

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |             |           |   |   |                        |  |
|---|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-------------|-----------|---|---|------------------------|--|
|   |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |             |           |   |   |                        |  |
|   | 2151760-2   | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | -                                 | -                     | 1338683-8   | 5-18022-5 | - | - | -                      |  |
|   | 2151760-5   | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 2119951-1                         | -                     | 8-2151760-5 | 1901094-3 | - | - | 2168400-6 (QUANTITY 2) |  |
|   | 2151760-6   | A        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | 2161326-1                         | -                     | 1338683-8   | 5-18022-5 | - | - | -                      |  |
|   | 2151760-7   | A        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -           | -         | - | - | -                      |  |
|   | 7-2151760-7 | A        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -           | -         | - | - | -                      |  |
|   |             |          |                          |                   |                                   |                       |             |           |   |   |                        |  |
|   |             |          |                          |                   |                                   |                       |             |           |   |   |                        |  |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP WIRE                           | SIZE           | TYPE |
|                                      | 6.35 mm [.250] | F    |
|                                      | 8.26 mm [.325] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: G&H Lear TERMINAL TE CRIMP SPECIFICATION |                   |                              |                   |
|---|-------------------|------------------------------|-------------------|
| TERMINAL NAME: TERMINAL                                 |                   |                              |                   |
| WIRE STRIP LENGTH                                       |                   | INSULATION DIAMETER RANGE    |                   |
| 5.50-7.00 mm [.217-.276 IN]                             |                   | Ø0.00-6.22 mm [.000-.245 IN] |                   |
| TERMINAL APPLICATION SPECIFICATION                      | NONE              |                              |                   |
| TERMINALS APPLIED                                       |                   |                              |                   |
| TE TERMINAL   | G&H Lear TERMINAL | TE TERMINAL                  | G&H Lear TERMINAL |
| 2113297-1   | 26741.122.179     |                              |                   |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 10.00mm2  | 4.80 +/- 0.05 [.189 +/- .002] | 1.2                            |
| 6.00mm2   | 3.76 +/- 0.05 [.148 +/- .002] | 13.5                           |

- 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:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151760-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151760-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151760-6
- 5 ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT
- 13 GRIND AT ASSEMBLY.

**\*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.

| -77 | -7 | -6 | -5 | -2 | PART NO   | DESCRIPTION                                    | ITEM NO |
|-----|----|----|----|----|-----------|--|---------|
| -   | 1  | 1  | 1  | 1  | 2119091-2 | SHIM, LAMINATE                                 | 270     |
| -   | 1  | 1  | 1  | 1  | 1633782-3 | FENCE  | 267     |
| -   | -  | 1  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK                           | 260     |
| -   | 1  | 1  | 1  | 1  | 455888-5  | SPACER, CRIMPER                                | 259     |
| -   | 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, MISMUMI                      | 249     |
| -   | -  | -  | -  | 1  | 2119641-1 | FEED CAM, AIR FEED                             | 248     |
| -   | 1  | -  | 1  | 1  | 2119798-1 | DETENT PIN                                     | 247     |
| -   | 1  | -  | 1  | 1  | 1-22279-3 | SPRING, COMPRESSION                            | 246     |
| -   | -  | 1  | -  | -  | 2161314-1 | RAM, STEPPED, AMP STYLE, SIDE FEED, NON-ADJUST | 245     |
| -   | 1  | 1  | 1  | 1  | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT              | 244     |
| -   | 1  | 1  | 1  | 1  | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST            | 243     |

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

| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |           |     |      |
|--------------|-----|------|-----------|-----|-------------|-----------|-----|------|
| 2119599-1    | A   | 66   | P         | LTM | DESCRIPTION | DATE      | OWN | APVD |
|              |     |      | 1         |     | ORIGINAL    | 15OCT2012 | GH  | TE   |
|              |     |      | 2         |     | REVISED     | 18OCT2012 | GH  | TE   |
|              |     |      | A         |     | RELEASED    | 25JAN2013 | GH  | TE   |

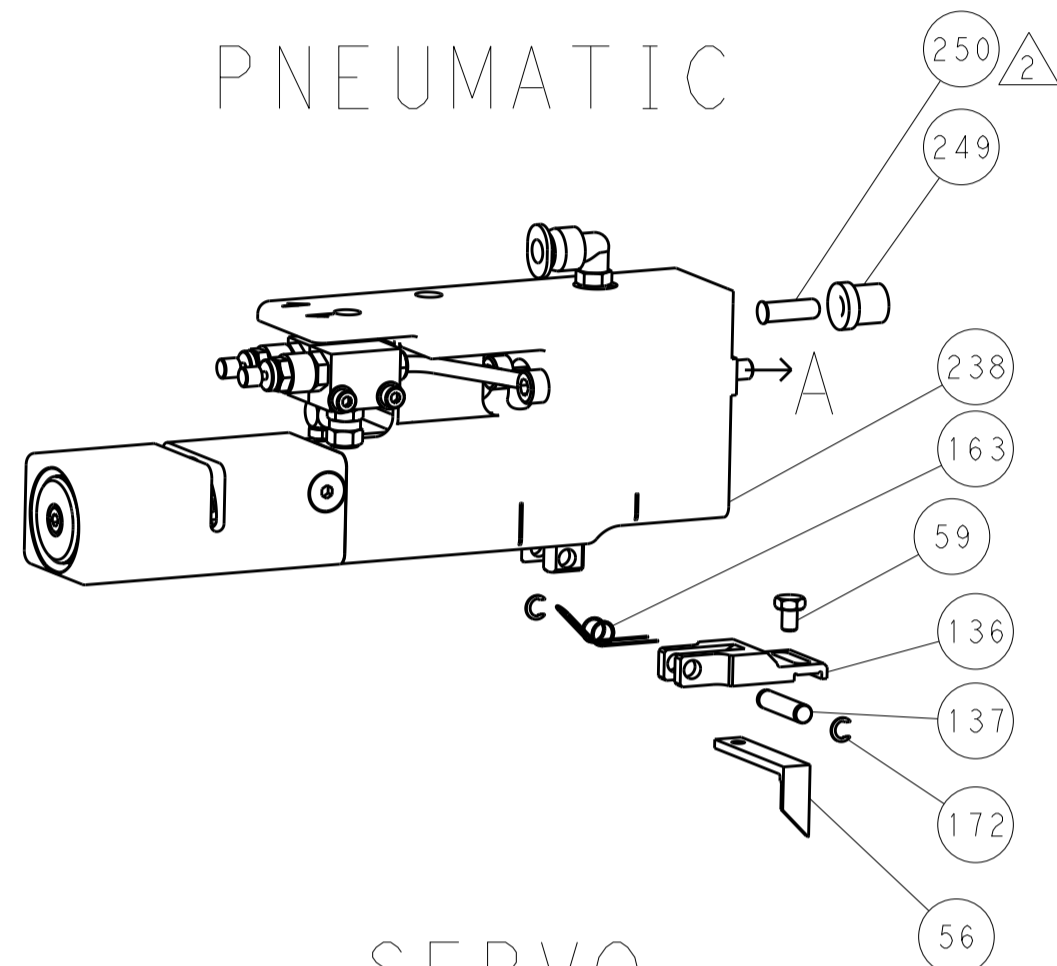
|   |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| 6 | -   | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 1   | 1   | 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   | -   | 2063440-2   | AIR FEED MODULE                     | 238 |
| - | -   | 1   | 1   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213 |
| - | -   | 1   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      | 198 |
| - | 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   | 1-22281-8   | SPRING, COMPRESSION                 | 121 |
| - | 1   | 1   | 1   | 1   | 1   | 2-690438-2  | FRONT STRIP GUIDE                   | 96  |
| - | 4   | 4   | 4   | 4   | 4   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95  |
| - | 1   | 1   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 6.5     | 93  |
| - | 1   | 1   | 1   | 1   | 1   | 318563-1    | GUARD, FRONT CHIP                   | 89  |
| - | 1   | 1   | 1   | 1   | 1   | 2-455888-7  | SPACER, CRIMPER                     | 82  |
| - | 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  |
| 6 | -   | 3   | -   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62  |
| - | 2   | 2   | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61  |
| - | 1   | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60  |
| - | -   | -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | -   | -   | -   | -   | 1   | 1-1338683-1 | FEED PAWL                           | 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   | 1901681-2   | HOLDDOWN, TERMINAL                  | 51  |
| - | 1   | 1   | 1   | 1   | 1   | 2-1752354-1 | STANDOFF, HOLD-DOWN                 | 50  |
| - | -   | -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | 1   | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46  |
| - | 1   | -   | -   | -   | 1   | 2161311-1   | RAM, STEPPED, AMP STYLE, SIDE FEED  | 44  |
| - | 1   | 1   | 1   | 1   | 1   | 1-2079383-5 | SCR, BHSC, RoHS (M8 X 40)           | 41  |
| - | 1   | -   | -   | -   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
| - | 1   | -   | -   | -   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
| - | 1   | 1   | 1   | 1   | 1   | 2119644-8   | RAM WASHER, PRECISION               | 38  |
| 6 | -   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37  |
| - | 1   | -   | -   | -   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35  |
| - | 1   | 1   | 1   | 1   | 1   | 3-1752356-3 | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2   | 2   | 2   | 1-2079383-3 | SCR, BHSC, RoHS (M4 X 25)           | 33  |
| - | 1   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 X 8mm LONG    | 32  |
| - | 1   | 1   | 1   | 1   | 1   | 2-1320908-5 | SPACER, STRIP GUIDE                 | 30  |
| - | 1   | 1   | 1   | 1   | 1   | 1901086-9   | PLATE, STRIP GUIDE                  | 29  |
| - | 1   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| - | 2   | 2   | 2   | 2   | 2   | 22281-9     | SPRING, COMPRESSION                 | 27  |
| - | 1   | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26  |
| - | 1   | 1   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25  |
| - | 1   | 1   | 1   | 1   | 1   | 1320928-6   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23  |
| - | 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   | 2119533-2   | 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   | 1-356885-3  | STOP, SHEAR                         | 11  |
| 1 | -   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| 1 | -   | 1   | 1   | 1   | 1   | 318707-8    | FLOATING SHEAR, FRONT               | 9   |
| 1 | 1   | 1   | 1   | 1   | 1   | 1633929-1   | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 1   | 1-2119757-3 | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 238011-3    | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 1   | 1   | 1   | 1   | 1   | 5-1633961-7 | CRIMPER, INSULATION F PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 2-455888-2  | SPACER, CRIMPER                     | 2   |
| 1 | 1   | 1   | 1   | 1   | 1   | 456432-8    | CRIMPER, WIRE                       | 1   |

| DIMENSIONS: |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DRAWING NO   |               | RESTRICTED TO                |        |
|-------------|------------|--|-------------|--------------|---------------|------------------------------|--------|
| mm          | 0 PLC ±0.1 | 1 PLC ±0.1                             | 2 PLC ±0.02 | 3 PLC ±0.005 | 4 PLC ±0.0005 | ANGLES ±0.0005               | FINISH |
| MATERIAL    |            | FINISH                                 |             | WEIGHT       |               | SCALE                        |        |
|             |            |  |             | A1 00779     |               | SCALE 1:2 SHEET 1 OF 4 REV A |        |

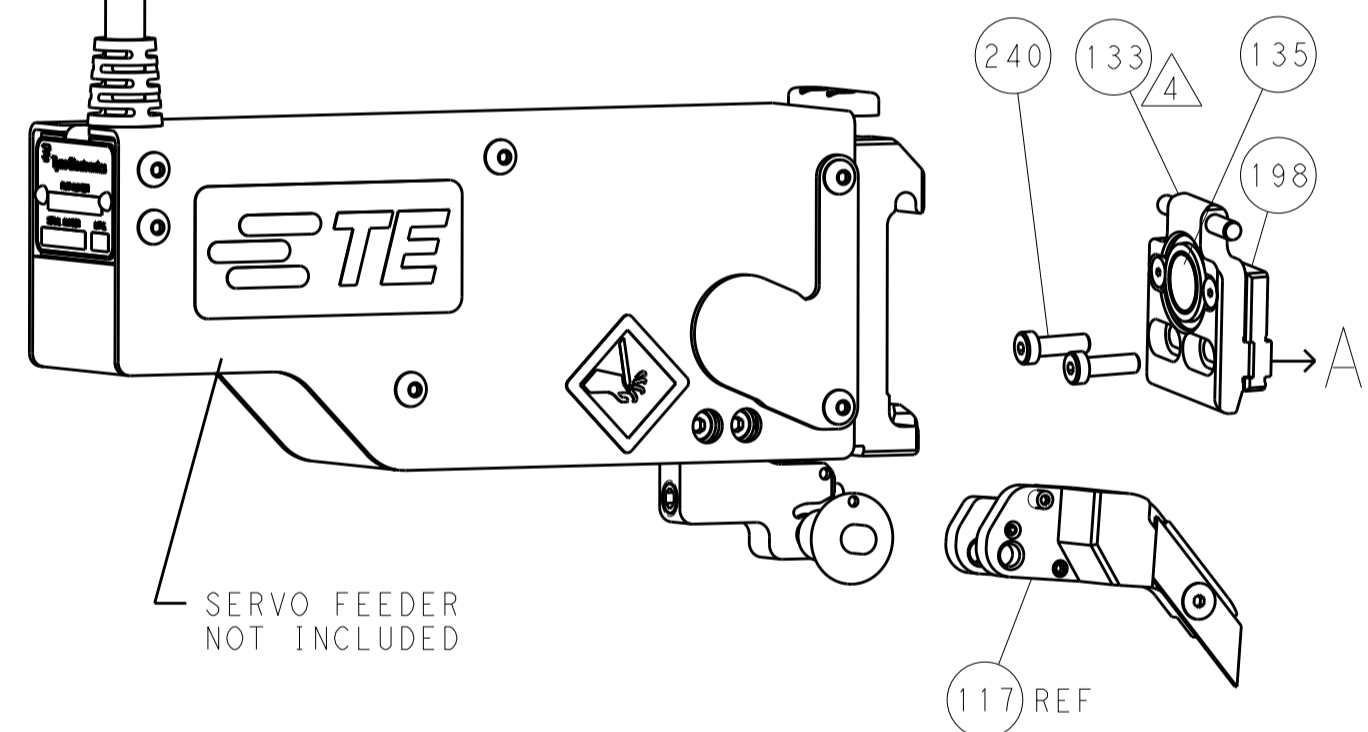
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    | -   | SEE SHEET 1 | -    | -   | -    |

### FEED TYPE

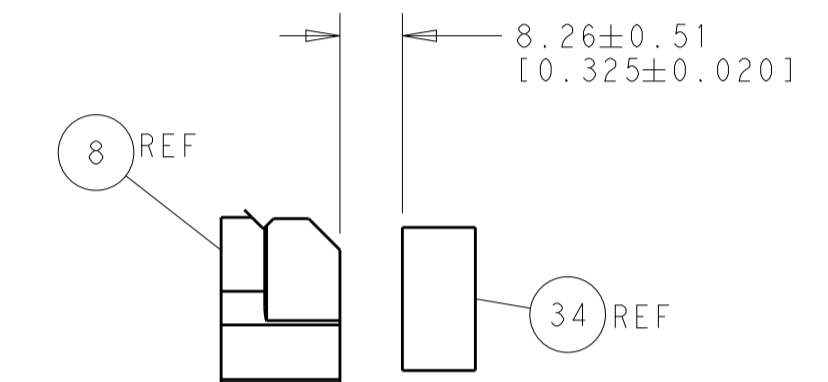
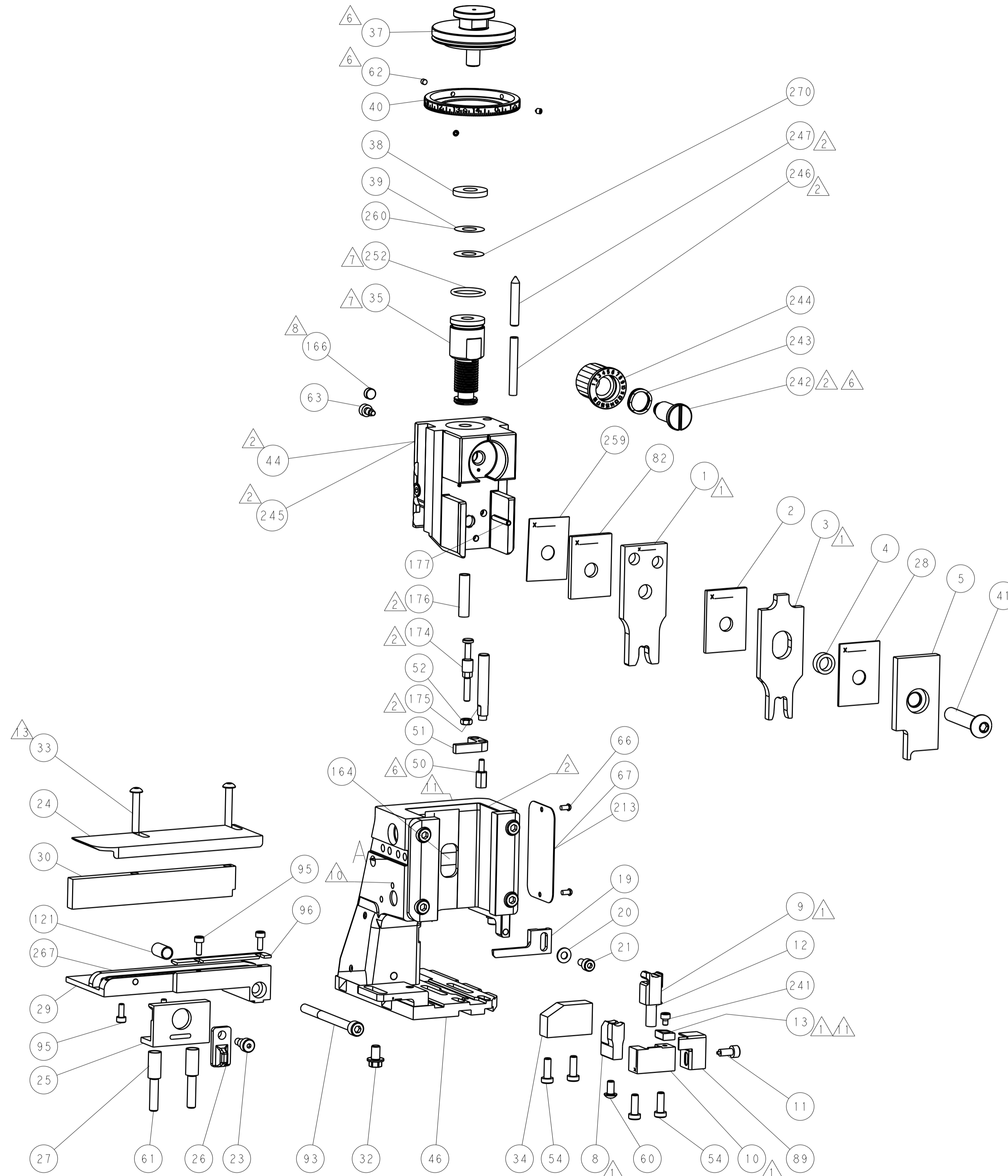
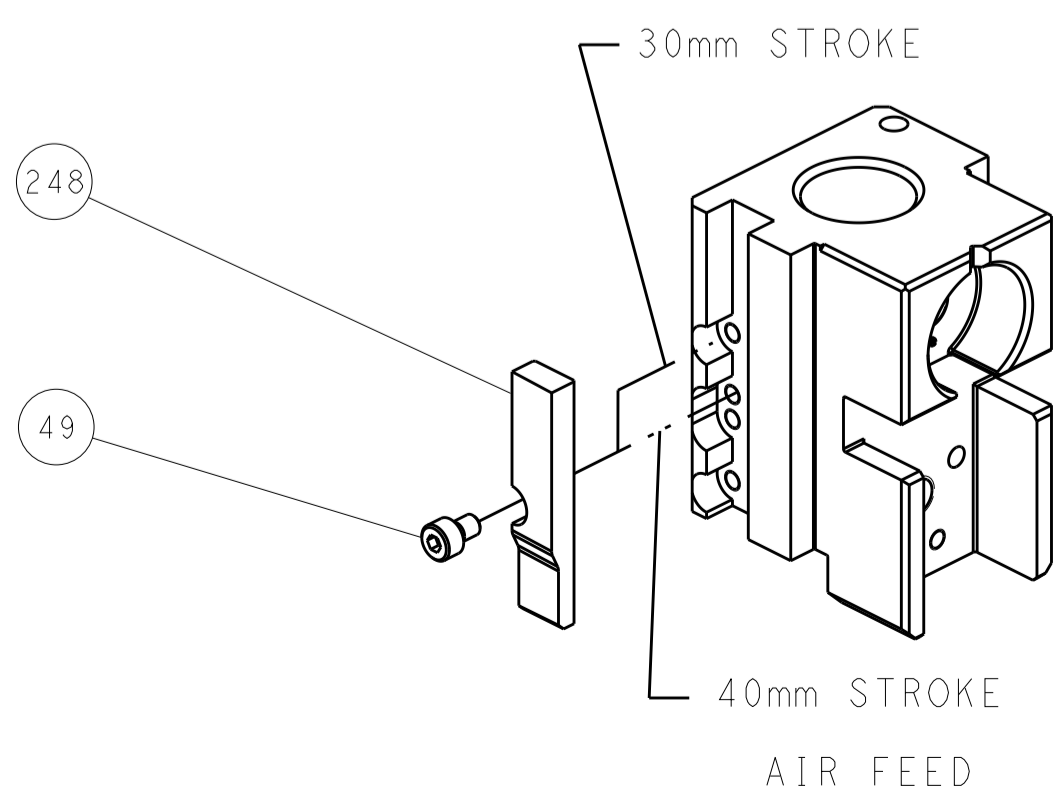
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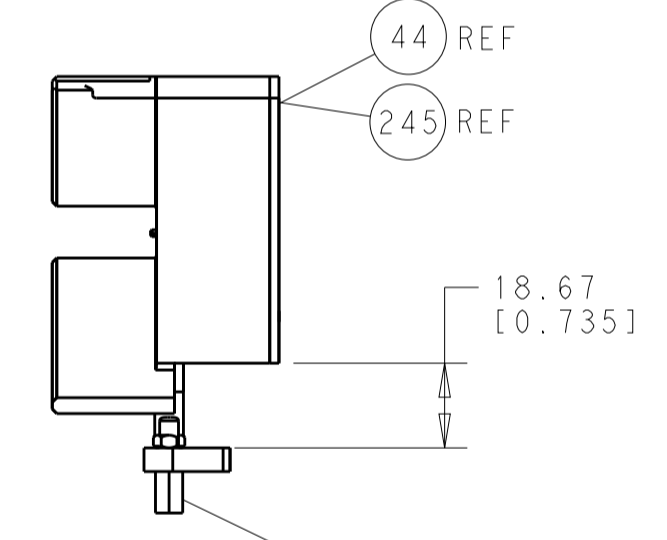
### SERVO LATCH PLATE



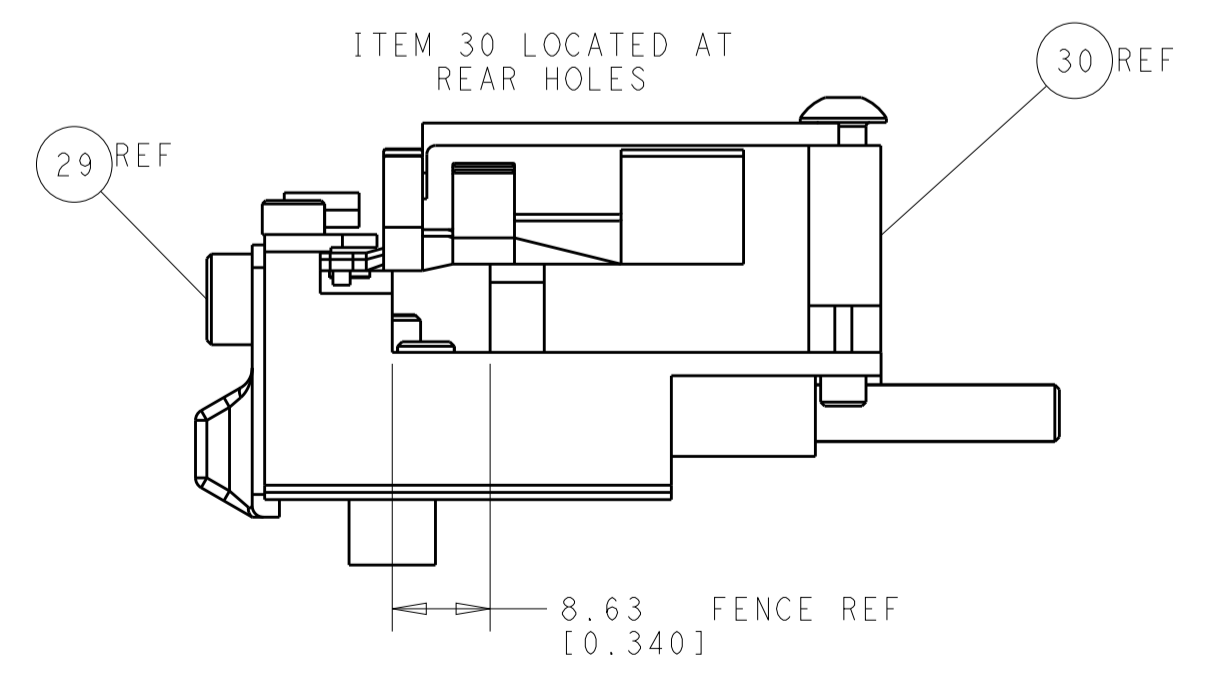
### CAM POSITIONS



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)

|  |            |  |             |                          |               |  |   |
|--|------------|--|-------------|--------------------------|---------------|--|---|
| DIMENSIONS:                            |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | OWN: HOFFNER 12OCT2012   |               | TE Connectivity                              |   |
| mm                                     | 0 PLC ±0.1 | 1 PLC ±0.1                             | 2 PLC ±0.02 | 3 PLC ±0.005             | 4 PLC ±0.0005 | ANGLES ±0.0005                               | TE Connectivity Harrisburg, PA 17105-3608 |
| MATERIAL:                              |            |  |             | APVD: T. ELBIN 15OCT2012 |               | NAME: Ocean Side Feed Applicator             |   |
| FINISH:                                |            |  |             | WEIGHT:                  |               | SIZE: CAGE CODE: DRAWING NO: 00779 ©=2151760 |   |
| Customer Accessible Production Drawing |            |  |             | SCALE: 1:2               |               | SHEET 2 OF 4 REV A                           |   |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |             |           |                        |           |
|--|-------------|--------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-------------|-----------|------------------------|-----------|
|  |             |                          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |             |           |                        |           |
|  | 2-2151760-2 | A                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | -                                 | 1338683-8             | 5-18022-5   | -         | -                      | -         |
|  |             |                          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | 8-2151760-5 | 1901094-3 | 2168400-6 (QUANTITY 2) |           |
|  | 2-2151760-5 | A                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | -                                 | 1338683-8             | 5-18022-5   | -         | -                      | -         |
|  |             |                          |                          |                   | PNEUMATIC FEED                    | 2119950-1             | 1338683-8   | 5-18022-5 | 2119641-2              | 2119799-1 |
| 2-2151760-7                                  | A           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                 | -                                 | -                     | -           | -         | -                      |           |
| 7-2151760-7                                  | A           | CRIMP TOOLING KIT        | -                        | -                 | -                                 | -                     | -           | -         | -                      |           |

| APPLICATOR DATA         |                |      |
|-------------------------|----------------|------|
| CRIMP                   | SIZE           | TYPE |
| WIRE                    | 6.35 mm [.250] | F    |
| INSUL                   | 8.26 mm [.325] | F    |
| APPLICATOR INSTRUCTIONS |                |      |
| 408-10389               |                |      |

| TERMINAL DATA: G&H Lear TERMINAL TE CRIMP SPECIFICATION |                   |                              |                   |
|---|-------------------|------------------------------|-------------------|
| TERMINAL NAME: TERMINAL                                 |                   |                              |                   |
| WIRE STRIP LENGTH                                       |                   | INSULATION DIAMETER RANGE    |                   |
| 5.50-7.00 mm [.217-.276 IN]                             |                   | Ø0.00-6.22 mm [.000-.245 IN] |                   |
| TERMINAL APPLICATION SPECIFICATION                      | NONE              | -                            | -                 |
| TERMINALS APPLIED                                       |                   |                              |                   |
| TE TERMINAL   | G&H Lear TERMINAL | TE TERMINAL                  | G&H Lear TERMINAL |
| 2113297-1   | 26741.122.179     |                              |                   |

| WIRE SIZE |  | CRIMP HEIGHT mm [INCH]        |  | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--|-------------------------------|--|--------------------------------|
| 10.00mm2  |  | 4.80 +/- 0.05 [.189 +/- .002] |  | 1.2                            |
| 6.00mm2   |  | 3.76 +/- 0.05 [.148 +/- .002] |  | 13.5                           |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151760-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151760-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50,62 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- GRIND AT ASSEMBLY.

\*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   | 2119091-2 | SHIM, LAMINATE                      | 270     |
| -   | 1   | 1   | 1   | 1633782-3 | FENCE                               | 267     |
| -   | 1   | 1   | 1   | 455888-5  | SPACER, CRIMPER                     | 259     |
| -   | 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   | 1-22279-3 | SPRING, COMPRESSION                 | 246     |
| -   | 1   | 1   | 1   | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -   | 1   | 1   | 1   | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -   | 1   | 1   | 1   | 2119083-1 | RETAINER, INSULATION DIAL           | 242     |
| -   | 1   | 1   | 1   | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0            | 241     |
| -77 | -27 | -25 | -22 | PART NO   | DESCRIPTION                         | ITEM NO |

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

| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
|              |     |      | -         | -   | SEE SHEET 1 | -    | -   | -    |

|     |     |     |     |             |                                      |         |
|-----|-----|-----|-----|-------------|--------------------------------------|---------|
| -   | -   | 2   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16        | 240     |
| -   | -   | -   | 1   | 2063440-2   | AIR FEED MODULE                      | 238     |
| -   | -   | -   | 1   | 2119740-2   | TAG, IDENTIFICATION                  | 213     |
| -   | -   | -   | 1   | 1901094-3   | SPACER, FEEDER                       | 198     |
| -   | 1   | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0       | 177     |
| -   | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                  | 176     |
| -   | 1   | 1   | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                  | 175     |
| -   | 1   | 1   | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                  | 174     |
| -   | -   | -   | 2   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT  | 172     |
| -   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY       | 166     |
| -   | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                    | 164     |
| -   | -   | -   | 1   | 240638-1    | SPRING, FEED FINGER                  | 163     |
| -   | 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   | 2119798-2   | DETENT PIN                           | 145     |
| -   | 1   | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)            | 144     |
| -   | 4   | 4   | 4   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20        | 143     |
| -   | 1   | 1   | 1   | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF        | 141     |
| -   | 1   | 1   | 1   | 2161312-1   | RAM, STEPPED, ASIAN STYLE, SIDE FEED | 140     |
| -   | 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   | 1-22281-8   | SPRING, COMPRESSION                  | 121     |
| -   | 1   | 1   | 1   | 2-690438-2  | FRONT STRIP GUIDE                    | 96      |
| -   | 4   | 4   | 4   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0      | 95      |
| -   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65       | 93      |
| -   | 1   | 1   | 1   | 318563-1    | GUARD, FRONT CHIP                    | 89      |
| -   | 1   | 1   | 1   | 2-455888-7  | SPACER, CRIMPER                      | 82      |
| -   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE                | 71      |
| -   | 1   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                  | 67      |
| -   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS               | 66      |
| -   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT             | 63      |
| -   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0  | 62      |
| -   | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0        | 61      |
| -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0            | 59      |
| -   | -   | -   | 1   | 1-1338683-1 | FEED PAWL                            | 56      |
| -   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5            | 52      |
| -   | 1   | 1   | 1   | 1901681-2   | HOLDDOWN, TERMINAL                   | 51      |
| -   | 1   | 1   | 1   | 2-1752354-1 | STANDOFF, HOLD-DOWN                  | 50      |
| -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0             | 49      |
| -   | 1   | 1   | 1   | 1-2079383-5 | SCR, BHSC, RoHS (M8 X 40)            | 41      |
| -   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT    | 40      |
| -   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                 | 39      |
| -   | 1   | 1   | 1   | 2119644-8   | RAM WASHER, PRECISION                | 38      |
| -   | 1   | 1   | 1   | 3-1752356-3 | SUPPORT, TERMINAL                    | 34      |
| -   | 2   | 2   | 2   | 1-2079383-3 | SCR, BHSC, RoHS (M4 X 25)            | 33      |
| -   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG     | 32      |
| -   | 1   | 1   | 1   | 2-1320908-5 | SPACER, STRIP GUIDE                  | 30      |
| -   | 1   | 1   | 1   | 1901086-9   | PLATE, STRIP GUIDE                   | 29      |
| -   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                      | 28      |
| -   | 2   | 2   | 2   | 22281-9     | SPRING, COMPRESSION                  | 27      |
| -   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                  | 26      |
| -   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                       | 25      |
| -   | 1   | 1   | 1   | 1320928-6   | STRIP GUIDE                          | 24      |
| -   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0      | 23      |
| -   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0      | 21      |
| -   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                 | 20      |
| -   | 1   | 1   | 1   | 2119533-2   | STRIPPER, SIDE FEED                  | 19      |
| -   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                        | 13      |
| -   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                  | 12      |
| -   | 1   | 1   | 1   | 1-356885-3  | STOP, SHEAR                          | 11      |
| -   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                  | 10      |
| -   | 1   | 1   | 1   | 318707-8    | FLOATING SHEAR, FRONT                | 9       |
| -   | 1   | 1   | 1   | 1633929-1   | ANVIL, COMBINATION                   | 8       |
| -   | -   | -   | -   | -           | -                                    | 7       |
| -   | -   | -   | -   | -           | -                                    | 6       |
| -   | 1   | 1   | 1   | 1-2119757-3 | DEPRESSOR, SHEAR                     | 5       |
| -   | 1   | 1   | 1   | 238011-3    | BLOCK, CRIMPER SPACER                | 4       |
| -   | 1   | 1   | 1   | 5-1633961-7 | CRIMPER, INSULATION F PREMIUM        | 3       |
| -   | 1   | 1   | 1   | 2-455888-2  | SPACER, CRIMPER                      | 2       |
| -   | 1   | 1   | 1   | 456432-8    | CRIMPER, WIRE                        | 1       |
| -77 | -27 | -25 | -22 | PART NO     | DESCRIPTION                          | ITEM NO |

|  |           |  |            |                          |           |                         |        |                          |       |                                  |     |
|--|-----------|--|------------|--------------------------|-----------|-------------------------|--------|--------------------------|-------|----------------------------------|-----|
| DIMENSIONS:                            |           | TOLERANCES UNLESS OTHERWISE SPECIFIED: |            | DRAWN: HOFFNER 12OCT2012 |           | CHK: T. ELBIN 15OCT2012 |        | APVD: T. ELBIN 15OCT2012 |       | NAME: Ocean Side Feed Applicator |     |
| mm                                     | 0 PLC ±.1 | 1 PLC ±0.1                             | 2 PLC ±0.2 | 3 PLC ±0.005             | 4 PLC ±.1 | ANGLES ±.1              | FINISH | WT                       | SCALE | SHEET                            | REV |
| MATERIAL                               |           | FINISH                                 |            | WEIGHT                   |           | SCALE                   |        | SHEET                    |       | REV                              |     |
|  |           |  |            |                          |           | A1 00779                |        | C=2151760                |       | A                                |     |
| Customer Accessible Production Drawing |           |  |            |                          |           |                         |        |                          |       | SCALE 1:2 SHEET 3 OF 4 REV A     |     |

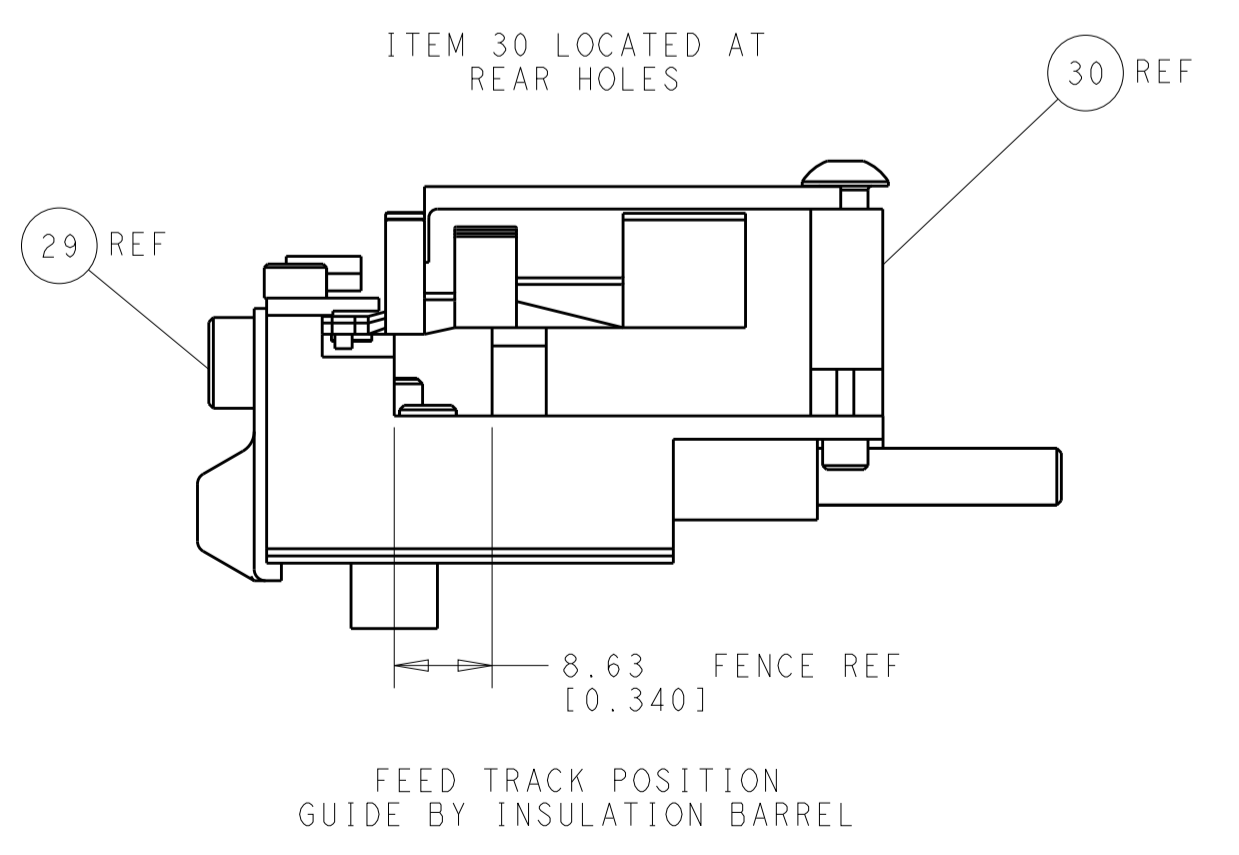
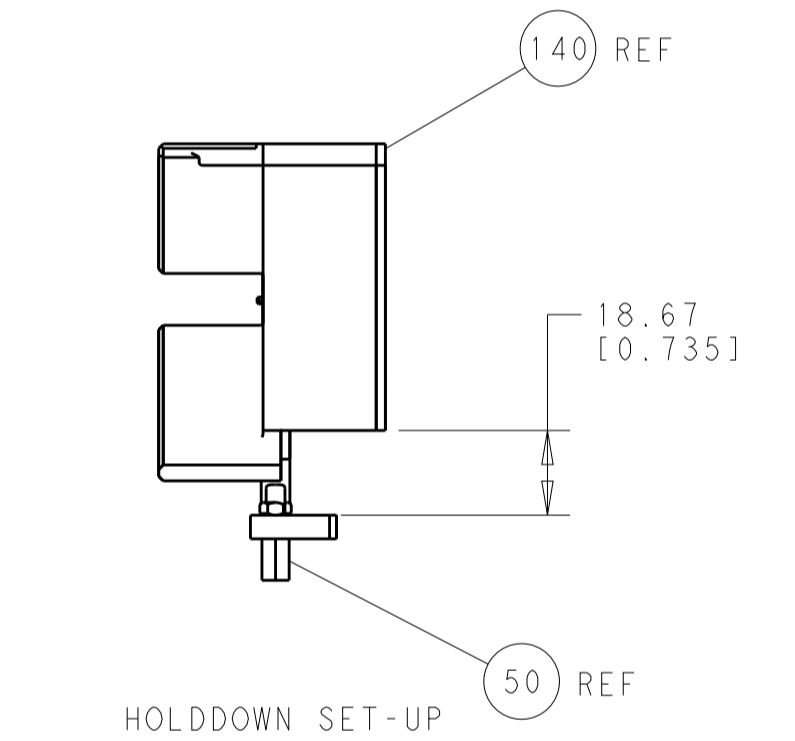
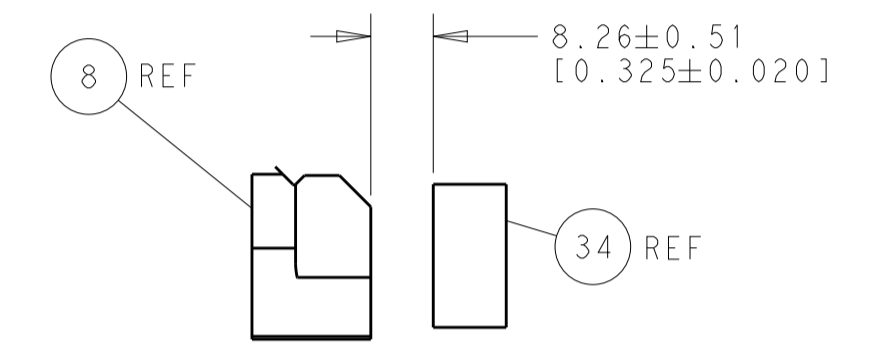
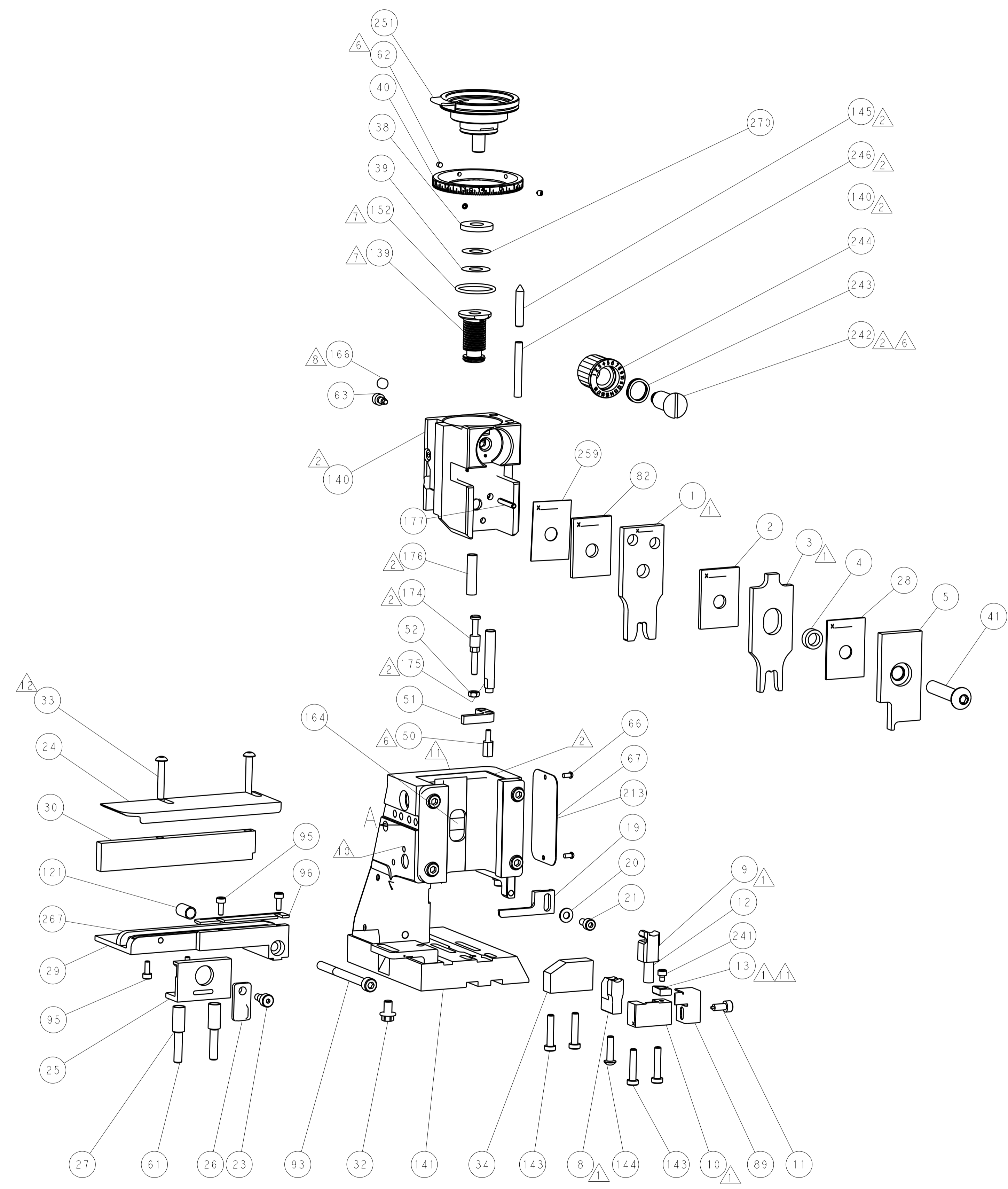
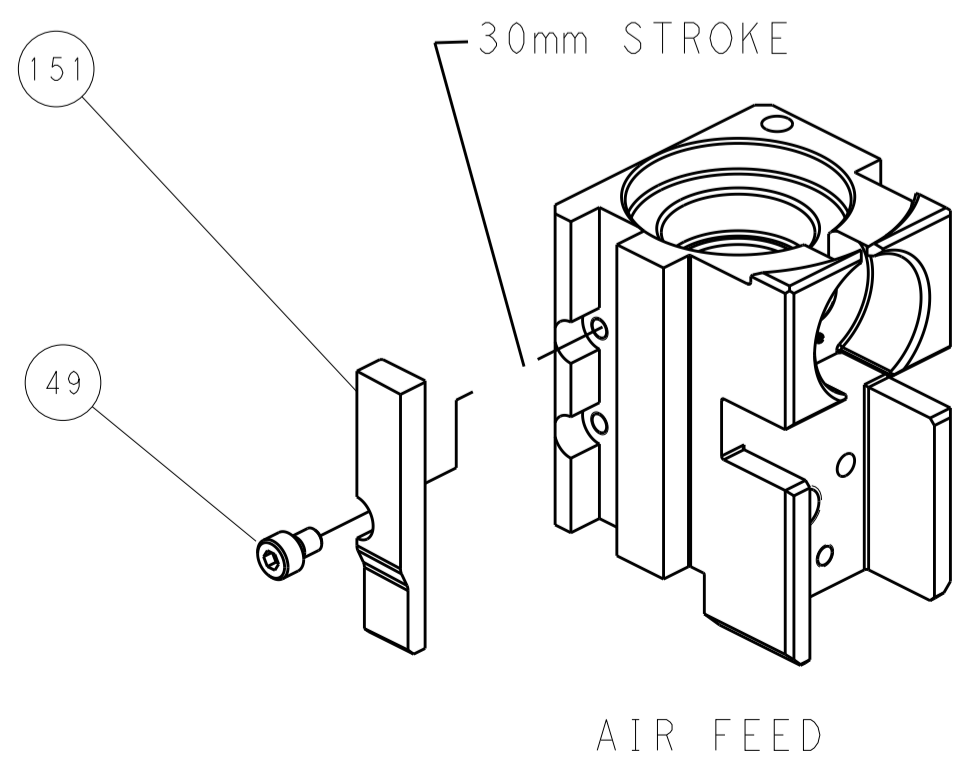
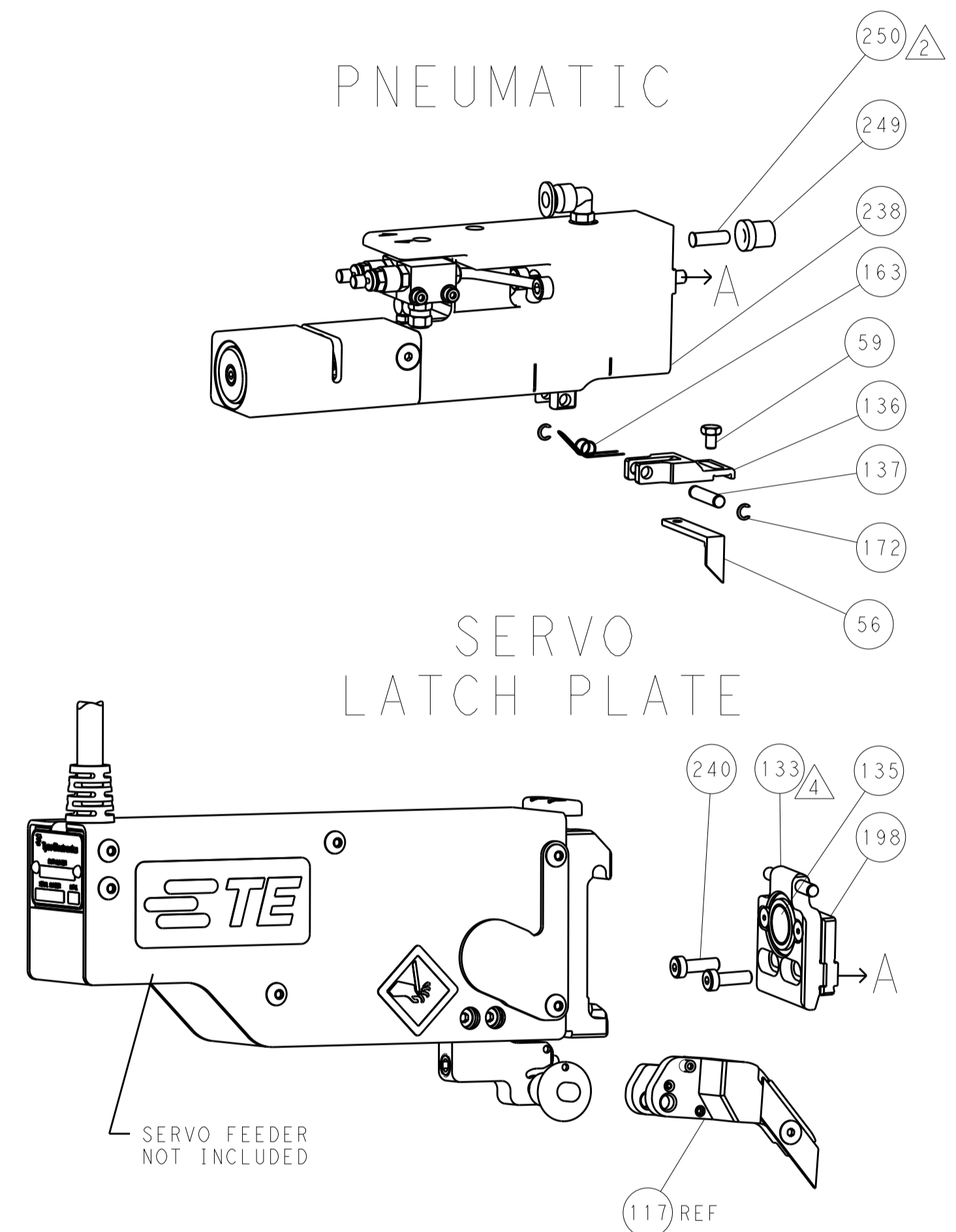
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTH | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    |     | SEE SHEET 1 |      |     |      |

### FEED TYPE

### 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: HOFFNER 12OCT2012 |               | TE Connectivity     |        |
| mm                                     | 0 PLC ±0.1 | 1 PLC ±0.1                             | 2 PLC ±0.02 | 3 PLC ±0.005           | 4 PLC ±0.0005 | ANGLES ±            | FINISH |
| MATERIAL:                              |            |  |             | CAGE CODE: 00779       |               | DRAWING NO: 2151760 |        |
| Customer Accessible Production Drawing |            |  |             | SCALE: 1:2             |               | SHEET 4 OF 4 REV A  |        |