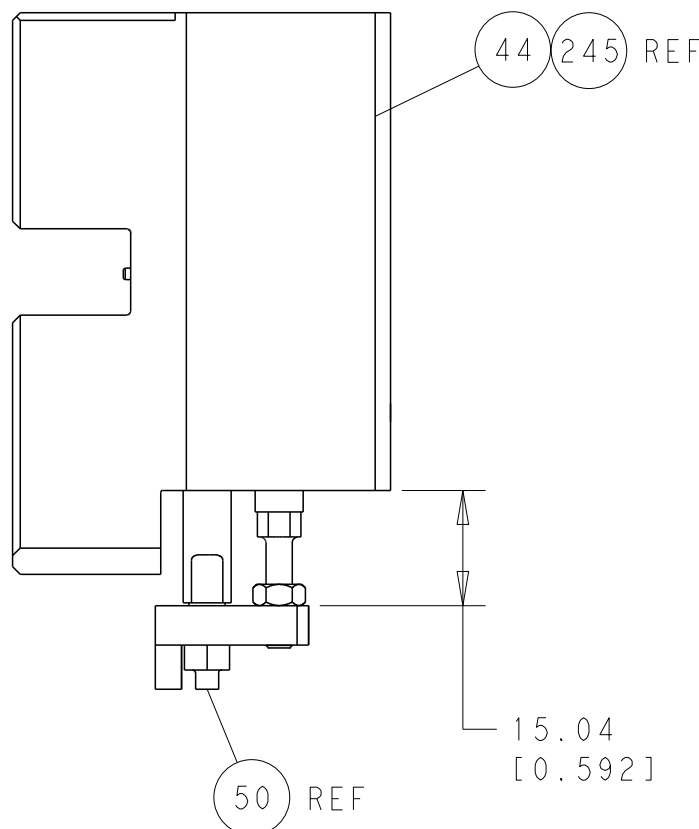
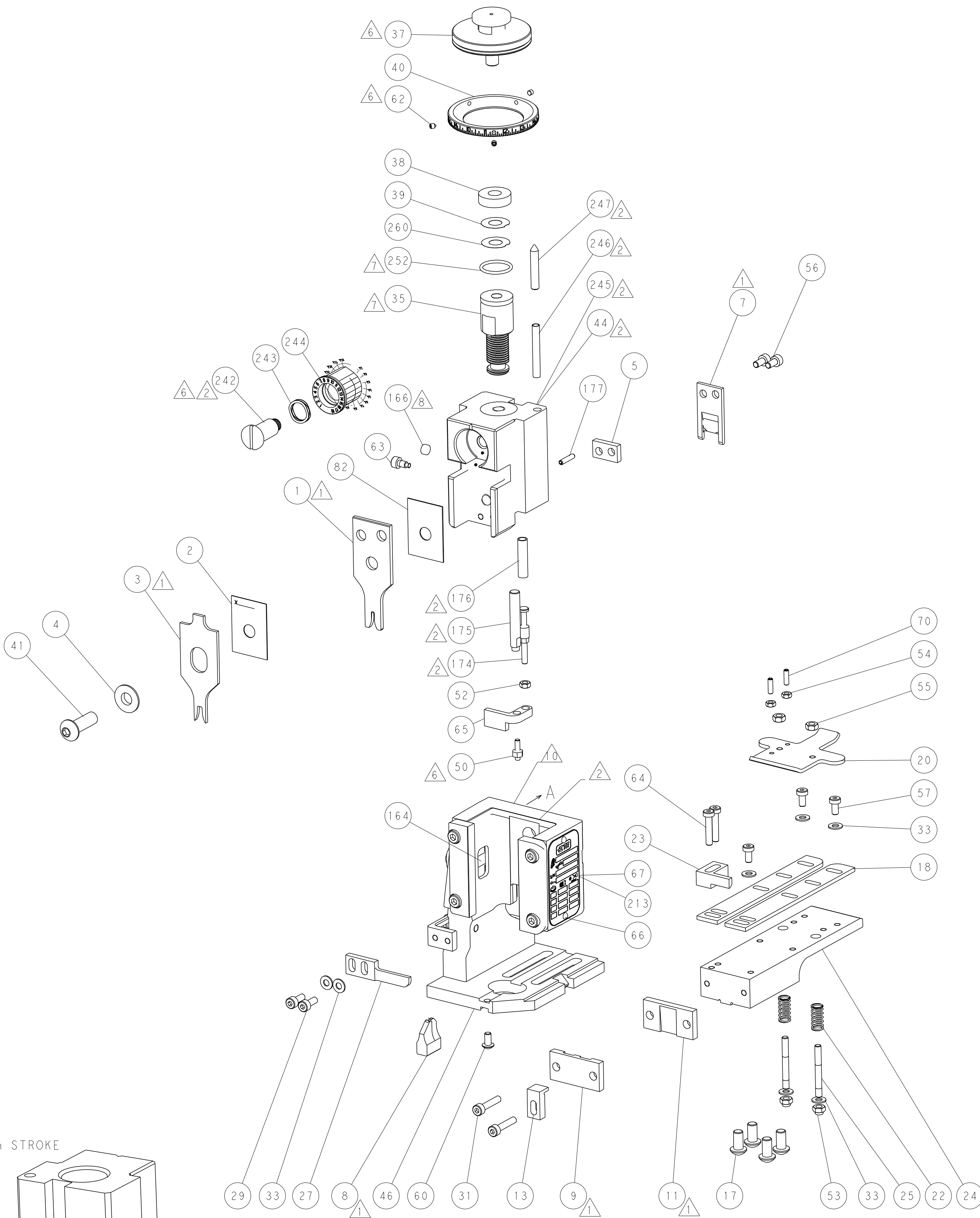


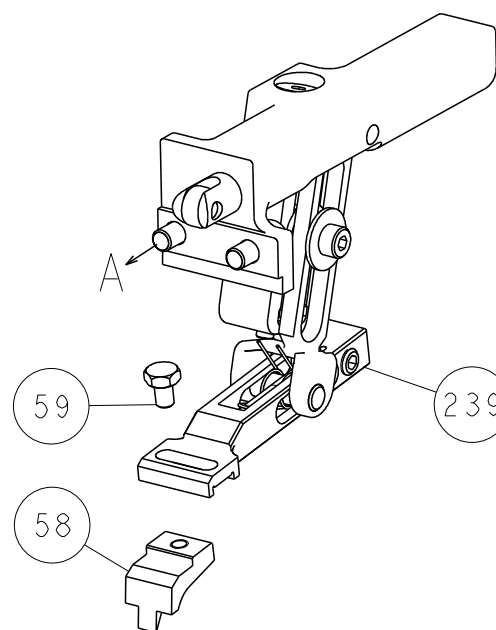
LOC		DIST		REVISONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



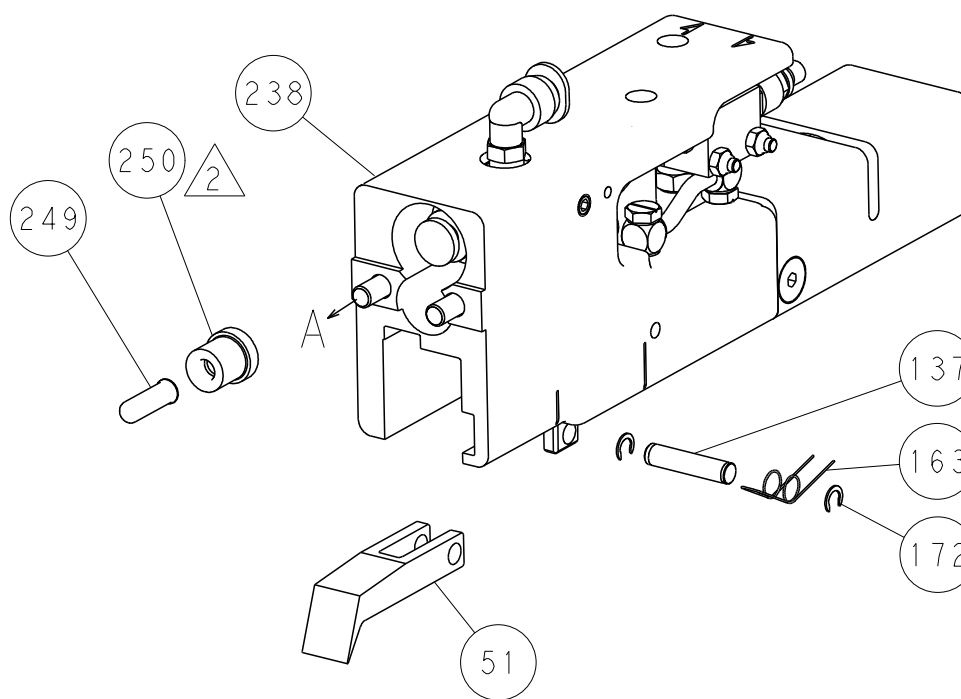
HOLDDOWN SET-UP



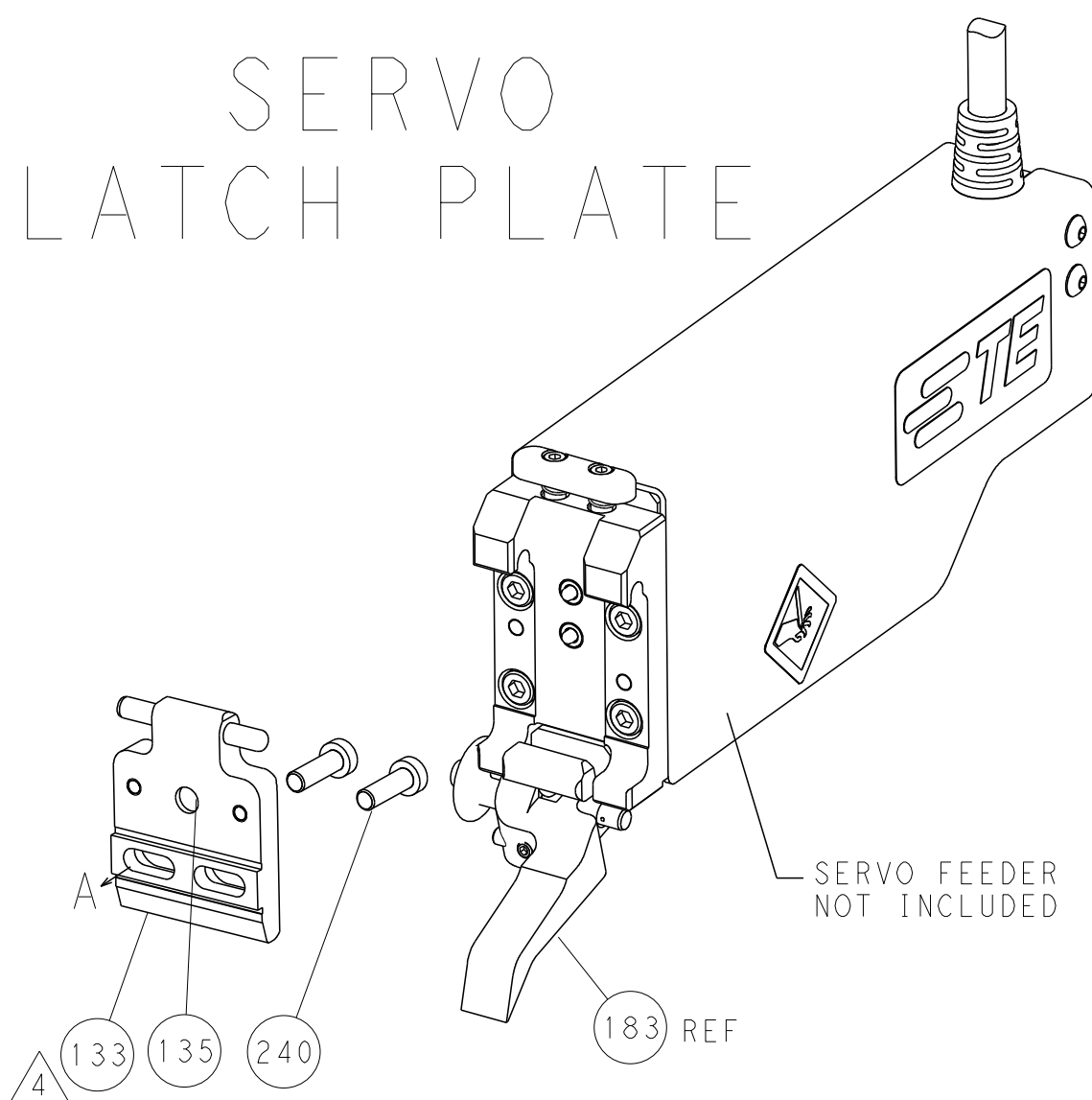
FEED TYPE
MECHANICAL



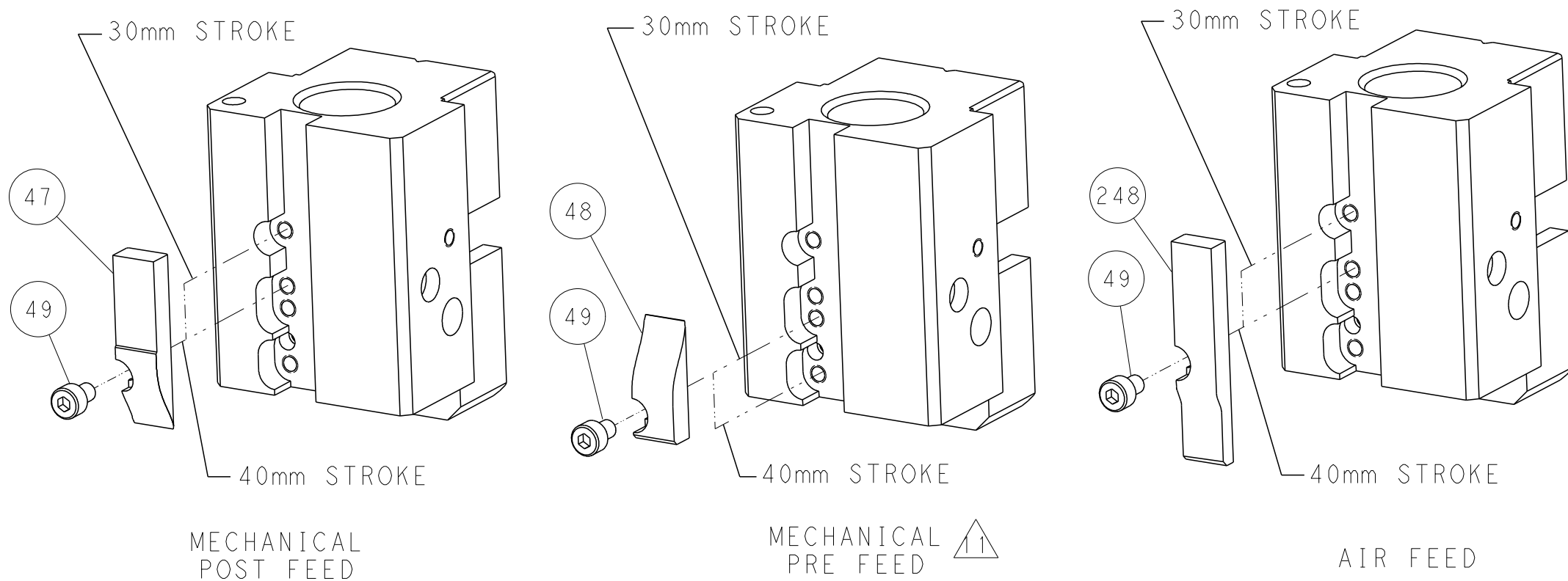
PNEUMATIC



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE CONTROLLING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.		DWN X. ZHAO 12JUN2012	TE Connectivity Harrisburg, PA 17105-3608	
CHK T. ELBIN 12JUN2012		NAME S. XI 12JUN2012	Ocean End Feed Applicator	
DIMENSIONS: mm		PRODUCT SPEC	SIZE A1	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001 FINISH		APPLICATION SPEC	CAGE CODE 00779	
MATERIAL		WEIGHT	DRAWING NO. 2150036	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:1	
			SHEET 2 OF 4	
			REV A	

8

7

6

5

4

3

2

1

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RELEASED FOR PUBLICATION

20

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER

2-2150036-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

2-2150036-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2-2150036-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2-2150036-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2150036-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.78 mm [.070]

F

INSUL

3.56 mm [.140]

F

APPL INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: "187" SERIES FASTON RECEPTACLE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

114-5013

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

0.50mm2

1.12+/-0.05 [.044+/- .002]

5.7

0.30mm2

1.02+/-0.05 [.040+/- .002]

6.8

0.20mm2

0.96+/-0.05 [.038+/- .002]

7.5

- RECOMMENDED SPARE PARTS
- 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: 8-2150036-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150036-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150036-5
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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
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.

*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	LYR	DESCRIPTION	DATE
			-	-	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	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	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
-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	65
-	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	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	1	-	2119792-2	PAWL, EF, AIR	51
-	1	1	1	1	1976055-8	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	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	2119644-1	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	1901259-5	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	690482-6	PLATE, FRONT SHEAR	9
1	1	1	1	1	1803000-2	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2217206-4	BLADE, SLUG	7
-	1	1	1	1	4-240641-1	SPACER	5
-	1	1	1	1	2-238009-3	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	1	1	1-456404-5	CRIMPER, WIRE PREMIUM	1
-77-	27	25	22	21	PART NO	DESCRIPTION	ITEM NO

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OWN
X.ZHAO

CHK
T.ELBIN

APVD
S.XI

12JUN2012

12JUN2012

12JUN2012

DIMENSIONS:
mm

0 PLC
1 PLC
2 PLC
3 PLC
4 PLC
ANGLES
FINISH

±
±0.5
±0.13
±0.013
±0.0001
±

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±
±0.5
±0.13
±0.013
±0.0001
±

MATERIAL
:

FINISH
:

DWN
X.ZHAO

CHK
T.ELBIN

APVD
S.XI

12JUN2012

12JUN2012

12JUN2012

NAME
Ocean End Feed
Applicator

SIZE
A

CAGE CODE
00779

DRAWING NO
C=2150036

RESTRICTED TO
-

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

SCALE
1:1

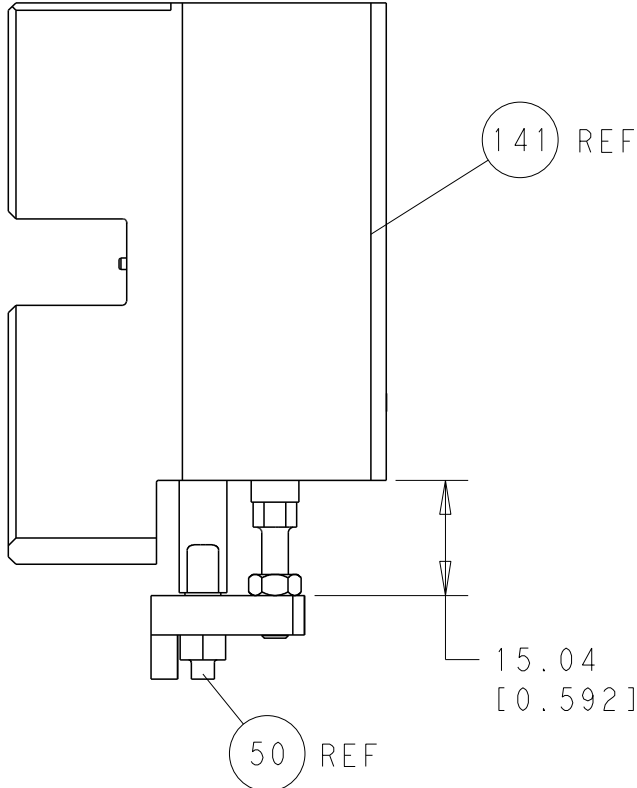
SHEET
3

OF
4

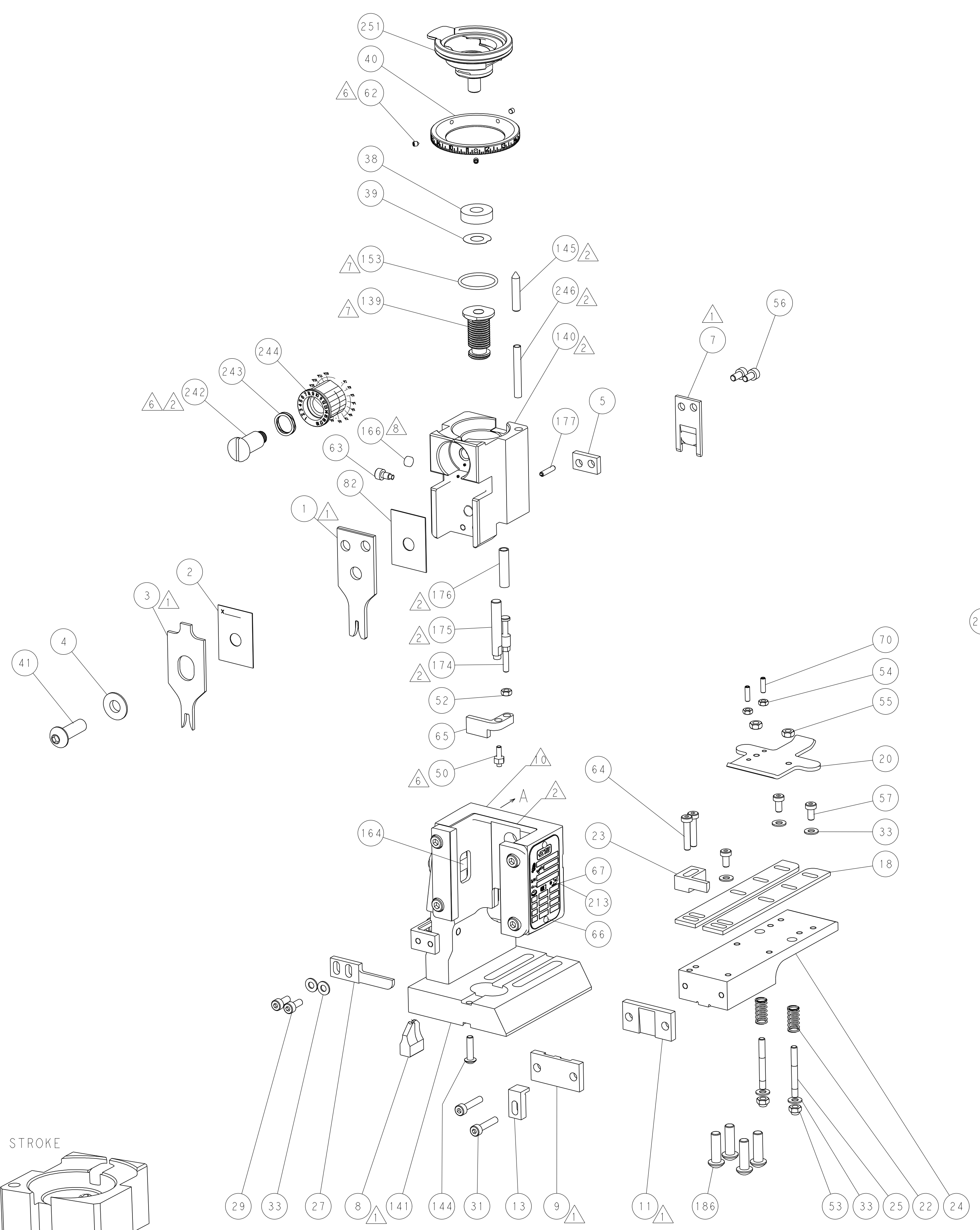
REV
A

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

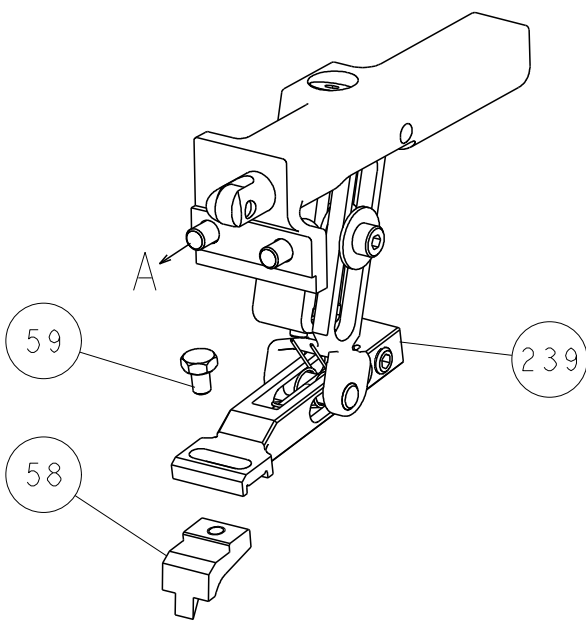
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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



