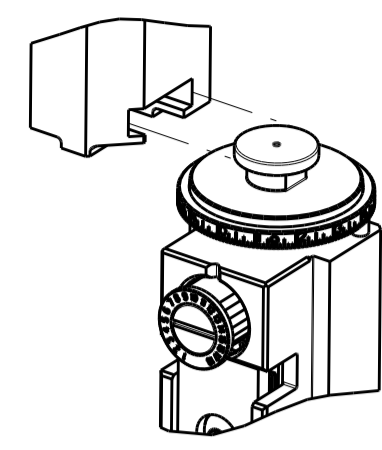


| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|-------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|------------------------|-----------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
|  | 2150837-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150837-5 | - | 2168400-7 (QUANTITY 2) | |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150837-4 | - | - | |
| | 2150837-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150837-5 | - | 2168400-7 (QUANTITY 2) | |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150837-4 | - | - | |
| | 2150837-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - | 2063440-1 |
| | 2150837-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | - |
| | | | | | - | - | - | - | - | - | - |
| | 2150837-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | | | | | - | - | - | - | - | - | - |
| 7-2150837-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------------------|------|--|
| CRIMP SIZE | TYPE | |
| WIRE 1.78 mm [.070] | F | |
| INSUL 3.56 mm [.140] | F | |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: DELPHI PACKARD TERMINALTE CRIMP SPECIFICATION | | | |
|--|------------------------------|-------------|-------------------------|
| TERMINAL NAME: 2.8 RECEPTACLE TERMINAL | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 3.33-4.09 mm [.131-.161 IN] | Ø1.50-2.40 mm [.059-.094 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | NONE | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | DELPHI PACKARD TERMINAL | TE TERMINAL | DELPHI PACKARD TERMINAL |
| 2318371-1 | 33501244 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|-------------------------------|--------------------------------|
| 1.00mm2 | 1.26 +/- 0.05 [.050 +/- .002] | 6.7 |
| 18 AWG | 1.19 +/- 0.05 [.047 +/- .002] | 7.9 |
| 0.75mm2 | 1.12 +/- 0.05 [.044 +/- .002] | 8.7 |
| 20 AWG OR 0.50mm2 | 1.08 +/- 0.05 [.043 +/- .002] | 9.0 |
| 22 AWG OR 0.30mm2 | 0.98 +/- 0.05 [.039 +/- .002] | 10.0 |

- RECOMMENDED SPARE PARTS**
- 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: 8-2150837-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150837-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150837-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150837-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 180.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 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.
- 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
- TERMINAL LUBRICANT IS RECOMMENDED.

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

| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |
|-----|----|----|----|----|----|-----------|--------------------------------------|---------|
| - | - | 1 | - | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 |
| - | 1 | - | 1 | 1 | 1 | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252 |
| - | - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | 1 | - | 1803259-1 | BUSHING, FLANGED | 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 |

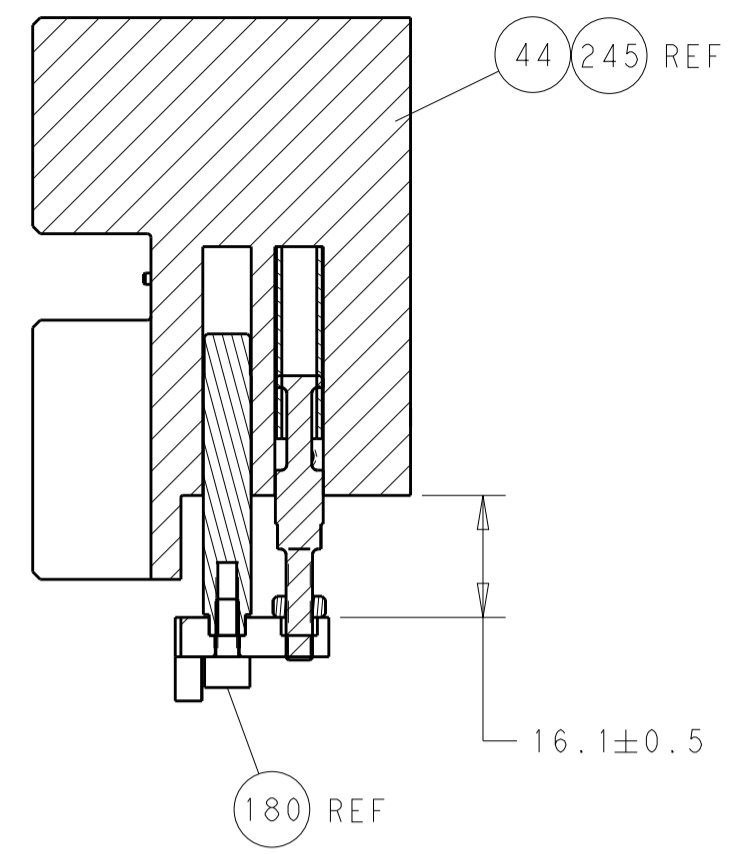
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS | | | | | |
|--------------|-----|------|-----------|-----|-------------|-----------|-----|------|
| 2119599-2 | A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | A | | | | RELEASED | 21SEP2017 | MZ | CT |

