

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION                    | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|---|-------------|--------------------------|--------------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   |             |                          |                                |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|   | 2266995-1   | A                        | FINE CRIMP HEIGHT ADJUST       | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 1338683-8 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |
|   |             |                          |                                |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266995-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                                |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266995-4 | -         | -         | -                      |
|   | 2266995-2   | A                        | FINE CRIMP HEIGHT ADJUST       | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338683-8 | 5-18022-5   | 2119653-1 | -         | -                      |
|   |             |                          |                                |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266995-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                                |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266995-4 | -         | -         | -                      |
|   | 2266995-5   | A                        | FINE CRIMP HEIGHT ADJUST       | SERVO LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 1338683-8 | 5-18022-5   | 2119653-1 | -         | -                      |
| PNEUMATIC FEED                                |             |                          |                                |                                | 2119950-1                         | 1338683-8             | 5-18022-5 | 2119641-1   | 2119799-1 | 2063440-1 |                        |
| 2266995-6                                     | A           | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | -                              | -                                 | -                     | -         | -           | -         | -         |                        |
| 2266995-7                                     | A           | FINE CRIMP HEIGHT ADJUST | NONE                           | -                              | -                                 | -                     | -         | -           | -         | -         |                        |
| 7-2266995-7                                   | A           | CRIMP TOOLING KIT        | -                              | -                              | -                                 | -                     | -         | -           | -         | -         |                        |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 4.98 mm [.196] | F    |
| INSUL           | 6.07 mm [.239] | F    |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: KET TERMINAL               |                | KET CRIMP SPECIFICATION      |              |
|---|----------------|------------------------------|--------------|
| TERMINAL NAME: TERMINAL, EARTH RING RIGHT |                |                              |              |
| WIRE STRIP LENGTH                         |                | INSULATION DIAMETER RANGE    |              |
| 6.50-7.00 mm [.256-.276 IN]               |                | Ø3.43-4.57 mm [.135-.180 IN] |              |
| TERMINAL APPLICATION SPECIFICATION        | KET Rev 4/7/09 | -                            | -            |
| TERMINALS APPLIED <sup>4</sup>            |                |                              |              |
| TE TERMINAL                               | KET TERMINAL   | TE TERMINAL                  | KET TERMINAL |
| 2113858-1                                 | ST710507-1     | 2113858-3                    | ST710507-3   |
| 2113858-2                                 | ST710507-2     |                              |              |

| TERMINAL DATA: KET TERMINAL               |                | KET CRIMP SPECIFICATION      |              |
|---|----------------|------------------------------|--------------|
| TERMINAL NAME: TERMINAL, EARTH RING RIGHT |                |                              |              |
| WIRE STRIP LENGTH                         |                | INSULATION DIAMETER RANGE    |              |
| 6.50-7.00 mm [.256-.276 IN]               |                | Ø3.43-4.57 mm [.135-.180 IN] |              |
| TERMINAL APPLICATION SPECIFICATION        | KET Rev 4/7/09 | -                            | -            |
| TERMINALS APPLIED                         |                |                              |              |
| TE TERMINAL                               | KET TERMINAL   | TE TERMINAL                  | KET TERMINAL |
| 2303585-1                                 | ST710964-1     | 2303585-2                    | ST710964-3   |

| WIRE SIZE                      | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|--------------------------------|----------------------------|--------------------------------|
| AVSS 0.85 + 2mm <sup>2</sup>   | 2.35+/-0.05 [.093+/- .002] | 7.0                            |
| (2) AVSS 1.25mm <sup>2</sup>   | 2.30+/-0.05 [.091+/- .002] | 7.6                            |
| AVSS 2mm <sup>2</sup>          | 2.20+/-0.05 [.087+/- .002] | 9.0                            |
| (2) AVSS 0.85mm <sup>2</sup>   | 2.15+/-0.05 [.085+/- .002] | 9.5                            |
| (3) AVSS 0.5mm <sup>2</sup>    | 2.10+/-0.05 [.083+/- .002] | 10.4                           |
| AVSS 0.85 + 0.5mm <sup>2</sup> | 2.05+/-0.05 [.081+/- .002] | 11.4                           |

| WIRE SIZE                      | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|--------------------------------|----------------------------|--------------------------------|
| AVSS 0.85 + 2mm <sup>2</sup>   | 2.35+/-0.05 [.093+/- .002] | 7.0                            |
| (2) AVSS 1.25mm <sup>2</sup>   | 2.30+/-0.05 [.091+/- .002] | 7.6                            |
| AVSS 2mm <sup>2</sup>          | 2.20+/-0.05 [.087+/- .002] | 9.0                            |
| (2) AVSS 0.85mm <sup>2</sup>   | 2.15+/-0.05 [.085+/- .002] | 9.5                            |
| (3) AVSS 0.5mm <sup>2</sup>    | 2.10+/-0.05 [.083+/- .002] | 10.4                           |
| AVSS 0.85 + 0.5mm <sup>2</sup> | 2.05+/-0.05 [.081+/- .002] | 11.4                           |

- <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: 8-2266995-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266995-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266995-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266995-6
- 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 ITEM 62. 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 3.45.
- <sup>13</sup> CUT TO LENGTH AT ASSEMBLY.
- <sup>14</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  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| -   | 1  | 1  | 1  | 1  | 1  | 1803078-5 | SPACER, PRECISION               | 259     |
| -   | 1  | -  | 1  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252     |
| -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)

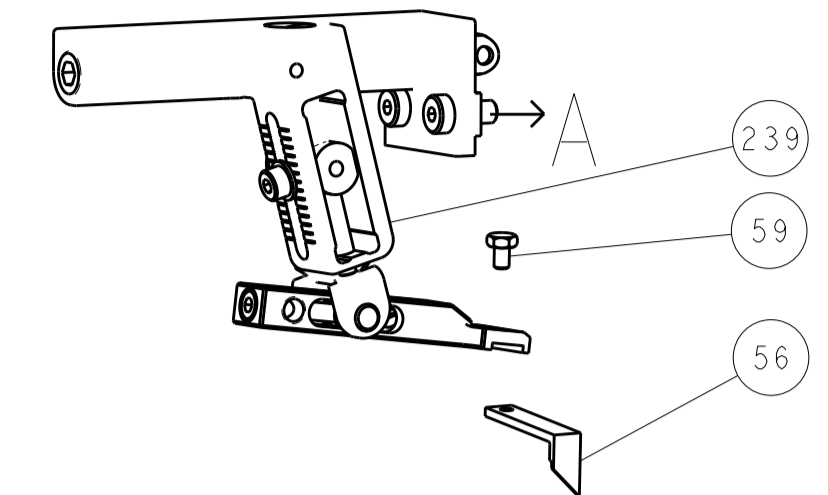
| SET UP GAUGE |  | LOC | DIST | REVISIONS |     |               |           |     |      |
|--------------|--|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-1    |  | A   | 66   | #         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|              |  |     |      | 1         |     | ORIGINAL      | 21SEP2015 | GH  | TE   |
|              |  |     |      | A         |     | RELEASED      | 30OCT2015 | GH  | TE   |
|              |  |     |      | A1        |     | ECR-16-008221 | 7JUN2016  | RS  | LZ   |

|   |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | -   | -   | 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   | -   | -   | -   | 2161314-1   | RAM, STEPPED, ATLANTIC, SF, NON-ADJ | 245 |
| - | 1   | 1   | 1   | 1   | 1   | 2119082-8   | 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 |
| - | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117 |
| - | 1   | 1   | 1   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113 |
| - | 1   | 1   | 1   | 1   | 1   | 1-455888-0  | 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   | 1338683-8   | FEED PAWL                           | 56  |
| - | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54  |
| - | 2   | 2   | 2   | 2   | 2   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 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   | 2161311-1   | RAM, STEPPED, AMP STYLE, SIDE FEED  | 44  |
| - | 1   | 1   | 1   | 1   | 1   | 1-2079383-5 | SCR, BHSC, RoHS (M8 X 40)           | 41  |
| - | 1   | -   | 1   | 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   | 1-1752356-3 | 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   | 1-1320908-8 | 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   | 1320928-6   | 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   | 2119533-2   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 1   | 1   | 1   | 4-22280-7   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1   | 1   | 1   | 1-356885-3  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1   | 1   | 1   | 454276-5    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 1   | 1-1803249-5 | ANVIL, COMBINATION                  | 8   |
| - | 1   | 1   | 1   | 1   | 1   | 240641-5    | SPACER                              | 7   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 1   | 1-2119757-2 | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 3-238011-4  | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 1   | 1803246-4   | CRIMPER, INSULATION F PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 455888-8    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1   | 1   | 1   | 3-1803188-5 | CRIMPER, WIRE                       | 1   |

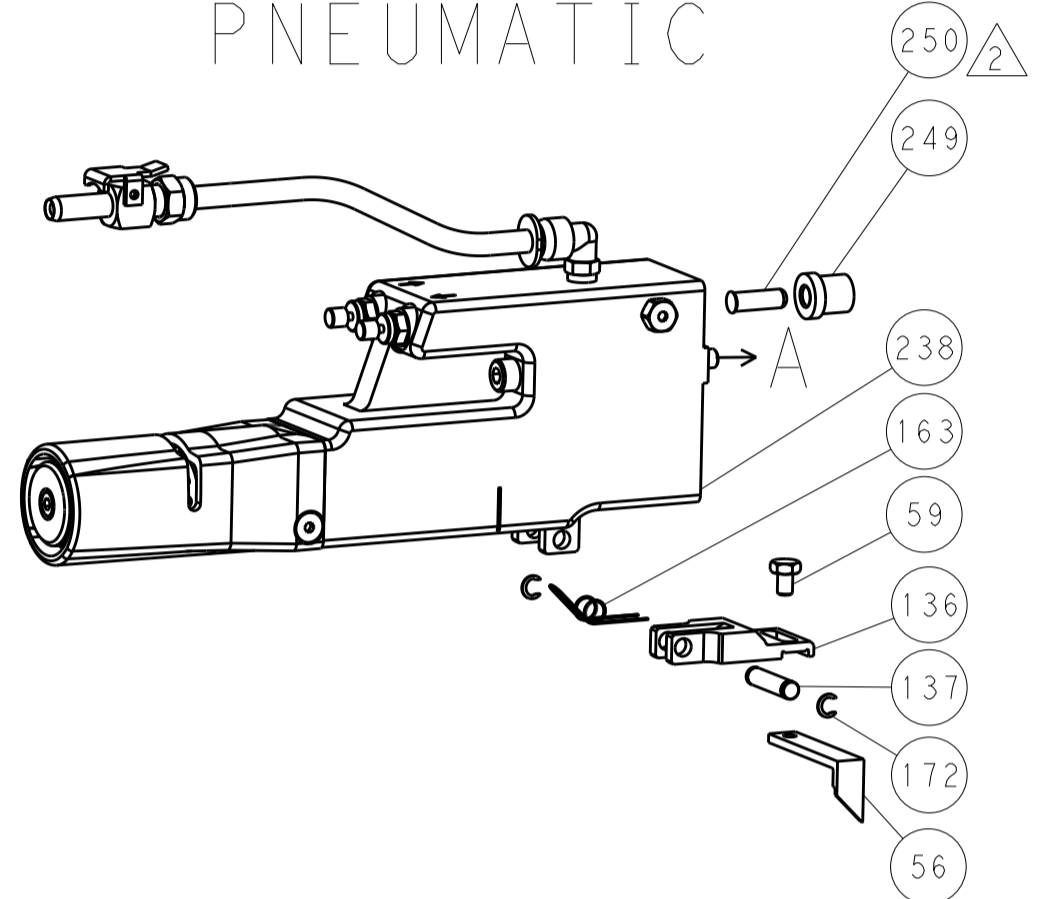
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DRAWING NO |         | RESTRICTED TO                          |          |
|-------------|---------|--|---------|------------|---------|--|----------|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±    | 4 PLC ± | ANGLES ±                               | FINISH ± |
| MATERIAL    |         | FINISH                                 |         | WEIGHT     |         | SCALE                                  |          |
|             |         |  |         | A1 00779   |         | Customer Accessible Production Drawing |          |

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

### FEED TYPE MECHANICAL



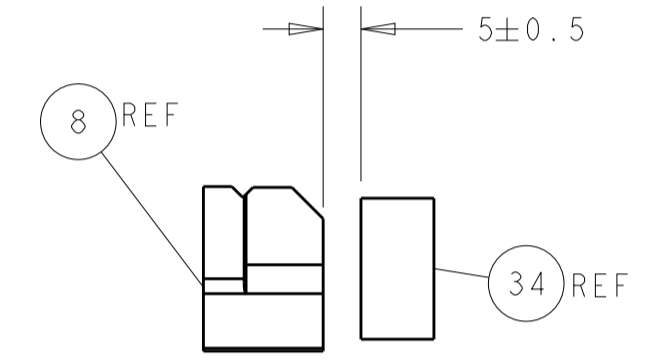
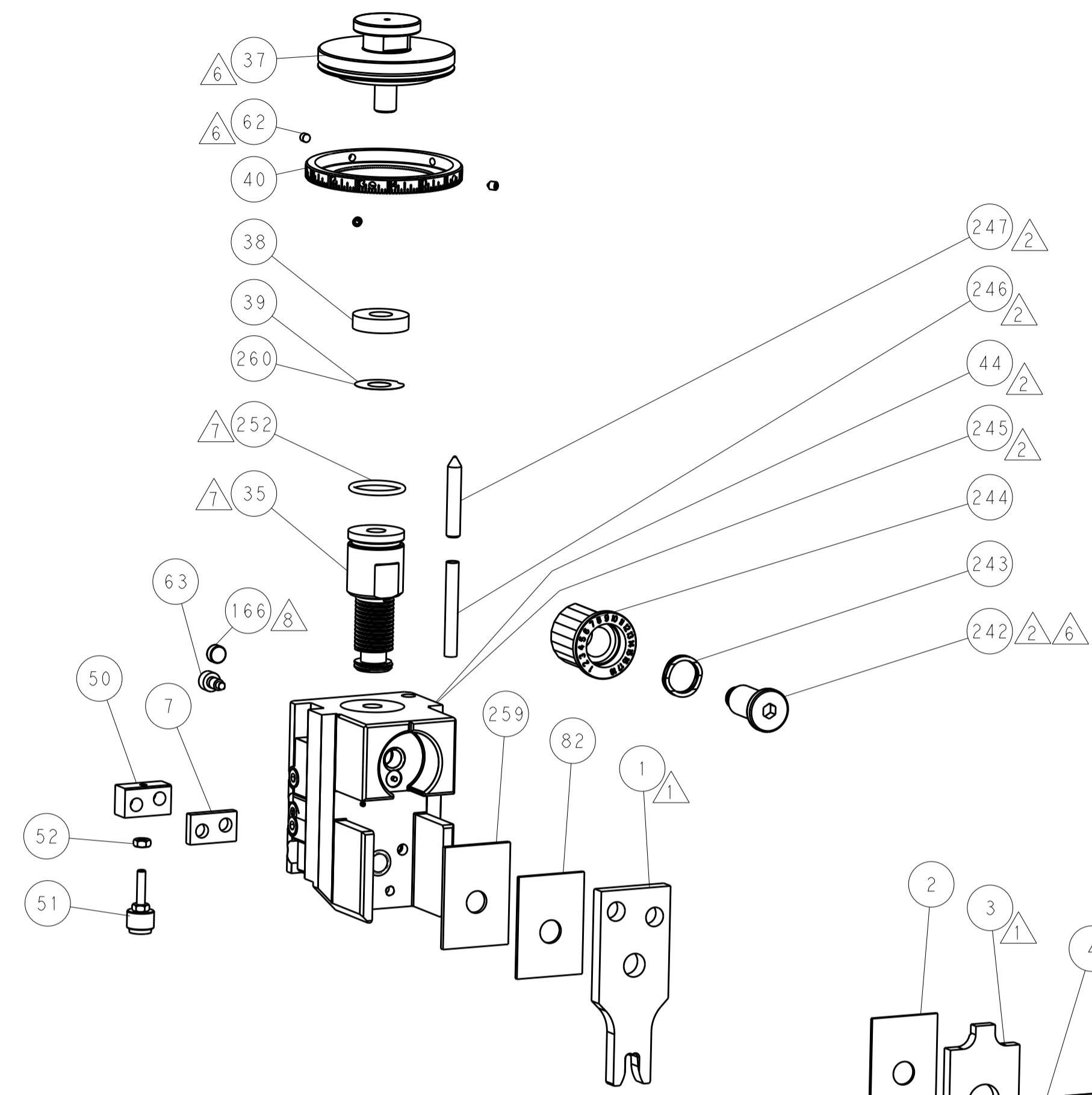
### PNEUMATIC



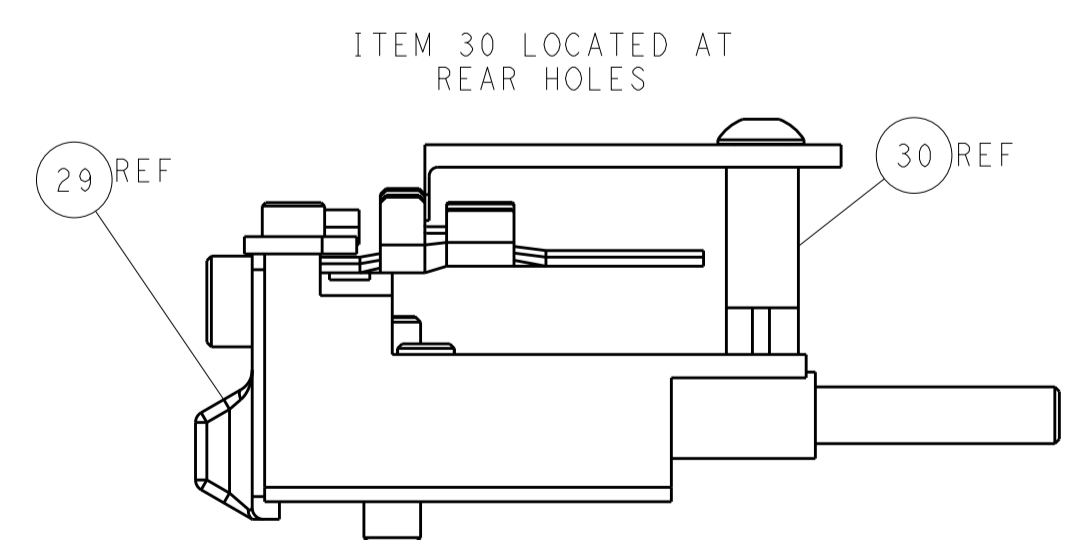
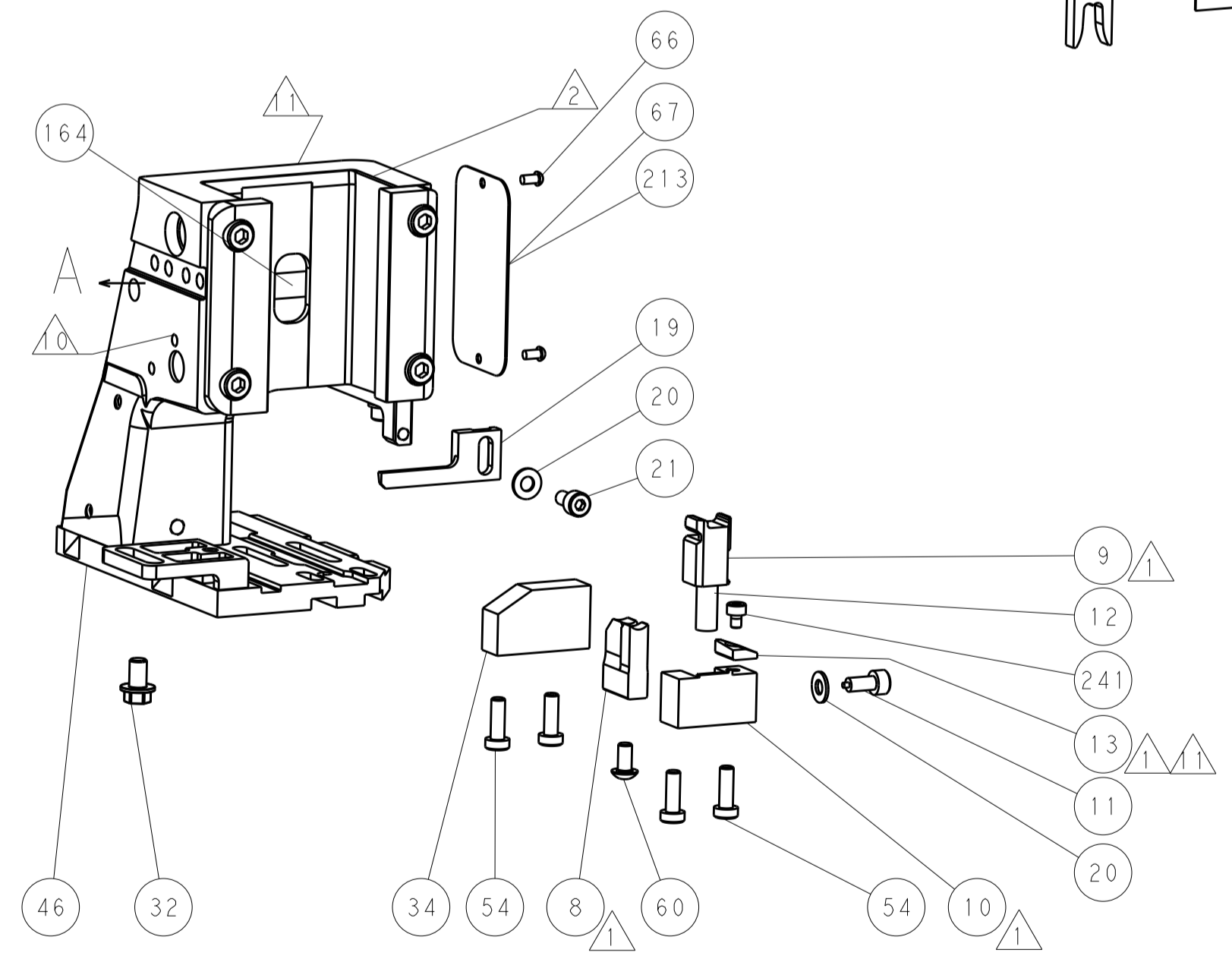
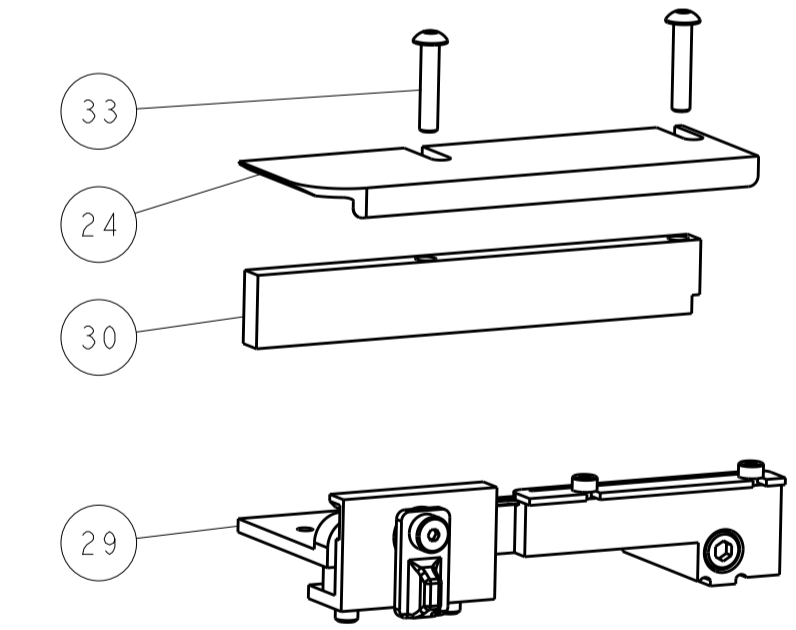
### SERVO LATCH PLATE



### CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

|  |         |  |         |                          |         |                                  |                           |
|--|---------|--|---------|--------------------------|---------|----------------------------------|---------------------------|
| DIMENSIONS:                            |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DWG: HOFFNER 21SEP2015   |         | TE Connectivity                  |                           |
| mm                                     | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                  | 4 PLC ± | 5 PLC ±                          | Harrisburg, PA 17105-3608 |
| MATERIAL:                              |         | FINISH:                                |         | CHK: T. ELBIN 22SEP2015  |         | NAME: Ocean Side Feed Applicator |                           |
| APVD: T. ELBIN 22SEP2015               |         | PRODUCT SPEC:                          |         | APVD: T. ELBIN 22SEP2015 |         | RESTRICTED TO:                   |                           |
| APPLICATION SPEC:                      |         | WEIGHT:                                |         | SIZE: A1                 |         | CAGE CODE: 00779                 |                           |
| Customer Accessible Production Drawing |         | SCALE: 1:2                             |         | SHEET: 2 of 4            |         | REV: A1                          |                           |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|  |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|  | 2-2266995-1 | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED                    | 2119950-1             | 1338683-8 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266995-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266995-4 | -         | -         | -                      |
|  | 2-2266995-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | MECHANICAL FEED                   | 2119949-1             | 1338683-8 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266995-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266995-4 | -         | -         | -                      |
|  | 2-2266995-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED                   | 2119949-1             | 1338683-8 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                   | PNEUMATIC FEED                    | 2119950-1             | 1338683-8 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  | 2-2266995-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | -         | -                      |
|  | 7-2266995-7 | A        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 4.98 mm [.196] | F    |
| INSUL                                | 6.07 mm [.239] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: KET TERMINAL KET CRIMP SPECIFICATION |                |                              |              |
|---|----------------|------------------------------|--------------|
| TERMINAL NAME: TERMINAL, EARTH RING RIGHT           |                |                              |              |
| WIRE STRIP LENGTH                                   |                | INSULATION DIAMETER RANGE    |              |
| 6.50-7.00 mm [.256-.276 IN]                         |                | Ø3.43-4.57 mm [.135-.180 IN] |              |
| TERMINAL APPLICATION SPECIFICATION                  | KET Rev 4/7/09 | -                            | -            |
| TERMINALS APPLIED                                   |                |                              |              |
| TE TERMINAL   | KET TERMINAL   | TE TERMINAL                  | KET TERMINAL |
| 2113858-1   | ST710507-1     | 2113858-3                    | ST710507-3   |
| 2113858-2   | ST710507-2     |                              |              |

| TERMINAL DATA: KET TERMINAL KET CRIMP SPECIFICATION |                |                              |              |
|---|----------------|------------------------------|--------------|
| TERMINAL NAME: TERMINAL, EARTH RING RIGHT           |                |                              |              |
| WIRE STRIP LENGTH                                   |                | INSULATION DIAMETER RANGE    |              |
| 6.50-7.00 mm [.256-.276 IN]                         |                | Ø3.43-4.57 mm [.135-.180 IN] |              |
| TERMINAL APPLICATION SPECIFICATION                  | KET Rev 4/7/09 | -                            | -            |
| TERMINALS APPLIED                                   |                |                              |              |
| TE TERMINAL   | KET TERMINAL   | TE TERMINAL                  | KET TERMINAL |
| 2303585-1   | ST710964-1     | 2303585-2                    | ST710964-3   |

| WIRE SIZE                      | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|--------------------------------|----------------------------|--------------------------------|
| AVSS 0.85 + 2mm <sup>2</sup>   | 2.35+/-0.05 [.093+/- .002] | 7.0                            |
| (2) AVSS 1.25mm <sup>2</sup>   | 2.30+/-0.05 [.091+/- .002] | 7.6                            |
| AVSS 2mm <sup>2</sup>          | 2.20+/-0.05 [.087+/- .002] | 9.0                            |
| (2) AVSS 0.85mm <sup>2</sup>   | 2.15+/-0.05 [.085+/- .002] | 9.5                            |
| (3) AVSS 0.5mm <sup>2</sup>    | 2.10+/-0.05 [.083+/- .002] | 10.4                           |
| AVSS 0.85 + 0.5mm <sup>2</sup> | 2.05+/-0.05 [.081+/- .002] | 11.4                           |

| WIRE SIZE                      | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|--------------------------------|----------------------------|--------------------------------|
| AVSS 0.85 + 2mm <sup>2</sup>   | 2.35+/-0.05 [.093+/- .002] | 7.0                            |
| (2) AVSS 1.25mm <sup>2</sup>   | 2.30+/-0.05 [.091+/- .002] | 7.6                            |
| AVSS 2mm <sup>2</sup>          | 2.20+/-0.05 [.087+/- .002] | 9.0                            |
| (2) AVSS 0.85mm <sup>2</sup>   | 2.15+/-0.05 [.085+/- .002] | 9.5                            |
| (3) AVSS 0.5mm <sup>2</sup>    | 2.10+/-0.05 [.083+/- .002] | 10.4                           |
| AVSS 0.85 + 0.5mm <sup>2</sup> | 2.05+/-0.05 [.081+/- .002] | 11.4                           |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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: 8-2266995-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266995-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266995-5
- 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.  
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.
- CUT TO LENGTH AT ASSEMBLY.
- 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   | 1803078-5 | SPACER, PRECISION | 259     |
| -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)

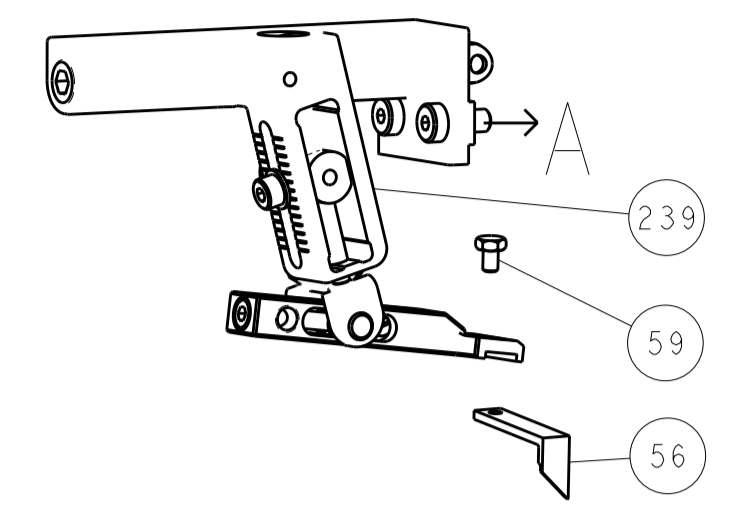
| SET UP GAUGE | LOC | DIST | REVISIONS |             |    |      |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-1    | A   | 66   | REV       | DATE        | BY | APPV |
|              |     |      | -         | SEE SHEET 1 | -  | -    |

|   |     |     |     |     |             |                                      |     |
|---|-----|-----|-----|-----|-------------|--------------------------------------|-----|
| - | 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   | 2119082-8   | 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   | 2161312-1   | RAM, STEPPED, 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   | 1-455888-0  | 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   | 1338683-8   | FEED PAWL                            | 56  |
| - | 2   | 2   | 2   | 2   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16       | 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   | 1-2079383-5 | SCR, BHSC, RoHS (M8 X 40)            | 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   | 1-1752356-3 | 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   | 1-1320908-8 | 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   | 1320928-6   | 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   | 2119533-2   | STRIPPER, SIDE FEED                  | 19  |
| - | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                        | 13  |
| - | 1   | 1   | 1   | 1   | 4-22280-7   | SPRING, COMPRESSION                  | 12  |
| - | 1   | 1   | 1   | 1   | 1-356885-3  | STOP, SHEAR                          | 11  |
| - | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                  | 10  |
| - | 1   | 1   | 1   | 1   | 454276-5    | FLOATING SHEAR, FRONT                | 9   |
| - | 1   | 1   | 1   | 1   | 1-1803249-5 | ANVIL, COMBINATION                   | 8   |
| - | 1   | 1   | 1   | 1   | 240641-5    | SPACER                               | 7   |
| - | -   | -   | -   | -   | -           | -                                    | 6   |
| - | 1   | 1   | 1   | 1   | 1-2119757-2 | DEPRESSOR, SHEAR                     | 5   |
| - | 1   | 1   | 1   | 1   | 3-238011-4  | BLOCK, CRIMPER SPACER                | 4   |
| - | 1   | 1   | 1   | 1   | 1803246-4   | CRIMPER, INSULATION F PREMIUM        | 3   |
| - | 1   | 1   | 1   | 1   | 455888-8    | SPACER, CRIMPER                      | 2   |
| - | 1   | 1   | 1   | 1   | 3-1803188-5 | CRIMPER, WIRE                        | 1   |

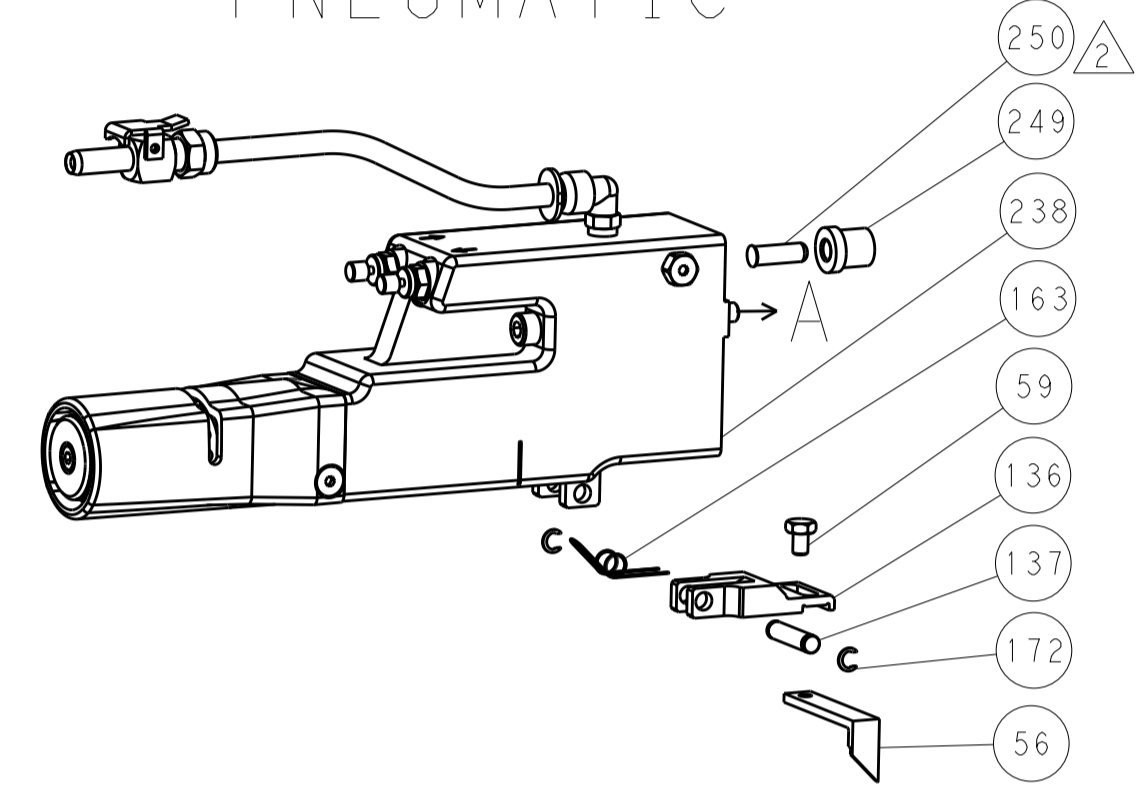
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |          | OWN                                    | CHK      | APPV               | DATE      | NAME                      |  |
|-------------|---------|--|----------|--|----------|--------------------|-----------|---------------------------|--|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ±  | OFFNER                                 | T. ELBIN | T. ELBIN           | 21SEP2015 | TE Connectivity           |  |
|             | 3 PLC ± | 4 PLC ±                                | ANGLES ± |  |          |                    | 22SEP2015 | Harrisburg, PA 17105-3608 |  |
| MATERIAL    | FINISH  | WEIGHT                                 | SCALE    | Customer Accessible Production Drawing |          | A1 00779 ©=2266995 |           | RESTRICTED TO             |  |
|             |         |  | 1:2      |  |          | SHEET 3 OF 4       |           | REV A1                    |  |

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

# FEED TYPE MECHANICAL



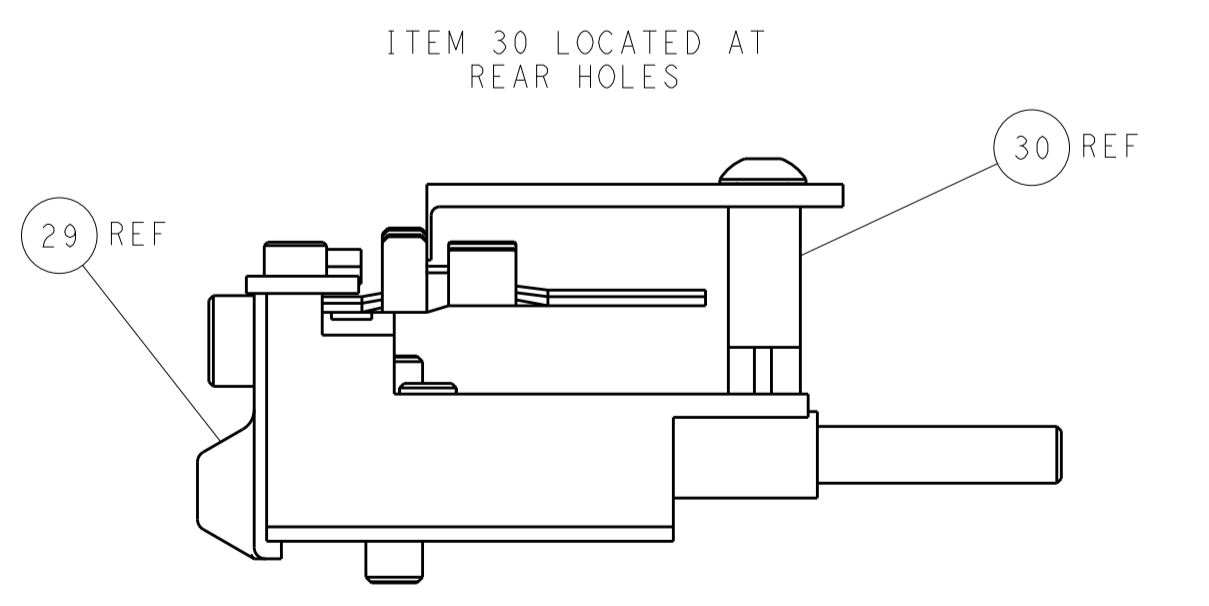
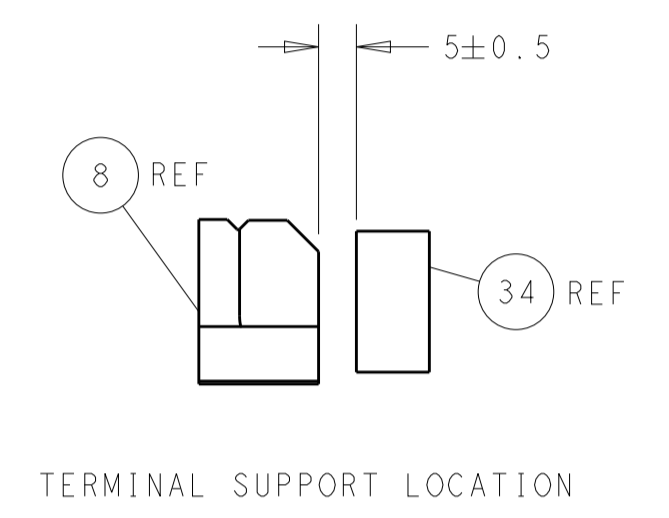
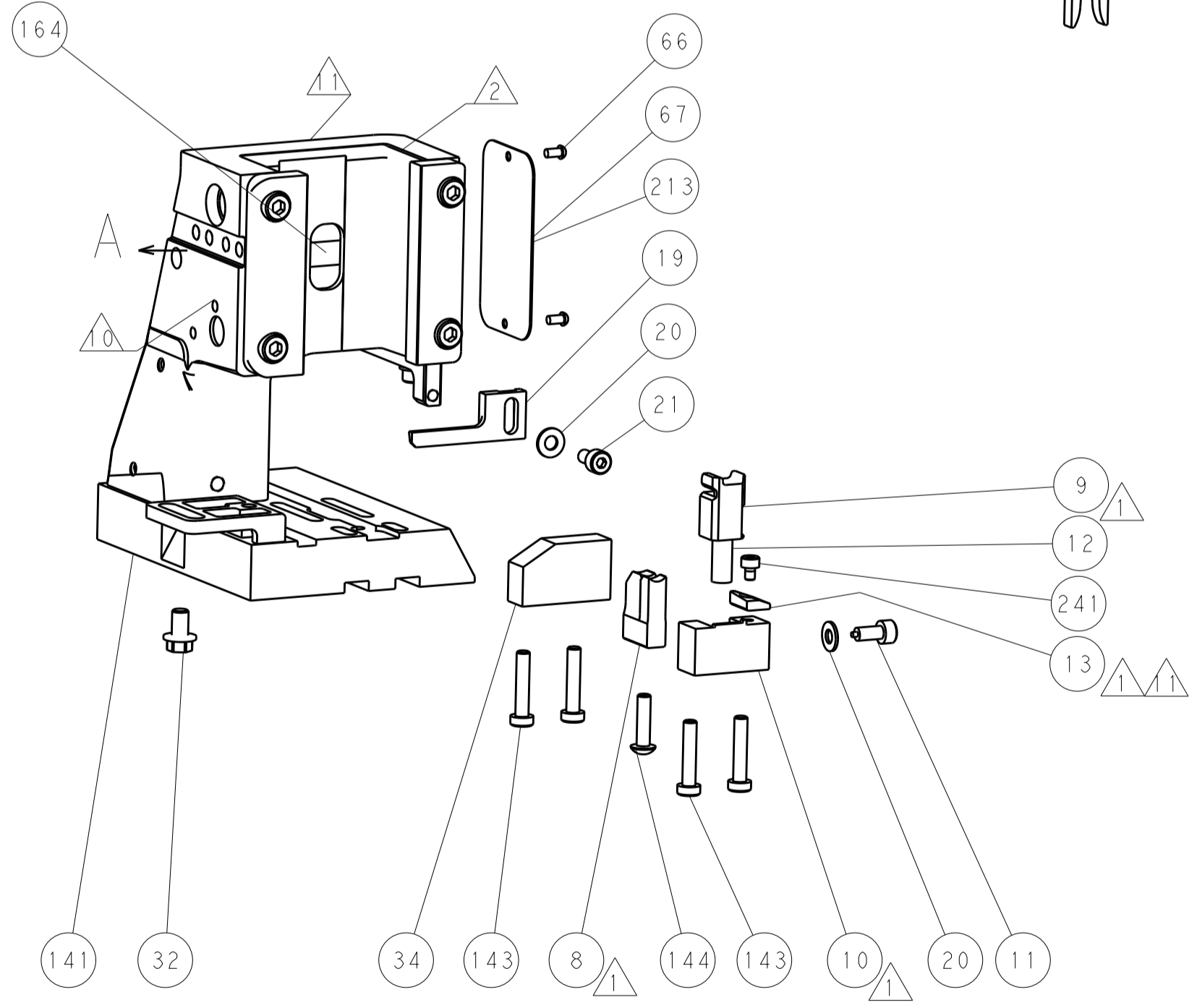
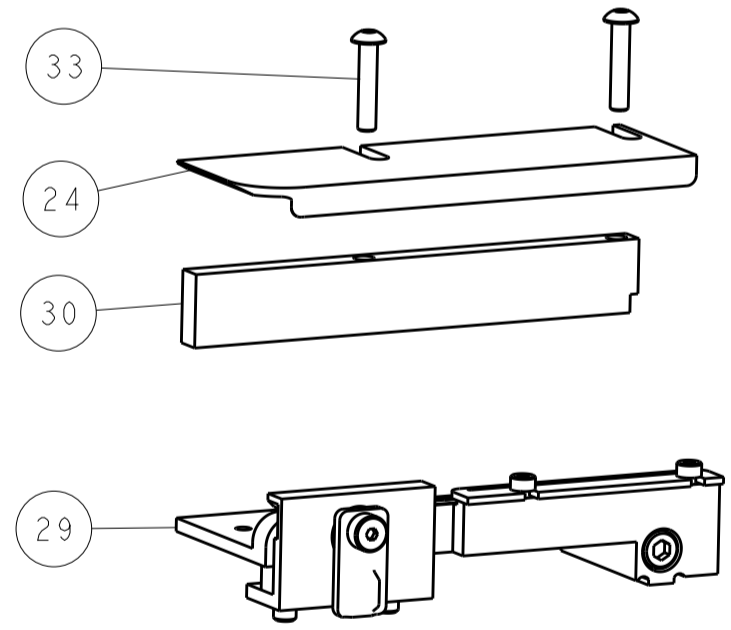
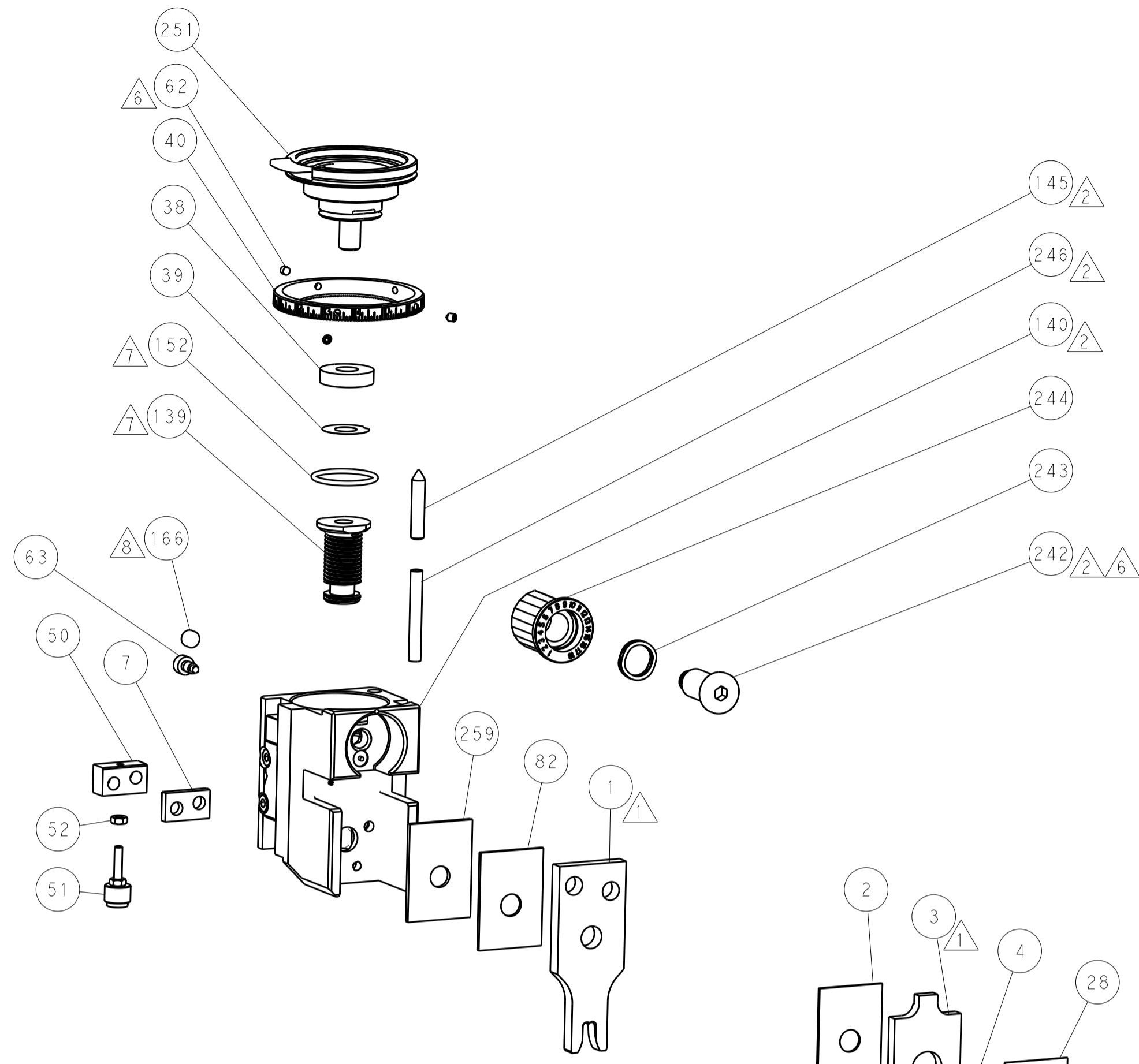
# PNEUMATIC



# 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: HOFFNER 21SEP2015                 |           | REV: T. ELBIN 22SEP2015 |               | NAME: Ocean Side Feed Applicator |        |
| mm          | 0 PLC  | ±                                      |  | SIZE                                   | CAGE CODE | DRAWING NO              | RESTRICTED TO |                                  |        |
|             | 1 PLC  | ±                                      |  | A1                                     | 00779     | ©=2266995               |               |                                  |        |
|             | 2 PLC  | ±                                      |  | Customer Accessible Production Drawing |           | SCALE                   | 1:2           | SHEET                            | 4 OF 4 |
|             | 3 PLC  | ±                                      |  |  |           |                         |               |                                  |        |
|             | 4 PLC  | ±                                      |  |  |           |                         |               |                                  |        |
|             | ANGLES | ±                                      |  |  |           |                         |               |                                  |        |
| MATERIAL    | FINISH |  |  |  |           |                         |               |                                  |        |