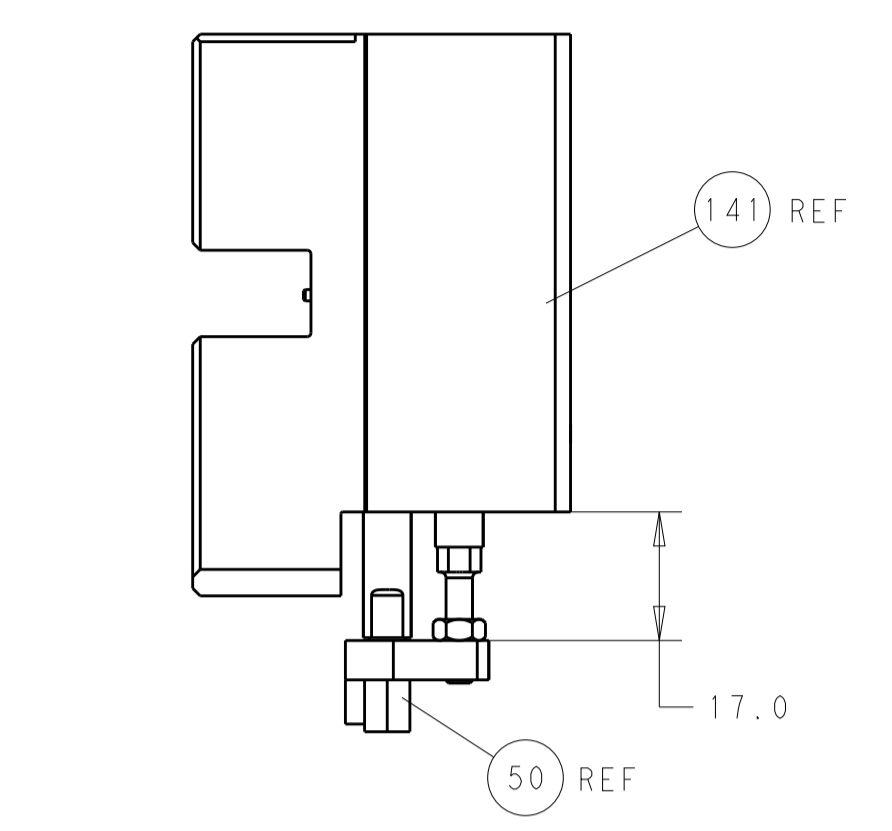
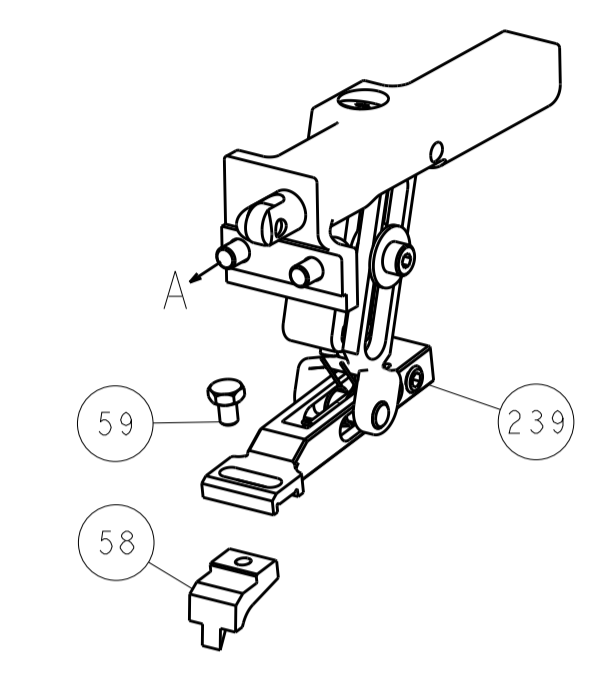


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

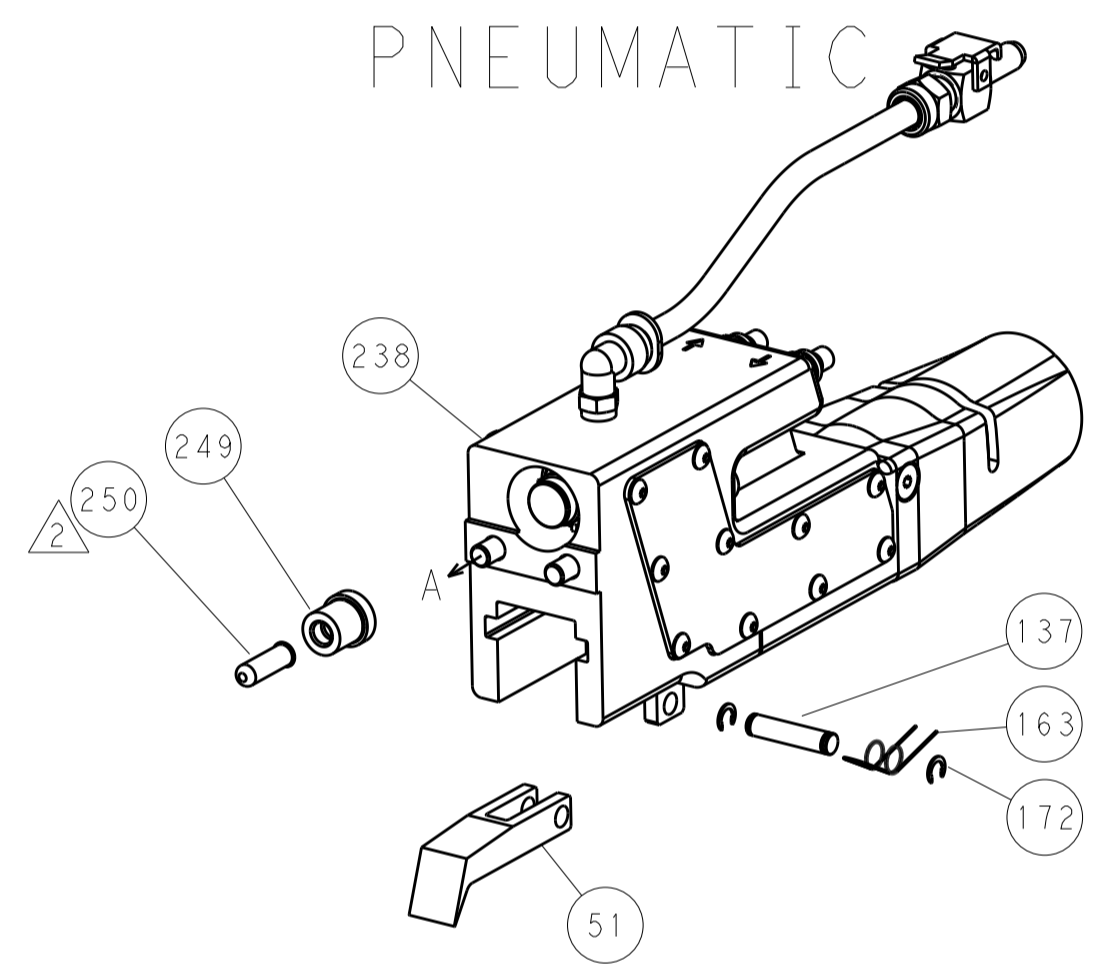


HOLDDOWN SET-UP

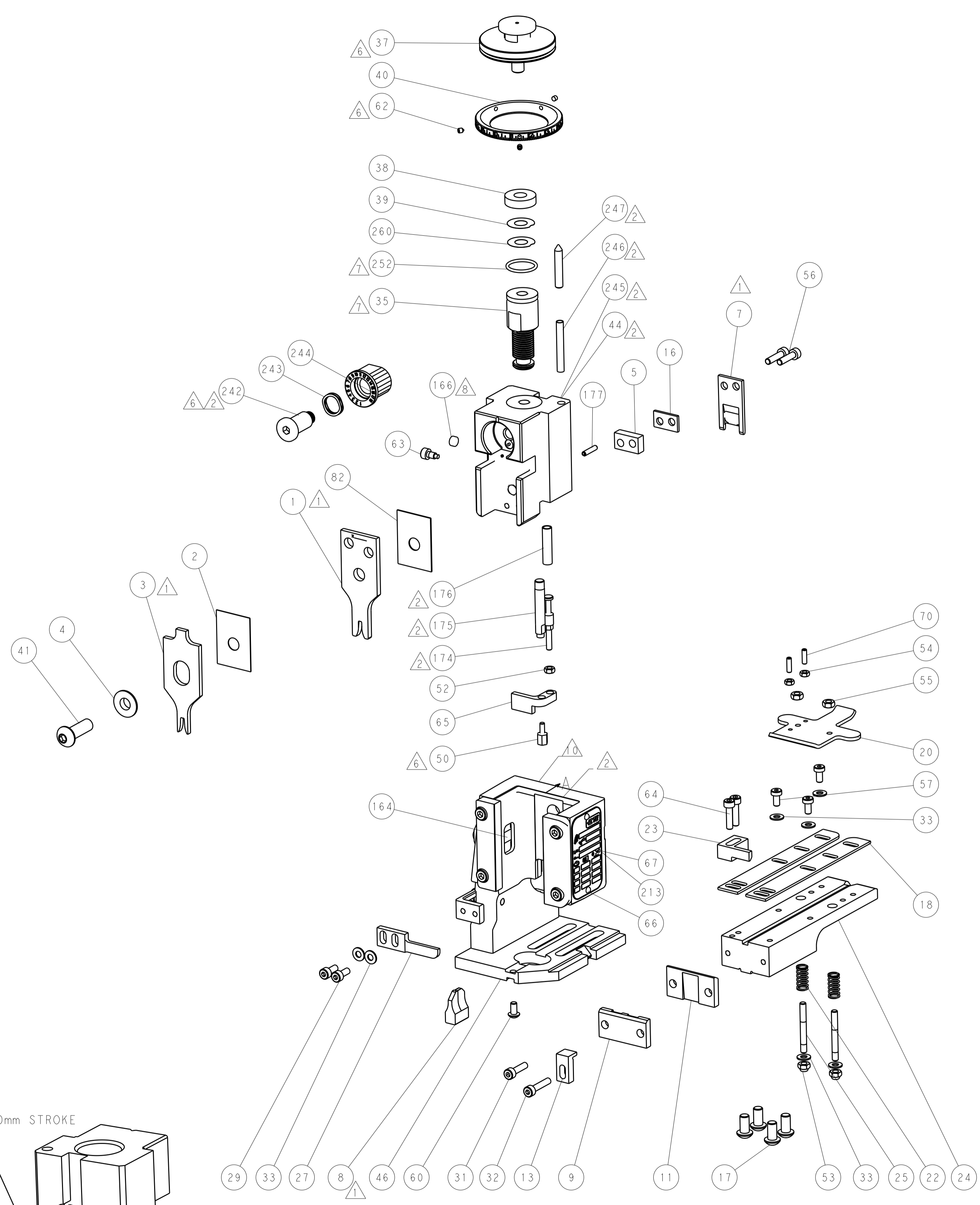
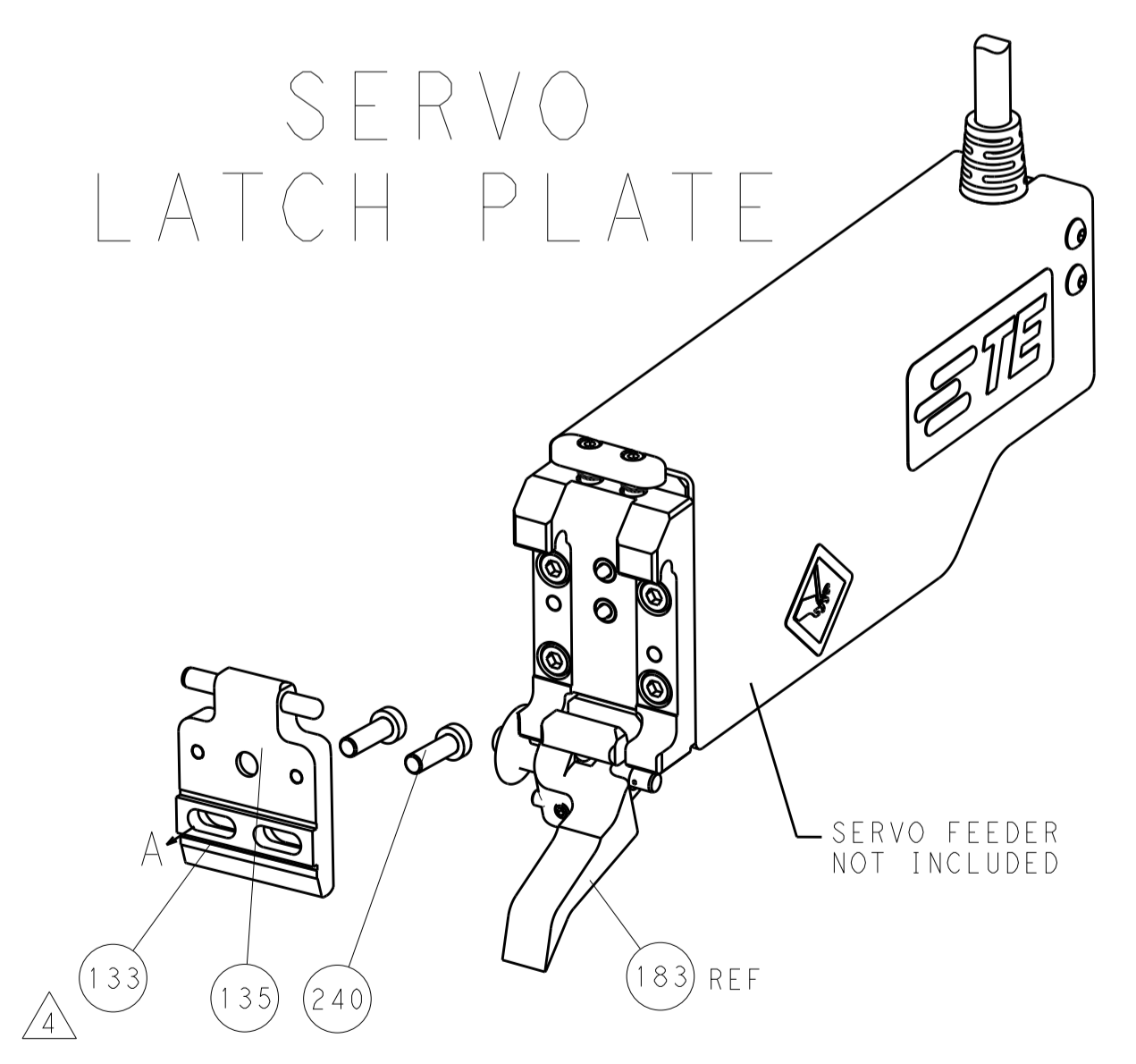
FEED TYPE
MECHANICAL



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB_HIGMAN 03OCT2013		TE Connectivity	
mm	0 PLC	±		CHK: T_ELFIN 03OCT2013	NAME		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: M_CLIFFORD 03OCT2013	PRODUCT SPEC		
	2 PLC	±			APPLICATION SPEC		
	3 PLC	±			SIZE		CAGE CODE DRAWING NO
	4 PLC	±			WEIGHT		RESTRICTED TO
	ANGLES	±			A11 00779 ©=2150376		
MATERIAL:	FINISH:				Customer Accessible Production Drawing		SCALE 1:1 SHEET 2 OF 4 REV B

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-
	2-2150376-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150376-5	-	-	2168400-7 (QUANTITY 2)
	2-2150376-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SMART APPLICATOR	2161326-1	-	8-2150376-4	-	-	-
	2-2150376-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150376-7	B	FINE CRIMP HEIGHT ADJUST	NONE	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150376-5	-	-	2168400-7 (QUANTITY 2)
	7-2150376-7	B	CRIMP TOOLING KIT	-	SMART APPLICATOR	2161326-1	-	8-2150376-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1

CRIMP SIZE	WIRE	INSUL	TYPE
2.28 mm [.090]	2.28 mm [.090]	3.00 mm [.118]	F
			F
APPL INSTRUCTIONS 408-10390			

TERMINAL DATA: TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: L.I.F. POSITIVE LOCK CONTACT 5MM SERIES	
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]	INSULATION DIAMETER RANGE 1.30-2.00 mm [.051-.079 IN]
TERMINAL APPLICATION SPECIFICATION 114-15008	
TERMINALS APPLIED	
TE TERMINAL 141991-1	TE TERMINAL 141991-3
TE TERMINAL 141991-2	TE TERMINAL 1-141991-2
	TE TERMINAL 142685-3
	TE TERMINAL 2-141991-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.6+0.35	1.42+/-0.05 [.056+/- .002]	8.5
1.00mm2	1.42+/-0.05 [.056+/- .002]	8.5
0.35+0.35	1.35+/-0.05 [.053+/- .002]	9.4
0.60mm2	1.29+/-0.05 [.051+/- .002]	10.1
0.35mm2	1.19+/-0.05 [.047+/- .002]	11.4

- 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: 8-2150376-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150376-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150376-5
- 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 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

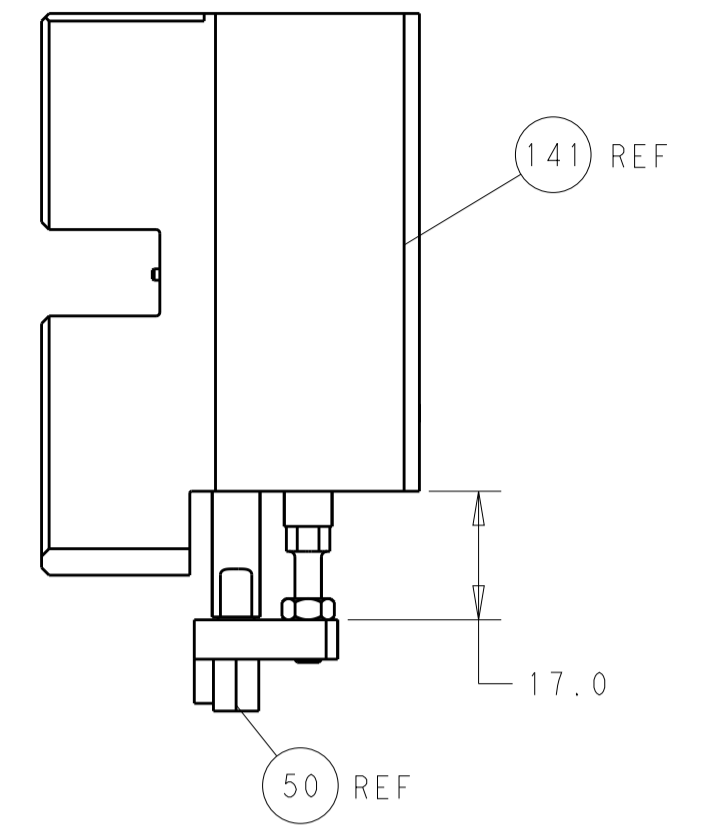
	DESCRIPTION	ITEM NO
- 1 1 1 1 1	2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- - - 1 -	2119640-1 PUSH ROD, AIR FEED	250
- - - 1 -	2079988-1 BUSHING, LCH5-12, MISUMI	249
- 1 1 1 1 1	1-22279-3 SPRING, COMPRESSION	246
- 1 1 1 1 1	2119082-9 CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
- 1 1 1 1 1	2119083-1 RETAINER, INSULATION DIAL	242
- - 2 - -	2168400-7 SHCS, LOW HEAD, RoHS, M5 X 10	240
-77-27-25-22-21	PART NO	DESCRIPTION

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

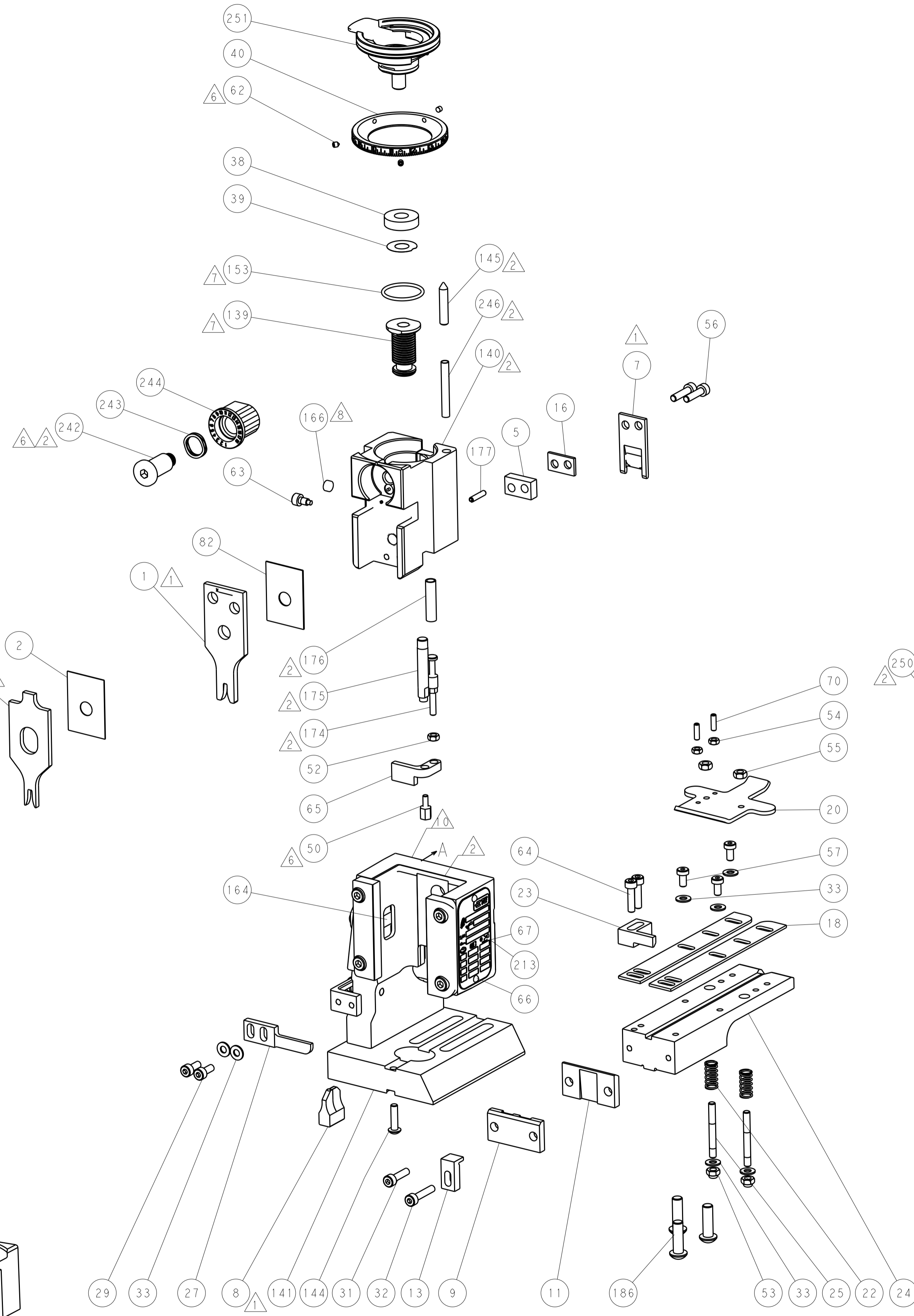
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	#	DATE	BY	APPV
			-	SEE SHEET 1		

	DESCRIPTION	ITEM NO	
- - - 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	6-993111-6 PIN, SLOTTED SPRING 3.0 X 14.0	177	
- 1 1 1 1 1	8-22280-7 SPRING, COMPRESSION	176	
- 1 1 1 1 1	1752353-2 GUIDE PIN, HOLDDOWN	175	
- 1 1 1 1 1	1901680-2 GUIDE PIN, HOLDDOWN	174	
- - - 2 -	21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
- 1 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 1	8-21084-1 O-RING, .801 ID, .070 DIA. MAT.	153	
- - - 1 -	2119641-2 FEED CAM, AIR FEED	152	
- 1 1 1 1 1	2119798-2 DETENT PIN	145	
- 1 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 1	2119655-6 APPLICATOR BASIC ASSEMBLY, EF	141	
- 1 1 1 1 1	2119651-1 RAM, ASIAN STYLE, END FEED	140	
- 1 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 1	455888-5 SPACER, CRIMPER	82	
- 1 1 1 1 1	2119956-2 DOCUMENTATION PACKAGE	71	
- 2 2 2 2 2	2-18032-2 SCR, SET, FLT POINT M3 X 10.0	70	
- 1 - 1 1 1	2119740-1 TAG, IDENTIFICATION	67	
- 2 2 2 2 2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66	
- 1 1 1 1 1	1901681-1 HOLDDOWN, TERMINAL	65	
- 2 2 2 2 2	2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	64	
- 1 1 1 1 1	2119793-1 LIMITER, ADJUSTMENT BOLT	63	
- 3 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 3	2168400-4 SHCS, LOW HEAD, RoHS, M4 X 8	57	
- 2 2 2 2 2	2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	56	
- 2 2 2 2 2	5018030-2 NUT, HEX, REG, RoHS, M4	55	
- 2 2 2 2 2	5018030-1 NUT, HEX, REG, RoHS, M3	54	
- 2 2 2 2 2	986965-8 NUT, LOCK, HEX, TORQUE (M4)	53	
- 1 1 1 1 1	1-5018030-0 NUT, HEX, REG, RoHS, M3.5	52	
- - - 1 -	2119792-2 PAWL, EF, AIR	51	
- 1 1 1 1 1	1-1752354-2 STANDOFF, HOLD-DOWN	50	
- - - 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 1	2079383-7 SCR, BHSC, RoHS (M8 X 25)	41	
- 1 1 1 1 1	2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT	40	
- 1 1 1 1 1	2119957-1 APPLICATOR SHIM PACK	39	
- 1 1 1 1 1	1-2119644-2 RAM WASHER, PRECISION	38	
- 7 7 7 7 7	1-18028-2 WASHER, FLAT, REG M4	33	
- 1 1 1 1 1	2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	32	
- 1 1 1 1 1	2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	31	
- 2 2 2 2 2	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	29	
- 1 1 1 1 1	240639-1 STRIPPER (MACHINING)	27	
- 2 2 2 2 2	1320906-1 STUD, THREADED	25	
- 1 1 1 1 1	1752371-6 PLATE, STRIP GUIDE	24	
- 1 1 1 1 1	240825-1 PLATE, STRIP HOLD DOWN	23	
- 2 2 2 2 2	2-22281-3 SPRING, COMPRESSION	22	
- 1 1 1 1 1	1752373-4 DRAG	20	
- 2 2 2 2 2	1901259-3 GUIDE, LOWER STRIP	18	
- 1 1 1 1 1	4-240641-2 SPACER	16	
- 1 1 1 1 1	1752360-1 SPACER, HOLD-DOWN	13	
- 1 1 1 1 1	240833-2 PLATE, REAR SHEAR	11	
- - - - -	-	10	
- 1 1 1 1 1	690496-6 PLATE, FRONT SHEAR	9	
1 1 1 1 1 1	3-1803001-1 ANVIL, COMBINATION, END FEED	8	
- 1 1 1 1 1	2217206-2 BLADE, SLUG	7	
- - - - -	-	6	
- 1 1 1 1 1	6-240641-5 SPACER	5	
- 1 1 1 1 1	238009-1 BLOCK, FL CRIMPER SPACER	4	
1 1 1 1 1 1	2-1803016-5 CRIMPER, INSULATION F	3	
- 1 1 1 1 1	455888-3 SPACER, CRIMPER	2	
1 1 1 1 1 1	1-456406-5 CRIMPER, WIRE PREMIUM	1	
-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO

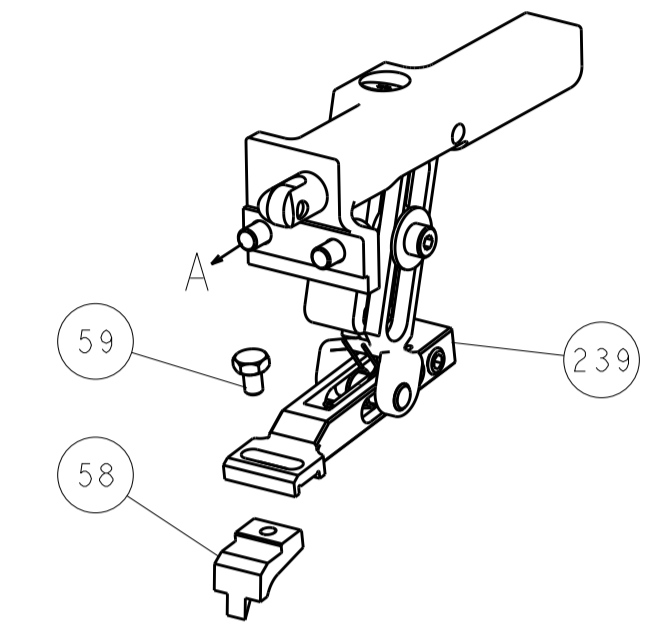
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
				SEE SHEET 1			



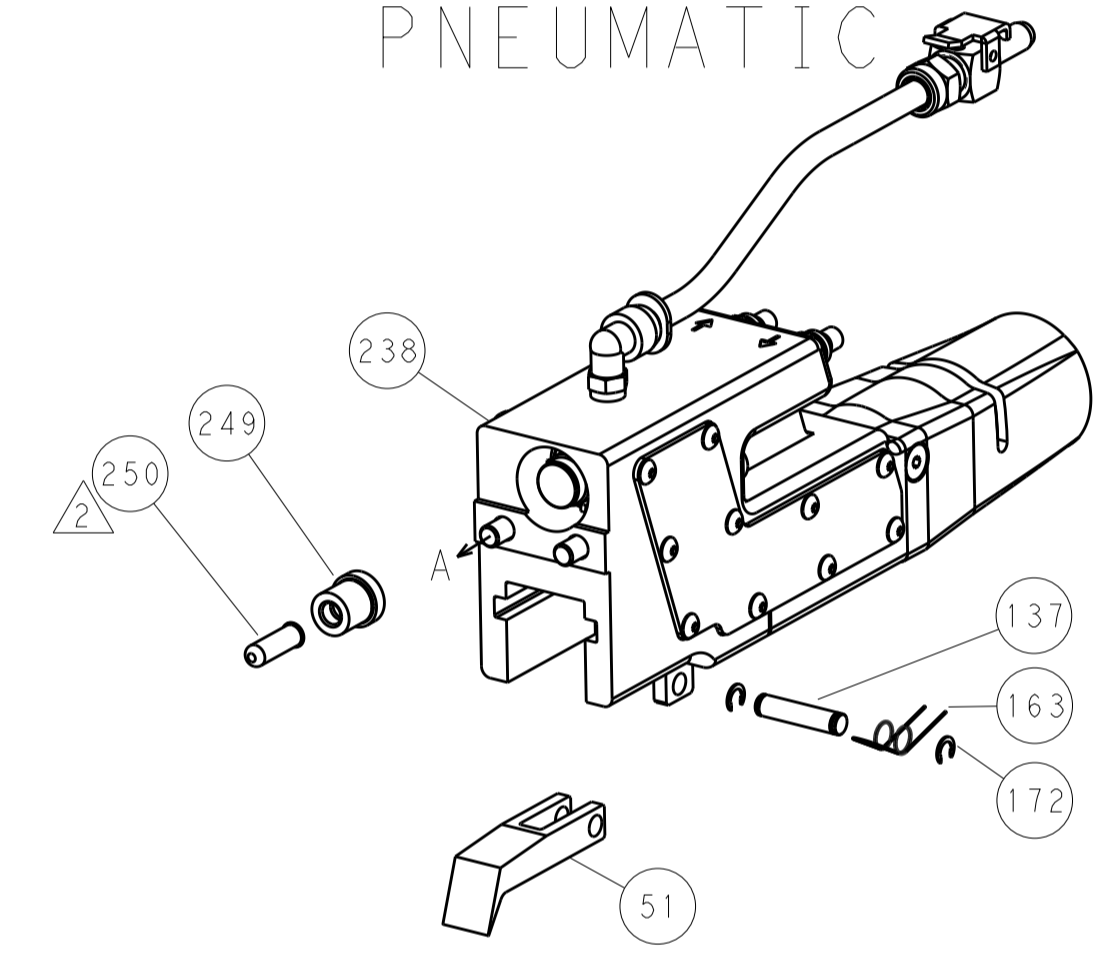
HOLDDOWN SET-UP



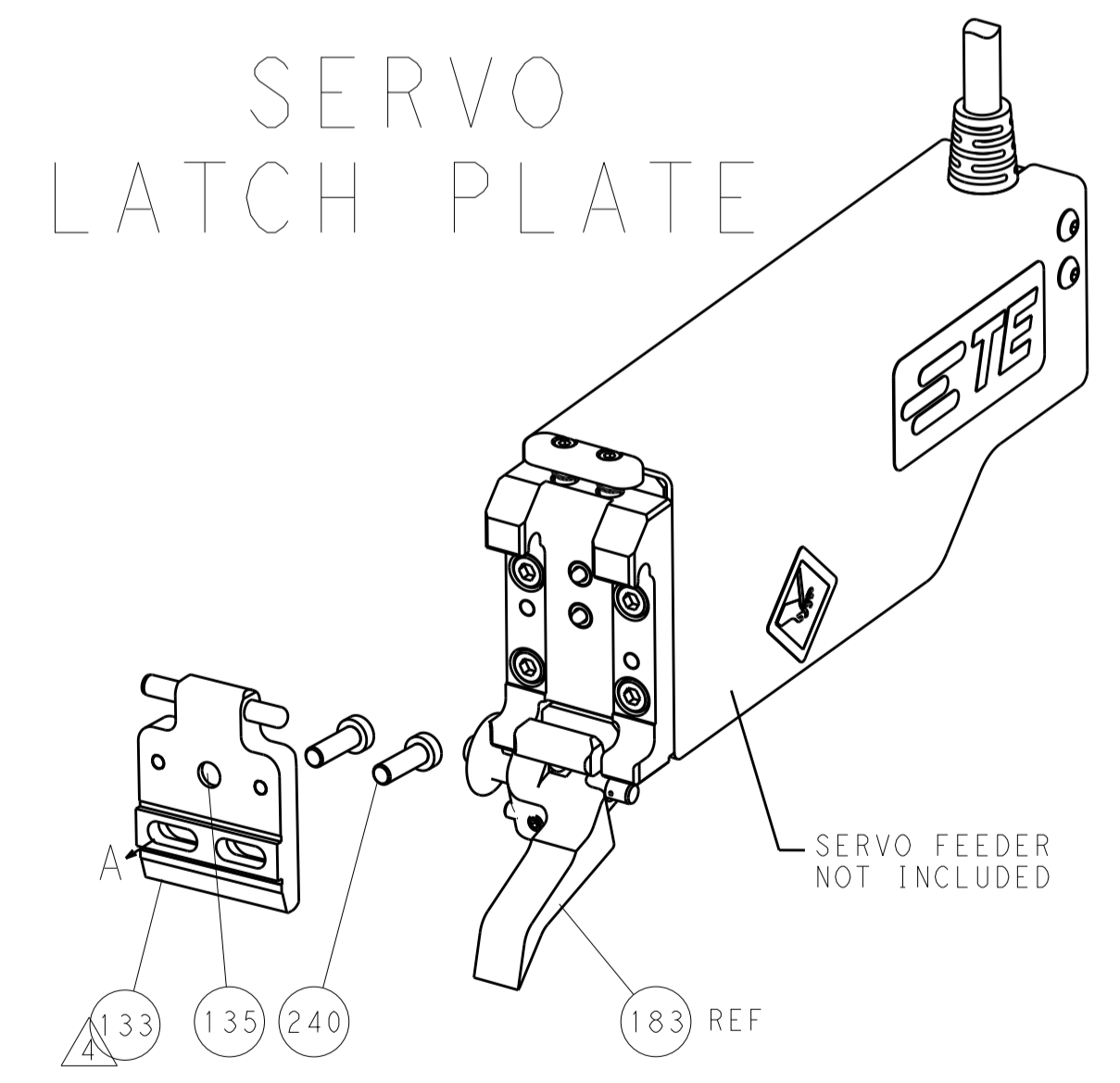
FEED TYPE
MECHANICAL



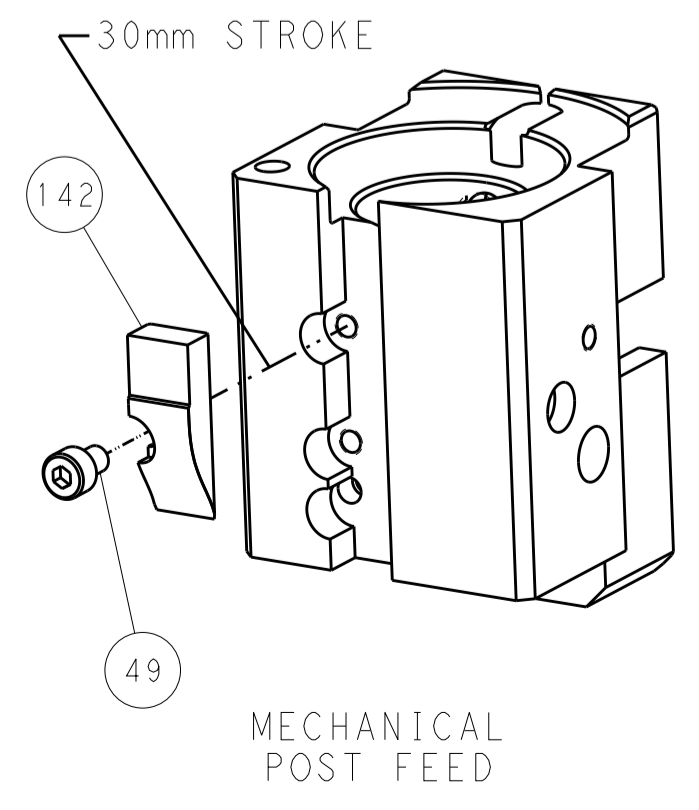
PNEUMATIC



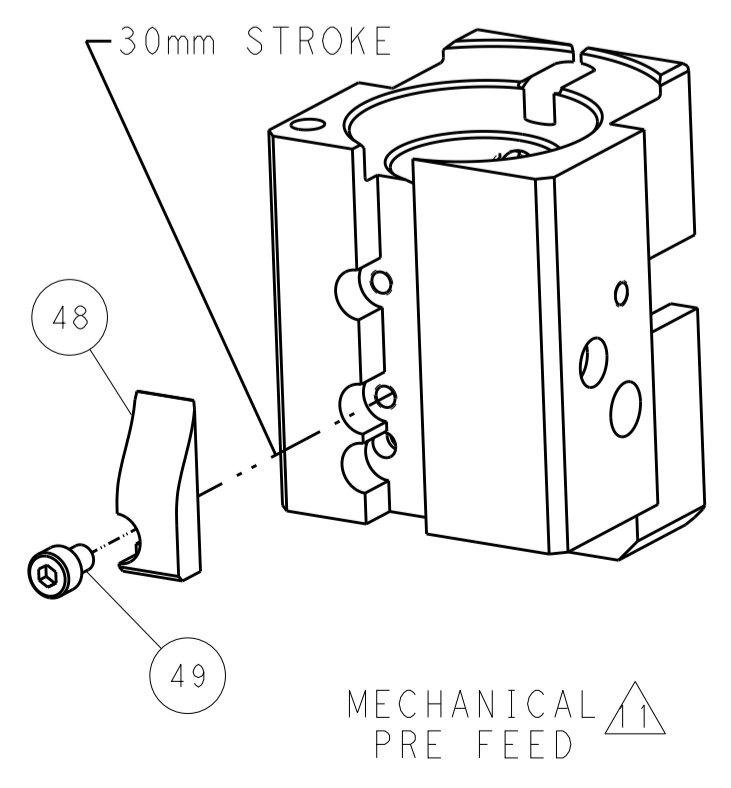
SERVO
LATCH PLATE



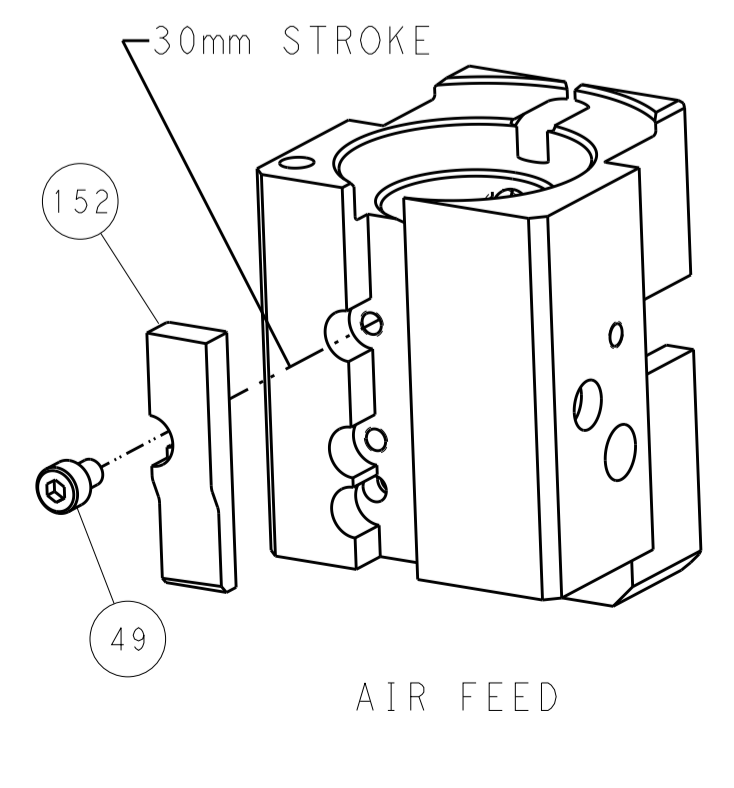
CAM POSITIONS



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:		DWG: BOB_HIGMAN 03OCT2013		TE Connectivity	
mm	0 PLC	±		CHK: T_ELFIN 03OCT2013	NAME		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: M_CLEFFORD 03OCT2013	Ocean End Feed		
	2 PLC	±		PRODUCT SPEC	Applicator		
	3 PLC	±		APPLICATION SPEC	SIZE		CAGE CODE DRAWING NO
	4 PLC	±		ANGLES	A11 00779		RESTRICTED TO
MATERIAL	FINISH	WEIGHT		Customer Accessible Production Drawing	SCALE	SHEET	REV
					1:1	4 OF 4	B