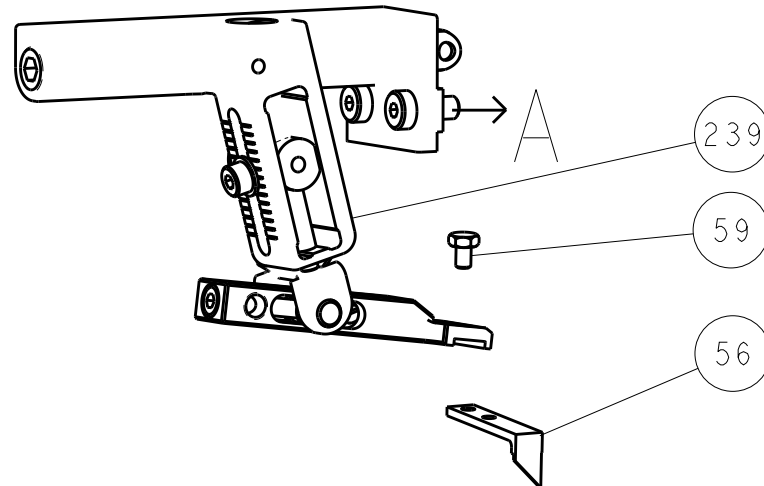
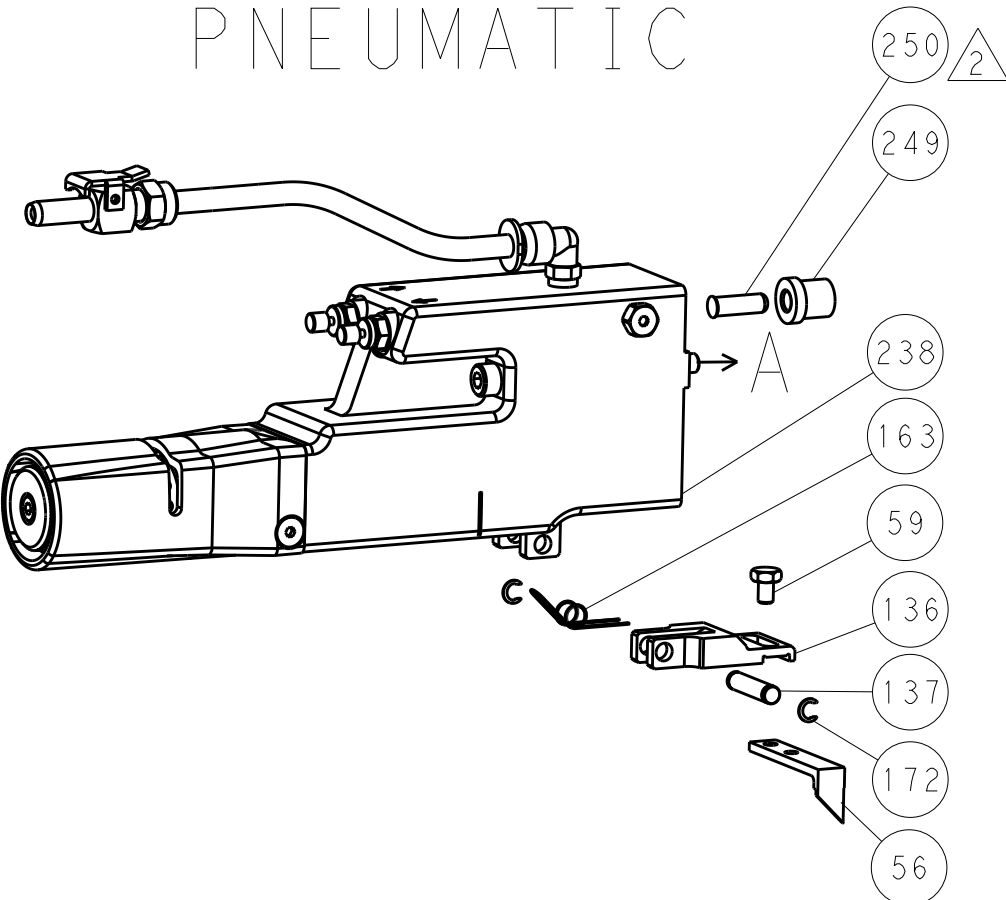


LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

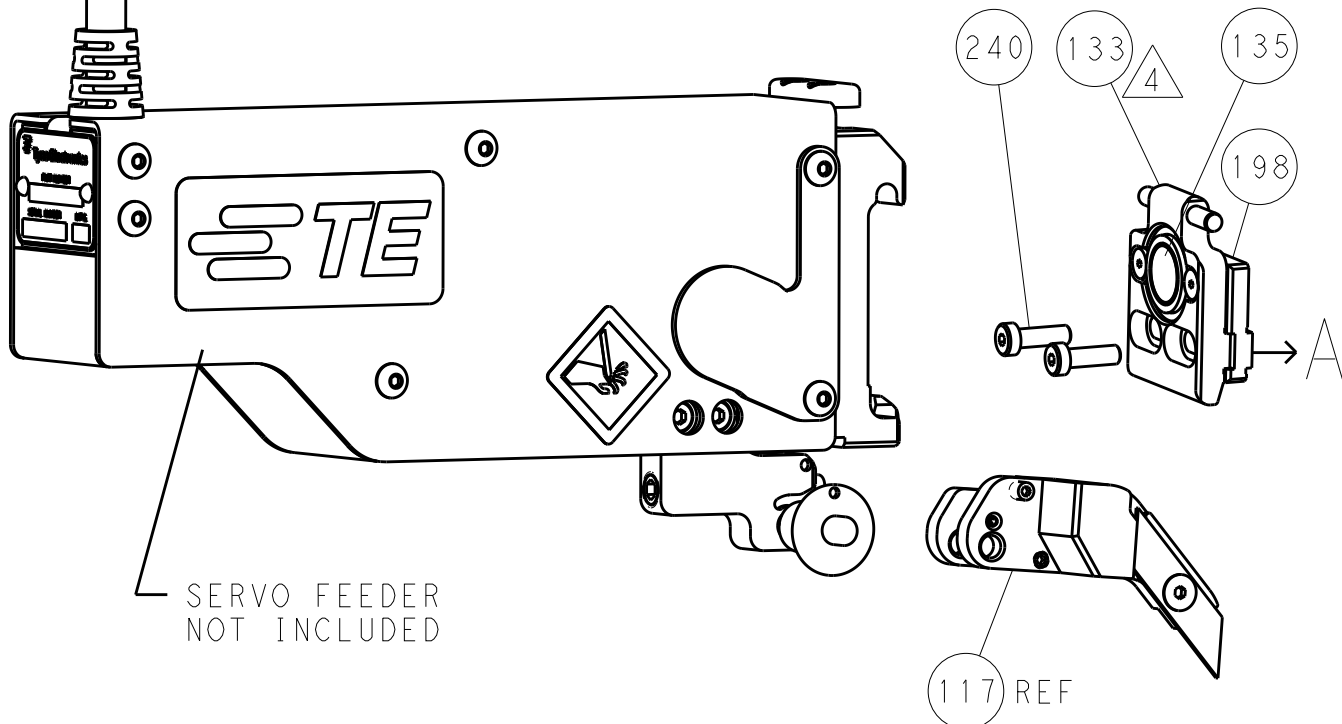
FEED TYPE MECHANICAL



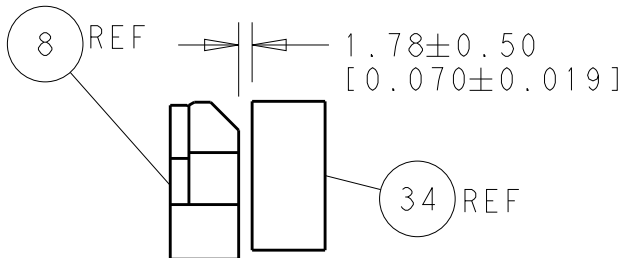
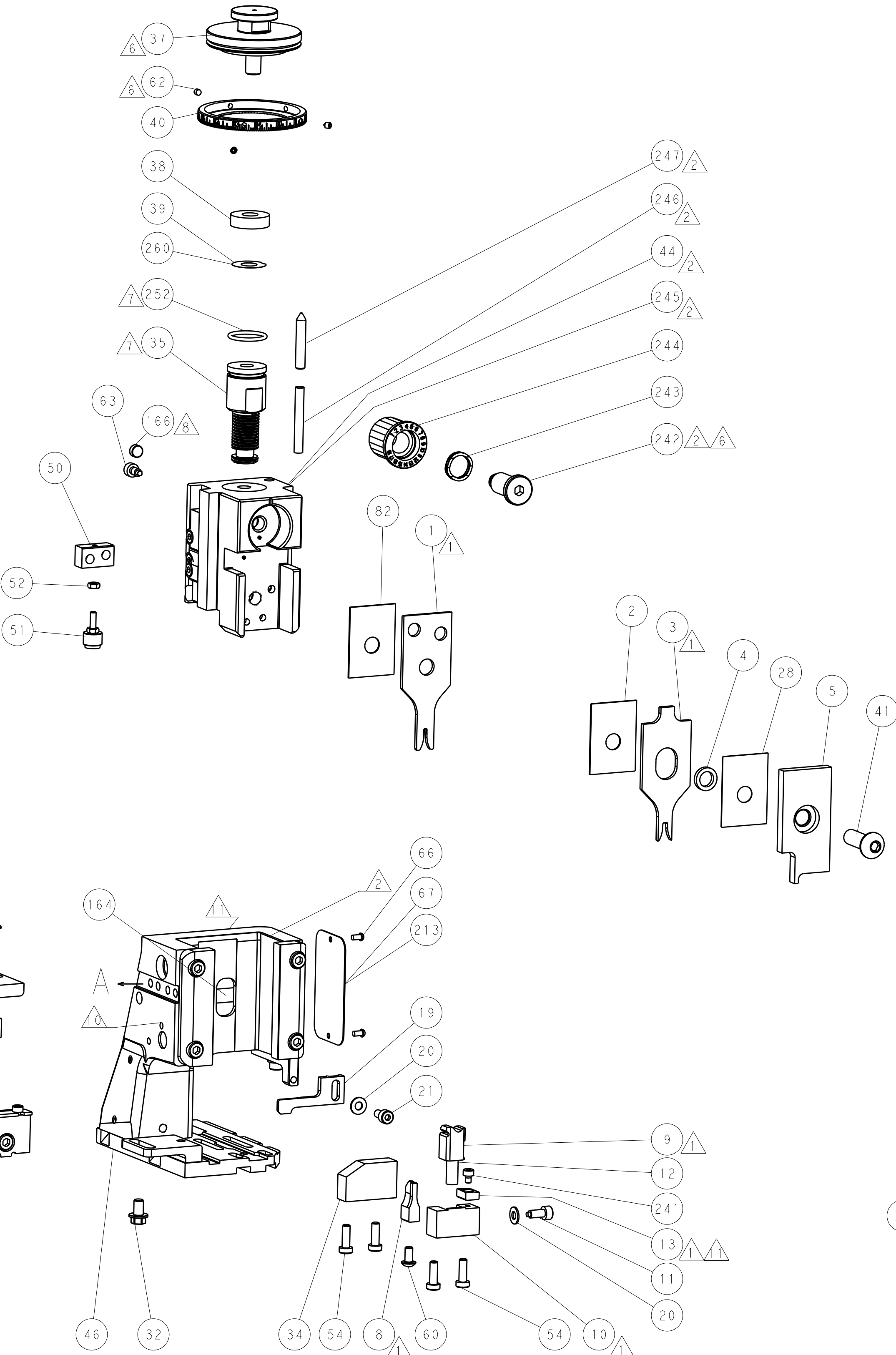
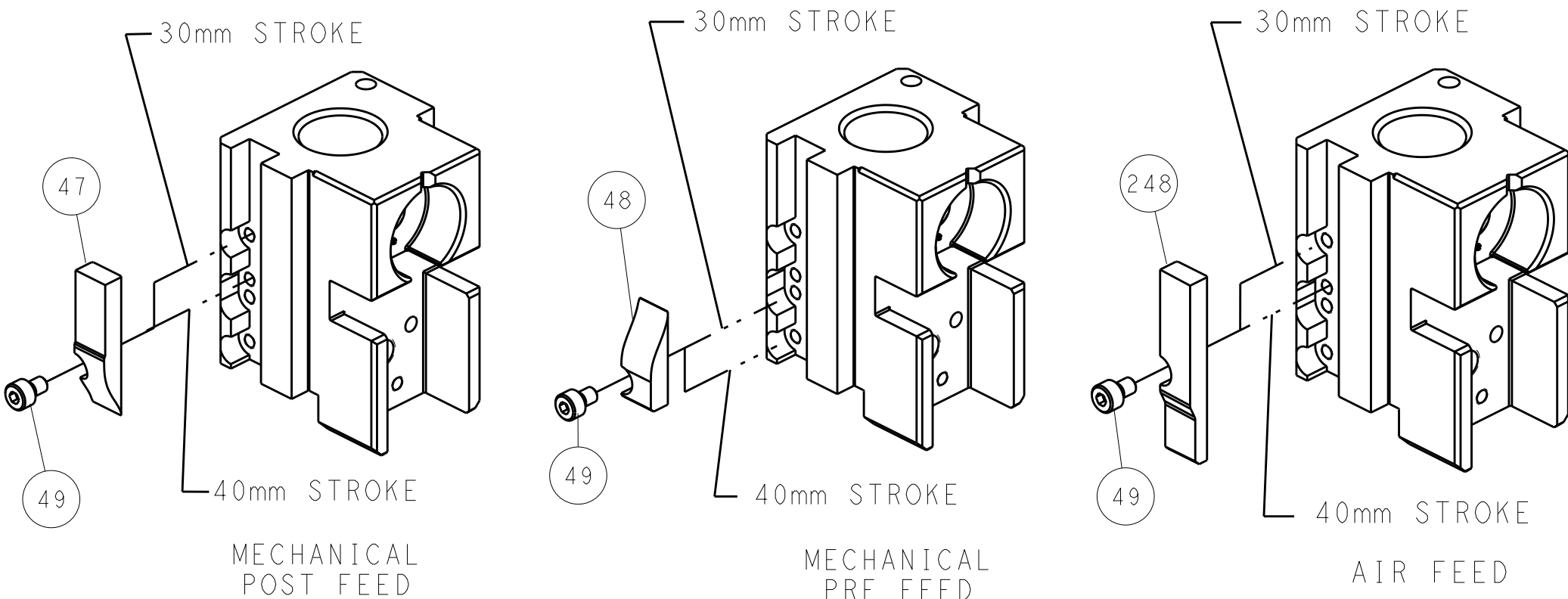
PNEUMATIC



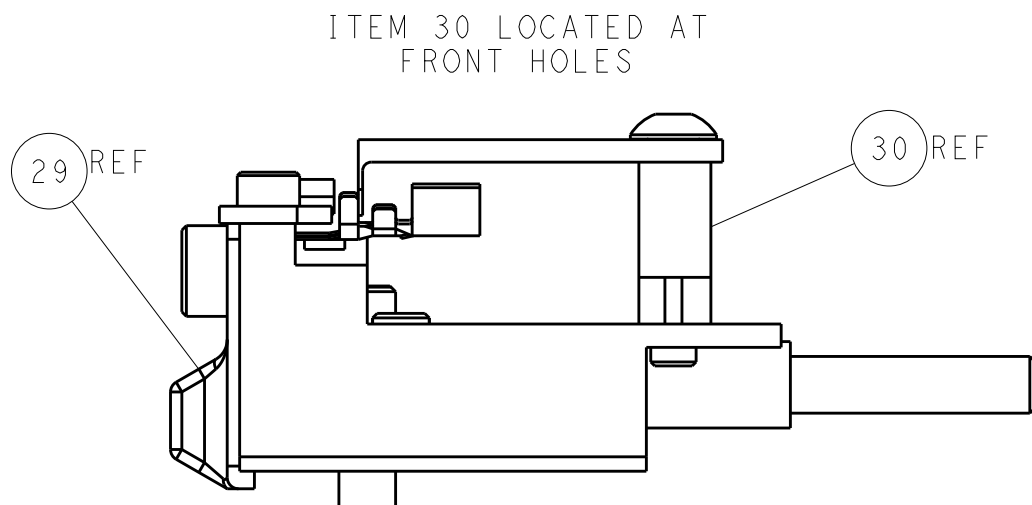
SERVO LATCH PLATE



CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG 08JAN2015		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		CHK L. ZHANG 08JAN2015		NAME Ocean Side Feed Applicator	
MATERIAL		FINISH		PRODUCT SPEC		SIZE A1	
				APPLICATION SPEC		CAGE CODE 00779	
				WEIGHT		DRAWING NO C=2266652	
				Customer Accessible Production Drawing		RESTRICTED TO	
				SCALE 1:2		SHEET 2 of 4	
						REV A	

8

7

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1

THIS DRAWING IS UNPUBLISHED.

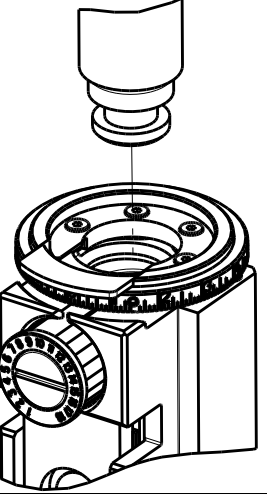
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2266652-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119951-1

8-2266652-5

1901094-3

-

2168400-6 (QUANTITY 2)

2161326-1

8-2266652-4

-

-

-

MECHANICAL FEED

2119949-1

2138685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

8-2266652-5

1901094-3

-

2168400-6 (QUANTITY 2)

2161326-1

8-2266652-4

-

-

-

SMART APPLICATOR

2161326-1

2138685-1

5-18022-5

2119653-2

-

-

MECHANICAL FEED

2119949-1

2138685-1

5-18022-5

2119641-2

2119799-1

2063440-1

PNEUMATIC FEED

2119950-1

-

-

-

-

-

-

-

-

-

-

CRIMP

SIZE

TYPE

WIRE

1.60 mm [.063]

F

INSUL

2.80 mm [.110]

F

APPLICATOR INSTRUCTIONS

408-10389

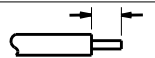
TERMINAL DATA: MOLEX TERMINAL

MOLEX CRIMP SPECIFICATION

TERMINAL NAME: 3.96mm PITCH SPOX CRIMP TERMINAL

WIRE STRIP LENGTH

3.00-3.50 mm [.118-.138 IN]



INSULATION DIAMETER RANGE

Ø1.30-3.00 mm [.051-.118 IN]

TERMINAL APPLICATION SPECIFICATION

ATS-639005300 Rev A

-

-

TERMINALS APPLIED

TE TERMINAL

MOLEX TERMINAL

TE TERMINAL

MOLEX TERMINAL

286982-1

08-70-1031

286982-3

39-00-0409

286982-2

39-00-0021

286982-4

39-00-0416

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



18 AWG OR 0.80mm2

1.15+/-0.05 [.045+/-0.002]

6.2

20 AWG OR 0.50mm2

1.12+/-0.05 [.044+/-0.002]

6.5

22 AWG OR 0.35mm2

1.01+/-0.05 [.040+/-0.002]

7.6

24 AWG OR 0.30mm2

0.95+/-0.05 [.037+/-0.002]

8.2

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: 8-2266652-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266652-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266652-5

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 ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

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

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

1-22279-3

SPRING, COMPRESSION

246

-

1

1

1

1

2119082-4

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

-

-

REF

-

-

2119944-1

FEED FINGER ASSEMBLY,SF

117

-

1

1

1

1

455888-6

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

1338685-1

PAWL, FEED

56

-

2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

53

-

1

1

1

1

5018030-1

NUT, HEX, REG, RoHS, M3

52

-

1

1

1

1

811242-6

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

2119644-1

RAM WASHER, PRECISION

38

-

1

1

1

1

1-1752356-9

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

1320908-3

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

-

2

2

2

2

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

1803095-1

FLOATING SHEAR, FRONT

9

-

1

1

1

1

1

2-1803171-9

ANVIL, COMBINATION

8

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7

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6

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1

1

1

1

2119757-8

DEPRESSOR, SHEAR

5

-

1

1

1

1

1-238011-0

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1

6-2119582-6

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

1

455888-6

SPACER, CRIMPER

2

-

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2-1633738-0

CRIMPER, WIRE

1

1

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8

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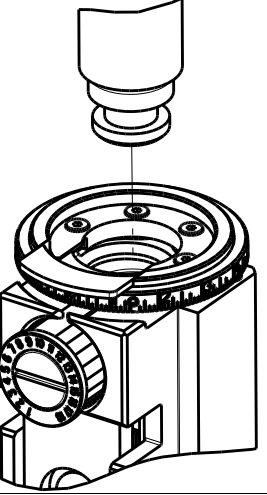
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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2266652-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119951-1

8-2266652-5

1901094-3

-

2168400-6 (QUANTITY 2)

2161326-1

8-2266652-4

-

-

-

MECHANICAL FEED

2119949-1

2138685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

8-2266652-5

1901094-3

-

2168400-6 (QUANTITY 2)

2161326-1

8-2266652-4

-

-

-

SMART APPLICATOR

2161326-1

2138685-1

5-18022-5

2119653-2

-

-

MECHANICAL FEED

2119949-1

2138685-1

5-18022-5

2119641-2

2119799-1

2063440-1

PNEUMATIC FEED

2119950-1

-

-

-

-

-

-

-

-

-

-

CRIMP

SIZE

TYPE

WIRE

1.60 mm [.063]

F

INSUL

2.80 mm [.110]

F

APPLICATOR INSTRUCTIONS

408-10389

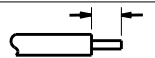
TERMINAL DATA: MOLEX TERMINAL

MOLEX CRIMP SPECIFICATION

TERMINAL NAME: 3.96mm PITCH SPOX CRIMP TERMINAL

WIRE STRIP LENGTH

3.00-3.50 mm [.118-.138 IN]



INSULATION DIAMETER RANGE

Ø1.30-3.00 mm [.051-.118 IN]

TERMINAL APPLICATION SPECIFICATION

ATS-639005300 Rev A

-

-

TERMINALS APPLIED

TE TERMINAL

MOLEX TERMINAL

TE TERMINAL

MOLEX TERMINAL

286982-1

08-70-1031

286982-3

39-00-0409

286982-2

39-00-0021

286982-4

39-00-0416

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



18 AWG OR 0.80mm2

1.15+/-0.05 [.045+/-0.002]

6.2

20 AWG OR 0.50mm2

1.12+/-0.05 [.044+/-0.002]

6.5

22 AWG OR 0.35mm2

1.01+/-0.05 [.040+/-0.002]

7.6

24 AWG OR 0.30mm2

0.95+/-0.05 [.037+/-0.002]

8.2

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: 8-2266652-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266652-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266652-5

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 ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

SET UP GAUGE

2119599-1

LOC

A

DIST

66

REVISIONS

P

LTR

DESCRIPTION

DATE

OWN

APVD

-

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SEE SHEET 1

-

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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

1-22279-3

SPRING, COMPRESSION

246

-

1

1

1

1

2119082-4

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

-

-

REF

-

-

2119944-1

FEED FINGER ASSEMBLY,SF

117

-

1

1

1

1

455888-6

SPACER, CRIMPER

82

-

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

-

1

1

2119740-1

TAG,IDENTIFICATION

67

-

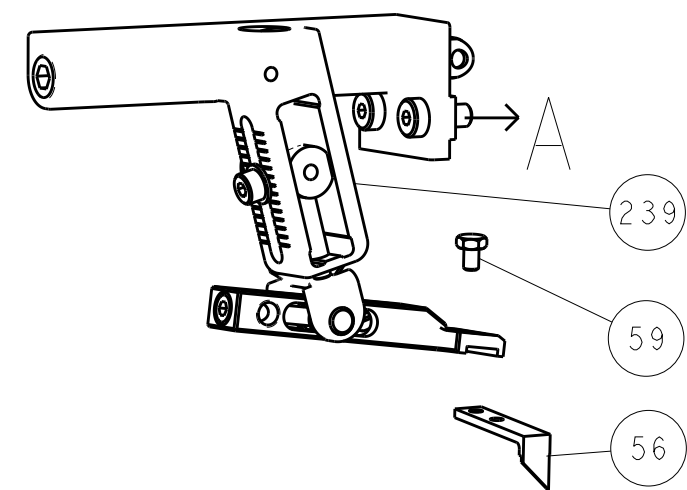
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2

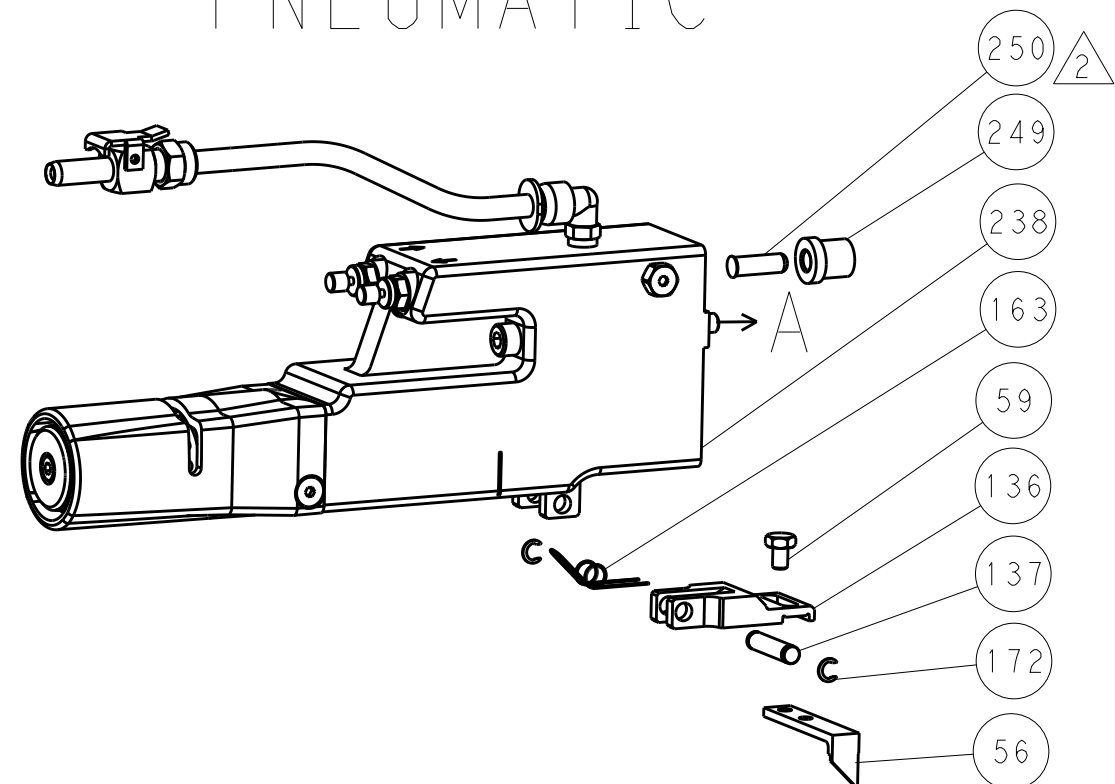
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2				7			
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

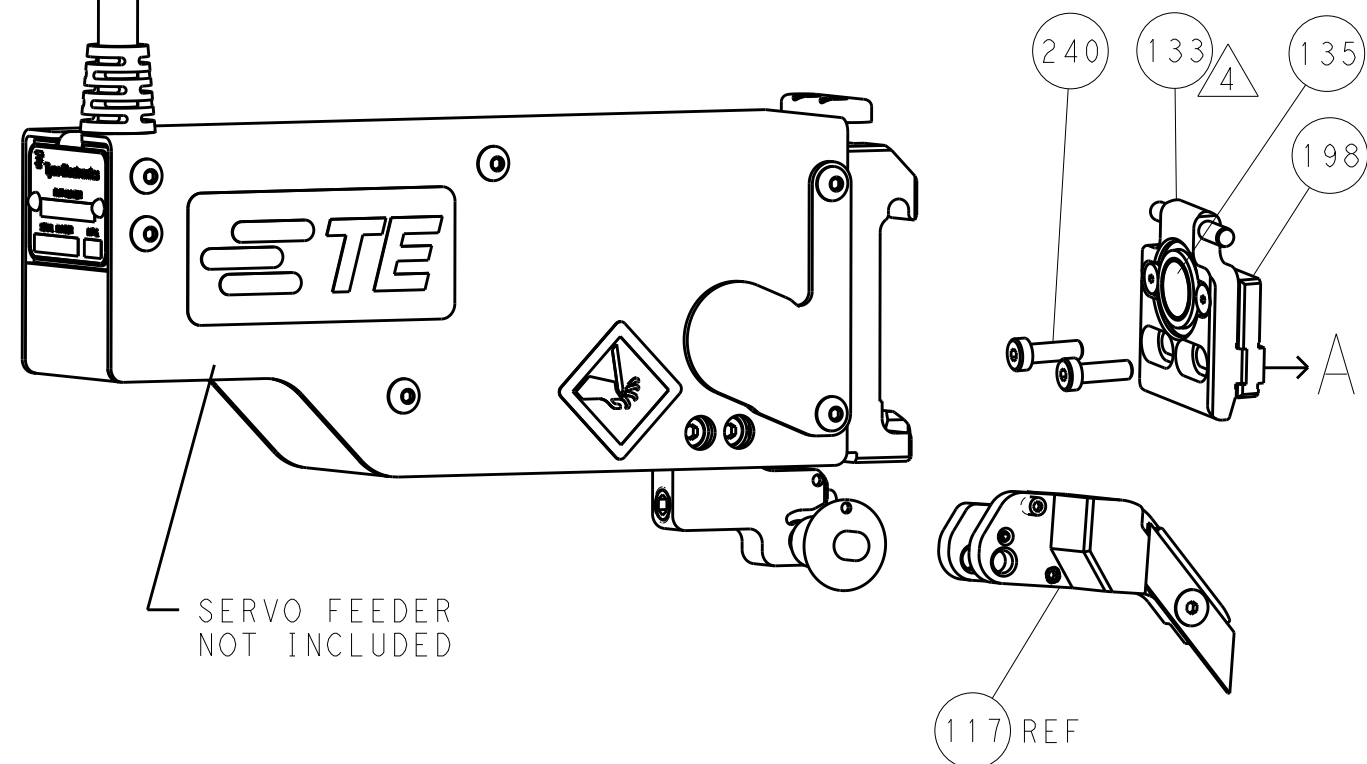
FEED TYPE MECHANICAL



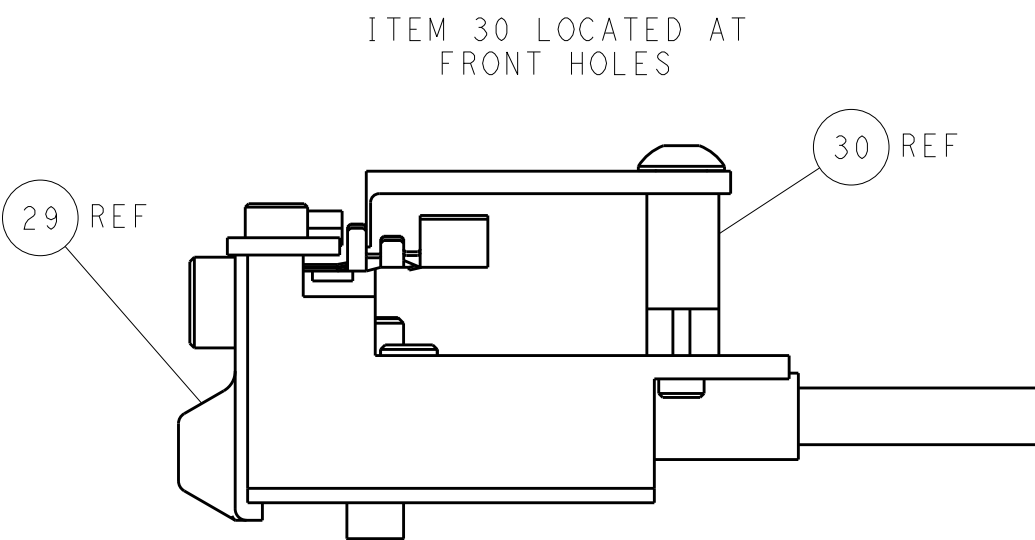
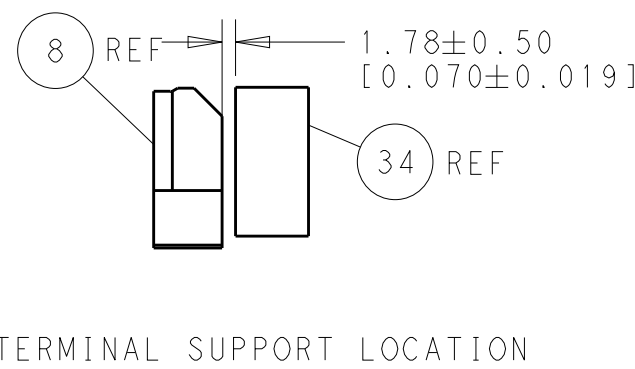
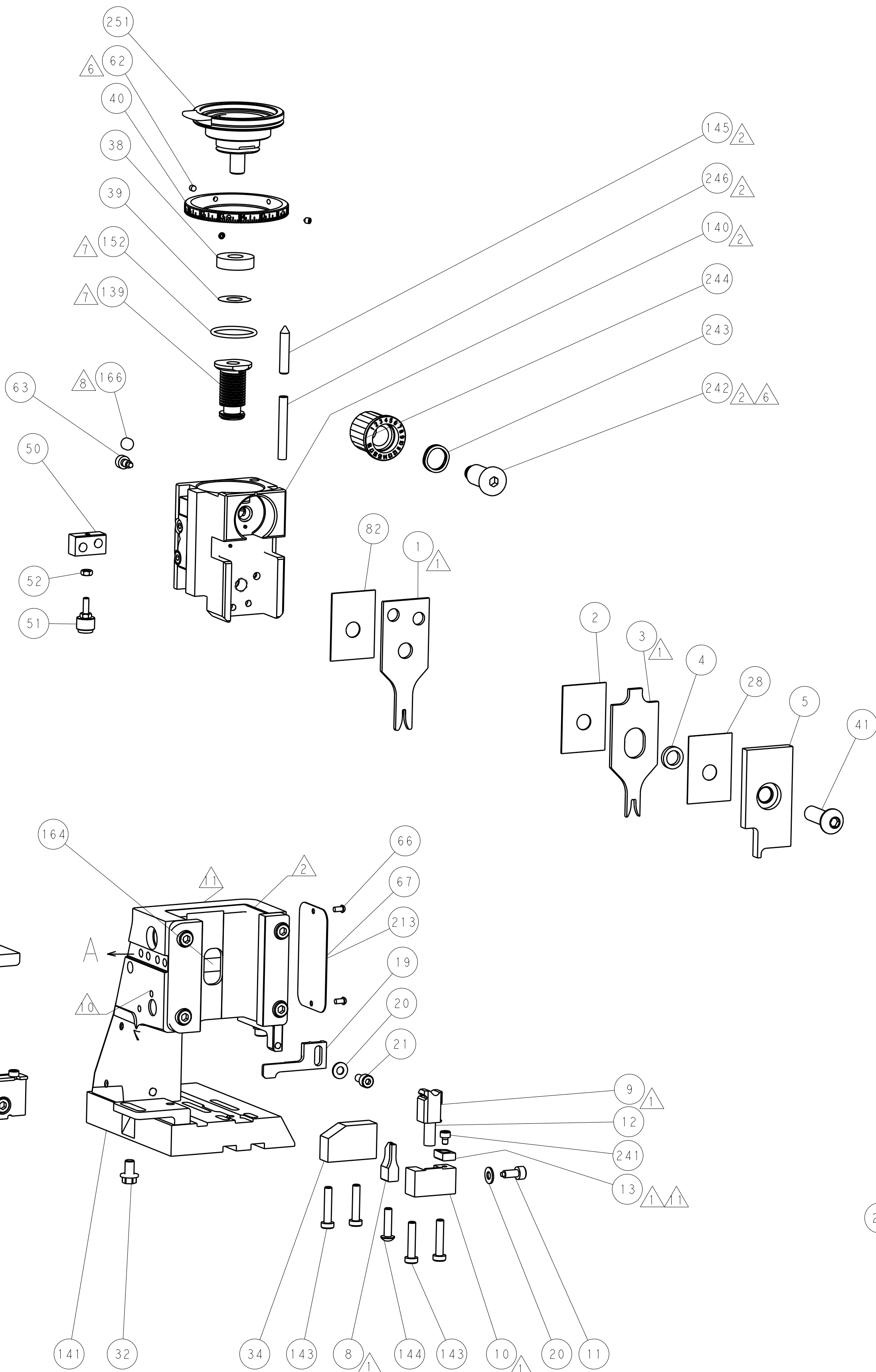
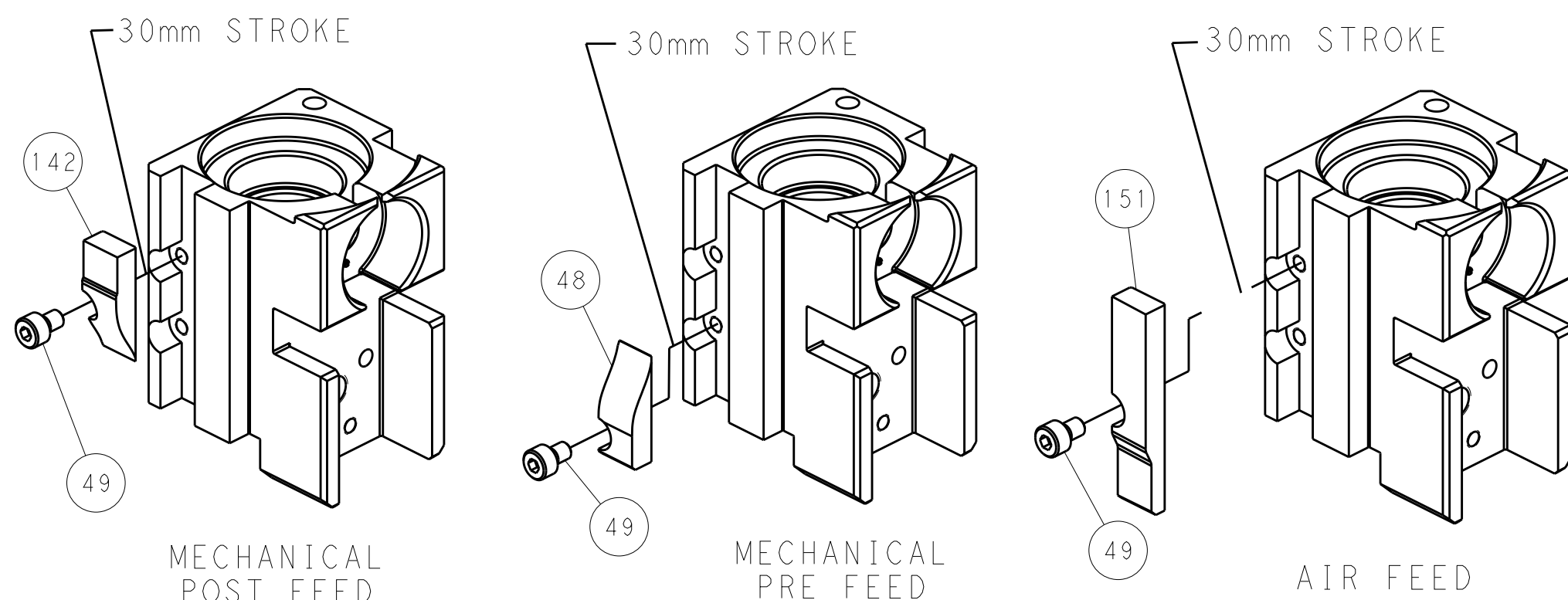
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH		DWN K. HUANG 08JAN2015	CHK L. ZHANG 08JAN2015	APVD J. GUO 08JAN2015	NAME Ocean Side Feed Applicator	SIZE A	CAGE CODE 00779	DRAWING NO C=2266652	RESTRICTED TO -	
MATERIAL -		WEIGHT -		Customer Accessible Production Drawing		SCALE 1:2		SHEET 4		OF 4		REV A