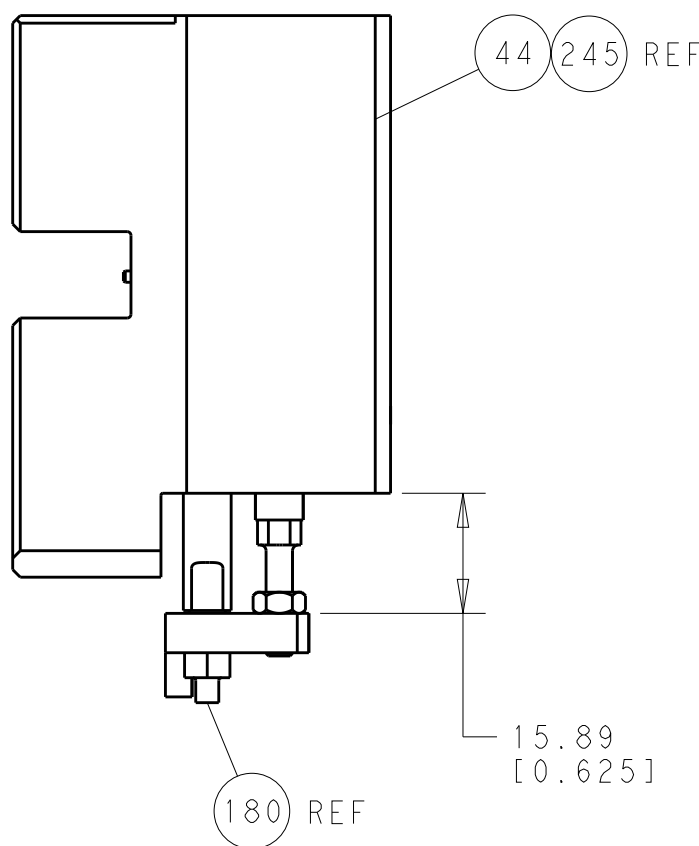
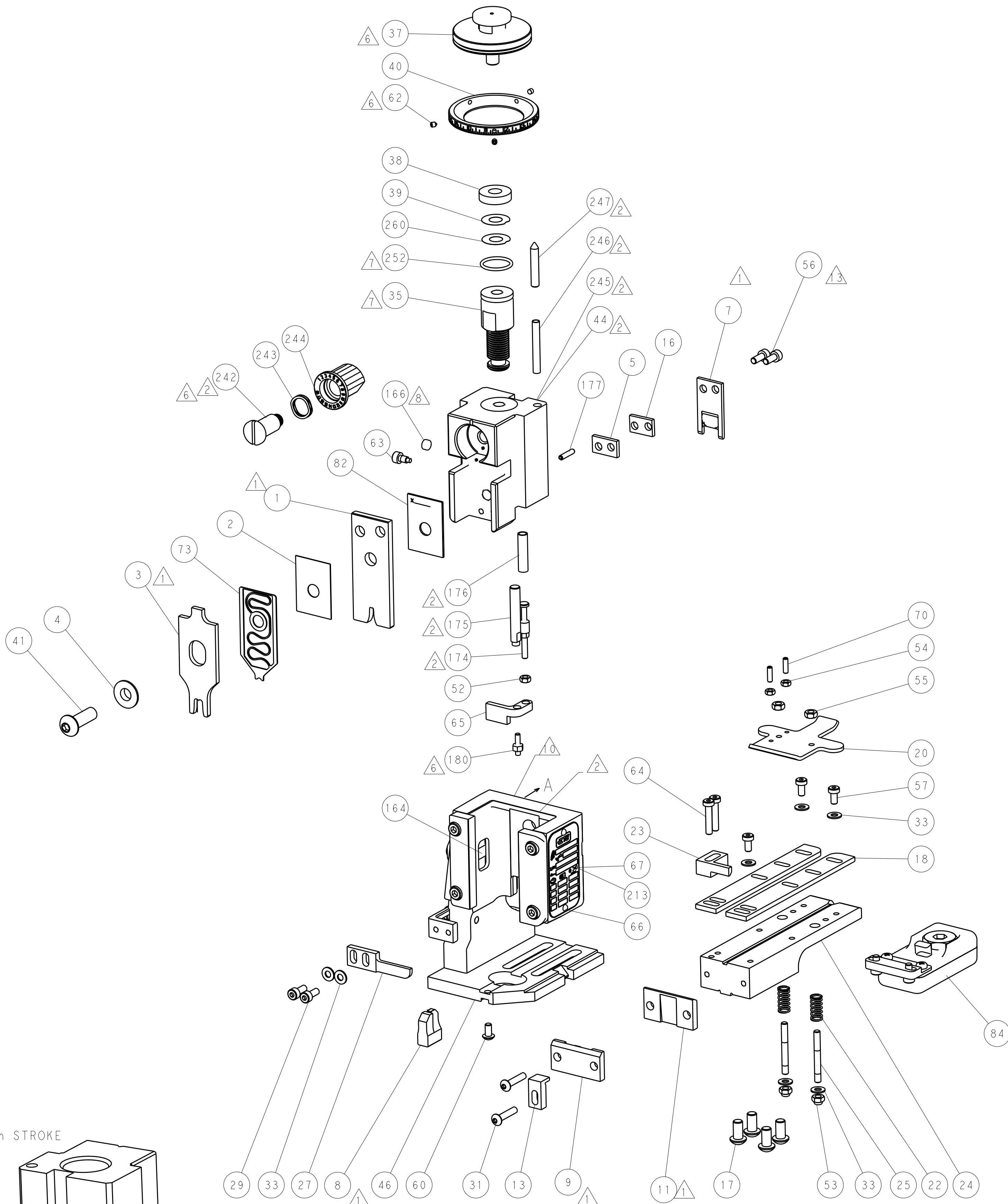


