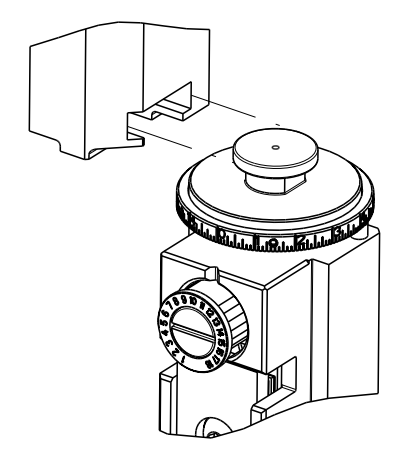


SET UP GAUGE 2119599-2 LOC A DIST 66 REVISIONS TABLE

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER TABLE with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED



APPLICATOR DATA TABLE with columns: CRIMP, SIZE, TYPE, WIRE, INSUL, APPL INSTRUCTIONS

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION TABLE with columns: TERMINAL NAME, WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLIED

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING TABLE

- RECOMMENDED SPARE PARTS, GREASE BEARING SURFACES LIGHTLY, LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET...

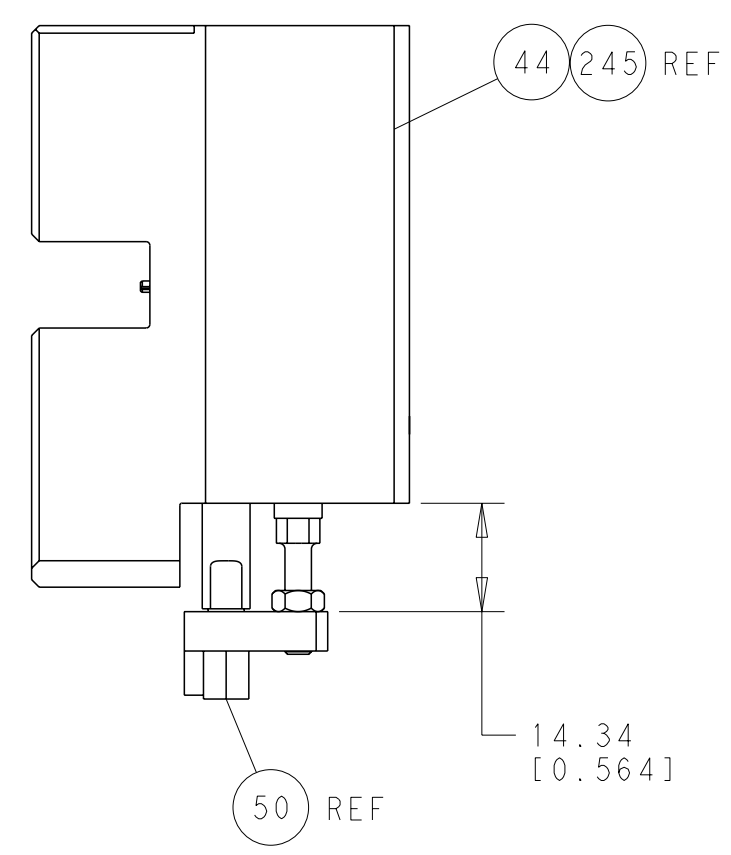
\*WARNING ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

Table with columns: PART NO, DESCRIPTION, ITEM NO, listing various spacers and shims.

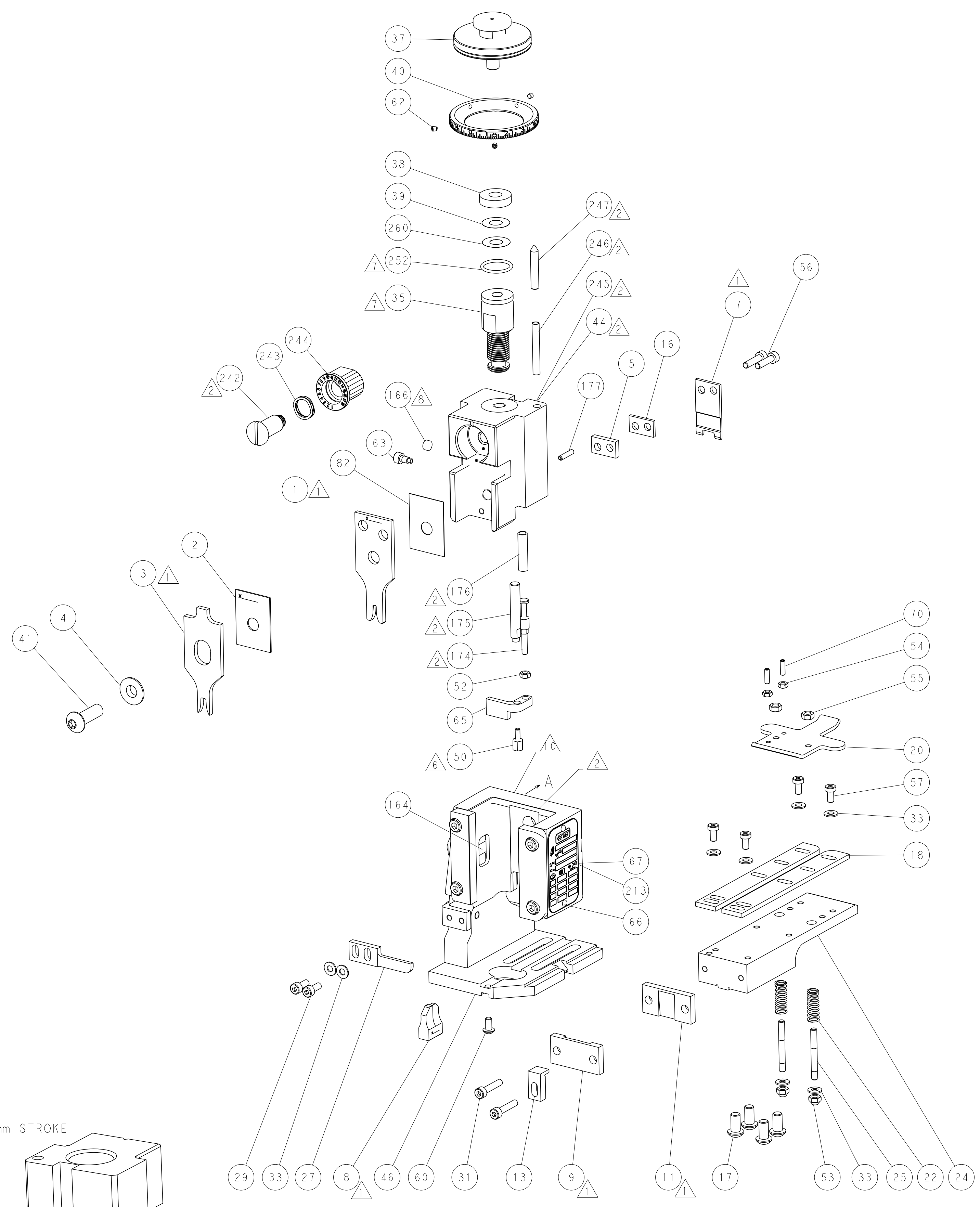
ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4)

