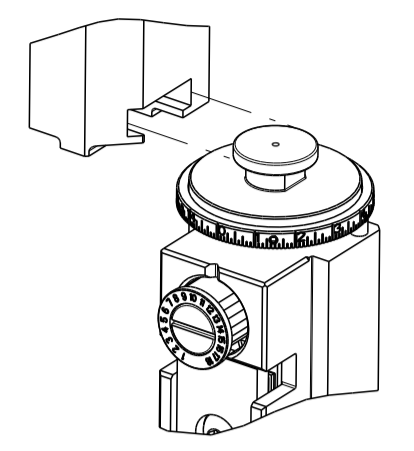
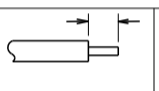


| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER                                    | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE         | CONVERT TO        | PART NUMBERS REQUIRED |             |             |           |           |                        |
|--|-------------|--------------------------|--------------------------|-------------------|-------------------|-----------------------|-------------|-------------|-----------|-----------|------------------------|
|  | 2150649-1   | A                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED    | 2119950-1             | 1-2119792-3 | -           | 2119641-1 | -         | 2063440-1              |
|  | 2150649-2   | A                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | SERVO LATCH PLATE | 2119951-1             | 1901697-5   | 8-2150649-5 | -         | -         | 2168400-7 (QUANTITY 2) |
|  |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -           | 8-2150649-4 | -         | -         | -                      |
|  |             |                          |                          |                   | MECHANICAL FEED   | 2119949-1             | 2063961-3   | 5-18022-5   | 2119653-1 | -         | -                      |
|  | 2150649-5   | A                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1             | 1901697-5   | 8-2150649-5 | -         | -         | 2168400-7 (QUANTITY 2) |
|  |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -           | 8-2150649-4 | -         | -         | -                      |
|  | 2150649-6   | A                        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | MECHANICAL FEED   | 2119949-1             | 2063961-3   | 5-18022-5   | 2119653-1 | -         | -                      |
| 2150649-7  | A           | FINE CRIMP HEIGHT ADJUST | NONE                     | PNEUMATIC FEED    | 2119950-1         | 1-2119792-3           | -           | 2119641-1   | -         | 2063440-1 |                        |
| 7-2150649-7  | A           | CRIMP TOOLING KIT        | -                        | -                 | -                 | -                     | -           | -           | -         | -         |                        |

| APPLICATOR DATA   |                |      |
|-------------------|----------------|------|
| CRIMP             | SIZE           | TYPE |
| WIRE              | 1.27 mm [.050] | F    |
| INSUL             | 1.78 mm [.070] | Ø    |
| APPL INSTRUCTIONS |                |      |
| 408-10390         |                |      |

|  |   |                               |             |
|--|---|-------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL                                 |   | TE CRIMP SPECIFICATION        |             |
| TERMINAL NAME: TERMINAL, RECEPTACLE FASTON FLAG 110 SERIES |   |                               |             |
| WIRE STRIP LENGTH  |  | INSULATION DIAMETER RANGE     |             |
| 3.56-4.32 mm [.140-.170 IN]                                |   | Ø 1.02-1.40 mm [.040-.055 IN] |             |
| TERMINAL APPLICATION SPECIFICATION                         | 114-2028  | -                             | -           |
| TERMINALS APPLIED  |   |                               |             |
| TE TERMINAL  | TE TERMINAL   | TE TERMINAL                   | TE TERMINAL |
| 2238092-1  |   |                               |             |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 24 AWG    | 0.76+/-0.038 [.030+/- .001] | 5.4                            |
| 26 AWG    | 0.71+/-0.038 [.028+/- .001] | 6.1                            |
| 28 AWG    | 0.69+/-0.038 [.027+/- .001] | 6.4                            |

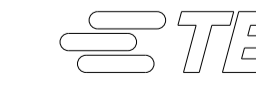
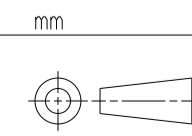
- 1. RECOMMENDED SPARE PARTS
- 2. GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150649-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150649-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150649-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150649-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- 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.
- 14. TERMINAL MUST BE FEED OFF INSULATION LEGS OF TERMINAL.

**\*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.

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

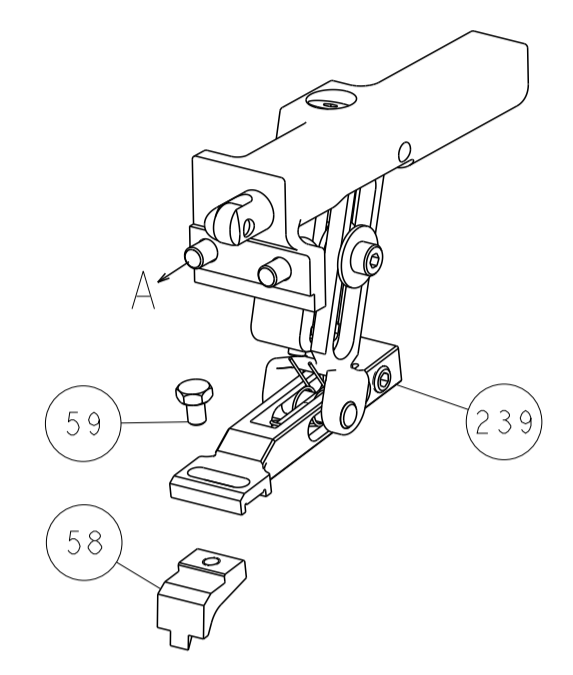
|              |     |      |           |     |           |     |      |
|--------------|-----|------|-----------|-----|-----------|-----|------|
| SET UP GAUGE | LOC | DIST | REVISIONS |     |           |     |      |
| 2119599-2    | A   | 66   | P         | LTN | DATE      | OWN | APVD |
|              | A   |      | RELEASED  |     | 01JUL2016 | MR  | TE   |

| P  | LTN | DESCRIPTION | DATE | OWN | APVD |             |  |     |
|----|-----|-------------|------|-----|------|-------------|--|-----|
| 2  | -   | 1           | -    | -   | -    | 2119957-2   | APPLICATOR SHIM PACK                   | 260 |
| 1  | -   | 1           | 1    | 1   | 1    | 455888-9    | SPACER, CRIMPER                        | 259 |
| 1  | -   | 1           | 1    | 1   | 1    | 8-21084-0   | O-RING, .676 ID, .070 DIA. MAT.        | 252 |
| -  | -   | -           | -    | 1   | -    | 2119640-1   | PUSH ROD, AIR FEED                     | 250 |
| -  | -   | -           | -    | 1   | -    | 2079988-1   | BUSHING, LCH5-12, MISUMI               | 249 |
| -  | -   | -           | -    | 1   | -    | 2119641-1   | FEED CAM, AIR FEED                     | 248 |
| -  | 1   | -           | 1    | 1   | 1    | 2119798-1   | DETENT PIN                             | 247 |
| -  | 1   | -           | 1    | 1   | 1    | 1-22279-3   | SPRING, COMPRESSION                    | 246 |
| -  | -   | 1           | -    | -   | -    | 2161315-1   | RAM, STEPPED, AMP STYL, EF, 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   | 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 |
| -  | 2   | 2           | 2    | 2   | 2    | 1-2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 6          | 191 |
| -  | -   | 1           | 1    | -   | -    | 1901697-5   | 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 |
| -  | REF | REF         | 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         | REF  | -   | -    | 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    | 1803078-2   | SPACER, PRECISION                      | 82  |
| -  | 1   | 1           | 1    | 1   | 1    | 2119956-2   | DOCUMENTATION PACKAGE                  | 71  |
| -  | 2   | 2           | 2    | 2   | 2    | 3-18032-3   | SCR, SET, FLT POINT M3 X 20.0          | 70  |
| -  | 1   | -           | -    | 1   | 1    | 2119740-1   | TAG, IDENTIFICATION                    | 67  |
| -  | 2   | 2           | 2    | 2   | 2    | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188       | 66  |
| -  | 1   | -           | 1    | 1   | 1    | 2119793-1   | LIMITER, ADJUSTMENT BOLT               | 63  |
| 6  | -   | 3           | -    | 3   | 3    | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0    | 62  |
| -  | 1   | 1           | 1    | 1   | 1    | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)               | 60  |
| -  | -   | -           | -    | -   | 1    | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0              | 59  |
| -  | -   | -           | -    | -   | 1    | 2063961-3   | FEED FINGER                            | 58  |
| -  | 4   | 4           | 4    | 4   | 4    | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8           | 57  |
| -  | 2   | 2           | 2    | 2   | 2    | 5018030-1   | NUT, HEX, REG, RoHS, M3                | 54  |
| -  | 2   | 2           | 2    | 2   | 2    | 986965-8    | NUT, LOCK, HEX, TORQUE (M4)            | 53  |
| -  | -   | -           | -    | -   | 1    | 1-2119792-3 | PAWL, EF, AIR                          | 51  |
| -  | -   | -           | -    | -   | 1    | 18023-9     | SCR, SKT HD CAP M4 X 6.0               | 49  |
| 11 | -   | -           | -    | -   | 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    | 2161310-1   | RAM, STEPPED, AMP STYLE, END FEED      | 44  |
| -  | 1   | 1           | 1    | 1   | 1    | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)              | 41  |
| -  | 1   | -           | 1    | 1   | 1    | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT      | 40  |
| -  | 1   | -           | 1    | 1   | 1    | 2119957-1   | APPLICATOR SHIM PACK                   | 39  |
| -  | 1   | 1           | 1    | 1   | 1    | 1-2119644-4 | RAM WASHER, PRECISION                  | 38  |
| 6  | -   | 1           | 1    | 1   | 1    | 2119085-1   | FA HEAD, ATLANTIC STYLE                | 37  |
| -  | 1   | -           | 1    | 1   | 1    | 2119092-1   | BOLT, ADJUSTMENT                       | 35  |
| -  | 8   | 8           | 8    | 8   | 8    | 1-18028-2   | WASHER, FLAT, REG M4                   | 33  |
| -  | 2   | 2           | 2    | 2   | 2    | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0       | 31  |
| -  | 2   | 2           | 2    | 2   | 2    | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10         | 29  |
| -  | 1   | 1           | 1    | 1   | 1    | 240639-3    | STRIPPER (MACHINING)                   | 27  |
| -  | 2   | 2           | 2    | 2   | 2    | 1-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 35         | 25  |
| -  | 1   | 1           | 1    | 1   | 1    | 1752371-1   | PLATE, STRIP GUIDE                     | 24  |
| -  | 2   | 2           | 2    | 2   | 2    | 22281-8     | SPRING, COMPRESSION                    | 22  |
| -  | 1   | 1           | 1    | 1   | 1    | 1633168-1   | ARM, STOCK DRAG                        | 21  |
| -  | 1   | 1           | 1    | 1   | 1    | 1-464452-6  | DRAG, STOCK                            | 20  |
| -  | 1   | 1           | 1    | 1   | 1    | 8-1901696-2 | STRIP GUIDE, REAR                      | 19  |
| -  | 1   | 1           | 1    | 1   | 1    | 1-1901259-7 | GUIDE, LOWER STRIP                     | 18  |
| -  | 4   | 4           | 4    | 4   | 4    | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12)              | 17  |
| 1  | -   | 1           | 1    | 1   | 1    | 240644-1    | PLATE, REAR SHEAR                      | 11  |
| -  | -   | -           | -    | -   | -    | -           | -                                      | 10  |
| 1  | -   | 1           | 1    | 1   | 1    | 8-690482-1  | PLATE, FRONT SHEAR                     | 9   |
| 1  | 1   | 1           | 1    | 1   | 1    | 1-1803257-3 | ANVIL, COMBINATION, END FEED           | 8   |
| 1  | -   | 1           | 1    | 1   | 1    | 462374-2    | BLADE, SLUG                            | 7   |
| -  | -   | -           | -    | -   | -    | -           | -                                      | 6   |
| -  | 1   | 1           | 1    | 1   | 1    | 2-238009-9  | BLOCK, FL CRIMPER SPACER               | 4   |
| 1  | 1   | 1           | 1    | 1   | 1    | 3-1633966-4 | CRIMPER, INSULATION O                  | 3   |
| -  | -   | -           | -    | -   | -    | -           | -                                      | 2   |
| 1  | 1   | 1           | 1    | 1   | 1    | 5-1633588-0 | CRIMPER, WIRE                          | 1   |

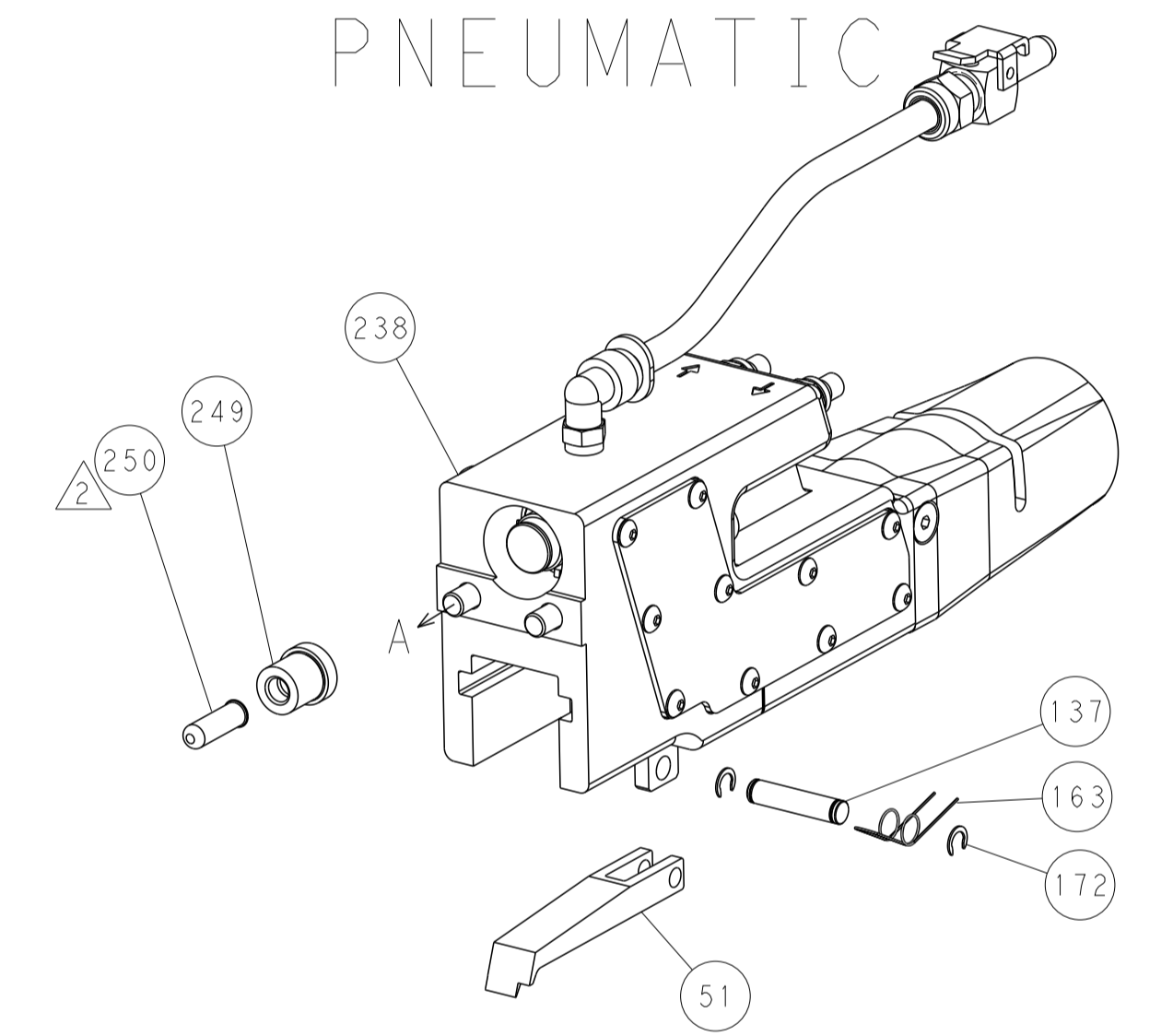
|   |  |   |       |      |           |  |
|---|--|---|-------|------|-----------|--|
| DIMENSIONS:   |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:  |       | OWN  | 31MAR2016 |  TE Connectivity<br>Harrisburg, PA 17105-3608 |
| mm  |  | 0 PLC ±.1<br>1 PLC ±.15<br>2 PLC ±.2<br>3 PLC ±.25<br>4 PLC ±.3<br>ANGLES ±.015 |       | CHK  | 31MAR2016 |  |
|  |  |   |       | APVD | 31MAR2016 |  |
| MATERIAL:   |  | FINISH:   |       | NAME |           |  |
| Customer Accessible Production Drawing  |  |   | SCALE | 1:1  | SHEET     | 1 of 4   |
|   |  |   | REV   | A    |           |  |

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

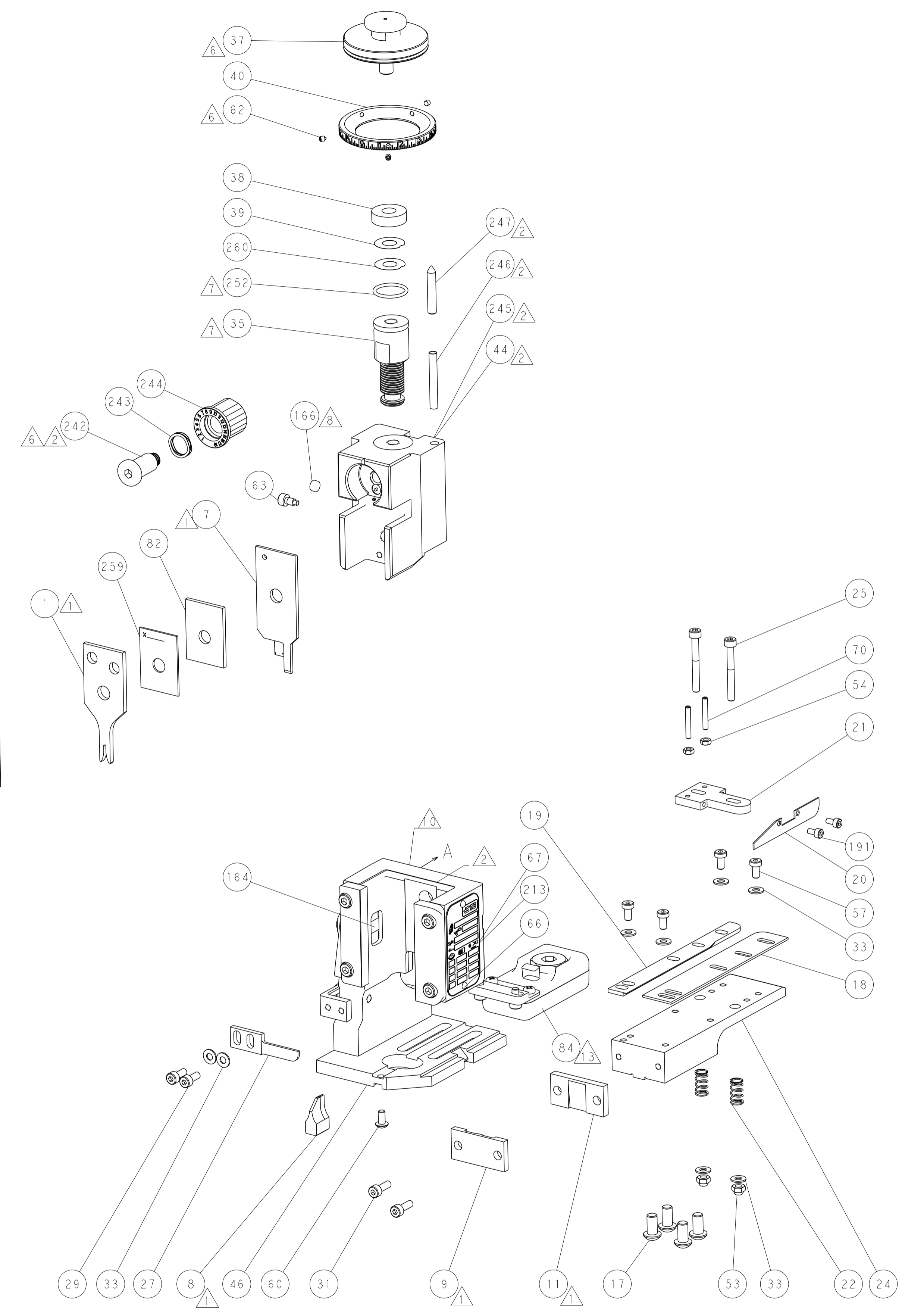
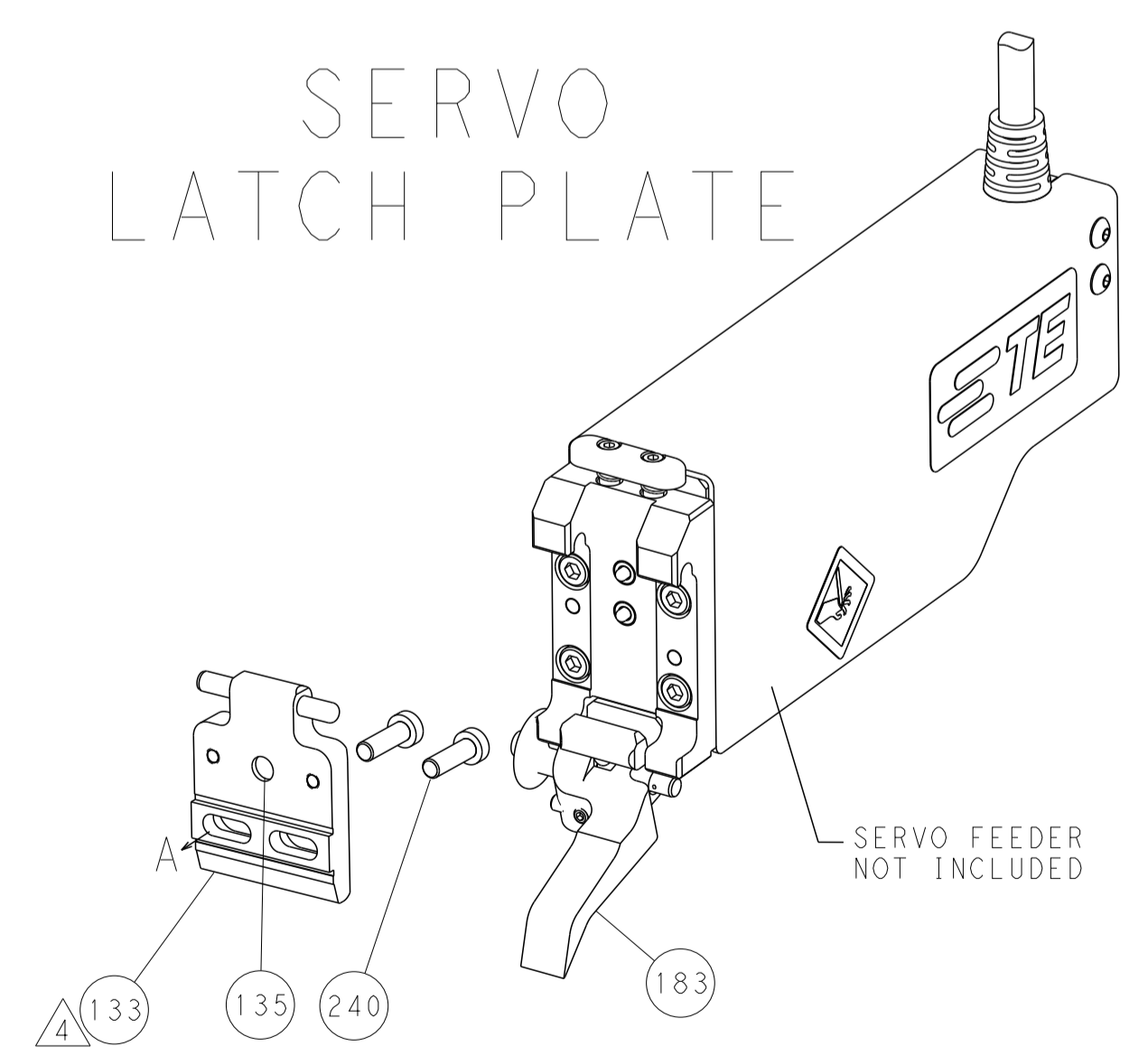
# FEED TYPE MECHANICAL



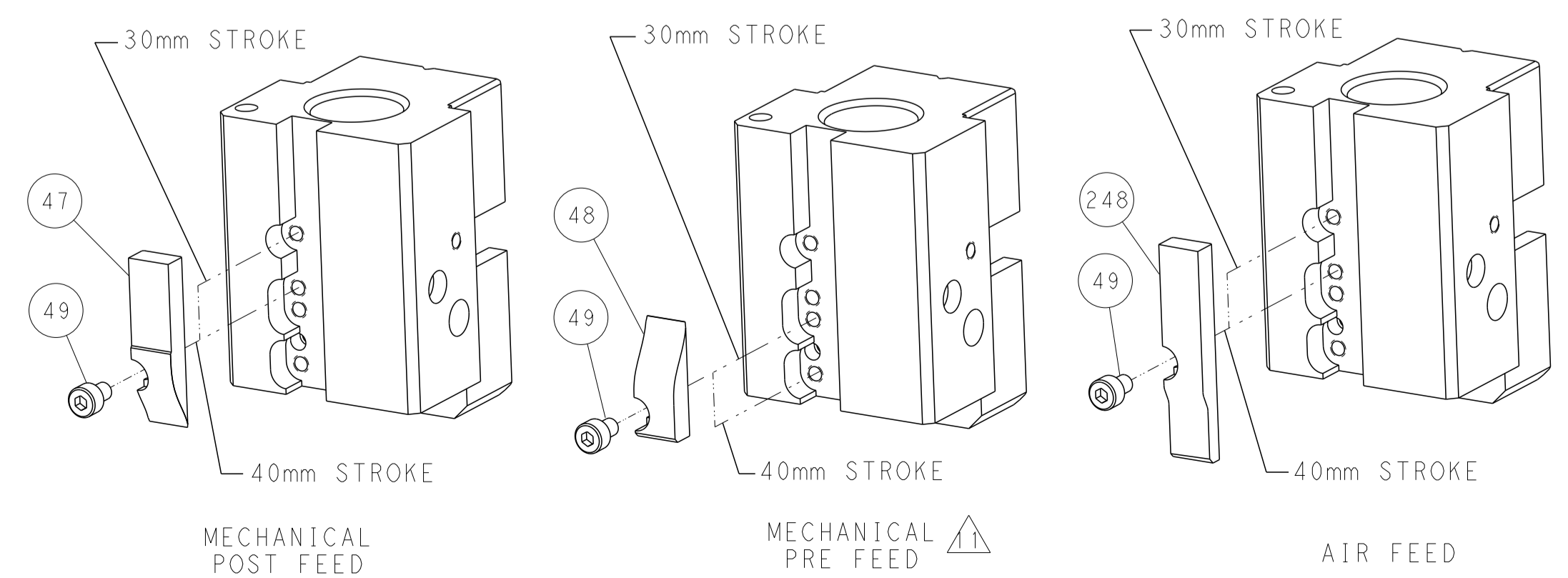
# PNEUMATIC



# 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 ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH |  | DWN J. HOU 31MAR2016<br>CHK L. ZHANG 31MAR2016<br>APVD L. ZHANG 31MAR2016<br>PRODUCT SPEC<br>APPLICATION SPEC<br>WEIGHT<br>SCALE 1:1 |  | NAME Ocean End Feed Applicator<br>SIZE CAGE CODE DRAWING NO. RESTRICTED TO<br>A1 00779 ©=2150649<br>SHEET 2 OF 4 REV A |  |
| MATERIAL:             |  |   |  | Customer Accessible Production Drawing   |  |  |  |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |             |             |           |   |                        |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-------------|-------------|-----------|---|------------------------|
|  |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |             |             |           |   |                        |
|  | 2-2150649-1 | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 1-2119792-3 | -           | 2119641-2 | - | 2063440-1              |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | 1901697-5   | 8-2150649-5 | -         | - | 2168400-7 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -           | 8-2150649-4 | -         | - | -                      |
|  | 2-2150649-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 2063961-3   | 5-18022-5   | 2119653-2 | - | -                      |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | 1901697-5   | 8-2150649-5 | -         | - | 2168400-7 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -           | 8-2150649-4 | -         | - | -                      |
|  | 2-2150649-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 2063961-3   | 5-18022-5   | 2119653-2 | - | -                      |
|  |             |          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1-2119792-3 | -           | 2119641-2 | - | 2063440-1              |
|  | 2-2150649-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -           | -           | -         | - | -                      |
|  | 7-2150649-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -           | -           | -         | - | -                      |

| APPLICATOR DATA                |                |      |
|--------------------------------|----------------|------|
| CRIMP                          | SIZE           | TYPE |
| WIRE                           | 1.27 mm [.050] | F    |
| INSUL                          | 1.78 mm [.070] | Ø    |
| APPL INSTRUCTIONS<br>408-10390 |                |      |

| TERMINAL DATA: TE TERMINAL                                 |             | TE CRIMP SPECIFICATION                                     |             |
|--|-------------|--|-------------|
| TERMINAL NAME: TERMINAL, RECEPTACLE FASTON FLAG 110 SERIES |             |  |             |
| WIRE STRIP LENGTH<br>3.56-4.32 mm [.140-.170 IN]           |             | INSULATION DIAMETER RANGE<br>Ø 1.02-1.40 mm [.040-.055 IN] |             |
| TERMINAL APPLICATION SPECIFICATION                         | 114-2028    | -  | -           |
| TERMINALS APPLIED  |             |  |             |
| TE TERMINAL  | TE TERMINAL | TE TERMINAL  | TE TERMINAL |
| 2238092-1  |             |  |             |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]         | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|-----------|--------------------------------|---|
| 24 AWG    | 0.76 +/- 0.038 [.030 +/- .001] | 5.4   |
| 26 AWG    | 0.71 +/- 0.038 [.028 +/- .001] | 6.1   |
| 28 AWG    | 0.69 +/- 0.038 [.027 +/- .001] | 6.4   |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150649-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150649-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150649-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-2. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- TERMINAL LUBRICANT IS RECOMMENDED.
- TERMINAL MUST BE FEED OFF INSULATION LEGS OF TERMINAL.

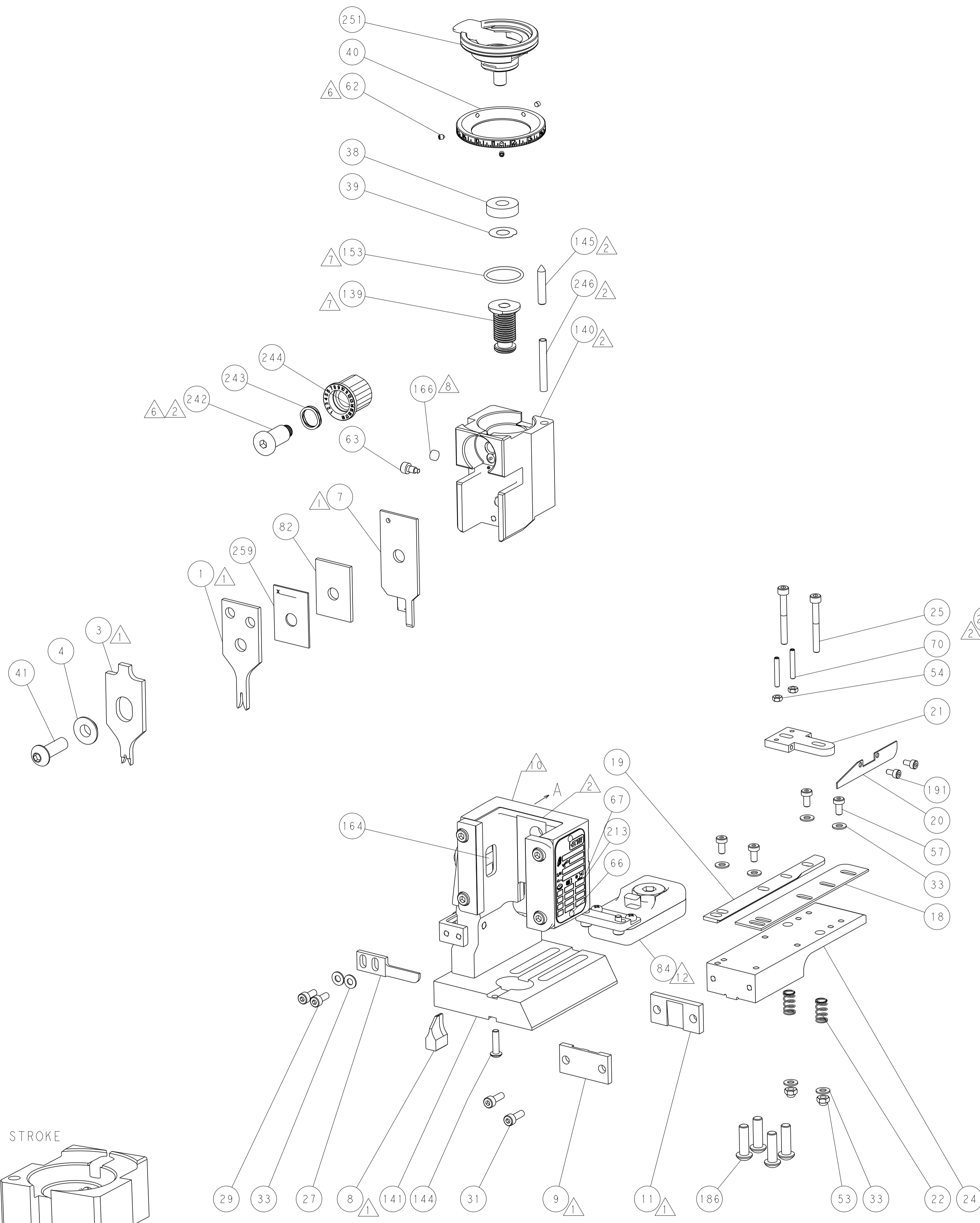
**\*WARNING**  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

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

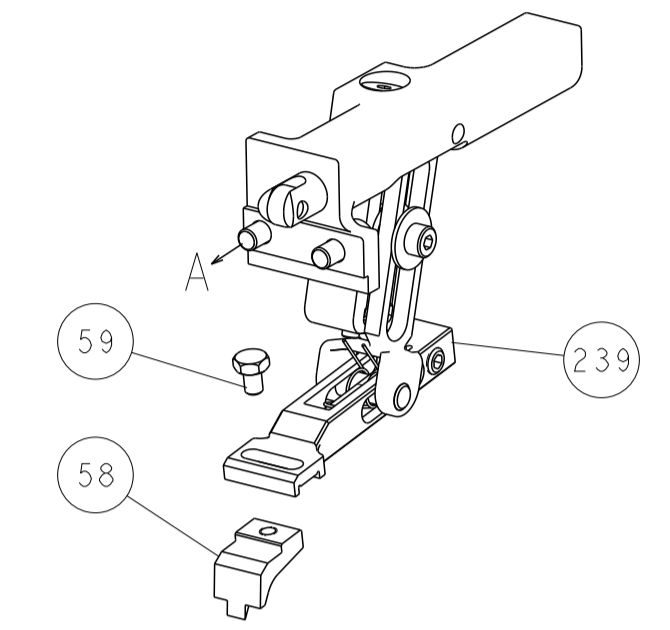
| SET UP GAUGE<br>2119599-2 |     |             | LOC<br>A | DIST<br>66 | REVISIONS   |                                     |     |  |
|---------------------------|-----|-------------|----------|------------|-------------|-------------------------------------|-----|--|
| P                         | LTN | DESCRIPTION | DATE     | OWN        | APVD        |                                     |     |  |
| -                         | -   | SEE SHEET 1 | -        | -          | -           |                                     |     |  |
| -                         | 1   | 1           | 1        | 1          | 455888-9    | SPACER, CRIMPER                     | 259 |  |
| -                         | 1   | 1           | 1        | 1          | 2119782-1   | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |  |
| -                         | -   | -           | 1        | -          | 2119640-1   | PUSH ROD, AIR FEED                  | 250 |  |
| -                         | -   | -           | 1        | -          | 2079988-1   | BUSHING, LCH5-12, MISUMI            | 249 |  |
| -                         | 1   | 1           | 1        | 1          | 1-22279-3   | SPRING, COMPRESSION                 | 246 |  |
| -                         | 1   | 1           | 1        | 1          | 2119082-4   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |  |
| -                         | 1   | 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 |  |
| -                         | 2   | 2           | 2        | 2          | 1-2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 6       | 191 |  |
| -                         | 4   | 4           | 4        | 4          | 2079383-9   | SCR, BHSC, RoHS (M6 X 20)           | 186 |  |
| -                         | -   | 1           | -        | -          | 1901697-5   | FEED FINGER ASSEMBLY, EF            | 183 |  |
| -                         | -   | -           | 2        | -          | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |  |
|                           | -   | 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          | 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          | 2161313-1   | RAM, STEPPED, ASIAN STYLE, END FEED | 140 |  |
|                           | -   | 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          | 1803078-2   | SPACER, PRECISION                   | 82  |  |
| -                         | 1   | 1           | 1        | 1          | 2119956-2   | DOCUMENTATION PACKAGE               | 71  |  |
| -                         | 2   | 2           | 2        | 2          | 3-18032-3   | SCR, SET, FLT POINT M3 X 20.0       | 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          | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |  |
|                           | -   | 3           | 3        | 3          | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62  |  |
| -                         | -   | -           | -        | 1          | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |  |
| -                         | -   | -           | -        | 1          | 2063961-3   | FEED FINGER                         | 58  |  |
| -                         | 4   | 4           | 4        | 4          | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8        | 57  |  |
| -                         | 2   | 2           | 2        | 2          | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 54  |  |
| -                         | 2   | 2           | 2        | 2          | 986965-8    | NUT, LOCK, HEX, TORQUE (M4)         | 53  |  |
| -                         | -   | -           | 1        | -          | 1-2119792-3 | 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          | 1-2119644-4 | RAM WASHER, PRECISION               | 38  |  |
| -                         | 8   | 8           | 8        | 8          | 1-18028-2   | WASHER, FLAT, REG M4                | 33  |  |
| -                         | 2   | 2           | 2        | 2          | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 31  |  |
| -                         | 2   | 2           | 2        | 2          | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 29  |  |
| -                         | 1   | 1           | 1        | 1          | 240639-3    | STRIPPER (MACHINING)                | 27  |  |
| -                         | 2   | 2           | 2        | 2          | 1-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 35      | 25  |  |
| -                         | 1   | 1           | 1        | 1          | 1752371-1   | PLATE, STRIP GUIDE                  | 24  |  |
| -                         | 2   | 2           | 2        | 2          | 22281-8     | SPRING, COMPRESSION                 | 22  |  |
| -                         | 1   | 1           | 1        | 1          | 1633168-1   | ARM, STOCK DRAG                     | 21  |  |
| -                         | 1   | 1           | 1        | 1          | 1-464452-6  | DRAG, STOCK                         | 20  |  |
| -                         | 1   | 1           | 1        | 1          | 8-1901696-2 | STRIP GUIDE, REAR                   | 19  |  |
| -                         | 1   | 1           | 1        | 1          | 1-1901259-7 | GUIDE, LOWER STRIP                  | 18  |  |
|                           | -   | 1           | 1        | 1          | 240644-1    | PLATE, REAR SHEAR                   | 11  |  |
| -                         | -   | -           | -        | -          | -           | -                                   | 10  |  |
|                           | -   | 1           | 1        | 1          | 8-690482-1  | PLATE, FRONT SHEAR                  | 9   |  |
|                           | 1   | 1           | 1        | 1          | 1-1803257-3 | ANVIL, COMBINATION, END FEED        | 8   |  |
|                           | -   | 1           | 1        | 1          | 462374-2    | BLADE, SLUG                         | 7   |  |
| -                         | -   | -           | -        | -          | -           | -                                   | 6   |  |
| -                         | 1   | 1           | 1        | 1          | 2-238009-9  | BLOCK, FL CRIMPER SPACER            | 4   |  |
|                           | 1   | 1           | 1        | 1          | 3-1633966-4 | CRIMPER, INSULATION O               | 3   |  |
| -                         | -   | -           | -        | -          | -           | -                                   | 2   |  |
|                           | 1   | 1           | 1        | 1          | 5-1633588-0 | CRIMPER, WIRE                       | 1   |  |
| -                         | -   | -           | -        | -          | -           | -                                   | 0   |  |

|  |       |   |  |  |   |  |  |                               |                                      |  |            |               |     |   |
|--|-------|---|--|--|---|--|--|-------------------------------|--------------------------------------|--|------------|---------------|-----|---|
| DIMENSIONS:                            |       |   |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |   |  |  | DWG<br>J. HOU<br>31MAR2016    |                                      | TE Connectivity<br>Harrisburg, PA 17105-3608 |            |               |     |   |
| mm                                     | 0 PLC | ± |  | 1 PLC                                  | ± |  |  | CHK<br>L. ZHANG<br>31MAR2016  | NAME<br>Ocean End Feed<br>Applicator |  |            |               |     |   |
|  | 2 PLC | ± |  | 3 PLC                                  | ± |  |  | APVD<br>L. ZHANG<br>31MAR2016 |                                      |  |            |               |     |   |
|  | 4 PLC | ± |  | ANGLES                                 | ± |  |  | PRODUCT SPEC                  |                                      |  |            |               |     |   |
| MATERIAL:                              |       |   |  | FINISH                                 |   |  |  | APPLICATION SPEC              | SIZE                                 | CAGE CODE                                    | DRAWING NO | RESTRICTED TO |     |   |
|  |       |   |  |  |   |  |  |                               | A1                                   | 00779  | ©=2150649  |               |     |   |
| Customer Accessible Production Drawing |       |   |  |  |   |  |  |                               | SCALE                                | 1:1  | SHEET      | 3 of 4        | REV | A |

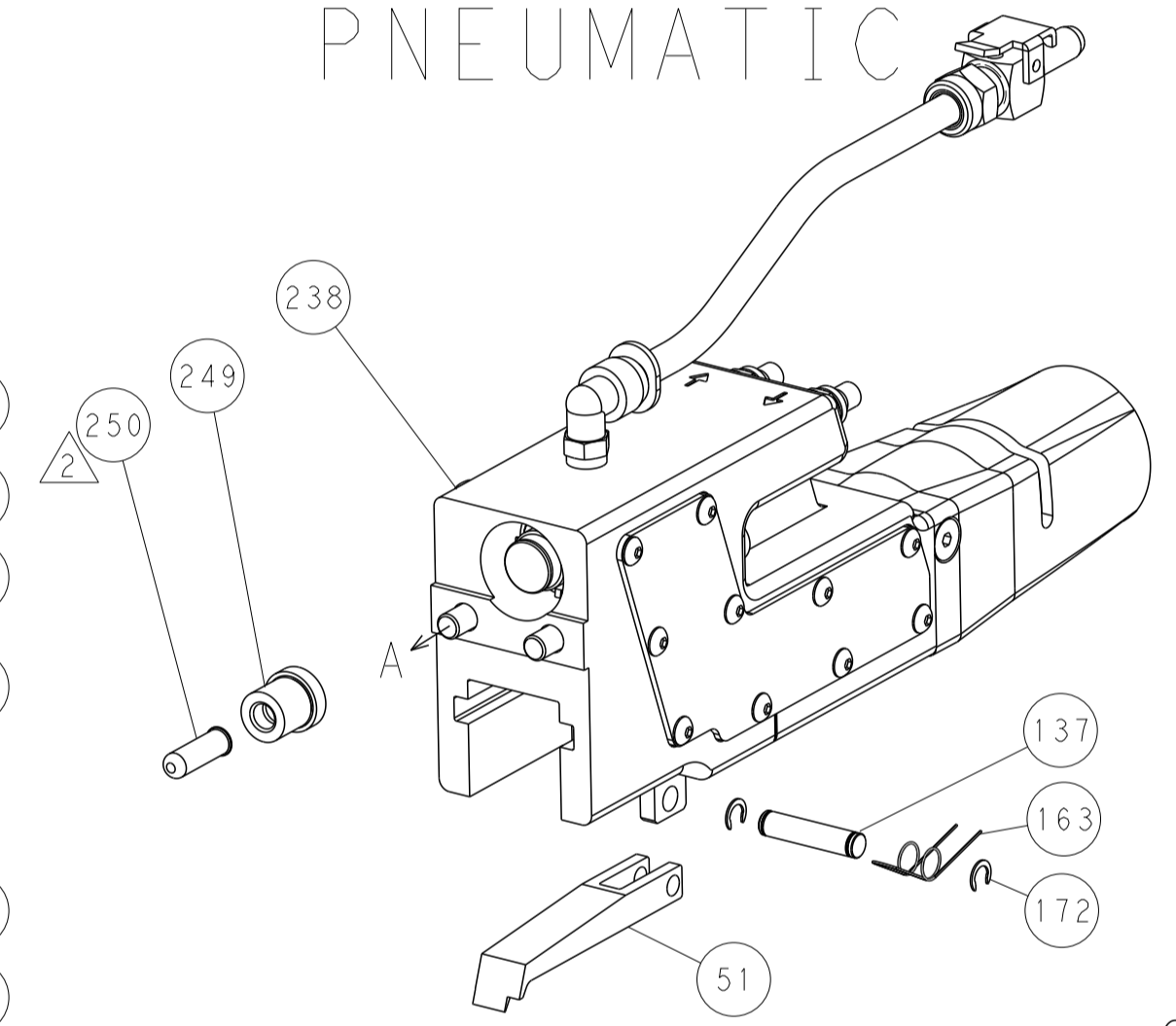
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    |     | SEE SHEET 1 |      |     |      |



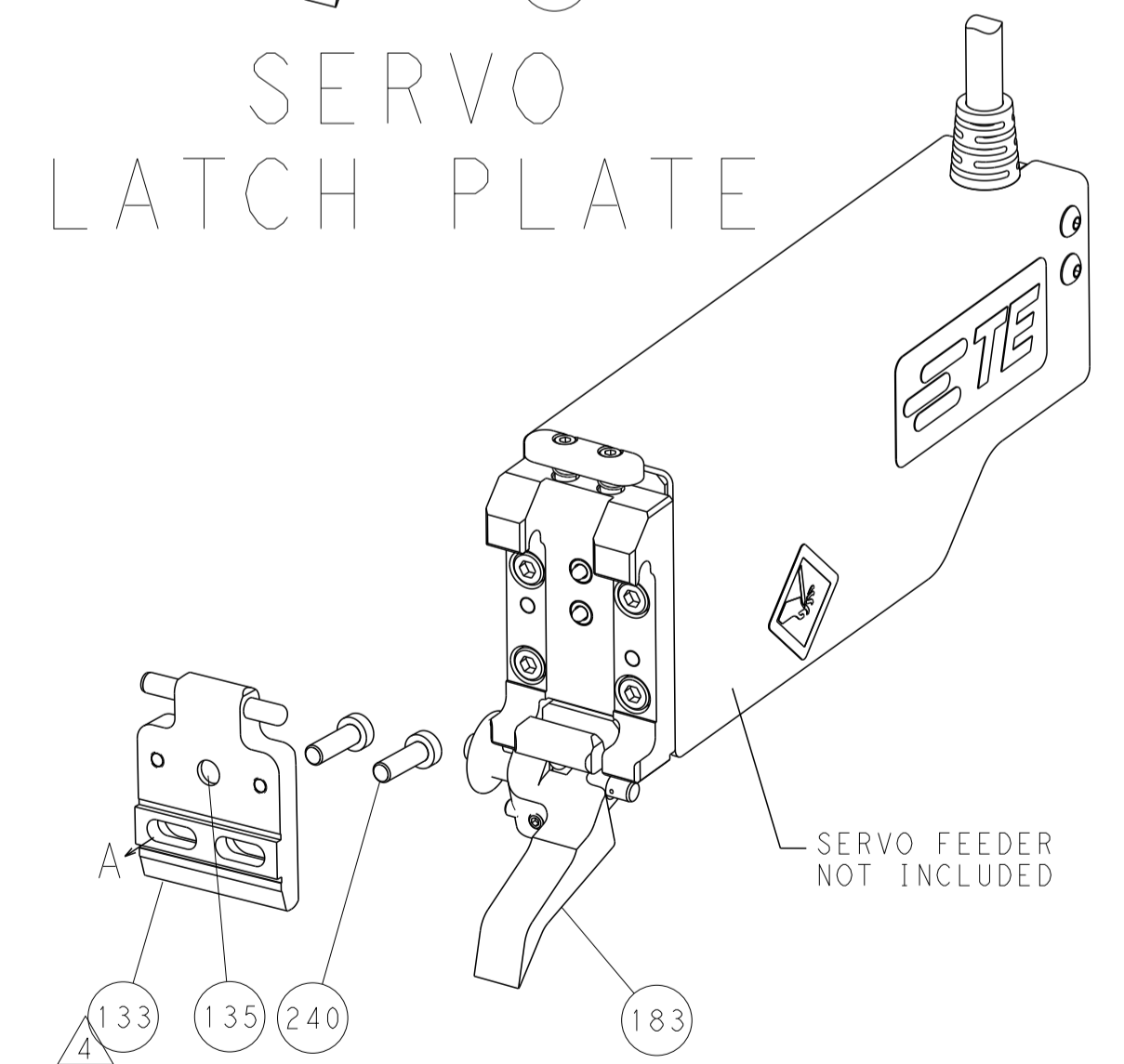
FEED TYPE  
MECHANICAL



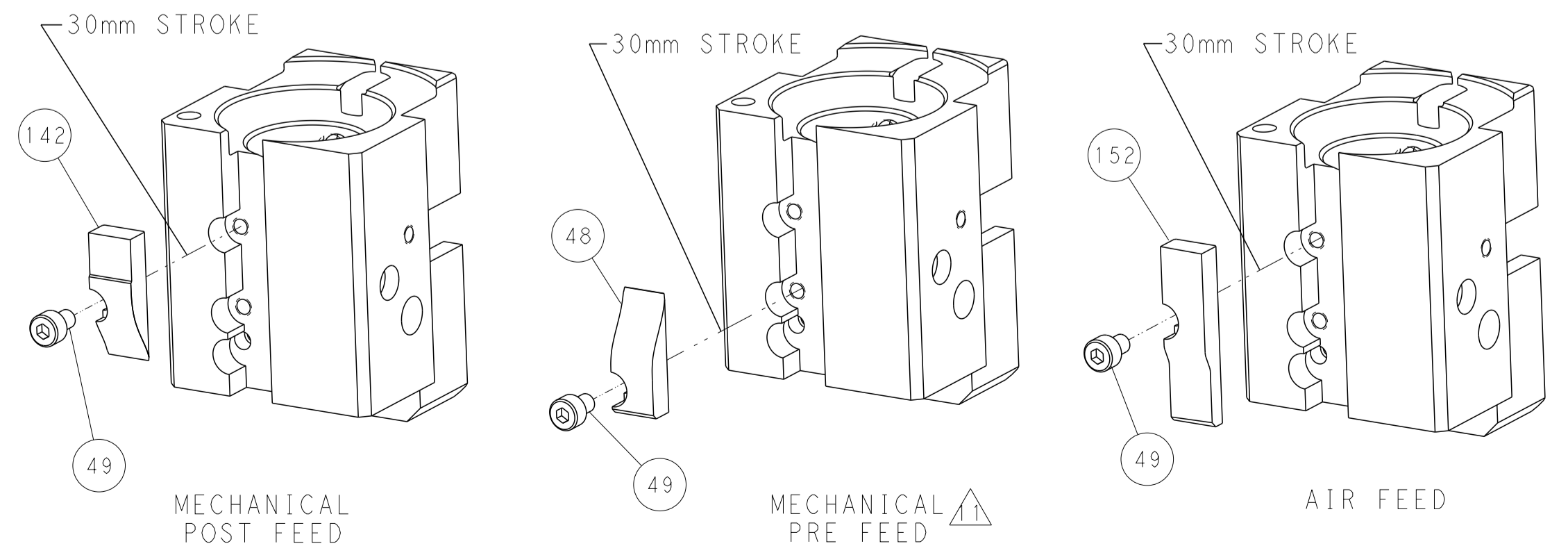
PNEUMATIC



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 J. HOU 31MAR2016                   |                        | STE TE Connectivity Harrisburg, PA 17105-3608 |                           |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ±  | 3 PLC ±                                | CHK L. ZHANG 31MAR2016 | NAME Ocean End Feed Applicator                |                           |
|             | 4 PLC ± | ANGLES ±                               | FINISH ± | APVD L. ZHANG 31MAR2016                | PRODUCT SPEC           |   | RESTRICTED TO             |
| MATERIAL    |         |  |          |  | APPLICATION SPEC       |   | SIZE CAGE CODE DRAWING NO |
|             |         |  |          |  | WEIGHT                 |   | A1 00779 C=2150649        |
|             |         |  |          | Customer Accessible Production Drawing |                        | SCALE 1:1                                     | SHEET 4 OF 4 REV A        |