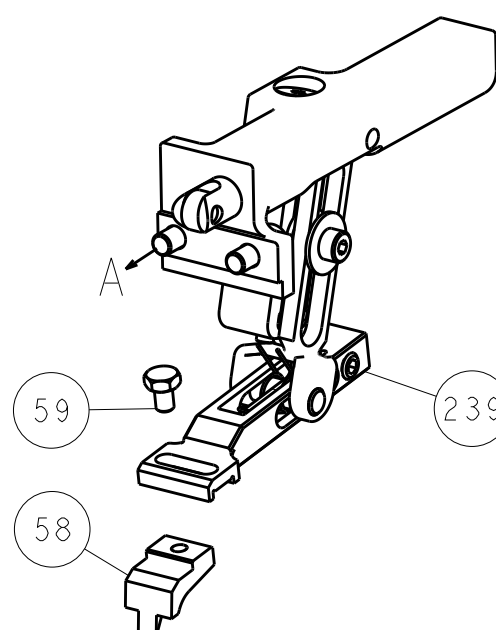
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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



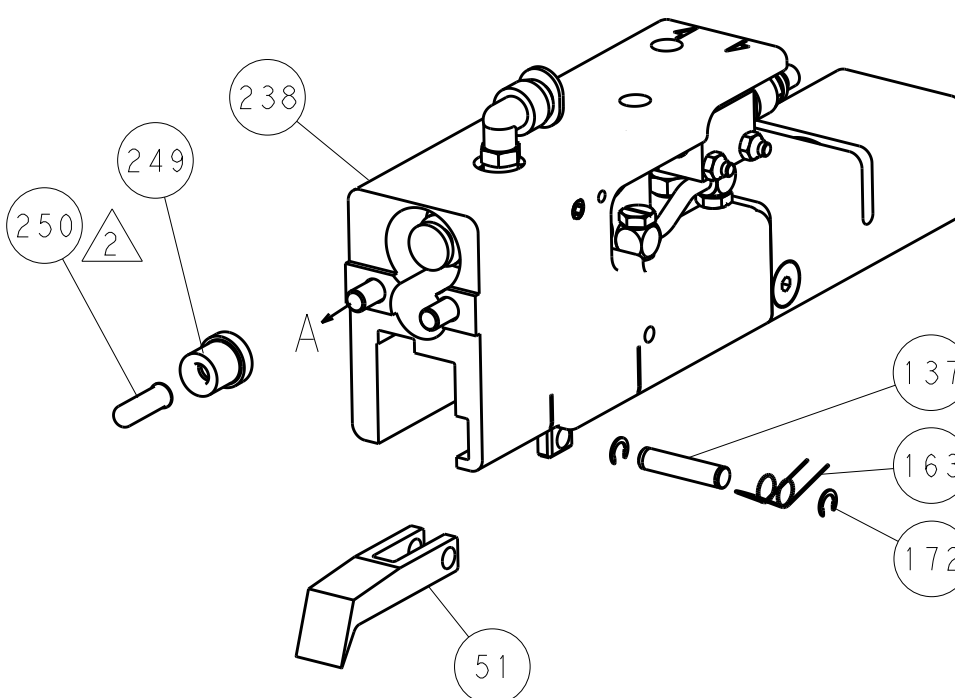
HOLDDOWN SET-UP



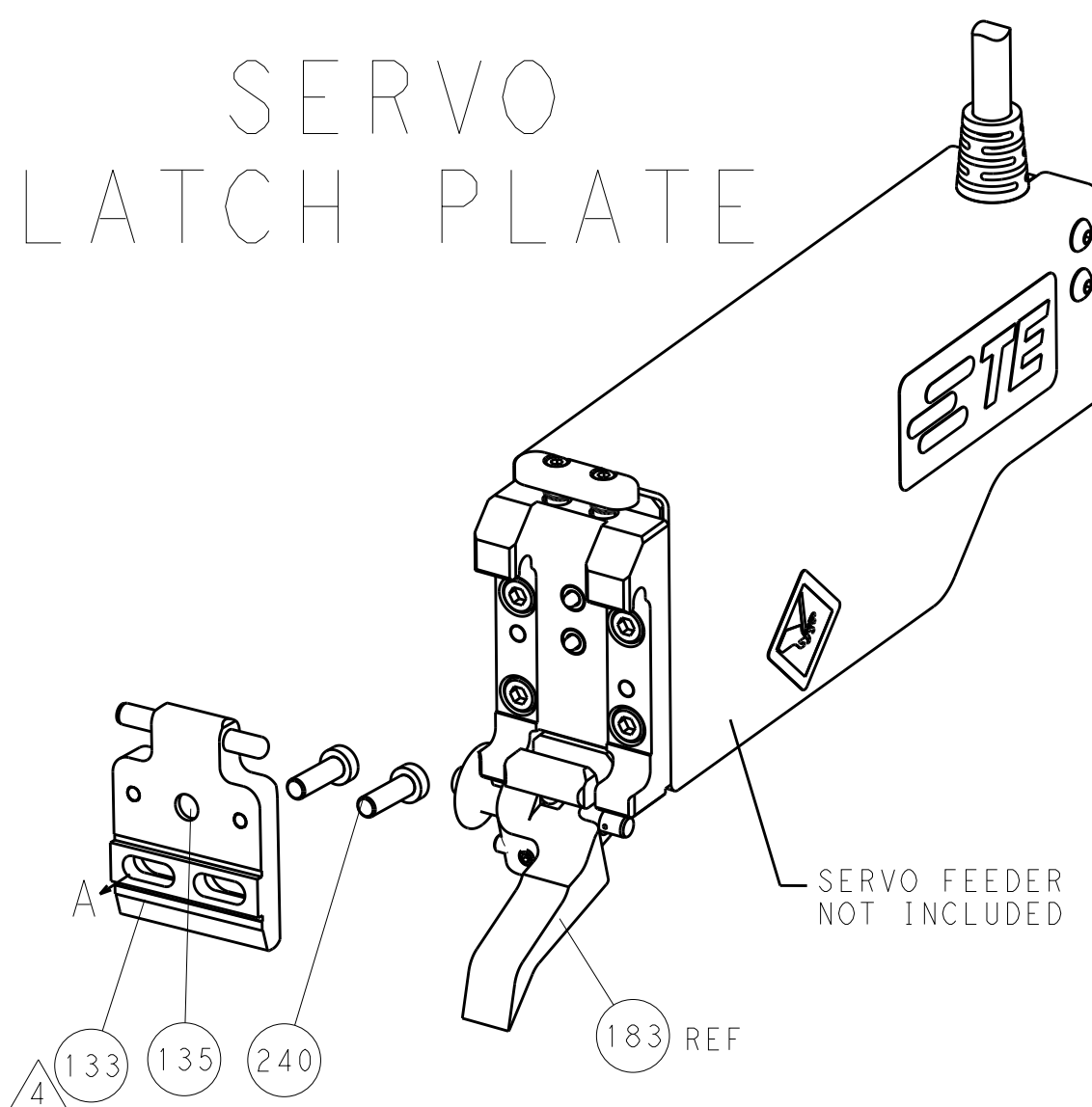
FEED TYPE
MECHANICAL



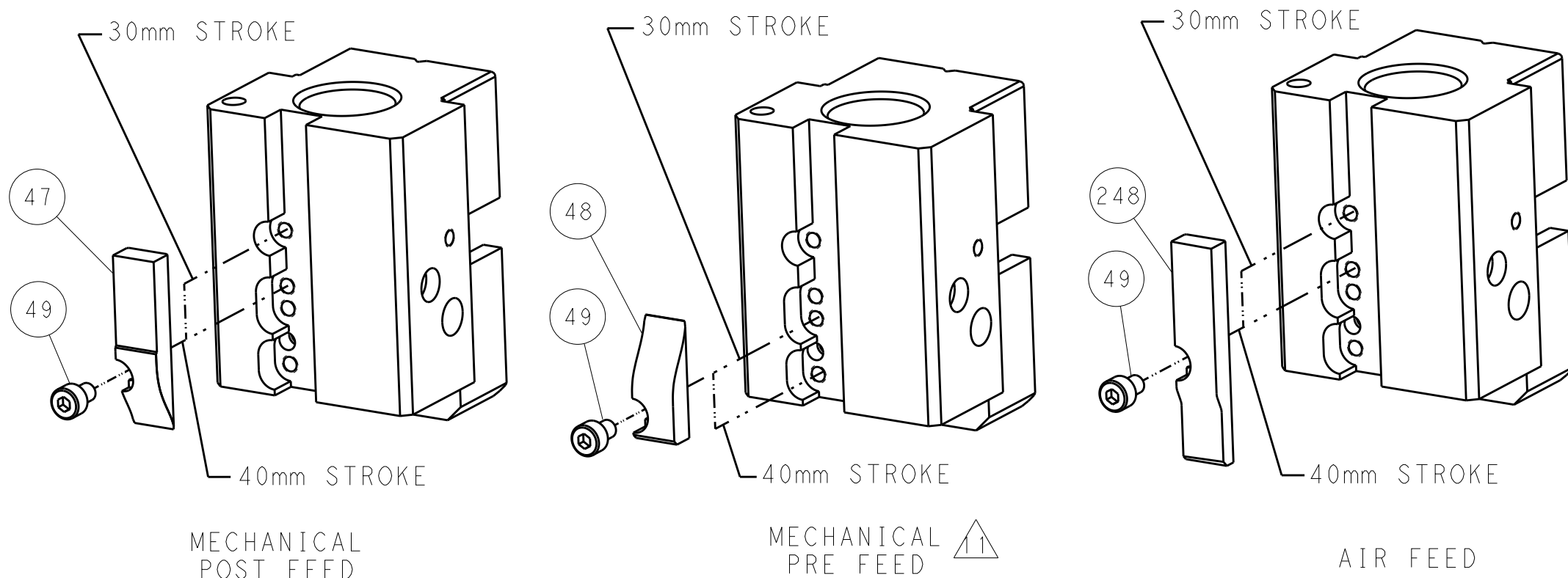
PNEUMATIC



SERVO
LATCH PLATE

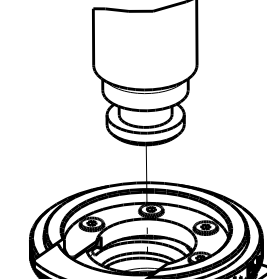


CAM POSITIONS



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: CHANGELIST REQUIRED FOR: TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGELIST REQUIREMENT AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST NOTATION.				DWN: HOFFNER 7FEB2012		TE Connectivity	
				CHK: T.ELBIN 8FEB2012		Harrisburg, PA 17105-3608	
				APVD: T.ELBIN 8FEB2012		NAME	
				PRODUCT SPEC		Ocean End Feed	
				APPLICATION SPEC		Applicator	
				WEIGHT		SIZE	
				Customer Accessible Production Drawing		A1 00779 ©=2150247	
				SCALE		1:1	
				SHEET		2 of 4	
				REV		D2	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150247-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150247-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150247-4	-	-	-
	2-2150247-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150247-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150247-4	-	-	-
	2-2150247-5	D	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
	2-2150247-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150247-7	D	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	6.35 mm [.250]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION
TERMINAL NAME: .250 SERIES FASTIN-FASTON RECEPTACLE				
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE	
4.72-4.74 mm [.186-.186 IN]			Ø4.06-5.33 mm [.160-.210 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-2025	-	-	
	(B)114-2036	-	-	
TERMINALS APPLIED ³				
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	
(A) 60249-1	(A) 60249-2	(A) 60249-3	(B) 63896-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
12 AWG		2.18+/-0.05 [.086+/- .002]		4.3
2x16 AWG		2.03+/-0.05 [.080+/- .002]		6.8
14 AWG		1.85+/-0.05 [.073+/- .002]		8.1
16 AWG		1.65+/-0.05 [.065+/- .002]		10.4



