

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
|---|-------------|--------------------------|--------------------------|-------------------|-------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | 2150171-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-9 | - | 2119641-1 | - | 2063440-1 |
| | 2150171-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | 1901697-3 | 8-2150171-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150171-4 | - | - | - |
| | | | | | MECHANICAL FEED | 2119949-1 | 2063961-3 | 5-18022-5 | 2119653-1 | - | - |
| | 2150171-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1 | 1901697-3 | 8-2150171-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150171-4 | - | - | - |
| | 2150171-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 2063961-3 | 5-18022-5 | 2119653-1 | - | - |
| 2150171-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | PNEUMATIC FEED | 2119950-1 | 2119792-9 | - | 2119641-1 | - | 2063440-1 | |
| 7-2150171-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 5.84 mm [.230] | F |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: KET TERMINAL | | KET CRIMP SPECIFICATION | |
|------------------------------------|--------------|-----------------------------|--------------|
| TERMINAL NAME: .250 D/L CONNECTOR | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.50-5.50 mm [.177-.217 IN] | | Ø 2.02-2.6mm [.080-.102 IN] | |
| TERMINAL APPLICATION SPECIFICATION | NONE | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | KET TERMINAL | TE TERMINAL | KET TERMINAL |
| 1949544-1 | ST730468-1 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------------------------------|----------------------------|--------------------------------|
| AVS 1.25mm ² OR 16 AWG | 1.67+/-0.05 [.066+/-0.002] | 5.1 |
| AVS 0.85mm ² OR 18 AWG | 1.51+/-0.05 [.059+/-0.002] | 6.7 |

- 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: 8-2150171-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150171-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150171-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150171-6
- 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 ITEMS 242.
 FOR *-6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 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.
- WHEN ASSEMBLING *-6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT
- 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.

| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |
|-----|----|----|----|----|----|-----------|--------------------------------------|---------|
| - | - | 1 | - | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 |
| - | 1 | - | 1 | 1 | 1 | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252 |
| - | - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | 1 | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| - | - | - | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | - | 1 | 1 | 1 | 2119798-1 | DETENT PIN | 247 |
| - | 1 | - | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | 1 | - | - | - | 2119759-1 | RAM, AMP STYLE, END FEED, NON-ADJUST | 245 |

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

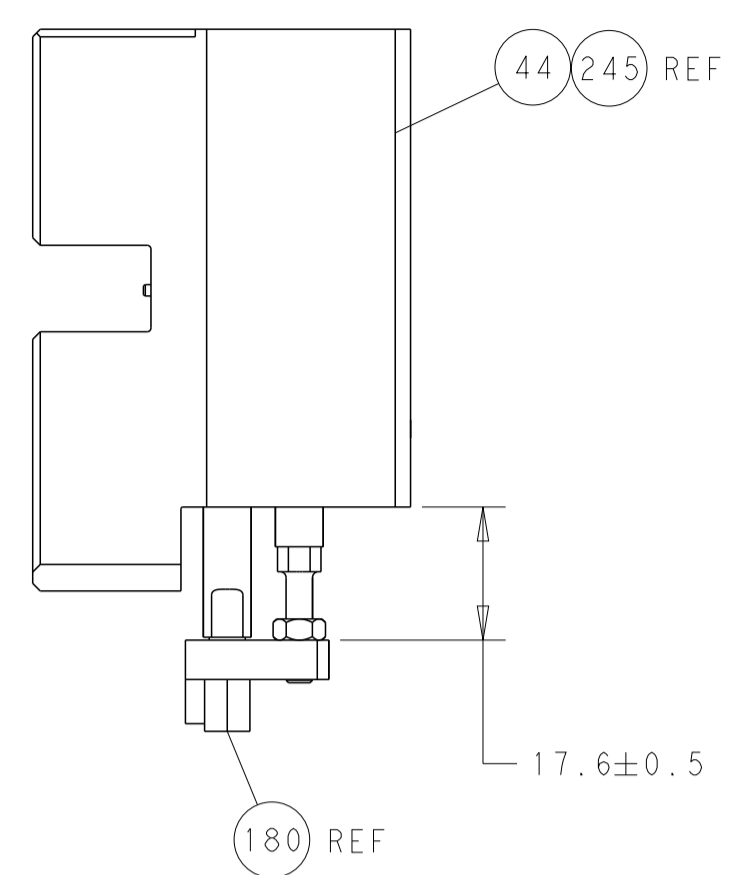
| SET UP GAUGE | LOC | DIST | REVISIONS | | | | | |
|--------------|-----|------|-----------|-----|-------------|-----------|-----|------|
| 2119599-2 | A | 66 | P | LTM | DESCRIPTION | DATE | OWN | APVD |
| | | | 1 | | DEVELOPMENT | 19APR2012 | YY | SX |
| | | | 2 | | REVISED | 10MAY2013 | KH | UG |
| | | | 3 | | UPDATE | 24JUL2015 | KH | UG |
| | | | A | | RELEASED | 05OCT2015 | CT | TE |

