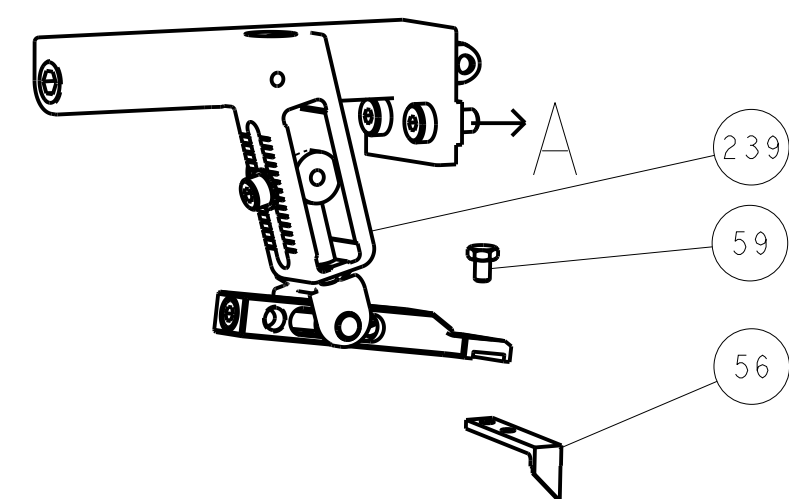
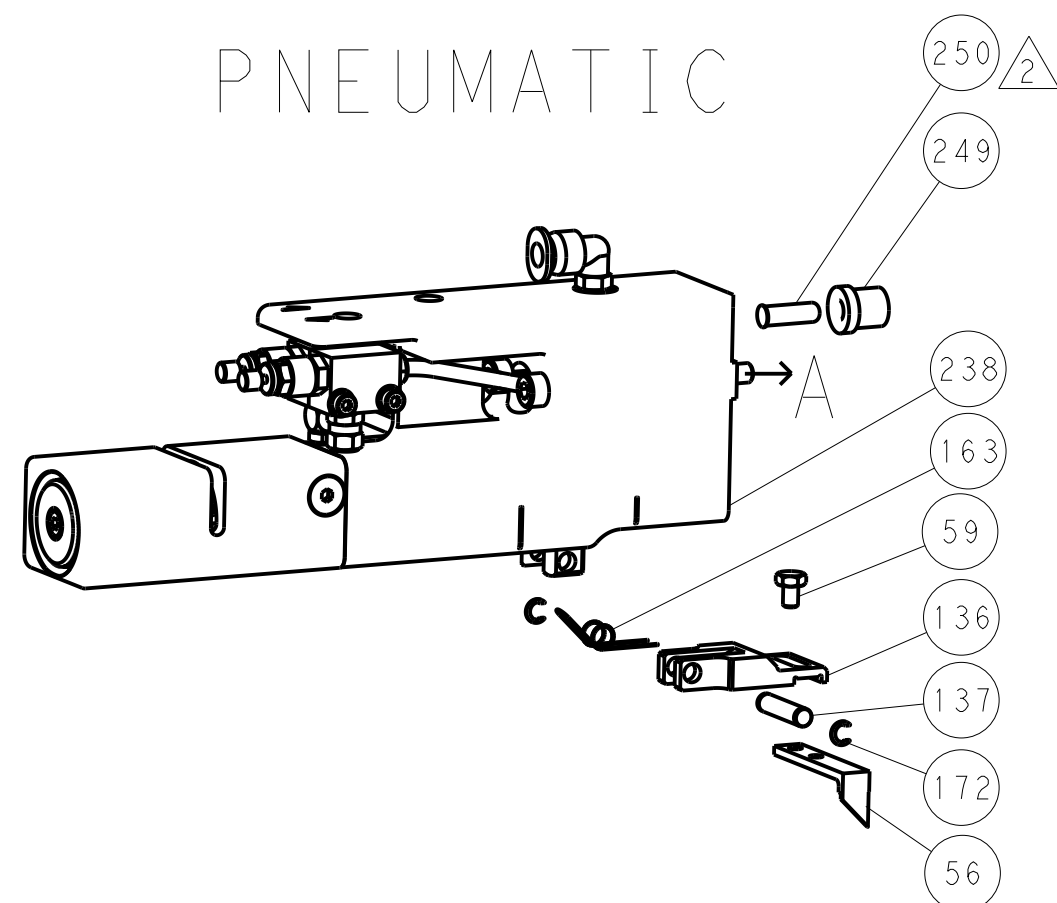


LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

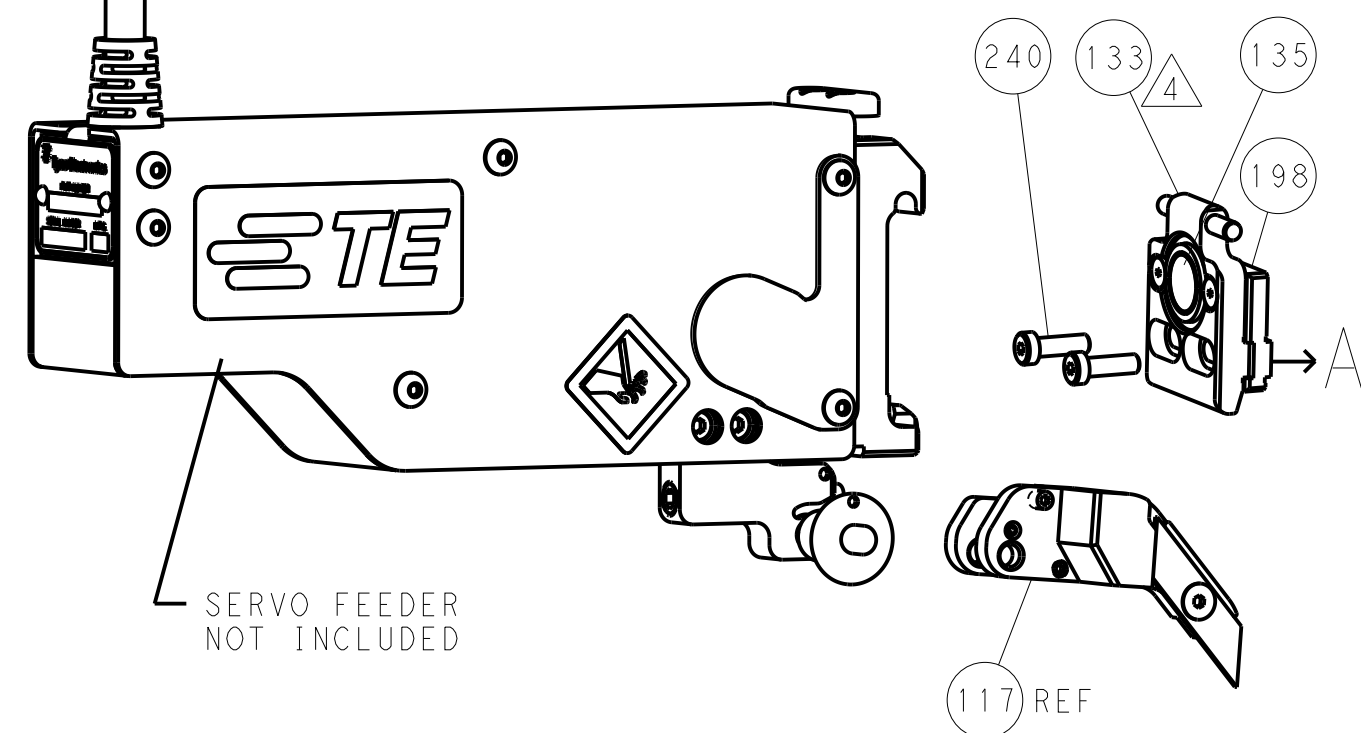
FEED TYPE
MECHANICAL



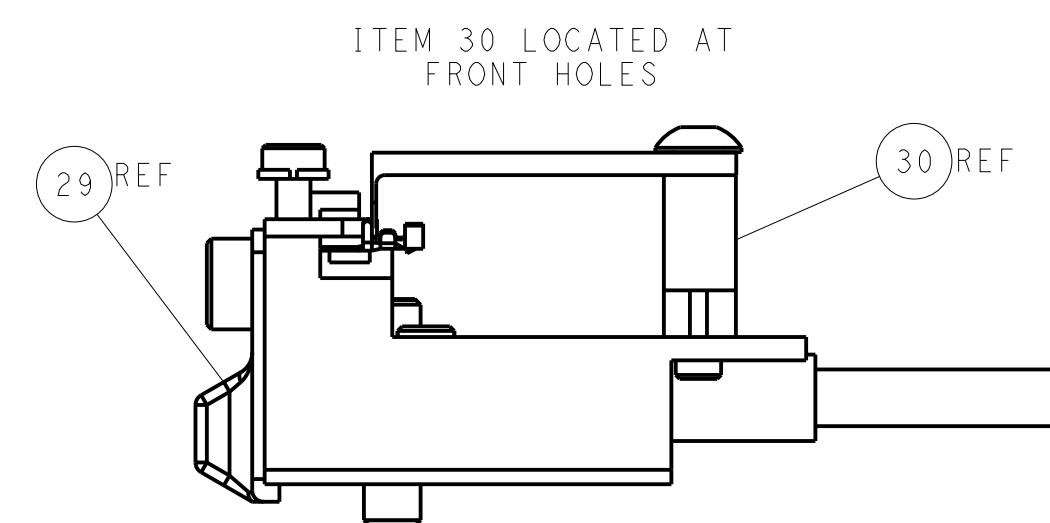
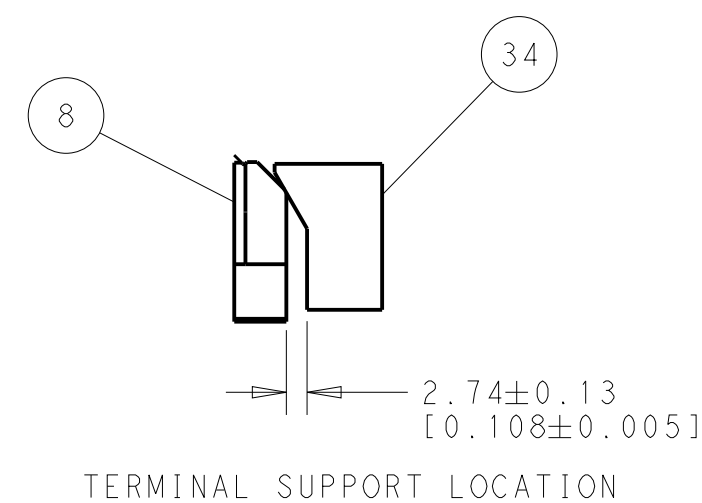
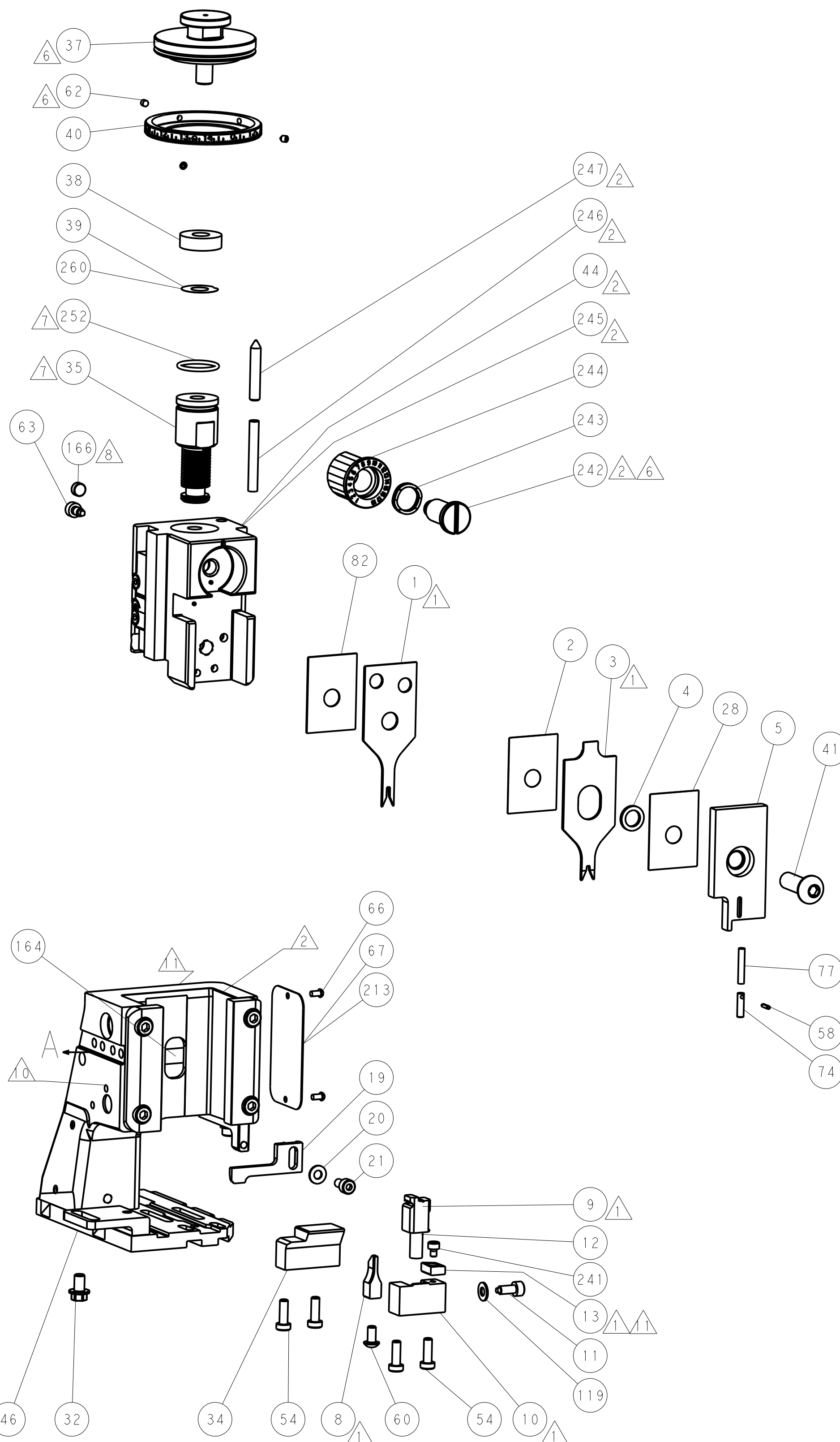
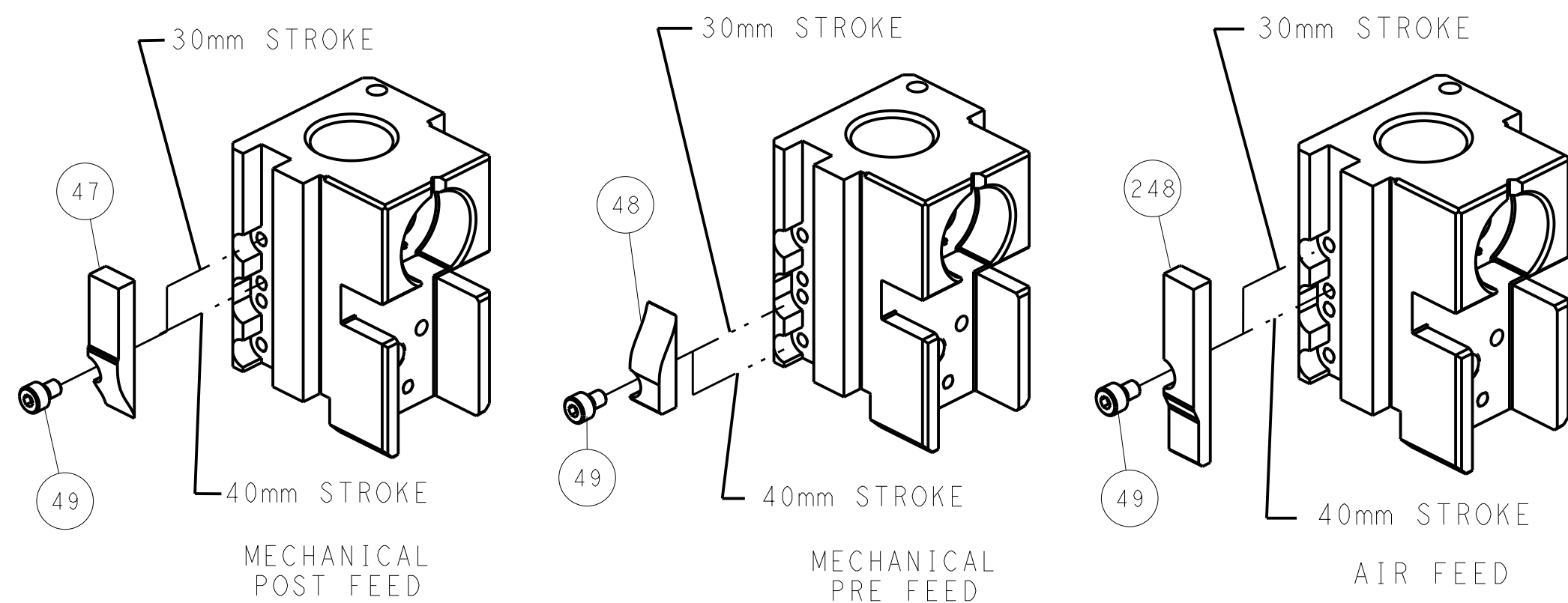
PNEUMATIC



SERVO
LATCH PLATE



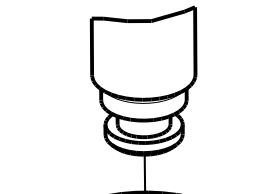
CAM POSITIONS



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

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
DIMENSIONS:							DWN: 21JAN2014	
mm							CHK: 22JAN2014	
							T. ELBIN	
							APVD: 22JAN2014	
							NAME	
							Ocean Side Feed	
							Applicator	
							SIZE: CAGE CODE: DRAWING NO	
							A1 00779 C=2266203	
							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	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20							
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.									
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266203-1	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	-	8-2266203-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266203-4	-	-	-
	2-2266203-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266203-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266203-4	-	-	-
	2-2266203-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	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
2-2266203-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
7-2266203-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, 2.5MM PITCH HPI CRIMP CONTACT			
WIRE STRIP LENGTH 1.90-2.50 mm [.075-.098 IN]		INSULATION DIAMETER RANGE Ø1.00-1.90 mm [.039-.075 IN]	
TERMINAL APPLICATION SPECIFICATION		 HM-0051 Rev R3	
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572258-1	SEH-001-T-P0.6		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, 2.5MM PITCH HPI CRIMP CONTACT			
WIRE STRIP LENGTH 1.90-2.50 mm [.075-.098 IN]		INSULATION DIAMETER RANGE Ø0.90-1.90 mm [.035-.075 IN]	
TERMINAL APPLICATION SPECIFICATION		HM-0051 Rev R3	
-		-	
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2113095-1	SEH-001T-P0.6L		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
22 AWG			0.75+/-0.05 [.030+/- .002]		5.7
24 AWG			0.70+/-0.05 [.028+/- .002]		6.1
26 AWG			0.65+/-0.05 [.026+/- .002]		6.6
28 AWG			0.625+/-0.025 [.0246+/- .0010]		6.8
30 AWG			0.595+/-0.025 [.0234+/- .0010]		7.1

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
22 AWG			0.695+/-0.025 [0.0274+/-0.0010]		6.1
24 AWG			0.645+/-0.025 [0.0254+/-0.0010]		6.6
26 AWG			0.595+/-0.025 [0.0234+/-0.0010]		7.1

```
*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.
```

2				1		
SET UP GAUGE 2119599-1		LOC A	QIST 66	REVISIONS		
P	LTR	DESCRIPTION		DATE	OWN	APVD
	-	SEE SHEET 1		-	-	-

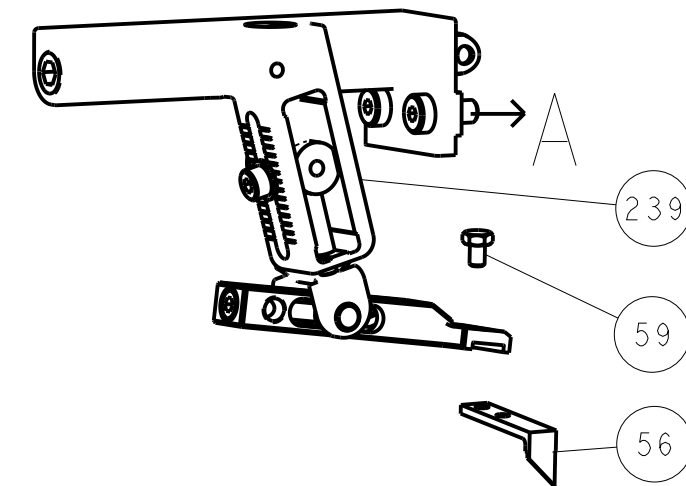
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	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
-	2	2	2	2	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
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1962431-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	-	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	1-2119644-4	RAM WASHER, PRECISION	38
-	1	1	1	1	3-1752356-9	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	1320908-3	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
