

|                                                                                                        |             |                                                            |             |
|--------------------------------------------------------------------------------------------------------|-------------|------------------------------------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL                                                                             |             | TE CRIMP SPECIFICATION                                     |             |
| TERMINAL NAME: GIC 3.3 REC CONTACT                                                                     |             |                                                            |             |
| WIRE STRIP LENGTH<br>1.70-2.30 mm [ .067-.091 IN]                                                      |             | INSULATION DIAMETER RANGE<br>Ø1.50-2.50 mm [ .059-.098 IN] |             |
| TERMINAL APPLICATION  |             | 114-5372                                                   |             |
| SPECIFICATION                                                                                          |             | -                                                          |             |
| TERMINALS APPLIED                                                                                      |             |                                                            |             |
| TE TERMINAL<br>1827395-1                                                                               | TE TERMINAL | TE TERMINAL                                                | TE TERMINAL |



- 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: 8-2151834-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151834-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151834-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151834-6
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 50, 62 & 242.  
 FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.87.

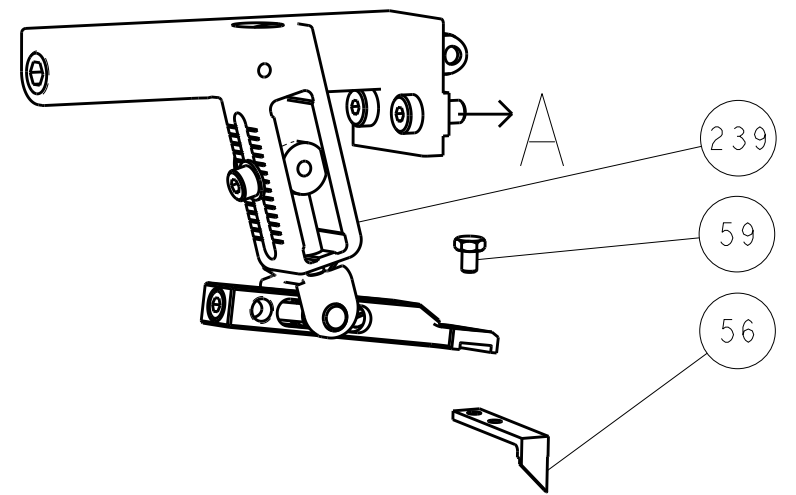
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

|     |     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -   | 1   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CRESTO-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   | 6-993111-6  | PIN, SLOTTED SPRING 3.0 X 14.0      | 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     |
| -   | REF | REF | REF | REF | REF | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166     |
| -   | -   | -   | -   | -   | -   | 994970-2    | COUNTER, MAGNETIC                   | 164     |
| -   | -   | -   | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163     |
| -   | 2   | 2   | 2   | 2   | 2   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       | 143     |
| -   | -   | -   | -   | 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     |
| -   | 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   | 854769-1    | HOLDER, INS                         | 74      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | -   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -   | 2   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS              | 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   | 1-1901681-3 | HOLDDOWN, TERMINAL                  | 51      |
| -   | 1   | 1   | 1   | 1   | 1   | 1-1752354-5 | STANDOFF, HOLD-DOWN                 | 50      |
| -   | -   | -   | -   | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -   | -   | -   | -   | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48      |
| -   | -   | -   | -   | -   | 1   | 2119653-1   | FEED CAM, POST FEED                 | 47      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46      |
| -   | 1   | -   | 1   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44      |
| -   | 1   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
| -   | 1   | -   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40      |
| -   | 1   | -   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119644-1   | RAM WASHER, PRECISION               | 38      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37      |
| -   | 1   | -   | 1   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35      |
| -   | 1   | 1   | 1   | 1   | 1   | 1752356-5   | 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   | 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   | 2119533-3   | 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   | 462006-6    | FLOATING SHEAR, FRONT               | 9       |
| 1   | 1   | 1   | 1   | 1   | 1   | 4-1633703-2 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1   | 2119780-1   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 1   | 238011-6    | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 1   | 1   | 1   | 6-1633961-6 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 2       |
| 1   | 1   | 1   | 1   | 1   | 1   | 7-1633588-1 | CRIMPER, WIRE                       | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

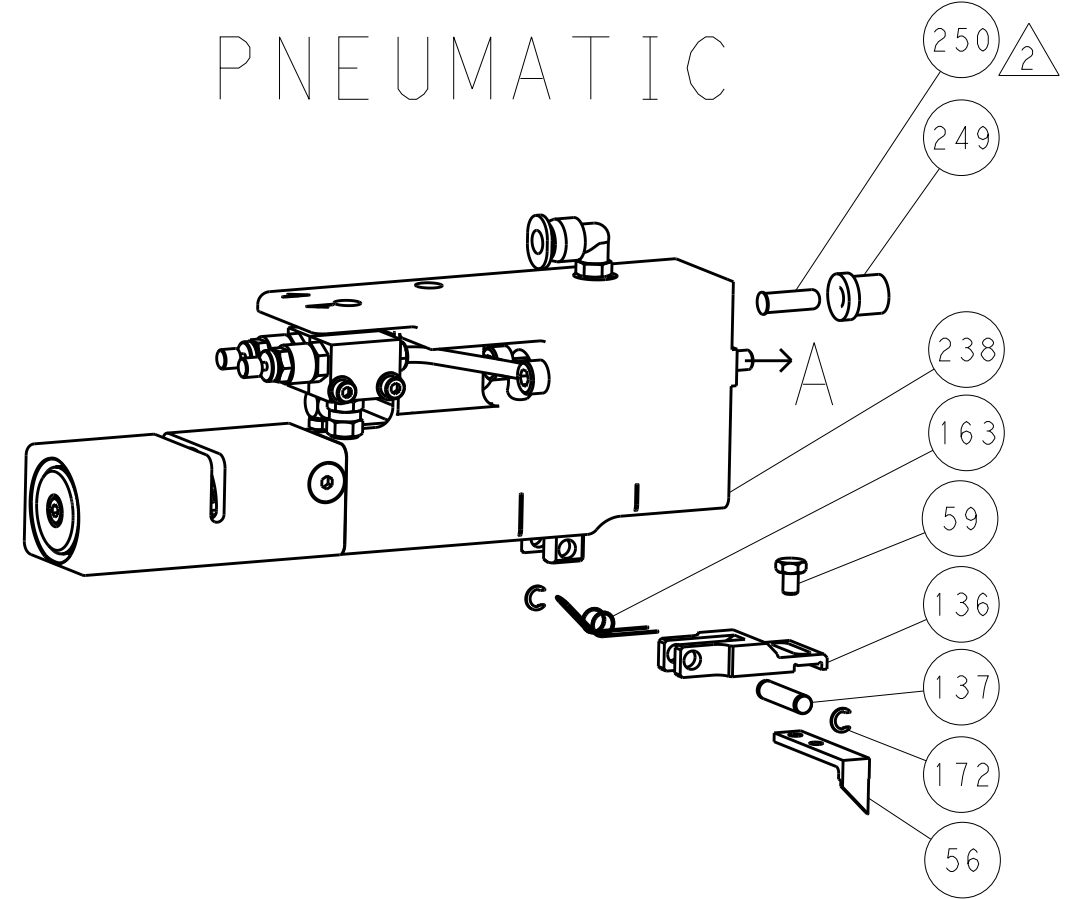
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|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    |     | SEE SHEET 1 | -    | -   | -    |
|     |    |      |     |             |      |     |      |
|     |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

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

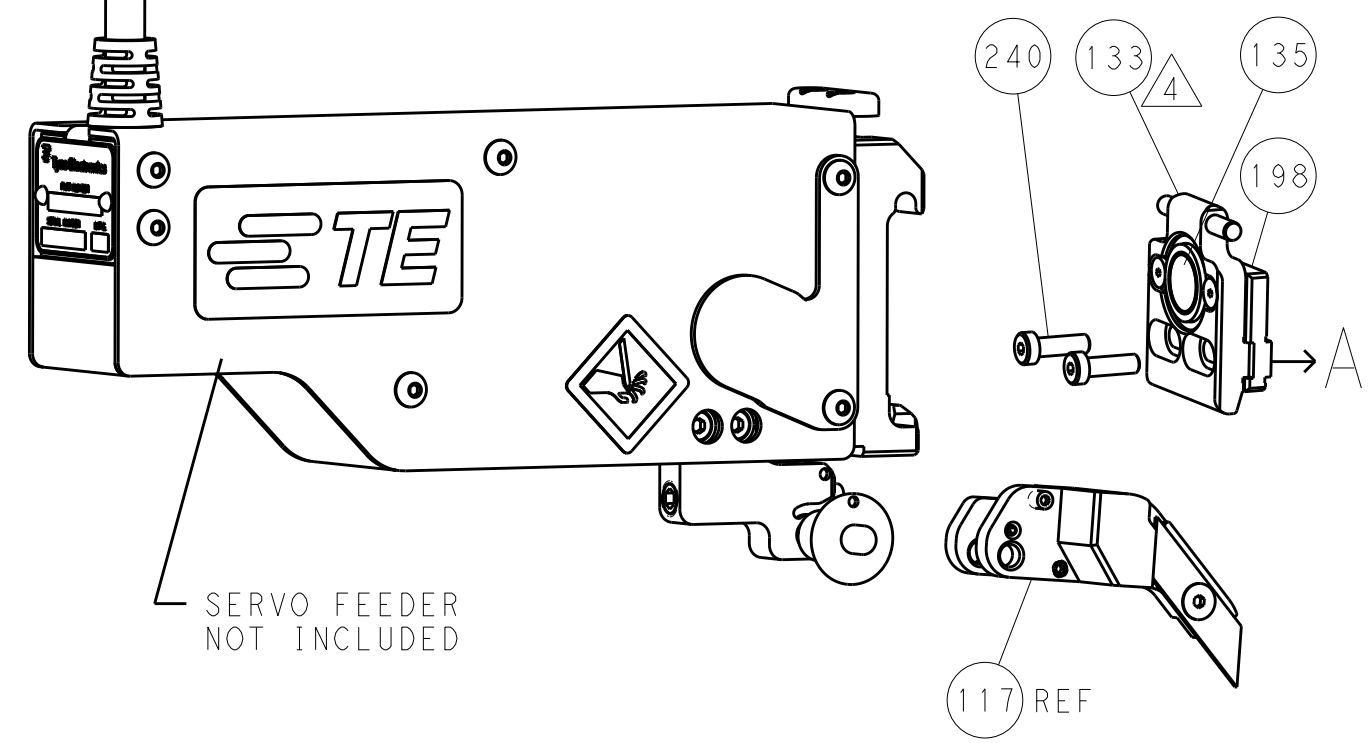
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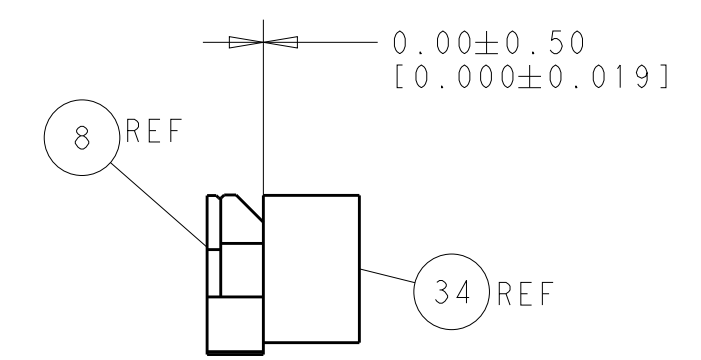
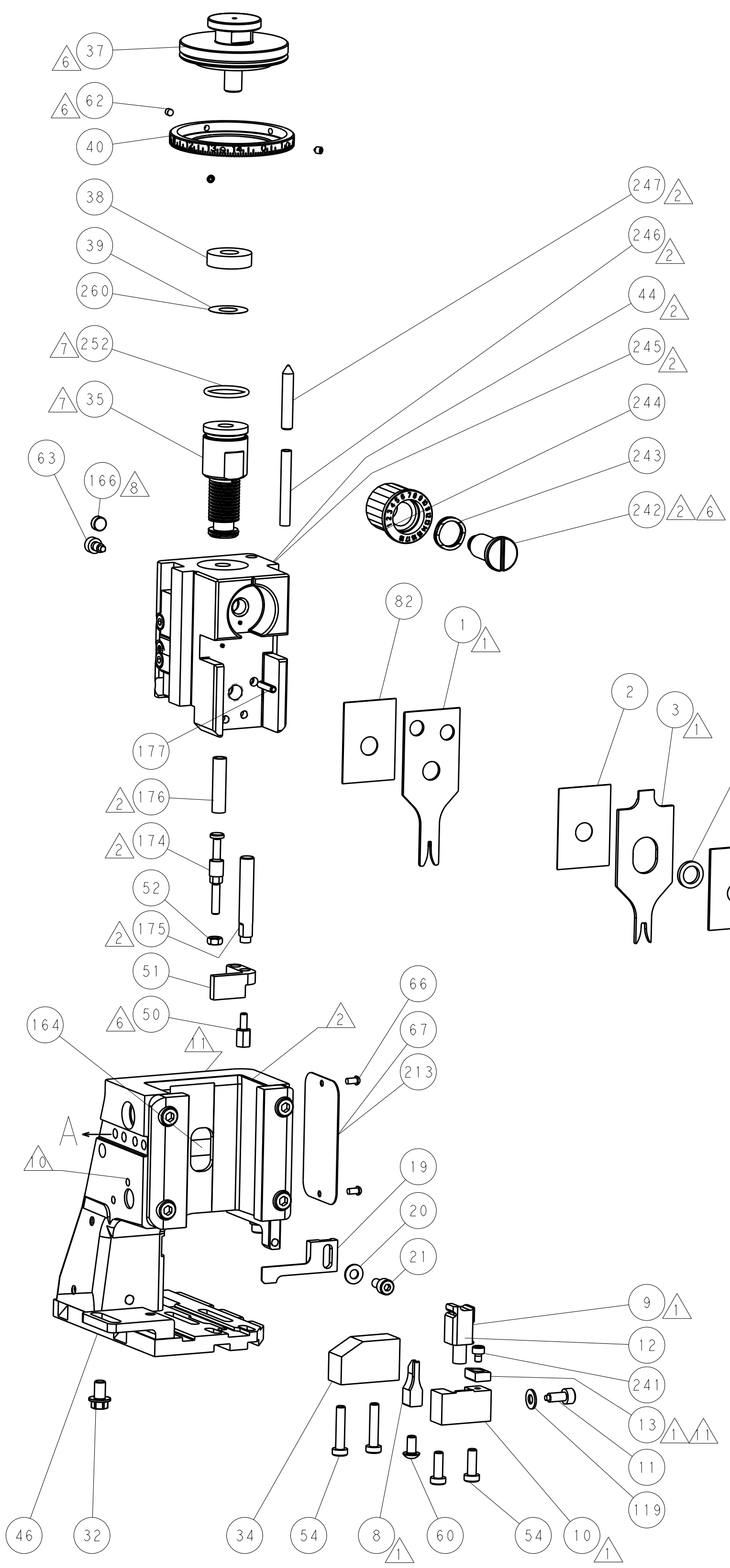
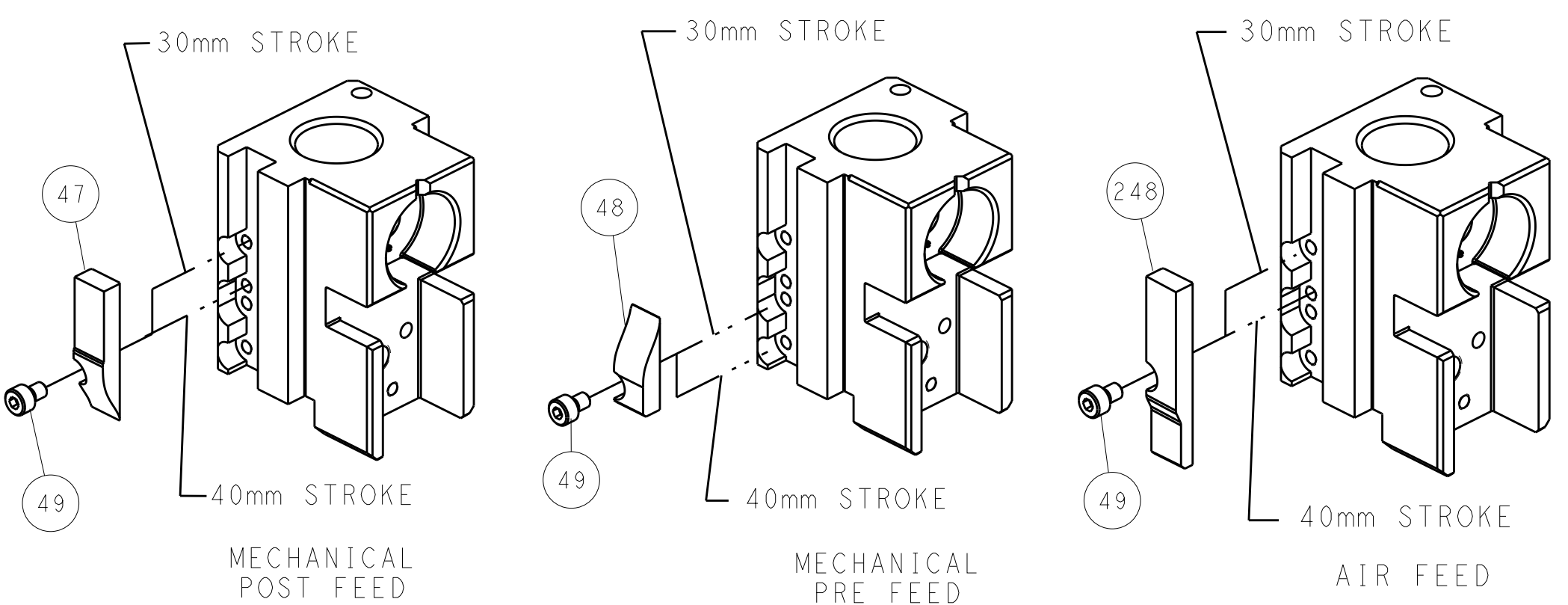
# PNEUMATIC



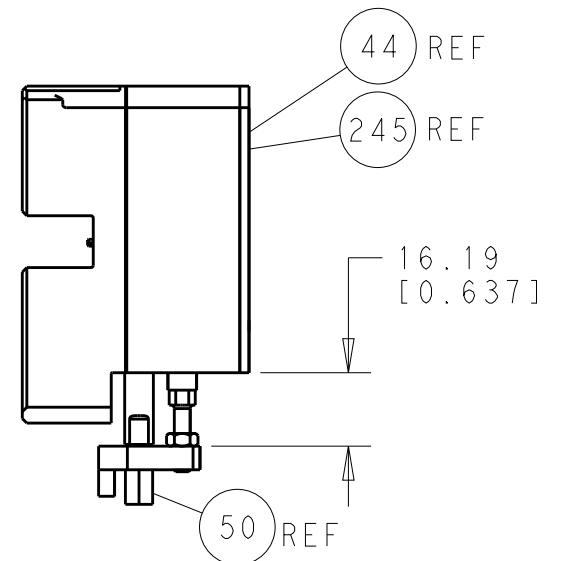
# SERVO LATCH PLATE



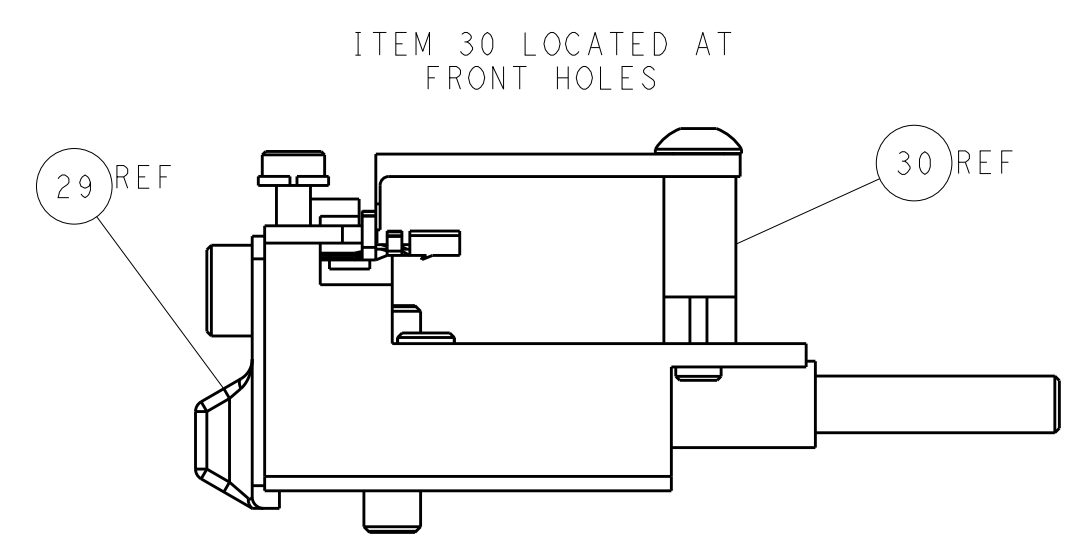
# CAM POSITIONS



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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| DIMENSIONS:                                                                                                                                          |  | CHK                                                | T. ELBIN | 14NOV2012 |                                                                                                                                                                                                                 |  |
| mm                                                                                                                                                   |  | APVD                                               | S. XI    | 14NOV2012 | NAME<br><br>Ocean Side Feed<br>Applicator<br>-<br><br>SIZE<br>CAGE CODE<br>DRAWING NO<br>RESTRICTED TO<br><br>A   00779 C-2151834<br><br>Customer Accessible Production Drawing<br>SCALE 1:1 SHEET 2 OF 4 REV A |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                                                                               |  | PRODUCT SPEC                                       |          |           |                                                                                                                                                                                                                 |  |
| 0 PLC ±0.1                                                                                                                                           |  | APPLICATION SPEC                                   |          |           |                                                                                                                                                                                                                 |  |
| 1 PLC ±0.1                                                                                                                                           |  | FINISH                                             |          |           |                                                                                                                                                                                                                 |  |
| 2 PLC ±0.02                                                                                                                                          |  | MATERIAL                                           |          |           |                                                                                                                                                                                                                 |  |
| 3 PLC ±0.005                                                                                                                                         |  | WEIGHT                                             |          |           |                                                                                                                                                                                                                 |  |
| 4 PLC ±0.0005                                                                                                                                        |  | SCALE                                              |          |           |                                                                                                                                                                                                                 |  |
| ANGLES ±0.0005                                                                                                                                       |  | SHEET                                              |          |           |                                                                                                                                                                                                                 |  |
| FINISH                                                                                                                                               |  | REV                                                |          |           |                                                                                                                                                                                                                 |  |
| Customer Accessible Production Drawing                                                                                                               |  | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION |          |           |                                                                                                                                                                                                                 |  |



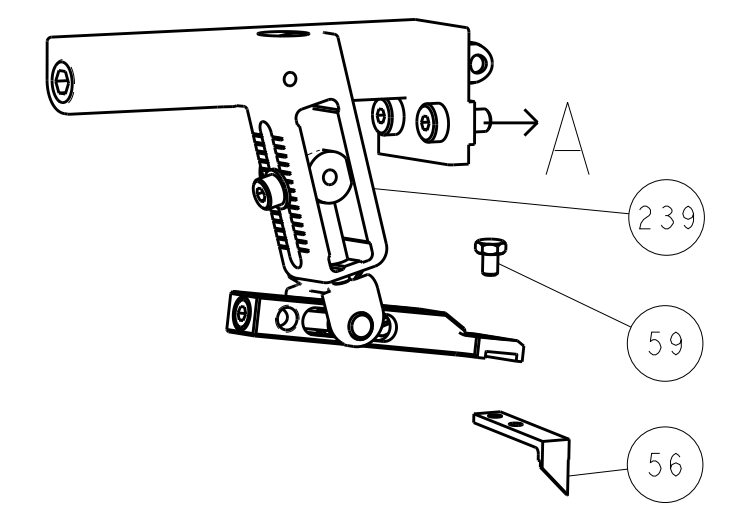
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

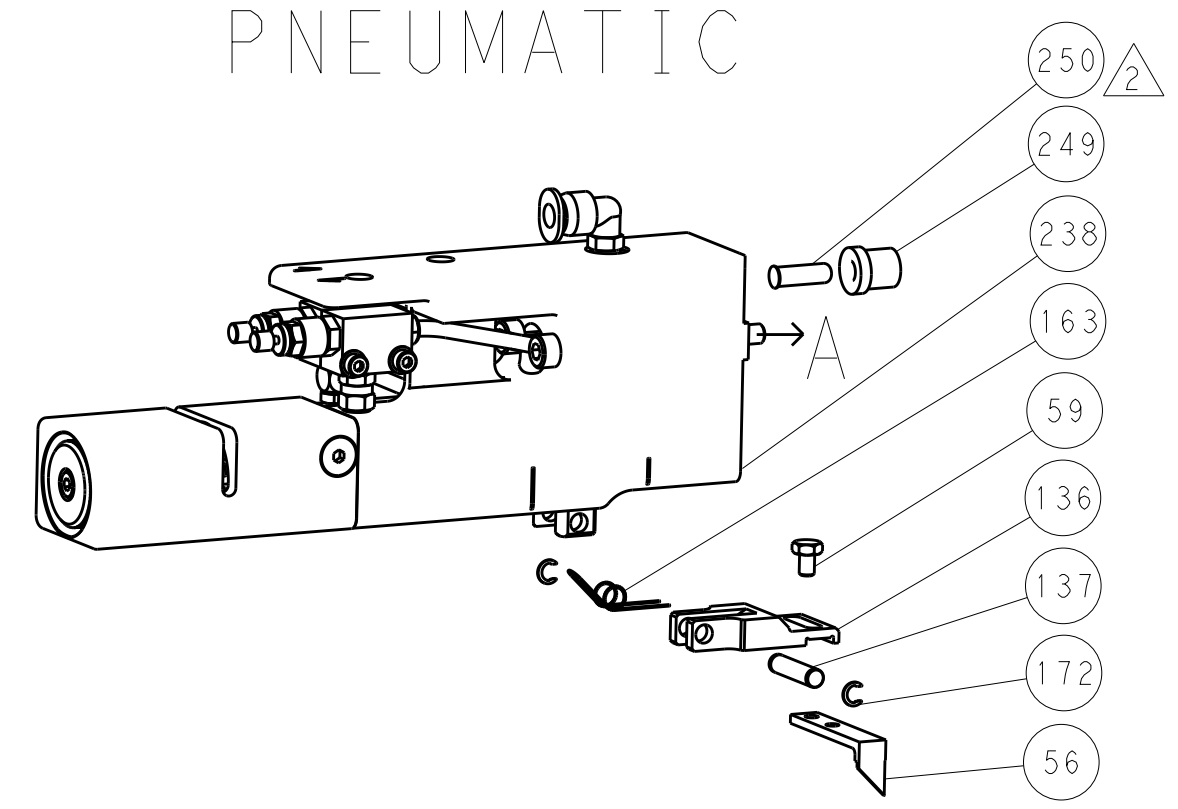
B

A

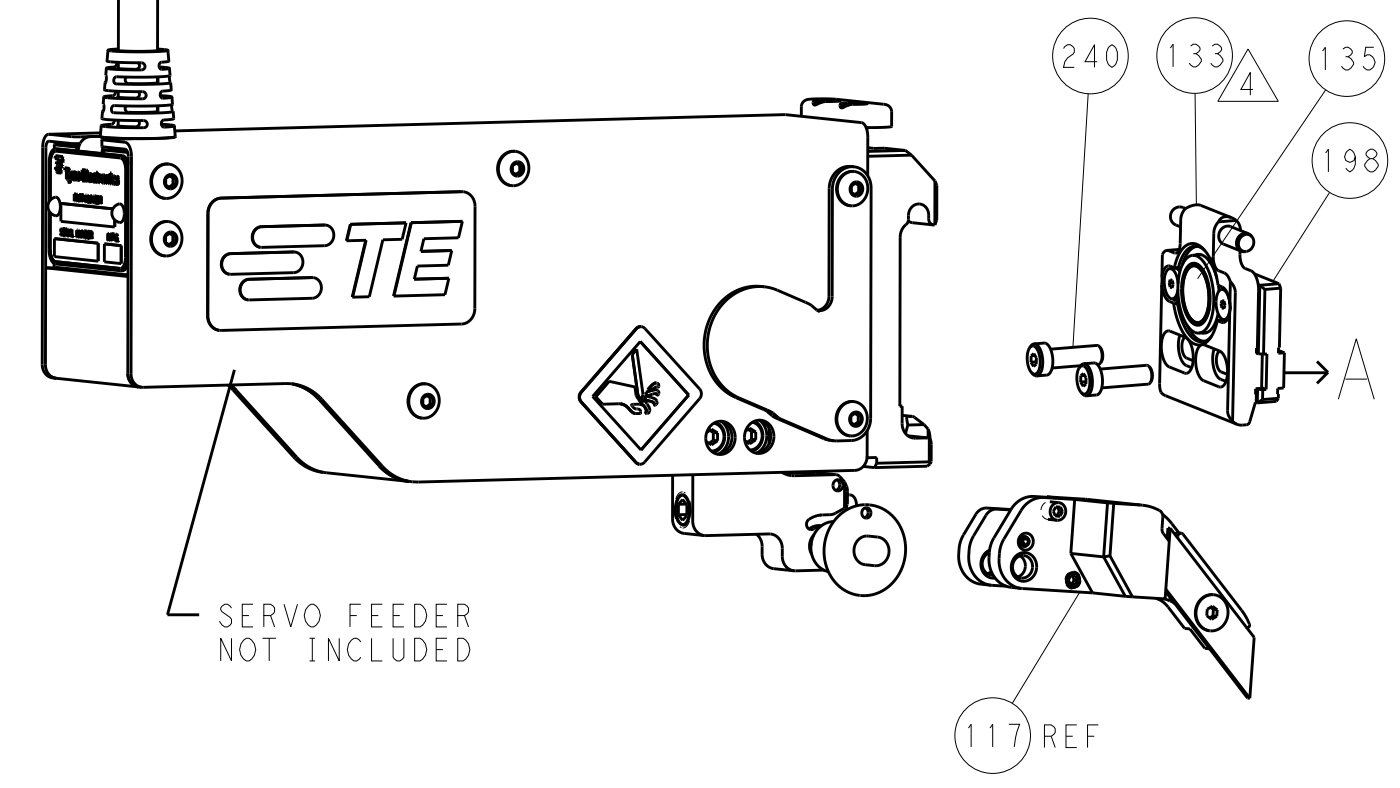
# FEED TYPE MECHANICAL



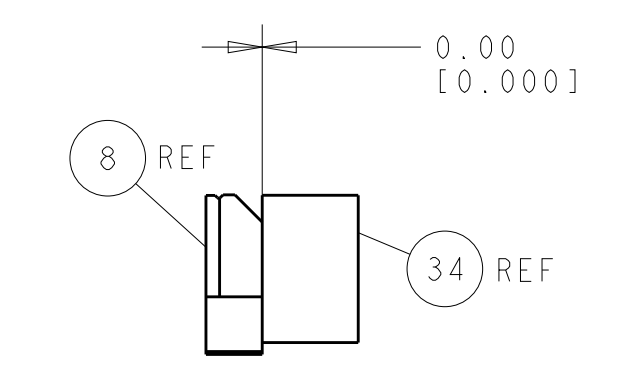
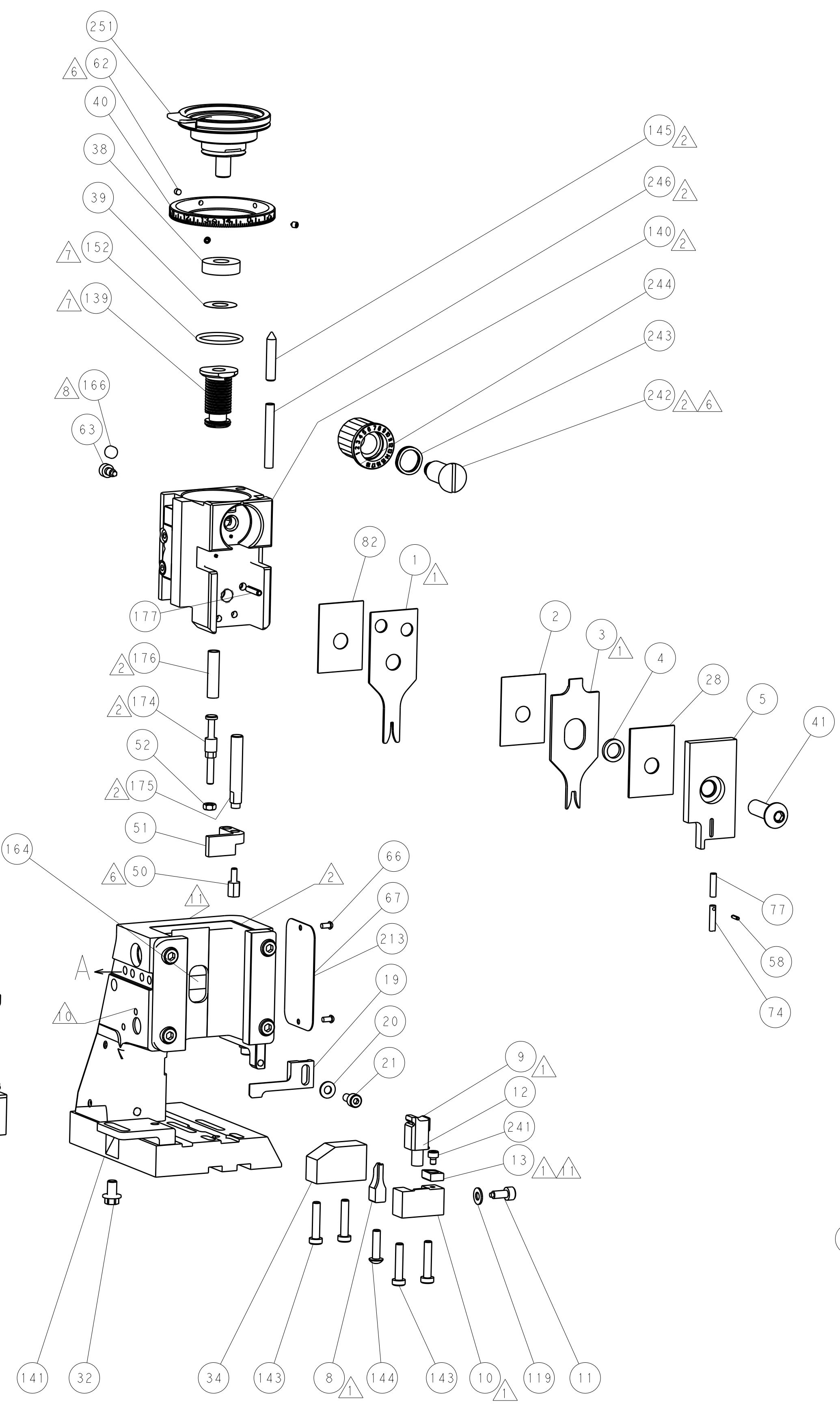
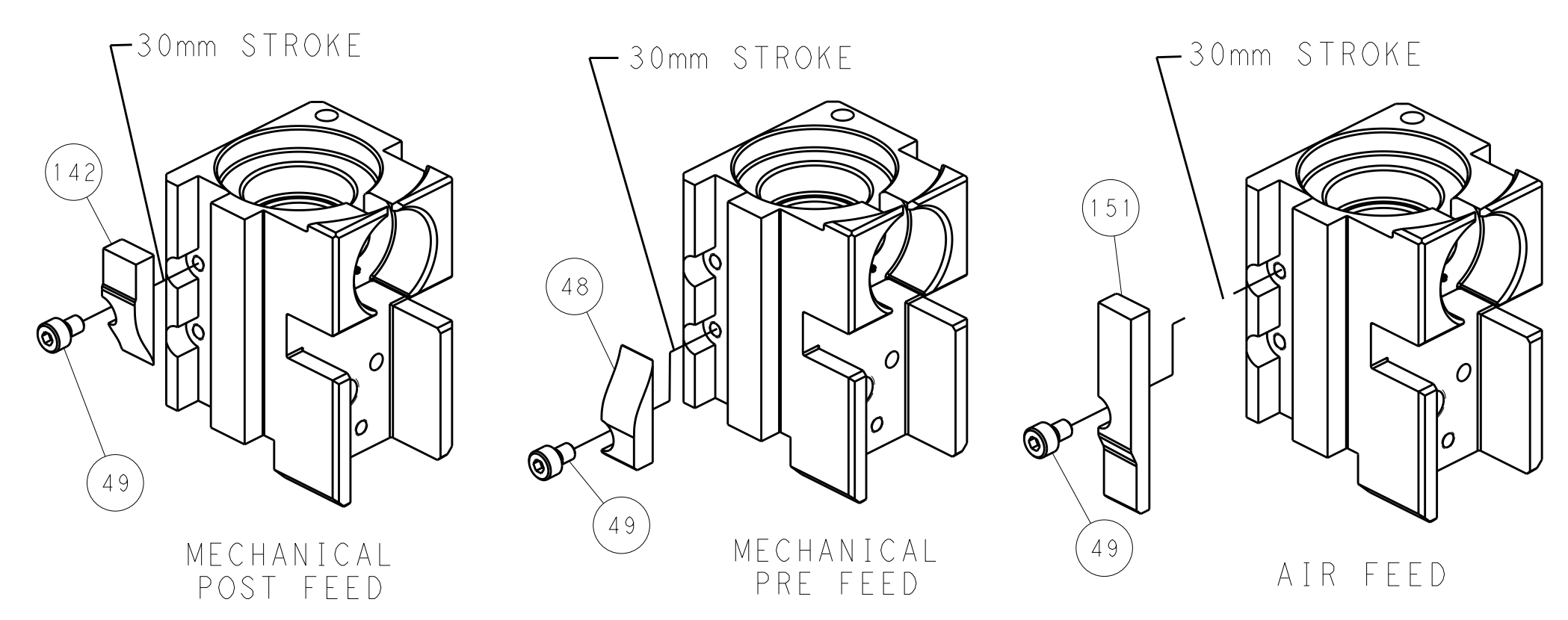
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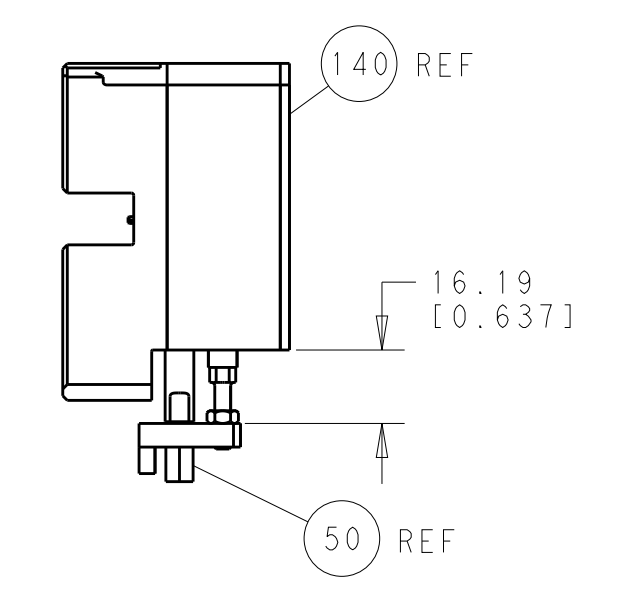
# SERVO LATCH PLATE



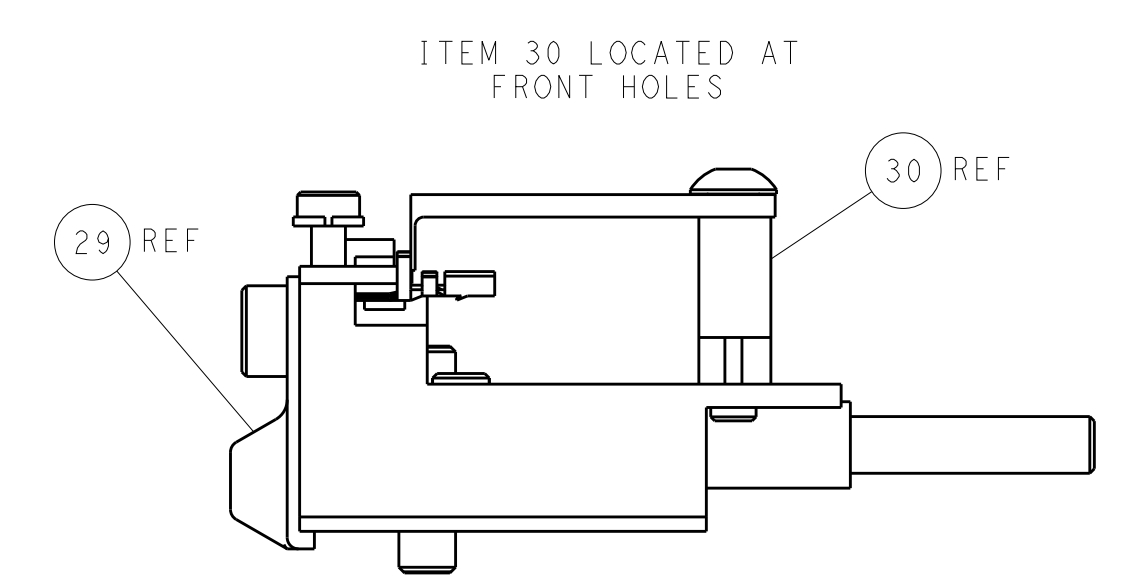
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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

|                                                                                                                            |  |                                        |          |                              |                                                                                                                                    |  |  |
|----------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------|----------|------------------------------|------------------------------------------------------------------------------------------------------------------------------------|--|--|
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|                                                                                                                            |  | CHK                                    | T. ELBIN | 14NOV2012                    |                                                                                                                                    |  |  |
|                                                                                                                            |  | APVD                                   | S. XI    | 14NOV2012                    | NAME<br><br>Ocean Side Feed<br>Applicator<br>-                                                                                     |  |  |
|                                                                                                                            |  | PRODUCT SPEC                           |          |                              |                                                                                                                                    |  |  |
|                                                                                                                            |  | APPLICATION SPEC                       |          |                              |                                                                                                                                    |  |  |
|                                                                                                                            |  | WEIGHT                                 |          | RESTRICTED TO                |                                                                                                                                    |  |  |
|                                                                                                                            |  | MATERIAL                               |          | A1 00779 C=2151834           |                                                                                                                                    |  |  |
|                                                                                                                            |  | Customer Accessible Production Drawing |          | SCALE 1:1 SHEET 4 OF 4 REV A |                                                                                                                                    |  |  |