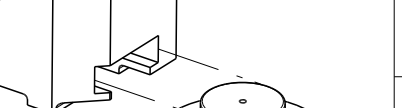


| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              | PART<br>NUMBER | REVISION | DESCRIPTION              | FEED TYPE                                                                                                                                                                                | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |   |                        |
|----------------------------------------------------------------------------------|----------------|----------|--------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
|                                                                                  |                |          |                          |                                                                                                                                                                                          | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |   |                        |
|  | 2150117-2      | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                                                                                                                                                                                | -                                 | -                     | -         | -           | -         | - | -                      |
|                                                                                  |                |          |                          |                                                                                                                                                                                          | SERVO LATCH PLATE                 | 2119951-1             | 1901697-2 | 8-2150117-5 | -         | - | 2168400-7 (QUANTITY 2) |
|                                                                                  |                |          |                          |                                                                                                                                                                                          | SMART APPLICATOR                  | 2161326-1             | -         | 8-2150117-4 | -         | - | -                      |
|                                                                                  | 2150117-5      | B        | FINE CRIMP HEIGHT ADJUST | SERVO<br>LATCH PLATE                                                                                    | -                                 | -                     | -         | -           | -         | - | -                      |
|                                                                                  |                |          |                          |                                                                                                                                                                                          | PNEUMATIC FEED                    | 2119950-1             | 2119792-9 | -           | 2119641-1 | - | 2063440-1              |
|                                                                                  | 2150117-6      | B        | NON-CRIMP HEIGHT ADJUST  |  SERVO<br>LATCH PLATE  | -                                 | -                     | -         | -           | -         | - | -                      |
|                                                                                  | 2150117-7      | B        | FINE CRIMP HEIGHT ADJUST | NONE                                                                                                                                                                                     | -                                 | -                     | -         | -           | -         | - | -                      |
|                                                                                  | 7-2150117-7    | A        | CRIMP TOOLING KIT        | -                                                                                                                                                                                        | -                                 | -                     | -         | -           | -         | - | -                      |

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

|                                                                                                                                                                                       |                        |                                  |             |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|----------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL                                                                                                                                                            |                        | TE CRIMP SPECIFICATION           |             |
| TERMINAL NAME: SPLICE (AMPLIVAR)                                                                                                                                                      |                        |                                  |             |
| WIRE STRIP LENGTH<br>6.86-7.88 mm [.270-.310 IN]                                                                                                                                      |                        | INSULATION DIAMETER RANGE<br>Ø - |             |
| TERMINAL APPLICATION SPECIFICATION<br>                                                               |                        | 114-2003<br>- -                  |             |
| TERMINALS APPLIED   |                        |                                  |             |
| TE TERMINAL<br>62304-1                                                                                                                                                                | TE TERMINAL<br>62304-2 | TE TERMINAL<br>9-62304-1         | TE TERMINAL |

|                                                                                                        |             |                                                           |             |
|--------------------------------------------------------------------------------------------------------|-------------|-----------------------------------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL                                                                             |             | TE CRIMP SPECIFICATION                                    |             |
| TERMINAL NAME: SPLICE (AMPLIVAR)                                                                       |             |                                                           |             |
| WIRE STRIP LENGTH<br>6.86-7.88 mm [.270-.310 IN]                                                       |             | INSULATION DIAMETER RANGE<br>Ø2.20-3.00 mm [.087-.118 IN] |             |
| TERMINAL APPLICATION  |             | 114-2003                                                  |             |
| SPECIFICATION                                                                                          |             | -                                                         |             |
| TERMINALS APPLIED    |             |                                                           |             |
| TE TERMINAL                                                                                            | TE TERMINAL | TE TERMINAL                                               | TE TERMINAL |
| 62305-1                                                                                                | 62305-2     | 62305-3                                                   | 62305-4     |

|                                                  |  |                                                           |  |
|--------------------------------------------------|--|-----------------------------------------------------------|--|
| TERMINAL DATA: TE TERMINAL                       |  | TE CRIMP SPECIFICATION                                    |  |
| TERMINAL NAME: SPLICE (AMPLIVAR)                 |  |                                                           |  |
| WIRE STRIP LENGTH<br>6.86-7.88 mm [.270-.310 IN] |  | INSULATION DIAMETER RANGE<br>Ø2.20-3.00 mm [.087-.118 IN] |  |
| TERMINAL APPLICATION SPECIFICATION               |  | 114-2003                                                  |  |
| TERMINALS APPLIED                                |  | - -                                                       |  |
| TE TERMINAL                                      |  | TE TERMINAL                                               |  |
| 62306-1                                          |  | 62306-2                                                   |  |
| TE TERMINAL                                      |  | TE TERMINAL                                               |  |
| 62306-3                                          |  | 9-62306-1                                                 |  |

| WIRE<br>SIZE              |  |  | CRIMP HEIGHT<br>mm [INCH]  |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|---------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|----------------------------|-------------------------------------------------------------------------------------|-----------------------------------|
| 3000 CMA 19+18% MAG(2951) |                                                                                     |                                                                                     | 1.64+/-0.05 [.065+/- .002] |                                                                                     | 7.6                               |
| 600 CMA 22% MAG(635)      |                                                                                     |                                                                                     | 1.33+/-0.05 [.052+/- .002] |                                                                                     | 10.8                              |

| WIRE SIZE                 |  |  | CRIMP HEIGHT<br>mm [INCH]   |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|---------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-----------------------------|---------------------------------------------------------------------------------------|-----------------------------------|
| 3000 CMA 19+18½ MAG(2951) |                                                                                     |                                                                                     | 1.45+/-0.05 [0.057+/-0.002] |                                                                                       | 9.6                               |
| 600 CMA 22½ MAG(635)      |                                                                                     |                                                                                     | 1.12+/-0.05 [0.044+/-0.002] |                                                                                       | 12.8                              |

| WIRE SIZE                |  |  | CRIMP HEIGHT<br>mm [INCH]  |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|--------------------------|---------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|----------------------------|---------------------------------------------------------------------------------------|-----------------------------------|
| 5000 CMA 16+17 MAG(4936) |                                                                                       |                                                                                       | 2.06+/-0.05 [.081+/- .002] |                                                                                       | 3.6                               |
| 1500 CMA 21+22 MAG(1503) |                                                                                       |                                                                                       | 1.60+/-0.05 [.063+/- .002] |                                                                                       | 8.1                               |



-  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:
- |                                                     |             |
|-----------------------------------------------------|-------------|
| MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: | 8-2150117-4 |
| PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION:  | 8-2150117-5 |
| SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST":         | 8-2150117-5 |
| SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST":          | 8-2150117-6 |

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 ITEM 62.  
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.

-  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 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.

- 12 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

- 13 REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.

- 14 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

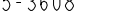
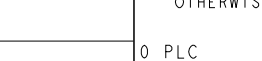
- 15 TERMINAL LUBRICANT RECOMMENDED.

\*WARNING

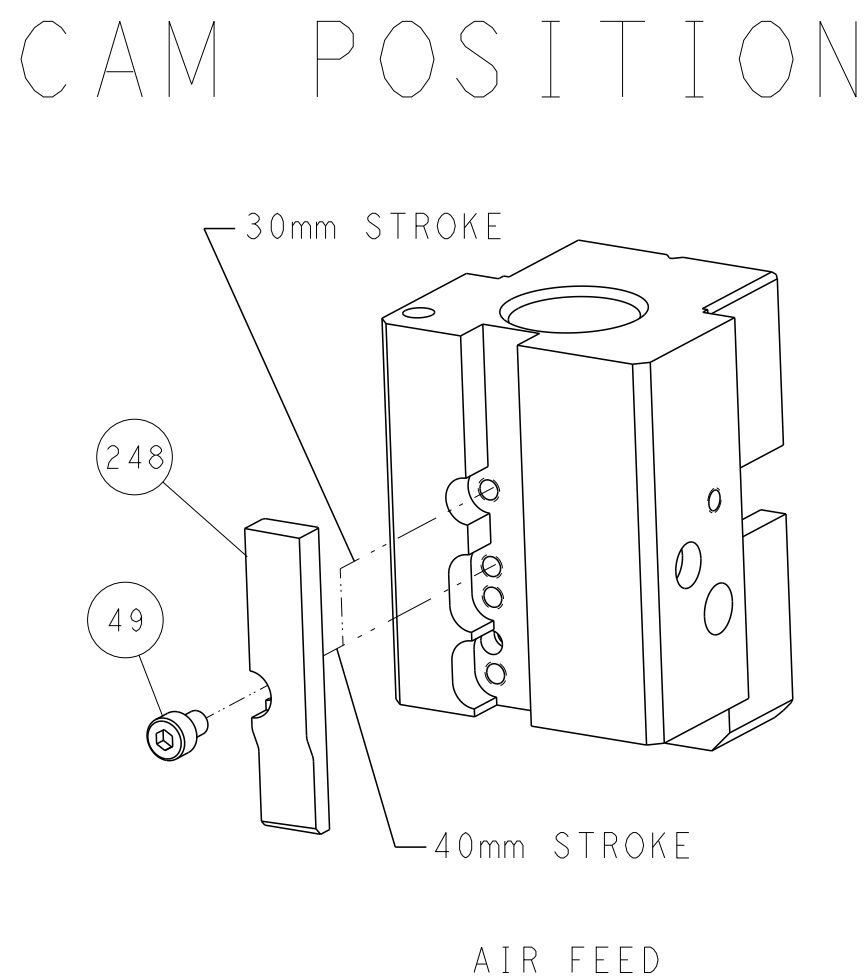
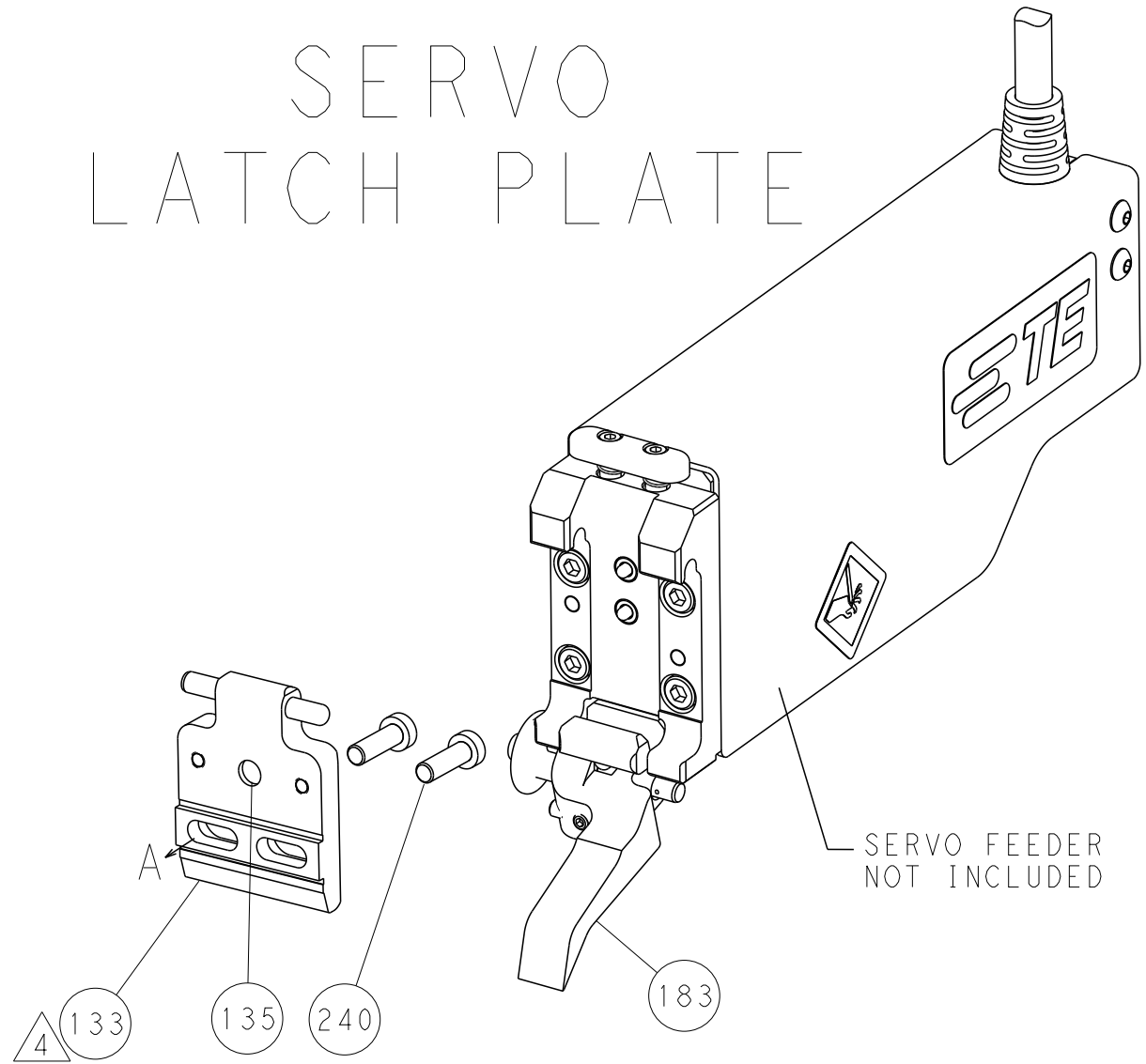
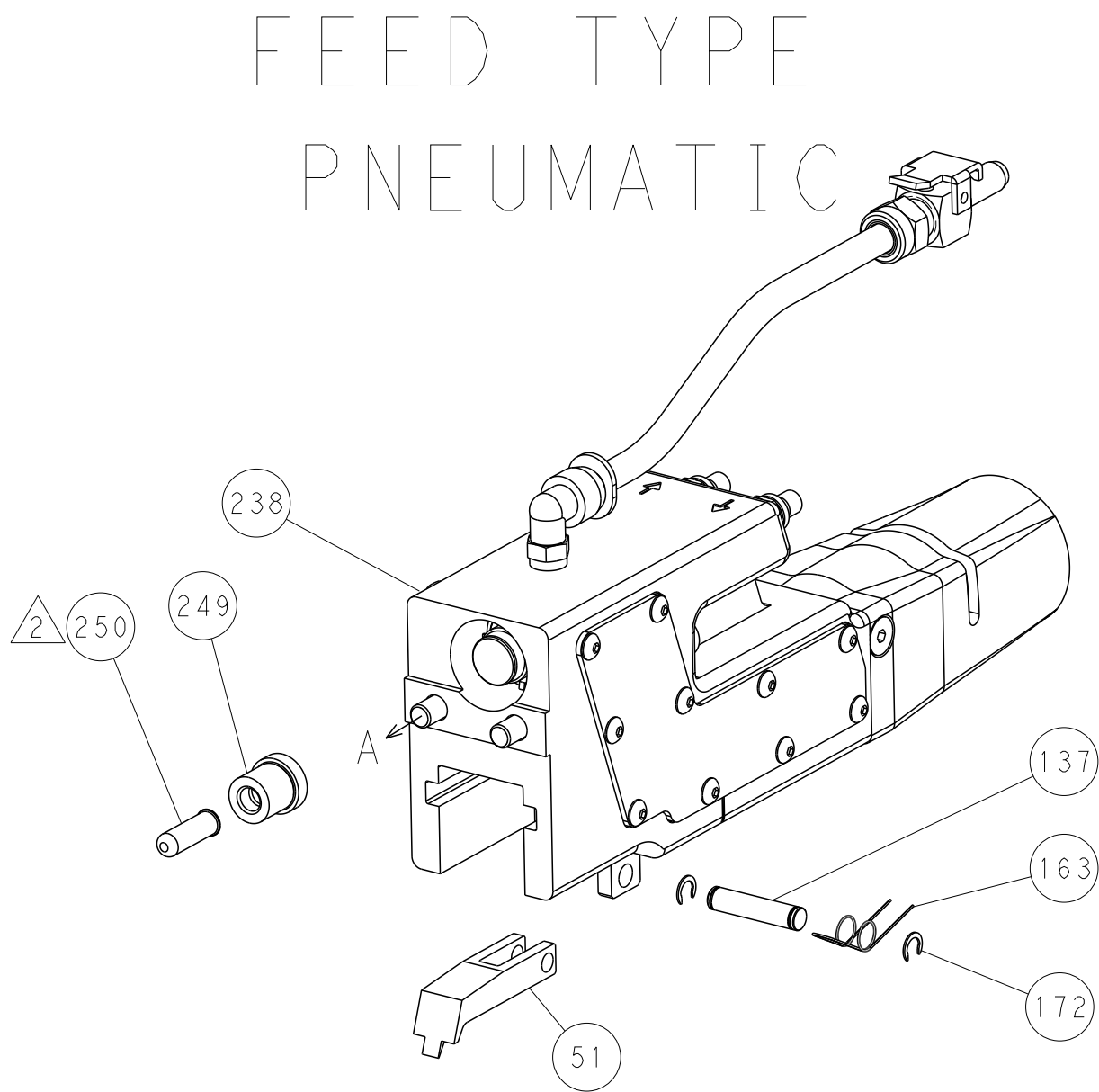
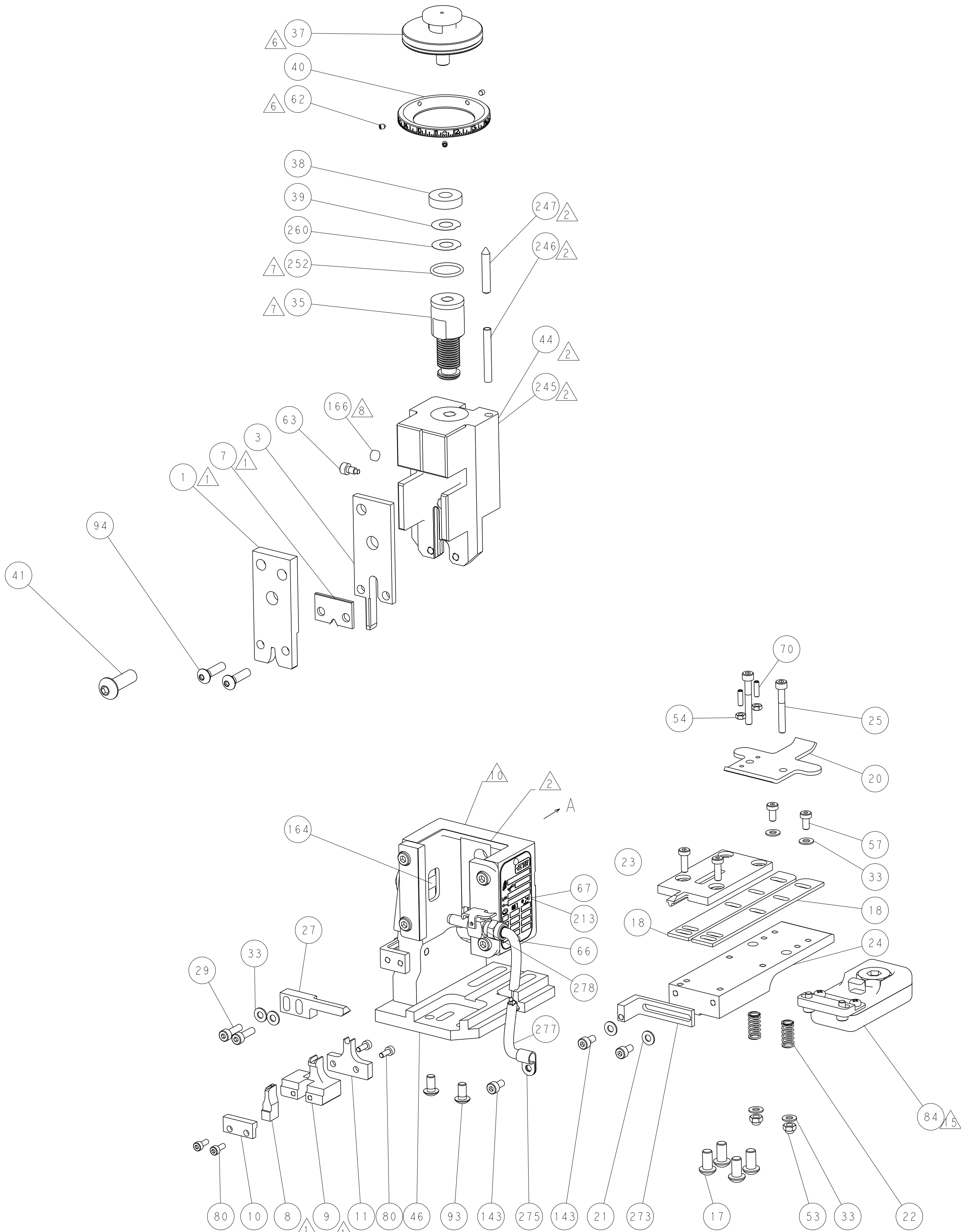
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|                           |               |             |           |
|---------------------------|---------------|-------------|-----------|
| 2                         |               | 1           |           |
| SET UP GAUGE<br>2119599-2 | LOC<br>A      | DIST<br>66  | REVISIONS |
| P                         | LTB           | DESCRIPTION | DATE      |
| A                         | RELEASED      | 02MAY2016   | EW GB     |
| B                         | ECR-17-000089 | 04JAN2017   | TB GB     |
|                           |               |             |           |
|                           |               |             |           |

|   |     |     |     |     |     |             |                                      |         |
|---|-----|-----|-----|-----|-----|-------------|--------------------------------------|---------|
|   | -   | 1   | 1   | 1   | 1   | 23238-1     | INSERT, COUPLING                     | 278     |
|   | -   | 24  | 24  | 24  | 24  | 2030758-3   | TUBING, POLYURETHANE                 | 277     |
|   | -   | 1   | 1   | 1   | 1   | 986220-3    | CLAMP, CABLE, BLACK                  | 275     |
|   | -   | 1   | 1   | 1   | 1   | 2844280-1   | MOUNT, AIR BLAST                     | 273     |
|   | -   | -   | 1   | -   | -   | 2119957-2   | APPLICATOR SHIM PACK                 | 260     |
| 7 | -   | 1   | -   | 1   | 1   | 8-21084-0   | O-RING, .676 ID, .070 DIA. MAT.      | 252     |
|   | -   | -   | -   | -   | 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   | -   | -   | 2844274-1   | RAM, AMP STYLE, END FEED, NON-ADJUST | 245     |
|   | -   | -   | 2   | 2   | -   | 2168400-7   | SHCS, LOW HEAD, RoHS, M5 X 10        | 24      |
|   | -   | -   | -   | -   | 1   | 2063440-1   | AIR FEED MODULE                      | 238     |
|   | -   | -   | 1   | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                  | 213     |
|   | -   | -   | 1   | 1   | -   | 1901697-2   | FEED FINGER ASSEMBLY, EF             | 183     |
|   | -   | -   | -   | -   | 2   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT  | 172     |
| 8 | -   | 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     |
|   | -   | 3   | 3   | 3   | 3   | 1-18023-0   | SCR, SKT HD CAP M4 X 8.0             | 143     |
|   | -   | -   | -   | -   | 1   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854       | 137     |
|   | -   | -   | REF | REF | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED              | 135     |
|   | -   | -   | 1   | 1   | -   | 1633743-1   | SERVO FEED LATCH ASM                 | 133     |
|   | -   | 2   | 2   | 2   | 2   | 1-18024-4   | SCR, BTN SKT HD CAP (M5 X 20.0)      | 94      |
|   | -   | 2   | 2   | 2   | 2   | 1-18024-1   | SCR, BTN SKT HD CAP (M5 X 10.0)      | 93      |
| 3 | -   | 1   | 1   | 1   | 1   | 2119955-2   | ASSY, LUBRICATOR, END FEED           | 84      |
|   | -   | 4   | 4   | 4   | 4   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0      | 80      |
|   | -   | 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   | 2119740-1   | TAG, IDENTIFICATION                  | 67      |
|   | -   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188     | 66      |
|   | -   | 1   | -   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT             | 63      |
| 6 | -   | 3   | -   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0  | 62      |
|   | -   | 2   | 2   | 2   | 2   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12        | 60      |
|   | -   | 2   | 2   | 2   | 2   | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8         | 57      |
|   | -   | 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   | 2119792-9   | PAWL, EF, AIR                        | 51      |
|   | -   | -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0             | 49      |
|   | -   | 1   | 1   | 1   | 1   | 2-2119655-1 | APPLICATOR BASIC ASSEMBLY, EF        | 46      |
|   | -   | 1   | -   | 1   | 1   | 2844273-1   | 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   | 1-2119644-2 | RAM WASHER, PRECISION                | 38      |
| 7 | -   | 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   | 2-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 14       | 29      |
|   | -   | 1   | 1   | 1   | 1   | 460276-2    | STRIPPER, SPECIAL                    | 27      |
|   | -   | 2   | 2   | 2   | 2   | 1-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 30       | 25      |
|   | -   | 1   | 1   | 1   | 1   | 3-1752371-0 | PLATE, STRIP GUIDE                   | 24      |
| 1 | -   | 1   | 1   | 1   | 1   | 1-462932-0  | PLATE, STRIP COVER                   | 23      |
|   | -   | 2   | 2   | 2   | 2   | 2-22281-3   | SPRING, COMPRESSION                  | 22      |
|   | -   | 2   | 2   | 2   | 2   | 18027-2     | WASHER, FLAT, REG M4                 | 21      |
|   | -   | 1   | 1   | 1   | 1   | 1803292-1   | DRAG                                 | 20      |
|   | -   | 2   | 2   | 2   | 2   | 1901259-4   | GUIDE, LOWER STRIP                   | 18      |
|   | -   | 4   | 4   | 4   | 4   | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12)            | 17      |
|   | -   | 1   | 1   | 1   | 1   | 459684-3    | PLATE GUIDE, RETAINING               | 11      |
|   | -   | 1   | 1   | 1   | 1   | 459580-1    | PLATE, RETAINING                     | 10      |
| 1 | -   | 1   | 1   | 1   | 1   | 2-459583-1  | BODY, ANVIL                          | 9       |
| 1 | -   | 1   | 1   | 1   | 1   | 459582-4    | ANVIL, AMPLIVAR SPLICE               | 8       |
| 1 | -   | 1   | 1   | 1   | 1   | 459581-1    | BLADE, SLUG                          | 7       |
|   | -   | -   | -   | -   | -   | -           | -                                    | 6       |
|   | -   | -   | -   | -   | -   | -           | -                                    | 5       |
|   | -   | -   | -   | -   | -   | -           | -                                    | 4       |
| 1 | -   | 1   | 1   | 1   | 1   | 459587-1    | GUIDE, CRIMPER                       | 3       |
|   | -   | -   | -   | -   | -   | -           | -                                    | 2       |
| 1 | -   | 1   | 1   | 1   | 1   | 459585-1    | CRIMPER, BLUNT F                     | 1       |
|   | -77 | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                          | ITEM NO |

|                                                                                                                                                                                                                          |  |        |  |                                        |  |                                       |  |                                                                                                       |  |                           |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------|--|----------------------------------------|--|---------------------------------------|--|-------------------------------------------------------------------------------------------------------|--|---------------------------|--|
| THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC CORPORATION<br>IT IS SUBJECT TO THE SAME CONTROL AND ENGINEERING OBSERVATION<br>SHOULD BE CONTACTED FOR THE LATEST REVISION.                                    |  |        |  |                                        |  | OWN<br><b>G. WEAVER</b><br>16FEB2016  |  |  TE Connectivity |  | Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:<br>mm<br><br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±° |  |        |  |                                        |  | CHK<br><b>G. BAILEY</b><br>16FEB2016  |  |                                                                                                       |  |                           |  |
|                                                                                                                                                                                                                          |  |        |  |                                        |  | APVD<br><b>G. BAILEY</b><br>16FEB2016 |  | NAME<br><b>Ocean End Feed Applicator</b>                                                              |  |                           |  |
|                                                                                                                                                                                                                          |  |        |  |                                        |  | PRODUCT SPEC<br>-                     |  | SIZE CAGE CODE DRAWING NO RESTRICTED TO                                                               |  |                           |  |
|                                                                                                                                                                                                                          |  |        |  |                                        |  | APPLICATION SPEC<br>-                 |  | A   00779 G=2150117 -                                                                                 |  |                           |  |
| MATERIAL FINISH                                                                                                                                                                                                          |  | WEIGHT |  | Customer Accessible Production Drawing |  | SCALE 1:1                             |  | SHEET 1 OF 4                                                                                          |  | REV B                     |  |

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



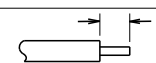
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

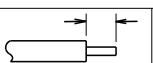
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |                                |                                              |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--------------------------------|----------------------------------------------|--|
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| CHK<br>G. BAILEY<br>16FEB2016                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |  | NAME<br>G. BAILEY<br>16FEB2016 | Ocean End Feed<br>Applicator                 |  |
| APVD<br>G. BAILEY<br>16FEB2016                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |  |  | PRODUCT SPEC                   | SIZE<br>A1                                   |  |
| APPLICATION SPEC                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |  | WEIGHT<br>-                    | SHEET 2 OF 4                                 |  |
| MATERIAL<br>-                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |  | FINISH<br>-                    | REV B                                        |  |
| Customer Accessible Production Drawing                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |  |  | SCALE<br>1:1                   | SHEET 2 OF 4                                 |  |

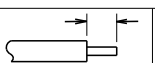
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

|                                                       |                |                          |                          |
|-------------------------------------------------------|----------------|--------------------------|--------------------------|
| 8                                                     |                | 7                        |                          |
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| PACIFIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER    | PART<br>NUMBER | REVISION                 | DESCRIPTION              |
|                                                       | 2-2150117-2    | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                       | 2-2150117-5    | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                       | 2-2150117-7    | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                       | 7-2150117-7    | A                        | CRIMP TOOLING KIT        |

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

|                                                                                                                                                                                       |             |                                                                                   |                           |             |             |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|-----------------------------------------------------------------------------------|---------------------------|-------------|-------------|
| TERMINAL DATA: TE TERMINAL                                                                                                                                                            |             |                                                                                   | TE CRIMP SPECIFICATION    |             |             |
| TERMINAL NAME: SPLICE (AMPLIVAR)                                                                                                                                                      |             |                                                                                   |                           |             |             |
| WIRE STRIP LENGTH                                                                                                                                                                     |             |  | INSULATION DIAMETER RANGE |             |             |
| 6.86-7.88 mm [.270-.310 IN]                                                                                                                                                           |             |                                                                                   | Ø -                       |             |             |
| TERMINAL APPLICATION SPECIFICATION                                                                                                                                                    |             |  | 114-2003                  | -           | -           |
|                                                                                                                                                                                       |             |                                                                                   | -                         | -           | -           |
| TERMINALS APPLIED   |             |                                                                                   |                           |             |             |
| TE TERMINAL                                                                                                                                                                           | TE TERMINAL | TE TERMINAL                                                                       | TE TERMINAL               | TE TERMINAL | TE TERMINAL |
| 62304-1                                                                                                                                                                               | 62304-2     | 9-62304-1                                                                         |                           |             |             |

|                                                                                                      |                                                                                   |                                                                                    |                                                           |
|------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                           |                                                                                   | TE CRIMP SPECIFICATION                                                             |                                                           |
| TERMINAL NAME: SPLICE (AMPLIVAR)                                                                     |                                                                                   |                                                                                    |                                                           |
| WIRE STRIP LENGTH<br>6.86-7.88 mm [.270-.310 IN]                                                     |                                                                                   |  | INSULATION DIAMETER RANGE<br>Ø2.20-3.00 mm [.087-.118 IN] |
| TERMINAL APPLICATION SPECIFICATION                                                                   |  | 114-2003                                                                           | -                                                         |
|                                                                                                      |                                                                                   | -                                                                                  | -                                                         |
| TERMINALS APPLIED  |                                                                                   |                                                                                    |                                                           |
| TE TERMINAL                                                                                          | TE TERMINAL                                                                       | TE TERMINAL                                                                        | TE TERMINAL                                               |
| 62305-1                                                                                              | 62305-2                                                                           | 62305-3                                                                            | 62305-4                                                   |

|                                                                                                                                                                                           |             |                                                                                     |                                                           |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|-------------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                                                                                                                |             | TE CRIMP SPECIFICATION                                                              |                                                           |
| TERMINAL NAME: SPLICE (AMPLIVAR)                                                                                                                                                          |             |                                                                                     |                                                           |
| WIRE STRIP LENGTH<br>6.86-7.88 mm [.270-.310 IN]                                                                                                                                          |             |  | INSULATION DIAMETER RANGE<br>Ø2.20-3.00 mm [.087-.118 IN] |
| TERMINAL APPLICATION SPECIFICATION                                                                                                                                                        | 114-2003    | -                                                                                   | -                                                         |
|                                                                                                                                                                                           | -           | -                                                                                   | -                                                         |
| TERMINALS APPLIED   |             |                                                                                     |                                                           |
| TE TERMINAL                                                                                                                                                                               | TE TERMINAL | TE TERMINAL                                                                         | TE TERMINAL                                               |
| 62306-1                                                                                                                                                                                   | 62306-2     | 62306-3                                                                             | 9-62306-1                                                 |

|                           |                                                                                     |                            |                                                                                     |                                |                                                                                     |
|---------------------------|-------------------------------------------------------------------------------------|----------------------------|-------------------------------------------------------------------------------------|--------------------------------|-------------------------------------------------------------------------------------|
| WIRE SIZE                 |  | CRIMP HEIGHT mm [INCH]     |  | CRIMP HEIGHT REFERENCE SETTING |  |
| 3000 CMA 19+18Ø MAG(2951) |                                                                                     | 1.64+/-0.05 [.065+/- .002] |                                                                                     | 7.6                            |                                                                                     |
| 600 CMA 22Ø MAG(635)      |                                                                                     | 1.33+/-0.05 [.052+/- .002] |                                                                                     | 10.8                           |                                                                                     |

|                           |                                                                                     |                            |                                                                                       |                                |                                                                                       |
|---------------------------|-------------------------------------------------------------------------------------|----------------------------|---------------------------------------------------------------------------------------|--------------------------------|---------------------------------------------------------------------------------------|
| WIRE SIZE                 |  | CRIMP HEIGHT mm [INCH]     |  | CRIMP HEIGHT REFERENCE SETTING |  |
| 3000 CMA 19+18Ø MAG(2951) |                                                                                     | 1.45+/-0.05 [.057+/- .002] |                                                                                       | 9.6                            |                                                                                       |
| 600 CMA 22Ø MAG(635)      |                                                                                     | 1.12+/-0.05 [.044+/- .002] |                                                                                       | 12.8                           |                                                                                       |

|                           |                                                                                       |                            |                                                                                       |                                |                                                                                       |
|---------------------------|---------------------------------------------------------------------------------------|----------------------------|---------------------------------------------------------------------------------------|--------------------------------|---------------------------------------------------------------------------------------|
| WIRE SIZE                 |  | CRIMP HEIGHT mm [INCH]     |  | CRIMP HEIGHT REFERENCE SETTING |  |
| 5000 CMA 16+17 MAG(4936)  |                                                                                       | 2.06+/-0.05 [.081+/- .002] |                                                                                       | 9.6                            |                                                                                       |
| 1500 CMA 21Ø+22 MAG(1503) |                                                                                       | 1.60+/-0.05 [.063+/- .002] |                                                                                       | 12.8                           |                                                                                       |

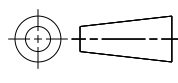


-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150117-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150117-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150117-5
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 ITEM 62.
-  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.
-  REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
-  TERMINAL LUBRICANT RECOMMENDED.

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

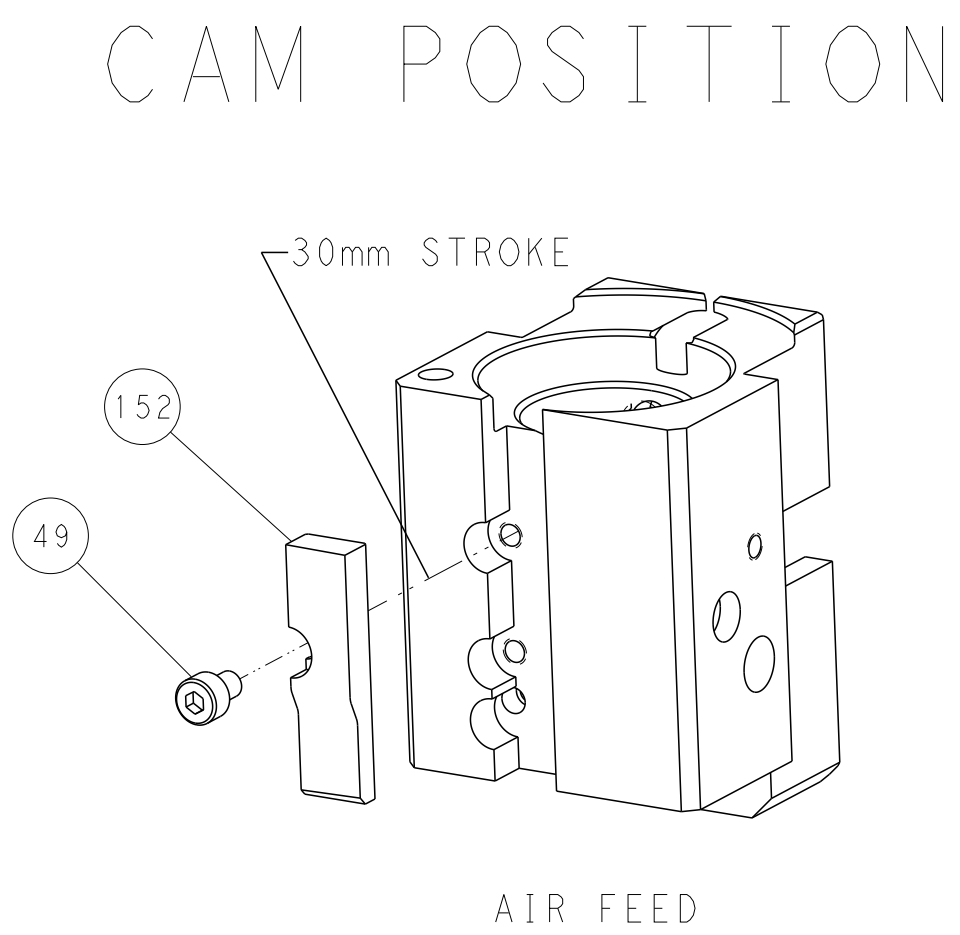
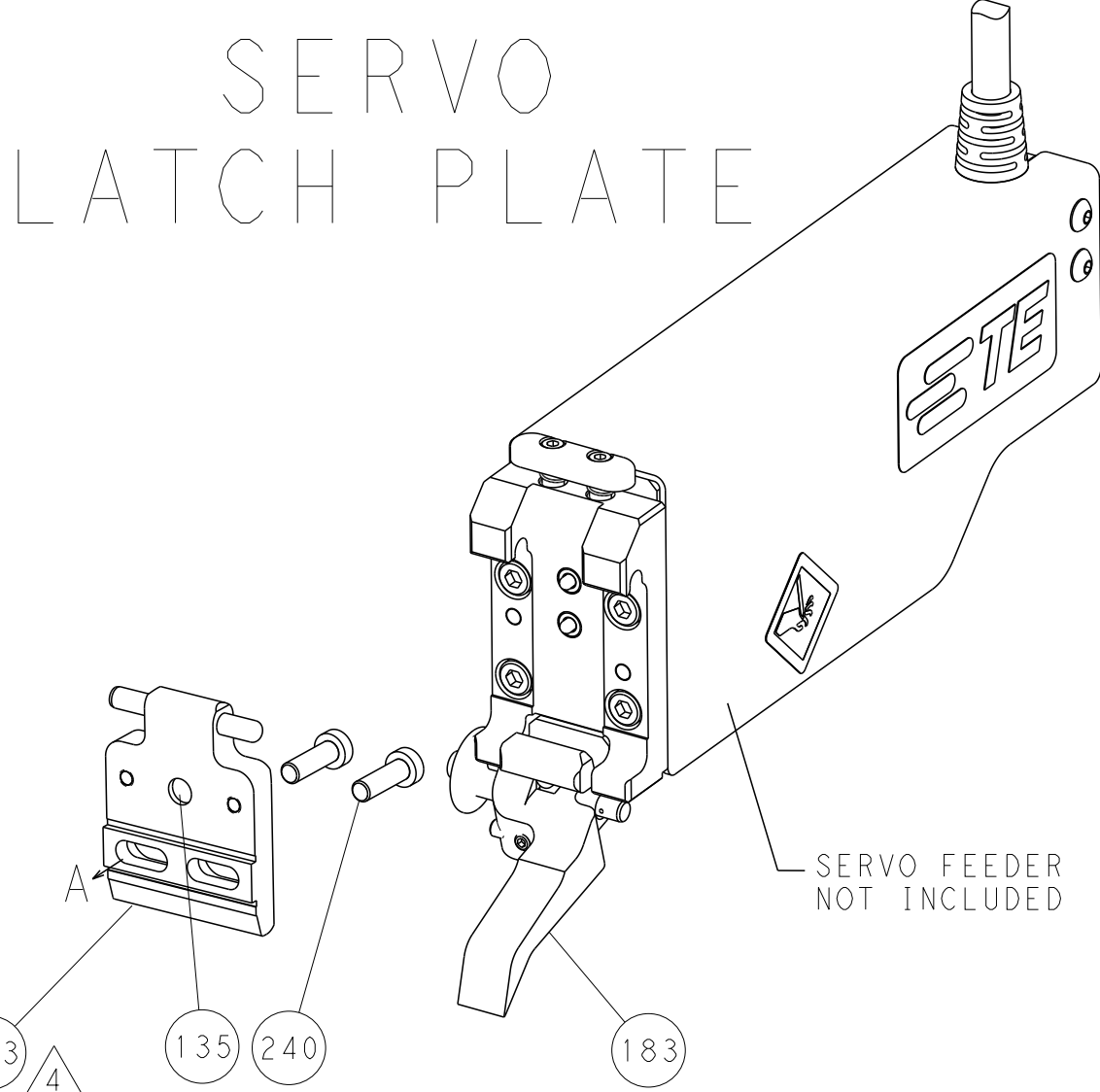
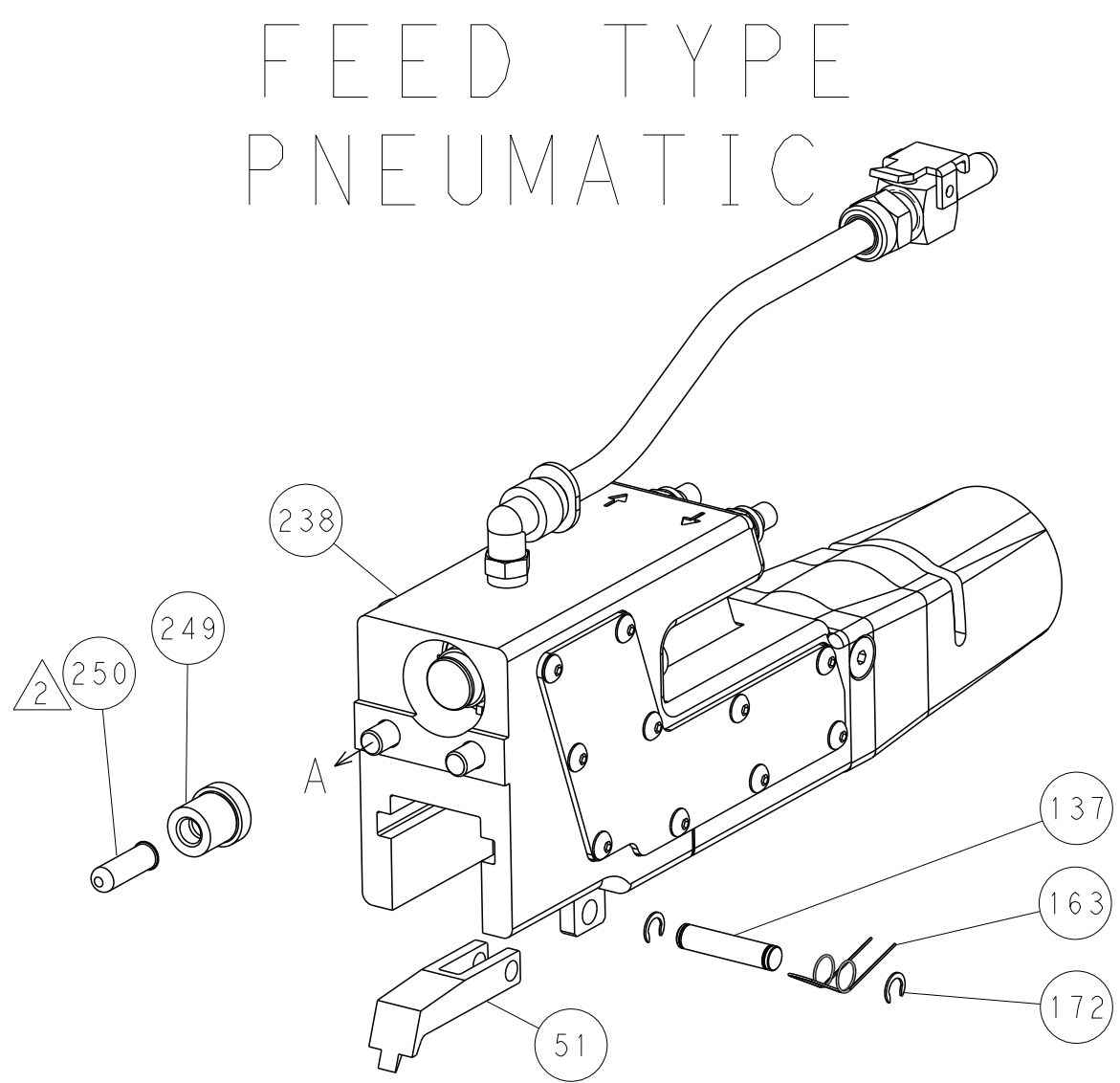
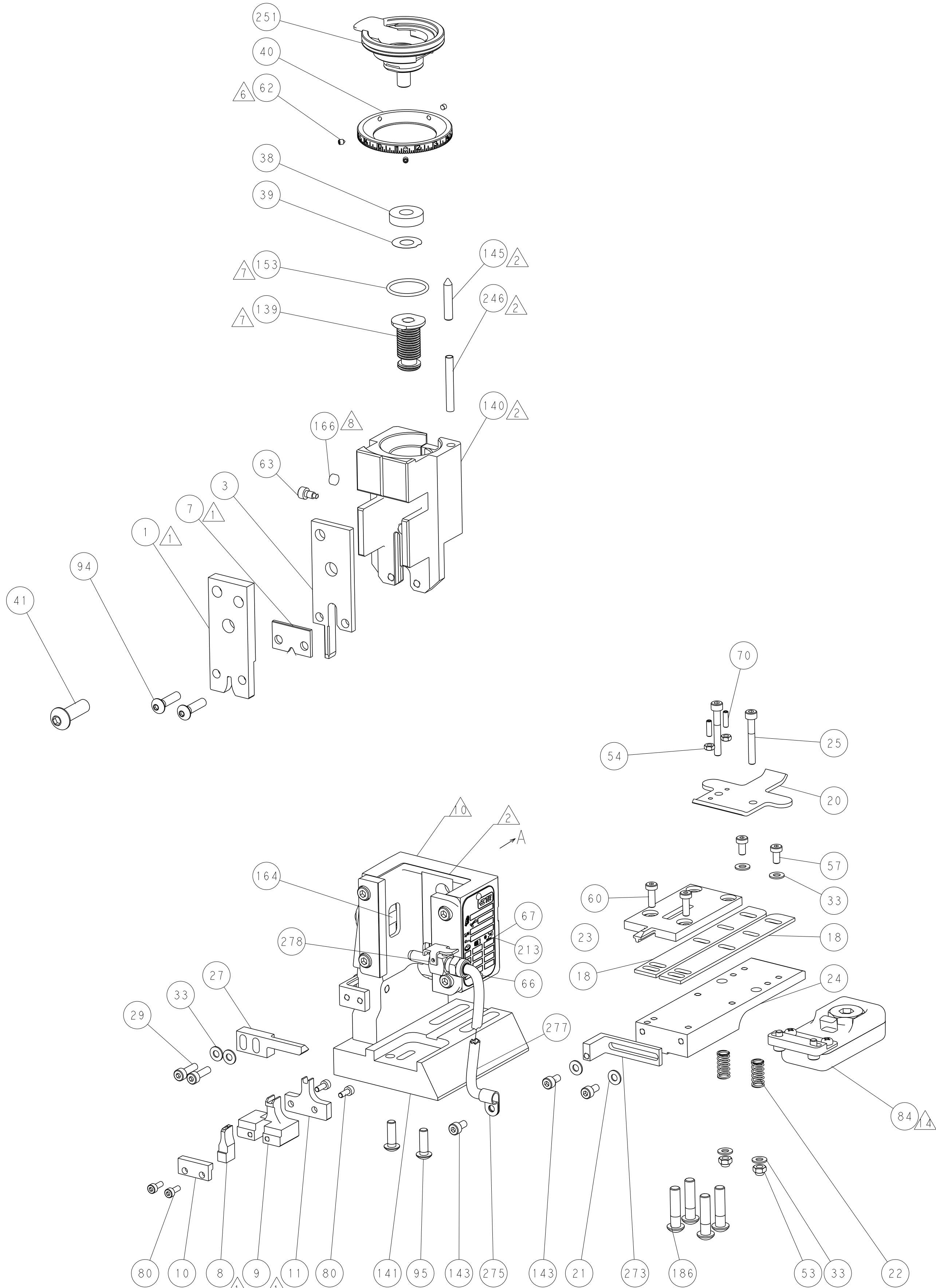
|                           |          |             |           |      |     |      |
|---------------------------|----------|-------------|-----------|------|-----|------|
| SET UP GAUGE<br>2119599-2 | LOC<br>A | DIST<br>66  | REVISIONS |      |     |      |
| P                         | LTR      | DESCRIPTION |           | DATE | DWN | APVD |
|                           | -        | SEE SHEET 1 |           | -    | -   | -    |
|                           |          |             |           |      |     |      |
|                           |          |             |           |      |     |      |

|                                                                                         |     |     |     |             |                                     |         |
|-----------------------------------------------------------------------------------------|-----|-----|-----|-------------|-------------------------------------|---------|
| -                                                                                       | 1   | 1   | 1   | 23238-1     | INSERT, COUPLING                    | 278     |
| -                                                                                       | 24  | 24  | 24  | 2030758-3   | TUBING, POLYURETHANE                | 277     |
| -                                                                                       | 1   | 1   | 1   | 986220-3    | CLAMP, CABLE, BLACK                 | 275     |
| -                                                                                       | 1   | 1   | 1   | 2844280-1   | MOUNT, AIR BLAST                    | 273     |
| -                                                                                       | 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     |
| -                                                                                       | -   | 2   | -   | 2168400-7   | SHCS, LOW HEAD, RoHS, M5 X 10       | 240     |
| -                                                                                       | -   | -   | 1   | 2063440-1   | AIR FEED MODULE                     | 238     |
| -                                                                                       | -   | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| -                                                                                       | 4   | 4   | 4   | 2-18024-1   | SCR, BTN SKT HD CAP (M6 X 25.0)     | 186     |
| -                                                                                       | -   | 1   | -   | 1901697-2   | FEED FINGER ASSEMBLY, EF            | 183     |
| -                                                                                       | -   | -   | 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     |
| -                                                                                       | 3   | 3   | 3   | 1-18023-0   | SCR, SKT HD CAP M4 X 8.0            | 143     |
| -                                                                                       | 1   | 1   | 1   | 2-2119655-2 | APPLICATOR BASIC ASSEMBLY, EF       | 141     |
| -                                                                                       | 1   | 1   | 1   | 2844275-1   | 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     |
| -                                                                                       | 2   | 2   | 2   | 1-18024-3   | SCR, BTN SKT HD CAP (M5 X 16.0)     | 95      |
|  -   | 2   | 2   | 2   | 1-18024-4   | SCR, BTN SKT HD CAP (M5 X 20.0)     | 94      |
| -                                                                                       | 1   | 1   | 1   | 2119955-2   | ASSY, LUBRICATOR, END FEED          | 84      |
| -                                                                                       | 4   | 4   | 4   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 80      |
| -                                                                                       | 1   | 1   | 1   | 2119956-2   | DOCUMENTATION PACKAGE               | 71      |
| -                                                                                       | 2   | 2   | 2   | 2-18032-2   | SCR, SET, FLT POINT 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   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| -                                                                                       | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62      |
| -                                                                                       | 2   | 2   | 2   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 60      |
| -                                                                                       | 2   | 2   | 2   | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8        | 57      |
| -                                                                                       | 2   | 2   | 2   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 54      |
| -                                                                                       | 2   | 2   | 2   | 986965-8    | NUT, LOCK, HEX, TORQUE (M4)         | 53      |
| -                                                                                       | -   | -   | 1   | 2119792-9   | 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   | 1-2119644-2 | RAM WASHER, PRECISION               | 38      |
| -                                                                                       | 8   | 8   | 8   | 1-18028-2   | WASHER, FLAT, REG M4                | 33      |
| -                                                                                       | 2   | 2   | 2   | 2-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 14      | 29      |
| -                                                                                       | 1   | 1   | 1   | 460276-2    | STRIPPER, SPECIAL                   | 27      |
| -                                                                                       | 2   | 2   | 2   | 1-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 30      | 25      |
|  - | 1   | 1   | 1   | 3-1752371-0 | PLATE, STRIP GUIDE                  | 24      |
| -                                                                                       | 1   | 1   | 1   | 1-462932-0  | PLATE, STRIP COVER                  | 23      |
| -                                                                                       | 2   | 2   | 2   | 2-22281-3   | SPRING, COMPRESSION                 | 22      |
| -                                                                                       | 2   | 2   | 2   | 18027-2     | WASHER, FLAT, REG M4                | 21      |
| -                                                                                       | 1   | 1   | 1   | 1803292-1   | DRAG                                | 20      |
| -                                                                                       | 2   | 2   | 2   | 1901259-4   | GUIDE, LOWER STRIP                  | 18      |
| -                                                                                       | 1   | 1   | 1   | 459684-3    | PLATE GUIDE, RETAINING              | 11      |
|  - | 1   | 1   | 1   | 459580-1    | PLATE, RETAINING                    | 10      |
|  - | 1   | 1   | 1   | 2-459583-1  | BODY, ANVIL                         | 9       |
|  - | 1   | 1   | 1   | 459582-4    | ANVIL, AMPLIVAR SPLICE              | 8       |
|  - | 1   | 1   | 1   | 459581-1    | BLADE, SLUG                         | 7       |
| -                                                                                       | -   | -   | -   | -           | -                                   | 6       |
| -                                                                                       | -   | -   | -   | -           | -                                   | 5       |
| -                                                                                       | -   | -   | -   | -           | -                                   | 4       |
|  - | 1   | 1   | 1   | 459587-1    | GUIDE, CRIMPER                      | 3       |
| -                                                                                       | -   | -   | -   | -           | -                                   | 2       |
|  - | 1   | 1   | 1   | 459585-1    | CRIMPER, BLUNT F                    | 1       |
| -77-27-25-22                                                                            |     |     |     | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                             |                                     |                                              |  |
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| DIMENSIONS:<br>mm                                                                                                                                                                                                                                                                                    |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.001<br>1 PLC ±.001<br>2 PLC ±.001<br>3 PLC ±.001<br>4 PLC ±.001<br>ANGLES ±.001<br>FINISH |                                     | NAME<br>Ocean End Feed<br>Applicator         |  |
|                                                                                                                                                                                                                 |  | PRODUCT SPEC<br>APPLICATION SPEC                                                                                                            |                                     | SIZE<br>A1                                   |  |
| MATERIAL<br>-                                                                                                                                                                                                                                                                                        |  | WEIGHT<br>-                                                                                                                                 |                                     | CAGE CODE<br>00779                           |  |
|                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                             |                                     | DRAWING NO<br>C=2150117                      |  |
|                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                             |                                     | RESTRICTED TO<br>-                           |  |
|                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                             |                                     | Customer Accessible Production Drawing       |  |
|                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                             |                                     | SCALE<br>1:1                                 |  |
|                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                             |                                     | SHEET<br>3                                   |  |
|                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                             |                                     | OF<br>4                                      |  |
|                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                             |                                     | REV<br>B                                     |  |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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



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

|                                                                                                                            |  |                                                 |                                               |          |
|----------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------|-----------------------------------------------|----------|
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| DIMENSIONS:<br>mm                                                                                                          |  | CHK<br>G. BAILEY<br>16FEB2016                   | NAME<br>Ocean End Feed<br>Applicator          |          |
| TOLERANCES UNLESS<br>OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH ±   |  | APVD<br>G. BAILEY<br>16FEB2016                  | SIZE<br>A1<br>00779<br>C=2150117              |          |
| MATERIAL<br>-                                                                                                              |  | PRODUCT SPEC<br>APPLICATION SPEC<br>WEIGHT<br>- | RESTRICTED TO<br>-                            |          |
| Customer Accessible Production Drawing                                                                                     |  | SCALE<br>1:1                                    | SHEET<br>4                                    | REV<br>B |

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