

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION                    | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|-----------------------------------------------|-------------|--------------------------|--------------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|                                               |             |                          |                                |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|                                               | 2266561-1   | 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             | -         | 8-2266561-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|                                               | 2266561-2   | A                        | FINE CRIMP HEIGHT ADJUST       | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -         | -                      |
|                                               |             |                          |                                |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266561-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|                                               |             |                          |                                |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266561-4 | -         | -         |                        |
|                                               | 2266561-5   | A                        | FINE CRIMP HEIGHT ADJUST       | SERVO LATCH PLATE <sup>4</sup> | 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              |
| 2266561-6                                     | A           | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | -                              | -                                 | -                     | -         | -           | -         | -         |                        |
| 2266561-7                                     | A           | FINE CRIMP HEIGHT ADJUST | NONE                           | -                              | -                                 | -                     | -         | -           | -         | -         |                        |
| 7-2266561-7                                   | A           | CRIMP TOOLING KIT        | -                              | -                              | -                                 | -                     | -         | -           | -         | -         |                        |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.57 mm [.062] | F    |
| INSUL           | 3.94 mm [.155] | O    |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: TE TERMINAL                          | TE CRIMP SPECIFICATION             |
|-----------------------------------------------------|------------------------------------|
| TERMINAL NAME: 2.5 MM SYST., CONTACT PIN AND SOCKET |                                    |
| WIRE STRIP LENGTH<br>5.20-5.80 mm [.205-.228 IN]    | INSULATION DIAMETER RANGE<br>Ø 1.3 |
| TERMINAL APPLICATION SPECIFICATION<br>114-18031-1   |                                    |

| TERMINALS APPLIED |             |          |          |                |
|-------------------|-------------|----------|----------|----------------|
| TE TERMINAL       | TE TERMINAL | TE SEAL  | TE SEAL  | CABLE DIAMETER |
| 929943-2          | 929944-3    | 828920-1 | 828920-2 | 1.2-2.0        |
| 929943-4          | 929944-4    |          |          |                |
| 929943-5          | 929944-5    |          |          |                |
| 929944-2          |             |          |          |                |

| WIRE SIZE           | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|-------------------------------|--------------------------------|
| 0.35mm <sup>2</sup> | 1.11 +/- 0.03 [.044 +/- .001] | 7.8                            |

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266561-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266561-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266561-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266561-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.69.
- <sup>13</sup> THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- <sup>14</sup> APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

**\*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     |
| -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)

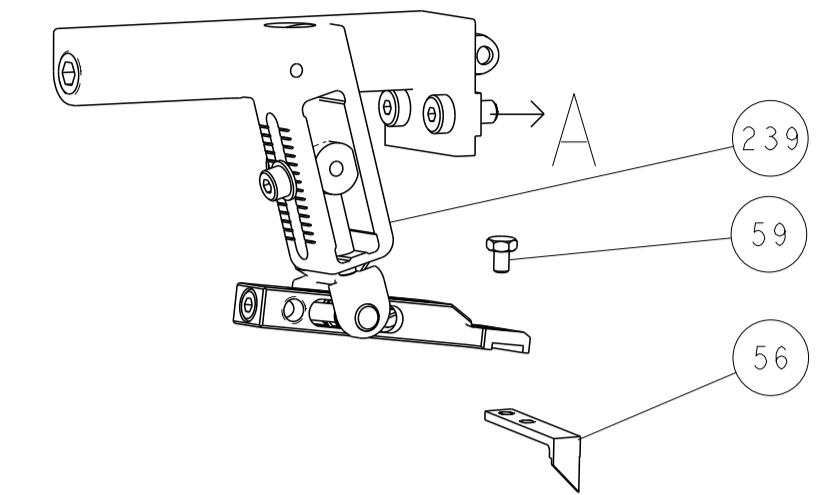
| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |           |     |      |
|--------------|-----|------|-----------|-----|-------------|-----------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE      | OWN | APVD |
|              |     |      | A         |     | RELEASED    | 13JAN2015 | RK  | GB   |

|     |     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | -   | -   | -   | 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     |
| -   | 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     |
| -   | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 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   | 985575-3    | SCR, FLT SKT HD CAP M3 X 10.0       | 57      |
| -   | -   | -   | -   | 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   | 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   | 455888-3    | 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      |
| -   | 2   | 2   | 2   | 2   | 2   | 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   | 318707-1    | FLOATING SHEAR, FRONT               | 9       |
| -   | 1   | 1   | 1   | 1   | 1   | 6-1333202-6 | ANVIL, COMBINATION                  | 8       |
| -   | 1   | 1   | 1   | 1   | 1   | 6-240641-4  | SPACER                              | 7       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1   | 2119781-1   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 1   | 238011-4    | BLOCK, CRIMPER SPACER               | 4       |
| -   | 1   | 1   | 1   | 1   | 1   | 2-2119784-9 | CRIMPER, INSULATION O PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 1   | 1-455888-3  | SPACER, CRIMPER                     | 2       |
| -   | 1   | 1   | 1   | 1   | 1   | 4-456403-7  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

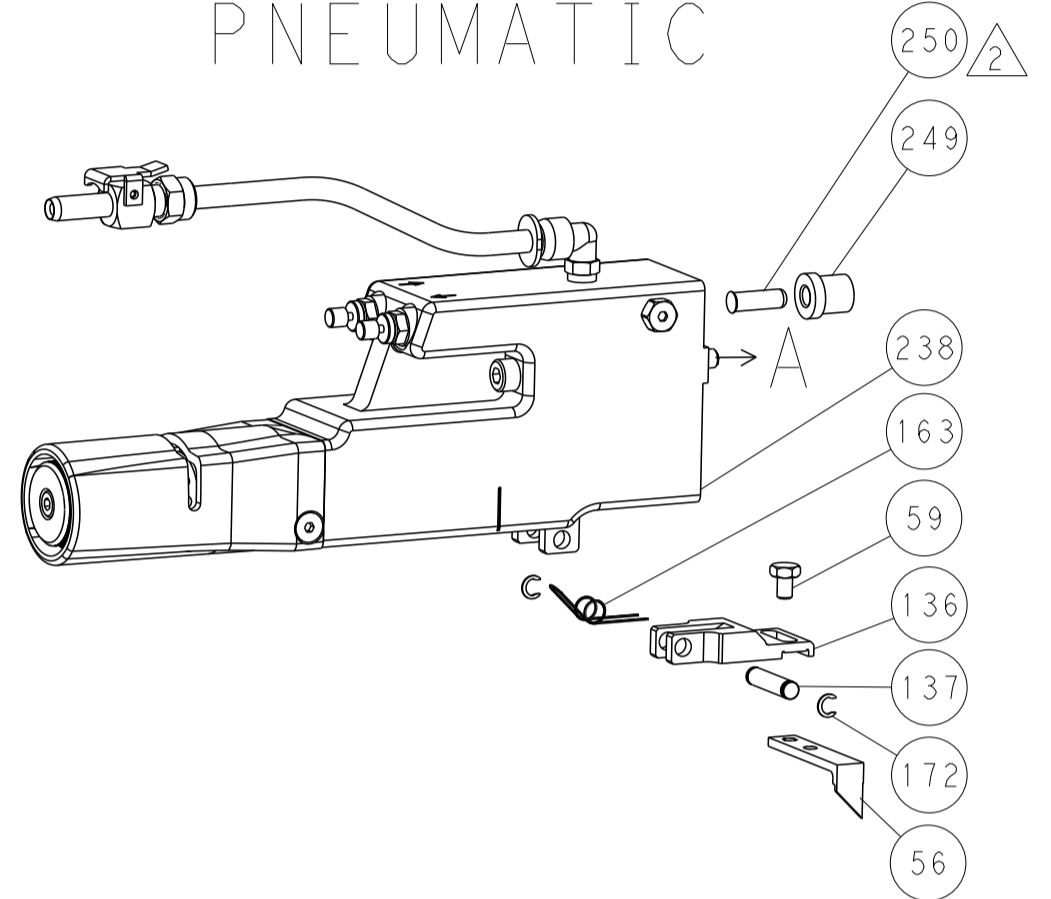
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|-------------|--------------|----------------------------------------|-----------|------------|-----------|
| mm          | 0 PLC ±.5    | 1 PLC ±.5                              | 2 PLC ±.5 | 3 PLC ±.5  | 4 PLC ±.5 |
|             | ANGLES ±.001 |                                        |           |            |           |
| MATERIAL    | FINISH       | WEIGHT                                 | SCALE     | SHEET      | REV       |
|             |              |                                        | 1:2       | 1 OF 4     | A         |

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

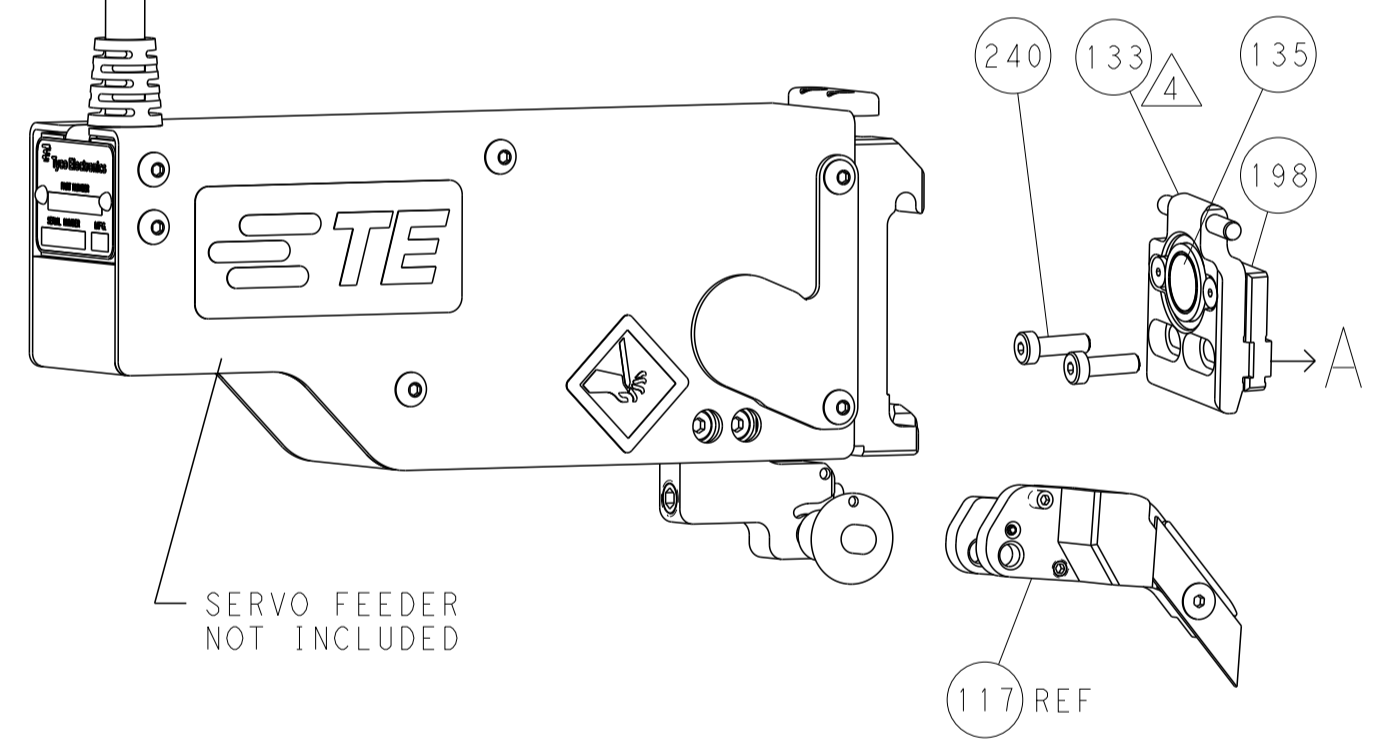
### FEED TYPE MECHANICAL



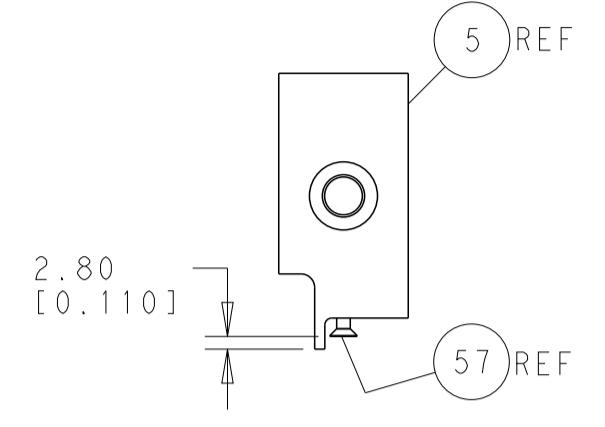
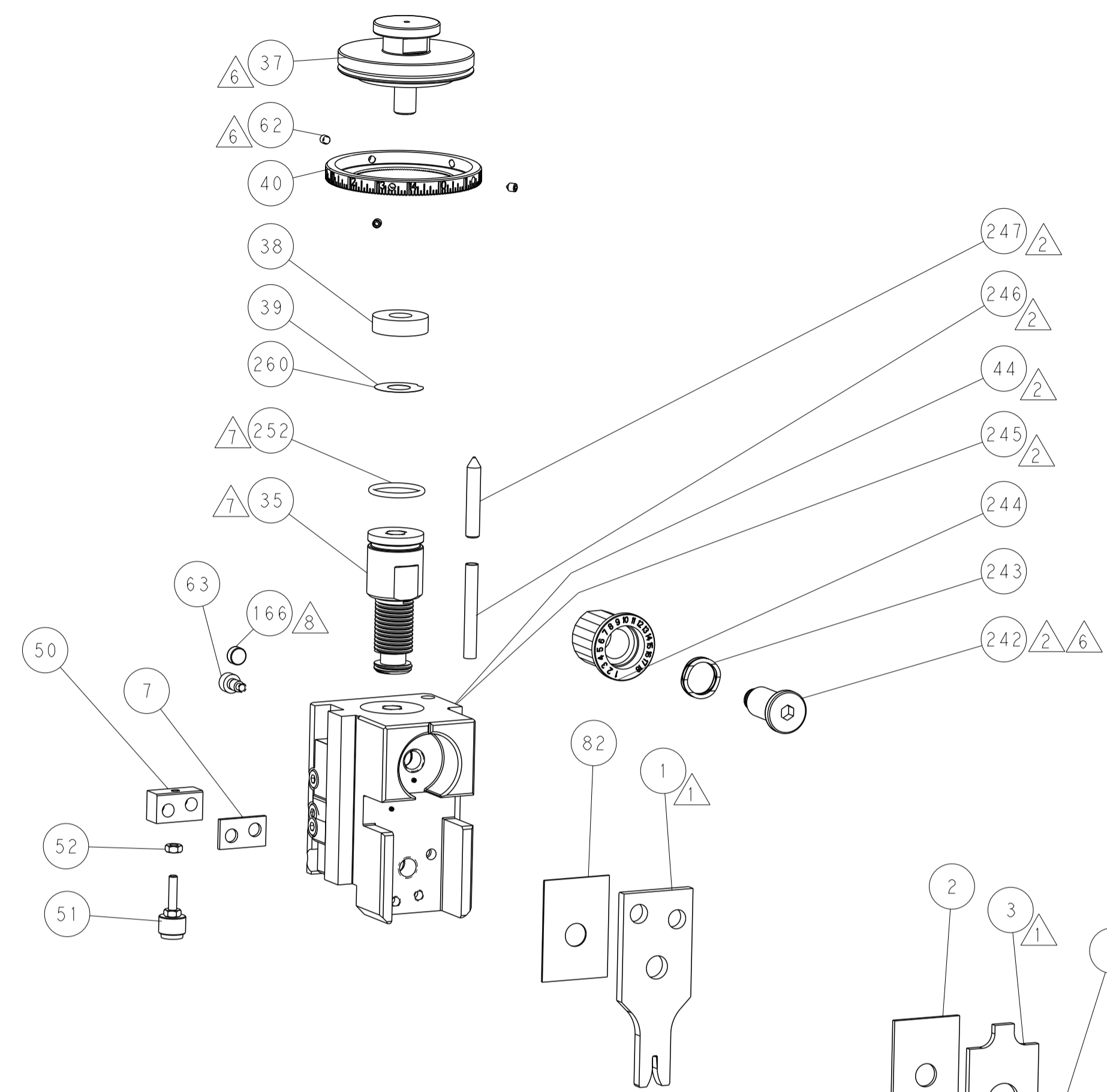
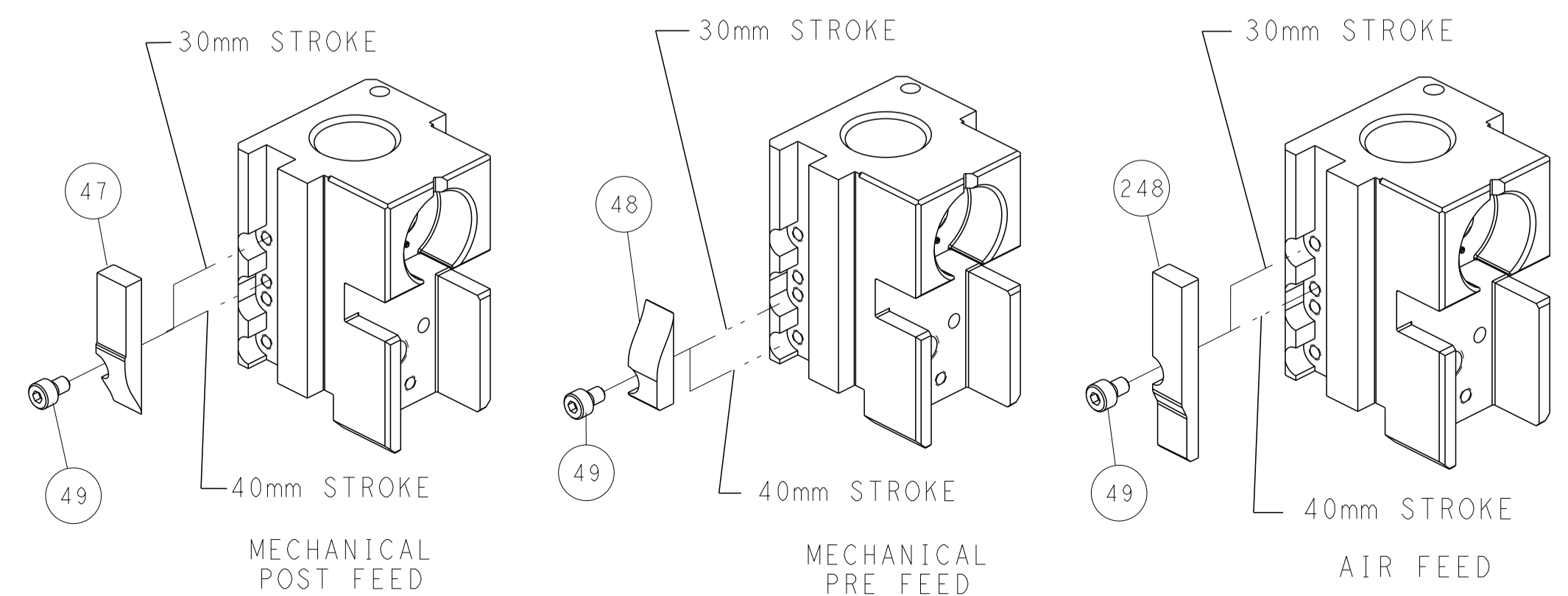
### PNEUMATIC



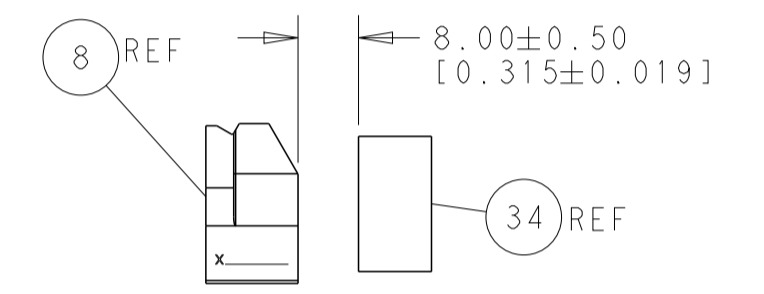
### SERVO LATCH PLATE



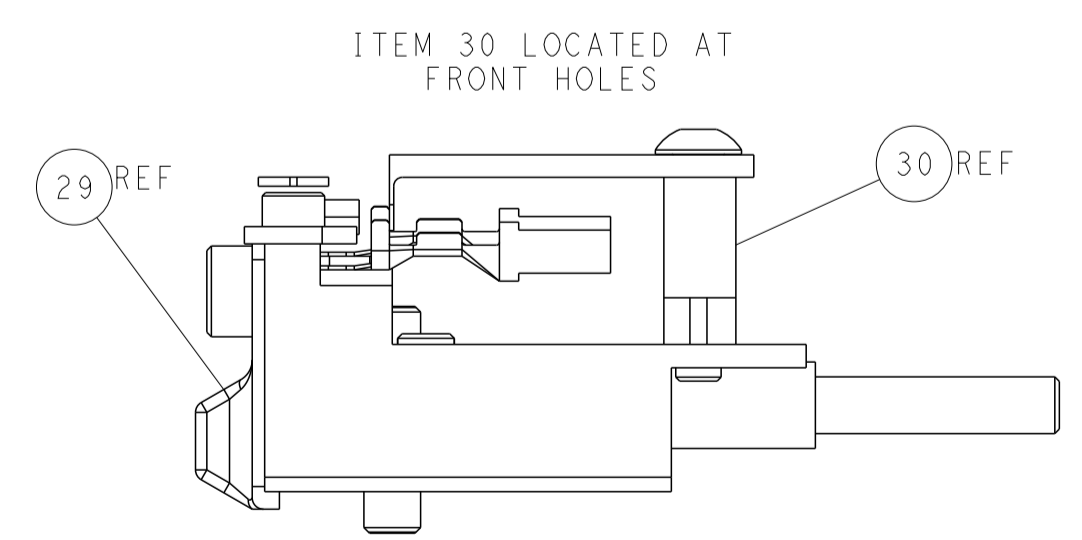
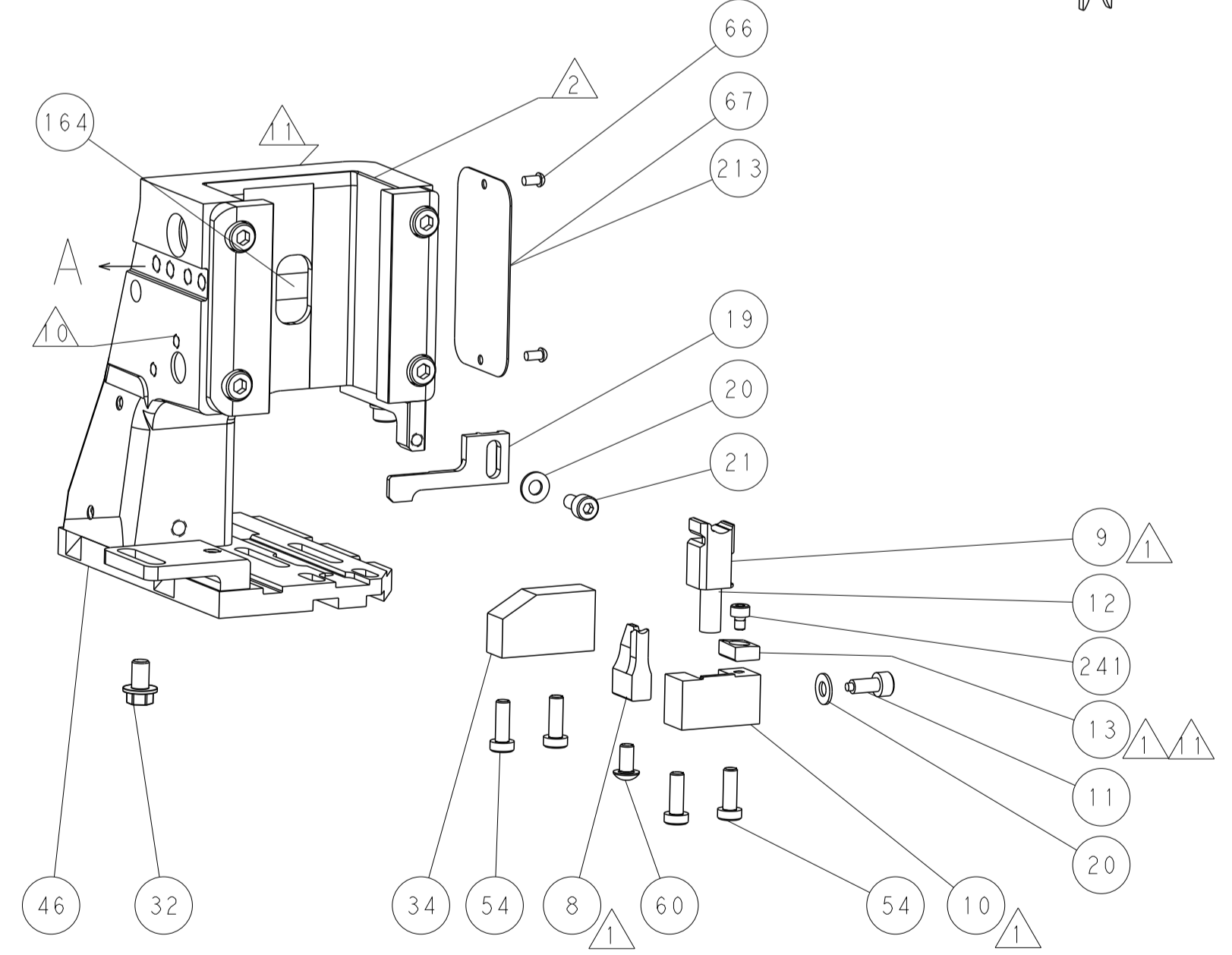
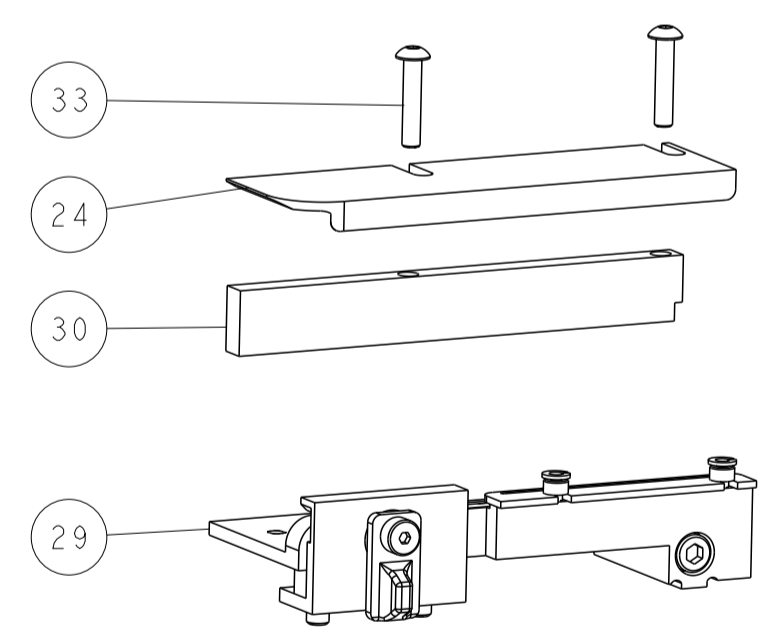
### CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

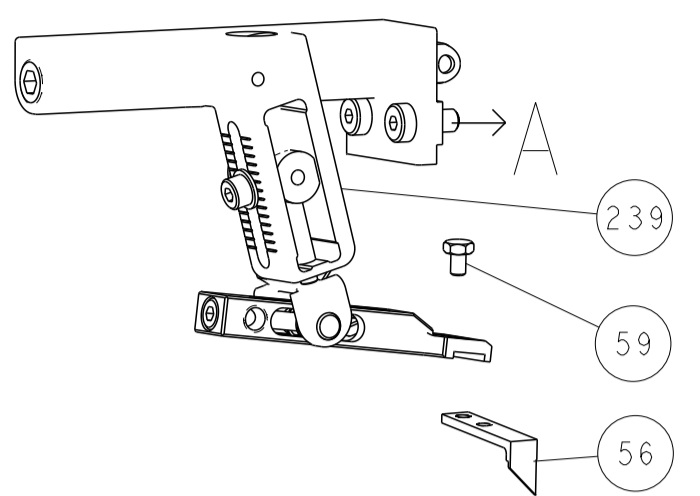
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

|             |                                                                          |                                        |  |                         |                                              |
|-------------|--------------------------------------------------------------------------|----------------------------------------|--|-------------------------|----------------------------------------------|
| DIMENSIONS: |                                                                          | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DWN: R. HUANG 29OCT2014 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| mm          | 0 PLC ±0.5<br>1 PLC ±0.5<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.0001 | FINISH:                                |  | CHK: L. ZHANG 29OCT2014 |                                              |
| MATERIAL:   |                                                                          |                                        |  | APVD: J. GUO 29OCT2014  | NAME: Ocean Side Feed Applicator             |
|             |                                                                          |                                        |  | PRODUCT SPEC:           | SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO:  |
|             |                                                                          |                                        |  | APPLICATION SPEC:       | SCALE: 1:2 SHEET 2 OF 4 REV A                |
|             |                                                                          |                                        |  | WEIGHT:                 | Customer Accessible Production Drawing       |
|             |                                                                          |                                        |  | APPROVALS:              |                                              |

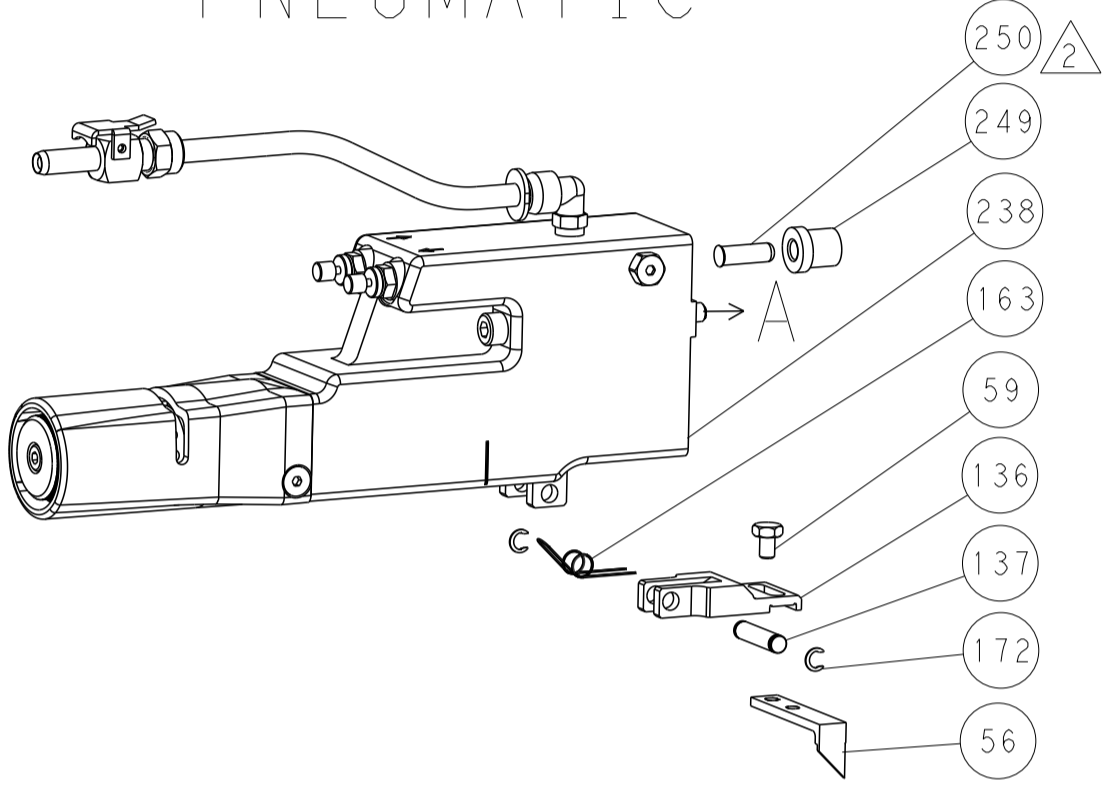


| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | OWN | APVD |
| -   | -  | -    | -   | SEE SHEET 1 | -    | -   | -    |

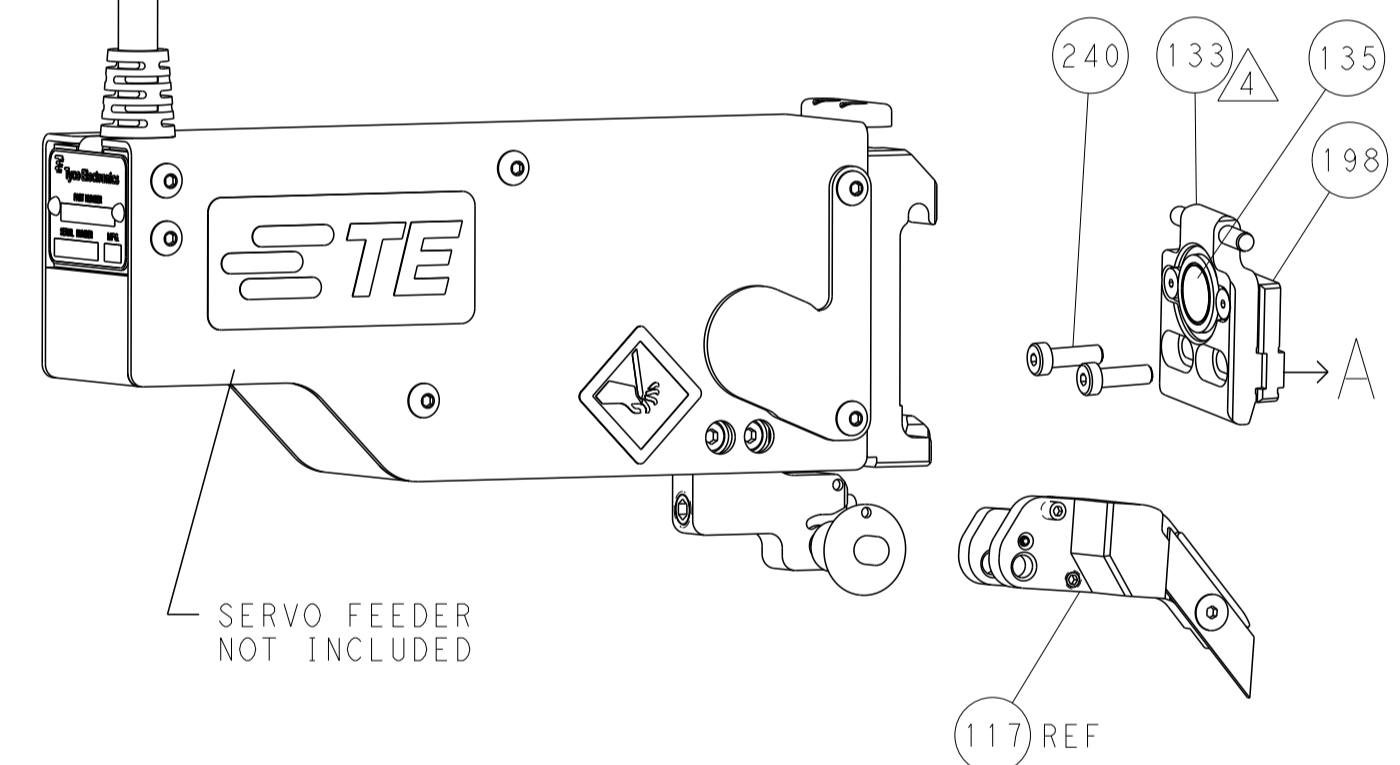
# FEED TYPE MECHANICAL



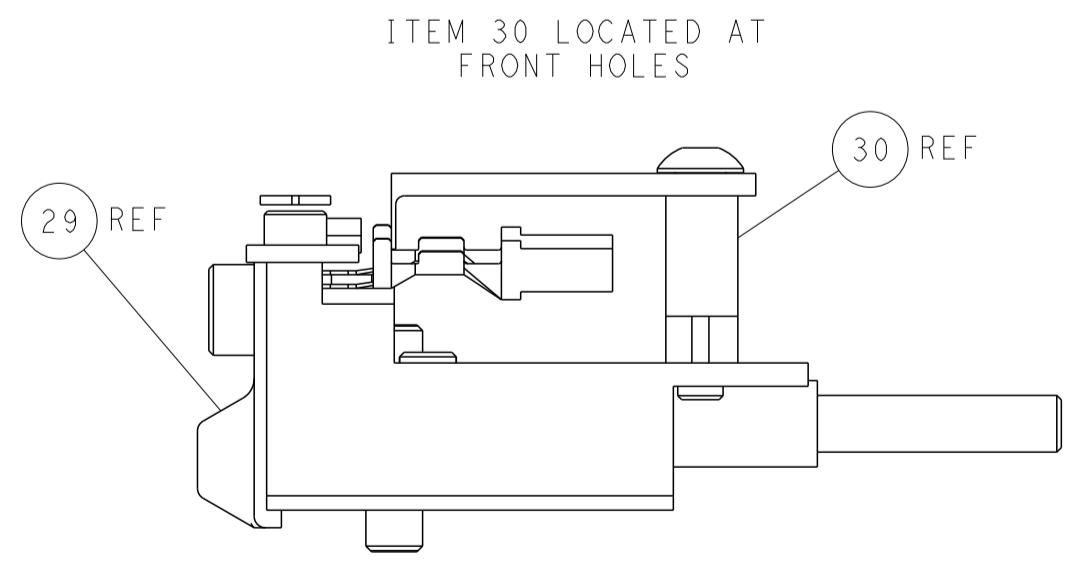
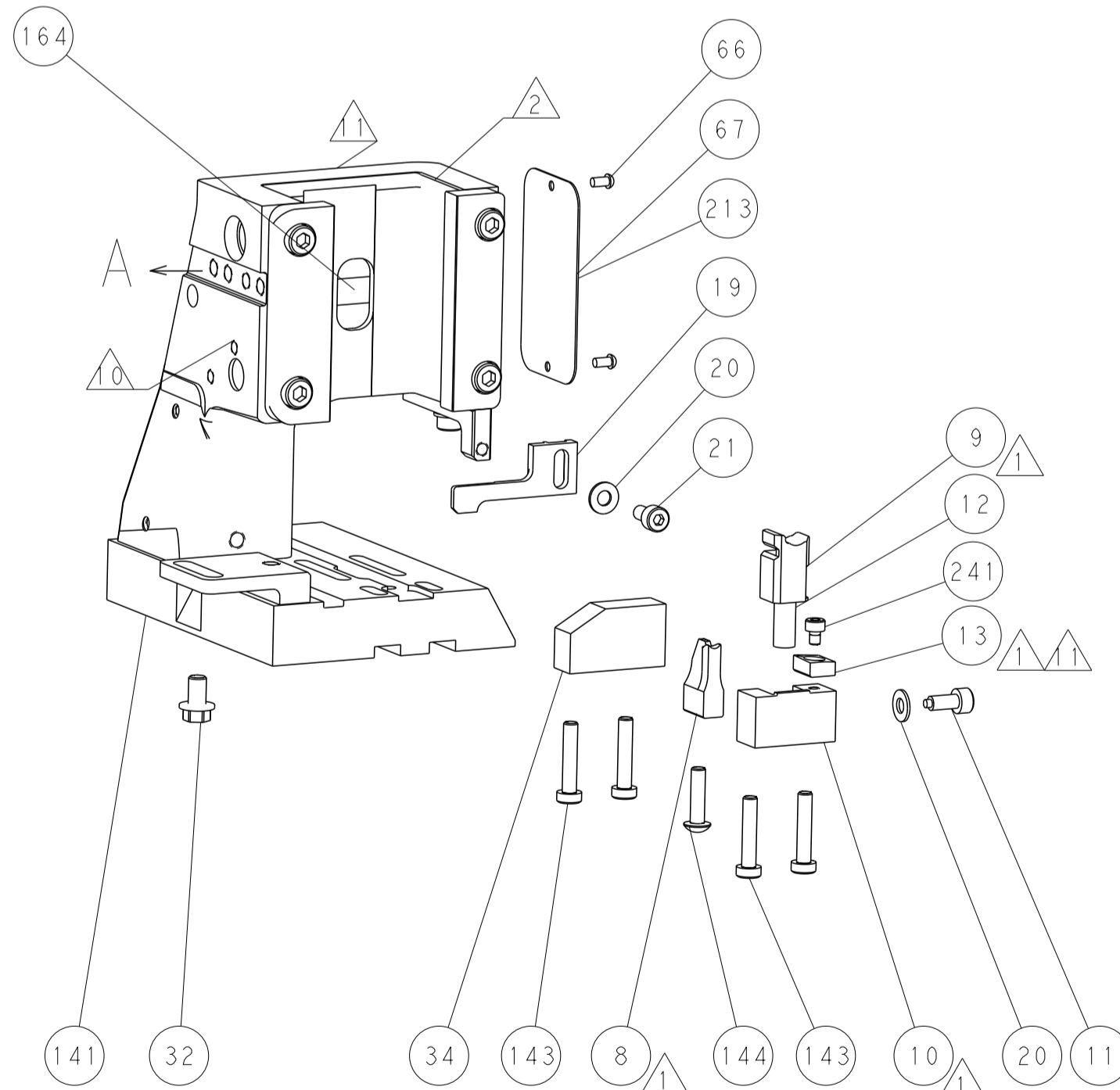
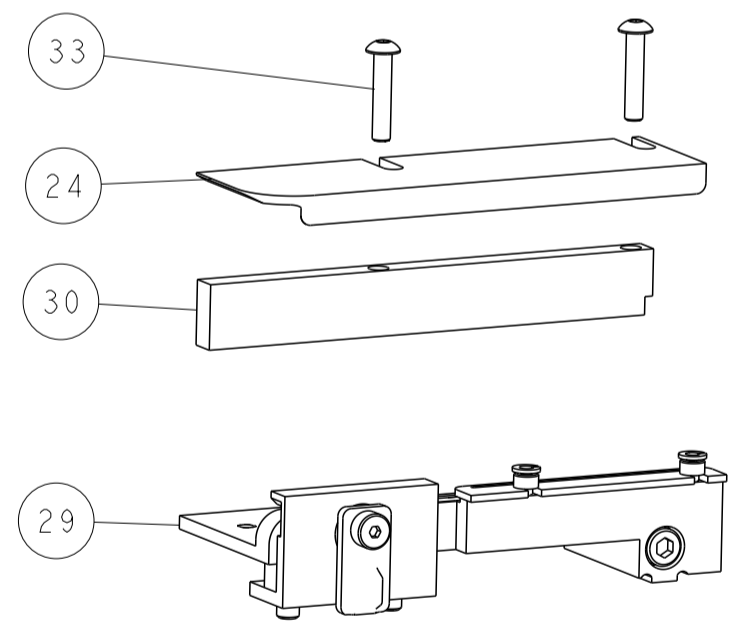
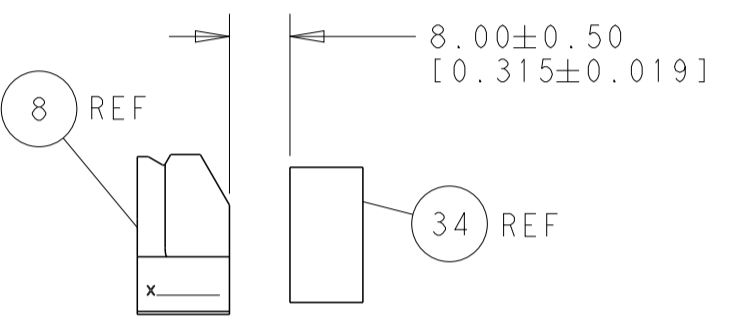
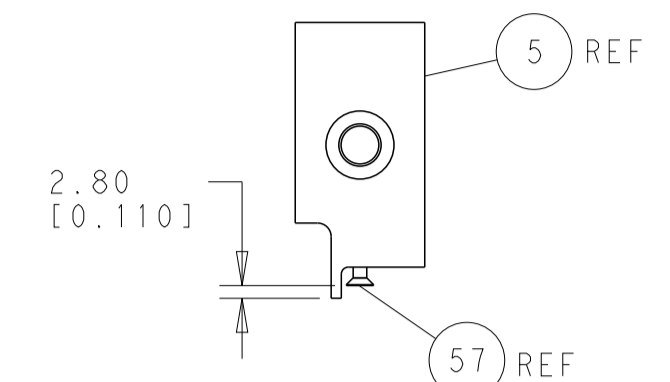
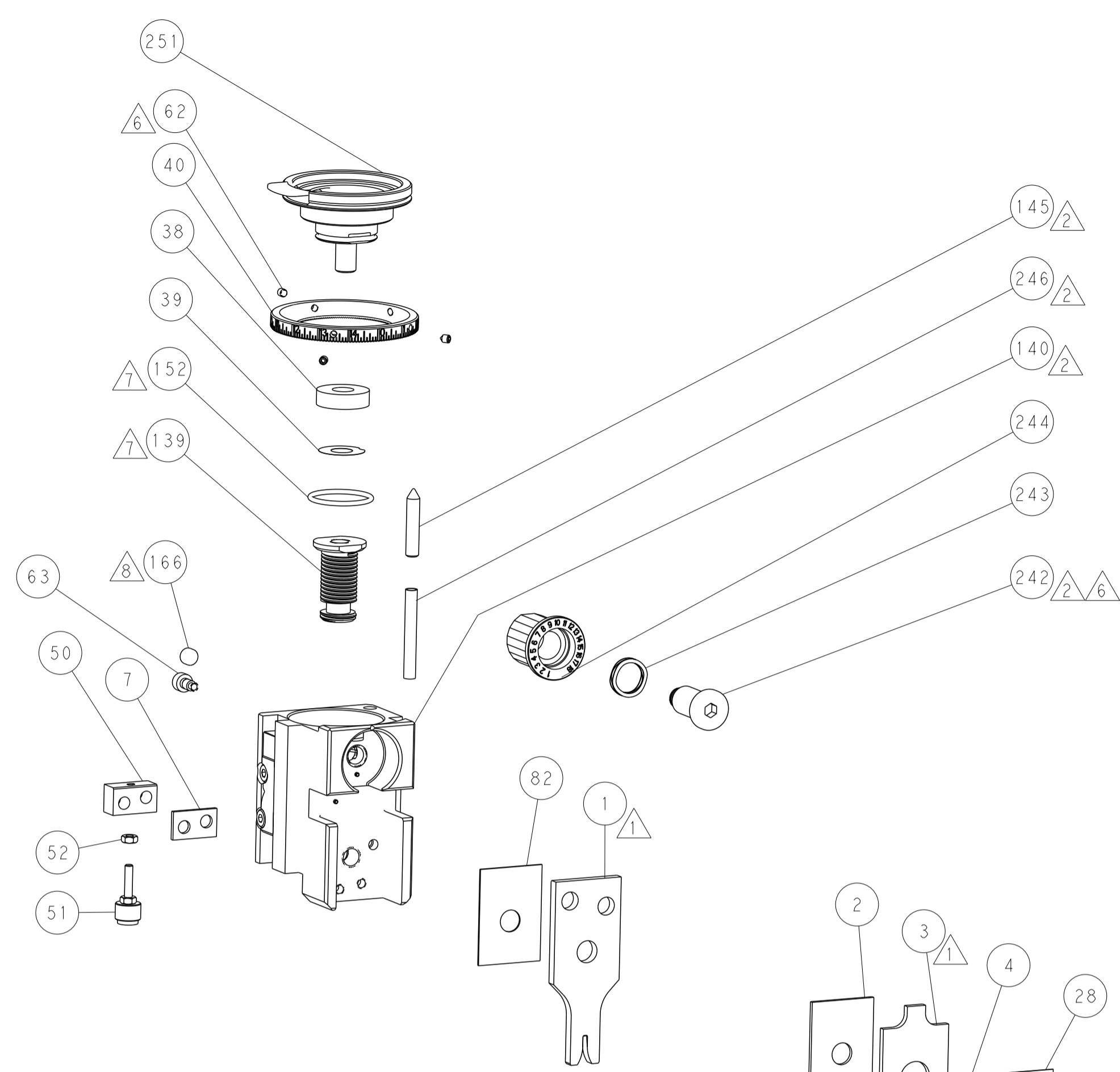
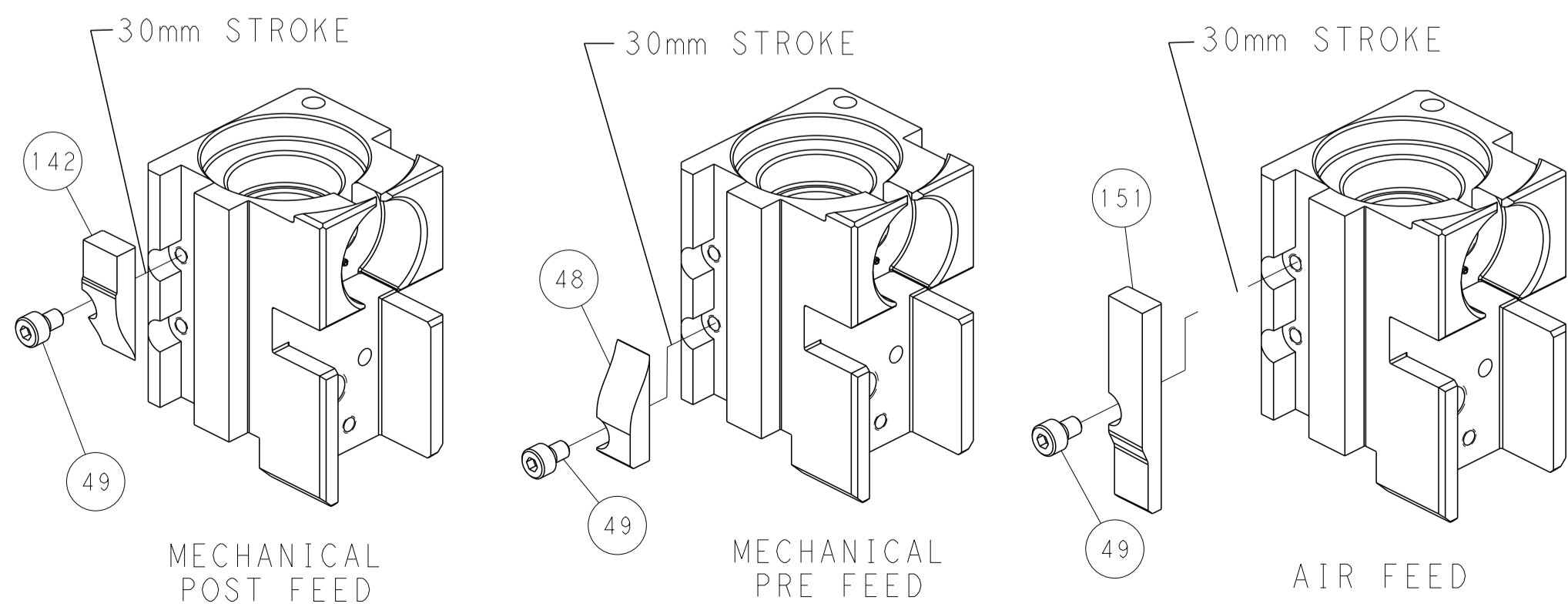
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



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

|             |            |                                        |             |                         |              |                         |        |                        |                  |                                  |                  |
|-------------|------------|----------------------------------------|-------------|-------------------------|--------------|-------------------------|--------|------------------------|------------------|----------------------------------|------------------|
| DIMENSIONS: |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DWG: H. HUANG 29OCT2014 |              | CHK: L. ZHANG 29OCT2014 |        | APVD: H. GUO 29OCT2014 |                  | NAME: Ocean Side Feed Applicator |                  |
| mm          | 0 PLC ±0.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013            | 4 PLC ±0.001 | ANGLES ±0.0001          | FINISH | SIZE: A1               | CAGE CODE: 00779 | DRAWING NO: C=2266561            | RESTRICTED TO: - |
| MATERIAL:   |            | FINISH:                                |             | WEIGHT:                 |              | SCALE: 1:2              |        | SHEET: 4 of 4          |                  | REV: A                           |                  |