

Atlantic Version Terminator Interface Adapter table with columns: Part Number, Revision, Description, Feed Type, Convert To, Part Numbers Required.

Applicator Data table with columns: Crimp, Size, Type, Wire, Insul.

Terminal Data and Terminals Applied table with columns: TE Terminal, TE Crimp Specification, Wire Strip Length, Insulation Diameter Range.

Wiring and Crimp Height Reference table with columns: Wire Size, Crimp Height, Crimp Height Reference Setting.

- 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.

\*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.

Parts list table with columns: Item No, Part No, Description, Item No.

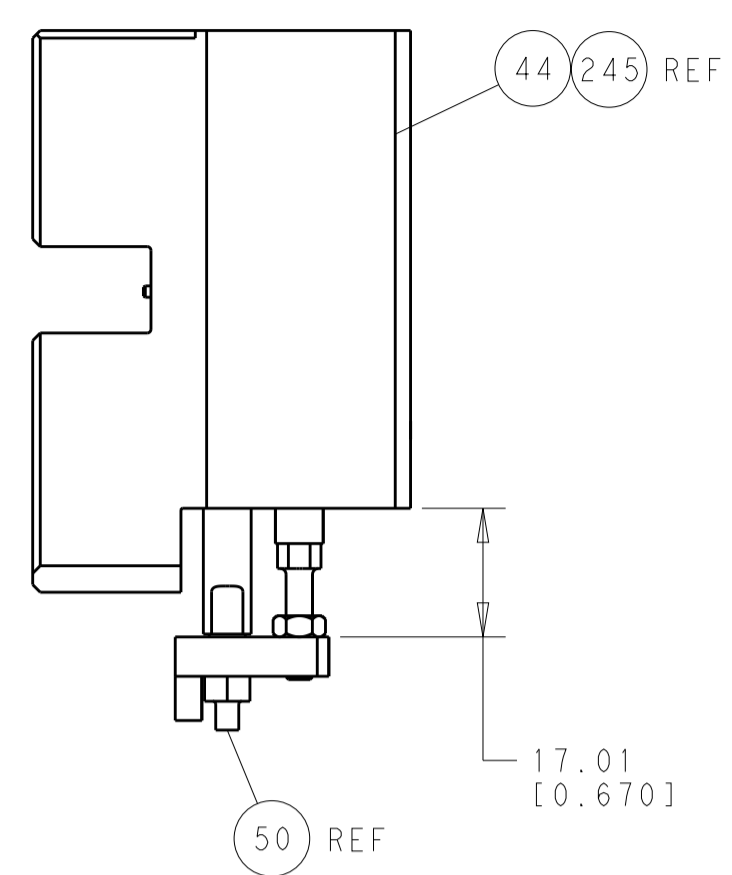
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE, LOC A, DIST 66, REVISIONS table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD.

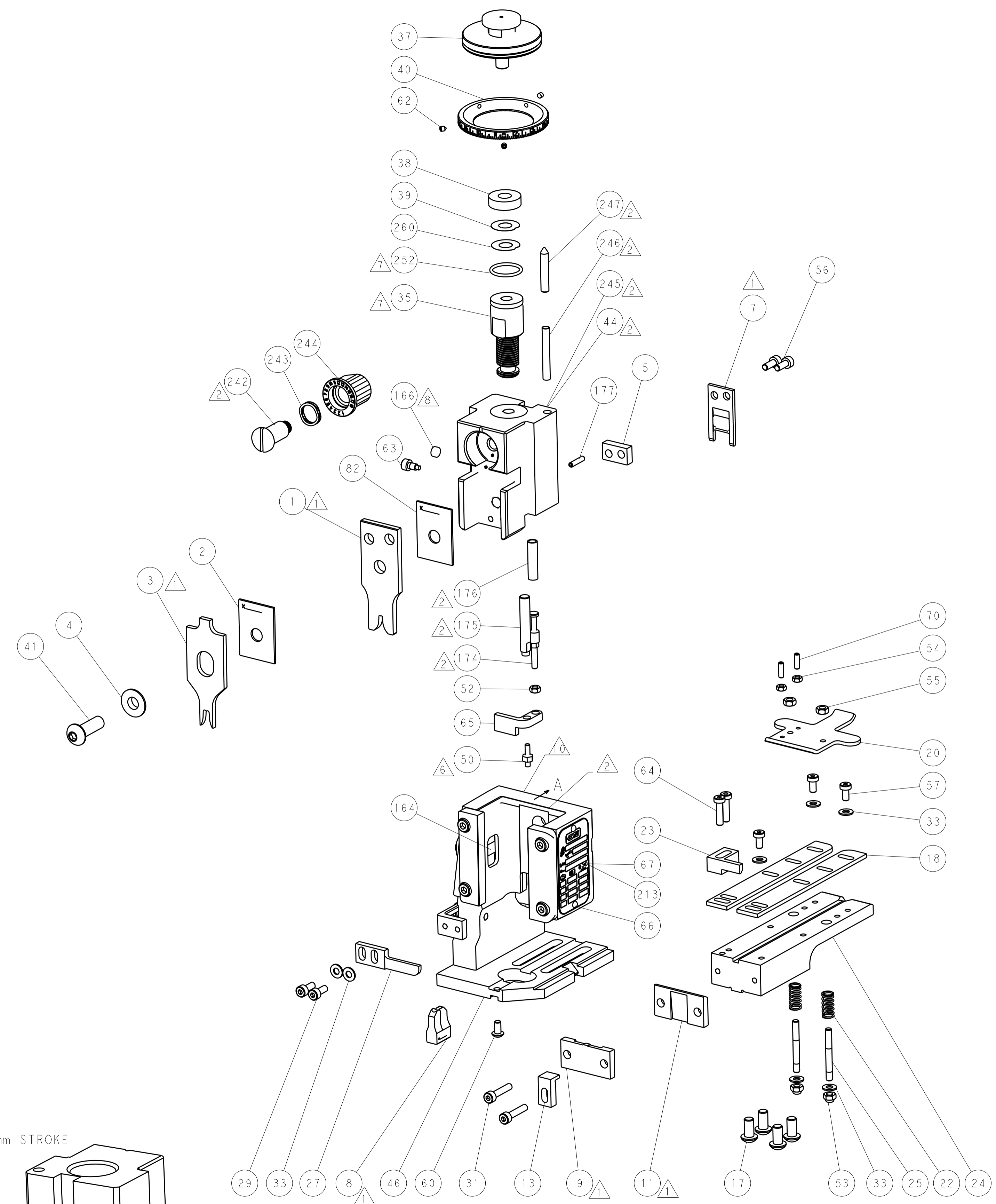
Main parts list table with columns: Item No, Part No, Description, Item No.

Technical drawing header including dimensions, tolerances, material, finish, and drawing information.

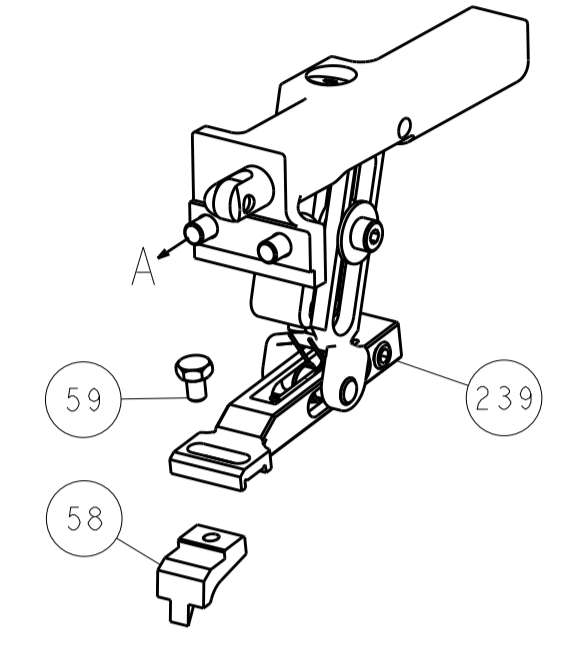
| LOC |    | DIST |     | REVISONS    |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTN | DESCRIPTION | DATE | OWN | APVD |
| -   | -  | -    | -   | SEE SHEET 1 | -    | -   | -    |



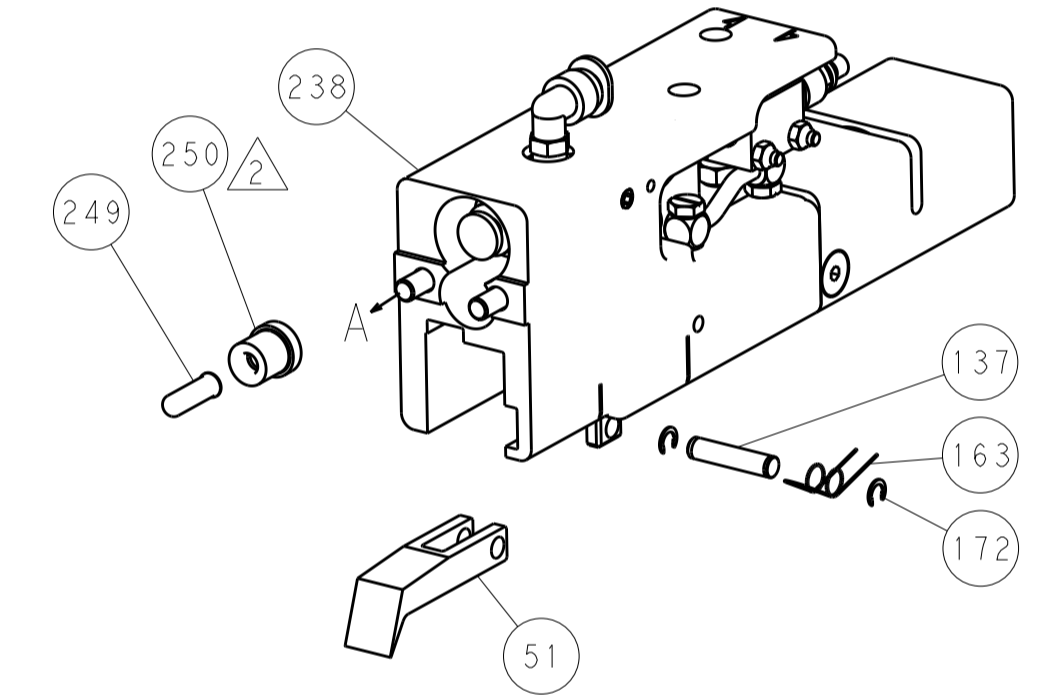
HOLDDOWN SET-UP



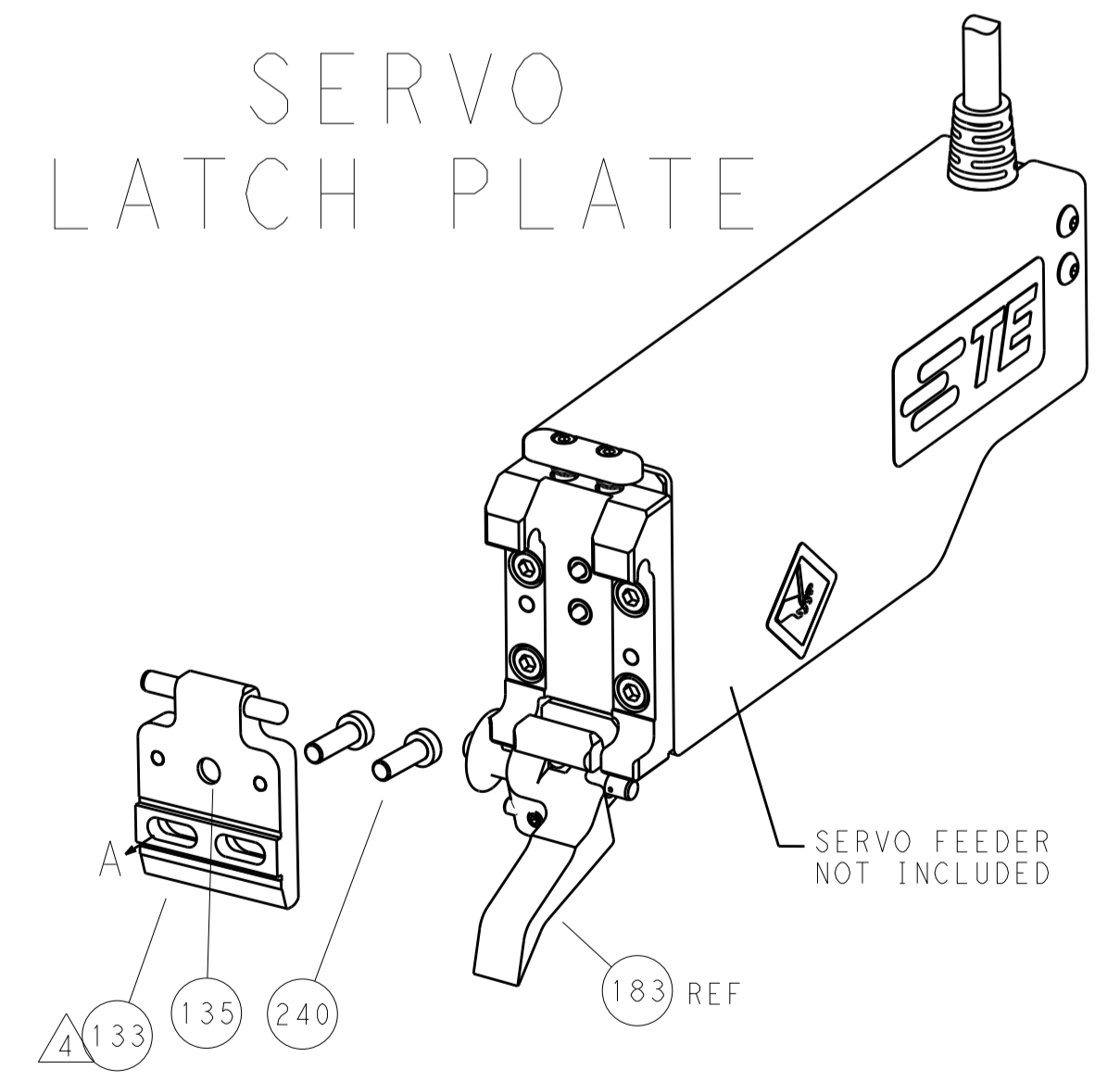
FEED TYPE  
MECHANICAL



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: B. WEAVER 22NOV2011               |              | TE Connectivity                |   |
| mm                                     | 0 PLC ±0.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.13                            | 4 PLC ±0.001 | APVD: T. ELBIN 22NOV2011       | TE Connectivity Harrisburg, PA 17105-3608 |
| MATERIAL:                              |            | FINISH:                                |             | NAME: Ocean End Feed Applicator        |              | RESTRICTED TO:                 |   |
|  |            |  |             | SIZE: A1 00779 C=2150238               |              | SCALE: 1:1 SHEET 2 OF 4 REV A1 |   |
| Customer Accessible Production Drawing |            |  |             | Customer Accessible Production Drawing |              |                                |   |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |   |                        |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
|  |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |   |                        |
|  | 2-2150238-1 | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED                    | 2119950-1             | 2119792-1 | -           | 2119641-2 | - | 2063440-1              |
|  |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150238-5 | -         | - | 2168400-7 (QUANTITY 2) |
|  | 2-2150238-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-2 | - | -                      |
|  |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150238-5 | -         | - | 2168400-7 (QUANTITY 2) |
|  | 2-2150238-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED                   | 2119949-1             | 2063961-1 | 5-18022-5   | 2119653-2 | - | -                      |
|  |             |          |                          |                   | PNEUMATIC FEED                    | 2119950-1             | 2119792-1 | -           | 2119641-2 | - | 2063440-1              |
|  | 2-2150238-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | - | -                      |
|  | 7-2150238-7 | A        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -         | -           | -         | - | -                      |

| APPLICATOR DATA                |                |      |
|--------------------------------|----------------|------|
| CRIMP                          | SIZE           | TYPE |
| WIRE                           | 2.79 mm [.110] | F    |
| INSUL                          | 4.57 mm [.180] | F    |
| APPL INSTRUCTIONS<br>408-10390 |                |      |

| TERMINAL DATA: TE TERMINAL                           |             | TE CRIMP SPEC  |             |
|--|-------------|--|-------------|
| TERMINAL NAME: RECEPTACLE, FASTIN-FASTON .250 SERIES |             |  |             |
| WIRE STRIP LENGTH<br>5.41-6.07 mm [.213-.239 IN]     |             | INSULATION DIAMETER RANGE<br>Ø2.54-4.32 mm [1.100-.170 IN] |             |
| TERMINAL APPLICATION SPECIFICATION<br>               | 114-2025    | -  |             |
| TERMINALS APPLIED                                    |             |  |             |
| TE TERMINAL  | TE TERMINAL | TE TERMINAL  | TE TERMINAL |
| 42100-1  | 2-42100-1   | 140808-3   | 150603-2    |
| 42100-2  | 2-42100-2   | 1-140808-1   | 150604-2    |
| 42100-3  | 140808-1    | 1-140808-2   | 152314-1    |
| 42100-9  | 140808-2    | 150603-1   | 170092-2    |
|  |             |  | 170092-4    |

| WIRE SIZE                    | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|------------------------------|-------------------------------|--------------------------------|
| 14AWG or 2.5mm <sup>2</sup>  | 1.60 +/- 0.05 [.063 +/- .002] | 2.1                            |
| 2.0mm <sup>2</sup>           | 1.57 +/- 0.05 [.062 +/- .002] | 2.3                            |
| 1.5mm <sup>2</sup>           | 1.42 +/- 0.05 [.056 +/- .002] | 3.7                            |
| 16AWG or 1.0mm <sup>2</sup>  | 1.37 +/- 0.05 [.054 +/- .002] | 4.3                            |
| 18AWG or 0.75mm <sup>2</sup> | 1.22 +/- 0.05 [.048 +/- .002] | 6.1                            |

- 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150238-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150238-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150238-5
- 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 & 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.

**\*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 | 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 | 1-22279-3 | SPRING, COMPRESSION                 | 246     |
| -77-27-25-22-21 |   |   |   |   | PART NO   | DESCRIPTION                         | ITEM NO |

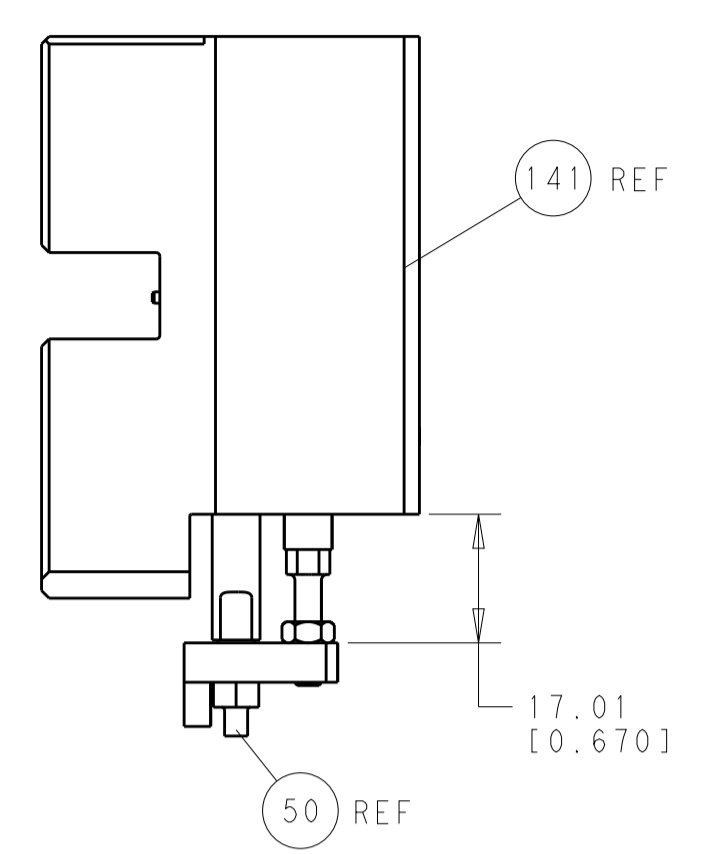
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

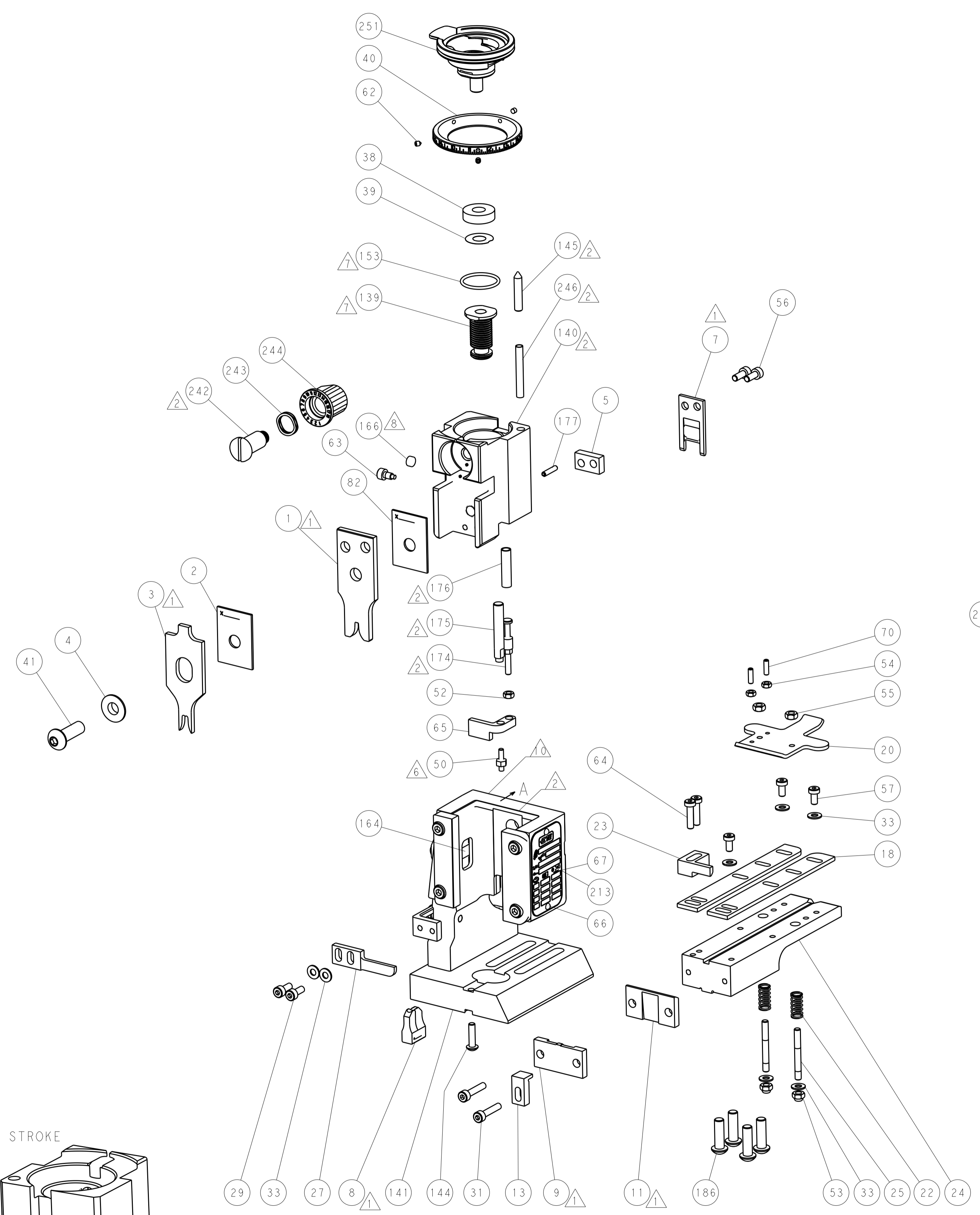
|                 |     |     |     |     |             |                                     |         |
|-----------------|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -               | 1   | 1   | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 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   | -   | -   | 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   | 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 | REF | REF | REF | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135     |
| -               | -   | 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 POINT 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   | 2168400-8   | SHCS, LOW HEAD, RoHS, M4 X 16       | 64      |
| -               | 1   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| -               | 3   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, 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   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 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   | 1-1976055-3 | 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   | 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   | 2119644-1   | 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   | 1320906-1   | STUD, THREADED                      | 25      |
| -               | 1   | 1   | 1   | 1   | 1752371-6   | PLATE, STRIP GUIDE                  | 24      |
| -               | 1   | 1   | 1   | 1   | 240825-2    | PLATE, STRIP HOLD DOWN              | 23      |
| -               | 2   | 2   | 2   | 2   | 2-22281-3   | SPRING, COMPRESSION                 | 22      |
| -               | 1   | 1   | 1   | 1   | 1752373-1   | 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   | 240833-2    | PLATE, REAR SHEAR                   | 11      |
| -               | 1   | 1   | 1   | 1   | 690495-4    | PLATE, FRONT SHEAR                  | 9       |
| -               | 1   | 1   | 1   | 1   | 1333219-3   | ANVIL, COMBINATION                  | 8       |
| -               | 1   | 1   | 1   | 1   | 690474-3    | BLADE, SLUG                         | 7       |
| -               | 1   | 1   | 1   | 1   | 3-240641-5  | SPACER                              | 5       |
| -               | 1   | 1   | 1   | 1   | 238009-1    | BLOCK, FL CRIMPER SPACER            | 4       |
| -               | 1   | 1   | 1   | 1   | 2119582-3   | CRIMPER, INSULATION F PREMIUM       | 3       |
| -               | 1   | 1   | 1   | 1   | 1-455888-1  | SPACER, CRIMPER                     | 2       |
| -               | 1   | 1   | 1   | 1   | 1-456408-8  | CRIMPER, WIRE PREMIUM               | 1       |
| -77-27-25-22-21 |     |     |     |     | PART NO     | DESCRIPTION                         | ITEM NO |

| DIMENSIONS:                            |           | TOLERANCES UNLESS OTHERWISE SPECIFIED: |            | DWG                           |              | REV           |        |
|--|-----------|--|------------|-------------------------------|--------------|---------------|--------|
| mm                                     | 0 PLC ±.5 | 1 PLC ±.3                              | 2 PLC ±.13 | 3 PLC ±.013                   | 4 PLC ±.0001 | ANGLES ±.0001 | FINISH |
| MATERIAL:                              |           |  |            | FINISH:                       |              |               |        |
| WEIGHT:                                |           |  |            | SCALE:                        |              |               |        |
| Customer Accessible Production Drawing |           |  |            | SCALE 1:1 SHEET 3 OF 4 REV A1 |              |               |        |

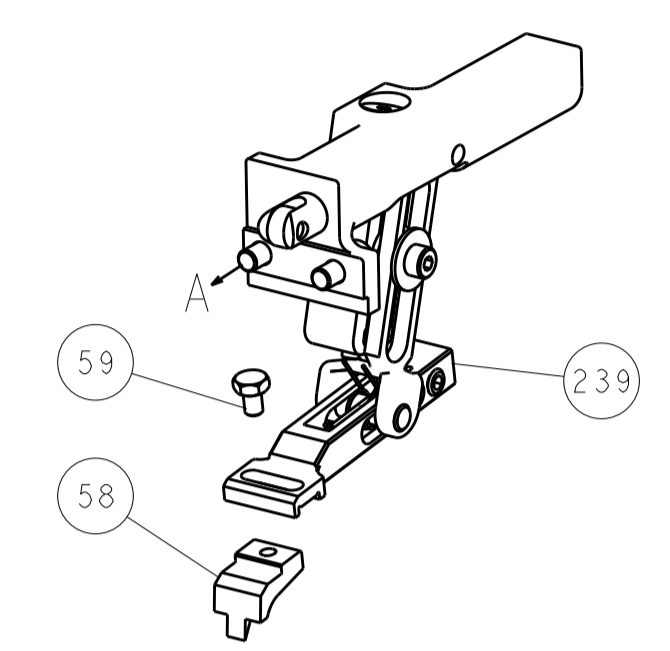
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | OWN | APVD |
|     |    |      |     | SEE SHEET 1 |      |     |      |



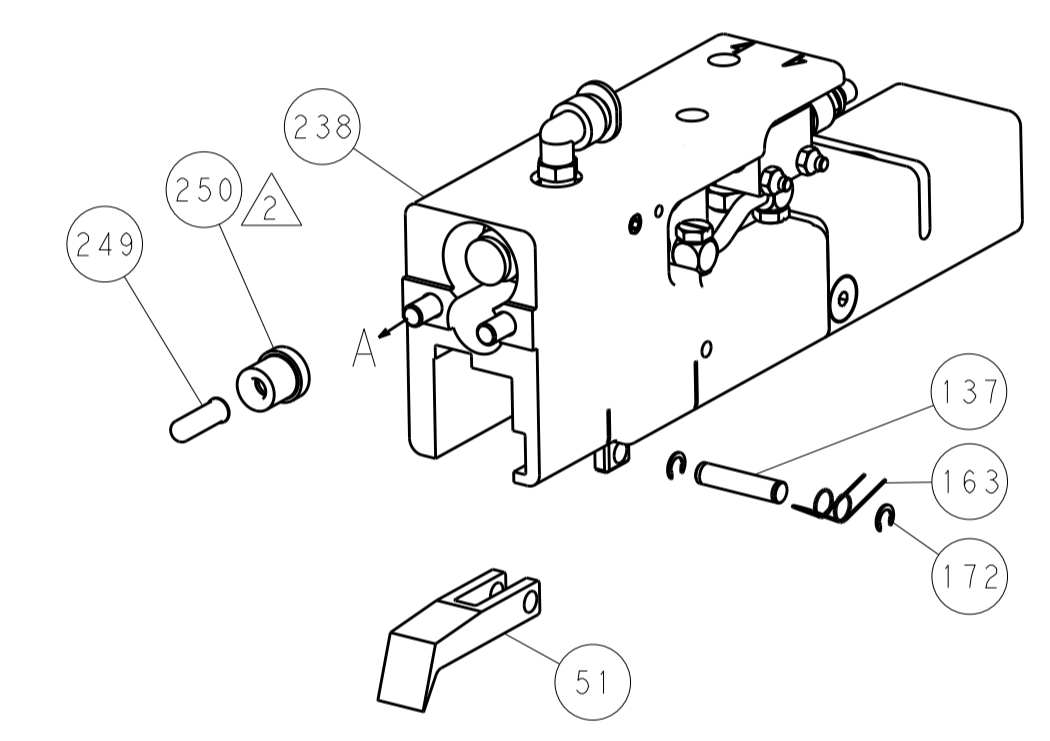
HOLDDOWN SET-UP



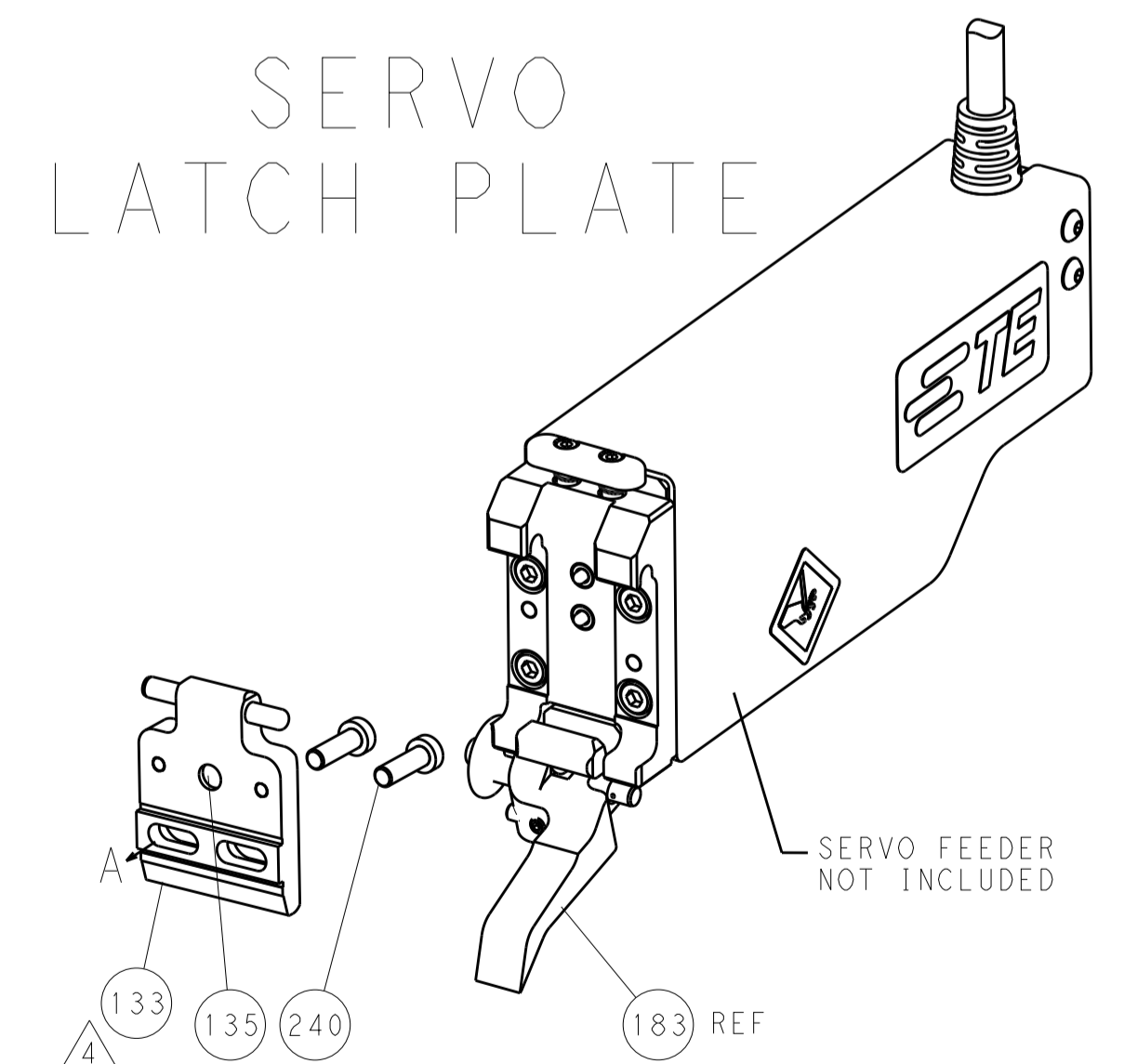
FEED TYPE  
MECHANICAL



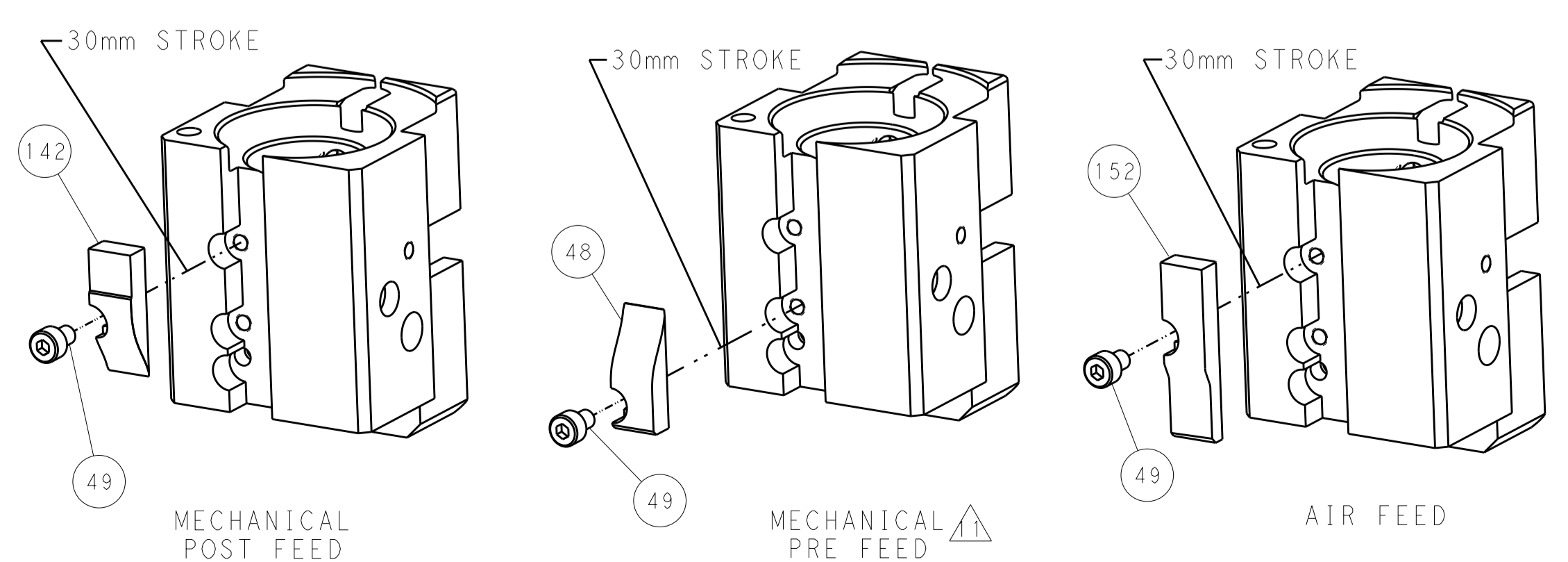
PNEUMATIC



SERVO  
LATCH PLATE



CAM POSITIONS



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 B. WEAVER 22NOV2011 |                         | STE TE Connectivity         |                |
| mm                                     | 0 PLC ±0.5   | 1 PLC ±0.5                             | 2 PLC ±0.13  | 3 PLC ±0.13             | CHK G. HOFNER 22NOV2011 | Harrisburg, PA 17105-3608   |                |
|  | 4 PLC ±0.013 | 5 PLC ±0.001                           | 6 PLC ±0.001 | 7 PLC ±0.001            | APVD T. ELBIN 22NOV2011 | NAME Ocean End Feed Applier |                |
| MATERIAL:                              | FINISH:      | WEIGHT:                                | SCALE:       | SIZE:                   | CAGE CODE:              | DRAWING NO:                 | RESTRICTED TO: |
|  |              |  | 1:1          | A1                      | 00779                   | 2150238                     |                |
| Customer Accessible Production Drawing |              |  |              | SHEET 4 OF 4 REV A1     |                         |                             |                |