

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
|---|-------------|--------------------------|--------------------------|--------------------------------|-------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| | 2150756-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-1 | - | 2119641-1 | - | 2063440-1 |
| | 2150756-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150756-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150756-4 | - | - | - |
| | | | | | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - |
| | 2150756-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150756-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150756-4 | - | - | - |
| | 2150756-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | - | - | - | - | - | - | - |
| 2150756-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2150756-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm [1.10] | F |
| INSUL | - | - |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: GMG TERMINAL | | TE CRIMP SPECIFICATION | |
|--------------------------------------|---------------|-------------------------------|--------------|
| TERMINAL NAME: FACETTED SINGLE CRIMP | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.24-6.00 mm [1.206-.236 IN] | | Ø2.20-3.00 mm [1.087-.118 IN] | |
| TERMINAL APPLICATION SPECIFICATION | NONE | - | - |
| TERMINALS APPLIED ³ | | | |
| TE TERMINAL | GMG TERMINAL | TE TERMINAL | GMG TERMINAL |
| 2303686-1 | 33021.50.08.1 | - | - |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 2.50mm2 | 2.19 +/- 0.05 [1.086 +/- .002] | 5.1 ⁹ |
| 2.00mm2 | 2.08 +/- 0.05 [1.082 +/- .002] | 6.5 |
| 1.50mm2 | 1.89 +/- 0.05 [1.074 +/- .002] | 8.7 |
| 1.00mm2 | 1.73 +/- 0.05 [1.068 +/- .002] | 10.7 |

- 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: 8-2150756-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150756-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150756-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150756-6
- 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.
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.

¹⁴ WIRE STRANDING MAY OCCUR WHEN RUNNING WIRES WITH CMA 4175 OR GREATER.

***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 | | | |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO | | | |

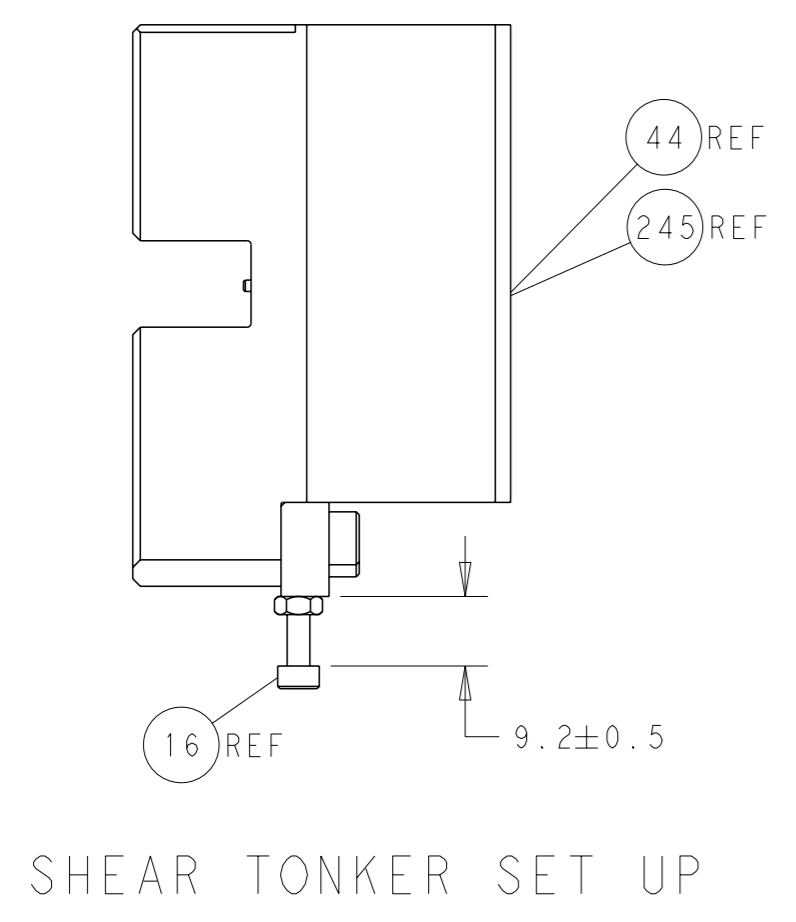
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

| REVISEMENTS | | | DATE | OWN | APVD |
|-------------|-------------|--|-----------|-----|------|
| 1 | PRELIMINARY | | 16NOV2016 | MEH | TE |
| A | RELEASED | | 12JAN2017 | MEH | TE |

