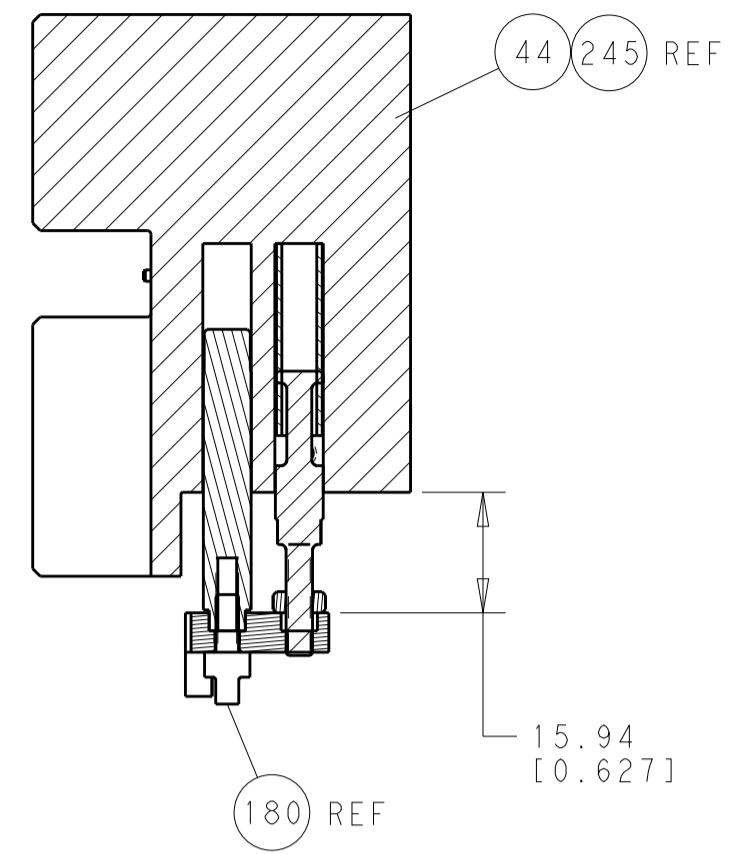
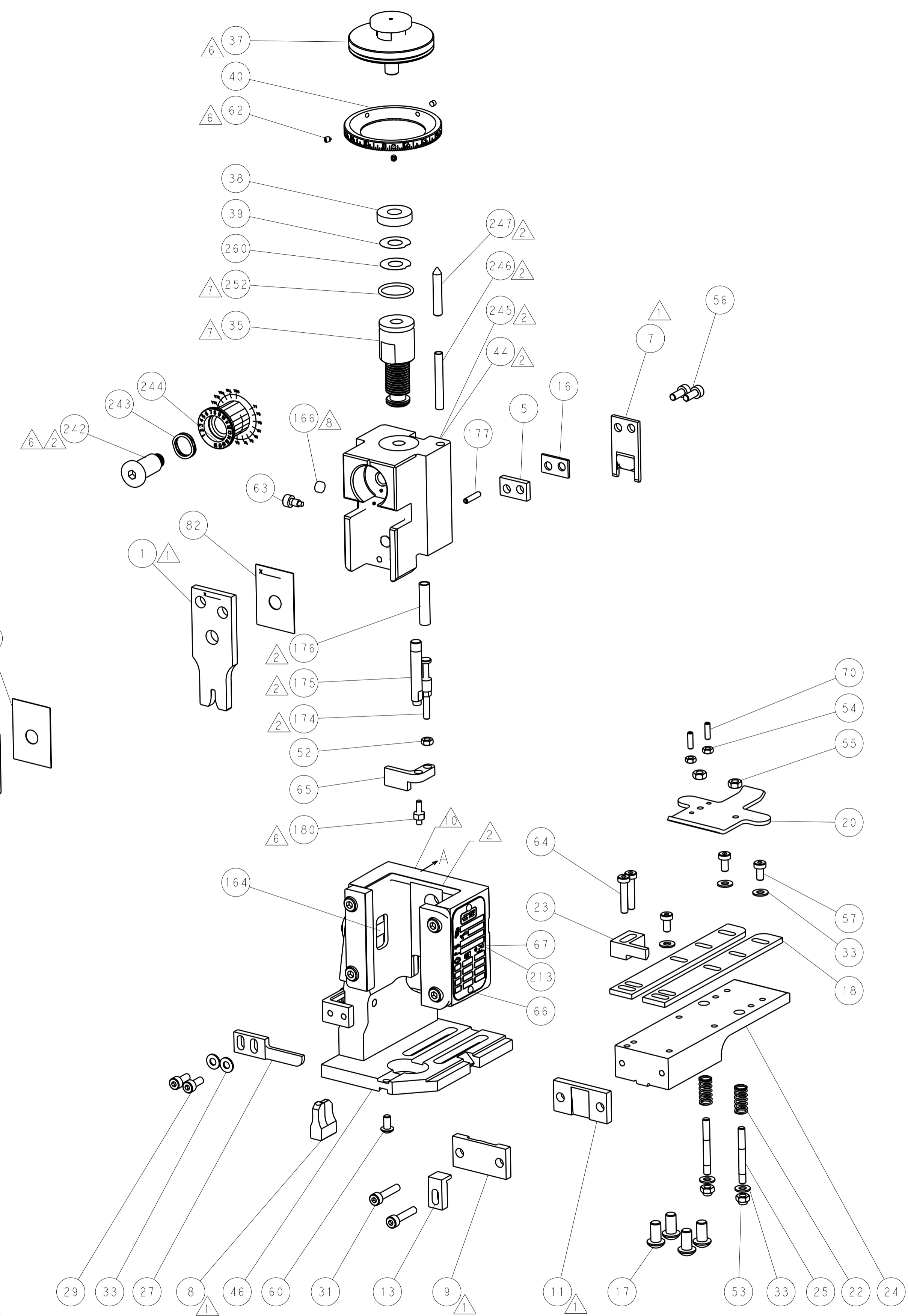


