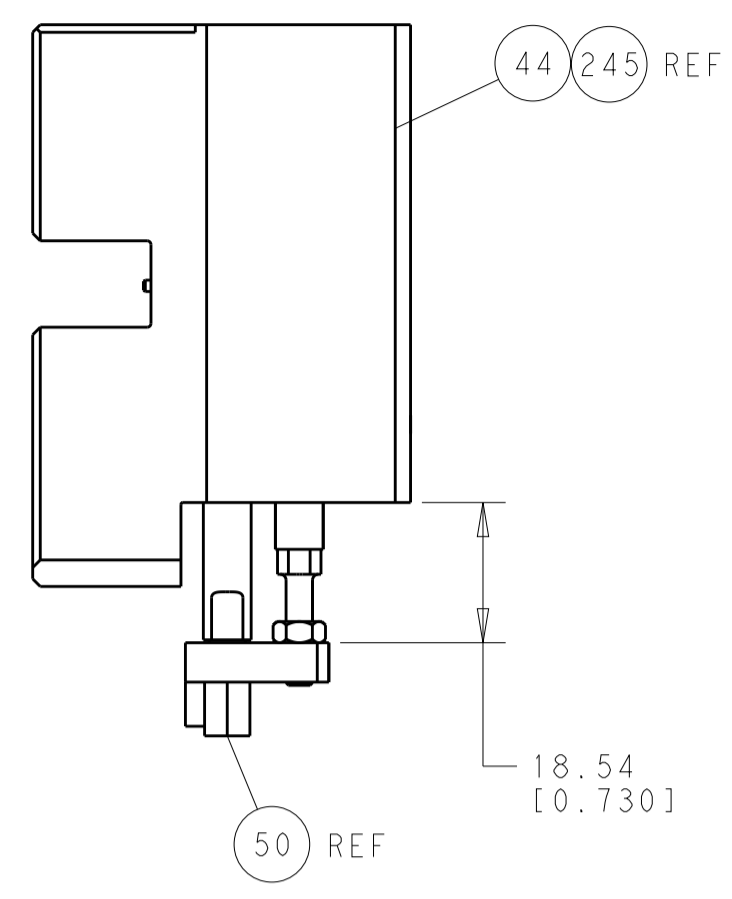


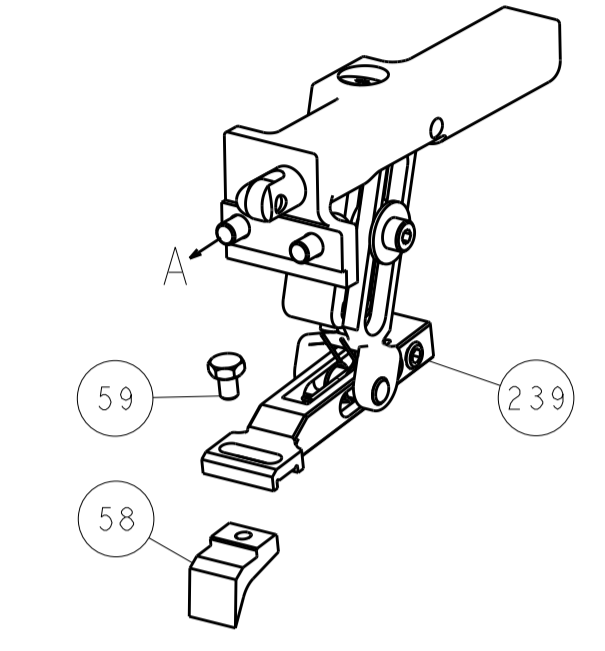


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

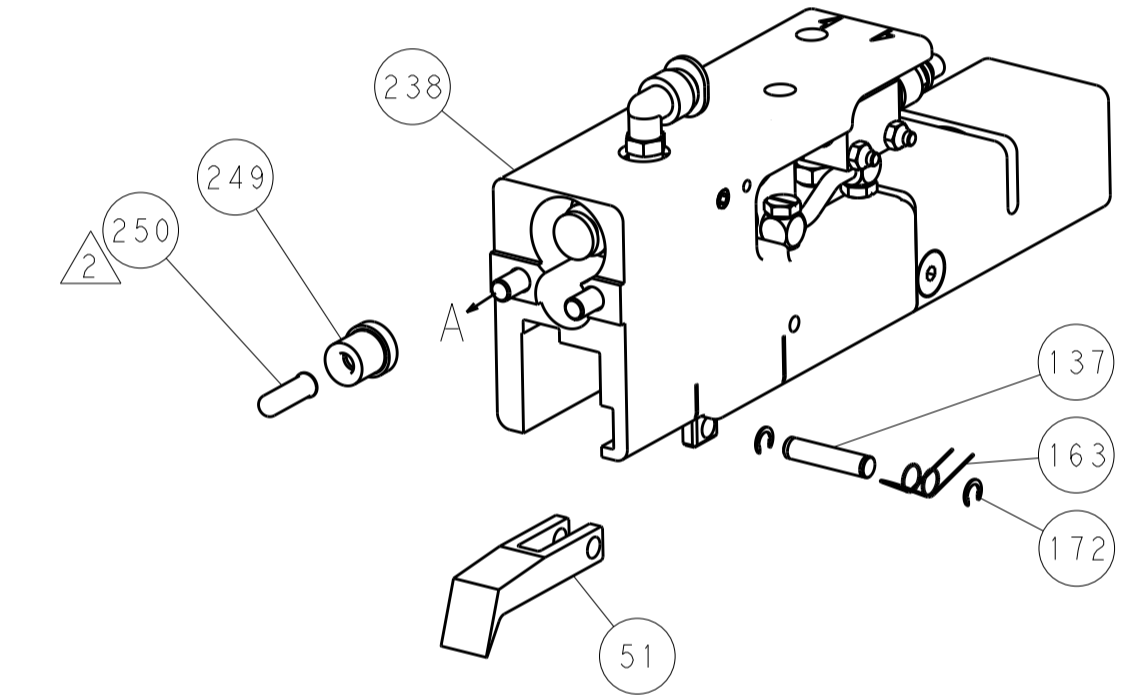


HOLDDOWN SET-UP

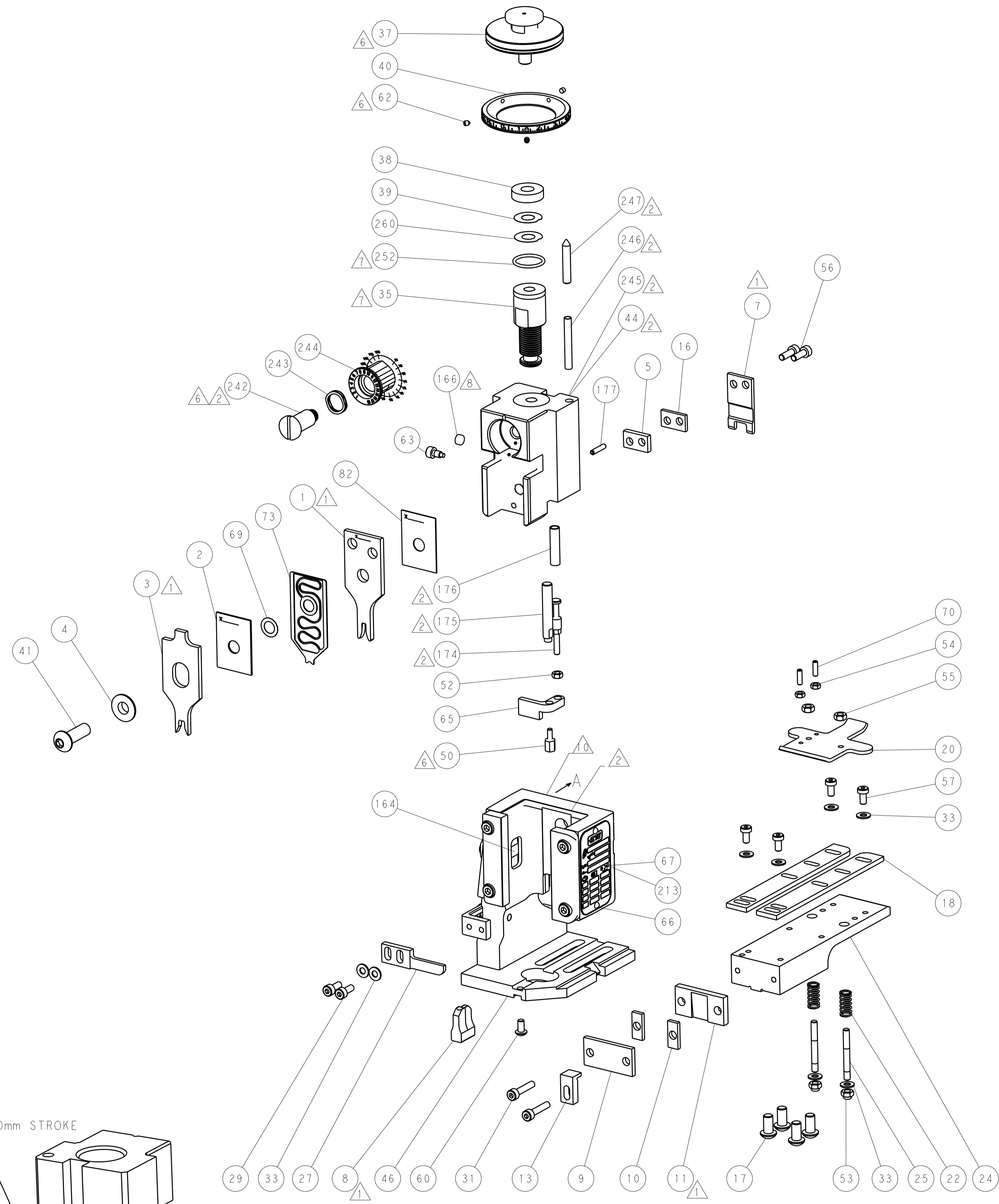
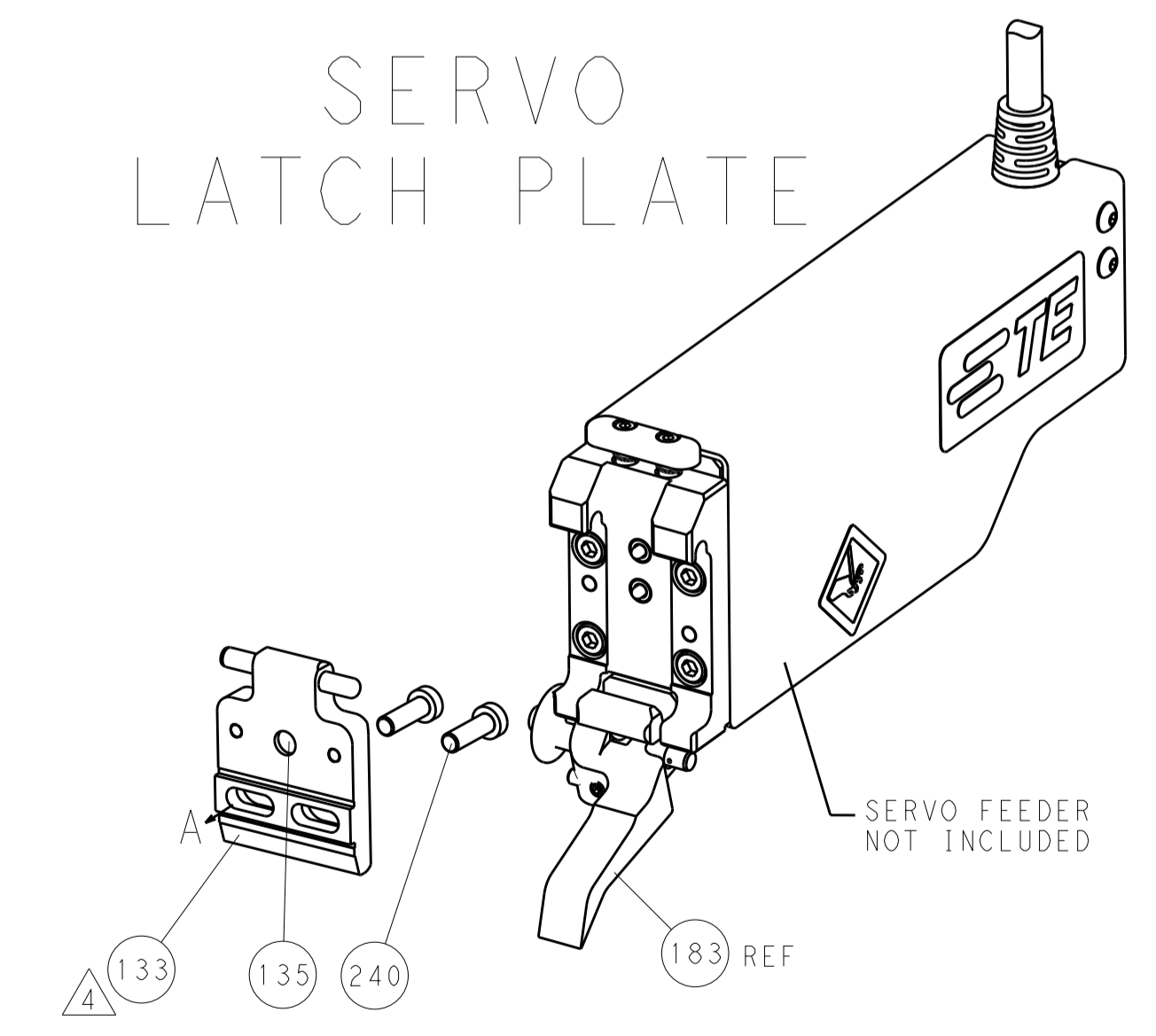
FEED TYPE  
MECHANICAL



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		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	09FEB2012	Harrisburg, PA 17105-3608	
	4 PLC ±0.001	ANGLES ±0.001			09FEB2012		
MATERIAL:	FINISH:	WEIGHT:	APVD:	NAME:	Customer Accessible Production Drawing		
			S. XI	Ocean End Feed Applicator	SCALE	SHEET	REV
					1:1	2 of 4	A

Table with columns: SET UP GAUGE (2119599-2), DIST (A), DIST (66), REVISIONS, and columns for REV, LTR, DESCRIPTION, DATE, QTN, APVD.

Table: APPLICATOR STYLE CONVERSION CHART. Includes columns for PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, and PART NUMBERS REQUIRED.

Large BOM table listing various components such as SHCS, FEED ASSEMBLY, TAG, SPRING, GUIDE PIN, RING, MAGNET, FEED FINGER, O-RING, DETENT PIN, SCR, FEED CAM, RAM, BOLT, PIN, MEMORY CHIP, SERVO FEED LATCH ASM, SPACER, DEPRESSOR, DOCUMENTATION PACKAGE, WASHER, SCR, SCREW, HOLDER, LIMITER, SCR, FEED FINGER, SHCS, SCR, NUT, PAWL, STANDOFF, FEED CAM, SCR, DISC, APPLICATOR SHIM PACK, RAM WASHER, WASHER, SCR, STRIPPER, STUD, PLATE, SPRING, DRAG, GUIDE, SPACER, PLATE, SPACER, ANVIL, BLADE, SLUG, SPACER, BLOCK, CRIMPER, SPACER, CRIMPER, CRIMPER.

Table: APPLICATOR DATA. Includes CRIMP SIZE, WIRE, INSUL, and APPLICATOR INSTRUCTIONS.

Table: TERMINAL DATA: TE TERMINAL. Includes terminal specifications, wire strip length, insulation diameter range, and terminal applications.

Table: WIRE SIZE vs CRIMP HEIGHT. Shows the relationship between wire size (mm) and crimp height (mm).

\*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.

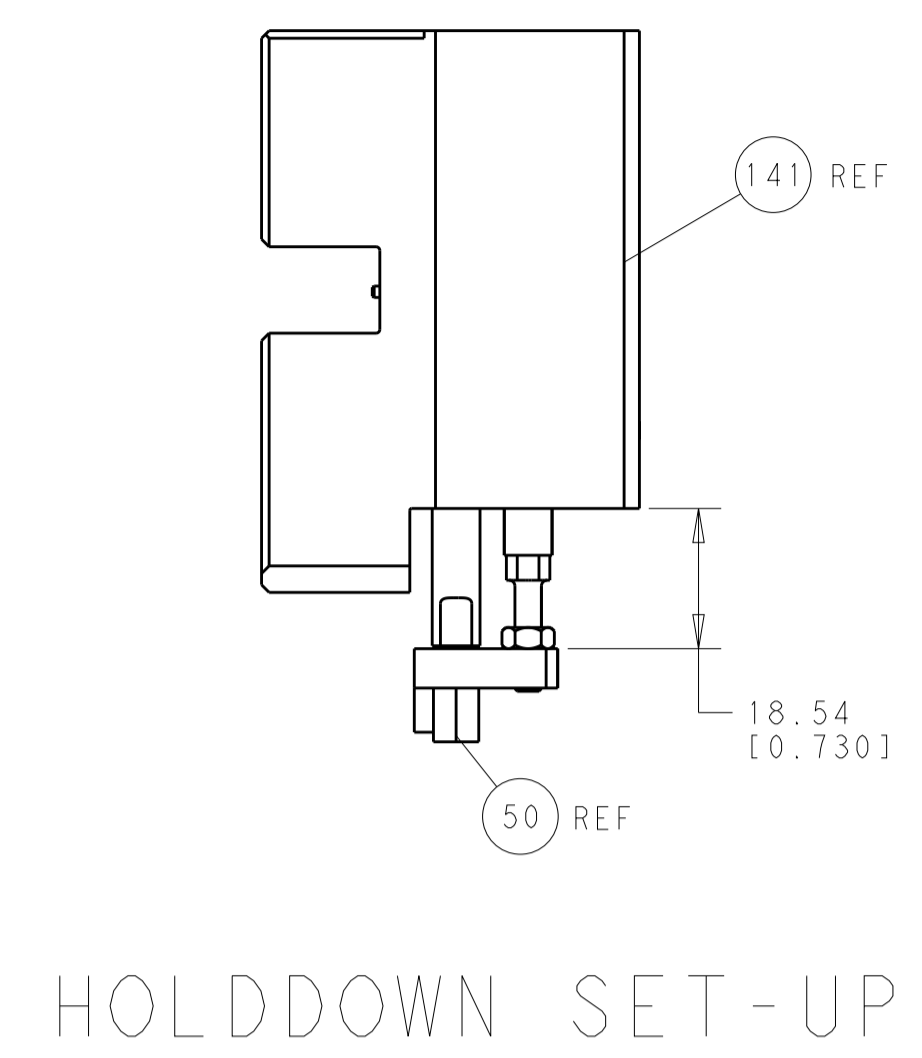
- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150060-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150060-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150060-5
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.

Table with columns: ITEM NO, DESCRIPTION, ITEM NO. Lists items 251 to 242 and their descriptions.

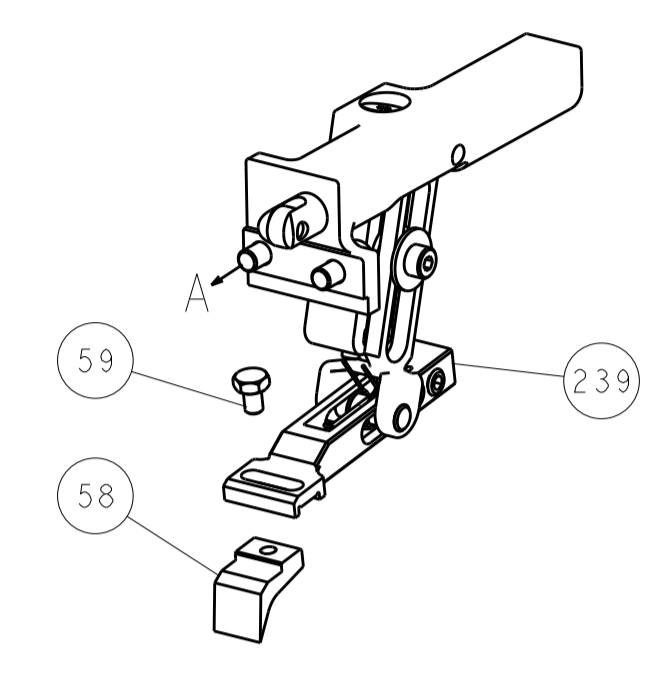
PACIFIC VERSION Shown on sheets 3 of 4 & 4 of 4 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

Technical drawing header block including dimensions, tolerances, material, finish, weight, scale, and sheet information.

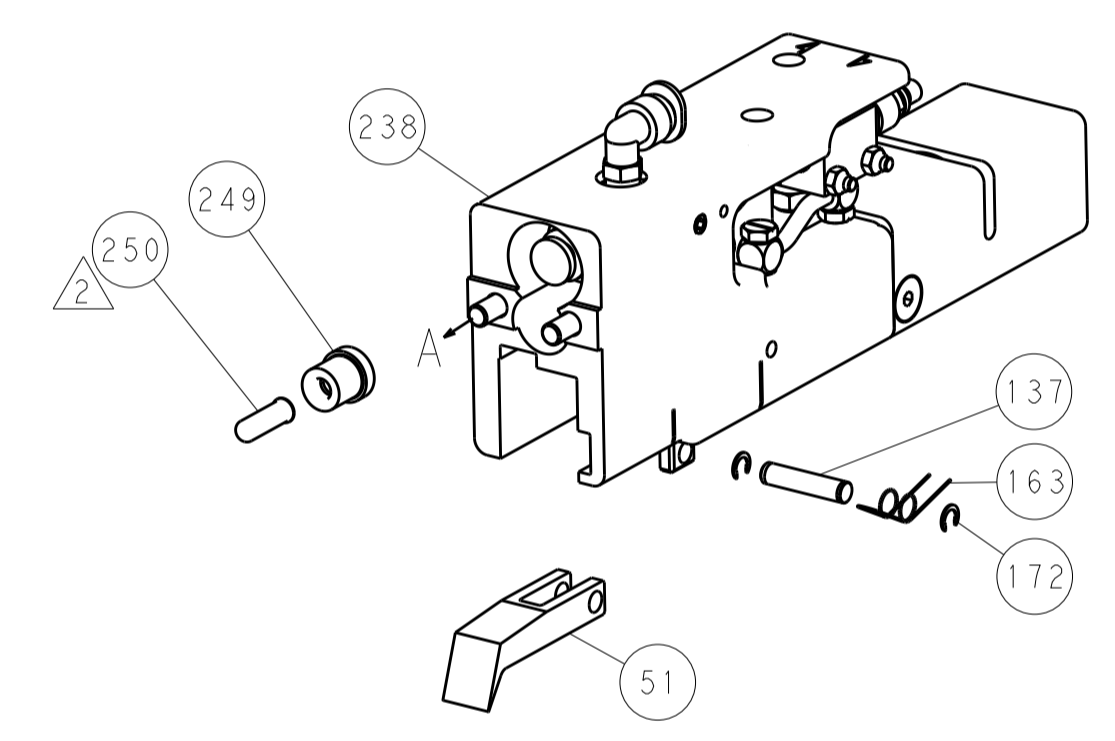
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1			



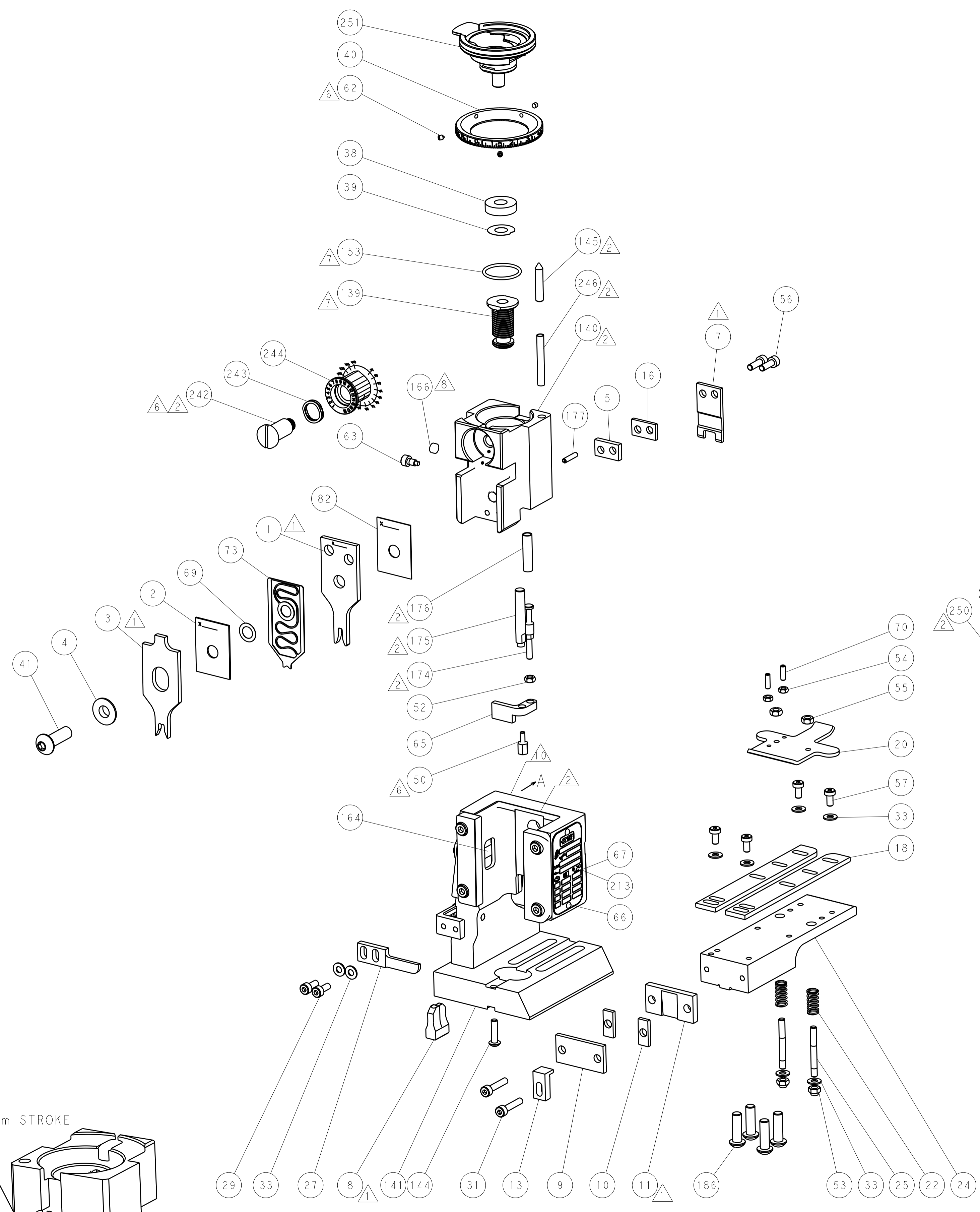
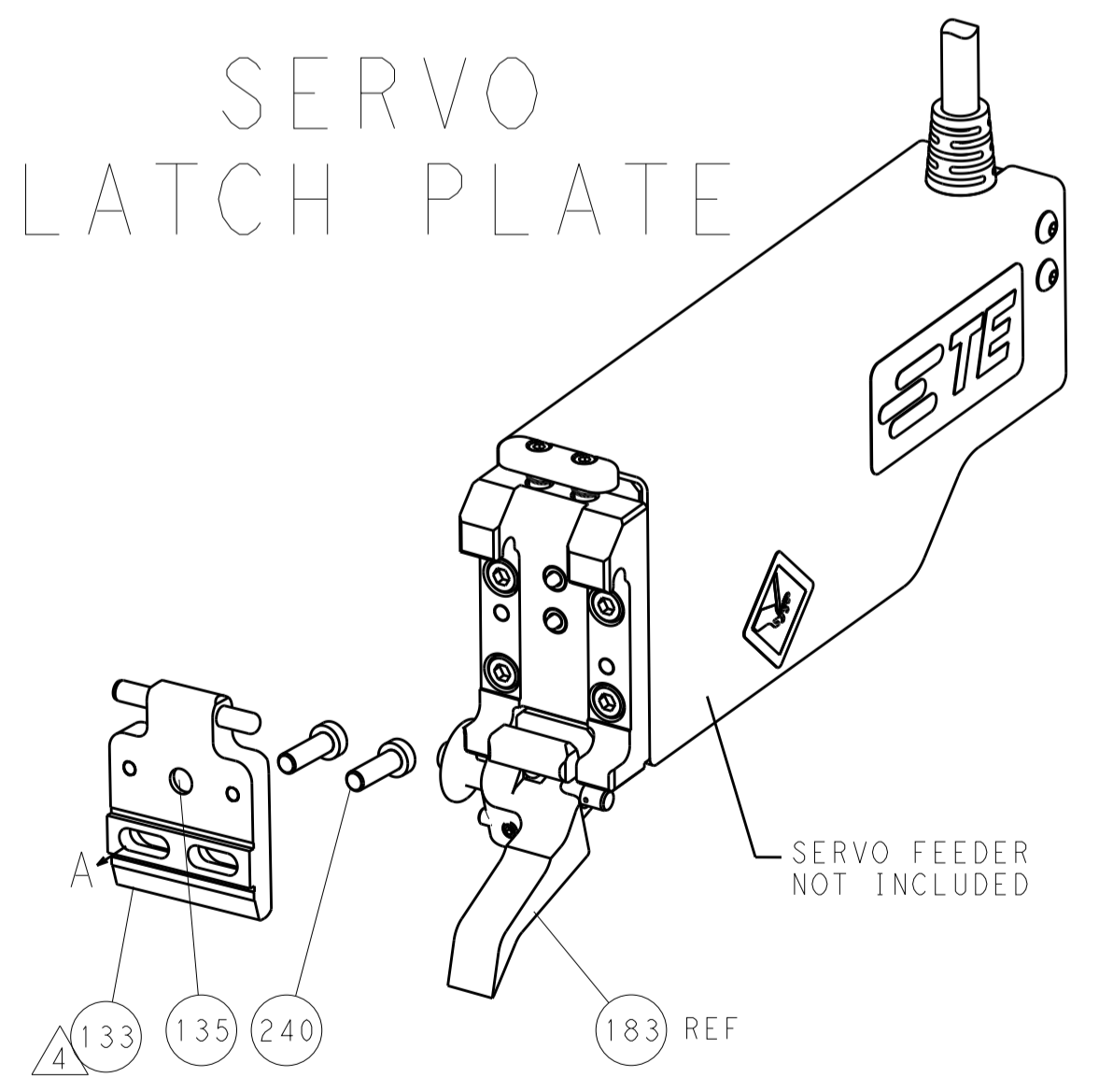
FEED TYPE  
MECHANICAL



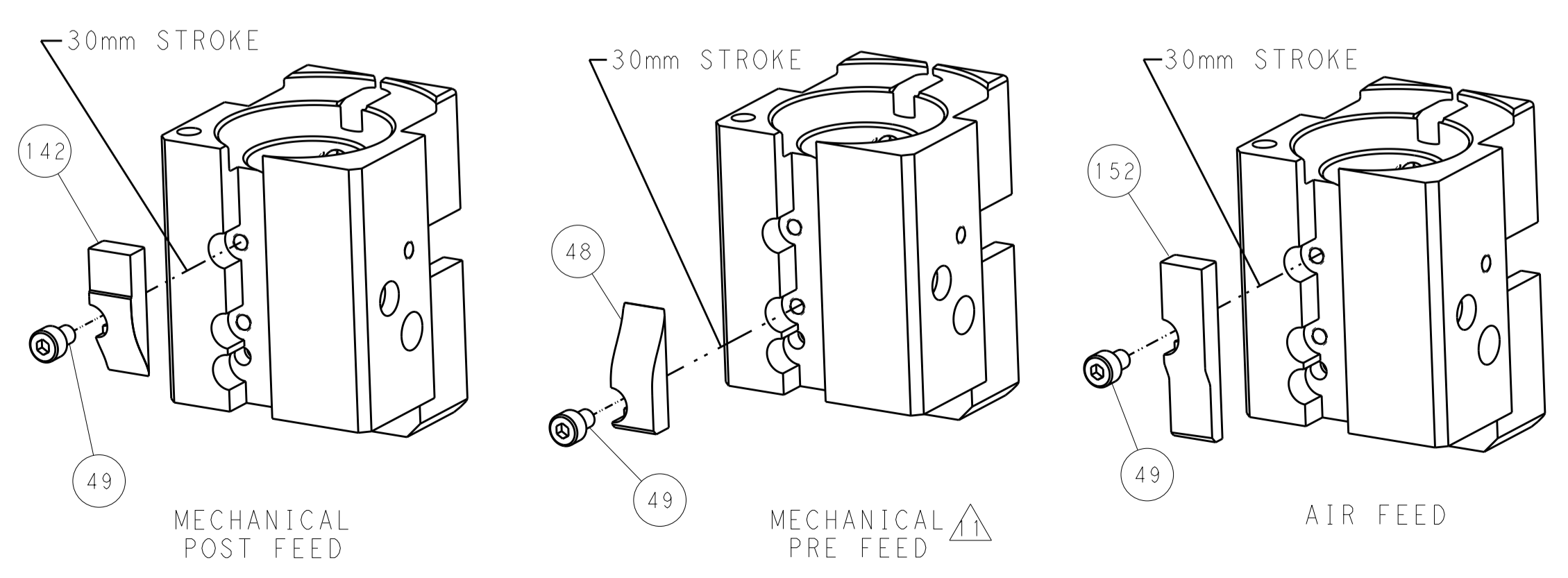
PNEUMATIC



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 Y. YIN 09FEB2012		STE TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	CHK G. BAILEY 09FEB2012	Harrisburg, PA 17105-3608	
	4 PLC ±0.013	5 PLC ±0.013	6 PLC ±0.001	7 PLC ±0.001	APVD S. XI 09FEB2012	NAME	
	ANGLES			PRODUCT SPEC		Ocean End Feed Applier	
MATERIAL	FINISH			APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A1 00779 C=2150060	
				Customer Accessible Production Drawing		RESTRICTED TO	
				SCALE 1:1		SHEET 4 OF 4 REV A	