

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2150589-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150589-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150589-4 | - | - | - |
| | 2150589-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150589-5 | - | - | 2168400-7 (QUANTITY 2) |
| | 2150589-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - | 2063440-1 |
| 2150589-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | - | |
| 2150589-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2150589-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.29 mm [.090] | F |
| INSUL | 3.15 mm [.124] | F |
| APPLICATOR INSTRUCTIONS 408-10390 | | |

| | | | |
|---|--|-------------|------------------|
| TERMINAL DATA: GH/LEAR TERMINAL | LEAR CRIMP SPECIFICATION | | |
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH 5.50-6.20 mm [.217-.244 IN] | INSULATION DIAMETER RANGE Ø 3.05 mm [.120 IN] MAX | | |
| TERMINAL APPLICATION SPECIFICATION 28640 CRIMP SPEC Rev 13 | - | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | GH/LEAR TERMINAL | TE TERMINAL | GH/LEAR TERMINAL |
| 2113724-1 | 28640.213.011 | 2113724-5 | 28640.123.242 |
| 2113724-2 | 28640.213.042 | 2113724-6 | 28640.123.211 |
| 2113724-3 | 28640.213.041 | 2113724-7 | 28640.123.204 |
| 2113724-4 | 28640.213.004 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 1.00mm2 | 1.45 +/- 0.05 [.057 +/- .002] | 5.4 |
| 0.75mm2 | 1.40 +/- 0.05 [.055 +/- .002] | 5.8 |
| 0.50mm2 | 1.30 +/- 0.05 [.051 +/- .002] | 7.4 |

- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
- 3 LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150589-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150589-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150589-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150589-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 180.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 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.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 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.
- 12 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
- 13 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 |
| - | 1 | 1 | 1 | 1 | 1 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |

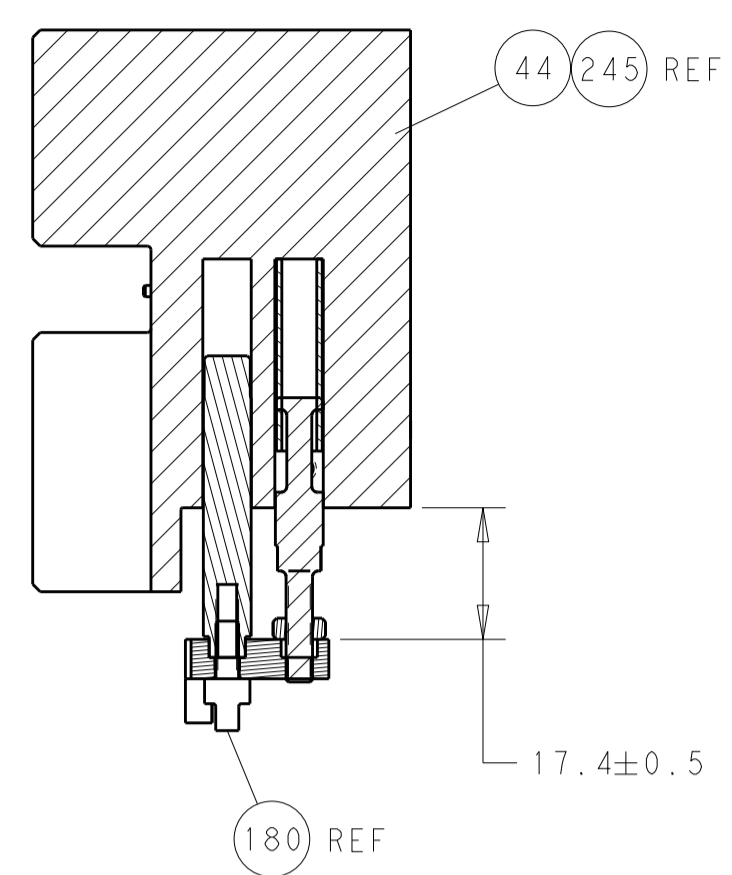
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS | | | | |
|--------------|-----|------|-----------|----------|-----------|------|----|
| 2119599-2 | A | 66 | REV | DATE | BY | APPD | |
| | | | A | RELEASED | 18AUG2015 | KH | TE |

| REV | DATE | BY | APPD | DESCRIPTION | DATE | OWN | APPD | |
|-----|--------|--------|--------|-------------|--------|-------------|-------------------------------------|-----|
| - | 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 | - | - | - | 1901697-1 | FEED FINGER ASSEMBLY, EF | 183 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1976055-2 | 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 |
| - | 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 | 455888-6 | 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 | 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 | 2168400-8 | SHCS, LOW HEAD, RoHS, M4 X 16 | 64 |
| - | 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 | 2063961-1 | FEED FINGER | 58 |
| - | 3 | 3 | 3 | 3 | 3 | 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 | - | 2119792-2 | 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 | 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 | 2119644-1 | 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 |
| - | 7 | 7 | 7 | 7 | 7 | 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 | 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 | 1-1752371-0 | 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 | 1901259-4 | GUIDE, LOWER STRIP | 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 | 240833-4 | PLATE, REAR SHEAR | 11 |
| - | - | - | - | - | - | - | - | 10 |
| - | 1 | 1 | 1 | 1 | 1 | 690482-4 | PLATE, FRONT SHEAR | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 8-1803001-9 | ANVIL, COMBINATION, END FEED | 8 |
| - | 1 | 1 | 1 | 1 | 1 | 1-2217206-2 | BLADE, SLUG | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2-240641-9 | SPACER | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 2-238009-9 | BLOCK, FL CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 3-1803187-8 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 1-455888-2 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 6-456406-2 | CRIMPER, WIRE PREMIUM | 1 |

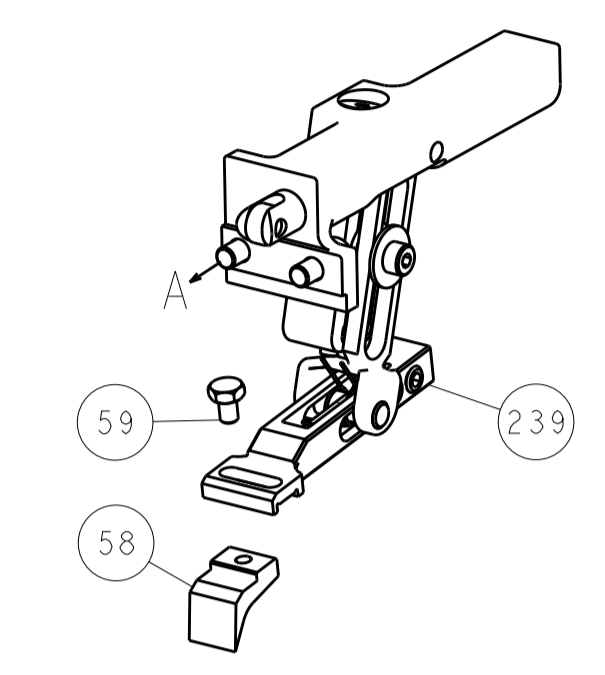
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DATE | | NAME | |
|--|---------|--|---------|------------|---------|--------------|----------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES ± | FINISH ± |
| MATERIAL: | | | | WEIGHT: | | SCALE: | |
| Customer Accessible Production Drawing | | | | SCALE: 1:1 | | SHEET 1 OF 4 | |

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

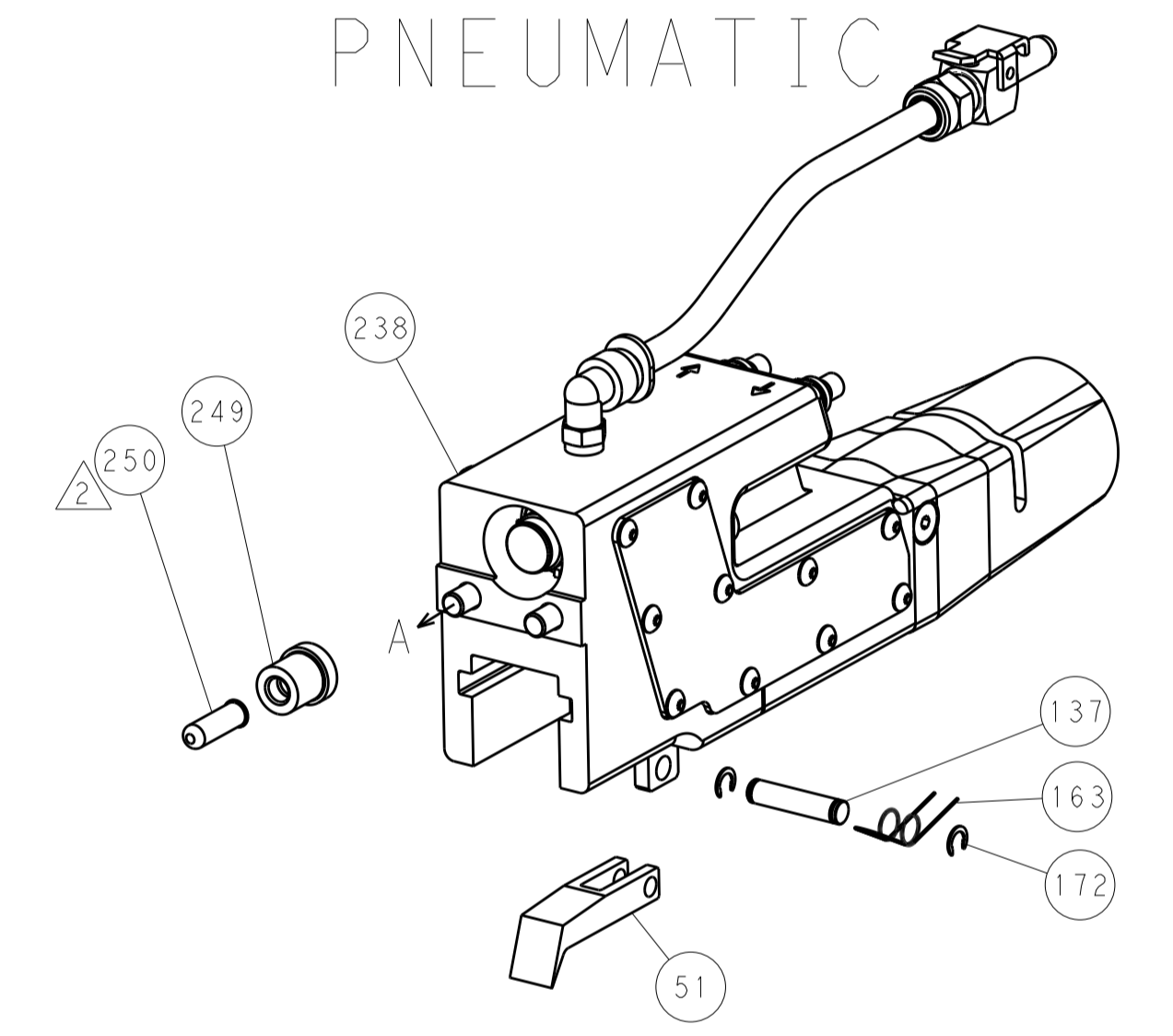


HOLDDOWN SET-UP

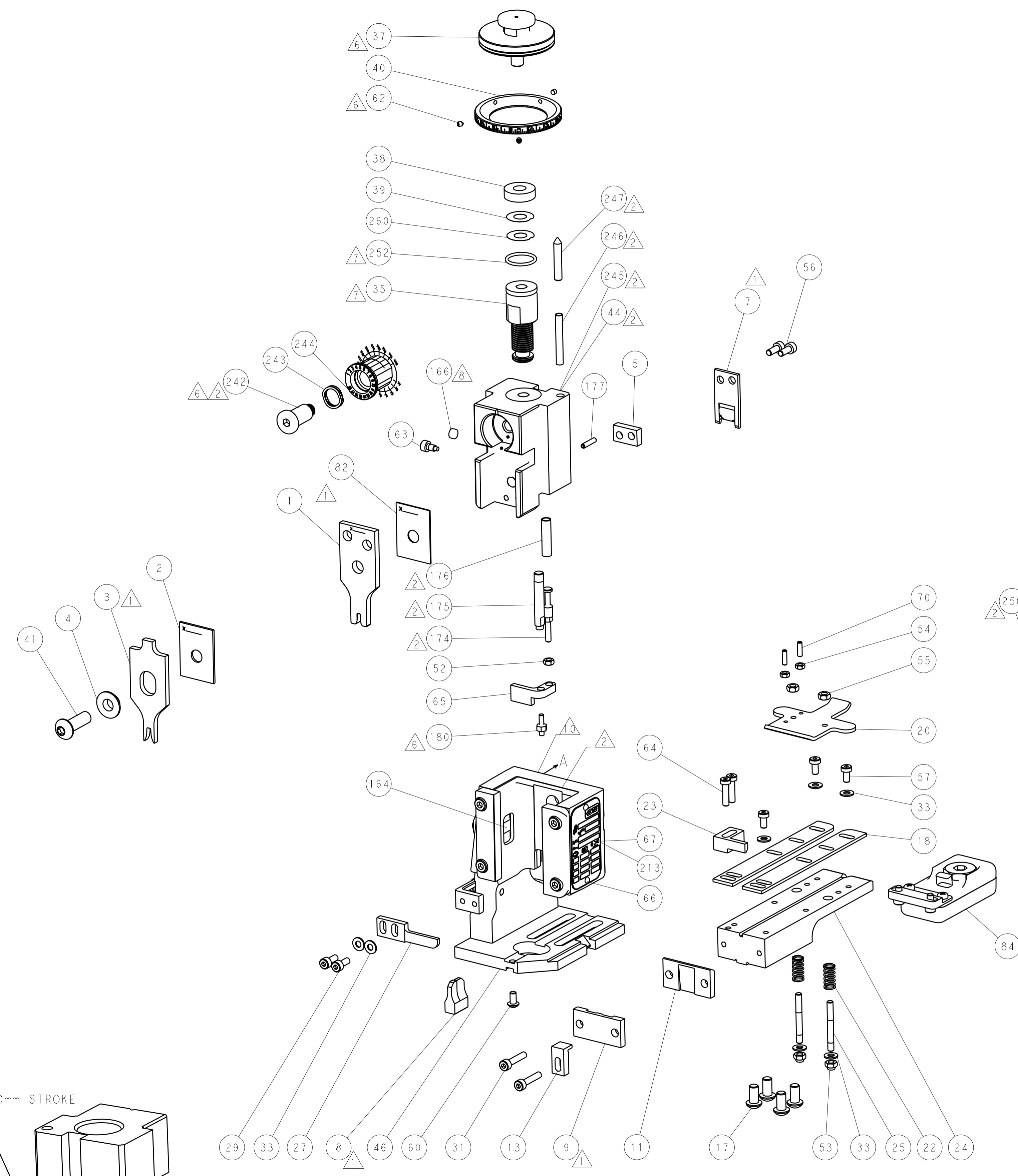
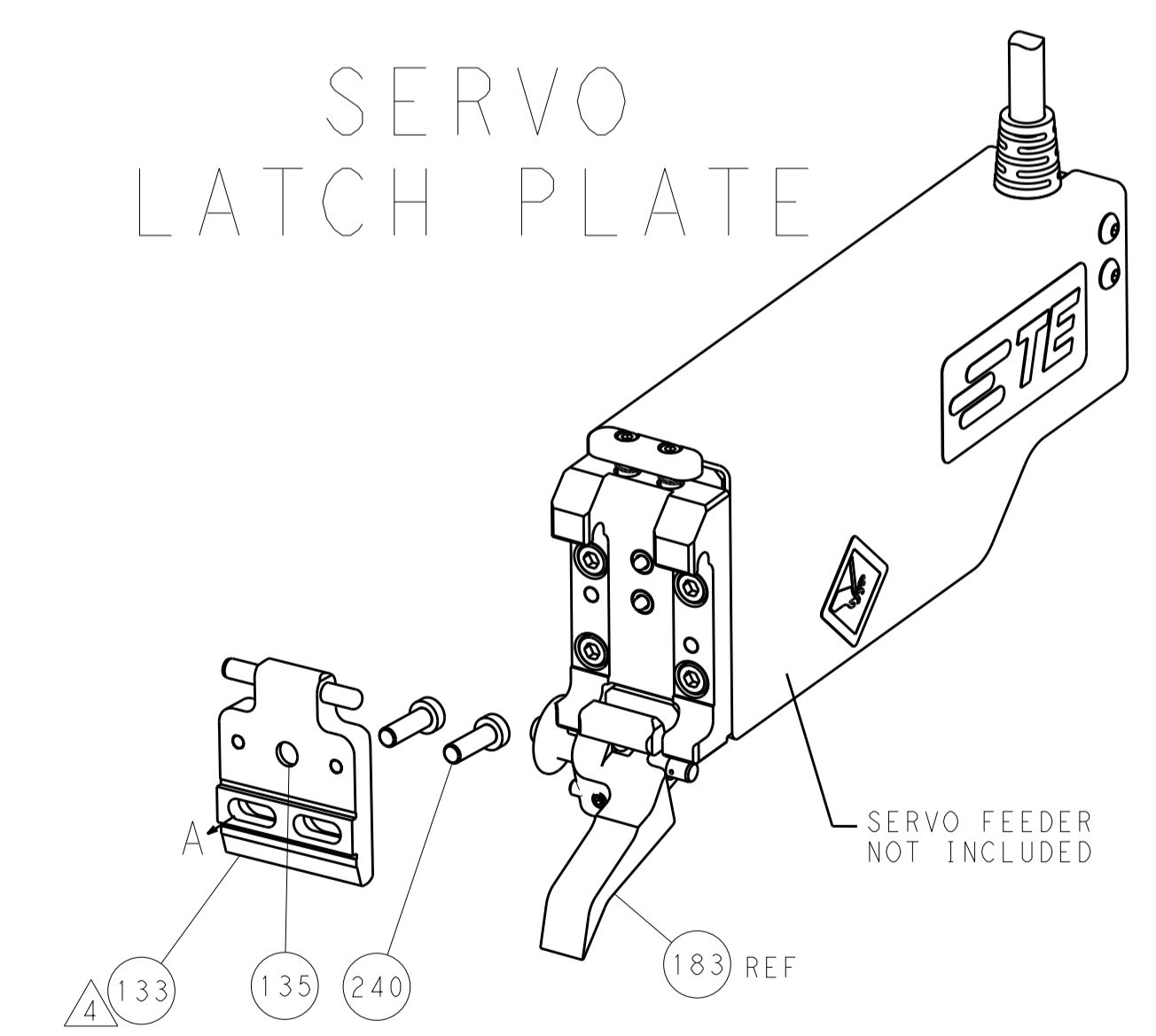
FEED TYPE
MECHANICAL



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: H. HUANG 17JUL2015 | TE Connectivity Harrisburg, PA 17105-3608 |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | CHK: L. ZHANG 17JUL2015 | |
| MATERIAL: | | FINISH: | | APVD: H. GUO 17JUL2015 | NAME: Ocean End Feed Applicator |
| | | | | PRODUCT SPEC: | SIZE: CAGE CODE: DRAWING NO: |
| | | | | APPLICATION SPEC: | RESTRICTED TO: |
| | | | | WEIGHT: | A1 00779 ©=2150589 |
| | | | | Customer Accessible Production Drawing | SCALE: 1:1 SHEET 2 OF 4 REV A |

| 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 | - |
| | 2-2150589-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150589-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150589-4 | - | - | - |
| | | | | | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | 2-2150589-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150589-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150589-4 | - | - | - |
| | | | | | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | 2-2150589-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 2119950-1 | 2119792-2 | - | - | 2119641-2 | - | 2063440-1 |
| | 2-2150589-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2150589-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|-----------------------------------|------|--|
| CRIMP SIZE | TYPE | |
| WIRE 2.29 mm (.090) | F | |
| INSUL 3.15 mm (.124) | F | |
| APPLICATOR INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: GH/LEAR TERMINAL LEAR CRIMP SPECIFICATION | | | |
|--|---------------------------|-------------|------------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 5.50-6.20 mm (.217-.244 IN) | 3.05 mm (.120 IN) MAX | | |
| TERMINAL APPLICATION SPECIFICATION | 28640 CRIMP SPEC Rev 13 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | GH/LEAR TERMINAL | TE TERMINAL | GH/LEAR TERMINAL |
| 2113724-1 | 28640.213.011 | 2113724-5 | 28640.123.242 |
| 2113724-2 | 28640.213.042 | 2113724-6 | 28640.123.211 |
| 2113724-3 | 28640.213.041 | 2113724-7 | 28640.123.204 |
| 2113724-4 | 28640.213.004 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 1.00mm2 | 1.45 +/- 0.05 [.057 +/- .002] | 5.4 |
| 0.75mm2 | 1.40 +/- 0.05 [.055 +/- .002] | 5.8 |
| 0.50mm2 | 1.30 +/- 0.05 [.051 +/- .002] | 7.4 |

- 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: 8-2150589-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150589-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150589-5
- 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.

***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.

| ITEM NO | DESCRIPTION | ITEM NO |
|-----------------|-------------------------------------|-------------|
| 251 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| 250 | PUSH ROD, AIR FEED | 250 |
| 249 | BUSHING, LCH5-12, MISUMI | 249 |
| 246 | SPRING, COMPRESSION | 246 |
| 244 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| 243 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| 242 | RETAINER, INSULATION DIAL | 242 |
| -77-27-25-22-21 | PART NO | DESCRIPTION |

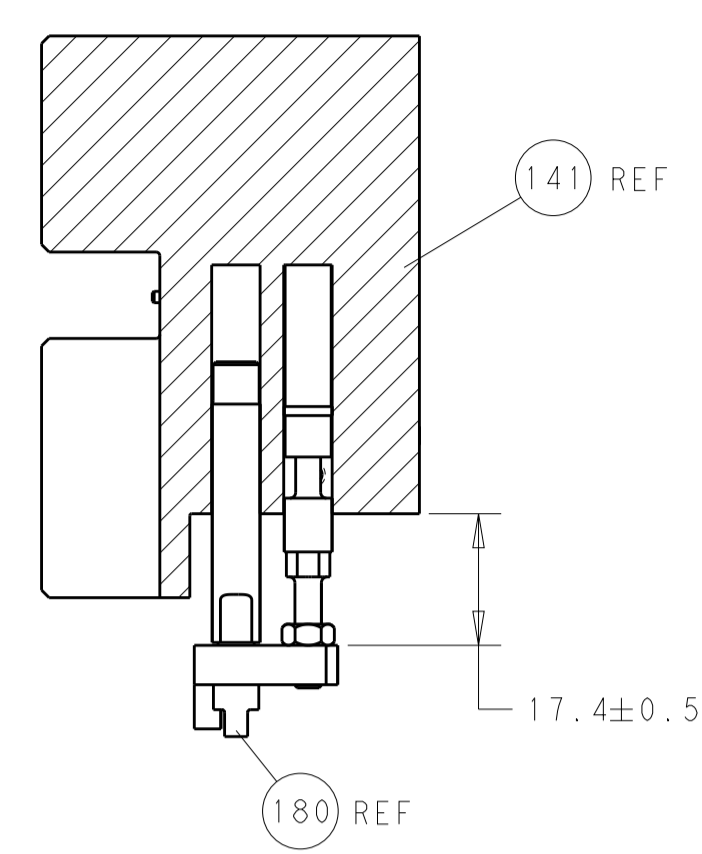
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

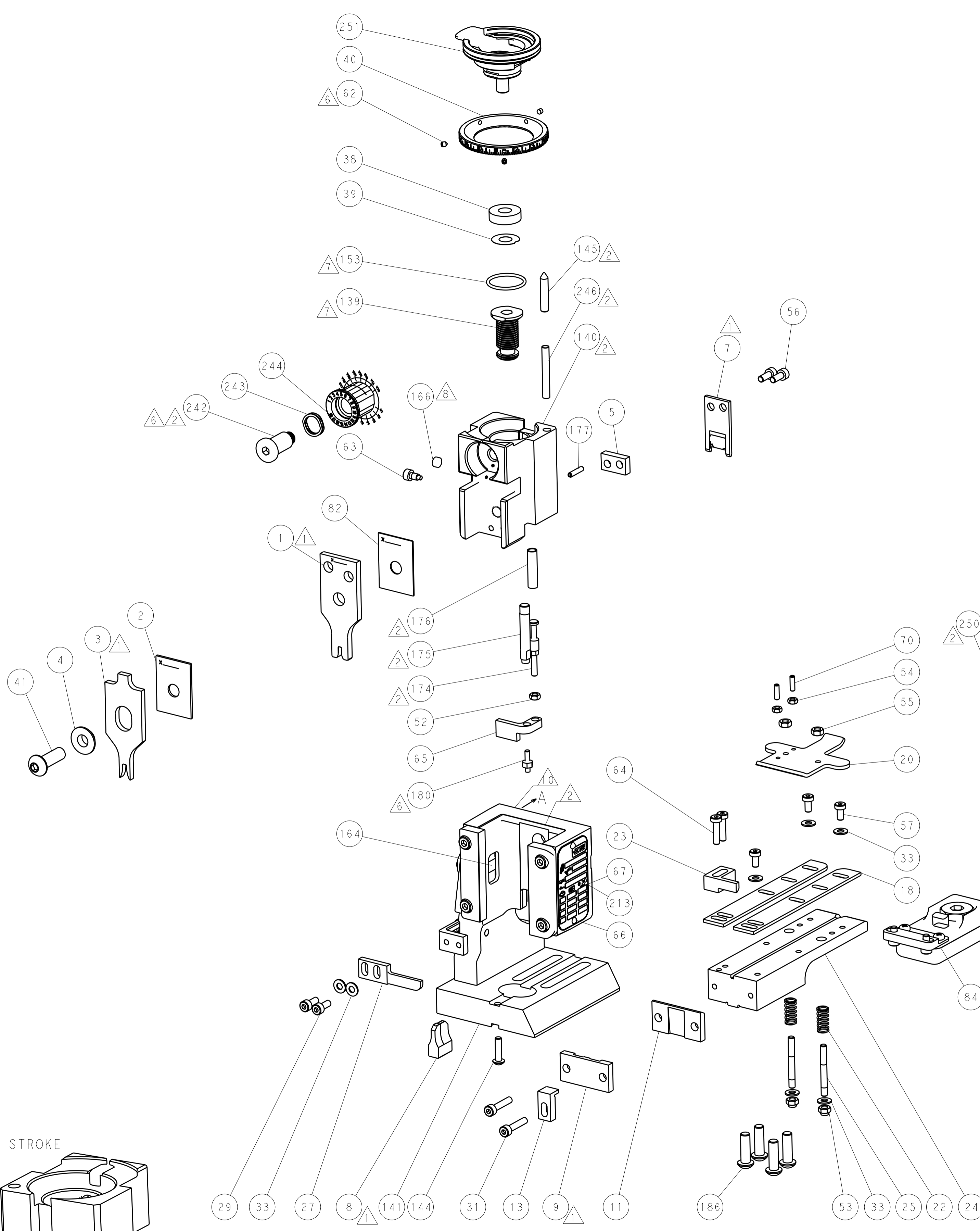
| | | | | | | | |
|-----------------|---------|-------------|---------|-----|-------------|-------------------------------------|-----|
| - | - | 2 | - | - | 2168400-7 | SHCS, LOW HEAD, RoHS, M5 X 10 | 240 |
| - | - | - | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | - | 1 | 2063440-1 | 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 |
| - | 1 | 1 | 1 | 1 | 1-1976055-2 | 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 |
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| -77-27-25-22-21 | PART NO | DESCRIPTION | ITEM NO | | | | |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DRAWN | | CHK | | APPV | | NAME | |
|-------------|---------|--|----------|---------|---------|----------|----------|--------|------------------------|-----------|-----------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | H. HUANG | L. ZHANG | U. GUO | 17JUL2015 | 17JUL2015 | TE Connectivity |
| | ANGLES | FINISH | MATERIAL | | | WEIGHT | | | SCALE | | |
| | | | | | | A1 00779 | | | 1:1 SHEET 3 OF 4 REV A | | |

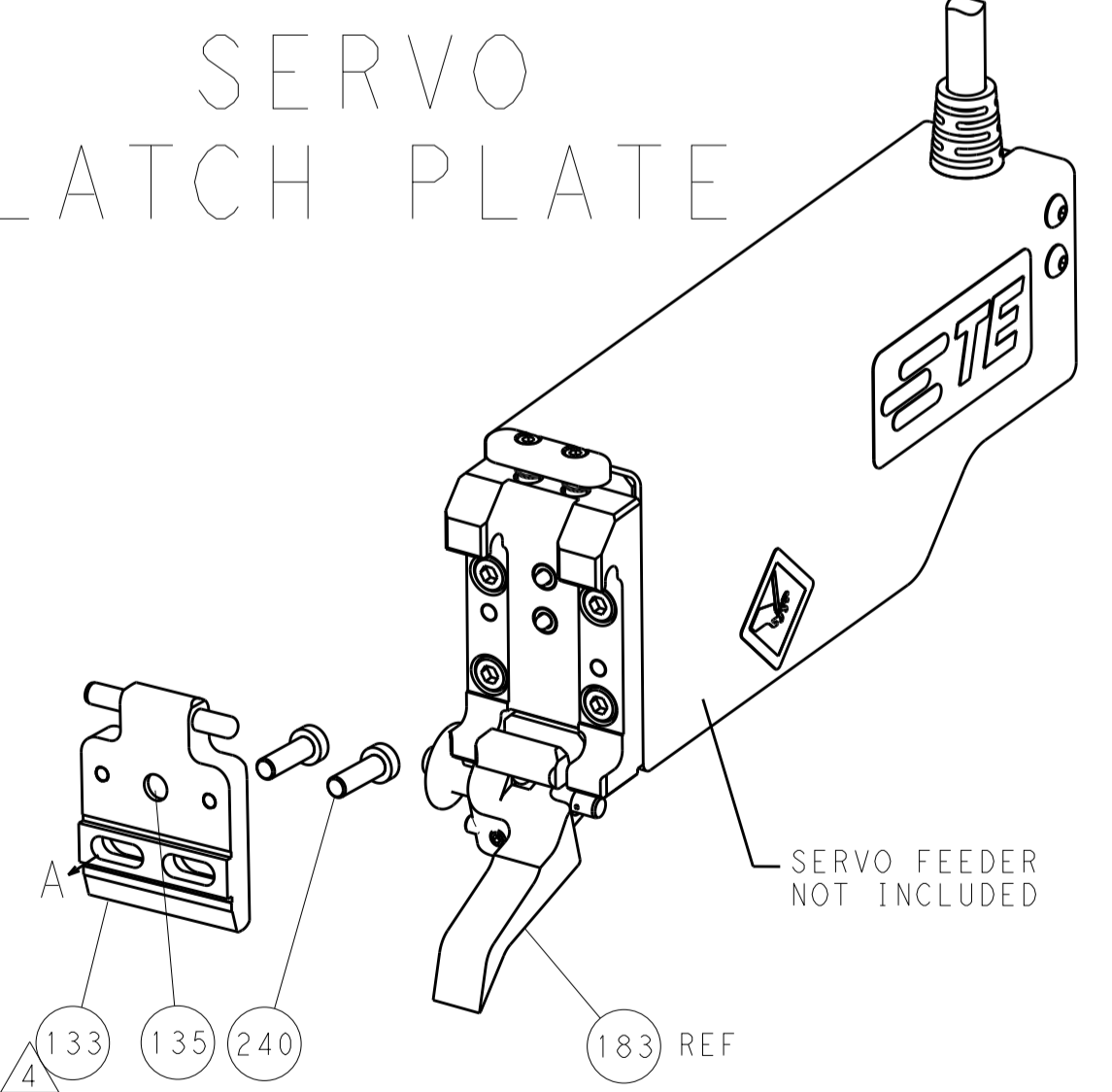
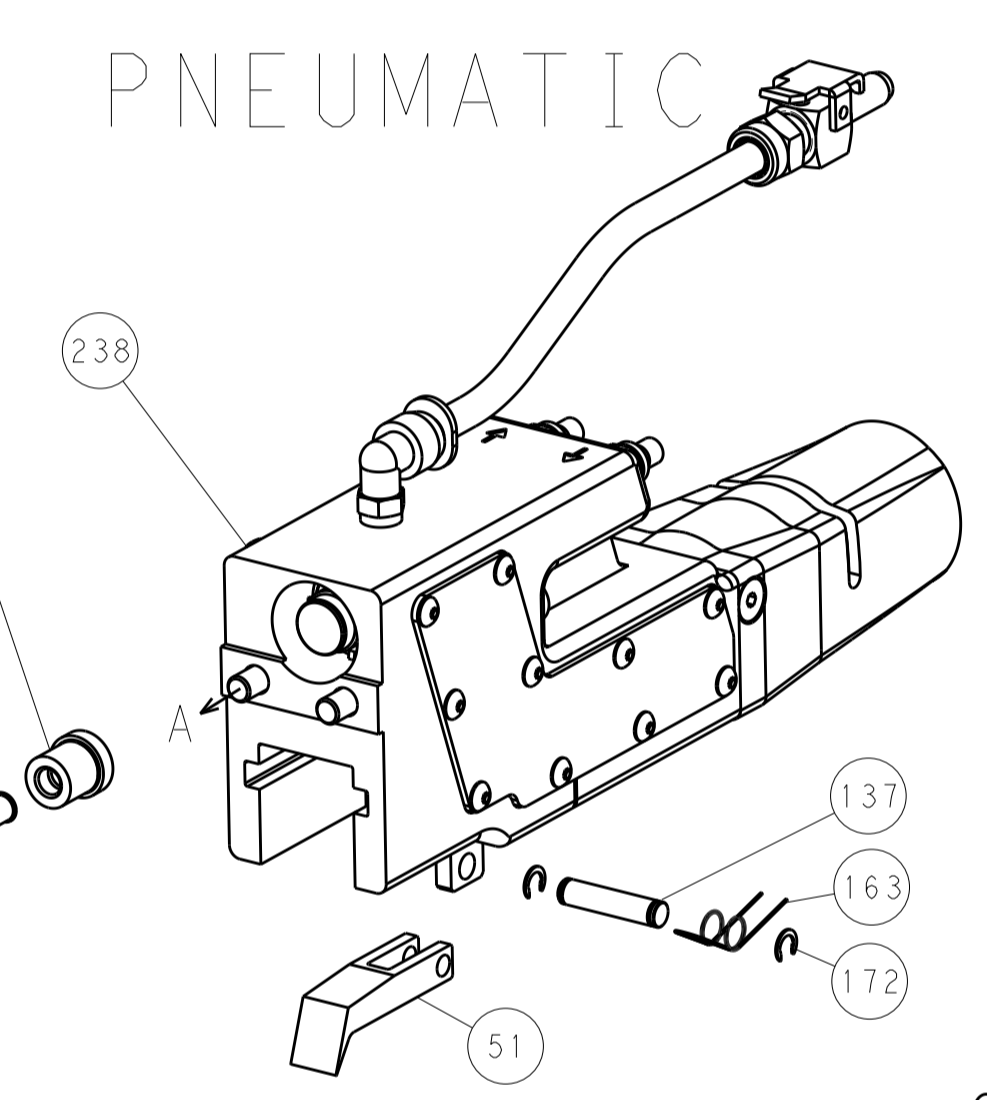
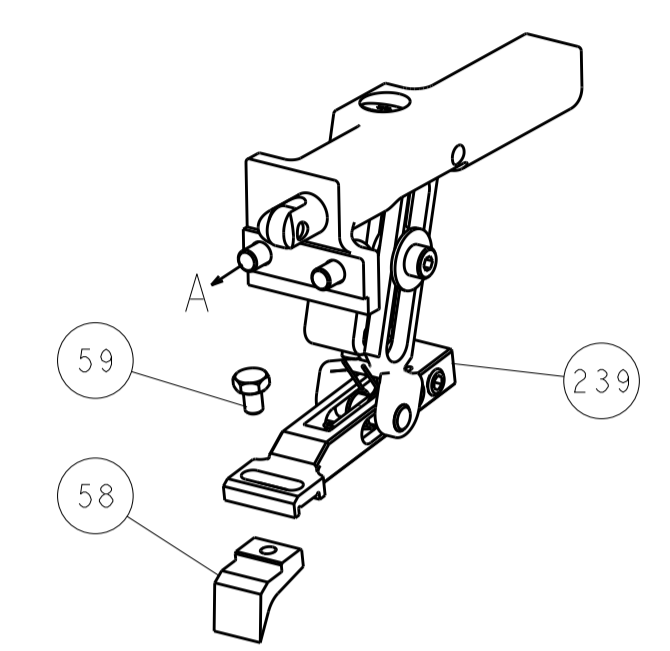
| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTM | DESCRIPTION | DATE | DWN | APVD |
| | | - | - | SEE SHEET 1 | - | - | - |



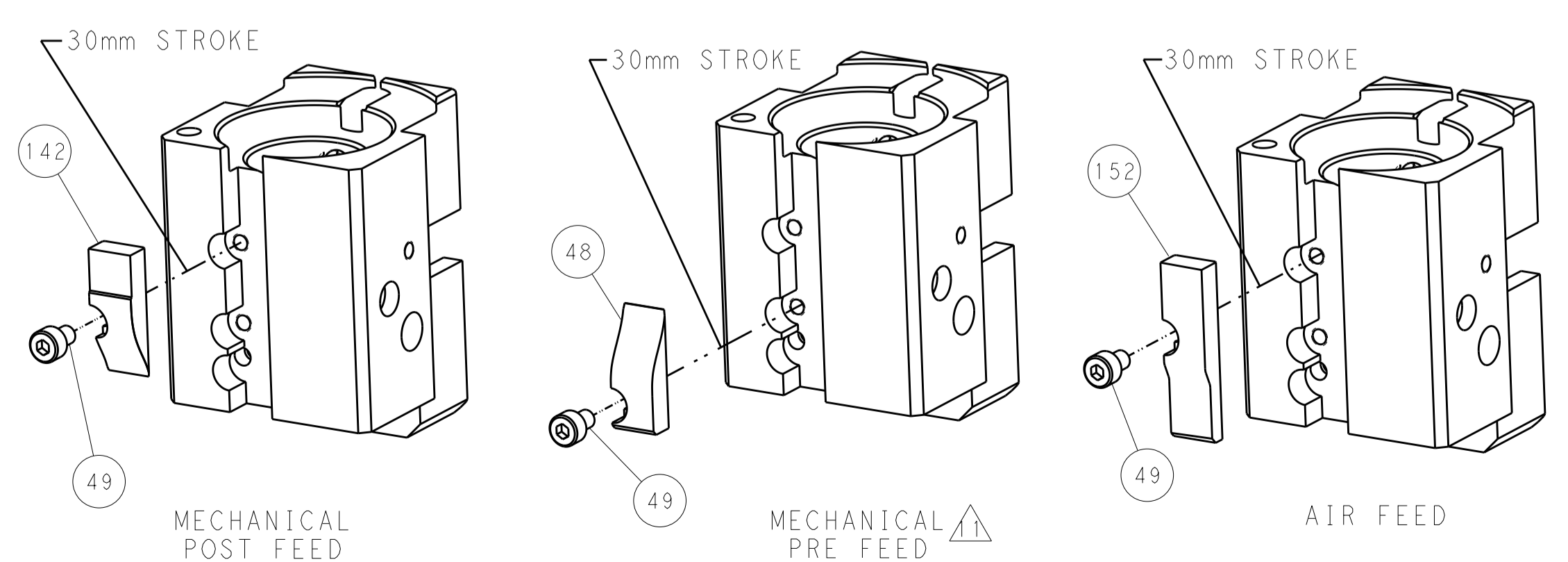
HOLDDOWN SET-UP



FEED TYPE
MECHANICAL



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: R. HUANG 17JUL2015 | | STE Connectivity Harrisburg, PA 17105-3608 | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | NAME: Ocean End Feed Applicator |
| MATERIAL: | FINISH: | WEIGHT: | APVD: L. ZHANG 17JUL2015 | APVD: H. GUO 17JUL2015 | PRODUCT SPEC: | APPLICATION SPEC: | SIZE: A1 00779 C=2150589 |
| Customer Accessible Production Drawing | | | | SCALE: 1:1 | SHEET: 4 | OF: 4 | REV: A |