

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2266074-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2266074-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266074-5	1901094-3	2-1752354-2	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266074-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
	2266074-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2266074-5	1901094-3	2-1752354-2	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266074-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
2266074-6	D	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
				-	-	-	-	-	-		
2266074-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266074-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.19 mm [.165]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT A			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.60-5.20 mm [.181-.205 IN]	Ø2.20-3.00 mm [.087-.118 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)114-18050		
	(B)114-18051		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	CABLE DIAMETER
(A)964273-1	(A)1241872-1	(A) 963292-1	Ø2.7-3.0
(A)964273-2	(A)4-1241872-1	(A) 963293-1	Ø2.0-2.7
(A)1-964273-1		(A) 963293-2	Ø2.0-2.7
(A)2-964273-1	(B)1-964302-3		
(A)3-964273-1	(B)2-964302-1		
(A)4-964273-1			
(A)6-964273-6			
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
2.50mm2	1.76+/-0.05 [.069+/-0.002]	3.9	
2.00mm2	1.70+/-0.05 [.067+/-0.002]	5.6	
1.50mm2	1.47+/-0.05 [.058+/-0.002]	7.0	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT A			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.20-4.80 mm [1.65-.189 IN]	Ø2.20-3.00 mm [.087-.118 IN]		
TERMINAL APPLICATION SPECIFICATION	(C)114-18387		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	CABLE DIAMETER
		(A) 963292-1	Ø2.7-3.0
		(A) 963293-1	Ø2.0-2.7
(C) 1241396-1		(A) 963293-2	Ø2.0-2.7
(C) 1241396-2			
(C) 1241396-3			
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
2.50mm2	1.76+/-0.05 [.069+/-0.002]	4.9	
2.00mm2	1.70+/-0.05 [.067+/-0.002]	5.6	
1.50mm2	1.47+/-0.05 [.058+/-0.002]	8.0	

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 - MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266074-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266074-5
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266074-5
 - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266074-6
- 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.
 - APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
 - FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 180.
- 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.
- 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- WHEN APPLYING TERMINAL PN 1241396-* APPLICATOR FEED WILL REQUIRED ADJUSTMENT TO 12.0mm [.472 IN].
- THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.
- TERMINAL LUBRICANT 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	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	1803259-1	BUSHING, FLANGED	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
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

SET UP GAUGE		LOC	DIST	REVISIONS					
2119599-1	A	66		P	LTN	DESCRIPTION	DATE	OWN	APVD
				B		ECR-16-005138	08APR2016	KH	CT
				C		ECR-16-010516	20JUL2016	MEH	CT
				C1		ECR-16-011947	19AUG2016	YY	KZ
				D		ECR-16-017814	15DEC2016	TB	CT

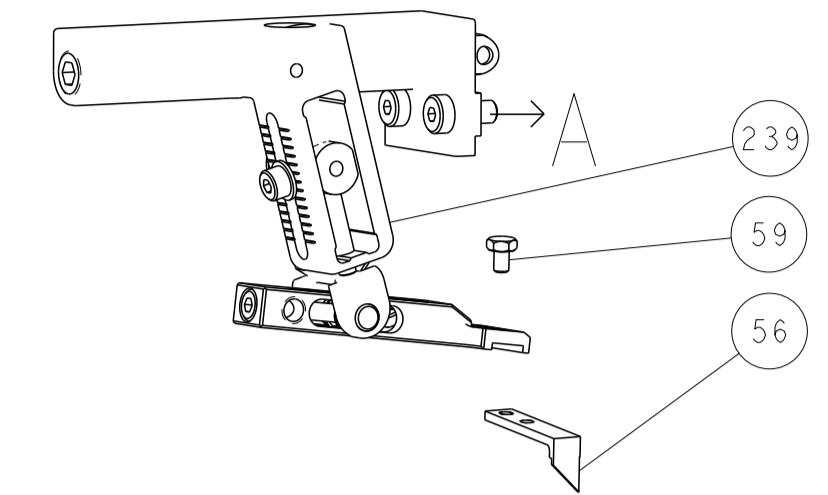
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	2	-	-	2168400-6	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	4-1722335-3	STRIPPER, SIDE FEED	182
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	1	1	1	1	1	2-1752354-2	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	5-22280-0	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-3	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	455888-6	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 SKT CAP, M4 X 6.0	59
-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	-	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	2-2119656-1	APPLICATOR BASIC ASSEMBLY, SF	46
-	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	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	1752356-4	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	1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-4	STRIP GUIDE	24
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1333206-2	ANVIL, COMBINATION .100	8
-	1	1	1	1	1	6-240641-3	SPACER	7
-	1	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1633996-3	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	1	1	1-456407-3	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC	±		0779	2266074		
	1 PLC	±					
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
	FINISH	±					

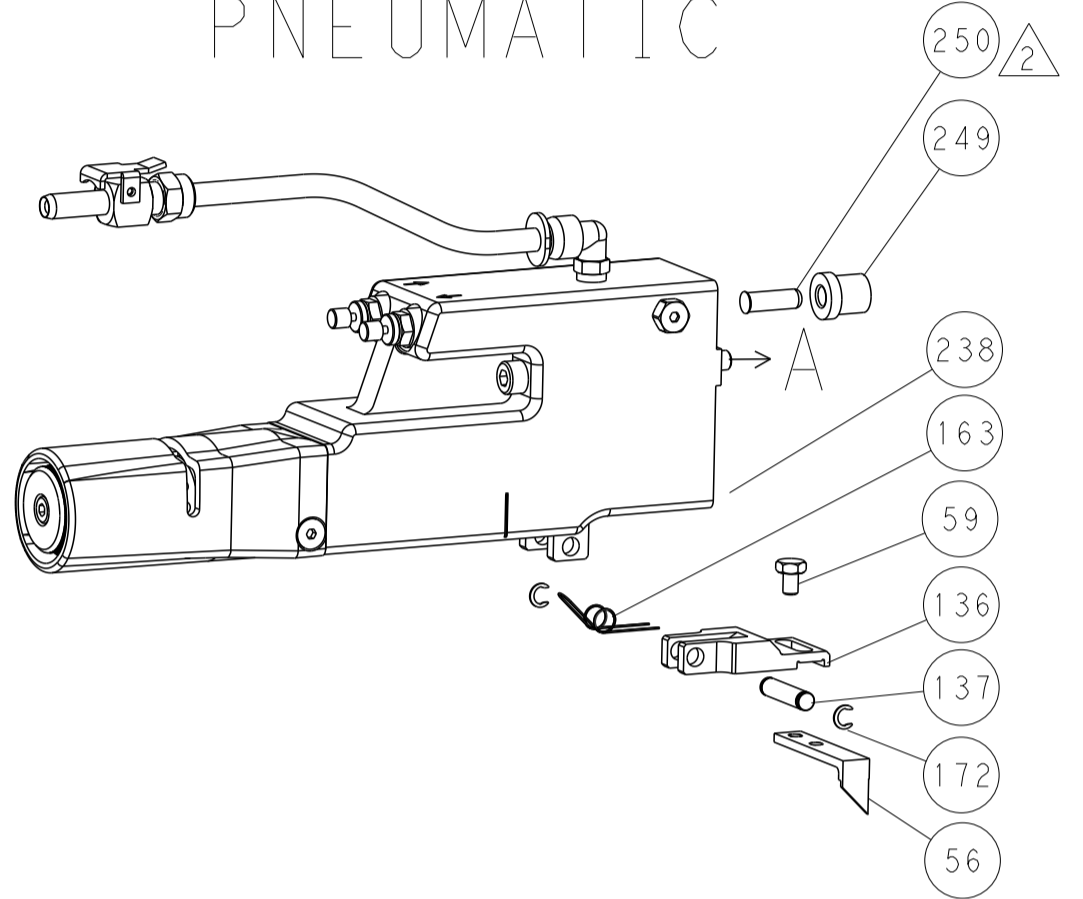
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV D

LOC	DIST	REVISIONS					
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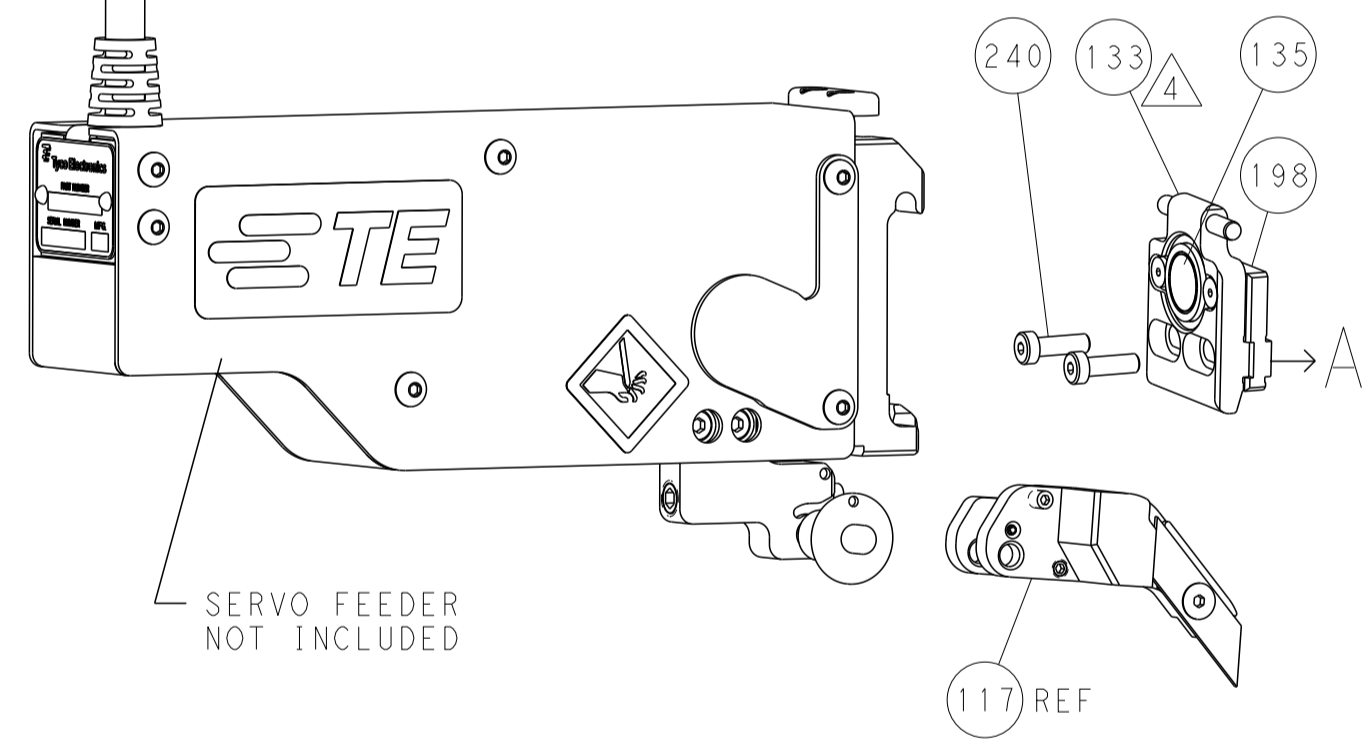
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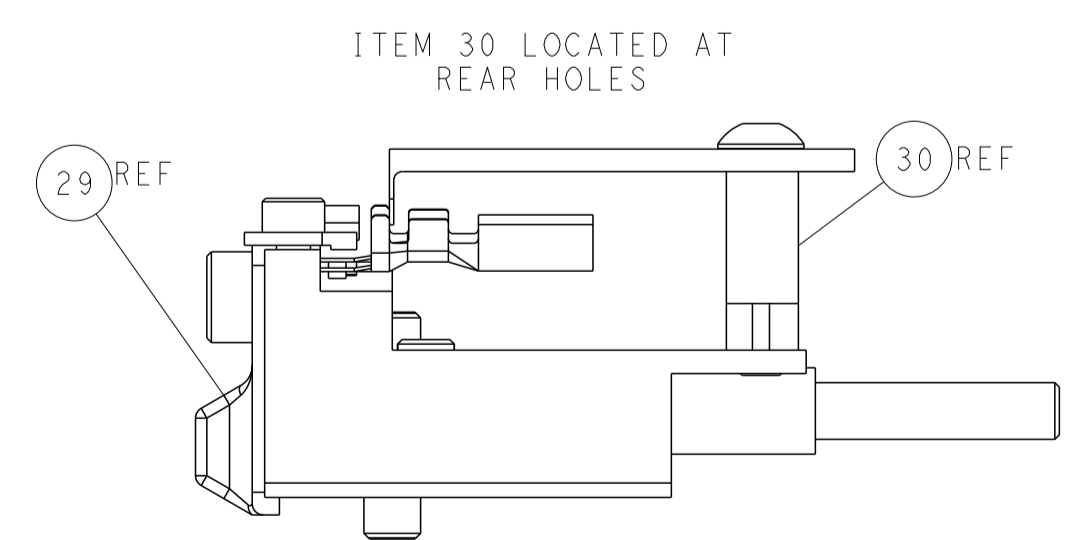
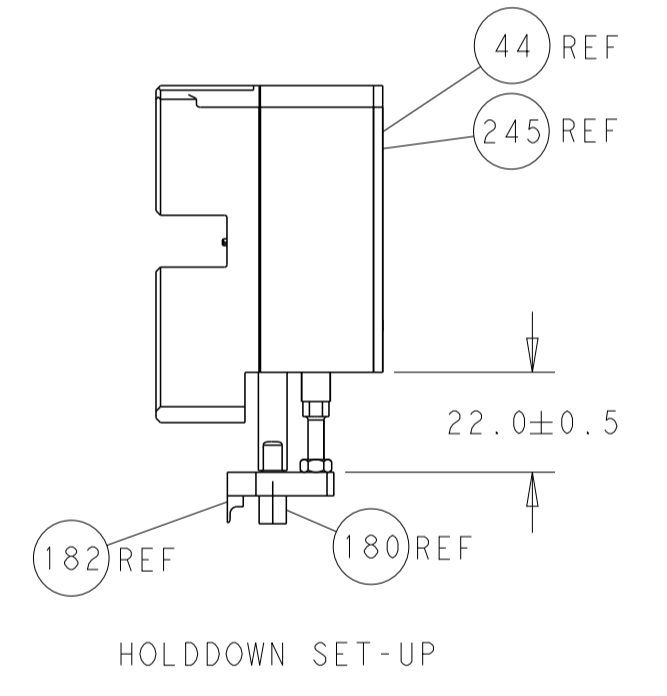
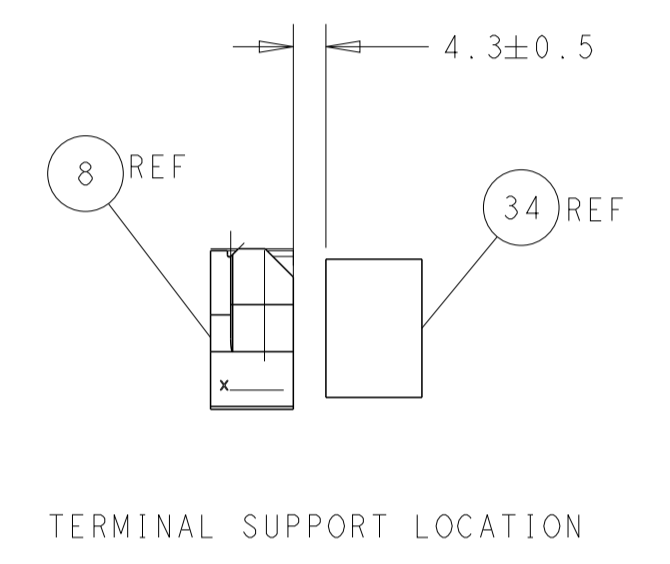
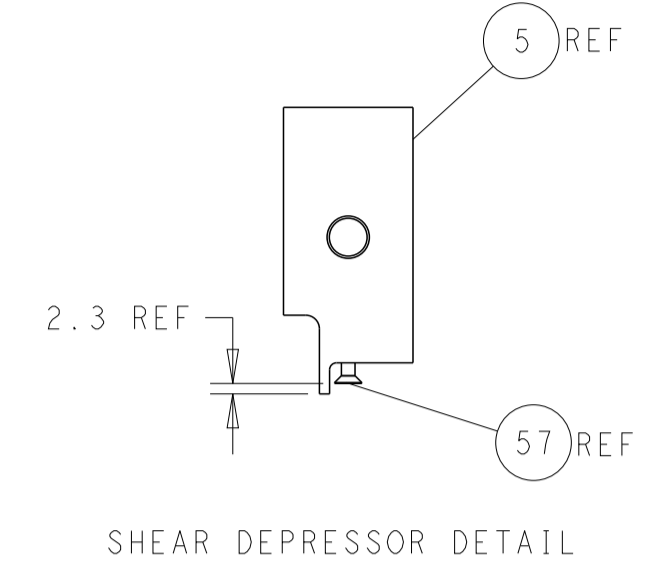
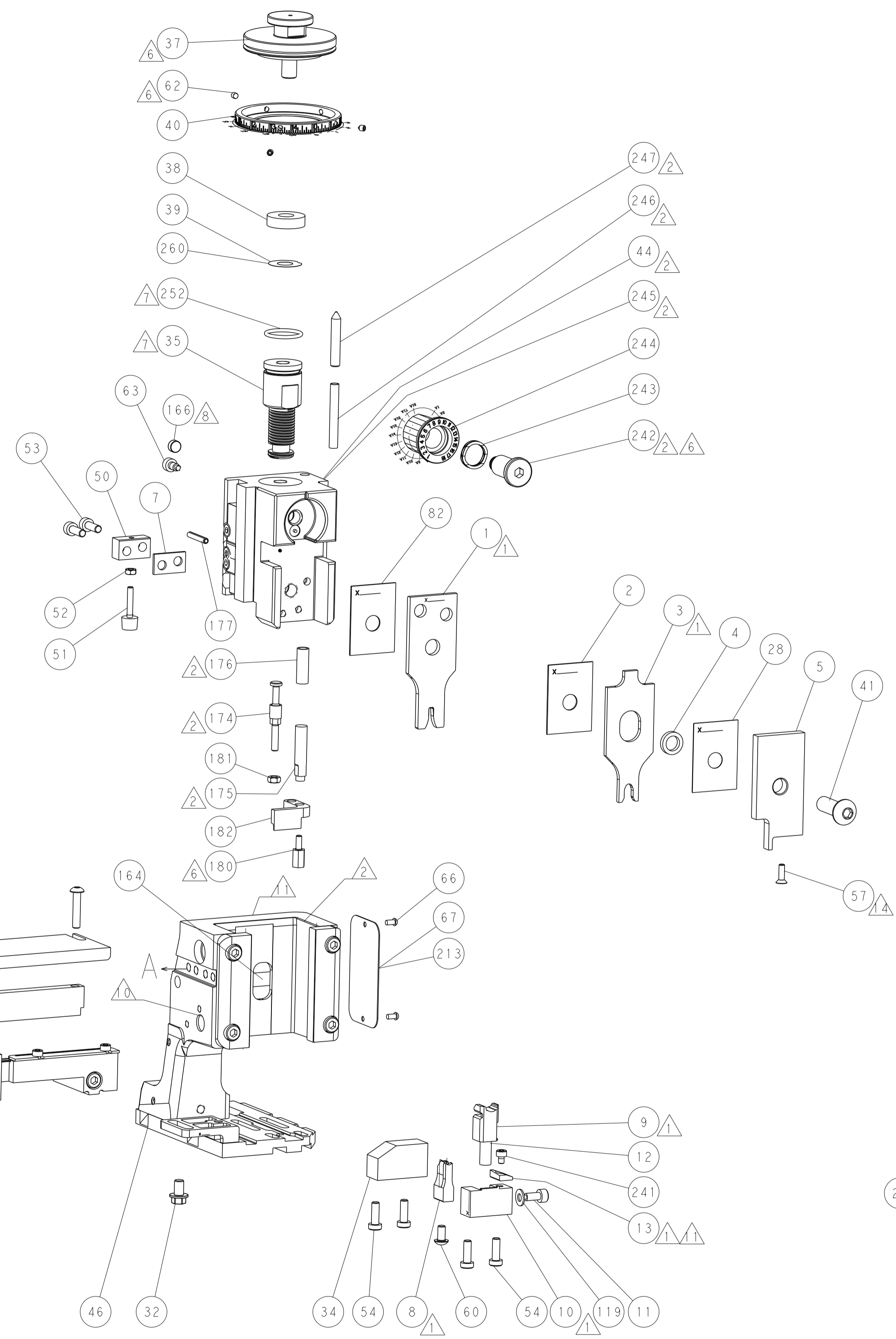
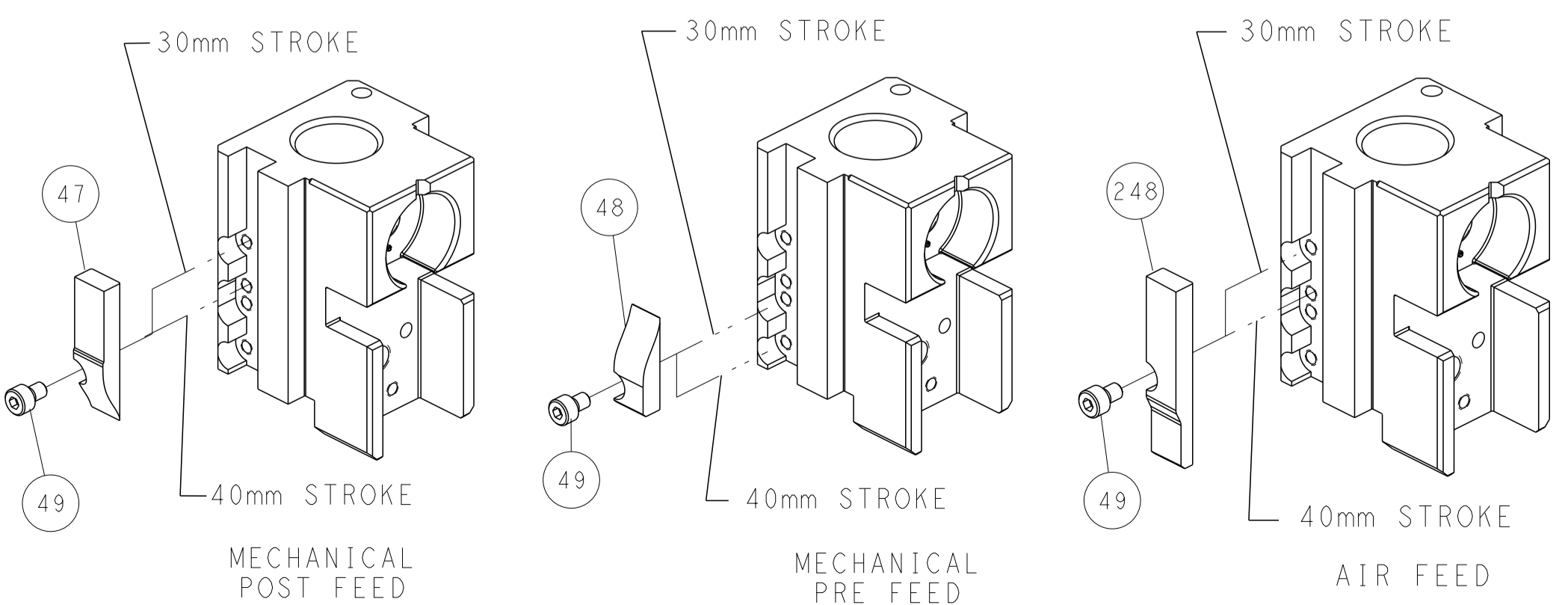
PNEUMATIC



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: H. HUANG 11OCT2013 CHK: L. ZHANG 11OCT2013 APVD: J. GUO 11OCT2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266074	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: D
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266074-1	D	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	-	8-2266074-5	1901094-3	2-1752354-2	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266074-4	-	-	-
	2-2266074-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266074-5	1901094-3	2-1752354-2	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266074-4	-	-	-
	2-2266074-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	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
	2-2266074-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266074-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.19 mm [.165]	O
APPLICATOR INSTRUCTIONS 408-10389		

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TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT A			
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4.60-5.20 mm [.181-.205 IN]		Ø2.20-3.00 mm [.087-.118 IN]	
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	(B)114-18051		
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TE TERMINAL	TE TERMINAL	TE SEAL	CABLE DIAMETER
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(A)964273-2	(A)4-1241872-1	(A) 963293-1	Ø2.0-2.7
(A)1-964273-1		(A) 963293-2	Ø2.0-2.7
(A)2-964273-1	(B)1-964302-3		
(A)3-964273-1	(B)2-964302-1		
(A)4-964273-1			
(A)6-964273-6			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT A			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-4.80 mm [1.65-.189 IN]		Ø2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	(C)114-18387		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	CABLE DIAMETER
		(A) 963292-1	Ø2.7-3.0
		(A) 963293-1	Ø2.0-2.7
(C) 1241396-1		(A) 963293-2	Ø2.0-2.7
(C) 1241396-2			
(C) 1241396-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.76+/-0.05 [.069+/- .002]	3.9
2.00mm2	1.70+/-0.05 [.067+/- .002]	5.6
1.50mm2	1.47+/-0.05 [.058+/- .002]	7.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.76+/-0.05 [.069+/- .002]	4.9
2.00mm2	1.70+/-0.05 [.067+/- .002]	5.6
1.50mm2	1.47+/-0.05 [.058+/- .002]	8.0

- 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: 8-2266074-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266074-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266074-5
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- 8 MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

- 12 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 13 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 14 WHEN APPLYING TERMINAL PN 1241396-* APPLICATOR FEED WILL REQUIRED ADJUSTMENT TO 12.0mm [.472 IN].
- 15 THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.
- 16 TERMINAL LUBRICANT 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.

ITEM NO	PART NO	DESCRIPTION					
-	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251		
-	-	1	2119640-1	PUSH ROD, AIR FEED	250		
-	-	1	1803259-1	BUSHING, FLANGED	249		
-	1	1	1-22279-3	SPRING, COMPRESSION	246		
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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

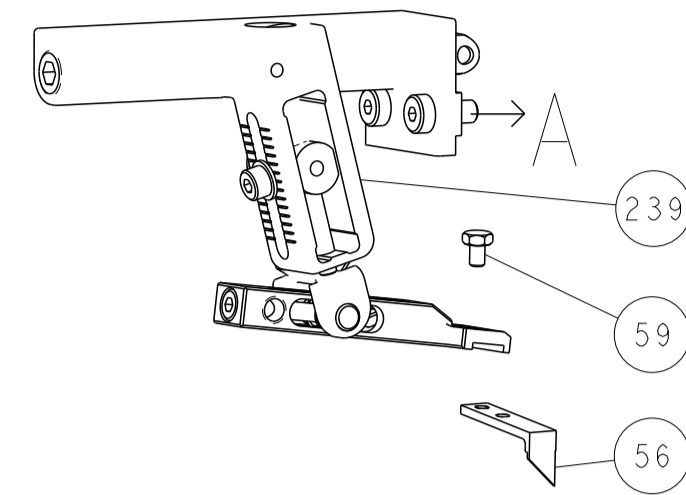
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPD
			-	SEE SHEET 1	-	-

REV	DATE	BY	APPD	DESCRIPTION	ITEM NO		
-	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	
-	-	-	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	4-1722335-3	STRIPPER, SIDE FEED	182	
-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181	
-	1	1	1	2-1752354-2	STANDOFF, HOLD-DOWN	180	
-	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	1	1	5-22280-0	SPRING, COMPRESSION	176	
-	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	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	
-	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	2119798-2	DETENT PIN	145	
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143	
-	-	-	1	2119653-2	FEED CAM, POST FEED	142	
-	1	1	1	2-2119656-2	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140	
-	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67	
-	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	
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	-	-	1	1338685-1	PAWL, FEED	56	
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53	
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	690753-2	SPACER, TONKER	50	
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38	
-	1	1	1	1752356-4	SUPPORT, TERMINAL	34	
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32	
-	1	1	1	1320908-7	SPACER, STRIP GUIDE	30	
-	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1320928-4	STRIP GUIDE	24	
-	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1-356885-4	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	1333206-2	ANVIL, COMBINATION .100	8	
-	1	1	1	6-240641-3	SPACER	7	
-	1	1	1	2119781-5	DEPRESSOR, SHEAR	5	
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	1	1	1633996-3	CRIMPER, INSULATION SPECIAL	3	
-	1	1	1	455888-7	SPACER, CRIMPER	2	
1	1	1	1	1-456407-3	CRIMPER, WIRE PREMIUM	1	
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

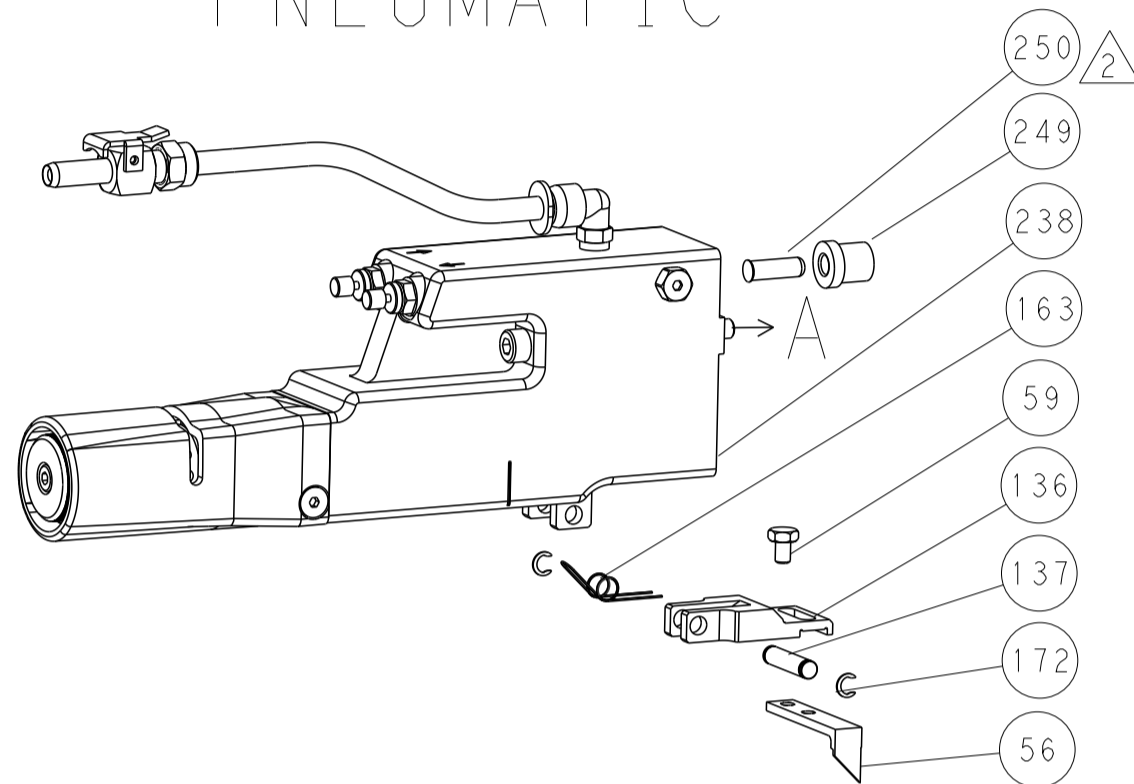
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	1 PLC	±			
	2 PLC	±			
	3 PLC	±			
	4 PLC	±			
	5 PLC	±			
	6 PLC	±			
	ANGLES	±			
	FINISH	±			
MATERIAL				SCALE	1:2
				SHEET	3 OF 4
				REV	D

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

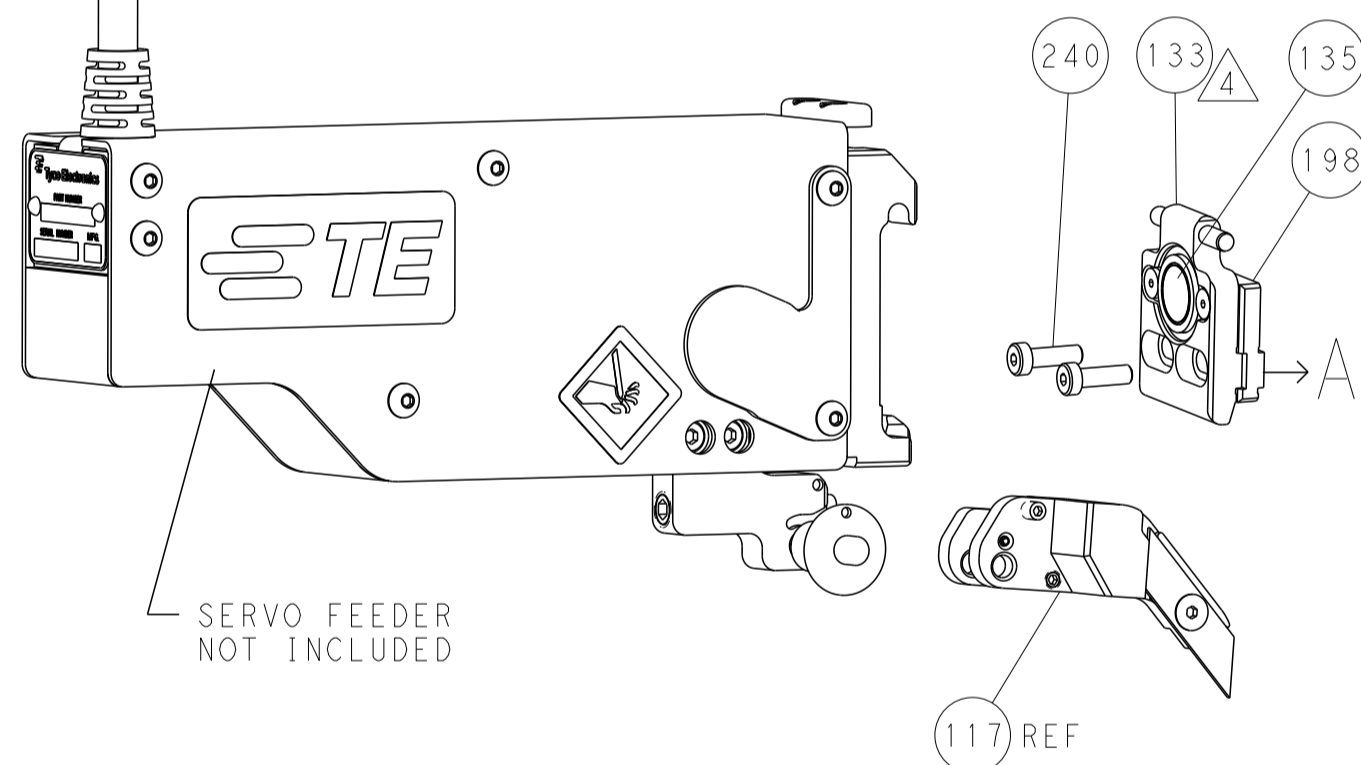
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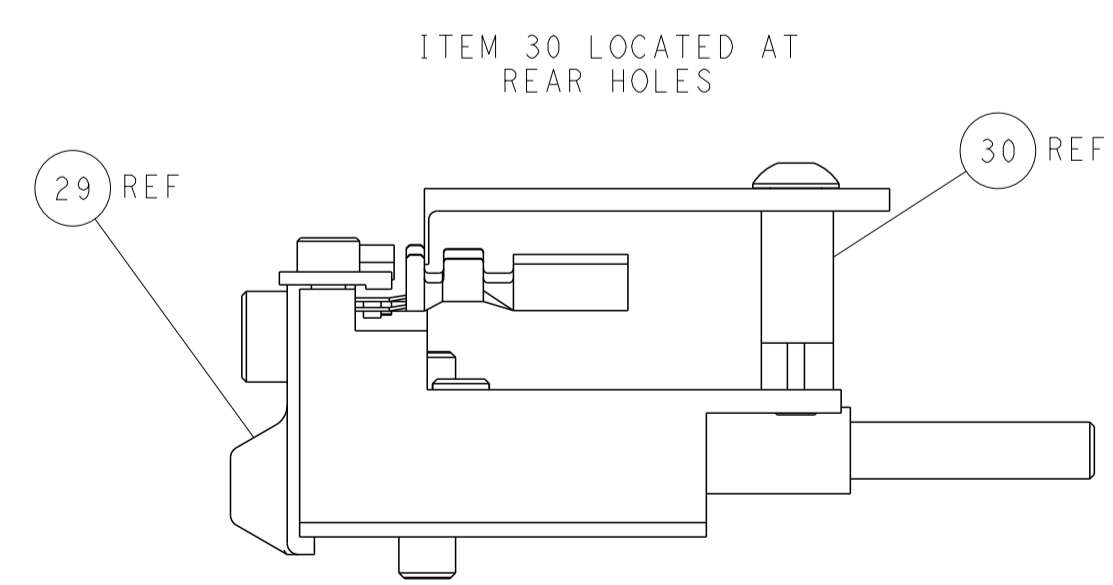
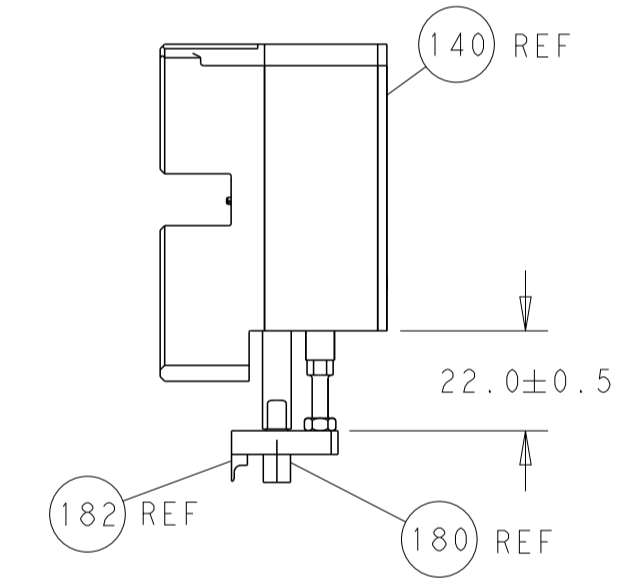
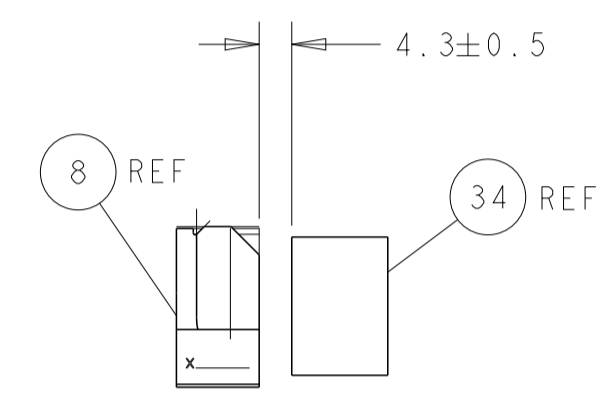
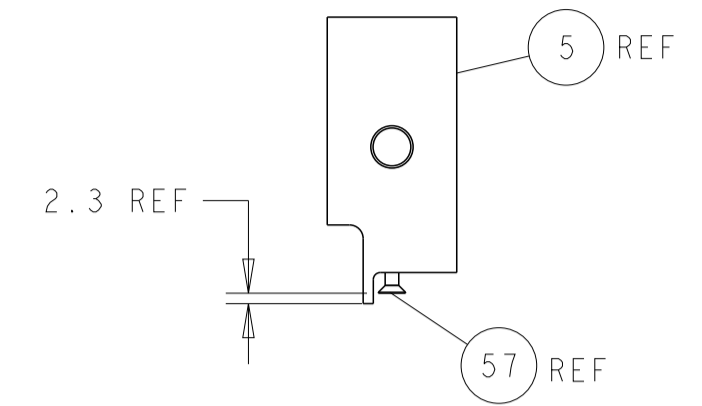
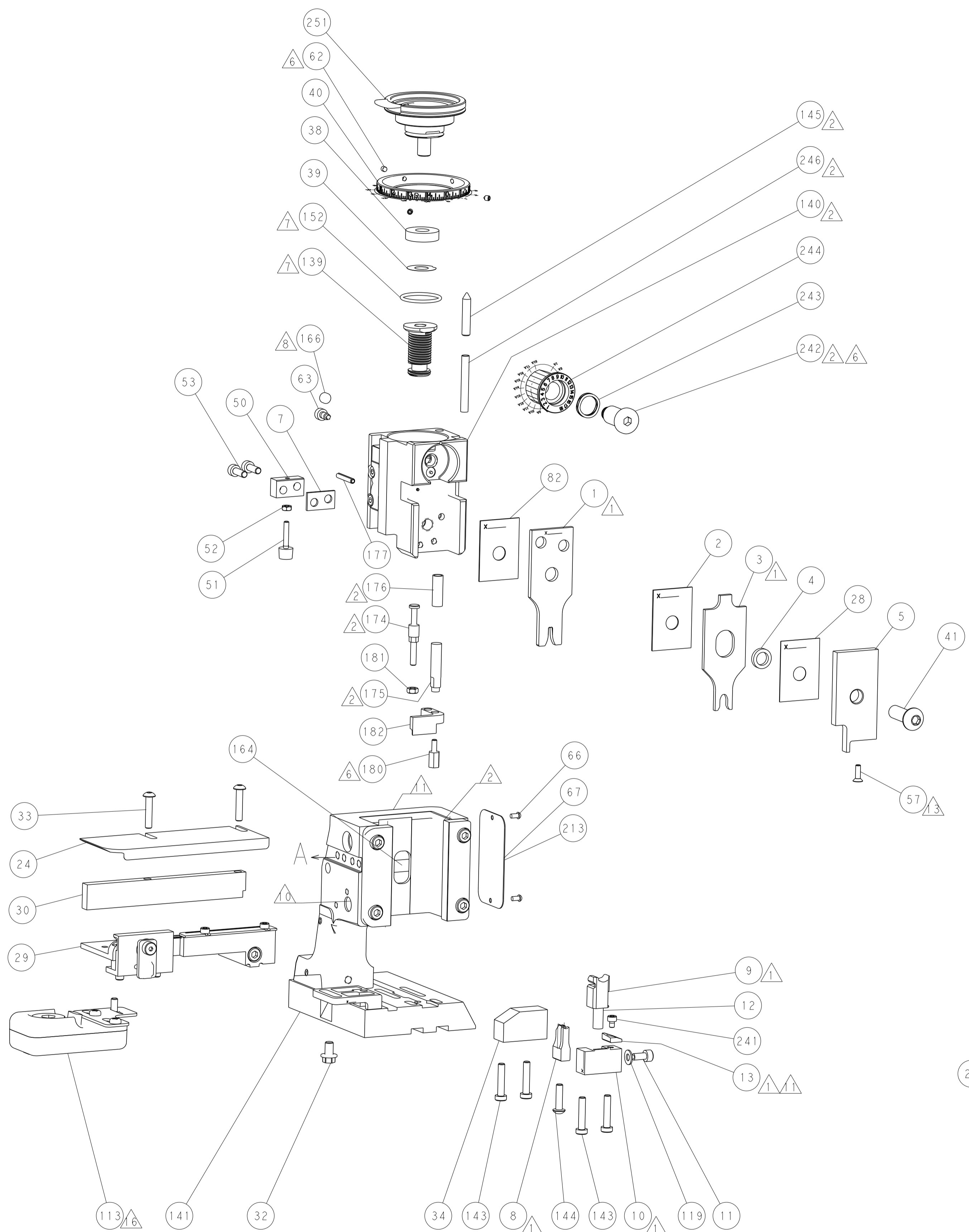
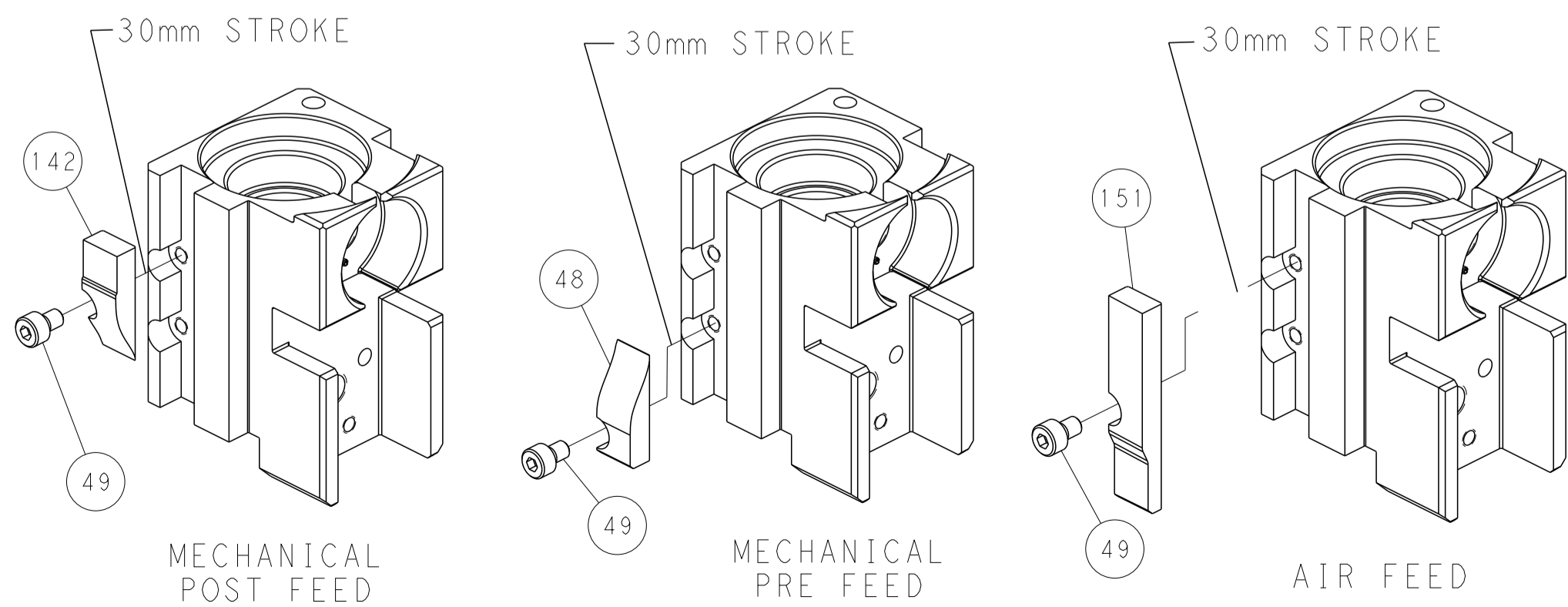
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: H. HUANG 11OCT2013		CHK: L. ZHANG 11OCT2013		APVD: H. GUO 11OCT2013		NAME: Ocean Side Feed Applicator	
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	Customer Accessible Production Drawing			
	1 PLC	±		SCALE	1:2	SHEET 4 OF 4	REV D				
	2 PLC	±									
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									
	FINISH	±									
MATERIAL:				WEIGHT:		A1 00779		C=2266074			