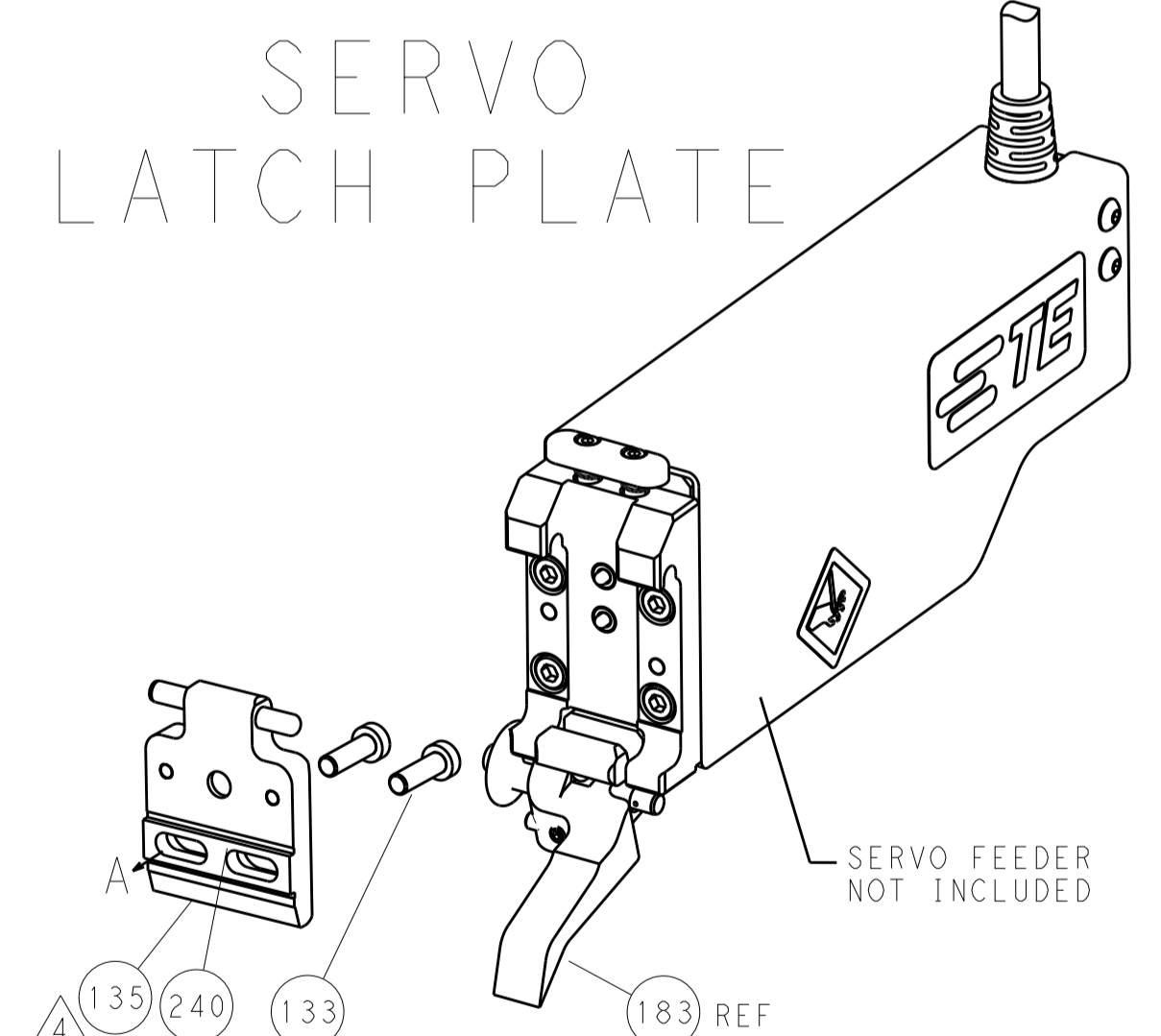
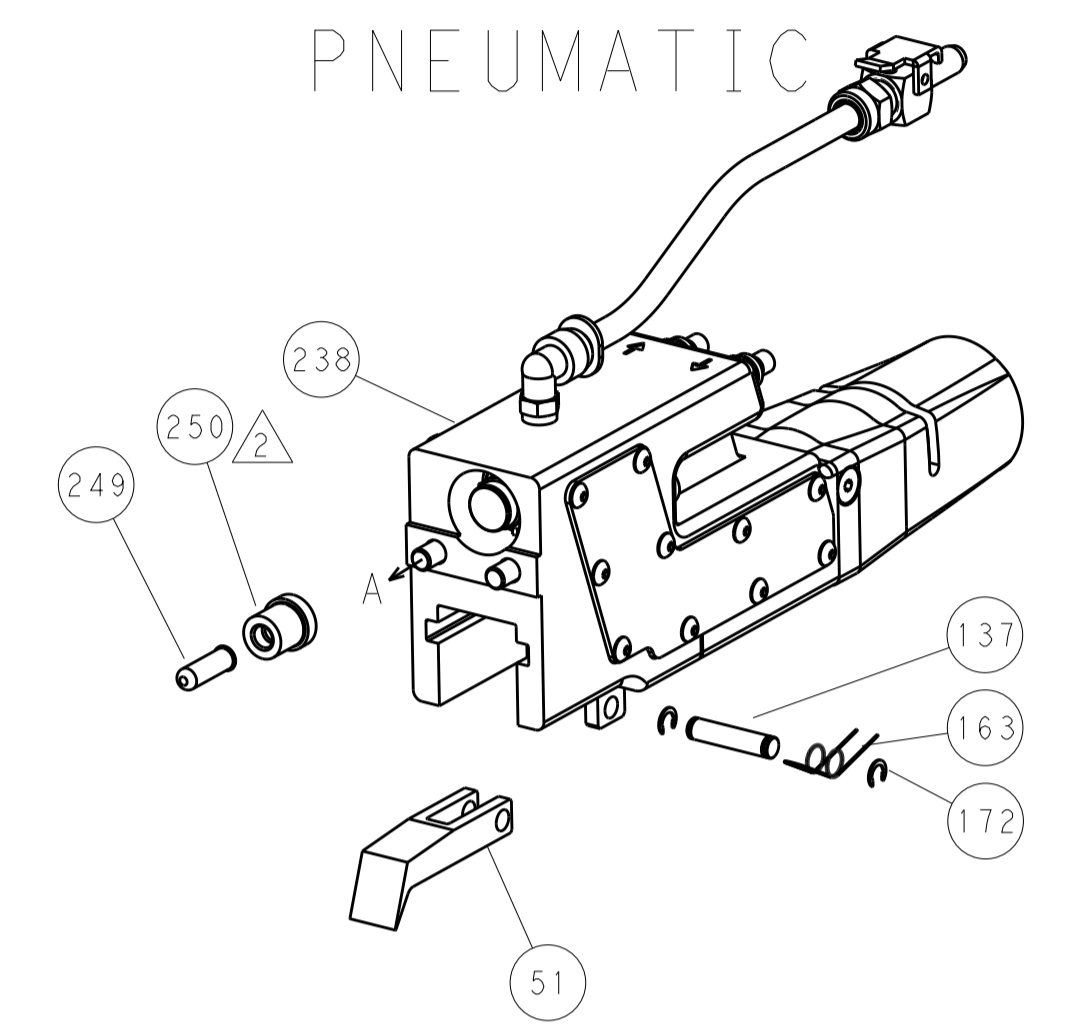


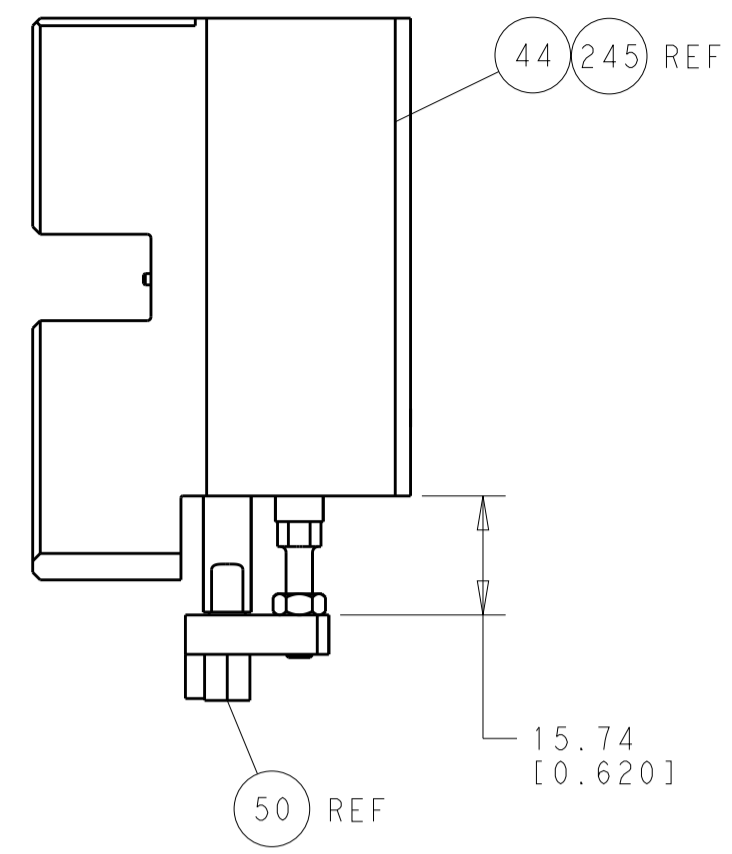
LOC	DIST	REV	DATE	BY	APPV
A	66				

FEED TYPE

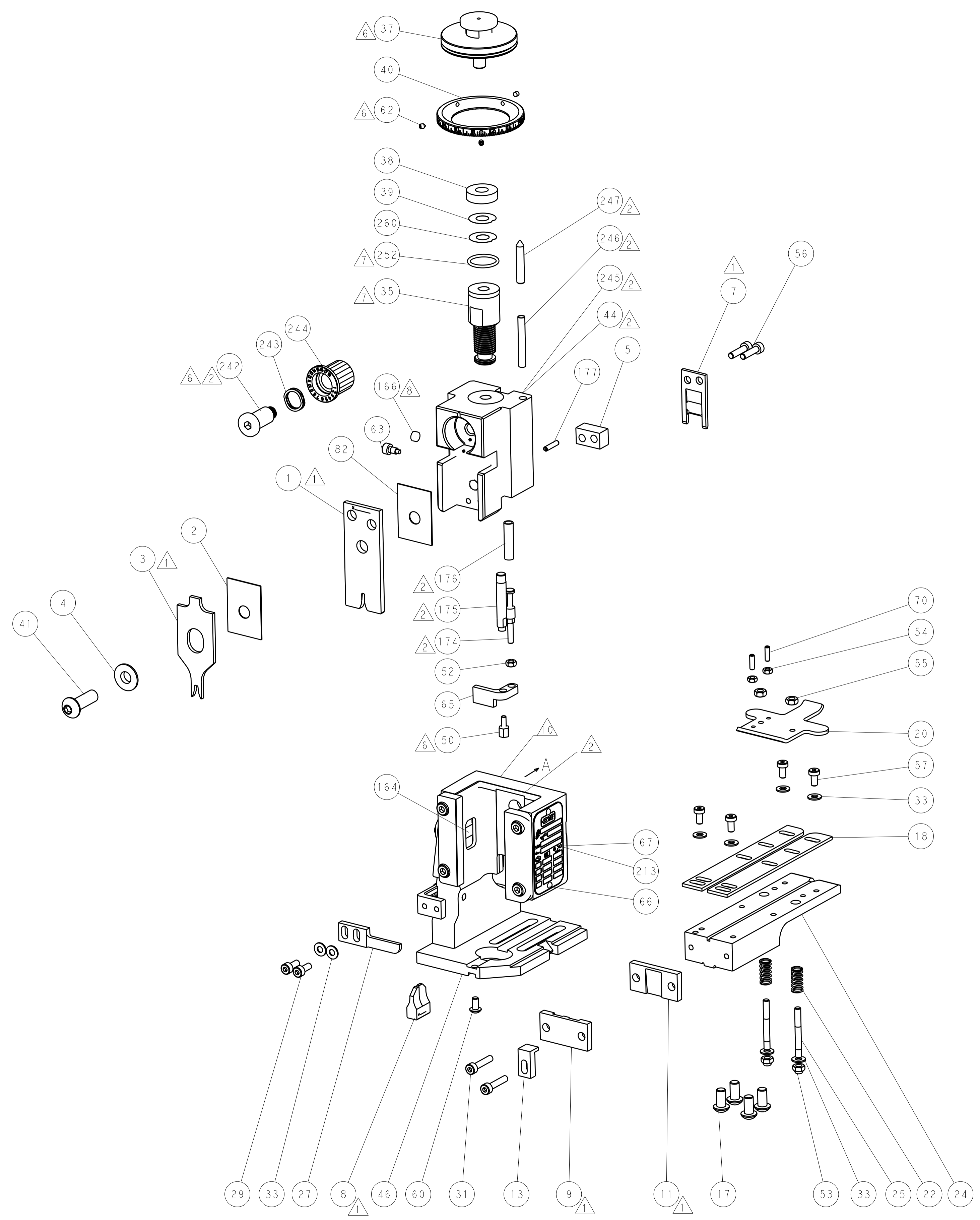
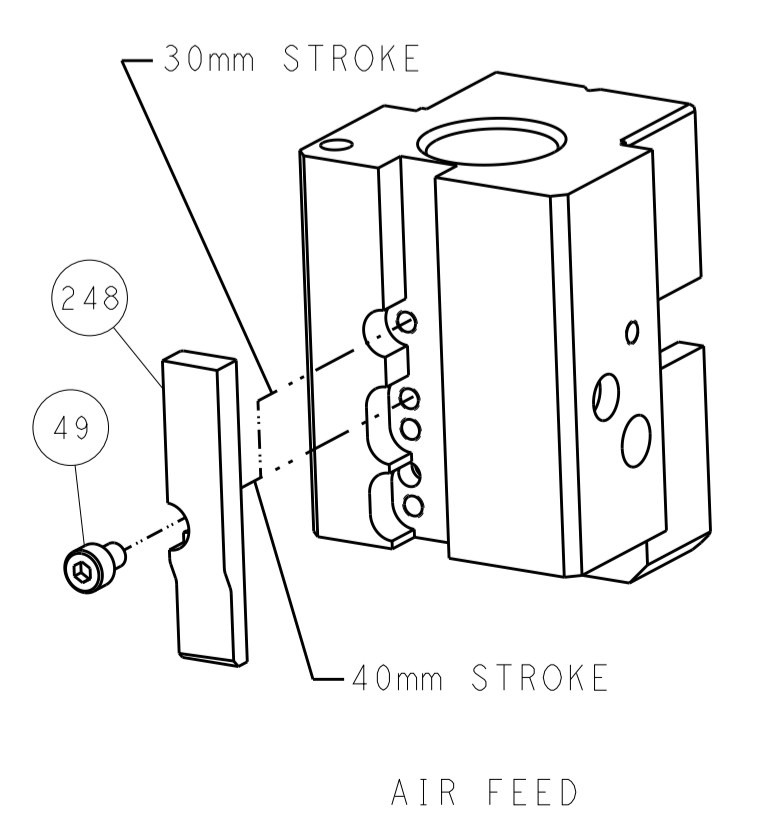
PNEUMATIC



HOLDDOWN SET-UP

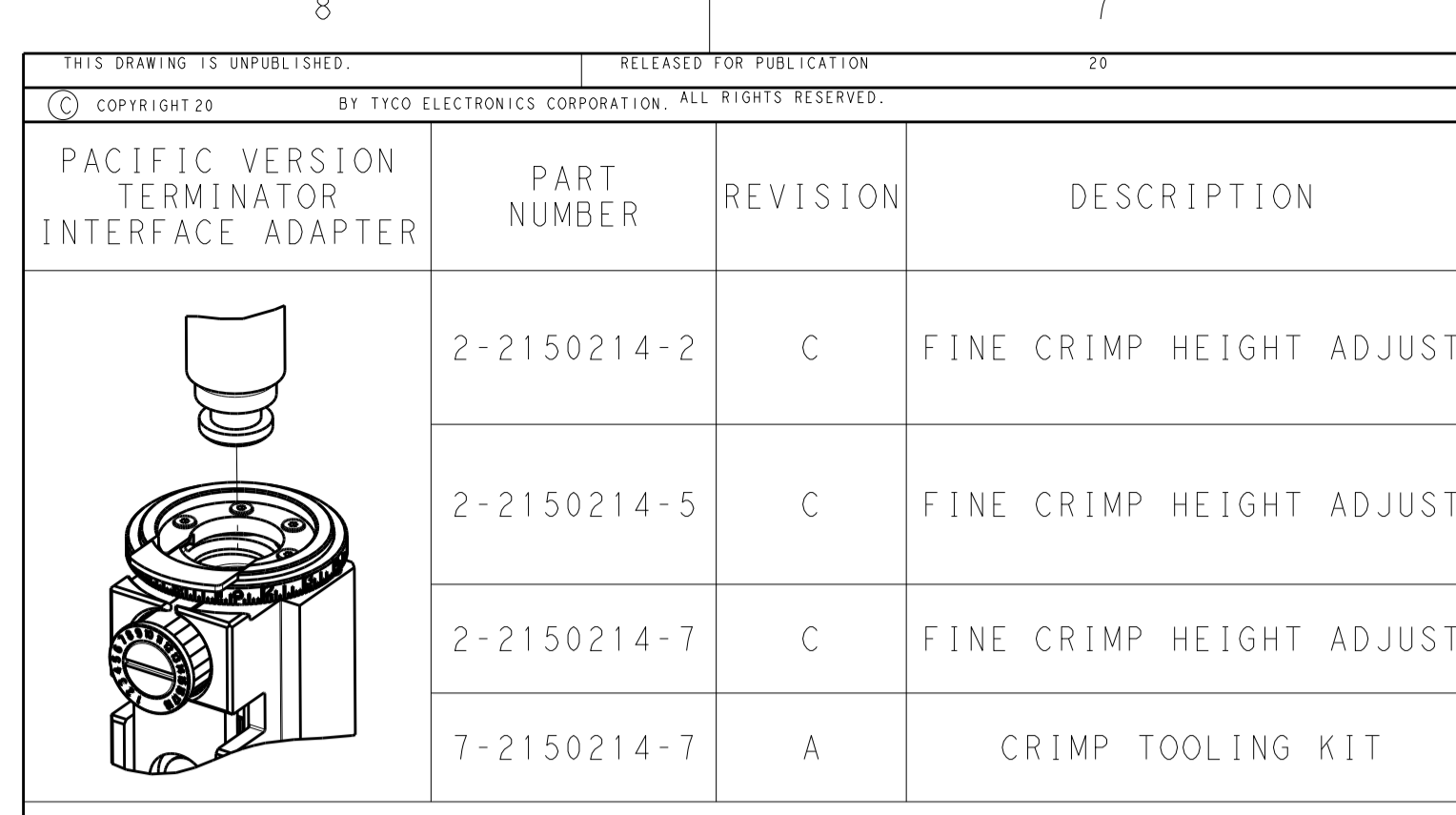


CAM POSITION



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

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		DWN Y. YIN 23MAR2012 CHK G. BAILEY 23MAR2012 APVD S. XI 23MAR2012		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2150214	
MATERIAL		FINISH		WEIGHT		SCALE 1:1 SHEET 2 OF 4 REV C	



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.79 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE M.I.C. IV			
WIRE STRIP LENGTH 4.58-4.59 mm [.180-.181 IN]		INSULATION DIAMETER RANGE Ø1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-15036	-	-
	(B)114-15003	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 144180-1	(B) 142183-2	(B) 142183-5	(B) 3-142183-1
(A) 142647-1	(B) 142183-3	(B) 1-142183-1	
(B) 142183-1	(B) 142183-4	(B) 2-142183-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.48+/-0.050 [.058+/- .002]	6.9
0.35+0.6	1.48+/-0.050 [.058+/- .002]	6.9
0.75mm2	1.41+/-0.050 [.056+/- .002]	7.5
0.35+0.35	1.36+/-0.050 [.054+/- .002]	8.1
0.60mm2	1.32+/-0.050 [.052+/- .002]	8.5
0.50mm2	1.27+/-0.050 [.050+/- .002]	9.1
0.35mm2	1.21+/-0.050 [.048+/- .002]	9.7

- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150214-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150214-5
- 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 50, 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

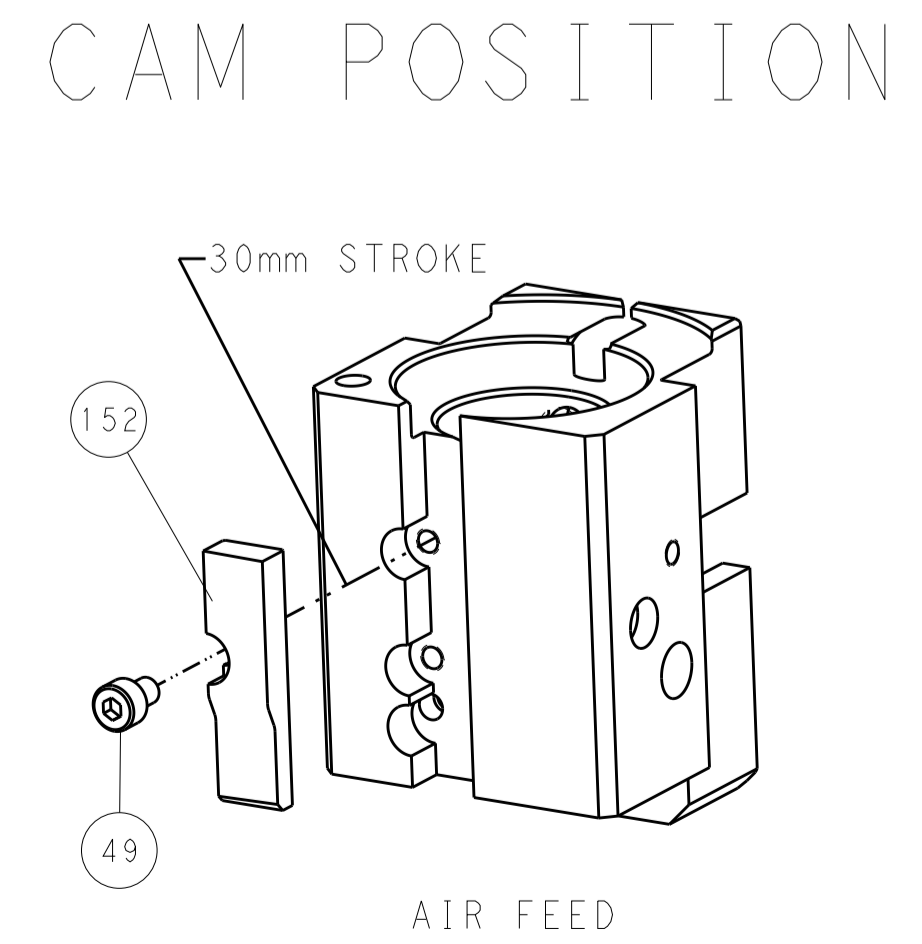
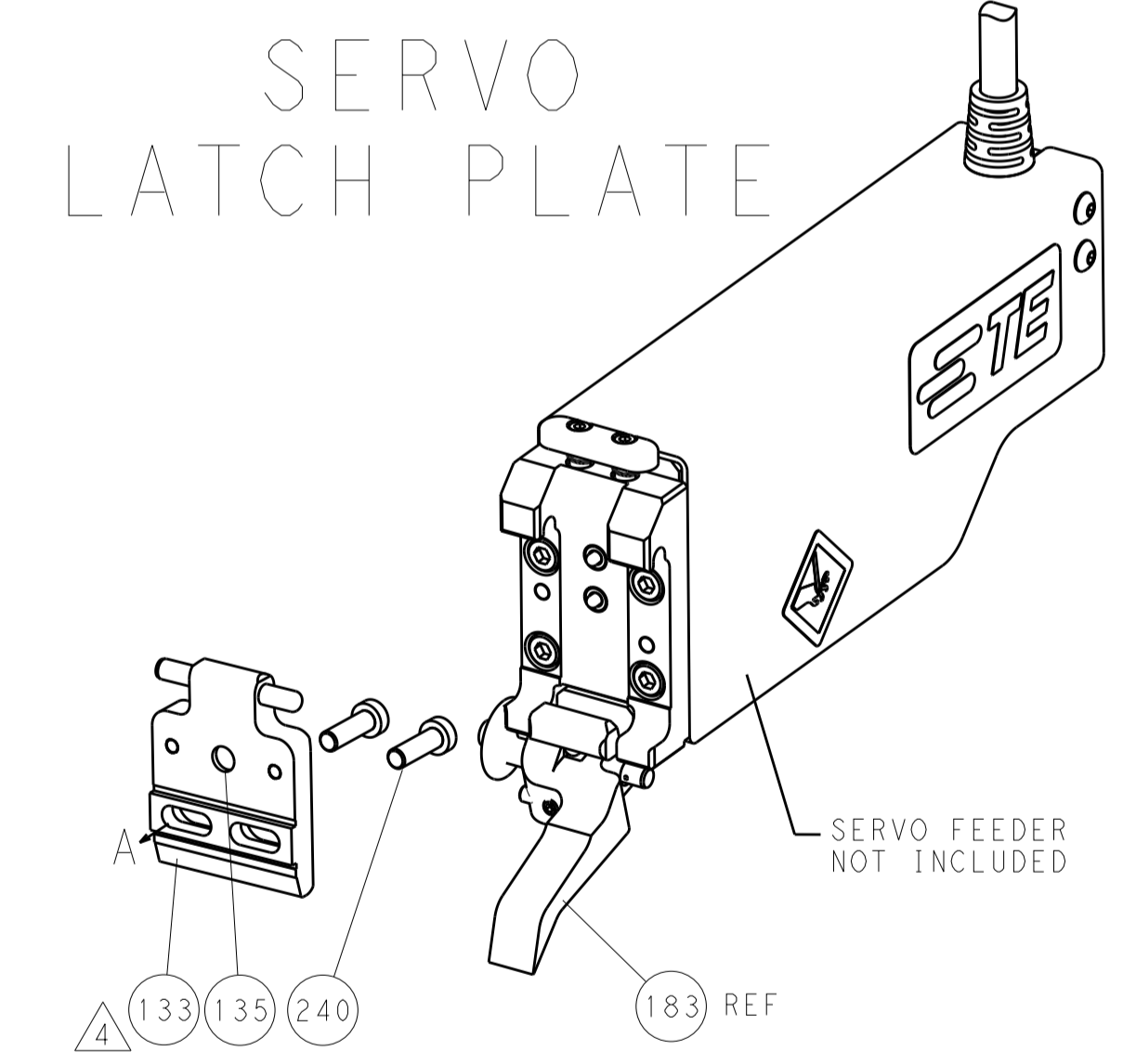
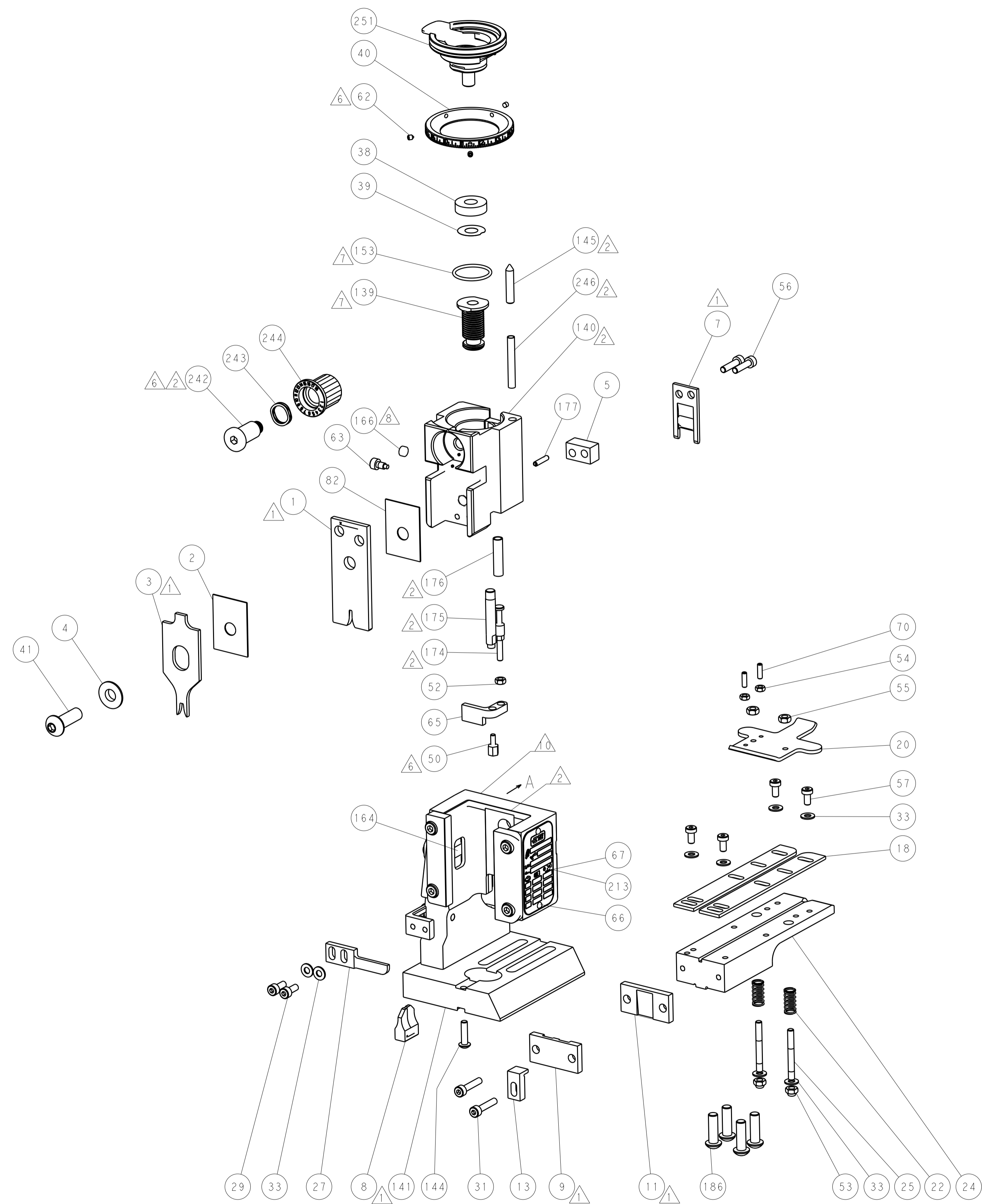
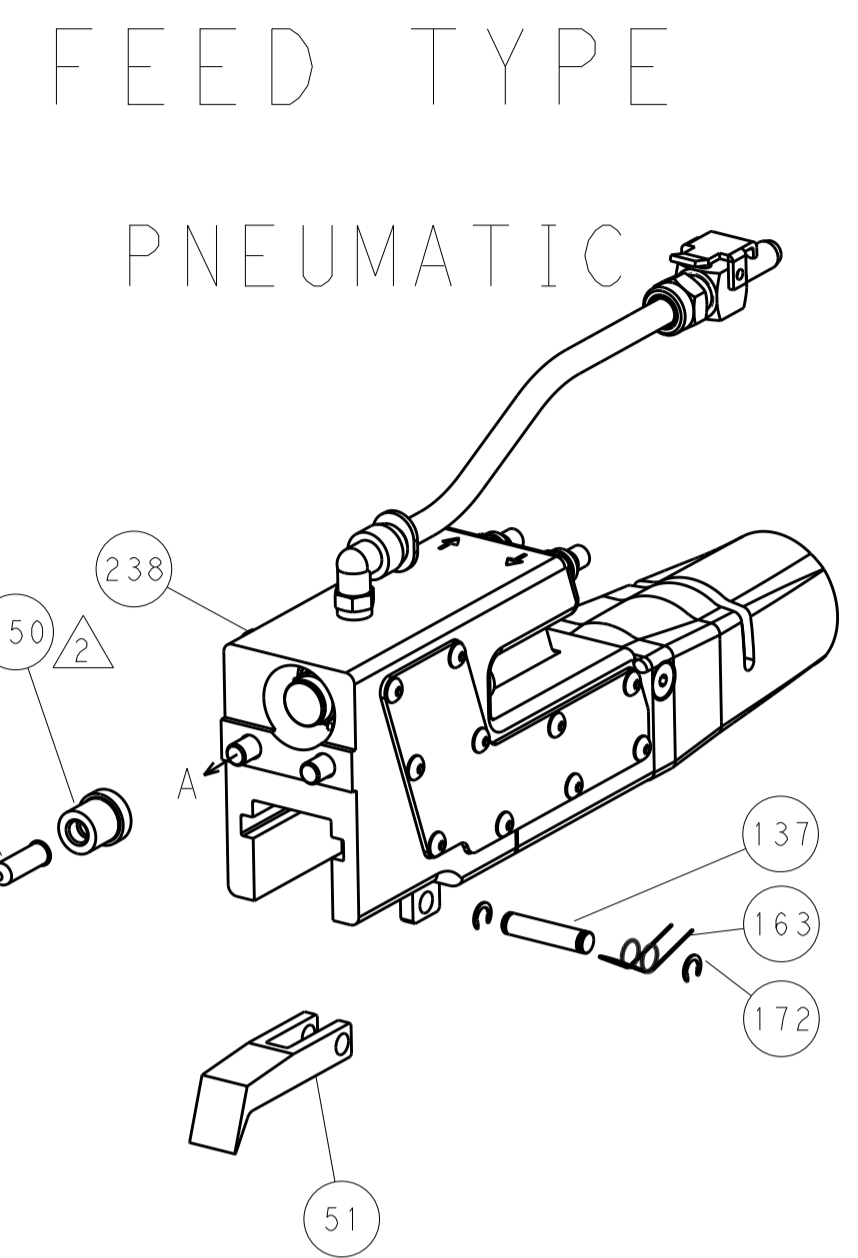
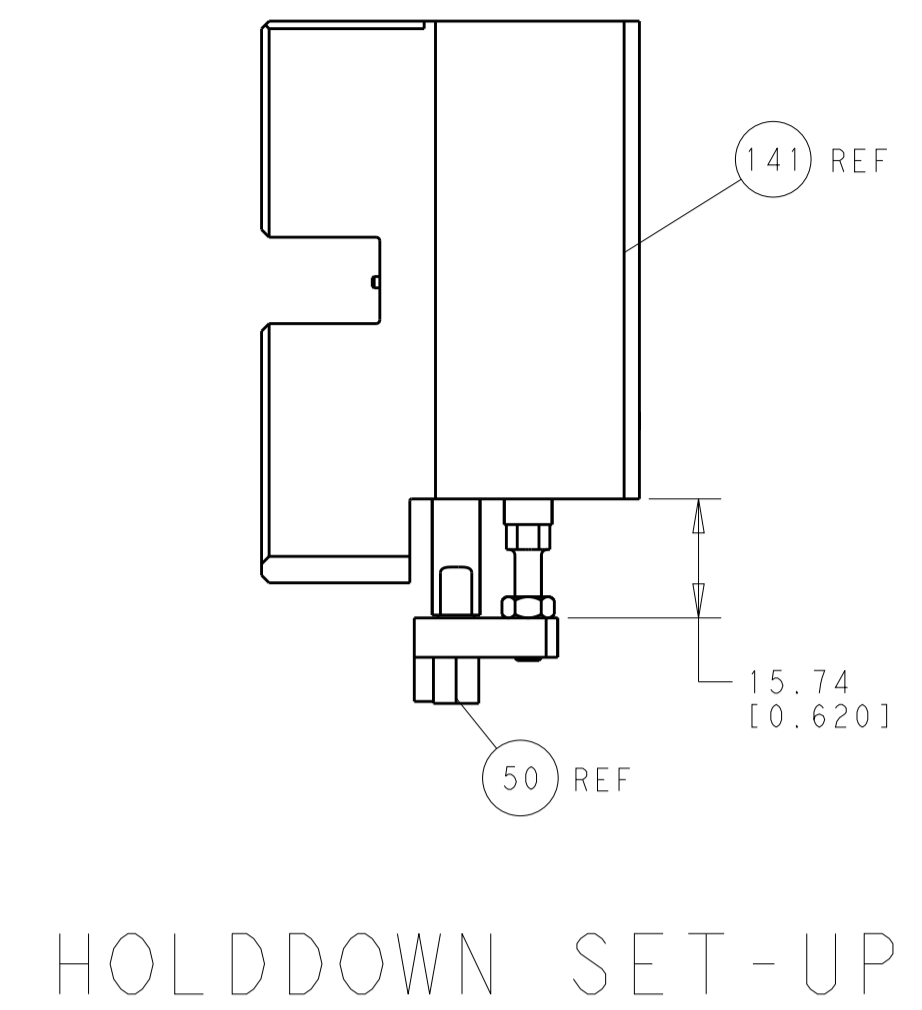
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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	2079988-1	BUSHING, LCH5-12, MISUMI		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	2063440-2	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	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
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT		63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0		62
-	4	4	4	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	1752354-9	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	2119644-1	RAM WASHER, PRECISION		38
-	8	8	8	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	2-1752371-0	PLATE, STRIP GUIDE		24
-	2	2	2	2-22281-3	SPRING, COMPRESSION		22
-	1	1	1	1752373-1	DRAG		20
-	2	2	2	1901259-4	GUIDE, LOWER STRIP		18
-	1	1	1	1752360-1	SPACER, HOLD-DOWN		13
-	1	1	1	240644-1	PLATE, REAR SHEAR		11
-	1	1	1	690482-5	PLATE, FRONT SHEAR		9
-	1	1	1	1338686-1	ANVIL, COMBINATION		8
-	1	1	1	690474-5	BLADE, SLUG		7
-	1	1	1	5-240641-5	SPACER		5
-	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER		4
-	1	1	1	4-2119582-5	CRIMPER, INSULATION F PREMIUM		3
-	1	1	1	455888-5	SPACER, CRIMPER		2
-	1	1	1	456418-2	CRIMPER, WIRE, .070 "F"		1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		DATE	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	ANGLES ±.0001	FINISH
MATERIAL				DWG		DATE	
				Y. YIN		23MAR2012	
				G. BAILEY		23MAR2012	
				S. XI		23MAR2012	
				NAME		TE Connectivity	
				PRODUCT SPEC		Harrisburg, PA 17105-3608	
				APPLICATION SPEC		Ocean End Feed Applicator	
				SIZE		CAGE CODE	
				A1		00779	
				DRAWING NO		C=2150214	
				WEIGHT		SCALE	
				Customer Accessible Production Drawing		1:1	
				SHEET		3 OF 4	
				REV		C	

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



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 Y. YIN 23MAR2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0001	NAME	Ocean End Feed Applicator
MATERIAL:		FINISH:		CHK G. BAILEY 23MAR2012	APVD S. XI 23MAR2012	SIZE	A1 00779 C=2150214
				Customer Accessible Production Drawing		SCALE	1:1 SHEET 4 OF 4 REV C

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