

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                        | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|---|-------------|----------|--------------------------|----------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   |             |          |                          |                                  | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|   | 2836378-2   | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                        | -                                 | -                     | -         | -           | -         | -         |                        |
|   | 2836378-5   | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup>   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2836378-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |          |                          |                                  | SMART APPLICATOR                  | 2161326-1             | -         | 8-2836378-4 | -         | -         |                        |
|   | 2836378-6   | A        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4,2</sup> | PNEUMATIC FEED                    | 2119950-1             | 1338683-8 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |
|   |             |          |                          |                                  | -                                 | -                     | -         | -           | -         | -         |                        |
|   | 2836378-7   | A        | FINE CRIMP HEIGHT ADJUST | NONE                             | -                                 | -                     | -         | -           | -         | -         | -                      |
|   | 7-2836378-7 | A        | CRIMP TOOLING KIT        | -                                | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 4.85 mm [.191] | F    |
| INSUL           | 5.60 mm [.220] | F    |

APPLICATOR INSTRUCTIONS  
408-10389

|                                    |   |                             |
|------------------------------------|---|-----------------------------|
| TERMINAL DATA:                     | FORD/WDP TERMINAL                             | FORD CRIMP SPECIFICATION    |
| TERMINAL NAME:                     | Trmnl WIR SNP on FEM (Ford)PNL-Fuse JCT (WDP) |                             |
| WIRE STRIP LENGTH                  |   | INSULATION DIAMETER RANGE   |
| 4.96-5.72 mm [.195-.225 IN]        |   | 3.40-4.30 mm [.134-.169 IN] |
| TERMINAL APPLICATION SPECIFICATION | FU5T-14474-AEA Rev 01/10/2014                 |                             |
| TERMINALS APPLIED                  |   |                             |
| TE TERMINAL                        | FORD/WDP TERMINAL                             | TE TERMINAL                 |
| 2303623-1                          | FU5T-14474-AEA                                | 2303623-2                   |
|                                    |   | FORD/WDP TERMINAL           |
|                                    |   | 6015462066A                 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 6.00mm2   | 3.40 +/- 0.05 [.134 +/- .002] | 6.6                            |
| 5.00mm2   | 3.20 +/- 0.05 [.126 +/- .002] | 8.8                            |
| 4.00mm2   | 3.00 +/- 0.05 [.118 +/- .002] | 10.9                           |

- 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:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836378-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836378-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836378-6
- 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. 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 ITEMS 37.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 2.4.
- 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  | 1803078-3 | SPACER, PRECISION                   | 259     |
|  | -   | 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  | 2119798-1 | DETENT PIN                          | 247     |
|  | -   | 1  | -  | 1  | 1  | 1-22279-3 | SPRING, COMPRESSION                 | 246     |
|  | -   | -  | 1  | -  | -  | 2161314-1 | RAM, STEPPED, ATLANTIC, SF, NON-ADJ | 245     |
|  | -   | 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     |
|  | -77 | -7 | -6 | -5 | -2 | PART NO   | DESCRIPTION                         | ITEM NO |

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

| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |           |     |      |
|--------------|-----|------|-----------|-----|-------------|-----------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE      | OWN | APVD |
|              |     |      | A         |     | RELEASED    | 15SEP2016 | MR  | TE   |

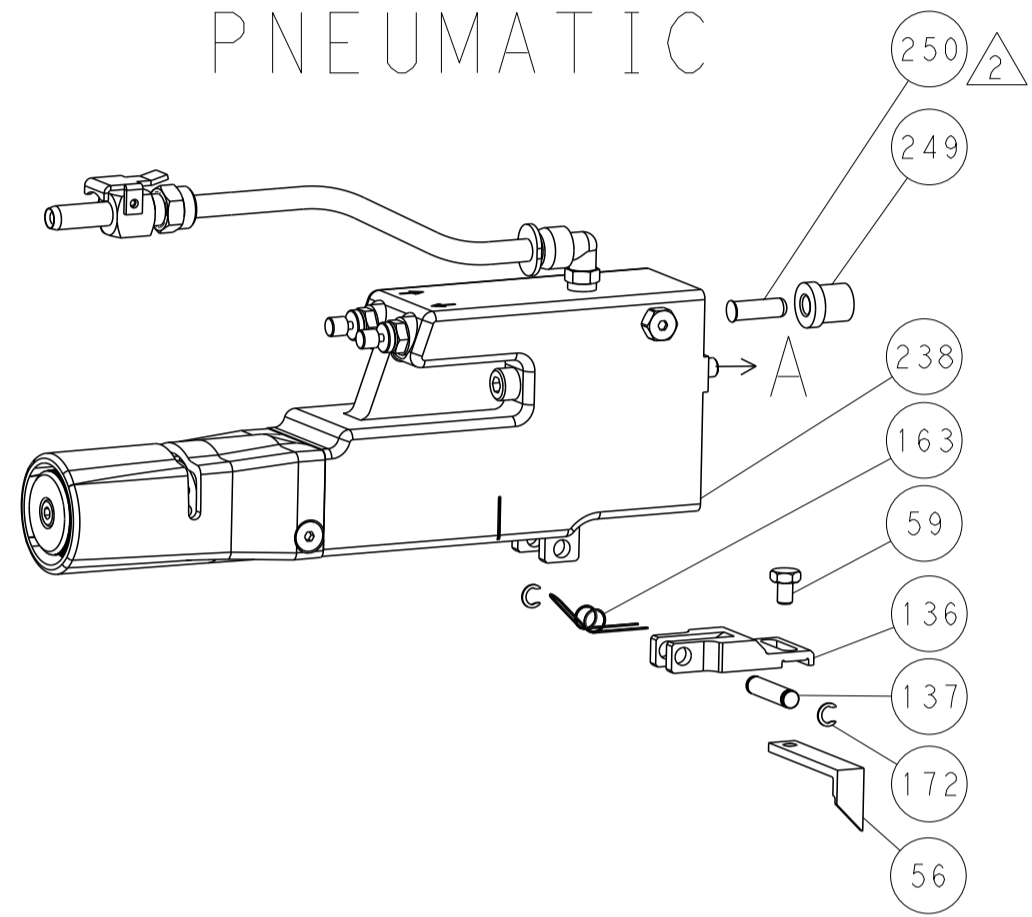
|     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241     |
| -   | -   | 2   | 2   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240     |
| -   | -   | -   | -   | 1   | 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   | 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   | 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   | 1-22281-8   | SPRING, COMPRESSION                 | 121     |
| -   | -   | REF | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113     |
| -   | 1   | 1   | 1   | 1   | 2-690438-2  | FRONT STRIP GUIDE                   | 96      |
| -   | 2   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95      |
| -   | 1   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 93      |
| -   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 22278-8     | SPRING, COMPRESSION                 | 77      |
| -   | 1   | 1   | 1   | 1   | 854769-4    | HOLDER, INS                         | 74      |
| -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| -   | 1   | -   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
|     | 3   | -   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62      |
| -   | 2   | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61      |
| -   | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60      |
| -   | -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | 1   | 1   | 1   | 1   | 21028-2     | PIN, SLOTTED SPRING .062 X .250     | 58      |
| -   | -   | -   | -   | 1   | 1338683-8   | FEED PAWL                           | 56      |
| -   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54      |
| -   | 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   | 690753-2    | SPACER, TONKER                      | 50      |
| -   | -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -   | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46      |
| -   | 1   | -   | 1   | 1   | 2161311-1   | RAM, STEPPED, AMP STYLE, SIDE FEED  | 44      |
| -   | 1   | 1   | 1   | 1   | 1-2079383-5 | SCR, BHSC, RoHS (M8 X 40)           | 41      |
| -   | 1   | -   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40      |
| -   | 1   | -   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
| -   | 1   | 1   | 1   | 1   | 2119644-5   | RAM WASHER, PRECISION               | 38      |
|     | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37      |
|     | 1   | -   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35      |
| -   | 1   | 1   | 1   | 1   | 3-1752356-3 | 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   | 2-1901086-7 | PLATE, STRIP GUIDE                  | 29      |
| -   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| -   | 2   | 2   | 2   | 2   | 22283-1     | SPRING, COMPRESSION                 | 27      |
| -   | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26      |
| -   | 1   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25      |
| -   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 1   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23      |
| -   | 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   | 2119533-1   | 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   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
|     | -   | 1   | 1   | 1   | 318707-1    | FLOATING SHEAR, FRONT               | 9       |
|     | 1   | 1   | 1   | 1   | 3-1803252-0 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1-2119780-1 | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 3-238011-5  | BLOCK, CRIMPER SPACER               | 4       |
|     | 1   | 1   | 1   | 1   | 8-1803187-4 | CRIMPER, INSULATION F               | 3       |
| -   | 1   | 1   | 1   | 1   | 455888-8    | SPACER, CRIMPER                     | 2       |
|     | 1   | 1   | 1   | 1   | 9-1803188-6 | CRIMPER, WIRE                       | 1       |
| -77 | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                         | ITEM NO |

|             |  |  |  |  |             |                            |  |
|-------------|--|--|--|--|-------------|----------------------------|--|
| DIMENSIONS: |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | OWN                                    | 26 JUL 2016 |                            | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| mm          |  | 0 PLC ±                                |  | CHK                                    | 26 JUL 2016 |                            |  |
|             |  | 1 PLC ±                                |  | APVD                                   | 26 JUL 2016 |                            |  |
|             |  | 2 PLC ±                                |  | NAME                                   |             |                            |  |
|             |  | 3 PLC ±                                |  | PRODUCT SPEC                           |             | Ocean Side Feed Applicator |  |
|             |  | 4 PLC ±                                |  | APPLICATION SPEC                       |             | SIZE                       |  |
|             |  | 5 PLC ±                                |  | MATERIAL                               |             | CAGE CODE                  |  |
|             |  | ANGLES                                 |  | WEIGHT                                 |             | DRAWING NO                 |  |
|             |  | FINISH                                 |  | A1                                     |             | 00779                      |  |
|             |  |  |  | Customer Accessible Production Drawing |             | SCALE                      |  |
|             |  |  |  | SHEET                                  |             | 1 OF 4                     |  |
|             |  |  |  | REV                                    |             | A                          |  |

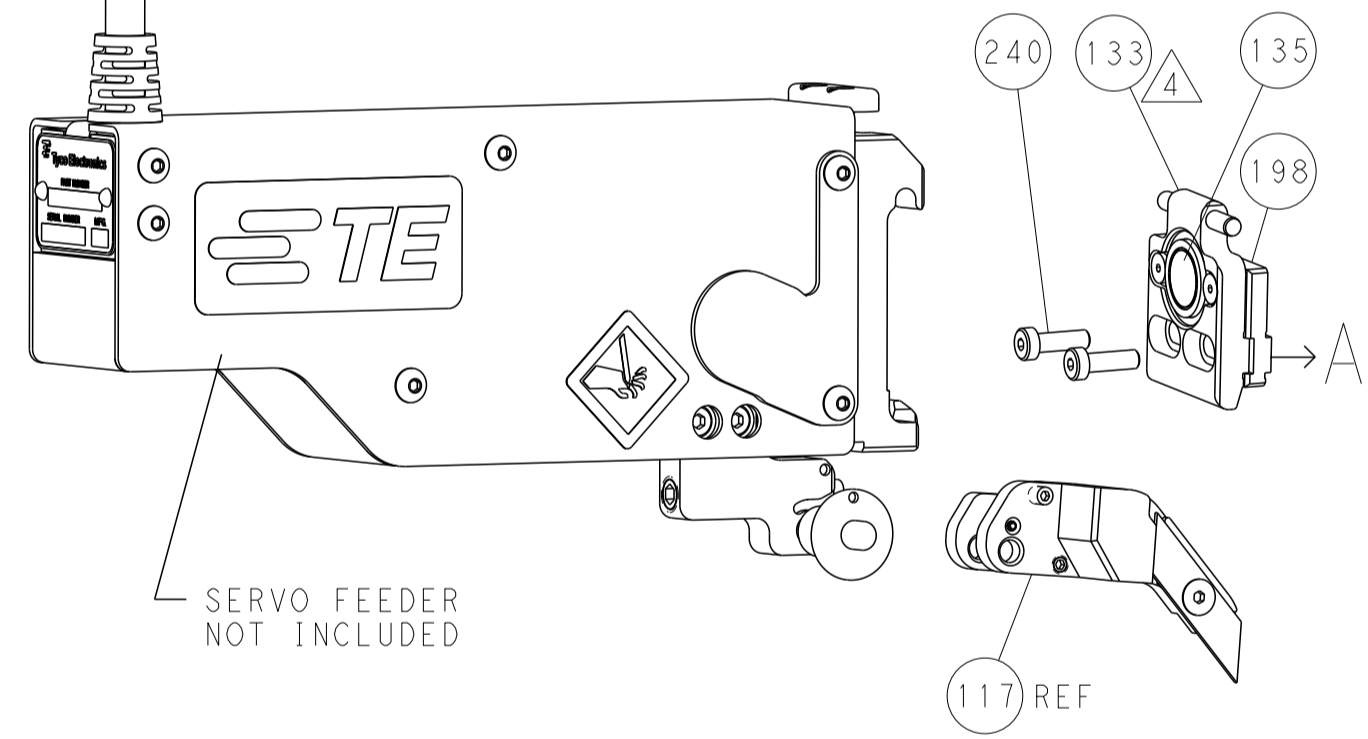
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    |     | SEE SHEET 1 |      |     |      |

