

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|--------------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2266688-1 | 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 | - | 8-2266688-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266688-4 | - | - | - |
| | 2266688-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266688-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266688-4 | - | - | - |
| | 2266688-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | 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 | |
| 2266688-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | - | - | - | - | - | - | - | |
| 2266688-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2266688-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.97 mm [.078] | F |
| INSUL | 2.72 mm [.107] | O |

APPLICATOR INSTRUCTIONS 408-10389

| TERMINAL DATA: FORD TERMINAL | | YAZAKI CRIMP SPECIFICATION | |
|------------------------------------|---------------|------------------------------|---------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.50-6.00 mm [.217-.236 IN] | | Ø1.90-2.10 mm [.075-.083 IN] | |
| TERMINAL APPLICATION SPECIFICATION | | 7113-2326 Rev - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | FORD TERMINAL | TE TERMINAL | FORD TERMINAL |
| 1572141-1 | 7113-2326 | 1572141-2 | E8EB-14461-KA |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 0.80mm2 | 1.30+/-0.05 [.051+/-0.002] | 7.8 |
| 0.75mm2 | 1.30+/-0.05 [.051+/-0.002] | 7.7 |
| 0.50mm2 | 1.20+/-0.05 [.047+/-0.002] | 9.0 |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266688-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266688-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266688-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266688-6
- 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 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.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.50.

***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 |
| -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)

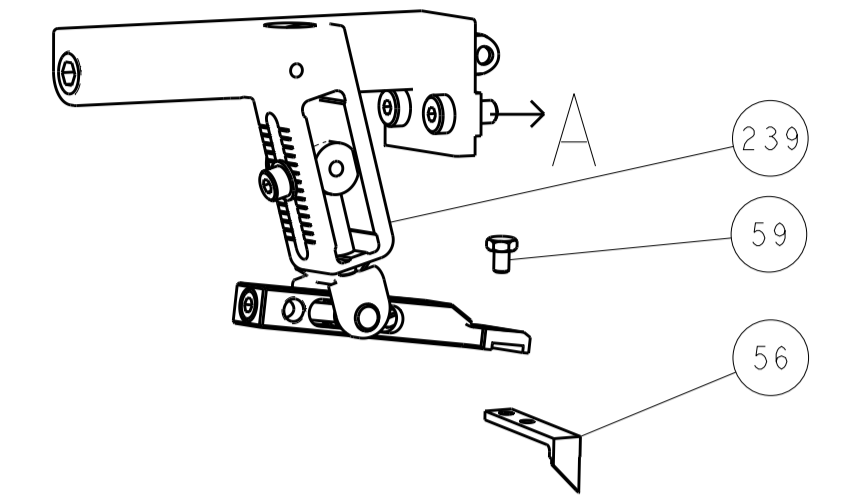
| SET UP GAUGE | LOC | DIST | REVISIONS | | | | | |
|--------------|-----|------|-----------|-----|-------------|----------|-----|------|
| 2119599-1 | A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | | A | | RELEASED | 1APR2010 | KS | TE |

| | | | | | | | | |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | - | - | - | 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 | 2119082-5 | 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 | 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 | 455888-4 | SPACER, CRIMPER | 82 |
| - | 2 | 2 | 2 | 2 | 2 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 79 |
| - | 1 | 1 | 1 | 1 | 1 | 1803096-1 | EXTENSION PLATE | 78 |
| - | 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 | 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 | 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 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 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 | 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 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| - | 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 | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | 1 | 1 | 1 | 1 | 1 | 1752356-1 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 1 | 1 | 1 | 1 | 1 | 2161328-1 | HEX HEAD, FLANGED, M5 X 8mm LONG | 32 |
| - | 1 | 1 | 1 | 1 | 1 | 1320908-5 | 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 | 1320928-4 | 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 | 1803095-1 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 4-1803056-5 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 1 | 1-240641-0 | SPACER | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2119757-4 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 3-238011-1 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 6-1803018-4 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 1-455888-2 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 8-1633305-0 | CRIMPER, WIRE PREMIUM | 1 |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

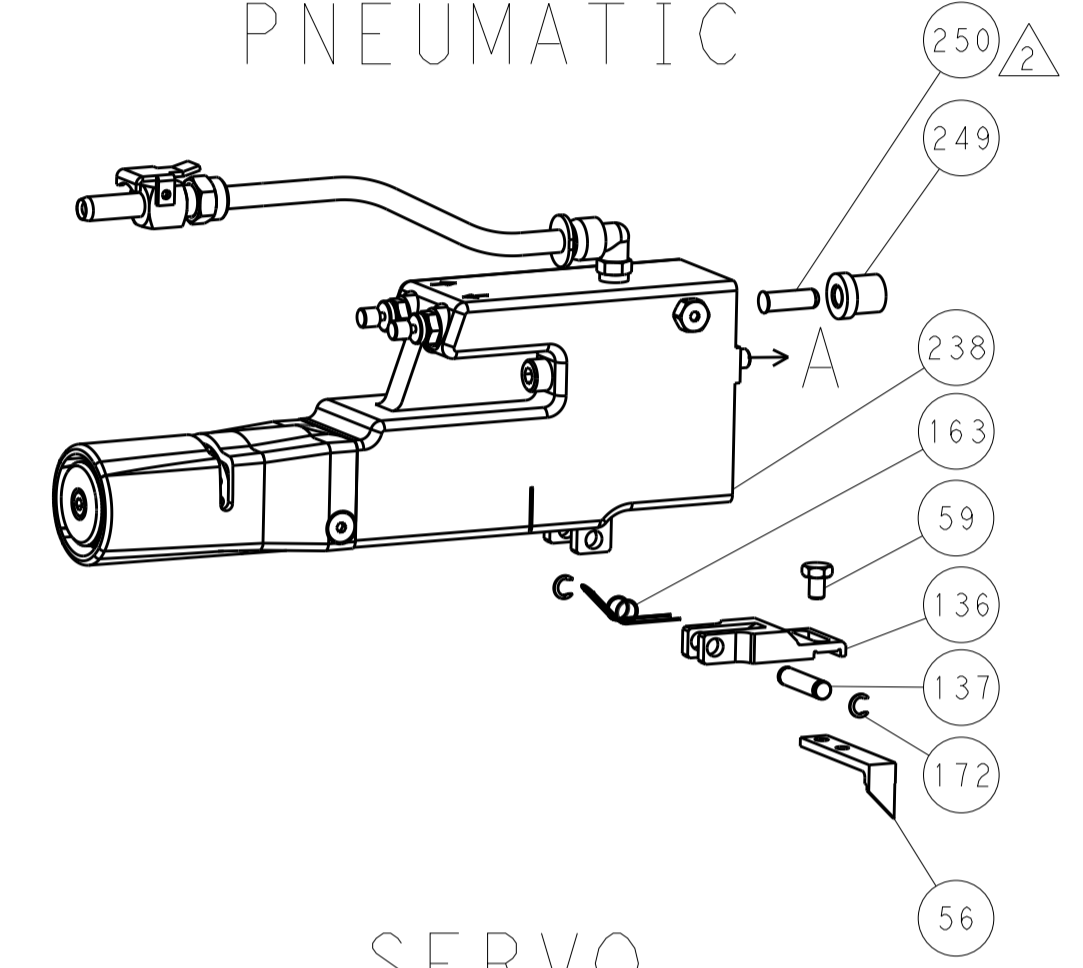
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN | CHK | DATE | NAME | |
|-------------|---------------|--|--------------|--|-----------|-----------|----------------------------|------------|
| mm | 0 PLC ±.5 | 1 PLC ±.5 | 2 PLC ±.5 | STAKEM | G. BAILEY | 19FEB2015 | TE Connectivity | |
| | 3 PLC ±.013 | 4 PLC ±.013 | 5 PLC ±.0001 | | | | Harrisburg, PA 17105-3608 | |
| | ANGLES ±.0001 | | | APVD | FLBIN | 19FEB2015 | Ocean Side Feed Applicator | |
| MATERIAL | FINISH | WEIGHT | SCALE | Customer Accessible Production Drawing | | SIZE | CAGE CODE | DRAWING NO |
| | | | 1:2 | | | A1 | 00779 | ©=2266688 |

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

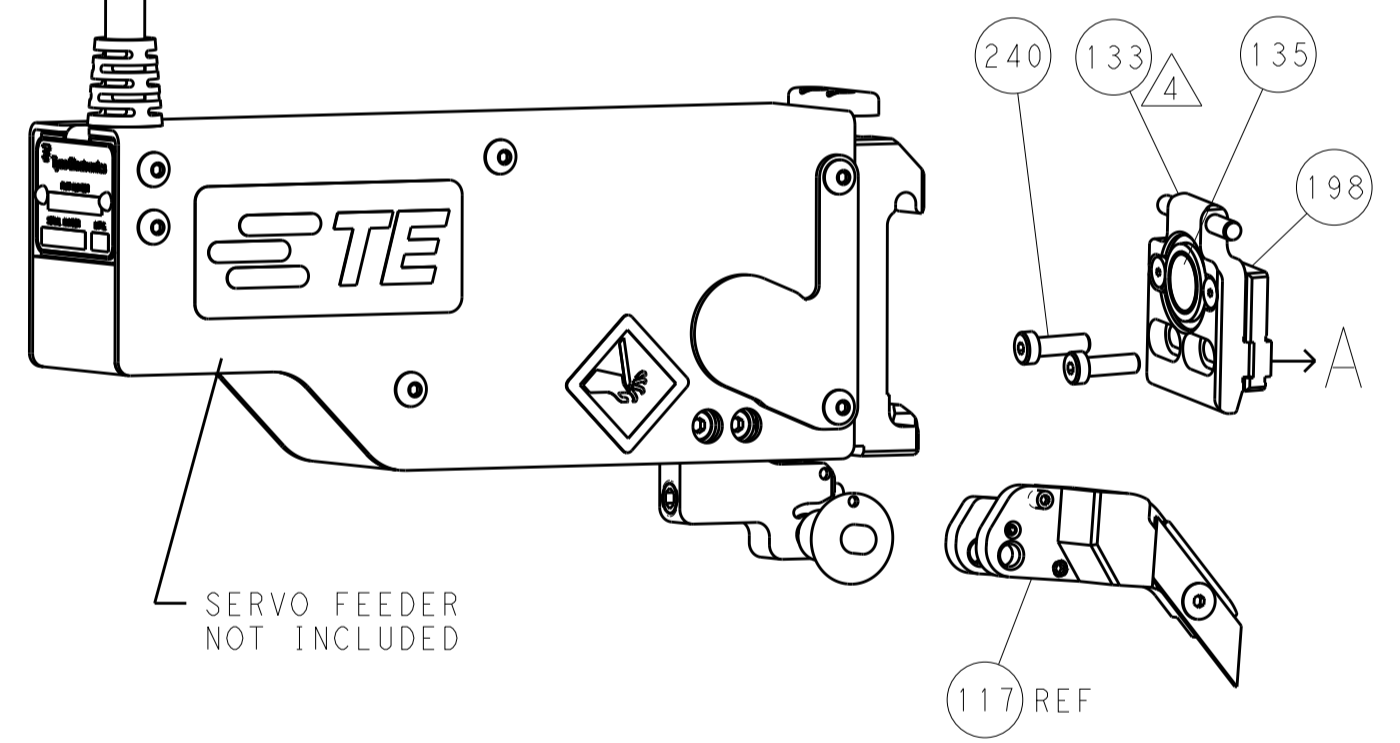
FEED TYPE MECHANICAL



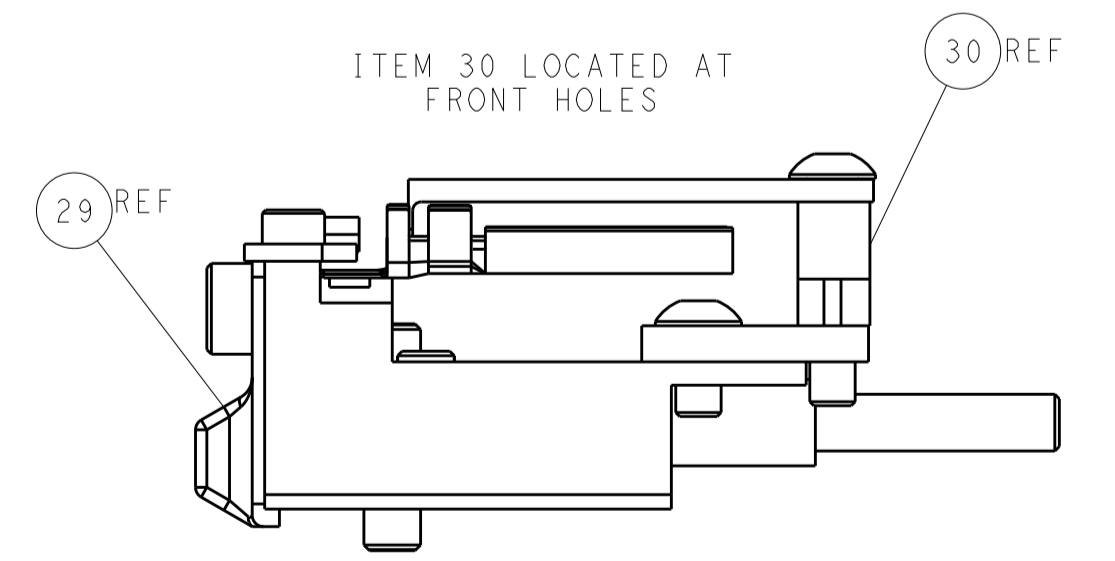
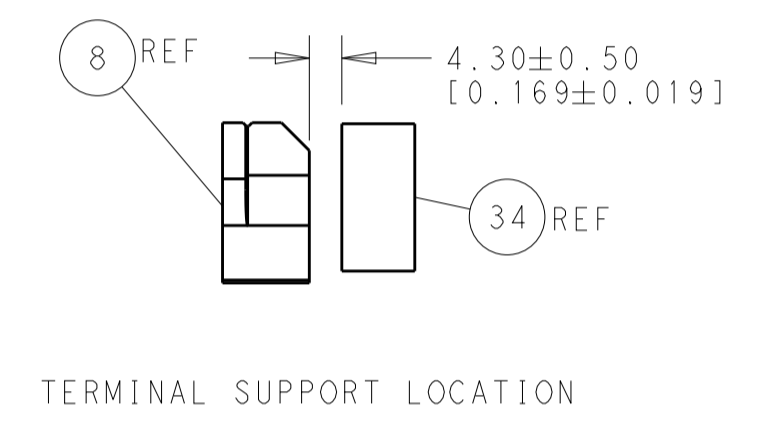
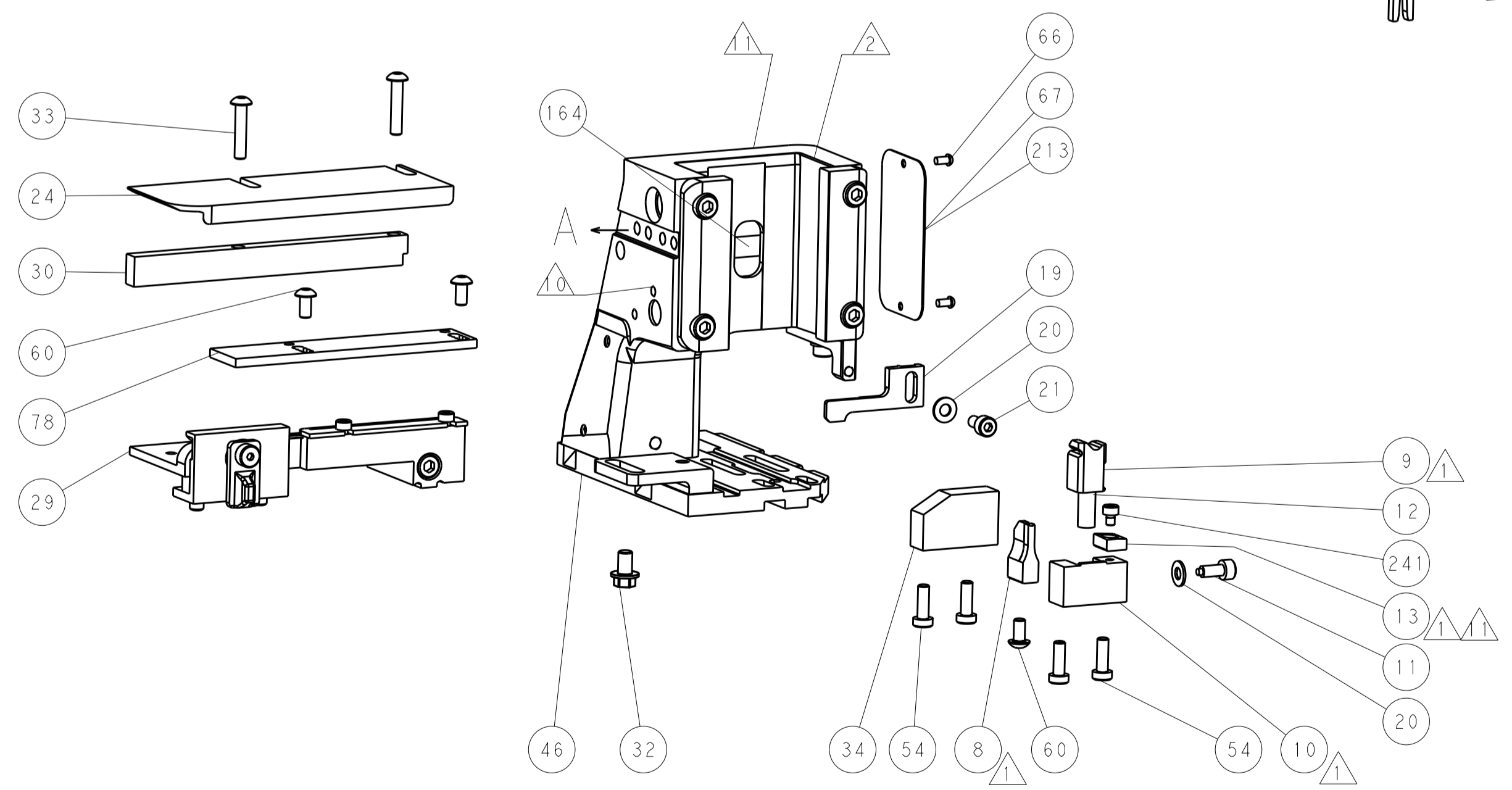
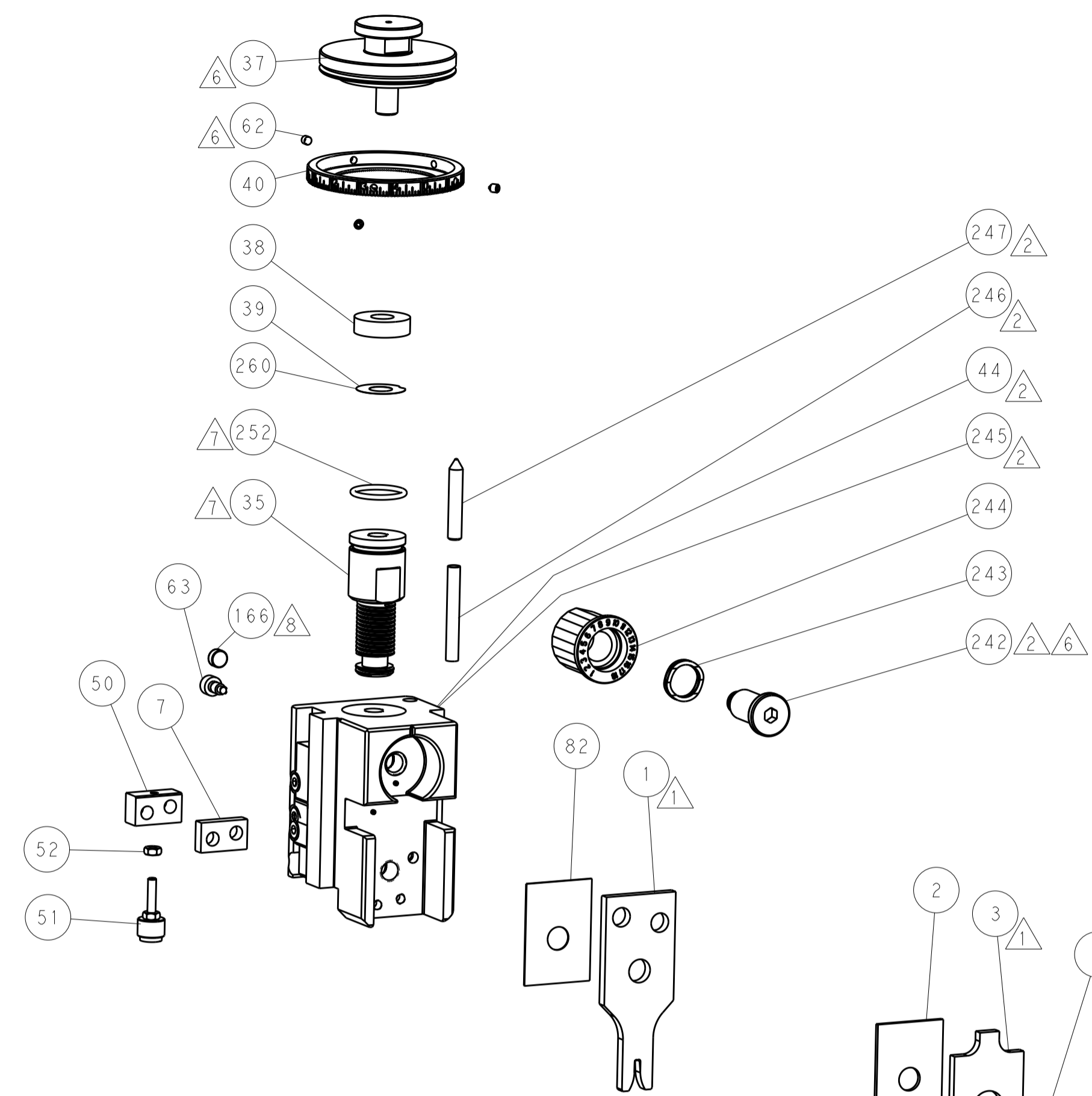
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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

| | | | | | | | |
|--|------------|--|-------------|----------------------------------|--------------|--------------------------|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN: R. STAKEM 19FEB2015 | | TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 | APVD: T. ELBIN 19FEB2015 | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | NAME: Ocean Side Feed Applicator | | RESTRICTED TO: | |
| Customer Accessible Production Drawing | | SCALE: 1:2 | | SHEET 2 of 4 | | REV A | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2266688-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266688-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266688-4 | - | - | - |
| | 2-2266688-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266688-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266688-4 | - | - | - |
| | 2-2266688-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 |
| | 2-2266688-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2266688-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.97 mm [.078] | F |
| INSUL | 2.72 mm [.107] | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: FORD TERMINAL | | YAZAKI CRIMP SPECIFICATION | |
|------------------------------------|-----------------|------------------------------|---------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.50-6.00 mm [1.217-.236 IN] | | Ø1.90-2.10 mm [.075-.083 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 7113-2326 Rev - | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | FORD TERMINAL | TE TERMINAL | FORD TERMINAL |
| 1572141-1 | 7113-2326 | 1572141-2 | E8EB-14461-KA |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 0.80mm2 | 1.30 +/- 0.05 [1.051 +/- .002] | 7.8 |
| 0.75mm2 | 1.30 +/- 0.05 [1.051 +/- .002] | 7.7 |
| 0.50mm2 | 1.20 +/- 0.05 [1.047 +/- .002] | 9.0 |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266688-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266688-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266688-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

***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 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 1 | 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)

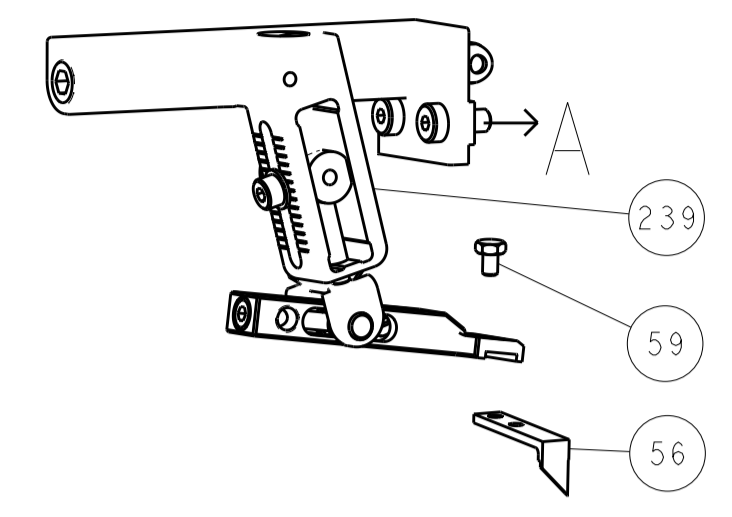
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-------------|------|----|------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPV |
| - | - | - | SEE SHEET 1 | - | - | - |

| | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | - | - | 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 | 2119082-5 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 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 |
| - | - | - | - | 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 | 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | - | - | 1 | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | 1 | 1 | 1 | 1 | 8-21084-1 | O-RING, .801 ID, .070 DIA. MAT. | 152 |
| - | - | - | 1 | - | 2119641-2 | FEED CAM, AIR FEED | 151 |
| - | 1 | 1 | 1 | 1 | 2119798-2 | DETENT PIN | 145 |
| - | 1 | 1 | 1 | 1 | 2079383-8 | SCR, BHSC, RoHS (M4 X 16) | 144 |
| - | 4 | 4 | 4 | 4 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 143 |
| - | - | - | - | 1 | 2119653-2 | FEED CAM, POST FEED | 142 |
| - | 1 | 1 | 1 | 1 | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1 | 1 | 1 | 2119650-1 | RAM, ASIAN STYLE, SIDE FEED | 140 |
| - | 1 | 1 | 1 | 1 | 2119092-2 | BOLT, ADJUSTMENT | 139 |
| - | - | - | 1 | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | - | - | 1 | - | 2119799-1 | HOLDER, FEED FINGER, AF | 136 |
| - | - | REF | - | - | - | SEE NOTE 4 | 135 |
| - | - | 1 | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 |
| - | - | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| - | 1 | 1 | 1 | 1 | 455888-4 | 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 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 1 | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| - | 3 | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62 |
| - | - | - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 2 | 2 | 2 | 2 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 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 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | 1 | 1 | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| - | 1 | 1 | 1 | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| - | 1 | 1 | 1 | 1 | 2119644-1 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 1752356-1 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 1 | 1 | 1 | 1 | 2161328-1 | HEX HEAD, FLANGED, M5 x 8mm LONG | 32 |
| - | 1 | 1 | 1 | 1 | 1320908-5 | 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 | 1803095-1 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 4-1803056-5 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 1-240641-0 | SPACER | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 2119757-4 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 3-238011-1 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 6-1803018-4 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 1 | 1 | 1-455888-2 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 8-1633305-0 | CRIMPER, WIRE PREMIUM | 1 |

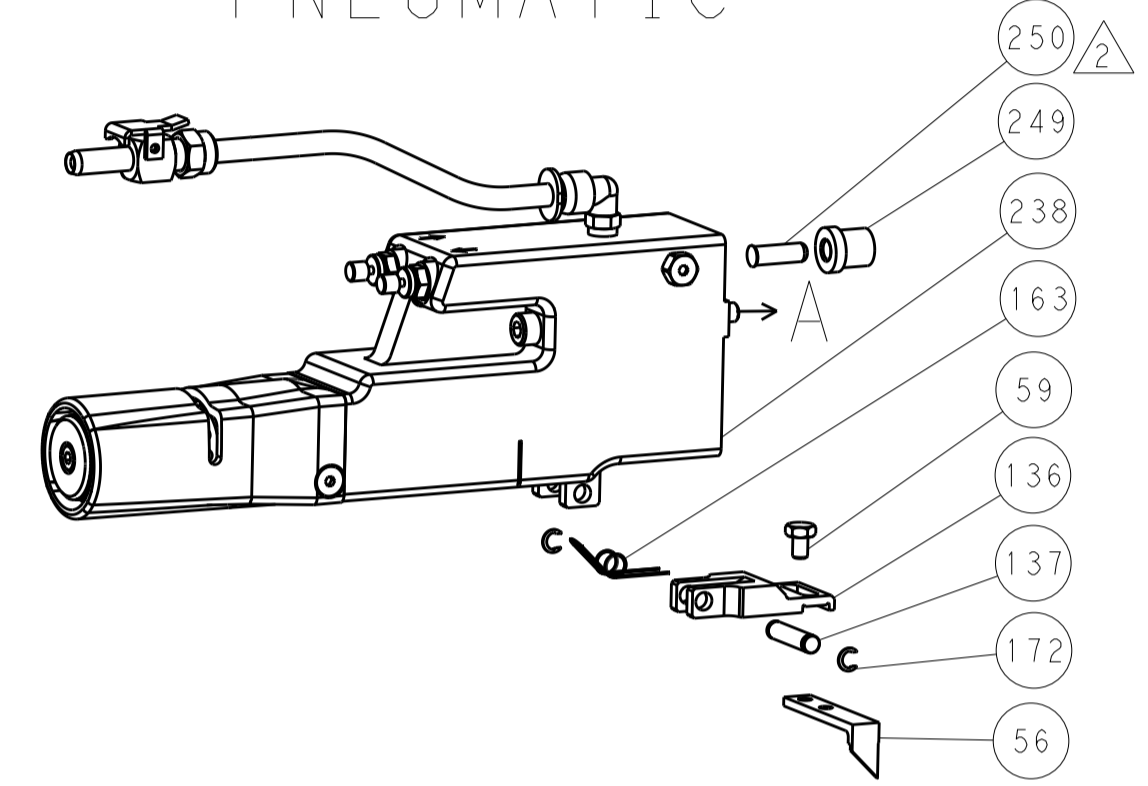
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DATE | BY | APPV | NAME |
|-------------|-------------|--|-------------|-----------|-----------|-----------|---------------------------|
| mm | 0 PLC ±.5 | 1 PLC ±.5 | 2 PLC ±.5 | 19FEB2015 | STAKEM | 19FEB2015 | TE Connectivity |
| | 3 PLC ±.5 | 4 PLC ±.5 | 5 PLC ±.5 | | G. BAILEY | | Harrisburg, PA 17105-3608 |
| | 6 PLC ±.5 | 7 PLC ±.5 | 8 PLC ±.5 | | | | |
| | 9 PLC ±.5 | 10 PLC ±.5 | 11 PLC ±.5 | | | | |
| | 12 PLC ±.5 | 13 PLC ±.5 | 14 PLC ±.5 | | | | |
| | 15 PLC ±.5 | 16 PLC ±.5 | 17 PLC ±.5 | | | | |
| | 18 PLC ±.5 | 19 PLC ±.5 | 20 PLC ±.5 | | | | |
| | 21 PLC ±.5 | 22 PLC ±.5 | 23 PLC ±.5 | | | | |
| | 24 PLC ±.5 | 25 PLC ±.5 | 26 PLC ±.5 | | | | |
| | 27 PLC ±.5 | 28 PLC ±.5 | 29 PLC ±.5 | | | | |
| | 30 PLC ±.5 | 31 PLC ±.5 | 32 PLC ±.5 | | | | |
| | 33 PLC ±.5 | 34 PLC ±.5 | 35 PLC ±.5 | | | | |
| | 36 PLC ±.5 | 37 PLC ±.5 | 38 PLC ±.5 | | | | |
| | 39 PLC ±.5 | 40 PLC ±.5 | 41 PLC ±.5 | | | | |
| | 42 PLC ±.5 | 43 PLC ±.5 | 44 PLC ±.5 | | | | |
| | 45 PLC ±.5 | 46 PLC ±.5 | 47 PLC ±.5 | | | | |
| | 48 PLC ±.5 | 49 PLC ±.5 | 50 PLC ±.5 | | | | |
| | 51 PLC ±.5 | 52 PLC ±.5 | 53 PLC ±.5 | | | | |
| | 54 PLC ±.5 | 55 PLC ±.5 | 56 PLC ±.5 | | | | |
| | 57 PLC ±.5 | 58 PLC ±.5 | 59 PLC ±.5 | | | | |
| | 60 PLC ±.5 | 61 PLC ±.5 | 62 PLC ±.5 | | | | |
| | 63 PLC ±.5 | 64 PLC ±.5 | 65 PLC ±.5 | | | | |
| | 66 PLC ±.5 | 67 PLC ±.5 | 68 PLC ±.5 | | | | |
| | 69 PLC ±.5 | 70 PLC ±.5 | 71 PLC ±.5 | | | | |
| | 72 PLC ±.5 | 73 PLC ±.5 | 74 PLC ±.5 | | | | |
| | 75 PLC ±.5 | 76 PLC ±.5 | 77 PLC ±.5 | | | | |
| | 78 PLC ±.5 | 79 PLC ±.5 | 80 PLC ±.5 | | | | |
| | 81 PLC ±.5 | 82 PLC ±.5 | 83 PLC ±.5 | | | | |
| | 84 PLC ±.5 | 85 PLC ±.5 | 86 PLC ±.5 | | | | |
| | 87 PLC ±.5 | 88 PLC ±.5 | 89 PLC ±.5 | | | | |
| | 90 PLC ±.5 | 91 PLC ±.5 | 92 PLC ±.5 | | | | |
| | 93 PLC ±.5 | 94 PLC ±.5 | 95 PLC ±.5 | | | | |
| | 96 PLC ±.5 | 97 PLC ±.5 | 98 PLC ±.5 | | | | |
| | 99 PLC ±.5 | 100 PLC ±.5 | 101 PLC ±.5 | | | | |
| | 102 PLC ±.5 | 103 PLC ±.5 | 104 PLC ±.5 | | | | |
| | 105 PLC ±.5 | 106 PLC ±.5 | 107 PLC ±.5 | | | | |
| | 108 PLC ±.5 | 109 PLC ±.5 | 110 PLC ±.5 | | | | |
| | 111 PLC ±.5 | 112 PLC ±.5 | 113 PLC ±.5 | | | | |
| | 114 PLC ±.5 | 115 PLC ±.5 | 116 PLC ±.5 | | | | |
| | 117 PLC ±.5 | 118 PLC ±.5 | 119 PLC ±.5 | | | | |
| | 120 PLC ±.5 | 121 PLC ±.5 | 122 PLC ±.5 | | | | |
| | 123 PLC ±.5 | 124 PLC ±.5 | 125 PLC ±.5 | | | | |
| | 126 PLC ±.5 | 127 PLC ±.5 | 128 PLC ±.5 | | | | |
| | 129 PLC ±.5 | 130 PLC ±.5 | 131 PLC ±.5 | | | | |
| | 132 PLC ±.5 | 133 PLC ±.5 | 134 PLC ±.5 | | | | |
| | 135 PLC ±.5 | 136 PLC ±.5 | 137 PLC ±.5 | | | | |
| | 138 PLC ±.5 | 139 PLC ±.5 | 140 PLC ±.5 | | | | |
| | 141 PLC ±.5 | 142 PLC ±.5 | 143 PLC ±.5 | | | | |
| | 144 PLC ±.5 | 145 PLC ±.5 | 146 PLC ±.5 | | | | |
| | 147 PLC ±.5 | 148 PLC ±.5 | 149 PLC ±.5 | | | | |
| | 150 PLC ±.5 | 151 PLC ±.5 | 152 PLC ±.5 | | | | |
| | 153 PLC ±.5 | 154 PLC ±.5 | 155 PLC ±.5 | | | | |
| | 156 PLC ±.5 | 157 PLC ±.5 | 158 PLC ±.5 | | | | |
| | 159 PLC ±.5 | 160 PLC ±.5 | 161 PLC ±.5 | | | | |
| | 162 PLC ±.5 | 163 PLC ±.5 | 164 PLC ±.5 | | | | |

