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APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Rows include various feed types like PNEUMATIC FEED, MECHANICAL FEED, etc.

APPLICATOR DATA. Table with columns: CRIMP SIZE, WIRE, INSUL, TYPE. Values include 3.56 mm [1.40], F, etc.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Table with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE (10 AWG, 12 AWG), CRIMP HEIGHT, REFERENCE SETTING.

- 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.
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 ITEM 62 & 180.
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
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.
10. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
11. THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1.
12. WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT
13. TERMINAL LUBRICANT IS RECOMMENDED.

*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 columns: PART NO, DESCRIPTION, ITEM NO. Rows include: DEPRESSOR, SHEAR; APPLICATOR SHIM PACK; O-RING, .676 ID, .070 DIA. MAT.; PUSH ROD, AIR FEED; BUSHING, LCH5-12, MISUMI; FEED CAM, AIR FEED; DETENT PIN; SPRING, COMPRESSION.

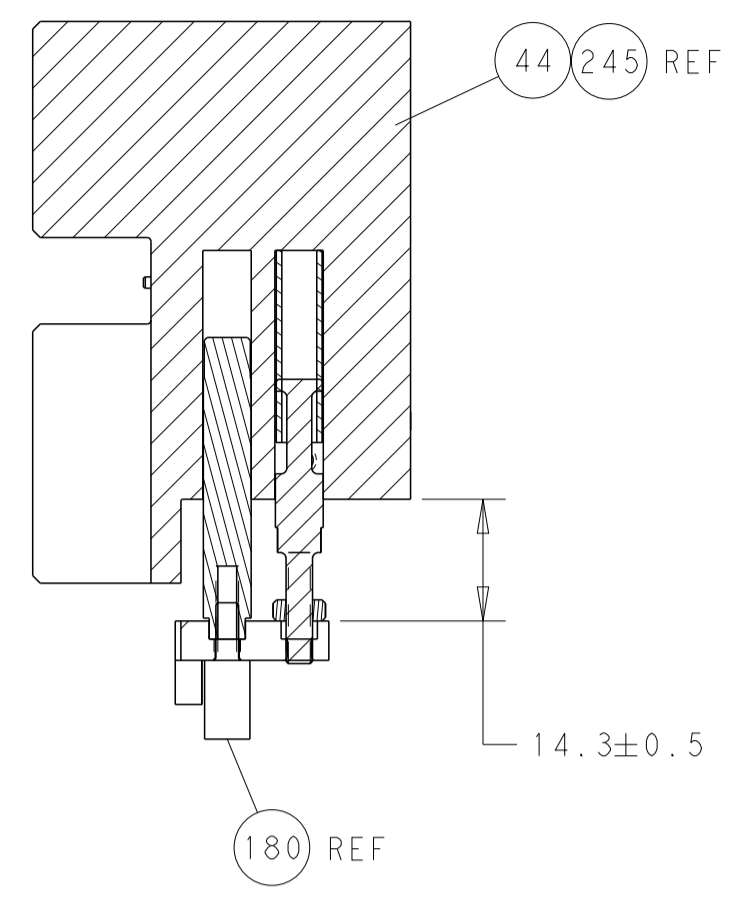
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2. Table with columns: LOC, DIST, REVISIONS. Includes revision history with descriptions like DEVELOPMENT, RELEASED, and dates.

Main BOM table with columns: QTY, UOM, PART NO, DESCRIPTION, DATE, DWN, APVD. Lists various components like RAM, AMP STYLE, END FEED, SHCS, LOW HEAD, RINGS, M5 X 10, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, TAG, IDENTIFICATION, SPACER, CRIMPER, FEED FINGER ASSEMBLY, EF, STANDOFF, HOLD-DOWN, PIN, SLOTTED SPRING, SPRING, COMPRESSION, GUIDE PIN, RING, RARE EARTH HIGH ENERGY MAGNET, COUNTER, SPRING, FEED FINGER, PIN, RETAIN, MEMORY CHIP, SERVO FEED LATCH ASM, ASSY, LUBRICATOR, END FEED, SPACER, CRIMPER, DEPRESSOR, WIRE, DOCUMENTATION PACKAGE, SCR, SET, FLT POINT, WASHER, TAG, IDENTIFICATION, SCREW, DRIVE, SCR, CONE POINT, LIMITER, SCR, BHSC, SCR, HEX HD CAP, FEED FINGER, SHCS, LOW HEAD, SCR, SKT HD CAP, NUT, HEX, REG, NUT, LOCK, HEX, TORQUE, NUT, HEX, REG, PAWL, FEED CAM, FEED CAM, PRE FEED, FEED CAM, POST FEED, APPLICATOR BASIC ASSEMBLY, RAM, AMP STYLE, SCR, BHSC, DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, FA HEAD, BOLT, WASHER, SCR, SKT HD CAP, WASHER, PLATE, SHEAR, PLATE, ANVIL, COMBINATION, BLADE, SLUG, SPACER, SPRING, COMPRESSION, DRAG, GUIDE, LOWER STRIP, SCR, BHSC, SCR, HOLD-DOWN, PLATE, REAR SHEAR, PLATE, FRONT SHEAR, ANVIL, COMBINATION, END FEED, BLADE, SLUG, SPACER, CRIMPER, WIRE PREMIUM.

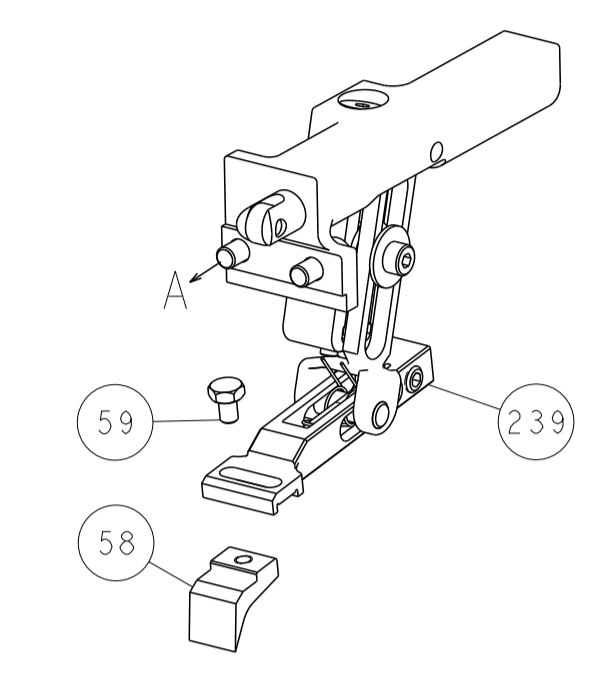
Customer drawing information. Includes: DIMENSIONS (mm), TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE (1:1), SHEET 1 OF 4, REV A. Includes STC logo and address: TE Connectivity, Harrisburg, PA 17105-3608.

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

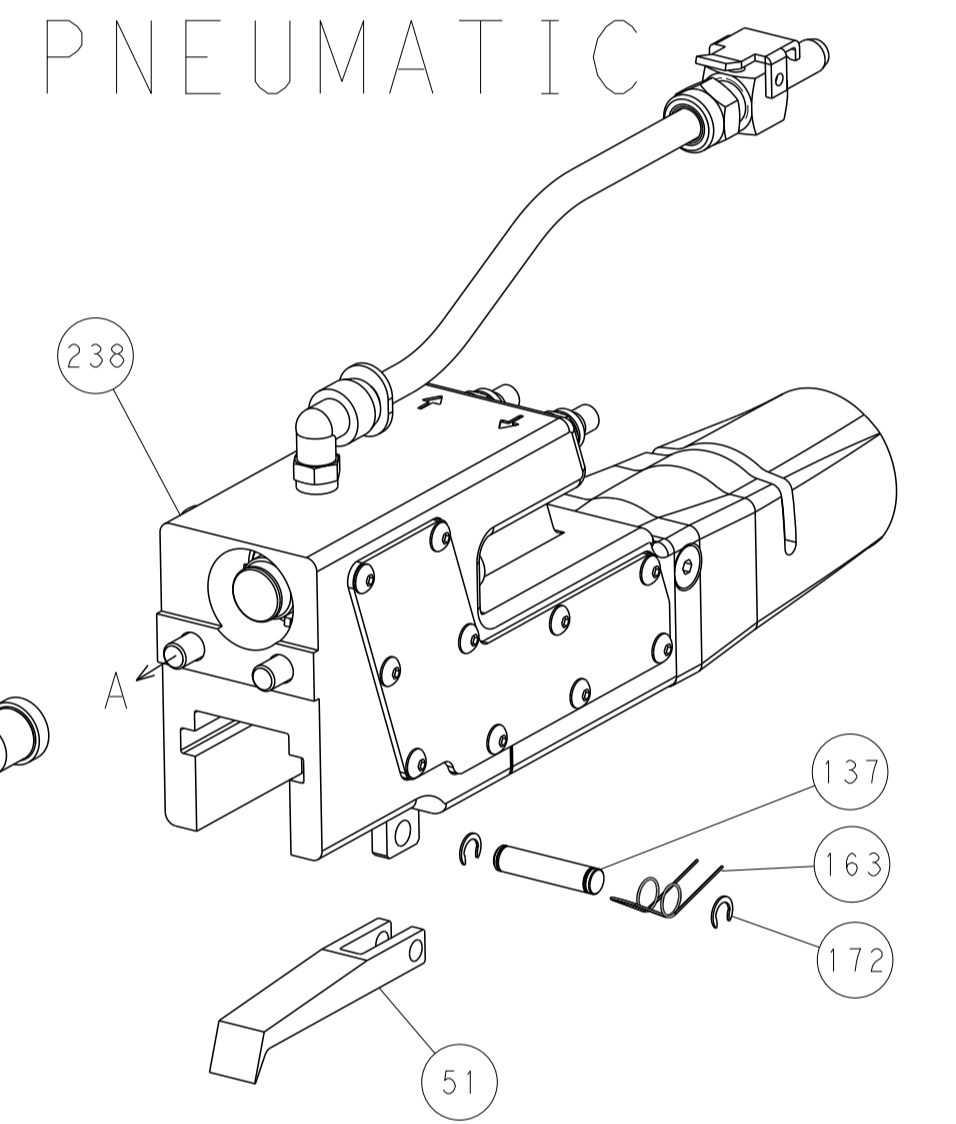


HOLDDOWN SET-UP

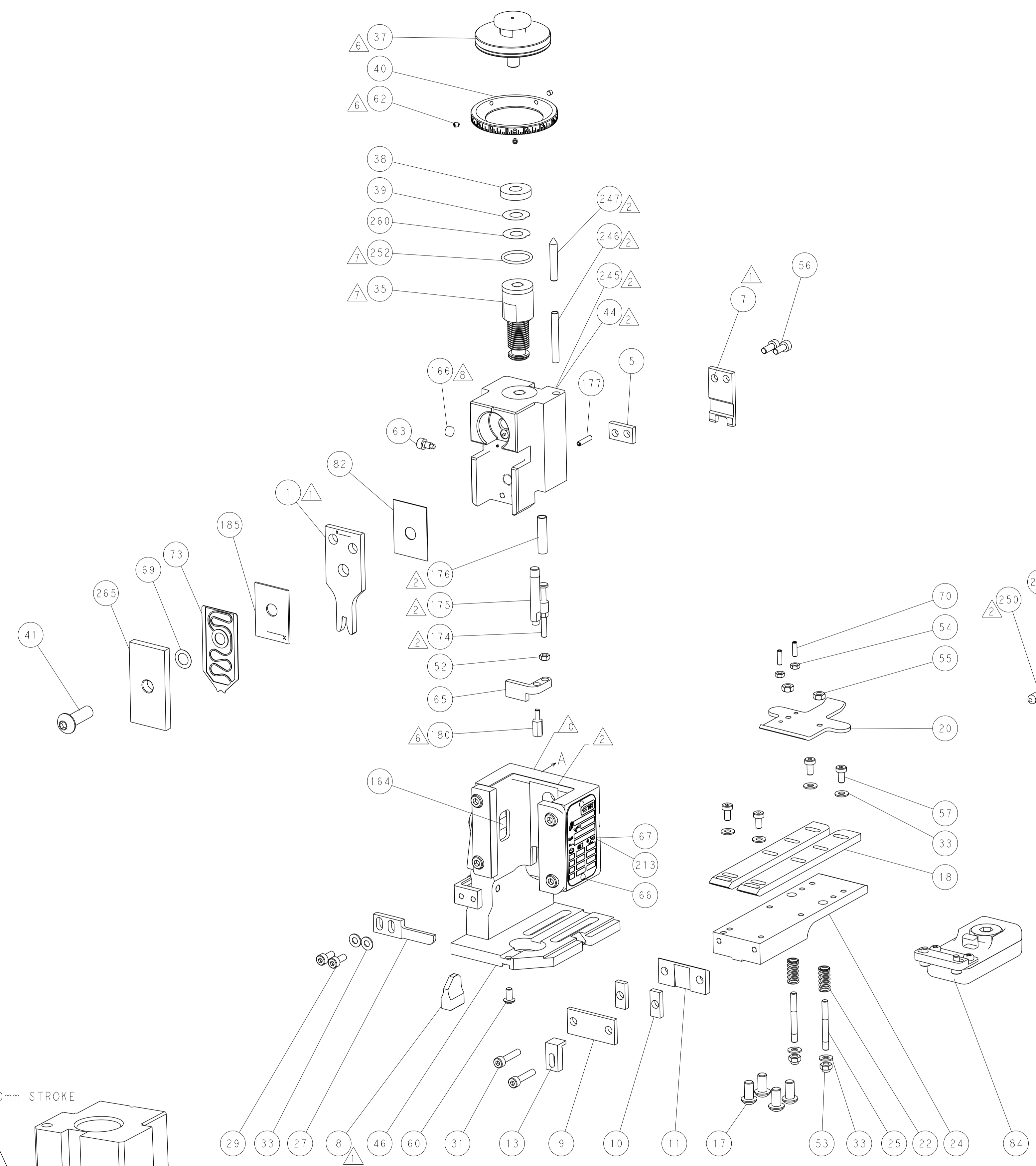
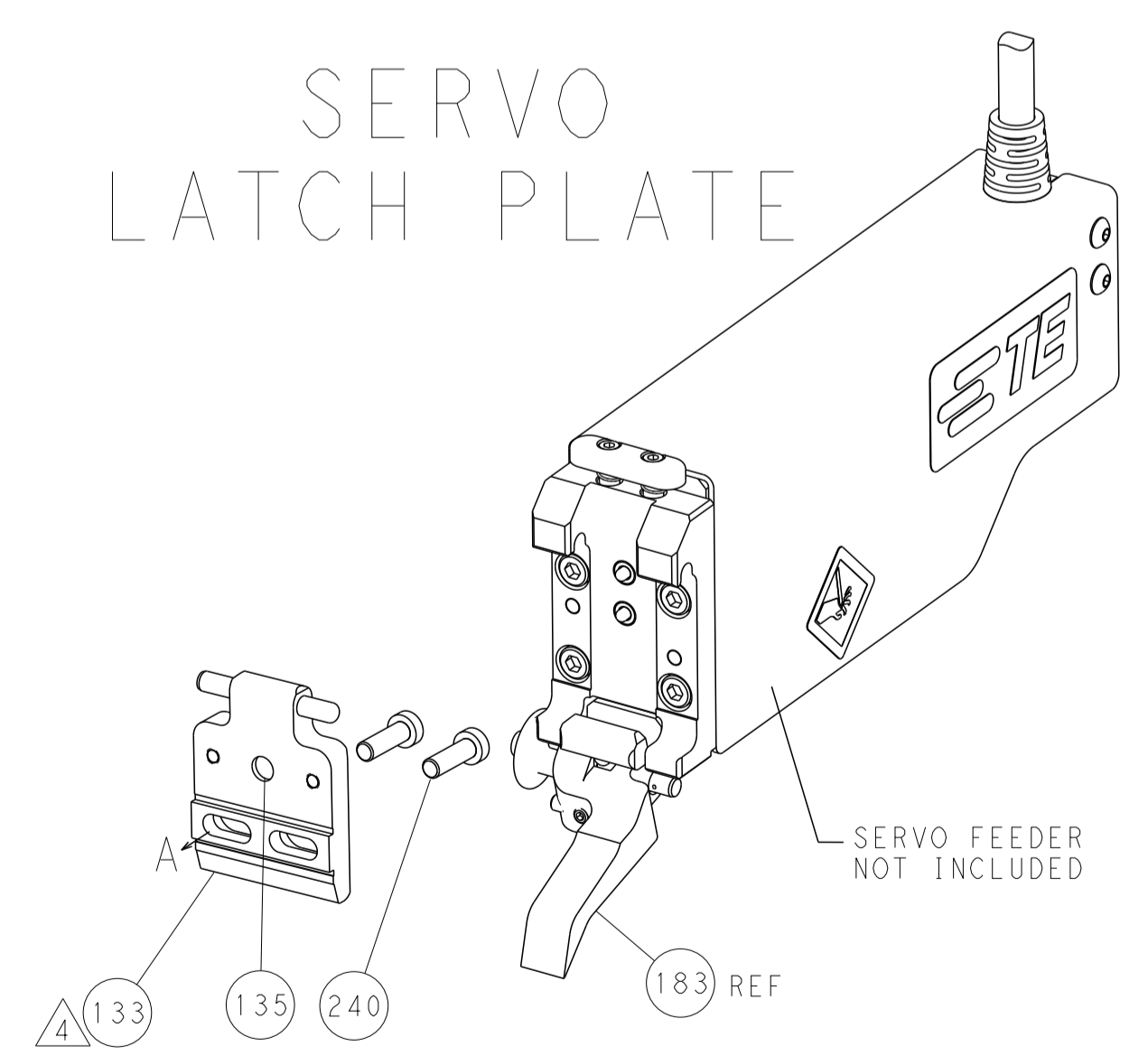
FEED TYPE
MECHANICAL



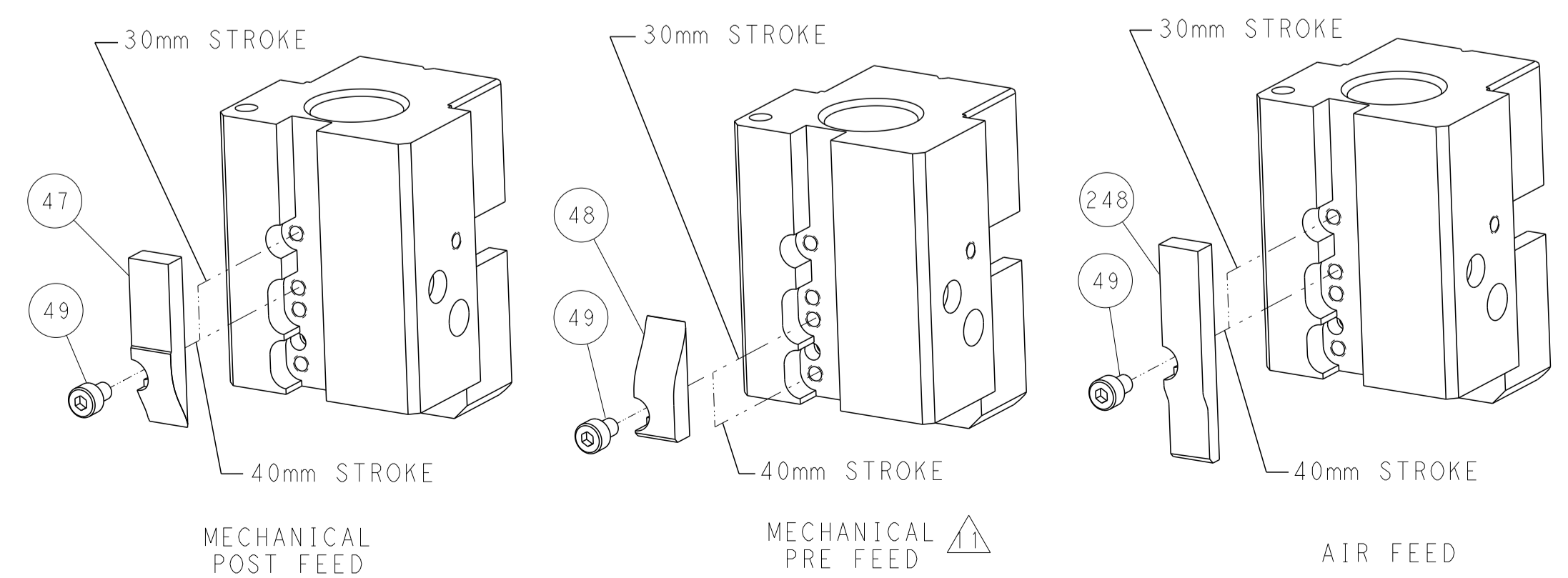
PNEUMATIC



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)

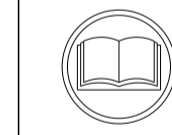
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN J. HOU 09MAY2016 CHK L. ZHANG 09MAY2016 APVD L. ZHANG 09MAY2016 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER DRAWING		TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150672 SCALE 1:1 SHEET 2 OF 4 REV A	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
				CONVERT TO	PART NUMBERS REQUIRED					
2-2150672-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
				SERVO LATCH PLATE	2119951-1	1901697-1	8-2150672-5	-	-	2168400-7 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2150672-4	-	-	-
2-2150672-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
				SERVO LATCH PLATE	2119951-1	1901697-1	8-2150672-5	-	-	2168400-7 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2150672-4	-	-	-
2-2150672-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	
2-2150672-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150672-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 3.56 mm [.140]	F	
INSUL -	-	
APPL INSTRUCTIONS 408-10390 		

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62587-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.97 +/- 0.05 [.117 +/- .002]	5.1
12 AWG	2.51 +/- 0.05 [.099 +/- .002]	10.3



-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
- 3. 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: 8-2150672-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150672-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150672-5
- 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 62 & 180.
-  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 LUBRICANT IS RECOMMENDED.

*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.

-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO
- 1 1 1 1 1	1-2119757-6	DEPRESSOR, SHEAR	265
- 1 1 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 1	1-22279-3	SPRING, COMPRESSION	246
- - 2 - -	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240

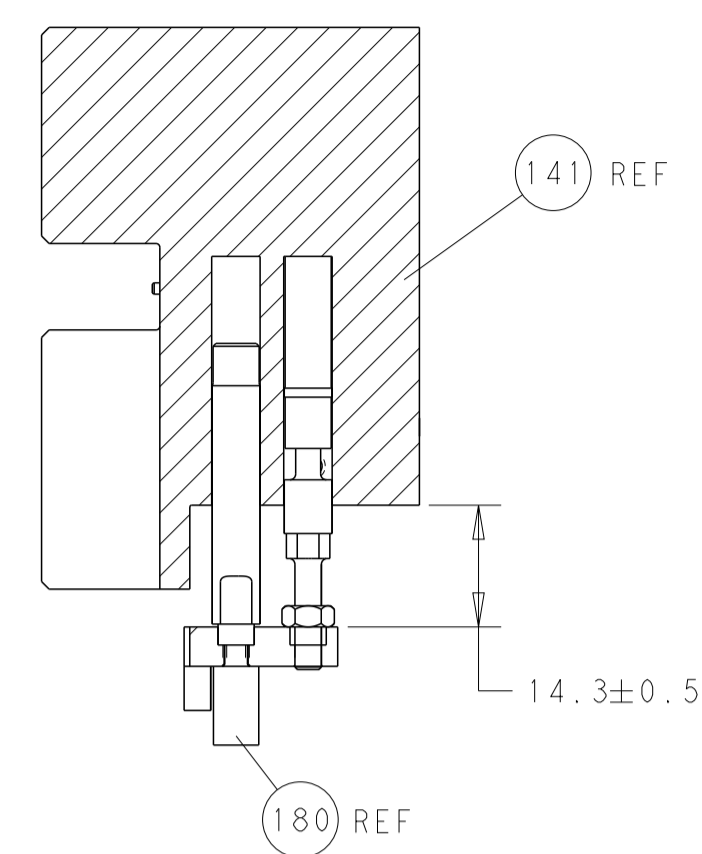
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	-	-	1	2063440-1	AIR FEED MODULE	238	
-	-	-	-	1	2119740-2	TAG, IDENTIFICATION	213	
-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	185	
-	-	-	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183	
-	1	1	1	1	2-1752354-6	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
-	-	-	-	-	994970-2	COUNTER, MAGNETIC	164	
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163	
-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153	
-	-	-	-	-	2119641-2	FEED CAM, AIR FEED	152	
-	1	1	1	1	2119798-2	DETENT PIN	145	
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	-	-	-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140	
-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139	
-	-	-	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	-	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	-	-	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	73	
-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	1	-	-	-	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	65	
-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
-	3	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	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56	
-	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55	
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	-	-	-	-	2119792-1	PAWL, EF, AIR	51	
-	-	-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48	
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1	1	2119644-4	RAM WASHER, PRECISION	38	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	2	2	1320906-1	STUD, THREADED	25	
-	1	1	1	1	3-1752371-0	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1752373-4	DRAG	20	
-	2	2	2	2	1-1901259-6	GUIDE, LOWER STRIP	18	
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	1	1	1-240833-2	PLATE, REAR SHEAR	11	
-	2	2	2	2	2-240645-7	SPACER, SHEAR PLATE	10	
-	1	1	1	1	240642-3	PLATE, FRONT SHEAR	9	
-	1	1	1	1	2-1803002-2	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	8-240651-6	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-1	SPACER	5	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	1	1	1	3-456411-5	CRIMPER, WIRE PREMIUM	1	

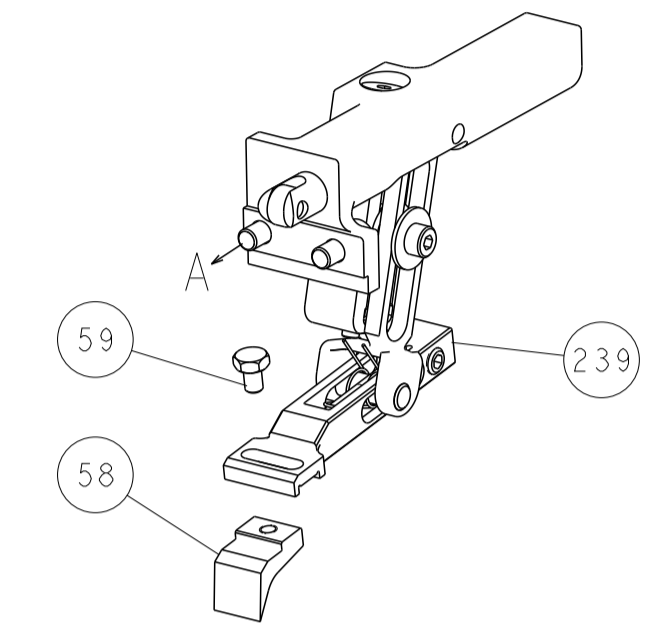
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MATERIAL:		CUSTOMER DRAWING		SCALE 1:1		SHEET 3 OF 4		REV A

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

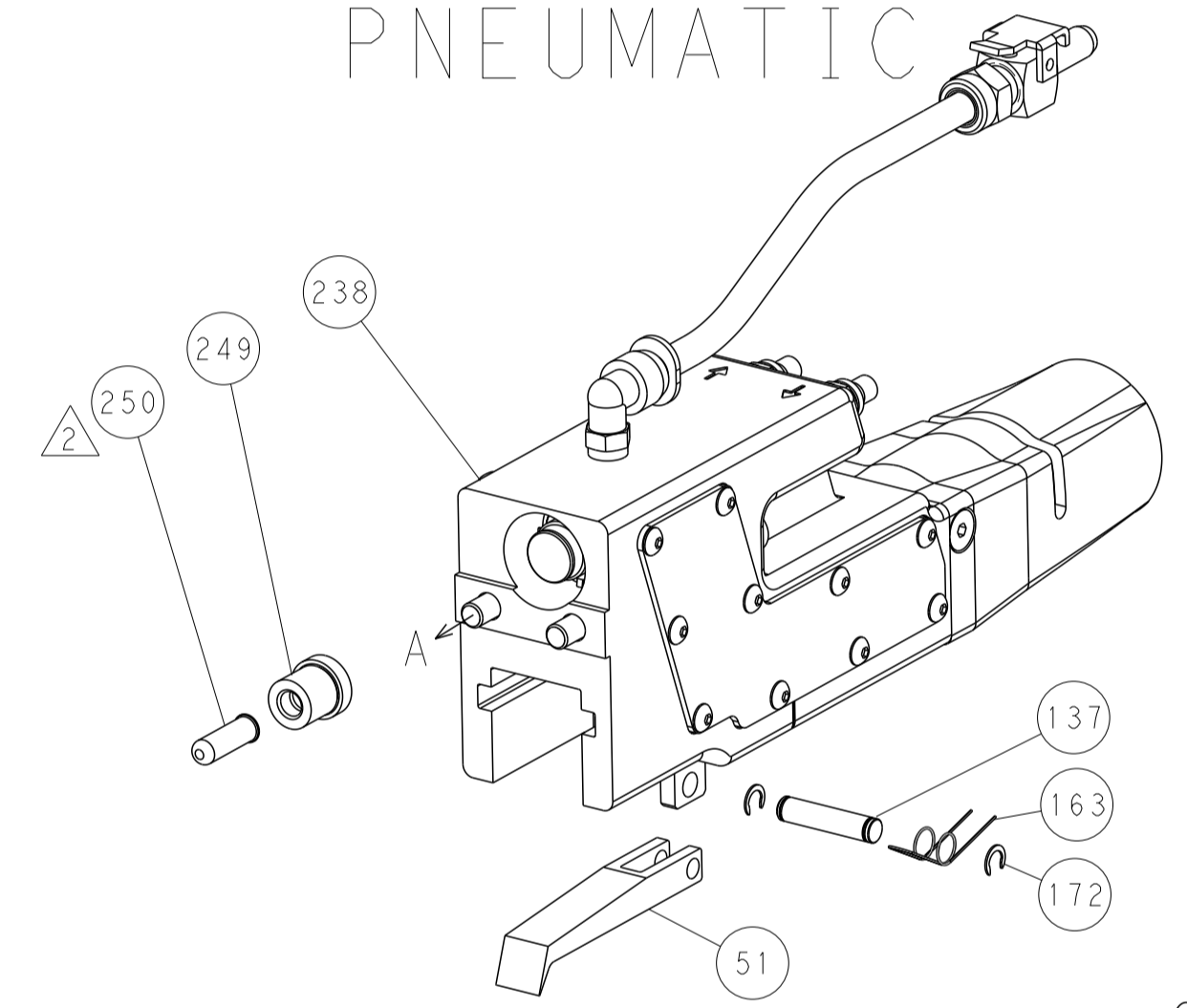


HOLDDOWN SET-UP

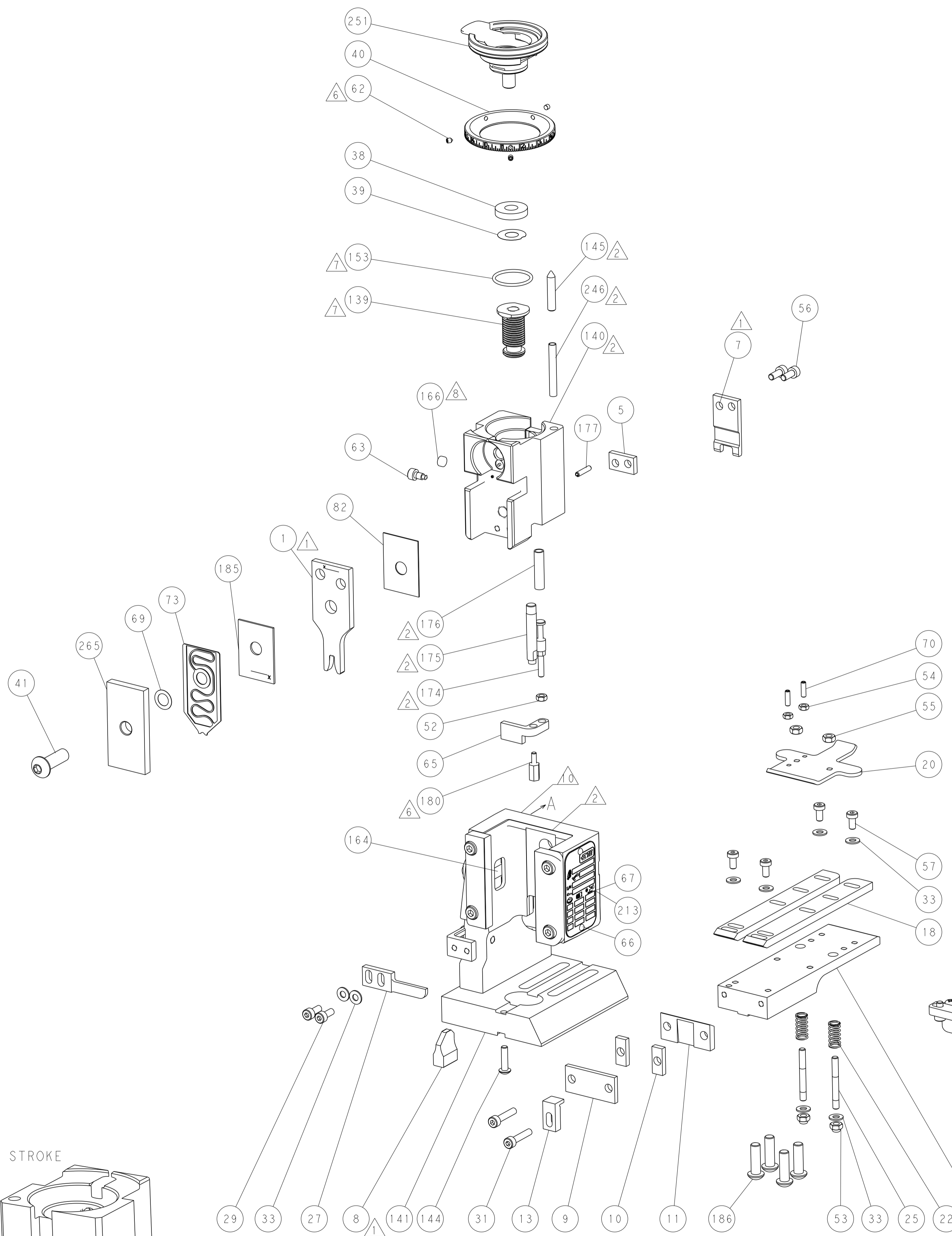
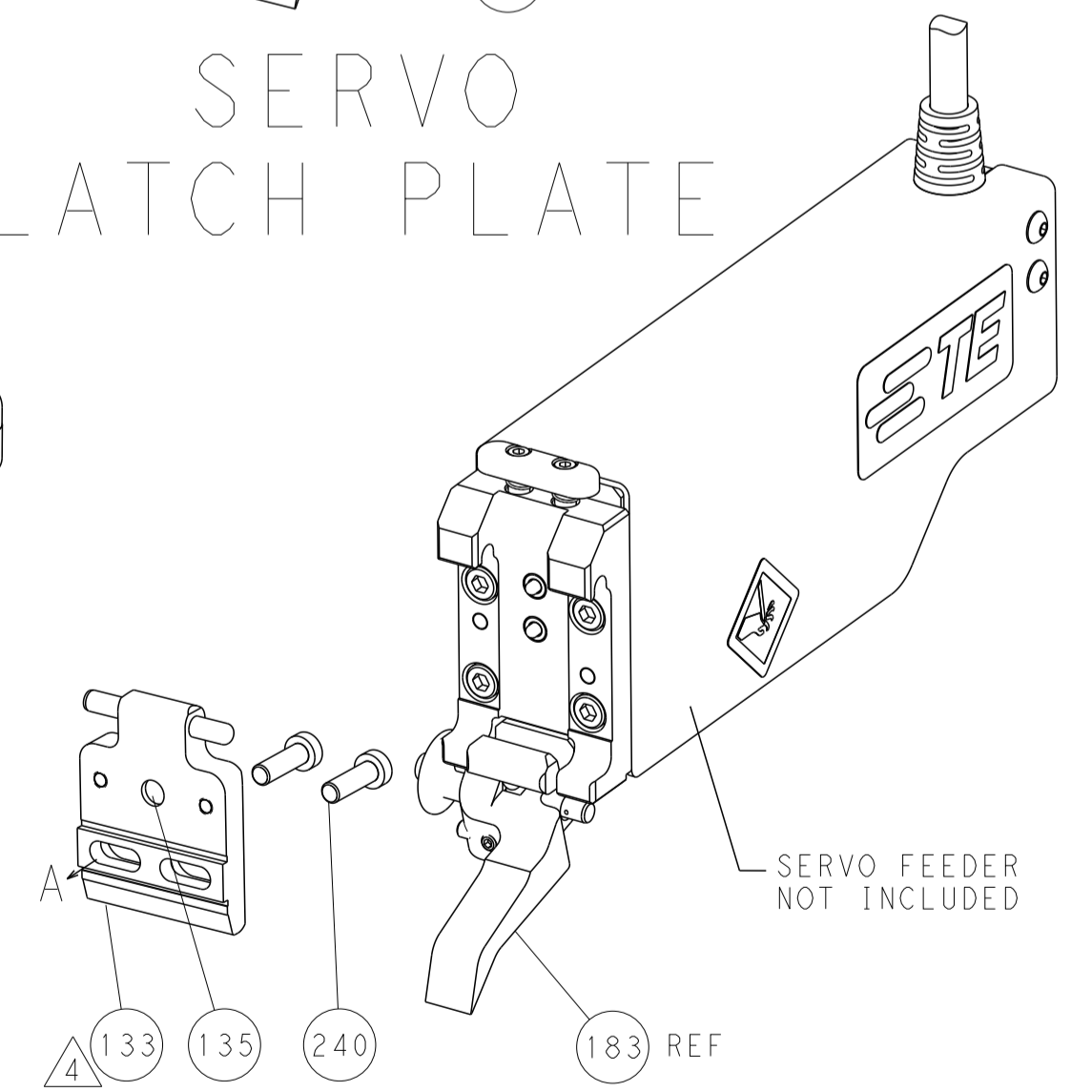
FEED TYPE
MECHANICAL



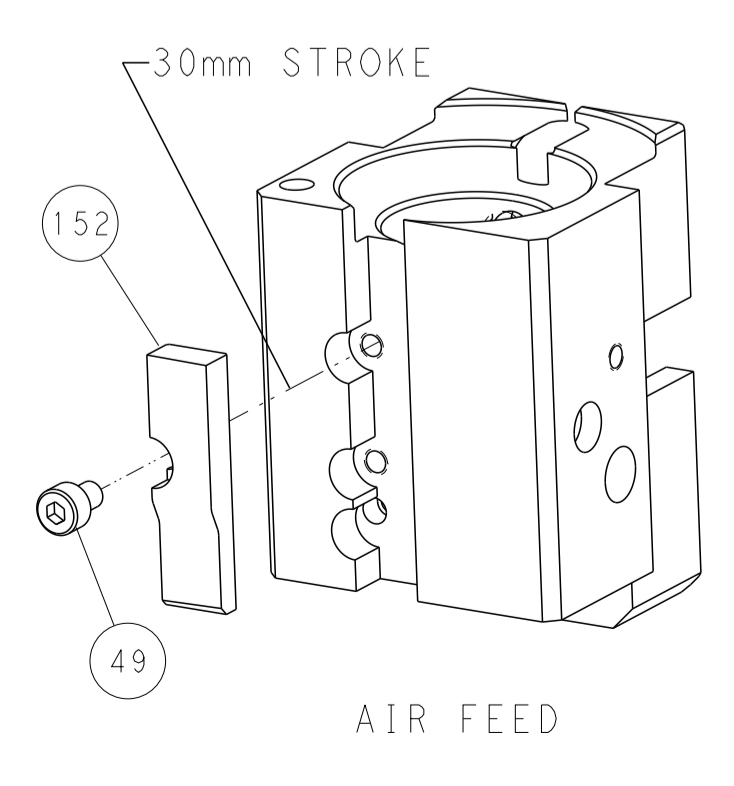
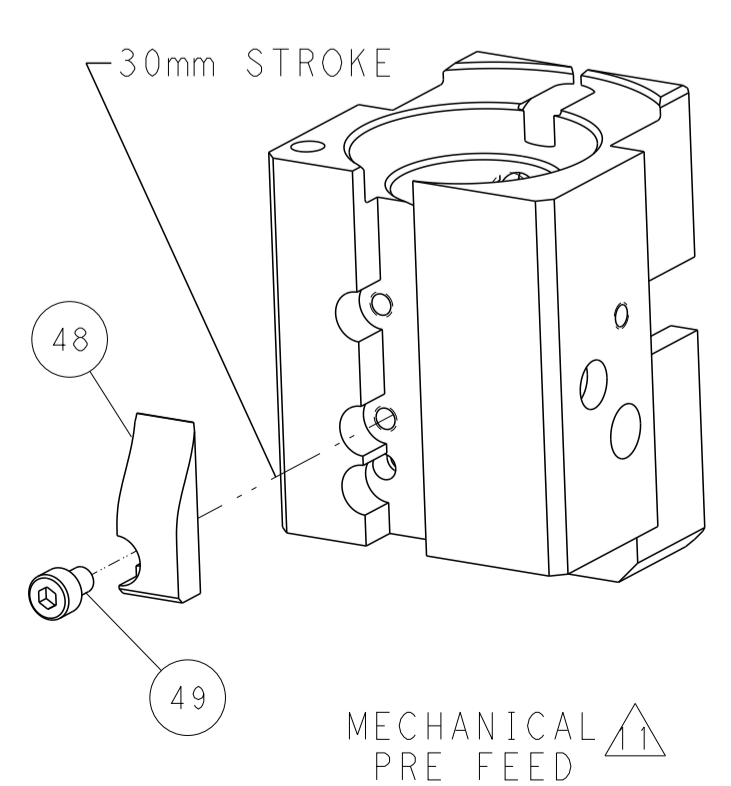
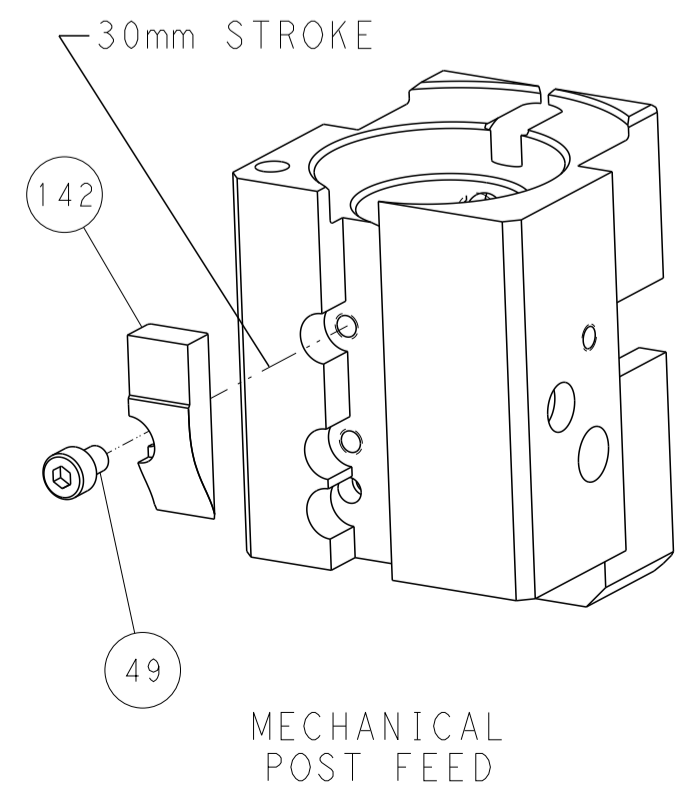
PNEUMATIC



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 J. HOU 09MAY2016		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD L. ZHANG 09MAY2016	NAME Ocean End Feed Applicator
MATERIAL	FINISH	WEIGHT	SCALE 1:1	SHEET 4	OF 4	REV A	RESTRICTED TO
CUSTOMER DRAWING		A1 00779 C=2150672		SCALE 1:1		SHEET 4 OF 4 REV A	