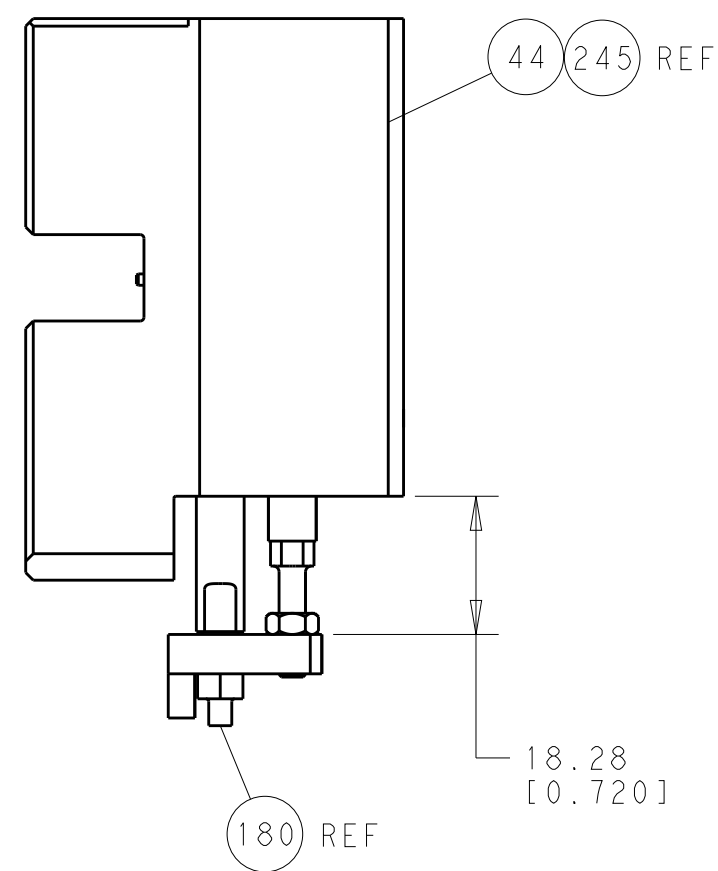
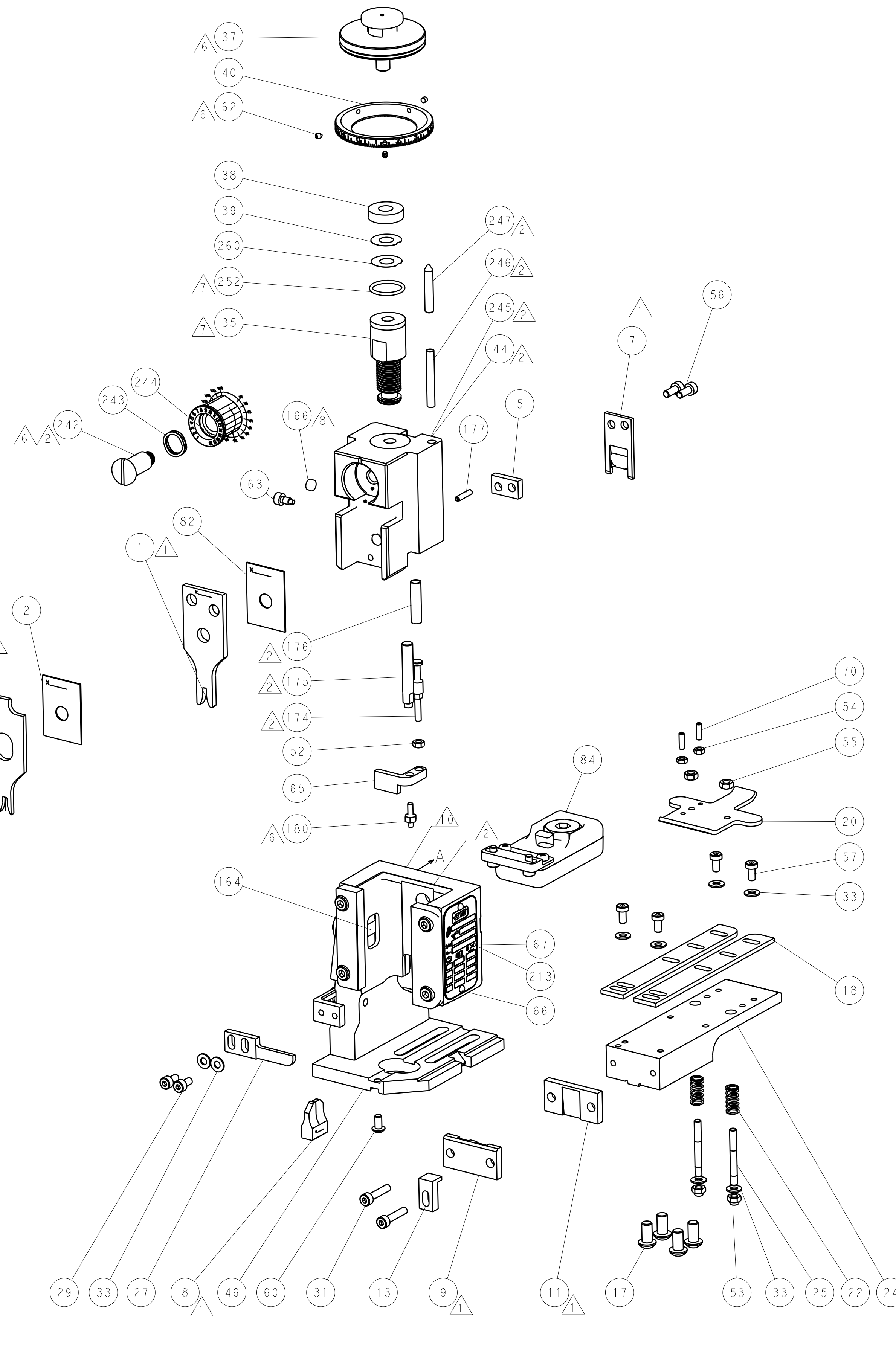
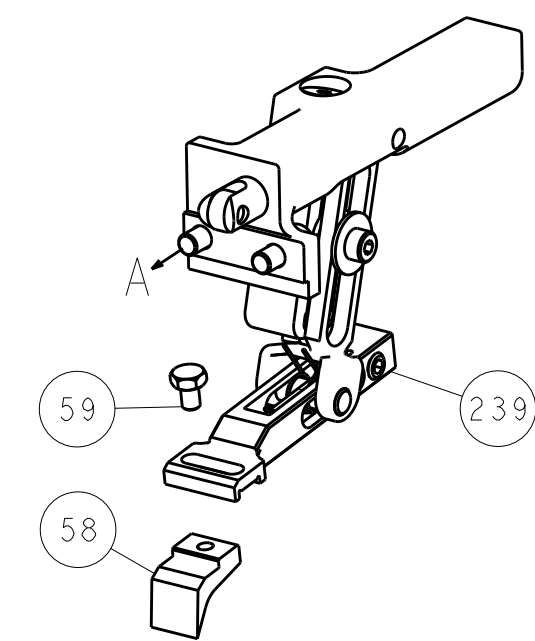




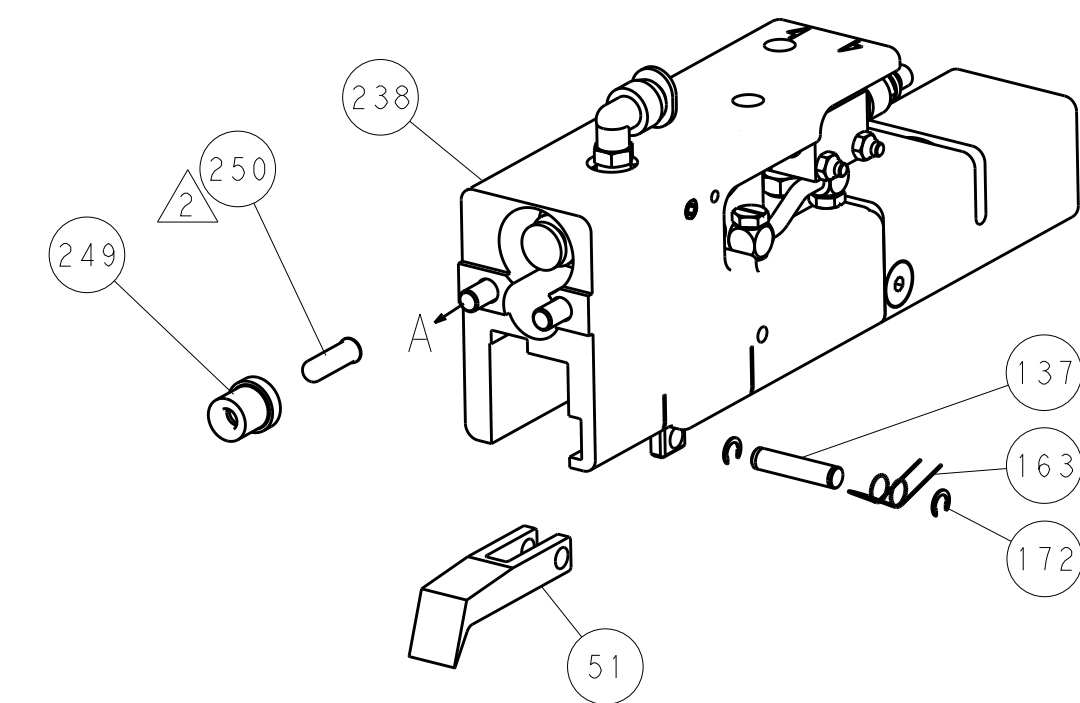
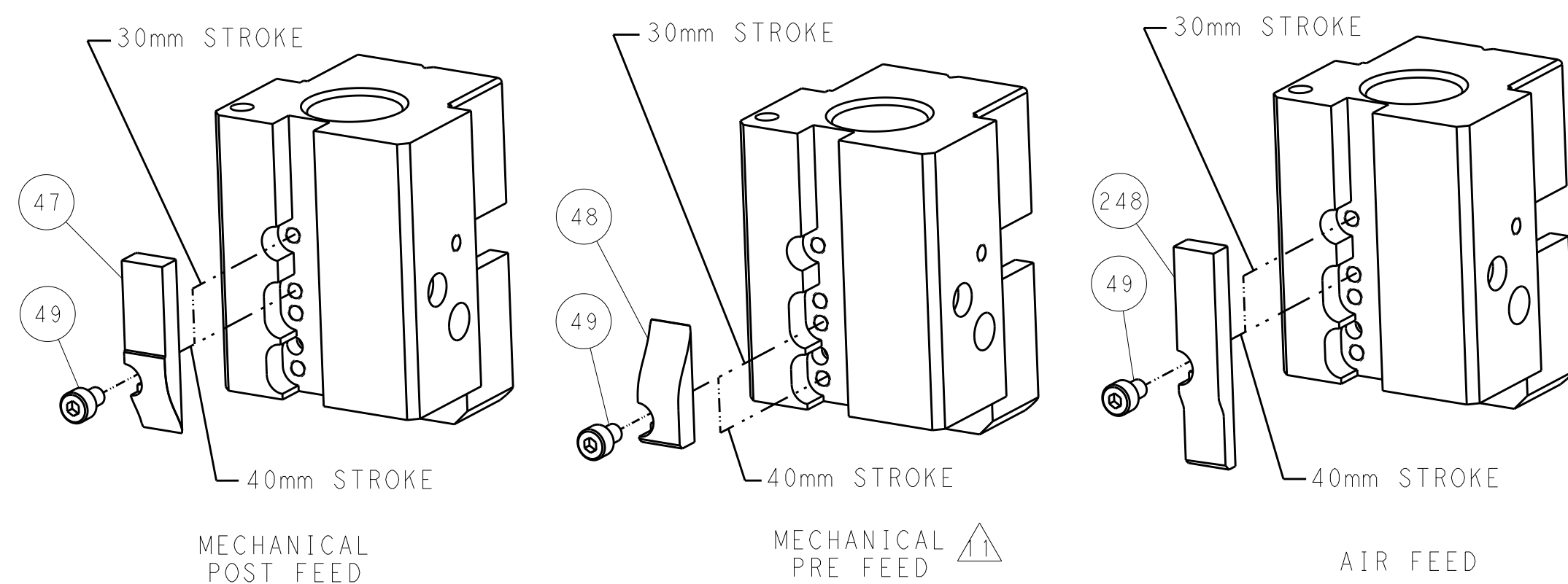
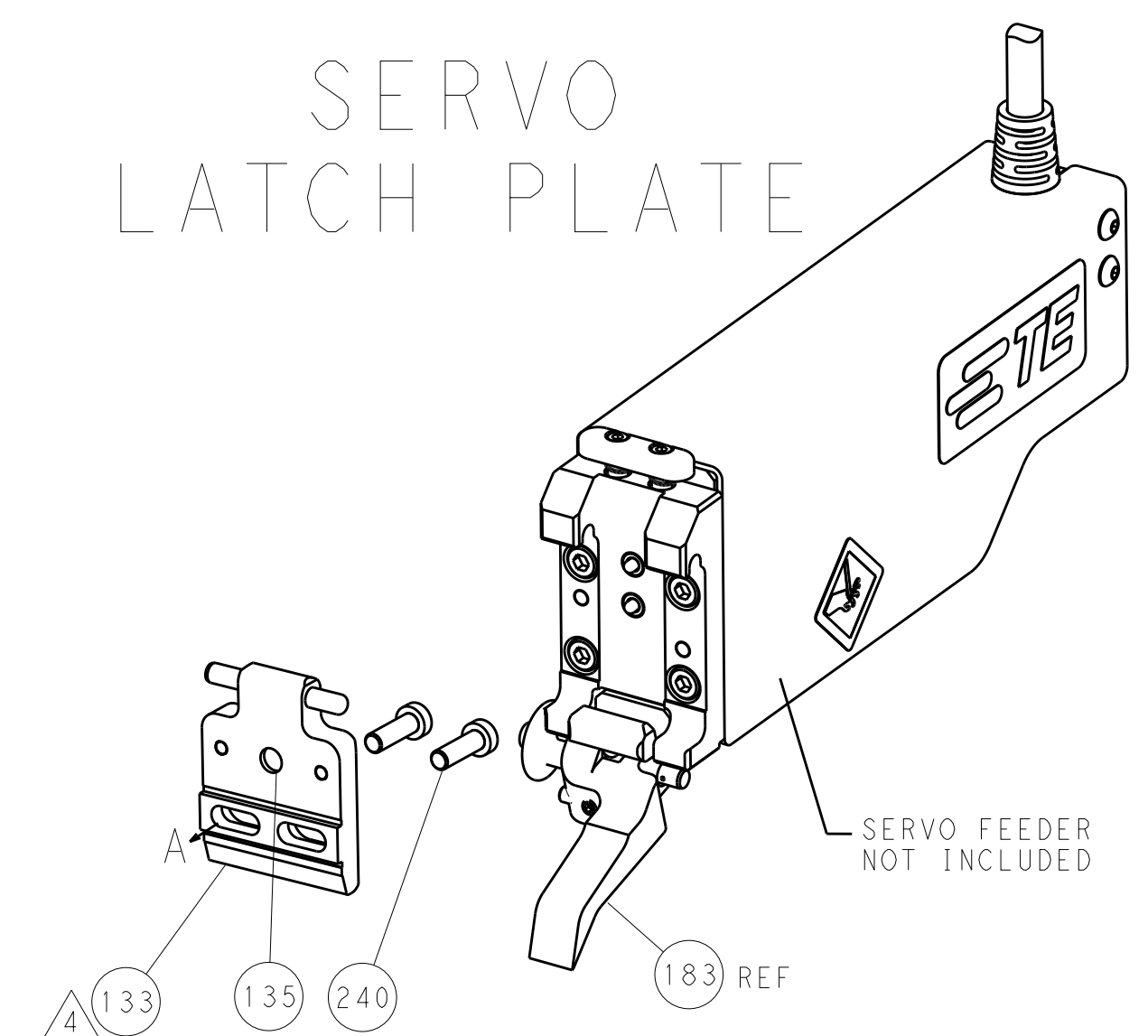
HOLDDOWN SET-UP



FEED TYPE
MECHANICAL



PNEUMATIC

SERVO
LATCH PLATE

ATLANTIC VERSION

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

THIS DRAWING IS A CONTROLLED DOCUMENT AND IT IS THE RESPONSIBILITY OF THE ORGANIZATION TO ENSURE THAT THE LATEST REVISION IS USED.		DWN K. HUANG 14FEB2014 CHK L. ZHANG 14FEB2014 U. GUO 14FEB2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		NAME Ocean End Feed Applicator -	
MATERIAL -		FINISH -		WEIGHT -	
		SIZE A1		CAGE CODE 00779	
		DRAWING NO C-2150411		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE	1:1
				SHEET	2 of 4
				REV	A

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150411-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150411-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150411-4	-	-	-
	2-2150411-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150411-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150411-4	-	-	-
	2-2150411-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150411-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150411-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.49 mm [.098]	F
INSUL	3.45 mm [.136]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: HATKO TERMINAL		HATKO CRIMP SPECIFICATION	
TERMINAL NAME: FASTON TERMINAL			
WIRE STRIP LENGTH 4.60-5.20 mm [.181-.205 IN]		INSULATION DIAMETER RANGE Ø 2.67 mm [.105 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	SF31DK(E)	-	-
TERMINALS APPLIED 			
TE TERMINAL	HATKO TERMINAL	TE TERMINAL	HATKO TERMINAL
2113427-1	0100104131	2113427-3	0500104131
2113427-2	0300104131		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
1.00mm2		1.70+/-0.04 [.067+/-0.002]		6.3
0.75mm2		1.58+/-0.04 [.062+/-0.002]		7.5
0.50mm2		1.51+/-0.04 [.059+/-0.002]		8.4



- [△] 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: 8-2150411-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150411-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150411-5
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, 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.
- [△] 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.
- [△]1 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.
- [△]2 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.

-	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
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77-27-25-22-21					PART NO	DESCRIPTION	ITEM NO

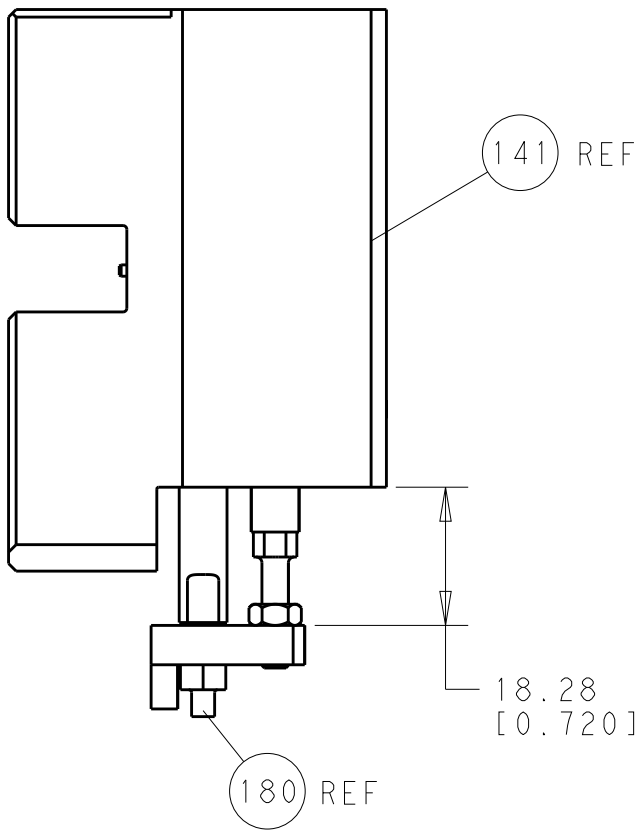
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

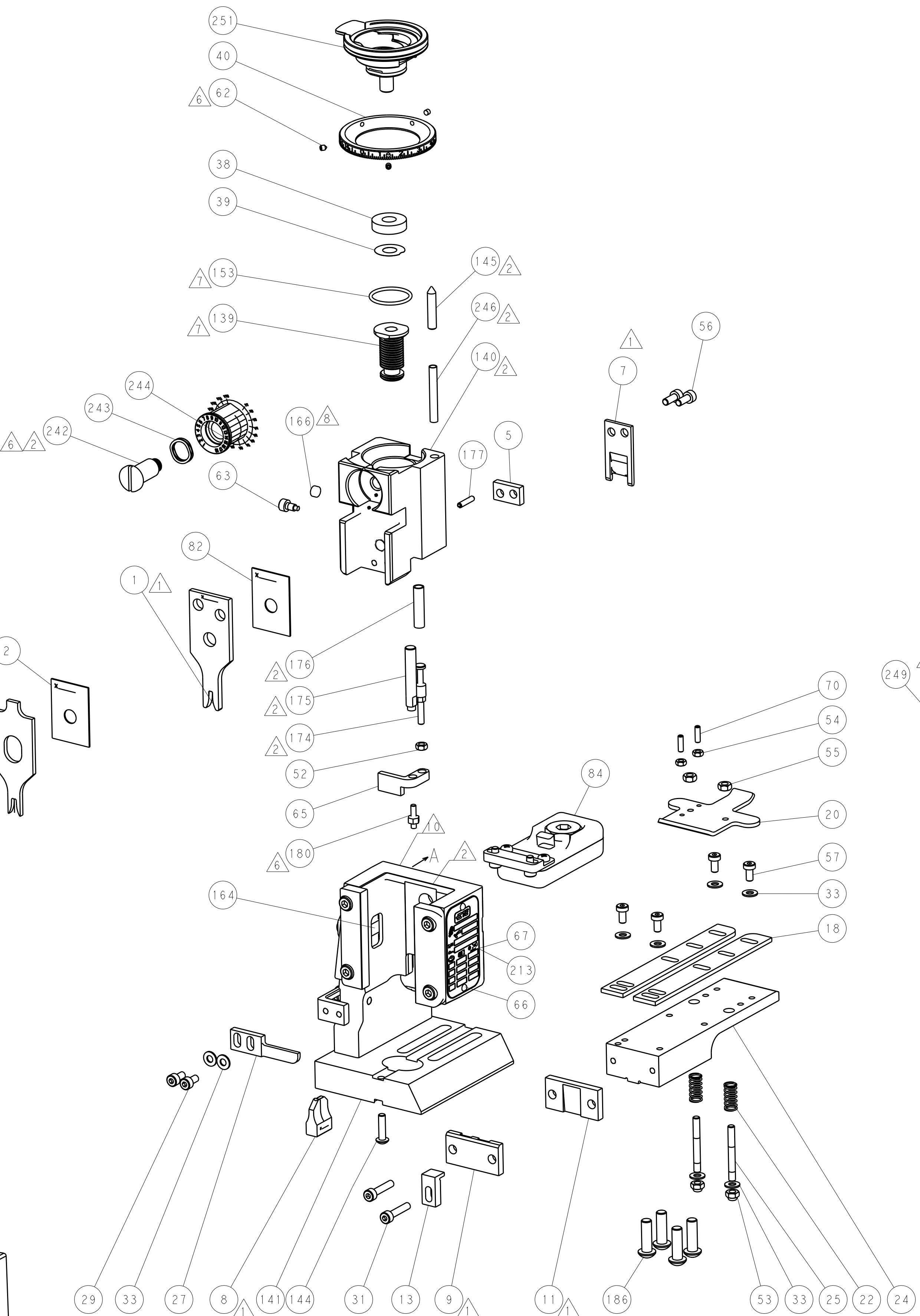
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1-1976055-2	STANDOFF, HOLD-DOWN	180
-	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	455888-6	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
-	1	1	1	1	1901681-5	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	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
-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690482-1	PLATE, FRONT SHEAR	9
-	1	1	1	1	1803060-5	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2217206-2	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2-240641-0	SPACER	5
-	1	1	1	1	3-238009-5	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	7-1633961-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	1	1	5-1633664-9	CRIMPER, WIRE	1
-77-27-25-22-21					PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm				CHK L. ZHANG	14FEB2014	NAME Ocean End Feed Applicator			
				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1	APVD J. GUO	14FEB2014	PRODUCT SPEC		
				APPLICATION SPEC					
				FINISH					
MATERIAL -				WEIGHT -		SIZE A	CAGE CODE 00779	DRAWING NO C=2150411	RESTRICTED TO -
Customer Accessible Production Drawing						SCALE 1:1	SHEET 3	OF 4	REV A

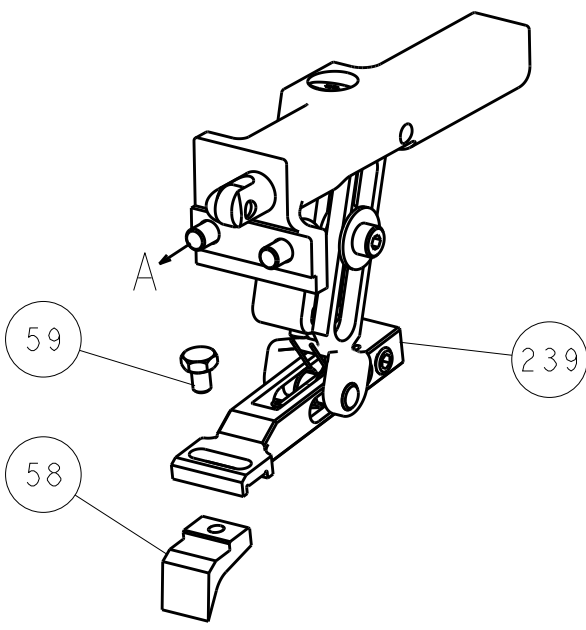
LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



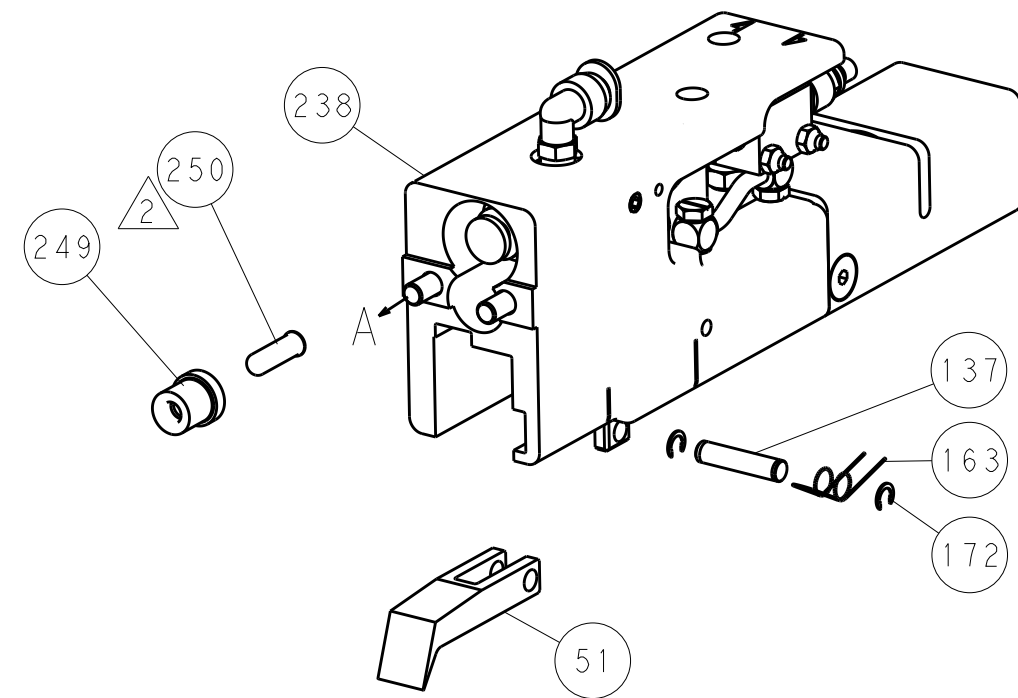
HOLDDOWN SET-UP



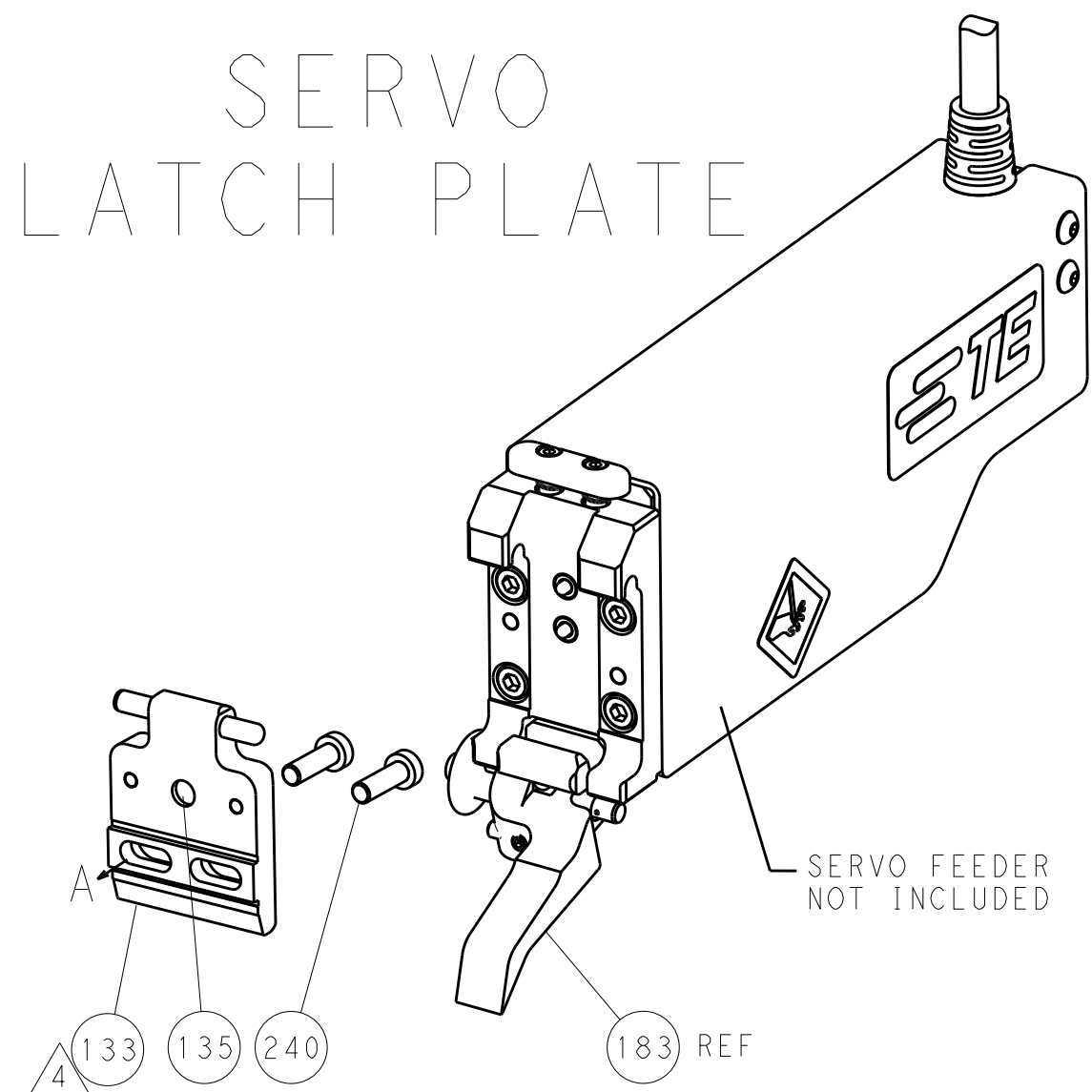
FEED TYPE
MECHANICAL



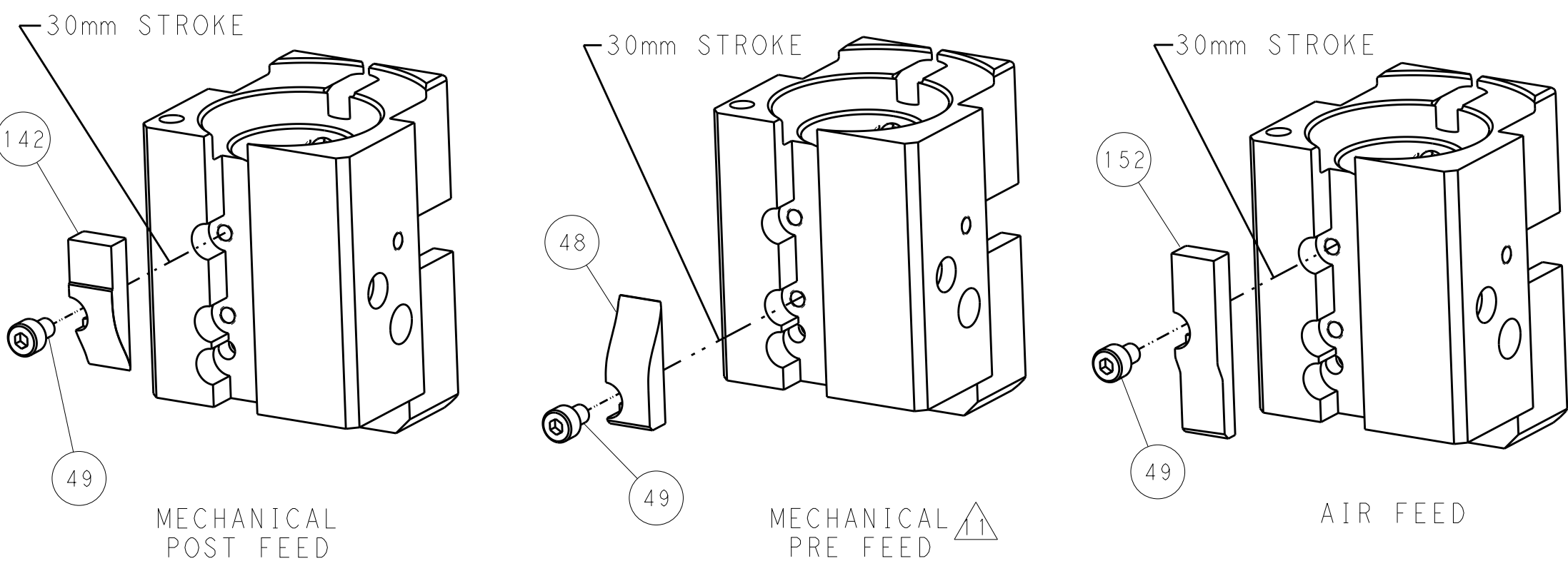
PNEUMATIC



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)

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CHK L. ZHANG 14FEB2014				NAME	Ocean End Feed Applicator		
APVD J. GUO 14FEB2014				PRODUCT SPEC	SIZE		
				APPLICATION SPEC	CAGE CODE		
				WEIGHT	DRAWING NO		
					A1 00779 C=2150411		
				Customer Accessible Production Drawing	RESTRICTED TO		
				SCALE	SHEET		
				1:1	4 OF 4		
					REV		
					A		

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