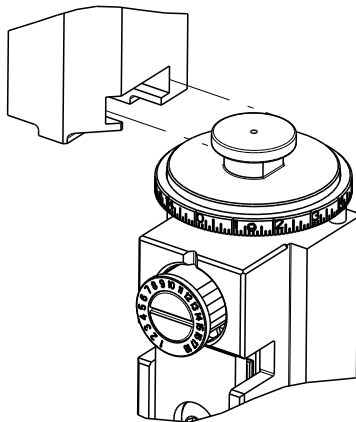
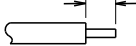


|                                                                                  |                |                          |                          |
|----------------------------------------------------------------------------------|----------------|--------------------------|--------------------------|
| 8                                                                                |                |                          | 7                        |
| THIS DRAWING IS UNPUBLISHED.                                                     |                | RELEASED FOR PUBLICATION | 20                       |
| © COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.             |                |                          |                          |
| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              | PART<br>NUMBER | REVISION                 | DESCRIPTION              |
|  | 2266732-1      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2266732-2      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2266732-5      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2266732-6      | B                        | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2266732-7      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2266732-7    | A                        | CRIMP TOOLING KIT        |

|                                   |                  |      |
|-----------------------------------|------------------|------|
| APPLICATOR DATA                   |                  |      |
| CRIMP                             | SIZE             | TYPE |
| WIRE                              | 2.08 mm [ .082 ] | F    |
| INSUL                             | 4.06 mm [ 1.60 ] | O    |
| APPLICATOR INSTRUCTIONS 408-10389 |                  |      |

|                                                                   |                     |                                                                                   |                           |                |
|-------------------------------------------------------------------|---------------------|-----------------------------------------------------------------------------------|---------------------------|----------------|
| TERMINAL DATA: ITT CANNON TERMINAL ITT CANNON CRIMP SPECIFICATION |                     |                                                                                   |                           |                |
| TERMINAL NAME: TERMINAL, SOCKET                                   |                     |                                                                                   |                           |                |
| WIRE STRIP LENGTH                                                 |                     |  | INSULATION DIAMETER RANGE |                |
| 4.89-5.65 mm [.193-.223 IN]                                       |                     | Ø                                                                                 | 1.3                       |                |
| TERMINAL APPLICATION SPECIFICATION                                | K031-8500-169 Rev G |                                                                                   | 1.3                       | -              |
|                                                                   | -                   | -                                                                                 | -                         | -              |
| TERMINALS APPLIED                                                 |                     |                                                                                   |                           |                |
| 1.3                                                               |                     |                                                                                   |                           |                |
| TE TERMINAL                                                       | ITT CANNON TERMINAL | TE SEAL                                                                           | ITT CANNON SEAL           | CABLE DIAMETER |
| 1949474-1                                                         | 121668-0125         | 1572322-1                                                                         | 121668-0032               | Ø 1.4-2.0      |
| 1949474-2                                                         | 121668-0022         |                                                                                   |                           |                |
| 1949474-3                                                         | 121668-0024         |                                                                                   |                           |                |

|                   |                              |                                |
|-------------------|------------------------------|--------------------------------|
| WIRE SIZE         | CRIMP HEIGHT mm [ INCH ]     | CRIMP HEIGHT REFERENCE SETTING |
| 1.00mm2           | 1.45+/-0.03 [ .057+/- .001 ] | 7.1                            |
| 18 AWG OR 0.75mm2 | 1.35+/-0.03 [ .053+/- .001 ] | 8.2                            |
| 0.50mm2           | 1.26+/-0.03 [ .050+/- .001 ] | 9.1                            |

- 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: 8-2266732-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266732-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266732-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266732-6
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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. 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 4.35.
- 13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 14 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.
- 15 18 AWG WIRE IS NOT LISTED ON TERMINAL MANUFACTURER SPECIFICATION.

\*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.

|    |     |    |    |    |    |    |           |                                 |         |
|----|-----|----|----|----|----|----|-----------|---------------------------------|---------|
| 12 | -   | -  | 1  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| 13 | -   | 1  | -  | 1  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252     |
|    | -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)

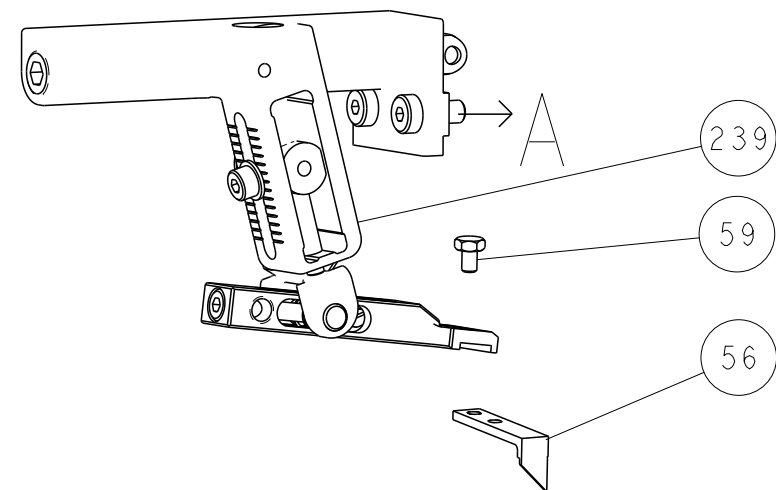
|                        |       |               |           |           |     |      |
|------------------------|-------|---------------|-----------|-----------|-----|------|
| SET UP GAUGE 2119599-1 | LOC A | DIST 66       | REVISIONS |           |     |      |
| P                      | LTR   | DESCRIPTION   |           | DATE      | OWN | APVD |
|                        | B     | ECR-16-002887 |           | 25FEB2016 | MR  | GB   |
|                        |       |               |           |           |     |      |
|                        |       |               |           |           |     |      |

|     |     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | -   | -   | -   | 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   | 2119082-4   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -   | 1   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -   | 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     |
| -   | -   | -   | -   | 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     |
| -   | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-6    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 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   | 1   | 1   | 1   | 985575-3    | SCR, FLT SKT HD CAP M3 X 10.0       | 57      |
| -   | -   | -   | -   | 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   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 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   | 1-2119644-2 | 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   | 1-1752356-7 | 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   | 1-1320908-0 | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29      |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28      |
| -   | 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      |
| -   | 2   | 2   | 2   | 2   | 2   | 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   | 318707-1    | FLOATING SHEAR, FRONT               | 9       |
| 1   | 1   | 1   | 1   | 1   | 1   | 3-1803171-8 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1   | 2-2119781-4 | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 1   | 238011-9    | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 1   | 1   | 1   | 3-2119784-1 | CRIMPER, INSULATION O PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2       |
| 1   | 1   | 1   | 1   | 1   | 1   | 3-1490019-5 | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

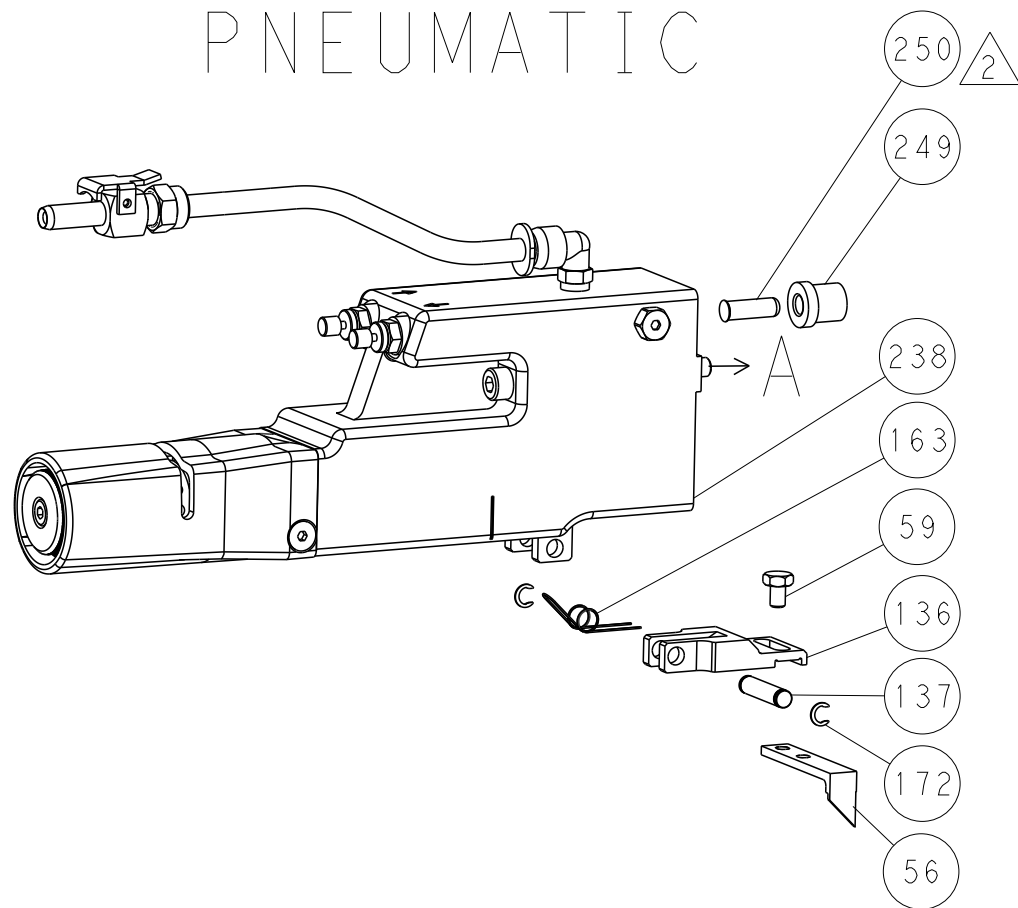
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|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|----------------------------------------|--|--------------------------------------------------|--|------------------------------|--|
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| DIMENSIONS:                                                                                                                                                                            |  |  |  |  |  |  |  |  |  | CHK: L. ZHANG 23MAR2015                |  | NAME                                             |  |                              |  |
| mm                                                                                                                                                                                     |  |  |  |  |  |  |  |  |  | APVD: U. GUO 23MAR2015                 |  | Ocean Side Feed<br>Applicator                    |  |                              |  |
|                                                                                                   |  |  |  |  |  |  |  |  |  | PRODUCT SPEC                           |  | SIZE CASE CODE DRAWING NO<br>A1 00779 ©=2266732  |  | RESTRICTED TO<br>-           |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                                                                                                                 |  |  |  |  |  |  |  |  |  | APPLICATION SPEC                       |  |                                                  |  |                              |  |
| 0 PLC ±.001                                                                                                                                                                            |  |  |  |  |  |  |  |  |  | WEIGHT                                 |  |                                                  |  |                              |  |
| 1 PLC ±.001                                                                                                                                                                            |  |  |  |  |  |  |  |  |  | SIZE                                   |  |                                                  |  |                              |  |
| 2 PLC ±.001                                                                                                                                                                            |  |  |  |  |  |  |  |  |  | CASE CODE                              |  |                                                  |  |                              |  |
| 3 PLC ±.001                                                                                                                                                                            |  |  |  |  |  |  |  |  |  | DRAWING NO                             |  | SCALE 1:2 SHEET 1 OF 4 REV B                     |  |                              |  |
| 4 PLC ±.001                                                                                                                                                                            |  |  |  |  |  |  |  |  |  | RESTRICTED TO                          |  |                                                  |  |                              |  |
| ANGLES                                                                                                                                                                                 |  |  |  |  |  |  |  |  |  | A1 00779 ©=2266732                     |  |                                                  |  |                              |  |
| FINISH                                                                                                                                                                                 |  |  |  |  |  |  |  |  |  | Customer Accessible Production Drawing |  |                                                  |  |                              |  |
| MATERIAL                                                                                                                                                                               |  |  |  |  |  |  |  |  |  | WEIGHT                                 |  |                                                  |  | SCALE 1:2 SHEET 1 OF 4 REV B |  |

| LOC |    | DIST |     | REVISONS    |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    |     | SEE SHEET 1 | -    | -   | -    |
|     |    |      |     |             |      |     |      |
|     |    |      |     |             |      |     |      |

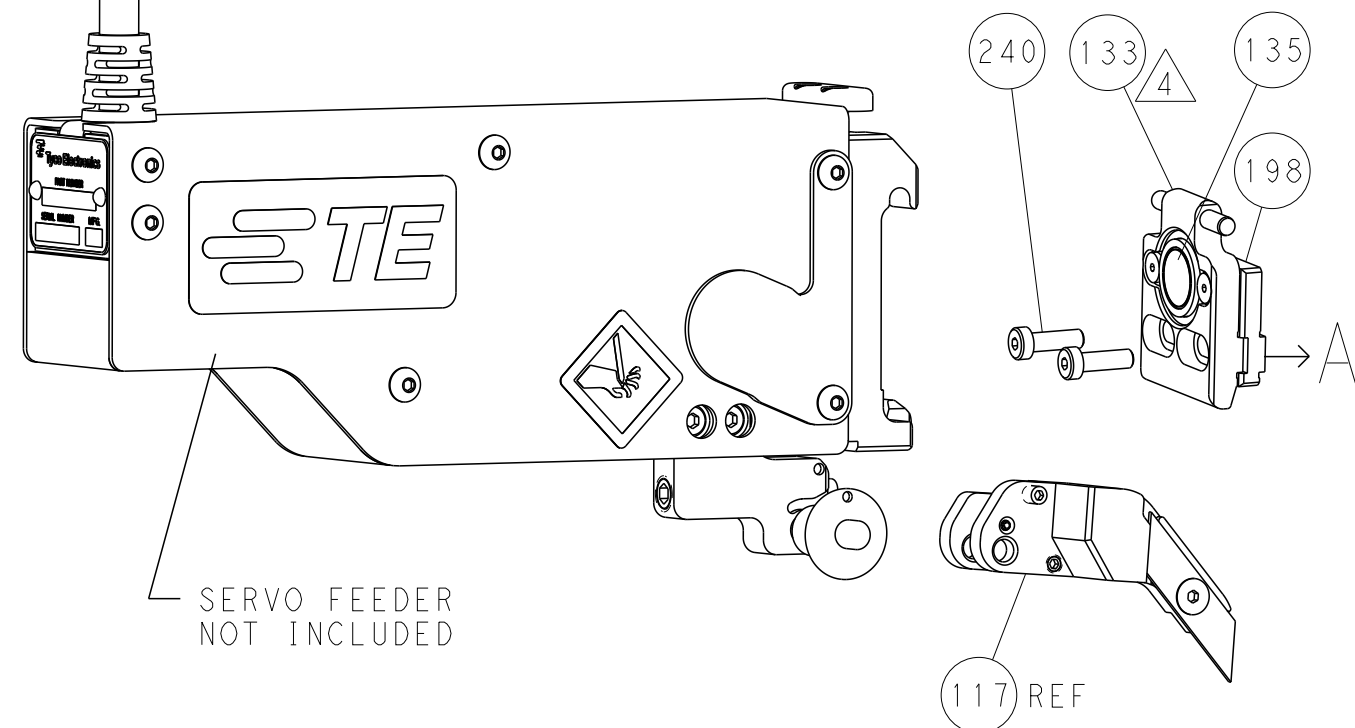
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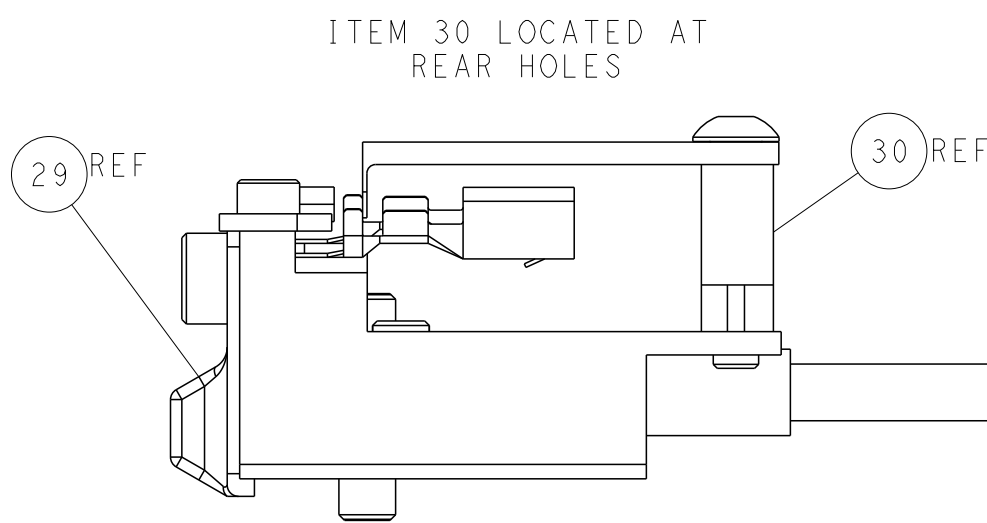
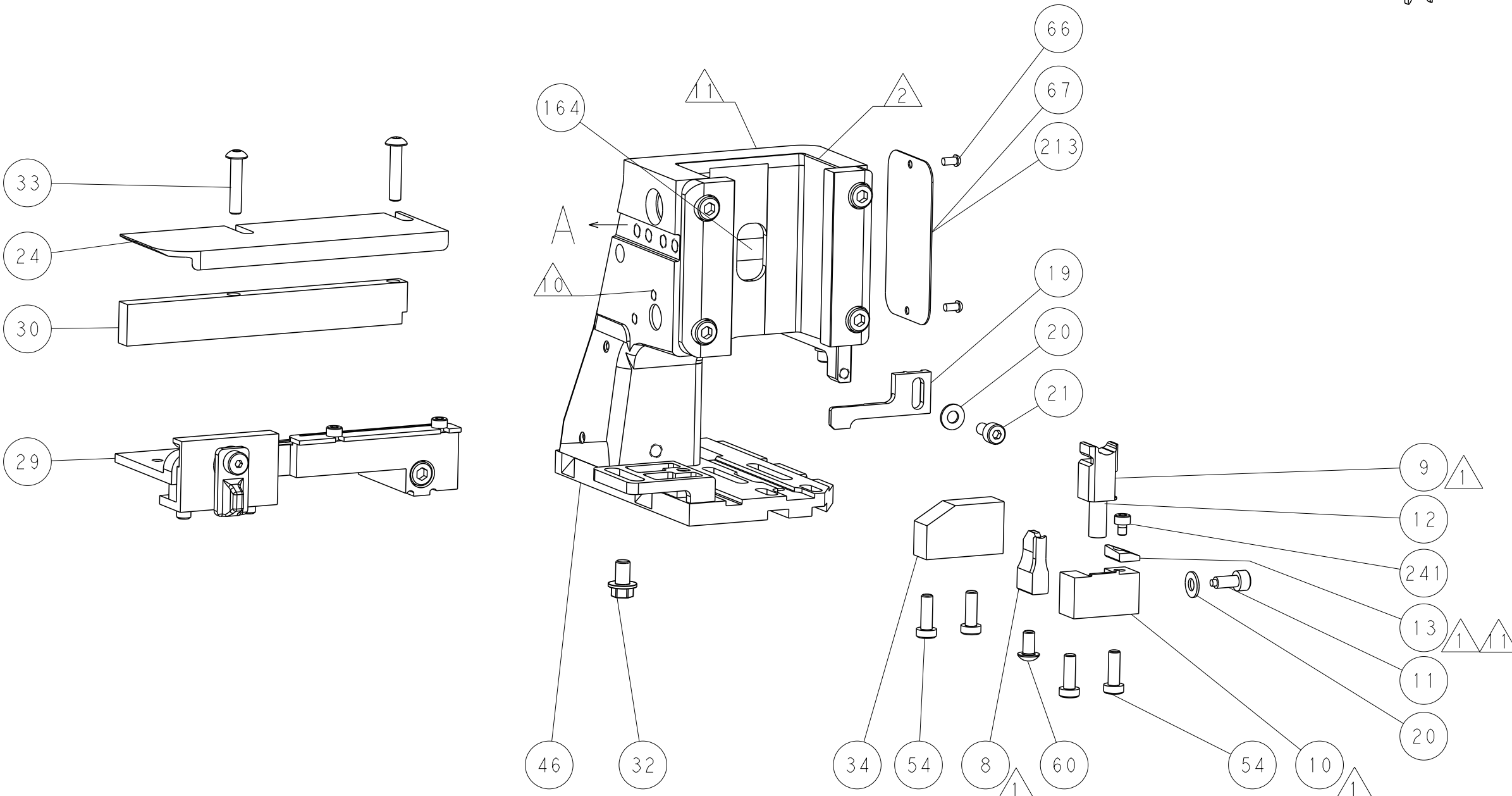
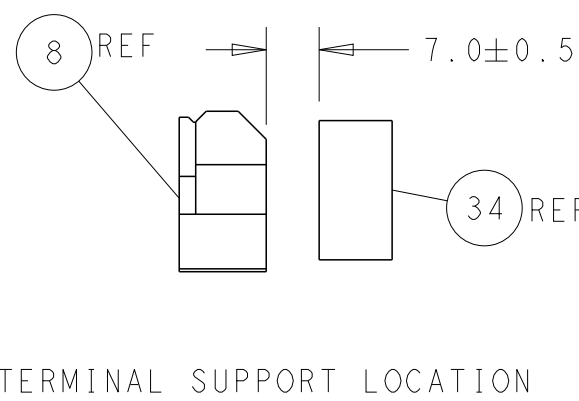
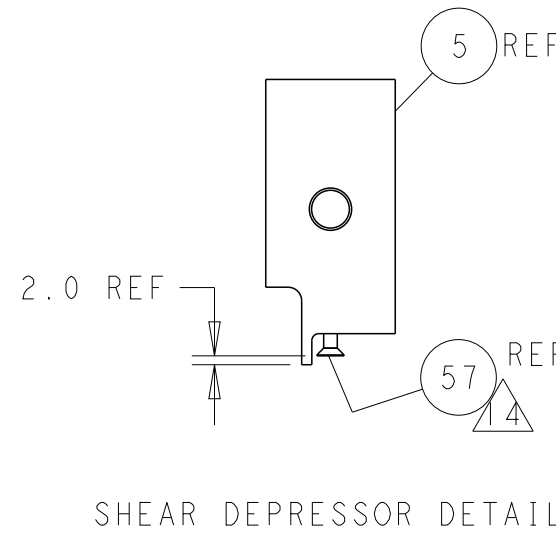
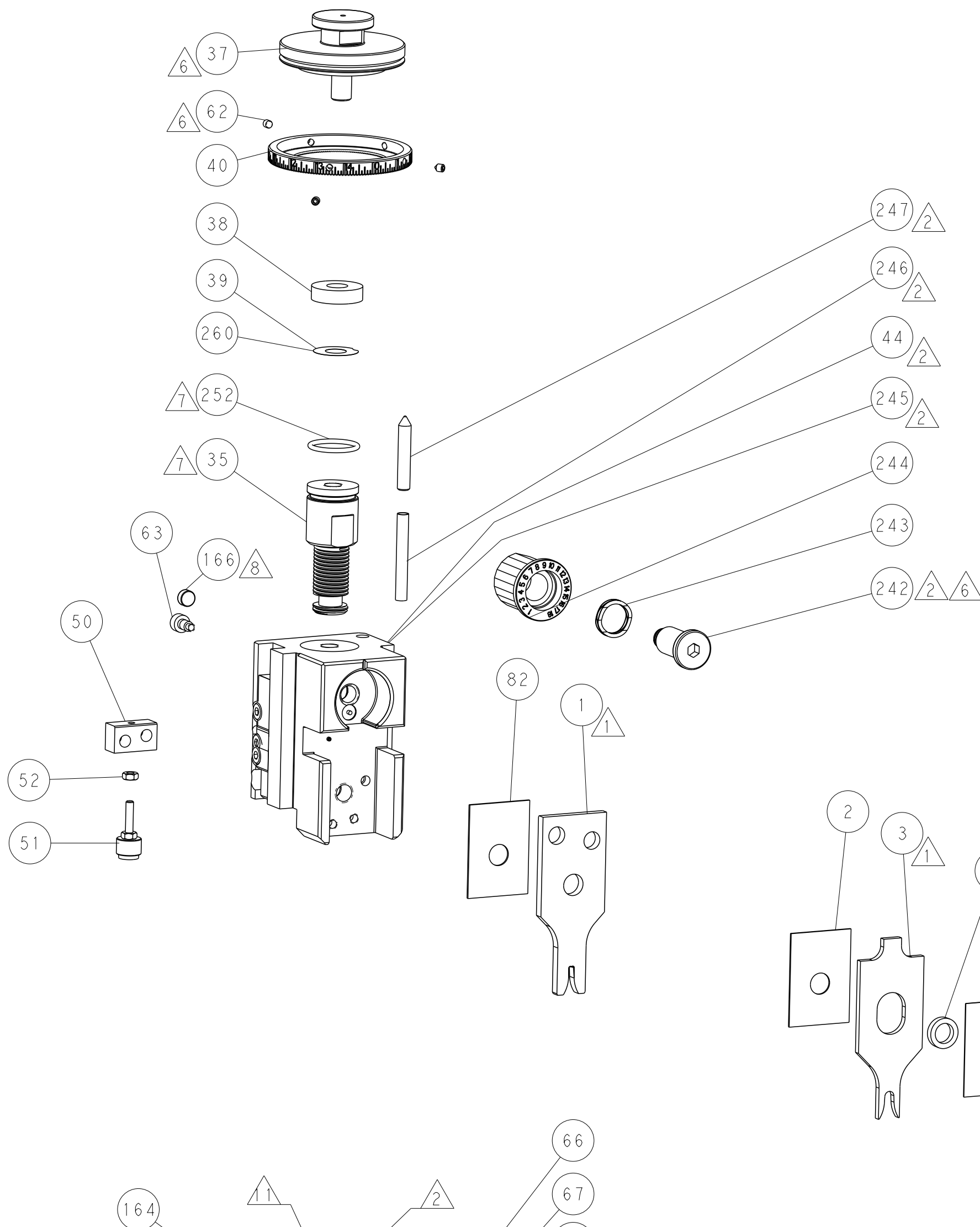
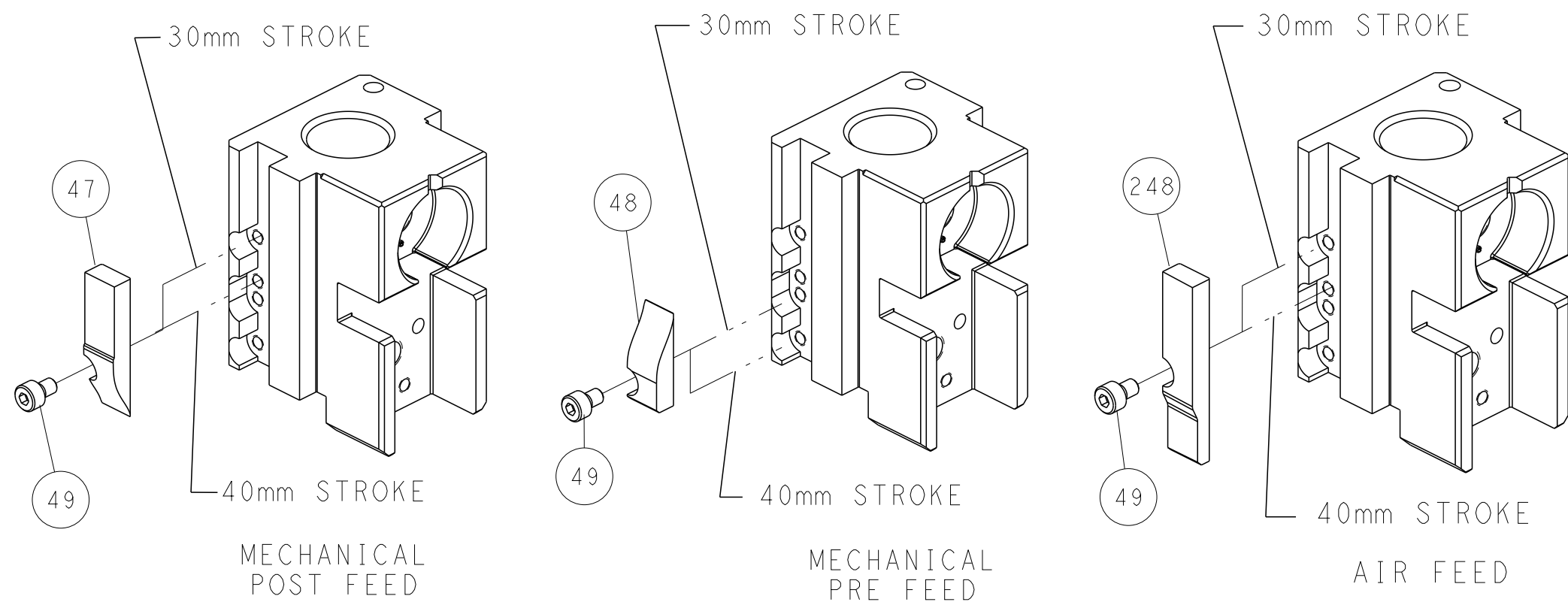
# PNEUMATIC



# SERVO LATCH PLATE

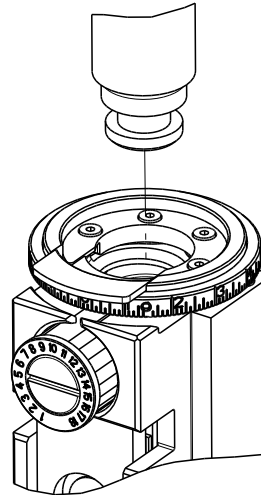


# CAM POSITIONS



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:<br>mm                                                                                                                                                                                                            |  |  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.1<br>1 PLC ±.1<br>2 PLC ±.1<br>3 PLC ±.1<br>4 PLC ±.1<br>ANGLES ±.1<br>FINISH |  |  |  | NAME<br>Ocean Side Feed<br>Applicator        |  |  |  |
| MATERIAL<br>-                                                                                                                                                                                                                |  |  |  | WEIGHT<br>-                                                                                                                     |  |  |  | SIZE<br>A1                                   |  |  |  |
| Customer Accessible Production Drawing                                                                                                                                                                                       |  |  |  | SCALE<br>1:2                                                                                                                    |  |  |  | SHEET<br>2 of 4                              |  |  |  |
|                                                                                                                                                                                                                              |  |  |  |                                                                                                                                 |  |  |  | REV<br>B                                     |  |  |  |

| <div>PACIFIC VERSION<br/>TERMINATOR<br/>INTERFACE ADAPTER</div>  | PART<br>NUMBER | REVISION | DESCRIPTION              | FEED TYPE                         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |   |
|--------------------------------------------------------------------------------------------------------------------------------------------------|----------------|----------|--------------------------|-----------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|---|
|                                                                                                                                                  |                |          |                          |                                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |   |
|                                                                                                                                                  |                |          |                          |                                   |                                   |                       |           |             |           |           |                        |   |
|                                                                                                                                                  | 2-2266732-1    | B        | 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             | -         | 8-2266732-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |   |
|                                                                                                                                                  |                |          |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266732-4 | -         | -         | -                      |   |
|                                                                                                                                                  | 2-2266732-2    | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                         | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |   |
|                                                                                                                                                  |                |          |                          |                                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266732-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |   |
|                                                                                                                                                  |                |          |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266732-4 | -         | -         | -                      |   |
|                                                                                                                                                  | 2-2266732-5    | B        | FINE CRIMP HEIGHT ADJUST | SERVO<br>LATCH PLATE <sup>4</sup> | 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              |   |
|                                                                                                                                                  | 2-2266732-7    | B        | FINE CRIMP HEIGHT ADJUST | NONE                              | -                                 | -                     | -         | -           | -         | -         | -                      | - |
|                                                                                                                                                  | 7-2266732-7    | A        | CRIMP TOOLING KIT        | -                                 | -                                 | -                     | -         | -           | -         | -         | -                      | - |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.08 mm [.082] | F    |
| INSUL                                | 4.06 mm [.160] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

|                                                                   |                     |                                                            |                 |                |
|-------------------------------------------------------------------|---------------------|------------------------------------------------------------|-----------------|----------------|
| TERMINAL DATA: ITT CANNON TERMINAL ITT CANNON CRIMP SPECIFICATION |                     |                                                            |                 |                |
| TERMINAL NAME: TERMINAL, SOCKET                                   |                     |                                                            |                 |                |
| WIRE STRIP LENGTH<br>4.89-5.65 mm [.193-.223 IN]                  |                     | INSULATION DIAMETER RANGE<br>Ø <sup>1</sup> / <sub>2</sub> |                 |                |
| TERMINAL APPLICATION SPECIFICATION                                | K031-8500-169 Rev G | -                                                          | -               | -              |
| TERMINALS APPLIED                                                 |                     |                                                            |                 |                |
| TE TERMINAL                                                       | ITT CANNON TERMINAL | TE SEAL                                                    | ITT CANNON SEAL | CABLE DIAMETER |
| 1949474-1                                                         | 121668-0125         | 1572322-1                                                  | 121668-0032     | Ø1.4-2.0       |
| 1949474-2                                                         | 121668-0022         |                                                            |                 |                |
| 1949474-3                                                         | 121668-0024         |                                                            |                 |                |

|                   |                            |                                |
|-------------------|----------------------------|--------------------------------|
| WIRE SIZE         | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
| 1.00mm2           | 1.45+/-0.03 [.057+/- .001] | 7.1                            |
| 18 AWG OR 0.75mm2 | 1.35+/-0.03 [.053+/- .001] | 8.2                            |
| 0.50mm2           | 1.26+/-0.03 [.050+/- .001] | 9.1                            |



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266732-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266732-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266732-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- <sup>8</sup> MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- <sup>13</sup> 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.
- <sup>14</sup> 18 AWG WIRE IS NOT LISTED ON TERMINAL MANUFACTURER SPECIFICATION.

\*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)

| SET UP GAUGE<br>2119599-1 |     | LOC<br>A    | DIST<br>66 | REVISIONS |     |      |   |
|---------------------------|-----|-------------|------------|-----------|-----|------|---|
| P                         | LYR | DESCRIPTION |            | DATE      | OWN | APVD |   |
| -                         | -   | SEE SHEET 1 |            | -         | -   | -    | - |
|                           |     |             |            |           |     |      |   |
|                           |     |             |            |           |     |      |   |

|   |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | 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   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| - | 1   | 1   | 1   | 1   | 2119082-4   | 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  | MEMORY CHIP, PROGRAMMED             | 135 |
| - | -   | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133 |
| - | -   | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY,SF             | 117 |
| - | 1   | 1   | 1   | 1   | 455888-6    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 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   | 1   | 1   | 985575-3    | SCR, FLT SKT HD CAP M3 X 10.0       | 57  |
| - | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 2   | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 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   | 1-2119644-2 | RAM WASHER, PRECISION               | 38  |
| - | 1   | 1   | 1   | 1   | 1-1752356-7 | 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   | 1-1320908-0 | SPACER, STRIP GUIDE                 | 30  |
| - | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28  |
| - | 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  |
| - | 2   | 2   | 2   | 2   | 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   | 318707-1    | FLOATING SHEAR, FRONT               | 9   |
| 1 | 1   | 1   | 1   | 1   | 3-1803171-8 | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 2-2119781-4 | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 238011-9    | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 1   | 1   | 1   | 1   | 3-2119784-1 | CRIMPER, INSULATION O PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2   |
| 1 | 1   | 1   | 1   | 1   | 3-1490019-5 | CRIMPER, WIRE PREMIUM               | 1   |

|                                                                                                                                                                                                       |  |                                                                                                           |  |                                                                                             |  |                                                                                                                                    |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|
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| DIMENSIONS:<br>mm                                                                                                                                                                                     |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ± |  | NAME<br>Ocean Side Feed<br>Applicator                                                       |  | SIZE<br>A1                                                                                                                         |  |
|                                                                                                                  |  | APPLICATION SPEC                                                                                          |  | PRODUCT SPEC                                                                                |  | CAGE CODE<br>00779                                                                                                                 |  |
| MATERIAL                                                                                                                                                                                              |  | FINISH                                                                                                    |  | WEIGHT                                                                                      |  | DRAWING NO<br>C=2266732                                                                                                            |  |
| Customer Accessible Production Drawing                                                                                                                                                                |  |                                                                                                           |  | SCALE<br>1:2                                                                                |  | SHEET<br>3                                                                                                                         |  |
|                                                                                                                                                                                                       |  |                                                                                                           |  | OF<br>4                                                                                     |  | REV<br>B                                                                                                                           |  |

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

D

C

B

A

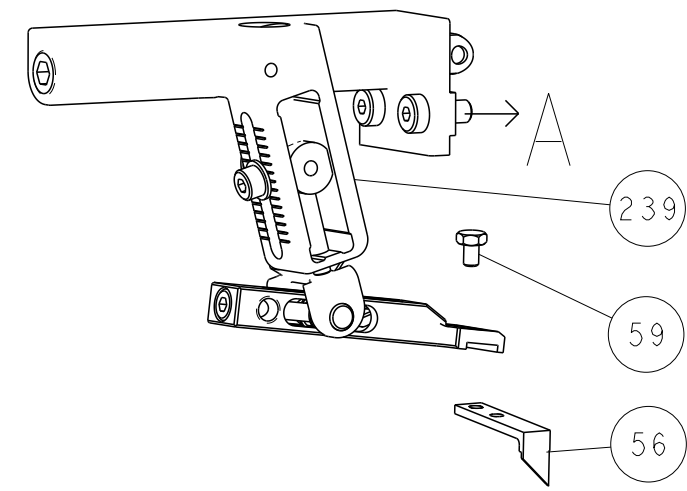
D

C

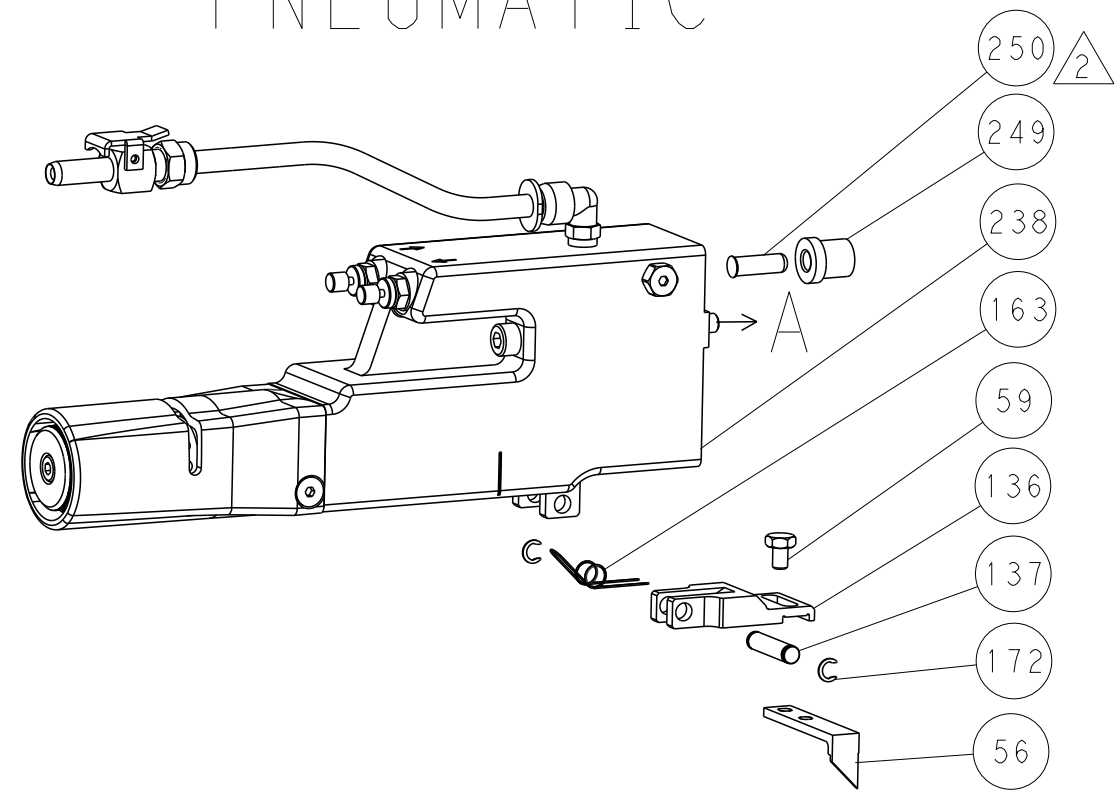
B

A

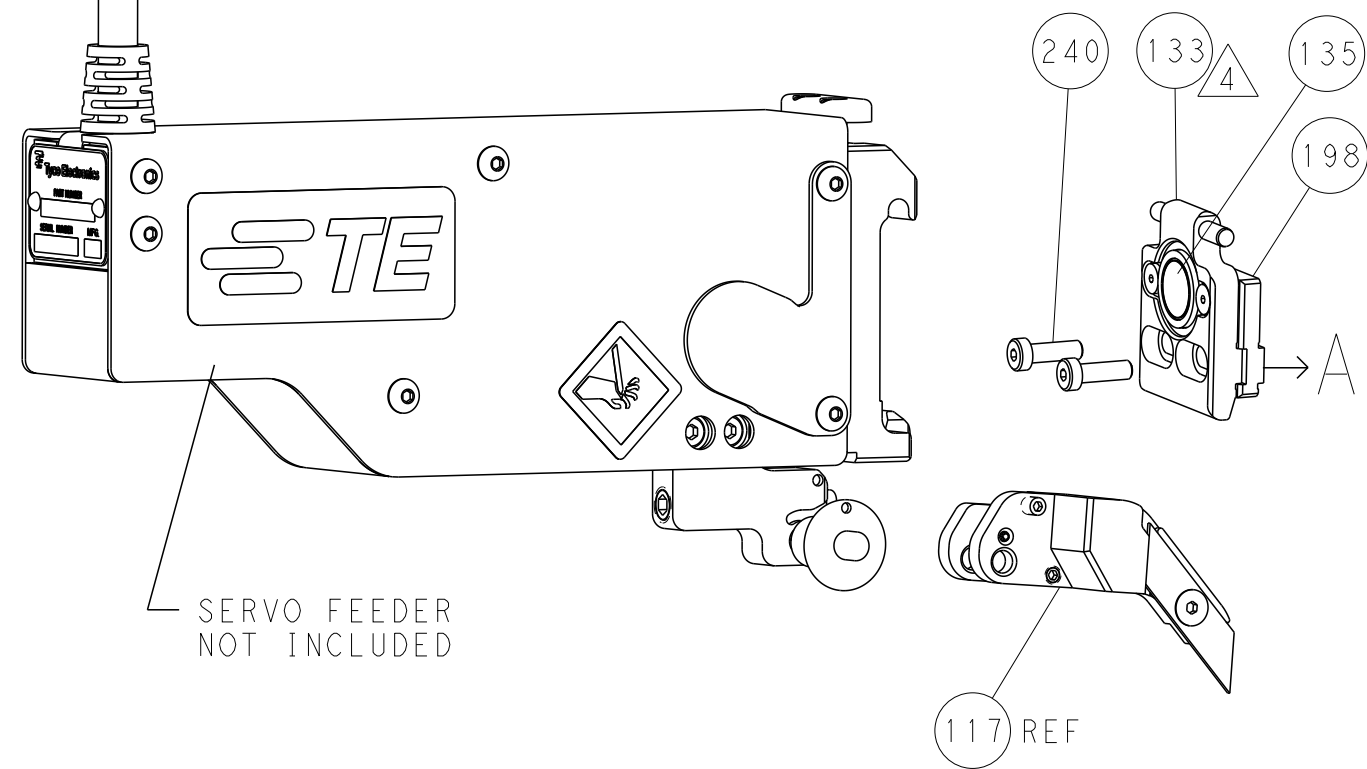
## FEED TYPE MECHANICAL



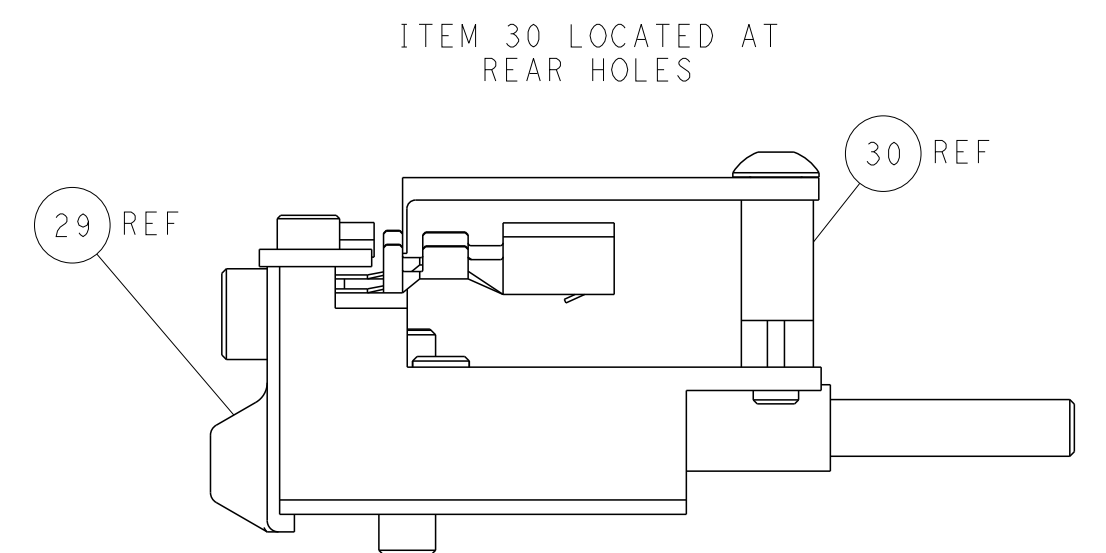
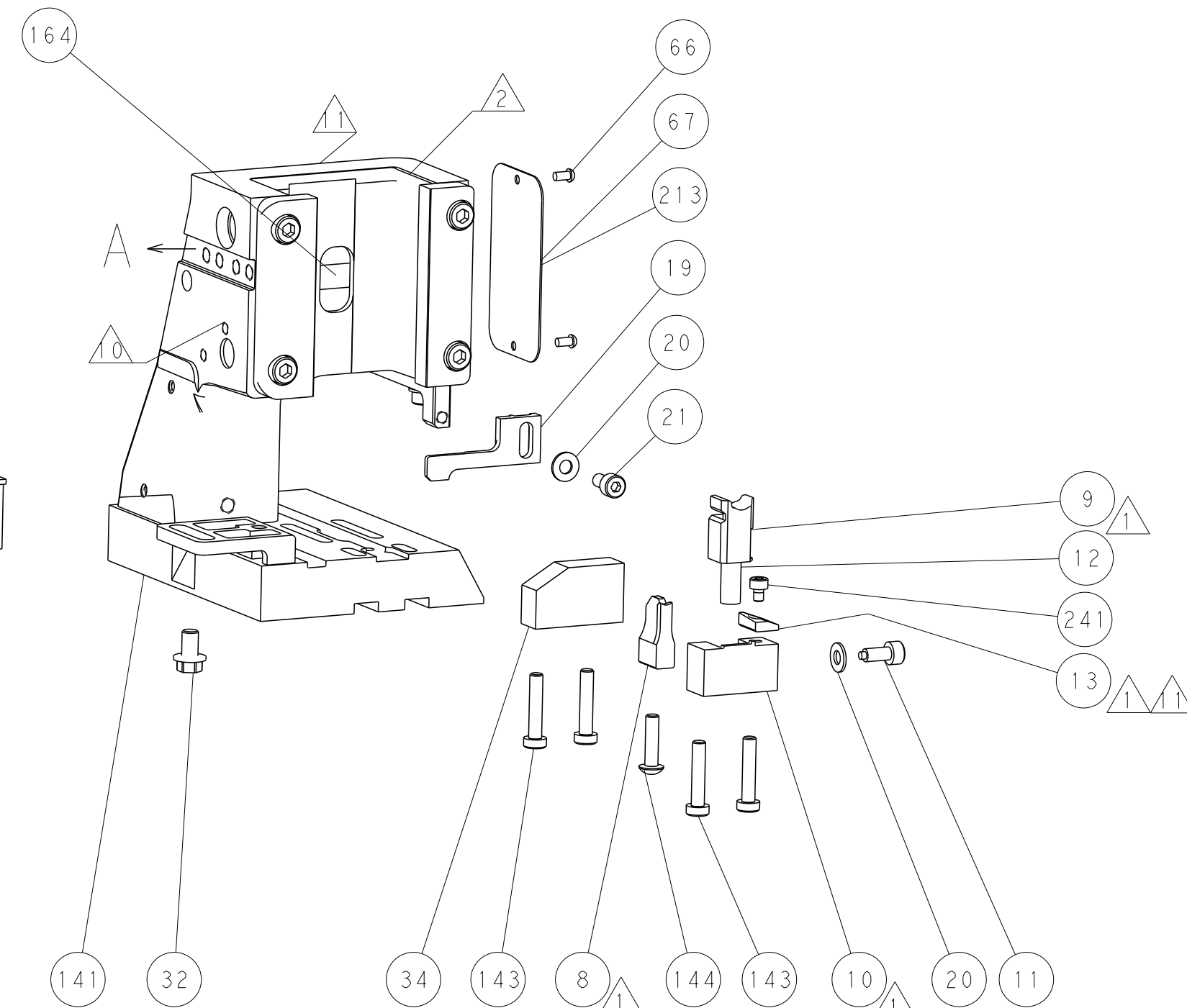
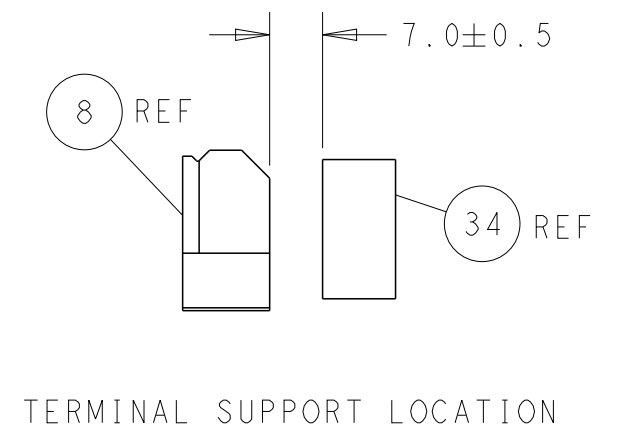
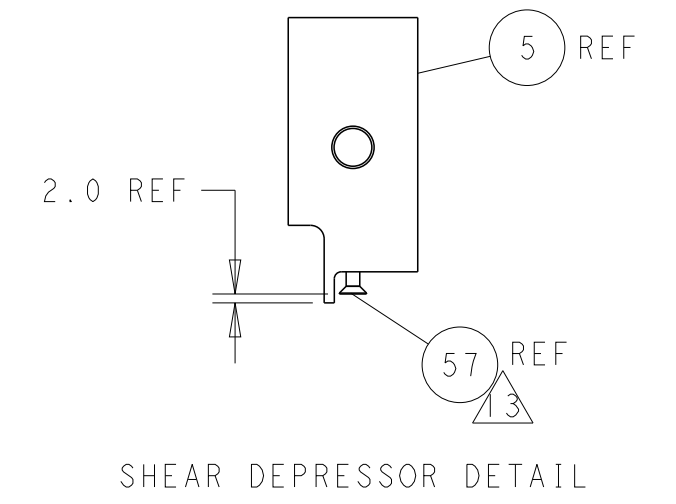
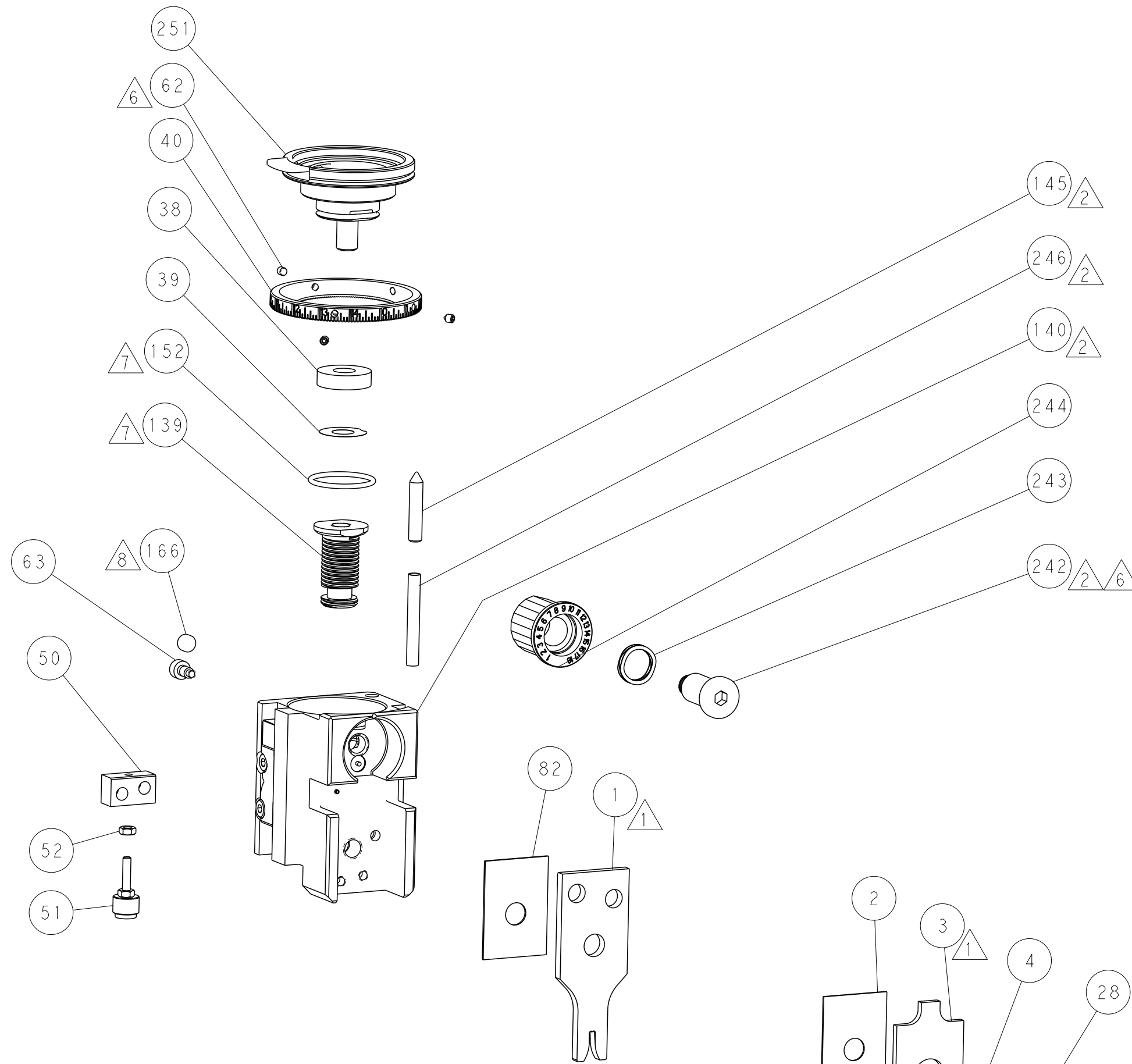
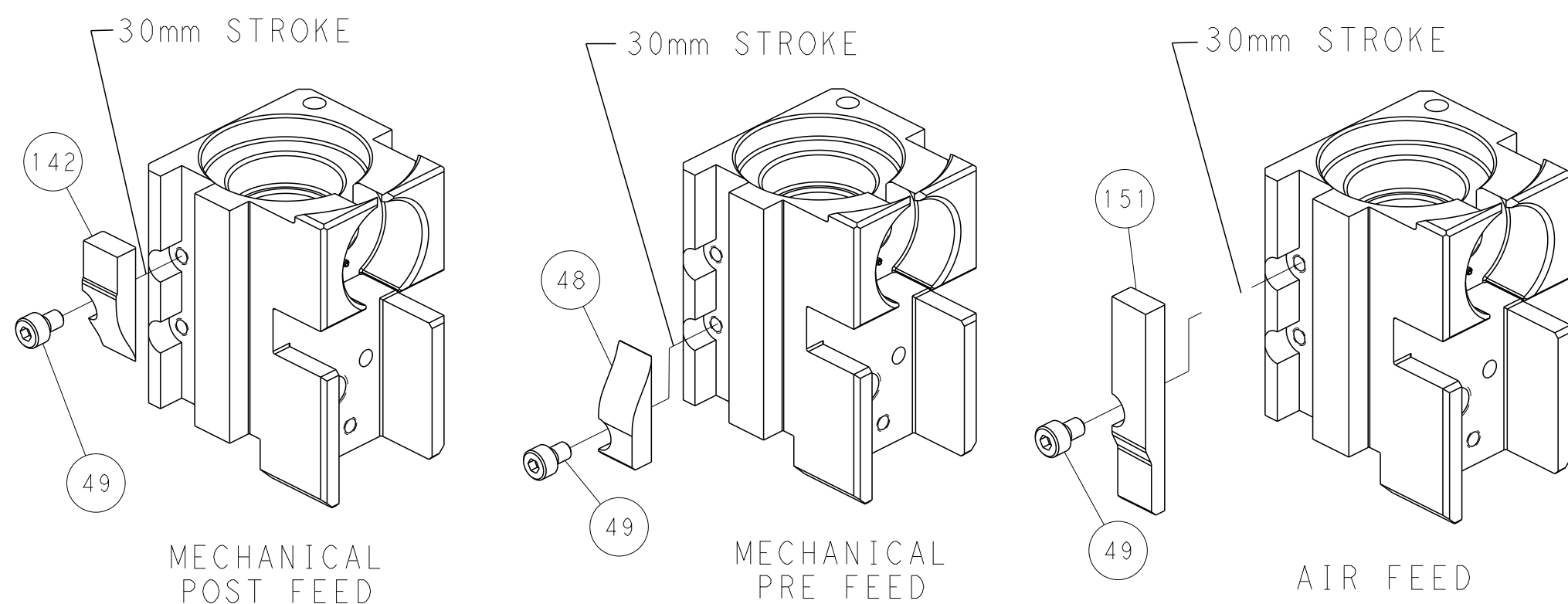
## PNEUMATIC



## 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)

|                                                                                                                                                                                              |  |  |  |                              |  |  |  |                                              |  |  |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|------------------------------|--|--|--|----------------------------------------------|--|--|--|
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| CHK<br>L. ZHANG<br>23MAR2015                                                                                                                                                                 |  |  |  | NAME                         |  |  |  | Ocean Side Feed<br>Applicator                |  |  |  |
| APVD<br>J. GUO<br>23MAR2015                                                                                                                                                                  |  |  |  | PRODUCT SPEC                 |  |  |  | SIZE                                         |  |  |  |
| APPLICATION SPEC                                                                                                                                                                             |  |  |  | CAGE CODE                    |  |  |  | DRAWING NO                                   |  |  |  |
| MATERIAL                                                                                                                                                                                     |  |  |  | WEIGHT                       |  |  |  | A1 00779 C=2266732                           |  |  |  |
| Customer Accessible Production Drawing                                                                                                                                                       |  |  |  | SCALE                        |  |  |  | 1:2 SHEET 4 OF 4 REV B                       |  |  |  |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION