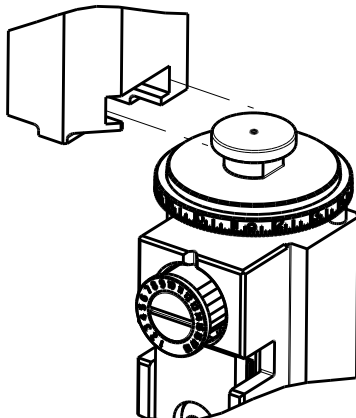


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION
		2266208-1	B
		2266208-2	B
		2266208-5	B
		2266208-6	B
		2266208-7	B
		7-2266208-7	A
		DESCRIPTION	
		FINE CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		NON-CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		CRIMP TOOLING KIT	
APPLICATOR DATA			
CRIMP	SIZE	TYPE	
WIRE	1.27 mm [.050]	F	
INSUL	3.05 mm [1.20]	O	
APPLICATOR INSTRUCTIONS 408-10389			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2 MM - SWS			
WIRE STRIP LENGTH 3.00-3.60 mm [118-142 IN]		INSULATION DIAMETER RANGE Ø 2.60 mm MAX $\Delta 13$	
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1718758-1	2141114-3	967067-1	
1718758-2	2208327-3	967067-2	
1718758-3		963142-2	

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.35mm2			0.84+/-0.03 [.033+/- .001]		5.6
22 AWG			0.83+/-0.03 [.033+/- .001]		5.8
0.25mm2			0.78+/-0.03 [.031+/- .001]		6.1
24 AWG			0.75+/-0.03 [.030+/- .001]		6.6



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: 8-2266208-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266208-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266208-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266208-6
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 & 180.
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 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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT
13. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
INSULATION RANGE QUOTED IS THAT OF THE TERMINAL.
SEAL PN 967067-2 & 963142-2 INSULATION RANGE IS 0.9- 1.4mm.
SEAL PN 967067-1 INSULATION RANGE IS 1.4- 2.1mm.
14. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
APPLY #1-23419-5 LOC-TITE TO THREADS.

6	5	4	3			
APPLICATOR STYLE CONVERSION CHART						
CONVERT TO	PART NUMBERS REQUIRED					
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
SERVO LATCH PLATE	2119951-1	-	8-2266208-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2266208-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
SERVO LATCH PLATE	2119951-1	-	8-2266208-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2266208-4	-	-	-
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
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-

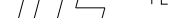
5 THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER TERMINATING UNIT.

2	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
1	-	1	-	1	1	1	8-210840-0	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	1	2119798-1	DETENT PIN	247
	1	-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-77	-7	-6	-5	-2	-1		PART NO	DESCRIPTION	ITEM NO

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

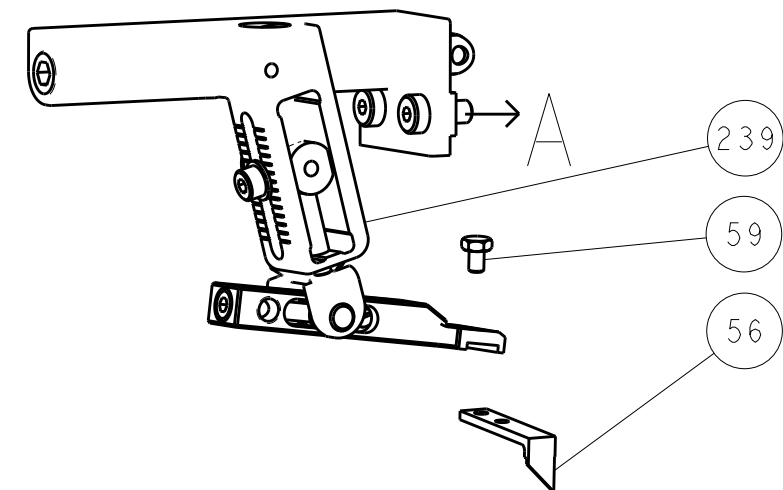
[illegible]

	-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
	-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
6	-	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
6	-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	180
	-	1	1	1	1	1	1-1752354-6	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
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	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
6	-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	-	-	-	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	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)	41
	-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
6	-	1	1	1	1	1	1-2119644-4	RAM WASHER, PRECISION	38
7	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	

