

8

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RELEASED FOR PUBLICATION

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

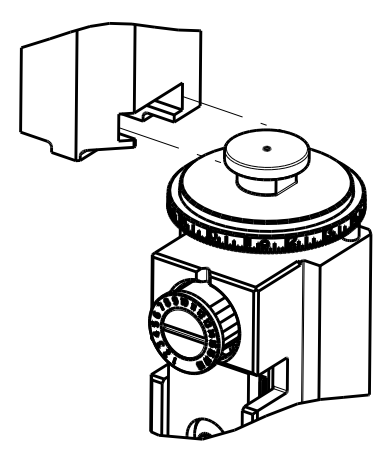
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2266081-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED
SERVO LATCH PLATE
SMART APPLICATOR

2119950-1
2119951-1
2161326-1

1338685-1
-
-

5-18022-5
8-2266081-5
8-2266081-4

2119641-1
1901094-3
-

2119799-1
2-1752354-1
-

2063440-1
2168400-6 (QUANTITY 2)
-

2266081-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED
SERVO LATCH PLATE
SMART APPLICATOR

2119949-1
2119951-1
2161326-1

1338685-1
-
-

5-18022-5
8-2266081-5
8-2266081-4

2119653-1
1901094-3
-

-
2-1752354-1
-

-
2168400-6 (QUANTITY 2)
-

2266081-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

MECHANICAL FEED
PNEUMATIC FEED

2119949-1
2119950-1

1338685-1
1338685-1

5-18022-5
5-18022-5

2119653-1
2119641-1

-
2119799-1

-
2063440-1

2266081-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

-

-

-

-

-

-

-

2266081-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

-

7-2266081-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.60 mm [1.02]

F

INSUL

4.06 mm [1.60]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: LEAR TERMINAL

LEAR CRIMP SPECIFICATION

TERMINAL NAME: MKS-Plus ROUND PIN PLUG 1.5

WIRE STRIP LENGTH

4.80-5.20 mm [1.89-.205 IN]

INSULATION DIAMETER RANGE

4.3

TERMINAL APPLICATION SPECIFICATION

LEAR 25719 Rev 3

TERMINALS APPLIED

TE TERMINAL

LEAR TERMINAL

TE SEAL

LEAR SEAL

CABLE DIAMETER

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

2.50mm2

1.55+/-0.05 [1.061+/-0.002]

7.1

1.50mm2

1.40+/-0.05 [1.055+/-0.002]

8.7

RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266081-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266081-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266081-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266081-6

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

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 37 & 242.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

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.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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.

WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.25.

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

APPLY TORO-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.

THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL.

-

-

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

-

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

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

DESCRIPTION

DATE

OWN

APVD

RELEASED

30DEC2013

LG

GB

-

1

1

1

1

1

2119082-2

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

-

-

-

-

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

455888-3

SPACER, CRIMPER

120

-

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

455888-6

SPACER, CRIMPER

82

-

2

2

2

2

2

2079383-4

SCR, BHSC, RoHS (M4 X 8)

79

-

1

1

1

1

1

1803096-1

EXTENSION PLATE

78

-

1

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

1

1

1

1

2119791-9

DEPRESSOR, WIRE

70

-

1

1

1

1

1

2119943-1

WASHER, SPACER

69

-

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

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

-

1

1

1

1

1

1-2119644-2

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

1752356-3

SUPPORT, TERMINAL

34

-

2

2

2

2

2

2079383-8

SCR, BHSC, RoHS (M4 X 16)

33

-

1

1

1

1

1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

-

1

1

1

1

1

1320908-4

SPACER, STRIP GUIDE

30

-

1

1

1

1

1

2119959-4

ASSEMBLY, STRIP GUIDE

29

-

1

1

1

1

1

455888-4

SPACER, CRIMPER

28

-

1

1

1

1

1

240792-1

DRAG, TERMINAL

25

-

1

1

1

1

1

1320928-4

STRIP GUIDE

24

-

1

1

1

1

1

2168083-2

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

318707-1

FLOATING SHEAR, FRONT

9

1

1

1

1

1

1

3-1803054-9

ANVIL, COMBINATION

8

-

1

1

1

1

1

1-240641-9

SPACER

7

-

-

-

-

-

-

-

-

6

-

1

1

1

1

1

2119781-5

DEPRESSOR, SHEAR

5

-

1

1

1

1

1

238011-7

BLOCK, CRIMPER SPACER

4

1

1

1

1

1

1

3-1633996-0

CRIMPER, INSULATION SPECIAL

3

-

1

1

1

1

1

455888-6

SPACER, CRIMPER

2

1

1

1

1

1

1

1633588-6

CRIMPER, WIRE

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

TE Connectivity

Harrisburg, PA 17105-3608

Ocean Side Feed

Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2266081

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

A

8

7

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

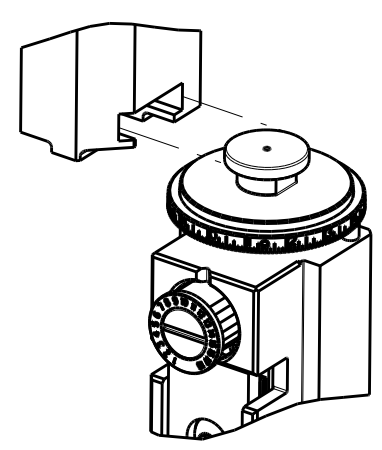
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2266081-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED
SERVO LATCH PLATE
SMART APPLICATOR

2119950-1
2119951-1
2161326-1

1338685-1
-
-

5-18022-5
8-2266081-5
8-2266081-4

2119641-1
1901094-3
-

2119799-1
2-1752354-1
-

2063440-1
2168400-6 (QUANTITY 2)
-

2266081-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED
SERVO LATCH PLATE
SMART APPLICATOR

2119949-1
2119951-1
2161326-1

1338685-1
-
-

5-18022-5
8-2266081-5
8-2266081-4

2119653-1
1901094-3
-

-
2-1752354-1
-

-
2168400-6 (QUANTITY 2)
-

2266081-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

MECHANICAL FEED
PNEUMATIC FEED

2119949-1
2119950-1

1338685-1
1338685-1

5-18022-5
5-18022-5

2119653-1
2119641-1

-
2119799-1

-
2063440-1

2266081-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

-

-

-

-

-

-

-

2266081-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

-

7-2266081-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.60 mm [1.02]

F

INSUL

4.06 mm [1.60]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: LEAR TERMINAL

LEAR CRIMP SPECIFICATION

TERMINAL NAME: MKS-Plus ROUND PIN PLUG 1.5

WIRE STRIP LENGTH

4.80-5.20 mm [1.89-.205 IN]

INSULATION DIAMETER RANGE

4.3

TERMINAL APPLICATION SPECIFICATION

LEAR 25719 Rev 3

TERMINALS APPLIED

TE TERMINAL

LEAR TERMINAL

TE SEAL

LEAR SEAL

CABLE DIAMETER

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

2.50mm2

1.55+/-0.05 [1.061+/-0.002]

7.1

1.50mm2

1.40+/-0.05 [1.055+/-0.002]

8.7

RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266081-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266081-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266081-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266081-6

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

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 37 & 242.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

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.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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.

WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.25.

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

APPLY TORO-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.

THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL.

-

-

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

-

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

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

DESCRIPTION

DATE

OWN

APVD

RELEASED

30DEC2013

LG

GB

-

1

1

1

1

1

2119082-2

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

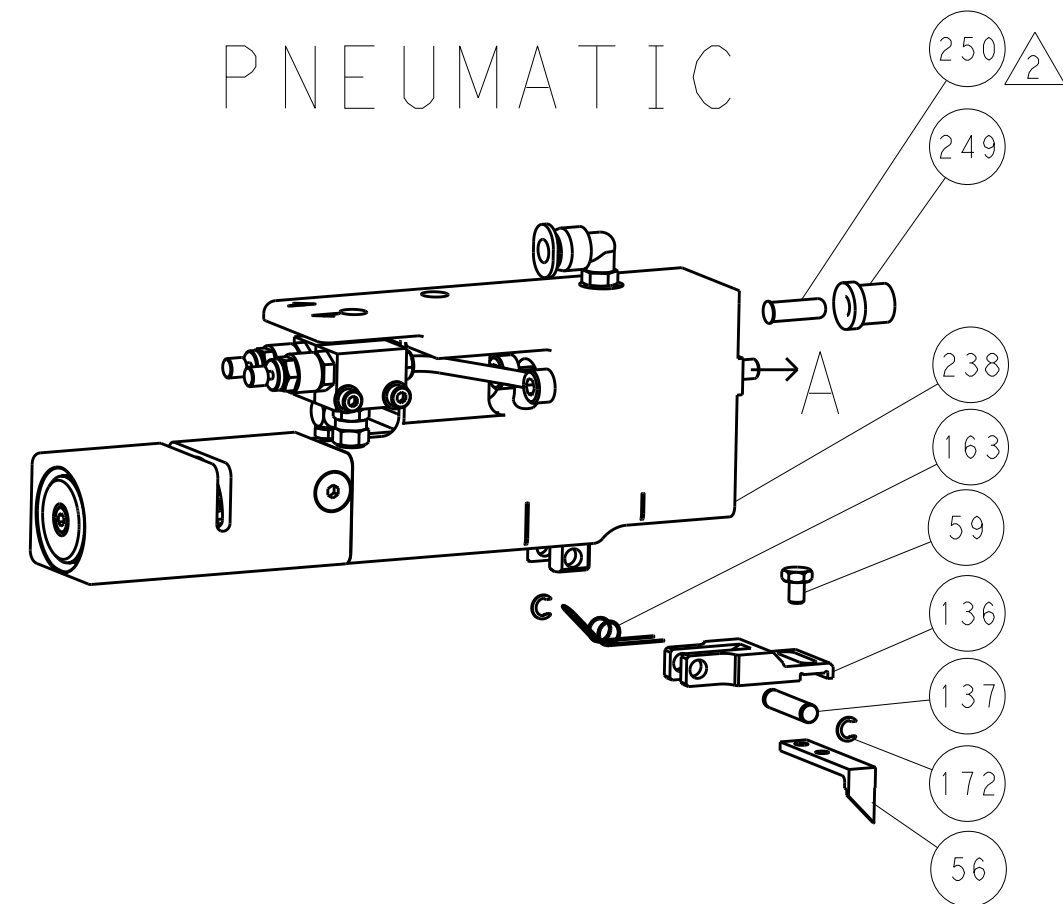
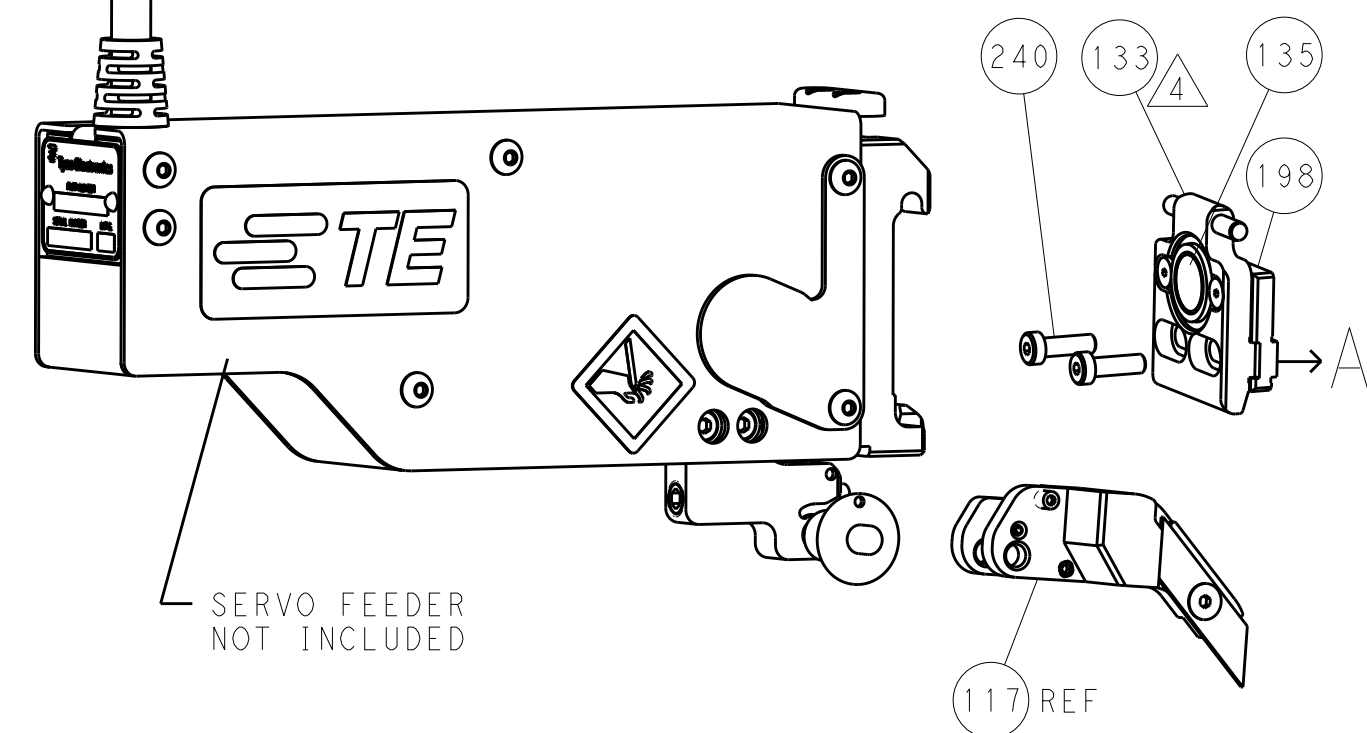
240

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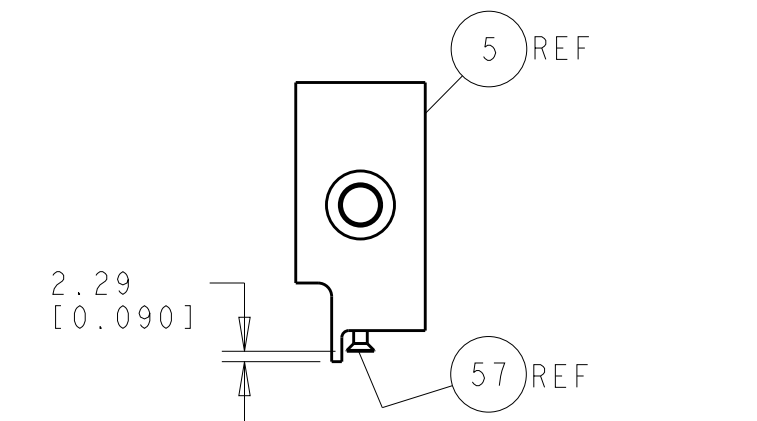
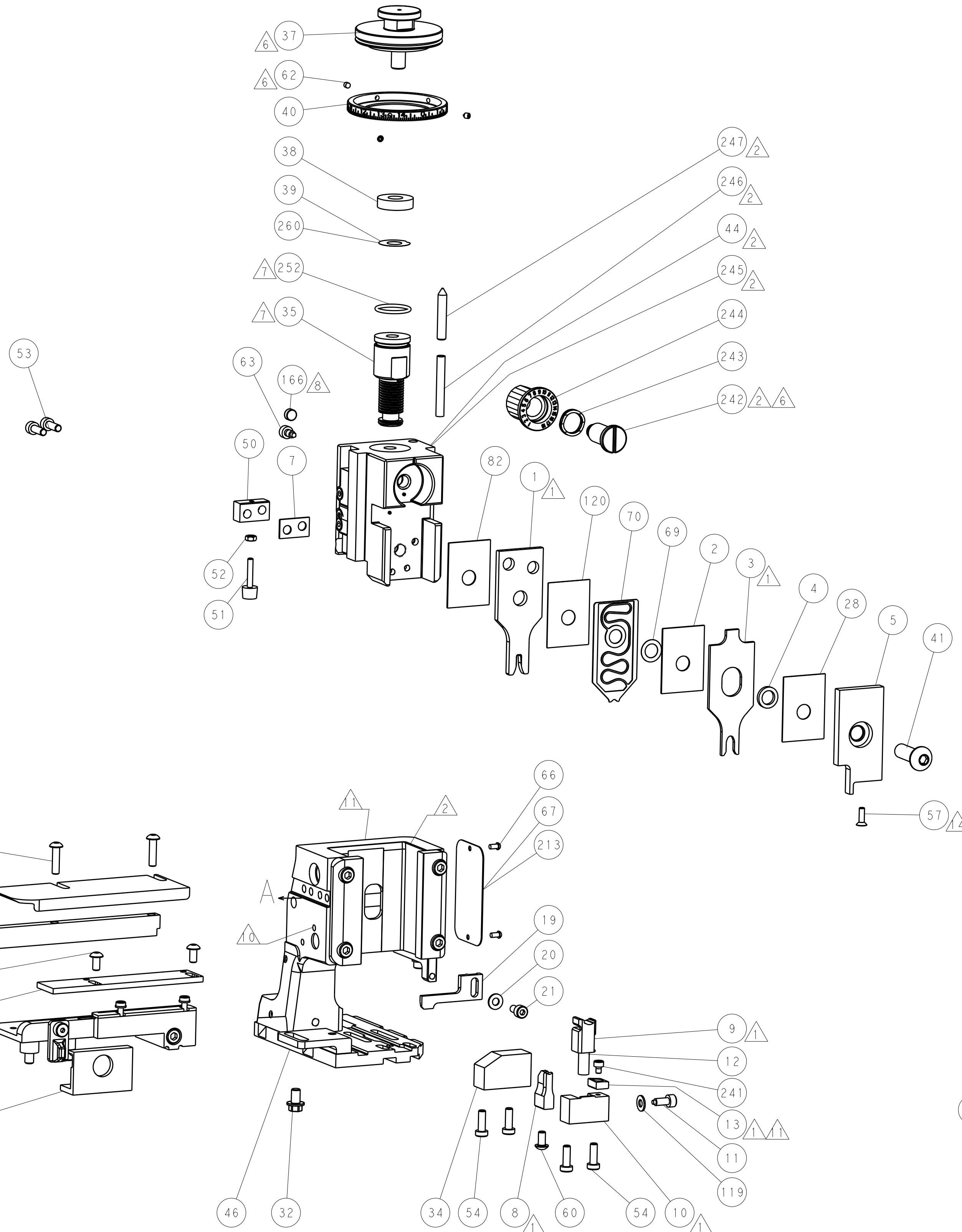
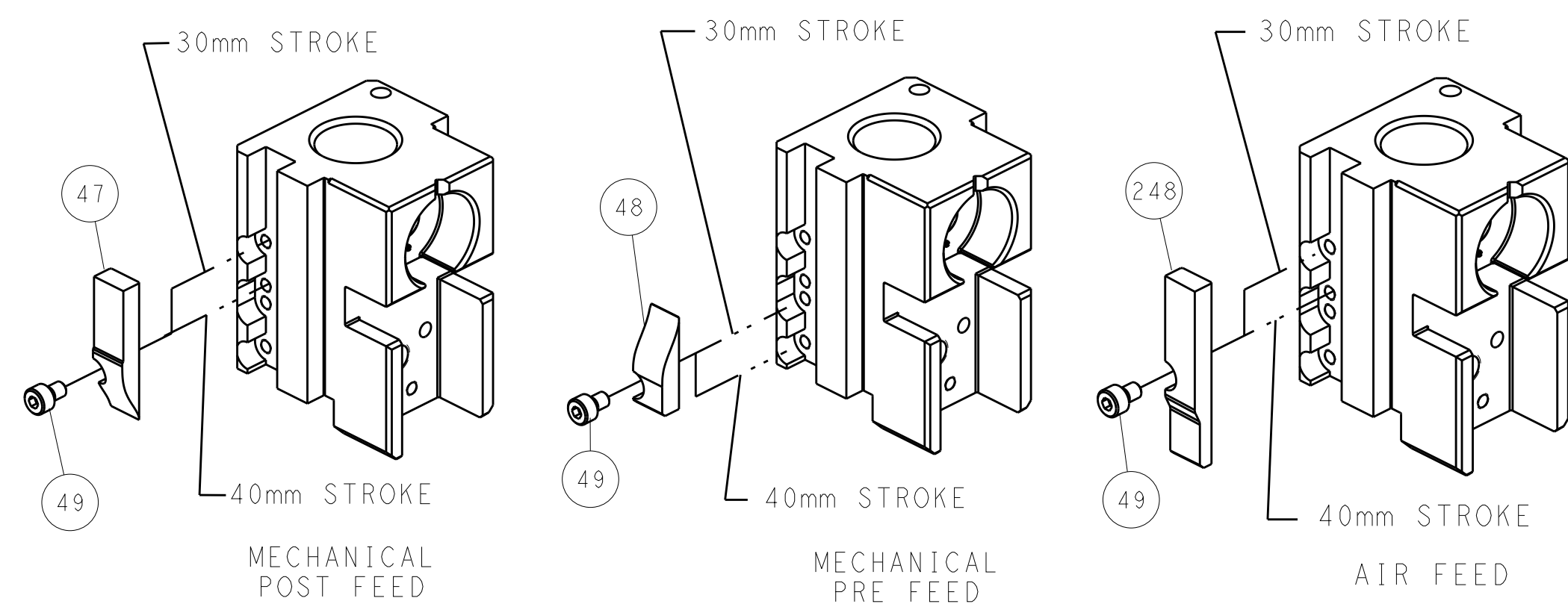
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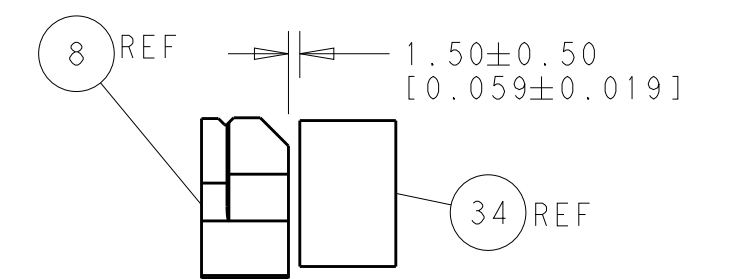
PNEUMATIC

SERVO
LATCH PLATE

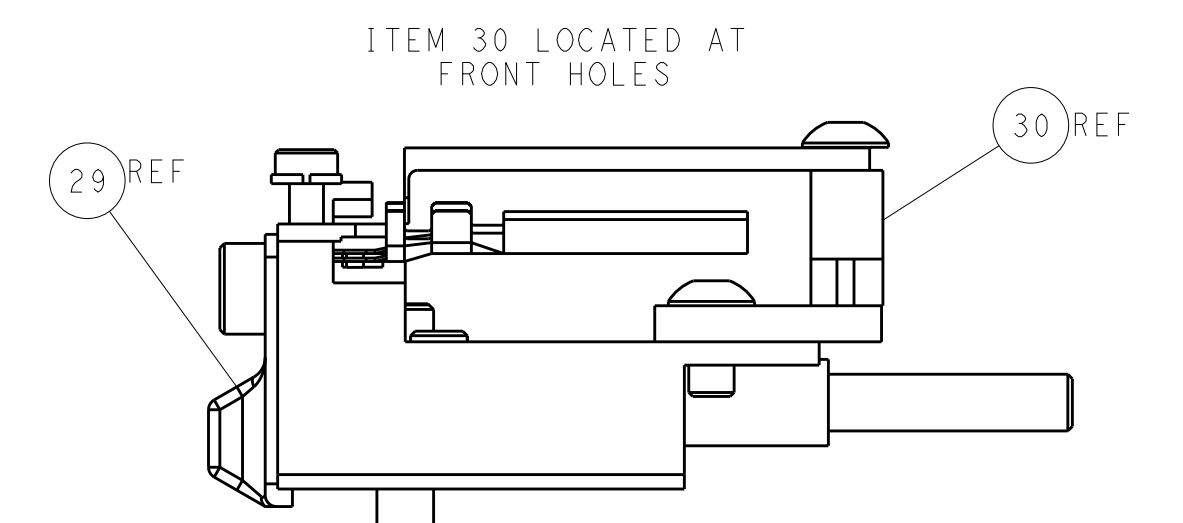
CAM POSITIONS



SHEAR DEPRESSOR DETAIL

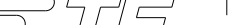
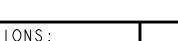


TERMINAL SUPPORT LOCATION



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 CONTROLLED DOCUMENT FOR YOUR ELECTRONIC INFORMATION SYSTEMS. IT IS SUBJECT TO THE SAME CONTROLS AS ANY OTHER DOCUMENT. ANY REVISIONS SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN 260C12013 R. O. WILSON CHK 290C12013 K. J. STAKEM APP'D 290C12013 T. L. FERCIN		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE CAD CODE DRAWING NO A1 00779 C-2266081	
MATERIAL -		FINISH -		WEIGHT -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV A	

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THIS DRAWING IS UNPUBLISHED.

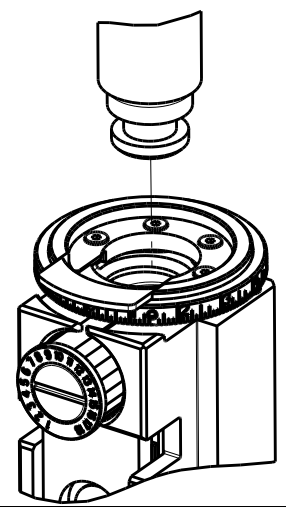
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2266081-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

CONVERT TO

SERVO LATCH PLATE

PART NUMBERS REQUIRED

2119951-1

-

8-2266081-5

1901094-3

2-1752354-1

2168400-6 (QUANTITY 2)

CONVERT TO

SMART APPLICATOR

PART NUMBERS REQUIRED

2161326-1

-

8-2266081-4

-

-

-

CONVERT TO

MECHANICAL FEED

PART NUMBERS REQUIRED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

-

CONVERT TO

SERVO LATCH PLATE

PART NUMBERS REQUIRED

2119951-1

-

8-2266081-5

1901094-3

2-1752354-1

2168400-6 (QUANTITY 2)

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CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

CONVERT TO

-

PART NUMBERS REQUIRED

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CONVERT TO

-

PART NUMBERS REQUIRED

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CRIMP

SIZE

TYPE

WIRE

2.60 mm [.102]

F

INSUL

4.06 mm [.160]

O

APPLICATOR INSTRUCTIONS

408-10389



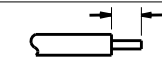
TERMINAL DATA: LEAR TERMINAL

LEAR CRIMP SPECIFICATION

TERMINAL NAME: MKS-Plus ROUND PIN PLUG 1.5

WIRE STRIP LENGTH

4.80-5.20 mm [.189-.205 IN]



INSULATION DIAMETER RANGE

Ø



TERMINAL APPLICATION SPECIFICATION

LEAR 25719 Rev 3

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TERMINALS APPLIED

TE TERMINAL	LEAR TERMINAL	TE SEAL	LEAR SEAL	CABLE DIAMETER
2113391-1	25719.201.184	1572316-1	16695.627.642	2.20-3.00
		1572316-2	16695.627.619	2.20-3.00
		1572316-3	7814140	2.20-3.00
		1572316-4	1533994	2.20-3.00
		1572316-5	16276.627.642	2.20-3.00
		1572316-6	801DL2	2.20-3.00

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



2.50mm2

1.55+/-0.05 [.061+/-0.002]

7.1

1.50mm2

1.40+/-0.05 [.055+/-0.002]

8.7

RECOMMENDED SPARE PARTS

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: 8-2266081-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266081-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266081-5

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 & 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 APPLIES TERMINAL WITH A SEAL.

13. 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.

14. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL.

6

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2119083-1

RETAINER, INSULATION DIAL

242

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7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

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2

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2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

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-

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-

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2119580-1

MECHANICAL FEED ASSEMBLY

239

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2063440-1

AIR FEED MODULE

238

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2119740-2

TAG,IDENTIFICATION

213

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1901094-3

SPACER, FEEDER

198

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

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240638-1

SPRING, FEED FINGER

163

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8-21084-1

O-RING, .801 ID, .070 DIA. MAT.

152

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2119641-2

FEED CAM, AIR FEED

151

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2119798-2

DETENT PIN

145

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2079383-8

SCR, BHSC, RoHS (M4 X 16)

144

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4

4

4

4

2168400-5

SHCS, LOW HEAD, RoHS, M4 X 20

143

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2119653-2

FEED CAM, POST FEED

142

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2-2119656-2

APPLICATOR BASIC ASSEMBLY, SF

141

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2119650-1

RAM, ASIAN STYLE, SIDE FEED

140

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2119092-2

BOLT, ADJUSTMENT

139

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3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

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2119799-1

HOLDER,FEED FINGER, AF

136

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REF

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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1633743-1

SERVO FEED LATCH ASM

133

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455888-3

SPACER, CRIMPER

120

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1-18028-2

WASHER, FLAT, REG M4

119

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REF

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2119944-1

FEED FINGER ASSEMBLY,SF

117

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455888-6

SPACER, CRIMPER

82

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2079383-4

SCR, BHSC, RoHS (M4 X 8)

79

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1803096-1

EXTENSION PLATE

78

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2119956-1

DOCUMENTATION PACKAGE

71

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2119791-9

DEPRESSOR, WIRE

70

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2119943-1

WASHER, SPACER

69

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2119740-1

TAG,IDENTIFICATION

67

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2

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2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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2119793-1

LIMITER, ADJUSTMENT BOLT

63

6

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3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

13

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5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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985575-3

SCR, FLT SKT HD CAP M3 X 10.0

57

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1338685-1

PAWL, FEED

56

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2168083-3

SCR, SKT HD CAP, RoHS, M4 X 12.0

53

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5018030-1

NUT, HEX, REG, RoHS, M3

52

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811242-5

BUMPER, HOLD DOWN

51

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690753-2

SPACER, TONKER

50

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18023-9

SCR, SKT HD CAP M4 X 6.0

49

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2119652-1

FEED CAM, PRE FEED

48

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2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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2119957-1

APPLICATOR SHIM PACK

39

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1-2119644-2

RAM WASHER, PRECISION

38

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1752356-3

SUPPORT, TERMINAL

34

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2079383-8

SCR, BHSC, RoHS (M4 X 16)

33

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2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

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1320908-4

SPACER, STRIP GUIDE

30

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2119959-4

ASSEMBLY, STRIP GUIDE

29

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455888-4

SPACER, CRIMPER

28

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240792-1

DRAG, TERMINAL

25

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1320928-4

STRIP GUIDE

24

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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1-18028-2

WASHER, FLAT, REG M4

20

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2119533-1

STRIPPER, SIDE FEED

19

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2119806-1

INSERT, SHEAR

13

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3-22280-3

SPRING, COMPRESSION

12

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1-356885-4

STOP, SHEAR

11

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2119805-1

SHEAR HOLDER, FRONT

10

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318707-1

FLOATING SHEAR, FRONT

9

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3-1803054-9

ANVIL, COMBINATION

8

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1-240641-9

SPACER

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2119781-5

DEPRESSOR, SHEAR

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238011-7

BLOCK, CRIMPER SPACER

4

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3-1633996-0

CRIMPER, INSULATION SPECIAL

3

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455888-6

SPACER, CRIMPER

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1633588-6

CRIMPER, WIRE

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77

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21

PART NO

DESCRIPTION

ITEM NO

251

250

249

246

244

243

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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2119782-1

FINE ADJUST HEAD ASM, PACIFIC STYLE

251

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2119640-1

PUSH ROD, AIR FEED

250

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2079988-1

BUSHING, LCH5-12, MISUMI

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1-22279-3

SPRING, COMPRESSION

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2119082-2

CAM, SNAIL, INSULATION ADJUSTMENT

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2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

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2119782-1

FINE ADJUST HEAD ASM, PACIFIC STYLE

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2119640-1

PUSH ROD, AIR FEED

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2079988-1

BUSHING, LCH5-12, MISUMI

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SPRING, COMPRESSION

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WASHER, WAVE SPRING, CREST-TO-CREST

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FINE ADJUST HEAD ASM, PACIFIC STYLE

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PUSH ROD, AIR FEED

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SPRING, COMPRESSION

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CAM, SNAIL, INSULATION ADJUSTMENT

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WASHER, WAVE SPRING, CREST-TO-CREST

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FINE ADJUST HEAD ASM, PACIFIC STYLE

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CAM, SNAIL, INSULATION ADJUSTMENT

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WASHER, WAVE SPRING, CREST-TO-CREST

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FINE ADJUST HEAD ASM, PACIFIC STYLE

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PUSH ROD, AIR FEED

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BUSHING, LCH5-12, MISUMI

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SPRING, COMPRESSION

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CAM, SNAIL, INSULATION ADJUSTMENT

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WASHER, WAVE SPRING, CREST-TO-CREST

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FINE ADJUST HEAD ASM, PACIFIC STYLE

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PUSH ROD, AIR FEED

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BUSHING, LCH5-12, MISUMI

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SPRING, COMPRESSION

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CAM, SNAIL, INSULATION ADJUSTMENT

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WASHER, WAVE SPRING, CREST-TO-CREST

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BUSHING, LCH5-12, MISUMI

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CAM, SNAIL, INSULATION ADJUSTMENT

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WASHER, WAVE SPRING, CREST-TO-CREST

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FINE ADJUST HEAD ASM, PACIFIC STYLE

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BUSHING, LCH5-12, MISUMI

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SPRING, COMPRESSION

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CAM, SNAIL, INSULATION ADJUSTMENT

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WASHER, WAVE SPRING, CREST-TO-CREST

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FINE ADJUST HEAD ASM, PACIFIC STYLE

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2119640-1

PUSH ROD, AIR FEED

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2079988-1

BUSHING, LCH5-12, MISUMI

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SPRING, COMPRESSION

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2119082-2

CAM, SNAIL, INSULATION ADJUSTMENT

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WASHER, WAVE SPRING, CREST-TO-CREST