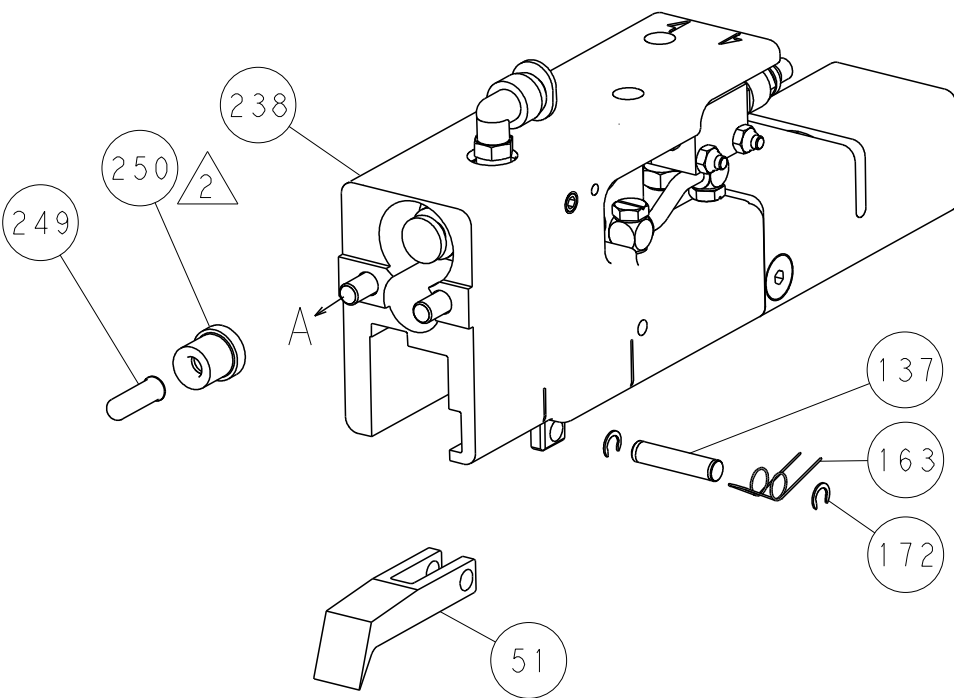
HOLDDOWN SET-UP



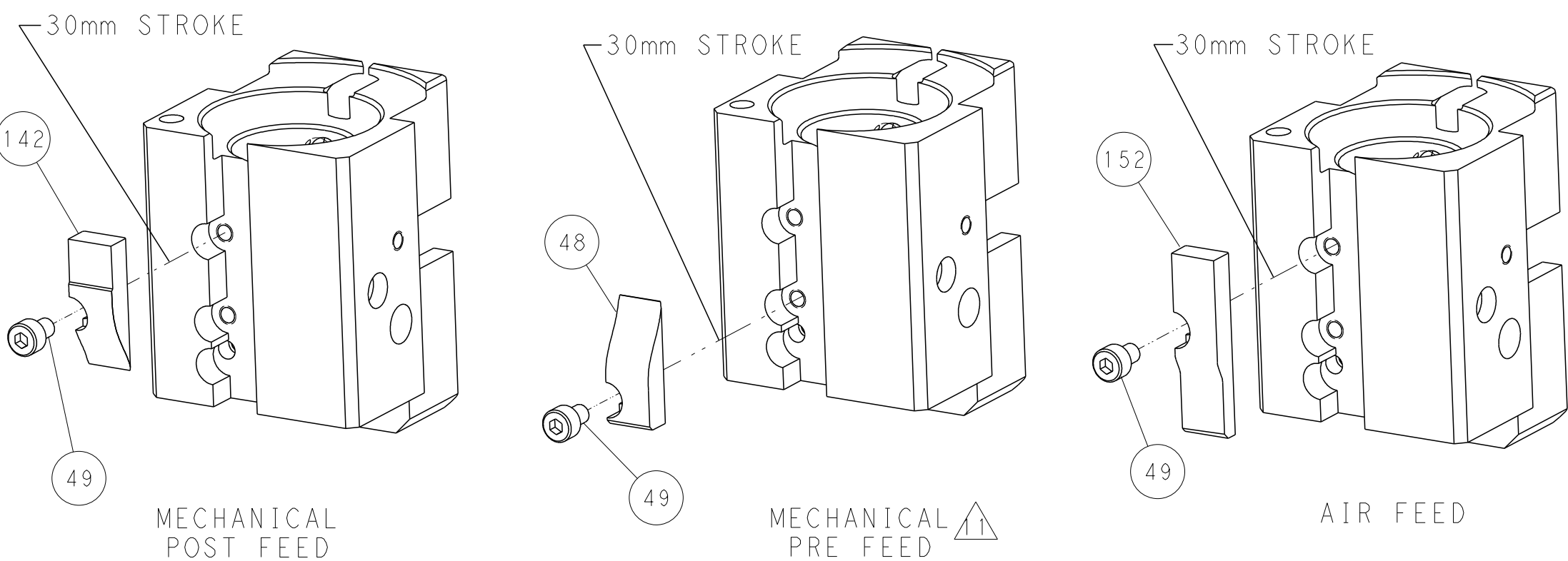
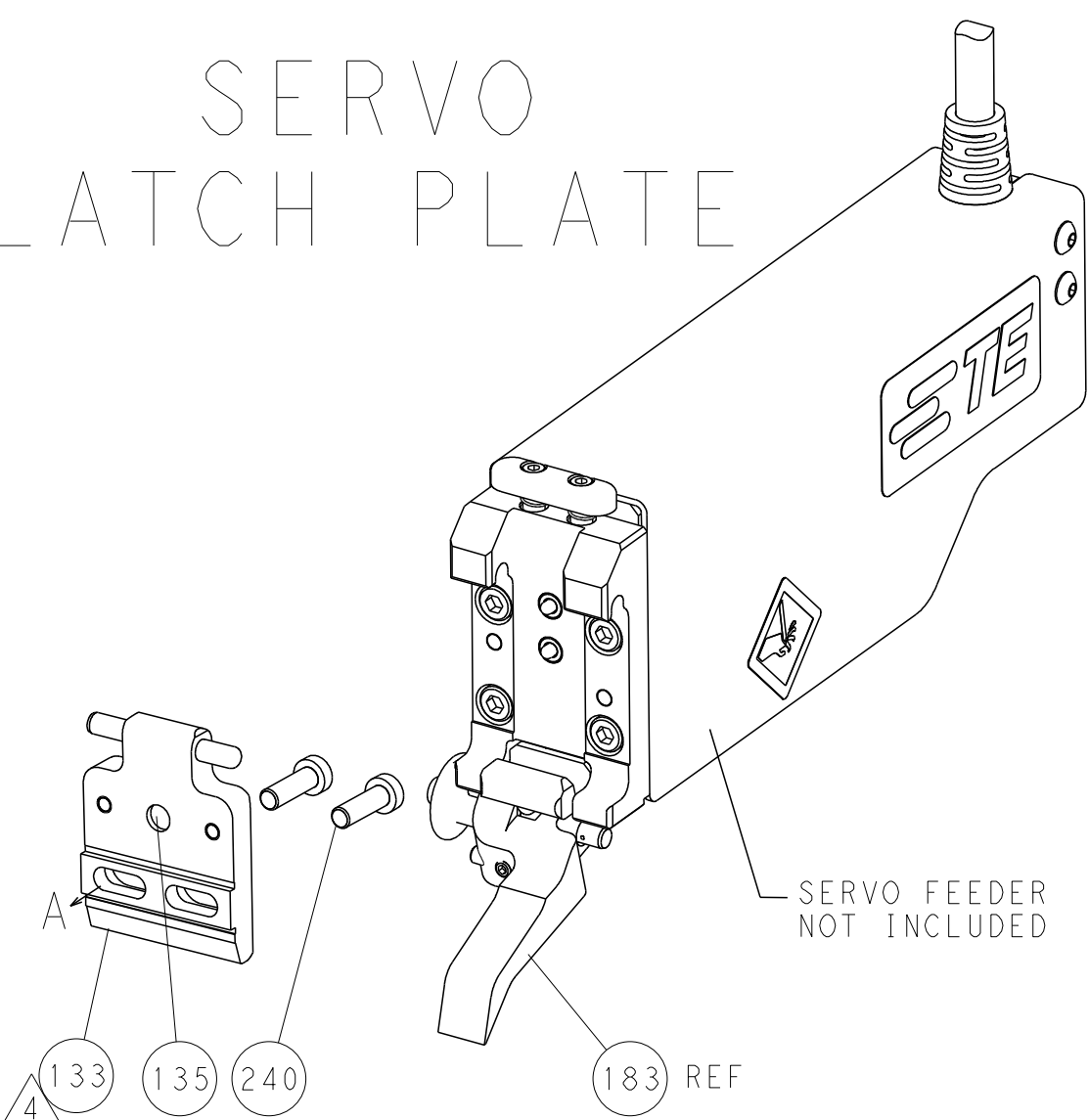
FEED TYPE
MECHANICAL



PNEUMATIC



SERVO
LATCH PLATE



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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO COMPANY POLICY AND THE CONTROLLING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST NOTATION		DWN X. ZHAO 12JUN2012	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN 12JUN2012	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.5 FINISH		APVD S. XI 12JUN2012	SIZE A	
MATERIAL		PRODUCT SPEC	CAGE CODE 00779	
		APPLICATION SPEC	DRAWING NO C=2150036	
		WEIGHT	RESTRICTED TO	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:1	
			SHEET 4 OF 4	
			REV A	

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