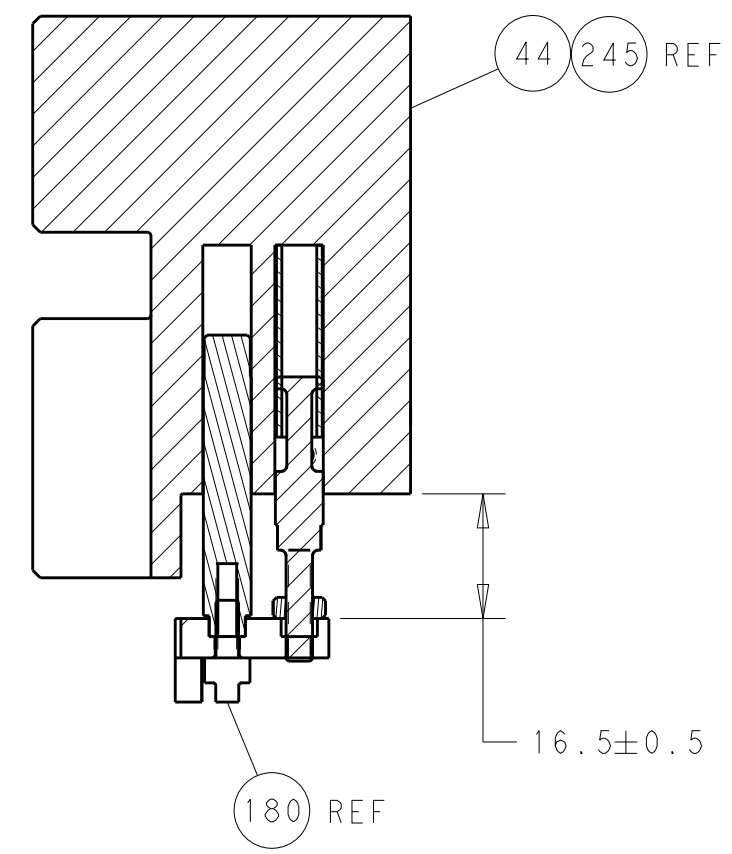
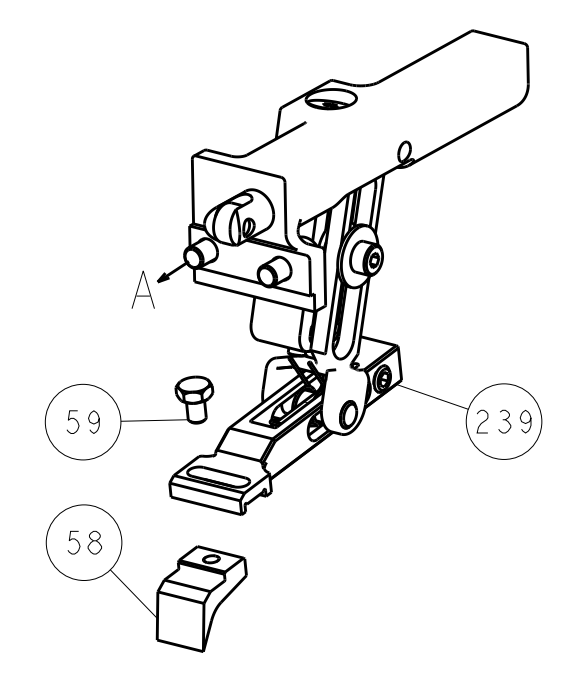


