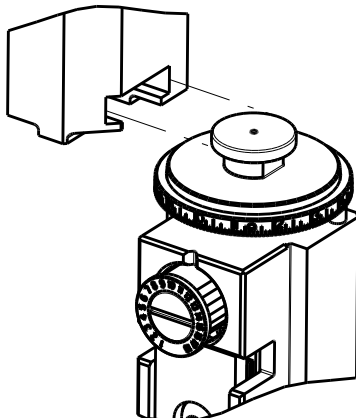


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2266166-1	A	FINE CRIMP HEIGHT ADJUST
	2266166-2	A	FINE CRIMP HEIGHT ADJUST
	2266166-5	A	FINE CRIMP HEIGHT ADJUST
	2266166-6	A	NON-CRIMP HEIGHT ADJUST
	2266166-7	A	FINE CRIMP HEIGHT ADJUST
	7-2266166-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	2.50 mm [.098]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: FCL TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL 1.5mm MALE			
WIRE STRIP LENGTH 4.57-4.95 mm [.180-.195 IN]		INSULATION DIAMETER RANGE Ø 2.54 mm [.100 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	13672903 Rev 02	-	-
TERMINALS APPLIED			
TE TERMINAL	FCL TERMINAL	TE TERMINAL	FCL TERMINAL
1832478-1	54001845	2113414-1	54001843
1832478-2	54001841		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18/20 AWG	1.27+/-0.05 [.050+/- .002]	4.8

- 

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: 8-2266166-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266166-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266166-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266166-6

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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.

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 4.53.

*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
-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	DWN
				I	DEVELOPMENT	04DEC2013	KH
				A	RELEASED	06JAN2014	BH
							UG
							TE

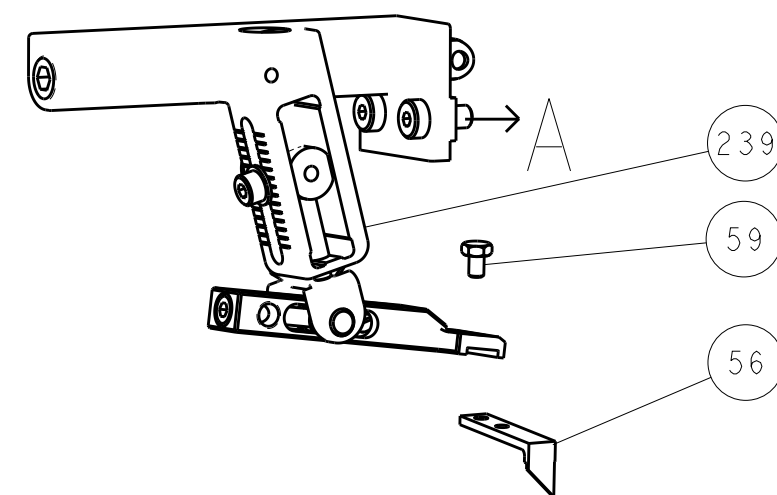
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	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
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	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	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	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	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	2119656-9	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	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	1752356-3	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	1320908-3	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	7-1633927-0	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1-1803018-1	CRIMPER, INSULATION O	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1	1	8-1633305-0	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS IS SUBJECT TO CHANGE AND TO BE USED FOR THE LATEST REVISIONS ONLY. IF IT IS SUBJECT TO CHANGE, THE USER SHOULD CONTACT THE ORGANIZATION FOR THE LATEST REVISIONS.										DWN A. HUANG 04DEC2013		 TE Connectivity Harrisburg, PA 17105-3608							
DIMENSIONS:										CHK L. ZHANG 04DEC2013		NAME							
mm										APVD J. GUO 04DEC2013		Ocean Side Feed Applicator -							
TOLERANCES UNLESS OTHERWISE SPECIFIED:										PRODUCT SPEC									
0 PLC ±.5										APPLICATION SPEC									
1 PLC ±0.13										WEIGHT									
2 PLC ±0.13										MATERIAL									
3 PLC ±0.013										FINISH									
4 PLC ±0.0001										Customer Accessible Production Drawing									
ANGLES ±.5										Customer Accessible Production Drawing									
MATERIAL										WEIGHT		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
-										-		A		00779		C=2266166		-	
										Customer Accessible Production Drawing		SCALE		1:2		SHEET 1 OF 4		REV A	

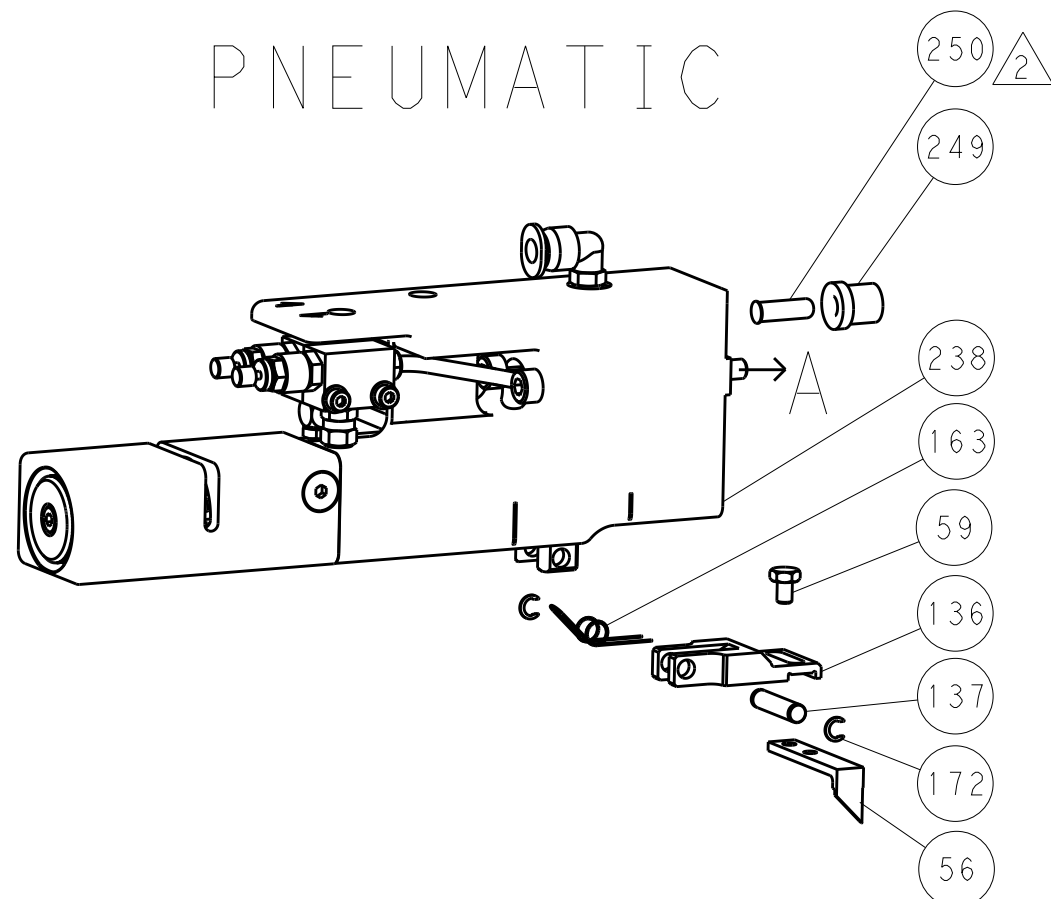
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

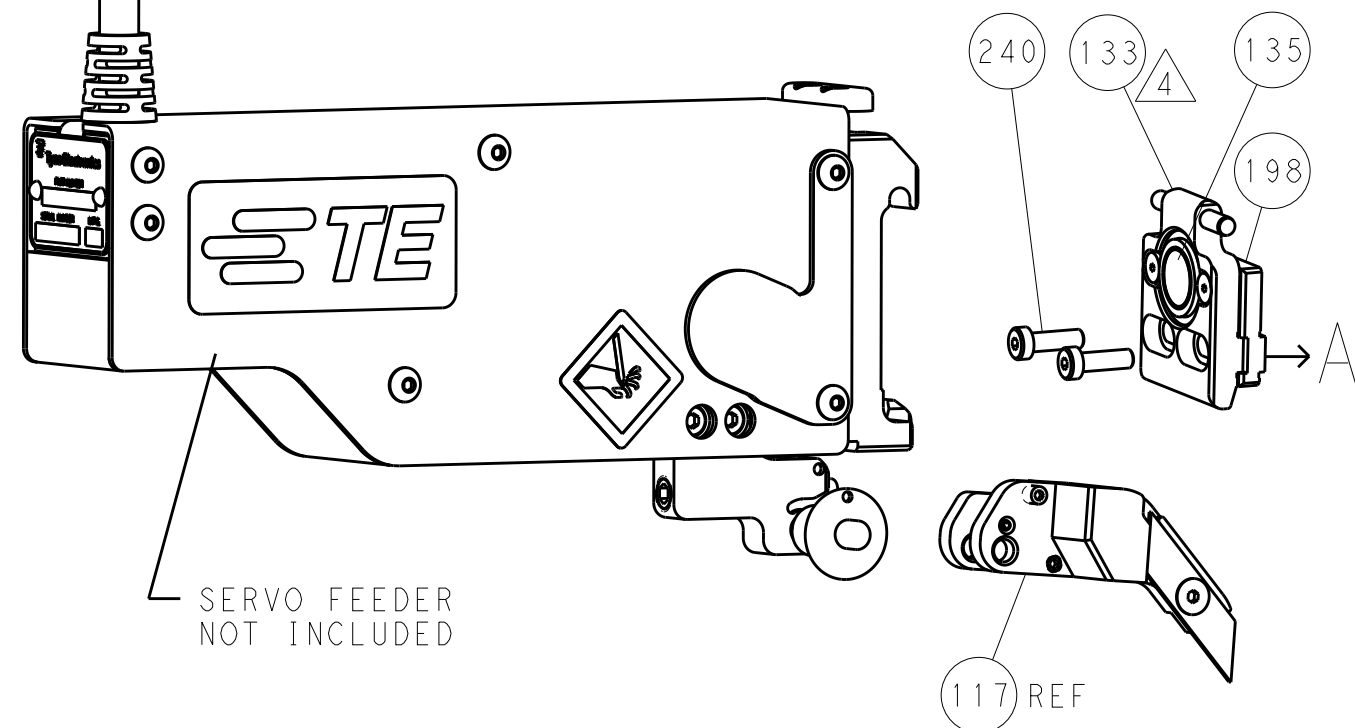
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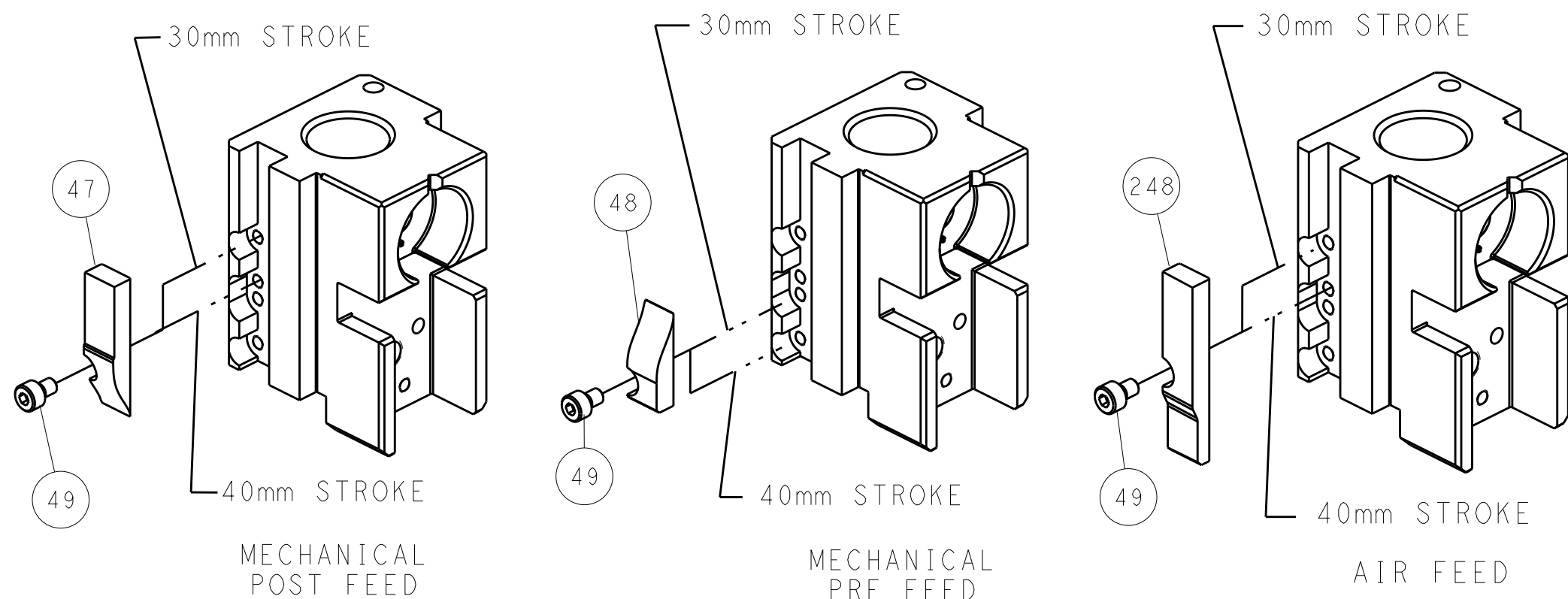
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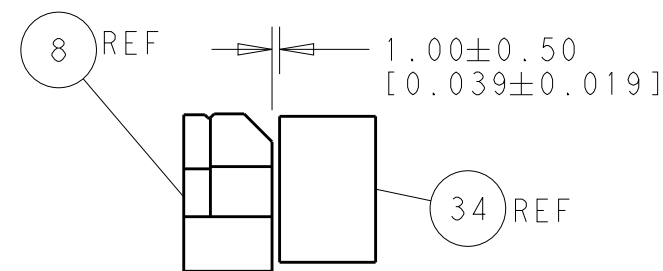
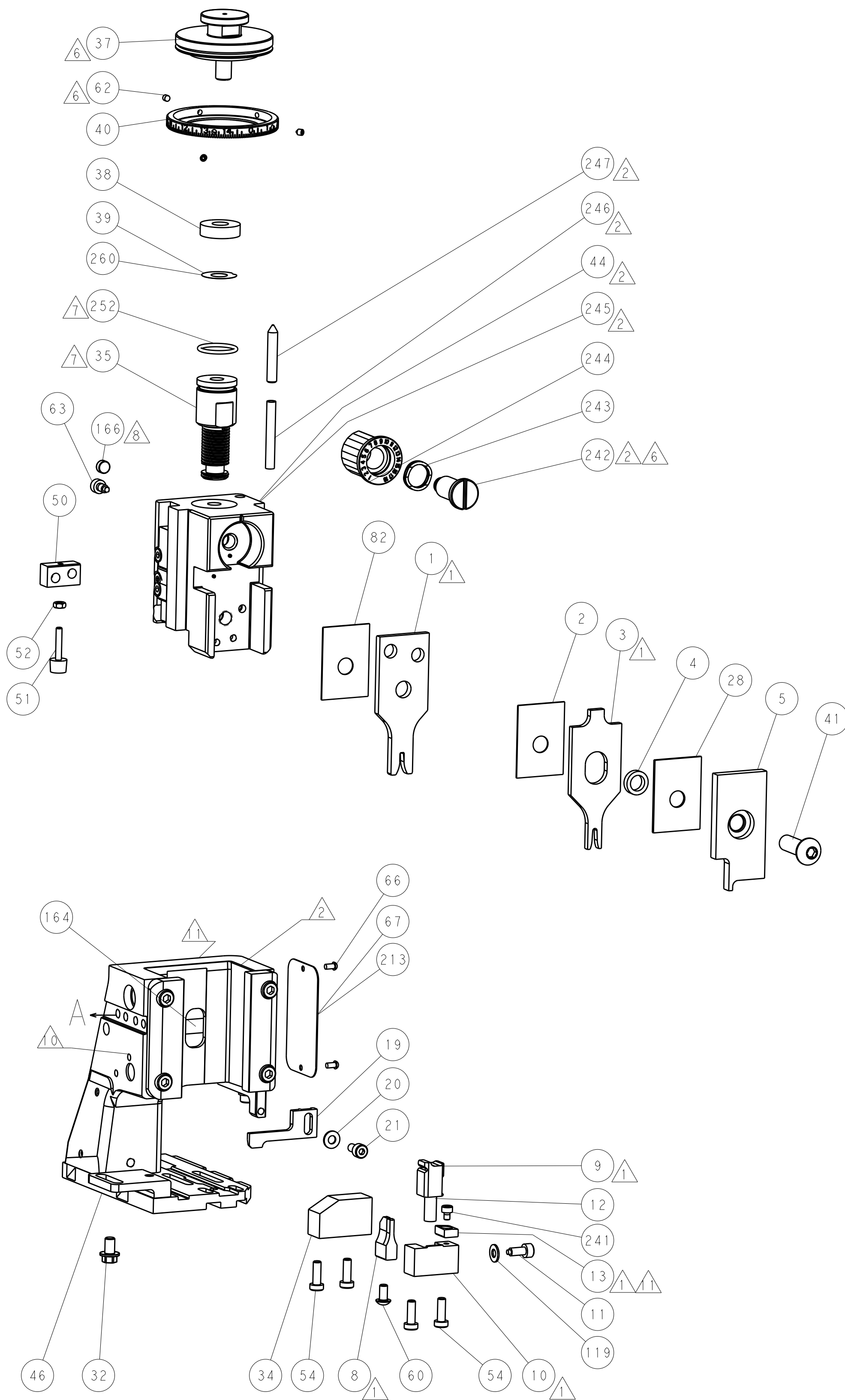
SERVO
LATCH PLATE



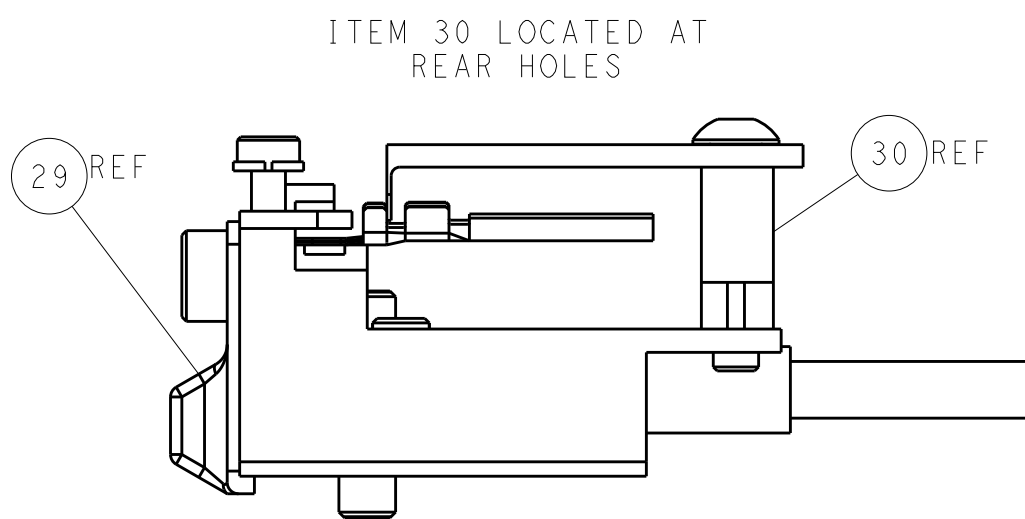
CAM POSITIONS



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



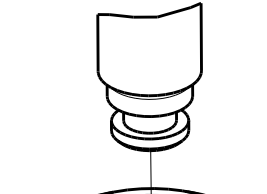
TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME: Ocean Side Feed Applicator			
mm				0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.001				SIZE: A1			
MATERIAL:				FINISH:				CAGE CODE: 00779			
								DRAWING NO: C=2266166			
								Customer Accessible Production Drawing			
								SCALE: 1:2			
								SHEET: 2 of 4			
								REV: A			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7		6		5		4		3	
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	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
					SERVO LATCH PLATE	2119951-1	-	8-2266166-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266166-4	-	-	-
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266166-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266166-4	-	-	-
					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
					-	-	-	-	-	-	-
					-	-	-	-	-	-	-
					-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	2.50 mm [.098]	O
APPLICATOR INSTRUCTIONS 408-10389		

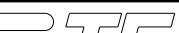
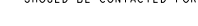
TERMINAL DATA: FCL TERMINAL		DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL 1.5mm MALE			
WIRE STRIP LENGTH 4.57-4.95 mm [.180-.195 IN]		INSULATION DIAMETER RANGE Ø 2.54 mm [.100 IN] MAX	
TERMINAL APPLICATION SPECIFICATION		13672903 Rev 02	
- - -		- - -	
TERMINALS APPLIED			
TE TERMINAL	FCL TERMINAL	TE TERMINAL	FCL TERMINAL
1832478-1	54001845	2113414-1	54001843
1832478-2	54001841		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18/20 AWG		1.27 $\pm$ 0.05 [0.050 $\pm$ 0.002]		4.8



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: 8-2266166-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266166-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266166-5
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.

[illegible]

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DIMENSIONS: mm		CUP L. ZHANG 04DEC2013	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:  0 PLC ± 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0013 ANGLES FINISH		APPV W. GUO 04DEC2013	PRODUCT SPEC APPLICATION SPEC WEIGHT	
MATERIAL -		SIZE A 00779 C=2266166		RESTRICTED TO -
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2 SHEET 3 of 4 REV A		

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

D

C

B

A

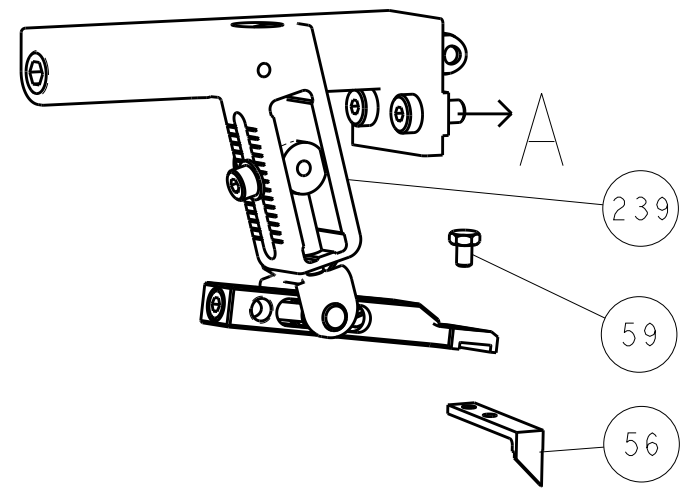
D

C

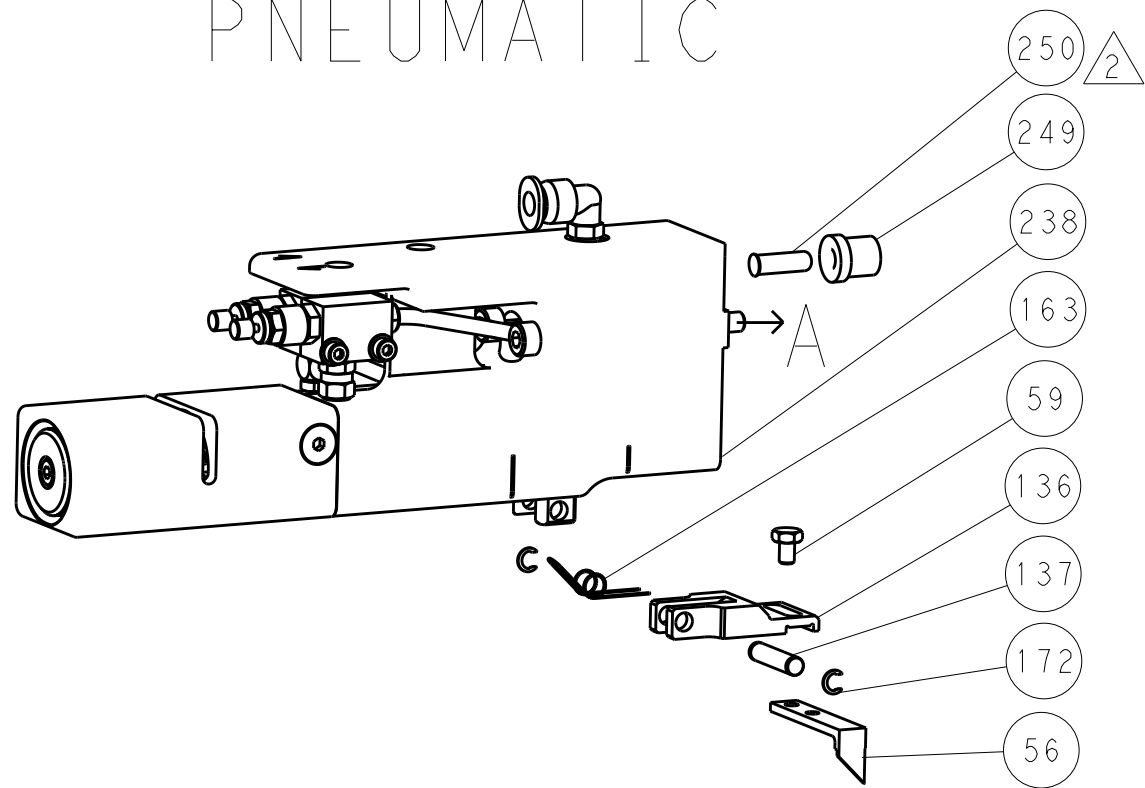
B

A

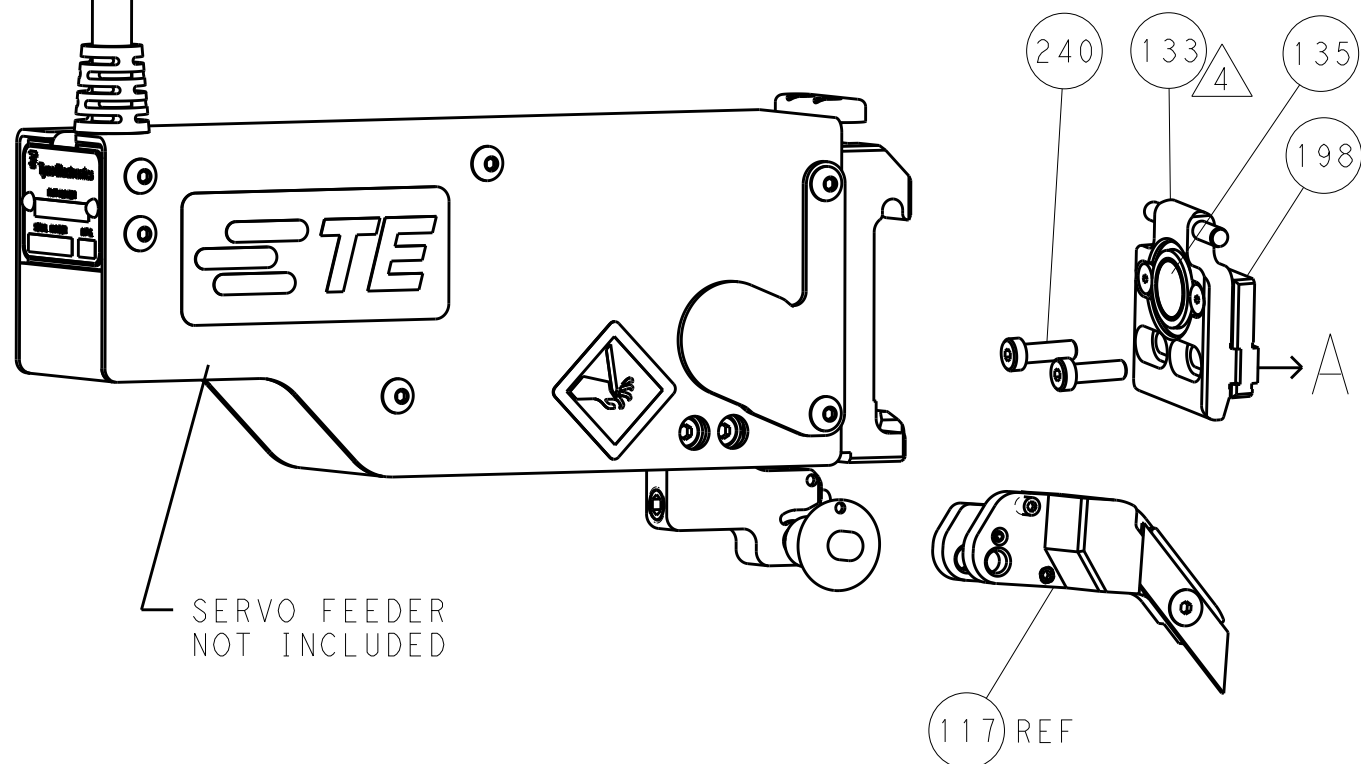
FEED TYPE MECHANICAL



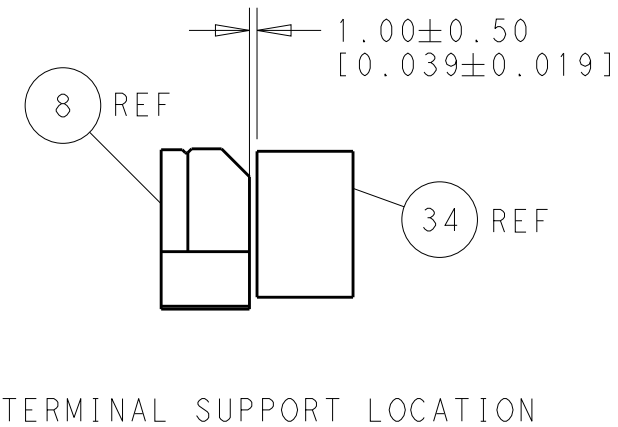
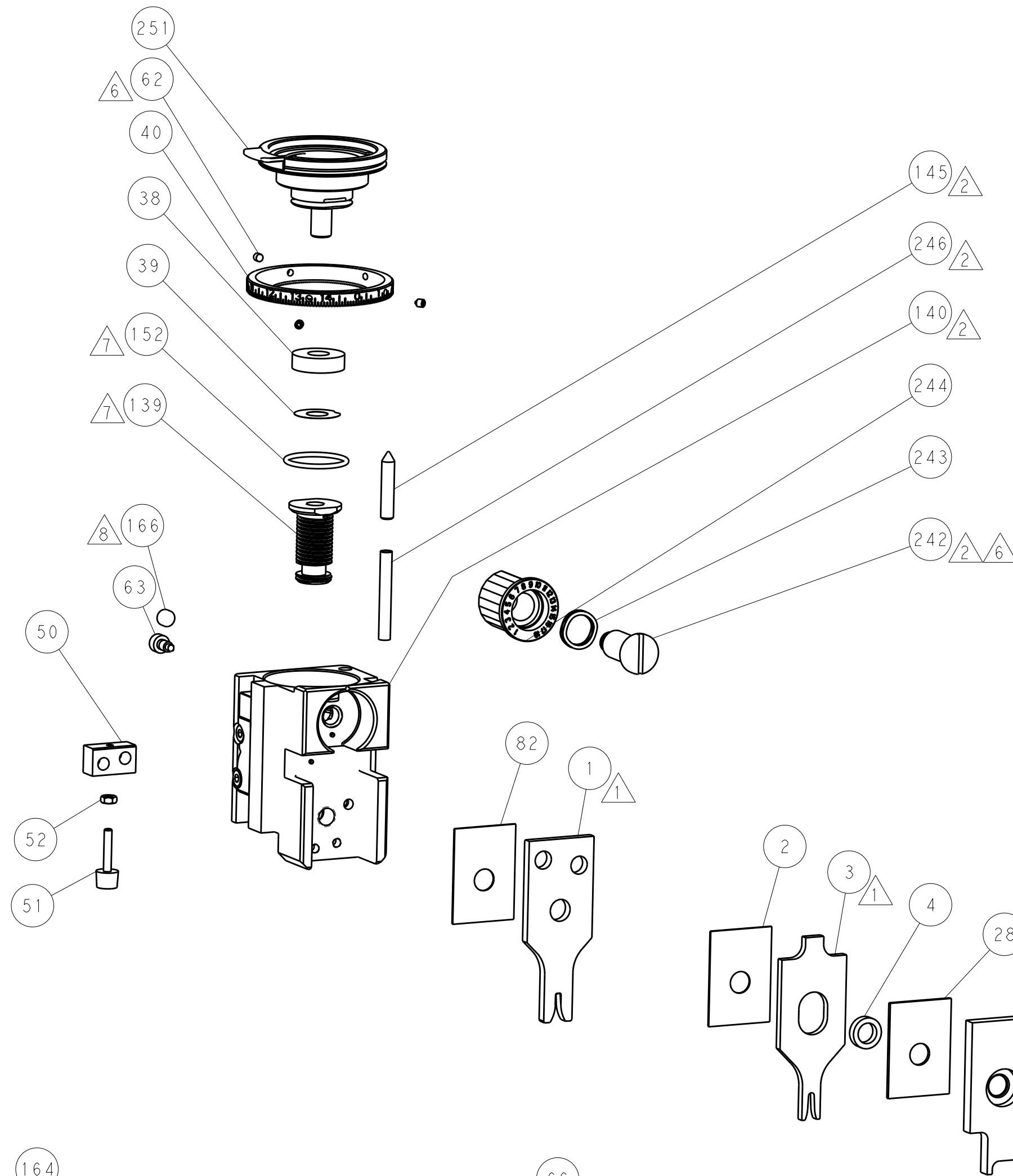
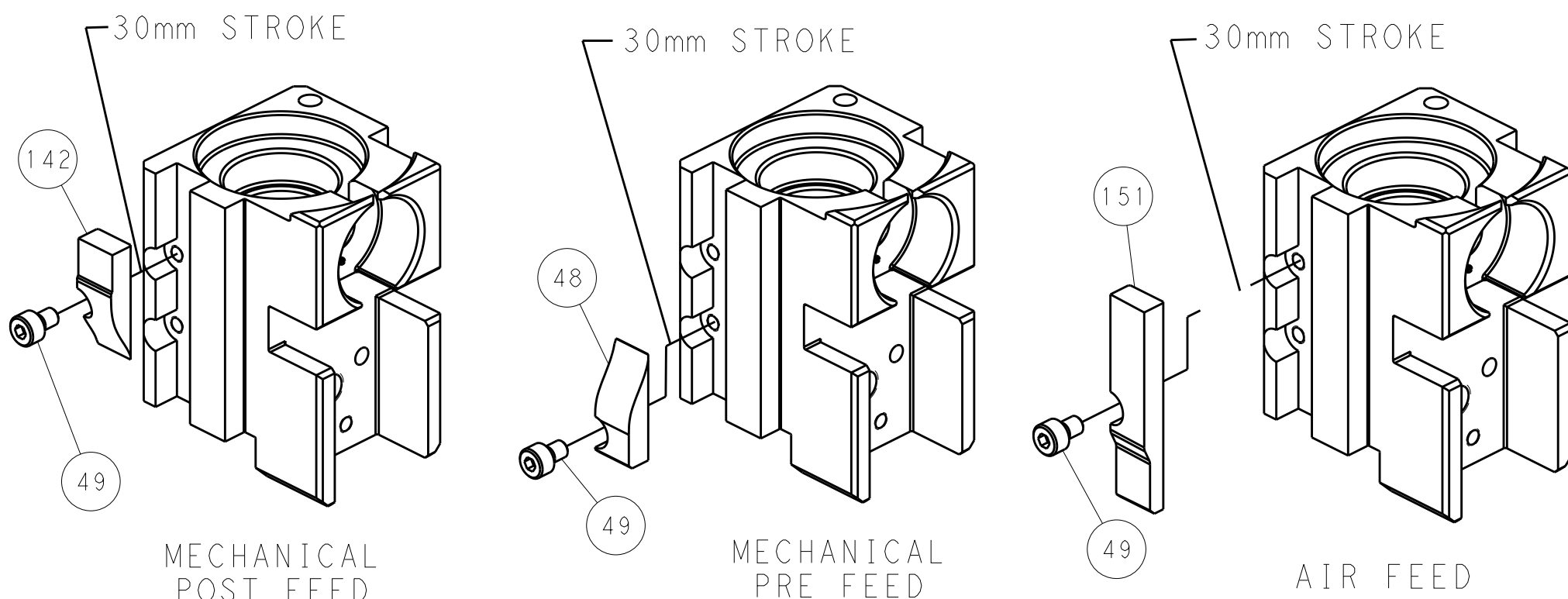
PNEUMATIC



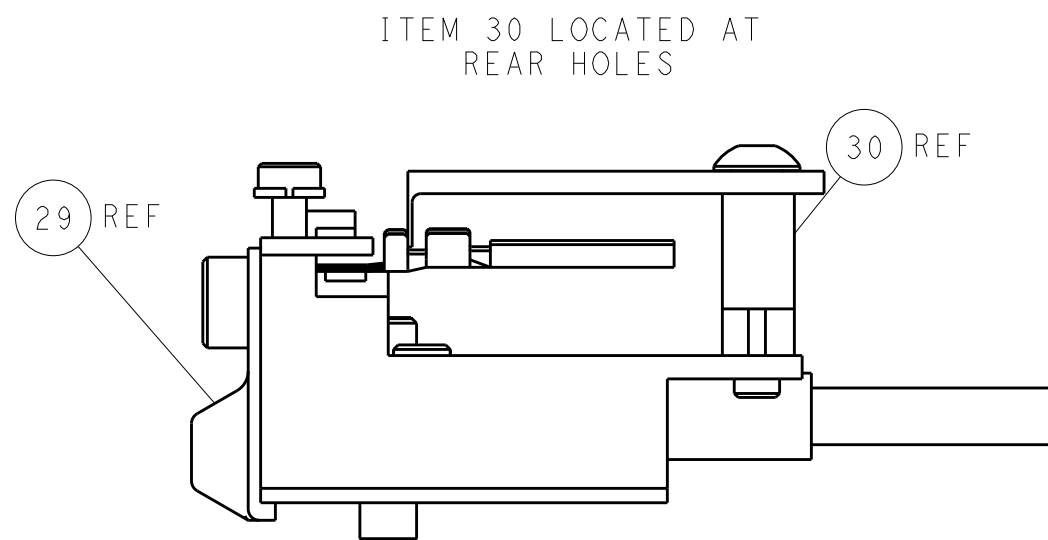
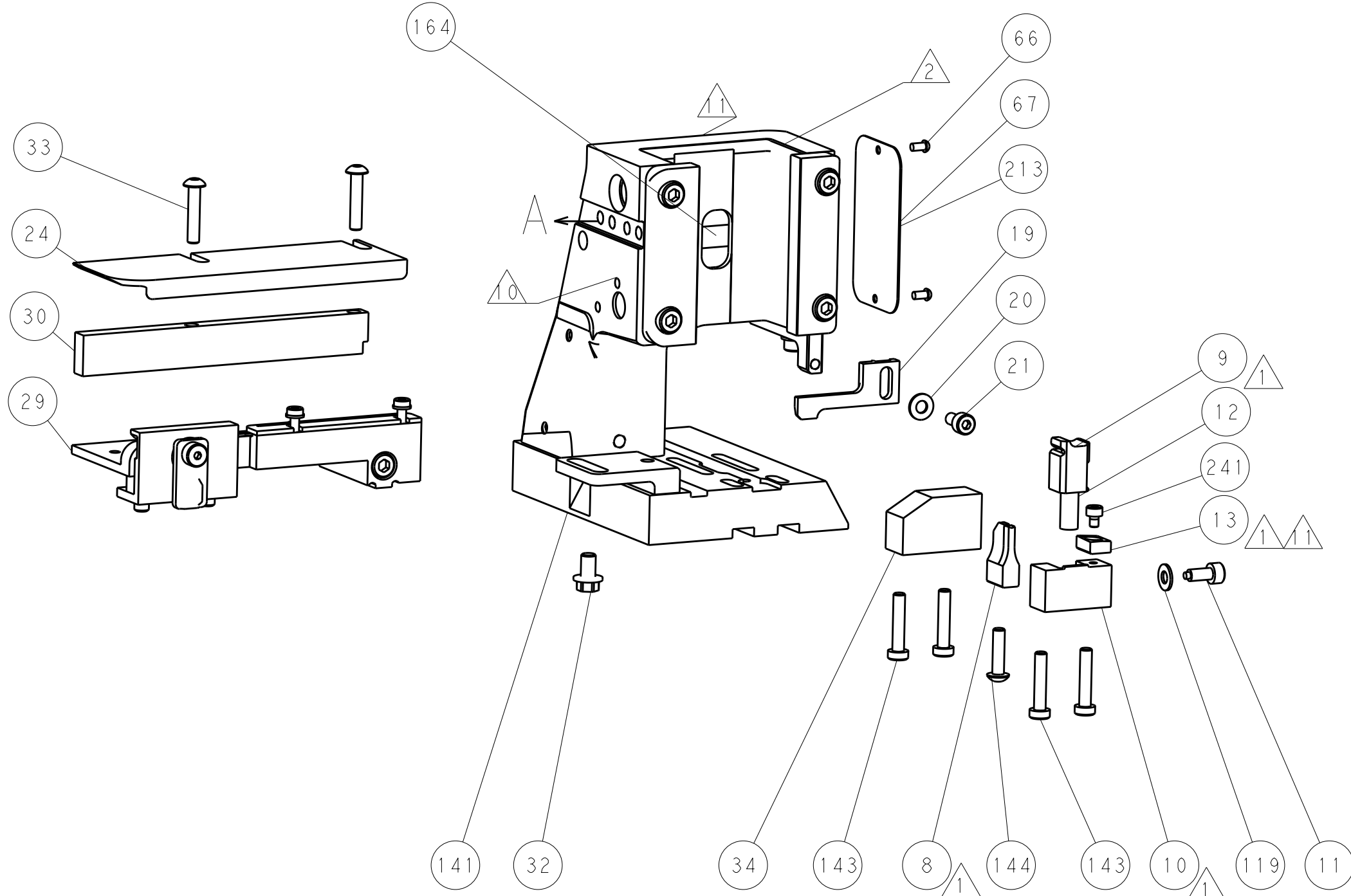
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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		CHK		APVD		NAME	
mm		0 PLC ±0.5		K. HUANG		L. ZHANG		J. GUO		Ocean Side Feed Applicator	
1 PLC ±0.13		2 PLC ±0.13		3 PLC ±0.13		4 PLC ±0.001		ANGLES		SIZE	
FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE		SHEET		REV	
-		-		-		-		-		-	
-		-		-		-		-		-	