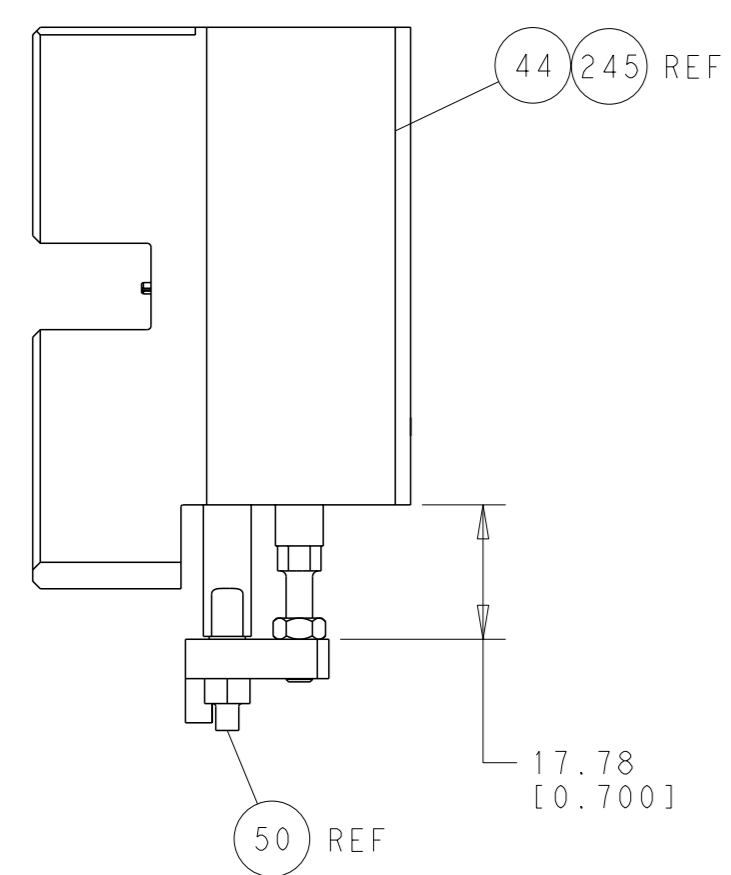


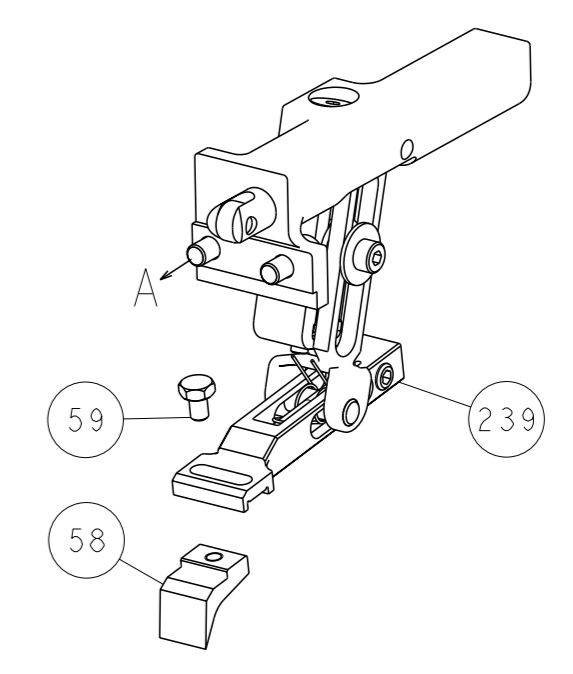
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

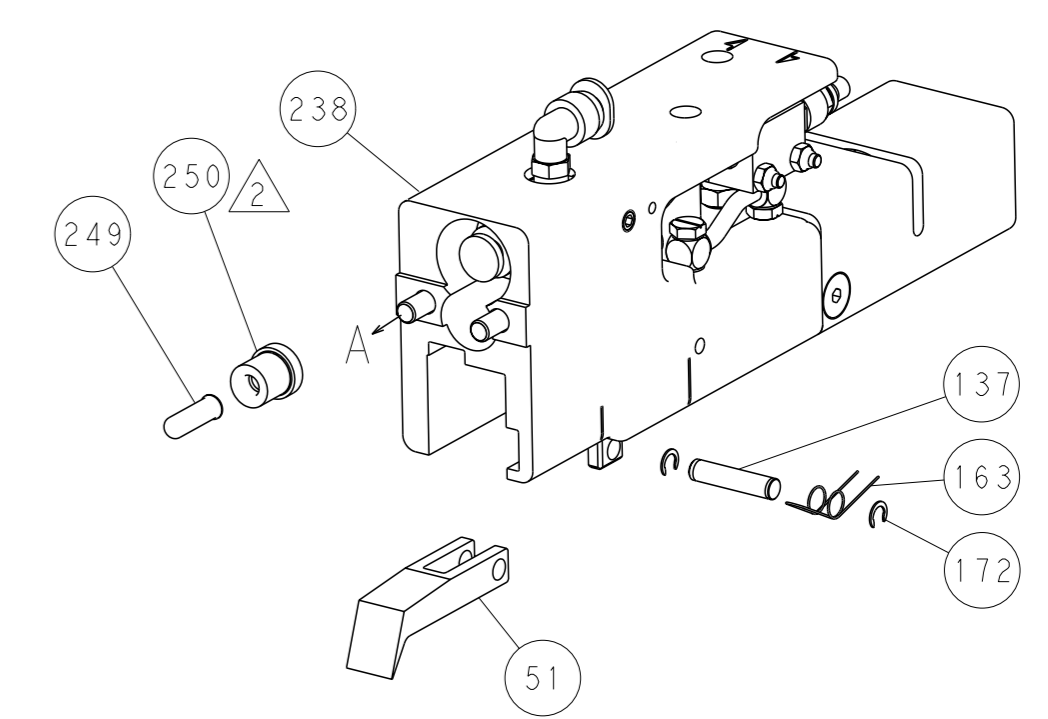


HOLDDOWN SET-UP

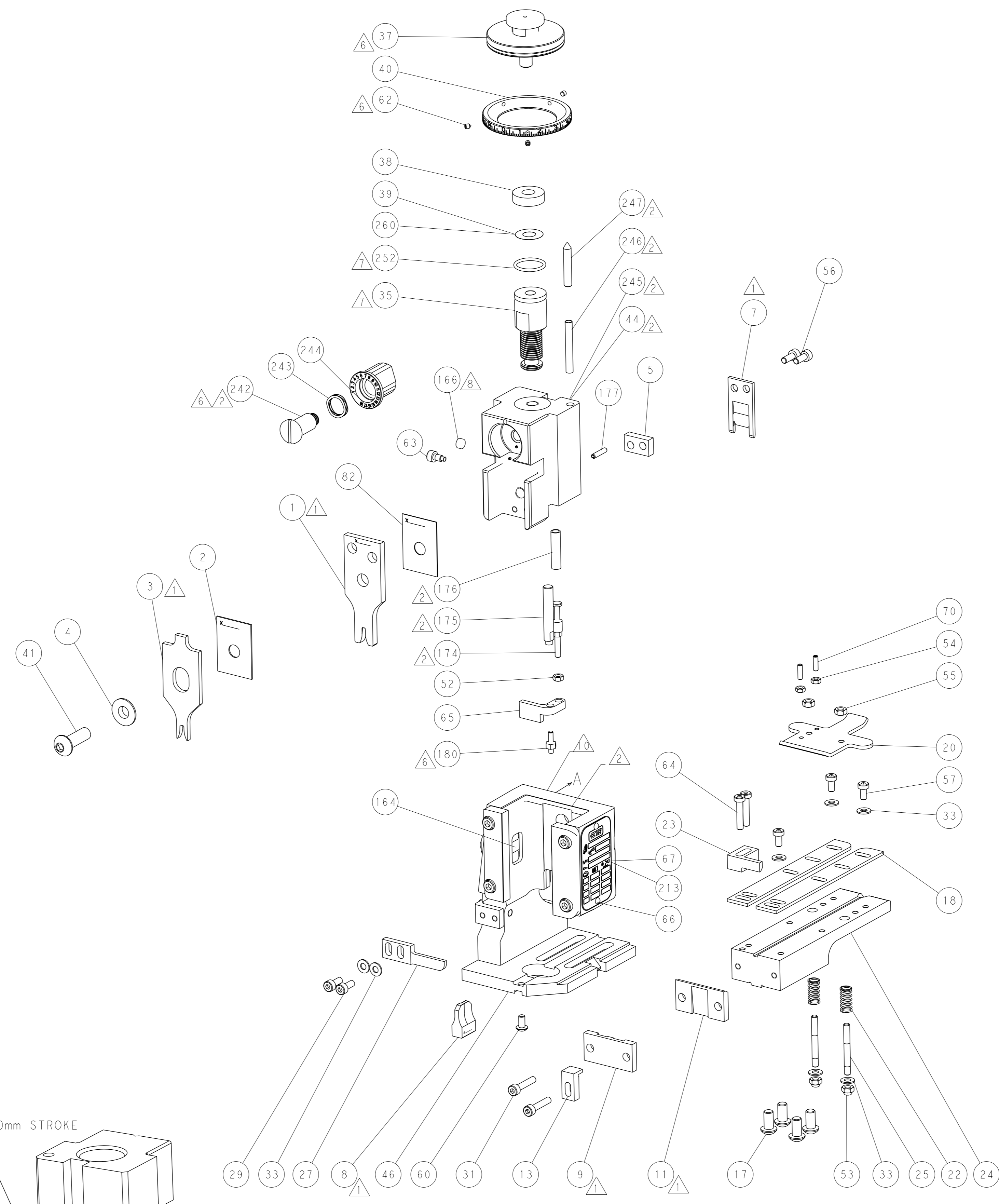
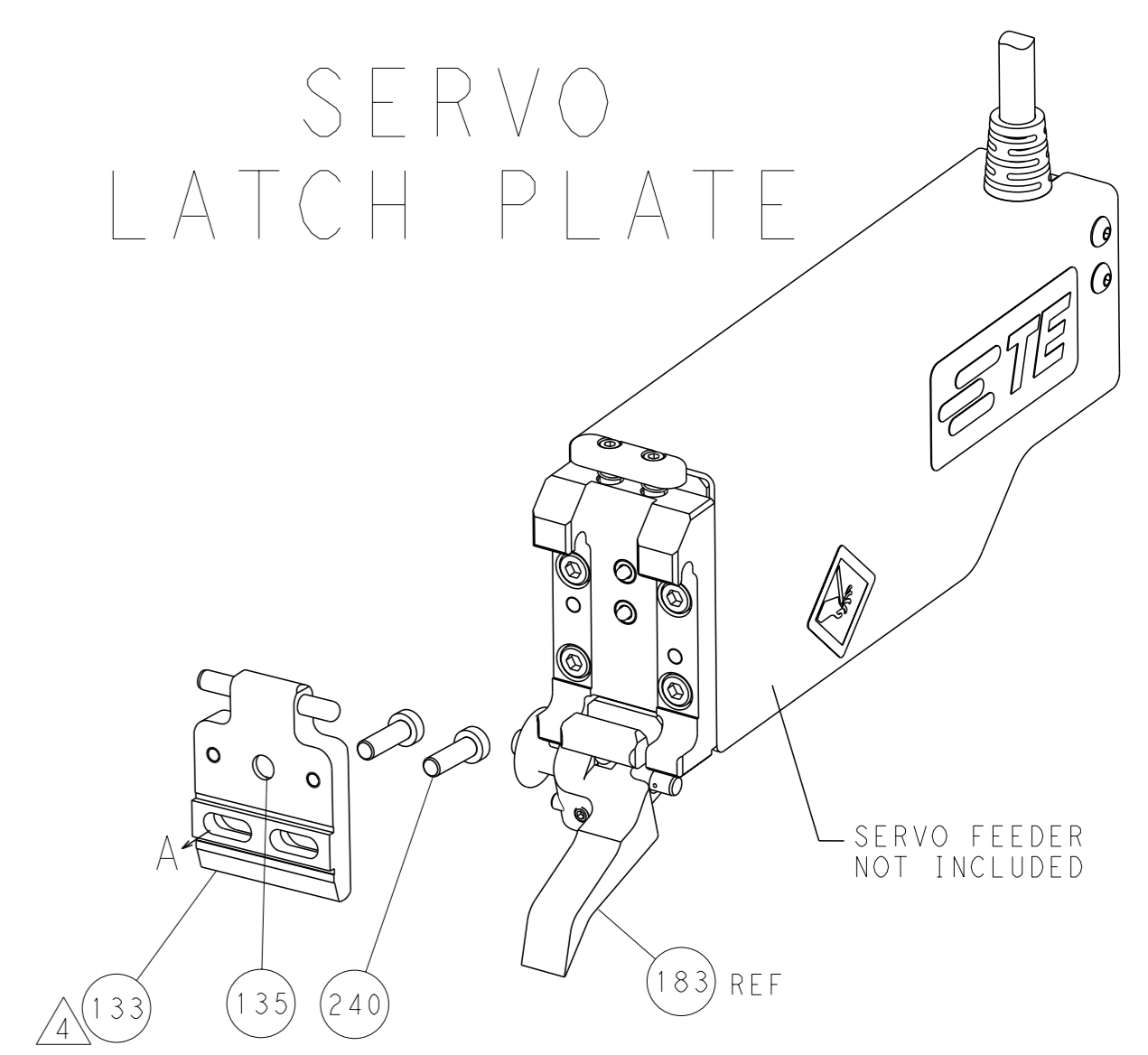
FEED TYPE
MECHANICAL



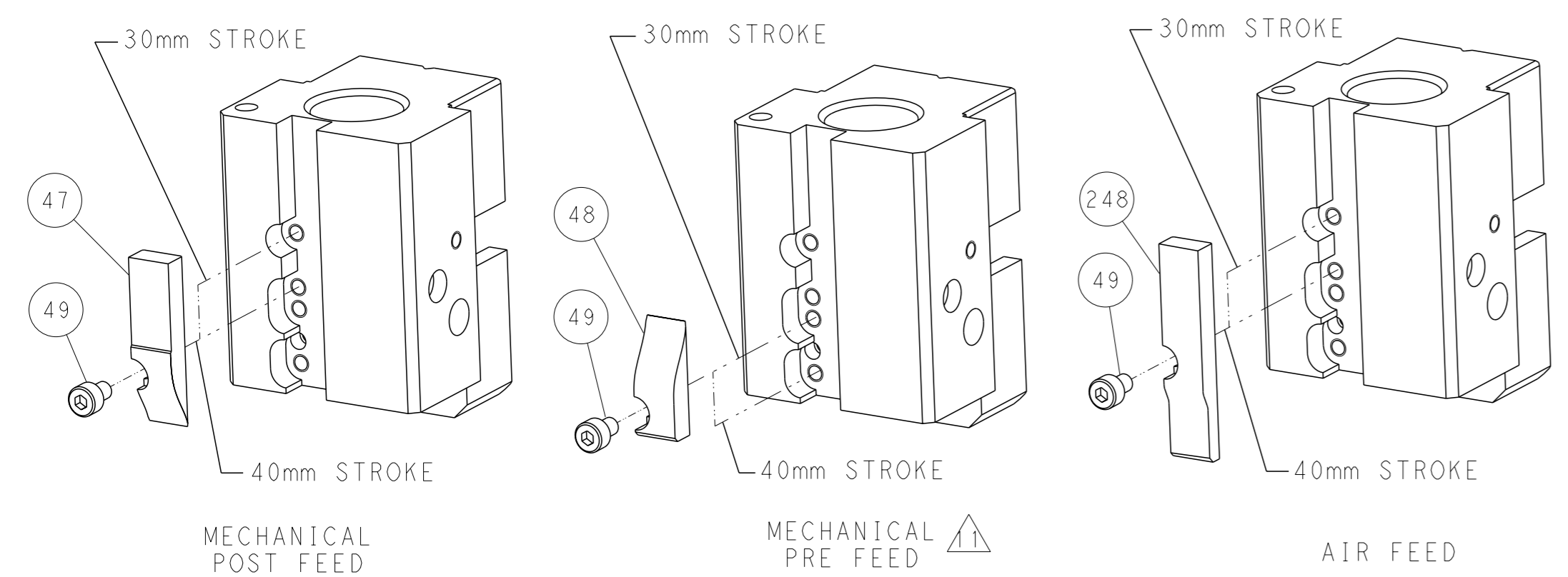
PNEUMATIC



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.001 4 PLC ±0.001 ANGLES ±0.001		OWN R. O. WILSON 06FEB2013 CHK K. J. STAKEM 07FEB2013 APVD J. L. ELBIN 07FEB2013 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2150316 RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 2 of 4 REV A	

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. PACIFIC VERSION TERMINATOR INTERFACE ADAPTER. PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA. CRIMP SIZE, TYPE. WIRE SIZE, TYPE. INSUL SIZE, TYPE. APPL INSTRUCTIONS 408-10390.

TERMINAL DATA: G & H TERMINAL LEAR CRIMP SPECIFICATION. TERMINAL NAME: RECEPTACLE 6, 3x0, 8-1. WIRE STRIP LENGTH, INSULATION DIAMETER RANGE. TERMINAL APPLICATION SPECIFICATION. TERMINALS APPLIED.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- 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: 8-2150316-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150316-5 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150316-5
- 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 50, 62 & 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.
- APPLICATION IS FOR FLY WIRE TYPE.

*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.

Table with 3 columns: Part No, Description, Item No. Includes parts like 2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE 251, 2119640-1 PUSH ROD, AIR FEED 250, etc.

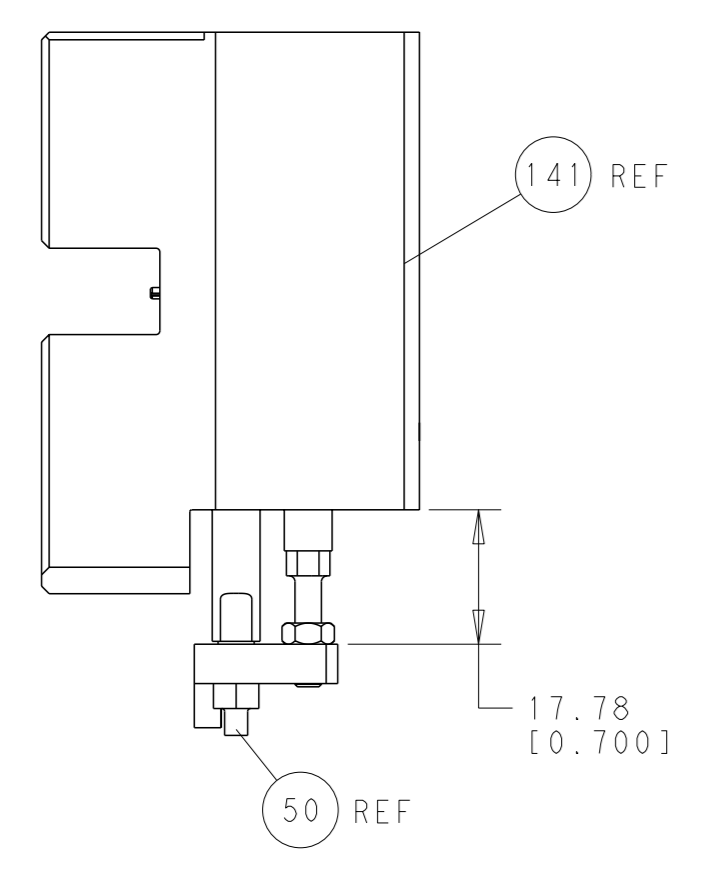
PACIFIC VERSION Shown on sheets 3 of 4 & 4 of 4 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE 2119599-2, LOC A, DIST 66. REVISIONS table with columns for date, description, and initials.

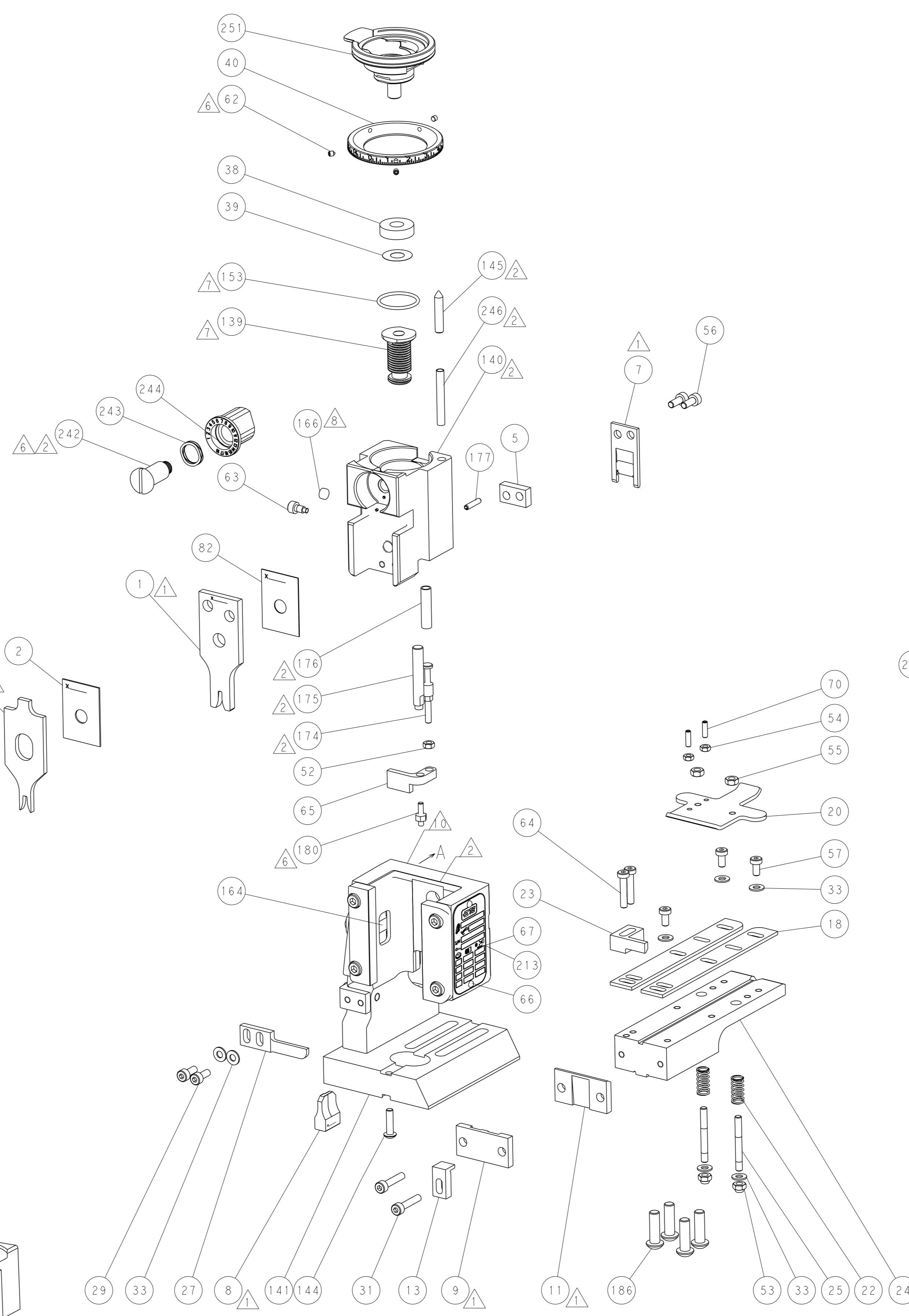
Main parts list table with columns: Qty, Part No, Description, Item No. Lists various components like RETAINER, INSULATION DIAL, SHCS, LOW HEAD, RoHS, MECHANICAL FEED ASSEMBLY, etc.

DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE, SHEET 3 OF 4, REV A.

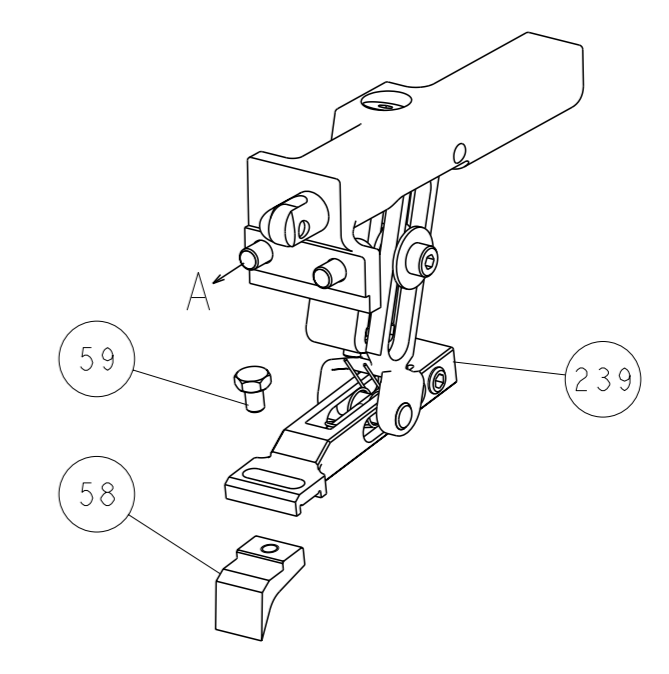
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



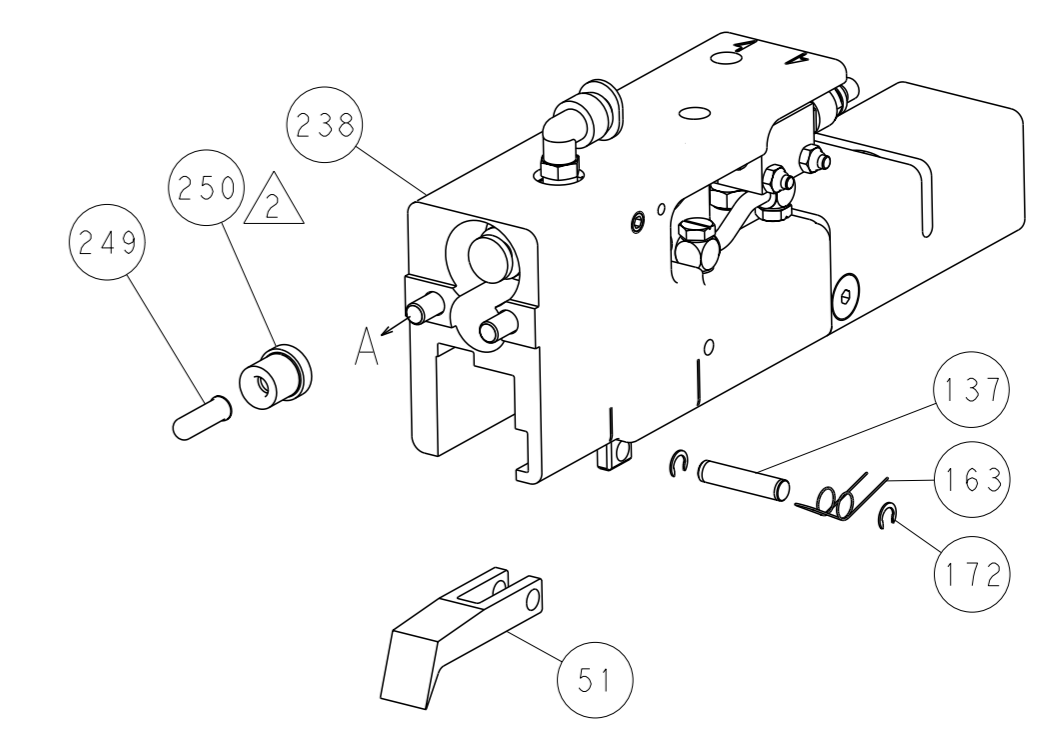
HOLDDOWN SET-UP



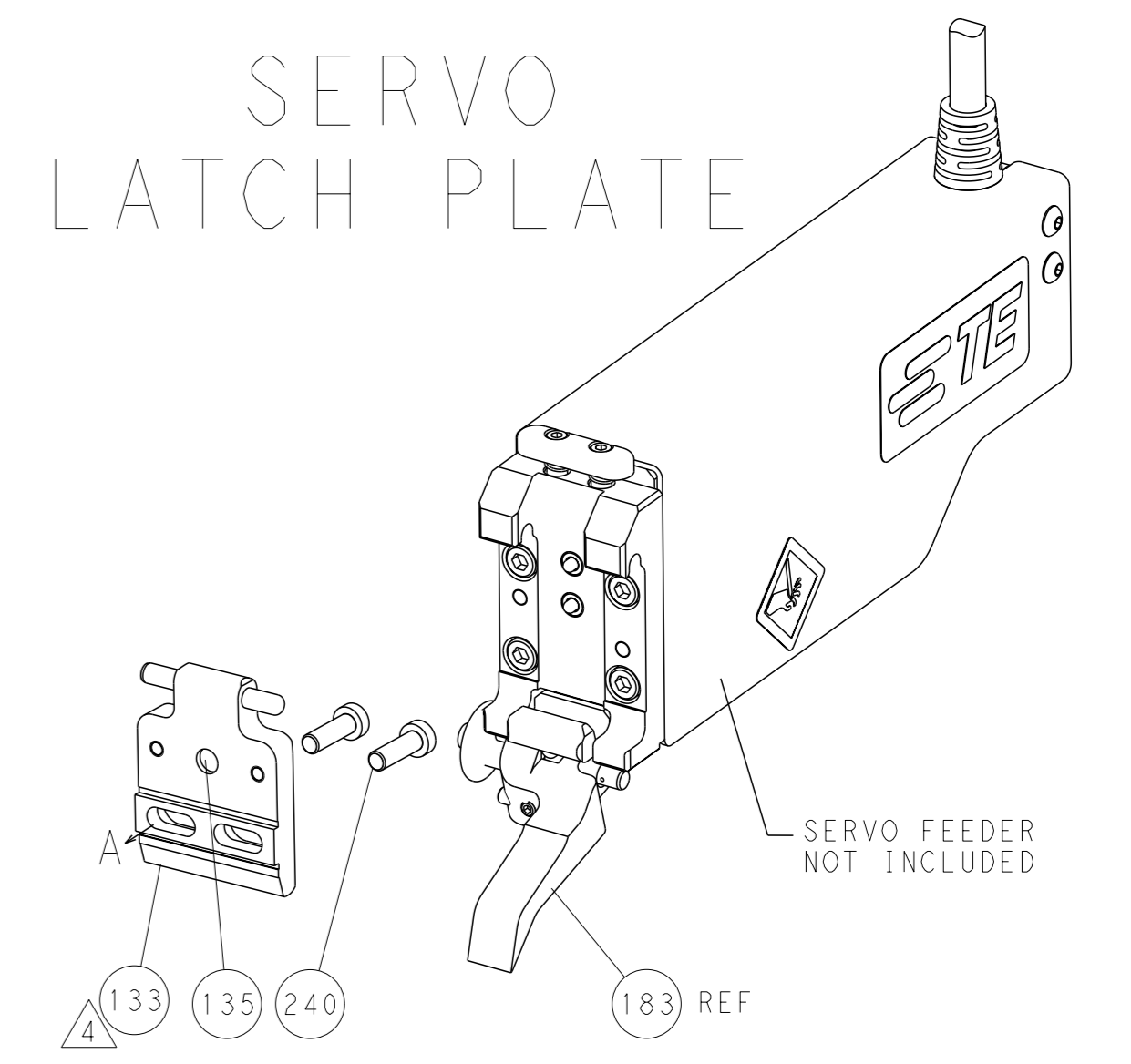
FEED TYPE
MECHANICAL



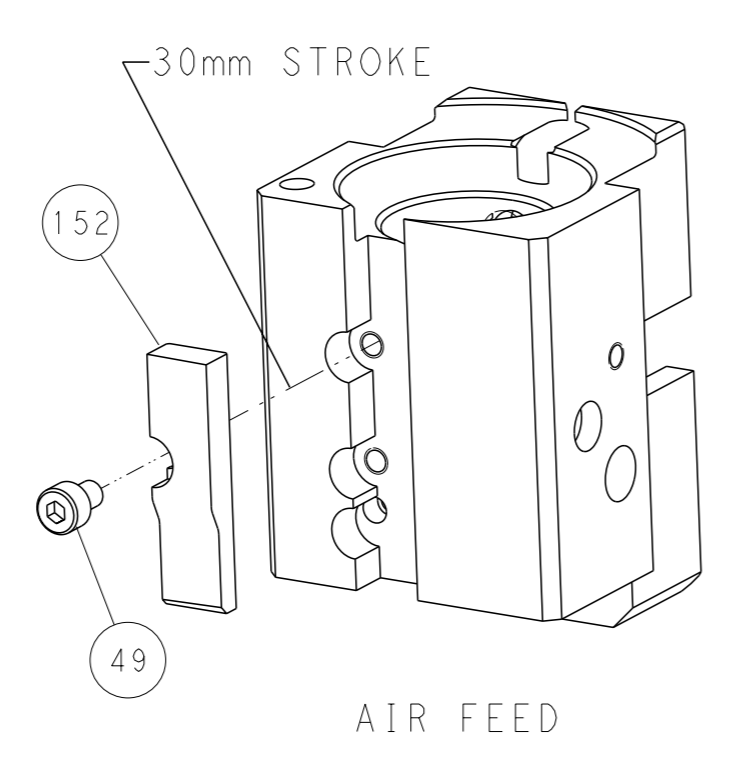
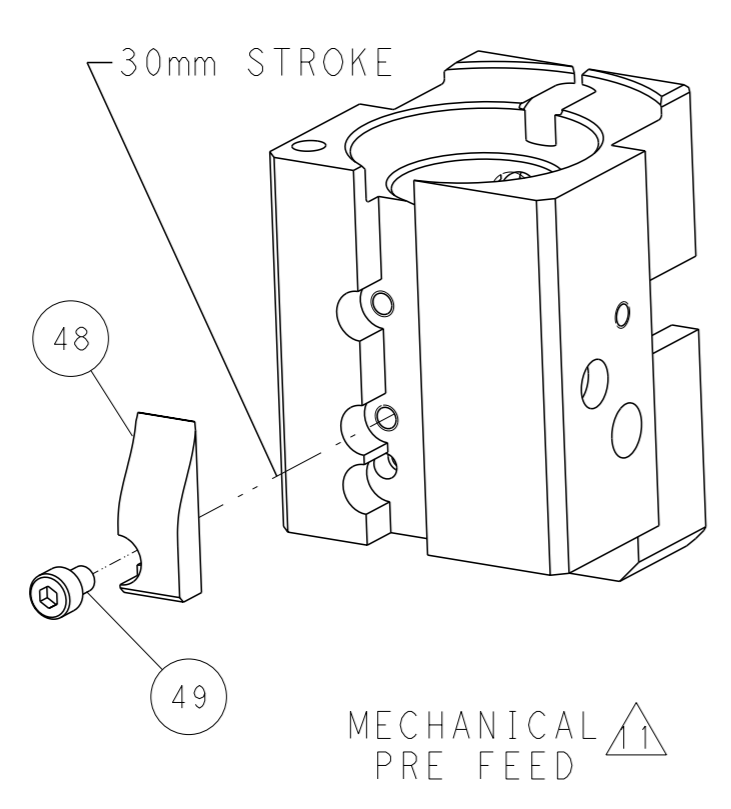
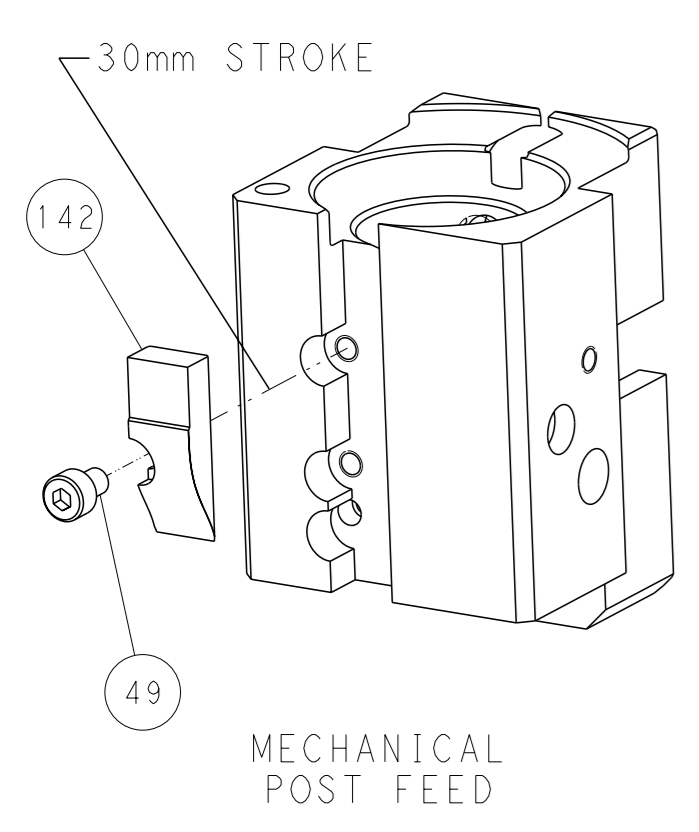
PNEUMATIC



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:		OWN: R. O. WILSON 06FEB2013		STE TE Connectivity	
mm		0 PLC ±0.5		CHK: K. J. STAKEM 07FEB2013		Harrisburg, PA 17105-3608	
HOLE		1 PLC ±0.13		APVD: J. L. ELBIN 07FEB2013		NAME: Ocean End Feed	
MATERIAL:		2 PLC ±0.13		PRODUCT SPEC:		SIZE: CAGE CODE DRAWING NO:	
		3 PLC ±0.013		APPLICATION SPEC:		A1 00779 C=2150316	
		4 PLC ±0.001		WEIGHT:		RESTRICTED TO:	
		ANGLES FINISH:		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 4 OF 4 REV A	