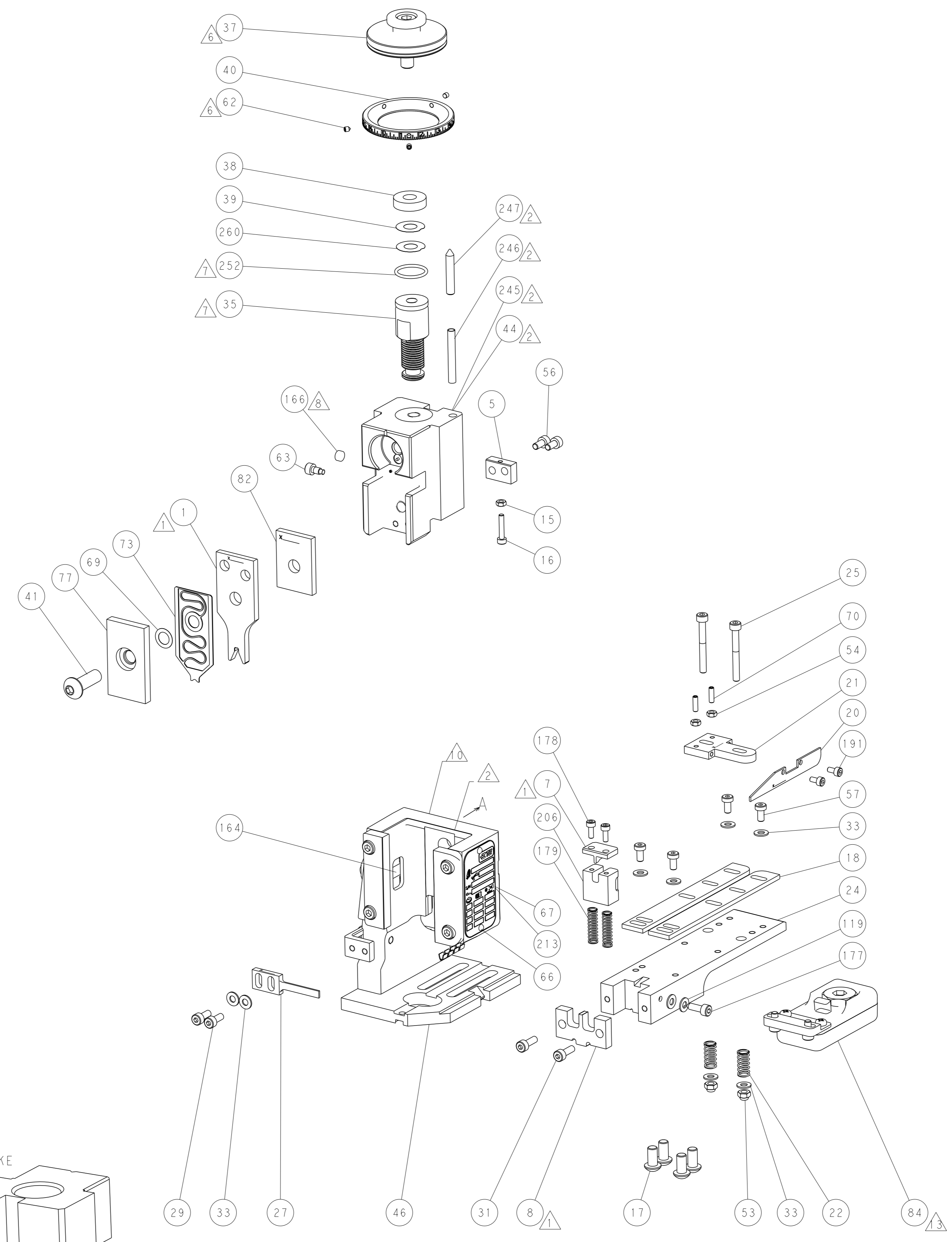
| - | 1 | - | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 | | | |
|---------------|--------|--------|--------|--------|--------|-------------|--------------------------------------|-----|--|--|--|
| - | - | 1 | - | - | - | 2119759-1 | RAM, AMP STYLE, END FEED, NON-ADJUST | 245 | | | |
| - | - | 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 | | | |
| - | 1 | 1 | 1 | 1 | 1 | 1803163-1 | FLOATING SHEAR HOLDER | 206 | | | |
| - | 2 | 2 | 2 | 2 | 2 | 1-2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 6 | 191 | | | |
| - | - | REFREF | - | - | - | 1901697-1 | FEED FINGER ASSEMBLY, EF | 183 | | | |
| - | 2 | 2 | 2 | 2 | 2 | 2-22280-0 | SPRING, COMPRESSION | 179 | | | |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 178 | | | |
| - | 1 | 1 | 1 | 1 | 1 | 356885-1 | STOP, SHEAR | 177 | | | |
| - | - | - | - | 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 | | | |
| - | 2 | 2 | 2 | 2 | 2 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 | | | |
| ¹³ | - | 1 | 1 | 1 | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 | | | |
| - | 1 | 1 | 1 | 1 | 1 | 2-455888-8 | SPACER, CRIMPER | 82 | | | |
| - | 1 | 1 | 1 | 1 | 1 | 1803203-1 | BLOCK, FRONT DEPRESSOR | 77 | | | |
| - | 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 | | | |
| - | 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 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | | | |
| - | - | - | - | - | 1 | 2063961-1 | FEED FINGER | 58 | | | |
| - | 4 | 4 | 4 | 4 | 4 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 | | | |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 56 | | | |
| - | 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 | - | 2119792-1 | 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 | 1-2119644-2 | RAM WASHER, PRECISION | 38 | | | |
| ⁶ | - | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 | | | |
| ⁷ | - | 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 | 468281-6 | STRIPPER | 27 | | | |
| - | 2 | 2 | 2 | 2 | 2 | 1-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 35 | 25 | | | |
| - | 1 | 1 | 1 | 1 | 1 | 1803162-1 | PLATE, STRIP GUIDE | 24 | | | |
| - | 2 | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 | | | |
| - | 1 | 1 | 1 | 1 | 1 | 1633168-1 | ARM, STOCK DRAG | 21 | | | |
| - | 1 | 1 | 1 | 1 | 1 | 464452-2 | DRAG, STOCK | 20 | | | |
| - | 2 | 2 | 2 | 2 | 2 | 1-1901259-8 | GUIDE, LOWER STRIP | 18 | | | |
| - | 4 | 4 | 4 | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 | | | |
| - | 1 | 1 | 1 | 1 | 1 | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16 | 16 | | | |
| - | 1 | 1 | 1 | 1 | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 15 | | | |
| - | - | - | - | - | - | - | - | 11 | | | |
| - | - | - | - | - | - | - | - | 10 | | | |
| - | - | - | - | - | - | - | - | 9 | | | |
| ¹ | 1 | 1 | 1 | 1 | 1 | 1-1633342-1 | ANVIL, WIRE | 8 | | | |
| ¹ | - | 1 | 1 | 1 | 1 | 1633722-3 | SHEAR BLADE | 7 | | | |
| - | - | - | - | - | - | - | - | 6 | | | |
| - | 1 | 1 | 1 | 1 | 1 | 690753-6 | SPACER, TONKER | 5 | | | |
| - | - | - | - | - | - | - | - | 4 | | | |
| - | - | - | - | - | - | - | - | 3 | | | |
| - | - | - | - | - | - | - | - | 2 | | | |
| ¹ | 1 | 1 | 1 | 1 | 1 | 4-1633730-7 | CRIMPER, WIRE | 1 | | | |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | APPROVED: | | NAME: | |
|---------------------------|---------|--|---------|----------------|--|-------------|----------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | ANGLES ± |
| MATERIAL: | FINISH: | WEIGHT: | SCALE: | RESTRICTED TO: | Customer Accessible Production Drawing | | |
| Ocean End Feed Applicator | | | | SIZE: | CAGE CODE: | DRAWING NO: | RESTRICTED TO: |
| | | | | A1 | 00779 | ©=2150756 | - |
| | | | | SCALE: | SHEET: | OF: | REV: |
| | | | | 1:1 | 1 | 4 | A |

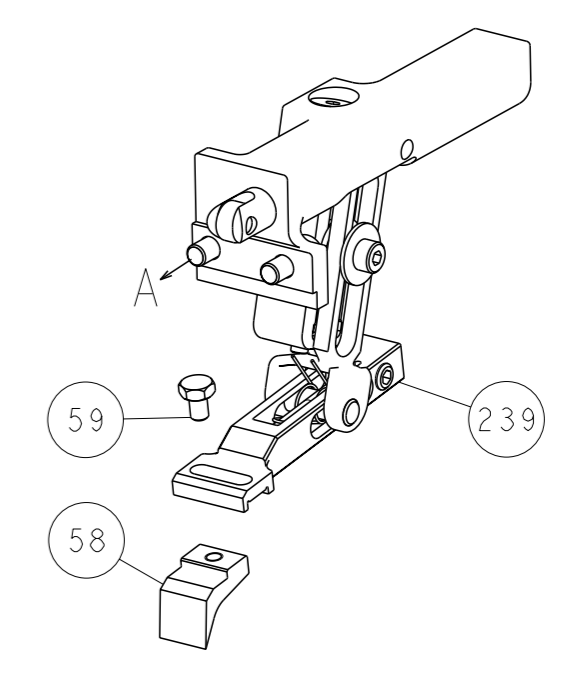
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|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LYR | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | | | |



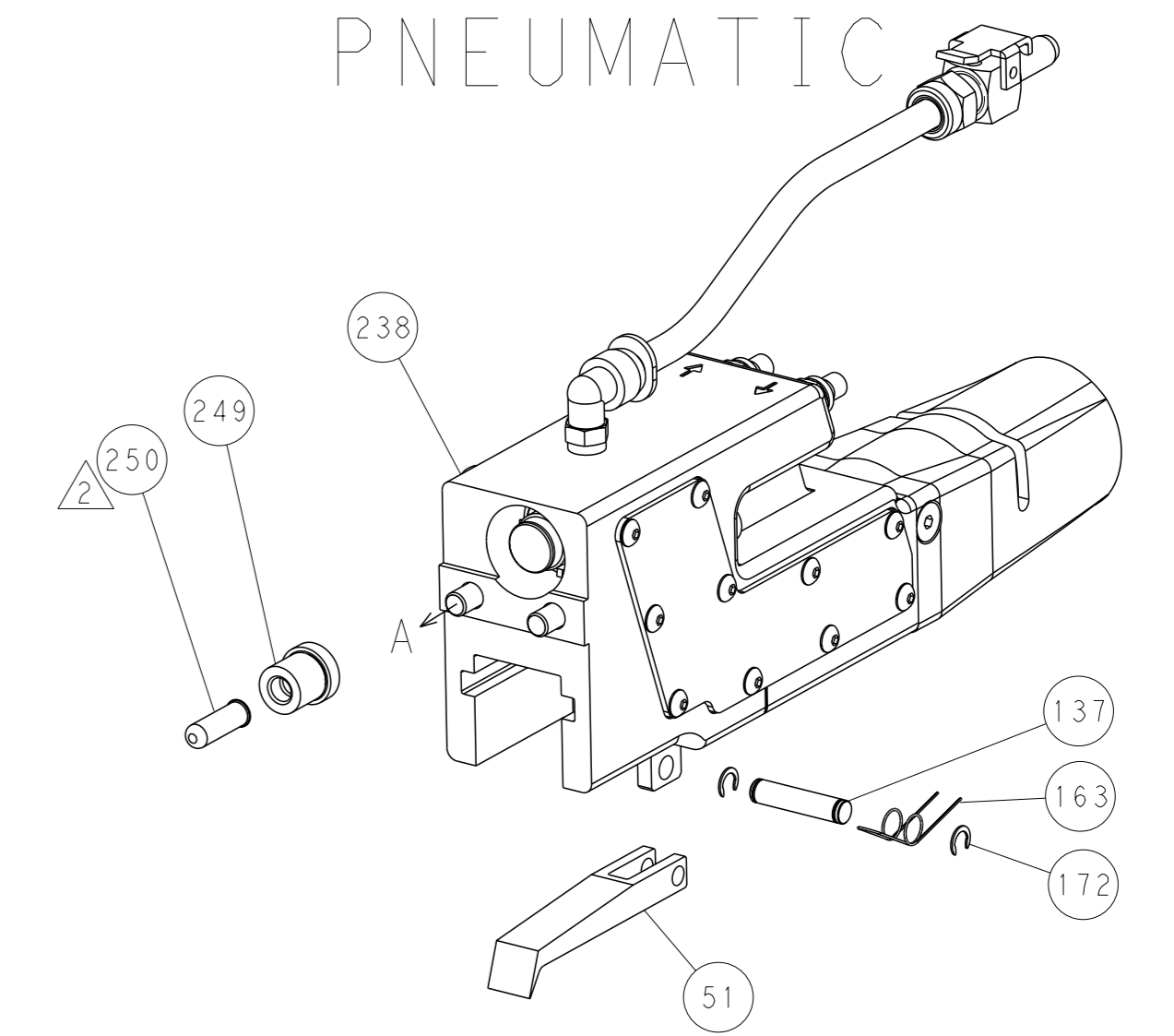
SHEAR TONKER SET UP



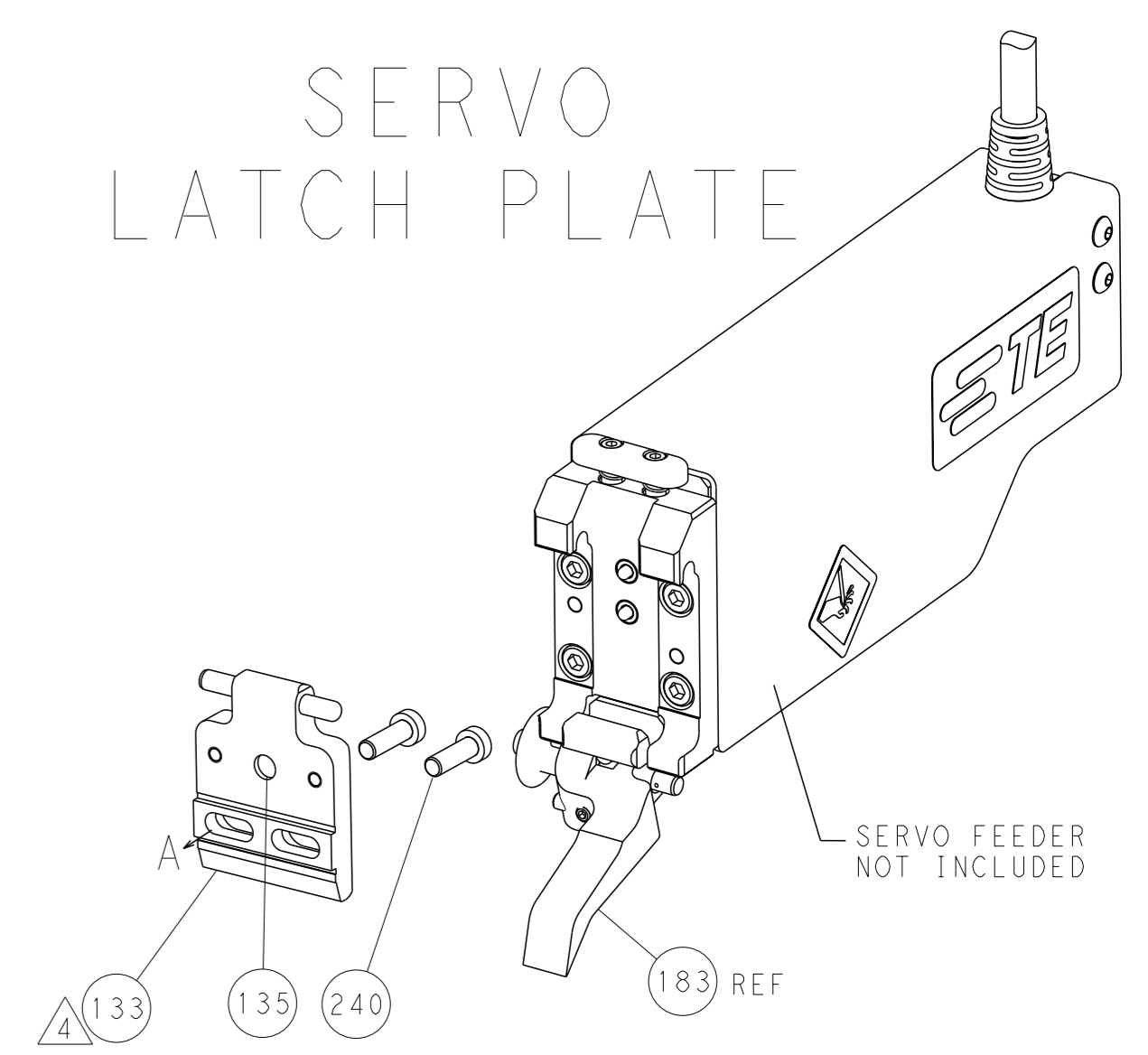
FEED TYPE
MECHANICAL



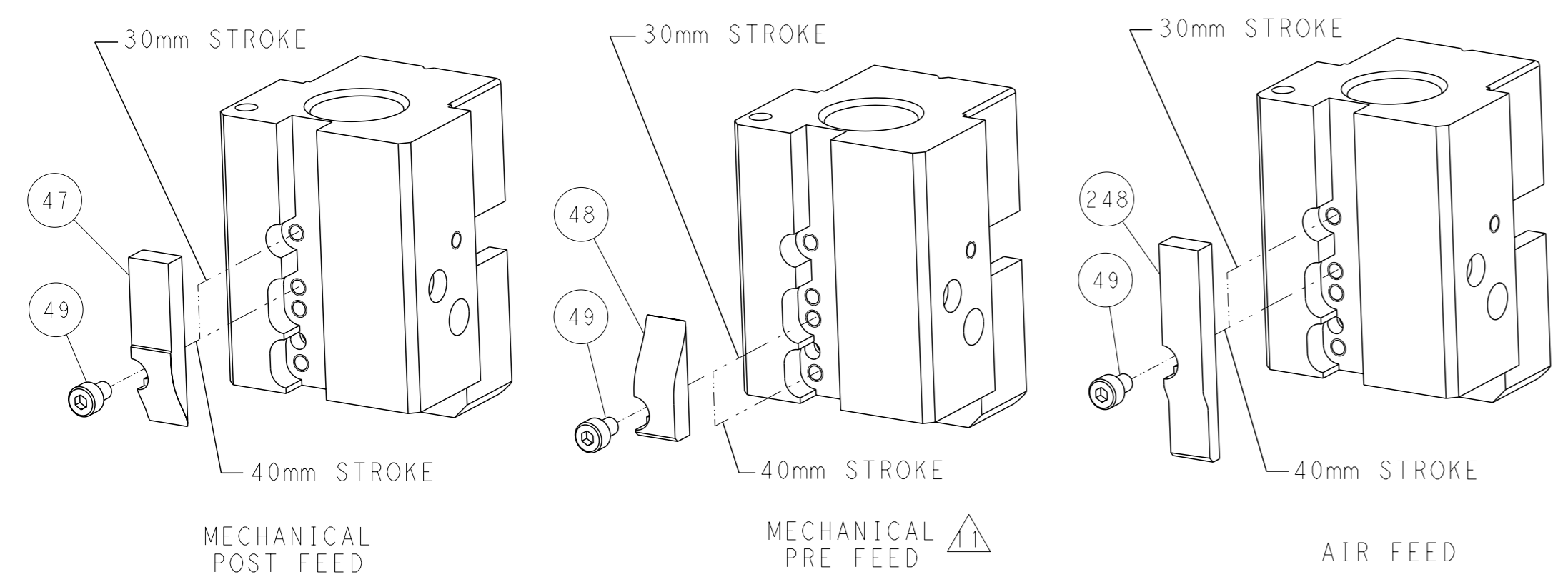
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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

| | | | | | | | |
|-------------|---------|--|---------|--|---------|--------------------------------|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN M. HERR 16NOV2016 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | APVD T. ELBIN 16NOV2016 | | NAME Ocean End Feed Applicator | |
| | | | | PRODUCT SPEC | | SIZE CAGE CODE DRAWING NO | |
| | | | | APPLICATION SPEC | | A1 00779 C=2150756 | |
| | | | | WEIGHT | | RESTRICTED TO | |
| | | | | Customer Accessible Production Drawing | | SCALE 1:1 SHEET 2 of 4 REV A | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2150756-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-1 | - | 2119641-2 | - | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150756-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150756-4 | - | - | - |
| | 2-2150756-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150756-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150756-4 | - | - | - |
| | 2-2150756-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-1 | - | 2119641-2 | - | 2063440-1 |
| | 2-2150756-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2150756-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|-----------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm (.110) | F |
| INSUL | - | - |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: GMG TERMINAL | | TE CRIMP SPECIFICATION | |
|--------------------------------------|---------------|------------------------------|--------------|
| TERMINAL NAME: FACETTED SINGLE CRIMP | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.24-6.00 mm (.206-.236 IN) | | Ø2.20-3.00 mm (.087-.118 IN) | |
| TERMINAL APPLICATION SPECIFICATION | NONE | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | GMG TERMINAL | TE TERMINAL | GMG TERMINAL |
| 2303686-1 | 33021.50.08.1 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 2.50mm2 | 2.19+/-0.05 [1.086+/-0.002] | 5.1 |
| 2.00mm2 | 2.08+/-0.05 [1.082+/-0.002] | 6.5 |
| 1.50mm2 | 1.89+/-0.05 [1.074+/-0.002] | 8.7 |
| 1.00mm2 | 1.73+/-0.05 [1.068+/-0.002] | 10.7 |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150756-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150756-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150756-5
- 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.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- TERMINAL LUBRICANT IS RECOMMENDED.
- WIRE STRANDING MAY OCCUR WHEN RUNNING WIRES WITH CMA 4175 OR GREATER.

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

| -77-27-25-22-21 | PART NO | DESCRIPTION | ITEM NO | | | |
|-----------------|---------|-------------|---------|-----------|-------------------------------------|-----|
| 1 | 1 | 1 | 1 | 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 | 1-22279-3 | SPRING, COMPRESSION | 246 |

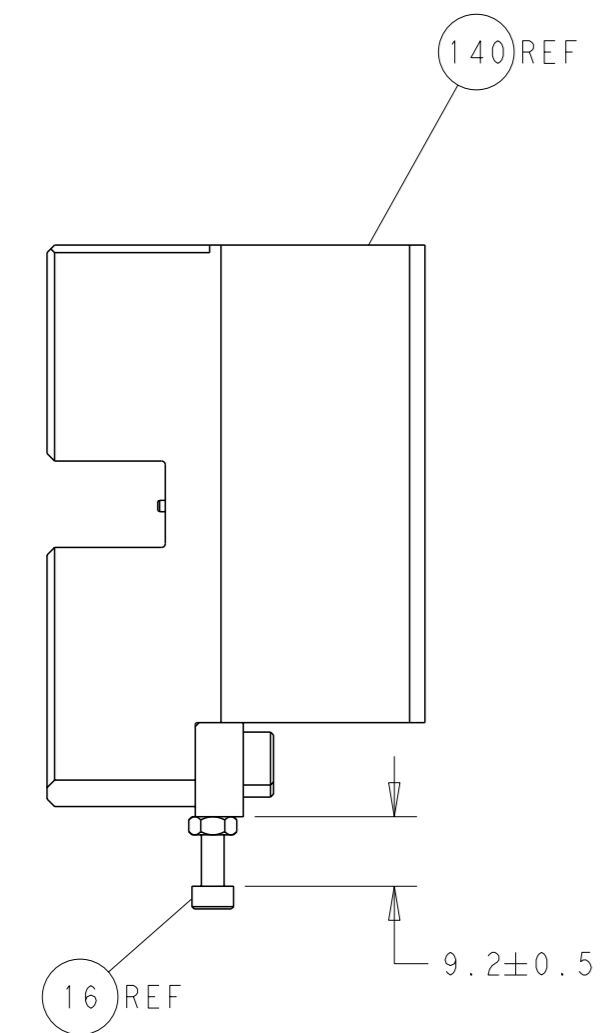
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

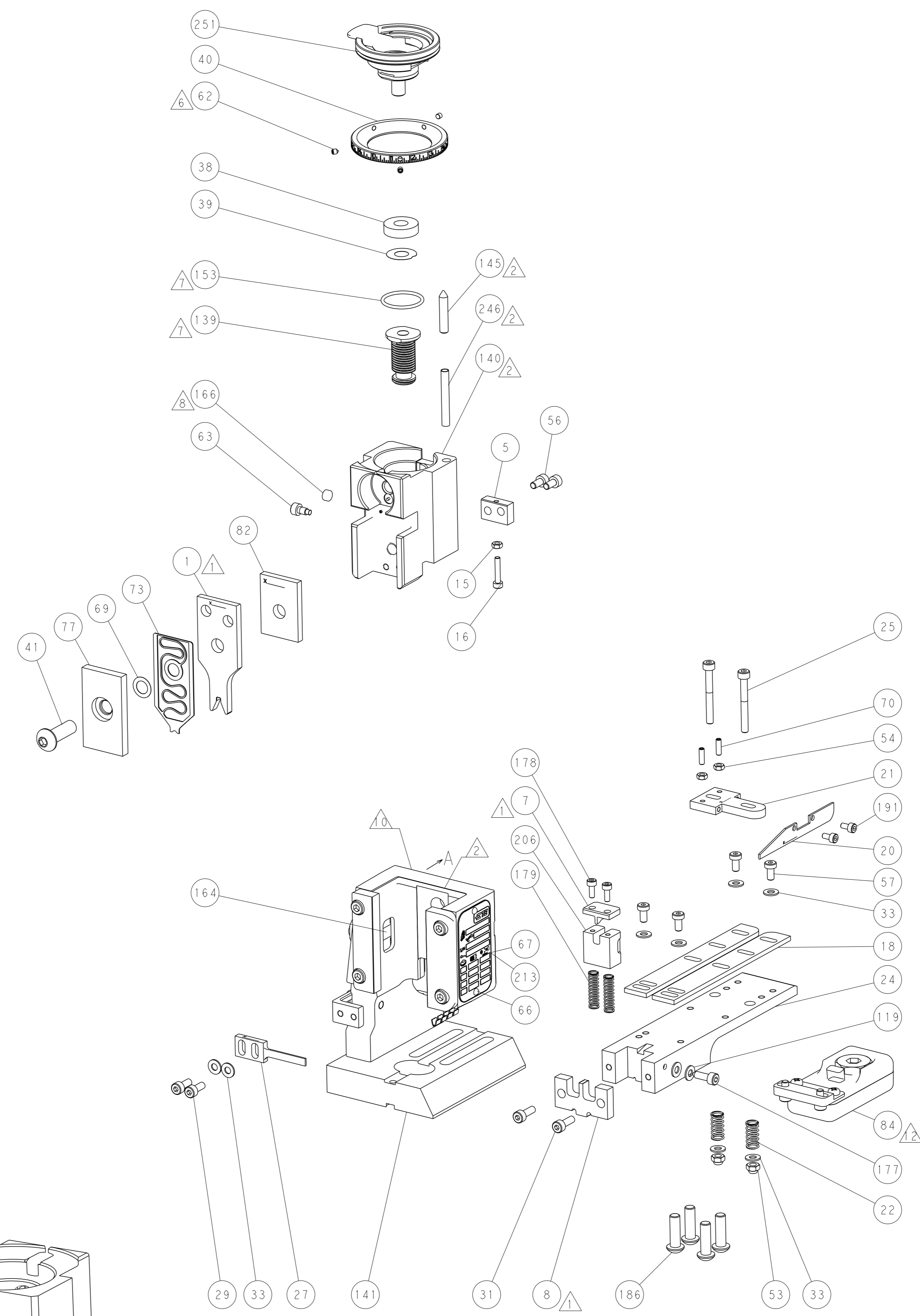
| | | | | | | | | |
|---|-----|-----|-----|-----|--|-------------|-------------------------------------|-----|
| - | - | 2 | - | - | | 2168400-7 | SHCS, LOW HEAD, RoHS, M5 X 10 | 240 |
| - | - | - | - | 1 | | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | - | 1 | | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | 1 | - | - | | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | 1 | 1 | 1 | 1 | | 1803163-1 | FLOATING SHEAR HOLDER | 206 |
| - | 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 |
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| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DRAWN | | DATE | |
|--|-----------|--|-----------------|---------------------------------|----------|-----------|-----------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | M | HERR | 16NOV2016 | 16NOV2016 |
| | 3 PLC ± | 4 PLC ± | ANGLES FINISH * | CHK | T. ELBIN | 16NOV2016 | 16NOV2016 |
| MATERIAL | WEIGHT | SCALE | SHEET | APV | T. ELBIN | 16NOV2016 | 16NOV2016 |
| Customer Accessible Production Drawing | SCALE 1:1 | SHEET 3 of 4 | REV A | NAME: Ocean End Feed Applicator | | | |
| Customer Accessible Production Drawing | | | | SCALE 1:1 SHEET 3 of 4 REV A | | | |

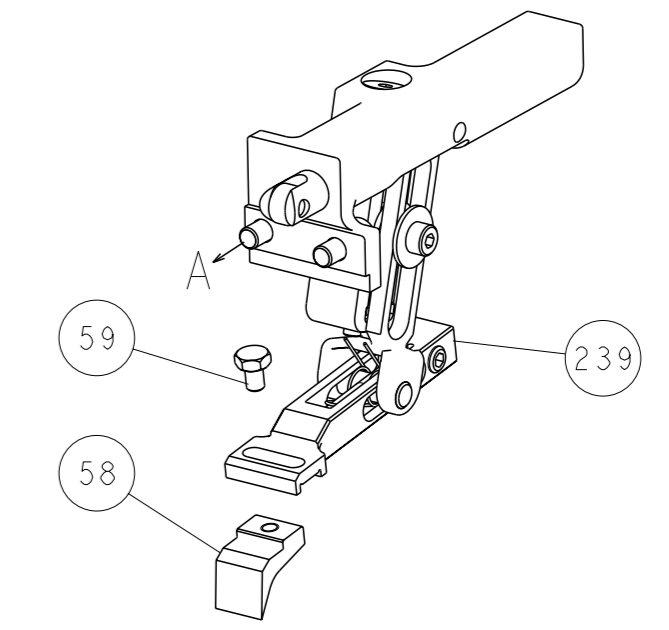
| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LYR | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | | | |



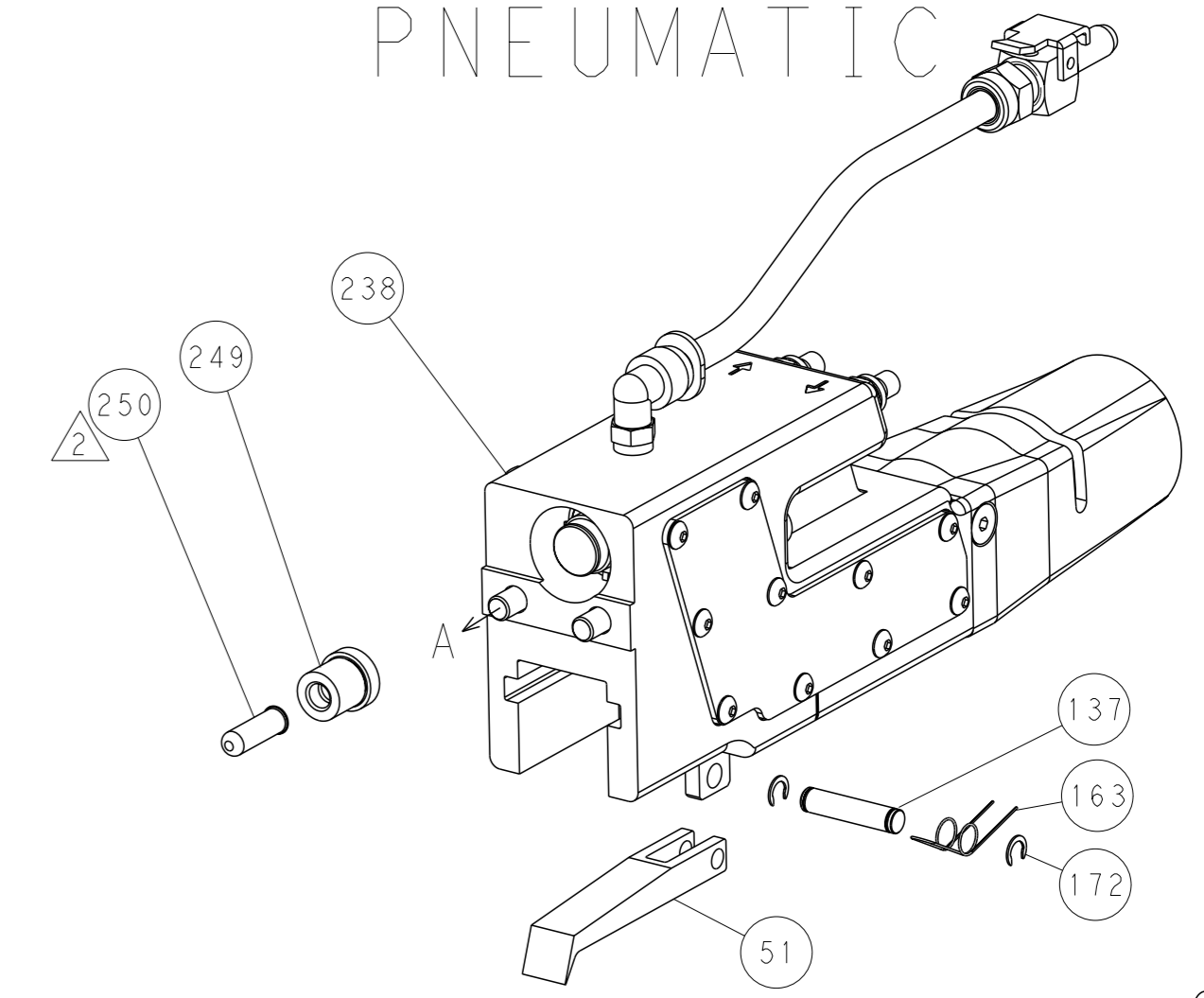
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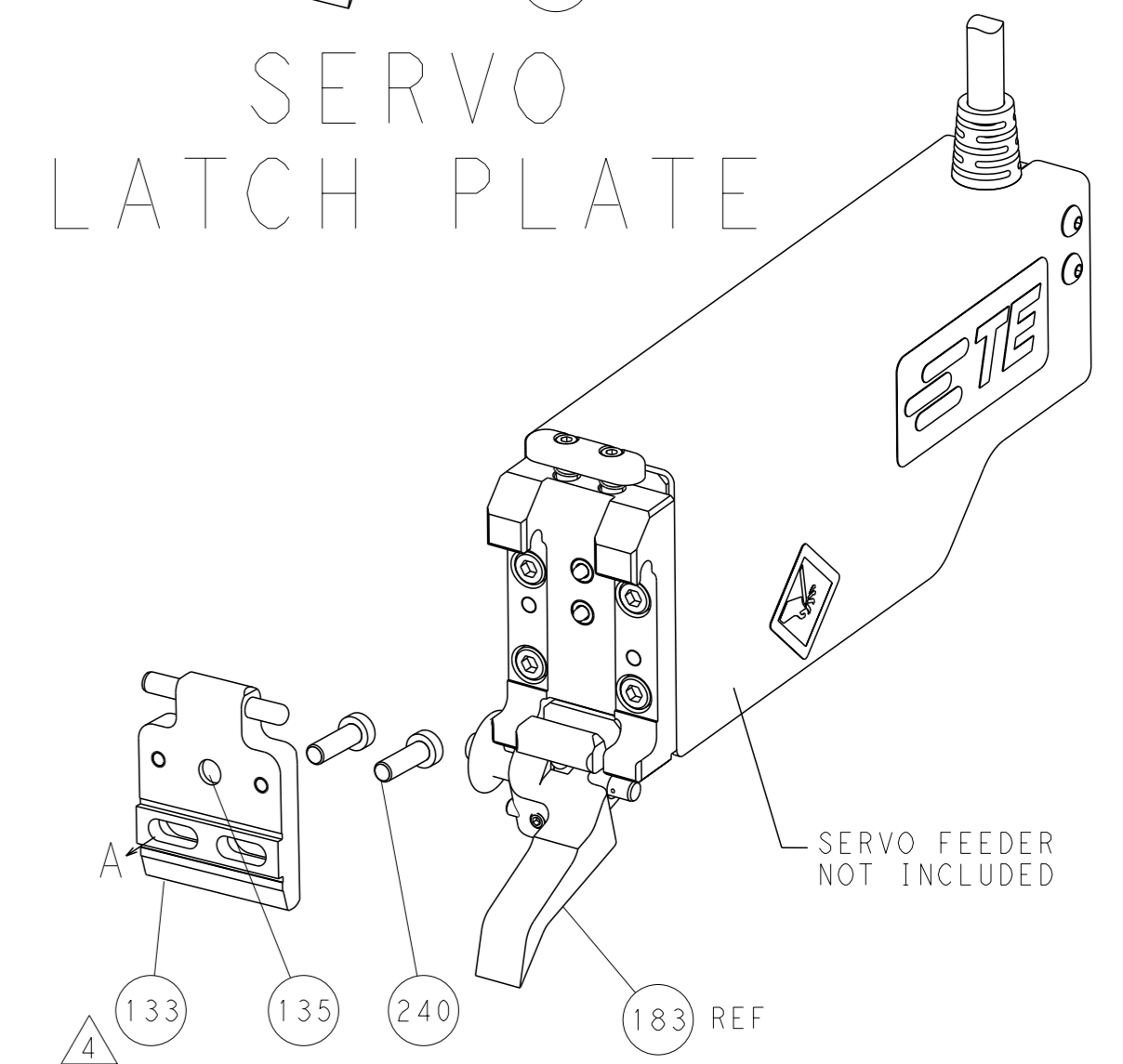
FEED TYPE
MECHANICAL



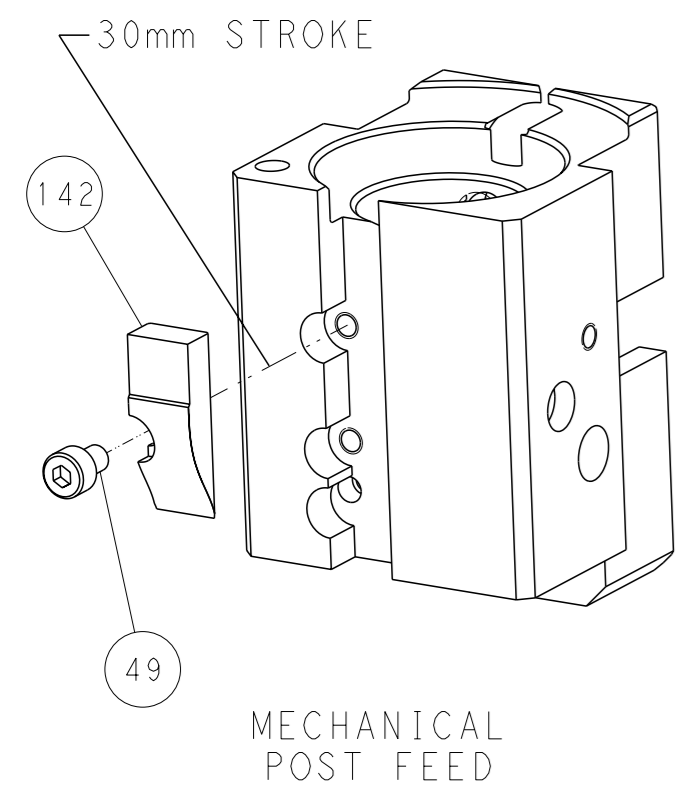
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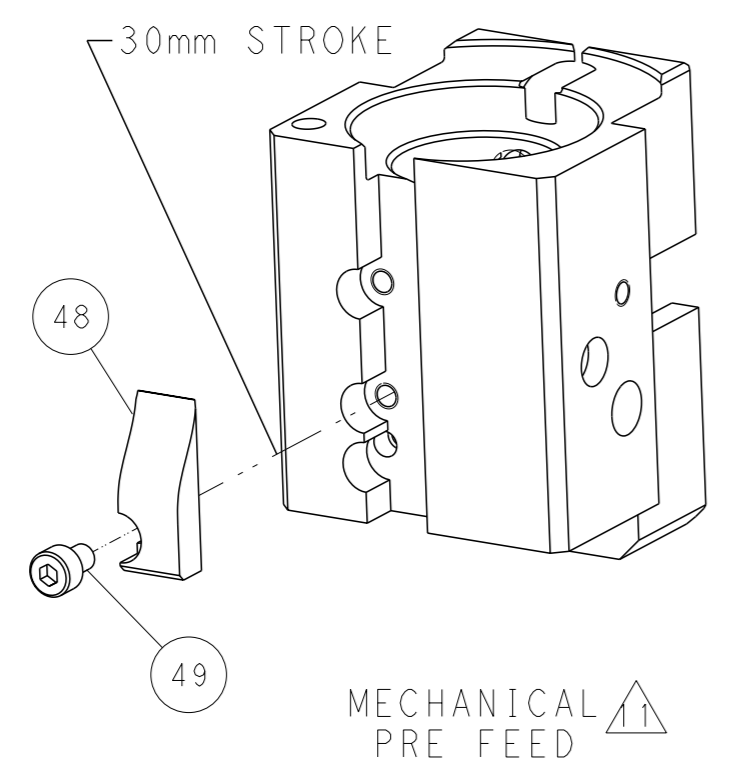
SERVO
LATCH PLATE



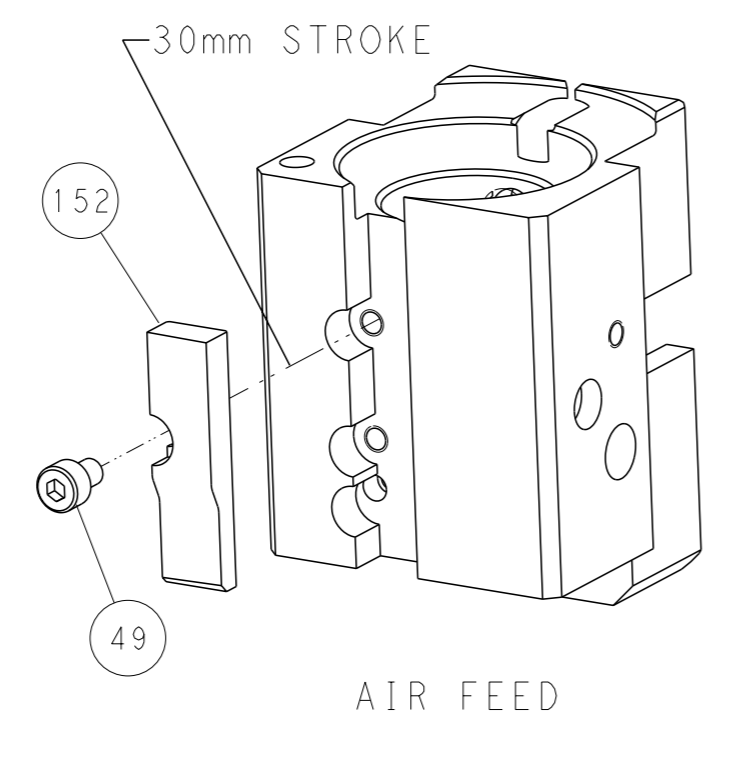
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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: | | OWN M. HERR 16NOV2016 | | STE TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | NAME | Harrisburg, PA 17105-3608 |
| | ANGLES | FINISH | | APVD T. ELBIN 16NOV2016 | PRODUCT SPEC | Ocean End Feed Applicator | |
| MATERIAL | | WEIGHT | | SCALE | 1:1 | SHEET | 4 of 4 |
| | | | | CAGE CODE | 00779 | DRAWING NO | 2150756 |
| Customer Accessible Production Drawing | | | | RESTRICTED TO | | | |