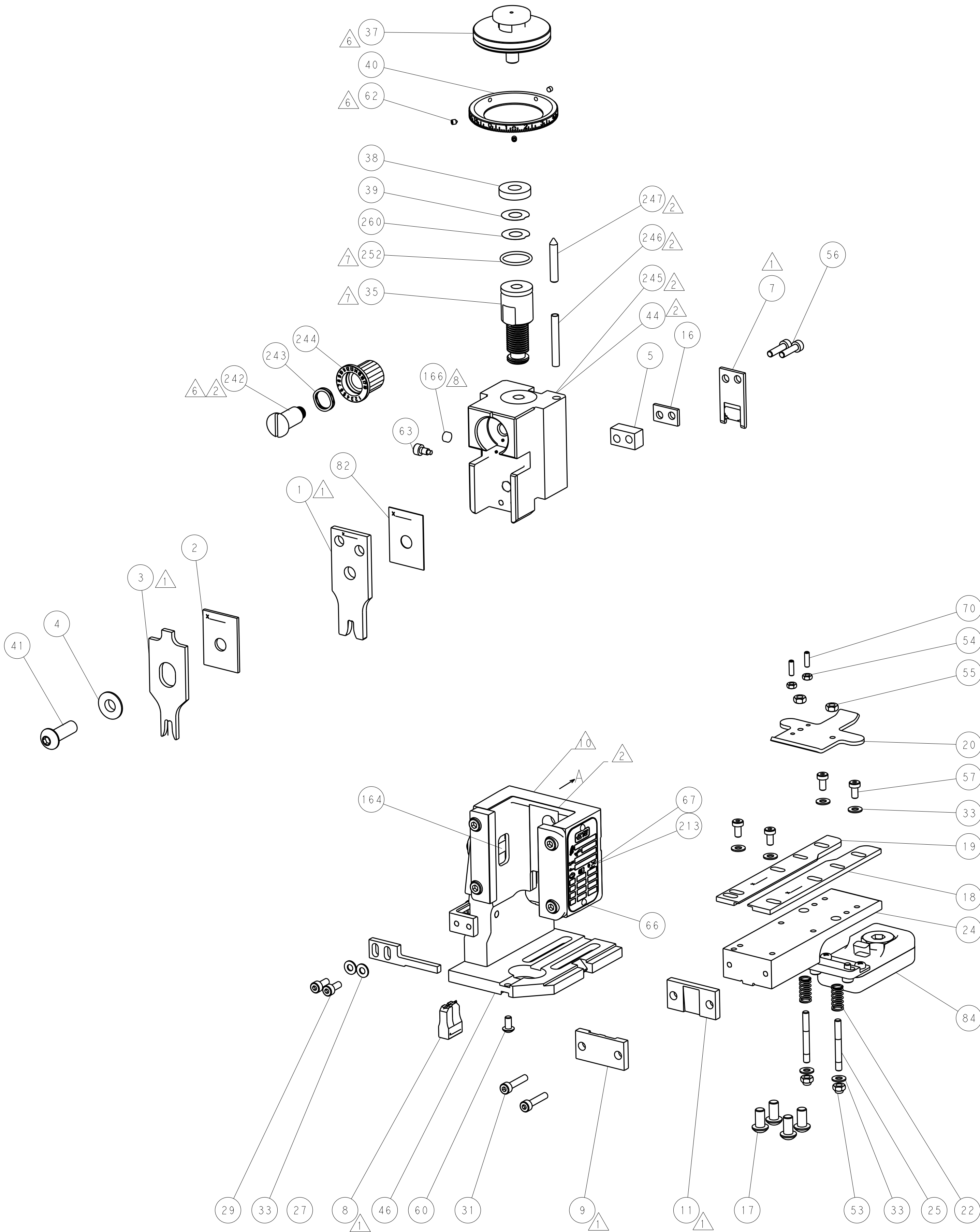
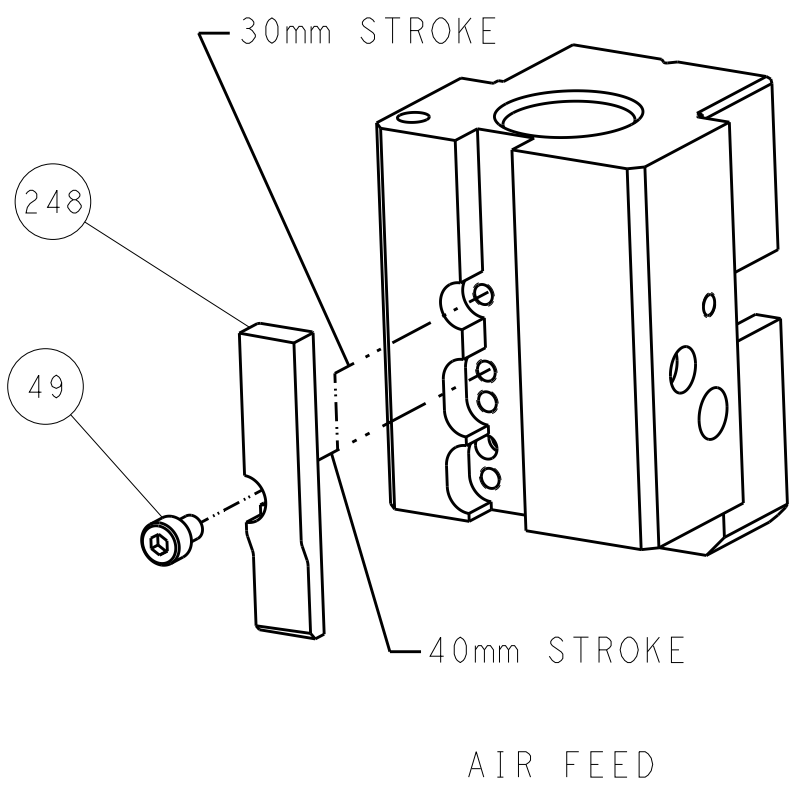


