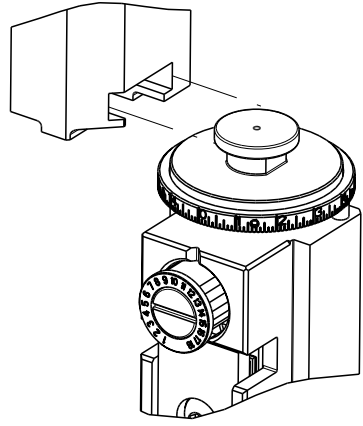


|                              |          |                                                       |           |
|------------------------------|----------|-------------------------------------------------------|-----------|
| 8                            |          | 7                                                     |           |
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| PART NUMBER                  | REVISION | DESCRIPTION                                           | FEED TYPE |
| 2150020-2                    | D        | FINE CRIMP HEIGHT ADJUST                              | PNEUMATIC |
| 7-2150020-2                  | D        | PNEUMATIC AND CRIMP TOOLING KIT                       | PNEUMATIC |
| 7-2150020-7                  | A        | CRIMP TOOLING KIT                                     | -         |

ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 3.30 mm [.130] | F    |
| INSUL                                | 4.06 mm [.160] | F    |
| APPLICATOR INSTRUCTIONS<br>408-35043 |                |      |

|                                                  |  |                                                           |  |
|--------------------------------------------------|--|-----------------------------------------------------------|--|
| TERMINAL DATA: TE TERMINAL                       |  | TE CRIMP SPECIFICATION                                    |  |
| TERMINAL NAME: RING TONGUE                       |  |                                                           |  |
| WIRE STRIP LENGTH<br>4.82-5.58 mm [.190-.220 IN] |  | INSULATION DIAMETER RANGE<br>Ø2.16-3.60 mm [.085-.142 IN] |  |
| TERMINAL APPLICATION SPECIFICATION               |  |                                                           |  |
| 114-37010                                        |  |                                                           |  |
| TERMINALS APPLIED                                |  |                                                           |  |
| TE TERMINAL                                      |  | TE TERMINAL                                               |  |
| 626034-1                                         |  | 626034-4                                                  |  |

|           |  |                             |  |                                   |
|-----------|--|-----------------------------|--|-----------------------------------|
| WIRE SIZE |  | CRIMP HEIGHT<br>mm [INCH]   |  | CRIMP HEIGHT<br>REFERENCE SETTING |
| 2.50mm2   |  | 2.41+/-0.05 [1.095+/- .002] |  | 8.3                               |
| 2.00mm2   |  | 2.29+/-0.05 [1.090+/- .002] |  | 9.1                               |
| 1.50mm2   |  | 2.18+/-0.05 [1.086+/- .002] |  | 10.1                              |
| 1.00mm2   |  | 2.05+/-0.05 [1.081+/- .002] |  | 11.4                              |



- 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 ITEMS 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FE7D.

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)

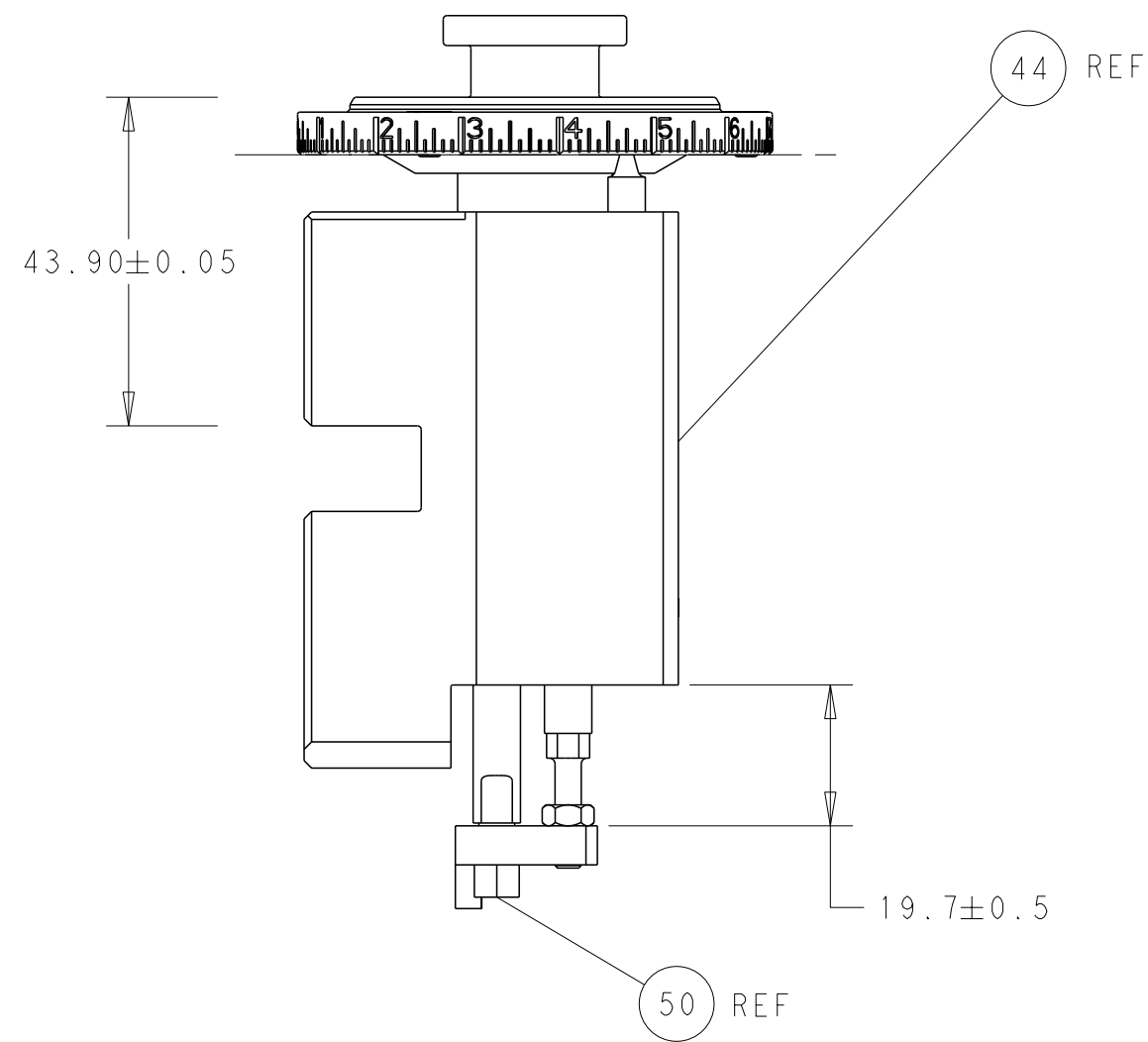
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| 2   |      | 1         |     |               |           |     |      |  |
| LOC | DIST | REVISIONS |     |               |           |     |      |  |
| A   | 66   | P         | LYR | DESCRIPTION   | DATE      | DWN | APVD |  |
|     |      |           | A   | RELEASED      | 28FEB2012 | CC  | SX   |  |
|     |      |           | B   | ECR-13-015279 | 28SEP2013 | KH  | TE   |  |
|     |      |           | C   | ECR-17-010758 | 25JUL2017 | MZ  | KZ   |  |
|     |      |           | D   | ECR-19-019276 | 11DEC2019 | FJ  | TE   |  |

|   |        |     |     |             |                                     |         |
|---|--------|-----|-----|-------------|-------------------------------------|---------|
|   | -      | 1   | 1   | 2119641-1   | FEED CAM, AIR FEED                  | 248     |
|   | -      | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
|   | -      | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| 3 | -      | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
|   | -      | 1   | 1   | 2844940-4   | AIR FEED MODULE                     | 238     |
|   | -      | 1   | 1   | 1-18028-0   | WASHER, FLAT, REG M8                | 192     |
|   | -      | 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     |
| 5 | -      | 1   | 1   | 2119955-2   | ASSY, LUBRICATOR, END FEED          | 84      |
|   | -      | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82      |
|   | -      | 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   | 1901681-1   | HOLDDOWN, TERMINAL                  | 65      |
|   | -      | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 60      |
|   | -      | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
|   | -      | 4   | 4   | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8        | 57      |
|   | -      | 2   | 2   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 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   | 1   | 2063961-9   | FEED FINGER                         | 51      |
| 3 | -      | 1   | 1   | 1752354-2   | STANDOFF,HOLD-DOWN                  | 50      |
|   | -      | 1   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
|   | -      | 1   | 1   | 2119655-5   | APPLICATOR BASIC ASSEMBLY, EF       | 46      |
|   | -      | 1   | 1   | 1803517-1   | RAM ASSEMBLY, EF ATLANTIC           | 44      |
|   | -      | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
|   | -      | 8   | 8   | 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   | 240639-1    | STRIPPER (MACHINING)                | 27      |
|   | -      | 2   | 2   | 1-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 30      | 25      |
|   | -      | 1   | 1   | 1-1752371-2 | PLATE, STRIP GUIDE                  | 24      |
|   | -      | 2   | 2   | 2-22281-3   | SPRING, COMPRESSION                 | 22      |
|   | -      | 1   | 1   | 1803292-4   | DRAG                                | 20      |
|   | -      | 1   | 1   | 1-1901696-0 | STRIP GUIDE, REAR                   | 19      |
|   | -      | 1   | 1   | 1-1901695-0 | STRIP GUIDE, FRONT                  | 18      |
|   | -      | 4   | 4   | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12)           | 17      |
|   | -      | 1   | 1   | 1-240641-0  | SPACER                              | 16      |
|   | -      | 1   | 1   | 1752360-1   | SPACER,HOLD-DOWN                    | 13      |
| 1 | -      | 1   | 1   | 240644-5    | PLATE, REAR SHEAR                   | 11      |
|   | -      | -   | -   | -           | -                                   | 10      |
| 1 | -      | 1   | 1   | 3-690482-4  | PLATE, FRONT SHEAR                  | 9       |
| 1 | 1      | 2   | 1   | 1-1333221-3 | ANVIL, EF .130                      | 8       |
| 1 | -      | 1   | 1   | 2217206-4   | BLADE, SLUG                         | 7       |
|   | -      | 1   | 1   | 7-240641-5  | SPACER                              | 5       |
|   | -      | 1   | 1   | 238011-2    | BLOCK, CRIMPER SPACER               | 4       |
| 1 | 1      | 2   | 1   | 3-2119582-4 | CRIMPER, INSULATION F PREMIUM       | 3       |
|   | -      | 1   | 1   | 1-455888-1  | SPACER, CRIMPER                     | 2       |
| 1 | 1      | 2   | 1   | 456424-9    | CRIMPER, WIRE PREMIUM               | 1       |
|   | -77-72 | -2  |     | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                                                 |  |                                                      |                                              |                 |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------|----------------------------------------------|-----------------|
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| DIMENSIONS:<br>mm                                                                                                                                                               |  | CHK<br>S. XI<br>23DEC2011                            | NAME<br>Ocean End Feed<br>Applicator         |                 |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±                                                                       |  | APVD<br>J. CRUZ<br>23DEC2011                         | SIZE<br>A1                                   |                 |
| MATERIAL<br>-                                                                                                                                                                   |  | PRODUCT SPEC<br>APPLICATION SPEC<br>-<br>WEIGHT<br>- | CAGE CODE<br>00779                           |                 |
| FINISH<br>-                                                                                                                                                                     |  | Customer Accessible Production Drawing               | SCALE<br>1:1                                 | SHEET<br>1 OF 4 |
|                                                                                                                                                                                 |  | REV<br>D                                             |                                              |                 |

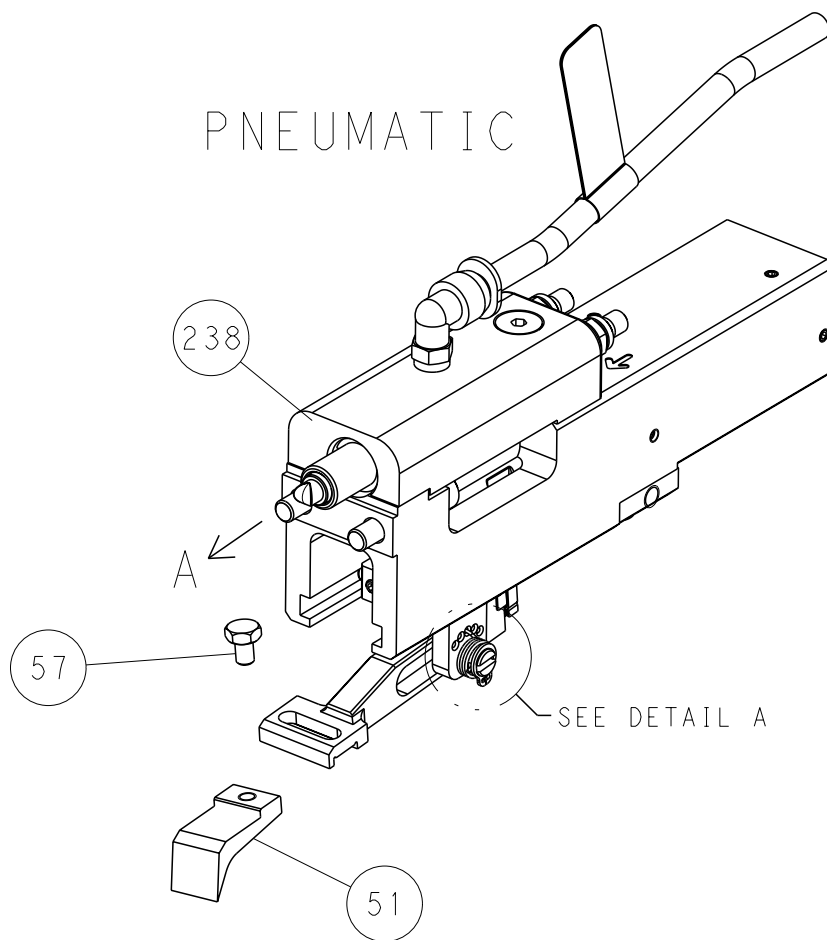
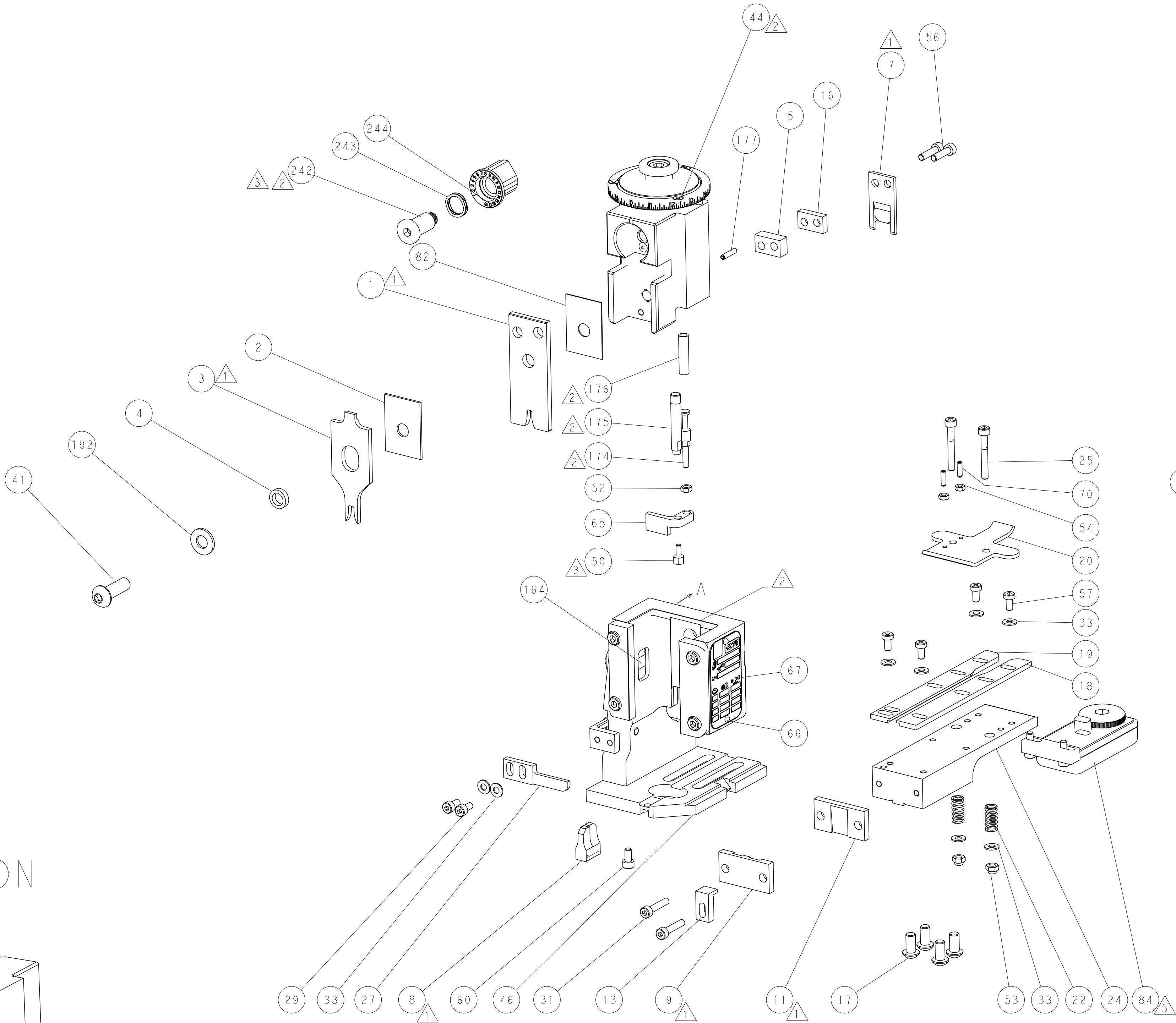
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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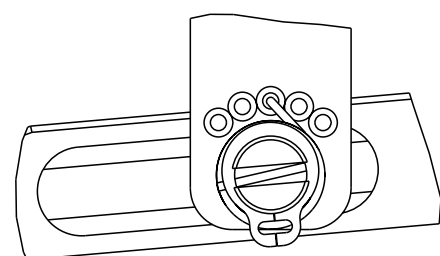


RAM AND HOLDDOWN SET-UP

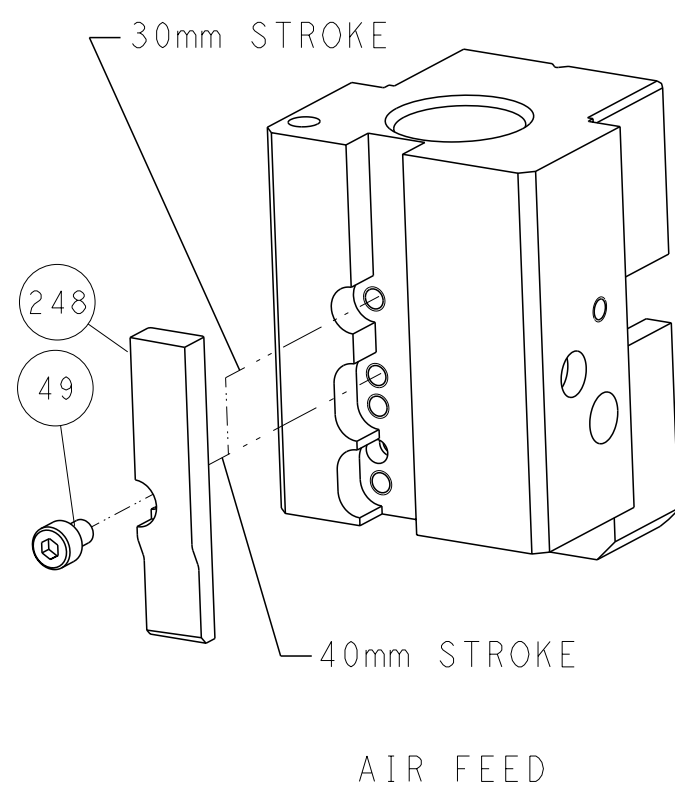
FEED TYPE



FEED SPRING  
SETTING POSITION



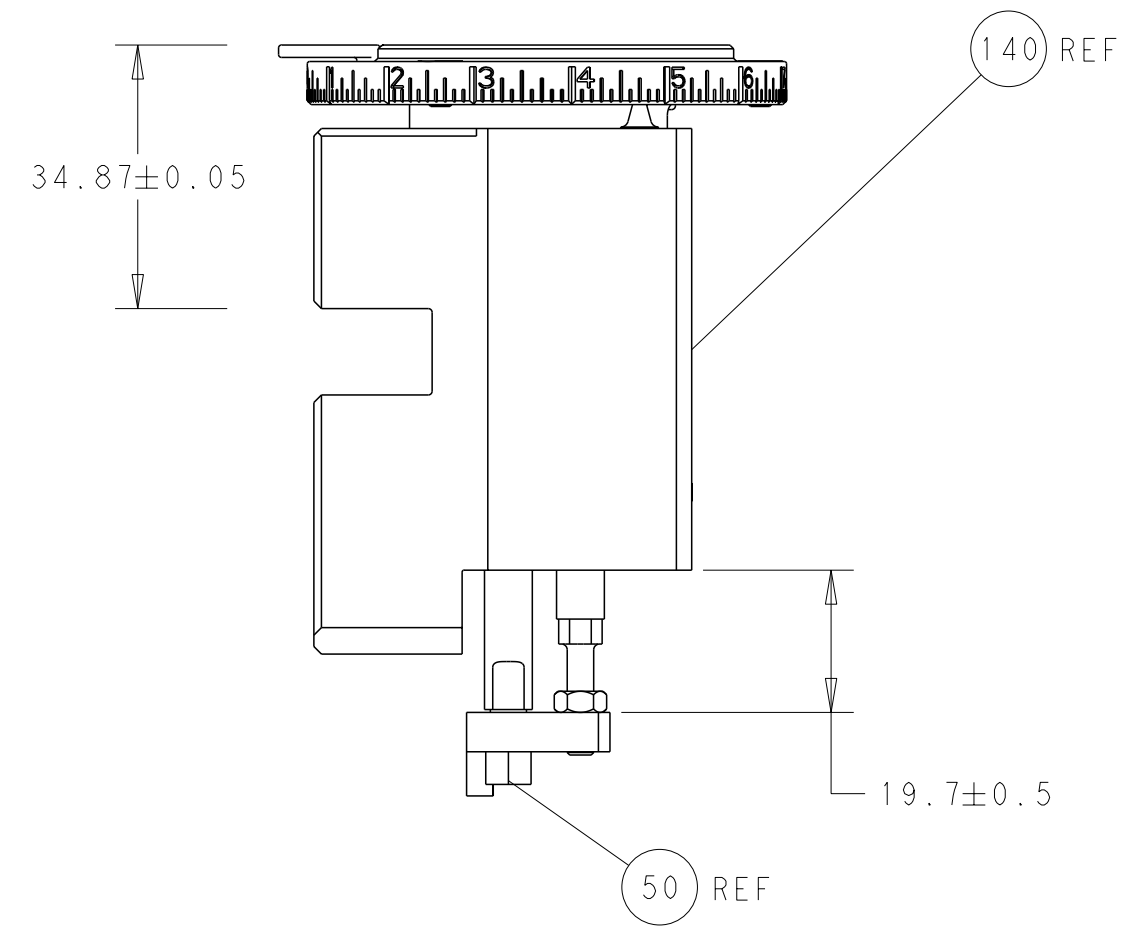
CAM POSITION



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

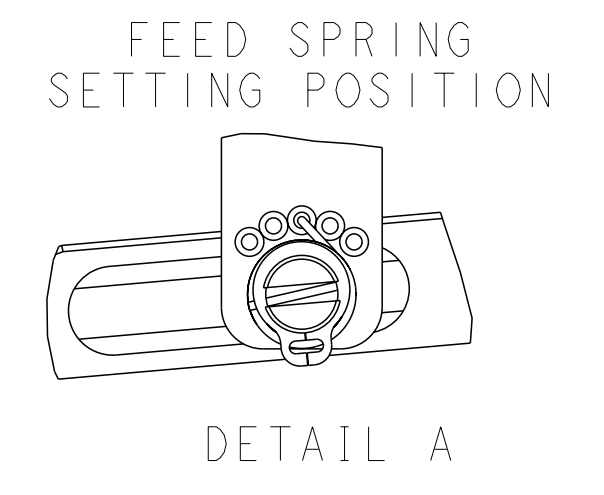
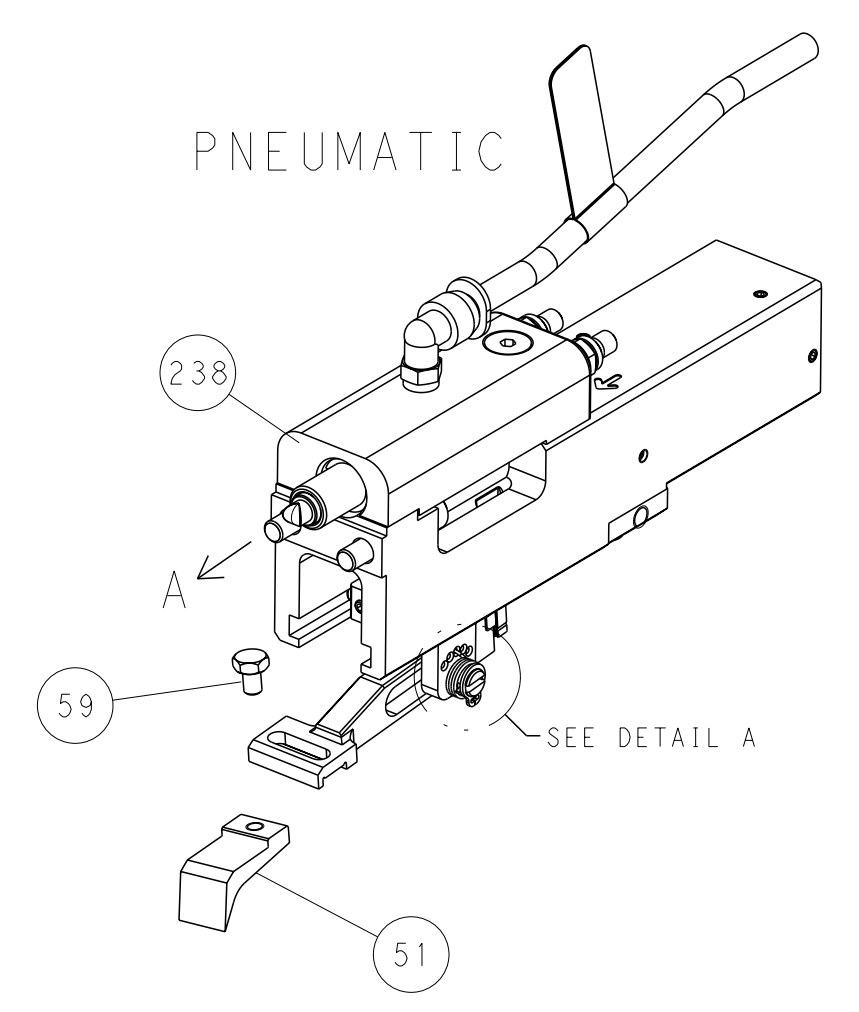
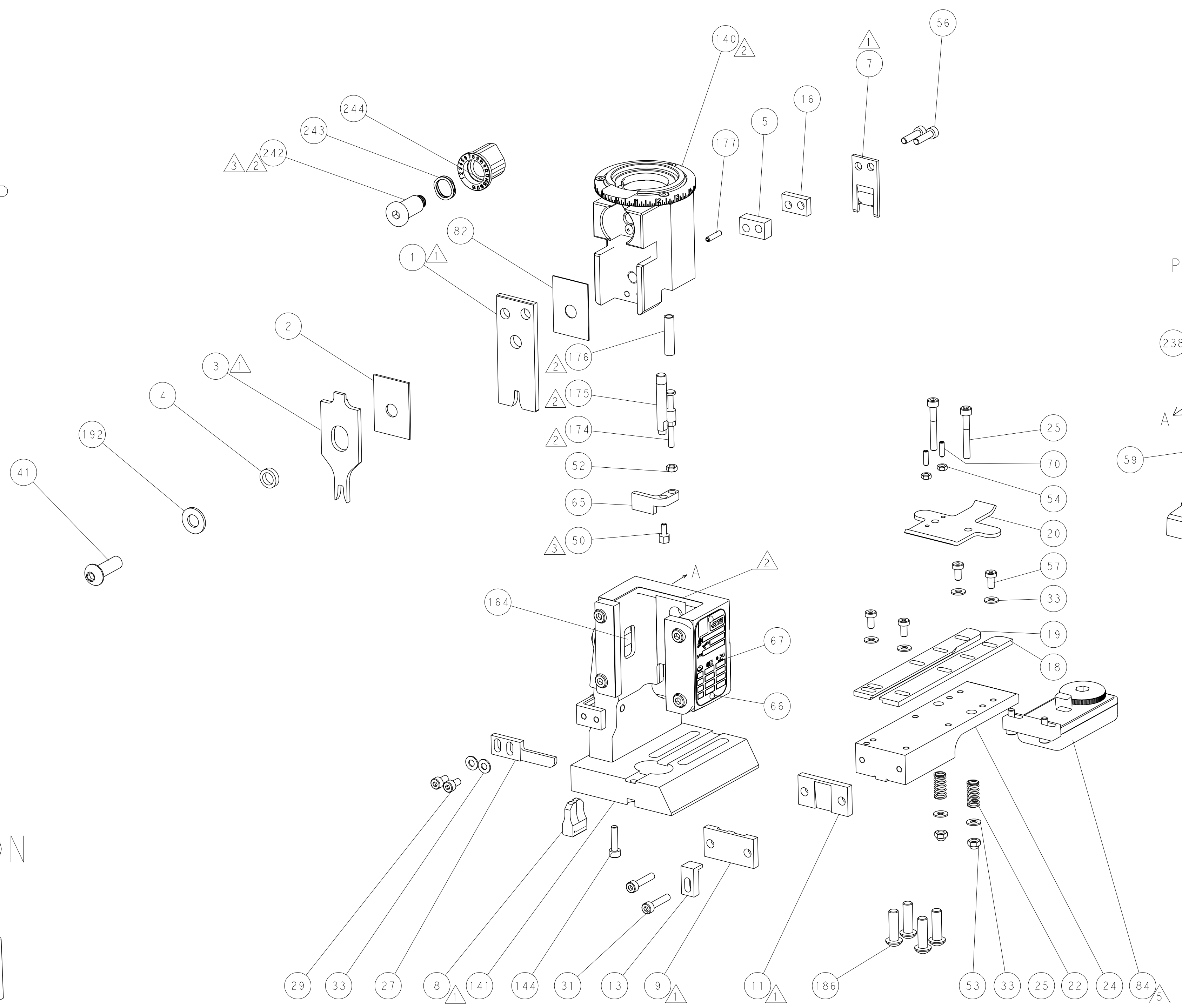
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| DIMENSIONS:<br>mm                                                                                                                     |  | CHK<br>S. XI<br>23DEC2011              | NAME<br>Ocean End Feed<br>Applicator         |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH -                 |  | APVD<br>J. CRUZ<br>23DEC2011           | SIZE<br>A1                                   |  |
| MATERIAL<br>-                                                                                                                         |  | PRODUCT SPEC<br>-                      | CAGE CODE<br>00779                           |  |
|                                                                                                                                       |  | APPLICATION SPEC<br>-                  | DRAWING NO<br>C=2150020                      |  |
|                                                                                                                                       |  | WEIGHT<br>-                            | RESTRICTED TO<br>-                           |  |
|                                                                                                                                       |  | Customer Accessible Production Drawing | SCALE<br>1:1                                 |  |
|                                                                                                                                       |  |                                        | SHEET<br>2                                   |  |
|                                                                                                                                       |  |                                        | OF<br>4                                      |  |
|                                                                                                                                       |  |                                        | REV<br>D                                     |  |



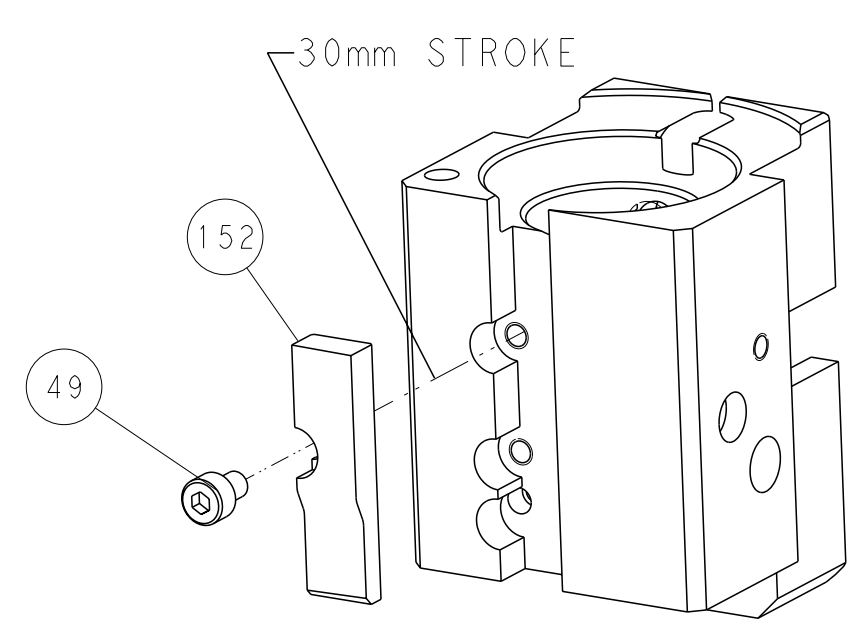


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITION



AIR FEED

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>S. XI                           | 23DEC2011 |                                              |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH                                          |  | APVD<br>J. CRUZ                        | 23DEC2011 | NAME<br>Ocean End Feed Applicator            |  |
| MATERIAL                                                                                                                                                     |  | PRODUCT SPEC                           |           | SIZE<br>A1                                   |  |
|                                                                                                                                                              |  | APPLICATION SPEC                       |           | CAGE CODE<br>00779                           |  |
|                                                                                                                                                              |  | WEIGHT                                 |           | DRAWING NO<br>C=2150020                      |  |
|                                                                                                                                                              |  | Customer Accessible Production Drawing |           | RESTRICTED TO<br>-                           |  |
|                                                                                                                                                              |  | SCALE<br>1:1                           |           | SHEET<br>4                                   |  |
|                                                                                                                                                              |  |                                        |           | OF<br>4                                      |  |
|                                                                                                                                                              |  |                                        |           | REV<br>D                                     |  |