### FEED TYPE

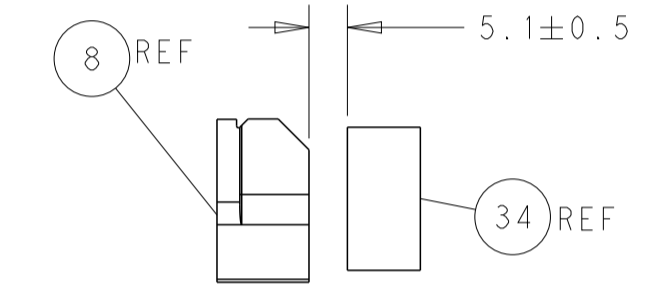
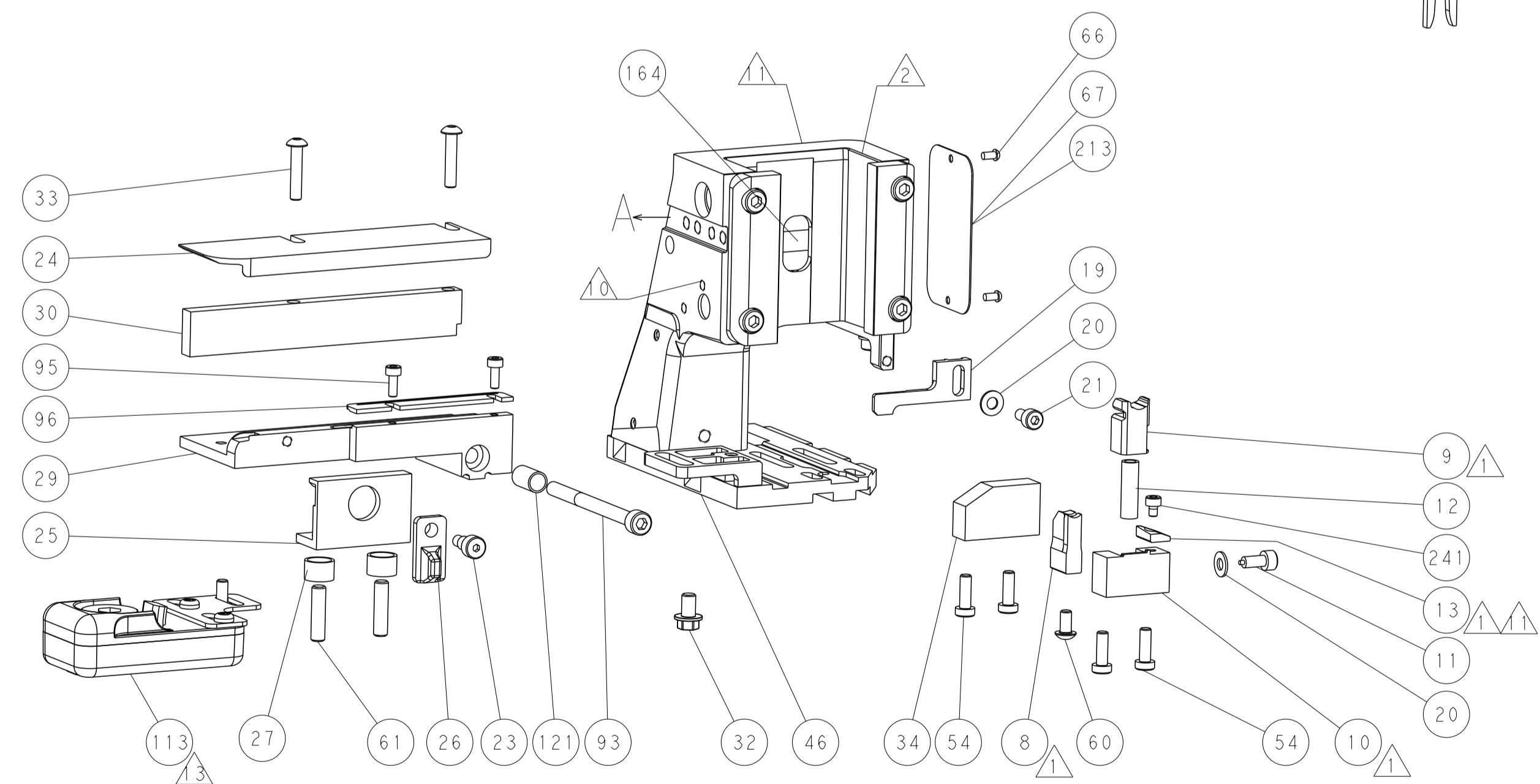
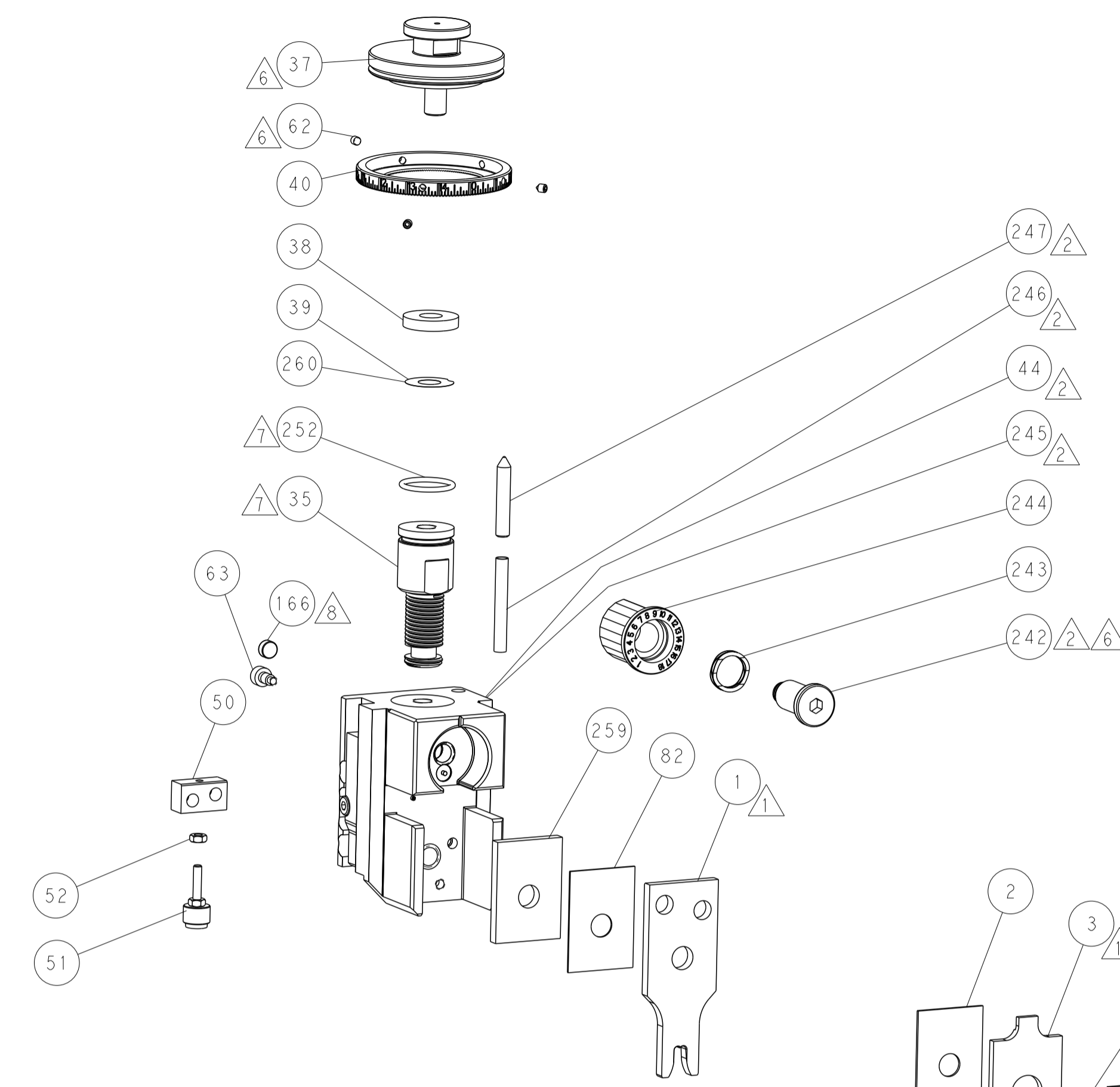
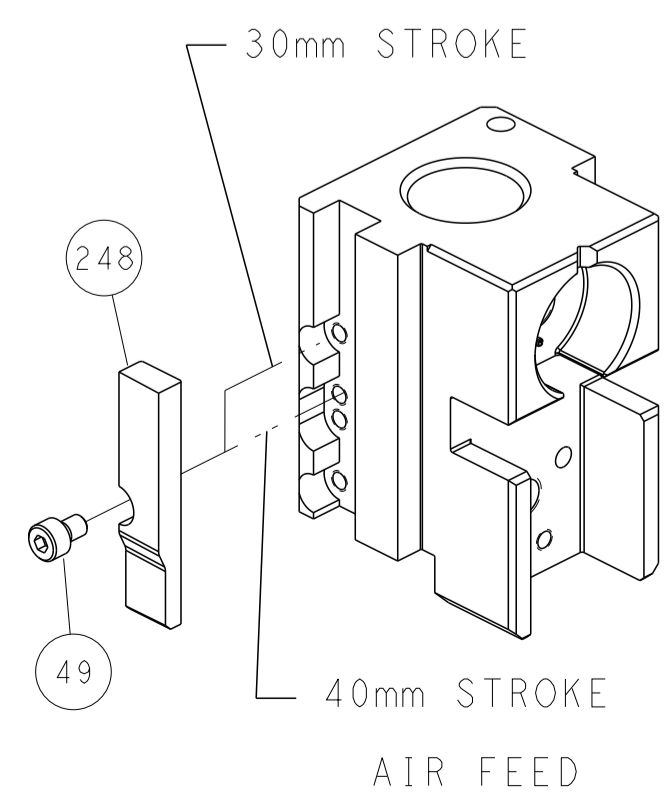
#### PNEUMATIC



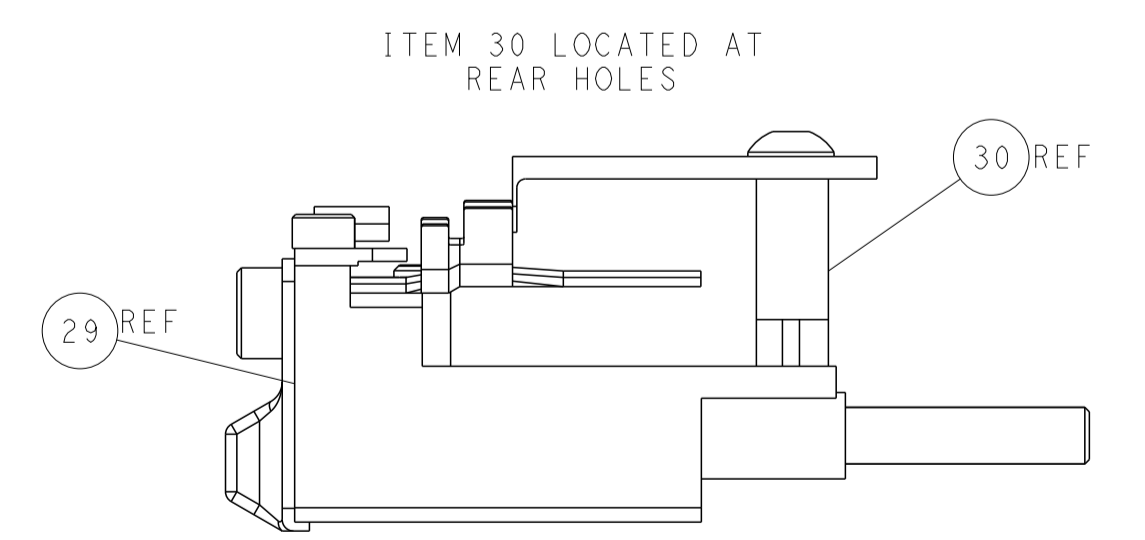
#### SERVO LATCH PLATE



### CAM POSITION



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT REAR HOLES

FEED TRACK POSITION GUIDE BY WIRE

**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 26 JUL 2016 |           | TE Connectivity |   |
| mm                                     | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                | 4 PLC ±   | ANGLES ±        | TE Connectivity Harrisburg, PA 17105-3608 |
| MATERIAL                               | FINISH  | WEIGHT                                 | SCALE   | SIZE                   | CAGE CODE | DRAWING NO      | RESTRICTED TO                             |
|  |         |  | 1:2     | A1                     | 00779     | ©=2836378       |   |
| Customer Accessible Production Drawing |         |  |         | SHEET 2 OF 4           |           | REV A           |   |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      |
|--|-------------|----------|--------------------------|--------------------------------|
|  | 2-2836378-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      |
|  | 2-2836378-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> |
|  | 2-2836378-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           |
|  | 7-2836378-7 | A        | CRIMP TOOLING KIT        | -                              |

| APPLICATOR DATA                   |                  |      |
|-----------------------------------|------------------|------|
| CRIMP                             | SIZE             | TYPE |
| WIRE                              | 4.85 mm [ .191 ] | F    |
| INSUL                             | 5.60 mm [ .220 ] | F    |
| APPLICATOR INSTRUCTIONS 408-10389 |                  |      |

| TERMINAL DATA:   |   | FORD/WDP TERMINAL | FORD CRIMP SPECIFICATION                                   |
|--|---|-------------------|--|
| TERMINAL NAME:   | Trmnl WIR SNP on FEM (Ford)PNL-Fuse JCT (WDP) |                   |  |
| WIRE STRIP LENGTH  | 4.96-5.72 mm [ .195-.225 IN ]                 |                   | INSULATION DIAMETER RANGE<br>3.40-4.30 mm [ .134-.169 IN ] |
| TERMINAL APPLICATION SPECIFICATION                       | FU5T-14474-AEA Rev 01/10/2014                 |                   |  |
| TERMINALS APPLIED <sup>4</sup> <sub>1</sub> <sub>2</sub> |   |                   |  |
| TE TERMINAL  | FORD/WDP TERMINAL                             | TE TERMINAL       | FORD/WDP TERMINAL  |
| 2303623-1  | FU5T-14474-AEA                                | 2303623-2         | 6015462066A  |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]          | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|-----------|---------------------------------|---|
| 6.00mm2   | 3.40 +/- 0.05 [ .134 +/- .002 ] | 6.6   |
| 5.00mm2   | 3.20 +/- 0.05 [ .126 +/- .002 ] | 8.8   |
| 4.00mm2   | 3.00 +/- 0.05 [ .118 +/- .002 ] | 10.9  |



- <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:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836378-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836378-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- <sup>8</sup> MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- <sup>10</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>12</sup> TERMINAL LUBRICANT IS RECOMMENDED.

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

|     |     |     |     |           |                                     |         |
|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1803078-3 | SPACER, PRECISION                   | 259     |
| -   | 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   | 1-22279-3 | SPRING, COMPRESSION                 | 246     |
| -   | 1   | 1   | 1   | 2119082-8 | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -   | 1   | 1   | 1   | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -   | 1   | 1   | 1   | 2119083-1 | RETAINER, INSULATION DIAL           | 242     |
| -   | 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     |
| -77 | -27 | -25 | -22 | 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)

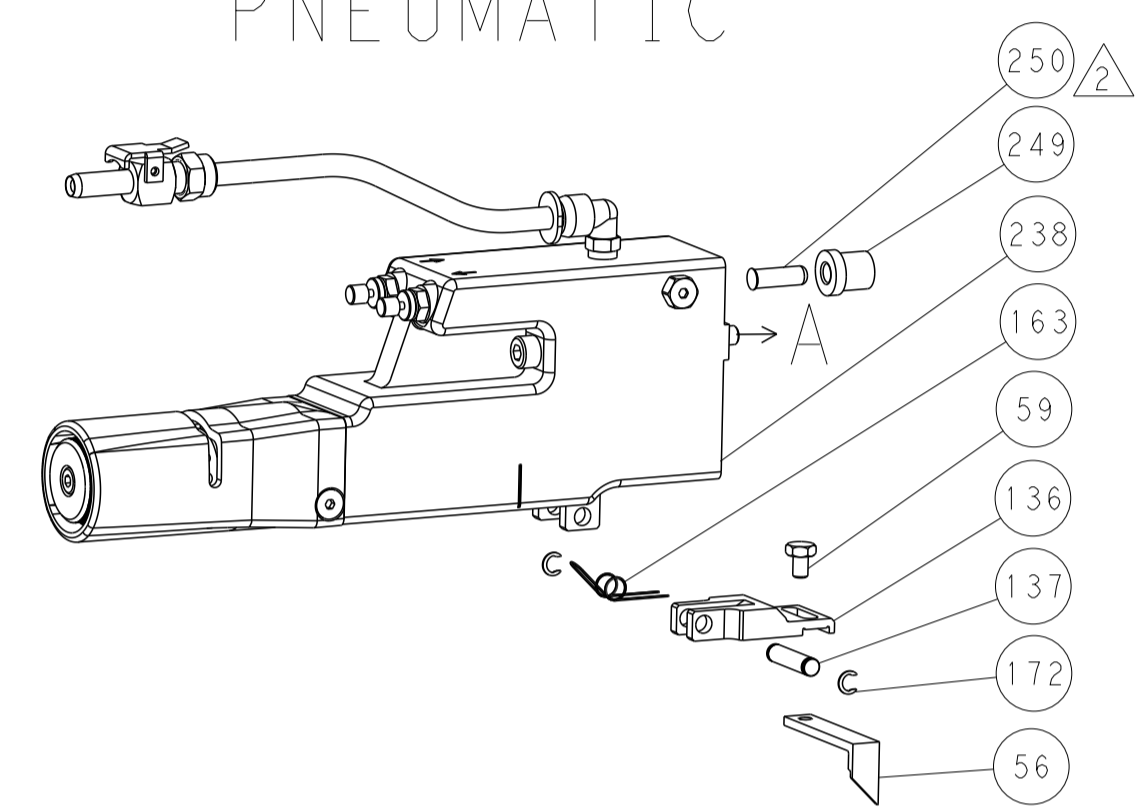
| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
|              |     |      | -         | -   | SEE SHEET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

|               |     |     |     |           |                                     |                                      |     |
|---------------|-----|-----|-----|-----------|-------------------------------------|--------------------------------------|-----|
| -             | -   | -   | 1   | 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                                  |     |
| <sup>8</sup>  | -   | 1   | 1   | 1         | 994969-1                            | MAGNET, RARE EARTH HIGH ENERGY       | 166 |
| -             | REF | REF | REF | 994970-2  | COUNTER, MAGNETIC                   | 164                                  |     |
| -             | -   | -   | -   | 1         | 240638-1                            | SPRING, FEED FINGER                  | 163 |
| <sup>7</sup>  | -   | 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   | 1         | 2168400-5                           | SHCS, LOW HEAD, RoHS, M4 X 20        | 143 |
| -             | 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 |
| <sup>7</sup>  | -   | 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         | 1-22281-8                           | SPRING, COMPRESSION                  | 121 |
| -             | -   | REF | -   | -         | 2119944-1                           | FEED FINGER ASSEMBLY, SF             | 117 |
| -             | 1   | 1   | 1   | 1         | 2119955-1                           | ASSY, LUBRICATOR, SIDE FEED          | 113 |
| -             | 1   | 1   | 1   | 1         | 2-690438-2                          | FRONT STRIP GUIDE                    | 96  |
| -             | 2   | 2   | 2   | 1         | 2168083-1                           | SCR, SKT HD CAP, RoHS, M3 X 8.0      | 95  |
| -             | 1   | 1   | 1   | 1         | 2168083-6                           | SCR, SKT HD CAP, RoHS, M5 X 65       | 93  |
| -             | 1   | 1   | 1   | 1         | 455888-5                            | SPACER, CRIMPER                      | 82  |
| -             | 1   | 1   | 1   | 1         | 22278-8                             | SPRING, COMPRESSION                  | 77  |
| -             | 1   | 1   | 1   | 1         | 854769-4                            | HOLDER, INS                          | 74  |
| -             | 1   | 1   | 1   | 1         | 2119956-1                           | DOCUMENTATION PACKAGE                | 71  |
| -             | 1   | -   | -   | 1         | 2119740-1                           | TAG IDENTIFICATION                   | 67  |
| -             | 2   | 2   | 2   | 1         | 2168078-1                           | SCREW, DRIVE, RH, RoHS, 2 x .188     | 66  |
| <sup>6</sup>  | -   | 1   | 1   | 1         | 2119793-1                           | LIMITER, ADJUSTMENT BOLT             | 63  |
| -             | 3   | 3   | 3   | 1         | 992763-5                            | SCR, SET, SOC, CONE POINT, M3 x 4.0  | 62  |
| -             | 2   | 2   | 2   | 1         | 2-18032-5                           | SCR, SET, FLT POINT M5 X 20.0        | 61  |
| -             | -   | -   | -   | 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         | 1338683-8                           | FEED PAWL                            | 56  |
| -             | 2   | 2   | 2   | 1         | 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         | 690753-2                            | SPACER, TONKER                       | 50  |
| -             | -   | -   | -   | 1         | 18023-9                             | SCR, SKT HD CAP M4 X 6.0             | 49  |
| -             | 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         | 2119644-5                           | RAM WASHER, PRECISION                | 38  |
| -             | 1   | 1   | 1   | 1         | 3-1752356-3                         | SUPPORT, TERMINAL                    | 34  |
| -             | 2   | 2   | 2   | 1         | 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         | 2-1901086-7                         | PLATE, STRIP GUIDE                   | 29  |
| -             | 1   | 1   | 1   | 1         | 1-455888-0                          | SPACER, CRIMPER                      | 28  |
| -             | 2   | 2   | 2   | 1         | 22283-1                             | SPRING, COMPRESSION                  | 27  |
| -             | 1   | 1   | 1   | 1         | 356835-1                            | LEVER, DRAG RELEASE                  | 26  |
| -             | 1   | 1   | 1   | 1         | 240792-1                            | DRAG, TERMINAL                       | 25  |
| -             | 1   | 1   | 1   | 1         | 1320928-2                           | STRIP GUIDE                          | 24  |
| -             | 1   | 1   | 1   | 1         | 980371-4                            | SCR, SKT HD SHLDR 5.0 DIA X 6.0      | 23  |
| -             | 1   | 1   | 1   | 1         | 2168083-2                           | SCR, SKT HD CAP, RoHS, M4 X 8.0      | 21  |
| -             | 2   | 2   | 2   | 1         | 1-18028-2                           | WASHER, FLAT, REG M4                 | 20  |
| -             | 1   | 1   | 1   | 1         | 2119533-1                           | STRIPPER, SIDE FEED                  | 19  |
| <sup>11</sup> | -   | 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  |
| <sup>1</sup>  | -   | 1   | 1   | 1         | 2119805-1                           | SHEAR HOLDER, FRONT                  | 10  |
| <sup>1</sup>  | -   | 1   | 1   | 1         | 318707-1                            | FLOATING SHEAR, FRONT                | 9   |
| <sup>1</sup>  | 1   | 1   | 1   | 1         | 3-1803252-0                         | ANVIL, COMBINATION                   | 8   |
| -             | -   | -   | -   | -         | -                                   | -                                    | 7   |
| -             | -   | -   | -   | -         | -                                   | -                                    | 6   |
| -             | 1   | 1   | 1   | 1         | 1-2119780-1                         | DEPRESSOR, SHEAR                     | 5   |
| -             | 1   | 1   | 1   | 1         | 3-238011-5                          | BLOCK, CRIMPER SPACER                | 4   |
| <sup>1</sup>  | 1   | 1   | 1   | 1         | 8-1803187-4                         | CRIMPER, INSULATION F                | 3   |
| -             | 1   | 1   | 1   | 1         | 455888-8                            | SPACER, CRIMPER                      | 2   |
| <sup>1</sup>  | 1   | 1   | 1   | 1         | 9-1803188-6                         | CRIMPER, WIRE                        | 1   |
| -77           | -27 | -25 | -22 | PART NO   | DESCRIPTION                         | ITEM NO                              |     |

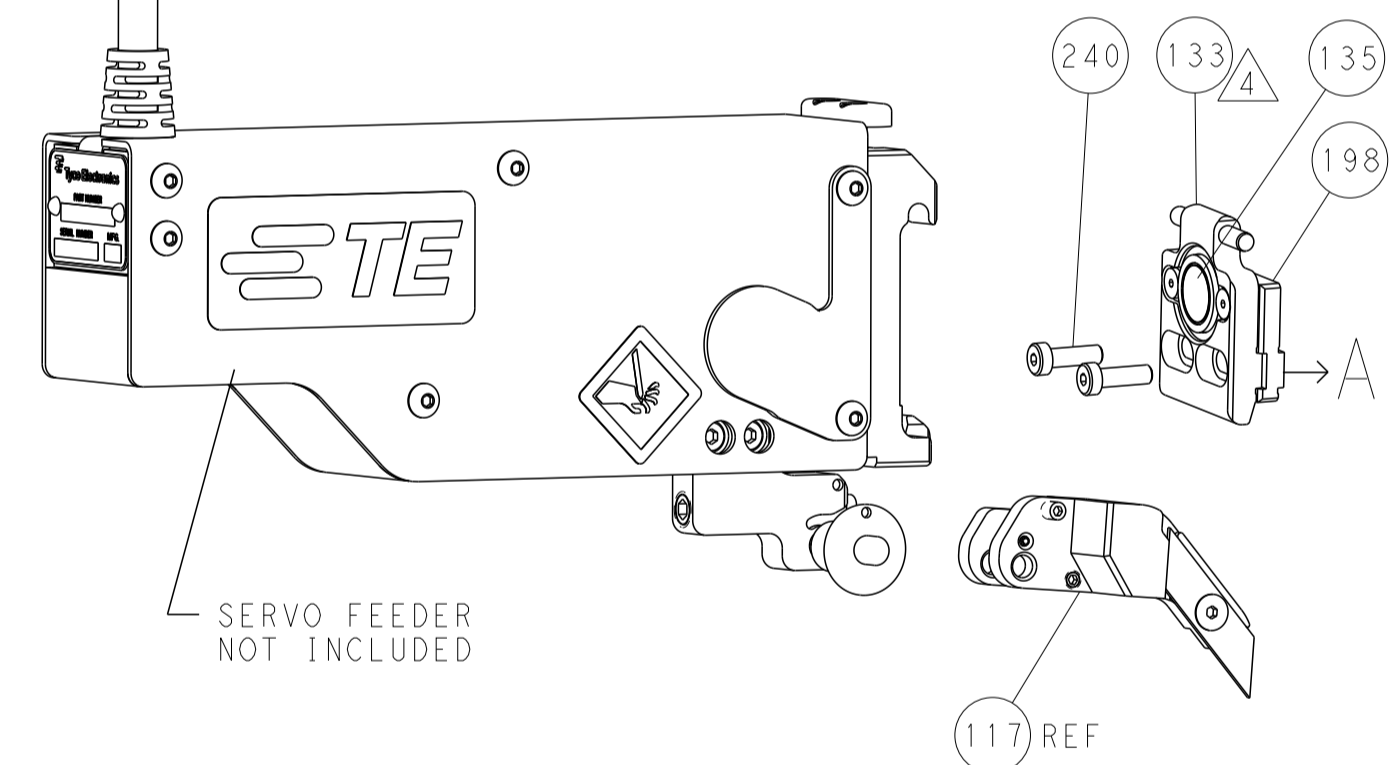
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DATE                                   |         | NAME      |            |
|-------------|---------|--|---------|--|---------|-----------|------------|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                                | 4 PLC ± | ANGLES ±  | FINISH     |
| MATERIAL    |         |  |         | WEIGHT                                 | SIZE    | CAGE CODE | DRAWING NO |
| -           |         |  |         | -                                      | A1      | 00779     | 2836378    |
| -           |         |  |         | Customer Accessible Production Drawing | SCALE   | SHEET     | REV        |
| -           |         |  |         | 1:2                                    | 3       | 4         | A          |

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

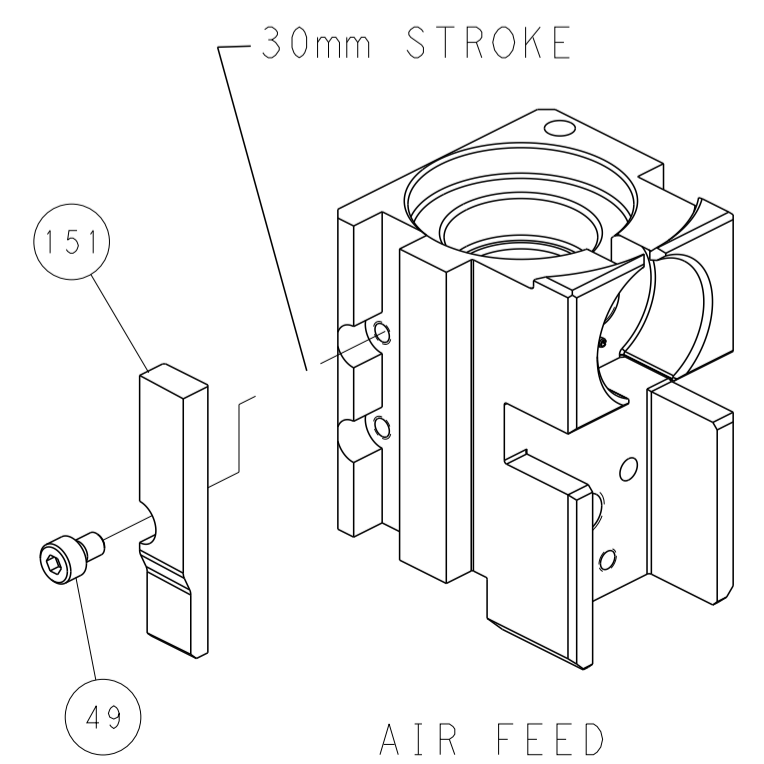
### FEED TYPE PNEUMATIC



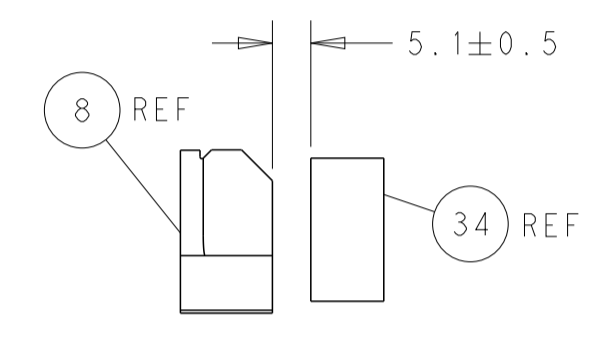
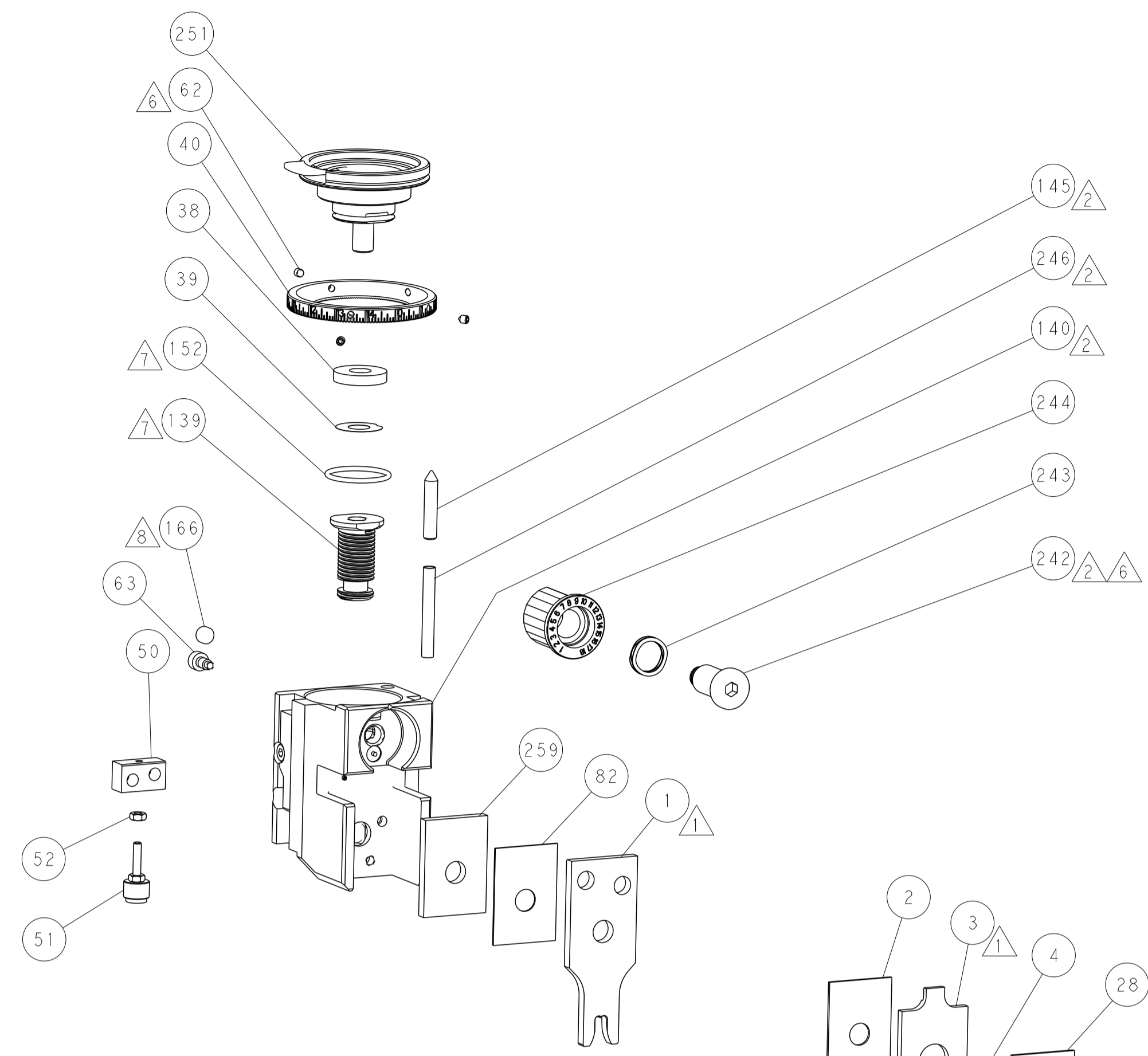
### SERVO LATCH PLATE



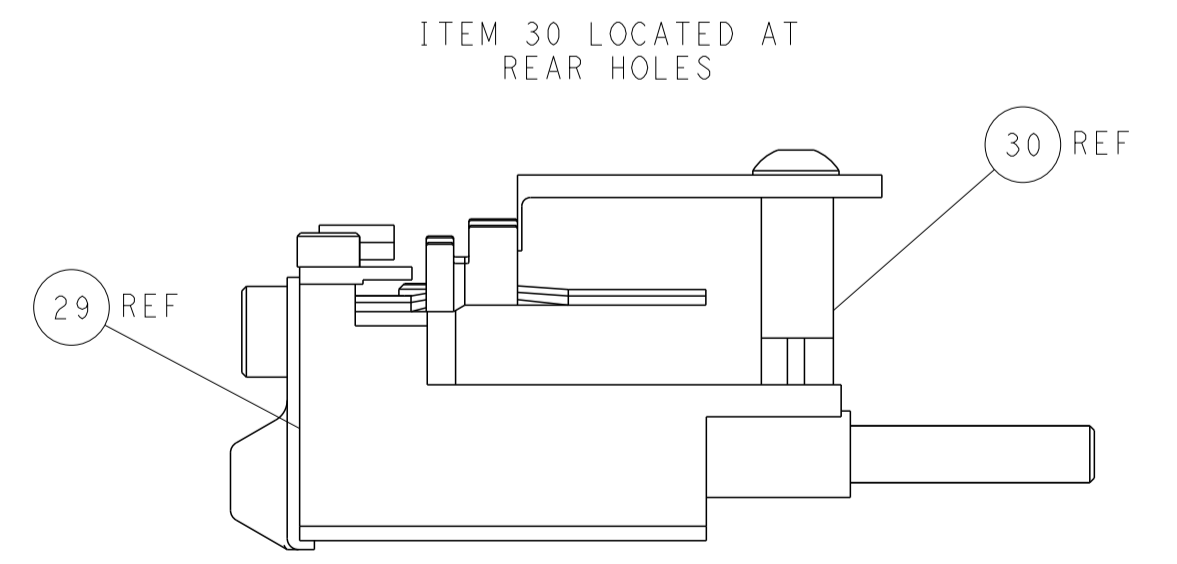
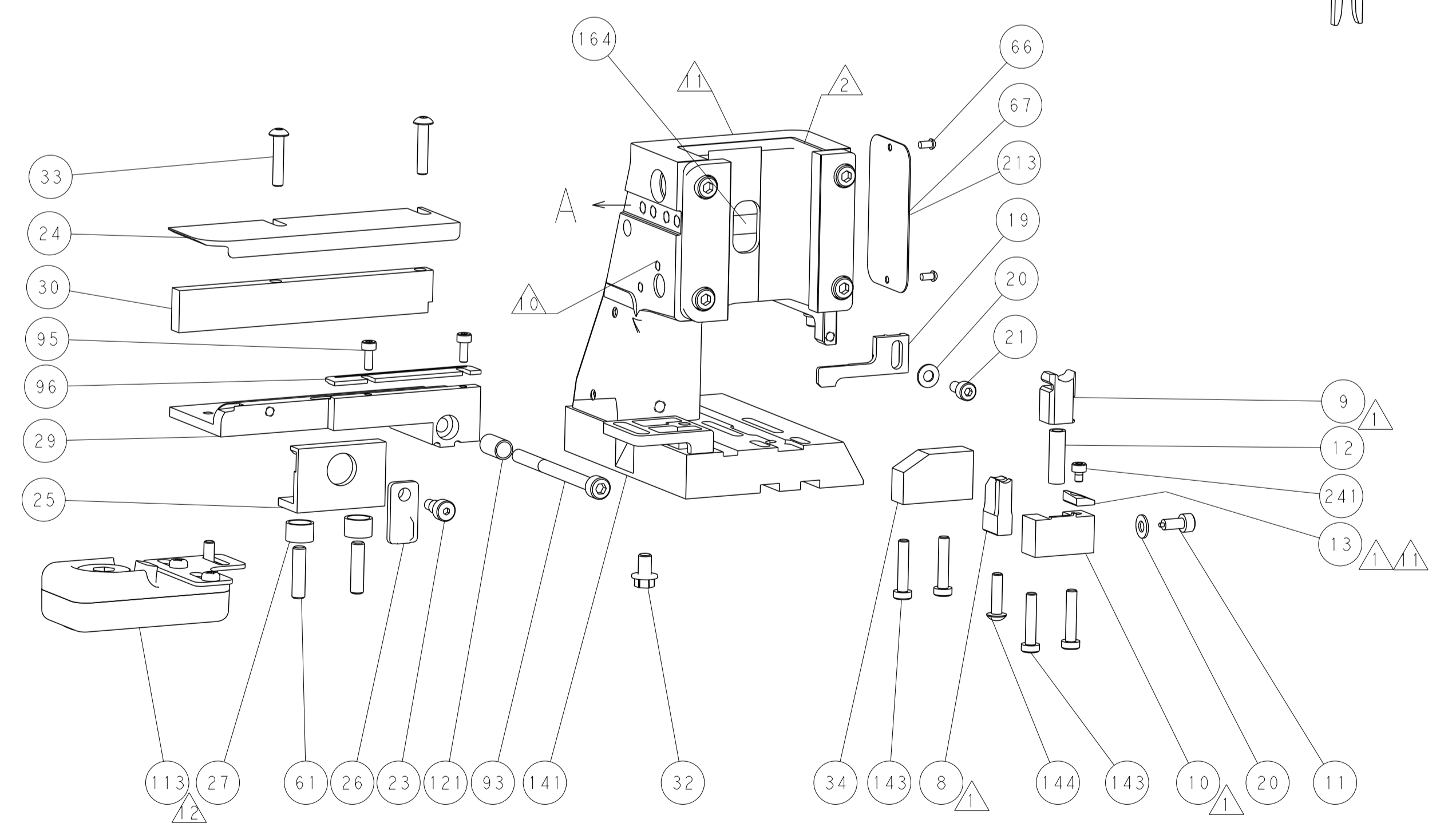
### CAM POSITION



AIR FEED



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION  
GUIDE BY WIRE

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

|  |  |   |  |   |  |                                       |  |
|--|--|---|--|---|--|---------------------------------------|--|
| DIMENSIONS:<br>mm<br>                  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH |  | DWN J. HOU 26 JUL 2016<br>CHK L. ZHANG 26 JUL 2016<br>APVD L. ZHANG 26 JUL 2016 |  | NAME<br>Ocean Side Feed<br>Applicator |  |
| MATERIAL:                              |  | WEIGHT:   |  | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2836378                           |  | RESTRICTED TO:                        |  |
| Customer Accessible Production Drawing |  |   |  | SCALE: 1:2  |  | SHEET 4 OF 4 REV A                    |  |