

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |             |                        |
|---|-------------|--------------------------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|   |             |                          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|   | 2266496-1   | E                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1   | 2063440-1              |
|   | 2266496-2   | E                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266496-5 | 1901094-3 | 1-1752354-4 | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266496-4 | -         | -           |                        |
|   |             |                          |                          |                                | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -           | -                      |
|   | 2266496-5   | E                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266496-5 | 1901094-3 | 1-1752354-4 | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266496-4 | -         | -           |                        |
|   | 2266496-6   | E                        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | SERVO LATCH PLATE <sup>12</sup>   | -                     | -         | -           | -         | -           | -                      |
| 2266496-7                                     | E           | FINE CRIMP HEIGHT ADJUST | NONE                     | NONE                           | -                                 | -                     | -         | -           | -         | -           | -                      |
| 7-2266496-7                                   | E           | CRIMP TOOLING KIT        | -                        | -                              | -                                 | -                     | -         | -           | -         | -           | -                      |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.00 mm [.039] | F    |
| INSUL           | 1.09 mm [.043] | F    |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: MOLEX TERMINAL                   |                     | MOLEX CRIMP SPECIFICATION    |  |
|---|---------------------|------------------------------|--|
| TERMINAL NAME: EMIX CONN., 1.5mm PITCH TERMINAL |                     |                              |  |
| WIRE STRIP LENGTH                               |                     | INSULATION DIAMETER RANGE    |  |
| 1.05-1.54 mm [.041-.061 IN]                     |                     | Ø0.90-1.15 mm [.035-.045 IN] |  |
| TERMINAL APPLICATION SPECIFICATION              | ATS-639014200 Rev D |                              |  |
| TERMINALS APPLIED <sup>3</sup>                  |                     |                              |  |
| TE TERMINAL                                     | MOLEX TERMINAL      |                              |  |
| 1949551-1                                       | 87421-0000          |                              |  |

| WIRE SIZE         | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|----------------------------|--------------------------------|
| 24 AWG OR 0.20mm2 | 0.58+/- .02 [.023+/- .001] | 6.7                            |
| 26 AWG OR 0.12mm2 | 0.55+/- .03 [.022+/- .001] | 7.2                            |
| 28 AWG OR 0.08mm2 | 0.55+/- .03 [.022+/- .001] | 7.2                            |
| 30 AWG OR 0.05mm2 | 0.55+/- .03 [.022+/- .001] | 7.2                            |

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266496-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266496-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266496-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266496-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 5.22.
- <sup>13</sup> TERMINAL LUBRICANT IS RECOMMENDED.

**\*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.

| <sup>12</sup> | -   | -  | 1  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK                |  | 260     |  |  |
|---------------|-----|----|----|----|----|----|-----------|-------------------------------------|--|---------|--|--|
| <sup>11</sup> | -   | 1  | -  | 1  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT.     |  | 252     |  |  |
|               | -   | -  | -  | -  | 1  | -  | 2119640-1 | PUSH ROD, AIR FEED                  |  | 250     |  |  |
|               | -   | -  | -  | -  | 1  | -  | 1803259-1 | BUSHING, FLANGED                    |  | 249     |  |  |
|               | -   | -  | -  | -  | 1  | -  | 2119641-1 | FEED CAM, AIR FEED                  |  | 248     |  |  |
|               | -   | 1  | -  | 1  | 1  | 1  | 2119798-1 | DETENT PIN                          |  | 247     |  |  |
|               | -   | 1  | -  | 1  | 1  | 1  | 1-22279-3 | SPRING, COMPRESSION                 |  | 246     |  |  |
|               | -   | -  | 1  | -  | -  | -  | 2119758-1 | RAM, AMP STYLE, SIDE FEED, NON-ADJ. |  | 245     |  |  |
|               | -77 | -7 | -6 | -5 | -2 | -1 | PART NO   | DESCRIPTION                         |  | ITEM NO |  |  |

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

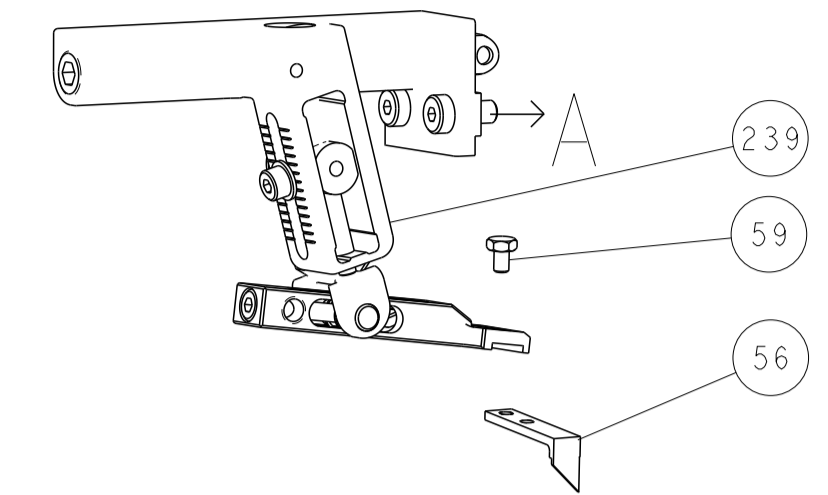
| SET UP GAUGE |  | LOC | DIST | REVISIONS |     |               |           |     |      |
|--------------|--|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-1    |  | A   | 66   | P         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|              |  |     |      | C         |     | ECR-16-005266 | 11APR2016 | RK  | GB   |
|              |  |     |      | D         |     | ECR-16-016210 | 16NOV2016 | KH  | CT   |
|              |  |     |      | D1        |     | ECR-16-016564 | 22NOV2016 | TB  | TE   |
|              |  |     |      | E         |     | ECR-17-003482 | 09MAR2017 | TB  | CT   |

|               |     |     |     |     |     |             |                                     |  |         |
|---------------|-----|-----|-----|-----|-----|-------------|-------------------------------------|--|---------|
| -             | 1   | 1   | 1   | 1   | 1   | 2119082-4   | 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     |
| -             | 2   | 2   | 2   | 2   | 2   | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)            |  | 230     |
| -             | -   | 1   | 1   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                 |  | 213     |
| -             | -   | 1   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      |  | 198     |
| <sup>6</sup>  | -   | 1   | 1   | 1   | 1   | 1-1752354-4 | STANDOFF, HOLD-DOWN                 |  | 180     |
| -             | 1   | 1   | 1   | 1   | 1   | 1-1633764-7 | HOLD DOWN, TERMINAL                 |  | 179     |
| -             | 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     |
| <sup>8</sup>  | -   | 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     |
| <sup>13</sup> | -   | 1   | 1   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         |  | 113     |
| -             | 1   | 1   | 1   | 1   | 1   | 2-455888-1  | SPACER, CRIMPER                     |  | 82      |
| -             | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               |  | 71      |
| -             | 1   | 1   | 1   | 1   | 1   | 2119791-9   | DEPRESSOR, WIRE                     |  | 70      |
| -             | 1   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      |  | 69      |
| -             | 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      |
| <sup>6</sup>  | -   | 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   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           |  | 59      |
| -             | -   | -   | -   | -   | 1   | 1338685-1   | PAWL, FEED                          |  | 56      |
| -             | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       |  | 54      |
| -             | 1   | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           |  | 52      |
| -             | 1   | 1   | 1   | 1   | 1   | 1901681-8   | HOLDDOWN, TERMINAL                  |  | 51      |
| -             | -   | -   | -   | -   | 1   | 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      |
| <sup>6</sup>  | -   | 1   | 1   | 1   | 1   | 1-2119644-4 | RAM WASHER, PRECISION               |  | 38      |
| <sup>7</sup>  | -   | 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   | 2-1752356-5 | SUPPORT, TERMINAL                   |  | 34      |
| -             | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           |  | 33      |
| -             | 1   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    |  | 32      |
| -             | 1   | 1   | 1   | 1   | 1   | 1320908-2   | SPACER, STRIP GUIDE                 |  | 30      |
| -             | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               |  | 29      |
| -             | 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      |
| -             | 2   | 2   | 2   | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                |  | 20      |
| -             | 1   | 1   | 1   | 1   | 1   | 2119533-3   | STRIPPER, SIDE FEED                 |  | 19      |
| <sup>11</sup> | -   | 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      |
| <sup>11</sup> | -   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 |  | 10      |
| <sup>11</sup> | -   | 1   | 1   | 1   | 1   | 1803095-6   | FLOATING SHEAR, FRONT               |  | 9       |
| <sup>11</sup> | 1   | 1   | 1   | 1   | 1   | 7-1803249-7 | ANVIL, COMBINATION                  |  | 8       |
| -             | -   | -   | -   | -   | -   | -           | -                                   |  | 7       |
| -             | -   | -   | -   | -   | -   | -           | -                                   |  | 6       |
| -             | 1   | 1   | 1   | 1   | 1   | 2119757-1   | DEPRESSOR, SHEAR                    |  | 5       |
| -             | 1   | 1   | 1   | 1   | 1   | 238011-6    | BLOCK, CRIMPER SPACER               |  | 4       |
| <sup>11</sup> | 1   | 1   | 1   | 1   | 1   | 9-1633962-7 | CRIMPER, INSULATION F PREMIUM       |  | 3       |
| -             | 1   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     |  | 2       |
| <sup>11</sup> | 1   | 1   | 1   | 1   | 1   | 1633609-2   | CRIMPER, WIRE                       |  | 1       |
| -77           | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         |  | ITEM NO |

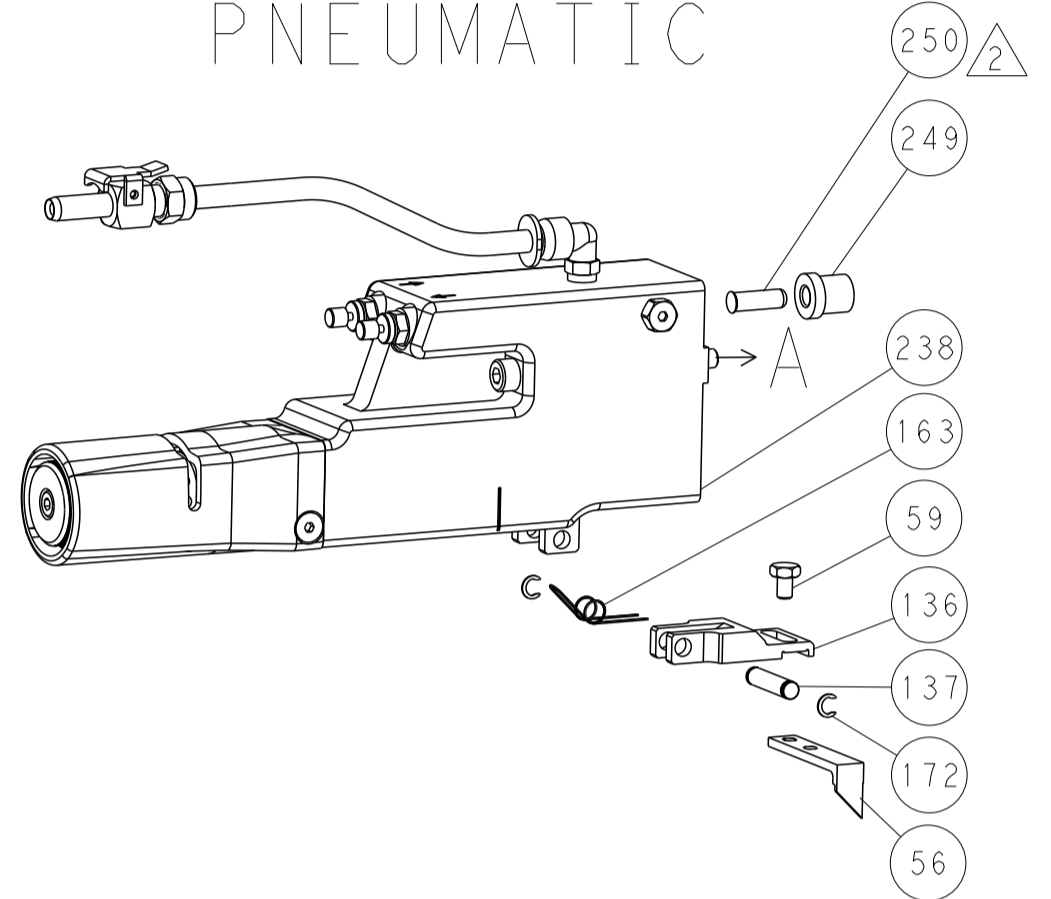
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |          | OWN     | CHK     | APVD     | DATE      | NAME                                   |              |
|-------------|---------|--|----------|---------|---------|----------|-----------|--|--------------|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ±  | M RILEY | T ELBIN | D STOUGH | 12MAR2014 | Ocean Side Feed Applicator             |              |
|             | 3 PLC ± | 4 PLC ±                                | ANGLES ± |         |         |          |           | SIZE                                   | CAGE CODE    |
|             | FINISH  |  |          |         |         |          |           | 00779                                  | 2266496      |
| MATERIAL    |         |  |          |         |         |          |           | Customer Accessible Production Drawing | SCALE        |
|             |         |  |          |         |         |          |           | 1:2                                    | SHEET 1 OF 4 |
|             |         |  |          |         |         |          |           |  | REV E        |

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

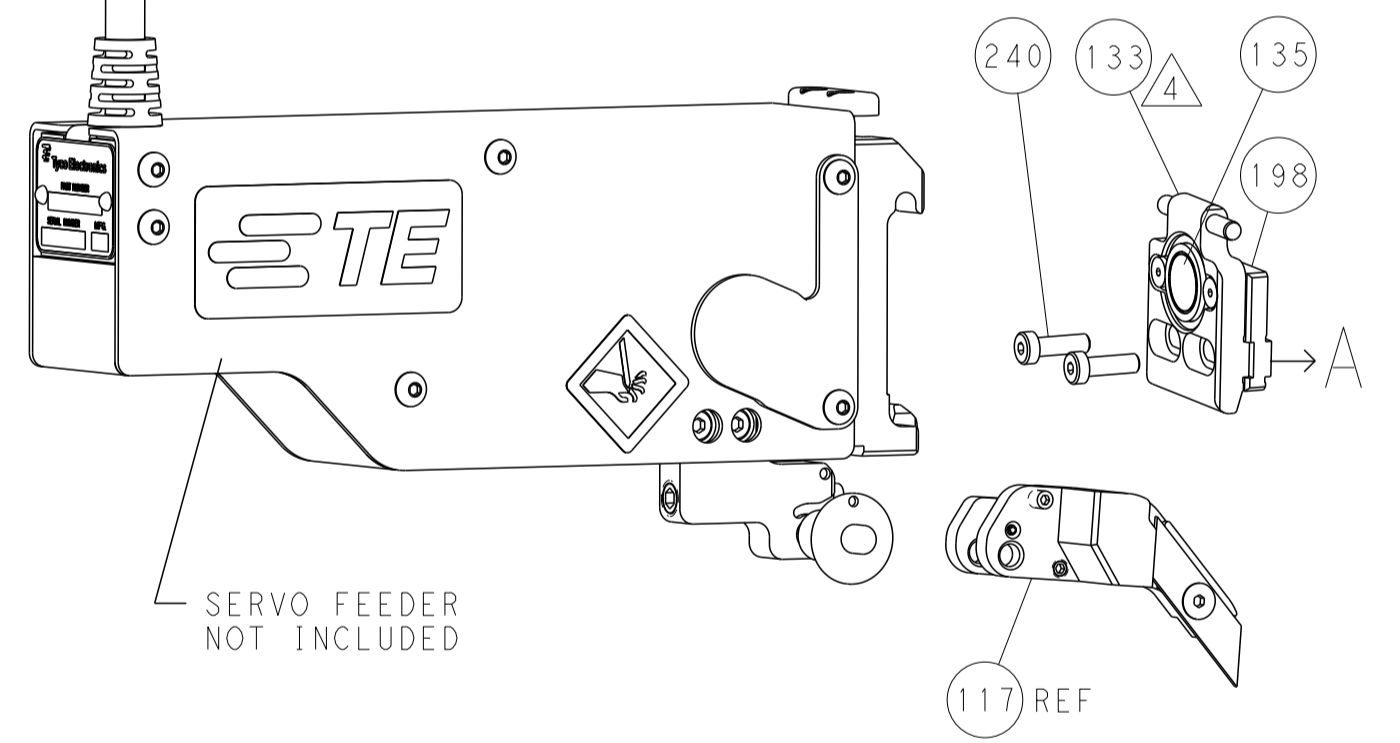
### FEED TYPE MECHANICAL



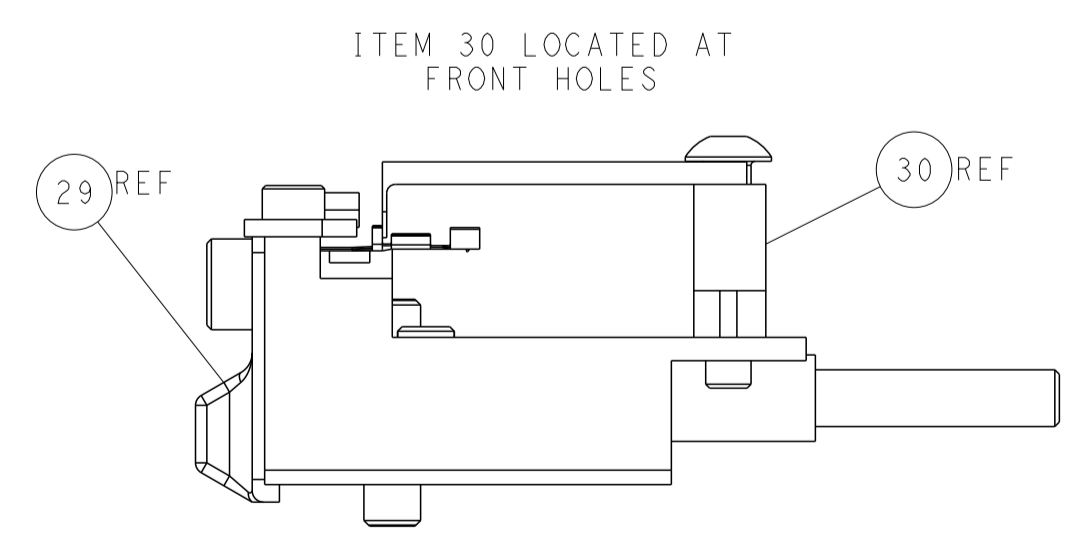
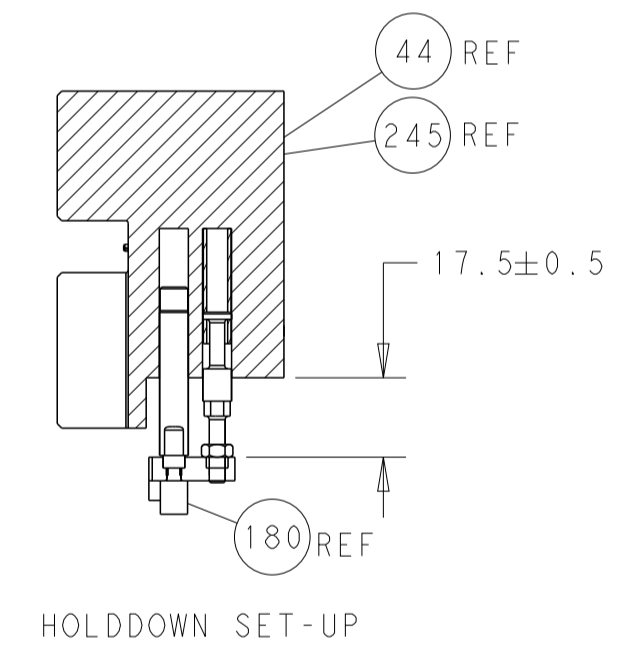
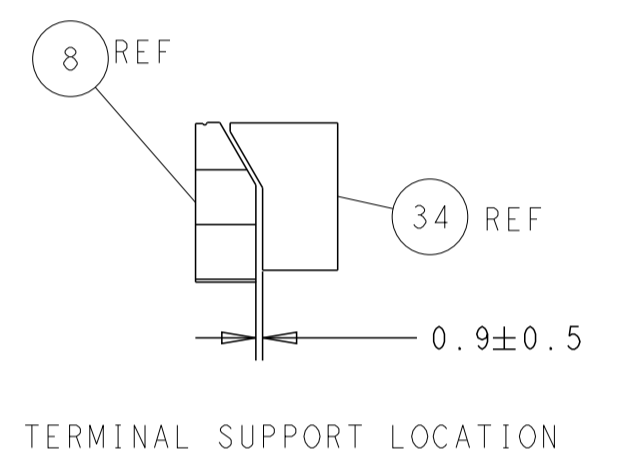
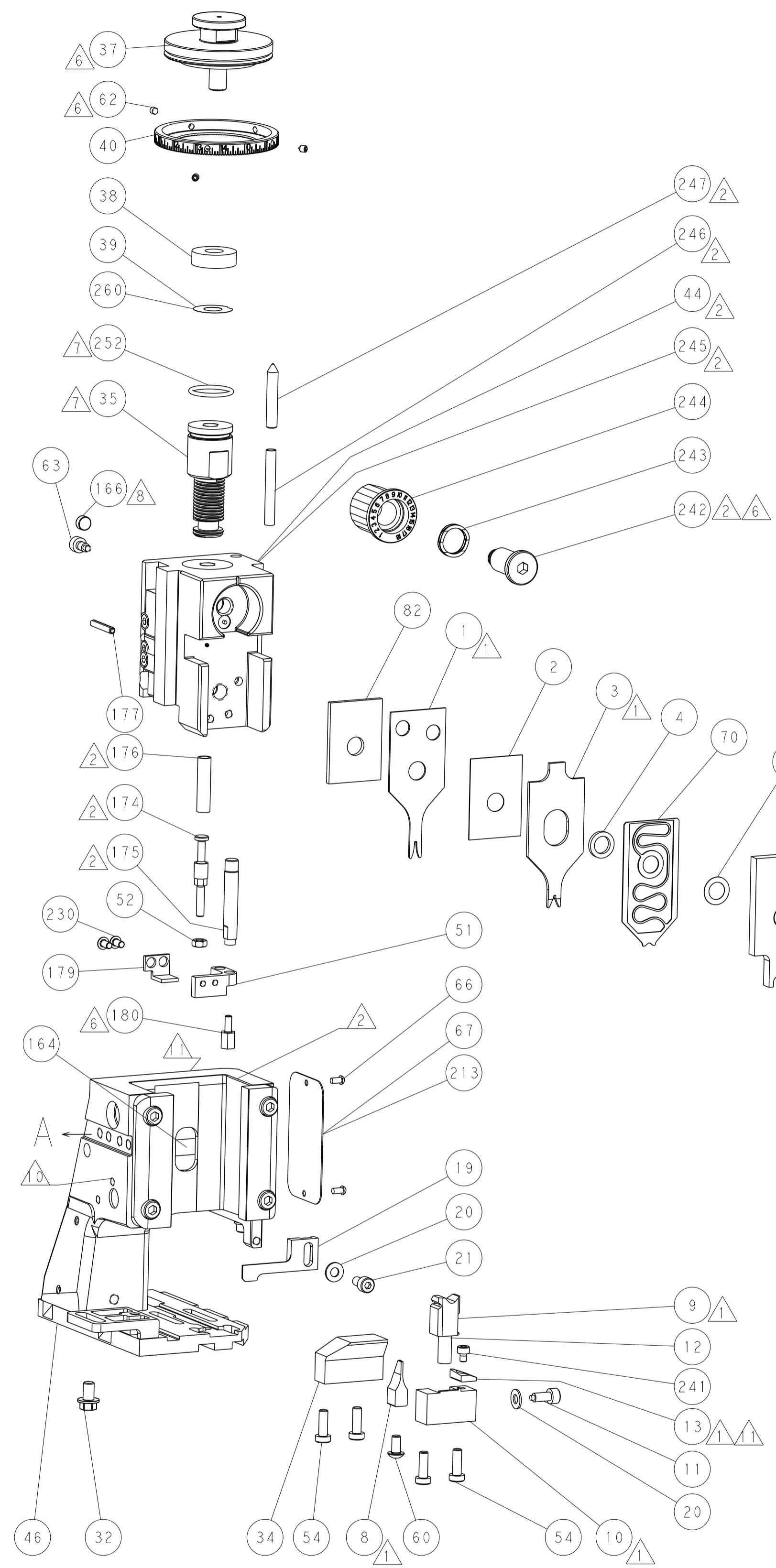
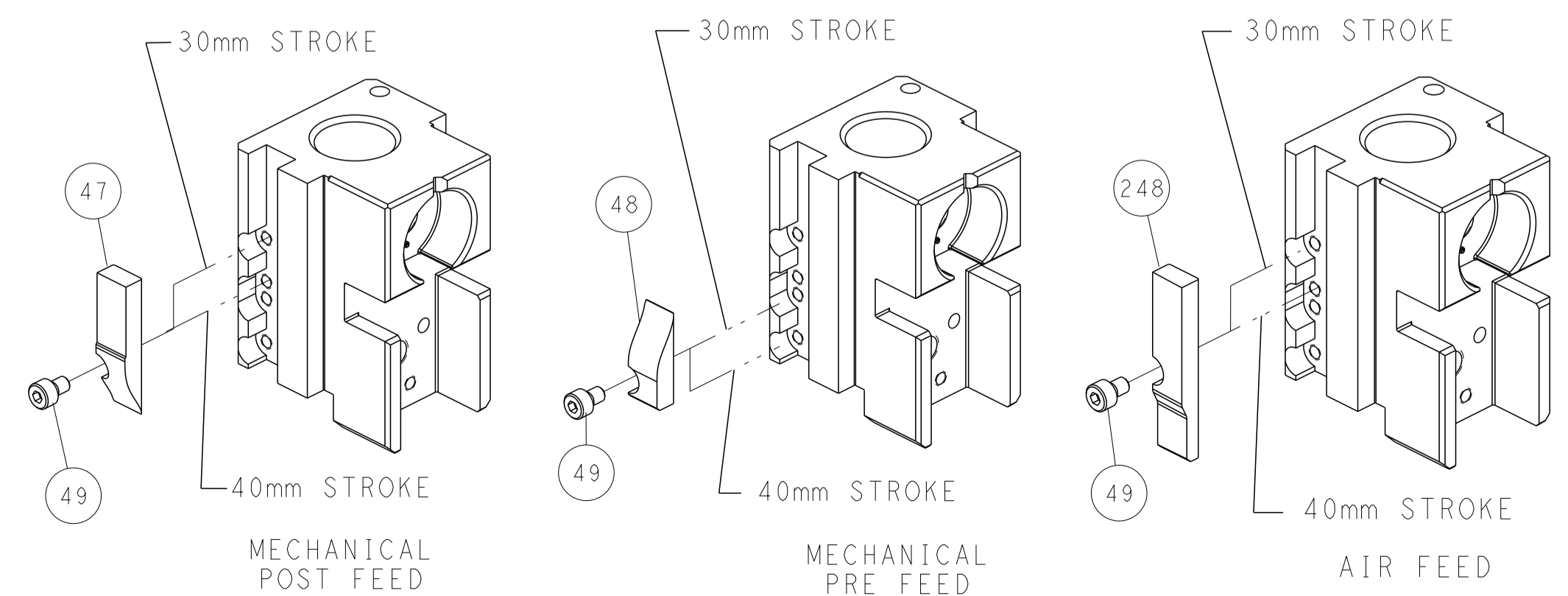
### PNEUMATIC



### 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: |         | OWN: M. RILEY 12MAR2014                | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | CHK: T. ELBIN 12MAR2014                |  |
| MATERIAL:   |         | FINISH:                                |         | APVD: D. STOUGH 12MAR2014              | NAME: Ocean Side Feed Applicator             |
|             |         |  |         | SIZE: A1                               | CAGE CODE: 00779                             |
|             |         |  |         | WEIGHT:                                | DRAWING NO: C=2266496                        |
|             |         |  |         | Customer Accessible Production Drawing |  |
|             |         |  |         | SCALE: 1:2                             | SHEET 2 OF 4                                 |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |             |                        |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|  |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|  | 2-2266496-1 | E        | 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             | -         | 8-2266496-5 | 1901094-3 | 1-1752354-4 | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266496-4 | -         | -           | -                      |
|  | 2-2266496-2 | E        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -           | -                      |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266496-5 | 1901094-3 | 1-1752354-4 | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266496-4 | -         | -           | -                      |
|  | 2-2266496-5 | E        | 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              |
|  | 2-2266496-7 | E        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -           | -                      |
|  | 7-2266496-7 | E        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -           | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.00 mm [.039] | F    |
| INSUL                                | 1.09 mm [.043] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: MOLEX TERMINAL                   |                     | MOLEX CRIMP SPECIFICATION    |   |
|---|---------------------|------------------------------|---|
| TERMINAL NAME: EMIX CONN., 1.5mm PITCH TERMINAL |                     |                              |   |
| WIRE STRIP LENGTH                               |                     | INSULATION DIAMETER RANGE    |   |
| 1.05-1.54 mm [.041-.061 IN]                     |                     | Ø0.90-1.15 mm [.035-.045 IN] |   |
| TERMINAL APPLICATION SPECIFICATION              | ATS-639014200 Rev D | -                            | - |
| TERMINALS APPLIED <sup>12</sup>                 |                     |                              |   |
| TE TERMINAL                                     | MOLEX TERMINAL      |                              |   |
| 1949551-1                                       | 87421-0000          |                              |   |

| WIRE SIZE                     | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|-------------------------------|----------------------------|---|
| 24 AWG OR 0.20mm <sup>2</sup> | 0.58+/- .02 [.023+/- .001] | 6.7   |
| 26 AWG OR 0.12mm <sup>2</sup> | 0.55+/- .03 [.022+/- .001] | 7.2   |
| 28 AWG OR 0.08mm <sup>2</sup> | 0.55+/- .03 [.022+/- .001] | 7.2   |
| 30 AWG OR 0.05mm <sup>2</sup> | 0.55+/- .03 [.022+/- .001] | 7.2   |

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266496-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266496-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266496-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- <sup>8</sup> MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> TERMINAL LUBRICANT IS RECOMMENDED.

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

|     |     |     |     |     |           |                                     |         |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |
| -   | -   | -   | 1   | -   | 2119640-1 | PUSH ROD, AIR FEED                  | 250     |
| -   | -   | -   | 1   | -   | 1803259-1 | BUSHING, FLANGED                    | 249     |
| -   | 1   | 1   | 1   | 1   | 1-22279-3 | SPRING, COMPRESSION                 | 246     |
| -   | 1   | 1   | 1   | 1   | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -   | 1   | 1   | 1   | 1   | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -77 | -27 | -25 | -22 | -21 | PART NO   | DESCRIPTION                         | ITEM NO |

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

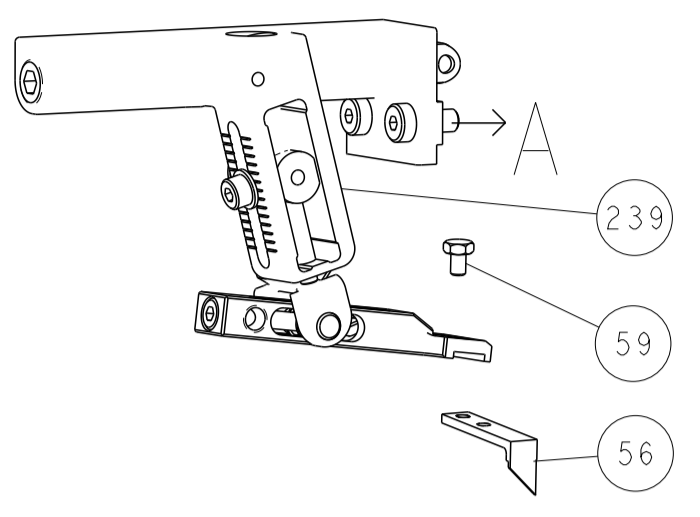
| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
|              |     |      | -         | -   | SEE SHEET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

|     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 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     |
| -   | 2   | 2   | 2   | 2   | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)            | 230     |
| -   | -   | 1   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| -   | -   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      | 198     |
| -   | 1   | 1   | 1   | 1   | 1-1752354-4 | STANDOFF, HOLD-DOWN                 | 180     |
| -   | 1   | 1   | 1   | 1   | 1-1633764-7 | HOLD DOWN, TERMINAL                 | 179     |
| -   | 1   | 1   | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177     |
| -   | 1   | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176     |
| -   | 1   | 1   | 1   | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 | 175     |
| -   | 1   | 1   | 1   | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 | 174     |
| -   | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172     |
| -   | 1   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166     |
| -   | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164     |
| -   | -   | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163     |
| -   | 1   | 1   | 1   | 1   | 8-21084-1   | O-RING, .801 ID, .070 DIA. MAT.     | 152     |
| -   | -   | -   | 1   | -   | 2119641-2   | FEED CAM, AIR FEED                  | 151     |
| -   | 1   | 1   | 1   | 1   | 2119798-2   | DETENT PIN                          | 145     |
| -   | 1   | 1   | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144     |
| -   | 4   | 4   | 4   | 4   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       | 143     |
| -   | -   | -   | -   | 1   | 2119653-2   | FEED CAM, POST FEED                 | 142     |
| -   | 1   | 1   | 1   | 1   | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141     |
| -   | 1   | 1   | 1   | 1   | 2119650-1   | RAM, ASIAN STYLE, SIDE FEED         | 140     |
| -   | 1   | 1   | 1   | 1   | 2119092-2   | BOLT, ADJUSTMENT                    | 139     |
| -   | -   | -   | 1   | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137     |
| -   | -   | -   | 1   | -   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136     |
| -   | -   | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135     |
| -   | -   | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133     |
| -   | -   | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113     |
| -   | 1   | 1   | 1   | 1   | 2-455888-1  | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | 1   | 1   | 1   | 2119791-9   | DEPRESSOR, WIRE                     | 70      |
| -   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69      |
| -   | 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      |
| -   | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52      |
| -   | 1   | 1   | 1   | 1   | 1901681-8   | HOLDDOWN, TERMINAL                  | 51      |
| -   | -   | -   | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -   | -   | -   | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48      |
| -   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
| -   | 1   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40      |
| -   | 1   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
| -   | 1   | 1   | 1   | 1   | 1-2119644-4 | RAM WASHER, PRECISION               | 38      |
| -   | 1   | 1   | 1   | 1   | 2-1752356-5 | 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   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21      |
| -   | 2   | 2   | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -   | 1   | 1   | 1   | 1   | 2119533-3   | STRIPPER, SIDE FEED                 | 19      |
| -   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13      |
| -   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11      |
| -   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| -   | 1   | 1   | 1   | 1   | 1803095-6   | FLOATING SHEAR, FRONT               | 9       |
| -   | 1   | 1   | 1   | 1   | 7-1803249-7 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 2119757-1   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 238011-6    | BLOCK, CRIMPER SPACER               | 4       |
| -   | 1   | 1   | 1   | 1   | 9-1633962-7 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 2       |
| -   | 1   | 1   | 1   | 1   | 1633609-2   | CRIMPER, WIRE                       | 1       |
| -77 | -27 | -25 | -22 | -21 | PART NO     | DESCRIPTION                         | ITEM NO |

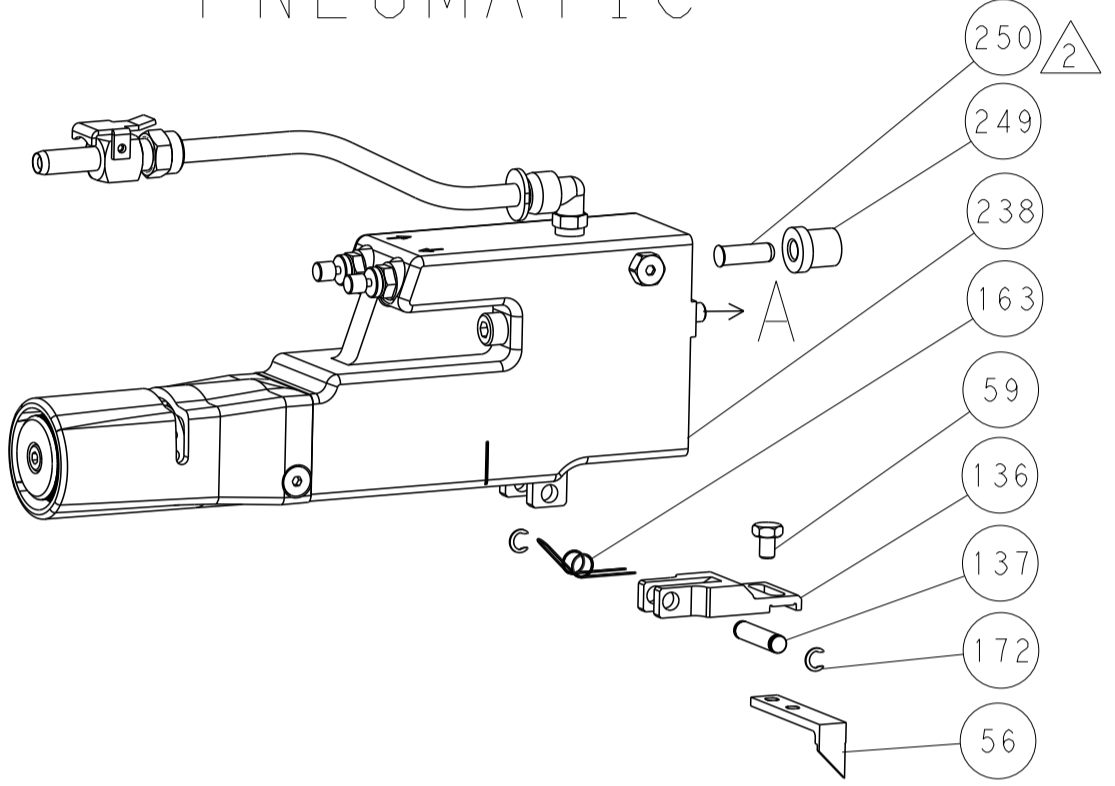
| DIMENSIONS:                            |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DRAWING NO |         | RESTRICTED TO |          |
|--|---------|--|---------|------------|---------|---------------|----------|
| mm                                     | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±    | 4 PLC ± | ANGLES ±      | FINISH ± |
| MATERIAL                               |         |  |         | WEIGHT     | SCALE   | SHEET         | REV      |
| Customer Accessible Production Drawing |         |  |         | SCALE      | 1:2     | SHEET 3 OF 4  | REV E    |

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

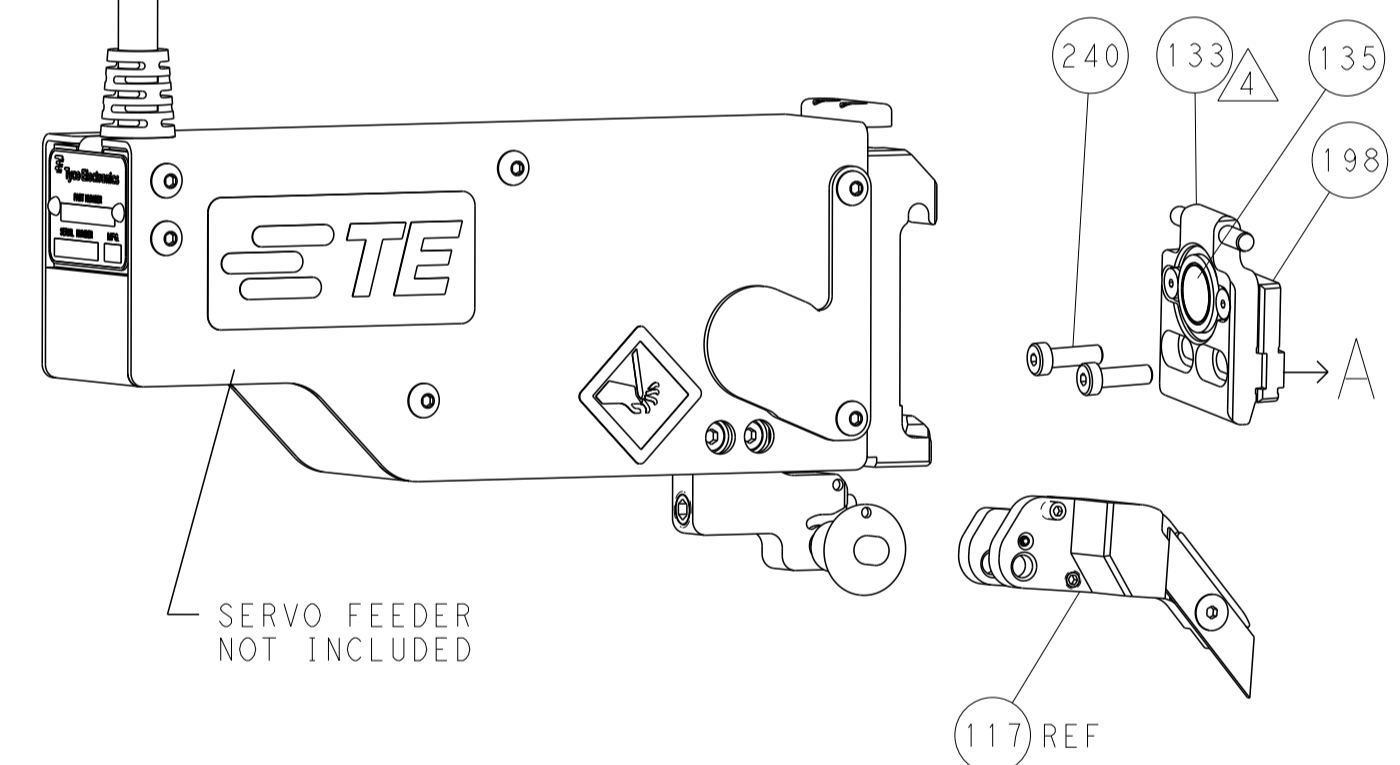
# FEED TYPE MECHANICAL



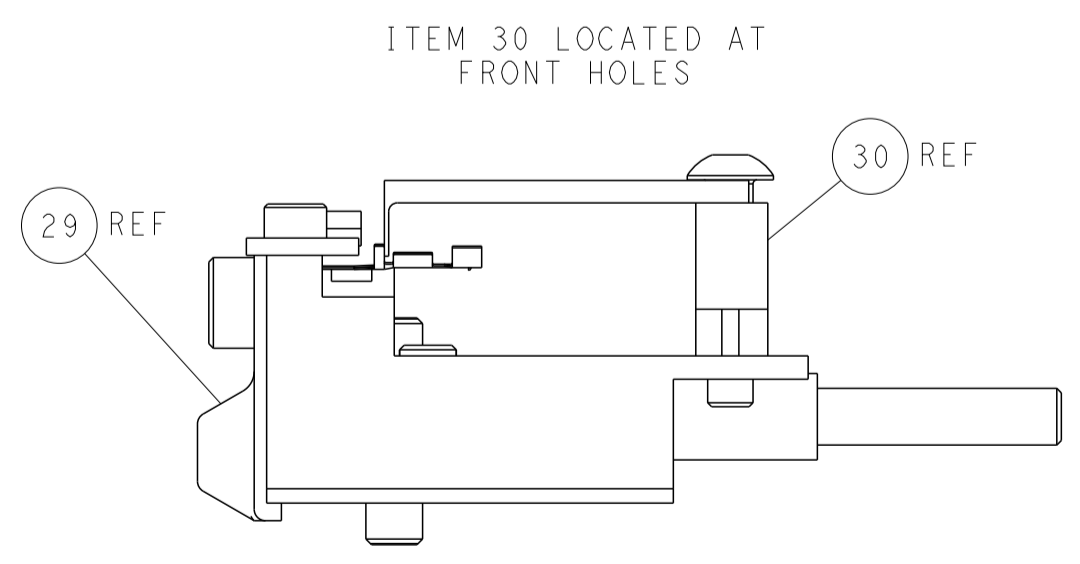
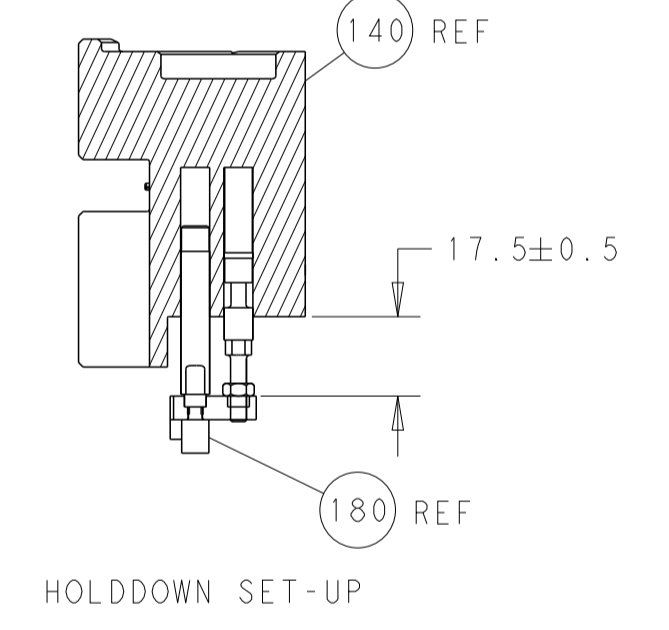
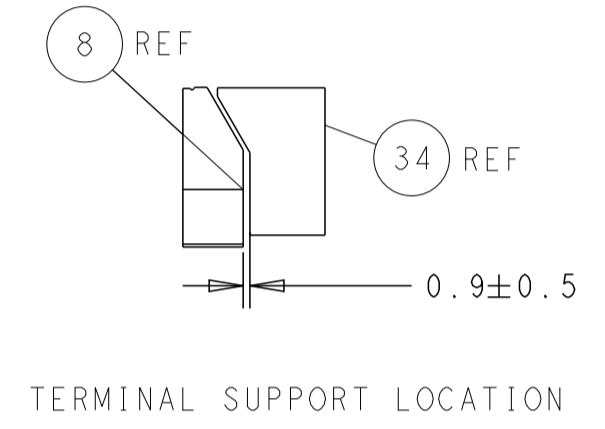
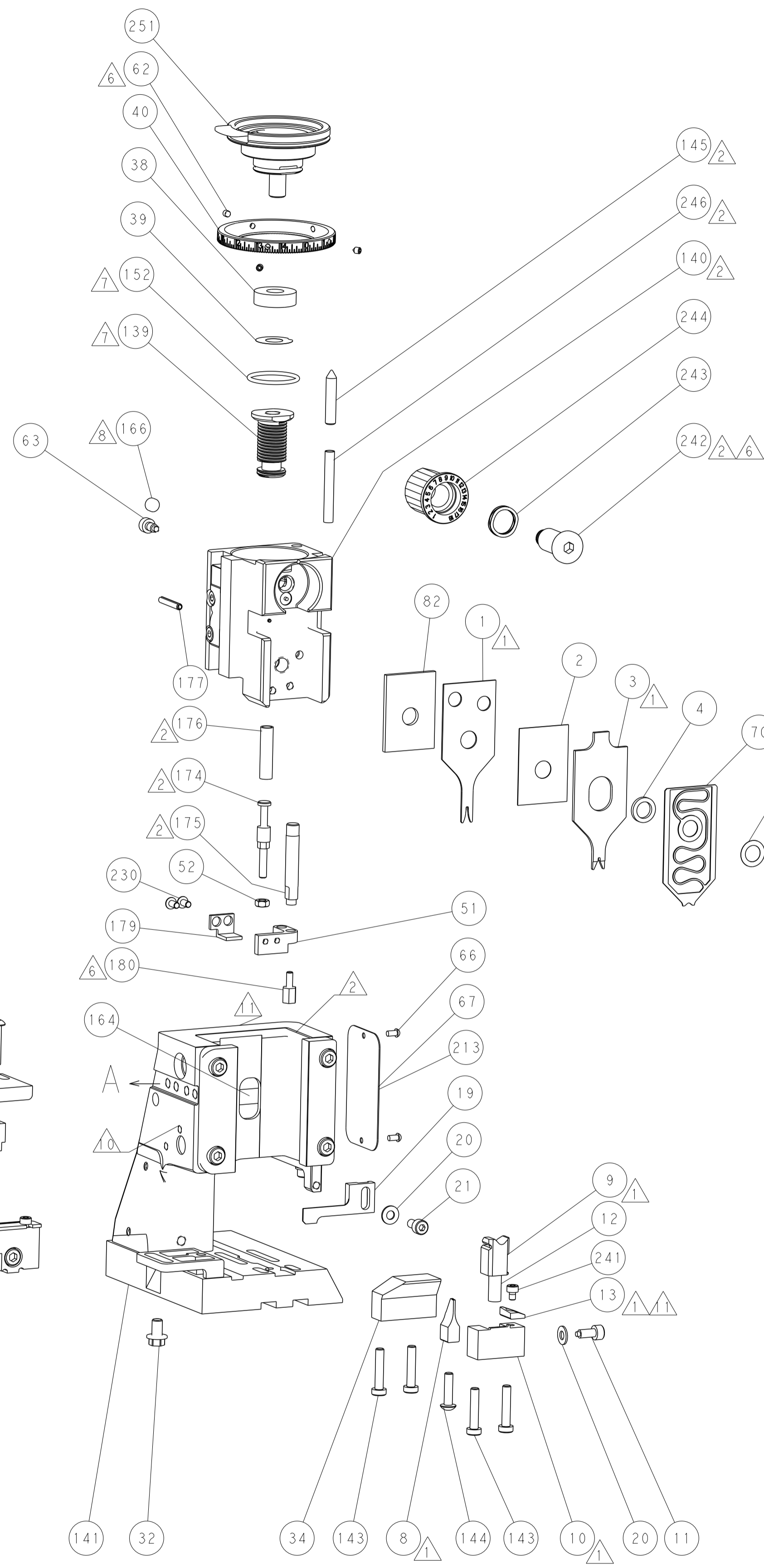
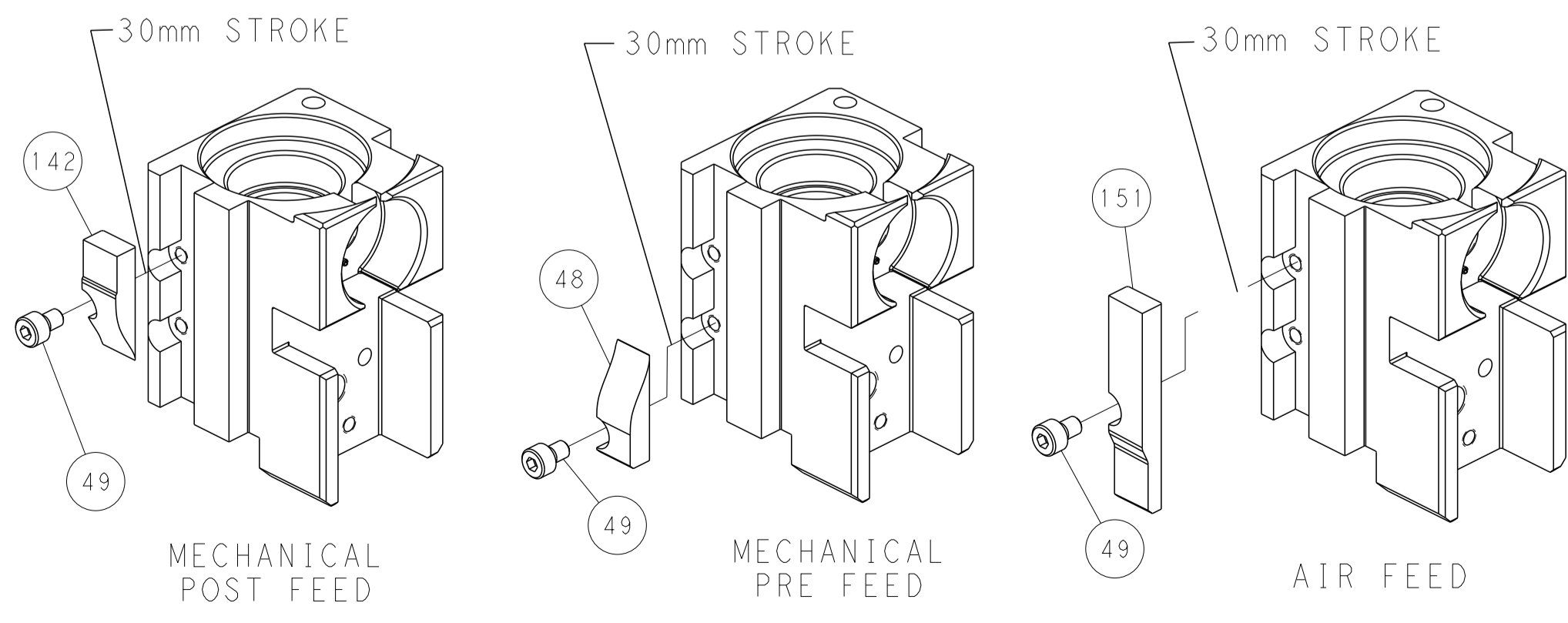
# PNEUMATIC



# 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:<br>mm<br> |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH |  | DWN M. RILEY 12MAR2014<br>CHK T. ELBIN 12MAR2014<br>APVD D. STOUGH 12MAR2014<br>PRODUCT SPEC<br>APPLICATION SPEC<br>WEIGHT<br>SCALE 1:2 |  | NAME Ocean Side Feed Applicator<br>SIZE CAGE CODE DRAWING NO. A1 00779 C=2266496<br>RESTRICTED TO<br>SHEET 4 OF 4 REV E |  |
|-----------------------|--|---|--|---|--|---|--|