

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
|---|-------------|--------------------------|--------------------------|-------------------|-------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | 2150498-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-8 | - | 2119641-1 | - | 2063440-1 |
| | 2150498-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150498-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150498-4 | - | - | |
| | | | | | MECHANICAL FEED | 2119949-1 | 2063961-3 | 5-18022-5 | 2119653-1 | - | - |
| | 2150498-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150498-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150498-4 | - | - | |
| | 2150498-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 2063961-3 | 5-18022-5 | 2119653-1 | - | - |
| 2150498-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | PNEUMATIC FEED | 2119950-1 | 2119792-8 | - | 2119641-1 | - | 2063440-1 | |
| 7-2150498-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 5.33 mm [.210] | F |

APPLICATOR INSTRUCTIONS 408-10390

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|---------------------------|----------------|
| TERMINAL NAME: .250 SERIES RECEPTACLE, ECONOSEAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.00-5.50 mm [.197-.217 IN] | | | |
| TERMINAL APPLICATION SPECIFICATION | 114-3036 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL |
| 344070-1 | | | 344095-1 |
| | | | 347707-1 |
| | | | CABLE DIAMETER |
| | | | Ø1.6 TO 2.4 |
| | | | Ø1.6 TO 2.4 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 1.50mm2 | 1.65+/-0.05 [.065+/- .002] | 4.9 |
| 1.00mm2 | 1.45+/-0.05 [.057+/- .002] | 7.0 |
| 0.75mm2 | 1.35+/-0.05 [.053+/- .002] | 8.0 |
| 0.50mm2 | 1.24+/-0.05 [.049+/- .002] | 9.4 |

- 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: 8-2150498-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150498-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150498-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150498-6
- 5 ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 180.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 12 WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT
- 13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

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

| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |
|-----|----|----|----|----|----|-----------|--------------------------------------|---------|
| - | - | 1 | - | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 |
| - | 1 | - | 1 | 1 | 1 | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252 |
| - | - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | 1 | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| - | - | - | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | - | 1 | 1 | 1 | 2119798-1 | DETENT PIN | 247 |
| - | 1 | - | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | 1 | - | - | - | 2119759-1 | RAM, AMP STYLE, END FEED, NON-ADJUST | 245 |

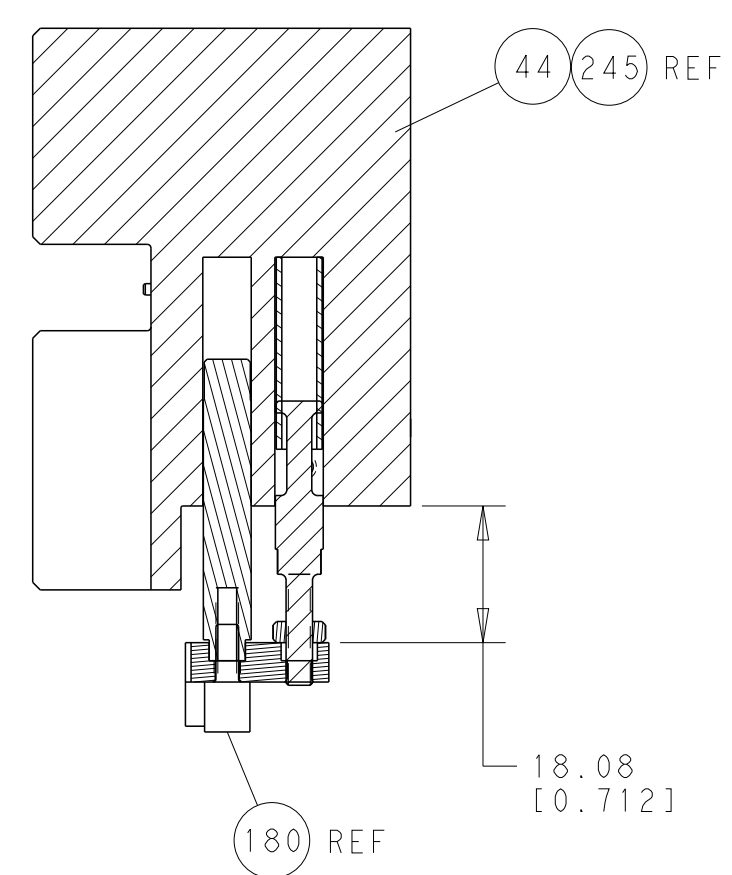
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS | | | | | |
|--------------|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-2 | A | 66 | P | LTM | DESCRIPTION | DATE | OWN | APVD |
| | | | B | | ECR-14-018341 | 15DEC2014 | MR | GB |

