

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | | |
|---|-------------|--------------------------|--------------------------------------|-------------------|-----------------------------------|-----------------------|-------------|-------------|-------------|------------------------|------------------------|--|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | | |
| | | | | | | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | |
| | 2266673-1 | G | 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 | - | 8-2266673-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266673-4 | - | - | - | |
| 2266673-2 | G | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | | |
| | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | | |
| | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266673-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | | |
| 2266673-5 | G | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | | |
| | | | | 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 | | |
| 2266673-6 | G | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | | |
| | | | | - | - | - | - | - | - | - | | |
| 2266673-7 | G | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | | |
| | | | | - | - | - | - | - | - | - | | |
| 3-2266673-2 | G | FINE CRIMP HEIGHT ADJUST | DOUBLE ACTING PNEUMATIC WITH SENSORS | 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 | | |
| | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266673-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | | |
| 7-2266673-7 | F | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | | |

| APPLICATOR DATA | | |
|-----------------------------------|-----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.07 mm [.042] | F |
| INSUL | 1.55 mm [1.061] | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-----------------------------|-------------------------------|-------------------|
| TERMINAL NAME: CONTACT, MALE, GENERATION Y, 0.64 | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.00-4.50 mm [1.57-.177 IN] | | Ø1.10-1.40 mm [1.043-.055 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-13183 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1924968-8 | 1924727-4 | 1924275-8 | 1456841-8 |
| 2098753-4 | 1-1924727-4 | 1456574-8 | 1456968-8 |
| 1924955-8 | 2035170-4 | 2098762-4 | 2138699-4 |
| 2035334-8 | 1-2035170-4 | - | 1-2138699-4 |
| WIRE SIZE | CRIMP HEIGHT | CRIMP HEIGHT | CRIMP HEIGHT |
| 0.35mm2 OR 22 AWG | mm [INCH] | mm [INCH] | REFERENCE SETTING |
| | 0.91+/-0.03 [1.036+/-1.001] | | 8.8 |

- 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: 8-2266673-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266673-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266673-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266673-6
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- 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. TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12. WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.89.
- 13. THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN WALL (FLR) INSULATION.

***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.

| -77 | -32 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |
|-----|-----|----|----|----|----|----|-----------|---------------------------------|---------|
| - | - | - | - | - | - | - | 1803430-1 | AIR FEED MODULE | 290 |
| - | - | - | - | - | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 |
| - | - | - | - | - | - | - | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252 |
| - | - | - | - | - | - | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |

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

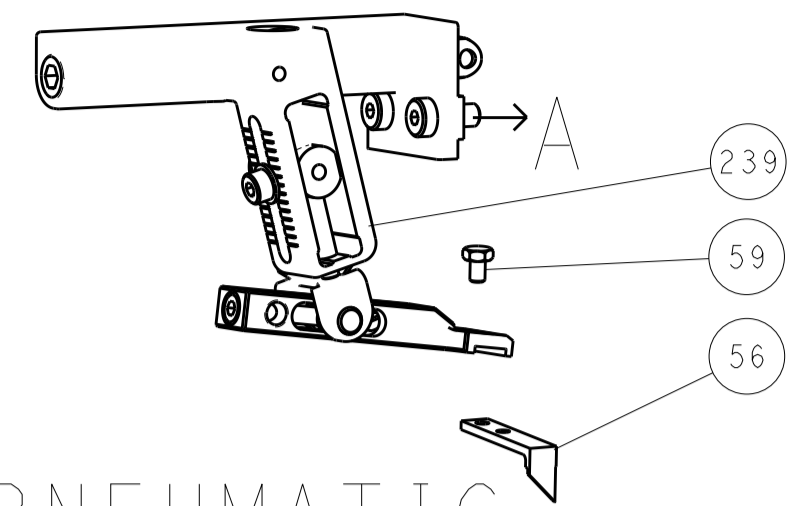
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|---------------|-----------|-----|
| 2119599-1 | A | 66 | REV | DATE | BY | CHK |
| | | | F | ECR-16-012044 | 22AUG2016 | MR |
| | | | G | ECR-16-012485 | 07SEP2016 | MZ |
| | | | G1 | ECR-16-015428 | 8NOV2016 | RS |

| | | | | | | | | | |
|---|---|---|---|---|---|---|-------------|-------------------------------------|-----|
| - | - | - | - | - | - | - | 1803259-1 | BUSHING, FLANGED | 249 |
| - | - | - | - | - | - | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | - | - | - | - | - | - | 2119798-1 | DETENT PIN | 247 |
| - | - | - | - | - | - | - | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | - | - | - | - | - | 2119758-1 | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| - | - | - | - | - | - | - | 2119082-5 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | - | - | - | - | - | - | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | - | - | - | - | - | - | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | - | - | - | - | - | - | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | - | - | - | - | - | 2168400-6 | SHCS, LOW HEAD, RoHS, M5 X 16 | 240 |
| - | - | - | - | - | - | - | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | - | - | - | - | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | - | - | - | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | - | - | - | - | - | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | - | - | - | - | - | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | - | - | - | - | - | - | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 |
| - | - | - | - | - | - | - | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | - | - | - | - | - | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | - | - | - | - | - | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | - | - | - | - | - | - | 2119799-1 | HOLDER, FEED FINGER, AF | 136 |
| - | - | - | - | - | - | - | SEE NOTE 4 | MEMORY CHIP, PROGRAMMED | 135 |
| - | - | - | - | - | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 |
| - | - | - | - | - | - | - | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | - | - | - | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| - | - | - | - | - | - | - | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | - | - | - | - | - | - | 455888-4 | SPACER, CRIMPER | 82 |
| - | - | - | - | - | - | - | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | - | - | - | - | - | - | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | - | - | - | - | - | - | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | - | - | - | - | - | - | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | - | - | - | - | - | - | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| - | - | - | - | - | - | - | 992763-5 | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62 |
| - | - | - | - | - | - | - | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 |
| - | - | - | - | - | - | - | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | - | - | - | - | - | 1338685-1 | PAWL, FEED | 56 |
| - | - | - | - | - | - | - | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 54 |
| - | - | - | - | - | - | - | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 53 |
| - | - | - | - | - | - | - | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 |
| - | - | - | - | - | - | - | 811242-5 | BUMPER, HOLD DOWN | 51 |
| - | - | - | - | - | - | - | 690753-2 | SPACER, TONKER | 50 |
| - | - | - | - | - | - | - | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | - | - | - | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | - | - | - | - | - | - | 2119653-1 | FEED CAM, POST FEED | 47 |
| - | - | - | - | - | - | - | 2119656-9 | APPLICATOR BASIC ASSEMBLY, SF | 46 |
| - | - | - | - | - | - | - | 2119370-1 | RAM, AMP STYLE, SIDE FEED | 44 |
| - | - | - | - | - | - | - | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | - | - | - | - | - | - | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| - | - | - | - | - | - | - | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| - | - | - | - | - | - | - | 2119644-1 | RAM WASHER, PRECISION | 38 |
| - | - | - | - | - | - | - | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | - | - | - | - | - | - | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | - | - | - | - | - | - | 6-1752356-2 | SUPPORT, TERMINAL | 34 |
| - | - | - | - | - | - | - | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | - | - | - | - | - | - | 2161328-1 | HEX HEAD, FLANGED, M5 x 8mm LONG | 32 |
| - | - | - | - | - | - | - | 1320908-6 | SPACER, STRIP GUIDE | 30 |
| - | - | - | - | - | - | - | 2119959-7 | ASSEMBLY, STRIP GUIDE | 29 |
| - | - | - | - | - | - | - | 1320928-2 | STRIP GUIDE | 24 |
| - | - | - | - | - | - | - | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | - | - | - | - | - | - | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | - | - | - | - | - | - | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | - | - | - | - | - | - | 2119806-1 | INSERT, SHEAR | 13 |
| - | - | - | - | - | - | - | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | - | - | - | - | - | - | 1-356885-4 | STOP, SHEAR | 11 |
| - | - | - | - | - | - | - | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | - | - | - | - | - | - | 1803095-6 | FLOATING SHEAR, FRONT | 9 |
| - | - | - | - | - | - | - | 1-1803058-6 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | - | 6 |
| - | - | - | - | - | - | - | 2119757-3 | DEPRESSOR, SHEAR | 5 |
| - | - | - | - | - | - | - | 3-238011-1 | BLOCK, CRIMPER SPACER | 4 |
| - | - | - | - | - | - | - | 1-1803019-1 | CRIMPER, INSULATION O | 3 |
| - | - | - | - | - | - | - | 455888-3 | SPACER, CRIMPER | 2 |
| - | - | - | - | - | - | - | 8-1633860-6 | CRIMPER, WIRE | 1 |

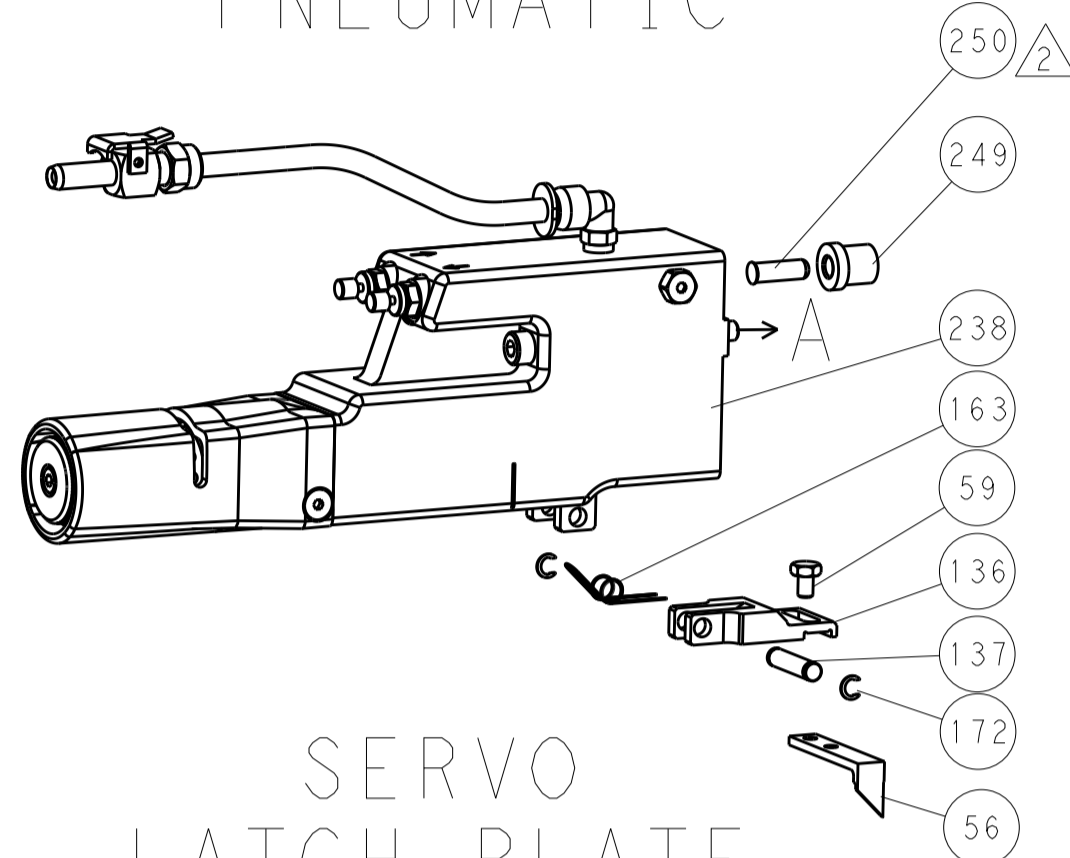
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|-------------|--------|--|--|------------------|-----------|------|----------------------------|---------------------------|---------------|
| mm | 0 PLC | ± | | J. HOU | 06FEB2015 | CHK | 06FEB2015 | TE Connectivity | |
| | 1 PLC | ± | | L. ZHANG | 06FEB2015 | APVD | 06FEB2015 | Harrisburg, PA 17105-3608 | |
| | 2 PLC | ± | | U. GUO | 06FEB2015 | NAME | Ocean Side Feed Applicator | | |
| | 3 PLC | ± | | PRODUCT SPEC | | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| | 4 PLC | ± | | APPLICATION SPEC | | A1 | 00779 | ©=2266673 | |
| MATERIAL | FINISH | WEIGHT | Customer Accessible Production Drawing | | SCALE | 1:2 | SHEET | 1 of 4 | REV |
| | | | | | | | | | G1 |

| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | DMN | APVD |
| | | - | | SEE SHEET 1 | | | |

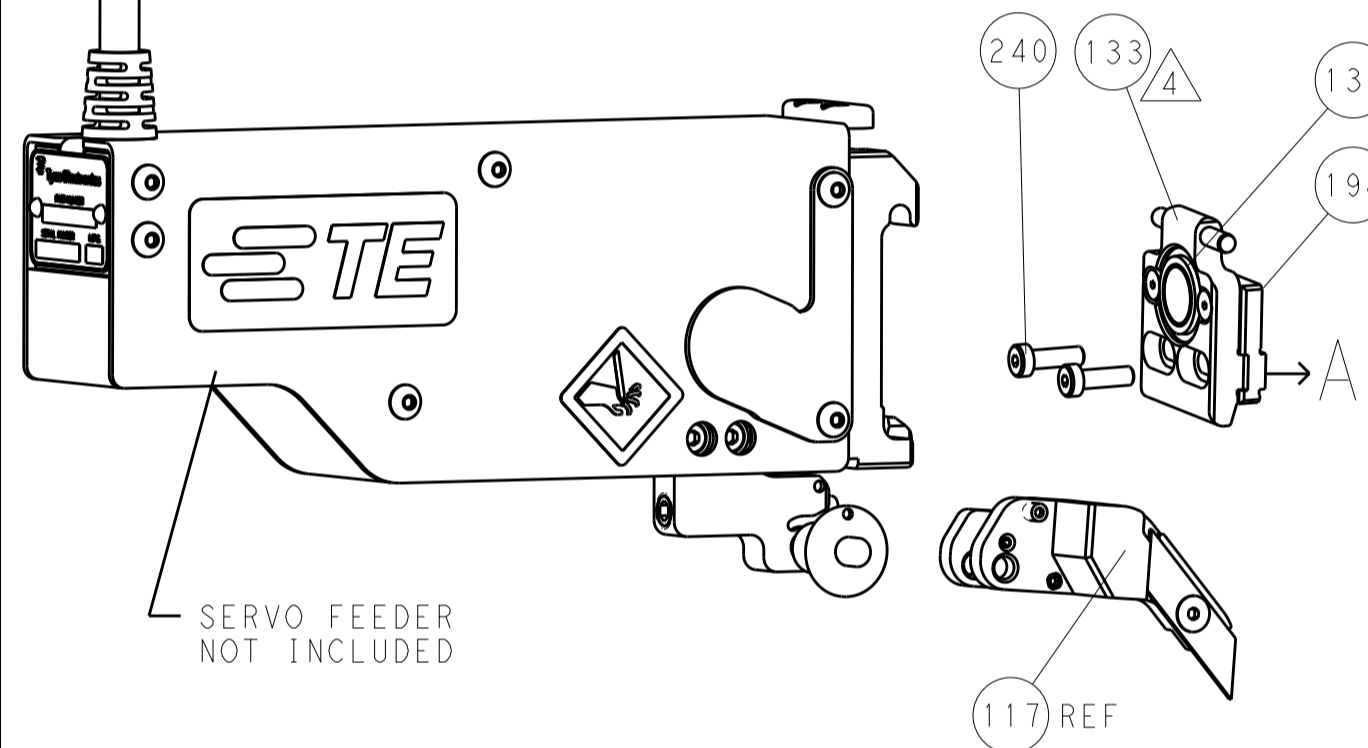
FEED TYPE MECHANICAL



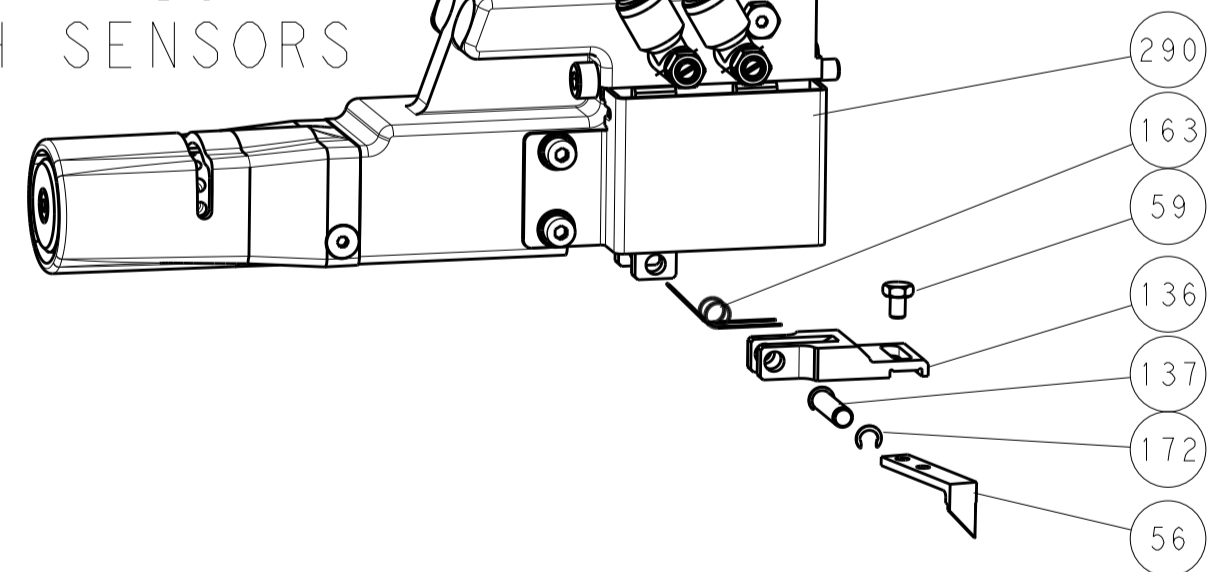
PNEUMATIC



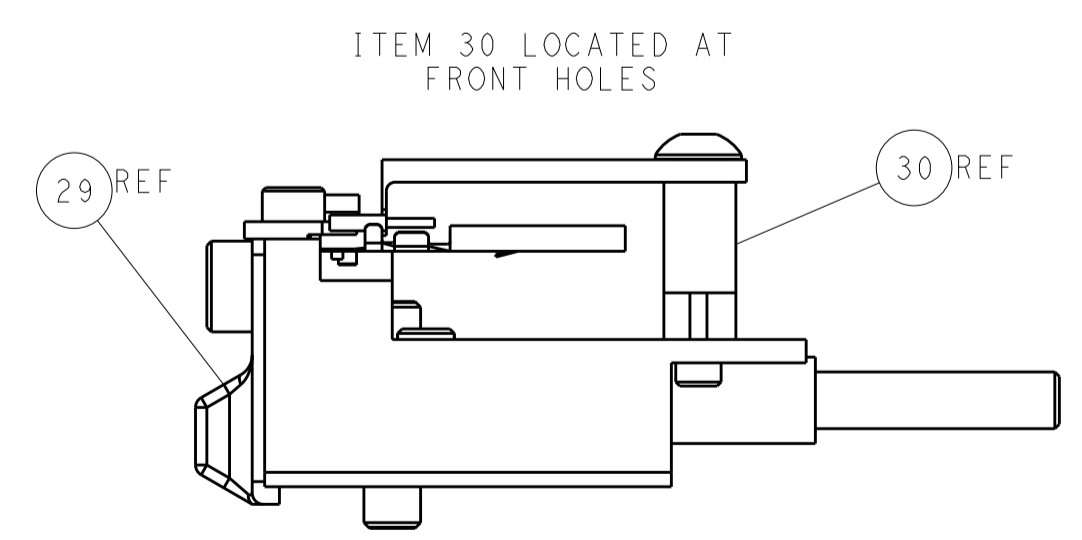
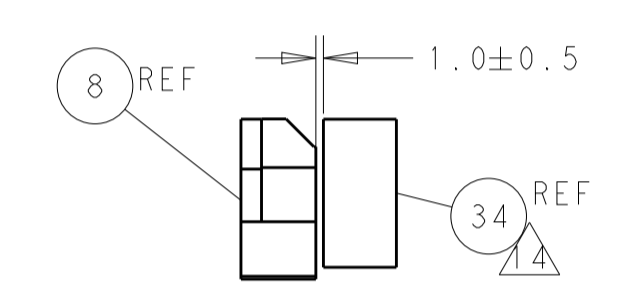
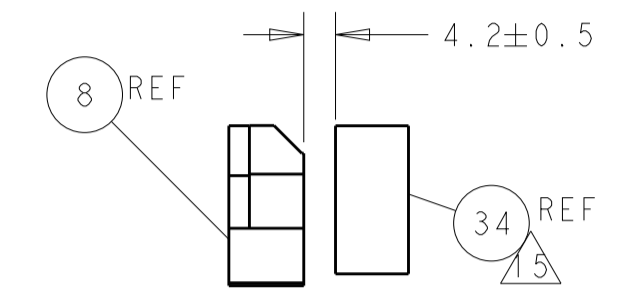
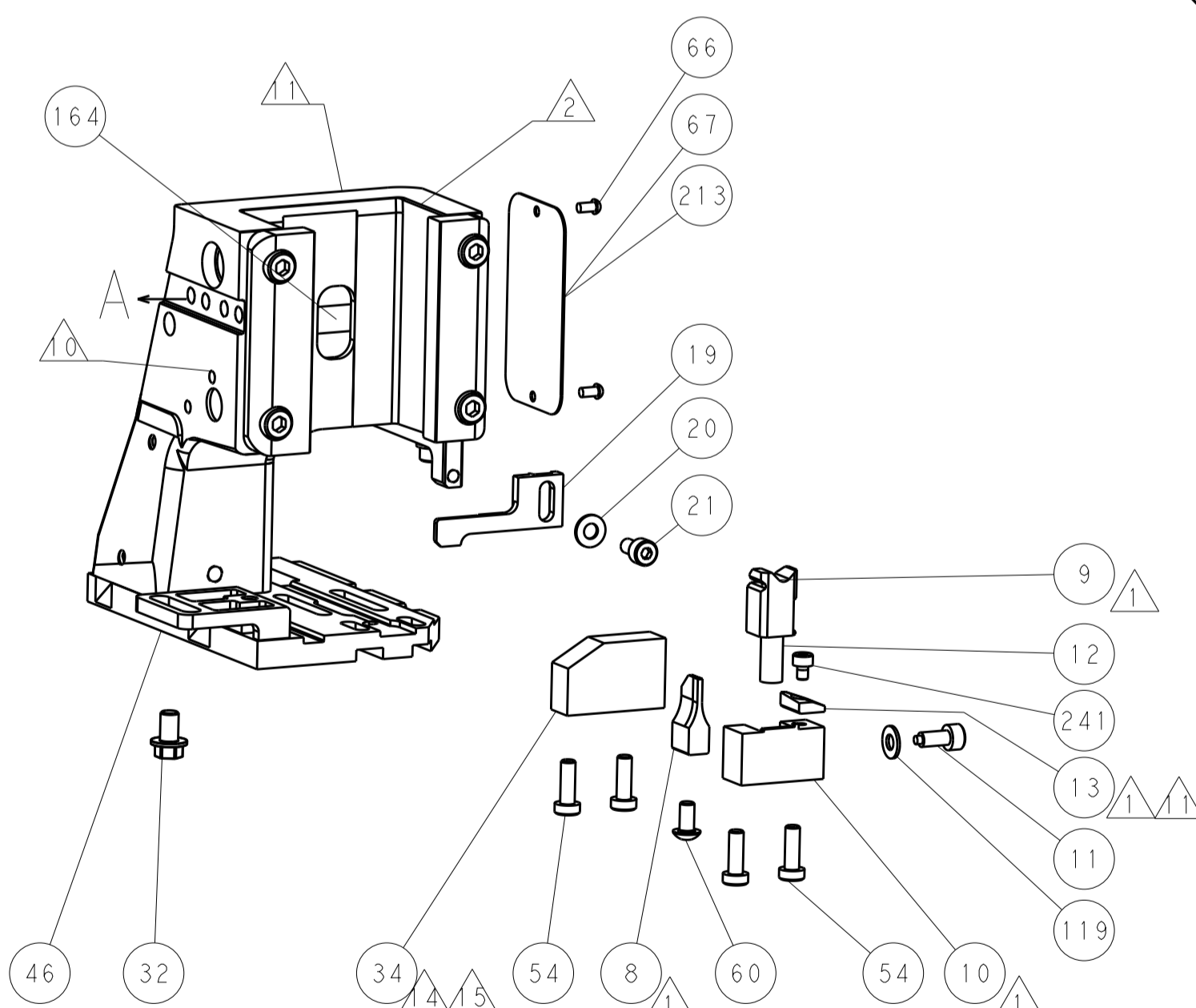
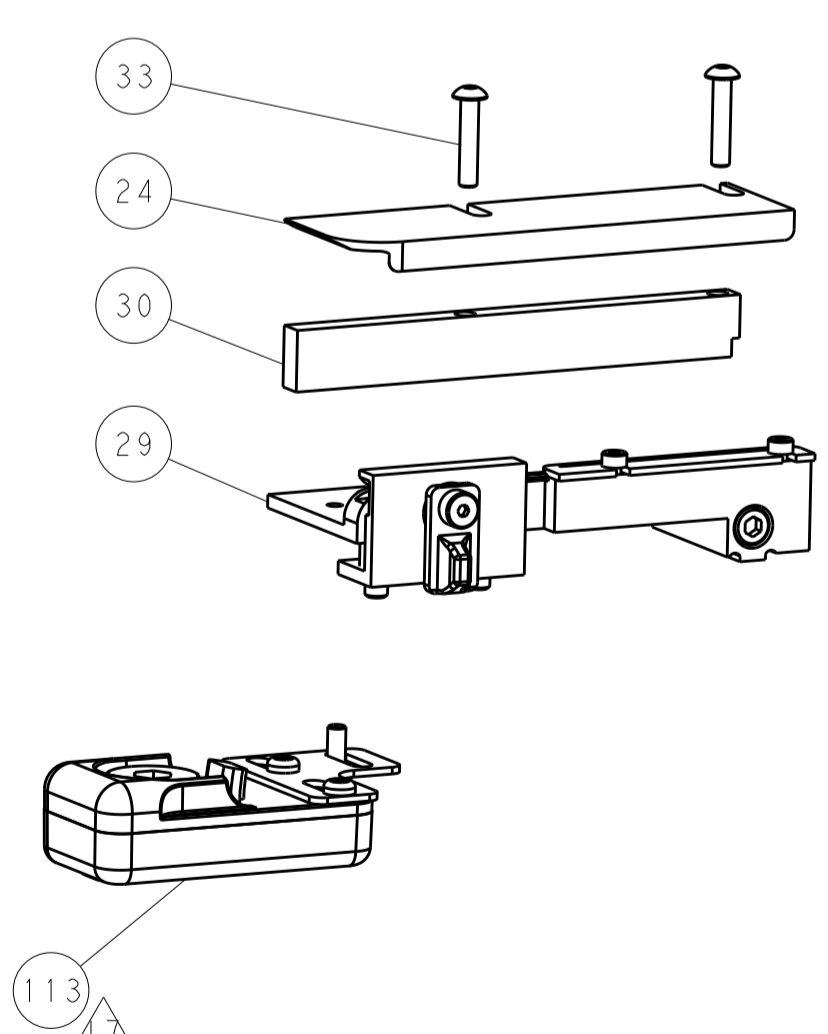
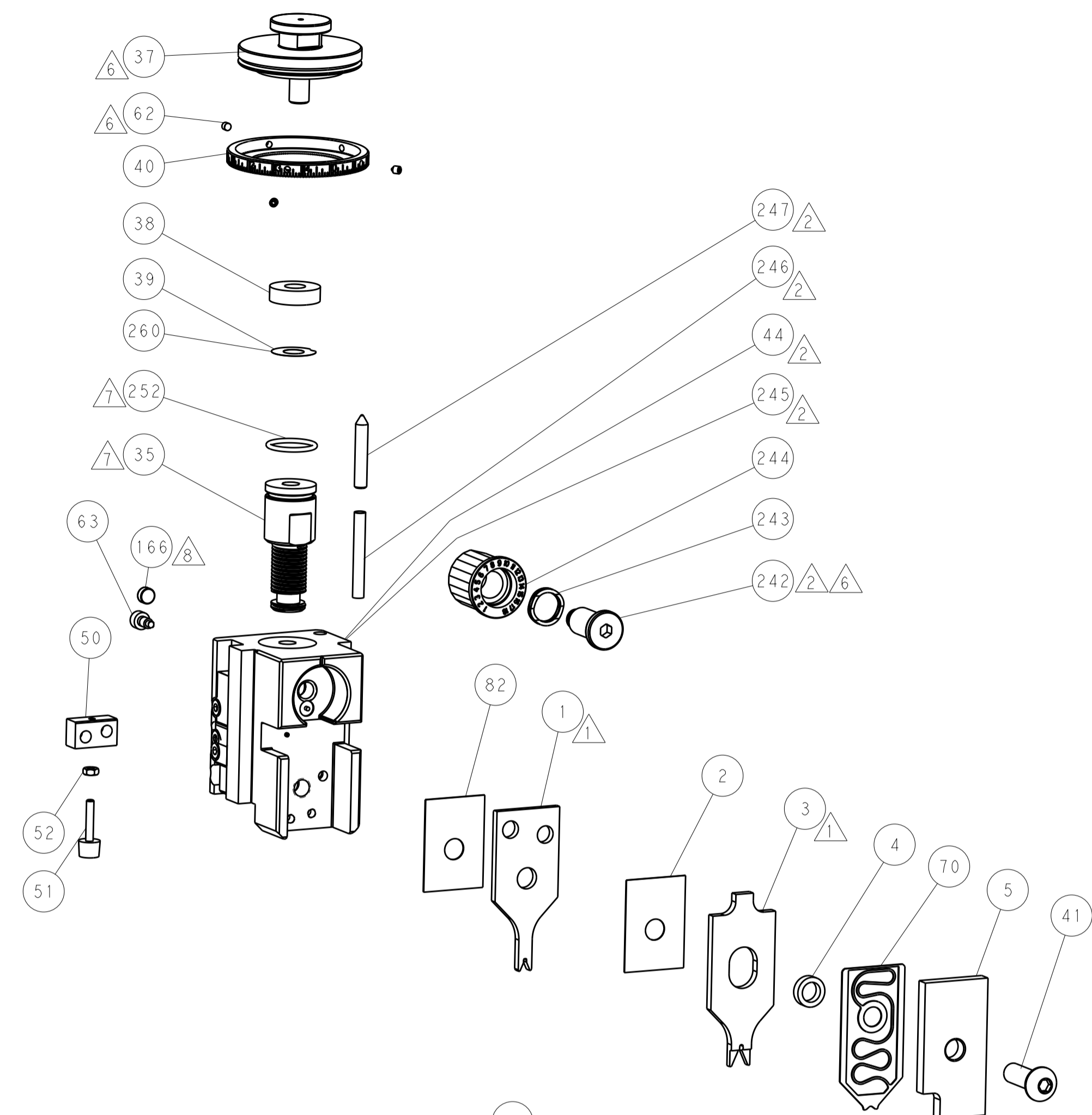
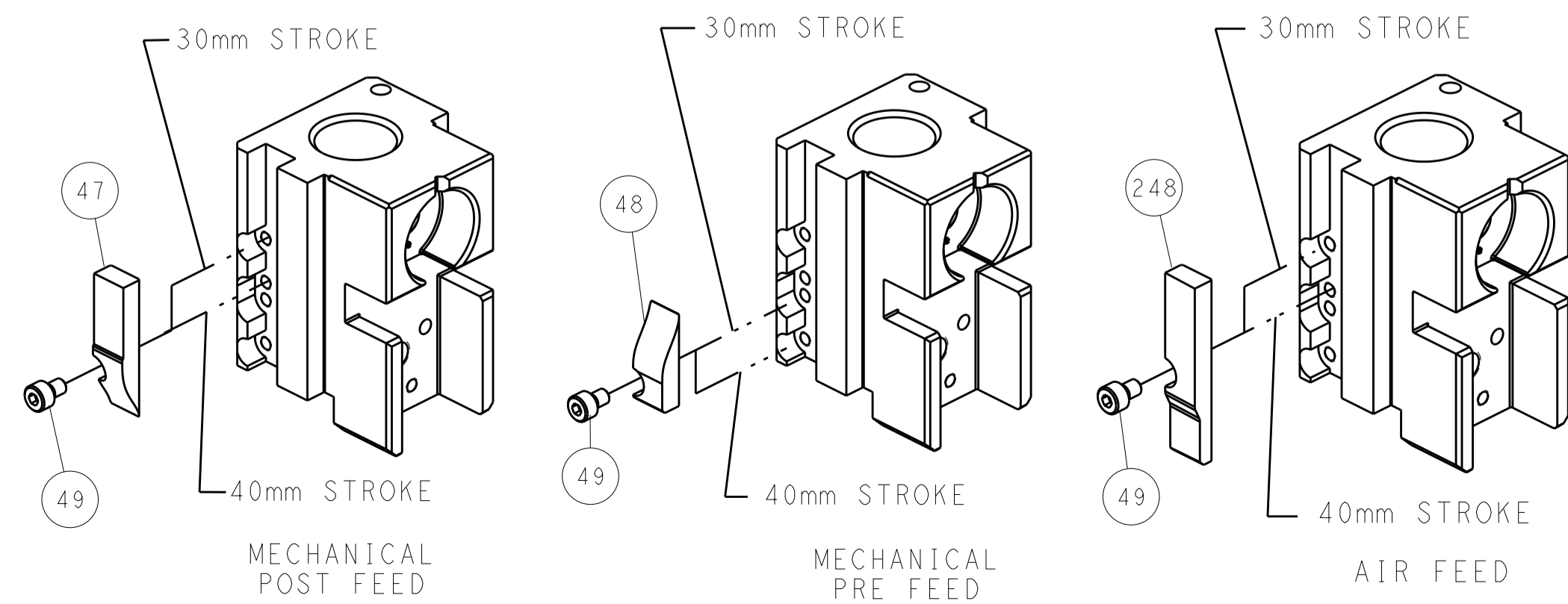
SERVO LATCH PLATE



DOUBLE ACTING PNEUMATIC WITH SENSORS



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: | | DWG: J. HOU 06FEB2015 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | NAME | Harrisburg, PA 17105-3608 |
| | ANGLES | FINISH | | CHK: L. ZHANG 06FEB2015 | | Ocean Side Feed Applicator | |
| MATERIAL | | FINISH | | APVD: H. GUO 06FEB2015 | | RESTRICTED TO | |
| | | | | PRODUCT SPEC | | SIZE: CAGE CODE DRAWING NO | |
| | | | | APPLICATION SPEC | | A1 00779 C=2266673 | |
| | | | | WEIGHT | | SCALE: 1:2 SHEET 2 OF 4 REV: G1 | |
| | | | | Customer Accessible Production Drawing | | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|--------------------------|--------------------------------------|-------------------|-----------------------------------|-----------------------|-------------|-------------|-------------|------------------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | | | | | | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 |
| | 2-2266673-1 | G | 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 | - | 8-2266673-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266673-4 | - | - | - |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | 2-2266673-2 | G | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | - | 8-2266673-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266673-4 | - | - | - |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 |
| | | | | | 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 |
| 2-2266673-5 | G | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | |
| | | | | 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 | |
| 2-2266673-7 | G | FINE CRIMP HEIGHT ADJUST | NONE | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | |
| | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | 2168400-6 (QUANTITY 2) | |
| 4-2266673-2 | G | FINE CRIMP HEIGHT ADJUST | DOUBLE ACTING PNEUMATIC WITH SENSORS | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 | |
| | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266673-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | |
| | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266673-4 | - | - | 2168400-6 (QUANTITY 2) | |
| 7-2266673-7 | F | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------------------------|------|--|
| CRIMP SIZE | TYPE | |
| WIRE 1.07 mm [0.42] | F | |
| INSUL 1.55 mm [0.61] | O | |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|------------------------------|------------------------|-------------|
| TERMINAL NAME: CONTACT, MALE, GENERATION Y, 0.64 | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 4.00-4.50 mm [0.157-.177 IN] | Ø1.10-1.40 mm [0.43-.055 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | 114-13183 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1924968-8 | 1924727-4 | 1924275-8 | 1456841-8 |
| 2098753-4 | 1-1924727-4 | 1456574-8 | 1456968-8 |
| 1924955-8 | 2035170-4 | 2098762-4 | 2138699-4 |
| 2035334-8 | 1-2035170-4 | | 1-2138699-4 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|-----------------------------|--------------------------------|
| 0.35mm2 OR 22 AWG | 0.91+/-0.03 [0.036+/-0.001] | 8.8 |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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: 8-2266673-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266673-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266673-5
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- 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.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN WALL (FLR) INSULATION.

- DIMENSION 1.0±0.5 ON TERMINAL SUPPORT VIEW APPLIES TO ALL SOCKET TERMINALS.
- DIMENSION 4.2±0.5 ON TERMINAL SUPPORT VIEW APPLIES TO ALL PIN TERMINALS.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
- 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.

| -77 | -42 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |
|-----|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| - | - | - | - | - | - | 1803430-1 | AIR FEED MODULE | 290 |
| - | - | - | - | - | - | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |

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

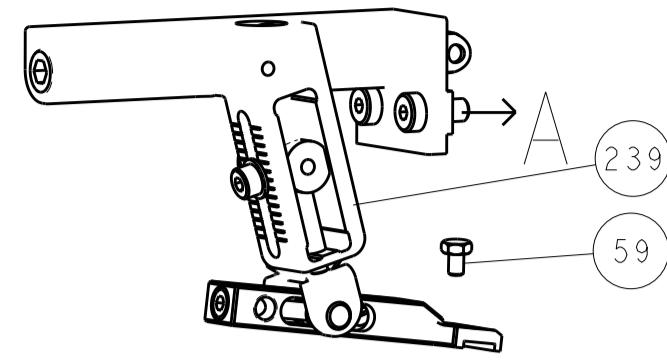
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPD |
| | | | - | SEE SHEET 1 | - | - |

| REV | DATE | BY | APPD | DESCRIPTION | DATE | BY | APPD | |
|-----|------|-----|------|-------------|------|-------------|-------------------------------------|-----|
| - | - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | 1 | - | 1803259-1 | BUSHING, FLANGED | 249 |
| - | 1 | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 1 | 1 | 2119082-5 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 1 | 1 | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | - | - | 2 | - | 2168400-6 | SHCS, LOW HEAD, RoHS, M5 X 16 | 240 |
| - | - | - | - | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | - | - | - | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | - | - | 1 | - | 2119740-2 | TAG IDENTIFICATION | 213 |
| - | - | - | - | 1 | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | - | - | - | - | 2 | 21045-3 | 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 | - | - | 1 | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | 1 | 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 | 1 | 2119798-2 | DETENT PIN | 145 |
| - | 1 | 1 | 1 | 1 | 1 | 2079383-8 | SCR, BHSC, RoHS (M4 X 16) | 144 |
| - | 4 | 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 | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1 | 1 | 1 | 1 | 2119650-1 | RAM, ASIAN STYLE, SIDE FEED | 140 |
| - | 1 | 1 | 1 | 1 | 1 | 2119092-2 | BOLT, ADJUSTMENT | 139 |
| - | 1 | - | - | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | - | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| - | 1 | 1 | 1 | 1 | 1 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-4 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | 1 | 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 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| - | 3 | 3 | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62 |
| - | 1 | - | - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | - | - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 2 | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 53 |
| - | 1 | 1 | 1 | 1 | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 |
| - | 1 | 1 | 1 | 1 | 1 | 811242-5 | BUMPER, HOLD DOWN | 51 |
| - | 1 | 1 | 1 | 1 | 1 | 690753-2 | SPACER, TONKER | 50 |
| - | - | - | - | - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | 1 | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | 1 | 1 | 1 | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| - | 1 | 1 | 1 | 1 | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| - | 1 | 1 | 1 | 1 | 1 | 2119644-1 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 1 | 6-1752356-2 | 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 | 1320908-6 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 2119959-7 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 1 | 1 | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 1 | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| - | 1 | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1 | 1 | 1 | 1803095-6 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1803058-6 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2119757-3 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 3-238011-1 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1803019-1 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 8-1633860-6 | CRIMPER, WIRE | 1 |

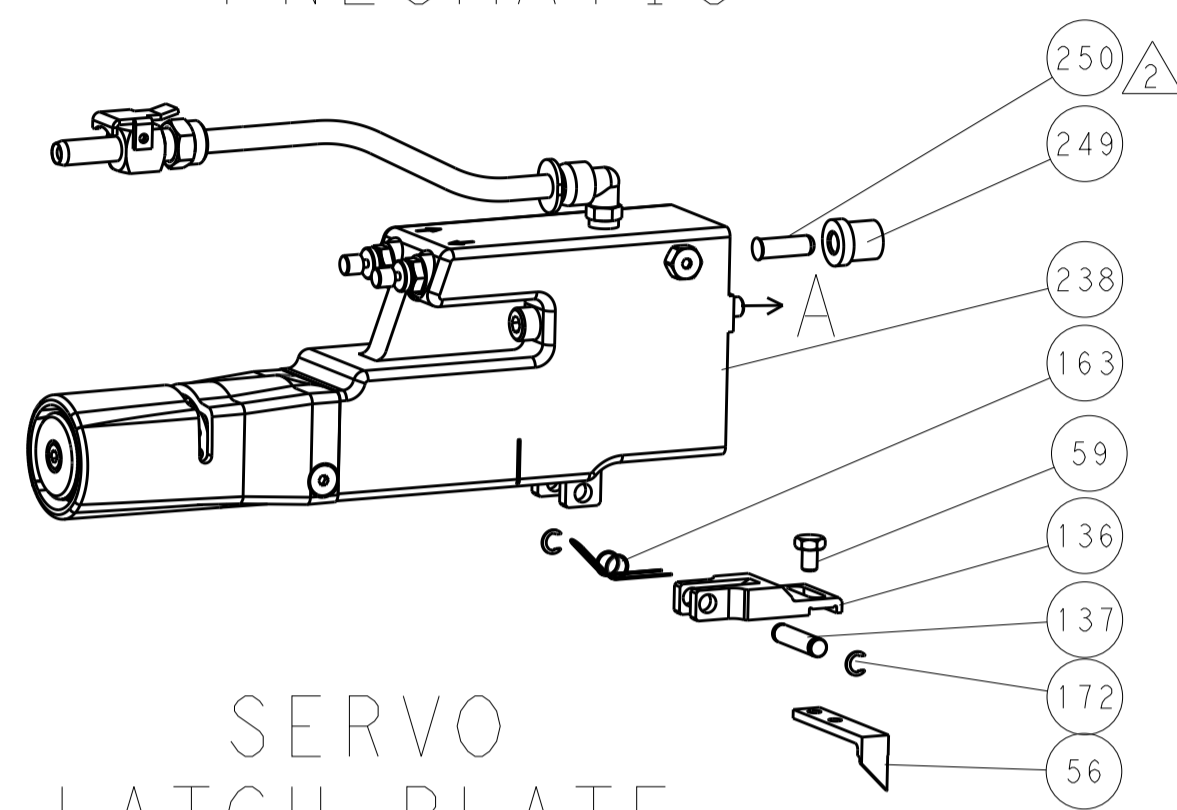
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DATE | | NAME | |
|--|---------|--|---------|-----------|---------|---------------|--------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES ± | FINISH |
| MATERIAL | | | | WEIGHT | | RESTRICTED TO | |
| Customer Accessible Production Drawing | | | | SCALE 1:2 | | SHEET 3 OF 4 | |

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

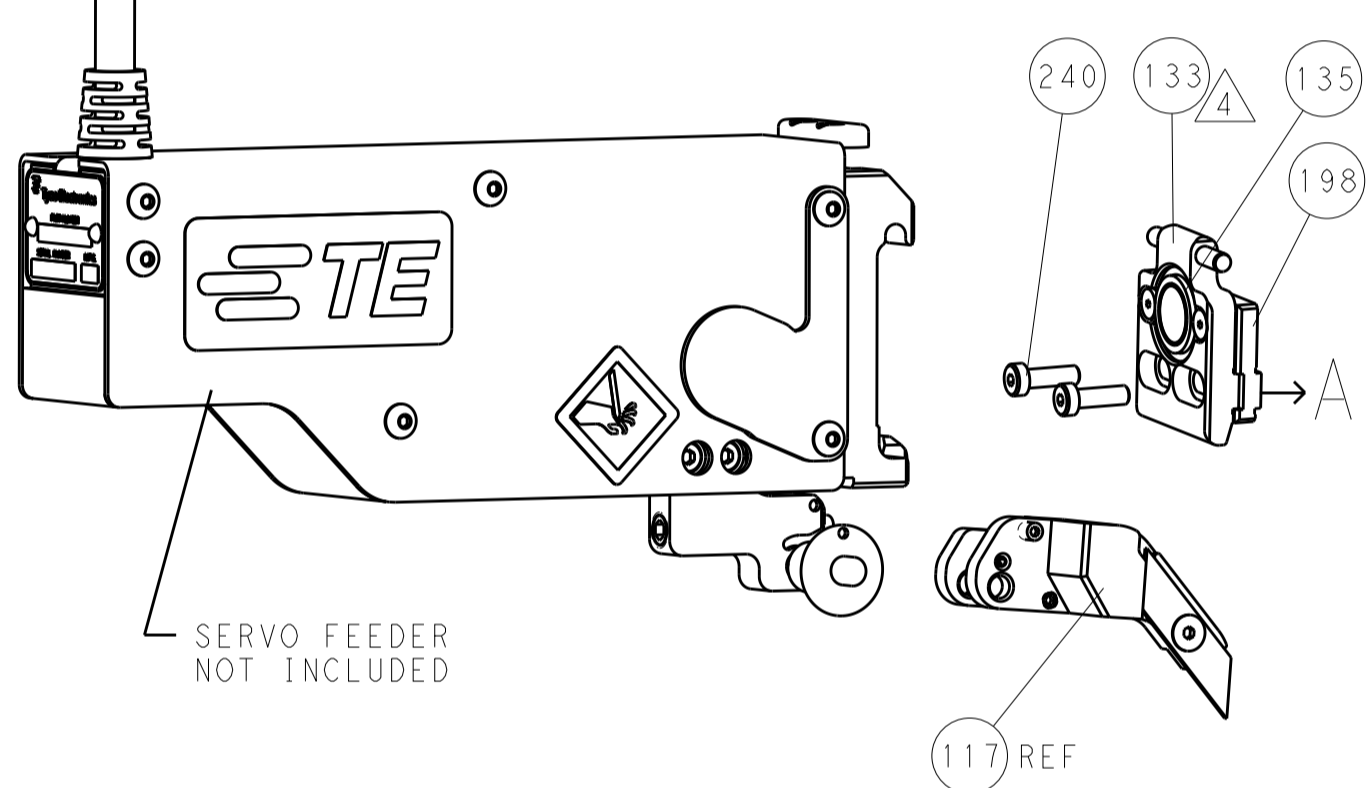
FEED TYPE MECHANICAL



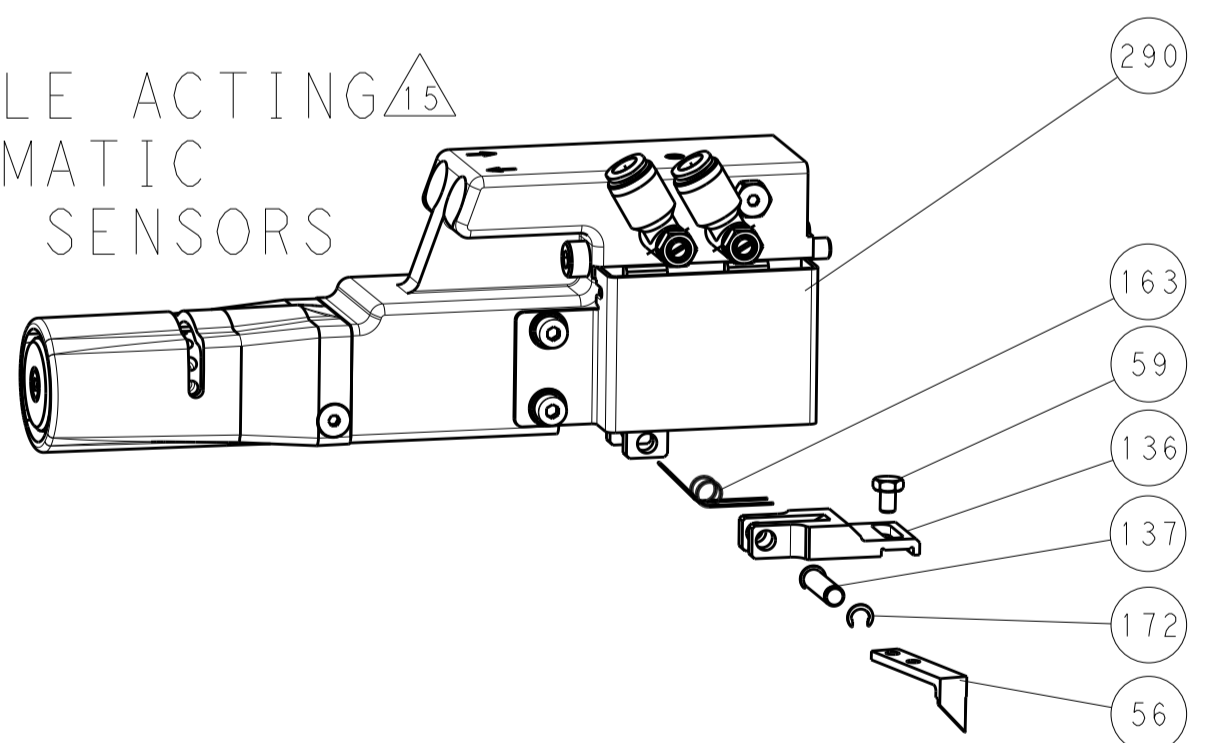
PNEUMATIC



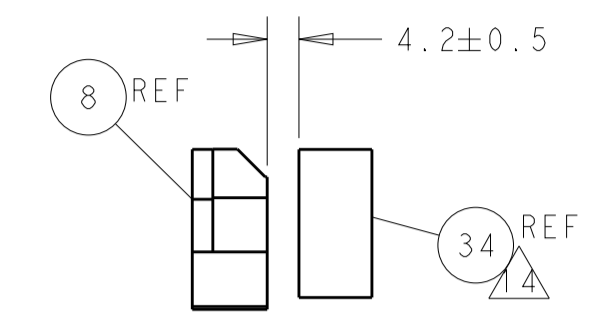
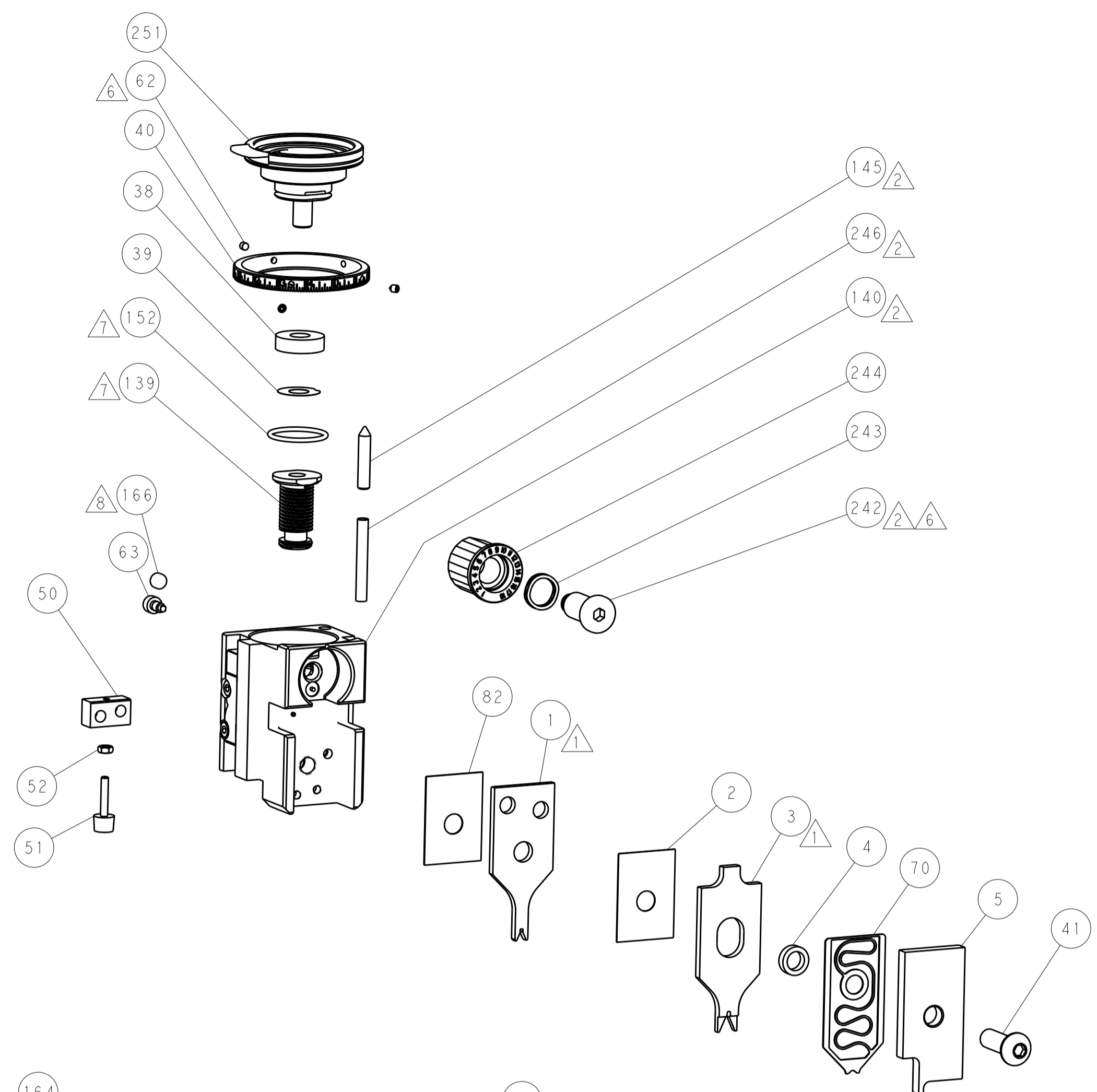
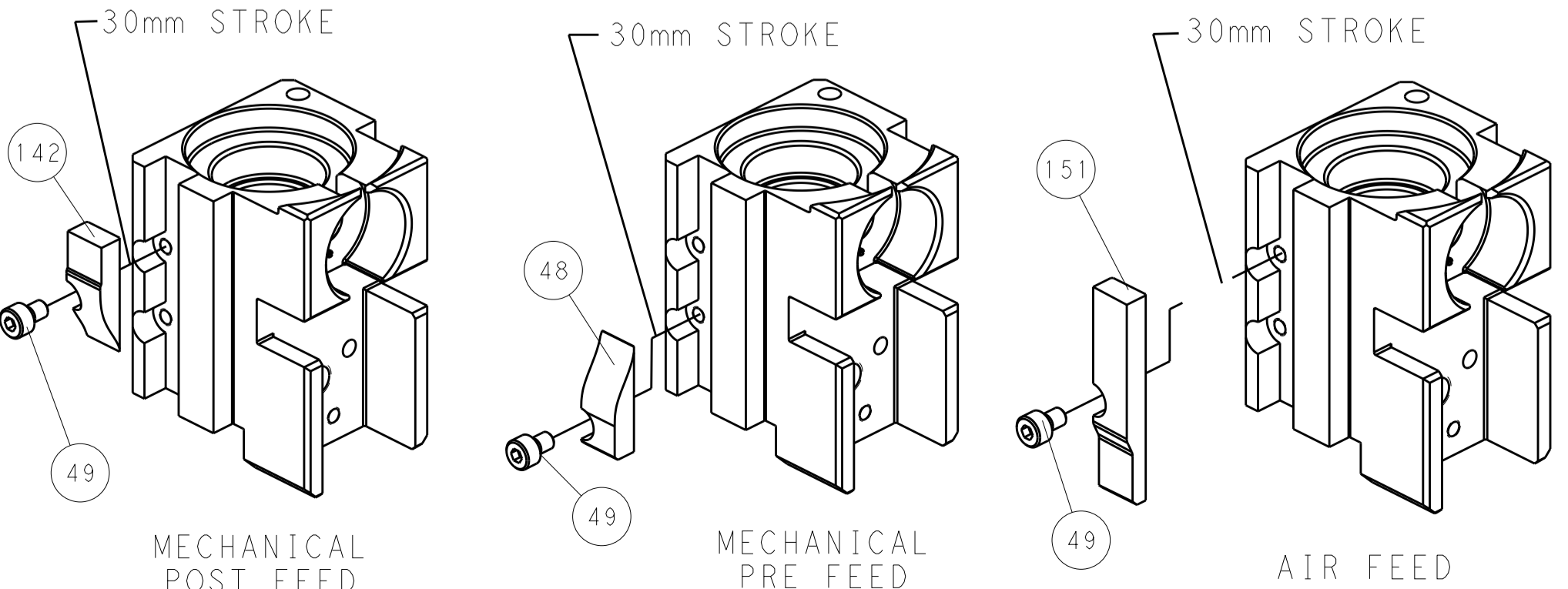
SERVO LATCH PLATE



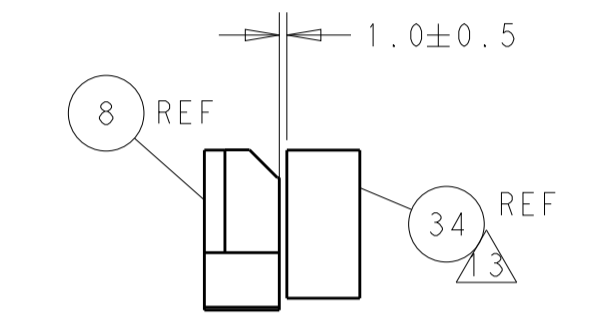
DOUBLE ACTING PNEUMATIC WITH SENSORS



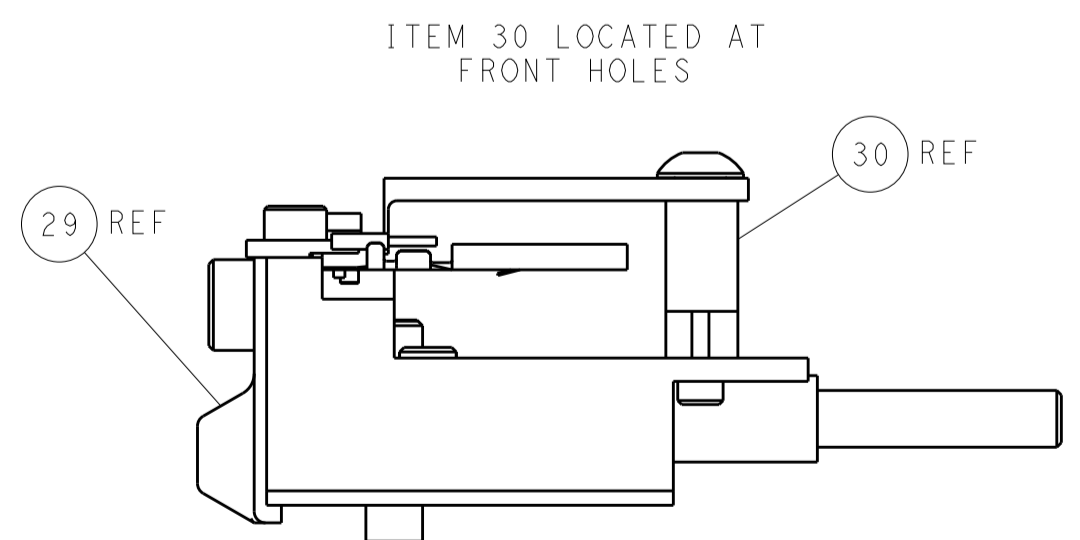
CAM POSITIONS



TERMINAL SUPPORT LOCATION FOR ALL PIN TERMINALS



TERMINAL SUPPORT LOCATION FOR ALL SOCKET TERMINALS



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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: J. HOU 06FEB2015 | | CHK: L. ZHANG 06FEB2015 | | APVD: H. GUO 06FEB2015 | | NAME: Ocean Side Feed Applicator | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH | WEIGHT | SIZE: A1 | CAGE CODE: 00779 | DRAWING NO: C=2266673 |
| Customer Accessible Production Drawing | | | | | | | | SCALE: 1:2 | SHEET: 4 | OF: 4 | REV: G1 |