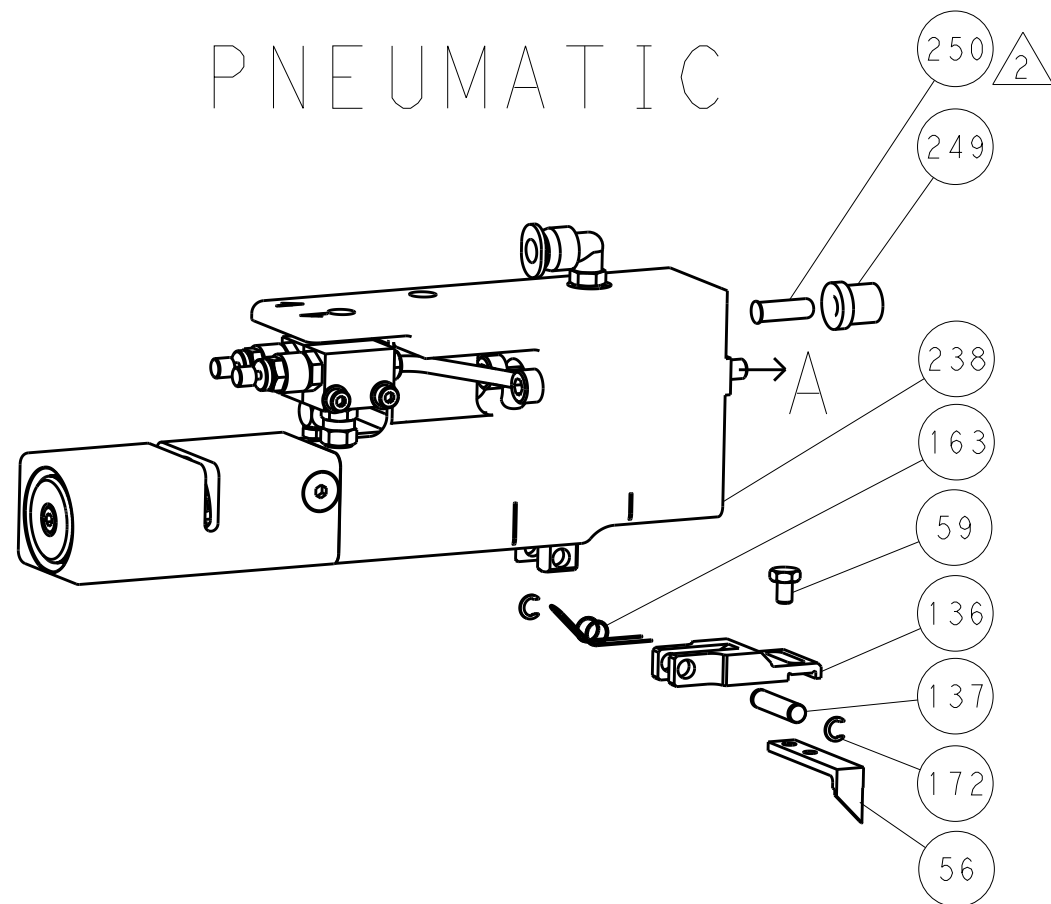


LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE
MECHANICAL



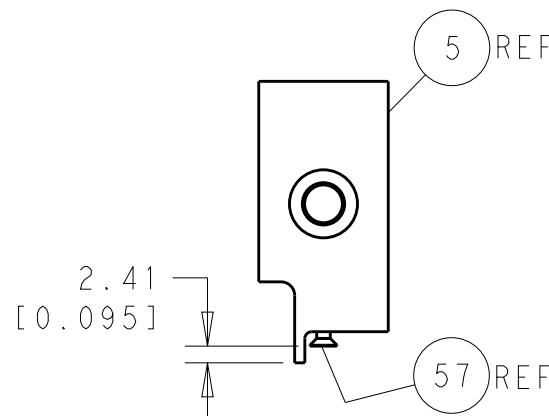
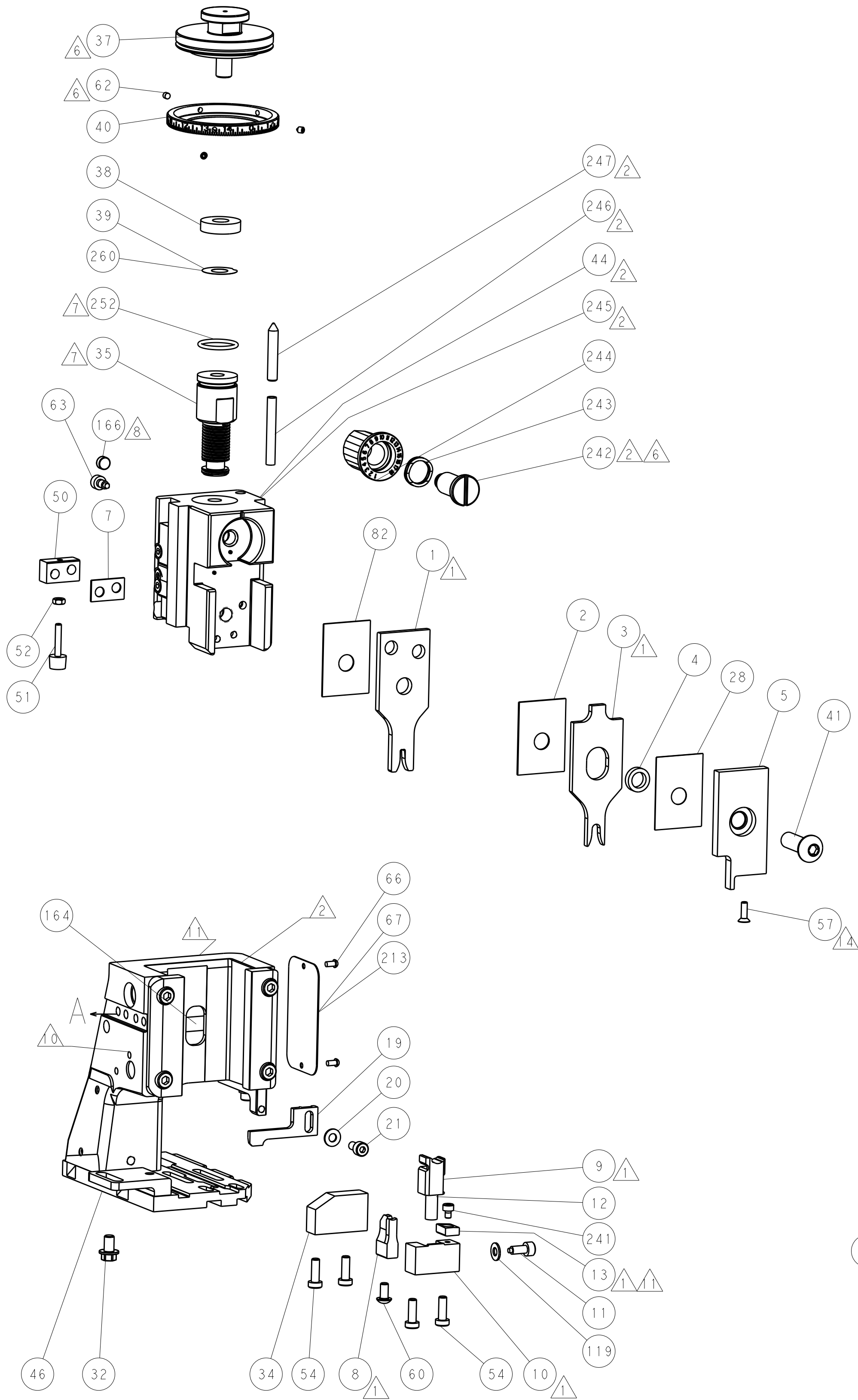
PNEUMATIC



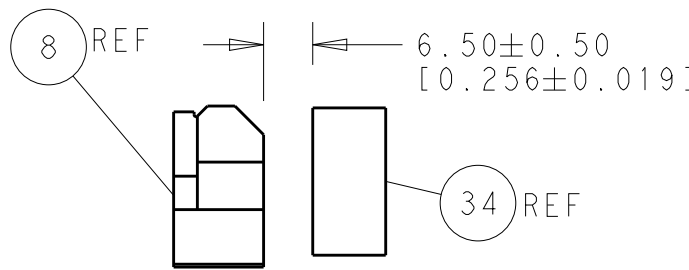
SERVO
LATCH PLATE



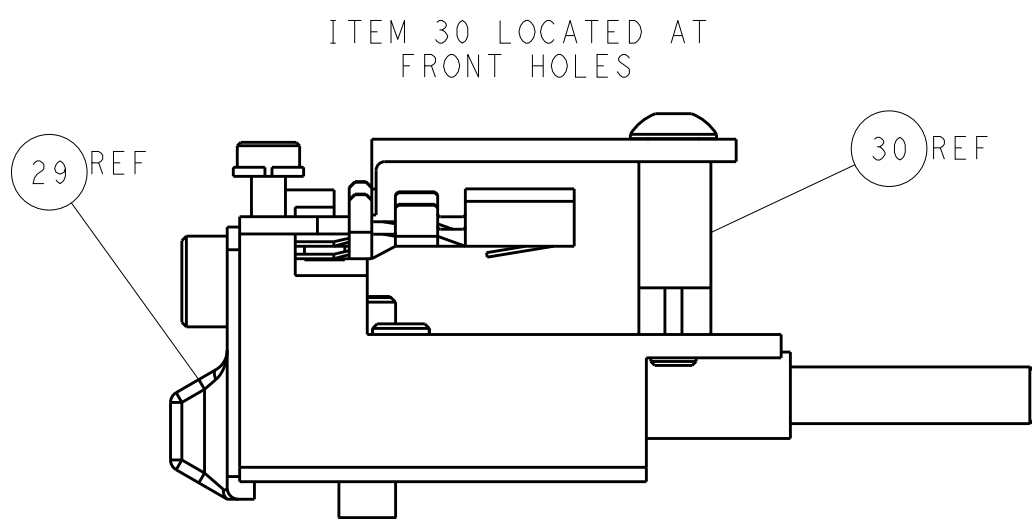
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

FIRST PUBLISHED BY: 01NOV2013 THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN: X. ZHAO 01NOV2013 CHK: T. ELBIN 01NOV2013 APVD: L. ZHANG 01NOV2013				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES FINISH				NAME: Ocean Side Feed Applicator			
MATERIAL: -				WEIGHT: -				SIZE: A1 00779 C=2266098			
Customer Accessible Production Drawing				SCALE: 1:2				SHEET 2 OF 4 REV A			

8

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1

THIS DRAWING IS UNPUBLISHED.

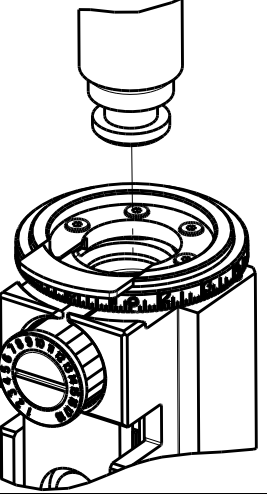
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2266098-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

CONVERT TO

SERVO LATCH PLATE

2119951-1

-

8-2266098-5

1901094-3

-

2168400-6 (QUANTITY 2)

CONVERT TO

SMART APPLICATOR

2161326-1

-

8-2266098-4

-

-

-

CONVERT TO

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

CONVERT TO

SERVO LATCH PLATE

2119951-1

-

8-2266098-5

1901094-3

-

2168400-6 (QUANTITY 2)

CONVERT TO

SMART APPLICATOR

2161326-1

-

8-2266098-4

-

-

-

CONVERT TO

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

CONVERT TO

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

CONVERT TO

-

-

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-

-

-

CONVERT TO

-

-

-

-

-

-

2-2266098-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2266098-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266098-4

-

-

-

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

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2-2266098-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2266098-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266098-4

-

-

-

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

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-

2-2266098-7

A

FINE CRIMP HEIGHT ADJUST

NONE

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2266098-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266098-4

-

-

-

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

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7-2266098-7

A

CRIMP TOOLING KIT

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2266098-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266098-4

-

-

-

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

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-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.46 mm [.097]

F

INSUL

4.60 mm [.181]

O

APPLICATOR INSTRUCTIONS

408-10389

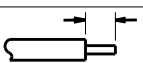


TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION

TERMINAL NAME: DELPHI TERMINAL

WIRE STRIP LENGTH

4.80-5.56 mm [.189-.219 IN]



INSULATION DIAMETER RANGE

Ø



TERMINAL APPLICATION SPECIFICATION

DELPHI SPEC

-

-

TERMINALS APPLIED

TE TERMINAL

DELPHI TERMINAL

TE SEAL

DELPHI SEAL

SEAL Ø

2113389-1

12077412

1949807-1

15324982

2.03-2.85

1949807-2

15324984

2.03-2.42

WIRE SIZE



CRIMP HEIGHT

mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



1.50mm2

1.80+/-0.05 [.071+/-0.002]

8.2

1.00mm2

1.70+/-0.05 [.067+/-0.002]

9.3



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: 8-2266098-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266098-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266098-5

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 ITEMS 62 & 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.

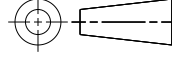
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-77	-27	-25	-22	-21	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	DIST 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	OWN	APVD
				-	SEE SHEET 1	-	-	-

-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	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	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	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	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	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	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	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	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	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	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	3-1633928-7	ANVIL, COMBINATION	8
-	1	1	1	1	1-240641-9	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119781-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	6-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	1	2-1633609-8	CRIMPER, WIRE	1

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE CONTACTED FOR THE LATEST REVISION.		OWN X. ZHAO	01NOV2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN	01NOV2013	NAME Ocean Side Feed Applicator	
		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.5		PRODUCT SPEC -	
		FINISH -		APPLICATION SPEC -	
MATERIAL -		WEIGHT -		SIZE A1	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 3 of 4	
REV A		DRAWING NO 00779		RESTRICTED TO -	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

AMP 4805 REV 31MAR2000

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

D

C

B

A

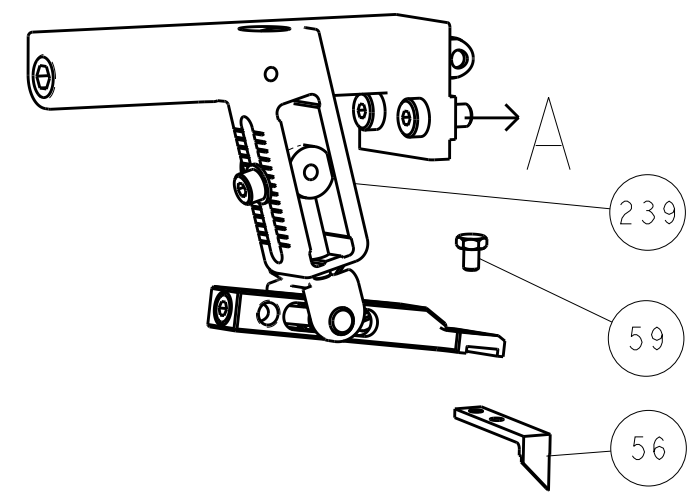
D

C

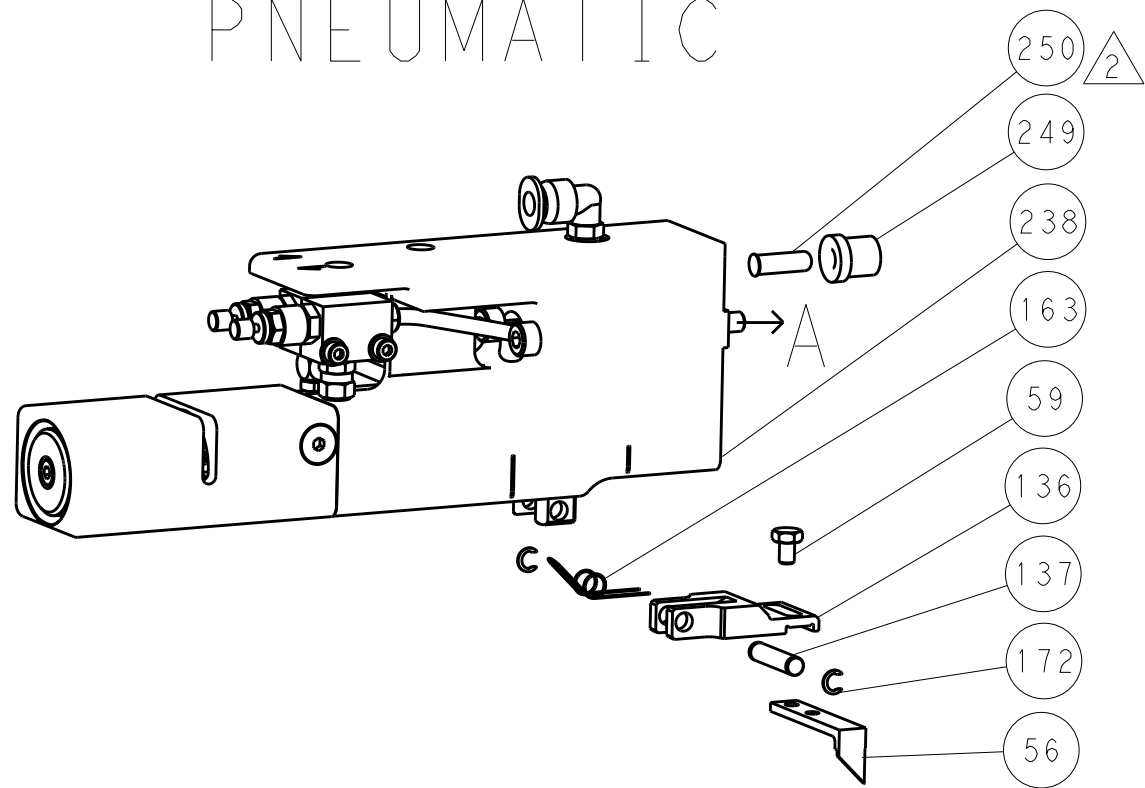
B

A

FEED TYPE MECHANICAL



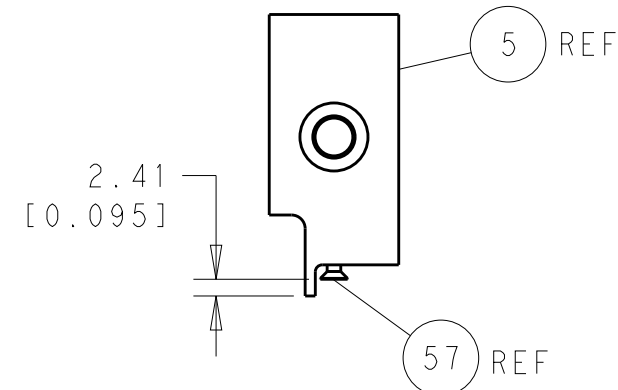
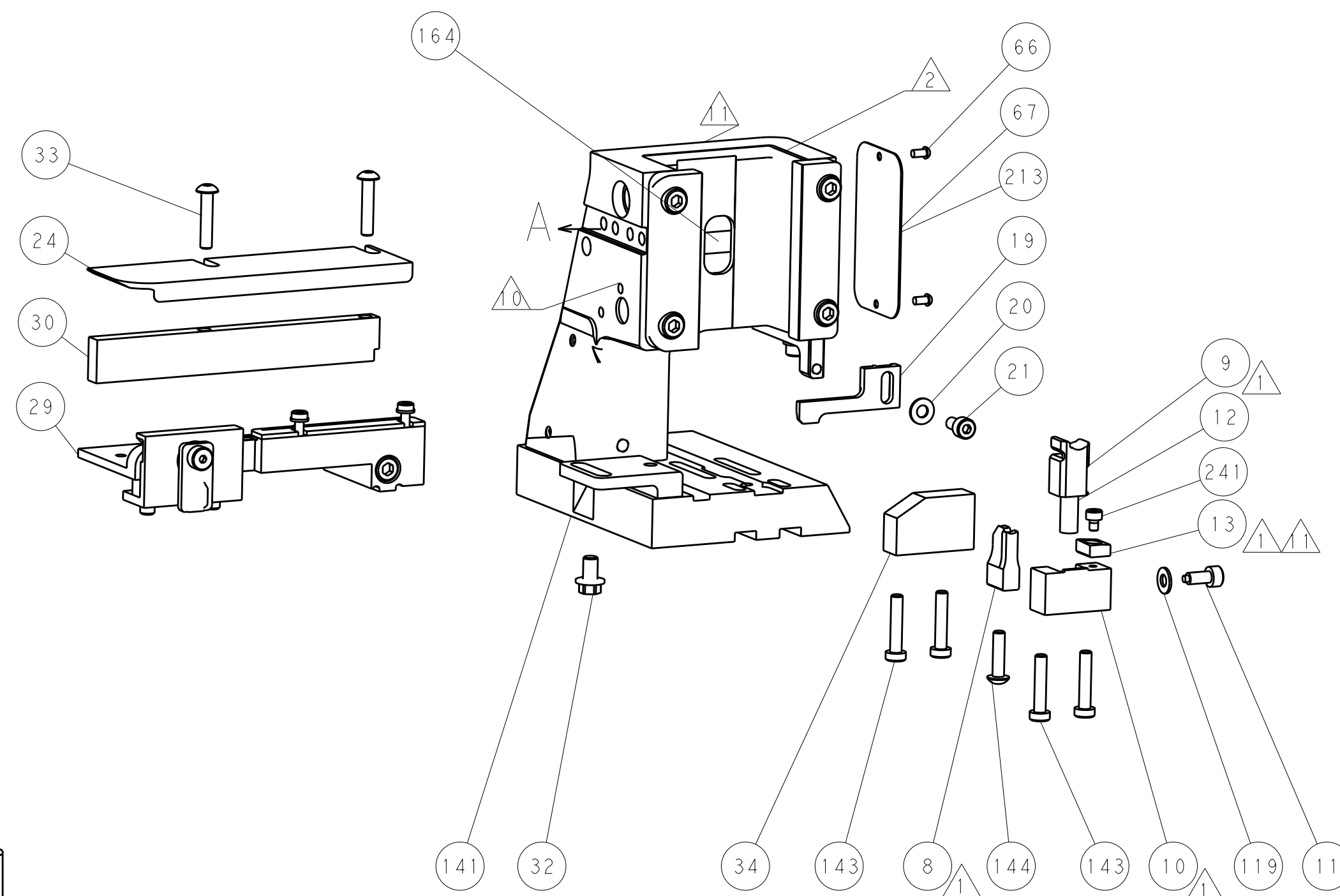
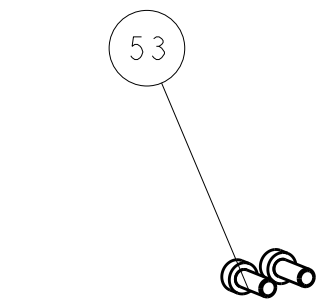
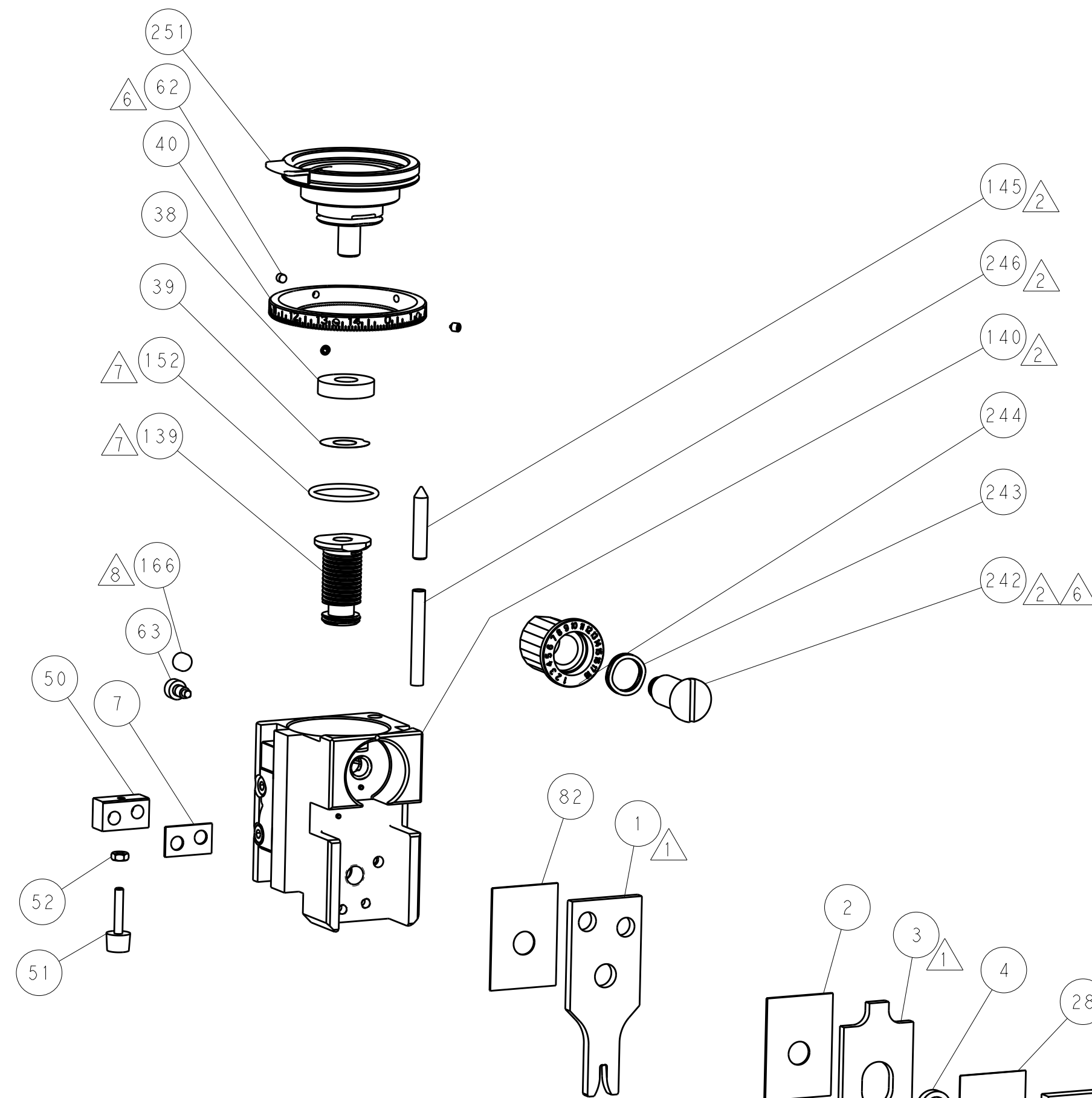
PNEUMATIC