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2119782-1

FINE ADJUST HEAD ASM, PACIFIC STYLE

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2119640-1

PUSH ROD, AIR FEED

250

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2079988-1

BUSHING, LCH5-12, MISUM

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

D

C

B

A

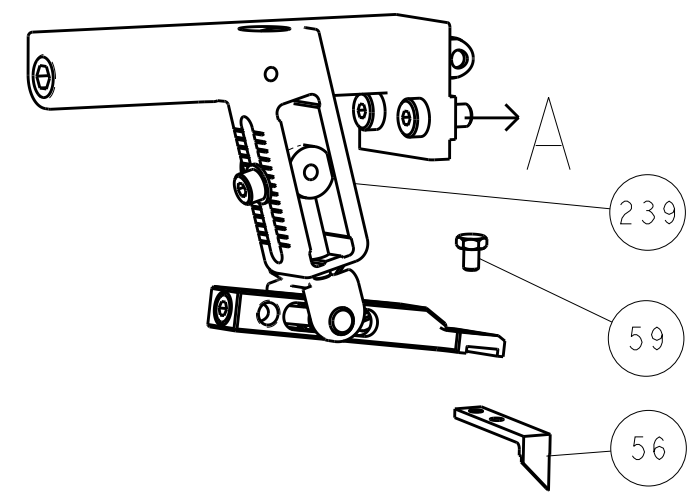
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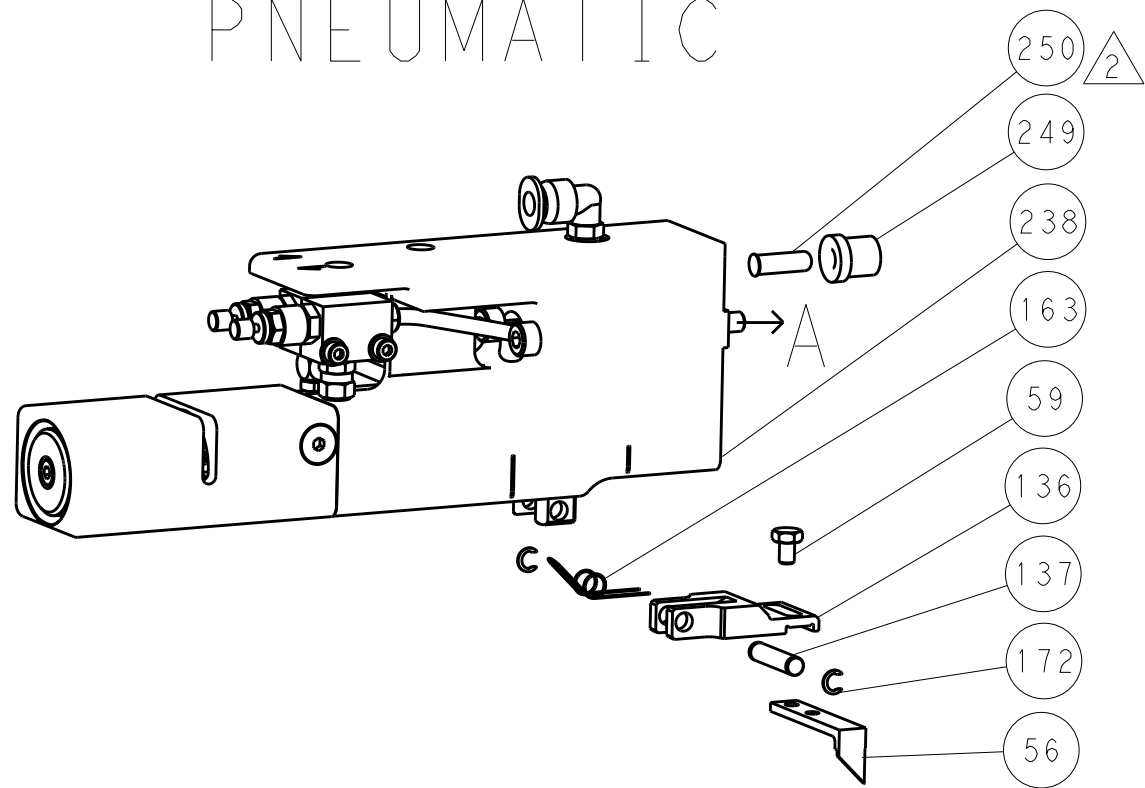
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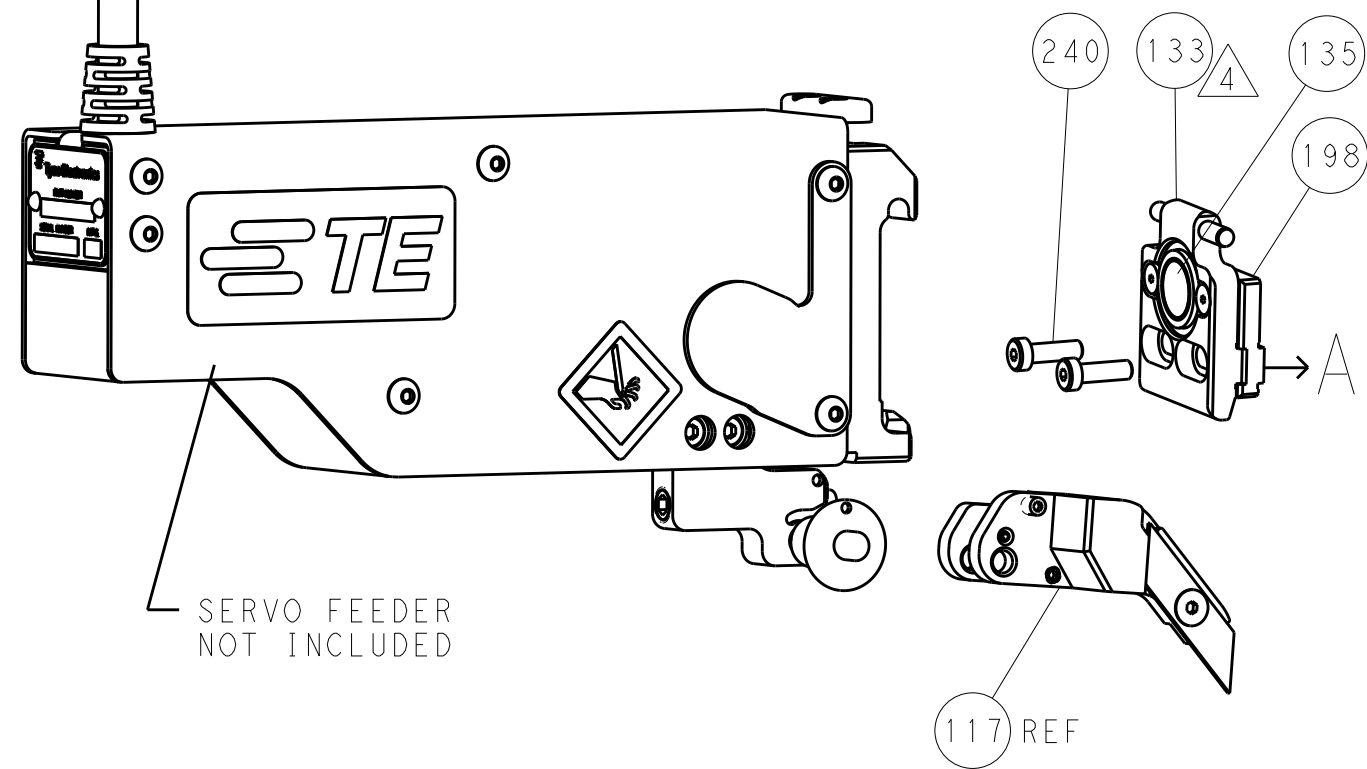
FEED TYPE MECHANICAL



