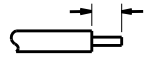
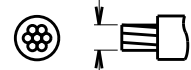


|                                                                                  |                |                          |                          |
|----------------------------------------------------------------------------------|----------------|--------------------------|--------------------------|
| 8                                                                                |                | 7                        |                          |
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| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              | PART<br>NUMBER | REVISION                 | DESCRIPTION              |
|  | 2151275-1      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151275-2      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151275-5      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151275-6      | B                        | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2151275-7      | B                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2151275-7    | A                        | CRIMP TOOLING KIT        |

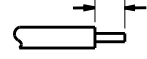
|                                      |                 |      |
|--------------------------------------|-----------------|------|
| APPLICATOR DATA                      |                 |      |
| CRIMP                                | SIZE            | TYPE |
| WIRE                                 | 2.29 mm [ .090] | F    |
| INSUL                                | 2.45 mm [ .096] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                 |      |

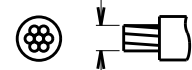
|                                                   |                                                                                   |                               |             |
|---------------------------------------------------|-----------------------------------------------------------------------------------|-------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION |                                                                                   |                               |             |
| TERMINAL NAME: .070 SERIES TAB CONTACT            |                                                                                   |                               |             |
| WIRE STRIP LENGTH                                 |  | INSULATION DIAMETER RANGE     |             |
| 3.50-4.50 mm [ .138-.177 IN]                      |                                                                                   | Ø1.70-2.40 mm [ .067-.094 IN] |             |
| TERMINAL APPLICATION SPECIFICATION                | 114-3120                                                                          | -                             | -           |
| TERMINALS APPLIED                                 |                                                                                   |                               |             |
| TE TERMINAL                                       | TE TERMINAL                                                                       | TE TERMINAL                   | TE TERMINAL |
| 345212-1                                          |                                                                                   |                               |             |

|           |                                                                                     |                             |                                                                                     |                                |
|-----------|-------------------------------------------------------------------------------------|-----------------------------|-------------------------------------------------------------------------------------|--------------------------------|
| WIRE SIZE |  | CRIMP HEIGHT mm [INCH]      |  | CRIMP HEIGHT REFERENCE SETTING |
| 1.50mm2   |                                                                                     | 1.65+/-0.05 [ .065+/- .002] |                                                                                     | 8.2                            |
| 1.00mm2   |                                                                                     | 1.47+/-0.05 [ .058+/- .002] |                                                                                     | 10.0                           |
| 0.75mm2   |                                                                                     | 1.38+/-0.05 [ .054+/- .002] |                                                                                     | 10.9                           |



- 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: 8-2151275-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151275-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151275-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151275-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180. 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.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.97.

|                                                   |                                                                                    |                               |             |
|---------------------------------------------------|------------------------------------------------------------------------------------|-------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION |                                                                                    |                               |             |
| TERMINAL NAME: .070 SERIES TAB CONTACT            |                                                                                    |                               |             |
| WIRE STRIP LENGTH                                 |  | INSULATION DIAMETER RANGE     |             |
| 3.50-4.50 mm [ .138-.177 IN]                      |                                                                                    | Ø2.40-2.70 mm [ .094-.106 IN] |             |
| TERMINAL APPLICATION SPECIFICATION                | 114-3120                                                                           | -                             | -           |
| TERMINALS APPLIED                                 |                                                                                    |                               |             |
| TE TERMINAL                                       | TE TERMINAL                                                                        | TE TERMINAL                   | TE TERMINAL |
| 345263-1                                          |                                                                                    |                               |             |

|           |                                                                                     |                             |                                                                                       |                                |
|-----------|-------------------------------------------------------------------------------------|-----------------------------|---------------------------------------------------------------------------------------|--------------------------------|
| WIRE SIZE |  | CRIMP HEIGHT mm [INCH]      |  | CRIMP HEIGHT REFERENCE SETTING |
| 2.00mm2   |                                                                                     | 1.83+/-0.05 [ .072+/- .002] |                                                                                       | 6.4                            |

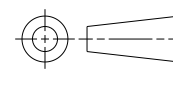
\*WARNING  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|     |    |    |    |    |    |           |                                     |         |
|-----|----|----|----|----|----|-----------|-------------------------------------|---------|
| -   | -  | 1  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK                | 260     |
| -   | 1  | -  | 1  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT.     | 252     |
| -   | -  | -  | -  | 1  | -  | 2119640-1 | PUSH ROD, AIR FEED                  | 250     |
| -   | -  | -  | -  | 1  | -  | 2079988-1 | BUSHING, LCH5-12, MISUMI            | 249     |
| -   | -  | -  | -  | 1  | -  | 2119641-1 | FEED CAM, AIR FEED                  | 248     |
| -   | 1  | -  | 1  | 1  | 1  | 2119798-1 | DETENT PIN                          | 247     |
| -   | 1  | -  | 1  | 1  | 1  | 1-22279-3 | SPRING, COMPRESSION                 | 246     |
| -   | -  | 1  | -  | -  | -  | 2119758-1 | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245     |
| -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<br>2119599-1 | LOC<br>A | DIST<br>66 | REVISIONS |     |               |           |
|                           |          |            | P         | LTR | DESCRIPTION   | DATE      |
|                           |          |            |           | A   | RELEASED      | 19JUL2013 |
|                           |          |            |           | B   | ECR-16-017763 | 15DEC2016 |
|                           |          |            |           |     |               |           |
|                           |          |            |           |     |               |           |

