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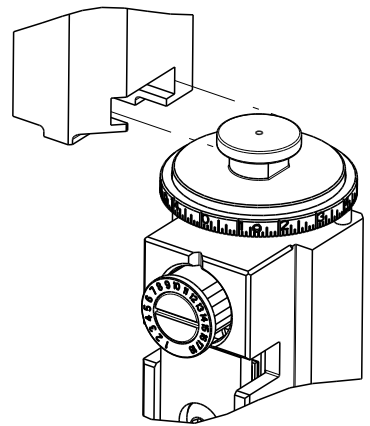
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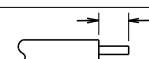
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	PART NUMBER	REVISION	DESCRIPTION
	2266278-2	C	FINE CRIMP HEIGHT ADJUST
	2266278-5	C	FINE CRIMP HEIGHT ADJUST
	2266278-6	C	NON-CRIMP HEIGHT ADJUST
	2266278-7	C	FINE CRIMP HEIGHT ADJUST
	7-2266278-7	C	CRIMP TOOLING KIT

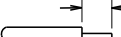
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.27 mm [.050]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO TERMINAL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.50-3.80 mm [.138-.150 IN]		114-18858	Ø0.95-1.30 mm [.037-.051 IN]
TERMINAL APPLICATION SPECIFICATION			
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-1703930-1	2-1703930-2	2-1703930-3	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
0.35mm2		0.78+/-0.05 [.031+/- .002]		9.6	



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266278-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266278-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266278-6
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 ITEMS 62 & 180. 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 ITEMS 37 & 180.
- 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
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 5.02.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO TERMINAL			
WIRE STRIP LENGTH 3.50-3.80 mm [.138-.150 IN]			INSULATION DIAMETER RANGE Ø0.95-1.30 mm [.037-.051 IN]
TERMINAL APPLICATION SPECIFICATION		114-94191	- - -
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2177909-1	2177909-3	1-2177909-1	1-2177909-2
8-2177909-3			

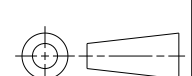
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	1	18030-1	NUT, HEX, REG M3	280
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	279
-	-	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	-	1803259-1	BUSHING, FLANGED	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-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 2119599-1		LOC A	DIST 66	REVISIONS			
P	LTR	DESCRIPTION		DATE	OWN	APVD	
	C	ECR-16-012112		29AUG2016	MR	GB	

