

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE                      | CONVERT TO                      | PART NUMBERS REQUIRED |           |             |           |           |                        |
|---|-------------|--------------------------|--------------------------|--------------------------------|---------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   | 2836085-1   | B                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED                  | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |
|   | 2836085-2   | B                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | SERVO LATCH PLATE               | 2119951-1             | -         | 8-2836085-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                                | SMART APPLICATOR                | 2161326-1             | -         | 8-2836085-4 | -         | -         |                        |
|   |             |                          |                          |                                | MECHANICAL FEED                 | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -         | -                      |
|   | 2836085-5   | B                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | SERVO LATCH PLATE               | 2119951-1             | -         | 8-2836085-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                                | SMART APPLICATOR                | 2161326-1             | -         | 8-2836085-4 | -         | -         |                        |
|   | 2836085-6   | B                        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | SERVO LATCH PLATE <sup>12</sup> | MECHANICAL FEED       | 2119949-1 | 1338685-1   | 5-18022-5 | 2119653-1 | -                      |
| PNEUMATIC FEED                                |             |                          |                          |                                |                                 | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |
| 2836085-7                                     | B           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                              | -                               | -                     | -         | -           | -         | -         | -                      |
| 7-2836085-7                                   | A           | CRIMP TOOLING KIT        | -                        | -                              | -                               | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA |                 |      |
|-----------------|-----------------|------|
| CRIMP           | SIZE            | TYPE |
| WIRE            | 1.55 mm [0.061] | F    |
| INSUL           | -               | -    |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: HI-STAT TERMINAL Season Group CRIMP SPECIFICATION |   |
|--|---|
| TERMINAL NAME: TERMINAL , FEMALE                                 |   |
| WIRE STRIP LENGTH<br>4.34-5.11 mm [0.171-.201 IN]                | INSULATION DIAMETER RANGE<br>1.30-1.60 mm [0.051-.063 IN] |
| TERMINAL APPLICATION SPECIFICATION                               | Season Group  |
| TERMINALS APPLIED  |   |
| TE TERMINAL  | HI-STAT TERMINAL  |
| 2113919-1  | 503-607-10  |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]         | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 20 AWG    | 1.25 +/- 0.05 [0.049 +/- .002] | 9.0                            |

- <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: 8-2836085-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836085-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836085-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836085-6
- 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. 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 4.55.

**\*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)

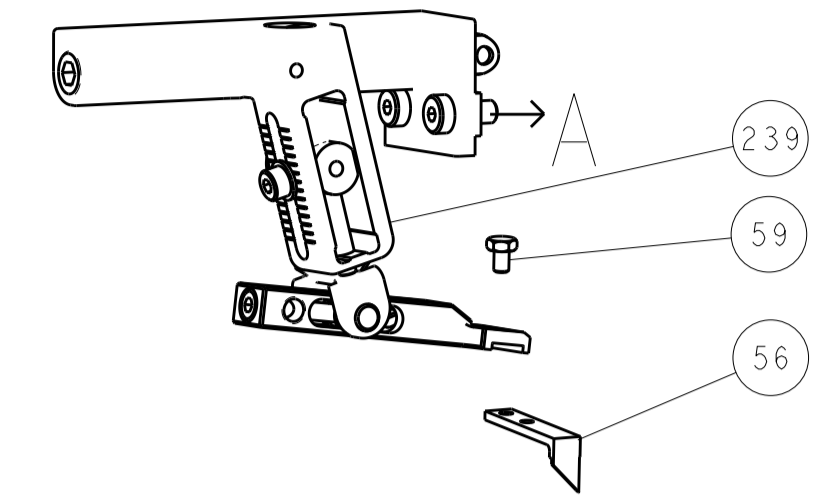
| SET UP GAUGE | LOC | DIST | REVISIONS |               |           |     |      |
|--------------|-----|------|-----------|---------------|-----------|-----|------|
| 2119599-1    | A   | 66   | P LTR     | DESCRIPTION   | DATE      | OWN | APVD |
|              |     |      | A         | RELEASED      | 07DEC2015 | BW  | TE   |
|              |     |      | B         | ECR-16-011879 | 18AUG2016 | JH  | TE   |

|   |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | 1   | -   | -   | -   | 2119957-2   | APPLICATOR SHIM PACK                | 260 |
| - | 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 |
| - | 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   | 455888-4    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 5-547505-2  | 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  |
| - | 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  |
| - | 2   | 2   | 2   | 2   | 2   | 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   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44  |
| - | 1   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | -   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
| - | 1   | -   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
| - | 1   | 1   | 1   | 1   | 1   | 2119644-1   | 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  |
| - | 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  |
| - | 2   | 2   | 2   | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | 1   | 1   | 1   | 2119533-3   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1   | 1   | 1   | 318707-1    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 1   | 6-1633933-6 | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 1   | 2119780-2   | DEPRESSOR, SHEAR                    | 5   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 4   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 3   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 2   |
| - | 1   | 1   | 1   | 1   | 1   | 2-1333281-3 | CRIMPER, WIRE PREMIUM               | 1   |

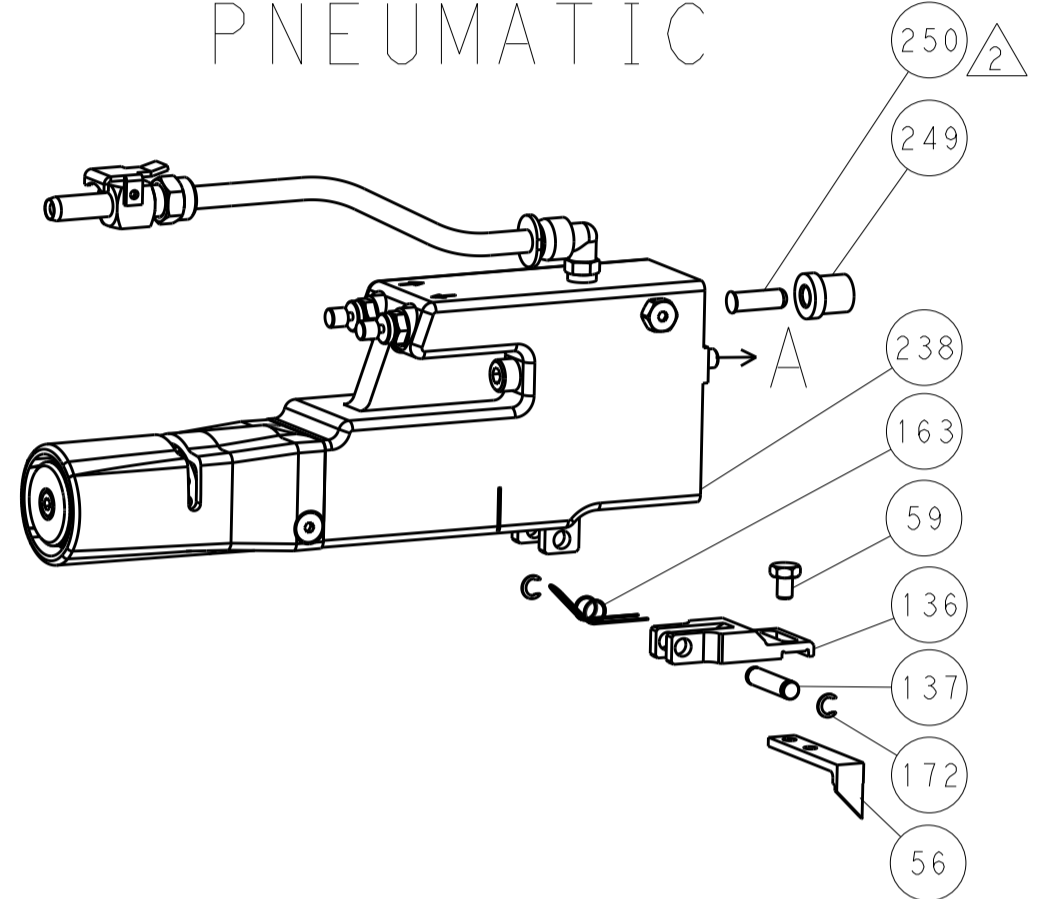
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|-------------|--------|--|--|------------------|--------|
| mm          | 0 PLC  | ±                                      |  | SCALE            | 1:2    |
|             | 1 PLC  | ±                                      |  | SHEET            | 1 OF 4 |
|             | 2 PLC  | ±                                      |  | REV              | B      |
|             | 3 PLC  | ±                                      |  |                  |        |
|             | 4 PLC  | ±                                      |  |                  |        |
|             | ANGLES | ±                                      |  |                  |        |
| MATERIAL    | FINISH |  |  |                  |        |

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

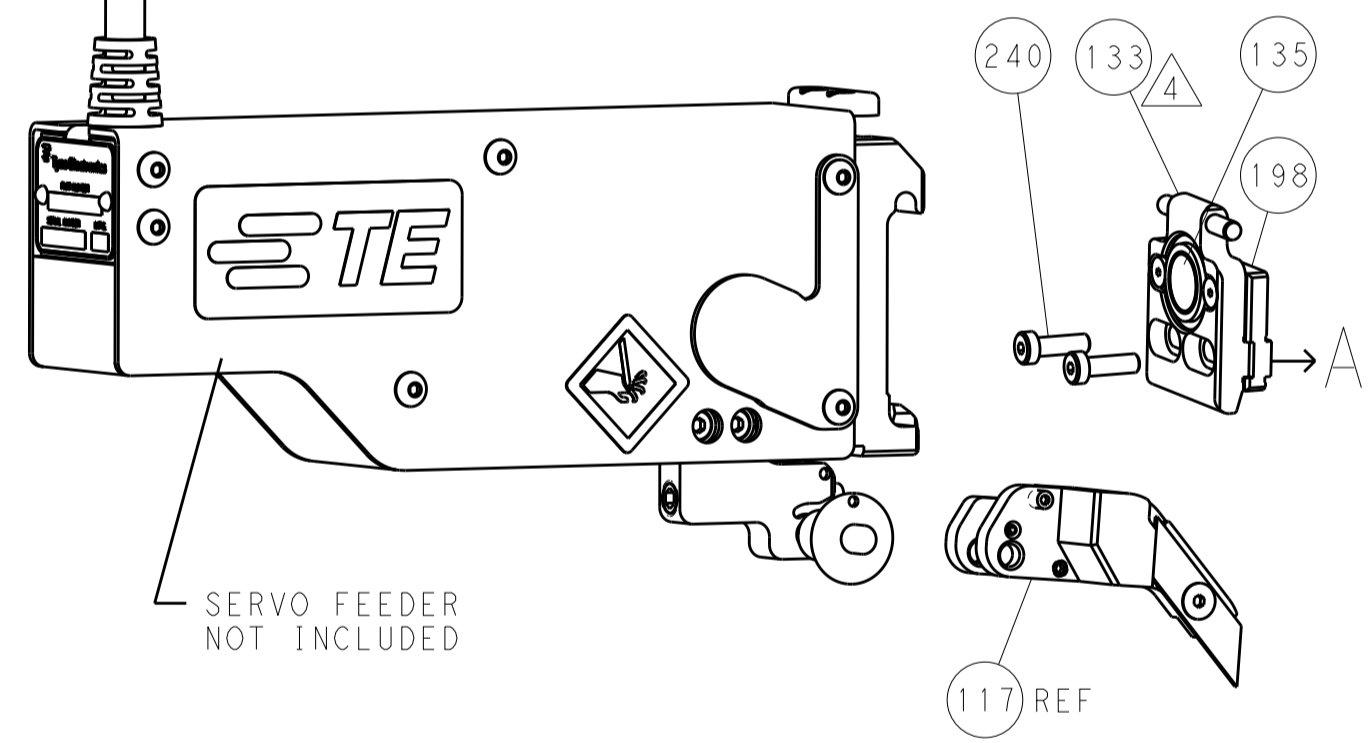
### FEED TYPE MECHANICAL



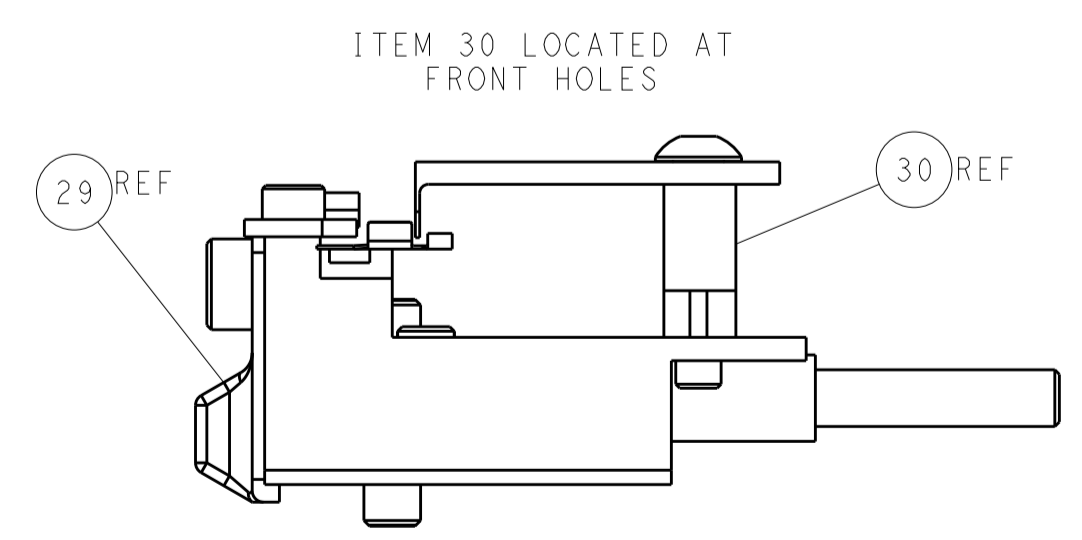
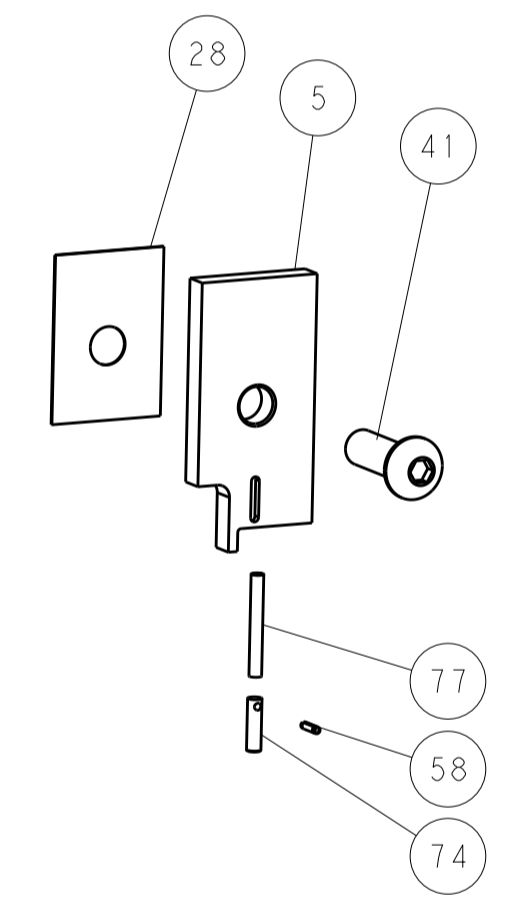
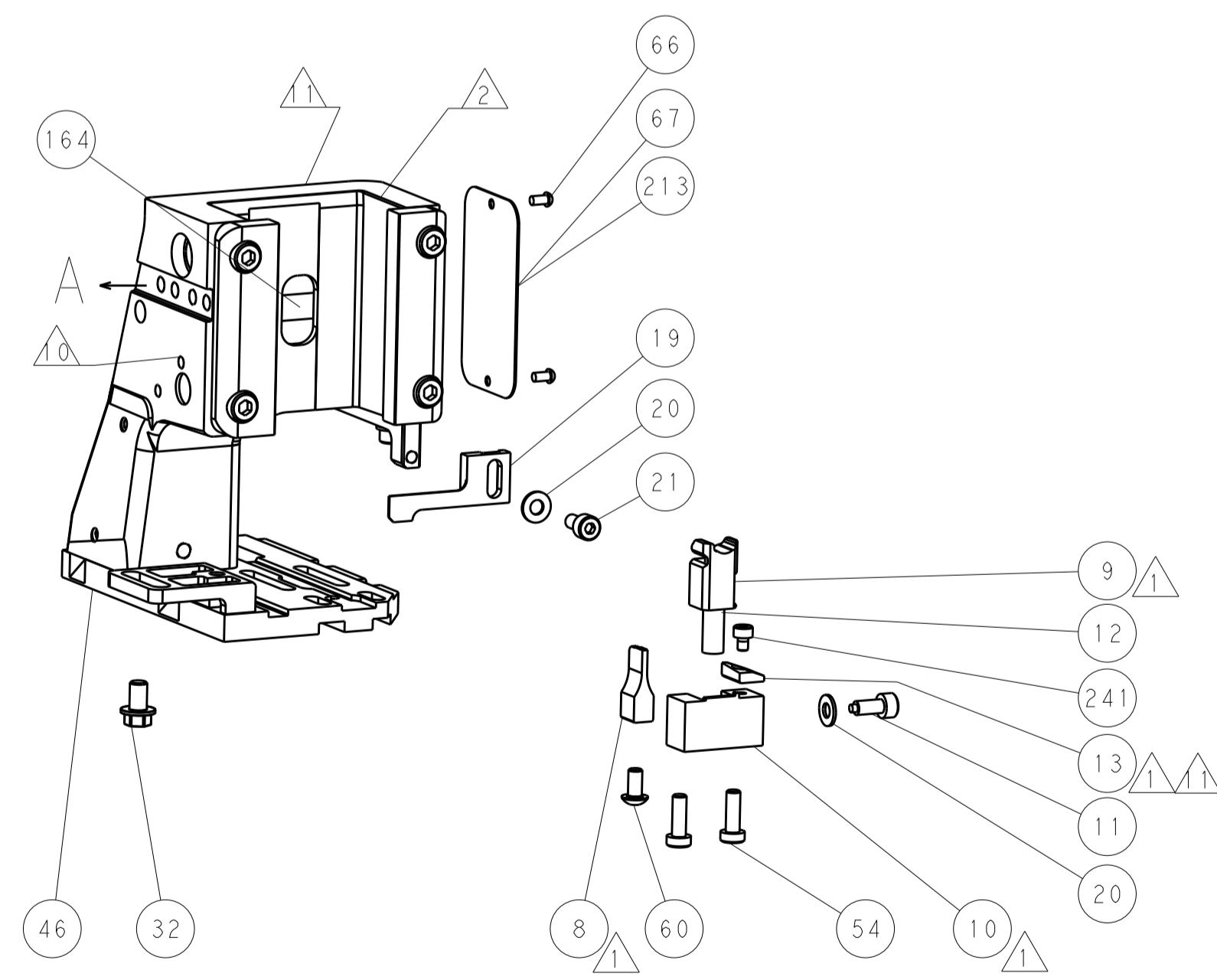
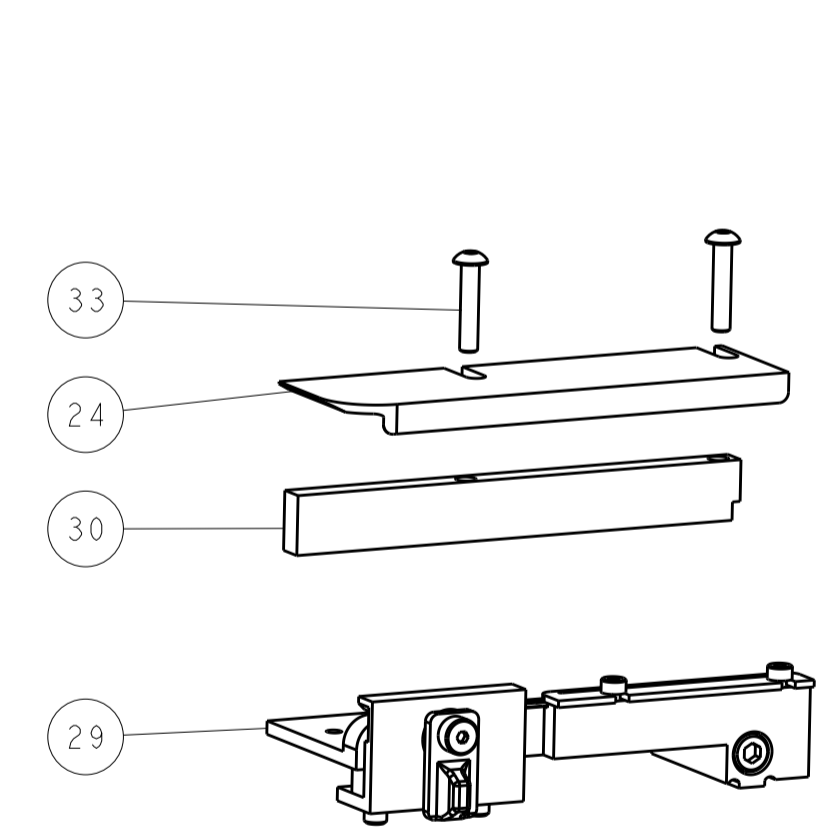
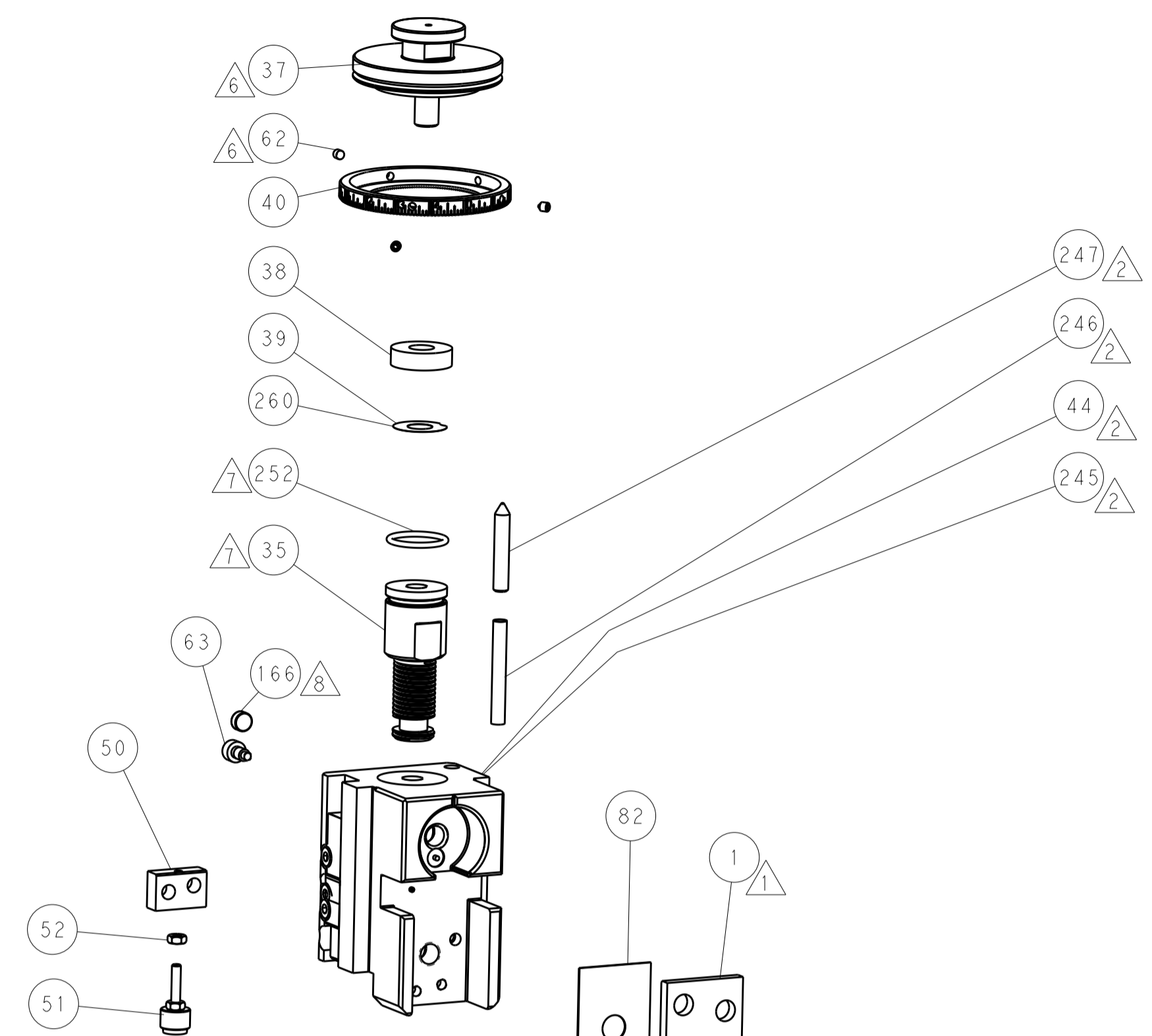
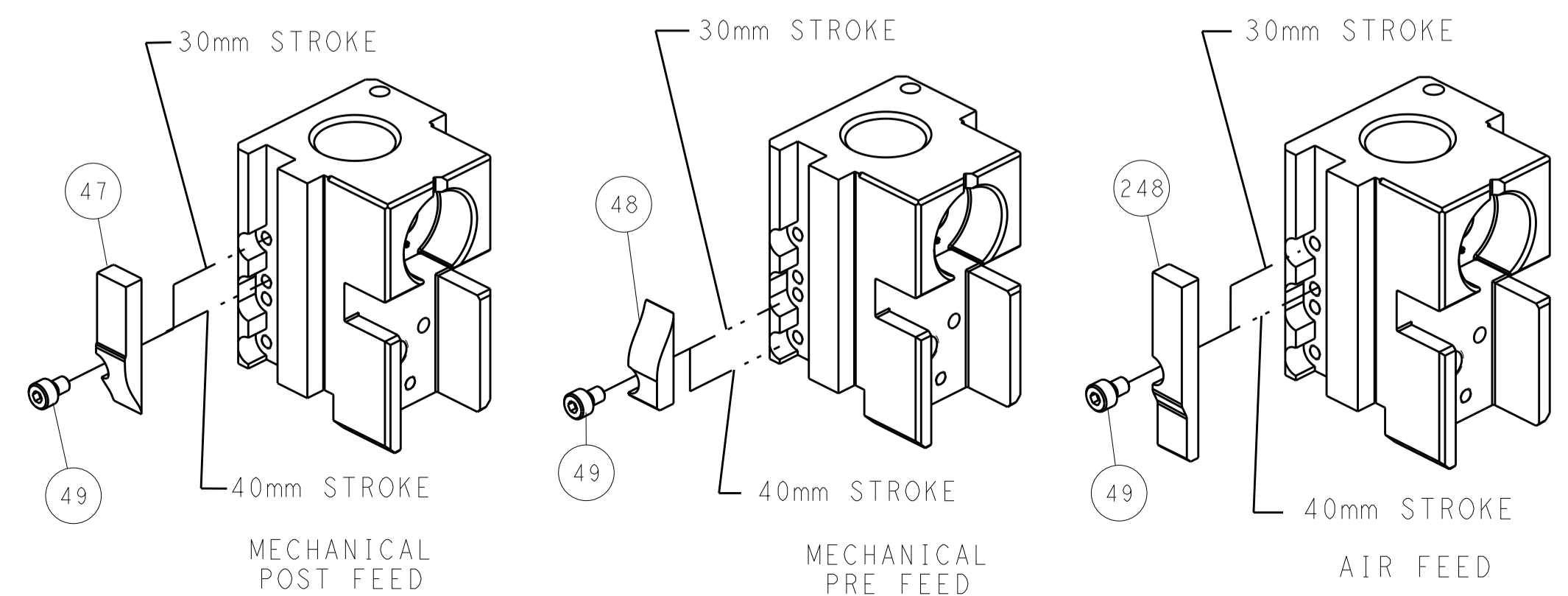
### PNEUMATIC



### 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: |         | DWN: J. HOU 22OCT2015   |         | TE Connectivity                            |  |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                 | 4 PLC ± | Harrisburg, PA 17105-3608                  |  |
| MATERIAL:   |         | FINISH:                                |         | CHK: L. ZHANG 22OCT2015 |         | NAME: Ocean Side Feed Applicator           |  |
|             |         |  |         | APVD: H. GUO 22OCT2015  |         | SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO |  |
|             |         |  |         | PRODUCT SPEC:           |         | A11 00779 ©=2836085                        |  |
|             |         |  |         | APPLICATION SPEC:       |         | SCALE: 1:2 SHEET 2 OF 4 REV B              |  |
|             |         |  |         | WEIGHT:                 |         | CUSTOMER DRAWING                           |  |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|  |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|  | 2-2836085-1 | B        | 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             | -         | 8-2836085-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2836085-4 | -         | -         | -                      |
|  | 2-2836085-2 | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2836085-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2836085-4 | -         | -         | -                      |
|  | 2-2836085-5 | B        | 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              |
|  | 2-2836085-7 | B        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -         | -                      |
|  | 7-2836085-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.55 mm [.061] | F    |
| INSUL                                | -              | -    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: HI-STAT TERMINAL Season Group CRIMP SPECIFICATION |  |
|--|--|
| TERMINAL NAME: TERMINAL, FEMALE                                  |  |
| WIRE STRIP LENGTH<br>4.34-5.11 mm [1.71-.201 IN]                 | INSULATION DIAMETER RANGE<br>1.30-1.60 mm [.051-.063 IN] |
| TERMINAL APPLICATION SPECIFICATION<br>Season Group               |  |
| TERMINALS APPLIED  |  |
| TE TERMINAL<br>2113919-1   | HI-STAT TERMINAL<br>503-607-10                           |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 20 AWG    | 1.25+/-0.05 [1.049+/-0.02] | 9.0                            |

- 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: 8-2836085-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836085-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836085-5
- 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        | OWN | APVD |
|              |     |      | -         | SEE SHEET 1 | -   | -    |

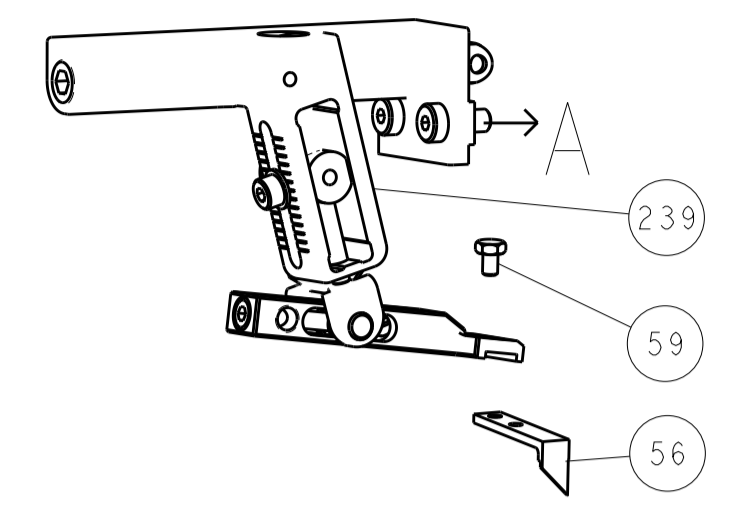
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|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | 1   | 1   | 1   | 2119782-1   | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | -   | -   | 1   | -   | 2119640-1   | PUSH ROD, AIR FEED                  | 250 |
| - | -   | -   | 1   | -   | 2079988-1   | BUSHING, LCH5-12, MISUMI            | 249 |
| - | 1   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| - | 1   | 1   | 1   | 1   | 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 |
| - | 2   | 2   | 2   | 2   | 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   | 455888-4    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 5-547505-2  | 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  |
| - | 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  |
| - | 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   | 318707-1    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 6-1633933-6 | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 2119780-2   | DEPRESSOR, SHEAR                    | 5   |
| - | -   | -   | -   | -   | -           | -                                   | 4   |
| - | -   | -   | -   | -   | -           | -                                   | 3   |
| - | -   | -   | -   | -   | -           | -                                   | 2   |
| - | 1   | 1   | 1   | 1   | 2-1333281-3 | CRIMPER, WIRE PREMIUM               | 1   |

| DIMENSIONS: |        | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DRAWING NO |          |
|-------------|--------|--|--|------------|----------|
| mm          | 0 PLC  | ±                                      |  | 220CT2015  | REV      |
|             | 1 PLC  | ±                                      |  | 220CT2015  | CHK      |
|             | 2 PLC  | ±                                      |  |            | L. ZHANG |
|             | 3 PLC  | ±                                      |  |            | APVD     |
|             | 4 PLC  | ±                                      |  | 220CT2015  | U. GUO   |
|             | ANGLES | ±                                      |  |            |          |
|             | FINISH | ±                                      |  |            |          |

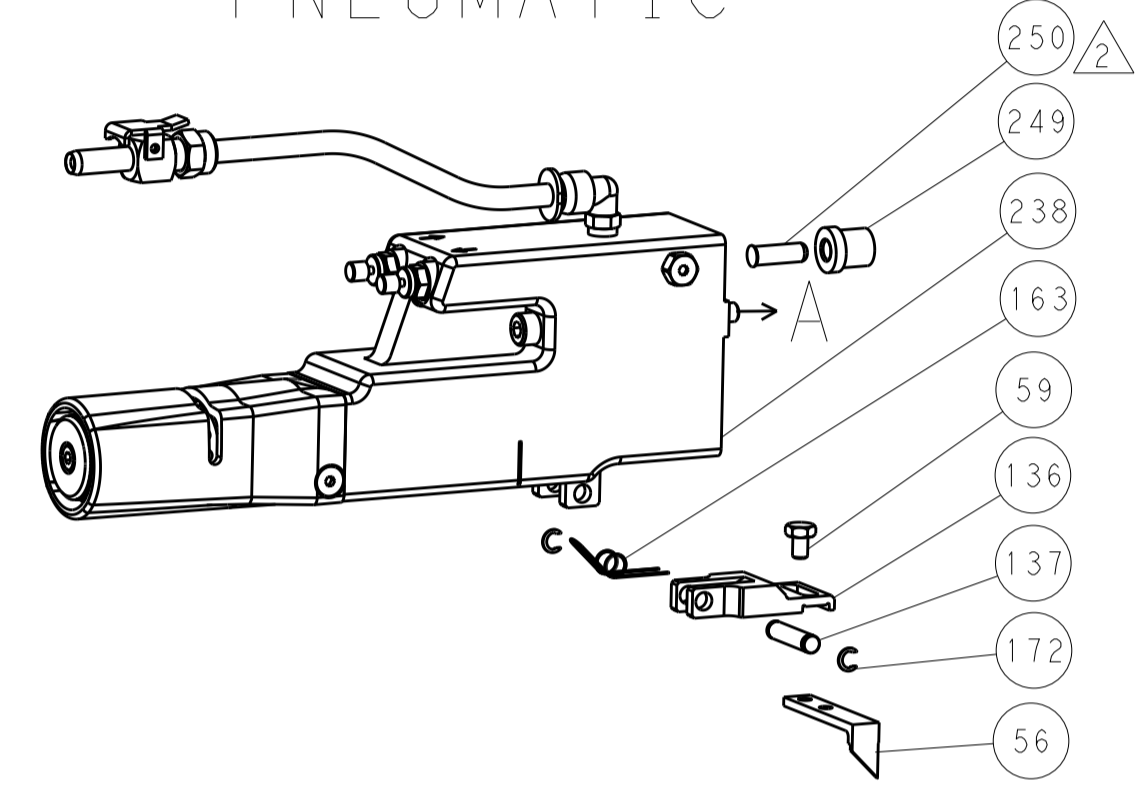
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|------------------|--|-------|-------|----|-----|
| CUSTOMER DRAWING |  | SCALE | SHEET | OF | REV |
| A1               |  | 1:2   | 3     | 4  | B   |

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

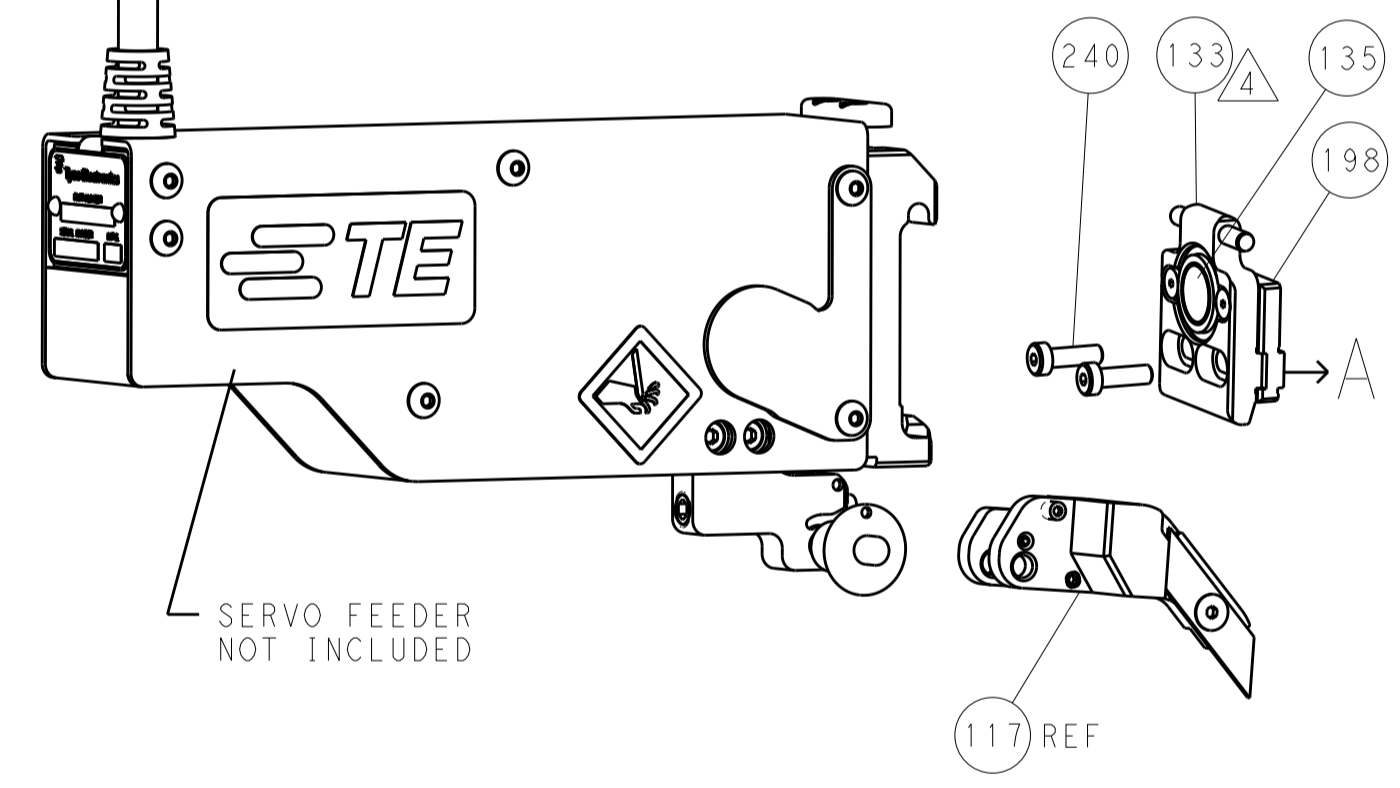
# FEED TYPE MECHANICAL



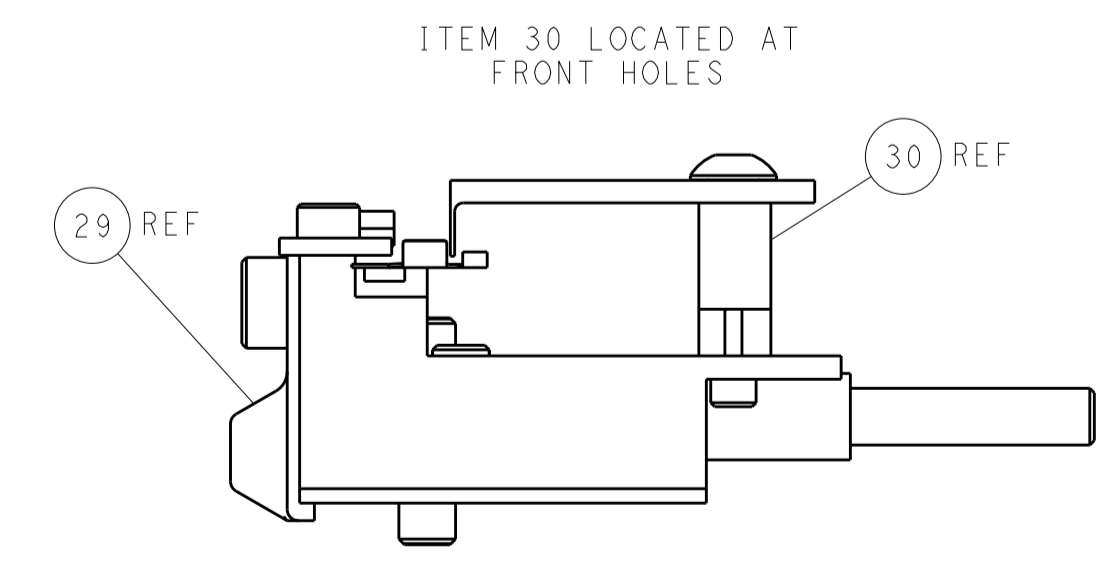
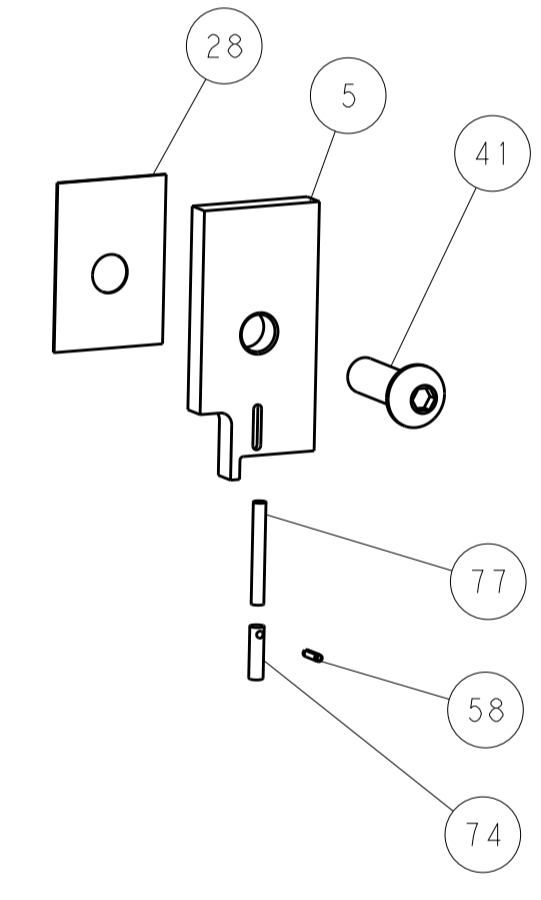
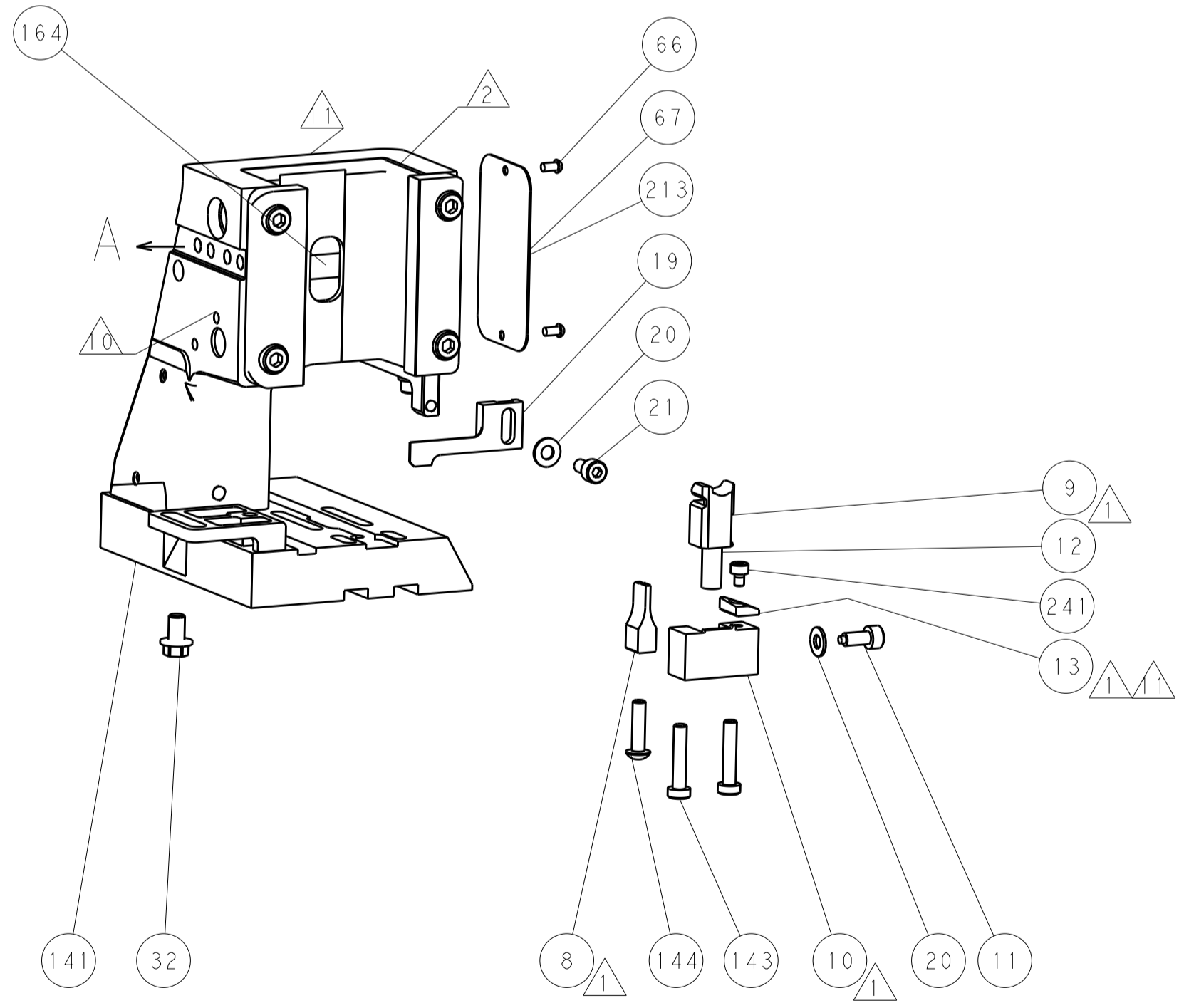
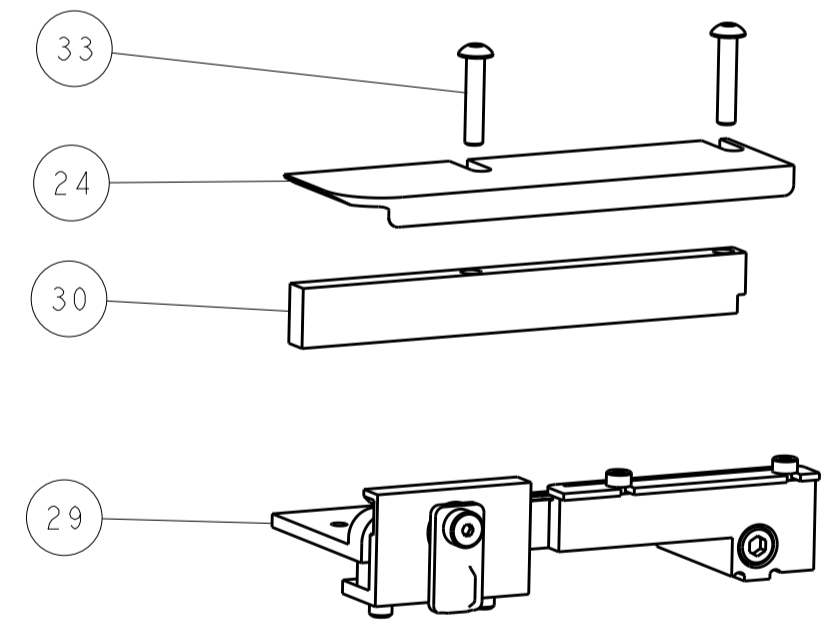
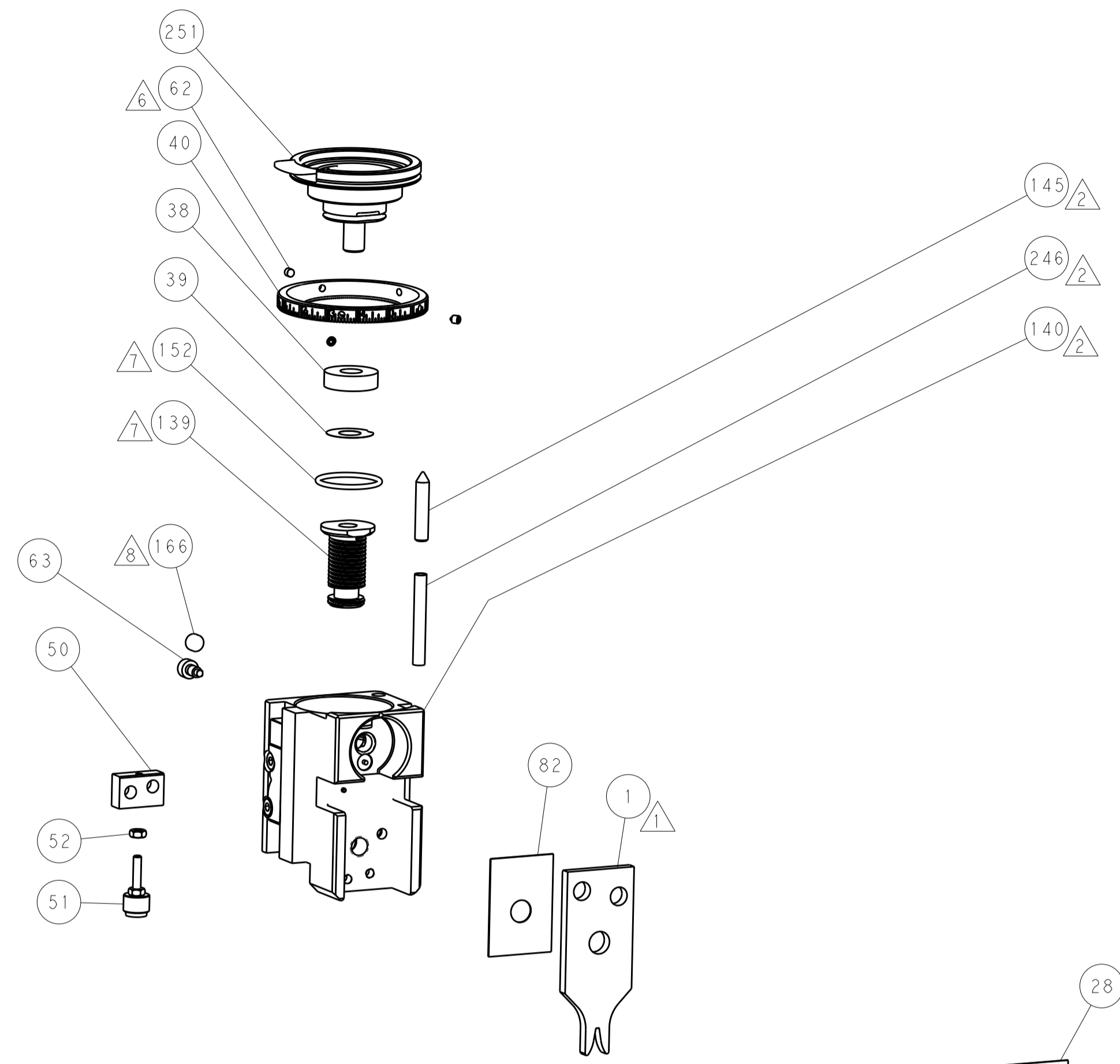
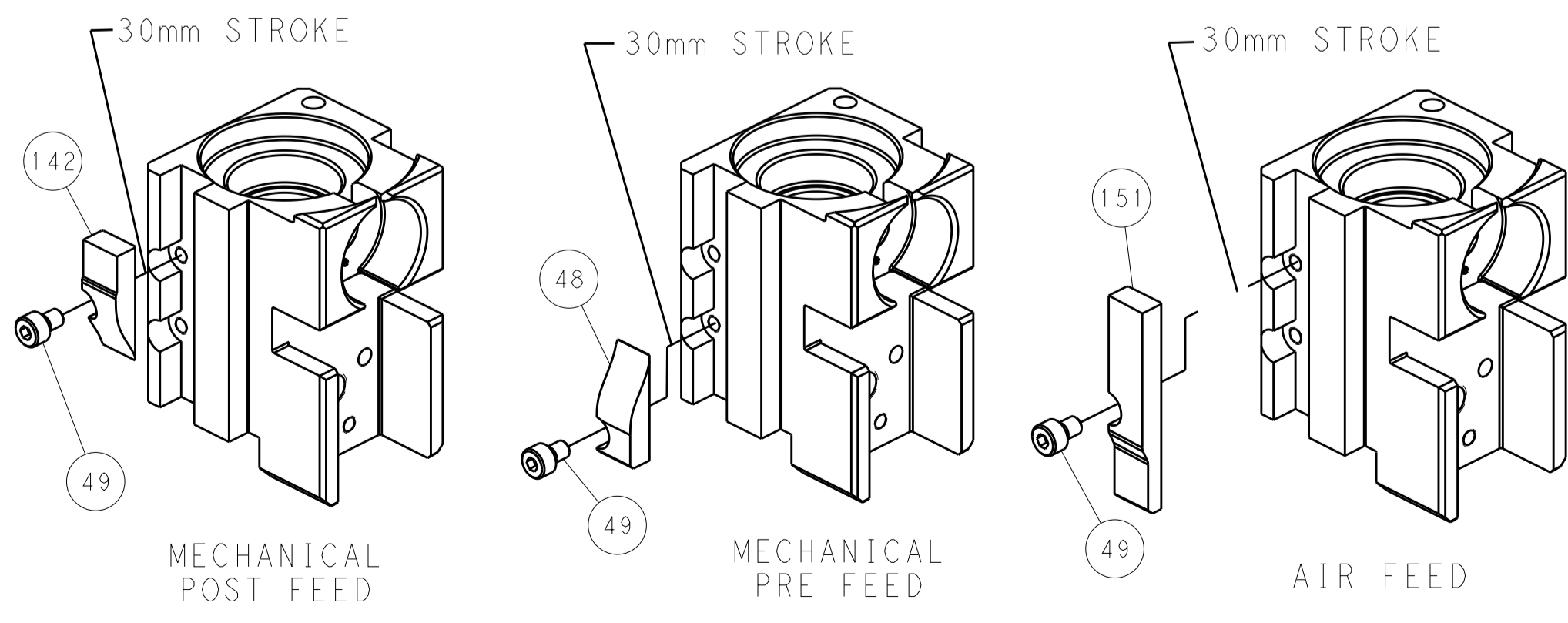
# PNEUMATIC



# 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: |         | DWN J. HOU 22OCT2015   |         | STE Connectivity                |   |
| mm               | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                | 4 PLC ± | 5 PLC ±                         | TE Connectivity Harrisburg, PA 17105-3608 |
| MATERIAL:        |         | FINISH:                                |         | CHK L. ZHANG 22OCT2015 |         | NAME Ocean Side Feed Applicator |   |
| CUSTOMER DRAWING |         | SCALE 1:2                              |         | APVD H. GUO 22OCT2015  |         | RESTRICTED TO                   |   |
|                  |         |  |         | PRODUCT SPEC           |         | SIZE CAGE CODE DRAWING NO       |   |
|                  |         |  |         | APPLICATION SPEC       |         | A1 00779 C=2836085              |   |
|                  |         |  |         | WEIGHT                 |         | SHEET 4 OF 4 REV B              |   |