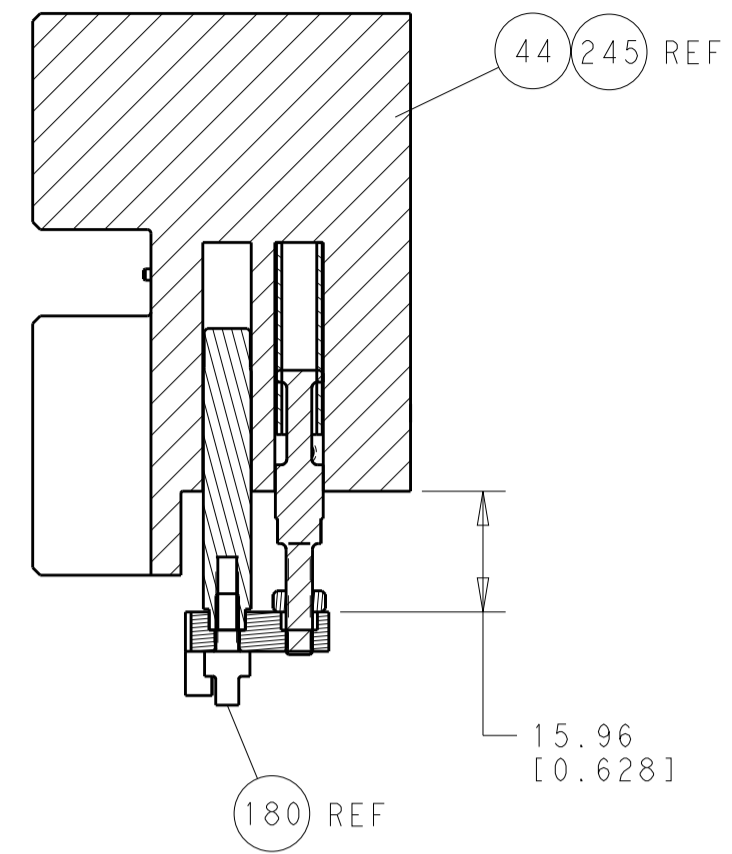


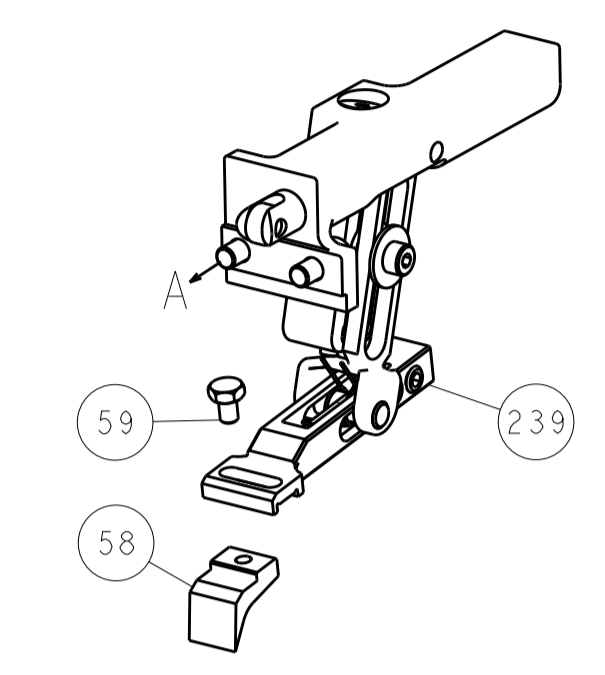


| LOC | DIST | REV         | DATE | BY | APPV |
|-----|------|-------------|------|----|------|
| A   | 66   |             |      |    |      |
|     |      | REVISIONS   |      |    |      |
|     |      | DESCRIPTION | DATE | BY | APPV |
|     |      | SEE SHEET 1 |      |    |      |

