

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-------------|-------------|-----------|------------------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - |
| | 2150234-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150234-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150234-4 | - | - | - |
| | | | | | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - |
| 2150234-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150234-5 | - | - | 2168400-7 (QUANTITY 2) | |
| | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150234-4 | - | - | - | |
| | | | | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - | |
| 2150234-5 | B | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - | 2063440-1 | |
| | | | | - | - | - | - | - | - | - | |
| 2150234-6 | B | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | - | |
| | | | | - | - | - | - | - | - | - | |
| 2150234-7 | B | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2150234-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.80 mm [.110] | F |
| INSUL | 4.57 mm [.180] | F |
| APPLICATOR INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION | |
|---|---|
| TERMINAL NAME: .250 SERIES FASTON RECEPTACLE | |
| WIRE STRIP LENGTH 6.00-6.80 mm [.236-.268 IN] | INSULATION DIAMETER RANGE Ø3.05-4.30 mm [1.20-.169 IN] |
| TERMINAL APPLICATION SPECIFICATION 114-20023 | - |
| TERMINALS APPLIED | |
| TE TERMINAL | TE TERMINAL |
| 280001-9 | 160808-1 |
| 1-280001-0 | 160808-2 |
| 1-280001-1 | 100605-7 |
| 1-280001-2 | 1-100605-2 |
| 160256-5 | 2-160256-1 |
| 3-160256-1 | 2-160256-2 |
| 4-160256-2 | 2-160256-2 |
| 4-160256-5 | 4-160256-8 |
| 4-160256-7 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------------------|----------------------------|--------------------------------|
| 2.50mm ² or 14 AWG | 1.98+/-0.03 [.078+/-0.001] | 5.5 |
| 2.00mm ² | 1.85+/-0.03 [.073+/-0.001] | 6.8 |
| 1.50mm ² or 16 AWG | 1.73+/-0.03 [.068+/-0.001] | 8.0 |
| 1.00mm ² or 18 AWG | 1.63+/-0.03 [.064+/-0.001] | 8.8 |
| 0.75mm ² | 1.52+/-0.03 [.060+/-0.001] | 10.0 |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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: 8-2150234-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150234-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150234-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150234-6
- 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 ITEM 50, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 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.
- 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
- 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 |
| - | - | - | - | 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 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |

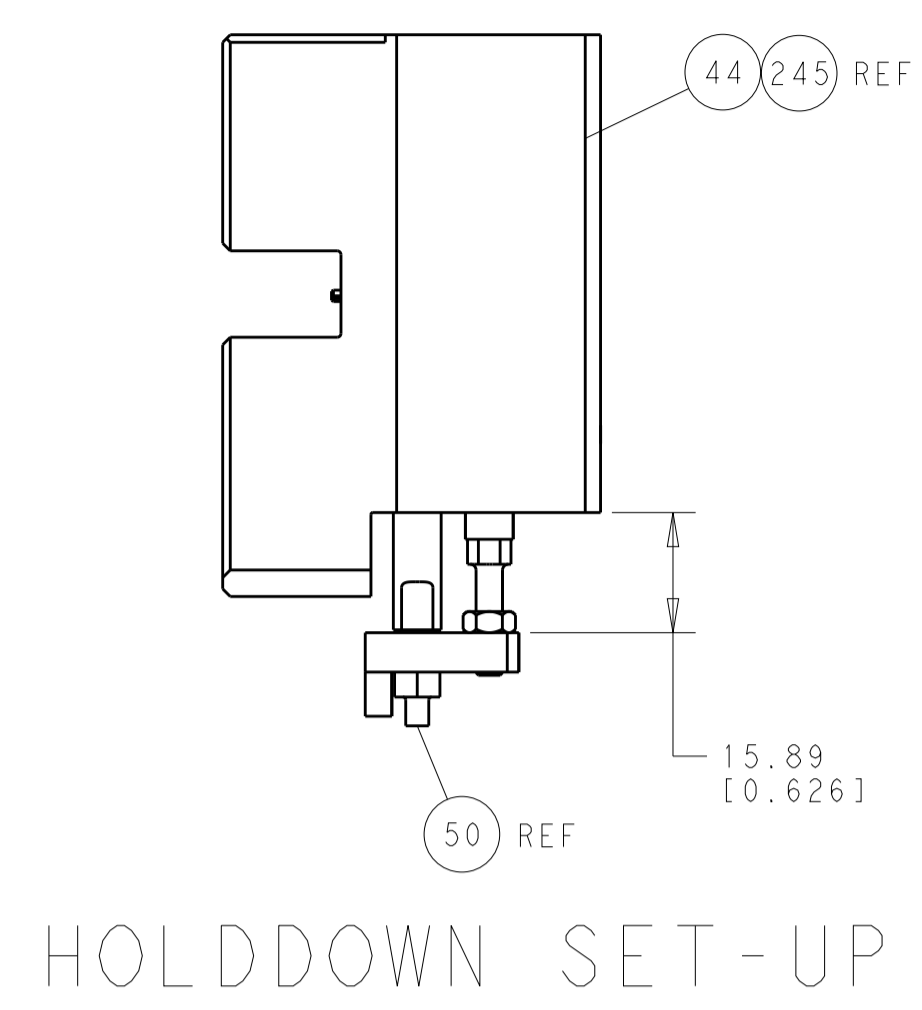
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|---------------|-----------|-------|
| 2119599-2 | A | 66 | REV | DATE | BY | APPV |
| | | | 1 | ORIGINAL | 16DEC2010 | GH TE |
| | | | A | RELEASED | 16MAY2012 | GH TE |
| | | | B | ECR-13-012585 | 07AUG2013 | BH GB |

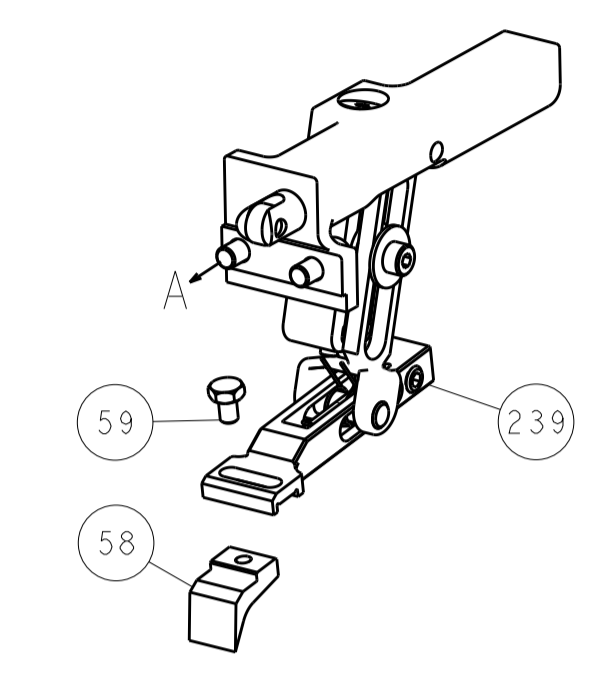
| REV | DATE | BY | APPV | DESCRIPTION | DATE | OWN | APPV | |
|-----|--------|--------|--------|-------------|--------|-------------|-------------------------------------|-----|
| - | 1 | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, 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 | 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 | 455888-6 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 2119791-9 | 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 | 1 | 1901681-5 | 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 | 2063961-1 | 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 | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | - | - | - | - | 1 | 2119792-2 | PAWL, EF, AIR | 51 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1976055-3 | STANDOFF, HOLD-DOWN | 50 |
| - | - | - | - | - | 1 | 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 | 240825-3 | 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 | 1901259-5 | 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 | 240644-9 | PLATE, REAR SHEAR | 11 |
| - | - | - | - | - | - | - | - | 10 |
| - | 1 | 1 | 1 | 1 | 1 | 2-690495-6 | PLATE, FRONT SHEAR | 9 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1338673-5 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 1 | 1-2217206-3 | BLADE, SLUG | 7 |
| - | 1 | 1 | 1 | 1 | 1 | 240641-3 | SPACER | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1 | 1 | 2119582-3 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 2 | 2 | 2 | 2 | 2 | 455888-1 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1490189-6 | CRIMPER, WIRE | 1 |

| DIMENSIONS: | TOLERANCES UNLESS OTHERWISE SPECIFIED: | OWN | CHK | APPV | DATE | NAME | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|-------------|---|---------|--|----------|------------|--|-------|-----------|------------|---------------|
| mm | 0 PLC ±.5 1 PLC ±.5 3 PLC ±.13 5 PLC ±.013 4 PLC ±.0001 ANGLES ±.1 | HOFFNER | T. ELBIN | T. ELBIN | 16DEC2011 | TE Connectivity Harrisburg, PA 17105-3608 | A1 | 00779 | ©=2150234 | - |
| MATERIAL: | FINISH: | WEIGHT: | Customer Accessible Production Drawing | | SCALE: 1:1 | SHEET 1 OF 4 | REV B | | | |

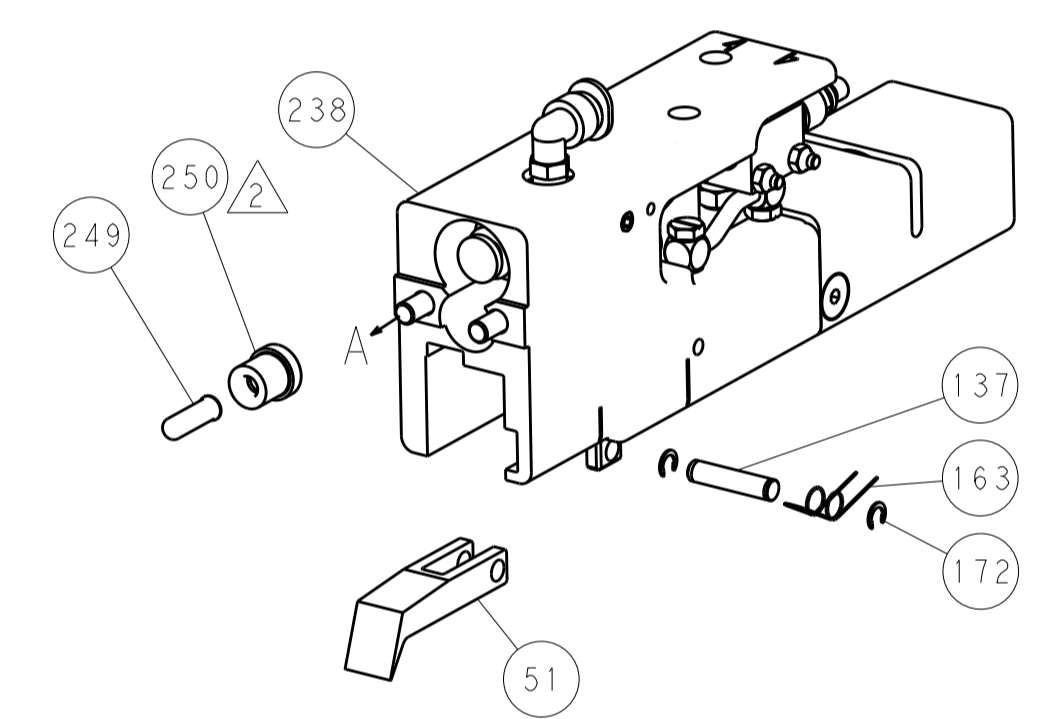
| LOC | DIST | REV | DATE | BY | APPV |
|-----------|------|-----|-------------|------|------|
| A | 66 | | | | |
| REVISIONS | | | DESCRIPTION | DATE | BY |
| - | | | SEE SHEET 1 | - | - |



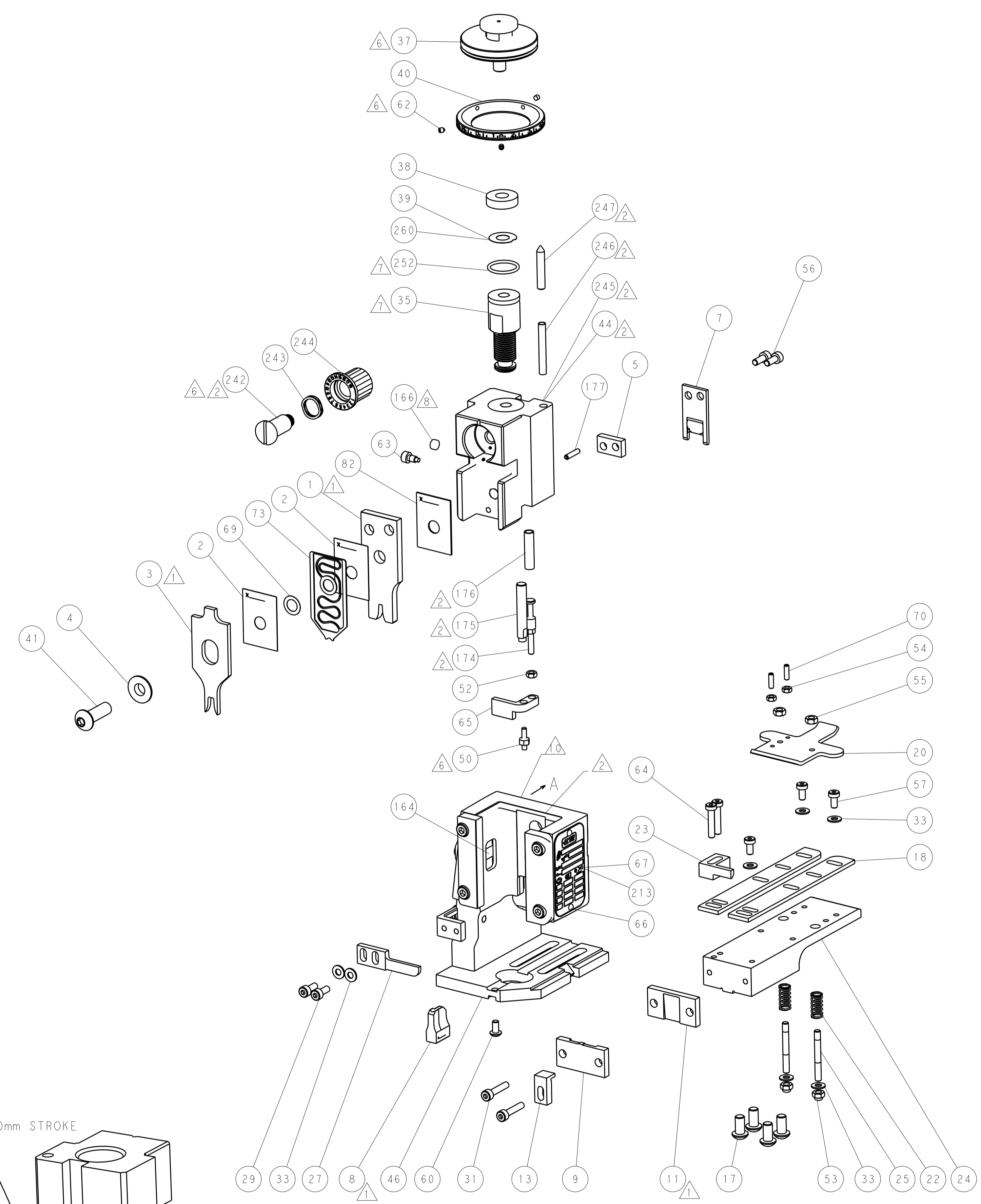
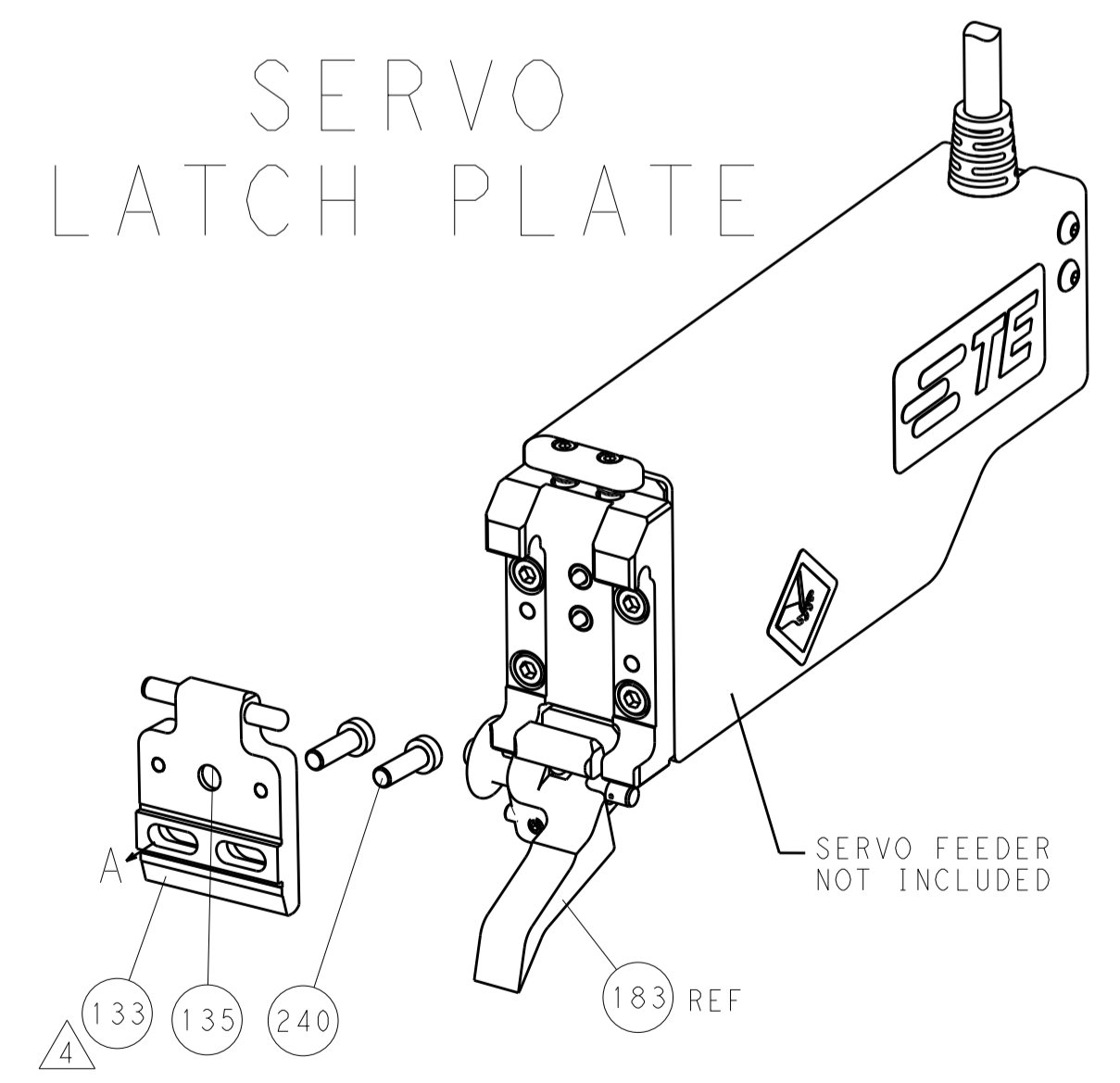
FEED TYPE MECHANICAL



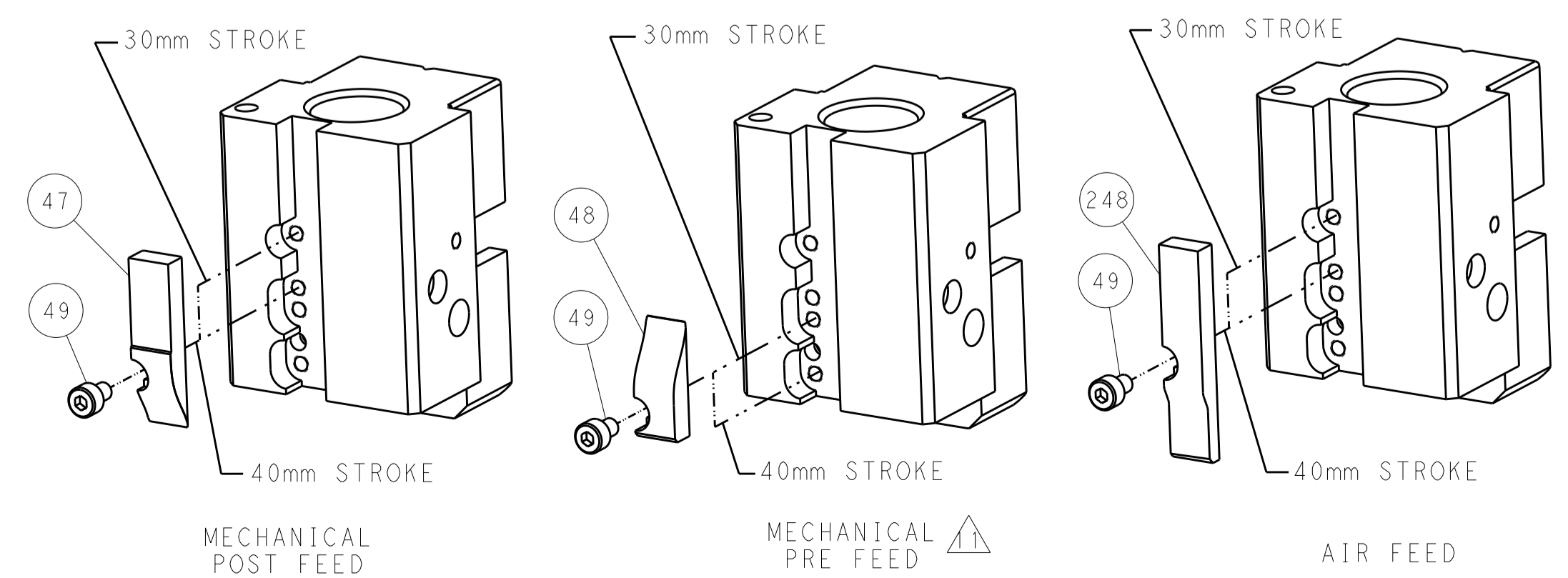
PNEUMATIC



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: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: HOFFNER 16DEC2011 | | TE Connectivity | |
| mm | | 0 PLC ±0.5 | | CHK: T. ELBIN 19DEC2011 | | Harrisburg, PA 17105-3608 | |
| Ø | | 1 PLC ±0.13 | | APPV: T. ELBIN 19DEC2011 | | NAME: Ocean End Feed Applicator | |
| H | | 3 PLC ±0.013 | | PRODUCT SPEC | | SIZE: CAGE CODE DRAWING NO | |
| ANGLES | | 4 PLC ±0.0001 | | APPLICATION SPEC | | RESTRICTED TO | |
| FINISH | | 5 PLC ±0.0001 | | WEIGHT | | A1 00779 ©=2150234 | |
| MATERIAL | | 6 PLC ±0.0001 | | Customer Accessible Production Drawing | | SCALE: 1:1 SHEET 2 OF 4 REV B | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2150234-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-2 | - | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150234-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150234-4 | - | - | - |
| | 2-2150234-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150234-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150234-4 | - | - | - |
| | 2-2150234-5 | B | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-2 | - | 2063440-1 |
| | 2-2150234-7 | B | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2150234-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.80 mm [.110] | F |
| INSUL | 4.57 mm [.180] | F |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|-----------------------------|-------------|
| TERMINAL NAME: .250 SERIES FASTON RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 6.00-6.80 mm [.236-.268 IN] | | 3.05-4.30 mm [.120-.169 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-20023 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 280001-9 | 160808-1 | 160256-5 | 3-160256-1 |
| 1-280001-0 | 160808-2 | 2-160256-1 | 4-160256-2 |
| 1-280001-1 | 100605-7 | 2-160256-2 | 4-160256-5 |
| 1-280001-2 | 1-100605-2 | 2-160256-8 | 4-160256-7 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------------------|----------------------------|--------------------------------|
| 2.50mm ² or 14 AWG | 1.98+/-0.03 [.078+/-0.001] | 5.5 |
| 2.00mm ² | 1.85+/-0.03 [.073+/-0.001] | 6.8 |
| 1.50mm ² or 16 AWG | 1.73+/-0.03 [.068+/-0.001] | 8.0 |
| 1.00mm ² or 18 AWG | 1.63+/-0.03 [.064+/-0.001] | 8.8 |
| 0.75mm ² | 1.52+/-0.03 [.060+/-0.001] | 10.0 |

- 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: 8-2150234-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150234-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150234-5
- 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 50, 62 & 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.
- TERMINAL LUBRICANT 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 | |
| - | - | - | 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 | 2119082-9 | CAM, SNAIL, 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 | |
| - | 77 | 27 | 25 | 22 | 21 | PART NO | DESCRIPTION | ITEM NO |

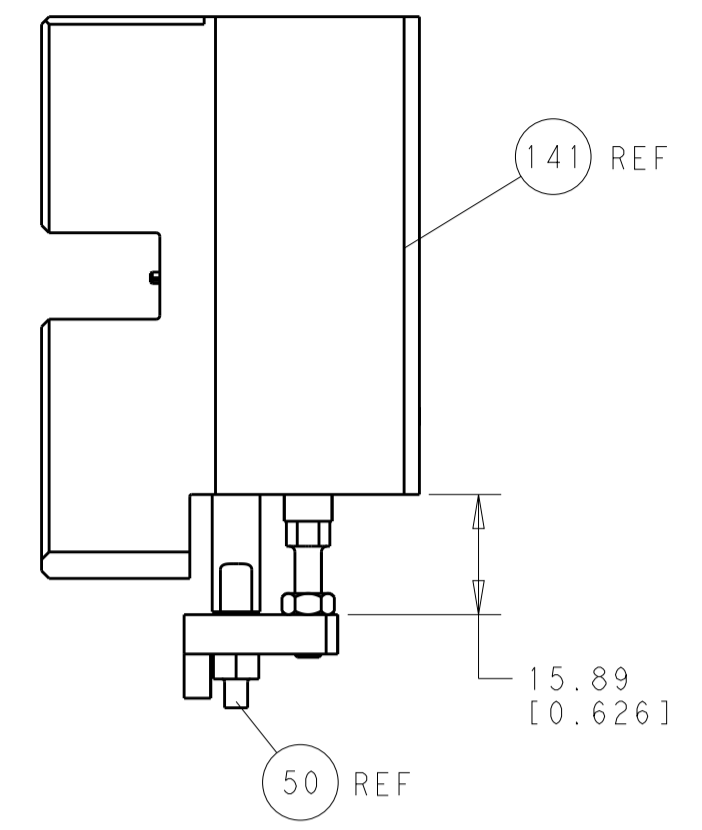
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

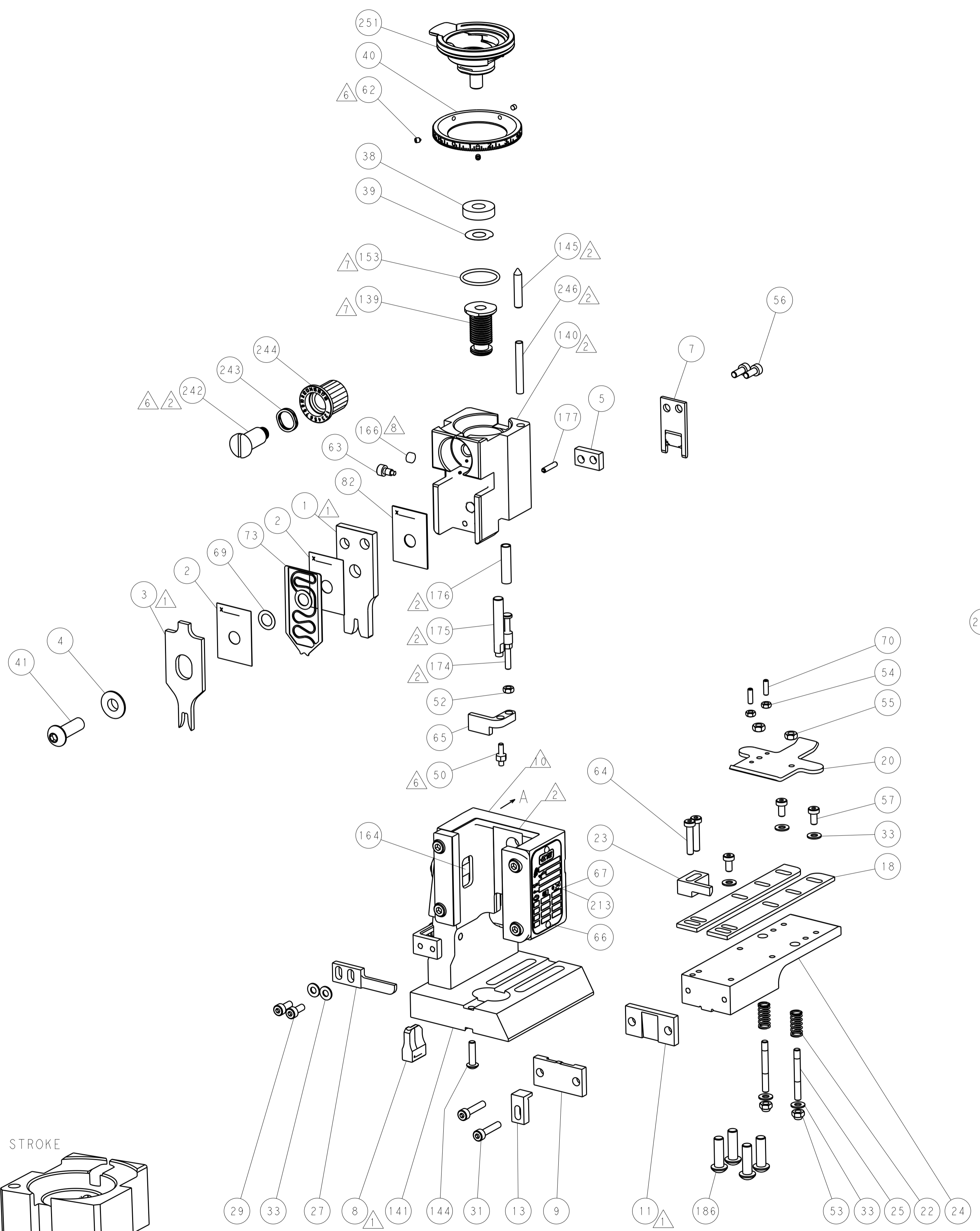
| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-------------|---------|
| - | - | 2 | - | - | 2168400-7 | SHCS, LOW HEAD, RoHS, M5 X 10 | 240 | |
| - | - | - | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 | |
| - | - | - | - | 1 | 2063440-1 | AIR FEED MODULE | 238 | |
| - | - | 1 | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 | |
| - | 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 | 6-993111-6 | PIN, SLOTTED SPRING 3.0 X 14.0 | 177 | |
| - | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 | |
| - | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 | |
| - | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 | |
| - | - | - | 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 | |
| - | 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 | 455888-6 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 2119791-9 | 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 | |
| - | 1 | 1 | 1 | 1 | 1901681-5 | HOLDDOWN, TERMINAL | 65 | |
| - | 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 | 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 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 | |
| - | - | - | - | 1 | 2119792-2 | PAWL, EF, AIR | 51 | |
| - | 1 | 1 | 1 | 1 | 1-1976055-3 | STANDOFF, HOLD-DOWN | 50 | |
| - | - | - | - | 1 | 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 | 1-2119644-2 | RAM WASHER, PRECISION | 38 | |
| - | 7 | 7 | 7 | 7 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 | |
| - | 2 | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 31 | |
| - | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 29 | |
| - | 1 | 1 | 1 | 1 | 240639-1 | STRIPPER (MACHINING) | 27 | |
| - | 2 | 2 | 2 | 2 | 1320906-1 | STUD, THREADED | 25 | |
| - | 1 | 1 | 1 | 1 | 1752371-5 | PLATE, STRIP GUIDE | 24 | |
| - | 1 | 1 | 1 | 1 | 240825-3 | PLATE, STRIP HOLD DOWN | 23 | |
| - | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 | |
| - | 1 | 1 | 1 | 1 | 1752373-4 | DRAG | 20 | |
| - | 2 | 2 | 2 | 2 | 1901259-5 | GUIDE, LOWER STRIP | 18 | |
| - | 1 | 1 | 1 | 1 | 1752360-1 | SPACER, HOLD-DOWN | 13 | |
| - | 1 | 1 | 1 | 1 | 240644-9 | PLATE, REAR SHEAR | 11 | |
| - | - | - | - | - | - | - | 10 | |
| - | 1 | 1 | 1 | 1 | 2-690495-6 | PLATE, FRONT SHEAR | 9 | |
| - | 1 | 1 | 1 | 1 | 1338673-5 | ANVIL, COMBINATION | 8 | |
| - | 1 | 1 | 1 | 1 | 1-2217206-3 | BLADE, SLUG | 7 | |
| - | 1 | 1 | 1 | 1 | 240641-3 | SPACER | 5 | |
| - | 1 | 1 | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 | |
| - | 1 | 1 | 1 | 1 | 2119582-3 | CRIMPER, INSULATION F PREMIUM | 3 | |
| - | 2 | 2 | 2 | 2 | 455888-1 | SPACER, CRIMPER | 2 | |
| - | 1 | 1 | 1 | 1 | 1490189-6 | CRIMPER, WIRE | 1 | |
| - | 77 | 27 | 25 | 22 | 21 | PART NO | DESCRIPTION | ITEM NO |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG | | REV | |
|-------------|---------------|--|-----------|-----------|---------------------------|--------------|---------------|
| mm | 0 PLC ±.5 | 1 PLC ±.5 | 2 PLC ±.5 | 3 PLC ±.5 | 4 PLC ±.5 | 5 PLC ±.5 | 6 PLC ±.5 |
| | ANGLES ±.0001 | FINISH | | OFFNER | 16DEC2011 | ELBIN | 19DEC2011 |
| MATERIAL | | | | NAME | Ocean End Feed Applicator | | |
| | | | | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| | | | | SCALE | 1:1 | SHEET 3 OF 4 | REV B |

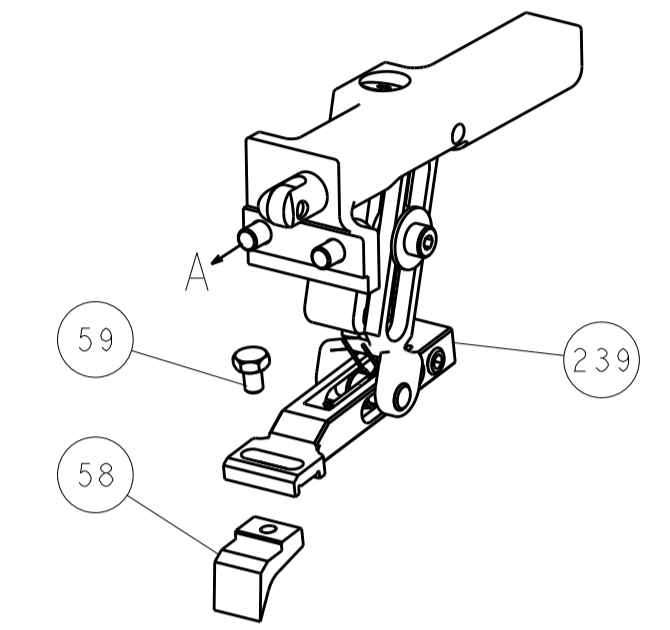
| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTM | DESCRIPTION | DATE | OWN | APVD |
| | | - | - | SEE SHEET 1 | - | - | - |



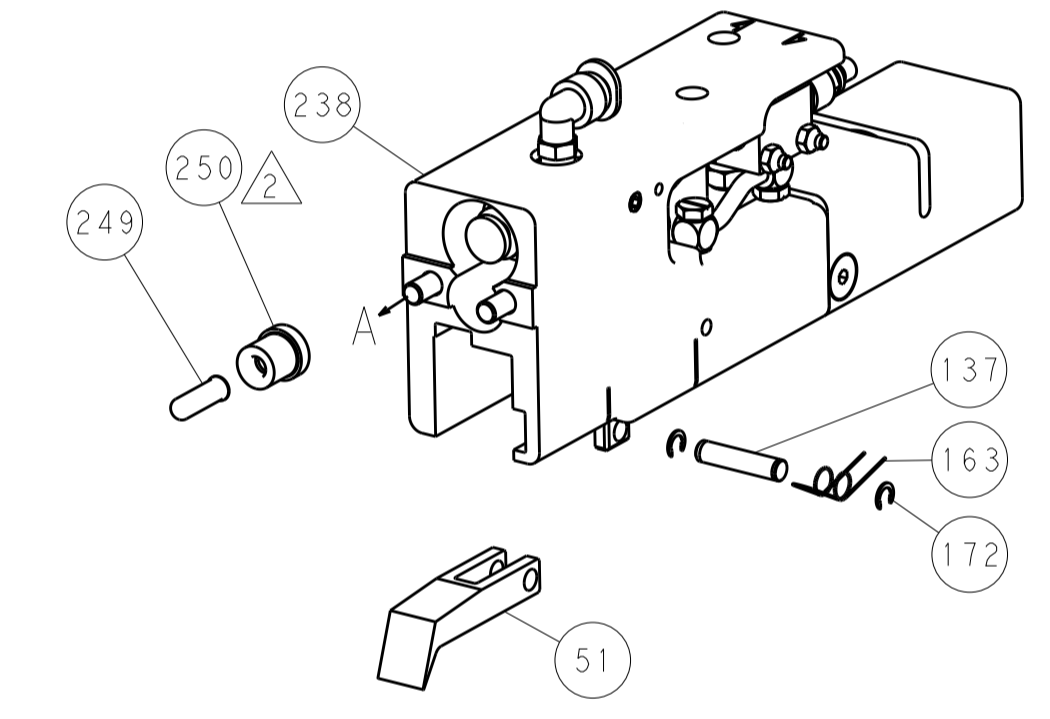
HOLDDOWN SET-UP



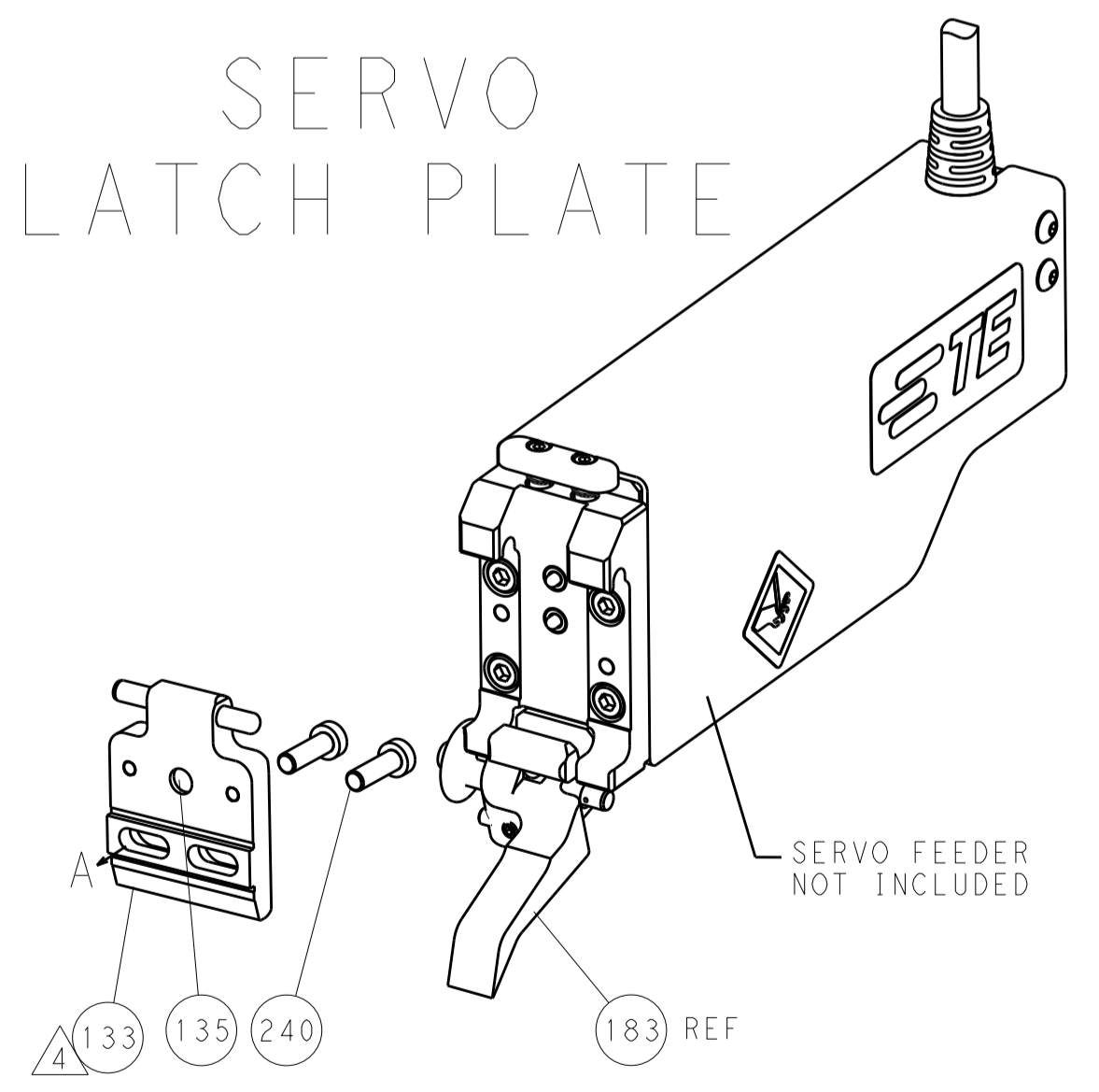
FEED TYPE
MECHANICAL



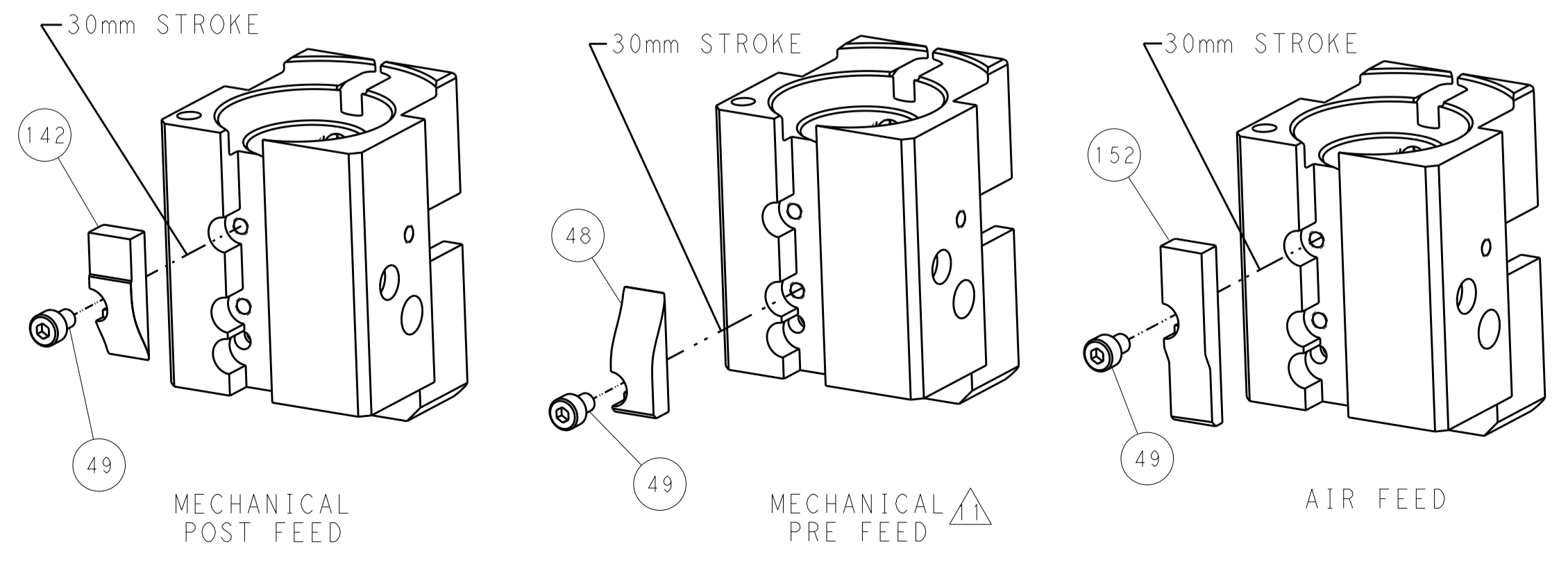
PNEUMATIC



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: HOFFNER 16DEC2011 | | TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.13 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.0013 | 5 PLC ±0.0013 | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | APVD: T. ELBIN 19DEC2011 | | NAME: Ocean End Feed Applicator | |
| | | | | PRODUCT SPEC: | | SIZE: CAGE CODE DRAWING NO: A11 00779 C=2150234 | |
| | | | | APPLICATION SPEC: | | RESTRICTED TO: | |
| | | | | WEIGHT: | | SCALE: 1:1 SHEET 4 OF 4 REV B | |
| | | | | Customer Accessible Production Drawing | | | |