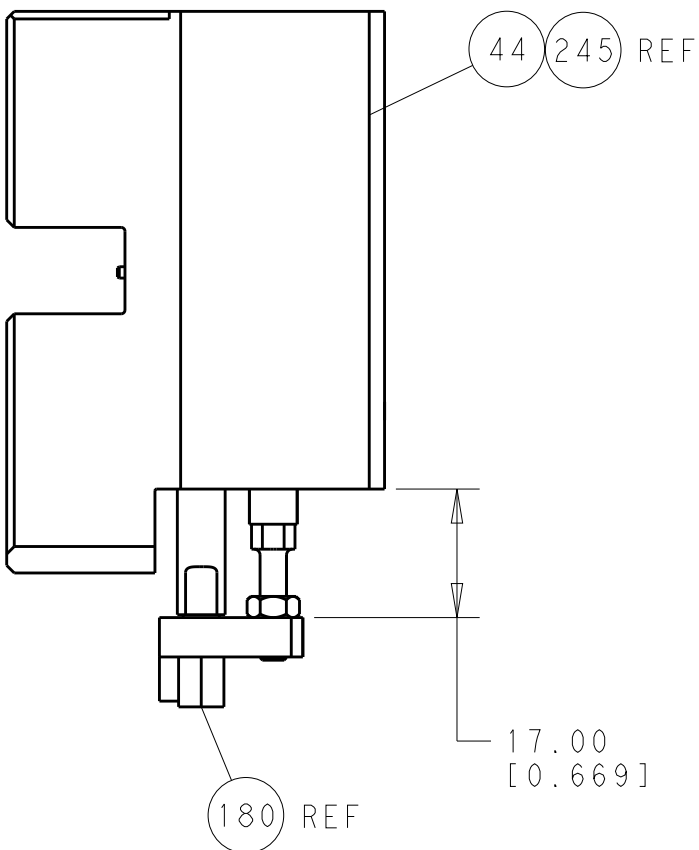
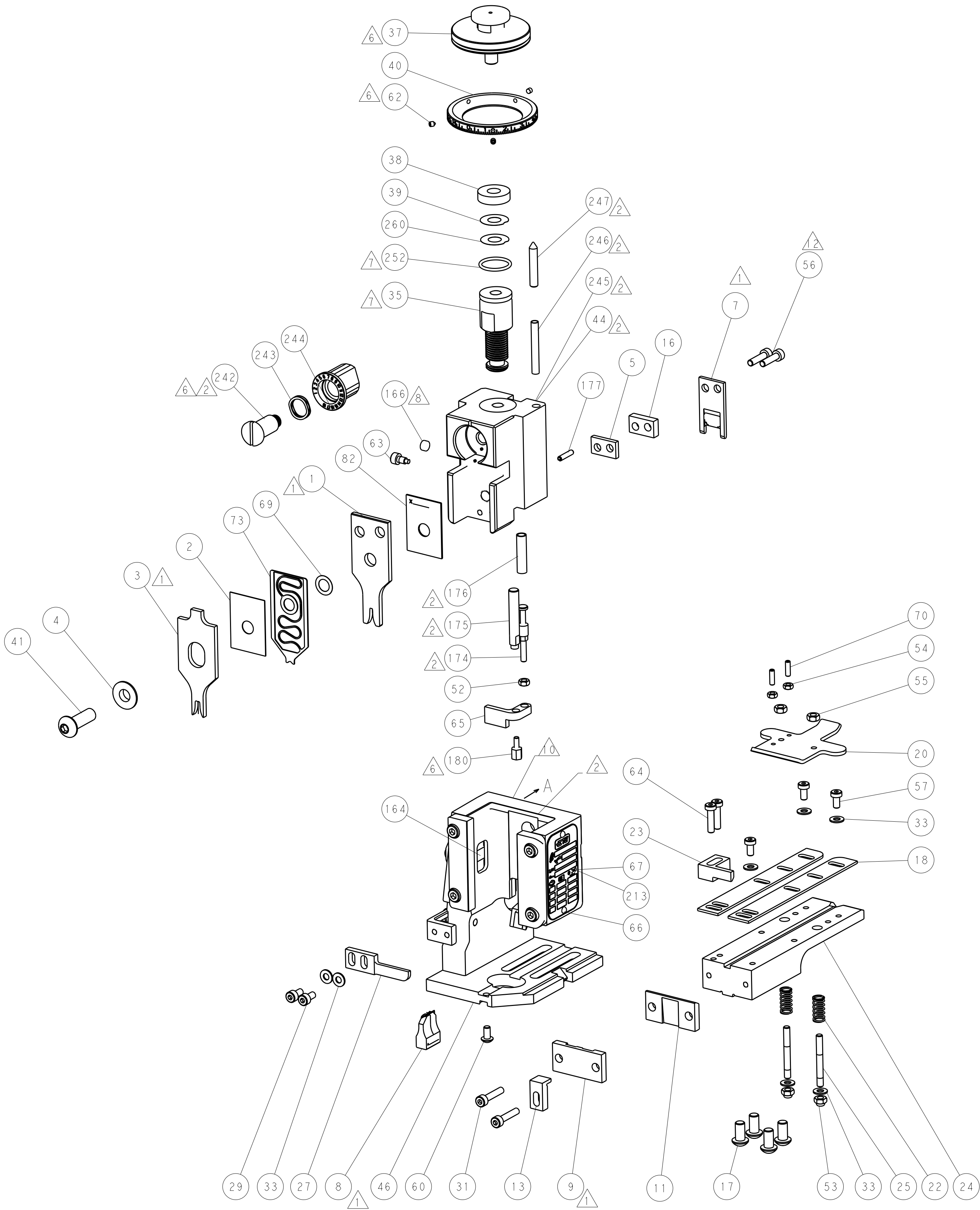


LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

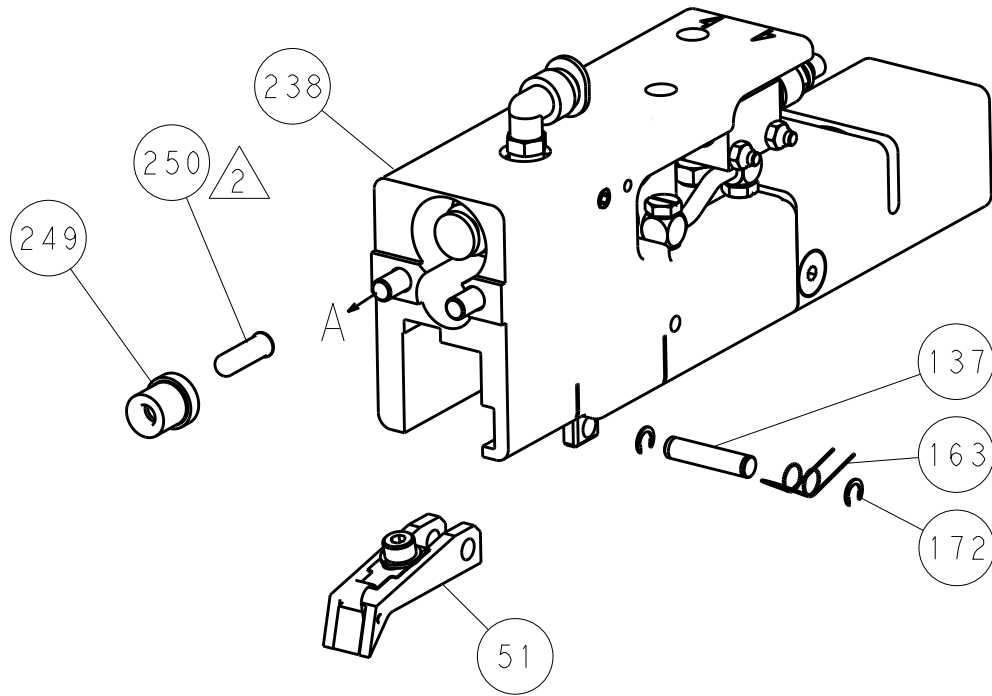


HOLDDOWN SET-UP

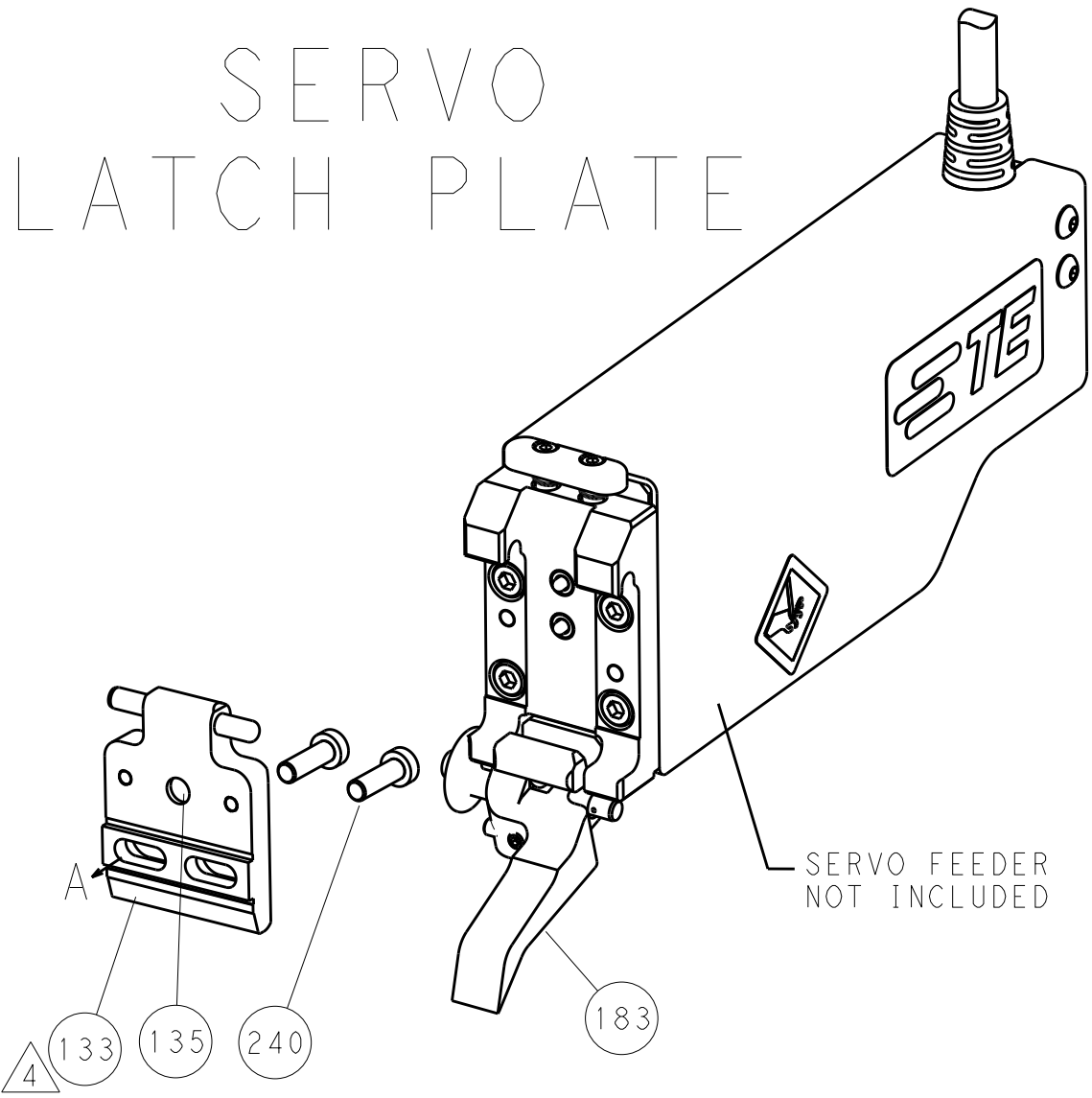


FEED TYPE

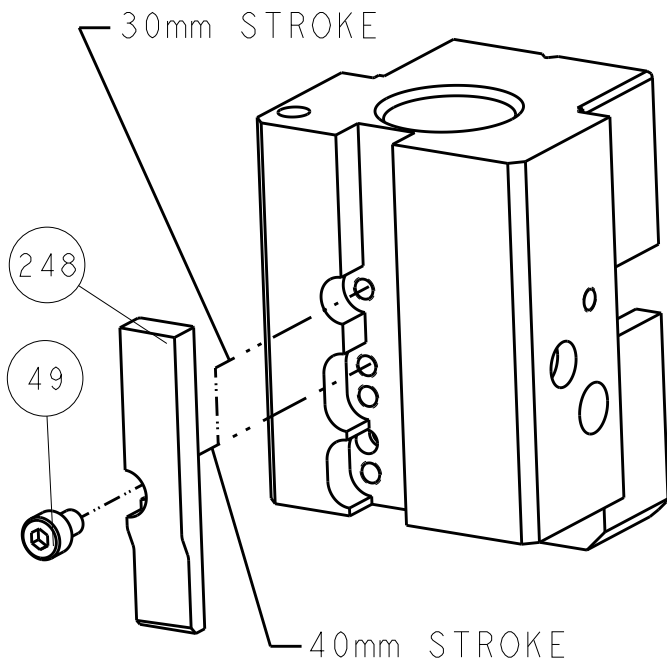
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



AIR FEED

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THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.				DWN K. HUANG 11JAN2012				TE Connectivity Harrisburg, PA 17105-3608			
CHK S. XI 11JAN2012				APVD I. CRUZ 11JAN2012				NAME Ocean End Feed Applicator			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC			
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC				±.5 ±0.13 ±0.13 ±0.001				APPLICATION SPEC			
MATERIAL				FINISH				WEIGHT			
-				-				Customer Accessible Production Drawing			
SCALE				1:1				SHEET 2 OF 4			
REV				A				RESTRICTED TO			

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150040-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1803052-1	8-2150040-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150040-4	-	-	-
	2-2150040-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	-	-	-	-	-	-	-
	2-2150040-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150040-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 POSITIVE REC EX MK-2			
WIRE STRIP LENGTH 5.50-6.50 mm [.217-.256 IN]		INSULATION DIAMETER RANGE Ø1.50-3.10 mm [.059-.122 IN]	
TERMINAL APPLICATION 		114-5119	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
175020-1	179973-1	179973-6	

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm2			1.61+/-0.05 [0.063+/-0.002]		5.3
20 AWG OR 0.50mm2			1.47+/-0.05 [0.058+/-0.002]		6.8
22 AWG OR 0.30mm2			1.41+/-0.05 [0.056+/-0.002]		7.5



```
*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	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
-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

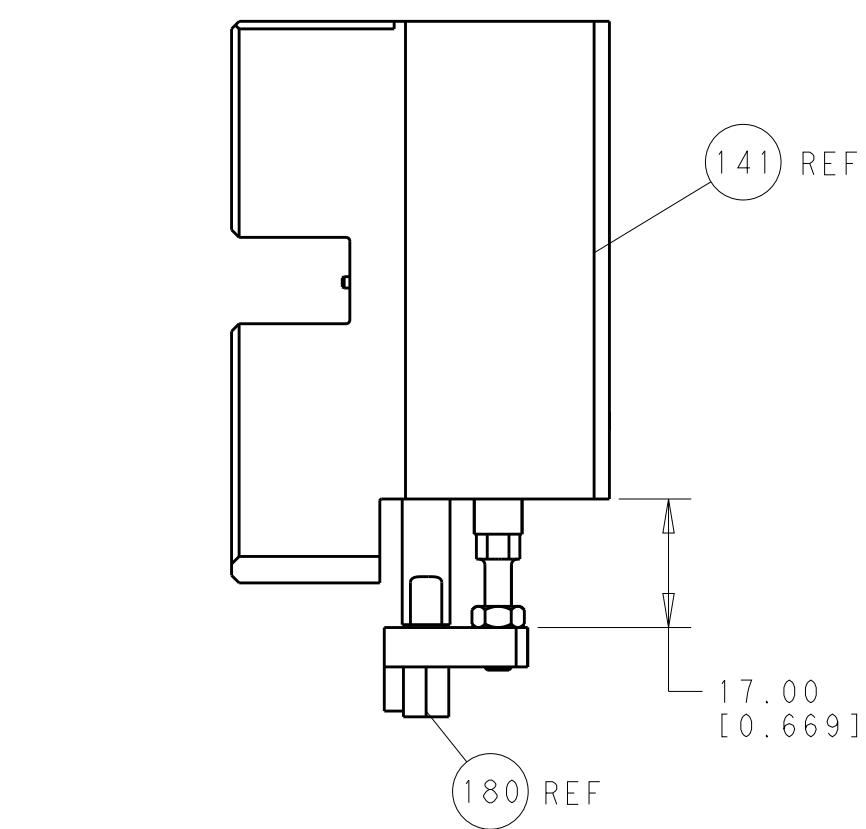
PACIFIC VERSION
(Atlantic version shown on sheets 1 of 4 & 2 of 4)
Shown on sheets 3 of 4 & 4 of 4

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

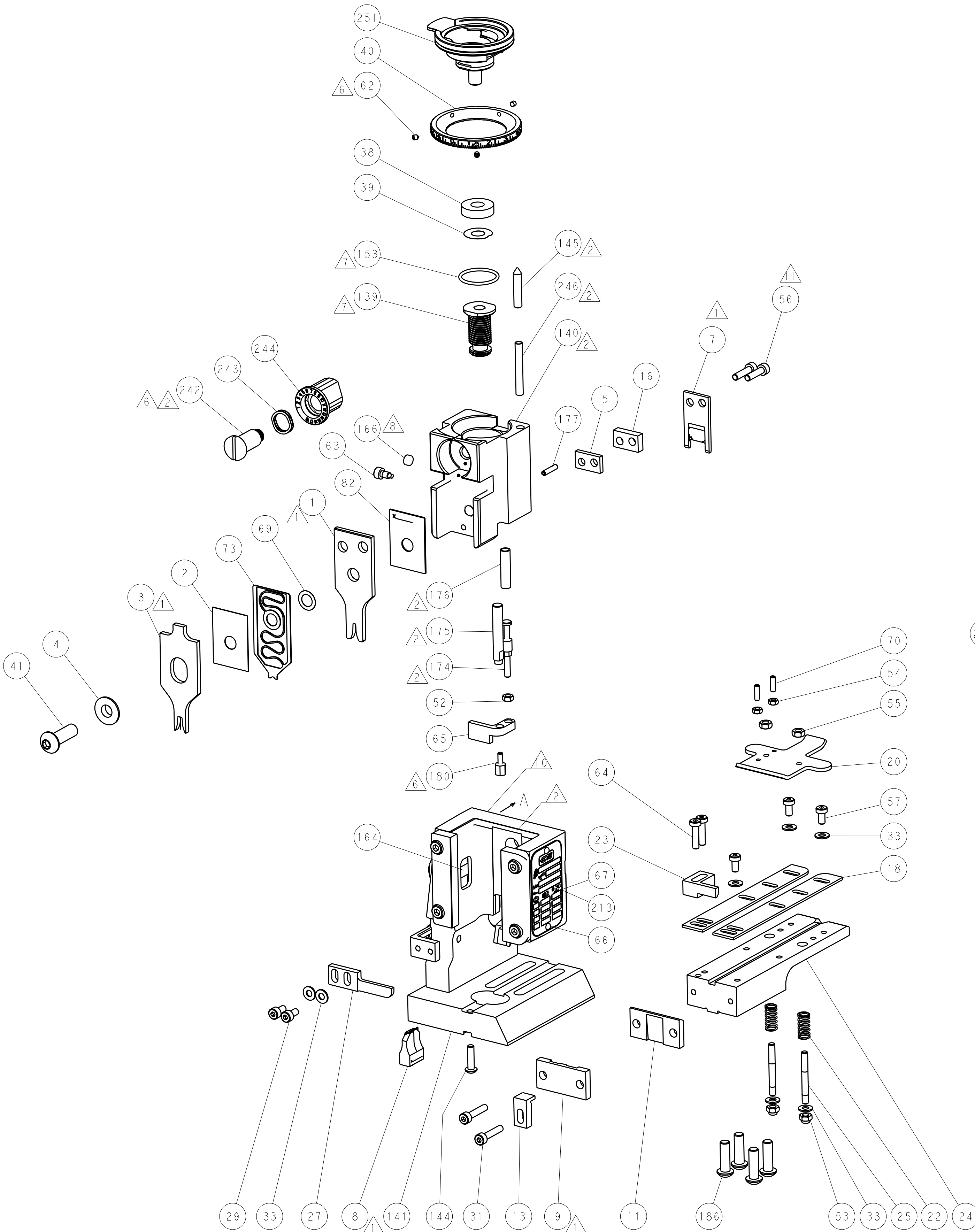
	-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	1	1	2119082-9	CAM,SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
	-	-	1	-	-	2119740-2	TAG,IDENTIFICATION	213
	-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	-	1	-	-	1803052-1	FEED FINGER ASSEMBLY,EF	183
6	-	1	1	1	1	1-1752354-1	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	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	455888-7	SPACER, CRIMPER	82
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
	-	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	1	2119943-1	WASHER, SPACER	69
	-	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	1901681-1	HOLDDOWN, TERMINAL	65
	-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
6	-	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
	-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
1	-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	-	2031314-1	FEED FINGER SUBASSEMBLY	51
	-	-	-	1	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	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	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	2-1752371-7	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	1901259-3	GUIDE, LOWER STRIP	18
	-	1	1	1	1	2-240641-9	SPACER	16
	-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	1	1	240833-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	-	10
1	-	1	1	1	1	690482-4	PLATE, FRONT SHEAR	9
1	1	1	1	1	1	1333216-4	ANVIL, COMBINATION	8
1	-	1	1	1	1	1-2217206-0	BLADE, SLUG	7
	-	1	1	1	1	5-240641-2	SPACER	5
	-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	1	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1
-77-27-25-22						PART NO	DESCRIPTION	ITEM NO

(NOTES: 1) IT IS THE BUYER'S RESPONSIBILITY TO OBTAIN ALL NECESSARY INFORMATION FROM THE SUPPLIER REGARDING THE PRODUCT. 2) THE BUYER SHALL BE CONTACTED FOR THE LATEST REVISIONS.				DWN 11JAN2012 CHK C.HUANG S.XI 11JAN2012 REV1 JCRUZ 11JAN2012		 TE Connectivity Harrisburg, PA 17105-3608							
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator							
				PRODUCT SPEC									
				APPLICATION SPEC									
MATERIAL		FINISH		WEIGHT		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
-		-		-		A		00779		C=2150040		-	
Customer Accessible Product Drawing						SCALE		1:1		SHEET		3 of 4	
						REV A							

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



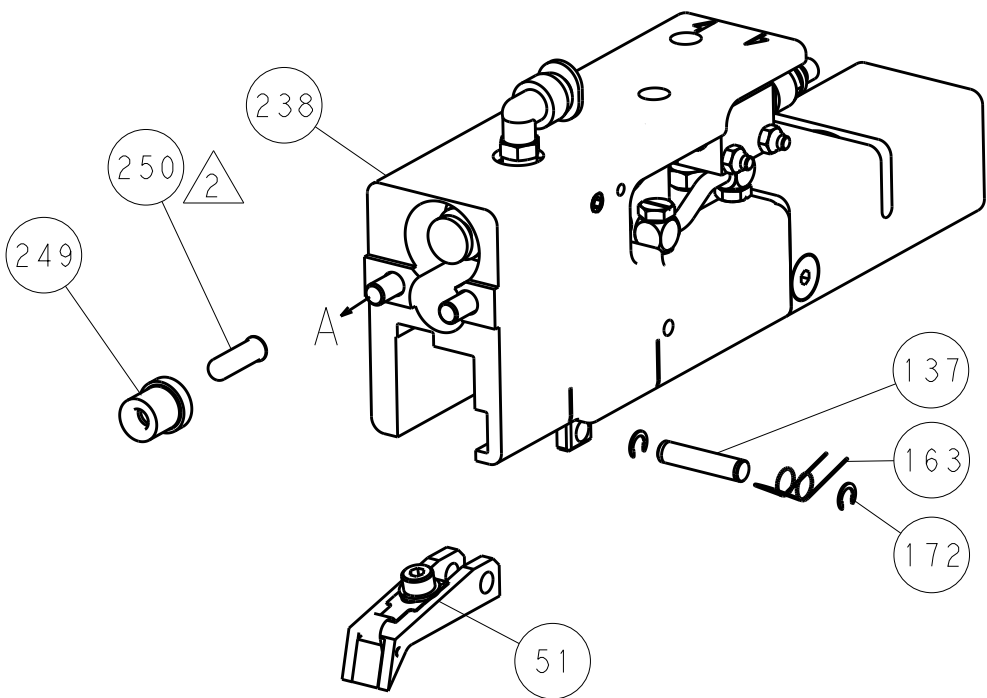
HOLDDOWN SET-UP



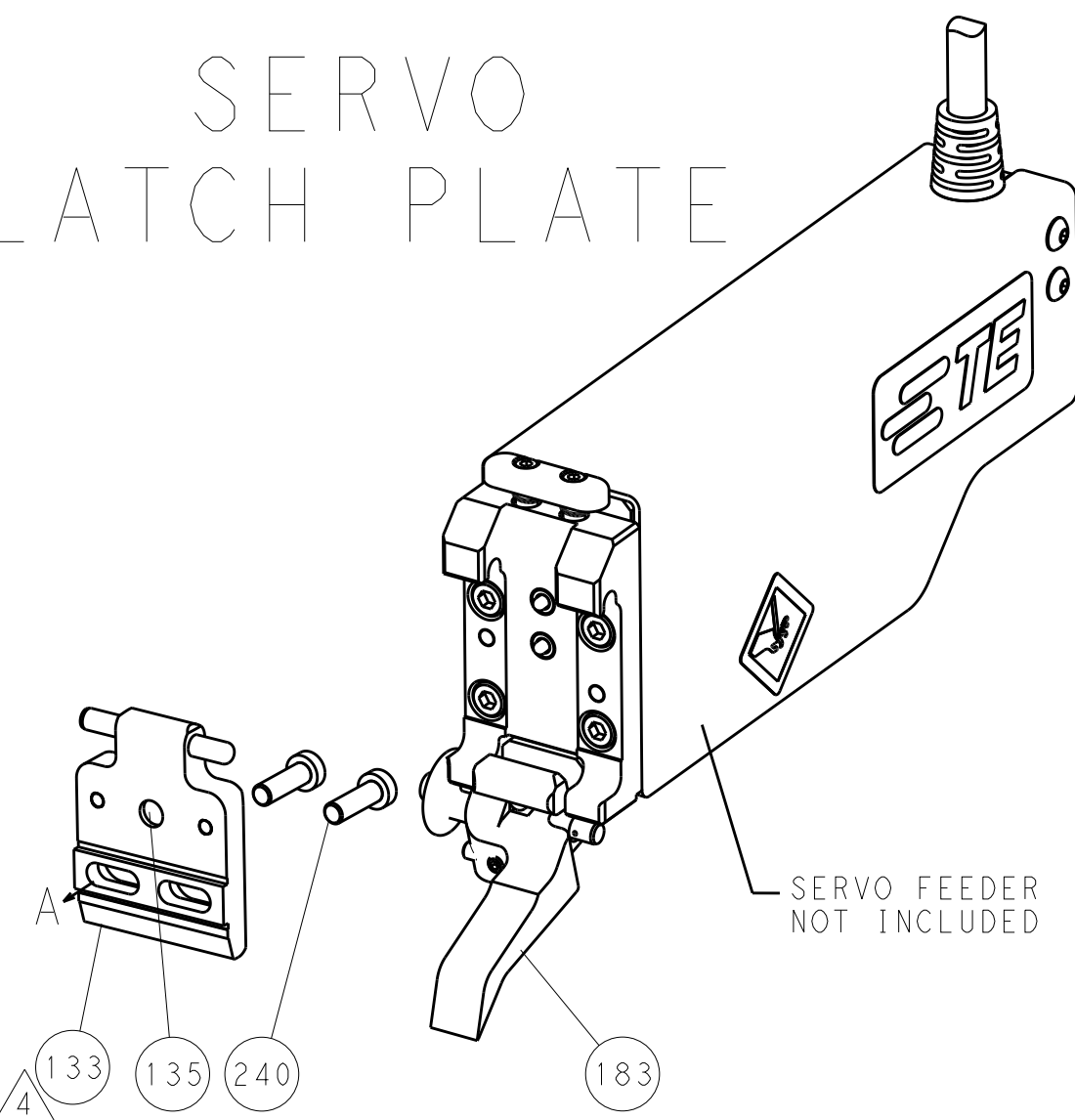
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

FEED TYPE

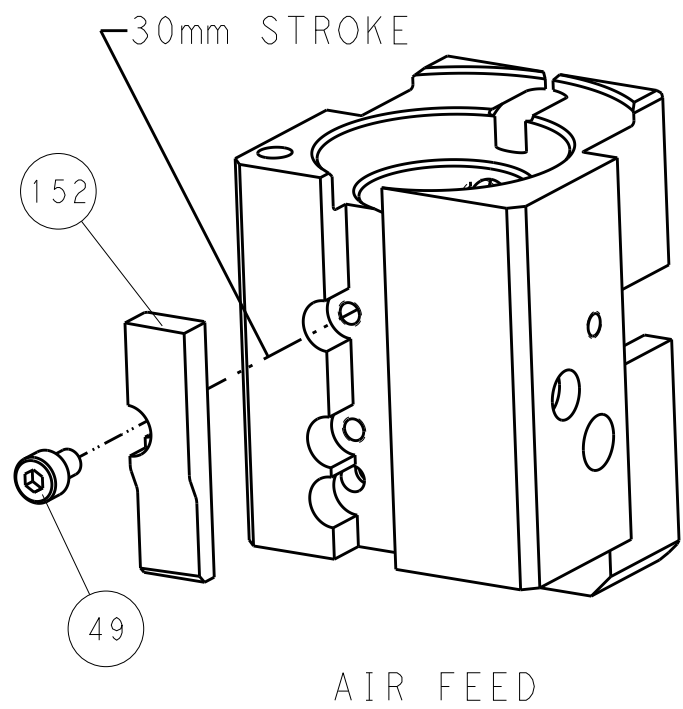
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



AIR FEED

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN: R. HUANG 11JAN2012				STE TE Connectivity Harrisburg, PA 17105-3608			
CHK: S. XI 11JAN2012				APVD: J. CRUZ 11JAN2012				NAME: Ocean End Feed Applicator			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:				SIZE: CAGE CODE: DRAWING NO: 00779 C=2150040			
0 PLC ±.5				1 PLC ±.13				RESTRICTED TO			
2 PLC ±.13				3 PLC ±.013				SCALE: 1:1			
4 PLC ±.0001				ANGLES FINISH				SHEET 4 OF 4			
MATERIAL				WEIGHT				REV A			
				Customer Accessible Production Drawing							

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