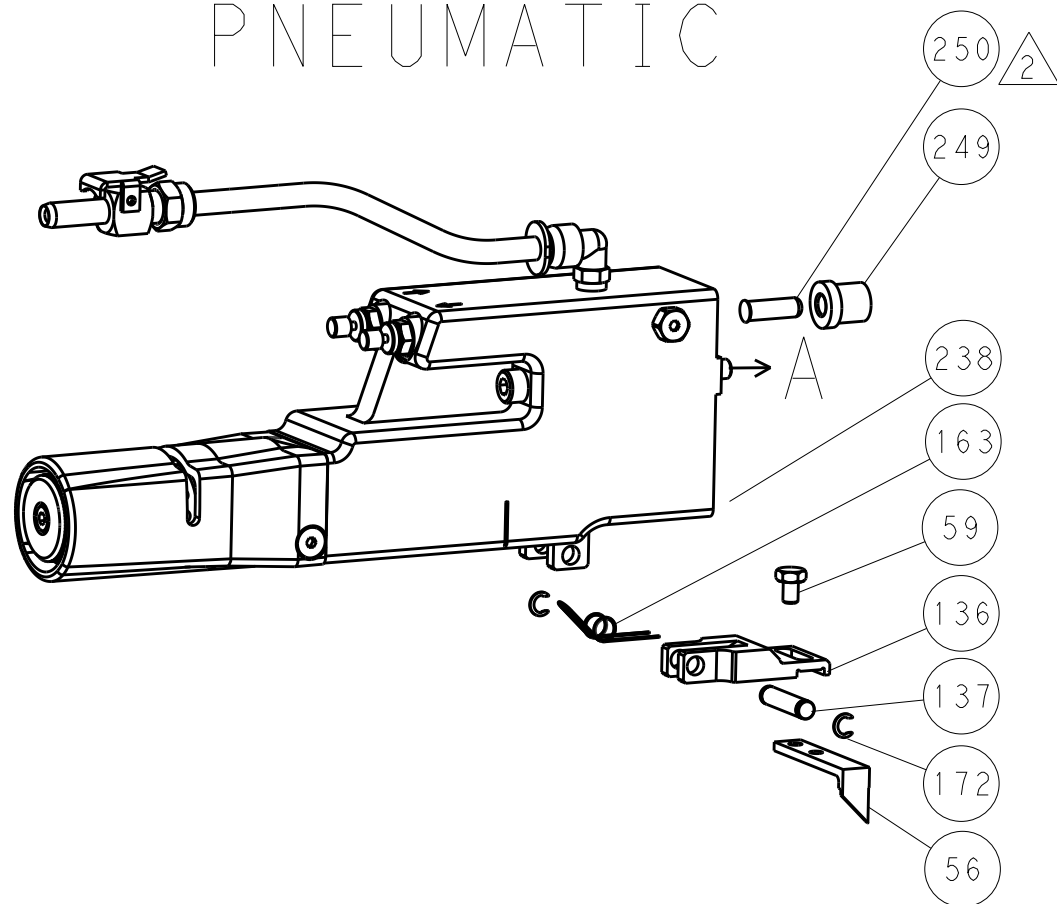
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		FINISH -		SIZE CAGE CODE DRAWING NO A 00779 C-2266208	
WEIGHT -		RESTRICTED TO -		SCALE 1:2 SHEET 1 OF 4 REV B	
Customer Accessible Product Drawing					

