

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |   |
|---|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|---|
|   |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |   |
|   |             |          |                          |                                |                                   |                       |           |             |           |           |                        |   |
|   | 2266232-1   | D        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 1338685-2 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |   |
|   |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266232-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |   |
|   | 2266232-2   | D        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-2 | 5-18022-5   | 2119653-1 | -         | -                      |   |
|   |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266232-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |   |
|   | 2266232-5   | D        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 1338685-2 | 5-18022-5   | 2119653-1 | -         | -                      |   |
|   |             |          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1338685-2 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |   |
|   | 2266232-6   | D        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | -                                 | -                     | -         | -           | -         | -         | -                      |   |
|   |             |          |                          |                                | -                                 | -                     | -         | -           | -         | -         | -                      | - |
|   | 2266232-7   | D        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -         | -                      |   |
|   |             |          |                          |                                | -                                 | -                     | -         | -           | -         | -         | -                      | - |
|   | 7-2266232-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -         | -                      |   |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 2.69 mm [1.06] | F    |
| INSUL           | 4.83 mm [1.90] | O    |

APPLICATOR INSTRUCTIONS 408-10389

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                           |           |                |                             |
|---|---------------------------|-----------|----------------|-----------------------------|
| TERMINAL NAME: 2.8 SYSTEM SEALED CONNECTOR                |                           |           |                |                             |
| WIRE STRIP LENGTH   | INSULATION DIAMETER RANGE |           |                |                             |
| 5.00-5.50 mm [1.97-.217 IN]                               | Ø 1.3                     |           |                |                             |
| TERMINAL APPLICATION SPECIFICATION                        | YVES 72-WT10-1732-1       |           |                |                             |
| TERMINALS APPLIED   |                           |           |                |                             |
| TE TERMINAL   | YAZAKI TERMINAL           | TE SEAL   | YAZAKI SEAL    | CABLE DIAMETER <sup>3</sup> |
| 1949063-1   | 7116-4152-02              | 1572716-3 | 15324980       | Ø 2.81-3.49                 |
|   |                           | 2137609-1 | 7158-3113-40   | Ø 2.10-3.00                 |
|   |                           |           | AE WIRING SEAL |                             |
|   |                           | 1572716-4 | 024625A        | Ø 2.81-3.49                 |

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                           |           |                |                             |
|---|---------------------------|-----------|----------------|-----------------------------|
| TERMINAL NAME: 2.8 SYSTEM SEALED CONNECTOR                |                           |           |                |                             |
| WIRE STRIP LENGTH   | INSULATION DIAMETER RANGE |           |                |                             |
| 5.00-5.50 mm [1.97-.217 IN]                               | Ø 1.3                     |           |                |                             |
| TERMINAL APPLICATION SPECIFICATION                        | YVES 72-WT0G-472          |           |                |                             |
| TERMINALS APPLIED   |                           |           |                |                             |
| TE TERMINAL   | YAZAKI TERMINAL           | TE SEAL   | TE SEAL        | CABLE DIAMETER <sup>3</sup> |
|   |                           | 1572716-3 | 15324980       | Ø 2.81-3.49                 |
|   |                           | 2137609-1 | 7158-3113-40   | Ø 2.10-3.00                 |
|   |                           |           | AE WIRING SEAL |                             |
|   |                           | 1572716-4 | 024625A        | Ø 2.81-3.49                 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 2.50mm2   | 1.80+/-0.05 [0.071+/-0.002] | 4.8                            |
| 2.00mm2   | 1.60+/-0.05 [0.063+/-0.002] | 6.0                            |
| 1.50mm2   | 1.50+/-0.05 [0.059+/-0.002] | 7.8                            |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 2.50mm2   | 1.70+/-0.05 [0.067+/-0.002] | 6.4                            |
| 2.00mm2   | 1.60+/-0.05 [0.063+/-0.002] | 7.7                            |
| 1.50mm2   | 1.45+/-0.05 [0.057+/-0.002] | 9.1                            |

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
  - MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266232-4
  - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266232-4
  - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266232-5
  - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266232-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62. 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.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>12</sup> WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.00.
- <sup>13</sup> THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- <sup>14</sup> 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.

**\*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  | 1  | 455888-4  | SPACER, CRIMPER                 | 261     |
| -   | -  | 1  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| -   | 1  | 1  | 1  | 1  | 1  | 1803078-3 | SPACER, PRECISION               | 259     |
| -   | 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     |
| -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)

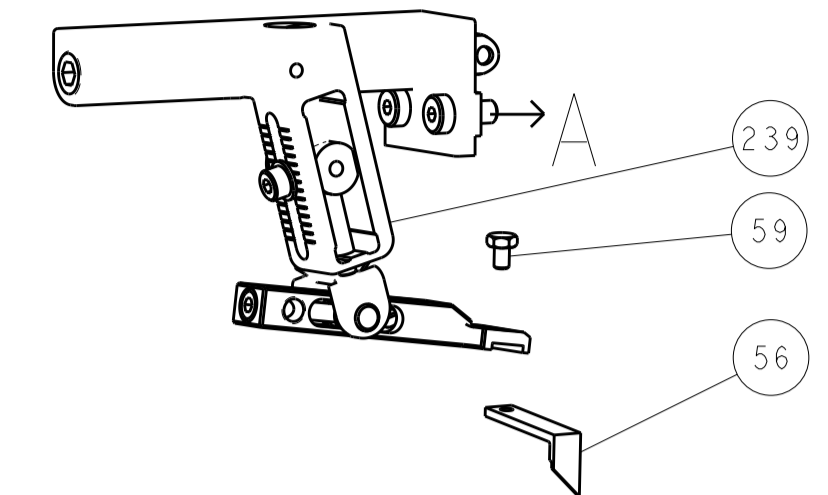
| SET UP GAUGE |  | LOC | DIST | REVISIONS |     |               |           |     |      |
|--------------|--|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-1    |  | A   | 66   | P         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|              |  |     |      | B         |     | ECR-14-014148 | 22SEP2014 | LG  | GB   |
|              |  |     |      | C         |     | ECR-15-007512 | 14MAY2015 | GH  | GB   |
|              |  |     |      | D         |     | ECR-15-018323 | 17DEC2015 | JH  | TE   |

|     |     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | -   | 1   | 1   | 1   | 2119798-1   | DETENT PIN                          | 247     |
| -   | 1   | -   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246     |
| -   | -   | 1   | -   | -   | -   | 2161314-1   | RAM, STEPPED, ATLANTIC, SF, 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     |
| -   | -   | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172     |
| -   | 1   | 1   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166     |
| -   | REF | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164     |
| -   | -   | -   | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163     |
| -   | -   | -   | -   | 1   | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137     |
| -   | -   | -   | -   | 1   | -   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136     |
| -   | -   | REF | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135     |
| -   | -   | 1   | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133     |
| -   | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 1   | 318563-1    | GUARD, FRONT CHIP                   | 89      |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-8    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69      |
| -   | 1   | -   | -   | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -   | 2   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| -   | 1   | -   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| -   | 3   | -   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62      |
| -   | 1   | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60      |
| -   | -   | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | 1   | 1   | 1   | 1   | 1   | 985575-3    | SCR, FLT SKT HD CAP M3 X 10.0       | 57      |
| -   | -   | -   | -   | 1   | 1   | 1338683-8   | FEED PAWL                           | 56      |
| -   | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54      |
| -   | 2   | 2   | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53      |
| -   | 1   | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52      |
| -   | 1   | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51      |
| -   | 1   | 1   | 1   | 1   | 1   | 690753-6    | SPACER, TONKER                      | 50      |
| -   | -   | -   | -   | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -   | -   | -   | -   | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48      |
| -   | -   | -   | -   | -   | 1   | 2119653-1   | FEED CAM, POST FEED                 | 47      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46      |
| -   | 1   | -   | 1   | 1   | 1   | 2161311-1   | RAM, STEPPED, AMP STYLE, SIDE FEED  | 44      |
| -   | 1   | 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   | 1   | 1-2119644-2 | 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   | 1752356-1   | 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   | 1-1320908-0 | 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   | 1320928-5   | 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   | 318707-1    | FLOATING SHEAR, FRONT               | 9       |
| -   | 1   | 1   | 1   | 1   | 1   | 7-1633927-8 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1   | 1-2119781-0 | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 1   | 3-238011-3  | BLOCK, CRIMPER SPACER               | 4       |
| -   | 1   | 1   | 1   | 1   | 1   | 4-2119784-4 | CRIMPER, INSULATION O PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 1   | 1-455888-7  | SPACER, CRIMPER                     | 2       |
| -   | 1   | 1   | 1   | 1   | 1   | 2-1490019-0 | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

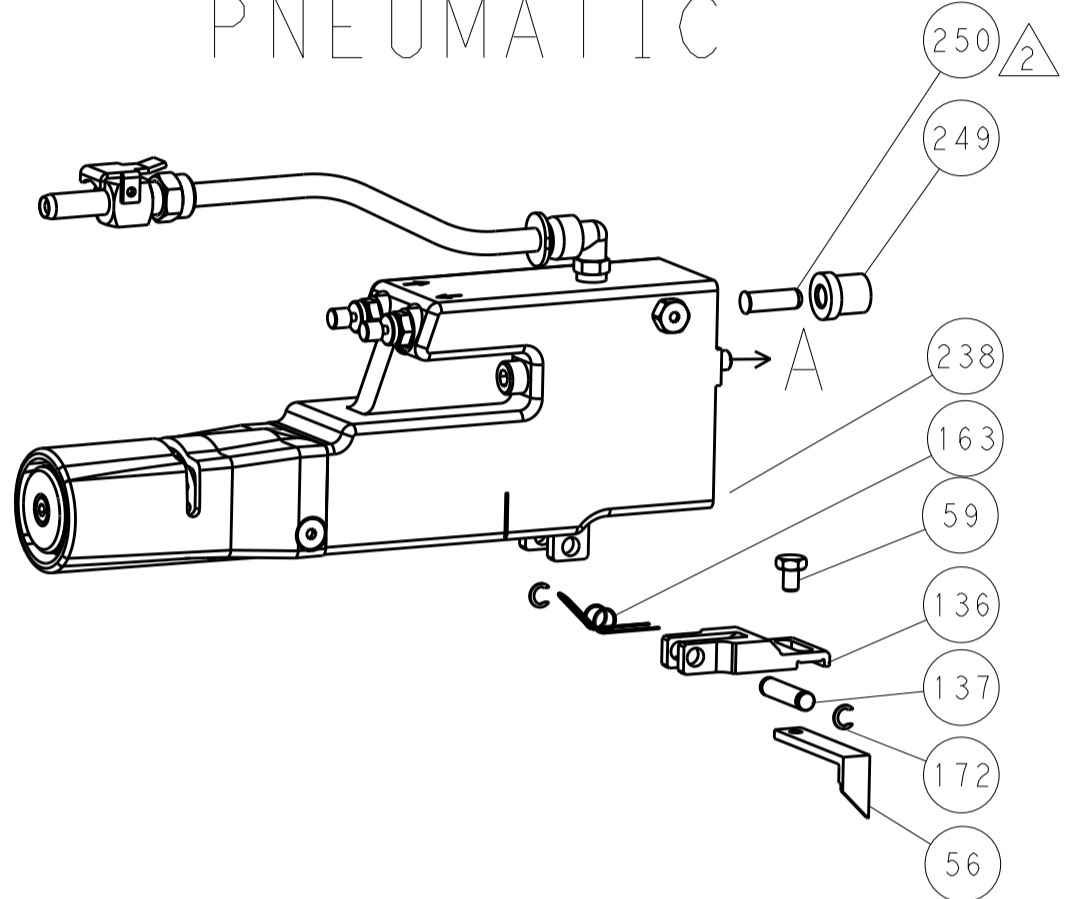
| DIMENSIONS: |       | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | OWN     | CHK      | APVD     | DATE      | TE Connectivity   |  |
|-------------|-------|--|--|---------|----------|----------|-----------|---|--|
| mm          | 0 PLC | ±                                      |  | HOFFNER | T. ELBIN | T. ELBIN | 07MAR2014 | Harrisburg, PA 17105-3608   |  |
|             | 1 PLC | ±                                      |  |         |          |          |           | Ocean Side Feed Applicator  |  |
|             | 2 PLC | ±                                      |  |         |          |          |           | SIZE CAGE CODE DRAWING NO RESTRICTED TO                             |  |
|             | 3 PLC | ±                                      |  |         |          |          |           | A1 00779 ©=2266232  |  |
|             | 4 PLC | ±                                      |  |         |          |          |           | Customer Accessible Production Drawing SCALE 1:2 SHEET 1 of 4 REV D |  |

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

### FEED TYPE MECHANICAL



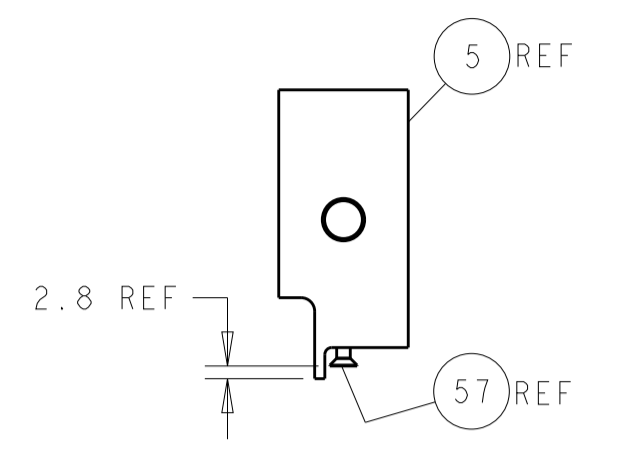
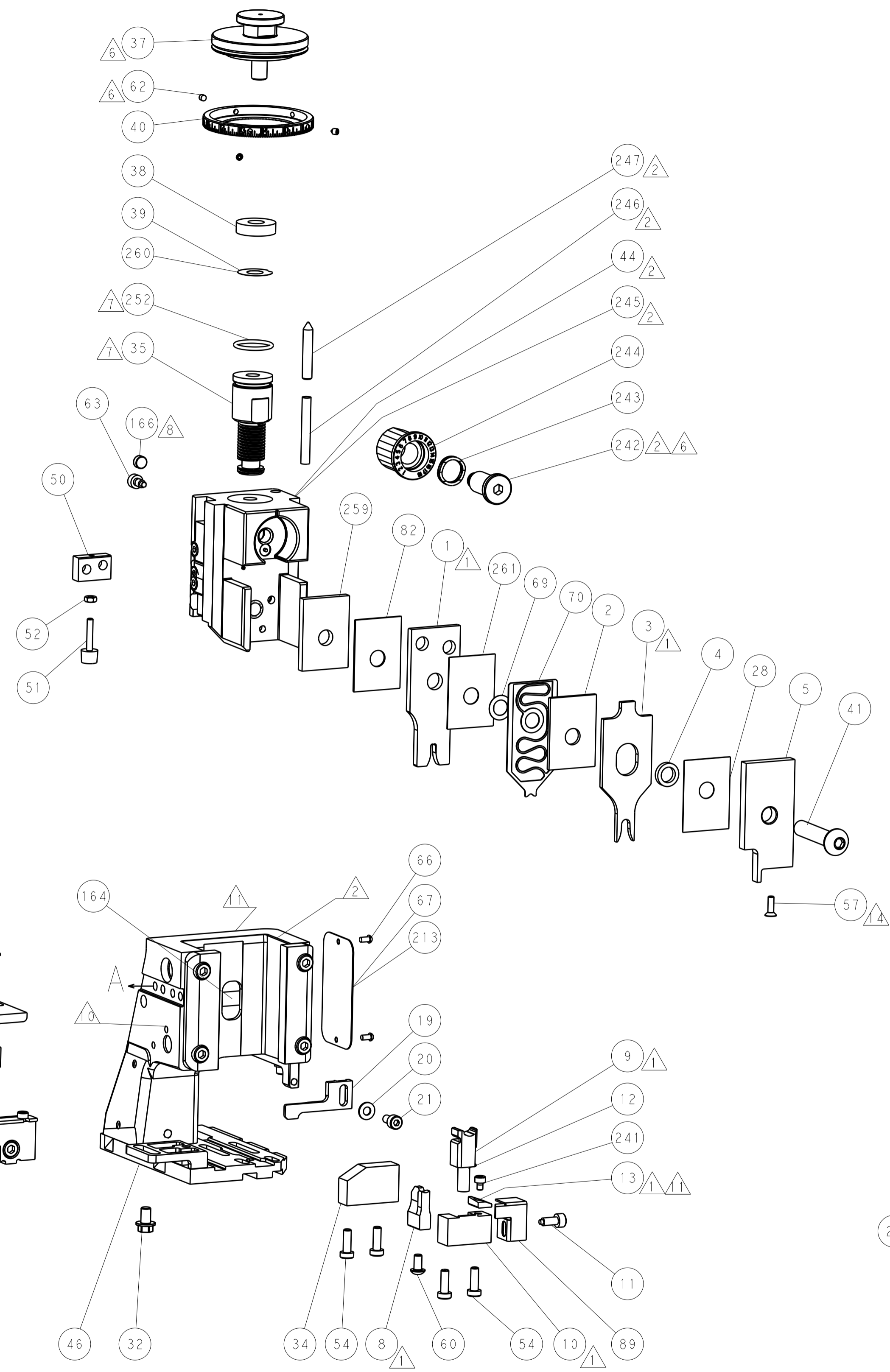
### PNEUMATIC



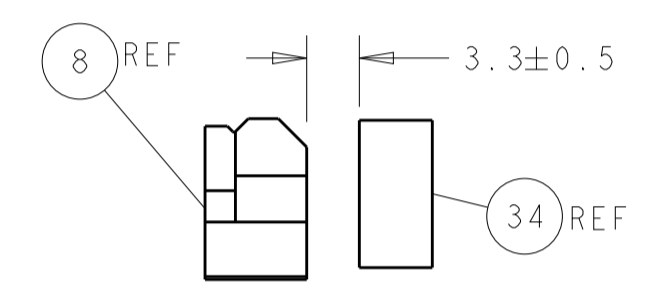
### SERVO LATCH PLATE



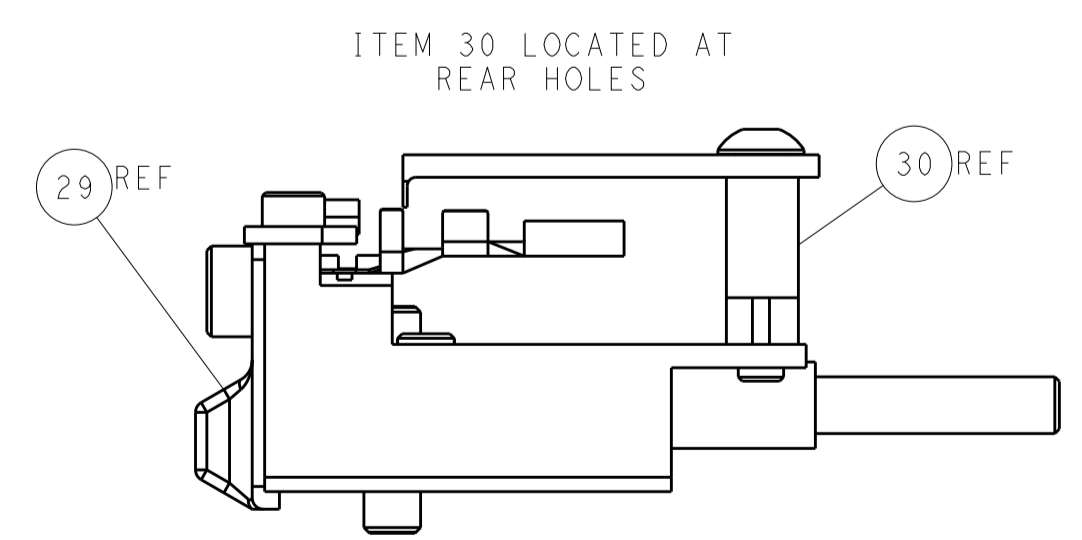
### CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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: |         | OWN: HOFFNER 06MAR2014                 |         | TE Connectivity                  |                           |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                                | 4 PLC ± | 5 PLC ±                          | Harrisburg, PA 17105-3608 |
| MATERIAL:   |         | FINISH:                                |         | APVD: T. ELBIN 07MAR2014               |         | NAME: Ocean Side Feed Applicator |                           |
|             |         |  |         | PRODUCT SPEC:                          |         | RESTRICTED TO:                   |                           |
|             |         |  |         | APPLICATION SPEC:                      |         | SIZE: CAGE CODE: DRAWING NO:     |                           |
|             |         |  |         | WEIGHT:                                |         | A1 00779 ©=2266232               |                           |
|             |         |  |         | Customer Accessible Production Drawing |         | SCALE: 1:2 SHEET 2 OF 4 REV D    |                           |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|  |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|  | 2-2266232-1 | D        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED                    | 2119950-1             | 1338685-2 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266232-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266232-4 | -         | -         | -                      |
|  | 2-2266232-2 | D        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | MECHANICAL FEED                   | 2119949-1             | 1338685-2 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266232-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266232-4 | -         | -         | -                      |
|  | 2-2266232-5 | D        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED                   | 2119949-1             | 1338685-2 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                   | PNEUMATIC FEED                    | 2119950-1             | 1338685-2 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  | 2-2266232-7 | D        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | -         | -                      |
|  | 7-2266232-7 | A        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.69 mm [.106] | F    |
| INSUL                                | 4.83 mm [.190] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                     |                           |                |                |
|---|---------------------|---------------------------|----------------|----------------|
| TERMINAL NAME: 2.8 SYSTEM SEALED CONNECTOR                |                     |                           |                |                |
| WIRE STRIP LENGTH   |                     | INSULATION DIAMETER RANGE |                |                |
| 5.00-5.50 mm [.197-.217 IN]                               |                     | Ø                         |                |                |
| TERMINAL APPLICATION SPECIFICATION                        | YPES 72-WT10-1732-1 |                           |                |                |
| TERMINALS APPLIED   |                     |                           |                |                |
| TE TERMINAL   | YAZAKI TERMINAL     | TE SEAL                   | YAZAKI SEAL    | CABLE DIAMETER |
| 1949063-1   | 7116-4152-02        | 1572716-3                 | 15324980       | Ø2.81-3.49     |
|   |                     | 2137609-1                 | 7158-3113-40   | Ø2.10-3.00     |
|   |                     |                           | AE WIRING SEAL |                |
|   |                     | 1572716-4                 | 024625A        | Ø2.81-3.49     |

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                  |                           |                |                |
|---|------------------|---------------------------|----------------|----------------|
| TERMINAL NAME: 2.8 SYSTEM SEALED CONNECTOR                |                  |                           |                |                |
| WIRE STRIP LENGTH   |                  | INSULATION DIAMETER RANGE |                |                |
| 5.00-5.50 mm [.197-.217 IN]                               |                  | Ø                         |                |                |
| TERMINAL APPLICATION SPECIFICATION                        | YPES 72-WT0G-472 |                           |                |                |
| TERMINALS APPLIED   |                  |                           |                |                |
| TE TERMINAL   | YAZAKI TERMINAL  | TE SEAL                   | TE SEAL        | CABLE DIAMETER |
| 1572463-1   | 7114-4152-02     | 1572716-3                 | 15324980       | Ø2.81-3.49     |
|   |                  | 2137609-1                 | 7158-3113-40   | Ø2.10-3.00     |
|   |                  |                           | AE WIRING SEAL |                |
|   |                  | 1572716-4                 | 024625A        | Ø2.81-3.49     |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 2.50mm2   | 1.80+/-0.05 [.071+/- .002] | 4.8                            |
| 2.00mm2   | 1.60+/-0.05 [.063+/- .002] | 6.0                            |
| 1.50mm2   | 1.50+/-0.05 [.059+/- .002] | 7.8                            |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 2.50mm2   | 1.70+/-0.05 [.067+/- .002] | 6.4                            |
| 2.00mm2   | 1.60+/-0.05 [.063+/- .002] | 7.7                            |
| 1.50mm2   | 1.45+/-0.05 [.057+/- .002] | 9.1                            |

- 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: 8-2266232-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266232-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266232-5
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
- 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.

**\*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   | 455888-4  | SPACER, CRIMPER                     | 261     |
| -   | 1   | 1   | 1   | 1   | 1803078-3 | SPACER, PRECISION                   | 259     |
| -   | 1   | 1   | 1   | 1   | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |
| -   | -   | -   | -   | -   | 2119640-1 | PUSH ROD, AIR FEED                  | 250     |
| -   | -   | -   | -   | -   | 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)

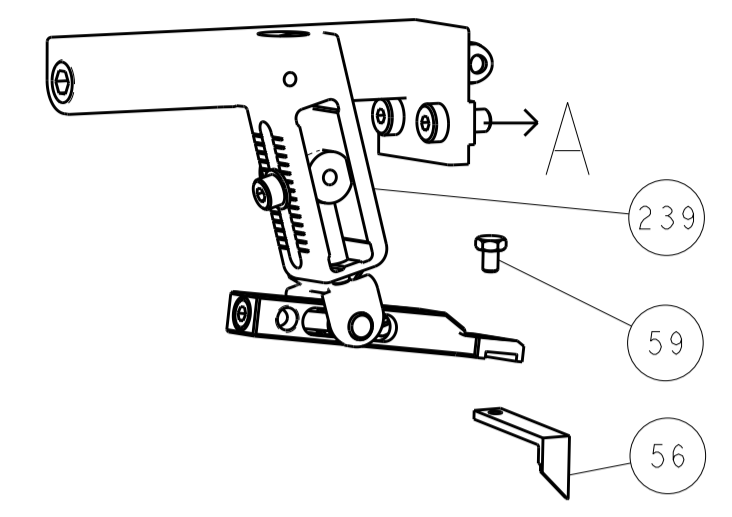
| SET UP GAUGE | LOC | DIST | REVISIONS |             |    |      |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-1    | A   | 66   | REV       | DATE        | BY | APPV |
|              |     |      | -         | SEE SHEET 1 |    |      |

|     |     |     |     |     |             |                                      |         |
|-----|-----|-----|-----|-----|-------------|--------------------------------------|---------|
| -   | 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     |
| -   | -   | -   | -   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16        | 240     |
| -   | -   | -   | -   | -   | 2119580-1   | MECHANICAL FEED ASSEMBLY             | 239     |
| -   | -   | -   | -   | -   | 2063440-1   | AIR FEED MODULE                      | 238     |
| -   | -   | -   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                  | 213     |
| -   | -   | -   | -   | -   | 1901094-3   | SPACER, FEEDER                       | 198     |
| -   | -   | -   | -   | -   | 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     |
| -   | -   | -   | -   | -   | 240638-1    | SPRING, FEED FINGER                  | 163     |
| -   | 1   | 1   | 1   | 1   | 8-21084-1   | O-RING, .801 ID, .070 DIA. MAT.      | 152     |
| -   | -   | -   | -   | -   | 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   | 4   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20        | 143     |
| -   | -   | -   | -   | -   | 2119653-2   | FEED CAM, POST FEED                  | 142     |
| -   | 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     |
| -   | 1   | 1   | 1   | 1   | 2119092-2   | BOLT, ADJUSTMENT                     | 139     |
| -   | -   | -   | -   | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854       | 137     |
| -   | -   | -   | -   | -   | 2119799-1   | HOLDER, FEED FINGER, AF              | 136     |
| -   | -   | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED              | 135     |
| -   | -   | -   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                 | 133     |
| -   | -   | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF             | 117     |
| -   | 1   | 1   | 1   | 1   | 318563-1    | GUARD, FRONT CHIP                    | 89      |
| -   | 1   | 1   | 1   | 1   | 455888-8    | SPACER, CRIMPER                      | 82      |
| -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE                | 71      |
| -   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                      | 70      |
| -   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                       | 69      |
| -   | 1   | -   | -   | -   | 2119740-1   | TAG, IDENTIFICATION                  | 67      |
| -   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188     | 66      |
| -   | 1   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT             | 63      |
| -   | 3   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0  | 62      |
| -   | -   | -   | -   | -   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0            | 59      |
| -   | 1   | 1   | 1   | 1   | 985575-3    | SCR, FLT SKT HD CAP M3 X 10.0        | 57      |
| -   | -   | -   | -   | -   | 1338683-8   | FEED PAWL                            | 56      |
| -   | 2   | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10       | 53      |
| -   | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3              | 52      |
| -   | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                    | 51      |
| -   | 1   | 1   | 1   | 1   | 690753-6    | SPACER, TONKER                       | 50      |
| -   | -   | -   | -   | -   | 18023-9     | SCR, SKT HD CAP M4 X 6.0             | 49      |
| -   | -   | -   | -   | -   | 2119652-1   | FEED CAM, PRE FEED                   | 48      |
| -   | 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   | 1-2119644-2 | RAM WASHER, PRECISION                | 38      |
| -   | 1   | 1   | 1   | 1   | 1752356-1   | 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   | 1-1320908-0 | SPACER, STRIP GUIDE                  | 30      |
| -   | 1   | 1   | 1   | 1   | 2119959-2   | ASSEMBLY, STRIP GUIDE                | 29      |
| -   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                      | 28      |
| -   | 1   | 1   | 1   | 1   | 1320928-5   | 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   | 2119533-1   | STRIPPER, SIDE FEED                  | 19      |
| -   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                        | 13      |
| -   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                  | 12      |
| -   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                          | 11      |
| -   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                  | 10      |
| -   | 1   | 1   | 1   | 1   | 318707-1    | FLOATING SHEAR, FRONT                | 9       |
| -   | 1   | 1   | 1   | 1   | 7-1633927-8 | ANVIL, COMBINATION                   | 8       |
| -   | -   | -   | -   | -   | -           | -                                    | 7       |
| -   | -   | -   | -   | -   | -           | -                                    | 6       |
| -   | 1   | 1   | 1   | 1   | 1-2119781-0 | DEPRESSOR, SHEAR                     | 5       |
| -   | 1   | 1   | 1   | 1   | 3-238011-3  | BLOCK, CRIMPER SPACER                | 4       |
| -   | 1   | 1   | 1   | 1   | 4-2119784-4 | CRIMPER, INSULATION O PREMIUM        | 3       |
| -   | 1   | 1   | 1   | 1   | 1-455888-7  | SPACER, CRIMPER                      | 2       |
| -   | 1   | 1   | 1   | 1   | 2-1490019-0 | CRIMPER, WIRE PREMIUM                | 1       |
| -77 | -27 | -25 | -22 | -21 | PART NO     | DESCRIPTION                          | ITEM NO |

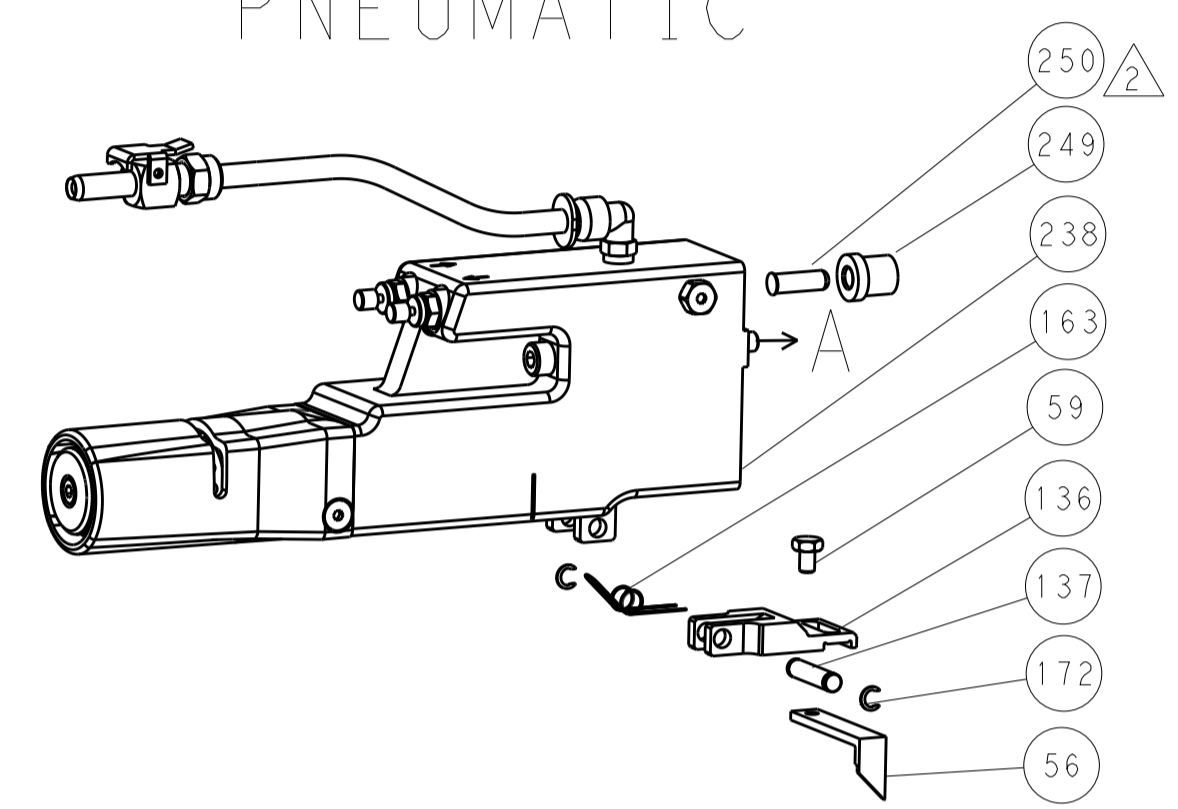
| DIMENSIONS:                            |        | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DATE      | BY      | APPV  | NAME                      |
|--|--------|--|--|-----------|---------|-------|---------------------------|
| mm                                     | 0 PLC  | ±                                      |  | 06MAR2014 | HOFFNER |       | TE Connectivity           |
|  | 1 PLC  | ±                                      |  | 07MAR2014 | ELBIN   |       | Harrisburg, PA 17105-3608 |
|  | 2 PLC  | ±                                      |  |           |         |       |                           |
|  | 3 PLC  | ±                                      |  |           |         |       |                           |
|  | 4 PLC  | ±                                      |  |           |         |       |                           |
|  | ANGLES | ±                                      |  |           |         |       |                           |
|  | FINISH | ±                                      |  |           |         |       |                           |
| MATERIAL                               |        |  |  | WEIGHT    |         |       |                           |
|  |        |  |  |           |         |       |                           |
| Customer Accessible Production Drawing |        |  |  | SCALE     | 1:2     | SHEET | 3 OF 4                    |
|  |        |  |  | REV       | D       |       |                           |

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

# FEED TYPE MECHANICAL



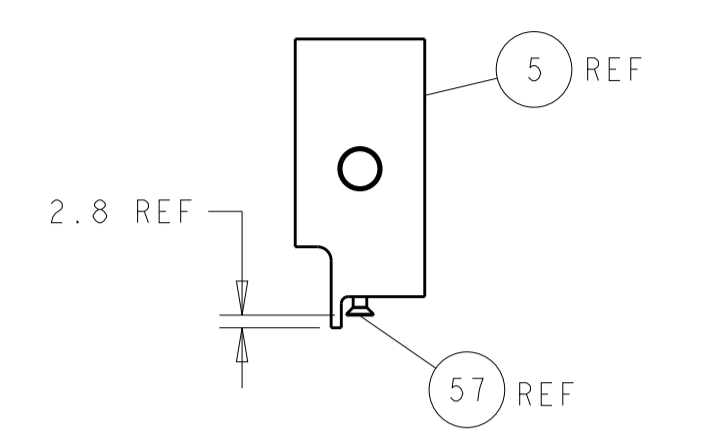
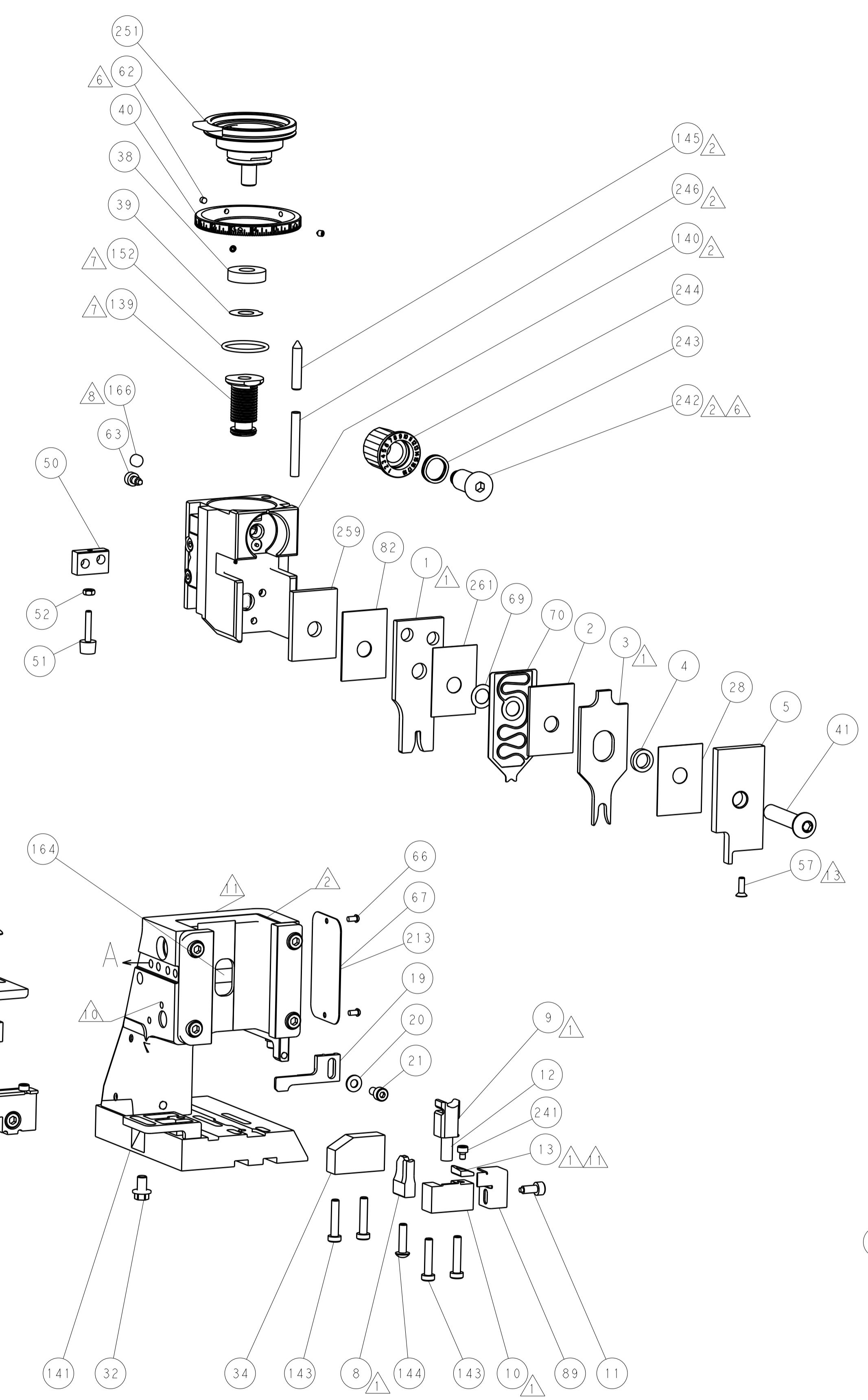
# PNEUMATIC



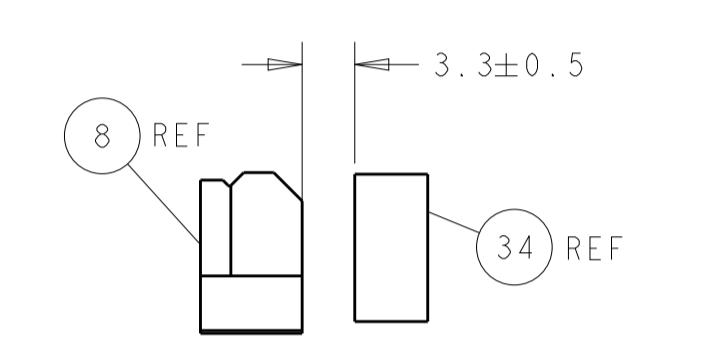
# SERVO LATCH PLATE



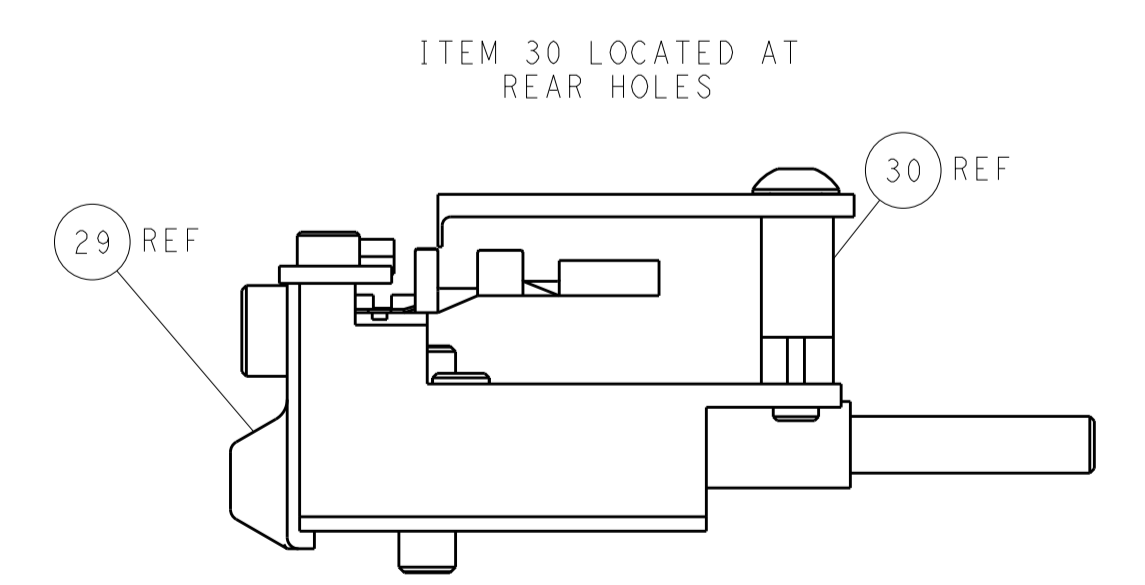
# CAM POSITIONS



SHEAR DEPRESSOR DETAIL



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)

|             |        |  |  |                          |  |                 |  |
|-------------|--------|--|--|--------------------------|--|-----------------|--|
| DIMENSIONS: |        | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DWG: HOFFNER 06MAR2014   |  | TE Connectivity |  |
| mm          | 0 PLC  | ±                                      |  | CHK: T. ELBIN 07MAR2014  | Harrisburg, PA 17105-3608                  |                 |  |
|             | 1 PLC  | ±                                      |  | APVD: T. ELBIN 07MAR2014 | NAME: Ocean Side Feed Applicator           |                 |  |
|             | 2 PLC  | ±                                      |  | PRODUCT SPEC             | SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO |                 |  |
|             | 3 PLC  | ±                                      |  | APPLICATION SPEC         | A1 00779 ©=2266232                         |                 |  |
|             | 4 PLC  | ±                                      |  | WEIGHT                   | Customer Accessible Production Drawing     |                 |  |
|             | ANGLES | ±                                      |  | SCALE: 1:2               | SHEET 4 OF 4 REV D                         |                 |  |