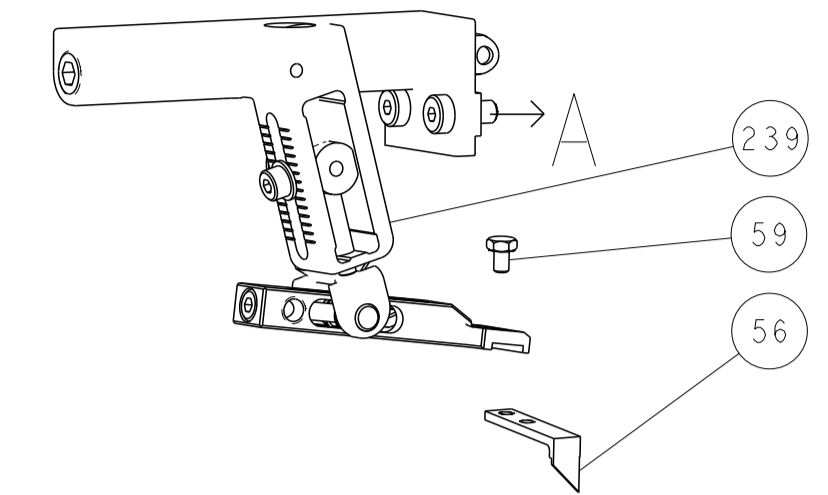
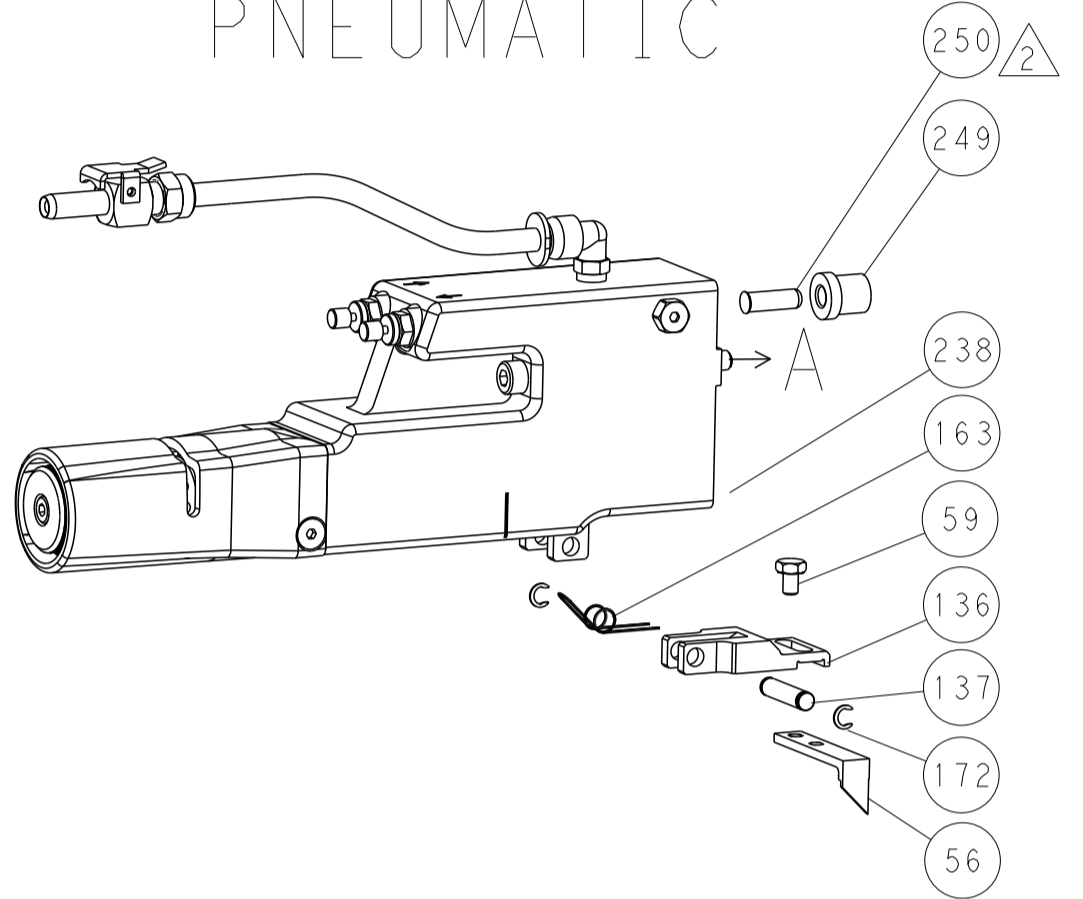


LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

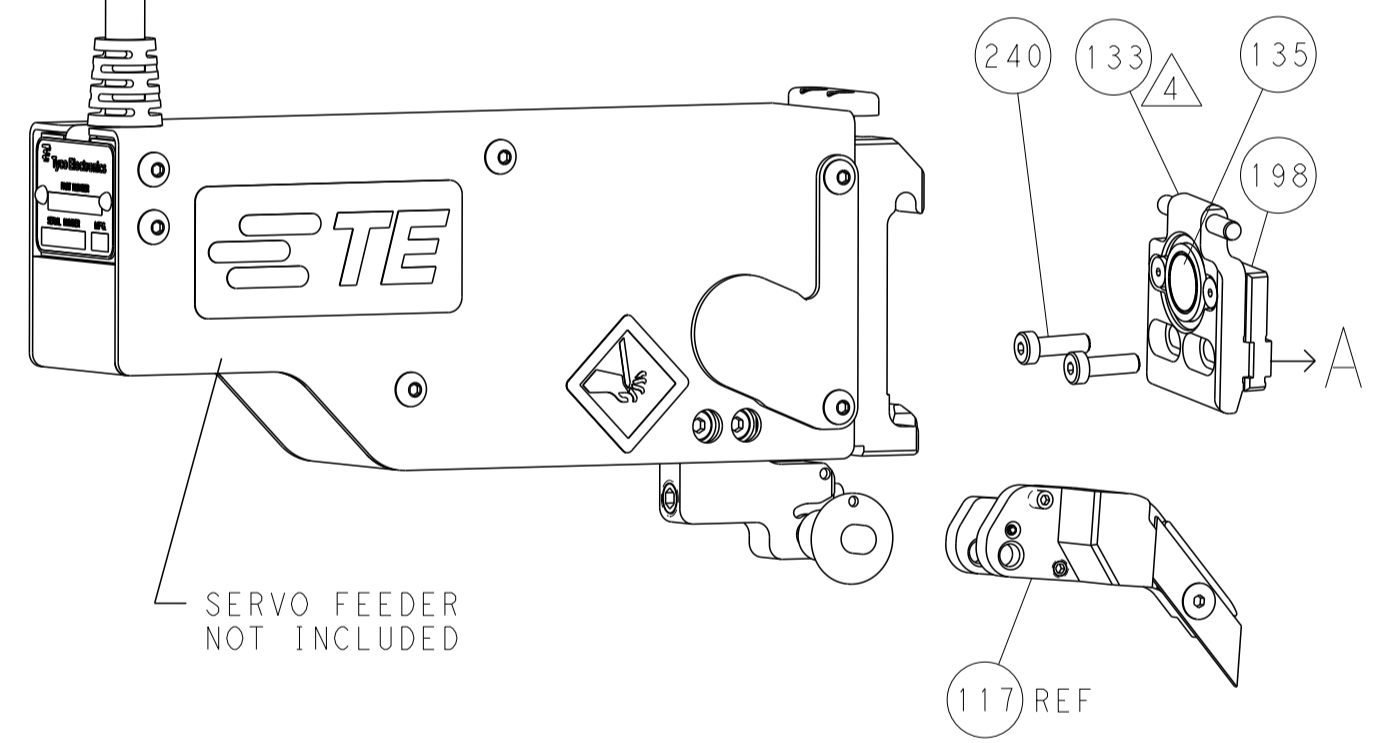
FEED TYPE MECHANICAL



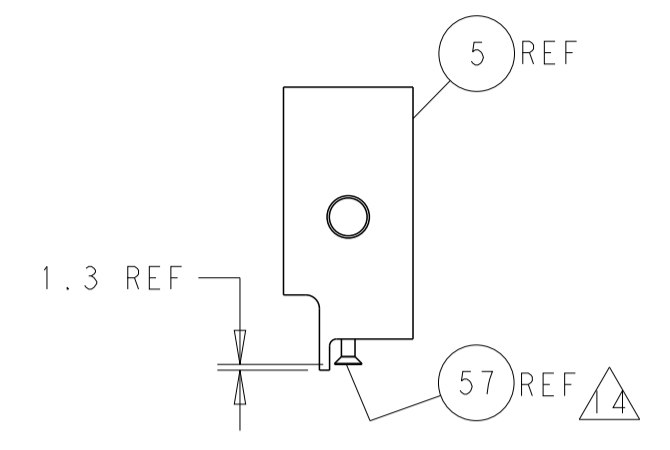
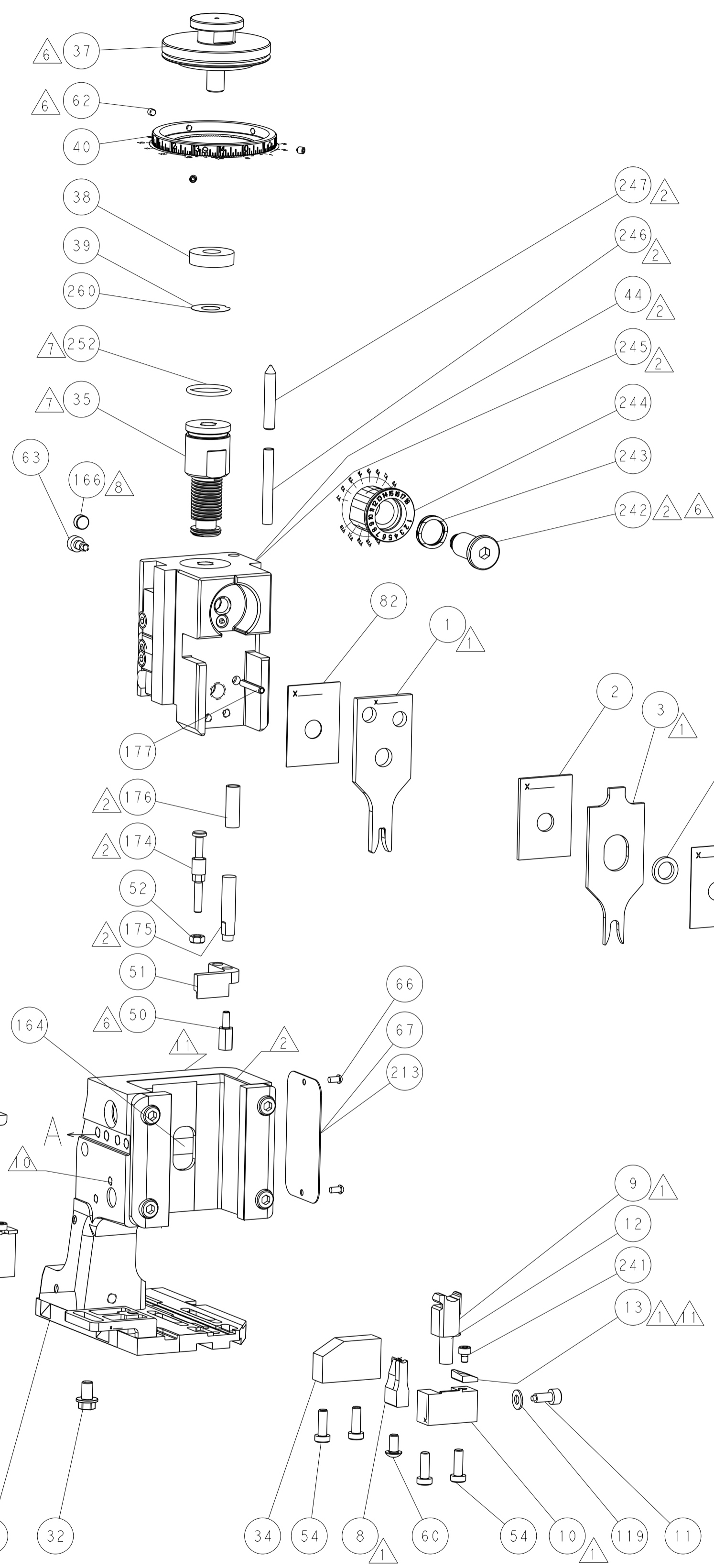
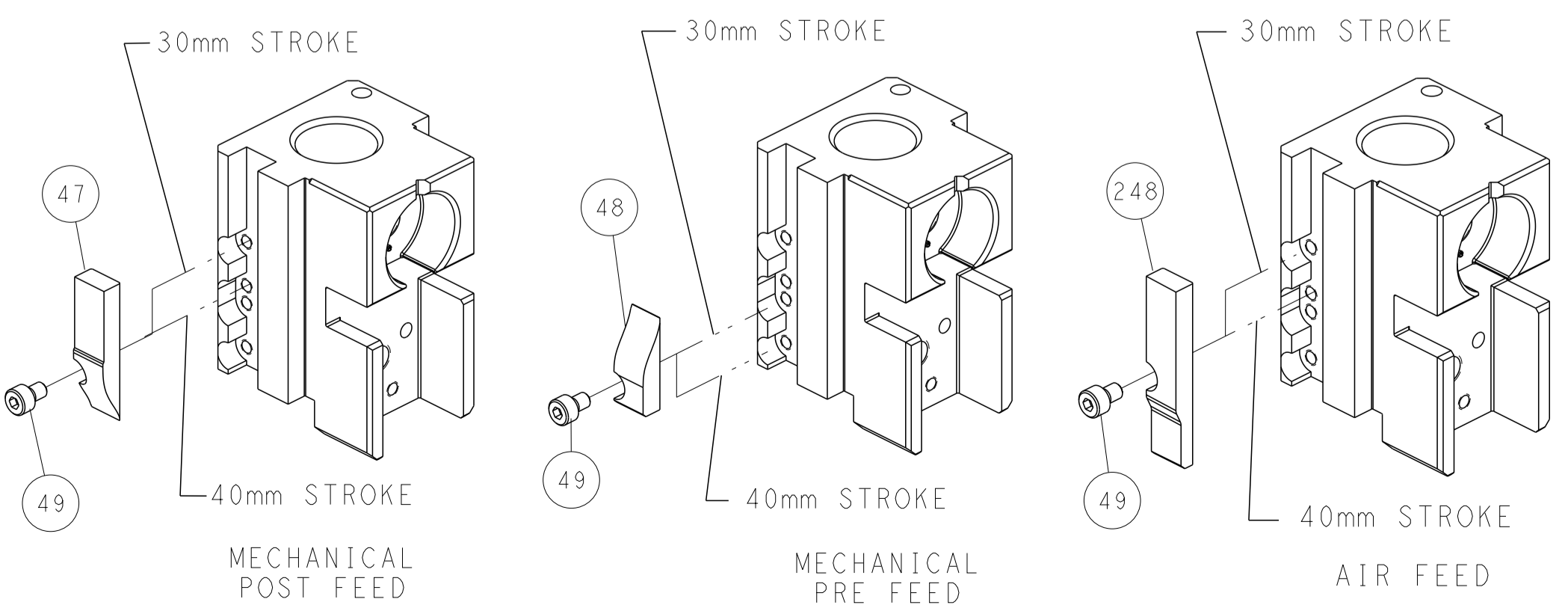
PNEUMATIC



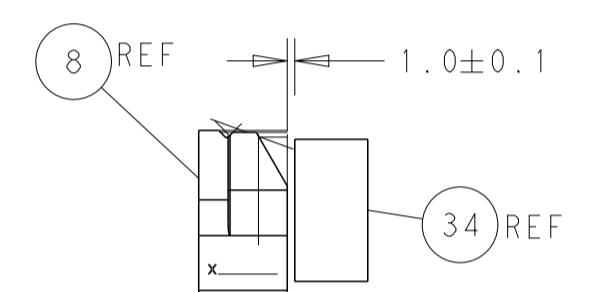
SERVO LATCH PLATE



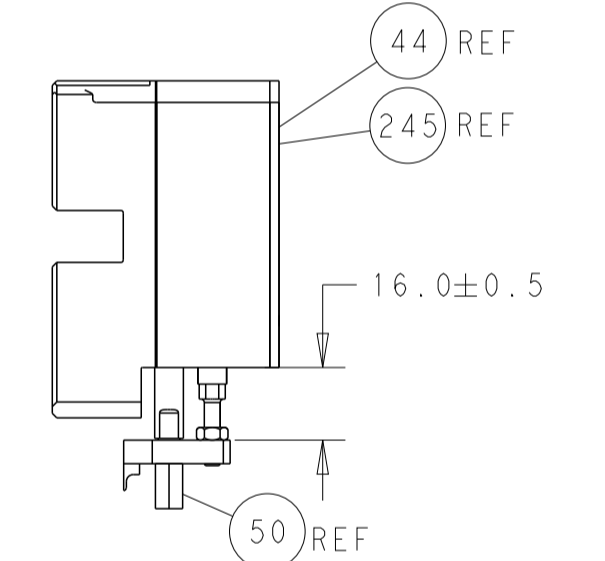
CAM POSITIONS



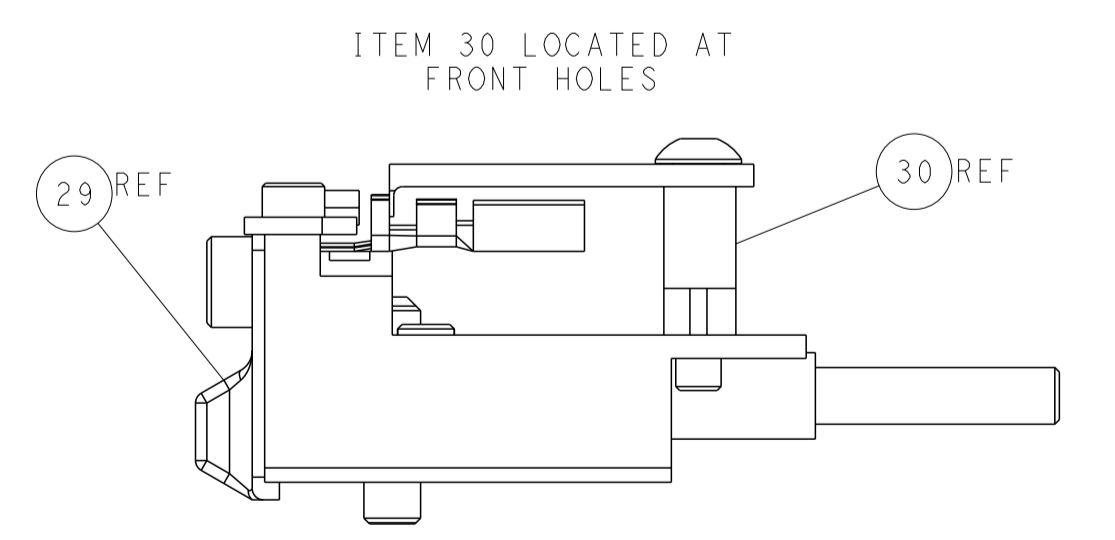
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN Y. YIN 09OCT2013 CHK G. BAILEY 09OCT2013 APVD H. GUO 09OCT2013 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME SIZE CAGE CODE DRAWING NO RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 2 OF 4		REV B1	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
	2-2266069-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	OBSOLETE
	2-2266069-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	OBSOLETE
	2-2266069-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	OBSOLETE
	2-2266069-7	B	FINE CRIMP HEIGHT ADJUST	NONE	OBSOLETE
	7-2266069-7	A	CRIMP TOOLING KIT	-	-

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

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.10]	F
INSUL	4.32 mm [1.70]	0

APPLICATOR INSTRUCTIONS 408-10389

REV	DATE	BY	APPROV	DESCRIPTION	ITEM NO	
-	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	2119082-7 CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	2119083-1 RETAINER, INSULATION DIAL	242	
-	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	
-	1	1	1	993111-1 PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	1	1	5-22280-0 SPRING, COMPRESSION	176	
-	1	1	1	1752353-3 GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1901680-2 GUIDE PIN, HOLDDOWN	174	
-	-	-	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	
-	-	-	-	2119653-2 FEED CAM, POST FEED	142	
-	1	1	1	2-2119656-2 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	
-	1	1	1	1-18028-2 WASHER, FLAT, REG M4	119	
-	-	REF	-	2119944-1 FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	455888-5 SPACER, CRIMPER	82	
-	1	1	1	2119956-1 DOCUMENTATION PACKAGE	71	
-	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 PNT, M3 X 4.0	62	
-	-	-	1	5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	985575-3 SCR, FLT SKT HD CAP M3 X 10.0	57	
-	-	-	1	1338685-1 PAWL, FEED	56	
-	1	1	1	1-5018030-0 NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1	4-1722335-3 STRIPPER, SIDE FEED	51	
-	1	1	1	2-1752354-4 STANDOFF, HOLD-DOWN	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	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	1-2119644-2 RAM WASHER, PRECISION	38	
-	1	1	1	1-1752356-8 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	1320908-8 SPACER, STRIP GUIDE	30	
-	1	1	1	2119959-1 ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	455888-3 SPACER, CRIMPER	28	
-	1	1	1	1320928-1 STRIP GUIDE	24	
-	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	1-1333207-0 ANVIL, COMBINATION .110	8	
-	1	1	1	2119781-1 DEPRESSOR, SHEAR	5	
-	1	1	1	5-238011-5 BLOCK, CRIMPER SPACER	4	
-	1	1	1	1-1633965-4 CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1-455888-6 SPACER, CRIMPER	2	
-	1	1	1	2-456408-0 CRIMPER, WIRE PREMIUM	1	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.90-5.50 mm [1.93-.217 IN]		Ø2.20-3.00 mm [1.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18050	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE SEAL
927766-1	2-927766-1	929937-7	828905-1
927766-3	929937-1	1-929937-1	
927766-8	929937-3	2-929937-1	
1-927766-1	929937-6		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
2.50mm2	1.77 +/- 0.05 [1.070 +/- .002]	5.1
2.00mm2	1.64 +/- 0.05 [1.065 +/- .002]	6.4
1.50mm2	1.51 +/- 0.05 [1.059 +/- .002]	7.8

- 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: 8-2266069-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266069-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266069-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266069-6
- 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 ITEMS 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- 8 MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION DIAMETER OF SEAL IS Ø2.2-3.0mm.
- 13 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 4 THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

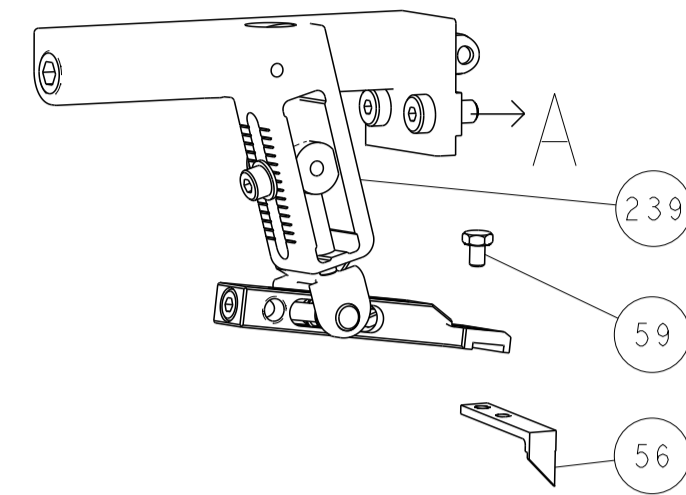
***WARNING**
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

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

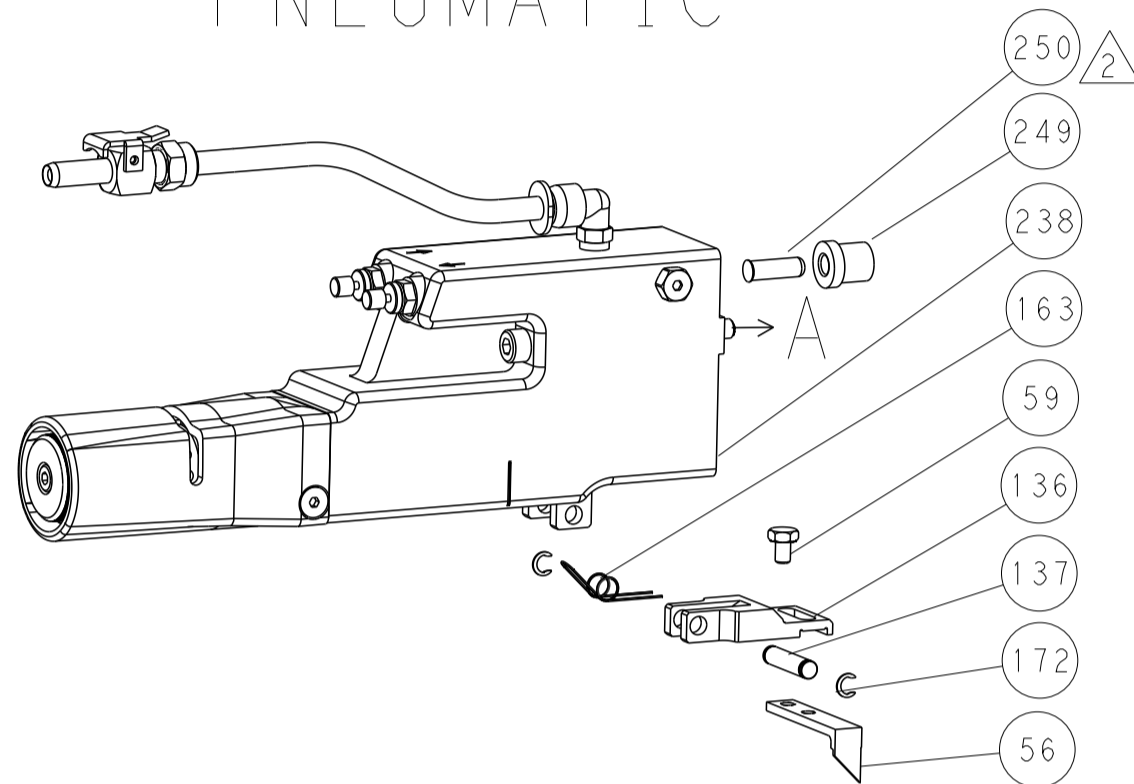
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN		DATE
mm	0 PLC ±	±	Y. YIN	09OCT2013	
	1 PLC ±	±	G. BAILEY	09OCT2013	
	3 PLC ±	±			
	4 PLC ±	±			
	ANGLES	±			
	FINISH	±			
MATERIAL			APPRV		
			J. GUO	09OCT2013	
			PRODUCT SPEC		
			APPLICATION SPEC		
			WEIGHT		
			SCALE	1:2	
			SHEET	3 of 4	
			REV	BI	

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

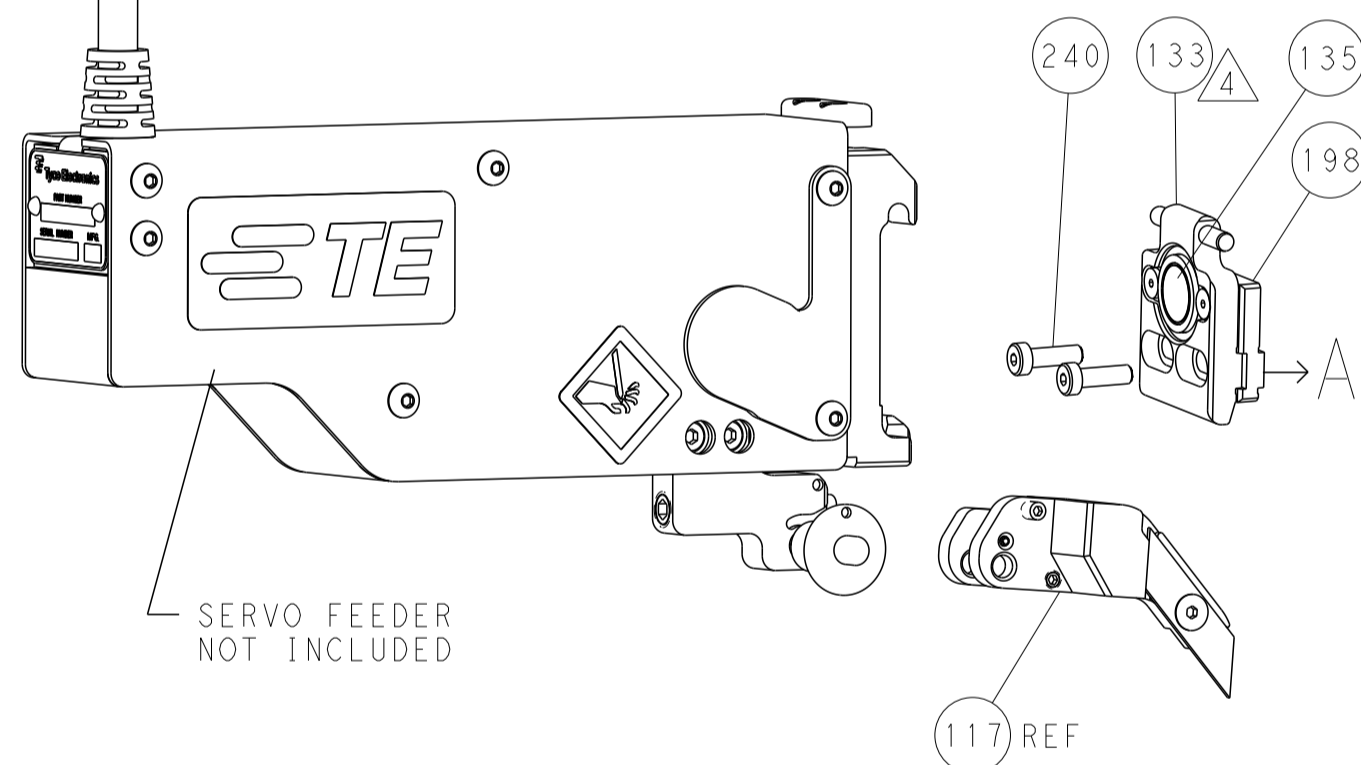
FEED TYPE MECHANICAL



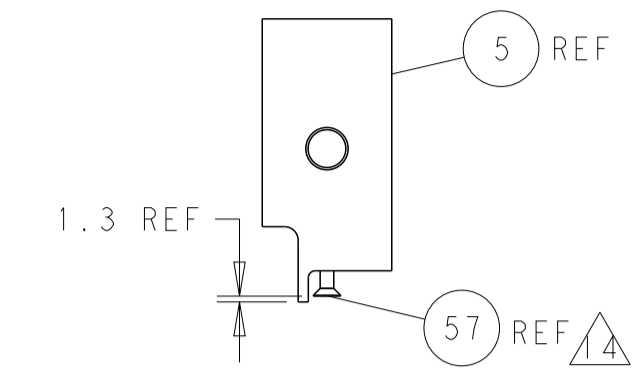
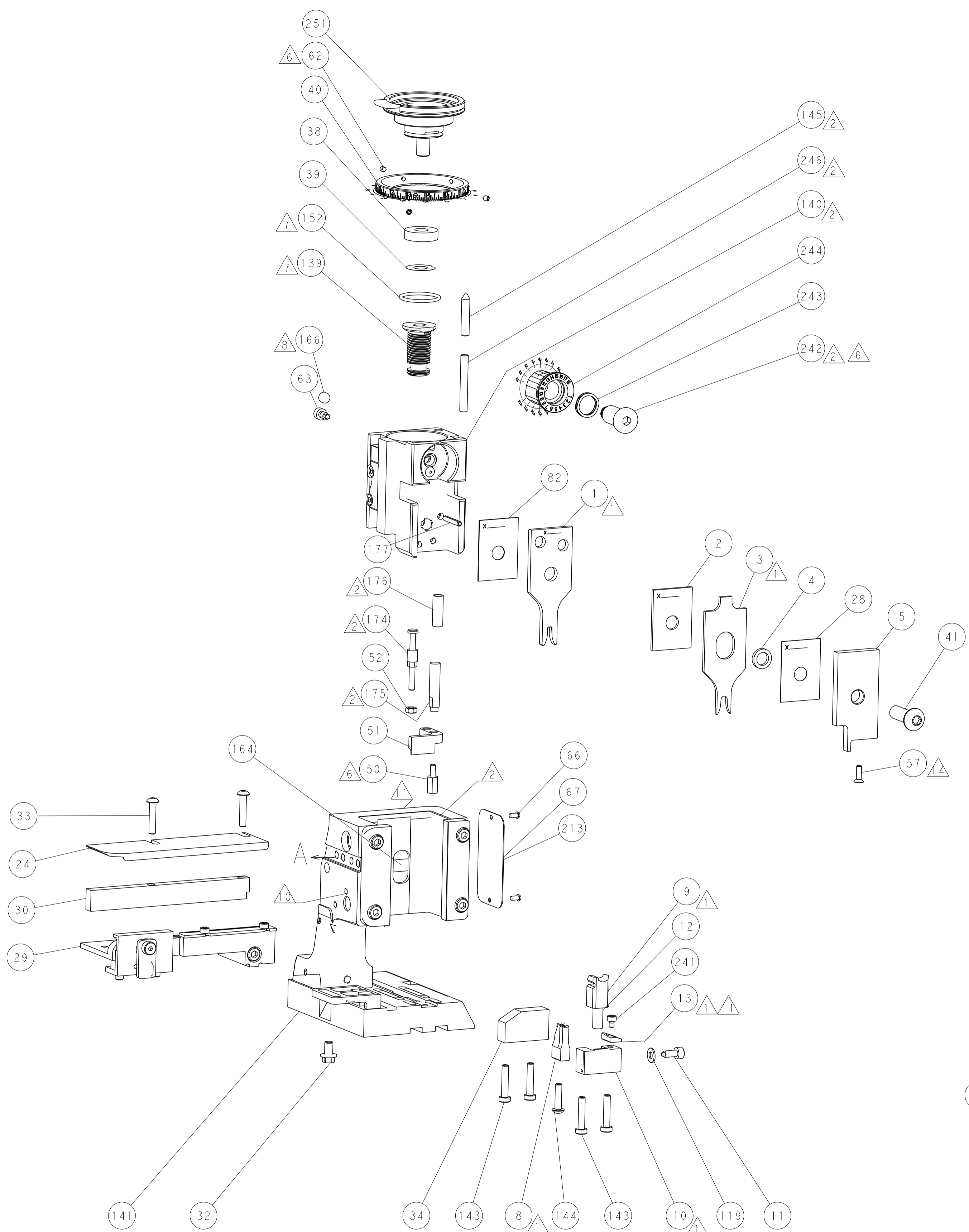
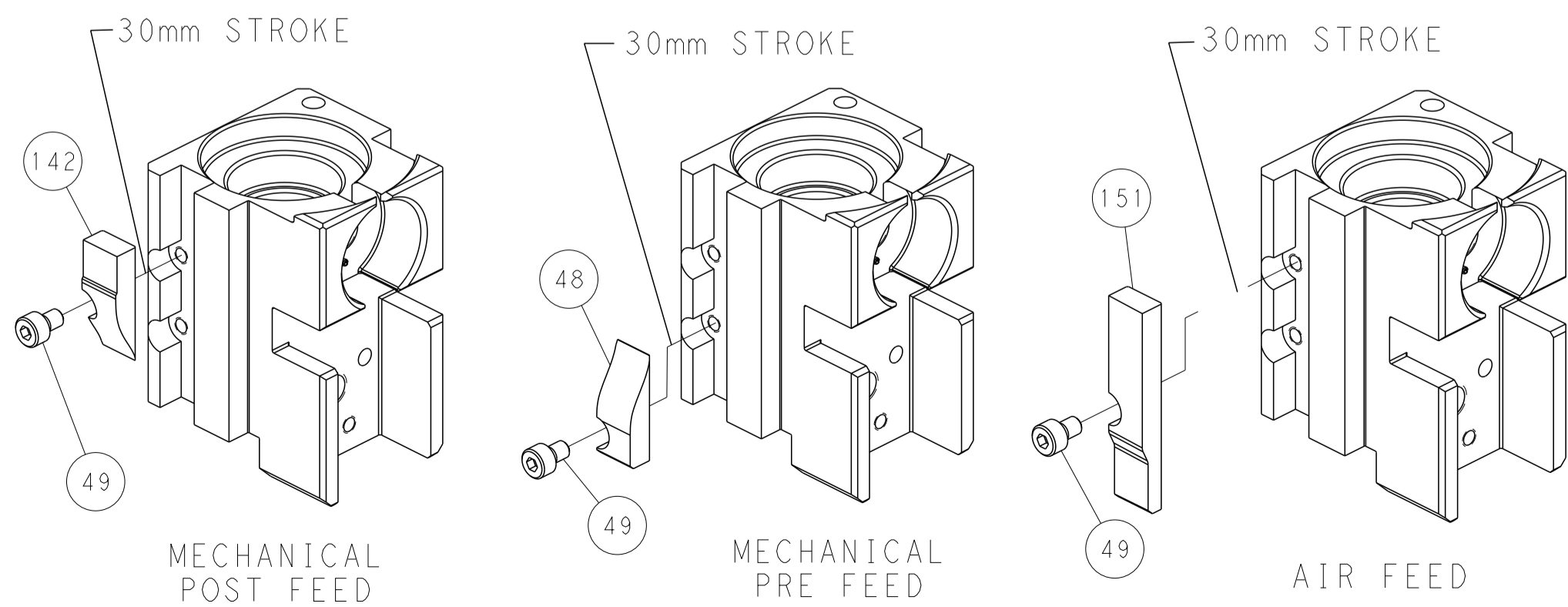
PNEUMATIC



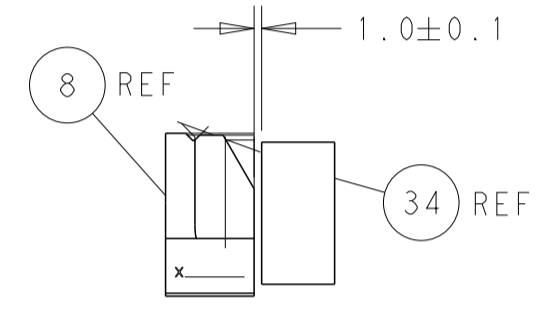
SERVO LATCH PLATE



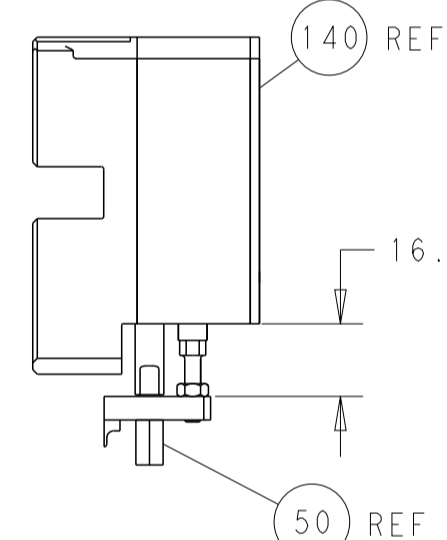
CAM POSITIONS



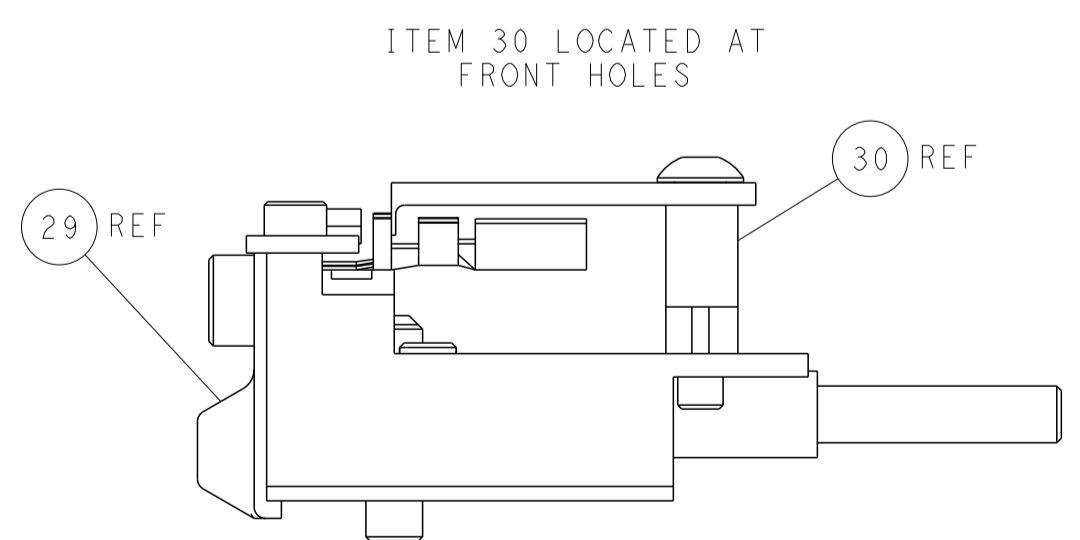
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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: Y. YIN 09OCT2013		REV: G. BAILEY 09OCT2013		NAME: Ocean Side Feed Applicator	
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	Customer Accessible Production Drawing	
	1 PLC	±		SCALE	1:2	SHEET 4 OF 4	REV: B1		
	2 PLC	±		Customer Accessible Production Drawing					
	3 PLC	±		SCALE 1:2 SHEET 4 OF 4 REV B1					
	4 PLC	±		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION					
	ANGLES	±							
	FINISH	±							