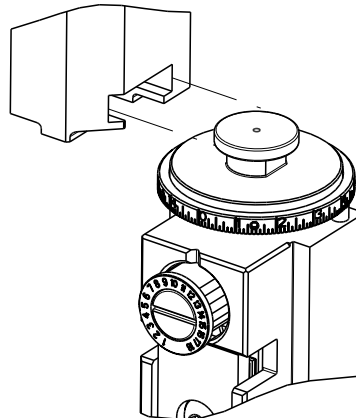


|                                                                                  |                |                          |                          |
|----------------------------------------------------------------------------------|----------------|--------------------------|--------------------------|
| 8                                                                                |                | 7                        |                          |
| THIS DRAWING IS UNPUBLISHED.                                                     |                | RELEASED FOR PUBLICATION |                          |
| 20                                                                               |                | 20                       |                          |
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| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              | PART<br>NUMBER | REVISION                 | DESCRIPTION              |
|  | 2150417-1      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2150417-2      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2150417-5      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2150417-6      | A                        | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2150417-7      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2150417-7    | A                        | CRIMP TOOLING KIT        |

| APPLICATOR DATA                      |                |                                                                                   |
|--------------------------------------|----------------|-----------------------------------------------------------------------------------|
| CRIMP                                | SIZE           | TYPE                                                                              |
| WIRE                                 | 2.29 mm [.090] | F                                                                                 |
| INSUL                                | 3.56 mm [.140] | F                                                                                 |
| APPLICATOR INSTRUCTIONS<br>408-10390 |                |  |

|                                                  |                     |                                                                                                                                                          |                     |
|--------------------------------------------------|---------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------|
| TERMINAL DATA: G & H LEAR TERMINAL               |                     | TE CRIMP SPECIFICATION                                                                                                                                   |                     |
| TERMINAL NAME: TERMINAL                          |                     |                                                                                                                                                          |                     |
| WIRE STRIP LENGTH<br>5.50-6.27 mm [.217-.247 IN] |                     |  INSULATION DIAMETER RANGE<br>$\varnothing$ 1.40-2.10 mm [.055-.083 IN] |                     |
| TERMINAL APPLICATION SPECIFICATION               | NONE                | -                                                                                                                                                        | -                   |
|                                                  | -                   | -                                                                                                                                                        | -                   |
| TERMINALS APPLIED                                |                     |                                                                                                                                                          |                     |
| TE TERMINAL                                      | G & H LEAR TERMINAL | TE TERMINAL                                                                                                                                              | G & H LEAR TERMINAL |
| 2113430-1                                        | 25815.213.011       | 2113430-4                                                                                                                                                | 25815.123.211       |
| 2113430-2                                        | 25815.213.004       | 2113430-5                                                                                                                                                | 25815.123.204       |
| 2113430-3                                        | 25815.123.213       |                                                                                                                                                          |                     |

| WIRE SIZE |  | CRIMP HEIGHT<br>mm [INCH]   |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|-----------|-------------------------------------------------------------------------------------|-----------------------------|-------------------------------------------------------------------------------------|-----------------------------------|
| 1.00mm2   |                                                                                     | 1.40+/-0.05 [1.055+/- .002] |                                                                                     | 6.3                               |
| 0.75mm2   |                                                                                     | 1.32+/-0.05 [1.052+/- .002] |                                                                                     | 7.0                               |
| 0.50mm2   |                                                                                     | 1.24+/-0.05 [1.049+/- .002] |                                                                                     | 8.0                               |



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: 8-2150417-4
  - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150417-4
  - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150417-5
  - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150417-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242.  
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8. MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
9. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
10. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
11. THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
12. WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

