

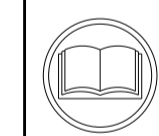
| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2266134-1 | 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 | - | 8-2266134-5 | 1901094-3 | 2-1752354-2 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266134-4 | - | - | - |
| | 2266134-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266134-5 | 1901094-3 | 2-1752354-2 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266134-4 | - | - | - |
| | 2266134-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 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 | |
| 2266134-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | - | |
| 2266134-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2266134-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.62 mm [.103] | F |
| INSUL | 4.32 mm [.170] | F |

APPLICATOR INSTRUCTIONS
408-10389

| TERMINAL DATA: LEAR TERMINAL | | LEAR CRIMP SPECIFICATION | |
|------------------------------------|---------------|---------------------------|---------------|
| TERMINAL NAME: DFK 2 RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.02-5.08 mm [.198-.200 IN] | | 3.99 mm MAX[.157 IN] | |
| TERMINAL APPLICATION SPECIFICATION | LEAR SPEC | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | LEAR TERMINAL | TE TERMINAL | LEAR TERMINAL |
| 1572665-1 | 26457.213.179 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 2.50mm2 | 1.85+/-0.05 [.073+/- .002] | 1 |
| 1.50+1.00 | 1.85+/-0.05 [.073+/- .002] | 2 |
| 1.50+0.75 | 1.75+/-0.05 [.069+/- .002] | 3 |
| 2 x 1.00 | 1.75+/-0.05 [.069+/- .002] | 4 |
| 1.00+0.75 | 1.70+/-0.05 [.067+/- .002] | 13.2 |
| 1.00+0.50 | 1.70+/-0.05 [.067+/- .002] | 13.2 |
| 2 x 0.75 | 1.70+/-0.05 [.067+/- .002] | 13.2 |
| 1.50mm2 | 1.65+/-0.05 [.065+/- .002] | 13.7 |



- 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: 8-2266134-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266134-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266134-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266134-6
- 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 62, 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- 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 3.95.

***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 |
| - | - | - | - | 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 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| -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)

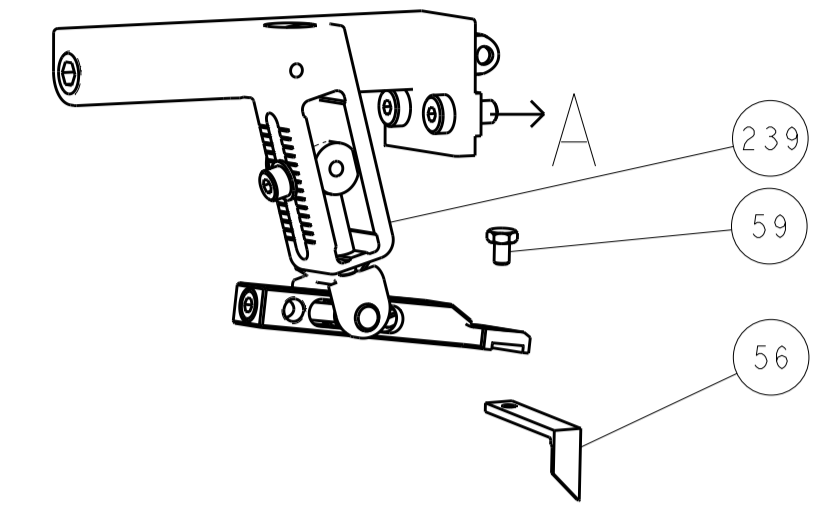
| SET UP GAUGE | LOC | DIST | REVISIONS | | | | | |
|--------------|-----|------|-----------|-----|-------------|-----------|-----|------|
| 2119599-1 | A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | | A | | RELEASE | 22NOV2013 | XZ | LZ |

| | | | | | | | | | |
|-----|----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| 6 | - | 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 |
| 6 | - | 1 | 1 | 1 | 1 | 1 | 2-1752354-2 | STANDOFF, HOLD-DOWN | 180 |
| | - | 1 | 1 | 1 | 1 | 1 | 993111-1 | PIN, SLOTTED SPRING 3.0 X 20.0 | 177 |
| | - | 1 | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 |
| | - | 1 | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 |
| | - | 1 | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 |
| | - | - | - | - | 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 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| | - | - | REF | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| | - | 1 | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| | - | 1 | 1 | 1 | 1 | 1 | 22278-8 | SPRING, COMPRESSION | 77 |
| | - | 1 | 1 | 1 | 1 | 1 | 854769-4 | HOLDER, INS | 74 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119791-5 | DEPRESSOR, WIRE | 70 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119943-1 | WASHER, SPACER | 69 |
| | - | 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 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| 6 | - | 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 | 1 | 1 | 1 | 21028-2 | PIN, SLOTTED SPRING .062 X .250 | 58 |
| | - | - | - | - | 1 | 1 | 1-1338683-1 | FEED PAWL | 56 |
| | - | 4 | 4 | 4 | 4 | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 54 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| | - | 1 | 1 | 1 | 1 | 1 | 1901681-1 | HOLDDOWN, TERMINAL | 51 |
| | - | - | - | - | 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 | 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 | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| | - | 1 | - | 1 | 1 | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119644-2 | RAM WASHER, PRECISION | 38 |
| 6 | - | 1 | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| | - | 1 | - | 1 | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-1752356-3 | 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 | 1-1320908-2 | SPACER, STRIP GUIDE | 30 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119959-2 | ASSEMBLY, STRIP GUIDE | 29 |
| | - | 1 | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 28 |
| | - | 1 | 1 | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| | - | 1 | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| | - | 1 | 1 | 1 | 1 | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| 1 | - | 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 | 318707-1 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 7-1333225-0 | ANVIL, COMBINATION | 8 |
| | - | - | - | - | - | - | - | - | 7 |
| | - | - | - | - | - | - | - | - | 6 |
| | - | 1 | 1 | 1 | 1 | 1 | 1-2119780-1 | DEPRESSOR, SHEAR | 5 |
| | - | 1 | 1 | 1 | 1 | 1 | 2-238011-2 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 4-2119582-9 | CRIMPER, INSULATION F PREMIUM | 3 |
| | - | 1 | 1 | 1 | 1 | 1 | 455888-1 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 8-1490019-5 | CRIMPER, WIRE PREMIUM | 1 |
| -77 | -7 | -6 | -5 | -2 | -1 | | PART NO | DESCRIPTION | ITEM NO |

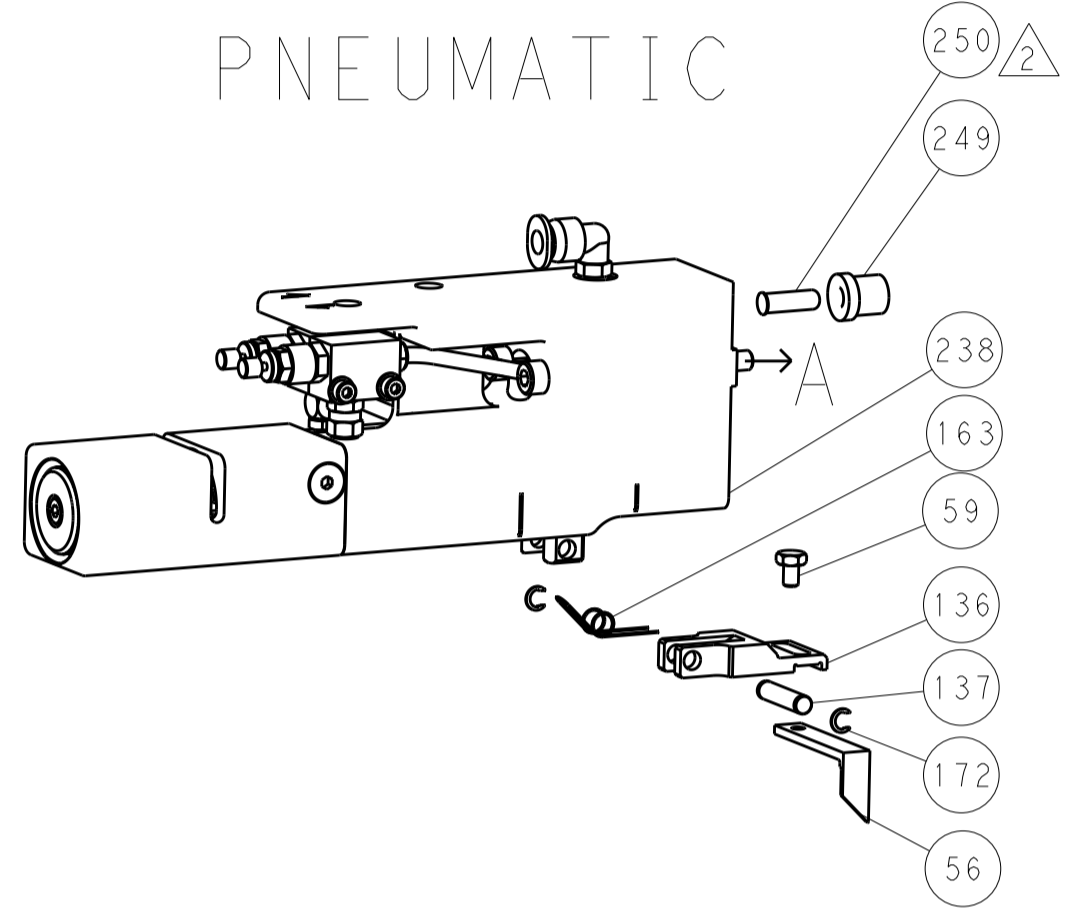
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DRAWING NO | | REVISIONS | |
|--|-----------|--|------------|--------------|--------------|---------------|--------|
| mm | 0 PLC ±.5 | 1 PLC ±.5 | 2 PLC ±.13 | 3 PLC ±.013 | 4 PLC ±.0001 | ANGLES ±.0001 | FINISH |
| MATERIAL | | FINISH | | WEIGHT | | SCALE | |
| | | | | A1 00779 | | C=2266134 | |
| Customer Accessible Production Drawing | | | | SHEET 1 OF 4 | | REV A | |

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

FEED TYPE MECHANICAL



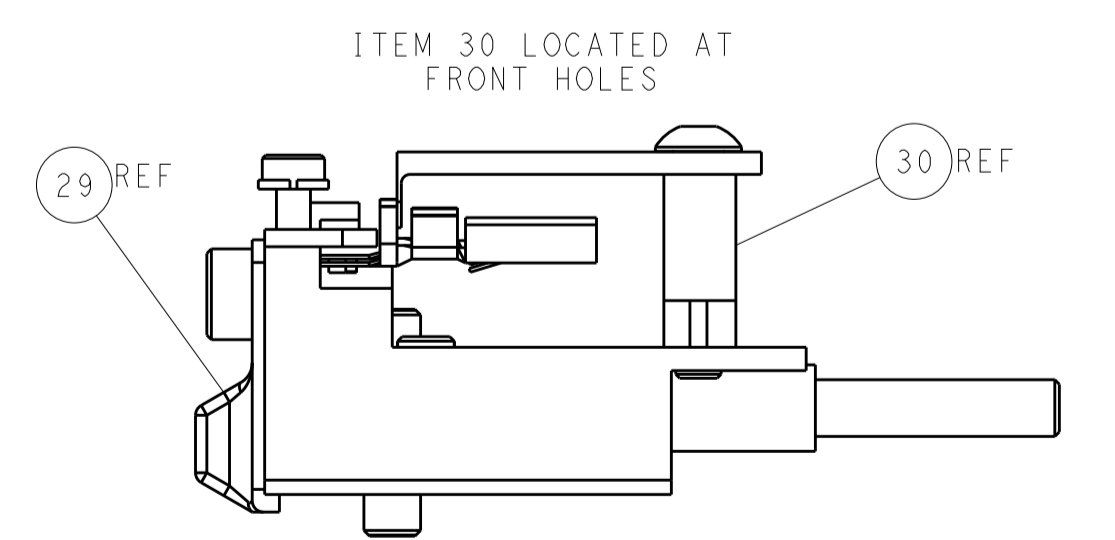
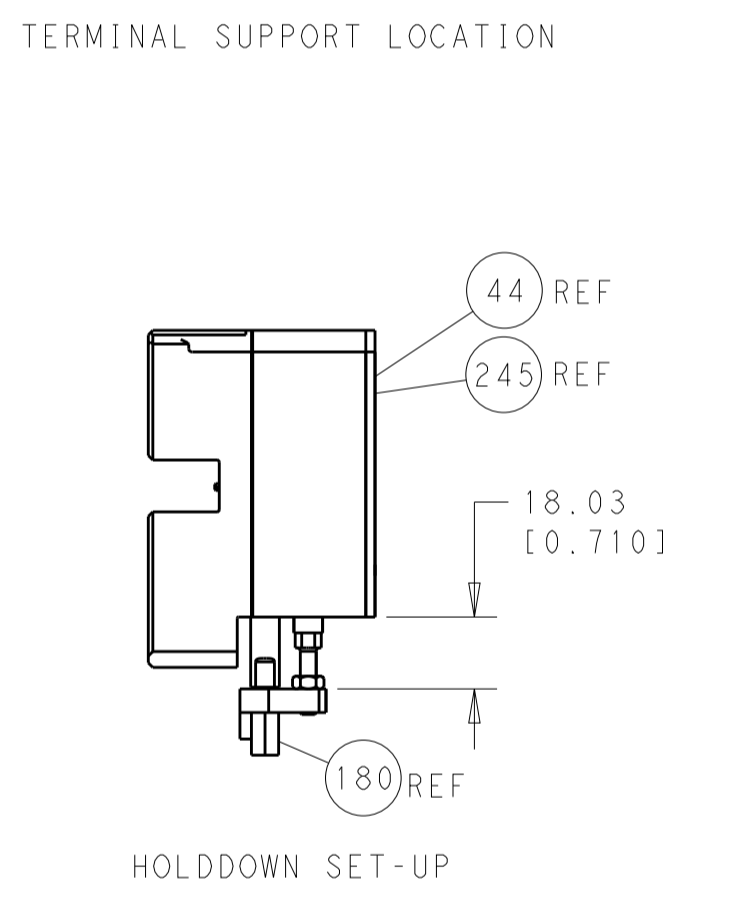
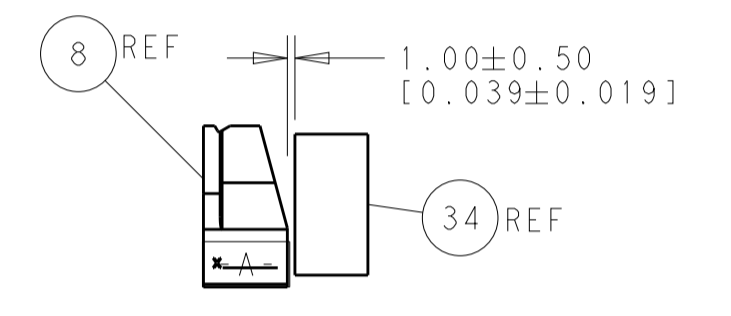
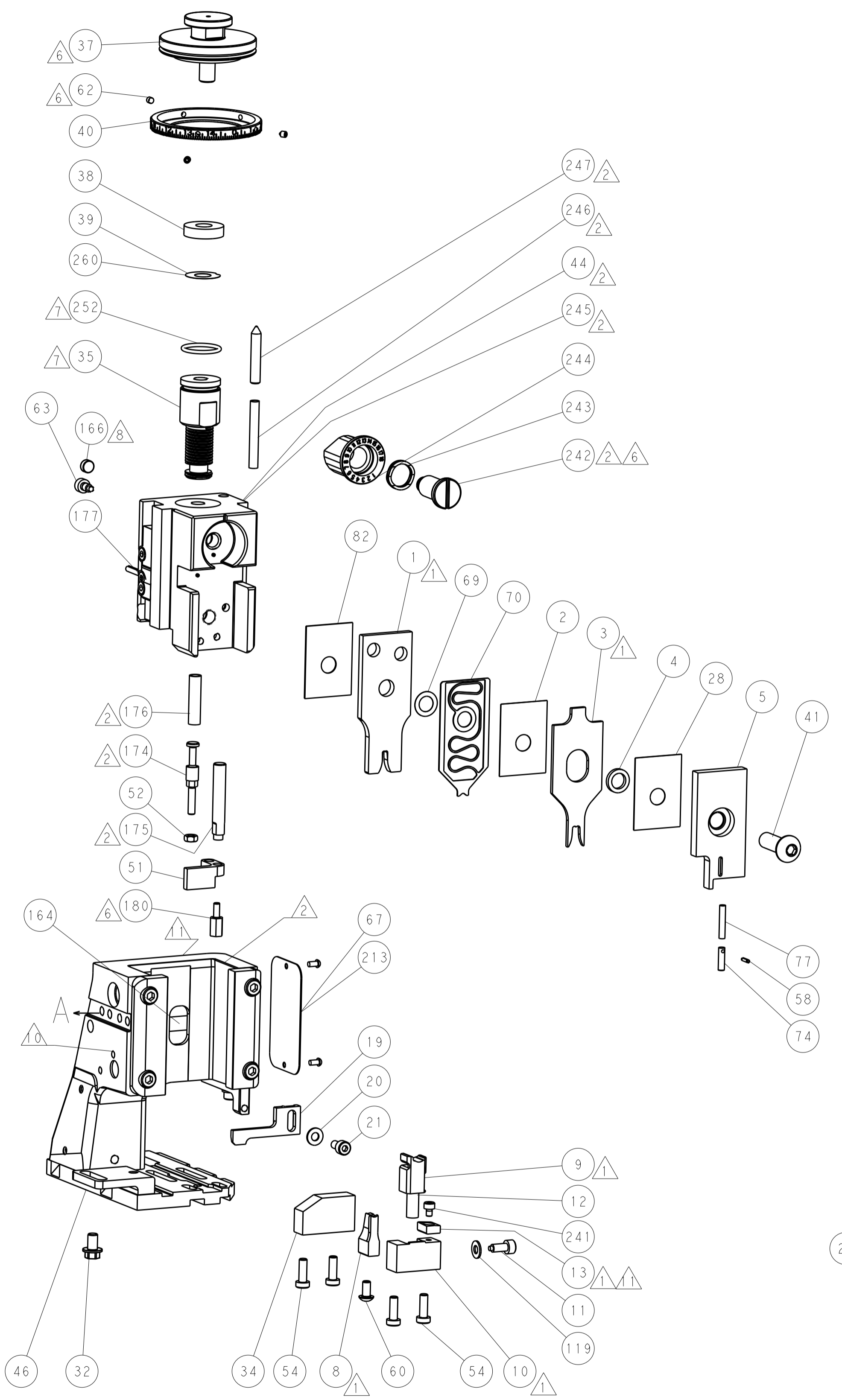
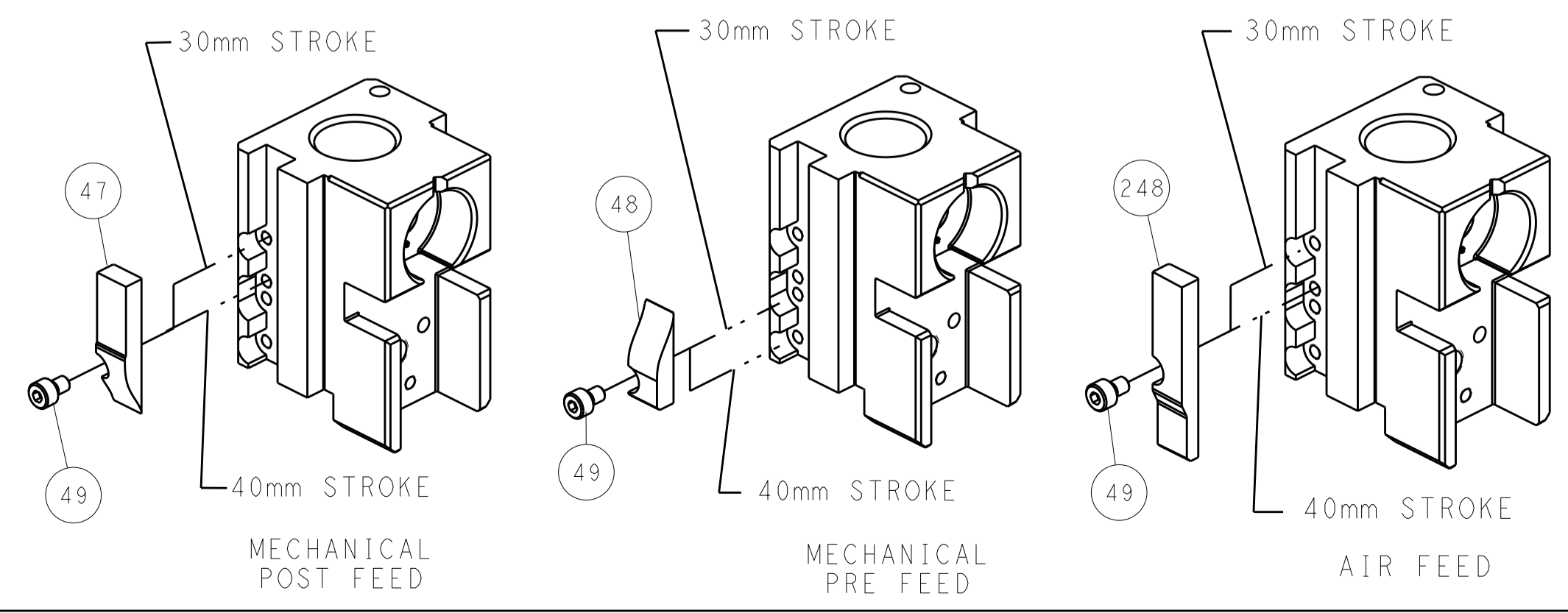
PNEUMATIC



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: | | DWG: X.ZHAO 16OCT2013 | | TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 | ANGLES ±0.0001 | FINISH |
| MATERIAL: | | | | NAME: Ocean Side Feed Applicator | | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | | | SIZE: A1 | | CAGE CODE: 00779 | |
| MATERIAL: | | | | DRAWING NO: 2266134 | | RESTRICTED TO: | |
| MATERIAL: | | | | SCALE: 1:2 | | SHEET 2 OF 4 | |
| MATERIAL: | | | | REV: A | | Customer Accessible Production Drawing | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2266134-1 | 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 | - | 8-2266134-5 | 1901094-3 | 2-1752354-2 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266134-4 | - | - | - |
| | 2-2266134-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2266134-5 | 1901094-3 | 2-1752354-2 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266134-4 | - | - | - |
| | 2-2266134-5 | 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 |
| | 2-2266134-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2266134-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.62 mm [.103] | F |
| INSUL | 4.32 mm [.170] | F |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: LEAR TERMINAL | | LEAR CRIMP SPECIFICATION | |
|------------------------------------|---------------|---------------------------|---------------|
| TERMINAL NAME: DFK 2 RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.02-5.08 mm [1.98-.200 IN] | | 3.99 mm MAX[.157 IN] | |
| TERMINAL APPLICATION SPECIFICATION | LEAR SPEC | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | LEAR TERMINAL | TE TERMINAL | LEAR TERMINAL |
| 1572665-1 | 26457.213.179 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|---------------------------|--------------------------------|
| 2.50mm2 | 1.85+/-0.05 [0.73+/-0.02] | 7.0 |
| 1.50mm2 | 1.65+/-0.05 [0.65+/-0.02] | 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: 8-2266134-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266134-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266134-5
- 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 ITEMS 62, 180 & 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.

| | | | | | | | |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | - | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| - | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 1 | 2119082-9 | 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 |
| -77 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

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

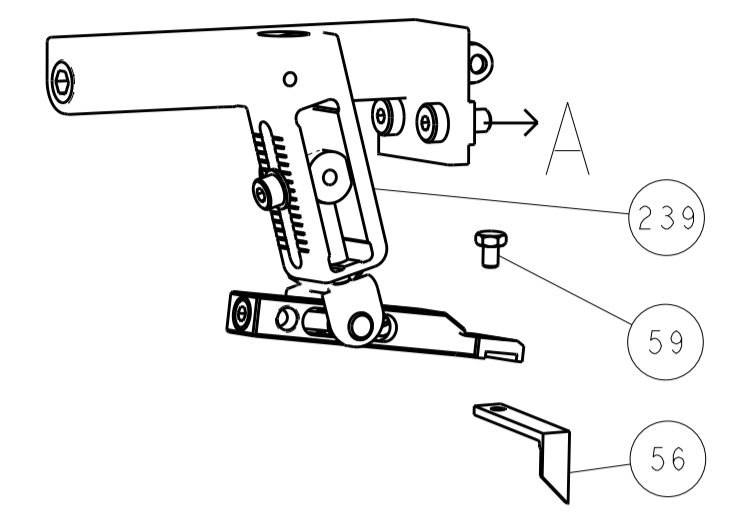
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-------------|------|----|------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPV |
| - | - | - | SEE SHEET 1 | - | - | - |

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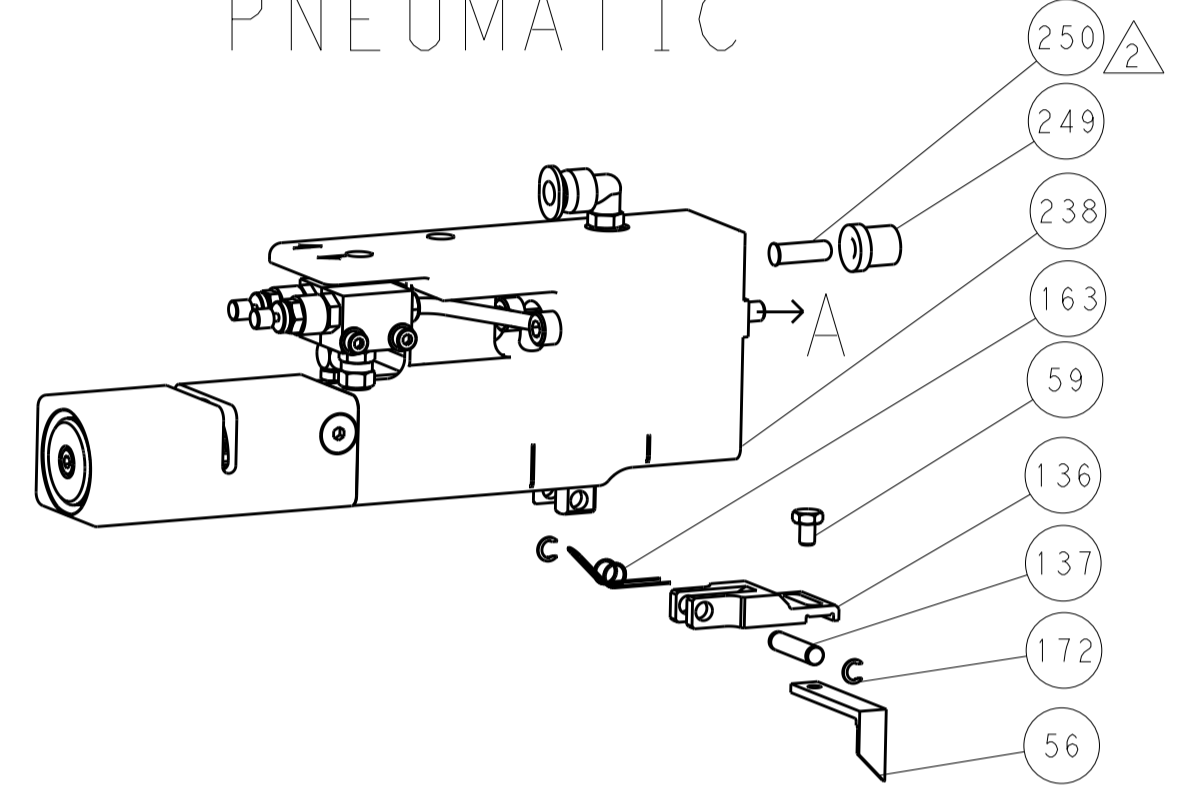
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DATE | BY | APPV | NAME |
|-------------|--------------|--|-------------|-----------|----------|-----------|----------------------------|
| mm | 0 PLC ±.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 16OCT2013 | X. ZHAO | 16OCT2013 | TE Connectivity |
| | 3 PLC ±0.013 | 4 PLC ±0.001 | ANGLES ±.1 | 16OCT2013 | T. ELBIN | 16OCT2013 | Harrisburg, PA 17105-3608 |
| | | | | | L. ZHANG | 16OCT2013 | Ocean Side Feed Applicator |
| MATERIAL | FINISH | WEIGHT | SCALE | SHEET | 3 | OF | 4 |
| | | | 1:2 | REV | A | | |

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

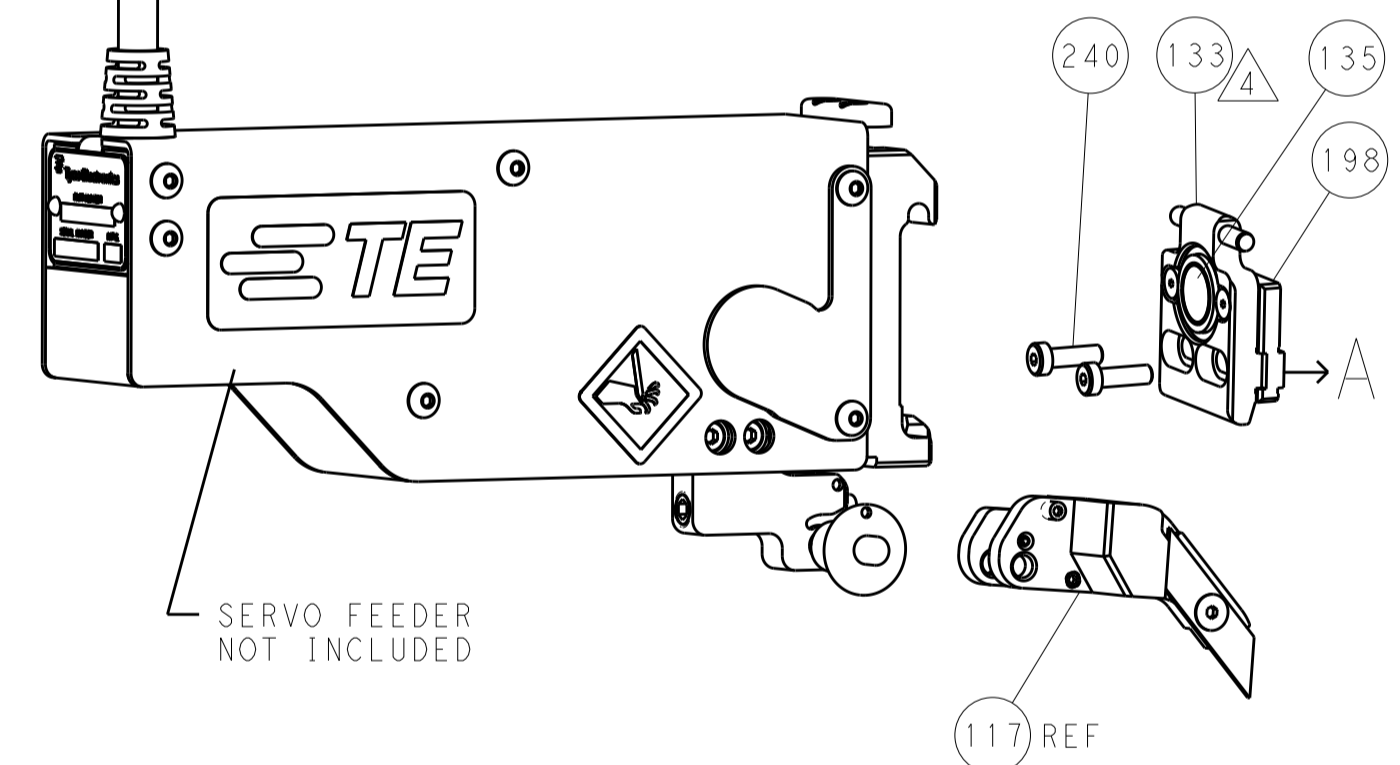
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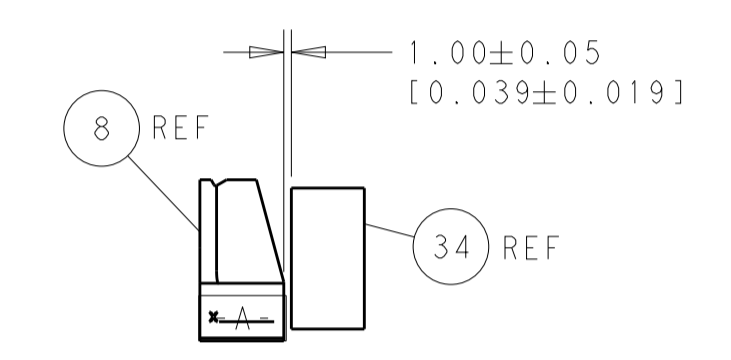
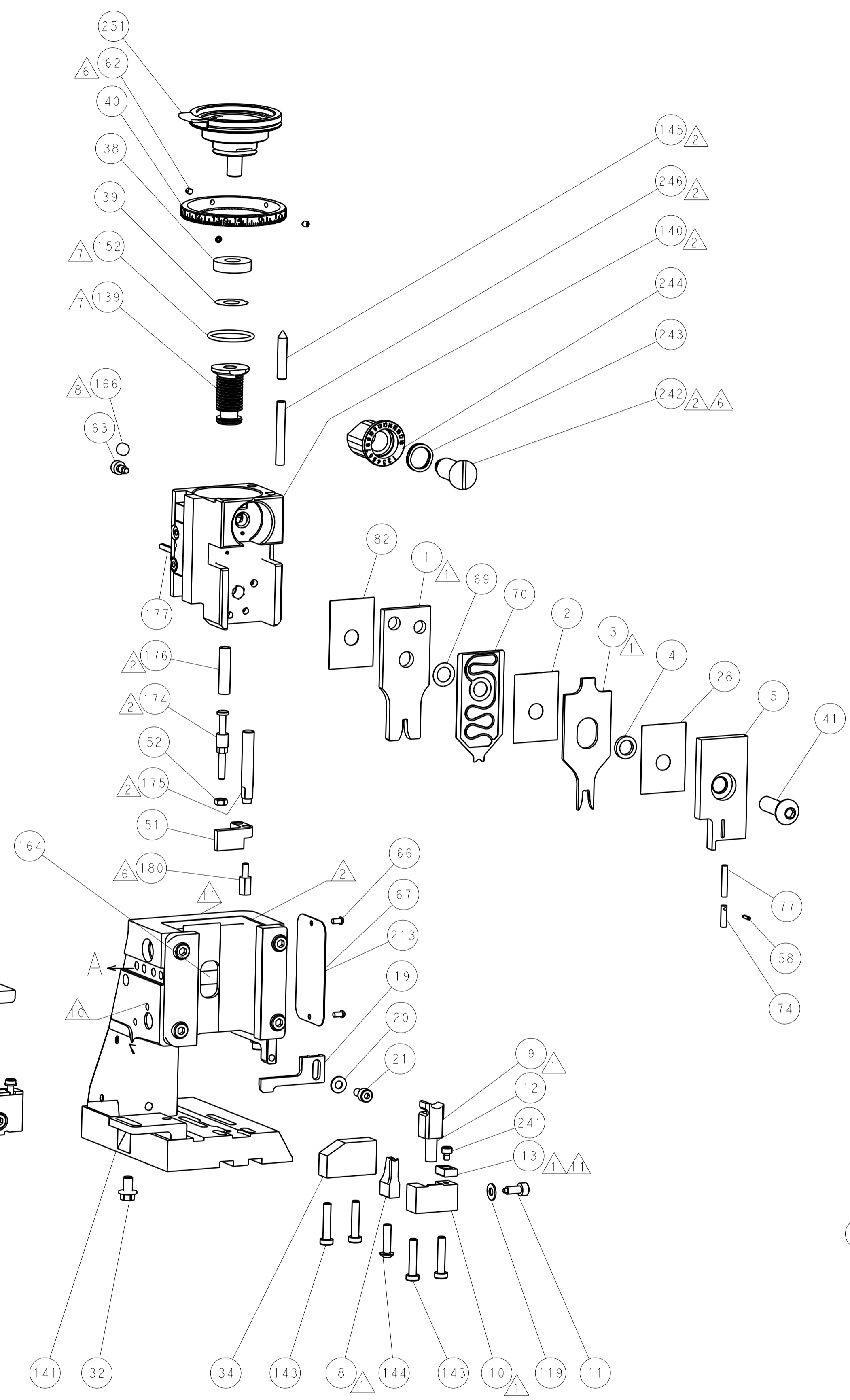
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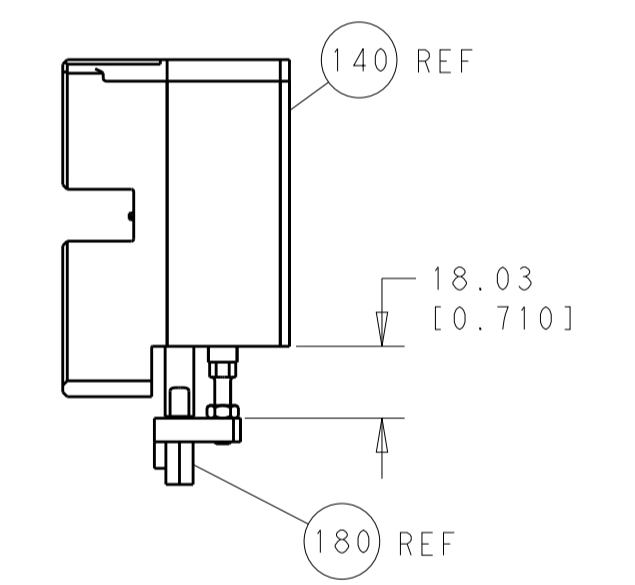
SERVO LATCH PLATE



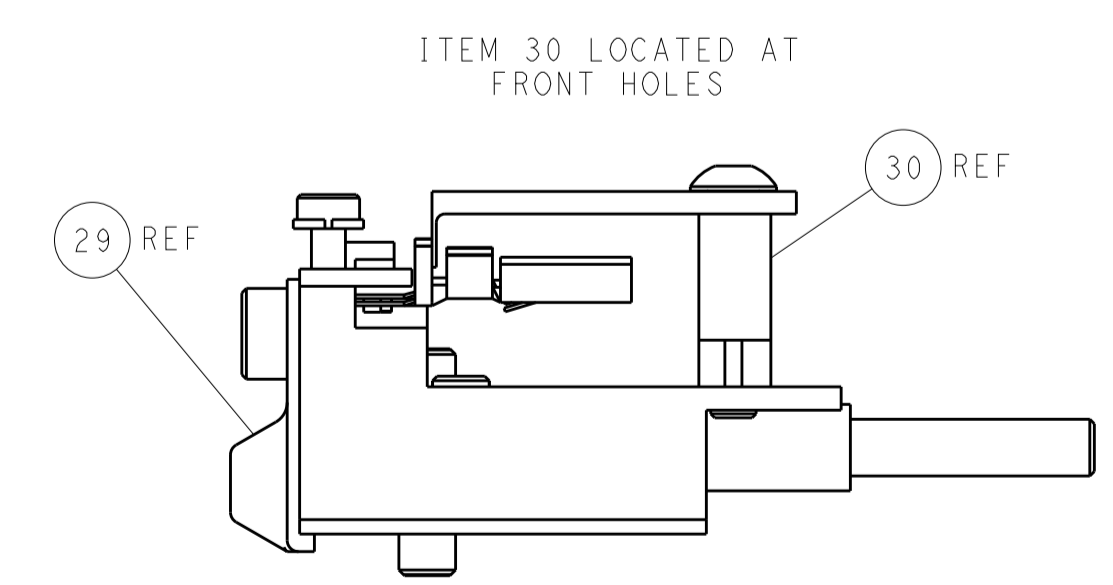
CAM POSITIONS



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: | | DWN X ZHAO 16OCT2013 | | 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 16OCT2013 | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | NAME | | Ocean Side Feed Applicator | |
| | | | | SIZE CAGE CODE DRAWING NO | | RESTRICTED TO | |
| | | | | A1 00779 C=2266134 | | | |
| Customer Accessible Production Drawing | | | | SCALE 1:2 | | SHEET 4 OF 4 REV A | |