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

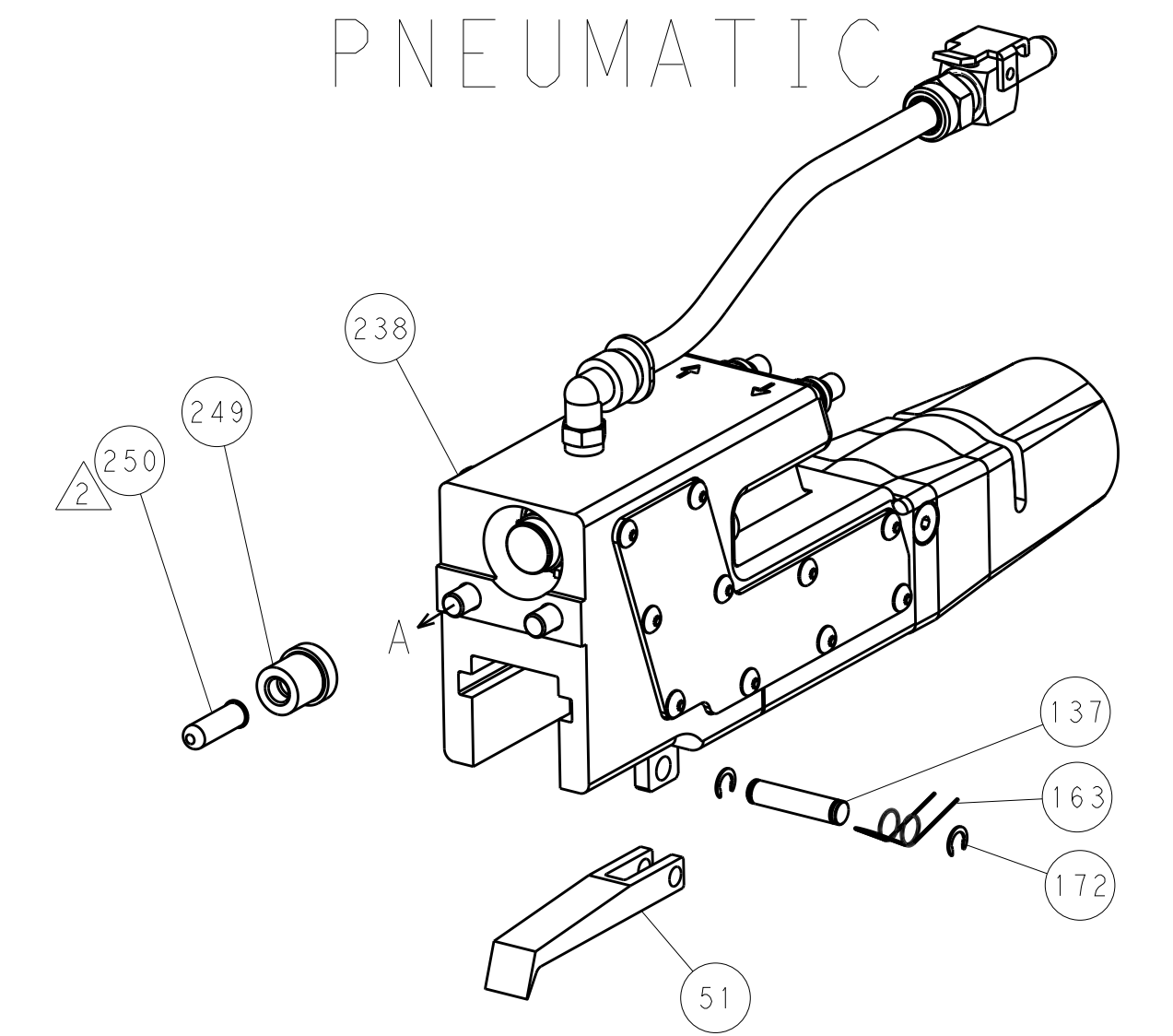


HOLDDOWN SET-UP

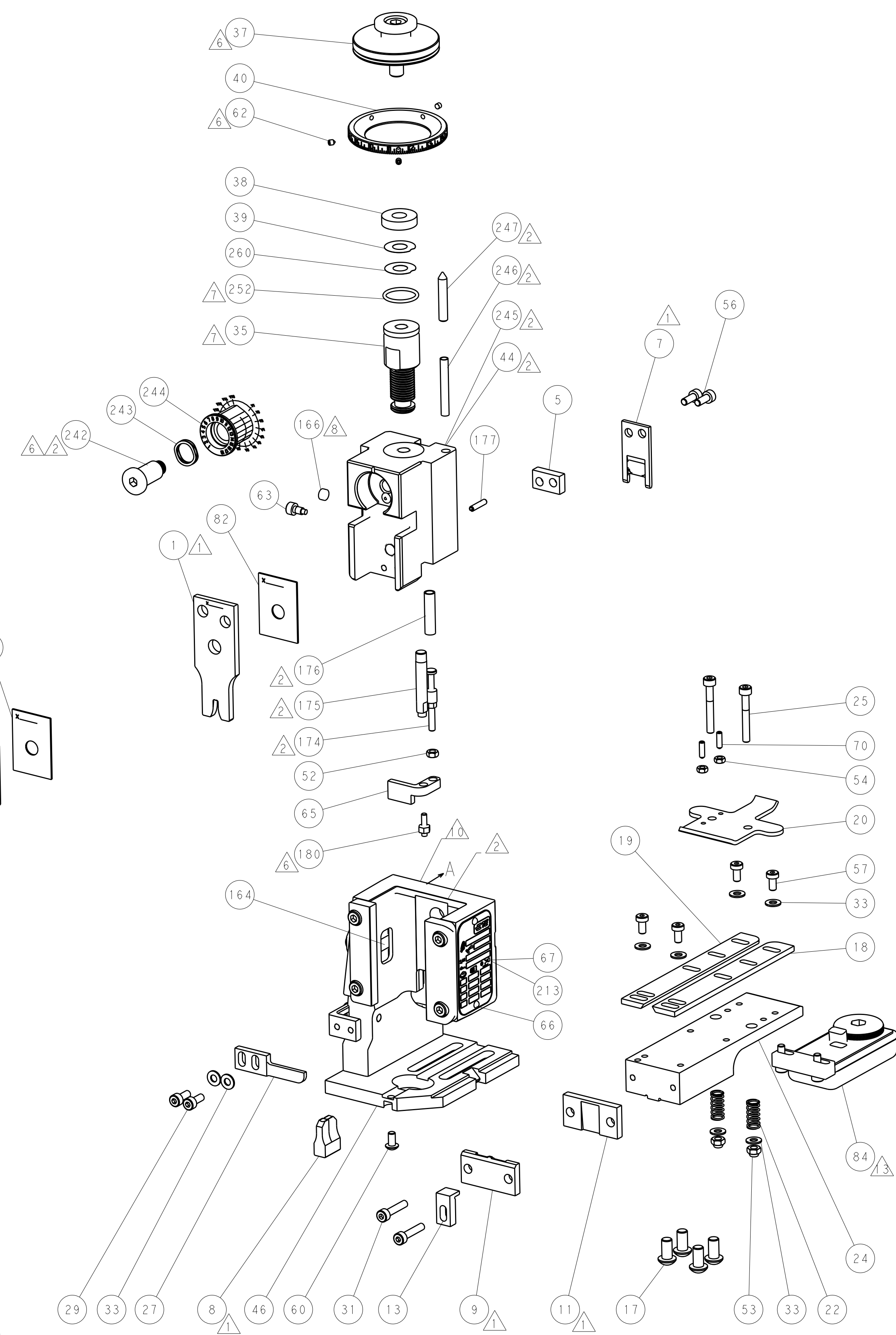
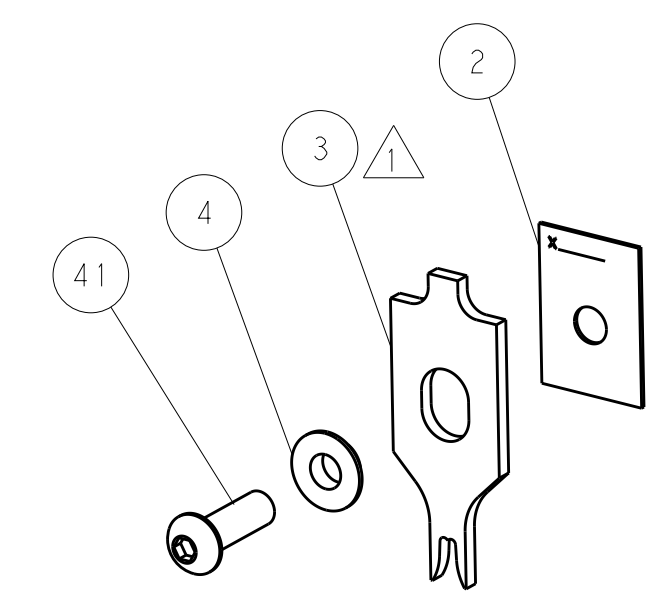
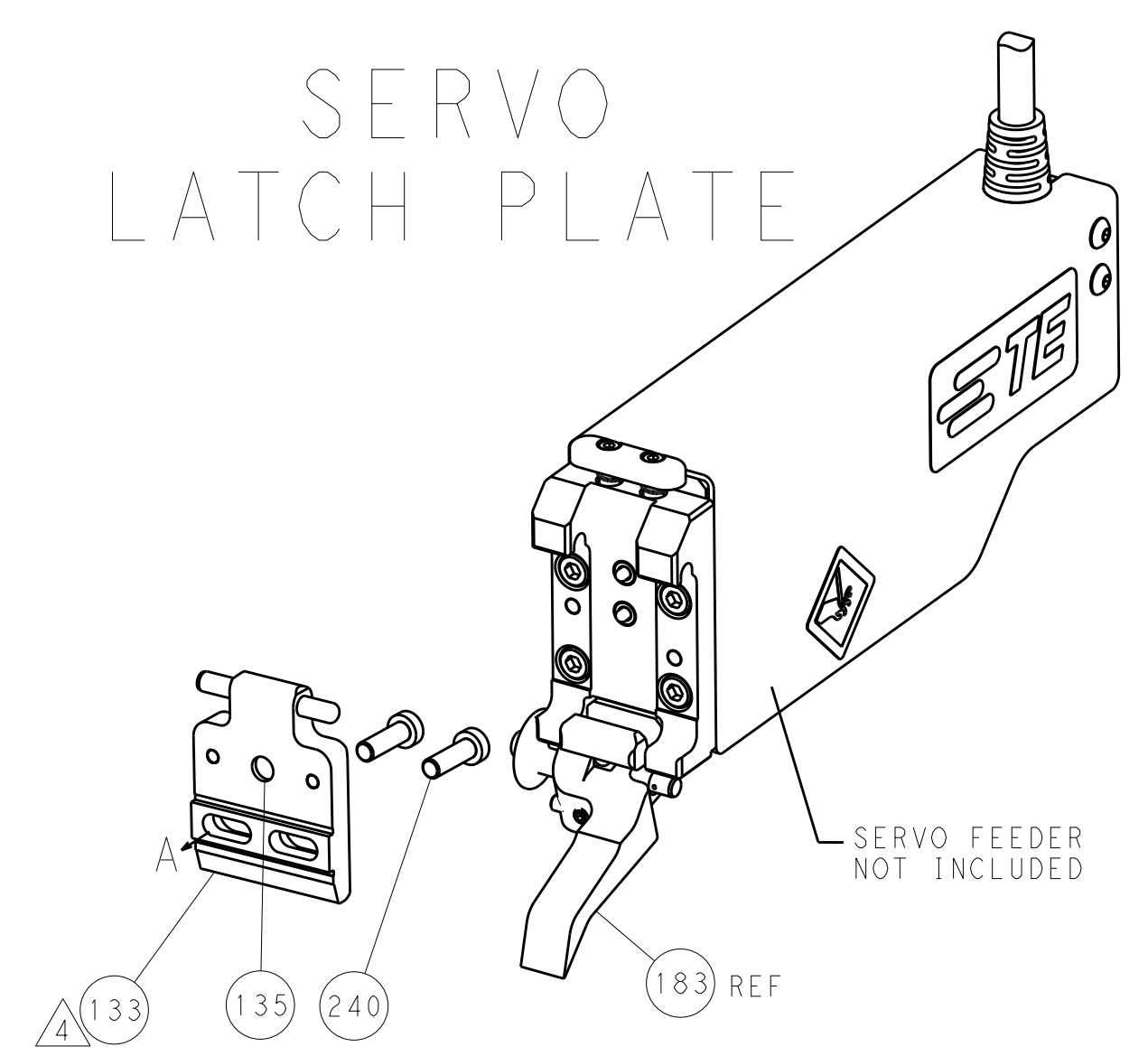
FEED TYPE
MECHANICAL



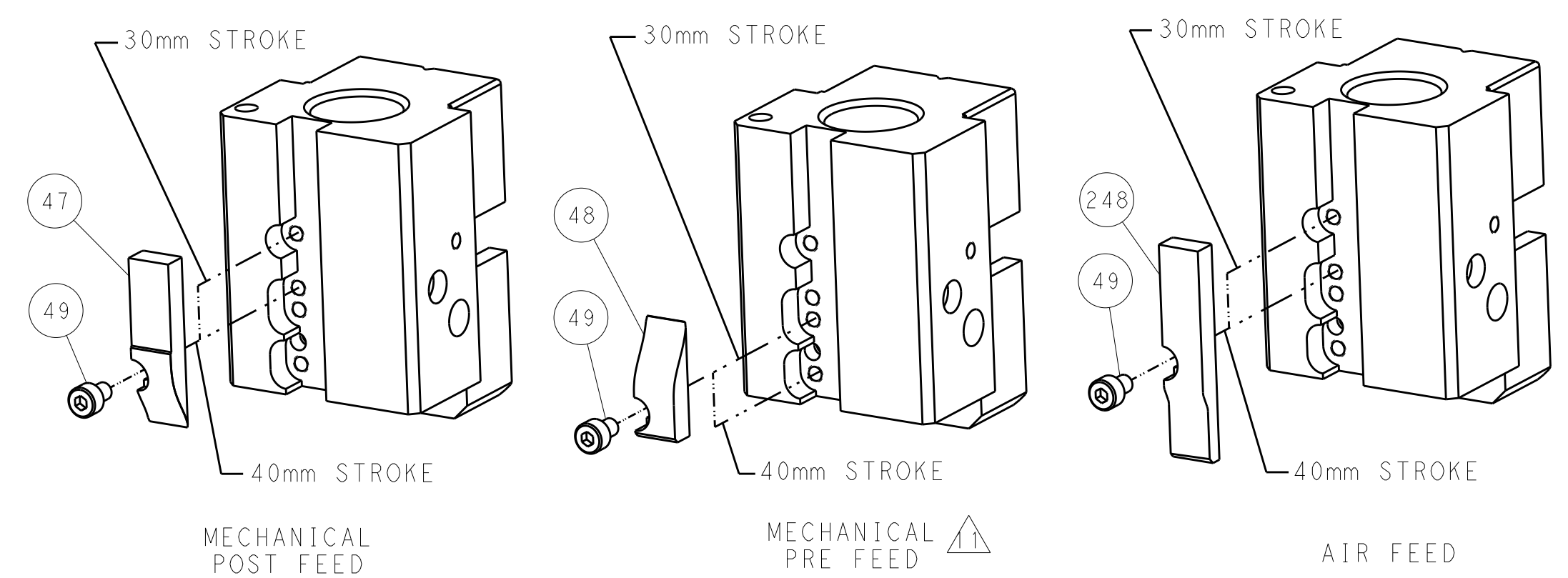
PNEUMATIC



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:		OWN: M_HERR 24MAR2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: T_ELBIN 24MAR2017		NAME: Ocean End Feed Applicator	
CUSTOMER DRAWING		SCALE: 1:1		APVD: T_ELBIN 24MAR2017		RESTRICTED TO: A	
				PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150790	
				APPLICATION SPEC:		SHEET 2 OF 4 REV A	
				WEIGHT:		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150790-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150790-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150790-4	-	-	
	2-2150790-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150790-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150790-4	-	-	
	2-2150790-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
	2-2150790-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150790-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.20 mm [.126]	F
INSUL	4.20 mm [.165]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: STOCKO TERMINAL STOCKO CRIMP SPECIFICATION			
TERMINAL NAME: RSB 8031 RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.05-5.81 mm [.199-.229 IN]		Ø2.80-3.70 mm [.110-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	RSB 8031 F 6.3-2.5 Rev 29/10/2010	-	-
TERMINALS APPLIED			
TE TERMINAL	STOCKO TERMINAL	TE TERMINAL	STOCKO TERMINAL
1572347-1	RSB 8031 F 6.3-2.5		

TERMINAL DATA: STOCKO TERMINAL STOCKO CRIMP SPECIFICATION			
TERMINAL NAME: RSB 8031 RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.05-5.81 mm [.199-.229 IN]		Ø2.80-3.70 mm [.110-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	RSB 8031 F 6.3-2.5 Rev 29/10/2010	-	-
TERMINALS APPLIED			
TE TERMINAL	STOCKO TERMINAL	TE TERMINAL	STOCKO TERMINAL
1572347-1	RSB 8031 F 6.3-2.5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.03+/-0.02 [.080+/- .001]	5.8
1.50mm2	1.79+/-0.02 [.070+/- .001]	8.0
16 AWG	1.76+/-0.02 [.069+/- .001]	8.8

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.69+/-0.05 [.067+/- .002]	10.3

***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: 8-2150790-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150790-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150790-5
- 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. 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN THE TERMINAL MANUFACTURER'S SPECIFICATIONS. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN THE MANUFACTURER'S APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION AND OBTAIN APPROVAL FROM TERMINAL MANUFACTURER FOR THIS CUSTOM REQUIREMENT.

-	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
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77-	27-	25-	22-	21	PART NO	DESCRIPTION	ITEM NO

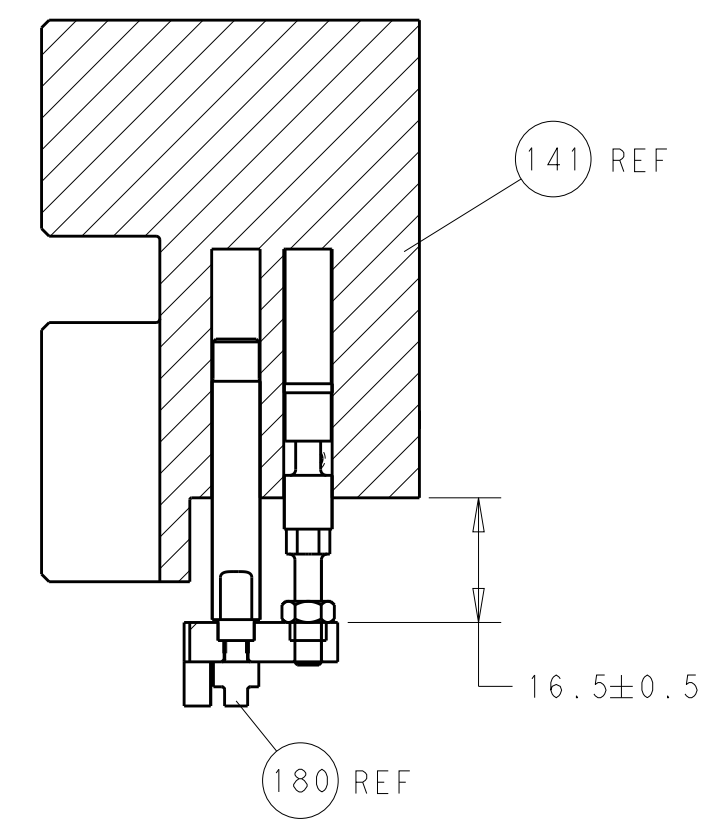
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

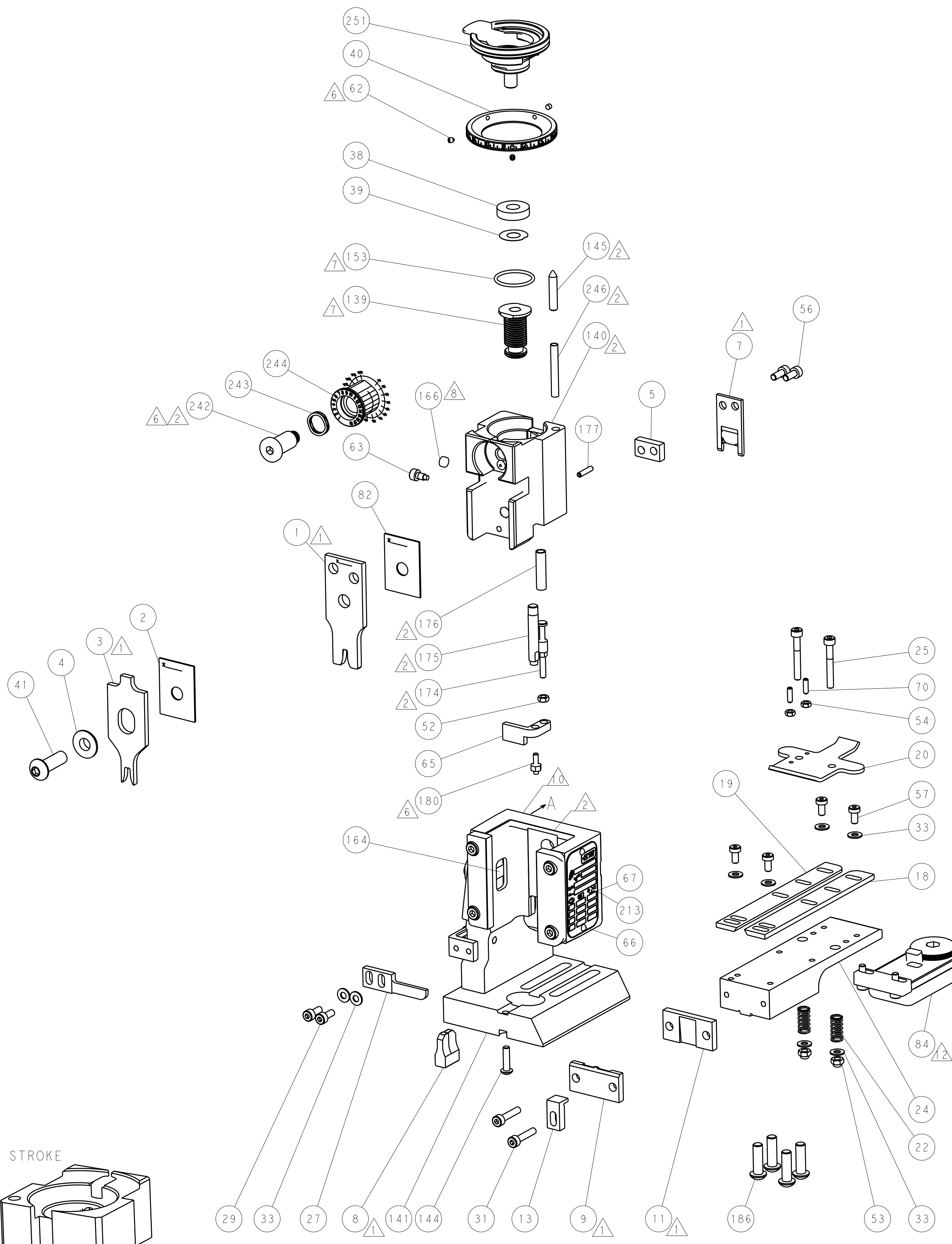
6	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
	-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
	-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	-	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
6	-	1	1	1	1	1976055-8	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
8	-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	-	-	-	1	240638-1	COUNTER, MAGNETIC	164
	-	-	-	-	1	219641-2	FEED CAM, AIR FEED	152
7	-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
	-	-	-	-	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
7	-	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
	-	-	-	-	-	1633743-1	SERVO FEED LATCH ASM	133
2	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	455888-7	SPACER, CRIMPER	82
	-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
	-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, 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	1901681-5	HOLDDOWN, TERMINAL	65
	-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	-	-	1	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	5018030-1	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	2119792-1	PAWL, EF, AIR	51
	-	-	-	-	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	2119644-2	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	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1	1803292-4	DRAG	20
	-	1	1	1	1	1803152-1	STRIP GUIDE, REAR	19
	-	1	1	1	1	1803151-1	STRIP GUIDE, FRONT	18
	-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	-	10
1	-	1	1	1	1	2-690495-2	PLATE, FRONT SHEAR	9
1	1	1	1	1	1	2-1803257-8	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	1-2217206-0	BLADE, SLUG	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	7-240641-1	SPACER	5
	-	1	1	1	1	1-238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	1803187-2	CRIMPER, INSULATION F	3
	-	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	1	1	1-1673600-9	CRIMPER, WIRE	1
-77-	27-	25-	22-	21	PART NO	DESCRIPTION	ITEM NO	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CUSTOMER DRAWING	
mm	0 PLC	±		WEIGHT	A1 00779
	1 PLC	±		SCALE	1:1
	2 PLC	±		SHEET	3 OF 4
	3 PLC	±		REV	A
	4 PLC	±			
	ANGLES	±			
	FINISH	±			

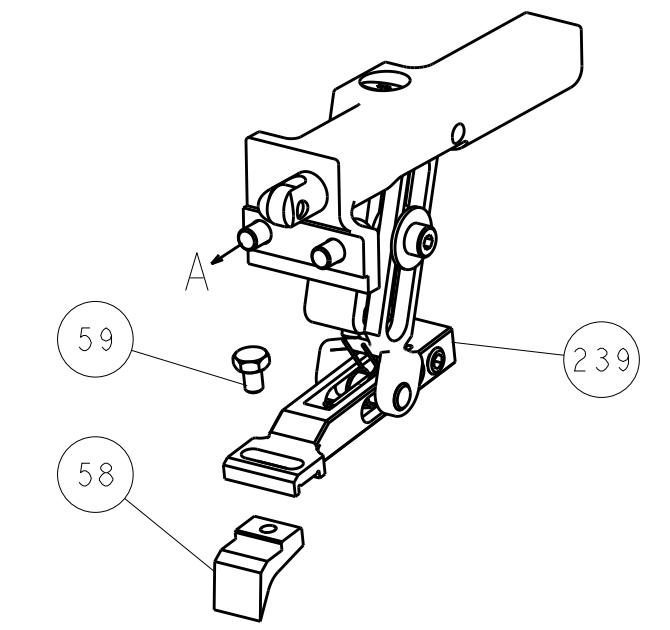
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
				SEE SHEET 1			



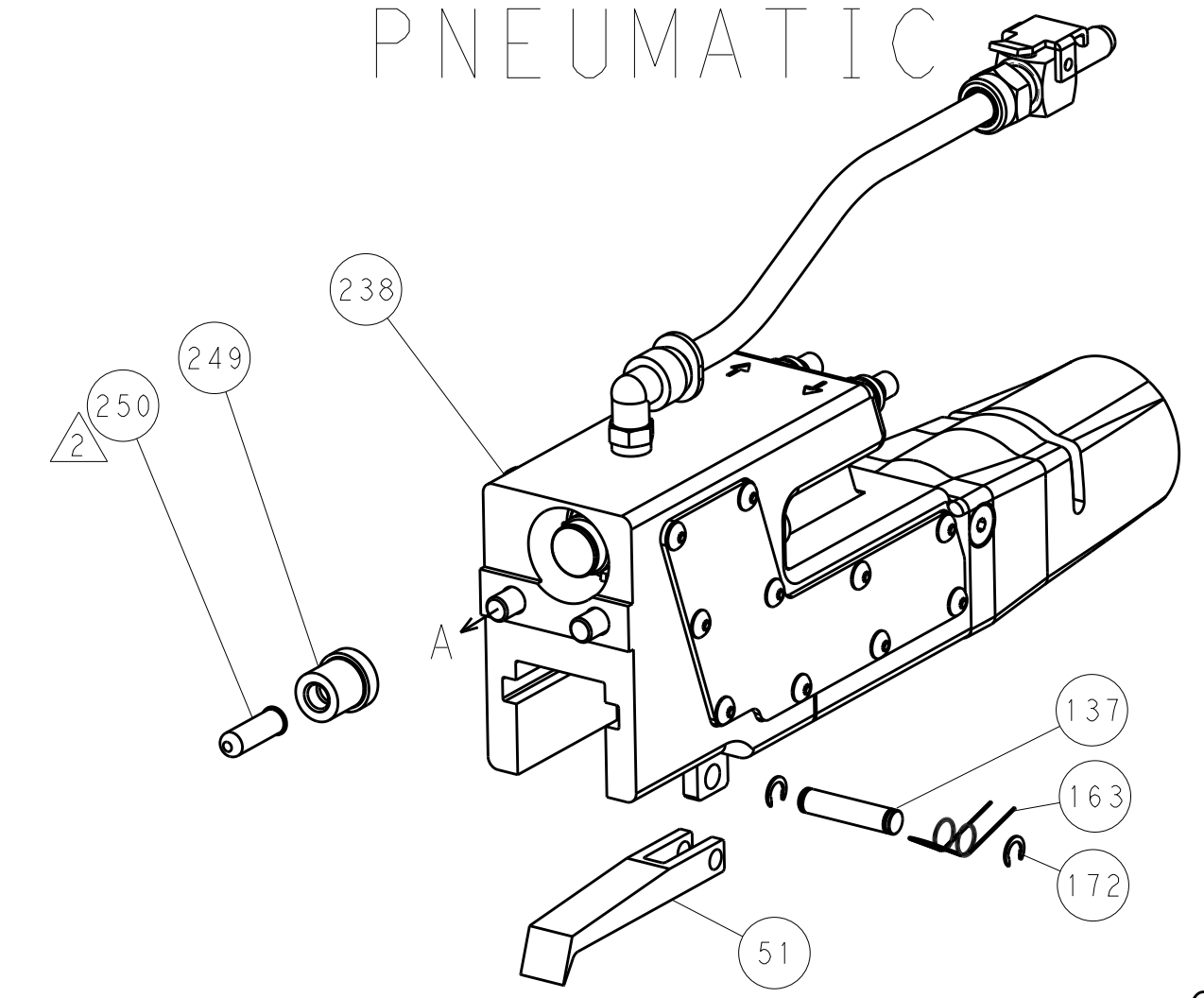
HOLDDOWN SET-UP



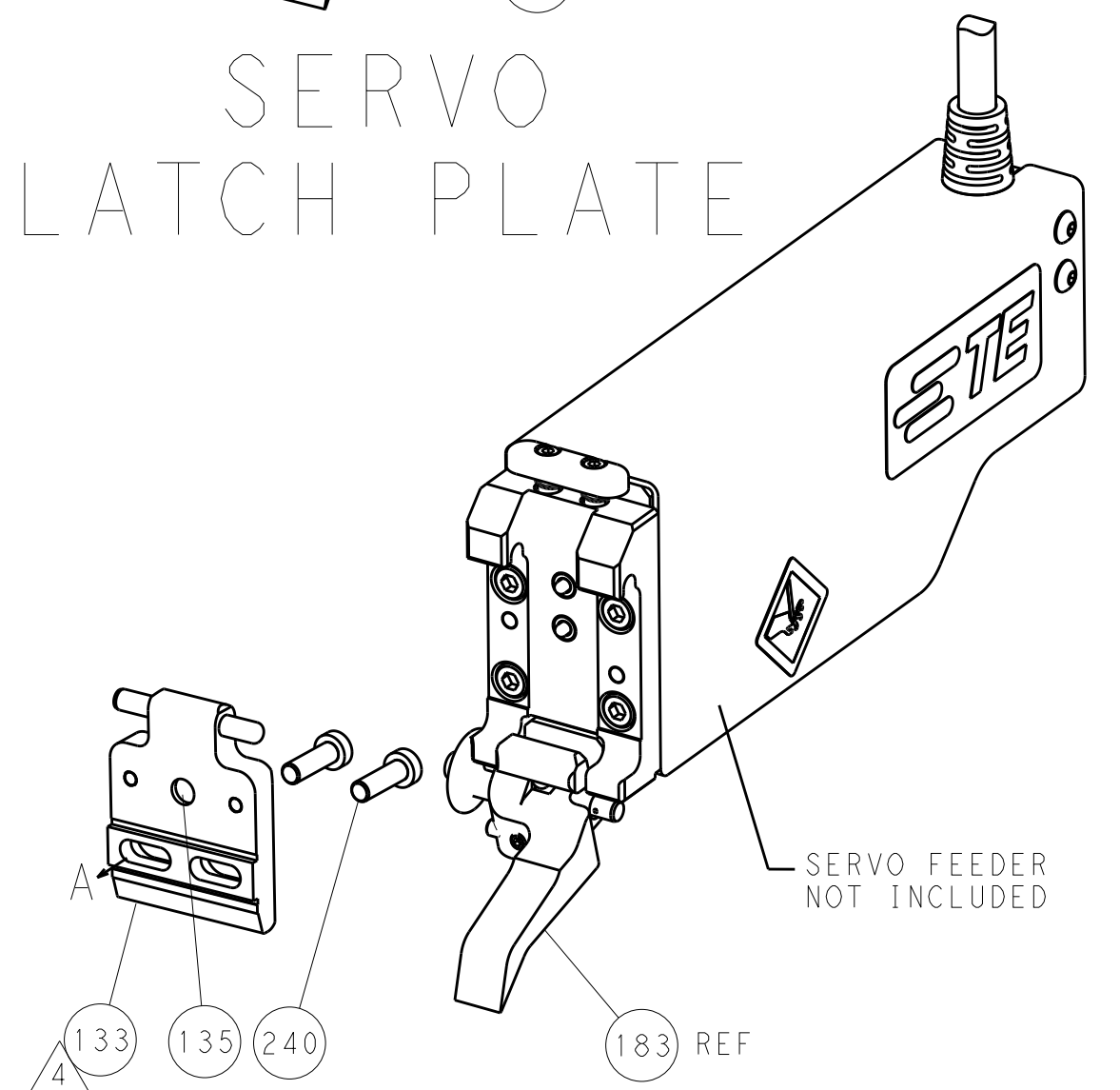
FEED TYPE
MECHANICAL



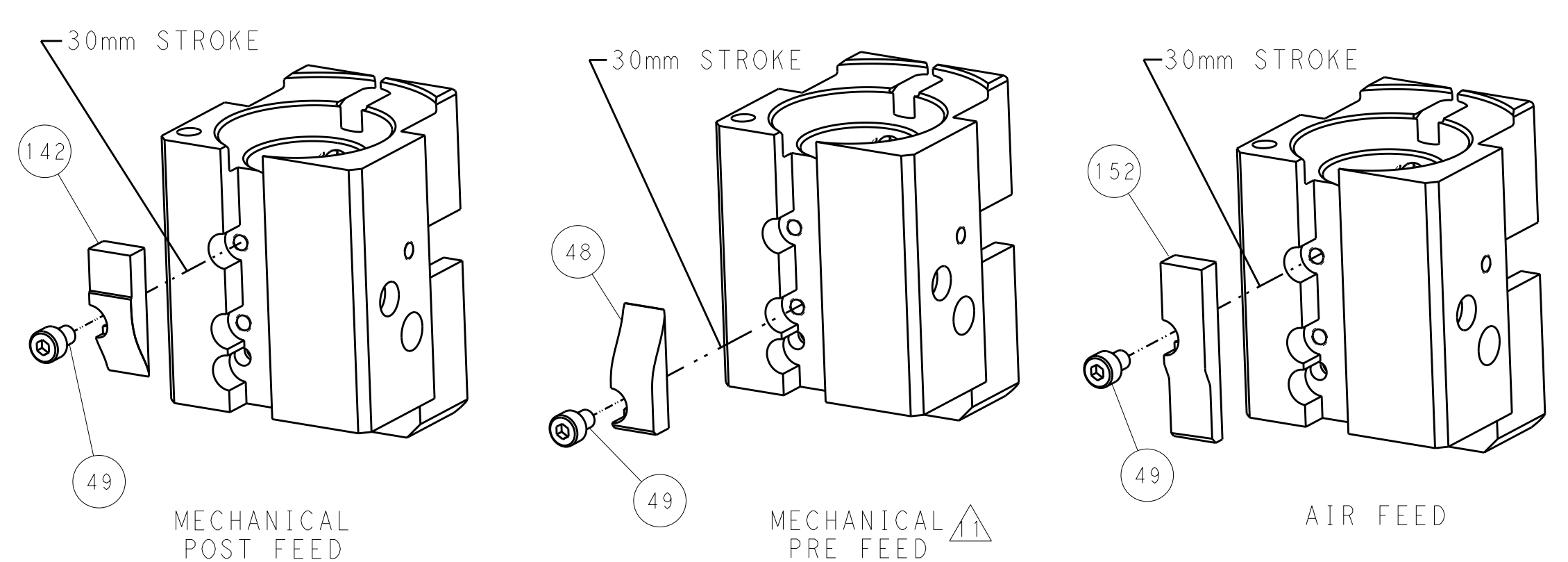
PNEUMATIC



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: M_HERR 24MAR2017 CHK: T_ELBIN 24MAR2017 APVD: T_ELBIN 24MAR2017		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150790		RESTRICTED TO: - SCALE: 1:1 SHEET: 4 OF 4 REV: A	
mm	0 PLC	±		PRODUCT SPEC					
	1 PLC	±		APPLICATION SPEC					
	2 PLC	±		WEIGHT					
	3 PLC	±		CUSTOMER DRAWING					
	4 PLC	±							
	ANGLES	±							
	FINISH								