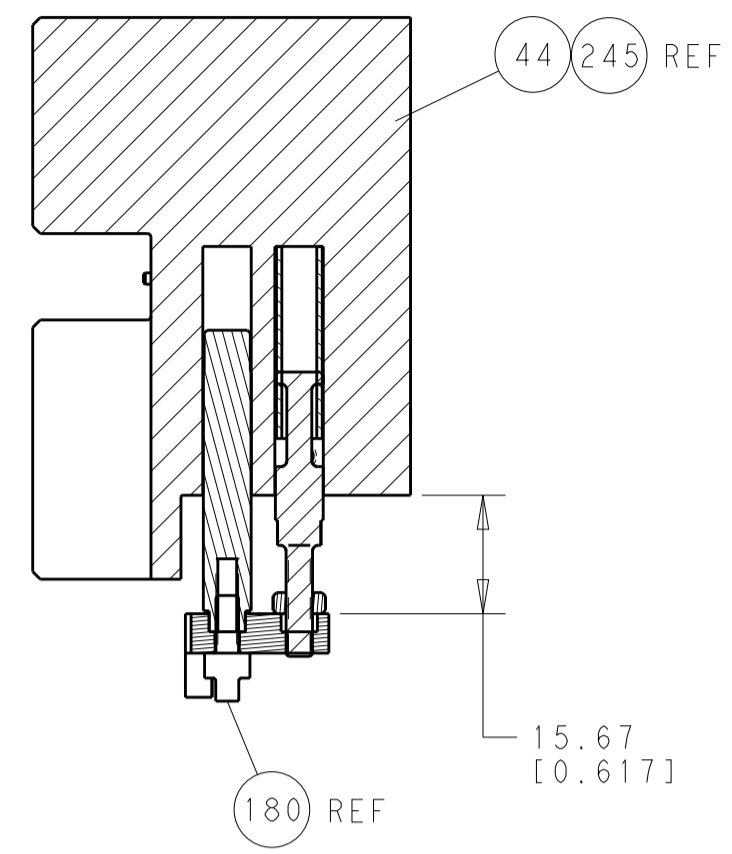
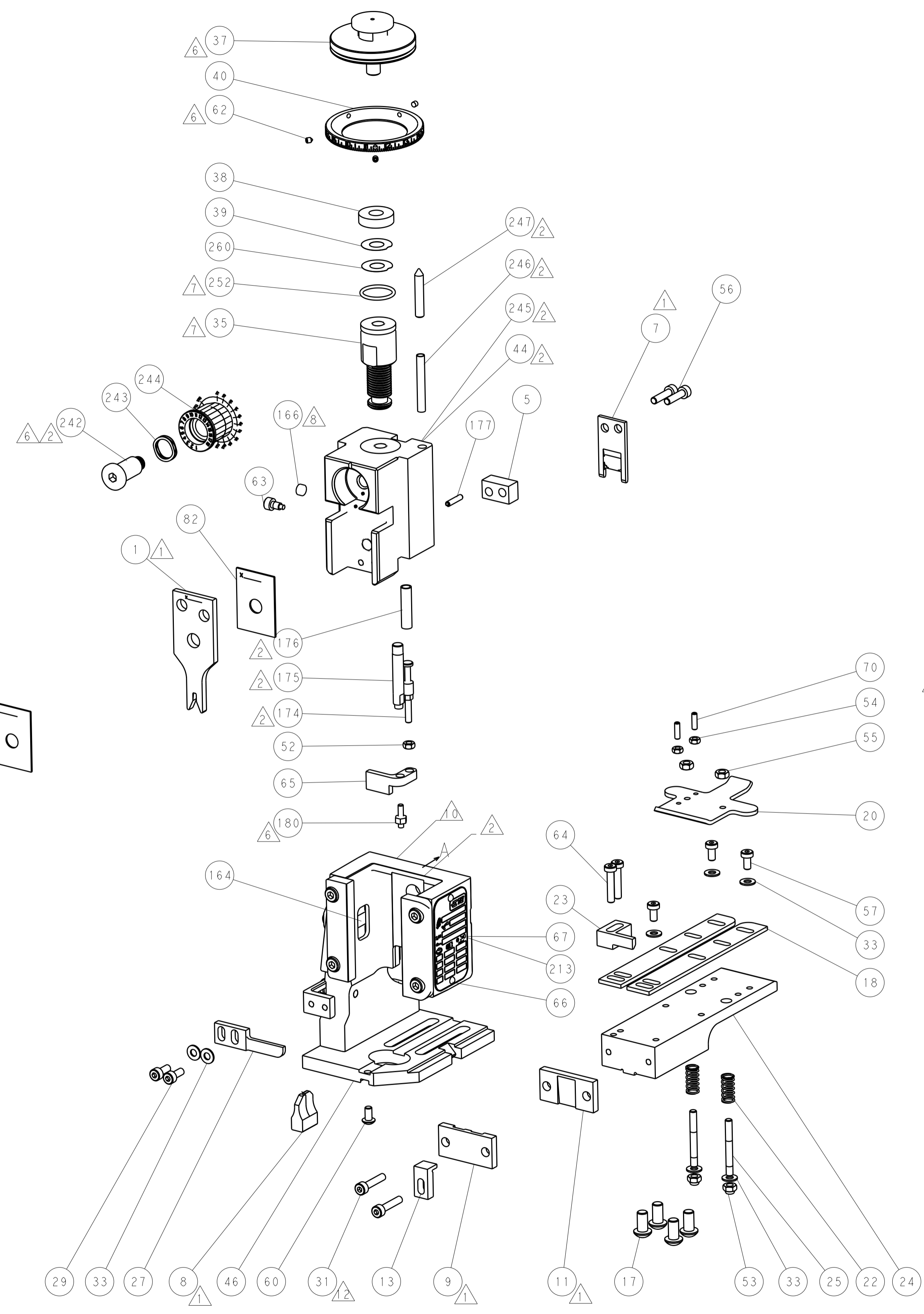


LOC	DIST	REV	DATE	BY	APPD
A	66				

REVISIONS			
REV	DATE	BY	APPD
-	-	-	-
-	-	-	-

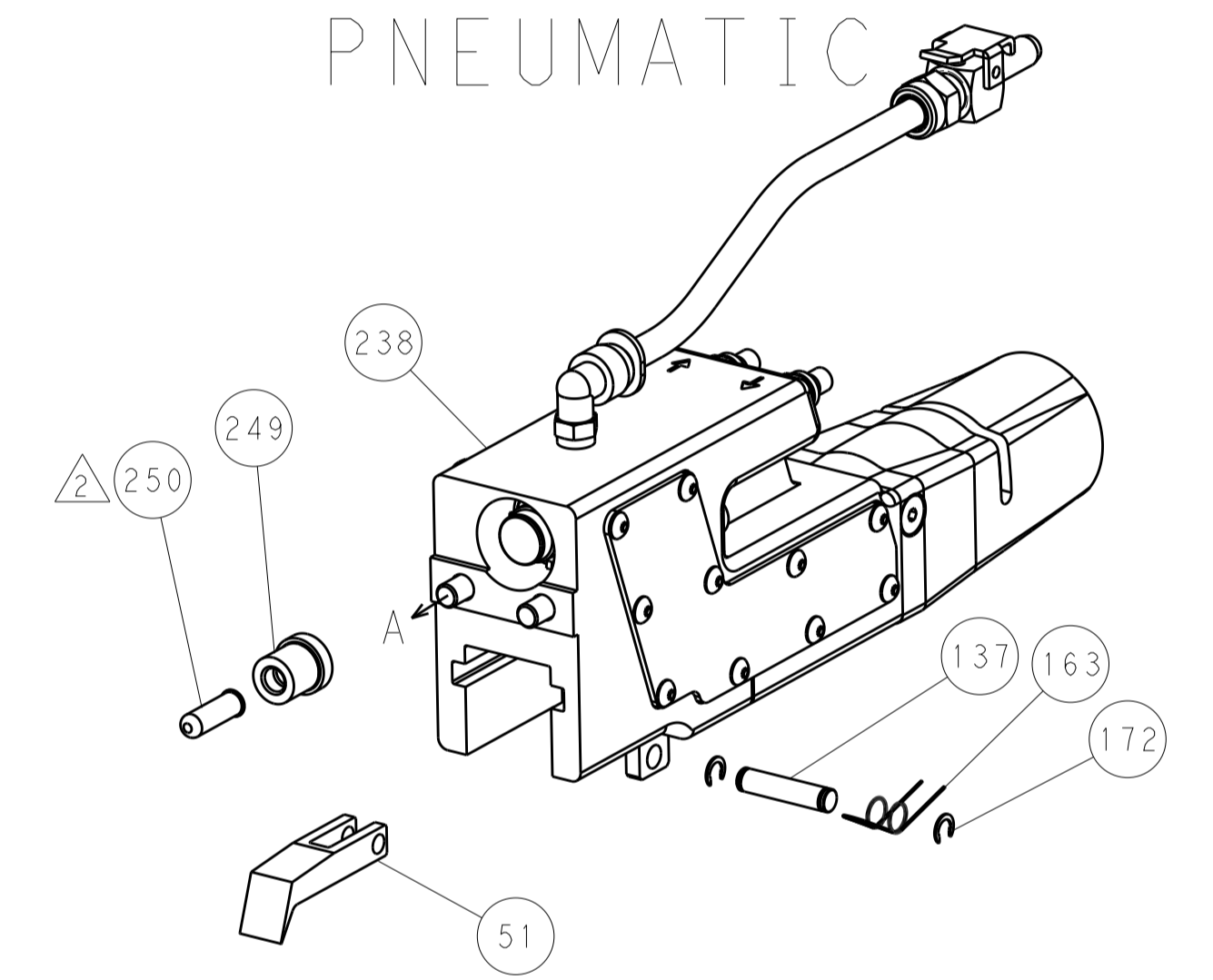


HOLDDOWN SET-UP

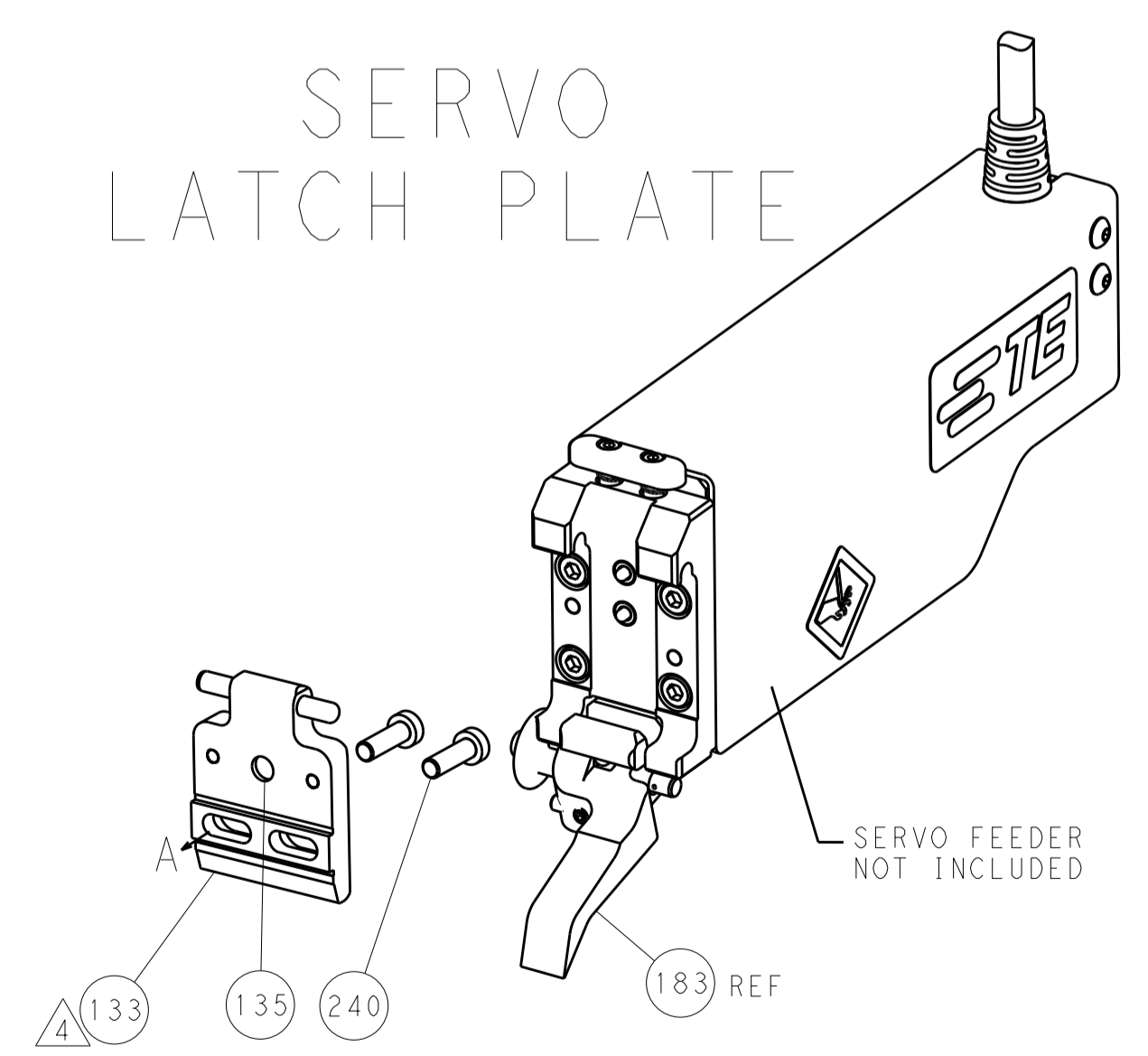


FEED TYPE

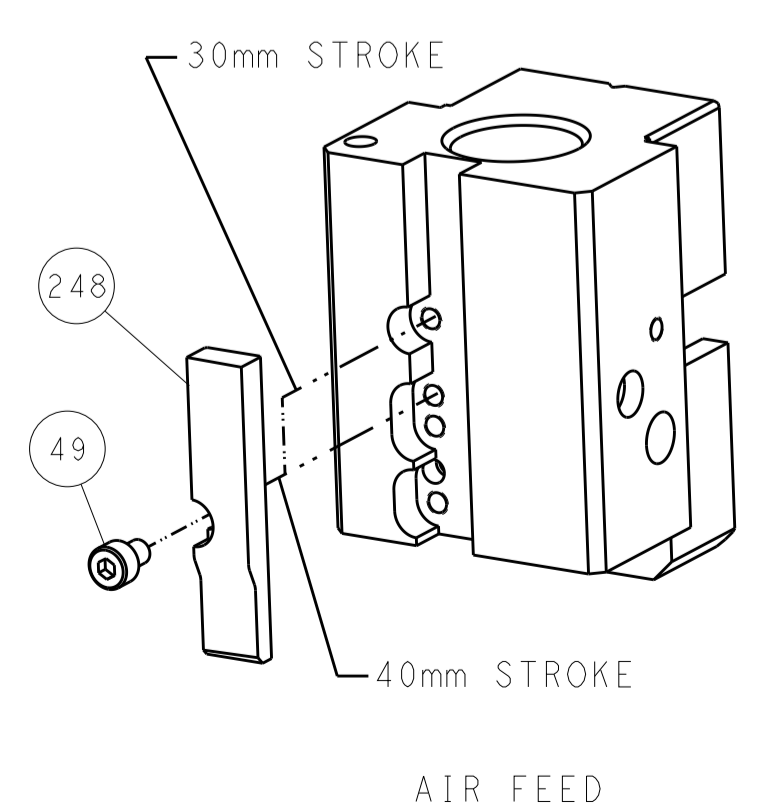
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



AIR FEED

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 ±0.5 1 PLC ±0.13 2 PLC ±0.013 3 PLC ±0.001 4 PLC ±0.001 ANGLES ±0.001		DWN B WEAVER 26 JUN 2015 CHK G. BAILEY 26 JUN 2015 APVD G. BAILEY 26 JUN 2015		NAME Ocean End Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2150584	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 2 OF 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150584-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150584-5	-	-
	2-2150584-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-
2-2150584-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150584-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm (.080)	F
INSUL	3.18 mm (.125)	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: EURAMTEC CORP TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.34-4.72 mm (.171-.186 IN)		INSULATION DIAMETER RANGE ∅ 1.68-2.54 mm (.066-.100 IN)	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED ¹⁰			
TE TERMINAL	EURAMTEC CORP TERMINAL	TE TERMINAL	EURAMTEC CORP TERMINAL
1949348-1	W-ST-200		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
16 AWG	1.49 +/- 0.05 [.059 +/- .002]	6.3
18 AWG	1.31 +/- 0.05 [.052 +/- .002]	8.4
20 AWG	1.18 +/- 0.05 [.046 +/- .002]	9.6

- 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: 8-2150584-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150584-5
- 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.
- 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.
- 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.
- ¹² 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.

-	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	ITEM NO

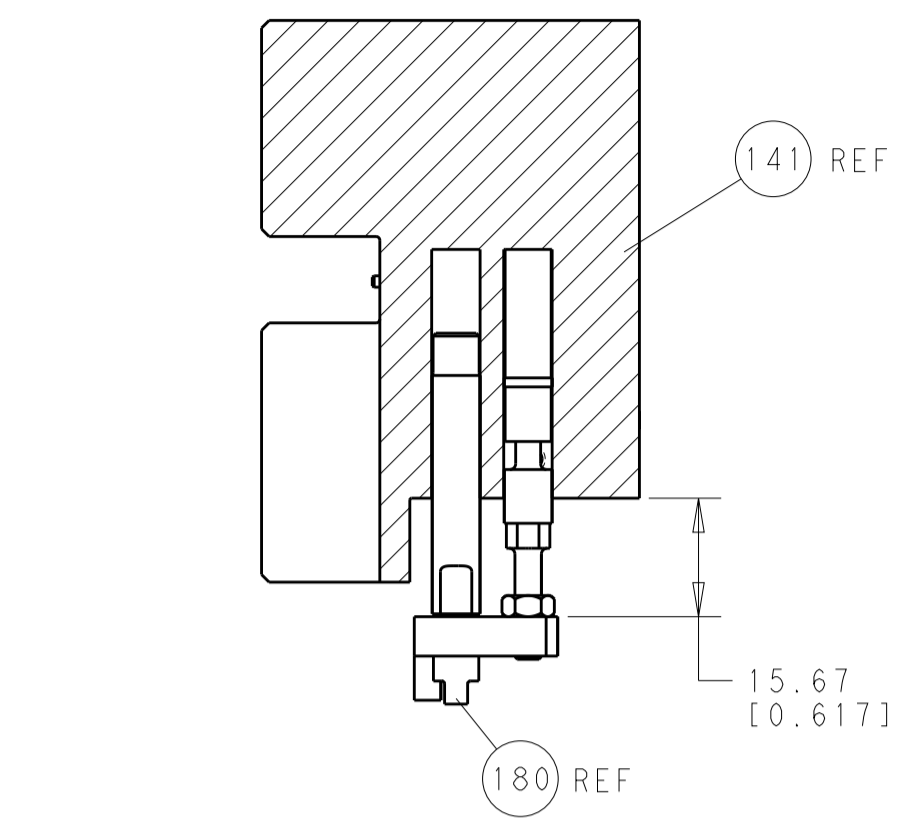
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

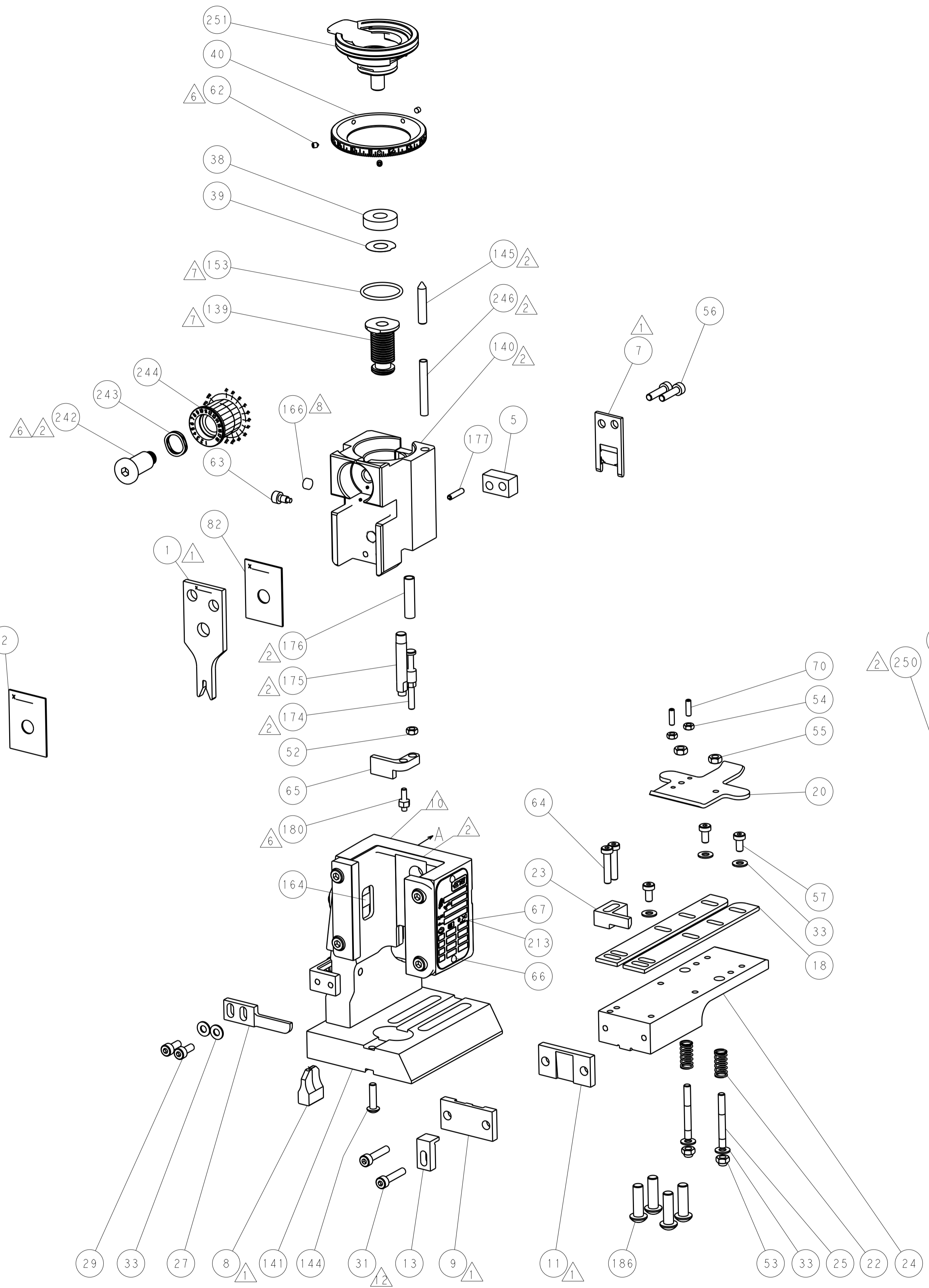
⁶	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	1	2063440-2	AIR FEED MODULE	238
	-	-	-	-	2119740-2	TAG, IDENTIFICATION	213
	-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
⁶	-	1	1	1	1-1976055-0	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
	-	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
	-	-	-	-	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	455888-8	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
¹²	-	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	240825-1	PLATE, STRIP HOLD DOWN	23
	-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1752373-4	DRAG	20
	-	2	2	2	1-1901259-0	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	690482-5	PLATE, FRONT SHEAR	9
¹	1	1	1	1	8-1803000-4	ANVIL, COMBINATION, END FEED	8
¹	-	1	1	1	2217206-7	BLADE, SLUG	7
	-	-	-	-	-	-	6
	-	1	1	1	6-240641-0	SPACER	5
	-	1	1	1	1-238009-4	BLOCK, FL CRIMPER SPACER	4
¹	1	1	1	1	6-1803017-6	CRIMPER, INSULATION F	3
	-	1	1	1	455888-7	SPACER, CRIMPER	2
¹	1	1	1	1	6-1633860-2	CRIMPER, WIRE	1
-77-27-25-22					PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 26JUN2015		CHK: G. BAILEY 26JUN2015		APVD: G. BAILEY 26JUN2015		NAME: Ocean End Feed Applicator	
0 PLC ±.5		1 PLC ±.13		2 PLC ±.05		3 PLC ±.013		4 PLC ±.0013		SIZE: A	
ANGLES ±.0001		FINISH		WEIGHT		SCALE: 1:1		SHEET: 3 OF 4		REV: A	
MATERIAL		FINISH		WEIGHT		SCALE: 1:1		SHEET: 3 OF 4		REV: A	

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



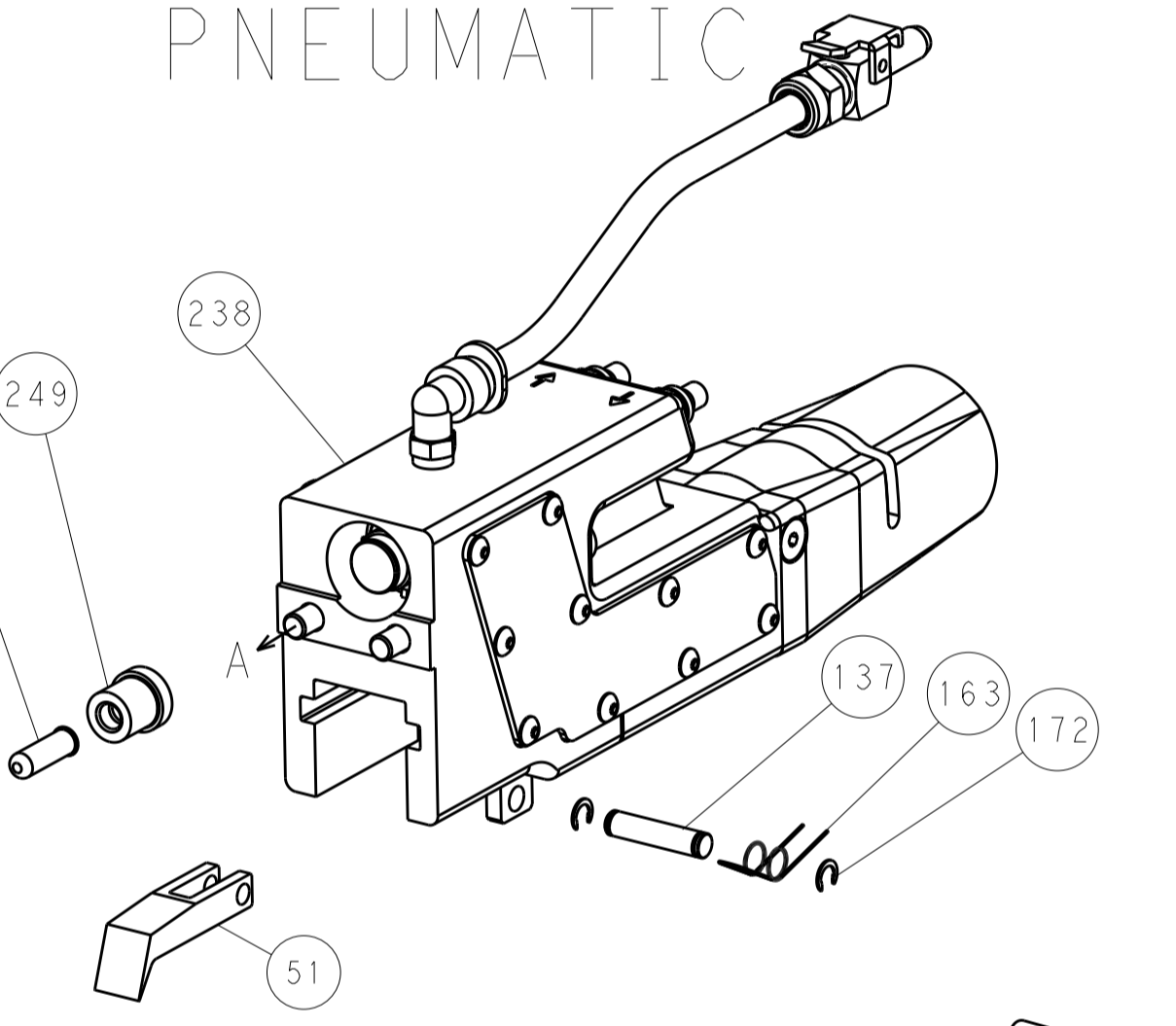
HOLDDOWN SET-UP



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

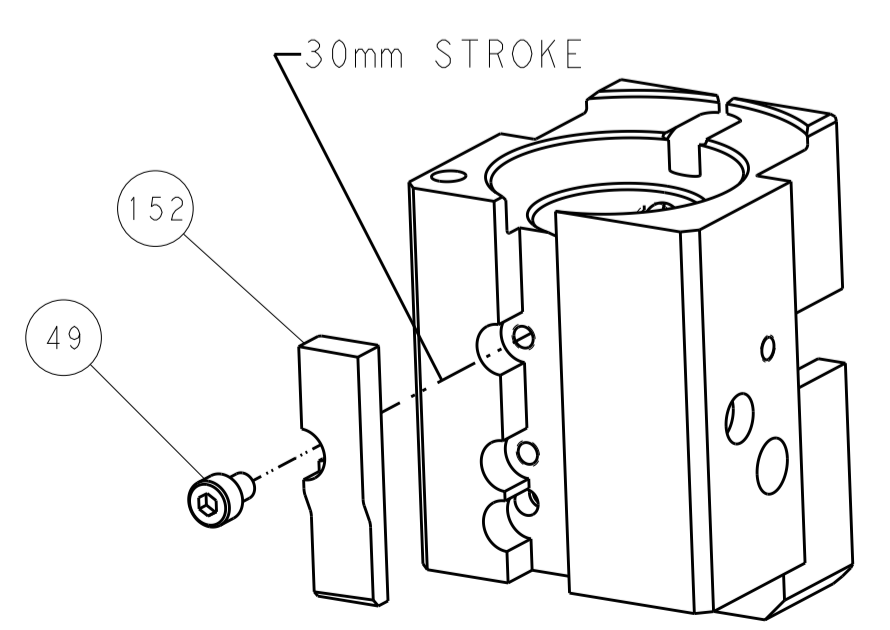
FEED TYPE

PNEUMATIC



SERVO LATCH PLATE

CAM POSITION



AIR FEED

<small>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OR LIABILITY. REVISIONS SHOULD BE CONTACTED FOR THE LATEST VERSION.</small>		DWN: B. WEAVER 26 JUN 2015 CHK: G. BAILEY 26 JUN 2015 APVD: G. BAILEY 26 JUN 2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:1	RESTRICTED TO: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150584 SHEET 4 OF 4 REV A
MATERIAL: FINISH:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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