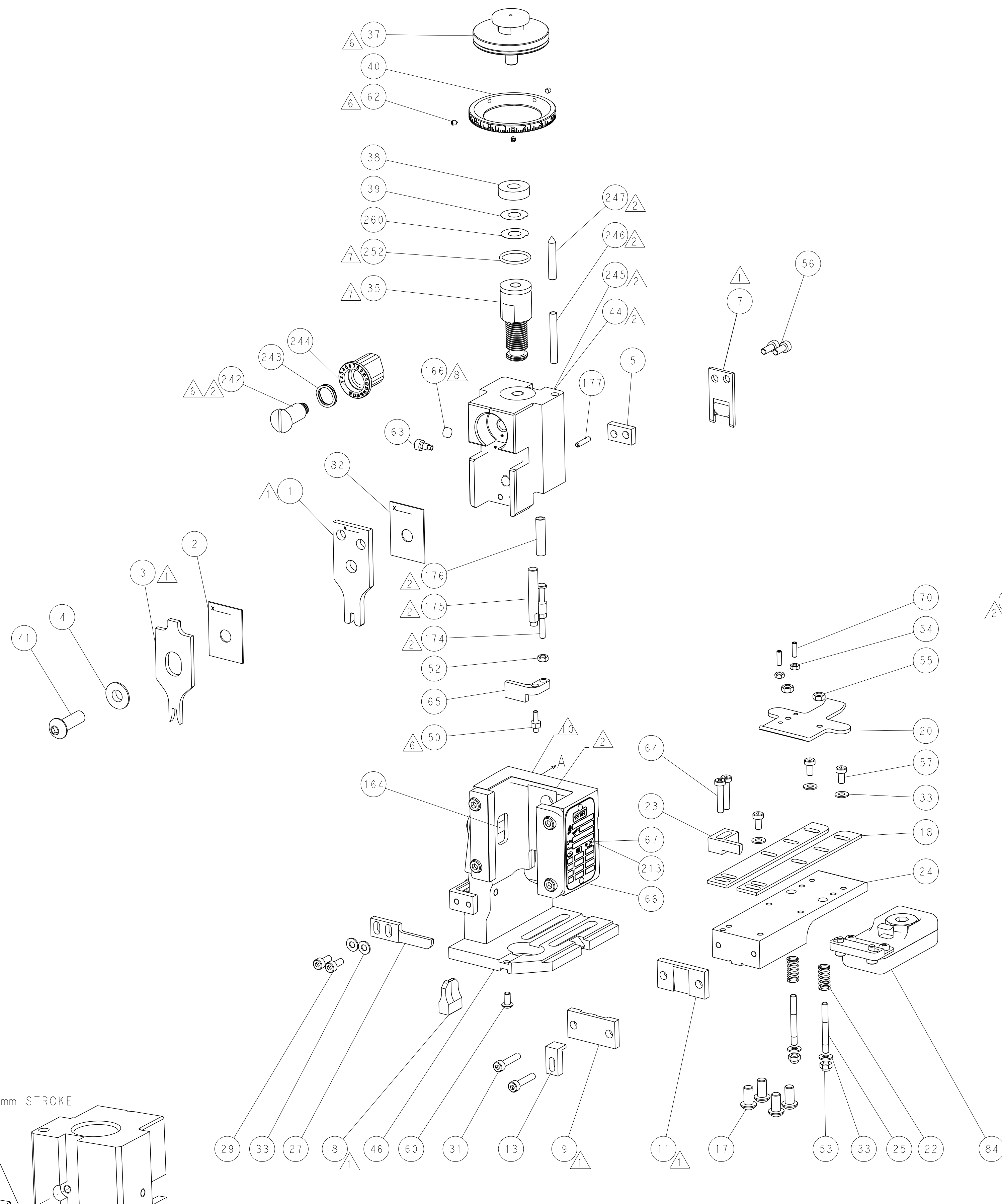
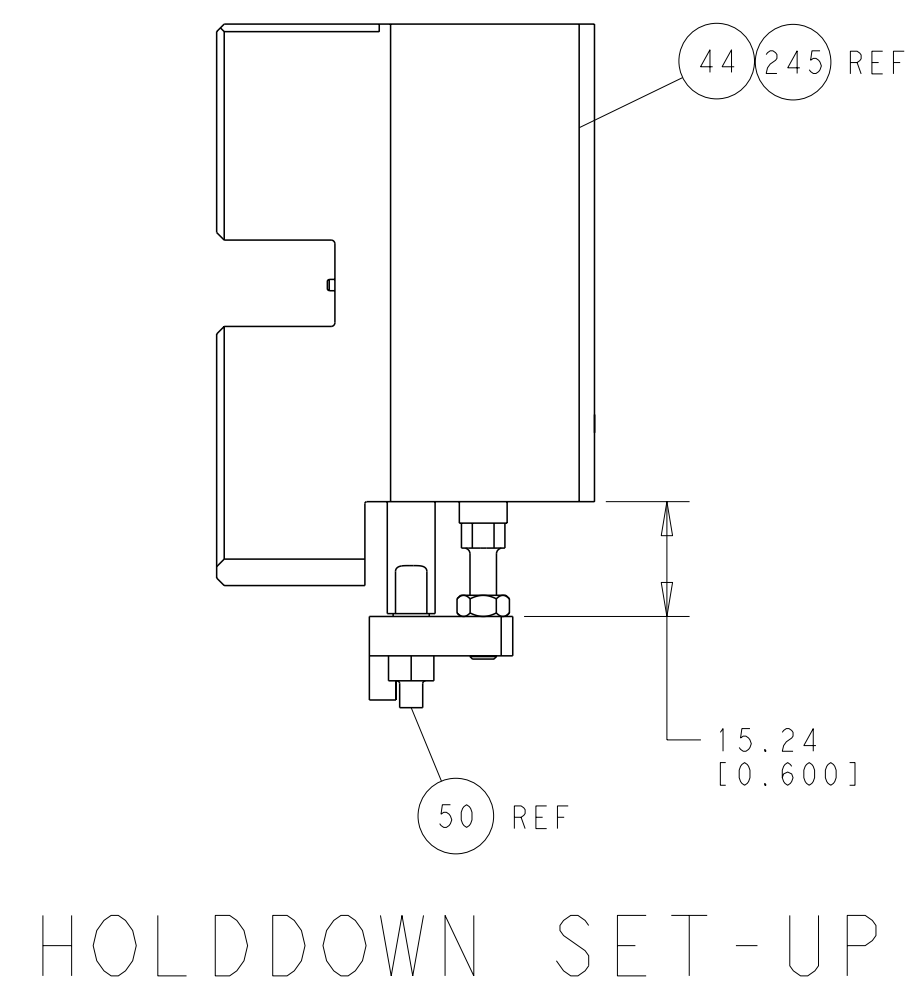
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|-----|----|----|----|----|----|-----------|--------------------------------------|---------|
| -   | -  | 1  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK                 | 260     |
| -   | 1  | -  | 1  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .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  | 2119082-9 | 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)

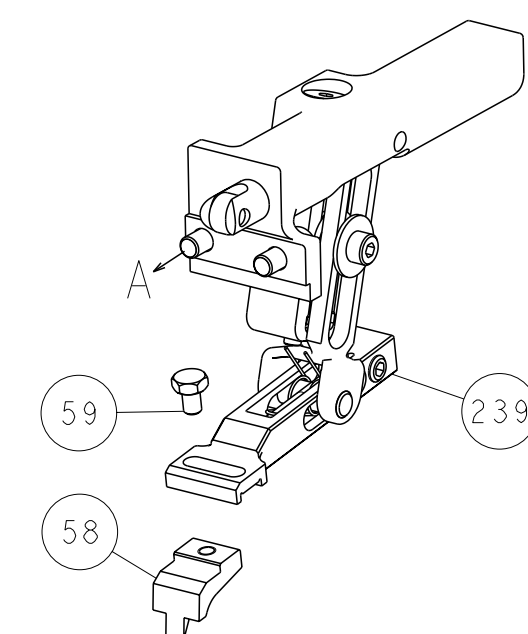
| 2            |     |     |             | 1                                   |     |             |             |     |         |
|--------------|-----|-----|-------------|-------------------------------------|-----|-------------|-------------|-----|---------|
| SET UP GAUGE |     | LOC | DIST        | REVISIONS                           |     |             |             |     |         |
| 2119599-2    |     | A   | 66          | P                                   | LTR | DESCRIPTION | DATE        | OWN | APVD    |
|              |     |     |             |                                     | A   | RELEASED    | 03MARCH2014 | KS  | GB      |
|              |     |     |             |                                     |     |             |             |     |         |
|              |     |     |             |                                     |     |             |             |     |         |
| 1            | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST |     |             |             |     | 243     |
| 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     |
| REF          | -   | -   | 1901697-1   | FEED FINGER ASSEMBLY,EF             |     |             |             |     | 183     |
| 1            | 1   | 1   | 6-9931111-6 | PIN, SLOTTED SPRING 3.0 X 14.0      |     |             |             |     | 177     |
| 1            | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 |     |             |             |     | 176     |
| 1            | 1   | 1   | 1752353-2   | GUIDE PIN,HOLDDOWN                  |     |             |             |     | 175     |
| 1            | 1   | 1   | 1901680-2   | GUIDE PIN,HOLDDOWN                  |     |             |             |     | 174     |
| -            | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT |     |             |             |     | 172     |
| 1            | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      |     |             |             |     | 166     |
| 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          | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             |     |             |             |     | 135     |
| 1            | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                |     |             |             |     | 133     |
| 1            | 1   | 1   | 2119955-2   | ASSY, LUBRICATOR, END FEED          |     |             |             |     | 84      |
| 1            | 1   | 1   | 455888-7    | SPACER, CRIMPER                     |     |             |             |     | 82      |
| 1            | 1   | 1   | 2119956-2   | DOCUMENTATION PACKAGE               |     |             |             |     | 71      |
| 2            | 2   | 2   | 2-18032-2   | SCR, SET, FLT POINT M3 X 10.0       |     |             |             |     | 70      |
| -            | 1   | 1   | 2119740-1   | TAG,IDENTIFICATION                  |     |             |             |     | 67      |
| 2            | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    |     |             |             |     | 66      |
| 1            | 1   | 1   | 1901681-1   | HOLDDOWN, TERMINAL                  |     |             |             |     | 65      |
| 2            | 2   | 2   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       |     |             |             |     | 64      |
| 1            | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            |     |             |             |     | 63      |
| 3            | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 |     |             |             |     | 62      |
| 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   | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8        |     |             |             |     | 57      |
| 2            | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      |     |             |             |     | 56      |
| 2            | 2   | 2   | 5018030-2   | NUT, HEX, REG, RoHS, M4             |     |             |             |     | 55      |
| 2            | 2   | 2   | 5018030-1   | NUT, HEX, REG, RoHS, M3             |     |             |             |     | 54      |
| 2            | 2   | 2   | 986965-8    | NUT, LOCK, HEX, TORQUE (M4)         |     |             |             |     | 53      |
| 1            | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           |     |             |             |     | 52      |
| -            | 1   | -   | 2119792-2   | PAWL, EF, AIR                       |     |             |             |     | 51      |
| 1            | 1   | 1   | 1-1976055-2 | STANDOFF, HOLD-DOWN                 |     |             |             |     | 50      |
| -            | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            |     |             |             |     | 49      |
| -            | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  |     |             |             |     | 48      |
| -            | -   | 1   | 2119653-1   | FEED CAM, POST FEED                 |     |             |             |     | 47      |
| 1            | 1   | 1   | 2119655-5   | APPLICATOR BASIC ASSEMBLY, EF       |     |             |             |     | 46      |
| 1            | 1   | 1   | 2119369-1   | RAM,AMP STYLE, END FEED             |     |             |             |     | 44      |
| 1            | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           |     |             |             |     | 41      |
| 1            | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   |     |             |             |     | 40      |
| 1            | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                |     |             |             |     | 39      |
| 1            | 1   | 1   | 2119644-1   | RAM WASHER, PRECISION               |     |             |             |     | 38      |
| 1            | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             |     |             |             |     | 37      |
| 1            | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    |     |             |             |     | 35      |
| 7            | 7   | 7   | 1-18028-2   | WASHER, FLAT, REG M4                |     |             |             |     | 33      |
| 2            | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      |     |             |             |     | 31      |
| 2            | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      |     |             |             |     | 29      |
| 1            | 1   | 1   | 240639-1    | STRIPPER (MACHINING)                |     |             |             |     | 27      |
| 2            | 2   | 2   | 1320906-1   | STUD, THREADED                      |     |             |             |     | 25      |
| 1            | 1   | 1   | 1752371-5   | PLATE, STRIP GUIDE                  |     |             |             |     | 24      |
| 1            | 1   | 1   | 240825-1    | PLATE, STRIP HOLD DOWN              |     |             |             |     | 23      |
| 2            | 2   | 2   | 2-22281-3   | SPRING, COMPRESSION                 |     |             |             |     | 22      |
| 1            | 1   | 1   | 1752373-4   | DRAG                                |     |             |             |     | 20      |
| 2            | 2   | 2   | 1901259-4   | GUIDE, LOWER STRIP                  |     |             |             |     | 18      |
| 4            | 4   | 4   | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12)           |     |             |             |     | 17      |
| 1            | 1   | 1   | 1752360-1   | SPACER,HOLD-DOWN                    |     |             |             |     | 13      |
| 1            | 1   | 1   | 240644-1    | PLATE, REAR SHEAR                   |     |             |             |     | 11      |
| -            | -   | -   | -           | -                                   |     |             |             |     | 10      |
| 1            | 1   | 1   | 690482-4    | PLATE, FRONT SHEAR                  |     |             |             |     | 9       |
| 1            | 1   | 1   | 4-1803001-2 | ANVIL, COMBINATION, END FEED        |     |             |             |     | 8       |
| 1            | 1   | 1   | 1-2217206-0 | BLADE, SLUG                         |     |             |             |     | 7       |
| -            | -   | -   | -           | -                                   |     |             |             |     | 6       |
| 1            | 1   | 1   | 240641-3    | SPACER                              |     |             |             |     | 5       |
| 1            | 1   | 1   | 238009-1    | BLOCK, FL CRIMPER SPACER            |     |             |             |     | 4       |
| 1            | 1   | 1   | 2-1633961-3 | CRIMPER, INSULATION F PREMIUM       |     |             |             |     | 3       |
| 1            | 1   | 1   | 455888-7    | SPACER, CRIMPER                     |     |             |             |     | 2       |
| 1            | 1   | 1   | 6-456406-2  | CRIMPER, WIRE PREMIUM               |     |             |             |     | 1       |
| -5           | -2  | -1  | PART NO     | DESCRIPTION                         |     |             |             |     | ITEM NO |

|                                                                                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                                                 |  |                                                                                                                                    |              |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--------------|
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| DIMENSIONS:<br>mm                                                                                                                                                                                                                                                                                                                                                    |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC $\pm .01$<br>1 PLC $\pm 0.5$<br>2 PLC $\pm 0.13$<br>3 PLC $\pm 0.013$<br>4 PLC $\pm 0.0001$<br>ANGLES<br>FINISH |  | NAME Ocean End Feed Applicator<br>-                                                                                                |              |
|                                                                                                                                                                                                                                                                                 |  | PRODUCT SPEC -<br>APPLICATION SPEC -                                                                                                                            |  | SIZE CAGE CODE DRAWING NO<br>A 00779 C=2150417                                                                                     |              |
| MATERIAL -                                                                                                                                                                                                                                                                                                                                                           |  | WEIGHT -                                                                                                                                                        |  | RESTRICTED TO -                                                                                                                    |              |
| Customer Accessible Production Drawing                                                                                                                                                                                                                                                                                                                               |  |                                                                                                                                                                 |  |                                                                                                                                    |              |
|                                                                                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                                                 |  | SCALE 1:1                                                                                                                          | SHEET 1 OF 4 |
|                                                                                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                                                 |  | REV A                                                                                                                              |              |

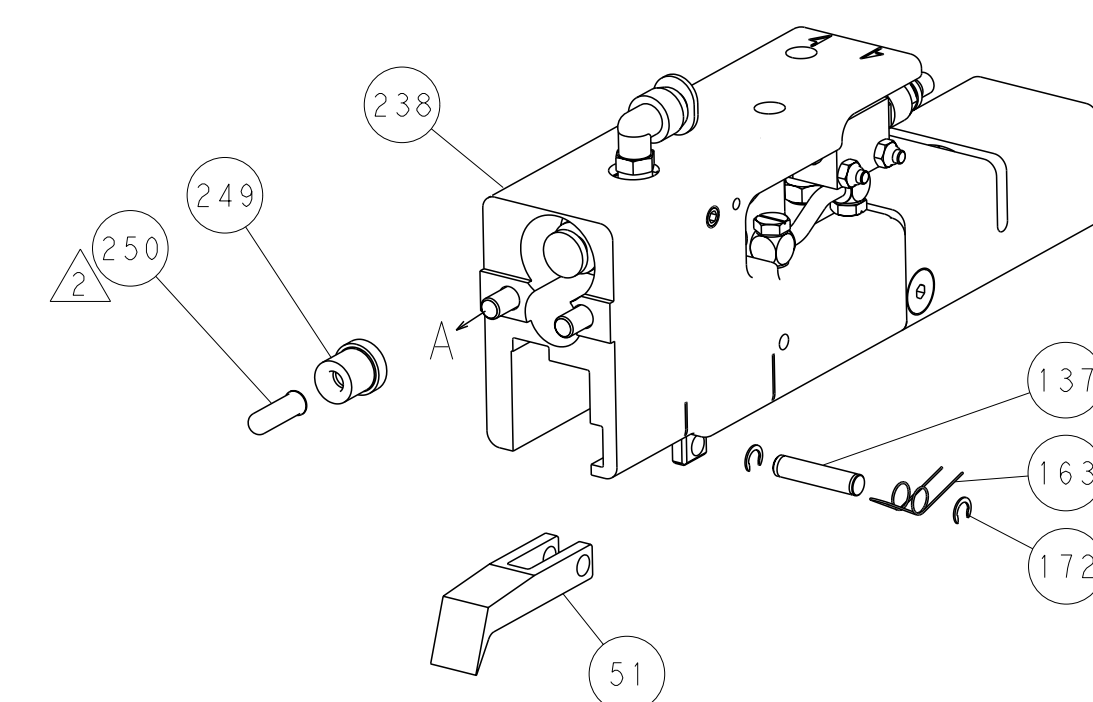
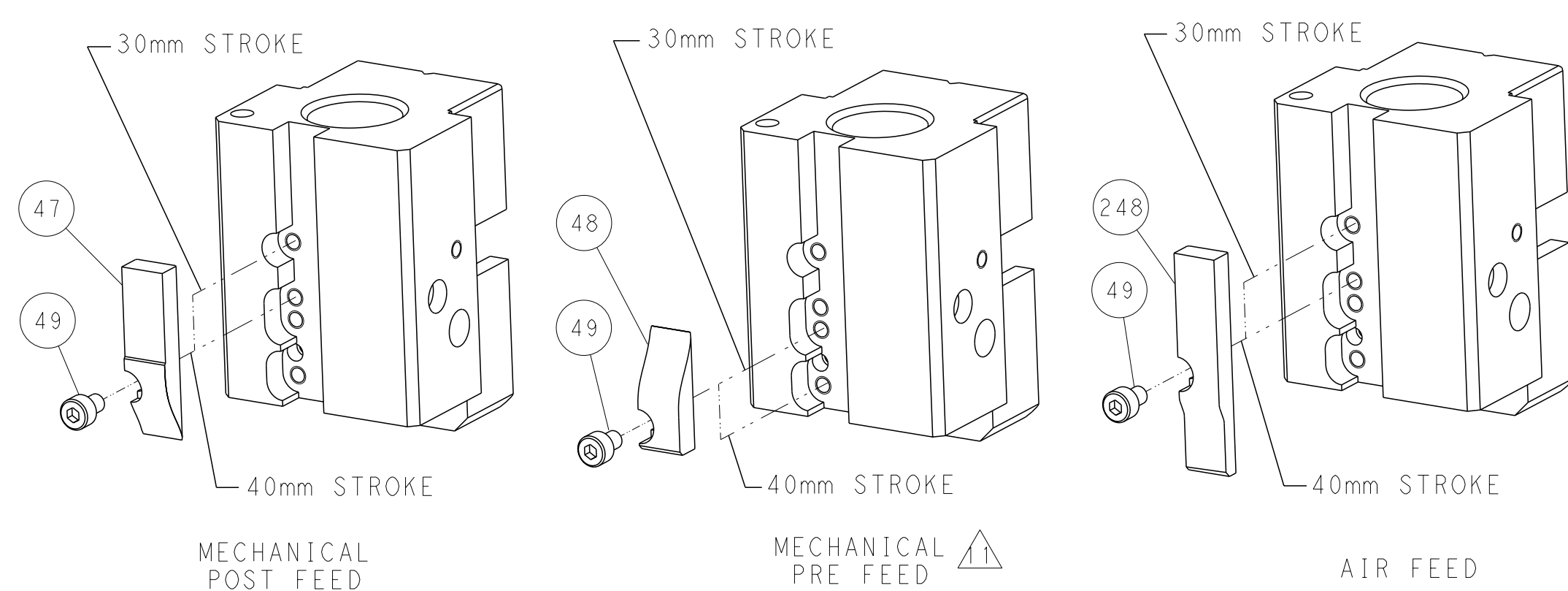
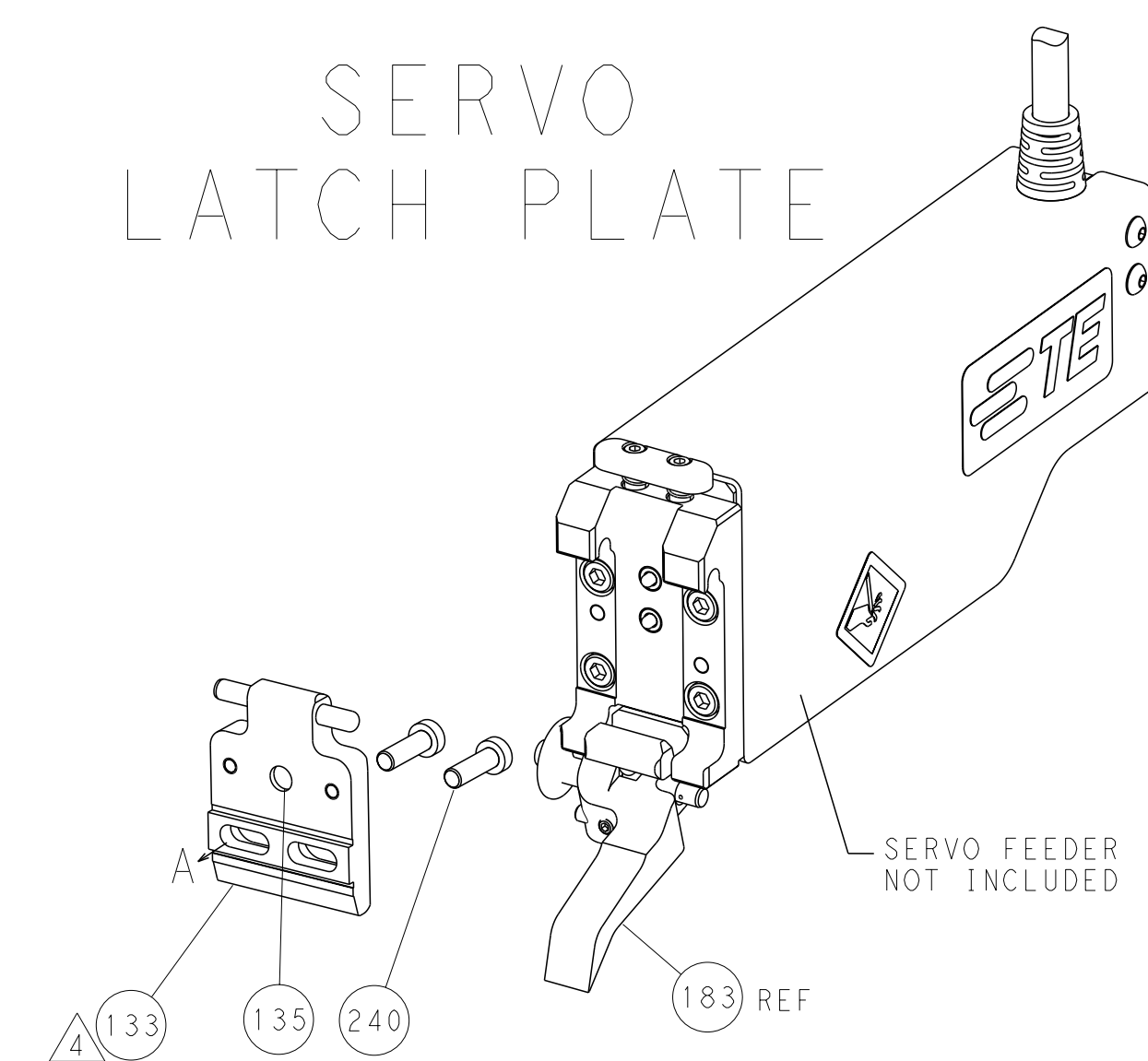




FEED TYPE  
MECHANICAL



# PNEUMATIC

SERVO  
LATCH PLATE

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

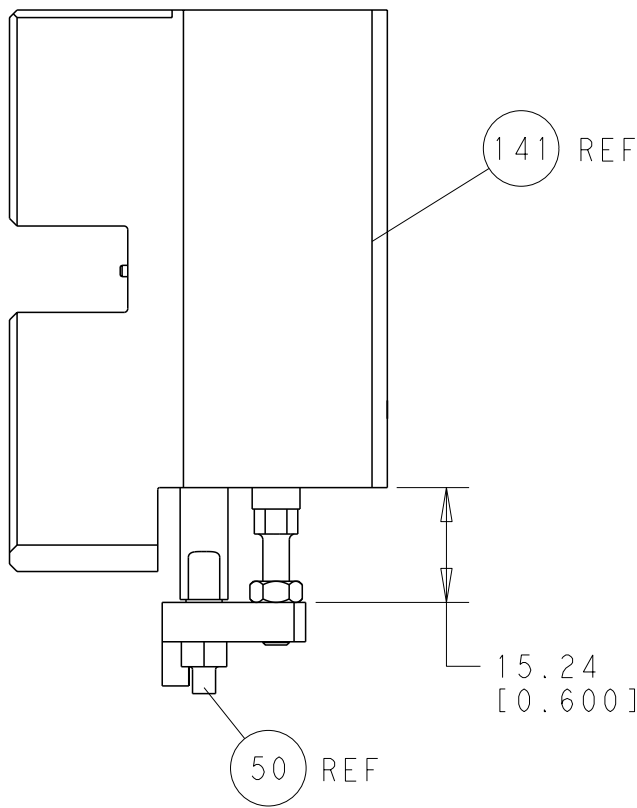
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|                                                                                                                                                                                                   |        | CHK<br><b>G. BAILEY</b><br>06FEB2014   |      |                              | Harrisburg, PA 17105-3608 |                 |               |
| DIMENSIONS:                                                                                                                                                                                       |        | APVD<br><b>T. FLRIN</b><br>06FEB2014   | NAME |                              | Ocean End Feed Applicator |                 |               |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:<br><br>mm                                                                                                                                                  |        | PRODUCT SPEC<br>-                      |      | SIZE                         |                           |                 | CAGE CODE     |
|                                                                                                                                                                                                   |        | APPLICATION SPEC<br>-                  |      | DRAWING NO                   |                           |                 | RESTRICTED TO |
| MATERIAL                                                                                                                                                                                          | FINISH | WEIGHT -                               |      | A1 00779 C=2150417           |                           |                 | -             |
|                                                                                                                                                                                                   |        | Customer Accessible Production Drawing |      | SCALE 1:1 SHEET 2 of 4 REV A |                           |                 |               |



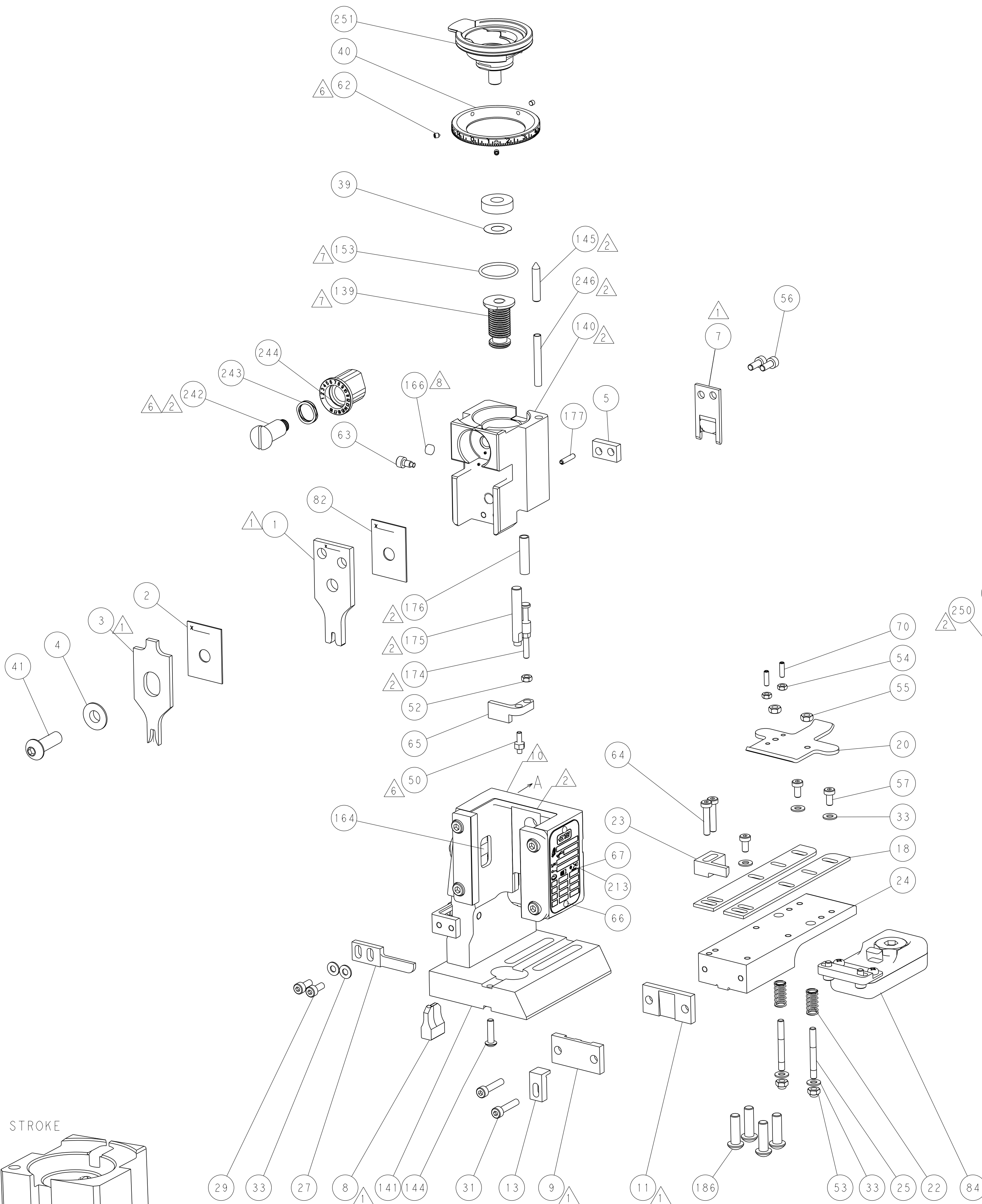




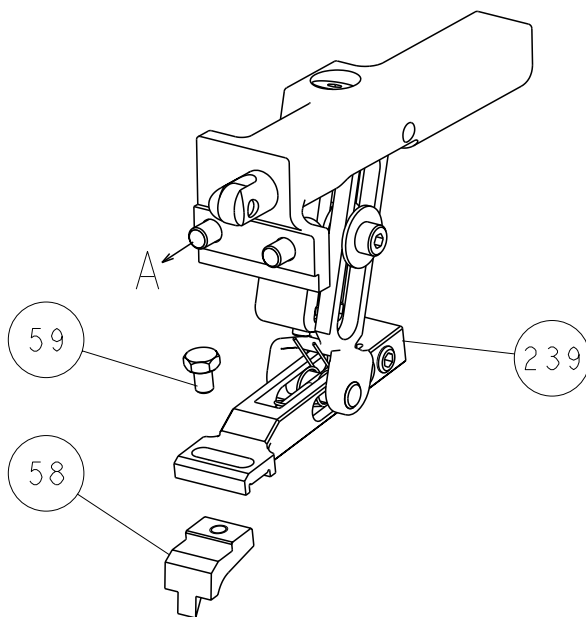
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| A   | 66 | P    | LYR | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    |     | SEE SHEET 1 | -    | -   | -    |
|     |    |      |     |             |      |     |      |
|     |    |      |     |             |      |     |      |



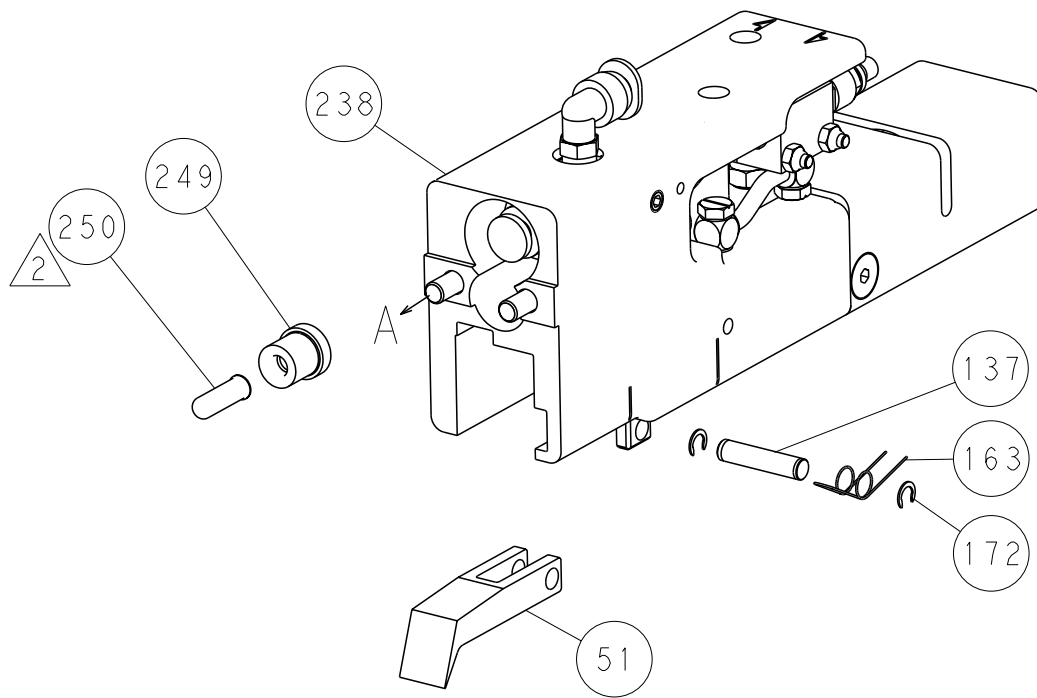
HOLDDOWN SET-UP



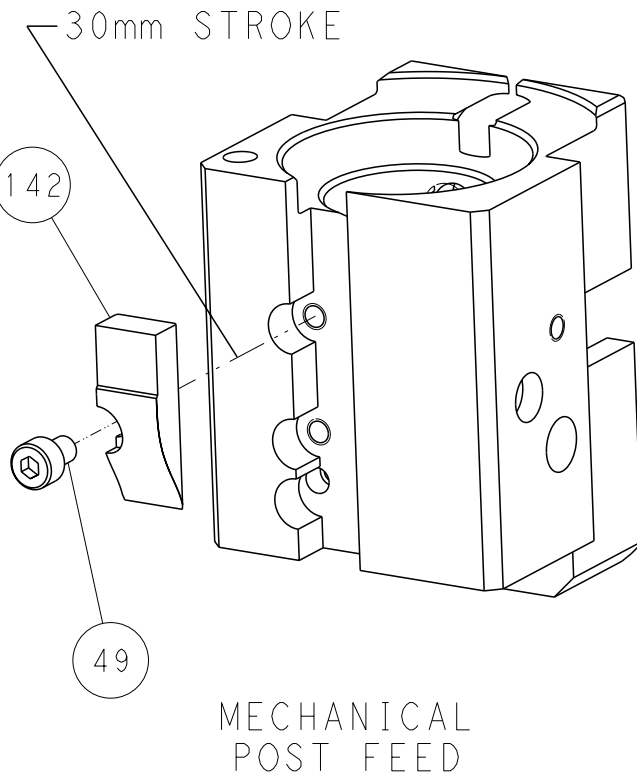
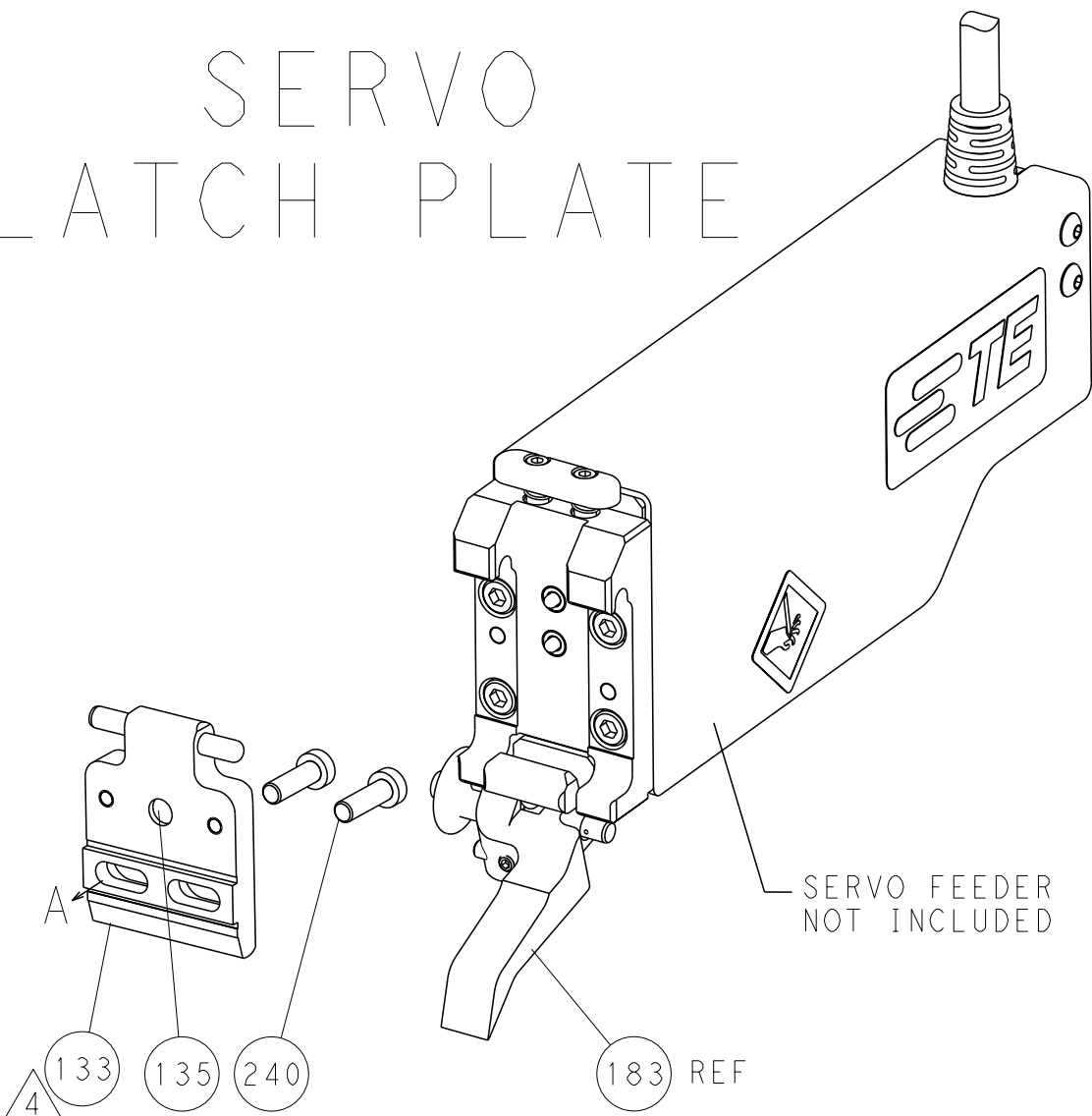
FEED TYPE  
MECHANICAL



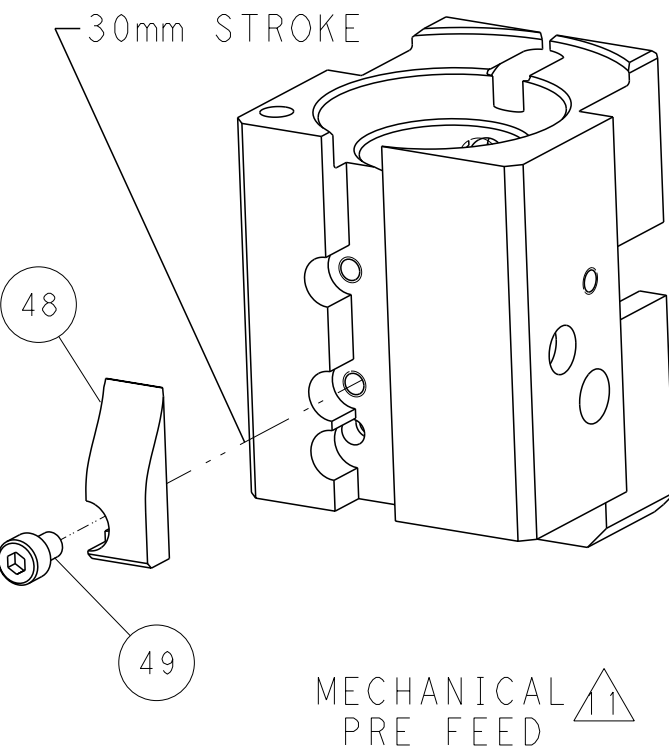
PNEUMATIC



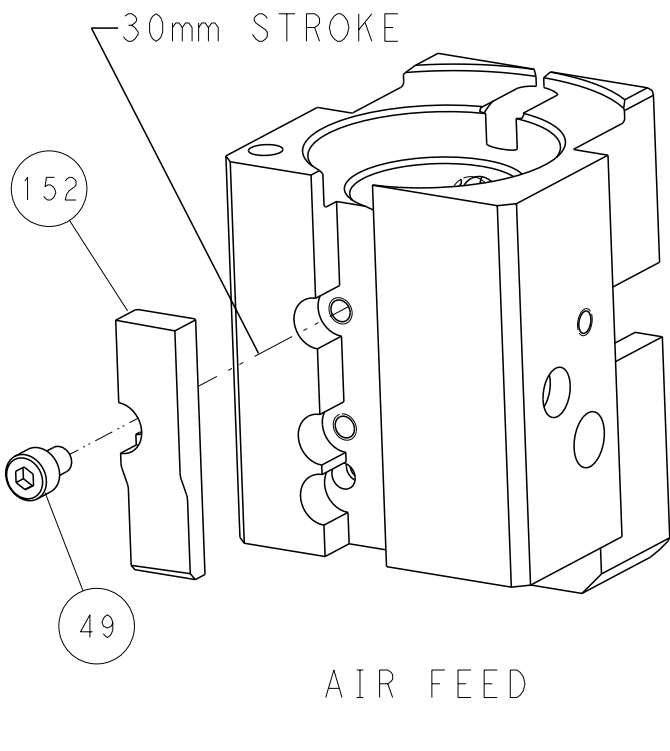
SERVO  
LATCH PLATE



MECHANICAL  
POST FEED



MECHANICAL  
PRE FEED



AIR FEED

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

|             |  |                                                                         |  |                                        |  |                                                  |  |
|-------------|--|-------------------------------------------------------------------------|--|----------------------------------------|--|--------------------------------------------------|--|
| DIMENSIONS: |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                                  |  | DWN<br>K. STAKEM<br>06FEB2014          |  | STE TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| mm          |  | 0 PLC ±.5<br>1 PLC ±0.13<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.001 |  | CHK<br>G. BAILEY<br>06FEB2014          |  | NAME<br>Ocean End Feed Applicator                |  |
| MATERIAL    |  | FINISH                                                                  |  | APVD<br>T. ELBIN<br>06FEB2014          |  | SIZE<br>A1                                       |  |
|             |  |                                                                         |  | PRODUCT SPEC                           |  | CAGE CODE<br>00779                               |  |
|             |  |                                                                         |  | APPLICATION SPEC                       |  | DRAWING NO<br>C=2150417                          |  |
|             |  |                                                                         |  | WEIGHT                                 |  | RESTRICTED TO                                    |  |
|             |  |                                                                         |  | Customer Accessible Production Drawing |  | SCALE<br>1:1                                     |  |
|             |  |                                                                         |  |                                        |  | SHEET<br>4                                       |  |
|             |  |                                                                         |  |                                        |  | OF<br>4                                          |  |
|             |  |                                                                         |  |                                        |  | REV<br>A                                         |  |

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