

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2266026-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | 2266026-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | - | 8-2266026-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266026-4 | - | - | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| | 2266026-5 | B | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | SERVO LATCH PLATE | 2119951-1 | - | 8-2266026-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2266026-4 | - | - | |
| | 2266026-6 | B | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | 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 | |
| 2266026-7 | B | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2266026-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

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

APPLICATOR INSTRUCTIONS 408-10389

| TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION | | | |
|---|-------------------|------------------------------|-------------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.00-4.50 mm [.157-.177 IN] | | Ø1.00-1.50 mm [.039-.060 IN] | |
| TERMINAL APPLICATION SPECIFICATION | NONE | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | SUMITOMO TERMINAL | TE TERMINAL | SUMITOMO TERMINAL |
| 2113372-1 | 8100-4029 | | |

| TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION | | | |
|---|-------------------|------------------------------|-------------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.00-4.50mm [.157-.177 IN] | | Ø1.00-1.50 mm [.039-.060 IN] | |
| TERMINAL APPLICATION SPECIFICATION | NONE | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | SUMITOMO TERMINAL | TE TERMINAL | SUMITOMO TERMINAL |
| 1832368-2 | 8100-4028 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|---------------|----------------------------|--------------------------------|
| AVSS 0.30mm2 | 0.80+/-0.05 [.031+/- .002] | 5.9 |
| CHFUS 0.35mm2 | 0.75+/-0.05 [.030+/- .002] | 6.5 |
| CHFUS 0.22mm2 | 0.70+/-0.05 [.028+/- .002] | 7.0 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|---------------|----------------------------|--------------------------------|
| AVSS 0.30mm2 | 1.00+/-0.05 [.039+/- .002] | 5.9 |
| CHFUS 0.35mm2 | 0.95+/-0.05 [.037+/- .002] | 6.5 |
| CHFUS 0.22mm2 | 0.90+/-0.05 [.035+/- .002] | 7.0 |

- 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: 8-2266026-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266026-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266026-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266026-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- ⁶ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62. 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.
- 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 5.00.

***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 |
|---------------|-----|----|----|----|----|----|-----------|---------------------------------|---------|
| ¹² | - | - | 1 | - | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 |
| ¹¹ | - | 1 | - | 1 | 1 | 1 | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252 |

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

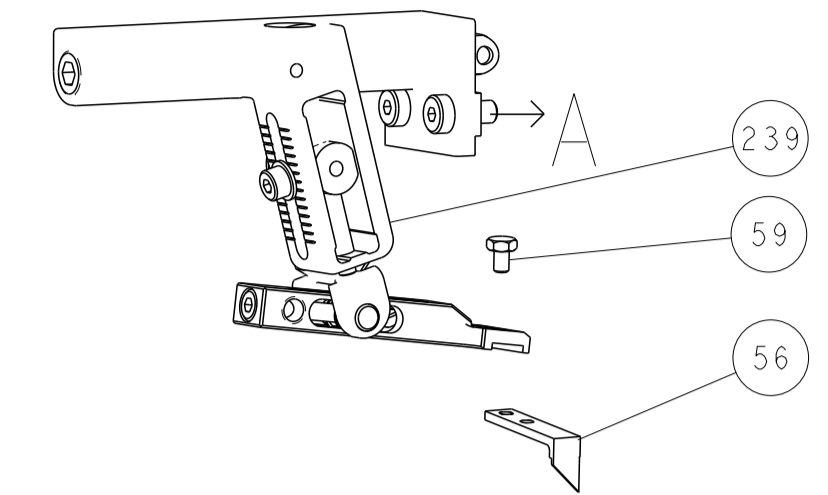
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|---------------|-----------|--------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPV |
| | | | B | ECR-15-018565 | 22DEC2015 | MR JDG |

| | | | | | | | | |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | - | - | - | 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 | 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 |
| - | 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 | 455888-4 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | 1 | - | - | 1 | 1 | 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 |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 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 | 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 | 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 | 1320908-6 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 1 | 1 | 1 | 2119533-1 | 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 | 4-1633932-0 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 1 | 240641-9 | SPACER | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2119757-5 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 238011-7 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1633961-2 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-4 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 1-456402-8 | CRIMPER, WIRE PREMIUM | 1 |

