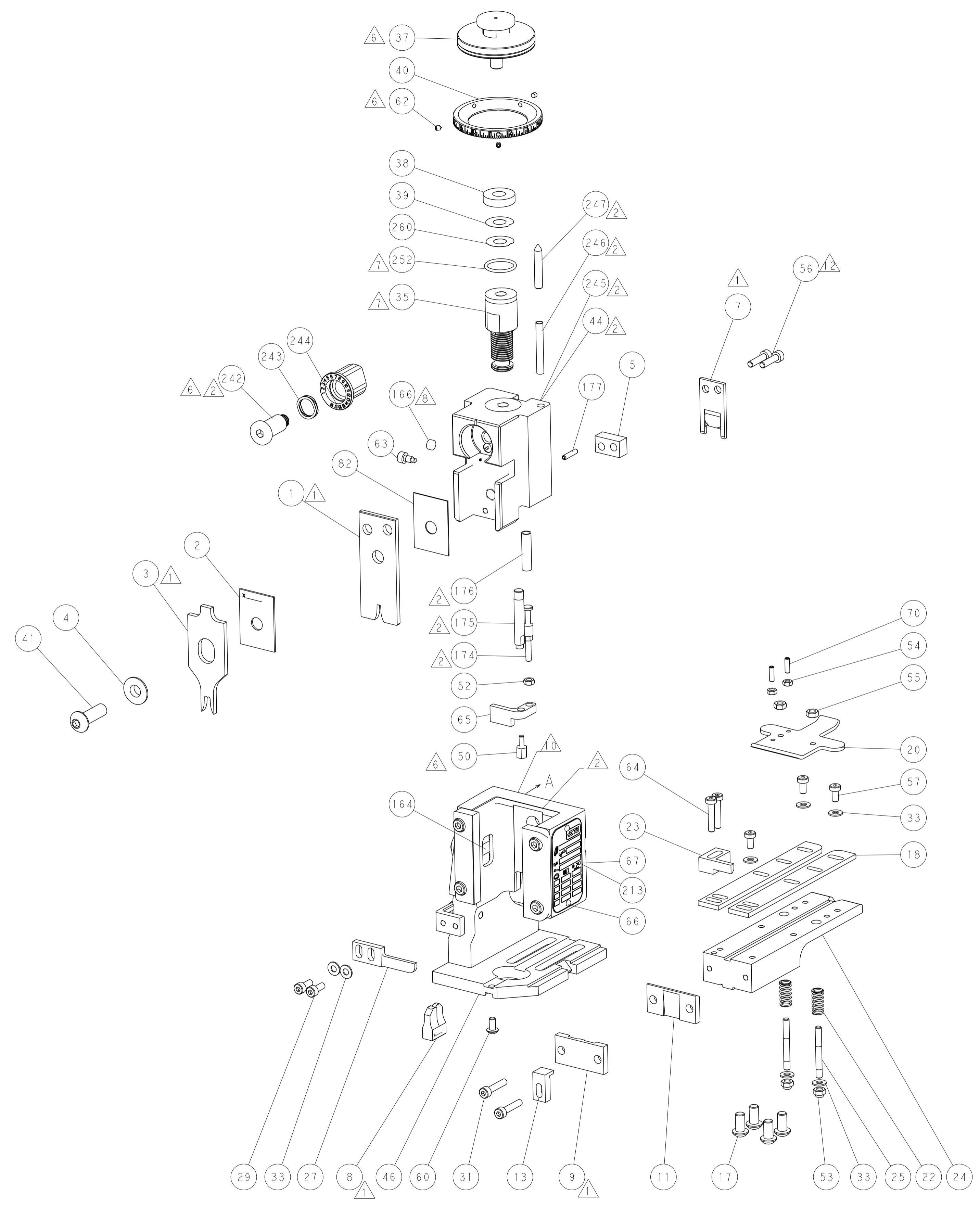
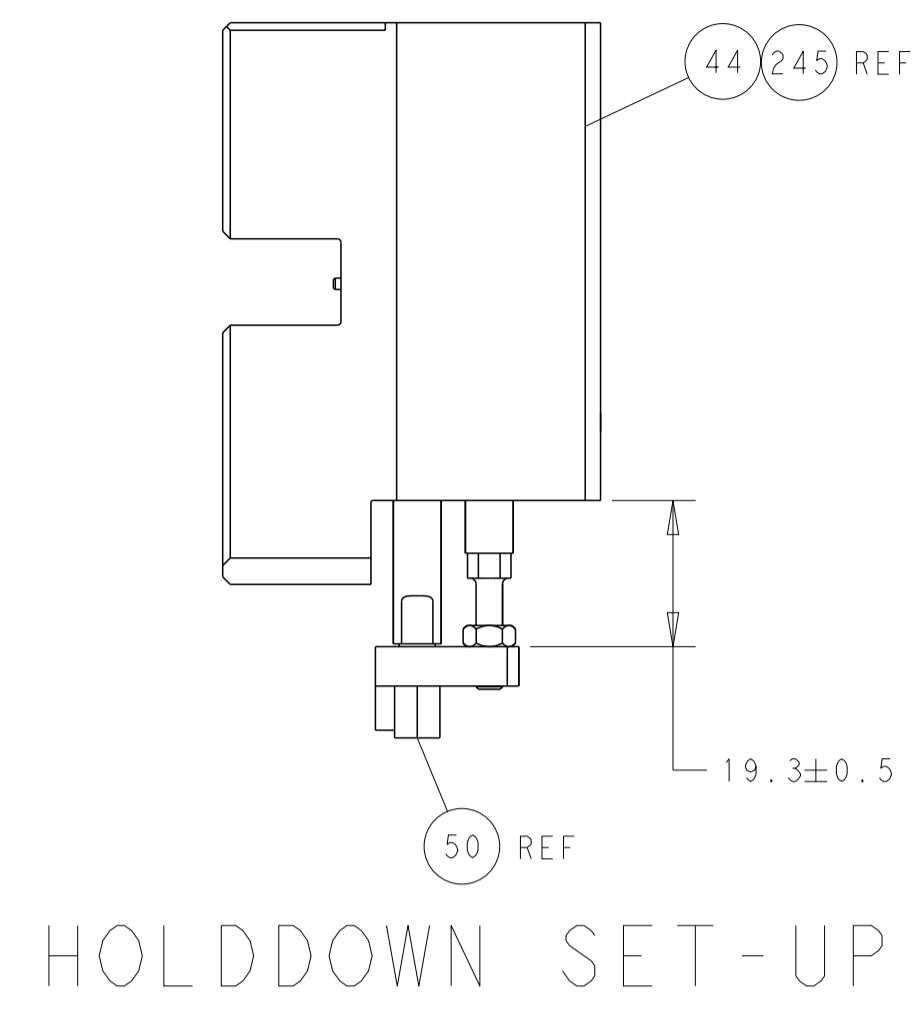
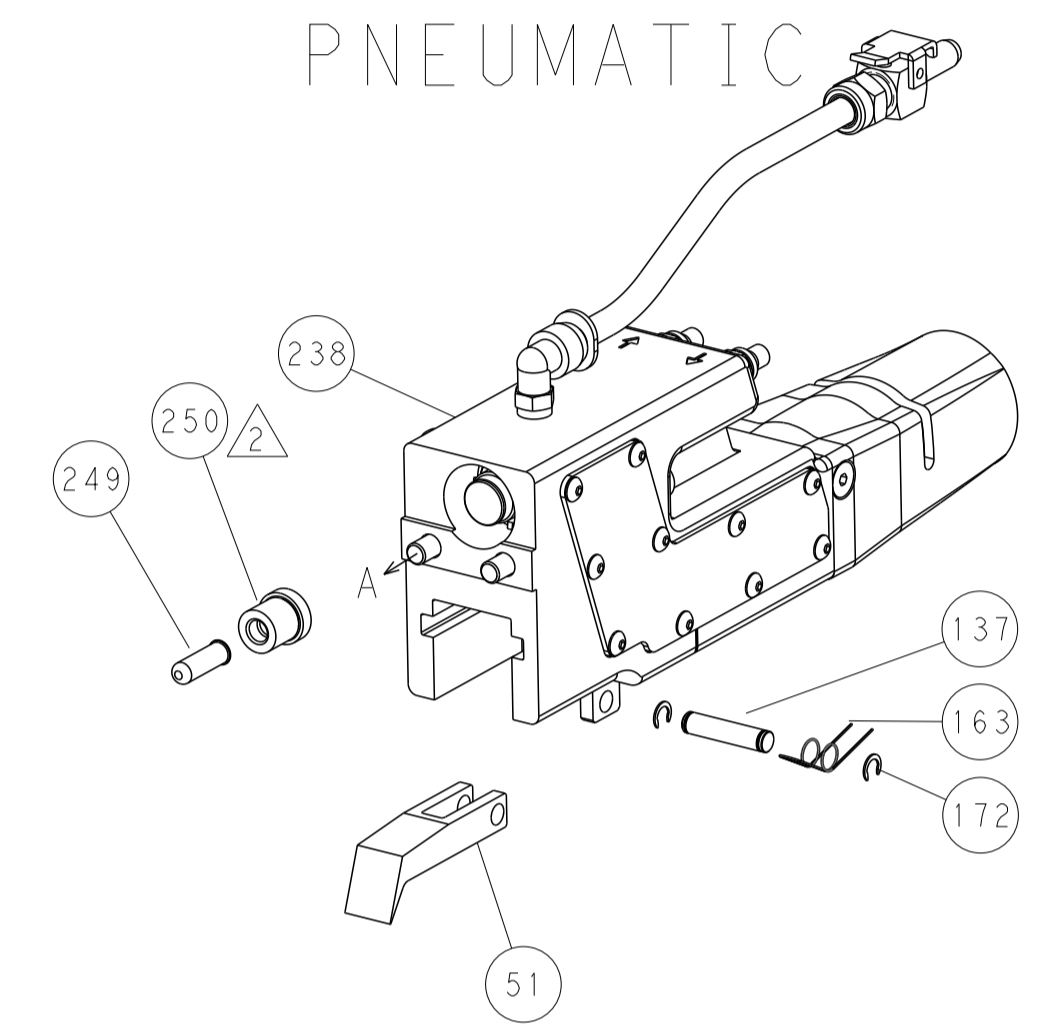


LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

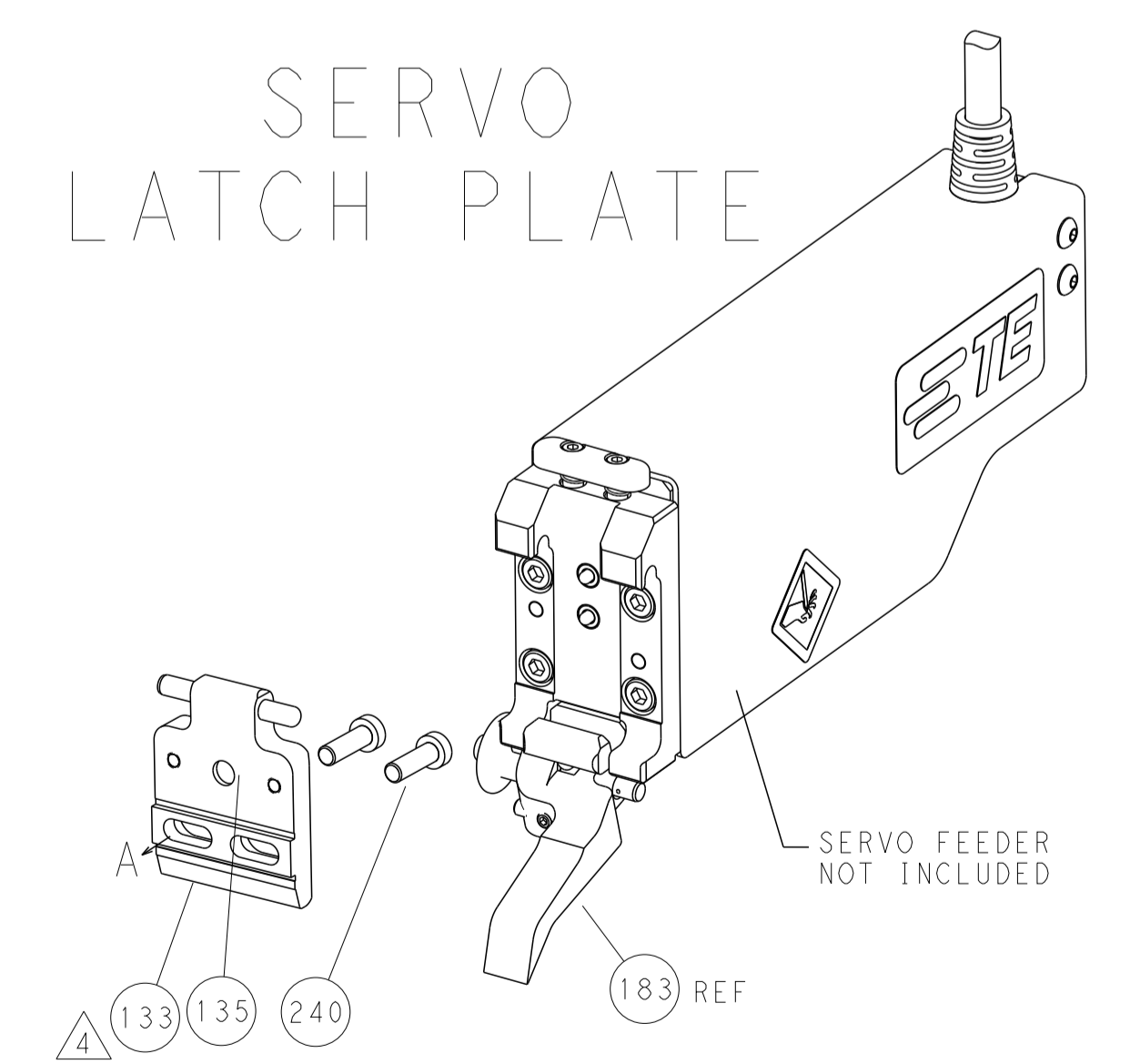


FEED TYPE

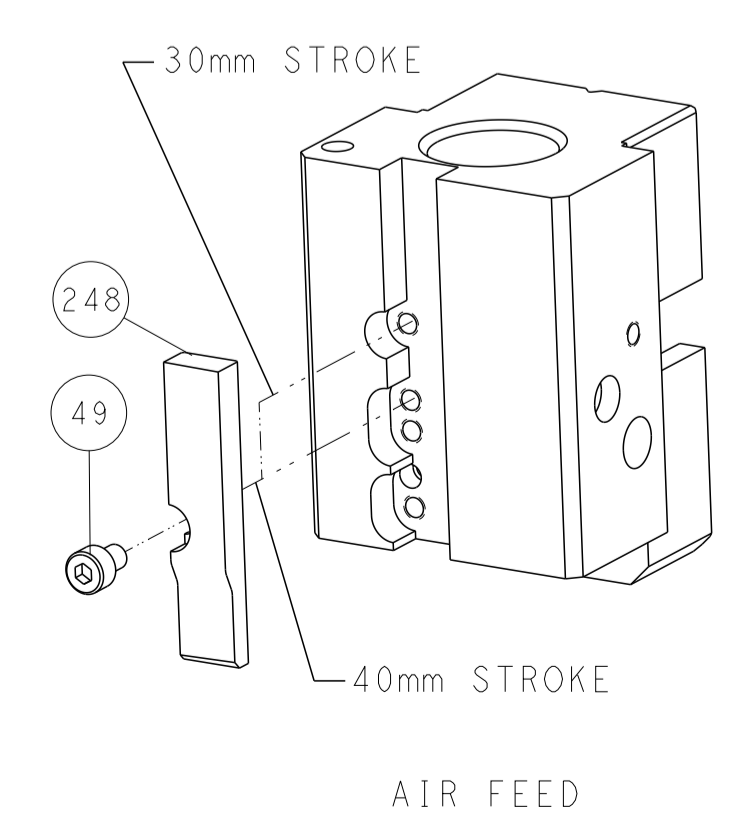
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN X.ZHAO 02FEB2012 CHK T.ELBIN 02FEB2012 APVD S.XI 02FEB2012 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150057 SHEET 2 OF 4 REV B	
MATERIAL:				RESTRICTED TO:			

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150057-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150057-5	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150057-4	-	-
	2-2150057-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-
2-2150057-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150057-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.10]	F
INSUL	4.57 mm [1.80]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: "250" SERIES POSITIVE LOCK-EX RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-6.50 mm [1.217-.256 IN]		∅2.20-3.40 mm [1.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5119	(B)114-5146	-
	(C)114-5195	-	-
TERMINALS APPLIED ¹⁰			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 175022-1	(A) 2-175022-1	(B) 175164-1	(C) 179974-1
(C) 179974-6			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
2.00mm2	1.82+/-0.05 [1.072+/-0.002]	5.9
(2)0.75mm2	1.82+/-0.05 [1.072+/-0.002]	5.9
1.25mm2	1.62+/-0.05 [1.064+/-0.002]	7.9
(2)0.5mm2	1.55+/-0.05 [1.061+/-0.002]	8.6
0.75mm2	1.50+/-0.05 [1.059+/-0.002]	9.1

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150057-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150057-5
- 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 ITEMS 50 AND 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

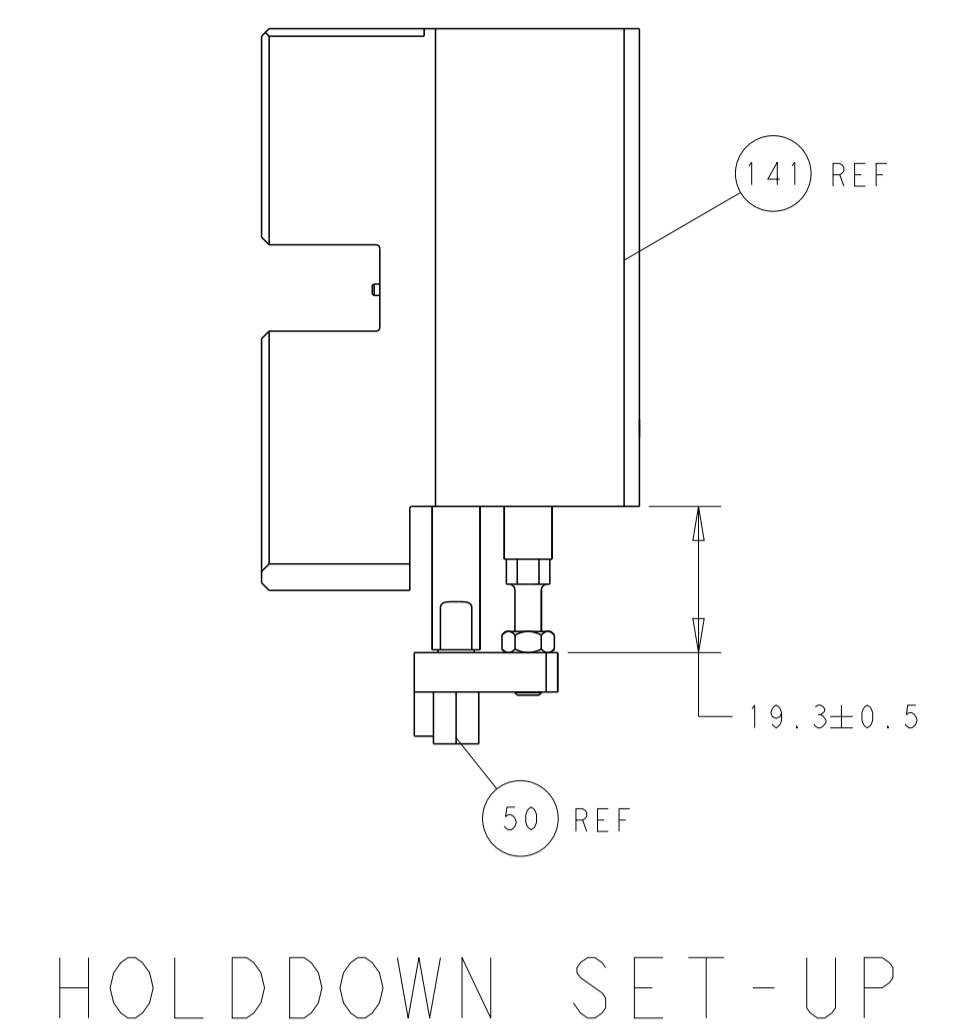
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE		251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED		250
-	-	-	1	1803259-1	BUSHING, FLANGED		249
-	1	1	1	1-22279-3	SPRING, COMPRESSION		246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	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	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	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	455888-5	SPACER, CRIMPER		82
-	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	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	1	1	1	1901681-1	HOLDDOWN, TERMINAL		65
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20		64
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT		63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0		62
-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8		57
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		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
-	-	-	1	2119792-2	PAWL, EF, AIR		51
-	1	1	1	1-1752354-2	STANDOFF, HOLD-DOWN		50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	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
-	7	7	7	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	1-1752371-7	PLATE, STRIP GUIDE		24
-	1	1	1	240825-2	PLATE, STRIP HOLD DOWN		23
-	2	2	2	2-22281-3	SPRING, COMPRESSION		22
-	1	1	1	1752373-4	DRAG		20
-	2	2	2	1901259-6	GUIDE, LOWER STRIP		18
-	1	1	1	1752360-1	SPACER, HOLD-DOWN		13
-	1	1	1	240833-1	PLATE, REAR SHEAR		11
-	-	-	-	-	-		10
-	1	1	1	690482-4	PLATE, FRONT SHEAR		9
-	1	1	1	4-1333219-0	ANVIL, COMBINATION		8
-	1	1	1	1-2217206-0	BLADE, SLUG		7
-	1	1	1	7-240641-2	SPACER		5
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER		4
-	1	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM		3
-	1	1	1	1-455888-0	SPACER, CRIMPER		2
-	1	1	1	1-456422-5	CRIMPER, WIRE PREMIUM		1

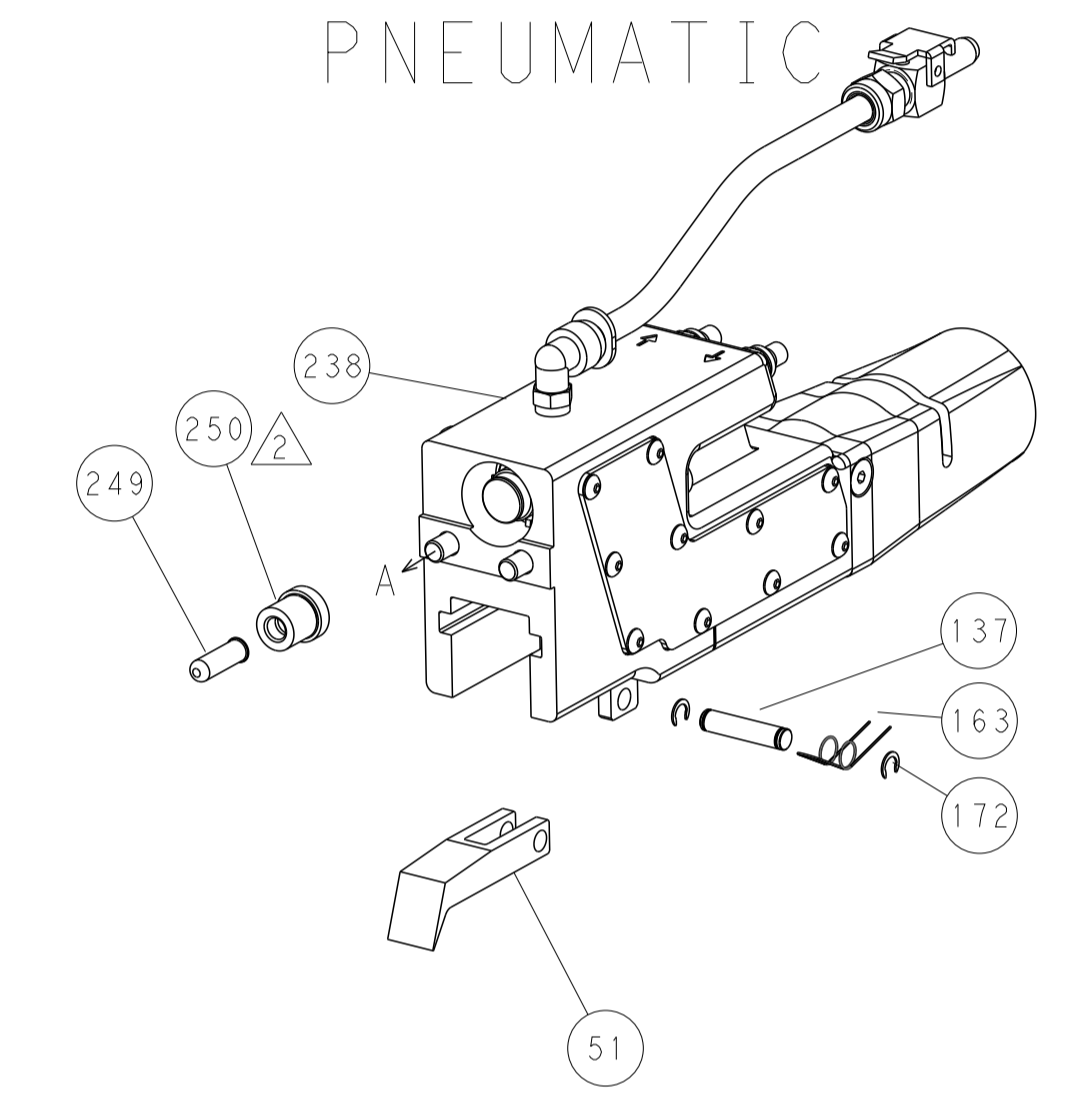
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	-	-	Customer Accessible Production Drawing	SCALE 1:1 SHEET 3 OF 4 REV B

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

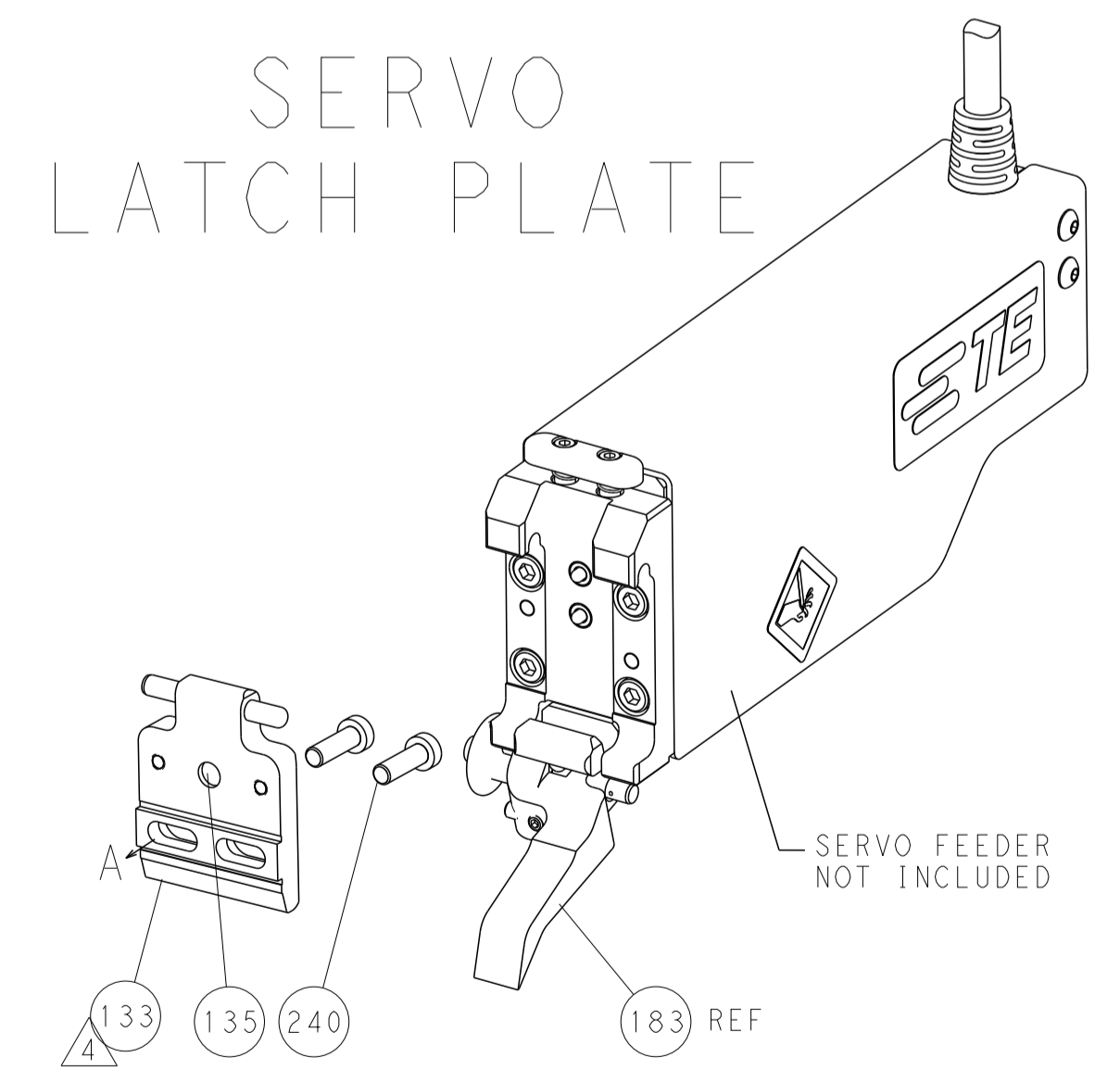


FEED TYPE

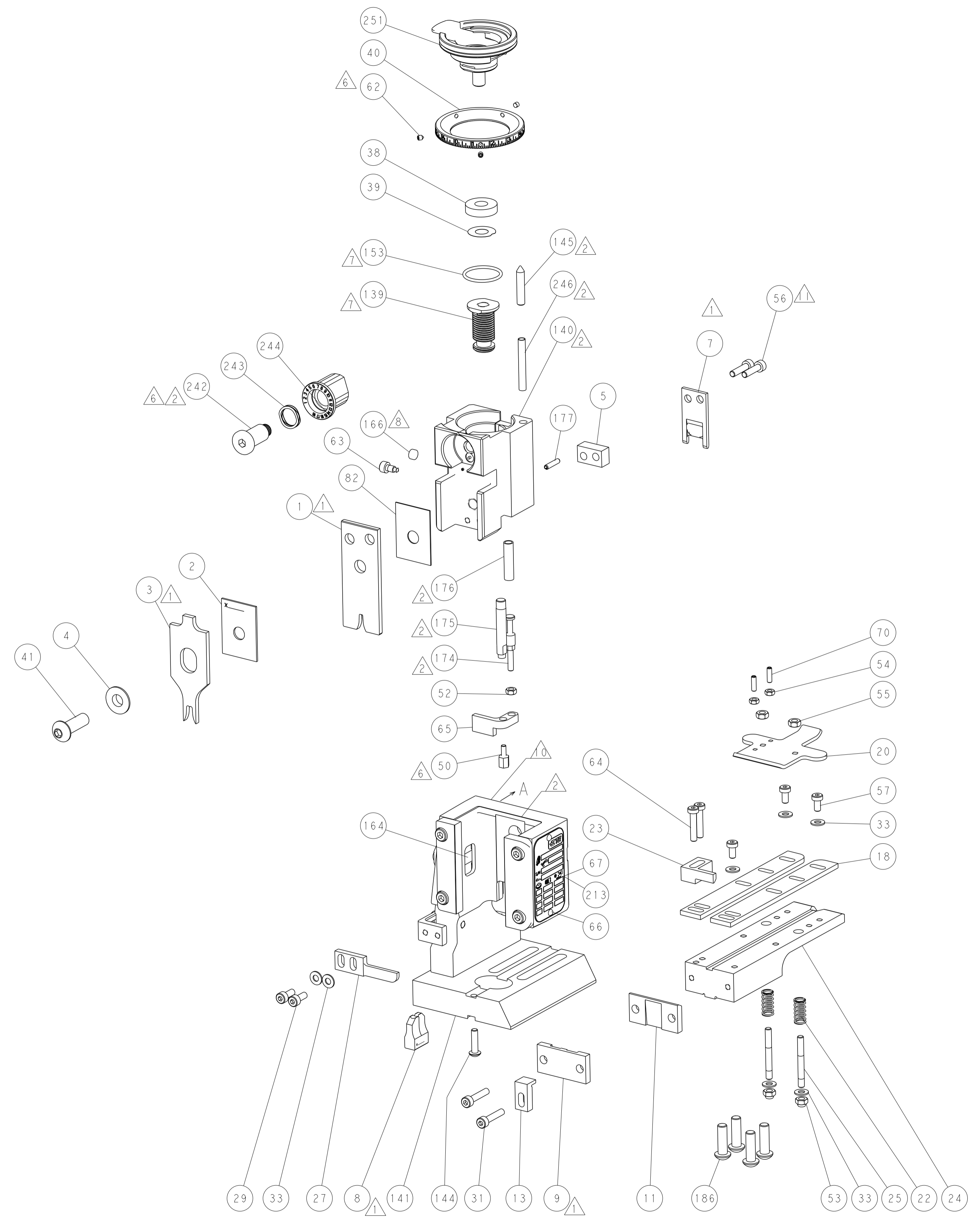
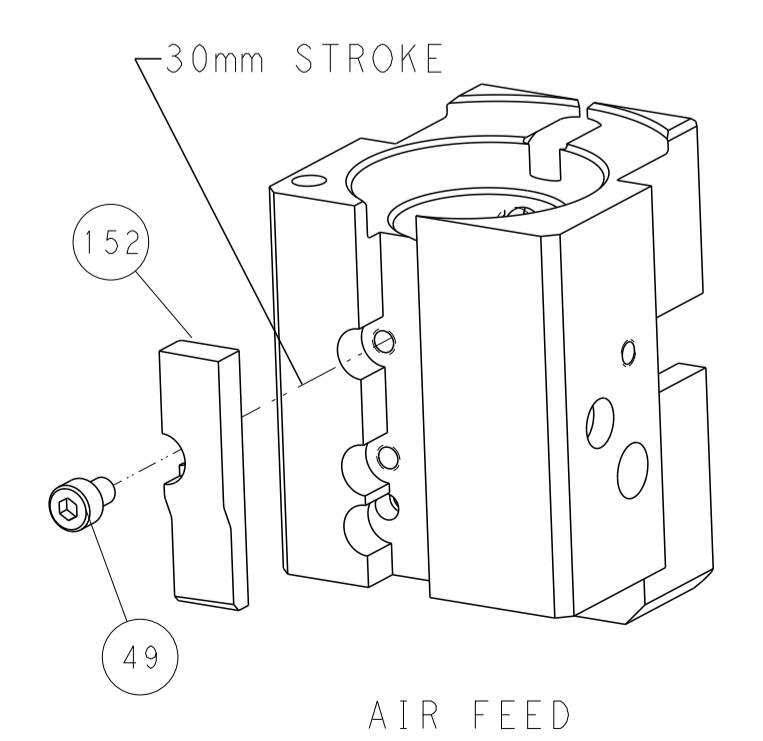
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150057 RESTRICTED TO SHEET 4 OF 4 REV B
MATERIAL:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION