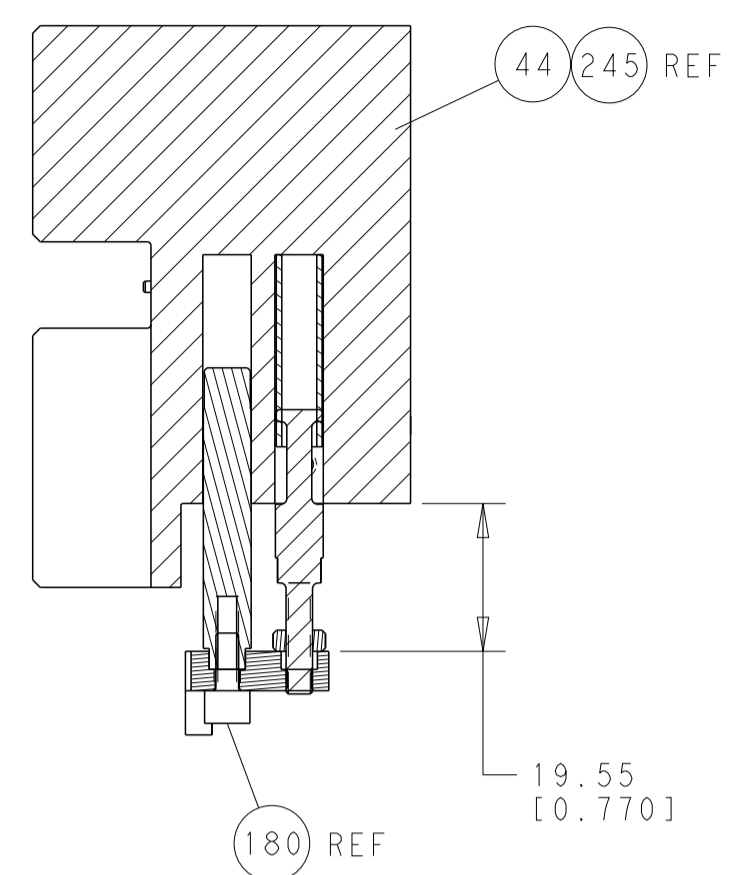
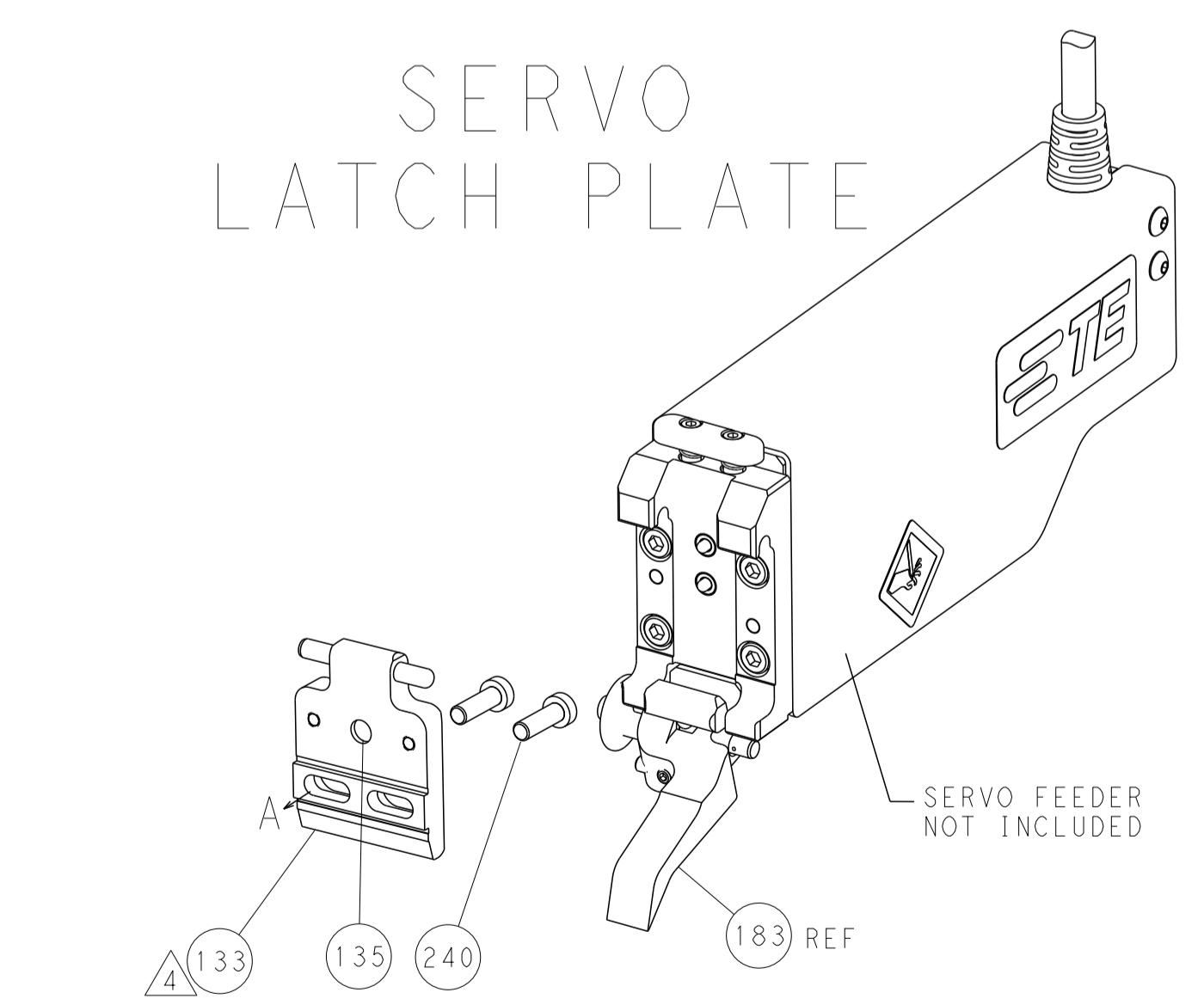
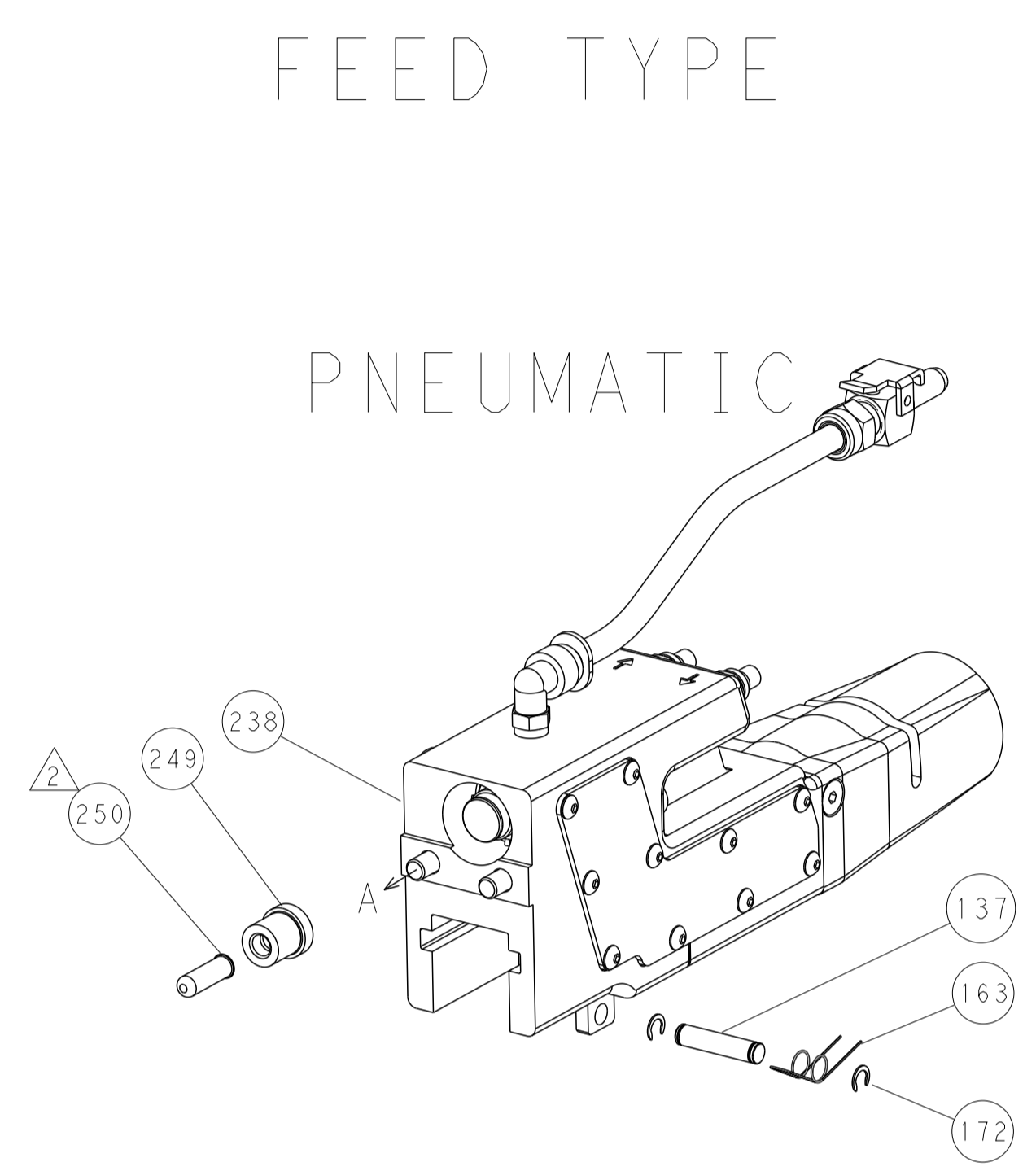
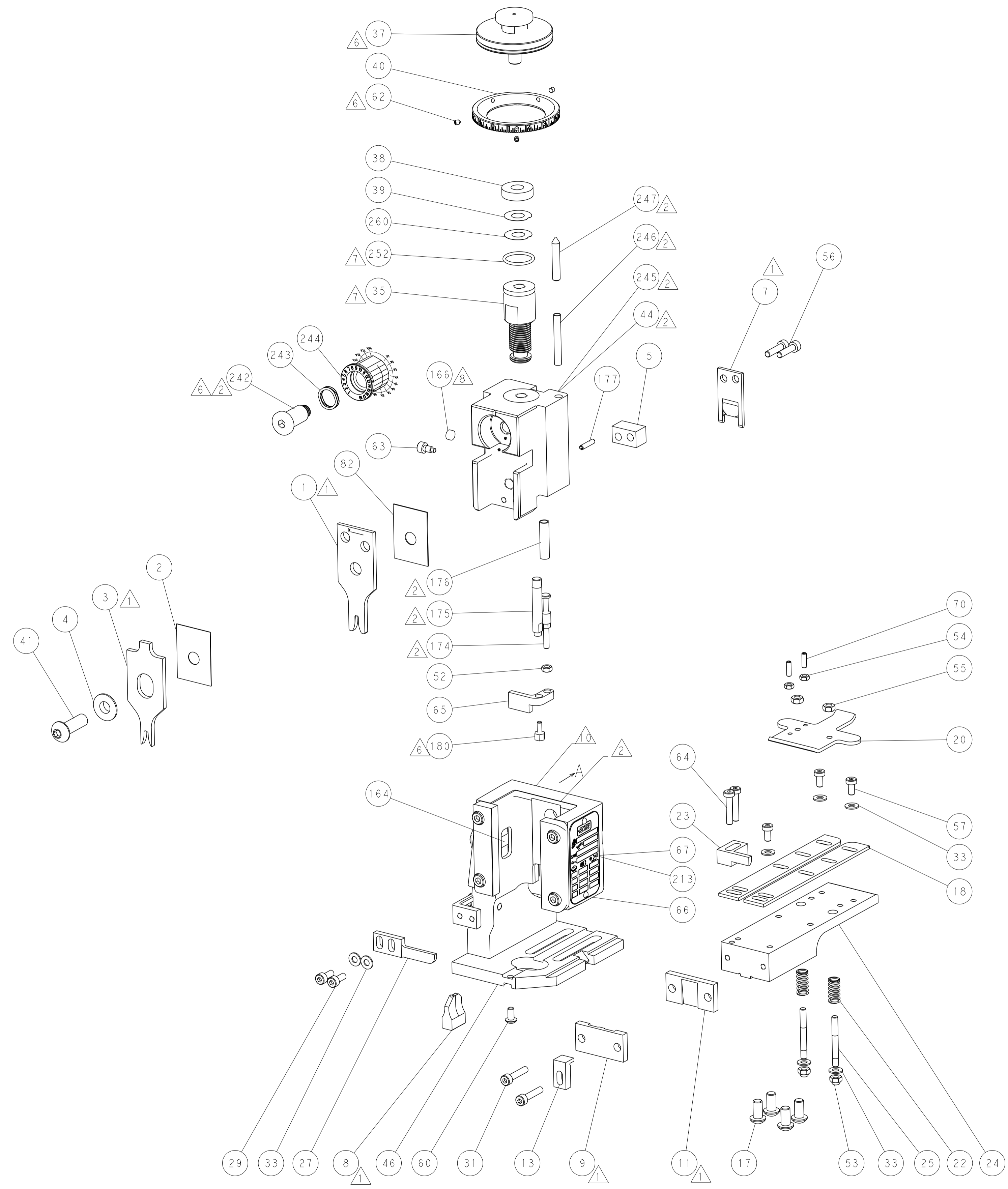


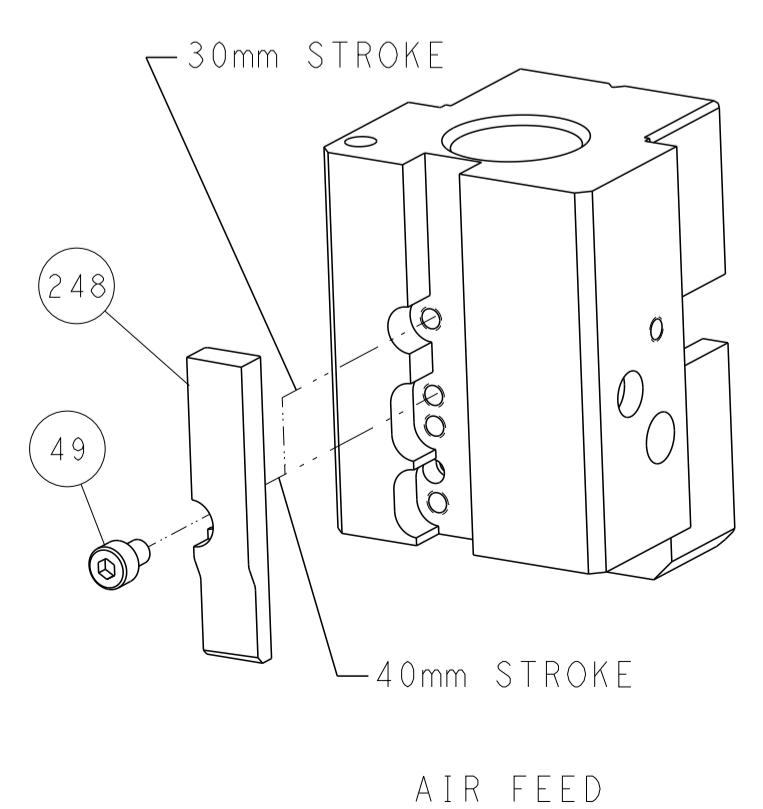
LOC	DIST	REV	DATE	BY	APPV
A	66				
		REVISIONS			
		DESCRIPTION	DATE	BY	APPV
		SEE SHEET 1			



HOLDDOWN SET-UP



CAM POSITION



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.0001 FINISH:		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150491	RESTRICTED TO: SCALE: 1:1 SHEET: 2 OF 4 REV: A
