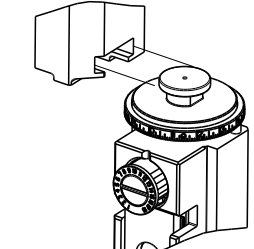
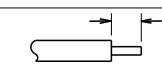

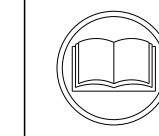


8	7	6	5	4	3	2	1			
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	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2150335-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1-1338683-0	5-18022-5	2119653-1	-
2150335-7	E	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]		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
18 AWG	1.45 +/- 0.05 [.057 +/- .002]	8.8
20 AWG	1.35 +/- 0.05 [.053 +/- .002]	10.1



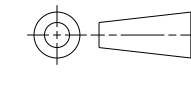
- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
- 3 LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150335-4
- 5 ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 50.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10 TERMINAL DESIGN IS NOT COMPATIBLE WITH SERVO FEED OR MECHANICAL FEED.

**\*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.

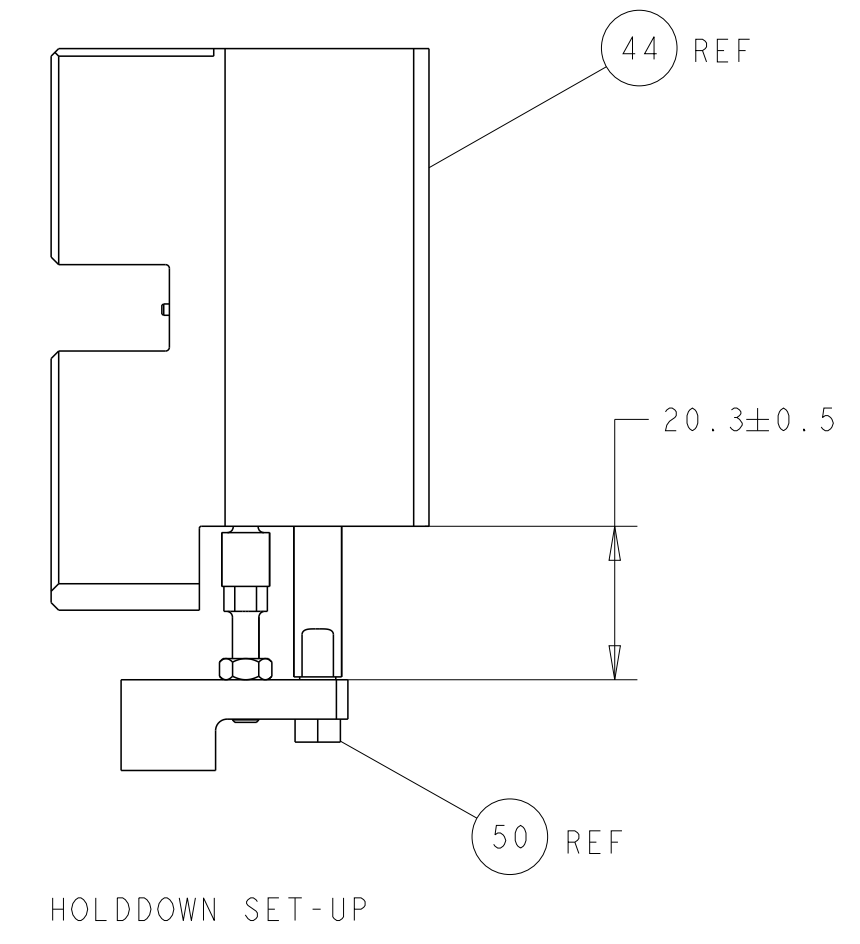
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS					
			P	LTN	DESCRIPTION	DATE	OWN	APVD
			C		ECR-15-001396	14SEP2015	YY	UG
			D		ECR-16-015133	26OCT2016	TB	GB
			E		ECR-17-012693	30AUG2017	TB	GB

7	-	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	
6	-	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	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	
6	-	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 X 4.0	62	
	-	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60	
	-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	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	
6	-	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	
6	-	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
7	-	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	1	461160-3	PLATE, REAR SHEAR	11	
	-	2	2	8-240645-6	SPACER, SHEAR PLATE	10	
1	-	1	1	455961-5	PLATE, FRONT SHEAR	9	
1	1	1	1	6-1803059-2	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1803186-1	BLADE, SLUG	7	
	-	-	-	-	-	6	
	-	-	-	-	-	5	
	-	1	1	3-238009-1	BLOCK, FL CRIMPER SPACER	4	
1	1	1	1	1803108-5	CRIMPER, INSULATION O	3	
	-	1	1	455888-6	SPACER, CRIMPER	2	
1	1	1	1	1-1803015-4	CRIMPER, WIRE	1	
	-	77	-7	-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)

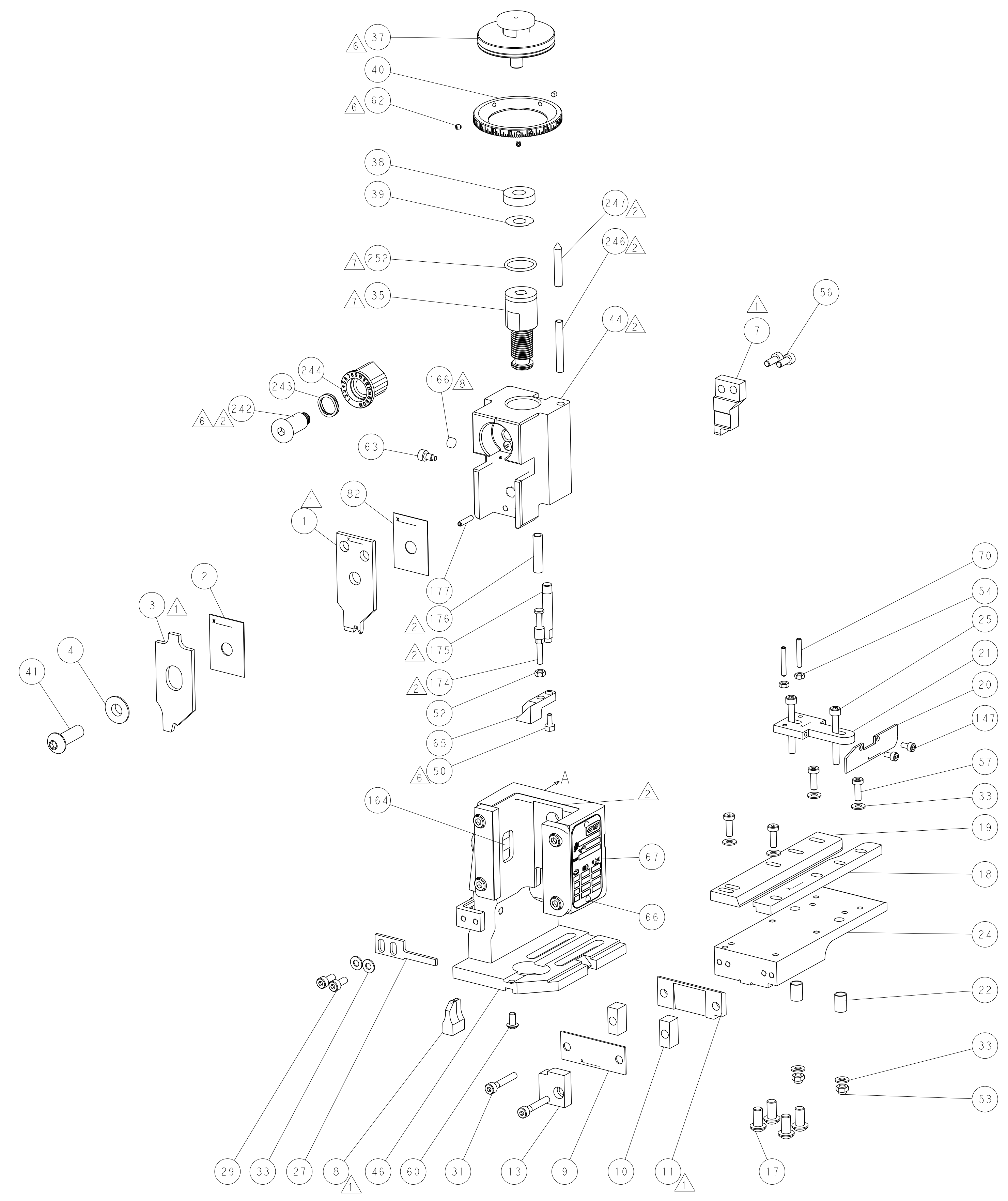
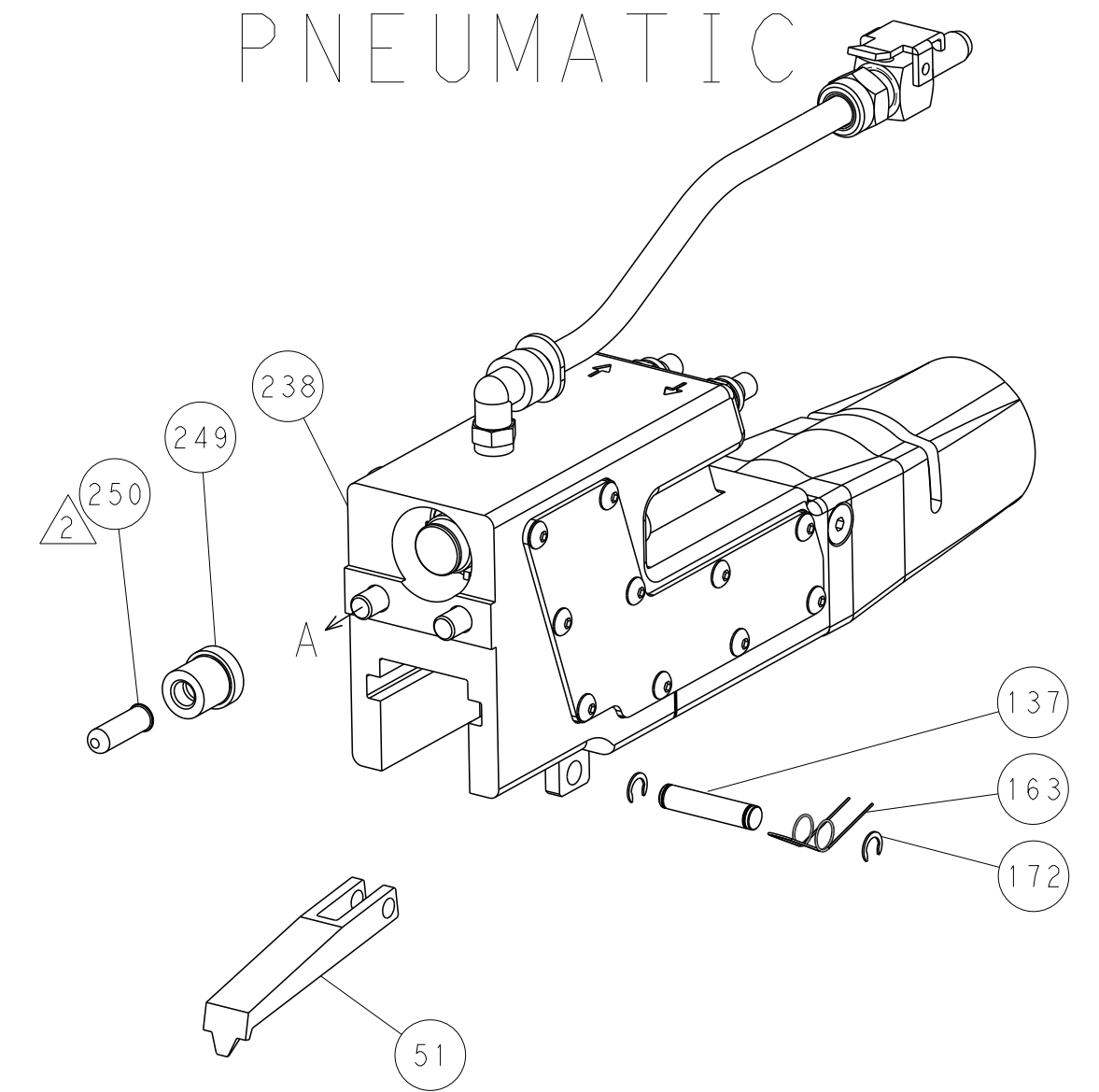
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	ANGLES	FINISH	OTHERWISE SPECIFIED:	APVD M. CLIFFORD 29MAY2013	PRODUCT SPEC	APPLICATION SPEC	SIZE A1
MATERIAL				WEIGHT		CAGE CODE 00779	DRAWING NO C=2150335
				Customer Accessible Production Drawing		SCALE 1:1	SHEET 1 of 4

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

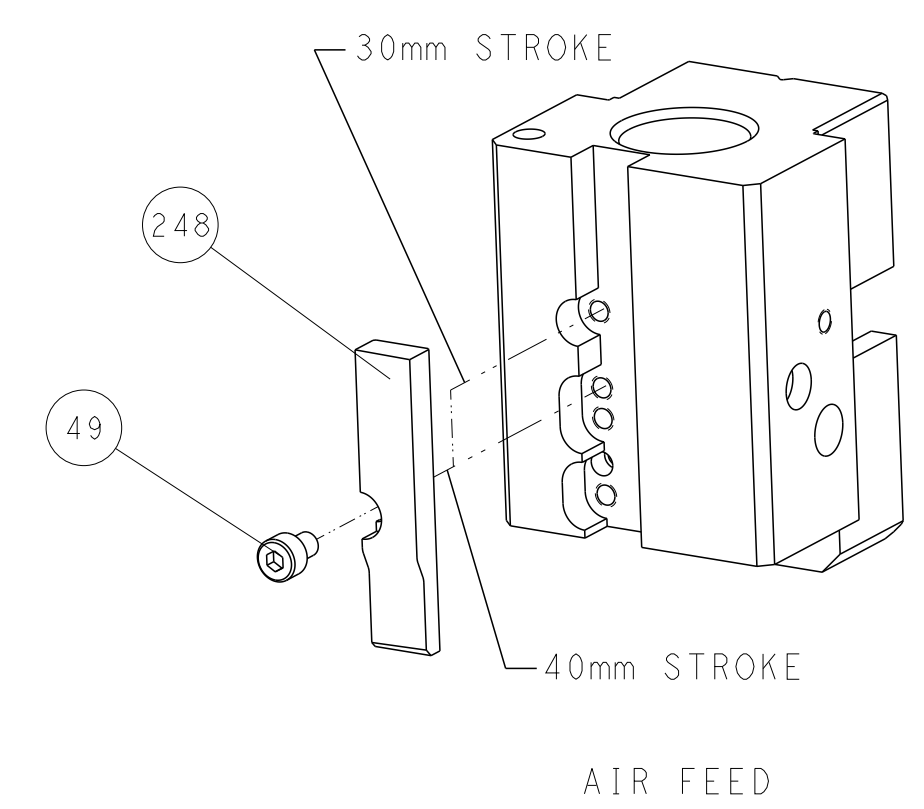


FEED TYPE

PNEUMATIC

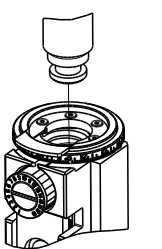



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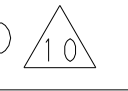


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)


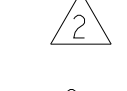

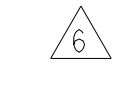

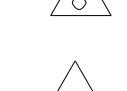
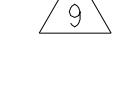
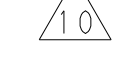
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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150335 WEIGHT:	RESTRICTED TO: SCALE: 1:1 SHEET: 2 OF 4 REV: E
MATERIAL:		Customer Accessible Production Drawing	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150335-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1-1338683-0	5-18022-5	2119653-2	-	-
	2-2150335-7	E	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 ]		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
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.

**\*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.

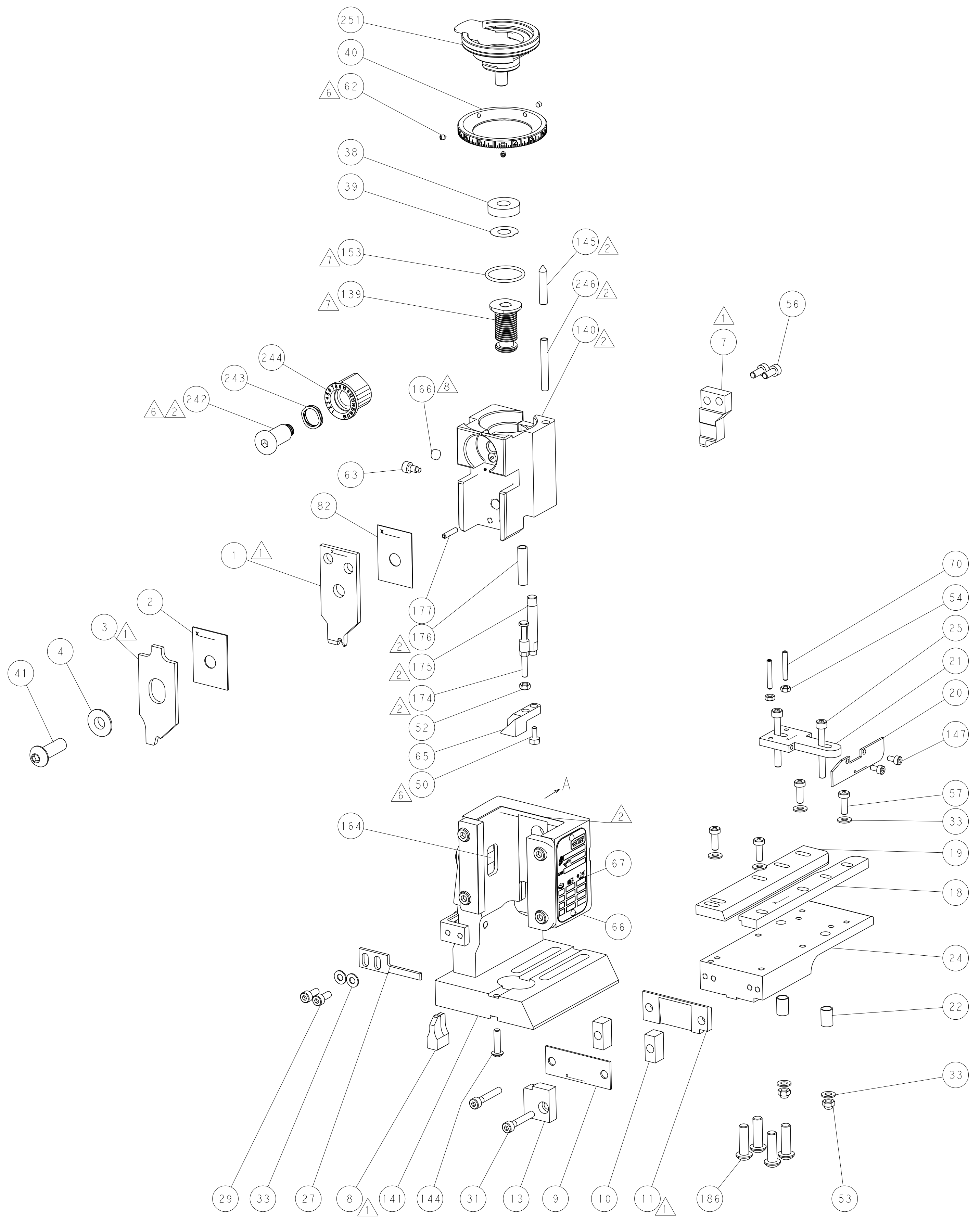
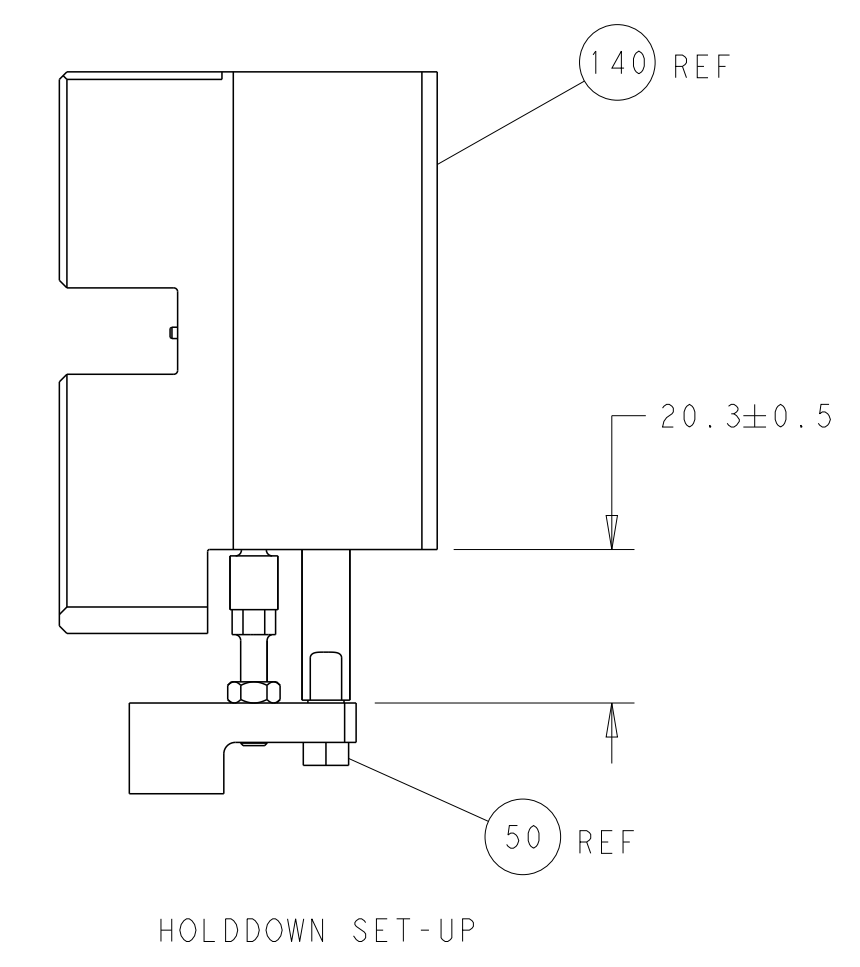
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

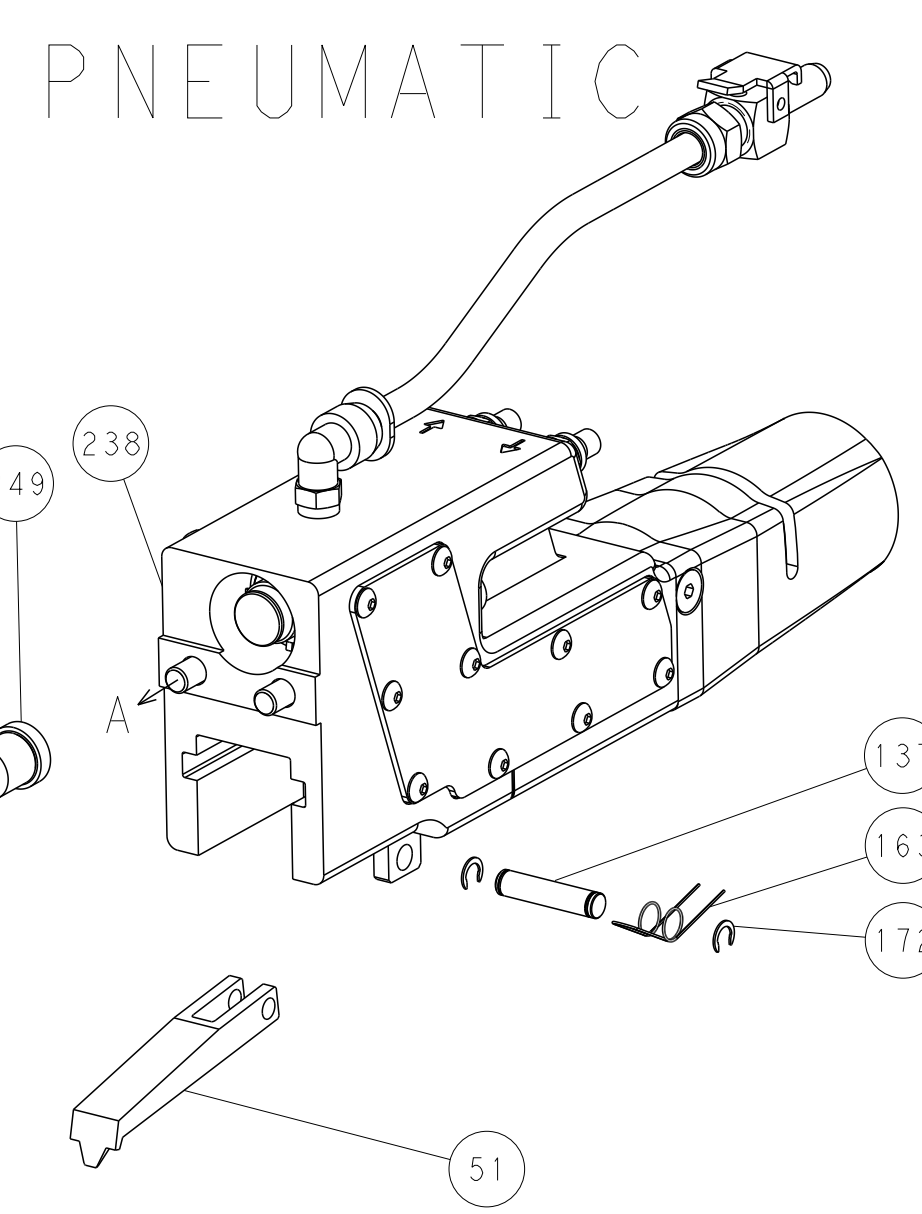
-	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	1	1803259-1	BUSHING, FLANGED	249
-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, 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	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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 PNT, M3 x 4.0	62
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	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	

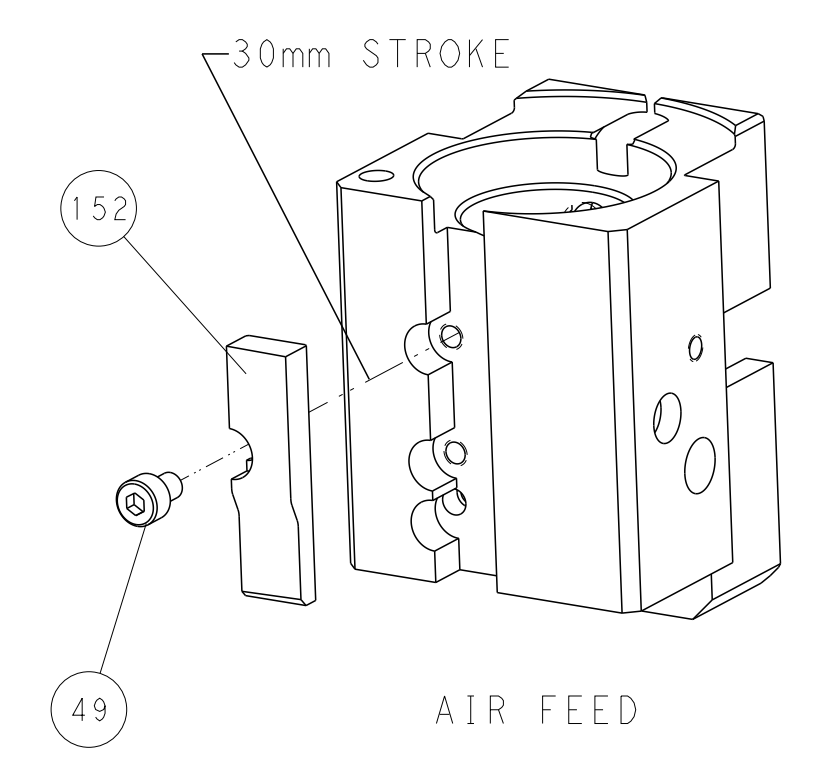
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			



FEED TYPE



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