- ¹ RECOMMENDED SPARE PARTS
- ² 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: 8-2150247-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150247-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150247-5
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 ITEMS 62, 180 & 242.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- 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.
- ¹² CUT TO LENGTH AT ASSY.
- ¹³ 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	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	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
-77-27-25-22-21					PART NO	DESCRIPTION	ITEM NO

⁶

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

-	-	-	-	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	1-1976055-1	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	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	455888-9	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	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	2168400-5	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	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	2119644-2	RAM WASHER, PRECISION	38
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2079383-5	SCR, BHSC, 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	1752371-3	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-3	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4	DRAW	20
-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	1	1	1	1	8-240641-6	SPACER	16
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690496-4	PLATE, FRONT SHEAR	9
1	1	1	1	1	1803000-6	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	1	1	1	1	1-240641-6	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	2-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	1	1	456423-2	CRIMPER, WIRE PREMIUM	1
-77-27-25-22-21					PART NO	DESCRIPTION	ITEM NO

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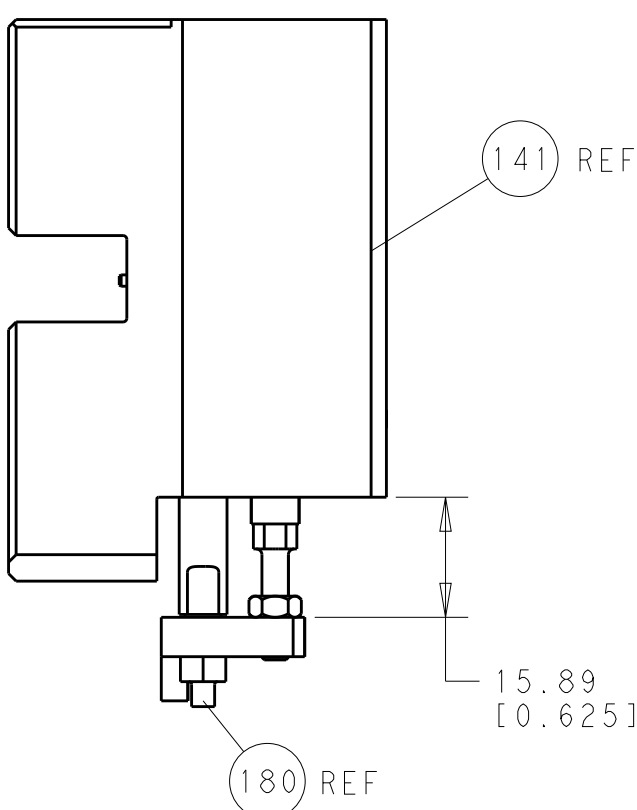
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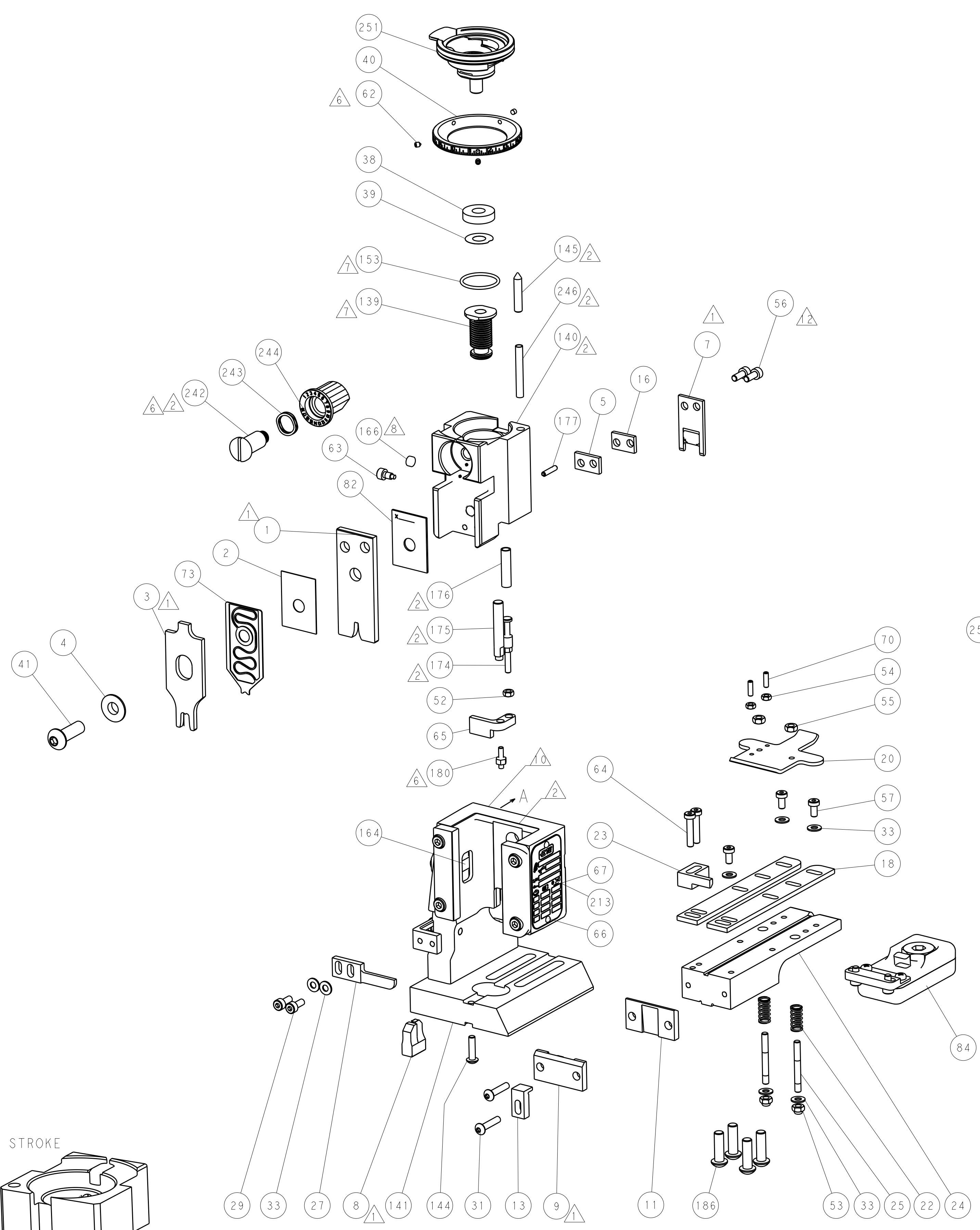
¹

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN HOFFNER 7/FEB/2012	STE TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:	CHK T.ELBIN 8/FEB/2012	NAME		
mm				0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5	APVD T.ELBIN 8/FEB/2012	Ocean End Feed Applicator		
				PRODUCT SPEC -	SIZE CAGE CODE DRAWING NO RESTRICTED TO			
MATERIAL				APPLICATION SPEC -	A 00779 C=2150247			
FINISH				WEIGHT	Customer Accessible Production Drawing			
					SCALE 1:1 SHEET 3 OF 4 REV D2			

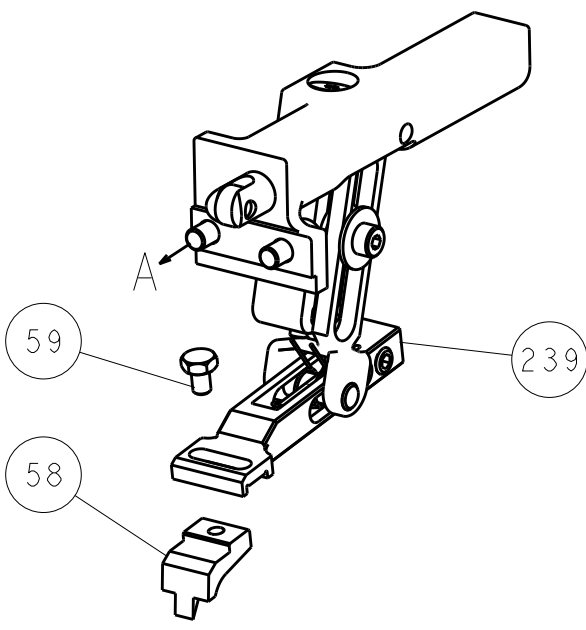
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



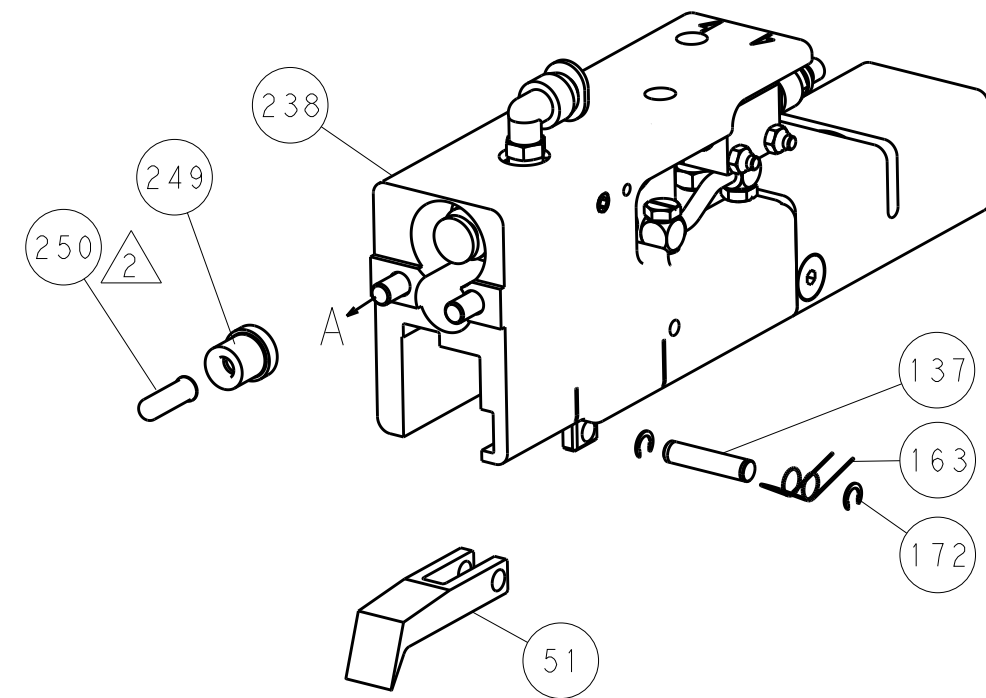
HOLDDOWN SET-UP



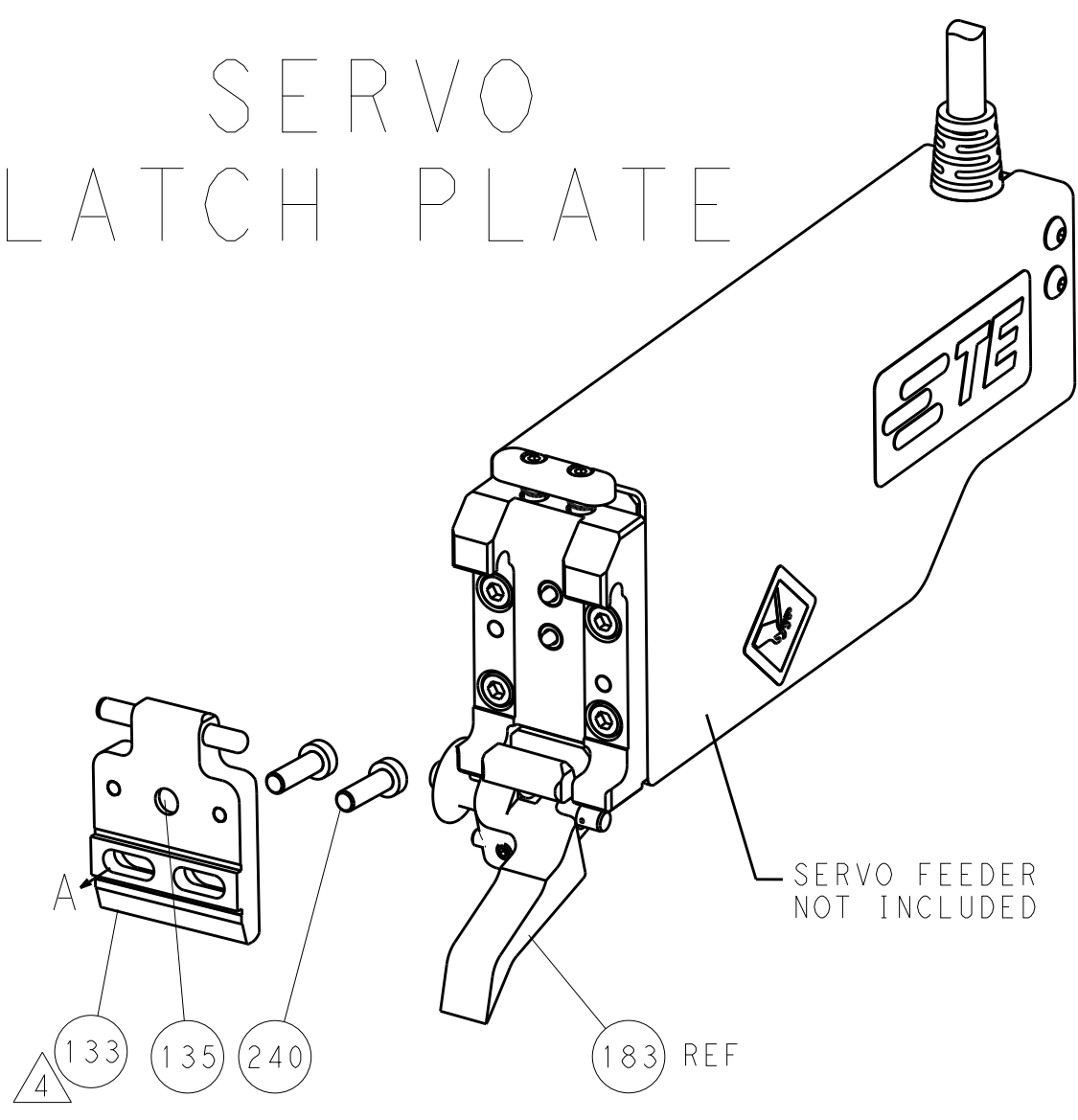
FEED TYPE
MECHANICAL



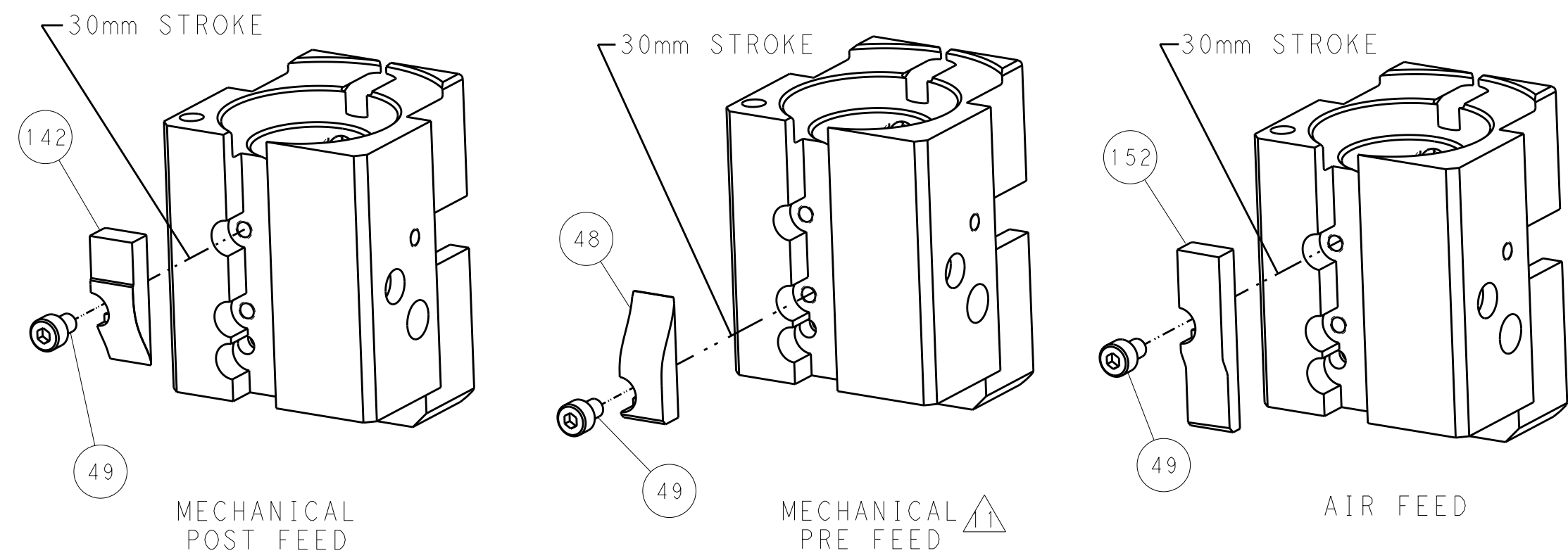
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: HOFFNER 7FEB2012		CHG: TELBIN 8FEB2012		NAME: TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±0.5		APVD: TELBIN 8FEB2012		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: 00779 C=2150247	
MATERIAL:		FINISH:		APPLICATION SPEC		WEIGHT:		RESTRICTED TO:	
				ANGLES:		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 4 OF 4 REV D2	

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