| | | | | | | | | |
|---|--------|--------|--------|--------|--------|-------------|-------------------------------------|-----|
| - | 1 | 1 | 1 | 1 | 1 | 2119082-7 | 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 | 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 | 1 | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | - | REFREF | - | - | - | 1901697-3 | FEED FINGER ASSEMBLY, EF | 183 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1752354-2 | STANDOFF, HOLD-DOWN | 180 |
| - | 1 | 1 | 1 | 1 | 1 | 6-9931111-6 | 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 |
| - | REFREF | REFREF | REFREF | REFREF | REFREF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | - | - | - | - | 1 | 240638-1 | SPRING, FEED FINGER | 163 |
| - | - | - | - | - | 1 | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | - | REFREF | - | - | - | SEE NOTE 4 | MEMORY CHIP, PROGRAMMED | 135 |
| - | - | 1 | 1 | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 |
| - | 1 | 1 | 1 | 1 | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 2119791-5 | DEPRESSOR, WIRE | 73 |
| - | 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 | 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 |
| - | 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 | 1 | 1 | 1 | 1 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 |
| - | - | - | - | - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | - | - | - | 1 | 2063961-3 | FEED FINGER | 58 |
| - | 4 | 4 | 4 | 4 | 4 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 |
| - | 2 | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 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 | 2119792-9 | PAWL, EF, AIR | 51 |
| - | - | - | - | - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | - | - | - | - | 1 | 2119653-1 | FEED CAM, POST FEED | 47 |
| - | 1 | 1 | 1 | 1 | 1 | 2119655-5 | APPLICATOR BASIC ASSEMBLY, EF | 46 |
| - | 1 | - | 1 | 1 | 1 | 2119369-1 | RAM, AMP STYLE, END FEED | 44 |
| - | 1 | 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 | 1-2119644-2 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | 1 | - | 1 | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | 8 | 8 | 8 | 8 | 8 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 31 |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 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 | 1752371-5 | PLATE, STRIP GUIDE | 24 |
| - | 2 | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1 | 1 | 1 | 1 | 1752373-4 | DRAG | 20 |
| - | 1 | 1 | 1 | 1 | 1 | 1803152-4 | STRIP GUIDE, REAR | 19 |
| - | 1 | 1 | 1 | 1 | 1 | 1803151-4 | STRIP GUIDE, FRONT | 18 |
| - | 4 | 4 | 4 | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 |
| - | 1 | 1 | 1 | 1 | 1 | 1752360-1 | SPACER, HOLD-DOWN | 13 |
| - | 1 | 1 | 1 | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | - | - | - | - | - | - | - | 10 |
| - | 1 | 1 | 1 | 1 | 1 | 690482-6 | PLATE, FRONT SHEAR | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 3-1633384-2 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 1 | 2217206-4 | BLADE, SLUG | 7 |
| - | 1 | 1 | 1 | 1 | 1 | 1-240641-8 | SPACER | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 2-1803187-4 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-7 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 1-456405-3 | CRIMPER, WIRE PREMIUM | 1 |

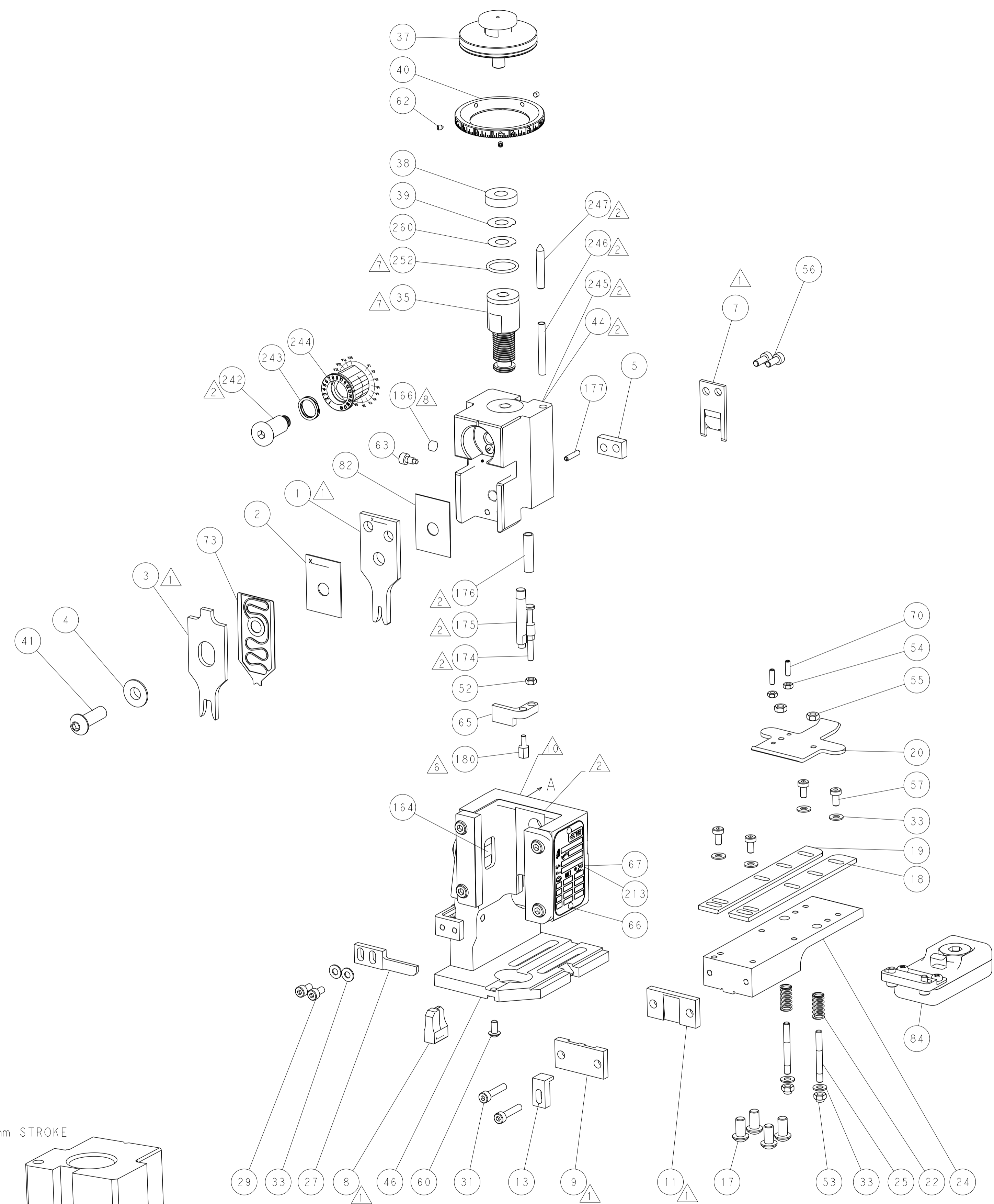
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG | | CHK | | APVD | | NAME | |
|-------------|---------------|--|-----------|-----------|-----------|-----------------|-----------|---------------------------|-----------|---------------------------|---|
| mm | 0 PLC ±.5 | 1 PLC ±.5 | 2 PLC ±.5 | 3 PLC ±.5 | 4 PLC ±.5 | Y. YIN | 19APR2012 | G. BAILEY | 19APR2012 | S. XI | |
| | ANGLES ±.0001 | FINISH | | | | TE Connectivity | | Harrisburg, PA 17105-3608 | | Ocean End Feed Applicator | |
| MATERIAL | | WEIGHT | | SCALE | 1:1 | SHEET | 1 | OF | 4 | REV | A |