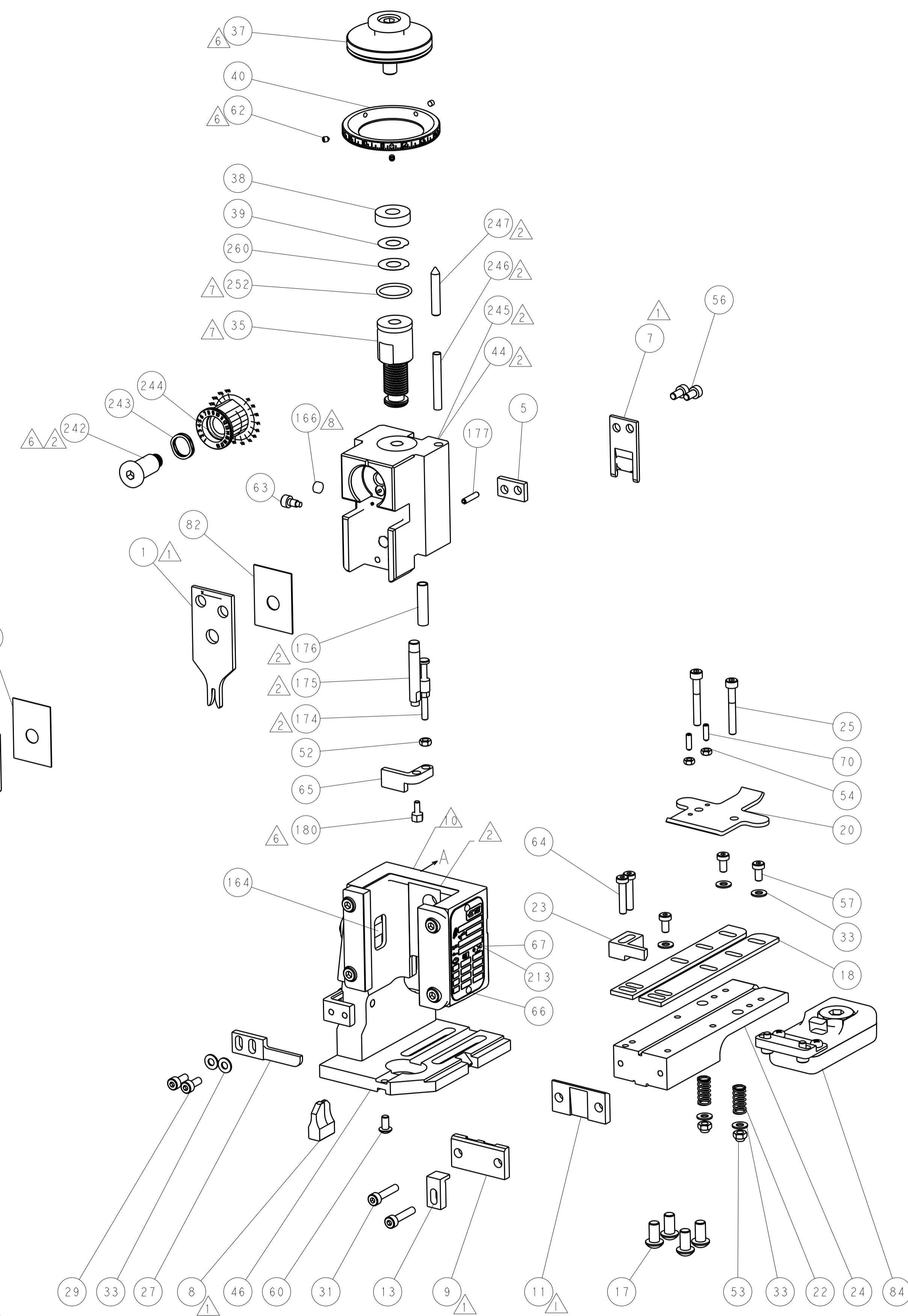
| | | | | | | | | | |
|---|--------------------|--------|---|---|---|-------------|-------------------------------------|--------------------------|----|
| - | 1 | 1 | 1 | 1 | 1 | 2119082-7 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 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 | |
| - | - | REFREF | - | - | - | 1901697-1 | FEED FINGER ASSEMBLY, EF | 183 | |
| - | 1 | 1 | 1 | 1 | 1 | 1752354-1 | STANDOFF, HOLD-DOWN | 180 | |
| - | 1 | 1 | 1 | 1 | 1 | 6-993111-6 | PIN, SLOTTED SPRING 3.0 X 14.0 | 177 | |
| - | 1 | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 | |
| - | 1 | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 | |
| - | 1 | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 | |
| - | - | - | - | 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 | |
| - | 1 | 1 | 1 | 1 | 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 | |
| - | REFREFREFREFREFREF | - | - | - | - | 994970-2 | COUNTER, MAGNETIC | 164 | |
| - | - | - | - | - | 1 | 240638-1 | SPRING, FEED FINGER | 163 | |
| - | - | - | - | - | 1 | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 | |
| - | - | REFREF | - | - | - | SEE NOTE 4 | MEMORY CHIP, PROGRAMMED | 135 | |
| - | - | 1 | 1 | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 | |
| - | 1 | 1 | 1 | 1 | 1 | 455888-5 | 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 | 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 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 64 | |
| - | 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 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 56 | |
| - | 2 | 2 | 2 | 2 | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 | |
| - | 2 | 2 | 2 | 2 | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 | |
| - | - | - | - | - | 1 | 2119792-2 | PAWL, EF, AIR | 51 | |
| - | - | - | - | - | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 | |
| - | - | - | - | - | 1 | 2119653-1 | FEED CAM, POST FEED | 47 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119655-5 | APPLICATOR BASIC ASSEMBLY, EF | 46 | |
| - | 1 | - | - | - | 1 | 2119369-1 | RAM, AMP STYLE, END FEED | 44 | |
| - | 1 | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 | |
| - | 1 | - | - | - | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 | |
| - | 1 | - | - | - | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-2119644-2 | RAM WASHER, PRECISION | 38 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 | |
| - | 1 | - | - | - | 1 | 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 | 1-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 30 | 25 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-1752371-8 | PLATE, STRIP GUIDE | 24 | |
| - | 1 | 1 | 1 | 1 | 1 | 240825-1 | PLATE, STRIP HOLD DOWN | 23 | |
| - | 2 | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 | |
| - | 1 | 1 | 1 | 1 | 1 | 1803292-4 | DRAG | 20 | |
| - | 2 | 2 | 2 | 2 | 2 | 1901259-5 | GUIDE, LOWER STRIP | 18 | |
| - | 4 | 4 | 4 | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 | |
| - | 1 | 1 | 1 | 1 | 1 | 1752360-1 | SPACER, HOLD-DOWN | 13 | |
| - | 1 | 1 | 1 | 1 | 1 | 240833-1 | PLATE, REAR SHEAR | 11 | |
| - | - | - | - | - | - | - | - | 10 | |
| - | 1 | 1 | 1 | 1 | 1 | 690482-1 | PLATE, FRONT SHEAR | 9 | |
| 1 | 1 | 1 | 1 | 1 | 1 | 3-1803257-7 | ANVIL, COMBINATION, END FEED | 8 | |
| - | 1 | 1 | 1 | 1 | 1 | 2217206-2 | BLADE, SLUG | 7 | |
| - | - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 1 | 240641-8 | SPACER | 5 | |
| - | 1 | 1 | 1 | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 | |
| 1 | 1 | 1 | 1 | 1 | 1 | 2-1633961-3 | CRIMPER, INSULATION F PREMIUM | 3 | |
| - | 1 | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 | |
| 1 | 1 | 1 | 1 | 1 | 1 | 3-456404-4 | CRIMPER, WIRE PREMIUM | 1 | |

| DIMENSIONS: | TOLERANCES UNLESS OTHERWISE SPECIFIED: | OWN | DATE | CHK | DATE | APVD | DATE | NAME | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|--|--|---------|-----------|----------|-----------|----------|-----------|--|------|-----------|------------|---------------|
| mm | 0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ± | M. ZHAO | 31AUG2017 | K. ZHANG | 31AUG2017 | K. ZHANG | 31AUG2017 | TE Connectivity Harrisburg, PA 17105-3608 | A1 | 00779 | ©=2150837 | |
| Customer Accessible Production Drawing | | | | | | | | | | | | |

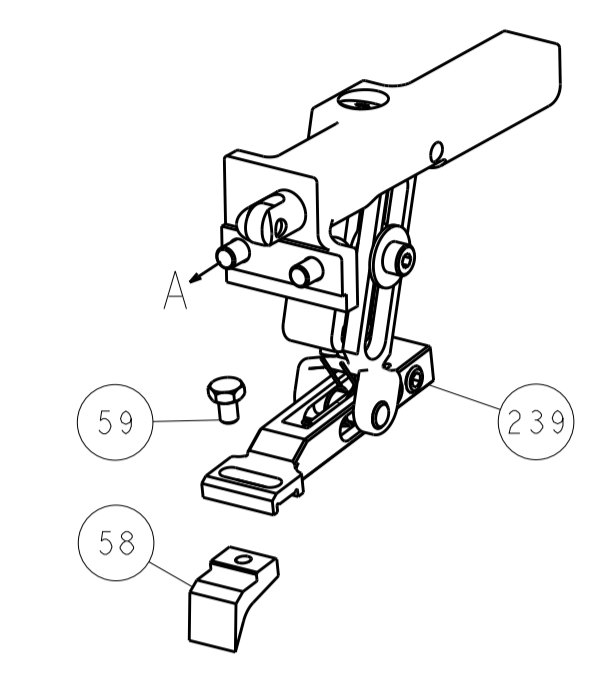
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|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTM | DESCRIPTION | DATE | DMN | APVD |
| | | - | - | SEE SHEET 1 | - | - | - |



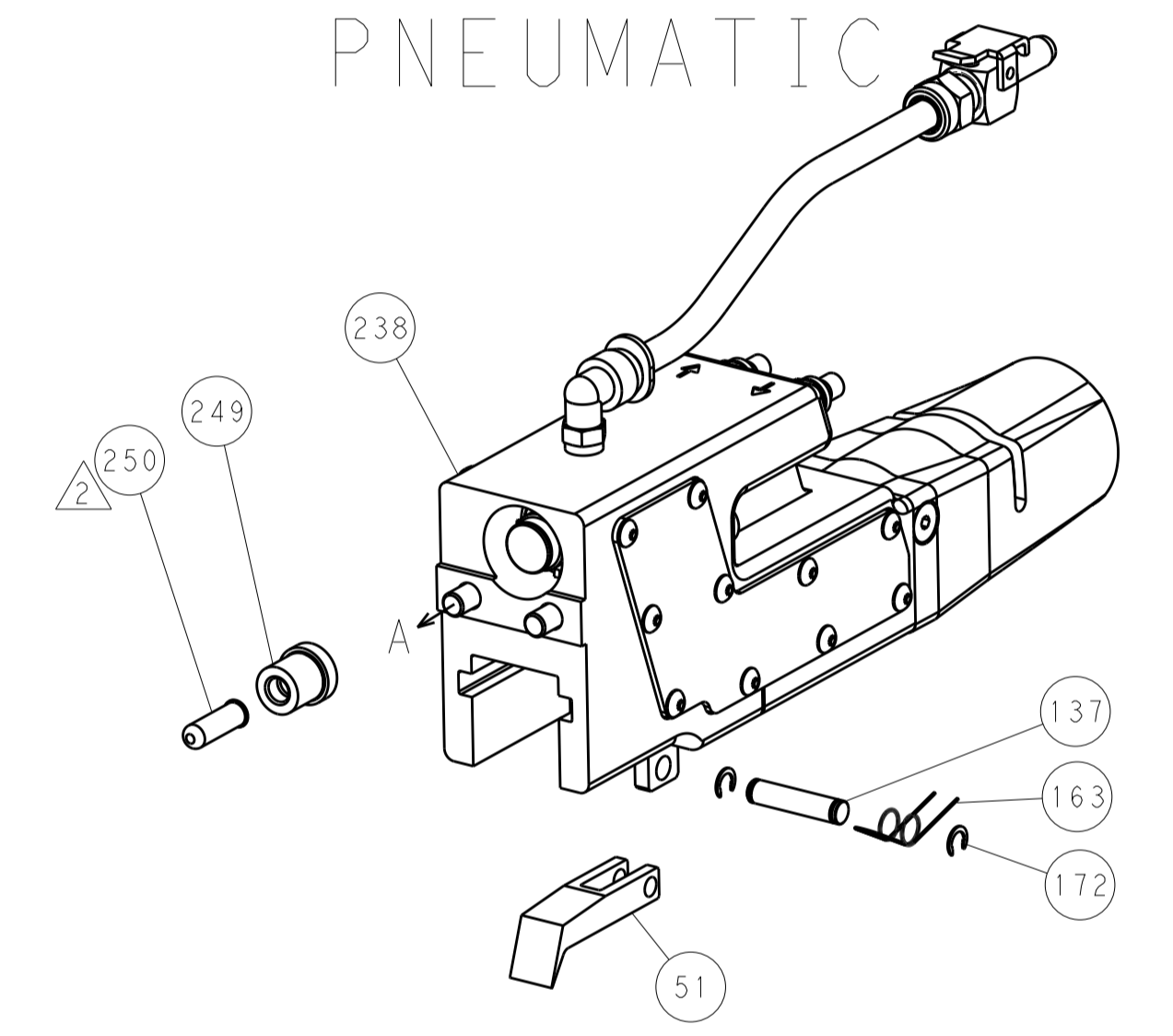
HOLDDOWN SET-UP



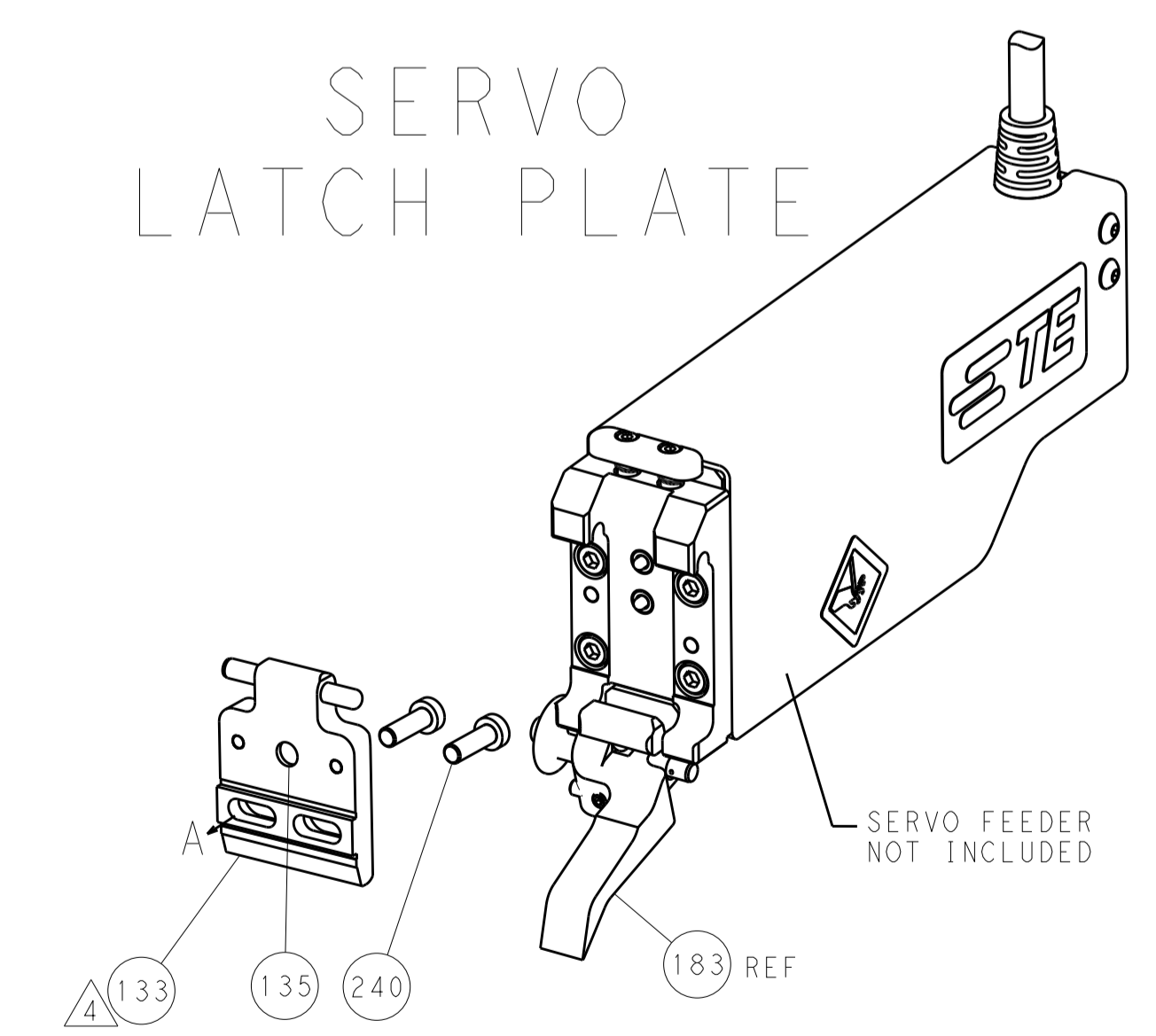
FEED TYPE
MECHANICAL



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)

| | | | | | | | |
|-------------|---------|--|---------|--|---------|---------------------------------|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: M. ZHAO 31AUG2017 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | CHK: K. ZHANG 31AUG2017 | | NAME: Ocean End Feed Applicator | |
| | | | | APVD: K. ZHANG 31AUG2017 | | PRODUCT SPEC: | |
| | | | | | | APPLICATION SPEC: | |
| | | | | WEIGHT: | | SIZE: CAGE CODE: DRAWING NO: | |
| | | | | A1 00779 ©=2150837 | | RESTRICTED TO: | |
| | | | | Customer Accessible Production Drawing | | SCALE: 1:1 SHEET 2 OF 4 REV A | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-2 | - |
| 2-2150837-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150837-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150837-4 | - | - | - |
| | | | | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150837-5 | - | - | 2168400-7 (QUANTITY 2) |
| 2-2150837-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SMART APPLICATOR | 2161326-1 | - | 8-2150837-4 | - | - | - |
| | | | | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150837-5 | - | - | 2168400-7 (QUANTITY 2) |
| 2-2150837-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-2 | - | 2063440-1 |
| 2-2150837-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| 7-2150837-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|-----------------------------|------|--|
| CRIMP SIZE | TYPE | |
| WIRE 1.78 mm (.070) | F | |
| INSUL 3.56 mm (.140) | F | |
| APPL INSTRUCTIONS 408-10390 | | |

| | | | |
|--|------------------------------|-------------|-------------------------|
| TERMINAL DATA: DELPHI PACKARD TERMINALTE CRIMP SPECIFICATION | | | |
| TERMINAL NAME: 2.8 RECEPTACLE TERMINAL | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 3.33-4.09 mm (.131-.161 IN) | Ø1.50-2.40 mm (.059-.094 IN) | | |
| TERMINAL APPLICATION SPECIFICATION | NONE | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | DELPHI PACKARD TERMINAL | TE TERMINAL | DELPHI PACKARD TERMINAL |
| 2318371-1 | 33501244 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|--------------------------------|--------------------------------|
| 1.00mm2 | 1.26 +/- 0.05 [0.050 +/- .002] | 6.7 |
| 18 AWG | 1.19 +/- 0.05 [0.047 +/- .002] | 7.9 |
| 0.75mm2 | 1.12 +/- 0.05 [0.044 +/- .002] | 8.7 |
| 20 AWG OR 0.50mm2 | 1.08 +/- 0.05 [0.043 +/- .002] | 9.0 |
| 22 AWG OR 0.30mm2 | 0.98 +/- 0.05 [0.039 +/- .002] | 10.0 |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150837-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150837-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150837-5
- ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180. 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

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

| - | 1 | 1 | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 | | |
|-----------------|---|---|---|---|---|-----------|-------------------------------------|---------|--|--|
| - | - | - | 1 | - | - | 2119640-1 | PUSH ROD, AIR FEED | 250 | | |
| - | - | - | 1 | - | - | 1803259-1 | BUSHING, FLANGED | 249 | | |
| - | 1 | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 | | |
| - | 1 | 1 | 1 | 1 | 1 | 2119082-7 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | | |
| - | 1 | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | | |
| -77-27-25-22-21 | | | | | | PART NO | DESCRIPTION | ITEM NO | | |

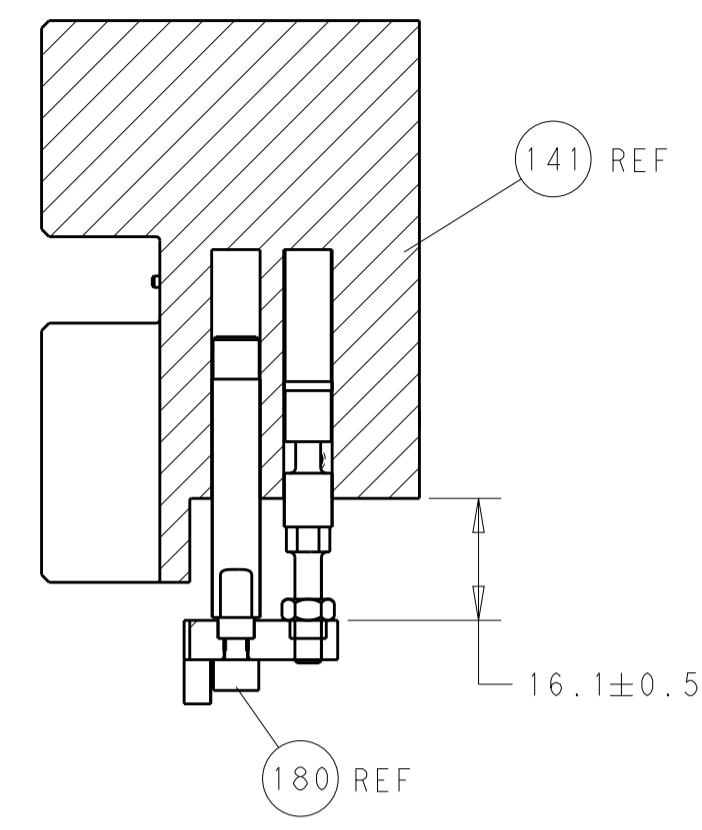
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|------|----|------|
| 2119599-2 | A | 66 | REV | DATE | BY | APPV |
| | | | - | - | - | - |
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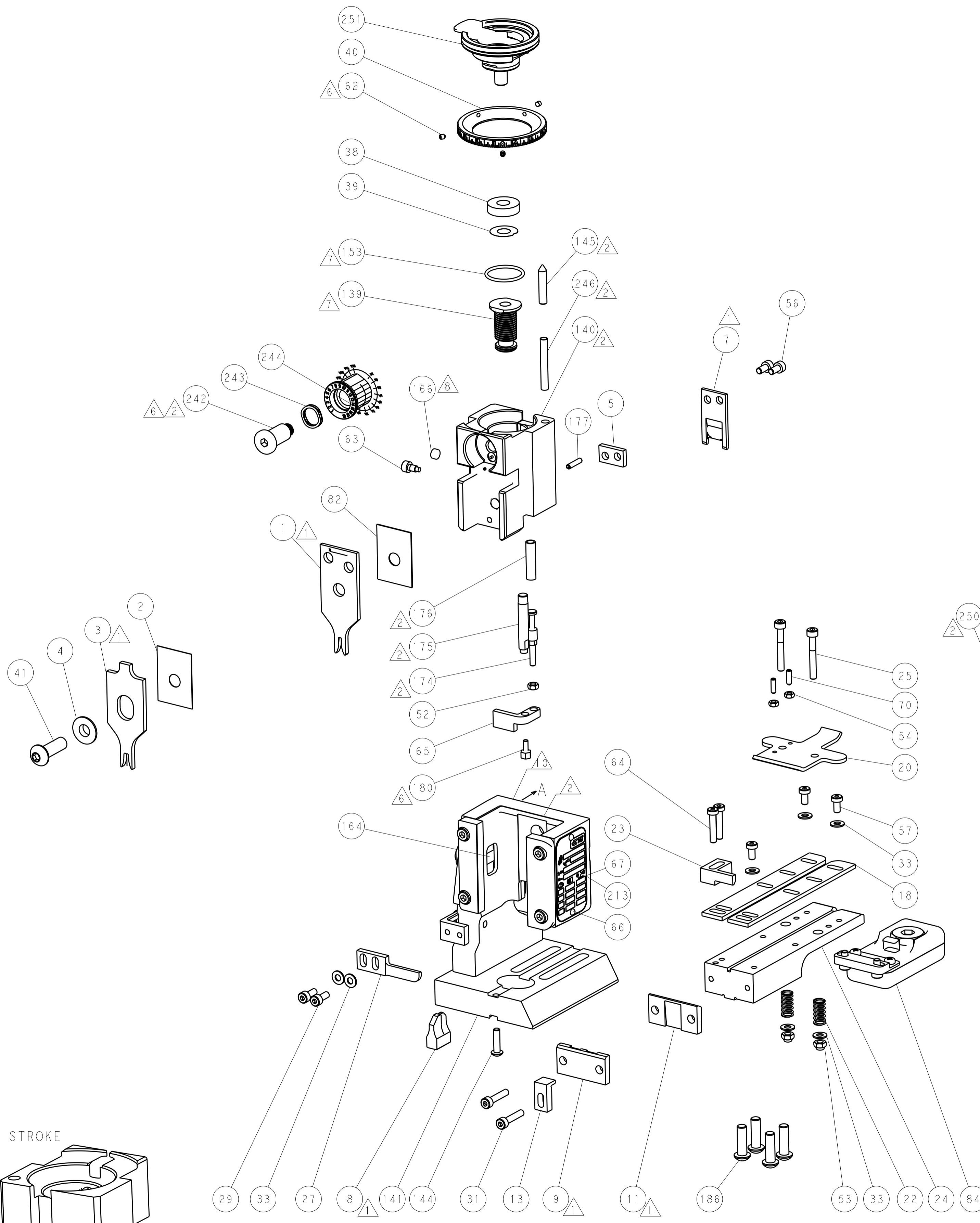
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|-----------------|------|-----|------|-------------|-------------|-------------------------------------|-------------|---------|--|--|
| - | - | - | - | SEE SHEET 1 | - | - | - | | | |
| - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 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 | 1752354-1 | STANDOFF, HOLD-DOWN | 180 | | | |
| - | 1 | 1 | 1 | 1 | 6-993111-6 | PIN, SLOTTED SPRING 3.0 X 14.0 | 177 | | | |
| - | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 | | | |
| - | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 | | | |
| - | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 | | | |
| - | - | - | 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 | | | |
| - | 1 | 1 | 1 | 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 | | | |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 | | | |
| - | - | - | 1 | - | 240638-1 | SPRING, FEED FINGER | 163 | | | |
| - | 1 | 1 | 1 | 1 | 8-21084-1 | O-RING, .801 ID, .070 DIA. MAT. | 153 | | | |
| - | - | - | 1 | - | 2119641-2 | FEED CAM, AIR FEED | 152 | | | |
| - | 1 | 1 | 1 | 1 | 2119798-2 | DETENT PIN | 145 | | | |
| - | 1 | 1 | 1 | 1 | 2079383-8 | SCR, BHSC, RoHS (M4 X 16) | 144 | | | |
| - | - | - | - | 1 | 2119653-2 | FEED CAM, POST FEED | 142 | | | |
| - | 1 | 1 | 1 | 1 | 2119655-6 | APPLICATOR BASIC ASSEMBLY, EF | 141 | | | |
| - | 1 | 1 | 1 | 1 | 2119651-1 | RAM, ASIAN STYLE, END FEED | 140 | | | |
| - | 1 | 1 | 1 | 1 | 2119092-2 | BOLT, ADJUSTMENT | 139 | | | |
| - | - | - | 1 | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 | | | |
| - | - | REF | - | - | SEE NOTE 4 | MEMORY CHIP, PROGRAMMED | 135 | | | |
| - | - | 1 | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 | | | |
| - | 1 | 1 | 1 | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 | | | |
| - | 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 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 64 | | | |
| - | 1 | 1 | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 | | | |
| - | 3 | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE 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 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 56 | | | |
| - | 2 | 2 | 2 | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 | | | |
| - | 2 | 2 | 2 | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 | | | |
| - | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 | | | |
| - | - | - | 1 | - | 2119792-2 | PAWL, EF, AIR | 51 | | | |
| - | - | - | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 | | | |
| - | - | - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 | | | |
| - | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 | | | |
| - | 1 | 1 | 1 | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 | | | |
| - | 1 | 1 | 1 | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 | | | |
| - | 1 | 1 | 1 | 1 | 1-2119644-2 | RAM WASHER, PRECISION | 38 | | | |
| - | 7 | 7 | 7 | 7 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 | | | |
| - | 2 | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 31 | | | |
| - | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 29 | | | |
| - | 1 | 1 | 1 | 1 | 240639-1 | STRIPPER (MACHINING) | 27 | | | |
| - | 2 | 2 | 2 | 2 | 1-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 30 | 25 | | | |
| - | 1 | 1 | 1 | 1 | 1-1752371-8 | PLATE, STRIP GUIDE | 24 | | | |
| - | 1 | 1 | 1 | 1 | 240825-1 | PLATE, STRIP HOLD DOWN | 23 | | | |
| - | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 | | | |
| - | 1 | 1 | 1 | 1 | 1803292-4 | DRAG | 20 | | | |
| - | 2 | 2 | 2 | 2 | 1901259-5 | GUIDE, LOWER STRIP | 18 | | | |
| - | 1 | 1 | 1 | 1 | 1752360-1 | SPACER, HOLD-DOWN | 13 | | | |
| - | 1 | 1 | 1 | 1 | 240833-1 | PLATE, REAR SHEAR | 11 | | | |
| - | - | - | - | - | - | - | 10 | | | |
| - | 1 | 1 | 1 | 1 | 690482-1 | PLATE, FRONT SHEAR | 9 | | | |
| - | 1 | 1 | 1 | 1 | 3-1803257-7 | ANVIL, COMBINATION, END FEED | 8 | | | |
| - | 1 | 1 | 1 | 1 | 2217206-2 | BLADE, SLUG | 7 | | | |
| - | - | - | - | - | - | - | 6 | | | |
| - | 1 | 1 | 1 | 1 | 240641-8 | SPACER | 5 | | | |
| - | 1 | 1 | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 | | | |
| - | 1 | 1 | 1 | 1 | 2-1633961-3 | CRIMPER, INSULATION F PREMIUM | 3 | | | |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 | | | |
| - | 1 | 1 | 1 | 1 | 3-456404-4 | CRIMPER, WIRE PREMIUM | 1 | | | |
| -77-27-25-22-21 | | | | | | PART NO | DESCRIPTION | ITEM NO | | |

| | | | | | | | | | | | |
|----------------|--|--|--|------------------------|--|-------------------------|--|--------------------------|--|---------------------------------|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: M. ZHAO 31AUG2017 | | CHK: K. ZHANG 31AUG2017 | | APVD: K. ZHANG 31AUG2017 | | NAME: Ocean End Feed Applicator | |
| 0 PLC ± | | 1 PLC ± | | 2 PLC ± | | 3 PLC ± | | 4 PLC ± | | RESTRICTED TO | |
| MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: 1:1 | | SHEET 3 OF 4 | | REV A | |

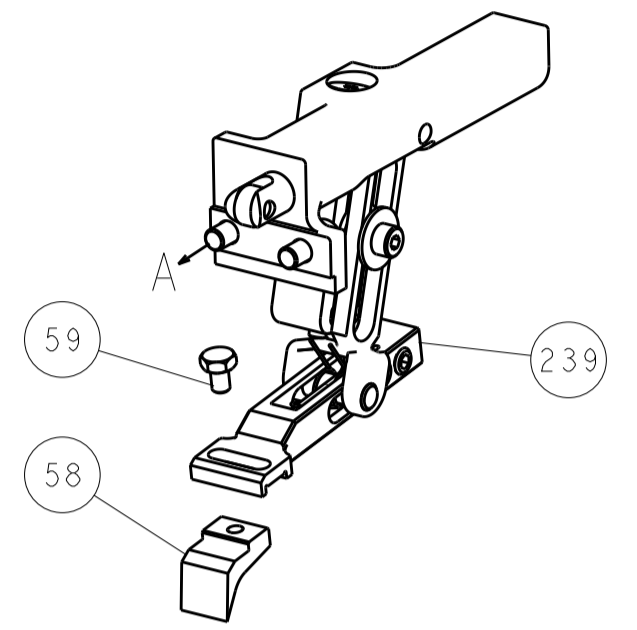
| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTM | DESCRIPTION | DATE | OWN | APVD |
| | | - | - | SEE SHEET 1 | - | - | - |



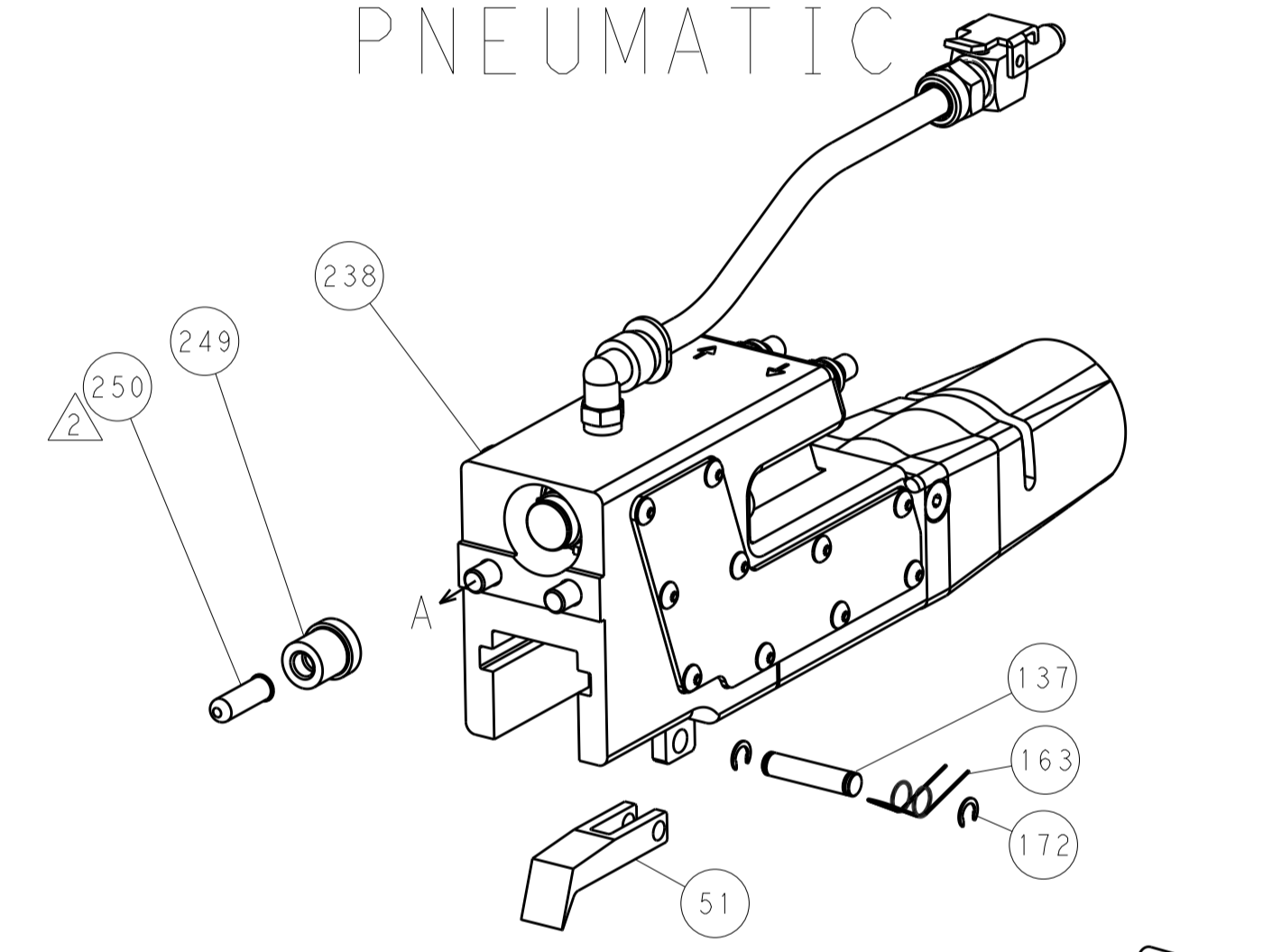
HOLDDOWN SET-UP



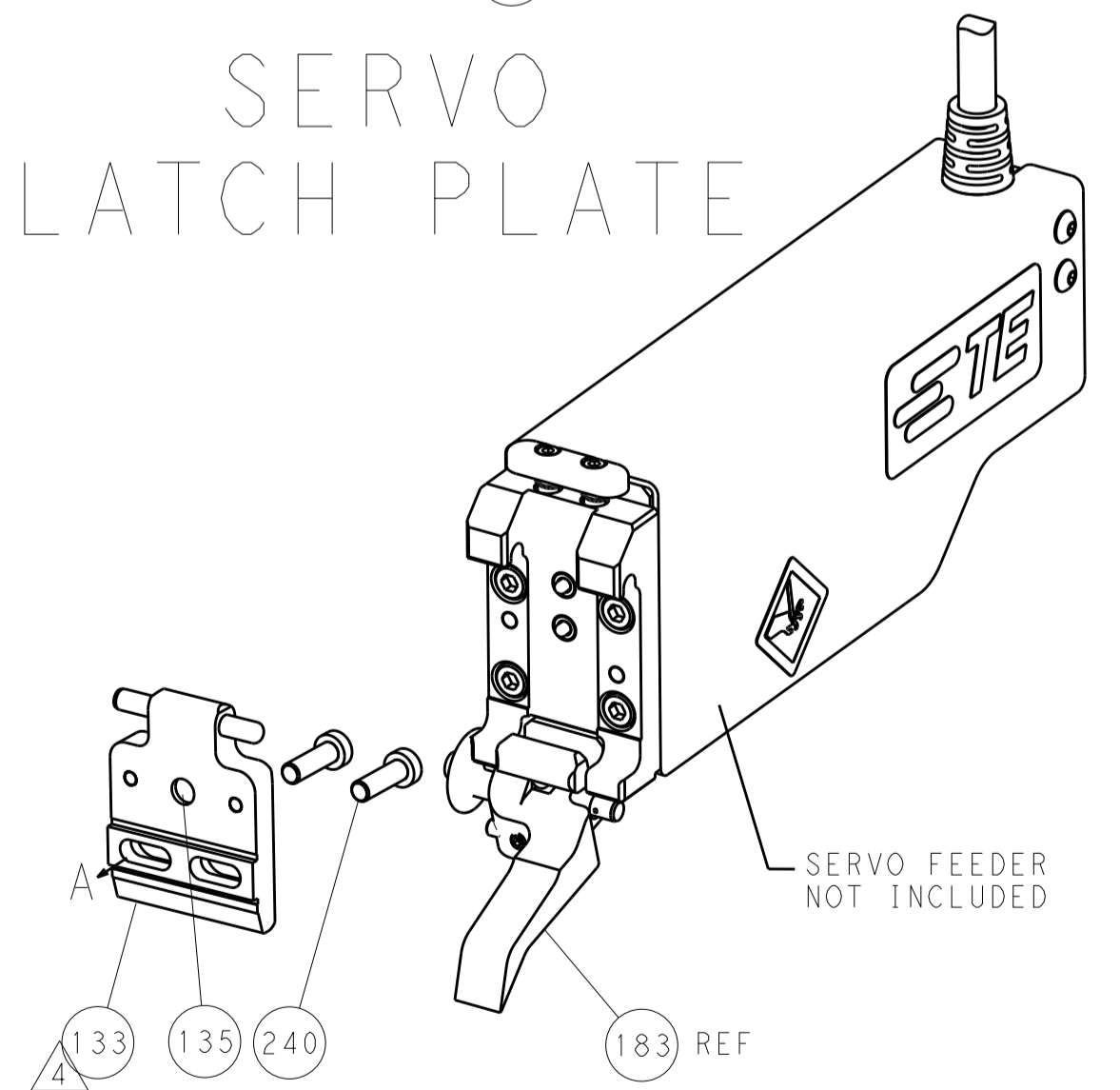
FEED TYPE
MECHANICAL



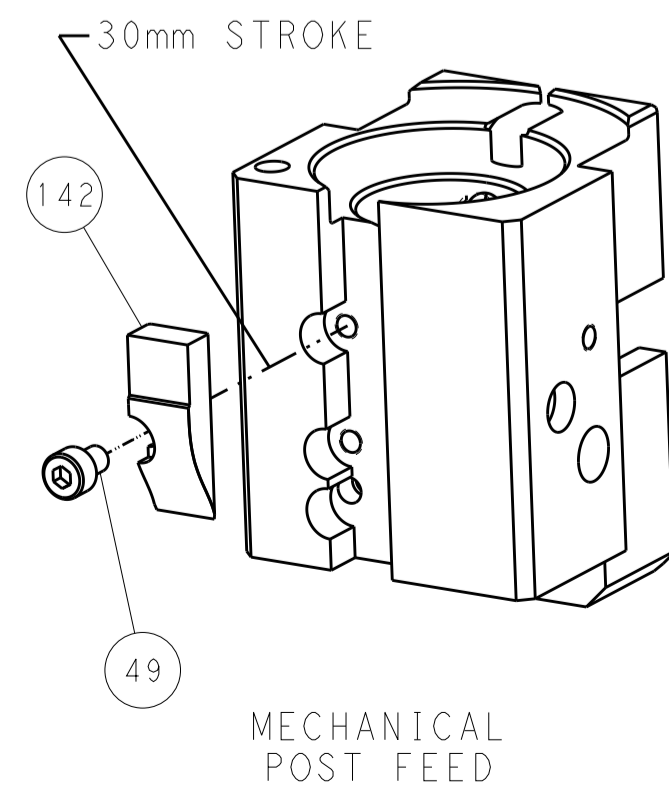
PNEUMATIC



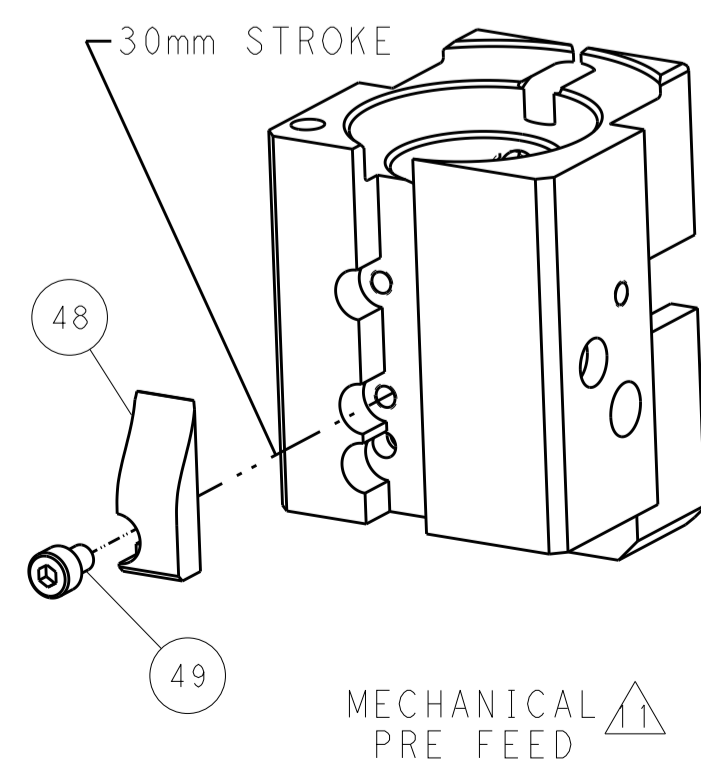
SERVO
LATCH PLATE



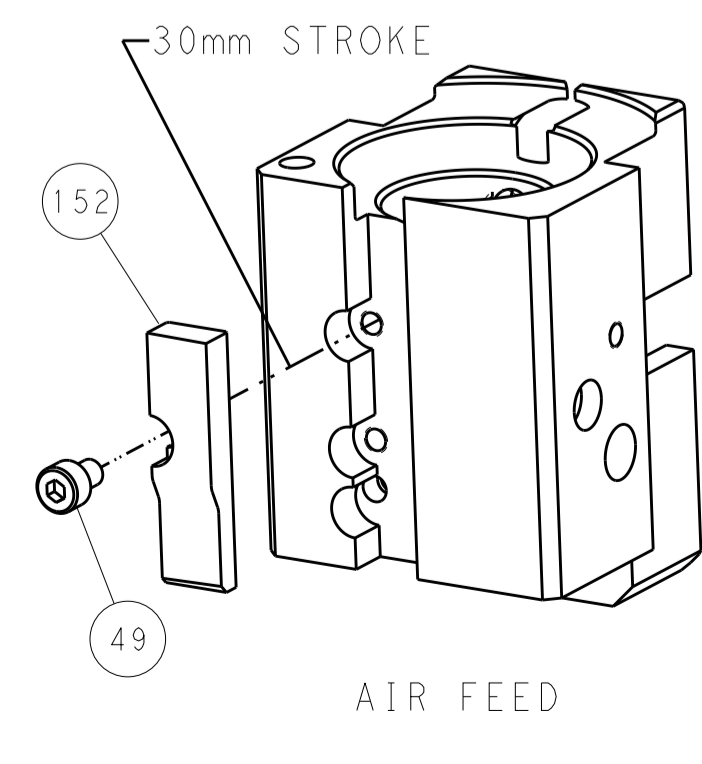
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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

| | | | | | | | |
|-------------|---------|--|---------|--|---------------------------|-----------------|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: M. ZHAO 31AUG2017 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| MATERIAL: | FINISH: | WEIGHT: | ANGLES: | APVD: K. ZHANG 31AUG2017 | NAME: | SIZE: | CAGE CODE: 00779 |
| | | | | PRODUCT SPEC: | Ocean End Feed Applicator | DRAWING NO: | ©=2150837 |
| | | | | APPLICATION SPEC: | | SCALE: | 1:1 |
| | | | | Customer Accessible Production Drawing | | SHEET: | 4 of 4 |
| | | | | | | REV: | A |

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