| | | | | | | | | | |
|---|--------|--------|--------|--------|--------|-------------|-------------------------------------|--------------------------|----|
| - | 1 | 1 | 1 | 1 | 1 | 2119082-3 | 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 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-1752354-1 | STANDOFF, HOLD-DOWN | 180 | |
| - | 1 | 1 | 1 | 1 | 1 | 6-993111-6 | PIN, SLOTTED SPRING 3.0 X 14.0 | 177 | |
| - | 1 | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 | |
| - | 1 | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 | |
| - | 1 | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 | |
| - | - | - | - | 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 | |
| - | 1 | 1 | 1 | 1 | 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 | |
| - | REFREF | REFREF | REFREF | REFREF | REFREF | 994970-2 | COUNTER, MAGNETIC | 164 | |
| - | - | - | - | - | 1 | 240638-1 | SPRING, FEED FINGER | 163 | |
| - | - | - | - | - | 1 | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 | |
| - | - | REFREF | - | - | - | SEE NOTE 4 | MEMORY CHIP, PROGRAMMED | 135 | |
| - | - | 1 | 1 | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 | |
| - | 1 | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119956-2 | DOCUMENTATION PACKAGE | 71 | |
| - | 2 | 2 | 2 | 2 | 2 | 2-18032-2 | SCR, SET, FLT POINT M3 X 10.0 | 70 | |
| - | 1 | - | - | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 | |
| - | 2 | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 | |
| - | 1 | 1 | 1 | 1 | 1 | 1901681-1 | HOLDDOWN, TERMINAL | 65 | |
| - | 2 | 2 | 2 | 2 | 2 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 64 | |
| - | 1 | - | 1 | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 | |
| - | 3 | - | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62 | |
| - | 1 | 1 | 1 | 1 | 1 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 | |
| - | - | - | - | - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | |
| - | - | - | - | - | 1 | 2063961-3 | FEED FINGER | 58 | |
| - | 3 | 3 | 3 | 3 | 3 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 | |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 56 | |
| - | 2 | 2 | 2 | 2 | 2 | 5018030-2 | NUT, HEX, REG, RoHS, M4 | 55 | |
| - | 2 | 2 | 2 | 2 | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 | |
| - | 2 | 2 | 2 | 2 | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 | |
| - | - | - | - | - | 1 | 2119792-8 | 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 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 | |
| - | 1 | - | 1 | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 | |
| - | 7 | 7 | 7 | 7 | 7 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 | |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 31 | |
| - | 2 | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 29 | |
| - | 1 | 1 | 1 | 1 | 1 | 240639-1 | STRIPPER (MACHINING) | 27 | |
| - | 2 | 2 | 2 | 2 | 2 | 1320906-1 | STUD, THREADED | 25 | |
| - | 1 | 1 | 1 | 1 | 1 | 1752371-5 | PLATE, STRIP GUIDE | 24 | |
| - | 1 | 1 | 1 | 1 | 1 | 240825-1 | PLATE, STRIP HOLD DOWN | 23 | |
| - | 2 | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 | |
| - | 1 | 1 | 1 | 1 | 1 | 1752373-4 | DRAG | 20 | |
| - | 2 | 2 | 2 | 2 | 2 | 1901259-7 | GUIDE, LOWER STRIP | 18 | |
| - | 4 | 4 | 4 | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 | |
| - | 1 | 1 | 1 | 1 | 1 | 1752360-1 | SPACER, HOLD-DOWN | 13 | |
| - | 1 | 1 | 1 | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 | |
| - | - | - | - | - | - | - | - | 10 | |
| - | 1 | 1 | 1 | 1 | 1 | 690482-6 | PLATE, FRONT SHEAR | 9 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-1333216-8 | ANVIL, COMBINATION | 8 | |
| - | 1 | 1 | 1 | 1 | 1 | 2217206-4 | BLADE, SLUG | 7 | |
| - | - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-240641-4 | SPACER | 5 | |
| - | 1 | 1 | 1 | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 | |
| - | 1 | 1 | 1 | 1 | 1 | 1633961-1 | CRIMPER, INSULATION F PREMIUM | 3 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-455888-8 | SPACER, CRIMPER | 2 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-456405-5 | CRIMPER, WIRE PREMIUM | 1 | |

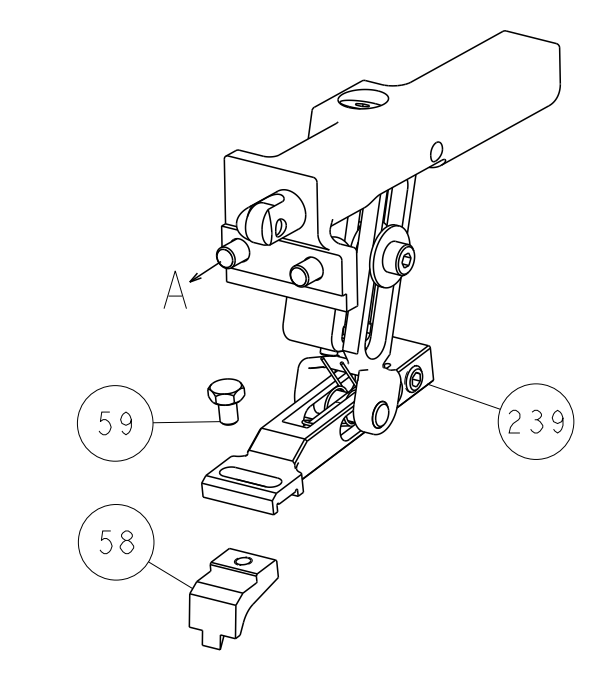
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: | |
|-----------------|-----------|--|-------------|-------------|--------------|---------------|--------|---------|--|--------|--|
| mm | 0 PLC ±.5 | 1 PLC ±.13 | 2 PLC ±.013 | 3 PLC ±.013 | 4 PLC ±.0001 | ANGLES ±.0001 | FINISH | | | | |
| APPLICATOR DATA | | APPLICATION SPEC | | MATERIAL | | FINISH | | WEIGHT | | SCALE | |
| A | | A | | A | | A | | A | | A | |

| LOC | DIST | REV | DESCRIPTION | DATE | OWN | APVD |
|-----|------|-----|-------------|------|-----|------|
| A | 66 | | SEE SHEET 1 | | | |

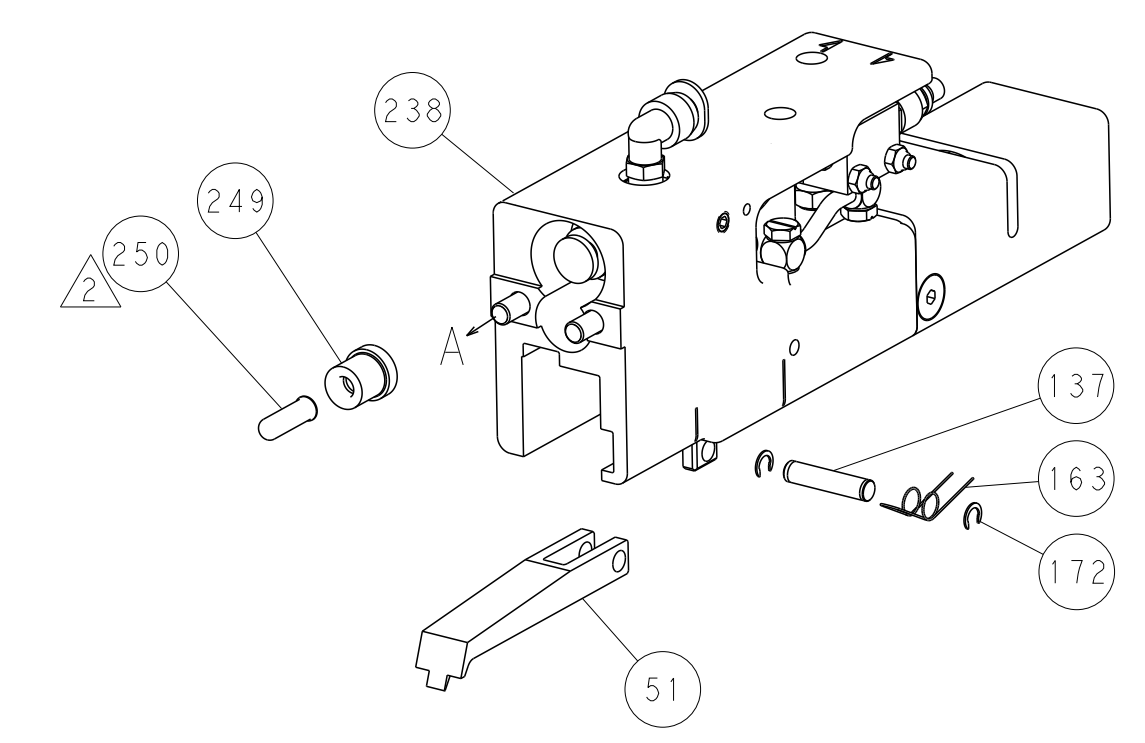


HOLDDOWN SET-UP

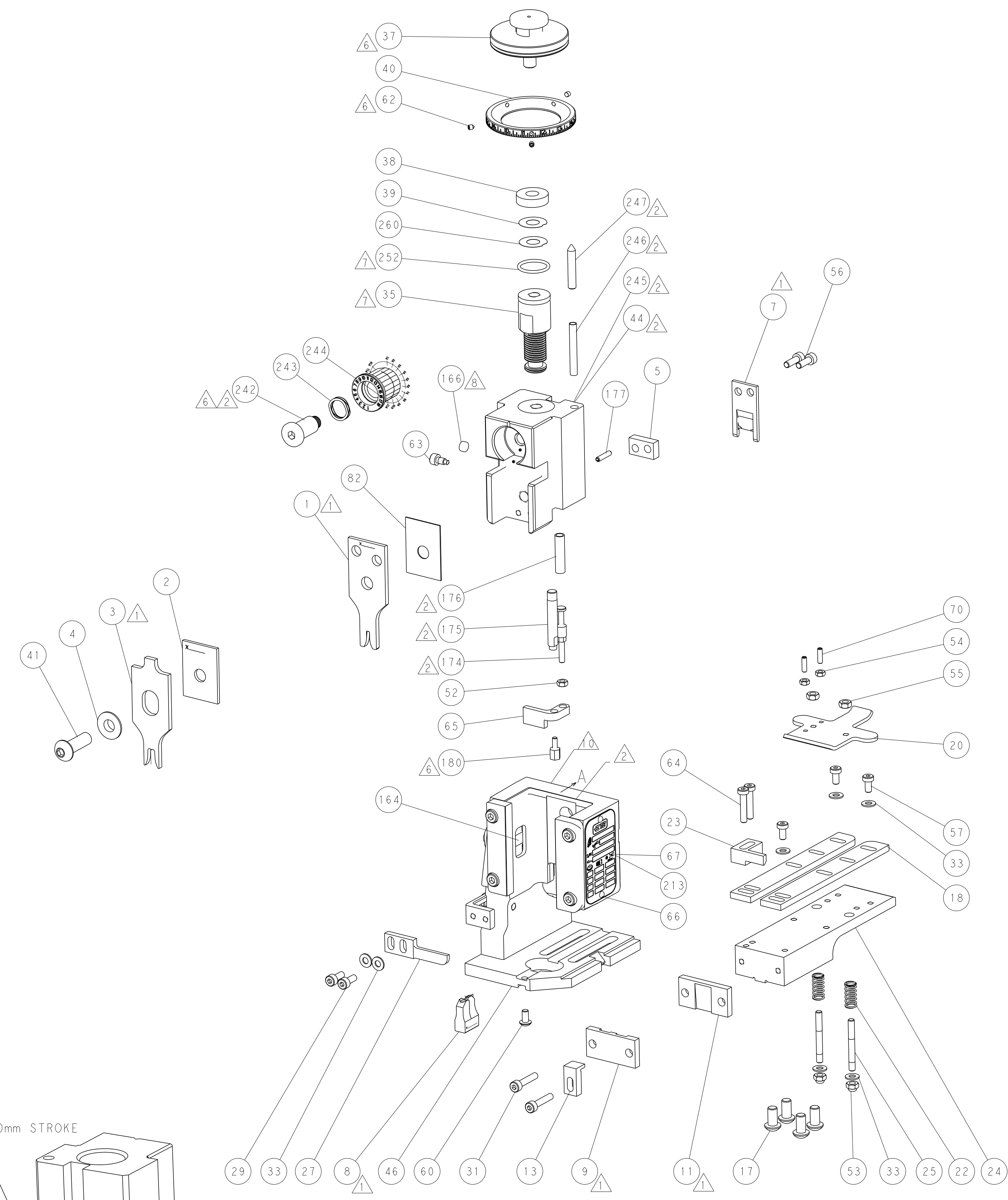
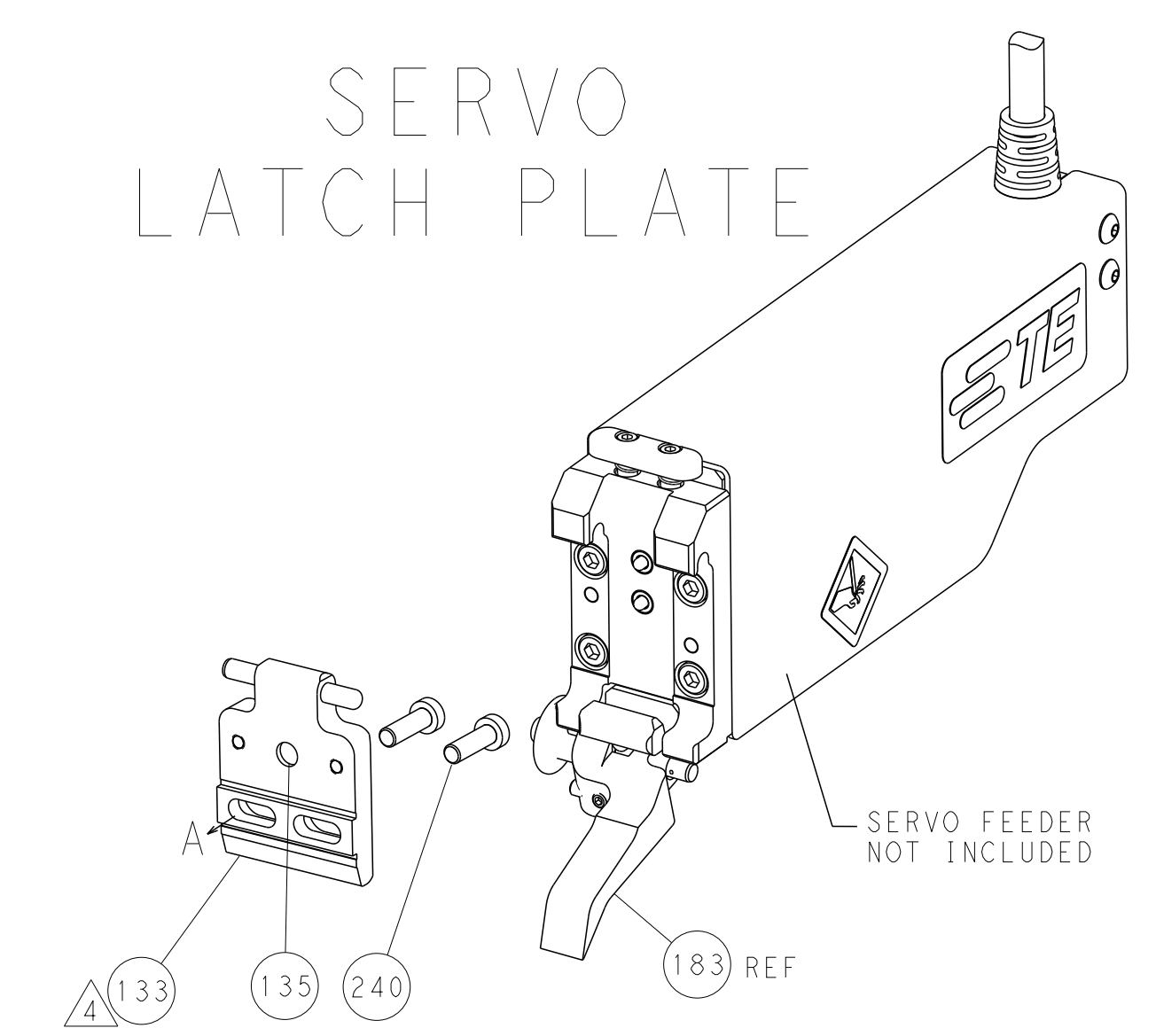
FEED TYPE
MECHANICAL



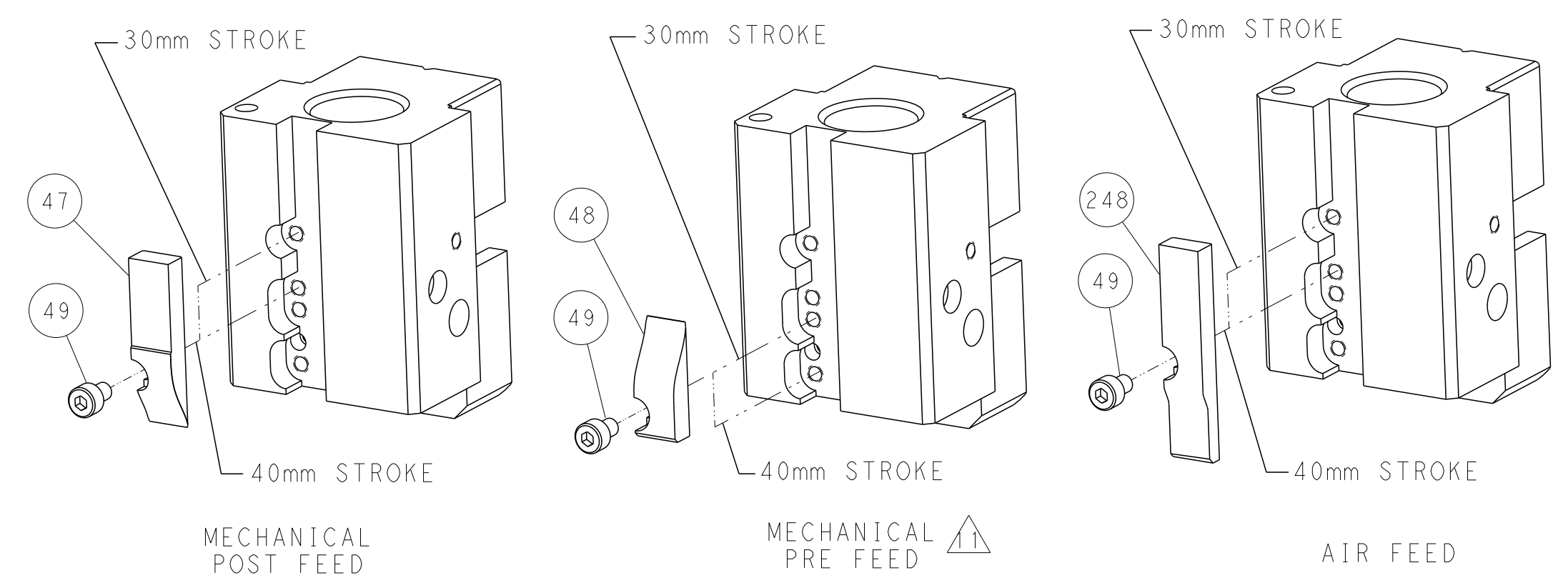
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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

| | | | | | | | | | |
|-------------------|--|--|--|--|--|--|--|---|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001 | | DWG: R. O. WILSON 15OCT2014 CHK: G. J. HOFFNER 16OCT2014 APVD: T. L. ELBIN 16OCT2014 | | NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150498 | | RESTRICTED TO: - SCALE: 1:1 SHEET: 2 OF 4 REV: B | |
| MATERIAL: - | | | | WEIGHT: - | | Customer Accessible Production Drawing | | | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2150498-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-8 | - | 2119641-2 | - | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150498-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150498-4 | - | - | - |
| | 2-2150498-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 2063961-3 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150498-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150498-4 | - | - | - |
| | 2-2150498-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 2063961-3 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-8 | - | 2119641-2 | - | 2063440-1 |
| | 2-2150498-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2150498-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 5.33 mm [.210] | F |
| APPLICATOR INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|---------------------------|----------------|
| TERMINAL NAME: .250 SERIES RECEPTACLE, ECONOSEAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.00-5.50 mm [.197-.217 IN] | | ∅ | ∅ |
| TERMINAL APPLICATION SPECIFICATION | 114-3036 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL |
| 344070-1 | | | 344095-1 |
| | | | 347707-1 |
| | | | CABLE DIAMETER |
| | | | ∅1.6 TO 2.4 |
| | | | ∅1.6 TO 2.4 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 1.50mm2 | 1.65 +/- 0.05 [.065 +/- .002] | 4.9 |
| 1.00mm2 | 1.45 +/- 0.05 [.057 +/- .002] | 7.0 |
| 0.75mm2 | 1.35 +/- 0.05 [.053 +/- .002] | 8.0 |
| 0.50mm2 | 1.24 +/- 0.05 [.049 +/- .002] | 9.4 |

- 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: 8-2150498-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150498-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150498-5
- 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 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

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

| | | | | | | | |
|------|-----|-----|-----|----|-----------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | 1 | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| - | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 1 | 2119082-3 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| -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)

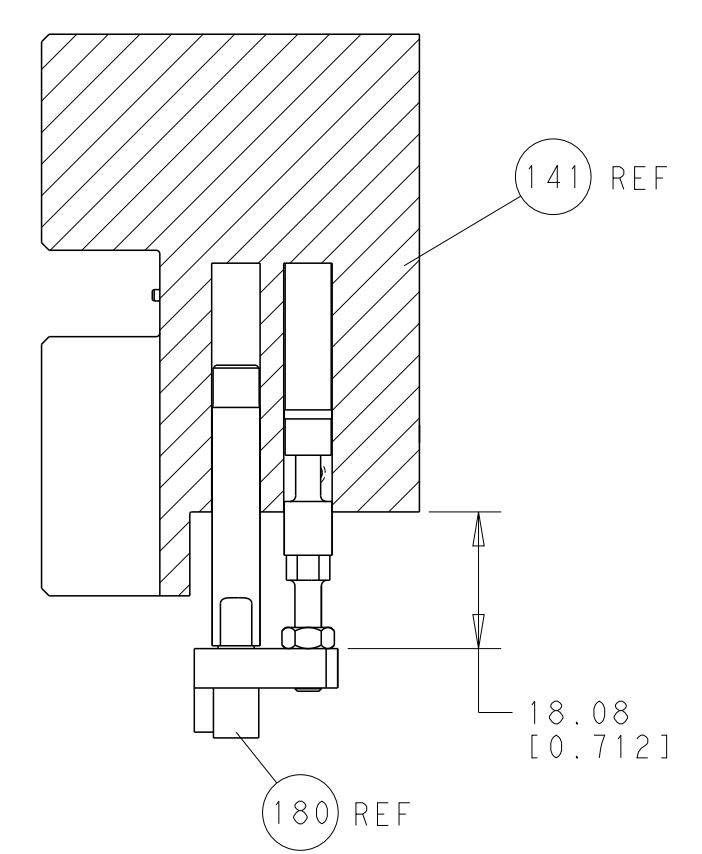
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-2 | A | 66 | REV | DATE | BY | APPV |
| | | | - | SEE SHEET 1 | - | - |

| | | | | | | | | |
|------|-----|-----|-----|-----|---------|-------------|-------------------------------------|-----|
| | - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| | - | - | 2 | - | - | 2168400-7 | SHCS, LOW HEAD, RoHS, M5 X 10 | 240 |
| | - | - | - | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| | - | - | - | - | 1 | 2063440-1 | AIR FEED MODULE | 238 |
| | - | - | 1 | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| | - | 4 | 4 | 4 | 4 | 2079383-9 | SCR, BHSC, RoHS (M6 X 20) | 186 |
| | - | - | REF | - | - | 1901697-1 | FEED FINGER ASSEMBLY, EF | 183 |
| | - | 1 | 1 | 1 | 1 | 1-1752354-1 | STANDOFF, HOLD-DOWN | 180 |
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| -77- | 27- | 25- | 22- | 21 | PART NO | DESCRIPTION | ITEM NO | |

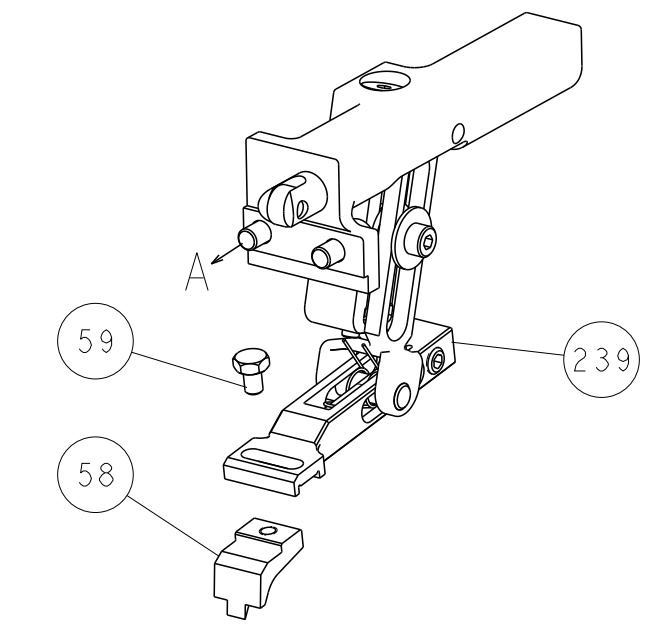
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG | | CHK | | APVD | | NAME | |
|--|---------------|--|-----------|------------|-----------|--------------|-----------|---------------|-----------|--|---------------|
| mm | 0 PLC ±.5 | 1 PLC ±.3 | 2 PLC ±.2 | 3 PLC ±.15 | 4 PLC ±.1 | R. O. WILSON | 15OCT2014 | G. J. HOFFNER | 16OCT2014 | STE TE Connectivity Harrisburg, PA 17105-3608 | |
| | ANGLES ±.0001 | FINISH | | | | I. L. ELBIN | 16OCT2014 | | | Ocean End Feed Applicator | |
| MATERIAL | | | | | | | | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| | | | | | | | | A1 | 00779 | ©=2150498 | |
| Customer Accessible Production Drawing | | | | | | | | SCALE | 1:1 | SHEET | 3 OF 4 |

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

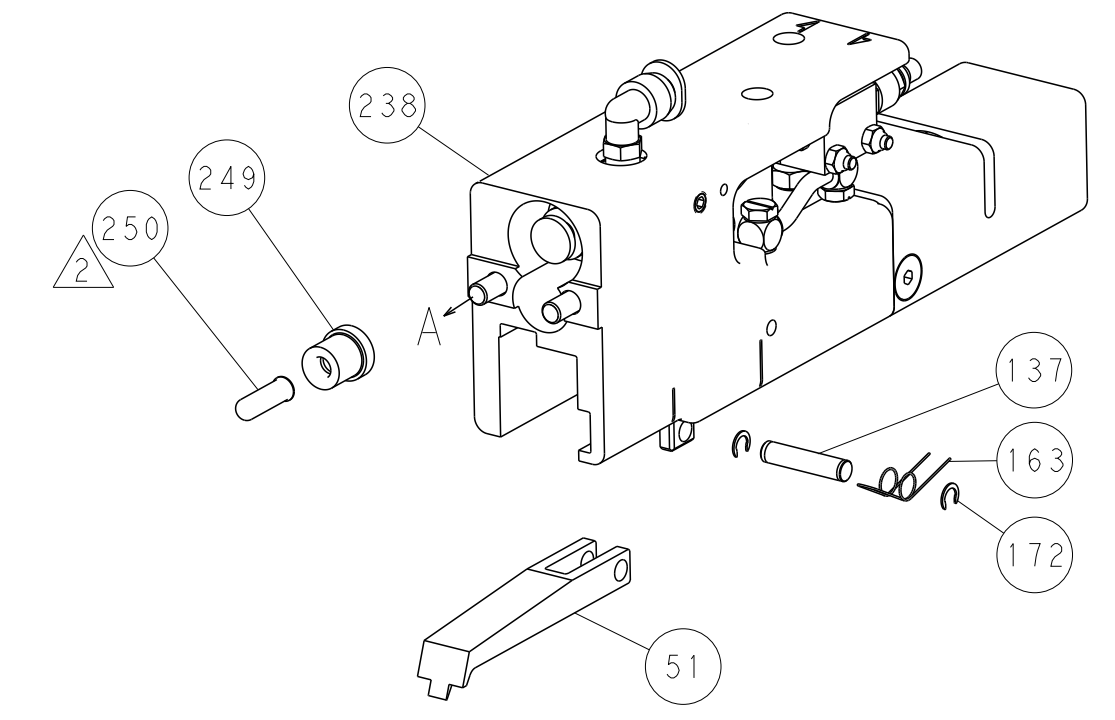
HOLDDOWN SET-UP



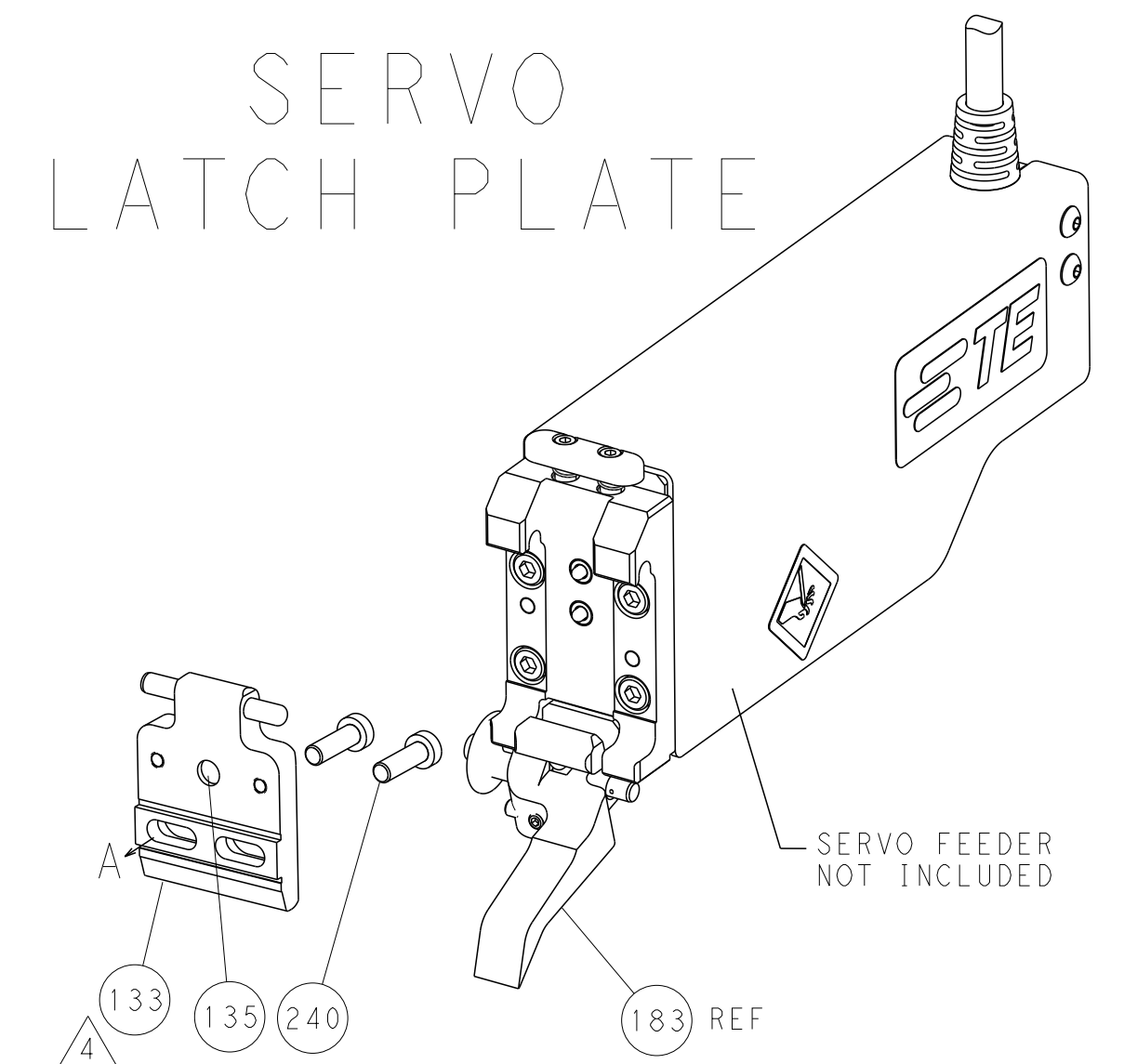
FEED TYPE MECHANICAL



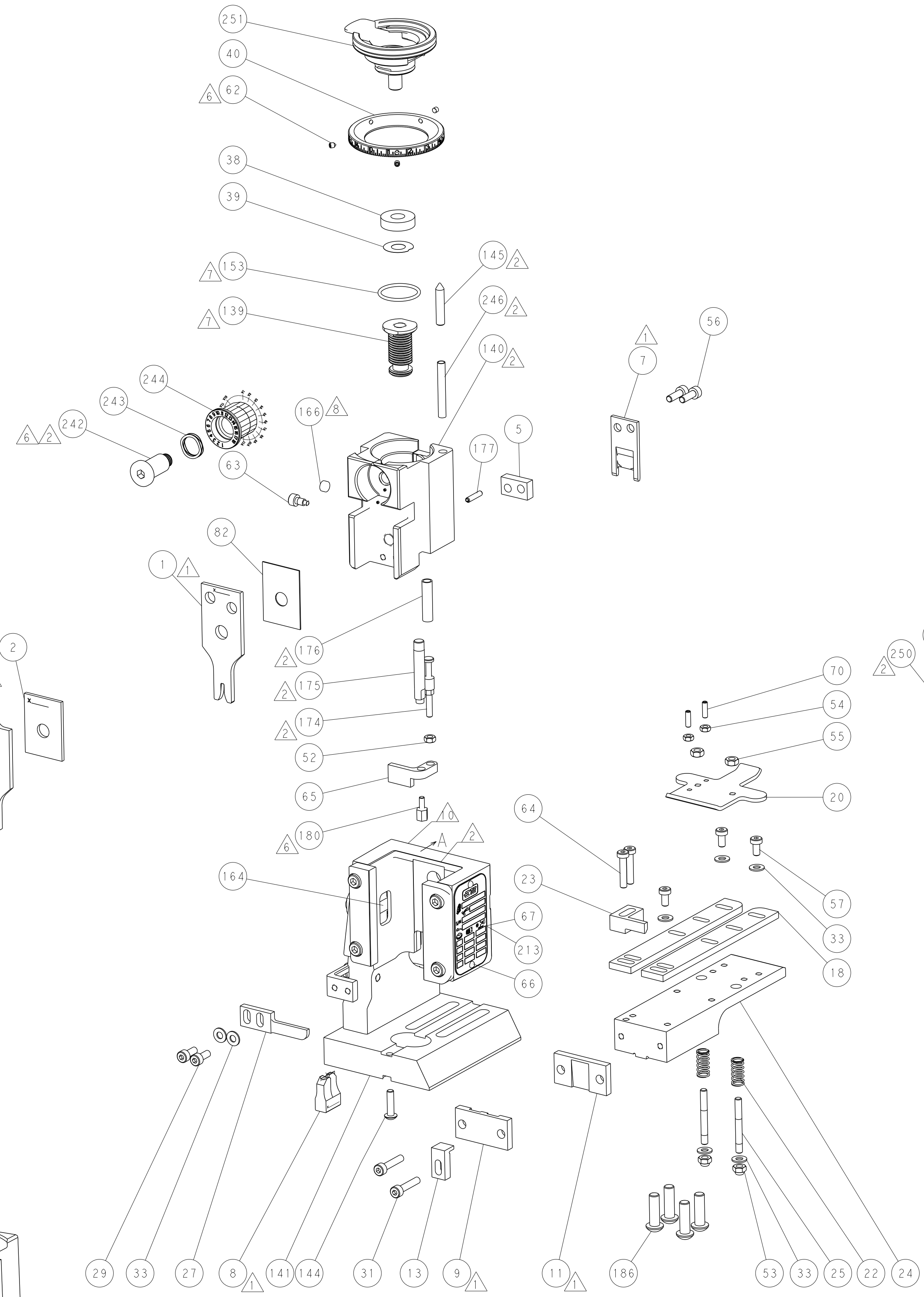
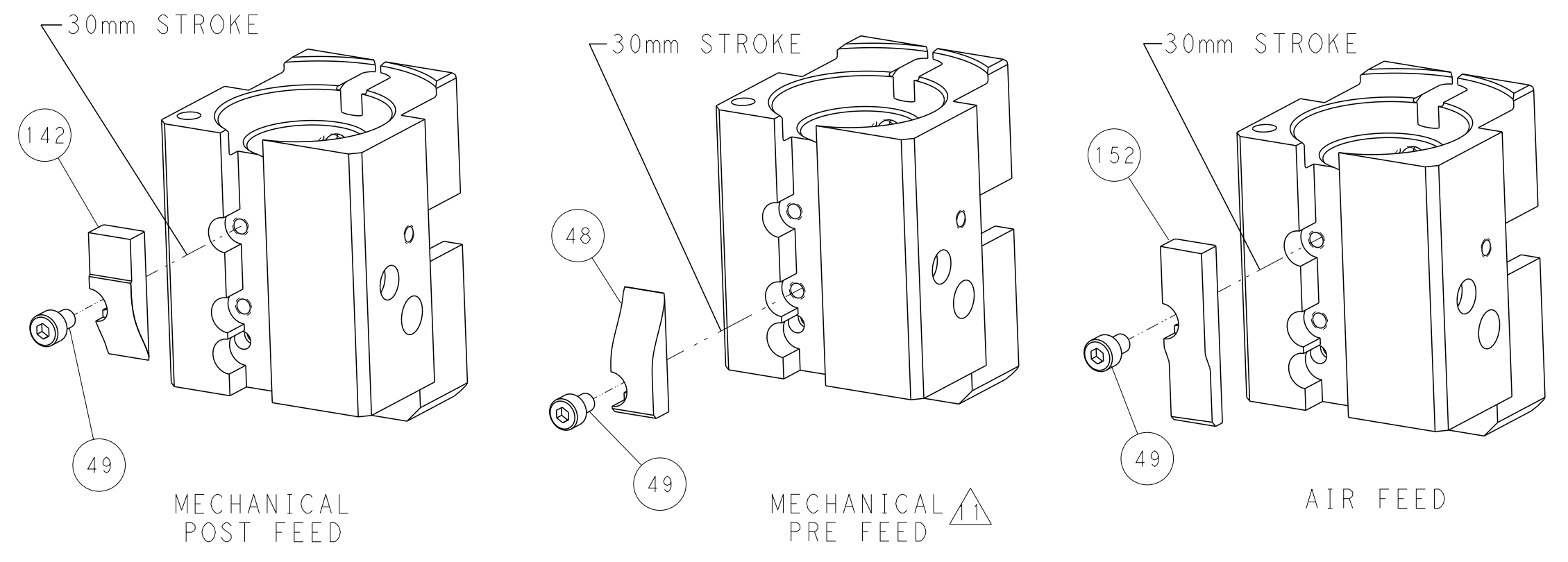
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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

| | | | | | | | |
|--|------------|--|-------------|---------------------------|---------------|---------------------------|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN R.O. WILSON 15OCT2014 | | STE TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.0013 | APVD T.L. ELBIN 16OCT2014 | Harrisburg, PA 17105-3608 |
| MATERIAL: | FINISH: | WEIGHT: | SCALE: | SIZE: | CAGE CODE: | DRAWING NO: | RESTRICTED TO: |
| | | | 1:1 | A1 | 00779 | 2150498 | |
| Customer Accessible Production Drawing | | | | SHEET 4 OF 4 REV B | | | |