

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

20

© COPYRIGHT 20

BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

REVISION

DESCRIPTION

FEED TYPE

2266309-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

2266309-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2266309-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

2266309-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

2266309-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2266309-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.29 mm [.090]

F

INSUL

2.45 mm [.096]

F

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .070 SERIES RECEPTACLE CONTACT

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

3.50-4.50 mm [.138-.177 IN]

2.00-2.60 mm [.079-.102 IN]

1.70-2.40 mm [.067-.094 IN]

TERMINAL APPLICATION SPECIFICATION

(A)114-5092

(B)114-5092-3

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

(A) 173645-1

(A) 173645-2

(A) 173645-3

(A) 173645-4

(A) 173645-5

(B) 175189-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

1.25mm2

1.52+/-0.05 [.060+/- .002]

6.3

0.85mm2

1.37+/-0.05 [.054+/- .002]

7.8

0.50mm2

1.25+/-0.05 [.049+/- .002]

9.2

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: 8-2266309-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266309-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266309-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266309-6

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 ITEMS 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 4.28.

13

TERMINAL
PART NUMBER

INSULATION
DIAMETER RANGE

173645

2.0-2.6 mm [.079-.102 IN]

345212

1.7-2.4 mm [.067-.094 IN]

175189

2.0-2.6 mm [.079-.102 IN]

AMP 4805 REV 31MAR2000

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

SERVO LATCH PLATE

2119951-1

-

8-2266309-5

1901094-3

1-1752354-5

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266309-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-1

-

-

-

SERVO LATCH PLATE

2119951-1

-

8-2266309-5

1901094-3

1-1752354-5

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266309-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-1

-

-

-

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

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

A

RELEASED

16MAT2014

LG

TE

A1

ECR-14-017986

02DEC2014

KH

TE

6

1

1

1

1

1

2119082-7

CAM, SNAIL, INSULATION ADJUSTMENT

244

6

1

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

6

1

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

6

1

1

1

1

1

7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

6

-

2

2

-

-

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

6

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

6

-

-

-

-

1

2063440-1

AIR FEED MODULE

238

6

-

1

1

-

-

2119740-2

TAG,IDENTIFICATION

213

6

-

1

1

-

-

1901094-3

SPACER, FEEDER

198

6

1

1

1

1

1

1-1752354-5

STANDOFF,HOLD-DOWN

180

6

1

1

1

1

1

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

6

1

1

1

1

1

8-22280-7

SPRING, COMPRESSION

176

6

1

1

1

1

1

1752353-2

GUIDE PIN,HOLDDOWN

175

6

1

1

1

1

1

1901680-2

GUIDE PIN,HOLDDOWN

174

6

-

-

-

-

2

-

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

6

1

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

6

-

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

6

-

-

-

-

1

-

240638-1

SPRING, FEED FINGER

163

6

-

-

-

-

1

-

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

6

-

-

-

-

1

-

2119799-1

HOLDER,FEED FINGER, AF

136

6

-

-

REF

REF

-

-

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

6

-

-

1

1

-

-

1633743-1

SERVO FEED LATCH ASM

133

6

1

1

1

1

1

1-18028-2

WASHER, FLAT, REG M4

119

6

-

-

REF

REF

-

-

2119944-1

FEED FINGER ASSEMBLY,SF

117

6

1

1

1

1

1

455888-4

SPACER, CRIMPER

82

6

1

1

1

1

1

22278-8

SPRING, COMPRESSION

77

6

1

1

1

1

1

854769-4

HOLDER, INS

74

6

1

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

6

1

-

-

-

1

1

2119740-1

TAG,IDENTIFICATION

67

6

2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

6

1

-

-

1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

6

3

-

3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

6

1

1

1

1

1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

6

-

-

-

-

1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

6

1

1

1

1

1

21028-2

PIN, SLOTTED SPRING .062 X .250

58

6

-

-

-

-

1

1

1338685-1

PAWL, FEED

56

6

4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

6

1

1

1

1

1

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

6

1

1

1

1

1

1901681-1

HOLDDOWN, TERMINAL

51

6

-

-

-

-

1

2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

6

-

-

-

-

-

1

2119652-1

FEED CAM, PRE FEED

48

6

-

-

-

-

-

1

2119653-1

FEED CAM, POST FEED

47

6

1

1

1

1

1

2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

6

1

-

-

1

1

1

2119370-1

RAM, AMP STYLE, SIDE FEED

44

6

1

1

1

1

1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

6

1

-

-

1

1

1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

6

1

-

-

1

1

1

2119957-1

APPLICATOR SHIM PACK

39

6

1

1

1

1

1

1-2119644-2

RAM WASHER, PRECISION

38

6

1

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

6

1

-

-

1

1

1

2119092-1

BOLT, ADJUSTMENT

35

6

1

1

1

1

1

1752356-3

SUPPORT, TERMINAL

34

6

2

2

2

2

2

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

6

1

1

1

1

1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

6

1

1

1

1

1

1-1320908-0

SPACER, STRIP GUIDE

30

6

1

1

1

1

1

2119959-1

ASSEMBLY, STRIP GUIDE

29

6

1

1

1

1

1

455888-3

SPACER, CRIMPER

28

6

1

1

1

1

1

1320928-2

STRIP GUIDE

24

6

1

1

1

1

1

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

6

1

1

1

1

1

1-18028-2

WASHER, FLAT, REG M4

20

6

1

1

1

1

1

2119533-1

STRIPPER, SIDE FEED

19

1

1

1

1

1

1

2119806-1

INSERT, SHEAR

13

1

1

1

1

1

1

3-22280-3

SPRING, COMPRESSION

12

1

1

1

1

1

1

1-356885-4

STOP, SHEAR

11

1

1

1

1

1

1

2119805-1

SHEAR HOLDER, FRONT

10

1

1

1

1

1

1

462006-6

FLOATING SHEAR, FRONT

9

1

1

1

1

1

1

1-1633922-8

ANVIL, COMBINATION

8

1

-

-

-

-

-

-

-

7

1

-

-

-

-

-

-

-

6

1

1

1

1

1

1

1-2119780-2

DEPRESSOR, SHEAR

5

1

1

1

1

1

1

238011-9

BLOCK, CRIMPER SPACER

4

1

1

1

1

1

1

8-1633961-0

CRIMPER, INSULATION F PREMIUM

3

1

1

1

1

1

1

455888-4

SPACER, CRIMPER

2

1

1

1

1

1

1

4-456406-3

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

7

6

5

4

3

2

1

THIS IS SUBJECT TO CHANGE BASED ON THE LATEST REVISIONS OF THE APPLICATOR INSTRUCTION SHEET. THE USER SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.13

4 PLC ±0.0001

ANGLES ±.5

FINISH

MATERIAL

-

APVD

DATE

NAME

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

SCALE

SHEET

OF

REV

Customer Accessible Production Drawing

1:2

4

A1

TE Connectivity

Harrisburg, PA 17105-3608

Ocean Side Feed
Applicator

00779

2266309

Customer Accessible Production Drawing

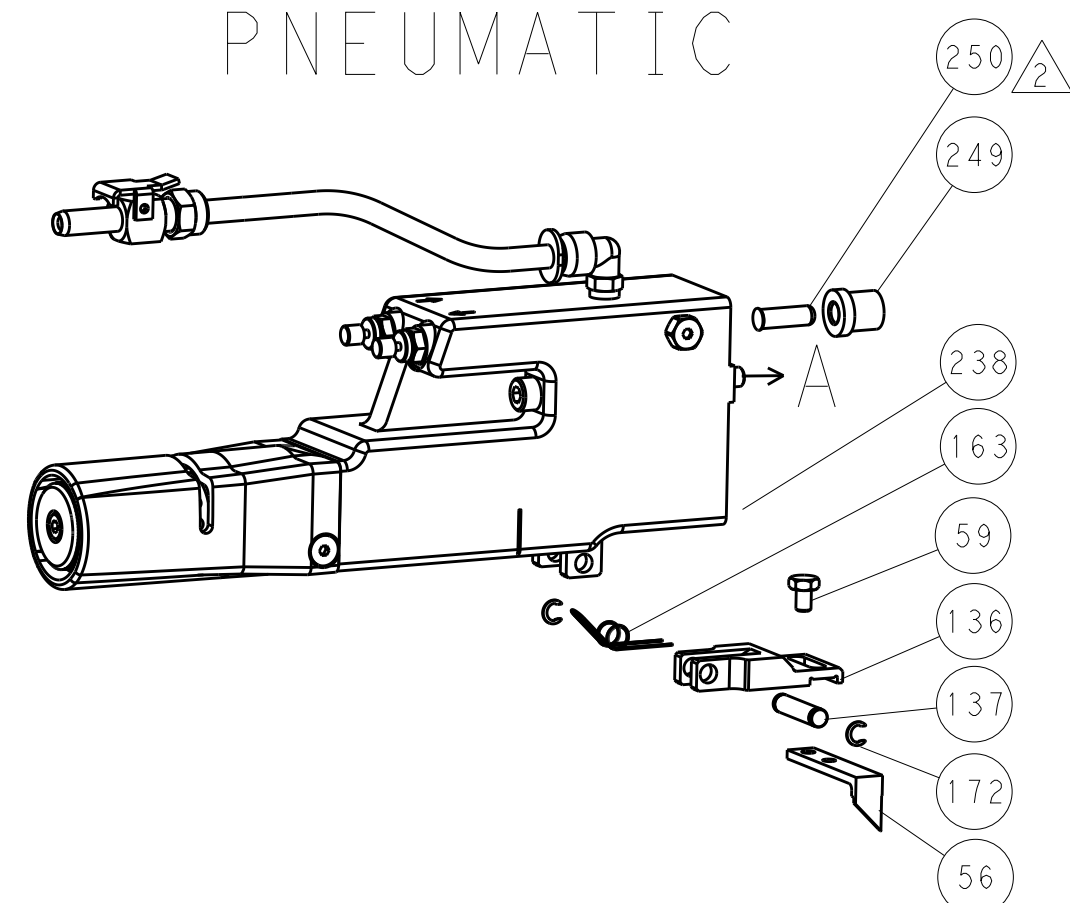
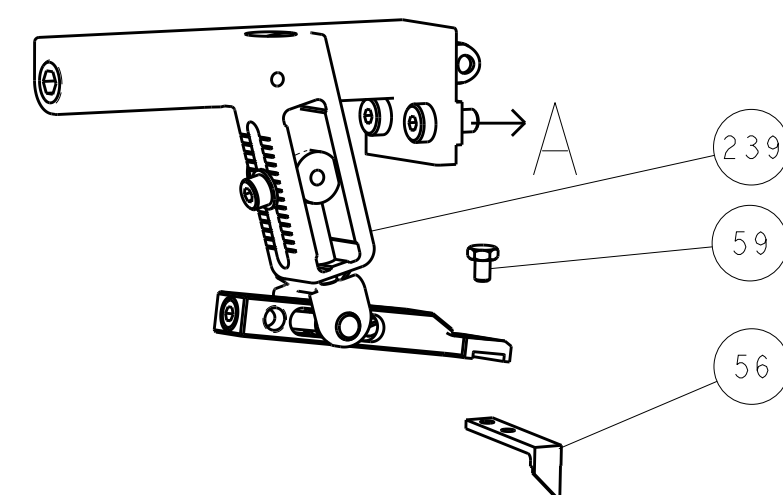
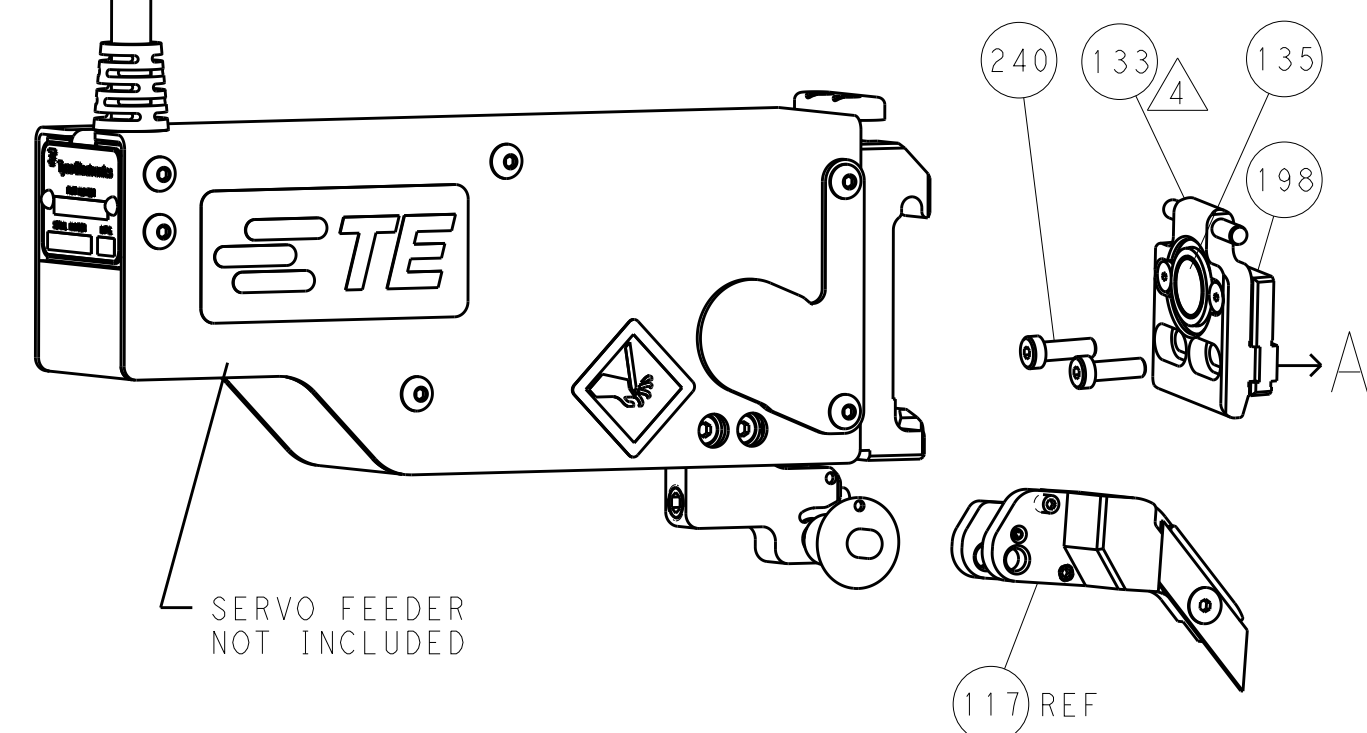
1:2

4

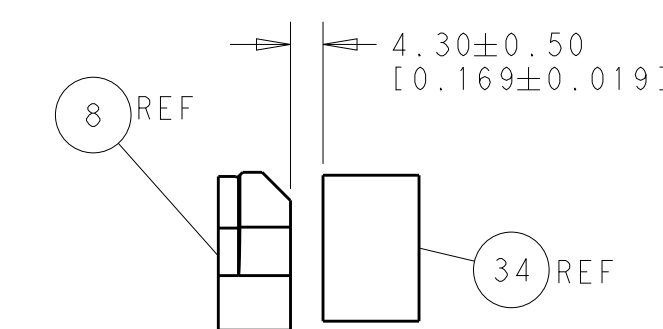
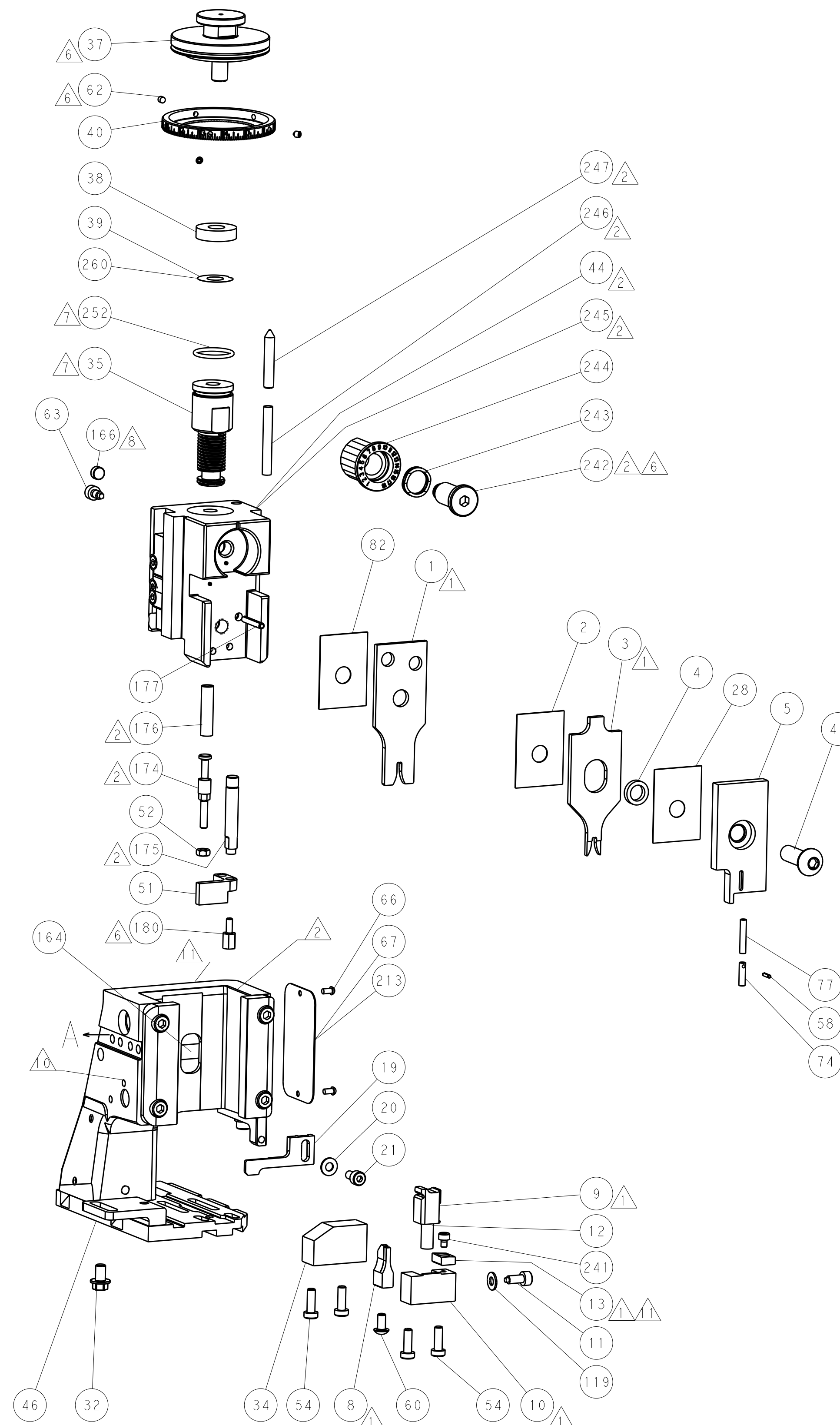
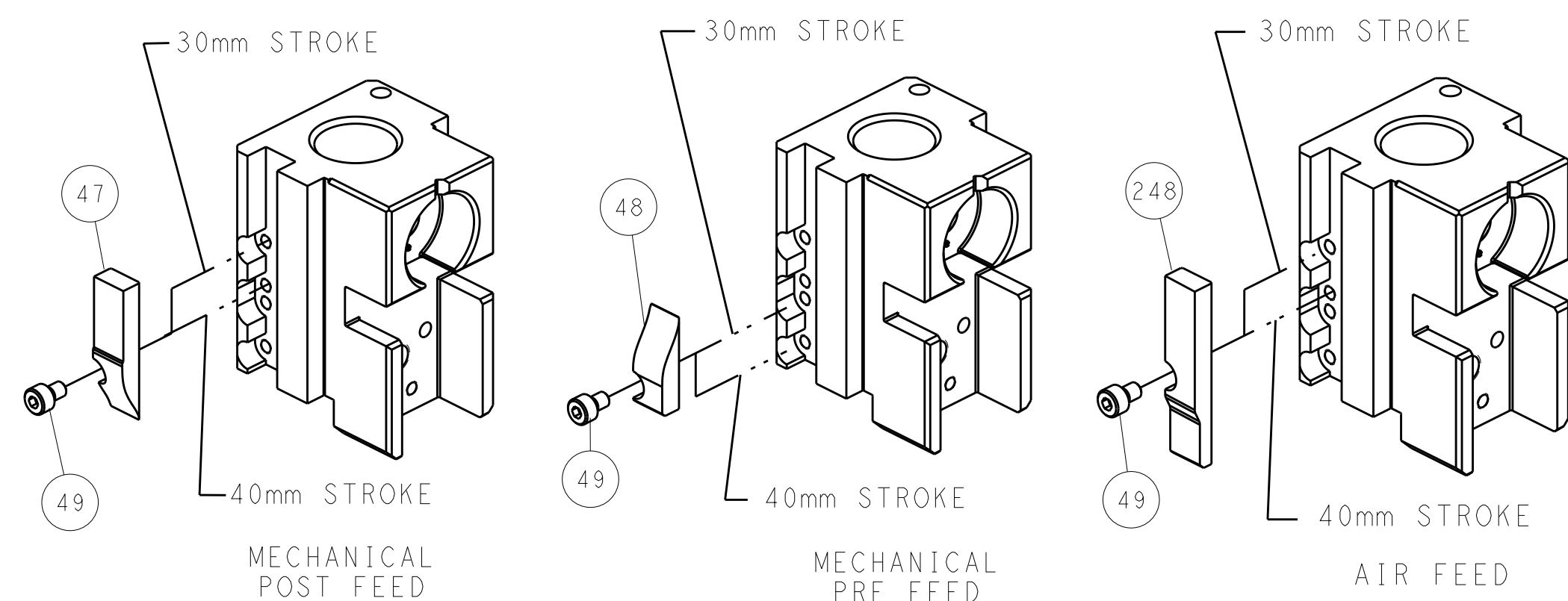
A1

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

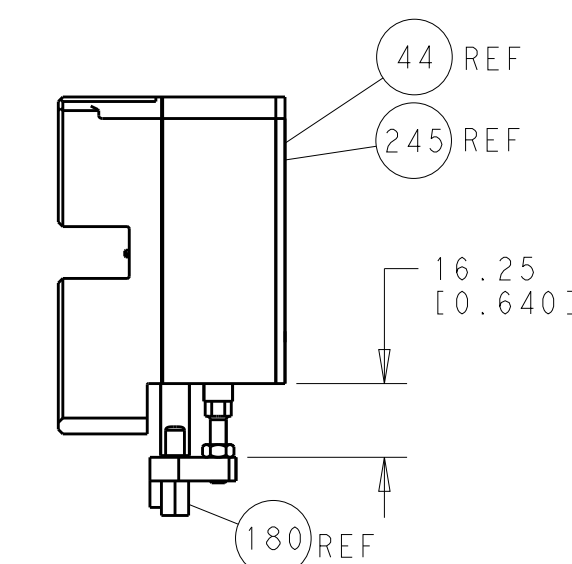
PNEUMATIC

SERVO
LATCH PLATE

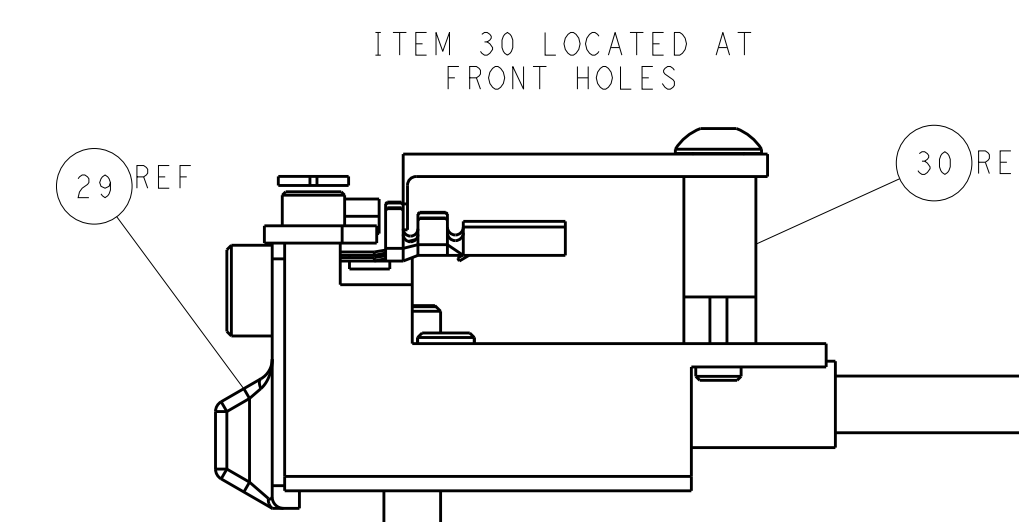
CAM POSITIONS



TERMINAL SUPPORT LOCATION



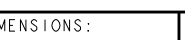
HOLDDOWN SET-UP



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)

THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION MAY BE REQUIRED TO MODIFY FOR THE LATEST REVISIONS		DWN 030C12013 L GROSS CHK 030C12013 ELBIN M CLIFFORD 030C12013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES		NAME Ocean Side Feed Applicator -	
MATERIAL -		FINISH -		WEIGHT -	
		SIZE A		CAGE CODE 00779	
		DRAWING NO C=2266309		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 of 4 REV A	

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

D

C

B

A

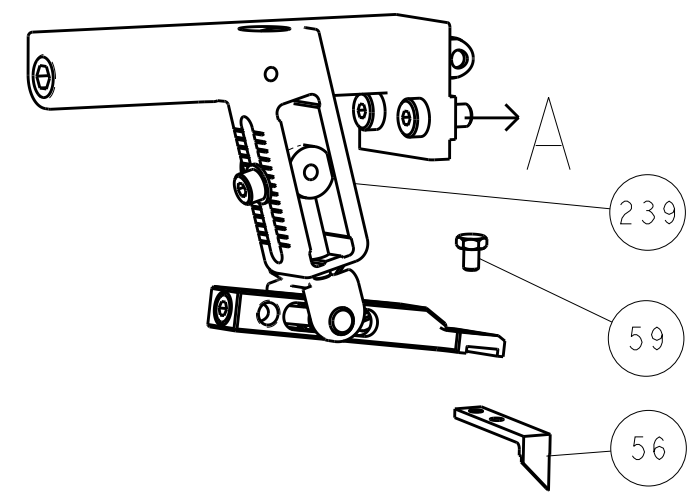
D

C

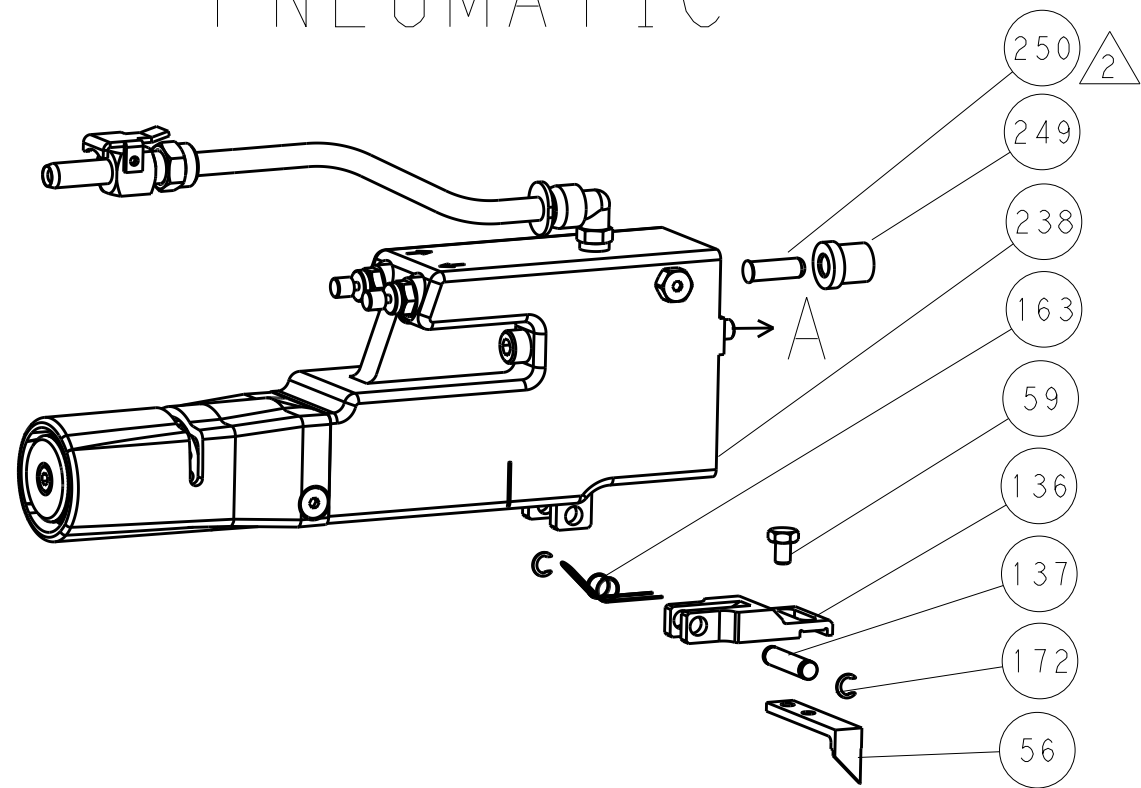
B

A

FEED TYPE MECHANICAL



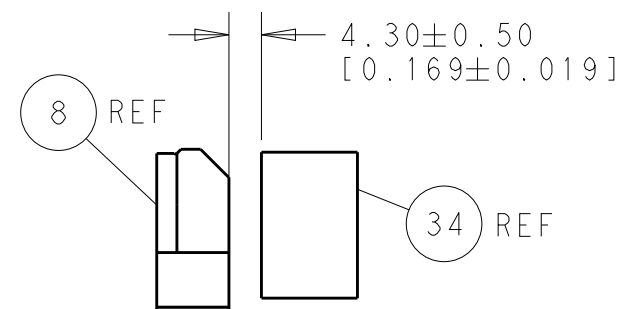
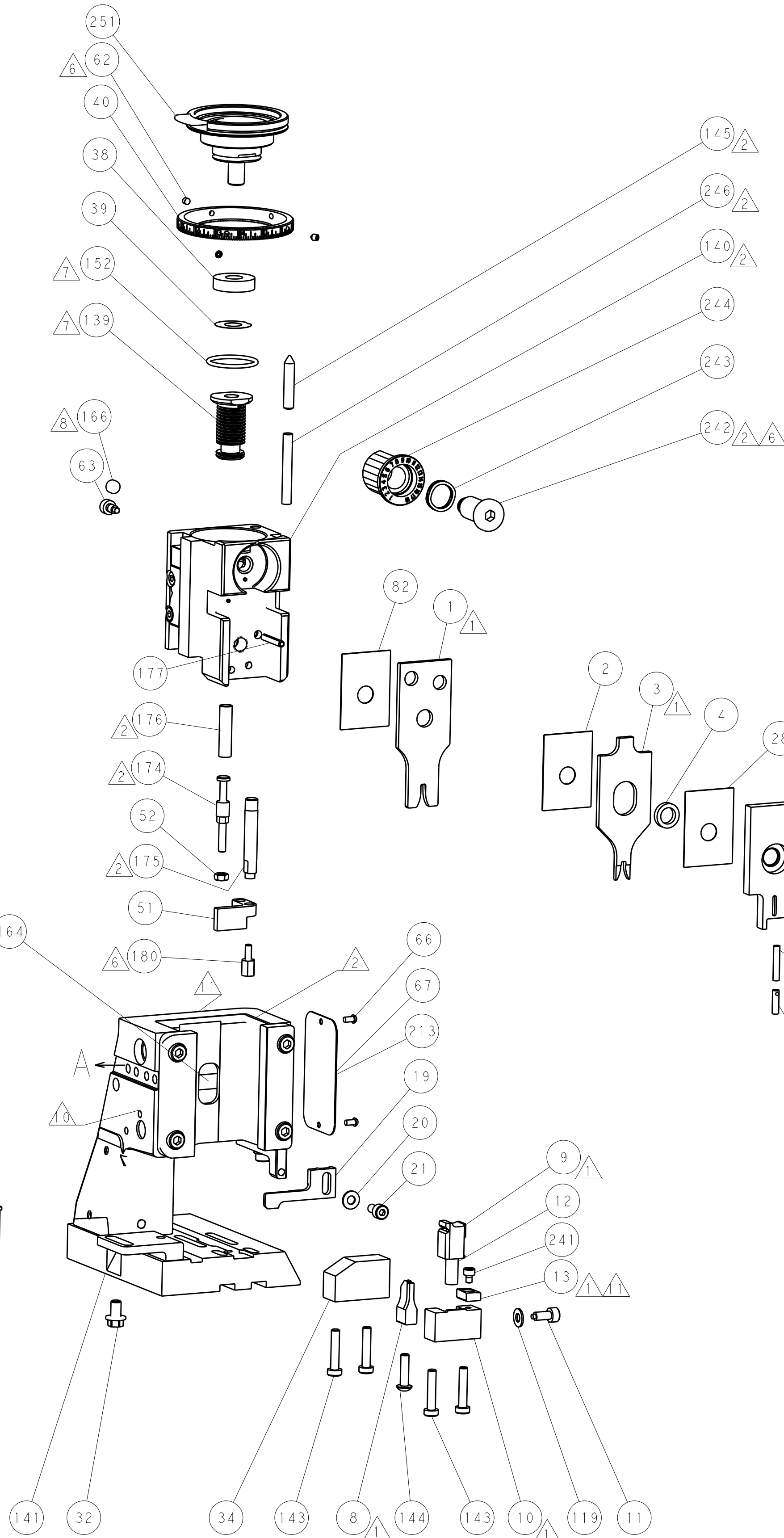
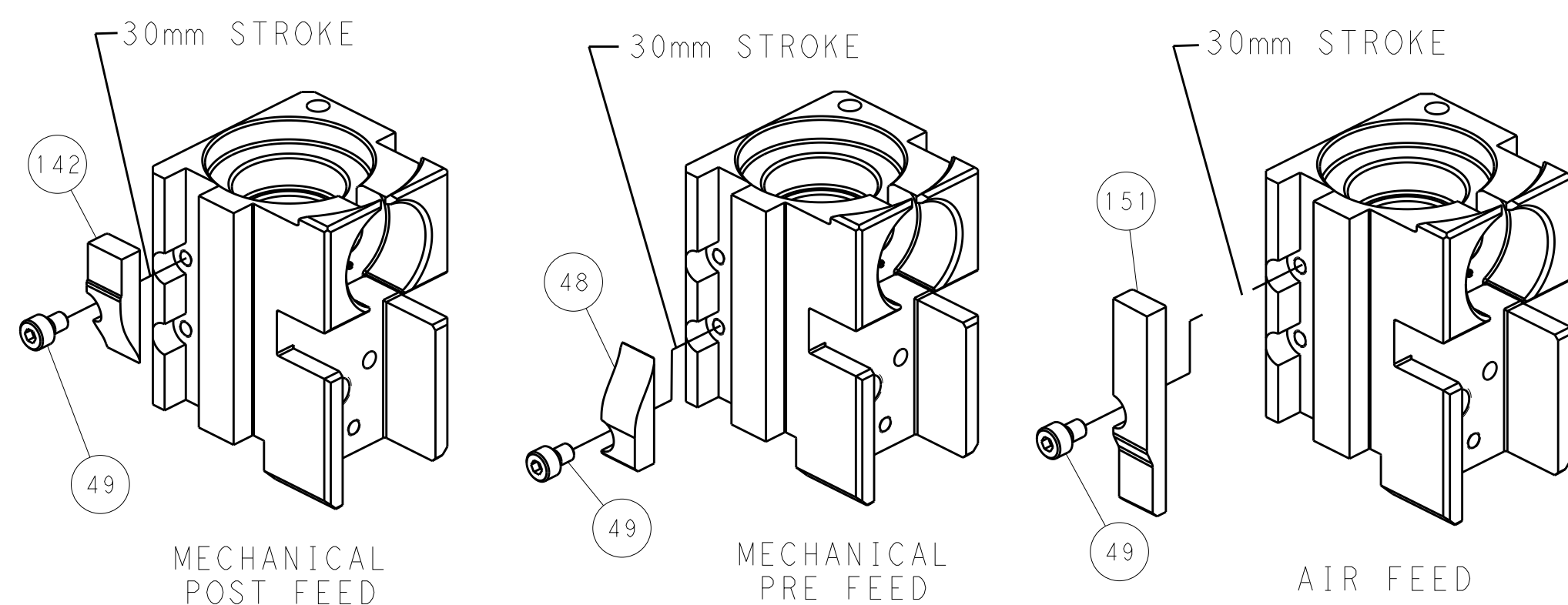
PNEUMATIC



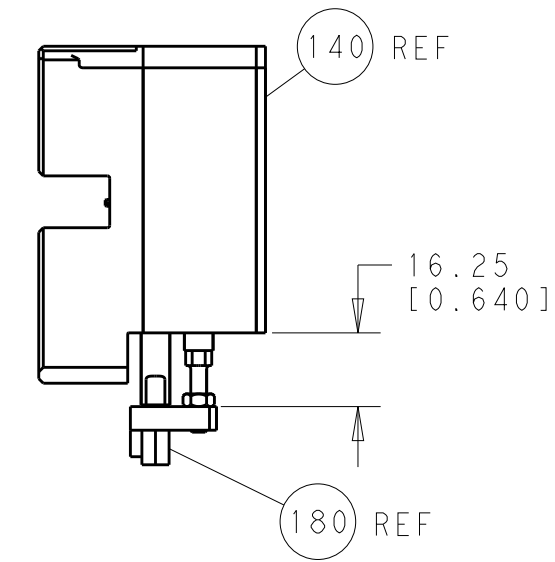
SERVO LATCH PLATE



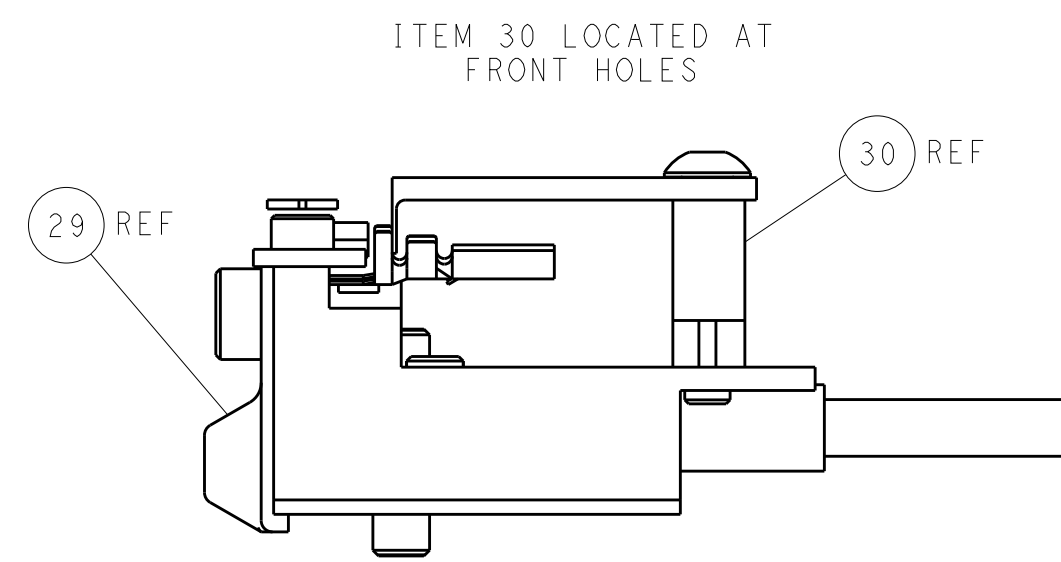
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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		03OCT2013		TE Connectivity	
mm		0 PLC ±0.5		CHK		03OCT2013		Harrisburg, PA 17105-3608	
		1 PLC ±0.13		APVD		03OCT2013		NAME	
		2 PLC ±0.013		M. CLIFFORD		PRODUCT SPEC		Ocean Side Feed	
		3 PLC ±0.001				APPLICATION SPEC		Applicator	
		4 PLC ±0.001				WEIGHT		SIZE	
		FINISH				Customer Accessible Production Drawing		CAGE CODE	
						SCALE		DRAWING NO	
						1:2		00779	
						SHEET		REV	
						4		A1	
						OF		4	
						REV		A1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION