

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2151016-1 | D | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | 2151016-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | - | 8-2151016-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151016-4 | - | - | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | |
| | 2151016-5 | D | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1 | - | 8-2151016-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151016-4 | - | - | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | |
| 2151016-6 | D | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | - | - | - | - | - | - | |
| | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | |
| 2151016-7 | D | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2151016-7 | B | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.57 mm [.062] | F |
| INSUL | 2.29 mm [.090] | O |

APPLICATOR INSTRUCTIONS 408-10389

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|--------------|------------------------------|---|
| TERMINAL NAME: PIN ASSEMBLY, .062 TYPE III+ | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.58-4.34 mm [.141-.171 IN] | | Ø1.02-2.03 mm [.040-.080 IN] | |
| TERMINAL APPLICATION SPECIFICATION | (A)114-10004 | - | - |
| | (B)114-10007 | - | - |

| TERMINALS APPLIED | | | |
|-------------------|---------------|----------------|----------------|
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| (A) 66102-6 | (A) 2-66104-3 | (B) 1-66584-0 | (A) 164160-4 |
| (A) 66102-7 | (A) 2-66104-5 | (A) 170245-2 | (A) 164160-7 |
| (A) 66102-8 | (A) 2-66104-7 | (A) 163087-6 | (A) 164160-8 |
| (A) 66102-9 | (A) 3-66104-0 | (A) 163087-7 | (A) 163085-8 |
| (A) 2-66102-2 | (A) 3-66104-2 | (A) 163087-8 | (A) 163085-9 |
| (A) 2-66102-5 | (A) 3-66104-3 | (A) 163087-9 | (A) 1-163085-1 |
| (A) 2-66102-8 | (B) 66583-2 | (A) 1-163087-1 | (A) 5-163085-2 |
| (A) 66104-6 | (B) 66583-4 | (A) 1-163087-4 | (A) 164819-2 |
| (A) 66104-7 | (B) 1-66583-0 | (A) 1-163087-5 | (A) 215325-1 |
| (A) 66104-8 | (B) 66584-2 | (A) 5-163087-2 | (A) 215325-2 |
| (A) 66104-9 | (B) 66584-4 | (A) 164160-3 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 20 AWG | 1.04 +/- 0.085 [.041 +/- .003] | 7.7 |
| 22 AWG | 0.98 +/- 0.070 [.039 +/- .003] | 8.3 |
| 24 AWG | 0.96 +/- 0.095 [.038 +/- .004] | 8.9 |

- 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: 8-2151016-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151016-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151016-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151016-6
- 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 ITEMS 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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 4.77.

TERMINAL LUBRICANT IS RECOMMENDED.

***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 | REV | DATE | BY | CHKD |
| | | | B | ECR-15-007854 | 26MAY2015 | MR |
| | | | C | ECR-16-005484 | 14APR2016 | KH |
| | | | D | ECR-17-002155 | 20FEB2017 | TB |

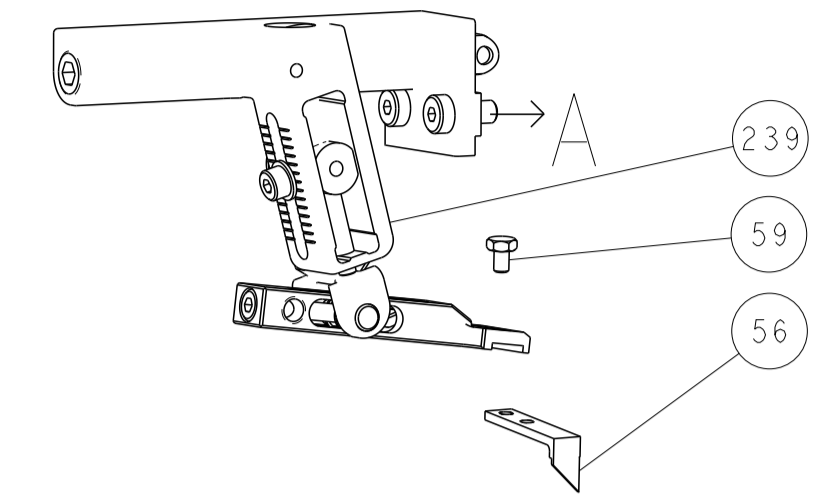
| | | | | | | | | | |
|---|-----|-----|-----|-----|-----|----|-------------|-------------------------------------|---------|
| - | - | - | - | 1 | - | - | 1803259-1 | BUSHING, FLANGED | 249 |
| - | - | - | - | 1 | - | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | - | 1 | 1 | 1 | - | 2119798-1 | 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 | - | 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 |
| - | - | - | - | - | - | - | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | - | - | - | - | 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 |
| - | 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 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 1 | 1 | 1 | 1 | - | 455888-7 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | - | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 1 | - | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | 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 |
| | - | 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 | 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 | - | 2119644-1 | RAM WASHER, PRECISION | 38 |
| | - | 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 | - | 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 | - | 1320908-3 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | - | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | - | 1320928-6 | 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 | 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 | 1803095-3 | FLOATING SHEAR, FRONT | 9 |
| | 1 | 1 | 1 | 1 | 1 | 1 | 1333202-2 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 1 | - | 240641-3 | SPACER | 7 |
| - | - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | - | 2119757-4 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | - | 238011-9 | BLOCK, CRIMPER SPACER | 4 |
| | 1 | 1 | 1 | 1 | 1 | 1 | 1803019-5 | CRIMPER, INSULATION O | 3 |
| - | - | - | - | - | - | - | - | - | 2 |
| | 1 | 1 | 1 | 1 | 1 | 1 | 1-1633860-8 | CRIMPER, WIRE | 1 |
| | -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DATE | | NAME | |
|-------------|--------|--|--|-----------|--------|------|--|
| mm | 0 PLC | ± | | 15JAN2013 | OFFNER | | |
| | 1 PLC | ± | | 16JAN2013 | ELBIN | | |
| | 2 PLC | ± | | | | | |
| | 3 PLC | ± | | | | | |
| | 4 PLC | ± | | | | | |
| | ANGLES | ± | | | | | |
| | FINISH | ± | | | | | |

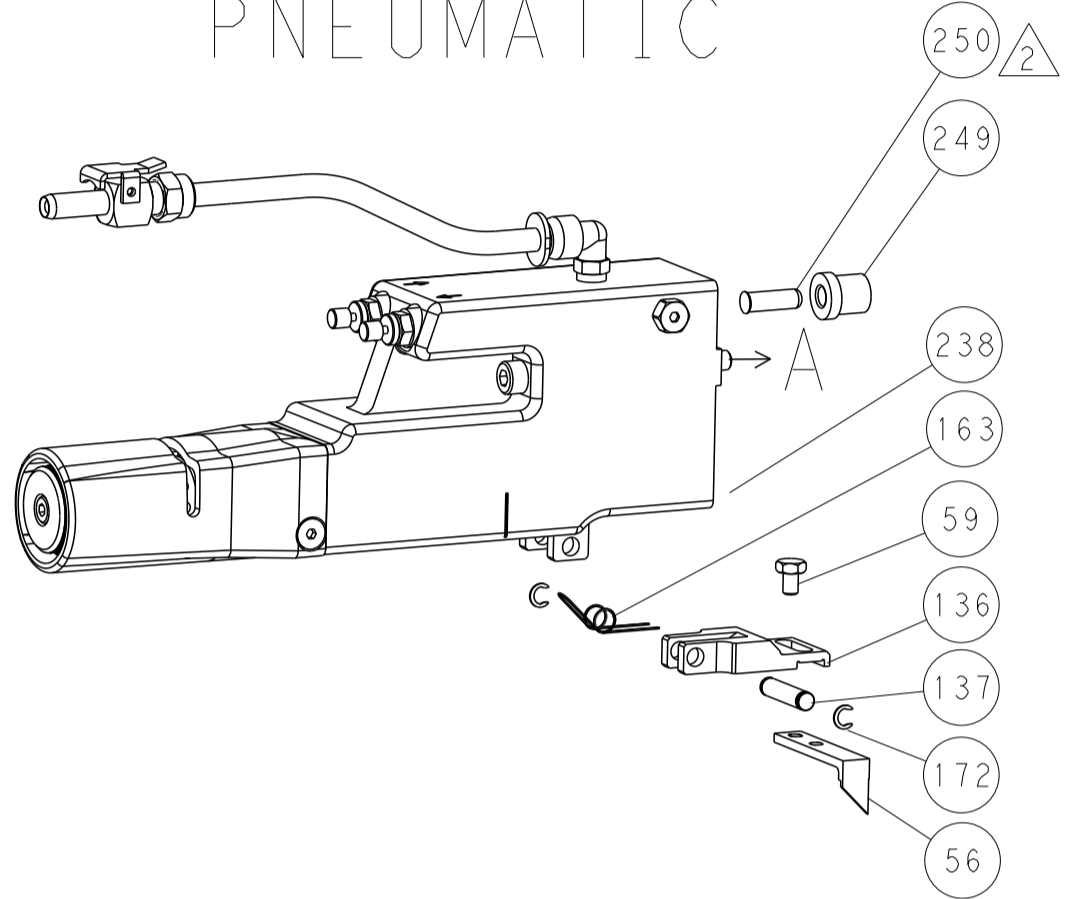
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV D

