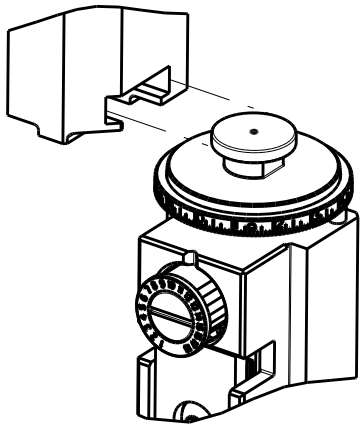
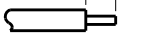


8		7		
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION
	2266172-1	B	FINE CRIMP HEIGHT ADJUST	
	2266172-2	B	FINE CRIMP HEIGHT ADJUST	
	2266172-5	B	FINE CRIMP HEIGHT ADJUST	
	2266172-6	B	NON-CRIMP HEIGHT ADJUST	4
	2266172-7	B	FINE CRIMP HEIGHT ADJUST	
	7-2266172-7	A	CRIMP TOOLING KIT	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.79 mm [.031]	F
INSUL	0.70 mm [.028]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MOLEX TERMINAL		Molex CRIMP SPECIFICATION	
TERMINAL NAME: 1.5 WIRE TO WIRE CONN. CRIMP PLUG TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.40-1.90 mm [.055-.075 IN]		Ø0.50-1.00 mm [.020-.039 IN]	
TERMINAL APPLICATION SPECIFICATION		63900-4200-A	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113413-1	500618000	2113413-2	500618018
2113413-3	500618028	2113413-4	500618099
2113413-5	501338000		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
28 AWG		0.51+/-0.03 [.020+/- .001]		6.6
30 AWG		0.50+/-0.025 [.019+/- .001]		6.7
32 AWG		0.47+/-0.025 [.018+/- .001]		7.0



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: 8-2266172-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266172-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266172-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266172-6

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.
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 5.29.

TERMINAL DATA: MOLEX TERMINAL		Molex CRIMP SPECIFICATION	
TERMINAL NAME: 1.5 WIRE TO WIRE CONN. CRIMP PLUG TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.40-1.90 mm [.055-.075 IN]		Ø 0.50-1.00 mm [.020-.039 IN]	
TERMINAL APPLICATION SPECIFICATION		63900-4200-A Rev -	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113413-6	501258000	2113413-7	500808000

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
26 AWG		0.61+/-0.025 [.024+/- .001]		9.1
28 AWG		0.57+/-0.025 [.023+/- .001]		9.6

*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.

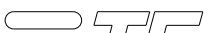
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO



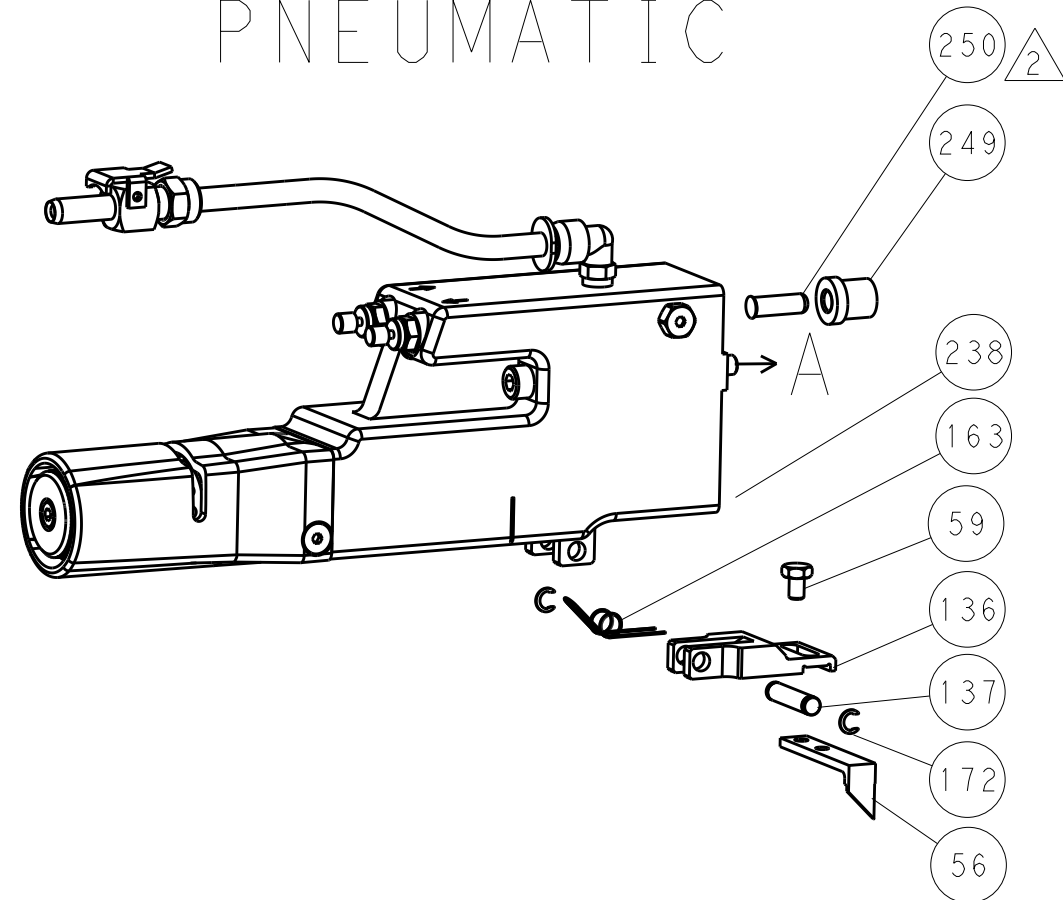
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE DWN APVD
				A	RELEASED	04FEB2014 BH TE
				B	ECR-14-005033	04APR2014 XZ TE
				B1	ECR-16-000837	20JAN2016 JH GB
				B2	ECR-16-003283	03MAR2016 JH TE

6	-	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
8	-	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	1-22281-8	SPRING, COMPRESSION	98
	-	1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	97
	-	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1	1	1	1-455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	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
6	-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
	-	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53
	-	-	-	-	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	1-2119644-4	RAM WASHER, PRECISION	38
6	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
7	-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	1	2-1752356-6	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	2-1901086-0	PLATE, STRIP GUIDE	31
	-	1	1	1	1	1	1320908-2	SPACER, STRIP GUIDE	30
	-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
	-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	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	2119533-3	STRIPPER, SIDE FEED	19
	-	1	1	1	1	1	2-690518-8	HOLD DOWN, TERMINAL	18
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	1633861-1	SHEAR, FLOATING	9
1	1	1	1	1	1	1	7-1633927-2	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	-	6
	-	1	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	2-238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1	2-1803017-5	CRIMPER, INSULATION F	3
	-	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	1	1	1	1	1633713-3	CRIMPER, WIRE PREMIUM	1
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS SHOULD BE CONTACTED FOR THE LATEST NOTATION.				DWN X. ZHAO	12DEC2013	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK L. ZHANG	12DEC2013				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T. ELBIN	12DEC2013	NAME Ocean Side Feed Applicator			
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC		SIZE CASE CODE DRAWING NO			
		FINISH		APPLICATION SPEC		RESTRICTED TO			
MATERIAL				WEIGHT		A1 00779 ©=2266172			
Customer Accessible Production Drawing						SCALE 1:2		SHEET 1 OF 4	
								REV B2	

PNEUMATIC



LATCH PLATE

SERVO FEEDER
NOT INCLUDED

240 133 135 198 117 REF

30mm STROKE

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

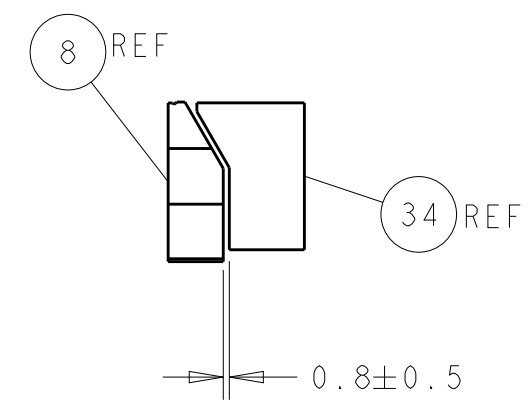
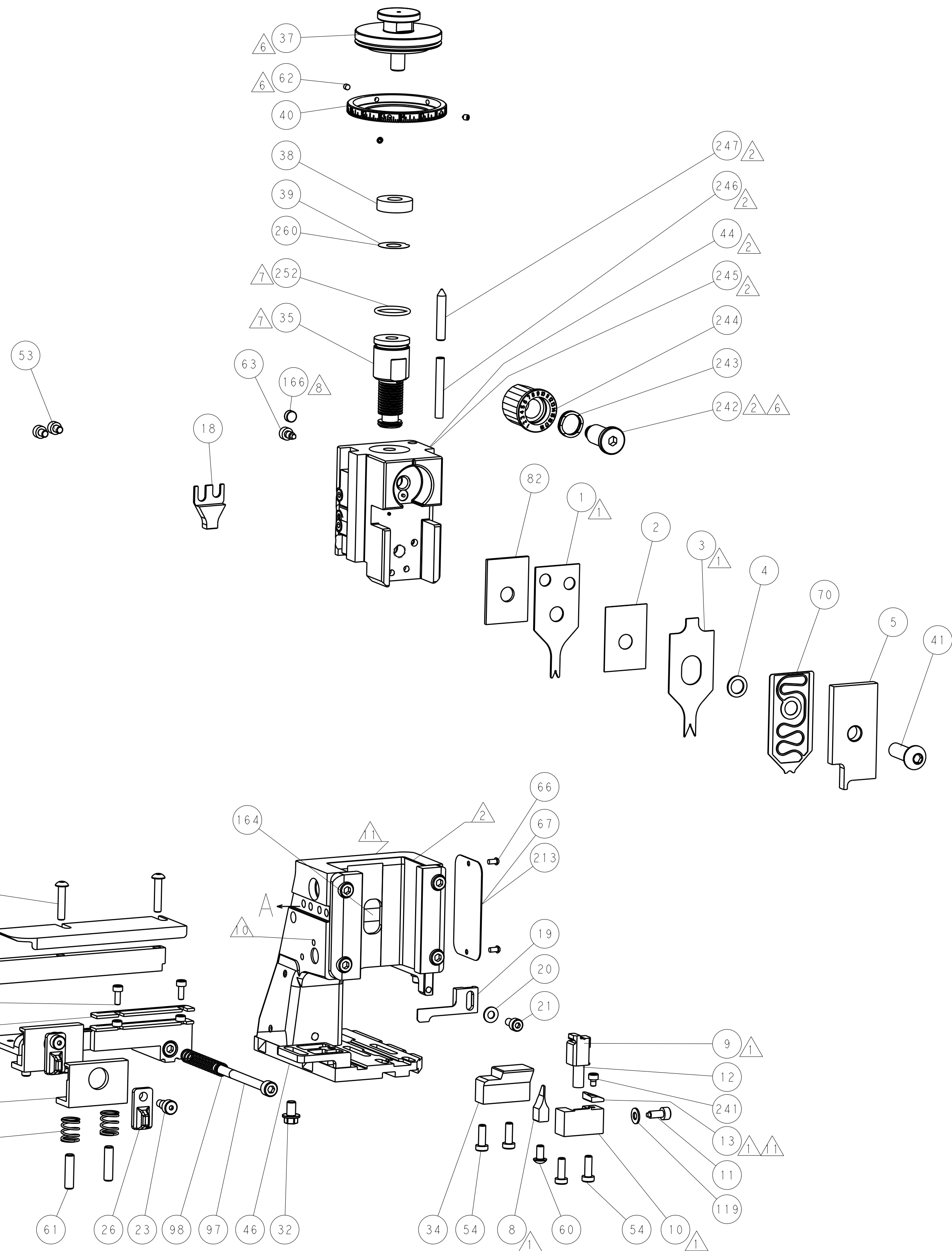
40mm STROKE

MECHANICAL PRE FEED

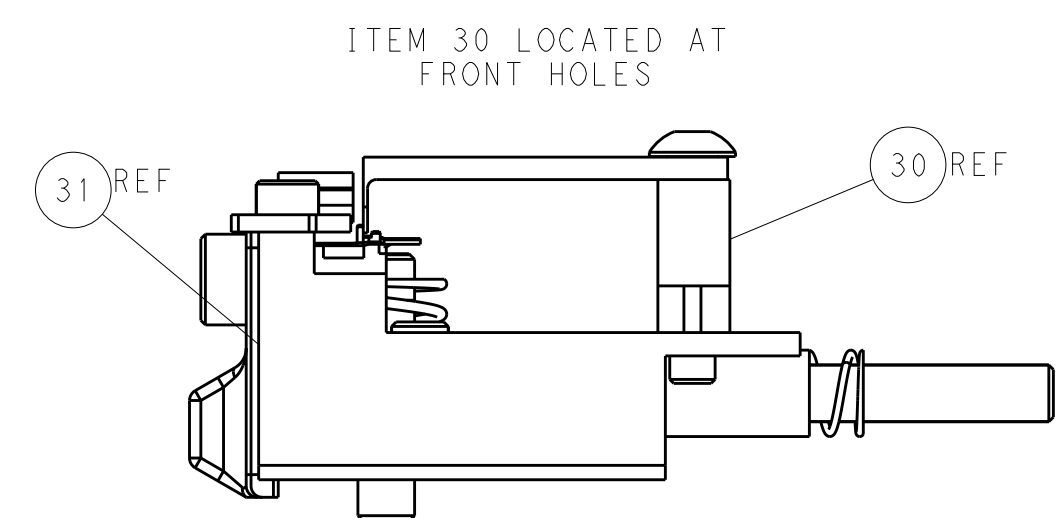
30mm STROKE

40mm STROKE

AIR FEED



TERMINAL SUPPORT LOCATION



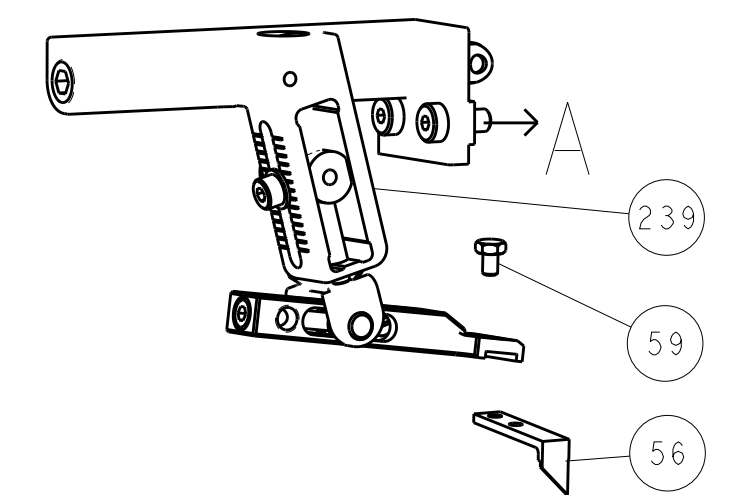
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

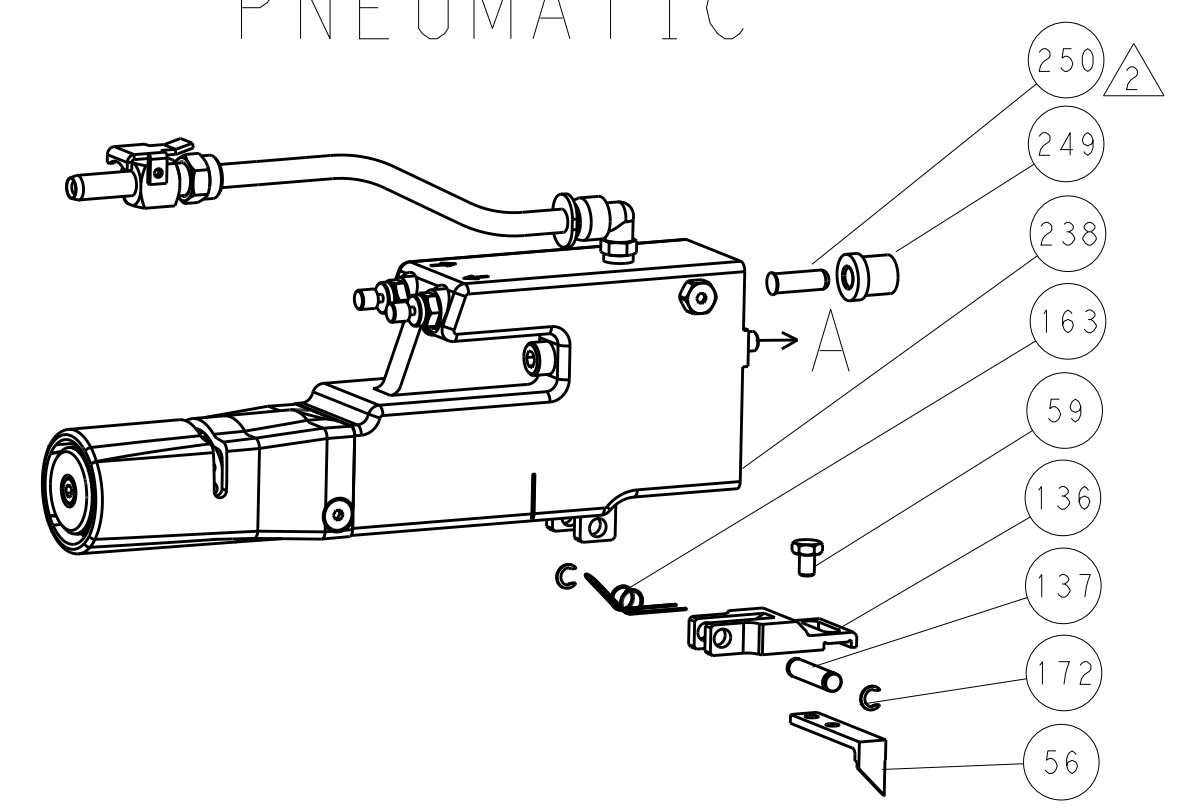
FILE OPENING IS A CONTROLLED DOCUMENT FOR TFCO-ESTERESERVICES CORPORATION IT IS SUBJECT TO THE TFCO-ESTERESERVICES CORPORATION'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN X ZHAO CHK ELBIN APVD L ZHANG	12DEC2013 12DEC2013 12DEC2013	 TE Connectivity Harrisburg, PA 17105-3608				
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	SIZE A	CASE CODE 00779	DRAWING NO C=2266172	RESTRICTED TO -
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±						
		PRODUCT SPEC - APPLICATION SPEC -						
MATERIAL -		FINISH - WEIGHT -						
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2	OF 4	REV B	

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

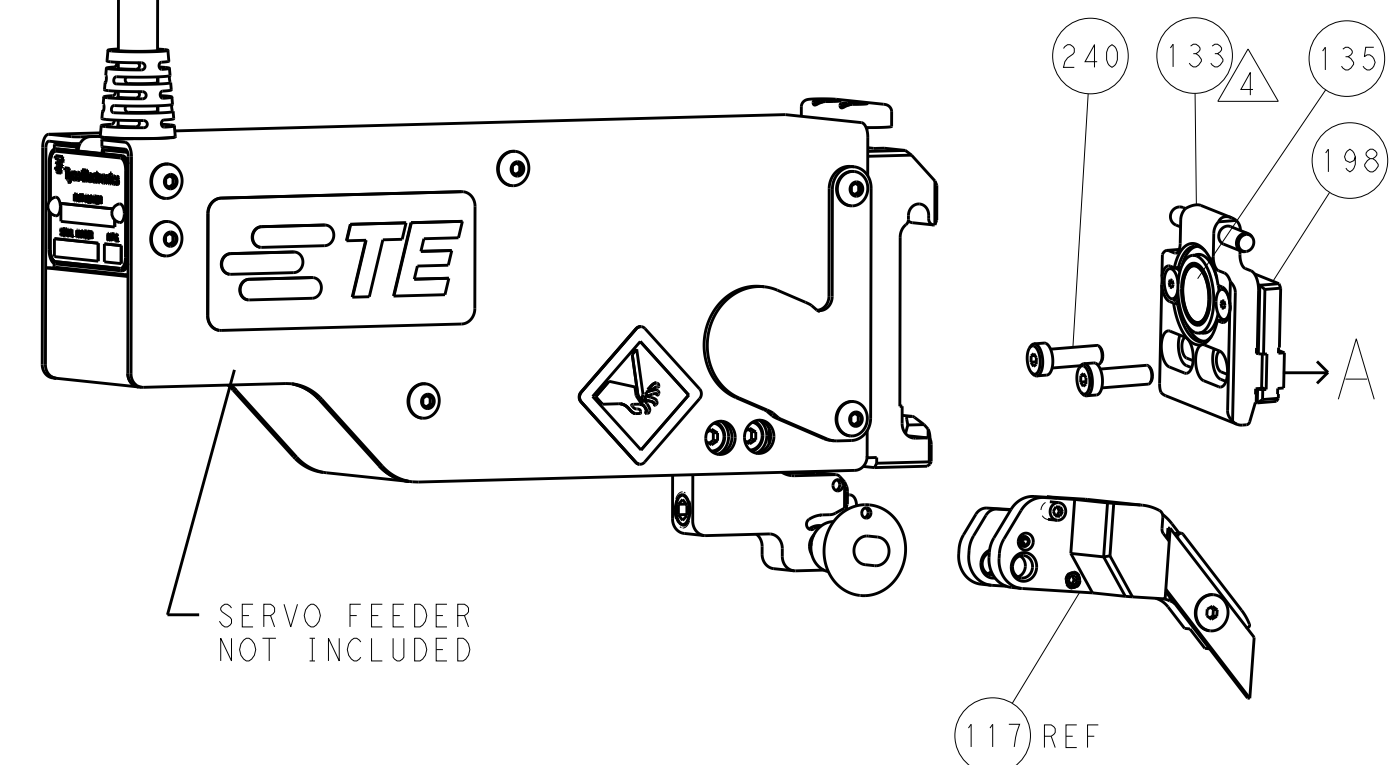
FEED TYPE
MECHANICAL



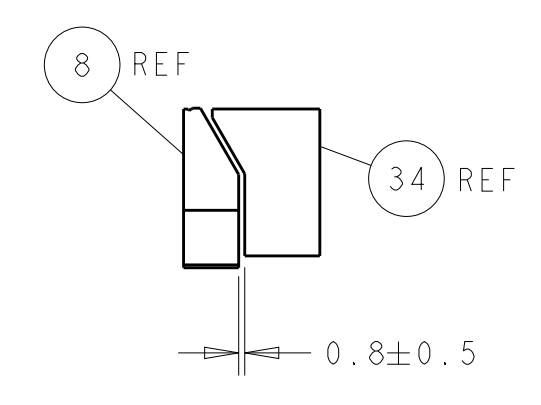
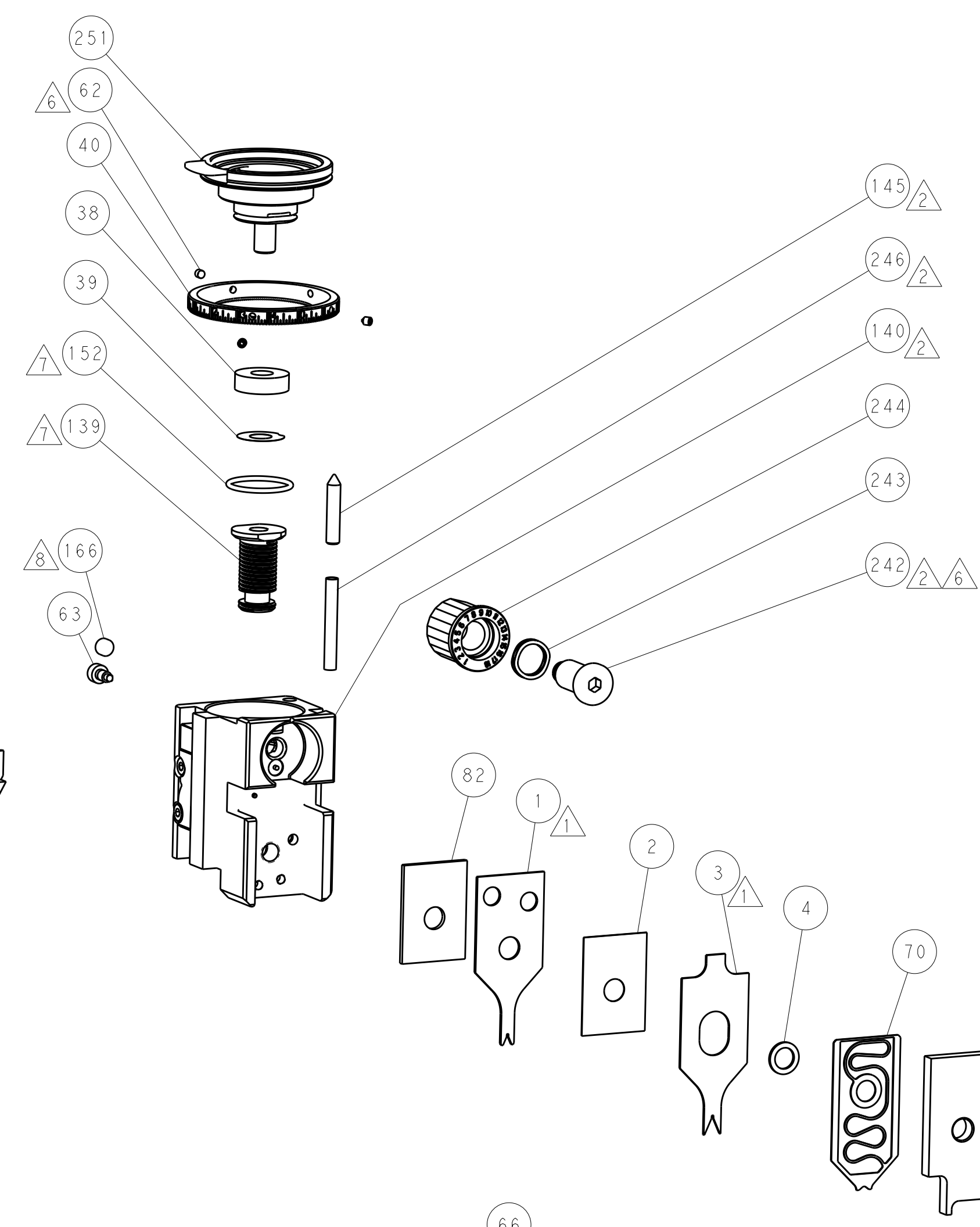
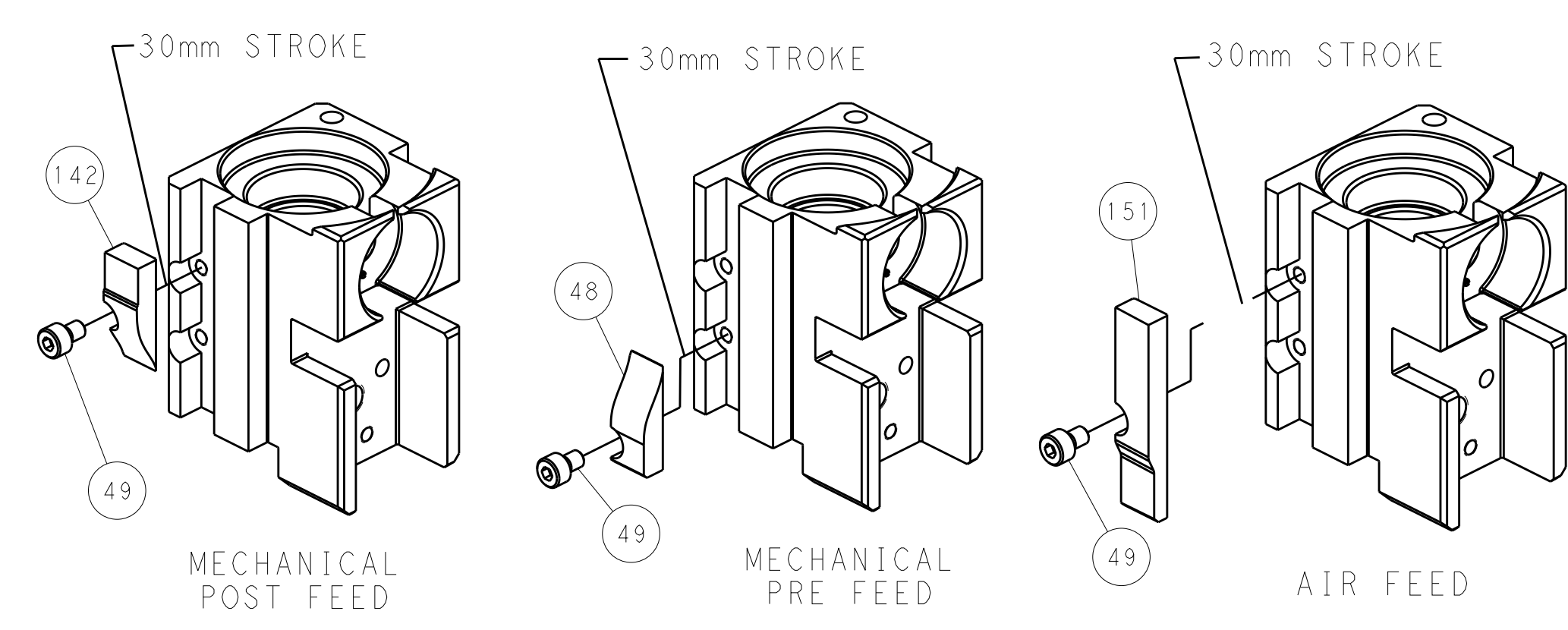
PNEUMATIC



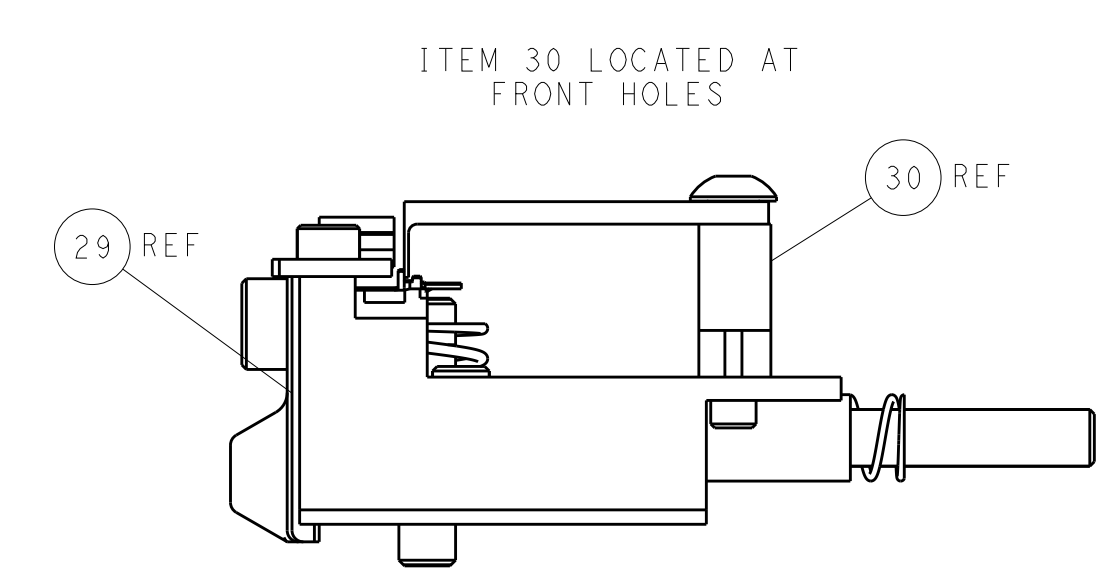
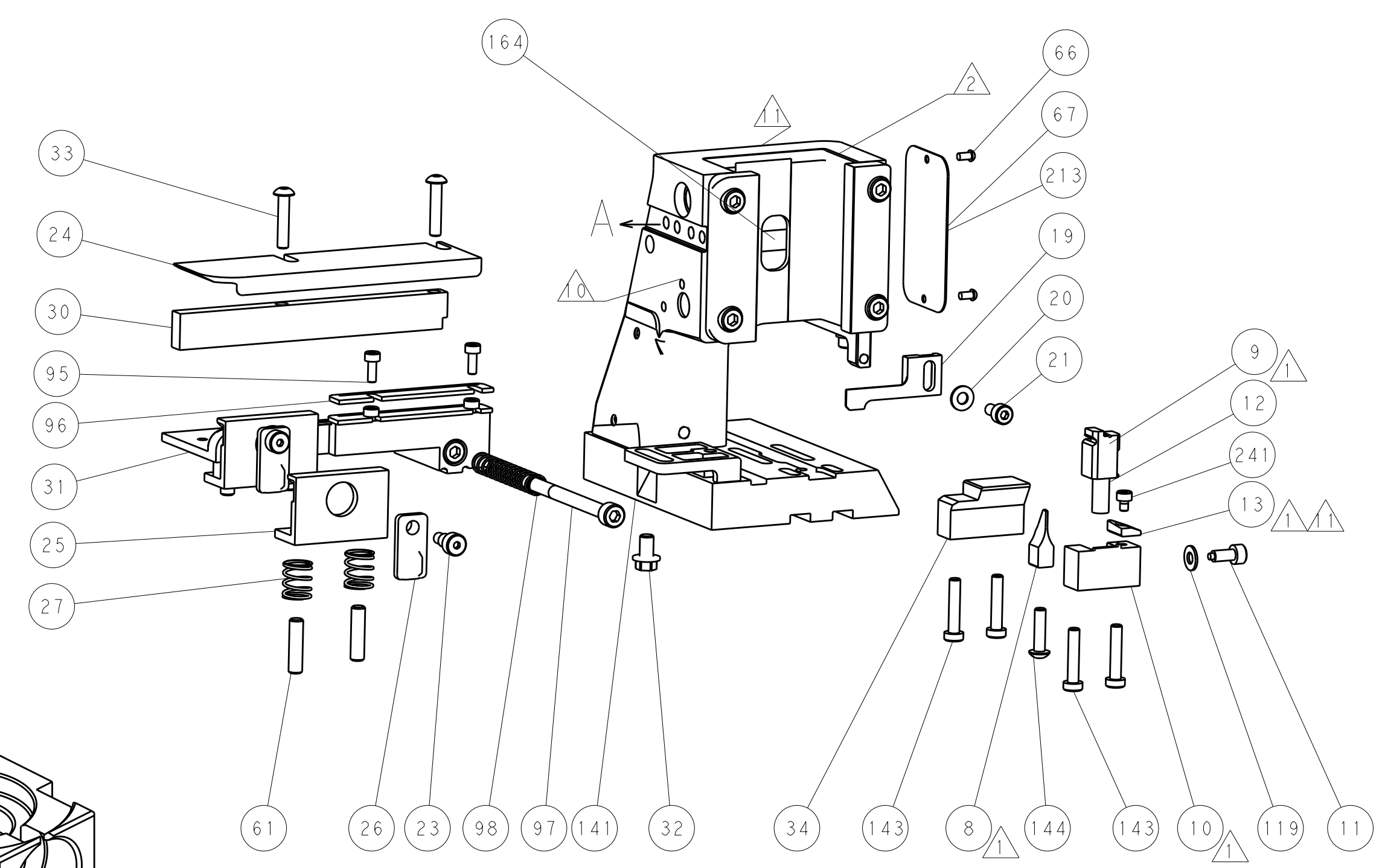
SERVO
LATCH PLATE



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 X. ZHAO 12DEC2013		CHK L. ZHANG 12DEC2013		APVD T. ELBIN 12DEC2013		NAME Ocean Side Feed Applicator	
mm		0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±	
ANGLES		FINISH		WEIGHT		SIZE		CAGE CODE		DRAWING NO	
MATERIAL		-		-		A1		00779		C=2266172	
Customer Accessible Production Drawing		SCALE		1:2		SHEET		4		OF 4	
										REV B2	