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

FEED TYPE MECHANICAL



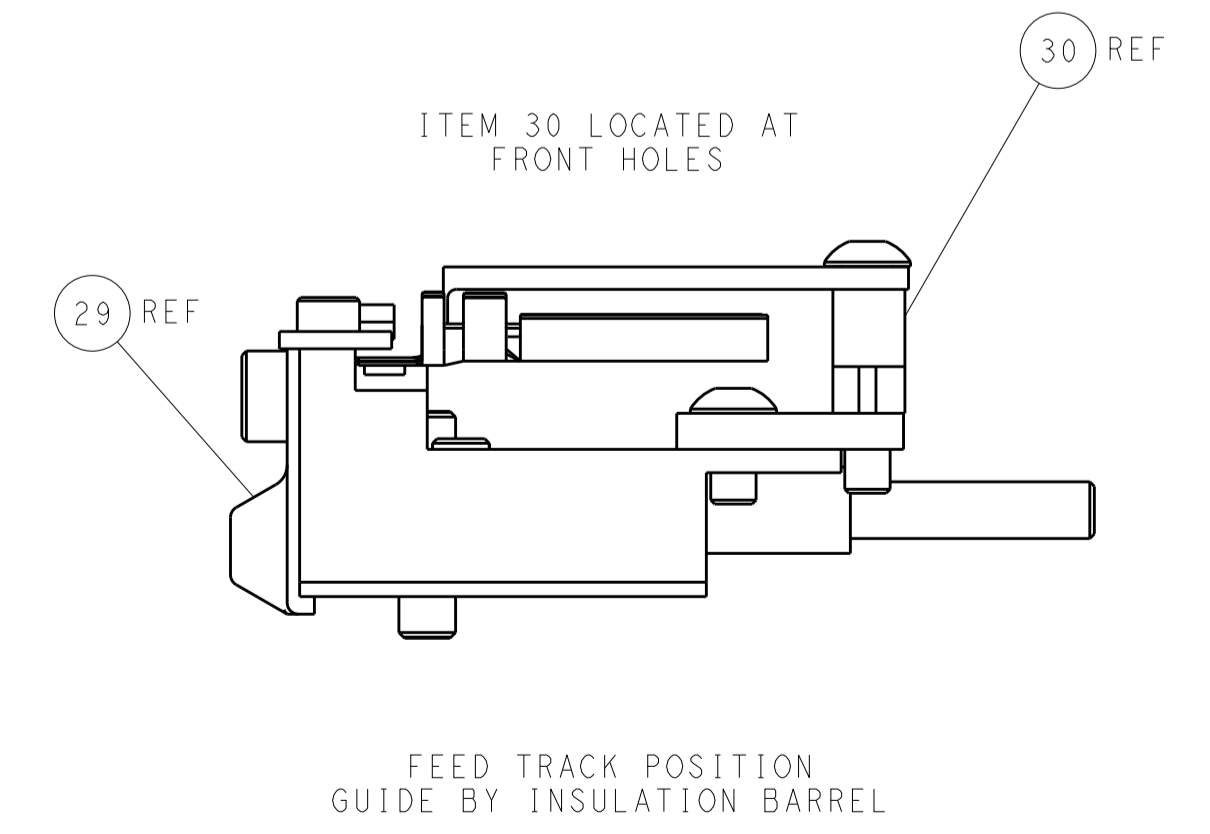
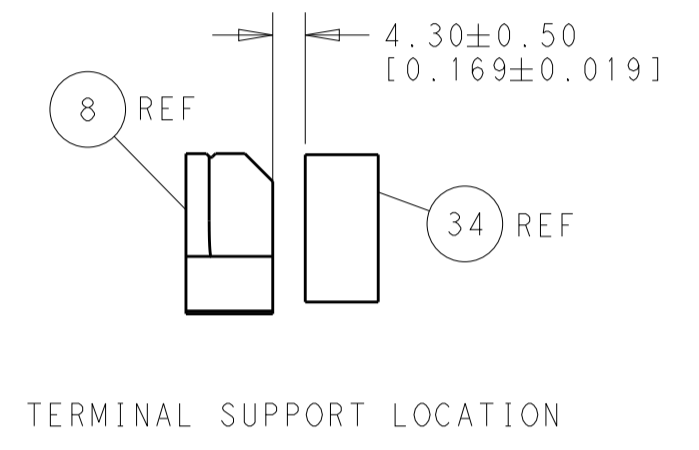
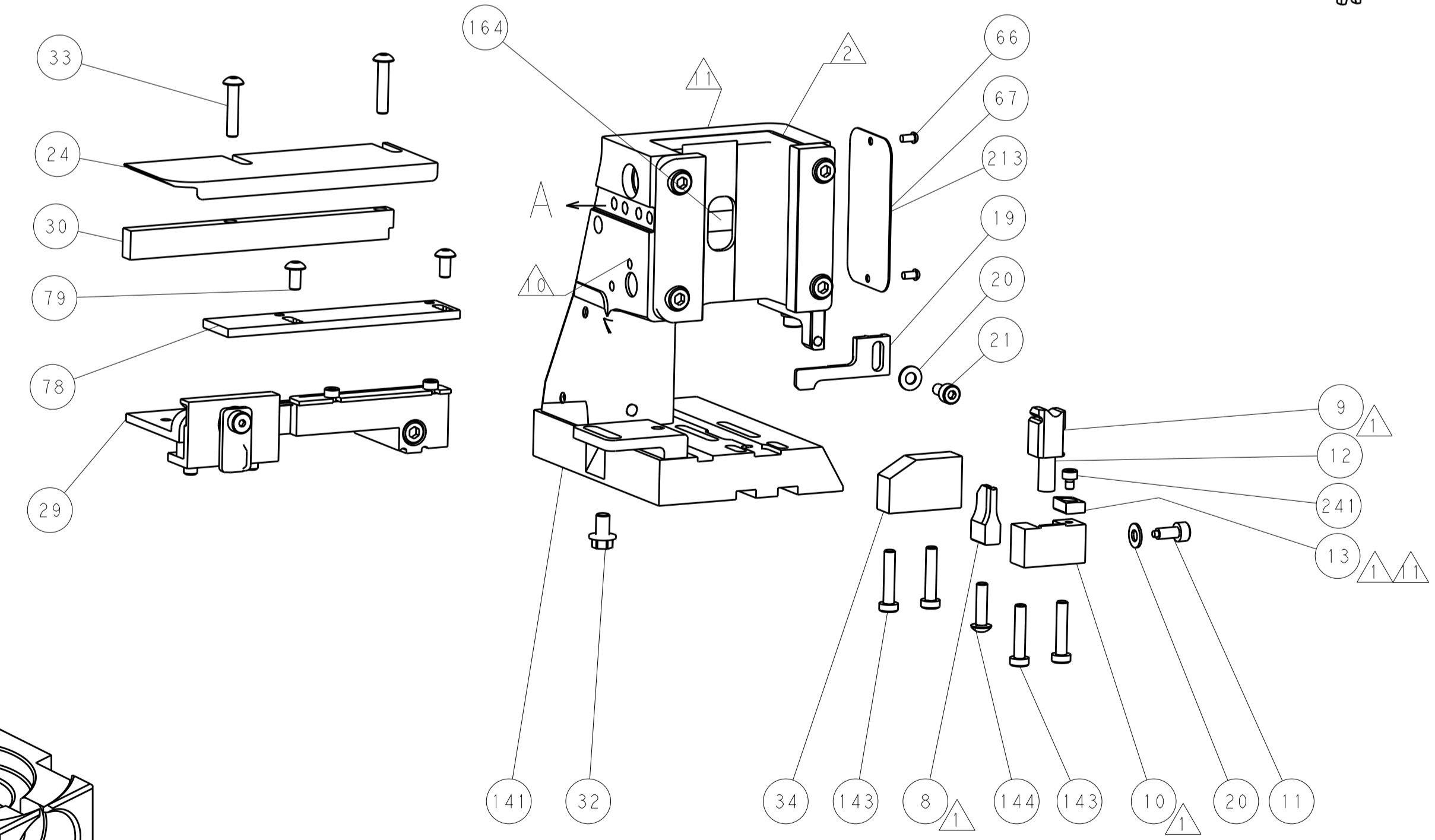
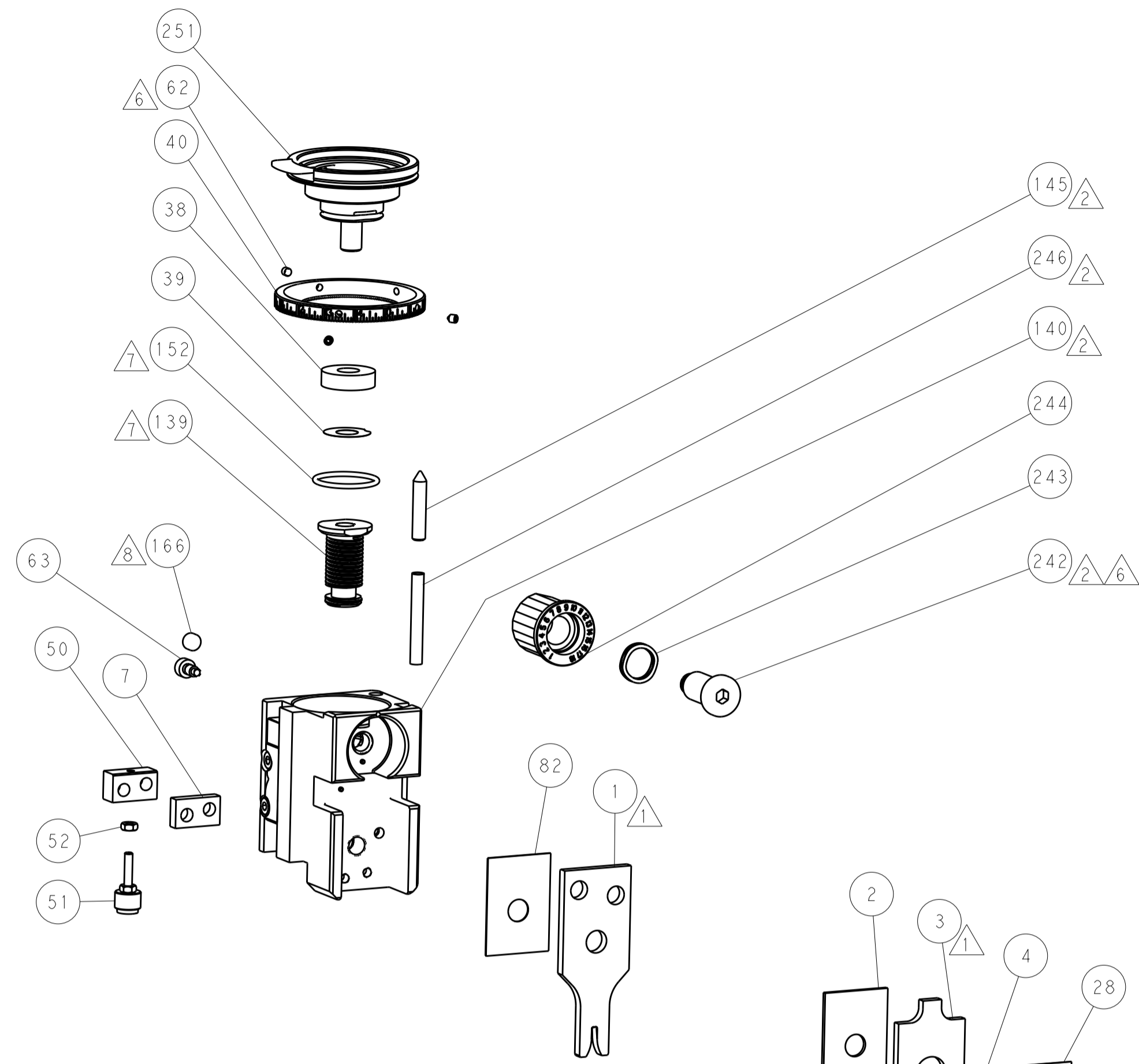
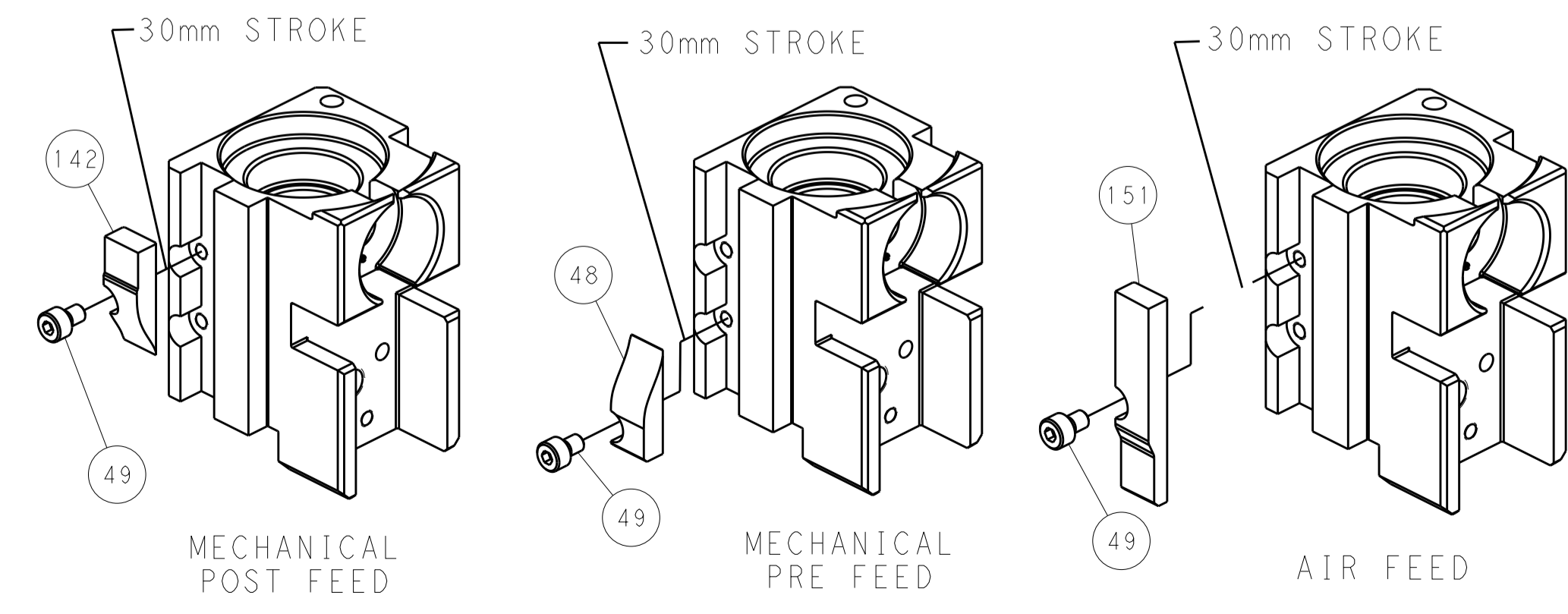
PNEUMATIC



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: | | OWN: STAKEM 19FEB2015 | | TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 | ANGLES ±0.001 | FINISH |
| MATERIAL: | | | | WEIGHT: | | RESTRICTED TO: | |
| Customer Accessible Production Drawing | | | | SCALE: 1:2 | | SHEET 4 OF 4 REV A | |