

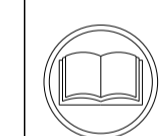
| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|---|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|   | 2266665-2   | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | -                                 | -                     | -         | -           | -         | -         |                        |
|   | 2266665-5   | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266665-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266665-4 | -         | -         |                        |
|   | 2266665-6   | A        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |
|   |             |          |                          |                                | -                                 | -                     | -         | -           | -         | -         |                        |
|   | 2266665-7   | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -         | -                      |
|   | 7-2266665-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 4.42 mm [1.74] | F    |
| INSUL           | -              | -    |

APPLICATOR INSTRUCTIONS  
408-10389

|   |                   |                           |                   |
|---|-------------------|---------------------------|-------------------|
| TERMINAL DATA: AMPHENOL TERMINAL AMPHENOL CRIMP SPECIFICATION |                   |                           |                   |
| TERMINAL NAME: AMPHENOL H4 CONTACT                            |                   |                           |                   |
| WIRE STRIP LENGTH   |                   | INSULATION DIAMETER RANGE |                   |
| 4.56-4.95 mm [1.80-.195 IN]                                   |                   | ∅ 3.18 mm [1.25 IN] MAX   |                   |
| TERMINAL APPLICATION SPECIFICATION                            | H4 CONTACT Rev -  | -                         | -                 |
| TERMINALS APPLIED <sup>10</sup>                               |                   |                           |                   |
| TE TERMINAL   | AMPHENOL TERMINAL | TE TERMINAL               | AMPHENOL TERMINAL |
| 2113652-1   | H4FF4R            | 2113652-2                 | H4FM4R            |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]         | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 6.00mm2   | 2.42 +/- 0.05 [1.095 +/- .002] | 5.6                            |
| 4.00mm2   | 2.30 +/- 0.05 [1.091 +/- .002] | 6.4                            |



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- <sup>3</sup> 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:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266665-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266665-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266665-6
- <sup>5</sup> 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. 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> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <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 3.38.
- <sup>13</sup> CUT TO LENGTH AT ASSEMBLY.

**\*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 | -7 | -6 | -5 | -2 | PART NO   | DESCRIPTION                     | ITEM NO |
|-----|----|----|----|----|-----------|---------------------------------|---------|
| -   | 2  | 2  | 2  | 2  | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269     |

**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        | APPD  |
|              |     |      | A         | RELEASED | 18FEB2015 | RK GB |

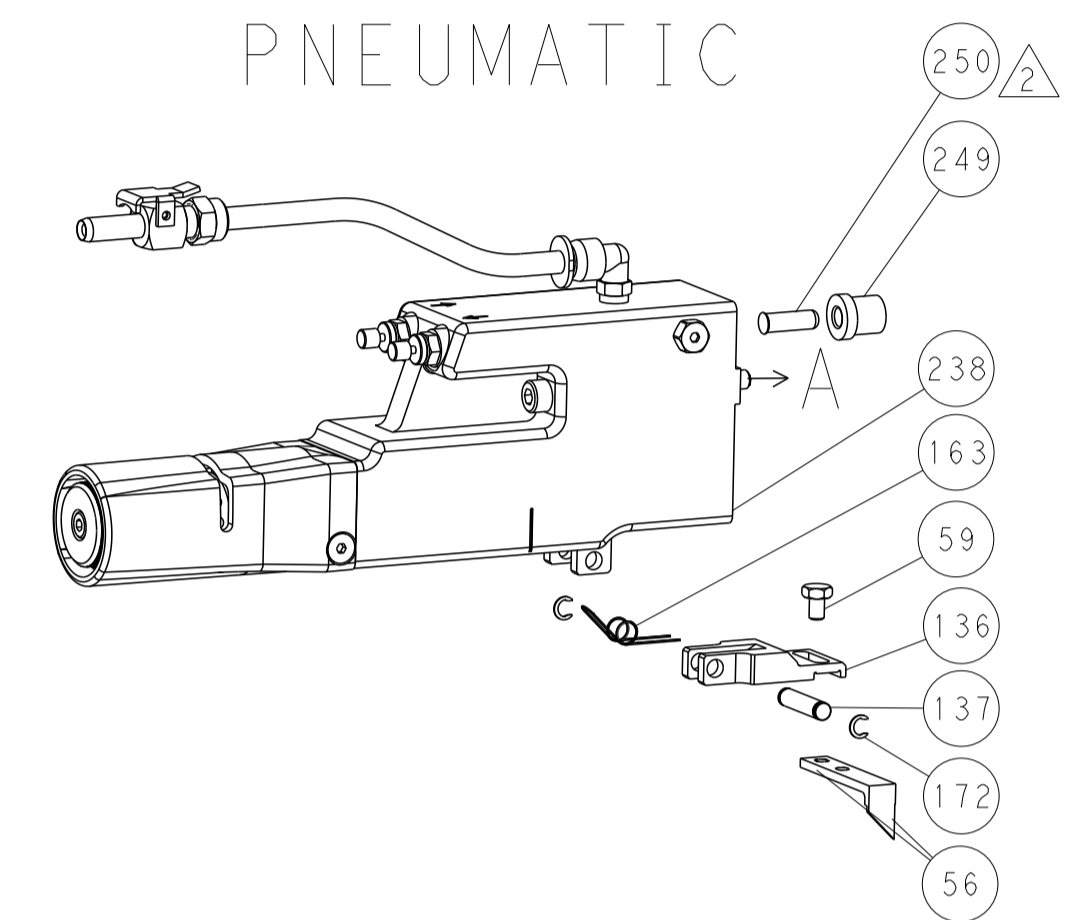
|   |     |     |     |     |             |                                     |               |   |
|---|-----|-----|-----|-----|-------------|-------------------------------------|---------------|---|
| - | 1   | 1   | 1   | 1   | 1-1633782-1 | FENCE                               | 267           |   |
| - | -   | 1   | -   | -   | 2119957-2   | APPLICATOR SHIM PACK                | 260           |   |
| - | 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   | 2119798-1   | DETENT PIN                          | 247           |   |
| - | 1   | -   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246           |   |
| - | -   | 1   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245           |   |
| - | 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   | 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   | 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   | 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   | 455888-5    | SPACER, CRIMPER                     | 82            |   |
| - | 2   | 2   | 2   | 2   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 79            |   |
| - | 1   | 1   | 1   | 1   | 1803096-1   | EXTENSION PLATE                     | 78            |   |
| - | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71            |   |
| - | 1   | 1   | 1   | 1   | 2119791-9   | DEPRESSOR, WIRE                     | 70            |   |
| - | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69            |   |
| - | 1   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67            |   |
| - | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66            |   |
| - | 1   | -   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63            |   |
| - | 3   | -   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62            |   |
| - | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60            |   |
| - | -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59            |   |
| - | -   | -   | -   | 1   | 1338685-1   | PAWL, FEED                          | 56            |   |
| - | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54            |   |
| - | 2   | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 53            |   |
| - | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52            |   |
| - | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51            |   |
| - | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 50            |   |
| - | -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49            |   |
| - | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46            |   |
| - | 1   | -   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44            |   |
| - | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41            |   |
| - | 1   | -   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40            |   |
| - | 1   | -   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39            |   |
| - | 1   | 1   | 1   | 1   | 1-2119644-3 | RAM WASHER, PRECISION               | 38            |   |
| - | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37            |   |
| - | 1   | -   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35            |   |
| - | 1   | 1   | 1   | 1   | 1752356-3   | 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   | 1320908-9   | SPACER, STRIP GUIDE                 | 30            |   |
| - | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29            |   |
| - | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28            |   |
| - | 1   | 1   | 1   | 1   | 1320928-4   | STRIP GUIDE                         | 24            |   |
| - | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21            |   |
| - | 2   | 2   | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20            |   |
| - | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19            |   |
| - | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13            |   |
| - | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12            |   |
| - | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11            |   |
| - | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10            |   |
| - | 1   | 1   | 1   | 1   | 318707-1    | FLOATING SHEAR, FRONT               | 9             |   |
| - | 1   | 1   | 1   | 1   | 4-1633933-1 | ANVIL, COMBINATION                  | 8             |   |
| - | 1   | 1   | 1   | 1   | 6-240641-8  | SPACER                              | 7             |   |
| - | -   | -   | -   | -   | -           | -                                   | 6             |   |
| - | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5             |   |
| - | -   | -   | -   | -   | -           | -                                   | 4             |   |
| - | -   | -   | -   | -   | -           | -                                   | 3             |   |
| - | -   | -   | -   | -   | -           | -                                   | 2             |   |
| - | 1   | 1   | 1   | 1   | 1           | 8-1633664-4                         | CRIMPER, WIRE | 1 |

