

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE         | CONVERT TO        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|---|-------------|--------------------------|--------------------------|-------------------|-------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   | 2266047-1   | A                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |
|   | 2266047-2   | A                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | SERVO LATCH PLATE | 2119951-1             | -         | 8-2266047-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2266047-4 | -         | -         |                        |
|   |             |                          |                          |                   | MECHANICAL FEED   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -         | -                      |
|   | 2266047-5   | A                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1             | -         | 8-2266047-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2266047-4 | -         | -         |                        |
|   | 2266047-6   | A                        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | -                 | -                     | -         | -           | -         | -         | -                      |
| 2266047-7                                     | A           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                 | -                 | -                     | -         | -           | -         | -         | -                      |
| 7-2266047-7                                   | A           | CRIMP TOOLING KIT        | -                        | -                 | -                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA |                  |      |
|-----------------|------------------|------|
| CRIMP           | SIZE             | TYPE |
| WIRE            | 1.17 mm [ .046 ] | F    |
| INSUL           | -                | -    |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: TE TERMINAL                       |             | TE CRIMP SPECIFICATION         |             |
|--|-------------|--------------------------------|-------------|
| TERMINAL NAME: CENTER CONTACT, 180 DEGREE, FAKRA |             |                                |             |
| WIRE STRIP LENGTH                                |             | INSULATION DIAMETER RANGE      |             |
| 2.86-3.80 mm [ .113-.150 IN ]                    |             | Ø1.49-1.65 mm [ .059-.065 IN ] |             |
| TERMINAL APPLICATION SPECIFICATION               | 114-32145   | -                              | -           |
| TERMINALS APPLIED                                |             |                                |             |
| TE TERMINAL                                      | TE TERMINAL | TE TERMINAL                    | TE TERMINAL |
| 1-2203260-3                                      | 2203260-6   | 1-2203270-3                    | 2203270-6   |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]          | CRIMP HEIGHT REFERENCE SETTING |
|-----------|---------------------------------|--------------------------------|
| RG-59     | 0.81 +/- 0.03 [ .032 +/- .001 ] | 9.6                            |
| RG-71     | 0.80 +/- 0.03 [ .031 +/- .001 ] | 9.7                            |
| RG-62     | 0.80 +/- 0.03 [ .031 +/- .001 ] | 9.7                            |

- 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: 8-2266047-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266047-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266047-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266047-6
- 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 62. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.99.

**\*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.

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

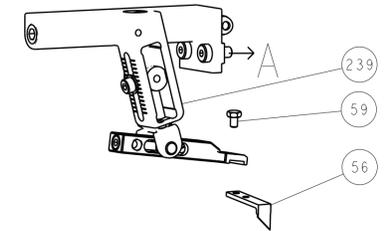
| SET UP GAUGE | LOC | DIST | REVISIONS |     |               |           |     |      |
|--------------|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|              |     |      | A         |     | RELEASED      | 12JAN2016 | MR  | TE   |
|              |     |      | A1        |     | ECR-16-010040 | 18JUL2016 | RS  | LZ   |

|   |   |     |     |     |     |     |             |                                     |     |
|---|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| 1 | - | -   | 1   | -   | -   | -   | 2119957-2   | APPLICATOR SHIM PACK                | 260 |
| 7 | - | 1   | -   | 1   | 1   | 1   | 8-21084-0   | O-RING, .676 ID, .070 DIA. MAT.     | 252 |
|   | - | -   | -   | -   | 1   | -   | 2119640-1   | PUSH ROD, AIR FEED                  | 250 |
|   | - | -   | -   | -   | 1   | -   | 2079988-1   | BUSHING, LCH5-12, MISUMI            | 249 |
|   | - | -   | -   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
|   | - | 1   | -   | 1   | 1   | 1   | 2119798-1   | DETENT PIN                          | 247 |
|   | - | 1   | -   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
|   | - | -   | 1   | -   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
|   | - | -   | 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 |
| 8 | - | 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 |
|   | - | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117 |
|   | - | 1   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82  |
|   | - | 1   | 1   | 1   | 1   | 1   | 22278-7     | SPRING, COMPRESSION                 | 77  |
|   | - | 1   | 1   | 1   | 1   | 1   | 854769-4    | HOLDER, INS                         | 74  |
|   | - | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
|   | - | 1   | -   | -   | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
|   | - | 2   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
|   | - | 1   | -   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |
| 6 | - | 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  |
|   | - | 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   | 690753-6    | 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   | 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   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
|   | - | 1   | -   | -   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
|   | - | 1   | 1   | 1   | 1   | 1   | 2119644-1   | RAM WASHER, PRECISION               | 38  |
| 6 | - | 1   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37  |
| 7 | - | 1   | -   | -   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35  |
|   | - | 1   | 1   | 1   | 1   | 1   | 2-1752356-6 | 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   | 1320908-2   | SPACER, STRIP GUIDE                 | 30  |
|   | - | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
|   | - | 1   | 1   | 1   | 1   | 1   | 455888-3    | 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   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
|   | - | 1   | 1   | 1   | 1   | 1   | 1-356885-2  | STOP, SHEAR                         | 11  |
| 1 | - | 1   | 1   | 1   | 1   | 1   | 1552193-1   | HOLDER, SHEAR                       | 10  |
| 1 | - | 1   | 1   | 1   | 1   | 1   | 1-1338293-2 | SHEAR, FLOATING                     | 9   |
| 1 | - | 1   | 1   | 1   | 1   | 1   | 1803190-2   | ANVIL, COMBINATION                  | 8   |
|   | - | -   | -   | -   | -   | -   | -           | -                                   | 7   |
|   | - | -   | -   | -   | -   | -   | -           | -                                   | 6   |
|   | - | 1   | 1   | 1   | 1   | 1   | 1803349-1   | DEPRESSOR, SHEAR                    | 5   |
|   | - | -   | -   | -   | -   | -   | -           | -                                   | 4   |
|   | - | -   | -   | -   | -   | -   | -           | -                                   | 3   |
|   | - | -   | -   | -   | -   | -   | -           | -                                   | 2   |
| 1 | - | 1   | 1   | 1   | 1   | 1   | 5-1333281-8 | CRIMPER, WIRE PREMIUM               | 1   |

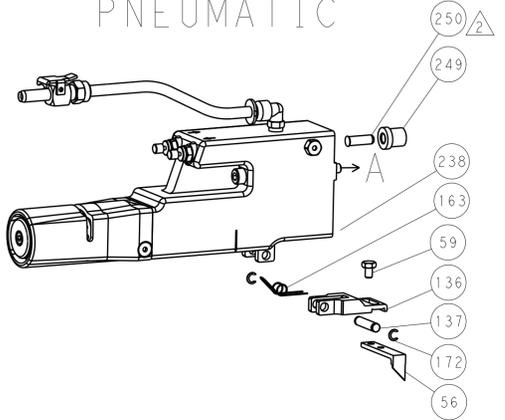
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | OWN     | CHK     | APVD     | DATE     | NAME        | PRODUCT SPEC | APPLICATION SPEC | SIZE      | CAGE CODE   | DRAWING NO | RESTRICTED TO                                |  |       |     |       |   |    |   |     |    |
|-------------|---------|--|---------|---------|---------|----------|----------|-------------|--------------|------------------|-----------|-------------|------------|--|--|-------|-----|-------|---|----|---|-----|----|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES ± | FINISH ± | R.O. WILSON | 21OCT2013    | J. J. STARKEM    | 21OCT2013 | I. L. ELBIN | 21OCT2013  | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |       |     |       |   |    |   |     |    |
| MATERIAL    |         |  |         |         |         |          |          |             |              |                  | WEIGHT    | A1          | 00779      | ©=2266047                                    | Customer Accessible Production Drawing | SCALE | 1:2 | SHEET | 1 | OF | 4 | REV | A1 |

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

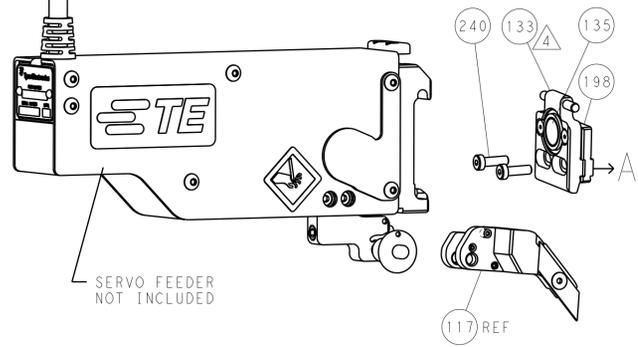
### FEED TYPE MECHANICAL



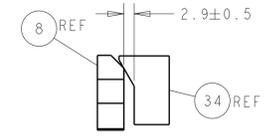
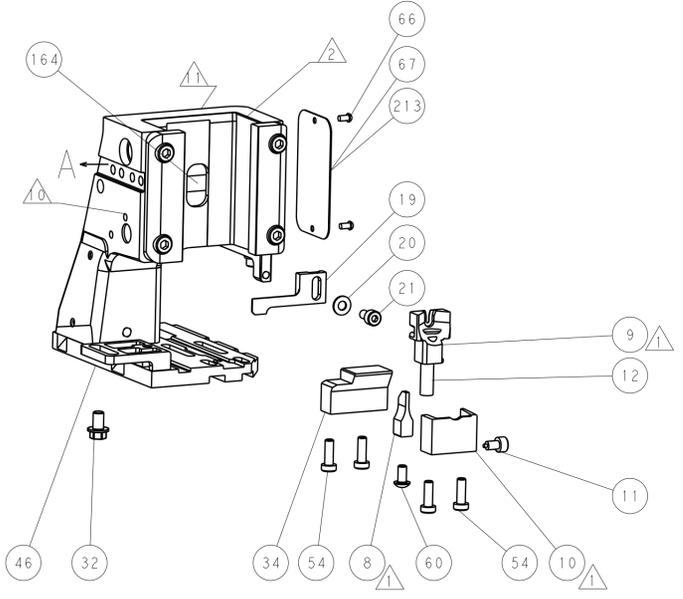
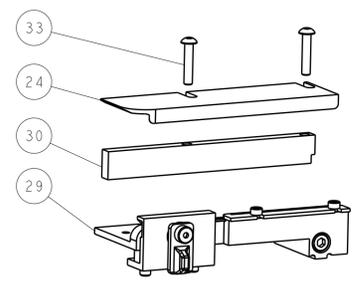
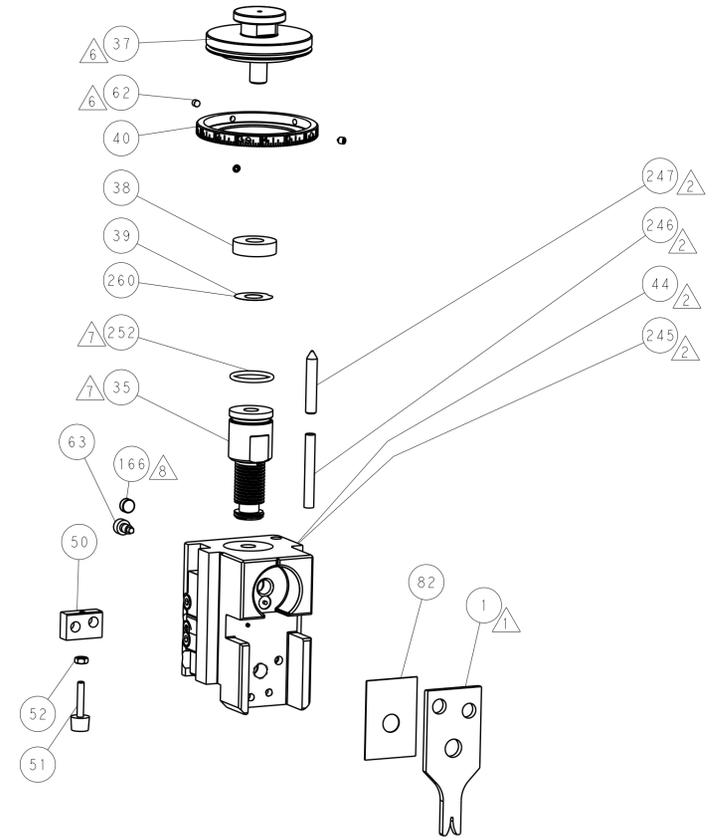
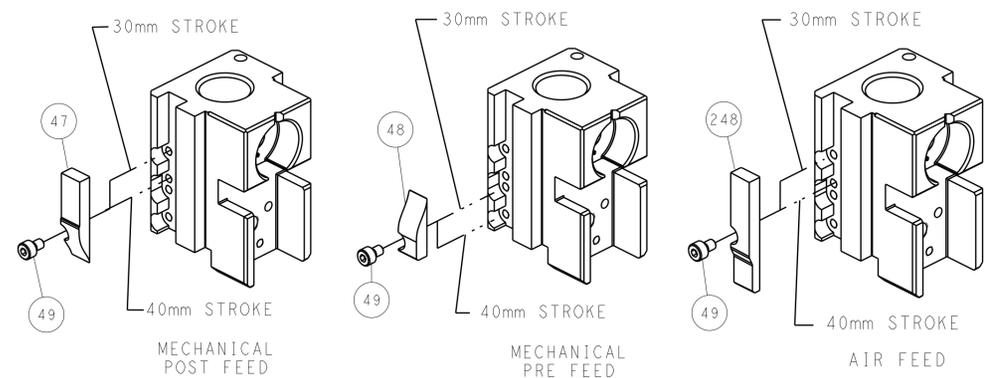
### PNEUMATIC



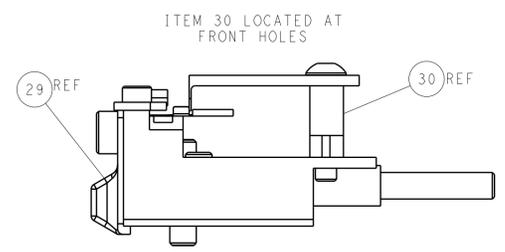
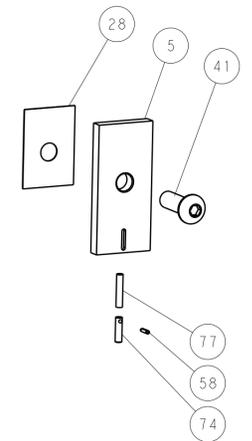
### SERVO LATCH PLATE



### CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY WIRE 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: |         | DWN R.O. WILSON 18OCT2013              |         | TE Connectivity               |                           |
| mm                                     | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                                | 4 PLC ± | APVD J.J. STAKEM 21OCT2013    | Harrisburg, PA 17105-3608 |
| MATERIAL:                              |         | FINISH:                                |         | PRODUCT SPEC                           |         | NAME                          |                           |
|  |         |  |         | APPLICATION SPEC                       |         | Ocean Side Feed Applicator    |                           |
|  |         |  |         | WEIGHT                                 |         | RESTRICTED TO                 |                           |
|  |         |  |         | A1 00779 ©=2266047                     |         | SCALE 1:2 SHEET 2 OF 4 REV A1 |                           |
| Customer Accessible Production Drawing |         |  |         | Customer Accessible Production Drawing |         |                               |                           |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|  |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|  | 2-2266047-1 | 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             | -         | 8-2266047-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266047-4 | -         | -         | -                      |
|  | 2-2266047-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266047-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266047-4 | -         | -         | -                      |
|  | 2-2266047-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  | 2-2266047-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -         | -                      |
|  | 7-2266047-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                   |                |      |
|-----------------------------------|----------------|------|
| CRIMP                             | SIZE           | TYPE |
| WIRE                              | 1.17 mm [.046] | F    |
| INSUL                             | -              | -    |
| APPLICATOR INSTRUCTIONS 408-10389 |                |      |

| TERMINAL DATA: TE TERMINAL                       |             | TE CRIMP SPECIFICATION       |             |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: CENTER CONTACT, 180 DEGREE, FAKRA |             |                              |             |
| WIRE STRIP LENGTH                                |             | INSULATION DIAMETER RANGE    |             |
| 2.86-3.80 mm [.113-.150 IN]                      |             | Ø1.49-1.65 mm [.059-.065 IN] |             |
| TERMINAL APPLICATION SPECIFICATION               | 114-32145   | -                            | -           |
| TERMINALS APPLIED                                |             |                              |             |
| TE TERMINAL                                      | TE TERMINAL | TE TERMINAL                  | TE TERMINAL |
| 1-2203260-3                                      | 2203260-6   | 1-2203270-3                  | 2203270-6   |

| WIRE SIZE | CRIMP HEIGHT WI_CRIMP_UNITS | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| RG-59     | 0.81+/-0.03 [.032+/-0.001]  | 9.6                            |
| RG-71     | 0.80+/-0.03 [.031+/-0.001]  | 9.7                            |
| RG-62     | 0.80+/-0.03 [.031+/-0.001]  | 9.7                            |

- 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: 8-2266047-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266047-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266047-5
- 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 62.
- 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.

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

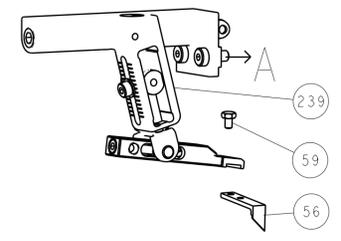
| SET UP GAUGE | LOC | DIST | REVISIONS   |      |    |      |
|--------------|-----|------|-------------|------|----|------|
| 2119599-1    | A   | 66   | REV         | DATE | BY | APPD |
| -            | -   | -    | SEE SHEET 1 | -    | -  | -    |

|   |     |     |     |     |             |                                     |                       |   |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----------------------|---|
| - | 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                   |   |
| - | -   | 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                          | 135                   |   |
| - | -   | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133                   |   |
| - | -   | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117                   |   |
| - | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82                    |   |
| - | 1   | 1   | 1   | 1   | 22278-7     | SPRING, COMPRESSION                 | 77                    |   |
| - | 1   | 1   | 1   | 1   | 854769-4    | HOLDER, INS                         | 74                    |   |
| - | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71                    |   |
| - | 1   | -   | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67                    |   |
| - | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66                    |   |
|   | 1   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63                    |   |
| - | 3   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62                    |   |
| - | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59                    |   |
| - | 1   | 1   | 1   | 1   | 21028-2     | PIN, SLOTTED SPRING .062 X .250     | 58                    |   |
| - | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56                    |   |
| - | 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   | 690753-6    | 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   | 2119644-1   | RAM WASHER, PRECISION               | 38                    |   |
| - | 1   | 1   | 1   | 1   | 2-1752356-6 | 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   | 1320908-2   | SPACER, STRIP GUIDE                 | 30                    |   |
| - | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29                    |   |
| - | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28                    |   |
| - | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24                    |   |
| - | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21                    |   |
| - | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20                    |   |
| - | 1   | 1   | 1   | 1   | 2119533-3   | STRIPPER, SIDE FEED                 | 19                    |   |
| - | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12                    |   |
| - | 1   | 1   | 1   | 1   | 1-356885-2  | STOP, SHEAR                         | 11                    |   |
|   | 1   | 1   | 1   | 1   | 1552193-1   | HOLDER, SHEAR                       | 10                    |   |
|   | 1   | 1   | 1   | 1   | 1-1338293-2 | SHEAR, FLOATING                     | 9                     |   |
|   | 1   | 1   | 1   | 1   | 1803190-2   | ANVIL, COMBINATION                  | 8                     |   |
| - | -   | -   | -   | -   | -           | -                                   | 7                     |   |
| - | -   | -   | -   | -   | -           | -                                   | 6                     |   |
| - | 1   | 1   | 1   | 1   | 1803349-1   | DEPRESSOR, SHEAR                    | 5                     |   |
| - | -   | -   | -   | -   | -           | -                                   | 4                     |   |
| - | -   | -   | -   | -   | -           | -                                   | 3                     |   |
| - | -   | -   | -   | -   | -           | -                                   | 2                     |   |
|   | 1   | 1   | 1   | 1   | 1           | 5-1333281-8                         | CRIMPER, WIRE PREMIUM | 1 |

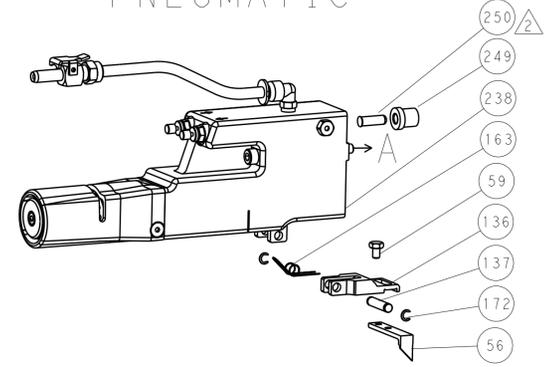
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |          | DRAWN        |           | DATE                                   |                               |
|-------------|---------|--|----------|--------------|-----------|--|-------------------------------|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ±  | R. O. WILSON | 18OCT2013 | CHK                                    | 21OCT2013                     |
|             | 3 PLC ± | 4 PLC ±                                | ANGLES ± | J. J. STAKEM |           | APPD                                   |                               |
| MATERIAL    | FINISH  | WEIGHT                                 | SCALE    | T. ELBIN     | 21OCT2013 | NAME                                   |                               |
|             |         |  |          |              |           | PRODUCT SPEC                           |                               |
|             |         |  |          |              |           | APPLICATION SPEC                       |                               |
|             |         |  |          |              |           | SIZE                                   |                               |
|             |         |  |          |              |           | CAGE CODE                              |                               |
|             |         |  |          |              |           | DRAWING NO                             |                               |
|             |         |  |          |              |           | RESTRICTED TO                          |                               |
|             |         |  |          |              |           | A1 00779                               | ©=2266047                     |
|             |         |  |          |              |           | Customer Accessible Production Drawing | SCALE 1:2 SHEET 3 OF 4 REV A1 |

| LOC       | DIST | REV | DATE | BY | APPV |
|-----------|------|-----|------|----|------|
| A         | 66   |     |      |    |      |
| REVISIONS |      |     |      |    |      |
|           |      |     |      |    |      |
|           |      |     |      |    |      |
|           |      |     |      |    |      |

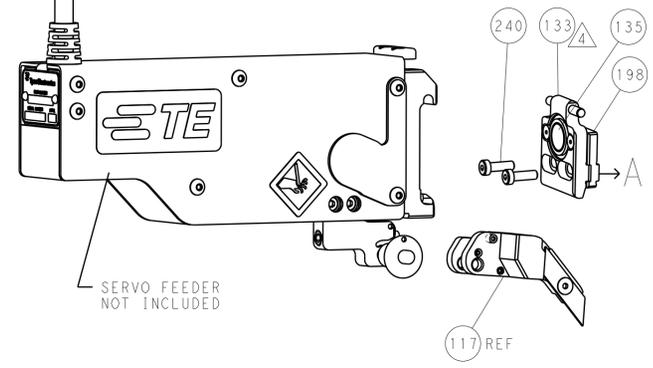
# FEED TYPE MECHANICAL



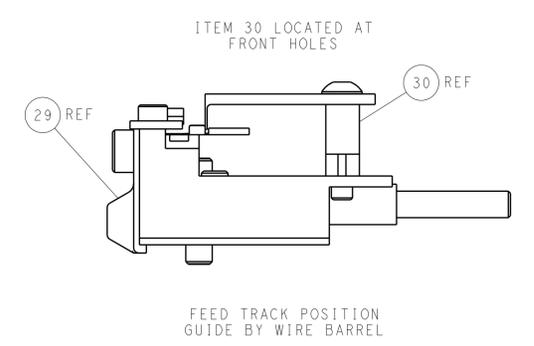
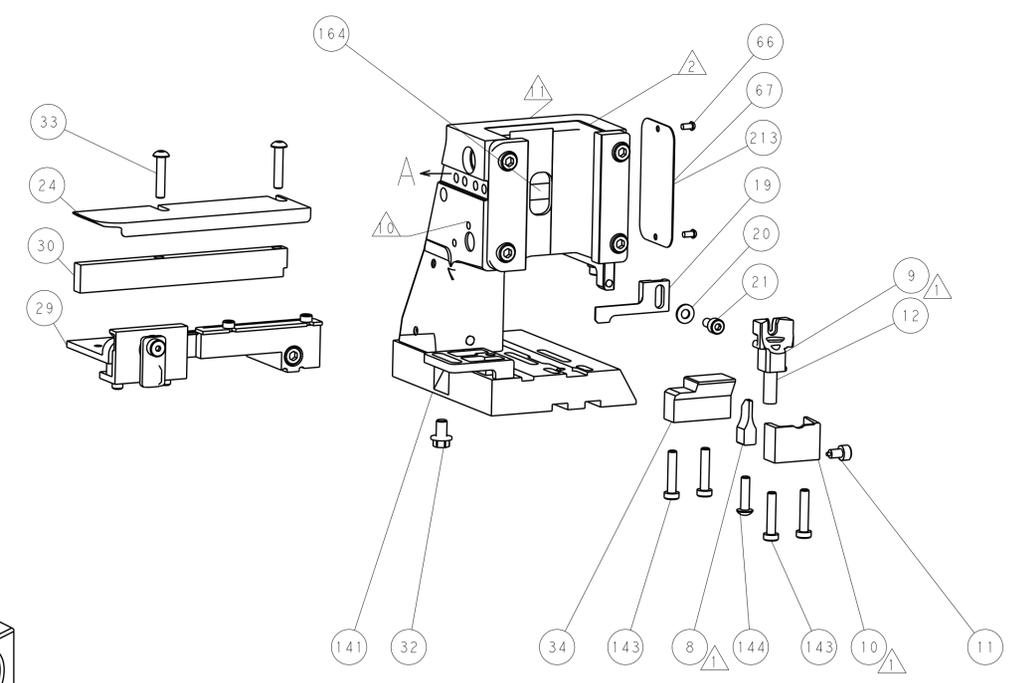
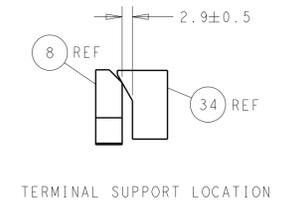
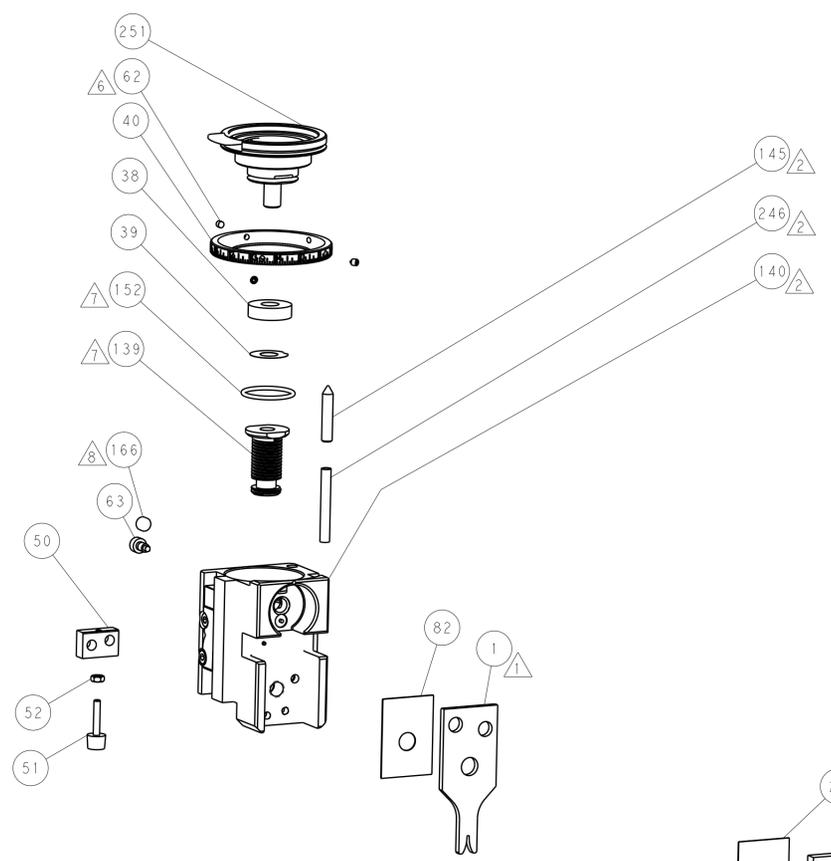
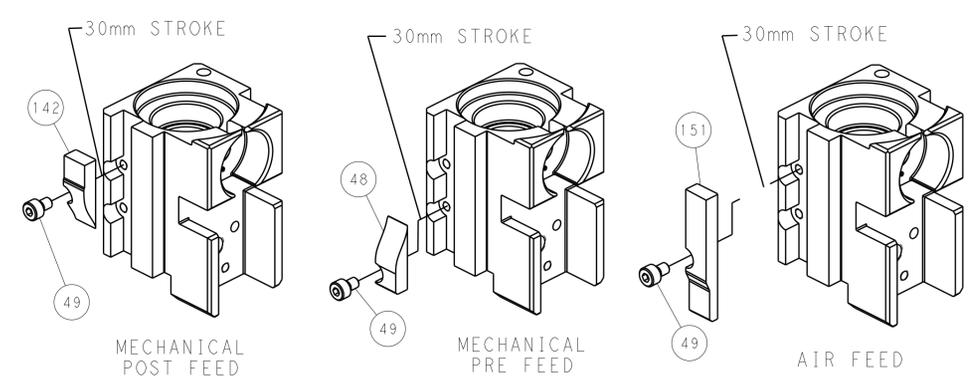
# PNEUMATIC



# 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: R.O. WILSON 18OCT2013 |  | REV: J.J. STAKEM 21OCT2013             |           | NAME: T.L. ELBIN 21OCT2013 |               | STE Connectivity<br>Harrisburg, PA 17105-3608 |    |
| mm          | 0 PLC  | ±                                      |  | PRODUCT SPEC               |  | SIZE                                   | CAGE CODE | DRAWING NO                 | RESTRICTED TO |   |    |
|             | 1 PLC  | ±                                      |  | APPLICATION SPEC           |  | WT                                     | 00779     | 2266047                    |               |   |    |
|             | 2 PLC  | ±                                      |  |                            |  | SCALE                                  | 1:2       | SHEET 4                    | OF 4          | REV   | A1 |
|             | 3 PLC  | ±                                      |  |                            |  | Customer Accessible Production Drawing |           |                            |               |   |    |
|             | 4 PLC  | ±                                      |  |                            |  |  |           |                            |               |   |    |
|             | ANGLES | ±                                      |  |                            |  |  |           |                            |               |   |    |
| MATERIAL    | FINISH |  |  |                            |  |  |           |                            |               |   |    |