

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2266073-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | 2266073-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | - | 8-2266073-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266073-4 | - | - | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | |
| | 2266073-5 | B | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1 | - | 8-2266073-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266073-4 | - | - | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | |
| 2266073-6 | B | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | - | |
| 2266073-7 | B | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2266073-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.90 mm [.075] | F |
| INSUL | 2.60 mm [.102] | F |

APPLICATOR INSTRUCTIONS
408-10389

| TERMINAL DATA: MOLEX TERMINAL | | MOLEX CRIMP SPECIFICATION | |
|--|--|------------------------------|--|
| TERMINAL NAME: MINI FIT CONNECTOR | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.00-3.50 mm [.118-.138 IN] | | Ø2.20-2.45 mm [.087-.096 IN] | |
| TERMINAL APPLICATION SPECIFICATION: ATS 63900-3000 Rev D | | | |

| TERMINALS APPLIED | | | |
|-------------------|----------------|-------------|----------------|
| TE TERMINAL | MOLEX TERMINAL | TE TERMINAL | MOLEX TERMINAL |
| 286673-1 | 39-00-0077 | 286857-1 | 39-00-0081 |
| 286673-2 | 39-00-0079 | 286857-2 | 39-00-0083 |
| 286673-3 | 39-00-0089 | 286857-3 | 39-00-0095 |
| 286673-6 | 39-00-0185 | 286857-4 | 39-00-0124 |
| 286673-7 | 39-00-0211 | 286857-5 | 39-00-0130 |
| 286673-8 | 39-00-0217 | 286857-6 | 39-00-0223 |
| 286673-9 | 39-00-0093 | 1-286857-4 | 44485-3211 |
| 1-286673-9 | 45750-3211 | 1-286857-6 | 46012-3111 |
| 2-286673-0 | 45750-3111 | 1-286857-7 | 46012-3141 |
| 2-286673-1 | 46018-3541 | 1-286857-8 | 46012-3211 |
| 2-286673-2 | 44478-3111 | 1-286857-9 | 46012-3241 |
| 2-286673-3 | 44476-3111 | 2-286857-0 | 44485-3411 |
| | | 2-286857-1 | 44476-3211 |
| | | 2-286857-2 | 44478-3211 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|----------------------------|--------------------------------|
| 16 AWG OR 1.31mm2 | 1.19+/-0.05 [.047+/-0.002] | 5.7 |

- 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: 8-2266073-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266073-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266073-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266073-6
- 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. 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 4.61.

***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 | 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 |
| -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)

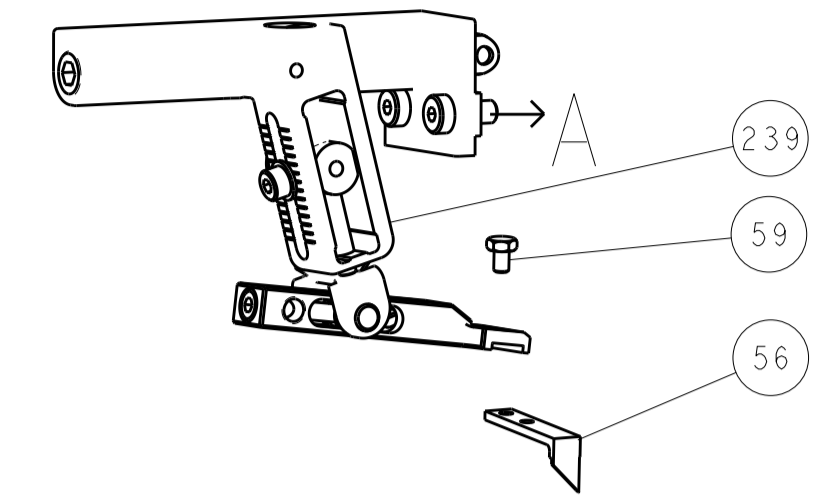
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|---------------|-----------|-------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPV |
| | | | A | RELEASED | 15NOV2013 | XZ TE |
| | | | A1 | ECR-14-013504 | 11SEP2014 | JH GB |
| | | | B | ECR-15-002260 | 12FEB2015 | JH GB |

| | | | | | | | | |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | - | 1 | - | - | - | 2119758-1 | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| - | 1 | 1 | 1 | 1 | 1 | 2119082-3 | 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 | 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 |
| - | - | - | - | 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 | - | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | REF | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY,SF | 117 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-7 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 5-547505-2 | 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 | 2119791-9 | 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 |
| - | 3 | - | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62 |
| - | 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 |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 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 | 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 | 2119644-1 | RAM WASHER, PRECISION | 38 |
| - | 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 | 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 | 1-1320908-0 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-9 | SPACER, CRIMPER | 28 |
| - | 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 | 1803095-1 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 3-1633928-2 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 1 | 5-240641-4 | SPACER | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2119780-9 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 238011-7 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 1633961-8 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | - | - | - | - | - | - | - | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 5-1490019-8 | CRIMPER, WIRE PREMIUM | 1 |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

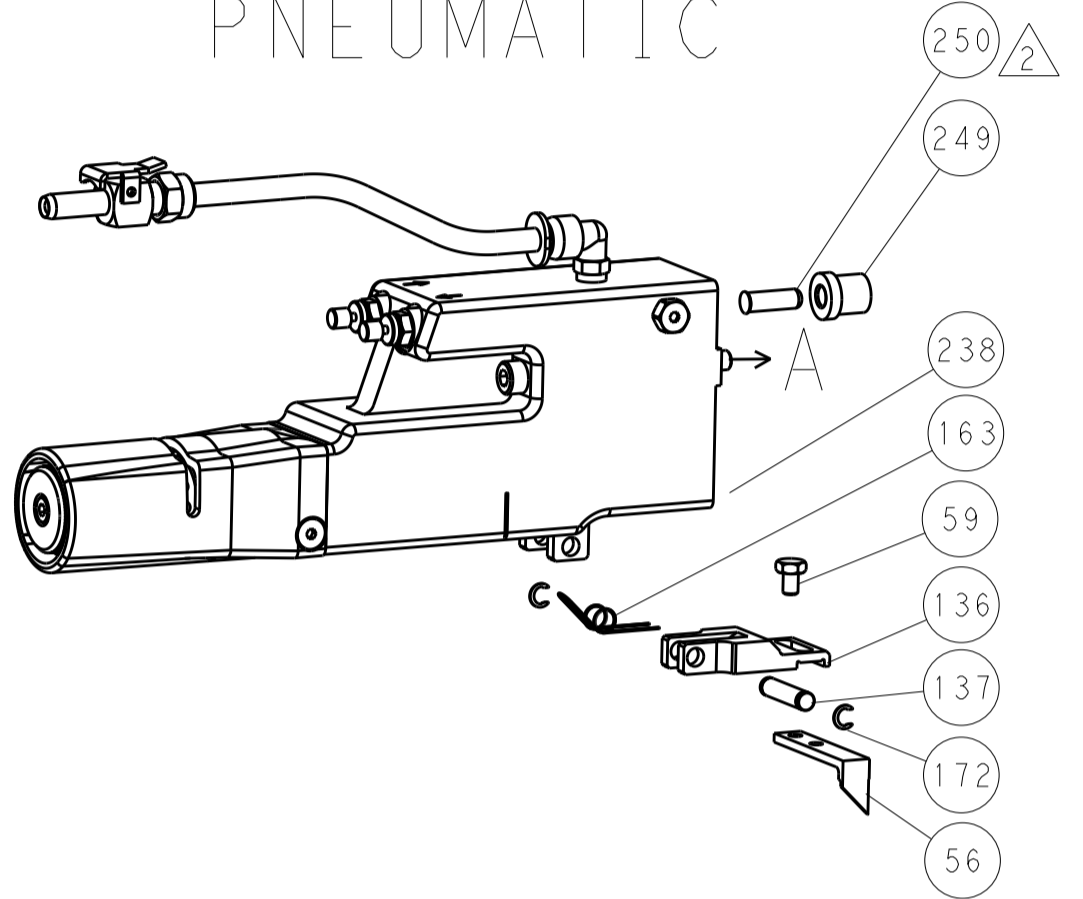
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DRAWING NO | | RESTRICTED TO | |
|--|-----------|--|------------|-------------|--------------|---------------|--------|
| mm | 0 PLC ±.5 | 1 PLC ±.5 | 2 PLC ±.13 | 3 PLC ±.013 | 4 PLC ±.0001 | ANGLES ±.0001 | FINISH |
| MATERIAL | | | | WEIGHT | | SCALE | |
| Customer Accessible Production Drawing | | | | SCALE 1:2 | | SHEET 1 of 4 | |

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

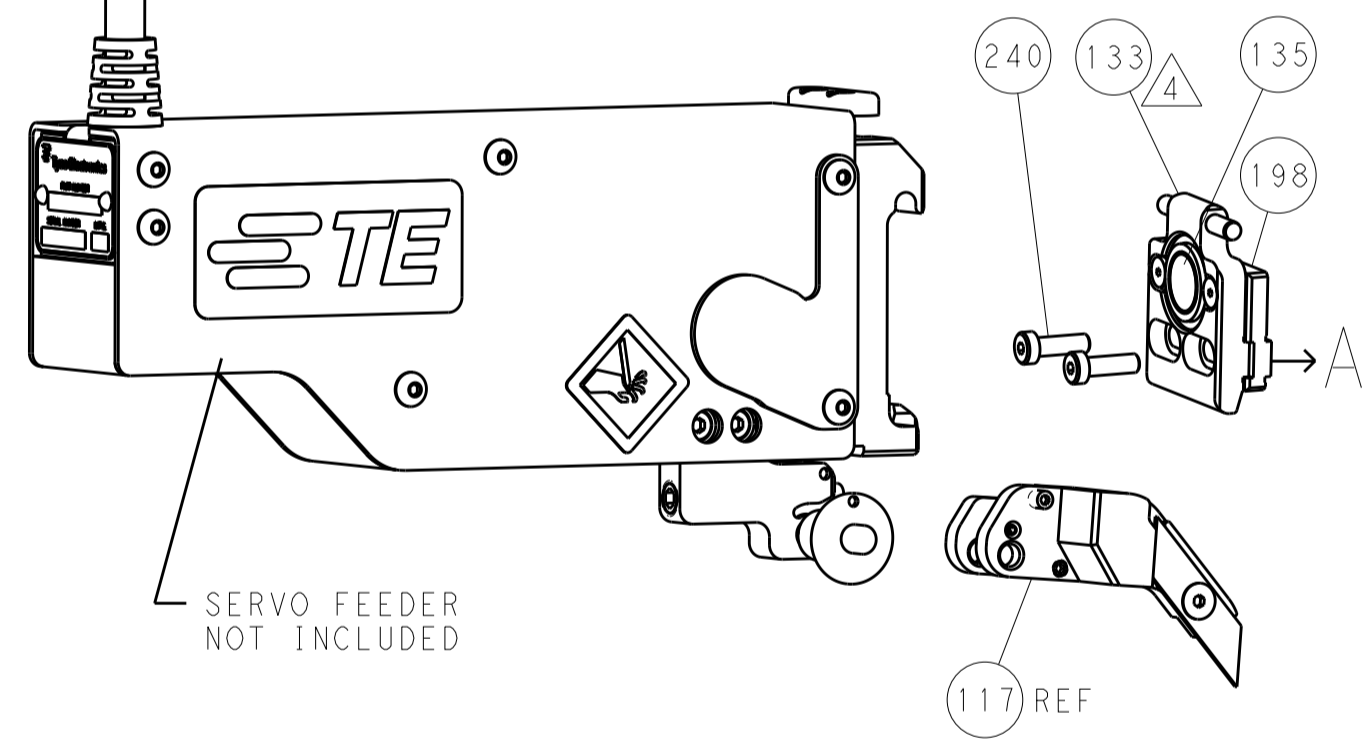
FEED TYPE MECHANICAL



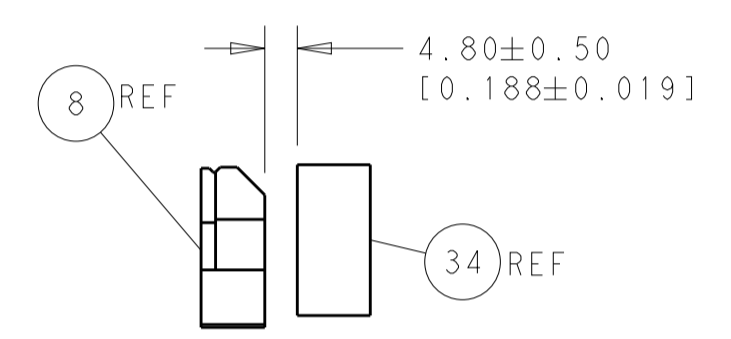
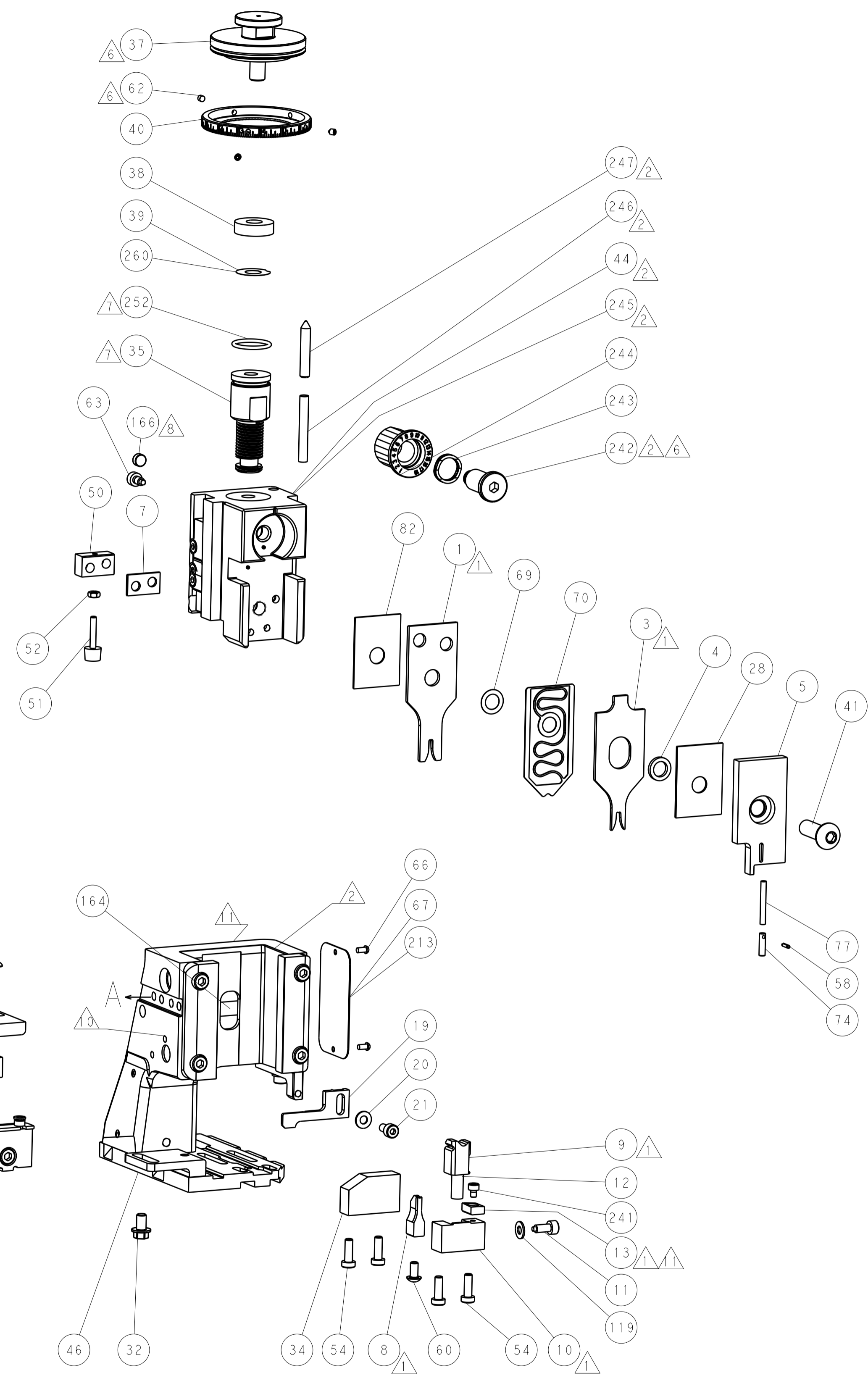
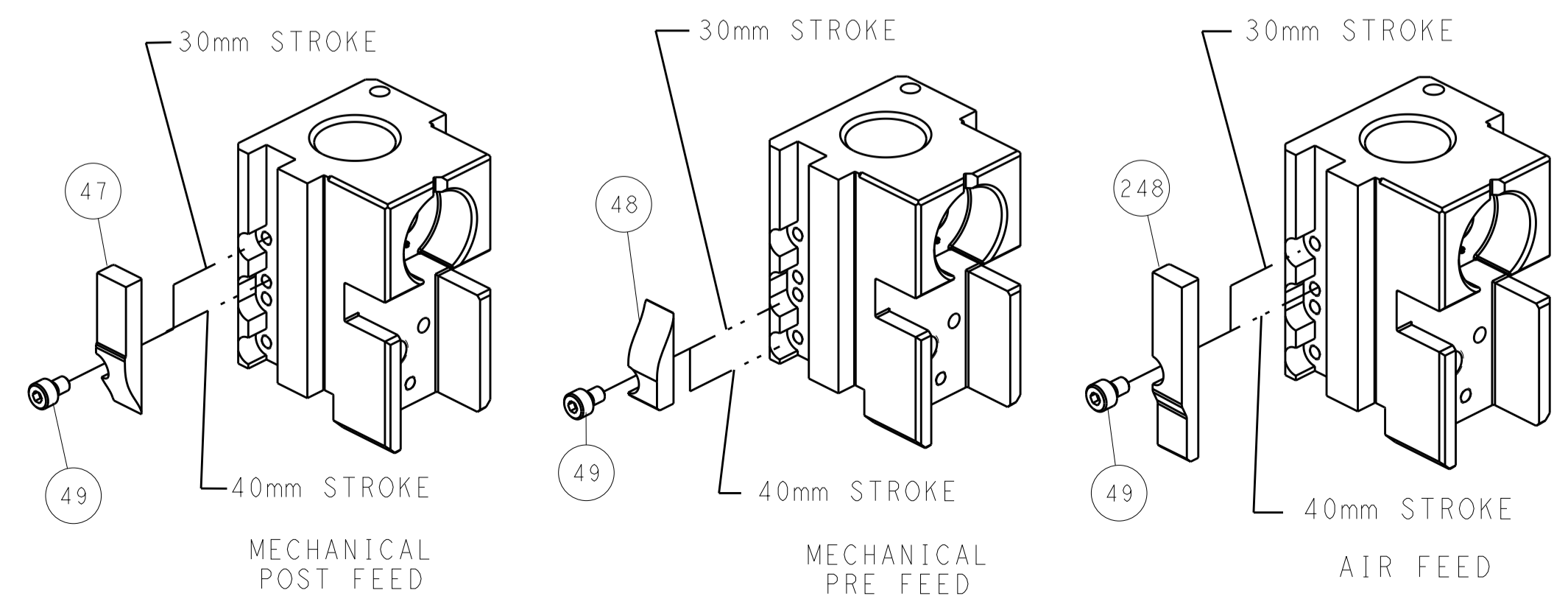
PNEUMATIC



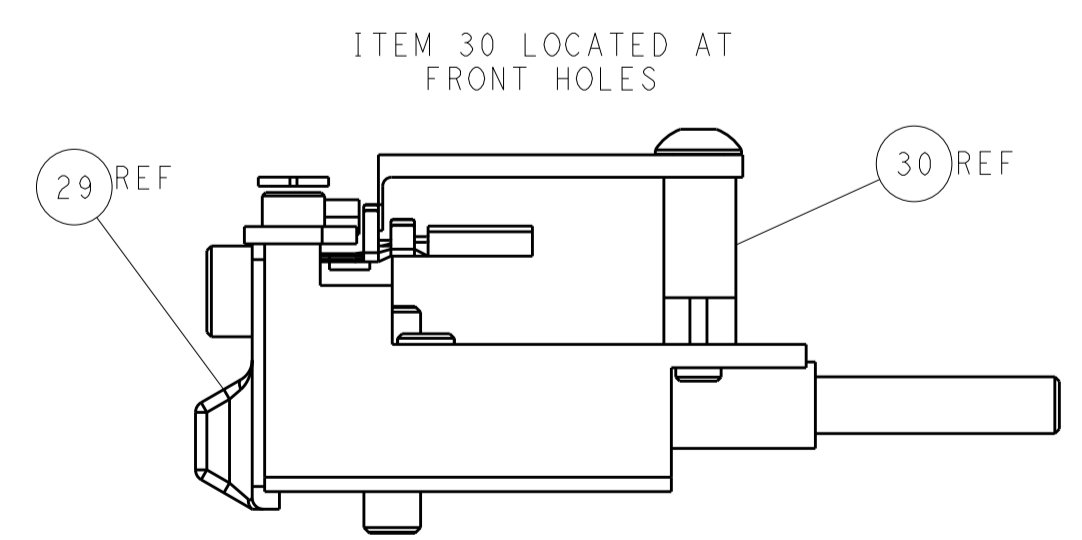
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 X ZHAO 11OCT2013 | | TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.0013 | APVD T. ZHANG 11OCT2013 | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | NAME | | Ocean Side Feed Applicator | |
| - | | - | | SIZE | | RESTRICTED TO | |
| - | | - | | CAGE CODE | | DRAWING NO | |
| - | | - | | A11 00779 | | C=2266073 | |
| - | | - | | WEIGHT | | SCALE | |
| - | | - | | - | | 1:2 SHEET 2 OF 4 REV B | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|--------------------------|--------------------------|-----------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2266073-1 | B | 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 | - | 8-2266073-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266073-4 | - | - | - |
| | 2-2266073-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266073-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
| 2-2266073-5 | B | 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 |
| 2-2266073-7 | B | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2266073-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.90 mm [.075] | F |
| INSUL | 2.60 mm [.102] | F |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: MOLEX TERMINAL | | MOLEX CRIMP SPECIFICATION | |
|------------------------------------|--|------------------------------|--|
| TERMINAL NAME: MINI FIT CONNECTOR | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.00-3.50 mm [.118-.138 IN] | | Ø2.20-2.45 mm [.087-.096 IN] | |
| TERMINAL APPLICATION SPECIFICATION | | | |
| TERMINALS APPLIED | | | |

| TE TERMINAL | MOLEX TERMINAL | TE TERMINAL | MOLEX TERMINAL |
|-------------|----------------|-------------|----------------|
| 286673-1 | 39-00-0077 | 286857-1 | 39-00-0081 |
| 286673-2 | 39-00-0079 | 286857-2 | 39-00-0083 |
| 286673-3 | 39-00-0089 | 286857-3 | 39-00-0095 |
| 286673-6 | 39-00-0185 | 286857-4 | 39-00-0124 |
| 286673-7 | 39-00-0211 | 286857-5 | 39-00-0130 |
| 286673-8 | 39-00-0217 | 286857-6 | 39-00-0223 |
| 286673-9 | 39-00-0093 | 1-286857-4 | 44485-3211 |
| 1-286673-9 | 45750-3211 | 1-286857-6 | 46012-3111 |
| 2-286673-0 | 45750-3111 | 1-286857-7 | 46012-3141 |
| 2-286673-1 | 46018-3541 | 1-286857-8 | 46012-3211 |
| 2-286673-2 | 44478-3111 | 1-286857-9 | 46012-3241 |
| 2-286673-3 | 44476-3111 | 2-286857-0 | 44485-3411 |
| | | 2-286857-1 | 44476-3211 |
| | | 2-286857-2 | 44478-3211 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|---------------------------|--------------------------------|
| 16 AWG OR 1.31mm2 | 1.19+/-0.05 [.047+/-0.02] | 5.7 |

- 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: 8-2266073-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266073-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266073-5
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- 8 MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

***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 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | 1 | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| - | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 1 | 2119082-3 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| -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)

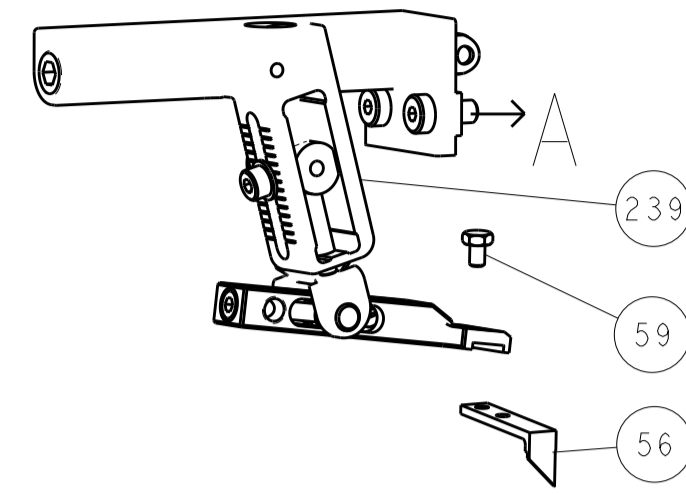
| SET UP GAUGE | LOC | DIST | REVISIONS | | | | | |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1 | A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | | - | - | SEE SHEET 1 | - | - | - |

| | | | | | | | |
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| - | - | - | - | - | - | - | 2 |
| - | 1 | 1 | 1 | 1 | 5-1490019-8 | CRIMPER, WIRE PREMIUM | 1 |
| -77 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

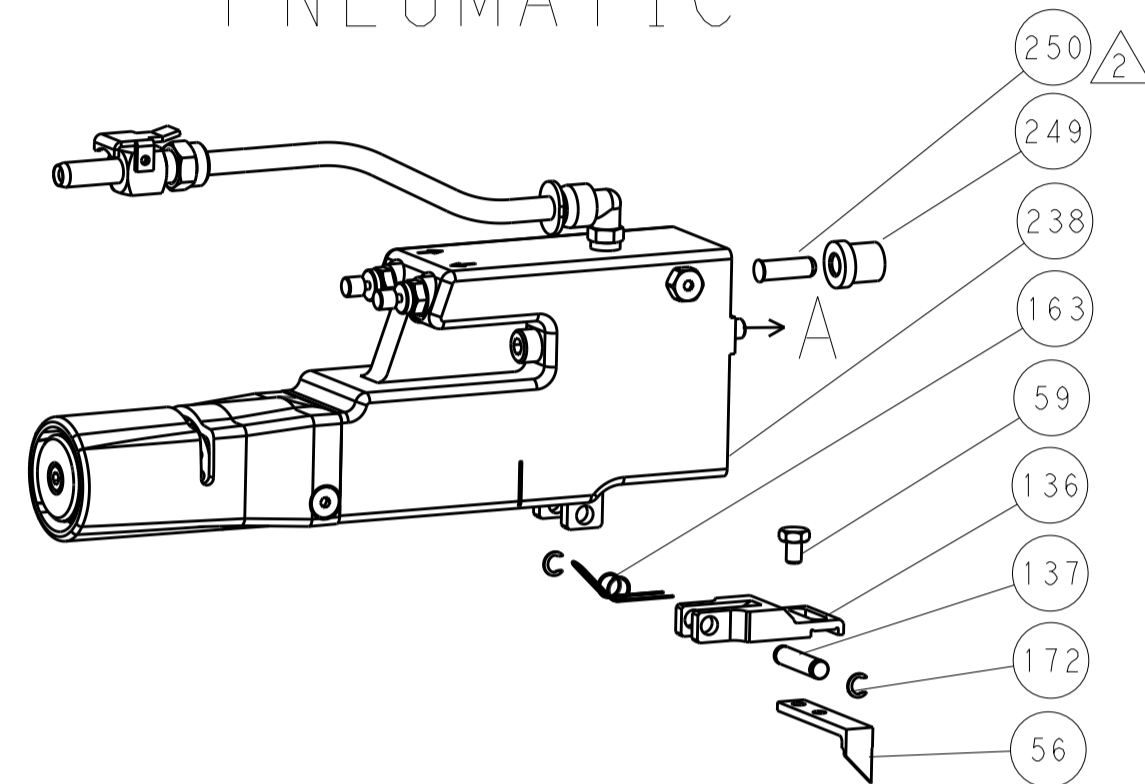
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DRAWING NO | | RESTRICTED TO | |
|--|-----------|--|------------|-------------|--------------|---------------|-----|
| mm | 0 PLC ±.5 | 1 PLC ±.5 | 2 PLC ±.13 | 3 PLC ±.013 | 4 PLC ±.0001 | ANGLES | ±.1 |
| MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: 1:2 | |
| Customer Accessible Production Drawing | | A1 | | 00779 | | REV B | |

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

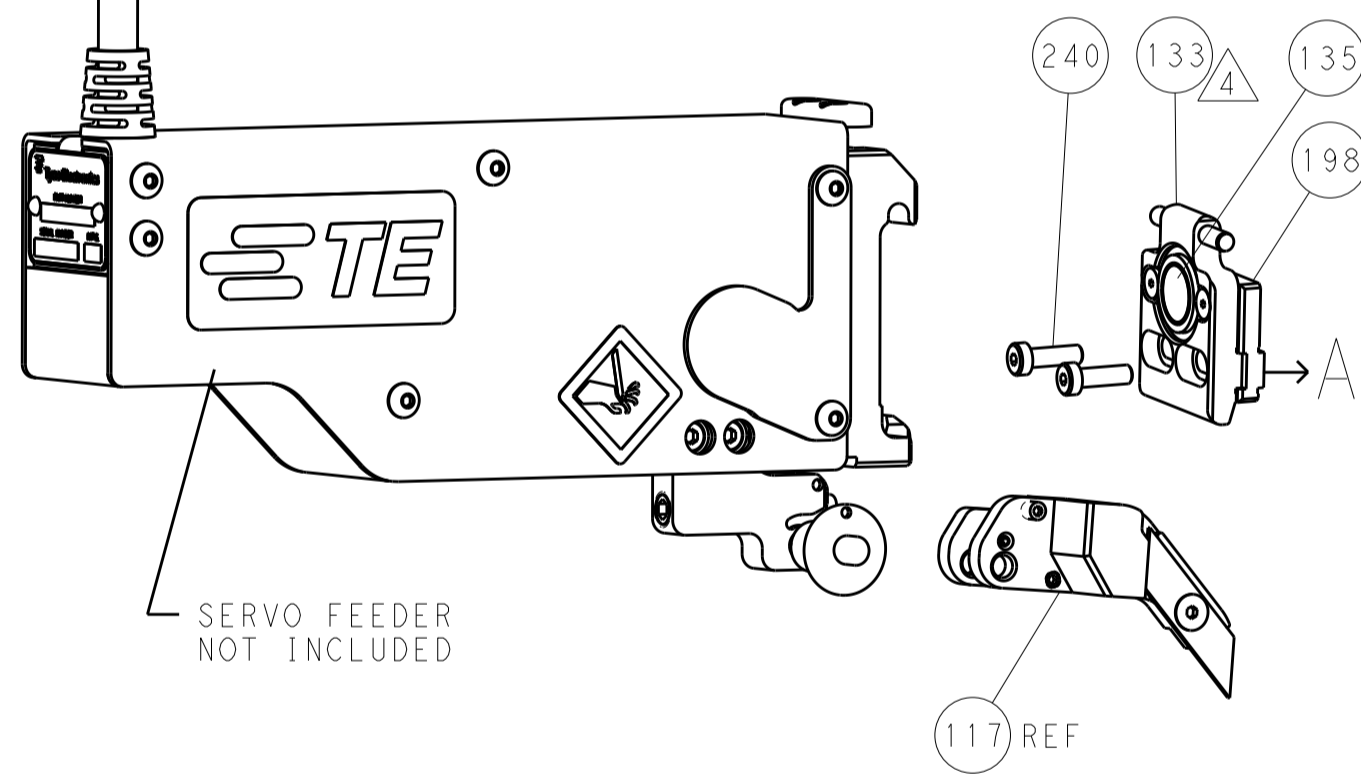
FEED TYPE MECHANICAL



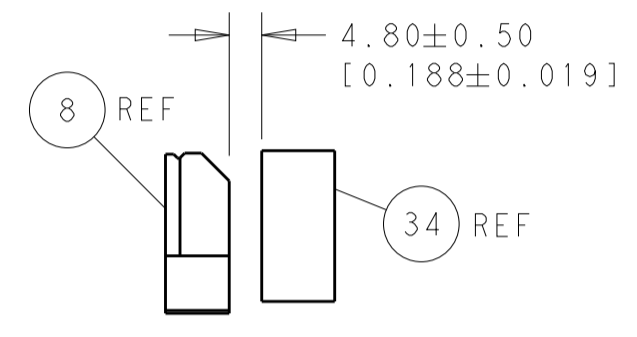
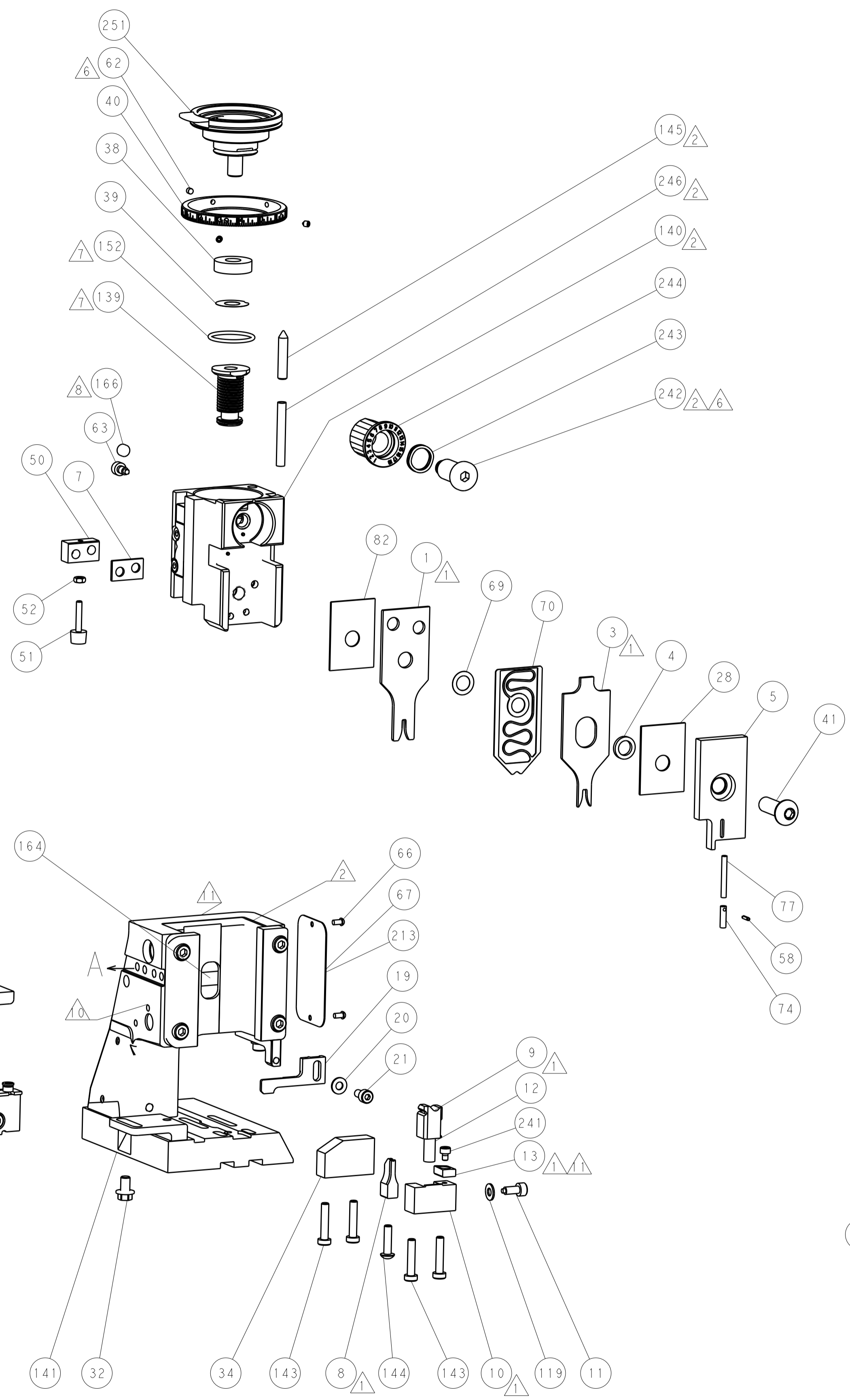
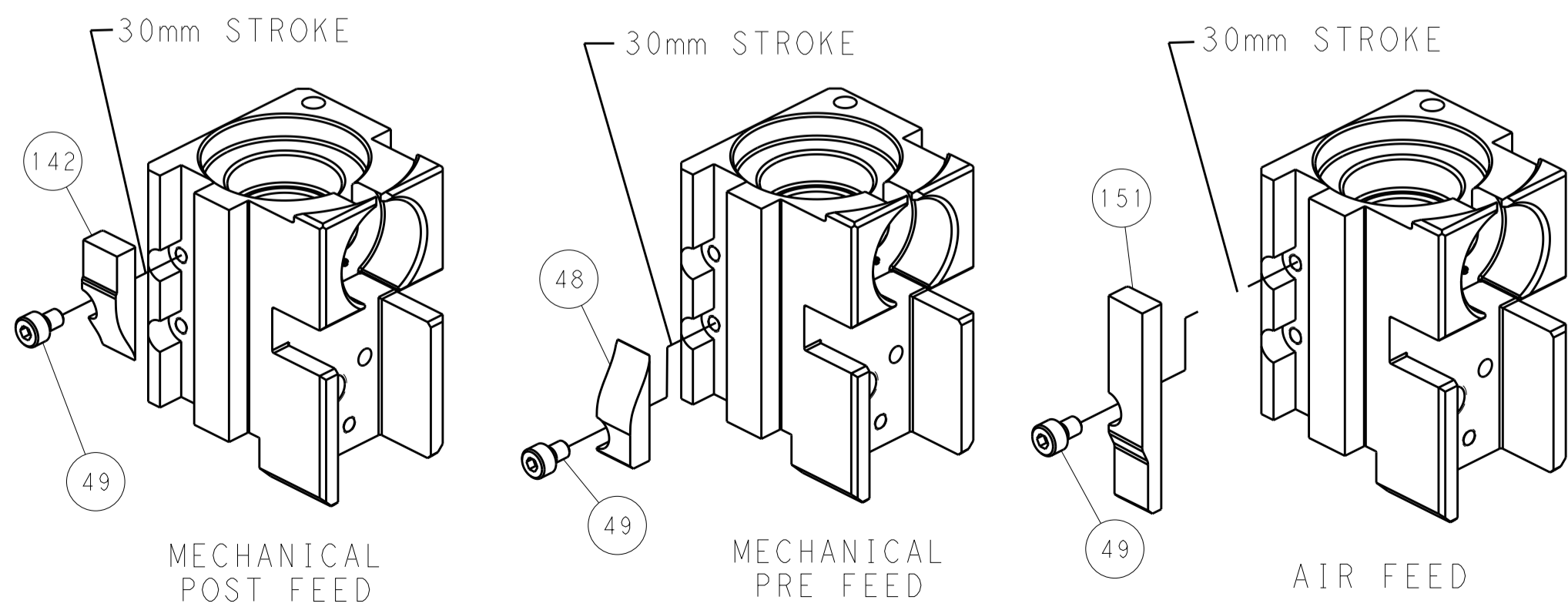
PNEUMATIC



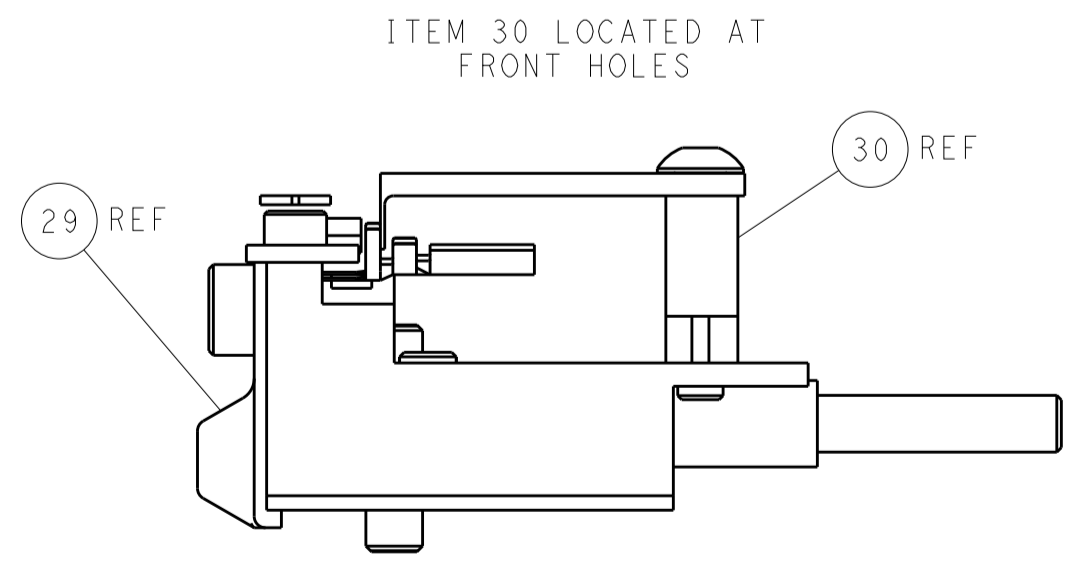
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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: | | DWN X ZHAO 11OCT2013 | | STE TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 | CHS T. ELBIN 11OCT2013 | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | APVD L. ZHANG 11OCT2013 | | NAME | |
| | | | | PRODUCT SPEC | | Ocean Side Feed | |
| | | | | APPLICATION SPEC | | Applicator | |
| | | | | WEIGHT | | SIZE CAGE CODE DRAWING NO | |
| | | | | A 00779 | | C=2266073 | |
| | | | | Customer Accessible Production Drawing | | RESTRICTED TO | |
| | | | | SCALE 1:2 | | SHEET 4 OF 4 REV B | |