



- 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: 8-2266131-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266131-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266131-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266131-6
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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS
- 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 3.15.

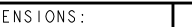
6		5			4		3	
FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
	CONVERT TO	PART NUMBERS REQUIRED						
MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
	SERVO LATCH PLATE	2119951-1	-	8-2266131-5	1901094-3	1-1752354-7	2168400-6 (QUANTITY 2)	
	SMART APPLICATOR	2161326-1	-	8-2266131-4	-	-	-	
PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
	SERVO LATCH PLATE	2119951-1	-	8-2266131-5	1901094-3	1-1752354-7	2168400-6 (QUANTITY 2)	
	SMART APPLICATOR	2161326-1	-	8-2266131-4	-	-	-	
SERVO LATCH PLATE 	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 	-	-	-	-	-	-	-	
	-	-	-	-	-	-	-	
NONE	-	-	-	-	-	-	-	
-	-	-	-	-	-	-	-	

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*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.
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							TEC Standard Metric Part Template		
-	-	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	
-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)

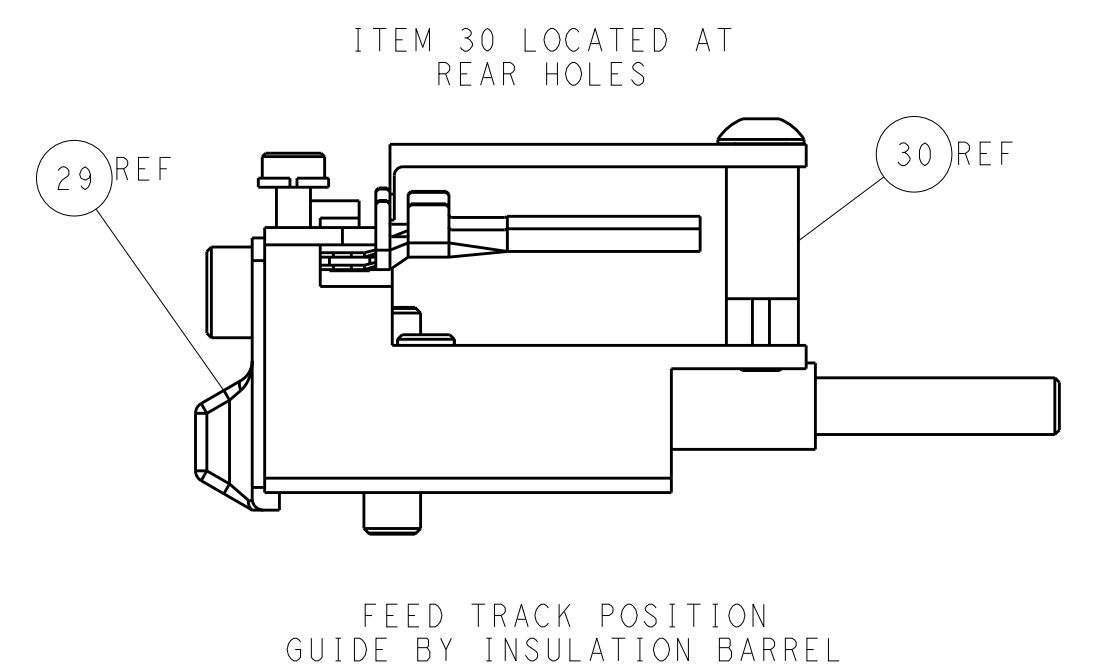
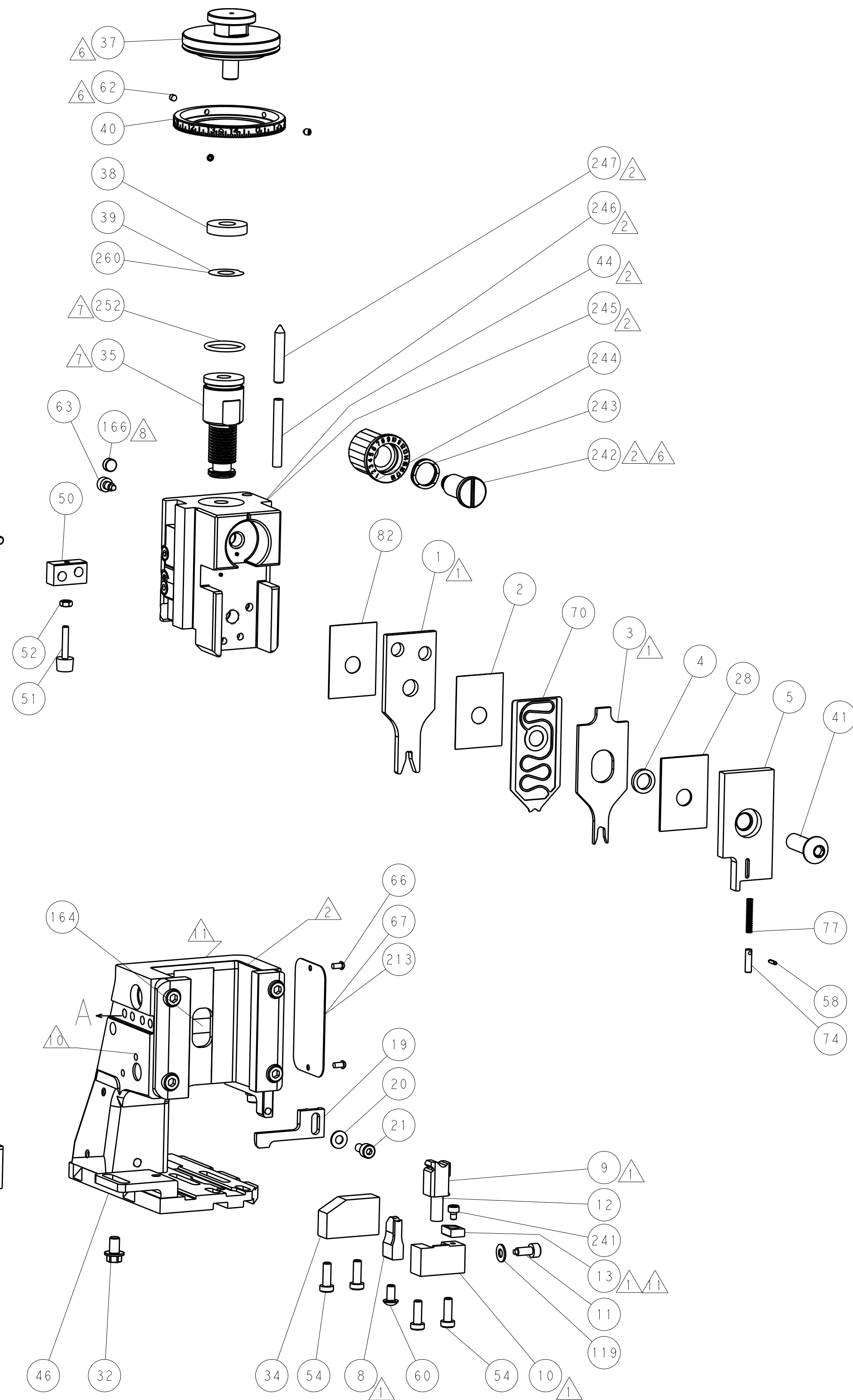
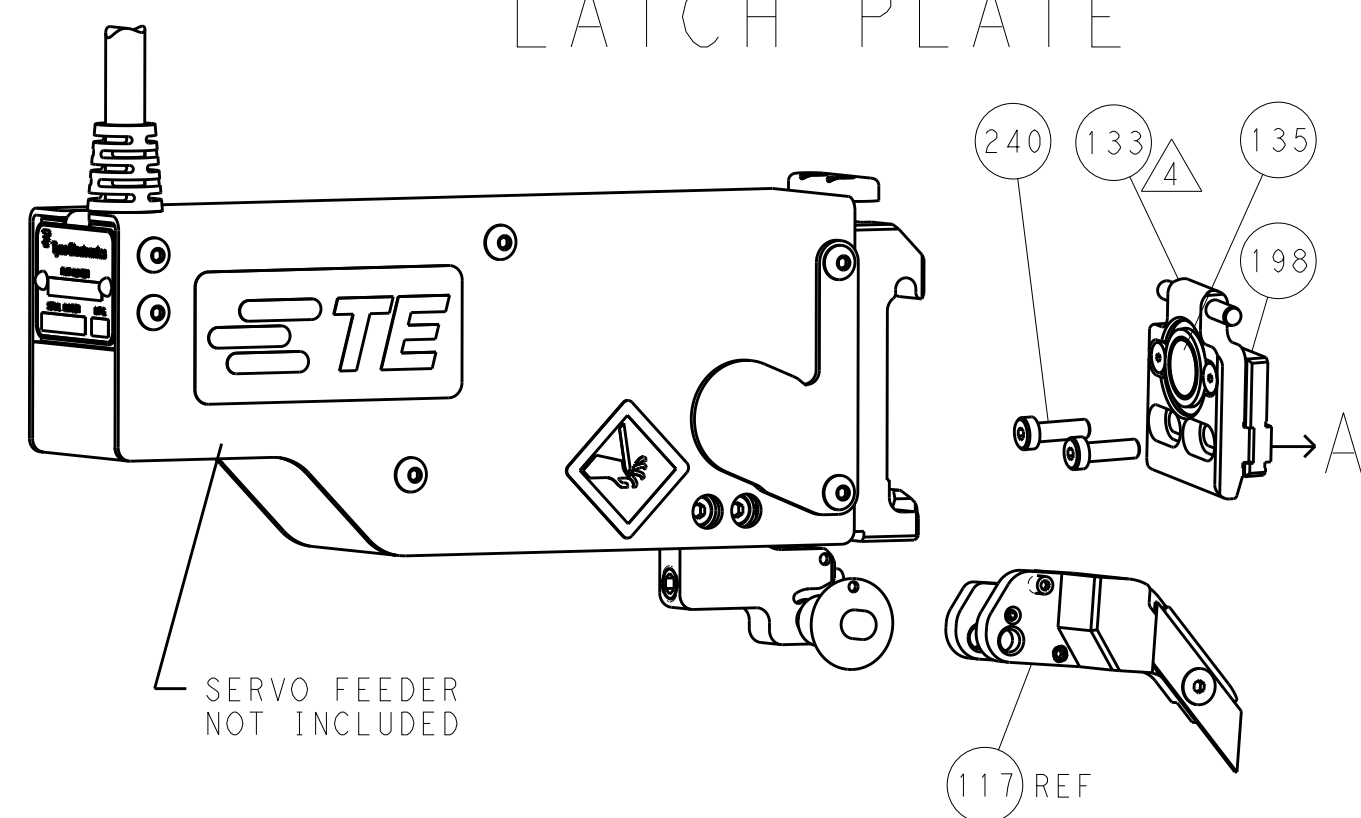
SET UP GAUGE 2119599-1				LOC A	DIST 66	REVISIONS				
P		LTR		DESCRIPTION			DATE	DWN	APVD	
		A		RELEASED			26DEC2013	KS	TE	
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION			246	
1	-	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.			245	
1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT			244	
1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243	
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	
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	455888-4	SPACER, CRIMPER			82	
1	1	1	1	1	22878-8	SPRING, COMPRESSION			77	
1	1	1	1	1	854769-4	HOLDER, INS			74	
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	
-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0			62	
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	
1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250			58	
-	-	1	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0			53	
1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3			52	
1	1	1	1	1	811242-5	BUMPER, HOLD DOWN			51	
1	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	-	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	2119644-3	RAM WASHER, PRECISION			38	
1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE			37	
-	1	1	1	1	2119092-1	BOLT, ADJUSTMENT			35	
1	1	1	1	1	1752356-1	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	1320908-7	SPACER, STRIP GUIDE			30	
1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE			29	
1	1	1	1	1	1-455888-0	SPACER, CRIMPER			28	
1	1	1	1	1	1320928-6	STRIP GUIDE			24	
1	1	1	1	1	168083-2	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	2119533-1	STRIPPER, SIDE FEED			19	
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	2119805-1	SHEAR HOLDER, FRONT			10	
1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT			9	
1	1	1	1	1	3-1803054-8	ANVIL, COMBINATION			8	
-	-	-	-	-	-	-			7	
-	-	-	-	-	-	-			6	
1	1	1	1	1	1-2119780-2	DEPRESSOR, SHEAR			5	
1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER			4	
1	1	1	1	1	1-1633964-4	CRIMPER, INSULATION OVERLAP PREMIUM			3	
1	1	1	1	1	455888-1	SPACER, CRIMPER			2	
1	1	1	1	1	2-1633860-8	CRIMPER, WIRE			1	
-6	-5	-2	-1		PART NO	DESCRIPTION			ITEM NO	

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC $\pm .1$ 1 PLC ± 0.5 2 PLC ± 0.13 3 PLC ± 0.013 4 PLC ± 0.0001 ANGLES $\pm$ FINISH		DWG 290C12013 CHK STAKEM 290C12013 APP'D T. BAILEY 290C12013 PRODUCT SPEC - APPLICATION SPEC - WEIGHT - Customer Accessible Production Drawing		 TE Connectivity Harrisburg, PA 17105-3608	
				NAME Ocean Side Feed Applicator		SIZE CAGE CODE DRAWING NO A 1 00779 C=2266131	
MATERIAL -		RESTRICTED TO -		SCALE 1:2		SHEET 1 OF 4 REV A	

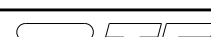
PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS



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 ETCO-ENTERPRISES CORPORATION IT IS SUBJECT TO THE ETCO-ENTERPRISES CORPORATION'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN K STAKEM CHK G BAILEY	290C2013 290C2013 290C2013	 ETC Connectivity Harrisburg, PA 17105-3608	NAME Ocean Side Feed Applicator	SIZE A 00779	CASE CODE C=2266131	DRAWING NO -	RESTRICTED TO -
DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 4 PLC ±0.013 ANGLES ±0.0001	JWD T. FIRBIN PRODUCT SPEC - APPLICATION SPEC -							
	MATERIAL -	FINISH -	WEIGHT -						
Customer Accessible Production Drawing									

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

D

C

B

A

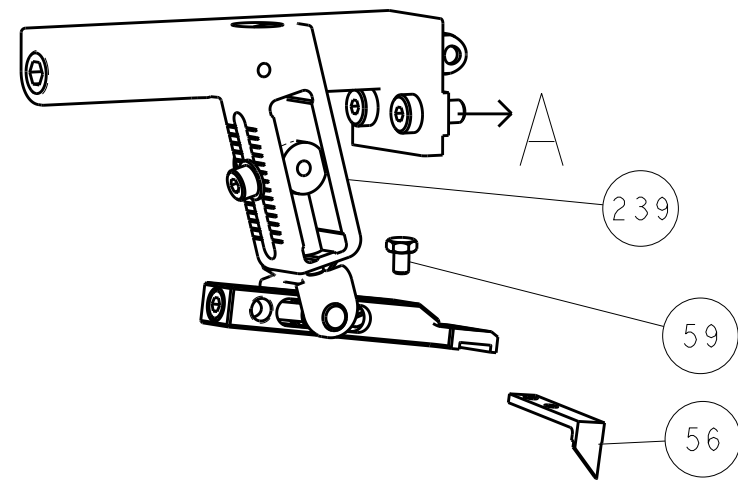
D

C

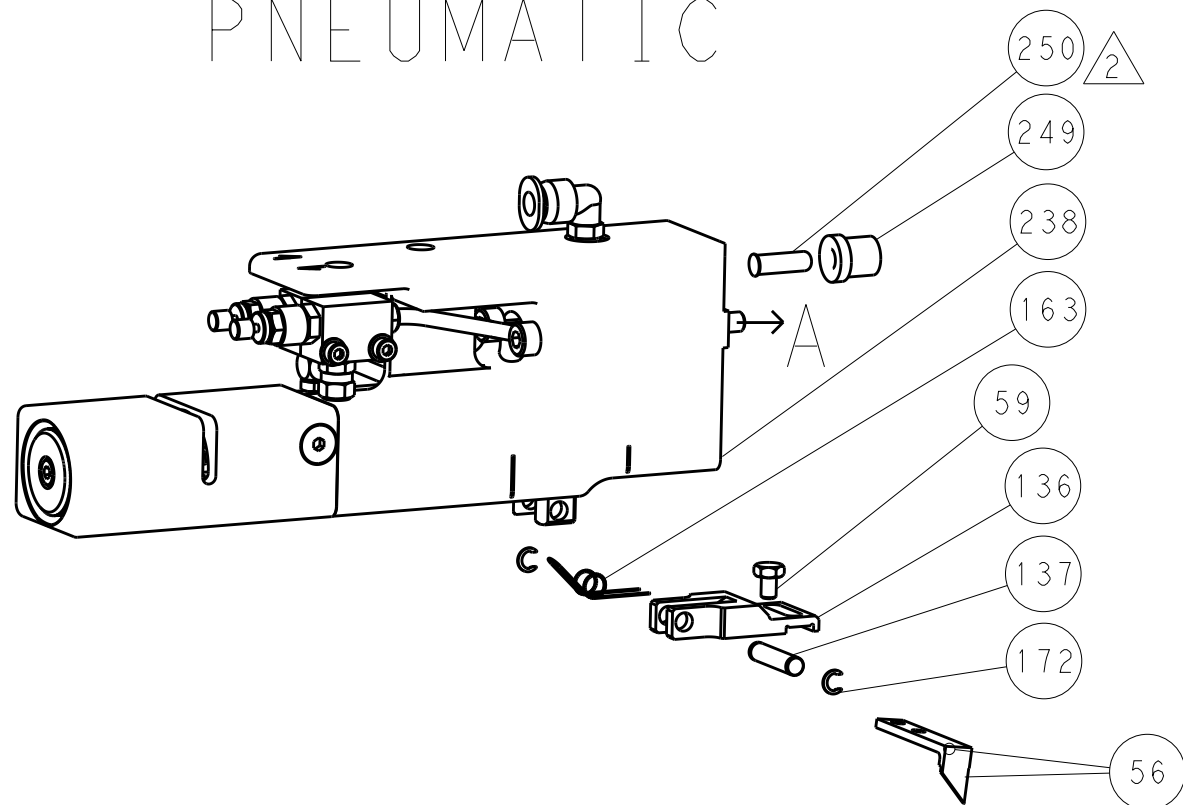
B

A

FEED TYPE MECHANICAL



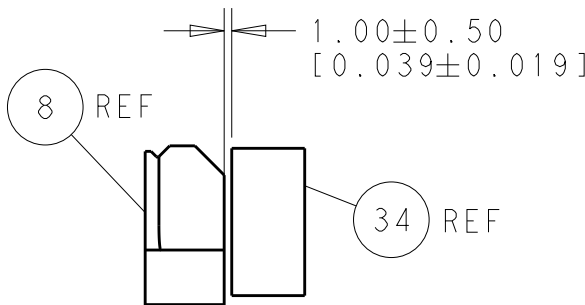
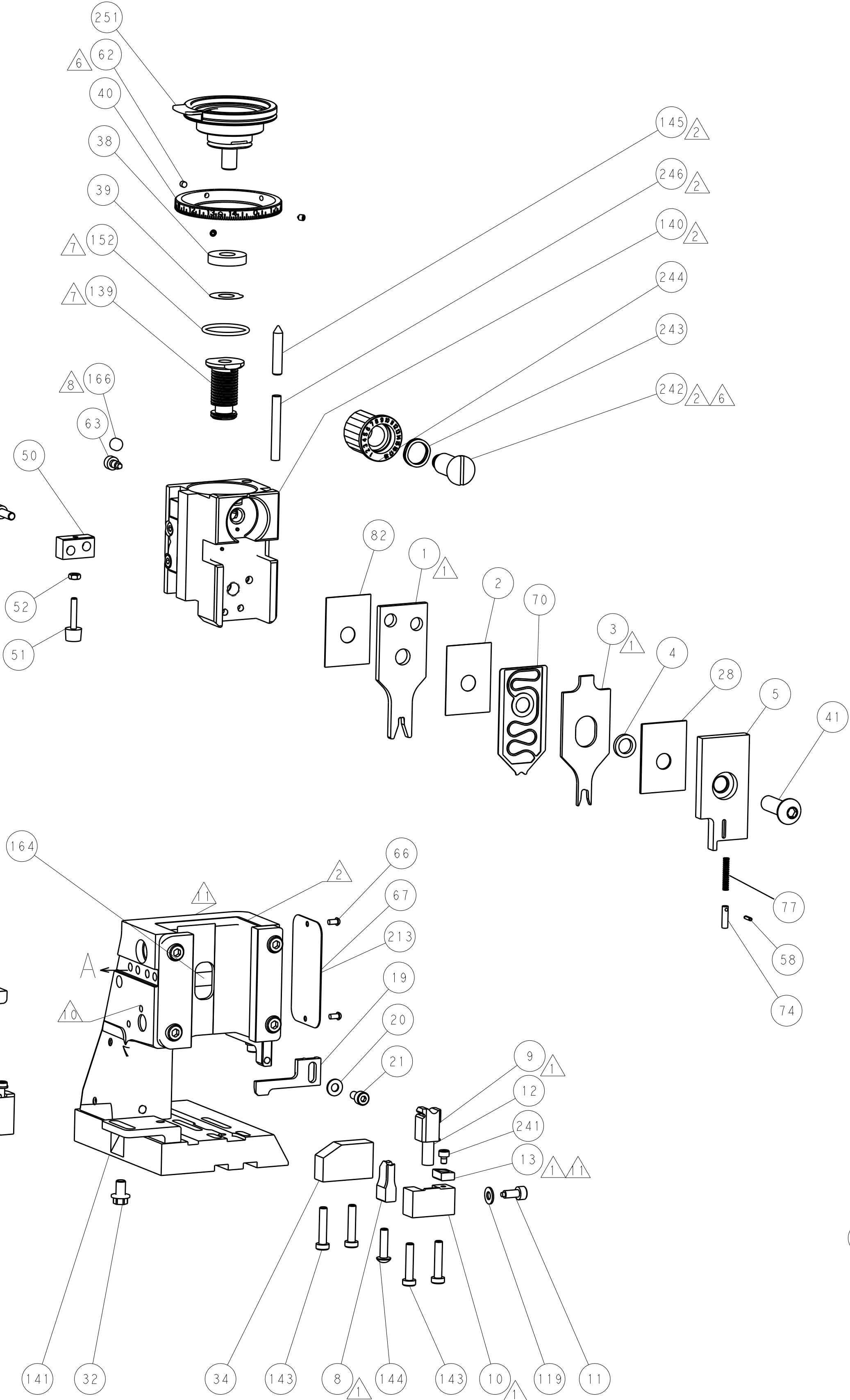
PNEUMATIC



SERVO LATCH PLATE

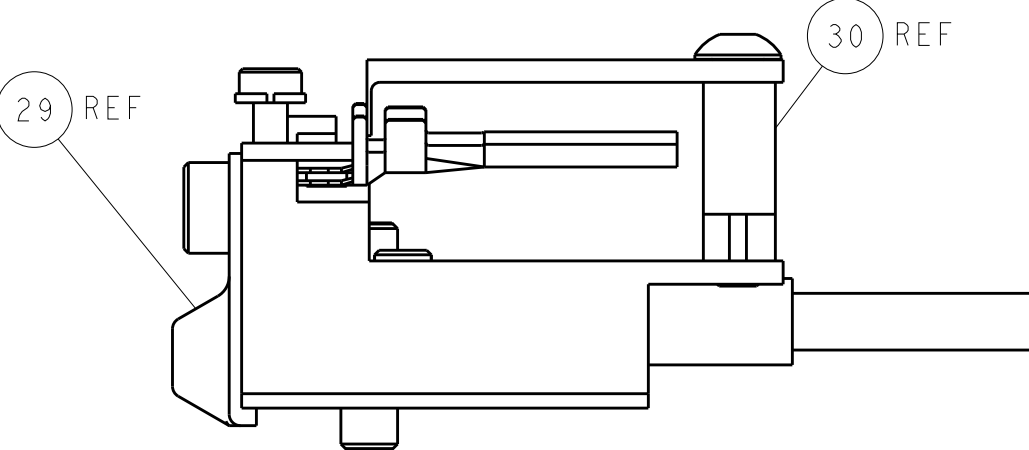


CAM POSITIONS



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT
REAR HOLES



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: R. STANEM 29OCT2013		CHK: G. BAILEY 29OCT2013		APVD: T. ELBIN 29OCT2013		NAME: Ocean Side Feed Applicator	
mm		0 PLC ±0.5		1 PLC ±0.5		2 PLC ±0.13		3 PLC ±0.013		4 PLC ±0.001	
MATERIAL		FINISH		WEIGHT		SIZE: A1		CAGE CODE: 00779		DRAWING NO: C=2266131	
						Customer Accessible Production Drawing		SCALE: 1:2		SHEET: 4 of 4	
										REV: A	