Large parts list table with columns: QTY, PART NO, DESCRIPTION, ITEM NO, listing various mechanical components like springs, washers, and nuts.

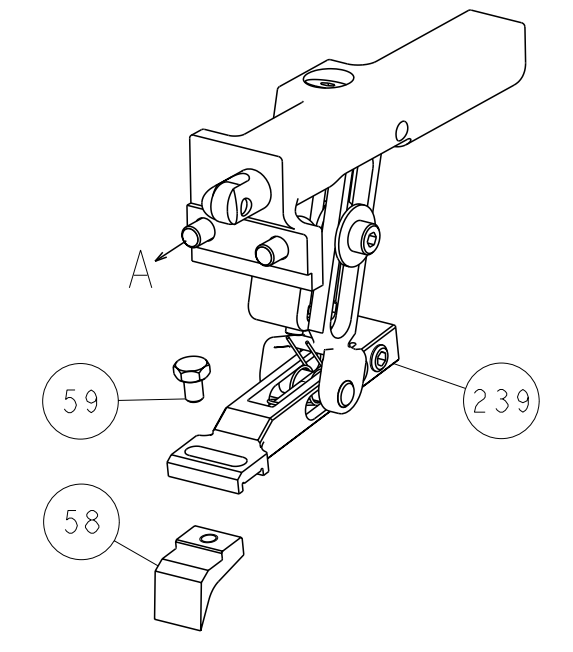
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			



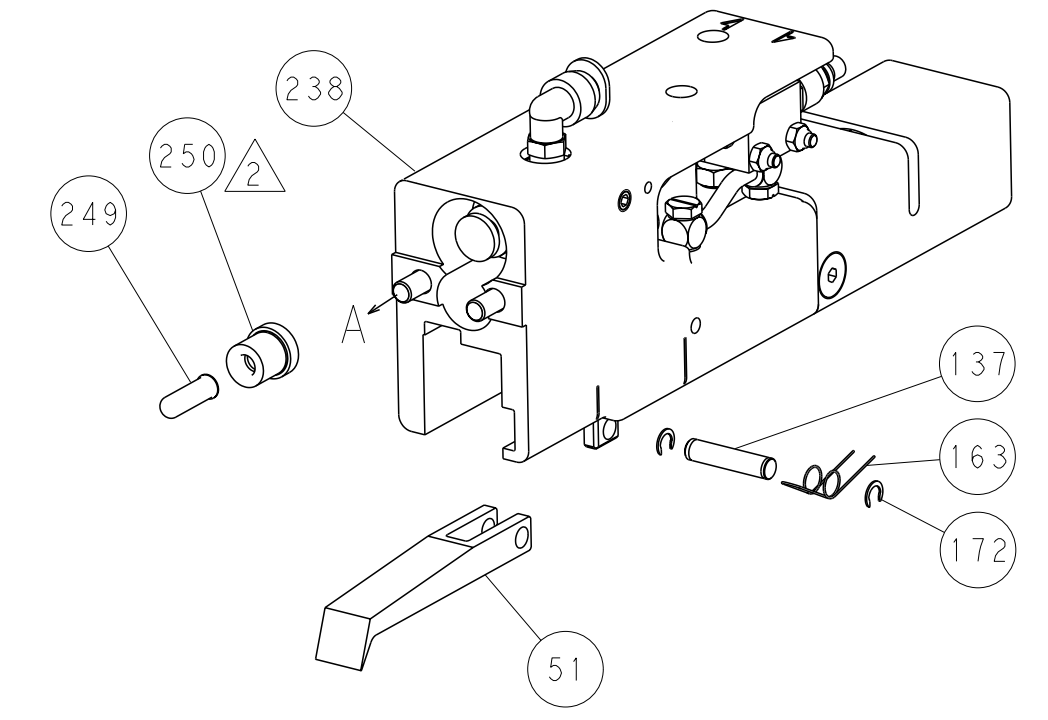
HOLDDOWN SET-UP



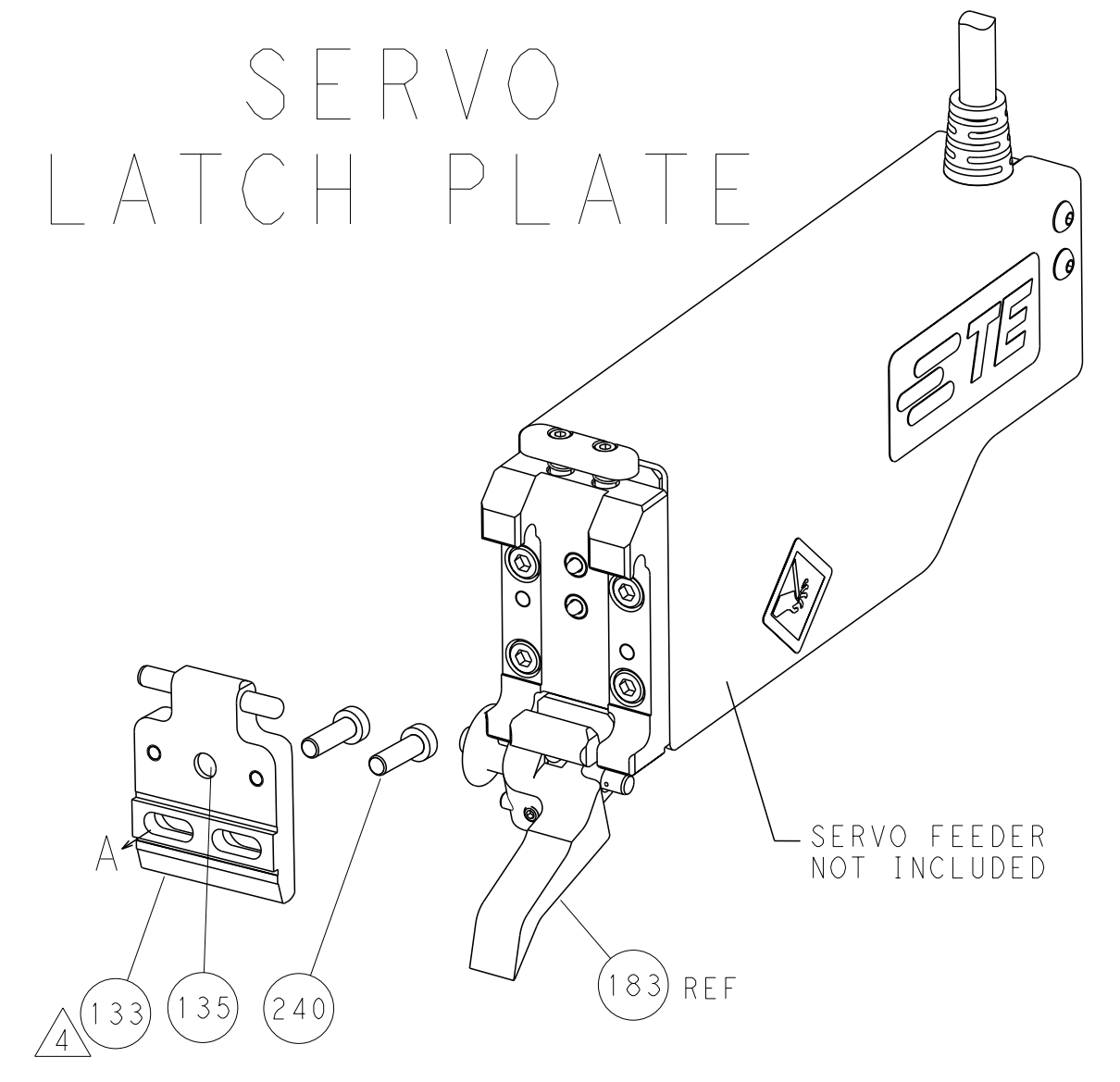
FEED TYPE  
MECHANICAL



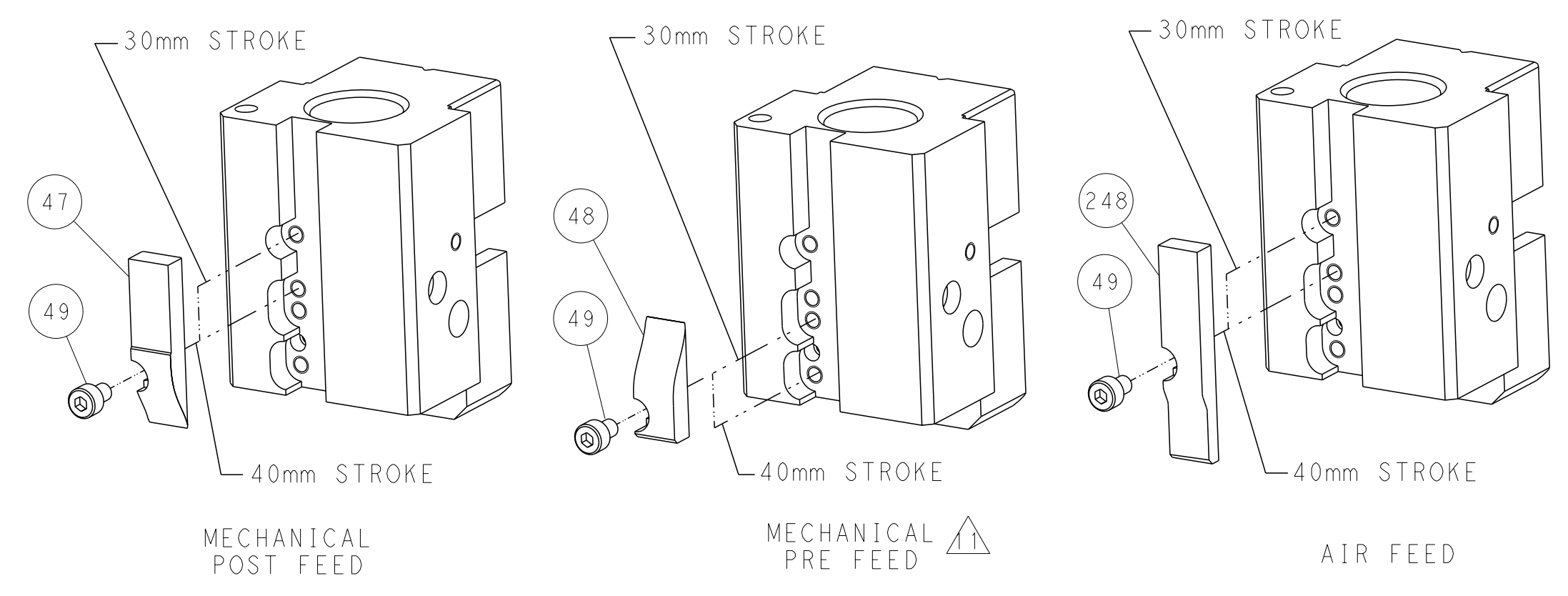
PNEUMATIC



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)

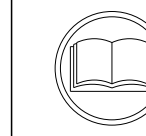
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ±0.5 1 PLC ±0.13 5 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		DWN C. CHEN 20DEC2011 CHK S. XI 20DEC2011 APVD J. CRUZ 20DEC2011		NAME Ocean End Feed Applicator	
MATERIAL:		FINISH:		PRODUCT SPEC:		APPLICATION SPEC:	
WEIGHT:		SCALE: 1:1		SIZE: CAGE CODE: DRAWING NO: A1 00779 C-2150010		RESTRICTED TO:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 2 OF 4		REV A1		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO		PART NUMBERS REQUIRED			
					PNEUMATIC FEED	SERVO LATCH PLATE	MECHANICAL FEED	SERVO LATCH PLATE	SMART APPLICATOR	MECHANICAL FEED
	2-2150010-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	2119950-1	2119792-1	-	2119641-2	-	2063440-1
	2-2150010-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	2119951-1	1901697-1	8-2150010-5	-	-	2168400-7 (QUANTITY 2)
					2161326-1	-	8-2150010-4	-	-	-
					2119949-1	2063961-1	5-18022-5	2119653-2	-	-
2-2150010-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150010-5	-	-	2168400-7 (QUANTITY 2)	
				2161326-1	-	8-2150010-4	-	-	-	
2-2150010-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150010-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.06 mm [.160]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME:	.140 DIA SHUR PLUG RECEPTACLE
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.80-4.60 mm [.150-.181 IN]	2.30-3.30 mm [.091-.130 IN]
TERMINAL APPLICATION SPECIFICATION	TE_SPEC_1
TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL
626399-1	626399-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.55+/-0.05 [.061+/-0.002]	9.2
18 AWG	1.40+/-0.05 [.055+/-0.002]	10.6
20 AWG	1.29+/-0.05 [.051+/-0.002]	11.6



- 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: 8-2150010-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150010-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150010-5
- 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 50.
- 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.

**\*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 1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- - - 1 -	2119640-1	PUSH ROD, AIR FEED	250
- - - 1 -	2079988-1	BUSHING, LCH5-12, MISMUMI	249
- 1 1 1 1 1	1-22279-3	SPRING, COMPRESSION	246
-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO

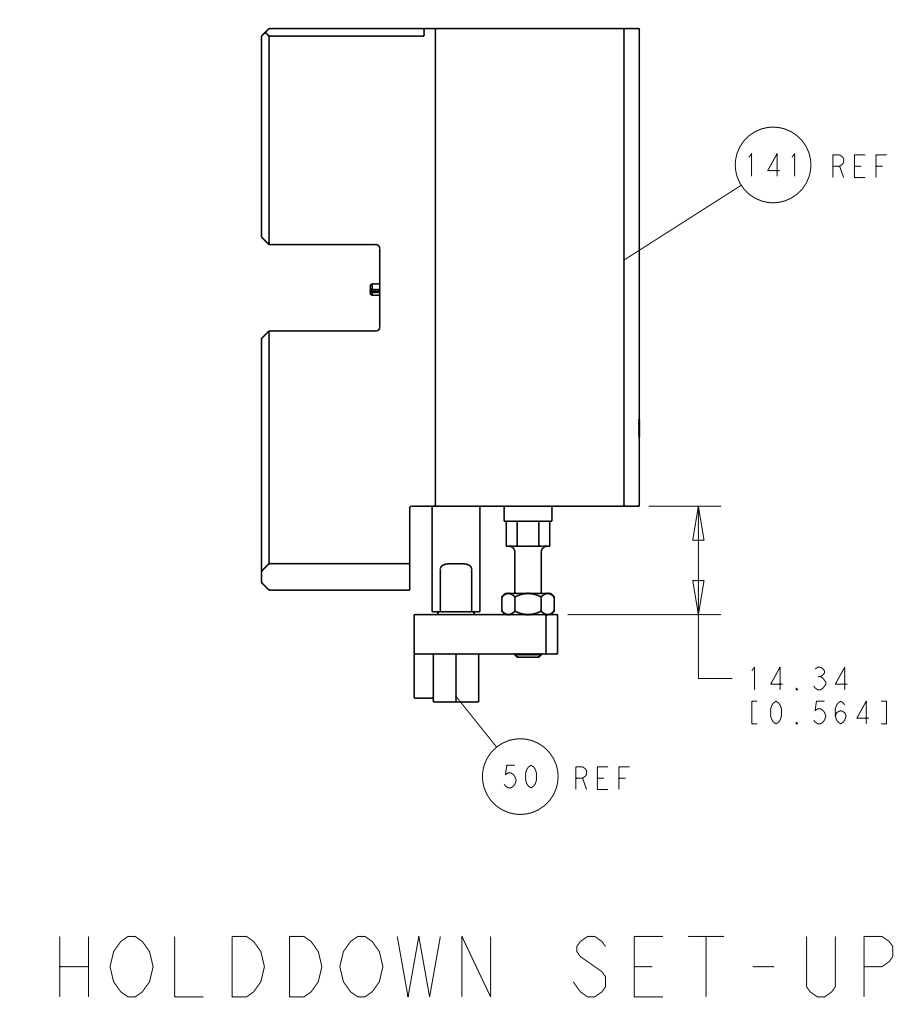
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPD
-	-	-	SEE SHEET 1	-	-	-

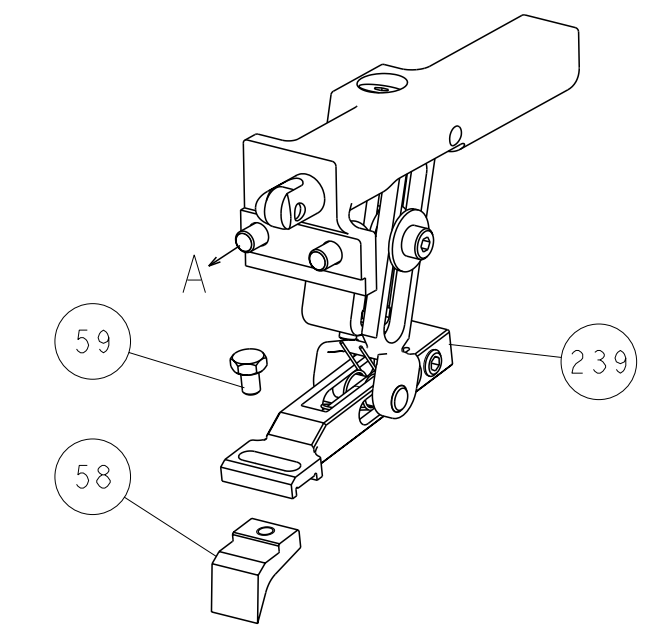
- 1 1 1 1 1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
- 1 1 1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
- - 2 - -	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
- - - - 1	2119580-1	MECHANICAL FEED ASSEMBLY	239
- - - 1 -	2063440-1	AIR FEED MODULE	238
- - 1 - -	2119740-2	TAG, IDENTIFICATION	213
- 4 4 4 4 4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
- - REF - -	1901697-1	FEED FINGER ASSEMBLY, EF	183
- 1 1 1 1 1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
- 1 1 1 1 1	8-22280-7	SPRING, COMPRESSION	176
- 1 1 1 1 1	1752353-2	GUIDE PIN, HOLDDOWN	175
- 1 1 1 1 1	1901680-2	GUIDE PIN, HOLDDOWN	174
- - - 2 -	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
- 1 1 1 1 1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
- REF REF REF REF REF	994970-2	COUNTER, MAGNETIC	164
- - - 1 -	240638-1	SPRING, FEED FINGER	163
- 1 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 1	2119798-2	DETENT PIN	145
- 1 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 1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
- 1 1 1 1 1	2119651-1	RAM, ASIAN STYLE, END FEED	140
- 1 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 1	455888-3	SPACER, CRIMPER	82
- 1 1 1 1 1	2119956-2	DOCUMENTATION PACKAGE	71
- 2 2 2 2 2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
- 1 - 1 1 1	2119740-1	TAG, IDENTIFICATION	67
- 2 2 2 2 2	2168078-1	SCREW, DRIVE, RH, RoHS	66
- 1 1 1 1 1	1901681-1	HOLDDOWN, TERMINAL	65
- 1 1 1 1 1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
- 3 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
- 4 4 4 4 4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
- 2 2 2 2 2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
- 2 2 2 2 2	5018030-2	NUT, HEX, REG, RoHS, M4	55
- 2 2 2 2 2	5018030-1	NUT, HEX, REG, RoHS, M3	54
- 2 2 2 2 2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
- 1 1 1 1 1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
- - - 1 -	2119792-1	PAWL, EF, AIR	51
- 1 1 1 1 1	1-1752354-0	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 1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
- 1 1 1 1 1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
- 1 1 1 1 1	2119957-1	APPLICATOR SHIM PACK	39
- 1 1 1 1 1	2119644-2	RAM WASHER, PRECISION	38
- 8 8 8 8 8	1-18028-2	WASHER, FLAT, REG M4	33
- 2 2 2 2 2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
- 2 2 2 2 2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
- 1 1 1 1 1	240639-1	STRIPPER (MACHINING)	27
- 2 2 2 2 2	1320906-1	STUD, THREADED	25
- 1 1 1 1 1	1752371-5	PLATE, STRIP GUIDE	24
- 2 2 2 2 2	4-22281-1	SPRING, COMPRESSION	22
- 1 1 1 1 1	1752373-1	DRAG	20
- 2 2 2 2 2	1901259-6	GUIDE, LOWER STRIP	18
- 1 1 1 1 1	1-240641-3	SPACER	16
- 1 1 1 1 1	1752360-1	SPACER, HOLD-DOWN	13
- 1 1 1 1 1	240644-1	PLATE, REAR SHEAR	11
- - - - -	-	-	10
- 1 1 1 1 1	690482-7	PLATE, FRONT SHEAR	9
1 1 1 1 1 1	1803001-2	ANVIL, COMBINATION, END FEED	8
- 1 1 1 1 1	240651-2	BLADE, SLUG	7
- 1 1 1 1 1	4-240641-6	SPACER	5
- 1 1 1 1 1	238009-1	BLOCK, FL CRIMPER SPACER	4
1 1 1 1 1 1	3-2119582-4	CRIMPER, INSULATION F PREMIUM	3
- 1 1 1 1 1	455888-7	SPACER, CRIMPER	2
1 1 1 1 1 1	2-456406-3	CRIMPER, WIRE PREMIUM	1
-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ±0.5 1 PLC ±0.13 5 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH	
MATERIAL:	:	WEIGHT:	:
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:1 SHEET 3 OF 4 REV A1	

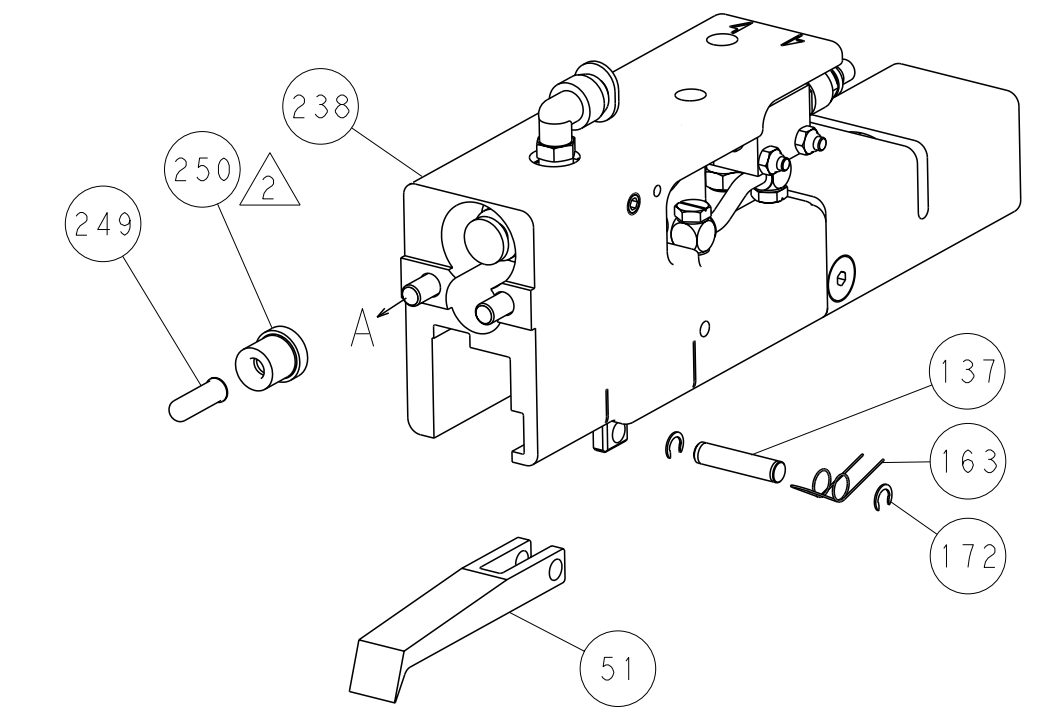
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			



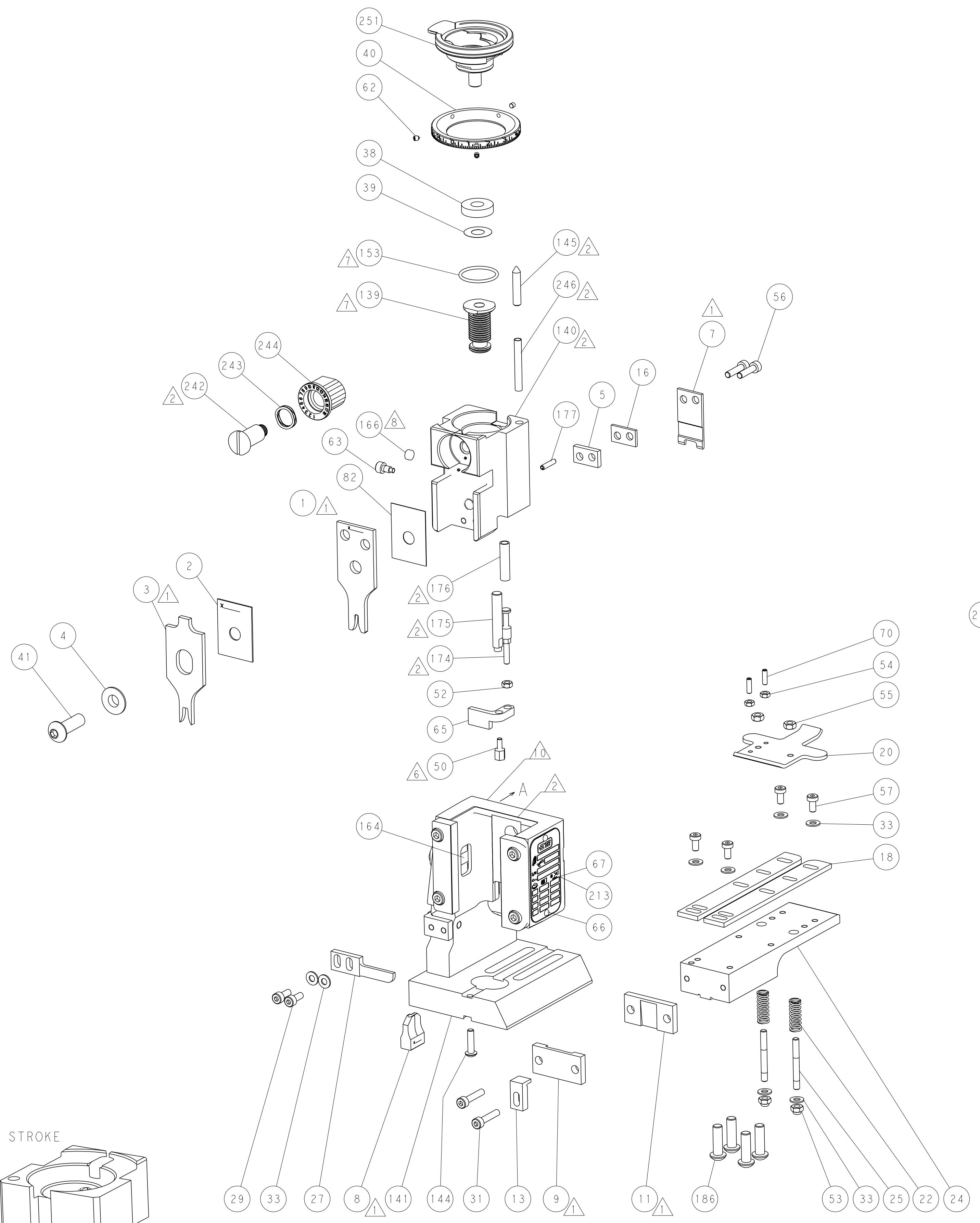
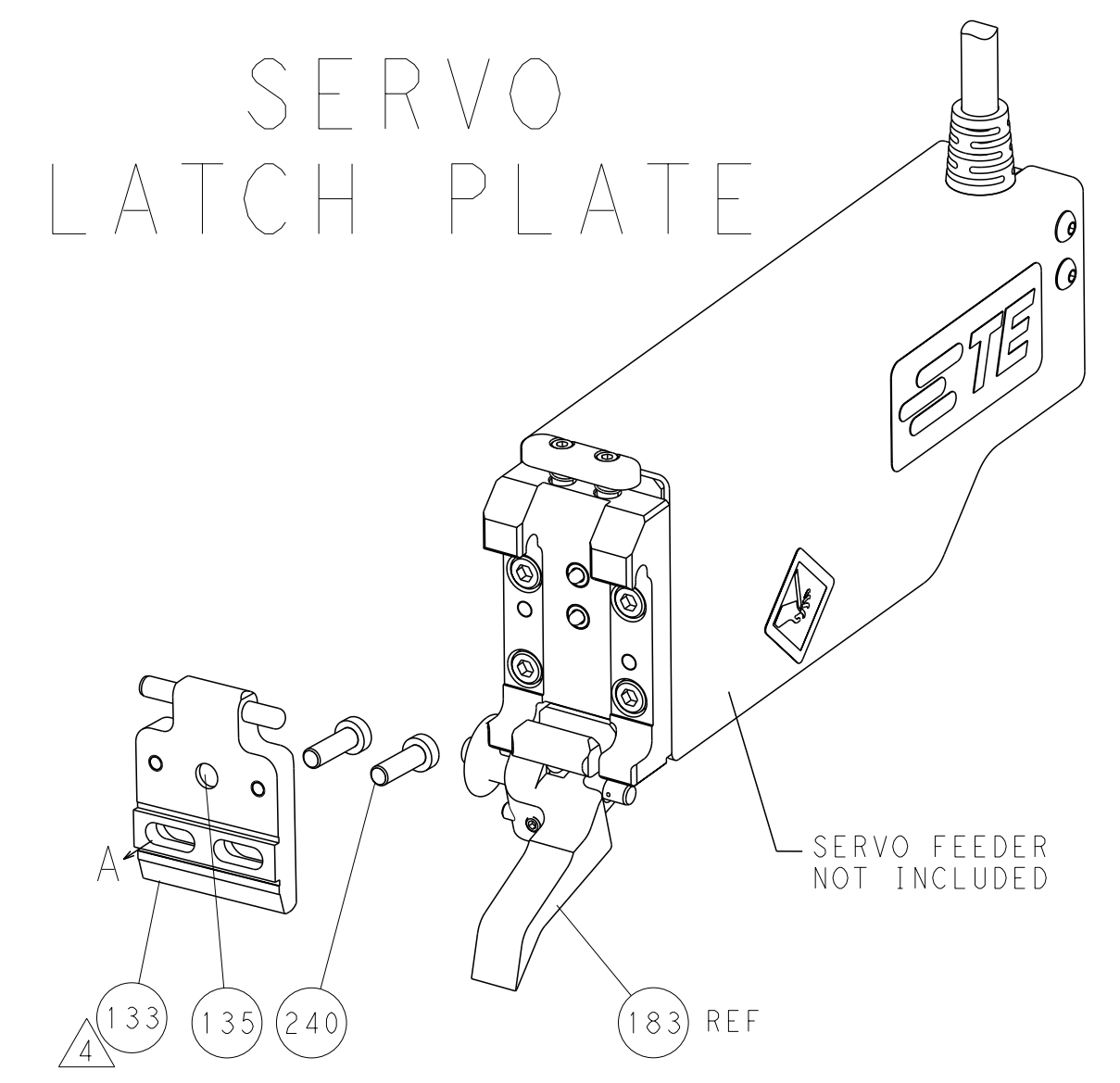
FEED TYPE  
MECHANICAL



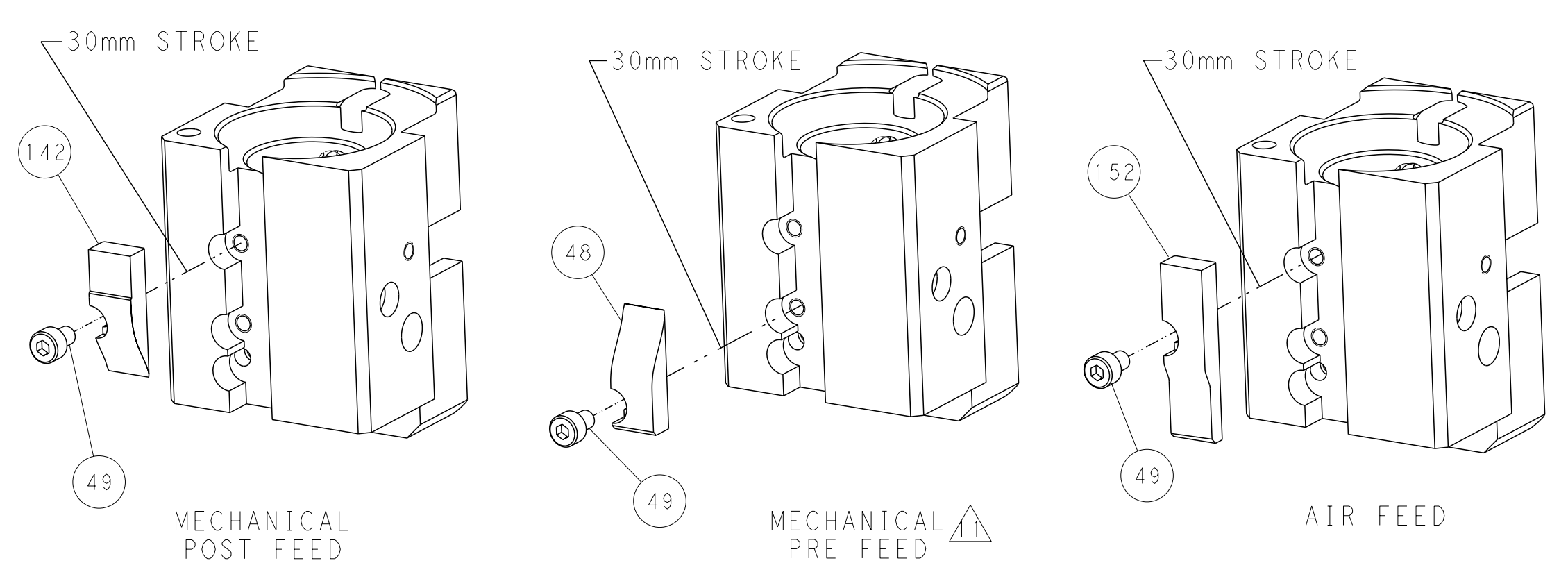
PNEUMATIC



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2011 TYCO ELECTRONICS CORPORATION. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2011 TYCO ELECTRONICS CORPORATION. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2011 TYCO ELECTRONICS CORPORATION.</small>		DWN: C. CHEN CHK: S. XI APVD: J. CRUZ	Z0DEC2011 Z0DEC2011 Z0DEC2011	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150010	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ±.5 1 PLC ±0.13 5 PLC ±0.13 4 PLC ±0.001 ANGLES ±.1 FINISH:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE: 1:1 SHEET: 4 OF 4 REV: A1	RESTRICTED TO:		