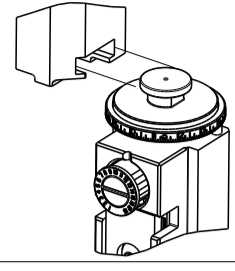

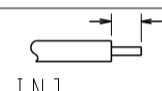

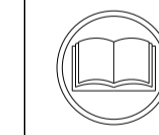


8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION					
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART		
	2150335-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	CONVERT TO	PART NUMBERS REQUIRED	
	2150335-7	E	FINE CRIMP HEIGHT ADJUST	NONE	MECHANICAL FEED	2119949-1	1-1338683-0
	7-2150335-7	D	CRIMP TOOLING KIT	-		5-18022-5	2119653-1
						-	-
						-	-
						-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	SP
APPL INSTRUCTIONS 408-10390 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS FLAG F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-5.30 mm [.169-.209 IN]		Ø1.90-3.30 mm [.075-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-64027		
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178423-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.60 +/- 0.05 [.063 +/- .002]	7
18 AWG	1.45 +/- 0.05 [.057 +/- .002]	8.8
20 AWG	1.35 +/- 0.05 [.053 +/- .002]	10.1



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

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

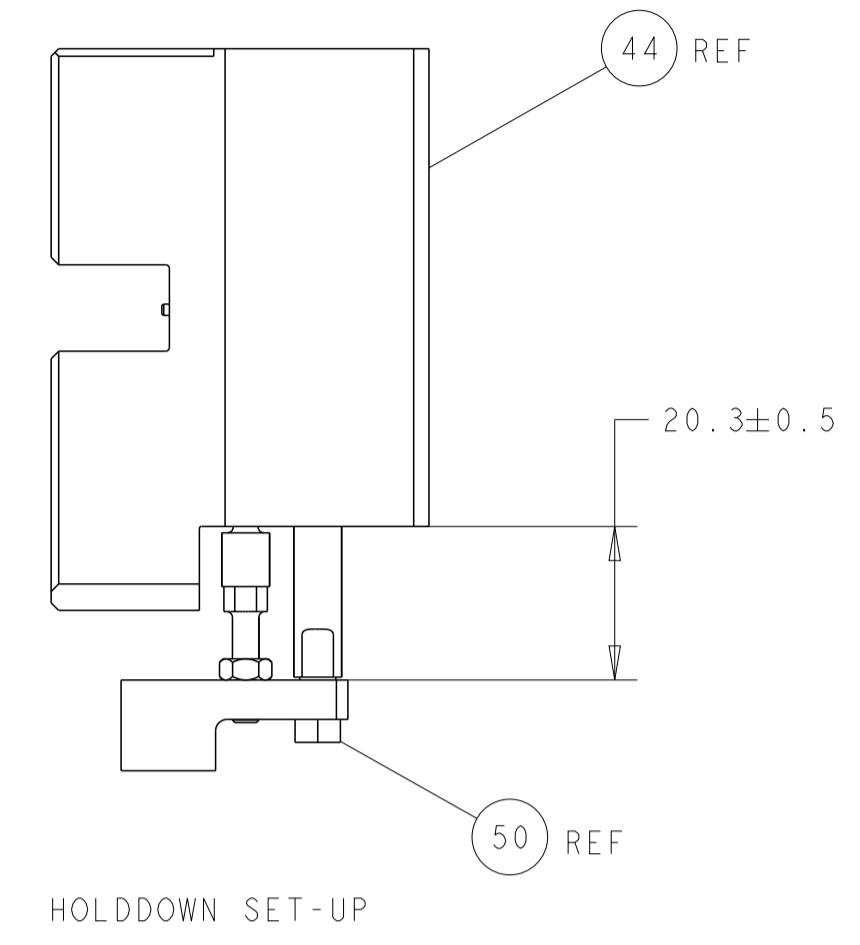
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			C		ECR-15-001396	14SEP2015	YY	UG
			D		ECR-16-015133	26OCT2016	TB	GB
			E		ECR-17-012693	30AUG2017	TB	GB

7	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	-	1	1803259-1	BUSHING, FLANGED	249
	-	-	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119798-1	DETENT PIN	247
	-	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	2063440-1	AIR FEED MODULE	238
	-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	1	240638-1	SPRING, FEED FINGER	163
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	2119956-2	DOCUMENTATION PACKAGE	71
	-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1803176-1	HOLDDOWN, TERMINAL	65
	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6	-	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 X 4.0	62
	-	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	-	1	2161920-3	NARROW PAWL, EF, AIR	51
6	-	1	1	3-1752354-8	STANDOFF,HOLD-DOWN	50
	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
	-	1	1	2119369-1	RAM, AMP STYLE, END FEED	44
	-	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1-2119644-2	RAM WASHER, PRECISION	38
6	-	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
7	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	1	1-690455-0	STRIPPER, FRONT CASTING	27
	-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
	-	1	1	2161922-1	PLATE, STRIP GUIDE	24
	-	2	2	22281-6	SPRING, COMPRESSION	22
	-	1	1	1633168-2	ARM, STOCK DRAG	21
	-	1	1	1-464452-7	DRAG, STOCK	20
	-	1	1	1803086-2	GUIDE, REAR STRIP	19
	-	1	1	3-1901695-3	STRIP GUIDE, FRONT	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1803175-1	SUPPORT, TERMINAL	13
1	-	1	1	461160-3	PLATE, REAR SHEAR	11
	-	2	2	8-240645-6	SPACER, SHEAR PLATE	10
1	-	1	1	455961-5	PLATE, FRONT SHEAR	9
1	1	1	1	6-1803059-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1803186-1	BLADE, SLUG	7
	-	-	-	-	-	6
	-	-	-	-	-	5
	-	1	1	3-238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1803108-5	CRIMPER, INSULATION O	3
	-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1	1-1803015-4	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL		FINISH		WEIGHT		SCALE	
				A1 00779		Customer Accessible Production Drawing	

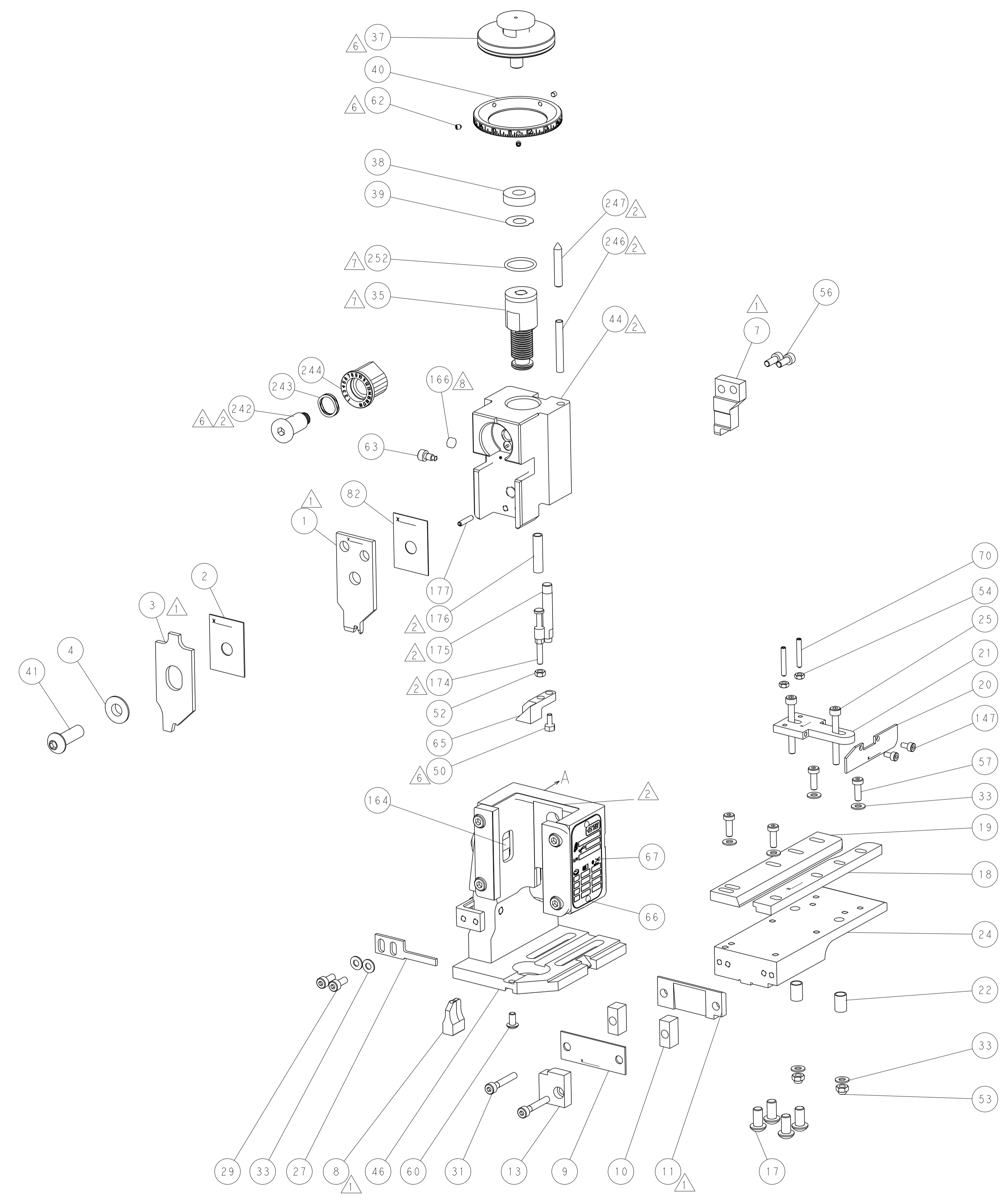
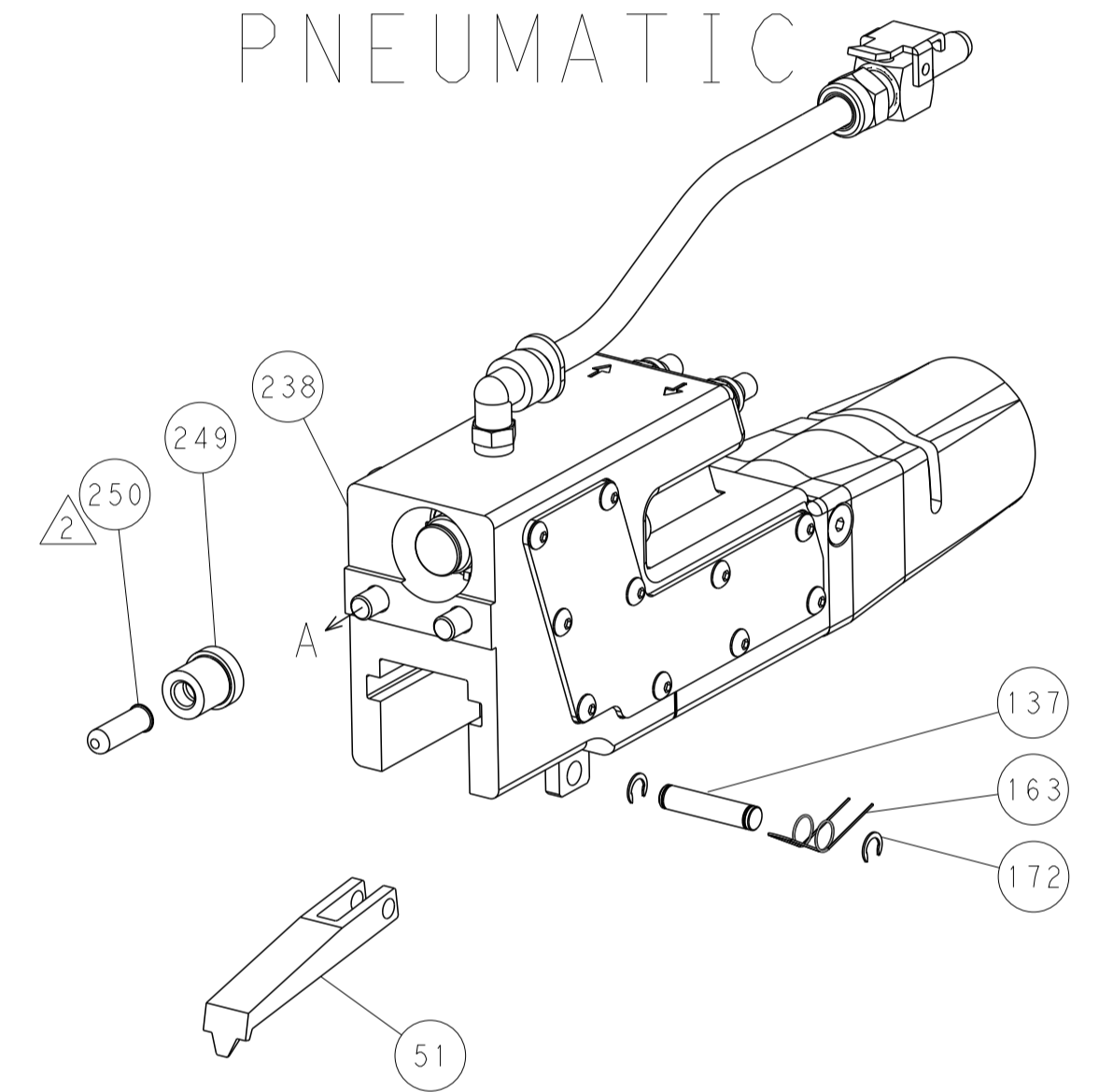
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

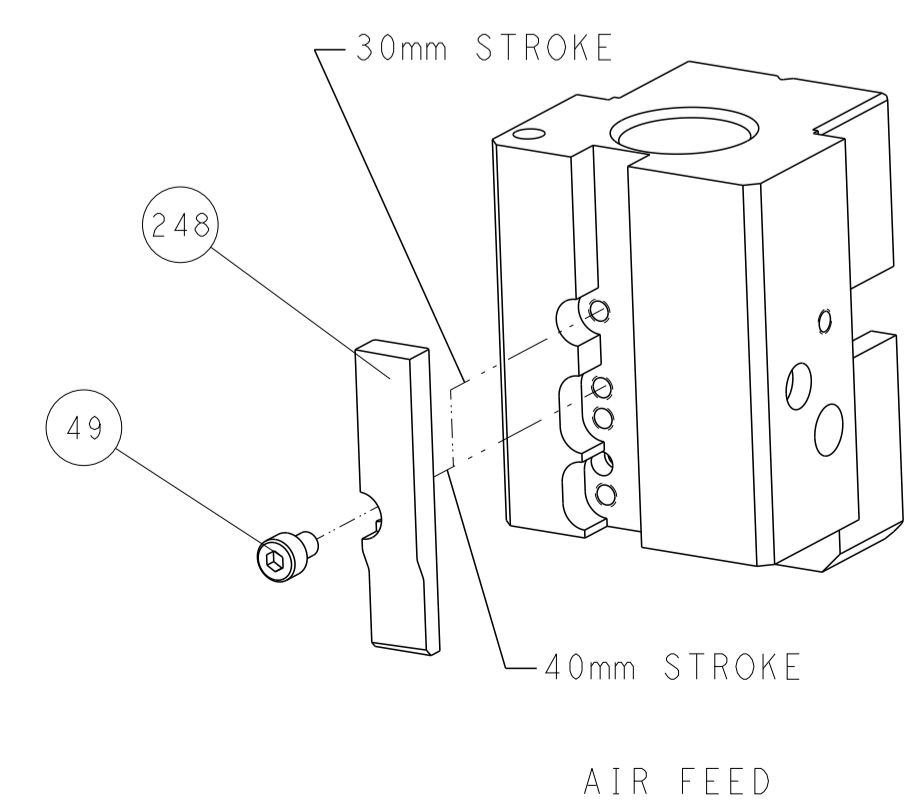


FEED TYPE

PNEUMATIC



CAM POSITION



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. KNEPPER 29MAY2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD M. CLIFFORD 29MAY2013		NAME Ocean End Feed Applicator	
Customer Accessible Production Drawing		SCALE 1:1		SIZE A1 00779 C=2150335		RESTRICTED TO	
				SHEET 2 OF 4		REV E	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150335-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1-1338683-0	5-18022-5	2119653-2	-	-
	2-2150335-7	E	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150335-7	D	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	SP
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS FLAG F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-5.30 mm [.169-.209 IN]		Ø1.90-3.30 mm [.075-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-64027	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178423-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.60 +/- 0.05 [.063 +/- .002]	7
18 AWG	1.45 +/- 0.05 [.057 +/- .002]	8.8
20 AWG	1.35 +/- 0.05 [.053 +/- .002]	10.1

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150335-4
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- TERMINAL DESIGN IS NOT COMPATIBLE WITH SERVO FEED OR MECHANICAL FEED.

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

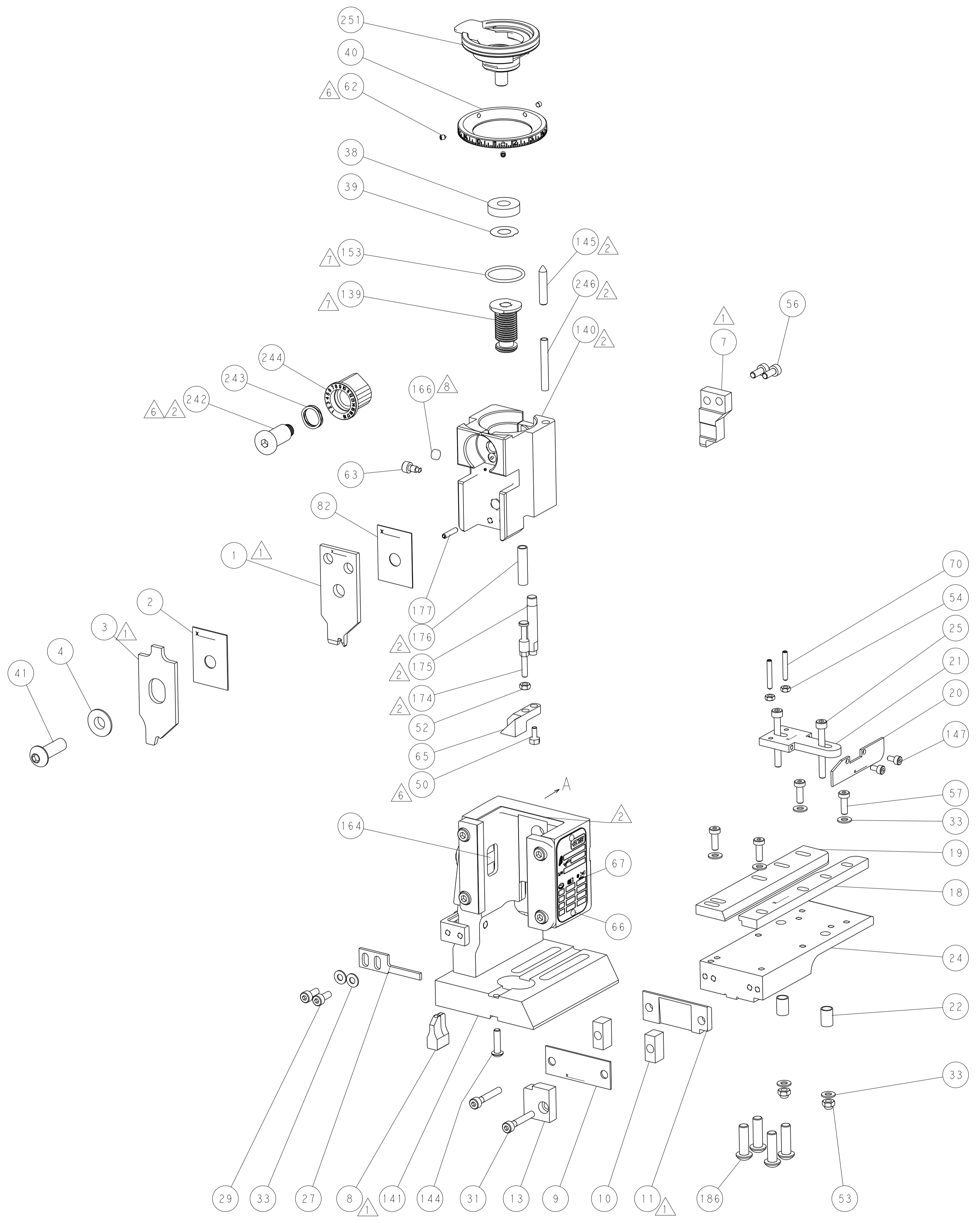
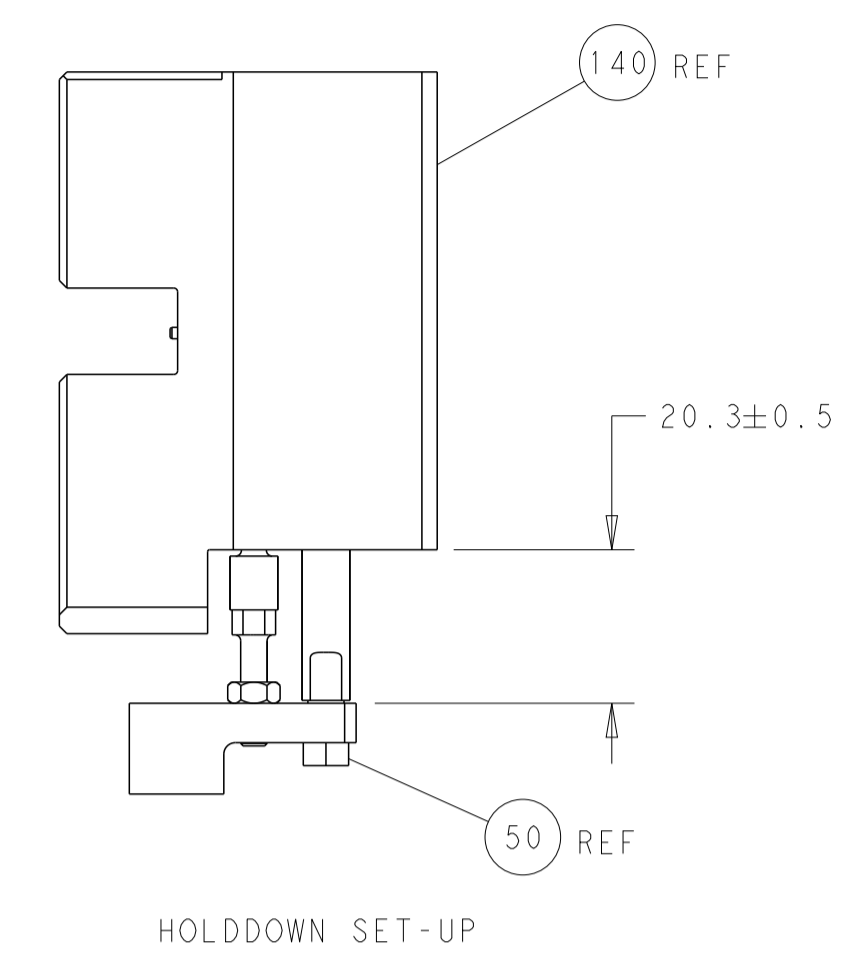
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

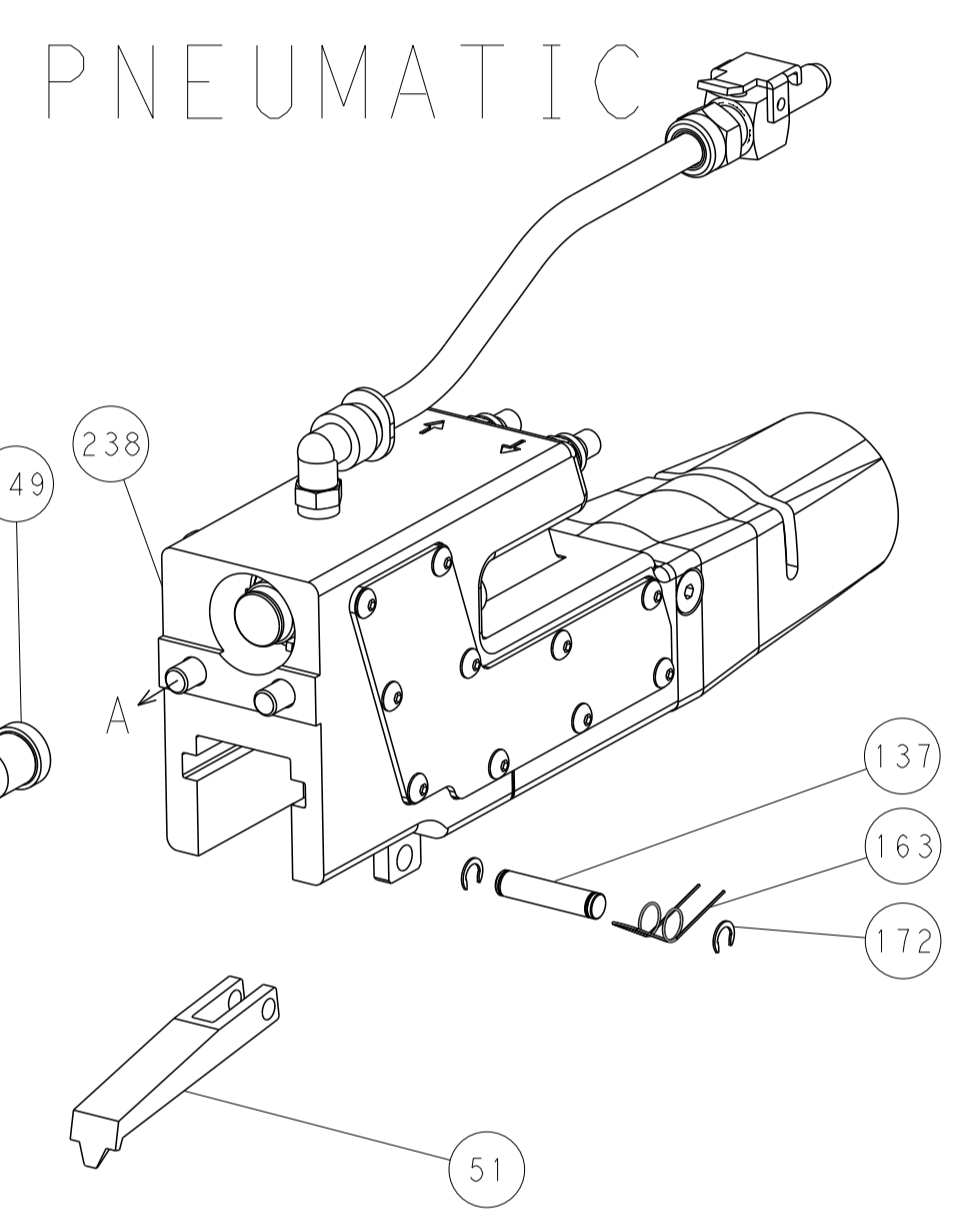
-	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251	
-	-	1	2119640-1	PUSH ROD, AIR FEED	250	
-	-	1	1803259-1	BUSHING, FLANGED	249	
-	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	2063440-1	AIR FEED MODULE	238	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175	
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174	
-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	-	1	240638-1	SPRING, FEED FINGER	163	
	-	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153	
-	-	1	2119641-2	FEED CAM, AIR FEED	152	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147	
-	1	1	2119798-2	DETENT PIN	145	
-	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140	
	-	1	2119092-2	BOLT, ADJUSTMENT	139	
-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	2119956-2	DOCUMENTATION PACKAGE	71	
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1803176-1	HOLDDOWN, TERMINAL	65	
-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
	-	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62	
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	-	1	2161920-3	NARROW PAWL, EF, AIR	51	
	-	1	3-1752354-8	STANDOFF,HOLD-DOWN	50	
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1-2119644-2	RAM WASHER, PRECISION	38	
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-	1	1	1-690455-0	STRIPPER, FRONT CASTING	27	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	2161922-1	PLATE, STRIP GUIDE	24	
-	2	2	22281-6	SPRING, COMPRESSION	22	
-	1	1	1633168-2	ARM, STOCK DRAG	21	
-	1	1	1-464452-7	DRAG, STOCK	20	
-	1	1	1803086-2	GUIDE, REAR STRIP	19	
-	1	1	3-1901695-3	STRIP GUIDE, FRONT	18	
-	1	1	1803175-1	SUPPORT, TERMINAL	13	
	-	1	461160-3	PLATE, REAR SHEAR	11	
	-	2	8-240645-6	SPACER, SHEAR PLATE	10	
	-	1	455961-5	PLATE, FRONT SHEAR	9	
	1	1	1-1803059-2	ANVIL, COMBINATION, END FEED	8	
	-	1	1803186-1	BLADE, SLUG	7	
-	-	-	-	-	6	
-	-	-	-	-	5	
-	1	1	3-238009-1	BLOCK, FL CRIMPER SPACER	4	
	1	1	1803108-5	CRIMPER, INSULATION O	3	
-	1	1	455888-6	SPACER, CRIMPER	2	
	1	1	1-1803015-4	CRIMPER, WIRE	1	
-	77	27	22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH	WEIGHT	SCALE	SHEET
MATERIAL				1:1	3 OF 4
Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 OF 4	

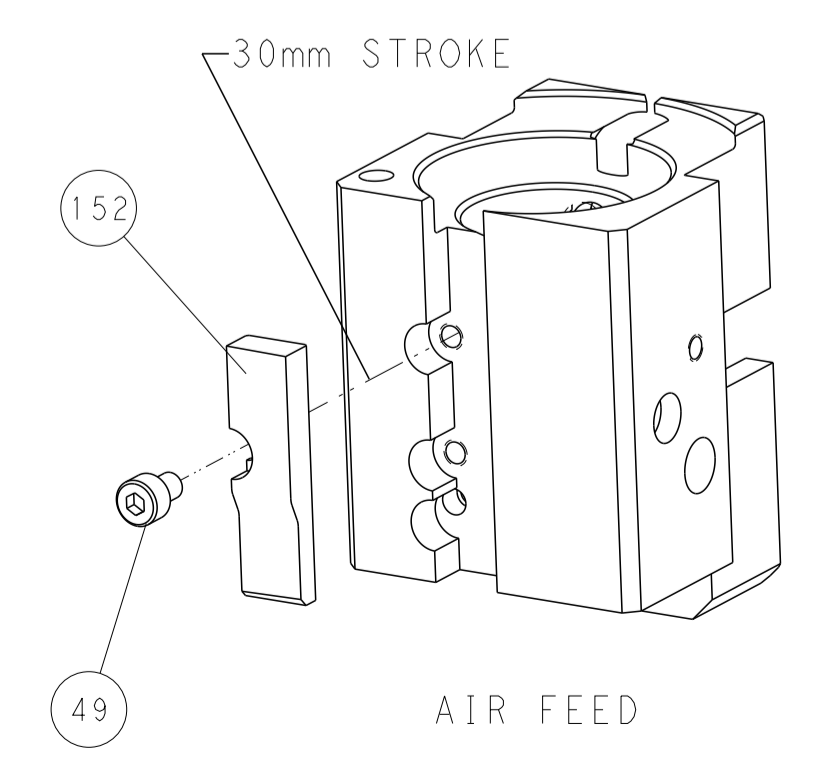
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



FEED TYPE



CAM POSITION



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: - SCALE: 1:1	RESTRICTED TO: SHEET 4 OF 4 REV E