| LOC | DIST | REV | DATE | BY | APPV |
|-----|------|-----|------|----|------|
| A | 66 | | | | |

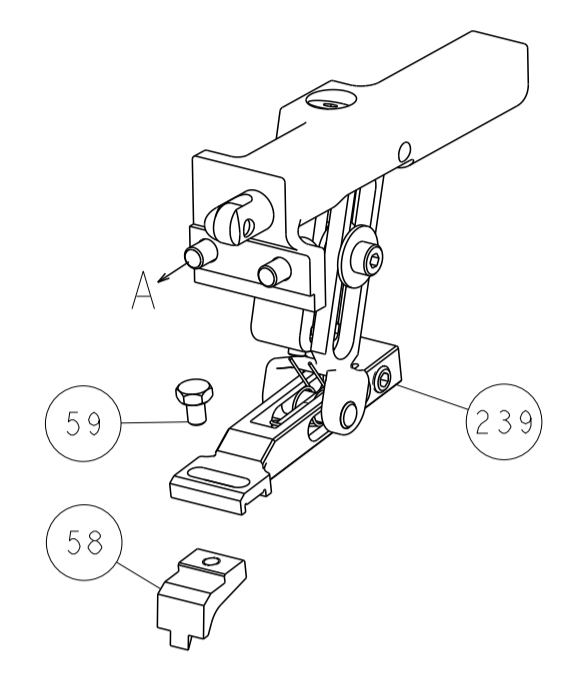
| REVISIONS | | | |
|-----------|-------------|----|------|
| REV | DATE | BY | APPV |
| - | SEE SHEET 1 | - | - |



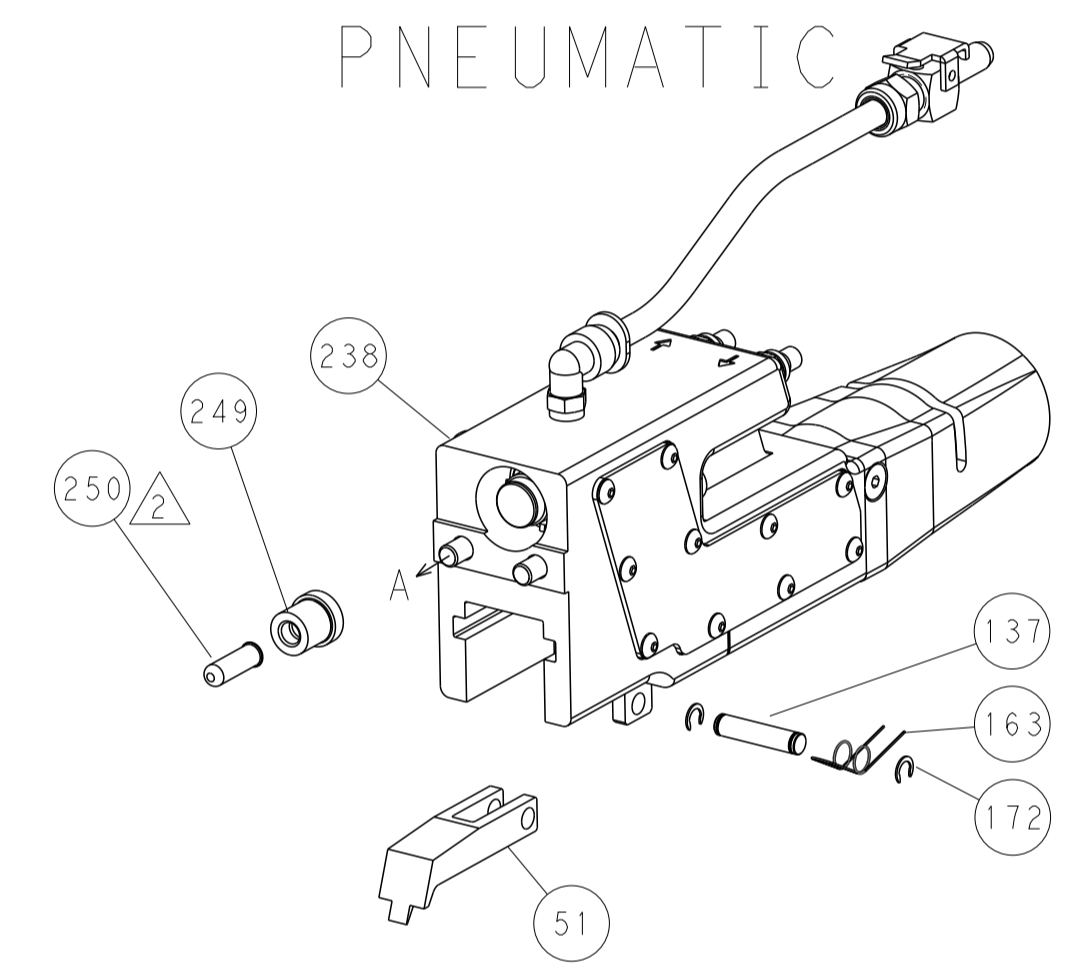
HOLDDOWN SET-UP



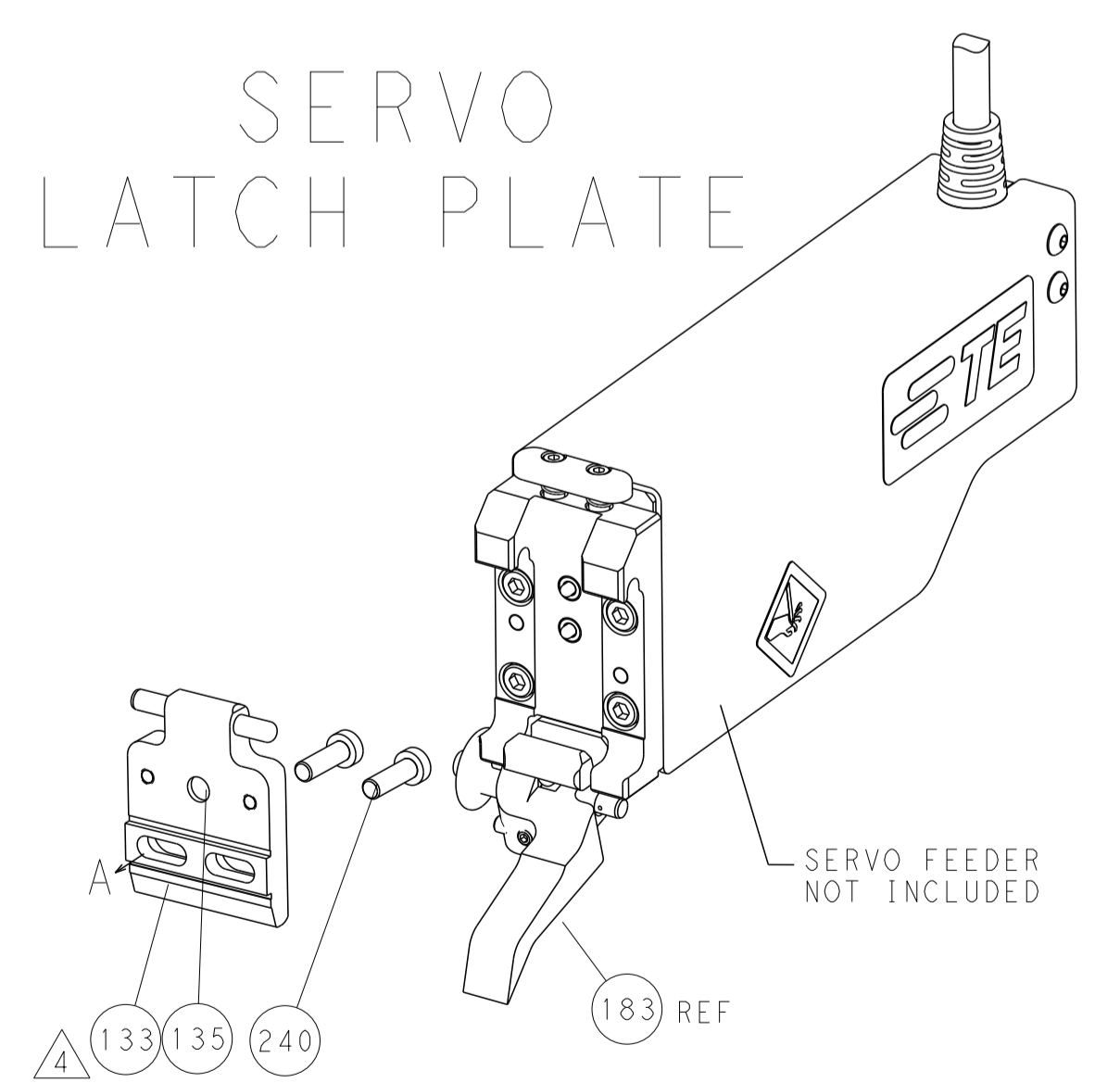
FEED TYPE
MECHANICAL



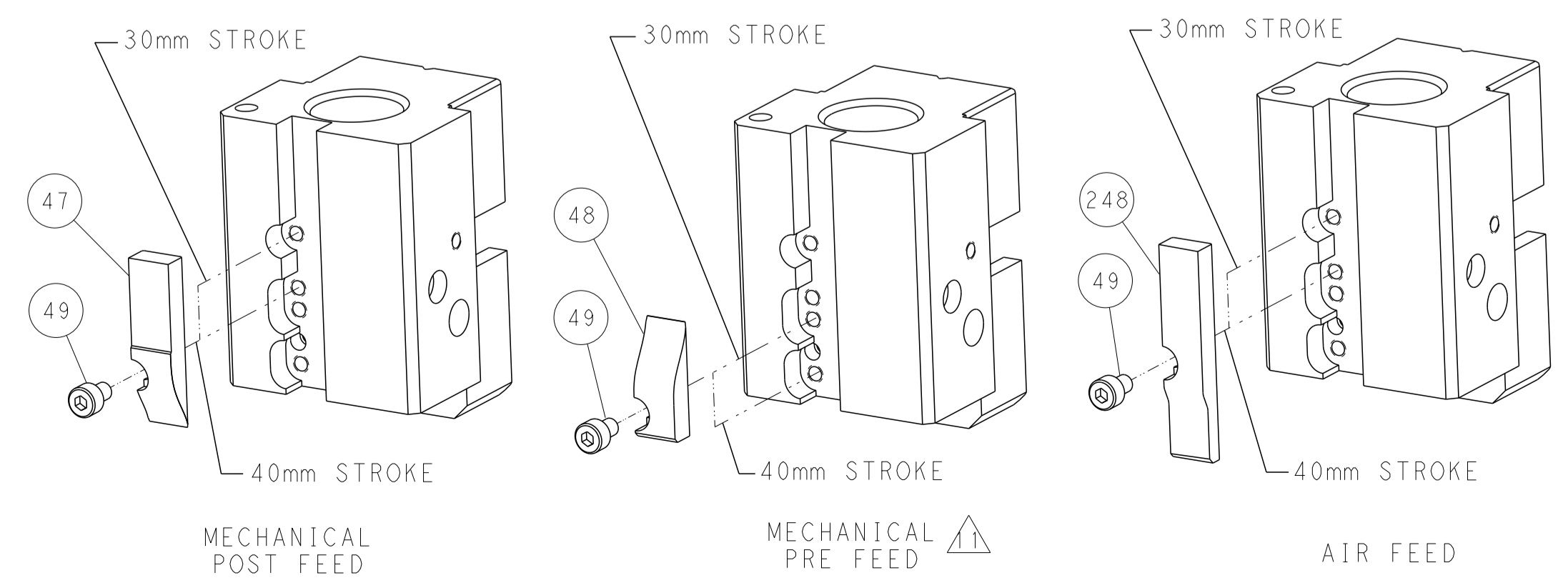
PNEUMATIC



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 | 19APR2012 | TE Connectivity Harrisburg, PA 17105-3608 |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | CHK | 19APR2012 | |
| | 3 PLC ±0.013 | 4 PLC ±0.001 | ANGLES ±0.0001 | APVD | 19APR2012 | NAME |
| MATERIAL: | FINISH: | WEIGHT: | SCALE | A | | Customer Accessible Production Drawing |
| SHEET 2 OF 4 | | REV A | | SIZE CAGE CODE DRAWING NO A1 00779 ©=2150171 | | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-9 | - | 2119641-2 | - |
| | 2-2150171-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | SERVO LATCH PLATE | 2119951-1 | 1901697-3 | 8-2150171-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150171-4 | - | - | - |
| | | | | | MECHANICAL FEED | 2119949-1 | 2063961-3 | 5-18022-5 | 2119653-2 | - | - |
| | 2-2150171-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | 1901697-3 | 8-2150171-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150171-4 | - | - | - |
| | | | | | MECHANICAL FEED | 2119949-1 | 2063961-3 | 5-18022-5 | 2119653-2 | - | - |
| | 2-2150171-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 2119950-1 | 2119792-9 | - | - | 2119641-2 | - | 2063440-1 |
| | 2-2150171-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2150171-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 5.84 mm [.230] | F |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: KET TERMINAL | | KET CRIMP SPECIFICATION | |
|------------------------------------|--------------|------------------------------|--------------|
| TERMINAL NAME: .250 D/L CONNECTOR | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.50-5.50 mm [.177-.217 IN] | | ∅ 2.02-2.60mm [.080-.102 IN] | |
| TERMINAL APPLICATION SPECIFICATION | NONE | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | KET TERMINAL | TE TERMINAL | KET TERMINAL |
| 1949544-1 | ST730468-1 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------------------------------|----------------------------|--------------------------------|
| AVS 1.25mm ² OR 16 AWG | 1.67+/-0.05 [.066+/-0.002] | 5.1 |
| AVS 0.85mm ² OR 18 AWG | 1.51+/-0.05 [.059+/-0.002] | 6.7 |

- 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: 8-2150171-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150171-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150171-5
- 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 62,180
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

