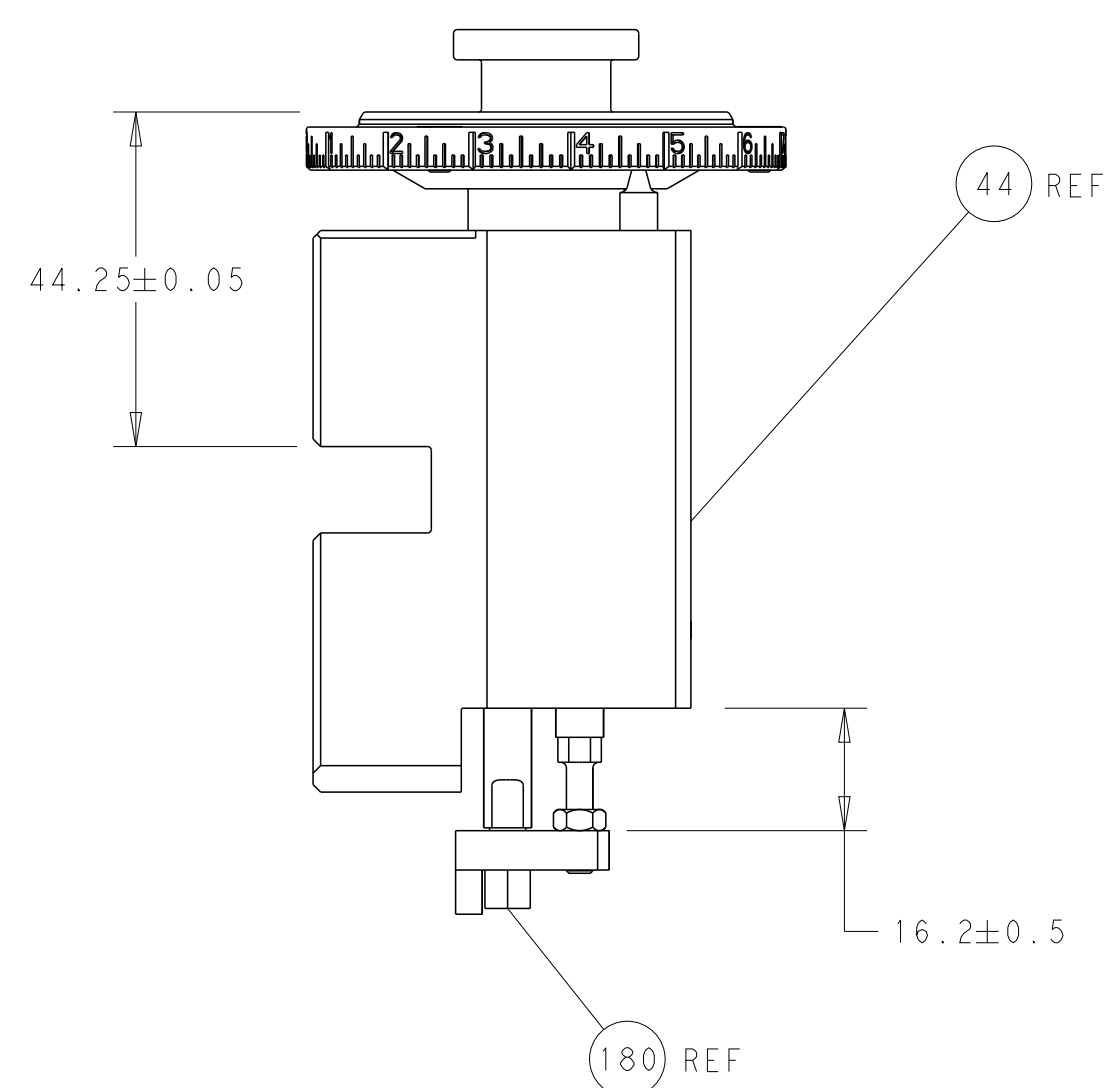
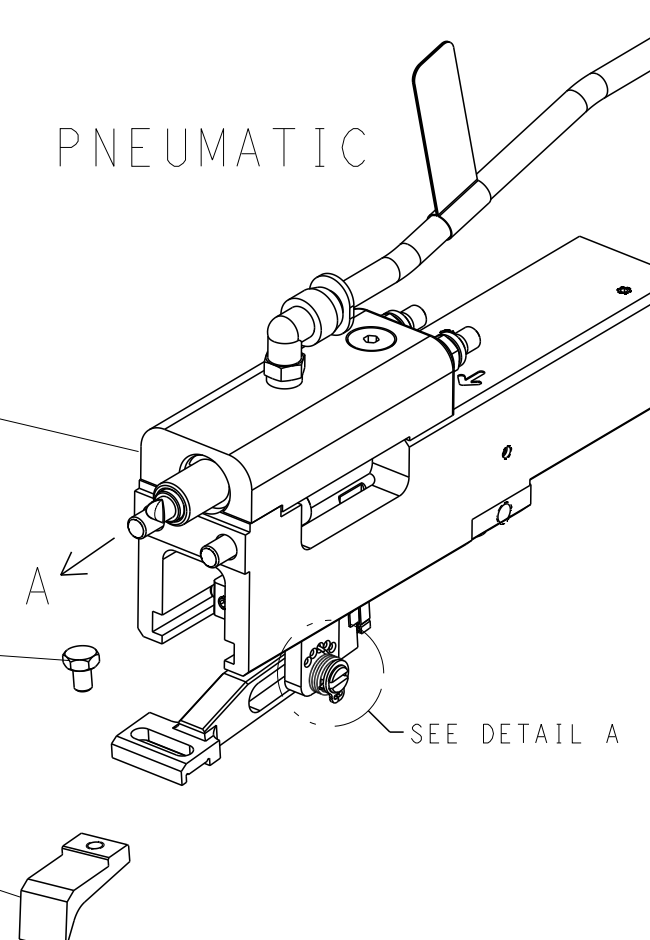
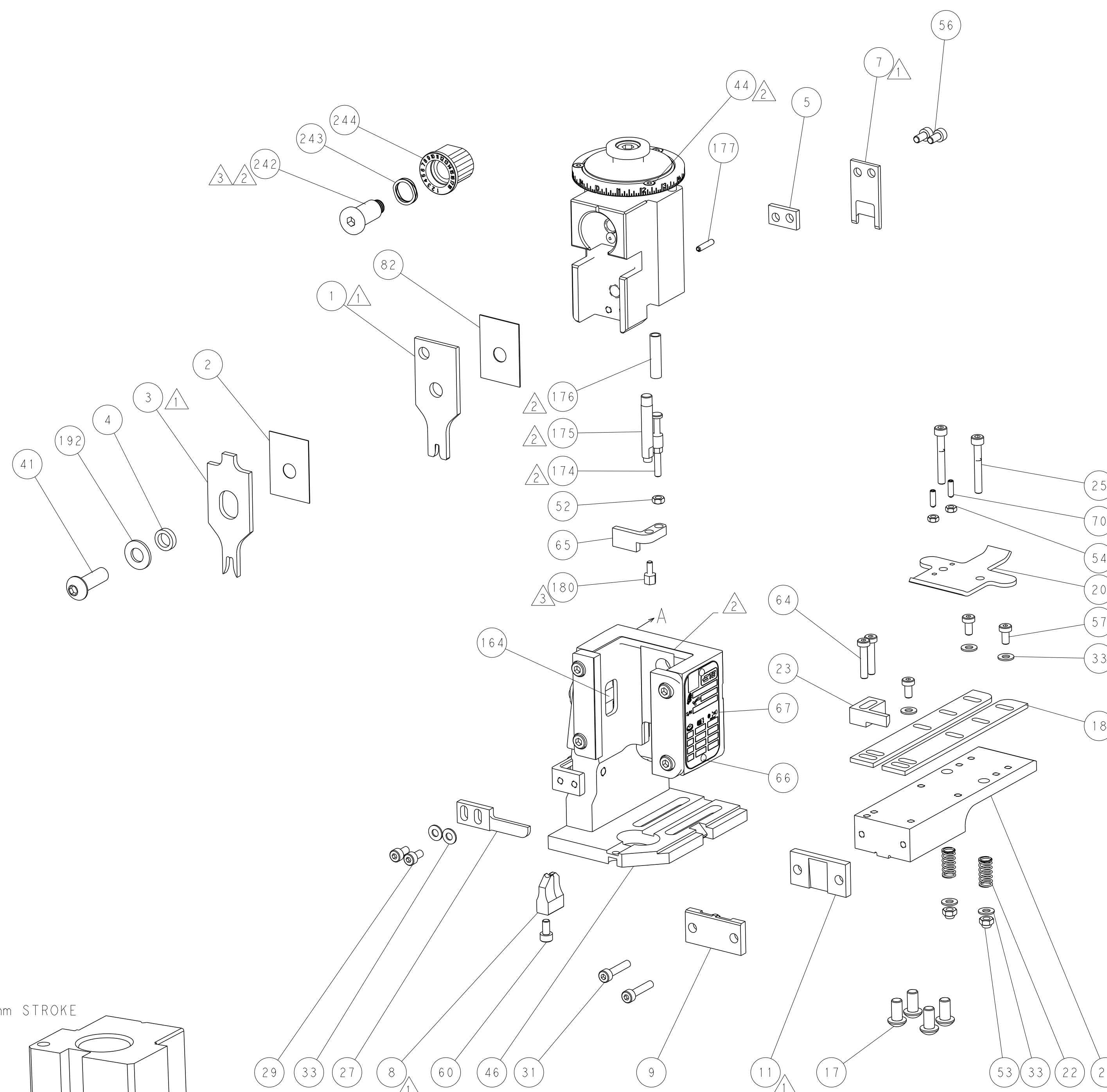
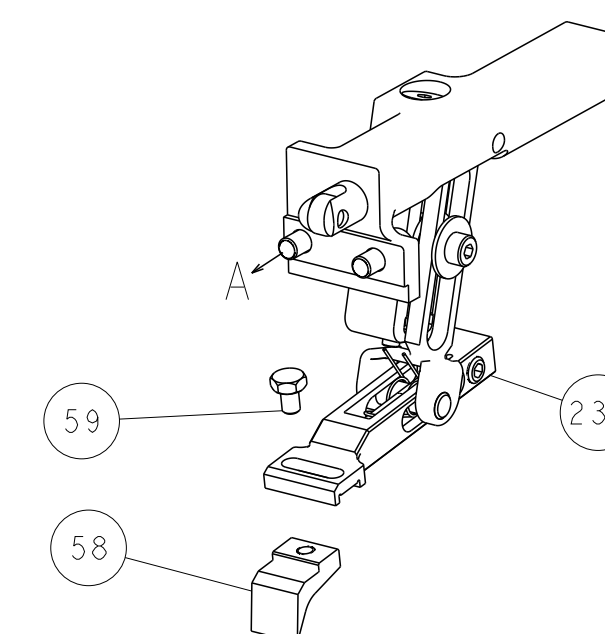


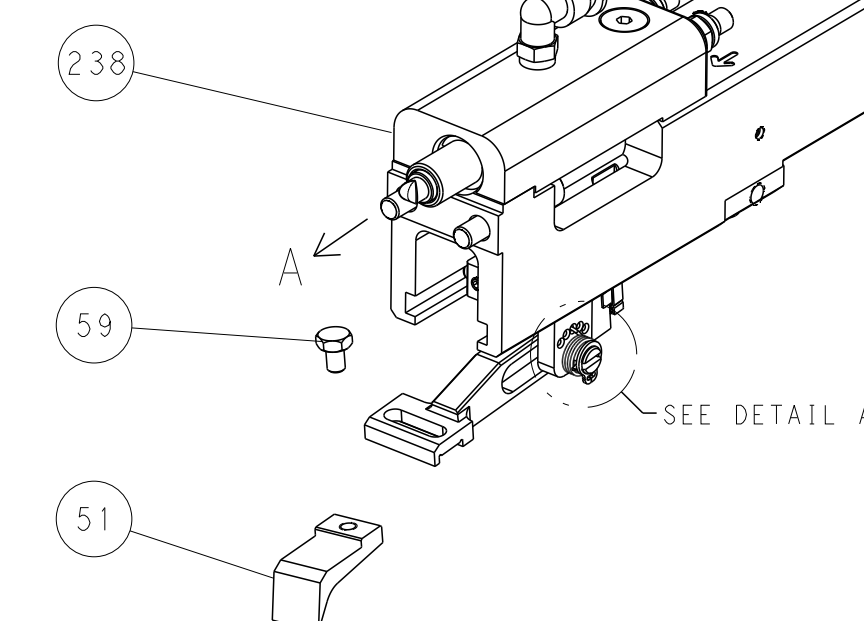


RAM AND HOLDDOWN SET-UP

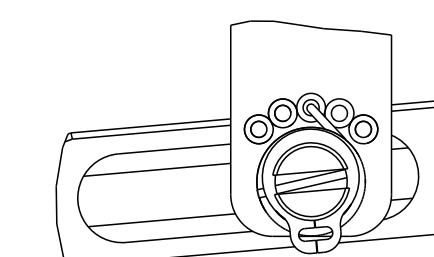
FEED TYPE
MECHANICAL



PNEUMATIC

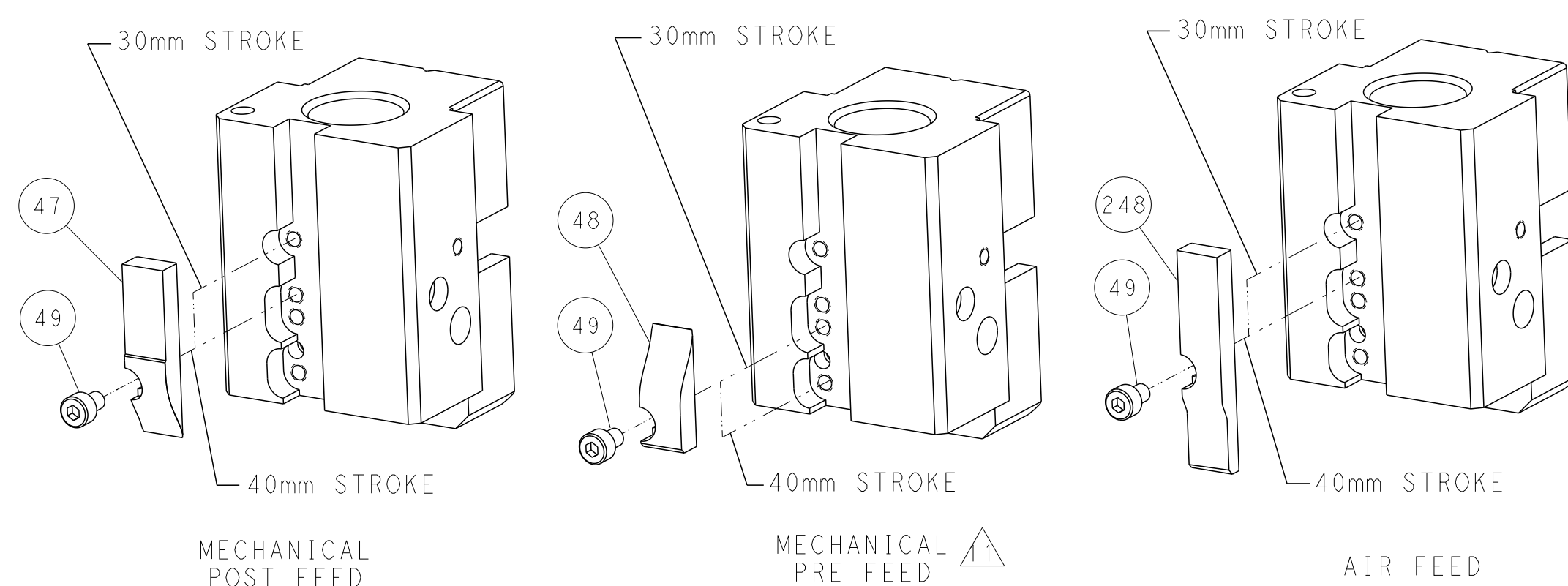


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS



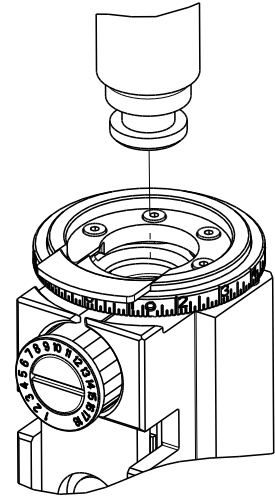
ATLANTIC VERSION

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR FICO-ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ORGANIZATION HAS THE RIGHT TO REVISIONS ONLY BE CONTROLLED FOR THIS REASON.						DWN		19FEB2014			
						CHK		Y.YIN		TE Connectivity	
						G.BAILEY		19FEB2014		Harrisburg, PA 17105-3608	
DIMENSIONS:						U GUO		19FEB2014		NAME	
mm						PRODUCT SPEC				Ocean End Feed Applicator	
						APPLICATION SPEC				-	
TOLERANCES UNLESS OTHERWISE SPECIFIED:						SIZE		CAGE CODE		DRAWING NO	
0 PLC ±.015						WEIGHT		A 00779		C=2150420	
1 PLC ±.010										RESTRICTED	
2 PLC ±.008										-	
3 PLC ±.005											
4 PLC ±.003											
ANGLES FINISH ±.010											
MATERIAL											
-											
Customer Accessible Production Drawing											
						SCALE		1:1		SHEET 2 OF 4 REV	

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150420-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150420-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150420-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE FASTON .187 SERIES			
WIRE STRIP LENGTH 3.75-3.76 mm [.148-.148 IN]		INSULATION DIAMETER RANGE Ø2.79-4.06 mm [.110-.160 IN]	
TERMINAL APPLICATION SPECIFICATION		114-35000	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217149-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88+/-0.05 [.074+/- .002]	4.6
16 AWG	1.60+/-0.05 [.063+/- .002]	7.7
18 AWG	1.42+/-0.05 [.056+/- .002]	9.5



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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)

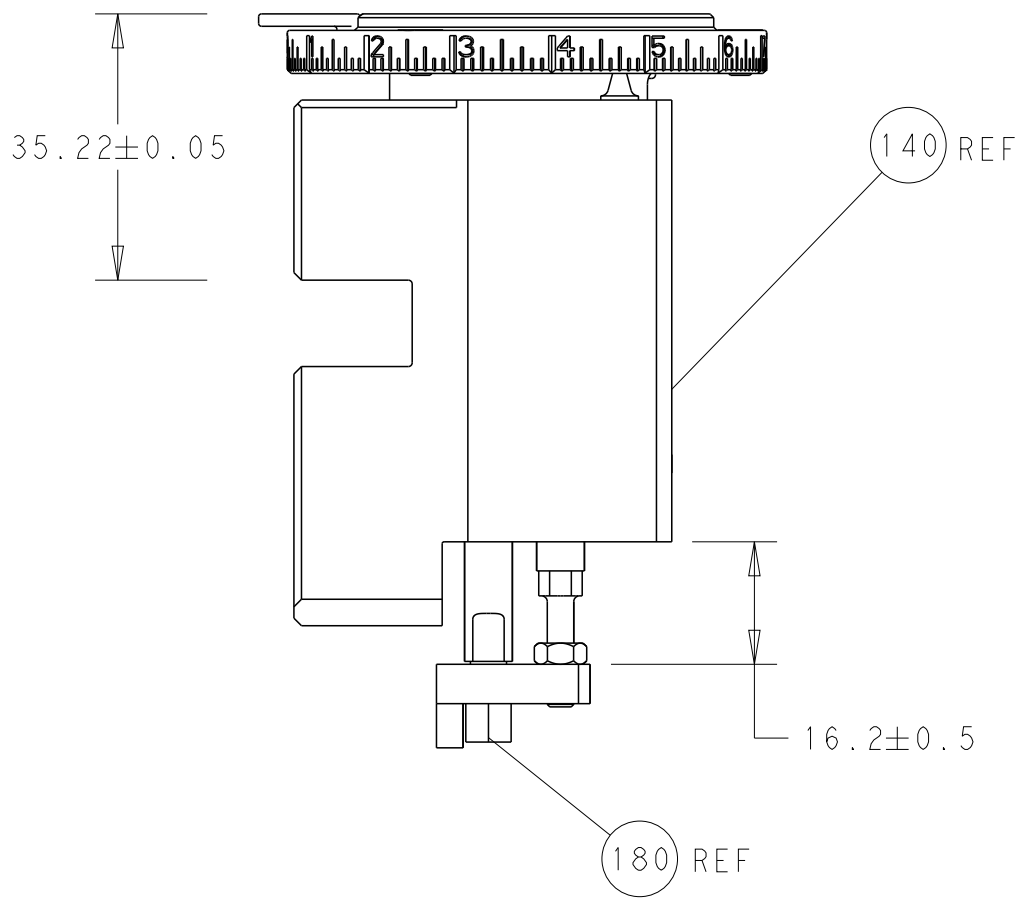
LOC		DIST		REVISIONS			
A		66		P	LTR	DESCRIPTION	DATE
					-	SEE SHEET 1	-

-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	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	1	1752354-5	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
-	REFREF	-	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	455888-5	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	-	2063961-9	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	1	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	4-690495-7	PLATE, FRONT SHEAR	9
-	1	1	4-1803000-4	ANVIL, COMBINATION, END FEED	8
-	1	1	2217206-4	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-5	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	4-456406-7	CRIMPER, WIRE PREMIUM	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

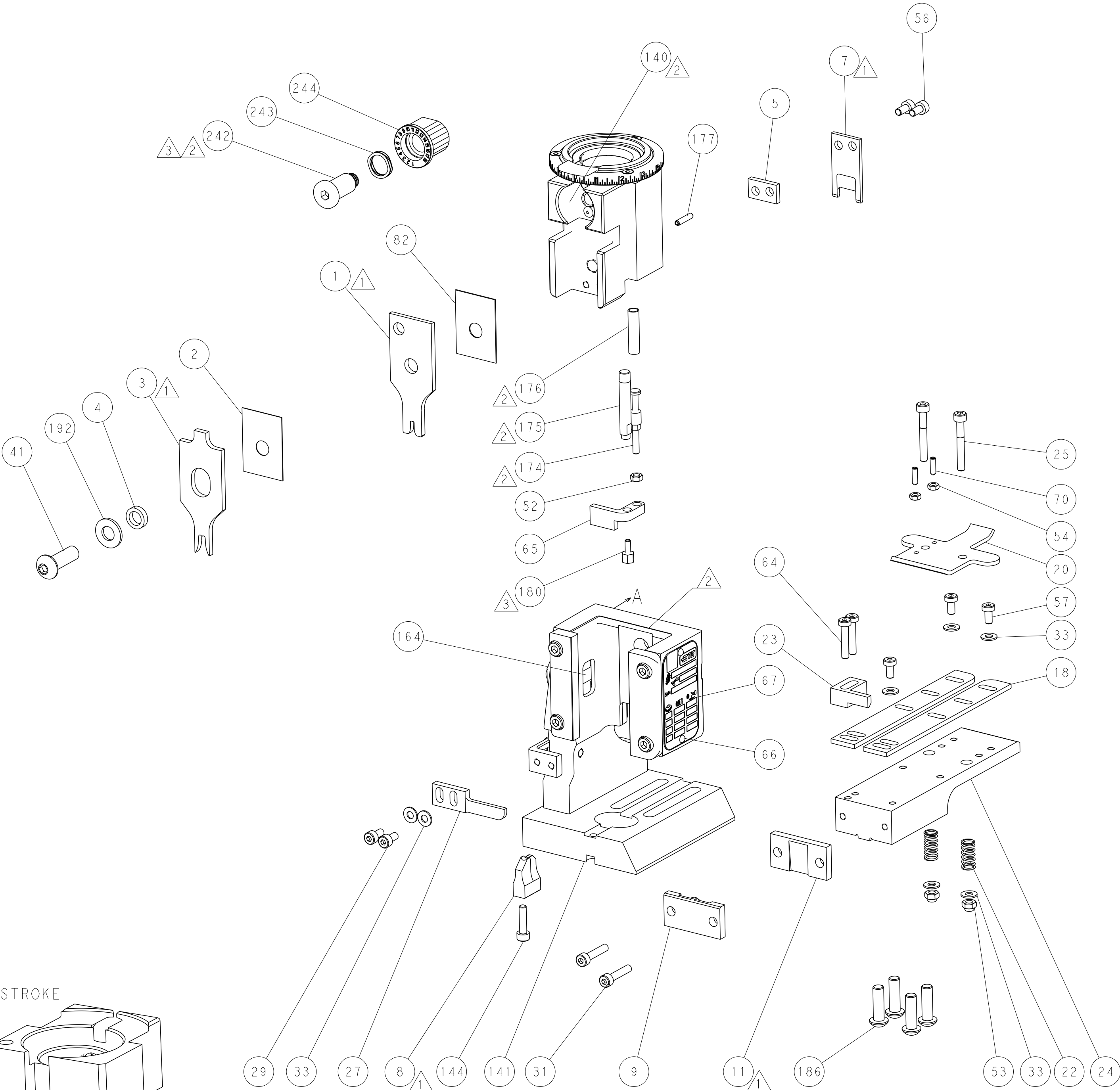
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.										DWN T. YIN 19FEB2014		CHK G. BAILEY 19FEB2014		APVD J. GUO 19FEB2014		NAME TE Connectivity Harrisburg, PA 17105-3608							
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:								PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO			
mm		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1								-		-		A		00779		C=2150420		-			
MATERIAL		FINISH								WEIGHT		-		Customer Accessible Production Drawing		SCALE		1:1		SHEET 3 OF 4		REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

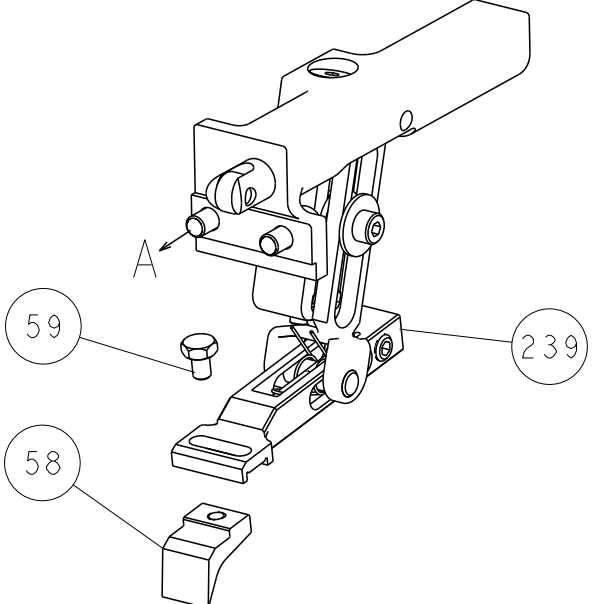
LOC		DIST		REVISIONS			
P	LYR	DESCRIPTION		DATE	DWN	APVD	
A	66	-	SEE SHEET 1	-	-	-	



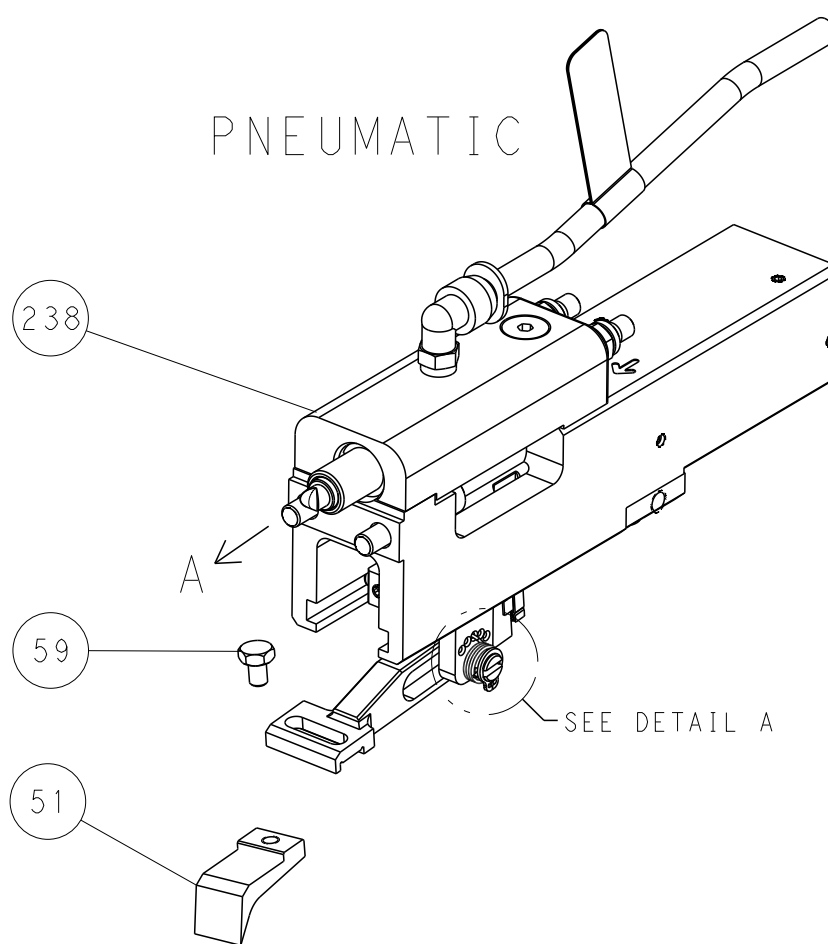
RAM AND HOLDDOWN SET-UP



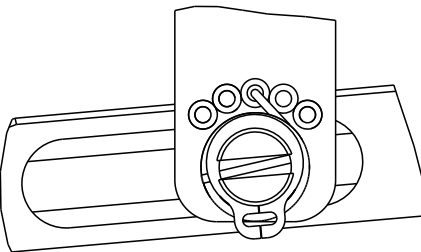
FEED TYPE
MECHANICAL



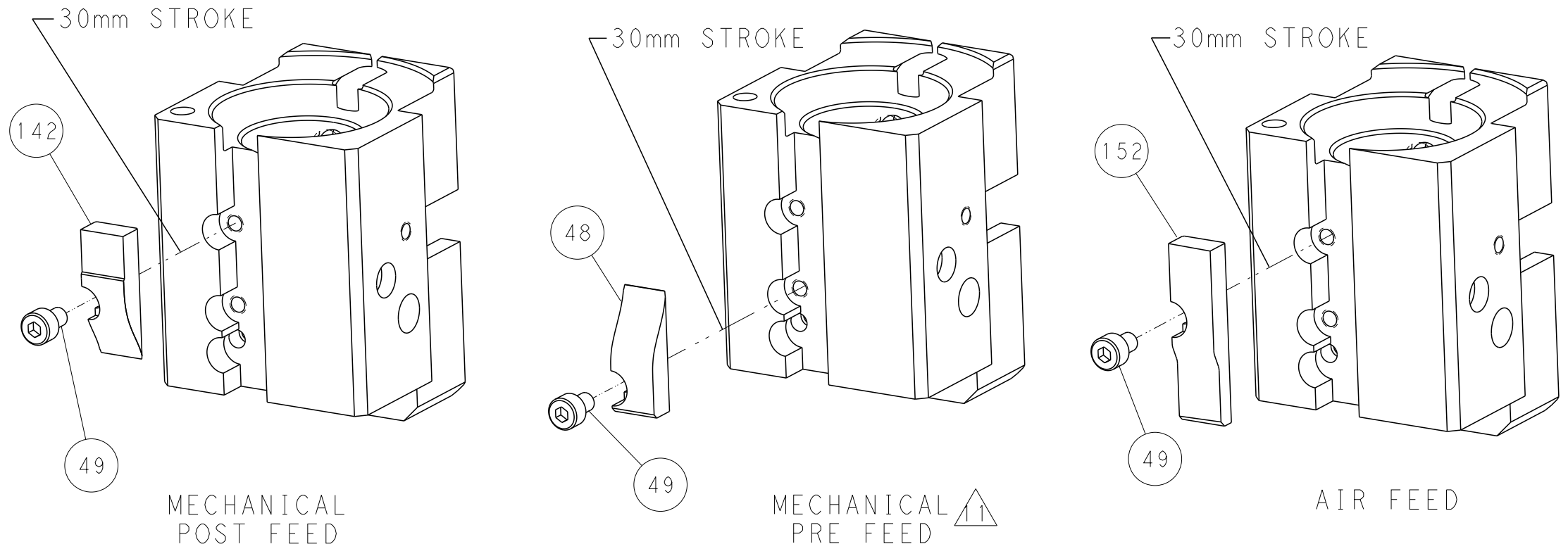
PNEUMATIC



FEED SPRING
SETTING POSITION



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		19FEB2014		Y. YIN	
mm		0 PLC ±.1		CHK		19FEB2014		G. BAILEY	
		1 PLC ±.1		APVD		19FEB2014		J. GUO	
		2 PLC ±.1		PRODUCT SPEC					
		3 PLC ±.1		APPLICATION SPEC					
		4 PLC ±.1		WEIGHT					
MATERIAL		FINISH		SCALE		1:1		SHEET 4 OF 4	
				Customer Accessible Production Drawing				REV B	



Ocean End Feed
Applicator

00779 ©=2150420