

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE         | CONVERT TO        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|---|-------------|--------------------------|--------------------------|-------------------|-------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   | 2150457-1   | A                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED    | 2119950-1             | 2119792-2 | -           | 2119641-1 | -         | 2063440-1              |
|   | 2150457-2   | A                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | SERVO LATCH PLATE | 2119951-1             | 1901697-1 | 8-2150457-5 | -         | -         | 2168400-7 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2150457-4 | -         | -         | -                      |
|   |             |                          |                          |                   | MECHANICAL FEED   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-1 | -         | -                      |
|   | 2150457-5   | A                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1             | 1901697-1 | 8-2150457-5 | -         | -         | 2168400-7 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2150457-4 | -         | -         | -                      |
|   | 2150457-6   | A                        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | MECHANICAL FEED   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-1 | -         | -                      |
| 2150457-7                                     | A           | FINE CRIMP HEIGHT ADJUST | NONE                     | PNEUMATIC FEED    | 2119950-1         | 2119792-2             | -         | 2119641-1   | -         | 2063440-1 |                        |
| 7-2150457-7                                   | A           | CRIMP TOOLING KIT        | -                        | -                 | -                 | -                     | -         | -           | -         | -         |                        |

| APPLICATOR DATA                   |                |      |
|-----------------------------------|----------------|------|
| CRIMP                             | SIZE           | TYPE |
| WIRE                              | 2.03 mm [.080] | F    |
| INSUL                             | 3.56 mm [.140] | F    |
| APPLICATOR INSTRUCTIONS 408-10390 |                |      |

| TERMINAL DATA: TE TERMINAL                             |             | TE CRIMP SPECIFICATION        |             |
|--|-------------|-------------------------------|-------------|
| TERMINAL NAME: .110 SERIES MINIATURE FASTON RECEPTACLE |             |                               |             |
| WIRE STRIP LENGTH                                      |             | INSULATION DIAMETER RANGE     |             |
| 3.20-4.00 mm [.126-.157 IN]                            |             | Ø 1.50-2.80 mm [.059-.110 IN] |             |
| TERMINAL APPLICATION SPECIFICATION                     | 114-20109   | -                             | -           |
| TERMINALS APPLIED                                      |             |                               |             |
| TE TERMINAL  | TE TERMINAL | TE TERMINAL                   | TE TERMINAL |
| 180423-1   | 1-180423-1  | 180437-2                      |             |
| 180423-2   | 180437-1    | 280429-2                      |             |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 1.50mm2   | 1.40 +/- 0.05 [.055 +/- .002] | 7.1                            |
| 1.00mm2   | 1.32 +/- 0.05 [.052 +/- .002] | 8.0                            |
| 0.75mm2   | 1.27 +/- 0.05 [.050 +/- .002] | 8.6                            |
| 0.50mm2   | 1.22 +/- 0.05 [.048 +/- .002] | 9.1                            |

- 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: 8-2150457-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150457-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150457-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150457-6
- 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 ITEM 62. 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 ITEM 37.
- 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     |

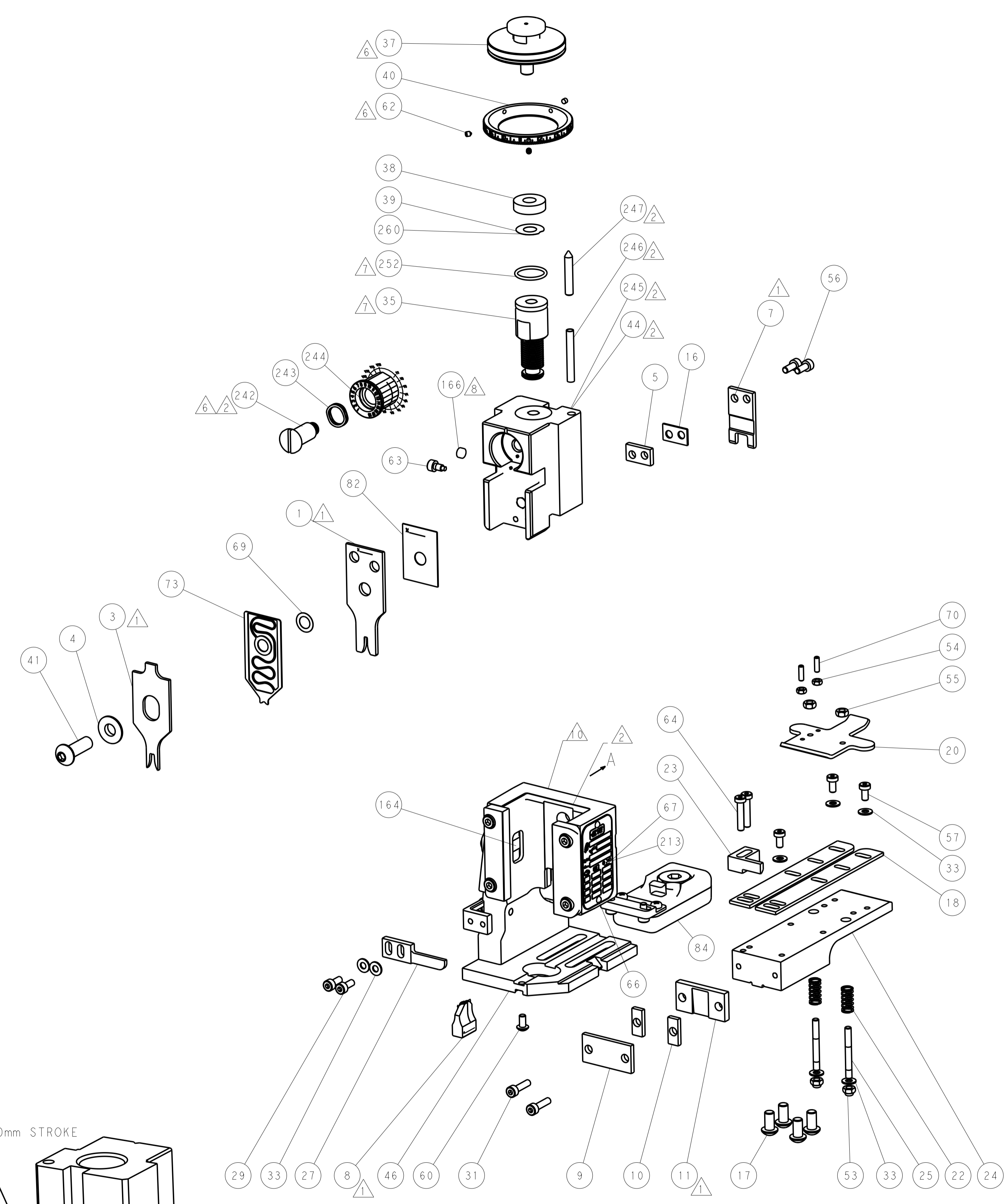
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS |           |    |      |
|--------------|-----|------|-----------|-----------|----|------|
| 2119599-2    | A   | 66   | REV       | DATE      | BY | APPV |
|              |     |      | A         | 09JUL2014 | BW | TE   |

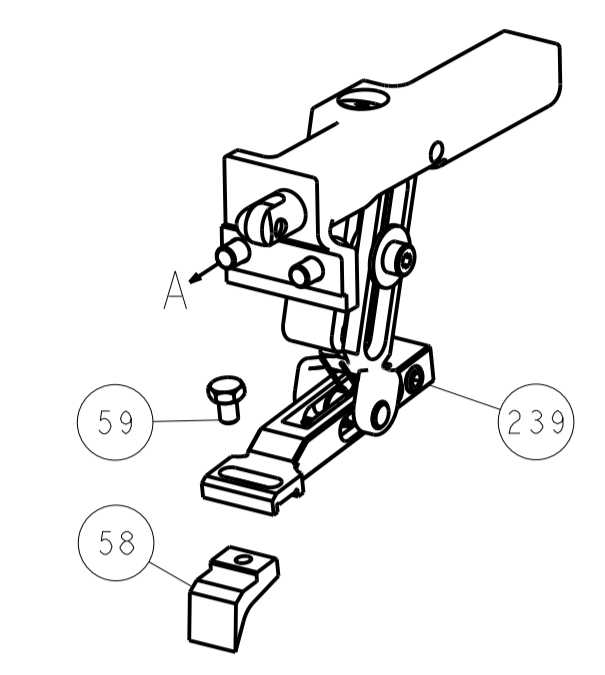
| REV | DATE   | BY     | APPV   | DESCRIPTION | DATE   | BY          | APPV                                 |     |
|-----|--------|--------|--------|-------------|--------|-------------|--------------------------------------|-----|
| -   | -      | -      | -      | 1           | -      | 2119641-1   | 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 |
| -   | 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 |
| -   | -      | -      | -      | 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      | 455888-4    | 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           | 1      | 2119943-1   | WASHER, SPACER                       | 69  |
| -   | 1      | -      | -      | 1           | 1      | 2119740-1   | TAG, IDENTIFICATION                  | 67  |
| -   | 2      | 2      | 2      | 2           | 2      | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188     | 66  |
| -   | 2      | 2      | 2      | 2           | 2      | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20        | 64  |
| -   | 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           | -      | 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      | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16       | 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      | 1752371-5   | PLATE, STRIP GUIDE                   | 24  |
| -   | 1      | 1      | 1      | 1           | 1      | 240825-4    | 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      | 5-240641-9  | SPACER                               | 16  |
| -   | 1      | 1      | 1      | 1           | 1      | 240644-1    | PLATE, REAR SHEAR                    | 11  |
| -   | 2      | 2      | 2      | 2           | 2      | 1-240645-4  | SPACER, SHEAR PLATE                  | 10  |
| -   | 1      | 1      | 1      | 1           | 1      | 240642-1    | PLATE, FRONT SHEAR                   | 9   |
| 1   | 1      | 1      | 1      | 1           | 1      | 1333216-2   | ANVIL, COMBINATION                   | 8   |
| 1   | 1      | 1      | 1      | 1           | 1      | 1-240651-8  | BLADE, SLUG                          | 7   |
| -   | -      | -      | -      | -           | -      | -           | -                                    | 6   |
| -   | 1      | 1      | 1      | 1           | 1      | 3-240641-0  | SPACER                               | 5   |
| -   | 1      | 1      | 1      | 1           | 1      | 2-238009-3  | BLOCK, FL CRIMPER SPACER             | 4   |
| 1   | 1      | 1      | 1      | 1           | 1      | 2-2119582-4 | CRIMPER, INSULATION F PREMIUM        | 3   |
| -   | -      | -      | -      | -           | -      | -           | -                                    | 2   |
| 1   | 1      | 1      | 1      | 1           | 1      | 1-456405-2  | CRIMPER, WIRE PREMIUM                | 1   |

| DIMENSIONS: |           | TOLERANCES UNLESS OTHERWISE SPECIFIED: |            | DATE                                   |              | NAME                          |        |
|-------------|-----------|--|------------|--|--------------|-------------------------------|--------|
| mm          | 0 PLC ±.5 | 1 PLC ±.3                              | 2 PLC ±.13 | 3 PLC ±.013                            | 4 PLC ±.0001 | ANGLES                        | FINISH |
| MATERIAL:   |           |  |            | WEIGHT:                                |              | SCALE:                        |        |
| FINISH:     |           |  |            | CUSTOMER ACCESSIBLE PRODUCTION DRAWING |              | SCALE: 1:1 SHEET 1 OF 4 REV A |        |

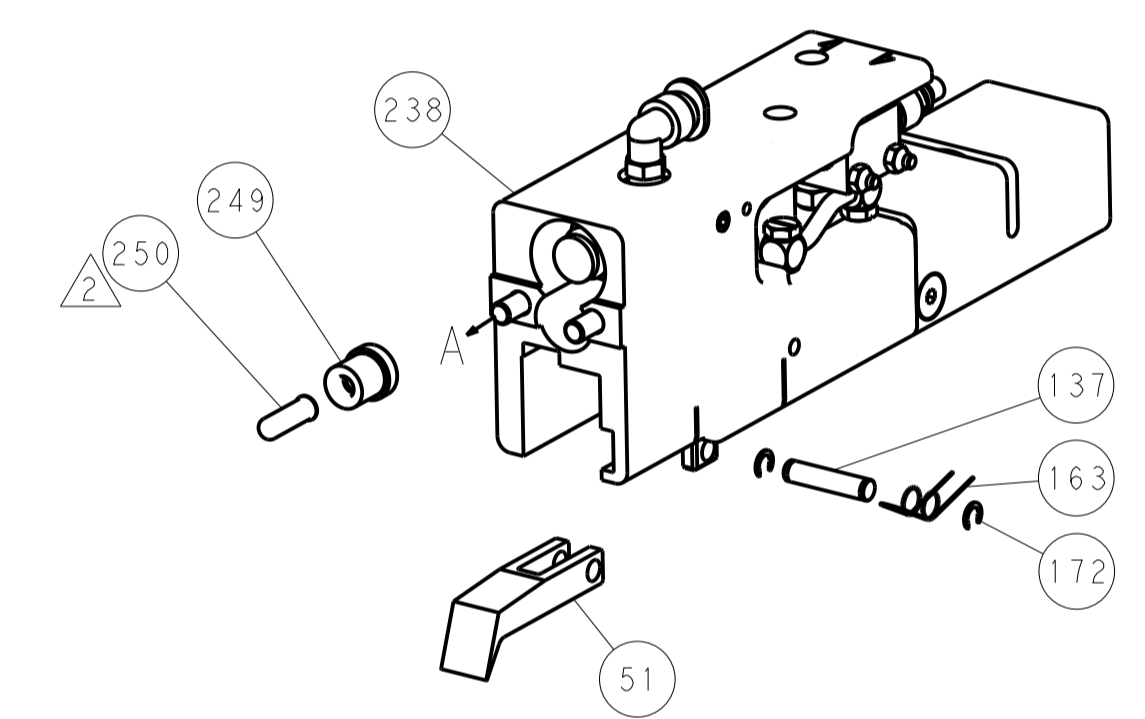
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|-----|------|-----|------|----|-----|------|-------------|------|----|-----|------|
| A   | 66   |     |      |    |     |      | SEE SHEET 1 |      |    |     |      |



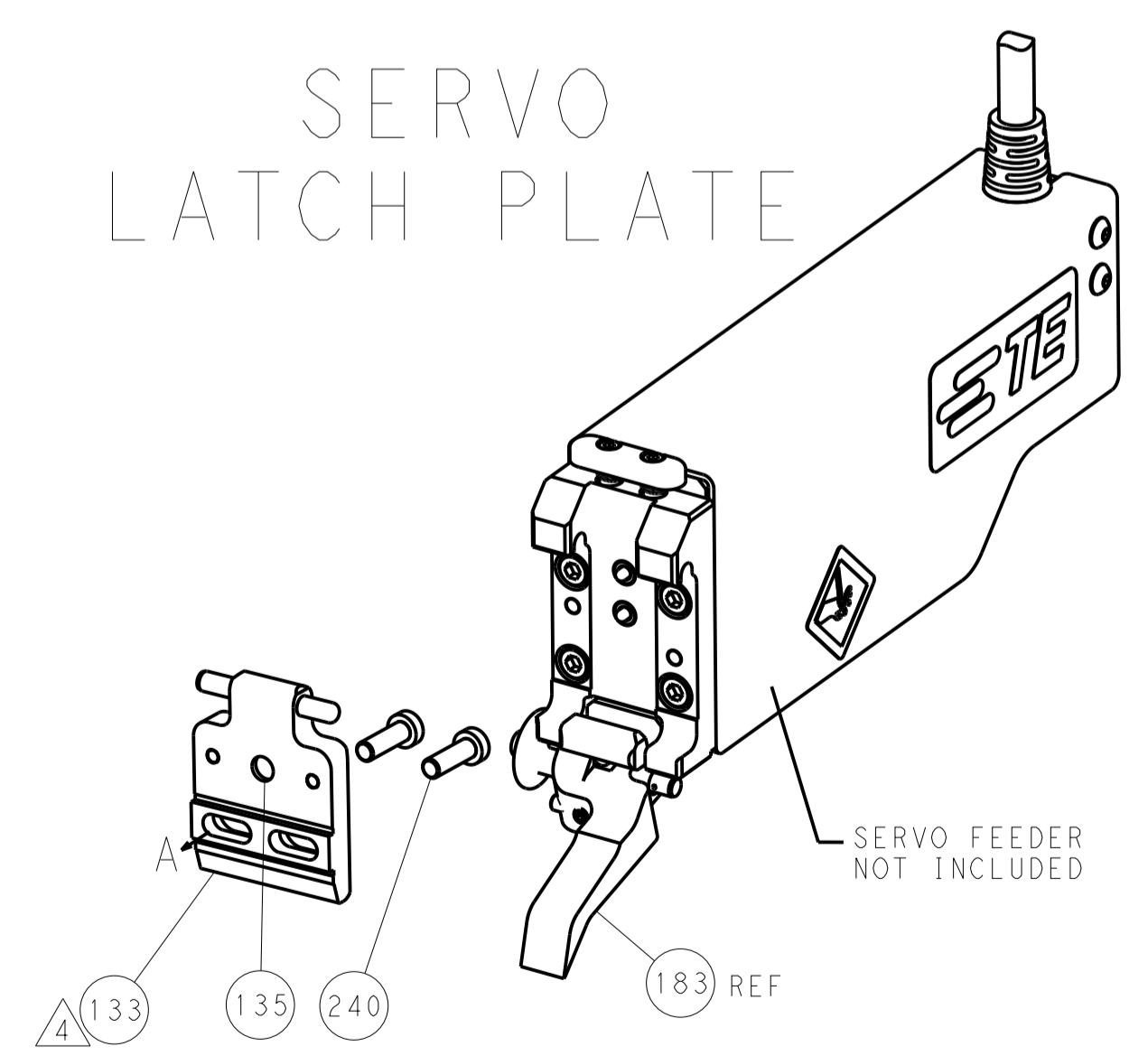
FEED TYPE  
MECHANICAL



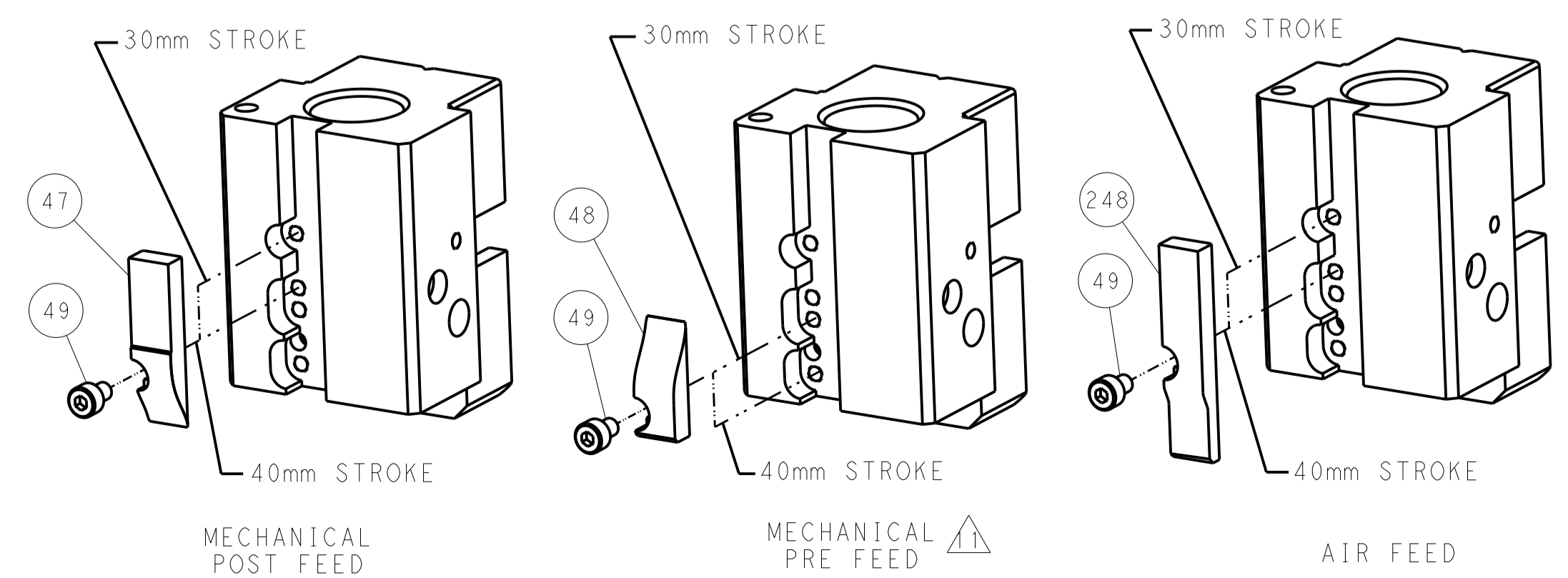
PNEUMATIC



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:<br>mm<br> |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.5<br>1 PLC ±0.5<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.001<br>ANGLES ±.1 |  | DWN B. WEAVER 09JUL2014<br>CHK T. ELBIN 09JUL2014<br>APVD T. ELBIN 09JUL2014<br>PRODUCT SPEC<br>APPLICATION SPEC<br>WEIGHT<br>Customer Accessible Production Drawing |  | TE Connectivity<br>Harrisburg, PA 17105-3608<br>NAME<br>Ocean End Feed Applicator<br>SIZE CAGE CODE DRAWING NO<br>A11 00779 ©=2150457<br>SCALE 1:1 SHEET 2 OF 4 REV A |  | RESTRICTED TO |  |
|-----------------------|--|--|--|--|--|---|--|---------------|--|

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |   |                        |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
|  |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |   |                        |
|  | 2-2150457-1 | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-2 | - | 2063440-1              |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150457-5 | -         | - | 2168400-7 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150457-4 | -         | - | -                      |
|  | 2-2150457-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-2 | - | -                      |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150457-5 | -         | - | 2168400-7 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150457-4 | -         | - | -                      |
|  | 2-2150457-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO 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              |
|  | 2-2150457-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | - | -                      |
|  | 7-2150457-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | - | -                      |

| APPLICATOR DATA                   |      |  |
|-----------------------------------|------|--|
| CRIMP SIZE                        | TYPE |  |
| WIRE 2.03 mm (.080)               | F    |  |
| INSUL 3.56 mm (.140)              | F    |  |
| APPLICATOR INSTRUCTIONS 408-10390 |      |  |

| TERMINAL DATA:                     | TE TERMINAL                             | TE CRIMP SPECIFICATION      |             |
|------------------------------------|---|-----------------------------|-------------|
| TERMINAL NAME:                     | .110 SERIES MINIATURE FASTON RECEPTACLE |                             |             |
| WIRE STRIP LENGTH                  | 3.20-4.00 mm (.126-.157 IN)             | INSULATION DIAMETER RANGE   |             |
|                                    |   | 1.50-2.80 mm (.059-.110 IN) |             |
| TERMINAL APPLICATION SPECIFICATION | 114-20109                               |                             |             |
| TERMINALS APPLIED <sup>10</sup>    |   |                             |             |
| TE TERMINAL                        | TE TERMINAL                             | TE TERMINAL                 | TE TERMINAL |
| 180423-1                           | 1-180423-1                              | 180437-2                    |             |
| 180423-2                           | 180437-1                                | 280429-2                    |             |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]          | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|-----------|---------------------------------|---|
| 1.50mm2   | 1.40 +/- 0.05 [ .055 +/- .002 ] | 7.1   |
| 1.00mm2   | 1.32 +/- 0.05 [ .052 +/- .002 ] | 8.0   |
| 0.75mm2   | 1.27 +/- 0.05 [ .050 +/- .002 ] | 8.6   |
| 0.50mm2   | 1.22 +/- 0.05 [ .048 +/- .002 ] | 9.1   |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150457-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150457-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150457-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.  
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> 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.

| -   | 1   | 1   | 1   | 1   | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | -   | -   | -   | -   | 2119640-1 | PUSH ROD, AIR FEED                  | 250     |
| -77 | -27 | -25 | -22 | -21 | PART NO   | DESCRIPTION                         | ITEM NO |

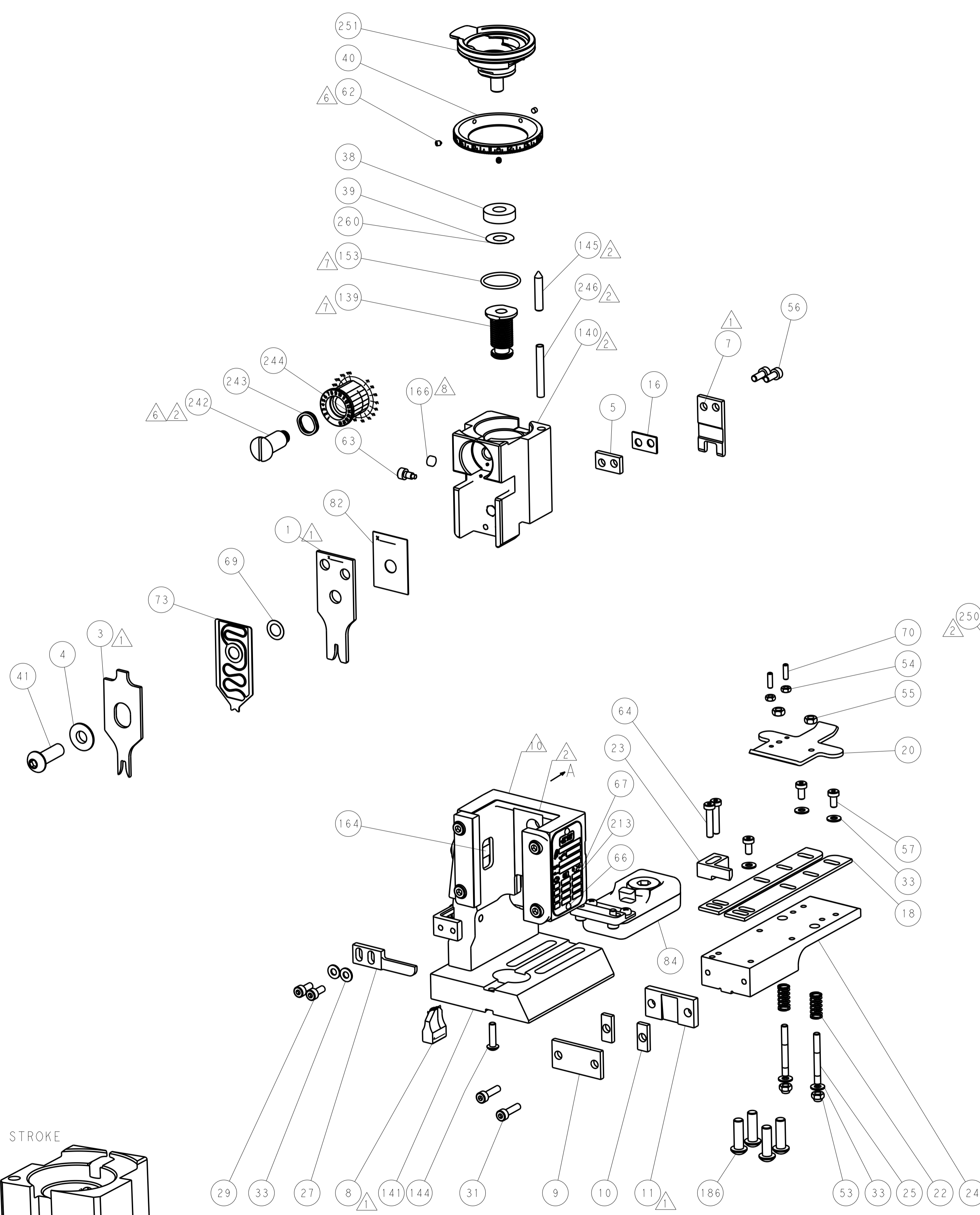
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

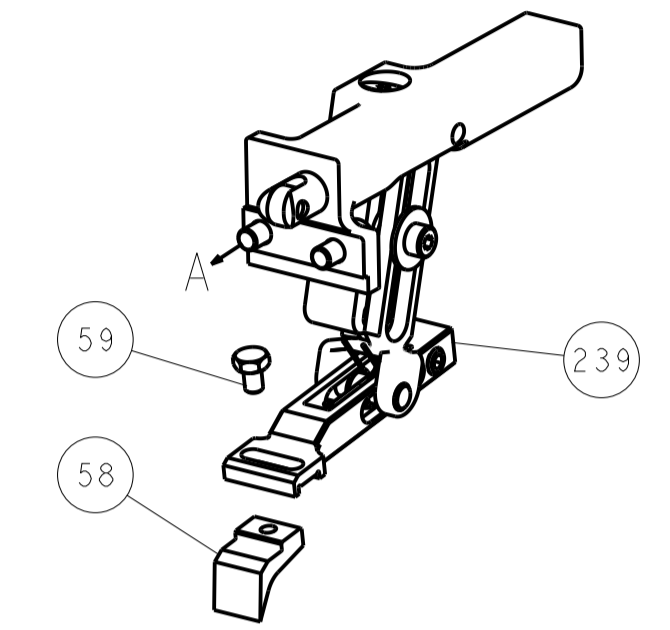
|               |     |     |     |     |             |                                     |         |
|---------------|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -             | -   | -   | 1   | -   | 2079988-1   | BUSHING, LCH5-12, MISUMI            | 249     |
| -             | 1   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246     |
| -             | 1   | 1   | 1   | 1   | 2119082-4   | CAM, SMALL, INSULATION ADJUSTMENT   | 244     |
| -             | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -             | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
| <sup>6</sup>  | -   | -   | 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     |
| -             | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172     |
| -             | 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     |
| -             | -   | -   | -   | 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     |
| -             | 1   | 1   | 1   | 1   | 2119955-2   | ASSY, LUBRICATOR, END FEED          | 84      |
| -             | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82      |
| -             | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 73      |
| -             | 1   | 1   | 1   | 1   | 2119956-2   | DOCUMENTATION PACKAGE               | 71      |
| -             | 2   | 2   | 2   | 2   | 2-18032-2   | SCR, SET, FLT POINT M3 X 10.0       | 70      |
| -             | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69      |
| -             | 1   | -   | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -             | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| -             | 2   | 2   | 2   | 2   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       | 64      |
| -             | 1   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| <sup>6</sup>  | -   | 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   | 2063961-1   | 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   | 5018030-2   | NUT, HEX, REG, RoHS, M4             | 55      |
| -             | 2   | 2   | 2   | 2   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 54      |
| -             | 2   | 2   | 2   | 2   | 986965-8    | NUT, LOCK, HEX, TORQUE (M4)         | 53      |
| -             | -   | -   | 1   | -   | 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   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
| -             | 1   | 1   | 1   | 1   | 2119644-1   | RAM WASHER, PRECISION               | 38      |
| -             | 7   | 7   | 7   | 7   | 1-18028-2   | WASHER, FLAT, REG M4                | 33      |
| -             | 2   | 2   | 2   | 2   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 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   | 1320906-1   | STUD, THREADED                      | 25      |
| -             | 1   | 1   | 1   | 1   | 1752371-5   | PLATE, STRIP GUIDE                  | 24      |
| -             | 1   | 1   | 1   | 1   | 240825-4    | PLATE, STRIP HOLD DOWN              | 23      |
| -             | 2   | 2   | 2   | 2   | 2-22281-3   | SPRING, COMPRESSION                 | 22      |
| -             | 1   | 1   | 1   | 1   | 1752373-4   | DRAG                                | 20      |
| -             | 2   | 2   | 2   | 2   | 1901259-4   | GUIDE, LOWER STRIP                  | 18      |
| -             | 1   | 1   | 1   | 1   | 5-240641-9  | SPACER                              | 16      |
| <sup>11</sup> | -   | 1   | 1   | 1   | 240644-1    | PLATE, REAR SHEAR                   | 11      |
| <sup>11</sup> | -   | 2   | 2   | 2   | 1-240645-4  | SPACER, SHEAR PLATE                 | 10      |
| <sup>11</sup> | -   | 1   | 1   | 1   | 240642-1    | PLATE, FRONT SHEAR                  | 9       |
| <sup>11</sup> | 1   | 1   | 1   | 1   | 1333216-2   | ANVIL, COMBINATION                  | 8       |
| <sup>11</sup> | -   | 1   | 1   | 1   | 1-240651-8  | BLADE, SLUG                         | 7       |
| -             | -   | -   | -   | -   | -           | -                                   | 6       |
| -             | 1   | 1   | 1   | 1   | 3-240641-0  | SPACER                              | 5       |
| -             | 1   | 1   | 1   | 1   | 2-238009-3  | BLOCK, FL CRIMPER SPACER            | 4       |
| <sup>11</sup> | 1   | 1   | 1   | 1   | 2-2119582-4 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -             | -   | -   | -   | -   | -           | -                                   | 2       |
| <sup>11</sup> | 1   | 1   | 1   | 1   | 1-456405-2  | CRIMPER, WIRE PREMIUM               | 1       |
| -77           | -27 | -25 | -22 | -21 | PART NO     | DESCRIPTION                         | ITEM NO |

| DIMENSIONS: |              | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DWG         |             | CHK         |             | APPV        |             | NAME        |                           |
|-------------|--------------|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------------------|
| mm          | 0 PLC ±.5    | 1 PLC ±.13                             | 2 PLC ±.013 | 3 PLC ±.001 | 09 JUL 2014 | 09 JUL 2014 | 09 JUL 2014 | 09 JUL 2014 | 09 JUL 2014 | 09 JUL 2014 | TE Connectivity           |
|             | 4 PLC ±.0001 | ANGLES ±.0001                          | FINISH      | FINISH      | 09 JUL 2014 | 09 JUL 2014 | 09 JUL 2014 | 09 JUL 2014 | 09 JUL 2014 | 09 JUL 2014 | Harrisburg, PA 17105-3608 |
| MATERIAL    |              | FINISH                                 |             | WEIGHT      |             | SCALE       |             | SHEET       |             | REV         |                           |
|             |              |  |             |             |             | A   00779   |             | 3 of 4      |             | A           |                           |

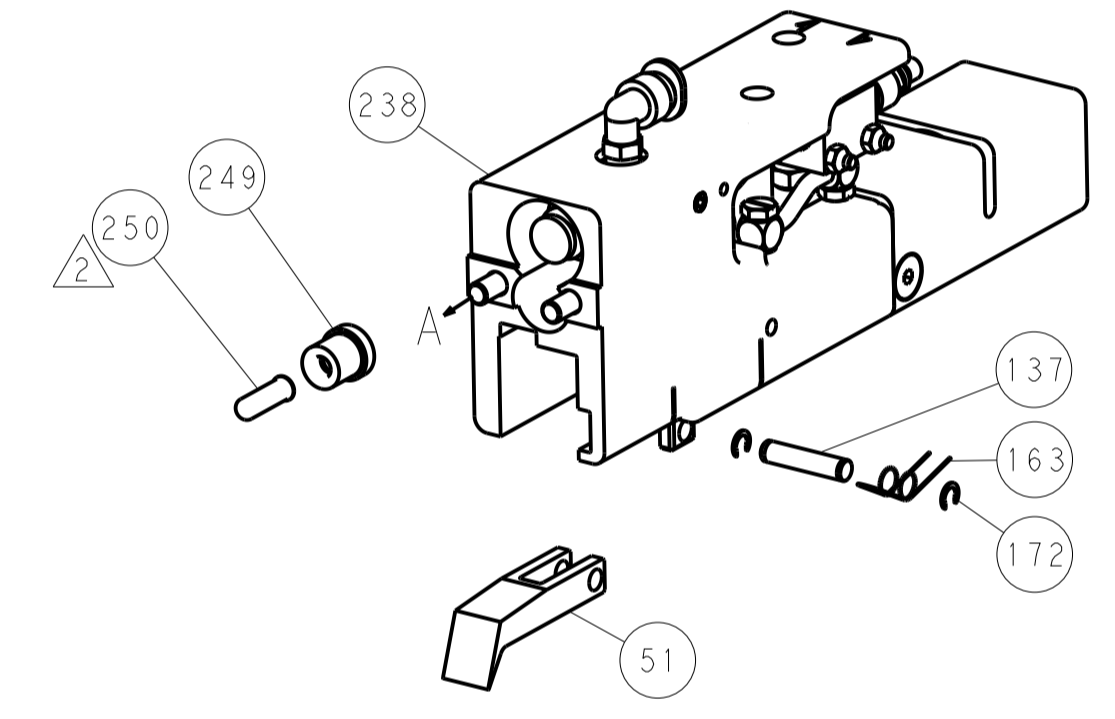
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | OWN | APVD |
|     |    |      |     | SEE SHEET 1 |      |     |      |



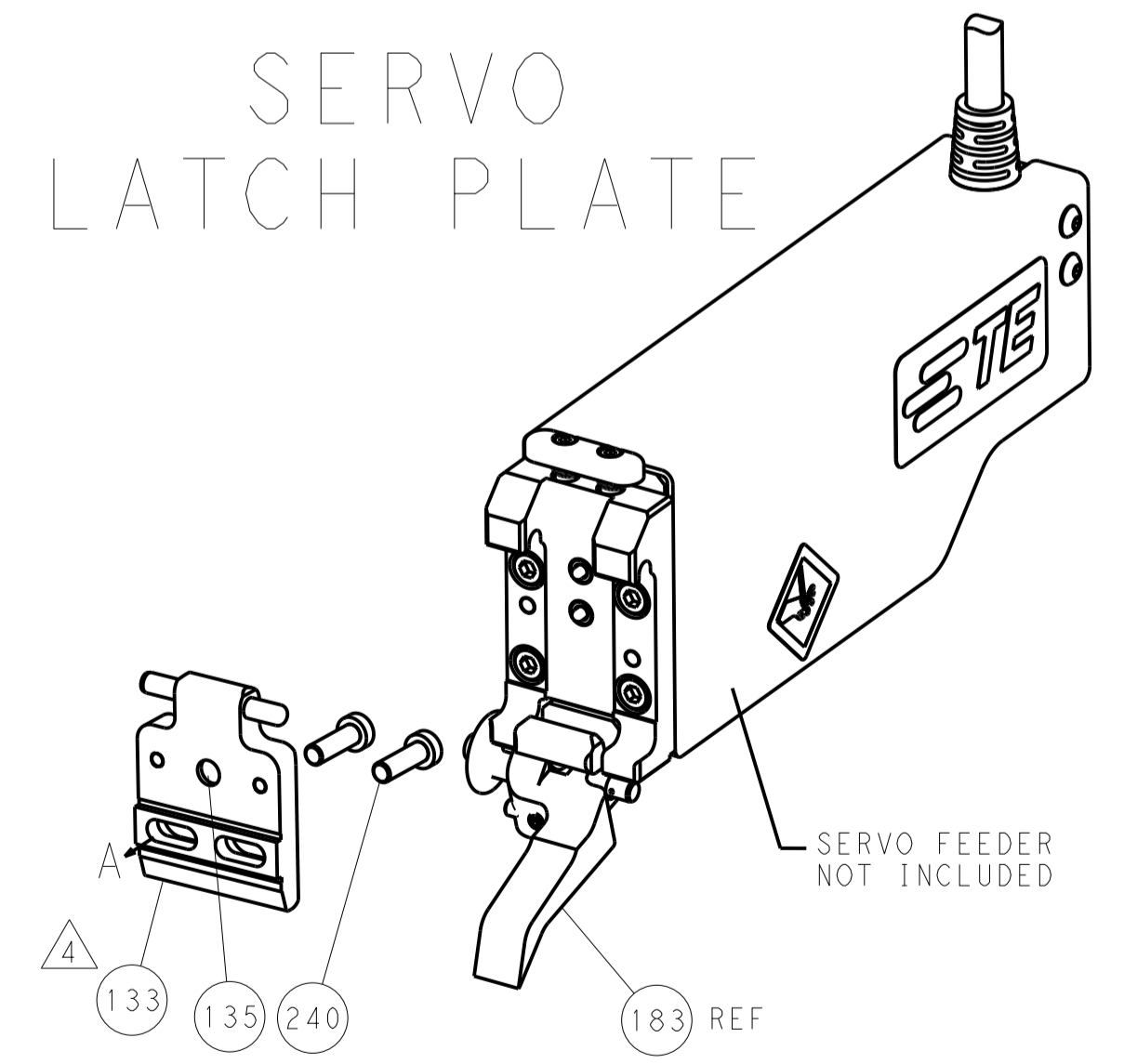
FEED TYPE  
MECHANICAL



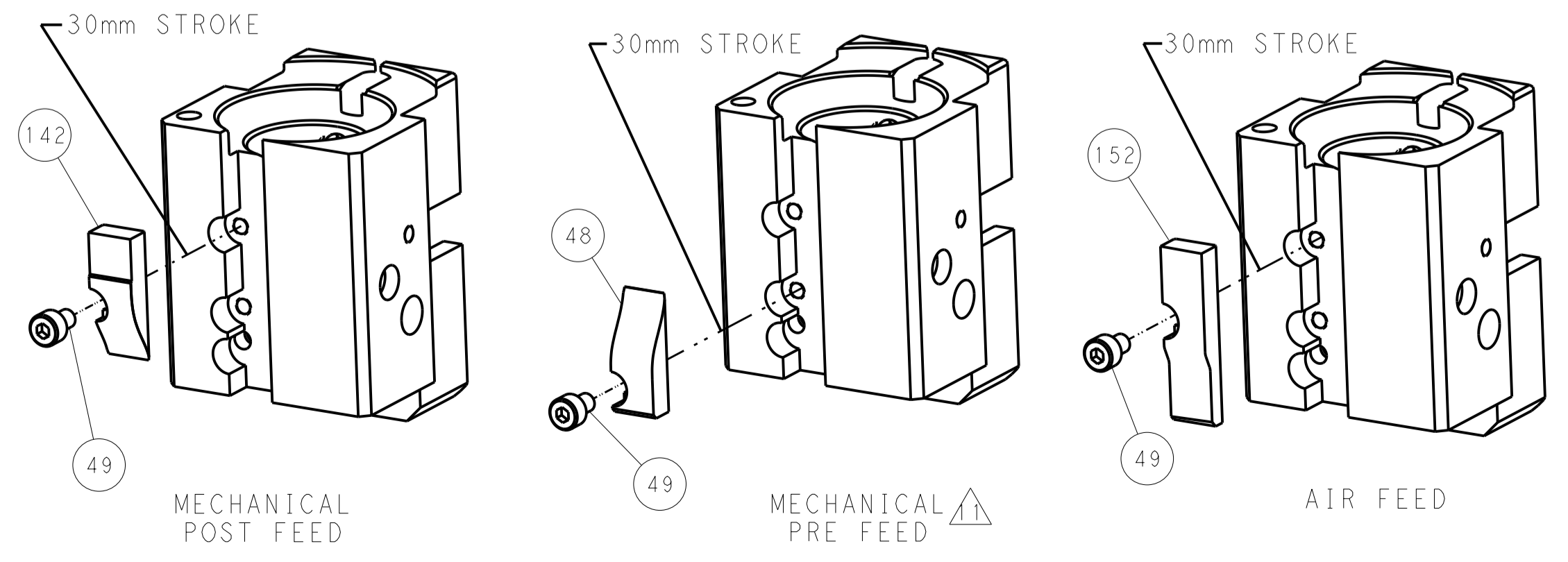
PNEUMATIC



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: B. WEAVER 09JUL2014               |                          | TE Connectivity                 |                |
| mm          | 0 PLC ±0.5   | 1 PLC ±0.5                             | 2 PLC ±0.13  | 3 PLC ±0.13                            | CHK: T. ELBIN 09JUL2014  | Harrisburg, PA 17105-3608       |                |
|             | 4 PLC ±0.013 | 5 PLC ±0.013                           | 6 PLC ±0.001 | 7 PLC ±0.001                           | APVD: T. ELBIN 09JUL2014 | NAME: Ocean End Feed Applicator |                |
| MATERIAL:   | FINISH:      | WEIGHT:                                | ANGLES:      | SIZE: A1                               | CAGE CODE: 00779         | DRAWING NO: C=2150457           | RESTRICTED TO: |
|             |              |  |              | Customer Accessible Production Drawing | SCALE: 1:1               | SHEET: 4 OF 4                   | REV: A         |