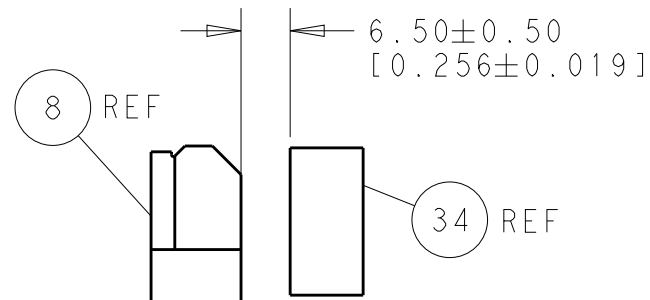
SERVO LATCH PLATE



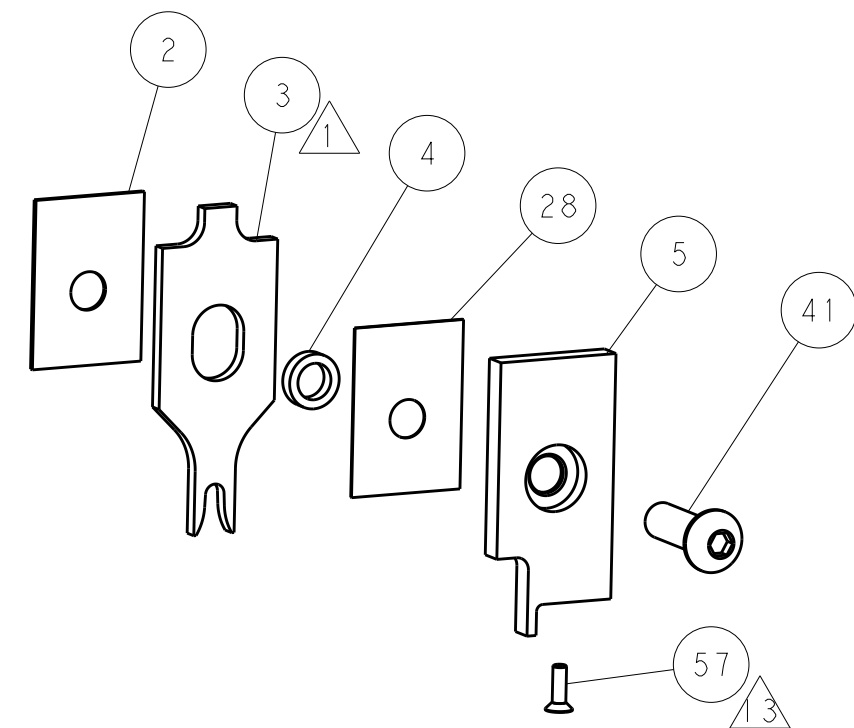
CAM POSITIONS



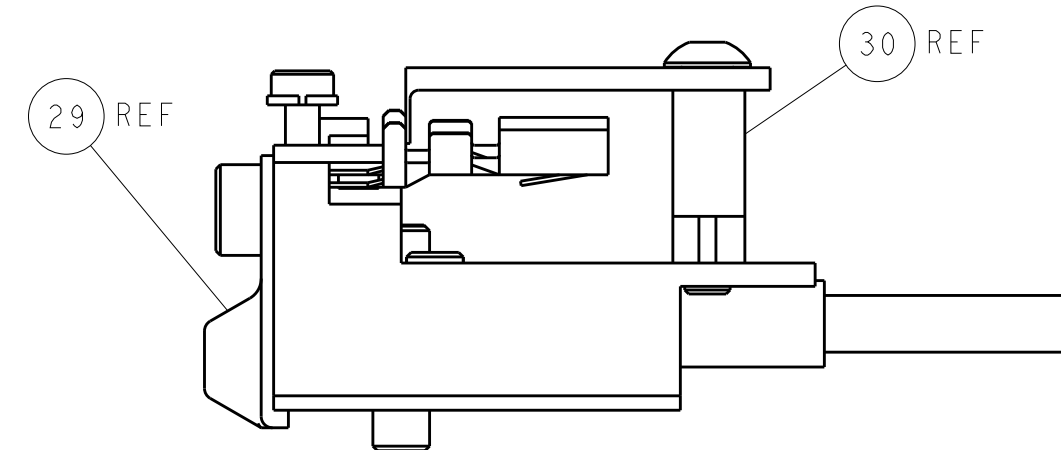
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT
FRONT HOLES



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 X.ZHAO 01NOV2013		CHK T.ELBIN 01NOV2013		APVD L.ZHANG 01NOV2013		NAME Ocean Side Feed Applicator	
mm		0 PLC ±0.5		PRODUCT SPEC		APPLICATION SPEC		SIZE A1		CAGE CODE 00779	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE 1:2		SHEET 4 OF 4	
										REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION