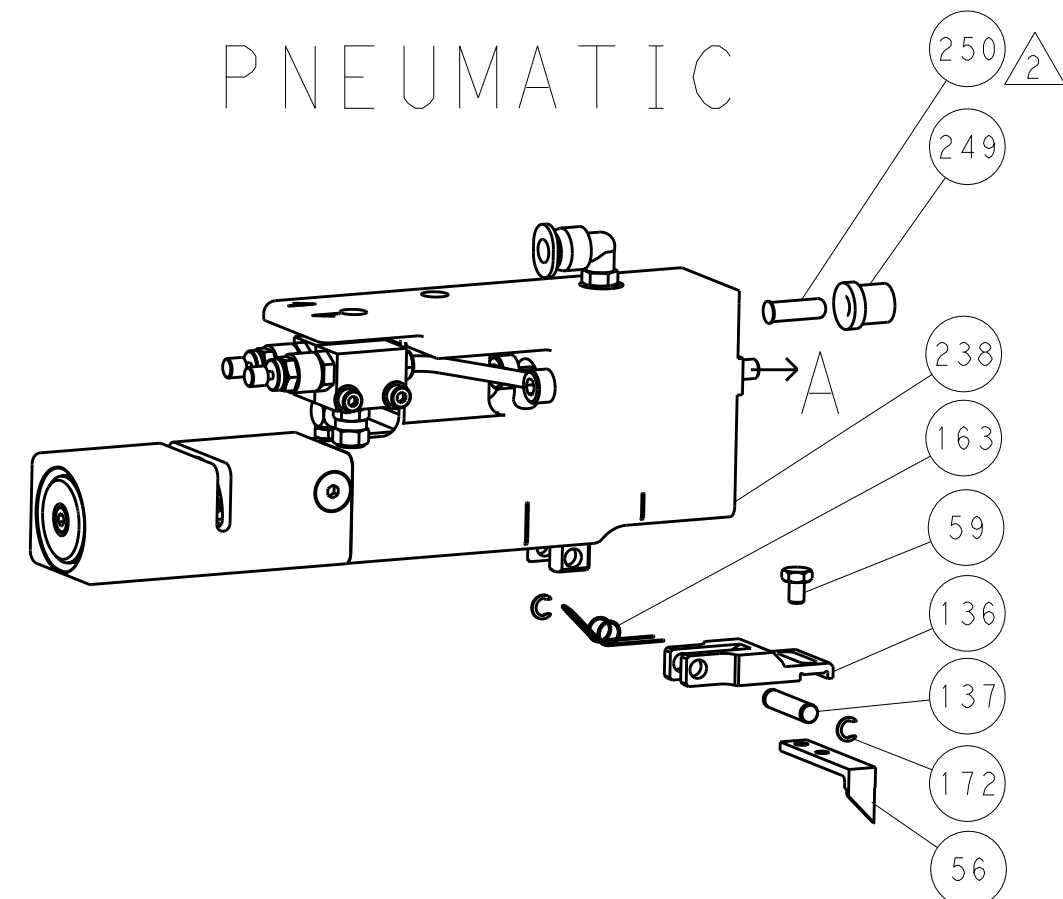
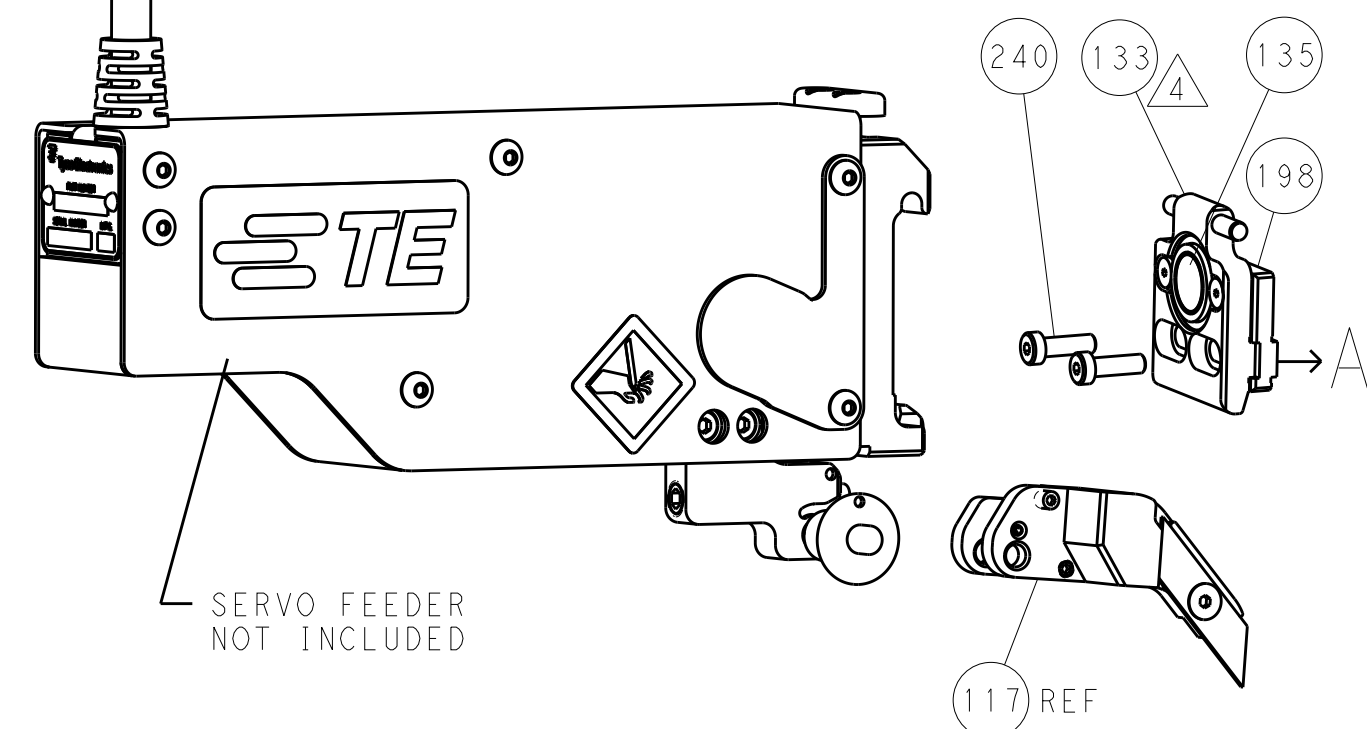
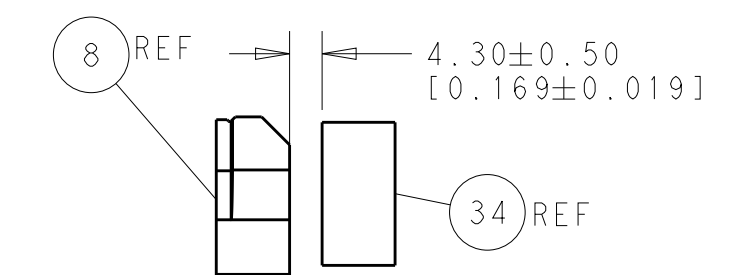
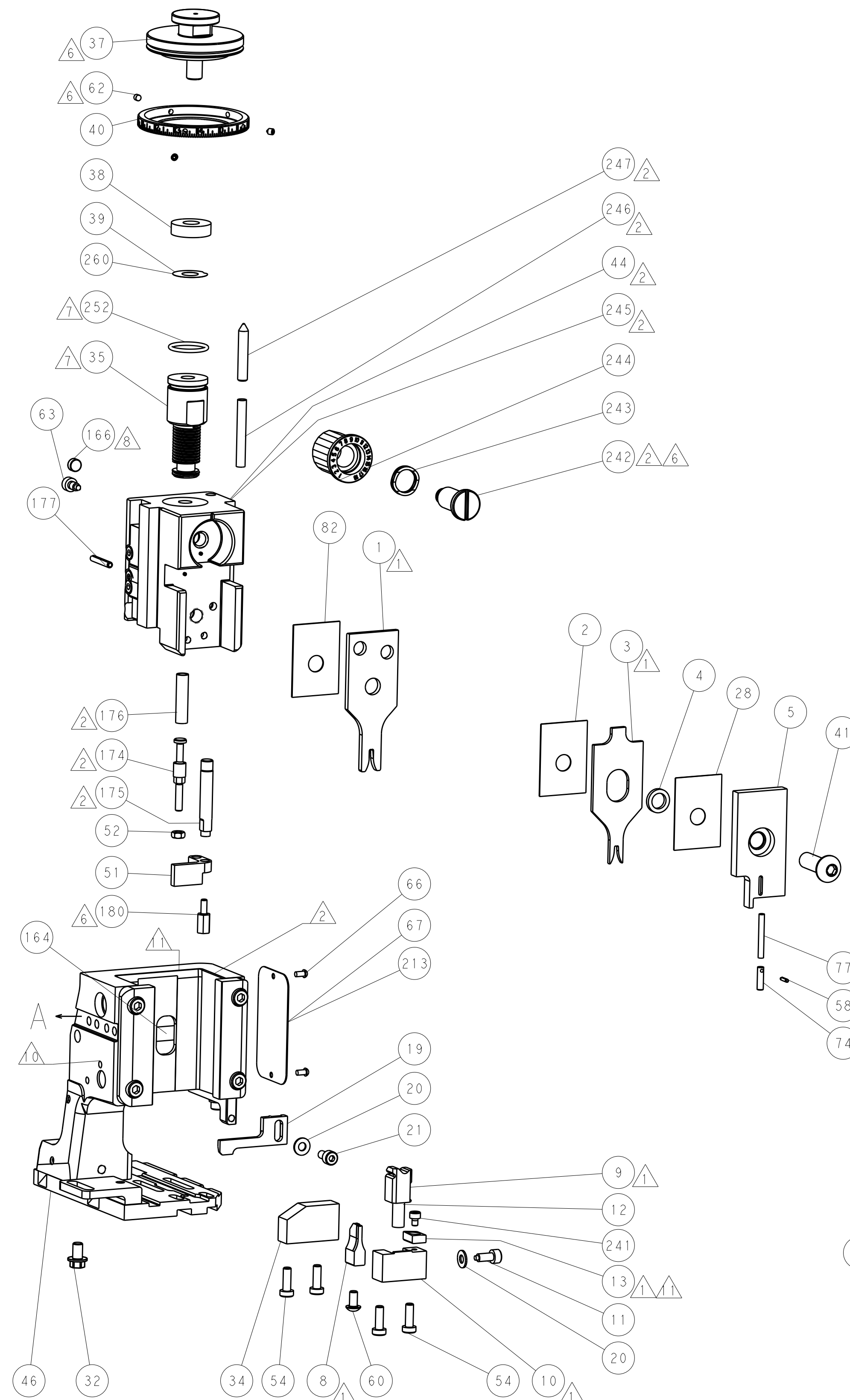
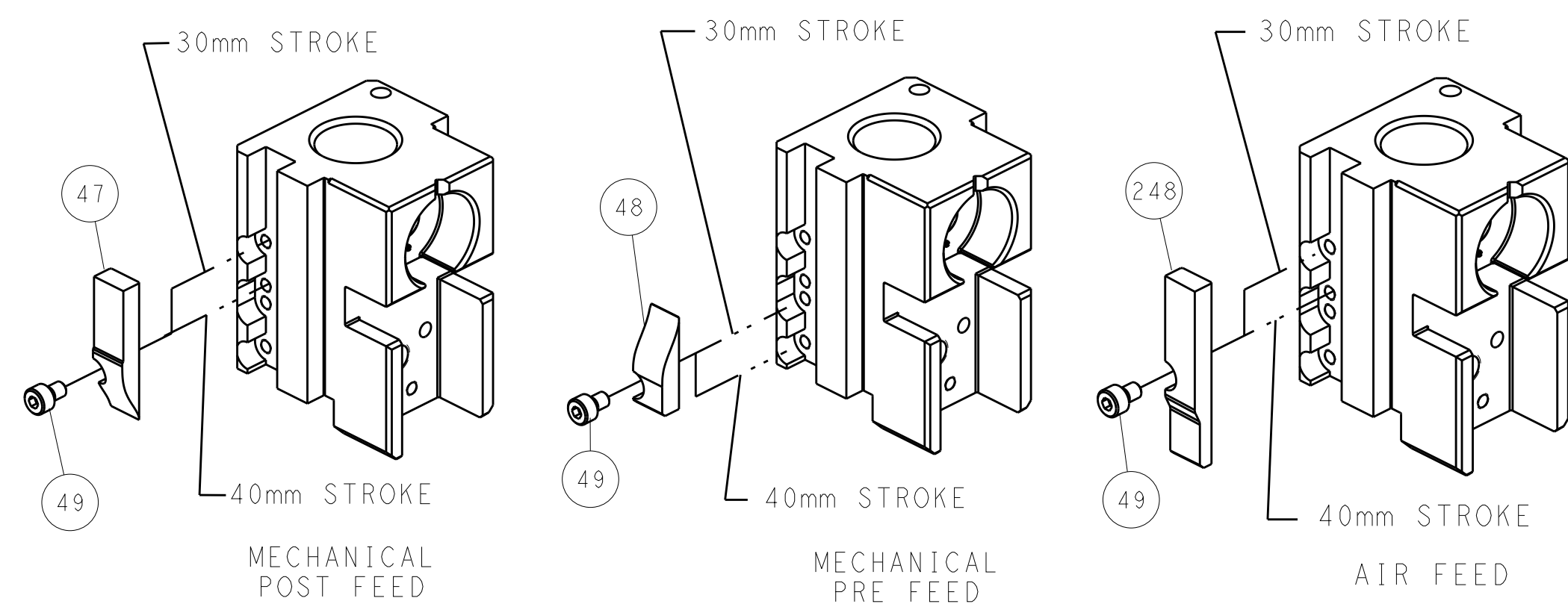


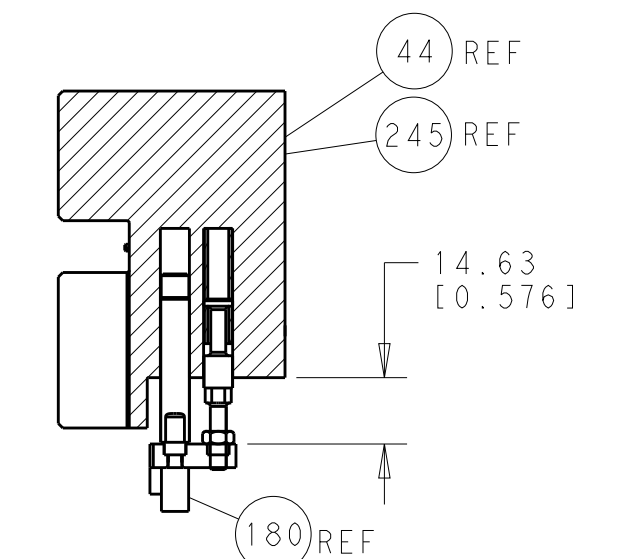
PNEUMATIC

SERVO
LATCH PLATE

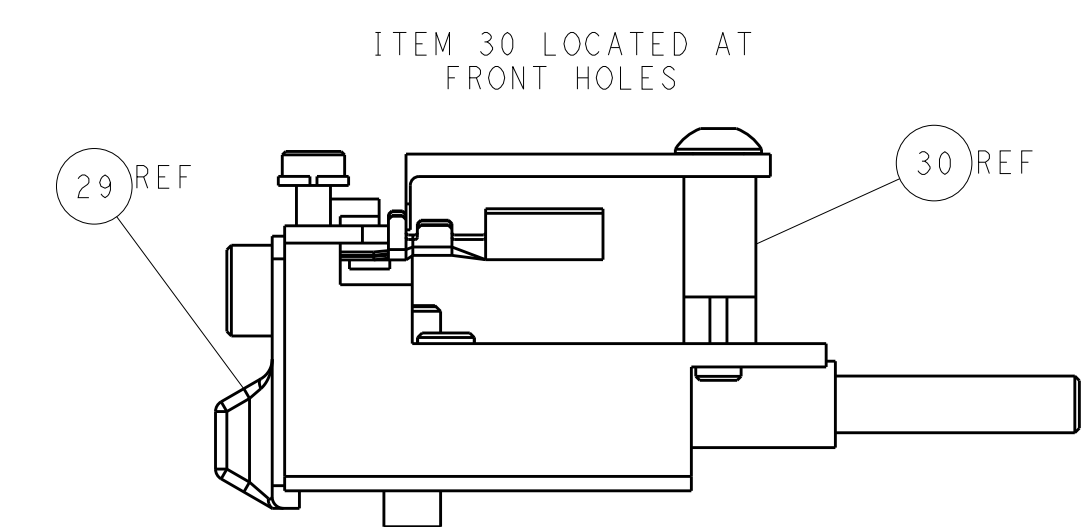
CAM POSITIONS



TERMINAL SUPPORT LOCATION



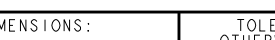
HOLDDOWN SET-UP

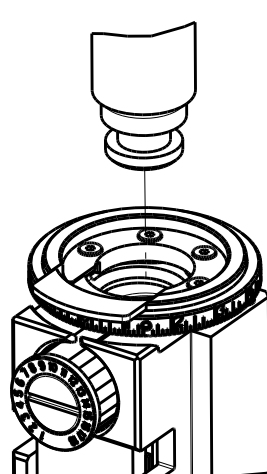


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLS AND ENGINEERING ORGANIZATION SHOULD BE NOTIFIED FOR THE LATEST REVISIONS		DWN WEAVER 12MAR2014 CHK ELBIN 12MAR2014 APVD ELBIN 12MAR2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A 1	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C=2266336		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV A	

8		7		6		5		4		3	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20							
(C) COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.									
	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266336-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266336-5	1901094-3	2-1752354-3	2168400-6 (QUANTITY 2)
	2-2266336-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SMART APPLICATOR	2161326-1	-	8-2266336-4	-	-	-
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
	2-2266336-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	-	8-2266336-5	1901094-3	2-1752354-3	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266336-4	-	-	-
	2-2266336-7	A	FINE CRIMP HEIGHT ADJUST	NONE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
7-2266336-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.29 mm [.090]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: PHOENIX TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MSTBC-MT 0.5-1.0 BA			
WIRE STRIP LENGTH 3.50-3.80 mm [.138-.150 IN]		INSULATION DIAMETER RANGE Ø1.40-2.31 mm [.055-.091 IN]	
TERMINAL APPLICATION 		NONE - -	
SPECIFICATION -		- -	
TERMINALS APPLIED			
TE TERMINAL 1572806-1	PHOENIX TERMINAL 3190645	TE TERMINAL	PHOENIX TERMINAL

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2			1.33+/- 0.05 [.052+/- .002]		4.6
0.75mm2			1.23+/- 0.05 [.048+/- .002]		5.8
0.50mm2			1.13+/- 0.05 [.044+/- .002]		6.8



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: 8-2266336-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266336-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266336-5
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 AND 180.
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.
12. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING

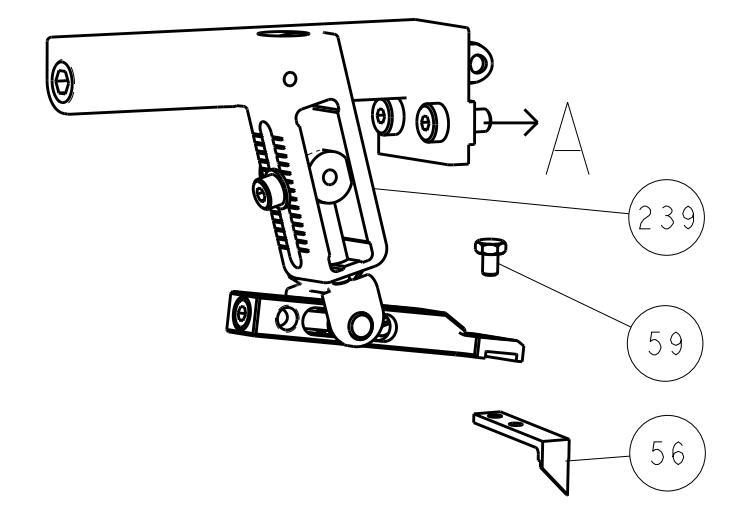
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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

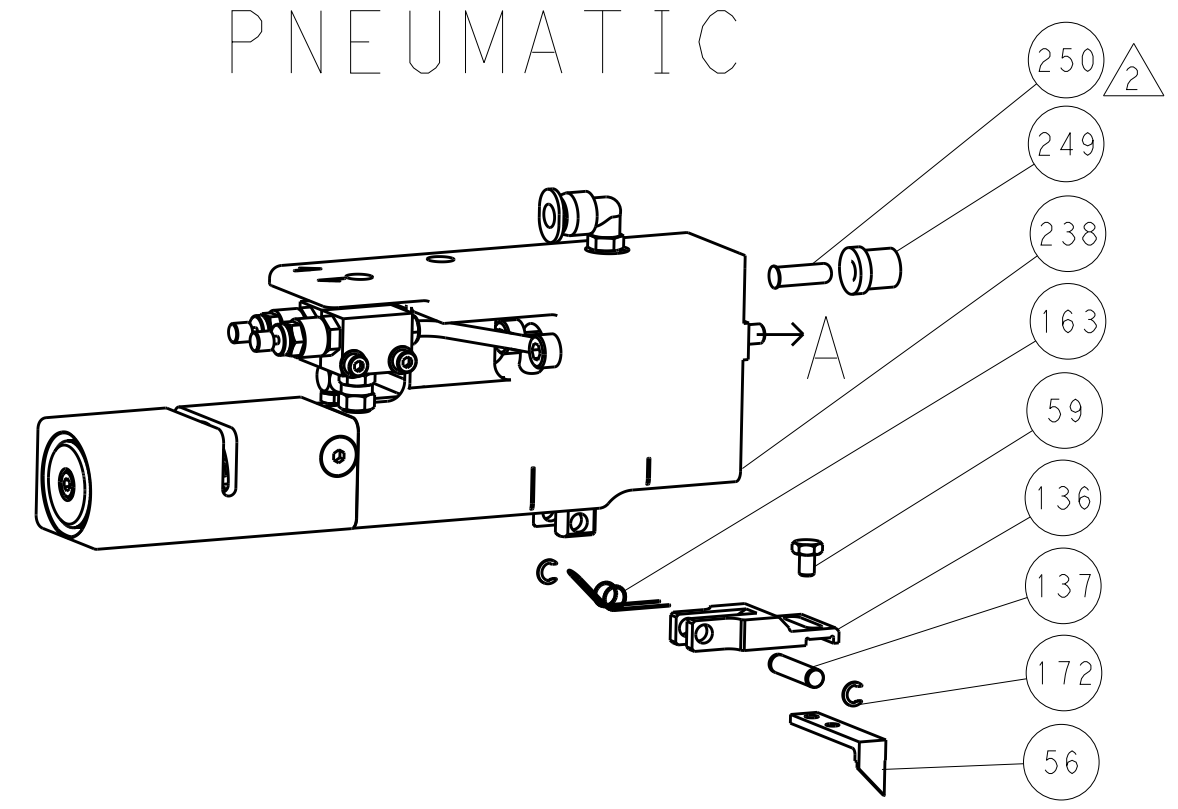
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS											
P	LTR	DESCRIPTION			DATE	OWN	APVD								
	-	SEE SHEET 1			-	-	-								
6	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243							
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242							
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241							
	-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240							
	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239							
6	-	-	-	1	-	2063440-1	AIR FEED MODULE	238							
	-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213							
	-	-	1	-	-	1901094-3	SPACER, FEEDER	198							
	-	1	1	1	1	2-1752354-3	STANDOFF, HOLD-DOWN	180							
	-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177							
6	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176							
	-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175							
	-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174							
	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172							
	-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166							
6	-	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							
6	-	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	2-2119656-2	APPLICATOR BASIC ASSEMBLY, SF	141							
	-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140							
6	-	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							
6	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117							
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82							
	-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77							
	-	1	1	1	1	854769-4	HOLDER, INS	74							
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71							
6	-	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							
6	-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58							
	-	-	-	1	1	1338685-1	PAWL, FEED	56							
	-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52							
	-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51							
	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49							
6	-	-	-	-	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	2119644-1	RAM WASHER, PRECISION	38							
6	-	1	1	1	1	3-1752356-3	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	1-1320908-0	SPACER, STRIP GUIDE	30							
	-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29							
6	-	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							
6	-	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							
6	1	1	1	1	1	2-1633920-0	ANVIL, COMBINATION	8							
	-	-	-	-	-	-	-	7							
	-	-	-	-	-	-	-	6							
	-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5							
	-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4							
6	1	1	1	1	1	1-2119582-1	CRIMPER, INSULATION F PREMIUM	3							
	-	1	1	1	1	455888-4	SPACER, CRIMPER	2							
	1	1	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1							
	-77	-27	-25	-22	-21	PART NO		DESCRIPTION	ITEM NO						
	DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN B. WEAVER 12MAR2014 CHK T. ELBIN 12MAR2014 APVD T. ELBIN 12MAR2014		NAME		TE Connectivity Harrisburg, PA 17105-3608						
mm		0 PLC ±.5 1 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES .01		PRODUCT SPEC		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO			
MATERIAL		FINISH		WEIGHT		A		00779		2266336		-			
				Customer Accessible		Production Drawing		SCALE		1:2		SHEET 3 OF 4		REV A	

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

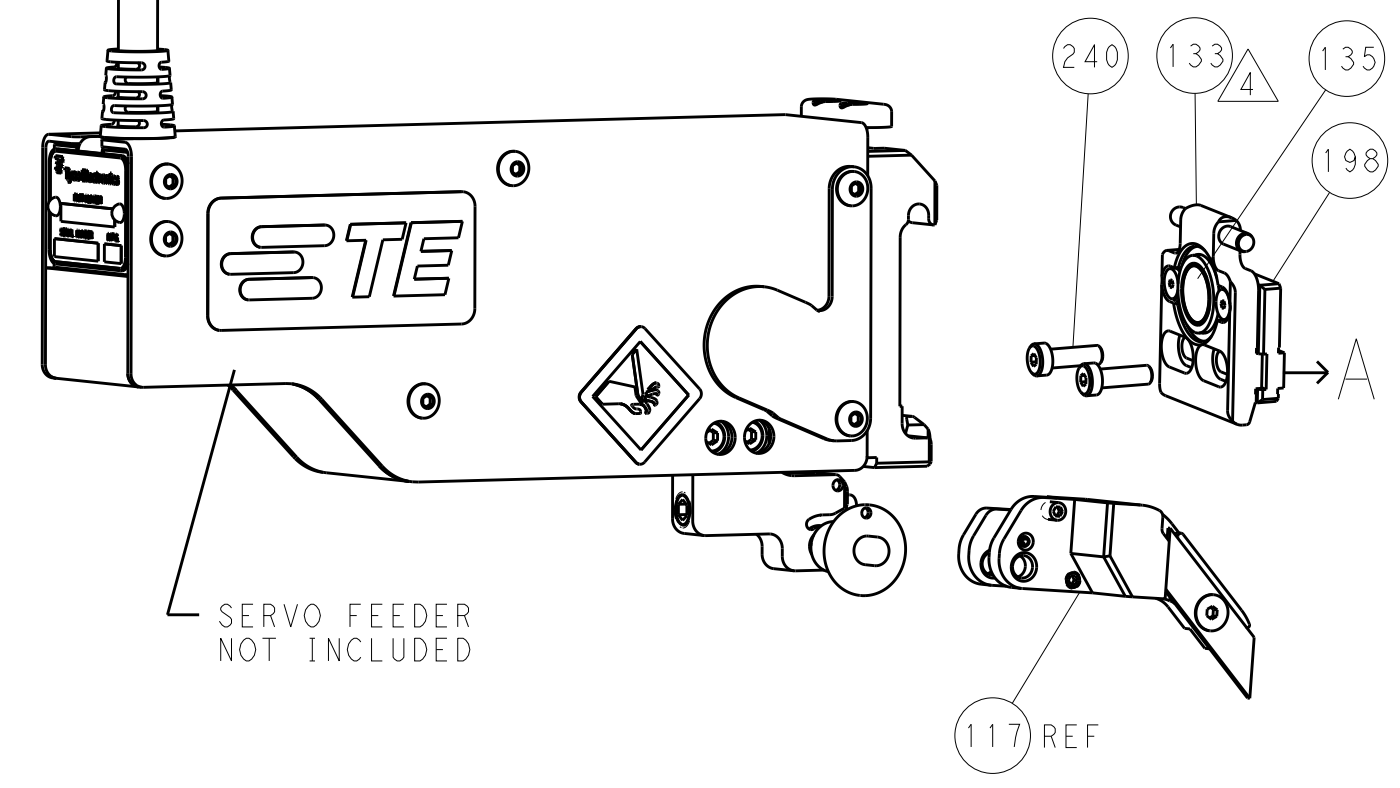
FEED TYPE MECHANICAL



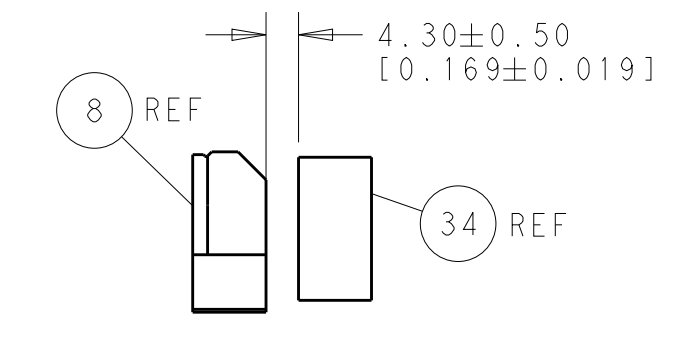
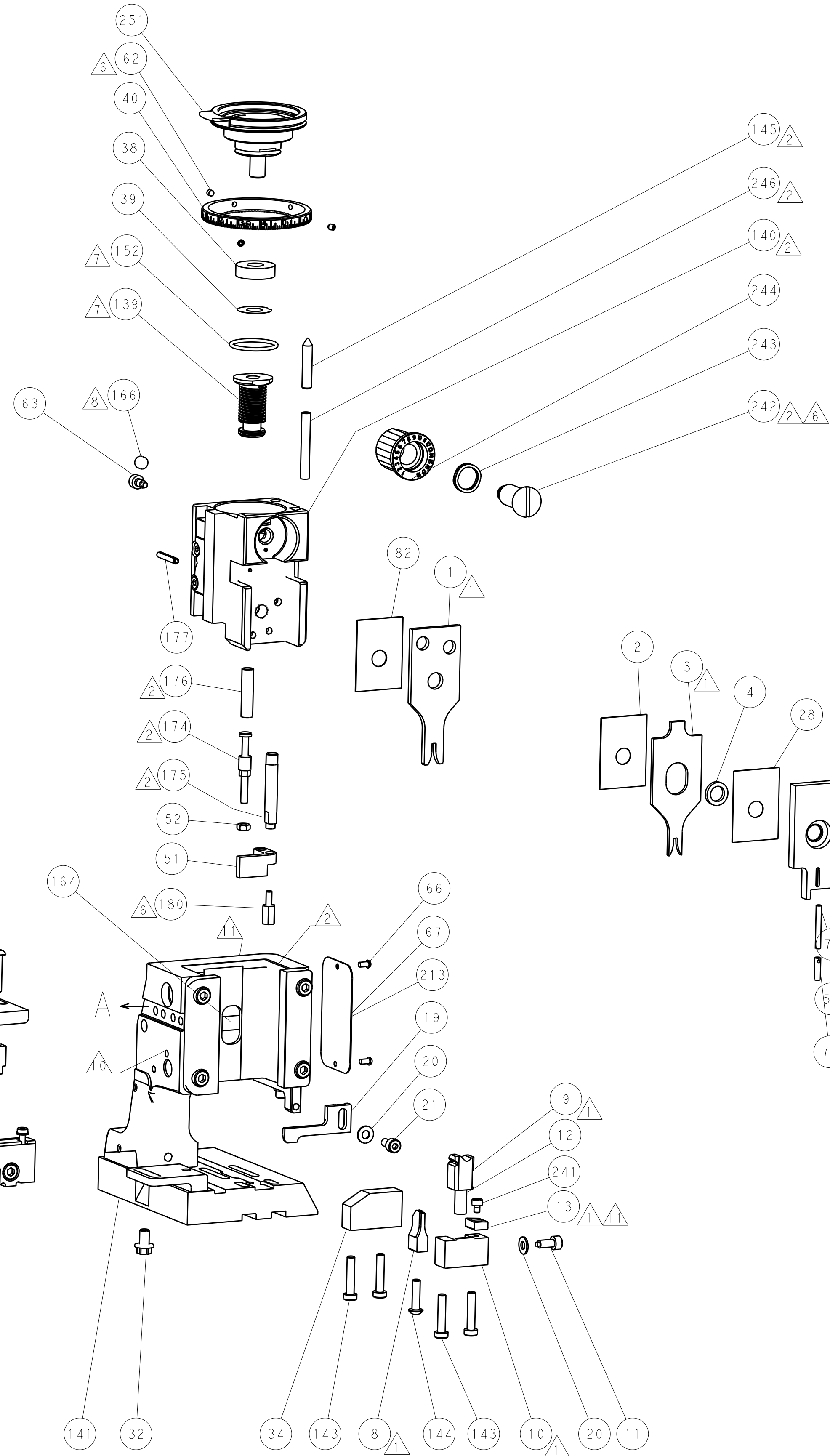
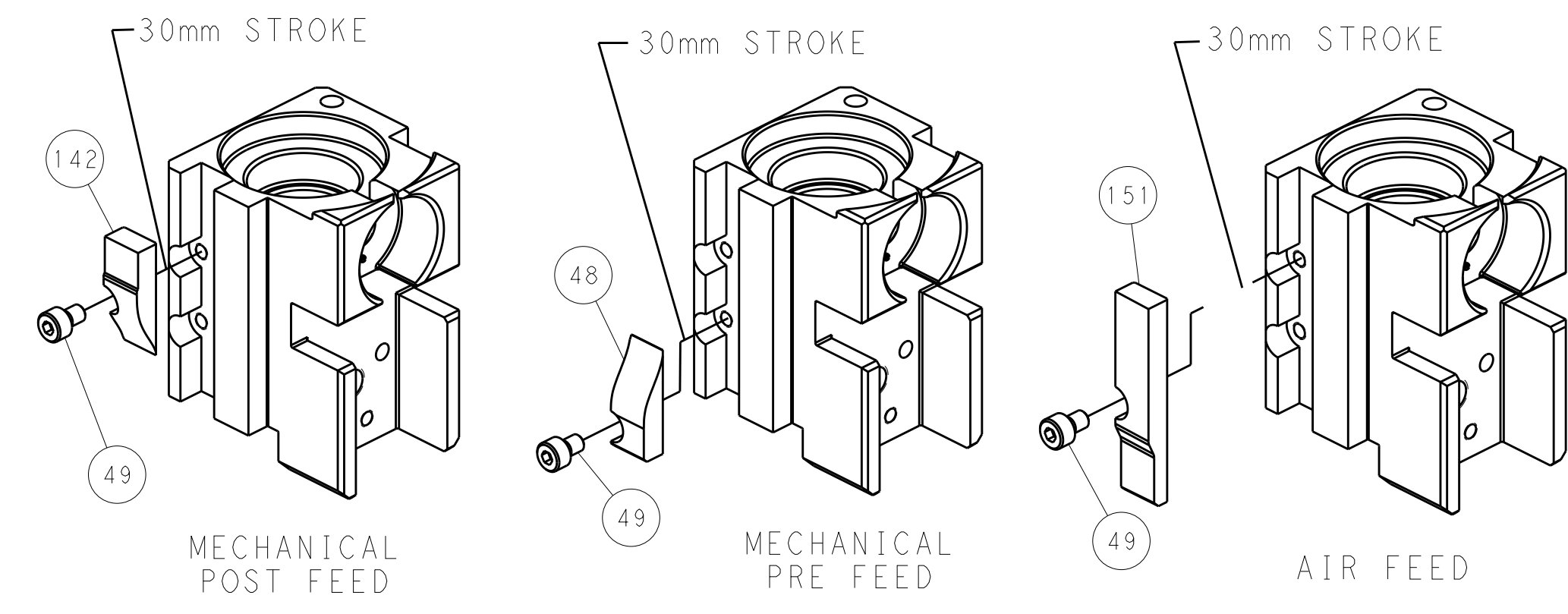
PNEUMATIC



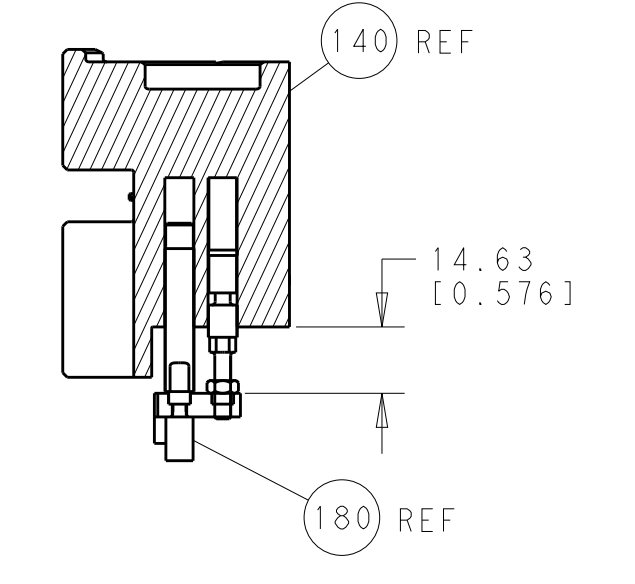
SERVO LATCH PLATE



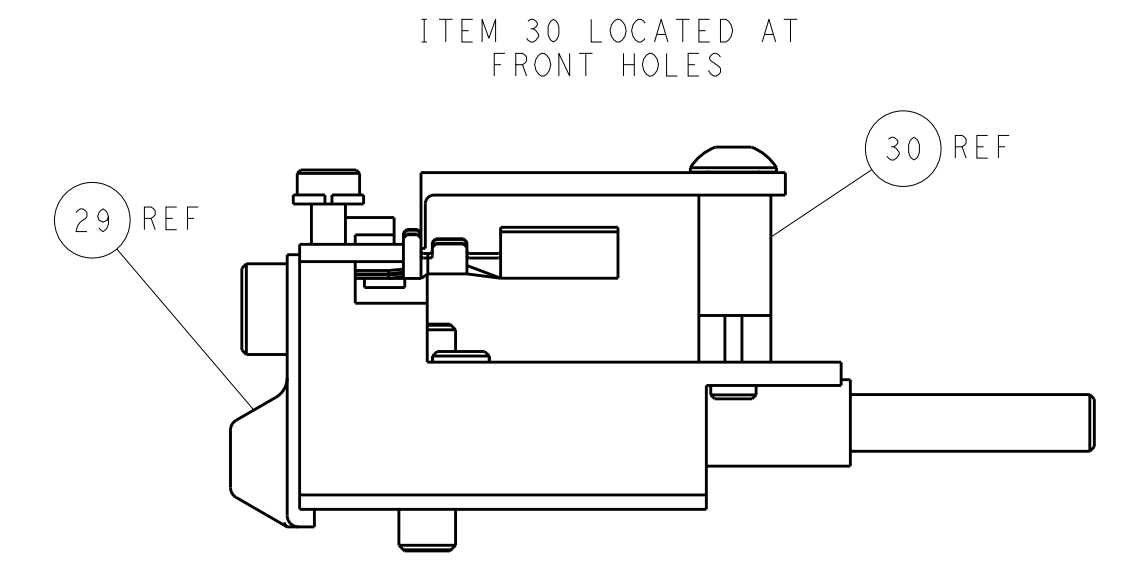
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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:		OWN		TE Connectivity	
mm		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.013 4 PLC ±0.0001		B. WEAVER 12MAR2014		Harrisburg, PA 17105-3608	
MATERIAL		FINISH		CHK T. ELBIN 12MAR2014		NAME	
				APVD T. ELBIN 12MAR2014		Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE	
				APPLICATION SPEC		CAGE CODE	
				WEIGHT		DRAWING NO	
				Customer Accessible Production Drawing		00779	
				SCALE		1:2	
				SHEET		4 of 4	
				REV		A	