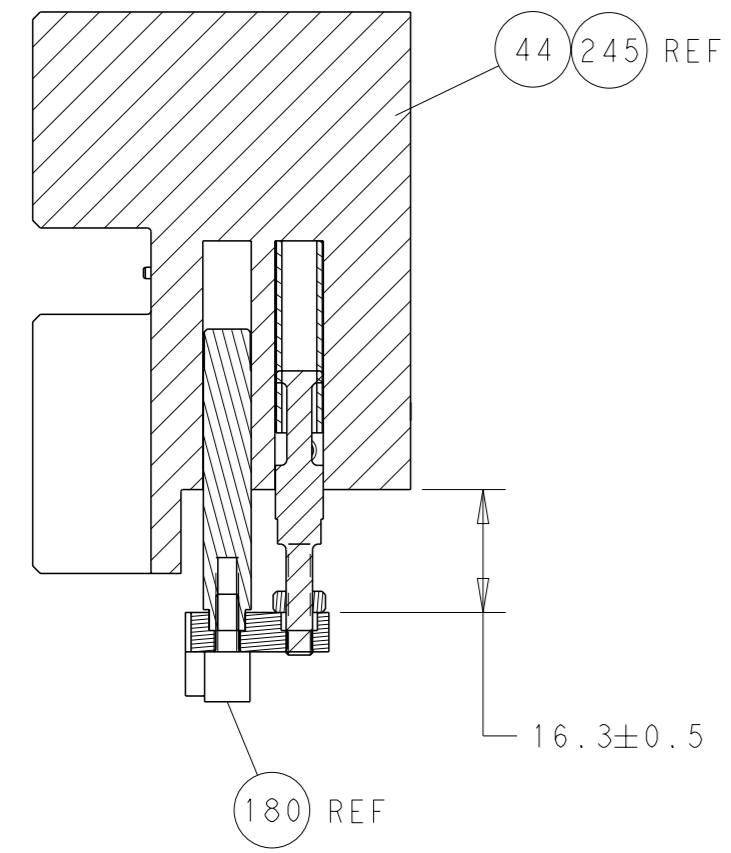
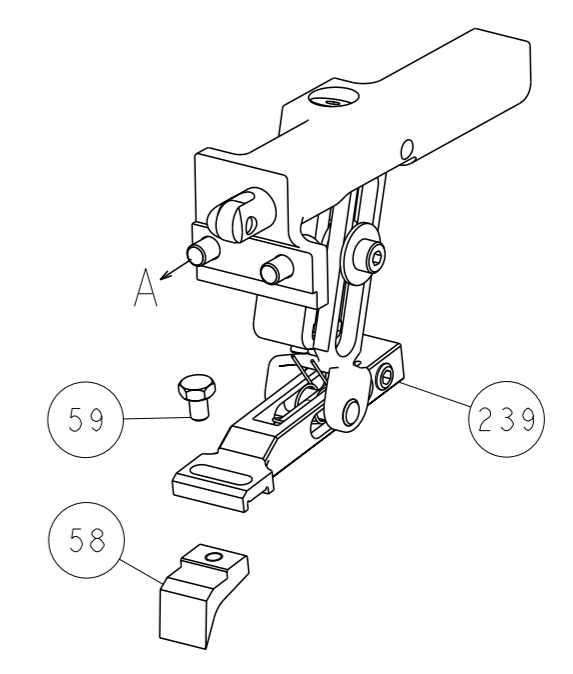


LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

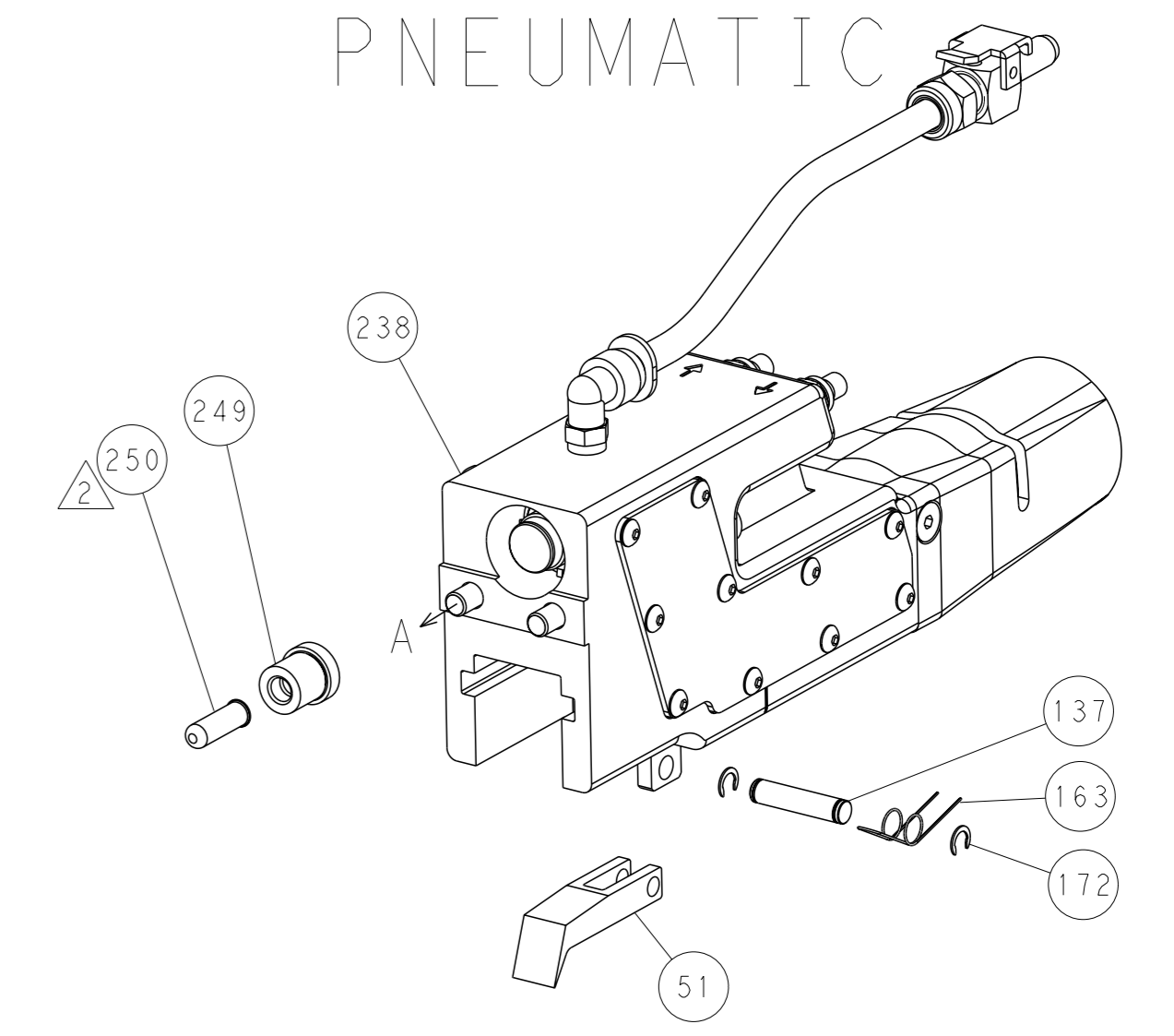


HOLDDOWN SET-UP

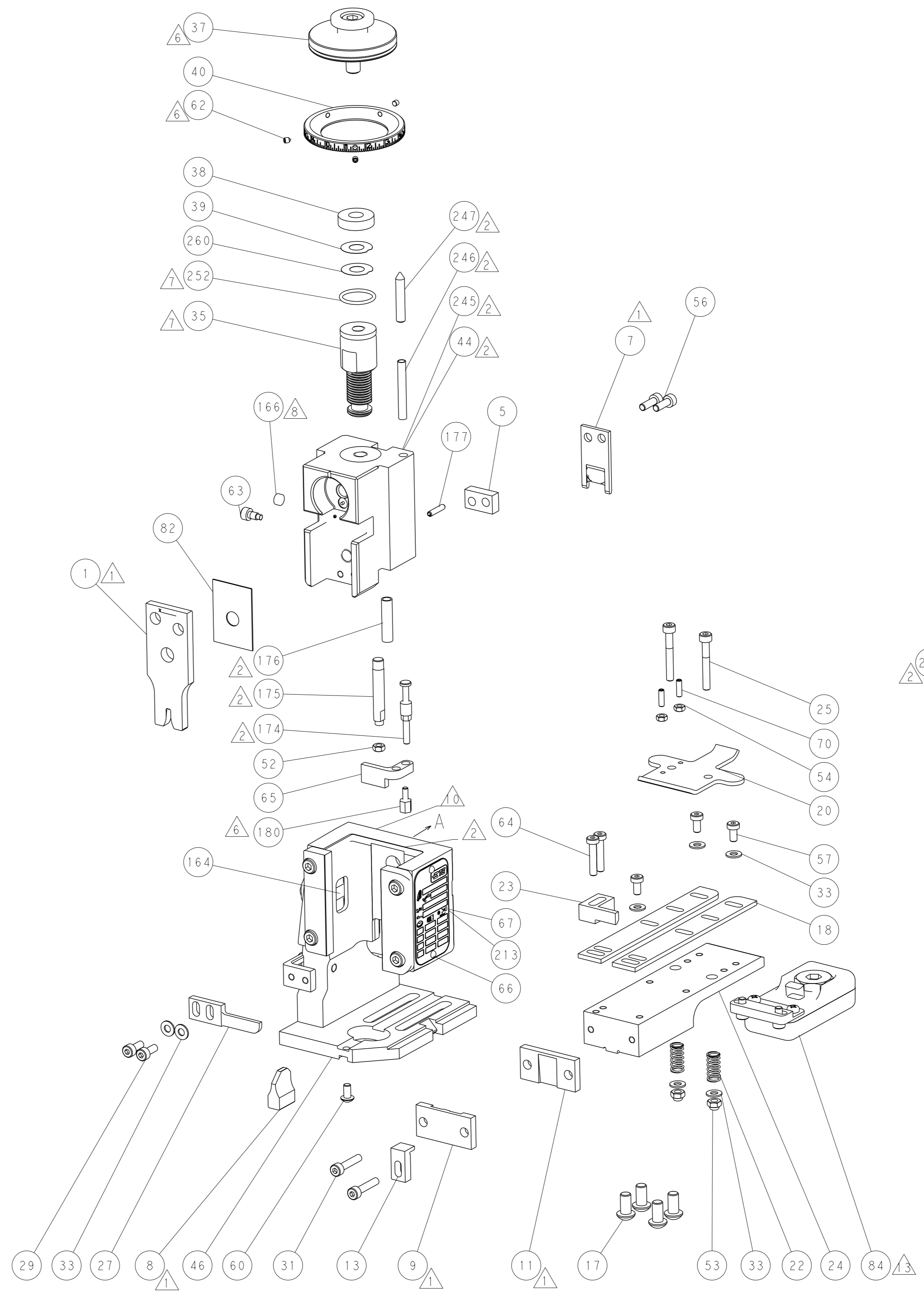
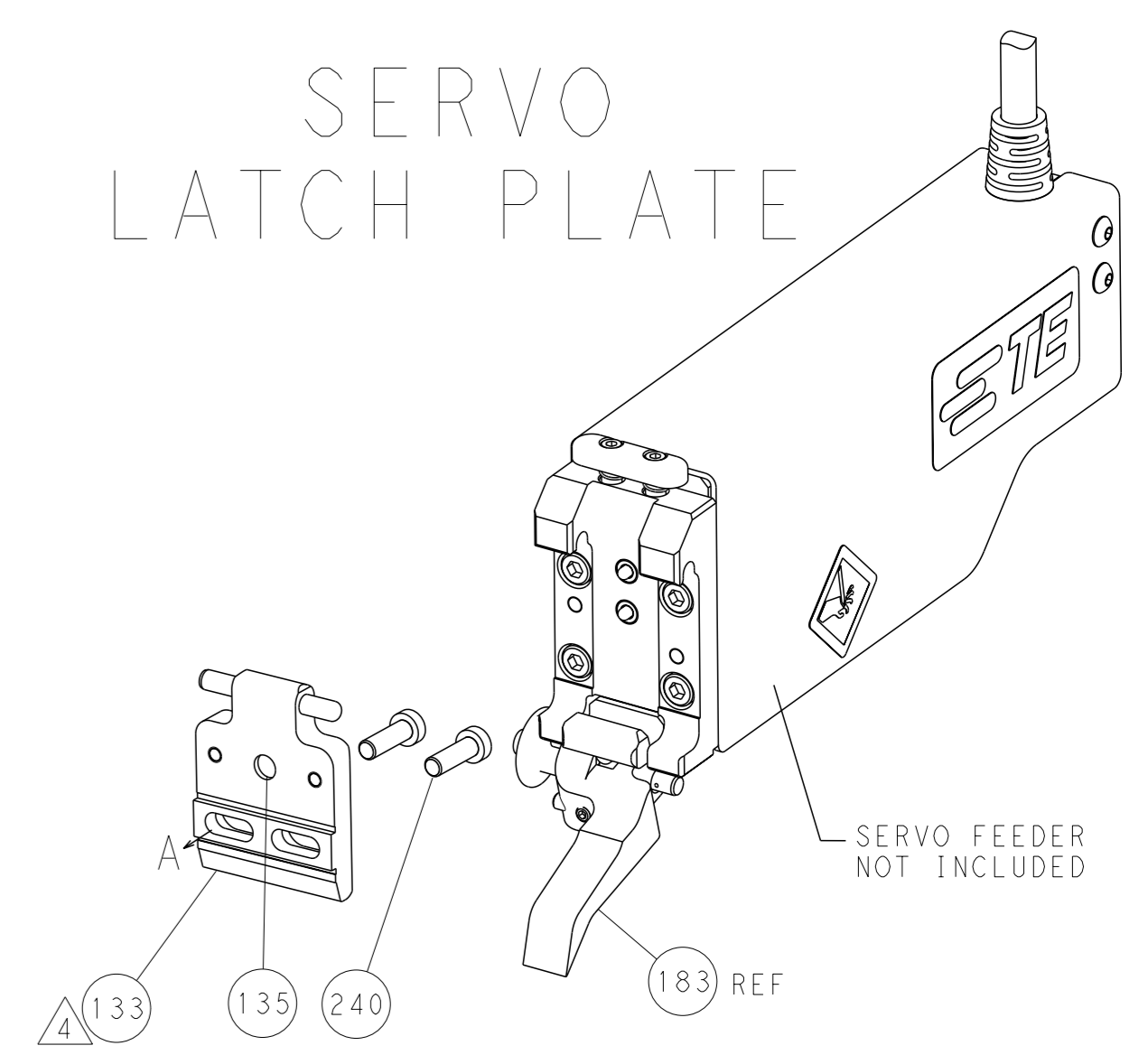
FEED TYPE
MECHANICAL



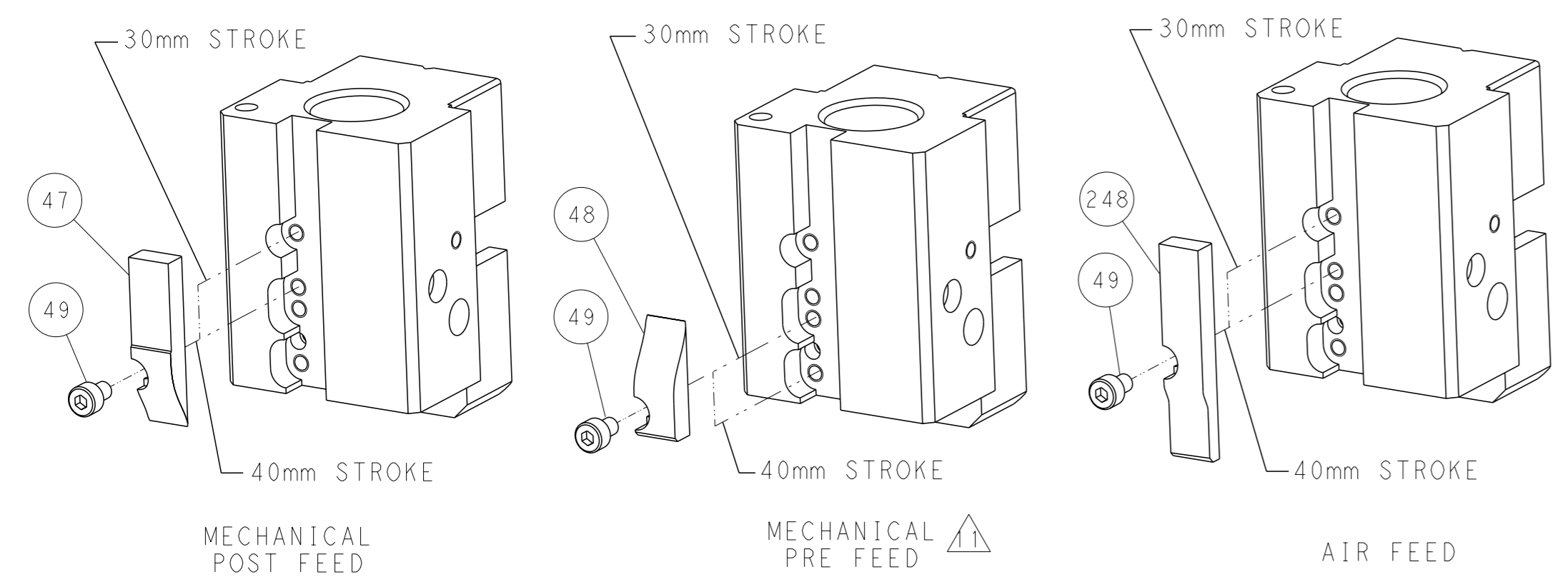
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: F. ZHANG 27JUN2017 CHK: T. ELBIN 27JUN2017 APVD: T. ELBIN 27JUN2017	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC WEIGHT SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150820	RESTRICTED TO: - SHEET 2 of 4 REV A
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150820-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150820-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150820-4	-	-	-
	2-2150820-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150820-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150820-4	-	-	-
	2-2150820-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150820-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150820-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.79 mm (.110)	F	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
7.05-7.43 mm (.278-.293 IN)		
TERMINAL APPLICATION SPECIFICATION	114-2036	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
60938-1	60938-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.83 +/- 0.05 [0.072 +/- .002]	5.5
16 AWG	1.60 +/- 0.05 [0.063 +/- .002]	7.9
18 AWG	1.45 +/- 0.05 [0.057 +/- .002]	9.4

- 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: 8-2150820-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150820-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150820-5
- 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.

	ITEM NO	DESCRIPTION	ITEM NO
- 1 1 1 1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- - - 1 -	2119640-1	PUSH ROD, AIR FEED	250
- - - 1 -	1803259-1	BUSHING, FLANGED	249
-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO

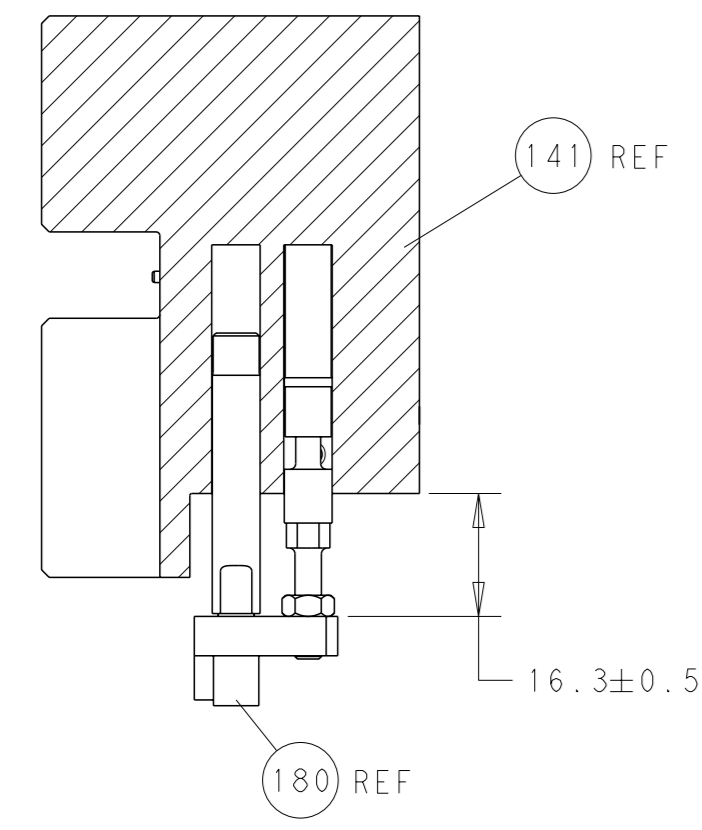
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

REV	DATE	BY	APPV	DESCRIPTION	DATE	OWN	APPV
- 1 1 1 1	1-22279-3			SPRING, COMPRESSION			246
- - 2 - -	2168400-7			SHCS, LOW HEAD, RoHS, M5 X 10			240
- - - 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
- - REF - -	1901697-1			FEED FINGER ASSEMBLY, EF			183
- 1 1 1 1	1-1752354-1			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
- REFREFREFREF	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
- - - 1 -	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
- - - - 1	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
- - - 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 1	2119955-2			ASSY, LUBRICATOR, END FEED			84
- 1 1 1 1	455888-5			SPACER, CRIMPER			82
- 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	2119740-1			TAG, IDENTIFICATION			67
- 2 2 2 2	2168078-1			SCREW, DRIVE, RH, RoHS, 2 x .188			66
- 1 1 1 1	1901681-1			HOLDDOWN, TERMINAL			65
- 2 2 2 2	2168400-5			SHCS, LOW HEAD, RoHS, M4 X 20			64
- 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
- - - - 1	5-18022-5			SCR, HEX HD CAP, M4 X 6.0			59
- - - - 1	2063961-1			FEED FINGER			58
- 3 3 3 3	2168400-4			SHCS, LOW HEAD, RoHS, M4 X 8			57
- 2 2 2 2	2168083-3			SCR, SKT HD CAP, RoHS, M4 X 12.0			56
- 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
- - - 1 -	2119792-2			PAWL, EF, AIR			51
- - - 1 2	18023-9			SCR, SKT HD CAP M4 X 6.0			49
- - - - 1	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	1-2119644-2			RAM WASHER, PRECISION			38
- 7 7 7 7	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	1-2168083-5			SCR, SKT HD CAP, RoHS, M4 X 30			25
- 1 1 1 1	1752371-5			PLATE, STRIP GUIDE			24
- 1 1 1 1	240825-6			PLATE, STRIP HOLD DOWN			23
- 2 2 2 2	2-22281-3			SPRING, COMPRESSION			22
- 1 1 1 1	1803292-4			DRAG			20
- 2 2 2 2	1901259-5			GUIDE, LOWER STRIP			18
- 1 1 1 1	1752360-1			SPACER, HOLD-DOWN			13
- 1 1 1 1	240644-1			PLATE, REAR SHEAR			11
- - - - -	-			-			10
- 1 1 1 1	690482-3			PLATE, FRONT SHEAR			9
1 1 1 1 1	3-1803002-0			ANVIL, COMBINATION, END FEED			8
- 1 1 1 1	1-2217206-4			BLADE, SLUG			7
- - - - -	-			-			6
- 1 1 1 1	8-240641-8			SPACER			5
- - - - -	-			-			4
- - - - -	-			-			3
- - - - -	-			-			2
1 1 1 1 1	456408-4			CRIMPER, WIRE PREMIUM			1
-77-27-25-22-21	PART NO			DESCRIPTION			ITEM NO

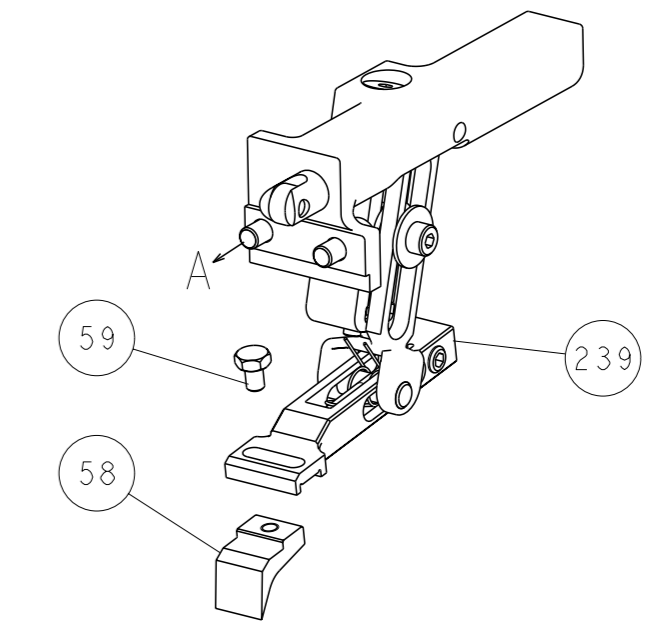
DIMENSIONS: 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: F. ZHANG 27JUN2017 CHK: T. ELBIN 27JUN2017 APPV: T. ELBIN 27JUN2017		NAME: TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		SIZE: A1		CAGE CODE: 00779	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET: 3 of 4		REV: A	

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

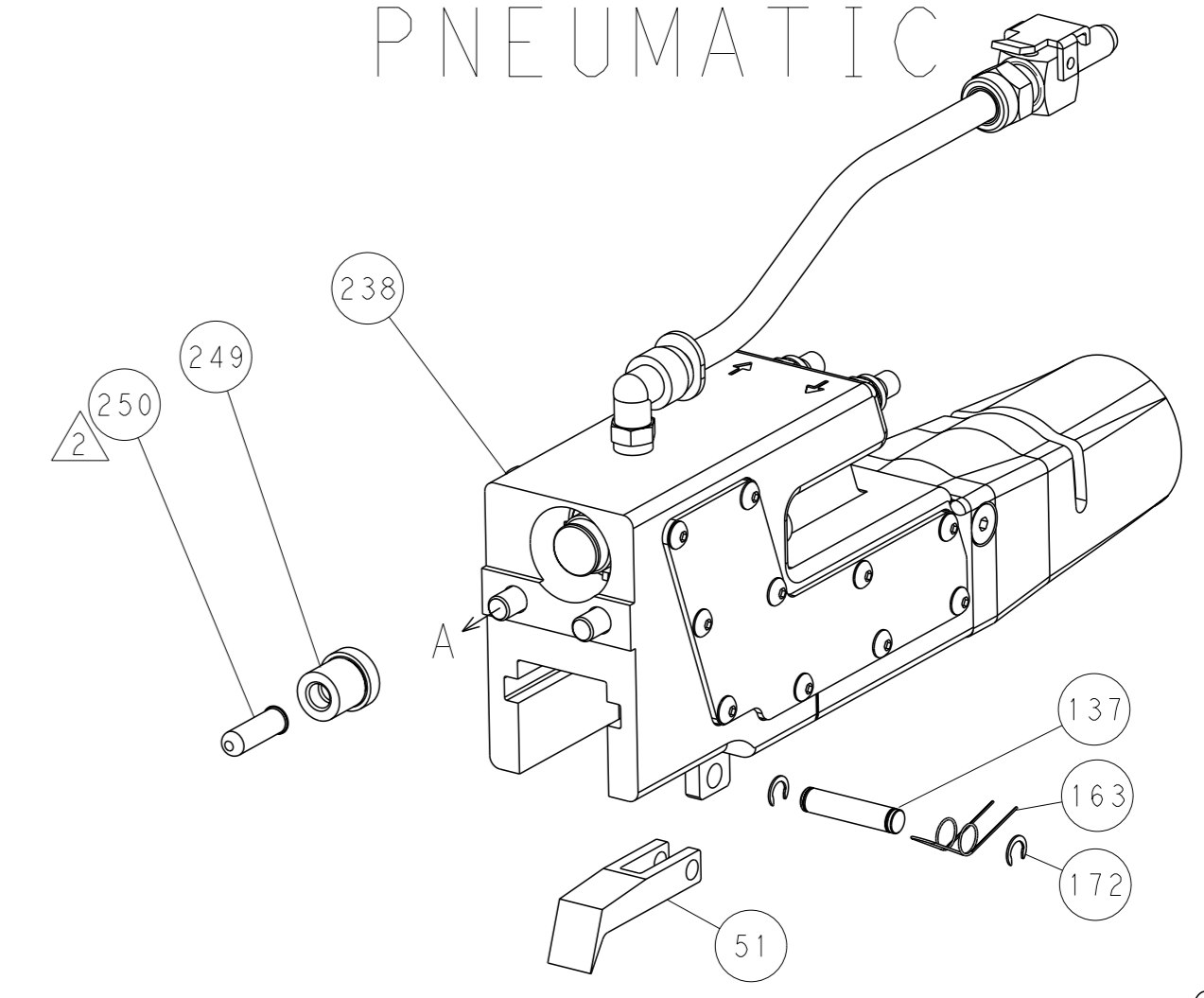


HOLDDOWN SET-UP

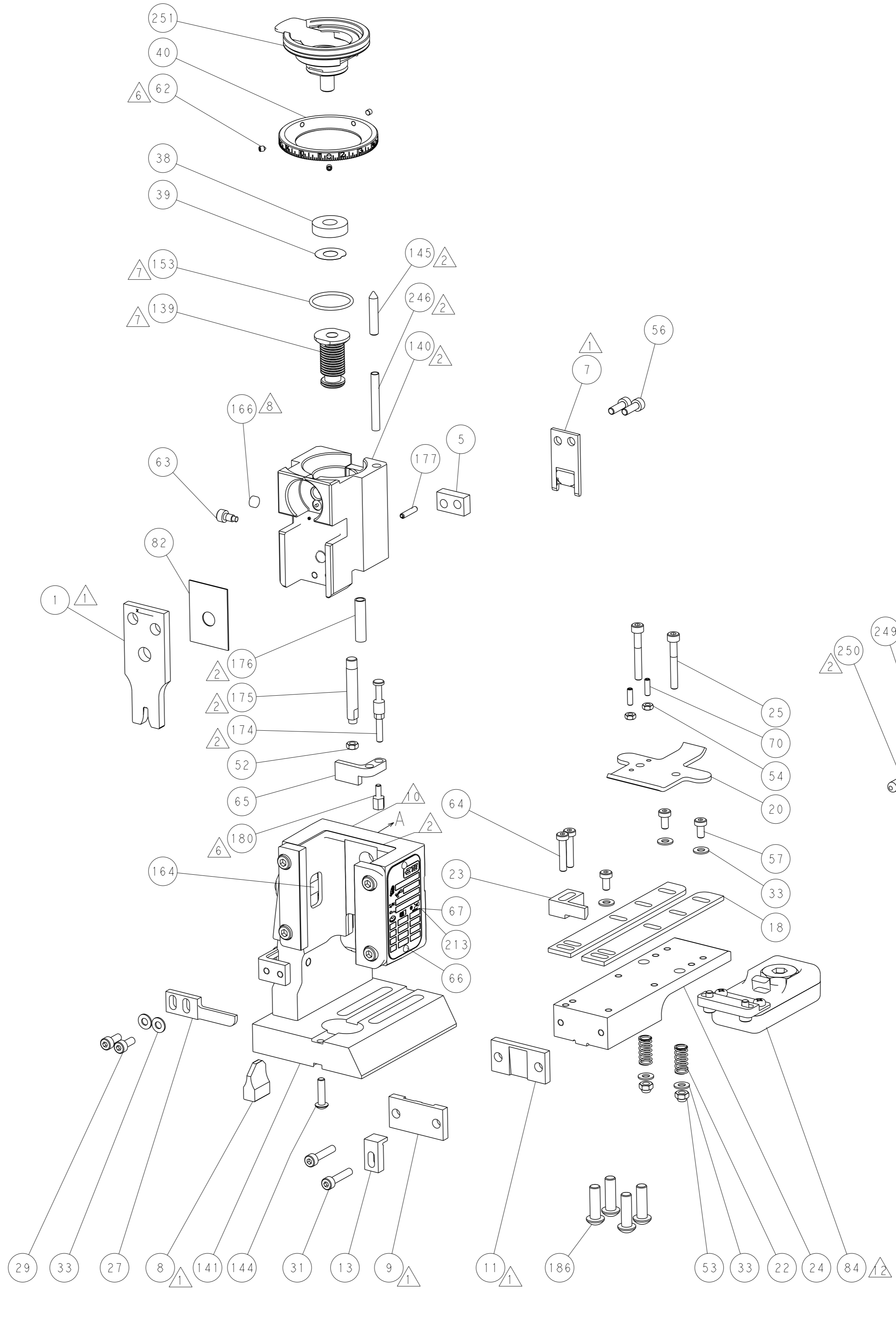
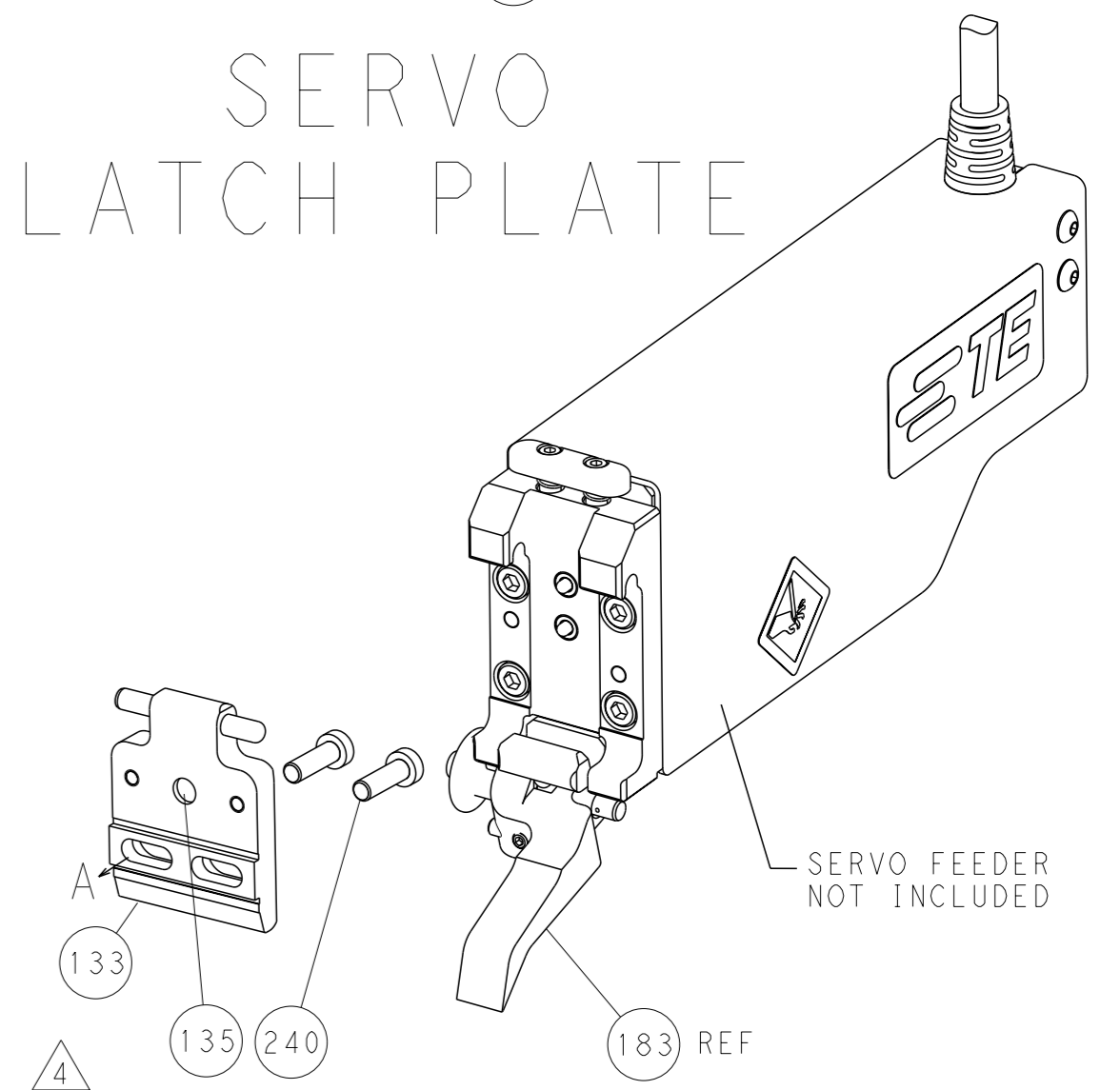
FEED TYPE
MECHANICAL



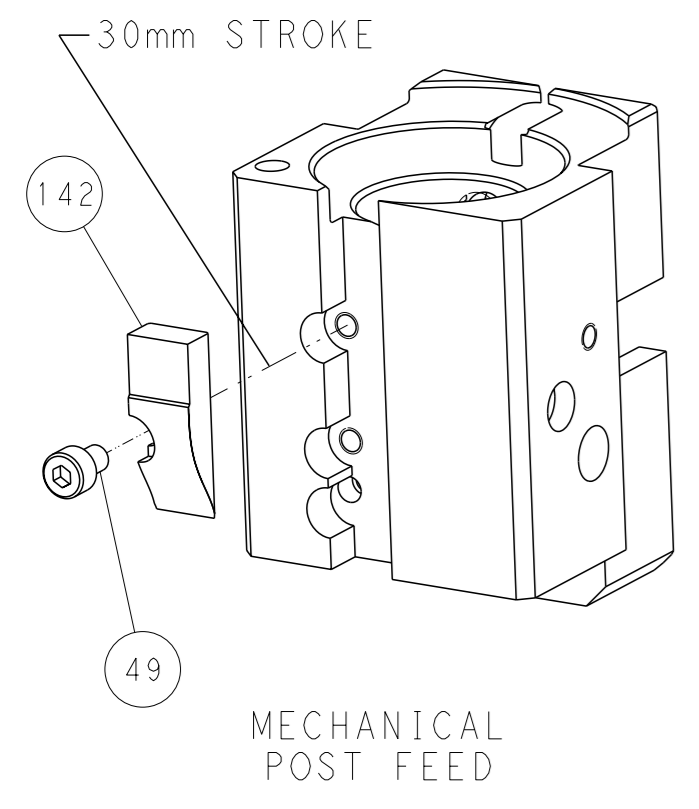
PNEUMATIC



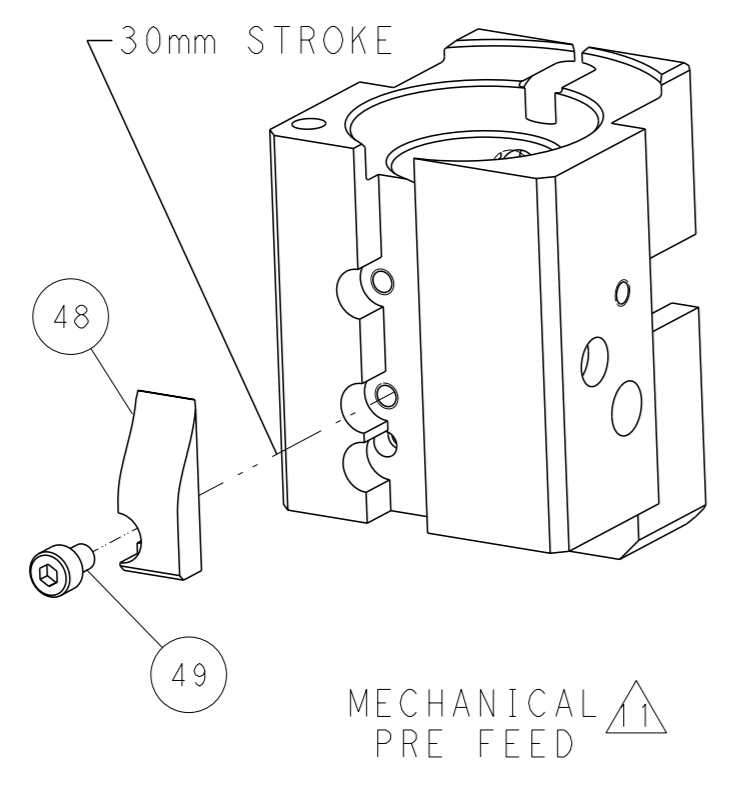
SERVO
LATCH PLATE



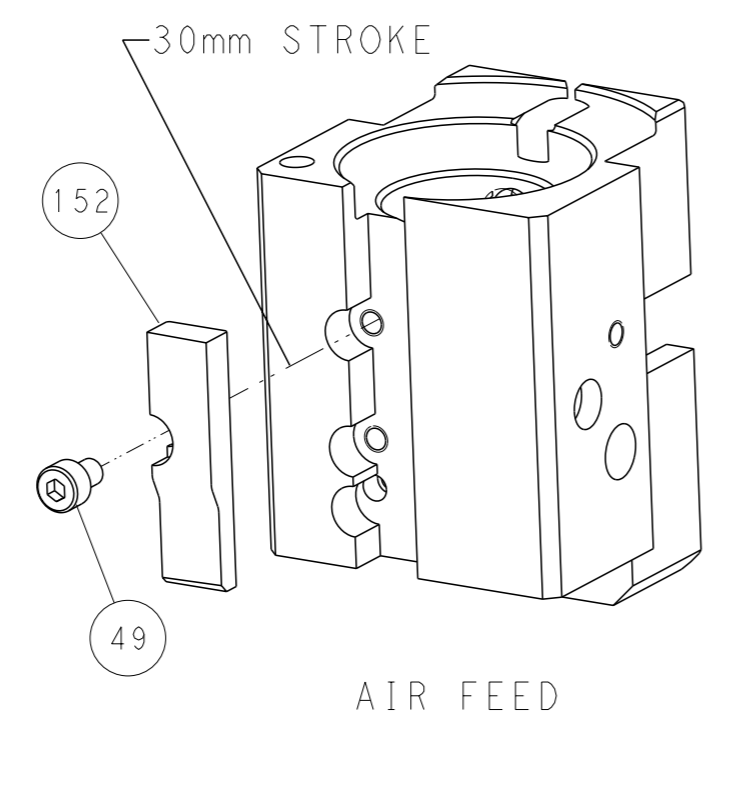
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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: F. ZHANG 27JUN2017		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD: T. ELBIN 27JUN2017		NAME: Ocean End Feed Applicator	
MATERIAL:				WEIGHT:		SIZE: CAGE CODE: DRAWING NO: A1 00779 C=2150820	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 4 OF 4 REV A	