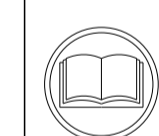


| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-------------|---|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2150387-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | - | - | - | - | - | - | |
| | 2150387-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150387-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | - | 8-2150387-4 | - | - |
| | 2150387-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - | 2063440-2 |
| | | | | | - | - | - | - | - | - | - |
| 2150387-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2150387-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm [.110] | F |
| INSUL | 3.94 mm [.155] | OV |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: G&H TERMINAL | | LEAR CRIMP SPECIFICATION | |
|---|-----------------|------------------------------|---------------|
| TERMINAL NAME: FLACHSTECKER 6.3 X 0.8 - 2.5 | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.20-5.80 mm [.205-.228 IN] | | Ø1.50-2.50 mm [.059-.098 IN] | |
| TERMINAL APPLICATION SPECIFICATION | LEAR SPEC Rev 3 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | G&H TERMINAL | TE TERMINAL | G&H TERMINAL |
| 1949284-1 | 26513.201.179 | 1949284-2 | 26513.213.009 |
| 1949284-3 | 26513.126.009 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|--------------|----------------------------|--------------------------------|
| 2.50mm2 | 1.90+/-0.05 [.075+/-0.002] | 6.4 |
| 1.50+0.50mm2 | 1.75+/-0.05 [.069+/-0.002] | 8.1 |
| 1.00+0.75mm2 | 1.70+/-0.05 [.063+/-0.002] | 8.7 |
| 1.50mm2 | 1.60+/-0.05 [.063+/-0.002] | 9.7 |



- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150387-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150387-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150387-6
- 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 ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 37 & 50.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ¹¹ 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 | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252 |
| -77 | -7 | -6 | -5 | -2 | 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 | LOC | DIST | REVISIONS | | | | | |
|--------------|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-2 | A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | | 1 | | DEVELOPMENT | 16OCT2013 | YY | UG |
| | | | A | | RELEASED | 06JAN2014 | YY | UG |
| | | | A1 | | ECR-17-016207 | 3NOV2017 | RS | LZ |

| | | | | | | | |
|---|--------|--------|---|---|-------------|--------------------------------------|-----|
| - | - | - | - | 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 | 2119798-1 | DETENT PIN | 247 |
| - | 1 | - | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | 1 | - | - | 2119759-1 | RAM, AMP STYLE, END FEED, NON-ADJUST | 245 |
| - | 1 | 1 | 1 | 1 | 2119082-7 | 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 | 2 | - | 2168400-7 | SHCS, LOW HEAD, RoHS, M5 X 10 | 240 |
| - | - | - | - | 1 | 2063440-2 | AIR FEED MODULE | 238 |
| - | - | 1 | 1 | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | - | REFREF | - | - | 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 |
| - | REFREF | REFREF | - | - | 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 | 1-455888-0 | 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 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 1 | 1 | 1 | 1976052-1 | HOLDDOWN, TERMINAL | 65 |
| - | 1 | - | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| - | 3 | - | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE PNT, M3 X 4.0 | 62 |
| - | 1 | 1 | 1 | 1 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 |
| - | 4 | 4 | 4 | 4 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 |
| - | 2 | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 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 | 1-1976055-1 | STANDOFF, HOLD-DOWN | 50 |
| - | - | - | - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1 | 1 | 1 | 2119655-5 | APPLICATOR BASIC ASSEMBLY, EF | 46 |
| - | 1 | - | 1 | 1 | 2119369-1 | RAM, AMP STYLE, END FEED | 44 |
| - | 1 | 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 | 1 | 2119644-2 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | 1 | - | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | 8 | 8 | 8 | 8 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 |
| - | 2 | 2 | 2 | 2 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 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 |
| - | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1 | 1 | 1 | 1752373-4 | DRAG | 20 |
| - | 1 | 1 | 1 | 1 | 1901696-3 | STRIP GUIDE, REAR | 19 |
| - | 1 | 1 | 1 | 1 | 1901695-3 | STRIP GUIDE, FRONT | 18 |
| - | 4 | 4 | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 |
| - | 1 | 1 | 1 | 1 | 2-240641-5 | SPACER | 16 |
| - | 1 | 1 | 1 | 1 | 1752360-1 | SPACER, HOLD-DOWN | 13 |
| - | 1 | 1 | 1 | 1 | 240644-9 | PLATE, REAR SHEAR | 11 |
| - | 1 | 1 | 1 | 1 | 5-690482-9 | PLATE, FRONT SHEAR | 9 |
| - | 1 | 1 | 1 | 1 | 3-1803001-2 | ANVIL, COMBINATION, END FEED | 8 |
| - | 1 | 1 | 1 | 1 | 1-2217206-4 | BLADE, SLUG | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 7-240641-2 | SPACER | 5 |
| - | 1 | 1 | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1-2119785-6 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 1-455888-2 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 2-1633305-3 | CRIMPER, WIRE PREMIUM | 1 |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG | | REV | |
|-------------|--------|--|--|-----------|-----------|-----|--|
| mm | 0 PLC | ± | | Y. YIN | 16OCT2013 | 1 | |
| | 1 PLC | ± | | G. BAILEY | 16OCT2013 | 2 | |
| | 2 PLC | ± | | J. GUO | 16OCT2013 | 3 | |
| | 3 PLC | ± | | | | | |
| | 4 PLC | ± | | | | | |
| | ANGLES | ± | | | | | |
| | FINISH | ± | | | | | |
| MATERIAL | | | | WEIGHT | | | |
| | | | | | | | |

STE TE Connectivity
 Harrisburg, PA 17105-3608

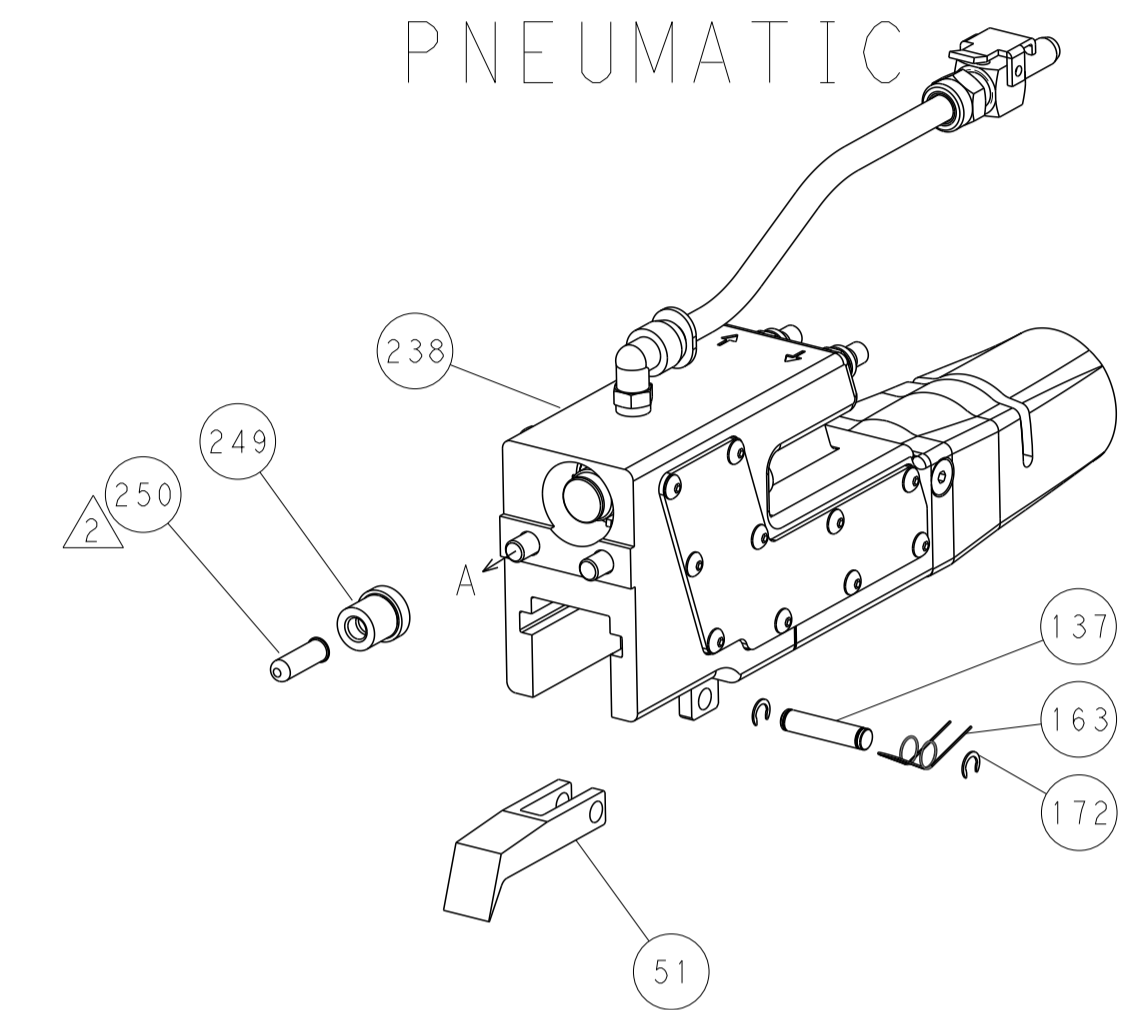
Ocean End Feed
 Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150387
 RESTRICTED TO: Customer Accessible Production Drawing SCALE: 1:1 SHEET 1 OF 4 REV: A1

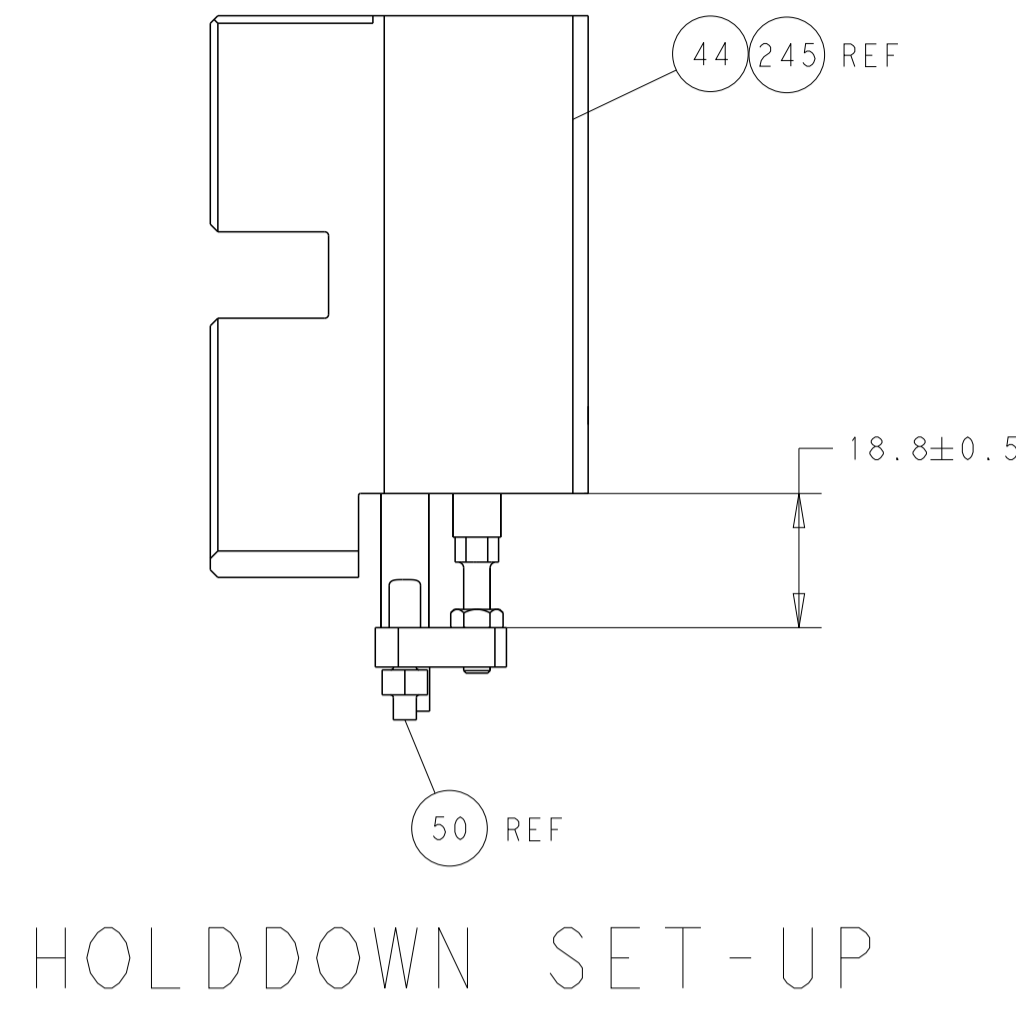
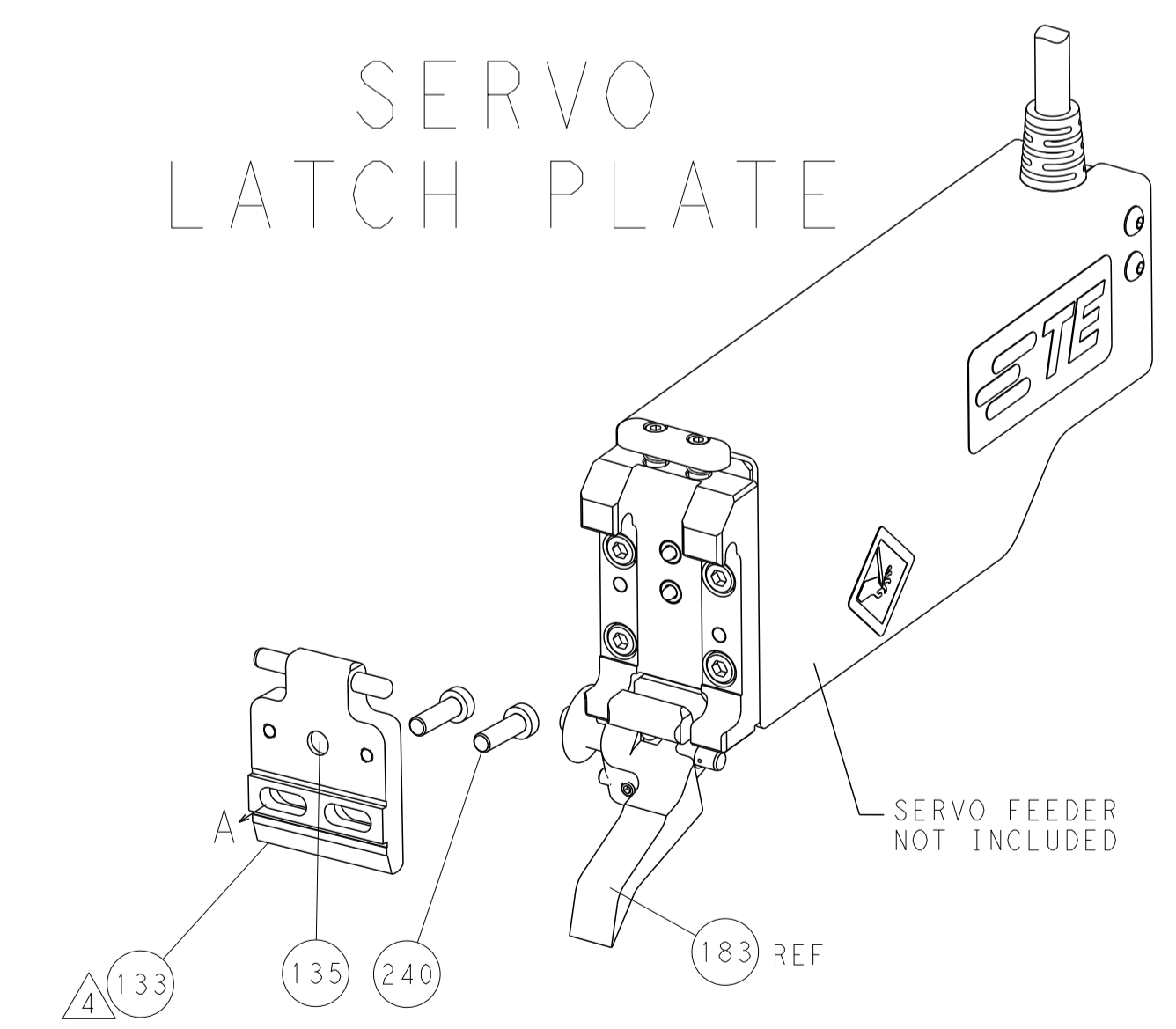
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|-----|------|-----|------|----|------|
| A | 66 | | | | |
| | | | | | |
| | | | | | |

FEED TYPE

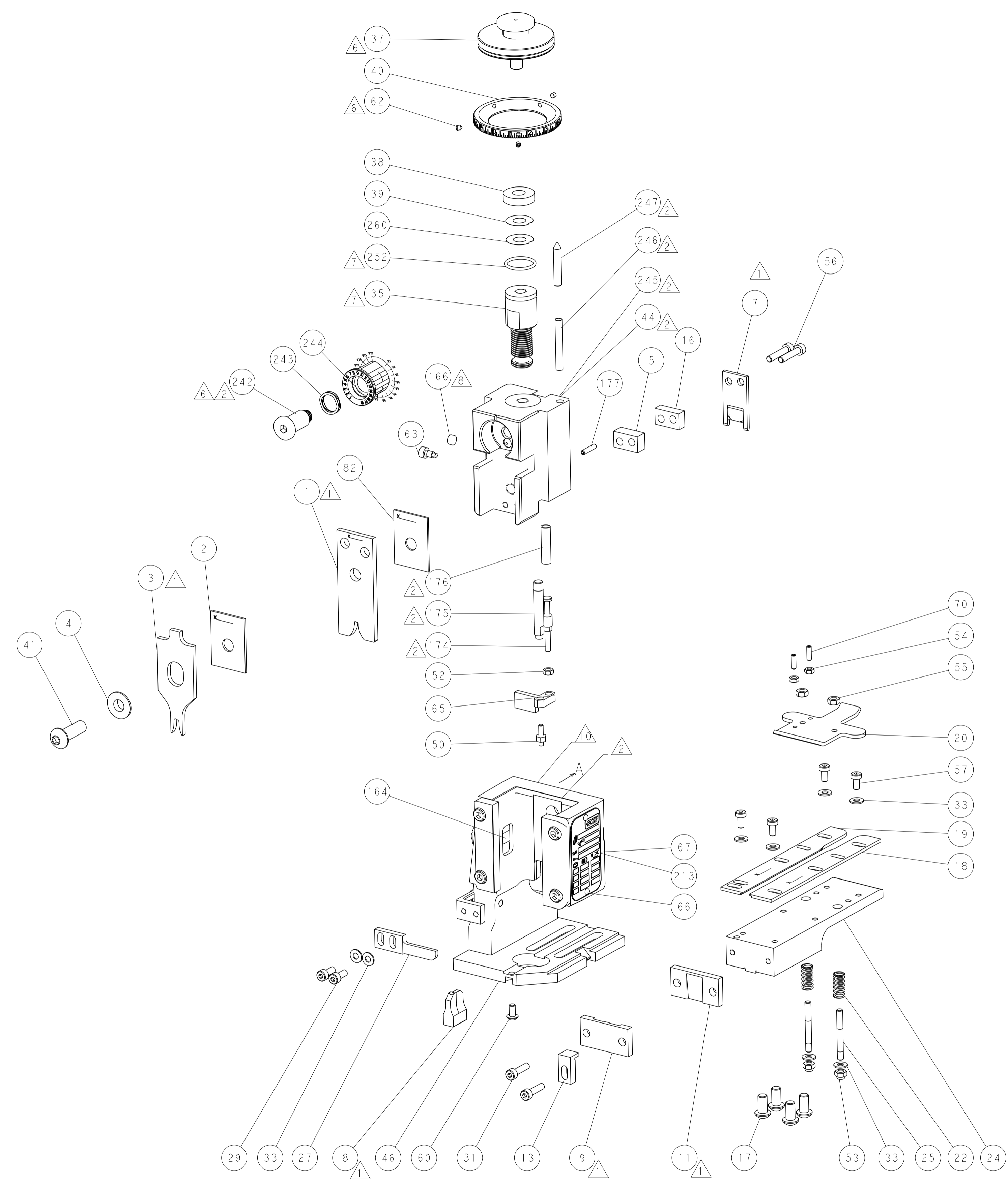
PNEUMATIC



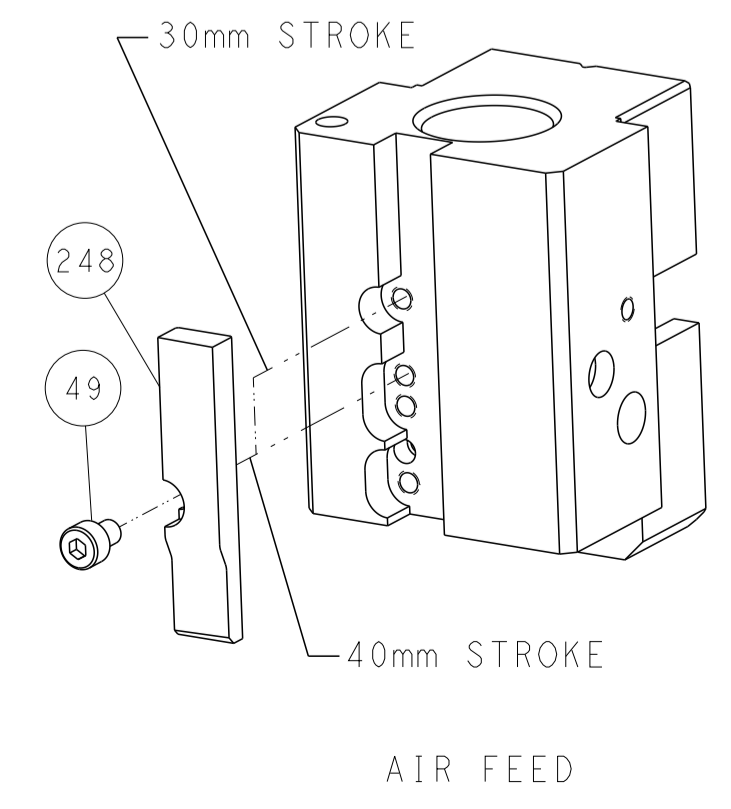
SERVO LATCH PLATE



HOLDDOWN SET-UP



CAM POSITION



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

| | | | |
|---|--|--|--|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN: Y. YIN 16OCT2013 CHK: G. BAILEY 16OCT2013 APVD: H. GUO 16OCT2013 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ± | | NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150387 RESTRICTED TO: | SCALE: 1:1 SHEET: 2 of 4 REV: A1 |
| MATERIAL: | | WEIGHT: Customer Accessible Production Drawing | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
|--|-------------|----------|--------------------------|--------------------------------|-------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| | 2-2150387-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150387-5 | - | - | 2168400-7 (QUANTITY 2) |
| | 2-2150387-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | SMART APPLICATOR | 2161326-1 | - | 8-2150387-4 | - | - | - |
| | 2-2150387-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-2 | - | 2063440-2 |
| | 7-2150387-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm [1.10] | F |
| INSUL | 3.94 mm [1.55] | OV |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: G&H TERMINAL | | LEAR CRIMP SPECIFICATION | |
|---|-----------------|------------------------------|---------------|
| TERMINAL NAME: FLACHSTECKER 6.3 X 0.8 - 2.5 | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.20-5.80 mm [1.205-.228 IN] | | 1.50-2.50 mm [1.059-.098 IN] | |
| TERMINAL APPLICATION SPECIFICATION | LEAR SPEC Rev 3 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | G&H TERMINAL | TE TERMINAL | G&H TERMINAL |
| 1949284-1 | 26513.201.179 | 1949284-2 | 26513.213.009 |
| 1949284-3 | 26513.126.009 | | |

| WIRE SIZE | CRIMP HEIGHT mm [IN] | CRIMP HEIGHT REFERENCE SETTING |
|--------------|--------------------------------|--------------------------------|
| 2.50mm2 | 1.90 +/- 0.05 [1.075 +/- .002] | 6.4 |
| 1.50+0.50mm2 | 1.75 +/- 0.05 [1.069 +/- .002] | 8.1 |
| 1.00+0.75mm2 | 1.70 +/- 0.05 [1.063 +/- .002] | 8.7 |
| 1.50mm2 | 1.60 +/- 0.05 [1.063 +/- .002] | 9.7 |

- 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: 8-2150387-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150387-5
- 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 ITEMS 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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 PITCH NOT COMPATIBLE WITH 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.

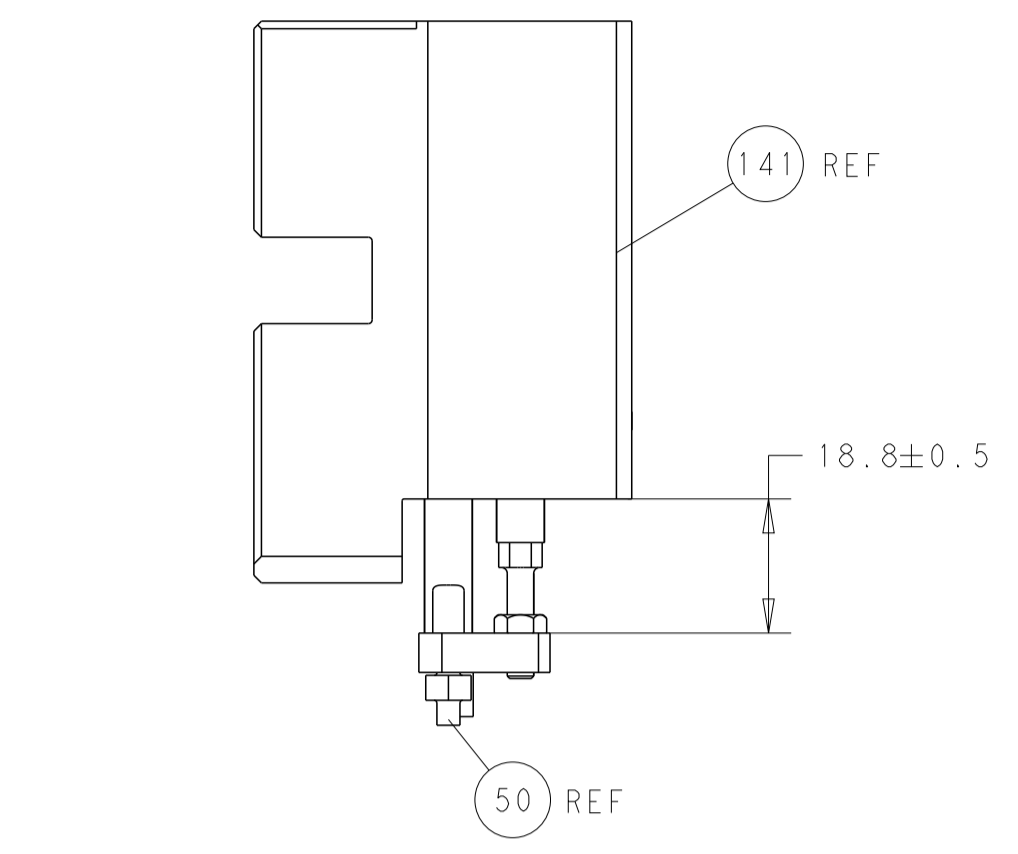
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-2 | A | 66 | REV | DATE | BY | APPD |
| | | | - | SEE SHEET 1 | - | - |

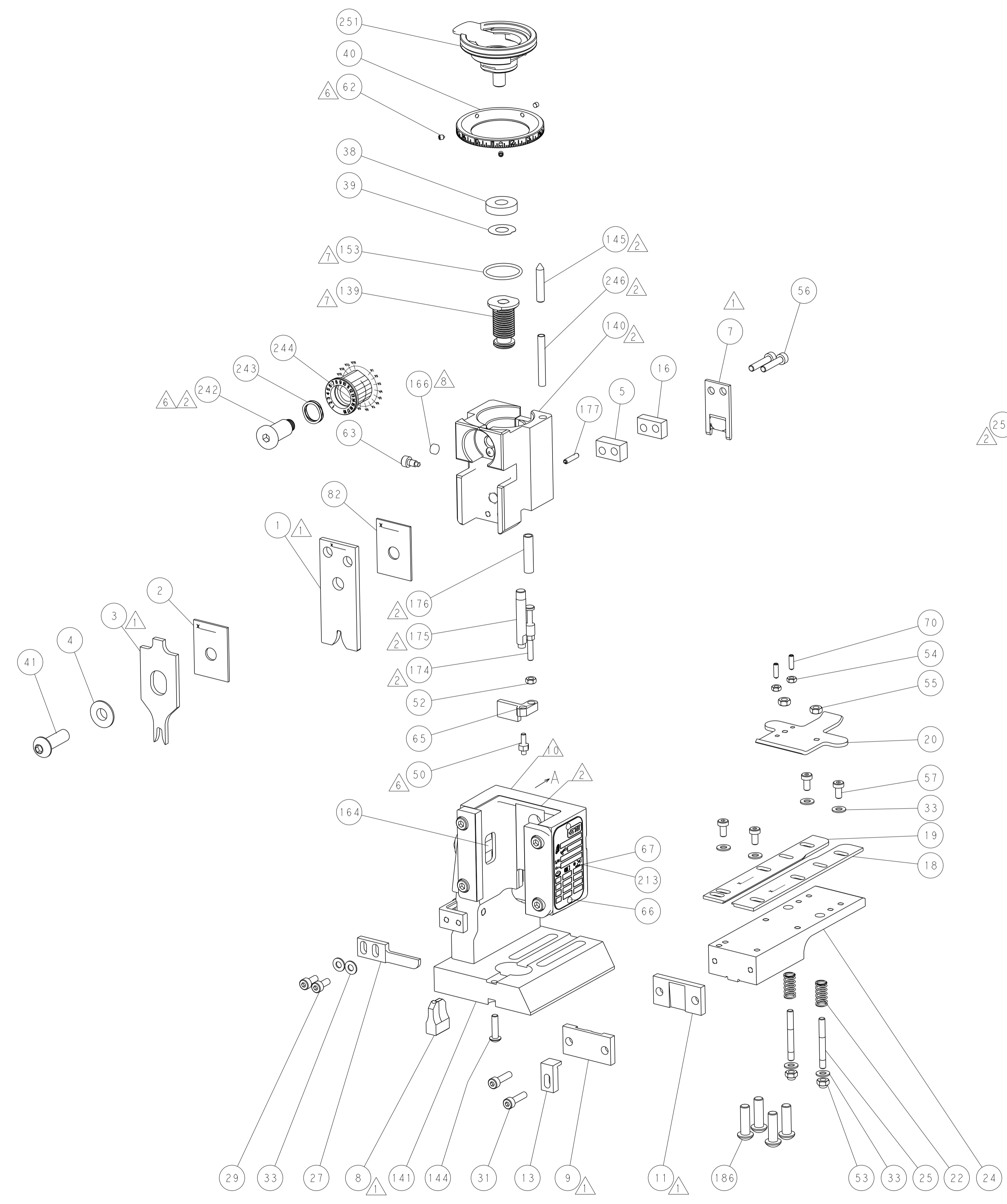
| | | | | | | |
|---|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | 1 | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | 1 | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| - | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 2119082-7 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 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 | 2063440-2 | AIR FEED MODULE | 238 |
| - | - | 1 | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | 4 | 4 | 4 | 2079383-9 | SCR, BHSC, RoHS (M6 X 20) | 186 |
| - | - | REF | - | 1901697-1 | FEED FINGER ASSEMBLY, EF | 183 |
| - | 1 | 1 | 1 | 6-993111-6 | 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 | 1 | 1 | 8-21084-1 | O-RING, .801 ID, .070 DIA. MAT. | 153 |
| - | - | - | 1 | 2119641-2 | FEED CAM, AIR FEED | 152 |
| - | 1 | 1 | 1 | 2119798-2 | DETENT PIN | 145 |
| - | 1 | 1 | 1 | 2079383-8 | SCR, BHSC, RoHS (M4 X 16) | 144 |
| - | 1 | 1 | 1 | 2119655-6 | APPLICATOR BASIC ASSEMBLY, EF | 141 |
| - | 1 | 1 | 1 | 2119651-1 | RAM, ASIAN STYLE, END FEED | 140 |
| - | 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 | 1-455888-0 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 2119956-2 | DOCUMENTATION PACKAGE | 71 |
| - | 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 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 1 | 1 | 1976052-1 | HOLDDOWN, TERMINAL | 65 |
| - | 1 | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| - | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE PNT, M3 x 4.0 | 62 |
| - | 4 | 4 | 4 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 |
| - | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 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 | 1-1976055-1 | STANDOFF, HOLD-DOWN | 50 |
| - | - | - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 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 | 2119644-2 | RAM WASHER, PRECISION | 38 |
| - | 8 | 8 | 8 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 |
| - | 2 | 2 | 2 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 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 |
| - | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1 | 1 | 1752373-4 | DRAG | 20 |
| - | 1 | 1 | 1 | 1901696-3 | STRIP GUIDE, REAR | 19 |
| - | 1 | 1 | 1 | 1901695-3 | STRIP GUIDE, FRONT | 18 |
| - | 1 | 1 | 1 | 2-240641-5 | SPACER | 16 |
| - | 1 | 1 | 1 | 1752360-1 | SPACER, HOLD-DOWN | 13 |
| - | 1 | 1 | 1 | 240644-9 | PLATE, REAR SHEAR | 11 |
| - | 1 | 1 | 1 | 5-690482-9 | PLATE, FRONT SHEAR | 9 |
| - | 1 | 1 | 1 | 3-1803001-2 | ANVIL, COMBINATION, END FEED | 8 |
| - | 1 | 1 | 1 | 1-2217206-4 | BLADE, SLUG | 7 |
| - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 7-240641-2 | SPACER | 5 |
| - | 1 | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1-2119785-6 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 1 | 1 | 1-455888-2 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 2-1633305-3 | CRIMPER, WIRE PREMIUM | 1 |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG | | REV | |
|-------------|---------|--|----------|------------------|-----------|-----|-----------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | Y. YIN | 16OCT2013 | 1 | 16OCT2013 |
| | 3 PLC ± | 4 PLC ± | ANGLES ± | G. BAILEY | 16OCT2013 | 2 | |
| | FINISH | | | U. GUO | 16OCT2013 | 3 | |
| MATERIAL | | | | APVD | | | |
| | | | | PRODUCT SPEC | | | |
| | | | | APPLICATION SPEC | | | |
| | | | | WEIGHT | | | |
| | | | | SIZE | | | |
| | | | | CAGE CODE | | | |
| | | | | DRAWING NO | | | |
| | | | | RESTRICTED TO | | | |
| | | | | SCALE | | | |
| | | | | SHEET | | | |
| | | | | OF | | | |
| | | | | REV | | | |

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

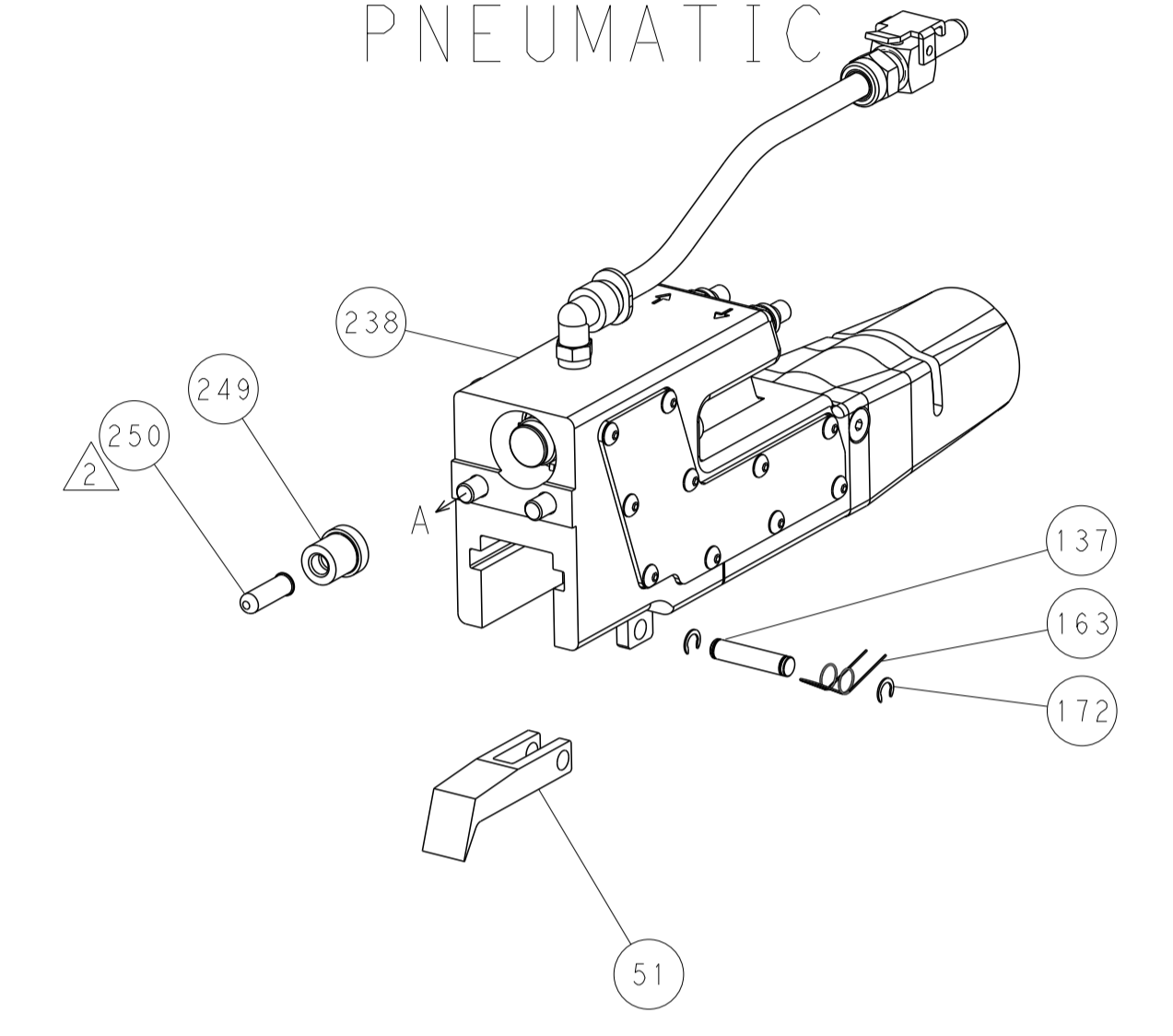


HOLDDOWN SET-UP

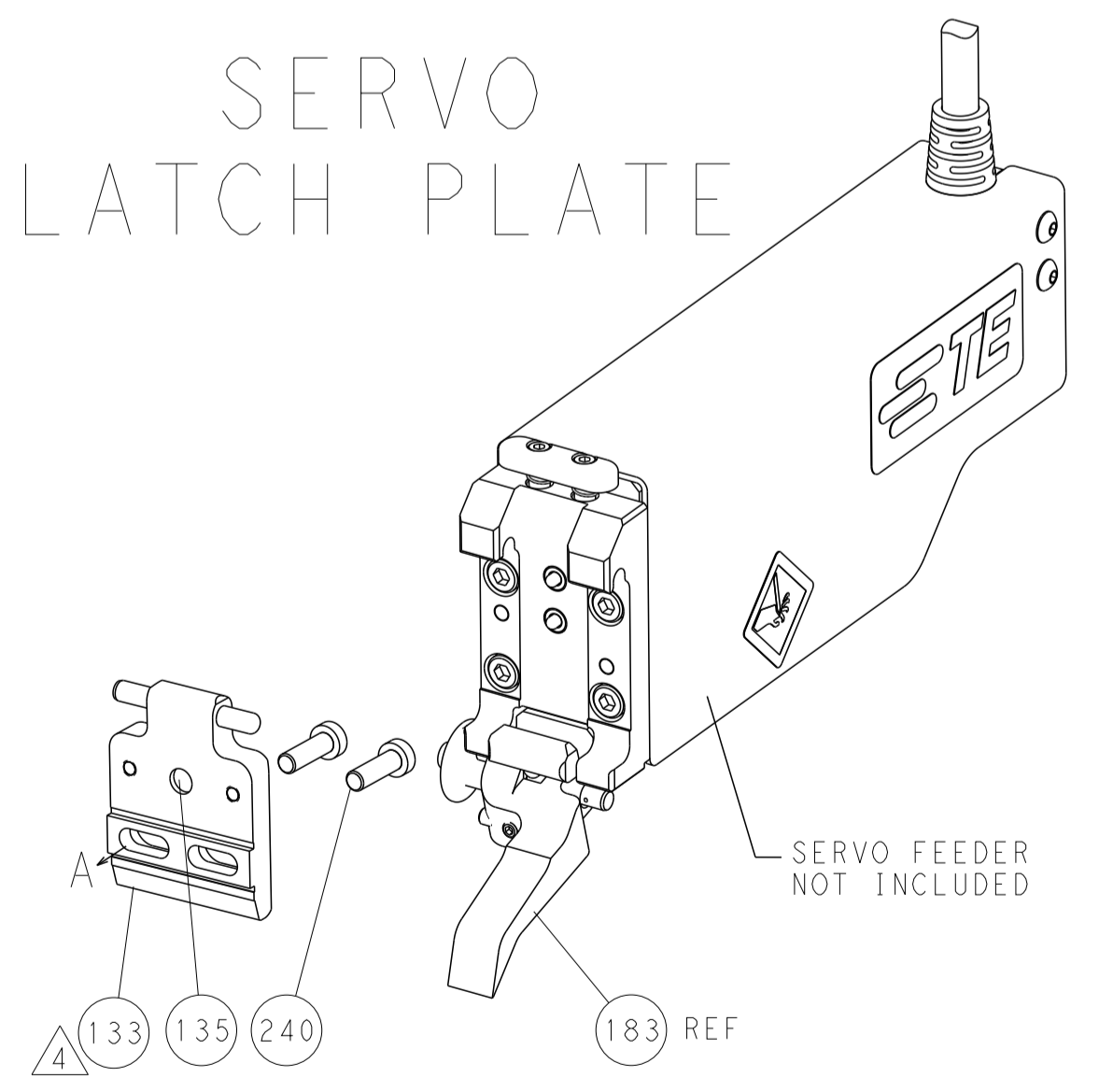


FEED TYPE

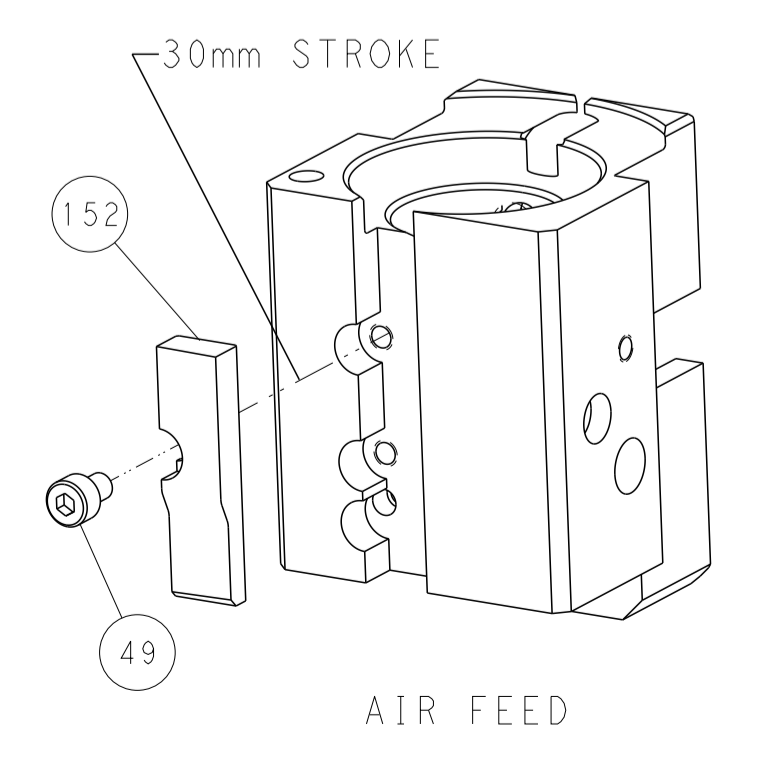
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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 Y. YIN 16OCT2013 | | STE TE Connectivity Harrisburg, PA 17105-3608 | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | NAME | Customer Accessible Production Drawing |
| | ANGLES | FINISH | | APVD G. BAILEY 16OCT2013 | U. GUO 16OCT2013 | PRODUCT SPEC | SCALE 1:1 |
| MATERIAL | | | | APVD U. GUO 16OCT2013 | PRODUCT SPEC | APPLICATION SPEC | SHEET 4 OF 4 |
| | | | | WEIGHT | A1 00779 | ©=2150387 | REV A1 |