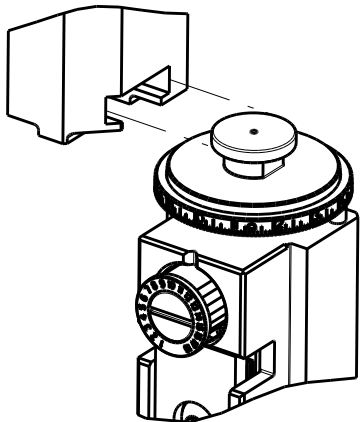
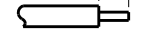


|                                                                                  |                |                          |                          |
|----------------------------------------------------------------------------------|----------------|--------------------------|--------------------------|
| 8                                                                                |                | 7                        |                          |
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| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              | PART<br>NUMBER | REVISION                 | DESCRIPTION              |
|  | 2151084-1      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151084-2      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151084-5      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151084-6      | B                        | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2151084-7      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2151084-7    | A                        | CRIMP TOOLING KIT        |

|                                   |                 |      |
|-----------------------------------|-----------------|------|
| APPLICATOR DATA                   |                 |      |
| CRIMP                             | SIZE            | TYPE |
| WIRE                              | 1.07 mm [ .042] | F    |
| INSUL                             | 1.57 mm [ .062] | O    |
| APPLICATOR INSTRUCTIONS 408-10389 |                 |      |

|                                                    |             |                                                                                   |                               |
|----------------------------------------------------|-------------|-----------------------------------------------------------------------------------|-------------------------------|
| TERMINAL DATA: TE TERMINAL                         |             | TE CRIMP SPECIFICATION                                                            |                               |
| TERMINAL NAME: CONTACT CRIMP SNAP IN AMP EI SERIES |             |                                                                                   |                               |
| WIRE STRIP LENGTH                                  |             |  | INSULATION DIAMETER RANGE     |
| 2.83-3.59 mm [ .111-.141 IN]                       |             |                                                                                   | Ø1.00-1.40 mm [ .039-.055 IN] |
| TERMINAL APPLICATION SPECIFICATION                 |             | 114-5035                                                                          | -                             |
|                                                    |             | -                                                                                 | -                             |
| TERMINALS APPLIED                                  |             |                                                                                   |                               |
| TE TERMINAL                                        | TE TERMINAL | TE TERMINAL                                                                       | TE TERMINAL                   |
| 170263-1                                           | 170263-2    | 170263-3                                                                          | 170263-4                      |
| 170377-1                                           | 170377-2    | 170377-3                                                                          | 170377-4                      |

|           |                             |                                |
|-----------|-----------------------------|--------------------------------|
| WIRE SIZE | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
| 26 AWG    | 0.66+/-0.05 [ .026+/- .002] | 6.3                            |
| 28 AWG    | 0.62+/-0.05 [ .024+/- .002] | 6.8                            |
| 30 AWG    | 0.59+/-0.05 [ .023+/- .002] | 7.2                            |

- 

RECOMMENDED SPARE PARTS
- 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: 8-2151084-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151084-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151084-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151084-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8. MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
9. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
10. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
11. TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
12. WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 5.14.

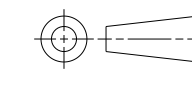
\*WARNING  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|     |    |    |    |    |    |           |                                 |         |
|-----|----|----|----|----|----|-----------|---------------------------------|---------|
| -   | -  | 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  | -  | 2079988-1 | BUSHING, LCH5-12, MISUMI        | 249     |
| -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)

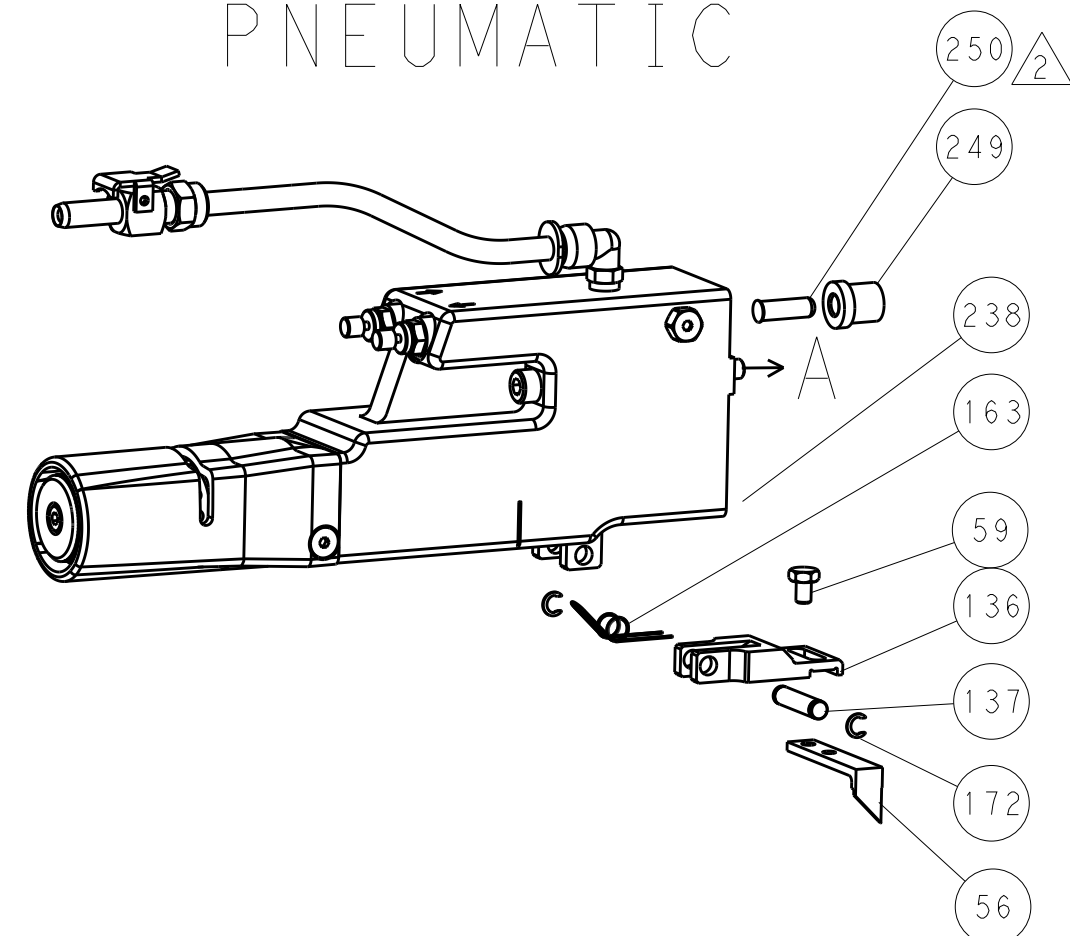
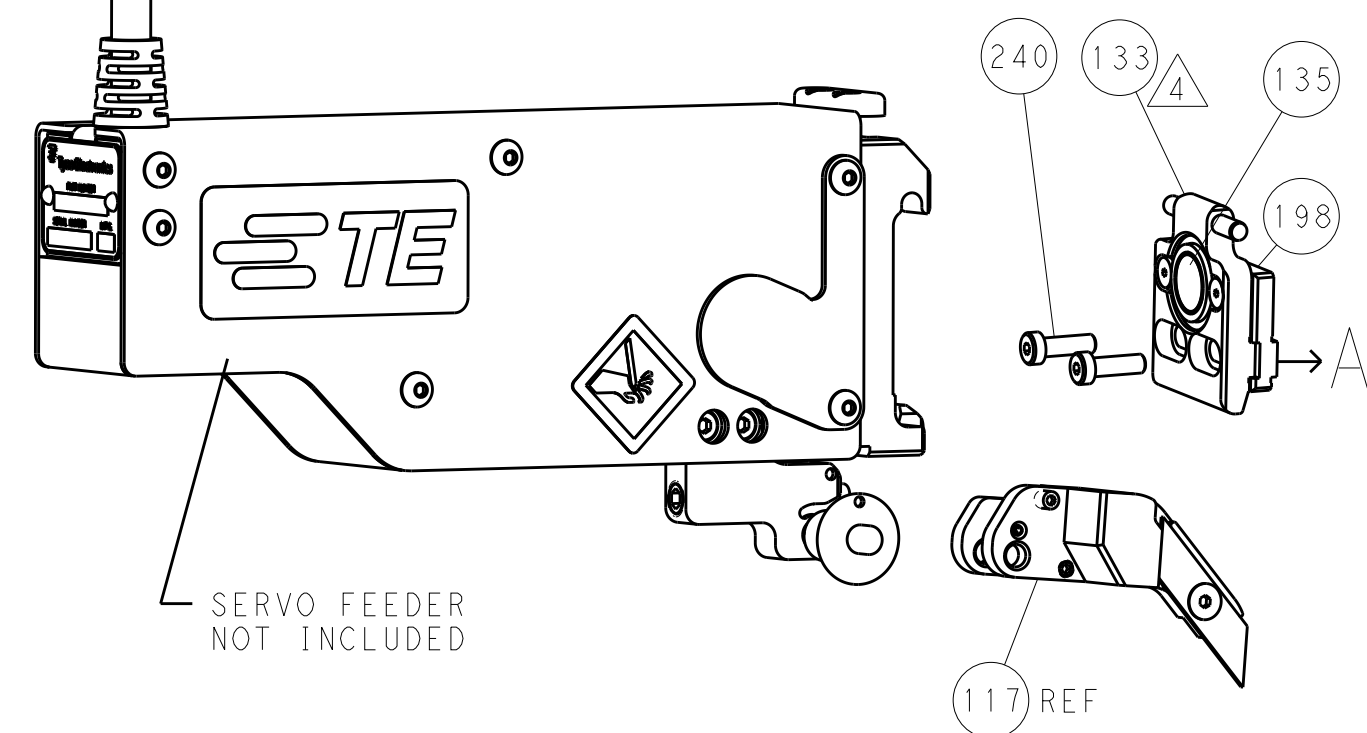
|                        |     |               |         |           |     |      |  |
|------------------------|-----|---------------|---------|-----------|-----|------|--|
| SET UP GAUGE 2119599-1 |     | LOC A         | DIST 66 | REVISIONS |     |      |  |
| P                      | LTR | DESCRIPTION   |         | DATE      | OWN | APVD |  |
|                        | A   | RELEASED      |         | 07NOV2014 | MR  | GB   |  |
|                        | B   | ECR-14-018590 |         | 12DEC2014 | KH  | JT   |  |
|                        | B1  | ECR-15-008572 |         | 05JUN2015 | YY  | JT   |  |
|                        | B2  | ECR-16-010395 |         | 19JUL2016 | MZ  | KZ   |  |

|     |     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | -   | -   | -   | 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   | -   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245     |
| -   | 1   | 1   | 1   | 1   | 1   | 2119082-5   | 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     |
| -   | 1   | 1   | 1   | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241     |
| -   | -   | 2   | 2   | -   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240     |
| -   | -   | -   | -   | -   | 1   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239     |
| -   | -   | -   | -   | 1   | -   | 2063440-1   | AIR FEED MODULE                     | 238     |
| -   | -   | 1   | 1   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| -   | -   | 1   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      | 198     |
| -   | -   | -   | -   | 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     |
| -   | -   | -   | -   | 1   | -   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136     |
| -   | -   | REF | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135     |
| -   | -   | 1   | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133     |
| -   | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-6    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 1   | 1962431-2   | SPRING, COMPRESSION                 | 77      |
| -   | 1   | 1   | 1   | 1   | 1   | 854769-4    | HOLDER, INS                         | 74      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 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      |
| -   | 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   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | 1   | 1   | 1   | 1   | 1   | 21028-2     | PIN, SLOTTED SPRING .062 X .250     | 58      |
| -   | -   | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56      |
| -   | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54      |
| -   | 2   | 2   | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53      |
| -   | 1   | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52      |
| -   | 1   | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51      |
| -   | 1   | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 50      |
| -   | -   | -   | -   | 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      |
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| -   | 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      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37      |
| -   | 1   | -   | 1   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35      |
| -   | 1   | 1   | 1   | 1   | 1   | 1752356-3   | SUPPORT, TERMINAL                   | 34      |
| -   | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| -   | 1   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32      |
| -   | 1   | 1   | 1   | 1   | 1   | 1320908-6   | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29      |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28      |
| -   | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 1   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21      |
| -   | 2   | 2   | 2   | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119533-4   | STRIPPER, SIDE FEED                 | 19      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13      |
| -   | 1   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -   | 1   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| -   | 1   | 1   | 1   | 1   | 1   | 1803095-1   | FLOATING SHEAR, FRONT               | 9       |
| 1   | 1   | 1   | 1   | 1   | 1   | 2-1803056-0 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1   | 2119780-4   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 1   | 238011-7    | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 1   | 1   | 1   | 1633966-6   | CRIMPER, INSULATION O               | 3       |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 2       |
| 1   | 1   | 1   | 1   | 1   | 1   | 4-1633860-7 | CRIMPER, WIRE                       | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

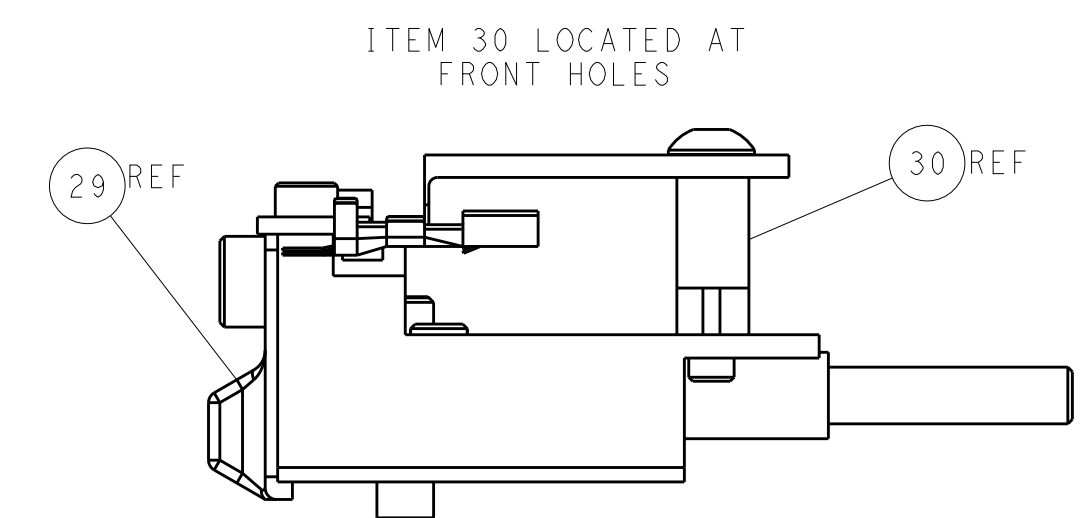
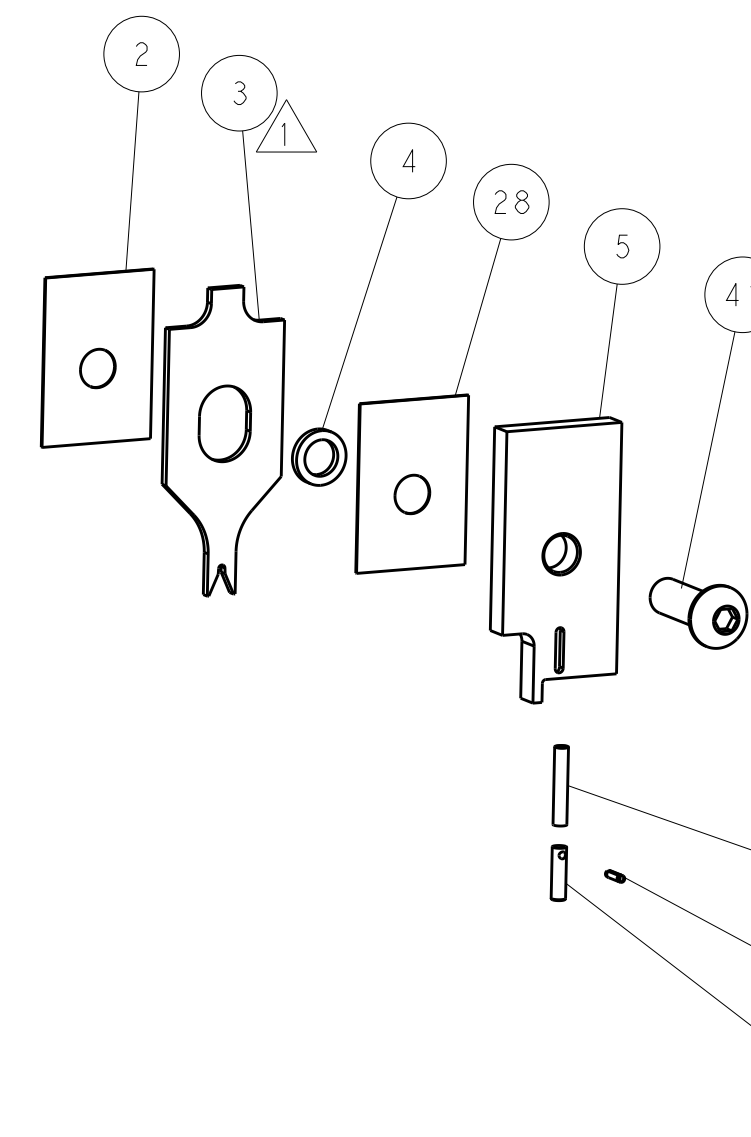
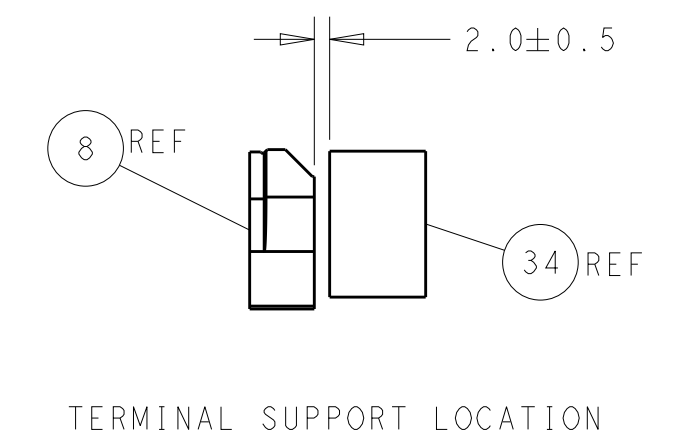
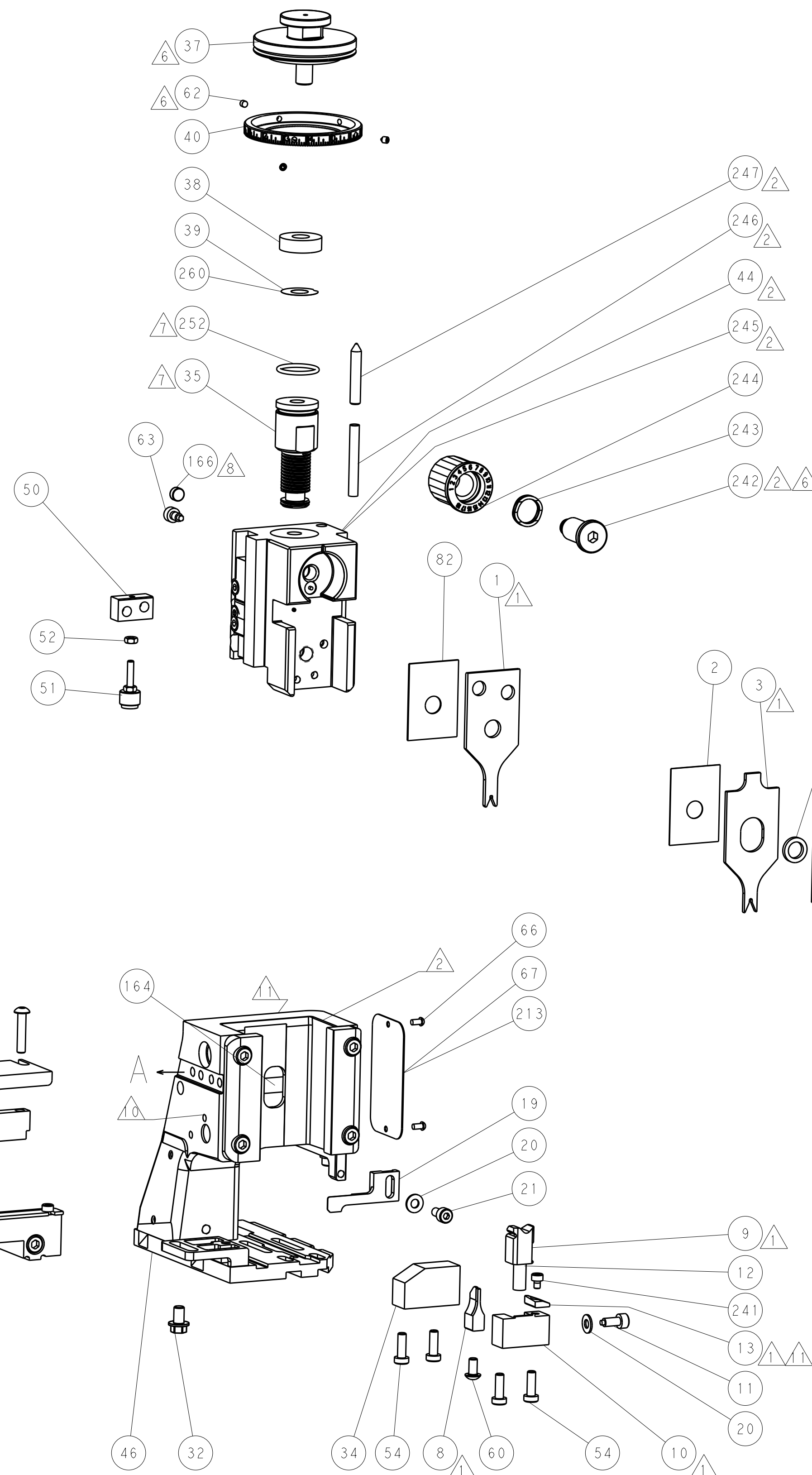
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|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------|--|------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|
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| DIMENSIONS:                                                                                                                                                                              |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                                      |  | CHK<br>Y. YIN<br>17SEP2014   |  |                                                                                                                                    |  |
| mm                                                                                                                                                                                       |  | 0 PLC ±.1<br>1 PLC ±.1<br>2 PLC ±.1<br>3 PLC ±.1<br>4 PLC ±.1<br>ANGLES ±.1 |  | APVD<br>H. GUO<br>17SEP2014  |  |                                                                                                                                    |  |
|                                                                                                     |  | FINISH                                                                      |  | PRODUCT SPEC                 |  |                                                                                                                                    |  |
| MATERIAL                                                                                                                                                                                 |  | FINISH                                                                      |  | APPLICATION SPEC             |  | NAME                                                                                                                               |  |
| -                                                                                                                                                                                        |  | -                                                                           |  | -                            |  | Ocean Side Feed Applicator                                                                                                         |  |
| -                                                                                                                                                                                        |  | -                                                                           |  | WEIGHT                       |  | SIZE CASE CODE DRAWING NO                                                                                                          |  |
| -                                                                                                                                                                                        |  |                                                                             |  | -                            |  | A1 00779 ©=2151084                                                                                                                 |  |
| Customer Accessible Production Drawing                                                                                                                                                   |  |                                                                             |  | SCALE 1:2                    |  | SHEET 1 OF 4                                                                                                                       |  |
|                                                                                                                                                                                          |  |                                                                             |  |                              |  | REV B2                                                                                                                             |  |



## PNEUMATIC

SERVO  
LATCH PLATE

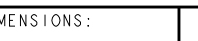
## CAM POSITIONS



FEED TRACK POSITION  
GUIDE BY WIRE BARREL

## ATLANTIC VERSION

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

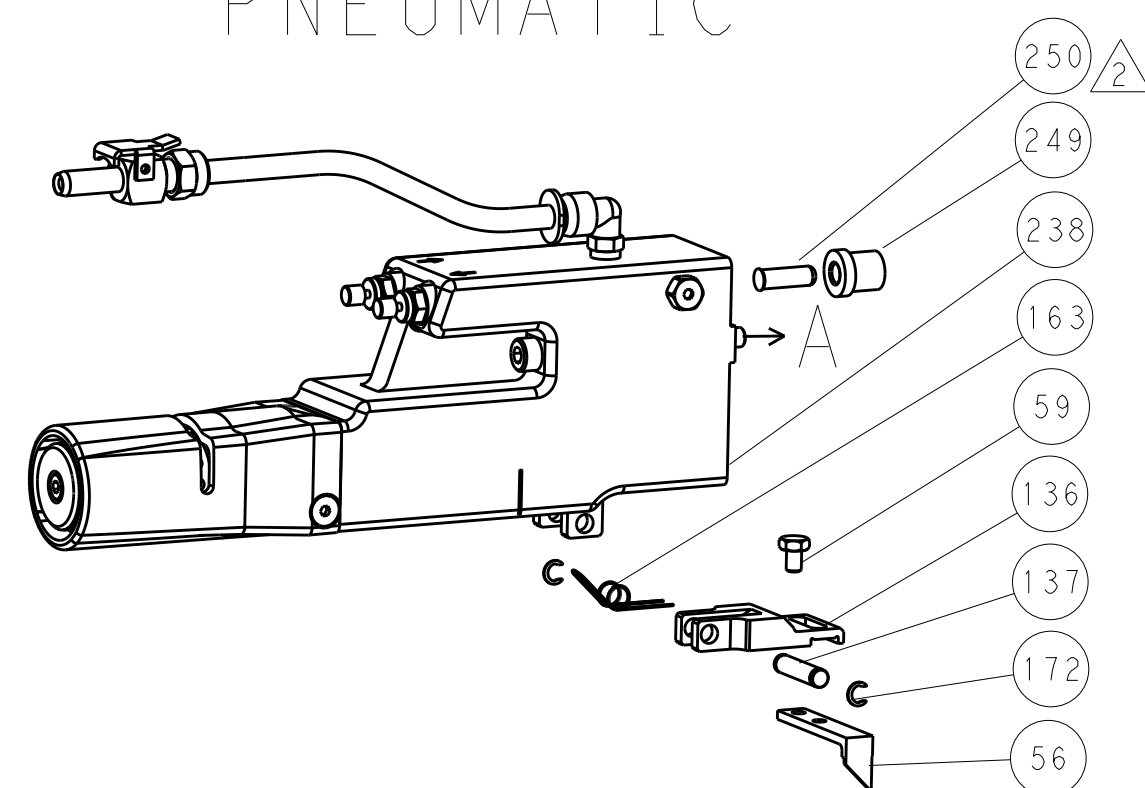
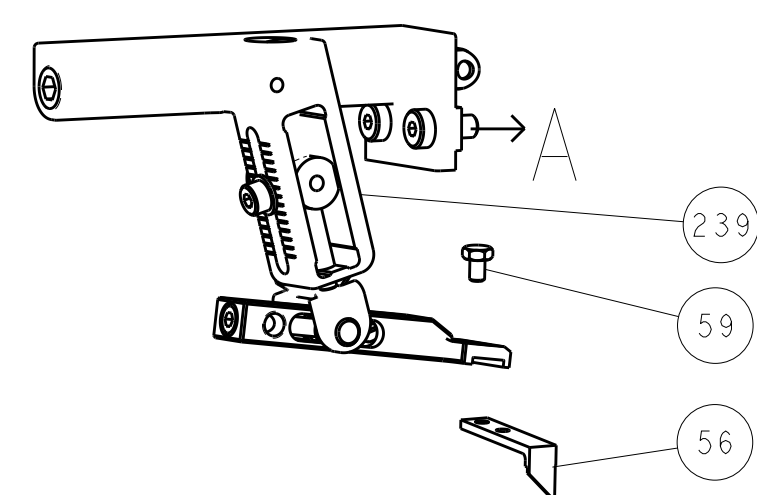
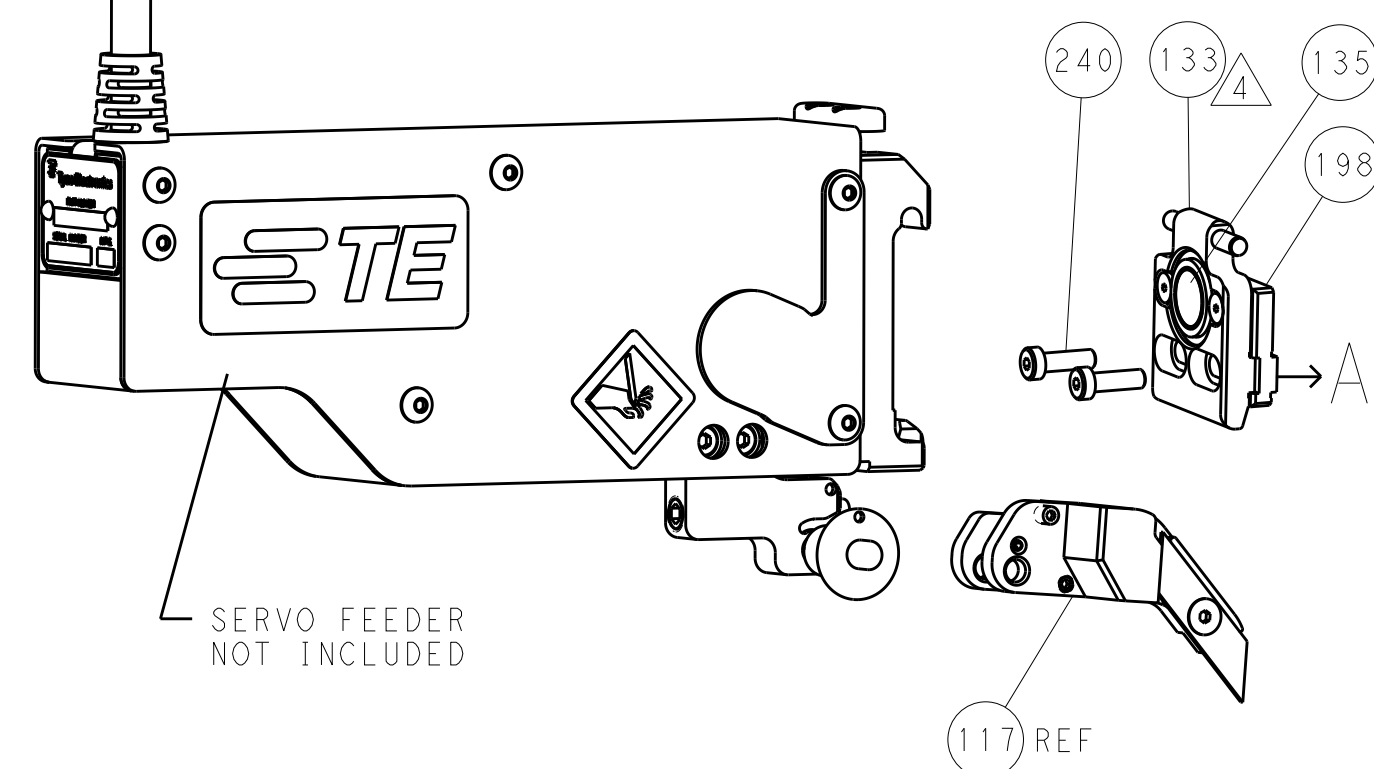
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| DIMENSIONS:                                                                                                                                                                          |  | CHK<br>Y. YIN<br>17SEP2014  |  |                                                                                                                                    |            |
| TOLERANCES UNLESS<br>OTHERWISE SPECIFIED:                                                                                                                                            |  | APVD<br>U. GUO<br>17SEP2014 |  | NAME                                                                                                                               |            |
| mm                                                                                                                                                                                   |  | PRODUCT SPEC                |  | Ocean Side Feed<br>Applicator                                                                                                      |            |
|                                                                                                 |  | APPLICATION SPEC            |  | -                                                                                                                                  |            |
| 0 PLC ±.1<br>1 PLC ±.1<br>2 PLC ±.1<br>3 PLC ±.1<br>4 PLC ±.1<br>ANGLES ±.1                                                                                                          |  | SIZE                        |  | CAGE CODE                                                                                                                          | DRAWING NO |
| MATERIAL                                                                                                                                                                             |  | FINISH                      |  | RESTRICTED TO                                                                                                                      |            |
| -                                                                                                                                                                                    |  | -                           |  | -                                                                                                                                  |            |
| WEIGHT                                                                                                                                                                               |  | A   00779                   |  | C=251084                                                                                                                           |            |
| Customer Accessible Production Drawing                                                                                                                                               |  | SCALE                       |  | 1:2                                                                                                                                |            |
| SHEET                                                                                                                                                                                |  | 2                           |  | of 4                                                                                                                               |            |
| REV                                                                                                                                                                                  |  | B2                          |  |                                                                                                                                    |            |



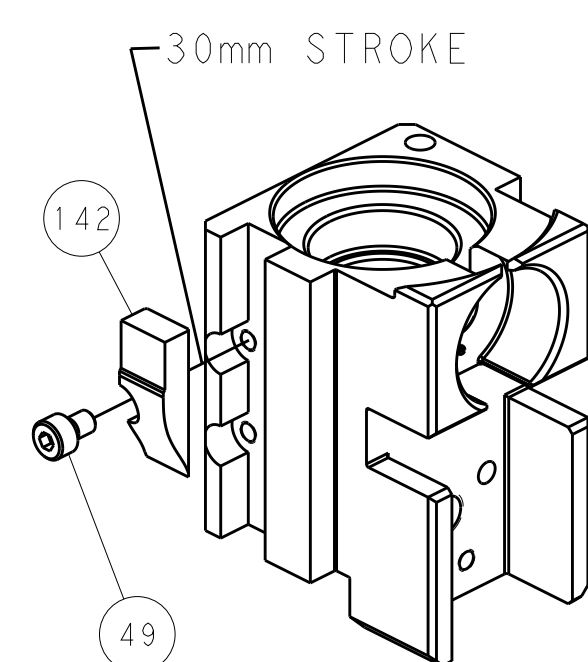




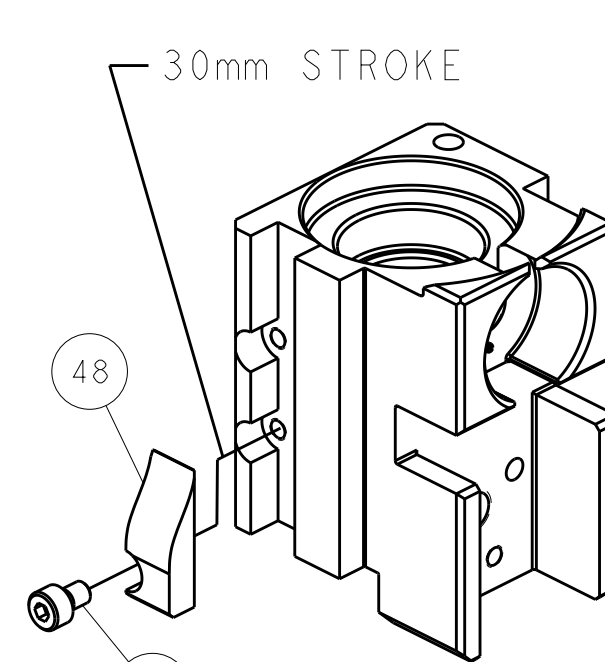
## PNEUMATIC

SERVO  
LATCH PLATE

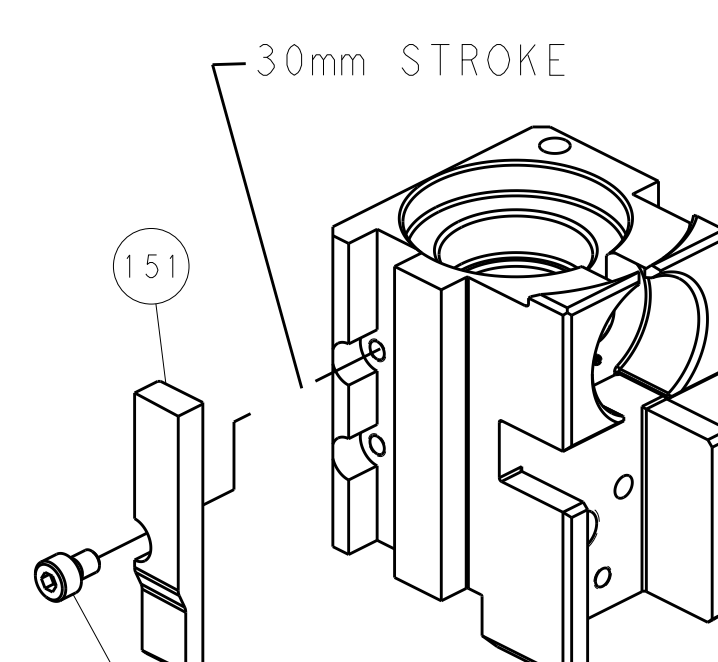
## CAM POSITIONS



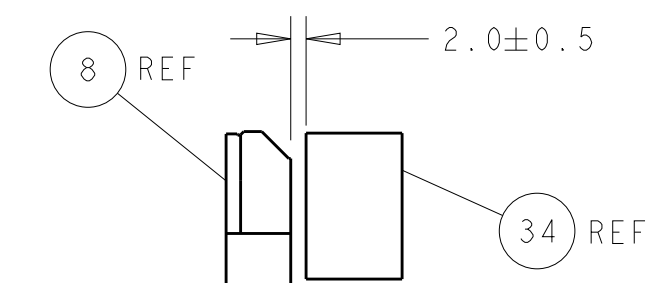
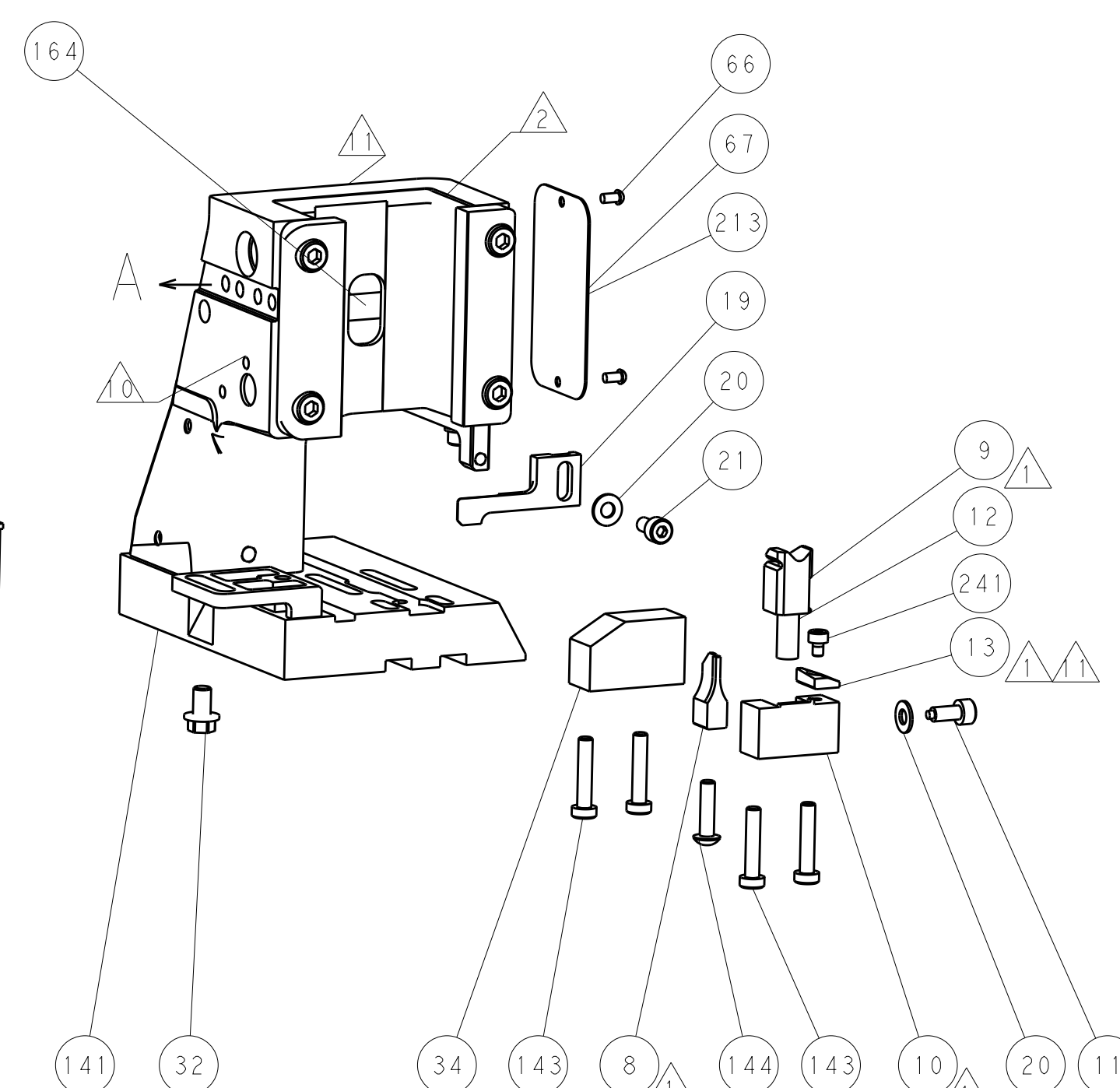
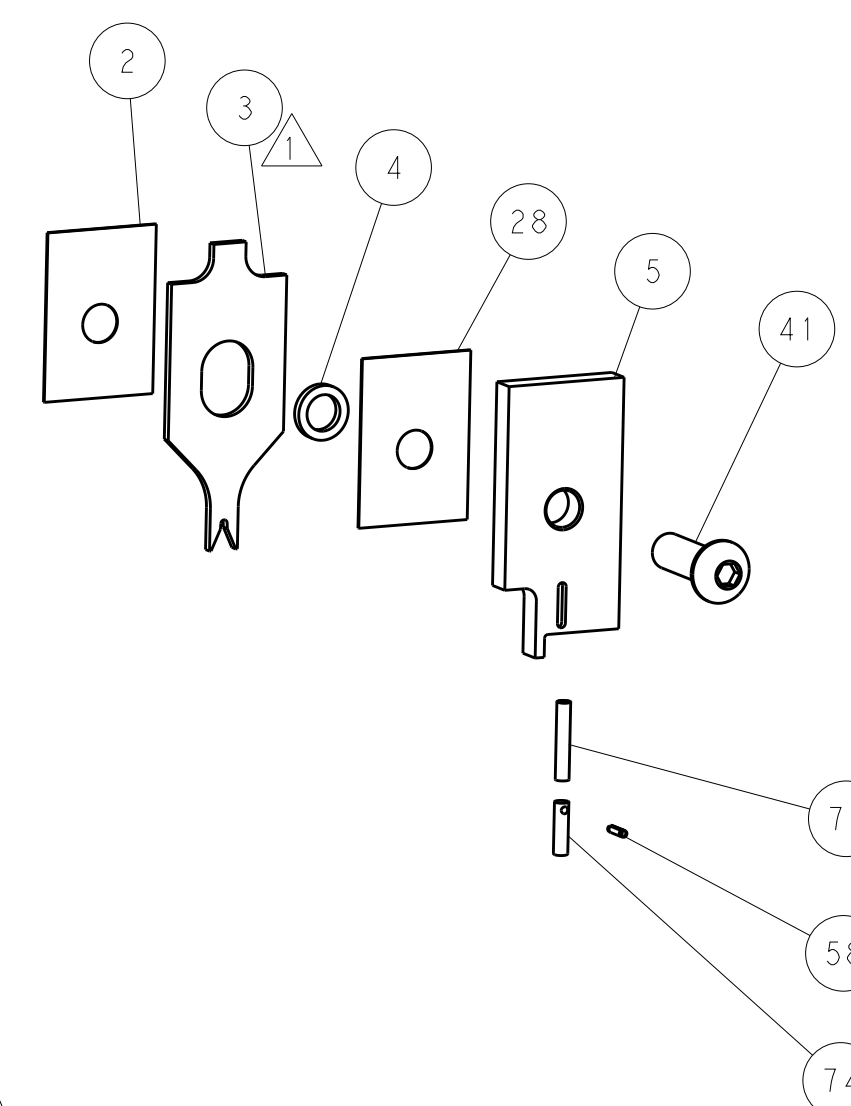
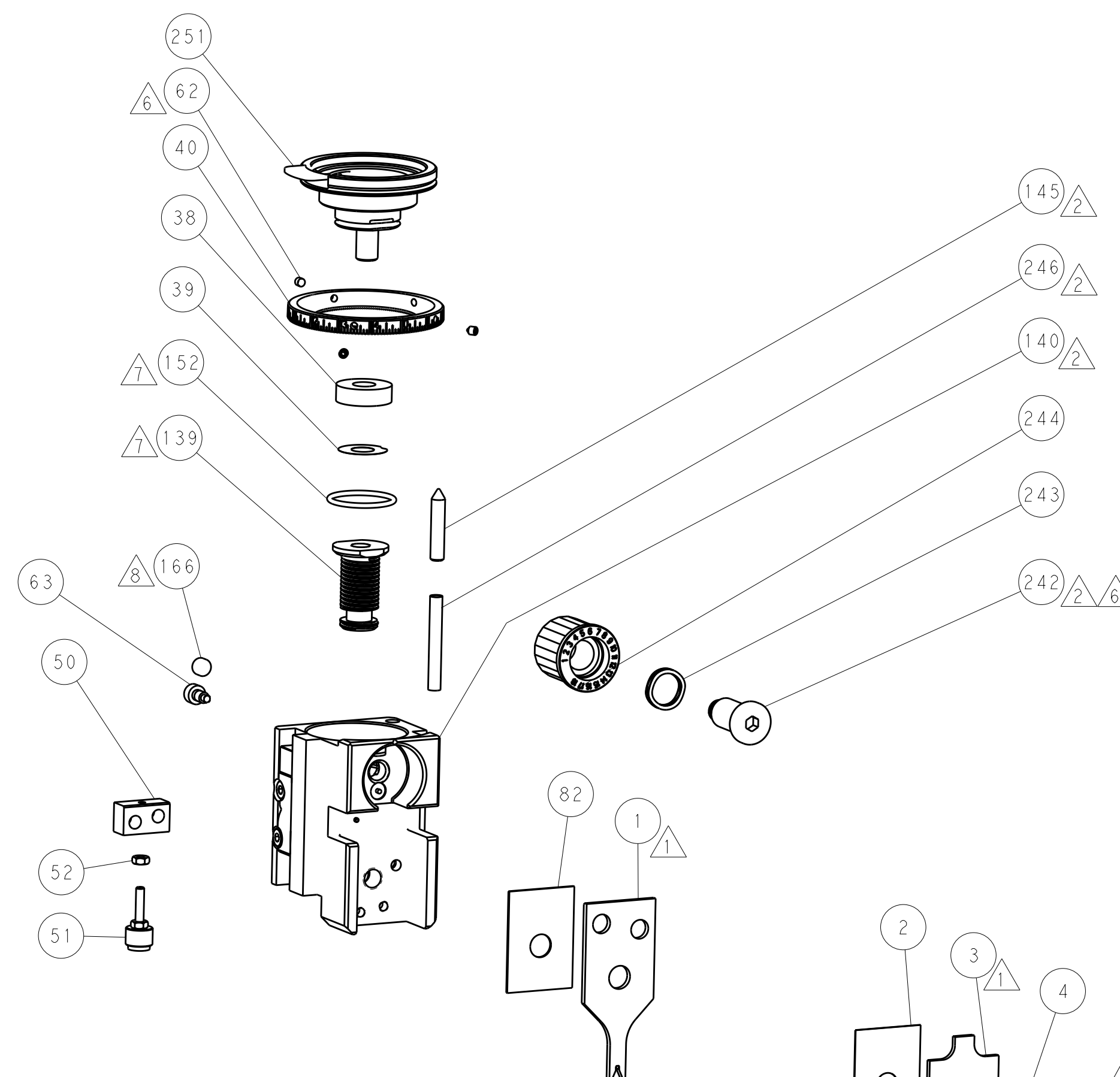
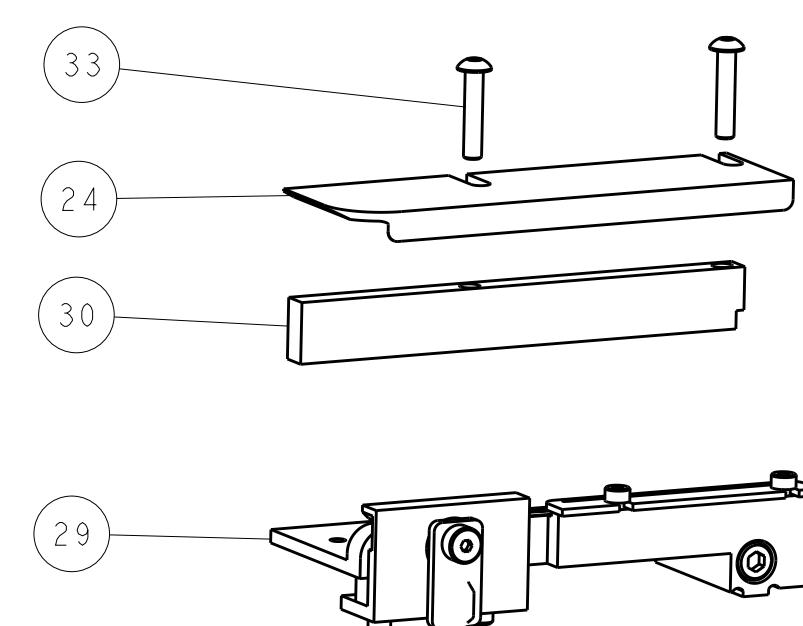
MECHANICAL  
POST FEED



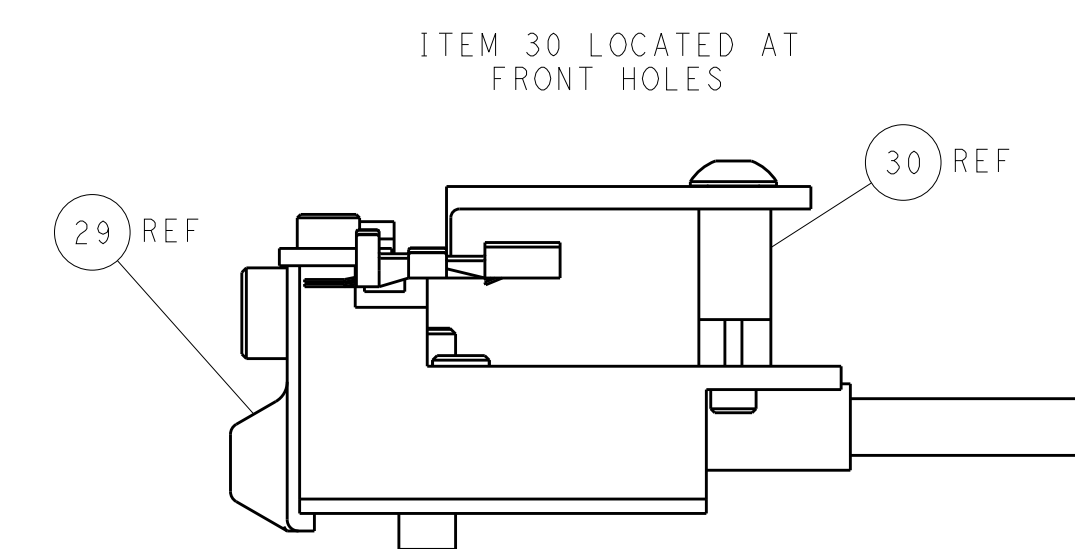
MECHANICAL  
PRE FEED



AIR FEED



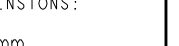
TERMINAL SUPPORT LOCATION



FEED TRACK POSITION  
GUIDE BY WIRE BARREL

## PACIFIC VERSION

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

|                                                                                                                                                                                                            |  |                                                                             |  |                                                                                                                                    |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|
| <small>*SEE DRAWING 1 &amp; 2 FOR DIMENSIONS. CONTACT FOUR FUNDRIES CORPORATION<br/>IF IT IS SUBJECT TO CHANGE AND THE CONTROLLING/ENGINEERING ORGANIZATION<br/>SHOULD BE NOTICED FOR ANY CHANGES.</small> |  | DWN 17SEP2014<br>J. HOU<br>CHK 17SEP2014<br>Y. YIN<br>U. GUO 17SEP2014      |  |  TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:<br>mm                                                                                                                                                                                          |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED:                                   |  | NAME<br>OCEAN SIDE FEED<br>APPLICATOR                                                                                              |  |
|                                                                                                                       |  | 0 PLC ±.1<br>1 PLC ±.1<br>2 PLC ±.1<br>3 PLC ±.1<br>4 PLC ±.1<br>ANGLES ±.1 |  | PRODUCT SPEC<br>-<br>APPLICATION SPEC<br>-                                                                                         |  |
| MATERIAL<br>-                                                                                                                                                                                              |  | WEIGHT<br>-                                                                 |  | SIZE<br>A   00779 C=2151084                                                                                                        |  |
|                                                                                                                                                                                                            |  |                                                                             |  | DRAWING NO<br>-                                                                                                                    |  |
|                                                                                                                                                                                                            |  |                                                                             |  | RESTRICTED TO<br>-                                                                                                                 |  |
| Customer Accessible Production Drawing                                                                                                                                                                     |  |                                                                             |  | SCALE 1:2 SHEET 4 OF 4 REV B2                                                                                                      |  |