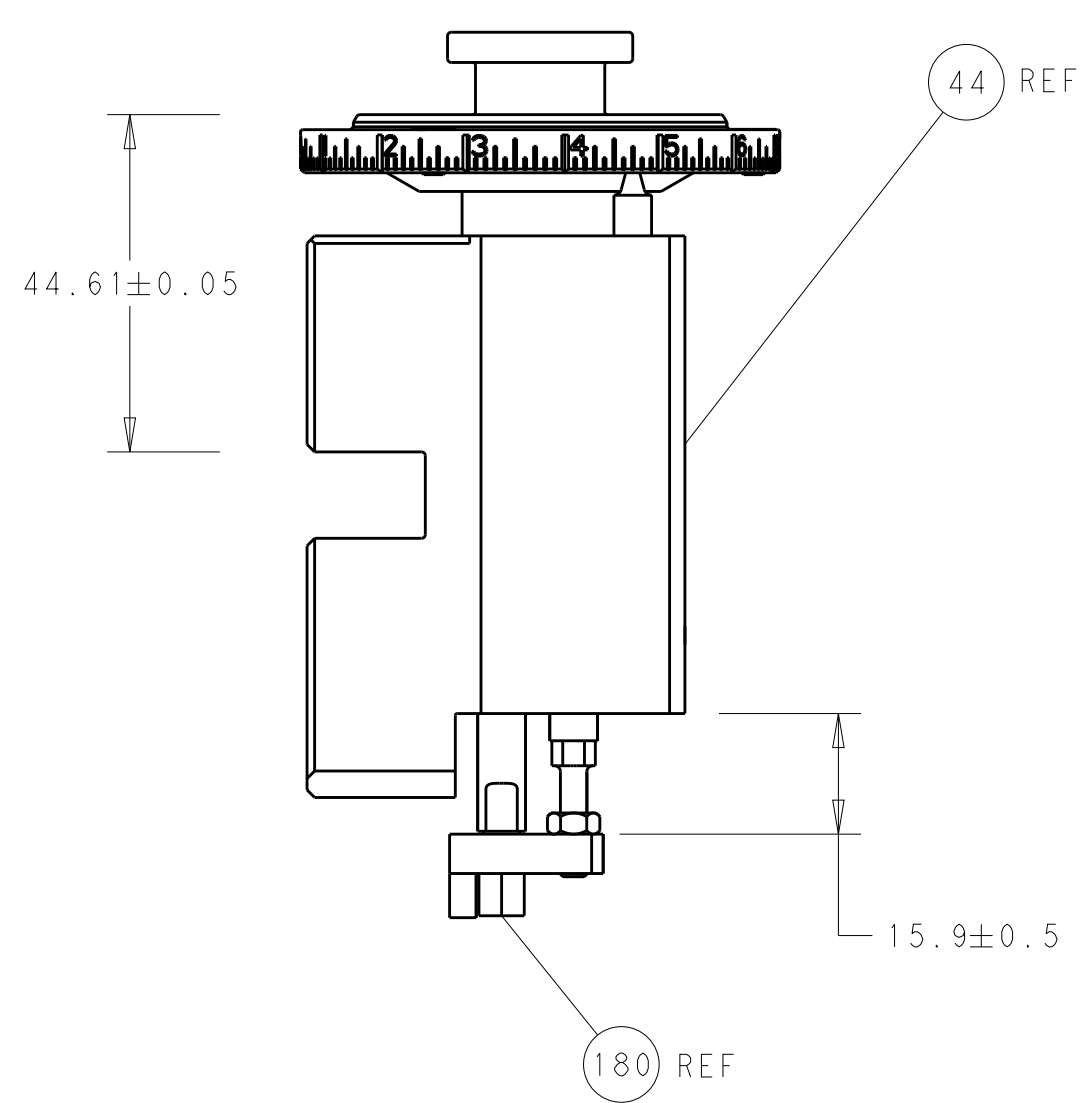


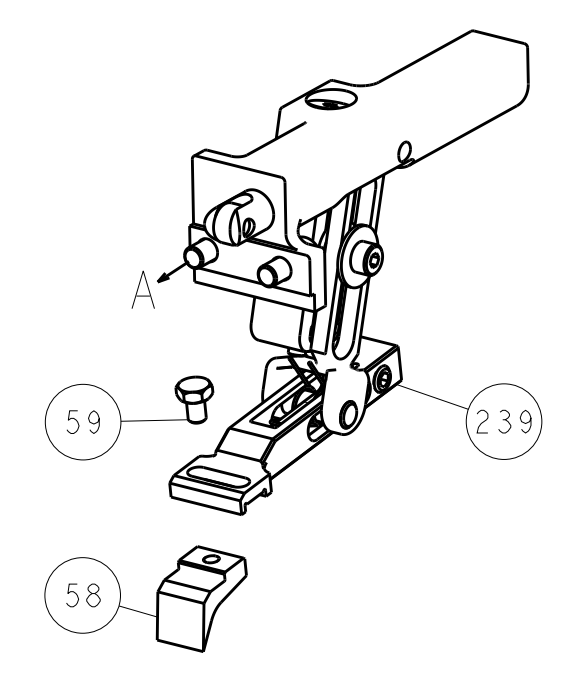


LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

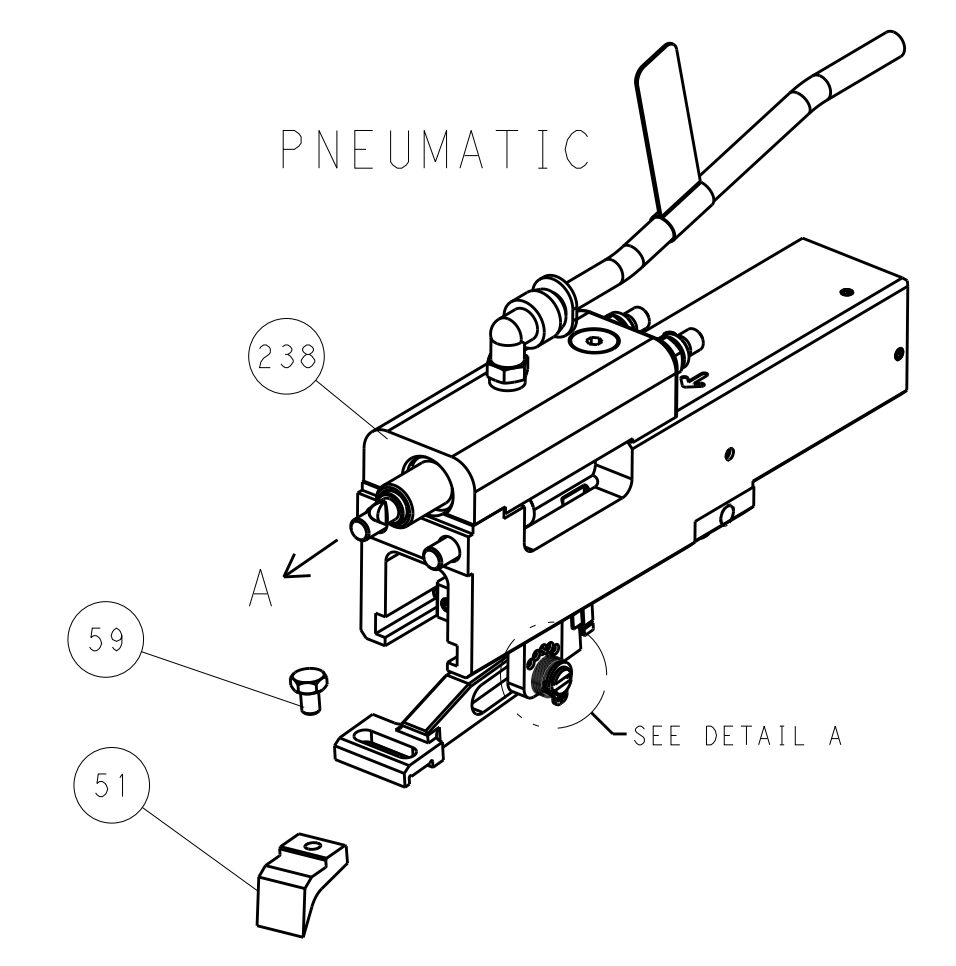


RAM AND HOLDDOWN SET-UP

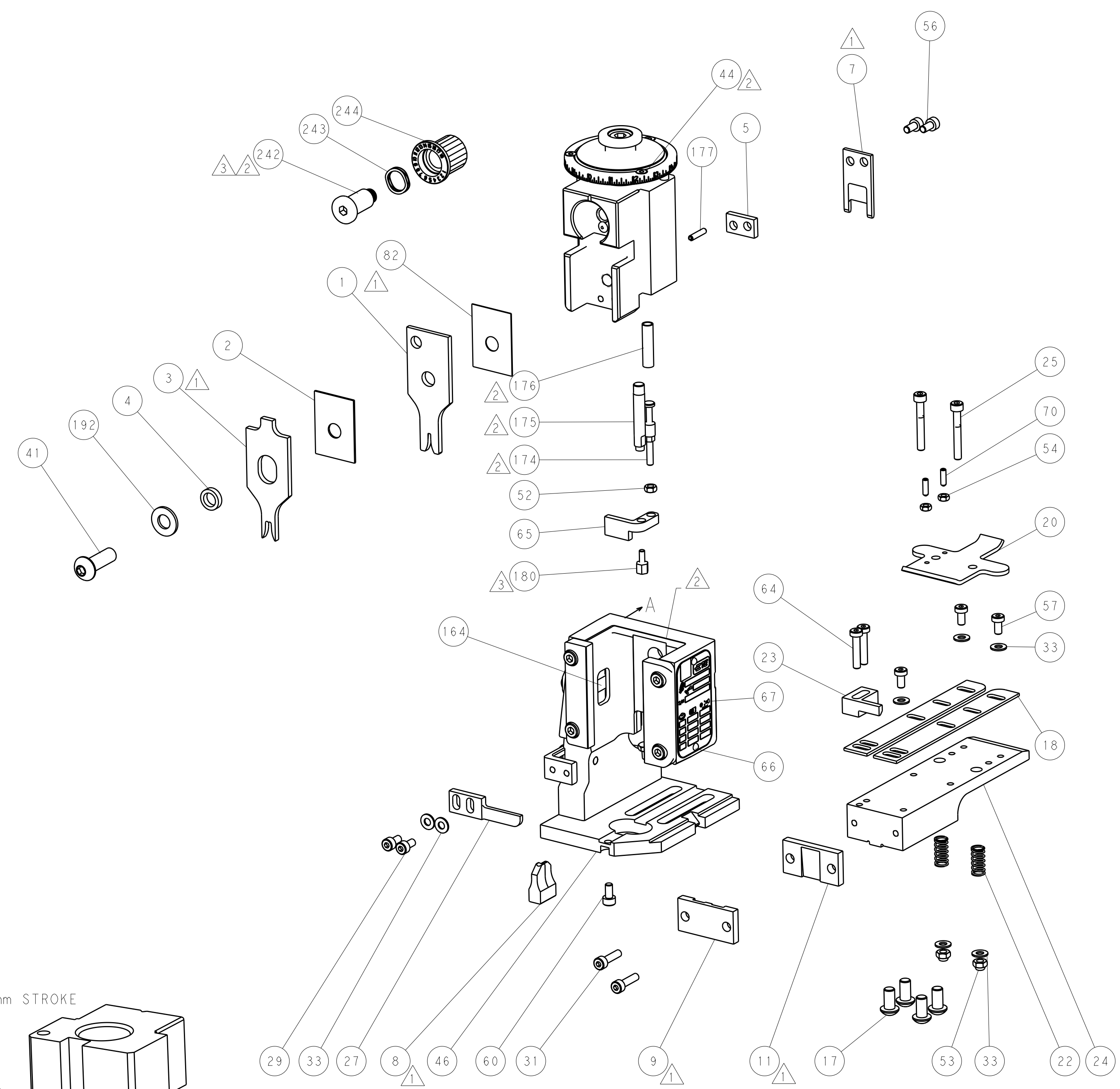
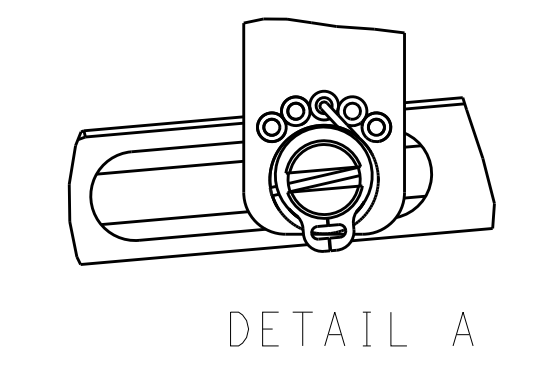
FEED TYPE  
MECHANICAL



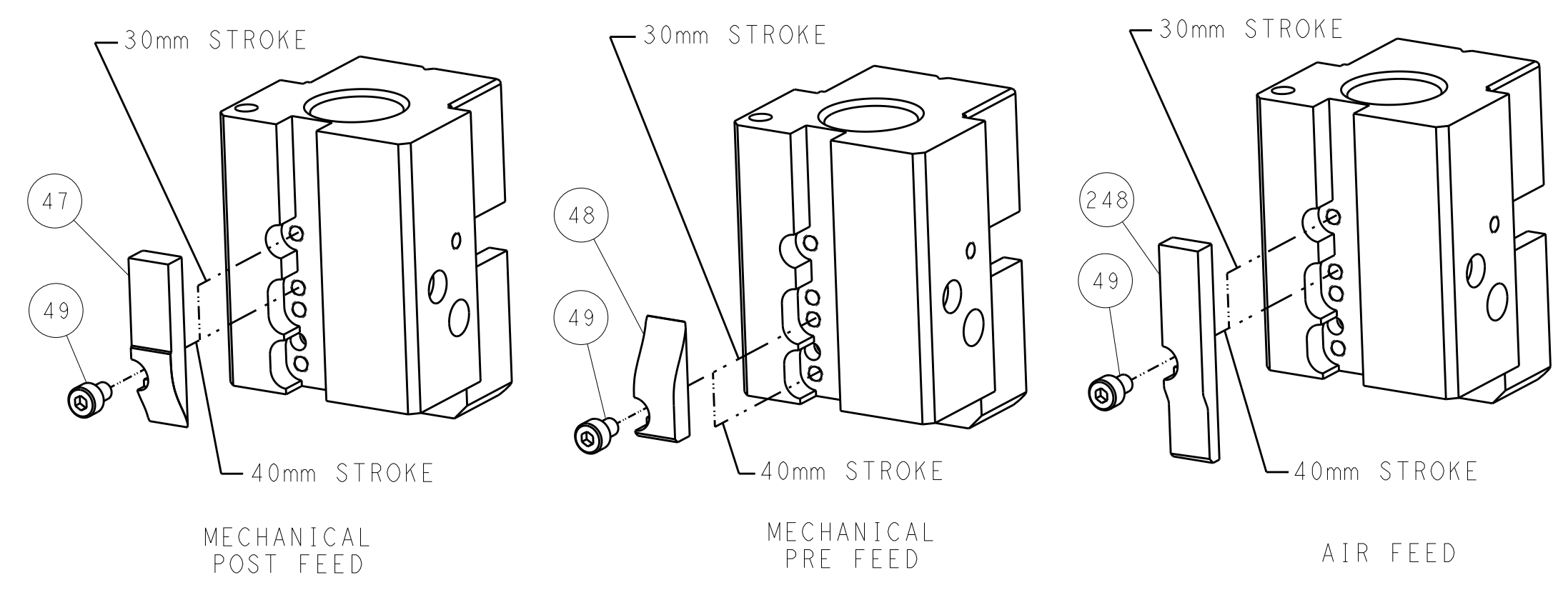
PNEUMATIC



FEED SPRING  
SETTING POSITION



CAM POSITIONS

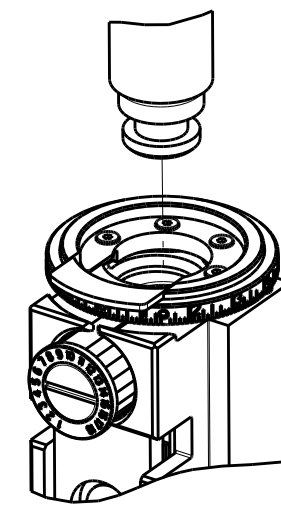


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. CHEN 20JUN2013		TE Connectivity	
mm		0 PLC ±		CHK U. GUO 20JUN2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV J. CRUZ 20JUN2013		NAME	
H		2 PLC ±		PRODUCT SPEC		Ocean End Feed	
L		3 PLC ±		APPLICATION SPEC		Applicator	
R		4 PLC ±		SIZE		A1 00779 ©=2150345	
S		5 PLC ±		WEIGHT		Customer Accessible Production Drawing	
T		6 PLC ±		SCALE		1:1 SHEET 2 OF 4 REV B	
Ø		7 PLC ±		RESTRICTED TO			
H		8 PLC ±					
L		9 PLC ±					
R		10 PLC ±					
S		11 PLC ±					
T		12 PLC ±					
Ø		13 PLC ±					
H		14 PLC ±					
L		15 PLC ±					
R		16 PLC ±					
S		17 PLC ±					
T		18 PLC ±					
Ø		19 PLC ±					
H		20 PLC ±					
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R		88 PLC ±					
S		89 PLC ±					
T		90 PLC ±					
Ø		91 PLC ±					
H		92 PLC ±					
L		93 PLC ±					
R		94 PLC ±					
S		95 PLC ±					
T		96 PLC ±					
Ø		97 PLC ±					
H		98 PLC ±					
L		99 PLC ±					
R		100 PLC ±					

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150345-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150345-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150345-7	A	CRIMP TOOLING KIT	-

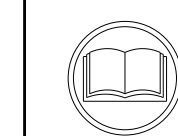
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm (.062)	F
INSUL	3.94 mm (.155)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON .110 SERIES			
WIRE STRIP LENGTH 5.21-5.97 mm (.205-.235 IN)		INSULATION DIAMETER RANGE 3.05-3.56 mm (.120-.140 IN)	
TERMINAL APPLICATION SPECIFICATION	114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60729-1	61158-1	63954-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.25 +/- 0.05 [0.049 +/- .002]	5.3
20 AWG	1.09 +/- 0.05 [0.043 +/- .002]	7.0
22 AWG	1.02 +/- 0.05 [0.040 +/- .002]	7.8



- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- △ 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

**\*WARNING**  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

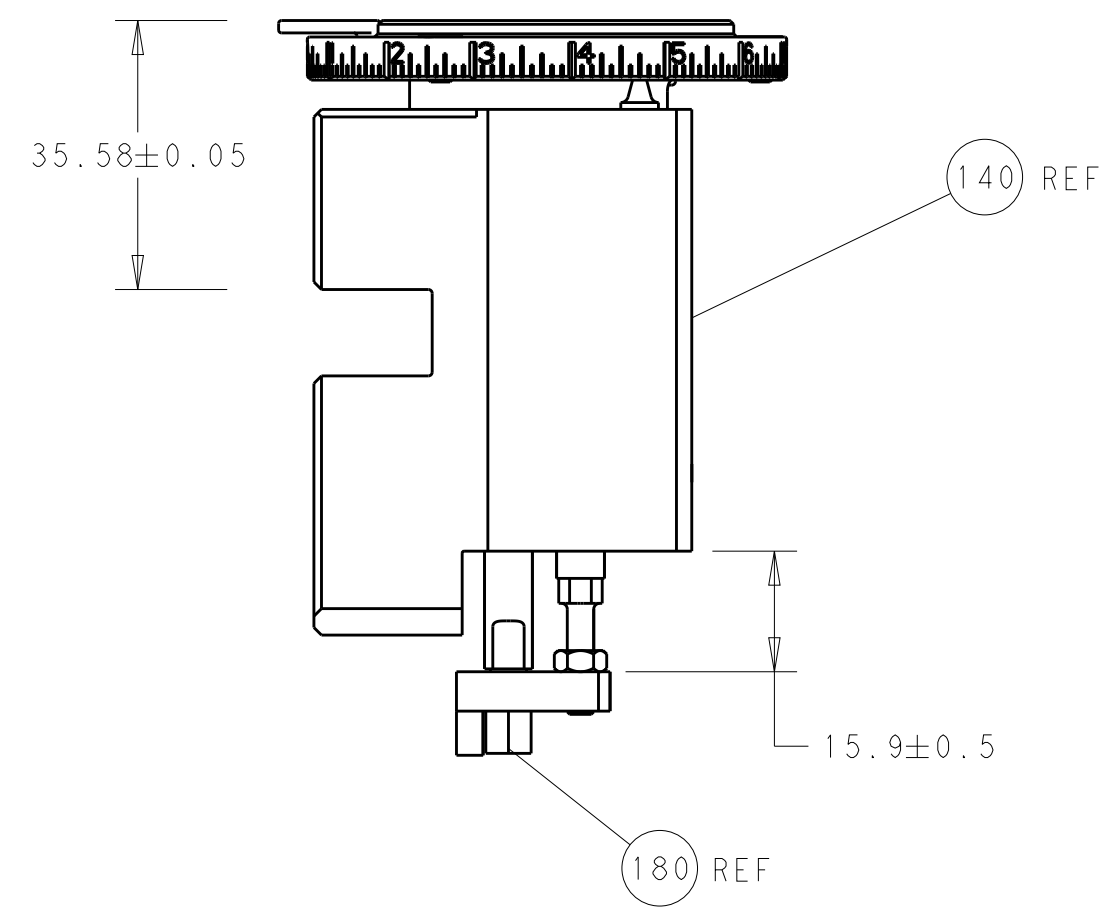
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
△	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
△	-	1	1752354-7	STANDOFF, HOLD-DOWN	180	
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	2119641-2	FEED CAM, AIR FEED	152	
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	-	1	2119653-2	FEED CAM, POST FEED	142	
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1901681-5	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2063961-1	FEED FINGER	58	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	-	2063961-1	FEED FINGER	51	
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1-1752371-2	PLATE, STRIP GUIDE	24	
-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-3	GUIDE, LOWER STRIP	18	
△	-	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	1-690482-8	PLATE, FRONT SHEAR	9	
△	1	1	2-1803001-3	ANVIL, COMBINATION, END FEED	8	
△	-	1	690474-5	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	4-240641-6	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
△	1	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-8	SPACER, CRIMPER	2	
△	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

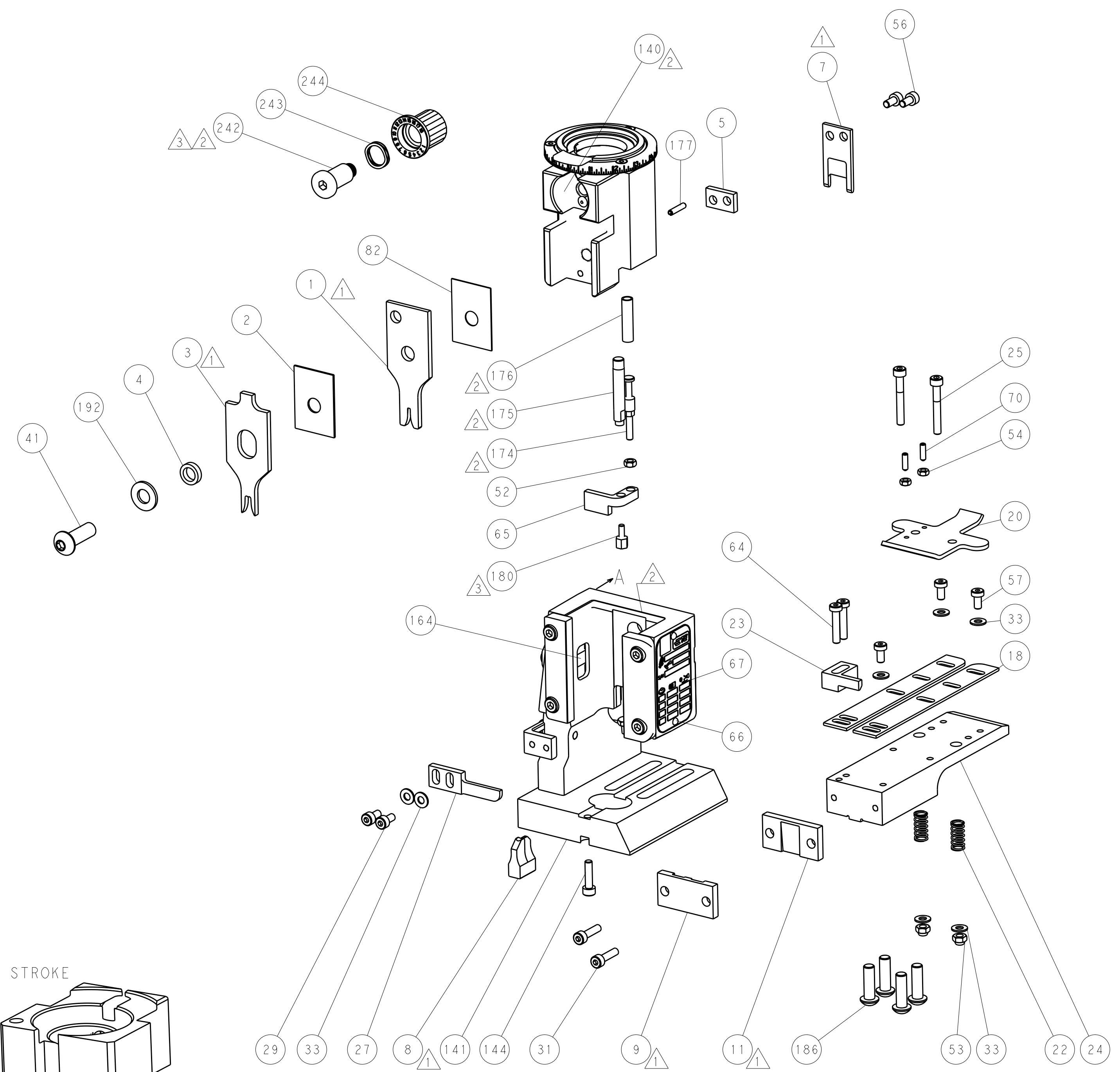
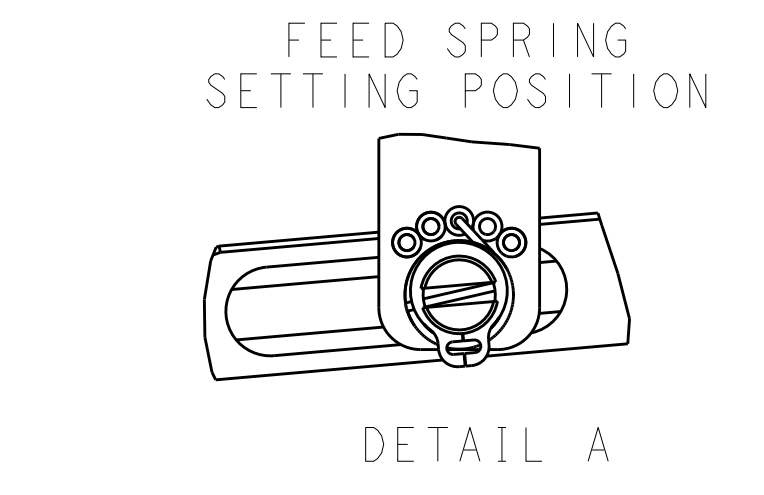
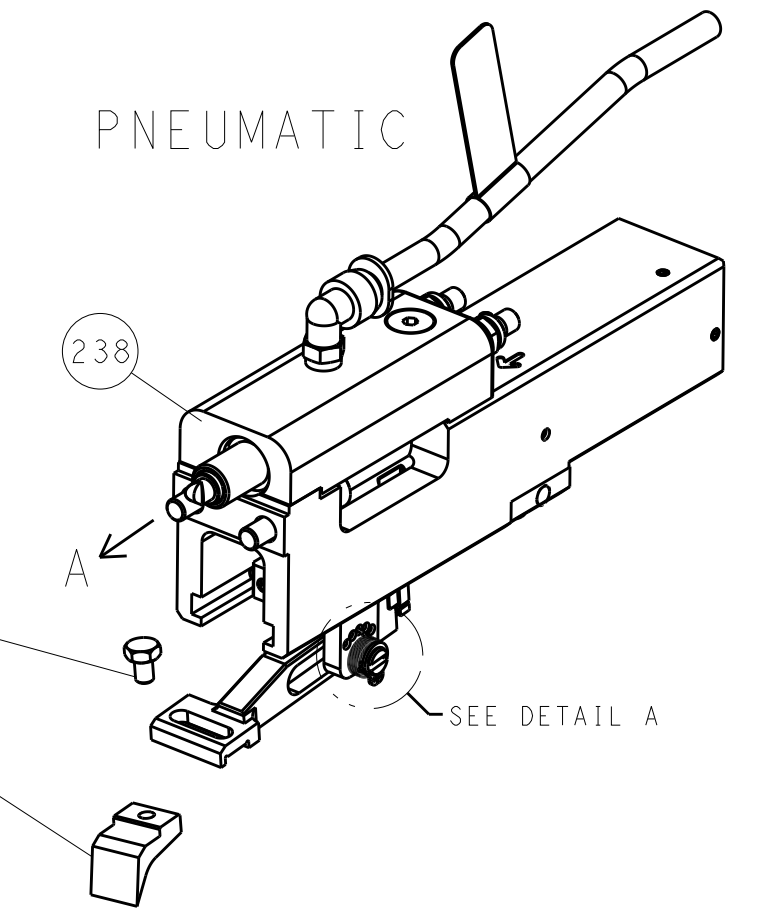
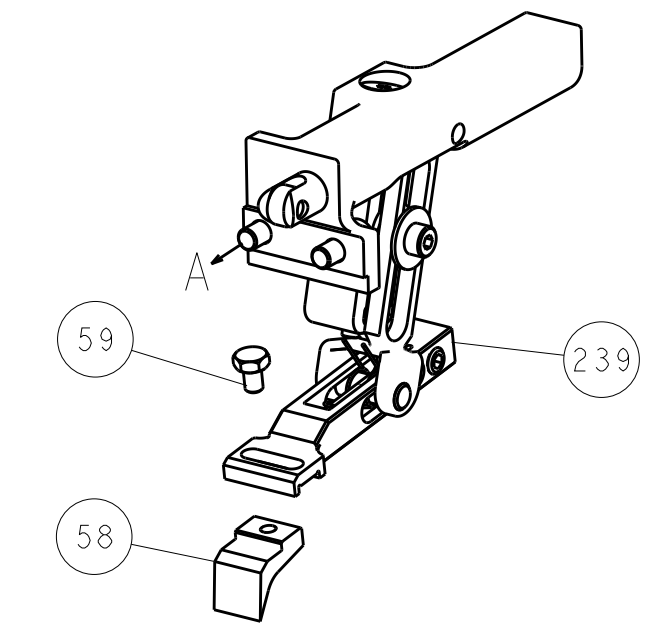
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: C. CHEN 20JUN2013		CHK: U. GUO 20JUN2013		APVD: J. CRUZ 20JUN2013		NAME: Ocean End Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:1		SHEET: 3 OF 4		REV: B	
MATERIAL		FINISH		WEIGHT		SCALE: 1:1		SHEET: 3 OF 4		REV: B	

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

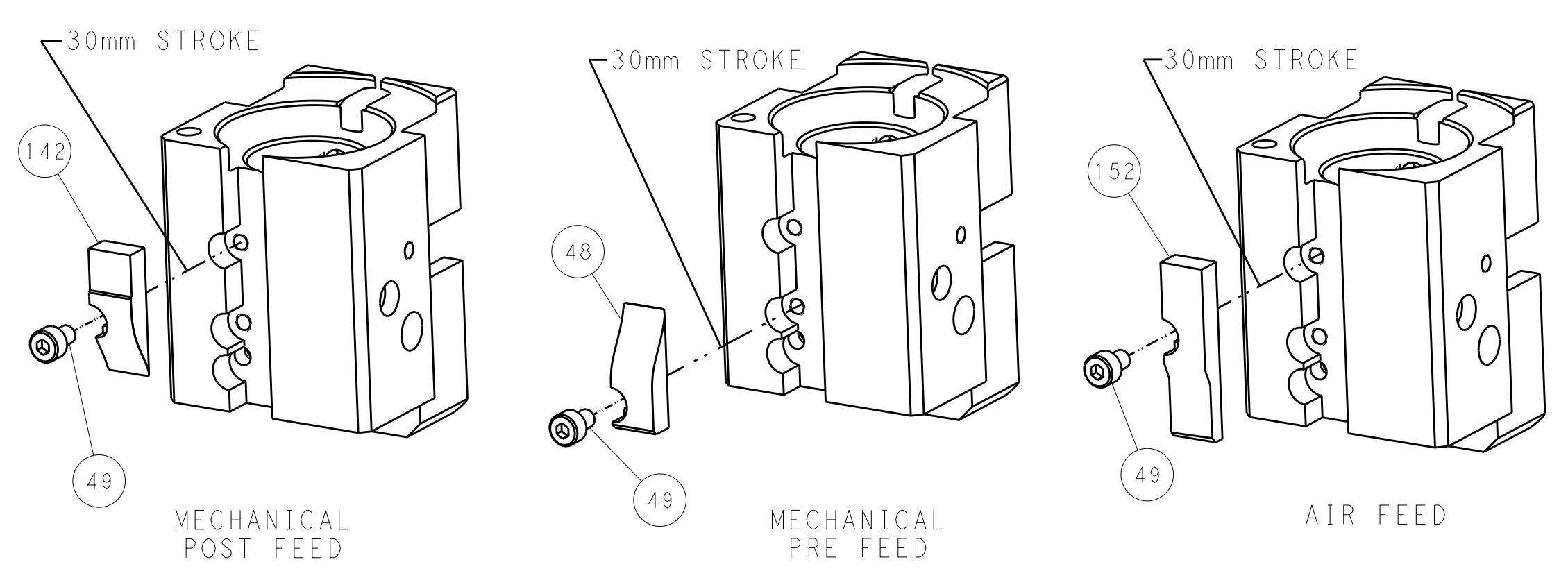


RAM AND HOLDDOWN SET-UP

FEED TYPE  
MECHANICAL



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 C. CHEN 20JUN2013		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD I. CRUZ 20JUN2013	NAME
	ANGLES						Product Spec
MATERIAL	FINISH	WEIGHT	SCALE	1:1	SHEET 4 OF 4	REV B	RESTRICTED TO
Customer Accessible Production Drawing				A 00779 ©=2150345			