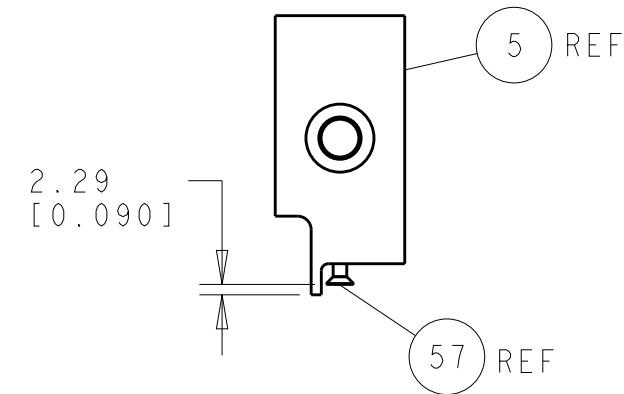
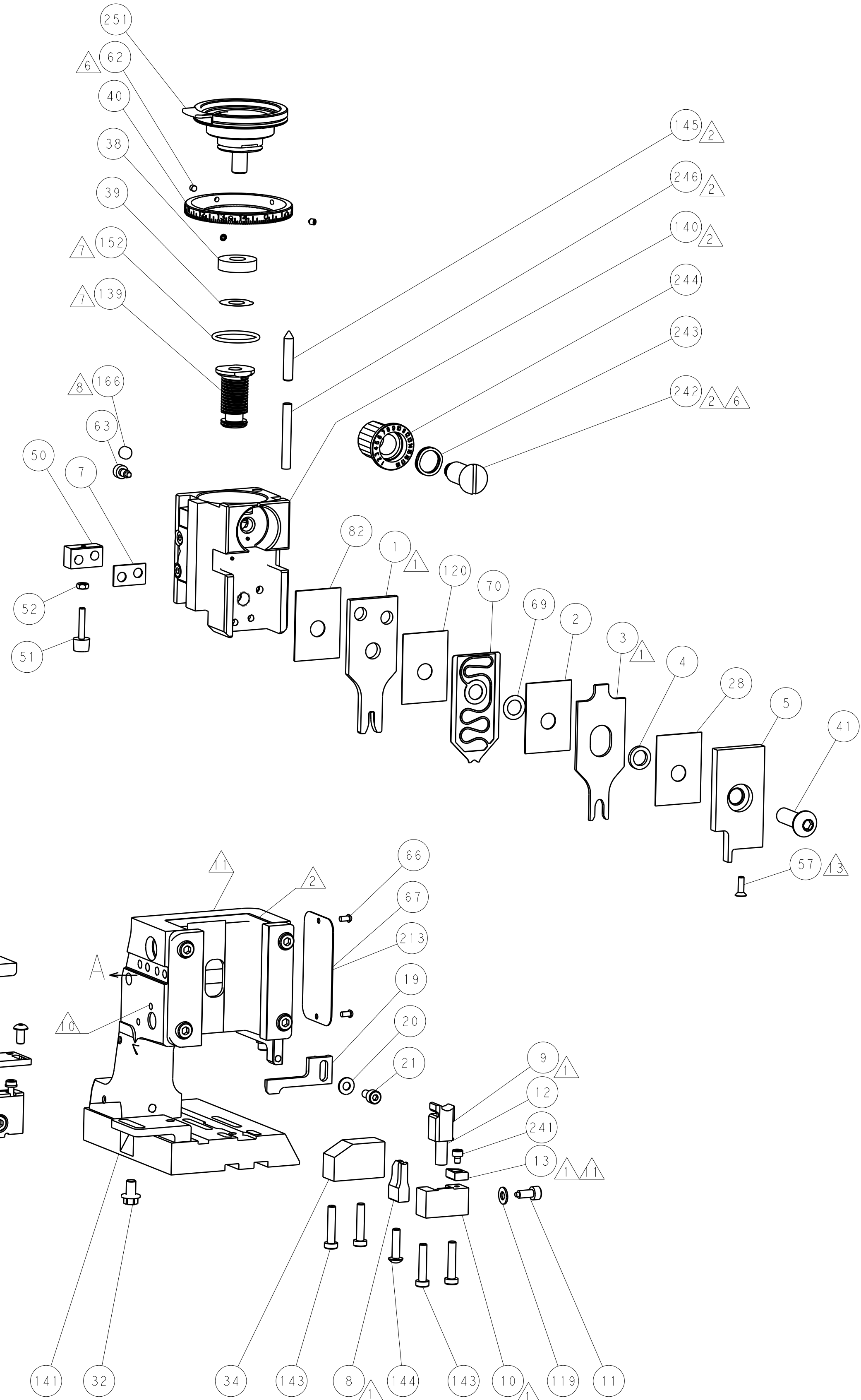
PNEUMATIC



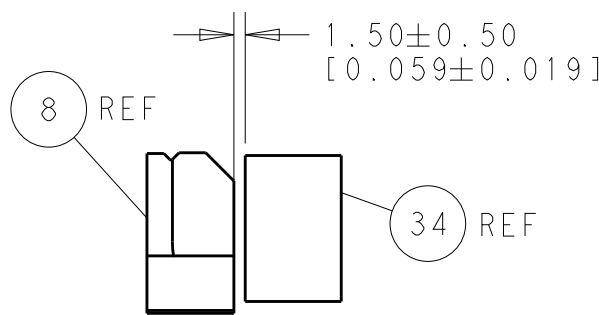
SERVO LATCH PLATE



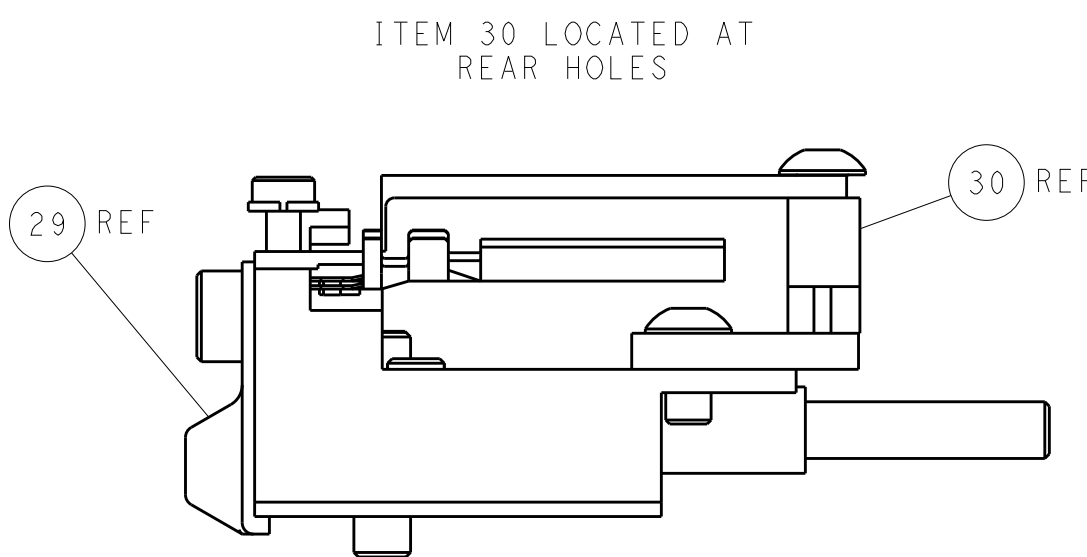
CAM POSITIONS



SHEAR DEPRESSOR DETAIL

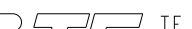


TERMINAL SUPPORT LOCATION



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN: R. Q. WILSON 26OCT2013 CHK: K. J. STAKEM 29OCT2013 APPR: T. L. ELLIN 29OCT2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME	
mm		0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001		APPLICATION SPEC		Ocean Side Feed Applicator	
						SIZE	
MATERIAL		FINISH		WEIGHT		CAGE CODE	
-		-		-		A 00779	
Customer Accessible Production Drawing				SCALE		DRAWING NO	
				1:2		C=2266081	
				SHEET		RESTRICTED TO	
				4		-	
				OF		REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION