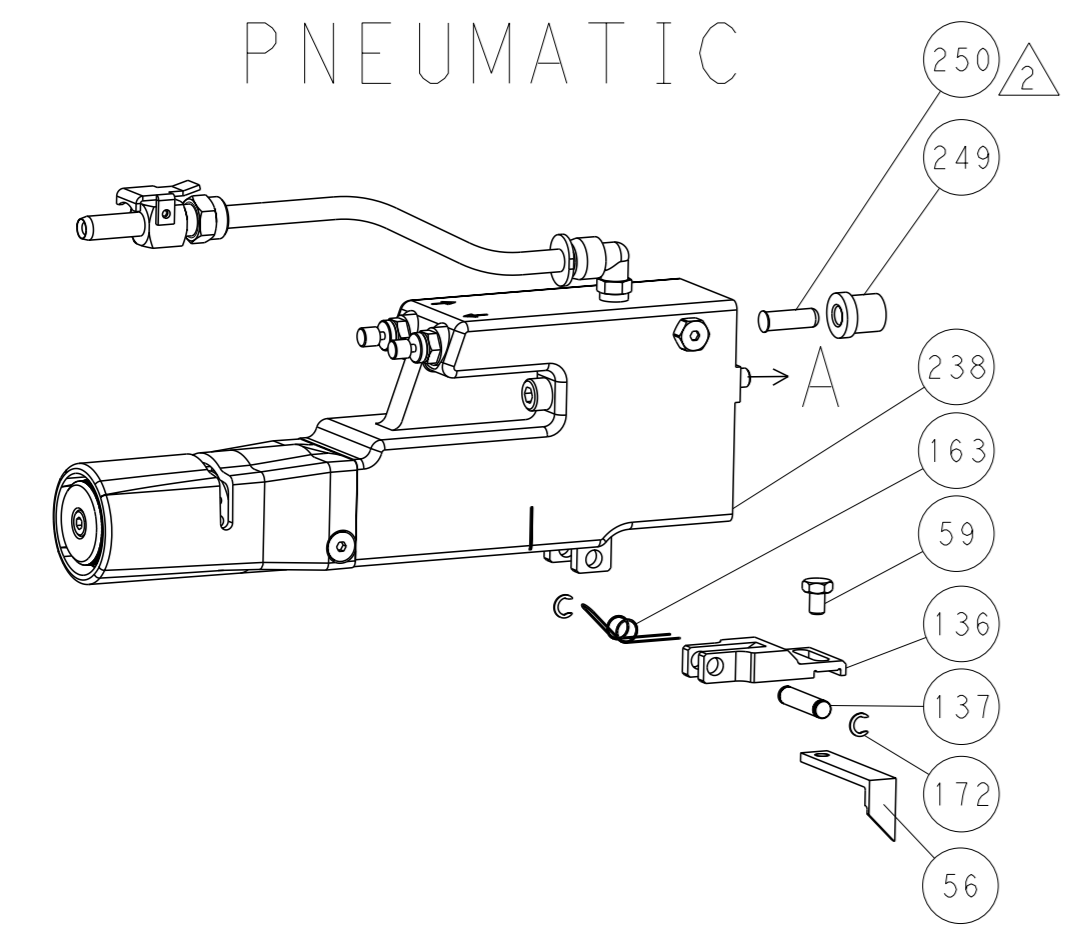




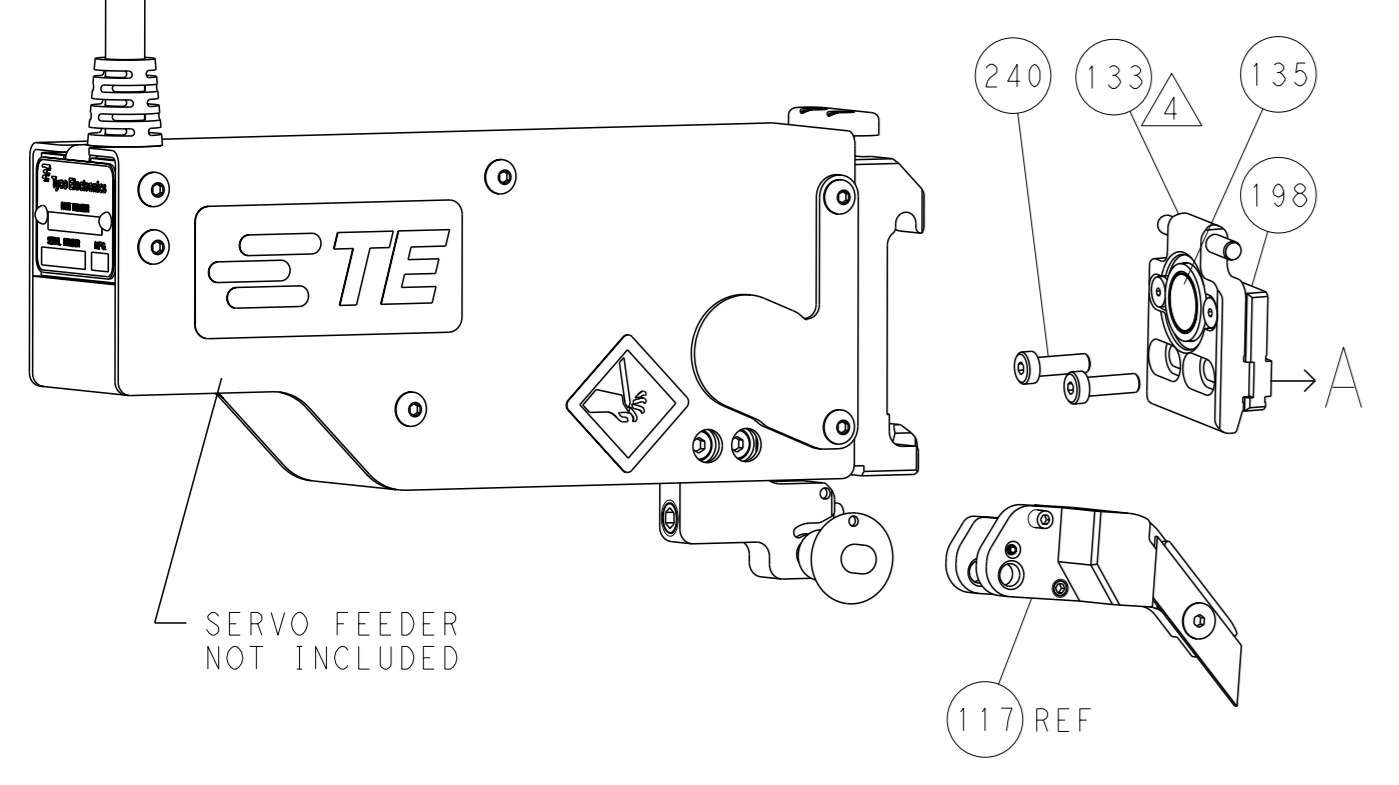
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|-----|-------------|-----------|------|-----|------|
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| -   | SEE SHEET 1 | -         | -    | -   | -    |

### FEED TYPE

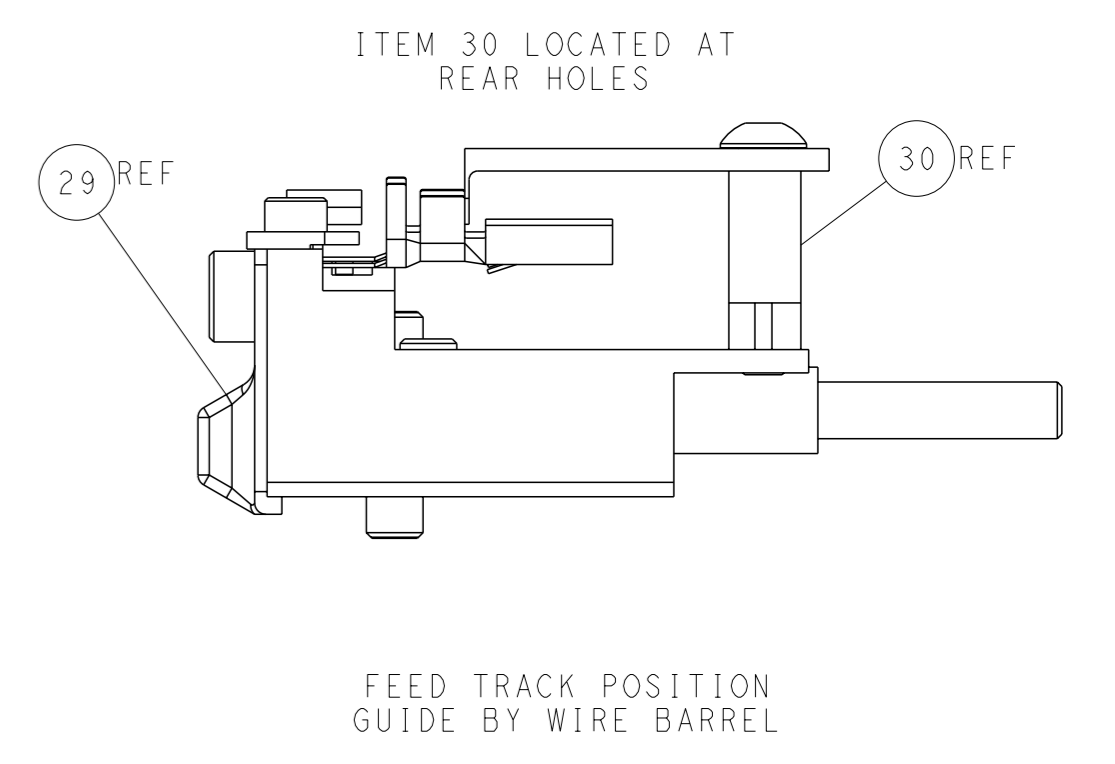
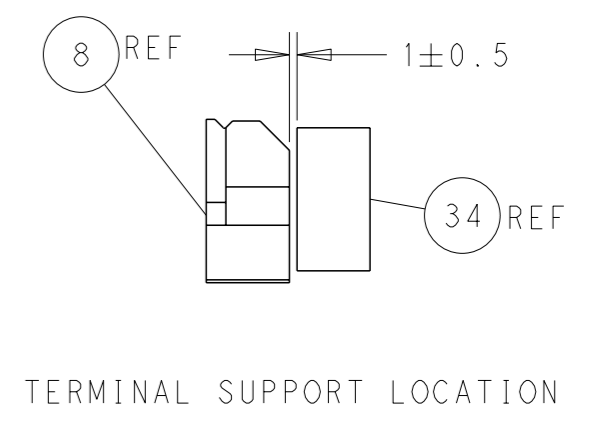
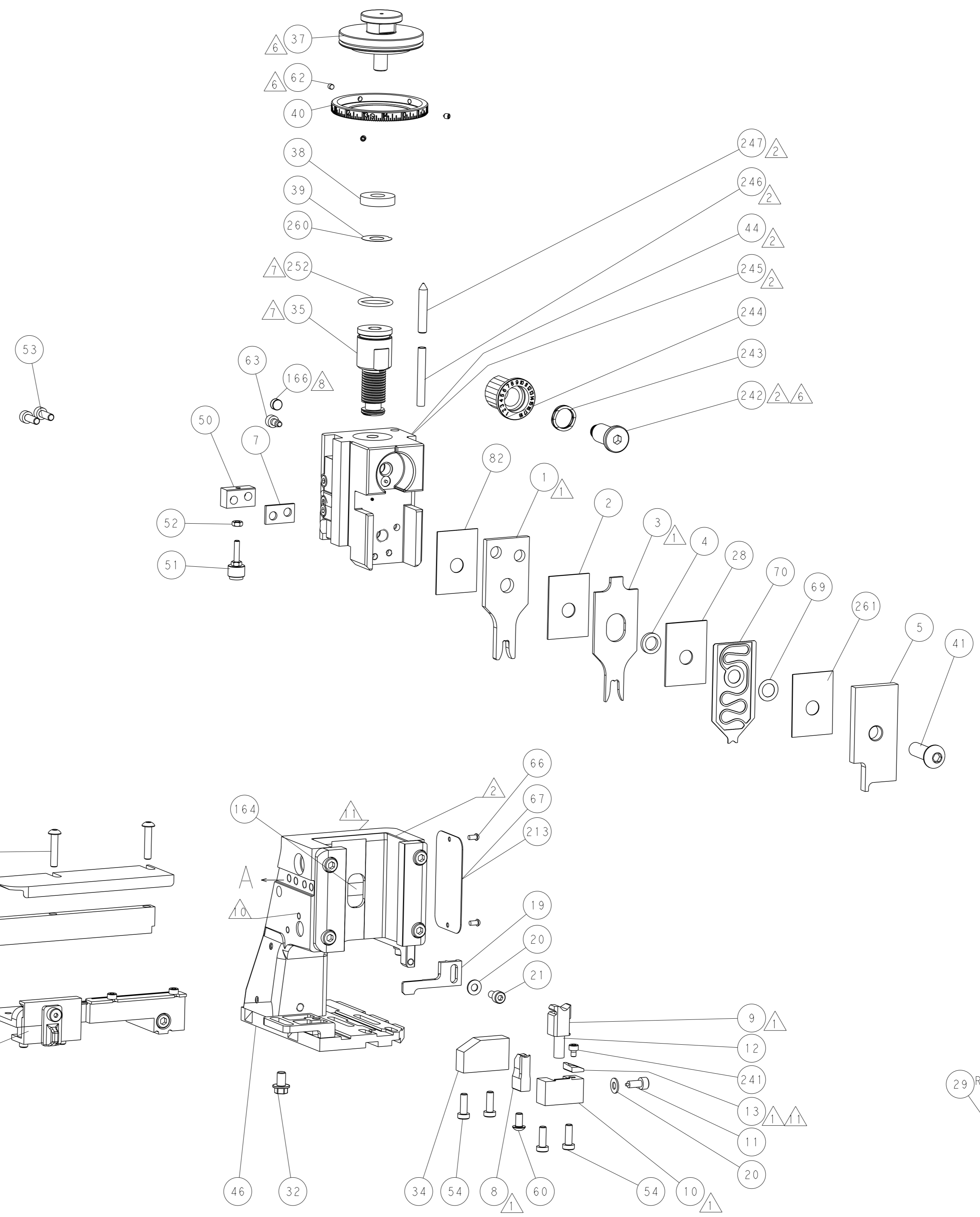
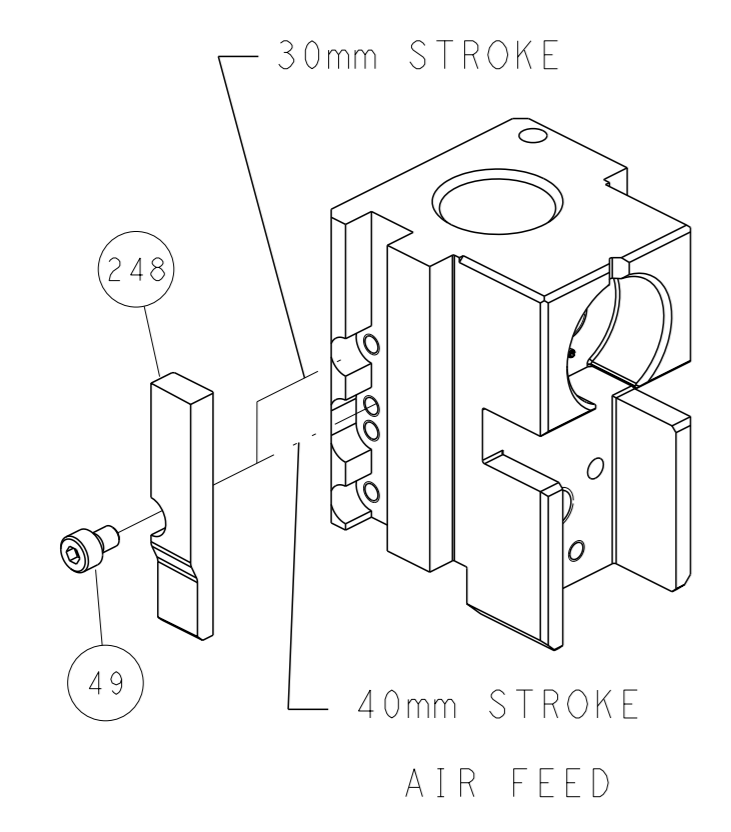
### PNEUMATIC



### SERVO LATCH PLATE

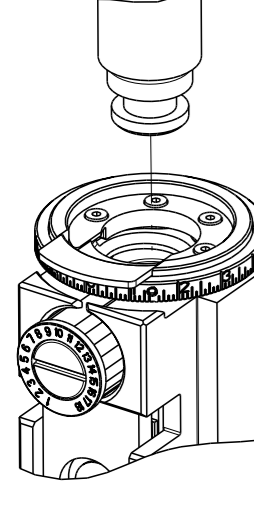




### CAM POSITION

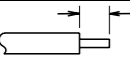




**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

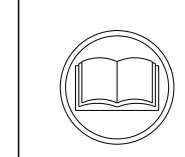
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|---|--|---|---|
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| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ±          |  | NAME Ocean Side Feed Applicator<br>APPLICATION SPEC<br>SIZE CAGE CODE DRAWING NO. 00779 C=2836190<br>WEIGHT<br>Customer Accessible Production Drawing | RESTRICTED TO<br>SCALE 1:2 SHEET 2 of 4 REV A |










| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER                                     | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE   | APPLICATOR STYLE CONVERSION CHART |                       |   |             |           |   |                        |
|--|-------------|----------|--------------------------|---|-----------------------------------|-----------------------|---|-------------|-----------|---|------------------------|
|  |             |          |                          |   | CONVERT TO                        | PART NUMBERS REQUIRED |   |             |           |   |                        |
|  | 2-2836190-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC   | SERVO LATCH PLATE                 | 2119951-1             | - | 8-2836190-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
|  | 2-2836190-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE  | -                                 | -                     | - | -           | -         | - | -                      |
|  | 2-2836190-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE  | -                                 | -                     | - | -           | -         | - | -                      |
|  | 7-2836190-7 | A        | CRIMP TOOLING KIT        | -   | -                                 | -                     | - | -           | -         | - | -                      |

| APPLICATOR DATA  |                |      |
|--|----------------|------|
| CRIMP  | SIZE           | TYPE |
| WIRE   | 3.89 mm [.153] | F    |
| INSUL  | 5.59 mm [.220] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389  |                |      |

| TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION  |               |                              |               |
|--|---------------|------------------------------|---------------|
| TERMINAL NAME: DFK 3 TERMINAL  |               |                              |               |
| WIRE STRIP LENGTH                   |               | INSULATION DIAMETER RANGE    |               |
| 5.60-6.40 mm [.220-.252 IN]  |               | Ø4.00-5.00 mm [.157-.197 IN] |               |
| TERMINAL APPLICATION SPECIFICATION  | 26233 Rev 3   | -                            | -             |
| TERMINALS APPLIED                   |               |                              |               |
| TE TERMINAL  | LEAR TERMINAL | TE TERMINAL                  | LEAR TERMINAL |
| 2113956-1  | 26233.331.XXX | 2113956-3                    | 26233.201.XXX |
| 2113956-2  | 26233.306.XXX | 2113956-4                    | 26233.163.XXX |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 6.00mm2   | 2.40+/-0.10 [.094+/-0.004] | 5.1                            |
| 4.00mm2   | 2.20+/-0.10 [.087+/-0.004] | 7.1                            |



-  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:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836190-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836190-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
-  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180.  
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.
-  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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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

| -77 | -27 | -25 | -22 | PART NO   | DESCRIPTION                         | ITEM NO |
|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 455888-5  | SPACER, CRIMPER                     | 261     |
| -   | 1   | 1   | 1   | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |
| -   | -   | -   | 1   | 2119640-1 | PUSH ROD, AIR FEED                  | 250     |

**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 |
| -            | -   | -    | 1         | -    | -  | -    |
| SEE SHEET 1  |     |      |           |      |    |      |

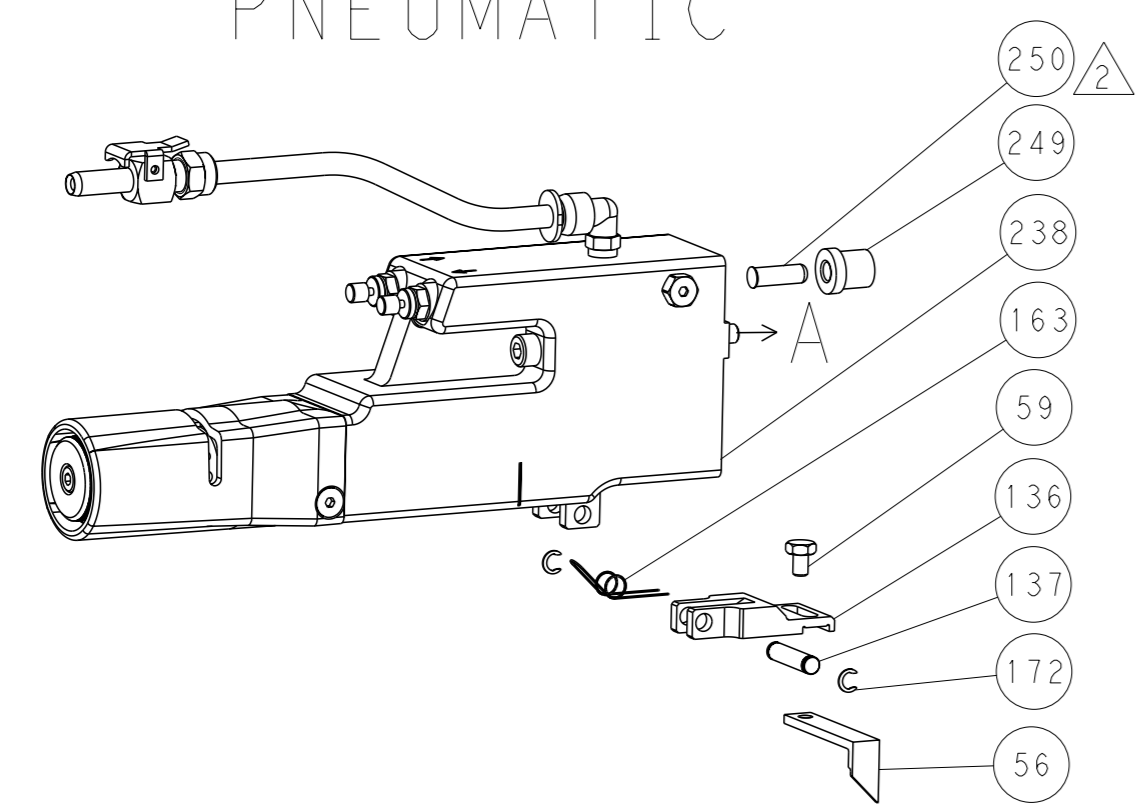
| REV | DATE | BY  | APPV | DESCRIPTION                                   |     |
|-----|------|-----|------|---|-----|
| -   | -    | -   | 1    | 2079988-1 BUSHING, LCH5-12, MISUMI            | 249 |
| -   | 1    | 1   | 1    | 1-22279-3 SPRING, COMPRESSION                 | 246 |
| -   | 1    | 1   | 1    | 2119082-6 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 |
| -   | -    | -   | -    | 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 |
| -   | -    | -   | 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 |
| -   | -    | -   | -    | 2119653-2 FEED CAM, POST FEED                 | 142 |
| -   | 1    | 1   | 1    | 1-2119656-0 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 |
| -   | -    | REF | -    | 2119944-1 FEED FINGER ASSEMBLY, SF            | 117 |
| -   | 1    | 1   | 1    | 455888-5 SPACER, CRIMPER                      | 82  |
| -   | 1    | 1   | 1    | 2119956-1 DOCUMENTATION PACKAGE               | 71  |
| -   | 1    | 1   | 1    | 2119791-6 DEPRESSOR, WIRE                     | 70  |
| -   | 1    | 1   | 1    | 2119943-1 WASHER, SPACER                      | 69  |
| -   | 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    | 1338683-8 FEED PAWL                           | 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  |
| -   | -    | -   | -    | 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    | 1-2119644-3 RAM WASHER, PRECISION             | 38  |
| -   | 1    | 1   | 1    | 3-1752356-3 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 SPACER, STRIP GUIDE                   | 30  |
| -   | 1    | 1   | 1    | 2119959-4 ASSEMBLY, STRIP GUIDE               | 29  |
| -   | 1    | 1   | 1    | 1-455888-0 SPACER, CRIMPER                    | 28  |
| -   | 1    | 1   | 1    | 240792-1 DRAG, TERMINAL                       | 25  |
| -   | 1    | 1   | 1    | 1320928-2 STRIP GUIDE                         | 24  |
| -   | 1    | 1   | 1    | 2168083-2 SCR, SKT HD CAP, RoHS, M4 x 8.0     | 21  |
| -   | 2    | 2   | 2    | 1-18028-2 WASHER, FLAT, REG M4                | 20  |
| -   | 1    | 1   | 1    | 2119533-1 STRIPPER, SIDE FEED                 | 19  |
| -   | 1    | 1   | 1    | 2119806-1 INSERT, SHEAR                       | 13  |
| -   | 1    | 1   | 1    | 3-22280-3 SPRING, COMPRESSION                 | 12  |
| -   | 1    | 1   | 1    | 1-356885-3 STOP, SHEAR                        | 11  |
| -   | 1    | 1   | 1    | 2119805-1 SHEAR HOLDER, FRONT                 | 10  |
| -   | 1    | 1   | 1    | 1803095-5 FLOATING SHEAR, FRONT               | 9   |
| -   | 1    | 1   | 1    | 8-1803171-8 ANVIL, COMBINATION                | 8   |
| -   | 1    | 1   | 1    | 3-240641-3 SPACER                             | 7   |
| -   | -    | -   | -    | -   | 6   |
| -   | 1    | 1   | 1    | 1-2119757-0 DEPRESSOR, SHEAR                  | 5   |
| -   | 1    | 1   | 1    | 2-238011-2 BLOCK, CRIMPER SPACER              | 4   |
| -   | 1    | 1   | 1    | 5-2119582-4 CRIMPER, INSULATION F PREMIUM     | 3   |
| -   | 1    | 1   | 1    | 455888-8 SPACER, CRIMPER                      | 2   |
| -   | 1    | 1   | 1    | 3-1803241-4 CRIMPER, WIRE F                   | 1   |

|  |  |  |
|--|--|--|
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|--|--|--|

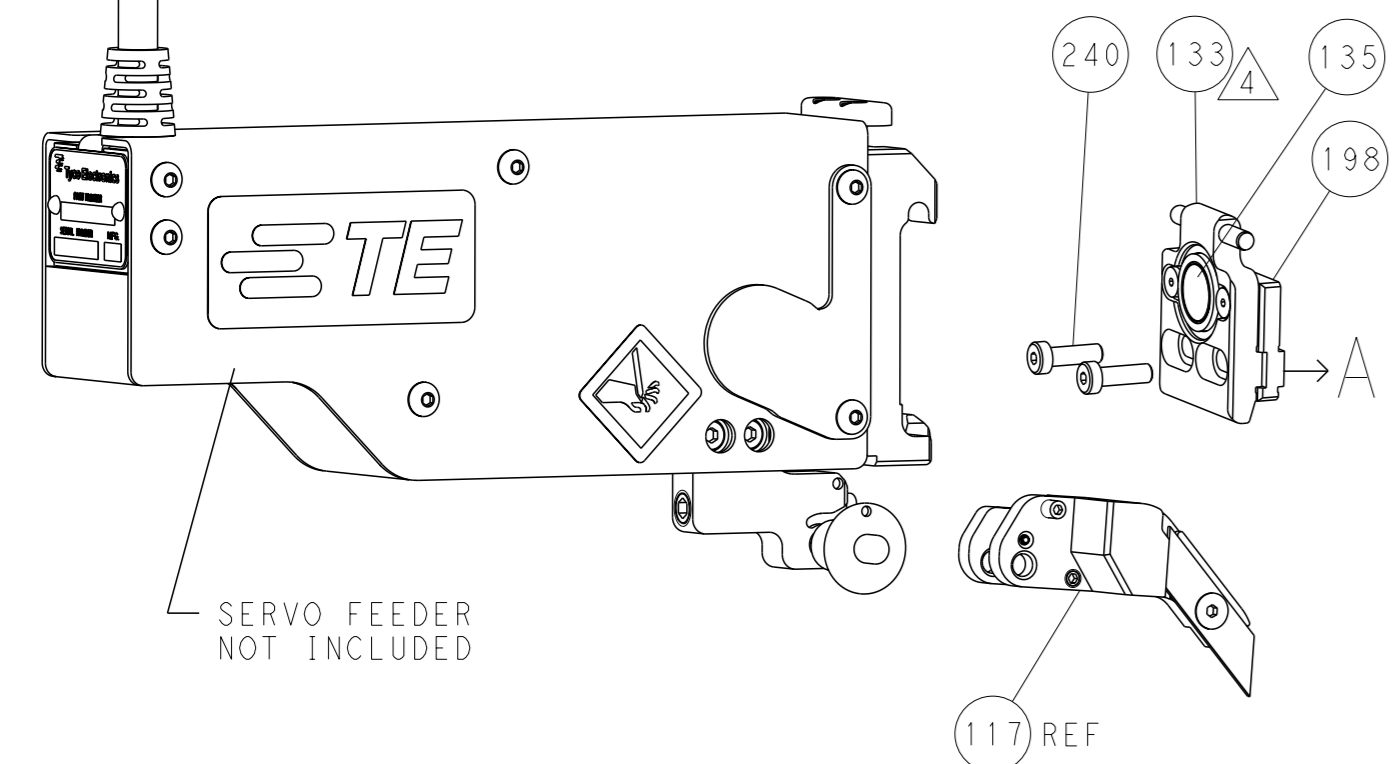
AMP 4805 REV 31MAR2000

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

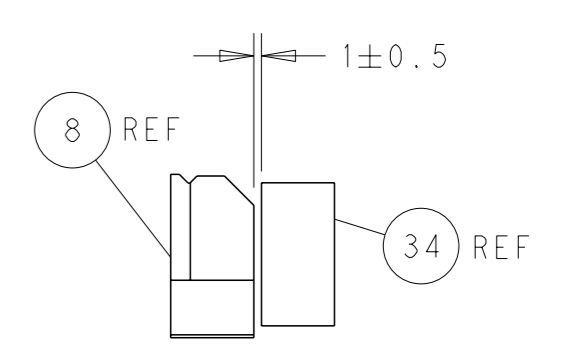
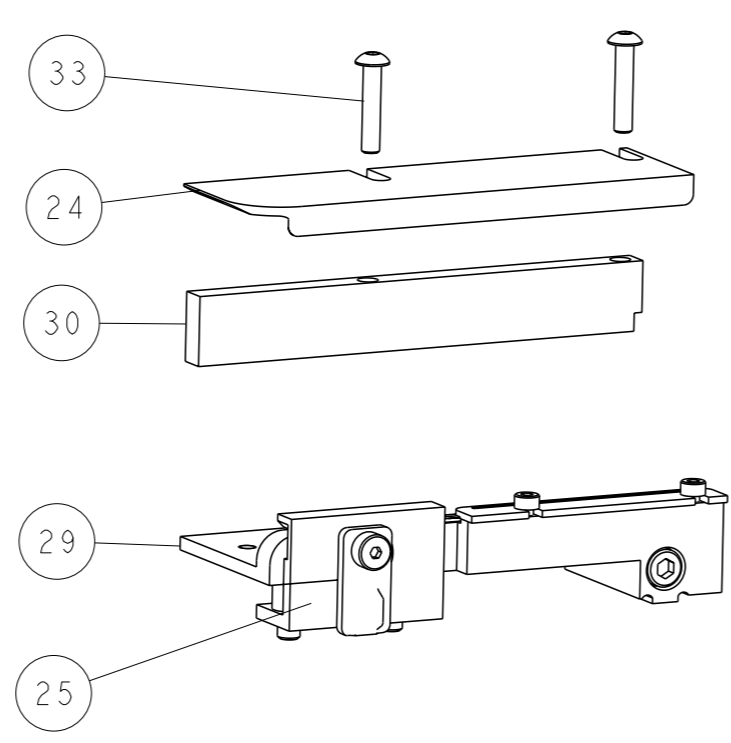
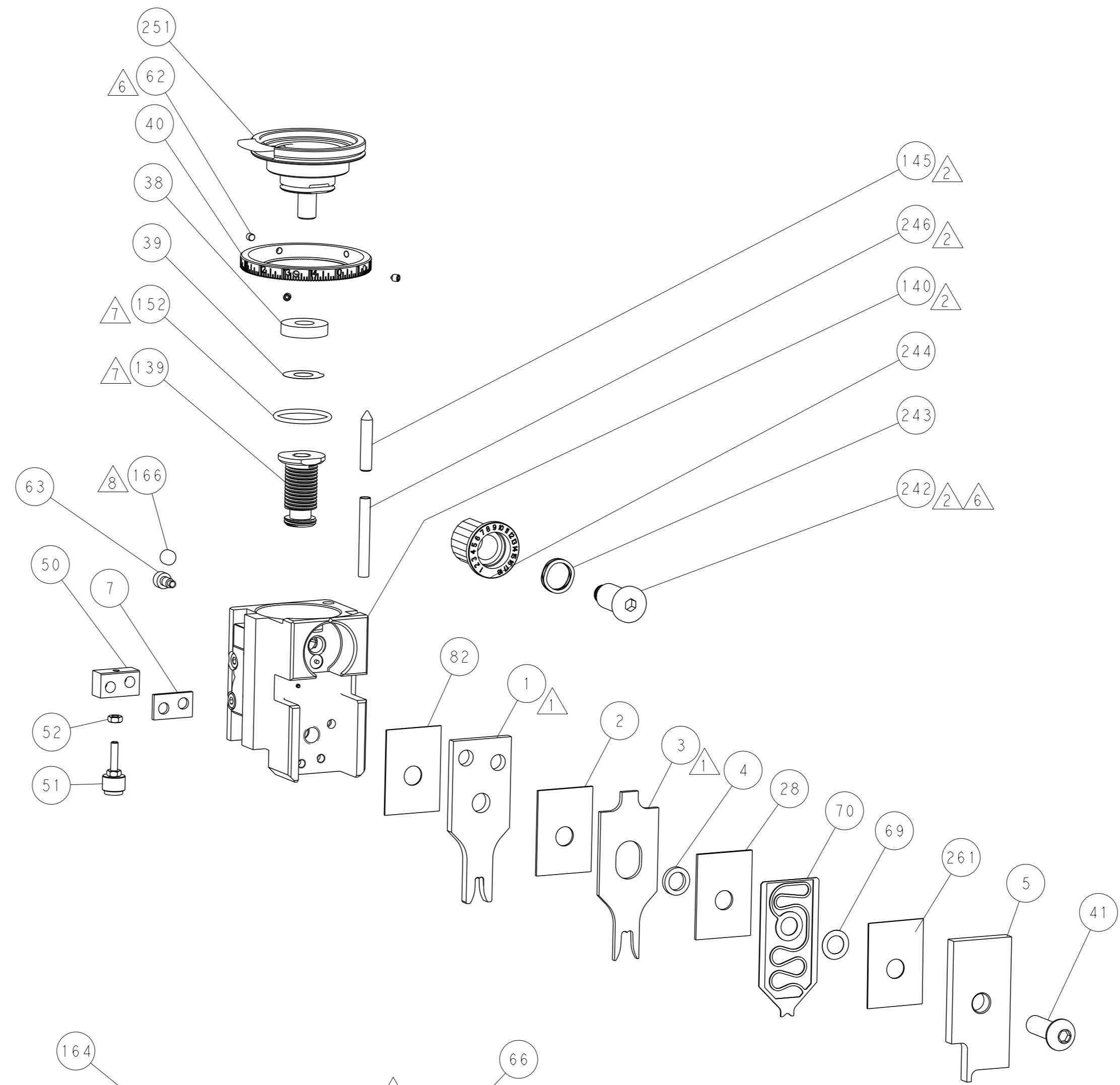
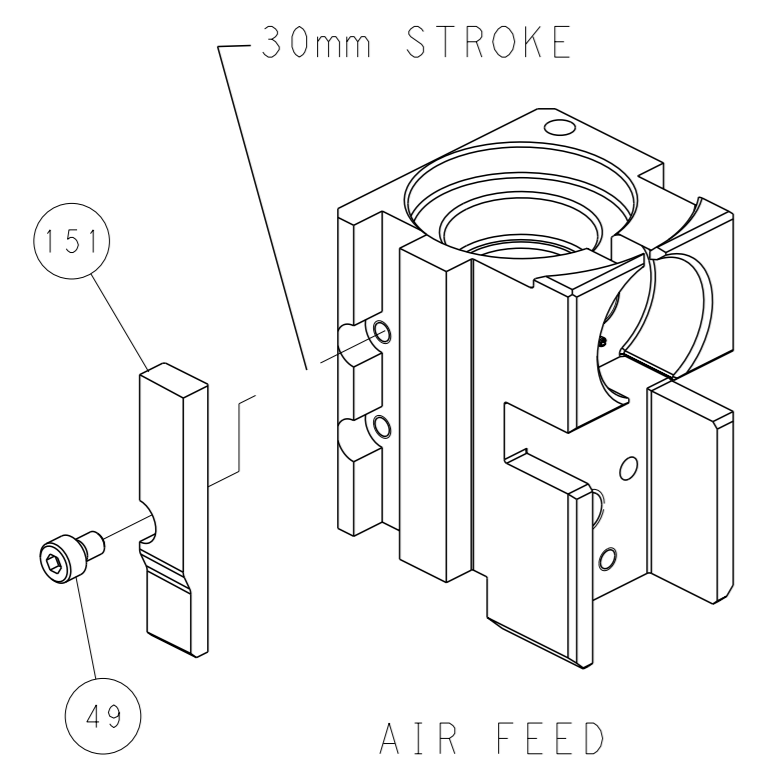
### FEED TYPE PNEUMATIC



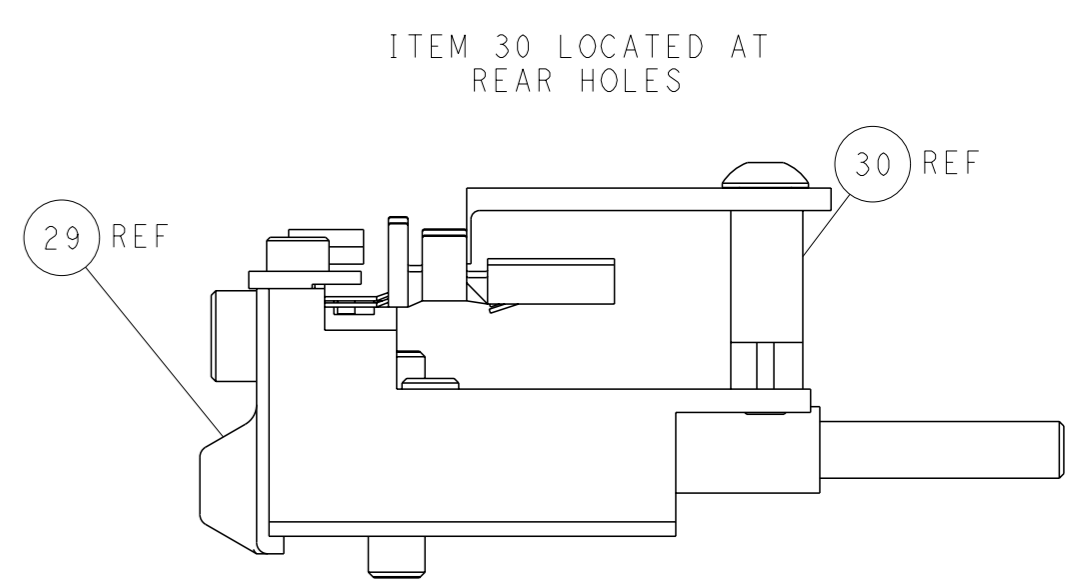
### SERVO LATCH PLATE



### CAM POSITION



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION  
GUIDE BY WIRE BARREL

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

|   |  |  |   |
|---|--|--|---|
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| 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 FINISH ± | PRODUCT SPEC<br>APPLICATION SPEC<br>WEIGHT<br>Customer Accessible Production Drawing | SIZE CAGE CODE DRAWING NO RESTRICTED TO<br>A1 00779 C=2836190<br>SCALE 1:2 SHEET 4 OF 4 REV A |

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