|     |     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 1   | 2119082-7   | 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     |
| -   | 1   | 1   | 1   | 1   | 1   | 1-1752354-4 | STANDOFF, HOLD-DOWN                 | 180     |
| -   | 1   | 1   | 1   | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177     |
| -   | 1   | 1   | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176     |
| -   | 1   | 1   | 1   | 1   | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 | 175     |
| -   | 1   | 1   | 1   | 1   | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 | 174     |
| -   | -   | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172     |
| -   | 1   | 1   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166     |
| -   | REF | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164     |
| -   | -   | -   | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163     |
| -   | -   | -   | -   | 1   | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137     |
| -   | -   | -   | -   | 1   | -   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136     |
| -   | -   | REF | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135     |
| -   | -   | 1   | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133     |
| -   | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
| -   | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 1   | 1-22278-0   | SPRING, COMPRESSION                 | 77      |
| -   | 1   | 1   | 1   | 1   | 1   | 854769-4    | HOLDER, INS                         | 74      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | -   | -   | 1   | 1   | 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   | 21028-2     | PIN, SLOTTED SPRING .062 X .250     | 58      |
| -   | -   | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56      |
| -   | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54      |
| -   | 1   | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52      |
| -   | 1   | 1   | 1   | 1   | 1   | 1901681-1   | HOLDDOWN, TERMINAL                  | 51      |
| -   | -   | -   | -   | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -   | -   | -   | -   | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48      |
| -   | -   | -   | -   | -   | 1   | 2119653-1   | FEED CAM, POST FEED                 | 47      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46      |
| -   | 1   | -   | 1   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44      |
| -   | 1   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
| -   | 1   | -   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40      |
| -   | 1   | -   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119644-2   | RAM WASHER, PRECISION               | 38      |
| -   | 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   | 1752356-3   | SUPPORT, TERMINAL                   | 34      |
| -   | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| -   | 1   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32      |
| -   | 1   | 1   | 1   | 1   | 1   | 2-1320908-2 | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29      |
| -   | 1   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| -   | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 1   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21      |
| -   | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19      |
| -   | 1   | 1   | 1   | 1   | 1   | 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   | 1803095-1   | FLOATING SHEAR, FRONT               | 9       |
| 1   | 1   | 1   | 1   | 1   | 1   | 2-1333205-5 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1   | 2119780-9   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 1   | 1-238011-8  | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 1   | 1   | 1   | 7-1633961-3 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2       |
| 1   | 1   | 1   | 1   | 1   | 1   | 1-456406-8  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

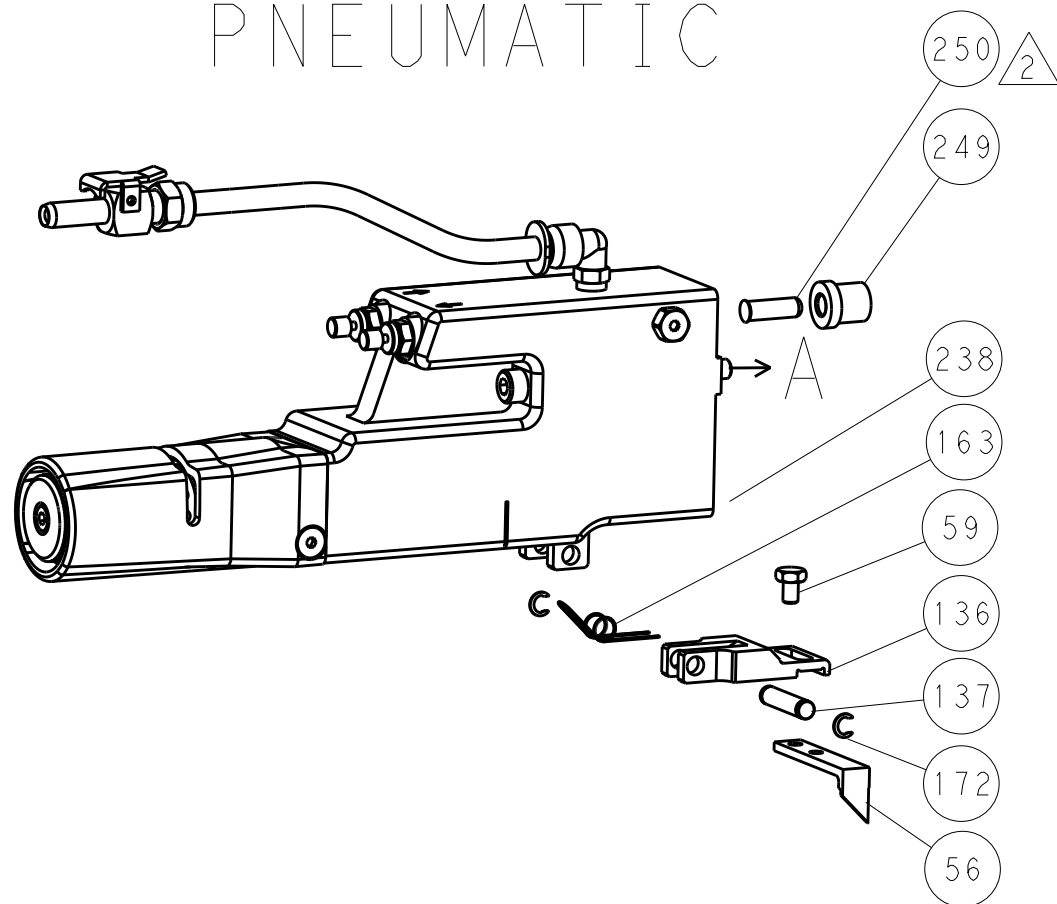
|                                                                                                                                                                    |  |                                                                             |  |                  |           |                                                                                                                                    |  |                               |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------|--|------------------|-----------|------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------|--|
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|                                                                                                                                                                    |  |                                                                             |  | CHK<br>U. GUO    | 14JUN2013 |                                                                                                                                    |  |                               |  |
| DIMENSIONS:                                                                                                                                                        |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                                      |  | APVD<br>J. CRUZ  | 14JUN2013 | NAME                                                                                                                               |  | Ocean Side Feed<br>Applicator |  |
| mm                                                                                                                                                                 |  | 0 PLC ±.1<br>1 PLC ±.1<br>2 PLC ±.1<br>3 PLC ±.1<br>4 PLC ±.1<br>ANGLES ±.1 |  | PRODUCT SPEC     |           | SIZE CASE CODE DRAWING NO RESTRICTED TO<br>A1 00779 C=2151275 -                                                                    |  |                               |  |
|                                                                               |  |                                                                             |  | APPLICATION SPEC |           |                                                                                                                                    |  |                               |  |
| MATERIAL                                                                                                                                                           |  | FINISH                                                                      |  | WEIGHT           |           | Customer Accessible Production Drawing                                                                                             |  |                               |  |
|                                                                                                                                                                    |  |                                                                             |  |                  |           | SCALE 1:2                                                                                                                          |  | SHEET 1 OF 4 REV B            |  |

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

FEED TYPE  
MECHANICAL



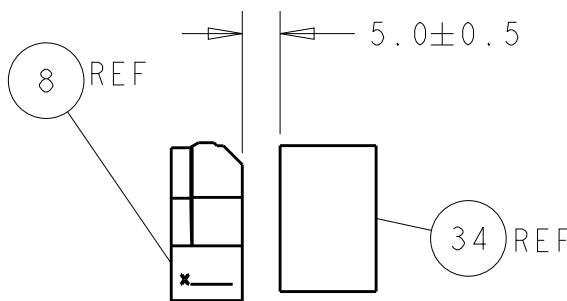
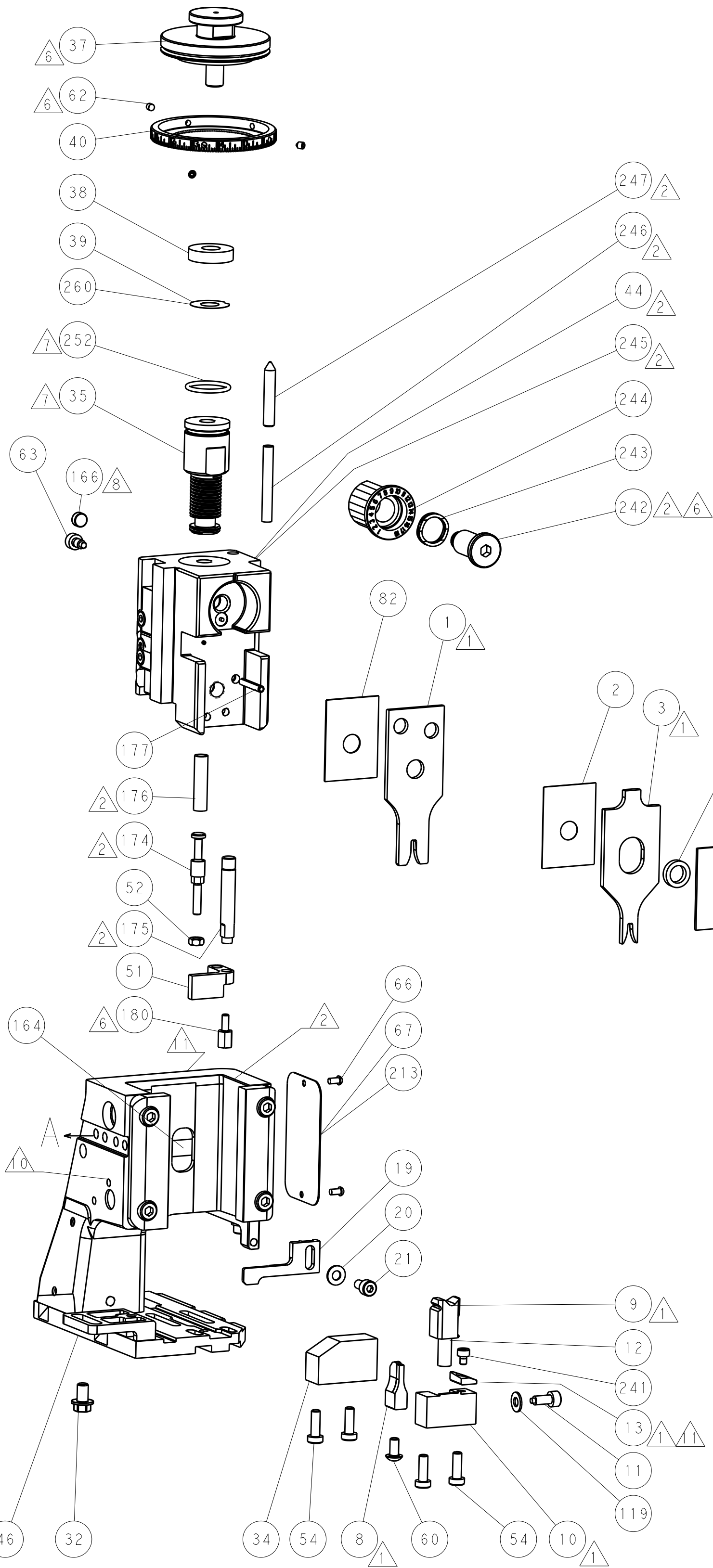
PNEUMATIC



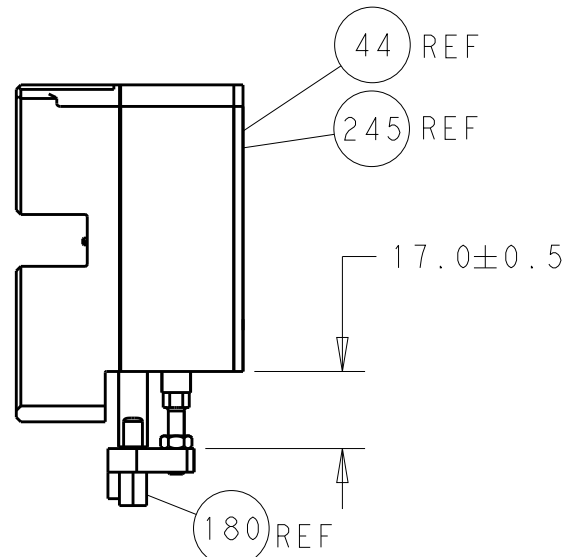
SERVO  
LATCH PLATE



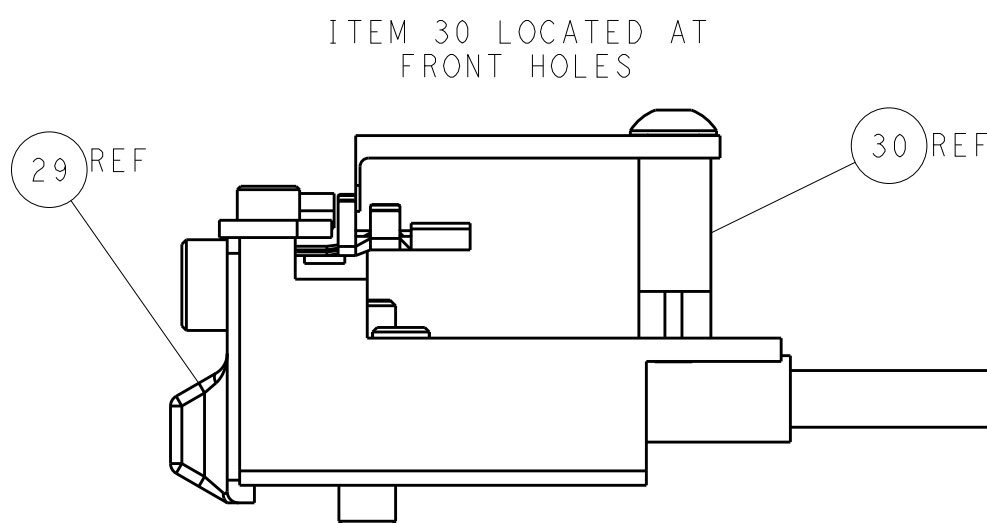
CAM POSITIONS



TERMINAL SUPPORT LOCATION

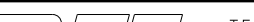


HOLDDOWN SET-UP

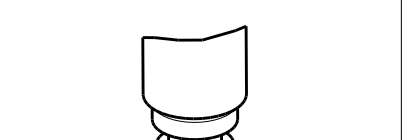


FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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

|                                                                                                                                                                                                                         |  |                                        |  |                                |  |                                                                                                       |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------|--|--------------------------------|--|-------------------------------------------------------------------------------------------------------|--|
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|                                                                                                                                                                                                                         |  |                                        |  | CNC: U. GUO 14JUN2013          |  | Harrisburg, PA 17105-3608                                                                             |  |
| DIMENSIONS:                                                                                                                                                                                                             |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | APPROVED BY: I. CRUZ 14JUN2013 |  | NAME                                                                                                  |  |
| mm                                                                                                                                                                                                                      |  |                                        |  | PRODUCT SPEC                   |  | Ocean Side Feed Applicator                                                                            |  |
|                                                                                                                                                                                                                         |  |                                        |  |                                |  |                                                                                                       |  |

|                                                                      |                             |
|----------------------------------------------------------------------|-----------------------------|
| 8                                                                    | 7                           |
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| PACIFIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                               | PART<br>NUMBER | REVISION | DESCRIPTION              | FEED TYPE                                                                                           | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |             |                        |
|----------------------------------------------------------------------------------|----------------|----------|--------------------------|-----------------------------------------------------------------------------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|                                                                                  |                |          |                          |                                                                                                     | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|  | 2-2151275-1    | 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             | -         | 8-2151275-5 | 1901094-3 | 1-1752354-4 | 2168400-6 (QUANTITY 2) |
|                                                                                  |                |          |                          |                                                                                                     | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151275-4 | -         | -           | -                      |
|                                                                                  | 2-2151275-2    | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                                                                                           | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -           | -                      |
|                                                                                  |                |          |                          |                                                                                                     | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151275-5 | 1901094-3 | 1-1752354-4 | 2168400-6 (QUANTITY 2) |
|                                                                                  |                |          |                          |                                                                                                     | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151275-4 | -         | -           | -                      |
|                                                                                  | 2-2151275-5    | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE  | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -           | -                      |
|                                                                                  | 2-2151275-7    | B        | FINE CRIMP HEIGHT ADJUST | NONE                                                                                                | -                                 | -                     | -         | -           | -         | -           | -                      |
|                                                                                  | 7-2151275-7    | A        | CRIMP TOOLING KIT        | -                                                                                                   | -                                 | -                     | -         | -           | -         | -           | -                      |

| APPLICATOR DATA                      |                |                                                                                   |
|--------------------------------------|----------------|-----------------------------------------------------------------------------------|
| CRIMP                                | SIZE           | TYPE                                                                              |
| WIRE                                 | 2.29 mm [.090] | F                                                                                 |
| INSUL                                | 2.45 mm [.096] | F                                                                                 |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |  |

|                                                                                                        |                                                                                   |                                                           |             |
|--------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL                                                                             |                                                                                   | TE CRIMP SPECIFICATION                                    |             |
| TERMINAL NAME: .070 SERIES                                                                             |                                                                                   | TAB CONTACT                                               |             |
| WIRE STRIP LENGTH<br>3.50-4.50 mm [.138-.177 IN]                                                       |  | INSULATION DIAMETER RANGE<br>Ø1.70-2.40 mm [.067-.094 IN] |             |
| TERMINAL APPLICATION  | 114-3120                                                                          | -                                                         | -           |
| SPECIFICATION                                                                                          | -                                                                                 | -                                                         | -           |
| TERMINALS APPLIED                                                                                      |                                                                                   |                                                           |             |
| TE TERMINAL<br>345212-1                                                                                | TE TERMINAL                                                                       | TE TERMINAL                                               | TE TERMINAL |

| WIRE<br>SIZE |  | CRIMP HEIGHT<br>mm [INCH]     |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|--------------|-------------------------------------------------------------------------------------|-------------------------------|-------------------------------------------------------------------------------------|-----------------------------------|
| 1.50mm2      |                                                                                     | 1.65+/- 0.05 [ .065+/- .002 ] |                                                                                     | 8.2                               |
| 1.00mm2      |                                                                                     | 1.47+/- 0.05 [ .058+/- .002 ] |                                                                                     | 10.0                              |
| 0.75mm2      |                                                                                     | 1.38+/- 0.05 [ .054+/- .002 ] |                                                                                     | 10.9                              |



-  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: 8-2151275-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151275-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151275-5

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 & 180.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.

-  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.

-  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.

|                                                  |             |                                                           |             |
|--------------------------------------------------|-------------|-----------------------------------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL                       |             | TE CRIMP SPECIFICATION                                    |             |
| TERMINAL NAME: .070 SERIES TAB CONTACT           |             |                                                           |             |
| WIRE STRIP LENGTH<br>3.50-4.50 mm [.138-.177 IN] |             | INSULATION DIAMETER RANGE<br>Ø2.40-2.70 mm [.094-.106 IN] |             |
| TERMINAL APPLICATION SPECIFICATION               |             | TERMINAL APPLICATION SPECIFICATION                        |             |
| TERMINALS APPLIED                                |             | TERMINALS APPLIED                                         |             |
| TE TERMINAL<br>345263-1                          | TE TERMINAL | TE TERMINAL                                               | TE TERMINAL |

| WIRE SIZE           |  | CRIMP HEIGHT<br>mm [INCH]   |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|---------------------|-------------------------------------------------------------------------------------|-----------------------------|---------------------------------------------------------------------------------------|-----------------------------------|
| 2.00mm <sup>2</sup> |                                                                                     | 1.83+/-0.05 [0.072+/- .002] |                                                                                       | 6.4                               |

\* 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     |
| -   | -   | -   | 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   | 2119082-7 | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -   | 1   | 1   | 1   | 1   | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -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)

|                           |     |             |            |           |      |     |      |
|---------------------------|-----|-------------|------------|-----------|------|-----|------|
|                           |     | 2           |            |           |      | I   |      |
| SET UP GAUGE<br>2119599-1 |     | LOC<br>A    | DIST<br>66 | REVISIONS |      |     |      |
| P                         | LTR | DESCRIPTION |            |           | DATE | DWN | APVD |
| -                         | -   | SEE SHEET I |            |           | -    | -   | -    |
|                           |     |             |            |           |      |     |      |
|                           |     |             |            |           |      |     |      |
|                           |     |             |            |           |      |     |      |
|                           |     |             |            |           |      |     |      |

|                    |   |     |     |     |           |                         |                                     |         |
|--------------------|---|-----|-----|-----|-----------|-------------------------|-------------------------------------|---------|
| 6                  | - | 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     |
|                    | - | 1   | 1   | 1   | 1         | 1-1752354-4             | STANDOFF,HOLD-DOWN                  | 180     |
|                    | - | 1   | 1   | 1   | 1         | 993111-1                | PIN, SLOTTED SPRING 3.0 X 20.0      | 177     |
|                    | - | 1   | 1   | 1   | 1         | 8-22280-7               | SPRING, COMPRESSION                 | 176     |
| 6                  | - | 1   | 1   | 1   | 1         | 1752353-2               | GUIDE PIN,HOLDDOWN                  | 175     |
|                    | - | 1   | 1   | 1   | 1         | 1901680-2               | GUIDE PIN,HOLDDOWN                  | 174     |
|                    | - | -   | -   | 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     |
|                    | - | 1   | 1   | 1   | 1         | 1-18028-2               | WASHER, FLAT, REG M4                | 119     |
| -                  | - | REF | -   | -   | 2119944-1 | FEED FINGER ASSEMBLY,SF | 117                                 |         |
| 6                  | - | 1   | 1   | 1   | 1         | 455888-5                | SPACER, CRIMPER                     | 82      |
|                    | - | 1   | 1   | 1   | 1         | 1-22278-0               | SPRING, COMPRESSION                 | 77      |
|                    | - | 1   | 1   | 1   | 1         | 854769-4                | HOLDER, INS                         | 74      |
|                    | - | 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         | 21028-2                 | PIN, SLOTTED SPRING .062 X .250     | 58      |
|                    | - | -   | -   | 1   | 1         | 1338685-1               | PAWL, FEED                          | 56      |
|                    | - | 1   | 1   | 1   | 1         | 1-5018030-0             | NUT, HEX, REG, RoHS, M3.5           | 52      |
|                    | - | 1   | 1   | 1   | 1         | 1901681-1               | HOLDDOWN, TERMINAL                  | 51      |
|                    | - | -   | -   | 1   | 2         | 18023-9                 | SCR, SKT HD CAP M4 X 6.0            | 49      |
|                    | - | -   | -   | -   | 1         | 2119652-1               | FEED CAM, PRE FEED                  | 48      |
|                    | - | 1   | 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         | 2119644-2               | RAM WASHER, PRECISION               | 38      |
|                    | - | 1   | 1   | 1   | 1         | 1752356-3               | SUPPORT, TERMINAL                   | 34      |
| 1                  | - | 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         | 2-1320908-2             | SPACER, STRIP GUIDE                 | 30      |
|                    | - | 1   | 1   | 1   | 1         | 2119959-1               | ASSEMBLY, STRIP GUIDE               | 29      |
|                    | - | 1   | 1   | 1   | 1         | 1-455888-0              | 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      |
|                    | - | 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         | 1803095-1               | FLOATING SHEAR, FRONT               | 9       |
|                    | - | 1   | 1   | 1   | 1         | 2-133205-5              | ANVIL, COMBINATION                  | 8       |
|                    | - | -   | -   | -   | -         | -                       | -                                   | 7       |
|                    | - | -   | -   | -   | -         | -                       | -                                   | 6       |
|                    | - | 1   | 1   | 1   | 1         | 2119780-9               | DEPRESSOR, SHEAR                    | 5       |
|                    | - | 1   | 1   | 1   | 1         | 1-238011-8              | BLOCK, CRIMPER SPACER               | 4       |
|                    | - | 1   | 1   | 1   | 1         | 7-1633961-3             | CRIMPER, INSULATION F PREMIUM       | 3       |
| 1                  | - | 1   | 1   | 1   | 1         | 455888-1                | SPACER, CRIMPER                     | 2       |
|                    | - | 1   | 1   | 1   | 1         | 1-456406-8              | CRIMPER, WIRE PREMIUM               | 1       |
| -77 -27 25 -22 -21 |   |     |     |     |           | PART NO                 | DESCRIPTION                         | ITEM NO |

[illegible]

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

D

C

B

A

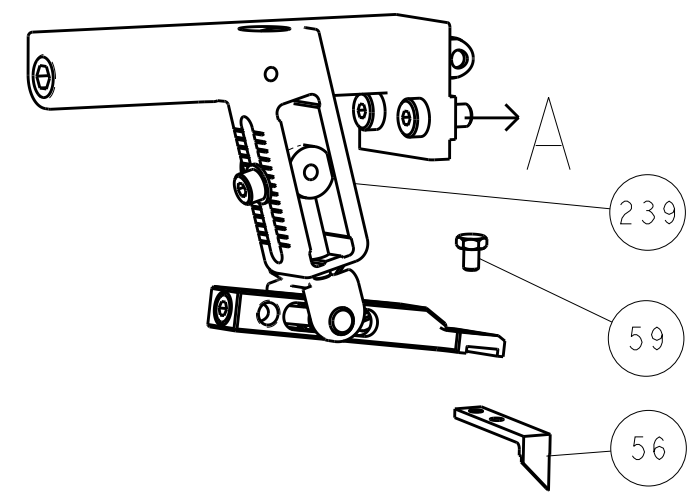
D

C

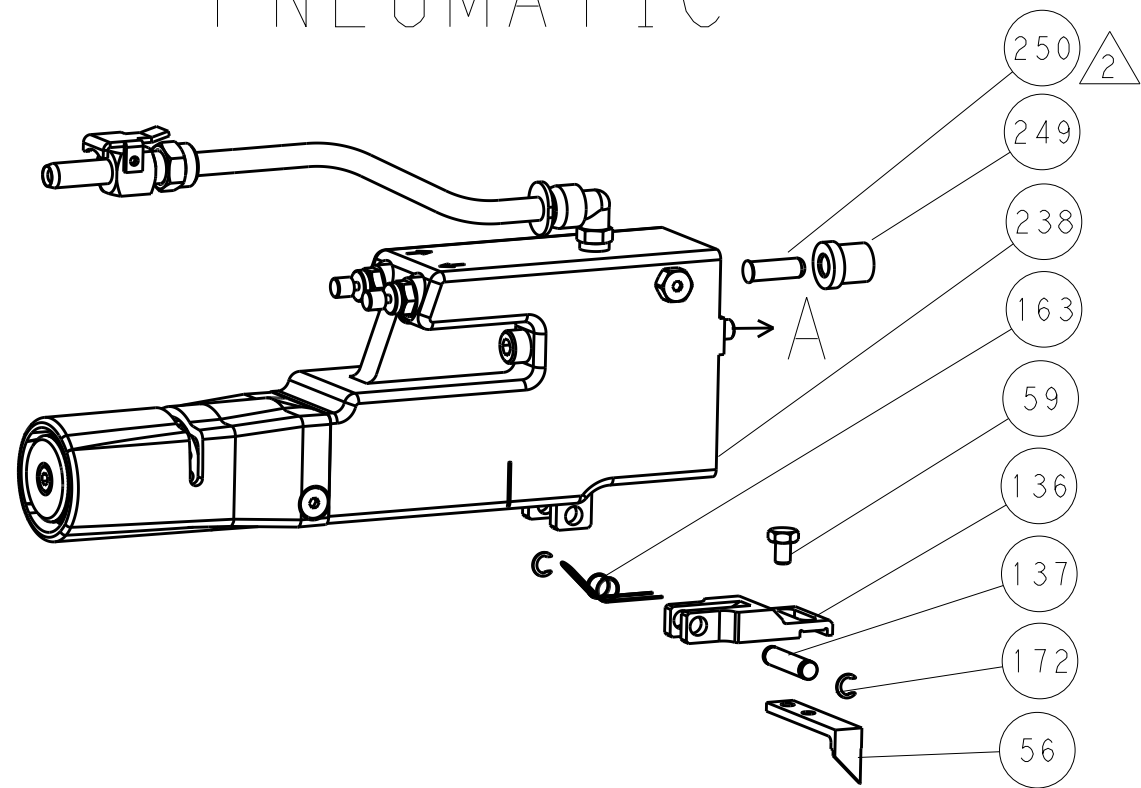
B

A

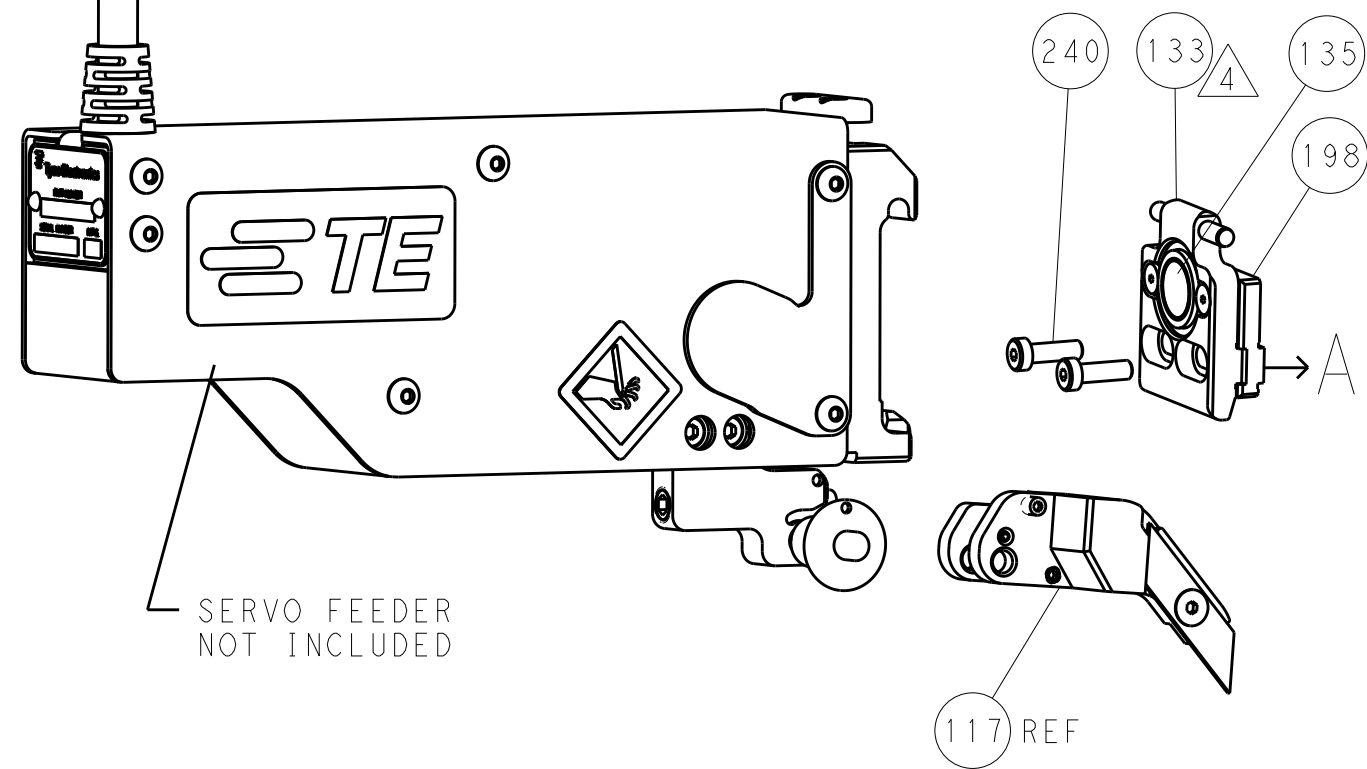
# FEED TYPE MECHANICAL



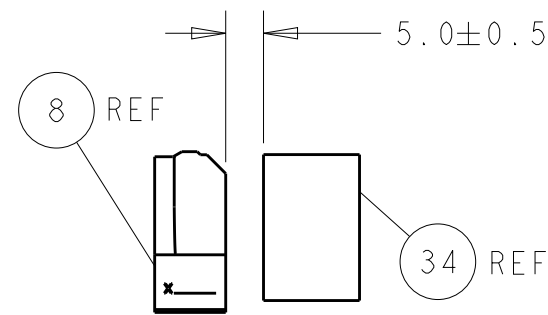
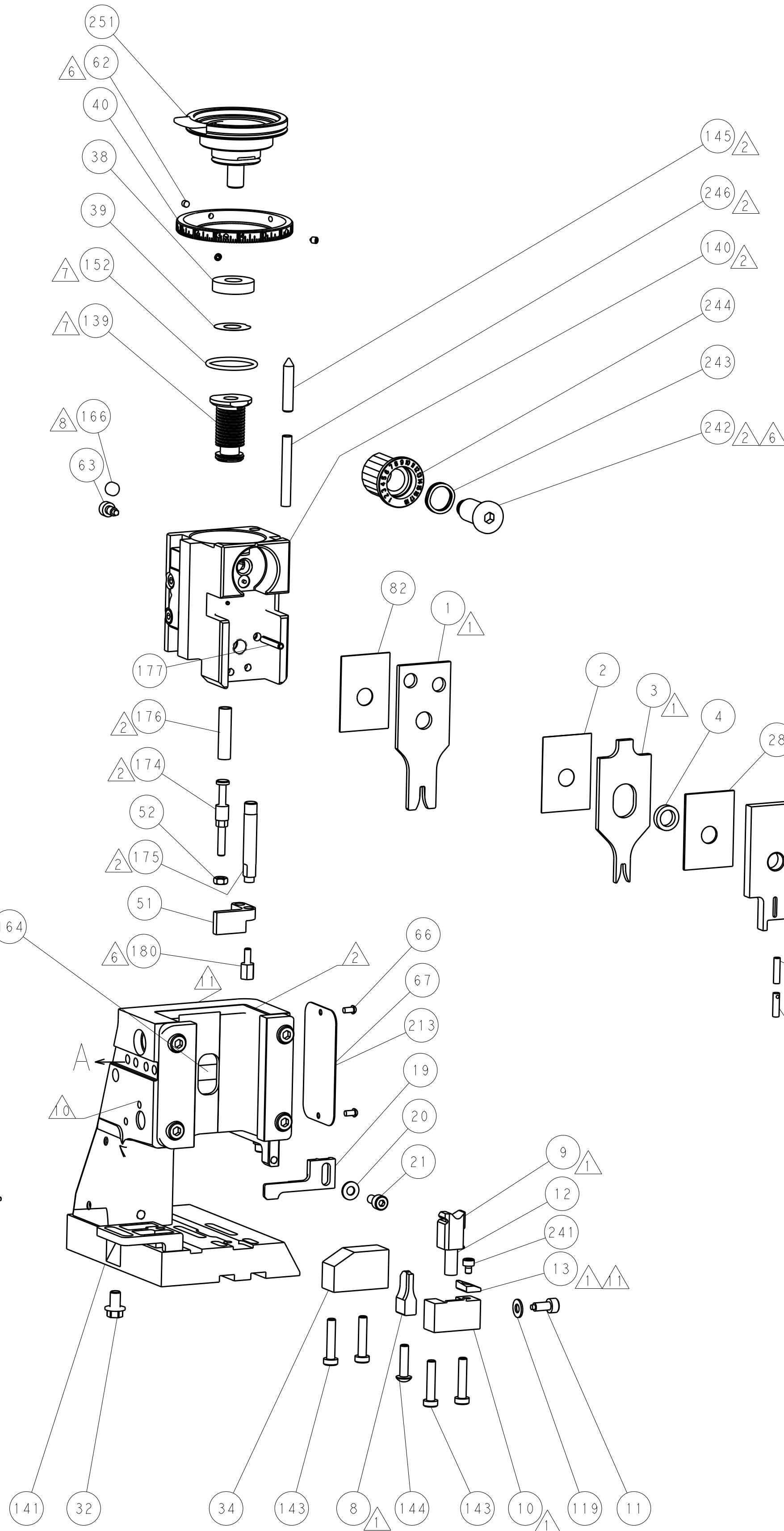
# PNEUMATIC



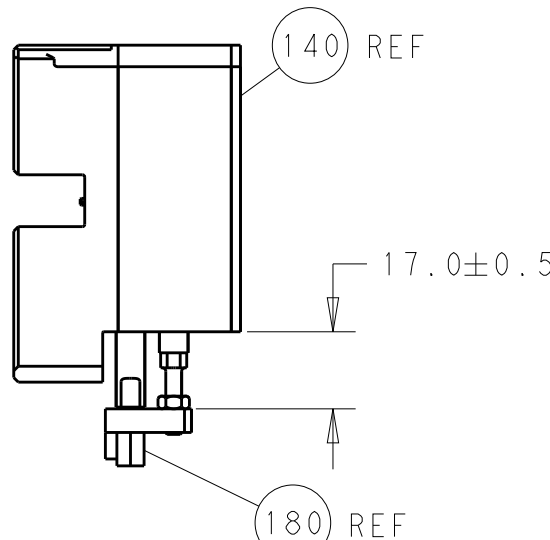
# SERVO LATCH PLATE



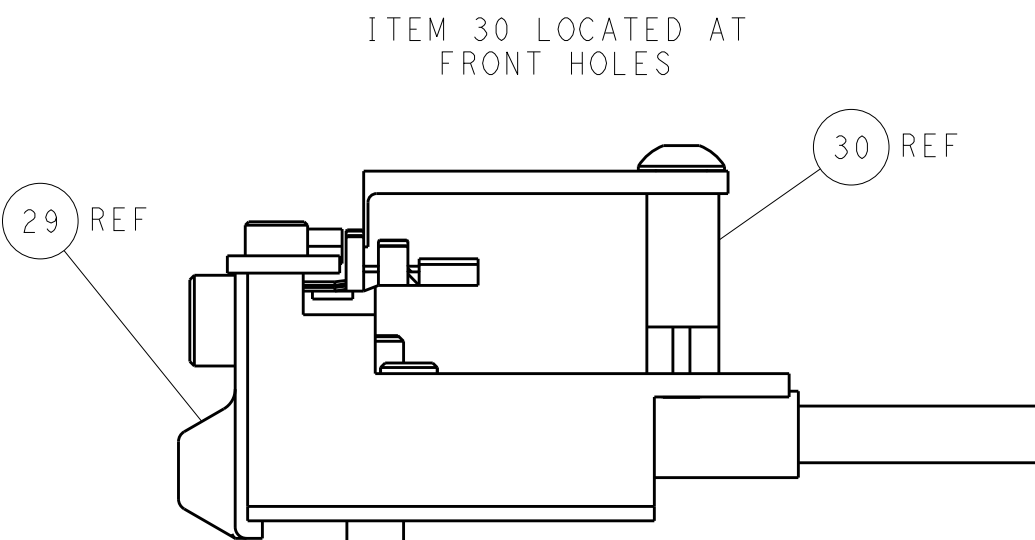
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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

|             |  |                                        |  |                                        |  |           |  |              |  |
|-------------|--|----------------------------------------|--|----------------------------------------|--|-----------|--|--------------|--|
| DIMENSIONS: |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DWN                                    |  | 14JUN2013 |  | C. CHEN      |  |
| mm          |  | 0 PLC ±.1                              |  | CHK                                    |  | 14JUN2013 |  | U. GUO       |  |
|             |  | 1 PLC ±.1                              |  | APVD                                   |  | 14JUN2013 |  | I. CRUZ      |  |
|             |  | 2 PLC ±.1                              |  | PRODUCT SPEC                           |  |           |  |              |  |
|             |  | 3 PLC ±.1                              |  | APPLICATION SPEC                       |  |           |  |              |  |
|             |  | 4 PLC ±.1                              |  | WEIGHT                                 |  |           |  |              |  |
| MATERIAL    |  | FINISH                                 |  | SCALE                                  |  | 1:2       |  | SHEET 4 OF 4 |  |
|             |  |                                        |  | Customer Accessible Production Drawing |  |           |  | REV B        |  |