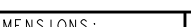


-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	219083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	1	2063440-2	AIR FEED MODULE	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	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	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
-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	2119740-1	TAG,IDENTIFICATION	67
-	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	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1338683-8	FEED PAWL	56
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1752356-3	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	1320908-7	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	1320928-6	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	454276-5	FLOATING SHEAR, FRONT	9
1	1	1	1	1	7-1803054-0	ANVIL, COMBINATION	8
-	1	1	1	1	2-240641-0	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	6-2119785-7	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1	1	456411-1	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

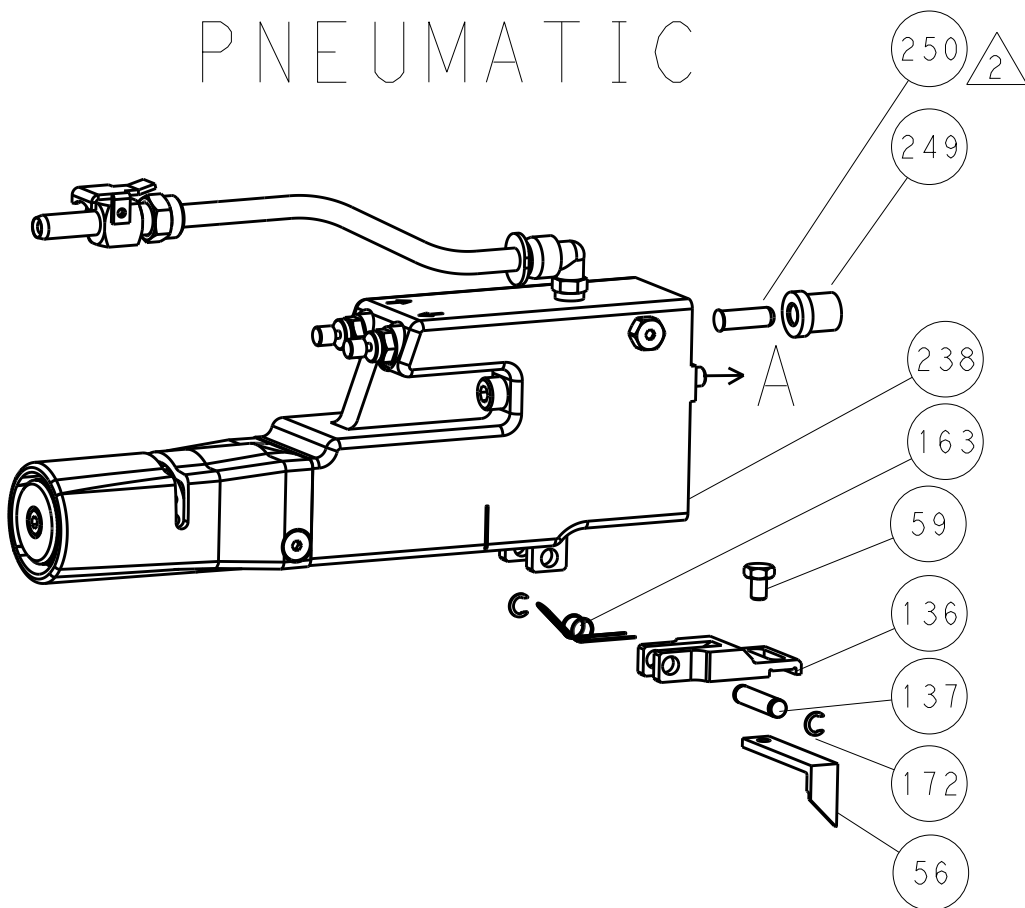
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION IT IS HEREBY TO BE USED ONLY FOR THE PURPOSES AND LIMITATIONS SPECIFIED HEREON. ANY OTHER USE IS PROHIBITED. NO REPRODUCTION SHOULD BE CONTACTED FOR THE LATEST REVISION.										DWN 190C12014 CHG YIN 190C12014 G. BAILEY 190C12014 APVD IF GUO 190C12014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm			TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±°			NAME Ocean Side Feed Applicator		SIZE CAGE CODE DRAWING NO A 00779 C=2266534		RESTRICTED TO -			
			PRODUCT SPEC - APPLICATION SPEC -			WEIGHT -		SCALE 1:2 SHEET 1 OF 4 REV A		Customer Accessible Production Drawing			

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

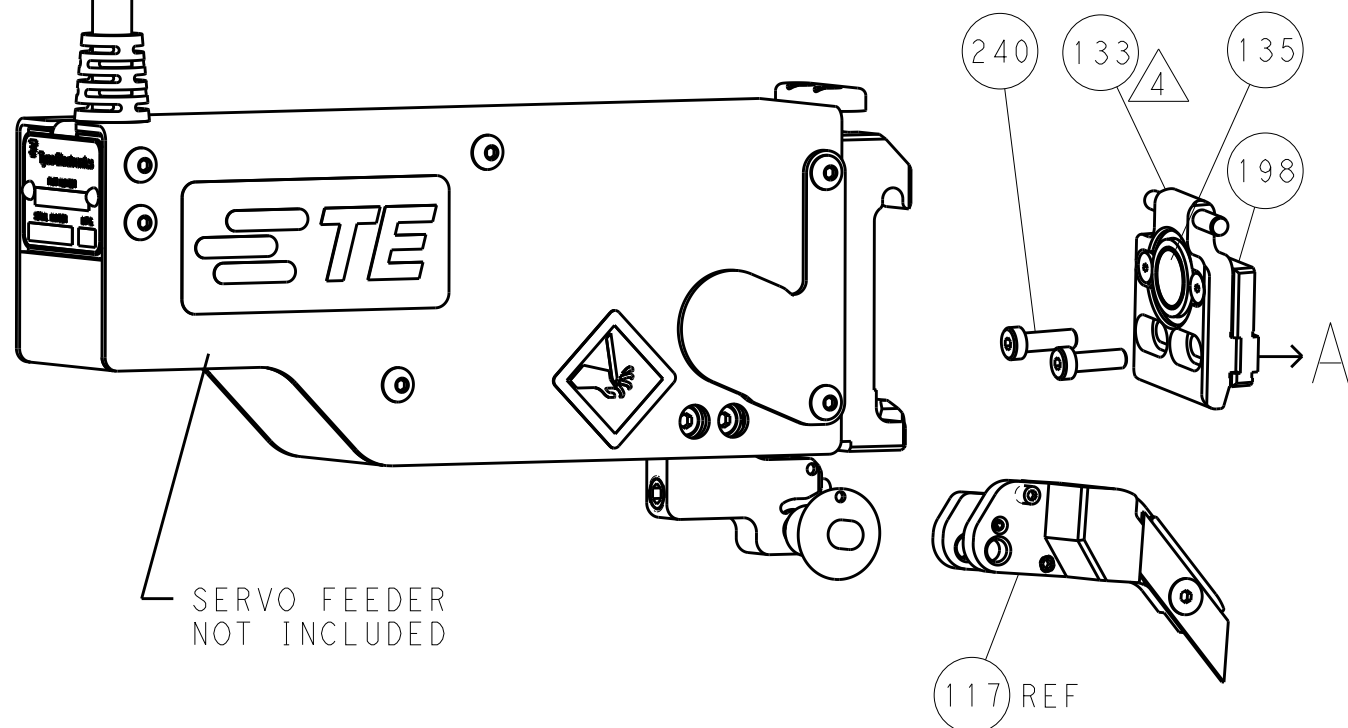
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

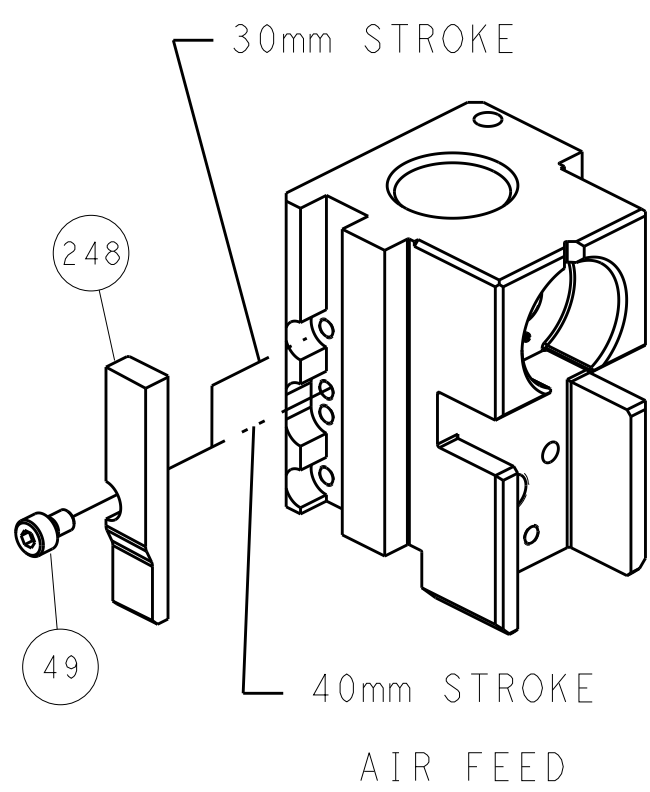
PNEUMATIC



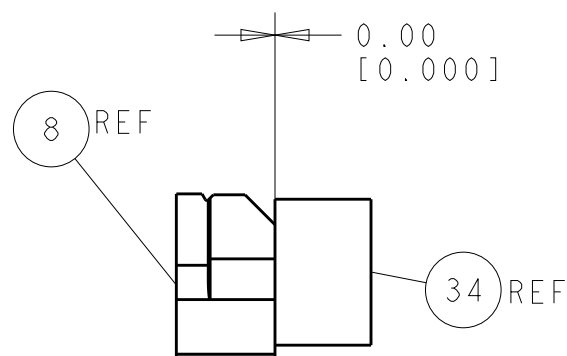
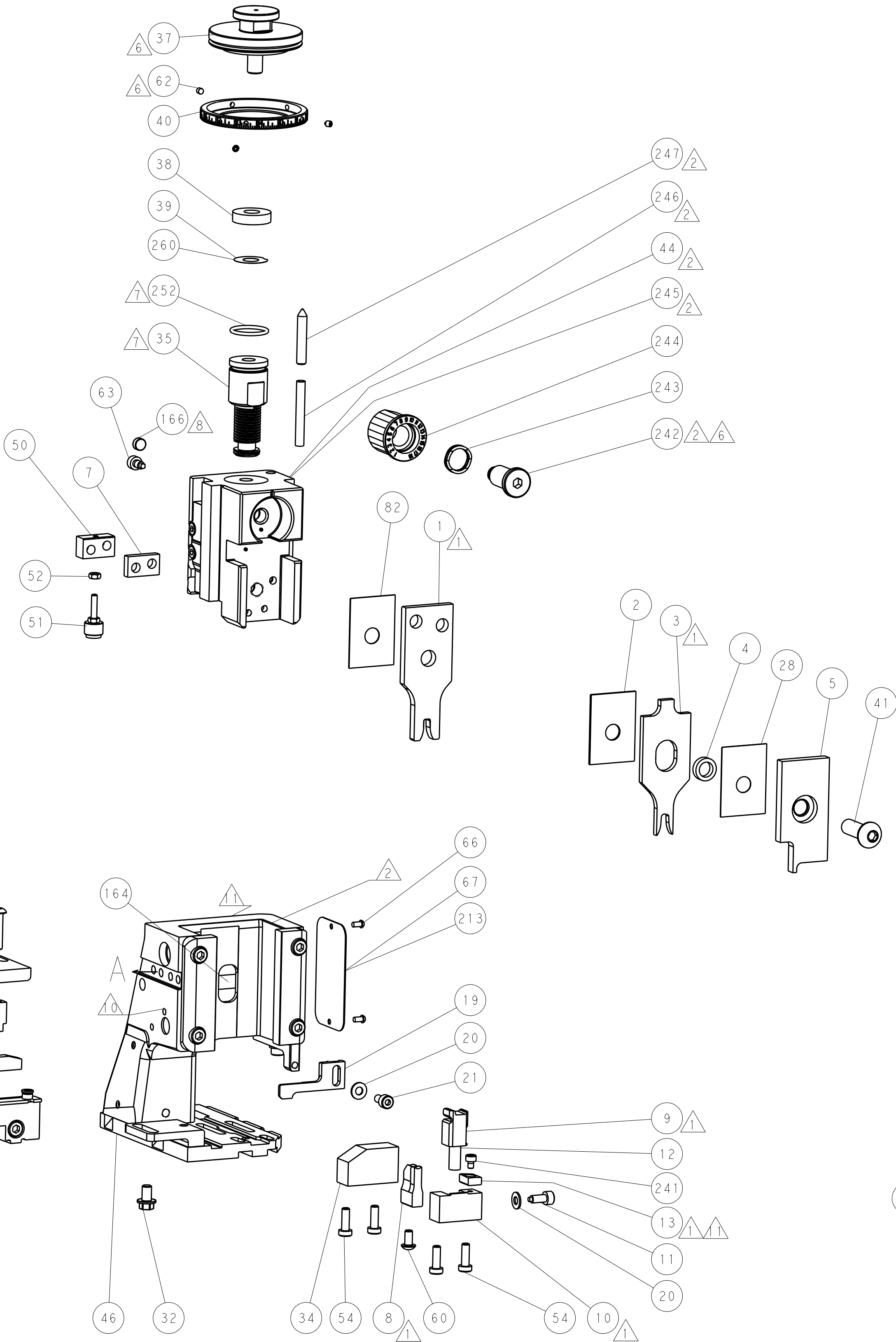
SERVO LATCH PLATE



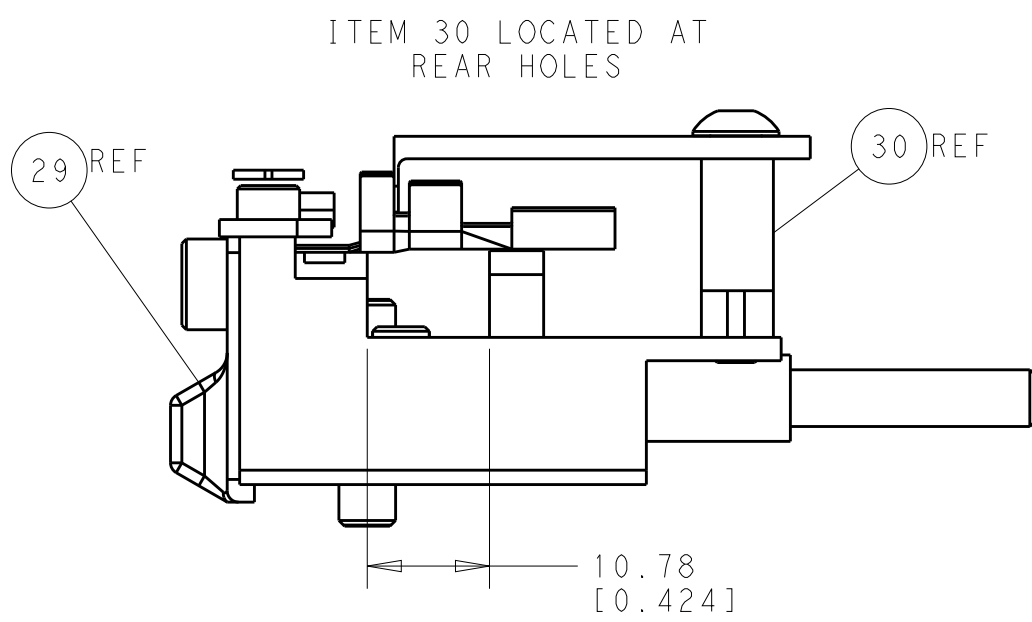
CAM POSITION



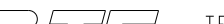
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

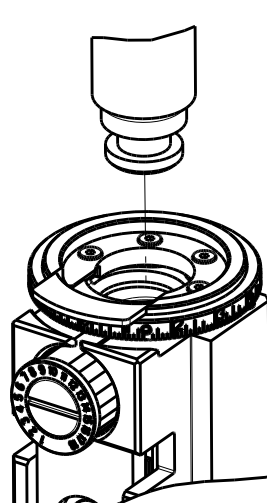


TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION.				DWN	Y. YIN		19OCT2014		 TE Connectivity Harrisburg, PA 17105-3608						
				CHK	G. BAILEY		19OCT2014								
				APVD	J. GUO		19OCT2014		NAME						
DIMENSIONS:								PRODUCT SPEC				Ocean Side Feed Applicator			
mm								APPLICATION SPEC							
TOLERANCES UNLESS OTHERWISE SPECIFIED:								SIZE							
0 PLC ±0.5								CAGE CODE							
				1 PLC ±0.13				DRAWING NO				RESTRICTED TO			
				2 PLC ±0.13				00779							
				3 PLC ±0.013				©=2266534							
				4 PLC ±0.0001				Customer Accessible Production Drawing							
				ANGLES				SCALE							
FINISH				1:2				SHEET				2 of 4			
MATERIAL				WEIGHT				REV							
								A							

8		7		6		5		4		3	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20							
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.									
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266534-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	-
	2-2266534-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	-	8-2266534-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266534-4	-	-	-
	2-2266534-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-2
7-2266534-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.50 mm [.177]	OV
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 6.3MM ISO RELAIS			
WIRE STRIP LENGTH 6.30-6.70 mm [.248-.264 IN]		INSULATION DIAMETER RANGE Ø3.20-4.70 mm [.126-.185 IN]	
TERMINAL APPLICATION 		LEAR SPEC Rev -	
SPECIFICATION			
TERMINALS APPLIED 			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113599-1	320100555	2113599-2	7703497825

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
5R3		2.70+/-0.05 [.106+/- .002]		4.9
4R3		2.50+/-0.05 [.098+/- .002]		6.0
3R3		2.40+/-0.05 [.094+/- .002]		6.9
1R3+2R3		2.30+/-0.05 [.091+/- .002]		8.3

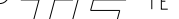
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO
LARGEST WIRE SIZE SETTING. USE OF SETTINGS
BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING
WILL CAUSE DAMAGE TO CRIMP TOOLING.



1. 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266534-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266534-5
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.
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. 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

2			I																	
SET UP GAUGE 2119599-1			LOC A			DIST 66			REVISIONS											
P			LYR			DESCRIPTION			DATE			DWN			APVD					
			-			SEE SHEET 1						-			-			-		

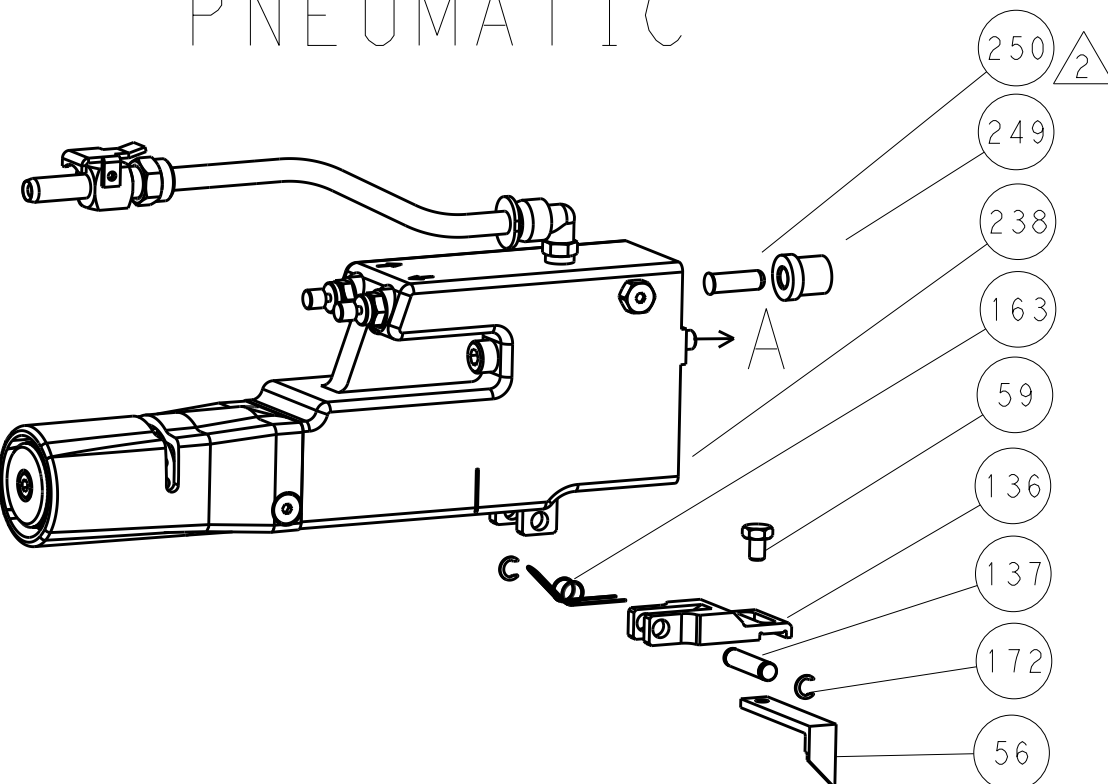
-	2	2	2	2168083-1	SCR,SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1633782-2	FENG	267
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	2063440-2	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	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	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	2119798-2	DETENT PIN	145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	1	2119740-1	TAG,IDENTIFICATION	67
-	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	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 x 6.0	59
-	-	-	1	1338683-8	FEED PAWL	56
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
1	1	1	1	7-1803054-0	ANVIL, COMBINATION	8
-	1	1	1	2-240641-0	SPACER	7
-	-	-	-			6
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4
1	1	1	1	6-2119785-7	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1	456411-1	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS THE PROPERTY OF THE COMPANY AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE COMPANY. IT IS TO BE USED FOR THE MANUFACTURE OF THE PARTS SPECIFIED HEREON ONLY.		DWG 190C12014 BY T.YIN CHK G.BAILEY 190C12014 APP'D W.GUO 190C12014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0001 .1 PLC ±0.5 .1 PLC ±0.13 .1 PLC ±0.013 .1 PLC ±0.001 ANGLES ±.0001		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE CASE CODE DRAWING NO A 1 00779 C=2266534	
MATERIAL -		FINISH -		RESTRICTED TO -	
		WEIGHT -		Customer Accessible Product Drawing	
		SCALE 1:2		SHEET 3 of 4 REV A	

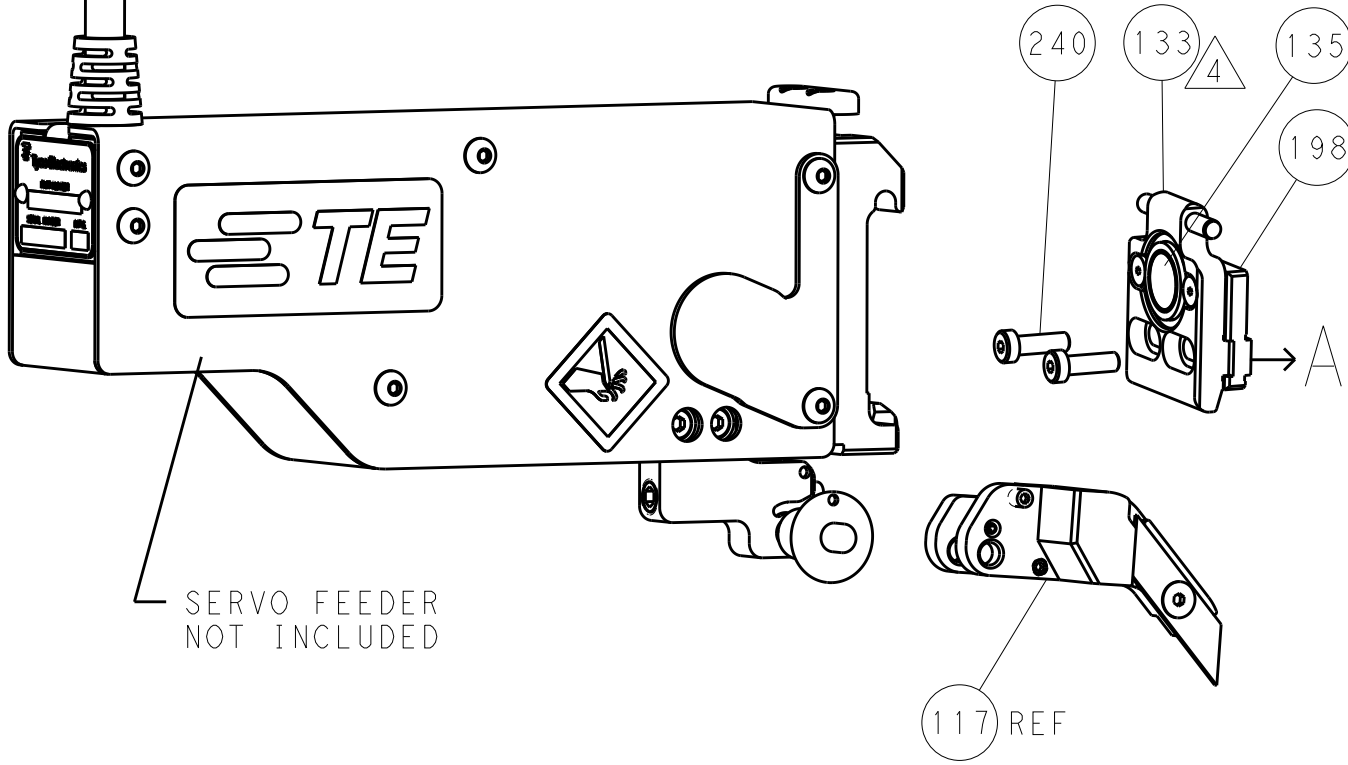
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

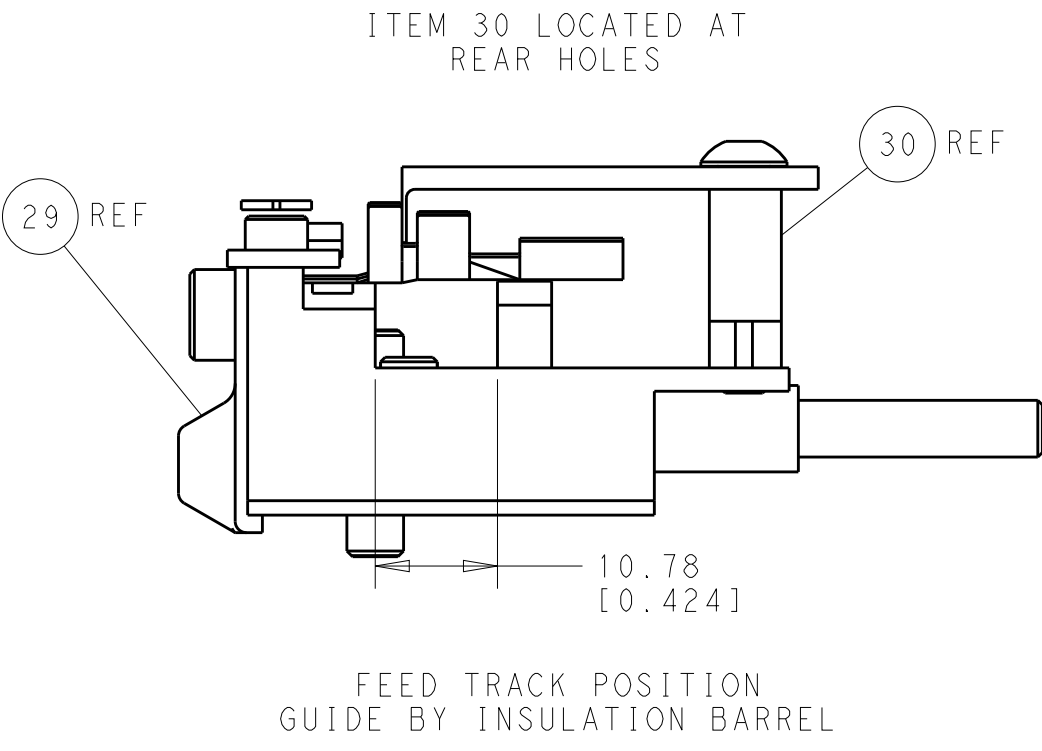
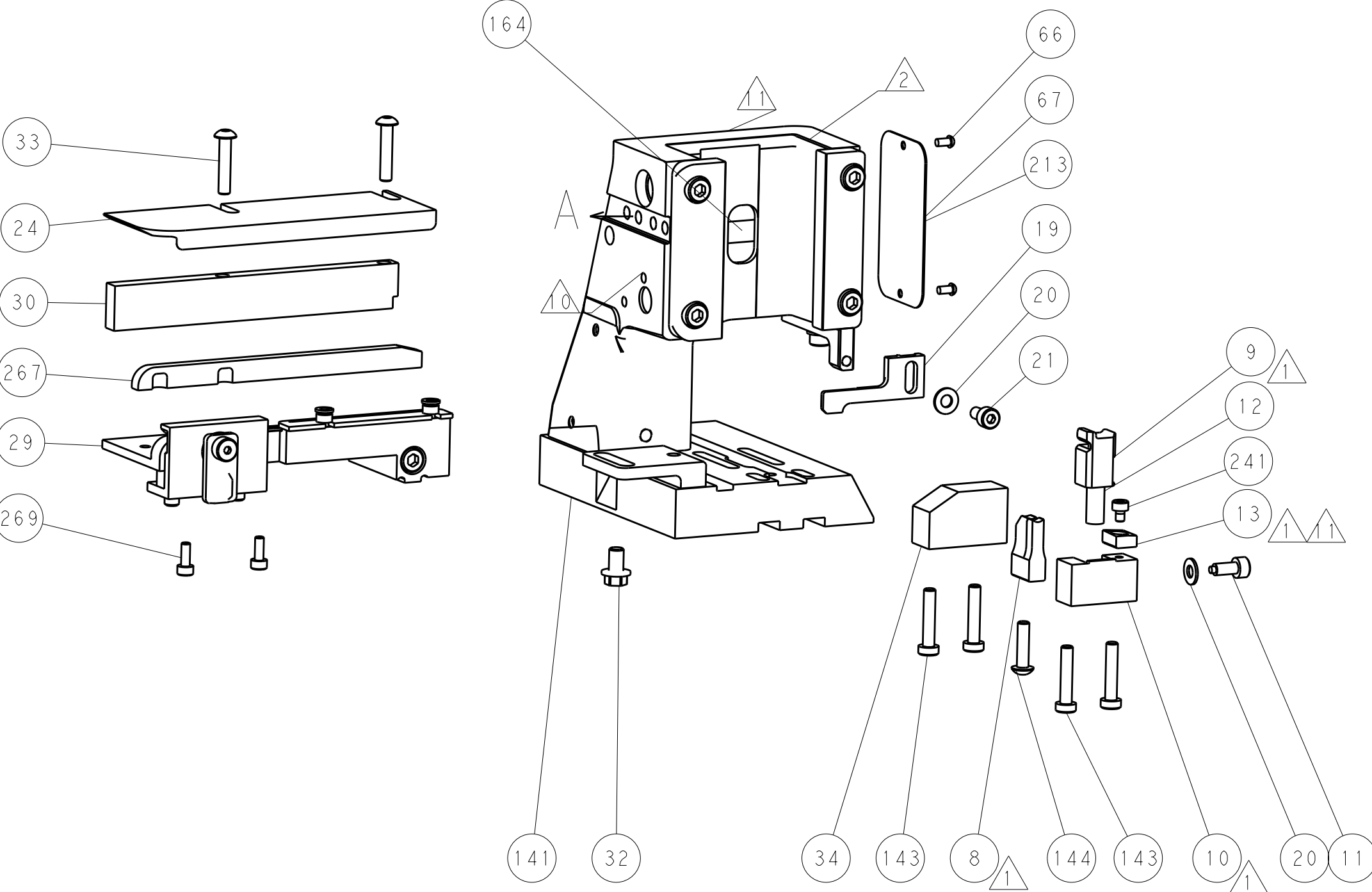
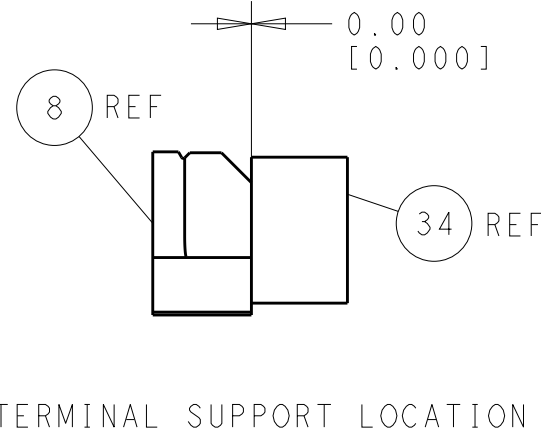
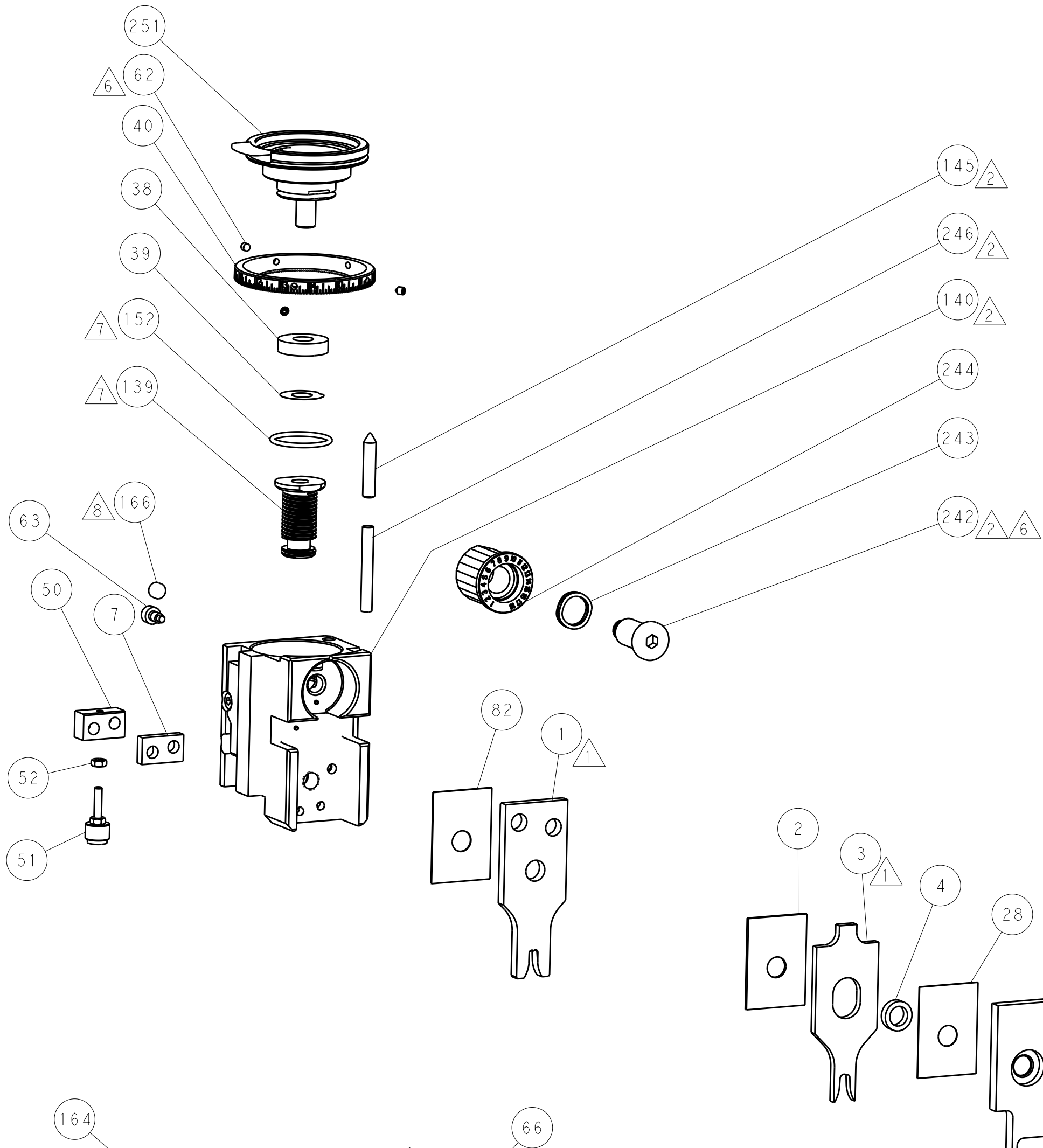
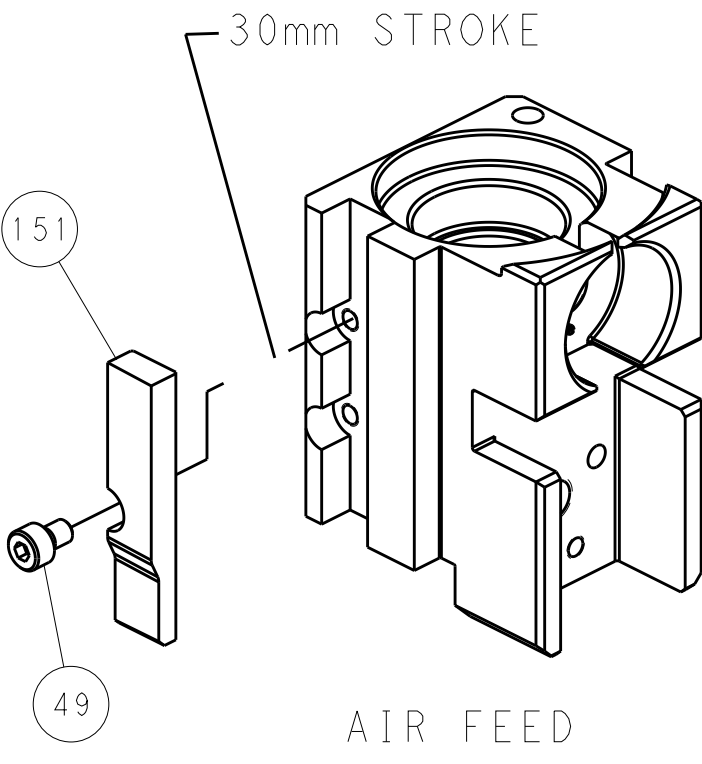
FEED TYPE
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITION



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

190CT2014		190CT2014F		190CT2014	
Y. YIN		G. BAILEY		J. GUO	
190CT2014		190CT2014F		190CT2014	
TE Connectivity		Harrisburg, PA 17105-3608		Ocean Side Feed Applicator	
00779		2266534		Customer Accessible Production Drawing	
1:2		4 of 4		REV A	