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

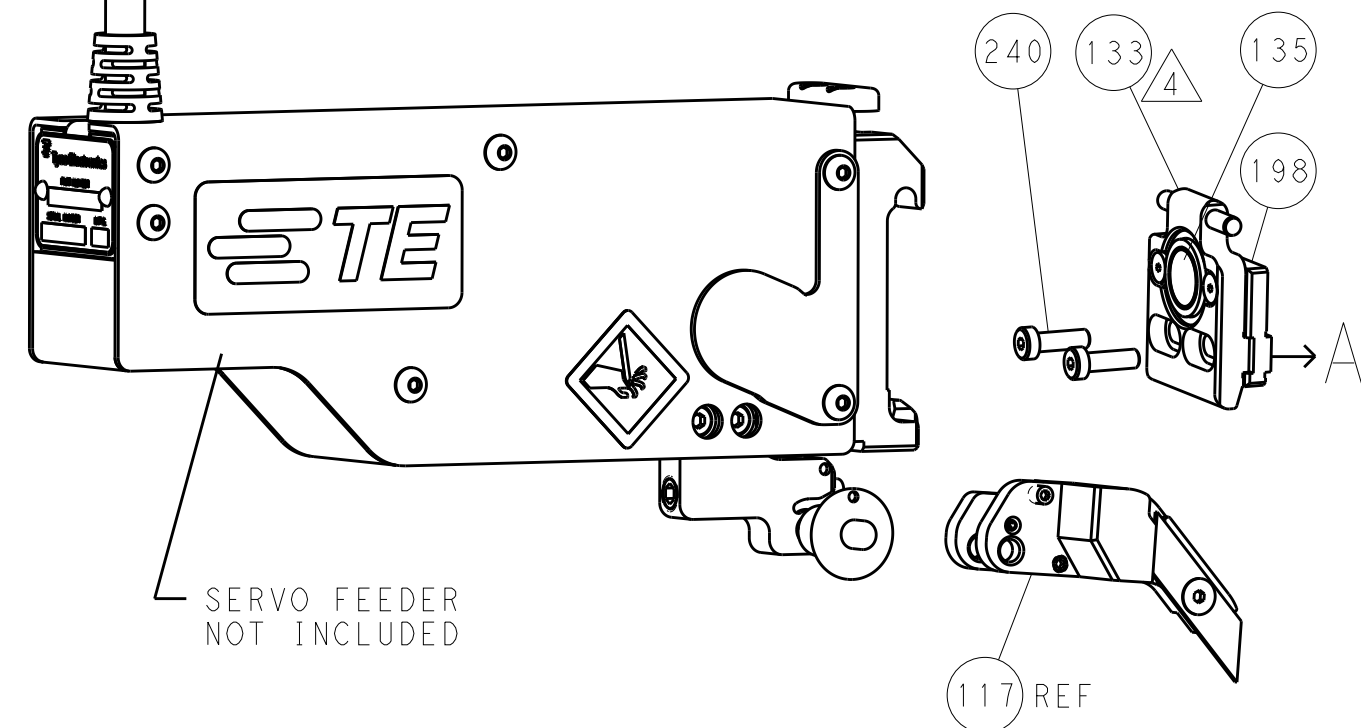
FEED TYPE
MECHANICAL



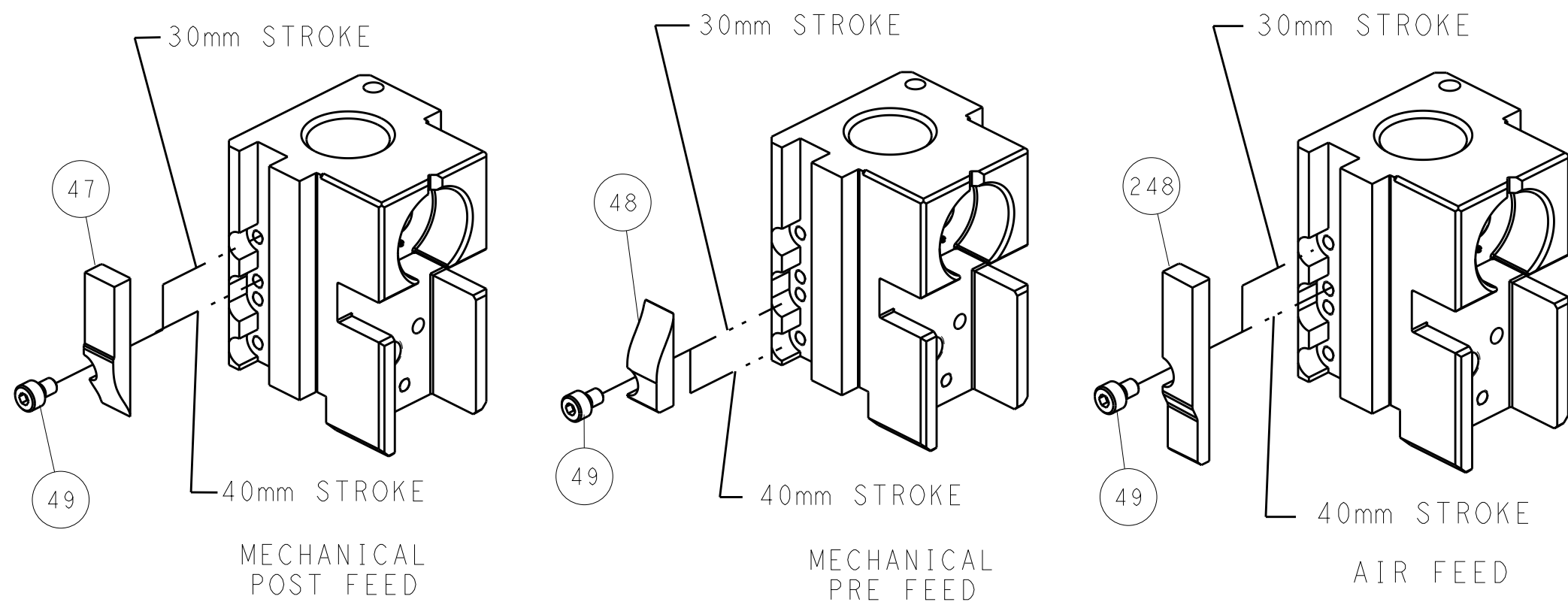
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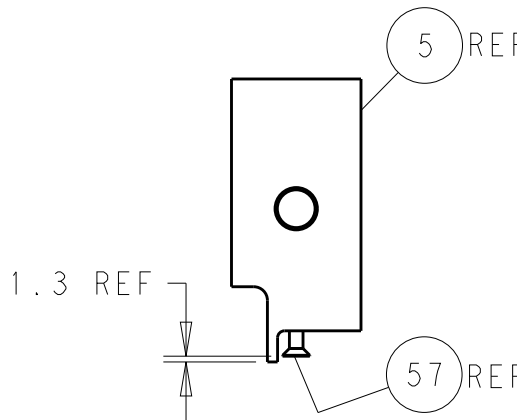
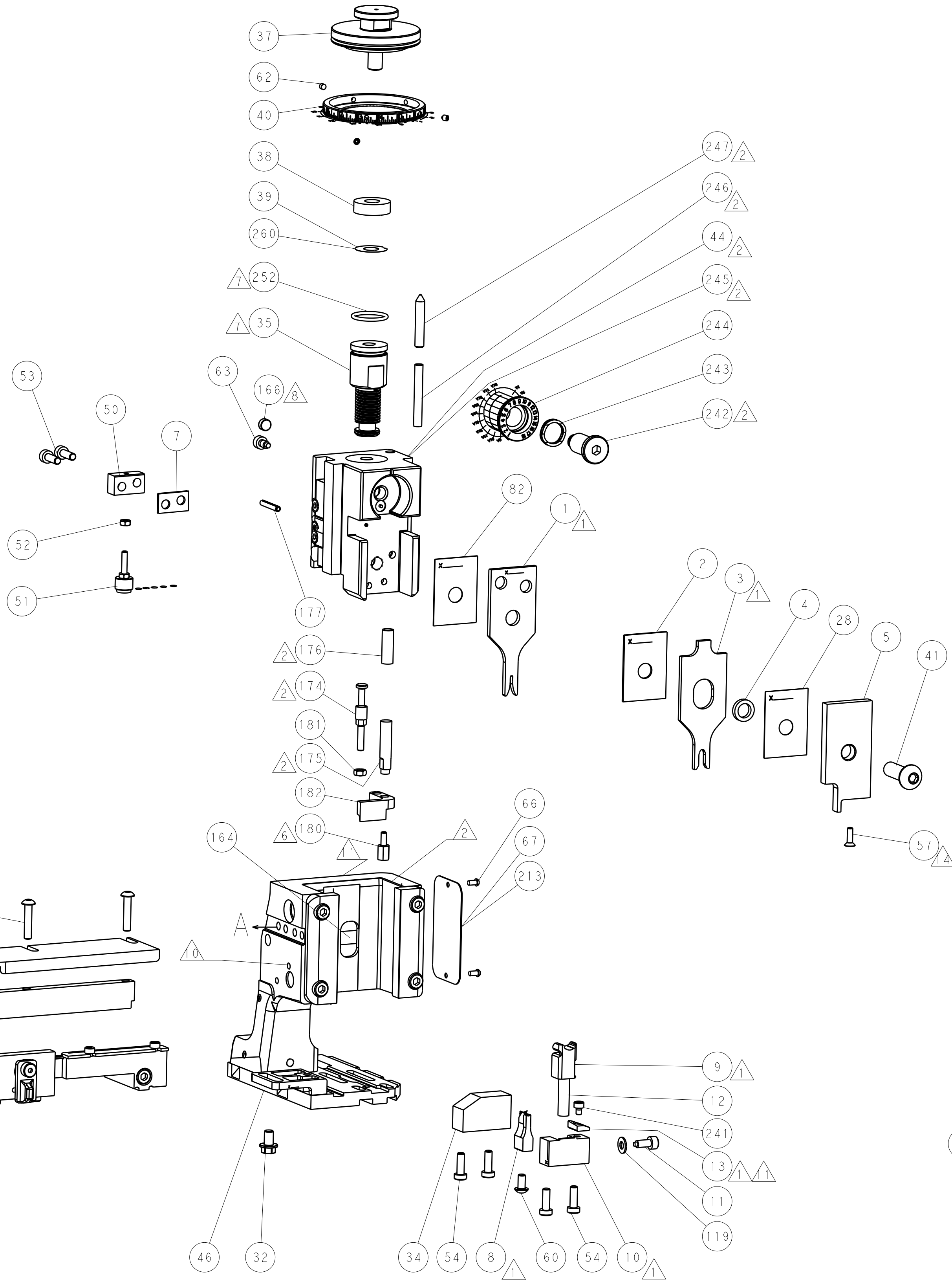
SERVO
LATCH PLATE



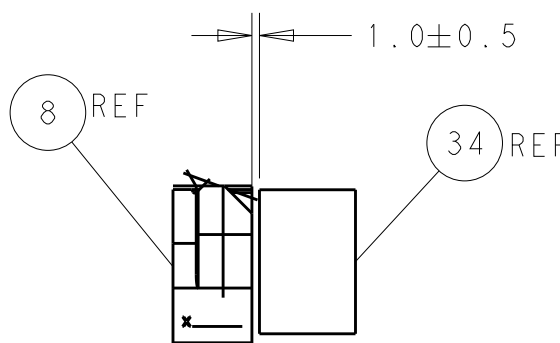
CAM POSITIONS



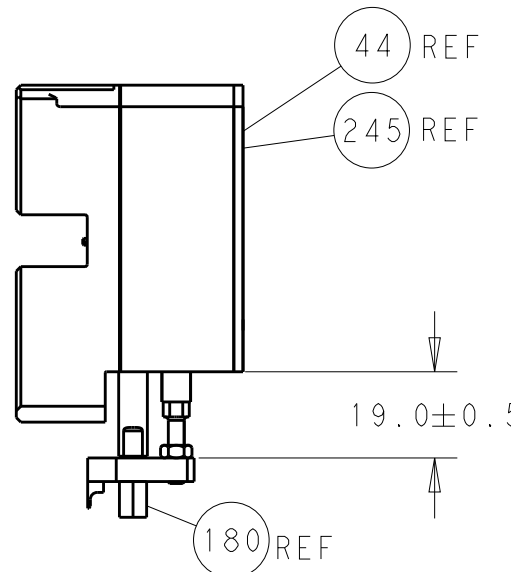
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



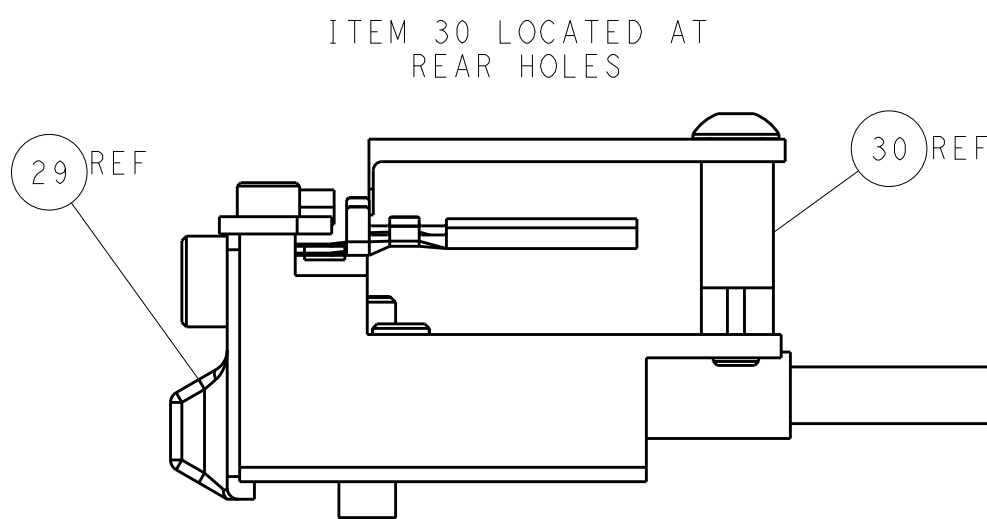
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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CHK L.ZHANG 13FEB2014				NAME				Ocean Side Feed			
APVD T.FILBIN 13FEB2014				PRODUCT SPEC				Harrisburg, PA 17105-3608			
APPLICATION SPEC				SIZE				CAGE CODE			
MATERIAL				WEIGHT				DRAWING NO			
FINISH				Customer Accessible Production Drawing				A1 00779 C=2266208			
SCALE				SHEET				REV			
1:2				2				B			

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

D

C

B

A

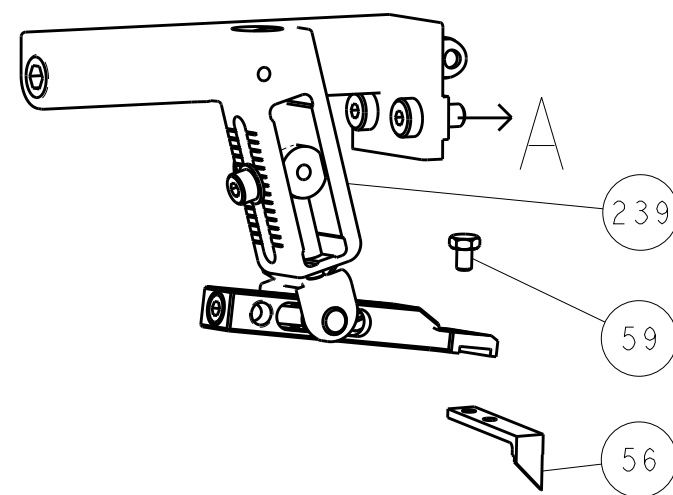
D

C

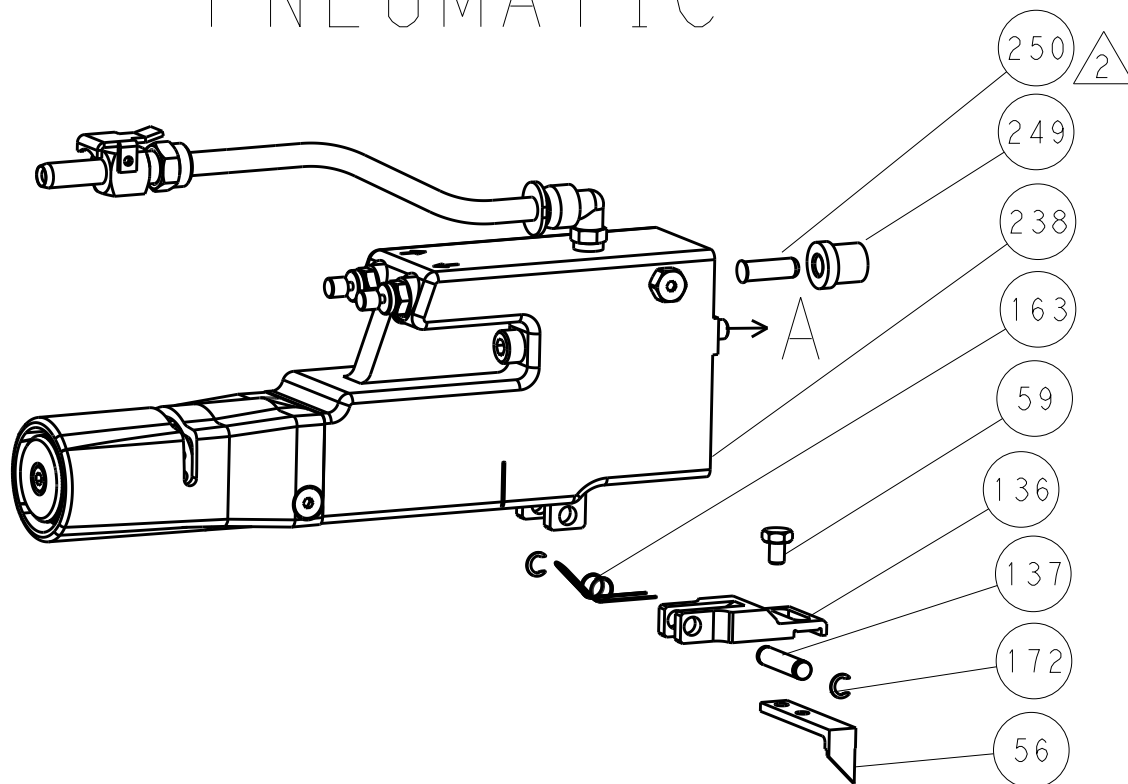
B

A

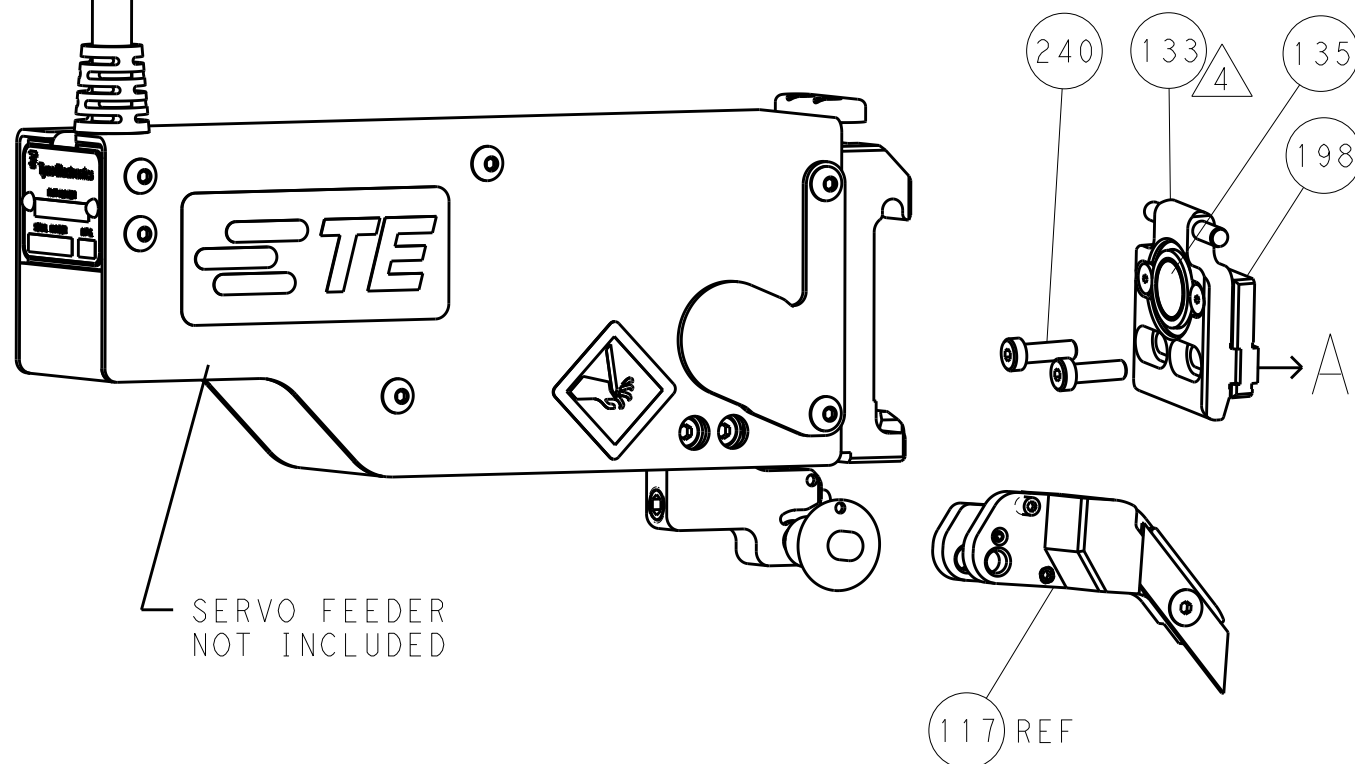
FEED TYPE MECHANICAL



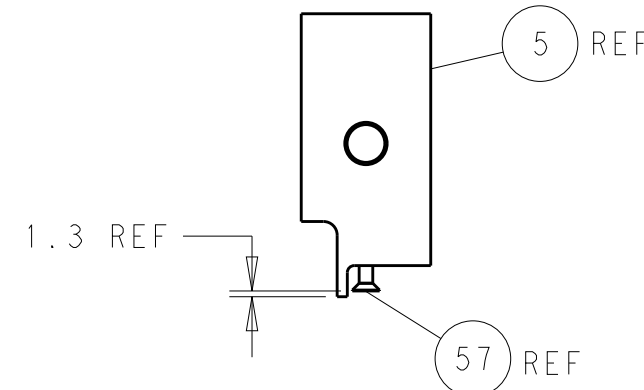
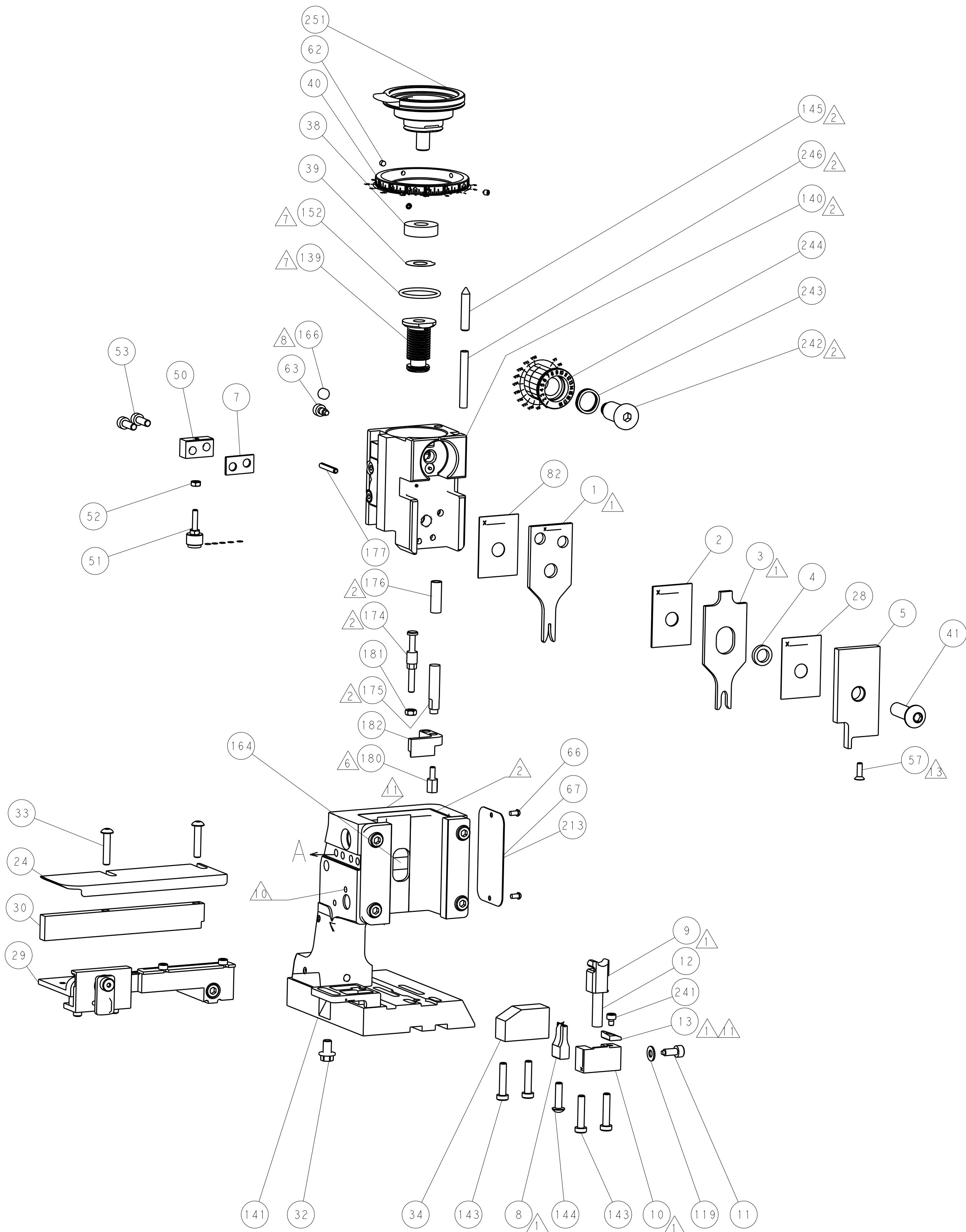
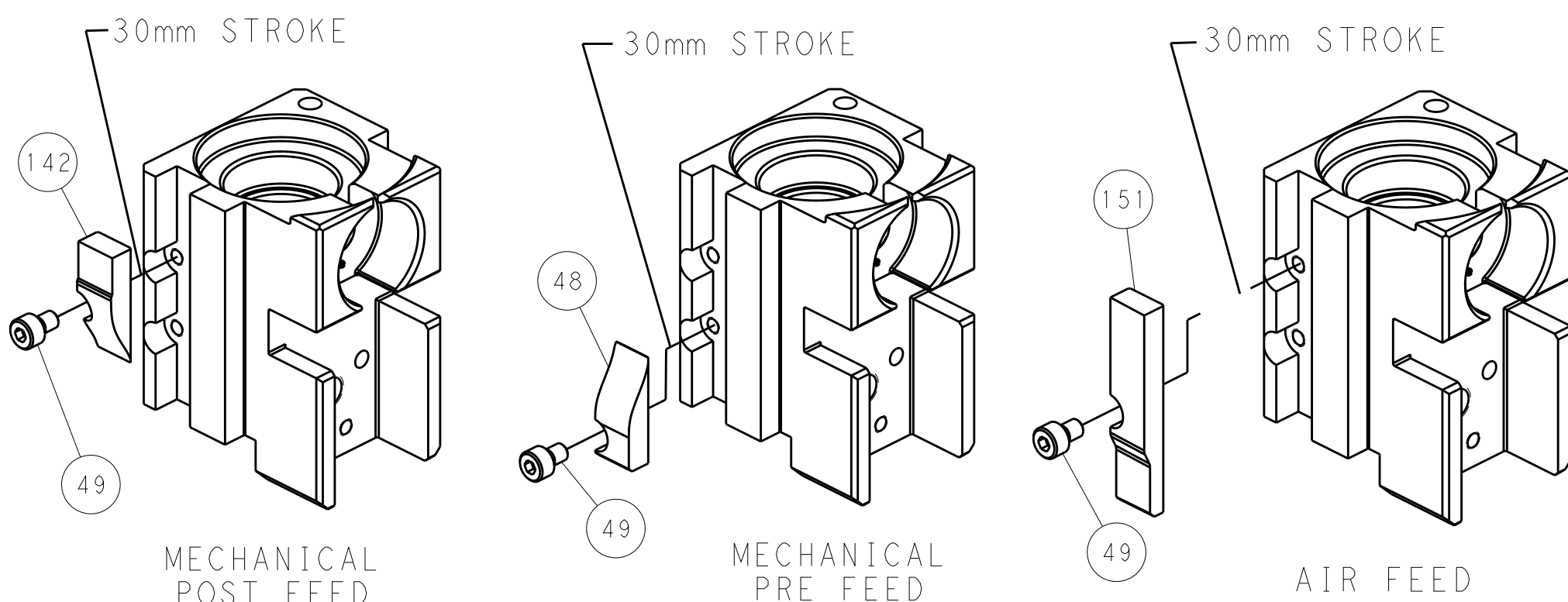
PNEUMATIC



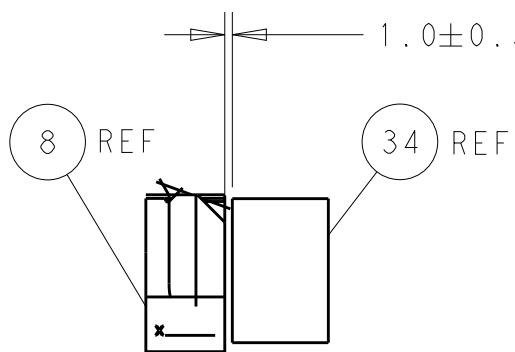
SERVO LATCH PLATE



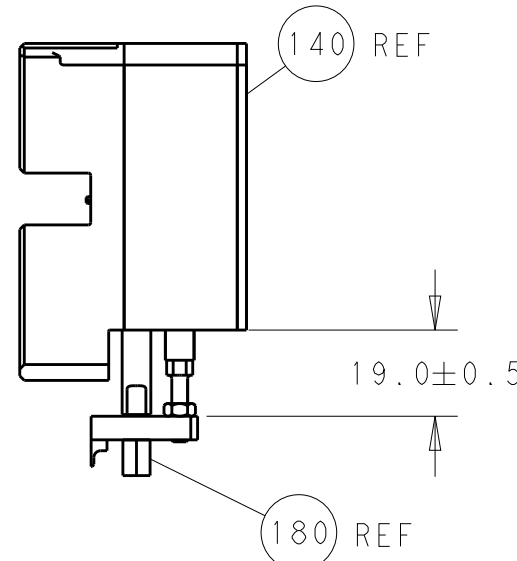
CAM POSITIONS



SHEAR DEPRESSOR DETAIL

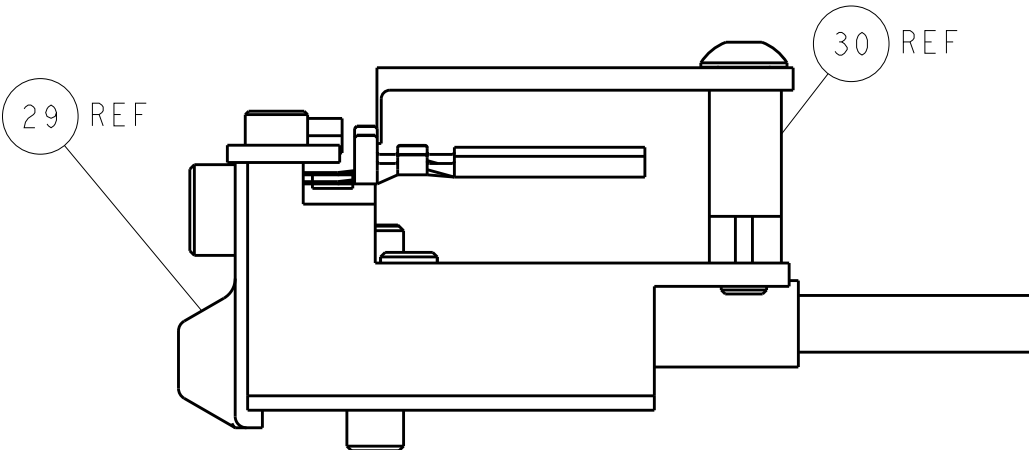


TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

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)

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		CHK	L. ZHANG	13FEB2014	
		APVD	T. ELBIN	13FEB2014	
		NAME	Ocean Side Feed Applicator		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	SIZE
mm		0 PLC ±.1		APPLICATION SPEC	
		1 PLC ±.1			
		2 PLC ±.1			
		3 PLC ±.1			
		4 PLC ±.1			
		ANGLES			
		FINISH			
MATERIAL		WEIGHT		Customer Accessible Production Drawing	RESTRICTED TO
				SCALE 1:2	SHEET 4 OF 4
				REV B	