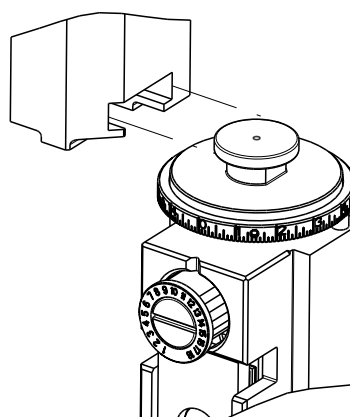


|                                                                                  |   |                                                       |          |                          |                                                                                                                                                                                       |                                   |                       |           |             |           |   |                        |
|----------------------------------------------------------------------------------|---|-------------------------------------------------------|----------|--------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| 8                                                                                |   | 7                                                     |          | 6                        |                                                                                                                                                                                       | 5                                 |                       | 4         |             | 3         |   |                        |
| THIS DRAWING IS UNPUBLISHED.                                                     |   | RELEASED FOR PUBLICATION                              |          | 20                       |                                                                                                                                                                                       |                                   |                       |           |             |           |   |                        |
| © COPYRIGHT 20                                                                   |   | BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. |          |                          |                                                                                                                                                                                       |                                   |                       |           |             |           |   |                        |
| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              |   | PART<br>NUMBER                                        | REVISION | DESCRIPTION              | FEED TYPE                                                                                                                                                                             | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |   |                        |
|                                                                                  |   |                                                       |          |                          |                                                                                                                                                                                       | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |   |                        |
|  |   | 2150828-1                                             | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                                                                                                                                                                            | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-1 | - | 2063440-1              |
|                                                                                  |   |                                                       |          |                          |                                                                                                                                                                                       | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150828-5 | -         | - | 2168400-7 (QUANTITY 2) |
|                                                                                  |   |                                                       |          |                          |                                                                                                                                                                                       | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150828-4 | -         | - | -                      |
|                                                                                  |   | 2150828-2                                             | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                                                                                                                                                                             | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-1 | - | -                      |
|                                                                                  |   |                                                       |          |                          |                                                                                                                                                                                       | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150828-5 | -         | - | 2168400-7 (QUANTITY 2) |
|                                                                                  |   |                                                       |          |                          |                                                                                                                                                                                       | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150828-4 | -         | - | -                      |
|                                                                                  |   | 2150828-5                                             | 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              |
|                                                                                  |   | 2150828-6                                             | A        | NON-CRIMP HEIGHT ADJUST  |  SERVO LATCH PLATE  | -                                 | -                     | -         | -           | -         | - | -                      |
|                                                                                  |   |                                                       |          |                          |                                                                                                                                                                                       | -                                 | -                     | -         | -           | -         | - | -                      |
| 2150828-7                                                                        | A | FINE CRIMP HEIGHT ADJUST                              | NONE     | -                        | -                                                                                                                                                                                     | -                                 | -                     | -         | -           | -         |   |                        |
| 7-2150828-7                                                                      | A | CRIMP TOOLING KIT                                     | -        | -                        | -                                                                                                                                                                                     | -                                 | -                     | -         | -           | -         |   |                        |

| APPLICATOR DATA                |                |                                                                                   |
|--------------------------------|----------------|-----------------------------------------------------------------------------------|
| CRIMP                          | SIZE           | TYPE                                                                              |
| WIRE                           | 2.79 mm [.110] | F                                                                                 |
| INSUL                          | 3.90 mm [.154] | OV                                                                                |
| APPL INSTRUCTIONS<br>408-10390 |                |  |

|                                                                               |                           |                                                           |                           |
|-------------------------------------------------------------------------------|---------------------------|-----------------------------------------------------------|---------------------------|
| TERMINAL DATA: GROTE & HARTMANN TERMINAL GROTE & HARTMANN CRIMP SPECIFICATION |                           |                                                           |                           |
| TERMINAL NAME: 6.3x0.8 RECEPTACLE TERMINAL                                    |                           |                                                           |                           |
| WIRE STRIP LENGTH<br>5.34-6.10 mm [.210-.240 IN]                              |                           | INSULATION DIAMETER RANGE<br>Ø2.20-3.00 mm [.087-.118 IN] |                           |
| TERMINAL APPLICATION SPECIFICATION                                            | E 80246 Rev 9             | -                                                         | -                         |
|                                                                               | -                         | -                                                         | -                         |
| TERMINALS APPLIED                                                             |                           |                                                           |                           |
| TE TERMINAL                                                                   | GROTE & HARTMANN TERMINAL | TE TERMINAL                                               | GROTE & HARTMANN TERMINAL |
| 1949278-1                                                                     | 25840.201.011             | 1949278-4                                                 | 25840.123.204             |
| 1949278-2                                                                     | 25840.201.004             | 1949278-5                                                 | 25840.417.031             |
| 1949278-3                                                                     | 25840.123.211             |                                                           |                           |

|                                                                                                                      |  |                           |  |                                                                                                                                                           |  |                           |  |
|----------------------------------------------------------------------------------------------------------------------|--|---------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------|--|
| TERMINAL DATA: GROTE & HARTMANN TERMINAL                                                                             |  |                           |  | GROTE & HARTMANN CRIMP SPECIFICATION                                                                                                                      |  |                           |  |
| TERMINAL NAME: 6.3x0.8 RECEPTACLE TERMINAL                                                                           |  |                           |  |                                                                                                                                                           |  |                           |  |
| WIRE STRIP LENGTH<br>5.34-6.10 mm [.210-.240 IN]                                                                     |  |                           |  |  INSULATION DIAMETER RANGE<br>$\varnothing 2.20-3.00$ mm [.087-.118 IN] |  |                           |  |
| TERMINAL APPLICATION  E 80246 Rev 9 |  |                           |  | -                                                                                                                                                         |  |                           |  |
| SPECIFICATION                                                                                                        |  |                           |  | -                                                                                                                                                         |  |                           |  |
| TERMINALS APPLIED                                                                                                    |  |                           |  |                                                                                                                                                           |  |                           |  |
| TE TERMINAL                                                                                                          |  | GROTE & HARTMANN TERMINAL |  | TE TERMINAL                                                                                                                                               |  | GROTE & HARTMANN TERMINAL |  |
| 1572845-1                                                                                                            |  | 25914.201.011             |  | 1572845-3                                                                                                                                                 |  | 25914.123.211             |  |
| 1572845-2                                                                                                            |  | 25914.201.004             |  | 1572845-4                                                                                                                                                 |  | 25914.123.204             |  |

| WIRE<br>SIZE           |  |  | CRIMP HEIGHT<br>mm [INCH] |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|---------------------------|-------------------------------------------------------------------------------------|-----------------------------------|
| 1.0+1.5mm <sup>2</sup> |                                                                                     |                                                                                     | 1.95+/-0.05 [0.77+/-0.02] |                                                                                     | 6.8                               |
| 2.50mm <sup>2</sup>    |                                                                                     |                                                                                     | 1.90+/-0.05 [0.75+/-0.02] |                                                                                     | 7.4                               |
| 2x 1.0mm <sup>2</sup>  |                                                                                     |                                                                                     | 1.80+/-0.05 [0.71+/-0.02] |                                                                                     | 8.5                               |
| 2x 0.75mm <sup>2</sup> |                                                                                     |                                                                                     | 1.65+/-0.05 [0.65+/-0.02] |                                                                                     | 10.1                              |
| 1.50mm <sup>2</sup>    |                                                                                     |                                                                                     | 1.65+/-0.05 [0.65+/-0.02] |                                                                                     | 10.1                              |

| WIRE<br>SIZE           |  | CRIMP HEIGHT<br>mm [INCH]  |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|------------------------|-------------------------------------------------------------------------------------|----------------------------|-------------------------------------------------------------------------------------|-----------------------------------|
| 1.0+1.5mm <sup>2</sup> |                                                                                     | 1.95+/-0.05 [0.77+/-0.002] |                                                                                     | 6.8                               |
| 2x 1.0mm <sup>2</sup>  |                                                                                     | 1.80+/-0.05 [0.71+/-0.002] |                                                                                     | 6.8                               |
| 1.50mm <sup>2</sup>    |                                                                                     | 1.65+/-0.05 [0.65+/-0.002] |                                                                                     | 10.1                              |

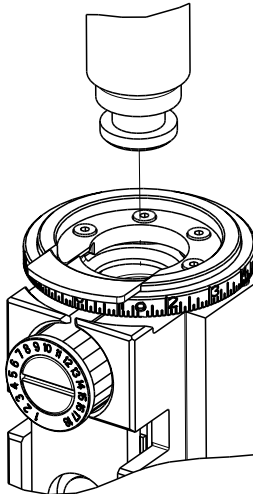
\*WARNING  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO  
LARGEST WIRE SIZE SETTING. USE OF SETTINGS  
BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING  
WILL CAUSE DAMAGE TO CRIMP TOOLING.

|                                                                                       |     |    |    |    |    |    |           |                                 |         |
|---------------------------------------------------------------------------------------|-----|----|----|----|----|----|-----------|---------------------------------|---------|
|  | -   | -  | 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  | -  | 1803259-1 | BUSHING, FLANGED                | 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     |
|                                                                                       | -77 | -7 | -6 | -5 | -2 | -1 | PART NO   | DESCRIPTION                     | ITEM NO |

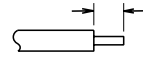
| SET UP GAUGE<br>2119599-2 |     |     | LOC<br>A | DIST<br>66  | REVISIONS |                                      |            |     |      |
|---------------------------|-----|-----|----------|-------------|-----------|--------------------------------------|------------|-----|------|
|                           |     |     |          | P           | LTR       | DESCRIPTION                          | DATE       | DRN | APVD |
|                           |     |     |          |             | A         | RELEASED                             | 14SEPT2017 | JH  | TE   |
|                           |     |     |          |             |           |                                      |            |     |      |
|                           |     |     |          |             |           |                                      |            |     |      |
| -                         | -   | -   |          | 2119759-1   |           | RAM, AMP STYLE, END FEED, NON-ADJUST |            |     | 245  |
| 1                         | 1   | 1   |          | 2119082-7   |           | CAM, SNAIL, INSULATION ADJUSTMENT    |            |     | 244  |
| 1                         | 1   | 1   |          | 2079764-1   |           | WASHER, WAVE SPRING, CREST-TO-CREST  |            |     | 243  |
| 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  |
| REF                       | -   | -   |          | 1901697-1   |           | FEED FINGER ASSEMBLY,EF              |            |     | 183  |
| 1                         | 1   | 1   |          | 1-1976055-2 |           | STANDOFF, HOLD-DOWN                  |            |     | 180  |
| 1                         | 1   | 1   |          | 6-9931111-6 |           | PIN, SLOTTED SPRING 3.0 X 14.0       |            |     | 177  |
| 1                         | 1   | 1   |          | 8-22280-7   |           | SPRING, COMPRESSION                  |            |     | 176  |
| 1                         | 1   | 1   |          | 1752353-2   |           | GUIDE PIN,HOLDDOWN                   |            |     | 175  |
| 1                         | 1   | 1   |          | 1901680-2   |           | GUIDE PIN,HOLDDOWN                   |            |     | 174  |
| -                         | 2   | -   |          | 21045-3     |           | RING, RETAIN, EXTERN, 3/16 CRESCENT  |            |     | 172  |
| 1                         | 1   | 1   |          | 994969-1    |           | MAGNET, RARE EARTH HIGH ENERGY       |            |     | 166  |
| REF                       | REF | REF |          | 994970-2    |           | COUNTER, MAGNETIC                    |            |     | 164  |
| -                         | 1   | -   |          | 240638-1    |           | SPRING, FEED FINGER                  |            |     | 163  |
| -                         | 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   |          | 455888-6    |           | SPACER, CRIMPER                      |            |     | 82   |
| 1                         | 1   | 1   |          | 2119956-2   |           | DOCUMENTATION PACKAGE                |            |     | 71   |
| 2                         | 2   | 2   |          | 2-18032-2   |           | SCR, SET, FLT PNT, M3 X 10.0         |            |     | 70   |
| -                         | 1   | 1   |          | 2119740-1   |           | TAG,IDENTIFICATION                   |            |     | 67   |
| 2                         | 2   | 2   |          | 2168078-1   |           | SCREW, DRIVE, RH, RoHS, 2 x .188     |            |     | 66   |
| 1                         | 1   | 1   |          | 1901681-1   |           | HOLDDOWN, TERMINAL                   |            |     | 65   |
| 2                         | 2   | 2   |          | 2168400-8   |           | SHCS, LOW HEAD, RoHS, M4 X 16        |            |     | 64   |
| 1                         | 1   | 1   |          | 2119793-1   |           | LIMITER, ADJUSTMENT BOLT             |            |     | 63   |
| 3                         | 3   | 3   |          | 992763-5    |           | SCR, SET, SOC, CONE PNT, M3 x 4.0    |            |     | 62   |
| 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   |          | 2168400-4   |           | SHCS, LOW HEAD, RoHS, M4 X 8         |            |     | 57   |
| 2                         | 2   | 2   |          | 1-2168083-0 |           | SCR, SKT HD CAP, RoHS, M4 X 10       |            |     | 56   |
| 2                         | 2   | 2   |          | 5018030-1   |           | NUT, HEX, REG, RoHS, M3              |            |     | 54   |
| 2                         | 2   | 2   |          | 986965-8    |           | NUT, LOCK, HEX, TORQUE (M4)          |            |     | 53   |
| 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   |          | 2119655-5   |           | APPLICATOR BASIC ASSEMBLY, EF        |            |     | 46   |
| 1                         | 1   | 1   |          | 2119369-1   |           | RAM, AMP STYLE, END FEED             |            |     | 44   |
| 1                         | 1   | 1   |          | 2079383-7   |           | SCR, BHSC, RoHS (M8 X 25)            |            |     | 41   |
| 1                         | 1   | 1   |          | 2119645-1   |           | DISC, NUMBERED FA WIRE ADJUSTMENT    |            |     | 40   |
| 1                         | 1   | 1   |          | 2119957-1   |           | APPLICATOR SHIM PACK                 |            |     | 39   |
| 1                         | 1   | 1   |          | 1-2119644-2 |           | RAM WASHER, PRECISION                |            |     | 38   |
| 1                         | 1   | 1   |          | 2119085-1   |           | FA HEAD, ATLANTIC STYLE              |            |     | 37   |
| 1                         | 1   | 1   |          | 2119092-1   |           | BOLT, ADJUSTMENT                     |            |     | 35   |
| 7                         | 7   | 7   |          | 1-18028-2   |           | WASHER, FLAT, REG M4                 |            |     | 33   |

|                                                                                                       |  |                                        |  |                              |  |
|-------------------------------------------------------------------------------------------------------|--|----------------------------------------|--|------------------------------|--|
| DRAWING IS CONTROLLED DOCUMENT - NO REVISIONS TO BE MADE WITHOUT THE AUTHORITY OF THE DESIGN ENGINEER |  | DWN 15AUG2017                          |  | TE Connectivity              |  |
| THIS DRAWING IS THE PROPERTY OF TE CONNECTIVITY. IT IS TO BE USED FOR THE DESIGN OF THE PRODUCT ONLY. |  | E. ZHANG 15AUG2017                     |  | Harrisburg, PA 17105-3608    |  |
| DIMENSIONS:                                                                                           |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | NAME                         |  |
| mm                                                                                                    |  | 0 PLC ±.001                            |  | Ocean End Feed               |  |
|                  |  | 1 PLC ±.001                            |  | Applicator                   |  |
|                                                                                                       |  | 2 PLC ±.001                            |  | -                            |  |
|                                                                                                       |  | 3 PLC ±.001                            |  | SIZE                         |  |
|                                                                                                       |  | 4 PLC ±.001                            |  | CAGE CODE                    |  |
| MATERIAL                                                                                              |  | ANGLES                                 |  | DRAWING NO                   |  |
| -                                                                                                     |  | FINISH                                 |  | A   00779 C=2150828          |  |
|                                                                                                       |  | WEIGHT                                 |  | RESTRICTED TO                |  |
|                                                                                                       |  | -                                      |  | -                            |  |
| Customer Accessible Production Drawing                                                                |  |                                        |  | SCALE 1:1 SHEET 1 of 4 REV A |  |



| <div><div>PACIFIC VERSION<br/>TERMINATOR<br/>INTERFACE ADAPTER</div><div></div></div> | PART<br>NUMBER | REVISION          | DESCRIPTION              | FEED TYPE                         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |   |                        |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|-------------------|--------------------------|-----------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
|                                                                                                                                                                       |                |                   |                          |                                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |   |                        |
|                                                                                                                                                                       |                |                   |                          |                                   |                                   |                       |           |             |           |   |                        |
|                                                                                                                                                                       | 2-2150828-1    | A                 | FINE CRIMP HEIGHT ADJUST | MECHANICAL                        | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-2 | - | 2063440-1              |
|                                                                                                                                                                       |                |                   |                          |                                   | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150828-5 | -         | - | 2168400-7 (QUANTITY 2) |
|                                                                                                                                                                       |                |                   |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150828-4 | -         | - | -                      |
|                                                                                                                                                                       | 2-2150828-2    | A                 | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                         | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-2 | - | -                      |
|                                                                                                                                                                       |                |                   |                          |                                   | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150828-5 | -         | - | 2168400-7 (QUANTITY 2) |
|                                                                                                                                                                       |                |                   |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150828-4 | -         | - | -                      |
|                                                                                                                                                                       | 2-2150828-5    | A                 | FINE CRIMP HEIGHT ADJUST | SERVO<br>LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-2 | - | -                      |
|                                                                                                                                                                       |                |                   |                          |                                   | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-2 | - | 2063440-1              |
|                                                                                                                                                                       |                |                   |                          |                                   | -                                 | -                     | -         | -           | -         | - | -                      |
|                                                                                                                                                                       | 2-2150828-7    | A                 | FINE CRIMP HEIGHT ADJUST | NONE                              | -                                 | -                     | -         | -           | -         | - | -                      |
| 7-2150828-7                                                                                                                                                           | A              | CRIMP TOOLING KIT | -                        | -                                 | -                                 | -                     | -         | -           | -         | - |                        |

| APPLICATOR DATA                |                |                                                                                   |
|--------------------------------|----------------|-----------------------------------------------------------------------------------|
| CRIMP                          | SIZE           | TYPE                                                                              |
| WIRE                           | 2.79 mm [.110] | F                                                                                 |
| INSUL                          | 3.90 mm [.154] | OV                                                                                |
| APPL INSTRUCTIONS<br>408-10390 |                |  |

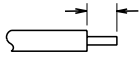
|                                                                               |                                                                                   |                                                           |                           |
|-------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------|---------------------------|
| TERMINAL DATA: GROTE & HARTMANN TERMINAL GROTE & HARTMANN CRIMP SPECIFICATION |                                                                                   |                                                           |                           |
| TERMINAL NAME: 6.3x0.8 RECEPTACLE TERMINAL                                    |                                                                                   |                                                           |                           |
| WIRE STRIP LENGTH<br>5.34-6.10 mm [.210-.240 IN]                              |  | INSULATION DIAMETER RANGE<br>Ø2.20-3.00 mm [.087-.118 IN] |                           |
| TERMINAL APPLICATION SPECIFICATION<br>E 80246 Rev 9                           | -                                                                                 | -                                                         | -                         |
| TERMINALS APPLIED                                                             |                                                                                   |                                                           |                           |
| TE TERMINAL                                                                   | GROTE & HARTMANN TERMINAL                                                         | TE TERMINAL                                               | GROTE & HARTMANN TERMINAL |
| 1949278-1                                                                     | 25840.201.011                                                                     | 1949278-4                                                 | 25840.123.204             |
| 1949278-2                                                                     | 25840.201.004                                                                     | 1949278-5                                                 | 25840.417.031             |
| 1949278-3                                                                     | 25840.123.211                                                                     |                                                           |                           |

| WIRE SIZE              |  |  | CRIMP HEIGHT<br>mm [INCH]  |  | CRIMP HEIGHT<br>REFERENCE SETTING <sup>9</sup> |
|------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|----------------------------|-------------------------------------------------------------------------------------|------------------------------------------------|
| 1.0+1.5mm <sup>2</sup> |                                                                                     |                                                                                     | 1.95+/-0.05 [.077+/- .002] |                                                                                     | 6.8                                            |
| 2.50mm2                |                                                                                     |                                                                                     | 1.90+/-0.05 [.075+/- .002] |                                                                                     | 7.4                                            |
| 2x 1.0mm <sup>2</sup>  |                                                                                     |                                                                                     | 1.80+/-0.05 [.071+/- .002] |                                                                                     | 8.5                                            |
| 2x 0.75mm <sup>2</sup> |                                                                                     |                                                                                     | 1.65+/-0.05 [.065+/- .002] |                                                                                     | 10.1                                           |
| 1.50mm2                |                                                                                     |                                                                                     | 1.65+/-0.05 [.065+/- .002] |                                                                                     | 10.1                                           |



- RECOMMENDED SPARE PARTS

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: 8-2150828-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150828-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150828-5
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.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
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.

|                                                                               |                                                                                    |                                                           |                           |
|-------------------------------------------------------------------------------|------------------------------------------------------------------------------------|-----------------------------------------------------------|---------------------------|
| TERMINAL DATA: GROTE & HARTMANN TERMINAL GROTE & HARTMANN CRIMP SPECIFICATION |                                                                                    |                                                           |                           |
| TERMINAL NAME: 6.3x0.8 RECEPTACLE TERMINAL                                    |                                                                                    |                                                           |                           |
| WIRE STRIP LENGTH<br>5.34-6.10 mm [.210-.240 IN]                              |  | INSULATION DIAMETER RANGE<br>Ø2.20-3.00 mm [.087-.118 IN] |                           |
| TERMINAL APPLICATION SPECIFICATION<br>E 80246 Rev 9                           | -                                                                                  | -                                                         | -                         |
| TERMINALS APPLIED                                                             |                                                                                    |                                                           |                           |
| TE TERMINAL                                                                   | GROTE & HARTMANN TERMINAL                                                          | TE TERMINAL                                               | GROTE & HARTMANN TERMINAL |
| 1572845-1                                                                     | 25914.201.011                                                                      | 1572845-3                                                 | 25914.123.211             |
| 1572845-2                                                                     | 25914.201.004                                                                      | 1572845-4                                                 | 25914.123.204             |

| WIRE SIZE              |  |  | CRIMP HEIGHT<br>mm [INCH]  |  | CRIMP HEIGHT<br>REFERENCE SETTING <sup>9</sup> |
|------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|----------------------------|---------------------------------------------------------------------------------------|------------------------------------------------|
| 1.0+1.5mm <sup>2</sup> |                                                                                     |                                                                                     | 1.95+/-0.05 [.077+/- .002] |                                                                                       | 6.8                                            |
| 2x 1.0mm <sup>2</sup>  |                                                                                     |                                                                                     | 1.80+/-0.05 [.071+/- .002] |                                                                                       | 6.8                                            |
| 1.50mm2                |                                                                                     |                                                                                     | 1.65+/-0.05 [.065+/- .002] |                                                                                       | 10.1                                           |

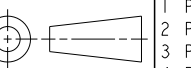
\*WARNING  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|                 |   |   |   |   |           |                                     |         |
|-----------------|---|---|---|---|-----------|-------------------------------------|---------|
| -               | 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<br>2119599-2 |  | LOC<br>A | DIST<br>66 | P | LYR | REVISIONS   |  | DATE | OWN | APVD |
|                           |  |          |            | - |     | 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     |
| 6 | -               | -   | REF | -   | -   | 1901697-1   | FEED FINGER ASSEMBLY,EF             | 183     |
|   | -               | 1   | 1   | 1   | 1   | 1-1976055-2 | STANDOFF, HOLD-DOWN                 | 180     |
|   | -               | 1   | 1   | 1   | 1   | 6-9931111-6 | 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     |
|   | -               | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164     |
|   | -               | -   | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163     |
|   | -               | 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   | 2119798-2   | DETENT PIN                          | 145     |
|   | -               | 1   | 1   | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144     |
| A | -               | -   | -   | -   | 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     |
|   | -               | 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     |
| 6 | -               | 1   | 1   | 1   | 1   | 455888-6    | 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   | 1901681-1   | HOLDDOWN, TERMINAL                  | 65      |
|   | -               | 2   | 2   | 2   | 2   | 2168400-8   | SHCS, LOW HEAD, RoHS, M4 X 16       | 64      |
| 6 | -               | 1   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
|   | -               | 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      |
|   | -               | 3   | 3   | 3   | 3   | 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      |
| A | -               | 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   | -   | 2119792-2   | 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   | 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   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
|   | -               | 1   | 1   | 1   | 1   | 1-2119644-2 | RAM WASHER, PRECISION               | 38      |
|   | -               | 7   | 7   | 7   | 7   | 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   | 1   | 1752371-3   | PLATE, STRIP GUIDE                  | 24      |
|   | -               | 1   | 1   | 1   | 1   | 240825-3    | PLATE, STRIP HOLD DOWN              | 23      |
|   | -               | 2   | 2   | 2   | 2   | 2-22281-3   | SPRING, COMPRESSION                 | 22      |
|   | -               | 1   | 1   | 1   | 1   | 1803292-4   | DRAG                                | 20      |
|   | -               | 2   | 2   | 2   | 2   | 1901259-6   | GUIDE, LOWER STRIP                  | 18      |
|   | -               | 1   | 1   | 1   | 1   | 1752360-1   | SPACER,HOLD-DOWN                    | 13      |
|   | -               | 1   | 1   | 1   | 1   | 240833-4    | PLATE, REAR SHEAR                   | 11      |
| 1 | -               | -   | -   | -   | -   | -           | -                                   | 10      |
|   | -               | 1   | 1   | 1   | 1   | 690482-3    | PLATE, FRONT SHEAR                  | 9       |
|   | 1               | 1   | 1   | 1   | 1   | 3-1803257-5 | ANVIL, COMBINATION, END FEED        | 8       |
|   | -               | 1   | 1   | 1   | 1   | 1-2217206-3 | BLADE, SLUG                         | 7       |
|   | -               | -   | -   | -   | -   | -           | -                                   | 6       |
|   | -               | 1   | 1   | 1   | 1   | 3-240641-5  | SPACER                              | 5       |
|   | -               | 1   | 1   | 1   | 1   | 4-238009-0  | BLOCK, FL CRIMPER SPACER            | 4       |
| A | 1               | 1   | 1   | 1   | 1   | 1803221-3   | CRIMPER, INSULATION OVERLAP PREMIUM | 3       |
|   | -               | 1   | 1   | 1   | 1   | 1-455888-3  | SPACER, CRIMPER                     | 2       |
|   | 1               | 1   | 1   | 1   | 1   | 3-456408-0  | CRIMPER, WIRE PREMIUM               | 1       |
|   | -77-27-25-22-21 |     |     |     |     | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                                                              |  |  |  |                                           |  |                                                  |  |                                                                        |  |             |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|-------------------------------------------|--|--------------------------------------------------|--|------------------------------------------------------------------------|--|-------------|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO MODIFICATION WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO CONTACT THE ENGINEERING DEPARTMENT FOR THE LATEST REVISION. |  |  |  | OWN<br>F. ZHANG<br>15AUG2017              |  | STE TE Connectivity<br>Harrisburg, PA 17105-3608 |  |                                                                        |  |             |  |
| DIMENSIONS:<br>mm                                                                                                                                                                            |  |  |  | TO TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | CHK<br>K. ZHANG<br>15AUG2017                     |  | NAME<br>Ocean End Feed<br>Applicator                                   |  |             |  |
|                                                                                                         |  |  |  | APVD<br>K. ZHANG<br>15AUG2017             |  | PRODUCT SPEC<br>-                                |  | SIZE<br>CAGE CODE<br>DRAWING NO<br>RESTRICTED TO<br>A1 00779 ©=2150828 |  |             |  |
|                                                                                                                                                                                              |  |  |  | APPLICATION SPEC<br>-                     |  |                                                  |  |                                                                        |  |             |  |
|                                                                                                                                                                                              |  |  |  | MATERIAL<br>-                             |  |                                                  |  | FINISH<br>-                                                            |  | WEIGHT<br>- |  |
|                                                                                                                                                                                              |  |  |  |                                           |  | SCALE<br>1:1                                     |  | SHEET<br>3 OF 4                                                        |  | REV<br>A    |  |

