

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | | |
|---|-------------|--------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-------------|-------------|-----------|-----------|------------------------|---|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | | |
| | | | | | | | | | | | | |
| | 2266470-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-3 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266470-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266470-4 | - | - | - | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-3 | 5-18022-5 | 2119653-1 | - | - | |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266470-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266470-4 | - | - | - | |
| | 2266470-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-3 | 5-18022-5 | 2119653-1 | - | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266470-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266470-4 | - | - | - | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-3 | 5-18022-5 | 2119653-1 | - | - | |
| | | | | | PNEUMATIC FEED | 2119950-1 | 1338685-3 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | |
| | | | | | - | - | - | - | - | - | - | - |
| 2266470-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1 | - | 8-2266470-5 | 1901094-3 | - | - | - | |
| | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266470-4 | - | - | - | | |
| 2266470-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1 | - | 8-2266470-5 | 1901094-3 | - | - | - | |
| | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266470-4 | - | - | - | | |
| 2266470-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | - | |
| | | | | - | - | - | - | - | - | - | - | |
| 7-2266470-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 3.76 mm [1.48] | F |
| INSUL | - | - |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| | |
|--|--------------------------------|
| TERMINAL DATA: HEYCO TERMINAL | TE CRIMP SPECIFICATION |
| TERMINAL NAME: GROUND PIN, MALE | |
| WIRE STRIP LENGTH 4.34-5.11 mm [1.71-.201 IN] | INSULATION DIAMETER RANGE Ø |
| TERMINAL APPLICATION SPECIFICATION NONE | - |
| TERMINALS APPLIED | |
| TE TERMINAL 2113571-1 | HEYCO TERMINAL 5922 |
| TE TERMINAL 2113571-2 | HEYCO TERMINAL 5921 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 12 AWG | 2.68 +/- 0.05 [1.105 +/- .002] | 4.3 |
| 14 AWG | 2.41 +/- 0.05 [1.095 +/- .002] | 6.9 |
| 16 AWG | 2.23 +/- 0.05 [1.088 +/- .002] | 8.8 |
| 18 AWG | 2.13 +/- 0.05 [1.084 +/- .002] | 9.8 |

- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
- 3 LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266470-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266470-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266470-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266470-6
- 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 ITEM 62. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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 4.40.
- 13 INSTALL ITEMS 20, 274 & 275 INTO THE STRIPPER HOLE IN THE APPLICATOR HOUSING.

*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.

| ITEM NO | DESCRIPTION | ITEM NO | | | |
|---------|----------------------------------|-------------|----|----|---------|
| 1 | INSERT, COUPLING | 278 | | | |
| 457 | TUBING, POLYURETHANE | 277 | | | |
| 1 | CLAMP, CABLE, BLACK | 275 | | | |
| 1 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 274 | | | |
| 2 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269 | | | |
| 1 | FENCE | 267 | | | |
| 1 | APPLICATOR SHIM PACK | 260 | | | |
| 1 | SPACER, PRECISION | 259 | | | |
| 1 | O-RING, .676 ID, .070 DIA. MAT. | 252 | | | |
| 1 | PUSH ROD, AIR FEED | 250 | | | |
| -77 | PART NO | DESCRIPTION | | | |
| -7 | -6 | -5 | -2 | -1 | ITEM NO |

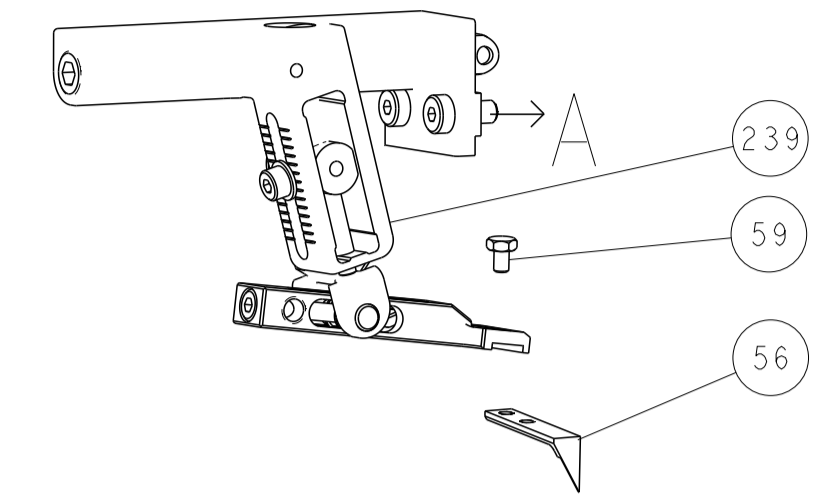
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

| P | LTN | DESCRIPTION | DATE | DWN | APVD | REVISIONS | | |
|-----|-----|-------------|------|-----|-------------|-------------------------------------|-------------|---------|
| | | | | | | REV | BY | DATE |
| - | - | - | 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 | - | - | 2161314-1 | RAM, STEPPED, ATLANTIC, SF, NON-ADJ | | 245 |
| - | - | 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 | 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 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | | 143 |
| - | - | - | 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 | 1-22281-8 | SPRING, COMPRESSION | | 121 |
| - | - | REF | REF | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | | 117 |
| - | 1 | 1 | 1 | 1 | 3-690712-3 | FRONT STRIP GUIDE | | 96 |
| - | 2 | 2 | 2 | 2 | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16 | | 95 |
| - | 1 | 1 | 1 | 1 | 2168083-6 | SCR, SKT HD CAP, RoHS, M5 X 65 | | 93 |
| - | 1 | 1 | 1 | 1 | 455888-1 | SPACER, CRIMPER | | 82 |
| - | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | | 71 |
| - | 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 |
| 6 | 3 | - | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 X 4.0 | | 62 |
| - | 2 | 2 | 2 | 2 | 2-18032-5 | SCR, SET, FLT POINT M5 X 20.0 | | 61 |
| - | 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 | 1338685-3 | PAWL, FEED | | 56 |
| - | 2 | 2 | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | | 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 | 2119653-1 | FEED CAM, POST FEED | | 47 |
| - | 1 | 1 | 1 | 1 | 2-2119656-3 | APPLICATOR BASIC ASSEMBLY, SF | | 46 |
| - | 1 | - | 1 | 1 | 2161311-1 | RAM, STEPPED, AMP STYLE, SIDE FEED | | 44 |
| - | 1 | 1 | 1 | 1 | 1-2079383-5 | SCR, BHSC, RoHS (M8 X 40) | | 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 | 2119644-1 | RAM WASHER, PRECISION | | 38 |
| - | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | | 37 |
| - | 1 | - | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | | 35 |
| - | 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 | 2-1320908-4 | SPACER, STRIP GUIDE | | 30 |
| - | 1 | 1 | 1 | 1 | 1901086-3 | PLATE, STRIP GUIDE | | 29 |
| - | 1 | 1 | 1 | 1 | 1-455888-4 | SPACER, CRIMPER | | 28 |
| - | 2 | 2 | 2 | 2 | 22283-1 | SPRING, COMPRESSION | | 27 |
| - | 1 | 1 | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | | 26 |
| - | 1 | 1 | 1 | 1 | 2-690754-2 | DRAG, SPECIAL | | 25 |
| - | 1 | 1 | 1 | 1 | 1-690440-6 | GUIDE, REAR STRIP | | 24 |
| - | 1 | 1 | 1 | 1 | 980371-4 | SCR, SKT HD SHLDR 5.0 DIA X 6.0 | | 23 |
| - | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | | 21 |
| - | 6 | 6 | 6 | 6 | 1-18028-2 | WASHER, FLAT, REG M4 | | 20 |
| - | 1 | 1 | 1 | 1 | 1-2119533-0 | STRIPPER, SIDE FEED | | 19 |
| - | 1 | 1 | 1 | 1 | 3-853720-6 | BLADE, SLUG | | 10 |
| - | 1 | 1 | 1 | 1 | 2-1803012-6 | PLATE, REAR SHEAR | | 9 |
| - | - | - | - | - | - | - | | 9 |
| 11 | 1 | 1 | 1 | 1 | 1803192-1 | ANVIL, WIRE, SPECIAL | | 8 |
| - | 1 | 1 | 1 | 1 | 1-240641-1 | SPACER | | 7 |
| - | - | - | - | - | - | - | | 6 |
| - | - | - | - | - | - | - | | 5 |
| - | - | - | - | - | - | - | | 4 |
| - | - | - | - | - | - | - | | 3 |
| - | - | - | - | - | - | - | | 2 |
| 11 | 1 | 1 | 1 | 1 | 4-568176-1 | CRIMPER, WIRE | | 1 |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

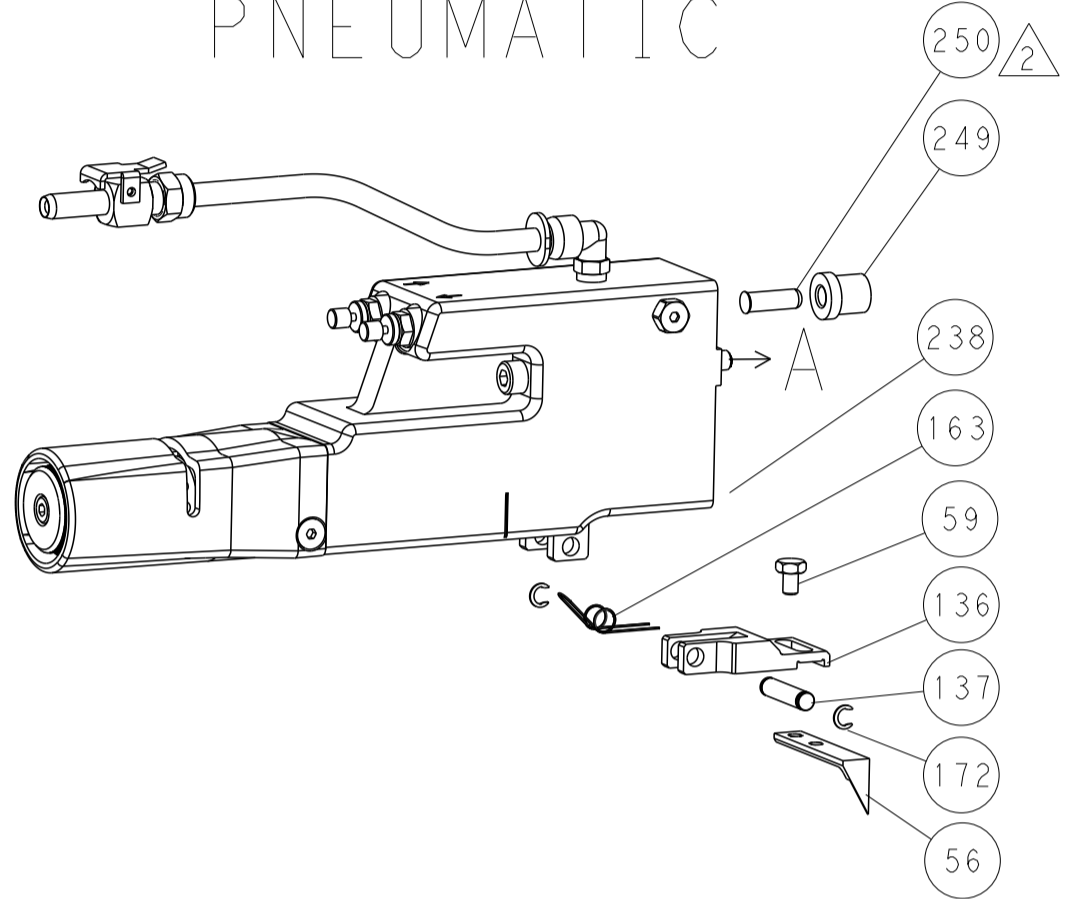
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| mm | 0 PLC ±.05 | 1 PLC ±.03 | 2 PLC ±.02 | 08SEP2014 | R.O. WILSON | | |
| mm | 3 PLC ±.013 | 4 PLC ±.008 | ANGLES ±.0001 | 12SEP2014 | K. J. STAKEM | | |
| MATERIAL: | FINISH: | WEIGHT: | SCALE: | 12SEP2014 | I.L. ELBIN | | |
| Customer Accessible Production Drawing | SCALE: 1:2 | SHEET 1 OF 4 | REV A | Ocean Side Feed Applicator | | | |

| LOC | DIST | REV | DATE | BY | APPV |
|-----|------|-----|------|----|------|
| A | 66 | | | | |
| | | | | | |
| | | | | | |

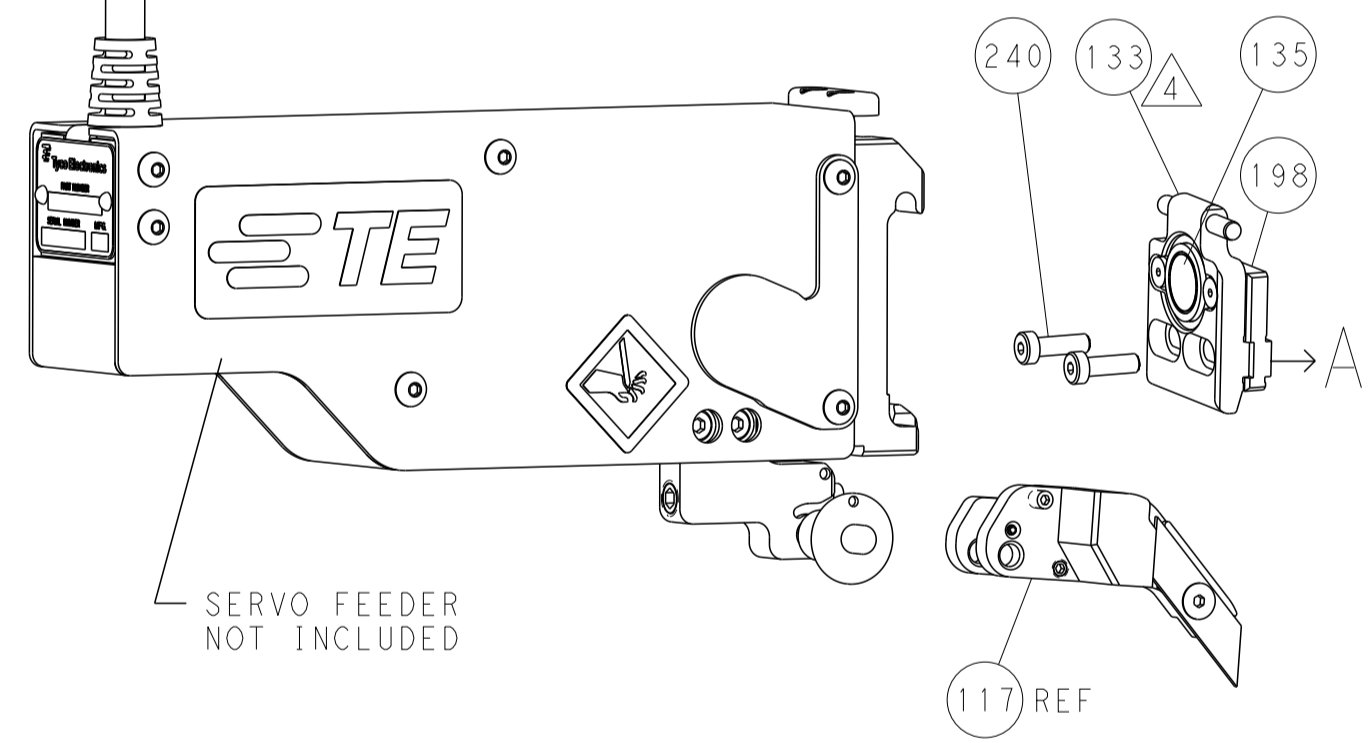
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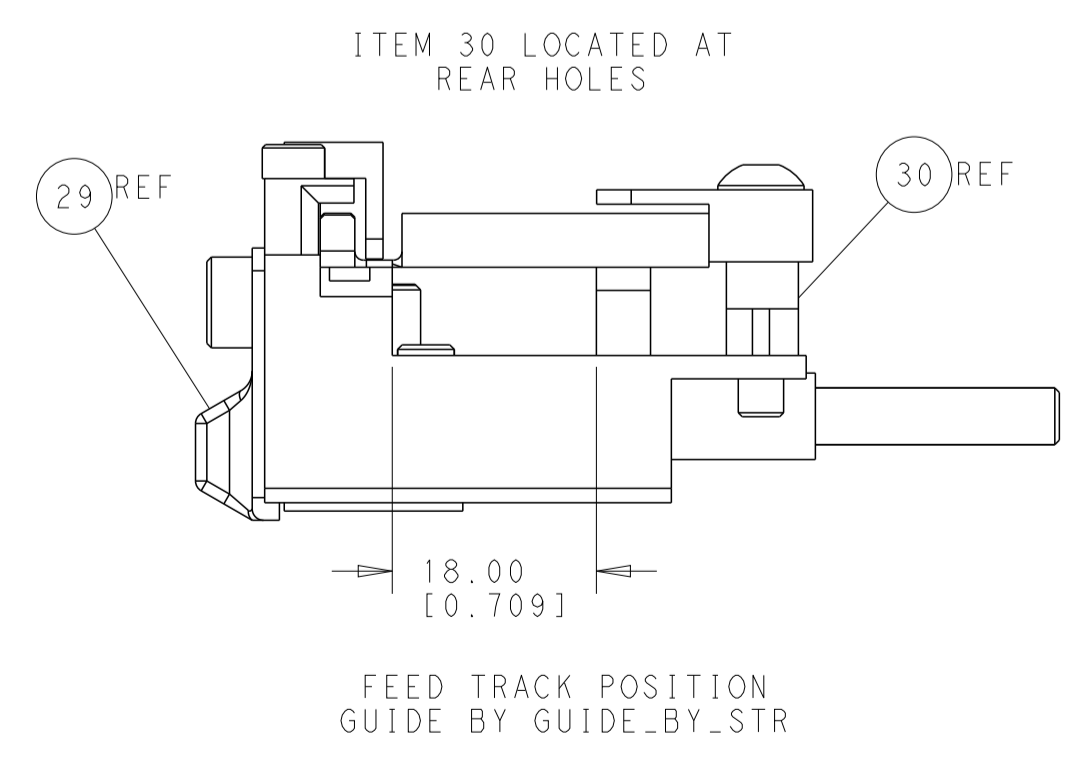
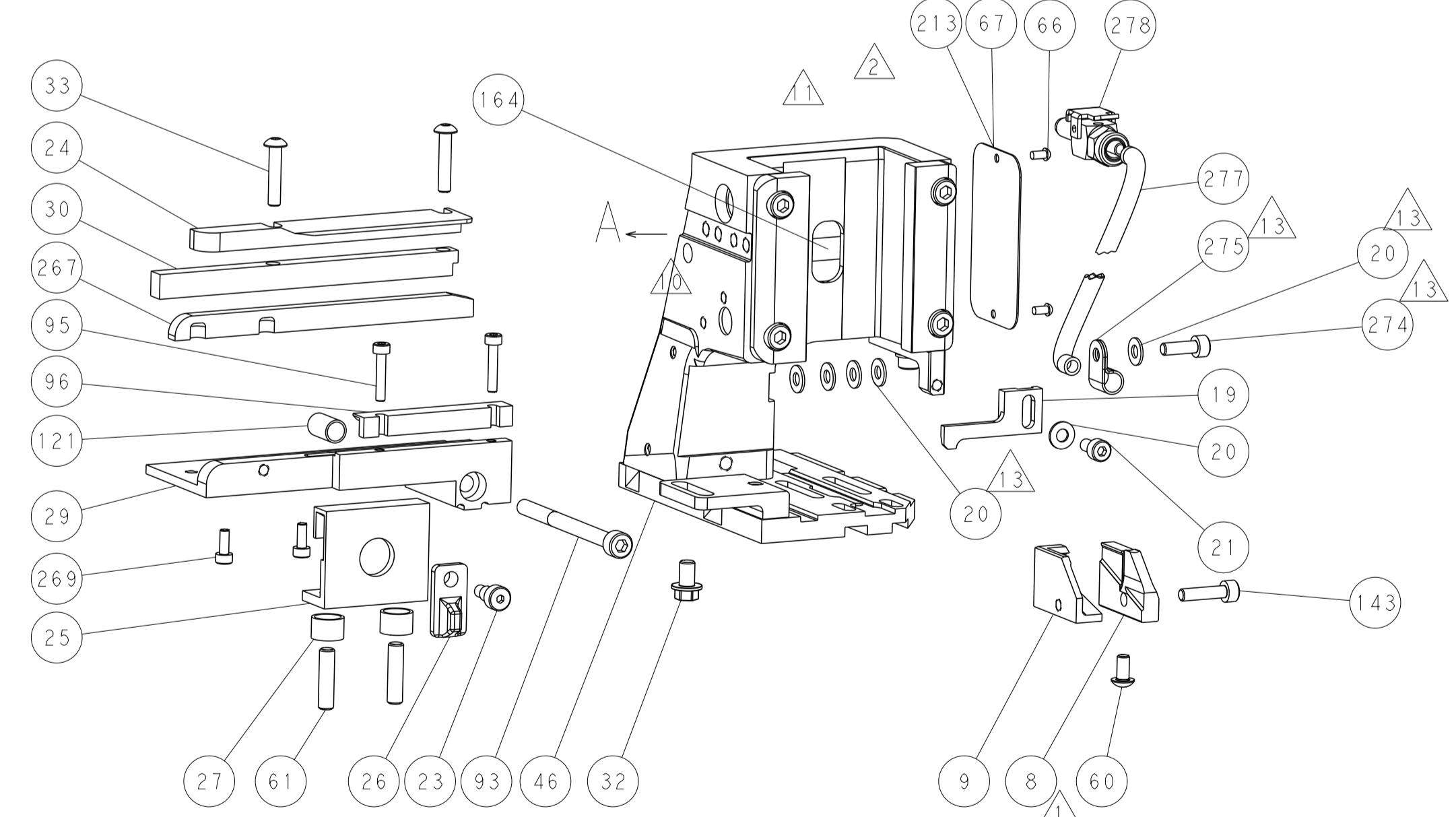
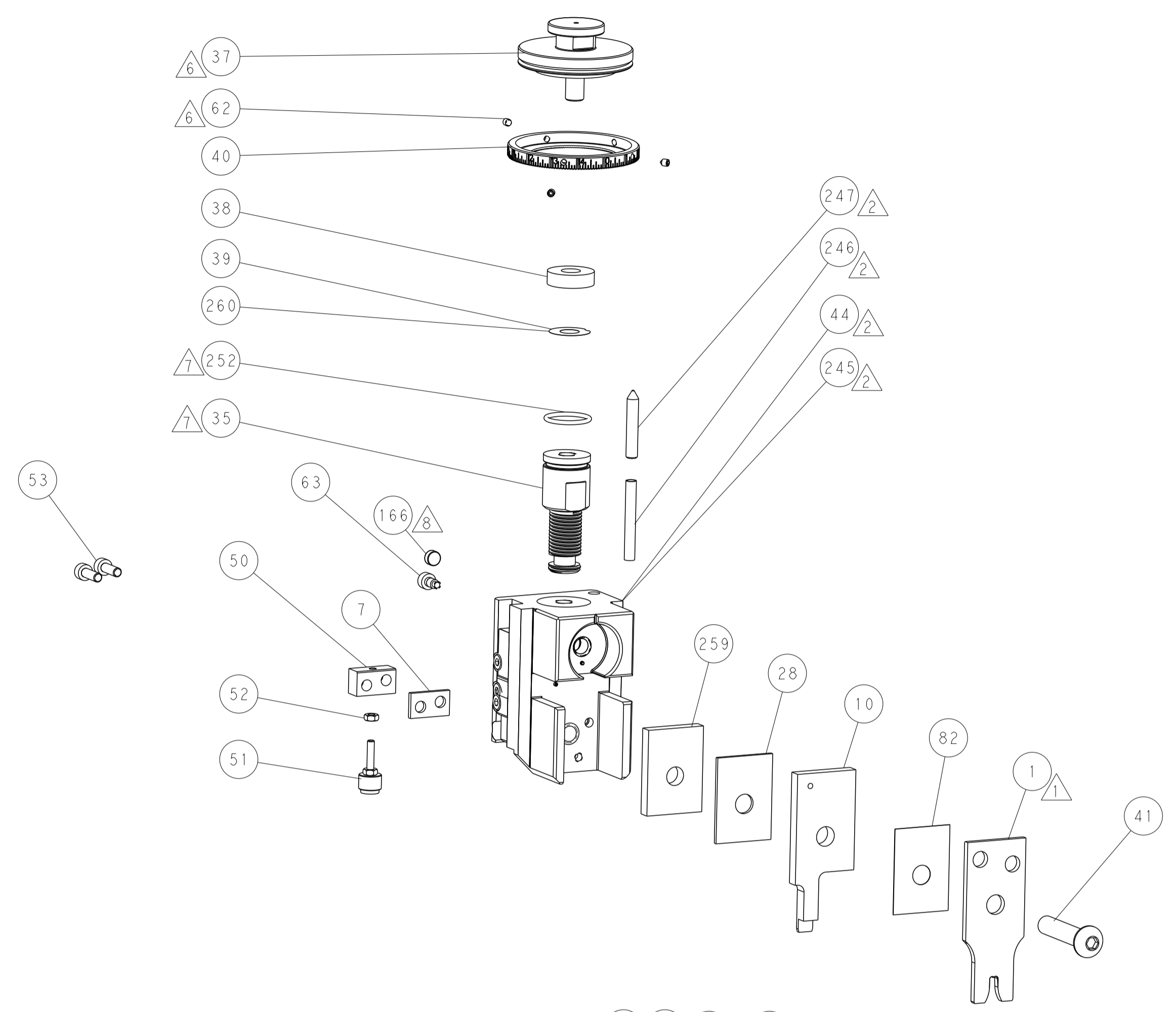
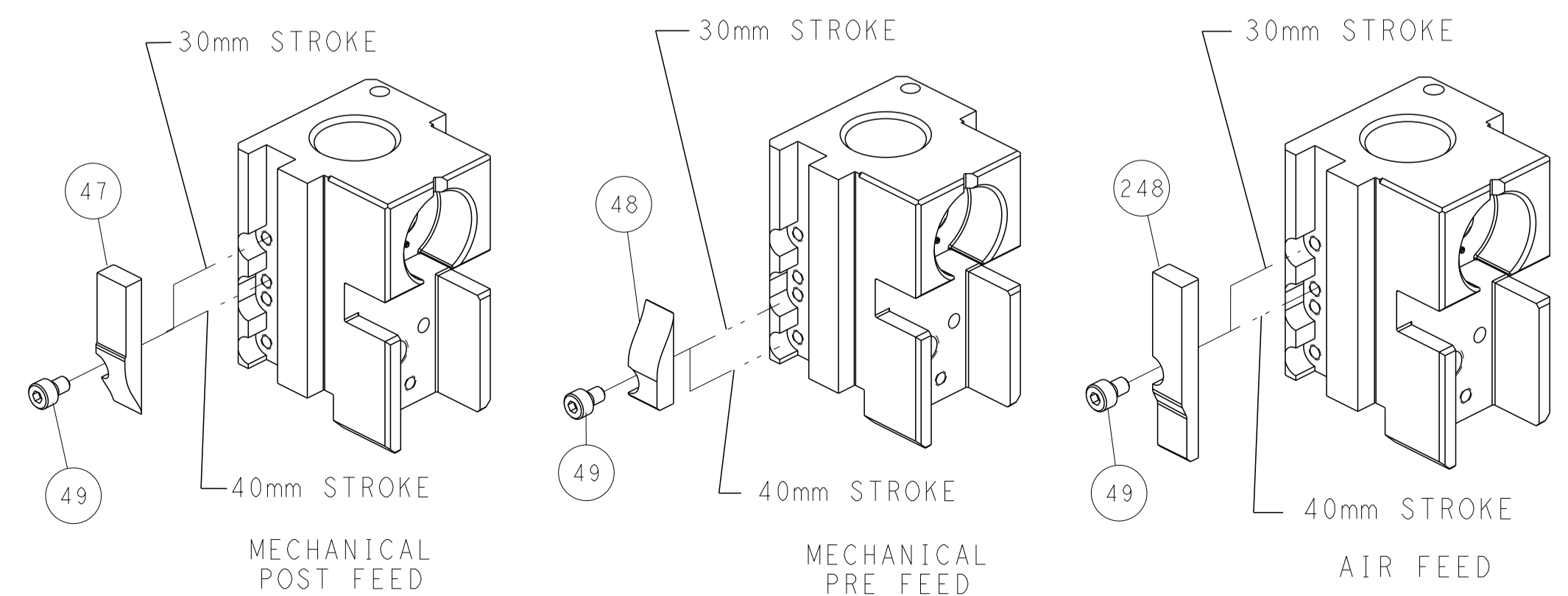
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS

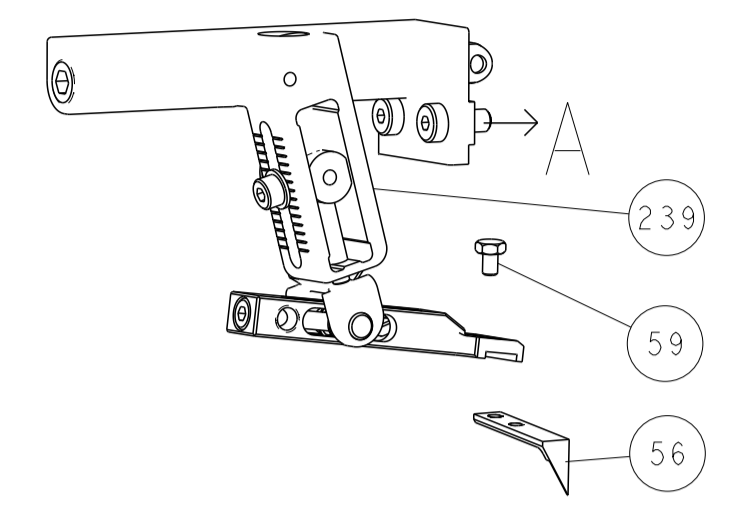


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

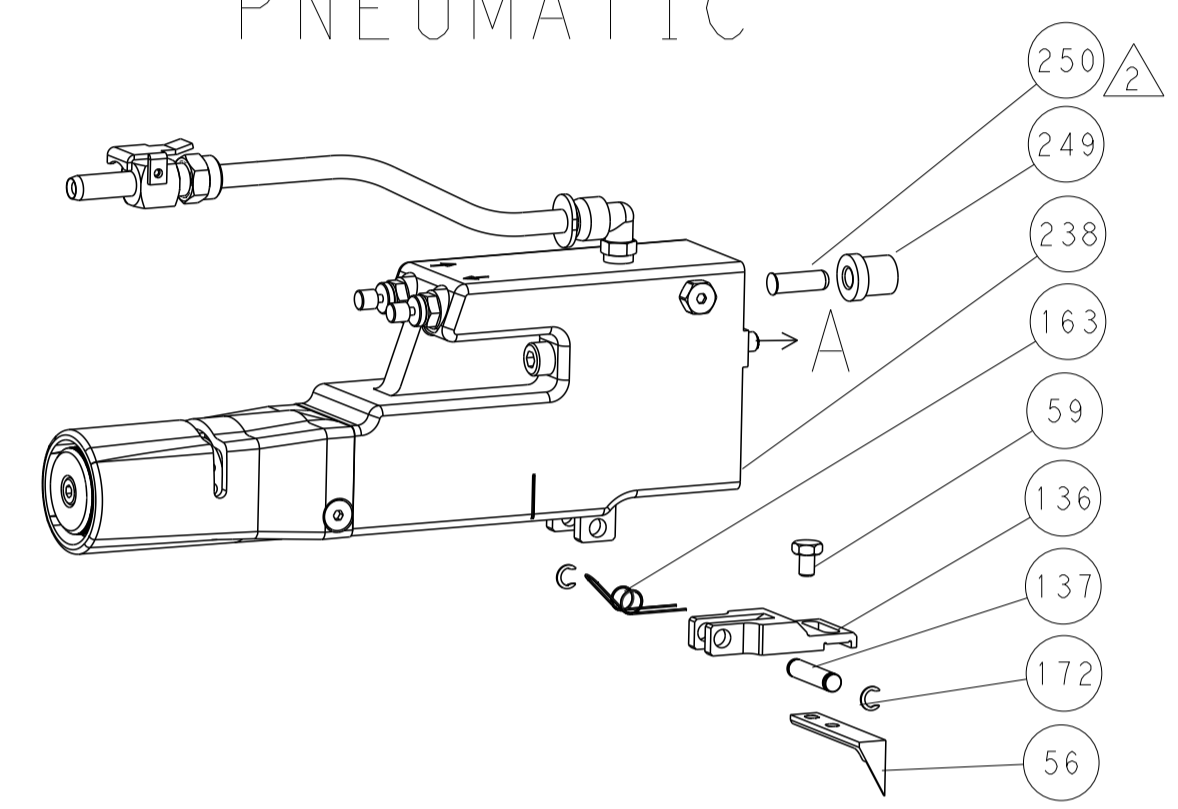
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|-----------------------|--|--|--|---|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1 FINISH | | DWN R.O. WILSON 08SEP2014 CHK K.J. STAKEM 12SEP2014 APVD T.L. ELBIN 12SEP2014 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266470 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV A | |
| MATERIAL: | | WEIGHT: | | DATE: 12SEP2014 BY: K.J. STAKEM APPV: T.L. ELBIN | |

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

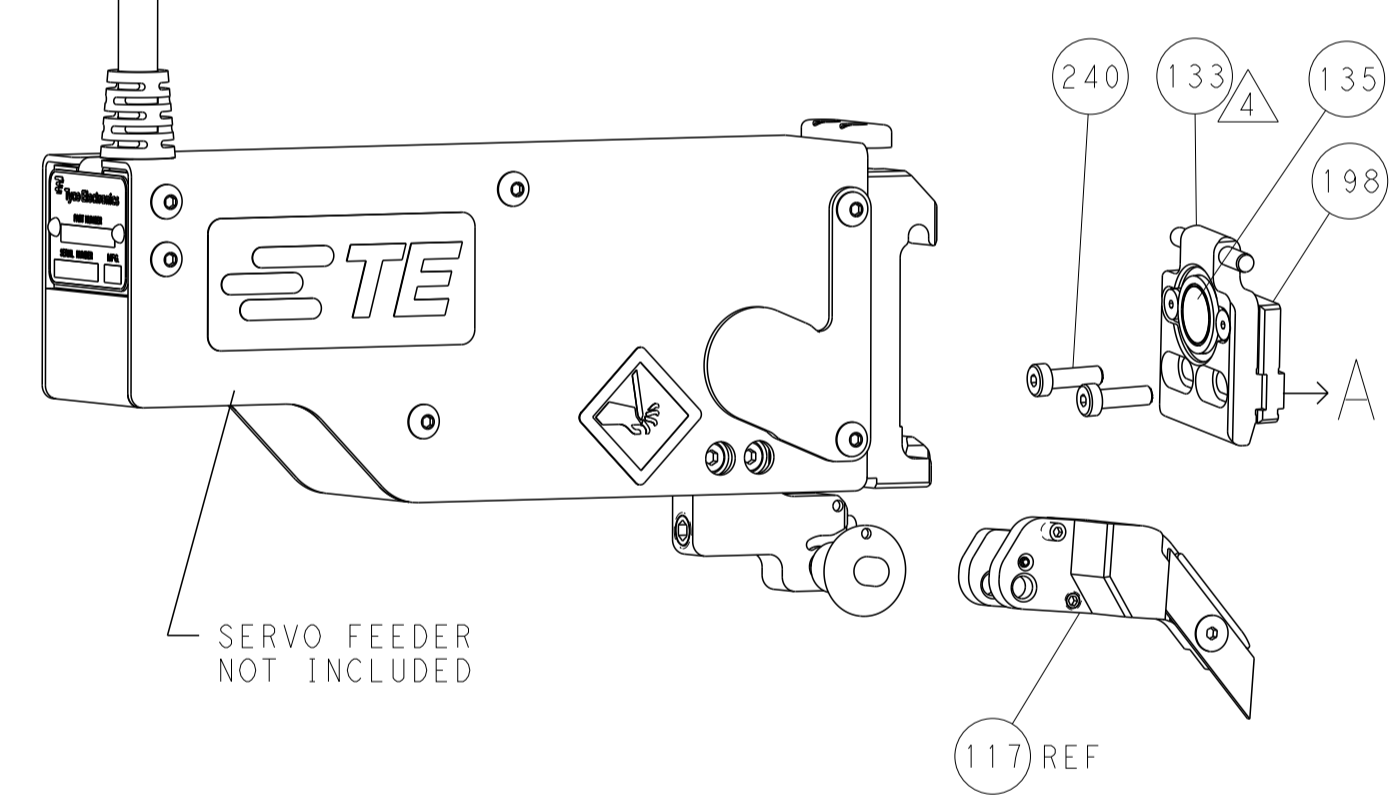
FEED TYPE MECHANICAL



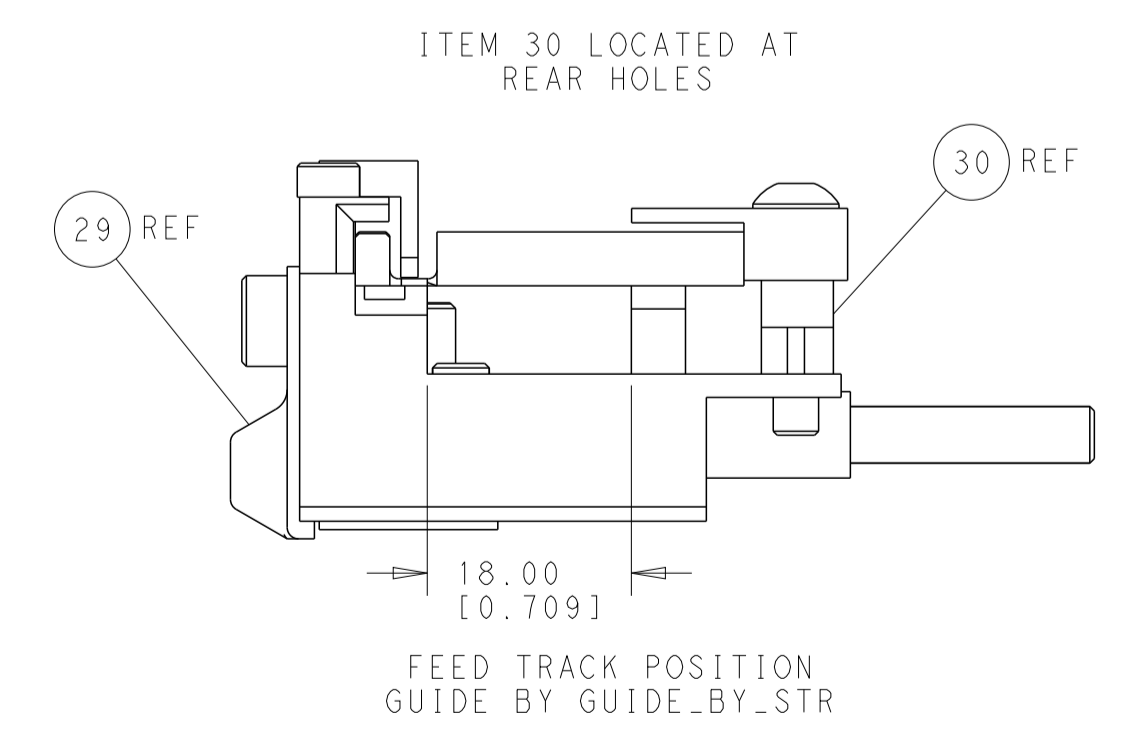
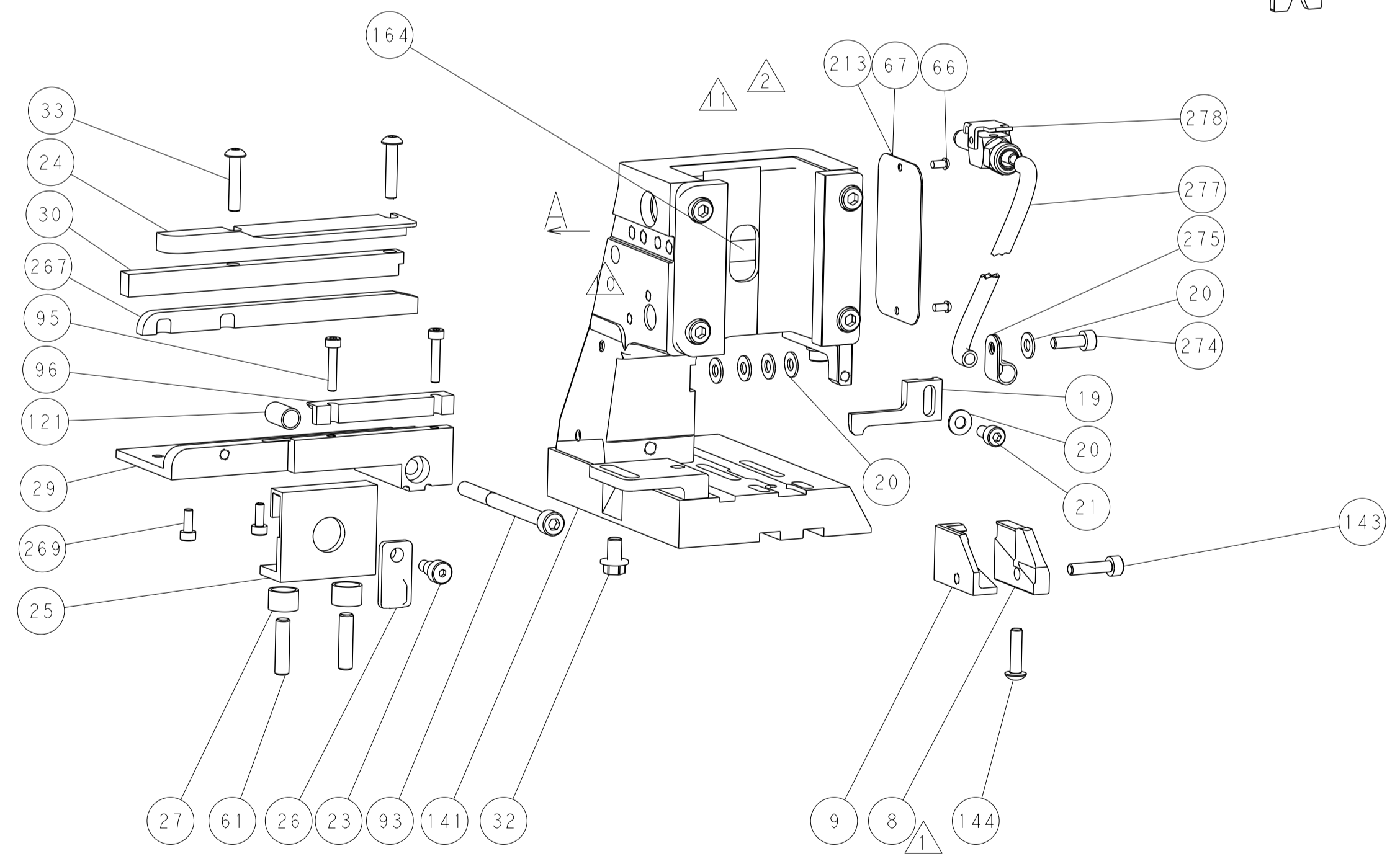
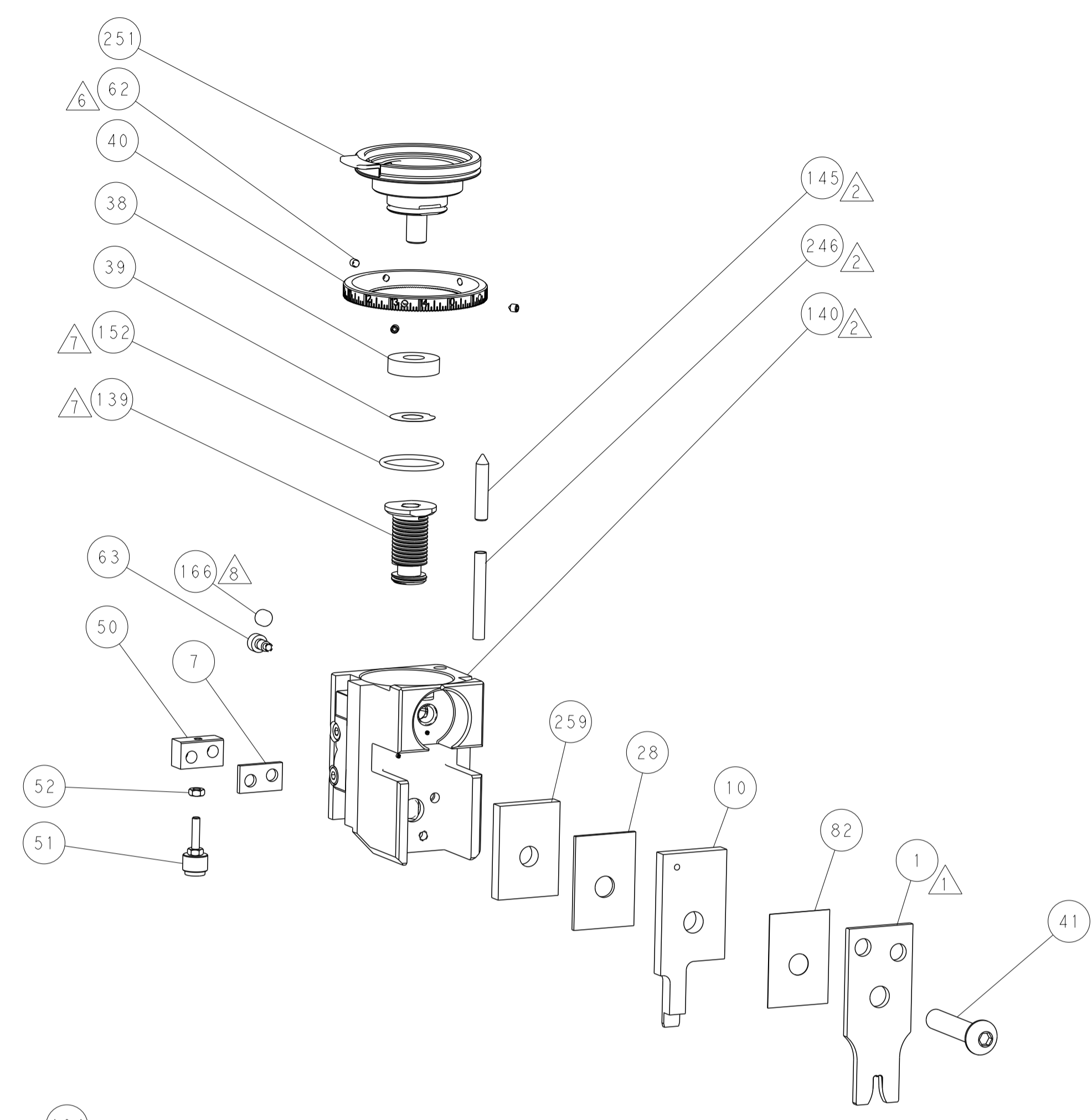
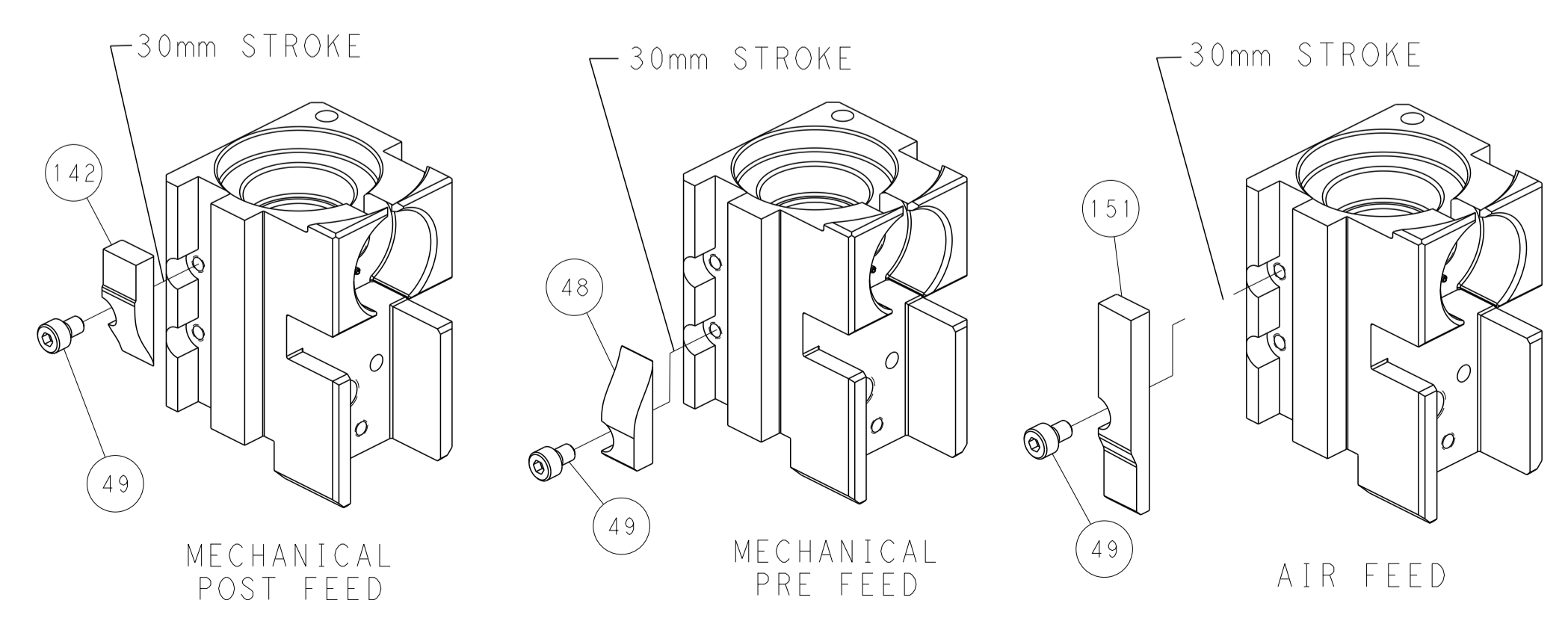
PNEUMATIC



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: R.O. WILSON 08SEP2014 | | REV: T.L. ELBIN 12SEP2014 | | 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 |
| MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: 1:2 | | SHEET 4 OF 4 | |
| Customer Accessible Production Drawing | | SCALE: 1:2 | | SHEET 4 OF 4 | | REV A | | RESTRICTED TO: | |