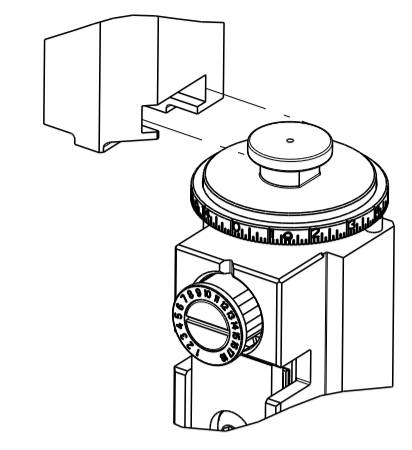


| PART NUMBER | REVISION | DESCRIPTION                            | FEED TYPE  |
|-------------|----------|--|------------|
| 2151015-1   | D        | FINE CRIMP HEIGHT ADJUST               | MECHANICAL |
| 2151015-2   | D        | FINE CRIMP HEIGHT ADJUST               | PNEUMATIC  |
| 5-2151015-1 | D        | SEAL STRIPPER CRIMPER TERMINATION UNIT | MECHANICAL |
| 5-2151015-2 | D        | SEAL STRIPPER CRIMPER TERMINATION UNIT | PNEUMATIC  |
| 7-2151015-1 | D        | MECHANICAL AND CRIMP TOOLING KIT       | MECHANICAL |
| 7-2151015-2 | D        | PNEUMATIC AND CRIMP TOOLING KIT        | PNEUMATIC  |
| 7-2151015-7 | A        | CRIMP TOOLING KIT                      | -          |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.58 mm [.062] | F    |
| INSUL           | 3.18 mm [.125] | F    |

APPLICATOR INSTRUCTIONS  
408-35042

| TERMINAL DATA: MOLEX TERMINAL                |  | MOLEX CRIMP SPECIFICATION    |  |
|--|--|------------------------------|--|
| TERMINAL NAME: 4.2mm PITCH MINI-FIT TERMINAL |  |                              |  |
| WIRE STRIP LENGTH                            |  | INSULATION DIAMETER RANGE    |  |
| 3.00-3.50 mm [.118-.138 IN]                  |  | Ø2.50-2.95 mm [.098-.116 IN] |  |

| TERMINAL APPLICATION SPECIFICATION |  |
|------------------------------------|--|
| MOLEX 63900-2600 REV J             |  |

TERMINALS APPLIED

| TE TERMINAL | MOLEX TERMINAL | TE TERMINAL | MOLEX TERMINAL |
|-------------|----------------|-------------|----------------|
| 286603-1    | 39-00-0038     | 286611-1    | 39-00-0040     |
| 286603-2    | 39-00-0055     | 286611-2    | 39-00-0061     |
| 286603-3    | 39-00-0207     | 286611-3    | 39-00-0053     |
| 286603-4    | 39-00-0163     | 286611-4    | 39-00-0120     |
| 286603-5    | 39-00-0059     | 286611-5    | 39-00-0126     |
| 286603-6    | 39-00-0153     | 286611-6    | 39-00-0219     |
| 286603-7    | 39-00-0181     | 286611-8    | 39-00-0411     |
| 286603-8    | 39-00-0213     | 286611-9    | 39-00-0430     |
| 1-286603-0  | 44485-1211     | 1-286611-1  | 39-00-0121     |
| 1-286603-1  | 39-00-0114     | 1-286611-2  | 39-00-0420     |
| 1-286603-2  | 39-00-0428     | 1-286611-3  | 39-00-0437     |
| 1-286603-3  | 39-00-0419     | 1-286611-4  | 39-00-0426     |
| 1-286603-4  | 39-00-0425     | 1-286611-6  | 39-00-0075     |
| 1-286603-5  | 39-00-0436     | 1-286611-7  | 39-00-0427     |
| 1-286603-6  | 39-00-0440     | 1-286611-8  | 40-13-0853     |
| 1-286603-7  | 39-00-0073     | 2-286611-0  | 30490-1002     |
| 1-286603-8  | 39-00-0108     | 2-286611-1  | 30490-2002     |
| 1-286603-9  | 39-00-0169     | 2-286611-2  | 40-01-0853     |
| 2-286603-0  | 39-00-0175     | 2-286611-3  | 98-00-0174     |
| 2-286603-1  | 39-00-0194     | 2-286611-4  | 30490-0002     |
| 2-286603-2  | 39-00-0200     |             |                |
| 2-286603-3  | 39-00-0405     |             |                |
| 2-286603-4  | 39-00-0407     |             |                |
| 2-286603-5  | 39-00-0410     |             |                |
| 2-286603-6  | 40-13-0851     |             |                |
| 2-286603-8  | 44485-1311     |             |                |
| 2-286603-9  | 44485-1411     |             |                |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.80mm2   | 1.02+/-0.05 [.040+/-0.002]    | 5.9                            |
| 18 AWG    | 1.02+/-0.05 [.040+/-0.002]    | 5.9                            |
| 0.50mm2   | 0.995+/-0.045 [.039+/-0.0018] | 6.2                            |
| 20 AWG    | 0.995+/-0.045 [.039+/-0.0018] | 6.2                            |
| 0.35mm2   | 0.895+/-0.045 [.035+/-0.0018] | 7.1                            |
| 22 AWG    | 0.895+/-0.045 [.035+/-0.0018] | 7.1                            |
| 0.20mm2   | 0.83+/-0.04 [.033+/-0.0016]   | 7.7                            |
| 24 AWG    | 0.83+/-0.04 [.033+/-0.0016]   | 7.7                            |

| TERMINAL DATA: MOLEX TERMINAL                |  | CMOLEX CRIMP SPECIFICATION   |  |
|--|--|------------------------------|--|
| TERMINAL NAME: 4.2mm PITCH MINI-FIT TERMINAL |  |                              |  |
| WIRE STRIP LENGTH                            |  | INSULATION DIAMETER RANGE    |  |
| 3.00-3.50 mm [.118-.138 IN]                  |  | Ø2.50-2.95 mm [.098-.116 IN] |  |

| TERMINAL APPLICATION SPECIFICATION |  |
|------------------------------------|--|
| MOLEX 63900-2600 REV J             |  |

TERMINALS APPLIED

| TE TERMINAL | MOLEX TERMINAL | TE TERMINAL | MOLEX TERMINAL |
|-------------|----------------|-------------|----------------|
| 286603-9    | 44476-1111     | 1-2113022-1 | 46083-1211     |
| 2-286603-7  | 44476-1211     | 1-2113022-2 | 46083-1221     |
| 286611-7    | 44478-1111     | 1-2113022-3 | 46134-1111     |
| 1-286611-9  | 44478-1211     | 1-2113022-4 | 46134-1121     |
| 2113022-1   | 45750-1211     | 1-2113022-5 | 46134-1211     |
| 2113022-2   | 45750-1111     | 1-2113022-6 | 46134-1221     |
| 2113022-3   | 46012-1111     |             |                |
| 2113022-4   | 46018-1541     |             |                |
| 2113022-5   | 46083-1111     |             |                |
| 2113022-6   | 46098-1541     |             |                |
| 2113022-7   | 46012-1141     |             |                |
| 2113022-8   | 46012-1211     |             |                |
| 2113022-9   | 46012-1241     |             |                |
| 1-2113022-0 | 46083-1121     |             |                |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.80mm2   | 1.02+/-0.05 [.040+/-0.002]    | 5.9                            |
| 18 AWG    | 1.02+/-0.05 [.040+/-0.002]    | 5.9                            |
| 0.50mm2   | 0.995+/-0.045 [.039+/-0.0018] | 6.2                            |
| 20 AWG    | 0.995+/-0.045 [.039+/-0.0018] | 6.2                            |

**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

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

| LOC | DIST | REVISIONS |     |               |           |     |      |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A   | 66   | P         | LTN | DESCRIPTION   | DATE      | DWN | APVD |
|     |      | A1        |     | ECR-15-018756 | 30DEC2015 | JH  | CT   |
|     |      | B         |     | ECR-18-006525 | 03MAY2018 | YY  | JDG  |
|     |      | C         |     | ECR-19-010789 | 10JUL2019 | FJ  | TE   |
|     |      | D         |     | ECR-23-162722 | 04JAN2023 | JWC | TE   |

|   |     |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1803945-4   | TONKER                              | 300 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1-22278-9   | SPRING, COMPRESSION                 | 299 |
| - | 2   | 2   | 2   | 2   | 2   | 2   | 4-18032-3   | SCR, SET, FLT PNT, M3 X 6.0         | 298 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1803944-1   | SPACER, TONKER                      | 297 |
| - | -   | -   | -   | -   | -   | -   | 2-1803583-1 | APPLICATOR BASIC ASSEMBLY, SF       | 292 |
| - | 1   | -   | 1   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 18023-1     | SCR, SKT HD CAP M3 X 5.0            | 241 |
| - | -   | -   | -   | -   | -   | -   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239 |
| - | 1   | -   | 1   | -   | 1   | -   | 2844940-1   | AIR FEED MODULE                     | 238 |
| - | REF | REF | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 455888-9    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119740-1   | TAG IDENTIFICATION                  | 67  |
| - | 2   | 2   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 60  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 4   | 4   | 4   | 4   | 4   | 4   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 54  |
| - | 2   | 2   | 2   | 2   | 2   | 2   | 2-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 14      | 53  |
| - | 1   | 2   | 1   | 2   | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | -   | -   | -   | -   | -   | -   | 2119652-1   | FEED CAM, PRE FEED                  | 48  |
| - | -   | -   | -   | -   | -   | -   | 2119653-1   | FEED CAM, POST FEED                 | 47  |
| - | 1   | 1   | -   | -   | -   | -   | 1803583-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1803515-1   | RAM ASSEMBLY, SF ATLANTIC           | 44  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 6-1752356-2 | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 2   | 2   | 2   | 2   | 2   | 2   | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2844992-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | -   | -   | -   | -   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 2   | 2   | 1   | 1   | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | -   | -   | -   | -   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1-356885-3  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1803095-5   | FLOATING SHEAR, FRONT               | 9   |
| 1 | 2   | 2   | 1   | 1   | 1   | 1   | 3-1633129-3 | ANVIL, COMBINATION .062             | 8   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 240641-5    | SPACER                              | 7   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1-238011-7  | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 2   | 2   | 1   | 1   | 1   | 1   | 1-2119582-8 | CRIMPER, INSULATION F PREMIUM       | 3   |
| 1 | 2   | 2   | 1   | 1   | 1   | 1   | 4-456403-2  | CRIMPER, WIRE PREMIUM               | 1   |

