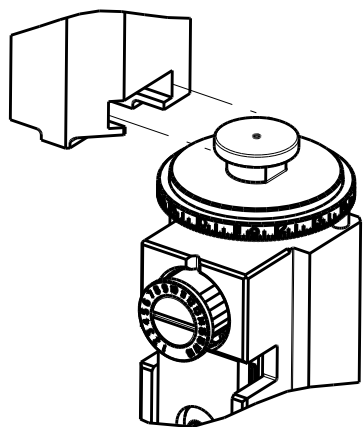


|                                                                                  |                |                          |                          |
|----------------------------------------------------------------------------------|----------------|--------------------------|--------------------------|
| 8                                                                                |                | 7                        |                          |
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| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              | PART<br>NUMBER | REVISION                 | DESCRIPTION              |
|  | 2150196-1      | D                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2150196-2      | D                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2150196-5      | D                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2150196-6      | D                        | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2150196-7      | D                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2150196-7    | B                        | CRIMP TOOLING KIT        |

|                                      |                |      |
|--------------------------------------|----------------|------|
| APPLICATOR DATA                      |                |      |
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.03 mm [.080] | F    |
| INSUL                                | 3.94 mm [.155] | OV   |
| APPLICATOR INSTRUCTIONS<br>408-10390 |                |      |

|                                                  |  |                                                           |  |
|--------------------------------------------------|--|-----------------------------------------------------------|--|
| TERMINAL DATA: TE TERMINAL                       |  | TE CRIMP SPECIFICATION                                    |  |
| TERMINAL NAME: RECEPTACLE POSITIVE 4.75 SERIES   |  |                                                           |  |
| WIRE STRIP LENGTH<br>3.50-4.50 mm [.138-.177 IN] |  | INSULATION DIAMETER RANGE<br>Ø2.30-3.60 mm [.091-.142 IN] |  |
| TERMINAL APPLICATION SPECIFICATION               |  | 114-5125                                                  |  |
| 114-5125                                         |  | -                                                         |  |
| -                                                |  | -                                                         |  |
| TERMINALS APPLIED                                |  |                                                           |  |
| TE TERMINAL                                      |  | TE TERMINAL                                               |  |
| 1742669-1                                        |  | TE TERMINAL                                               |  |
|                                                  |  | TE TERMINAL                                               |  |

|             |                            |                                |
|-------------|----------------------------|--------------------------------|
| WIRE SIZE   | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
| 1.4mm solid | 1.57+/-0.05 [.062+/-0.002] | 3.8                            |
| 16 AWG      | 1.53+/-0.05 [.060+/-0.002] | 3.6                            |
| 18 AWG      | 1.33+/-0.05 [.052+/-0.002] | 5.8                            |
| 20 AWG      | 1.22+/-0.05 [.048+/-0.002] | 6.9                            |



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: 8-2150196-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150196-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150196-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150196-6
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. 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 & 50.
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     |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO   | DESCRIPTION                     | ITEM NO |

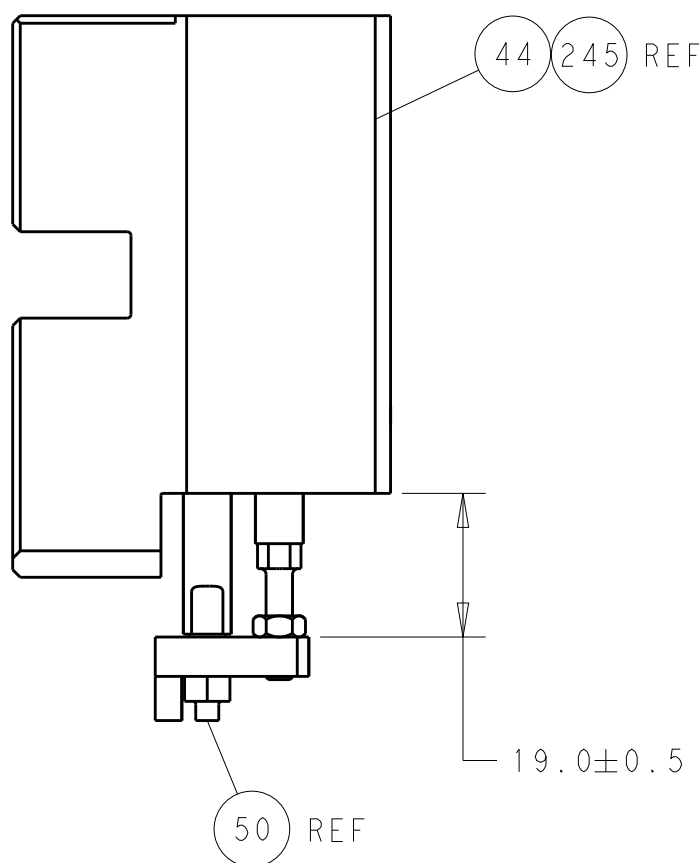
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

|                           |          |            |           |     |               |           |
|---------------------------|----------|------------|-----------|-----|---------------|-----------|
| SET UP GAUGE<br>2119599-2 | LOC<br>A | DIST<br>66 | REVISIONS |     |               |           |
|                           |          |            | P         | LTR | DESCRIPTION   | DATE      |
|                           |          |            |           | C   | ECR-14-009893 | 01JUL2014 |
|                           |          |            |           | D   | ECR-17-017022 | 20NOV2017 |
|                           |          |            |           |     |               |           |
|                           |          |            |           |     |               |           |