***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.

| -77-27-25-22-21 | PART NO | 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 | 2119082-7 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - 1 1 1 1 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |

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

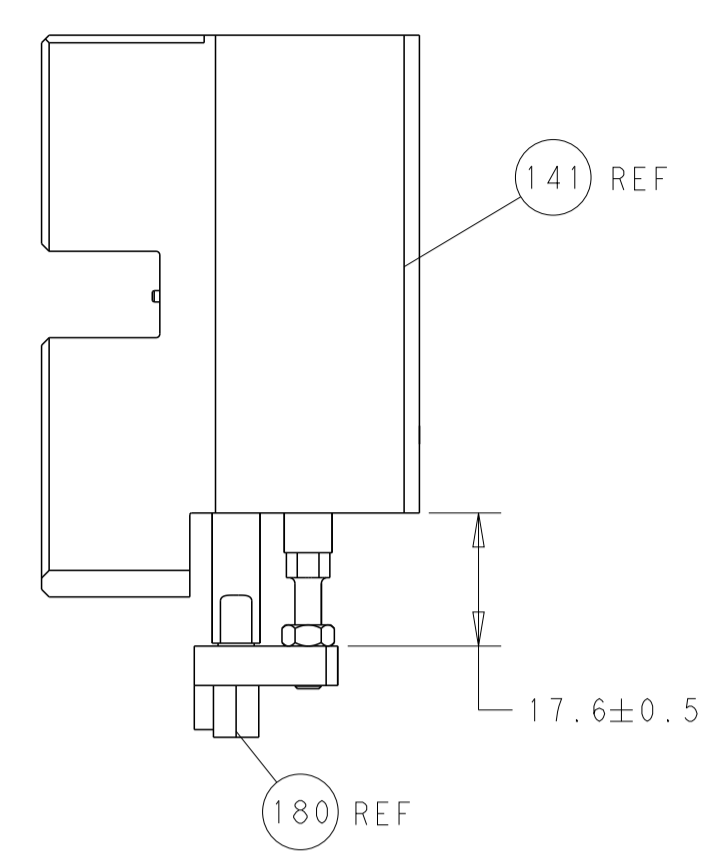
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-2 | A | 66 | REV | DATE | BY | APPV |
| | | | - | SEE SHEET 1 | - | - |

| REV | DATE | BY | APPV | DESCRIPTION | DATE | BY | APPV |
|----------------|-------------|----|------|-------------------------------------|------|----|------|
| - 1 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 - - | 1901697-3 | | | FEED FINGER ASSEMBLY, EF | | | 183 |
| - 1 1 1 1 1 | 1-1752354-2 | | | STANDOFF, HOLD-DOWN | | | 180 |
| - 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 | 2119955-2 | | | ASSY, LUBRICATOR, END FEED | | | 84 |
| - 1 1 1 1 1 | 455888-5 | | | SPACER, CRIMPER | | | 82 |
| - 1 1 1 1 1 | 2119791-5 | | | DEPRESSOR, WIRE | | | 73 |
| - 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 |
| - 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 | 2063961-3 | | | FEED FINGER | | | 58 |
| - 4 4 4 4 4 | 2168400-4 | | | SHCS, LOW HEAD, RoHS, M4 X 8 | | | 57 |
| - 2 2 2 2 2 | 1-2168083-0 | | | SCR, SKT HD CAP, RoHS, M4 X 10 | | | 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 - | 2119792-9 | | | 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 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 |
| - 8 8 8 8 8 | 1-18028-2 | | | WASHER, FLAT, REG M4 | | | 33 |
| - 2 2 2 2 2 | 2168083-9 | | | SCR, SKT HD CAP, RoHS, M4 X 20 | | | 31 |
| - 2 2 2 2 2 | 2168083-2 | | | SCR, SKT HD CAP, RoHS, M4 X 8.0 | | | 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 | 1752371-5 | | | PLATE, STRIP GUIDE | | | 24 |
| - 2 2 2 2 2 | 2-22281-3 | | | SPRING, COMPRESSION | | | 22 |
| - 1 1 1 1 1 | 1752373-4 | | | DRAG | | | 20 |
| - 1 1 1 1 1 | 1803152-4 | | | STRIP GUIDE, REAR | | | 19 |
| - 1 1 1 1 1 | 1803151-4 | | | STRIP GUIDE, FRONT | | | 18 |
| - 1 1 1 1 1 | 1752360-1 | | | SPACER, HOLD-DOWN | | | 13 |
| - 1 1 1 1 1 | 240644-1 | | | PLATE, REAR SHEAR | | | 11 |
| - - - - - | - | | | - | | | 10 |
| - 1 1 1 1 1 | 690482-6 | | | PLATE, FRONT SHEAR | | | 9 |
| 1 1 1 1 1 1 | 3-1633384-2 | | | ANVIL, COMBINATION | | | 8 |
| - 1 1 1 1 1 | 2217206-4 | | | BLADE, SLUG | | | 7 |
| - 1 1 1 1 1 | 1-240641-8 | | | SPACER | | | 5 |
| - 1 1 1 1 1 | 238009-1 | | | BLOCK, FL CRIMPER SPACER | | | 4 |
| 1 1 1 1 1 1 | 2-1803187-4 | | | CRIMPER, INSULATION F | | | 3 |
| - 1 1 1 1 1 | 455888-7 | | | SPACER, CRIMPER | | | 2 |
| 1 1 1 1 1 1 | 1-456405-3 | | | CRIMPER, WIRE PREMIUM | | | 1 |

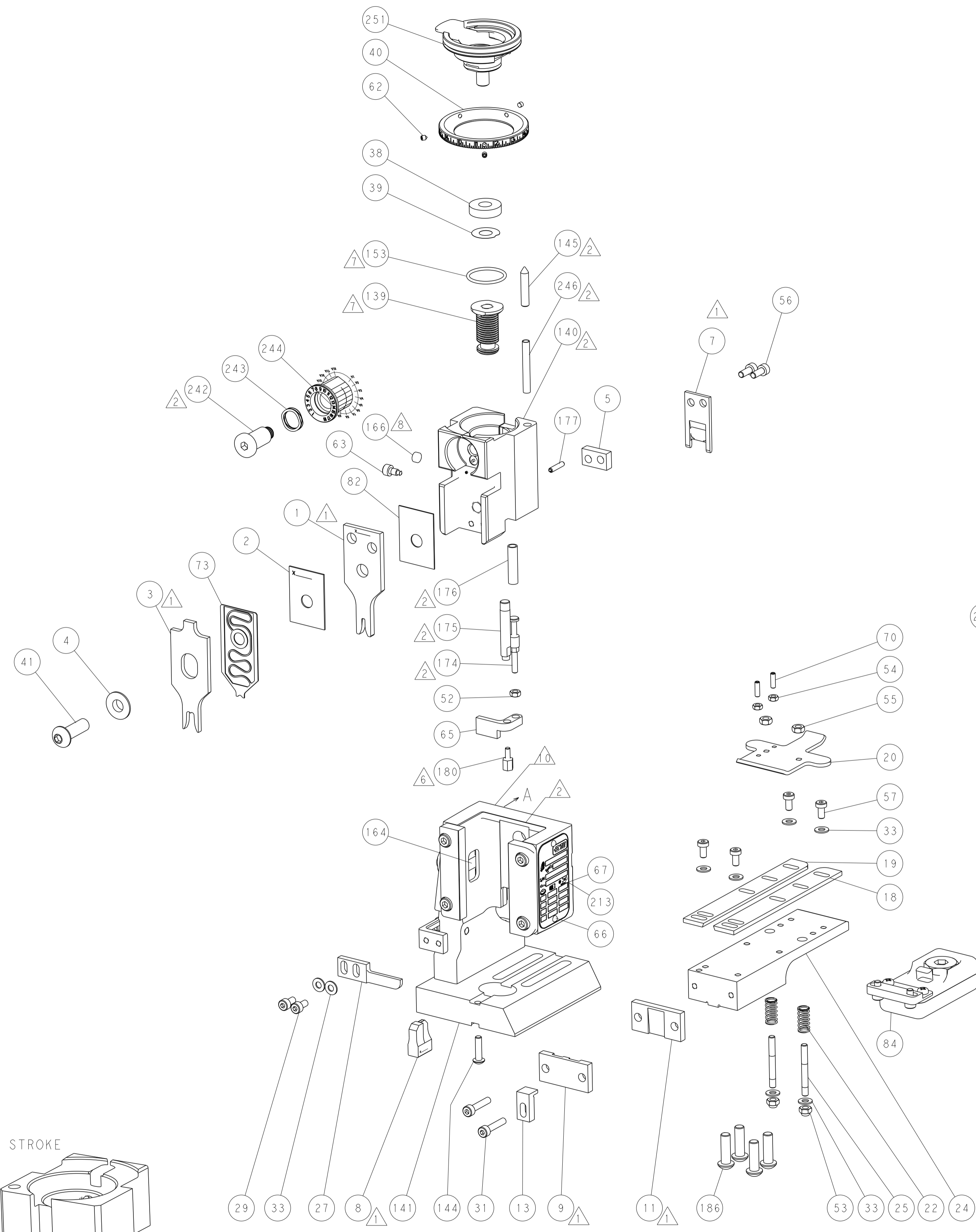
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DATE | |
|-------------|-----------|--|--------------|--------------|---------------------|
| mm | 0 PLC ±.5 | 1 PLC ±.13 | 2 PLC ±.0013 | 3 PLC ±.0001 | 4 PLC ANGLES ±.0001 |
| FINISH | | FINISH | | DATE | |
| MATERIAL | | MATERIAL | | DATE | |
| WEIGHT | | WEIGHT | | DATE | |

| | | | | |
|--|-----------|------------|---------------------------|---------------------------|
| OWN | T. YIN | 19APR2012 | | TE Connectivity |
| CHK | G. BAILEY | 19APR2012 | | Harrisburg, PA 17105-3608 |
| APPV | S. XI | 19APR2012 | NAME | |
| PRODUCT SPEC | | | Ocean End Feed Applicator | |
| APPLICATION SPEC | | | - | |
| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO | |
| A1 | 00779 | ©=2150171 | - | |
| Customer Accessible Production Drawing | | | SCALE | SHEET 3 OF 4 |
| | | | REV | A |

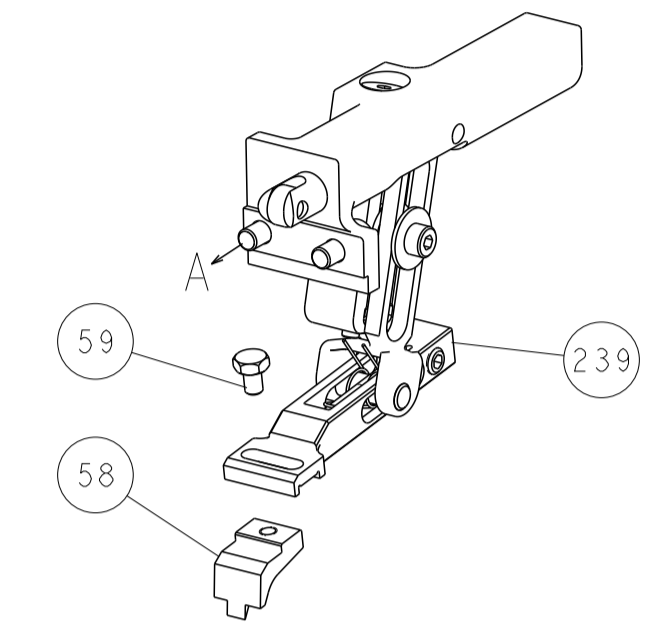
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|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTM | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | | | |



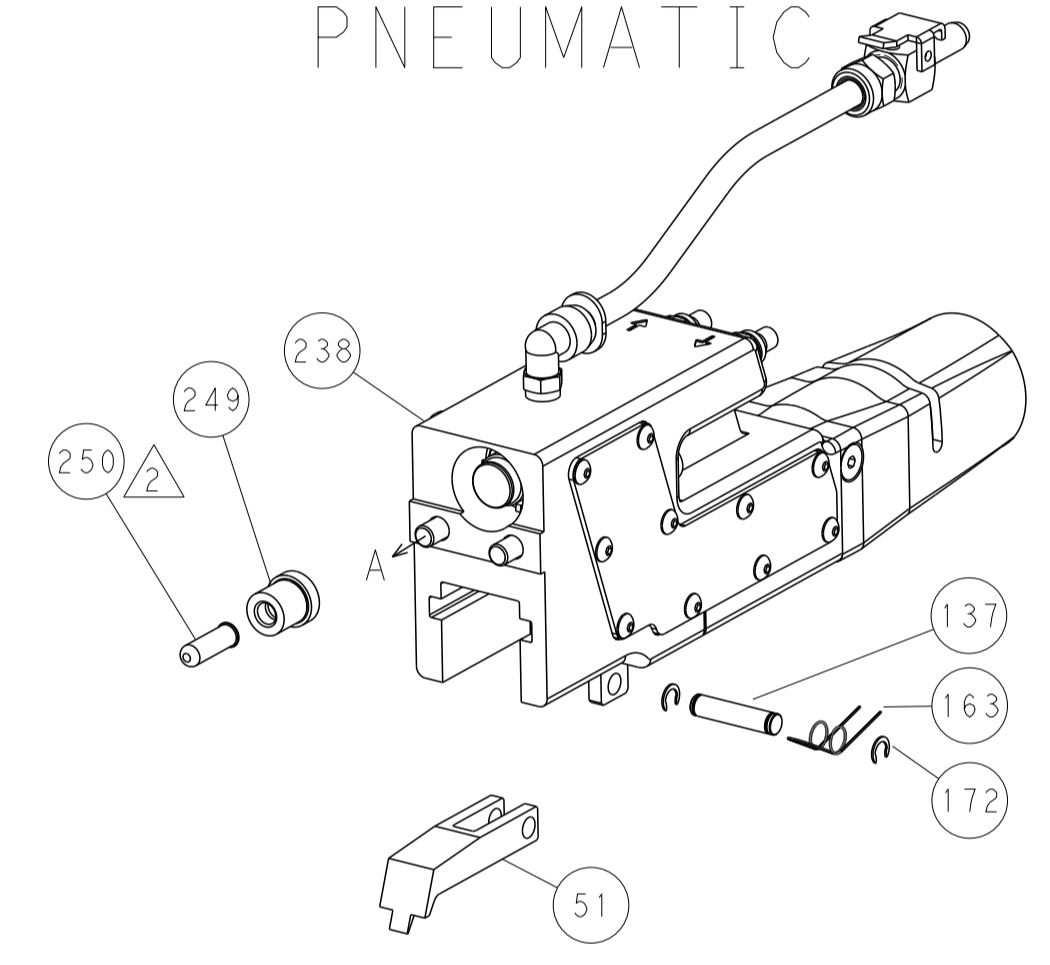
HOLDDOWN SET-UP



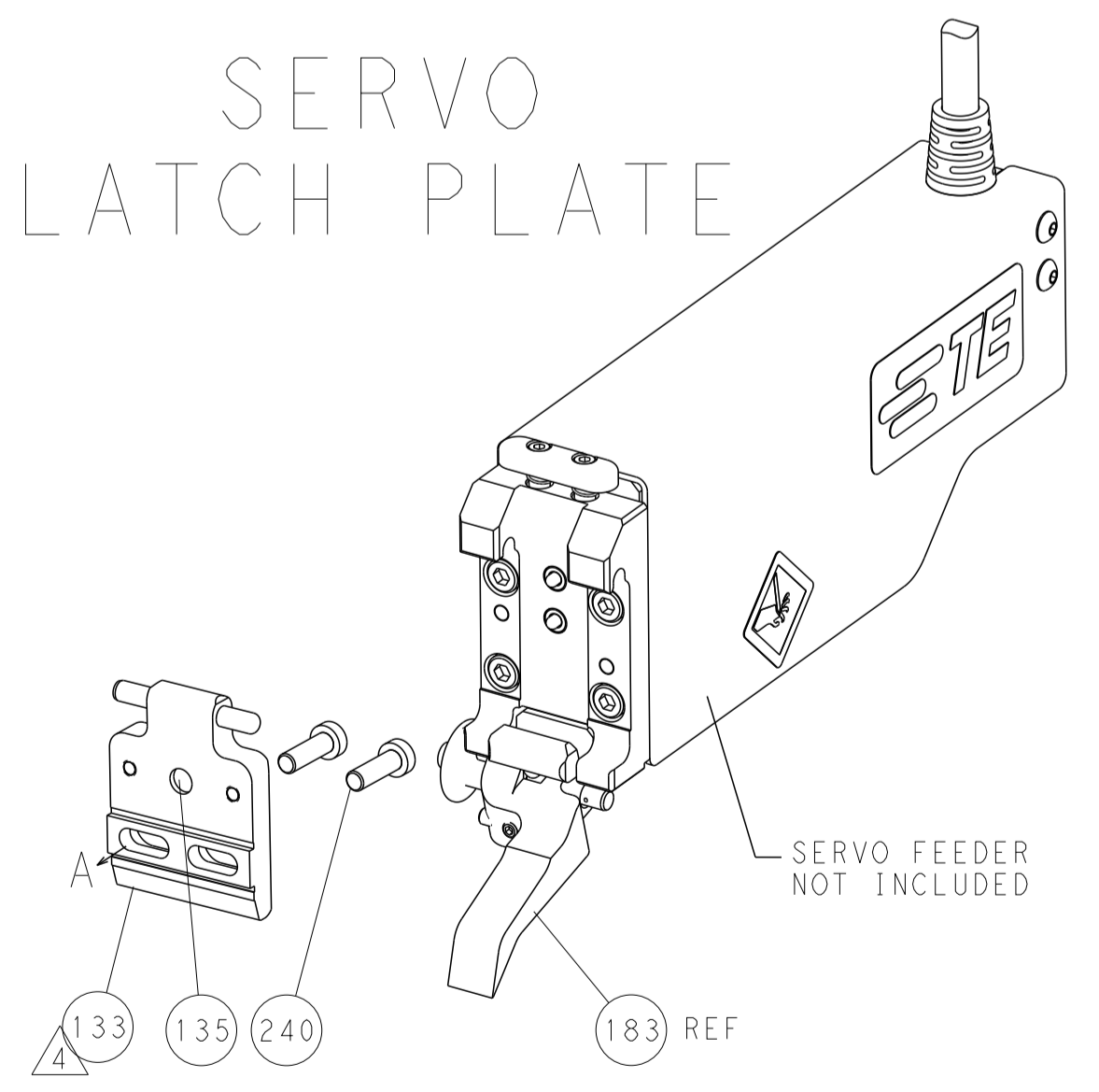
FEED TYPE
MECHANICAL



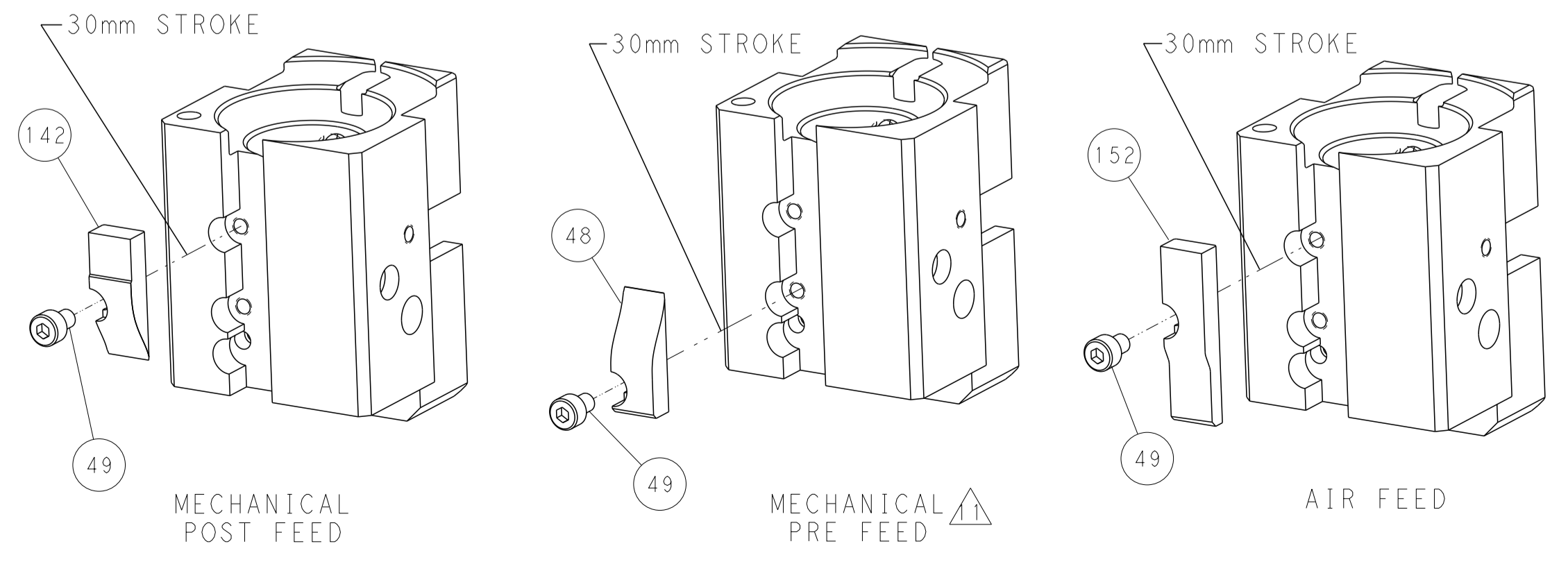
PNEUMATIC



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 Y. YIN 19APR2012 | | STE TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 | 5 PLC ±0.001 | Harrisburg, PA 17105-3608 |
| MATERIAL: | FINISH: | APVD S. XI 19APR2012 | NAME | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| | | PRODUCT SPEC | Ocean End Feed | A1 | 00779 | 2150171 | |
| | | APPLICATION SPEC | Applicator | Customer Accessible Production Drawing | SCALE 1:1 | SHEET 4 OF 4 | REV A |