

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |   |                        |
|---|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
|   |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |   |                        |
|   | 2150870-2   | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | -                                 | -                     | -         | -           | -         | - |                        |
|   | 2150870-5   | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150870-5 | -         | - | 2168400-7 (QUANTITY 2) |
|   |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150870-4 | -         | - | -                      |
|   | 2150870-6   | A        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | PNEUMATIC FEED                    | 2119950-1             | 2119792-2 | -           | 2119641-1 | - | 2063440-2              |
|   |             |          |                          |                   | -                                 | -                     | -         | -           | -         | - | -                      |
|   | 2150870-7   | A        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | - | -                      |
|   | 7-2150870-7 | A        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -         | -           | -         | - | -                      |

| APPLICATOR DATA             |                  |      |
|-----------------------------|------------------|------|
| CRIMP                       | SIZE             | TYPE |
| WIRE                        | 4.57 mm [ .180 ] | F    |
| APPL INSTRUCTIONS 408-10390 |                  |      |

| TERMINAL DATA; KET BORGWARNER TERMINAL Borg Warner International CRIMP SPECIFICATION |   |                           |                         |
|--|---|---------------------------|-------------------------|
| TERMINAL NAME: 6.4 RING TERMINAL   |   |                           |                         |
| WIRE STRIP LENGTH  |   | INSULATION DIAMETER RANGE |                         |
| 6.70-7.10 mm [ .264-.280 IN ]  |   | Ø                         |                         |
| TERMINAL APPLICATION SPECIFICATION   | BorgWarner Tooling Spec PG 6-8 Rev 12/07/17 |                           |                         |
| TERMINALS APPLIED  |   |                           |                         |
| TE TERMINAL  | KET BORGWARNER TERMINAL                     | TE TERMINAL               | KET BORGWARNER TERMINAL |
| -  | -   | 3311041-2                 | 1987060                 |

| WIRE SIZE      | CRIMP HEIGHT mm [INCH]          | CRIMP HEIGHT REFERENCE SETTING |
|----------------|---------------------------------|--------------------------------|
| 2 x 12-3/4 MAG | 2.92 +/- 0.05 [ .115 +/- .002 ] | 5.0                            |
| 2 x 13 MAG     | 2.79 +/- 0.05 [ .110 +/- .002 ] | 6.4                            |
| 2 x 14 MAG     | 2.66 +/- 0.05 [ .105 +/- .002 ] | 7.7                            |
| 2 x 14 MAG     | 2.58 +/- 0.05 [ .102 +/- .002 ] | 8.4                            |

- 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: 8-2150870-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150870-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150870-6
- 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. 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

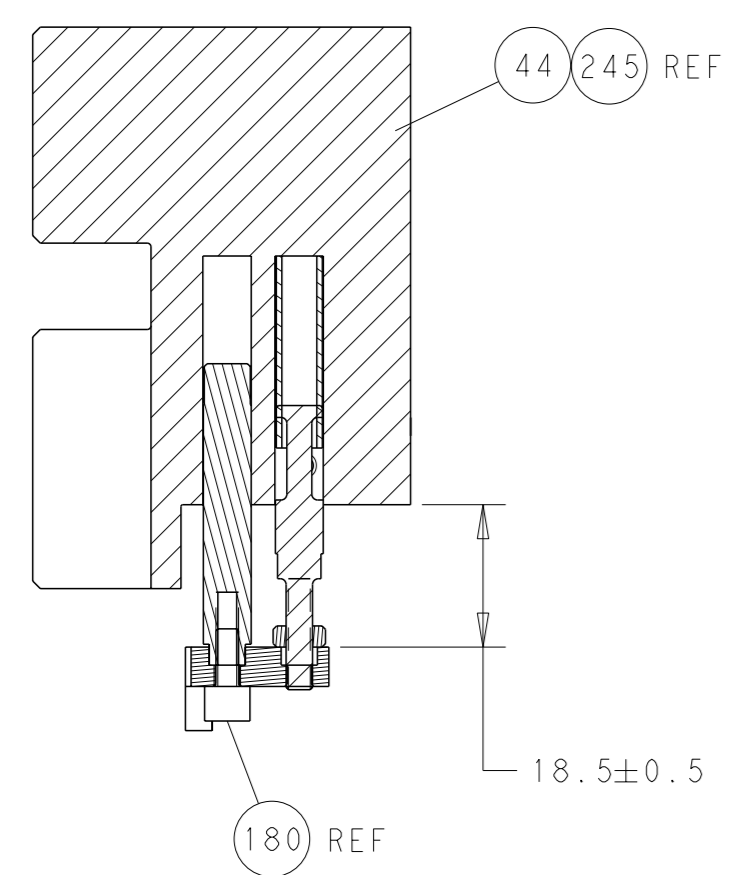
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS |               |           |        |
|--------------|-----|------|-----------|---------------|-----------|--------|
| 2119599-2    | A   | 66   | REV       | DATE          | BY        | APPV   |
|              |     |      | 1         | DEVELOPMENT   | 15JAN2018 | FZ KZ  |
|              |     |      | A         | RELEASED      | 07FEB2018 | JAH TE |
|              |     |      | A1        | ECR-18-007386 | 14MAY2018 | AW TE  |

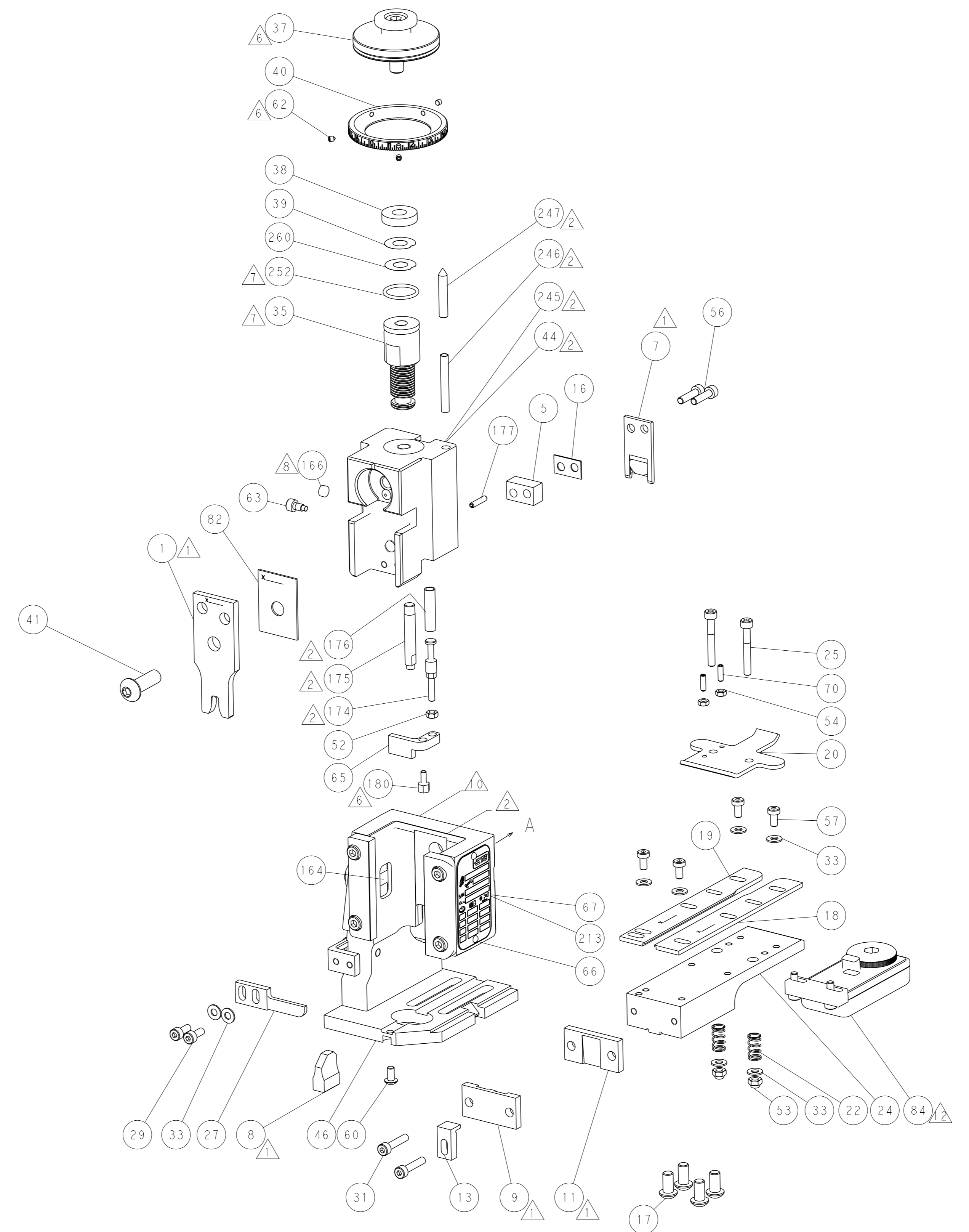
|  |   |     |     |     |     |             |                                      |     |
|--|---|-----|-----|-----|-----|-------------|--------------------------------------|-----|
|  | - | -   | 1   | -   | -   | 2119957-2   | APPLICATOR SHIM PACK                 | 260 |
|  | - | -   | 1   | -   | 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   | 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 |
|  | - | -   | 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 |
|  | - | -   | REF | REF | -   | 1901697-1   | FEED FINGER ASSEMBLY, EF             | 183 |
|  | - | 1   | 1   | 1   | 1   | 1752354-3   | 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   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854       | 137 |
|  | - | REF | REF | -   | -   | -           | SEE NOTE 4                           | 135 |
|  | - | 1   | 1   | 1   | -   | 1633743-1   | SERVO FEED LATCH ASM                 | 133 |
|  | - | 1   | 1   | 1   | 1   | 2119955-2   | ASSY, LUBRICATOR, END FEED           | 84  |
|  | - | 1   | 1   | 1   | 1   | 455888-9    | 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   | 1901681-1   | HOLDDOWN, TERMINAL                   | 65  |
|  | - | 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   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16       | 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   | 18023-9     | SCR, SKT HD CAP M4 X 6.0             | 49  |
|  | - | 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   | 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   | 1-2119644-3 | RAM WASHER, PRECISION                | 38  |
|  | - | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE              | 37  |
|  | - | 1   | -   | -   | 1   | 2119092-1   | BOLT, ADJUSTMENT                     | 35  |
|  | - | 8   | 8   | 8   | 8   | 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   | 1752371-5   | PLATE, STRIP GUIDE                   | 24  |
|  | - | 2   | 2   | 2   | 2   | 22281-8     | SPRING, COMPRESSION                  | 22  |
|  | - | 1   | 1   | 1   | 1   | 1803292-4   | DRAG                                 | 20  |
|  | - | 1   | 1   | 1   | 1   | 1901696-5   | STRIP GUIDE, REAR                    | 19  |
|  | - | 1   | 1   | 1   | 1   | 1901695-5   | STRIP GUIDE, FRONT                   | 18  |
|  | - | 4   | 4   | 4   | 4   | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12)            | 17  |
|  | - | 1   | 1   | 1   | 1   | 3-240641-8  | SPACER                               | 16  |
|  | - | 1   | 1   | 1   | 1   | 1752360-1   | SPACER, HOLD-DOWN                    | 13  |
|  | - | 1   | 1   | 1   | 1   | 240644-9    | PLATE, REAR SHEAR                    | 11  |
|  | - | -   | -   | -   | -   | -           | -                                    | 10  |
|  | - | 1   | 1   | 1   | 1   | 6-690482-3  | PLATE, FRONT SHEAR                   | 9   |
|  | 1 | 1   | 1   | 1   | 1   | 3-1803002-5 | ANVIL, COMBINATION, END FEED         | 8   |
|  | - | 1   | 1   | 1   | 1   | 1-2217206-2 | BLADE, SLUG                          | 7   |
|  | - | -   | -   | -   | -   | -           | -                                    | 6   |
|  | - | 1   | 1   | 1   | 1   | 5-240641-1  | SPACER                               | 5   |
|  | - | -   | -   | -   | -   | -           | -                                    | 4   |
|  | - | -   | -   | -   | -   | -           | -                                    | 3   |
|  | - | -   | -   | -   | -   | -           | -                                    | 2   |
|  | 1 | 1   | 1   | 1   | 1   | 456412-7    | CRIMPER, WIRE .180 F PREMIUM         | 1   |

| DIMENSIONS: |        | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | OWN      |           | NAME                                   |           |
|-------------|--------|--|--|----------|-----------|--|-----------|
| mm          | 0 PLC  | ±                                      |  | F. ZHANG | 15JAN2018 | TE Connectivity                        |           |
|             | 1 PLC  | ±                                      |  | K. ZHANG | 15JAN2018 | Harrisburg, PA 17105-3608              |           |
|             | 3 PLC  | ±                                      |  | K. ZHANG | 15JAN2018 | Ocean End Feed                         |           |
|             | 4 PLC  | ±                                      |  |          |           | Applicator                             |           |
|             | ANGLES | ±                                      |  |          |           | -                                      |           |
|             | FINISH | ±                                      |  |          |           | -                                      |           |
| MATERIAL    |        |  |  | WEIGHT   |           | SIZE                                   | CAGE CODE |
|             |        |  |  |          |           | A1                                     | 00779     |
|             |        |  |  |          |           | DRAWING NO                             | 2150870   |
|             |        |  |  |          |           | RESTRICTED TO                          |           |
|             |        |  |  |          |           | Customer Accessible Production Drawing | SCALE 1:1 |
|             |        |  |  |          |           | SHEET 1                                | OF 4      |
|             |        |  |  |          |           | REV                                    | A1        |

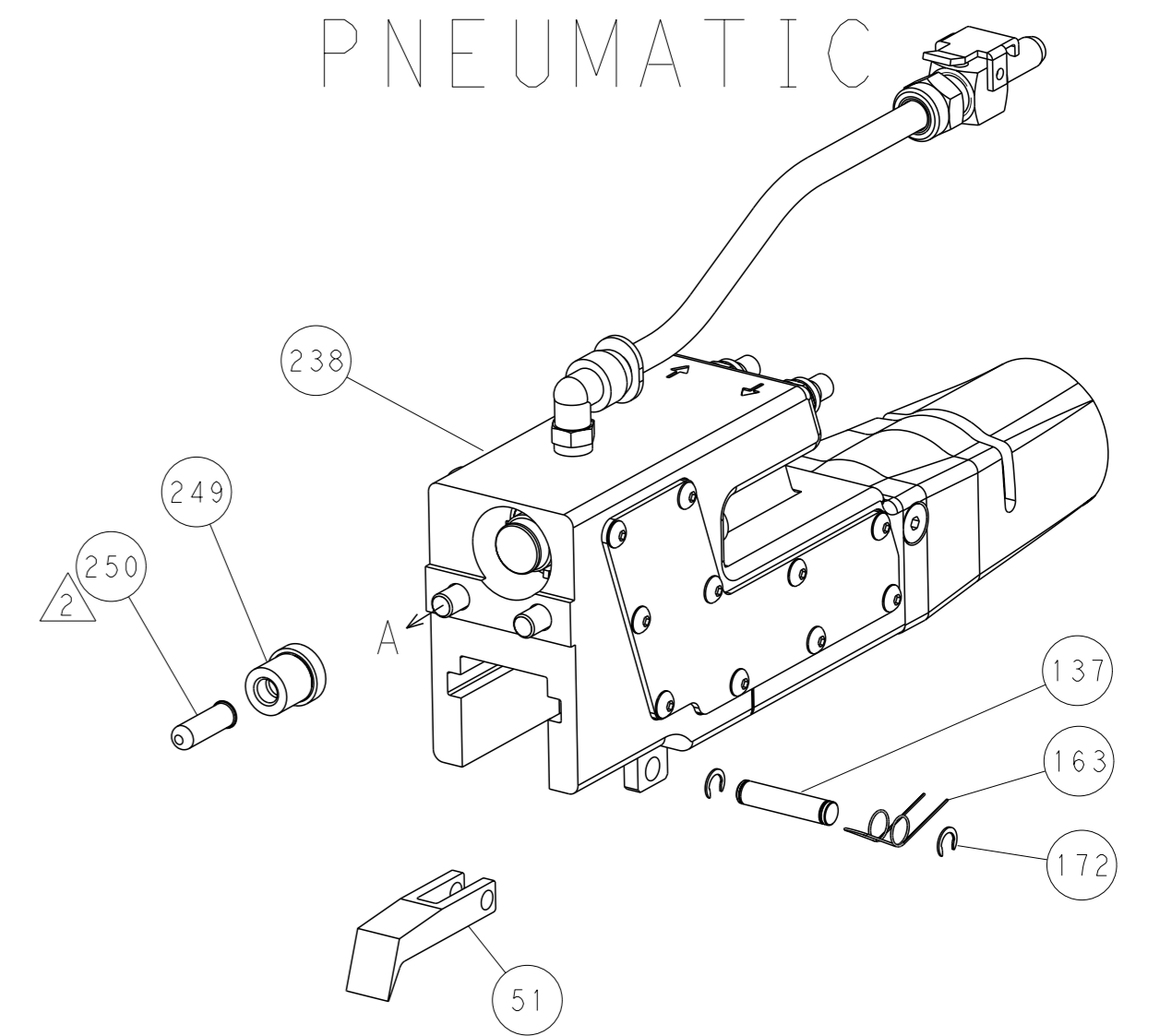
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LYR | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    |     | SEE SHEET 1 | -    | -   | -    |



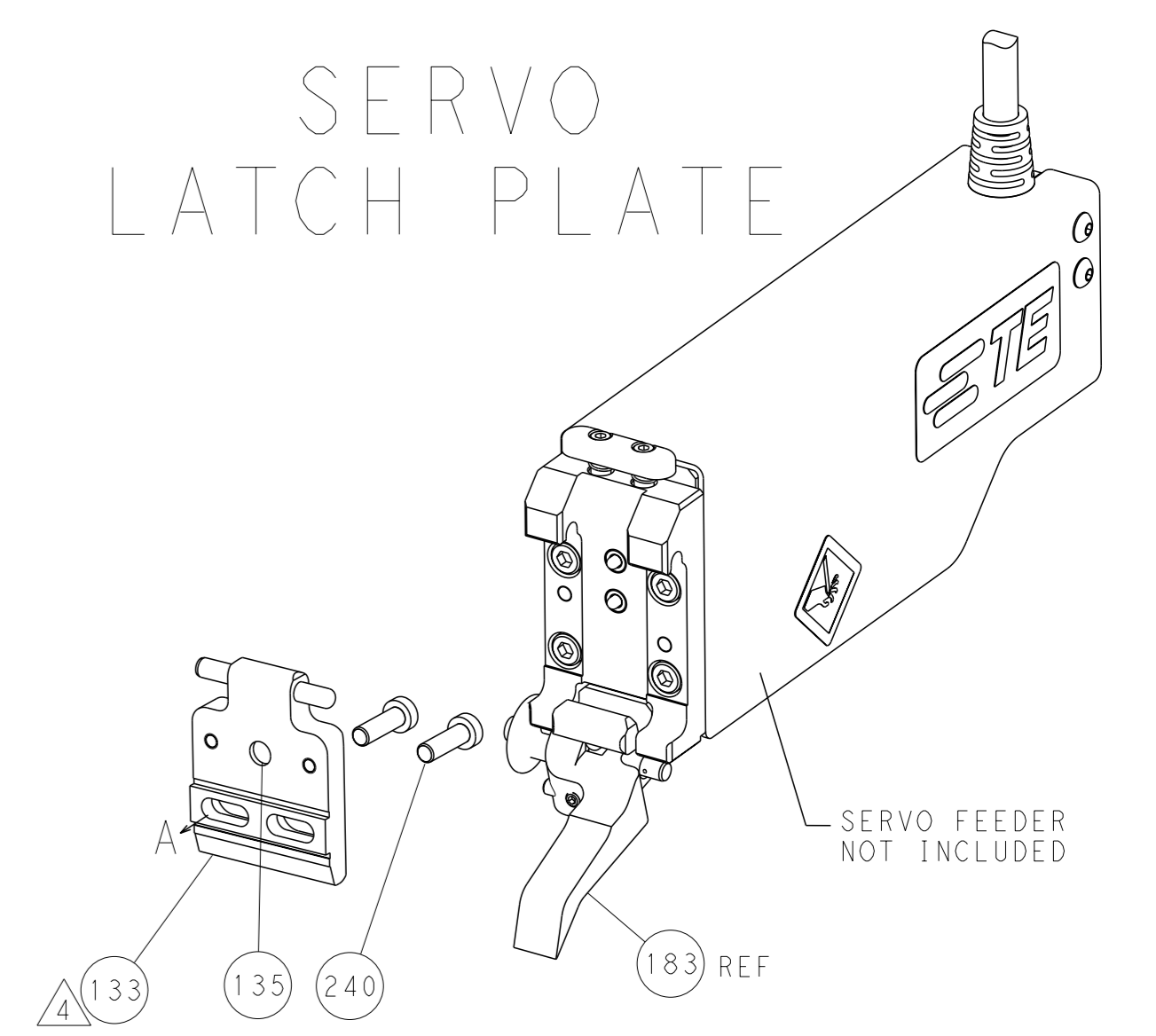
HOLDDOWN SET-UP



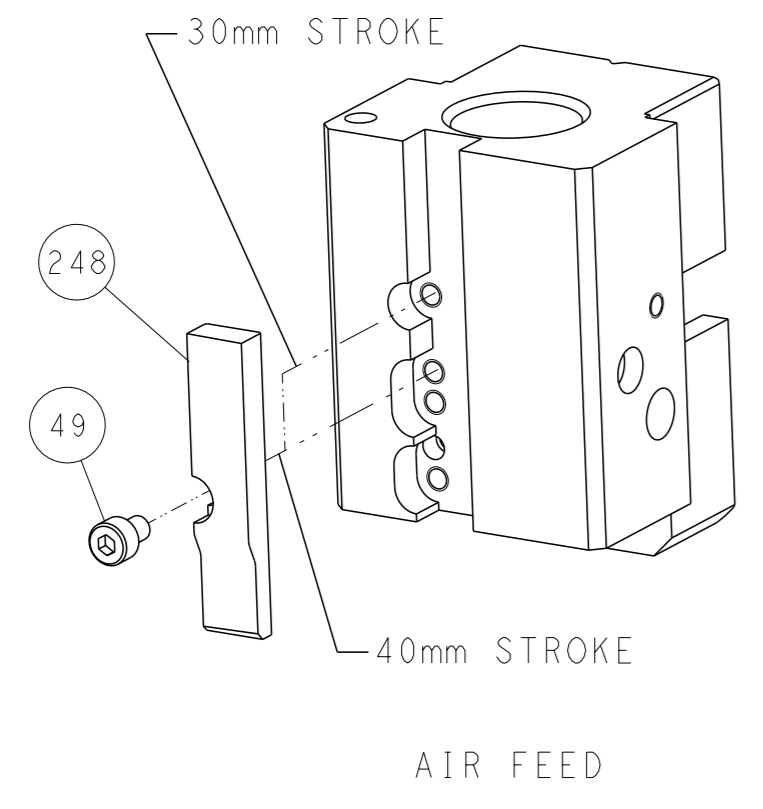
FEED TYPE  
PNEUMATIC



SERVO  
LATCH PLATE



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)

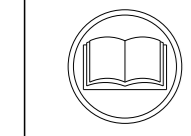
|   |  |  |  |  |
|---|--|--|--|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> |  | OWN: F. ZHANG 15JAN2018<br>CHK: K. ZHANG 15JAN2018<br>APVD: K. ZHANG 15JAN2018 | NAME: Ocean End Feed Applicator<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2150870 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ±  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ± | WEIGHT: -<br>FINISH: -   | RESTRICTED TO: -<br>SCALE: 1:1<br>SHEET: 2 of 4<br>REV: A1                               | Customer Accessible Production Drawing       |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION          | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |   |   |                        |
|--|-------------|-------------------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|---|---|------------------------|
|  |             |                   |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |   |   |                        |
|  | 2-2150870-2 | A                 | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | -                                 | -                     | -         | -           | - | - |                        |
|  | 2-2150870-5 | A                 | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | SERVO LATCH PLATE                 | 2119951-1             | 1901697-1 | 8-2150870-5 | - | - | 2168400-7 (QUANTITY 2) |
|  |             |                   |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150870-4 | - | - | -                      |
|  | 2-2150870-7 | A                 | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | - | - |                        |
| 7-2150870-7                                  | A           | CRIMP TOOLING KIT | -                        | -                              | -                                 | -                     | -         | -           | - | - |                        |

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

|  |   |                           |                         |
|--|---|---------------------------|-------------------------|
| TERMINAL DATA: KET BORGWARNER TERMINAL Borg Warner International CRIMP SPECIFICATION |   |                           |                         |
| TERMINAL NAME: 6.4 RING TERMINAL   |   |                           |                         |
| WIRE STRIP LENGTH  |   | INSULATION DIAMETER RANGE |                         |
| 6.70-7.10 mm [ .264-.280 IN ]  |   | Ø                         |                         |
| TERMINAL APPLICATION SPECIFICATION   | BorgWarner Tooling Spec PG 6-8 Rev 12/07/17 |                           |                         |
| TERMINALS APPLIED  |   |                           |                         |
| TE TERMINAL  | KET BORGWARNER TERMINAL                     | TE TERMINAL               | KET BORGWARNER TERMINAL |
| -  | -   | 3311041-2                 | 1987060                 |

| WIRE SIZE      | CRIMP HEIGHT mm [INCH]          | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|----------------|---------------------------------|---|
| 2 x 12-3/4 MAG | 2.92 +/- 0.05 [ .115 +/- .002 ] | 5.0   |
| 2 x 13 MAG     | 2.79 +/- 0.05 [ .110 +/- .002 ] | 6.4   |
| 2 x 14 MAG     | 2.66 +/- 0.05 [ .105 +/- .002 ] | 7.7   |
| 2 x 14 MAG     | 2.58 +/- 0.05 [ .102 +/- .002 ] | 8.4   |



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150870-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150870-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> 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.
- <sup>12</sup> 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.

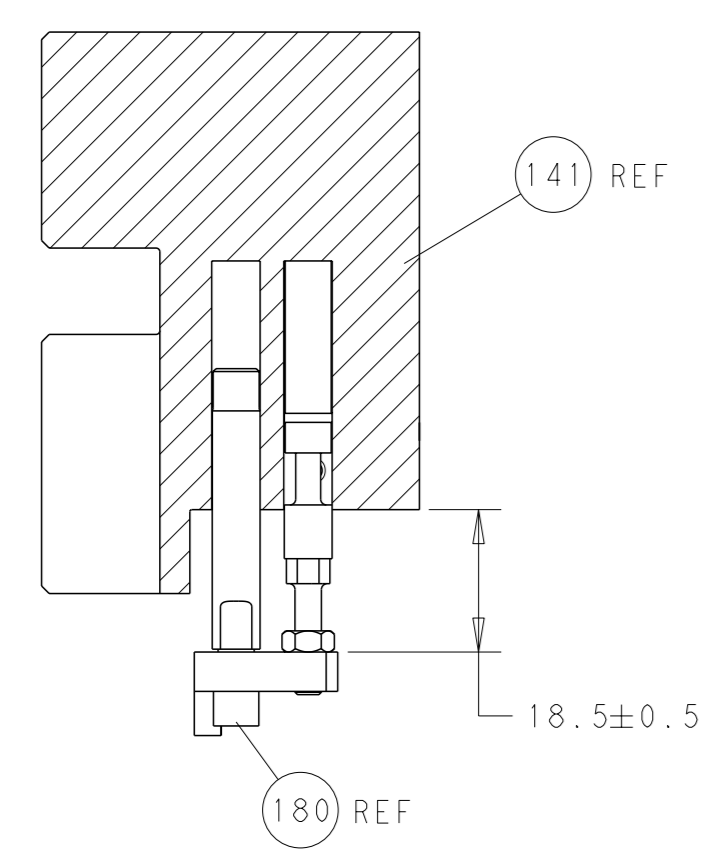
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

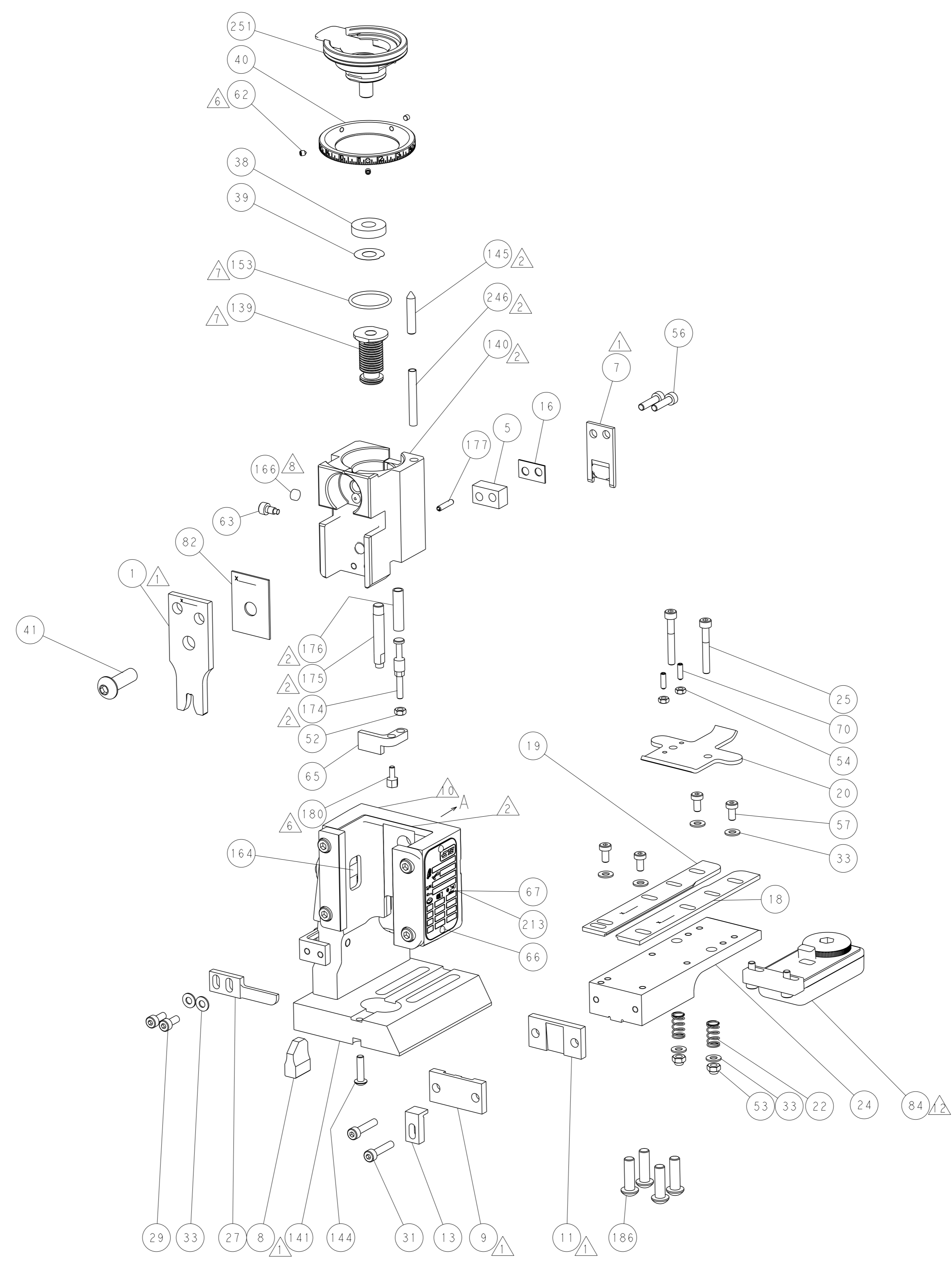
|              |              |     |     |             |                                     |                                 |     |
|--------------|--------------|-----|-----|-------------|-------------------------------------|---------------------------------|-----|
| -            | 1            | 1   | 1   | 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   | 1-22279-3   | SPRING, COMPRESSION                 | 246                             |     |
| -            | -            | 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                             |     |
| <sup>6</sup> | -            | 1   | 1   | 1           | 1752354-3                           | STANDOFF, HOLD-DOWN             | 180 |
| -            | 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                             |     |
| <sup>8</sup> | -            | 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                             |     |
| <sup>7</sup> | -            | 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                             |     |
| -            | -            | -   | -   | 2119653-2   | FEED CAM, POST FEED                 | 142                             |     |
| -            | 1            | 1   | 1   | 2119655-6   | APPLICATOR BASIC ASSEMBLY, EF       | 141                             |     |
| -            | 1            | 1   | 1   | 2119651-1   | RAM, ASIAN STYLE, END FEED          | 140                             |     |
| <sup>7</sup> | -            | 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                             |     |
| <sup>7</sup> | <sup>1</sup> | 1   | 1   | 2119955-2   | ASSY, LUBRICATOR, END FEED          | 84                              |     |
| -            | 1            | 1   | 1   | 455888-9    | 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   | 1901681-1   | HOLDDOWN, TERMINAL                  | 65                              |     |
| <sup>6</sup> | -            | 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   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 56                              |     |
| -            | 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   | 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   | 1-2119644-3 | RAM WASHER, PRECISION               | 38                              |     |
| -            | 8            | 8   | 8   | 1-18028-2   | WASHER, FLAT, REG M4                | 33                              |     |
| -            | 2            | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 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   | 1-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 30      | 25                              |     |
| -            | 1            | 1   | 1   | 1752371-5   | PLATE, STRIP GUIDE                  | 24                              |     |
| -            | 2            | 2   | 2   | 22281-8     | SPRING, COMPRESSION                 | 22                              |     |
| -            | 1            | 1   | 1   | 1803292-4   | DRAG                                | 20                              |     |
| -            | 1            | 1   | 1   | 1901696-5   | STRIP GUIDE, REAR                   | 19                              |     |
| -            | 1            | 1   | 1   | 1901695-5   | STRIP GUIDE, FRONT                  | 18                              |     |
| -            | 1            | 1   | 1   | 3-240641-8  | SPACER                              | 16                              |     |
| -            | 1            | 1   | 1   | 1752360-1   | SPACER, HOLD-DOWN                   | 13                              |     |
| <sup>1</sup> | -            | 1   | 1   | 1           | 240644-9                            | PLATE, REAR SHEAR               | 11  |
| -            | -            | -   | -   | -           | -                                   | 10                              |     |
| <sup>1</sup> | -            | 1   | 1   | 1           | 6-690482-3                          | PLATE, FRONT SHEAR              | 9   |
| <sup>1</sup> | 1            | 1   | 1   | 1           | 3-1803002-5                         | ANVIL, COMBINATION, END FEED    | 8   |
| <sup>1</sup> | -            | 1   | 1   | 1           | 1-2217206-2                         | BLADE, SLUG                     | 7   |
| -            | -            | -   | -   | -           | -                                   | 6                               |     |
| -            | 1            | 1   | 1   | 1           | 5-240641-1                          | SPACER                          | 5   |
| -            | -            | -   | -   | -           | -                                   | 4                               |     |
| <sup>1</sup> | -            | -   | -   | -           | -                                   | 3                               |     |
| -            | -            | -   | -   | -           | -                                   | 2                               |     |
| <sup>1</sup> | 1            | 1   | 1   | 1           | 456412-7                            | CRIMPER, WIRE .180 F PREMIUM    | 1   |

| DIMENSIONS:                            |               | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | OWN     |           | NAME       |               |
|--|---------------|--|---------|---------|-----------|------------|---------------|
| mm                                     | 0 PLC ±       | 1 PLC ±                                | 2 PLC ± | 3 PLC ± | 4 PLC ±   | APV        | NAME          |
|  | ANGLES FINISH |  |         |         |           |            |               |
| MATERIAL                               |               | WEIGHT                                 |         | SIZE    | CAGE CODE | DRAWING NO | RESTRICTED TO |
|  |               |  |         | A1      | 00779     | ©=2150870  |               |
| Customer Accessible Production Drawing |               |  |         | SCALE   | 1:1       | SHEET      | 3 OF 4        |

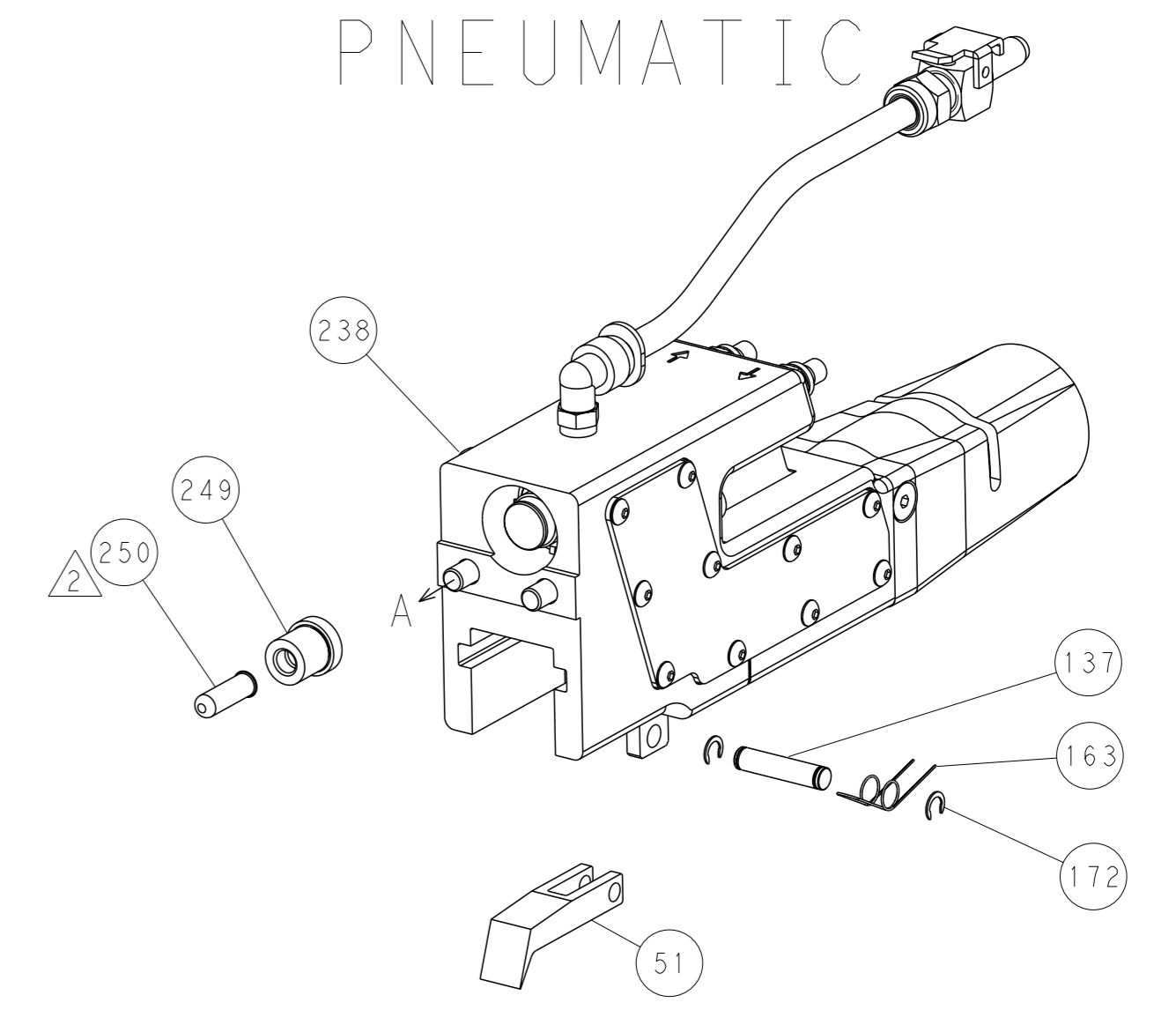
| LOC | DIST | REVISIONS |             |     |      |
|-----|------|-----------|-------------|-----|------|
| A   | 66   | REV       | DATE        | OWN | APVD |
|     |      | -         | SEE SHEET 1 | -   | -    |



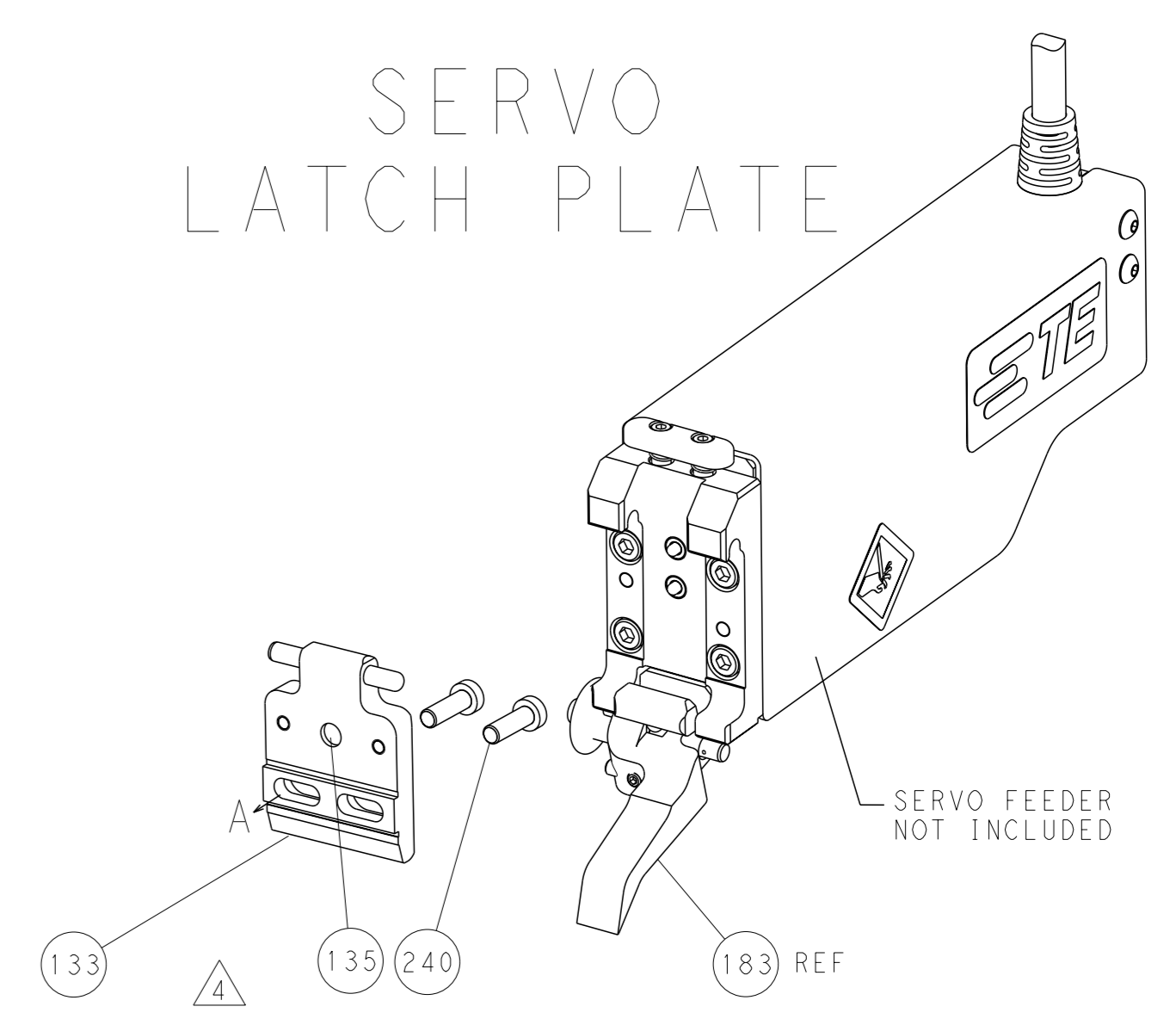
HOLDDOWN SET-UP



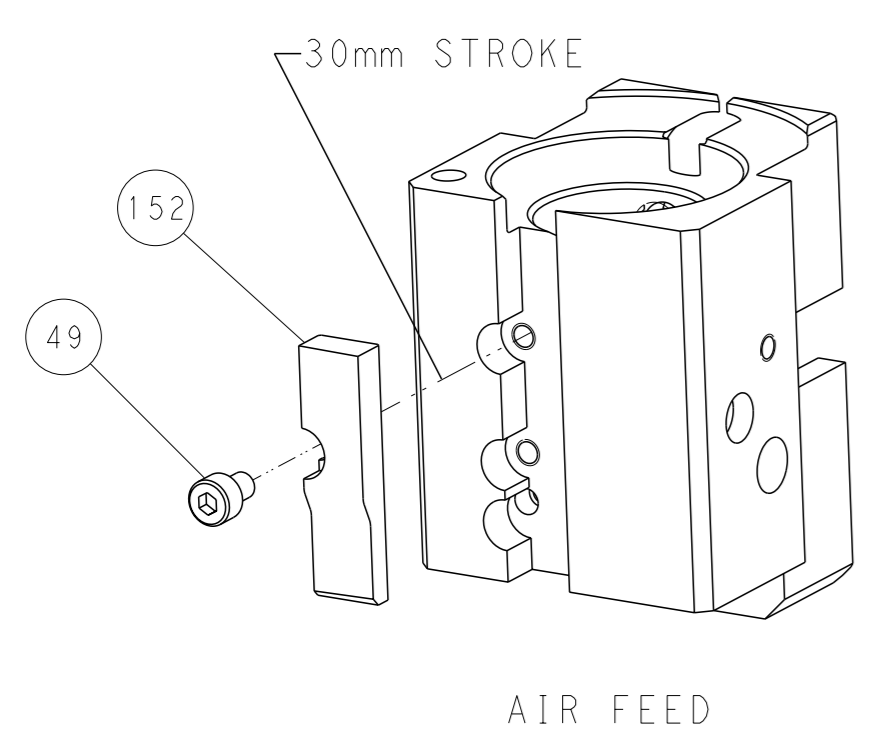
FEED TYPE  
PNEUMATIC



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)

|   |  |  |  |
|---|--|--|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> |  | OWN: F. ZHANG 15JAN2018<br>CHK: K. ZHANG 15JAN2018<br>APVD: K. ZHANG 15JAN2018 | NAME: STE TE Connectivity<br>Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ±  | APPLICATION SPEC: -<br>WEIGHT: -<br>SCALE: 1:1 | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2150870                          | RESTRICTED TO: -<br>SHEET 4 OF 4<br>REV A1             |
| Customer Accessible Production Drawing  |  |  |  |

# Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2150870-2](#)