| ITEM NO | PART NO | DESCRIPTION | ITEM NO |
|---------|---------|-------------|---------|
| -77     | -72     | -71         | -52     |
| -51     | -2      | -1          |         |

|      |           |           |
|------|-----------|-----------|
| CHK  | STAKEM    | 11OCT2011 |
| CHK  | G. BAILEY | 11OCT2011 |
| APVD | T. ELBIN  | 11OCT2011 |

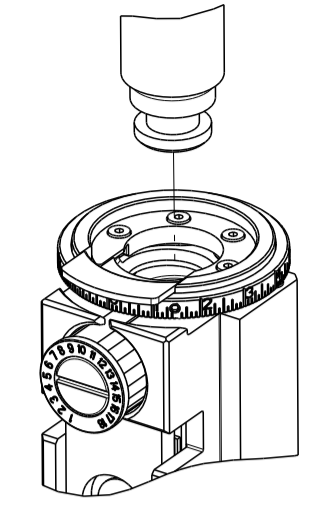
|             |  |
|-------------|--|
| DIMENSIONS: | TOLERANCES UNLESS OTHERWISE SPECIFIED: |
| mm          | 0 PLC ±                                |
|             | 1 PLC ±                                |
|             | 2 PLC ±                                |
|             | 3 PLC ±                                |
|             | 4 PLC ±                                |
|             | ANGLES ±                               |
|             | FINISH ±                               |

|  |                              |
|--|------------------------------|
| NAME                                   | Ocean Side Feed Applicator   |
| SIZE                                   | A1                           |
| CAGE CODE                              | 00779                        |
| DRAWING NO                             | 2151015                      |
| RESTRICTED TO                          |                              |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING | SCALE 1:2 SHEET 1 OF 4 REV D |



| PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE  |
|-------------|----------|--------------------------|------------|
| 2-2151015-1 | D        | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151015-2 | D        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC  |
| 7-2151015-7 | A        | CRIMP TOOLING KIT        | -          |

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.58 mm [.062] | F    |
| INSUL           | 3.18 mm [.125] | F    |

APPLICATOR INSTRUCTIONS  
408-35042

| TERMINAL DATA: MOLEX TERMINAL                             |  | MOLEX CRIMP SPECIFICATION     |  |
|---|--|-------------------------------|--|
| TERMINAL NAME: 4.2mm PITCH MINI-FIT TERMINAL              |  |                               |  |
| WIRE STRIP LENGTH   |  | INSULATION DIAMETER RANGE     |  |
| 3.00-3.50 mm [.118-.138 IN]                               |  | Ø 2.50-2.95 mm [.098-.116 IN] |  |
| TERMINAL APPLICATION SPECIFICATION MOLEX 63900-2600 REV J |  |                               |  |

| TERMINALS APPLIED |                |             |                |
|-------------------|----------------|-------------|----------------|
| TE TERMINAL       | MOLEX TERMINAL | TE TERMINAL | MOLEX TERMINAL |
| 286603-1          | 39-00-0038     | 286611-1    | 39-00-0040     |
| 286603-2          | 39-00-0055     | 286611-2    | 39-00-0061     |
| 286603-3          | 39-00-0207     | 286611-3    | 39-00-0053     |
| 286603-4          | 39-00-0163     | 286611-4    | 39-00-0120     |
| 286603-5          | 39-00-0059     | 286611-5    | 39-00-0126     |
| 286603-6          | 39-00-0153     | 286611-6    | 39-00-0219     |
| 286603-7          | 39-00-0181     | 286611-8    | 39-00-0411     |
| 286603-8          | 39-00-0213     | 286611-9    | 39-00-0430     |
| 1-286603-0        | 44485-1211     | 1-286611-1  | 39-00-0121     |
| 1-286603-1        | 39-00-0114     | 1-286611-2  | 39-00-0420     |
| 1-286603-2        | 39-00-0428     | 1-286611-3  | 39-00-0437     |
| 1-286603-3        | 39-00-0419     | 1-286611-4  | 39-00-0426     |
| 1-286603-4        | 39-00-0425     | 1-286611-6  | 39-00-0075     |
| 1-286603-5        | 39-00-0436     | 1-286611-7  | 39-00-0427     |
| 1-286603-6        | 39-00-0440     | 1-286611-8  | 40-13-0853     |
| 1-286603-7        | 39-00-0073     | 2-286611-0  | 30490-1002     |
| 1-286603-8        | 39-00-0108     | 2-286611-1  | 30490-2002     |
| 1-286603-9        | 39-00-0169     | 2-286611-2  | 40-01-0853     |
| 2-286603-0        | 39-00-0175     | 2-286611-3  | 98-00-0174     |
| 2-286603-1        | 39-00-0194     | 2-286611-4  | 30490-0002     |
| 2-286603-2        | 39-00-0200     |             |                |
| 2-286603-3        | 39-00-0405     |             |                |
| 2-286603-4        | 39-00-0407     |             |                |
| 2-286603-5        | 39-00-0410     |             |                |
| 2-286603-6        | 40-13-0851     |             |                |
| 2-286603-8        | 44485-1311     |             |                |
| 2-286603-9        | 44485-1411     |             |                |

| TERMINAL DATA: MOLEX TERMINAL                             |  | CMOLEX CRIMP SPECIFICATION    |  |
|---|--|-------------------------------|--|
| TERMINAL NAME: 4.2mm PITCH MINI-FIT TERMINAL              |  |                               |  |
| WIRE STRIP LENGTH   |  | INSULATION DIAMETER RANGE     |  |
| 3.00-3.50 mm [.118-.138 IN]                               |  | Ø 2.50-2.95 mm [.098-.116 IN] |  |
| TERMINAL APPLICATION SPECIFICATION MOLEX 63900-2600 REV J |  |                               |  |

| TERMINALS APPLIED |                |             |                |
|-------------------|----------------|-------------|----------------|
| TE TERMINAL       | MOLEX TERMINAL | TE TERMINAL | MOLEX TERMINAL |
| 286603-9          | 44476-1111     | 1-2113022-1 | 46083-1211     |
| 2-286603-7        | 44476-1211     | 1-2113022-2 | 46083-1221     |
| 286611-7          | 44478-1111     | 1-2113022-3 | 46134-1111     |
| 1-286611-9        | 44478-1211     | 1-2113022-4 | 46134-1121     |
| 2113022-1         | 45750-1211     | 1-2113022-5 | 46134-1211     |
| 2113022-2         | 45750-1111     | 1-2113022-6 | 46134-1221     |
| 2113022-3         | 46012-1111     |             |                |
| 2113022-4         | 46018-1541     |             |                |
| 2113022-5         | 46083-1111     |             |                |
| 2113022-6         | 46098-1541     |             |                |
| 2113022-7         | 46012-1141     |             |                |
| 2113022-8         | 46012-1211     |             |                |
| 2113022-9         | 46012-1241     |             |                |
| 1-2113022-0       | 46083-1121     |             |                |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.80mm2   | 1.02+/-0.05 [.040+/- .002]    | 5.9                            |
| 18 AWG    | 1.02+/-0.05 [.040+/- .002]    | 5.9                            |
| 0.50mm2   | 0.995+/-0.045 [.039+/- .0018] | 6.2                            |
| 20 AWG    | 0.995+/-0.045 [.039+/- .0018] | 6.2                            |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.80mm2   | 1.02+/-0.05 [.040+/- .002]    | 5.9                            |
| 18 AWG    | 1.02+/-0.05 [.040+/- .002]    | 5.9                            |
| 0.50mm2   | 0.995+/-0.045 [.039+/- .0018] | 6.2                            |
| 20 AWG    | 0.995+/-0.045 [.039+/- .0018] | 6.2                            |
| 0.35mm2   | 0.895+/-0.045 [.035+/- .0018] | 7.1                            |
| 22 AWG    | 0.895+/-0.045 [.035+/- .0018] | 7.1                            |
| 0.20mm2   | 0.83+/-0.04 [.033+/- .0016]   | 7.7                            |
| 24 AWG    | 0.83+/-0.04 [.033+/- .0016]   | 7.7                            |

**\*WARNING**  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

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

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

|   |     |     |             |                                     |     |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | 1   | 1803945-4   | TONKER                              | 300 |
| - | 1   | 1   | 1-22278-9   | SPRING, COMPRESSION                 | 299 |
| - | 2   | 2   | 4-18032-3   | SCR, SET, FLT PNT, M3 X 6.0         | 298 |
| - | 1   | 1   | 1803944-1   | SPACER, TONKER                      | 297 |
| - | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 1   | 18023-1     | SCR, SKT HD CAP M3 X 5.0            | 241 |
| - | -   | 1   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239 |
| - | 1   | -   | 2844940-1   | AIR FEED MODULE                     | 238 |
| - | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | 1   | -   | 2119641-2   | FEED CAM, AIR FEED                  | 151 |
| - | 1   | 1   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 144 |
| - | 4   | 4   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 143 |
| - | -   | 1   | 2119653-2   | FEED CAM, POST FEED                 | 142 |
| - | 1   | 1   | 1-1803583-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141 |
| - | 1   | 1   | 1803516-1   | RAM ASSEMBLY, SF PACIFIC            | 140 |
| - | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113 |
| - | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99  |
| - | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98  |
| - | 1   | 1   | 455888-9    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
| - | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69  |
| - | 1   | 1   | 2119740-1   | TAG IDENTIFICATION                  | 67  |
| - | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 2   | 2   | 2-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 14      | 53  |
| - | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48  |
| - | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | 1   | 6-1752356-2 | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 2   | 2   | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30  |
| - | 1   | 1   | 2844992-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1-356885-3  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1803095-5   | FLOATING SHEAR, FRONT               | 9   |
| 1 | 1   | 1   | 3-1633129-3 | ANVIL, COMBINATION .062             | 8   |
| - | 1   | 1   | 240641-5    | SPACER                              | 7   |
| - | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1-238011-7  | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 1   | 1   | 1-2119582-8 | CRIMPER, INSULATION F PREMIUM       | 3   |
| 1 | 1   | 1   | 4-456403-2  | CRIMPER, WIRE PREMIUM               | 1   |

| DIMENSIONS: |          | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | MATERIAL: |         |
|-------------|----------|--|---------|-----------|---------|
| mm          | 0 PLC ±  | 1 PLC ±                                | 2 PLC ± | 3 PLC ±   | 4 PLC ± |
|             | ANGLES ± | FINISH                                 |         |           |         |

| ITEM NO | PART NO | DESCRIPTION | ITEM NO |
|---------|---------|-------------|---------|
| -77     | -22     | -21         |         |

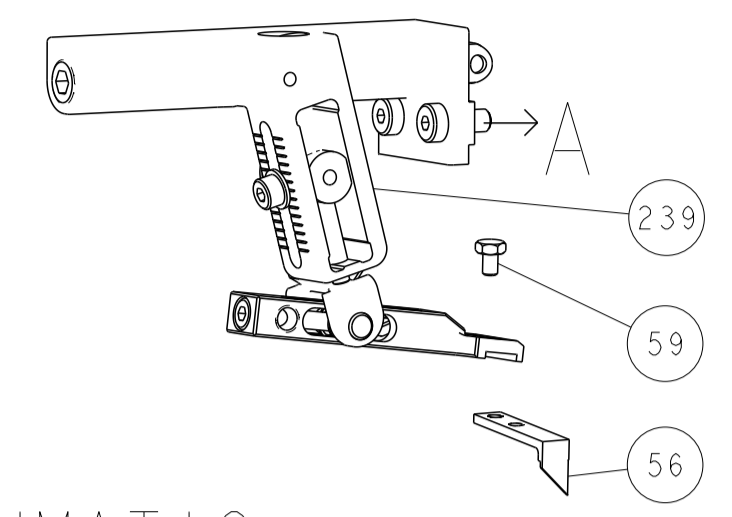
| CHK       | DATE      | APVD | NAME |
|-----------|-----------|------|------|
| STAKEM    | 11OCT2011 |      |      |
| G. BAILEY | 11OCT2011 |      |      |
| ELBLN     | 11OCT2011 |      |      |

| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|------|-----------|------------|---------------|
| A1   | 00779     | 2151015    | D             |

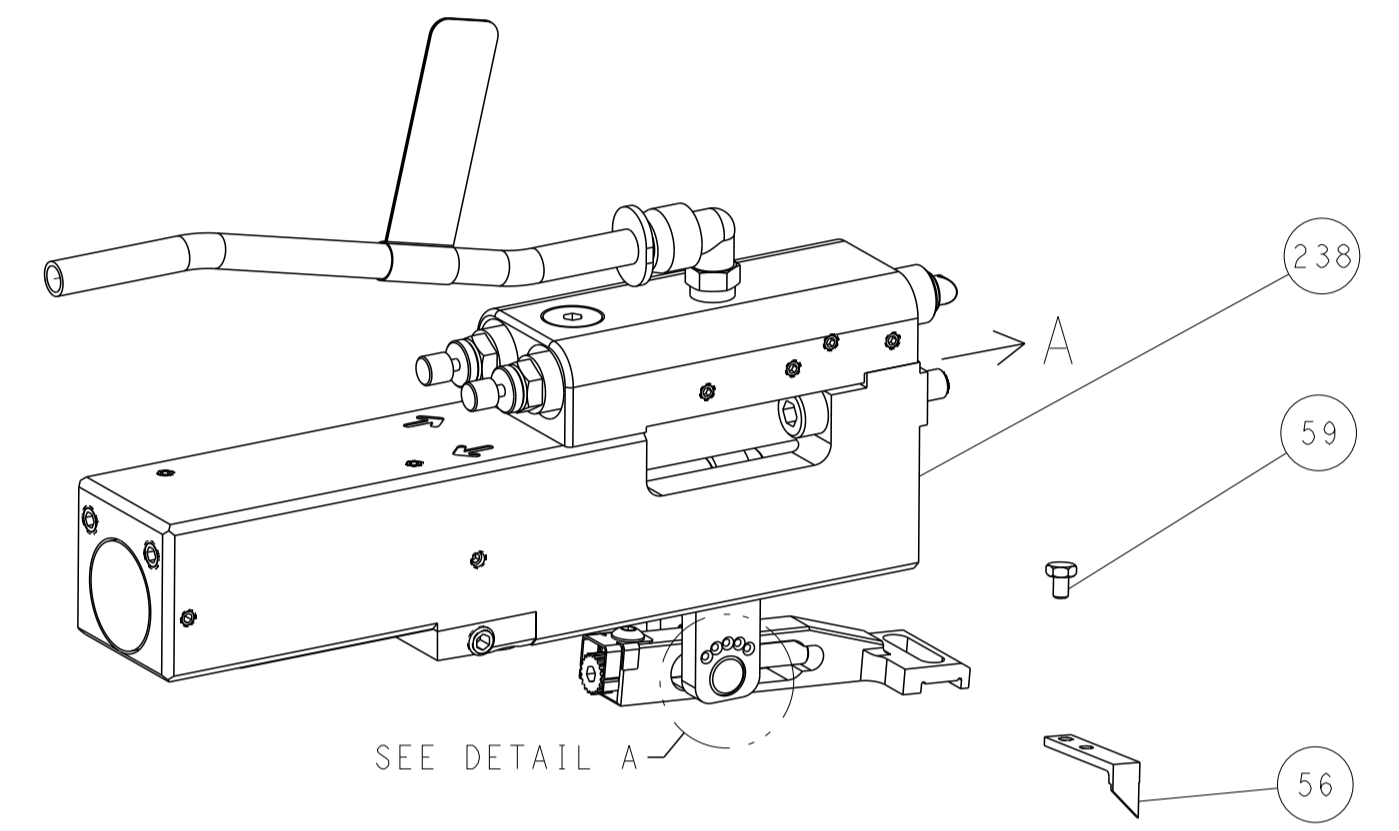
CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:2 SHEET 3 OF 4 REV D

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

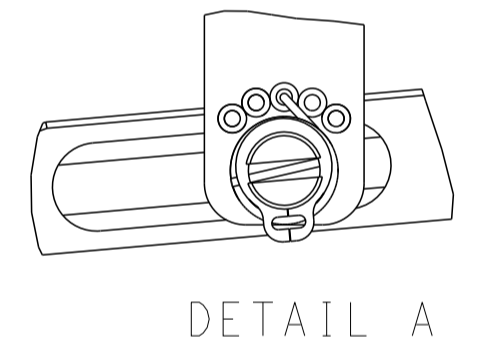
# FEED TYPE MECHANICAL



## PNEUMATIC

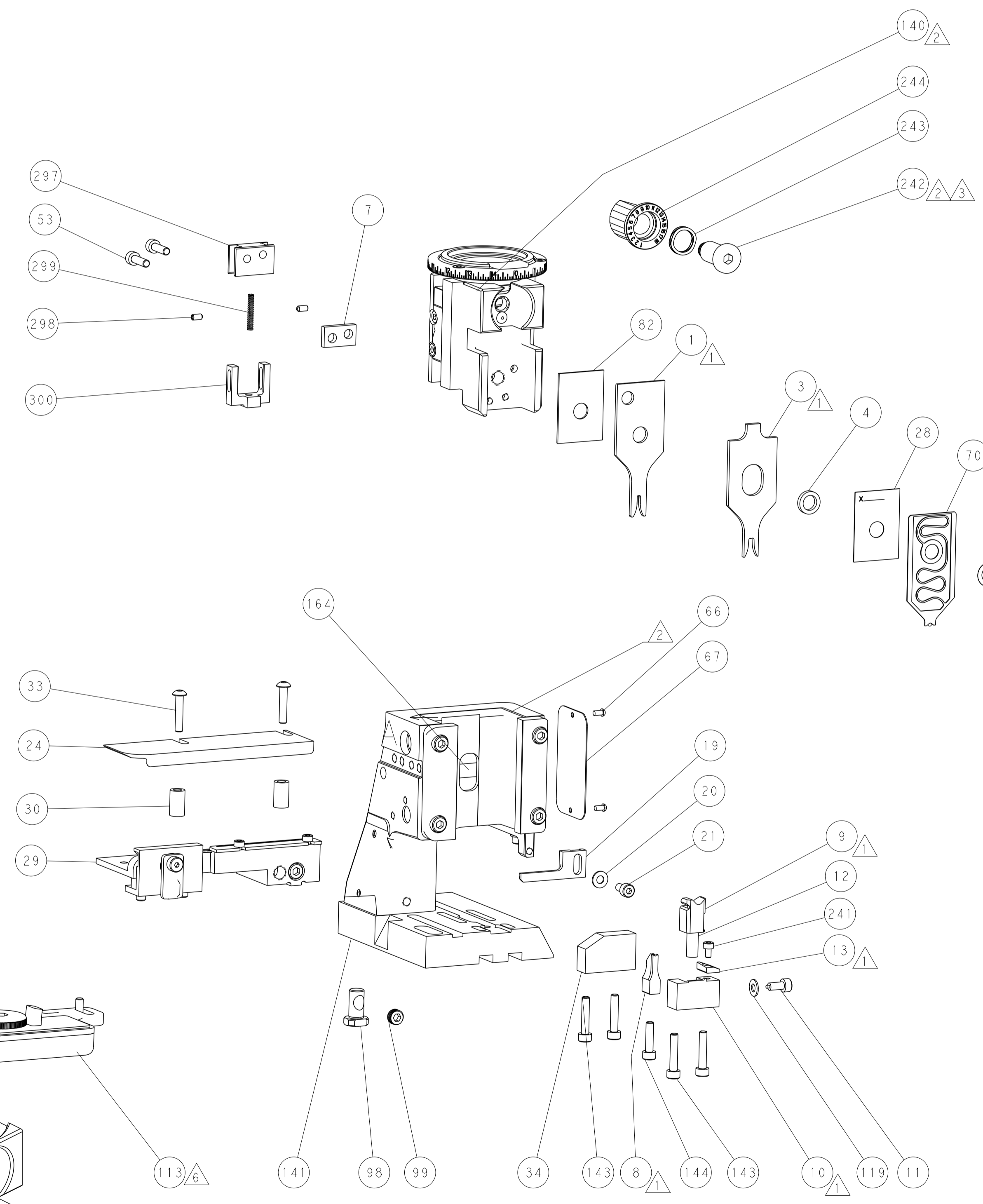
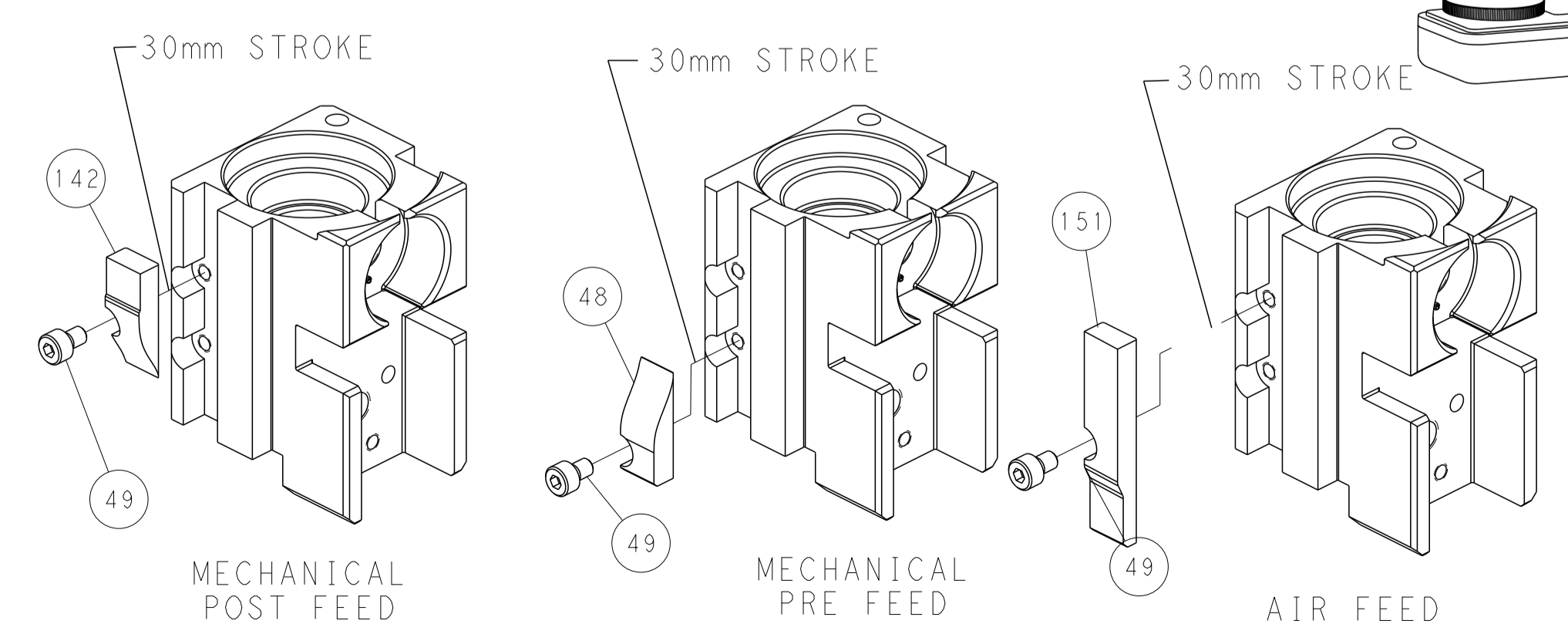


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

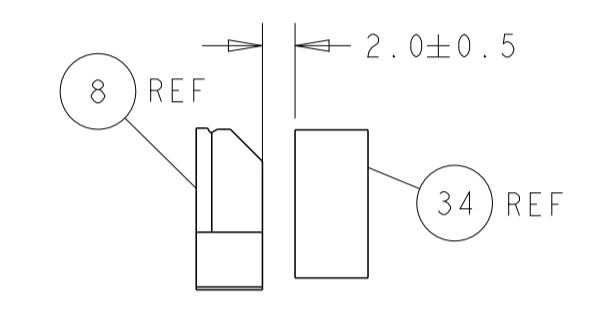


DETAIL A

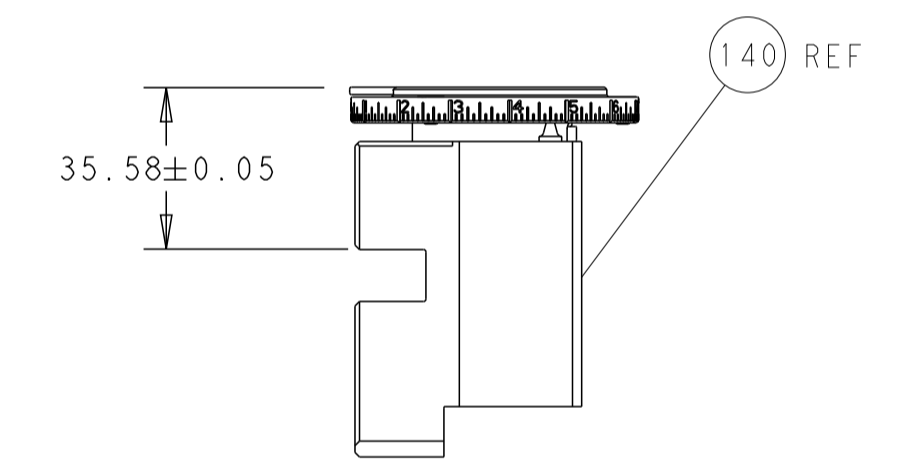
## CAM POSITIONS



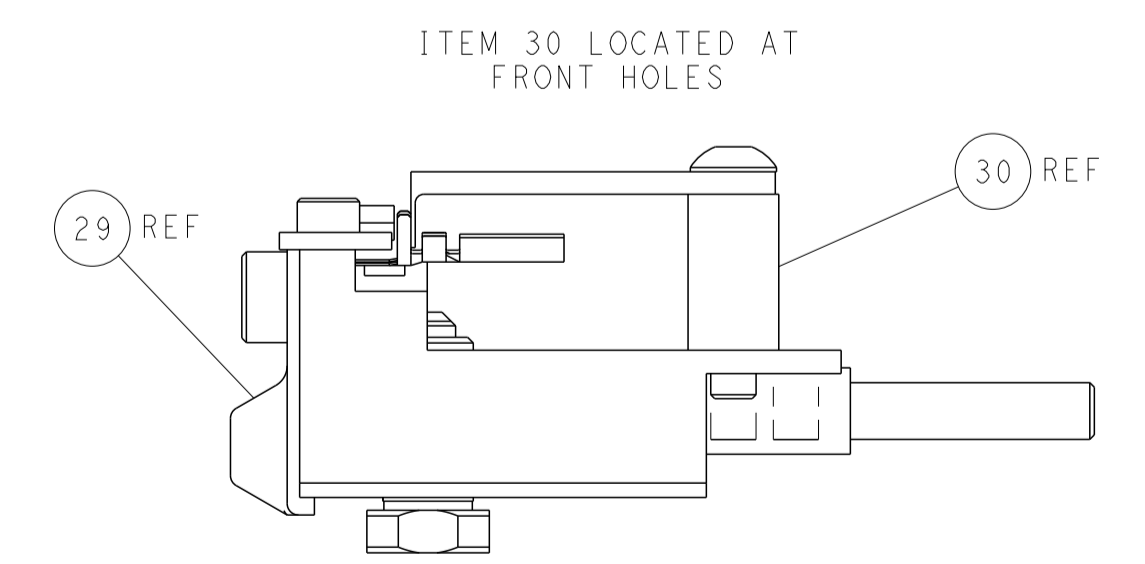
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

|             |         |  |         |  |         |  |  |
|-------------|---------|--|---------|--|---------|--|--|
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DWG: STAKEM 11OCT2011                  |         | TE Connectivity                              |  |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                                | 4 PLC ± | Harrisburg, PA 17105-3608                    |  |
| MATERIAL:   |         | FINISH:                                |         | CHK: G. BAILEY 11OCT2011               |         | NAME: Ocean Side Feed Applicator             |  |
|             |         |  |         | APVD: T. ELBIN 11OCT2011               |         | SIZE: CAGE CODE: DRAWING NO: 00779 ©=2151015 |  |
|             |         |  |         | WEIGHT:                                |         | RESTRICTED TO:                               |  |
|             |         |  |         | CUSTOMER ACCESSIBLE PRODUCTION DRAWING |         | SCALE: 1:2 SHEET 4 OF 4 REV D                |  |