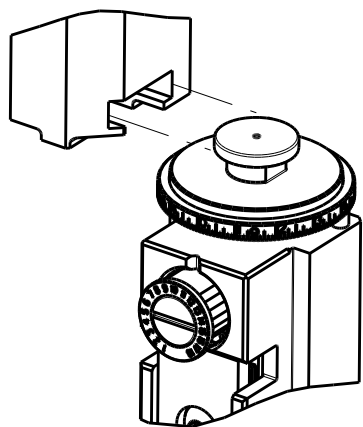


|                                                                                  |                |                          |                          |
|----------------------------------------------------------------------------------|----------------|--------------------------|--------------------------|
| 8                                                                                |                | 7                        |                          |
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| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              | PART<br>NUMBER | REVISION                 | DESCRIPTION              |
|  | 2150490-1      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2150490-2      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2150490-5      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2150490-6      | A                        | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2150490-7      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2150490-7    | A                        | CRIMP TOOLING KIT        |

|                                      |                |      |
|--------------------------------------|----------------|------|
| APPLICATOR DATA                      |                |      |
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.79 mm [.110] | F    |
| INSUL                                | 3.81 mm [.150] | OV   |
| APPLICATOR INSTRUCTIONS<br>408-10390 |                |      |

|                                                           |                     |                              |                 |
|-----------------------------------------------------------|---------------------|------------------------------|-----------------|
| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                     |                              |                 |
| TERMINAL NAME: .250 FAST-ON TYPE RECEPTACLE               |                     |                              |                 |
| WIRE STRIP LENGTH                                         |                     | INSULATION DIAMETER RANGE    |                 |
| 5.00-5.50 mm [.197-.217 IN]                               |                     | Ø1.60-3.00 mm [.063-.118 IN] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | WIRE WT10-115-1 Rev | -                            | -               |
| TERMINALS APPLIED                                         |                     |                              |                 |
| TE TERMINAL                                               | YAZAKI TERMINAL     | TE TERMINAL                  | YAZAKI TERMINAL |
| 1572413-1                                                 | 7116-2090(TF0497)   | 1572413-2                    | 7116-2090-02    |

|                   |  |                            |  |                                             |
|-------------------|--|----------------------------|--|---------------------------------------------|
| WIRE SIZE         |  | CRIMP HEIGHT mm [INCH]     |  | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
| 14 AWG OR 2.00mm2 |  | 1.45+/-0.05 [.057+/- .002] |  | 7.9                                         |
| 16 AWG OR 1.25mm2 |  | 1.35+/-0.05 [.053+/- .002] |  | 9.4                                         |
| 0.5mm2+0.5mm2     |  | 1.30+/-0.05 [.051+/- .002] |  | 9.9                                         |
| 18 AWG OR 0.85mm2 |  | 1.20+/-0.05 [.047+/- .002] |  | 10.8                                        |



- 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: 8-2150490-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150490-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150490-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150490-6
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

\*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     |
| -   | -  | -  | -  | 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  | 2119082-2 | CAM, SNAIL, INSULATION ADJUSTMENT    | 244     |
| -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)

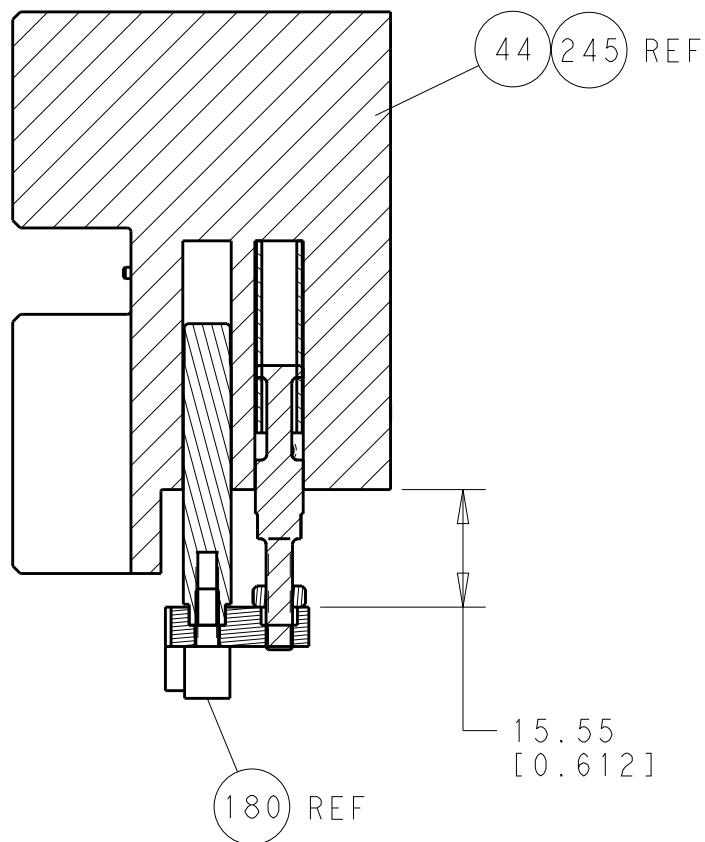
|                           |          |            |           |     |             |           |
|---------------------------|----------|------------|-----------|-----|-------------|-----------|
| SET UP GAUGE<br>2119599-2 | LOC<br>A | DIST<br>66 | REVISIONS |     |             |           |
|                           |          |            | P         | LTR | DESCRIPTION | DATE      |
|                           |          |            |           | 1   | DEVELOPMENT | 19SEP2014 |
|                           |          |            |           | A   | RELEASED    | 22OCT2014 |
|                           |          |            |           |     |             |           |
|                           |          |            |           |     |             |           |

|   |                 |        |   |   |   |             |                                     |     |
|---|-----------------|--------|---|---|---|-------------|-------------------------------------|-----|
| - | 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 | 1-1752354-2 | 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 |
| - | REFREFREFREFREF | -      | - | - | - | 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 | 2063961-1   | 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 | 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 | 1-1752371-0 | 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 | 1901259-5   | GUIDE, LOWER STRIP                  | 18  |
| - | 4               | 4      | 4 | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12)           | 17  |
| - | 1               | 1      | 1 | 1 | 1 | 6-240641-4  | SPACER                              | 16  |
| - | 1               | 1      | 1 | 1 | 1 | 1752360-1   | SPACER, HOLD-DOWN                   | 13  |
| - | 1               | 1      | 1 | 1 | 1 | 240833-3    | PLATE, REAR SHEAR                   | 11  |

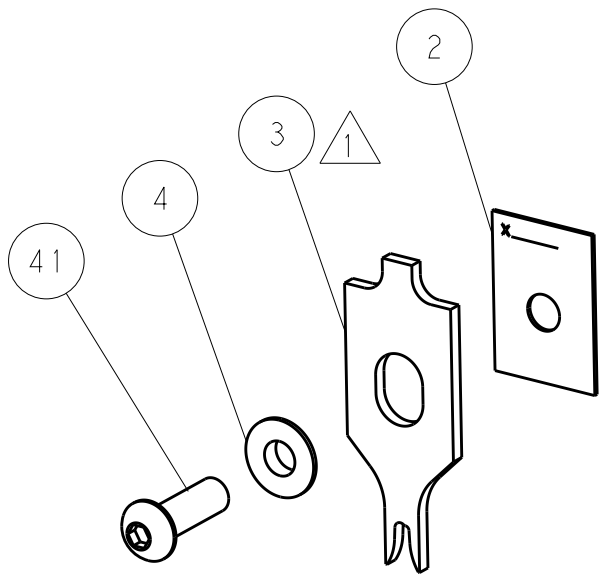
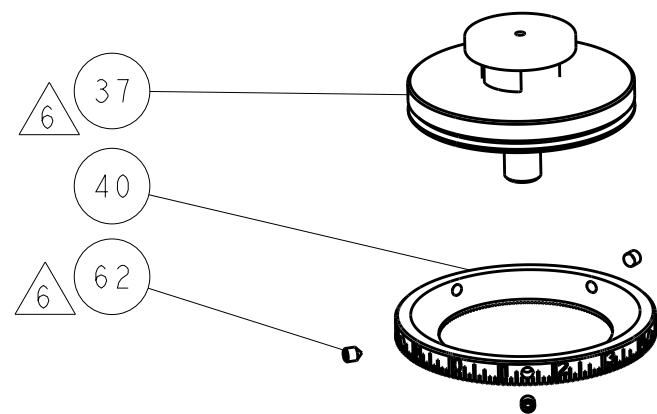
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|-----|----|----|----|----|----|---------|-------------|-------------------------------------|
| -   | -  | -  | -  | -  | -  | -       | -           | 10                                  |
| -   | 1  | 1  | 1  | 1  | 1  | 1       | 6-690482-7  | PLATE, FRONT SHEAR                  |
| 1   | 1  | 1  | 1  | 1  | 1  | 1       | 1-1803060-6 | ANVIL, COMBINATION, END FEED        |
| -   | 1  | 1  | 1  | 1  | 1  | 1       | 1-2217206-3 | BLADE, SLUG                         |
| -   | -  | -  | -  | -  | -  | -       | -           | 6                                   |
| -   | 1  | 1  | 1  | 1  | 1  | 1       | 240641-3    | SPACER                              |
| -   | 1  | 1  | 1  | 1  | 1  | 1       | 238009-1    | BLOCK, FL CRIMPER SPACER            |
| 1   | 1  | 1  | 1  | 1  | 1  | 1       | 6-2119785-3 | CRIMPER, INSULATION OVERLAP PREMIUM |
| -   | 1  | 1  | 1  | 1  | 1  | 1       | 455888-7    | SPACER, CRIMPER                     |
| 1   | 1  | 1  | 1  | 1  | 1  | 1       | 3-456408-3  | CRIMPER, WIRE PREMIUM               |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO                             |

|                                                                                                                                                       |  |                                                                                      |  |                                                      |                                     |                                              |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------|--|------------------------------------------------------|-------------------------------------|----------------------------------------------|--|
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| DIMENSIONS:                                                                                                                                           |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                                               |  | NAME                                                 |                                     | Ocean End Feed<br>Applicator                 |  |
| mm                                                                                                                                                    |  | 0 PLC ±.5<br>1 PLC ±0.5<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.001<br>ANGLES ±.5 |  | PRODUCT SPEC                                         |                                     | SIZE                                         |  |
|                                                                                                                                                       |  | FINISH                                                                               |  | APPLICATION SPEC                                     |                                     | CAGE CODE                                    |  |
| MATERIAL                                                                                                                                              |  | FINISH                                                                               |  | WEIGHT                                               |                                     | DRAWING NO                                   |  |
| -                                                                                                                                                     |  | -                                                                                    |  | -                                                    |                                     | 00779                                        |  |
| -                                                                                                                                                     |  | -                                                                                    |  | -                                                    |                                     | ©=2150490                                    |  |
| Customer Accessible Production Drawing                                                                                                                |  | SCALE                                                                                |  | 1:1                                                  |                                     | SHEET 1 OF 4                                 |  |
| -                                                                                                                                                     |  | -                                                                                    |  | -                                                    |                                     | REV A                                        |  |

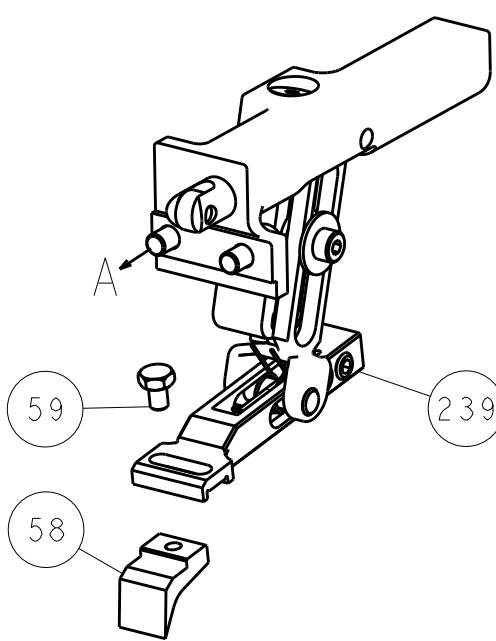
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| A   | 66 | P    | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    |     | SEE SHEET 1 | -    | -   | -    |
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|     |    |      |     |             |      |     |      |



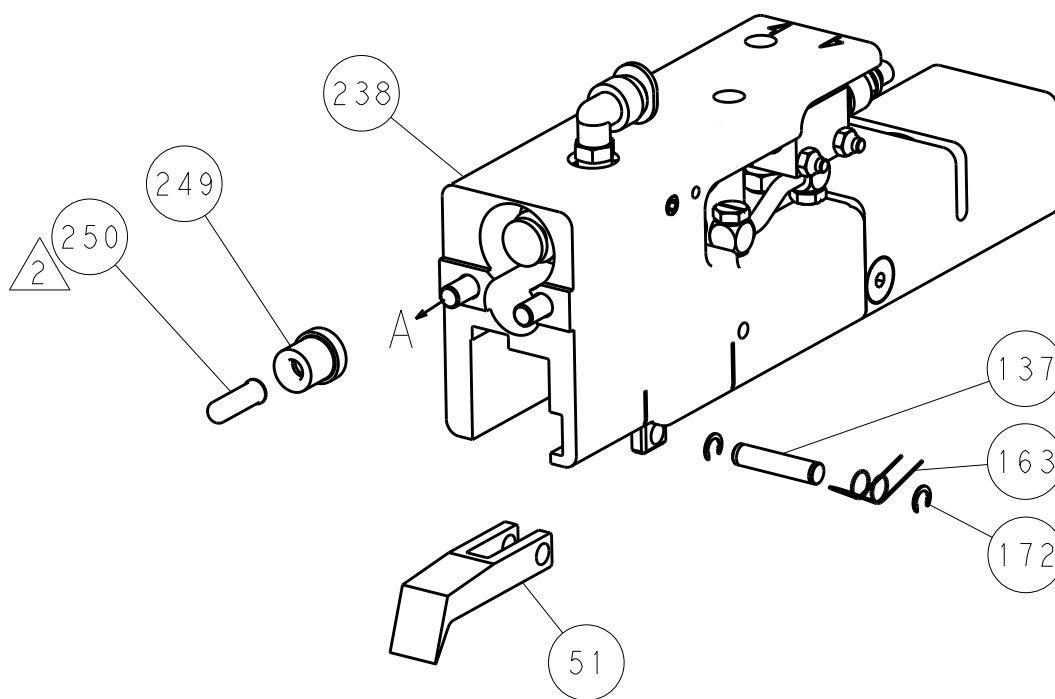
HOLDDOWN SET-UP



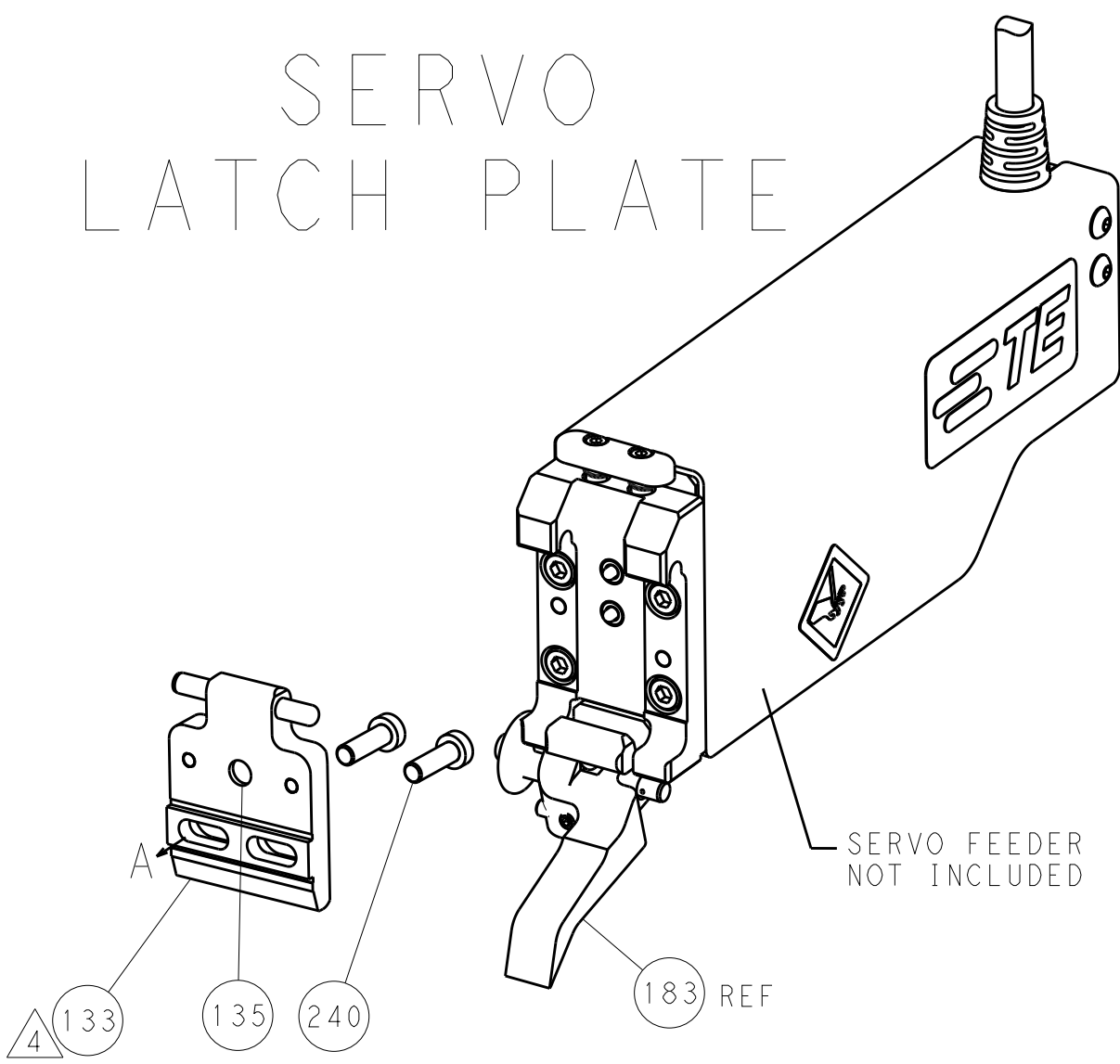
FEED TYPE  
MECHANICAL



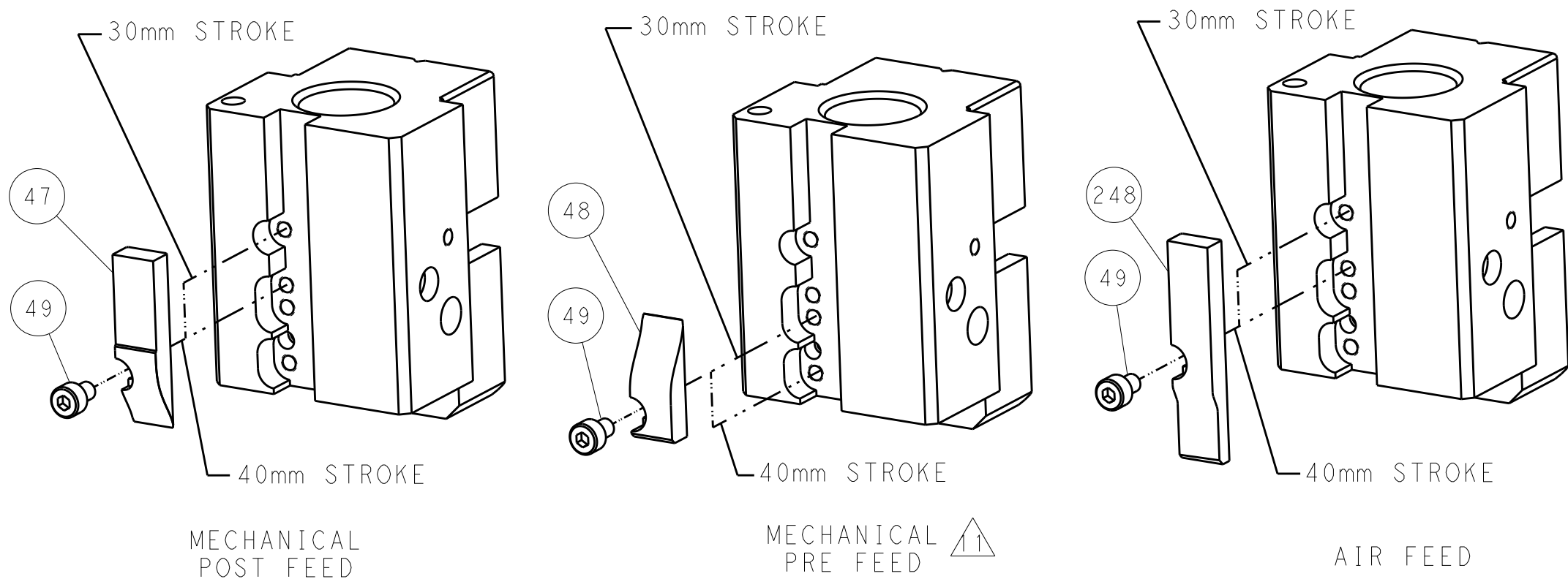
PNEUMATIC



SERVO  
LATCH PLATE

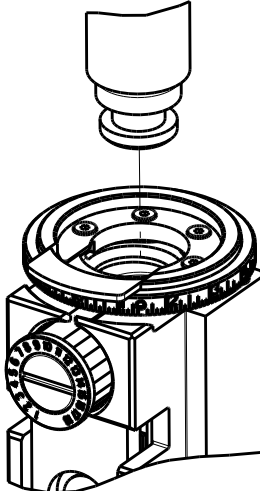


CAM POSITIONS



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

|                                                                                                                                                                                              |  |  |  |                        |  |  |  |                                        |  |  |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|------------------------|--|--|--|----------------------------------------|--|--|--|
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| CHK L. ZHANG 19SEP2014                                                                                                                                                                       |  |  |  | NAME                   |  |  |  | Ocean End Feed                         |  |  |  |
| APVD J. GUO 20MAR2014                                                                                                                                                                        |  |  |  | PRODUCT SPEC           |  |  |  | Applicator                             |  |  |  |
| APPLICATION SPEC                                                                                                                                                                             |  |  |  | SIZE                   |  |  |  | Customer Accessible Production Drawing |  |  |  |
| MATERIAL                                                                                                                                                                                     |  |  |  | WEIGHT                 |  |  |  | SCALE 1:1                              |  |  |  |
| FINISH                                                                                                                                                                                       |  |  |  | CAGE CODE              |  |  |  | SHEET 2 OF 4                           |  |  |  |
| Customer Accessible Production Drawing                                                                                                                                                       |  |  |  | 00779 ©=2150490        |  |  |  | REV A                                  |  |  |  |

|                                                                                  |                |                                                                                   |                          |
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| PACIFIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                               | PART<br>NUMBER | REVISION                                                                          | DESCRIPTION              |
|  | 2-2150490-1    | A                                                                                 | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2-2150490-2    | A                                                                                 | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2-2150490-5    | A                                                                                 | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2-2150490-7    | A                                                                                 | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2150490-7    | A                                                                                 | CRIMP TOOLING KIT        |
|                                                                                  |                |                                                                                   |                          |
| APPLICATOR DATA                                                                  |                |                                                                                   |                          |
| CRIMP                                                                            | SIZE           | TYPE                                                                              |                          |
| WIRE                                                                             | 2.79 mm [.110] | F                                                                                 |                          |
| INSUL                                                                            | 3.81 mm [.150] | OV                                                                                |                          |
| APPLICATOR INSTRUCTIONS<br>408-10390                                             |                |  |                          |

|                                                           |                           |                                                           |                 |
|-----------------------------------------------------------|---------------------------|-----------------------------------------------------------|-----------------|
| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                           |                                                           |                 |
| TERMINAL NAME: .250 FAST-ON TYPE RECEPTACLE               |                           |                                                           |                 |
| WIRE STRIP LENGTH<br>5.00-5.50 mm [.197-.217 IN]          |                           | INSULATION DIAMETER RANGE<br>Ø1.60-3.00 mm [.063-.118 IN] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | TERMS 72-WT10-115-1 Rev - | -                                                         | -               |
| TERMINALS APPLIED                                         |                           |                                                           |                 |
| TE TERMINAL                                               | YAZAKI TERMINAL           | TE TERMINAL                                               | YAZAKI TERMINAL |
| 1572413-1                                                 | 7116-2090(TF0497)         | 1572413-2                                                 | 7116-2090-02    |

|                   |  |                            |  |                                             |
|-------------------|--|----------------------------|--|---------------------------------------------|
| WIRE SIZE         |  | CRIMP HEIGHT mm [INCH]     |  | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
| 14 AWG OR 2.00mm2 |  | 1.45+/-0.05 [.057+/- .002] |  | 7.9                                         |
| 16 AWG OR 1.25mm2 |  | 1.35+/-0.05 [.053+/- .002] |  | 9.4                                         |
| 0.5mm2+0.5mm2     |  | 1.30+/-0.05 [.051+/- .002] |  | 9.9                                         |
| 18 AWG OR 0.85mm2 |  | 1.20+/-0.05 [.047+/- .002] |  | 10.8                                        |



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150490-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150490-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150490-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> 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.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.

\*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  | 2119082-2 | 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 |

<sup>6</sup>

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

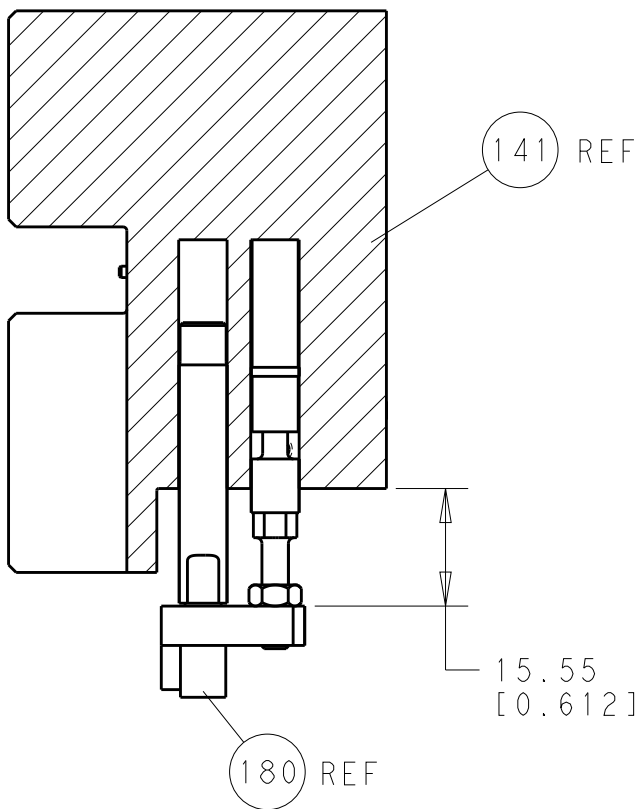
|                           |          |            |           |     |             |      |
|---------------------------|----------|------------|-----------|-----|-------------|------|
| SET UP GAUGE<br>2119599-2 | LOC<br>A | DIST<br>66 | REVISIONS |     |             |      |
|                           |          |            | P         | LTR | DESCRIPTION | DATE |
|                           |          |            | -         | -   | 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   | 1-1752354-2 | STANDOFF, HOLD-DOWN                 | 180     |
| -    | 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   | 455888-5    | SPACER, CRIMPER                     | 82      |
| -    | 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   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -    | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| -    | 1   | 1   | 1   | 1   | 1901681-1   | 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   | 2   | 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   | 1-1752371-0 | PLATE, STRIP GUIDE                  | 24      |
| -    | 1   | 1   | 1   | 1   | 240825-1    | 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   | 6-240641-4  | SPACER                              | 16      |
| -    | 1   | 1   | 1   | 1   | 1752360-1   | SPACER, HOLD-DOWN                   | 13      |
| -    | 1   | 1   | 1   | 1   | 240833-3    | PLATE, REAR SHEAR                   | 11      |
| -    | -   | -   | -   | -   | -           | -                                   | 10      |
| -    | 1   | 1   | 1   | 1   | 6-690482-7  | PLATE, FRONT SHEAR                  | 9       |
| -    | 1   | 1   | 1   | 1   | 1-1803060-6 | ANVIL, COMBINATION, END FEED        | 8       |
| -    | 1   | 1   | 1   | 1   | 1-2217206-3 | BLADE, SLUG                         | 7       |
| -    | -   | -   | -   | -   | -           | -                                   | 6       |
| -    | 1   | 1   | 1   | 1   | 240641-3    | SPACER                              | 5       |
| -    | 1   | 1   | 1   | 1   | 238009-1    | BLOCK, FL CRIMPER SPACER            | 4       |
| -    | 1   | 1   | 1   | 1   | 6-2119785-3 | CRIMPER, INSULATION OVERLAP PREMIUM | 3       |
| -    | 1   | 1   | 1   | 1   | 455888-7    | SPACER, CRIMPER                     | 2       |
| -    | 1   | 1   | 1   | 1   | 3-456408-3  | CRIMPER, WIRE PREMIUM               | 1       |
| -77- | 27  | 25  | 22  | 21  | PART NO     | DESCRIPTION                         | ITEM NO |

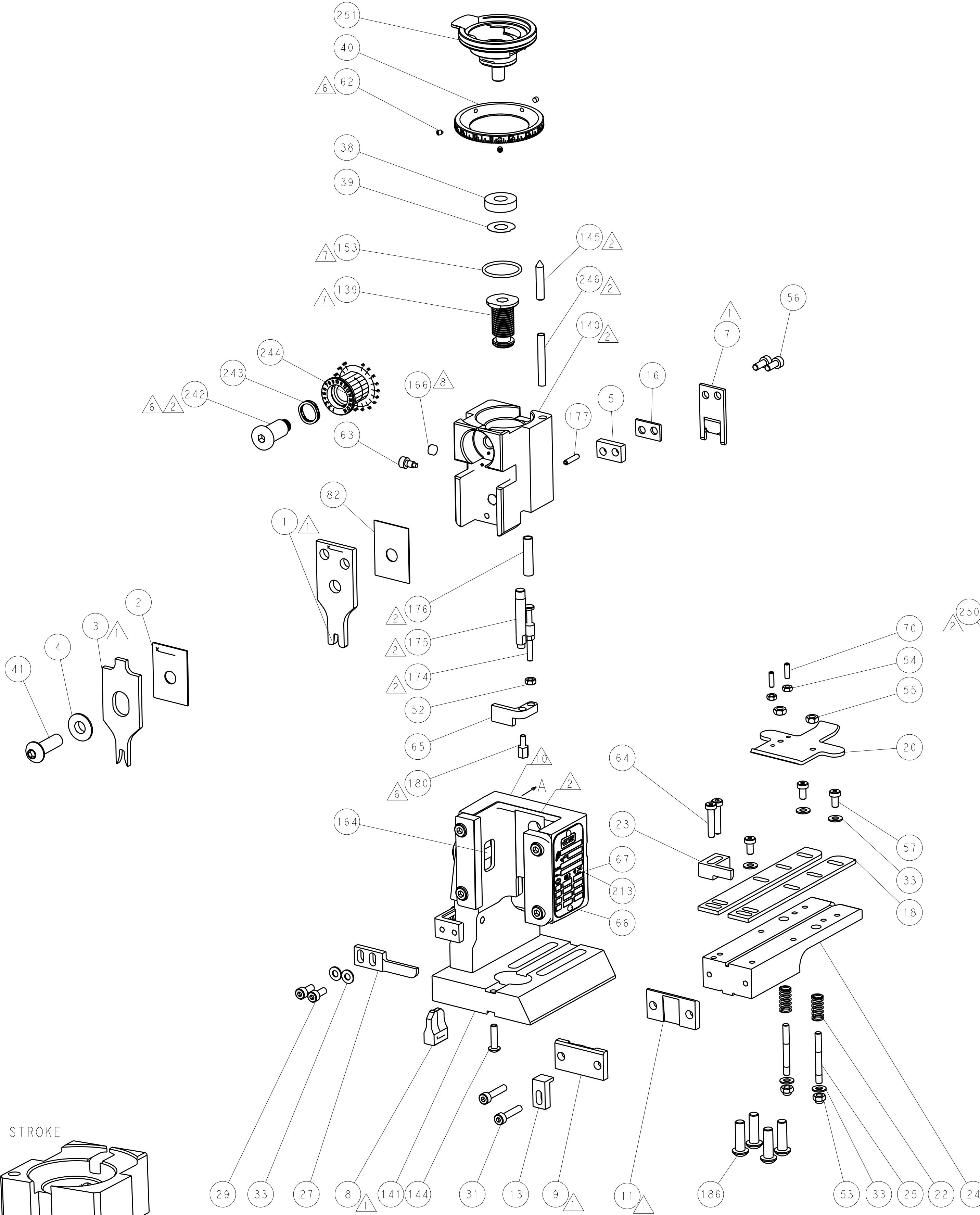
|                                                                                                                            |  |                                                                                       |                                     |                                                  |  |  |  |
|----------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------|-------------------------------------|--------------------------------------------------|--|--|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS. |  | DWN<br>K. HUANG<br>CHK<br>L. ZHANG<br>APVD<br>J. GUO                                  | ZOMAR2014<br>ZOMAR2014<br>ZOMAR2014 | STE TE Connectivity<br>Harrisburg, PA 17105-3608 |  |  |  |
| DIMENSIONS:<br>mm                                                                                                          |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                |                                     | NAME<br>Ocean End Feed<br>Applicator             |  |  |  |
|                                                                                                                            |  | 0 PLC ±.5<br>1 PLC ±0.13<br>2 PLC ±0.13<br>3 PLC ±0.13<br>4 PLC ±0.0001<br>ANGLES ±.5 |                                     | PRODUCT SPEC                                     |  |  |  |
| MATERIAL                                                                                                                   |  | FINISH                                                                                |                                     | APPLICATION SPEC                                 |  |  |  |
| -                                                                                                                          |  | -                                                                                     |                                     | WEIGHT                                           |  |  |  |
| -                                                                                                                          |  | -                                                                                     |                                     | A1 00779 ©=2150490                               |  |  |  |
| Customer Accessible Production Drawing                                                                                     |  | SCALE                                                                                 |                                     | 1:1 SHEET 3 OF 4 REV A                           |  |  |  |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

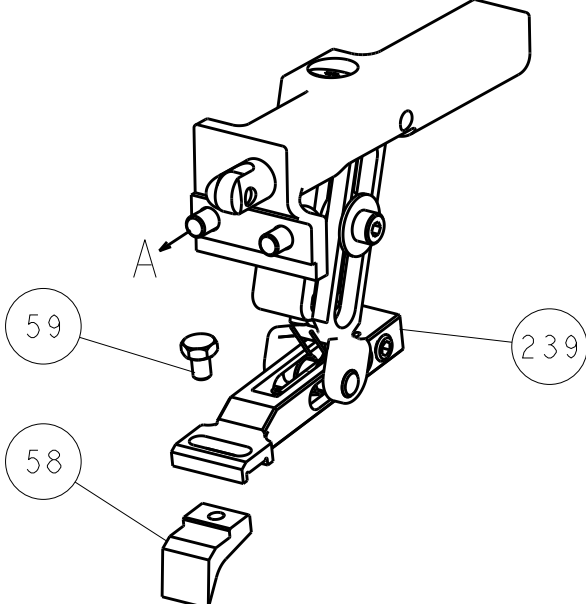
| LOC |    | DIST |     | REVISONS    |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    |     | SEE SHEET 1 | -    | -   | -    |
|     |    |      |     |             |      |     |      |
|     |    |      |     |             |      |     |      |
|     |    |      |     |             |      |     |      |



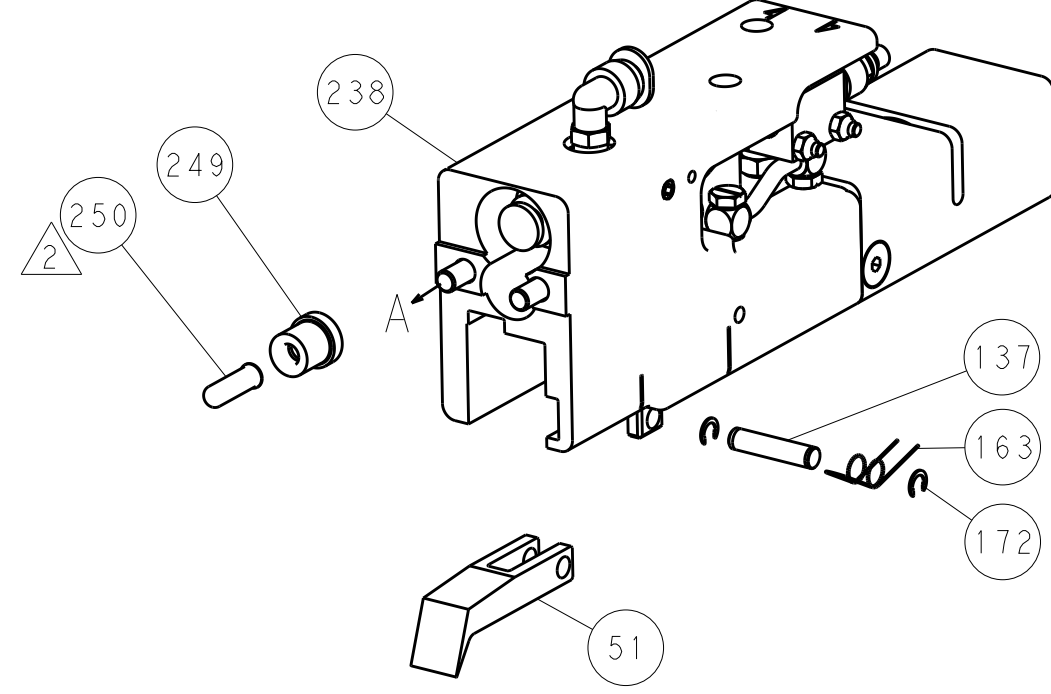
HOLDDOWN SET-UP



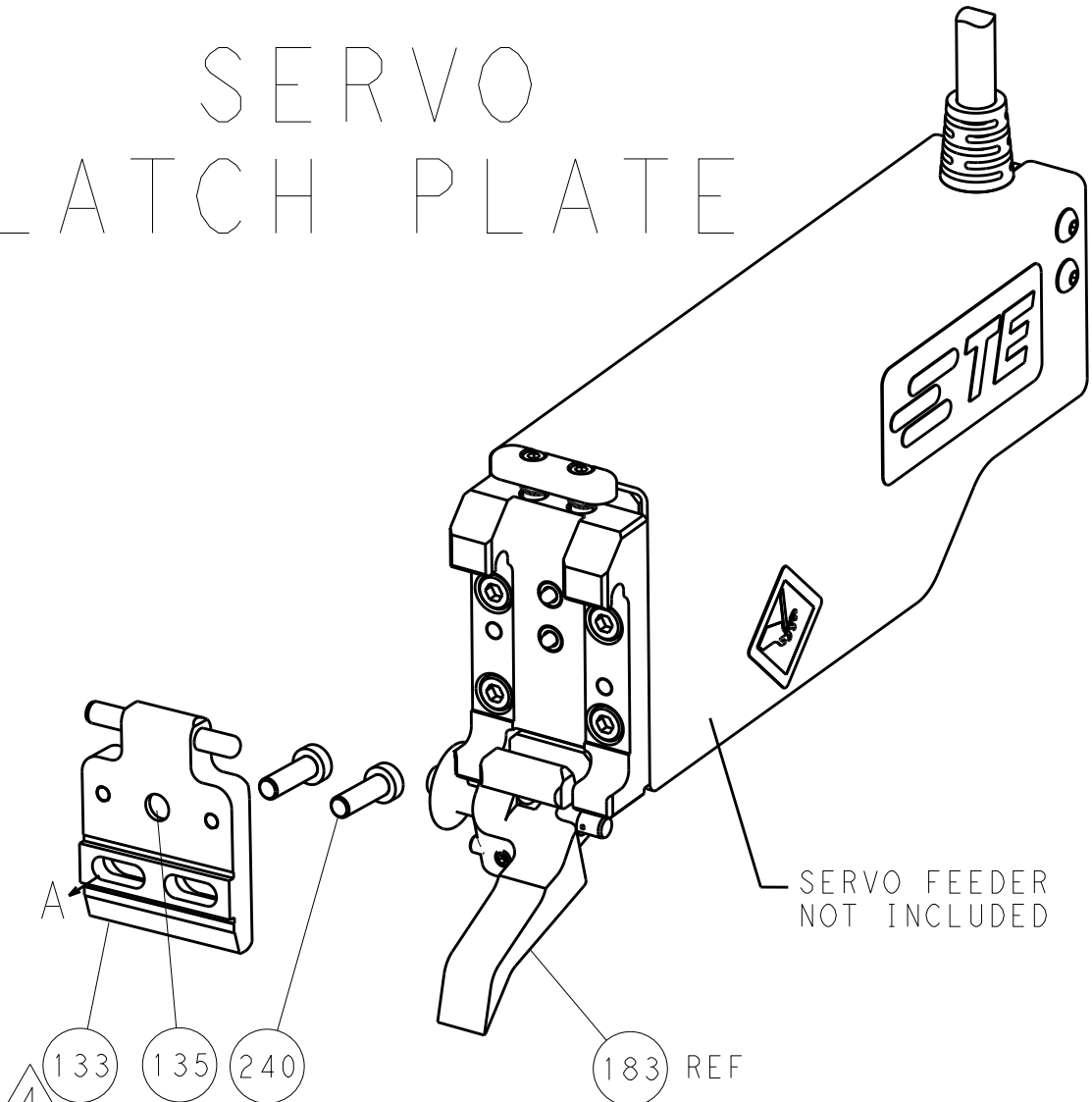
FEED TYPE  
MECHANICAL



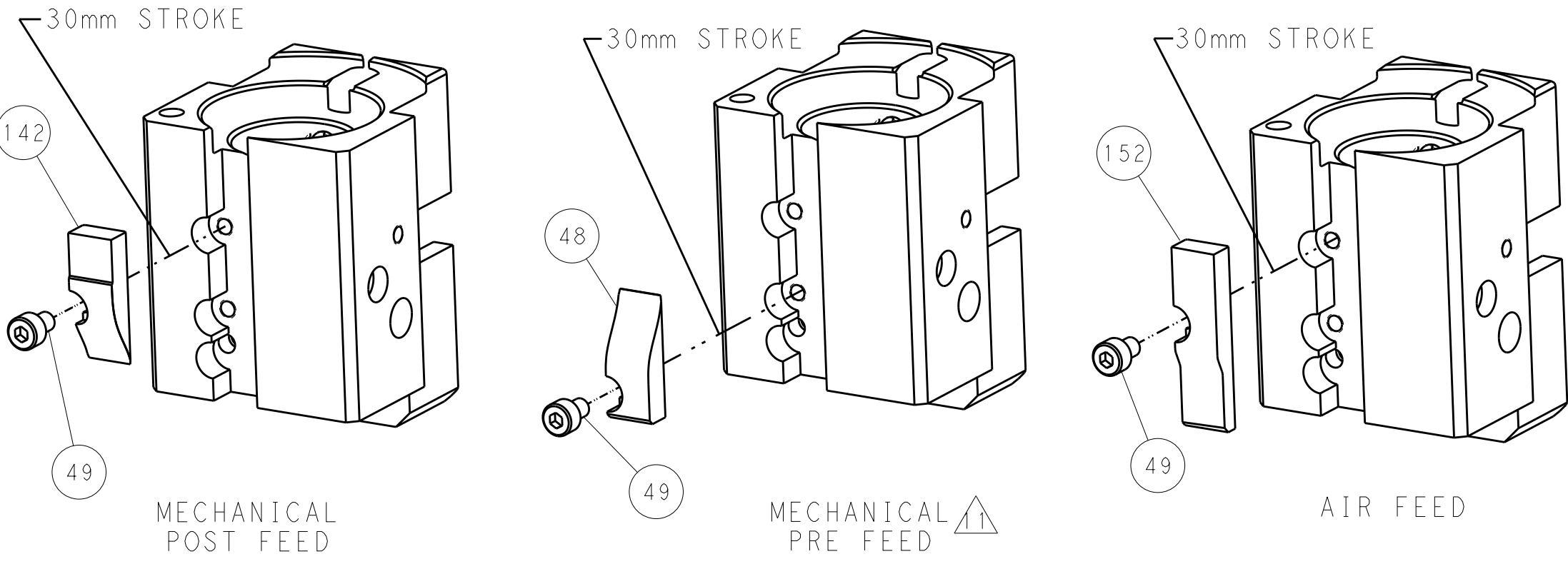
PNEUMATIC



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                                    |  | CHK      |  | NAME         |  |
| mm          |  | 0 PLC ±0.5                             |  | K. HUANG                               |  | L. ZHANG |  | ZOMAR2014    |  |
|             |  | 1 PLC ±0.13                            |  | APVD                                   |  | U. GUO   |  | ZOMAR2014    |  |
|             |  | 2 PLC ±0.13                            |  | PRODUCT SPEC                           |  |          |  |              |  |
|             |  | 3 PLC ±0.013                           |  | APPLICATION SPEC                       |  |          |  |              |  |
|             |  | 4 PLC ±0.0001                          |  | WEIGHT                                 |  |          |  |              |  |
| MATERIAL    |  | FINISH                                 |  | Customer Accessible Production Drawing |  | SCALE    |  | SHEET 4 OF 4 |  |
|             |  |                                        |  |                                        |  | 1:1      |  | REV A        |  |