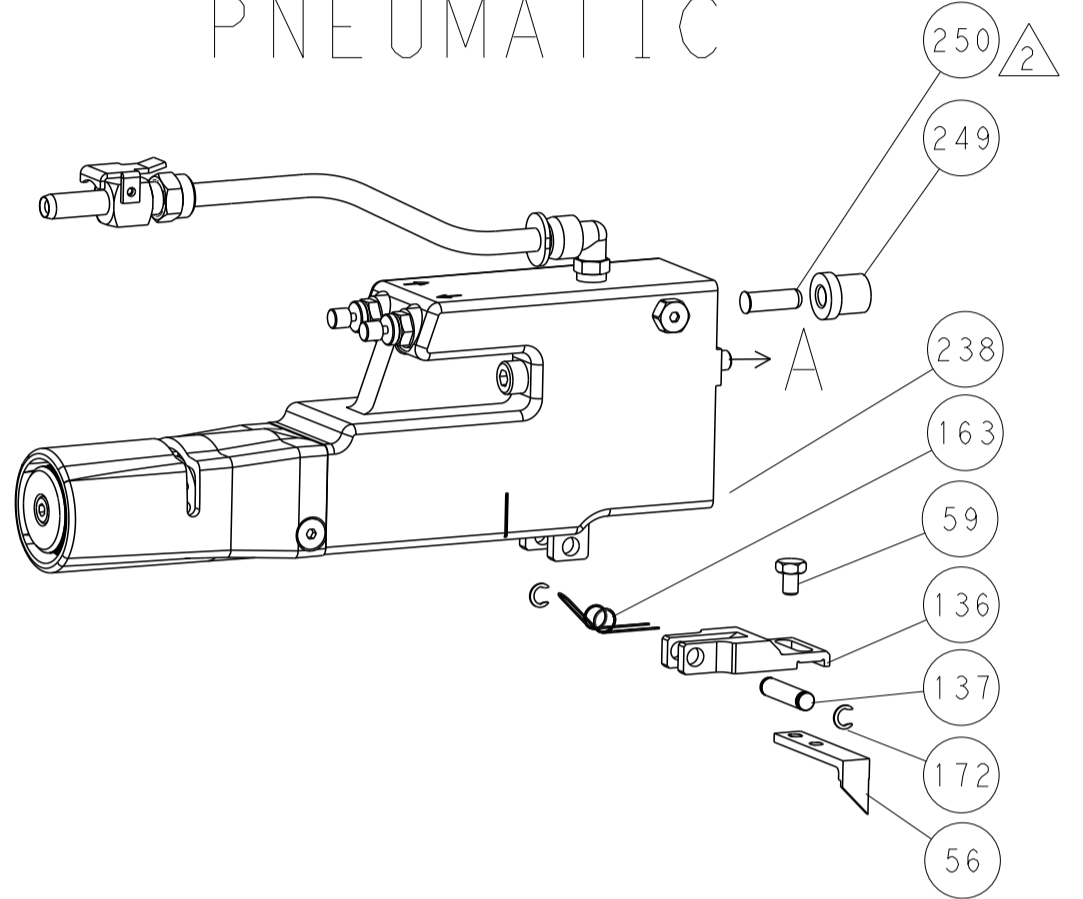
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: | |
|-------------|---------|--|---------|-----------|---------|---------|--------|---------|--|--|------------------------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH | | | Customer Accessible Production Drawing | SCALE 1:2 SHEET 1 OF 4 REV B |

| LOC | DIST | REV | DESCRIPTION | DATE | DWN | APVD |
|-----|------|-----|------------------|------|-----|------|
| | | 1 | rev_sym_1 desc_1 | | | |
| | | 2 | rev_sym_2 desc_2 | | | |
| | | 3 | rev_sym_3 desc_3 | | | |
| | | 4 | rev_sym_4 desc_4 | | | |

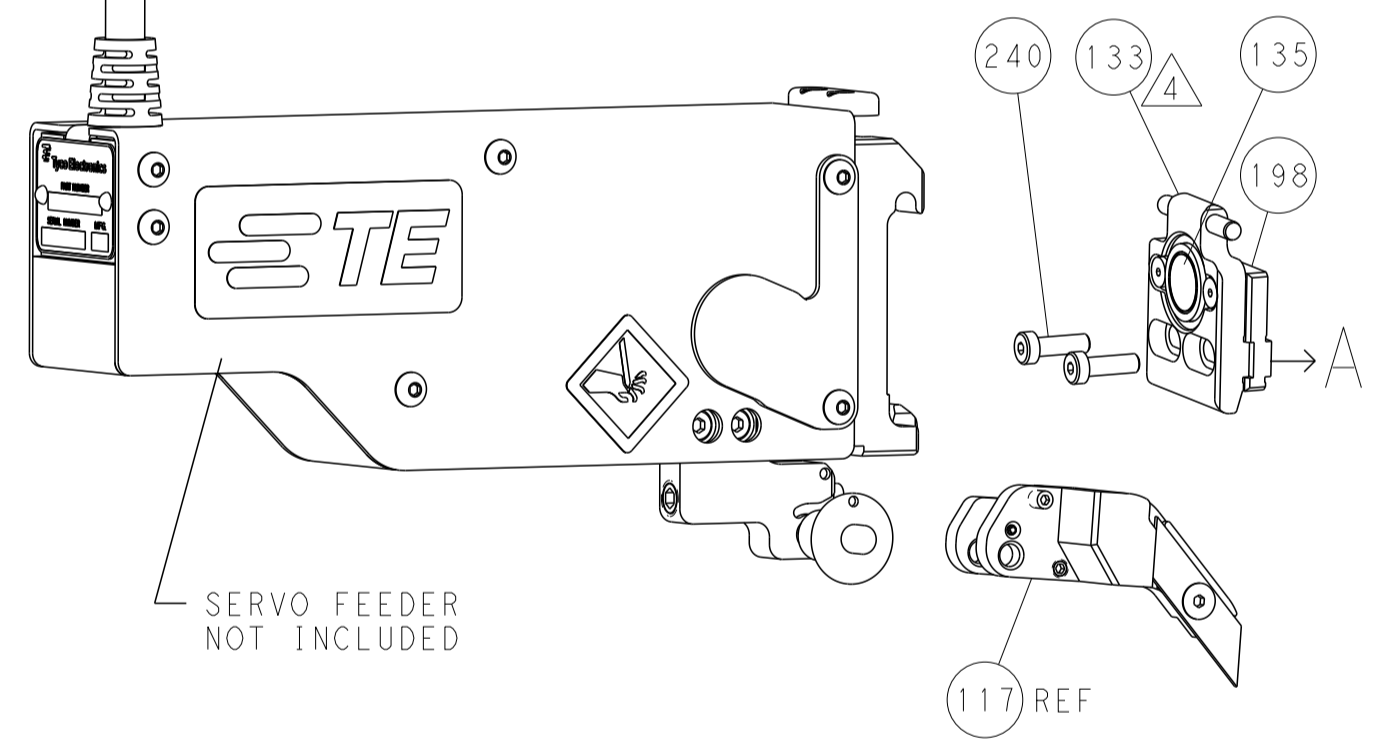
FEED TYPE MECHANICAL



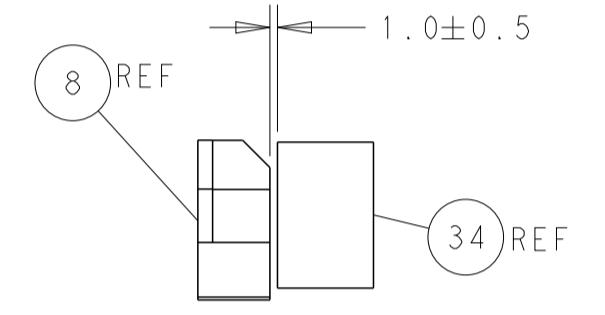
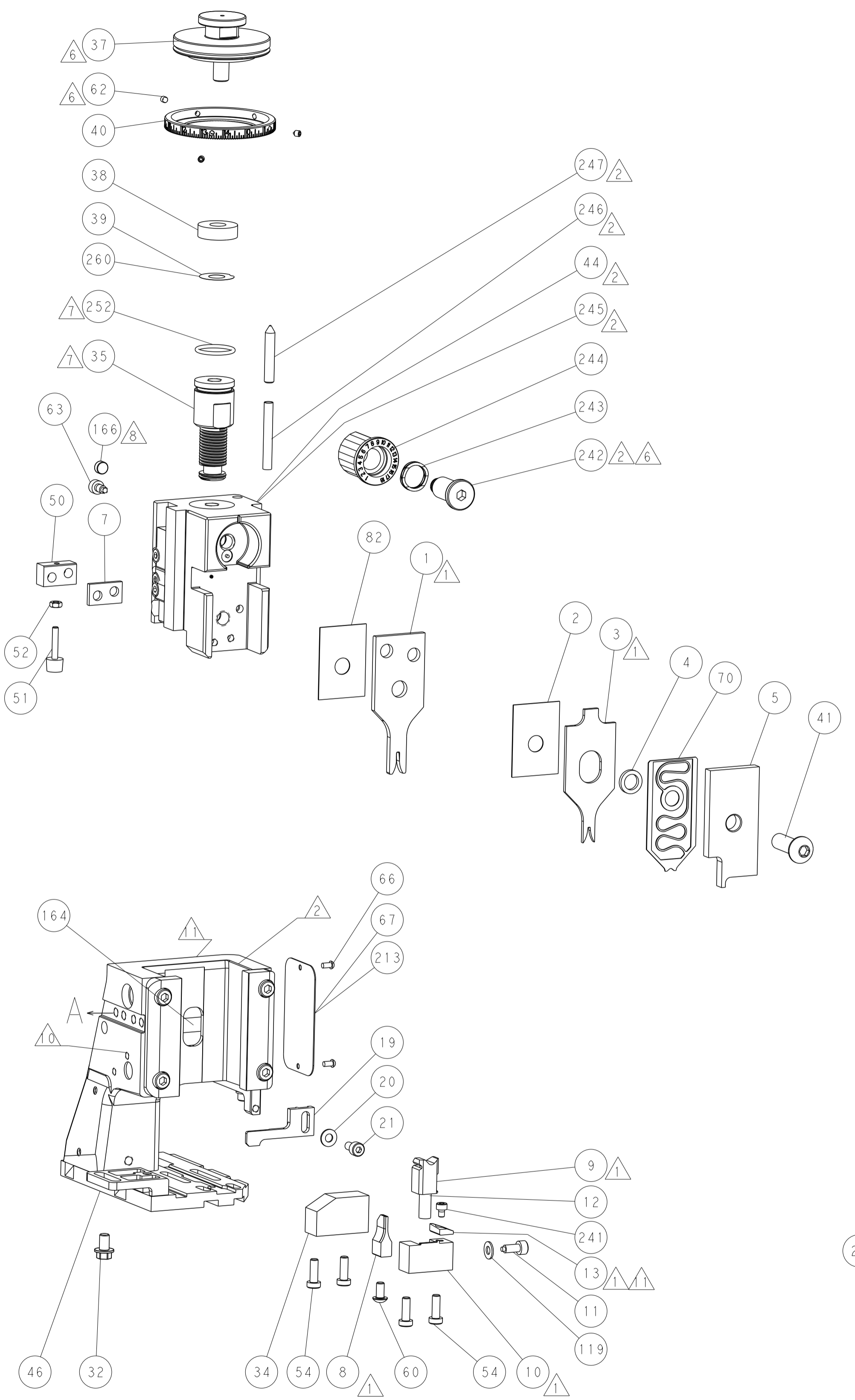
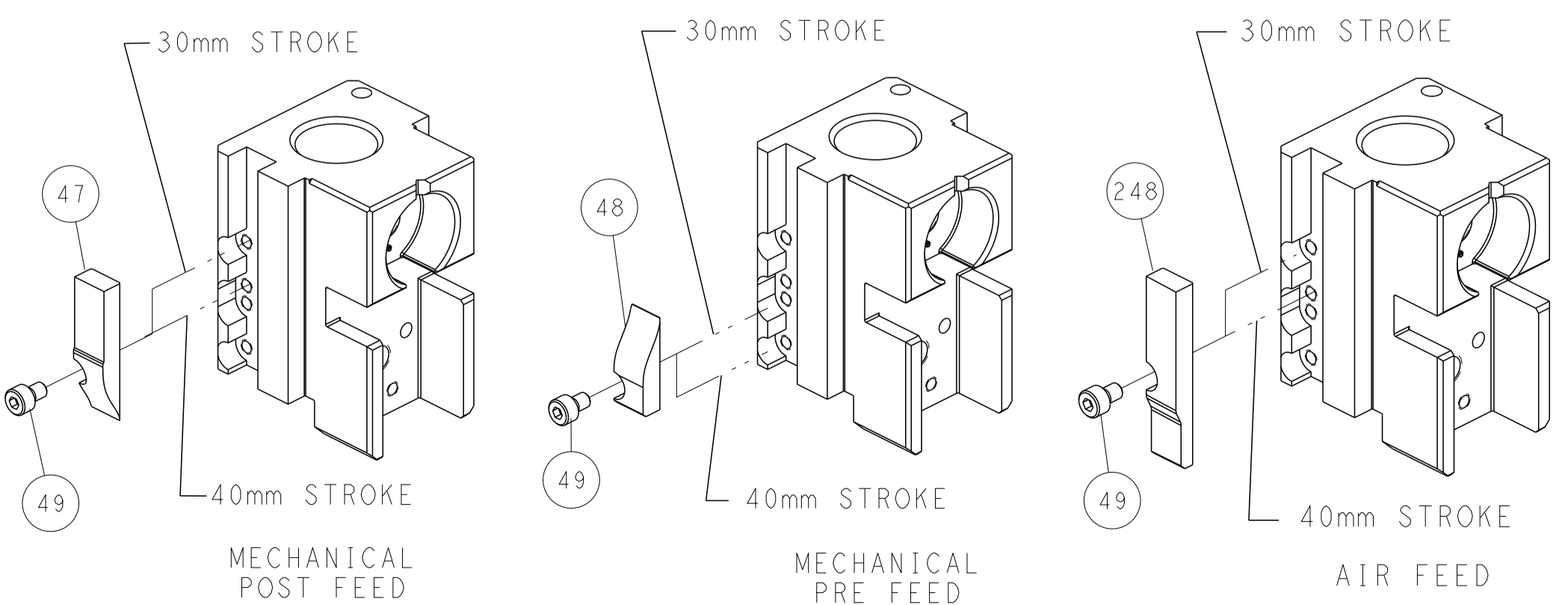
PNEUMATIC



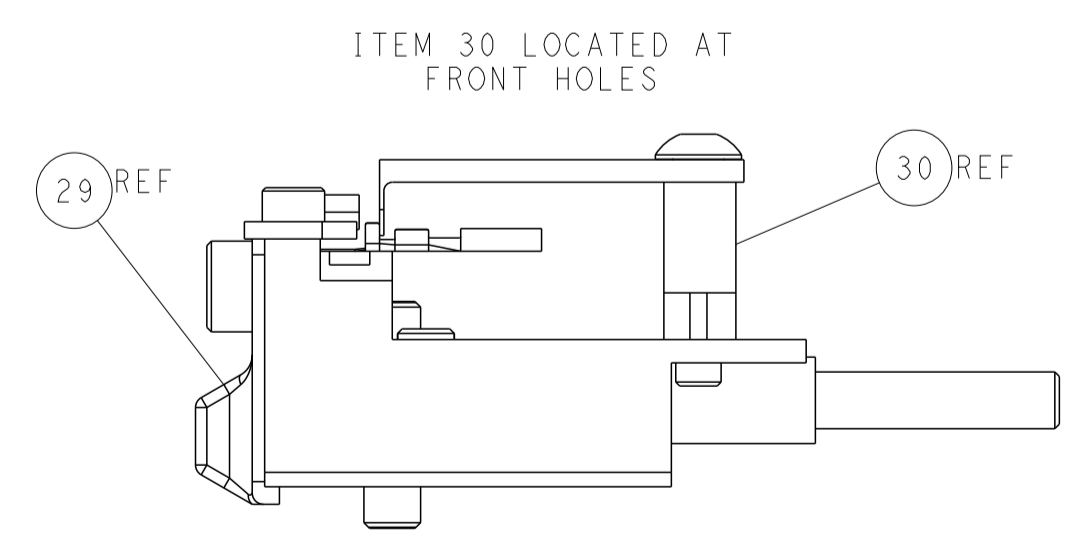
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT FRONT HOLES
 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: | | DWN | C. CHEN | 26AUG2013 | STE |
| mm | | 0 PLC ± | | CHK | U. GUO | 26AUG2013 | |
| MATERIAL: | | FINISH: | | APVD | J. CRUZ | 26AUG2013 | NAME Ocean Side Feed Applicator |
| | | | | PRODUCT SPEC | | | |
| | | | | APPLICATION SPEC | | | SIZE CAGE CODE DRAWING NO Ac 100 1790 2266026 |
| | | | | RESTRICTED TO | | | |
| | | | | WEIGHT | | | Customer Accessible Production Drawing |
| | | | | SCALE | 1:2 | SHEET 2 OF 4 | |

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

APPLICATOR STYLE CONVERSION CHART table with columns for CONVERT TO, PART NUMBERS REQUIRED, FEED TYPE, and DESCRIPTION.

APPLICATOR DATA table including CRIMP SIZE TYPE, WIRE INSUL dimensions, and APPLICATOR INSTRUCTIONS.

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION table with columns for WIRE STRIP LENGTH and INSULATION DIAMETER RANGE.

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION table with columns for WIRE STRIP LENGTH and INSULATION DIAMETER RANGE.

WIRE SIZE table with columns for CRIMP HEIGHT mm [INCH] and CRIMP HEIGHT REFERENCE SETTING.

WIRE SIZE table with columns for CRIMP HEIGHT mm [INCH] and CRIMP HEIGHT REFERENCE SETTING.

- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

*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)

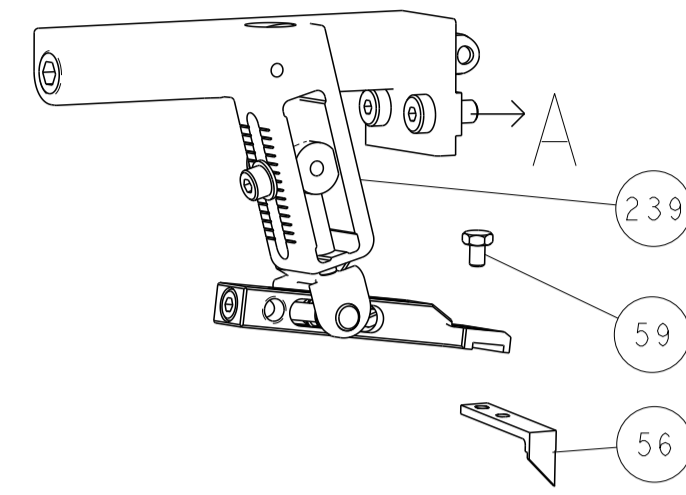
REVISIONS table with columns for P, LTR, DESCRIPTION, DATE, DWG, APPR.

Large parts list table with columns for PART NO, DESCRIPTION, ITEM NO, and various identifiers.

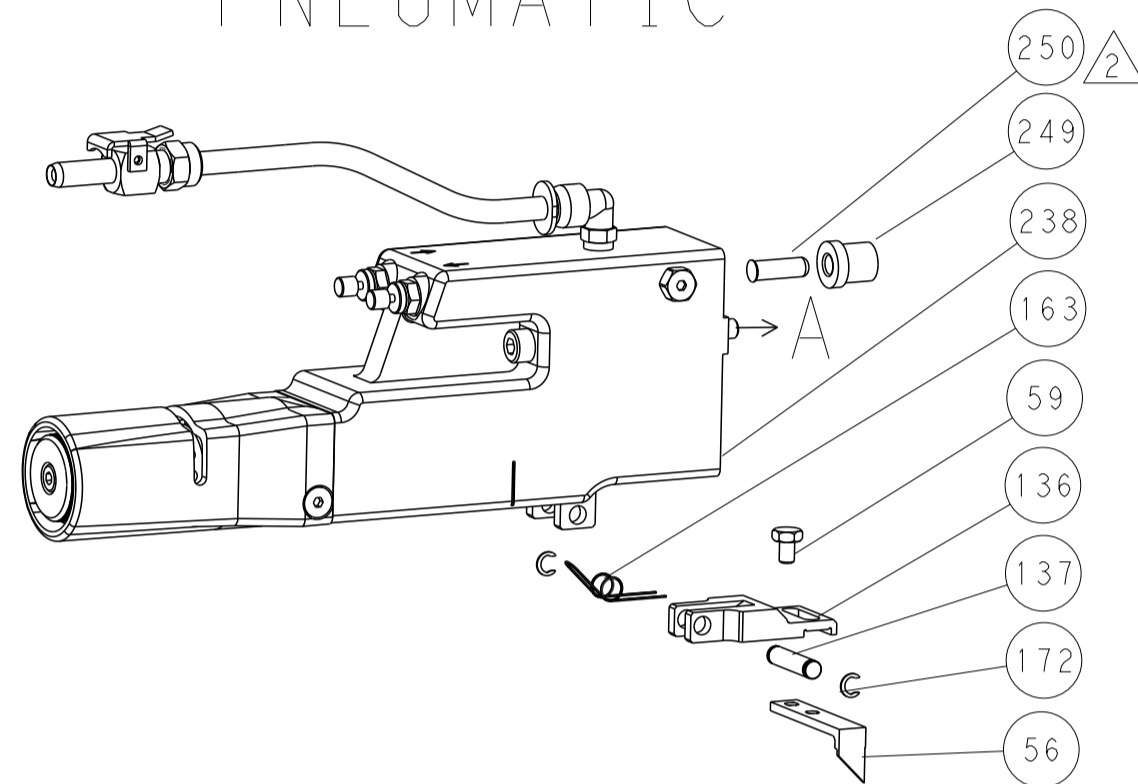
Customer Accessible Production Drawing table including dimensions, tolerances, material, weight, and scale.

| LOC | DIST | REVISIONS | | | |
|-----------|------------|-------------|------|------------|------------|
| P | LTM | DESCRIPTION | DATE | DWN | APVD |
| rev_sym_1 | 1866 | 8H6E111 | | rev_defect | dmv_bppr_1 |
| rev_sym_2 | rev_desc_2 | | | rev_defect | dmv_bppr_2 |
| rev_sym_3 | rev_desc_3 | | | rev_defect | dmv_bppr_3 |
| rev_sym_4 | rev_desc_4 | | | rev_defect | dmv_bppr_4 |

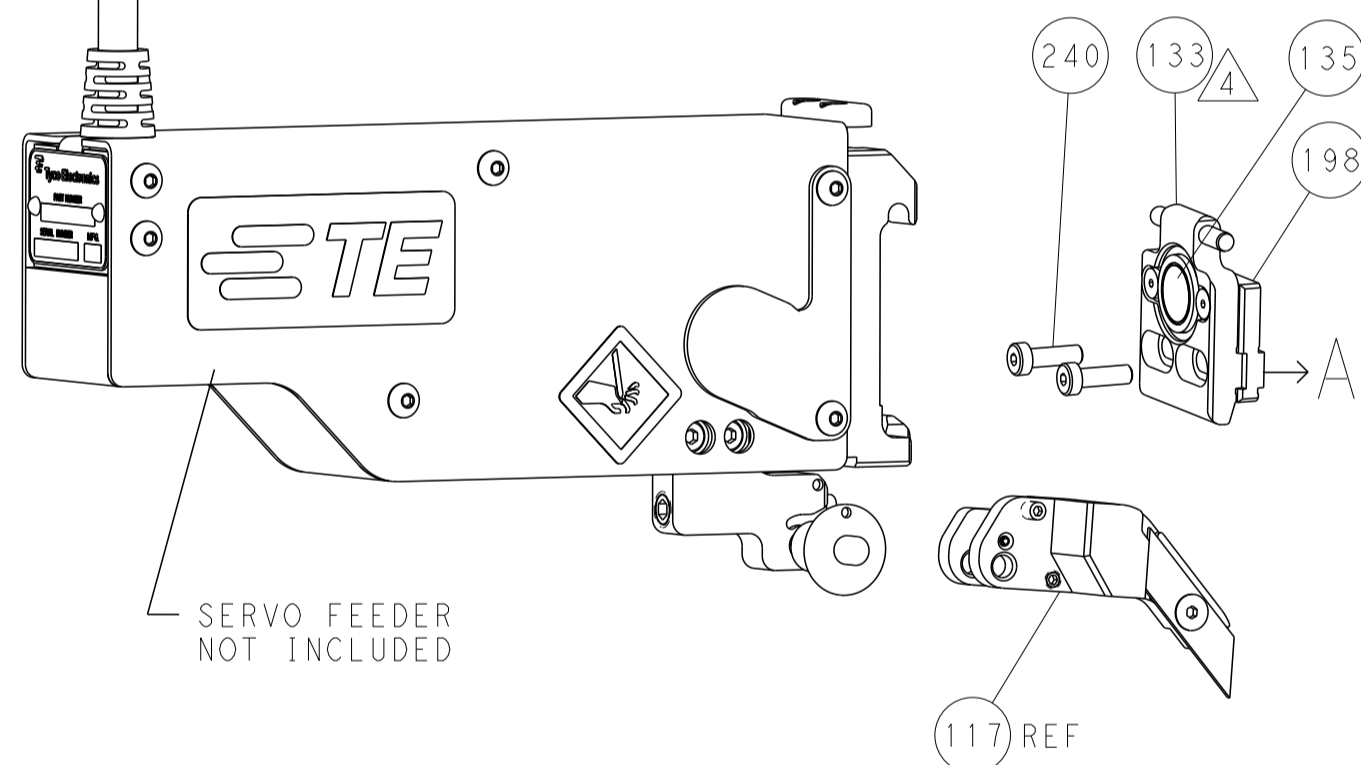
FEED TYPE MECHANICAL



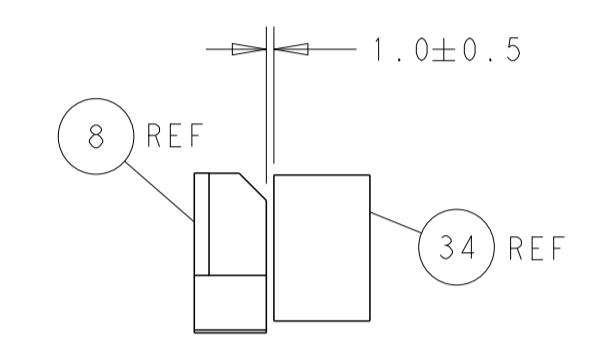
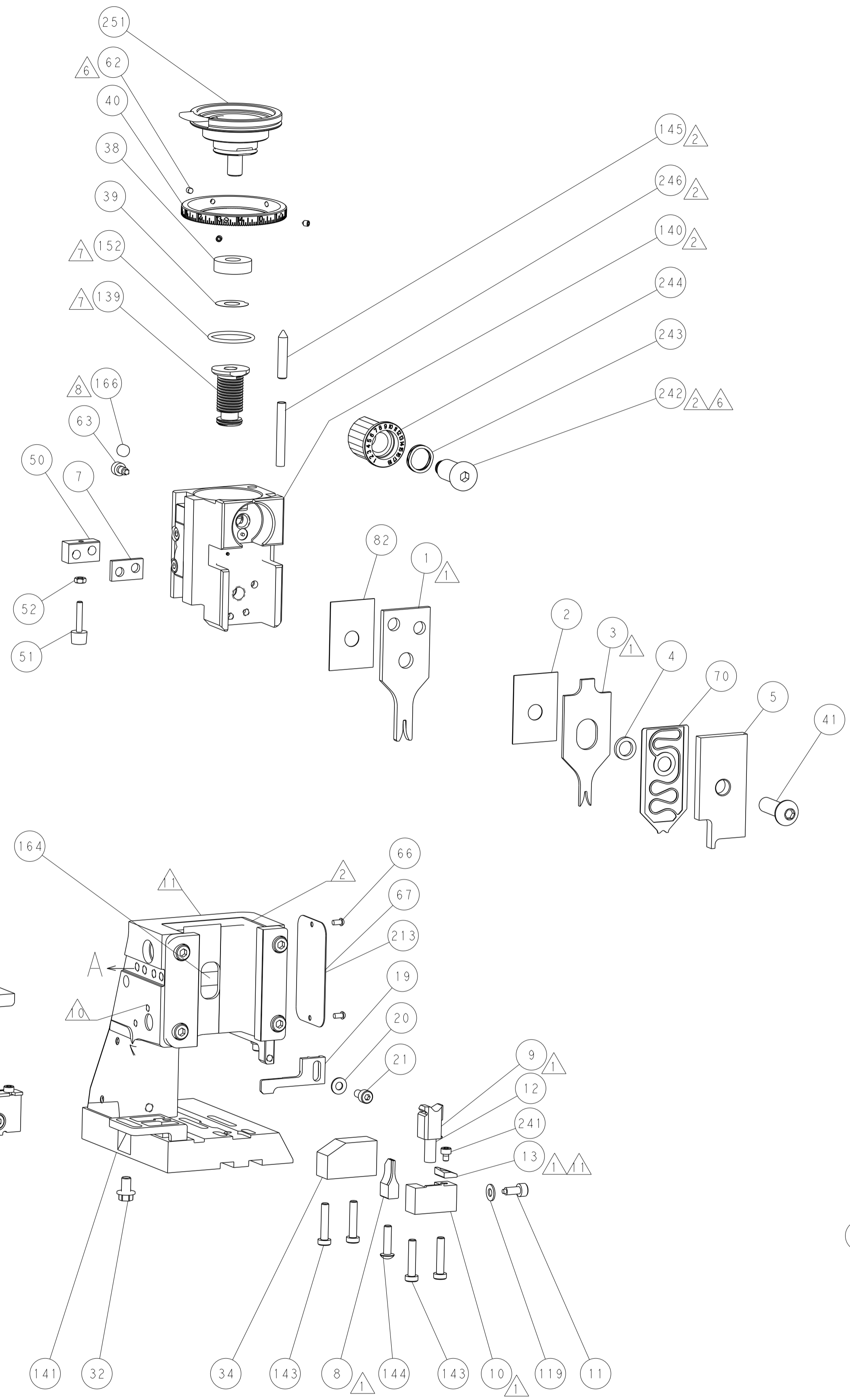
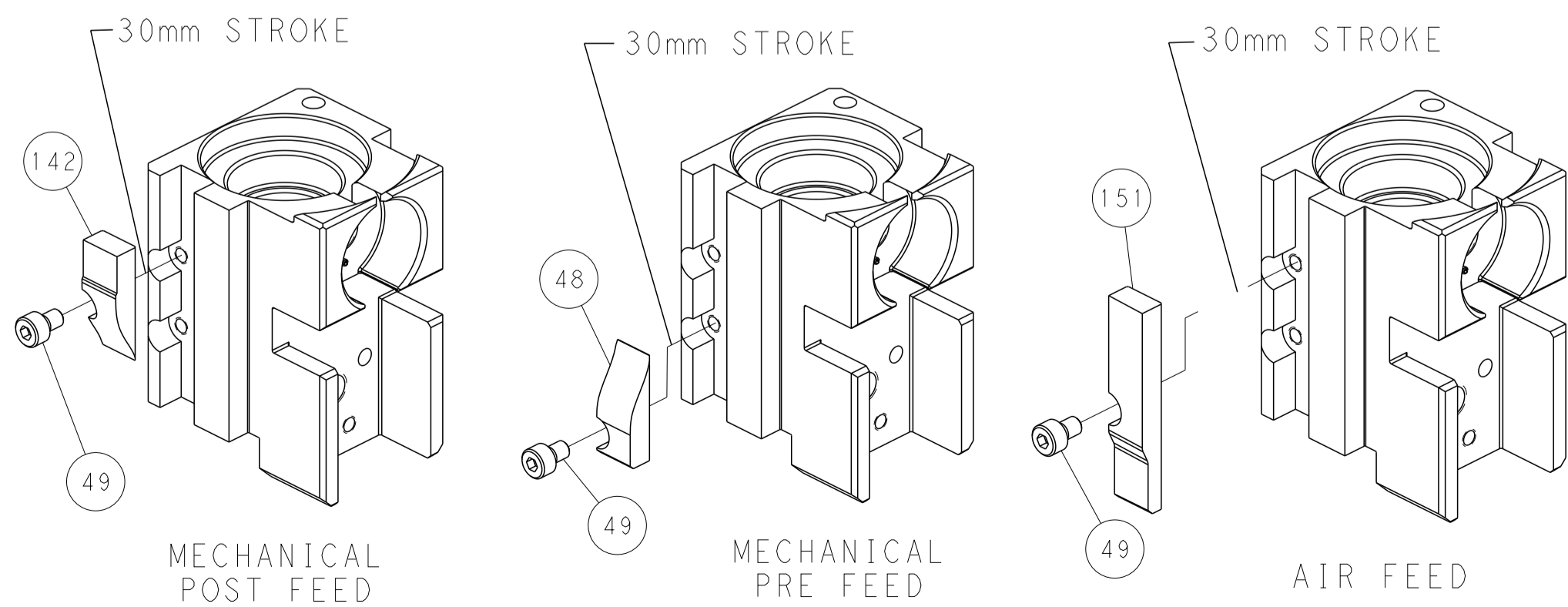
PNEUMATIC



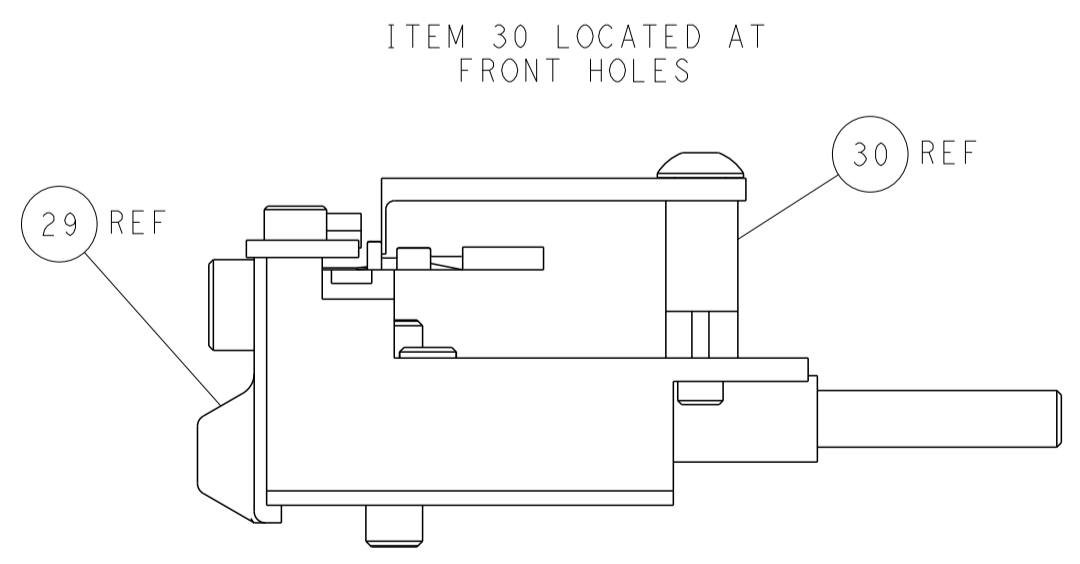
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

| | | | | |
|--|---|--|--|--|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small> | | DWN: C. CHEN 26AUG2013 CHK: U. GUO 26AUG2013 APVD: J. CRUZ 26AUG2013 | | NAME: Ocean Side Feed Applicator |
| DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: - | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: - | PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2 | | SIZE: - CAGE CODE: - DRAWING NO: Ac b p 0 1 7 9 0 2 266026 RESTRICTED TO: - SHEET 4 OF 4 REV B |