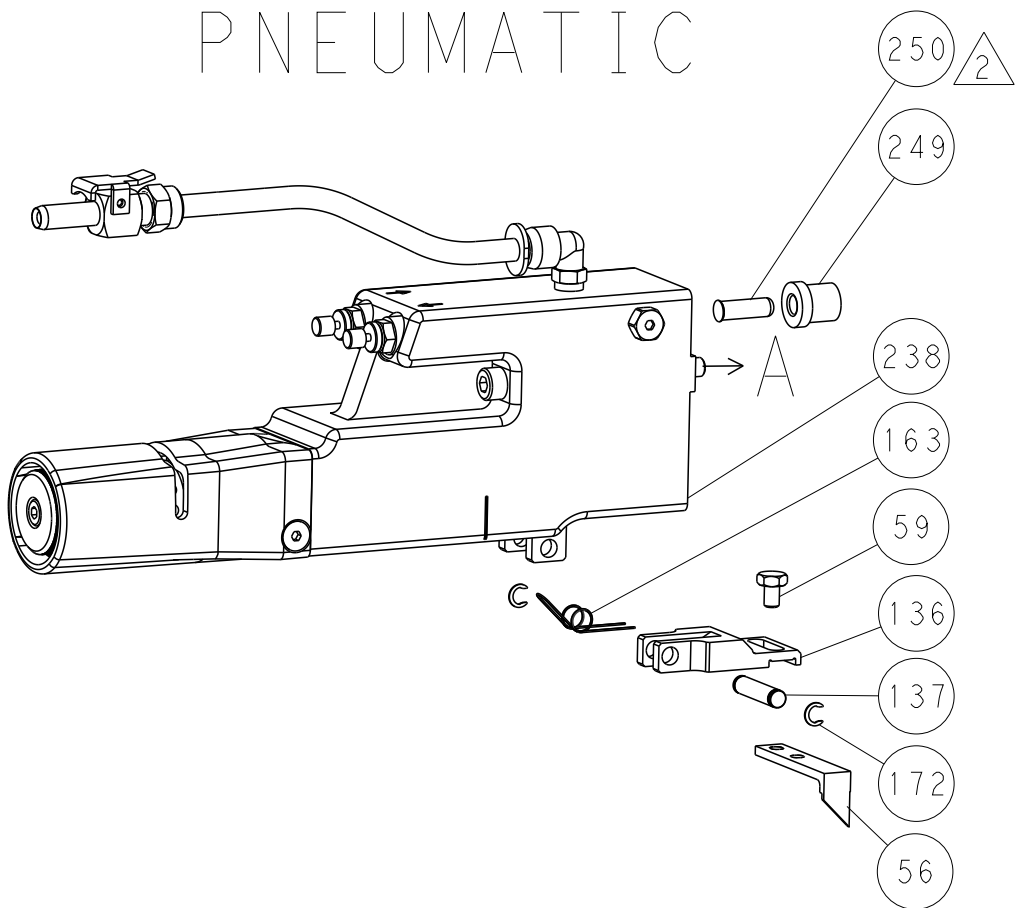
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	1	1-1752354-6	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	-	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
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	1-22281-8	SPRING, COMPRESSION	98
-	1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	97
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
-	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	95
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1	1	2-2119656-1	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	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	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	1	1	1	1	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	36
-	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	2-1722335-1	Thread bolt Gewindebolzen	31
-	1	1	1	1	1	1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1901086-1	PLATE, STRIP GUIDE	29
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1803095-7	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	6-1633620-7	ANVIL, COMBINATION	8
-	1	1	1	1	1	240641-1	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1803143-6	CRIMPER, INSULATION O	3
-	-	-	-	-	-	-	-	2
1	1	1	1	1	1	2-1333281-7	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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				CHK G. BAILEY 24APR2014				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD U. GUO 24APR2014	NAME Ocean Side Feed Applicator -	SIZE CAGE CODE DRAWING NO A 00779 C=2266278	RESTRICTED TO -	
mm		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		PRODUCT SPEC				
				APPLICATION SPEC				
MATERIAL		FINISH		WEIGHT				
-		-		-				
Customer Accessible Production Drawing					SCALE	1:2	SHEET 1 OF 4	REV C

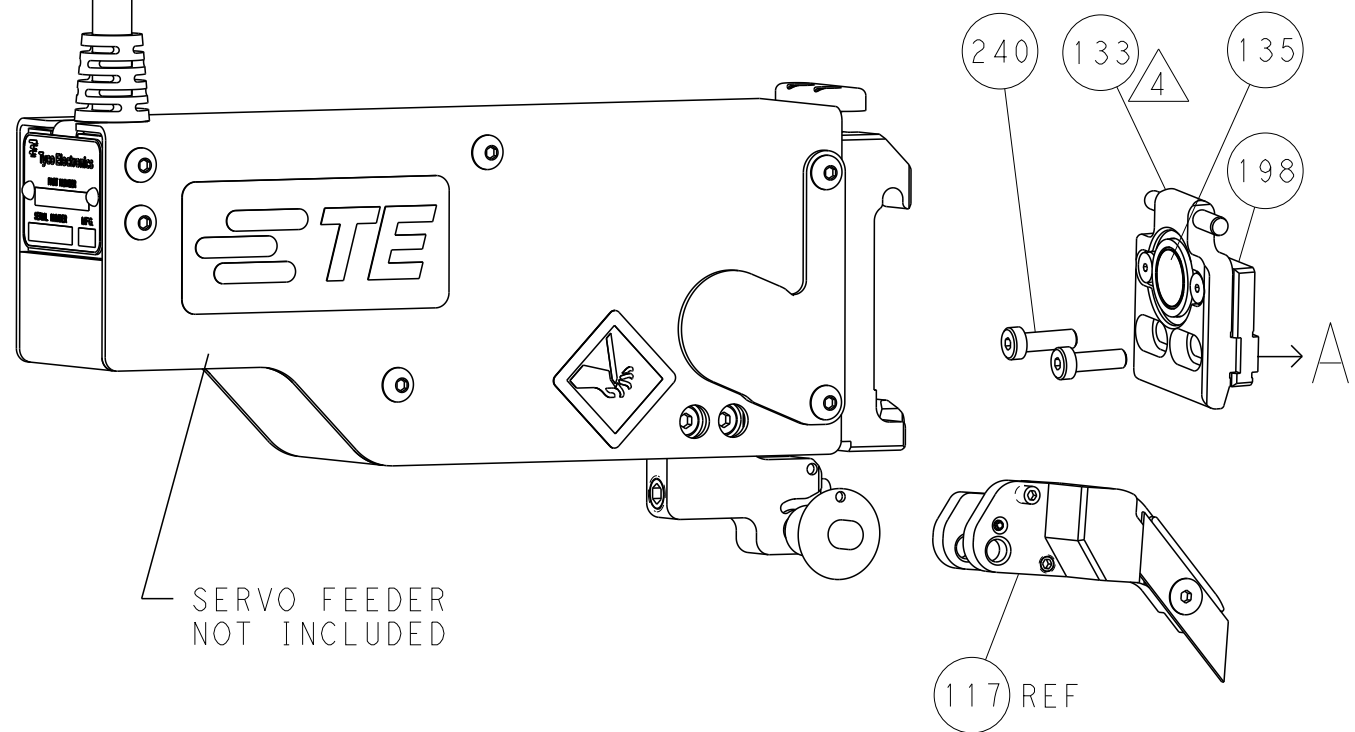
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		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

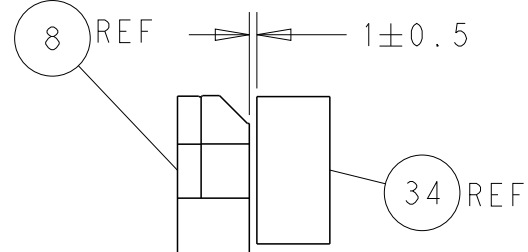
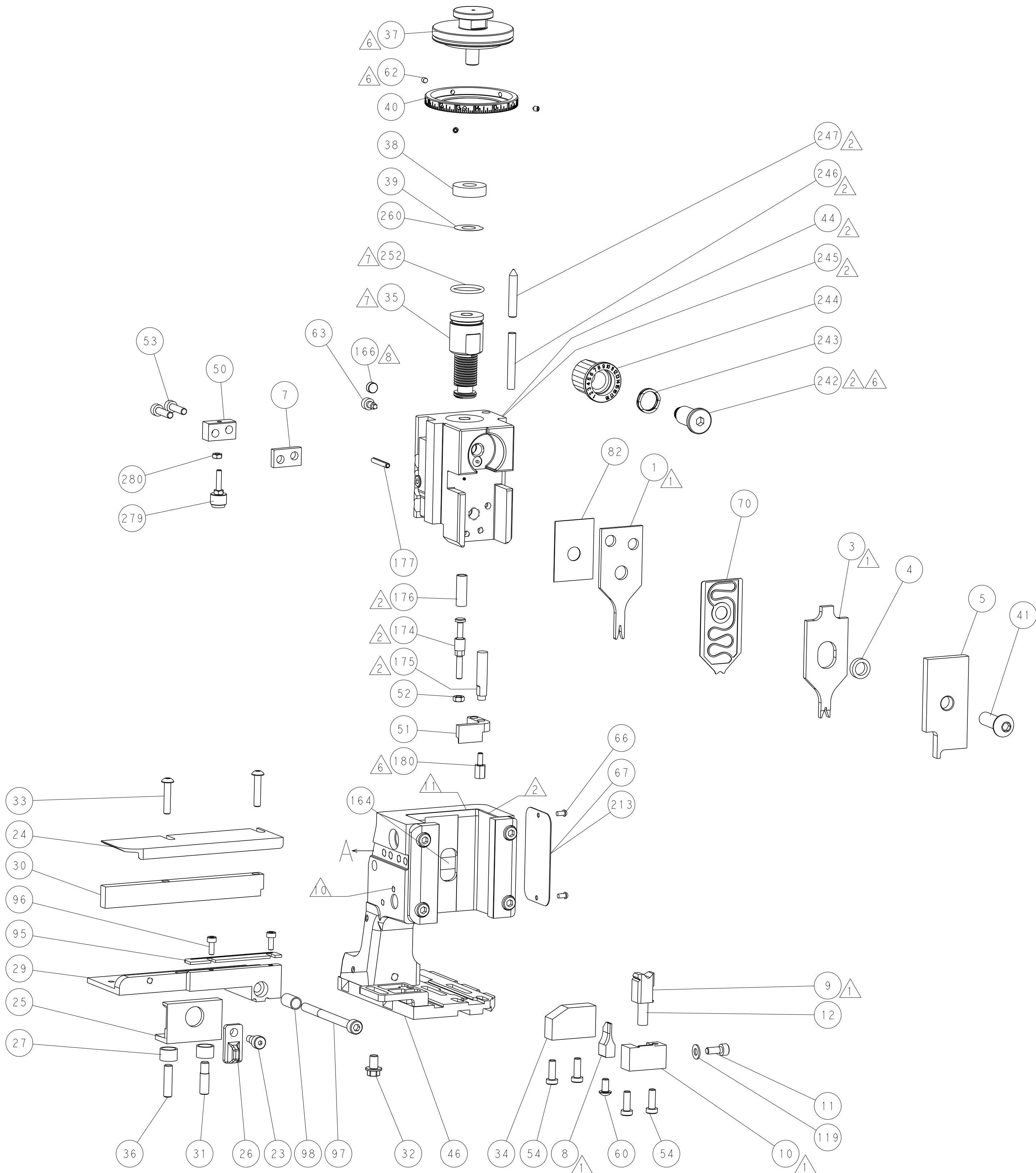
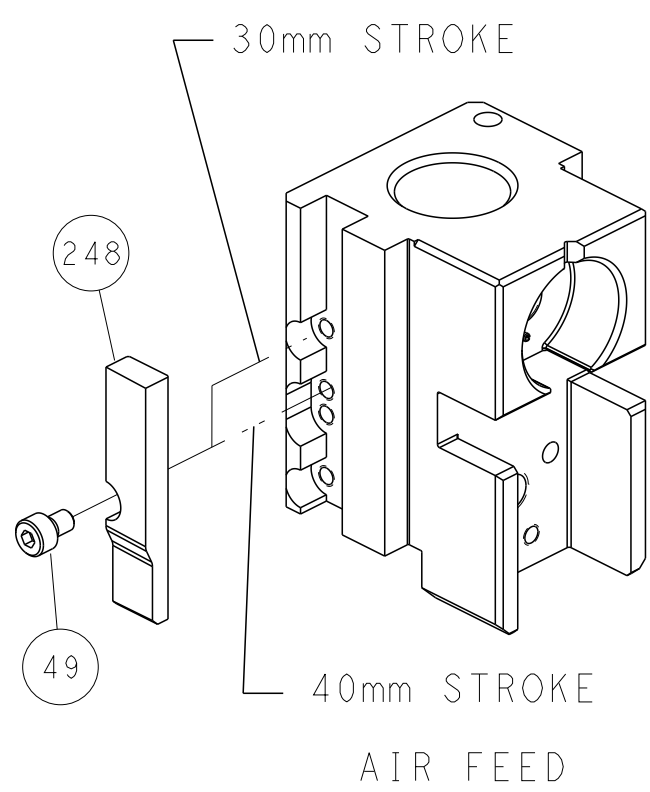
PNEUMATIC



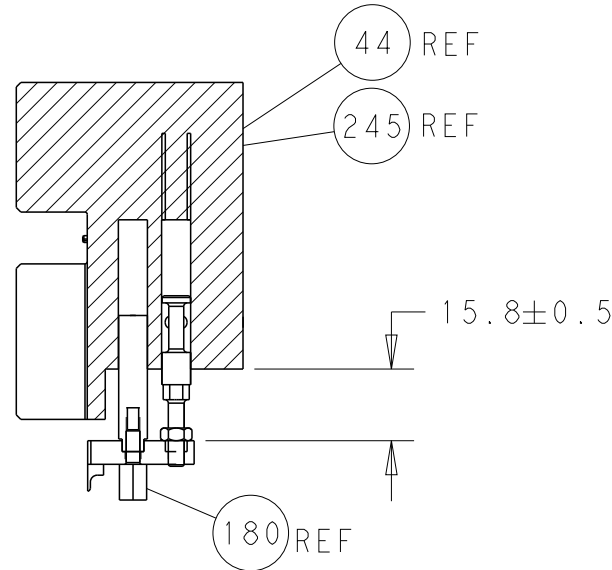
SERVO LATCH PLATE



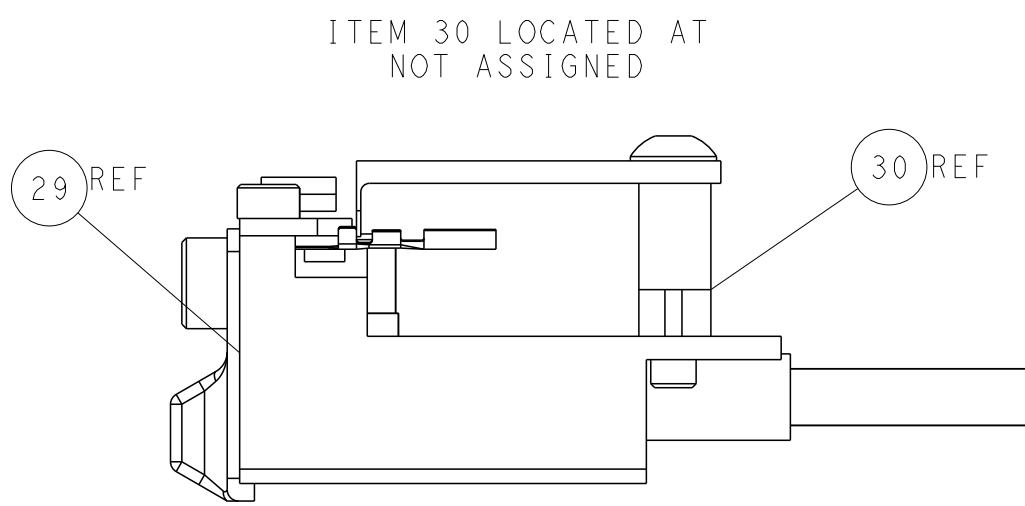
CAM POSITION



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY GUIDE_BY_STR

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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CHK G. BAILEY 24APR2014				APVD J. GUO 24APR2014	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm				PRODUCT SPEC	SIZE A1	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				APPLICATION SPEC	CAGE CODE 00779	
MATERIAL -				WEIGHT -	DRAWING NO. C-2266278	
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2	REV C

PNEUMATIC

Diagram illustrating the assembly of a pneumatic cylinder. The main components are shown in an exploded view, with callouts indicating the sequence of assembly:

- 250: Air line with connector
- 249: Air line with connector
- 238: Air line with connector
- 163: Piston rod with seal
- 59: Piston rod with seal
- 136: Piston rod with seal
- 137: Piston rod with seal
- 172: Piston rod with seal
- 56: Piston rod with seal
- A: Air line with connector
- C: Piston rod with seal

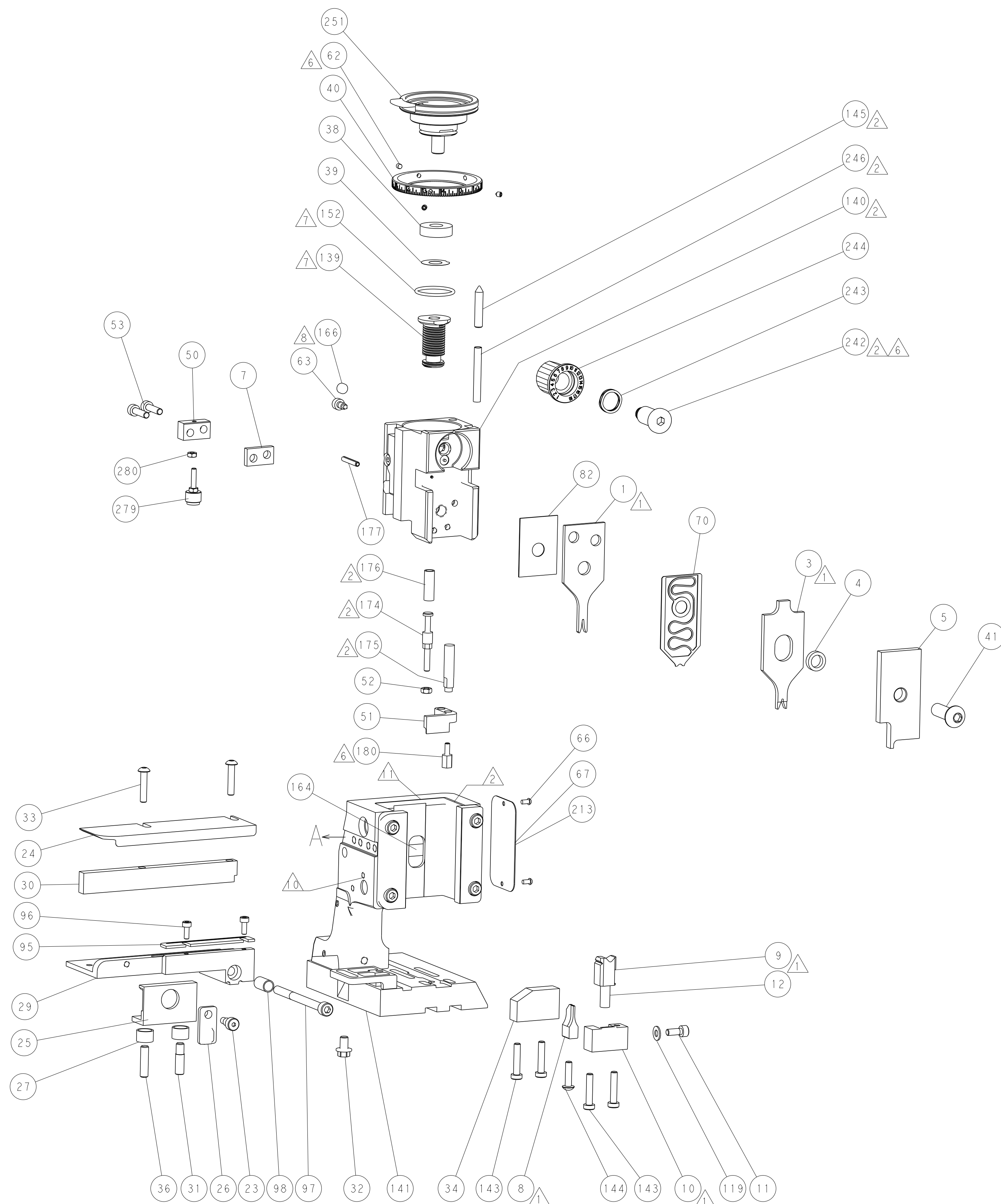
Diagram of the STE servo feeder assembly. The main unit is labeled 'STE' and has a warning symbol. A callout shows the servo motor assembly with parts 240, 133, 135, 198, and 117 (REF). An arrow points to the servo motor assembly.

30mm STROKE

151

49

AIR FEED



HOLDDOWN SET-UP

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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						CHE G.BAILEY 24APR2014	
DIMENSIONS: mm						TE Connectivity Harrisburg, PA 17105-3608	
TOLERANCES UNLESS OTHERWISE SPECIFIED: Ø PLC ± H PLC ± P PLC ± R PLC ± S PLC ± ANGLES ±°						NAME Ocean Side Feed Applicator	
MATERIAL - FINISH -						PRODUCT SPEC U QUO APPLICATION SPEC -	
WEIGHT -						SIZE CASE CODE DRAWING NO RESTRICTED TO A 00779 C=2266278	
Customer Accessible Product						SCALE 1:2 SHEET 4 OF 4 REV C	