-	1	1	1	1	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	1633861-1	SHEAR, FLOATING	9
1	1	1	1	1	2-1633917-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-3	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	5-1633962-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	3-1633860-1	CRIMPER, WIRE	1

THIS DRAWING IS A COMPUTER GENERATED DRAWING FOR THE ELECTRONIC COMPONENTS MANUFACTURING INDUSTRY. IT IS NOT TO BE USED FOR ANY OTHER PURPOSE. THE USER OF THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN: 21JAN2014 CMT: HOFFNER 22JAN2014 T. ELBIN 22JAN2014		 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 5 ANGLES ±.		NAME: Ocean Side Fed Applicator -	
MATERIAL: FINISH:		WEIGHT: -		SIZE: A CAGE CODE: 00779 DRAWING NO: C=2266203 RESTRICTED TO: -	
Customer Accessible Production Drawing				SCALE: 1:2 SHEET: 3 OF 4 REV: A	

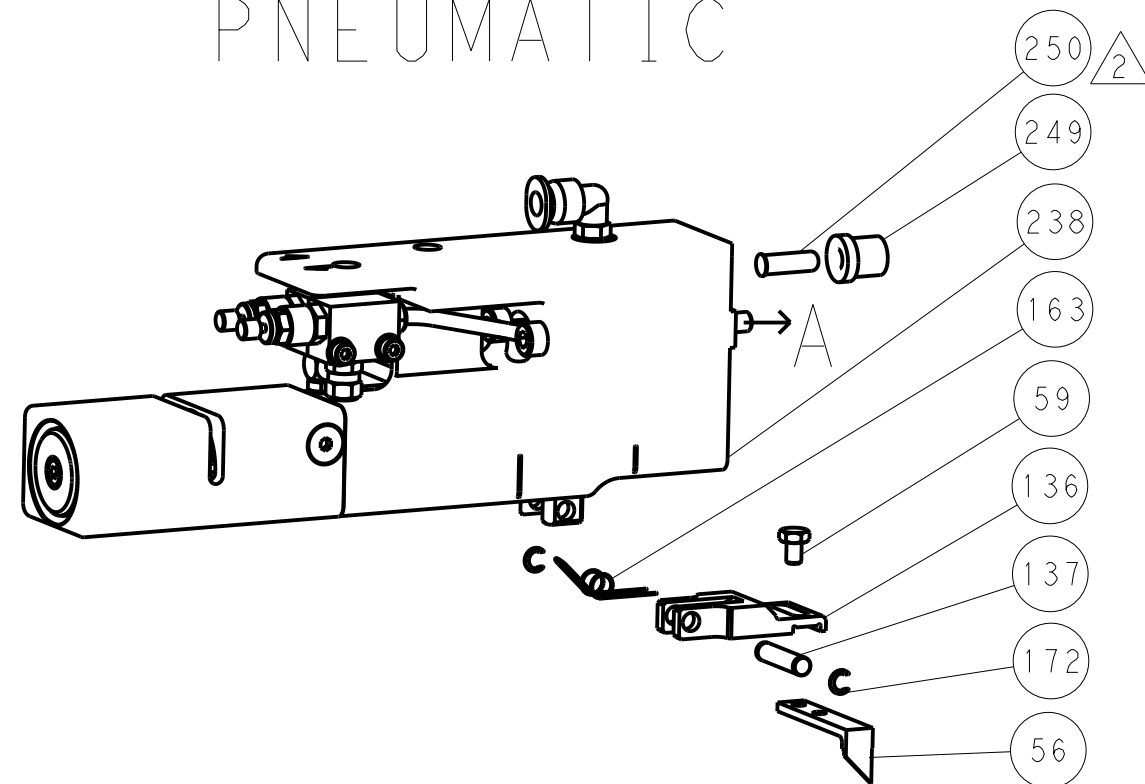
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

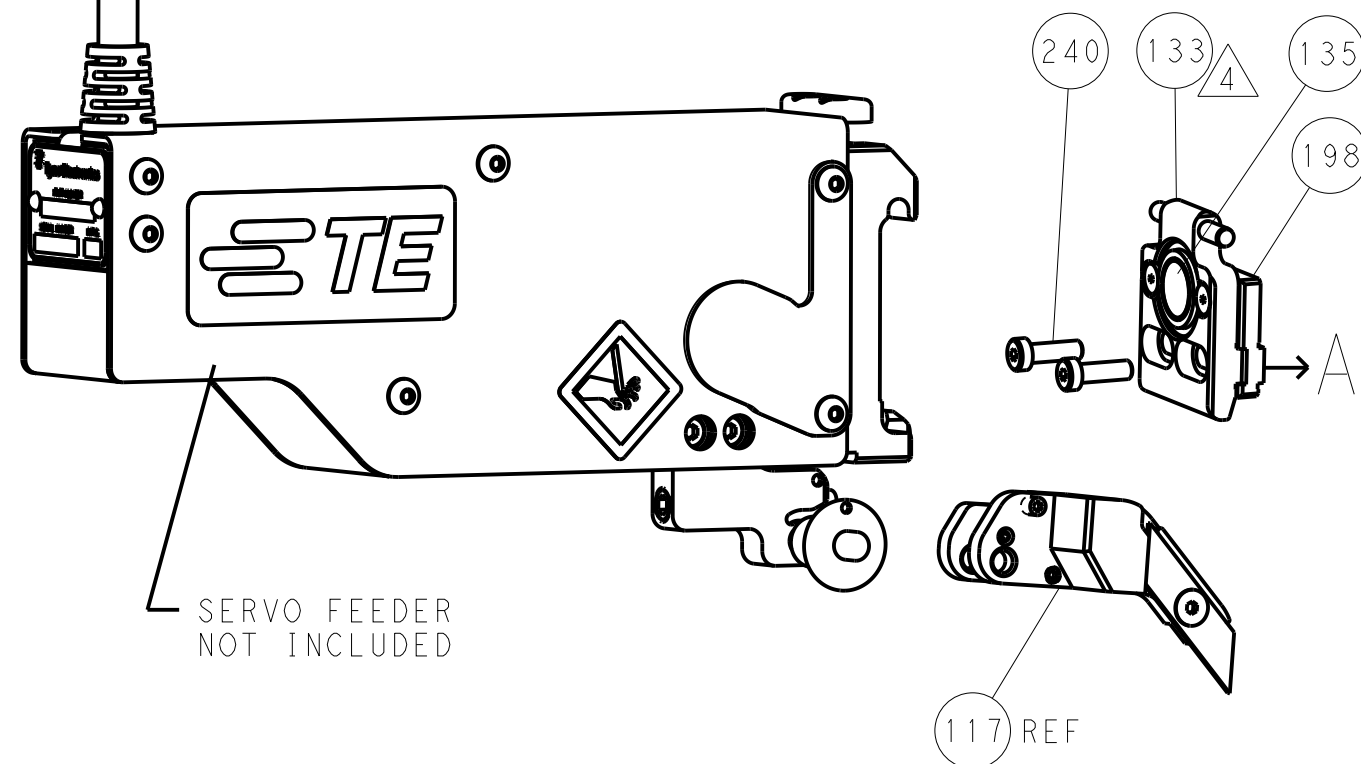
FEED TYPE MECHANICAL



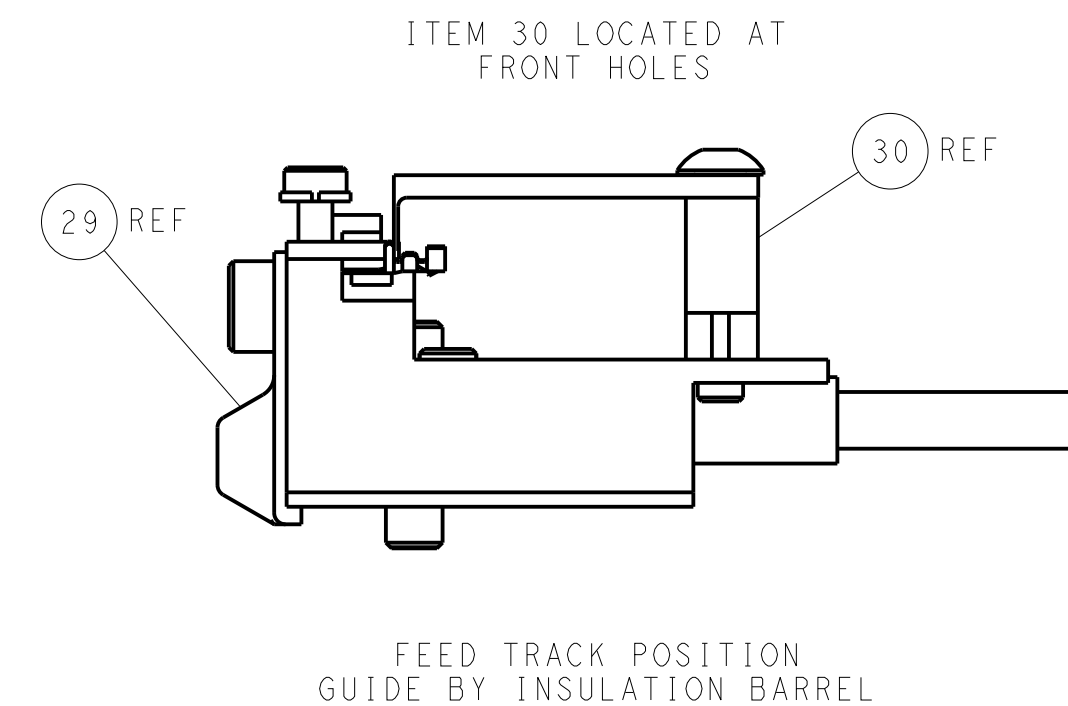
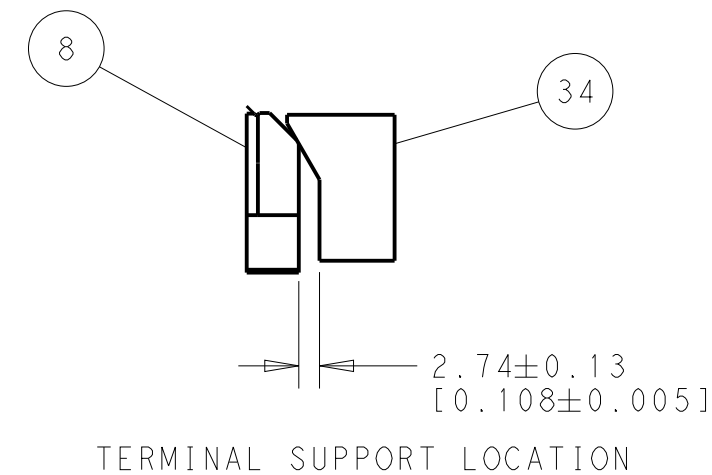
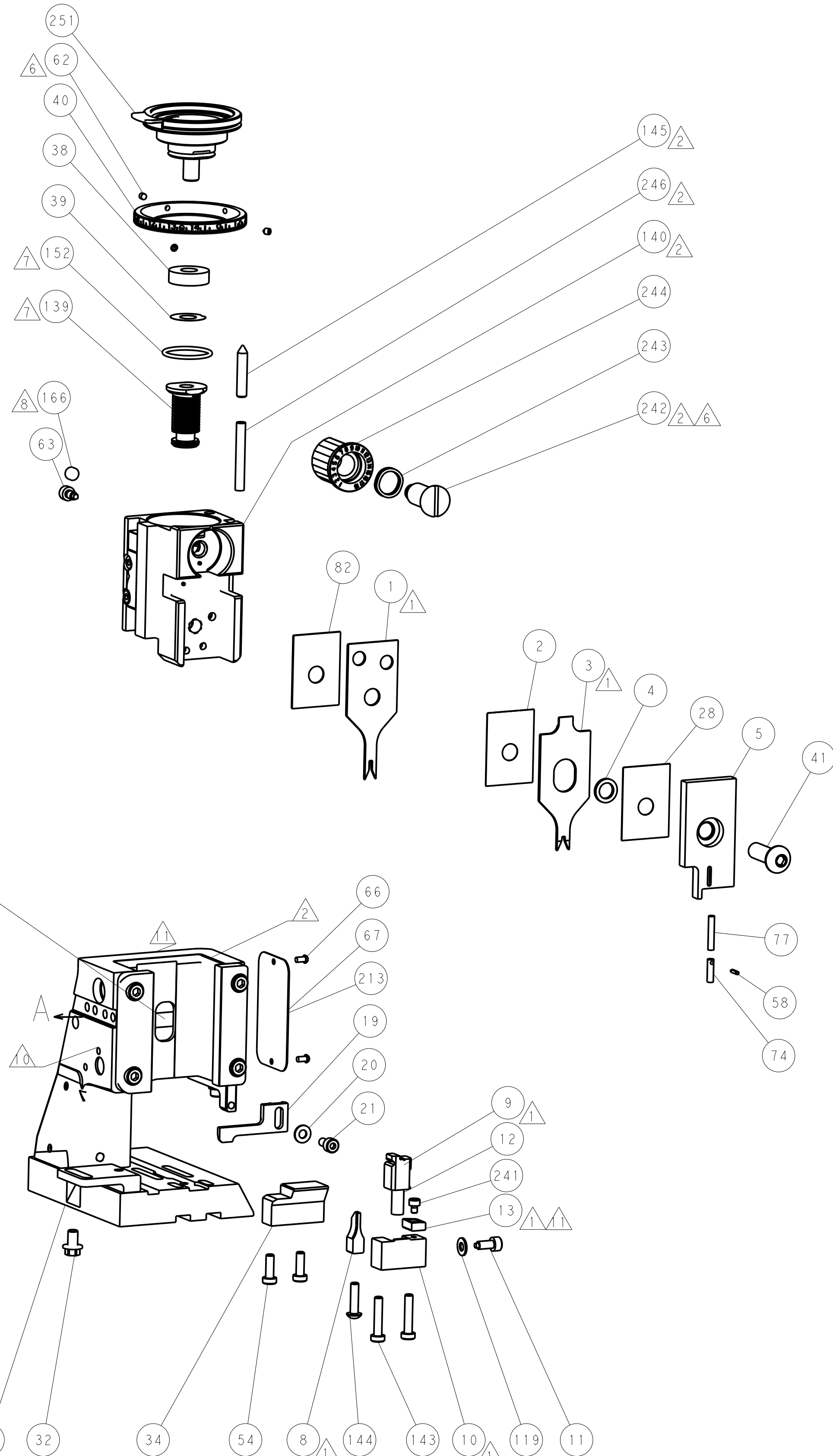
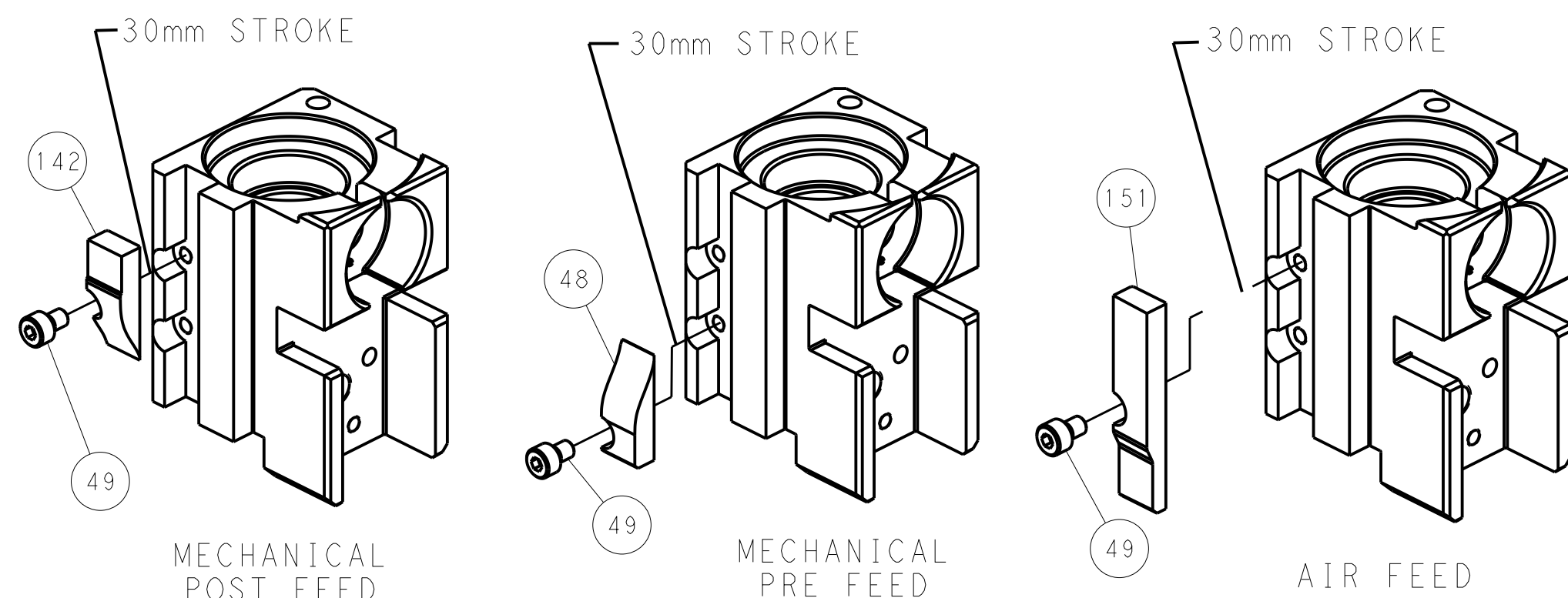
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. 2. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION.		OWN: HOFFNER 21JAN2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK: T. ELBIN 22JAN2014		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: T. ELBIN 22JAN2014	NAME: Ocean Side Feed Applicator	
0 PLC ±.5		PRODUCT SPEC	SIZE: CAGE CODE: DRAWING NO: 00779 ©=2266203	
1 PLC ±0.13		APPLICATION SPEC	RESTRICTED TO	
2 PLC ±0.013		WEIGHT	Customer Accessible Production Drawing	
3 PLC ±0.001		SCALE: 1:2	SHEET 4 OF 4	
4 PLC ±0.001		REV: A	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	
ANGLES				
FINISH				
MATERIAL				