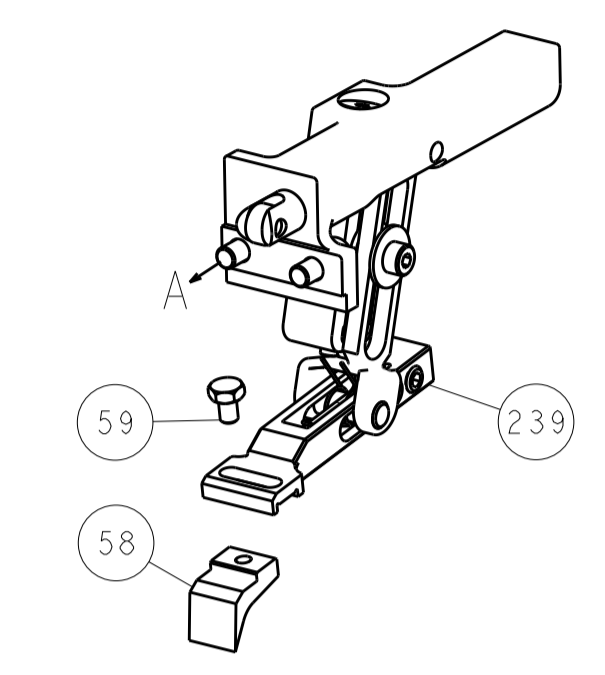
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A	66				
		REVISIONS			
		DESCRIPTION	DATE	BY	APPV
		SEE SHEET 1			



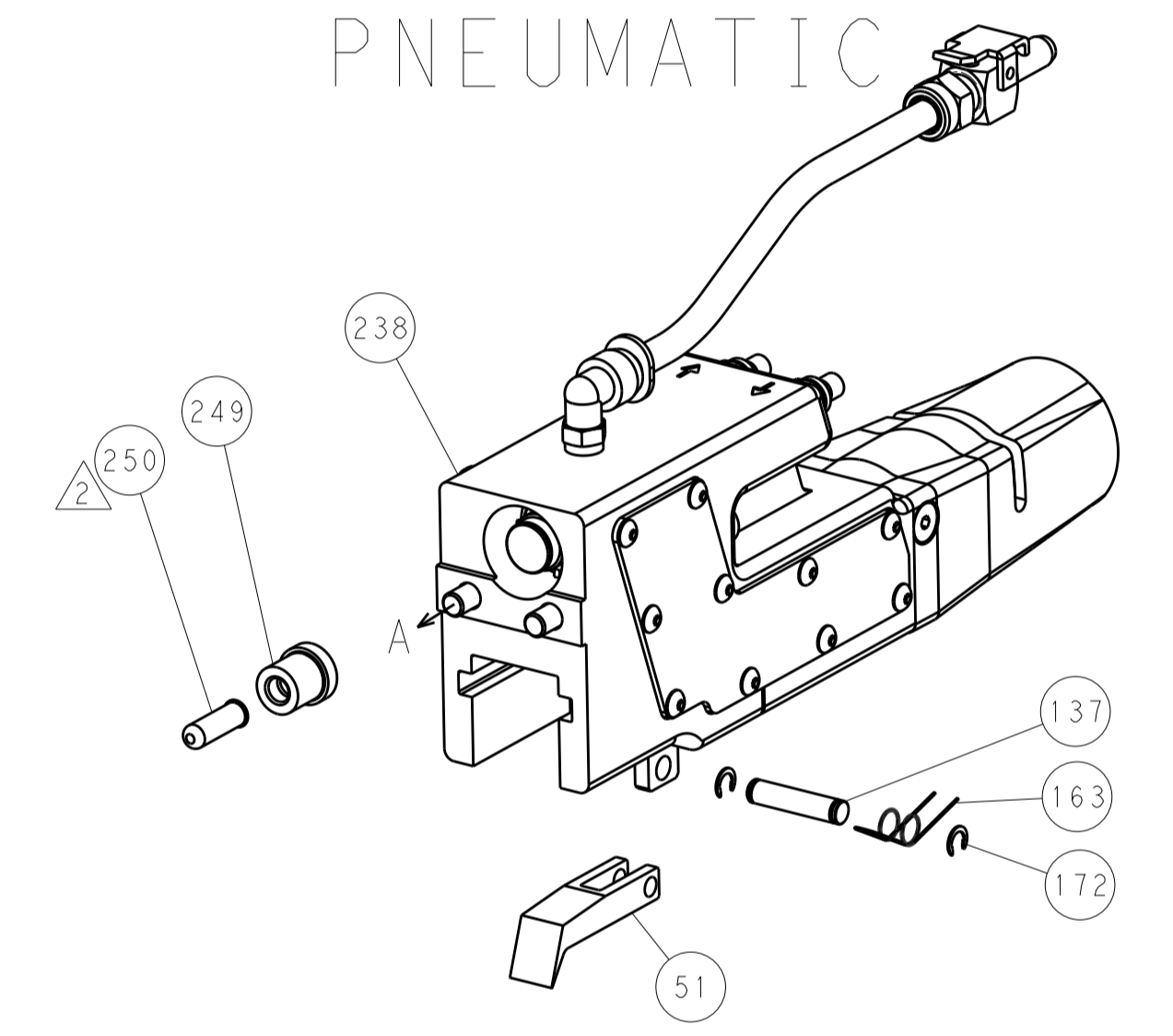
HOLDDOWN SET-UP



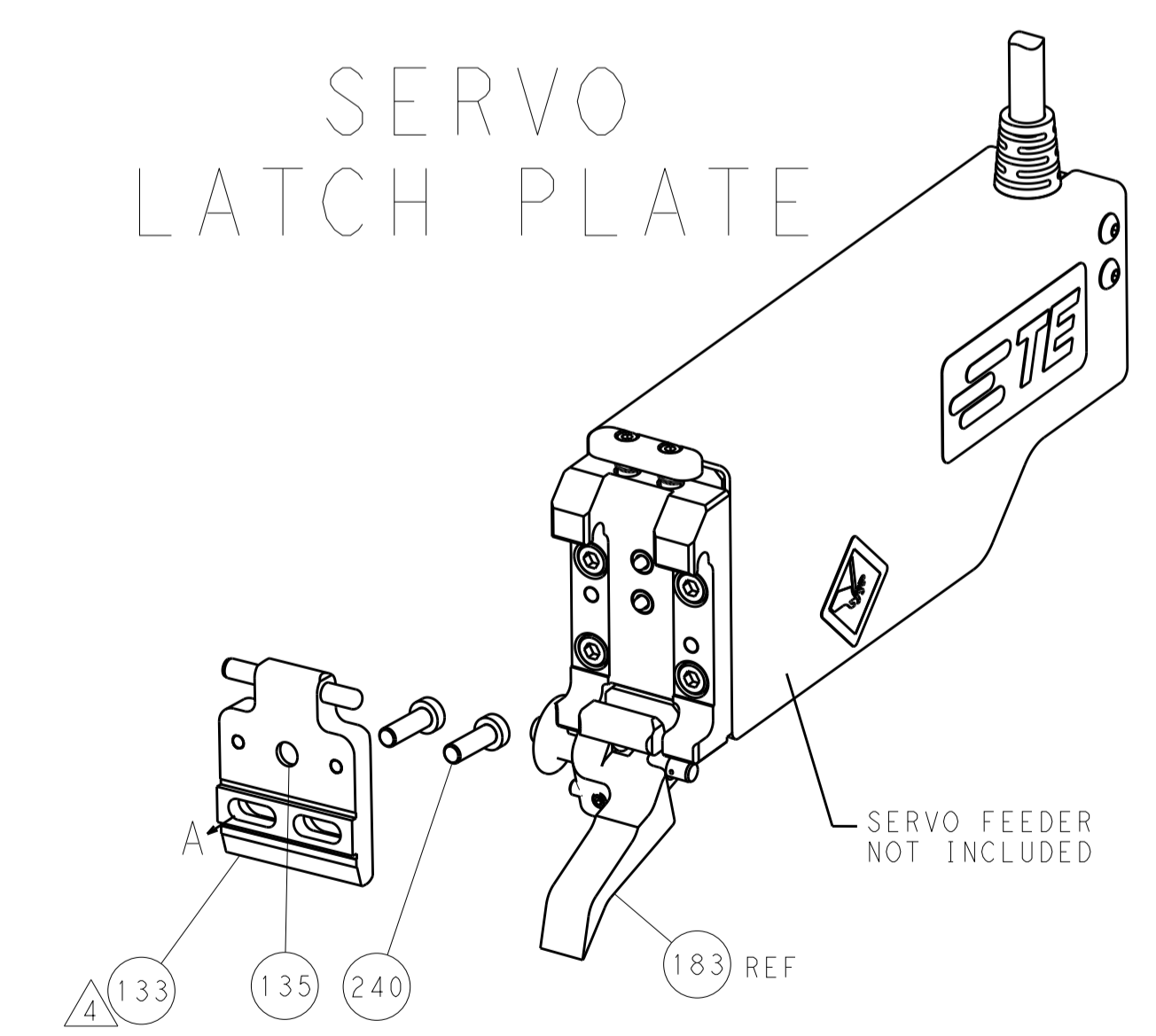
FEED TYPE
MECHANICAL



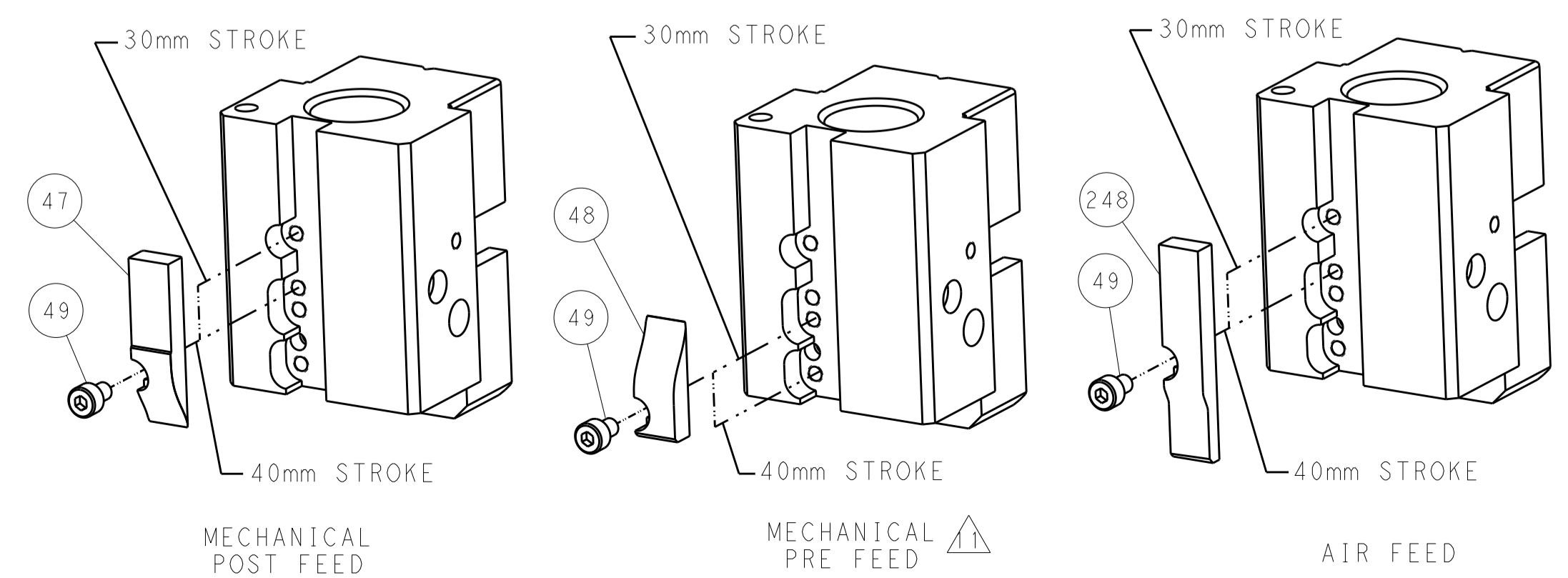
PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 09JAN2015		TE Connectivity	
mm		0 PLC ±0.5		CHK: G. BAILEY 09JAN2015		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APPV: H. GUO 09JAN2015		NAME: Ocean End Feed Applicator	
H		3 PLC ±0.013		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
A		4 PLC ±0.001		APPLICATION SPEC		RESTRICTED TO	
ANGLES		±0.001		WEIGHT		A1 00779 ©=2150521	
FINISH		-		SCALE: 1:1		SHEET 2 OF 4 REV A	
MATERIAL		-		Customer Accessible Production Drawing		Customer Accessible Production Drawing	

APPLICATOR STYLE CONVERSION CHART

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO		PART NUMBERS REQUIRED					
				MECHANICAL FEED	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150521-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150521-5	-	-	2168400-7 (QUANTITY 2)
	2-2150521-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SMART APPLICATOR	2161326-1	-	8-2150521-4	-	-	-
	2-2150521-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\triangle 4$	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150521-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
7-2150521-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.54 mm (.100)	F
INSUL	4.32 mm (.170)	F

APPL INSTRUCTIONS
408-10390

TERMINAL DATA: GMG TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: FASTON FEMMINA 6.3X0.8

WIRE STRIP LENGTH 5.54-6.30 mm (.218-.248 IN) INSULATION DIAMETER RANGE \varnothing 2.86-3.81 mm (1.113-1.50 IN)

TERMINAL APPLICATION SPECIFICATION NONE

TERMINALS APPLIED

TE TERMINAL	GMG TERMINAL	TE TERMINAL	GMG TERMINAL
2113642-1	30001.52.00.1	2113642-6	30001.21.00.1
2113642-2	30001.52.00.0	2113642-7	30001.30.00.1
2113642-3	30001.52.02.0	2113642-8	30001.30.02.1
2113642-4	30001.52.02.1	2113642-9	30001.40.01.1
2113642-5	30001.04.00.1		

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING $\triangle 9$

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.01 +/- 0.05 [0.079 +/- .002]	5.1
16 AWG	1.78 +/- 0.05 [0.070 +/- .002]	7.7
18 AWG	1.63 +/- 0.05 [0.064 +/- .002]	9.2



RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150521-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150521-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150521-5

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 62 & 180.
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.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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													
-	-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250													
-	-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MITSUBI	249													
-	1	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246													
-	1	1	1	1	1	2119082-2	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													
-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)

REVISIONS

REV	DATE	DESCRIPTION	APPD	DATE	APPD
1	-	SEE SHEET 1	-	-	-
2	-	2168400-7 SHCS, LOW HEAD, RoHS, M5 X 10	240	-	-
-	-	2119580-1 MECHANICAL FEED ASSEMBLY	239	-	-
-	-	2063440-1 AIR FEED MODULE	238	-	-
-	-	2119740-2 TAG, IDENTIFICATION	213	-	-
-	4	2079383-9 SCR, BHSC, RoHS (M6 X 20)	186	-	-
-	4	1901697-1 FEED FINGER ASSEMBLY, EF	183	-	-
-	1	1-1976055-2 STANDOFF, HOLD-DOWN	180	-	-
-	1	6-993111-6 PIN, SLOTTED SPRING 3.0 X 14.0	177	-	-
-	1	8-22280-7 SPRING, COMPRESSION	176	-	-
-	1	1752353-2 GUIDE PIN, HOLDDOWN	175	-	-
-	1	1901680-2 GUIDE PIN, HOLDDOWN	174	-	-
-	-	21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172	-	-
-	1	994969-1 MAGNET, RARE EARTH HIGH ENERGY	166	-	-
-	REF	994970-2 COUNTER, MAGNETIC	164	-	-
-	-	240638-1 SPRING, FEED FINGER	163	-	-
-	1	8-21084-1 O-RING, .801 ID, .070 DIA. MAT.	153	-	-
-	-	2119641-2 FEED CAM, AIR FEED	152	-	-
-	1	2119798-2 DETENT PIN	145	-	-
-	1	2079383-8 SCR, BHSC, RoHS (M4 X 16)	144	-	-
-	-	2119653-2 FEED CAM, POST FEED	142	-	-
-	1	2119655-6 APPLICATOR BASIC ASSEMBLY, EF	141	-	-
-	1	2119651-1 RAM, ASIAN STYLE, END FEED	140	-	-
-	1	2119092-2 BOLT, ADJUSTMENT	139	-	-
-	-	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	455888-4 SPACER, CRIMPER	82	-	-
-	1	2119956-2 DOCUMENTATION PACKAGE	71	-	-
-	2	2-18032-2 SCR, SET, FLT POINT M3 X 10.0	70	-	-
-	1	2119740-1 TAG, IDENTIFICATION	67	-	-
-	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66	-	-
-	1	1901681-1 HOLDDOWN, TERMINAL	65	-	-
-	2	2168400-5 SHCS, LOW HEAD, RoHS, M4 X 20	64	-	-
-	1	2119793-1 LIMITER, ADJUSTMENT BOLT	63	-	-
-	3	992763-5 SCR, SET, SOC, CONE POINT, M3 x 4.0	62	-	-
-	-	5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59	-	-
-	-	2063961-1 FEED FINGER	58	-	-
-	3	2168400-4 SHCS, LOW HEAD, RoHS, M4 X 8	57	-	-
-	2	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	56	-	-
-	2	5018030-2 NUT, HEX, REG, RoHS, M4	55	-	-
-	2	5018030-1 NUT, HEX, REG, RoHS, M3	54	-	-
-	2	986965-8 NUT, LOCK, HEX, TORQUE (M4)	53	-	-
-	1	1-5018030-0 NUT, HEX, REG, RoHS, M3.5	52	-	-
-	-	2119792-2 PAWL, EF, AIR	51	-	-
-	-	18023-9 SCR, SKT HD CAP M4 X 6.0	49	-	-
-	-	2119652-1 FEED CAM, PRE FEED	48	-	-
-	1	2079383-7 SCR, BHSC, RoHS (M8 X 25)	41	-	-
-	1	2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT	40	-	-
-	1	2119957-1 APPLICATOR SHIM PACK	39	-	-
-	1	2119644-2 RAM WASHER, PRECISION	38	-	-
-	7	1-18028-2 WASHER, FLAT, REG M4	33	-	-
-	2	2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	31	-	-
-	2	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	29	-	-
-	1	240639-1 STRIPPER (MACHINING)	27	-	-
-	2	1320906-1 STUD, THREADED	25	-	-
-	1	1752371-5 PLATE, STRIP GUIDE	24	-	-
-	1	240825-1 PLATE, STRIP HOLD DOWN	23	-	-
-	2	2-22281-3 SPRING, COMPRESSION	22	-	-
-	1	1752373-4 DRAG	20	-	-
-	2	1901259-6 GUIDE, LOWER STRIP	18	-	-
-	1	6-240641-3 SPACER	16	-	-
-	1	1752360-1 SPACER, HOLD-DOWN	13	-	-
-	1	240644-1 PLATE, REAR SHEAR	11	-	-
-	-	-	-	-	-
-	1	690482-3 PLATE, FRONT SHEAR	9	-	-
-	1	7-1803001-1 ANVIL, COMBINATION, END FEED	8	-	-
-	1	1-2217206-3 BLADE, SLUG	7	-	-
-	-	-	-	-	-
-	-	-	-	-	-
-	1	240641-1 SPACER	5	-	-
-	1	238009-2 BLOCK, FL CRIMPER SPACER	4	-	-
-	1	3-1633961-8 CRIMPER, INSULATION F PREMIUM	3	-	-
-	1	455888-3 SPACER, CRIMPER	2	-	-
-	1	2-456407-5 CRIMPER, WIRE PREMIUM	1	-	-
-77-	27-	25-	22-	21-	PART NO DESCRIPTION ITEM NO

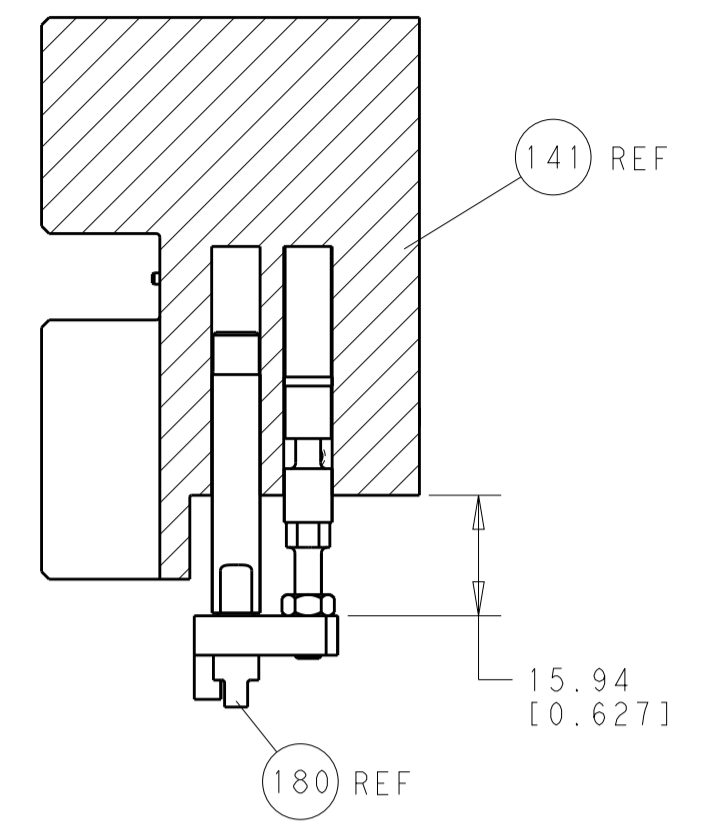
STE TE Connectivity Harrisburg, PA 17105-3608

Ocean End Feed Applicator

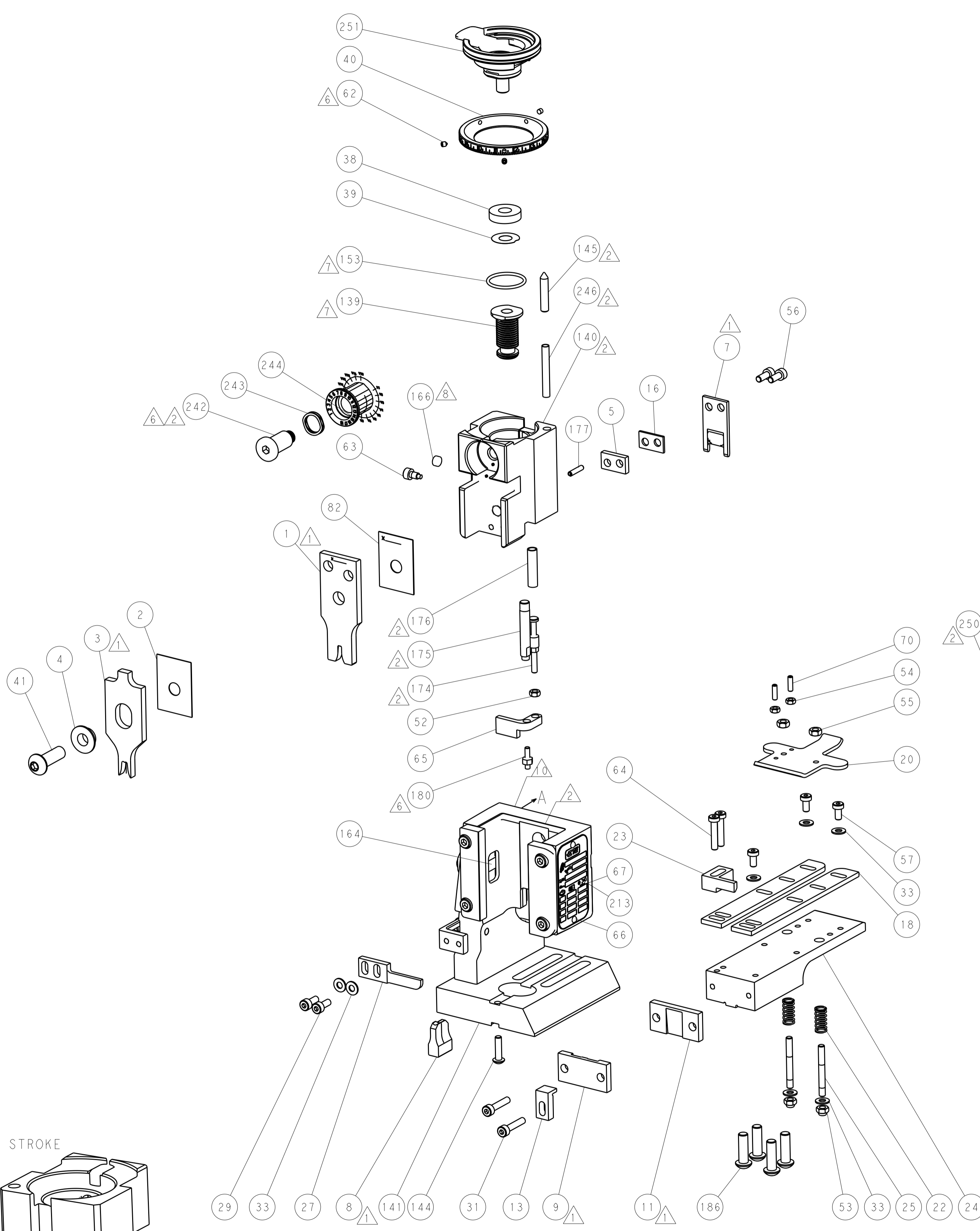
Customer Accessible Production Drawing

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		09JAN2015	G.BAILEY	
		09JAN2015	JU.GUO	

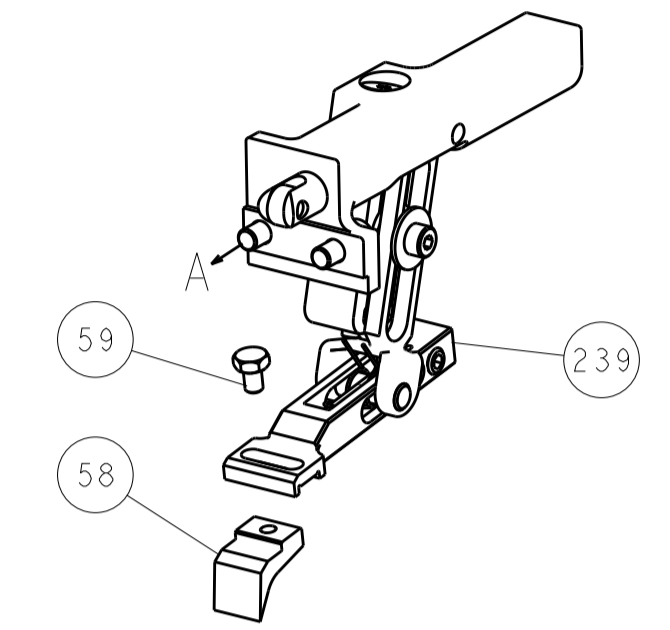
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A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
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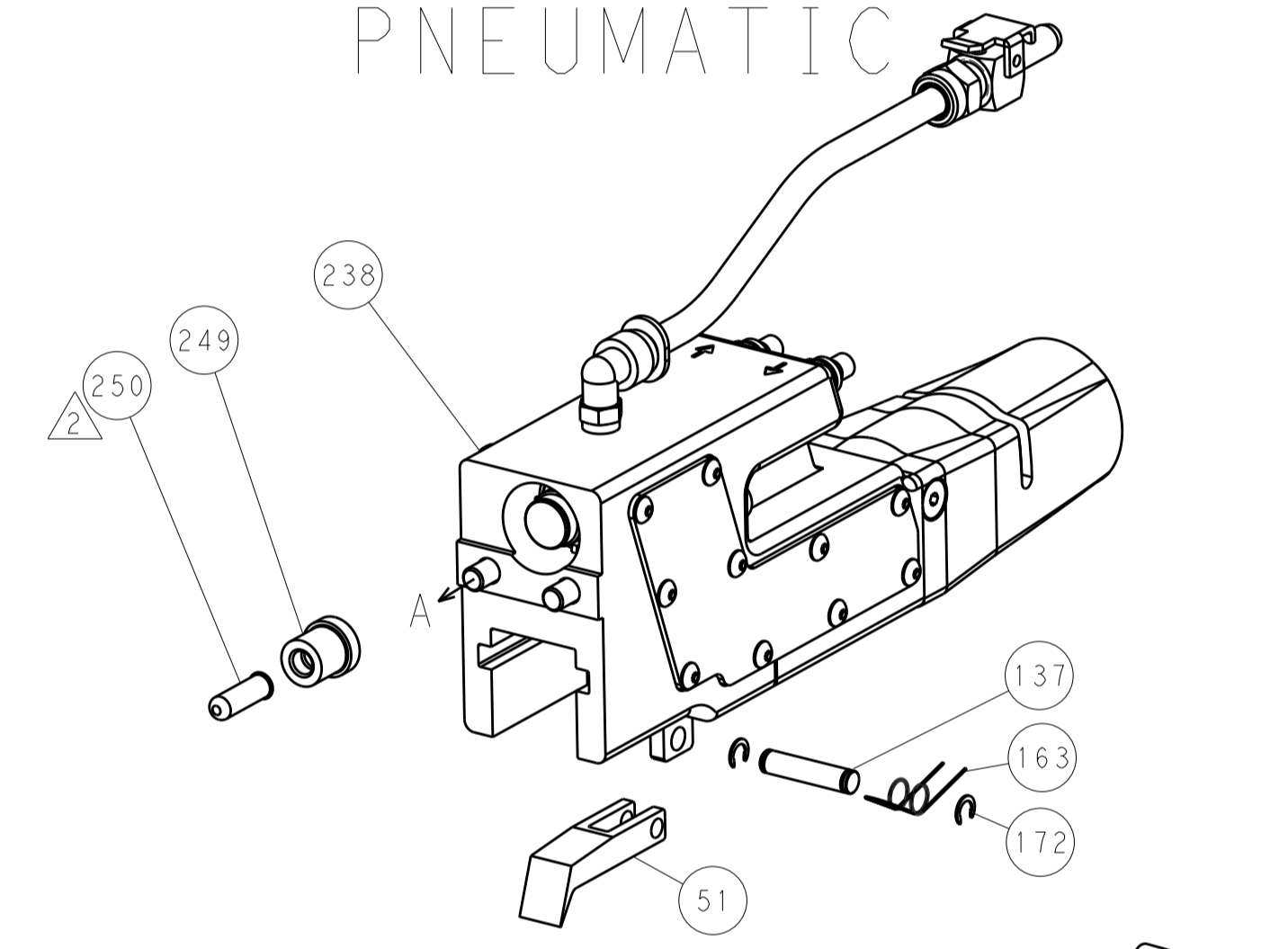
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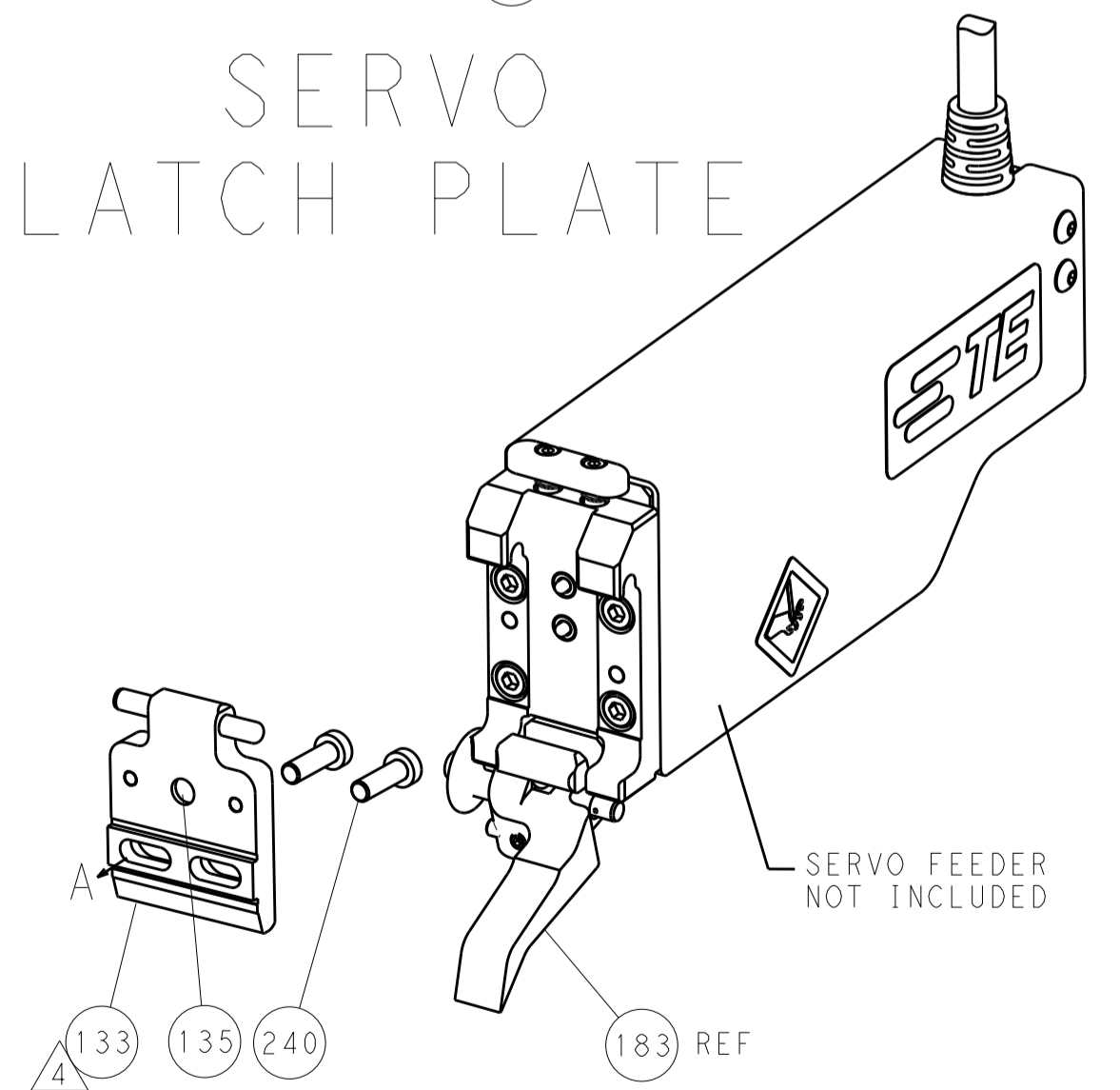
FEED TYPE
MECHANICAL



