

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2150410-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150410-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150410-4 | - | - | - |
| | 2150410-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150410-5 | - | - | 2168400-7 (QUANTITY 2) |
| | 2150410-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - | 2063440-1 |
| 2150410-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | - | |
| 2150410-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2150410-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.48 mm [.098] | F |
| INSUL | 3.47 mm [.137] | F |
| APPL INSTRUCTIONS 408-10390 | | |

| | | | |
|--|--|-------------|----------------|
| TERMINAL DATA: HATKO TERMINAL | HATKO CRIMP SPECIFICATION | | |
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH 5.14-5.16 mm [.203-.203 IN] | INSULATION DIAMETER RANGE Ø 3.05 mm MAX [.120 IN MAX] | | |
| TERMINAL APPLICATION SPECIFICATION | HATKO SPEC | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | HATKO TERMINAL | TE TERMINAL | HATKO TERMINAL |
| 2113426-1 | 0100104009 | 2113426-3 | 0500104009 |
| 2113426-2 | 0300104009 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 1.00mm2 | 1.70+/-0.02 [.067+/- .001] | 7.2 |
| 0.75mm2 | 1.58+/-0.02 [.062+/- .001] | 8.2 |
| 0.50mm2 | 1.52+/-0.02 [.060+/- .001] | 8.6 |

- 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: 8-2150410-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150410-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150410-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150410-6
- 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 50, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.
- 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.

***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 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |

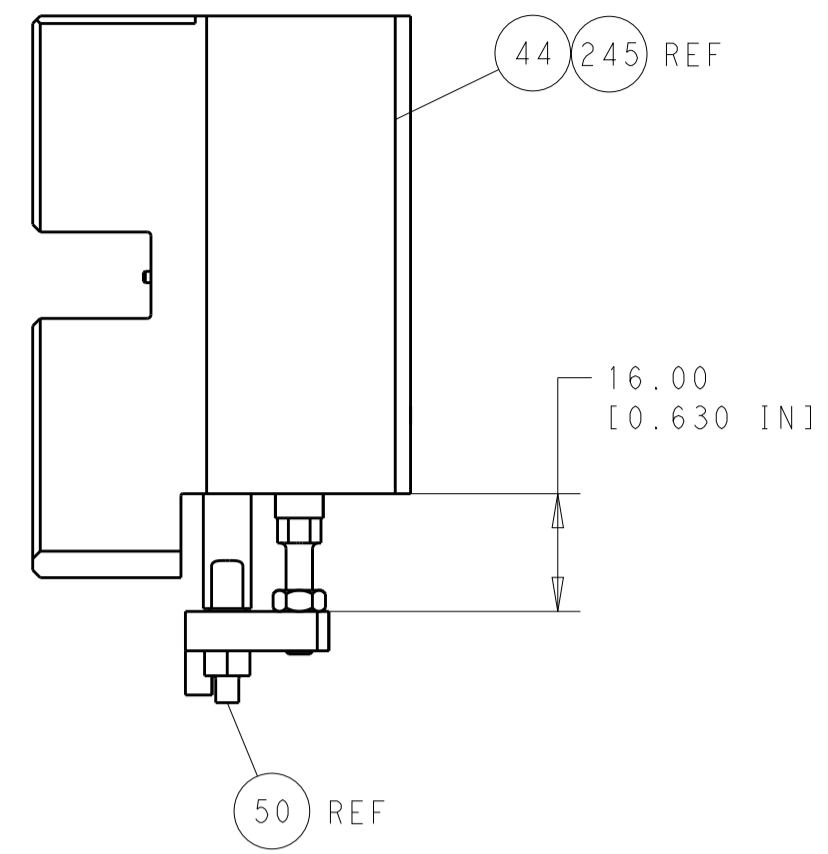
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|-------------|-----------|-------|
| 2119599-2 | A | 66 | REV | DATE | BY | APPD |
| | | | 1 | DEVELOPMENT | 14FEB2014 | YY UG |
| | | | A | RELEASED | 24MAR2014 | YY UG |

| | | | | | | | | |
|---|--------|--------|--------|--------|--------|-------------|-------------------------------------|-----|
| - | 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 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-6 | 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 | 2168400-8 | SHCS, LOW HEAD, RoHS, M4 X 16 | 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 | 1-1976055-2 | STANDOFF, HOLD-DOWN | 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 |
| - | 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 | 1901259-4 | 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 | 690482-4 | PLATE, FRONT SHEAR | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 8-1633384-3 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 1 | 1-2217206-0 | BLADE, SLUG | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2-240641-9 | SPACER | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 2-238009-9 | BLOCK, FL CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 3-1803016-0 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 1-455888-1 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 5-1633664-9 | CRIMPER, WIRE | 1 |

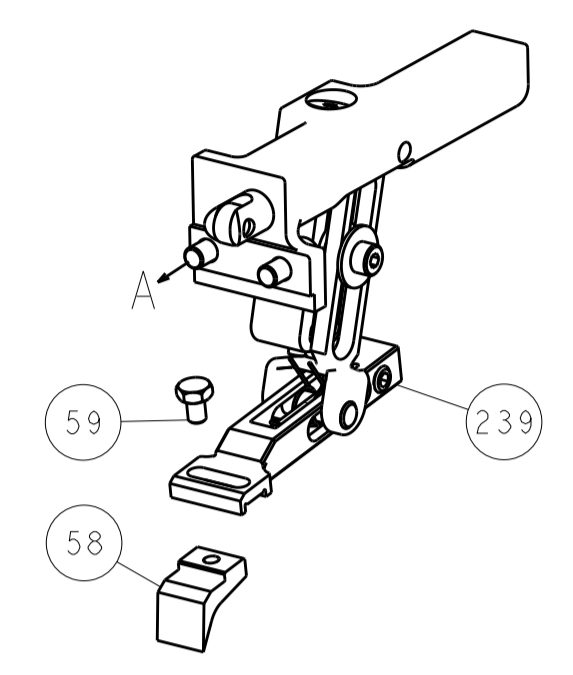
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG | | CHK | | APPD | | NAME | |
|--|-----------|--|------------|--------------|--------------|--------|-----------|-----------|-----------|-----------|-----------|
| mm | 0 PLC ±.5 | 1 PLC ±.3 | 2 PLC ±.13 | 3 PLC ±.013 | 4 PLC ±.0001 | Y. YIN | 14FEB2014 | G. BAILEY | 14FEB2014 | U. GUO | 14FEB2014 |
| MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: | | SHEET: | | REV: | |
| Customer Accessible Production Drawing | | SCALE 1:1 | | SHEET 1 OF 4 | | REV A | | A1 00779 | | C=2150410 | |

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

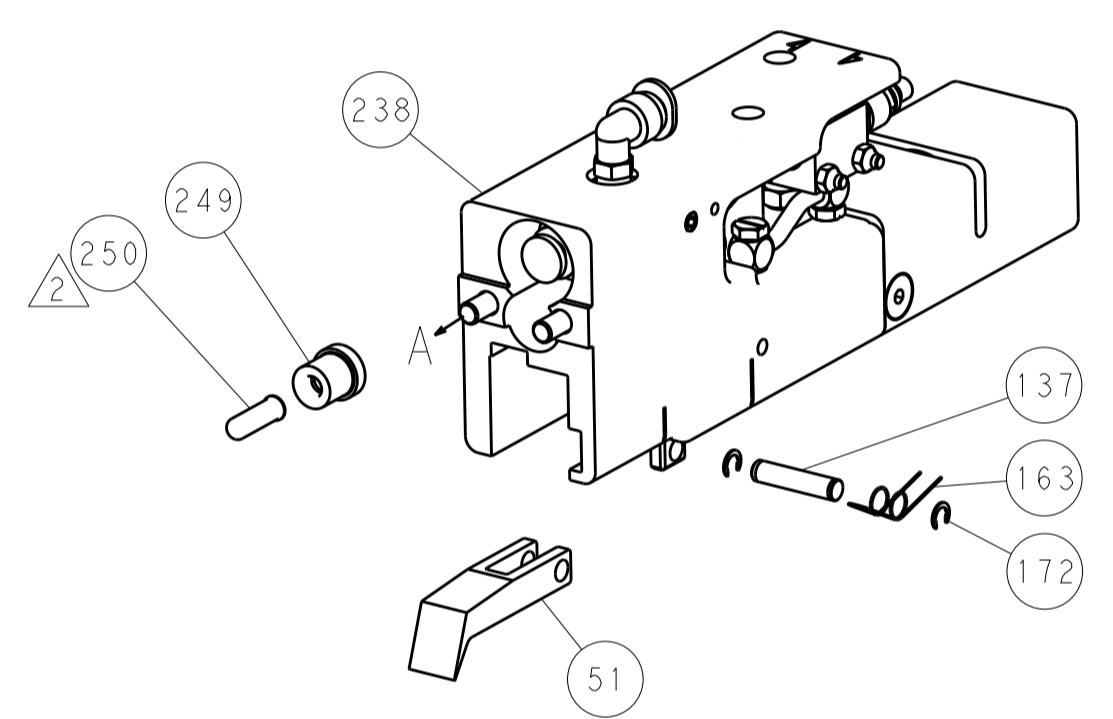


HOLDDOWN SET-UP

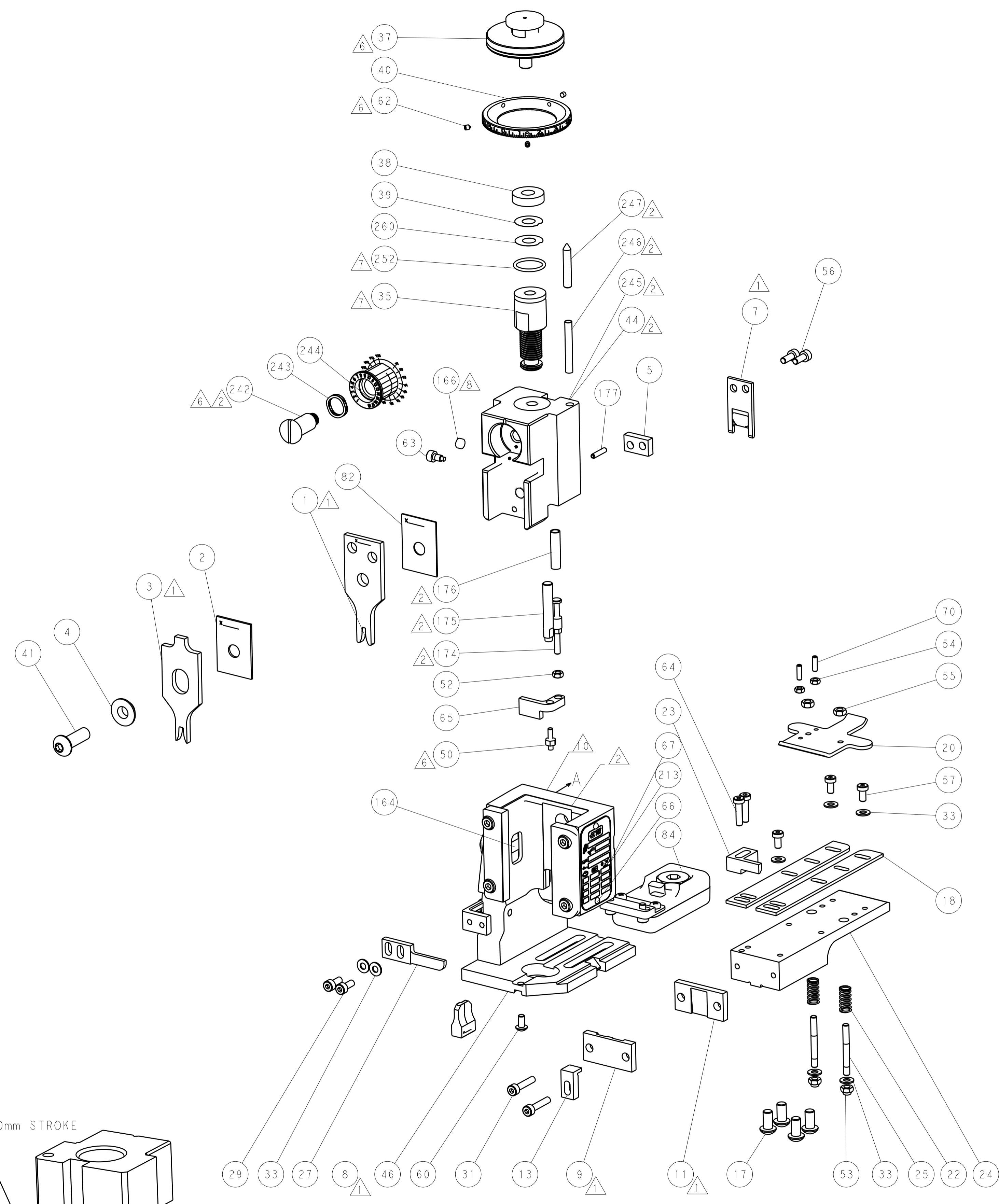
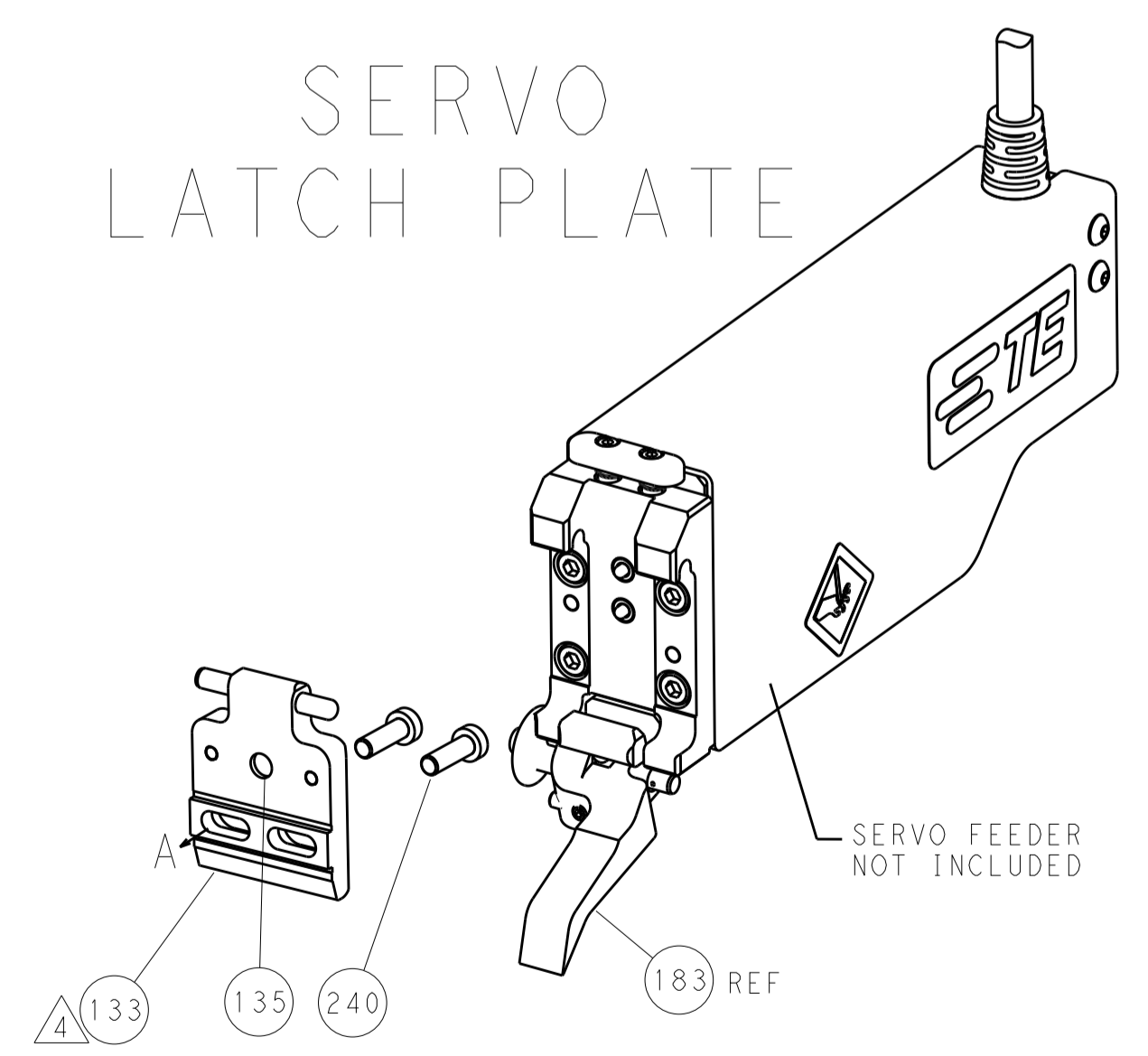
FEED TYPE
MECHANICAL



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: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG | | REV | | DATE | | NAME | |
| mm | | 0 PLC ±0.5 | | TY YIN | | 14FEB2014 | | 14FEB2014 | | G. BAILEY | |
| Ø | | 1 PLC ±0.13 | | H. GUO | | 14FEB2014 | | 14FEB2014 | | NAME | |
| HOLE | | 3 PLC ±0.013 | | APVD | | 14FEB2014 | | 14FEB2014 | | PRODUCT SPEC | |
| MATERIAL | | 4 PLC ±0.001 | | APVD | | 14FEB2014 | | 14FEB2014 | | APPLICATION SPEC | |
| FINISH | | ANGLES ±0.0001 | | APVD | | 14FEB2014 | | 14FEB2014 | | WEIGHT | |
| | | | | APVD | | 14FEB2014 | | 14FEB2014 | | SCALE | |
| | | | | APVD | | 14FEB2014 | | 14FEB2014 | | SHEET 2 OF 4 | |
| | | | | APVD | | 14FEB2014 | | 14FEB2014 | | REV A | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|------------------------|-----------|
| | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| 2-2150410-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-2 | - | 2063440-1 |
| | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150410-5 | - | 2168400-7 (QUANTITY 2) | |
| | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150410-4 | - | - | |
| 2-2150410-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150410-5 | - | 2168400-7 (QUANTITY 2) | |
| | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150410-4 | - | - | |
| 2-2150410-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - | |
| 2-2150410-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | |
| 7-2150410-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------------------|------|--|
| CRIMP SIZE | TYPE | |
| WIRE 2.48 mm (.098) | F | |
| INSUL 3.47 mm (.137) | F | |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: HATKO TERMINAL HATKO CRIMP SPECIFICATION | |
|---|---|
| TERMINAL NAME: TERMINAL | |
| WIRE STRIP LENGTH 5.14-5.16 mm (.203-.203 IN) | INSULATION DIAMETER RANGE 3.05 mm MAX (.120 IN MAX) |
| TERMINAL APPLICATION SPECIFICATION HATKO SPEC | |
| TERMINALS APPLIED | |
| TE TERMINAL | HATKO TERMINAL |
| 2113426-1 | 0100104009 |
| 2113426-2 | 0300104009 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 1.00mm2 | 1.70 +/- 0.02 [.067 +/- .001] | 7.2 |
| 0.75mm2 | 1.58 +/- 0.02 [.062 +/- .001] | 8.2 |
| 0.50mm2 | 1.52 +/- 0.02 [.060 +/- .001] | 8.6 |

- 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: 8-2150410-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150410-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150410-5
- 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 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.

| ITEM NO | DESCRIPTION | ITEM NO |
|-----------------|-------------------------------------|-------------|
| 251 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| 250 | PUSH ROD, AIR FEED | 250 |
| 249 | BUSHING, LCH5-12, MISUMI | 249 |
| 246 | SPRING, COMPRESSION | 246 |
| 244 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| 243 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| 242 | RETAINER, INSULATION DIAL | 242 |
| -77-27-25-22-21 | PART NO | DESCRIPTION |

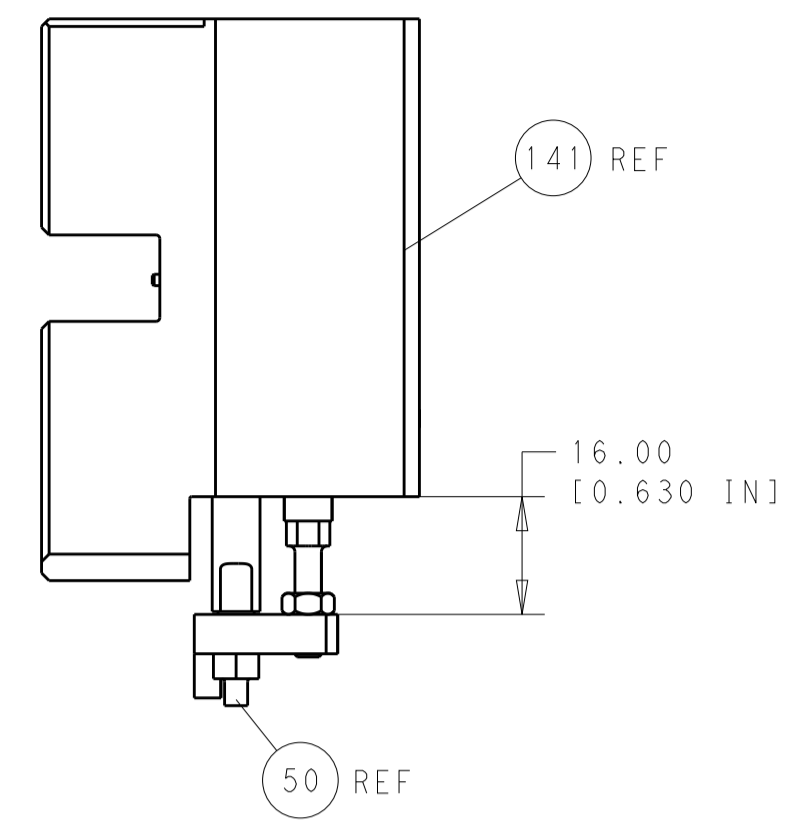
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

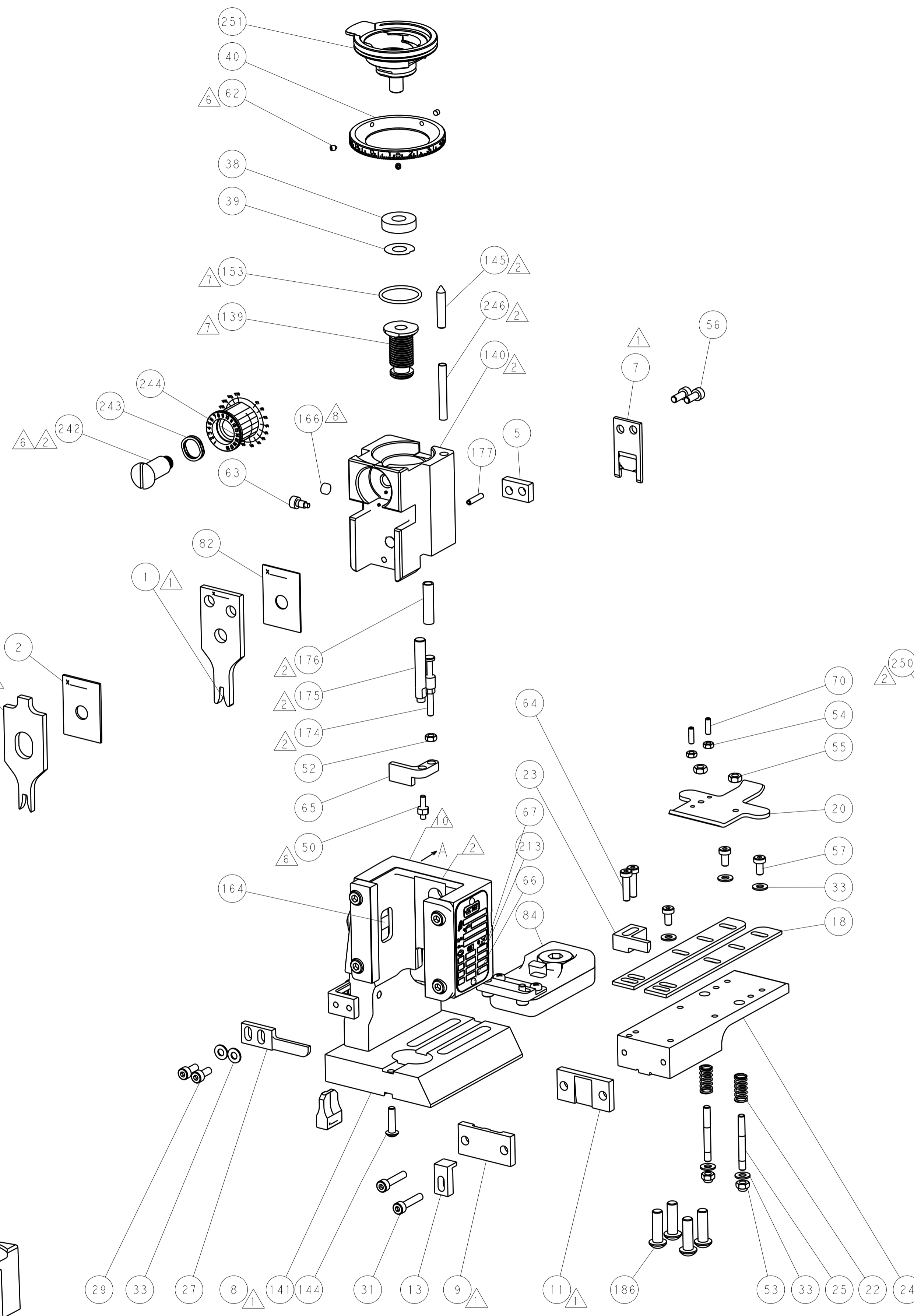
| REV | DATE | BY | APPV | DESCRIPTION | DATE | BY | APPV |
|-----------------|---------|-------------|---------|-------------|-------------|-------------------------------------|------|
| - | - | 2 | - | - | 2168400-7 | SHCS, LOW HEAD, RoHS, M5 X 10 | 240 |
| - | - | - | - | 1 | 2119580-1 | MECHANICAL 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 | 6-9931111-6 | 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 |
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| -77-27-25-22-21 | PART NO | DESCRIPTION | ITEM NO | | | | |

| | | | |
|-----------------------|---|---|--|
| DIMENSIONS: mm | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.13 2 PLC ±.013 3 PLC ±.001 4 PLC ±.0001 ANGLES ±.001 | DWN BY: YIN 14FEB2014 CHK: G. BAILEY 14FEB2014 APVD: H. GUO 14FEB2014 | NAME: Ocean End Feed Applicator SIZE: A1 CASE CODE: 00779 DRAWING NO: C=2150410 RESTRICTED TO: A |
| MATERIAL: | | WEIGHT: | SCALE: 1:1 SHEET 3 OF 4 REV A |

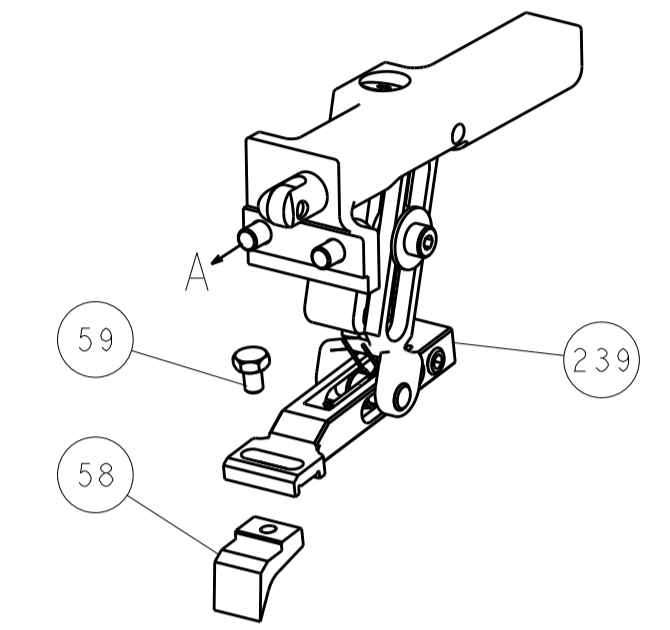
| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTM | DESCRIPTION | DATE | OWN | APVD |
| | | - | - | SEE SHEET 1 | - | - | - |



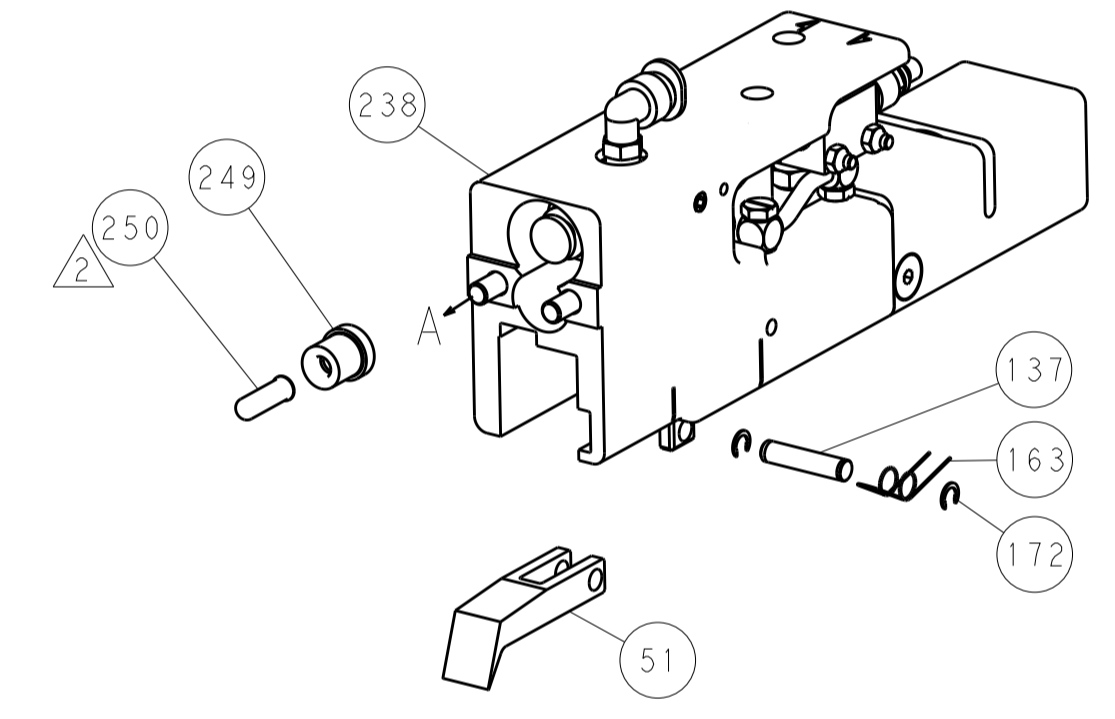
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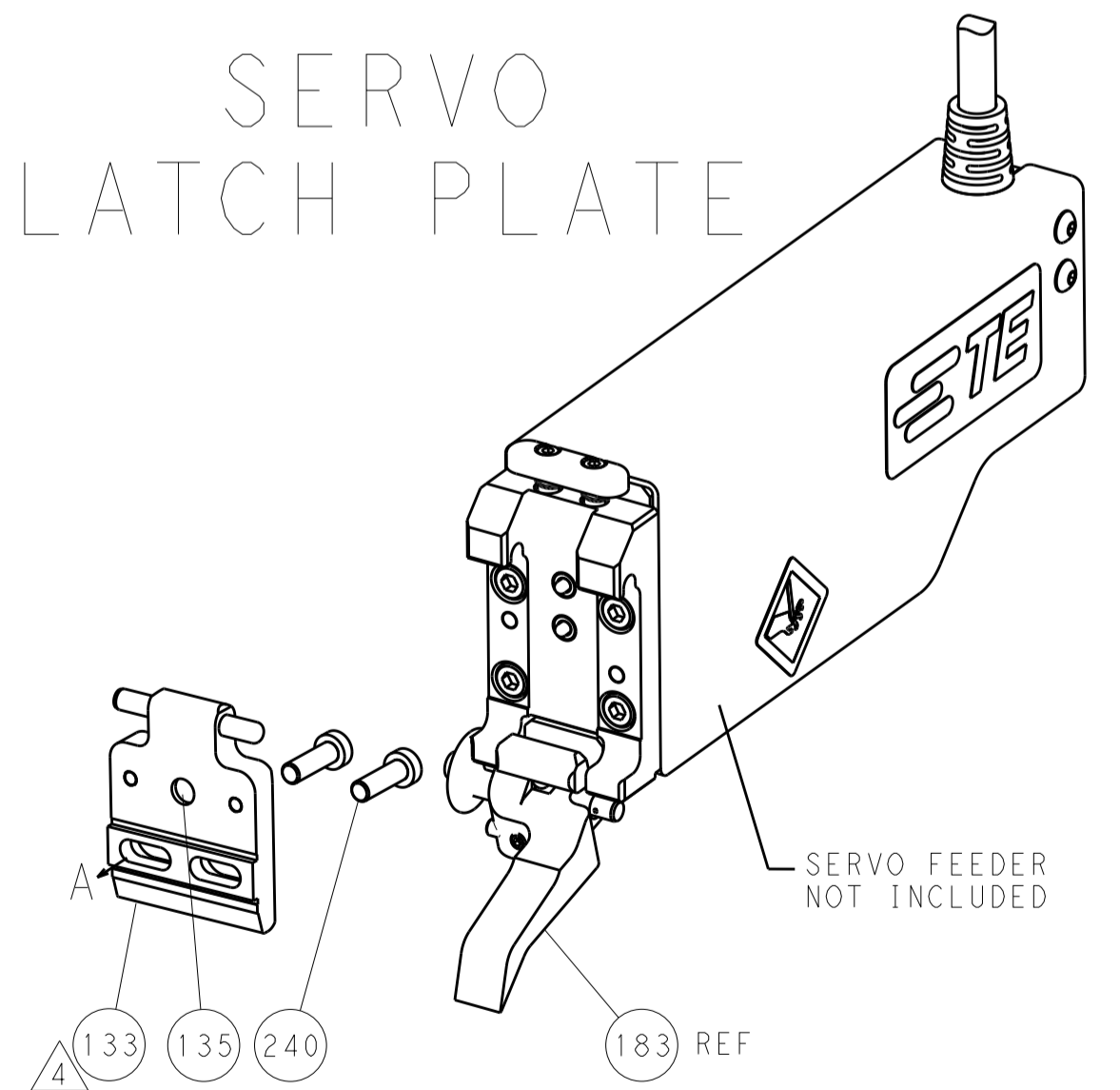
FEED TYPE
MECHANICAL



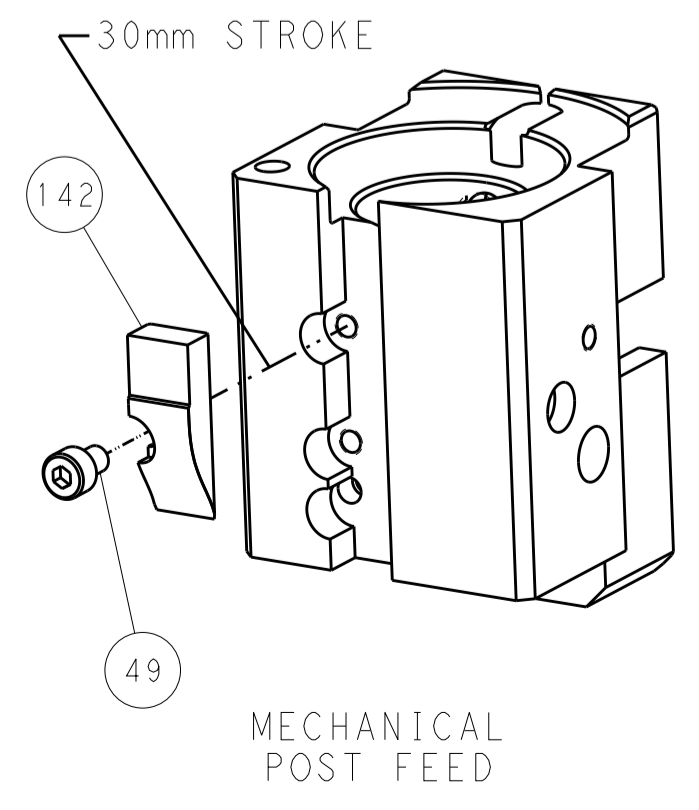
PNEUMATIC



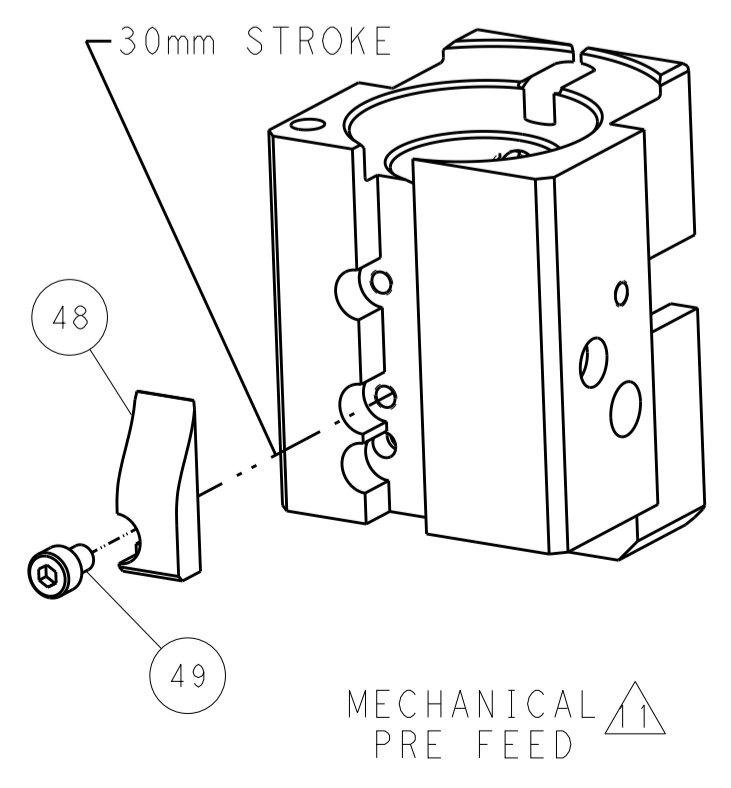
SERVO
LATCH PLATE



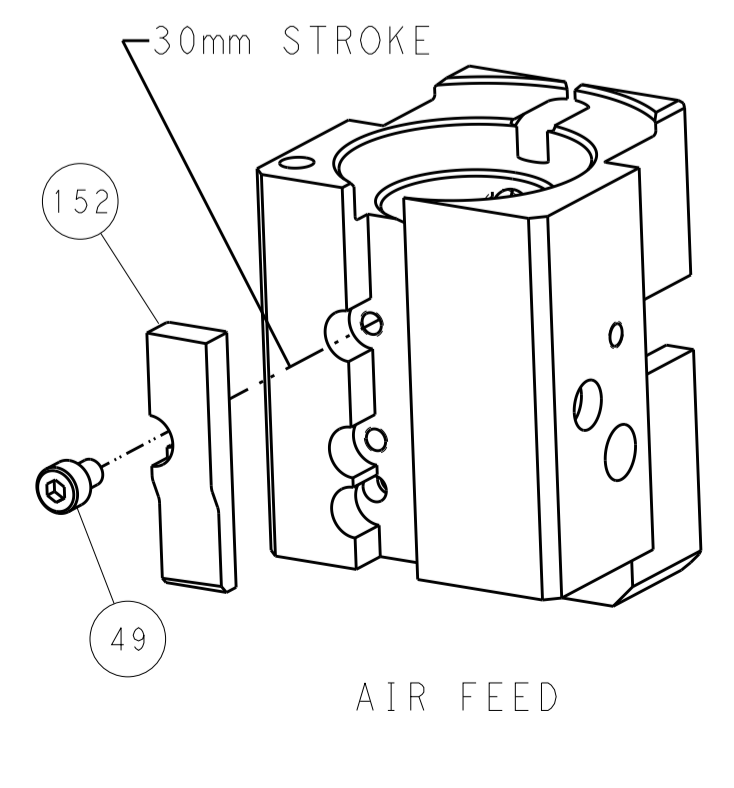
CAM POSITIONS



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: | | DWG | | REV | | NAME | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.13 | CHK | 14FEB2014 | 14FEB2014 | STE TE Connectivity Harrisburg, PA 17105-3608 | |
| | 4 PLC ±0.013 | 5 PLC ±0.001 | ANGLES ±0.001 | FINISH | APPV | 14FEB2014 | | PRODUCT SPEC | |
| MATERIAL | | | | | | | | APPLICATION SPEC | |
| | | | | | | | | WEIGHT | |
| | | | | | | | | SIZE | |
| | | | | | | | | CAGE CODE | |
| | | | | | | | | DRAWING NO | |
| | | | | | | | | RESTRICTED TO | |
| | | | | | | | | A 00779 C=2150410 | |
| | | | | | | | | Customer Accessible Production Drawing | |
| | | | | | | | | SCALE 1:1 SHEET 4 OF 4 REV A | |