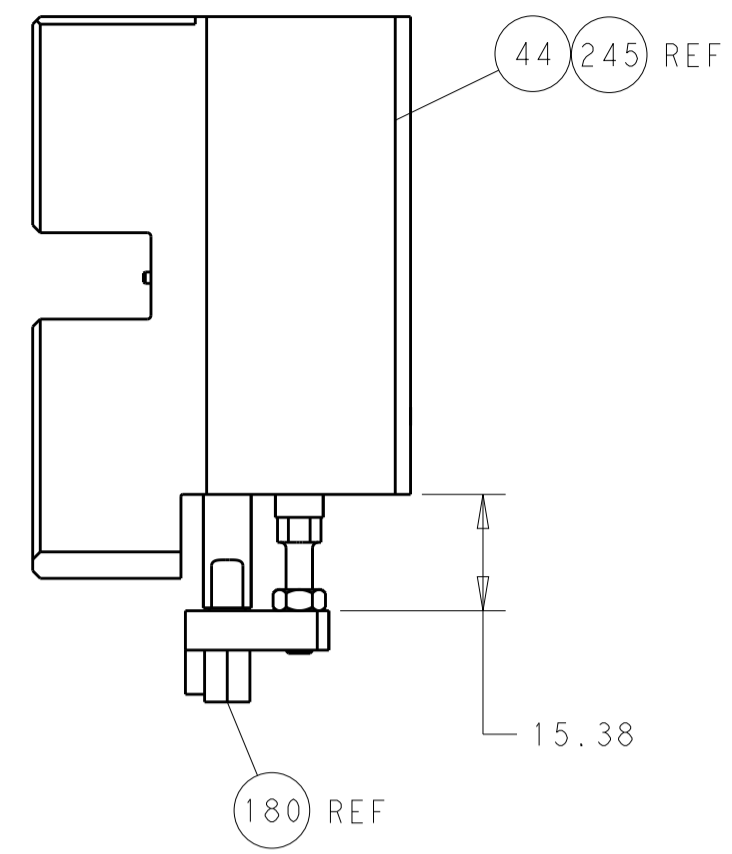


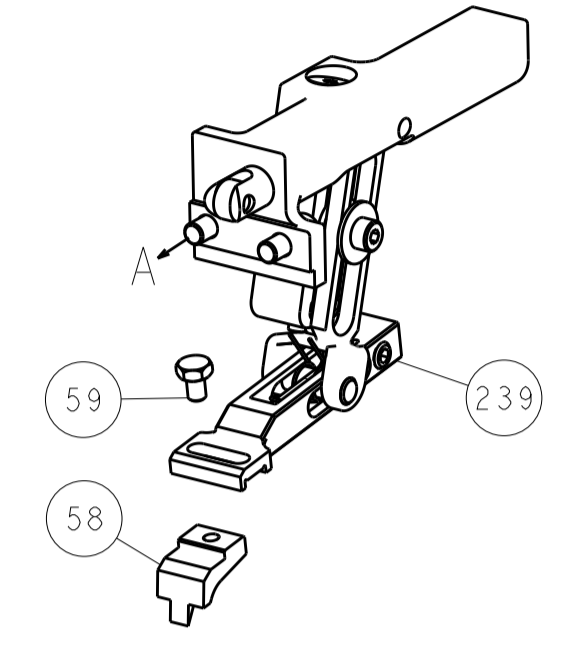


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

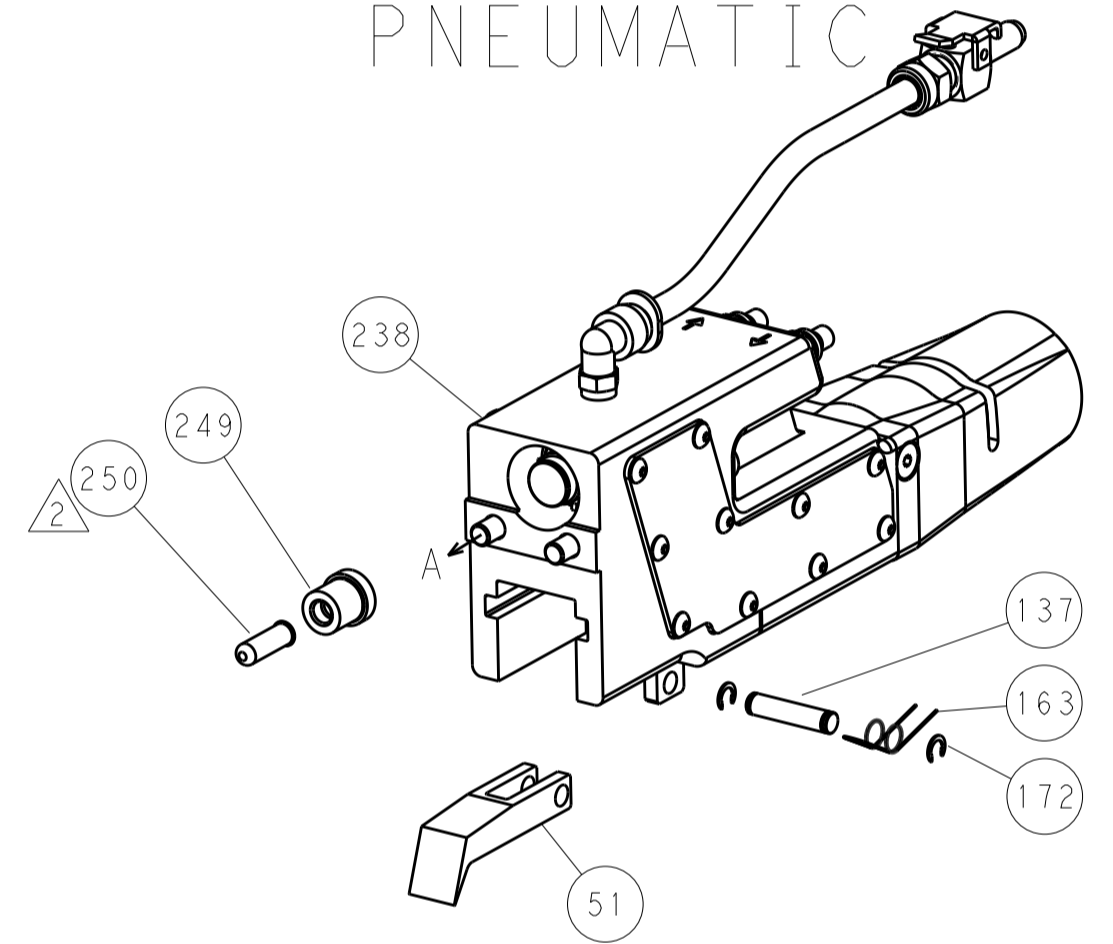


HOLDDOWN SET-UP

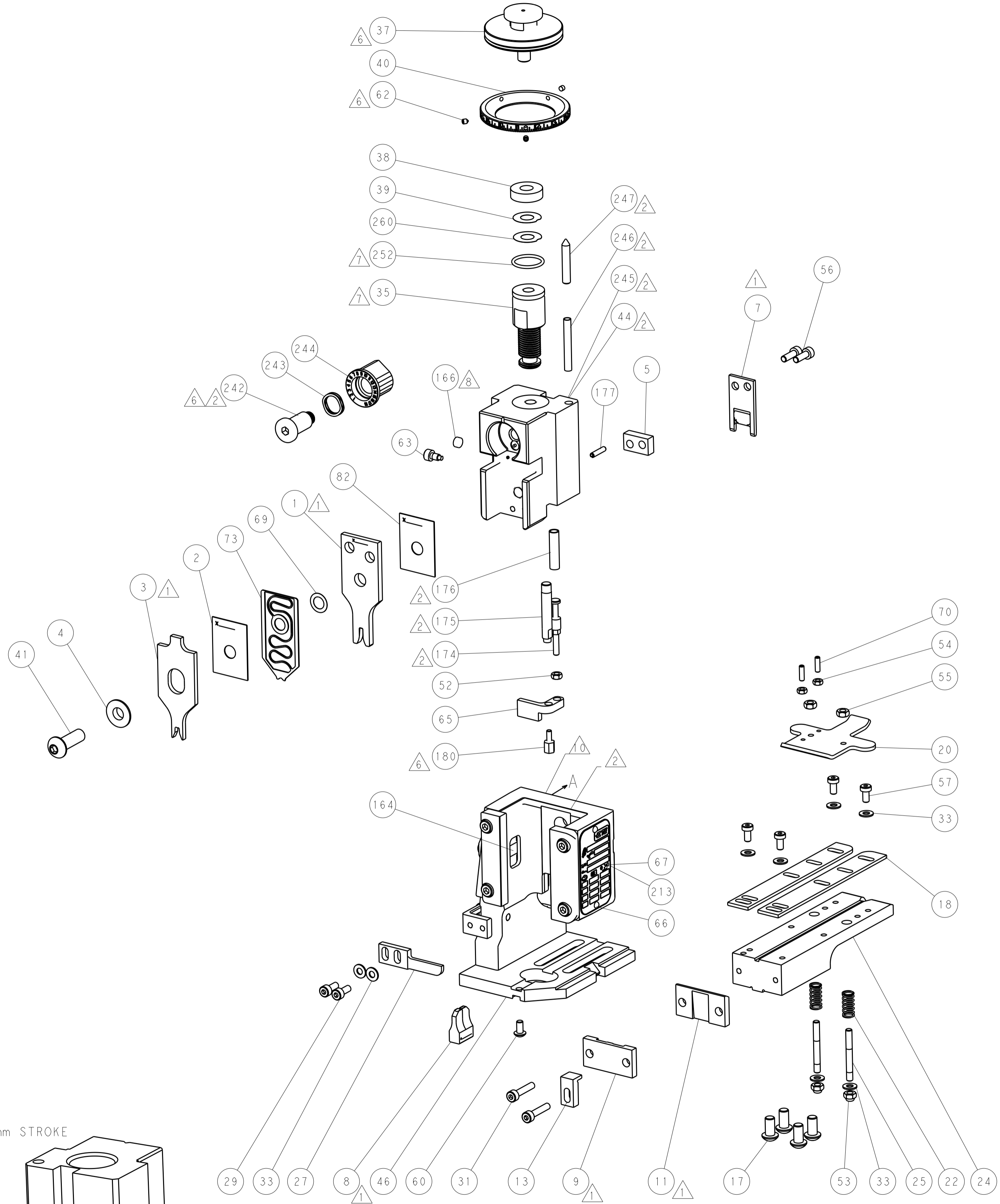
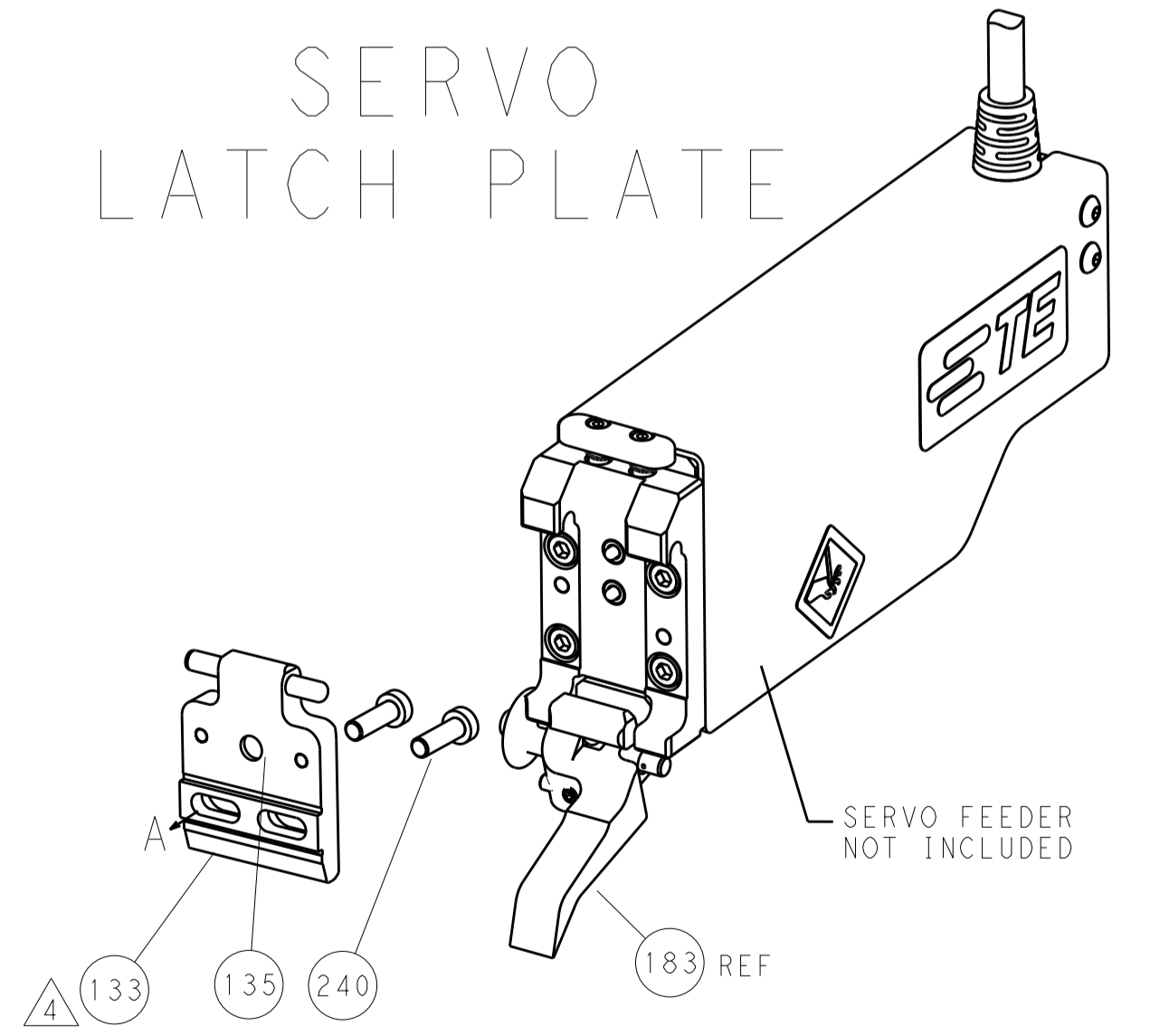
FEED TYPE  
MECHANICAL



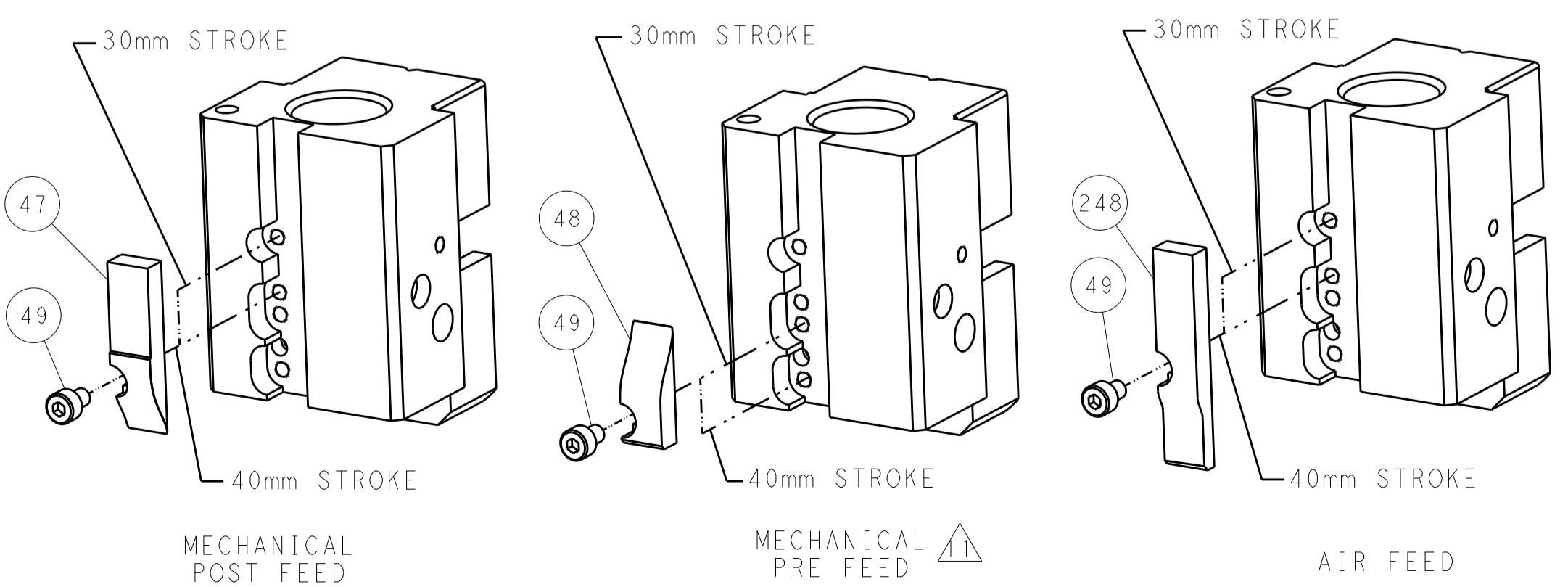
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X_ZHAO 12APR2013		TE Connectivity	
mm		0 PLC ±		CHK: T_ELBIN 12APR2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: L_ZHANG 12APR2013		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
D		3 PLC ±		APPLICATION SPEC		A1 00779 ©=2150334	
R		4 PLC ±		WEIGHT		RESTRICTED TO	
ANGLES		FINISH		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV A1	

SET UP GAUGE 2119599-2  
REVISONS: A 66  
DESCRIPTION, DATE, DWN, APVD

APPLICATOR STYLE CONVERSION CHART  
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER  
CONVERT TO: PNEUMATIC FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, MECHANICAL FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, PNEUMATIC FEED  
PART NUMBERS REQUIRED: 2119950-1, 2119792-2, 2119641-2, 2063440-1, 2119951-1, 1901697-1, 8-2150334-5, 2168400-7 (QUANTITY 2), 2161326-1, 2063961-1, 5-18022-5, 2119653-2, 2119949-1, 2119951-1, 1901697-1, 8-2150334-5, 2161326-1, 8-2150334-4, 2119949-1, 2063961-1, 5-18022-5, 2119653-2, 2119950-1, 2119792-2, 2119641-2, 2063440-1

APPLICATOR DATA  
CRIMP SIZE TYPE  
WIRE 2.29 mm (.090) F  
INSUL 3.30 mm (.130) F  
APPL INSTRUCTIONS 408-10390

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION  
TERMINAL NAME: .250 SERIES FASTIN-FASTON RECEPTACLE  
WIRE STRIP LENGTH 4.80-5.60 mm (.189-.220 IN)  
INSULATION DIAMETER RANGE 1.73-3.30 mm (.068-.130 IN)  
TERMINAL APPLICATION SPECIFICATION 114-3118  
TERMINALS APPLIED: TE TERMINAL, TE TERMINAL, TE TERMINAL, TE TERMINAL

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION  
TERMINAL NAME: .250 SERIES FASTIN-FASTON RECEPTACLE  
WIRE STRIP LENGTH 4.80-5.60 mm (.189-.220 IN)  
INSULATION DIAMETER RANGE 1.73-3.30 mm (.068-.130 IN)  
TERMINAL APPLICATION SPECIFICATION  
TERMINALS APPLIED: TE TERMINAL, TE TERMINAL, TE TERMINAL, TE TERMINAL

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING  
16 AWG OR 1.50mm2 1.50+/-0.05 [.059+/-0.002] 3.8  
1.00mm2 1.45+/-0.05 [.057+/-0.002] 4.2  
18 AWG OR 0.75mm2 1.40+/-0.05 [.055+/-0.002] 4.8  
20 AWG OR 0.50mm2 1.35+/-0.05 [.053+/-0.002] 5.1

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING  
0.35+0.5mm 1.36+/-0.05 [.054+/-0.002] 5

\*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.

- 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: 8-2150334-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150334-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150334-5
- 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 ITEM 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.
- TERMINAL INS. RANGE IS 2.30-3.30mm. BUT APPLICATION FOUND TO BE SUITABLE ON A RANGE OF 1.73-3.30mm. THIS INCREASE IN INS. RANGE IS AS APPROVED BY TE PRODUCT ENGINEERING.

THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS. AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

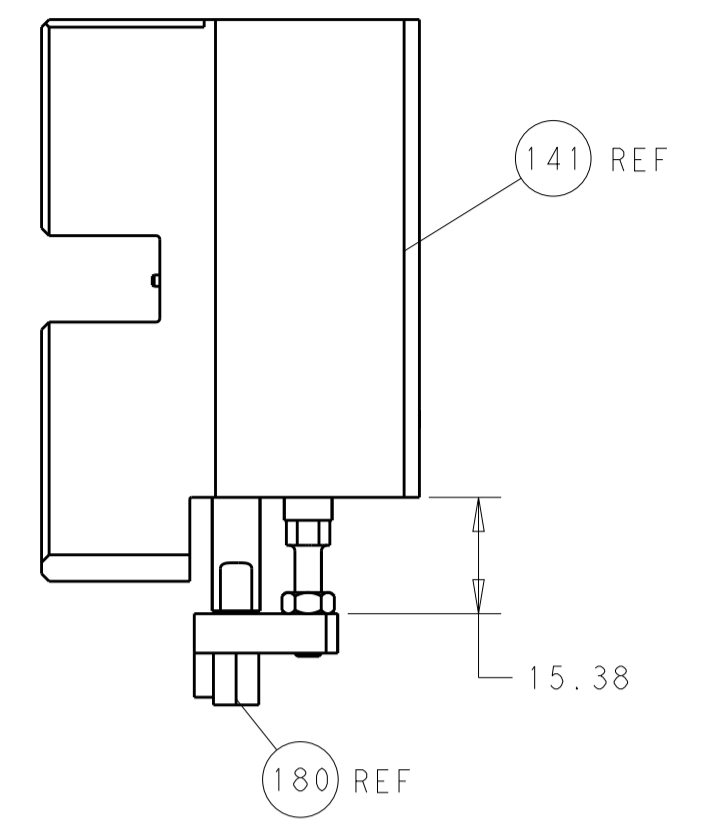
Table with 3 columns: PART NO, DESCRIPTION, ITEM NO

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

Table with 3 columns: P, LTH, DESCRIPTION, DATE, DWN, APVD  
Includes various part numbers and descriptions like RETAINER, INSULATION DIAL, SHCS, LOW HEAD, ROHS, M5 X 10, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, TAG, IDENTIFICATION, FEED FINGER ASSEMBLY, EF, STANDOFF, HOLD-DOWN, PIN, SLOTTED SPRING, SPRING, COMPRESSION, GUIDE PIN, RING, RETAIN, EXTERN, MAGNET, COUNTER, MAGNETIC, SPRING, FEED FINGER, O-RING, FEED CAM, AIR FEED, DETENT PIN, SCR, BHSC, RING, FEED CAM, POST FEED, APPLICATOR BASIC ASSEMBLY, RAM, ASIAN STYLE, END FEED, BOLT, ADJUSTMENT, PIN, RETAIN, MEMORY CHIP, SERVO FEED LATCH ASM, SPACER, CRIMPER, DEPRESSOR, WIRE, DOCUMENTATION PACKAGE, SCR, SET, WASHER, SPACER, TAG, IDENTIFICATION, SCREW, DRIVE, HOLDDOWN, TERMINAL, LIMITER, ADJUSTMENT BOLT, SCR, SET, CONE POINT, WASH, SPACER, SCR, SKT HD CAP, NUT, HEX, REG, NUT, LOCK, HEX, TORQUE, NUT, HEX, REG, PAWL, FEED CAM, SCR, SKT HD CAP, SCR, BHSC, DISC, NUMBERED FA WIRE, APPLICATOR SHIM PACK, RAM WASHER, WASH, FLAT, REG, SCR, SKT HD CAP, STRIPPER, STUD, THREADED, PLATE, STRIP GUIDE, SPRING, COMPRESSION, DRAG, GUIDE, LOWER STRIP, SPACER, HOLD-DOWN, PLATE, REAR SHEAR, PLATE, FRONT SHEAR, ANVIL, BLADE, SLUG, SPACER, BLOCK, FL CRIMPER, CRIMPER, SPACER, CRIMPER, CRIMPER, WIRE PREMIUM

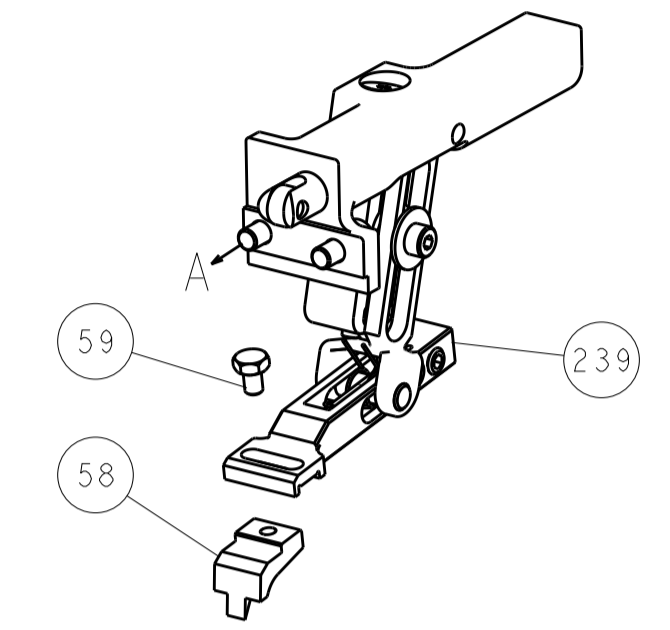
Technical drawing information including dimensions, tolerances, material, weight, and drawing details like DWG, CHK, DWN, APVD, NAME, PRODUCT SPEC, APPLICATION SPEC, SIZE, CASE CODE, DRAWING NO, RESTRICTED TO, SCALE, SHEET, REV.

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

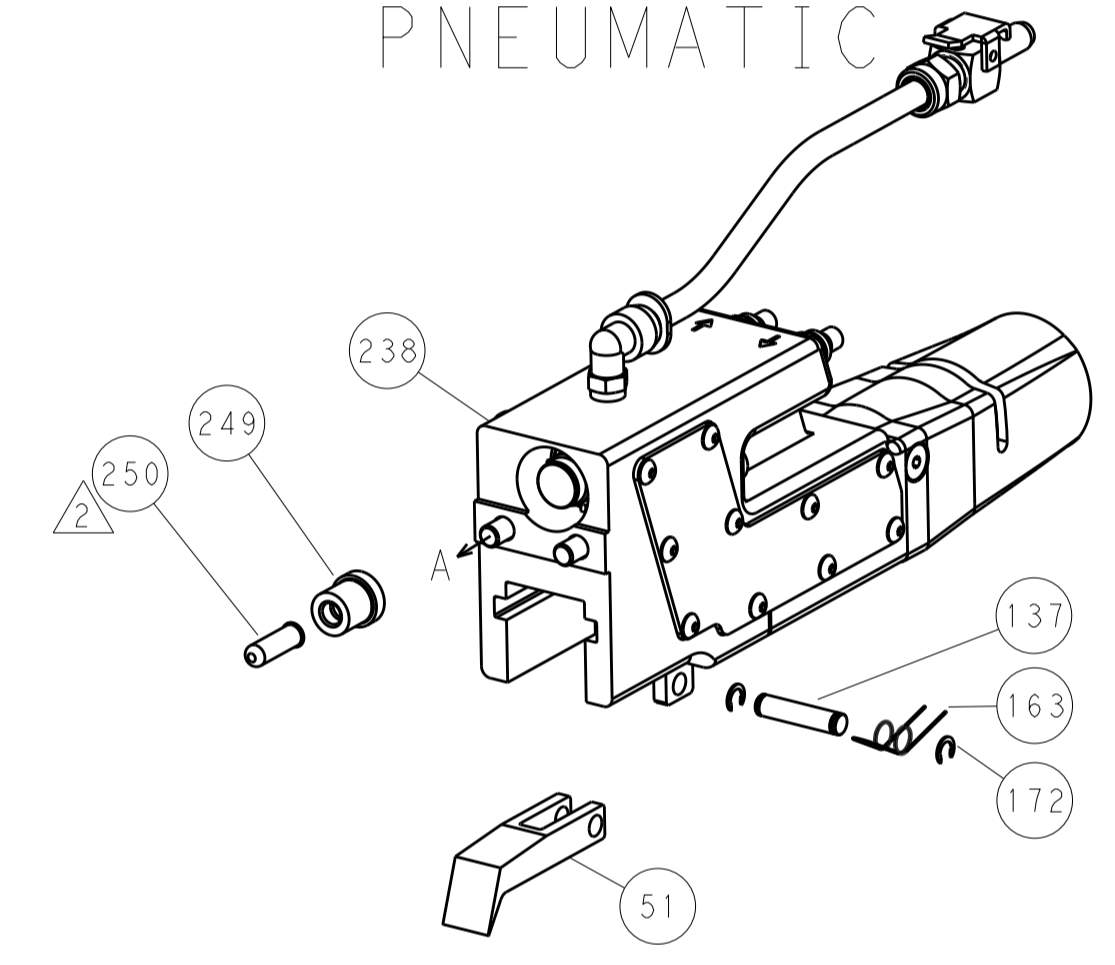


HOLDDOWN SET-UP

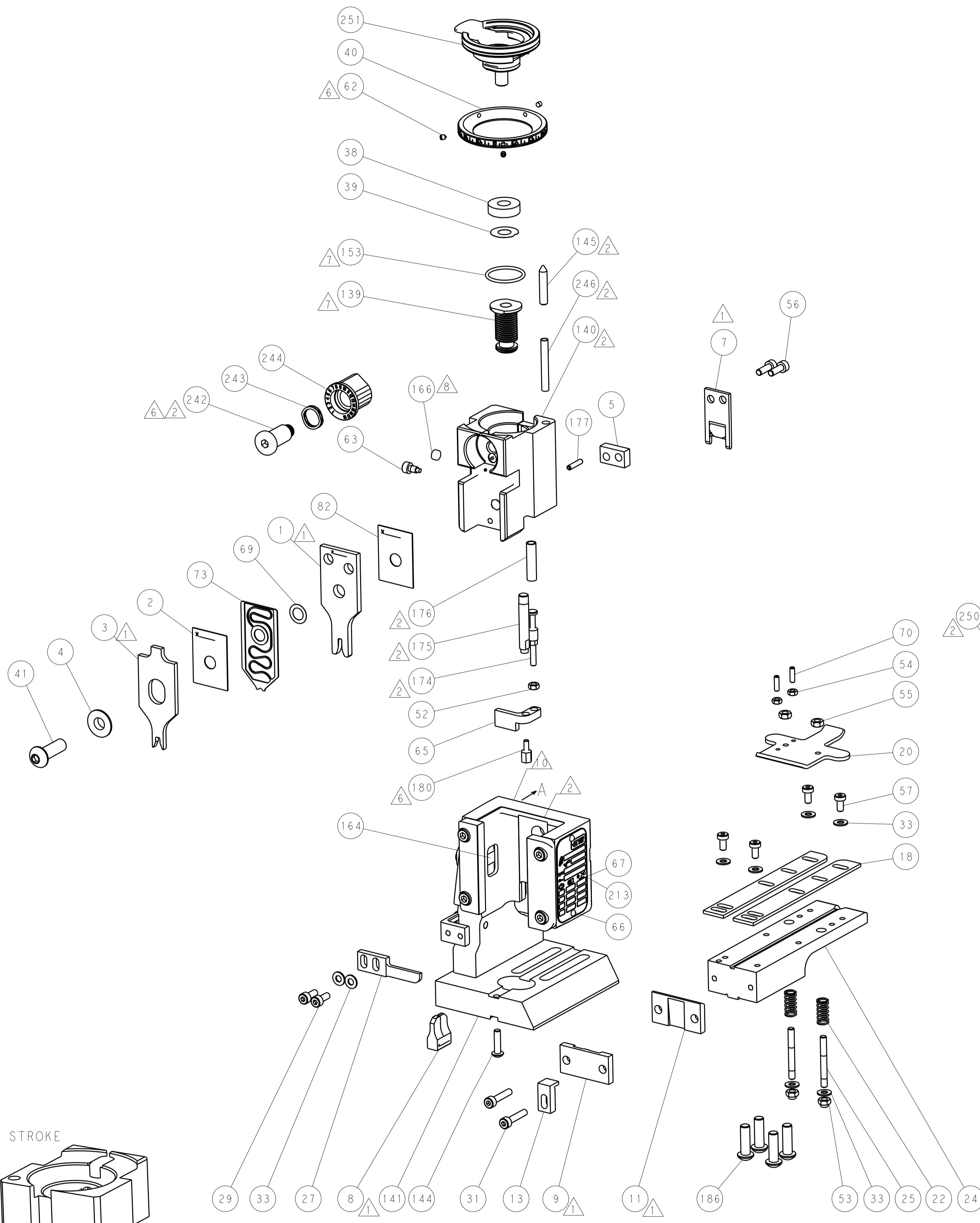
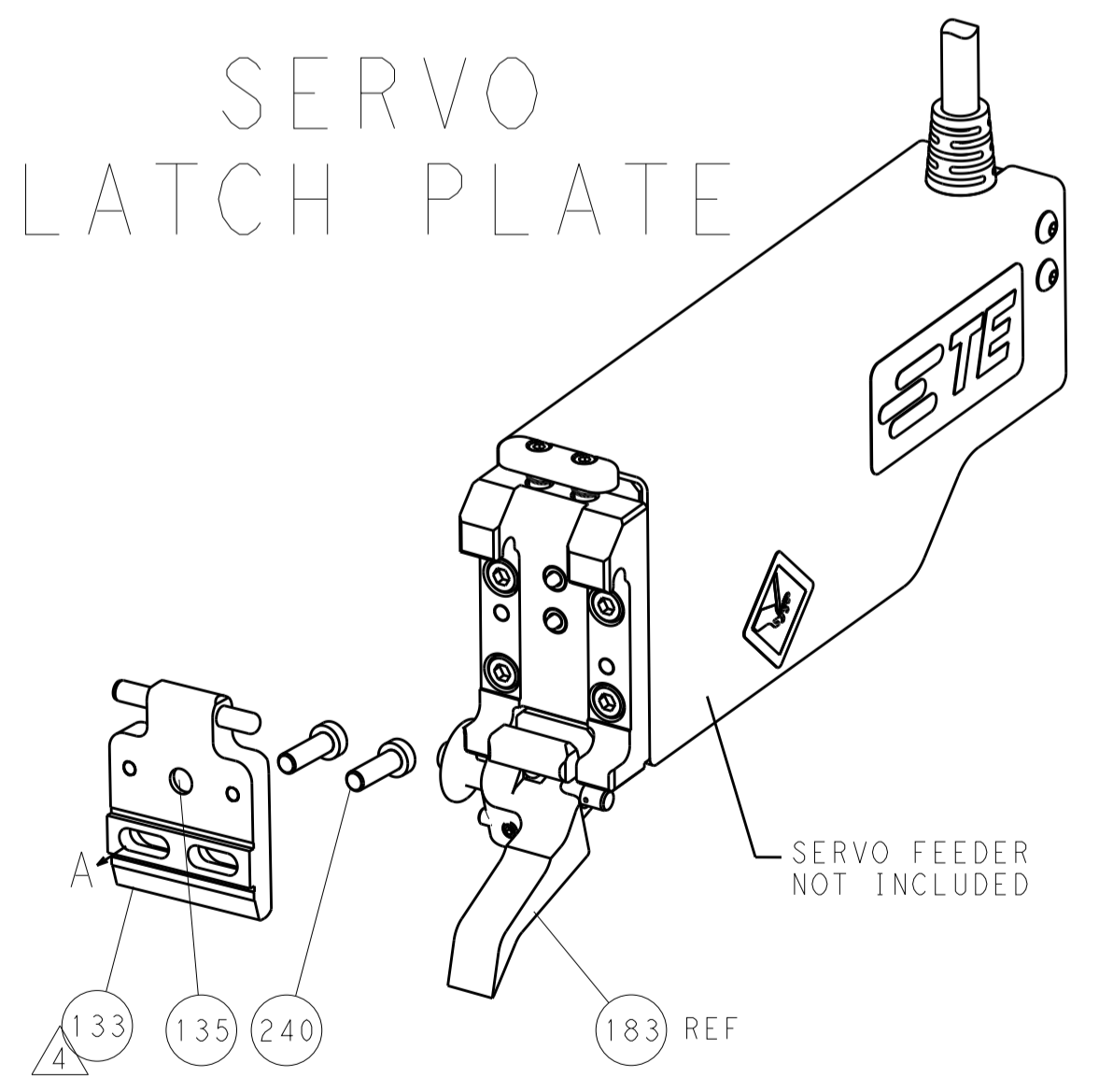
FEED TYPE  
MECHANICAL



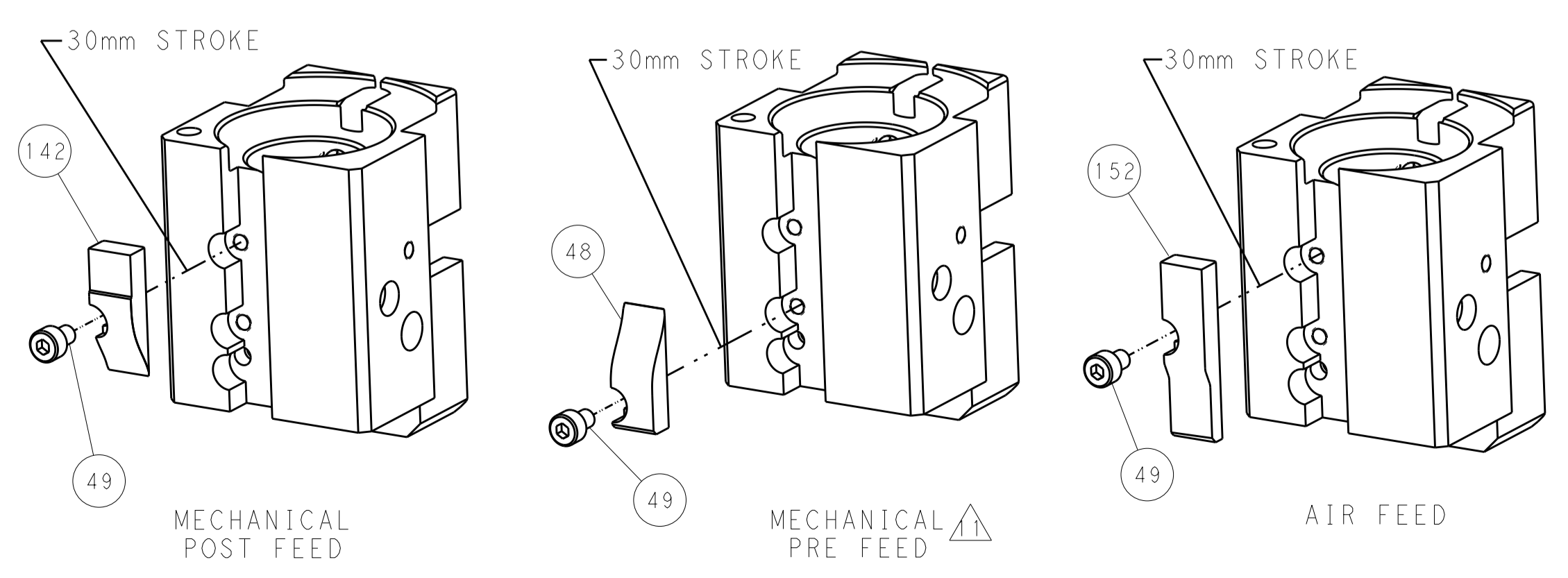
PNEUMATIC



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 X ZHAO 12APR2013		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±
	ANGLES	FINISH		NAME		RESTRICTED TO	
MATERIAL				Ocean End Feed Applicator			
				SIZE CAGE CODE DRAWING NO		A1 00779 C=2150334	
				WEIGHT		SCALE 1:1 SHEET 4 OF 4 REV A1	
Customer Accessible Production Drawing				Customer Accessible Production Drawing			