|                 |  |   |  |  |  |   |  |
|-----------------|--|---|--|--|--|---|--|
| DIMENSIONS:<br> |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.5<br>1 PLC ±0.5<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.001<br>ANGLES ±.01 |  | DWN HOFFNER 22JAN2015<br>CHK T. ELBIN 23JAN2015<br>APVD T. ELBIN 23JAN2015 |  | TE Connectivity<br>Harrisburg, PA 17105-3608          |  |
| MATERIAL:       |  | FINISH:   |  | NAME: Ocean Side Feed Applicator   |  | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C-2266665 |  |
| WEIGHT:         |  | RESTRICTED TO:  |  | SCALE: 1:2   |  | SHEET 1 OF 4 REV A                                    |  |

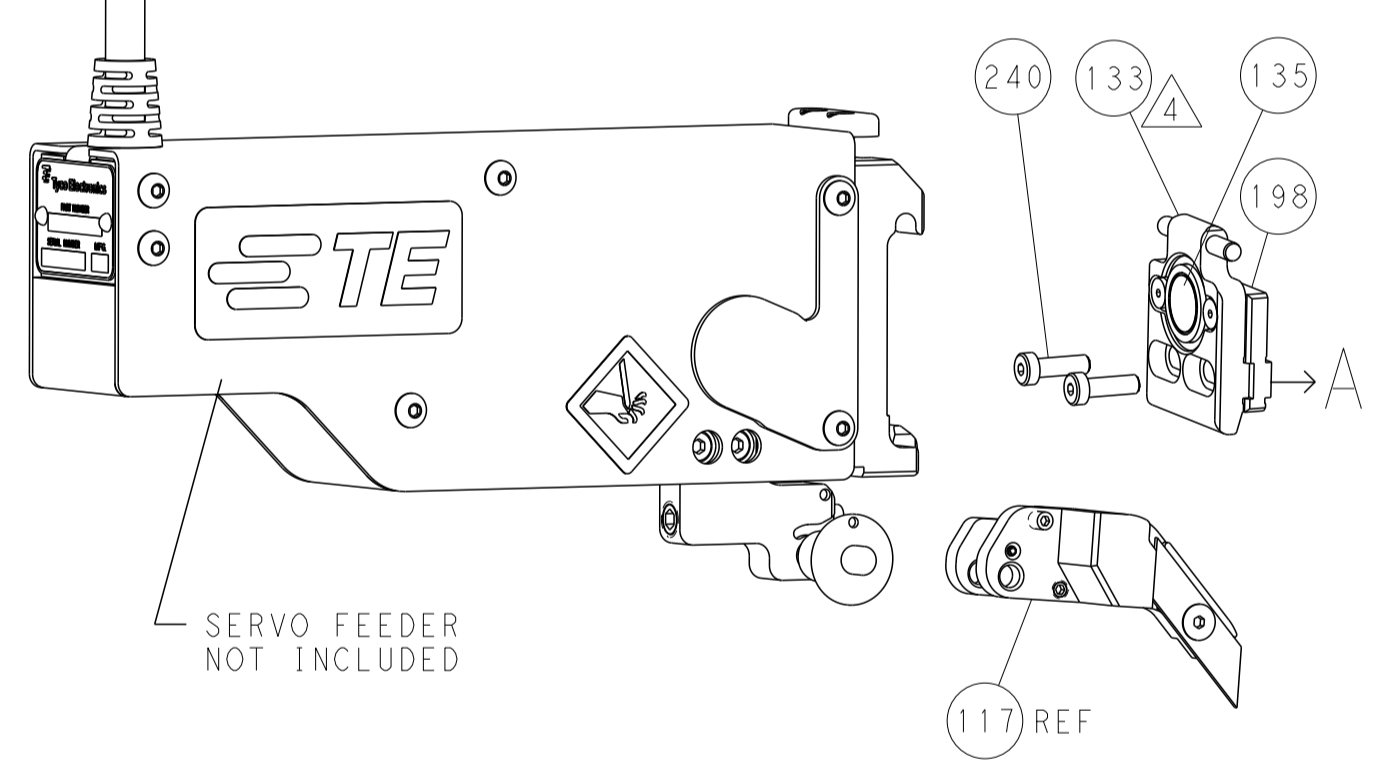
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|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTN | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    |     | SEE SHEET 1 |      |     |      |

### FEED TYPE

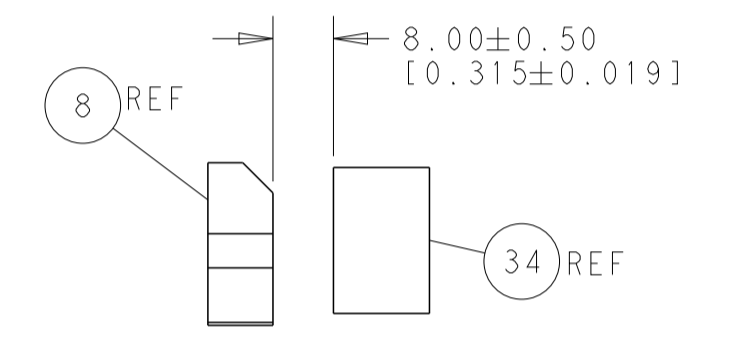
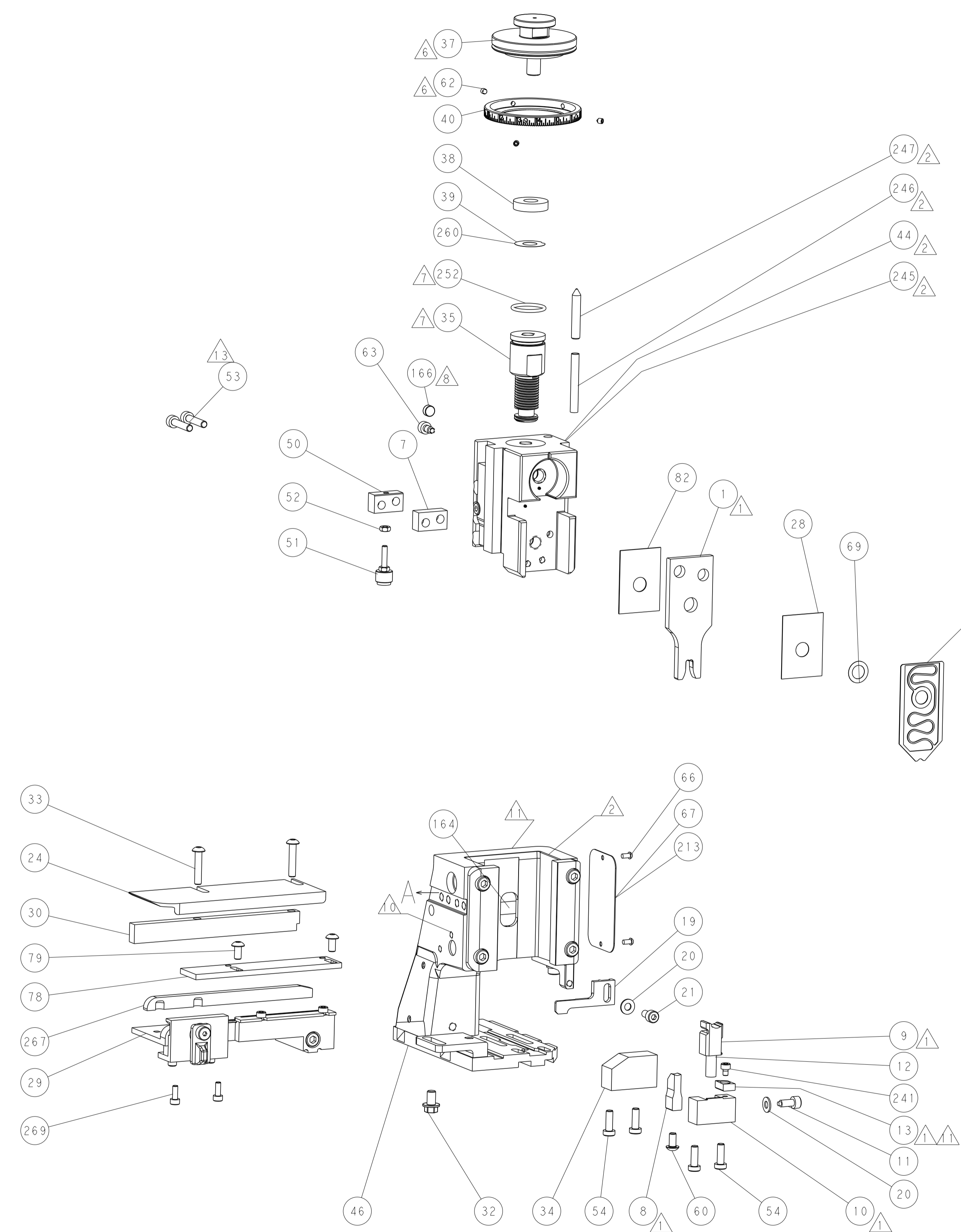
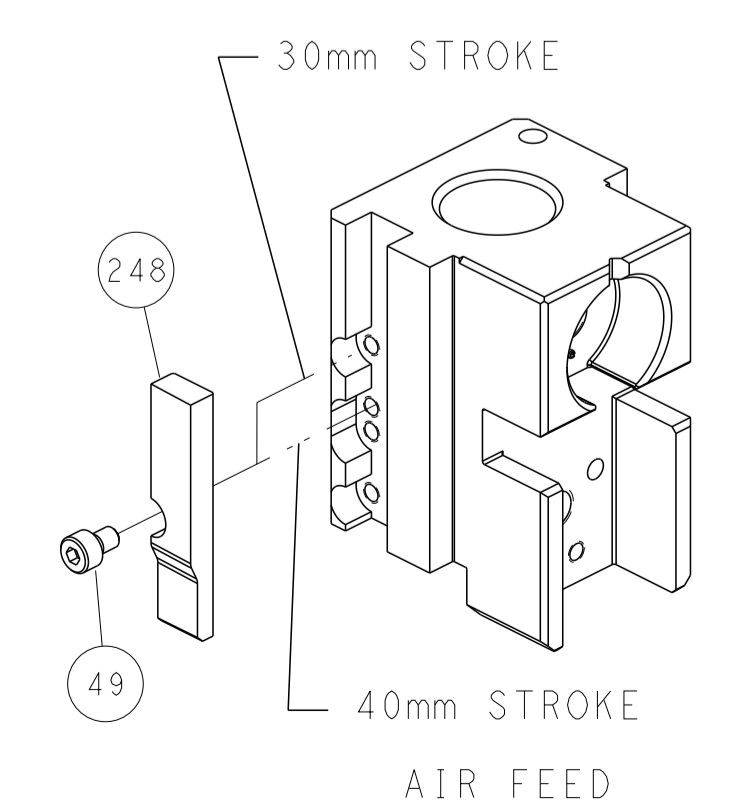
### PNEUMATIC



### SERVO LATCH PLATE

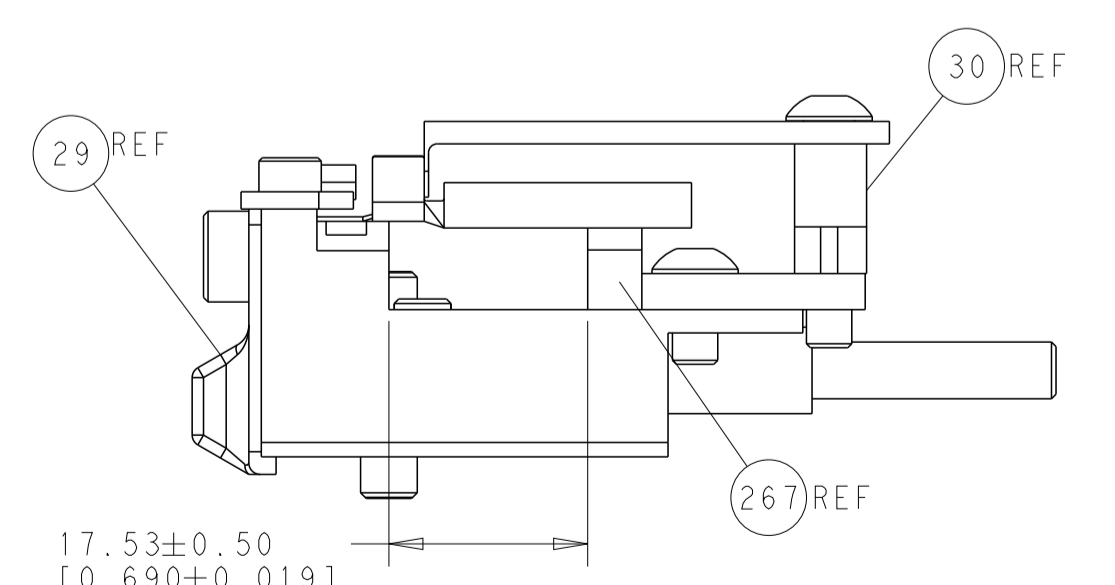


### CAM POSITION



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY WIRE 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: |             | OWN: HOFFNER 22JAN2015           |               | TE Connectivity          |                           |
| mm          | 0 PLC ±0.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013                     | 4 PLC ±0.0001 | APVD: T. ELBIN 23JAN2015 | Harrisburg, PA 17105-3608 |
| MATERIAL:   |            | FINISH:                                |             | NAME: Ocean Side Feed Applicator |               | RESTRICTED TO:           |                           |
|             |            |  |             | SIZE: A1                         |               | CAGE CODE: 00779         |                           |
|             |            |  |             | DRAWING NO: 2266665              |               | SCALE: 1:2               |                           |
|             |            |  |             | SHEET: 2 OF 4                    |               | REV: A                   |                           |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      |
|--|-------------|----------|--------------------------|--------------------------------|
|  | 2-2266665-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      |
|  | 2-2266665-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> |
|  | 2-2266665-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           |
|  | 7-2266665-7 | A        | CRIMP TOOLING KIT        | -                              |

| APPLICATOR DATA                      |                 |      |
|--------------------------------------|-----------------|------|
| CRIMP WIRE                           | SIZE            | TYPE |
| INSUL                                | 4.42 mm [1.741] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                 |      |

| TERMINAL DATA: AMPHENOL TERMINAL AMPHENOL CRIMP SPECIFICATION |                   |                           |                   |
|---|-------------------|---------------------------|-------------------|
| TERMINAL NAME: AMPHENOL H4 CONTACT                            |                   |                           |                   |
| WIRE STRIP LENGTH   |                   | INSULATION DIAMETER RANGE |                   |
| 4.56-4.95 mm [1.80-.195 IN]                                   |                   | 3.18 mm [1.125 IN] MAX    |                   |
| TERMINAL APPLICATION SPECIFICATION                            | H4 CONTACT Rev -  | -                         | -                 |
| TERMINALS APPLIED <sup>10</sup>                               |                   |                           |                   |
| TE TERMINAL   | AMPHENOL TERMINAL | TE TERMINAL               | AMPHENOL TERMINAL |
| 2113652-1   | H4FF4R            | 2113652-2                 | H4FM4R            |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]         | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|-----------|--------------------------------|---|
| 6.00mm2   | 2.42 +/- 0.05 [1.095 +/- .002] | 5.6   |
| 4.00mm2   | 2.30 +/- 0.05 [1.091 +/- .002] | 6.4   |



- <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:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266665-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266665-5
- 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.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- <sup>8</sup> MAGNET 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> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> 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.
- <sup>12</sup> CUT TO LENGTH AT ASSEMBLY.

| APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
| -                                 | -                     | -         | -           | -         | -         | -                      |
| SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266665-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
| SMART APPLICATOR                  | 2161326-1             | -         | 8-2266665-4 | -         | -         | -                      |
| PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |

**\*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.

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

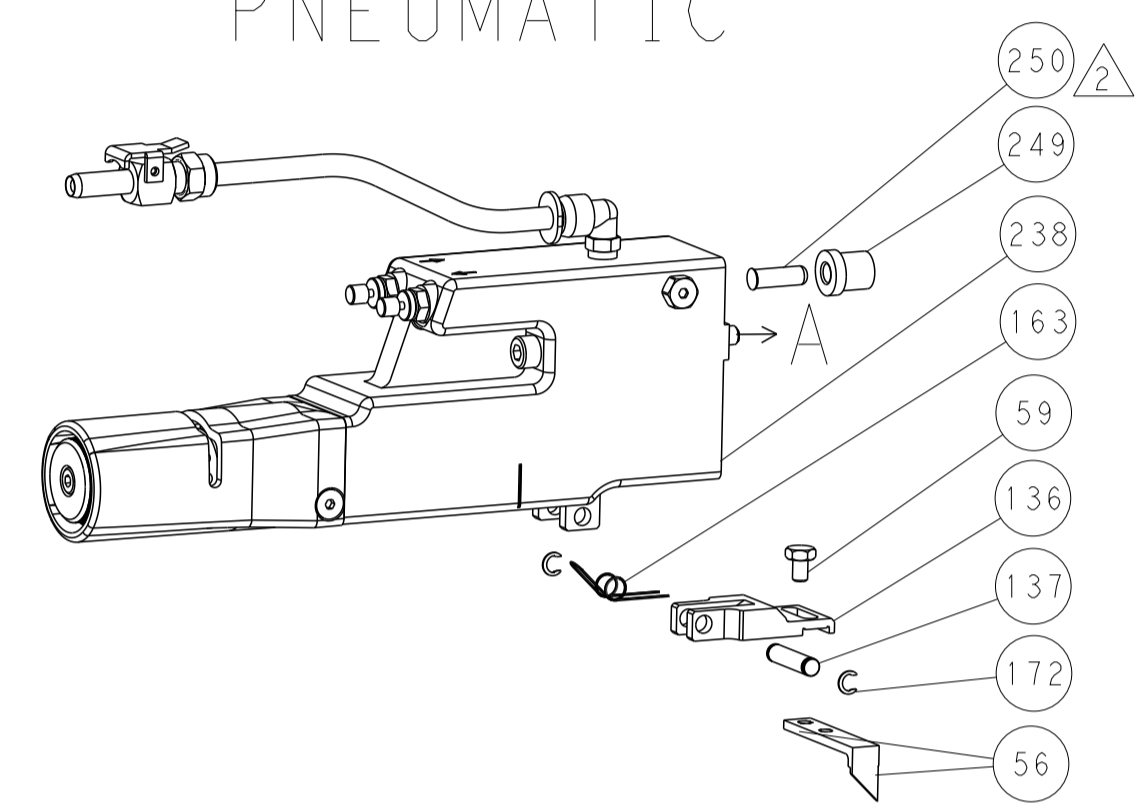
| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE | DWN | APVD |
| -            | -   | -    | -         | -   | SEE SHEET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

|   |     |     |     |             |                                     |               |   |
|---|-----|-----|-----|-------------|-------------------------------------|---------------|---|
| - | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 269           |   |
| - | 1   | 1   | 1   | 1-1633782-1 | FENCE                               | 267           |   |
| - | 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   | 1-22279-3   | SPRING, COMPRESSION                 | 246           |   |
| - | 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   | 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   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166           |   |
| - | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164           |   |
| - | -   | -   | 1   | 240638-1    | SPRING, FEED FINGER                 | 163           |   |
| - | 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   | 2119798-2   | DETENT PIN                          | 145           |   |
| - | 1   | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144           |   |
| - | 4   | 4   | 4   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       | 143           |   |
| - | 1   | 1   | 1   | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141           |   |
| - | 1   | 1   | 1   | 2119650-1   | RAM, ASIAN STYLE, SIDE FEED         | 140           |   |
| - | 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           |   |
| - | -   | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117           |   |
| - | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82            |   |
| - | 2   | 2   | 2   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 79            |   |
| - | 1   | 1   | 1   | 1803096-1   | EXTENSION PLATE                     | 78            |   |
| - | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71            |   |
| - | 1   | 1   | 1   | 2119791-9   | DEPRESSOR, WIRE                     | 70            |   |
| - | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69            |   |
| - | 1   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67            |   |
| - | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66            |   |
| - | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63            |   |
| - | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62            |   |
| - | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59            |   |
| - | -   | -   | 1   | 1338685-1   | PAWL, FEED                          | 56            |   |
| - | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 53            |   |
| - | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52            |   |
| - | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51            |   |
| - | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 50            |   |
| - | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49            |   |
| - | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41            |   |
| - | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40            |   |
| - | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39            |   |
| - | 1   | 1   | 1   | 1-2119644-3 | RAM WASHER, PRECISION               | 38            |   |
| - | 1   | 1   | 1   | 1752356-3   | SUPPORT, TERMINAL                   | 34            |   |
| - | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33            |   |
| - | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32            |   |
| - | 1   | 1   | 1   | 1320908-9   | SPACER, STRIP GUIDE                 | 30            |   |
| - | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29            |   |
| - | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28            |   |
| - | 1   | 1   | 1   | 1320928-4   | STRIP GUIDE                         | 24            |   |
| - | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21            |   |
| - | 2   | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20            |   |
| - | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19            |   |
| - | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13            |   |
| - | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12            |   |
| - | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11            |   |
| - | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10            |   |
| - | 1   | 1   | 1   | 318707-1    | FLOATING SHEAR, FRONT               | 9             |   |
| - | 1   | 1   | 1   | 4-1633933-1 | ANVIL, COMBINATION                  | 8             |   |
| - | 1   | 1   | 1   | 6-240641-8  | SPACER                              | 7             |   |
| - | -   | -   | -   | -           | -                                   | 6             |   |
| - | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5             |   |
| - | -   | -   | -   | -           | -                                   | 4             |   |
| - | -   | -   | -   | -           | -                                   | 3             |   |
| - | -   | -   | -   | -           | -                                   | 2             |   |
| - | 1   | 1   | 1   | 1           | 8-1633664-4                         | CRIMPER, WIRE | 1 |

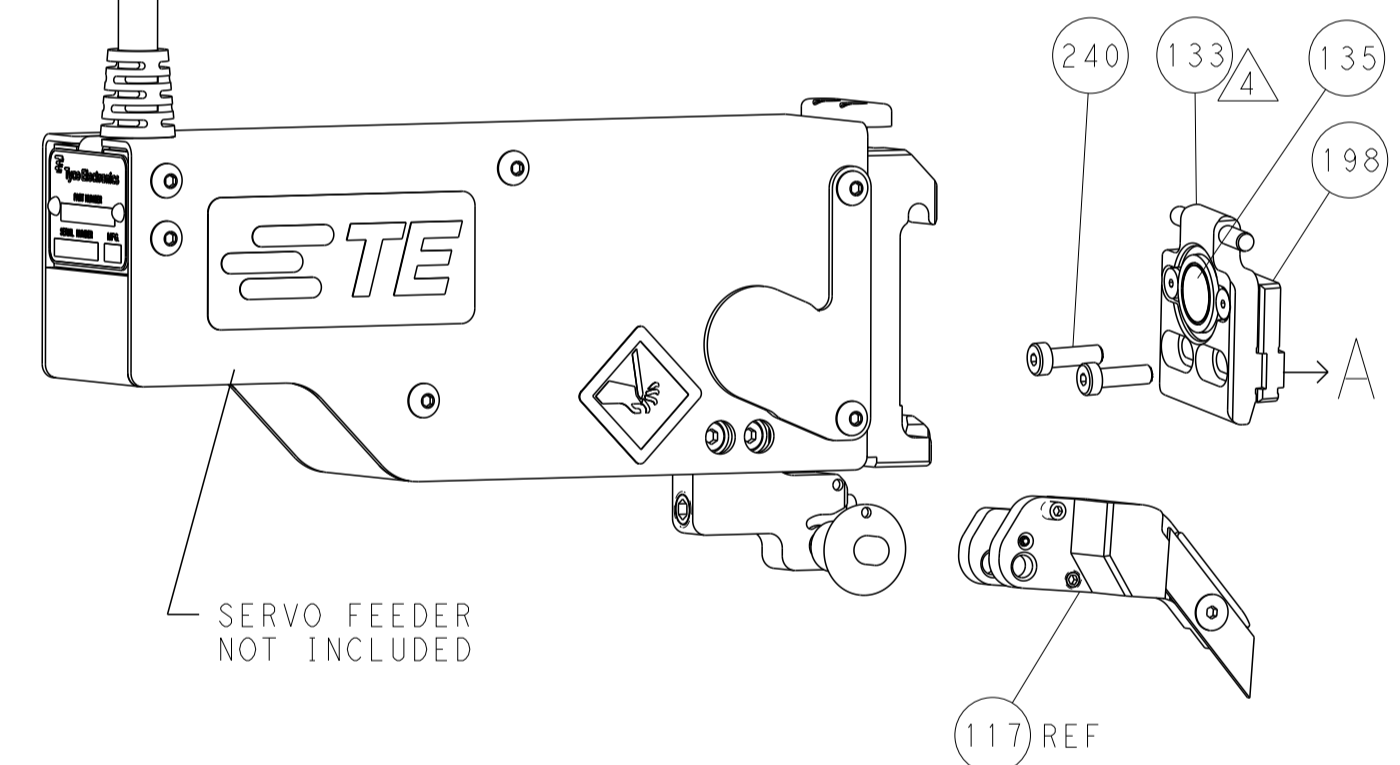
| DIMENSIONS: | TOLERANCES UNLESS OTHERWISE SPECIFIED:   | DRAWN            | DATE      | DESCRIPTION                            | ITEM NO      |
|-------------|--|------------------|-----------|--|--------------|
| mm          | 0 PLC ±.5<br>1 PLC ±0.5<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.001<br>ANGLES ±.1 | HOFFNER          | 22JAN2015 | TE Connectivity                        |              |
|             |  | CHS              | 23JAN2015 | Harrisburg, PA 17105-3608              |              |
|             |  | T. ELBIN         |           |  |              |
|             |  | T. ELBIN         | 23JAN2015 |  |              |
|             |  | APVD             |           |  |              |
|             |  | PRODUCT SPEC     |           |  |              |
|             |  | APPLICATION SPEC |           |  |              |
|             |  | FINISH           |           |  |              |
| MATERIAL    |  | WEIGHT           |           | SIZE                                   | CAGE CODE    |
|             |  |                  |           | A1                                     | 00779        |
|             |  |                  |           | Customer Accessible Production Drawing | SCALE        |
|             |  |                  |           | 1:2                                    | SHEET 3 OF 4 |
|             |  |                  |           | REV                                    | A            |

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

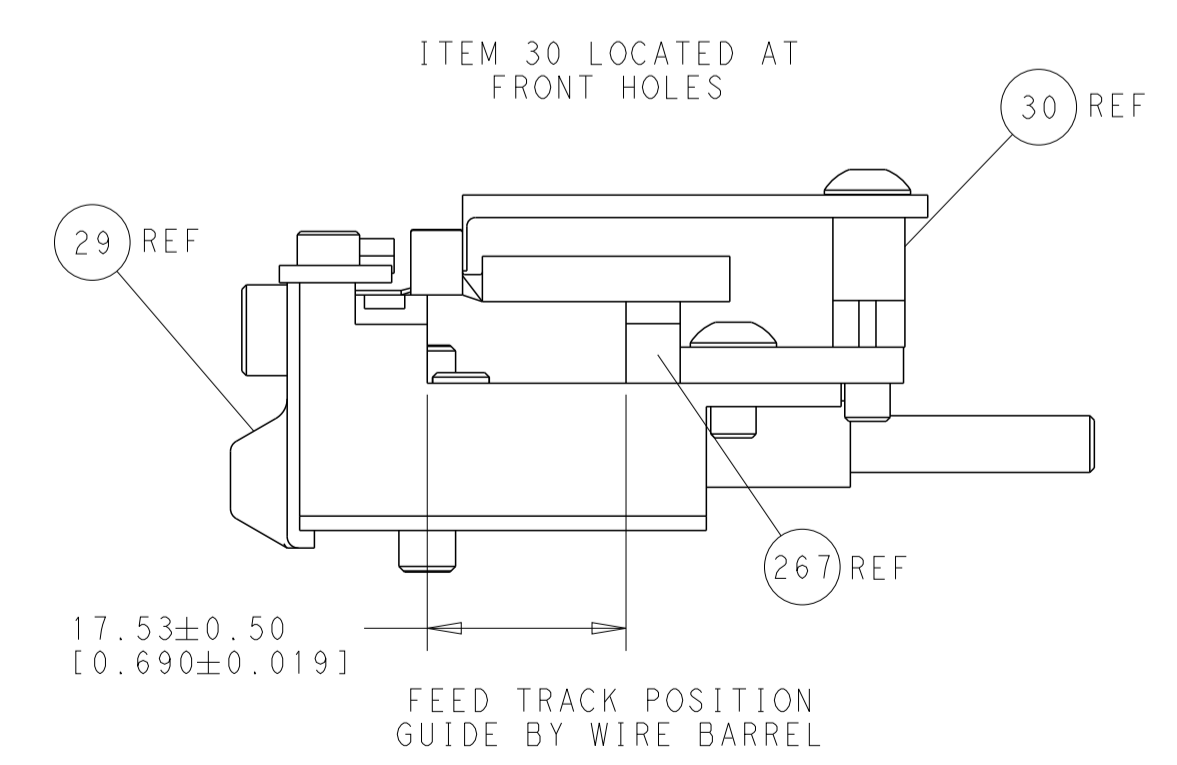
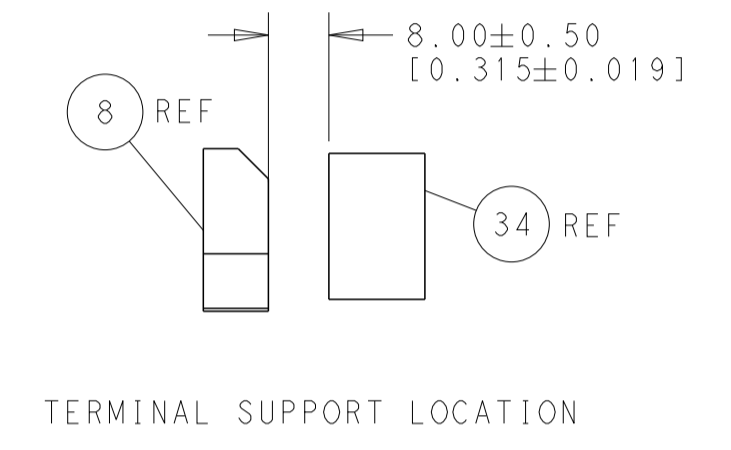
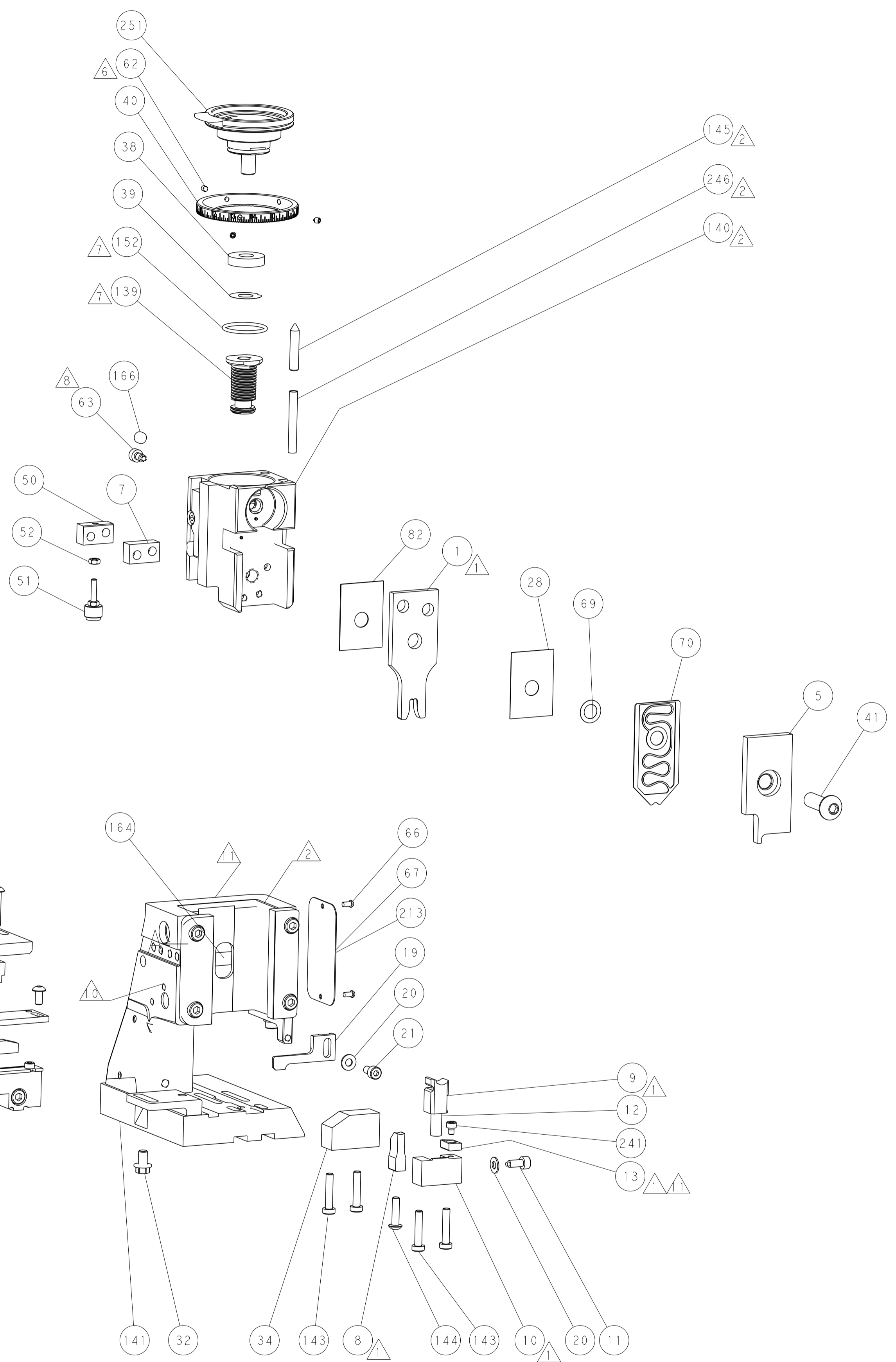
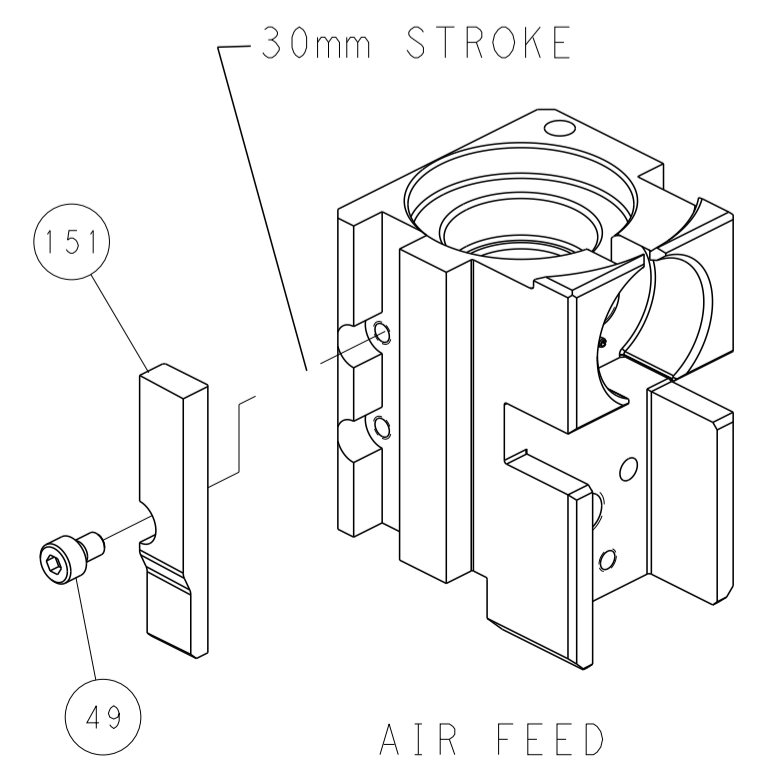
### FEED TYPE PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITION



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

|   |  |   |  |
|---|--|---|--|
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| DIMENSIONS: mm<br>0 PLC ±0.5<br>1 PLC ±0.13<br>2 PLC ±0.013<br>3 PLC ±0.001<br>4 PLC ±0.001<br>ANGLES FINISH  | TOLERANCES UNLESS OTHERWISE SPECIFIED: | PRODUCT SPEC: -<br>APPLICATION SPEC: -<br>WEIGHT: -                           | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2266665<br>SCALE: 1:2<br>SHEET: 4 OF 4<br>REV: A |
| MATERIAL: -   |  | Customer Accessible Production Drawing  |  |