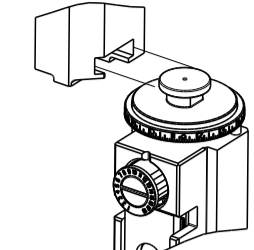

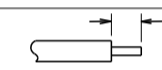



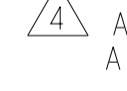

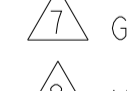
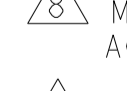

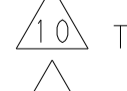
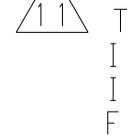


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
	2150335-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	CONVERT TO	PART NUMBERS REQUIRED					
	2150335-7	D	FINE CRIMP HEIGHT ADJUST	NONE	MECHANICAL FEED	2119949-1	1-1338683-0	5-18022-5	2119653-1	-	-
	7-2150335-7	D	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	SP
APPL INSTRUCTIONS 408-10390 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS FLAG F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-5.30 mm [.169-.209 IN]		Ø1.90-3.30 mm [.075-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-64027		
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178423-1			













WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.60 +/- 0.05 [.063 +/- .002]	7.0
18 AWG	1.45 +/- 0.05 [.057 +/- .002]	8.8
20 AWG	1.35 +/- 0.05 [.053 +/- .002]	10.1

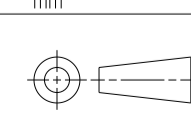
-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150335-4
- 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 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.
-  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.
-  TERMINAL DESIGN IS NOT COMPATIBLE WITH SERVO FEED OR MECHANICAL FEED.
-  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.

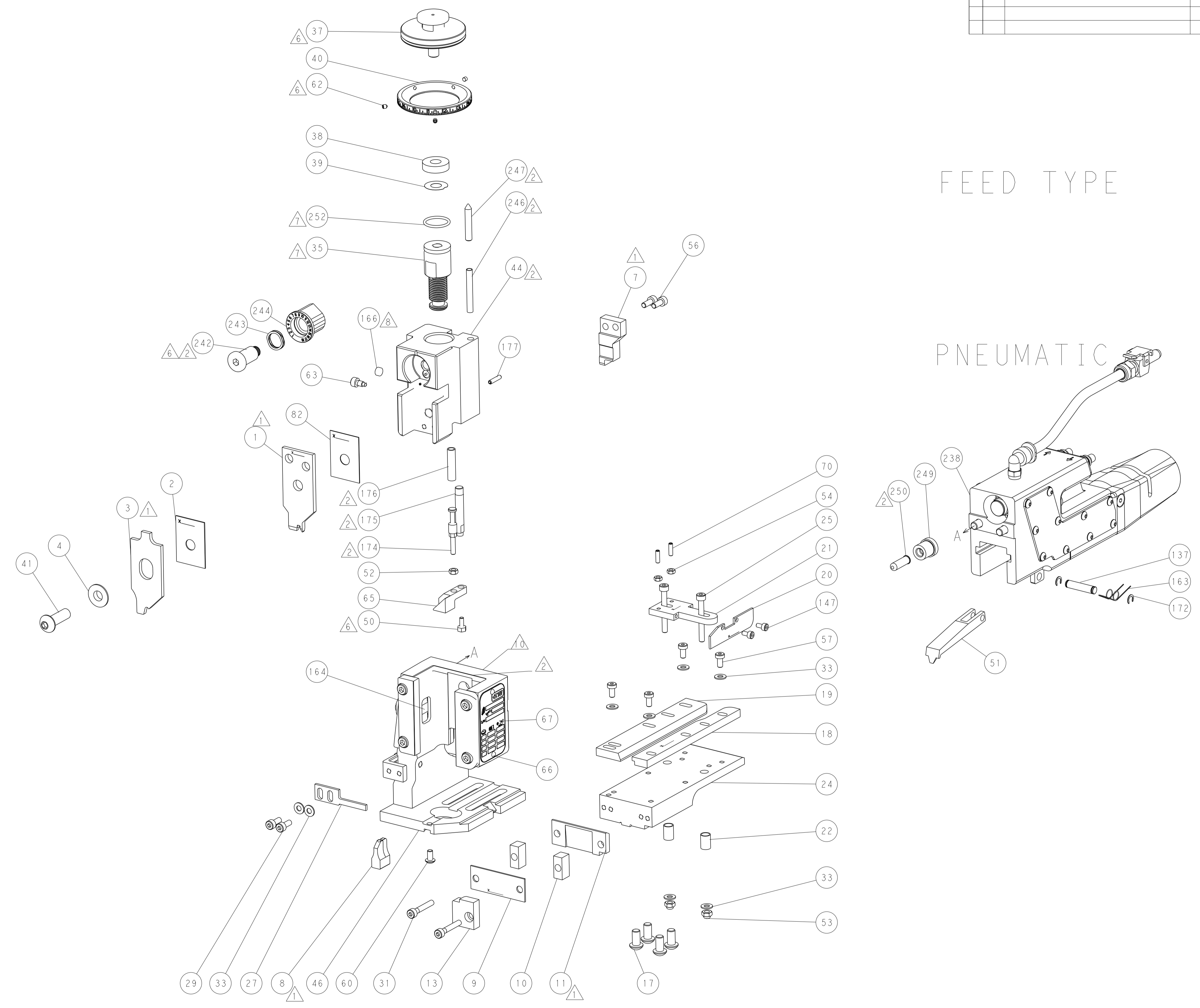
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			REV	DATE	BY	APPD
			C	14SEP2015	YY	UG
			D	26OCT2016	TB	GB

	-	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	2119798-1	DETENT PIN	247
	-	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	2063440-1	AIR FEED MODULE	238
	-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	1	240638-1	SPRING, FEED FINGER	163
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	2119956-2	DOCUMENTATION PACKAGE	71
	-	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1803176-1	HOLDDOWN, TERMINAL	65
	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
	-	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	-	1	2161920-3	NARROW PAWL, EF, AIR	51
	-	1	1	3-1752354-8	STANDOFF, HOLD-DOWN	50
	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
	-	1	1	2119369-1	RAM, AMP STYLE, END FEED	44
	-	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	1-2119644-2	RAM WASHER, PRECISION	38
	-	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	1	1-690455-0	STRIPPER, FRONT CASTING	27
	-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
	-	1	1	2161922-1	PLATE, STRIP GUIDE	24
	-	2	2	22281-6	SPRING, COMPRESSION	22
	-	1	1	1633168-2	ARM, STOCK DRAG	21
	-	1	1	1-464452-7	DRAG, STOCK	20
	-	1	1	1803086-2	GUIDE, REAR STRIP	19
	-	1	1	3-1901695-3	STRIP GUIDE, FRONT	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1803175-1	SUPPORT, TERMINAL	13
	-	1	1	461160-3	PLATE, REAR SHEAR	11
	-	2	2	8-240645-6	SPACER, SHEAR PLATE	10
	-	1	1	455961-5	PLATE, FRONT SHEAR	9
	1	1	1	6-1803059-2	ANVIL, COMBINATION, END FEED	8
	-	1	1	1803186-1	BLADE, SLUG	7
	-	-	-	-	-	6
	-	-	-	-	-	5
	-	1	1	3-238009-1	BLOCK, FL CRIMPER SPACER	4
	1	1	1	1803108-5	CRIMPER, INSULATION O	3
	-	1	1	455888-6	SPACER, CRIMPER	2
	1	1	1	1-1803015-4	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R. KNEPPER 29MAY2013		TE Connectivity	
mm		0 PLC ±		CHK: T. ELBIN 29MAY2013		Harrisburg, PA 17105-3608	
		1 PLC ±		APPD: M. CLIFFORD 29MAY2013		NAME: Ocean End Feed Applicator	
		2 PLC ±		PRODUCT SPEC		SIZE: A1	
		3 PLC ±		APPLICATION SPEC		CAGE CODE: 00779	
		4 PLC ±		WEIGHT		DRAWING NO: C=2150335	
		ANGLES		RESTRICTED TO		SCALE: 1:1	
		FINISH		SHEET 1 OF 4		REV D	
MATERIAL				Customer Accessible Production Drawing			

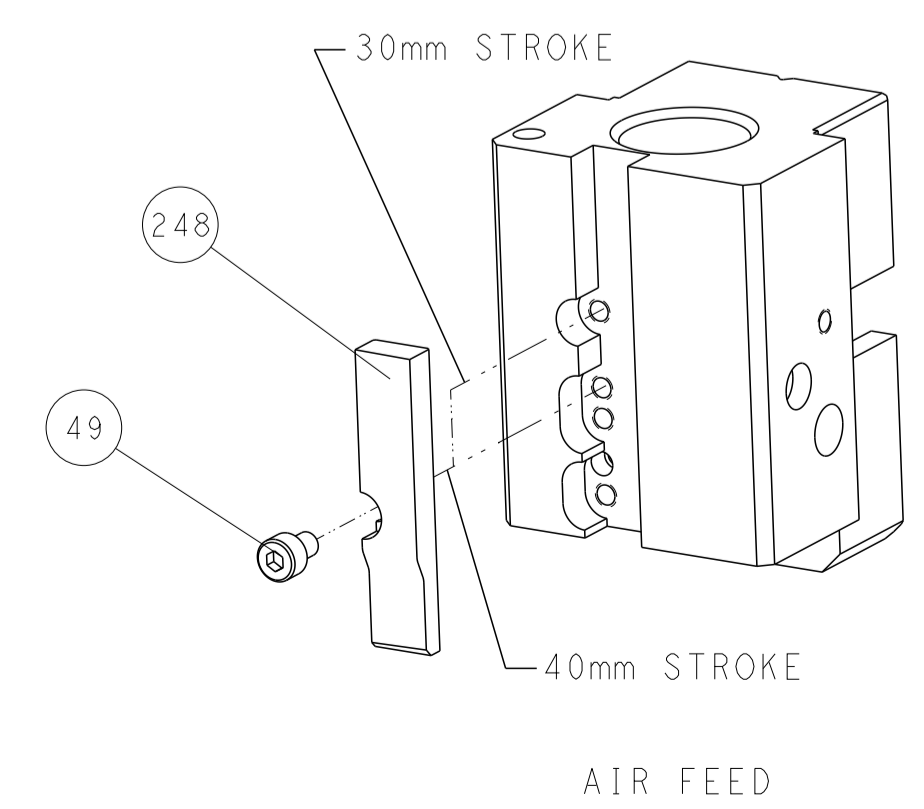
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			



FEED TYPE

PNEUMATIC

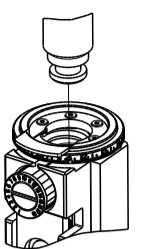
CAM POSITION




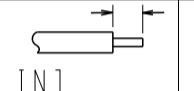


AIR FEED

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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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME Ocean End Feed Applicator	RESTRICTED TO
MATERIAL	WEIGHT	SIZE CAGE CODE DRAWING NO A1 00779 C=2150335	SCALE 1:1 SHEET 2 OF 4 REV D
Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150335-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1-1338683-0	5-18022-5	2119653-2	-	-
	2-2150335-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150335-7	D	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	SP
APPL INSTRUCTIONS 408-10390 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS FLAG F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-5.30 mm [.169-.209 IN]		∅1.90-3.30 mm [.075-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-64027	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178423-1			













WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.60 +/- 0.05 [.063 +/- .002]	7.0
18 AWG	1.45 +/- 0.05 [.057 +/- .002]	8.8
20 AWG	1.35 +/- 0.05 [.053 +/- .002]	10.1

-  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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150335-4
- 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 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.
-  TERMINAL DESIGN IS NOT COMPATIBLE WITH SERVO FEED OR MECHANICAL FEED.
-  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.

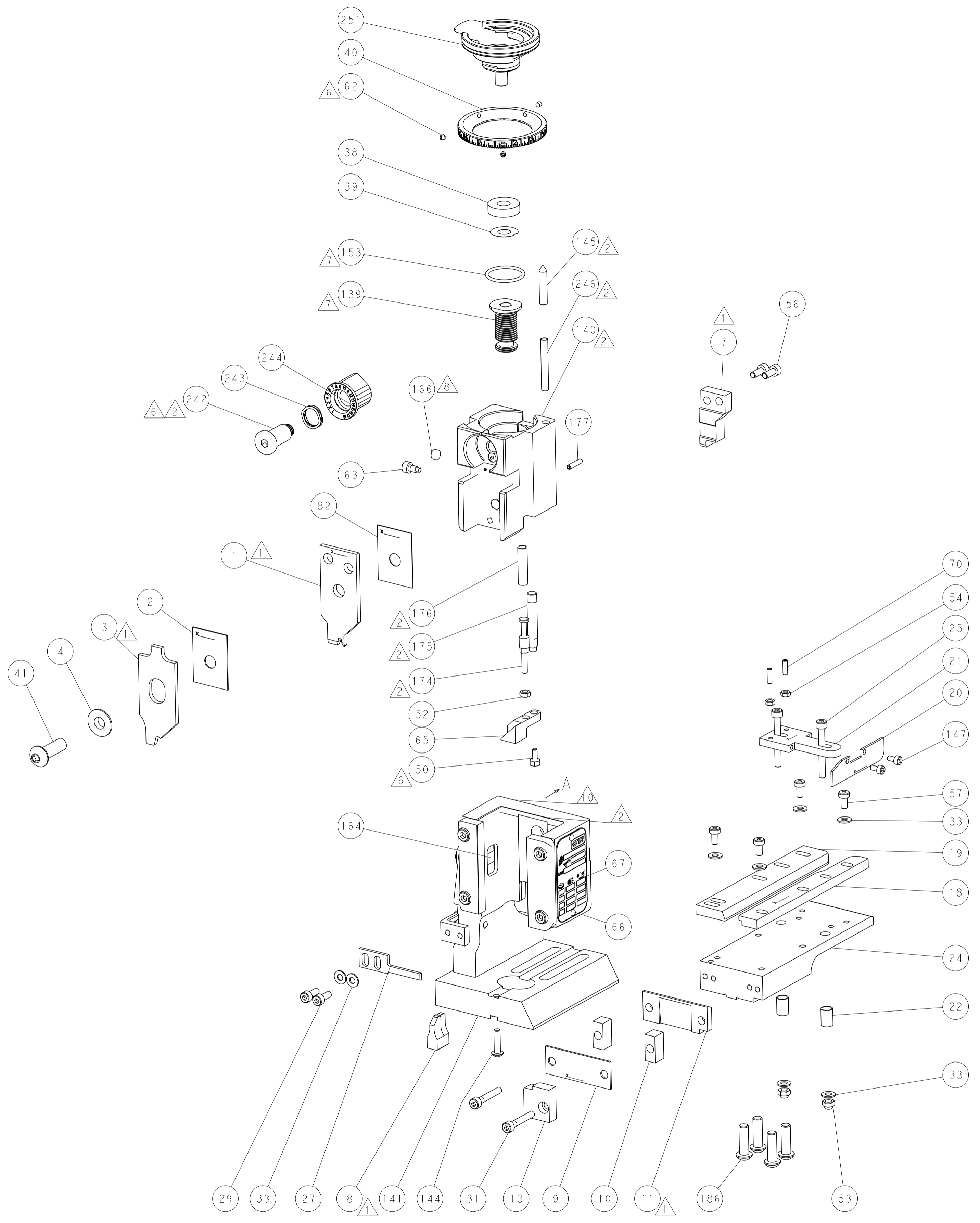
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPD
-	-	-	SEE SHEET 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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2063440-1	AIR FEED MODULE	238
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREF	-	994970-2	COUNTER, MAGNETIC	164
-	-	1	240638-1	SPRING, FEED FINGER	163
	-	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
-	-	1	2119641-2	FEED CAM, AIR FEED	152
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
-	1	1	2119798-2	DETENT PIN	145
-	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
	-	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1803176-1	HOLDDOWN, TERMINAL	65
-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	1	2161920-3	NARROW PAWL, EF, AIR	51
	-	1	3-1752354-8	STANDOFF,HOLD-DOWN	50
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	1-2119644-2	RAM WASHER, PRECISION	38
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1-690455-0	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161922-1	PLATE, STRIP GUIDE	24
-	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1-464452-7	DRAG, STOCK	20
-	1	1	1803086-2	GUIDE, REAR STRIP	19
-	1	1	3-1901695-3	STRIP GUIDE, FRONT	18
-	1	1	1803175-1	SUPPORT, TERMINAL	13
	-	1	461160-3	PLATE, REAR SHEAR	11
	-	2	8-240645-6	SPACER, SHEAR PLATE	10
	-	1	455961-5	PLATE, FRONT SHEAR	9
	1	1	1-1803059-2	ANVIL, COMBINATION, END FEED	8
	-	1	1803186-1	BLADE, SLUG	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	3-238009-1	BLOCK, FL CRIMPER SPACER	4
	1	1	1803108-5	CRIMPER, INSULATION O	3
-	1	1	455888-6	SPACER, CRIMPER	2
	1	1	1-1803015-4	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±	-	-	1:1	SHEET 3 OF 4
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	

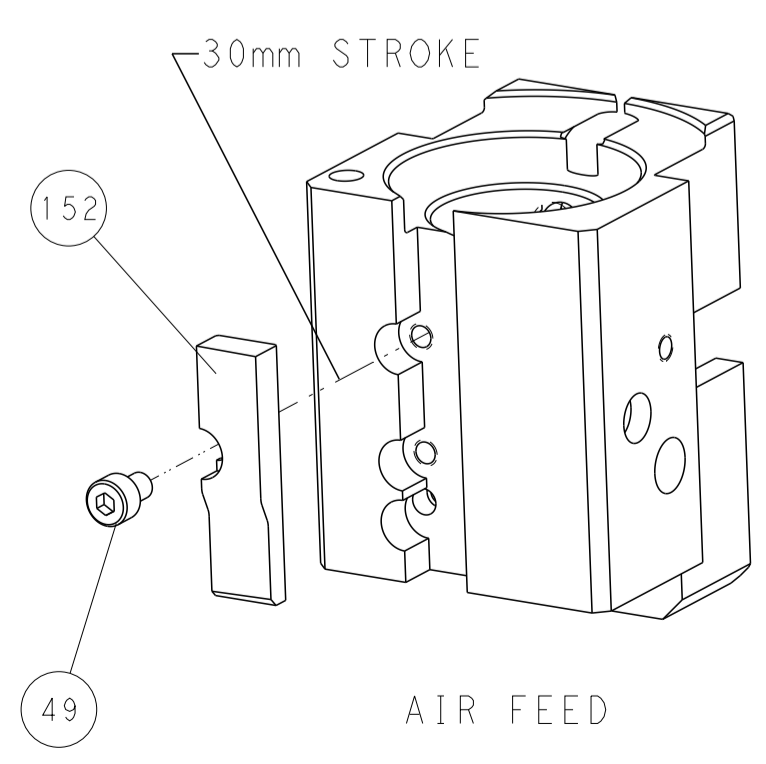
LOC	DIST	REVISIONS					
A	66	P	LTH	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			



FEED TYPE

PNEUMATIC

CAM POSITION



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± MATERIAL: - FINISH: -	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: - SCALE: 1:1	NAME: Ocean End Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150335 SHEET: 4 of 4 REV: D	RESTRICTED TO: -