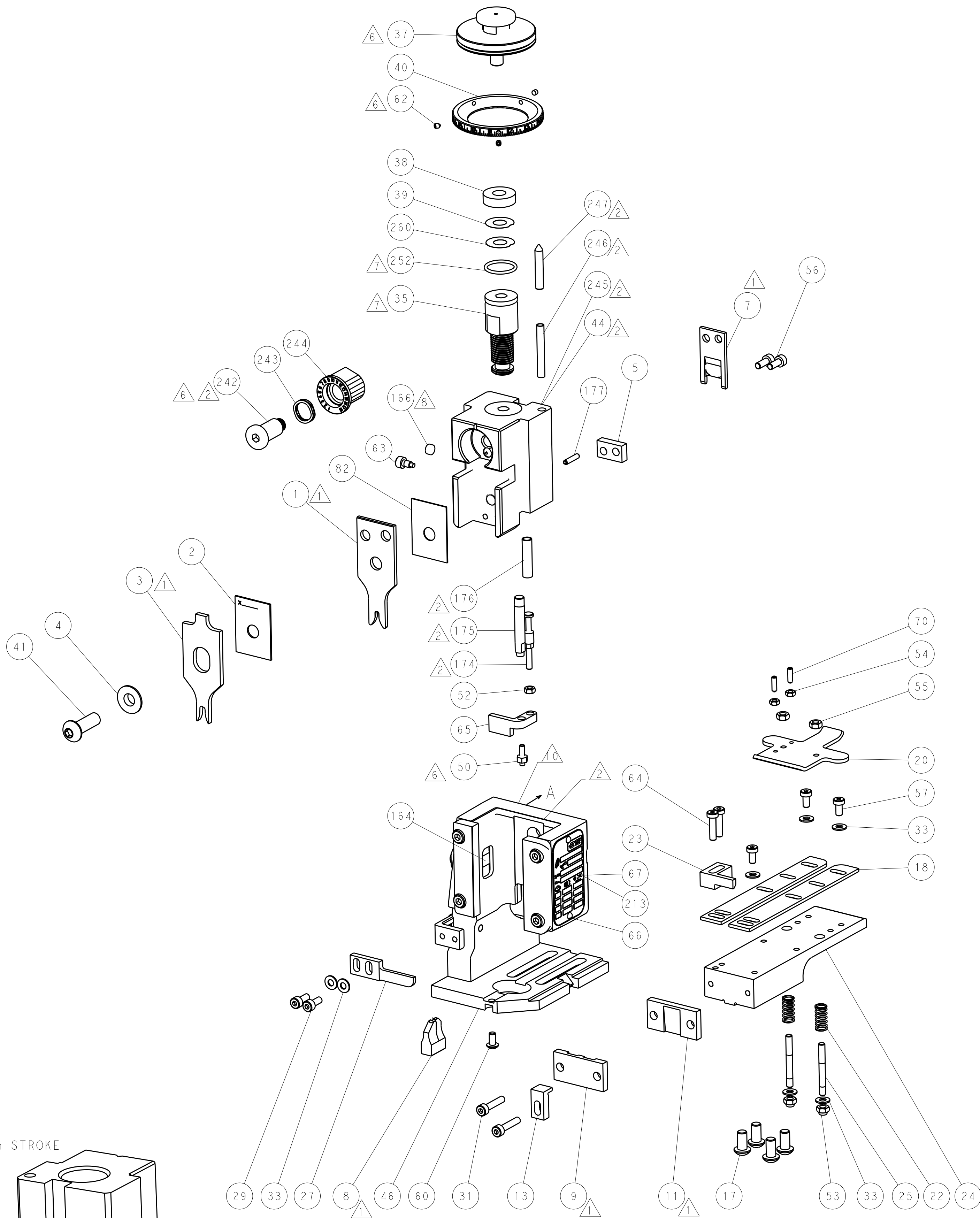
|     |     |     |     |     |     |             |                                      |         |
|-----|-----|-----|-----|-----|-----|-------------|--------------------------------------|---------|
| -   | 1   | -   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                  | 246     |
| -   | -   | 1   | -   | -   | -   | 2119759-1   | RAM, AMP STYLE, END FEED, NON-ADJUST | 245     |
| -   | 1   | 1   | 1   | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT    | 244     |
| -   | 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     |
| -   | -   | REF | REF | -   | -   | 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     |
| -   | 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     |
| -   | -   | REF | REF | -   | -   | 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 PNT, 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   | 1901681-5   | 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 PNT, 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   | 1976055-8   | 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   | 2119644-1   | 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   | 240825-2    | 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      |
| -   | 1   | 1   | 1   | 1   | 1   | 690482-6    | PLATE, FRONT SHEAR                   | 9       |
| 1   | 1   | 1   | 1   | 1   | 1   | 1-1803000-1 | ANVIL, COMBINATION, END FEED         | 8       |
| -   | 1   | 1   | 1   | 1   | 1   | 2217206-4   | BLADE, SLUG                          | 7       |
| -   | 1   | 1   | 1   | 1   | 1   | 3-240641-5  | SPACER                               | 5       |
| -   | 1   | 1   | 1   | 1   | 1   | 238009-1    | BLOCK, FL CRIMPER SPACER             | 4       |
| 1   | 1   | 1   | 1   | 1   | 1   | 1-2119785-6 | CRIMPER, INSULATION OVERLAP PREMIUM  | 3       |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-8    | SPACER, CRIMPER                      | 2       |
| 1   | 1   | 1   | 1   | 1   | 1   | 2-1633738-2 | CRIMPER, WIRE                        | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                          | ITEM NO |

|                                                                                                                                                                                |  |                         |           |                                              |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------|-----------|----------------------------------------------|--|
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| DIMENSIONS:<br>mm                                                                                                                                                              |  | CHK<br>S. XI            | 07MAR2012 | NAME<br>Ocean End Feed<br>Applicator         |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±                                                                      |  | APVD<br>J. CRUZ         | 07MAR2012 | PRODUCT SPEC                                 |  |
| MATERIAL<br>-                                                                                                                                                                  |  | APPLICATION SPEC        |           | SIZE<br>A1                                   |  |
| FINISH<br>-                                                                                                                                                                    |  | WEIGHT<br>-             |           | CASE CODE<br>00779                           |  |
| Customer Accessible Production Drawing                                                                                                                                         |  | DRAWING NO<br>C=2150196 |           | RESTRICTED TO<br>-                           |  |
| SCALE<br>1:1                                                                                                                                                                   |  | SHEET<br>1              |           | REV<br>D                                     |  |

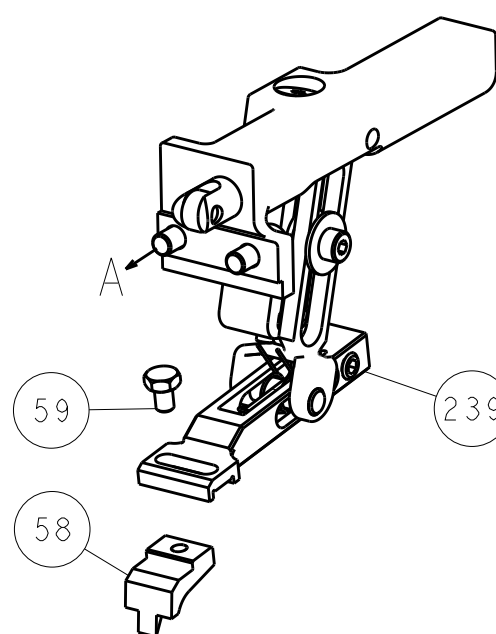
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|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    |     | SEE SHEET 1 | -    | -   | -    |
|     |    |      |     |             |      |     |      |
|     |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



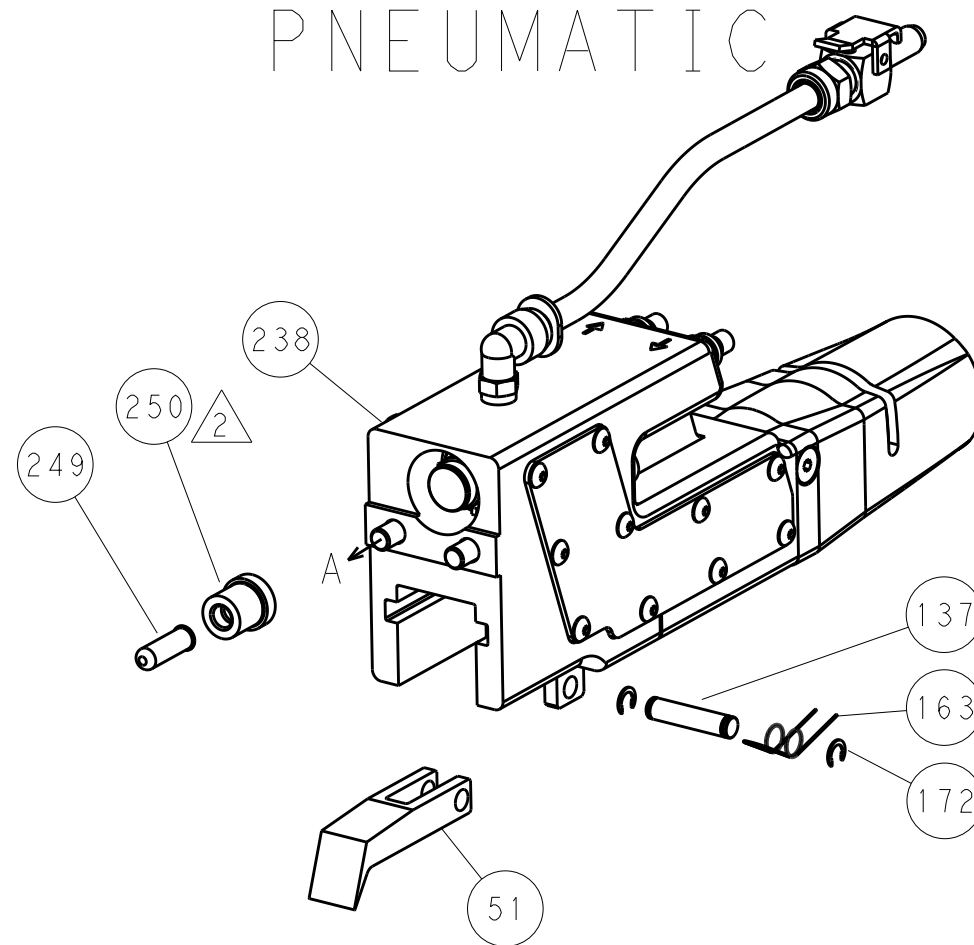
HOLDDOWN SET-UP



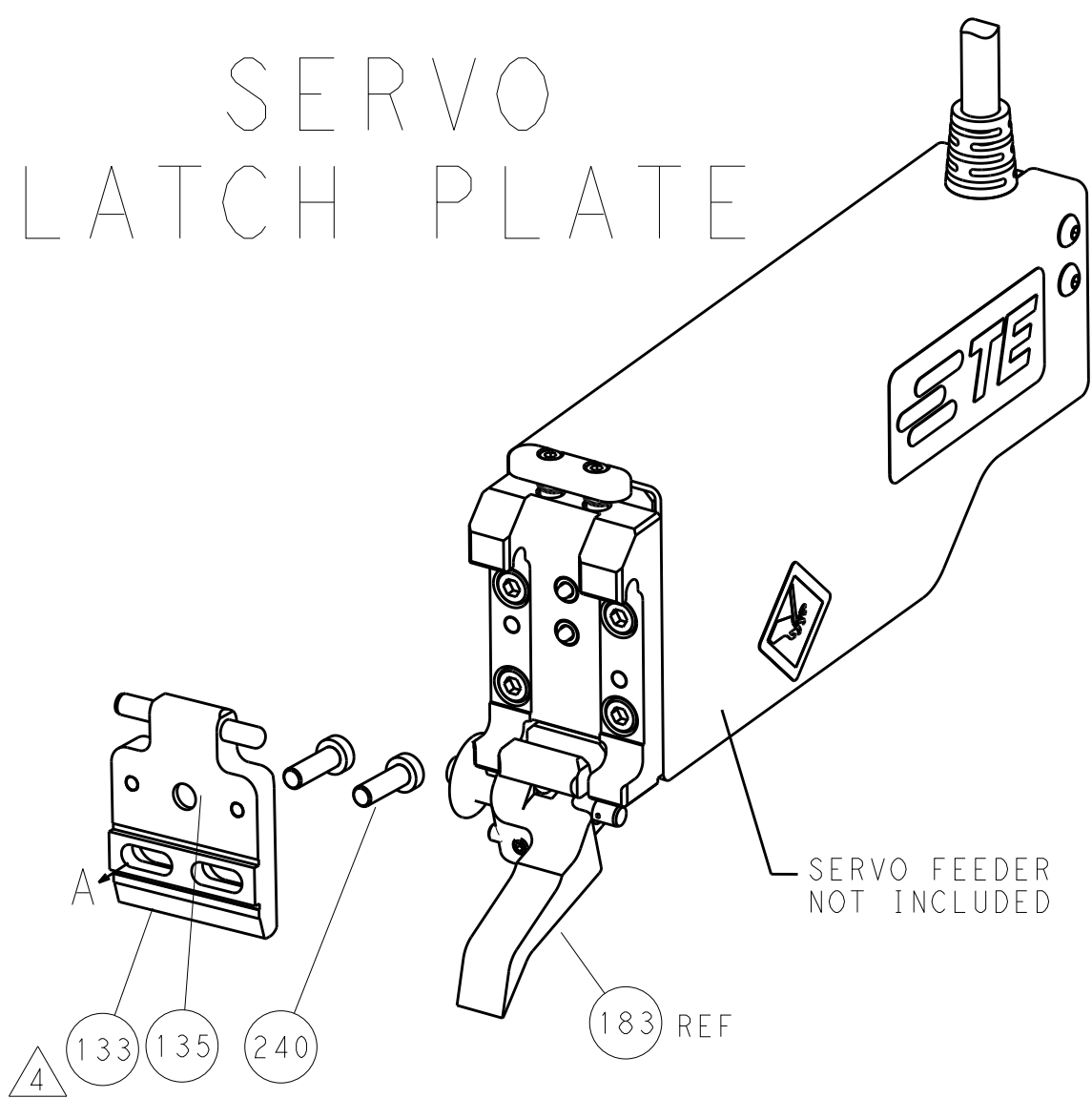
FEED TYPE  
MECHANICAL



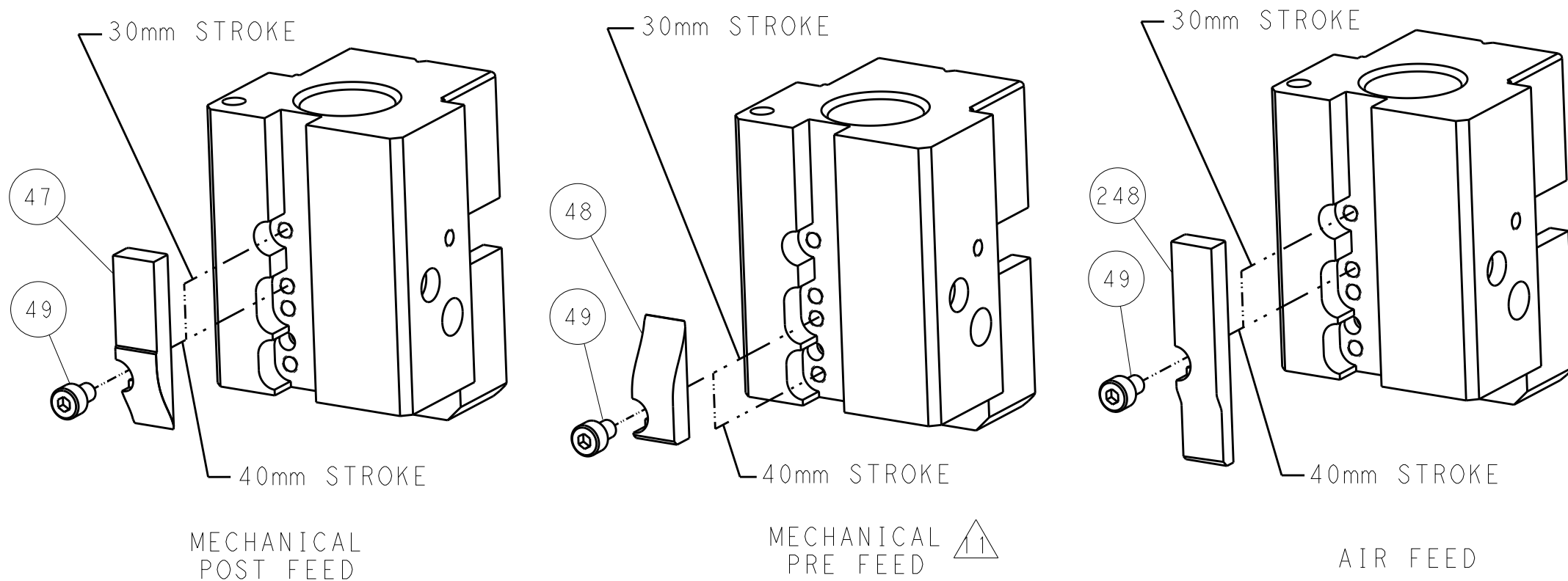
PNEUMATIC



SERVO  
LATCH PLATE

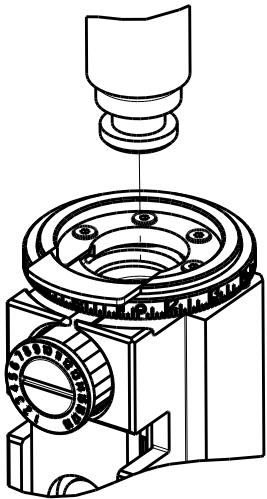


CAM POSITIONS



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

|                                                                                                                                                                                  |  |  |  |                                        |  |                                              |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|----------------------------------------|--|----------------------------------------------|--|
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| CHK<br>S. XI<br>07MAR2012                                                                                                                                                        |  |  |  | NAME                                   |  | Ocean End Feed<br>Applicator                 |  |
| APVD<br>J. CRUZ<br>07MAR2012                                                                                                                                                     |  |  |  | PRODUCT SPEC                           |  | SIZE                                         |  |
|                                                                                                                                                                                  |  |  |  | APPLICATION SPEC                       |  | CAGE CODE                                    |  |
|                                                                                                                                                                                  |  |  |  | WEIGHT                                 |  | DRAWING NO                                   |  |
|                                                                                                                                                                                  |  |  |  | MATERIAL                               |  | 00779                                        |  |
|                                                                                                                                                                                  |  |  |  | FINISH                                 |  | C=2150196                                    |  |
|                                                                                                                                                                                  |  |  |  | Customer Accessible Production Drawing |  | SCALE                                        |  |
|                                                                                                                                                                                  |  |  |  |                                        |  | 1:1                                          |  |
|                                                                                                                                                                                  |  |  |  |                                        |  | SHEET 2 OF 4                                 |  |
|                                                                                                                                                                                  |  |  |  |                                        |  | REV D                                        |  |

|                                                                                  |                |                                                                                   |                          |
|----------------------------------------------------------------------------------|----------------|-----------------------------------------------------------------------------------|--------------------------|
| 8                                                                                |                | 7                                                                                 |                          |
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| PACIFIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                               | PART<br>NUMBER | REVISION                                                                          | DESCRIPTION              |
|  | 2-2150196-1    | D                                                                                 | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2-2150196-2    | D                                                                                 | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2-2150196-5    | D                                                                                 | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2-2150196-7    | D                                                                                 | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2150196-7    | B                                                                                 | CRIMP TOOLING KIT        |
|                                                                                  |                |                                                                                   |                          |
| APPLICATOR DATA                                                                  |                |                                                                                   |                          |
| CRIMP                                                                            | SIZE           | TYPE                                                                              |                          |
| WIRE                                                                             | 2.03 mm [.080] | F                                                                                 |                          |
| INSUL                                                                            | 3.94 mm [.155] | OV                                                                                |                          |
| APPLICATOR INSTRUCTIONS<br>408-10390                                             |                |  |                          |

|                                                |                |
|------------------------------------------------|----------------|
| APPLICATOR DATA                                |                |
| CRIMP                                          | SIZE           |
| WIRE                                           | 2.03 mm [.080] |
| INSUL                                          | 3.94 mm [.155] |
| APPLICATOR INSTRUCTIONS<br>408-10390           |                |
| TERMINAL DATA: TE TERMINAL                     |                |
| TERMINAL NAME: RECEPTACLE POSITIVE 4.75 SERIES |                |
| WIRE STRIP LENGTH                              |                |
| 3.50-4.50 mm [.138-.177 IN]                    |                |
| INSULATION DIAMETER RANGE                      |                |
| Ø2.30-3.60 mm [.091-.142 IN]                   |                |
| TERMINAL APPLICATION SPECIFICATION             |                |
| TERMINALS APPLIED                              |                |
| TE TERMINAL                                    |                |
| 1742669-1                                      |                |

|              |                            |                                   |
|--------------|----------------------------|-----------------------------------|
| WIRE<br>SIZE | CRIMP HEIGHT<br>mm [INCH]  | CRIMP HEIGHT<br>REFERENCE SETTING |
| 1.4mm solid  | 1.57+/-0.05 [.062+/- .002] | 3.8                               |
| 16 AWG       | 1.53+/-0.05 [.060+/- .002] | 3.6                               |
| 18 AWG       | 1.33+/-0.05 [.052+/- .002] | 5.8                               |
| 20 AWG       | 1.22+/-0.05 [.048+/- .002] | 6.9                               |

- 
-  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: 8-2150196-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150196-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150196-5

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 50 & 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

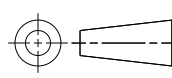
\*WARNING  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|                 |         |   |   |   |             |                                     |         |
|-----------------|---------|---|---|---|-------------|-------------------------------------|---------|
| -               | 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     |
| -77-27-25-22-21 | PART NO |   |   |   | DESCRIPTION |                                     | ITEM NO |

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

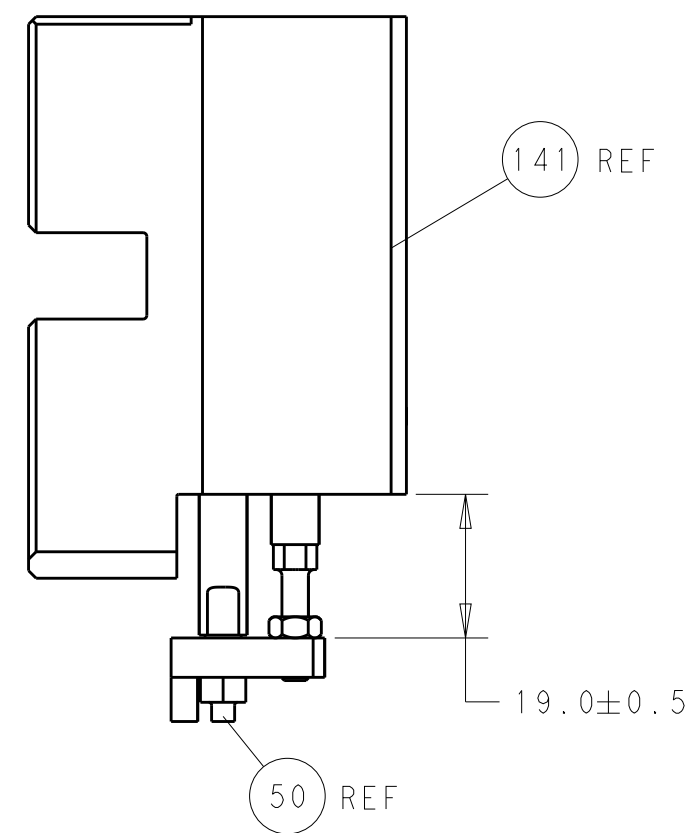
|                           |          |            |           |     |             |      |     |
|---------------------------|----------|------------|-----------|-----|-------------|------|-----|
| SET UP GAUGE<br>2119599-2 | LOC<br>A | DIST<br>66 | REVISIONS |     |             |      |     |
|                           |          |            | P         | LTR | DESCRIPTION | DATE | DWN |
|                           |          |            | -         | -   | SEE SHEET 1 | -    | -   |
|                           |          |            |           |     |             |      |     |
|                           |          |            |           |     |             |      |     |

|                 |         |     |     |     |             |                                     |         |
|-----------------|---------|-----|-----|-----|-------------|-------------------------------------|---------|
| -               | 1       | 1   | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -               | 1       | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -               | 1       | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
| -               | -       | 2   | -   | -   | 2168400-7   | SHCS, LOW HEAD, RoHS, M5 X 10       | 240     |
| -               | -       | -   | -   | 1   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239     |
| -               | -       | -   | 1   | -   | 2063440-1   | AIR FEED MODULE                     | 238     |
| -               | -       | 1   | -   | -   | 2119740-2   | TAG,IDENTIFICATION                  | 213     |
| -               | 4       | 4   | 4   | 4   | 2079383-9   | SCR, BHSC, RoHS (M6 X 20)           | 186     |
| -               | -       | REF | -   | -   | 1901697-1   | FEED FINGER ASSEMBLY,EF             | 183     |
| -               | 1       | 1   | 1   | 1   | 6-993111-6  | PIN, SLOTTED SPRING 3.0 X 14.0      | 177     |
| -               | 1       | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176     |
| -               | 1       | 1   | 1   | 1   | 1752353-2   | GUIDE PIN,HOLDDOWN                  | 175     |
| -               | 1       | 1   | 1   | 1   | 1901680-2   | GUIDE PIN,HOLDDOWN                  | 174     |
| -               | -       | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172     |
| -               | 1       | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166     |
| -               | REF     | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164     |
| -               | -       | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163     |
| -               | 1       | 1   | 1   | 1   | 8-21084-1   | O-RING, .801 ID, .070 DIA. MAT.     | 153     |
| -               | -       | -   | 1   | -   | 2119641-2   | FEED CAM, AIR FEED                  | 152     |
| -               | 1       | 1   | 1   | 1   | 2119798-2   | DETENT PIN                          | 145     |
| -               | 1       | 1   | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144     |
| -               | -       | -   | -   | 1   | 2119653-2   | FEED CAM, POST FEED                 | 142     |
| -               | 1       | 1   | 1   | 1   | 2119655-6   | APPLICATOR BASIC ASSEMBLY, EF       | 141     |
| -               | 1       | 1   | 1   | 1   | 2119651-1   | RAM, ASIAN STYLE, END FEED          | 140     |
| -               | 1       | 1   | 1   | 1   | 2119092-2   | BOLT, ADJUSTMENT                    | 139     |
| -               | -       | -   | 1   | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137     |
| -               | -       | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135     |
| -               | -       | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133     |
| -               | 1       | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82      |
| -               | 1       | 1   | 1   | 1   | 2119956-2   | DOCUMENTATION PACKAGE               | 71      |
| -               | 2       | 2   | 2   | 2   | 2-18032-2   | SCR, SET, FLT PNT, 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   | 1901681-5   | HOLDDOWN, TERMINAL                  | 65      |
| -               | 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 PNT, M3 x 4.0   | 62      |
| -               | -       | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -               | -       | -   | -   | 1   | 2063961-1   | FEED FINGER                         | 58      |
| -               | 3       | 3   | 3   | 3   | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8        | 57      |
| -               | 2       | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 56      |
| -               | 2       | 2   | 2   | 2   | 5018030-2   | NUT, HEX, REG, RoHS, M4             | 55      |
| -               | 2       | 2   | 2   | 2   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 54      |
| -               | 2       | 2   | 2   | 2   | 986965-8    | NUT, LOCK, HEX, TORQUE (M4)         | 53      |
| -               | 1       | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52      |
| -               | -       | -   | 1   | -   | 2119792-2   | PAWL, EF, AIR                       | 51      |
| -               | 1       | 1   | 1   | 1   | 1976055-8   | 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       | 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   | 2119644-1   | RAM WASHER, PRECISION               | 38      |
| -               | 7       | 7   | 7   | 7   | 1-18028-2   | WASHER, FLAT, REG M4                | 33      |
| -               | 2       | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 31      |
| -               | 2       | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 29      |
| -               | 1       | 1   | 1   | 1   | 240639-1    | STRIPPER (MACHINING)                | 27      |
| -               | 2       | 2   | 2   | 2   | 1320906-1   | STUD, THREADED                      | 25      |
| -               | 1       | 1   | 1   | 1   | 1752371-5   | PLATE, STRIP GUIDE                  | 24      |
| -               | 1       | 1   | 1   | 1   | 240825-2    | 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   | 1901259-4   | GUIDE, LOWER STRIP                  | 18      |
| -               | 1       | 1   | 1   | 1   | 1752360-1   | SPACER,HOLD-DOWN                    | 13      |
| -               | 1       | 1   | 1   | 1   | 240644-1    | PLATE, REAR SHEAR                   | 11      |
| -               | 1       | 1   | 1   | 1   | 690482-6    | PLATE, FRONT SHEAR                  | 9       |
| 1               | 1       | 1   | 1   | 1   | 1-1803000-1 | ANVIL, COMBINATION, END FEED        | 8       |
| -               | 1       | 1   | 1   | 1   | 2217206-4   | BLADE, SLUG                         | 7       |
| -               | 1       | 1   | 1   | 1   | 3-240641-5  | SPACER                              | 5       |
| -               | 1       | 1   | 1   | 1   | 238009-1    | BLOCK, FL CRIMPER SPACER            | 4       |
| 1               | 1       | 1   | 1   | 1   | 1-2119785-6 | CRIMPER, INSULATION OVERLAP PREMIUM | 3       |
| -               | 1       | 1   | 1   | 1   | 455888-8    | SPACER, CRIMPER                     | 2       |
| 1               | 1       | 1   | 1   | 1   | 2-1633738-2 | CRIMPER, WIRE                       | 1       |
| -77-27-25-22-21 | PART NO |     |     |     | DESCRIPTION |                                     | ITEM NO |

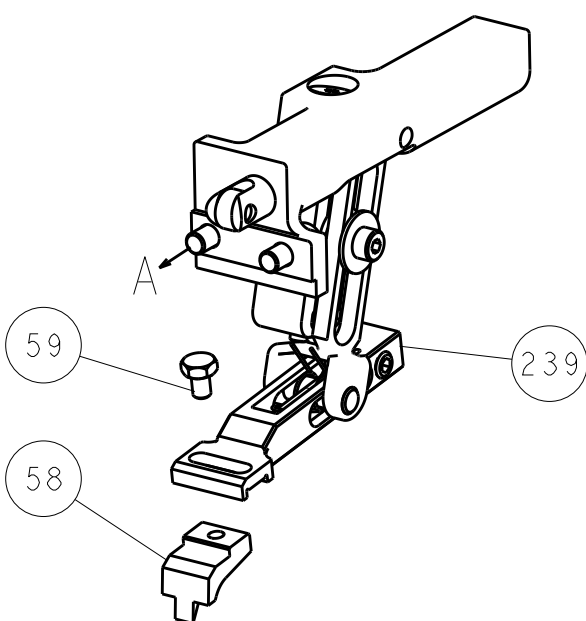
|                                                                                                                          |  |                                        |           |                                                  |  |  |  |
|--------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------|-----------|--------------------------------------------------|--|--|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE CONTACTED FOR THE LATEST EDITION. |  | DWN<br>C.CHEN                          | 07MAR2012 | STE TE Connectivity<br>Harrisburg, PA 17105-3608 |  |  |  |
| DIMENSIONS:                                                                                                              |  | CHK<br>S.XI                            | 07MAR2012 | NAME                                             |  |  |  |
| mm                                                                                                                       |  | APVD<br>J. CRUZ                        | 07MAR2012 | PRODUCT SPEC                                     |  |  |  |
|                                     |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |           | APPLICATION SPEC                                 |  |  |  |
| MATERIAL                                                                                                                 |  | FINISH                                 |           | WEIGHT                                           |  |  |  |
| -                                                                                                                        |  | -                                      |           | -                                                |  |  |  |
| Customer Accessible Production Drawing                                                                                   |  | SCALE                                  |           | SHEET 3 OF 4                                     |  |  |  |
| REV D                                                                                                                    |  | REV                                    |           | REV                                              |  |  |  |

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

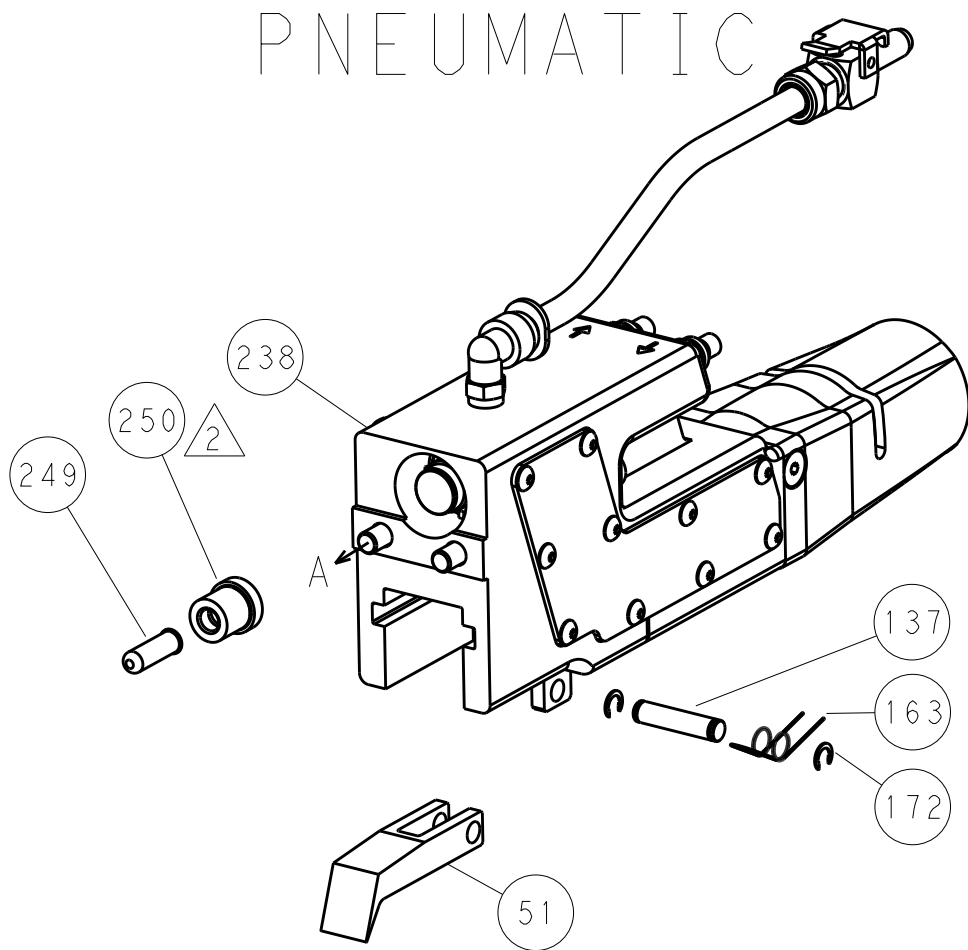
HOLDDOWN SET-UP



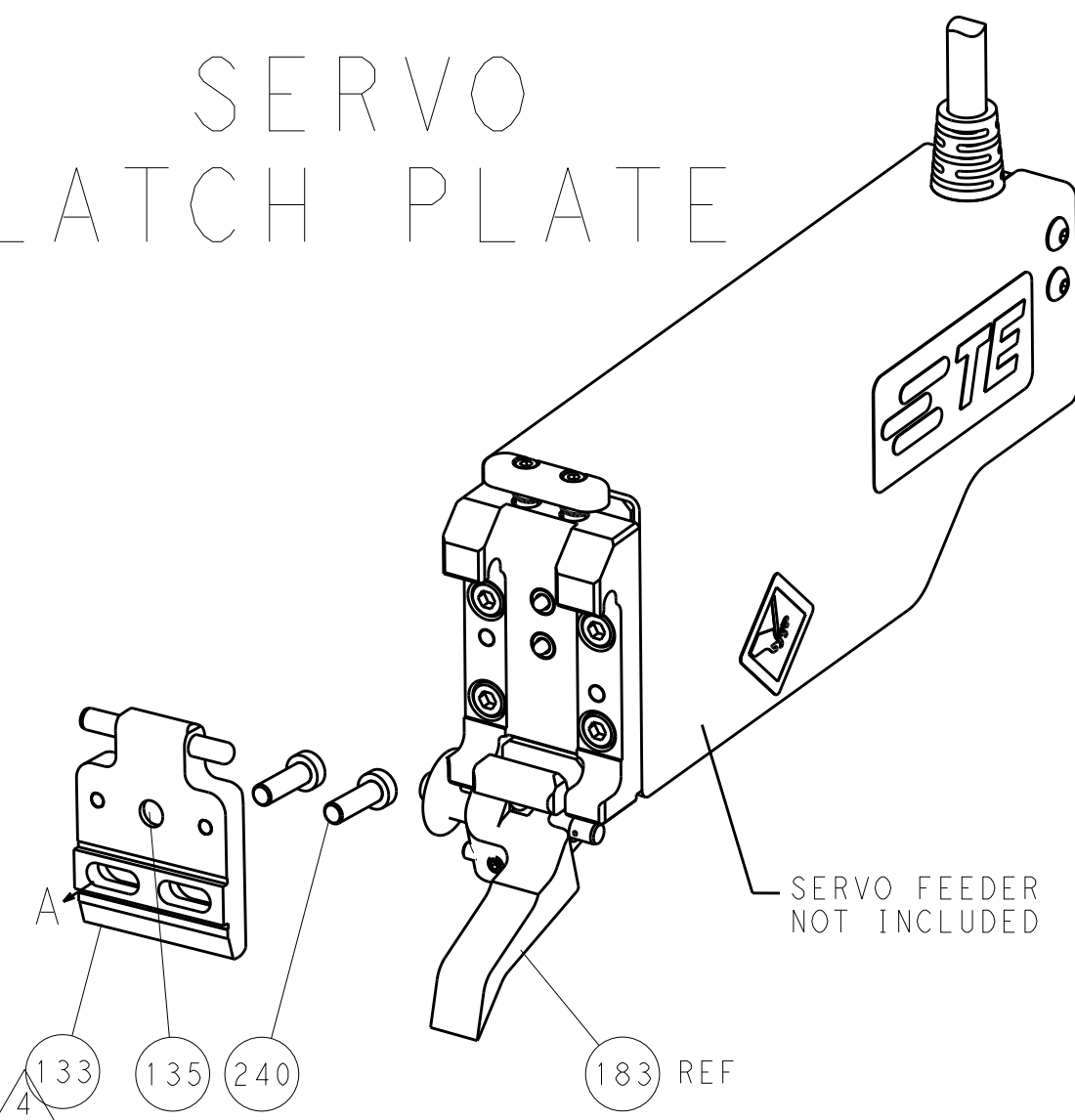
FEED TYPE  
MECHANICAL



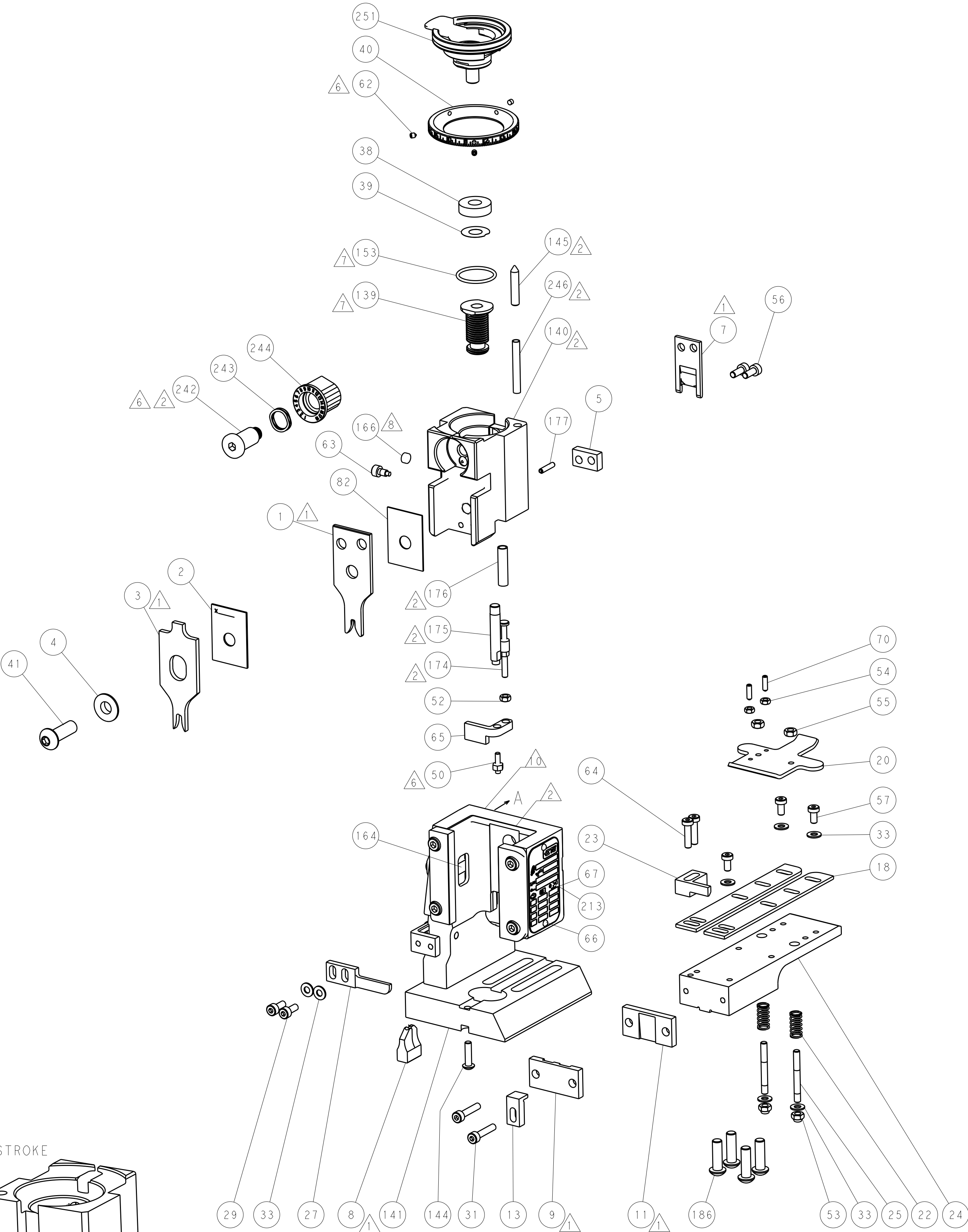
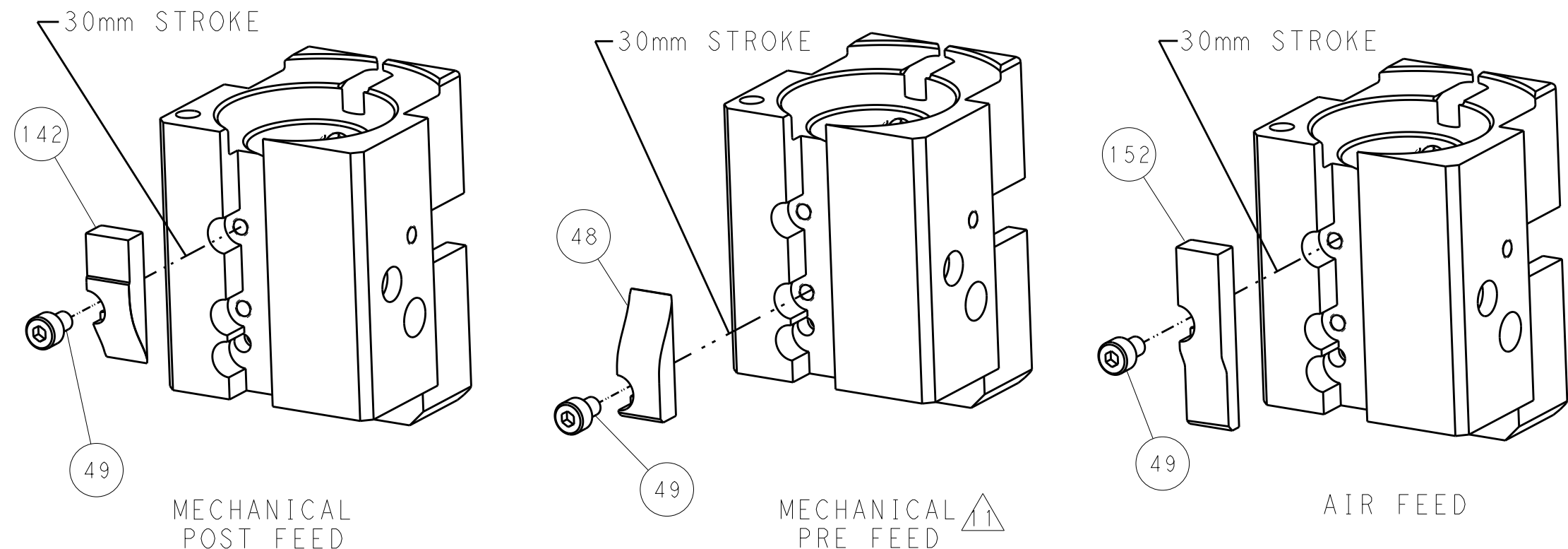
PNEUMATIC



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                                    |  | TE Connectivity           |  |
| mm          |  | 0 PLC ±                                |  | C. CHEN                                |  | Harrisburg, PA 17105-3608 |  |
|             |  | 1 PLC ±                                |  | S. XI                                  |  |                           |  |
|             |  | 2 PLC ±                                |  | I. CRUZ                                |  |                           |  |
|             |  | 3 PLC ±                                |  | 07MAR2012                              |  |                           |  |
|             |  | 4 PLC ±                                |  | PRODUCT SPEC                           |  |                           |  |
|             |  | ANGLES ±                               |  | APPLICATION SPEC                       |  |                           |  |
|             |  | FINISH                                 |  | WEIGHT                                 |  |                           |  |
|             |  |                                        |  | Customer Accessible Production Drawing |  |                           |  |
|             |  |                                        |  | SCALE                                  |  |                           |  |
|             |  |                                        |  | 1:1                                    |  |                           |  |
|             |  |                                        |  | SHEET                                  |  |                           |  |
|             |  |                                        |  | 4                                      |  |                           |  |
|             |  |                                        |  | OF                                     |  |                           |  |
|             |  |                                        |  | 4                                      |  |                           |  |
|             |  |                                        |  | REV                                    |  |                           |  |
|             |  |                                        |  | D                                      |  |                           |  |

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