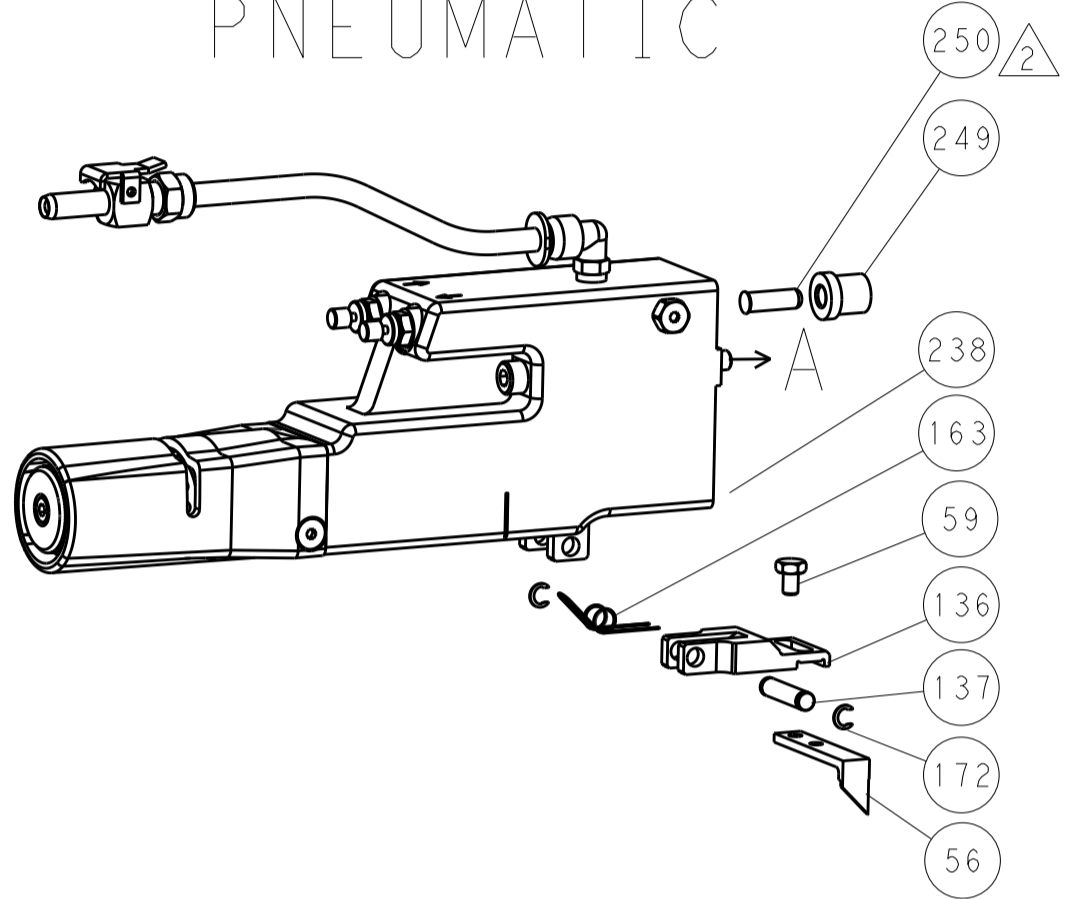


LOC	DIST	REV	DATE	BY	APP'D
A	66				

FEED TYPE MECHANICAL



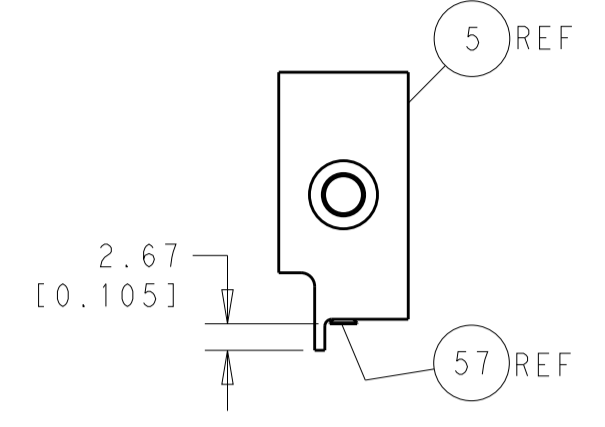
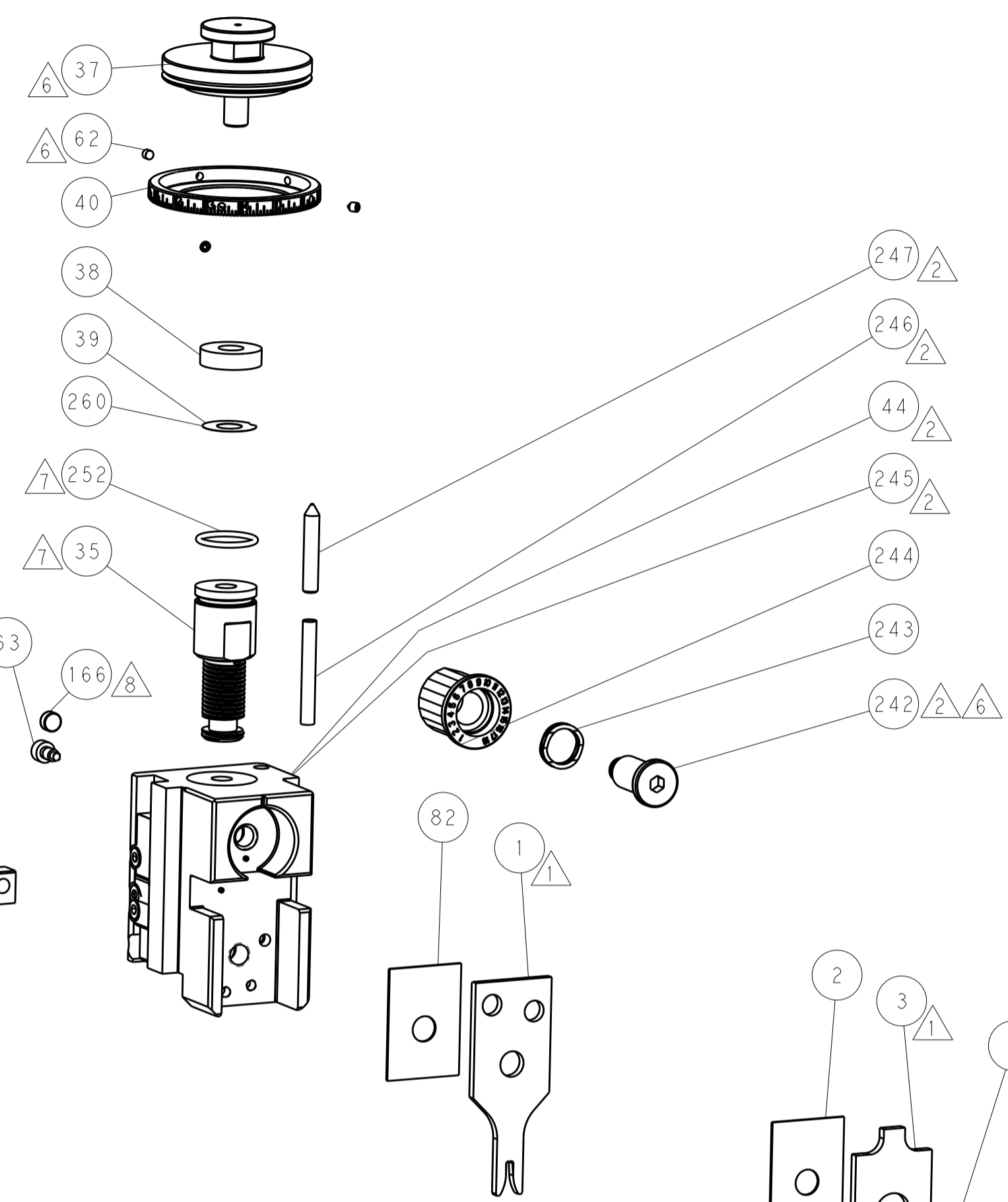
PNEUMATIC



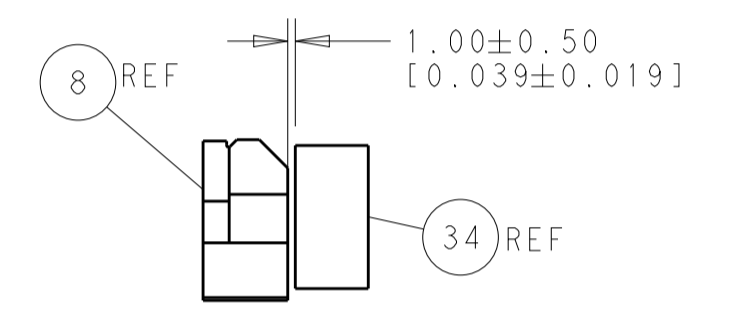
SERVO LATCH PLATE



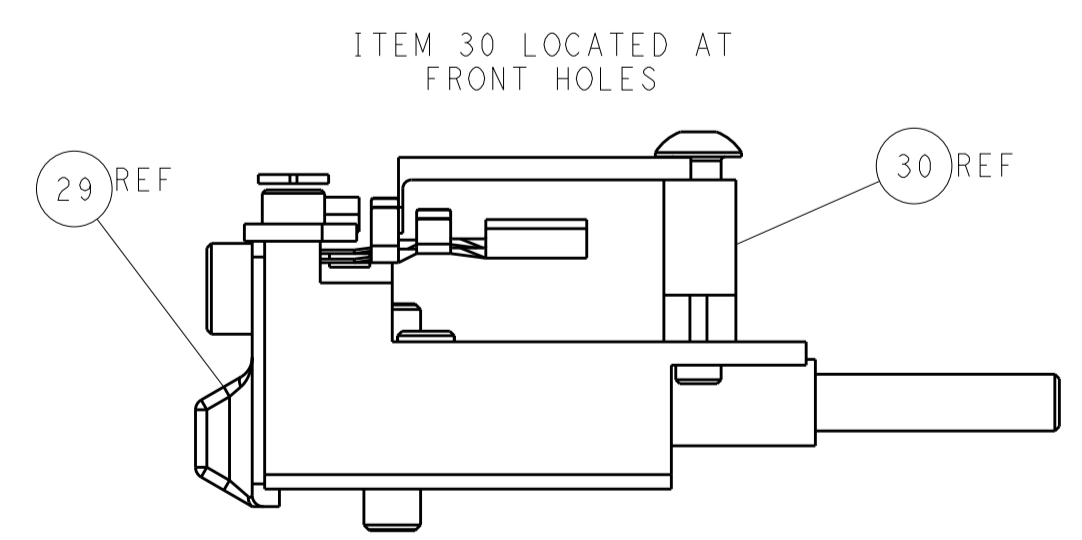
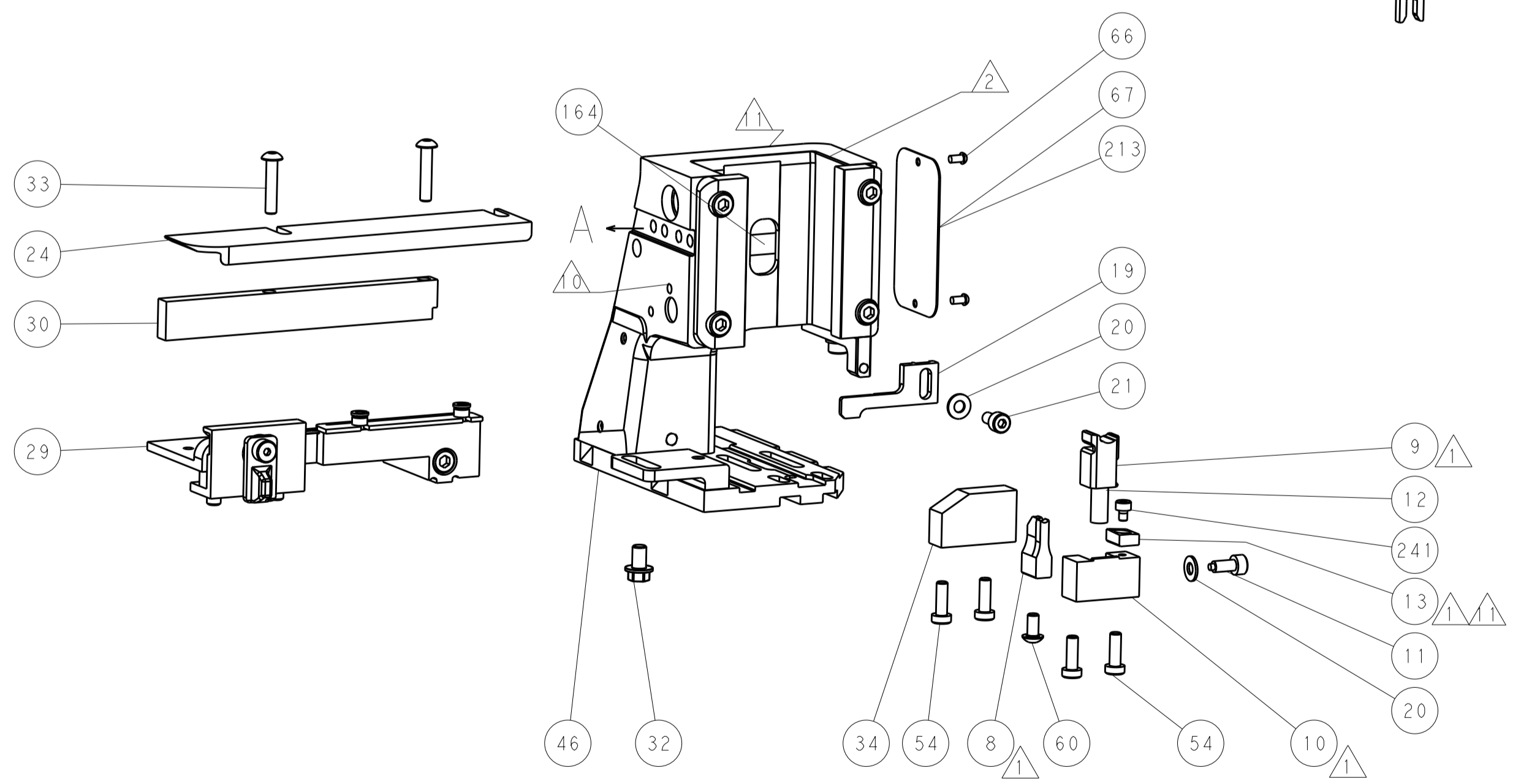
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



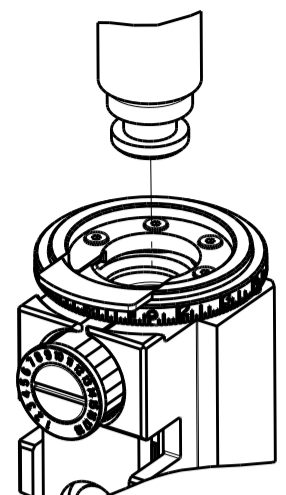
TERMINAL SUPPORT LOCATION




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)

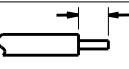
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J.HOU 22OCT2014		TE Connectivity	
mm		0 PLC ±0.5		CHK: Y.YIN 22OCT2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APP'D: H.GUO 22OCT2014		NAME: Ocean Side Feed Applicator	
FINISH:		3 PLC ±0.013		PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
MATERIAL:		4 PLC ±0.0001		APPLICATION SPEC:		RESTRICTED TO:	
		ANGLES ±0.0001		WEIGHT:		A1 00779 ©=2266548	
				Customer Accessible Production Drawing		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					
	2-2266548-1	A	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	-	8-2266548-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266548-4	-	-	-
	2-2266548-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266548-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266548-4	-	-	-
	2-2266548-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	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
	2-2266548-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266548-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
INSUL	2.29 mm (.090)	F
	3.43 mm (.135)	O
APPLICATOR INSTRUCTIONS 408-10389 		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: MICRO TIMER 2 CONTACT

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.80-4.56 mm (.150-.180 IN) 	Ø2.20-2.40 mm (.087-.094 IN)

TERMINAL APPLICATION SPECIFICATION	114-18081
	-

TERMINALS APPLIED ²

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
1703414-1		2112323-1	2112323-2	Ø2.20-2.40

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm ²	1.50 +/- 0.05 [.059 +/- .002]	6.7



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: 8-2266548-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266548-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266548-5

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 ITEM 62.
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.

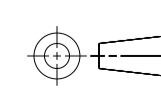
¹³ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

*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.

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	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO.
-	-	-	-	2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	2119640-1 PUSH ROD, AIR FEED	250
-	-	-	-	2079988-1 BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3 SPRING, COMPRESSION	246
-	1	1	1	2119082-4 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
-	-	-	-	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	994969-1 MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2 COUNTER, MAGNETIC	164
-	-	-	-	240638-1 SPRING, FEED FINGER	163
-	1	1	1	8-21084-1 O-RING, .801 ID, .070 DIA, MAT.	152
-	-	-	-	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
-	-	-	-	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	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
-	-	-	-	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
-	-	-	-	1338685-1 PAWL, FEED	56
-	2	2	2	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	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
-	-	-	-	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	1-2119644-2 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	1320908-3 SPACER, STRIP GUIDE	30
-	1	1	1	2119959-1 ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-3 SPACER, CRIMPER	28
-	1	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	1-356885-4 STOP, SHEAR	11
-	1	1	1	2119805-1 SHEAR HOLDER, FRONT	10
-	1	1	1	318707-1 FLOATING SHEAR, FRONT	9
-	1	1	1	1-1633132-7 ANVIL, COMBINATION .090	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1	2-2119781-4 DEPRESSOR, SHEAR	5
-	1	1	1	238011-2 BLOCK, CRIMPER SPACER	4
-	1	1	1	1633996-1 CRIMPER, INSULATION SPECIAL	3
-	1	1	1	455888-6 SPACER, CRIMPER	2
-	1	1	1	4-456406-1 CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm		0 PLC	±	J. HOU	220CT2014	CHK	220CT2014
		1 PLC	±0.5	Y. YIN		APV	220CT2014
		2 PLC	±0.13				
		3 PLC	±0.013				
		4 PLC	±0.001				
		ANGLES	±0.0001				
		FINISH					
MATERIAL:		WEIGHT:		SCALE:	1:2	SHEET:	3 of 4
				Customer Accessible Production Drawing		REV:	A

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE MECHANICAL



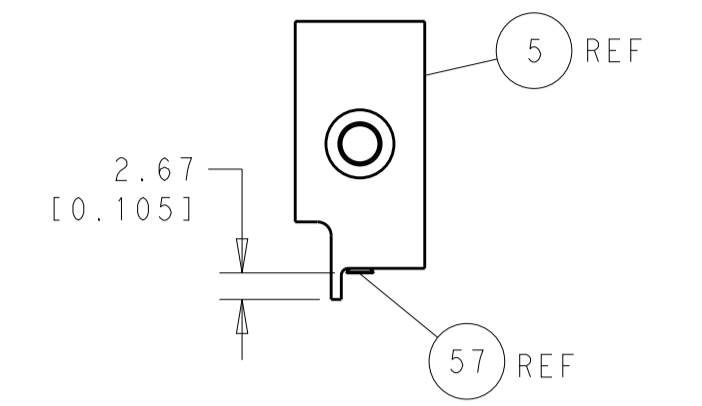
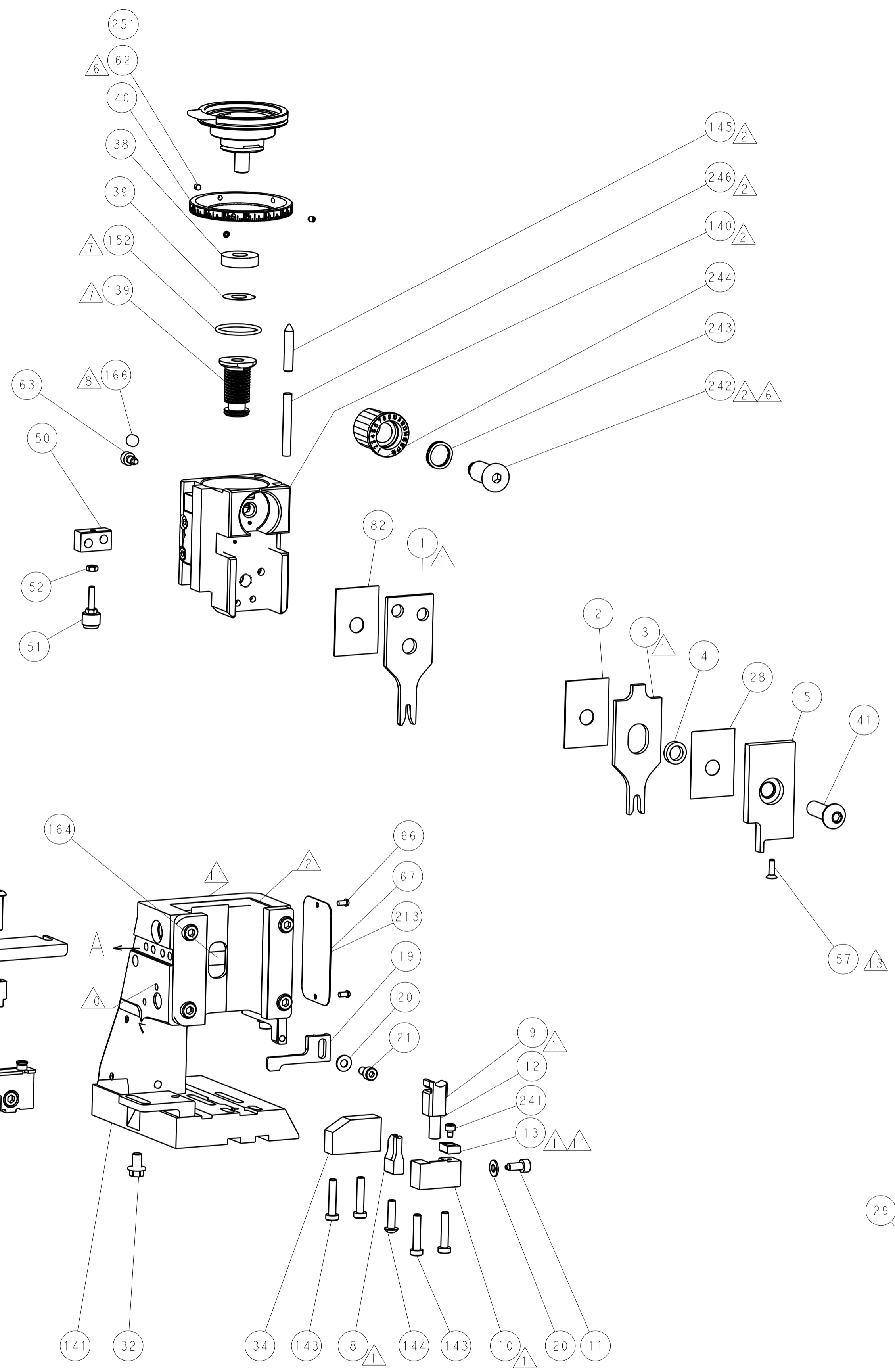
PNEUMATIC



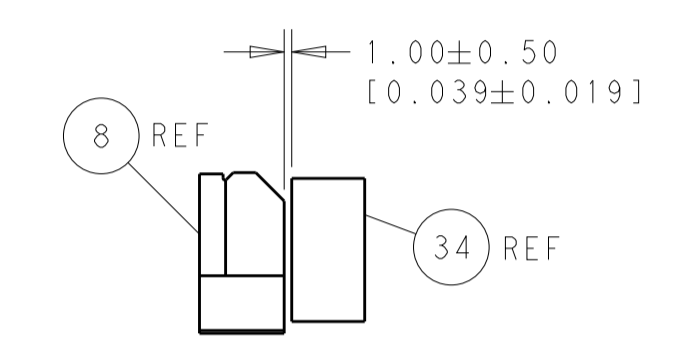
SERVO LATCH PLATE



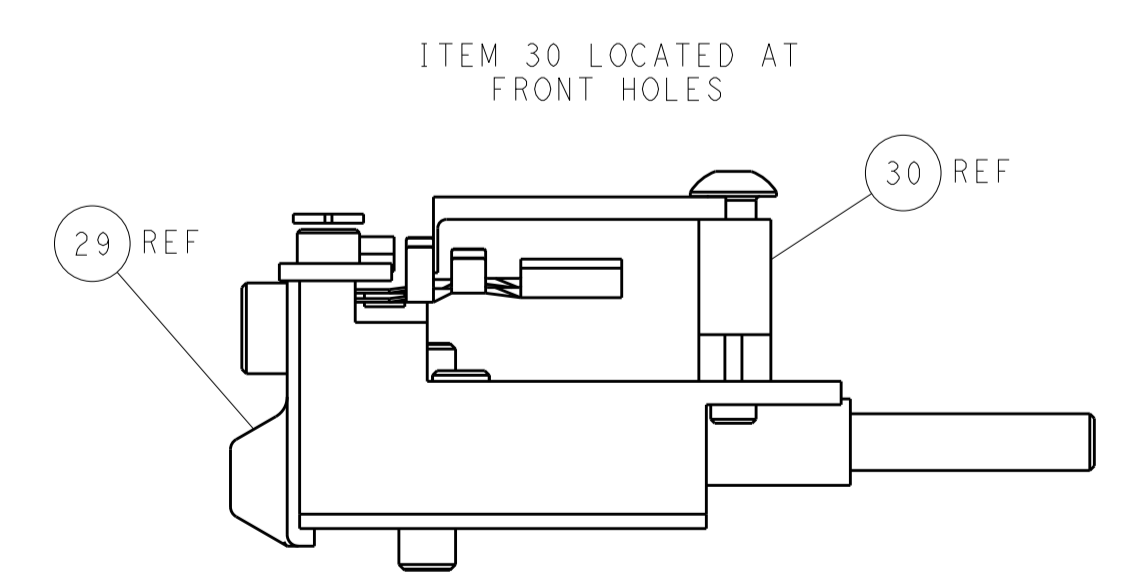
CAM POSITIONS



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:		DWN J.HOU 22OCT2014		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD Y.YIN 22OCT2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME	
				APPLICATION SPEC:		Ocean Side Feed Applicator	
				WEIGHT:		SIZE CAGE CODE DRAWING NO	
				A 00779		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV A	