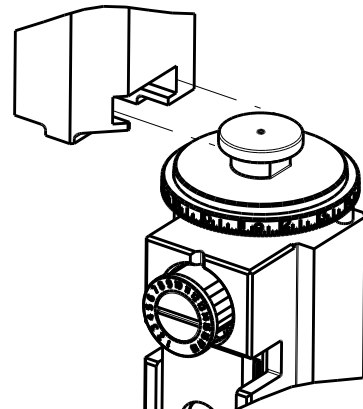
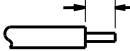


8		7		6		5		4		3		
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	ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
		2266058-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2266058-5	1901094-3	1-1752354-7	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2266058-4	-	-	-
		2266058-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2266058-5	1901094-3	1-1752354-7	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2266058-4	-	-	-
		2266058-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ^{△4}	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
		2266058-6	B	NON-CRIMP HEIGHT ADJUST	^{△4} SERVO LATCH PLATE ^{△12}	-	-	-	-	-	-	-
		2266058-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266058-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.90 mm [.114]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MQS SOCKET CONTACT			
WIRE STRIP LENGTH 3.35-3.65 mm [.132-.144 IN]		INSULATION DIAMETER RANGE Ø2.40-2.60 mm [.094-.102 IN] 	
			
TERMINAL APPLICATION 	114-18025	-	-
SPECIFICATION	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
965906-1	6-965906-5	967067-1	
965906-5	7-965906-5		
965906-6	965908-1		
1-965906-5	965908-2		
2-965906-5	2-965908-2		
5-965906-1	5-965908-1		
5-965906-5	5-965908-2		
5-965906-6	7-965908-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT ⁹ REFERENCE SETTING
0.75mm2		1.07+/-0.03 [0.042+/-0.001]		6.3
0.50mm2		0.93+/-0.03 [0.037+/-0.001]		7.7



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 ASSEMBLY. SEE BELOW FOR PART NUMBER:
 - MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8
 - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8
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 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8. MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO 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 (-) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
13. INSULATION RANGLE QUOTED IS THAT OF THE TERMINAL. THE SEAL INSULATION RANGE IS Ø1.4 - 1.9 [.055 - .075 IN.]
14. APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
15. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TOOL

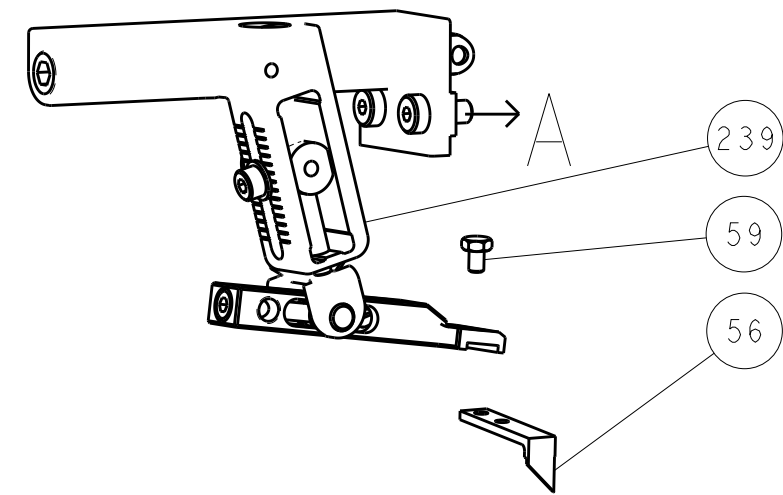
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISHUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3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

				2						1
SET UP GAUGE		LOC	DIST	REVISIONS						
2119599-1		A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD	
				I		DEVELOPMENT	25SEP2013	KH	UG	
				A		RELEASED	23OCT2013	BH	GB	
				A1		ECR-15-009693	26JUN2015	JH	TE	
				B		ECR-16-014999	24OCT2016	KH	TE	
1	1	1	1	1	2119082-4	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		
1	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED		182		
1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5		181		
1	1	1	1	1	1-1752354-7	STANDOFF,HOLD-DOWN		180		
1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0		177		
1	1	1	1	1	5-22280-0	SPRING, COMPRESSION		176		
1	1	1	1	1	1752353-3	GUIDE PIN,HOLDDOWN		175		
1	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN		174		
-	-	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	455888-5	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		
-	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	985575-4	SCR, FLT SKT HD CAP M3 X 12.0		57		
-	-	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	2	18023-9	SCR, SKT HD CAP M4 X 6.0		49		
-	-	-	1	1	2119652-1	FEED CAM, PRE FEED		48		
-	-	-	1	1	2119653-1	FEED CAM, POST FEED		47		
1	1	1	1	1	2-2119656-1	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)		4		
-	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	2119644-1	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	1752356-6	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	1-1320908-0	SPACER, STRIP GUIDE		30		
1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE		29		
1	1	1	1	1	455888-6	SPACER, CRIMPER		28		
1	1	1	1	1	1320928-2	STRIP GUIDE		24		
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	318707-1	FLOATING SHEAR, FRONT		9		
1	1	1	1	1	1-1333201-0	ANVIL, COMBINATION		8		
1	1	1	1	1	5-240641-4	SPACER		7		
-	-	-	-	-	-	-		6		
1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR		5		
1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER		4		
1	1	1	1	1	1-2119784-5	CRIMPER, INSULATION O PREMIUM		3		
1	1	1	1	1	455888-1	SPACER, CRIMPER		2		
1	1	1	1	1	1-456402-7	CRIMPER, WIRE PREMIUM		1		
-6	-5	-2	-1		PART NO	DESCRIPTION			ITEM NO	

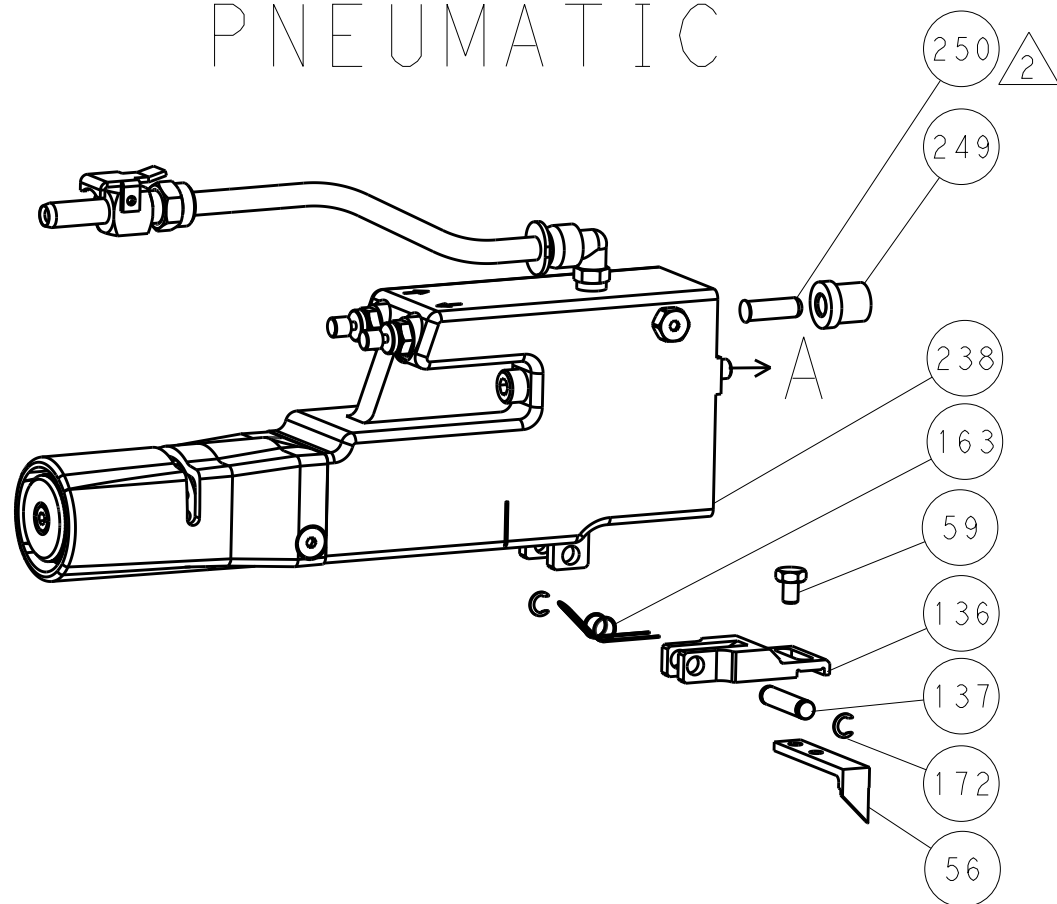
TEST: DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRICAL CONNECTION CHECK FOR CORRECT USE FOR THE LATEST EDITION OF THE CONNECTION		OWN 25SEP2013 CHG 25SEP2013 APPR U GUO 25SEP2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES, UNLESS OTHERWISE SPECIFIED: Ø PLC ±.0 PLC ±0.5 PLC ±0.13 PLC ±0.013 ANGLES ±0.0001		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC -			
		APPLICATION SPEC -			
MATERIAL -		WEIGHT -		SIZE CAGE CODE DRAWING NO RESTRICTED TO A 00779 C=2266058 -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 1 OF 4 REV B	

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

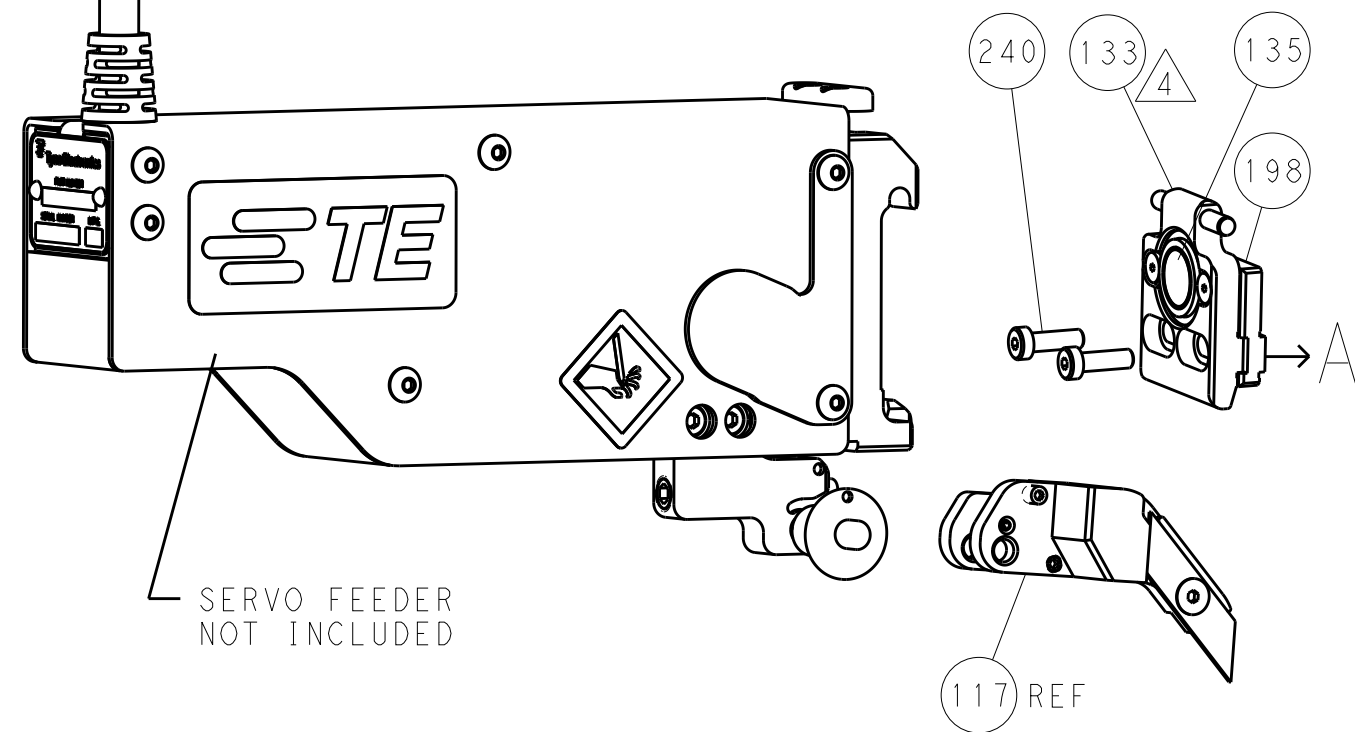
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PNEUMATIC



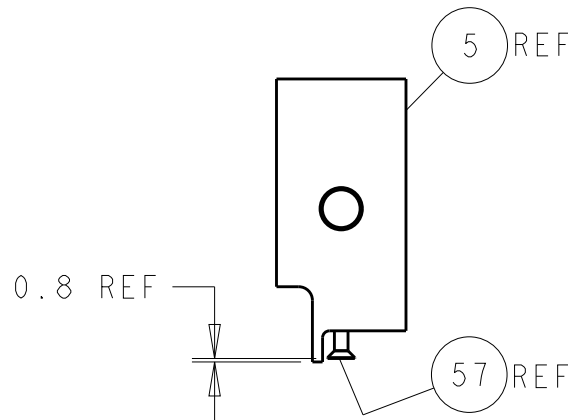
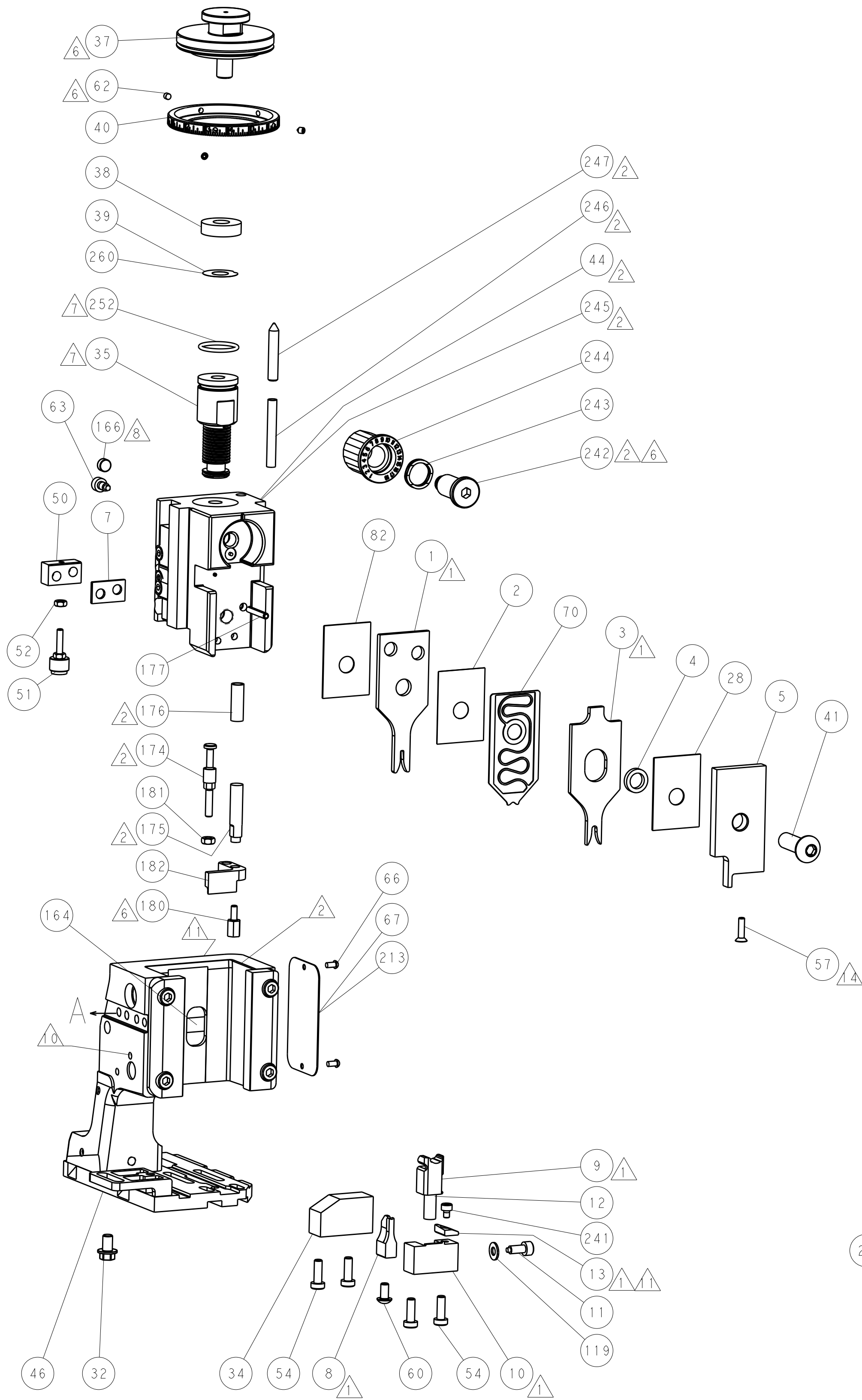
SERVO
LATCH PLATE



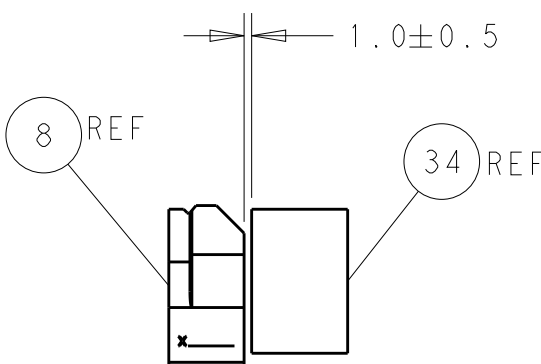
CAM POSITIONS



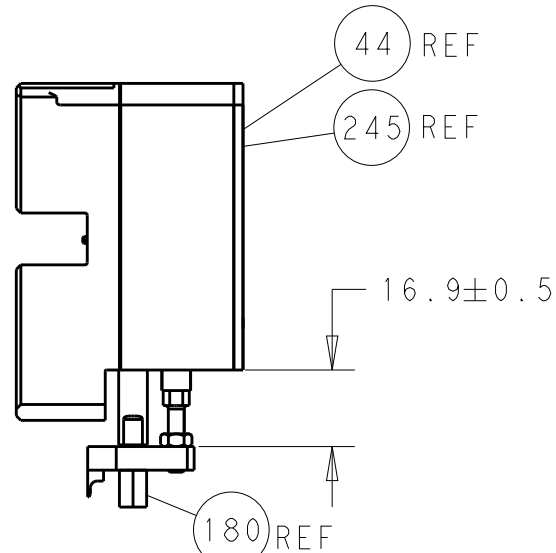
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



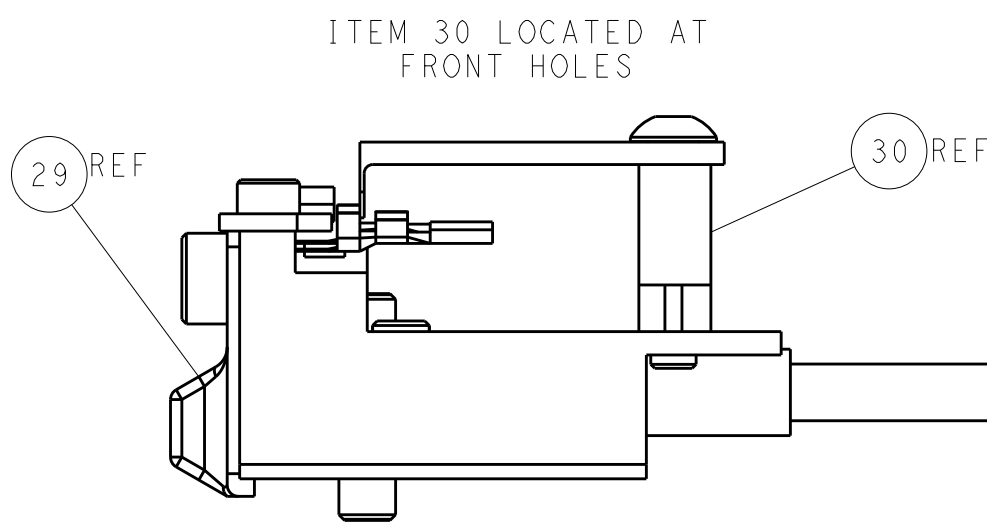
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

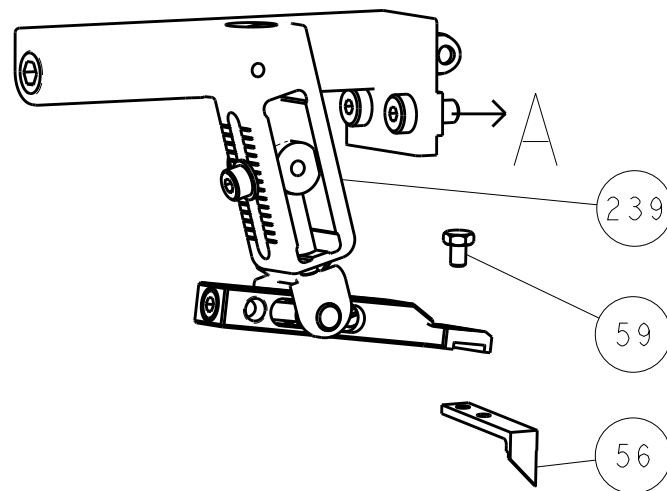


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

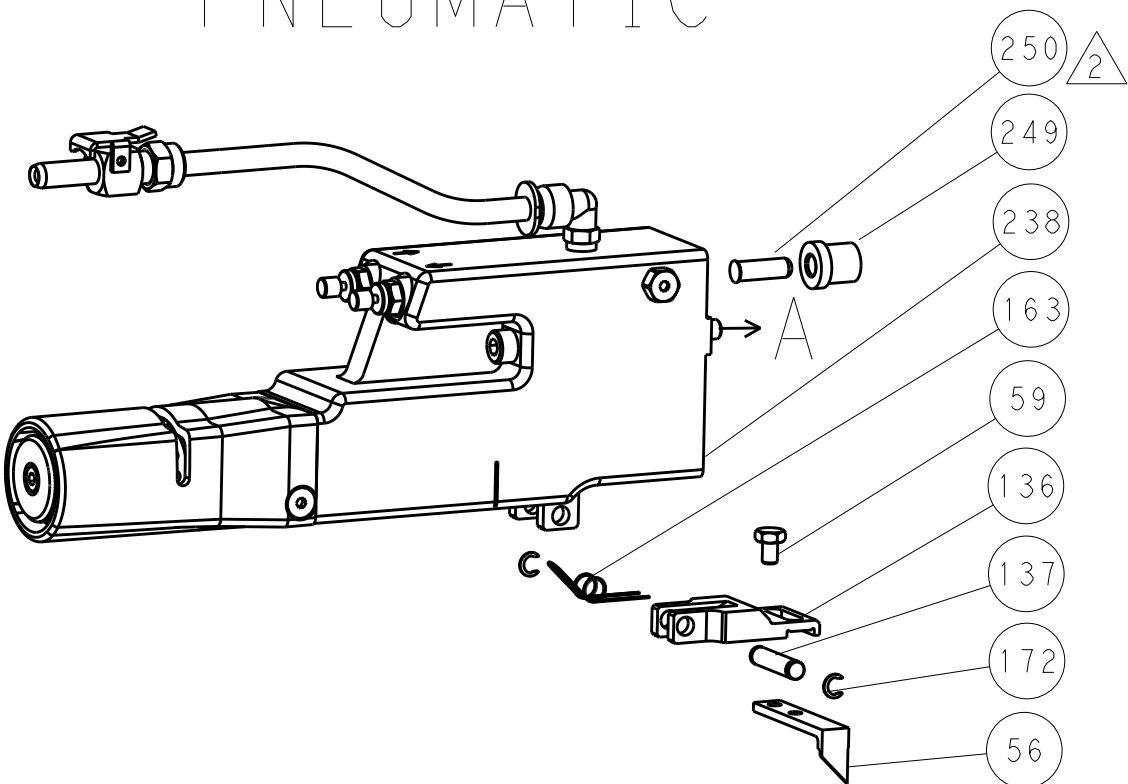
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		RESTRICTED TO	
mm		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001		OCEAN SIDE FEED APPLICATOR		-	
MATERIAL		FINISH		SIZE		CAGE CODE	
-		-		A1		00779	
Customer Accessible Production Drawing		SCALE		1:2		SHEET 2 OF 4	

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

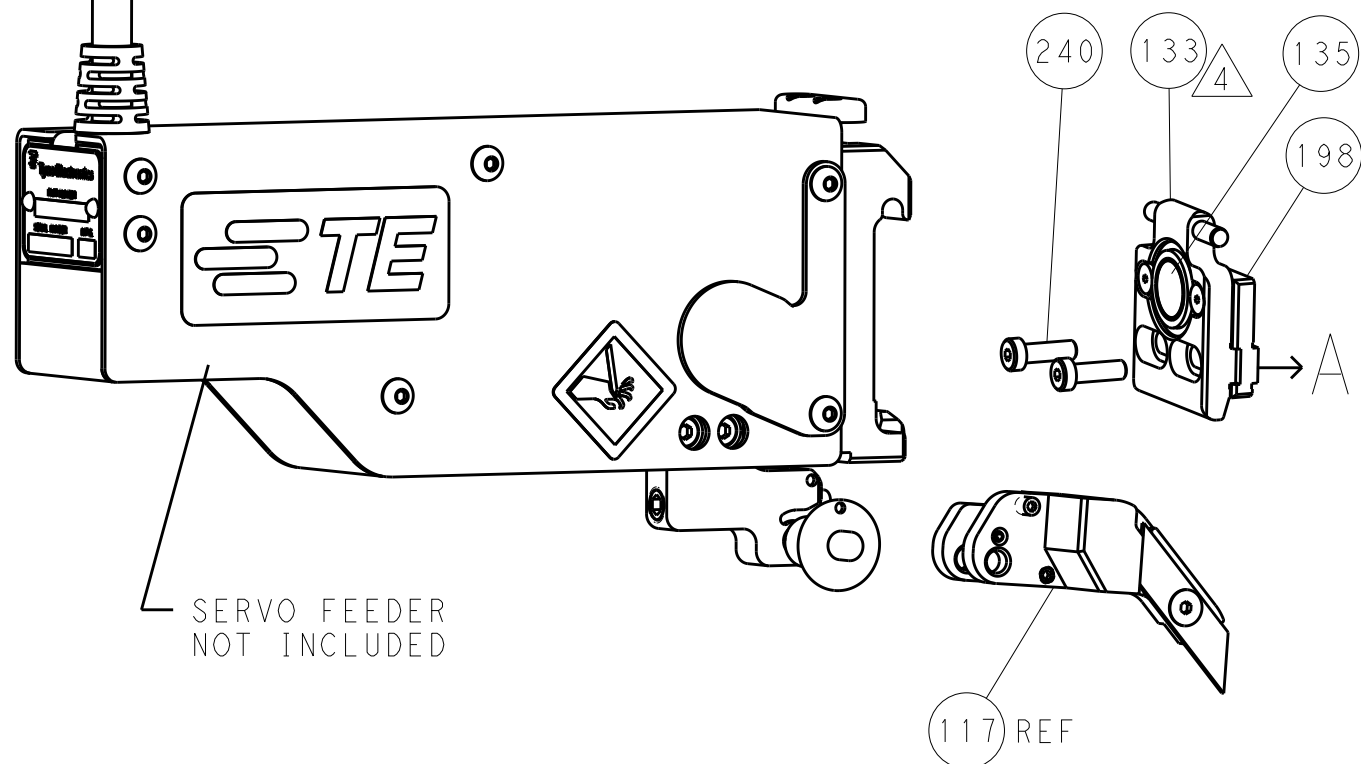
FEED TYPE
MECHANICAL



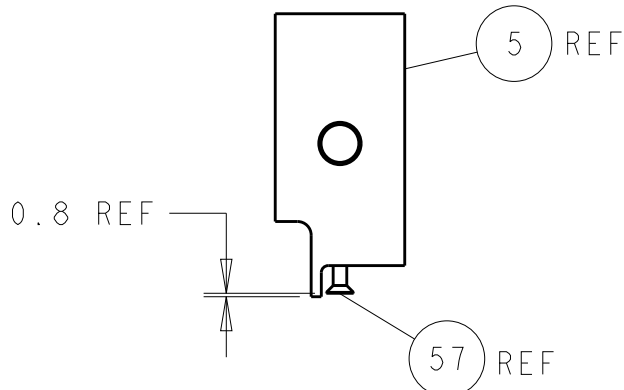
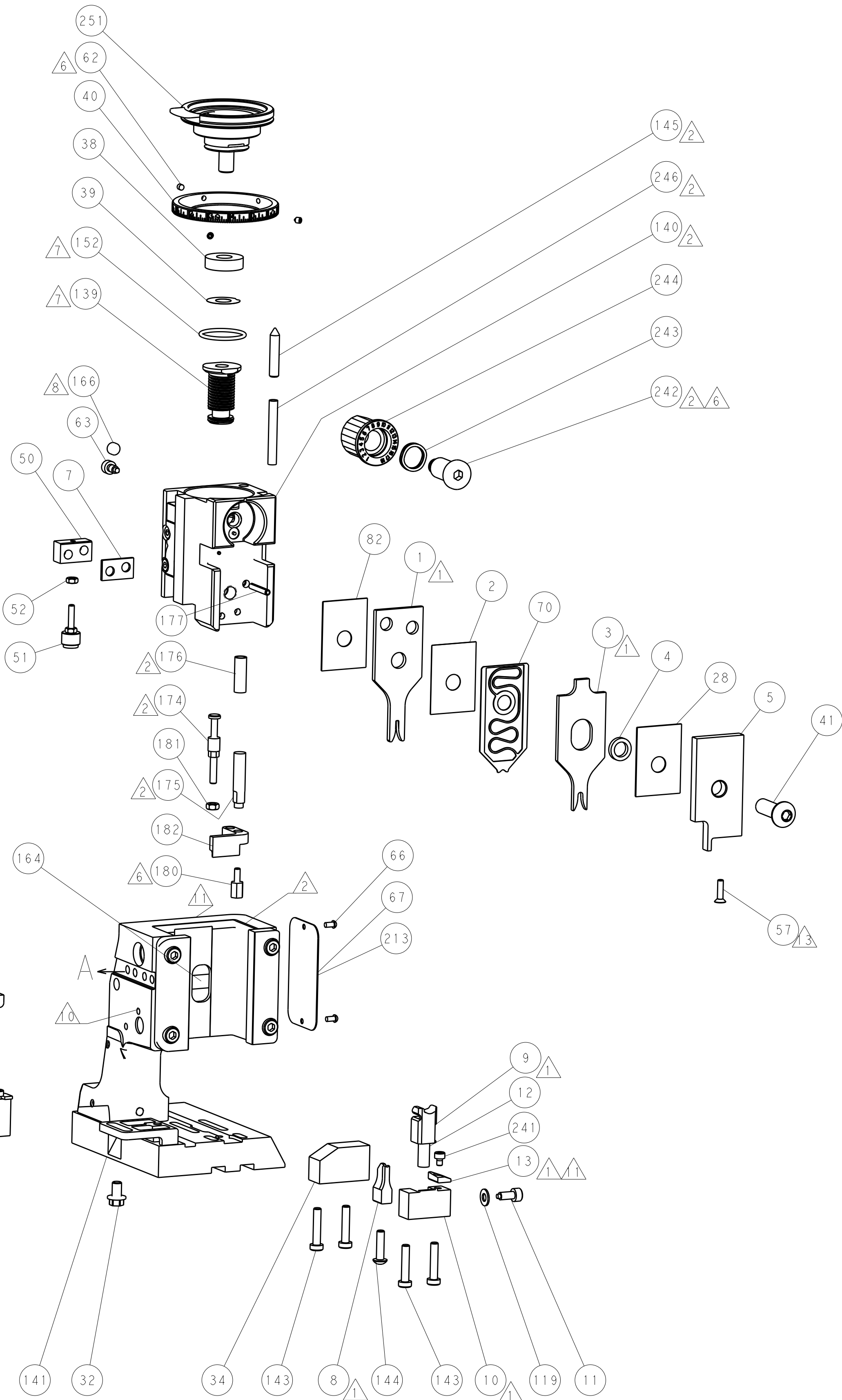
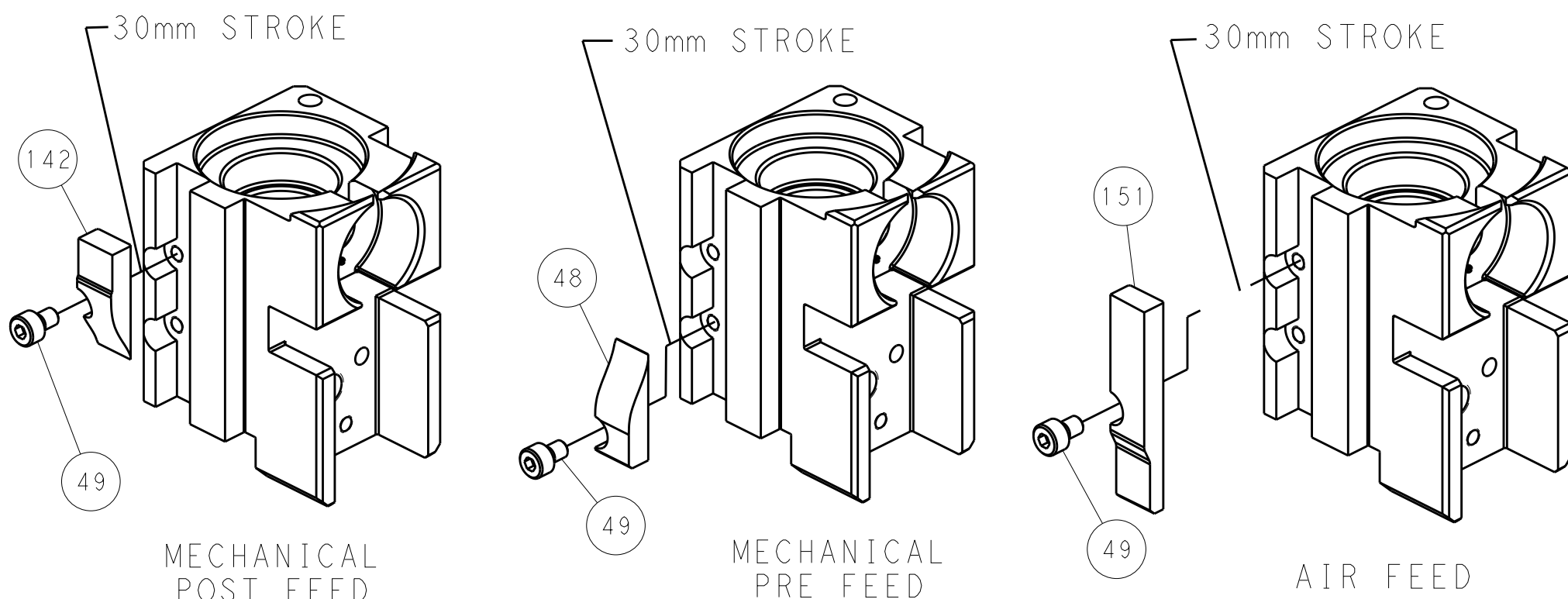
PNEUMATIC



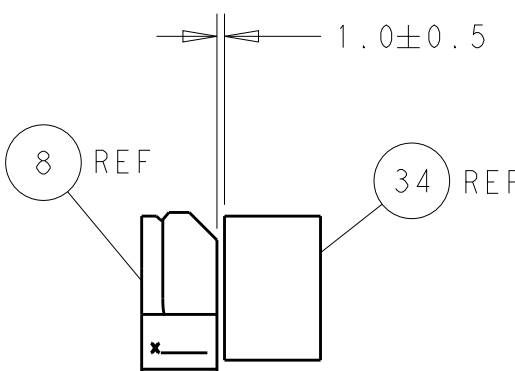
SERVO
LATCH PLATE



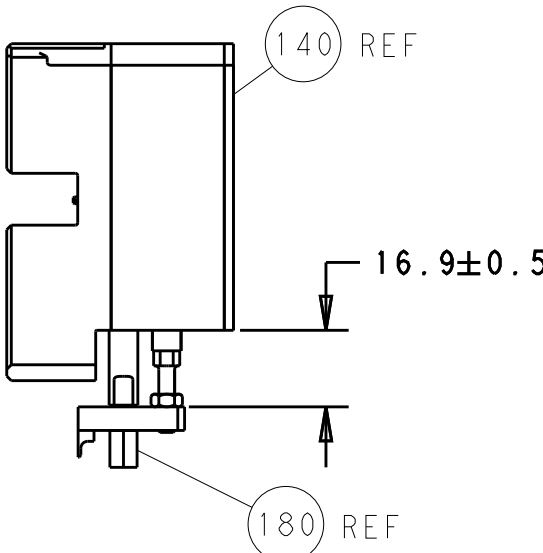
CAM POSITIONS



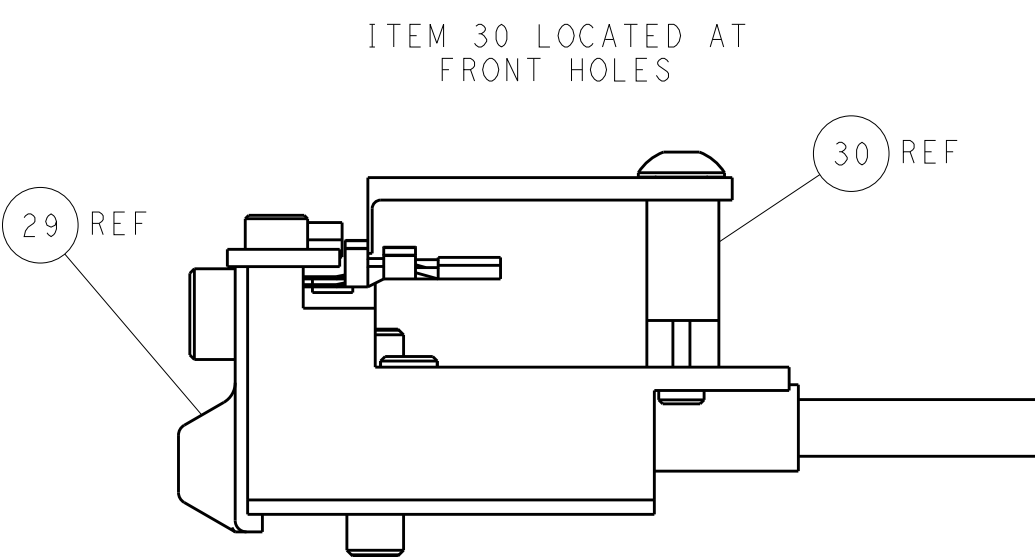
SHEAR DEPRESSOR DETAIL



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: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG 25SEP2013		CHK L. ZHANG 25SEP2013		APVD J. GUO 25SEP2013		NAME Ocean Side Feed Applicator	
0 PLC ±.5		1 PLC ±0.13		2 PLC ±0.13		3 PLC ±0.013		4 PLC ±0.001		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		SIZE		CAGE CODE		DRAWING NO	
						A1		00779		C=2266058	
Customer Accessible Production Drawing		SCALE		1:2		SHEET		4		REV	
										B	