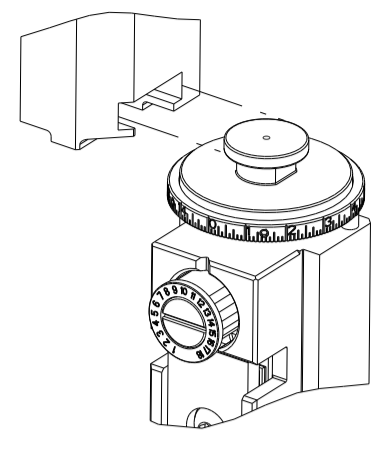


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2150087-1 | F | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2150087-2 | G | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150087-1 | F | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2150087-2 | G | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2150087-7 | D | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



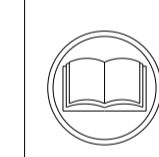
| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.29 mm [.090] | F |
| INSUL | 3.81 mm [.150] | F |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION | | | |
|---|-------------|------------------------------|-------------|
| TERMINAL NAME: 2.3DIA CLUSTER PIN RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.55-5.05 mm [.179-.199 IN] | | Ø2.00-3.40 mm [.079-.134 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-5235 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 170063-2 | 1-170063-2 | 5-170063-2 | 170063-9 |

| TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION | | | |
|---|-------------|------------------------------|-------------|
| TERMINAL NAME: 2.3DIA CLUSTER PIN RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.55-5.05 mm [.179-.199 IN] | | Ø2.00-3.40 mm [.079-.134 IN] | |
| TERMINAL APPLICATION SPECIFICATION | | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 170063-2 | 1-170063-2 | 5-170063-2 | 170063-9 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|----------------------------|--------------------------------|
| 16 AWG OR 1.25mm2 | 1.63+/-0.05 [.064+/- .002] | 7.7 |
| 18 AWG OR 0.85mm2 | 1.47+/-0.05 [.058+/- .002] | 9.2 |
| 20 AWG OR 0.50mm2 | 1.47+/-0.05 [.058+/- .002] | 9.2 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 1.0 mm2 | 1.52+/-0.05 [.060+/- .002] | 8.8 |



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

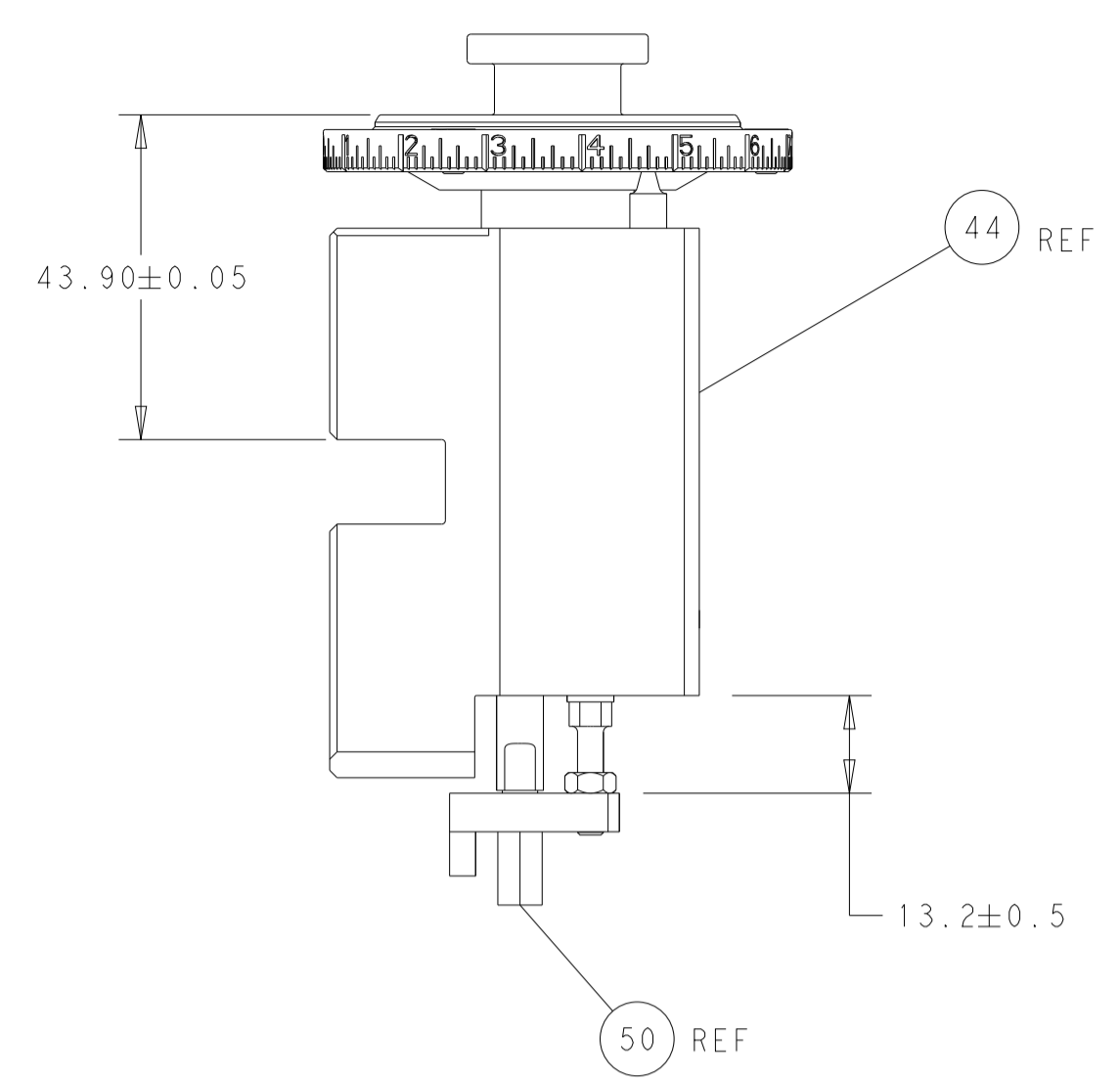
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | D | | ECR-17-011718 | 11AUG2017 | TB | CT |
| | | E | | ECR-18-014395 | 11SEP2018 | FZ | KZ |
| | | F | | ECR-19-008198 | 23MAY2019 | MZ | YY |
| | | G | | ECR-21-007147 | 04AUG2021 | FJ | RK |

| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-------------|---------|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | |
| - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 | |
| - | - | 1 | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 | |
| - | 1 | - | 1 | - | 2844940-3 | AIR FEED MODULE | 238 | |
| - | 1 | 1 | 1 | 1 | 1-18028-0 | WASHER, FLAT, REG M8 | 192 | |
| - | 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 | |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 | |
| - | 1 | 1 | 1 | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 | |
| - | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 18031-1 | SCR, SET, CUP POINT M3 X 5.0 | 75 | |
| - | 1 | 1 | 1 | 1 | 690191-5 | PLUG,NYLON | 74 | |
| - | 1 | 1 | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 73 | |
| - | 1 | 1 | 1 | 1 | 1333249-1 | PIN, FORMING | 72 | |
| - | 1 | 1 | 1 | 1 | 1803607-4 | DOCUMENTATION PACKAGE | 71 | |
| - | 2 | 2 | 2 | 2 | 2-18032-2 | SCR, SET, FLT PNT, M3 X 10.0 | 70 | |
| - | 1 | 1 | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 | |
| - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 | |
| - | 1 | 1 | 1 | 1 | 1-1901681-7 | HOLDDOWN, TERMINAL | 65 | |
| - | 2 | 2 | 2 | 2 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 64 | |
| - | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 60 | |
| - | - | 2 | - | 2 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | |
| - | - | 1 | - | 1 | 1-2063961-0 | FEED FINGER | 58 | |
| - | 3 | 3 | 3 | 3 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 | |
| - | 2 | 2 | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 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 | - | 1 | - | 1-2063961-0 | FEED FINGER | 51 | |
| - | 1 | 1 | 1 | 1 | 2-1752354-4 | STANDOFF, HOLD-DOWN | 50 | |
| - | 1 | 2 | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 | |
| - | - | 1 | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 | |
| - | - | 1 | - | 1 | 2119653-1 | FEED CAM, POST FEED | 47 | |
| - | 1 | 1 | 1 | 1 | 2119655-5 | APPLICATOR BASIC ASSEMBLY, EF | 46 | |
| - | 1 | 1 | 1 | 1 | 1803517-1 | RAM ASSEMBLY, EF ATLANTIC | 44 | |
| - | 1 | 1 | 1 | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 | |
| - | 7 | 7 | 7 | 7 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 | |
| - | 2 | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 31 | |
| - | 2 | 2 | 2 | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 29 | |
| - | 1 | 1 | 1 | 1 | 240639-2 | STRIPPER (MACHINING) | 27 | |
| - | 2 | 2 | 2 | 2 | 1-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 30 | 25 | |
| - | 1 | 1 | 1 | 1 | 2-1752371-3 | PLATE, STRIP GUIDE | 24 | |
| - | 1 | 1 | 1 | 1 | 240825-3 | PLATE, STRIP HOLD DOWN | 23 | |
| - | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 | |
| - | 1 | 1 | 1 | 1 | 1803292-4 | DRAG | 20 | |
| - | 2 | 2 | 2 | 2 | 1901259-7 | GUIDE, LOWER STRIP | 18 | |
| - | 4 | 4 | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 | |
| - | 1 | 1 | 1 | 1 | 1333248-1 | HOLDER, FORMING PIN | 16 | |
| - | 1 | 1 | 1 | 1 | 5-240641-9 | SPACER | 15 | |
| - | 1 | 1 | 1 | 1 | 1752360-1 | SPACER,HOLD-DOWN | 13 | |
| - | 1 | 1 | 1 | 1 | 240833-4 | PLATE, REAR SHEAR | 11 | |
| - | 2 | 2 | 2 | 2 | 2-240645-7 | SPACER, SHEAR PLATE | 10 | |
| - | 1 | 1 | 1 | 1 | 690796-2 | PLATE-FRONT SHEAR MINI APPLICATOR | 9 | |
| - | 1 | 2 | 2 | 1 | 1633387-5 | ANVIL, COMBINATION | 8 | |
| - | 1 | 1 | 1 | 1 | 8-240651-6 | BLADE, SLUG | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 4-240641-3 | SPACER | 5 | |
| - | 1 | 1 | 1 | 1 | 238011-4 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 2 | 2 | 1 | 7-1633961-7 | CRIMPER, INSULATION F PREMIUM | 3 | |
| - | 1 | 1 | 1 | 1 | 455888-2 | SPACER, CRIMPER | 2 | |
| - | 1 | 2 | 2 | 1 | 2-456406-3 | CRIMPER, WIRE PREMIUM | 1 | |
| - | 77 | 72 | 71 | 2 | -1 | PART NO | DESCRIPTION | ITEM NO |

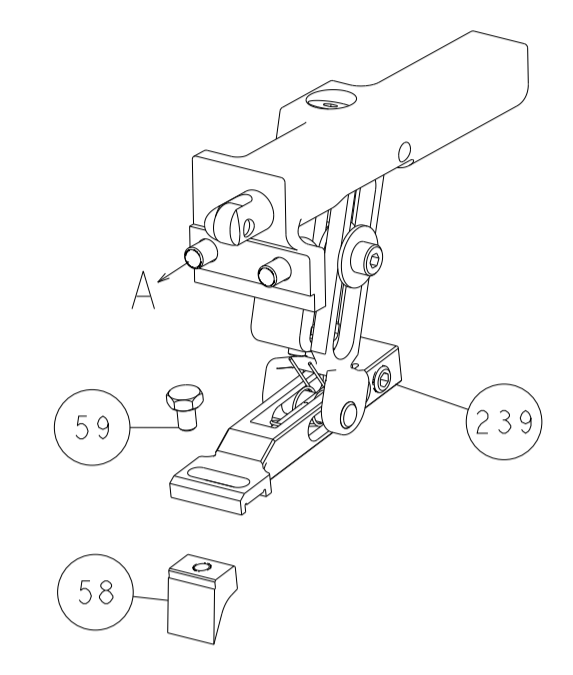
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|--|----------|--|---------|------------------------|---------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± |
| | ANGLES ± | FINISH ± | | | |
| DWG: Y. YIN 28NOV2013 | | CHK: G. BAILEY 28NOV2013 | | APVD: U. GUO 28NOV2013 | |
| NAME: Ocean End Feed Applicator | | SIZE: A1 | | CAGE CODE: 00779 | |
| DRAWING NO: 2150087 | | SCALE: 1:1 | | SHEET 1 OF 4 | |
| Customer Accessible Production Drawing | | REV: G | | | |

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

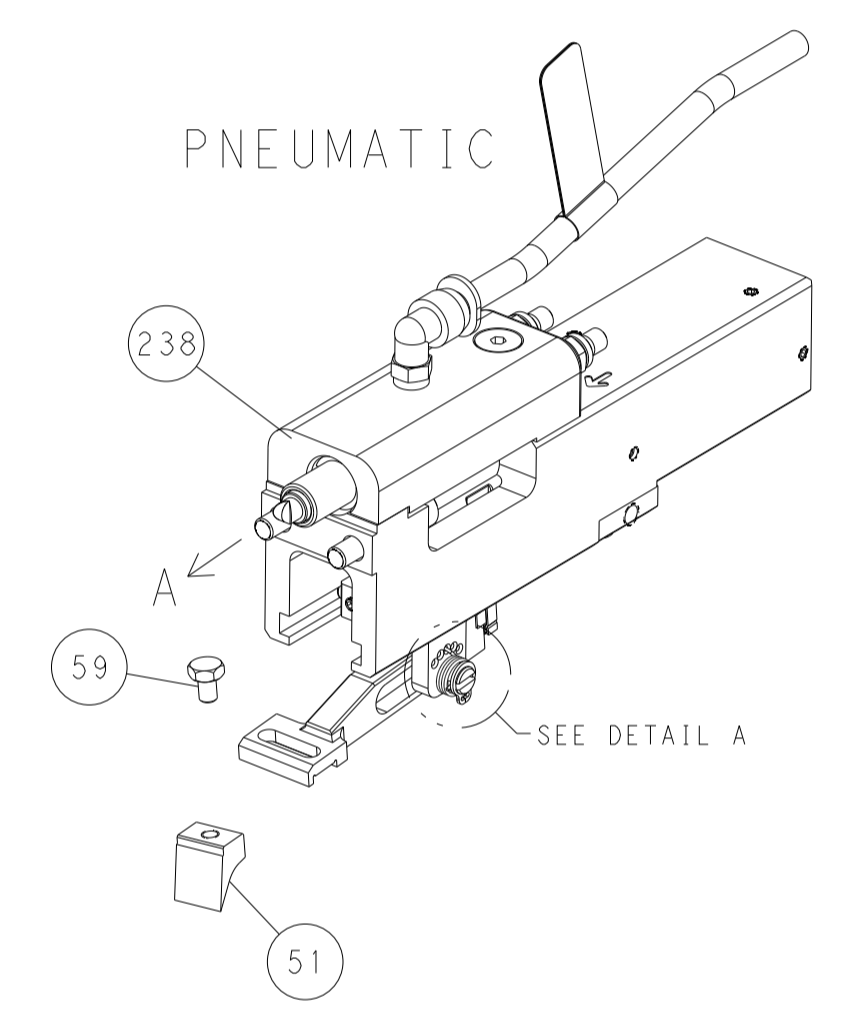


RAM AND HOLDDOWN SET-UP

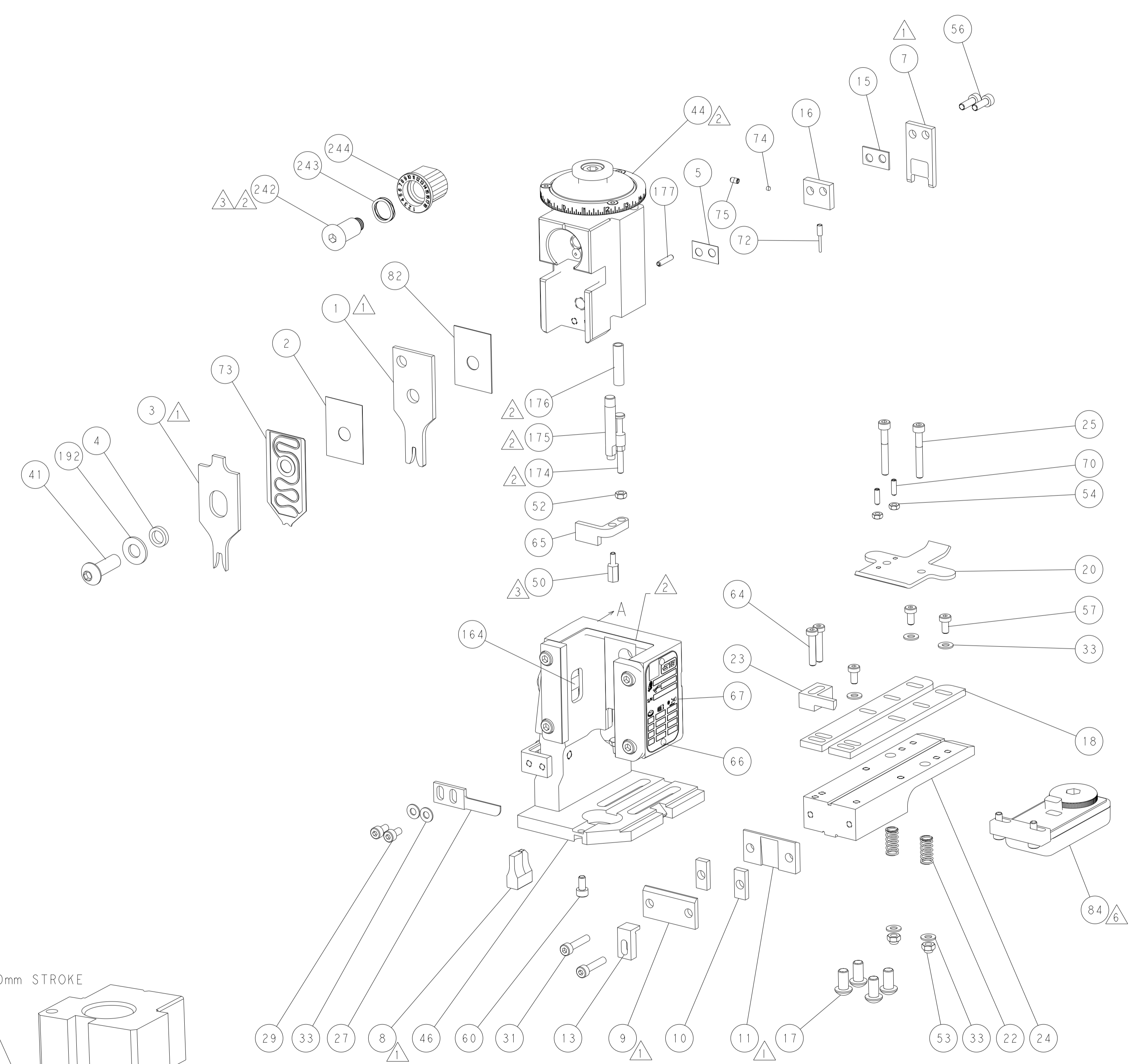
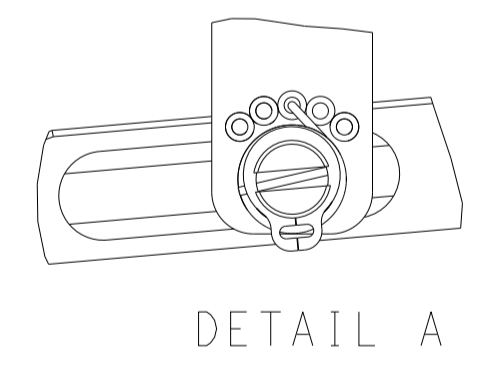
FEED TYPE
MECHANICAL



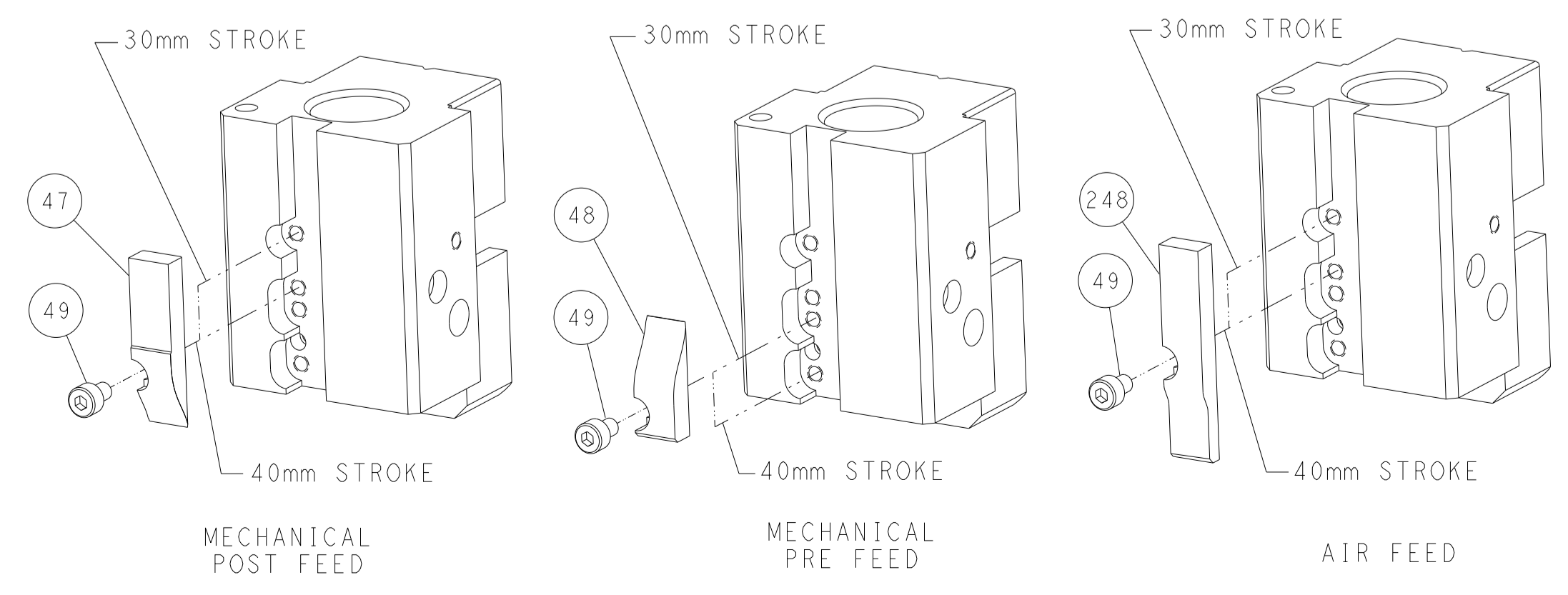
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

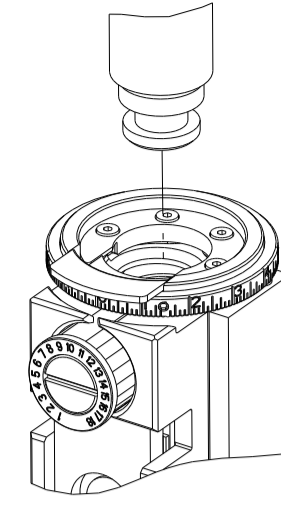


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | | |
|-----------------------|--|---|--|--|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | | DWN Y. YIN 28NOV2013 CHK G. BAILEY 28NOV2013 APVD U. GUO 28NOV2013 NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A 00779 C-2150087 Customer Accessible Production Drawing SCALE 1:1 SHEET 2 OF 4 REV G | |
|-----------------------|--|---|--|--|--|

| 8 | 7 | 6 | 5 | 4 | 3 | 2 | 1 |
|--|----------|--------------------------|------------|----|---|---|---|
| THIS DRAWING IS UNPUBLISHED. | | RELEASED FOR PUBLICATION | | 20 | | | |
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| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | | | | |
| 2-2150087-1 | F | FINE CRIMP HEIGHT ADJUST | MECHANICAL | | | | |
| 2-2150087-2 | G | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | | | | |
| 7-2150087-7 | D | CRIMP TOOLING KIT | - | | | | |

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.29 mm [.090] | F |
| INSUL | 3.81 mm [.150] | F |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: 2.3DIA CLUSTER PIN RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.55-5.05 mm [.179-.199 IN] | | Ø2.00-3.40 mm [.079-.134 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-5235 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 170063-2 | 1-170063-2 | 5-170063-2 | 170063-9 |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: 2.3DIA CLUSTER PIN RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.55-5.05 mm [.179-.199 IN] | | Ø2.00-3.40 mm [.079-.134 IN] | |
| TERMINAL APPLICATION SPECIFICATION | | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 170063-2 | 1-170063-2 | 5-170063-2 | 170063-9 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|-------------------------------|--------------------------------|
| 16 AWG OR 1.25mm2 | 1.63 +/- 0.05 [.064 +/- .002] | 7.7 |
| 18 AWG OR 0.85mm2 | 1.47 +/- 0.05 [.058 +/- .002] | 9.2 |
| 20 AWG OR 0.50mm2 | 1.47 +/- 0.05 [.058 +/- .002] | 9.2 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 1.00 mm2 | 1.52 +/- 0.05 [.060 +/- .002] | 8.8 |



- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
 - 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.
 - THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
 - TERMINAL LUBRICANT IS RECOMMENDED.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

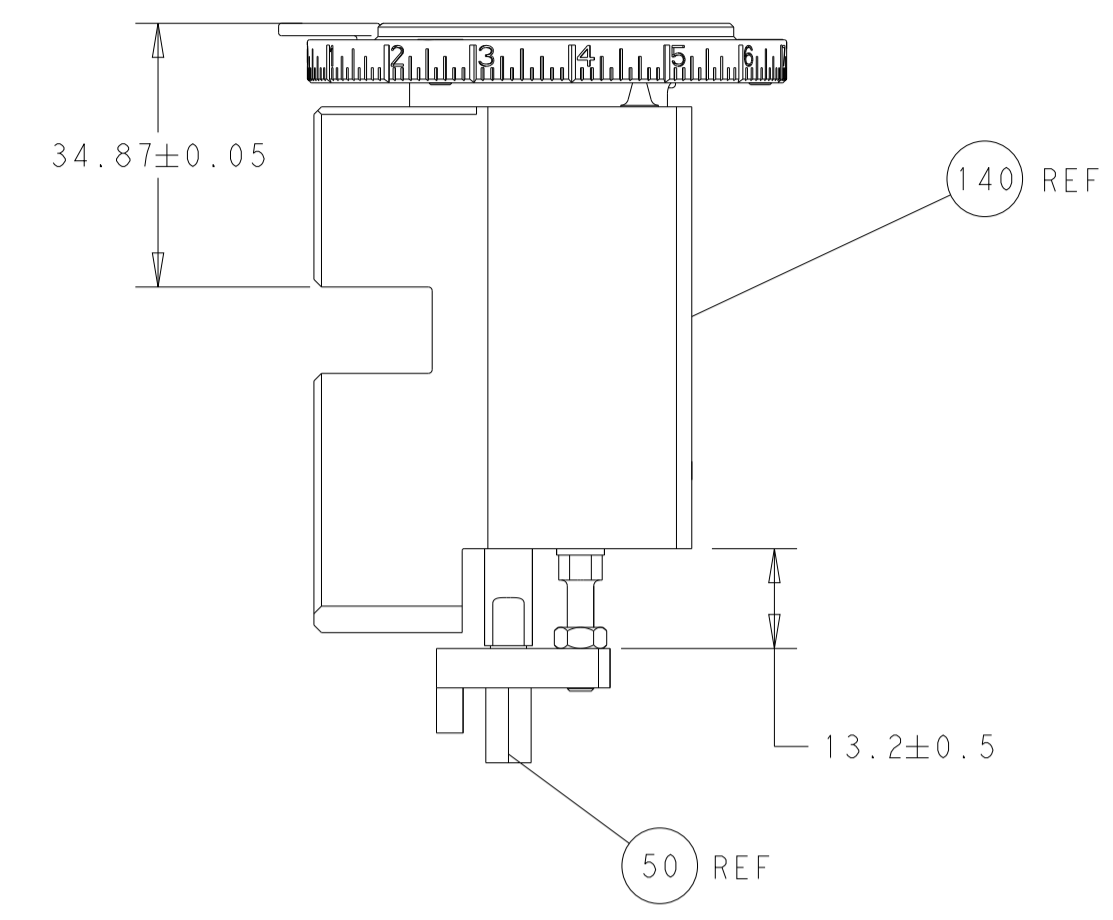
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

| LOC | | DIST | | REVISIONS | | | |
|-----|----------|------|-----|-------------|-------------------------------------|-----|---------|
| A | 66 | P | LYN | DESCRIPTION | DATE | OWN | APVD |
| - | - | - | - | SEE SHEET 1 | - | - | - |
| - | 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 | | 2119580-1 | MECHANICAL FEED ASSEMBLY | | 239 |
| - | 1 | - | | 2844940-3 | AIR FEED MODULE | | 238 |
| - | 1 | 1 | | 1-18028-0 | WASHER, FLAT, REG M8 | | 192 |
| - | 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 |
| - | REF | REF | | 994970-2 | COUNTER, MAGNETIC | | 164 |
| - | 1 | - | | 2119641-2 | FEED CAM, AIR FEED | | 152 |
| - | 1 | 1 | | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | | 144 |
| - | - | 1 | | 2119653-2 | FEED CAM, POST FEED | | 142 |
| - | 1 | 1 | | 2119655-6 | APPLICATOR BASIC ASSEMBLY, EF | | 141 |
| - | 1 | 1 | | 1803518-1 | RAM ASSEMBLY, EF PACIFIC | | 140 |
| | - | 1 | | 2119955-2 | ASSY, LUBRICATOR, END FEED | | 84 |
| - | 1 | 1 | | 455888-5 | SPACER, CRIMPER | | 82 |
| - | 1 | 1 | | 18031-1 | SCR, SET, CUP POINT M3 X 5.0 | | 75 |
| - | 1 | 1 | | 690191-5 | PLUG,NYLON | | 74 |
| - | 1 | 1 | | 2119791-9 | DEPRESSOR, WIRE | | 73 |
| - | 1 | 1 | | 1333249-1 | PIN, FORMING | | 72 |
| - | 1 | 1 | | 1803607-4 | DOCUMENTATION PACKAGE | | 71 |
| - | 2 | 2 | | 2-18032-2 | SCR, SET, FLT PNT, M3 X 10.0 | | 70 |
| - | 1 | 1 | | 2119740-1 | TAG,IDENTIFICATION | | 67 |
| - | 2 | 2 | | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | | 66 |
| - | 1 | 1 | | 1-1901681-7 | HOLDDOWN, TERMINAL | | 65 |
| - | 2 | 2 | | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | | 64 |
| - | - | 2 | | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | | 59 |
| - | - | 1 | | 1-2063961-0 | FEED FINGER | | 58 |
| - | 3 | 3 | | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | | 57 |
| - | 2 | 2 | | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | | 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 |
| | - | - | | 1-2063961-0 | FEED FINGER | | 51 |
| - | 1 | 1 | | 2-1752354-4 | STANDOFF,HOLD-DOWN | | 50 |
| - | 1 | 2 | | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | | 49 |
| - | - | 1 | | 2119652-1 | FEED CAM, PRE FEED | | 48 |
| - | 1 | 1 | | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | | 41 |
| - | 7 | 7 | | 1-18028-2 | WASHER, FLAT, REG M4 | | 33 |
| - | 2 | 2 | | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | | 31 |
| - | 2 | 2 | | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | | 29 |
| - | 1 | 1 | | 240639-2 | STRIPPER (MACHINING) | | 27 |
| - | 2 | 2 | | 1-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 30 | | 25 |
| - | 1 | 1 | | 2-1752371-3 | PLATE, STRIP GUIDE | | 24 |
| - | 1 | 1 | | 240825-3 | PLATE, STRIP HOLD DOWN | | 23 |
| - | 2 | 2 | | 2-22281-3 | SPRING, COMPRESSION | | 22 |
| - | 1 | 1 | | 1803292-4 | DRAG | | 20 |
| - | 2 | 2 | | 1901259-7 | GUIDE, LOWER STRIP | | 18 |
| - | 1 | 1 | | 1333248-1 | HOLDER, FORMING PIN | | 16 |
| - | 1 | 1 | | 5-240641-9 | SPACER | | 15 |
| | - | 1 | | 1752360-1 | SPACER,HOLD-DOWN | | 13 |
| - | 1 | 1 | | 240833-4 | PLATE, REAR SHEAR | | 11 |
| | - | 2 | | 2-240645-7 | SPACER, SHEAR PLATE | | 10 |
| | - | 1 | | 690796-2 | PLATE-FRONT SHEAR MINI APPLICATOR | | 9 |
| | 1 | 1 | | 1633387-5 | ANVIL, COMBINATION | | 8 |
| | - | 1 | | 8-240651-6 | BLADE, SLUG | | 7 |
| - | - | - | | - | - | | 6 |
| - | 1 | 1 | | 4-240641-3 | SPACER | | 5 |
| - | 1 | 1 | | 238011-4 | BLOCK, CRIMPER SPACER | | 4 |
| | 1 | 1 | | 7-1633961-7 | CRIMPER, INSULATION F PREMIUM | | 3 |
| - | 1 | 1 | | 455888-2 | SPACER, CRIMPER | | 2 |
| | 1 | 1 | | 2-456406-3 | CRIMPER, WIRE PREMIUM | | 1 |
| - | 77-22-21 | | | PART NO | DESCRIPTION | | ITEM NO |

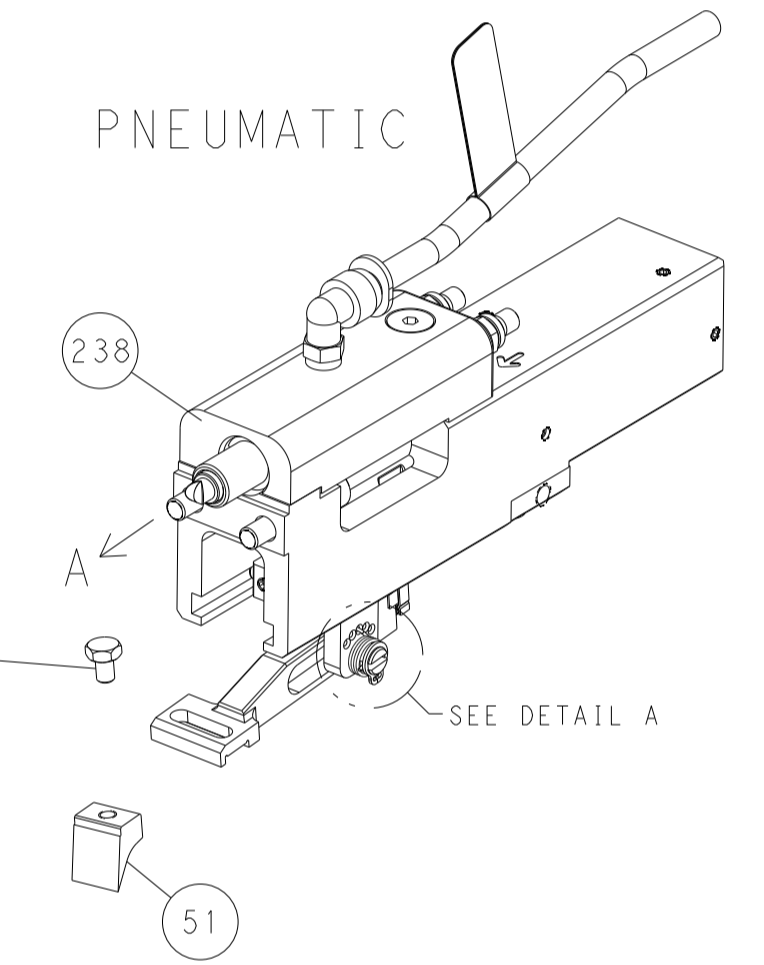
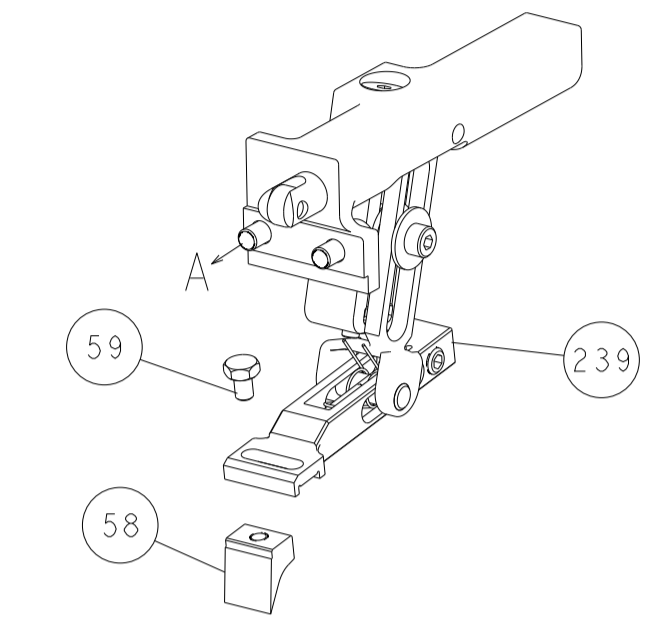
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|-------------|--|--|--|-----------|--|-----------|--|------------------|--|---------------------------|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG | | CHK | | APVD | | NAME | |
| mm | | 0 PLC ± | | Y. YIN | | 28NOV2013 | | G. BAILEY | | TE Connectivity | |
| | | 1 PLC ± | | G. BAILEY | | 28NOV2013 | | U. GUO | | Harrisburg, PA 17105-3608 | |
| | | 2 PLC ± | | U. GUO | | 28NOV2013 | | PRODUCT SPEC | | Ocean End Feed | |
| | | 3 PLC ± | | APVD | | | | APPLICATION SPEC | | Applicator | |
| | | 4 PLC ± | | MATERIAL | | | | SIZE | | RESTRICTED TO | |
| | | ANGLES | | FINISH | | | | CAGE CODE | | DRAWING NO | |
| | | | | | | | | A1 | | 00779 | |
| | | | | | | | | DRAWING NO | | 2150087 | |
| | | | | | | | | SCALE | | SHEET 3 OF 4 | |
| | | | | | | | | REV | | G | |

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

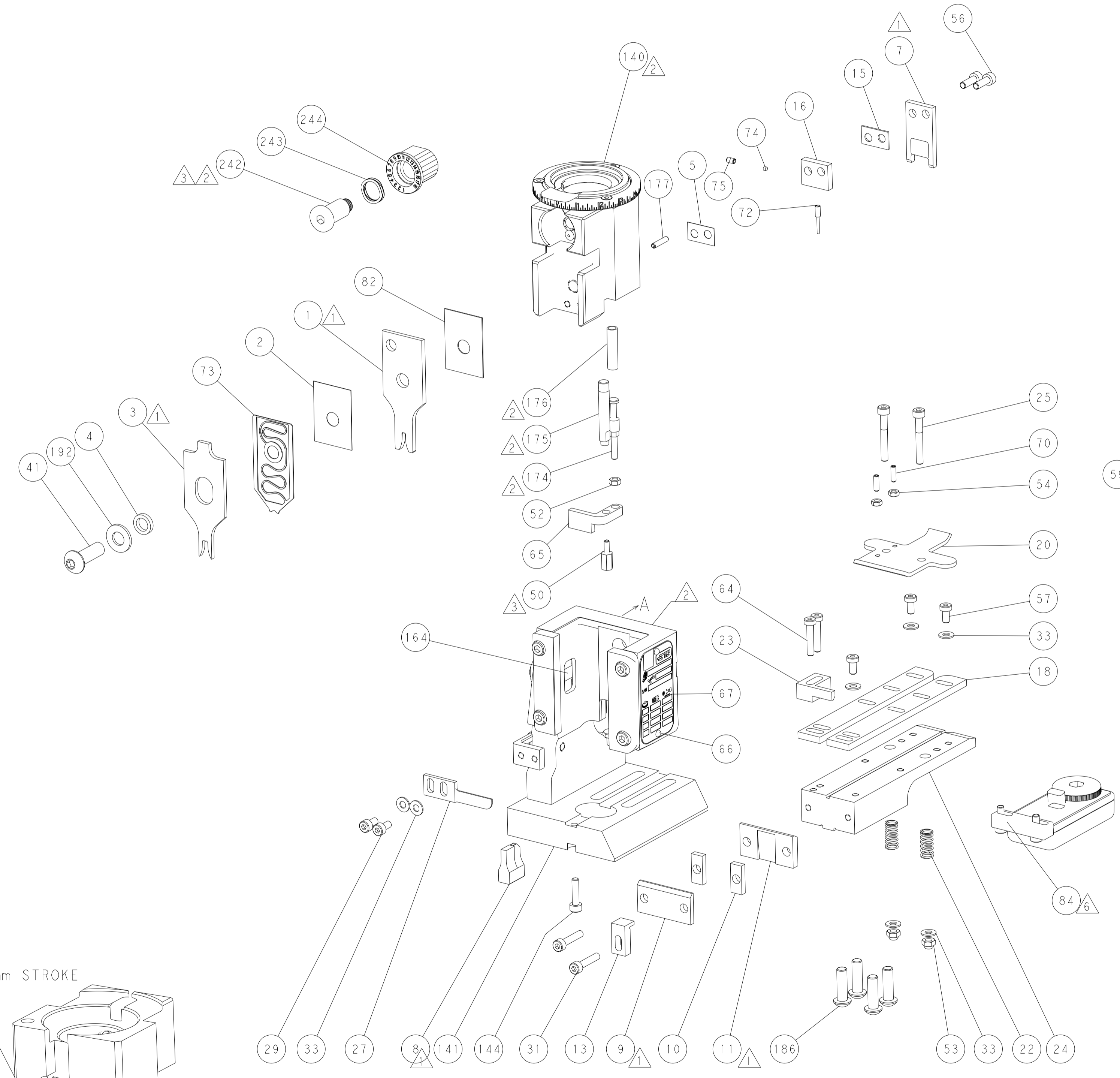
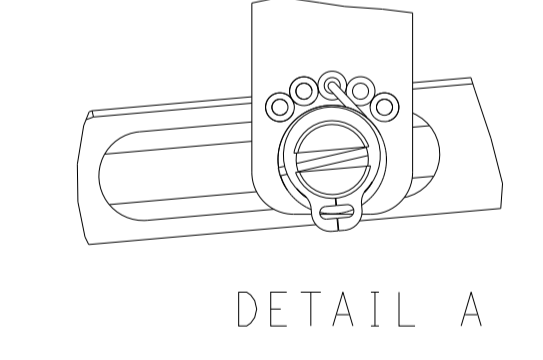


RAM AND HOLDDOWN SET-UP

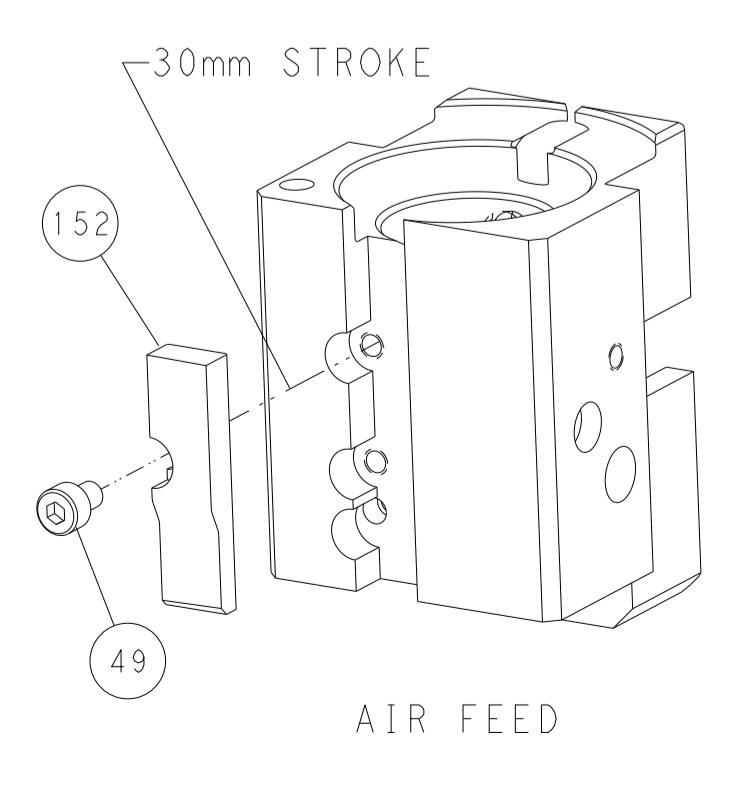
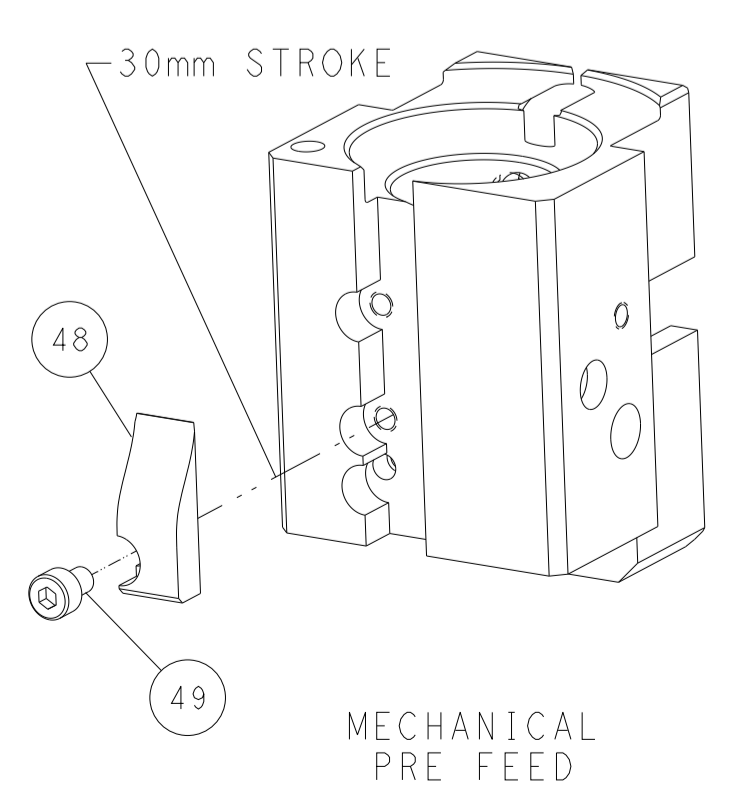
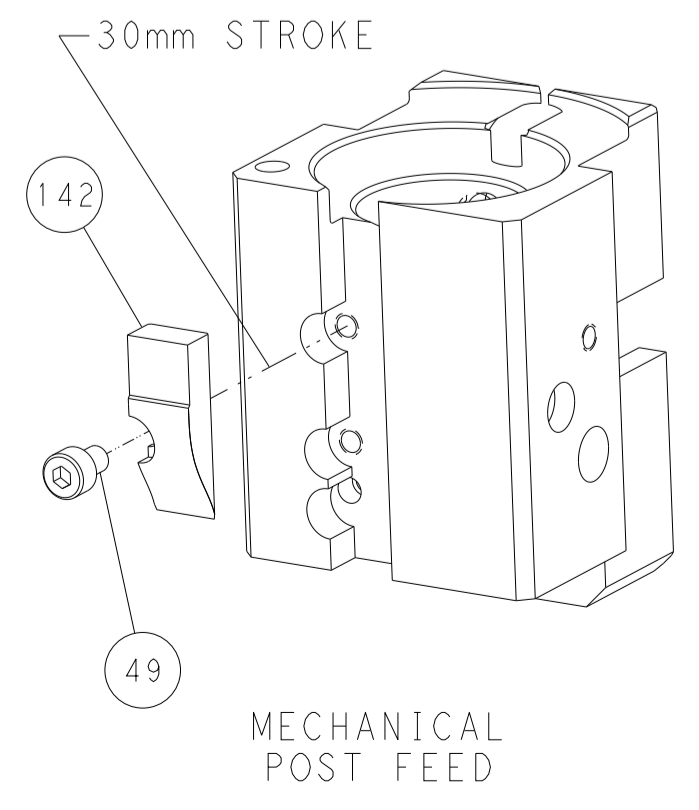
FEED TYPE
MECHANICAL



FEED SPRING
SETTING POSITION



CAM POSITIONS



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

| | | | | | | | | | | | | | |
|-------------|---------|--|---------|----------------------|---------|-------------------------|--------|-----------------------|------------------|-------|-----------|---|---------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG Y. YIN 28NOV2013 | | CHK G. BAILEY 28NOV2013 | | APVD U. GUO 28NOV2013 | | NAME | | STE TE Connectivity Harrisburg, PA 17105-3608 | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES ± | FINISH | PRODUCT SPEC | APPLICATION SPEC | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| MATERIAL | | | | | | | | WEIGHT | A 00779 | SCALE | 1:1 | SHEET 4 OF 4 | REV G |