIRE PREMIUM | 1 | |
| - | 77 | 27 | 25 | 22 | 21 | PART NO | DESCRIPTION | ITEM NO |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN | CHK | APPV | DATE | NAME | |
|-------------|--------------|--|-------------|--|----------|------------------------|--------------|---------------------------|--|
| mm | 0 PLC ± | 1 PLC ±0.5 | 2 PLC ±0.13 | HOFFNER | T. ELBIN | T. ELBIN | 18 JUNE 2014 | STE TE Connectivity | |
| | 3 PLC ±0.001 | 4 PLC ±0.0001 | ANGLES ± | | | | | Harrisburg, PA 17105-3608 | |
| MATERIAL | FINISH | WEIGHT | SCALE | Customer Accessible Production Drawing | | SCALE 1:1 SHEET 3 OF 4 | | REV A | |

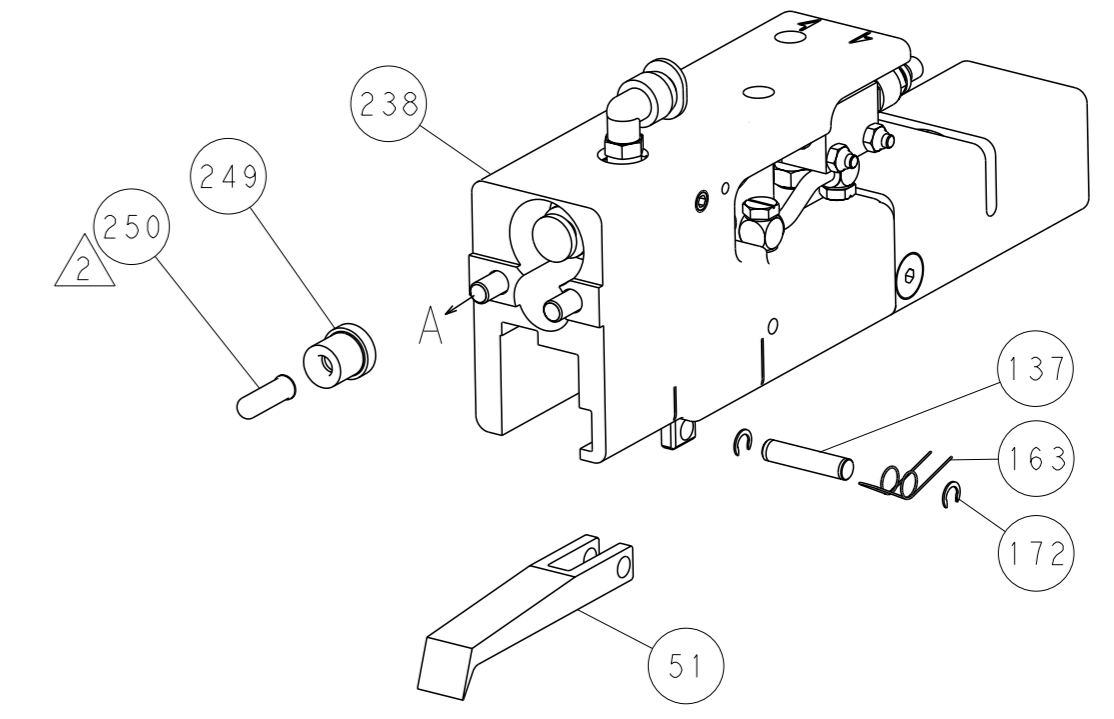
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|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LYR | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | | | |



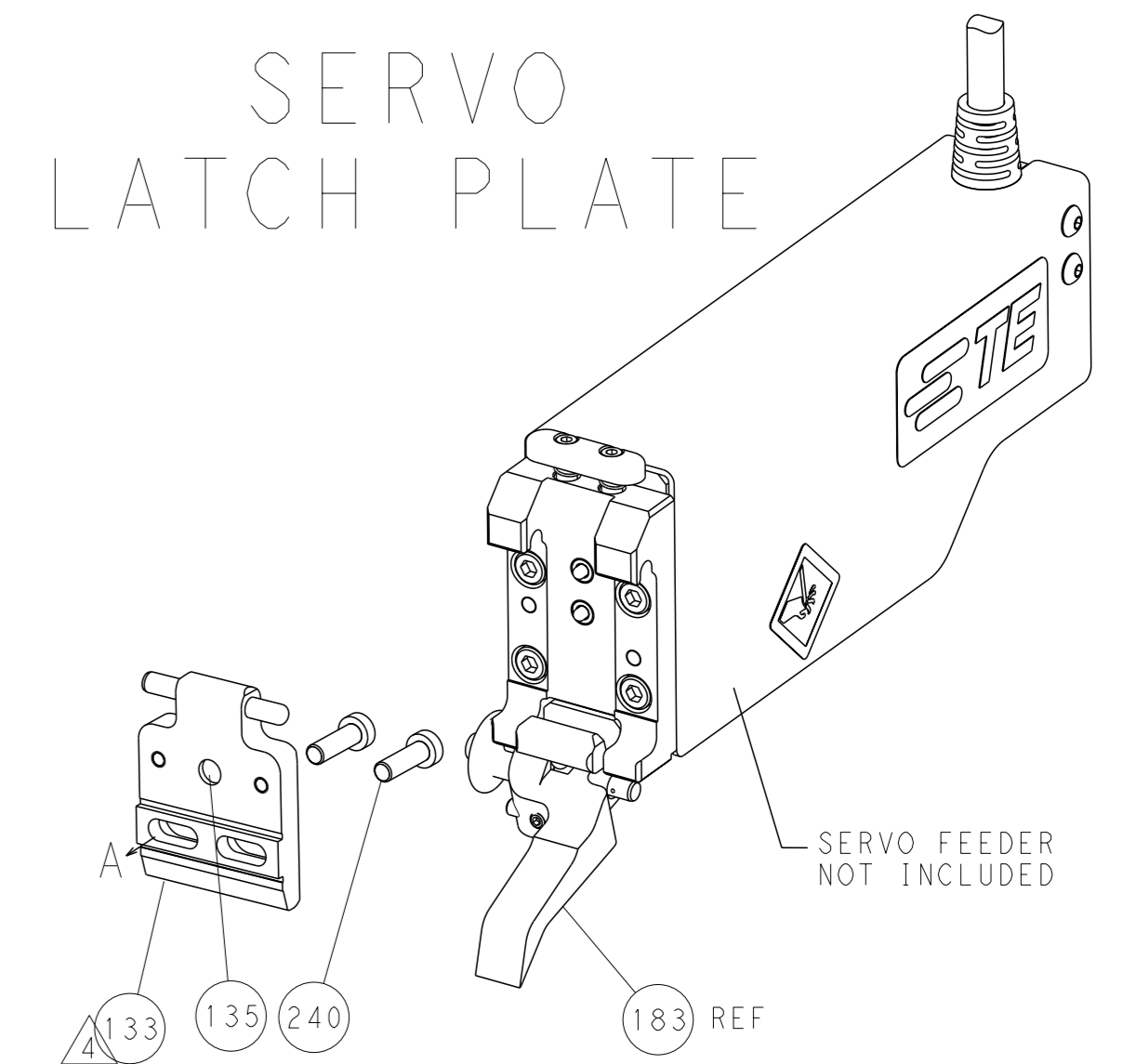
FEED TYPE
MECHANICAL



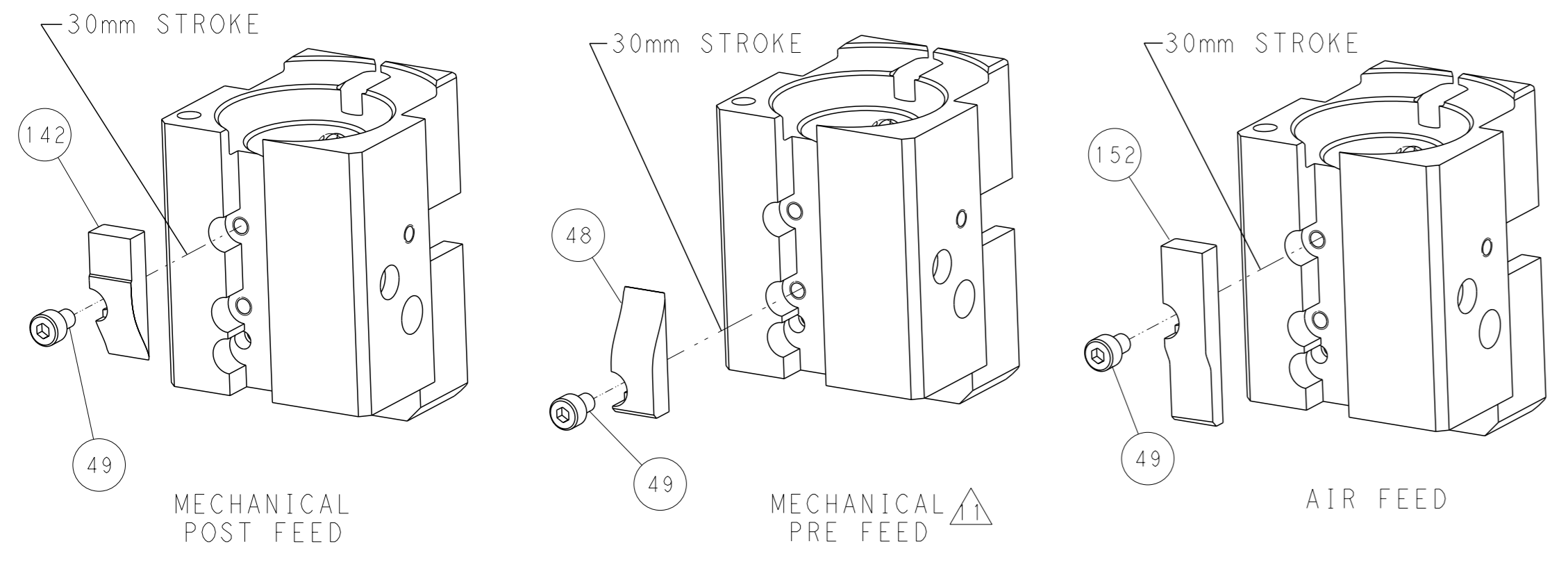
PNEUMATIC



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: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.013 3 PLC ±0.001 4 PLC ±0.0001 ANGLES FINISH ±. | | OWN HOFFNER 17JUNE2014 CHK T. ELBIN 18JUNE2014 APVD T. ELBIN 18JUNE2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing | | NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150452 SCALE 1:1 SHEET 4 OF 4 REV A | | RESTRICTED TO - - - | |
|-----------------------|--|---|--|---|--|--|--|------------------------------|--|