

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|-------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | | | | | | | | | | | |
| | 2266023-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266023-5 | 1901094-3 | 1-1752354-0 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266023-4 | - | - | - |
| | 2266023-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266023-5 | 1901094-3 | 1-1752354-0 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266023-4 | - | - | - |
| | 2266023-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | | | | | - | - | - | - | - | - | - |
| | 2266023-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | - |
| | | | | | - | - | - | - | - | - | - |
| | 2266023-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| 7-2266023-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 0.76 mm (.030) | F |
| INSUL | - | - |

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: AMPHENOL TERMINAL TE CRIMP SPECIFICATION
 TERMINAL NAME: OPEN END BARREL CONTACT PIN

| | |
|-----------------------------|---------------------------|
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE |
| 0.17-0.19 mm (.007-.007 IN) | Ø - |

TERMINAL APPLICATION SPECIFICATION
 NONE -

| TE TERMINAL | AMPHENOL TERMINAL | TE TERMINAL | AMPHENOL TERMINAL |
|-------------|-------------------|-------------|-------------------|
| 2113368-1 | X-X81-110-2828 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 26 AWG | 0.711+0.025/-0 (.028+.001/-0) | 5.0 |

- 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: 8-2266023-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266023-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266023-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266023-6
- 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 ITEMS 62, 180. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180.
- 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. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11. WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 5.21.
- 12. TERMINAL LUBRICANT IS RECOMMENDED.

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

| | | | | | | | | |
|-----|----|----|----|----|----|-----------|-------------------------------------|---------|
| - | - | 1 | - | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 |
| - | 1 | 1 | 1 | 1 | 1 | 1803078-2 | SPACER, PRECISION | 259 |
| - | 1 | - | 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 | 1 | 2119798-1 | DETENT PIN | 247 |
| - | 1 | - | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | 1 | - | - | - | 2119758-1 | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| - | - | 2 | 2 | - | - | 2168400-6 | SHCS, LOW HEAD, RoHS, M5 X 16 | 240 |
| - | - | - | - | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | - | 1 | - | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | 1 | 1 | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | - | 1 | 1 | - | - | 1901094-3 | SPACER, FEEDER | 198 |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

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

| SET UP GAUGE 2119599-1 | LOC A | DIST 66 | REVISIONS | | | |
|---------------------------|----------|------------|-----------|-----------|----|------|
| | | | REV | DATE | BY | APPD |
| | A | 66 | 1 | 17OCT2013 | LG | TE |

| | | | | | | | | | |
|-----|----|-----|-----|-----|-----|---------|-------------------------------------|-------------------------------------|-----|
| 6 | - | 1 | 1 | 1 | 1 | 1 | 1-1752354-0 | STANDOFF, HOLD-DOWN | 180 |
| | - | 1 | 1 | 1 | 1 | 1 | 7-459492-1 | CRIMPER, WIRE O | 178 |
| | - | 1 | 1 | 1 | 1 | 1 | 993111-1 | PIN, SLOTTED SPRING 3.0 X 20.0 | 177 |
| | - | 1 | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 |
| | - | 1 | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 |
| | - | 1 | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 |
| | - | - | - | - | 2 | - | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 | |
| | - | 1 | 1 | 1 | 1 | 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 |
| | - | REF | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| | - | - | - | - | 1 | - | 240638-1 | SPRING, FEED FINGER | 163 |
| | - | - | - | - | 1 | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| | - | - | - | - | 1 | - | 2119799-1 | HOLDER, FEED FINGER, AF | 136 |
| | - | - | REF | REF | - | - | SEE NOTE 4 | MEMORY CHIP, PROGRAMMED | 135 |
| | - | - | 1 | 1 | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-22281-8 | SPRING, COMPRESSION | 121 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| | - | - | REF | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| 12 | - | 1 | 1 | 1 | 1 | 1 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-690438-0 | FRONT STRIP GUIDE | 96 |
| | - | 2 | 2 | 2 | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 95 |
| | - | 1 | 1 | 1 | 1 | 1 | 2168083-6 | SCR, SKT HD CAP, RoHS, M5 X 65 | 93 |
| | - | 1 | 1 | 1 | 1 | 1 | 455888-8 | SPACER, CRIMPER | 82 |
| | - | 1 | 1 | 1 | 1 | 1 | 547505-3 | SPRING, COMPRESSION | 77 |
| | - | 1 | 1 | 1 | 1 | 1 | 854769-4 | HOLDER, INS | 74 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119791-6 | DEPRESSOR, WIRE | 70 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119943-1 | WASHER, SPACER | 69 |
| | - | 1 | - | - | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| | - | 2 | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| | - | 1 | - | 1 | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| 6 | - | 3 | - | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62 |
| | - | 2 | 2 | 2 | 2 | 2 | 2-18032-5 | SCR, SET, FLT POINT M5 X 20.0 | 61 |
| | - | 1 | 1 | 1 | 1 | 1 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 |
| | - | - | - | - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| | - | 1 | 1 | 1 | 1 | 1 | 21028-2 | PIN, SLOTTED SPRING .062 X .250 | 58 |
| | - | - | - | - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| | - | 4 | 4 | 4 | 4 | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 54 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-1901681-9 | HOLDDOWN, TERMINAL | 51 |
| | - | - | - | - | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| | - | - | - | - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 |
| | - | - | - | - | - | 1 | 2119653-1 | FEED CAM, POST FEED | 47 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119656-9 | APPLICATOR BASIC ASSEMBLY, SF | 46 |
| | - | 1 | - | 1 | 1 | 1 | 2119370-1 | RAM, AMP STYLE, SIDE FEED | 44 |
| | - | 1 | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| | - | 1 | - | 1 | 1 | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| | - | 1 | - | 1 | 1 | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-2119644-4 | RAM WASHER, PRECISION | 38 |
| 6 | - | 1 | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| | - | 1 | - | 1 | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| | - | 1 | 1 | 1 | 1 | 1 | 3-1752356-1 | SUPPORT, TERMINAL | 34 |
| | - | 2 | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| | - | 1 | 1 | 1 | 1 | 1 | 2161328-1 | HEX HEAD, FLANGED, M5 X 8mm LONG | 32 |
| | - | 1 | 1 | 1 | 1 | 1 | 1320908-2 | SPACER, STRIP GUIDE | 30 |
| | - | 1 | 1 | 1 | 1 | 1 | 1901086-1 | PLATE, STRIP GUIDE | 29 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| | - | 2 | 2 | 2 | 2 | 2 | 22281-8 | SPRING, COMPRESSION | 27 |
| | - | 1 | 1 | 1 | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| | - | 1 | 1 | 1 | 1 | 1 | 240792-1 | DRAG, TERMINAL | 25 |
| | - | 1 | 1 | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| | - | 1 | 1 | 1 | 1 | 1 | 980371-4 | SCR, SKT HD SHLDR 5.0 DIA X 6.0 | 23 |
| | - | 1 | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-356885-5 | STOP, SHEAR | 11 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| | - | 1 | 1 | 1 | 1 | 1 | 1633861-1 | SHEAR, FLOATING | 9 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-1633933-8 | ANVIL, COMBINATION | 8 |
| | - | - | - | - | - | - | - | - | 7 |
| | - | - | - | - | - | - | - | - | 6 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119780-3 | DEPRESSOR, SHEAR | 5 |
| | - | - | - | - | - | - | - | - | 4 |
| | - | - | - | - | - | - | - | - | 3 |
| | - | 1 | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 7-1633609-9 | CRIMPER, WIRE | 1 |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO | |

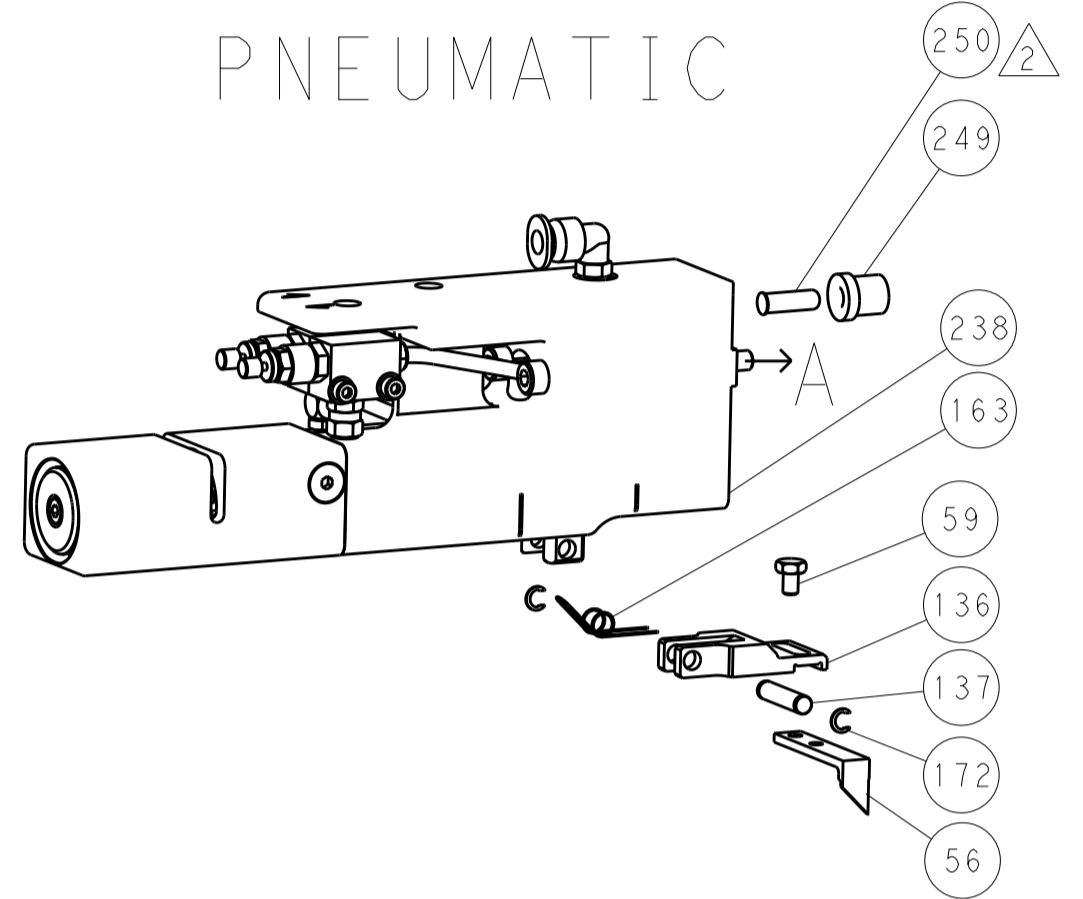
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN | CHK | APPD | DATE | TE Connectivity | |
|-------------|-----------|--|-------------|--------------|--------------|---------------|--------|-----------------|--|
| mm | 0 PLC ±.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 | ANGLES ±.0001 | FINISH | DATE | NAME |
| | | | | | | | | 03SEP2013 | H. HUANG |
| | | | | | | | | 03SEP2013 | L. ZHANG |
| | | | | | | | | 03SEP2013 | H. GUO |
| | | | | | | | | | TE Connectivity |
| | | | | | | | | | Harrisburg, PA 17105-3608 |
| | | | | | | | | | Ocean Side Feed |
| | | | | | | | | | Applicator |
| | | | | | | | | | SIZE |
| | | | | | | | | | CAGE CODE |
| | | | | | | | | | DRAWING NO |
| | | | | | | | | | RESTRICTED TO |
| | | | | | | | | | 00779 |
| | | | | | | | | | ©=2266023 |
| | | | | | | | | | Customer Accessible Production Drawing |
| | | | | | | | | | SCALE 1:2 |
| | | | | | | | | | SHEET 1 OF 4 |
| | | | | | | | | | REV A |

| REVISONS | | DATE | OWN | APVD |
|----------|------|-------------|-----|------|
| LOC | DIST | | | |
| A | 66 | | | |
| P | LTN | DESCRIPTION | | |
| | | SEE SHEET 1 | | |

FEED TYPE MECHANICAL



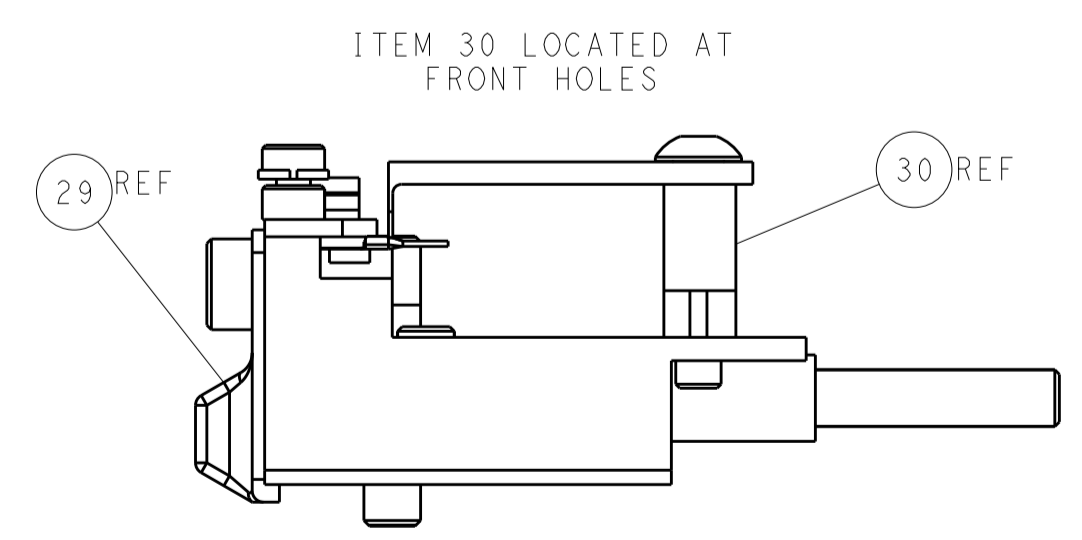
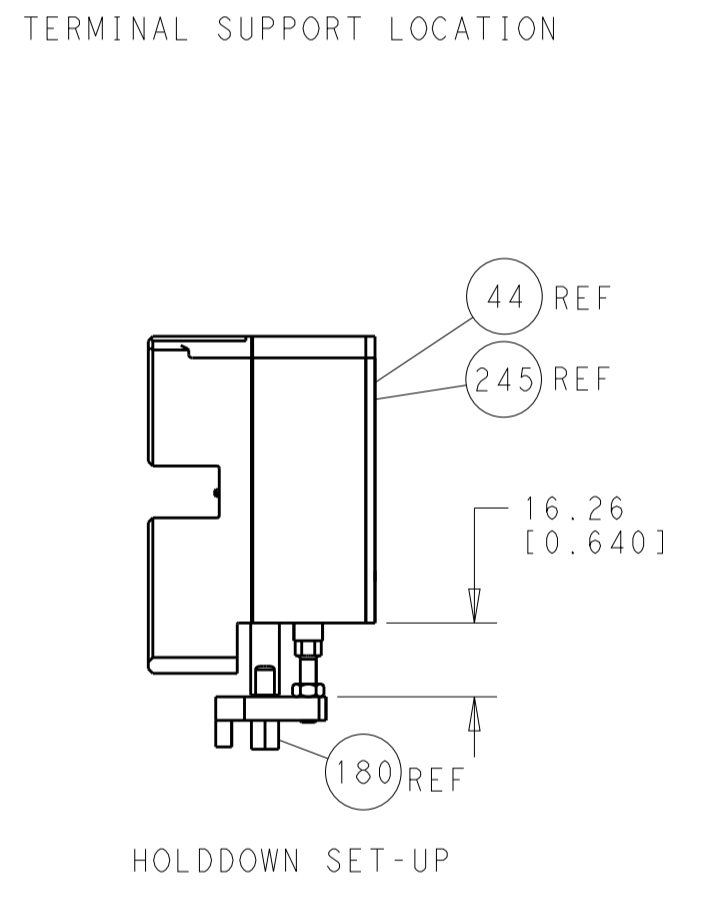
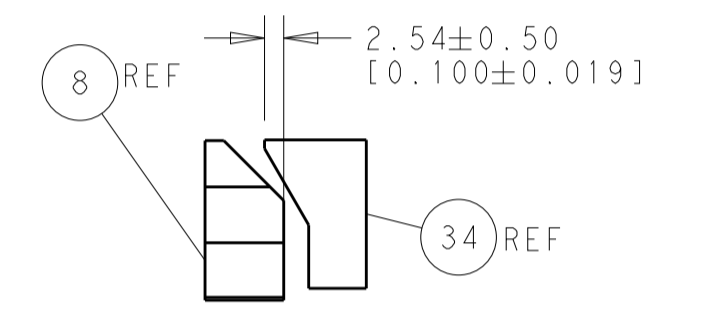
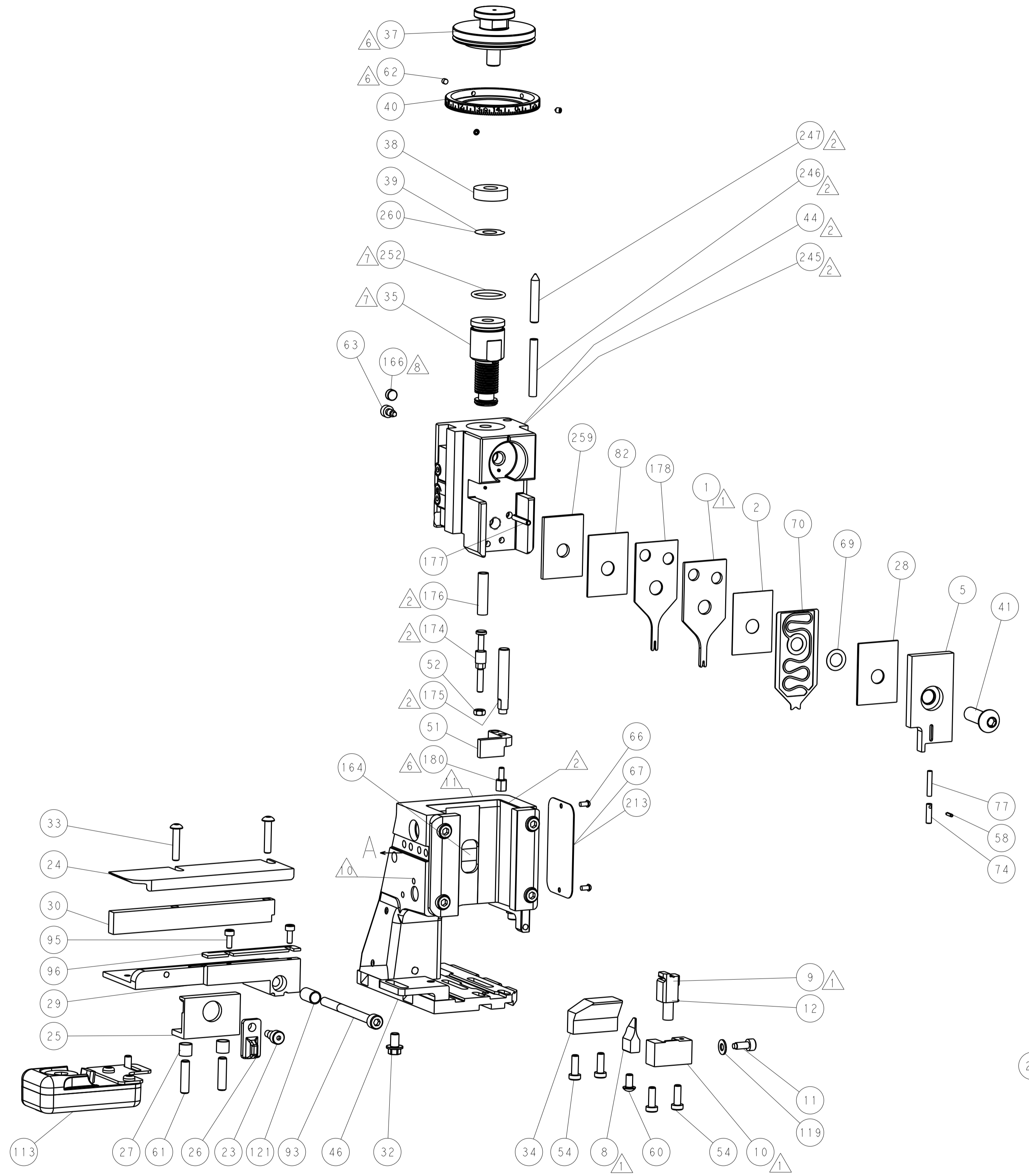
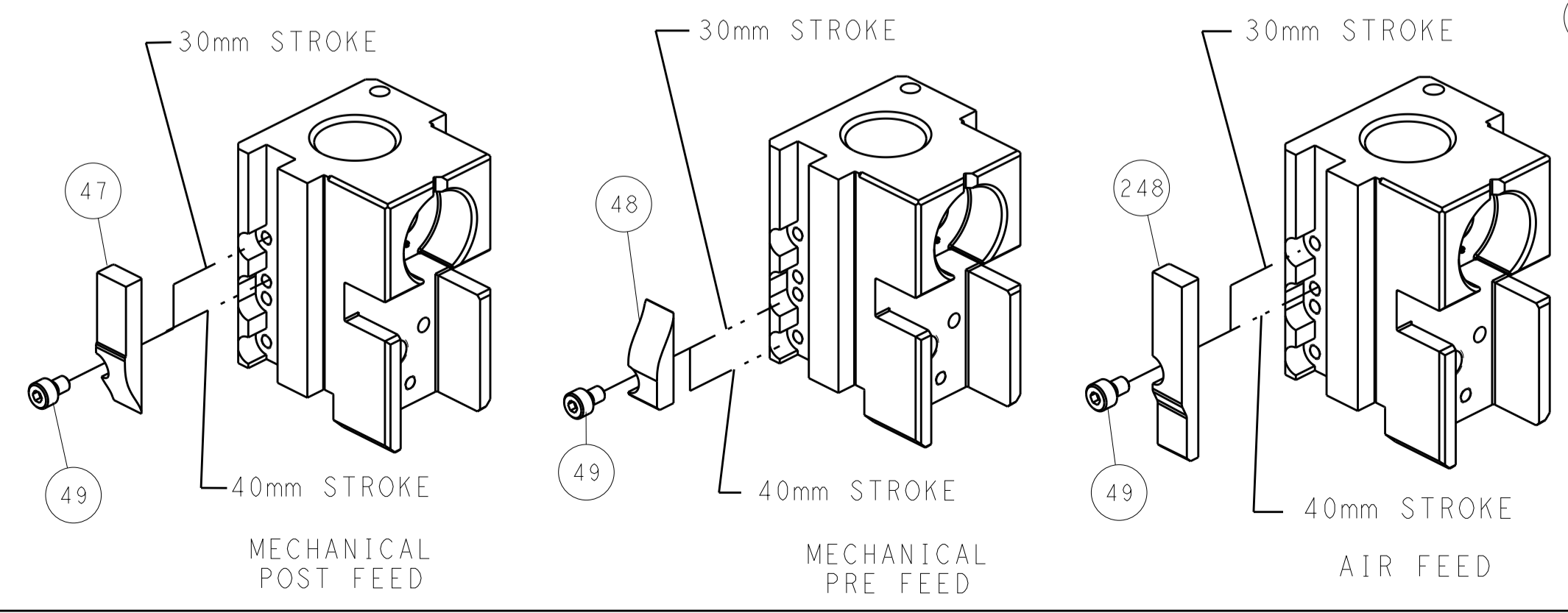
PNEUMATIC



SERVO LATCH PLATE



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: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN 03SEP2013 | | TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 | CHK L. ZHANG 03SEP2013 | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | APVD H. GUO 03SEP2013 | | NAME Ocean Side Feed Applicator | |
| | | | | PRODUCT SPEC | | SIZE CAGE CODE DRAWING NO | |
| | | | | APPLICATION SPEC | | RESTRICTED TO | |
| | | | | WEIGHT | | A1 00779 ©=2266023 | |
| | | | | Customer Accessible Production Drawing | | SCALE 1:2 SHEET 2 OF 4 REV A | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2266023-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266023-5 | 1901094-3 | 1-1752354-0 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266023-4 | - | - | - |
| | 2-2266023-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266023-5 | 1901094-3 | 1-1752354-0 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266023-4 | - | - | - |
| | 2-2266023-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 |
| | 2-2266023-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2266023-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 0.76 mm [.030] | F |
| INSUL | - | - |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: AMPHENOL TERMINAL TE CRIMP SPECIFICATION | | | |
|---|-------------------|---------------------------|-------------------|
| TERMINAL NAME: OPEN END BARREL CONTACT PIN | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 0.17-0.19 mm [.007-.007 IN] | | Ø | |
| TERMINAL APPLICATION SPECIFICATION | NONE | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | AMPHENOL TERMINAL | TE TERMINAL | AMPHENOL TERMINAL |
| 2113368-1 | X-X81-110-2828 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 26 AWG | 0.711+0.025/-0 [0.028+.001/-0] | 5.0 |

- 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: 8-2266023-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266023-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266023-5
- 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 ITEMS 62, 180.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

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

| | | | | | | | |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 1 | 1803078-2 | SPACER, PRECISION | 259 |
| - | 1 | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | - | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| - | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | 2 | - | - | 2168400-6 | SHCS, LOW HEAD, RoHS, M5 X 16 | 240 |
| - | - | - | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | - | 1 | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | 1 | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | - | 1 | - | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | 1 | 1 | 1 | 1 | 1-1752354-0 | STANDOFF, HOLD-DOWN | 180 |
| - | 1 | 1 | 1 | 1 | 7-459492-1 | CRIMPER, WIRE O | 178 |
| -77 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

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 | | | |
|--------------|-----|------|-------------|------|----|------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPD |
| - | - | - | SEE SHEET 1 | - | - | - |

| | | | | | | | |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 1 | 993111-1 | PIN, SLOTTED SPRING 3.0 X 20.0 | 177 |
| - | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 |
| - | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 |
| - | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 |
| - | - | - | 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 1 | 1 | 1 | 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | - | - | 1 | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | 1 | 1 | 1 | 1 | 8-21084-1 | O-RING, .801 ID, .070 DIA. MAT. | 152 |
| - | - | - | 1 | - | 2119641-2 | FEED CAM, AIR FEED | 151 |
| - | 1 | 1 | 1 | 1 | 2119798-2 | DETENT PIN | 145 |
| - | 1 | 1 | 1 | 1 | 2079383-8 | SCR, BHSC, RoHS (M4 X 16) | 144 |
| - | 4 | 4 | 4 | 4 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 143 |
| - | - | - | - | 1 | 2119653-2 | FEED CAM, POST FEED | 142 |
| - | 1 | 1 | 1 | 1 | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1 | 1 | 1 | 2119650-1 | RAM, ASIAN STYLE, SIDE FEED | 140 |
| - | 1 | 1 | 1 | 1 | 2119092-2 | BOLT, ADJUSTMENT | 139 |
| - | - | - | 1 | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | - | - | 1 | - | 2119799-1 | HOLDER, FEED FINGER, AF | 136 |
| - | - | REF | - | - | SEE NOTE 4 | MEMORY CHIP, PROGRAMMED | 135 |
| - | - | 1 | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 |
| - | 1 | 1 | 1 | 1 | 1-22281-8 | SPRING, COMPRESSION | 121 |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| - | 1 | 1 | 1 | 1 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 1 | 1 | 1 | 1-690438-0 | FRONT STRIP GUIDE | 96 |
| - | 2 | 2 | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 95 |
| - | 1 | 1 | 1 | 1 | 2168083-6 | SCR, SKT HD CAP, RoHS, M5 X 65 | 93 |
| - | 1 | 1 | 1 | 1 | 455888-8 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 547505-3 | SPRING, COMPRESSION | 77 |
| - | 1 | 1 | 1 | 1 | 854769-4 | HOLDER, INS | 74 |
| - | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 2119791-6 | DEPRESSOR, WIRE | 70 |
| - | 1 | 1 | 1 | 1 | 2119943-1 | WASHER, SPACER | 69 |
| - | 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 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| - | 3 | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62 |
| - | 2 | 2 | 2 | 2 | 2-18032-5 | SCR, SET, FLT POINT M5 X 20.0 | 61 |
| - | - | - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1 | 1 | 21028-2 | PIN, SLOTTED SPRING .062 X .250 | 58 |
| - | - | - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | 1 | 1 | 1 | 1 | 1-1901681-9 | HOLDDOWN, TERMINAL | 51 |
| - | - | - | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | 1 | 1 | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| - | 1 | 1 | 1 | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| - | 1 | 1 | 1 | 1 | 1-2119644-4 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 3-1752356-1 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 1 | 1 | 1 | 1 | 2161328-1 | HEX HEAD, FLANGED, M5 X 8mm LONG | 32 |
| - | 1 | 1 | 1 | 1 | 1320908-2 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1901086-1 | PLATE, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 2 | 2 | 2 | 2 | 22281-8 | SPRING, COMPRESSION | 27 |
| - | 1 | 1 | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| - | 1 | 1 | 1 | 1 | 240792-1 | DRAG, TERMINAL | 25 |
| - | 1 | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 980371-4 | SCR, SKT HD SHLDR 5.0 DIA X 6.0 | 23 |
| - | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1 | 1-356885-5 | STOP, SHEAR | 11 |
| - | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1 | 1 | 1633861-1 | SHEAR, FLOATING | 9 |
| - | 1 | 1 | 1 | 1 | 1-1633933-8 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 2119780-3 | DEPRESSOR, SHEAR | 5 |
| - | - | - | - | - | - | - | 4 |
| - | - | - | - | - | - | - | 3 |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 7-1633609-9 | CRIMPER, WIRE | 1 |
| -77 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DRAWING NO | |
|-------------|------------|--|-------------|--|---------------|
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.0013 |
| MATERIAL: | | FINISH: | | WEIGHT: | |
| | | | | Customer Accessible Production Drawing | |
| | | | | SCALE 1:2 SHEET 3 OF 4 REV A | |

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

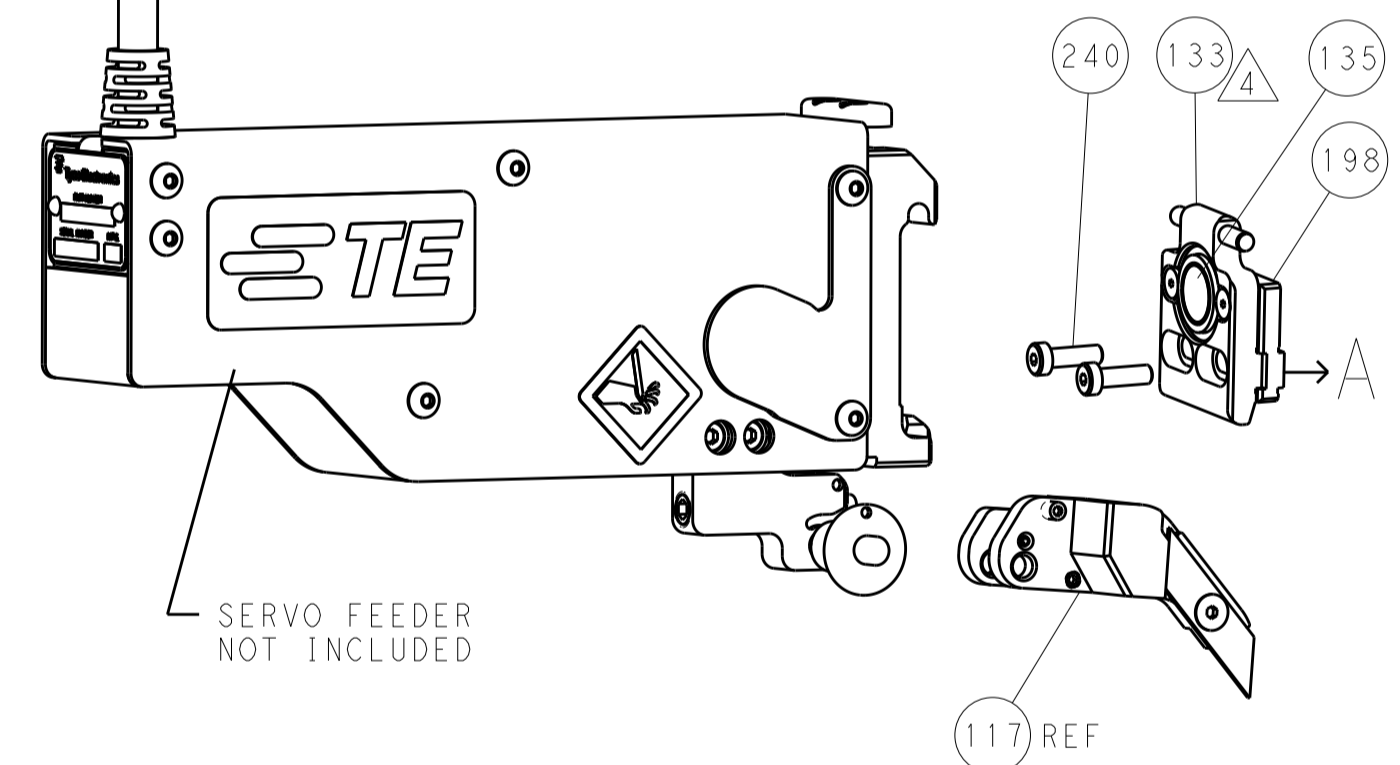
FEED TYPE MECHANICAL



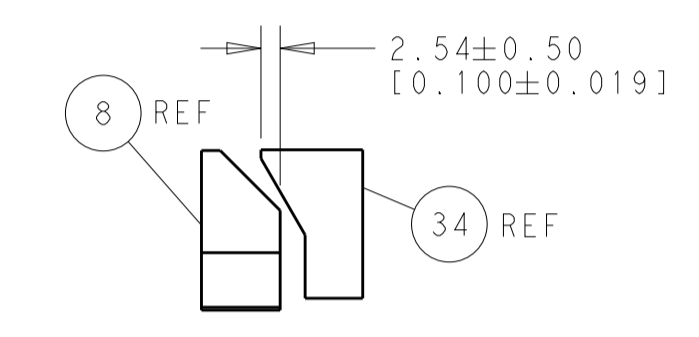
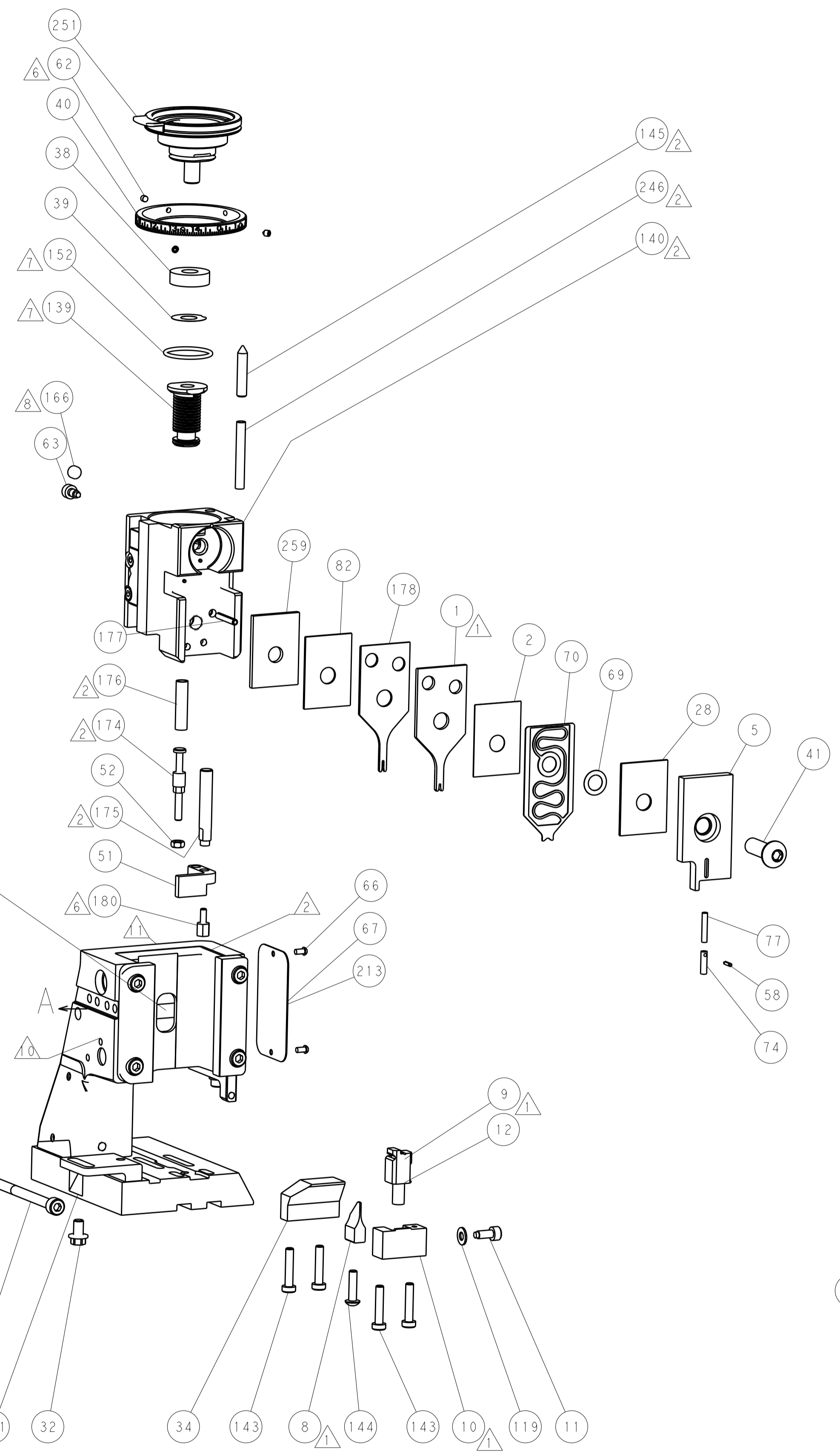
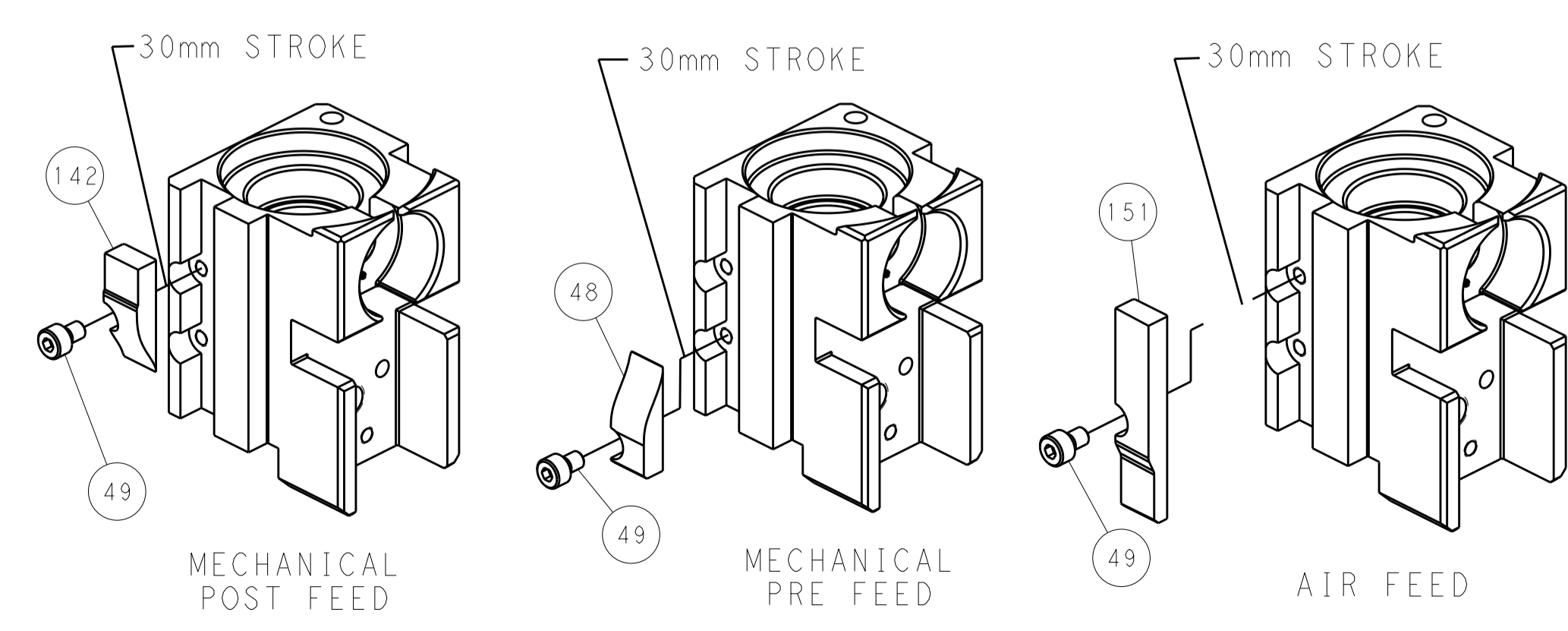
PNEUMATIC



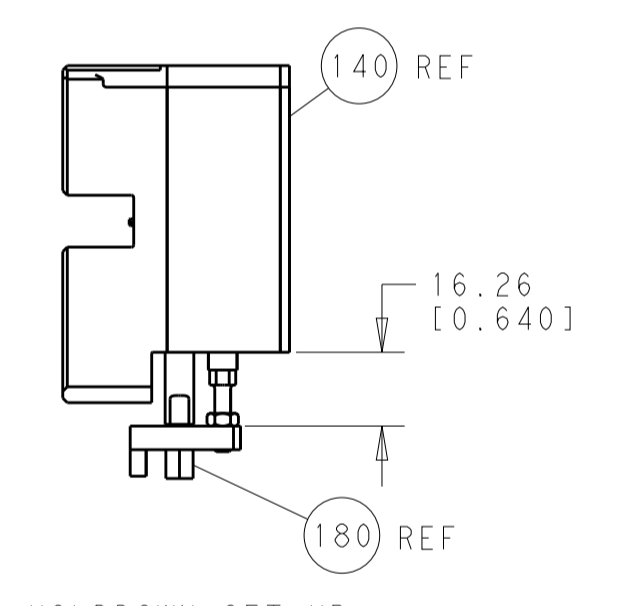
SERVO LATCH PLATE



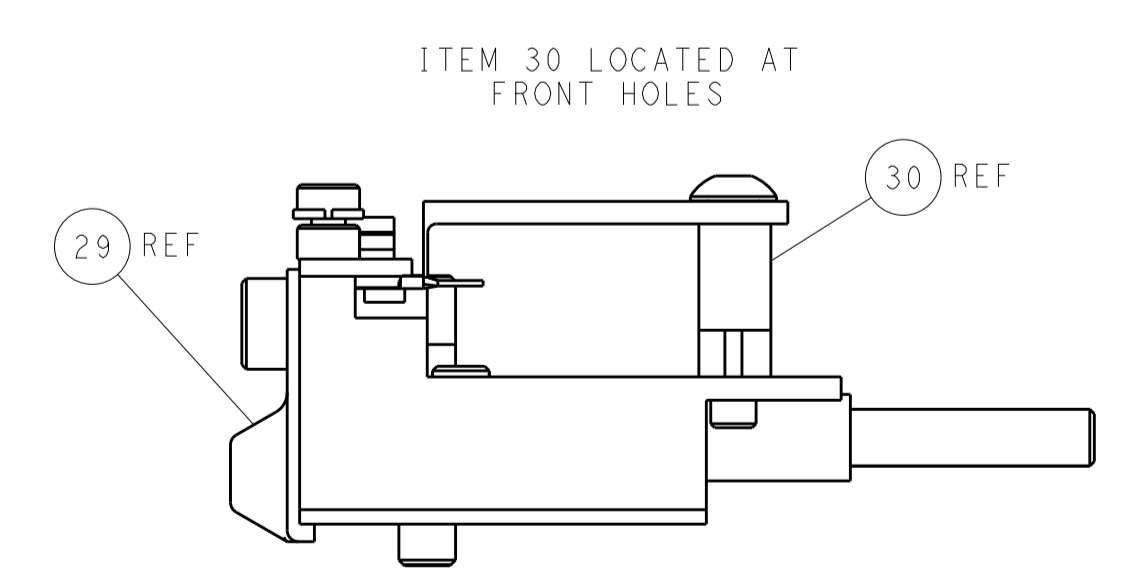
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



ITEM 30 LOCATED AT FRONT HOLES

FEED TRACK POSITION GUIDE FROM CLOSED BARREL

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

| | | | | | | | |
|--|--|--|--|--|--|---|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1 | | DWN R. HUANG 03SEP2013 CHK L. ZHANG 03SEP2013 APVD H. GUO 03SEP2013 | | NAME Ocean Side Feed Applicator | |
| MATERIAL . | | FINISH . | | WEIGHT . | | SIZE CAGE CODE DRAWING NO A1 00779 C=2266023 | |
| Customer Accessible Production Drawing | | | | SCALE 1:2 | | SHEET 4 OF 4 REV A | |