

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:	8-2266649-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION:	8-2266649-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST":	8-2266649-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST":	8-2266649-6
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 ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM
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 4.12.

6		5			4		3	
FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
	CONVERT TO	PART NUMBERS REQUIRED						
MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1	
	SERVO LATCH PLATE	2119951-1	-	8-2266649-5	1901094-3	-	2168400-6 (QUANTITY 2)	
	SMART APPLICATOR	2161326-1	-	8-2266649-4	-	-	-	
PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-	-	
	SERVO LATCH PLATE	2119951-1	-	8-2266649-5	1901094-3	-	2168400-6 (QUANTITY 2)	
	SMART APPLICATOR	2161326-1	-	8-2266649-4	-	-	-	
SERVO LATCH PLATE 	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-	-	
	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1	
SERVO LATCH PLATE 	-	-	-	-	-	-	-	
	-	-	-	-	-	-	-	
NONE	-	-	-	-	-	-	-	
-	-	-	-	-	-	-	-	

```
*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.
```

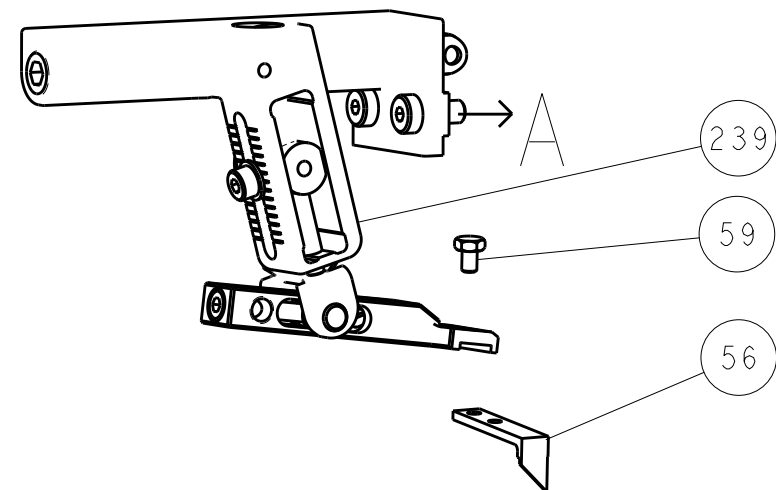
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

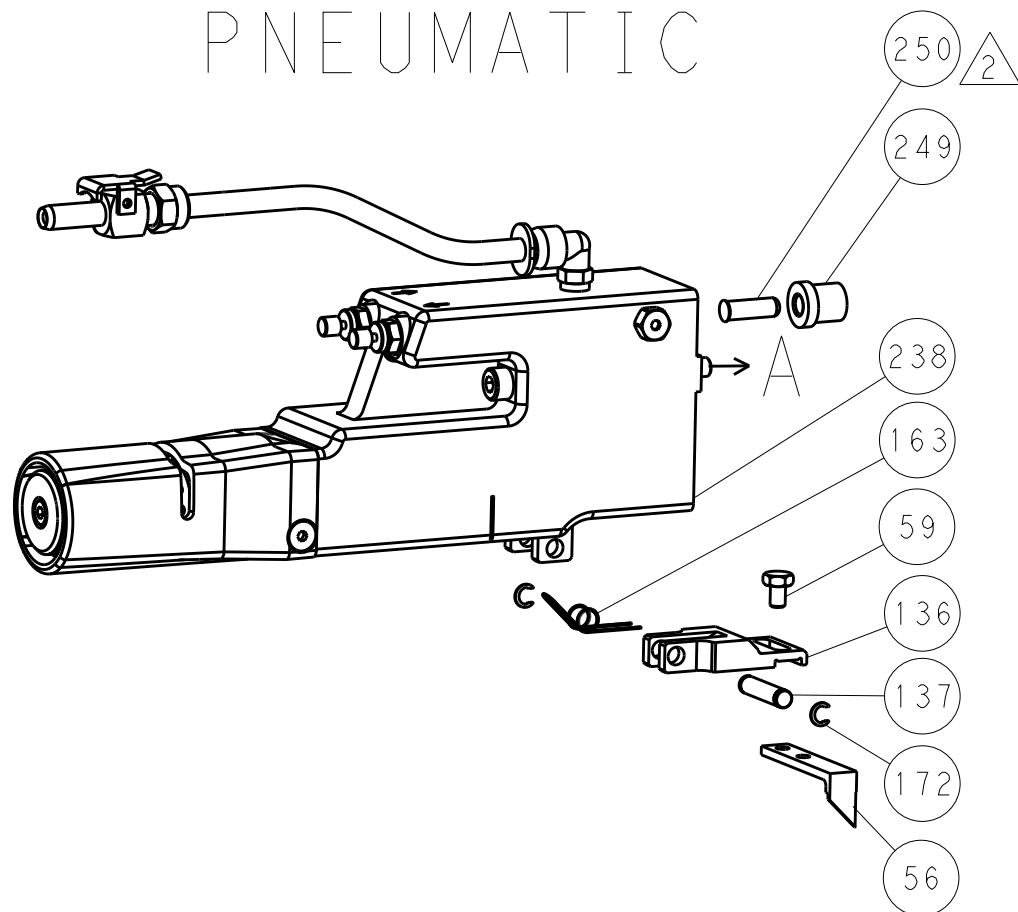
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LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL



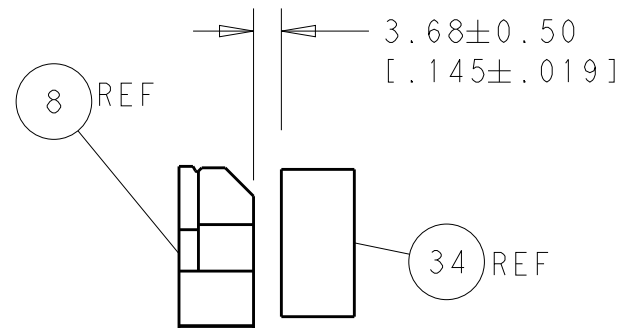
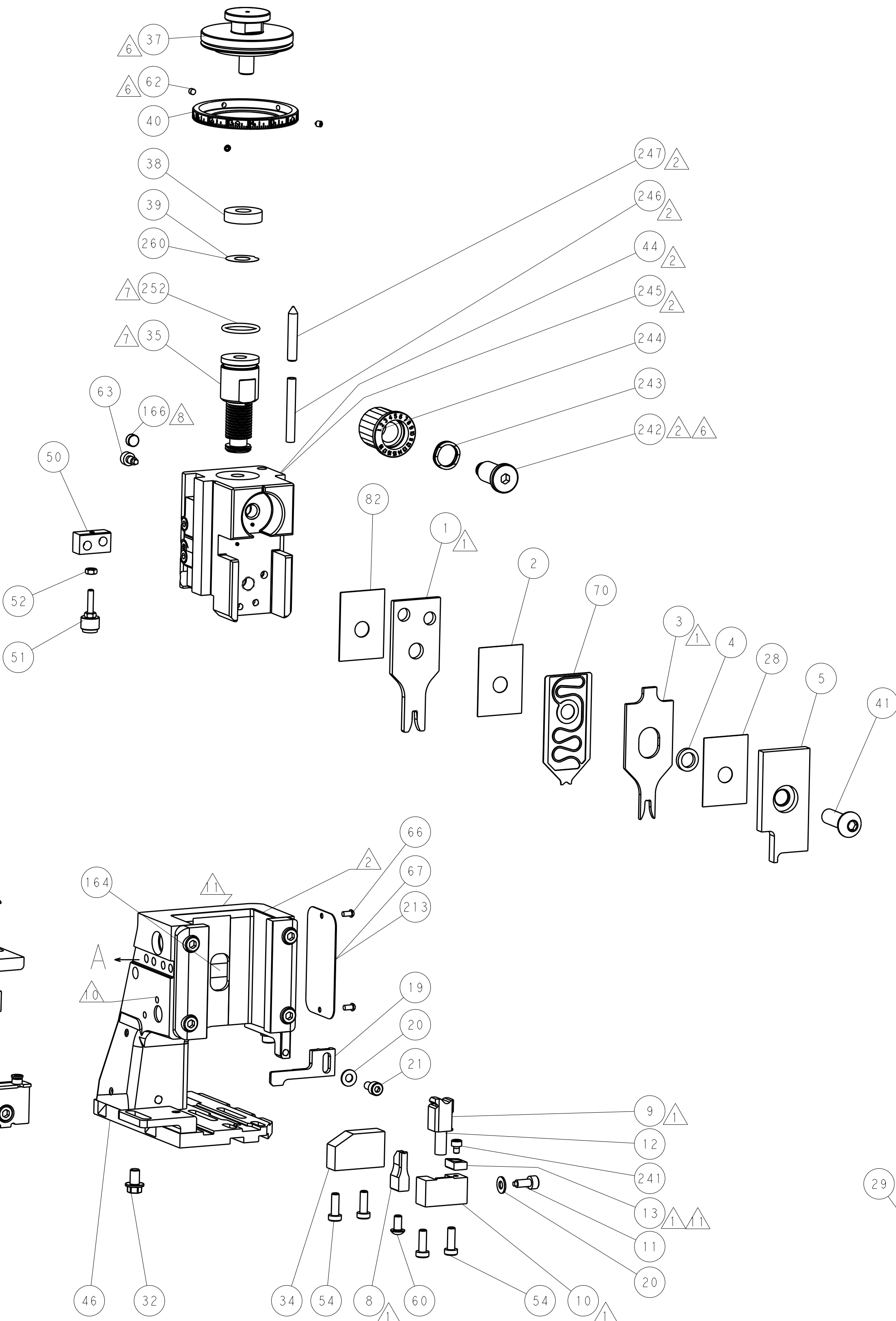
PNEUMATIC



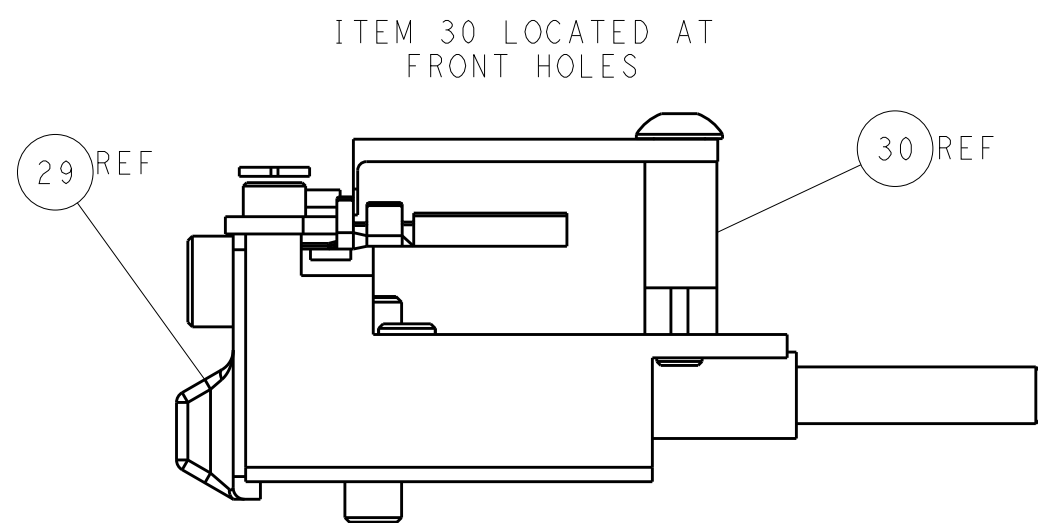
SERVO LATCH PLATE



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN J. HOU	24DEC2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG	24DEC2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J. GUO	24DEC2014	SIZE A1	
0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001		PRODUCT SPEC		CAGE CODE 00779	
FINISH		APPLICATION SPEC		DRAWING NO C=2266649	
MATERIAL		WEIGHT		RESTRICTED TO	
		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

2

1

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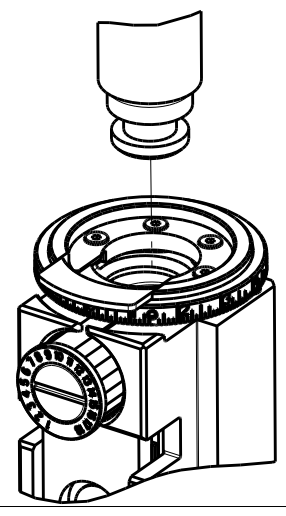
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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2266649-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

1338683-8

5-18022-5

2119641-2

2119799-1

2063440-1

SERVO LATCH PLATE

2119951-1

SMART APPLICATOR

2161326-1

MECHANICAL FEED

2119949-1

SERVO LATCH PLATE

2119951-1

SMART APPLICATOR

2161326-1

MECHANICAL FEED

2119949-1

PNEUMATIC FEED

2119950-1

2-2266649-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2-2266649-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2-2266649-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2266649-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.64 mm [.104]

F

INSUL

3.56 mm [.140]

F

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: GMG TERMINAL

GMG CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH

3.71-4.47 mm [.146-.176 IN]

INSULATION DIAMETER RANGE

Ø2.13-2.84 mm [.084-.112 IN]

TERMINAL APPLICATION SPECIFICATION

35157.52.08.6-35.58.52.08.6

-

Rev 01

-

-

TERMINALS APPLIED

TE TERMINAL

2113638-1

GMG TERMINAL

35157.52.08.6

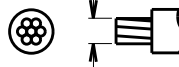
TE TERMINAL

2113645-1

GMG TERMINAL

35158.52.08.6

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



2.50mm2

1.68+/-0.05 [.066+/- .002]

4.4

1.50mm2

1.47+/-0.05 [.058+/- .002]

6.7

1.00mm2

1.38+/-0.05 [.054+/- .002]

7.5

0.50mm2

1.26+/-0.05 [.050+/- .002]

8.4

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: 8-2266649-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266649-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266649-5

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

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

1

1

1

2119791-5

DEPRESSOR, WIRE

70

-

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

811242-5

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

1-2119644-2

RAM WASHER, PRECISION

38

-

1

1

1

1

1752356-1

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

1-1320908-2

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

1-1803171-7

ANVIL, COMBINATION

8

-

-

-

-

-

-

-

7

-

-

-

-

-

-

-

6

-

1

1

1

1

1-2119757-0

DEPRESSOR, SHEAR

5

-

1

1

1

1

238011-8

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1-2119582-4

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

455888-2

SPACER, CRIMPER

2

-

1

1

1

1

8-1633664-1

CRIMPER, WIRE

1

-77

-27

-25

-22

-21

PART NO

DESCRIPTION

ITEM NO

THE FOLLOWING IS A SUMMARY OF THE INFORMATION CONTAINED IN THIS DRAWING. IT IS SUBJECT TO CHANGE AND DOES NOT CONSTITUTE A CONTRACT. THE ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

0 PLC

±.5

1 PLC

±0.5

2 PLC

±0.13

3 PLC

±0.013

4 PLC

±0.0001

ANGLES

±.1

FINISH

-

TO TOLERANCES UNLESS OTHERWISE SPECIFIED:

OWN

24DEC2014

CHK

24DEC2014

APVD

24DEC2014

PRODUCT SPEC

-

APPLICATION SPEC

-

WEIGHT

-

CAGE CODE

00779

DRAWING NO

©=2266649

RESTRICTED TO

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

3

OF

4

REV

A

TE Connectivity

Harrisburg, PA 17105-3608

Ocean Side Feed

Applicator

AMF 4805 REV 31MAR2000

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

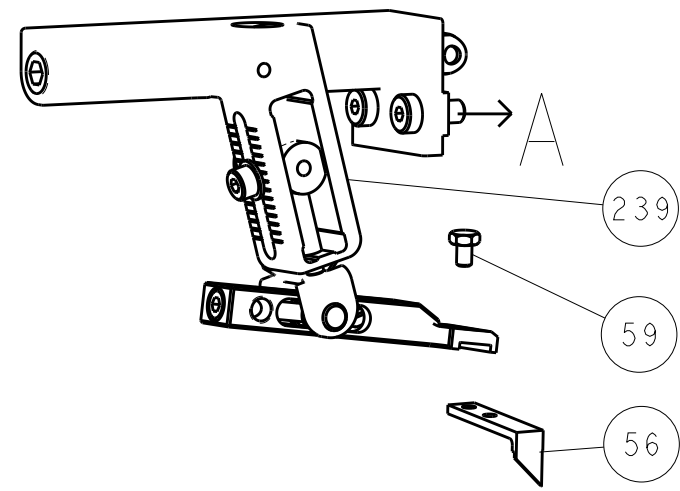
D

C

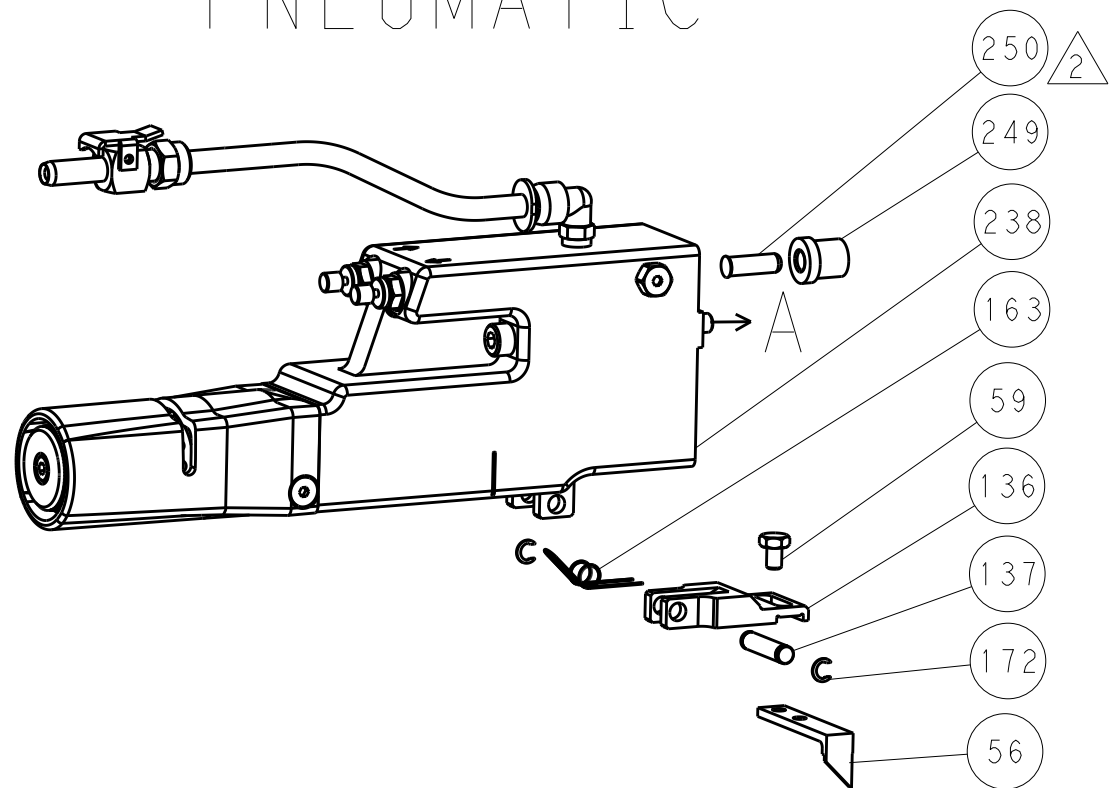
B

A

FEED TYPE MECHANICAL



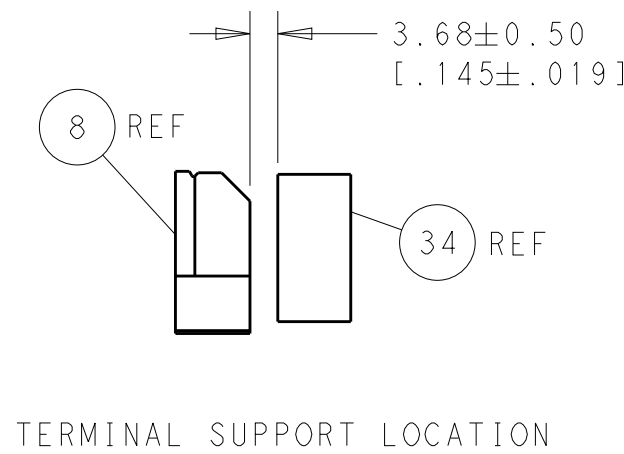
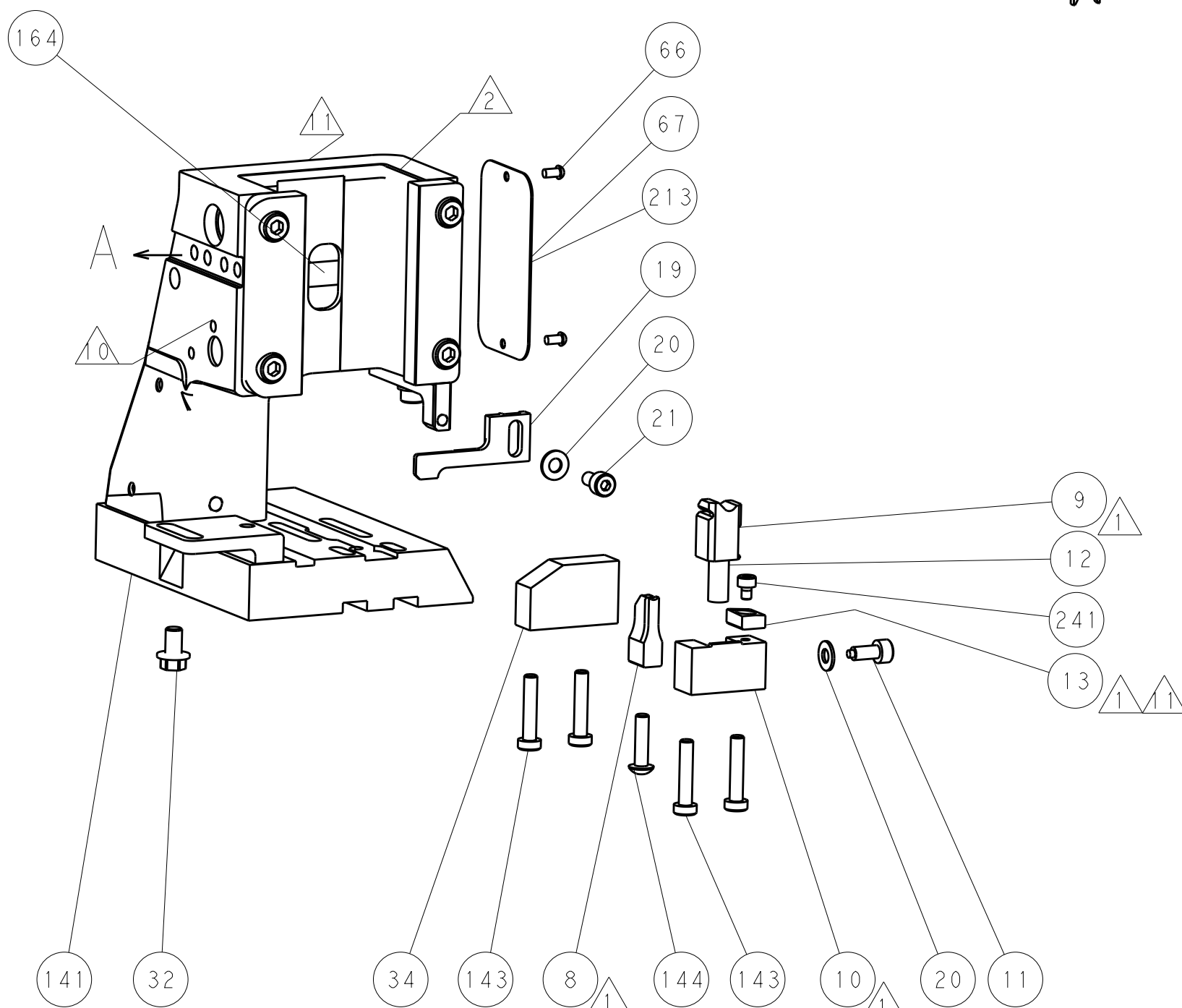
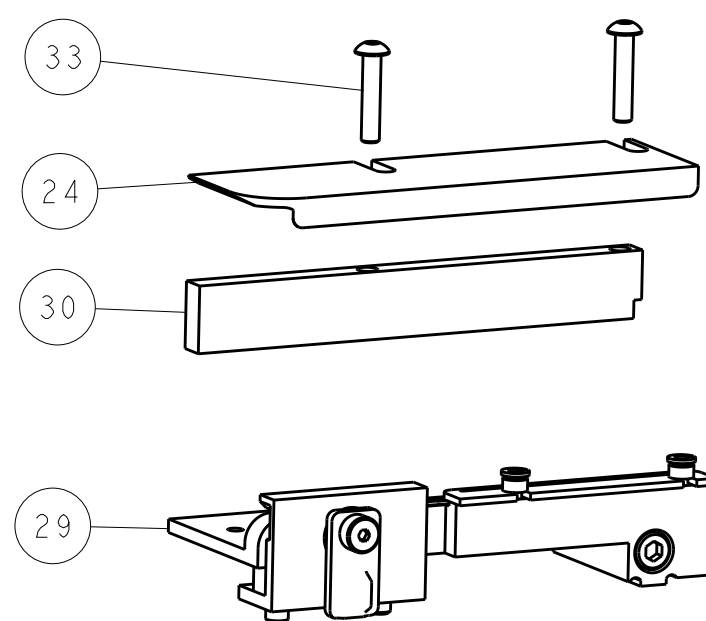
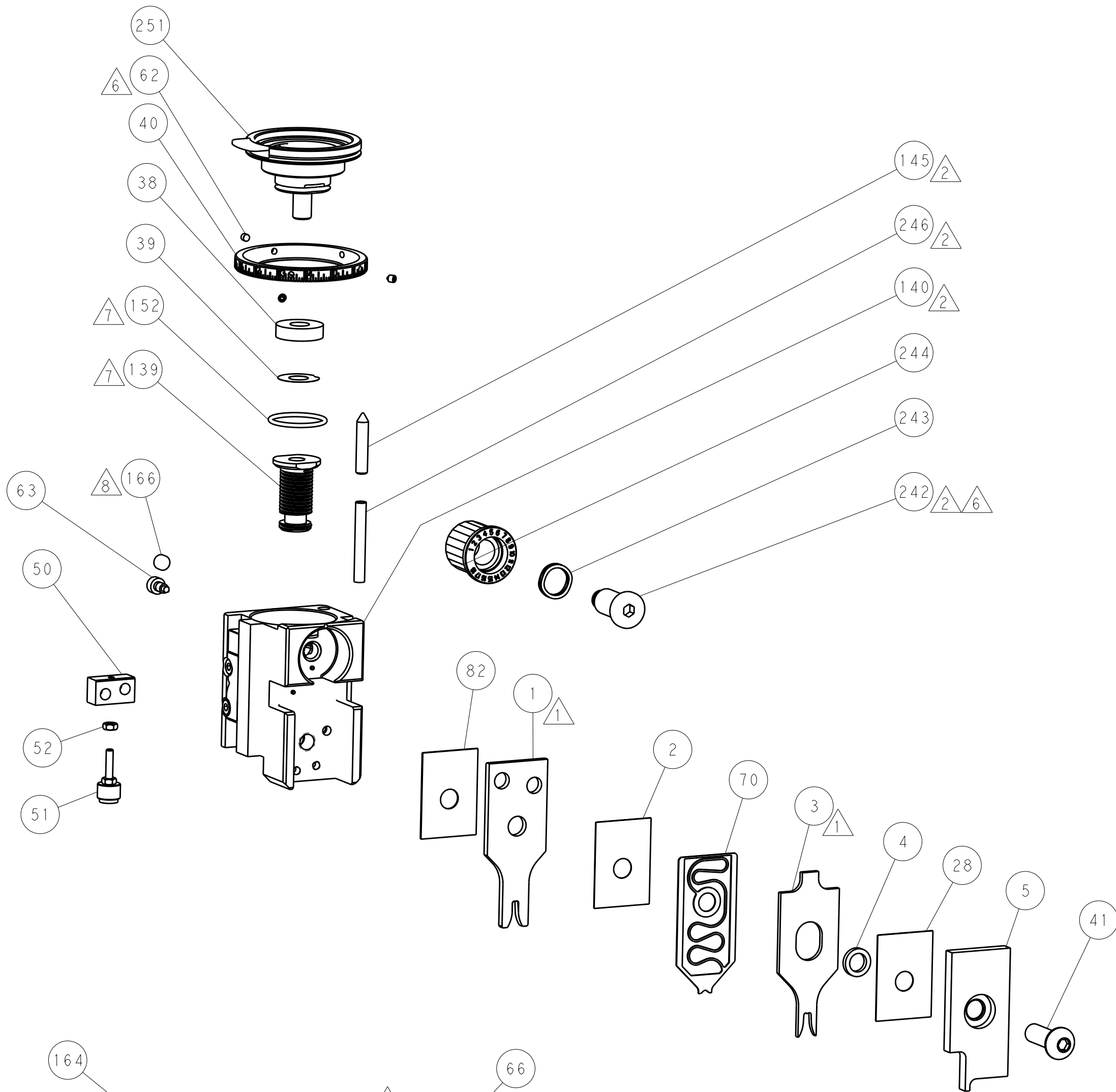
PNEUMATIC



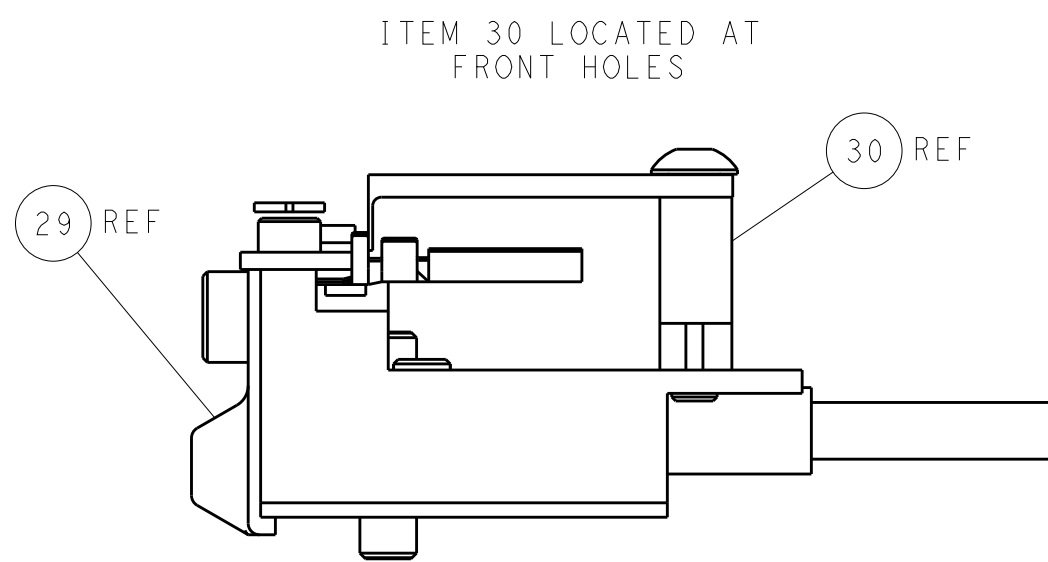
SERVO LATCH PLATE



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		24DEC2014		STE		TE Connectivity	
mm		0 PLC ±.5		CHK		24DEC2014		Harrisburg, PA 17105-3608			
1 PLC ±0.5		APVD		J. GUO		24DEC2014		NAME		Ocean Side Feed	
2 PLC ±0.13		PRODUCT SPEC								Applicator	
3 PLC ±0.013		APPLICATION SPEC									
4 PLC ±0.0001		WEIGHT									
ANGLES		FINISH									
MATERIAL		Customer Accessible Production Drawing									
		SCALE									
		1:2									
		SHEET									
		4									
		OF									
		4									
		REV									
		A									