

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE         | CONVERT TO        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|---|-------------|--------------------------|--------------------------|-------------------|-------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   | 2266218-1   | A                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |
|   | 2266218-2   | A                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | SERVO LATCH PLATE | 2119951-1             | -         | 8-2266218-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2266218-4 | -         | -         |                        |
|   |             |                          |                          |                   | MECHANICAL FEED   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -         | -                      |
|   | 2266218-5   | A                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1             | -         | 8-2266218-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2266218-4 | -         | -         |                        |
|   | 2266218-6   | A                        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | -                 | -                     | -         | -           | -         | -         | -                      |
| 2266218-7                                     | A           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                 | -                 | -                     | -         | -           | -         | -         | -                      |
| 7-2266218-7                                   | A           | CRIMP TOOLING KIT        | -                        | -                 | -                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.40 mm [.055] | F    |
| INSUL           | 1.78 mm [.070] | F    |

APPLICATOR INSTRUCTIONS 408-10389

| TERMINAL DATA: MOLEX TERMINAL                   |                | MOLEX CRIMP SPECIFICATION    |                |
|---|----------------|------------------------------|----------------|
| TERMINAL NAME: 2.5 LOW PROFILE CRIMP RECEPTACLE |                |                              |                |
| WIRE STRIP LENGTH                               |                | INSULATION DIAMETER RANGE    |                |
| 2.40-2.90 mm [.094-.114 IN]                     |                | Ø1.40-1.60 mm [.055-.063 IN] |                |
| TERMINAL APPLICATION SPECIFICATION              | MOLEX SPEC     |                              |                |
| TERMINALS APPLIED                               |                |                              |                |
| TE TERMINAL                                     | MOLEX TERMINAL | TE TERMINAL                  | MOLEX TERMINAL |
| 1572313-1                                       | 08701039       | 1572313-5                    | 456270002      |
| 1572313-2                                       | 08701045       | 1572313-6                    | 456271002      |
| 1572313-3                                       | 39000160       | 1572313-7                    | 08701047       |
| 1572313-4                                       | 98000242       |                              |                |

| TERMINAL DATA: MOLEX TERMINAL                   |                | MOLEX CRIMP SPECIFICATION    |                |
|---|----------------|------------------------------|----------------|
| TERMINAL NAME: 2.5 LOW PROFILE CRIMP RECEPTACLE |                |                              |                |
| WIRE STRIP LENGTH                               |                | INSULATION DIAMETER RANGE    |                |
| 2.40-2.90 mm [.094-.114 IN]                     |                | Ø1.40-1.60 mm [.055-.063 IN] |                |
| TERMINAL APPLICATION SPECIFICATION              | MOLEX SPEC     | ATS 639023100                |                |
|   | REV.C          |                              |                |
| TERMINALS APPLIED                               |                |                              |                |
| TE TERMINAL                                     | MOLEX TERMINAL | TE TERMINAL                  | MOLEX TERMINAL |
| 1572313-5                                       | 456270002      | 1572313-6                    | 456271002      |

| WIRE SIZE         | CRIMP HEIGHT mm [INCH]       | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|------------------------------|--------------------------------|
| 22 AWG OR 0.35mm2 | 0.725+/-0.035 [.029+/-0.001] | 9.8                            |
| 24 AWG OR 0.20mm2 | 0.665+/-0.035 [.026+/-0.001] | 10.4                           |
| 26 AWG OR 0.12mm2 | 0.62+/-0.03 [.024+/-0.001]   | 10.8                           |
| 28 AWG OR 0.08mm2 | 0.60+/-0.03 [.024+/-0.001]   | 11.0                           |

| WIRE SIZE         | CRIMP HEIGHT mm [INCH]       | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|------------------------------|--------------------------------|
| 22 AWG OR 0.35mm2 | 0.725+/-0.035 [.029+/-0.001] | 7.2                            |
| 24 AWG OR 0.20mm2 | 0.665+/-0.035 [.026+/-0.001] | 7.7                            |

- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
- 3 LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266218-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266218-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266218-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266218-6
- 5 ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62,180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37,180 & 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 5.08.

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

| -77 | -7 | -6 | -5 | -2 | -1 | PART NO   | DESCRIPTION                     | ITEM NO |
|-----|----|----|----|----|----|-----------|---------------------------------|---------|
| -   | -  | 1  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| -   | 1  | -  | 1  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252     |
| -   | -  | -  | -  | 1  | -  | 2119640-1 | PUSH ROD, AIR FEED              | 250     |
| -   | -  | -  | -  | 1  | -  | 2079988-1 | BUSHING, LCH5-12, MISUMI        | 249     |
| -   | -  | -  | -  | 1  | -  | 2119641-1 | FEED CAM, AIR FEED              | 248     |

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

| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |           |     |      |
|--------------|-----|------|-----------|-----|-------------|-----------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE      | OWN | APVD |
|              |     |      | A         |     | RELEASE     | 14MAR2014 | XZ  | GB   |

|   |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | -   | 1   | 1   | 1   | 2119798-1   | DETENT PIN                          | 247 |
| - | 1   | -   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| - | -   | 1   | -   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| - | 1   | 1   | 1   | 1   | 1   | 2119082-4   | 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 |
| - | -   | 1   | 1   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213 |
| - | -   | 1   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      | 198 |
| - | 1   | 1   | 1   | 1   | 1   | 1-1752354-5 | STANDOFF, HOLD-DOWN                 | 180 |
| - | 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 |
| - | 1   | 1   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166 |
| - | REF | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | -   | -   | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163 |
| - | -   | -   | -   | 1   | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137 |
| - | -   | -   | -   | 1   | -   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136 |
| - | -   | REF | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135 |
| - | -   | 1   | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133 |
| - | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117 |
| - | 1   | 1   | 1   | 1   | 1   | 1-455888-2  | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | -   | -   | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| - | 2   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | 1   | -   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |
| - | 3   | -   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62  |
| - | 1   | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60  |
| - | -   | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | -   | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54  |
| - | 1   | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52  |
| - | 1   | 1   | 1   | 1   | 1   | 1-1901681-3 | 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   | 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   | 1-2119644-4 | 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   | 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   | 1320908-6   | SPACER, STRIP GUIDE                 | 30  |
| - | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | 1   | 1   | 1   | 2119533-3   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 1   | 1   | 1   | 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   | 1803095-1   | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 1   | 1-1633139-9 | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 2-238011-0  | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 1   | 1-1633962-9 | CRIMPER, INSULATION F PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1   | 1   | 1   | 2-456402-9  | CRIMPER, WIRE PREMIUM               | 1   |

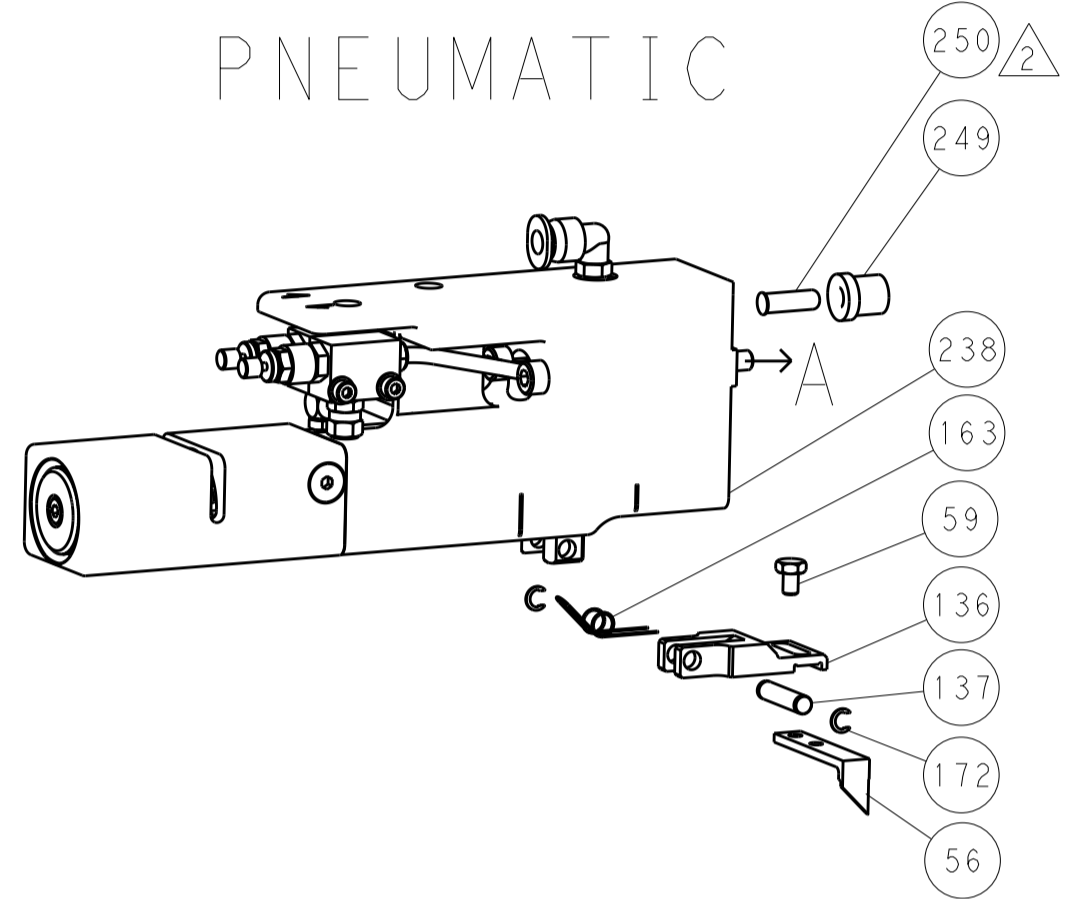
| DIMENSIONS: |               | TOLERANCES UNLESS OTHERWISE SPECIFIED: |            | DWG        |            | CHK        |            | APVD       |            | NAME       |             |
|-------------|---------------|--|------------|------------|------------|------------|------------|------------|------------|------------|-------------|
| mm          | 0 PLC ±.05    | 1 PLC ±.05                             | 2 PLC ±.05 | 3 PLC ±.05 | 4 PLC ±.05 | 5 PLC ±.05 | 6 PLC ±.05 | 7 PLC ±.05 | 8 PLC ±.05 | 9 PLC ±.05 | 10 PLC ±.05 |
|             | ANGLES ±.0001 |  |            |            |            |            |            |            |            |            |             |
| MATERIAL    | FINISH        | WEIGHT                                 | SCALE      | SHEET      | OF         | REV        |            |            |            |            |             |
|             |               |  | 1:2        | 1          | 4          | A          | 00779      | 2266218    |            |            |             |

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

### FEED TYPE MECHANICAL



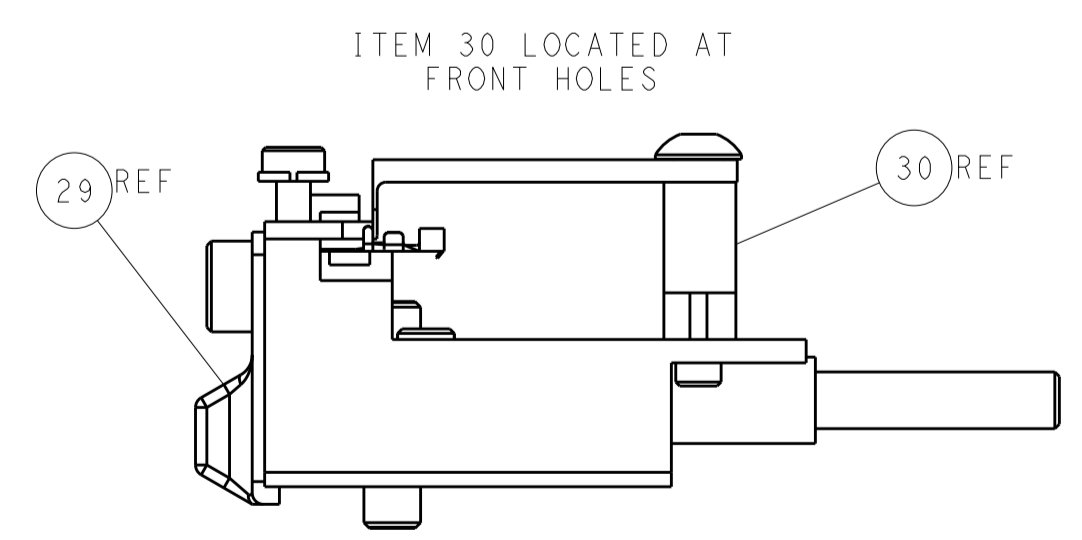
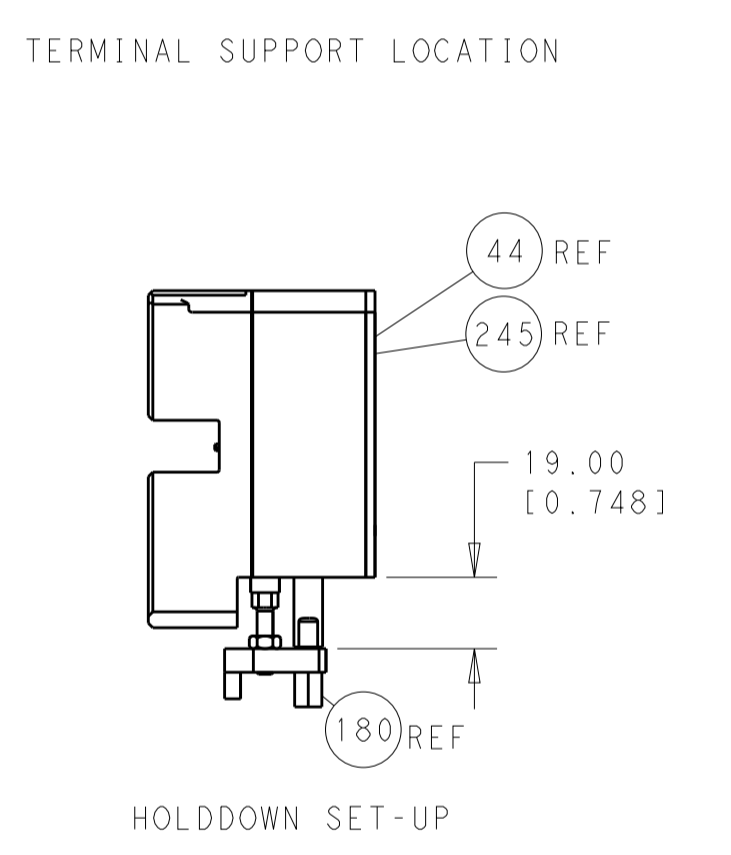
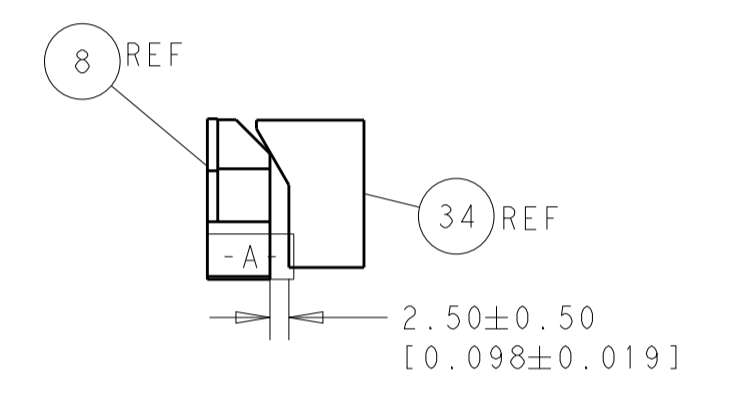
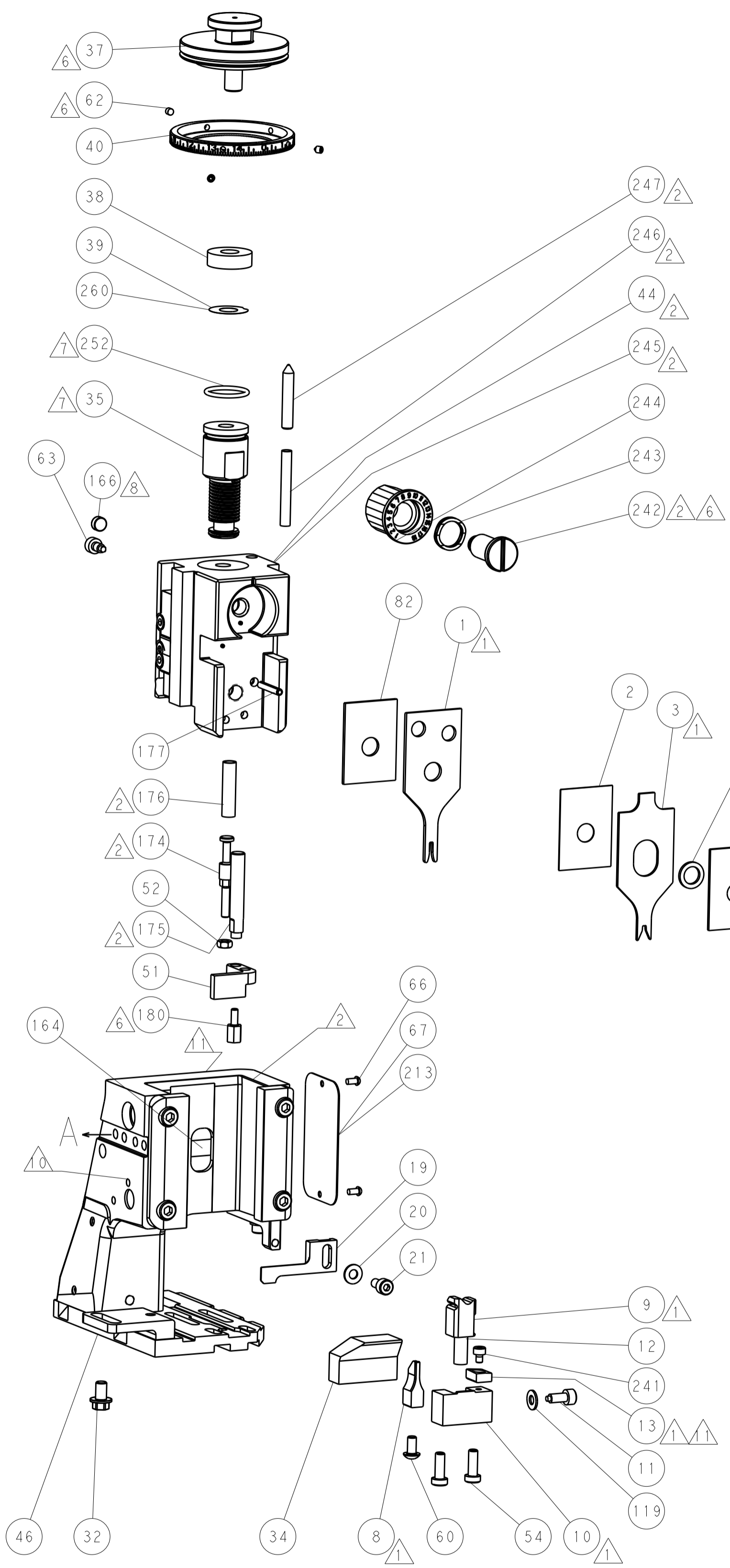
### PNEUMATIC



### 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: |              | DWG: X.ZHAO 21FEB2014                  |                        | TE Connectivity                                  |  |
| mm          | 0 PLC ±0.5 | 1 PLC ±0.13                            | 3 PLC ±0.013 | 4 PLC ±0.0001                          | CHK: L.ZHANG 21FEB2014 | Harrisburg, PA 17105-3608                        |  |
| MATERIAL:   |            | FINISH:                                |              | APVD: T.FLRIN 21FEB2014                |                        | NAME: Ocean Side Feed Applicator                 |  |
|             |            |  |              | WEIGHT:                                |                        | SIZE: CAGE CODE: DRAWING NO: A11 00779 ©=2266218 |  |
|             |            |  |              | Customer Accessible Production Drawing |                        | SCALE: 1:2 SHEET 2 OF 4 REV A                    |  |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|  |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|  | 2-2266218-1 | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266218-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266218-4 | -         | -         |                        |
|  | 2-2266218-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266218-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266218-4 | -         | -         |                        |
|  | 2-2266218-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  | 2-2266218-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -         | -                      |
|  | 7-2266218-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.40 mm [.055] | F    |
| INSUL                                | 1.78 mm [.070] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: MOLEX TERMINAL                   |                | MOLEX CRIMP SPECIFICATION    |                |
|---|----------------|------------------------------|----------------|
| TERMINAL NAME: 2.5 LOW PROFILE CRIMP RECEPTACLE |                |                              |                |
| WIRE STRIP LENGTH                               |                | INSULATION DIAMETER RANGE    |                |
| 2.40-2.90 mm [.094-.114 IN]                     |                | Ø1.40-1.60 mm [.055-.063 IN] |                |
| TERMINAL APPLICATION SPECIFICATION              | MOLEX SPEC     | -                            | -              |
| TERMINALS APPLIED                               |                |                              |                |
| TE TERMINAL                                     | MOLEX TERMINAL | TE TERMINAL                  | MOLEX TERMINAL |
| 1572313-1                                       | 08701039       | 1572313-4                    | 98000242       |
| 1572313-2                                       | 08701045       | 1572313-7                    | 08701047       |
| 1572313-3                                       | 39000160       |                              |                |

| TERMINAL DATA: MOLEX TERMINAL                   |                | MOLEX CRIMP SPECIFICATION    |                |
|---|----------------|------------------------------|----------------|
| TERMINAL NAME: 2.5 LOW PROFILE CRIMP RECEPTACLE |                |                              |                |
| WIRE STRIP LENGTH                               |                | INSULATION DIAMETER RANGE    |                |
| 2.40-2.90 mm [.094-.114 IN]                     |                | Ø1.40-1.60 mm [.055-.063 IN] |                |
| TERMINAL APPLICATION SPECIFICATION              | MOLEX SPEC     | ATS 639023100                | -              |
|   | REV.C          | -                            | -              |
| TERMINALS APPLIED                               |                |                              |                |
| TE TERMINAL                                     | MOLEX TERMINAL | TE TERMINAL                  | MOLEX TERMINAL |
| 1572313-5                                       | 456270002      | 1572313-6                    | 456271002      |

| WIRE SIZE         | CRIMP HEIGHT mm [INCH]       | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|------------------------------|--------------------------------|
| 22 AWG OR 0.35mm2 | 0.725+/-0.035 [.029+/-0.001] | 7.2                            |
| 24 AWG OR 0.20mm2 | 0.665+/-0.035 [.026+/-0.001] | 7.7                            |
| 26 AWG OR 0.12mm2 | 0.62+/-0.03 [.024+/-0.001]   | 8.4                            |
| 28 AWG OR 0.08mm2 | 0.60+/-0.03 [.024+/-0.001]   | 8.6                            |

| WIRE SIZE         | CRIMP HEIGHT mm [INCH]       | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|------------------------------|--------------------------------|
| 22 AWG OR 0.35mm2 | 0.725+/-0.035 [.029+/-0.001] | 7.2                            |
| 24 AWG OR 0.20mm2 | 0.665+/-0.035 [.026+/-0.001] | 7.7                            |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266218-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266218-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266218-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62,180 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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

|     |     |     |     |     |           |                                     |         |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 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     |
| -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   | 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     |
| -   | 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     |
| -   | 1   | 1   | 1   | 1   | 1-1752354-5 | STANDOFF, HOLD-DOWN                 | 180     |
| -   | 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     |
| -   | 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     |
| -   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
| -   | -   | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 1-455888-2  | 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   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62      |
| -   | -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | -   | -   | -   | 1   | 1338685-1   | PAWL, FEED                          | 56      |
| -   | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52      |
| -   | 1   | 1   | 1   | 1   | 1-1901681-3 | HOLDDOWN, TERMINAL                  | 51      |
| -   | -   | -   | -   | 1   | 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   | 1320908-6   | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29      |
| -   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| -   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21      |
| -   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -   | 1   | 1   | 1   | 1   | 2119533-3   | STRIPPER, SIDE FEED                 | 19      |
| -   | 1   | 1   | 1   | 1   | 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   | 1803095-1   | FLOATING SHEAR, FRONT               | 9       |
| -   | 1   | 1   | 1   | 1   | 1-1633139-9 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 2-238011-0  | BLOCK, CRIMPER SPACER               | 4       |
| -   | 1   | 1   | 1   | 1   | 1-1633962-9 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 2       |
| -   | 1   | 1   | 1   | 1   | 2-456402-9  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -27 | -25 | -22 | -21 | PART NO     | DESCRIPTION                         | ITEM NO |

| DIMENSIONS:                            |           | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DRAWING NO   |              | RESTRICTED TO |        |
|--|-----------|--|-------------|--------------|--------------|---------------|--------|
| mm                                     | 0 PLC ±.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 | ANGLES ±.001  | FINISH |
| MATERIAL                               |           |  |             | WEIGHT       | SCALE        | SHEET         | REV    |
| Customer Accessible Production Drawing |           |  |             | SCALE        | 1:2          | SHEET 3 OF 4  | REV A  |

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

# FEED TYPE MECHANICAL



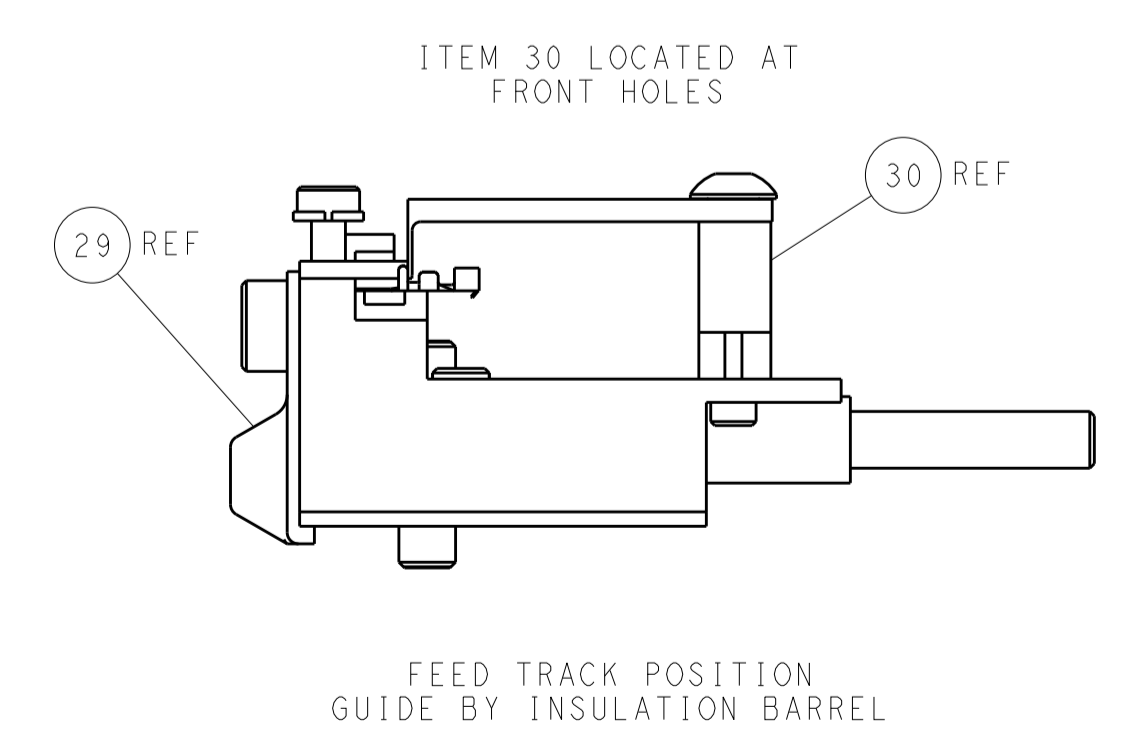
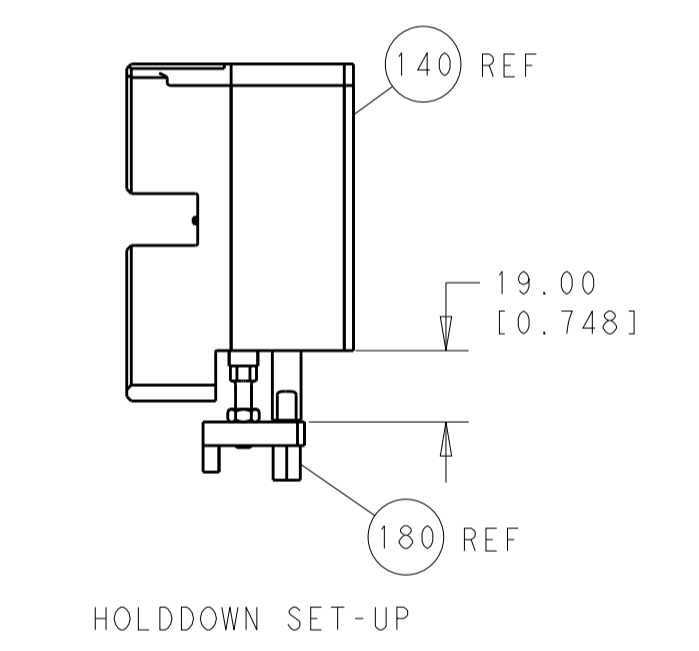
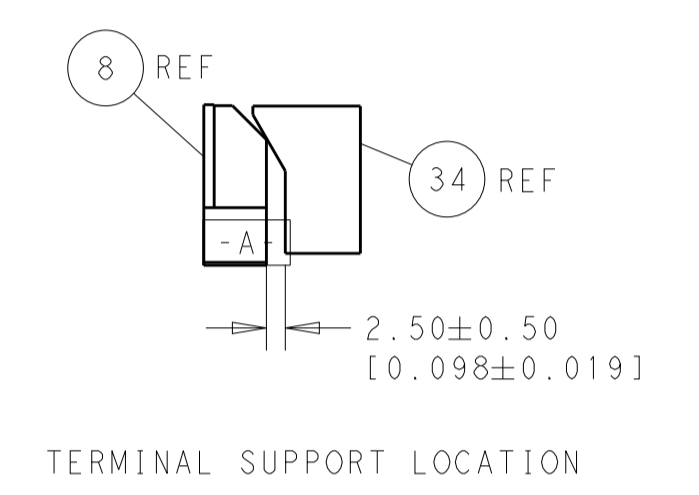
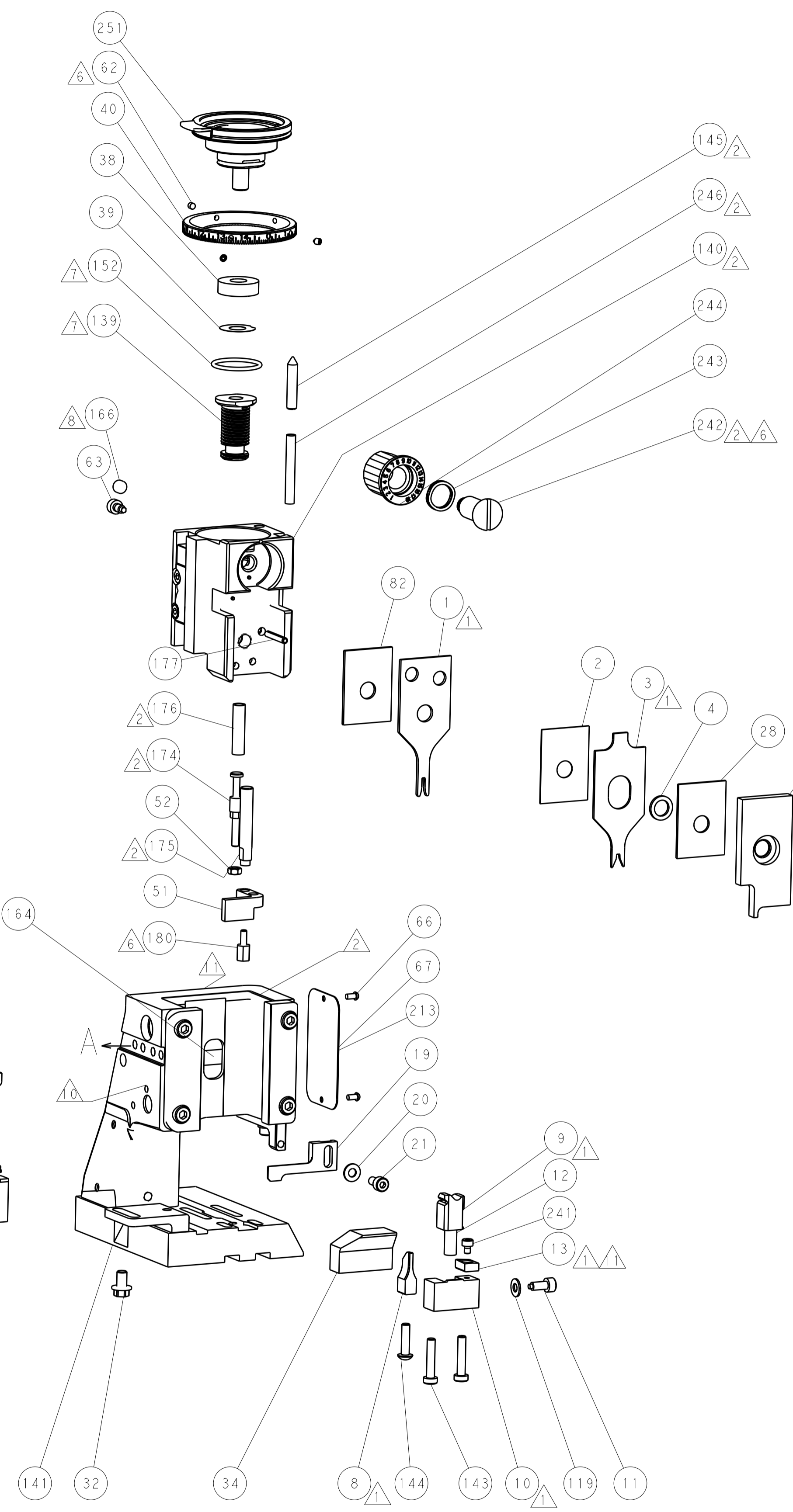
# PNEUMATIC



# 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)

|   |  |  |   |   |
|---|--|--|---|---|
| <small>THE DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE BUYER'S RESPONSIBILITY TO CONTACT THE SUPPLIER FOR THE LATEST REVISIONS. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE BUYER'S RESPONSIBILITY TO CONTACT THE SUPPLIER FOR THE LATEST REVISIONS.</small> |  | DWN: X.ZHAO 21FEB2014<br>CHK: L.ZHANG 21FEB2014<br>APVD: T.ELBIN 21FEB2014 | NAME: Ocean Side Feed Applicator<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2266218 | RESTRICTED TO: -<br>SCALE: 1:2<br>SHEET: 4 of 4<br>REV: A |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±0.5<br>1 PLC ±0.13<br>2 PLC ±0.013<br>3 PLC ±0.001<br>4 PLC ±0.001<br>ANGLES ±0.001  |  | PRODUCT SPEC: -<br>APPLICATION SPEC: -<br>WEIGHT: -                        | CUSTOMER ACCESSIBLE PRODUCTION DRAWING  |   |