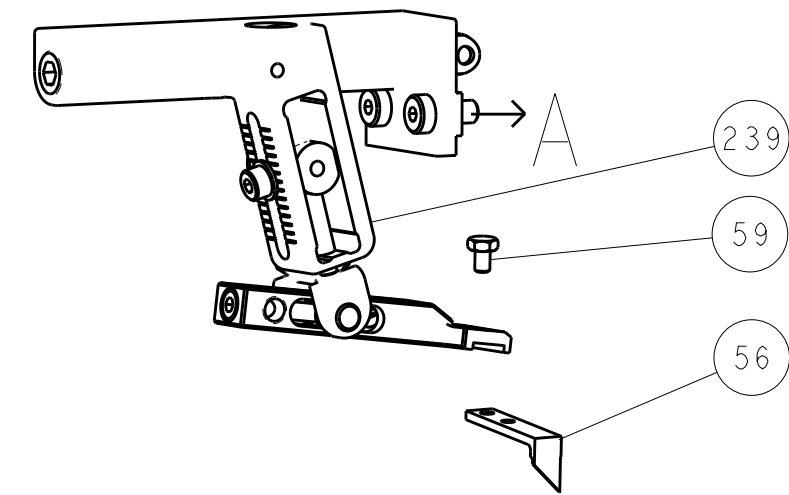


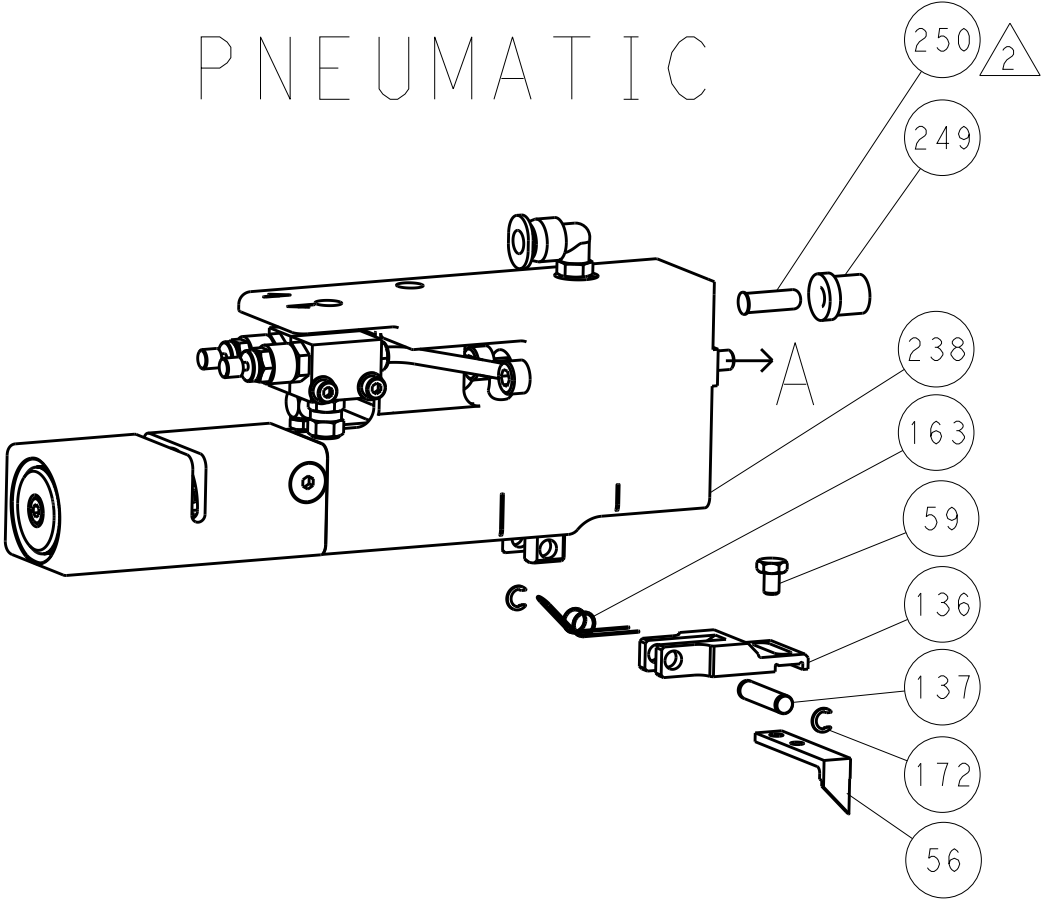


| LOC |     | DIST        |  | REVISONS |     |      |  |
|-----|-----|-------------|--|----------|-----|------|--|
| P   | LTR | DESCRIPTION |  | DATE     | DWN | APVD |  |
| -   | -   | SEE SHEET 1 |  | -        | -   | -    |  |
|     |     |             |  |          |     |      |  |
|     |   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

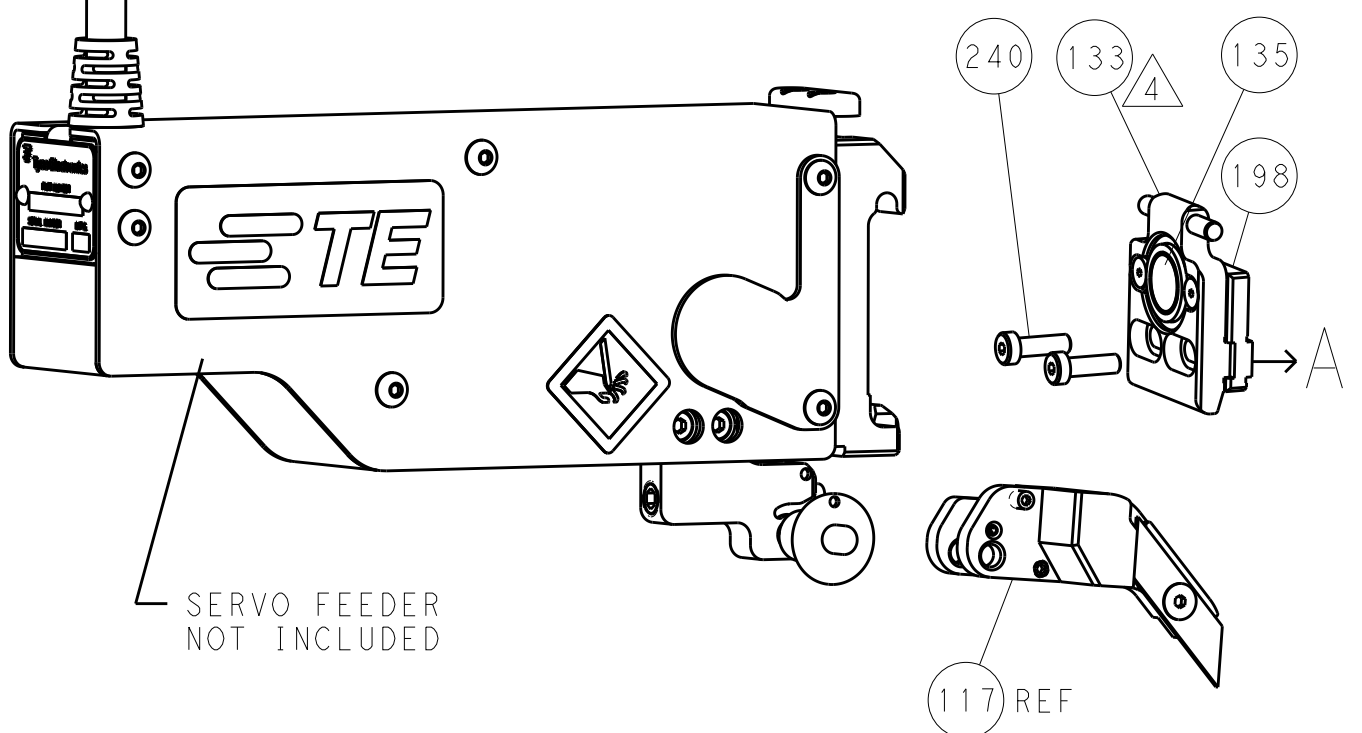
# FEED TYPE MECHANICAL



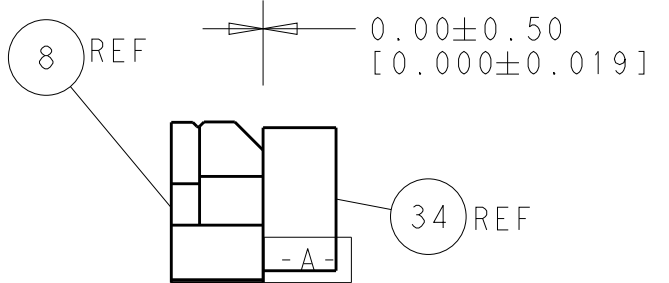
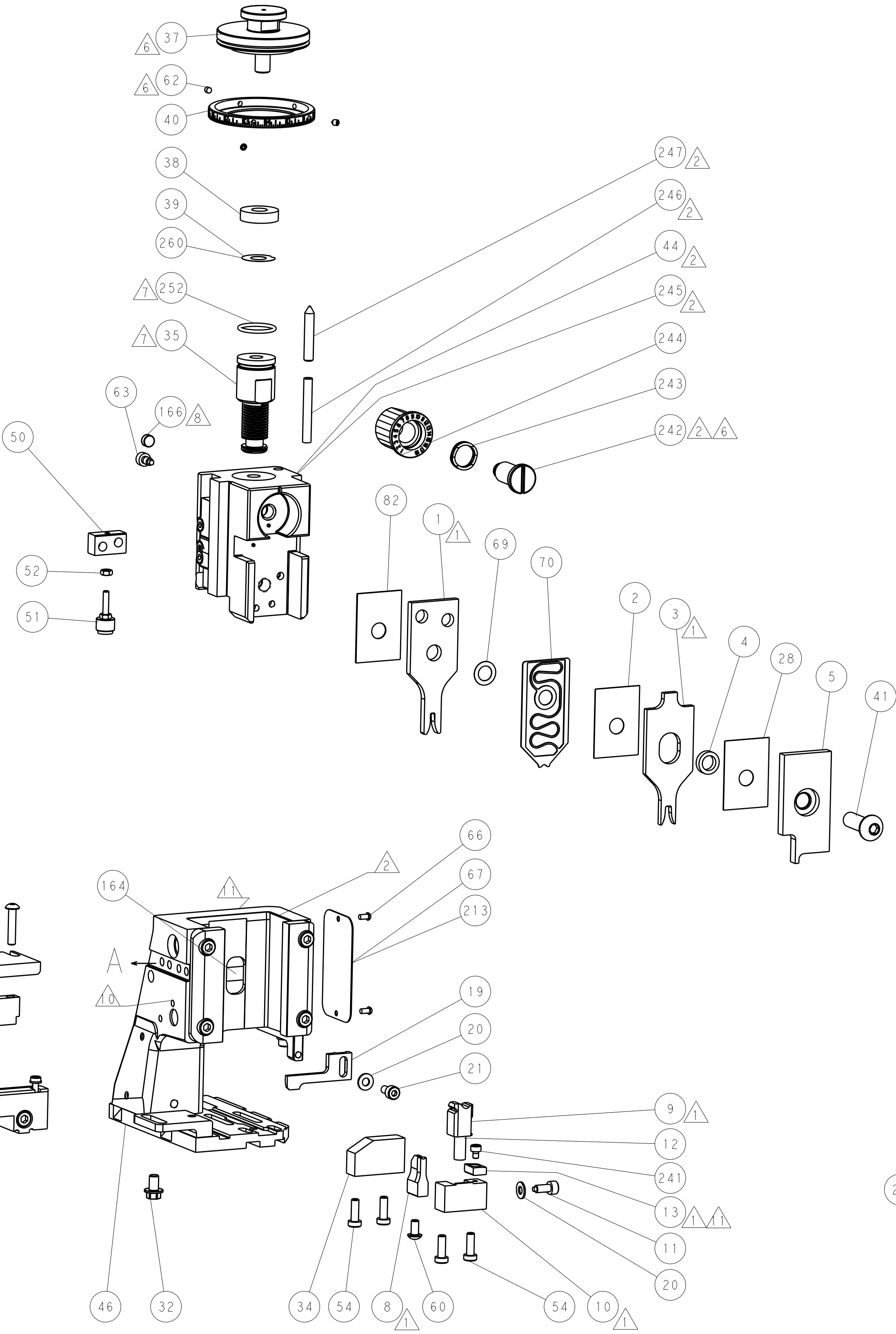
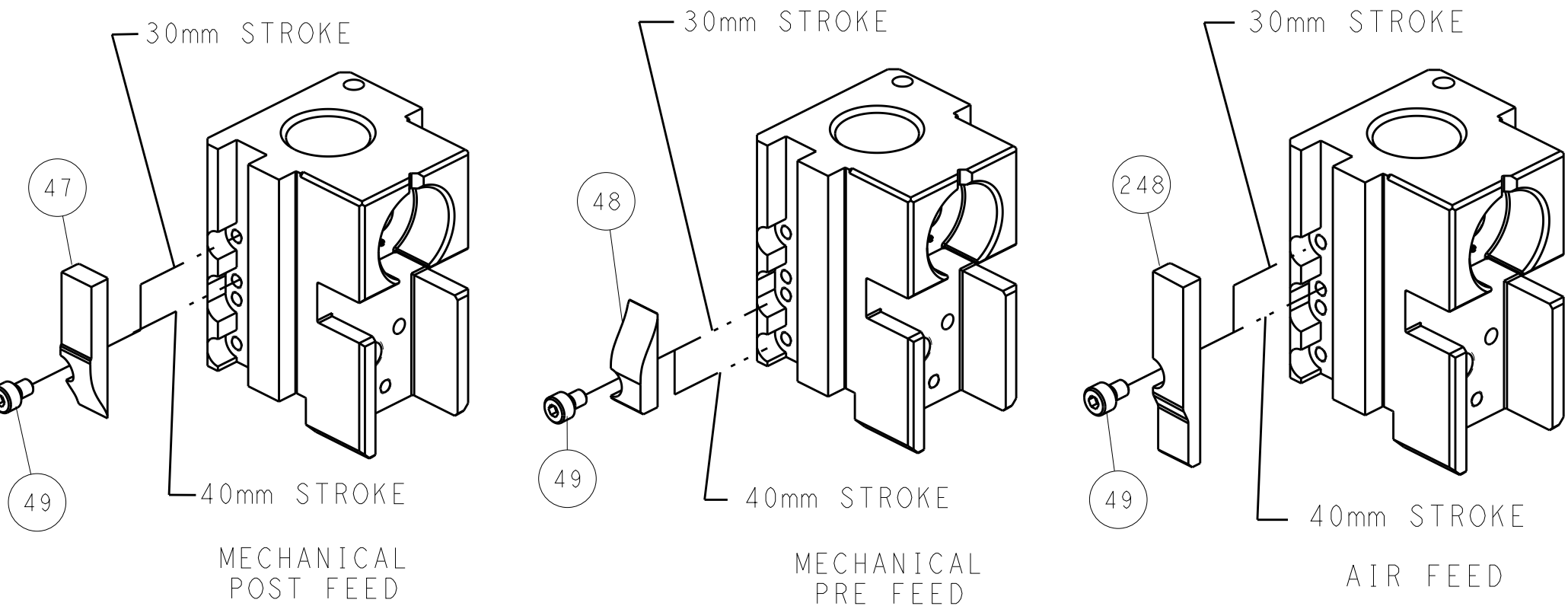
# PNEUMATIC



# SERVO LATCH PLATE

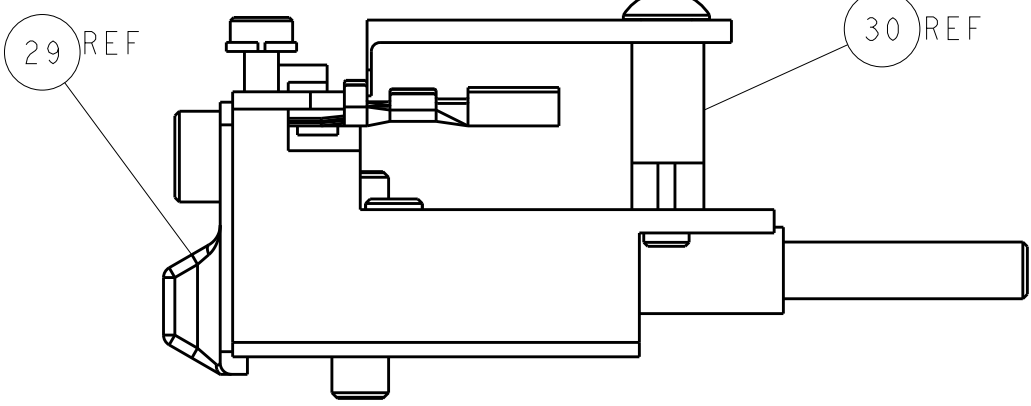


# CAM POSITIONS



TERMINAL SUPPORT LOCATION

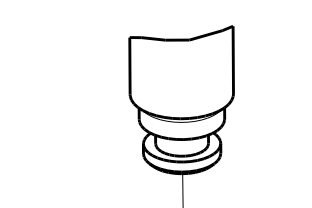
ITEM 30 LOCATED AT  
FRONT HOLES



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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

|             |  |                                           |  |          |  |                                        |  |        |  |                               |  |       |  |           |  |            |  |               |  |
|-------------|--|-------------------------------------------|--|----------|--|----------------------------------------|--|--------|--|-------------------------------|--|-------|--|-----------|--|------------|--|---------------|--|
| DIMENSIONS: |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED: |  | DWN      |  | CHK                                    |  | APVD   |  | NAME                          |  | SIZE  |  | CAGE CODE |  | DRAWING NO |  | RESTRICTED TO |  |
| mm          |  | 0 PLC ±0.5                                |  | K. HUANG |  | L. ZHANG                               |  | J. GUO |  | Ocean Side Feed<br>Applicator |  | A1    |  | 00779     |  | C=2266327  |  | -             |  |
| MATERIAL    |  | FINISH                                    |  | WEIGHT   |  | Customer Accessible Production Drawing |  | SCALE  |  | 1:2                           |  | SHEET |  | 2         |  | OF 4       |  | REV           |  |
|             |  |                                           |  |          |  |                                        |  |        |  |                               |  |       |  |           |  |            |  |               |  |

| <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 |           |             |           |           |                        |
|                                                                                                                                                  |                |                   |                          |                                   |                                   |                       |           |             |           |           |                        |
|                                                                                                                                                  | 2-2266327-1    | 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             | -         | 8-2266327-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|                                                                                                                                                  |                |                   |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266327-4 | -         | -         | -                      |
|                                                                                                                                                  | 2-2266327-2    | A                 | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                         | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|                                                                                                                                                  |                |                   |                          |                                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266327-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|                                                                                                                                                  |                |                   |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266327-4 | -         | -         | -                      |
|                                                                                                                                                  | 2-2266327-5    | A                 | 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              |
|                                                                                                                                                  | 2-2266327-7    | A                 | FINE CRIMP HEIGHT ADJUST | NONE                              | -                                 | -                     | -         | -           | -         | -         | -                      |
| 7-2266327-7                                                                                                                                      | A              | CRIMP TOOLING KIT | -                        | -                                 | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA <sup>12</sup>                      |                |      |
|----------------------------------------------------|----------------|------|
| CRIMP                                              | SIZE           | TYPE |
| WIRE                                               | 2.24 mm [.088] | F    |
| INSUL                                              | 3.56 mm [.140] | F    |
| APPLICATOR INSTRUCTIONS <sup>10</sup><br>408-10389 |                |      |

|                                                                |                      |                                                           |                      |
|----------------------------------------------------------------|----------------------|-----------------------------------------------------------|----------------------|
| TERMINAL DATA: SHIEY JOUNG TERMINAL TE CRIMP SPECIFICATION     |                      |                                                           |                      |
| TERMINAL NAME: TERMINAL                                        |                      |                                                           |                      |
| WIRE STRIP LENGTH <sup>11</sup><br>4.34-5.11 mm [.171-.201 IN] |                      | INSULATION DIAMETER RANGE<br>Ø2.38-3.17 mm [.094-.125 IN] |                      |
| TERMINAL APPLICATION SPECIFICATION <sup>10</sup>               | NONE                 | -                                                         | -                    |
| TERMINALS APPLIED                                              |                      |                                                           |                      |
| TE TERMINAL                                                    | SHIEY JOUNG TERMINAL | TE TERMINAL                                               | SHIEY JOUNG TERMINAL |
| 2113475-1                                                      | 84111                |                                                           |                      |

|           |  |                            |  |                                             |
|-----------|--|----------------------------|--|---------------------------------------------|
| WIRE SIZE |  | CRIMP HEIGHT mm [INCH]     |  | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
| 16 AWG    |  | 1.40+/-0.05 [.055+/-0.002] |  | 3.1                                         |
| 18 AWG    |  | 1.11+/-0.05 [.044+/-0.002] |  | 11.5                                        |



- RECOMMENDED SPARE PARTS

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: 8-2266327-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266327-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266327-5

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.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.

7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

8

MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

9

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

10

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12

CRIMP WIDTH IS PROVIDED BY CUSTOMER.

\*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)

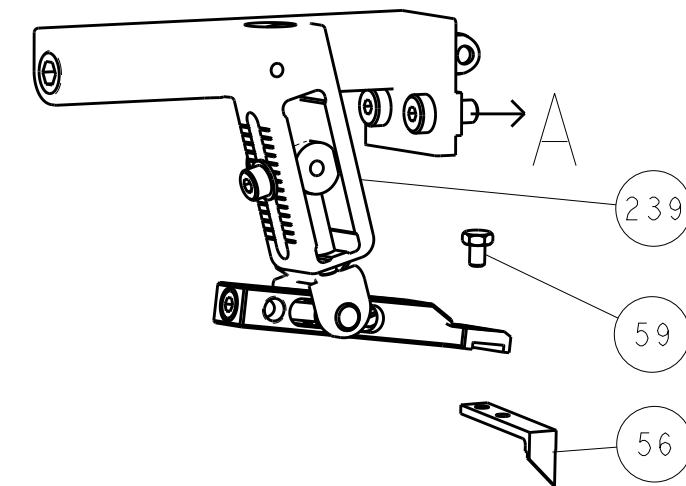
| SET UP GAUGE<br>2119599-1 | LOC<br>A | DIS<br>66 | REVISIONS |     |             |      |     |      |
|---------------------------|----------|-----------|-----------|-----|-------------|------|-----|------|
|                           |          |           | P         | LTR | DESCRIPTION | DATE | DWN | APVD |
|                           |          |           | -         | -   | SEE SHEET 1 | -    | -   | -    |
|                           |          |           |           |     |             |      |     |      |
|                           |          |           |           |     |             |      |     |      |

|   |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | -   | 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   | 455888-5    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 1   | 1   | 2119791-9   | DEPRESSOR, WIRE                     | 70  |
| - | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69  |
| - | 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   | 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   | 3-1752356-3 | 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   | 1320928-2   | 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   | 1803095-1   | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 8-1633927-7 | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 2119757-4   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 2-238011-1  | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 2-1633961-3 | CRIMPER, INSULATION F PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1   | 1   | 9-1633609-6 | CRIMPER, WIRE                       | 1   |

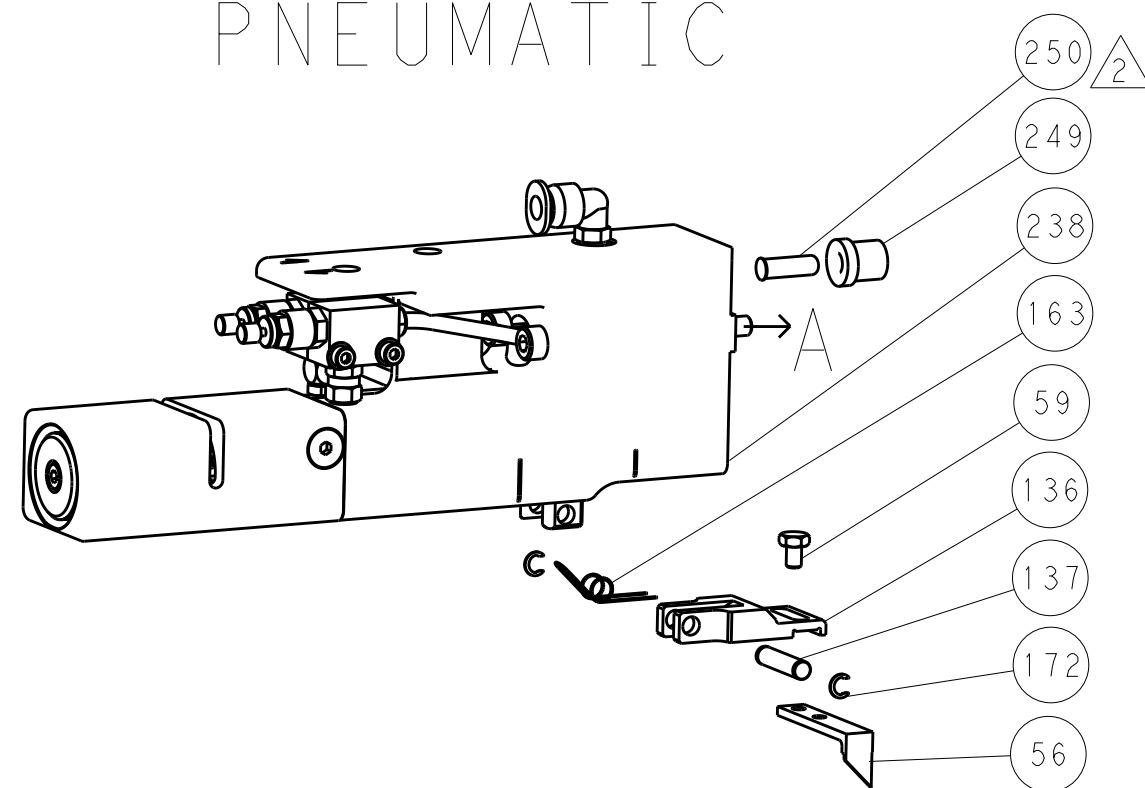
|                                                                                                               |  |  |  |                              |                                              |  |  |  |
|---------------------------------------------------------------------------------------------------------------|--|--|--|------------------------------|----------------------------------------------|--|--|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE CONTACTED FOR THE LATEST REVISION. |  |  |  | DWN<br>R. HUANG<br>12JUN2014 | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |  |  |
| DIMENSIONS:<br>mm                                                                                             |  |  |  | CHK<br>L. ZHANG<br>12JUN2014 | NAME<br>Ocean Side Feed<br>Applicator        |  |  |  |
|                                                                                                               |  |  |  | APVD<br>J. GUO<br>12JUN2014  | PRODUCT SPEC                                 |  |  |  |
|                                                                                                               |  |  |  |                              | APPLICATION SPEC                             |  |  |  |
| MATERIAL<br>-                                                                                                 |  |  |  |                              | WEIGHT<br>-                                  |  |  |  |
|                                                                                                               |  |  |  |                              | FINISH<br>-                                  |  |  |  |
|                                                                                                               |  |  |  |                              | Customer Accessible Production Drawing       |  |  |  |
|                                                                                                               |  |  |  |                              | SCALE<br>1:2                                 |  |  |  |
|                                                                                                               |  |  |  |                              | SHEET<br>3 of 4                              |  |  |  |
|                                                                                                               |  |  |  |                              | REV<br>A                                     |  |  |  |

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

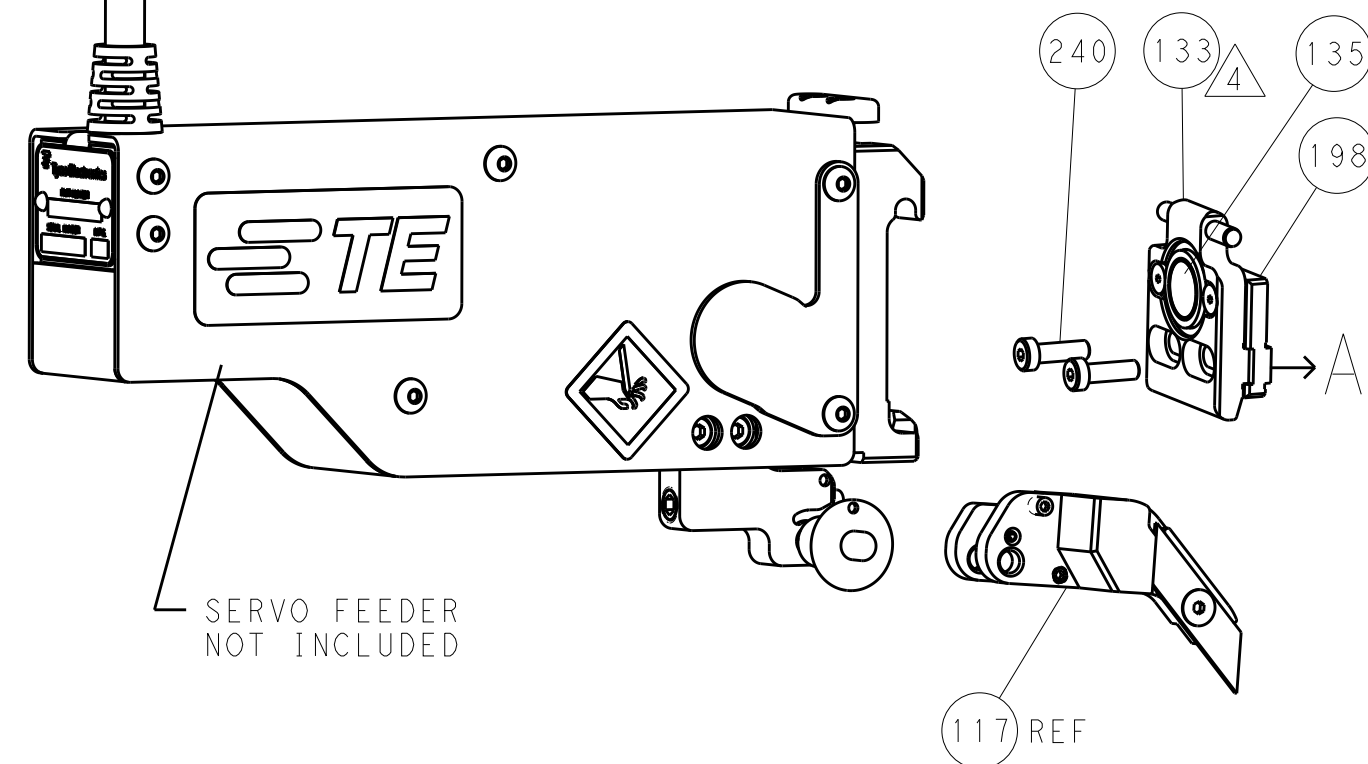
FEED TYPE  
MECHANICAL



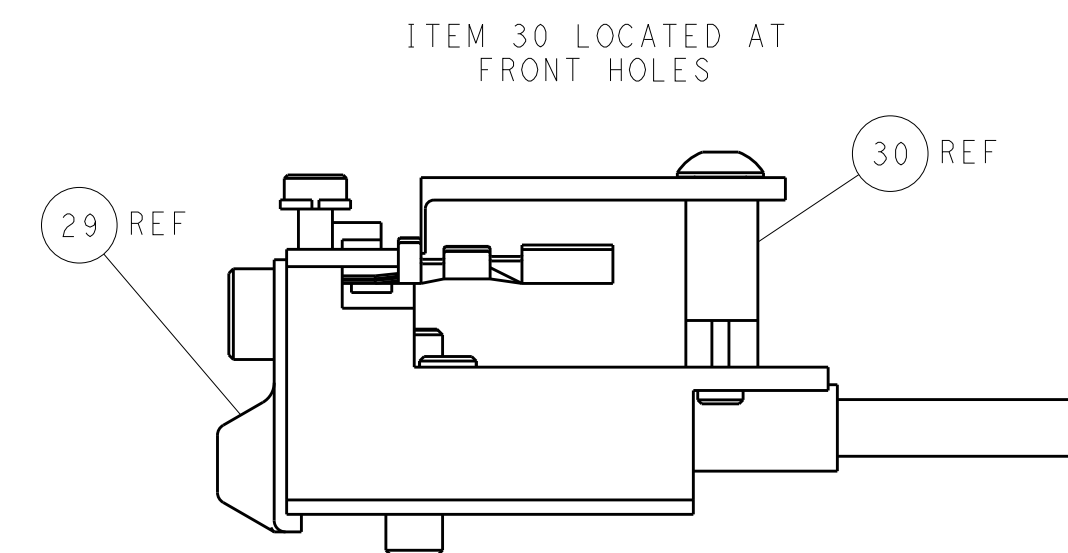
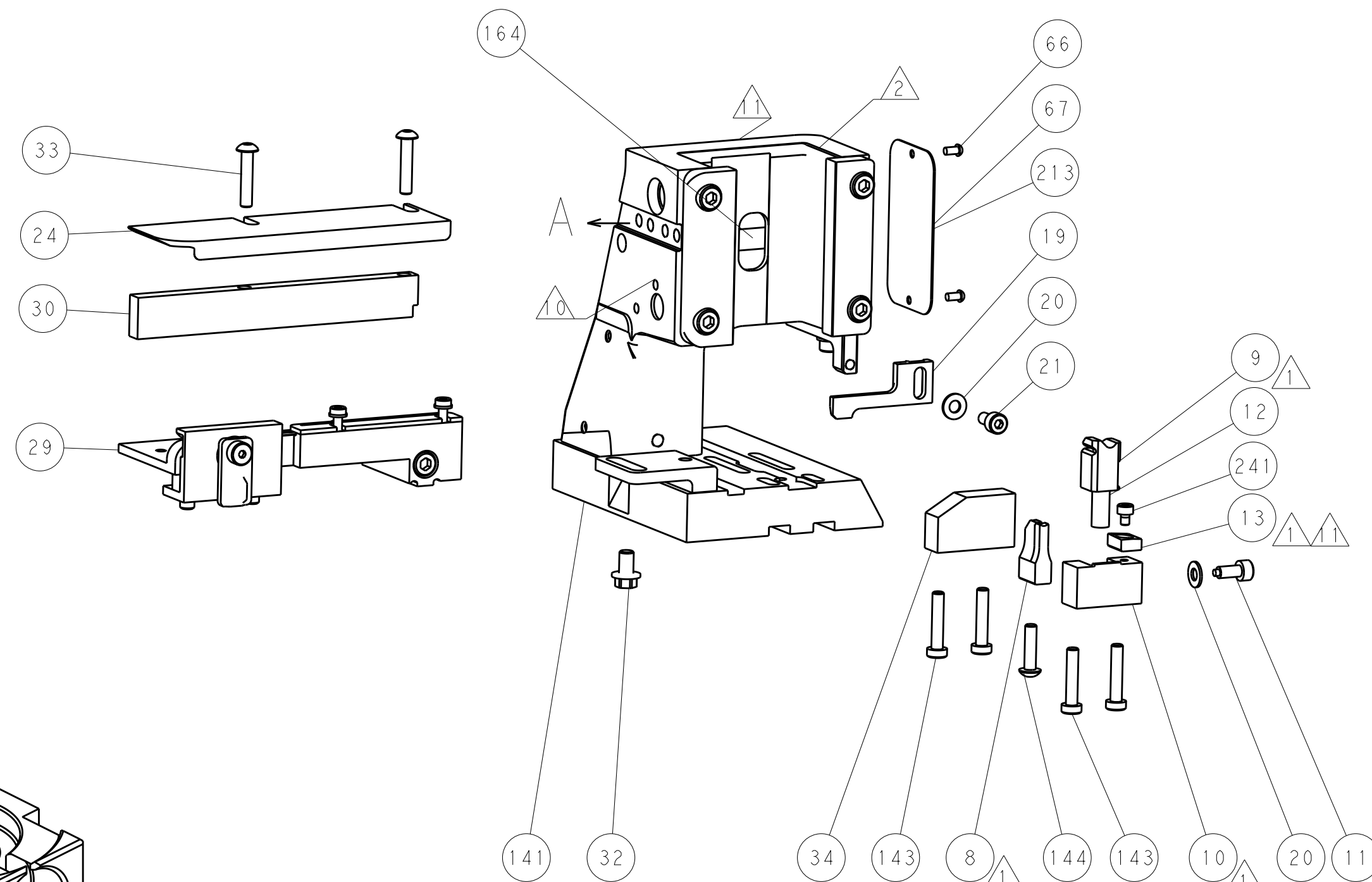
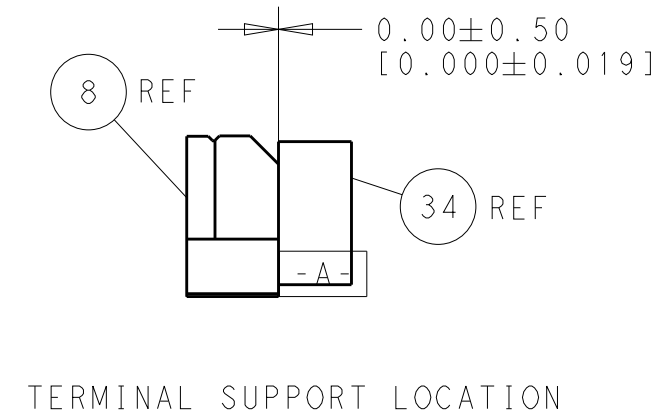
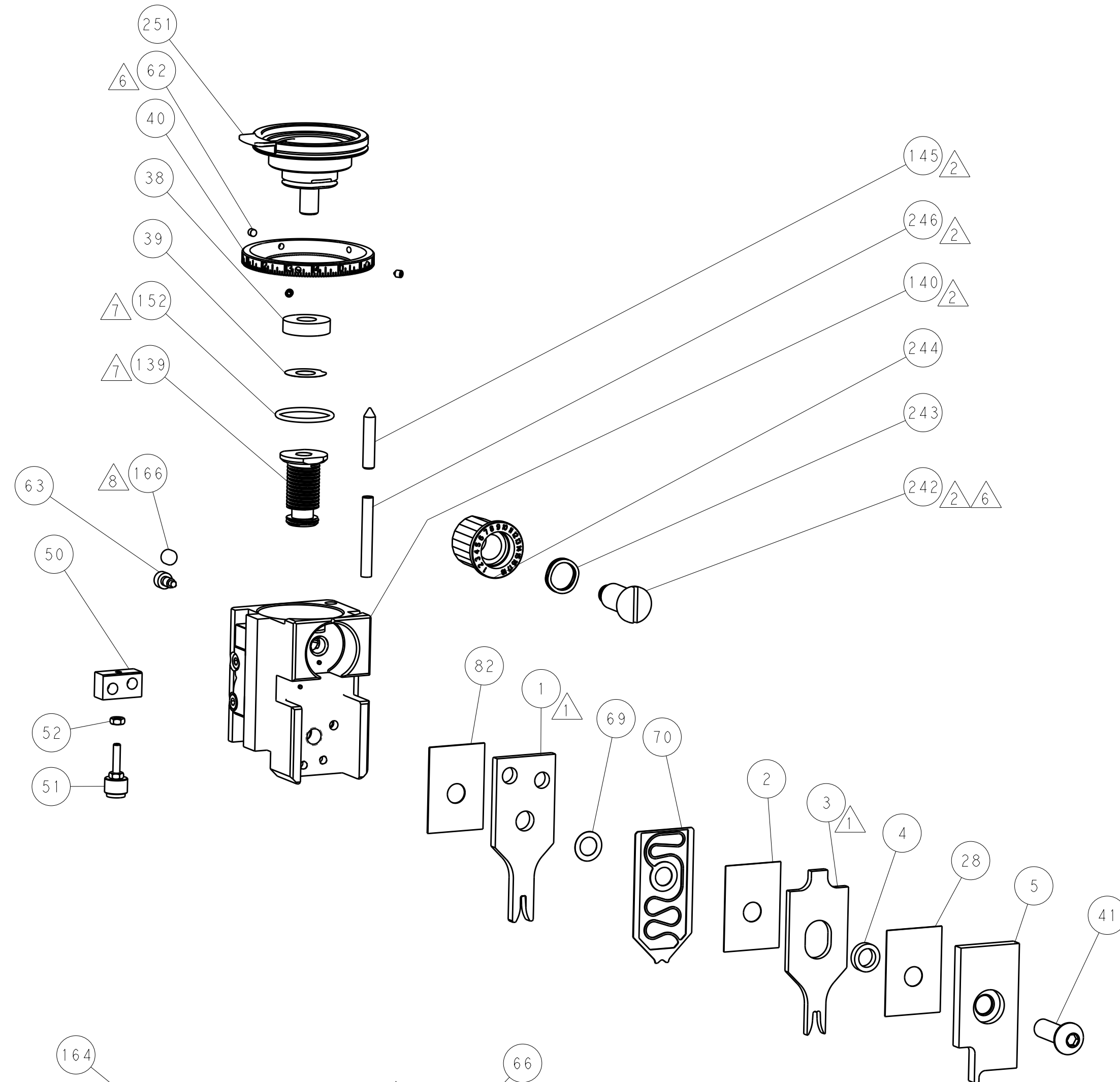
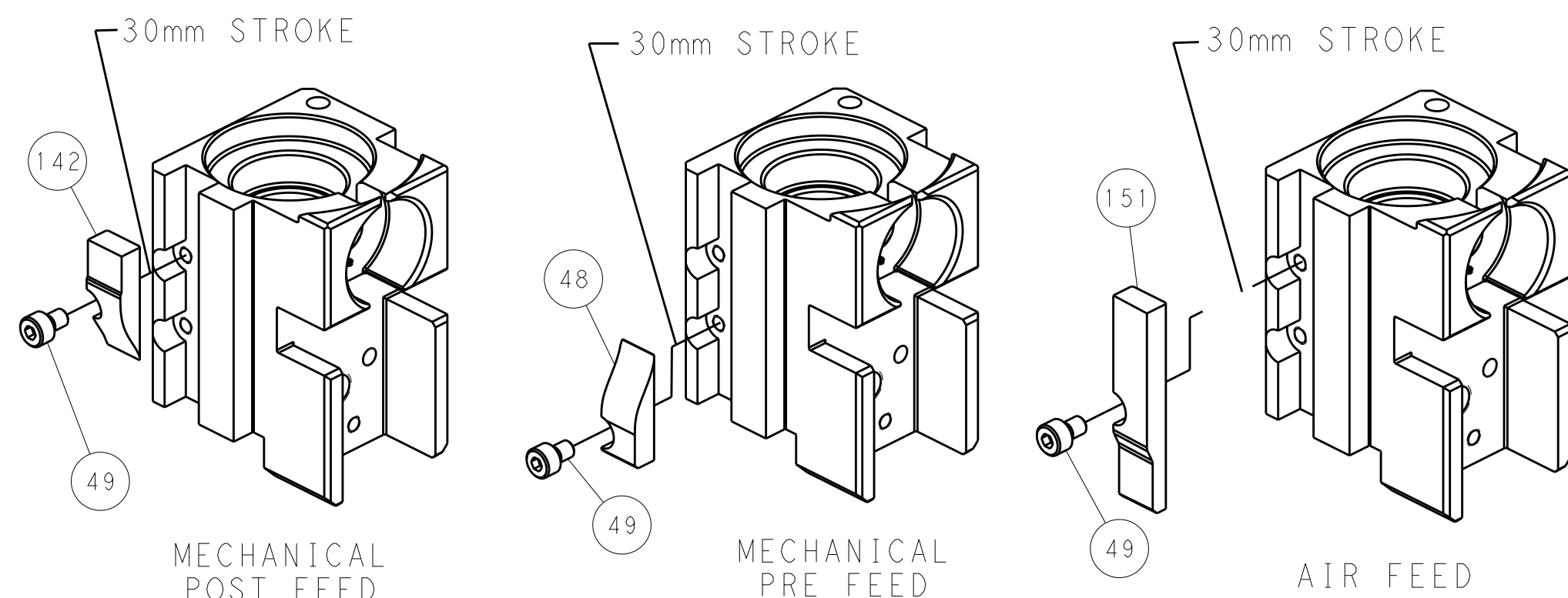
PNEUMATIC



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)

|             |  |                                        |  |                                        |  |              |  |        |  |                            |  |
|-------------|--|----------------------------------------|--|----------------------------------------|--|--------------|--|--------|--|----------------------------|--|
| DIMENSIONS: |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DWN                                    |  | CHK          |  | APVD   |  | NAME                       |  |
| mm          |  | 0 PLC ±0.5                             |  | K. HUANG                               |  | L. ZHANG     |  | J. GUO |  | Ocean Side Feed Applicator |  |
| 1 PLC ±0.13 |  | 2 PLC ±0.13                            |  | 3 PLC ±0.13                            |  | 4 PLC ±0.001 |  | ANGLES |  | SIZE                       |  |
| FINISH      |  | WEIGHT                                 |  | Customer Accessible Production Drawing |  | SCALE        |  | SHEET  |  | REV                        |  |
| -           |  | -                                      |  | -                                      |  | -            |  | -      |  | -                          |  |
| -           |  | -                                      |  | -                                      |  | -            |  | -      |  | -                          |  |