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

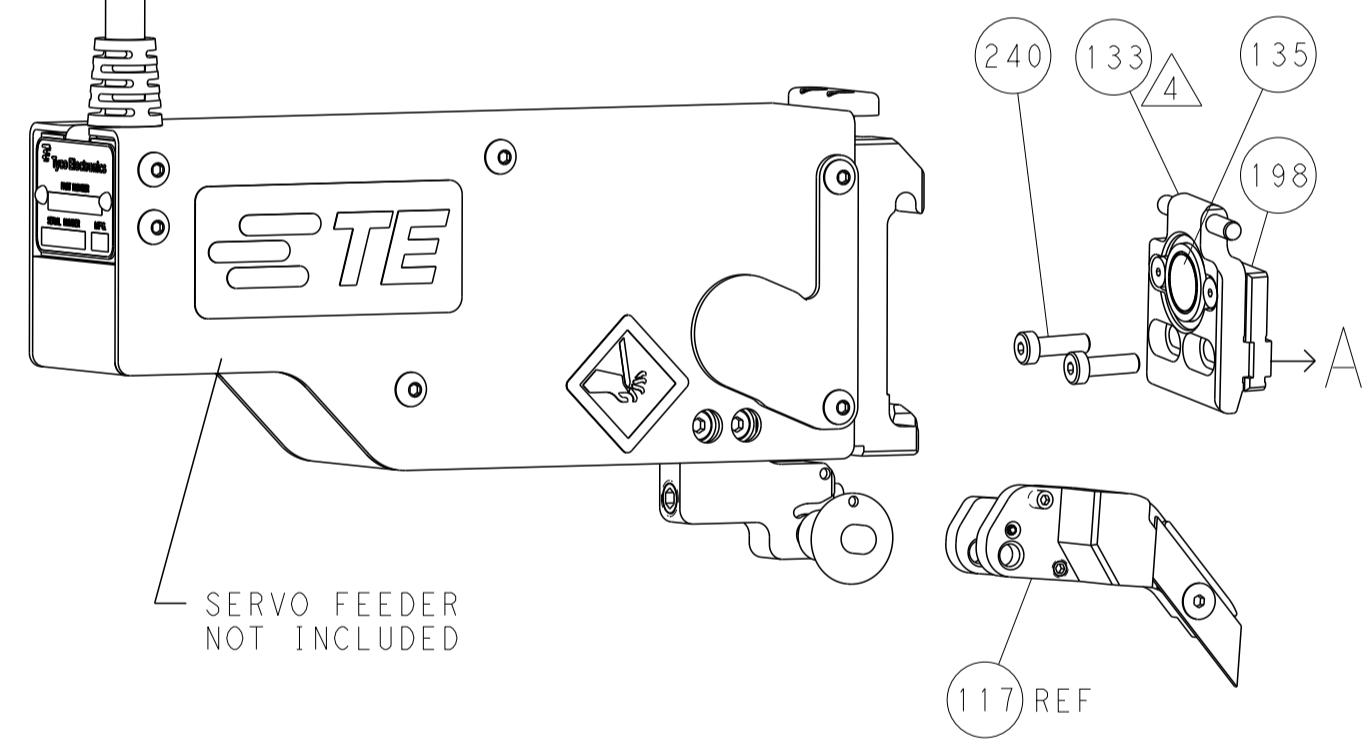
FEED TYPE MECHANICAL



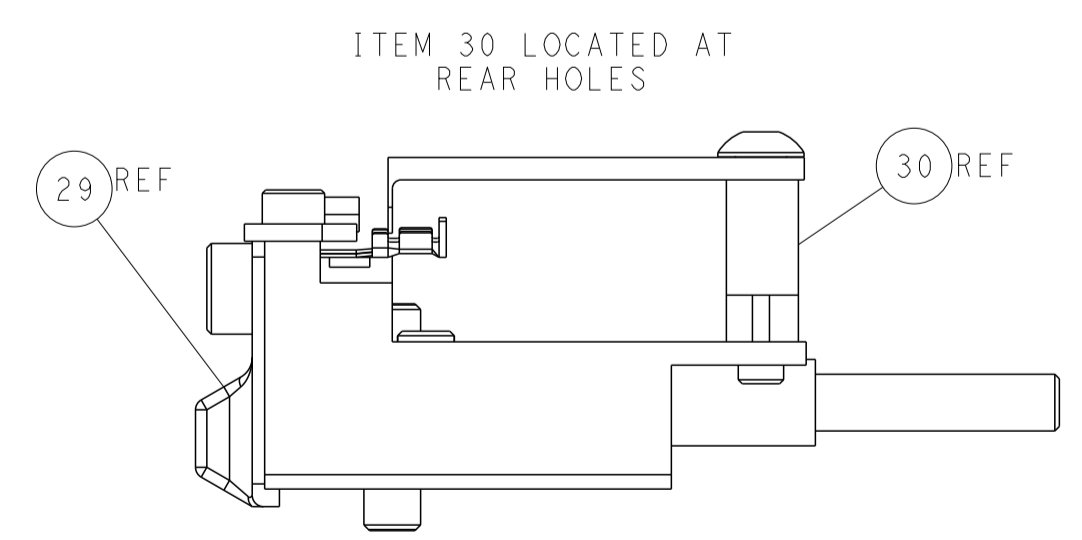
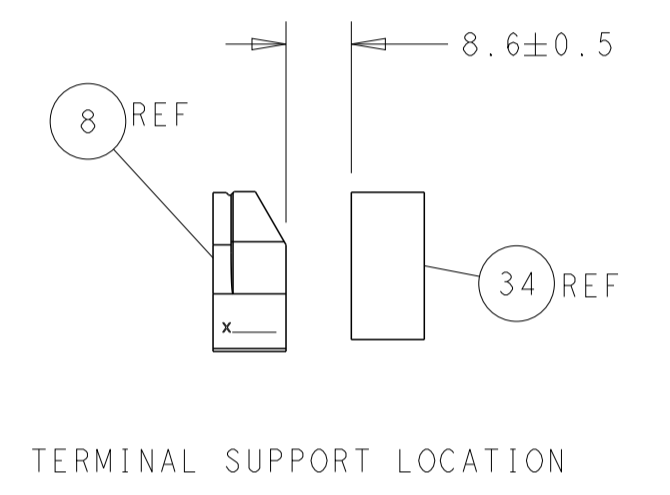
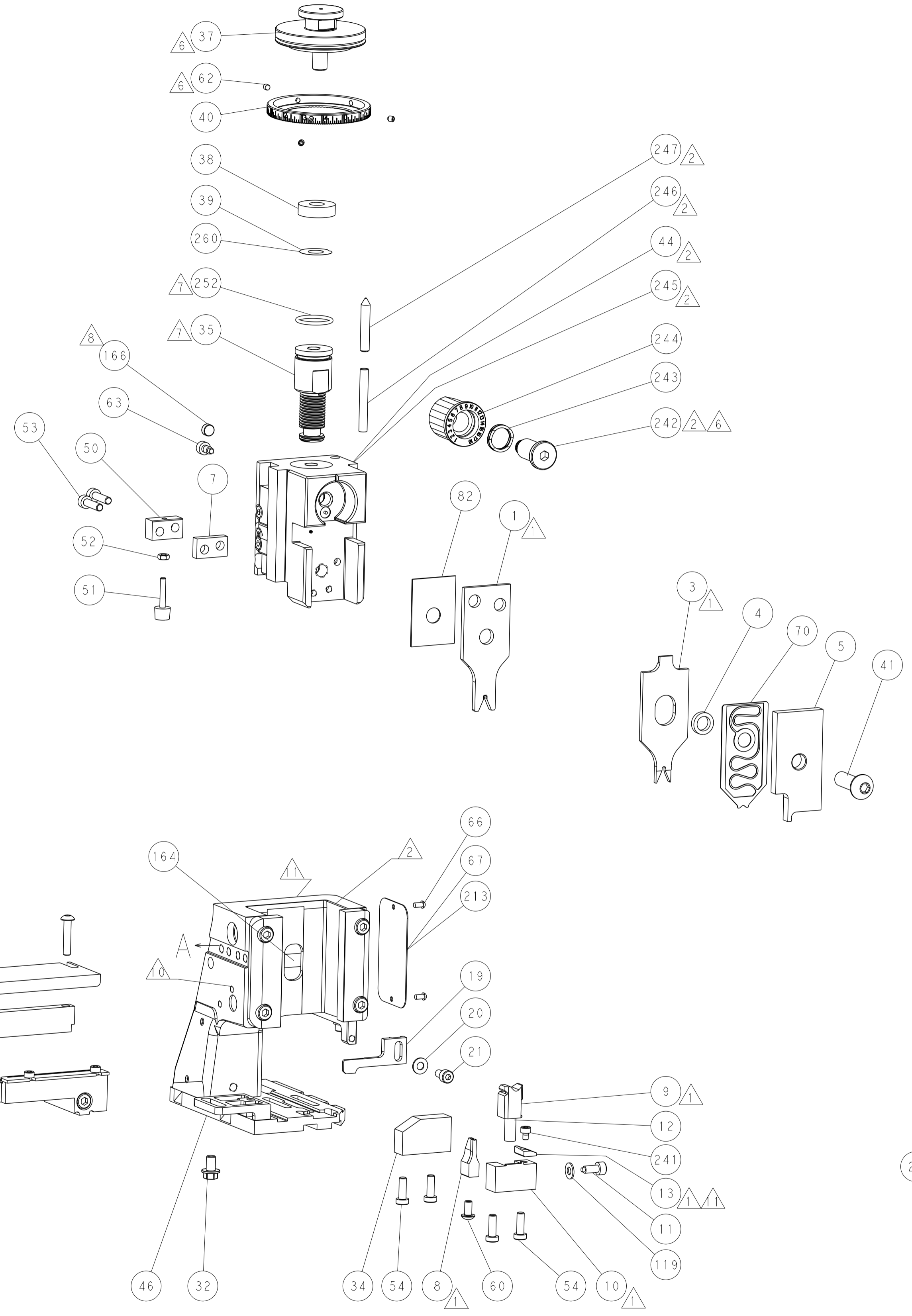
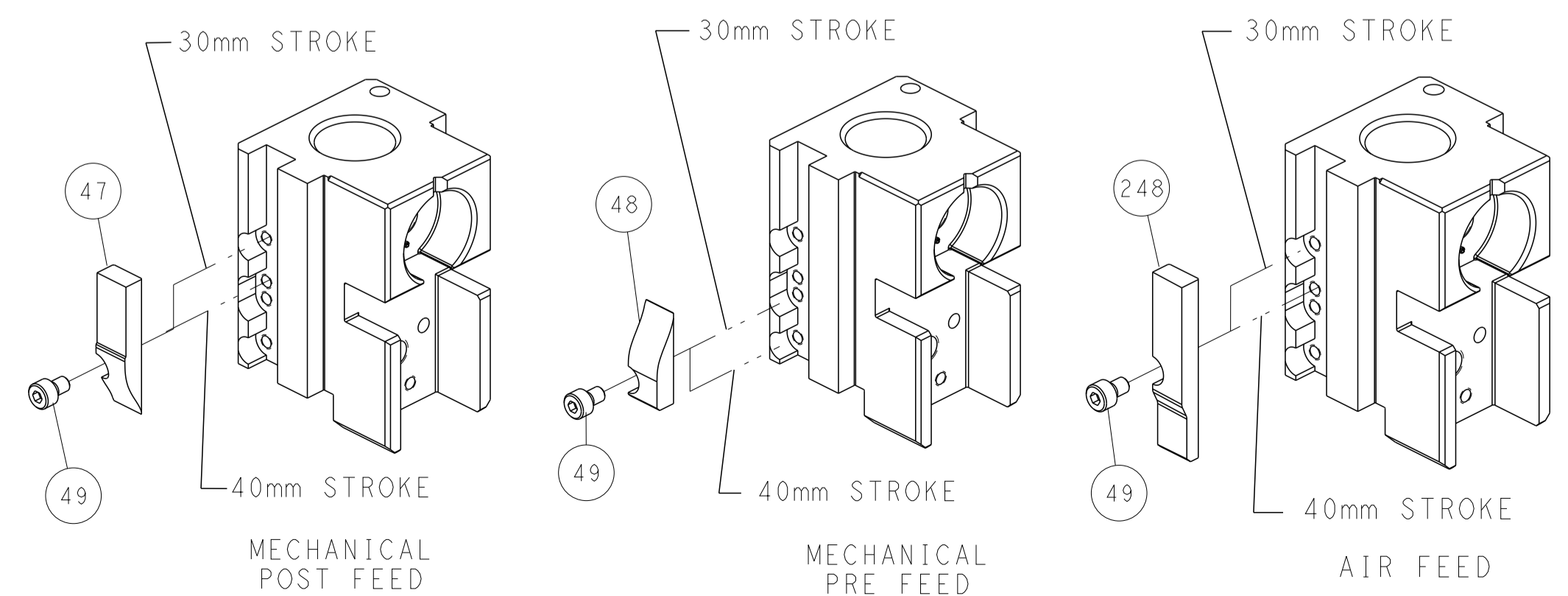
PNEUMATIC



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: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | | DWN: HOFFNER 15JAN2013 CHK: T. ELBIN 16JAN2013 APVD: T. ELBIN 16JAN2013 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing | | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151016 SCALE: 1:2 SHEET: 2 of 4 REV: D | |
| MATERIAL: | | | | RESTRICTED TO: | | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151016-1 | D | 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 | - | 8-2151016-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151016-4 | - | - | - |
| | 2-2151016-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151016-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151016-4 | - | - | - |
| | 2-2151016-5 | D | 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 |
| | 2-2151016-7 | D | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151016-7 | B | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.57 mm [.062] | F |
| INSUL | 2.29 mm [.090] | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|--------------|-------------------------------|---|
| TERMINAL NAME: PIN ASSEMBLY, .062 TYPE III+ | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.58-4.34 mm [1.41-.171 IN] | | Ø1.02-2.03 mm [0.040-.080 IN] | |
| TERMINAL APPLICATION SPECIFICATION | (A)114-10004 | - | - |
| | (B)114-10007 | - | - |

| TERMINALS APPLIED | | | |
|-------------------|---------------|----------------|----------------|
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| (A) 66102-6 | (A) 2-66104-3 | (B) 1-66584-0 | (A) 164160-4 |
| (A) 66102-7 | (A) 2-66104-5 | (A) 170245-2 | (A) 164160-7 |
| (A) 66102-8 | (A) 2-66104-7 | (A) 163087-6 | (A) 164160-8 |
| (A) 66102-9 | (A) 3-66104-0 | (A) 163087-7 | (A) 163085-8 |
| (A) 2-66102-2 | (A) 3-66104-2 | (A) 163087-8 | (A) 163085-9 |
| (A) 2-66102-5 | (A) 3-66104-3 | (A) 163087-9 | (A) 1-163085-1 |
| (A) 2-66102-8 | (B) 66583-2 | (A) 1-163087-1 | (A) 5-163085-2 |
| (A) 66104-6 | (B) 66583-4 | (A) 1-163087-4 | (A) 164819-2 |
| (A) 66104-7 | (B) 1-66583-0 | (A) 1-163087-5 | (A) 215325-1 |
| (A) 66104-8 | (B) 66584-2 | (A) 5-163087-2 | (A) 215325-2 |
| (A) 66104-9 | (B) 66584-4 | (A) 164160-3 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|---------------------------------|--------------------------------|
| 20 AWG | 1.04 +/- 0.085 [0.041 +/- .003] | 7.7 |
| 22 AWG | 0.98 +/- 0.070 [0.039 +/- .003] | 8.3 |
| 24 AWG | 0.96 +/- 0.095 [0.038 +/- .004] | 8.9 |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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: 8-2151016-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151016-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151016-5
- 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.
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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 |
| -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 | P | LTN | DESCRIPTION | DATE | DWN | APVD |
| | | | - | - | SEE SHEET 1 | - | - | - |

| | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | 1 | - | 1803259-1 | BUSHING, FLANGED | 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 |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| - | 1 | 1 | 1 | 1 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 1 | 1 | 1 | 455888-7 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | 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 | 1320908-3 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1320928-6 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 1 | 1 | 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 | 1803095-3 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 1333202-2 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 240641-3 | SPACER | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 2119757-4 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 238011-9 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1803019-5 | CRIMPER, INSULATION O | 3 |
| - | - | - | - | - | - | - | 2 |
| - | 1 | 1 | 1 | 1 | 1-1633860-8 | CRIMPER, WIRE | 1 |

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

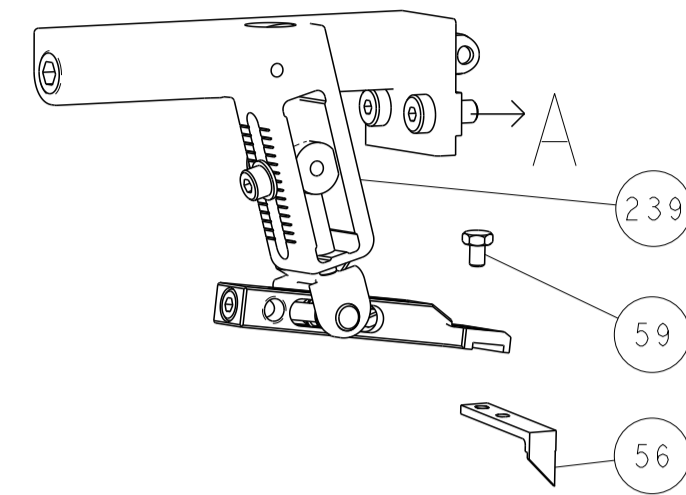
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|---------------|-------------|------------------|---------|
| DATE | 15 JAN 2013 | CHKD | HOFFNER |
| DATE | 16 JAN 2013 | CHKD | ELBIN |
| DATE | 16 JAN 2013 | APVD | ELBIN |
| PRODUCT SPEC | | APPLICATION SPEC | |
| SIZE | A1 | CAGE CODE | 00779 |
| DRAWING NO | | DRAWING NO | 2151016 |
| RESTRICTED TO | | SCALE | 1:2 |
| SHEET | 3 | OF | 4 |
| REV | D | | |

STE TE Connectivity
 Harrisburg, PA 17105-3608
Ocean Side Feed
 Applicator

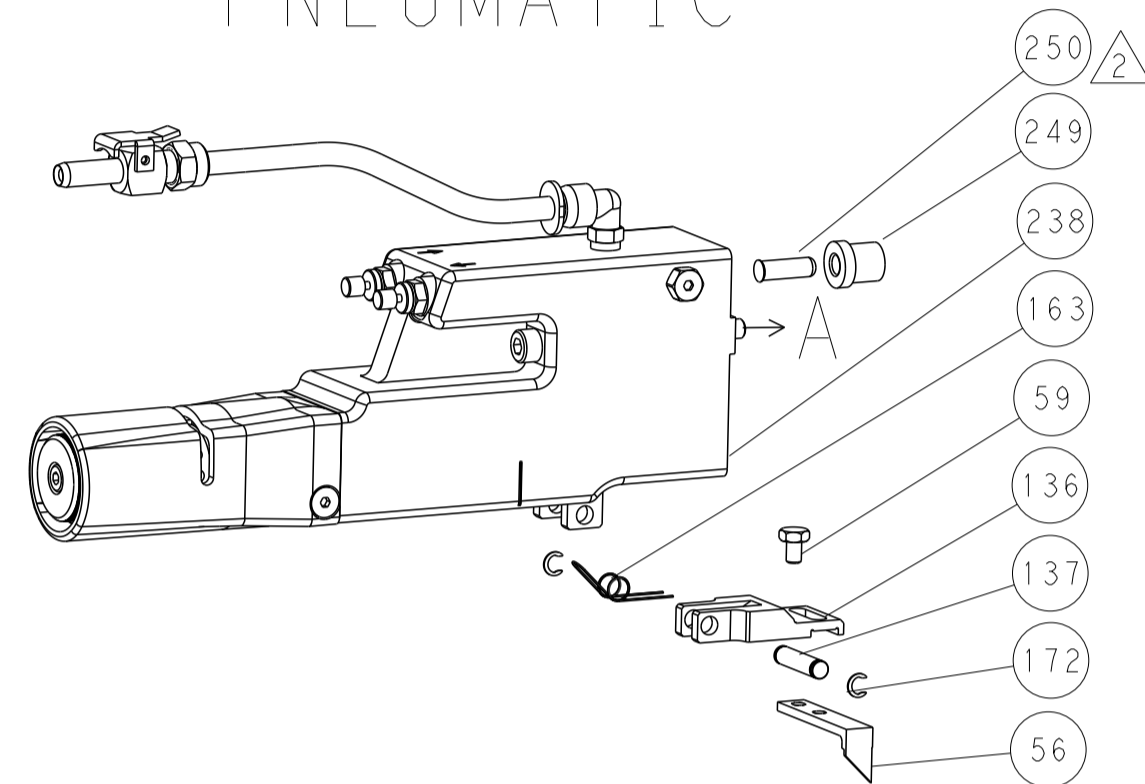
Customer Accessible Production Drawing

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

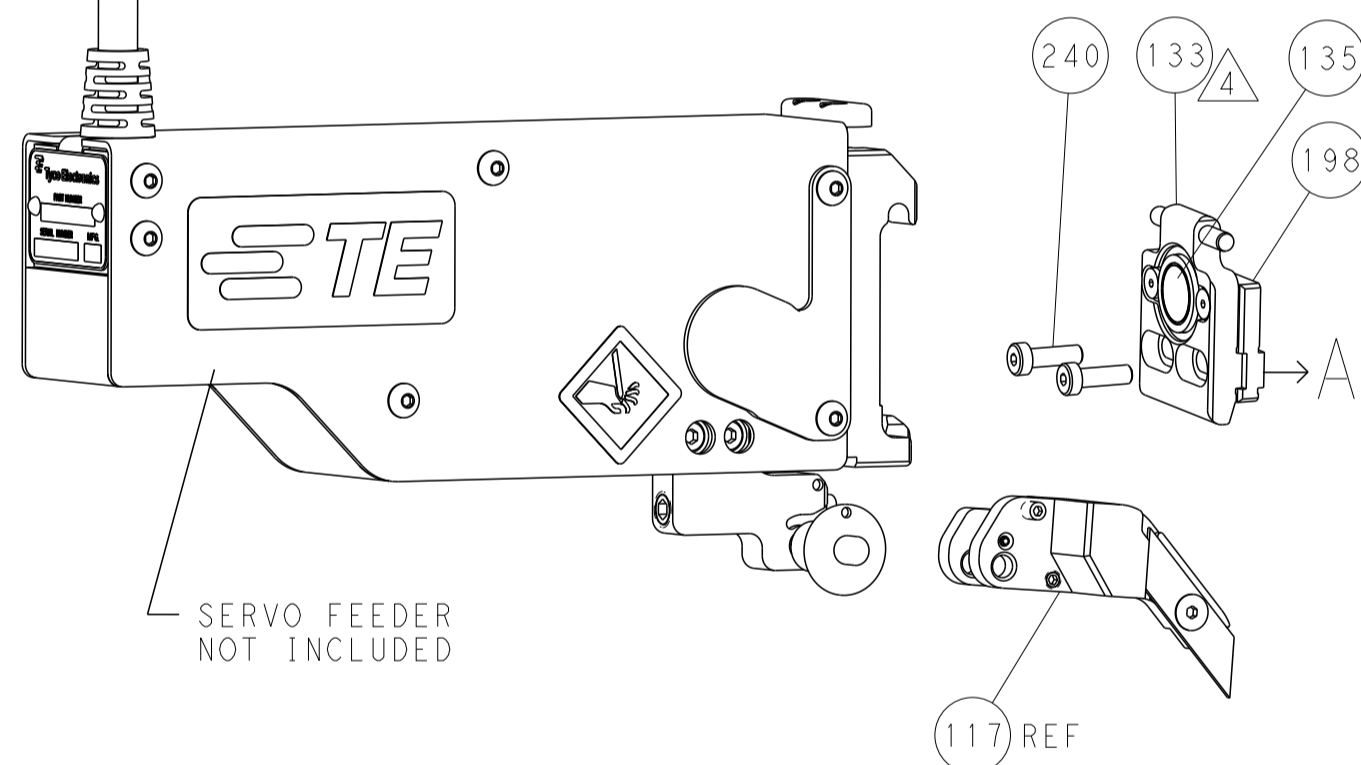
FEED TYPE MECHANICAL



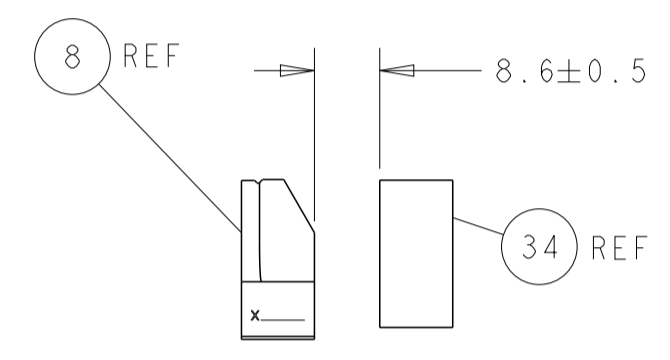
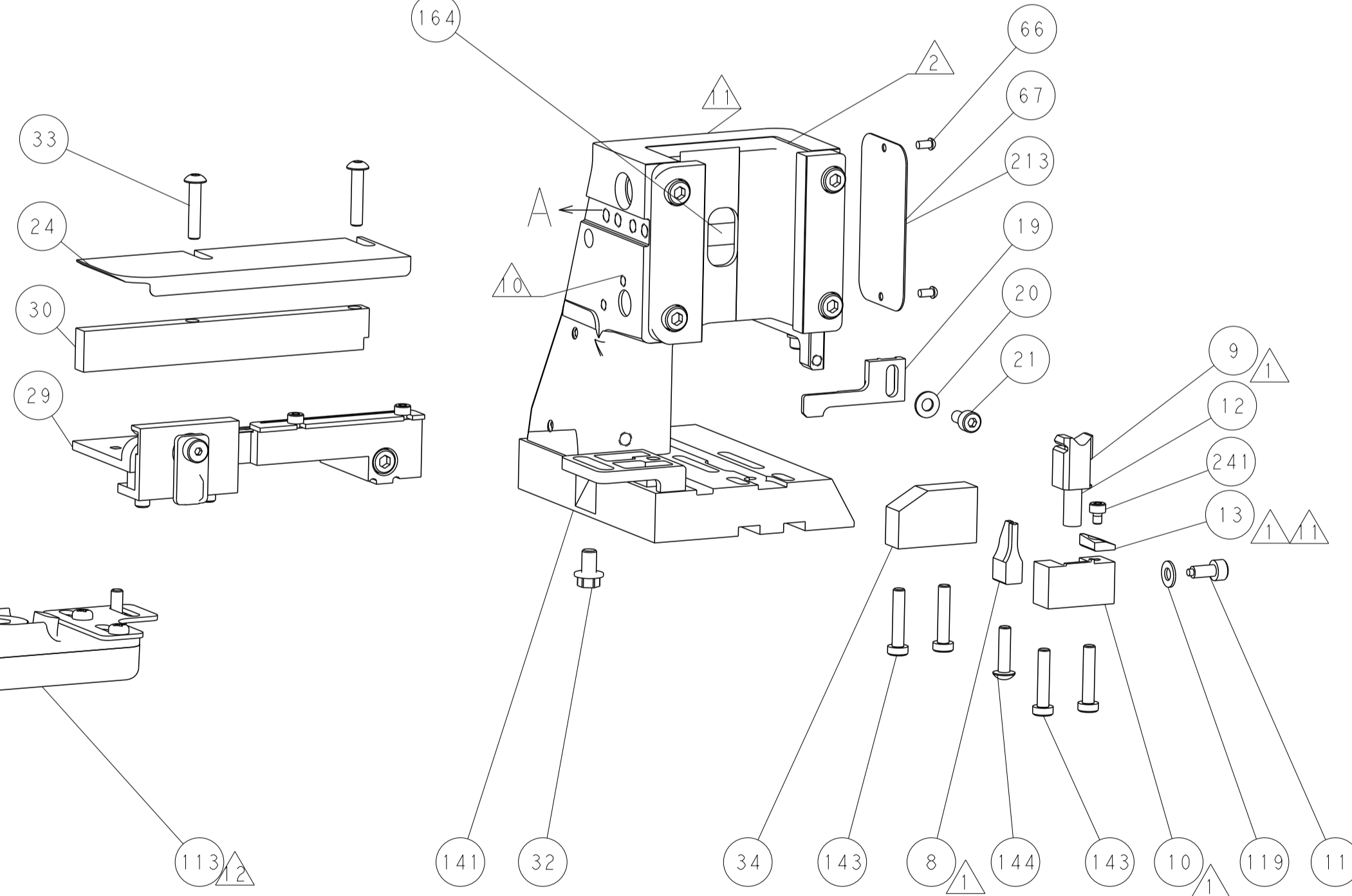
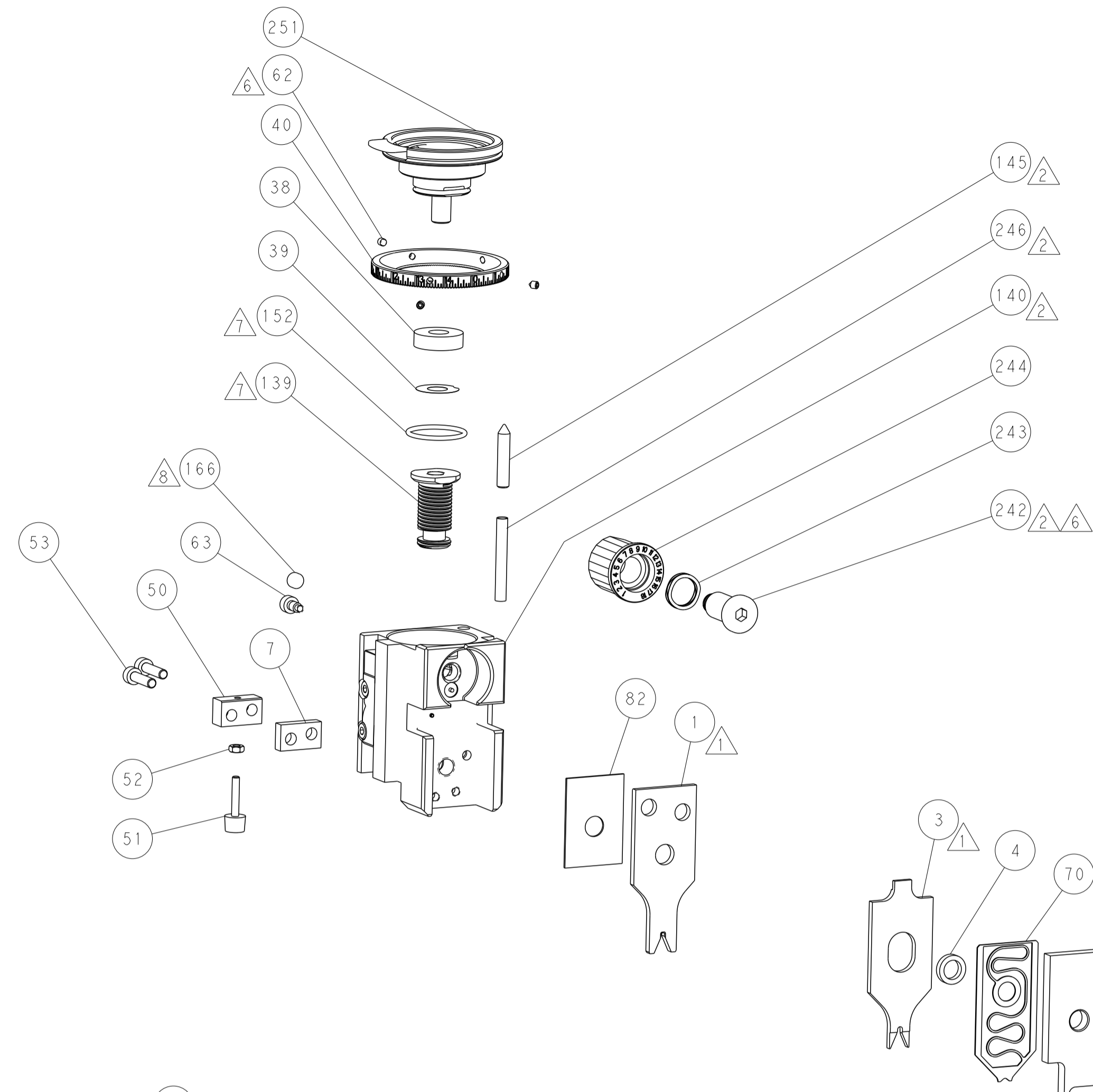
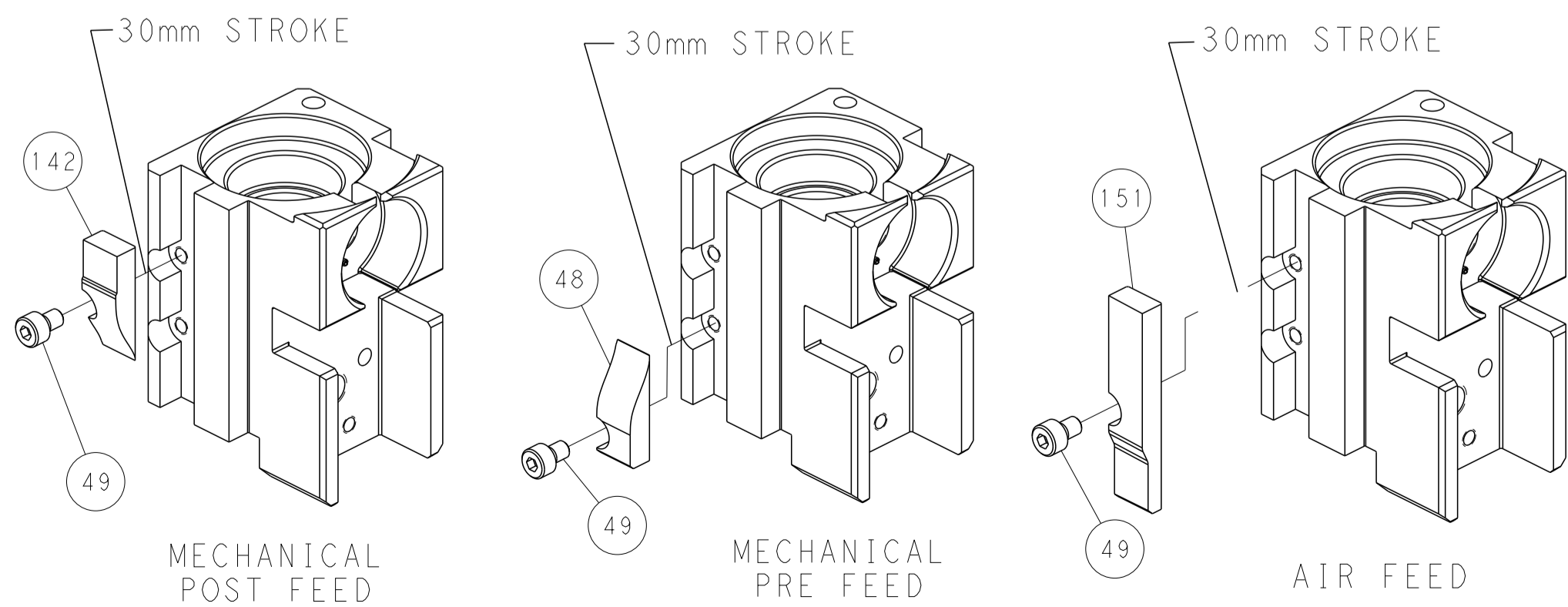
PNEUMATIC



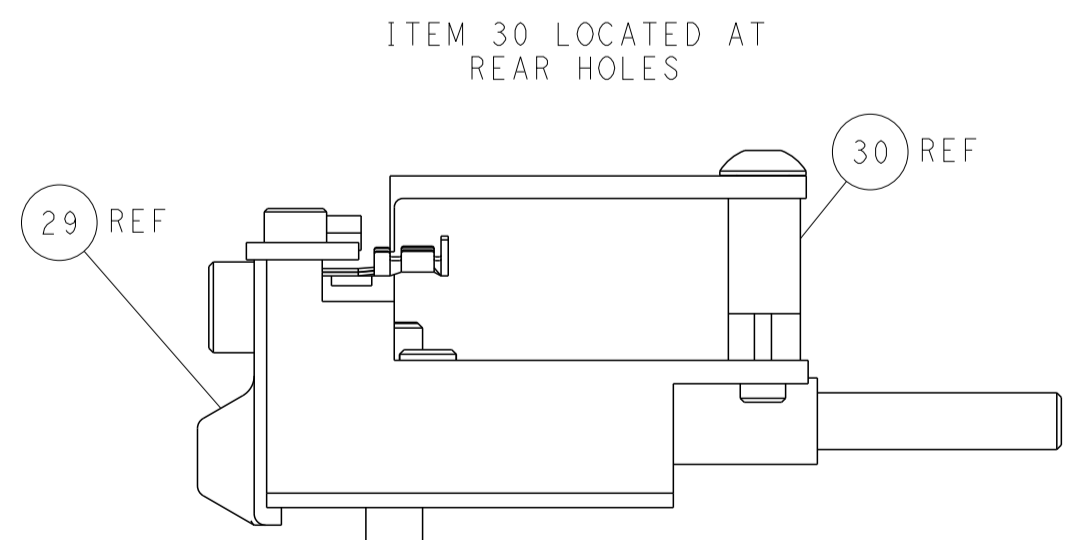
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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: HOFFNER 15JAN2013 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | APVD: T. ELBIN 16JAN2013 | | NAME: Ocean Side Feed Applicator | |
| Customer Accessible Production Drawing | | SCALE: 1:2 | | SHEET 4 OF 4 | | REV D | |