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2-2150491-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150491-5	-	-	2168400-7 (QUANTITY 2)
	2-2150491-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SMART APPLICATOR	2161326-1	-	8-2150491-4	-	-	-
	2-2150491-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-2
	7-2150491-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.40 mm [.094]	F
INSUL	3.30 mm [1.30]	OV
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: 2.8 X 0.8 TAB CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.00 mm [1.177-.197 IN]		1.40-2.10 mm [1.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	25628 Rev 2	-	-
TERMINALS APPLIED ¹⁰			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1572637-1	25628.213.009	1572637-8	25628.213.141
1572637-2	25628.213.111	1572637-9	25628.213.112
1572637-3	25628.123.009	1-1572637-0	25628.213.004
1572637-4	25628.123.111	1-1572637-1	25628.123.142
1572637-5	25628.123.141	1-1572637-2	25628.123.041
1572637-6	25628.213.001	1-1572637-3	25628.123.011
1572637-7	25628.213.178	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
1.00mm2	1.45+/-0.05 [1.057+/-0.002]	7.6
0.75mm2	1.40+/-0.05 [1.055+/-0.002]	8.2
0.50mm2	1.35+/-0.05 [1.053+/-0.002]	8.9

- RECOMMENDED SPARE PARTS
- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150491-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150491-5
- 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. 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.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

ITEM NO	DESCRIPTION	ITEM NO
- 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	1-22279-3 SPRING, COMPRESSION	246
- 1 1 1	2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
- 77-27-25-22	PART NO	DESCRIPTION

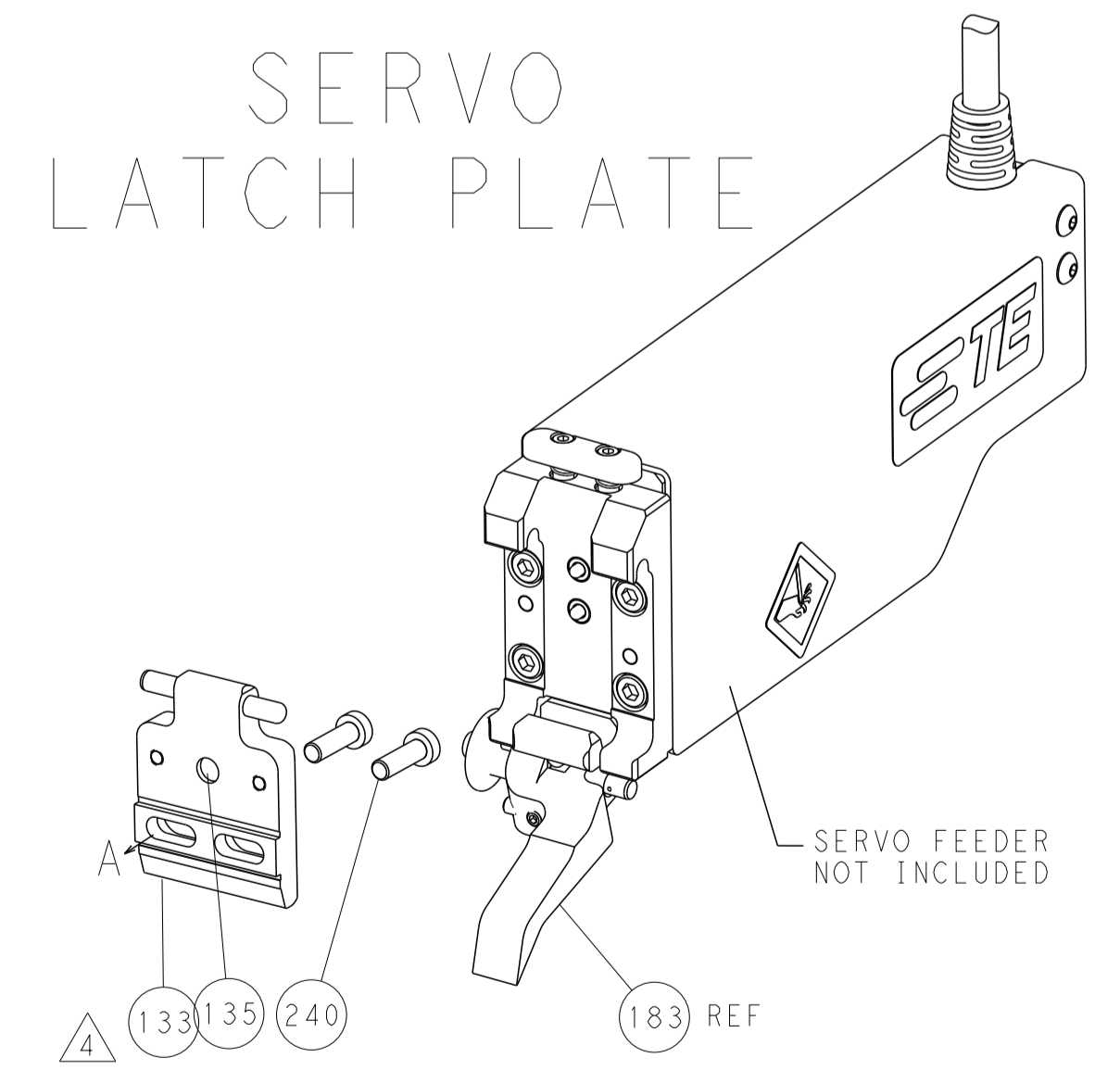
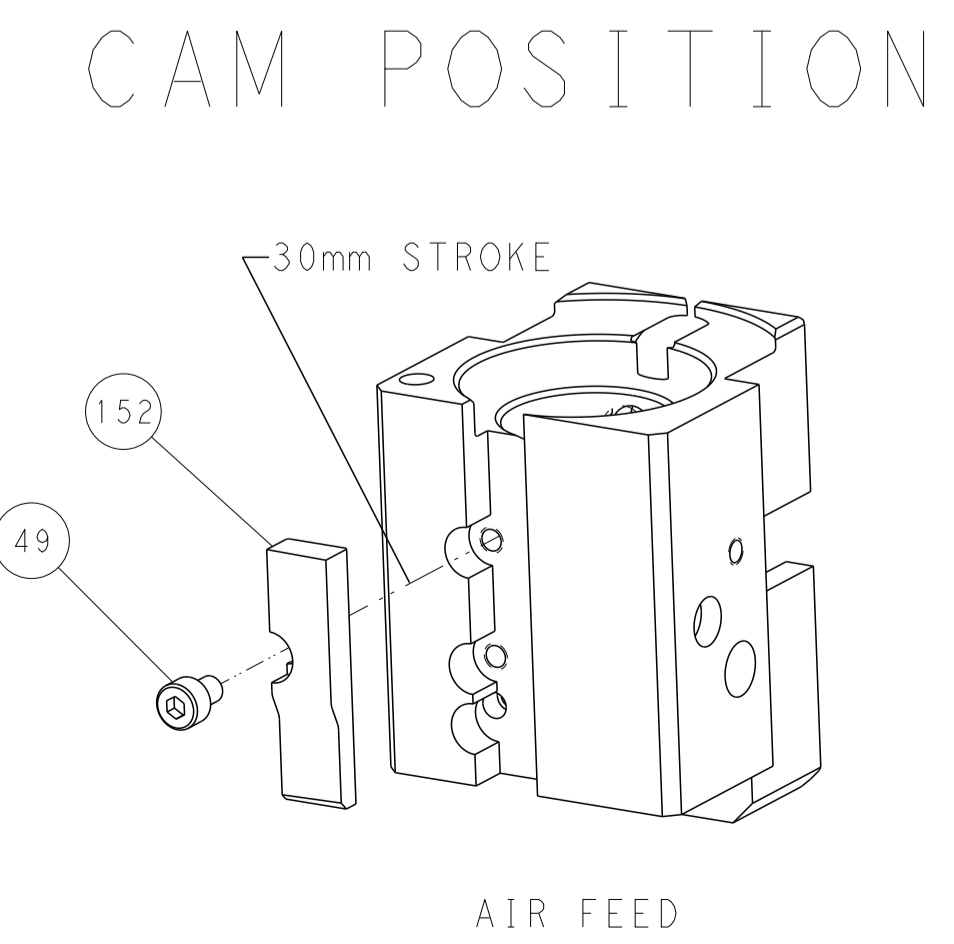
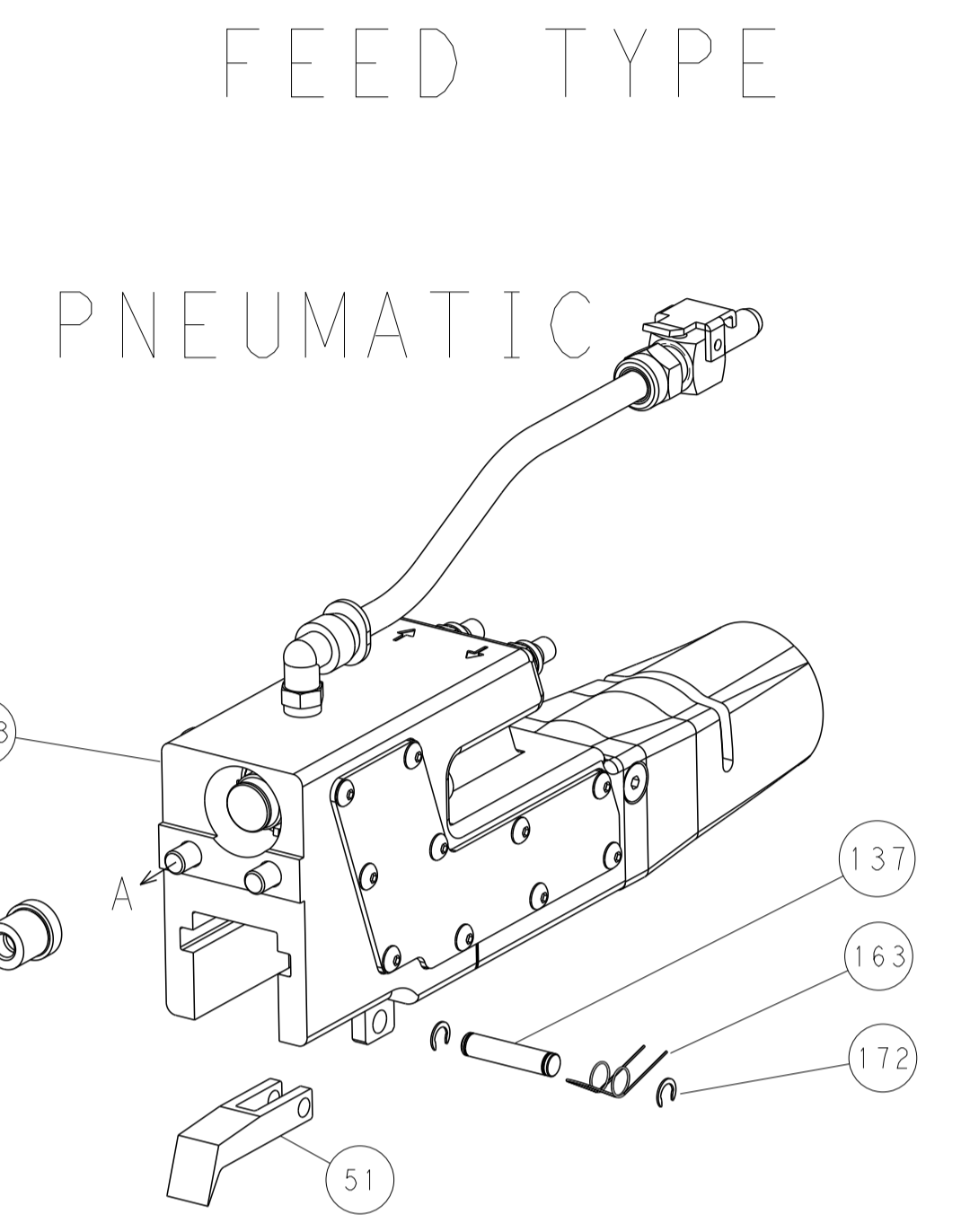
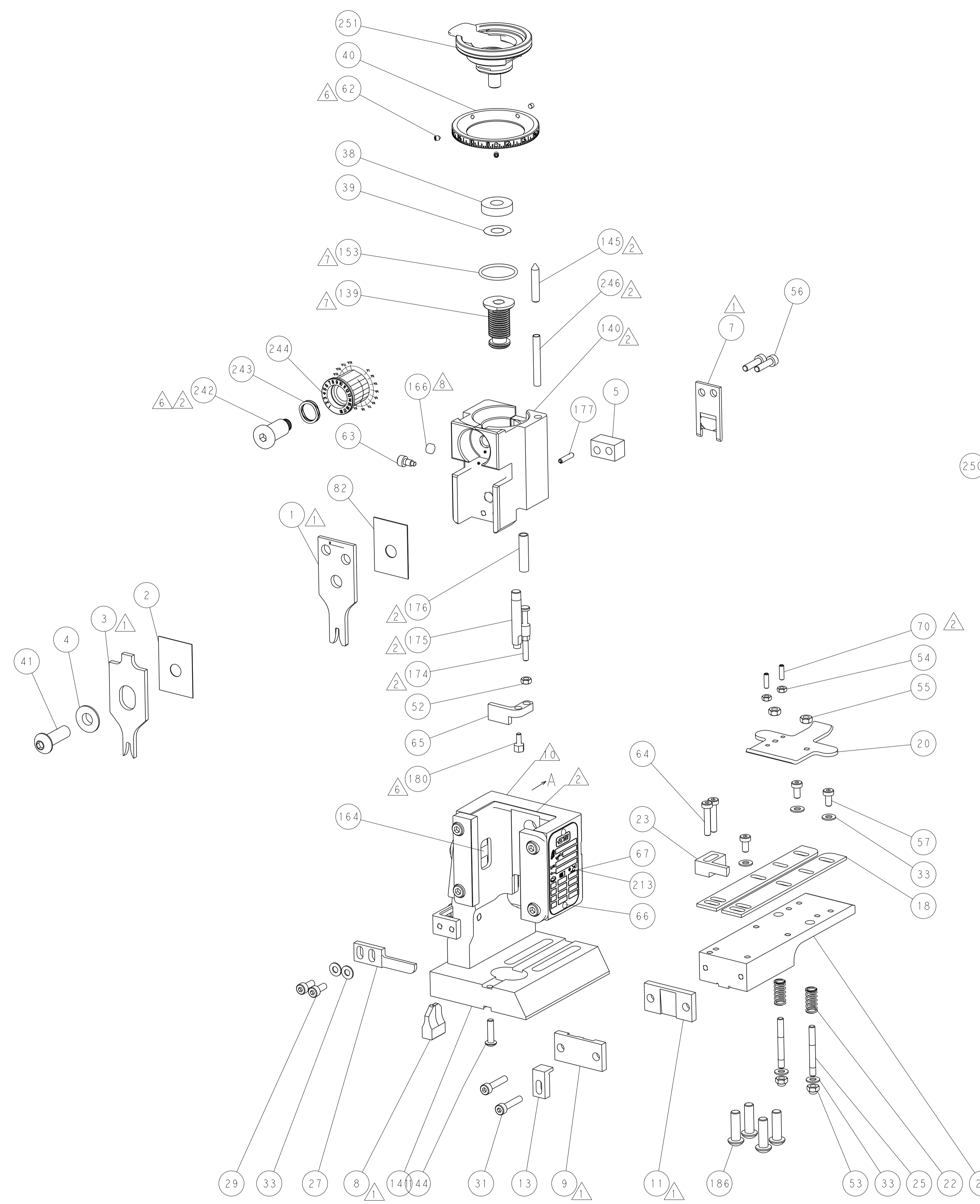
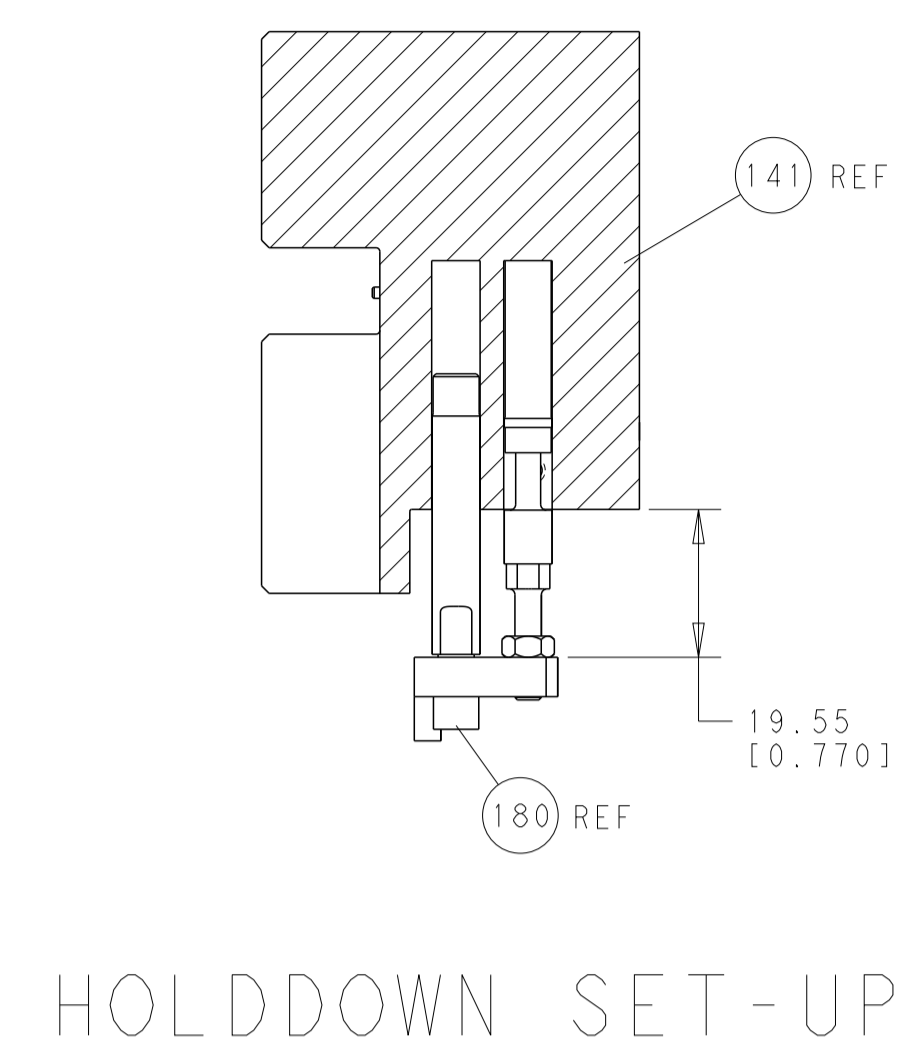
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

ITEM NO	DESCRIPTION	ITEM NO
- 1 1 1	2119083-1 RETAINER, INSULATION DIAL	242
- - 2 -	2168400-7 SHCS, LOW HEAD, RoHS, M5 X 10	240
- - - -	2119580-1 MECHANICAL FEED ASSEMBLY	239
- - - 1	2063440-2 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	1752354-2 STANDOFF, HOLD-DOWN	180
- 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
- REFREFREF	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
- - - -	2119653-2 FEED CAM, POST FEED	142
- 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
⁶ - 3 3 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 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	18023-9 SCR, SKT HD CAP M4 X 6.0	49
- - - -	2119652-1 FEED CAM, PRE FEED	48
- 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	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	1752371-5 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	1901259-4 GUIDE, LOWER STRIP	18
- 1 1 1	1752360-1 SPACER, HOLD-DOWN	13
¹ - 1 1 1	240644-1 PLATE, REAR SHEAR	11
- - - -	-	10
¹ - 1 1 1	690482-4 PLATE, FRONT SHEAR	9
¹ 1 1 1 1	6-1803001-6 ANVIL, COMBINATION, END FEED	8
¹ - 1 1 1	1-2217206-0 BLADE, SLUG	7
- - - -	-	6
- 1 1 1	7-240641-7 SPACER	5
- 1 1 1	238009-1 BLOCK, FL CRIMPER SPACER	4
¹ 1 1 1 1	4-2119785-4 CRIMPER, INSULATION OVERLAP PREMIUM	3
- 1 1 1	455888-3 SPACER, CRIMPER	2
¹ 1 1 1 1	3-1490019-3 CRIMPER, WIRE PREMIUM	1
- 77-27-25-22	PART NO	DESCRIPTION

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC ±.5	1 PLC ±.3	2 PLC ±.2	3 PLC ±.15	4 PLC ±.1	5 PLC ±.075	6 PLC ±.05
	ANGLES ±.0001	FINISH		OFFNER	11NOV2014	12NOV2014	12NOV2014
				T. ELBIN			
				T. ELBIN			
				PRODUCT SPEC			
				APPLICATION SPEC			
				WEIGHT			
				SCALE	1:1		
				SHEET	3	OF	4
				REV	A		

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



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

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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1	NAME: Ocean End Feed Applier PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150491 SCALE: 1:1 SHEET: 4 of 4 REV: A
MATERIAL:		RESTRICTED TO:	