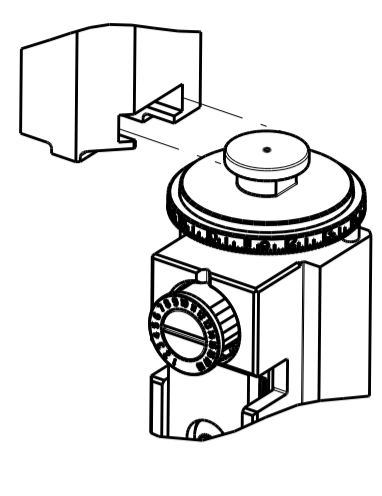


SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
P	LN	DESCRIPTION	DATE	OWN	APPD	
A	RELEASED		27JAN2015	KH	TE	

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2266630-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2266630-5	1901094-3	-	2168400-6 (QUANTITY 2)	
	2266630-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
					SERVO LATCH PLATE	2119951-1	-	8-2266630-5	1901094-3	-	2168400-6 (QUANTITY 2)	
	2266630-5	A	FINE CRIMP HEIGHT ADJUST		SERVO LATCH PLATE	SMART APPLICATOR	2161326-1	-	8-2266630-4	-	-	-
						MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2266630-6	A	NON-CRIMP HEIGHT ADJUST		SERVO LATCH PLATE	-	-	-	-	-	-	-
2266630-7	A	FINE CRIMP HEIGHT ADJUST		NONE	-	-	-	-	-	-	-	
7-2266630-7	A	CRIMP TOOLING KIT			-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.33 mm [.210]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .156 MATE-N-LOK TERMINAL			
WIRE STRIP LENGTH 4.95-5.71 mm [.195-.225 IN]		INSULATION DIAMETER RANGE 4.70mm [.185 IN] MAX	
TERMINAL APPLICATION SPECIFICATION 114-1109			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1586487-1	1586486-1	61234-1	61233-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.70+/-0.05 [.106+/-0.002]	4.8
12 AWG	2.21+/-0.05 [.087+/-0.002]	9.9



- 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: 8-2266630-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266630-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266630-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266630-6
- 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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.10.
- 13 FEED ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

\*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	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-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)

6

6

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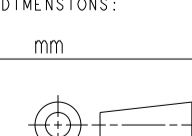
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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.		FINISH:		DWG CH L. HUANG 18DEC2014 L. ZHANG 18DEC2014	NAME Ocean Side Feed Applicator
MATERIAL:		APPROVALS: APVD: JJ. GUO 18DEC2014 PRODUCT SPEC: - APPLICATION SPEC: -		WEIGHT: -		SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2266630 1 of 4 REV A	
Customer Accessible Production Drawing						SCALE 1:2 SHEET 1 OF 4	

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

### FEED TYPE MECHANICAL



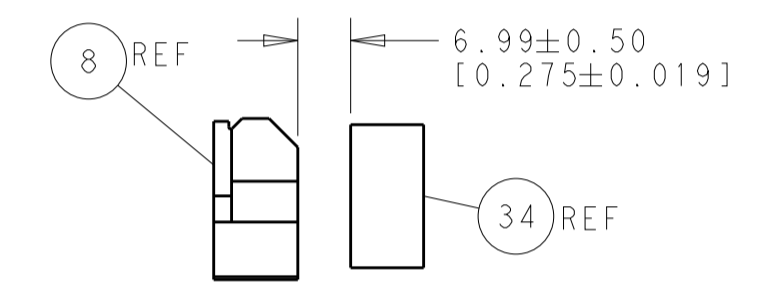
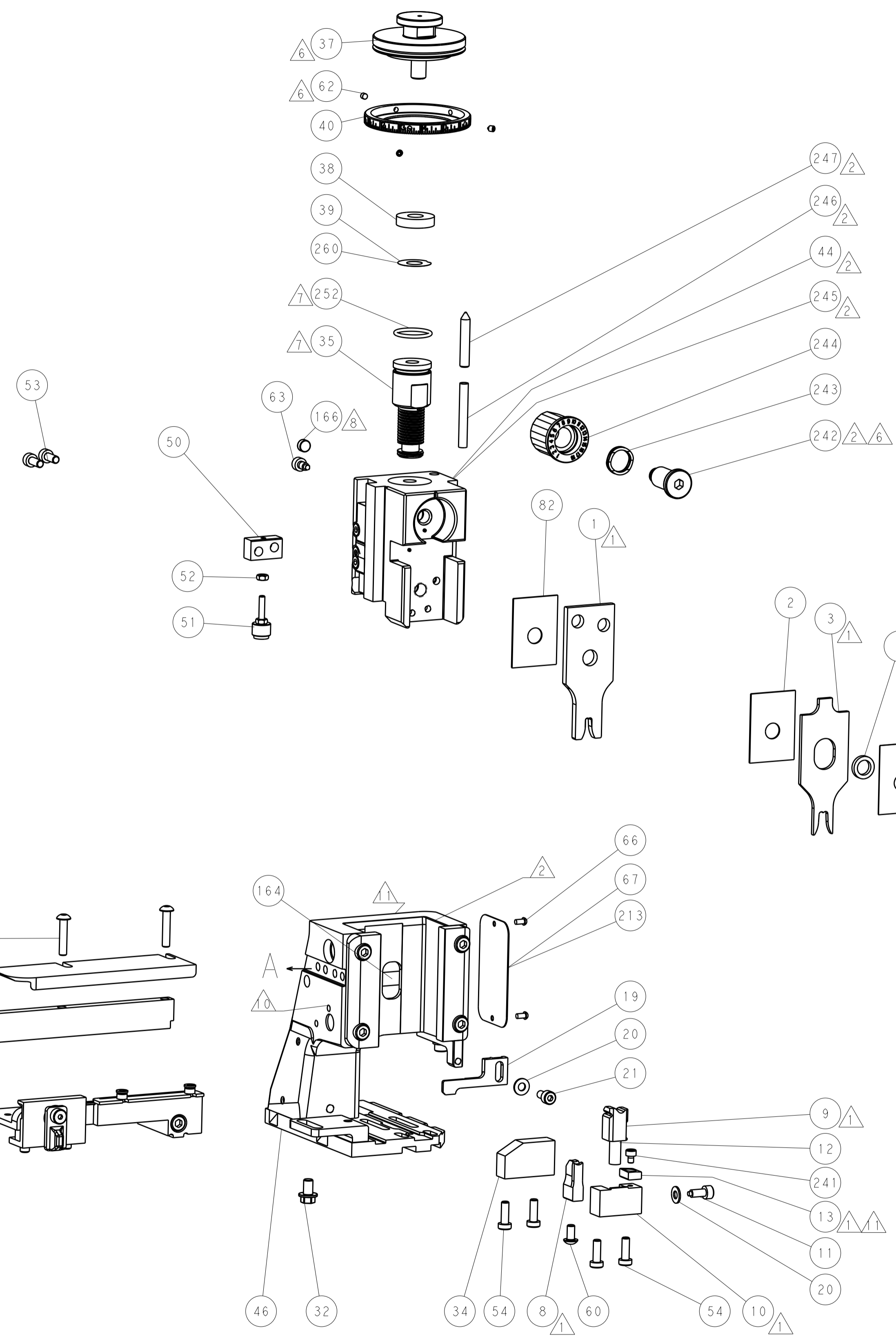
### PNEUMATIC



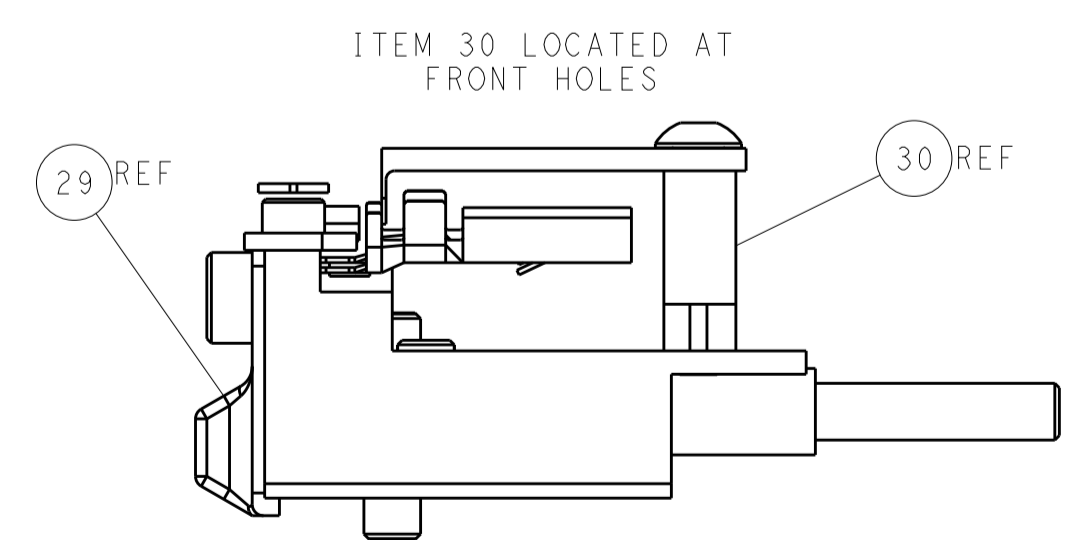
### SERVO LATCH PLATE



### CAM POSITIONS



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:		DWN: H. HUANG 18DEC2014		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	CHK: L. ZHANG 18DEC2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: H. GUO 18DEC2014		NAME: Ocean Side Feed Applicator	
-		-		WEIGHT: -		SIZE: CAGE CODE: DRAWING NO: A11 00779 ©=2266630	
-		-		Customer Accessible Production Drawing		SCALE: 1:2 SHEET 2 OF 4 REV A	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
				CONVERT TO	PART NUMBERS REQUIRED						
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
2-2266630-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2266630-5	1901094-3	-	2168400-6 (QUANTITY 2)	
				SMART APPLICATOR	2161326-1	-	8-2266630-4	-	-	-	
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	
2-2266630-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266630-5	1901094-3	-	2168400-6 (QUANTITY 2)	
				SMART APPLICATOR	2161326-1	-	8-2266630-4	-	-	-	
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	
2-2266630-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1	
				-	-	-	-	-	-	-	
2-2266630-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266630-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.33 mm [.210]	F

APPLICATOR INSTRUCTIONS  
 408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: .156 MATE-N-LOK TERMINAL		
WIRE STRIP LENGTH 4.95-5.71 mm [1.95-.225 IN]		INSULATION DIAMETER RANGE 4.70mm [1.85 IN] MAX
TERMINAL APPLICATION SPECIFICATION 114-1109	-	-

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1586487-1	1586486-1	61234-1	61233-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.70+/-0.05 [1.06+/-0.002]	4.8
12 AWG	2.21+/-0.05 [1.087+/-0.002]	9.9

- RECOMMENDED SPARE PARTS
- 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: 8-2266630-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266630-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266630-5
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. FEED ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

**\*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	-21	PART NO	DESCRIPTION	ITEM NO
-	1	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)

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

REV	DATE	BY	DESCRIPTION	ITEM NO			
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249	
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	1	1	1	2119082-5	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	
-	-	-	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	
-	-	-	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	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	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1-22278-0	SPRING, COMPRESSION	77	
-	1	1	1	854769-4	HOLDER, INS	74	
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	-	-	1	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	
-	-	-	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	1-2119644-3	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	2-1320908-2	SPACER, STRIP GUIDE	30	
-	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	455888-3	SPACER, CRIMPER	28	
-	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	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	1	1	1-1633137-3	ANVIL, COMBINATION .140	8	
-	-	-	-	-	-	7	
-	-	-	-	-	-	6	
-	1	1	1	1-2119780-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
-	1	1	1	1-1633961-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	455888-6	SPACER, CRIMPER	2	
-	1	1	1	456411-3	CRIMPER, WIRE PREMIUM	1	
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

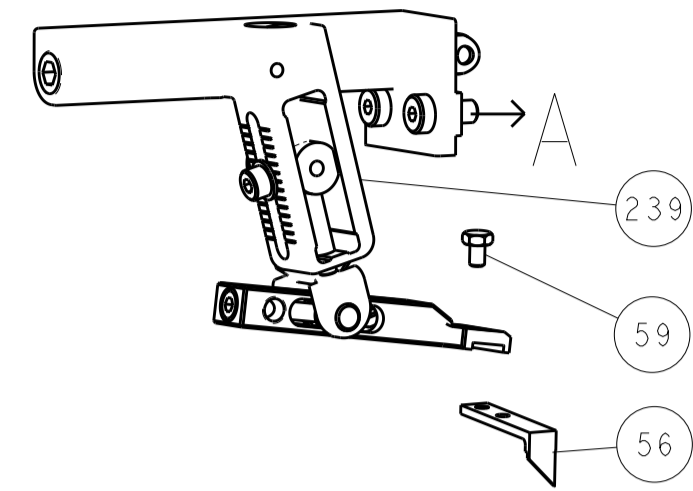
THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY TO THE ORIGINAL ORIGINATOR UNLESS SPECIFICALLY INDICATED OTHERWISE.

DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	0 PLC ±.5	1 PLC ±.13	2 PLC ±.013	3 PLC ±.003	4 PLC ±.0001	ANGLES ±.001	FINISH	
MATERIAL		PRODUCT SPEC		APPLICATION SPEC		WEIGHT		RESTRICTED TO	

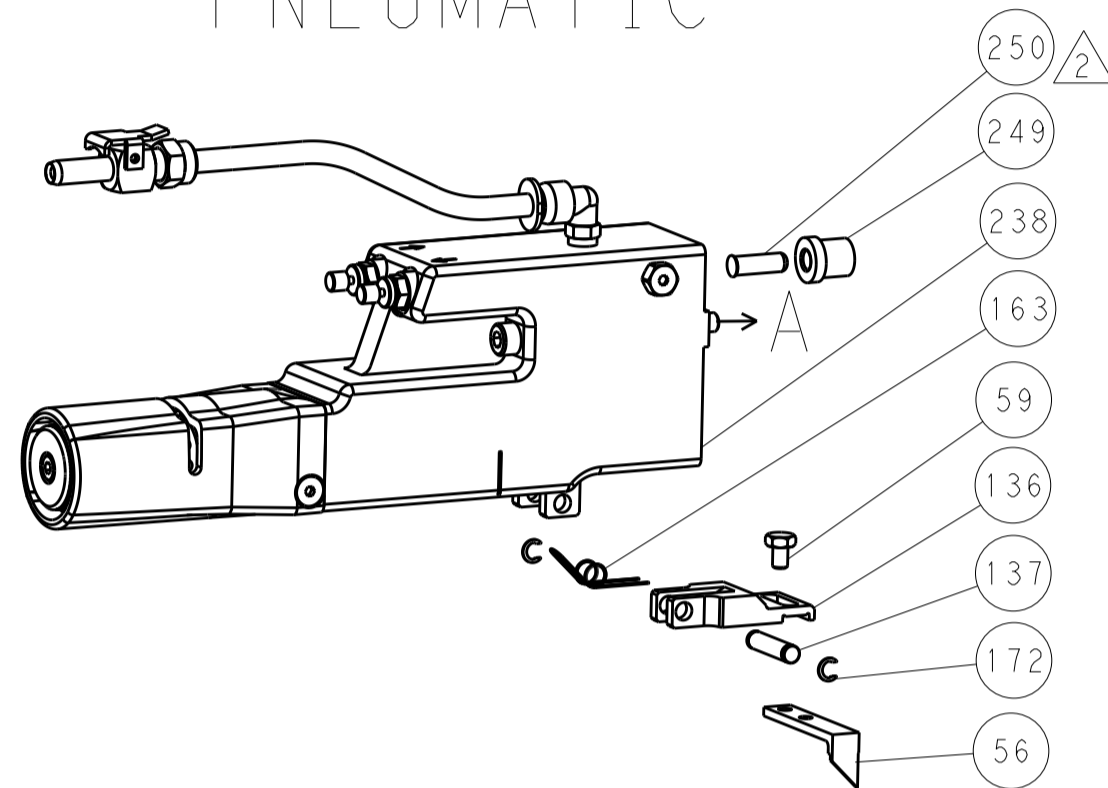
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV A

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

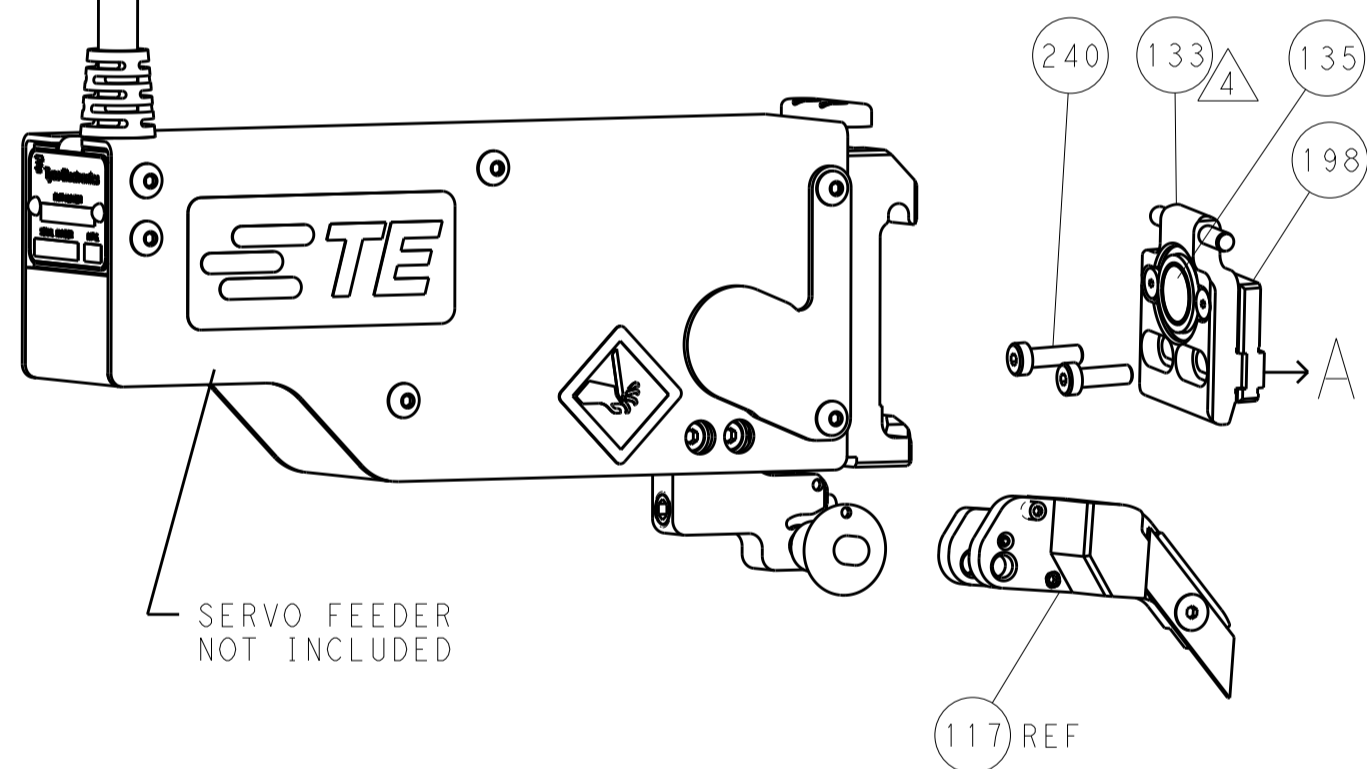
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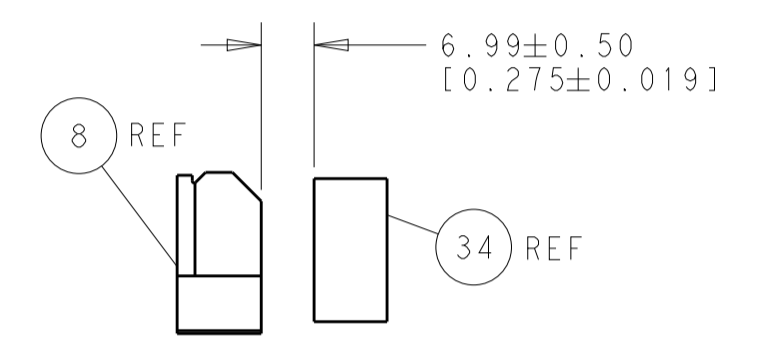
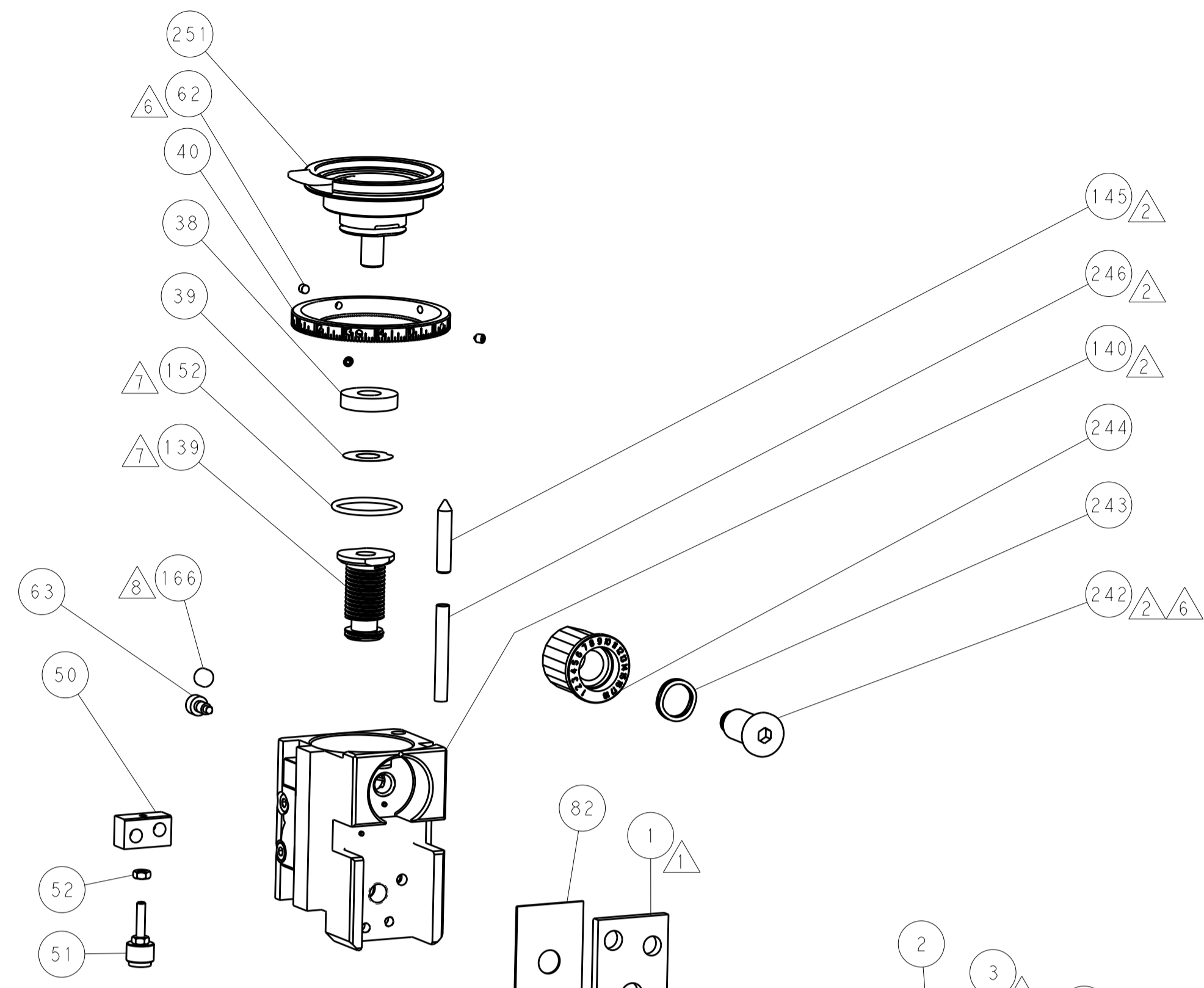
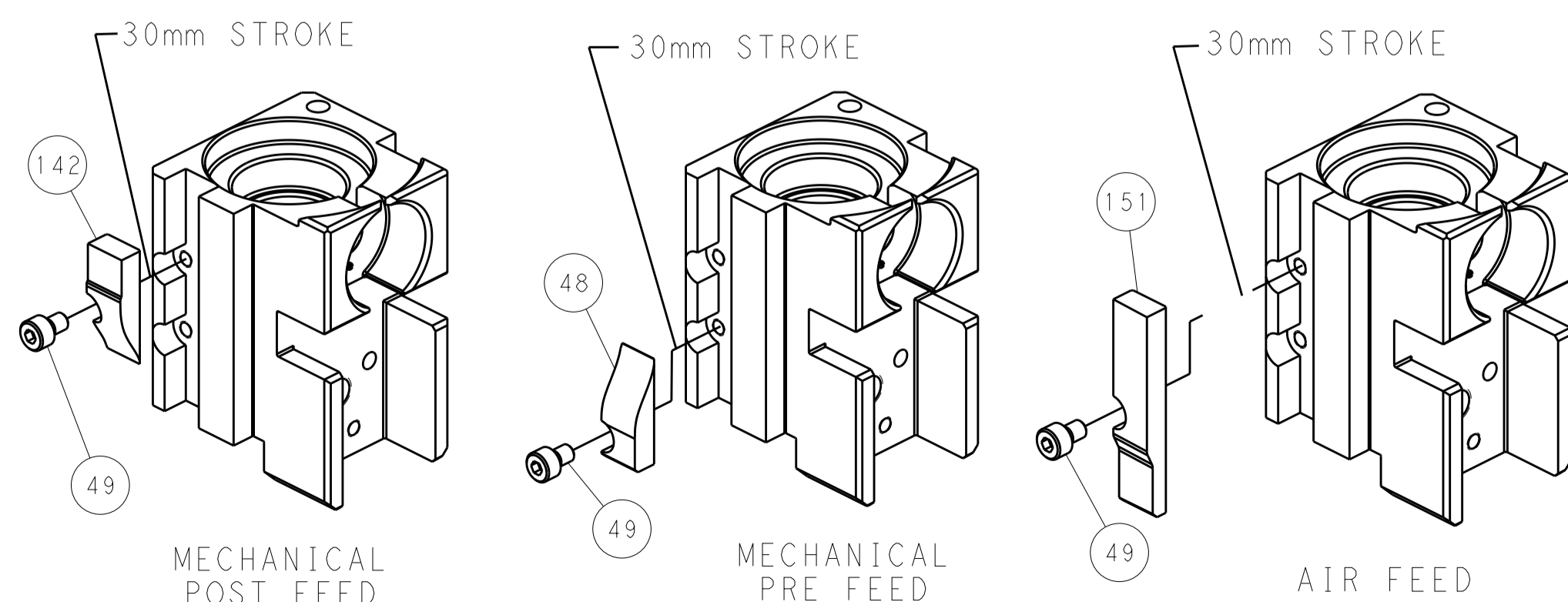
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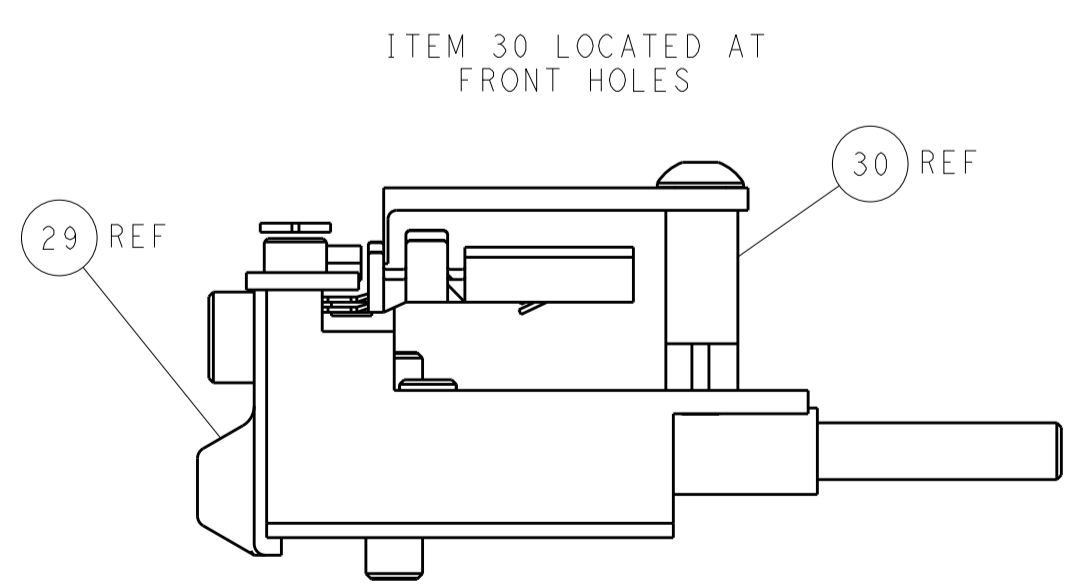
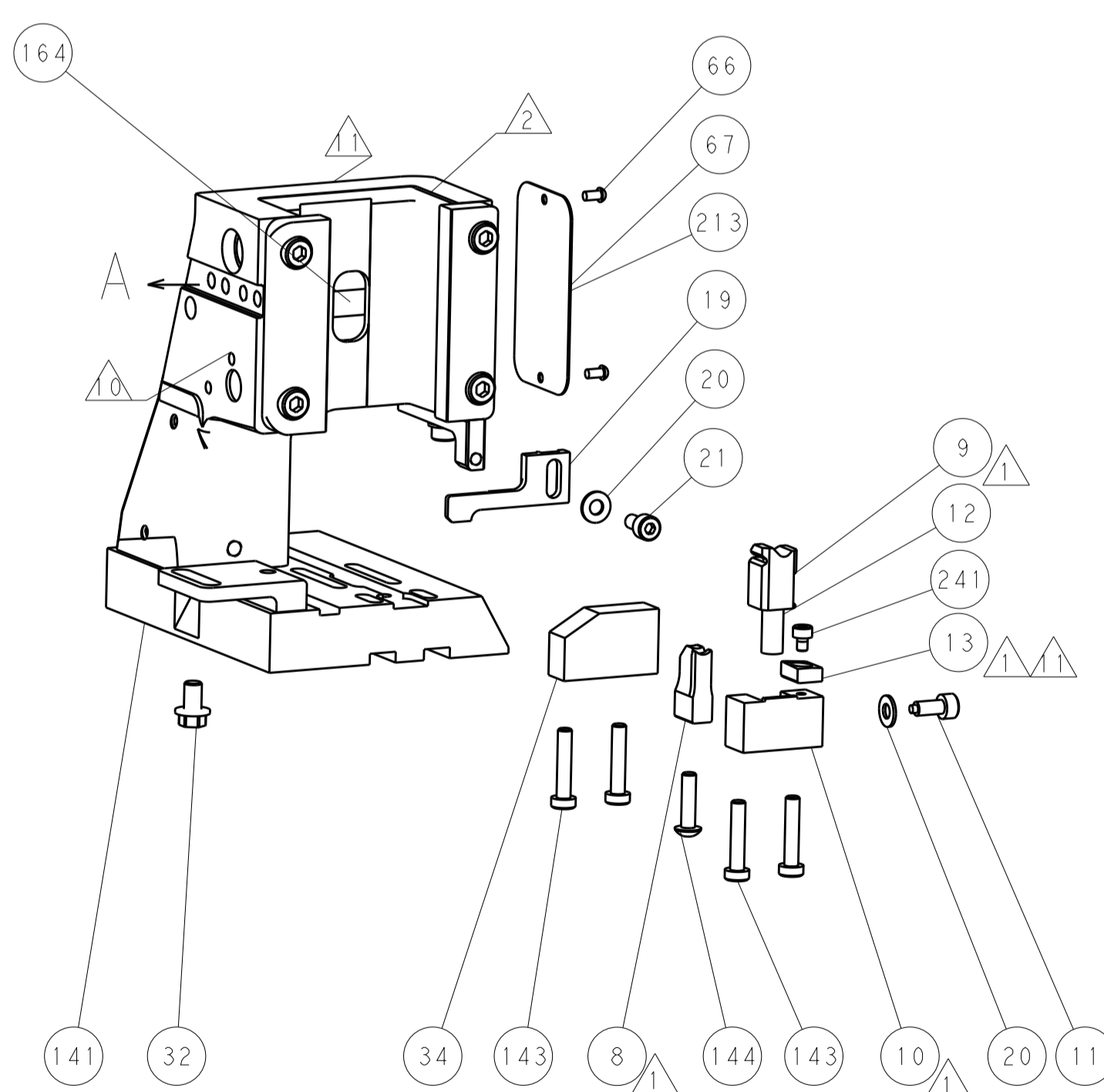
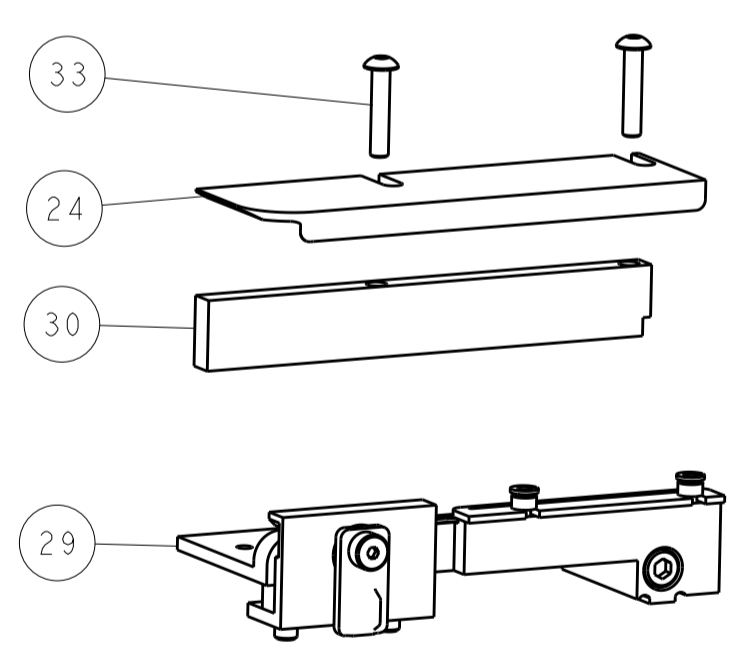
# SERVO LATCH PLATE



# CAM POSITIONS



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		DWN R. HUANG 18DEC2014 CHK L. ZHANG 18DEC2014 APVD H. GUO 18DEC2014 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A 00779 C=2266630 Customer Accessible Production Drawing SCALE 1:2 SHEET 4 OF 4 REV A	
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