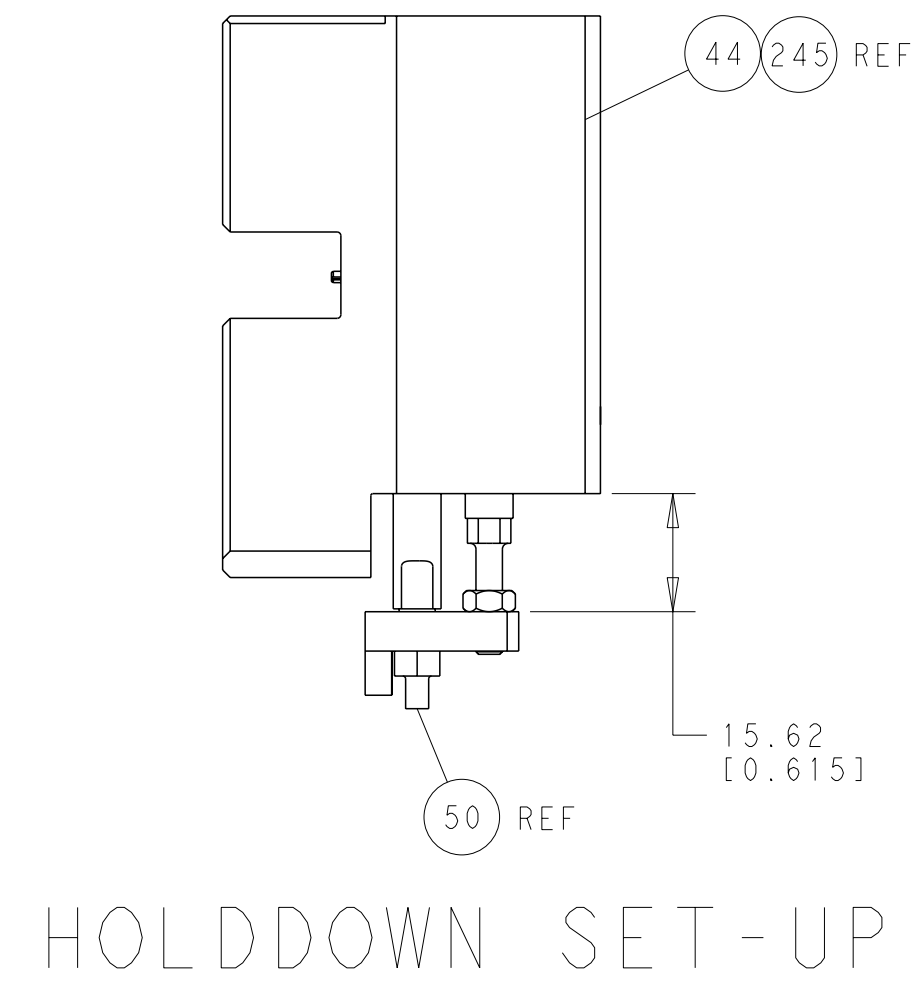
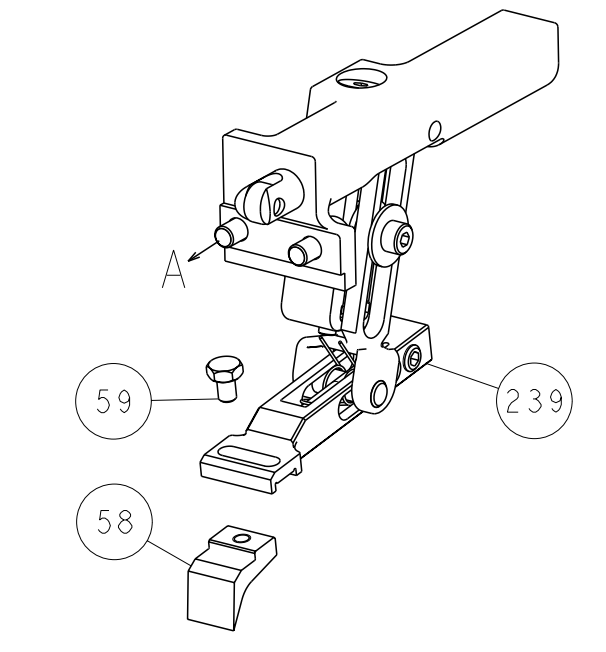


LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

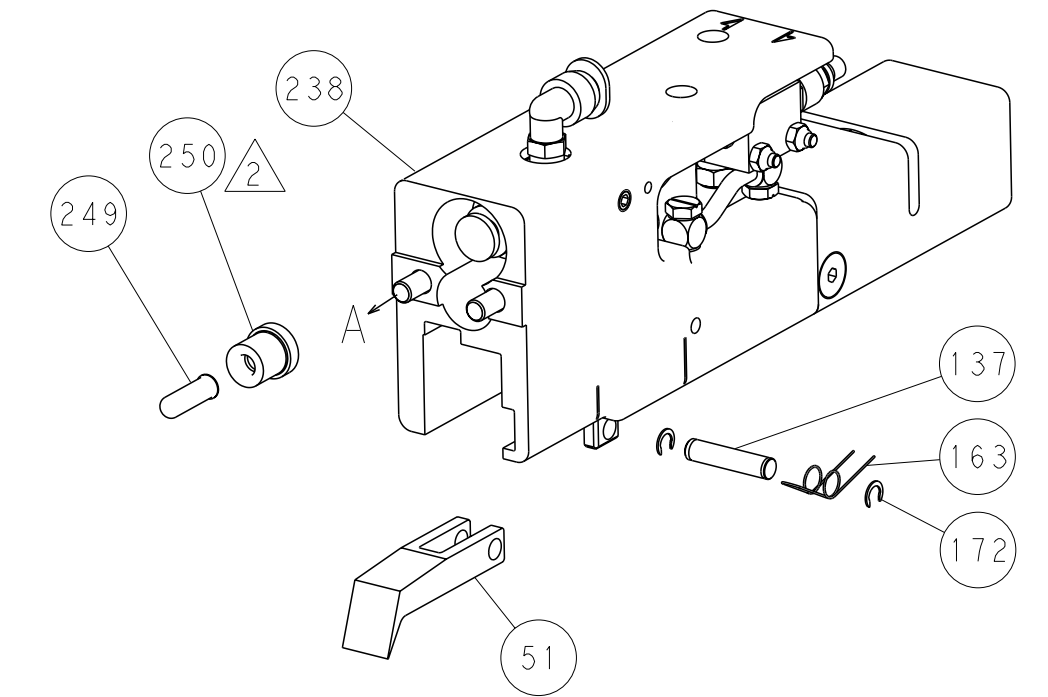


HOLDDOWN SET-UP

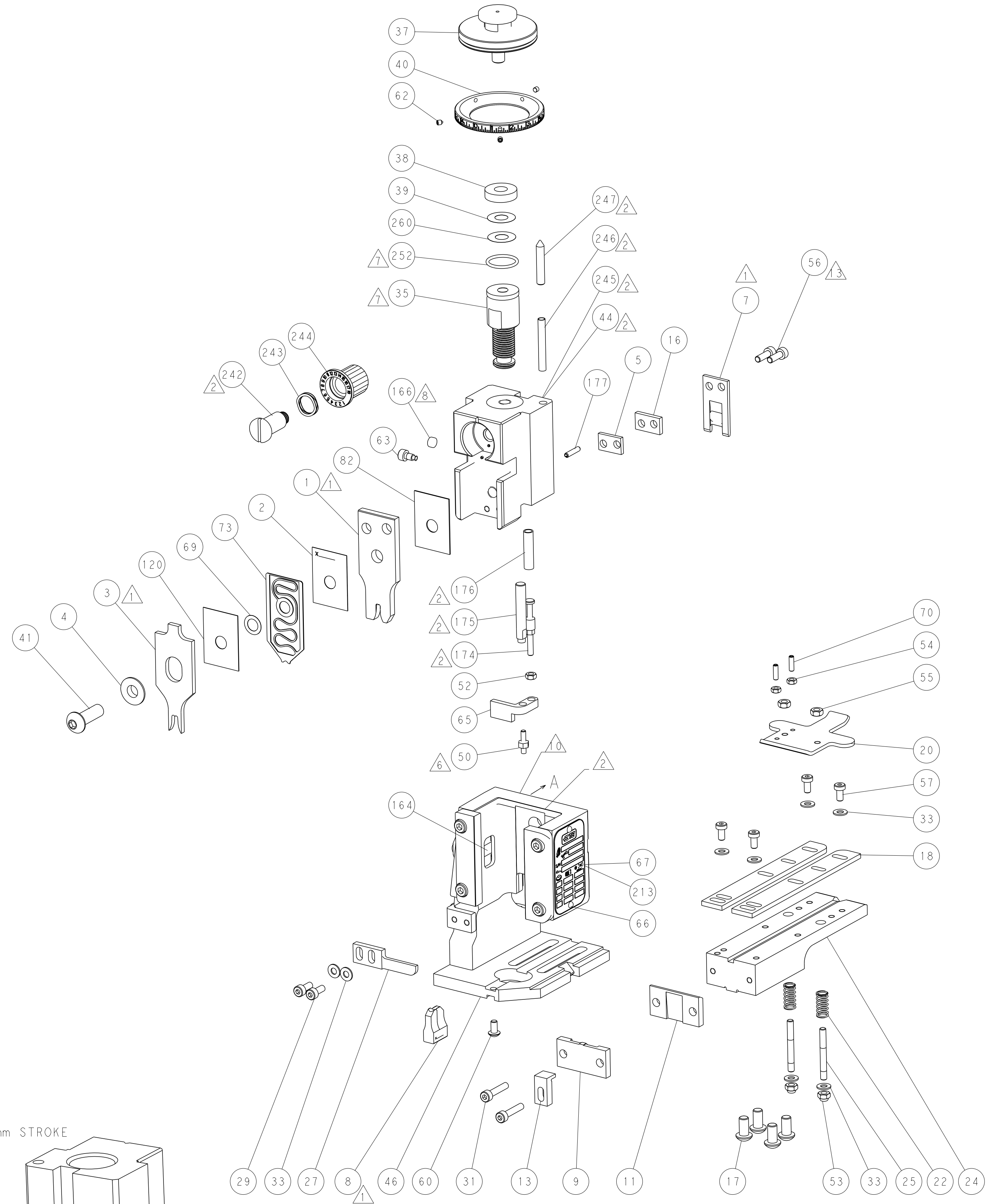
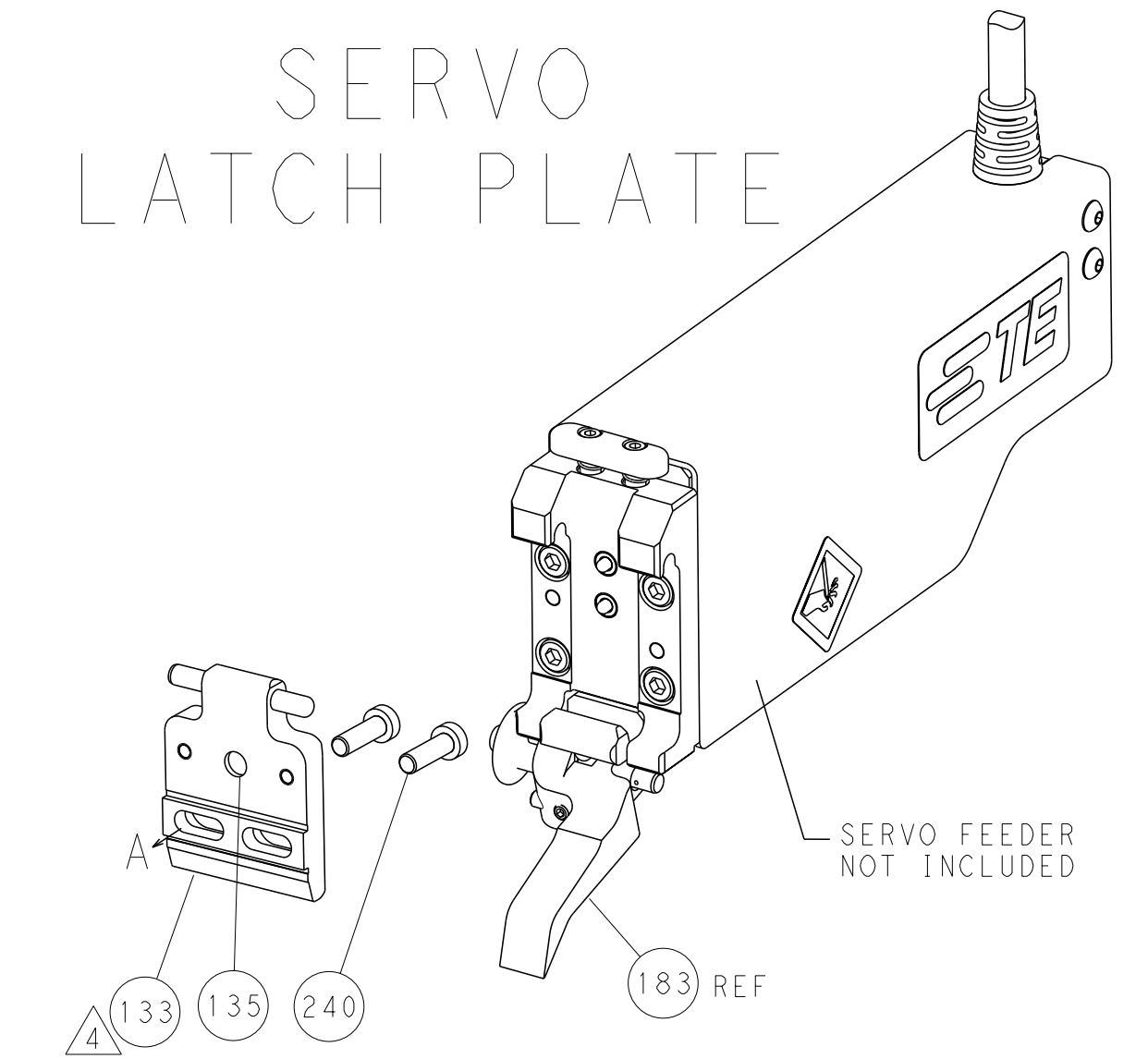
FEED TYPE
 MECHANICAL



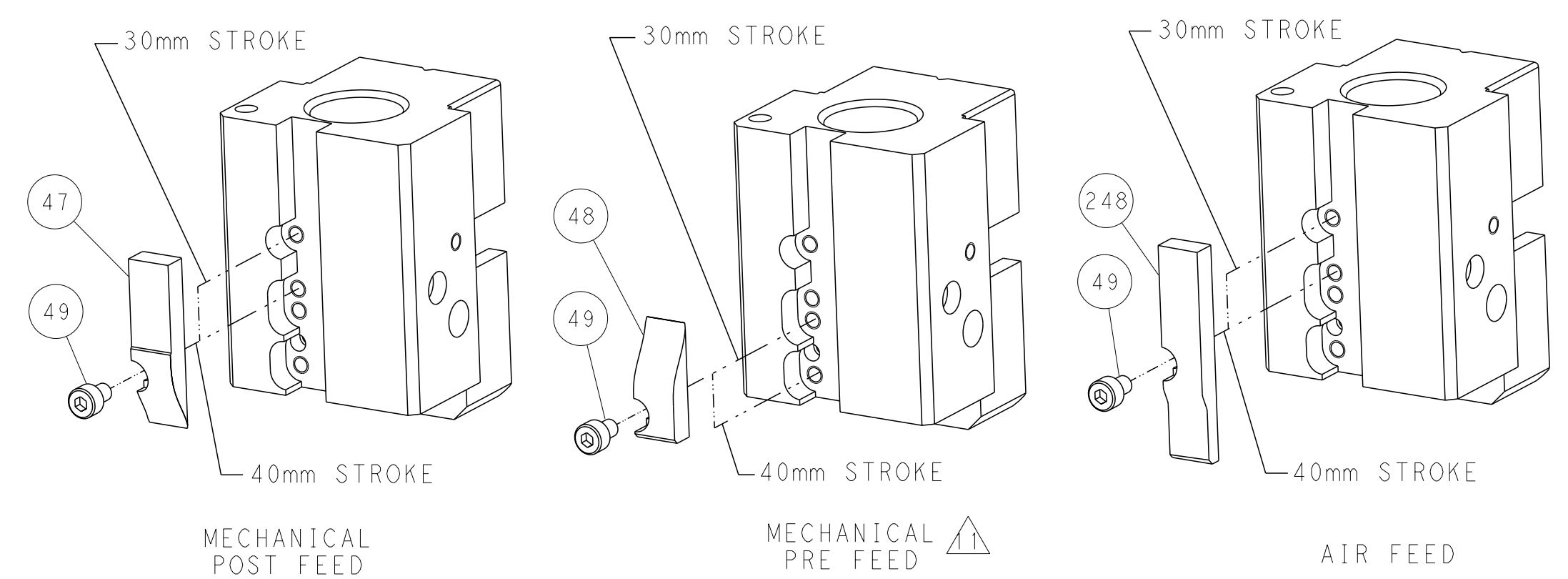
PNEUMATIC



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:		DWN GROSS 23NOV2011		TE Connectivity	
mm		9 PLC ±0.5		CHK T. ELBIN 23NOV2011		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APVD M. CLIFFORD 23NOV2011		NAME	
H		5 PLC ±0.013		PRODUCT SPEC		Ocean End Feed	
A		4 PLC ±0.001		APPLICATION SPEC		Applicator	
MATERIAL		FINISH		WEIGHT		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
						A11 00779 C=2150235	
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					
	2-2150235-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150235-5	-	-	2168400-7 (QUANTITY 2)
	2-2150235-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150235-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150235-4	-	-	-
	2-2150235-5	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
	2-2150235-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150235-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	4.57 mm (.180)	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTIN-FASTON REC.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.80-5.60 mm (.189-.220 IN)		3.05-4.32 mm (.120-.170 IN)	
TERMINAL APPLICATION SPECIFICATION	114-3118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
5-160446-1	5-160446-4	5-160446-6	160824-5
5-160446-2	5-160446-5	5-160446-8	160824-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
2.50mm2	1.83 +/- 0.05 (.072 +/- .002)	8.1
2.00mm2	1.78 +/- 0.05 (.070 +/- .002)	8.7
1.50mm2	1.68 +/- 0.05 (.066 +/- .002)	9.7
1.00mm2	1.58 +/- 0.05 (.062 +/- .002)	10.9

- 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: 8-2150235-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150235-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150235-5
- 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 ITEM 50.
- 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.
- CUT TO LENGTH AT ASSEMBLY.

***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.

ITEM 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
- 1 1 1 1 1	2119083-1 RETAINER, INSULATION DIAL	242
-77-27-25-22-21	PART NO DESCRIPTION	ITEM NO

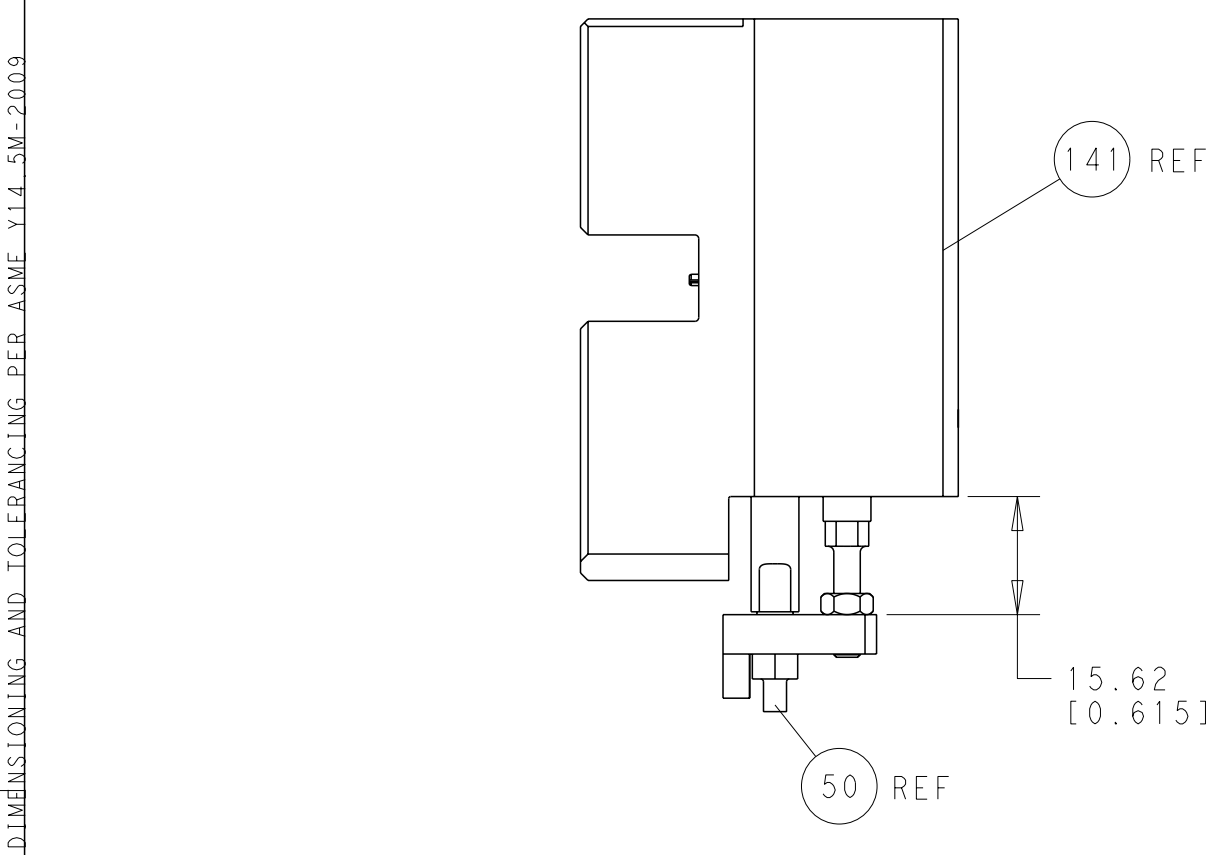
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

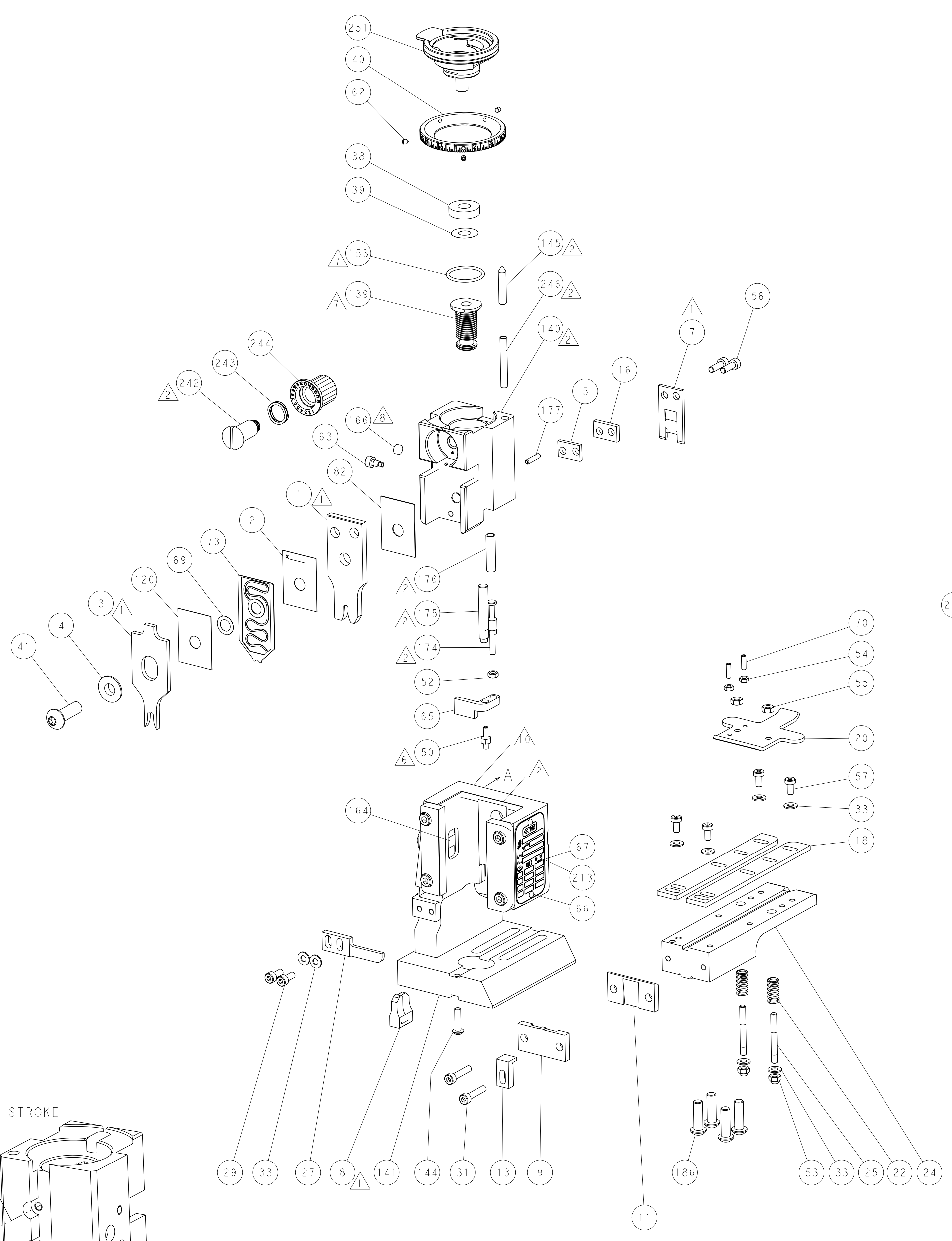
REV	DATE	BY	APPD	DESCRIPTION	DATE	BY	APPD
-	-	2	-	2168400-7 SHCS, LOW HEAD, RoHS, M5 X 10	-	-	240
-	-	-	-	2119580-1 MECHANICAL FEED ASSEMBLY	-	-	239
-	-	-	-	2063440-1 AIR FEED MODULE	-	-	238
-	-	1	-	2119740-2 TAG, IDENTIFICATION	-	-	213
-	4	4	4	2079383-9 SCR, BHSC, RoHS (M6 X 20)	-	-	186
-	-	REF	-	1901697-1 FEED FINGER ASSEMBLY, EF	-	-	183
-	1	1	1	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
-	-	-	1	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	455888-3 SPACER, CRIMPER	-	-	120
-	1	1	1	455888-5 SPACER, CRIMPER	-	-	82
-	1	1	1	2119791-9 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	1	2119943-1 WASHER, SPACER	-	-	69
-	1	-	1	2119740-1 TAG, IDENTIFICATION	-	-	67
-	2	2	2	2168078-1 SCREW, DRIVE, RH, RoHS	-	-	66
-	1	1	1	1901681-5 HOLDDOWN, TERMINAL	-	-	65
-	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
-	4	4	4	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
-	-	-	-	2119792-2 PAWL, EF, AIR	-	-	51
-	1	1	1	1-1976055-5 STANDOFF, HOLD-DOWN	-	-	50
-	-	-	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
-	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	240639-1 STRIPPER (MACHINING)	-	-	27
-	2	2	2	1320906-1 STUD, THREADED	-	-	25
-	1	1	1	1752371-6 PLATE, STRIP GUIDE	-	-	24
-	2	2	2	2-22281-3 SPRING, COMPRESSION	-	-	22
-	1	1	1	1752373-1 DRAG	-	-	20
-	2	2	2	1901259-6 GUIDE, LOWER STRIP	-	-	18
-	1	1	1	5-240641-2 SPACER	-	-	16
-	1	1	1	1752360-1 SPACER, HOLD-DOWN	-	-	13
-	1	1	1	240833-4 PLATE, REAR SHEAR	-	-	11
-	-	-	-	-	-	-	10
-	1	1	1	690495-6 PLATE, FRONT SHEAR	-	-	9
1	1	1	1	1333219-3 ANVIL, COMBINATION	-	-	8
-	1	1	1	1-690474-7 BLADE, SLUG	-	-	7
-	1	1	1	8-240641-6 SPACER	-	-	5
-	1	1	1	238009-1 BLOCK, FL CRIMPER SPACER	-	-	4
1	1	1	1	2119582-3 CRIMPER, INSULATION F PREMIUM	-	-	3
-	1	1	1	455888-2 SPACER, CRIMPER	-	-	2
1	1	1	1	456408-5 CRIMPER, WIRE PREMIUM	-	-	1
-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO				

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		
mm	9 PLC ±.5	1 PLC ±.13	5 PLC ±.013	4 PLC ±.0001	ANGLE	FINISH	SCALE	1:1	SHEET	3 OF 4	REV	A

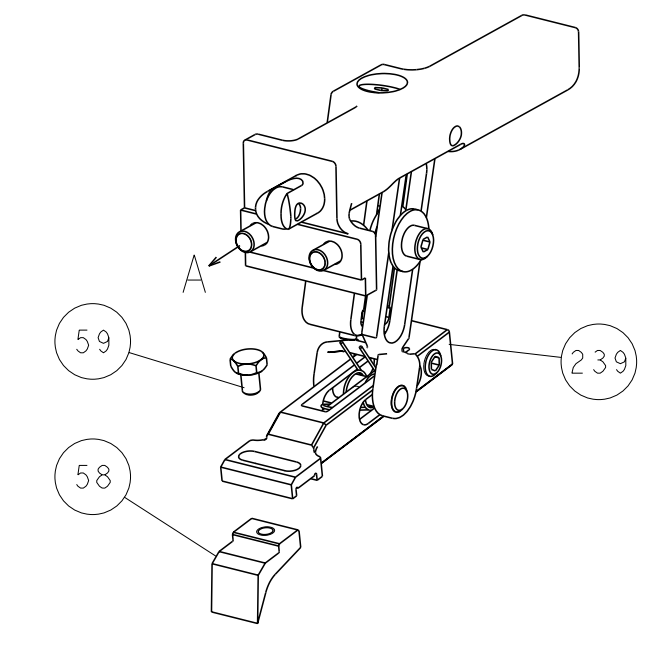
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			



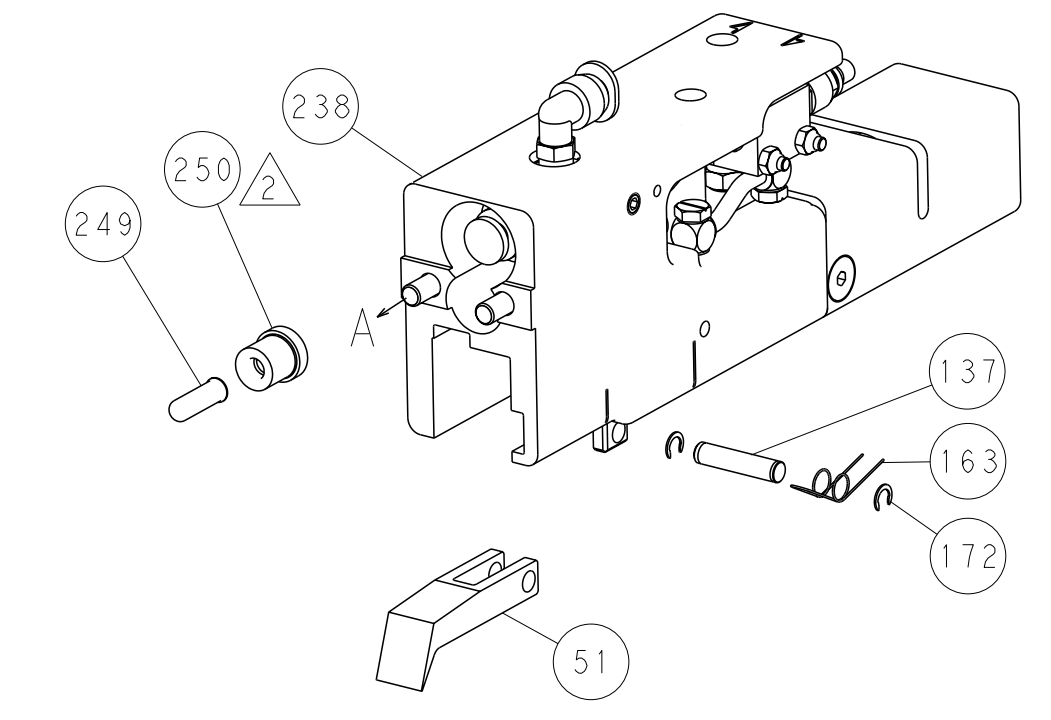
HOLDDOWN SET-UP



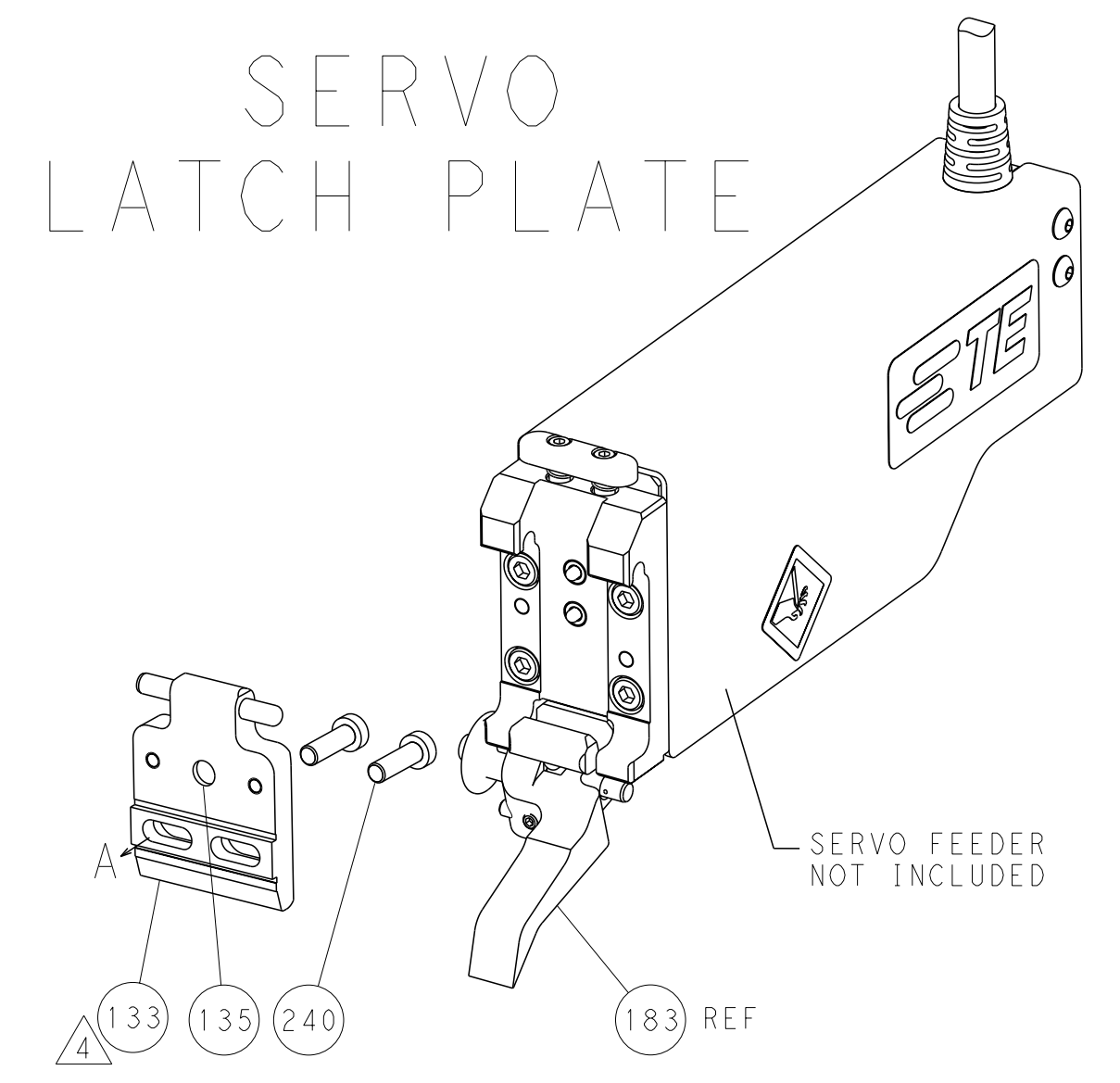
FEED TYPE
MECHANICAL



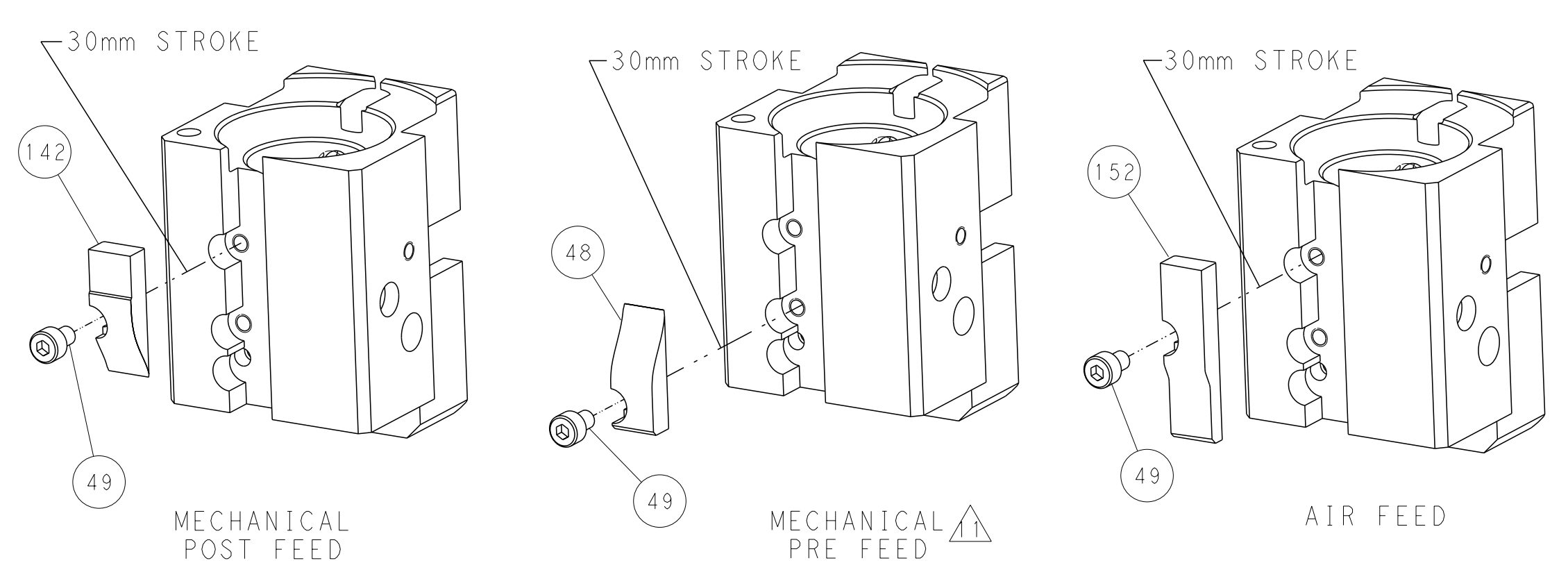
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN 23NOV2011		TE Connectivity	
mm		9 PLC ±0.5		ELB IN 23NOV2011		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		M. CLIFFORD		NAME	
MATERIAL:		4 PLC ±0.013		PRODUCT SPEC		Ocean End Feed Applicator	
FINISH:		2 PLC ±0.001		APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
		ANGLES ±		WEIGHT		A11 00779 C=2150235	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1 SHEET 4 OF 4 REV A	