

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE                      | CONVERT TO        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|-----------------------------------------------|-------------|--------------------------|--------------------------|--------------------------------|-------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|                                               | 2266005-1   | A                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1   | 2063440-1              |
|                                               | 2266005-2   | A                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | SERVO LATCH PLATE | 2119951-1             | -         | 8-2266005-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
|                                               |             |                          |                          |                                | SMART APPLICATOR  | 2161326-1             | -         | 8-2266005-4 | -         | -           |                        |
|                                               |             |                          |                          |                                | MECHANICAL FEED   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -           |                        |
|                                               | 2266005-5   | A                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | SERVO LATCH PLATE | 2119951-1             | -         | 8-2266005-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
|                                               |             |                          |                          |                                | SMART APPLICATOR  | 2161326-1             | -         | 8-2266005-4 | -         | -           |                        |
|                                               | 2266005-6   | A                        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | -                 | -                     | -         | -           | -         | -           | -                      |
| 2266005-7                                     | A           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                              | -                 | -                     | -         | -           | -         | -           |                        |
| 7-2266005-7                                   | A           | CRIMP TOOLING KIT        | -                        | -                              | -                 | -                     | -         | -           | -         | -           |                        |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP WIRE      | SIZE           | TYPE |
| WIRE            | 2.29 mm [.090] | F    |
| INSUL           | 3.05 mm [.120] | OV   |

APPLICATOR INSTRUCTIONS 408-10389

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                                    |                            |                 |
|-----------------------------------------------------------|------------------------------------|----------------------------|-----------------|
| TERMINAL NAME: TERMINAL                                   |                                    |                            |                 |
| WIRE STRIP LENGTH                                         |                                    | INSULATION DIAMETER RANGE  |                 |
| 5.00-6.00 mm [.197-.236 IN]                               |                                    | Ø 2.34 mm MAX[.092 IN MAX] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | (A) YAZAKI SPECIFICATION 7114-4021 |                            |                 |
| TERMINALS APPLIED                                         |                                    |                            |                 |
| TE TERMINAL                                               | YAZAKI TERMINAL                    | TE TERMINAL                | YAZAKI TERMINAL |
| (A) 286573-1                                              | (A) 7114-4021                      |                            |                 |

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                                    |                            |                 |
|-----------------------------------------------------------|------------------------------------|----------------------------|-----------------|
| TERMINAL NAME: TERMINAL                                   |                                    |                            |                 |
| WIRE STRIP LENGTH                                         |                                    | INSULATION DIAMETER RANGE  |                 |
| 5.00-6.00 mm [.197-.236 IN]                               |                                    | Ø 2.34 mm MAX[.092 IN MAX] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | (B) YAZAKI SPECIFICATION 7116-4021 |                            |                 |
| TERMINALS APPLIED                                         |                                    |                            |                 |
| TE TERMINAL                                               | YAZAKI TERMINAL                    | TE TERMINAL                | YAZAKI TERMINAL |
| (B) 286639-1                                              | (B) 7116-4021                      |                            |                 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 1.25mm2   | 1.35+/-0.05 [.053+/- .002] | 5.7                            |
| 0.75mm2   | 1.25+/-0.05 [.049+/- .002] | 6.8                            |
| 0.50mm2   | 1.15+/-0.05 [.045+/- .002] | 7.8                            |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 1.25mm2   | 1.15+/-0.05 [.045+/- .002] | 7.6                            |
| 0.75mm2   | 1.10+/-0.05 [.043+/- .002] | 8.1                            |
| 0.50mm2   | 1.00+/-0.05 [.039+/- .002] | 9.1                            |

- 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266005-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266005-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266005-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266005-6
- 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 ITEMS 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.45.

**\*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 | -1 | PART NO   | DESCRIPTION                     | ITEM NO |
|-----|----|----|----|----|----|-----------|---------------------------------|---------|
| -   | -  | 1  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| -   | 1  | -  | 1  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252     |

**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         | LTN | DESCRIPTION | DATE      | OWN | APVD |
|              |     |      | 1         |     | DEVELOPMENT | 17JUL2013 | YY  | UG   |
|              |     |      | A         |     | RELEASED    | 06SEP2013 | BH  | GB   |

|   |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | -   | -   | 1   | -   | 2119640-1   | PUSH ROD, AIR FEED                  | 250 |
| - | -   | -   | -   | 1   | -   | 2079988-1   | BUSHING, LCH5-12, MISUMI            | 249 |
| - | -   | -   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
| - | 1   | -   | 1   | 1   | 1   | 2119798-1   | DETENT PIN                          | 247 |
| - | 1   | -   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| - | -   | 1   | -   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| - | 1   | 1   | 1   | 1   | 1   | 2119082-7   | 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 |
| - | -   | -   | -   | 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   | 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   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54  |
| - | 2   | 2   | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53  |
| - | 1   | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
| - | 1   | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
| - | 1   | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 50  |
| - | -   | -   | -   | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | -   | -   | -   | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48  |
| - | -   | -   | -   | -   | 1   | 2119653-1   | FEED CAM, POST FEED                 | 47  |
| - | 1   | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46  |
| - | 1   | -   | 1   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44  |
| - | 1   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | -   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
| - | 1   | -   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
| - | 1   | 1   | 1   | 1   | 1   | 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   | 1752356-4   | 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   | 1320928-6   | 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   | 462006-6    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 1   | 1-1803057-5 | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 238011-2    | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 1   | 1-1633963-1 | CRIMPER, INSULATION OVERLAP PREMIUM | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1   | 1   | 1   | 1-456406-6  | CRIMPER, WIRE PREMIUM               | 1   |

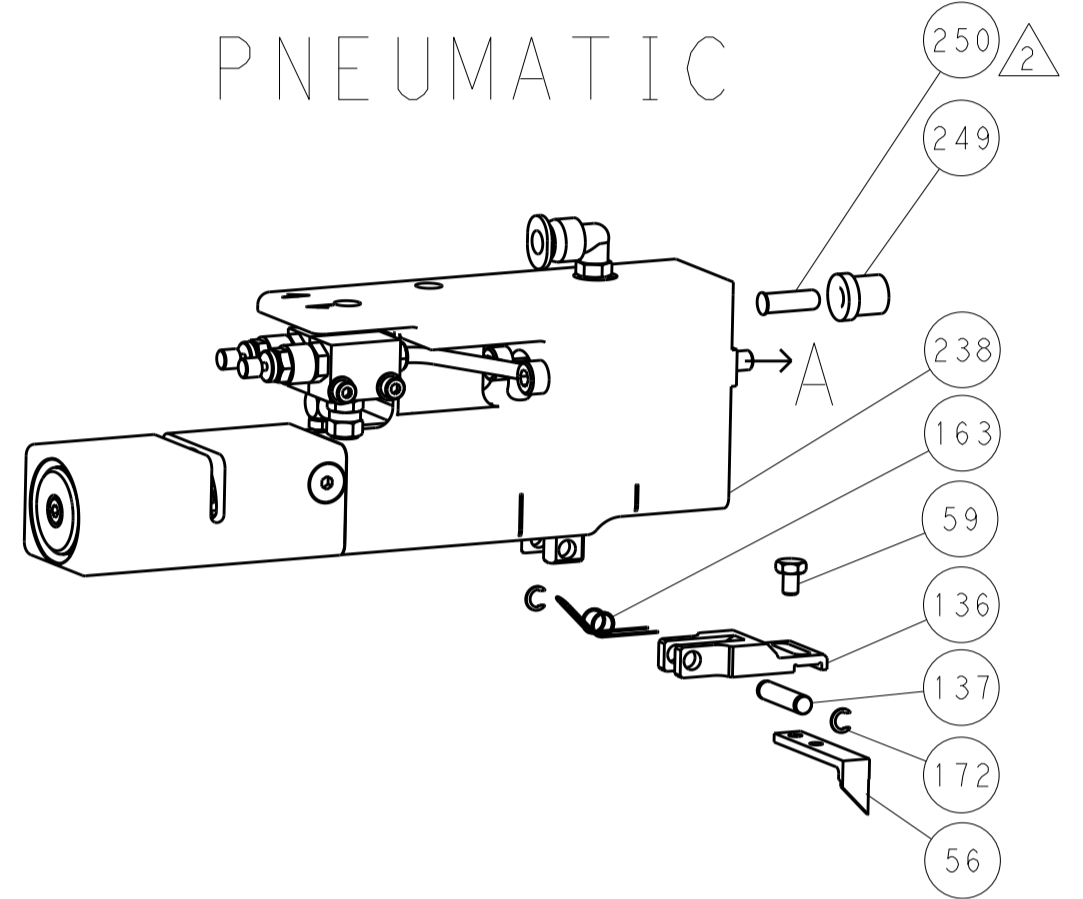
| DIMENSIONS: |             | TOLERANCES UNLESS OTHERWISE SPECIFIED: |               | OWN          | CHK       | DATE      | NAME                                   |  |
|-------------|-------------|----------------------------------------|---------------|--------------|-----------|-----------|----------------------------------------|--|
| mm          | 0 PLC ±.5   | 1 PLC ±.13                             | 2 PLC ±.013   | Y. YIN       | G. BAILEY | 17JUL2013 | Ocean Side Feed Applicator             |  |
|             | 3 PLC ±.013 | 4 PLC ±.0001                           | ANGLES ±.0001 | U. GUO       |           | 17JUL2013 | Customer Accessible Production Drawing |  |
| MATERIAL    | FINISH      | WEIGHT                                 | SCALE         | SHEET 1 OF 4 |           | REV A     | RESTRICTED TO                          |  |

| LOC |     | DIST        |      | REVISIONS |      |  |  |
|-----|-----|-------------|------|-----------|------|--|--|
| P   | LTN | DESCRIPTION | DATE | DMN       | APVD |  |  |
| A   | 66  | SEE SHEET 1 |      |           |      |  |  |

### FEED TYPE MECHANICAL



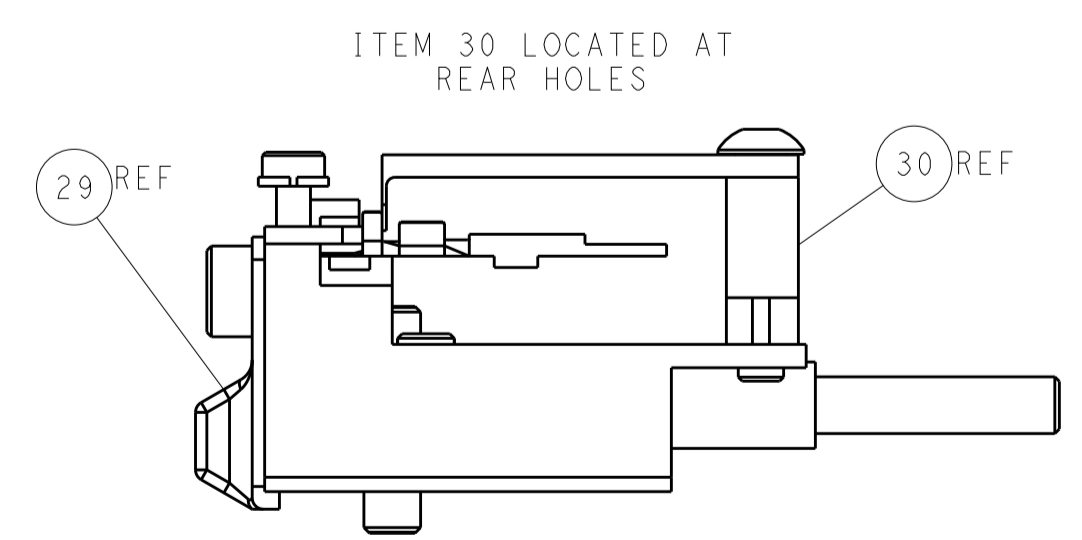
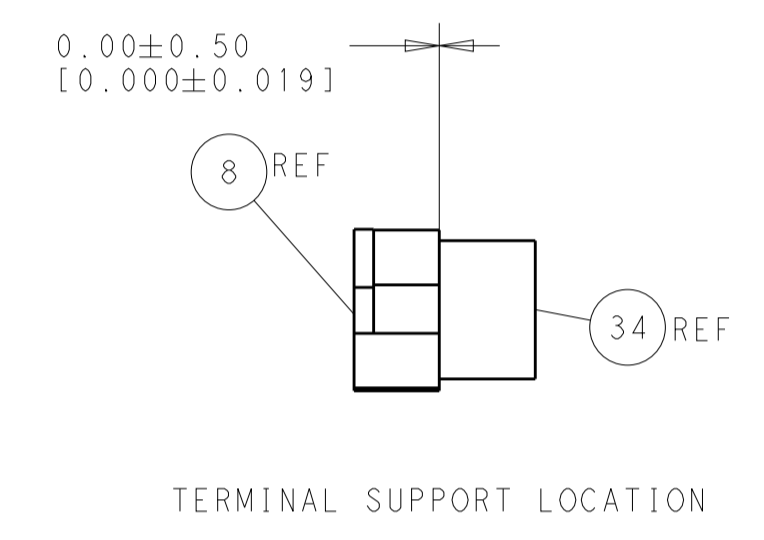
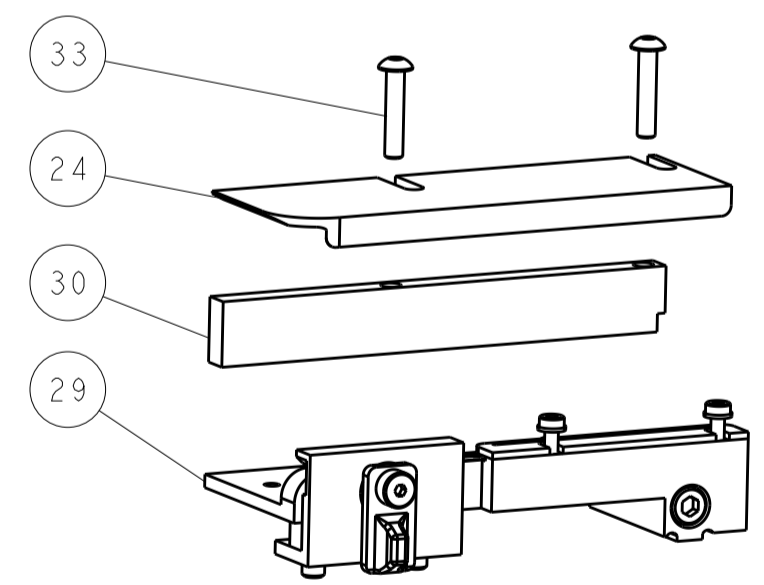
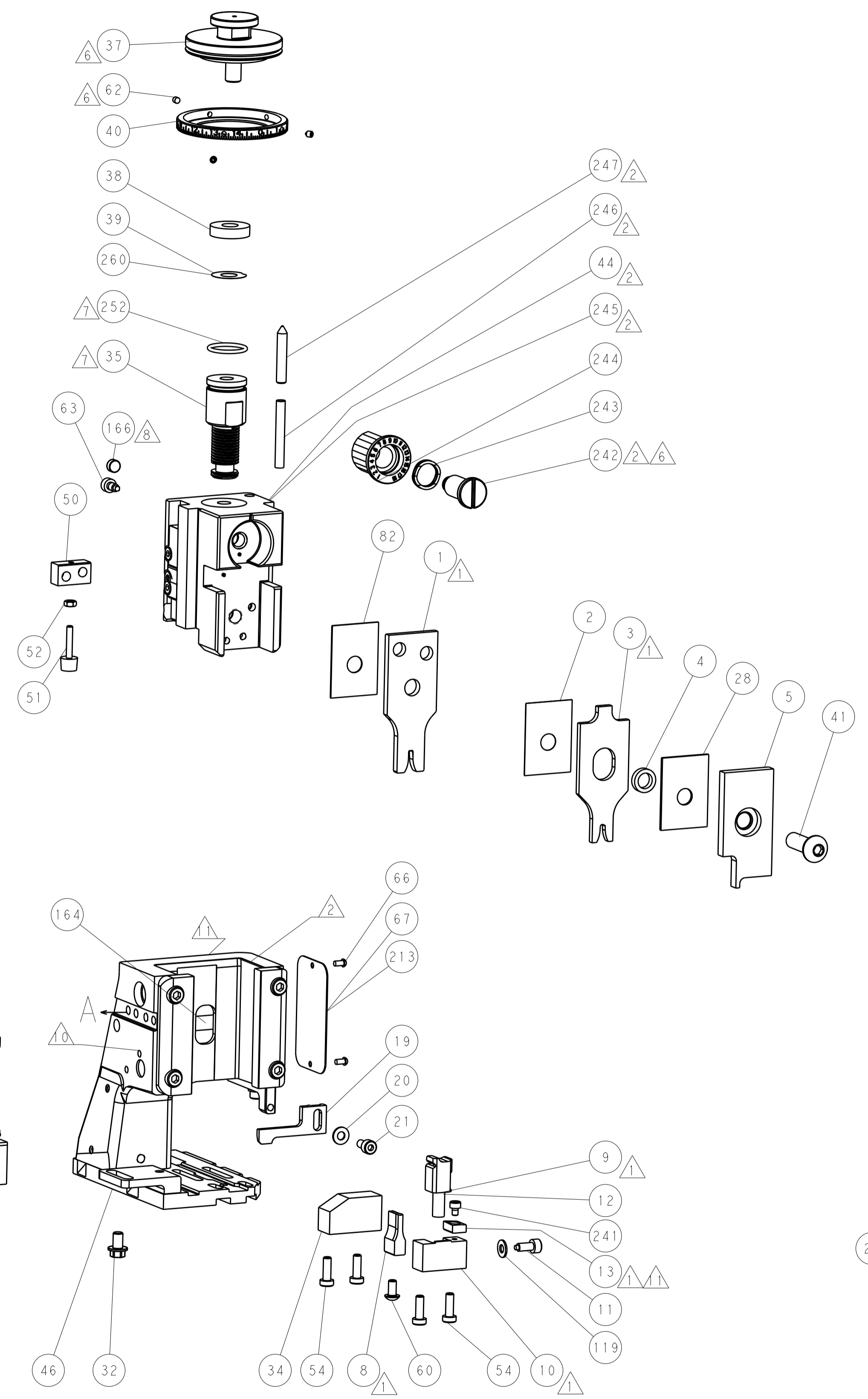
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



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

|             |              |                                        |                                        |      |           |                                              |               |
|-------------|--------------|----------------------------------------|----------------------------------------|------|-----------|----------------------------------------------|---------------|
| DIMENSIONS: |              | TOLERANCES UNLESS OTHERWISE SPECIFIED: |                                        | DMN  | 17JUL2013 | TE Connectivity<br>Harrisburg, PA 17105-3608 |               |
| mm          | 0 PLC ±0.5   | 1 PLC ±0.5                             | 2 PLC ±0.13                            | CHK  | 17JUL2013 |                                              |               |
|             | 3 PLC ±0.013 | 4 PLC ±0.001                           | ANGLES ±0.0001                         | APVD | 17JUL2013 | NAME                                         |               |
| MATERIAL    | FINISH       | WEIGHT                                 | Customer Accessible Production Drawing | SIZE | CAGE CODE | DRAWING NO                                   | RESTRICTED TO |
|             |              |                                        | SCALE                                  | A1   | 00779     | ©=2266005                                    |               |
|             |              |                                        | 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 |           |             |           |             |                        |
|                                              | 2-2266005-1 | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1   | 2063440-1              |
|                                              |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266005-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
|                                              |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266005-4 | -         | -           | -                      |
|                                              | 2-2266005-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -           | -                      |
|                                              |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266005-5 | 1901094-3 | 1-1752354-7 | 2168400-6 (QUANTITY 2) |
|                                              |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266005-4 | -         | -           | -                      |
|                                              | 2-2266005-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -           | -                      |
|                                              |             |          |                          |                   | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1   | 2063440-1              |
|                                              | 2-2266005-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | -           | -                      |
|                                              | 7-2266005-7 | A        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -         | -           | -         | -           | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.29 mm [.090] | F    |
| INSUL                                | 3.05 mm [.120] | OV   |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                 |                             |                 |
|-----------------------------------------------------------|-----------------|-----------------------------|-----------------|
| TERMINAL NAME: TERMINAL                                   |                 |                             |                 |
| WIRE STRIP LENGTH                                         |                 | INSULATION DIAMETER RANGE   |                 |
| 5.00-6.00 mm [.197-.236 IN]                               |                 | Ø 2.34 mm MAX [.092 IN MAX] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | (A) YAZAKI SPEC | -                           | -               |
| TERMINALS APPLIED                                         |                 |                             |                 |
| TE TERMINAL                                               | YAZAKI TERMINAL | TE TERMINAL                 | YAZAKI TERMINAL |
| (A) 286573-1                                              | (A) 7114-4021   |                             |                 |

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                 |                             |                 |
|-----------------------------------------------------------|-----------------|-----------------------------|-----------------|
| TERMINAL NAME: TERMINAL                                   |                 |                             |                 |
| WIRE STRIP LENGTH                                         |                 | INSULATION DIAMETER RANGE   |                 |
| 5.00-6.00 mm [.197-.236 IN]                               |                 | Ø 2.34 mm MAX [.092 IN MAX] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | (B) YAZAKI SPEC | -                           | -               |
| TERMINALS APPLIED                                         |                 |                             |                 |
| TE TERMINAL                                               | YAZAKI TERMINAL | TE TERMINAL                 | YAZAKI TERMINAL |
| (B) 286639-1                                              | (B) 7116-4021   |                             |                 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 1.25mm2   | 1.35+/-0.05 [.053+/- .002] | 5.7                            |
| 0.75mm2   | 1.25+/-0.05 [.049+/- .002] | 6.8                            |
| 0.50mm2   | 1.15+/-0.05 [.045+/- .002] | 7.8                            |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 1.25mm2   | 1.15+/-0.05 [.045+/- .002] | 7.6                            |
| 0.75mm2   | 1.10+/-0.05 [.043+/- .002] | 8.1                            |
| 0.50mm2   | 1.00+/-0.05 [.039+/- .002] | 9.1                            |

- 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266005-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266005-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266005-5
- 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 ITEMS 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.

**\*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.

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

|   |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | 1   | 1   | 1   | 2119782-1   | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | -   | -   | 1   | -   | 2119640-1   | PUSH ROD, AIR FEED                  | 250 |
| - | -   | -   | 1   | -   | 2079988-1   | BUSHING, LCH5-12, MISUMI            | 249 |
| - | 1   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| - | 1   | 1   | 1   | 1   | 2119082-7   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 1   | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241 |
| - | -   | 2   | -   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240 |
| - | -   | -   | -   | 1   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239 |
| - | -   | -   | 1   | -   | 2063440-1   | AIR FEED MODULE                     | 238 |
| - | -   | 1   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213 |
| - | -   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      | 198 |
| - | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 1   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166 |
| - | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | -   | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163 |
| - | 1   | 1   | 1   | 1   | 8-21084-1   | O-RING, .801 ID, .070 DIA, MAT.     | 152 |
| - | -   | -   | 1   | -   | 2119641-2   | FEED CAM, AIR FEED                  | 151 |
| - | 1   | 1   | 1   | 1   | 2119798-2   | DETENT PIN                          | 145 |
| - | 1   | 1   | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144 |
| - | 4   | 4   | 4   | 4   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       | 143 |
| - | -   | -   | -   | 1   | 2119653-2   | FEED CAM, POST FEED                 | 142 |
| - | 1   | 1   | 1   | 1   | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141 |
| - | 1   | 1   | 1   | 1   | 2119650-1   | RAM, ASIAN STYLE, SIDE FEED         | 140 |
| - | 1   | 1   | 1   | 1   | 2119092-2   | BOLT, ADJUSTMENT                    | 139 |
| - | -   | -   | 1   | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137 |
| - | -   | -   | 1   | -   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136 |
| - | -   | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135 |
| - | -   | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133 |
| - | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | -   | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117 |
| - | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | -   | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| - | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | 1   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |
| - | 3   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62  |
| - | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 2   | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53  |
| - | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
| - | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
| - | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 50  |
| - | -   | -   | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | -   | -   | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48  |
| - | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
| - | 1   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
| - | 1   | 1   | 1   | 1   | 2119644-2   | RAM WASHER, PRECISION               | 38  |
| - | 1   | 1   | 1   | 1   | 1752356-4   | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 X 8mm LONG    | 32  |
| - | 1   | 1   | 1   | 1   | 1-1320908-0 | SPACER, STRIP GUIDE                 | 30  |
| - | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1   | 1   | 1320928-6   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 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   | 462006-6    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 1-1803057-5 | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 238011-2    | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 1-1633963-1 | CRIMPER, INSULATION OVERLAP PREMIUM | 3   |
| - | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1   | 1   | 1-456406-6  | CRIMPER, WIRE PREMIUM               | 1   |

| DIMENSIONS: |              | TOLERANCES UNLESS OTHERWISE SPECIFIED: |               | OWN                                    | CHK       | APVD      | NAME                       |
|-------------|--------------|----------------------------------------|---------------|----------------------------------------|-----------|-----------|----------------------------|
| mm          | 0 PLC ±.5    | 1 PLC ±0.5                             | 2 PLC ±0.13   | Y. YIN                                 | 17JUL2013 | 17JUL2013 | TE Connectivity            |
|             | 3 PLC ±0.013 | 4 PLC ±0.001                           | ANGLES ±.0001 | G. BAILEY                              |           |           | Harrisburg, PA 17105-3608  |
|             |              |                                        |               | H. GUO                                 | 17JUL2013 |           | Ocean Side Feed Applicator |
| MATERIAL    | FINISH       | WEIGHT                                 | SCALE         | Customer Accessible Production Drawing |           | 3         | REV A                      |

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

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

# FEED TYPE MECHANICAL



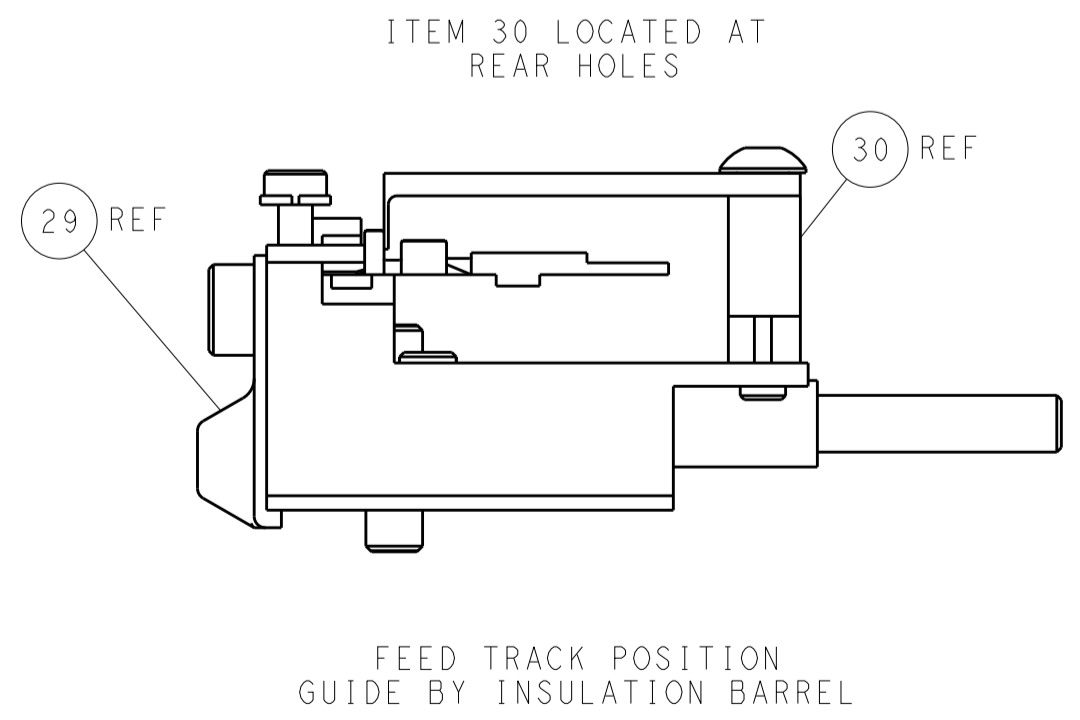
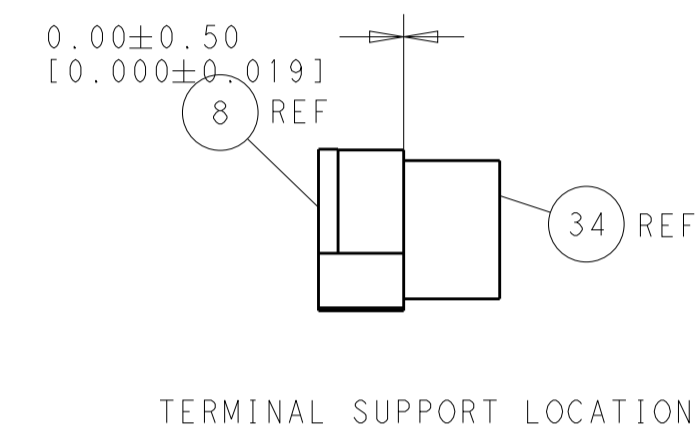
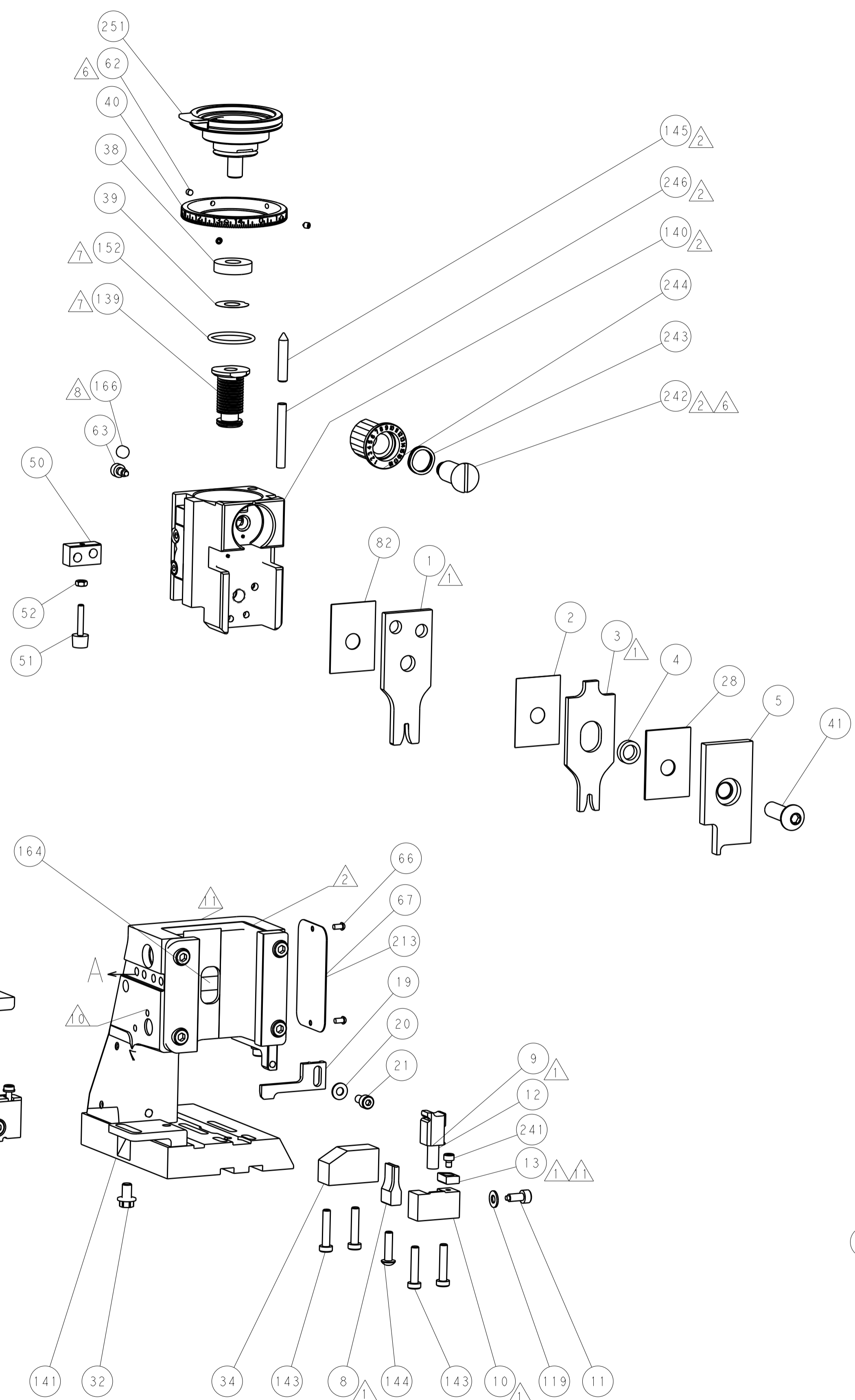
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



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

|                                        |            |                                        |             |                       |              |                          |        |                                  |              |
|----------------------------------------|------------|----------------------------------------|-------------|-----------------------|--------------|--------------------------|--------|----------------------------------|--------------|
| DIMENSIONS:                            |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DWG: Y. YIN 17JUL2013 |              | REV: G. BAILEY 17JUL2013 |        | NAME: Ocean Side Feed Applicator |              |
| mm                                     | 0 PLC ±0.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013          | 4 PLC ±0.001 | ANGLES                   | FINISH | WEIGHT                           | SCALE: 1:2   |
| MATERIAL:                              |            |                                        |             |                       |              |                          |        |                                  | SHEET 4 OF 4 |
| Customer Accessible Production Drawing |            |                                        |             |                       |              |                          |        | SCALE: 1:2                       | REV: A       |