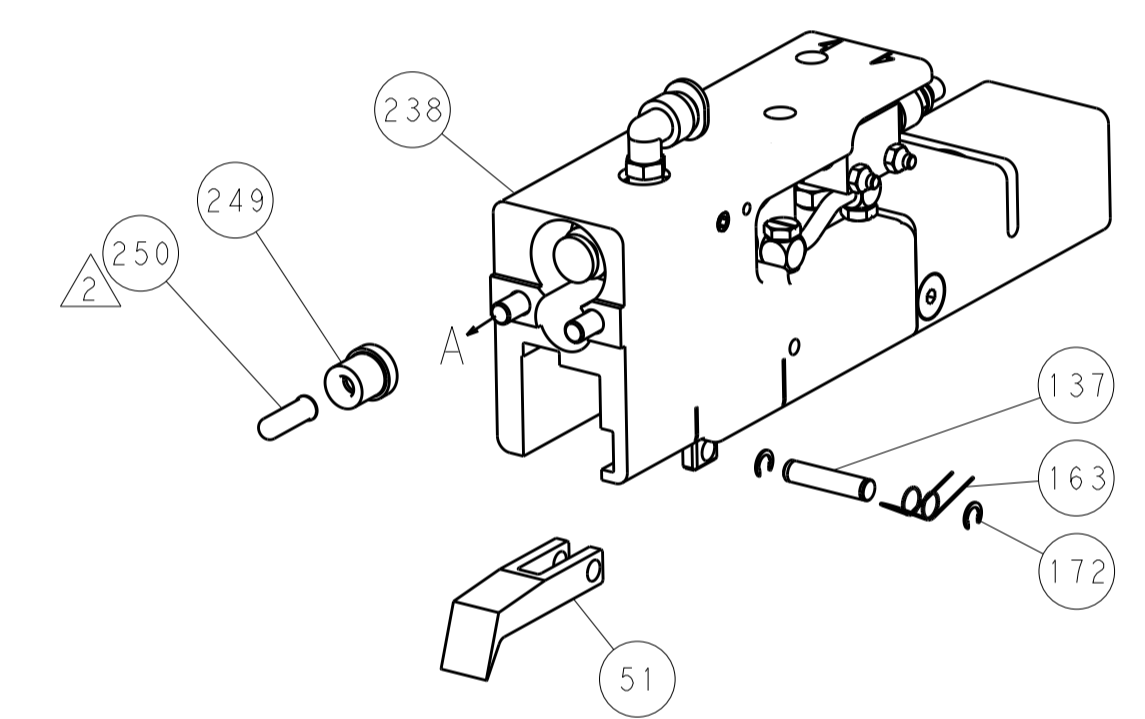


HOLDDOWN SET-UP

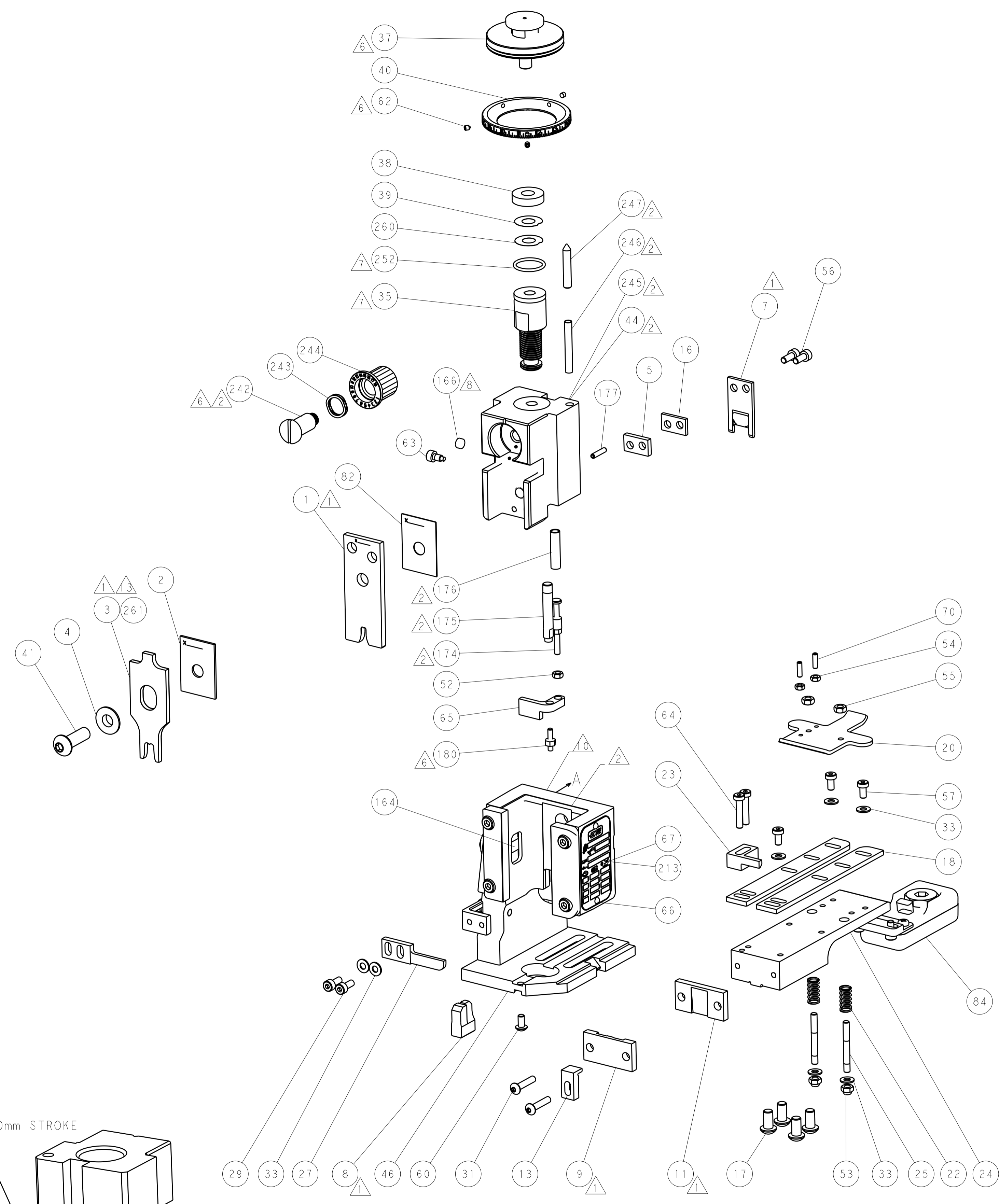
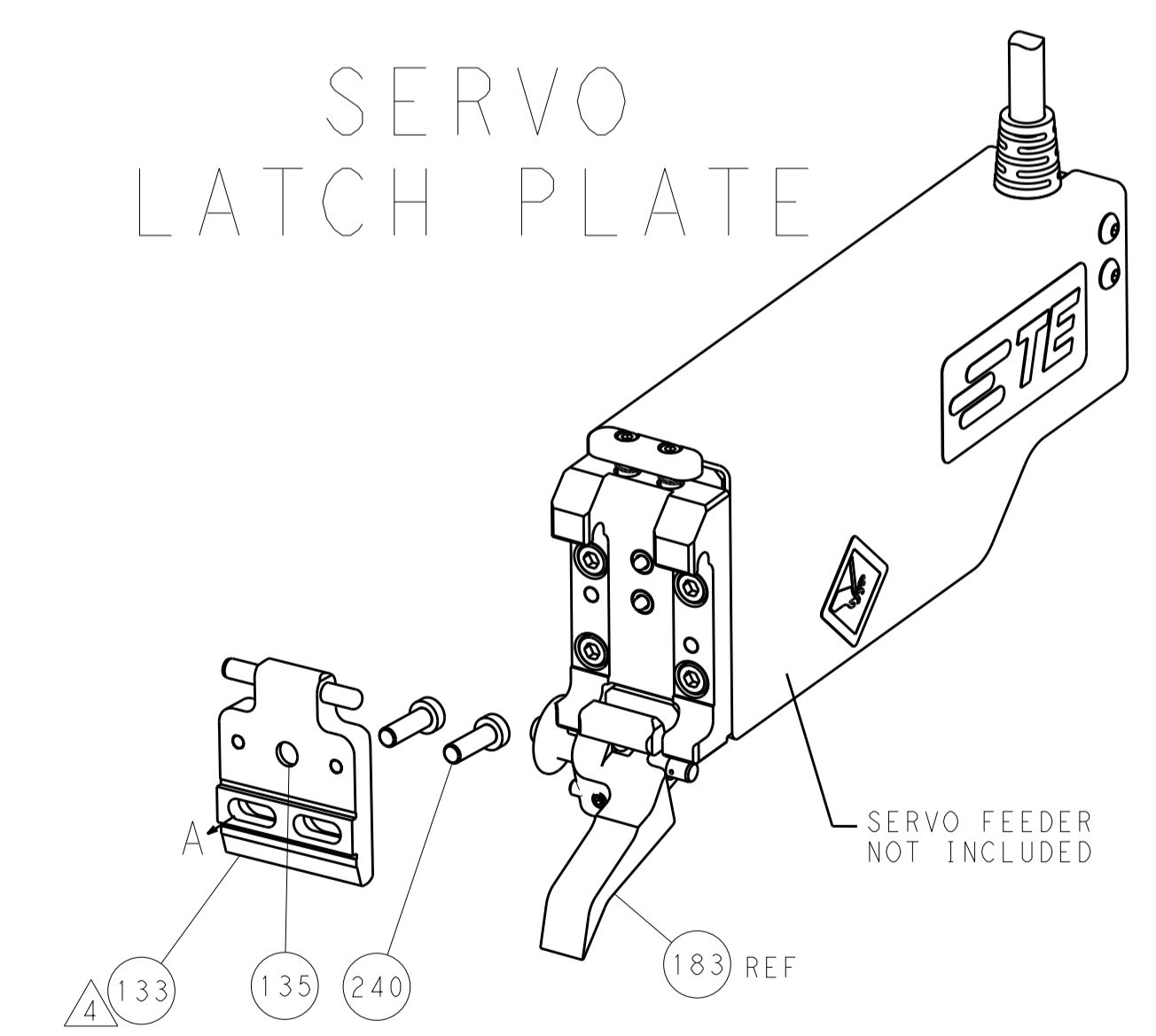
FEED TYPE  
MECHANICAL



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: X.ZHAO 14MAR2014                  |  | TE Connectivity                 |  |
| mm          |  | 0 PLC ±0.5                             |  | CHK: L.ZHANG 14MAR2014                 |  | Harrisburg, PA 17105-3608       |  |
| Ø           |  | 1 PLC ±0.13                            |  | APPV: J.FELBIN 14MAR2014               |  | NAME: Ocean End Feed Applicator |  |
| H           |  | 2 PLC ±0.013                           |  | PRODUCT SPEC                           |  | SIZE: CAGE CODE DRAWING NO      |  |
| L           |  | 3 PLC ±0.001                           |  | APPLICATION SPEC                       |  | A11 00779 ©=2150425             |  |
| R           |  | 4 PLC ±0.001                           |  | WEIGHT                                 |  | RESTRICTED TO                   |  |
| ANGLES      |  | FINISH                                 |  | Customer Accessible Production Drawing |  | SCALE: 1:1 SHEET 2 OF 4 REV B   |  |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      |
|--|-------------|----------|--------------------------|--------------------------------|
|  | 2-2150425-1 | B        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     |
|  | 2-2150425-2 | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      |
|  | 2-2150425-5 | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> |
|  | 2-2150425-7 | B        | FINE CRIMP HEIGHT ADJUST | NONE                           |
|  | 7-2150425-7 | A        | CRIMP TOOLING KIT        | -                              |

| APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |   |                        |  |  |  |  |  |
|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|--|--|--|--|--|
| CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |   |                        |  |  |  |  |  |
| PNEUMATIC FEED                    | 2119950-1             | 2119792-1 | -           | 2119641-2 | - | 2063440-1              |  |  |  |  |  |
| SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150425-5 | -         | - | 2168400-7 (QUANTITY 2) |  |  |  |  |  |
| SMART APPLICATOR                  | 2161326-1             | -         | 8-2150425-4 | -         | - | -                      |  |  |  |  |  |
| MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-2 | - | -                      |  |  |  |  |  |
| SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150425-5 | -         | - | 2168400-7 (QUANTITY 2) |  |  |  |  |  |
| SMART APPLICATOR                  | 2161326-1             | -         | 8-2150425-4 | -         | - | -                      |  |  |  |  |  |
| MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-2 | - | -                      |  |  |  |  |  |
| PNEUMATIC FEED                    | 2119950-1             | 2119792-1 | -           | 2119641-2 | - | 2063440-1              |  |  |  |  |  |

| APPLICATOR DATA                |                |      |
|--------------------------------|----------------|------|
| CRIMP                          | SIZE           | TYPE |
| WIRE                           | 3.56 mm [.140] | F    |
| INSUL                          | 7.11 mm [.280] | F    |
| APPL INSTRUCTIONS<br>408-10390 |                |      |

| TERMINAL DATA: TE TERMINAL  | TE CRIMP SPECIFICATION                                    |
|---|---|
| TERMINAL NAME: RECEPTACLE,FASTON,LOW-INSERTION,.250 SERIES        |   |
| WIRE STRIP LENGTH<br>6.02-6.78 mm [.237-.267 IN]                  | INSULATION DIAMETER RANGE<br>Ø5.33-6.73 mm [.210-.265 IN] |
| TERMINAL APPLICATION SPECIFICATION<br>(A)114-2036<br>(B)114-35000 |   |
| TERMINALS APPLIED   |   |
| TE TERMINAL<br>(A) 63757-1  | TE TERMINAL<br>(A) 63757-2                                |
| TE TERMINAL<br>(B) 63800-1  | TE TERMINAL   |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 12 AWG    | 2.13+/-0.050 [.084+/- .002] | 6.3                            |
| 14 AWG    | 1.83+/-0.050 [.072+/- .002] | 9.7                            |
| (2) 18    | 1.75+/-0.050 [.069+/- .002] | 10.3                           |
| 16 AWG    | 1.68+/-0.05 [.066+/- .002]  | 11.2                           |

- 
- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150425-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150425-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150425-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 180 & 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.
- ITEM #261 FOR (2)18 AWG WIRE SIZES. ITEM #3 FOR ALL OTHER WIRE SIZES.

**\*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 | PART NO         | DESCRIPTION                         | ITEM NO     |
|---------|-----------------|-------------------------------------|-------------|
|         | 3-1803016-1     | CRIMPER, INSULATION F               | 261         |
|         | 2119782-1       | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251         |
|         | 2119640-1       | PUSH ROD, AIR FEED                  | 250         |
|         | 2079988-1       | BUSHING, LCH5-12, MISUMI            | 249         |
|         | 1-22279-3       | SPRING, COMPRESSION                 | 246         |
|         | 2119082-9       | CAM, SNAIL, INSULATION ADJUSTMENT   | 244         |
|         | 2079764-1       | WASHER, WAVE SPRING, CREST-TO-CREST | 243         |
|         | 2119083-1       | RETAINER, INSULATION DIAL           | 242         |
|         | 2168400-7       | SHCS, LOW HEAD, RoHS, M5 X 10       | 240         |
|         | -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)

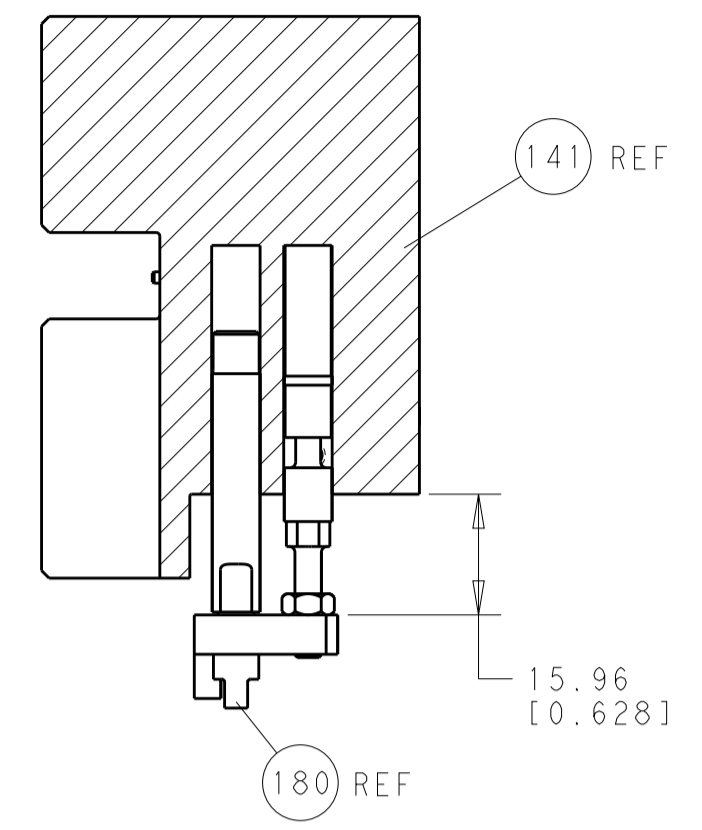
| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-2    | A   | 66   | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
|              |     |      | -         | -   | SEE SHEET 1 | -    | -   | -    |

|  |                 |                                     |             |
|--|-----------------|-------------------------------------|-------------|
|  | 2119580-1       | MECHANICAL FEED ASSEMBLY            | 239         |
|  | 2063440-1       | AIR FEED MODULE                     | 238         |
|  | 2119740-2       | TAG, IDENTIFICATION                 | 213         |
|  | 2079383-9       | SCR, BHSC, RoHS (M6 X 20)           | 186         |
|  | 1901697-1       | FEED FINGER ASSEMBLY, EF            | 183         |
|  | 1-1976055-3     | STANDOFF, HOLD-DOWN                 | 180         |
|  | 6-993111-6      | PIN, SLOTTED SPRING 3.0 X 14.0      | 177         |
|  | 8-22280-7       | SPRING, COMPRESSION                 | 176         |
|  | 1752353-2       | GUIDE PIN, HOLDDOWN                 | 175         |
|  | 1901680-2       | GUIDE PIN, HOLDDOWN                 | 174         |
|  | 21045-3         | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172         |
|  | 994969-1        | MAGNET, RARE EARTH HIGH ENERGY      | 166         |
|  | 994970-2        | COUNTER, MAGNETIC                   | 164         |
|  | 240638-1        | SPRING, FEED FINGER                 | 163         |
|  | 8-21084-1       | O-RING, .801 ID, .070 DIA. MAT.     | 153         |
|  | 2119641-2       | FEED CAM, AIR FEED                  | 152         |
|  | 2119798-2       | DETENT PIN                          | 145         |
|  | 2079383-8       | SCR, BHSC, RoHS (M4 X 16)           | 144         |
|  | 2119653-2       | FEED CAM, POST FEED                 | 142         |
|  | 2119655-6       | APPLICATOR BASIC ASSEMBLY, EF       | 141         |
|  | 2119651-1       | RAM, ASIAN STYLE, END FEED          | 140         |
|  | 2119092-2       | BOLT, ADJUSTMENT                    | 139         |
|  | 3-23627-7       | PIN, RETAIN, GRVD, 3/16 X .854      | 137         |
|  | SEE NOTE 4      | MEMORY CHIP, PROGRAMMED             | 135         |
|  | 1633743-1       | SERVO FEED LATCH ASM                | 133         |
|  | 2119955-2       | ASSY, LUBRICATOR, END FEED          | 84          |
|  | 455888-4        | SPACER, CRIMPER                     | 82          |
|  | 2119956-2       | DOCUMENTATION PACKAGE               | 71          |
|  | 2-18032-2       | SCR, SET, FLT POINT M3 X 10.0       | 70          |
|  | 2119740-1       | TAG, IDENTIFICATION                 | 67          |
|  | 2168078-1       | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66          |
|  | 1901681-1       | HOLDDOWN, TERMINAL                  | 65          |
|  | 2168400-5       | SHCS, LOW HEAD, RoHS, M4 X 20       | 64          |
|  | 2119793-1       | LIMITER, ADJUSTMENT BOLT            | 63          |
|  | 992763-5        | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62          |
|  | 5-18022-5       | SCR, HEX HD CAP, M4 X 6.0           | 59          |
|  | 2063961-1       | FEED FINGER                         | 58          |
|  | 2168400-4       | SHCS, LOW HEAD, RoHS, M4 X 8        | 57          |
|  | 1-2168083-0     | SCR, SKT HD CAP, RoHS, M4 X 10      | 56          |
|  | 5018030-2       | NUT, HEX, REG, RoHS, M4             | 55          |
|  | 5018030-1       | NUT, HEX, REG, RoHS, M3             | 54          |
|  | 986965-8        | NUT, LOCK, HEX, TORQUE (M4)         | 53          |
|  | 1-5018030-0     | NUT, HEX, REG, RoHS, M3.5           | 52          |
|  | 2119792-2       | PAWL, EF, AIR                       | 51          |
|  | 18023-9         | SCR, SKT HD CAP M4 X 6.0            | 49          |
|  | 2119652-1       | FEED CAM, PRE FEED                  | 48          |
|  | 2079383-7       | SCR, BHSC, RoHS (M8 X 25)           | 41          |
|  | 2119645-1       | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40          |
|  | 2119957-1       | APPLICATOR SHIM PACK                | 39          |
|  | 2119644-2       | RAM WASHER, PRECISION               | 38          |
|  | 1-18028-2       | WASHER, FLAT, REG M4                | 33          |
|  | 2079383-5       | SCR, BHSC, RoHS (M4 X 20)           | 31          |
|  | 1-2168083-0     | SCR, SKT HD CAP, RoHS, M4 X 10      | 29          |
|  | 240639-1        | STRIPPER (MACHINING)                | 27          |
|  | 1320906-1       | STUD, THREADED                      | 25          |
|  | 1752371-5       | PLATE, STRIP GUIDE                  | 24          |
|  | 240825-8        | PLATE, STRIP HOLD DOWN              | 23          |
|  | 2-22281-3       | SPRING, COMPRESSION                 | 22          |
|  | 1752373-4       | DRAG                                | 20          |
|  | 1901259-6       | GUIDE, LOWER STRIP                  | 18          |
|  | 240641-9        | SPACER                              | 16          |
|  | 1752360-1       | SPACER, HOLD-DOWN                   | 13          |
|  | 240644-9        | PLATE, REAR SHEAR                   | 11          |
|  | -               | -                                   | 10          |
|  | 5-690482-9      | PLATE, FRONT SHEAR                  | 9           |
|  | 4-1803000-6     | ANVIL, COMBINATION, END FEED        | 8           |
|  | 1-2217206-3     | BLADE, SLUG                         | 7           |
|  | -               | -                                   | 6           |
|  | 240641-8        | SPACER                              | 5           |
|  | 238009-1        | BLOCK, FL CRIMPER SPACER            | 4           |
|  | 3-1803016-4     | CRIMPER, INSULATION F               | 3           |
|  | 1-455888-2      | SPACER, CRIMPER                     | 2           |
|  | 456425-8        | CRIMPER, WIRE .140 F PREMIUM        | 1           |
|  | -77-27-25-22-21 | PART NO                             | DESCRIPTION |

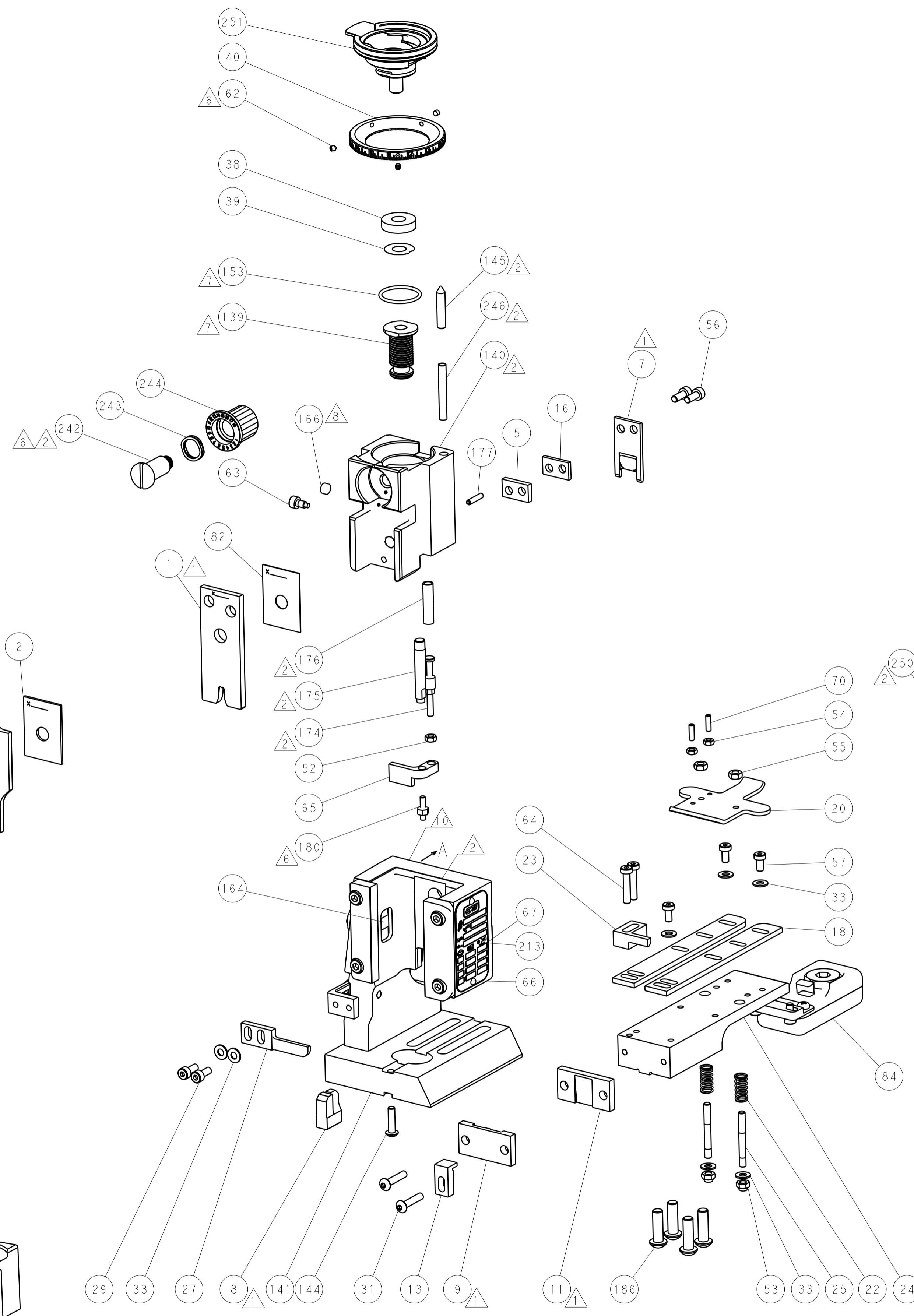
|                |  |  |            |                          |             |                         |               |  |  |
|----------------|--|--|------------|--------------------------|-------------|-------------------------|---------------|--|--|
| DIMENSIONS: mm |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |            | DRAWN: X. ZHAO 14MAR2014 |             | CHK: L. ZHANG 14MAR2014 |               | NAME: TE Connectivity Harrisburg, PA 17105-3608  |  |
|                |  | 0 PLC ±.05                             | 1 PLC ±.03 | 2 PLC ±.02               | 3 PLC ±.015 | 4 PLC ±.01              | ANGLES ±.0001 |  |  |
| MATERIAL: .    |  | FINISH: .                              |            | APVD: T. ELBIN 14MAR2014 |             | PRODUCT SPEC: .         |               | APPLICATION SPEC: .  |  |
| WEIGHT: .      |  | SCALE: 1:1                             |            | SHEET: 3 OF 4            |             | REV: B                  |               | Ocean End Feed Applicator<br>SIZE: A1 CASE CODE: 00779 ©=2150425<br>Customer Accessible Production Drawing |  |



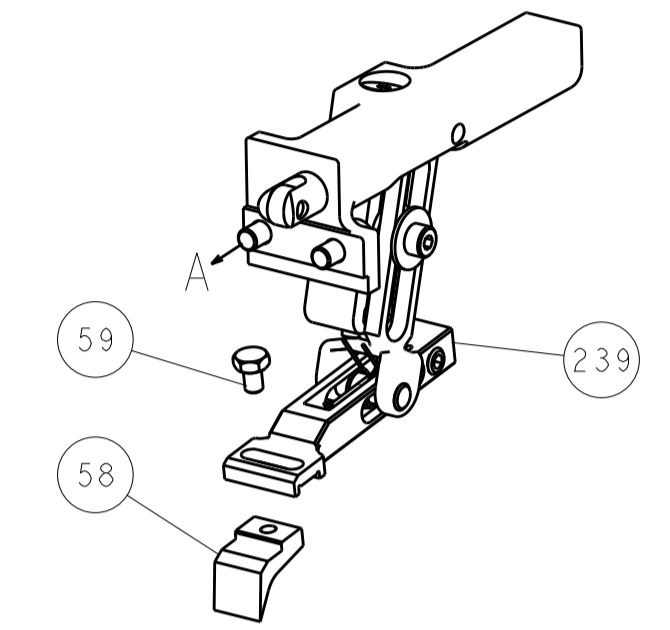
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|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    | -   | SEE SHEET 1 | -    | -   | -    |



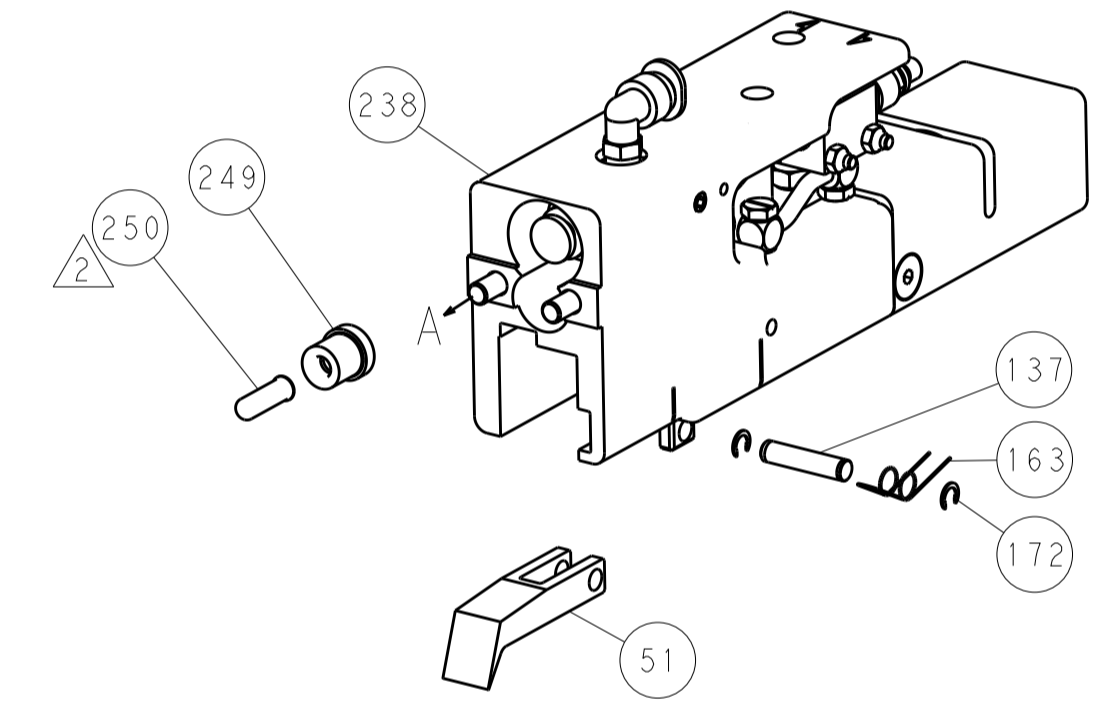
HOLDDOWN SET-UP



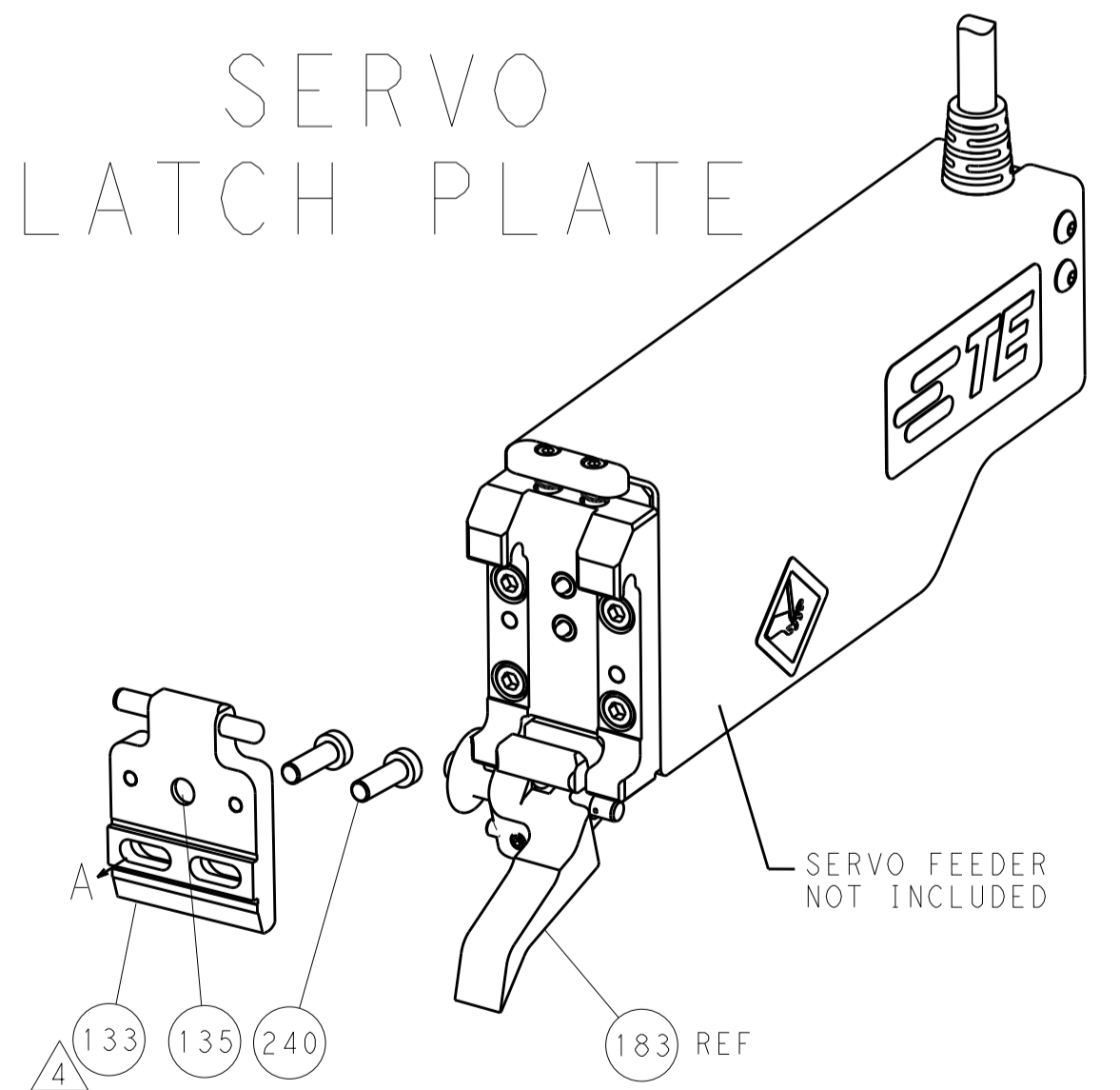
FEED TYPE  
MECHANICAL



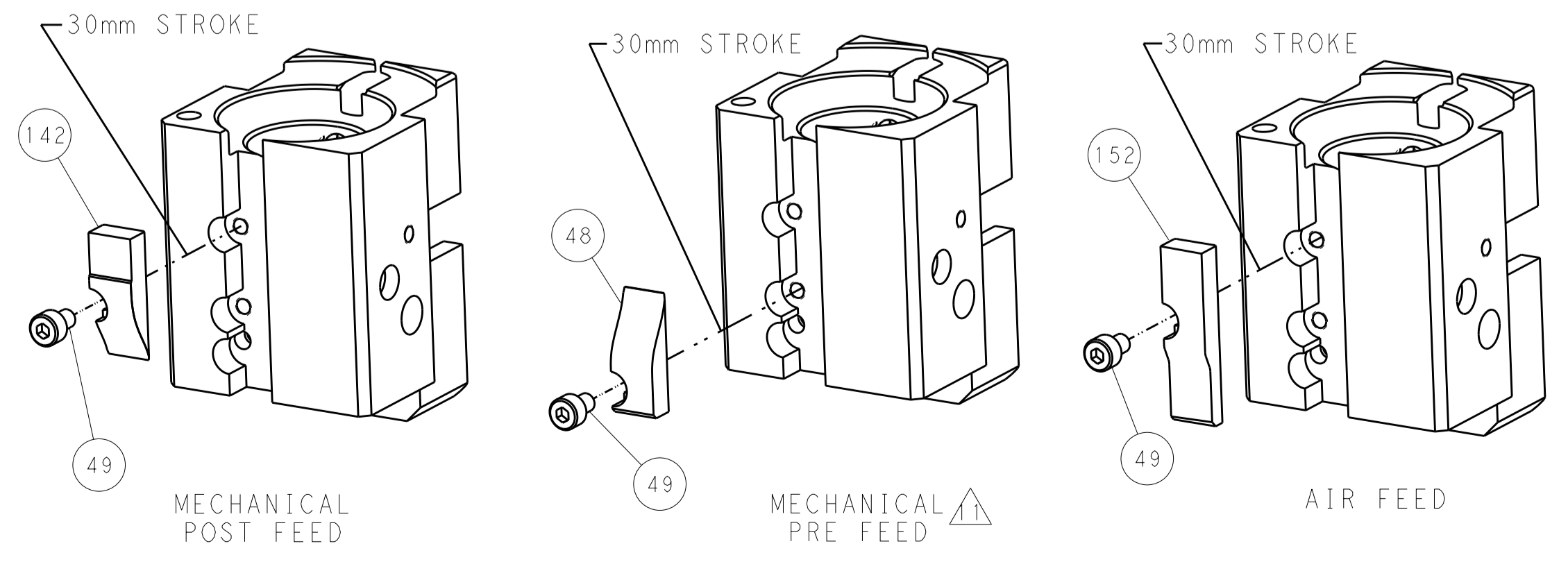
PNEUMATIC



SERVO  
LATCH PLATE



CAM POSITIONS



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

|  |            |  |              |                        |        |                         |        |                          |     |                                 |   |
|--|------------|--|--------------|------------------------|--------|-------------------------|--------|--------------------------|-----|---------------------------------|---|
| DIMENSIONS:                            |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |              | DWN: X. ZHAO 14MAR2014 |        | CHK: L. ZHANG 14MAR2014 |        | APVD: T. ELBIN 14MAR2014 |     | NAME: Ocean End Feed Applicator |   |
| mm                                     | 0 PLC ±0.5 | 1 PLC ±0.13                            | 3 PLC ±0.013 | 4 PLC ±0.001           | ANGLES | FINISH                  | WEIGHT | SCALE                    | 1:1 | SHEET                           | 4 |
| MATERIAL                               |            |  |              |                        |        |                         |        |                          |     |                                 |   |
| Customer Accessible Production Drawing |            |  |              |                        |        |                         |        | A11 00779 C=2150425      |     | RESTRICTED TO                   |   |