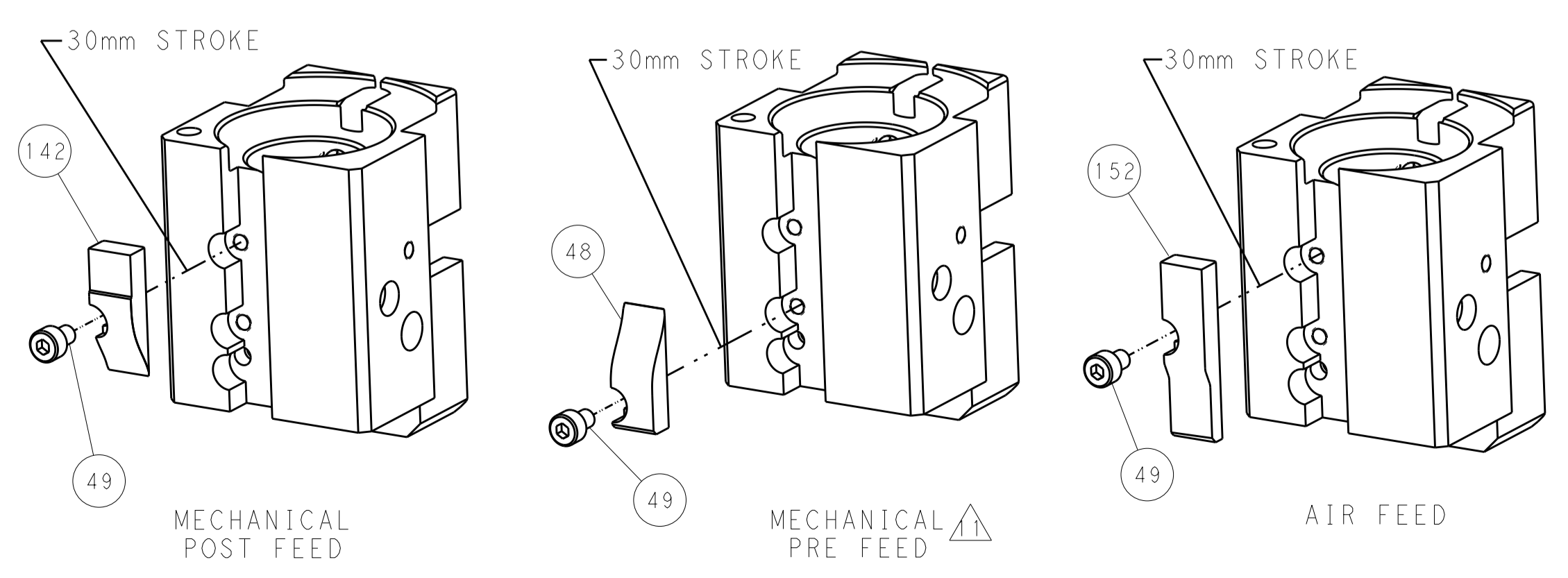
PNEUMATIC



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:		DWG: Y. YIN 09JAN2015		CHK: G. BAILEY 09JAN2015		REV: H. GUO 09JAN2015		NAME: Ocean End Feed Applier	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.001	PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2150521		RESTRICTED TO:
MATERIAL:	FINISH:		WEIGHT:		SCALE: 1:1		SHEET 4 OF 4		REV A		