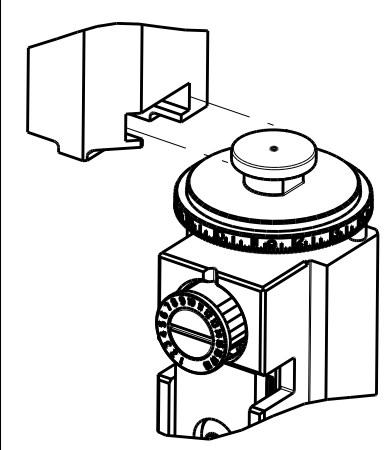


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2266673-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2266673-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2266673-5	G	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE
	2266673-6	G	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE
	2266673-7	G	FINE CRIMP HEIGHT ADJUST	NONE
	3-2266673-2	G	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
	7-2266673-7	F	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.55 mm [.061]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, MALE, GENERATION Y, 0.64			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]		INSULATION DIAMETER RANGE Ø1.10-1.40 mm [.043-.055 IN]	
TERMINAL APPLICATION SPECIFICATION		114-13183	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1924968-8	1924727-4	1924275-8	1456841-8
2098753-4	1-1924727-4	1456574-8	1456968-8
1924955-8	2035170-4	2098762-4	2138699-4
2035334-8	1-2035170-4		1-2138699-4
WIRE SIZE	CRIMP HEIGHT	CRIMP HEIGHT REFERENCE SETTING	
0.35mm2 OR 22 AWG	0.91+/-0.03 [.036+/- .001]	8.8	

- 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: 8-2266673-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266673-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266673-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266673-6
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 ITEMS 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 4.89.
- 13
- THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN WALL (FLR) INSULATION.

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	-	8-2266673-5	1901094-3	1-1752354-6	2168400-6 (QUANTITY 2)			
SMART APPLICATOR	2161326-1	-	8-2266673-4	-	-	-			
DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1			
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-			
SERVO LATCH PLATE	2119951-1	-	8-2266673-5	1901094-3	1-1752354-6	2168400-6 (QUANTITY 2)			
SMART APPLICATOR	2161326-1	-	8-2266673-4	-	-	-			
DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1			
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			
DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1			
-	-	-	-	-	-	-			
-	-	-	-	-	-	-			
-	-	-	-	-	-	-			
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			
SERVO LATCH PLATE	2119951-1	-	8-2266673-5	1901094-3	1-1752354-6	2168400-6 (QUANTITY 2)			
SMART APPLICATOR	2161326-1	-	8-2266673-4	-	-	-			
-	-	-	-	-	-	-			

- 14
- DIMENSION 1.0±0.5 ON TERMINAL SUPPORT VIEW APPLIES TO ALL SOCKET TERMINALS.
- 15
- DIMENSION 4.2±0.5 ON TERMINAL SUPPORT VIEW APPLIES TO ALL PIN TERMINALS.
- 16
- THIS APPLICATOR IS EQUIPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
- 17
- TERMINAL LUBRICANT IS RECOMMENDED.

-	1	-	-	-	-	-	1803430-1	AIR FEED MODULE	290
-	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-77	-32	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

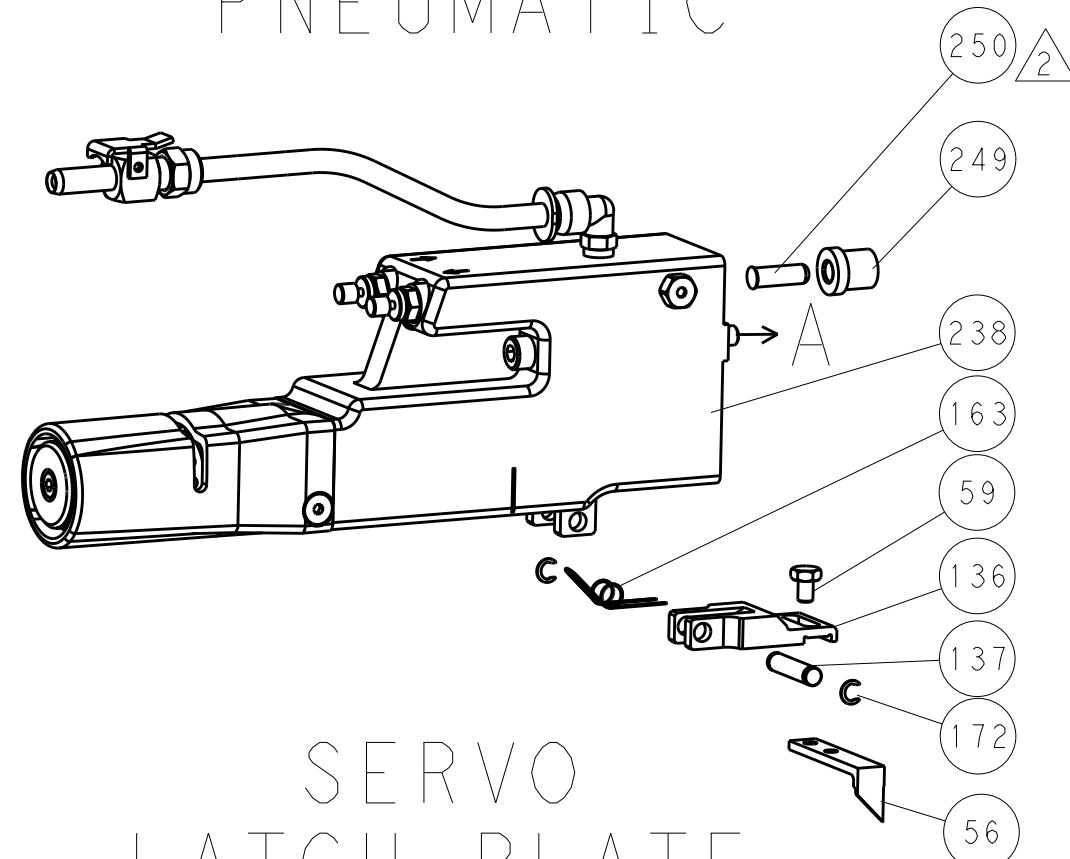
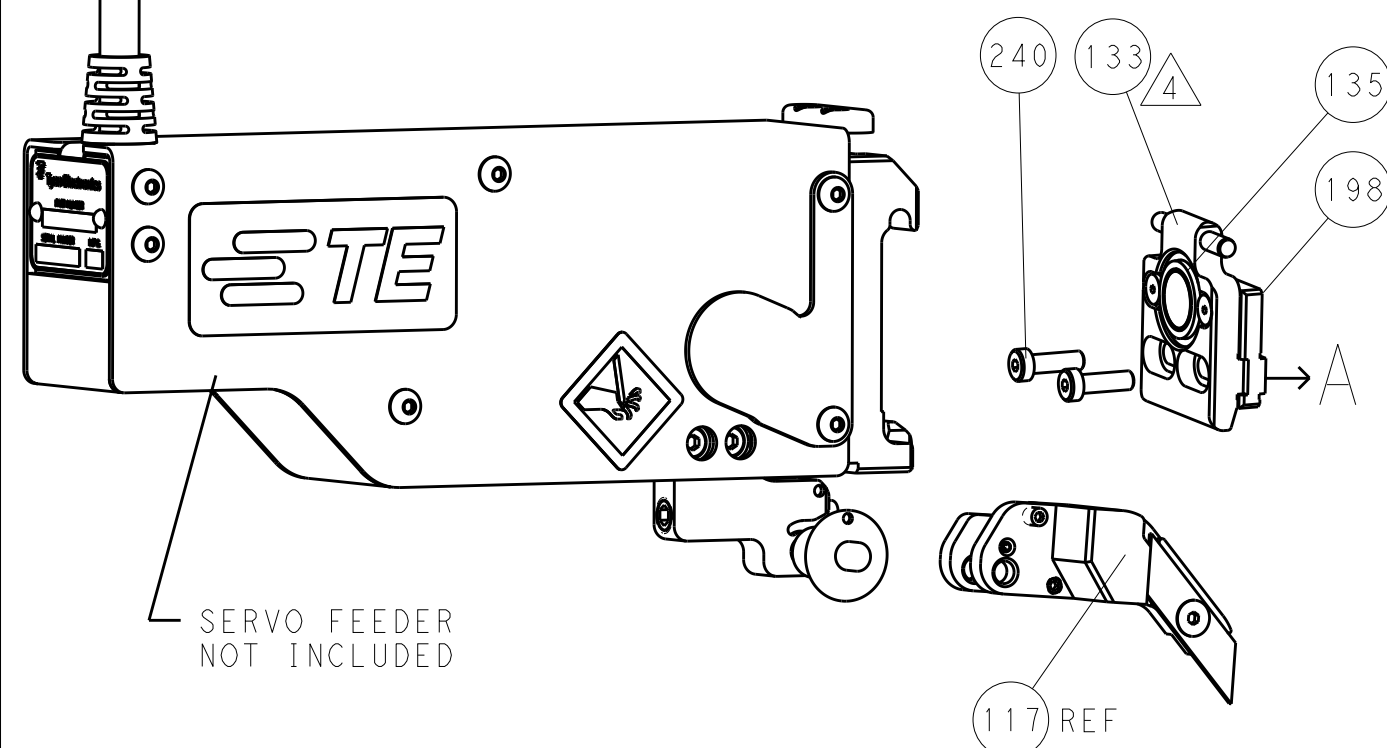
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

				2						1	
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS							
				P	LTR	DESCRIPTION			DATE	DWN	APVD
					F	ECR-16-012044			22AUG2016	MR	GB
					G	ECR-16-012485			07SEP2016	MZ	JDG
					G1	ECR-16-015428			8NOV2016	RS	LZ

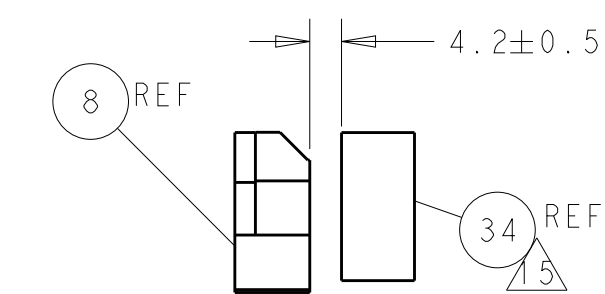
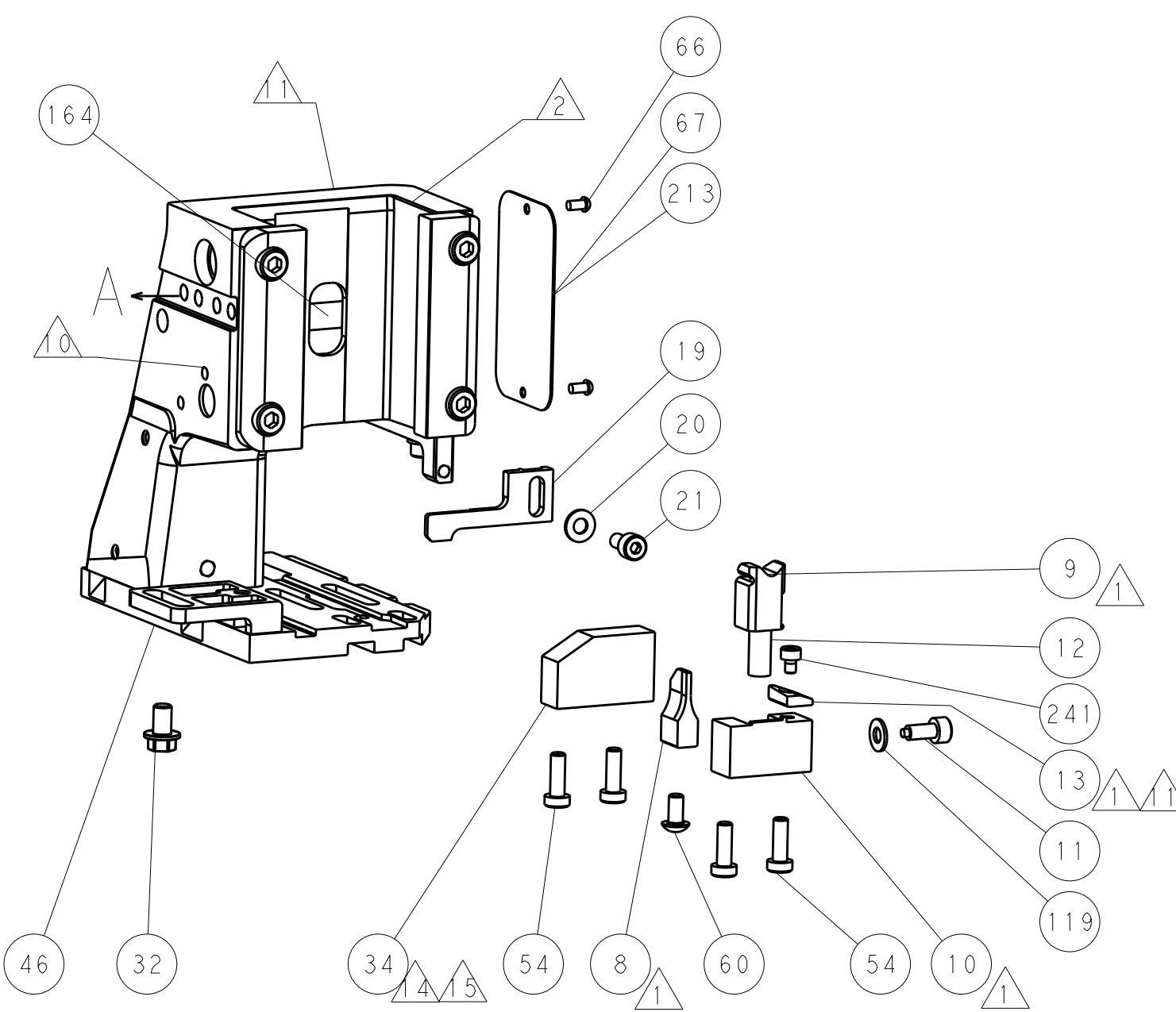
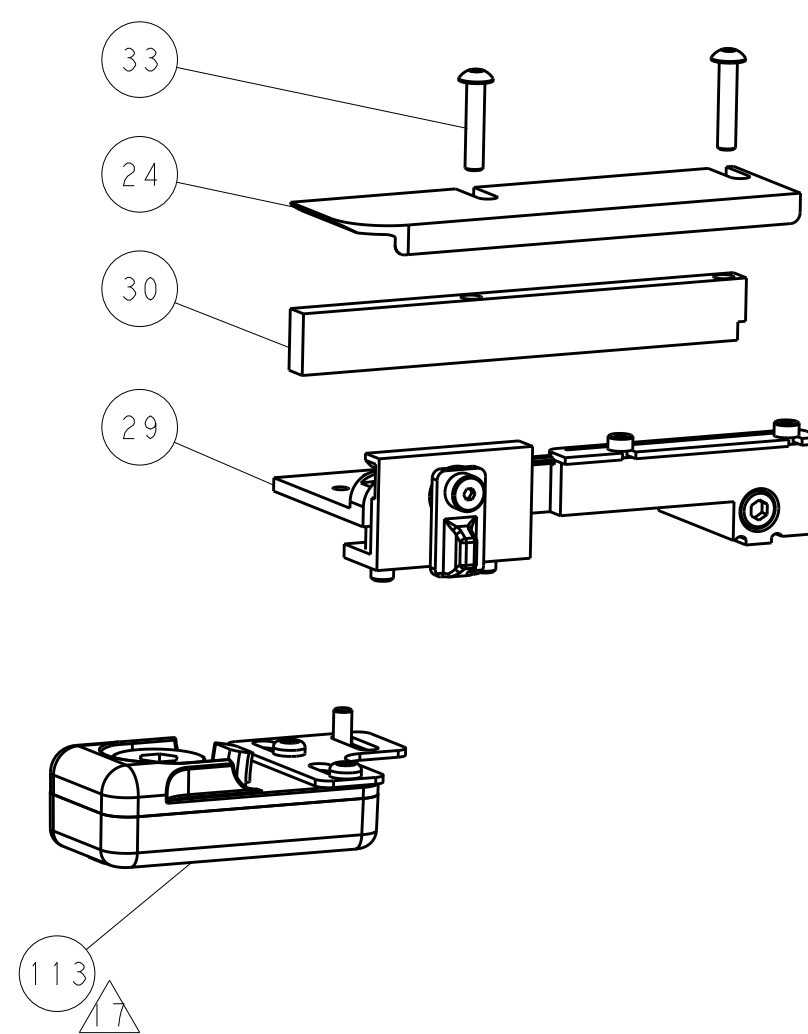
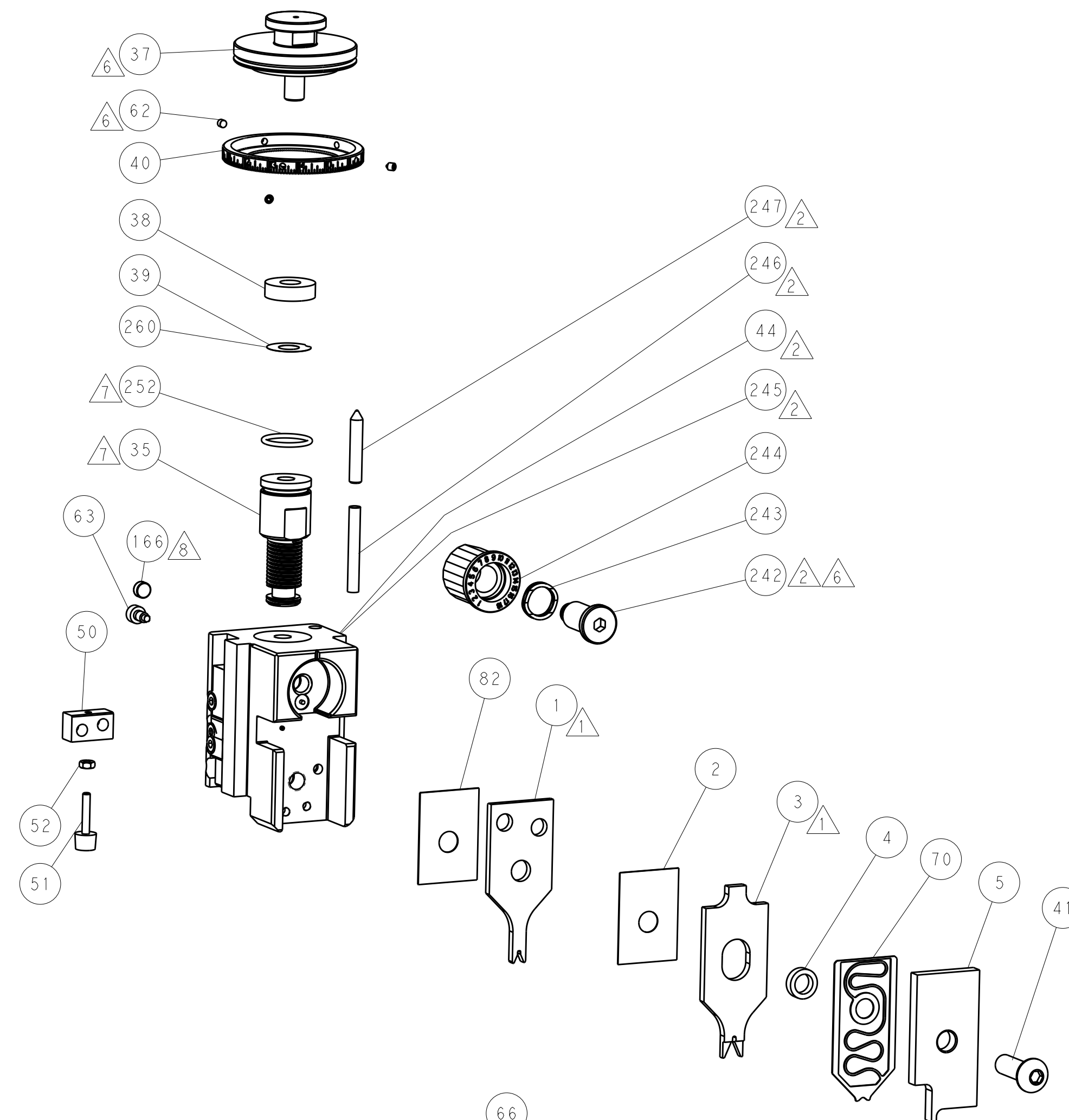
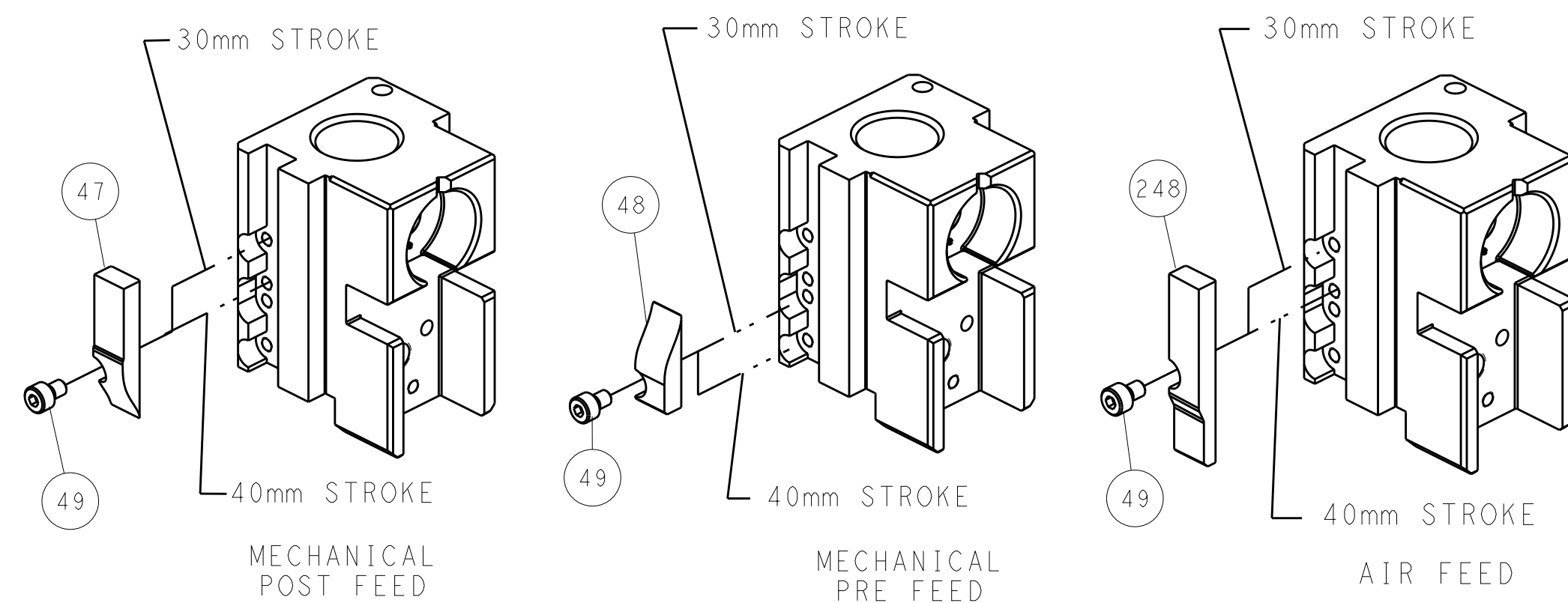
-	-	-	-	-	1	-	1803259-1	BUSHING, FLANGED	249
-	-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
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-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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
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-	2	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
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-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
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-	-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	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	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
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-	1	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	1	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
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-	4	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
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-	1	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	1	6-1752356-2	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	2119959-7	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	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	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1	1-1803058-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-3	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1	1-1803019-1	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	1	1	1	1	8-1633860-6	CRIMPER, WIRE	1

-77 -32 -7 -6 -5 -2 -1				PART NO		DESCRIPTION				ITEM NO			
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THIS ELECTRONIC COMPONENT IT IS SUBJECT TO CHANGE BASED ON CUSTOMER REQUIREMENTS. ANY REQUEST FOR MODIFICATION MUST BE CONTACTED FOR THE LATEST REVISION						DWN	06FEB2015	 TE Connectivity Harrisburg, PA 17105-3608					
						CHK	06FEB2015						
						APVD	06FEB2015						
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME		Ocean Side Feed Applicator					
mm		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1				PRODUCT SPEC							
						APPLICATION SPEC							
MATERIAL		FINISH		WEIGHT		SIZE	CASE CODE	DRAWING NO	RESTRICTED TO				
-		-		-		A1	00779	C-2266673	-				
Customer Accessible Production Drawing						SCALE		1:2	SHEET	1	OF	REV	G1

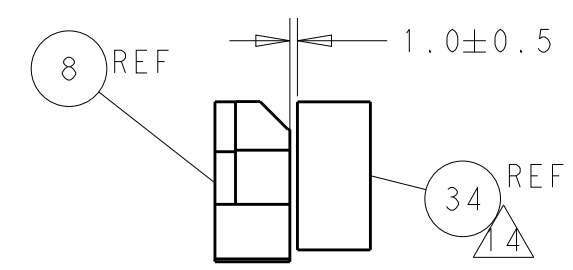
PNEUMATIC

SERVO
LATCH PLATE

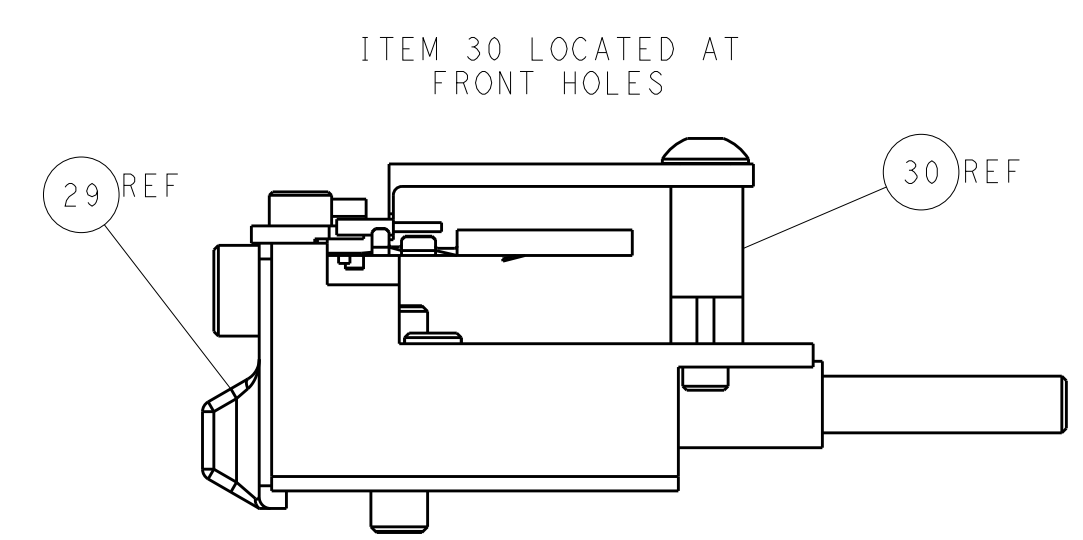
CAM POSITIONS



TERMINAL SUPPORT LOCATION
FOR ALL PIN TERMINALS

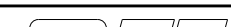
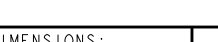


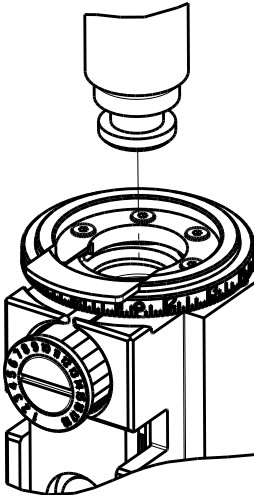
TERMINAL SUPPORT LOCATION
FOR ALL SOCKET TERMINALS

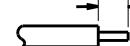


FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±.		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE - CAGE CODE - DRAWING NO - A1 00779 C=2266673	
MATERIAL - FINISH -		WEIGHT -		RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 of 4 REV G	

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2266673-1	G	FINE CRIMP HEIGHT ADJUST
	2-2266673-2	G	FINE CRIMP HEIGHT ADJUST
	2-2266673-5	G	FINE CRIMP HEIGHT ADJUST
	2-2266673-7	G	FINE CRIMP HEIGHT ADJUST
	4-2266673-2	G	FINE CRIMP HEIGHT ADJUST
	7-2266673-7	F	CRIMP TOOLING KIT

APPLICATOR DATA			
CRIMP	SIZE	TYPE	
WIRE	1.07 mm [.042]	F	
INSUL	1.55 mm [.061]	O	
APPLICATOR INSTRUCTIONS			
408-10389			
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, MALE, GENERATION Y, 0.64			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.00-4.50 mm [.157-.177 IN]			Ø1.10-1.40 mm [.043-.055 IN]
TERMINAL APPLICATION SPECIFICATION		114-13183	- - -
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1924968-8	1924727-4	1924275-8	1456841-8
2098753-4	1-1924727-4	1456574-8	1456968-8
1924955-8	2035170-4	2098762-4	2138699-4
2035334-8	1-2035170-4		1-2138699-4
WIRE SIZE   	CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.35mm2 OR 22 AWG	0.91+/-0.03 [.036+/-0.001]		8.8

-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266673-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266673-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266673-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
-  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.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
-  MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
-  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.
-  SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
-  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.
-  THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN WALL (FLR) INSULATION.

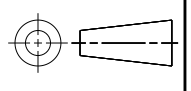
-  DIMENSION 1.0±0.5 ON TERMINAL SUPPORT VIEW APPLIES TO ALL SOCKET TERMINALS.
-  DIMENSION 4.2±0.5 ON TERMINAL SUPPORT VIEW APPLIES TO ALL PIN TERMINALS.
-  THIS APPLICATOR IS EQUIPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
-  TERMINAL LUBRICANT IS RECOMMENDED.

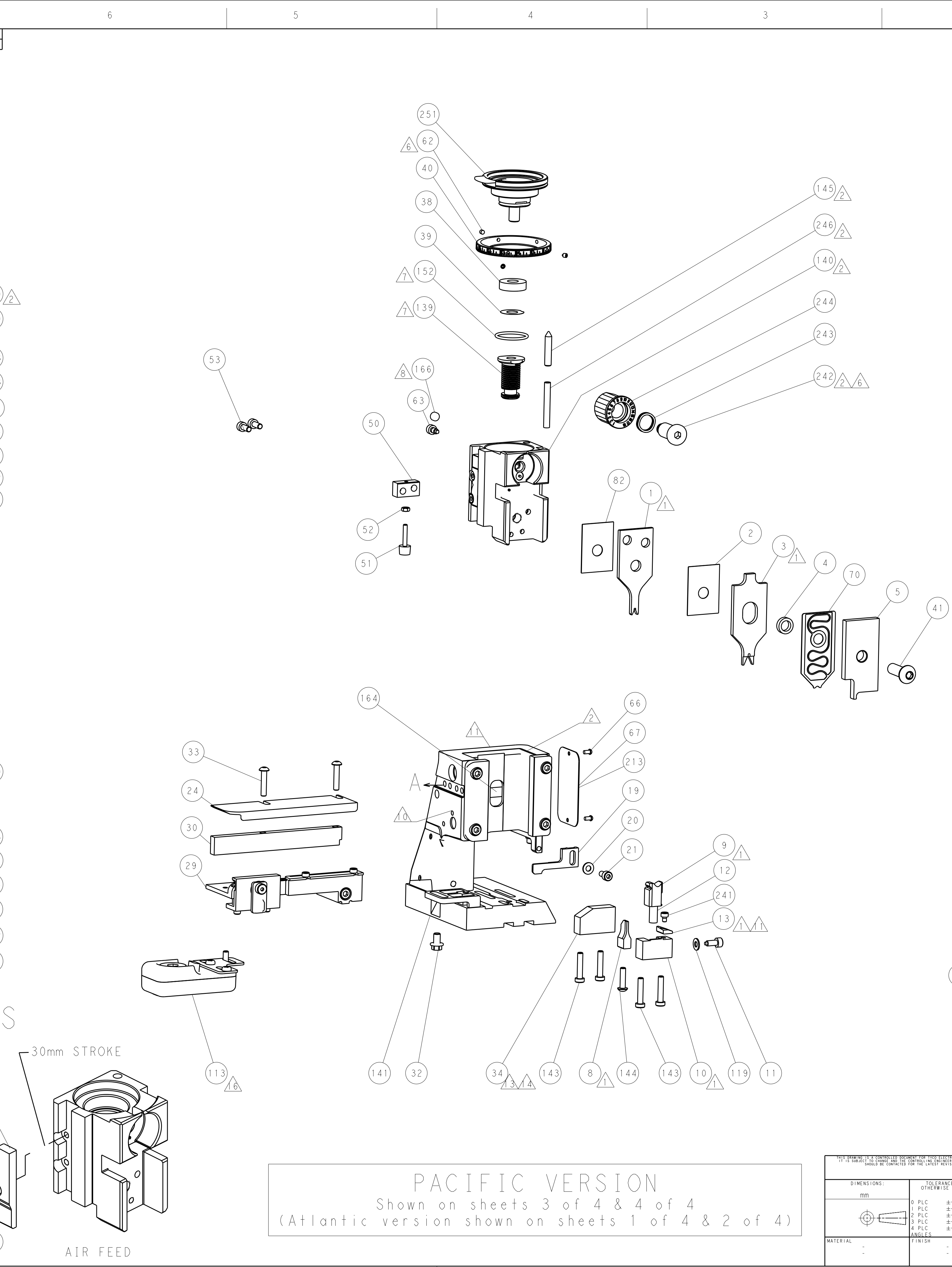
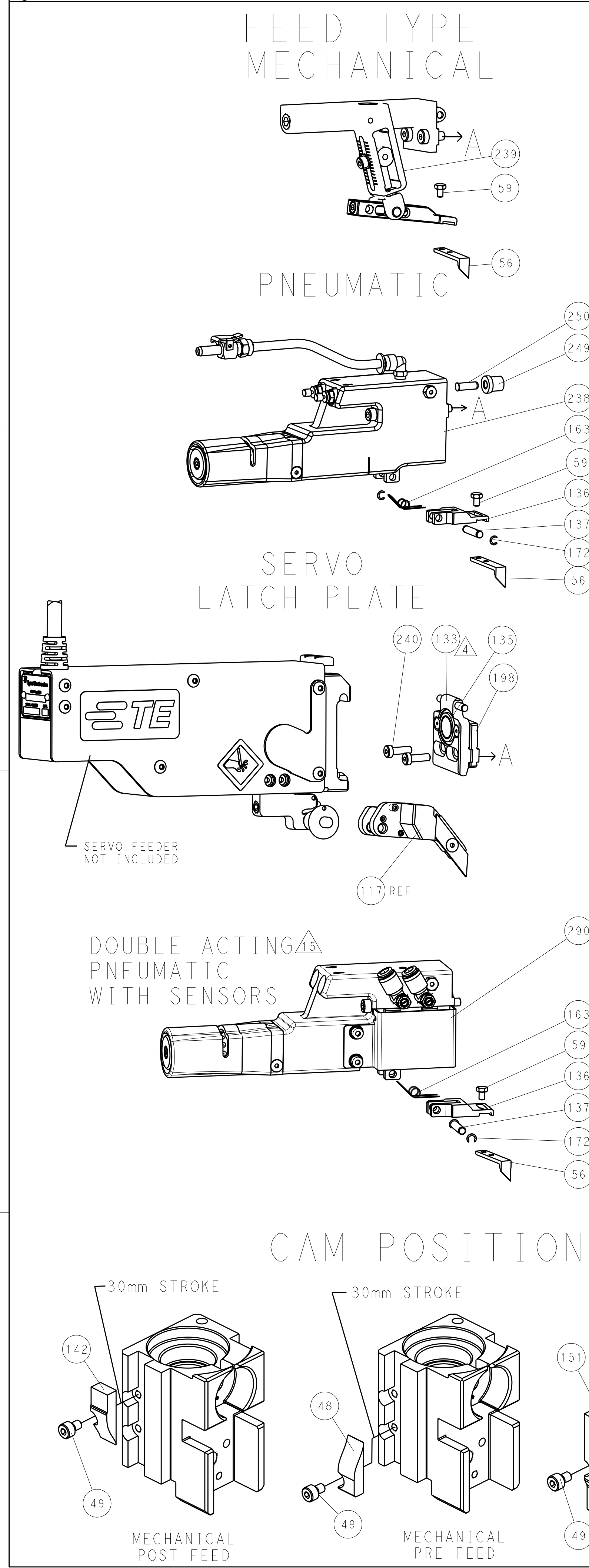
-	1	-	-	-	-	1803430-1	AIR FEED MODULE	290
-	1	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-77	-42	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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			
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THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE CONTACTED FOR THE LATEST EDITION.		OWN J. HOU CHK L. ZHANG APVD J. GUO	06FEB2015 06FEB2015 06FEB2015	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC		SIZE A1	
MATERIAL -		APPLICATION SPEC		CASE CODE 00779	
-		WEIGHT -		DRAWING NO C=2266673	
-		Customer Accessible Production Drawing		RESTRICTED TO -	
-		SCALE 1:2		SHEET 3 OF 4	
-		REV G1			



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

TERMINAL SUPPORT LOCATION FOR ALL PIN TERMINALS

TERMINAL SUPPORT LOCATION FOR ALL SOCKET TERMINALS

ITEM 30 LOCATED AT FRONT HOLES

FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
mm		0 PLC	±
		1 PLC	±
		2 PLC	±
		3 PLC	±
		4 PLC	±
		ANGLES	±
		FINISH	±
MATERIAL			

OWN	06FEB2015	 TE Connectivity Harrisburg, PA 17105-3608					
CHK	06FEB2015						
APVD	06FEB2015						
U. GUO							
PRODUCT SPEC		NAME	Ocean Side Feed Applicator				
APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
WEIGHT		A1	00779	©=2266673	-		
Customer Accessible Production Drawing		SCALE	1:2	SHEET	4 OF 4	REV	G1

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION