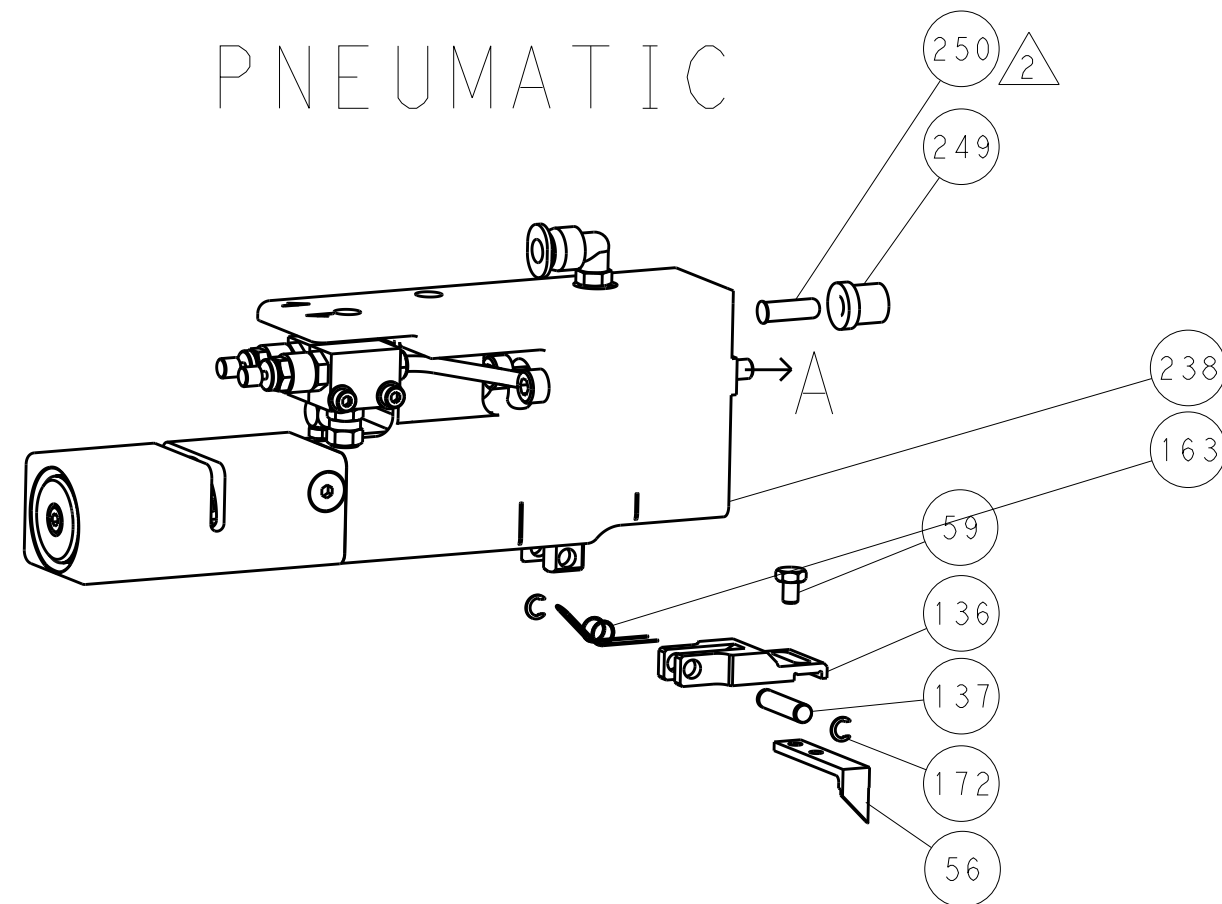


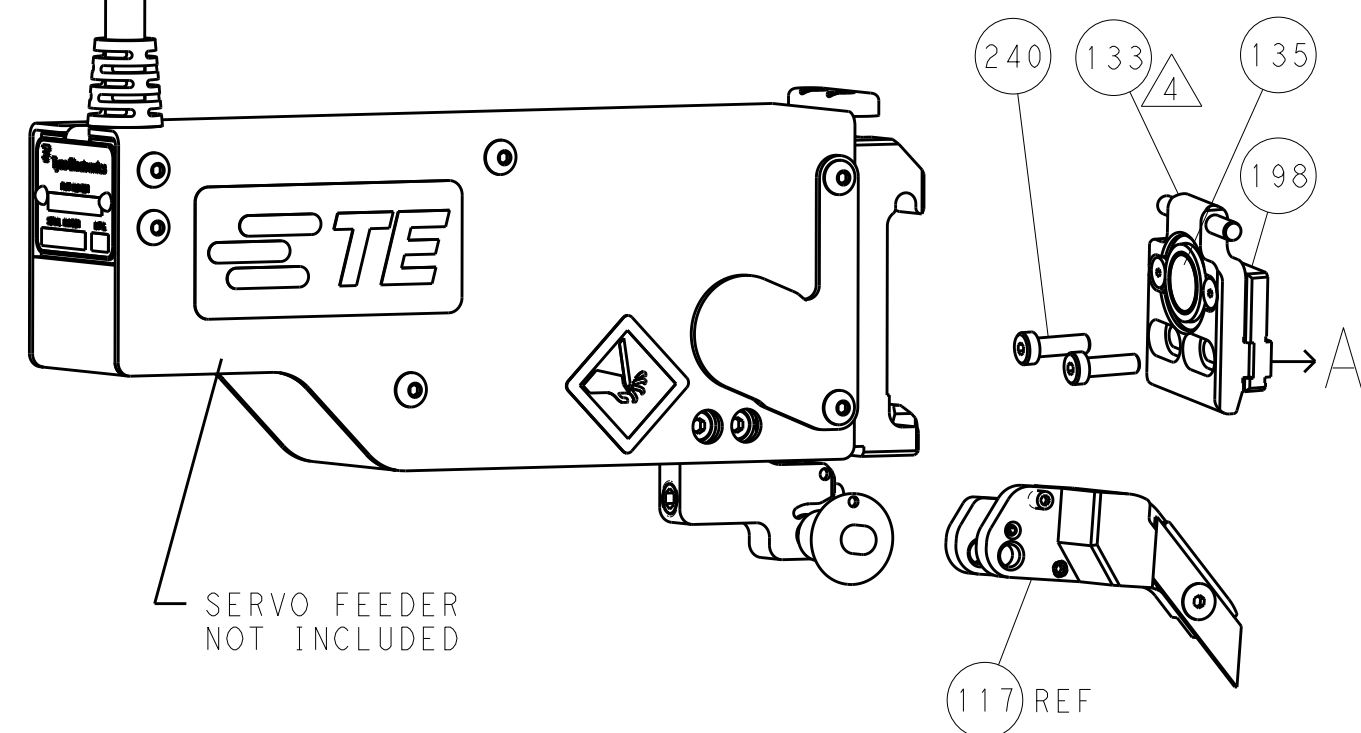
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

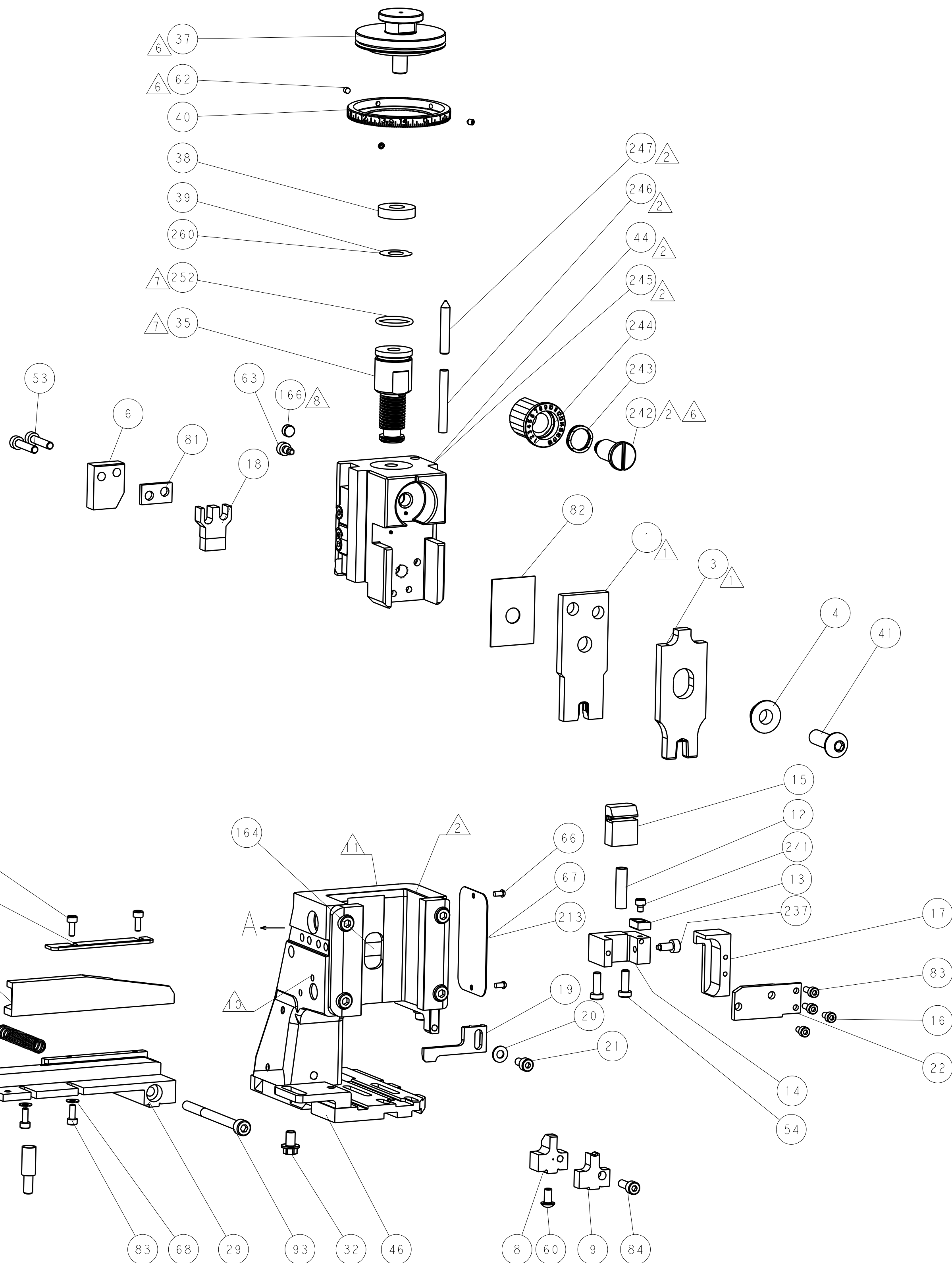
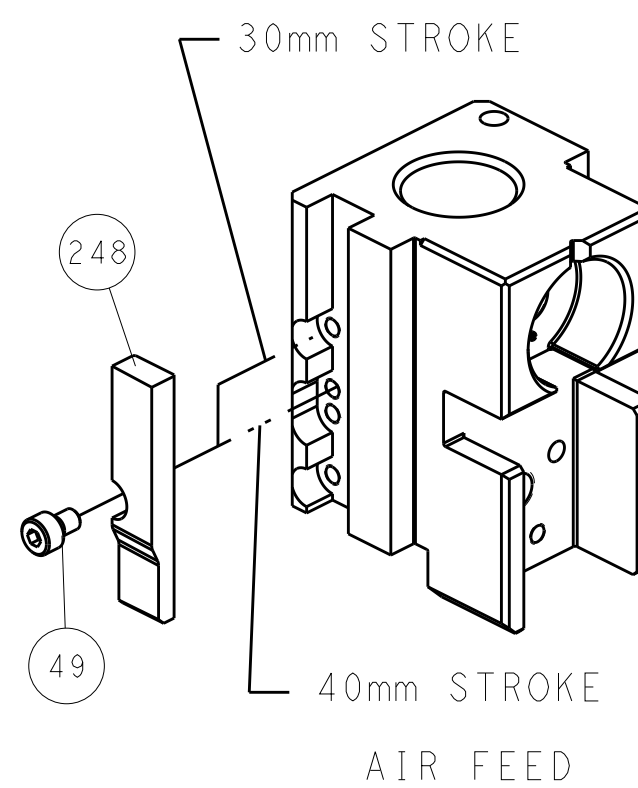
PNEUMATIC



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)

1ST PUBLISHED BY: COMPANY'S TOOLING FOR THE ELECTRONIC CONNECTION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN: BOB HIGMAN 18OCT2013 CHK: G. BAILEY 18OCT2013 APVD: M. CLIFFORD 18OCT2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:2	NAME: Ocean Side Feed Applicator SIZE: A11 CAGE CODE: 00779 DRAWING NO: C=2266077	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		RESTRICTED TO: Customer Accessible Production Drawing	SHEET 2 OF 4 REV A	

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266077-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC					-	-	
					SERVO LATCH PLATE	2119951-1	-	8-2266077-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266077-4	-	-	-
	2-2266077-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 					-	-	
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
2-2266077-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-		
7-2266077-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm [.176]	F
INSUL	5.54 mm [.218]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ULTRA FAST PLUS FULLY INSULATED FASTON			
WIRE STRIP LENGTH 6.73-7.54 mm [.265-.297 IN]			INSULATION DIAMETER RANGE Ø 1.52-3.43 mm [.060-.135 IN]
TERMINAL APPLICATION SPECIFICATION 	114-2123	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520405-2	2-521360-2	2-521055-2	
2-520403-2	2-520401-2	2-521361-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
18 AWG		1.78+/-0.05 [.070+/- .002]	6.1	6.4
20 OR 22		1.65+/-0.05 [.065+/- .002]	7.5	7.6



- 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: 8-2266077-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266077-5
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 & 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.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø .12 IN [3.05mm]) 60/40 SOLID CORE AND MEASURE AT CENTER OF SLUG.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

*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.

					TEC Standard Metric Part Template	
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-77	-27	-25	-22	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 2119599-1	LOC A	DIS 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

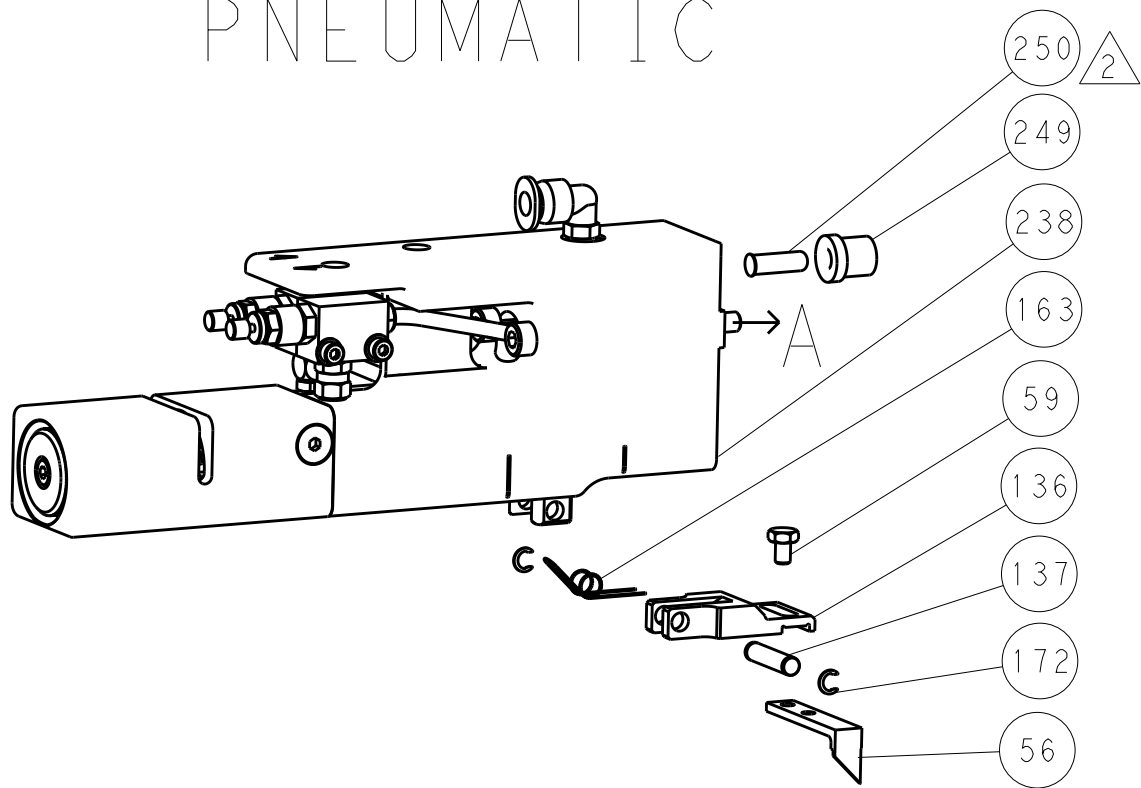
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	1	2063440-1	AIR FEED MODULE	238
-	1	1	1	356885-4	STOP, SHEAR	237
-	-	1	-	2119740-2	TAG,IDENTIFICATION	213
-	-	1	-	1901094-3	SPACER, FEEDER	198
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	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
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	2-2119656-0	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
-	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	84
-	6	6	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	83
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	240641-9	SPACER	81
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	2	2	2	1-18028-4	WASHER, FLAT, REG M3	68
-	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
-	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	462427-2	FINGER, FEED	56
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	-	-	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	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	2161336-1	PLATE, REAR STRIP GUIDE	29
-	2	2	2	22281-9	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	684042-4	GUIDE, STRIP, FRONT	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	2161335-2	SHEAR PLATE, REAR	22
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	463460-3	HOLD DOWN, TERMINAL	18
-	1	1	1	803925-2	GUIDE, CARRIER SCRAP	17
-	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	469542-3	REAR FLOATING SHEAR	15
-	1	1	1	2119862-2	SHEAR HOLDER, REAR	14
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	-	10
-	1	1	1	1-454766-4	ANVIL, INSULATION	9
1	1	1	1	808025-3	ANVIL, SAND-BLASTED 16-14	8
-	1	1	1	690468-6	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	-	5
-	1	1	1	3-238009-6	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1803130-1	CRIMPER, INSULATION FASTON	3
-	-	-	-	-	-	2
1	1	1	1	808830-2	CRIMPER, SEMI FLAT 16-14	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator	
		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		PRODUCT SPEC		SIZE	
MATERIAL		FINISH		APPLICATION SPEC		CAGE CODE	
-		-		WEIGHT		DRAWING NO	
-		-		Customer Accessible Production Drawing		SCALE	
-		-		A1		00779	
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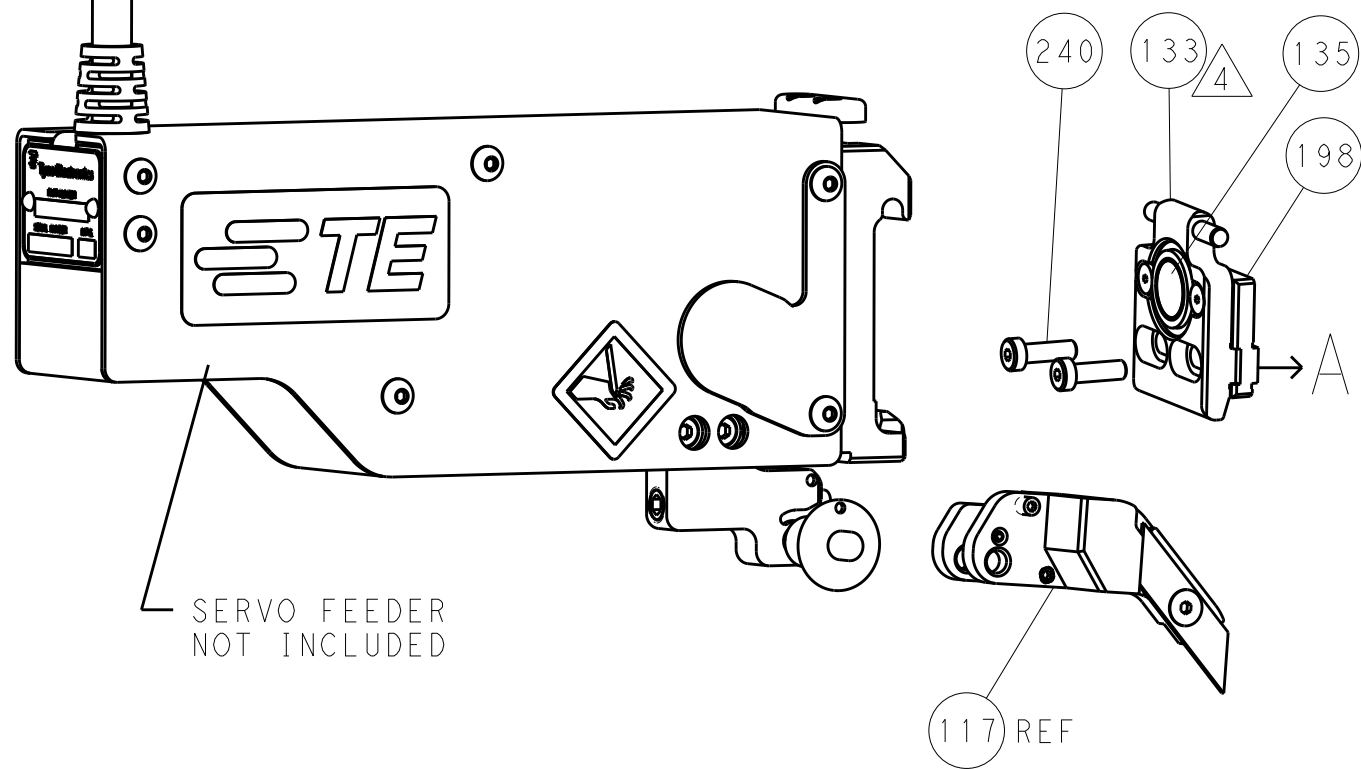
LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

FEED TYPE

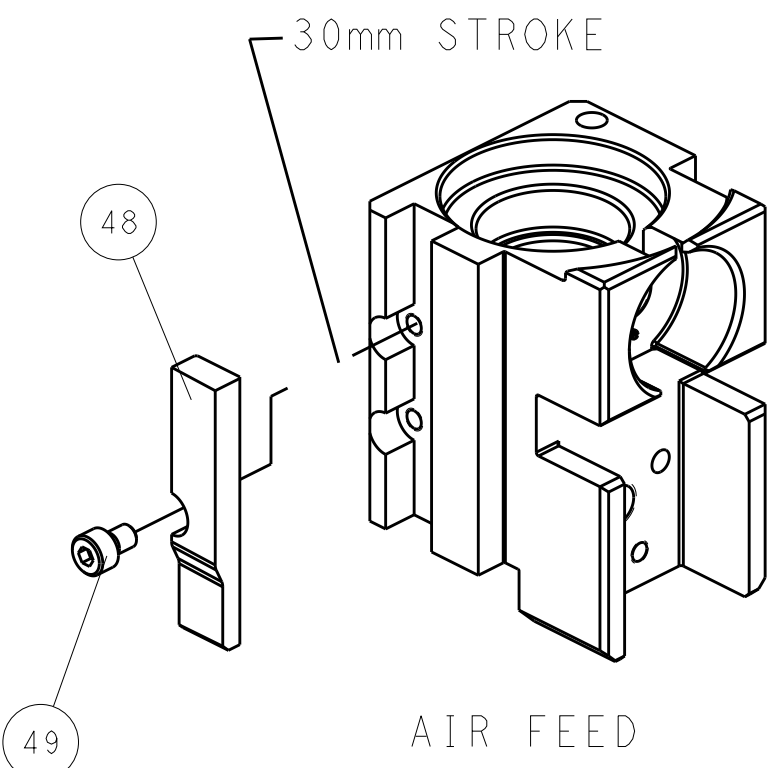
PNEUMATIC



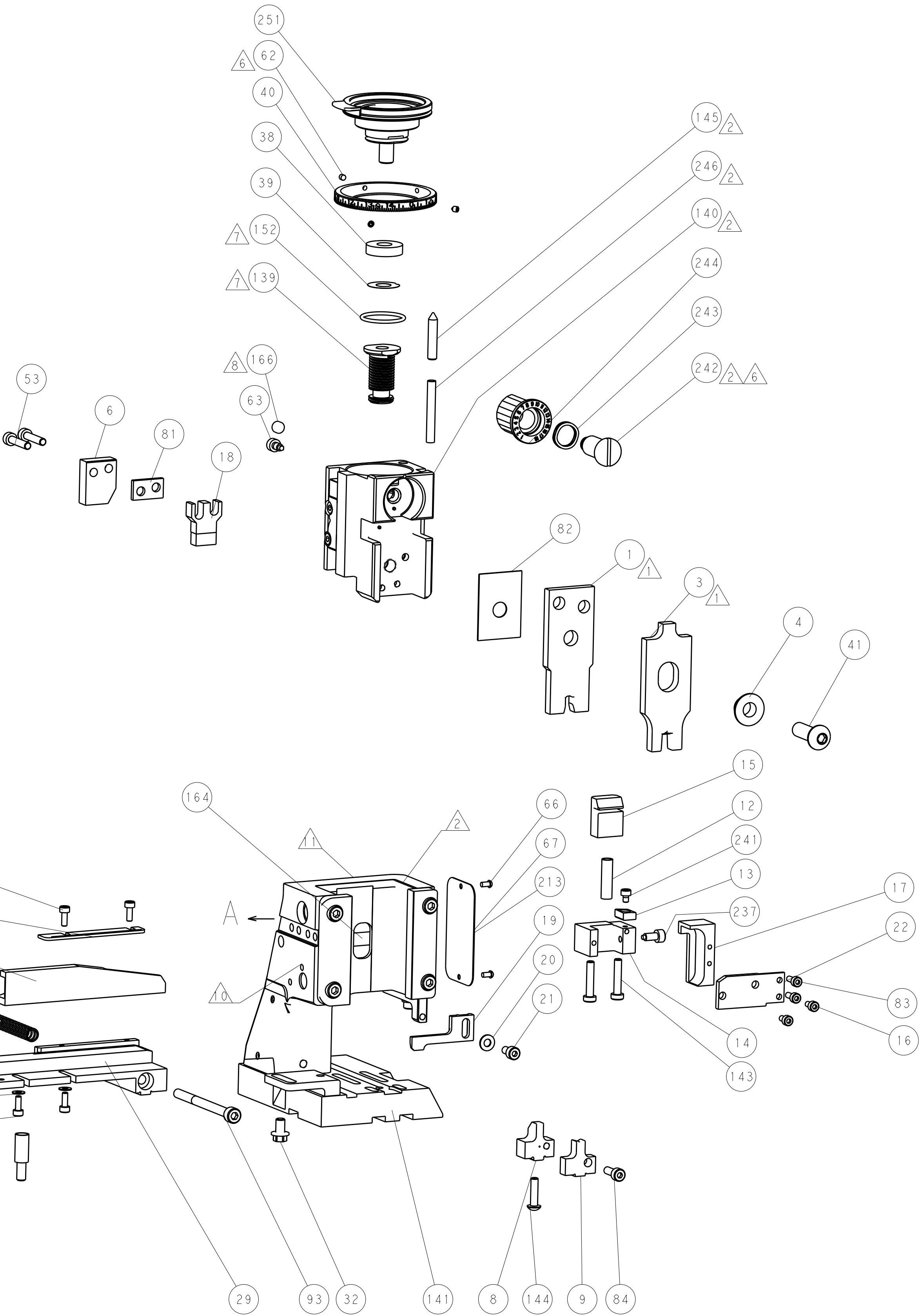
SERVO LATCH PLATE



CAM POSITION



AIR FEED



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: BOB HIGMAN 18OCT2013		CHK: G.BAILEY 18OCT2013		APVD: M.CLIFFORD 18OCT2013		NAME: STE TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±.5		1 PLC ±0.13		2 PLC ±0.13		3 PLC ±0.013		4 PLC ±0.0001	
ANGLES		FINISH		PRODUCT SPEC		APPLICATION SPEC		WEIGHT		SIZE: A1	
MATERIAL		-		Customer Accessible Production Drawing		SCALE: 1:2		SHEET: 4 OF 4		REV: A	