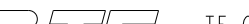
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

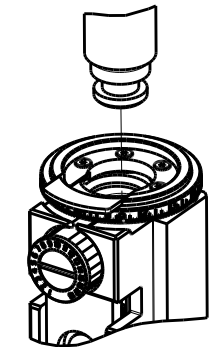


CAM POSITIONS



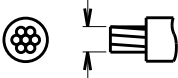
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1ST PUBLISHED BY: COMPANY/ISSUE FOR: THIS ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE/REVISIONS FOR THE LATEST REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISIONS.		OWN: HOFFNER 20DEC2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK: T.ELBIN 23DEC2013			
mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: T.ELBIN 23DEC2013	
		0 PLC ±.5		NAME: Ocean End Feed Applicator	
		1 PLC ±0.13			
		2 PLC ±0.13		PRODUCT SPEC	
		3 PLC ±0.013			
		4 PLC ±0.0001		APPLICATION SPEC	
		ANGLES: -			
MATERIAL: -		WEIGHT: -		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150406	
FINISH: -		Customer Accessible Production Drawing		RESTRICTED TO: -	
				SCALE: 1:1 SHEET 2 OF 4 REV: A	

8				6		5		4		3				
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART								
						CONVERT TO	PART NUMBERS REQUIRED							
		2-2150406-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-			
						SERVO LATCH PLATE	2119951-1	1901697-1	8-2150406-5	-	-	2168400-7 (QUANTITY 2)		
						SMART APPLICATOR	2161326-1	-	8-2150406-4	-	-	-		
				2-2150406-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	-	-	-	-	-	-	
								PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-2
				2-2150406-7		A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-
									7-2150406-7		A	CRIMP TOOLING KIT	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE WITH INSULATION SUPPORT			
WIRE STRIP LENGTH 5.54-6.35 mm [.218-.250 IN]		INSULATION DIAMETER RANGE Ø4.00-4.50 mm [.157-.177 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED		-	-
TE TERMINAL		TE TERMINAL	TE TERMINAL
160921-1		160921-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
4.00mm2		2.93+/-0.000 [.115+/- .000]		4.8
3.50mm2		2.83+/-0.000 [.111+/- .000]		6.1
3.00mm2		2.73+/-0.000 [.107+/- .000]		7.1

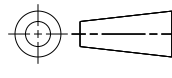


-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150406-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150406-5
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 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.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
11. 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.

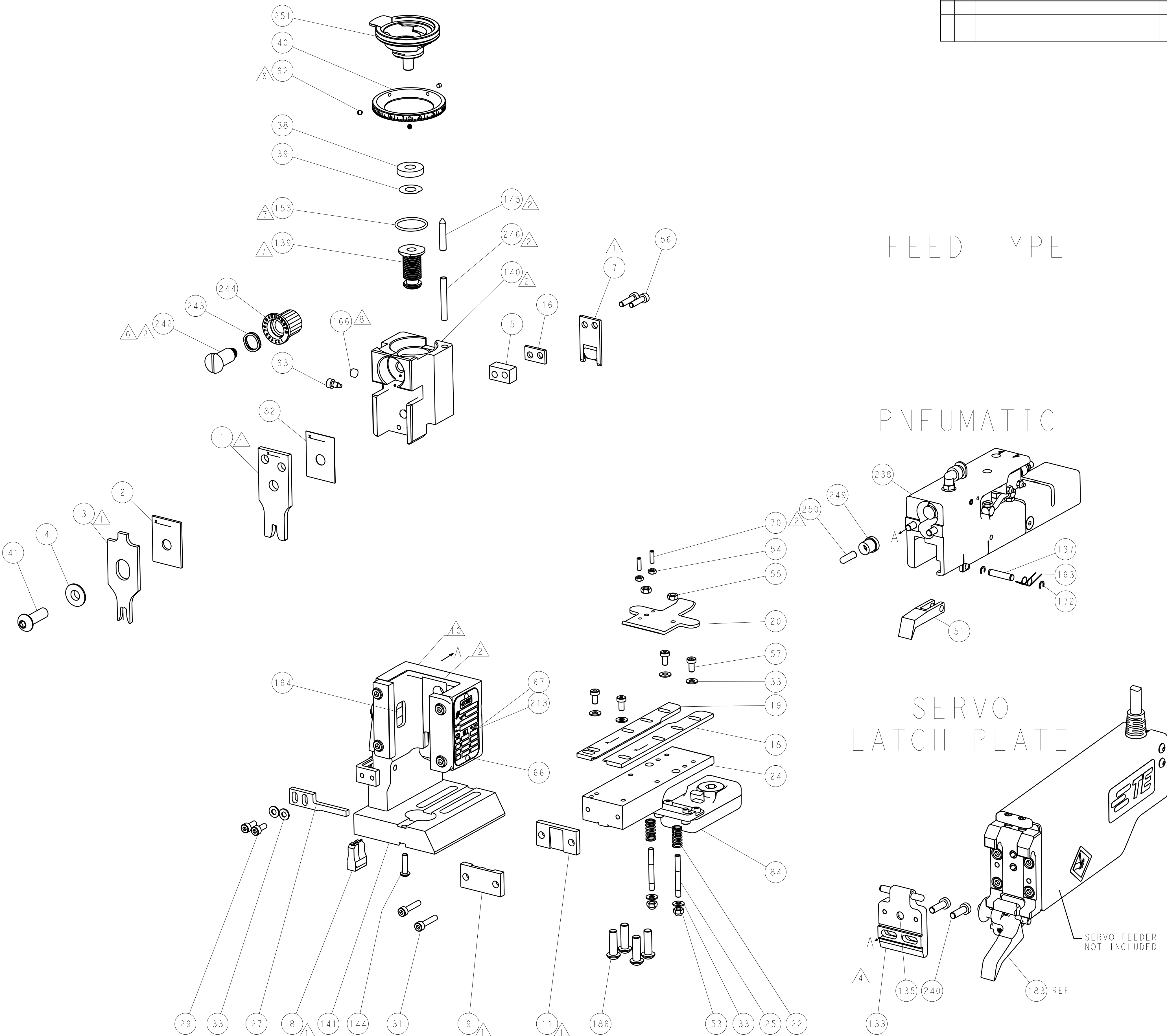
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
			-	-	SEE SHEET 1	-

-	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	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
-	-	-	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	455888-4	SPACER, CRIMPER	82
-	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2119792-2	PAWL, EF, AIR	51
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	2119644-3	RAM WASHER, PRECISION	38
-	8	8	8	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	690455-1	STRIPPER, FRONT CASTING	27
-	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1752373-4	DRAG	20
-	1	1	1	2-1901696-1	STRIP GUIDE, REAR	19
-	1	1	1	2-1901695-1	STRIP GUIDE, FRONT	18
-	1	1	1	3-240641-7	SPACER	16
-	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
-	1	1	1	6-690482-3	PLATE, FRONT SHEAR	9
-	1	1	1	3-1333223-1	ANVIL, COMBINATION	8
-	1	1	1	1-2217206-2	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	6-240641-0	SPACER	5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	3-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1-455888-7	SPACER, CRIMPER	2
-	1	1	1	456414-5	CRIMPER, WIRE	1
-	77	27	25	22	PART NO	DESCRIPTION
-	-	-	-	-	-	ITEM NO

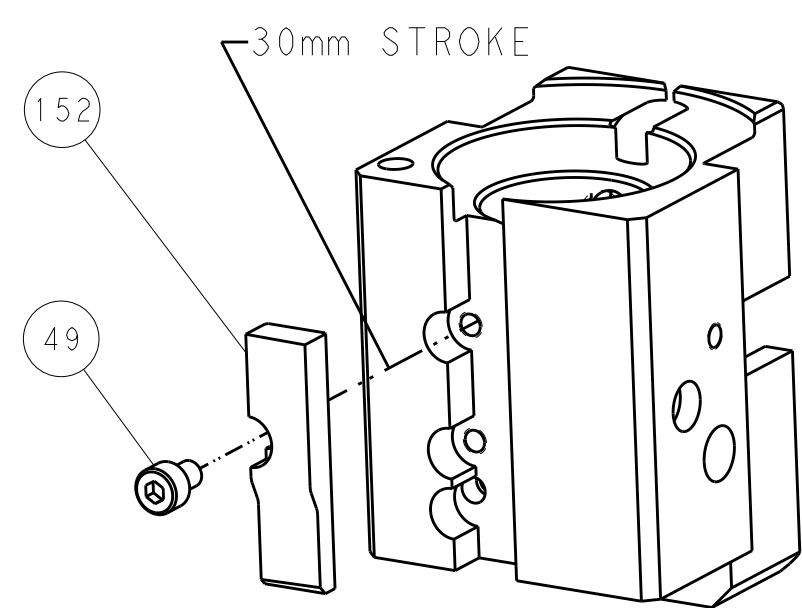
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DIMENSIONS: mm		CHK T.ELBIN	23DEC2013	NAME Ocean End Feed Applicator	
		APVD T.ELBIN	23DEC2013	SIZE 00779	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.0.13 3 PLC ±.0.13 4 PLC ±.0.0001 ANGLES ±.1		PRODUCT SPEC -	CAGE CODE 00779		RESTRICTED TO -
MATERIAL -		APPLICATION SPEC -	DRAWING NO C=2150406		REV A
FINISH -		WEIGHT -	Customer Accessible Production Drawing		SCALE 1:1
		SHEET 3 OF 4			

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

LOC		DIST		REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
-	-	SEE SHEET 1		-	-	-	-



CAM POSITIONS



AIR FEED

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
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DIMENSIONS:		CHK: T.ELBIN 23DEC2013		
mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD: T.ELBIN 23DEC2013	NAME: Ocean End Feed Applicator	
	0 PLC +/- 0.5	PRODUCT SPEC	SIZE: CAGE CODE: DRAWING NO: 00779 C=2150406	
	1 PLC +/- 0.13	APPLICATION SPEC	RESTRICTED TO	
MATERIAL	2 PLC +/- 0.13	WEIGHT	Customer Accessible Production Drawing	
	3 PLC +/- 0.13	SCALE: 1:1	SHEET 4 OF 4	
	4 PLC +/- 0.0001	REV: A		
	ANGLES			
	FINISH			

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