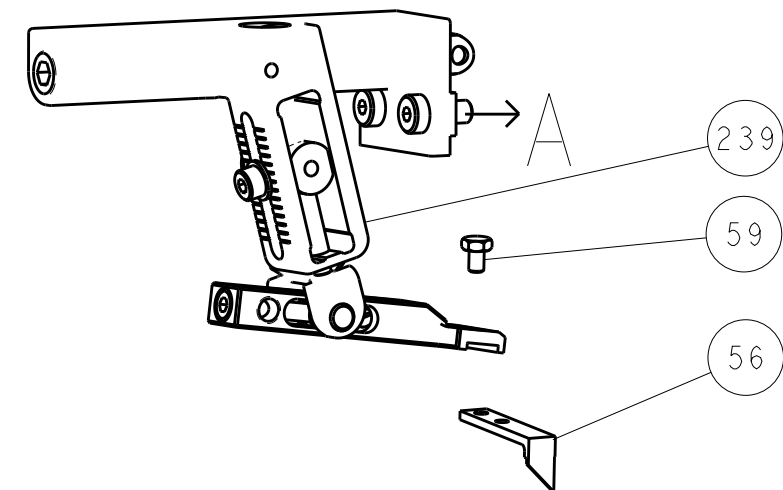
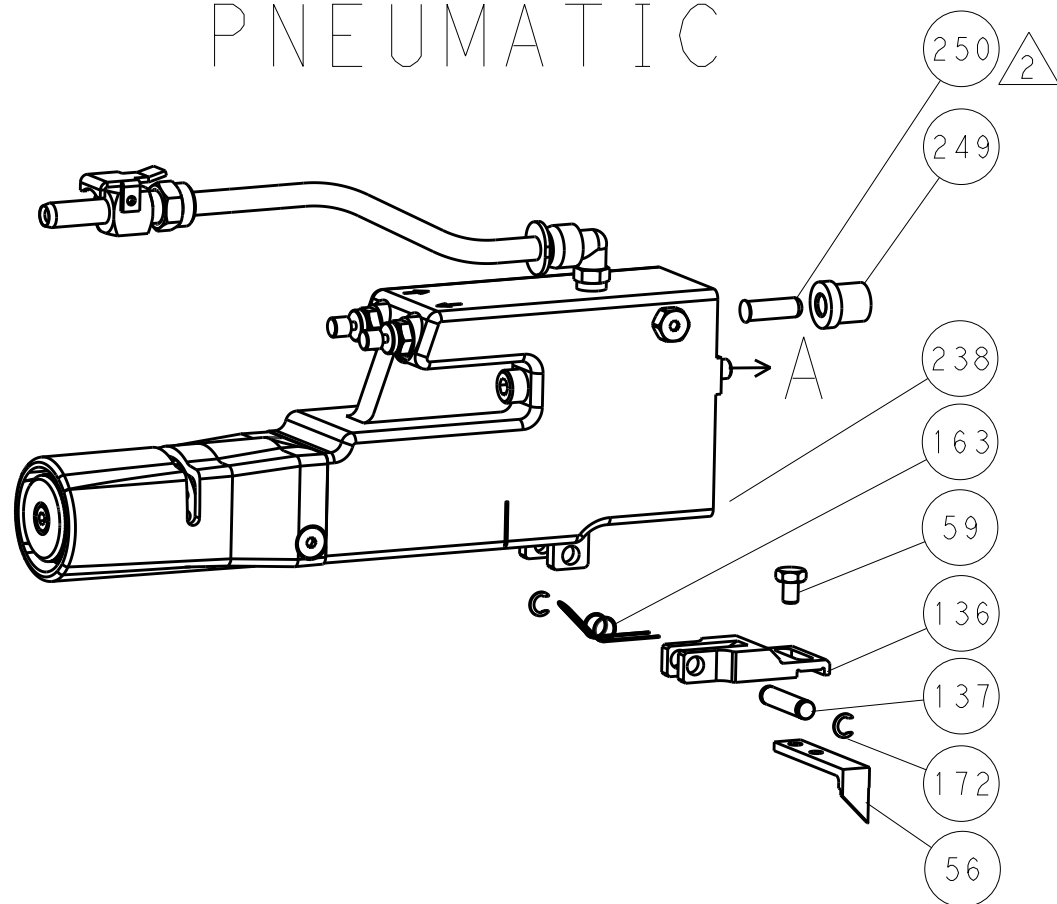


LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

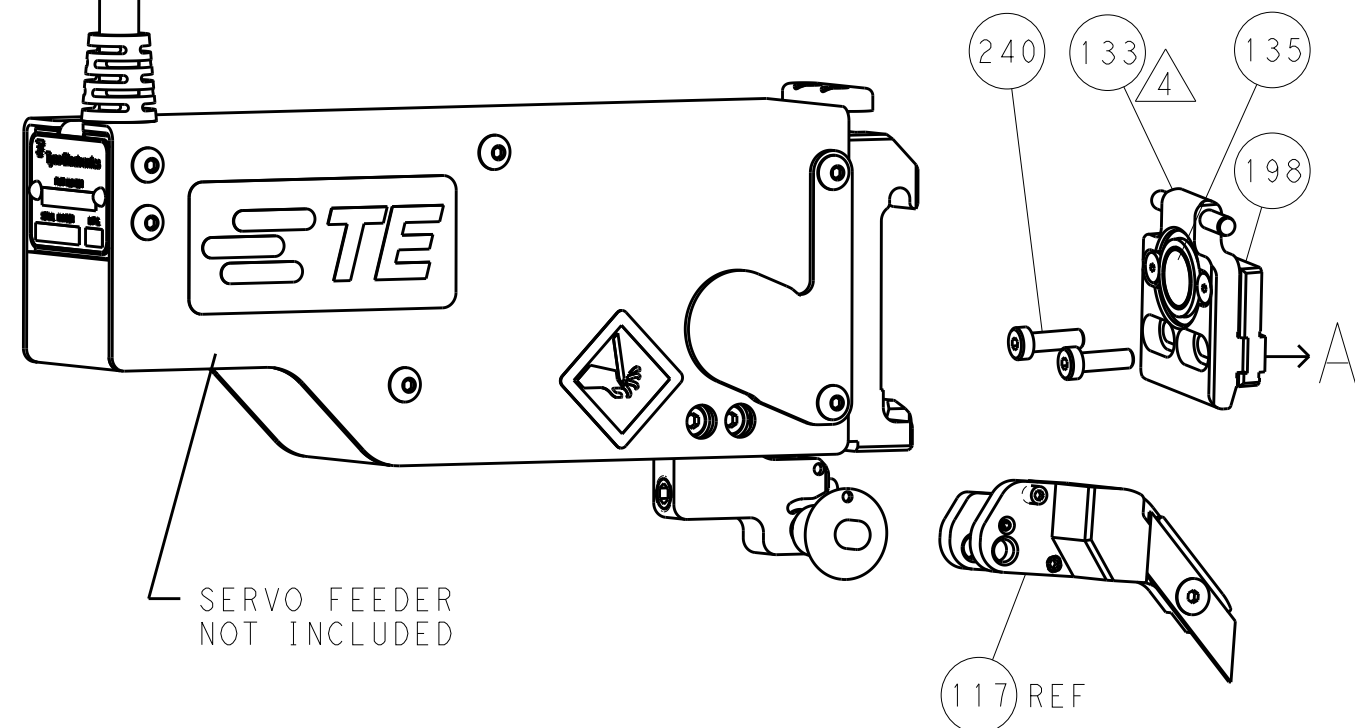
FEED TYPE
MECHANICAL



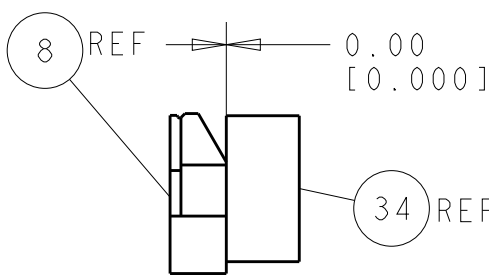
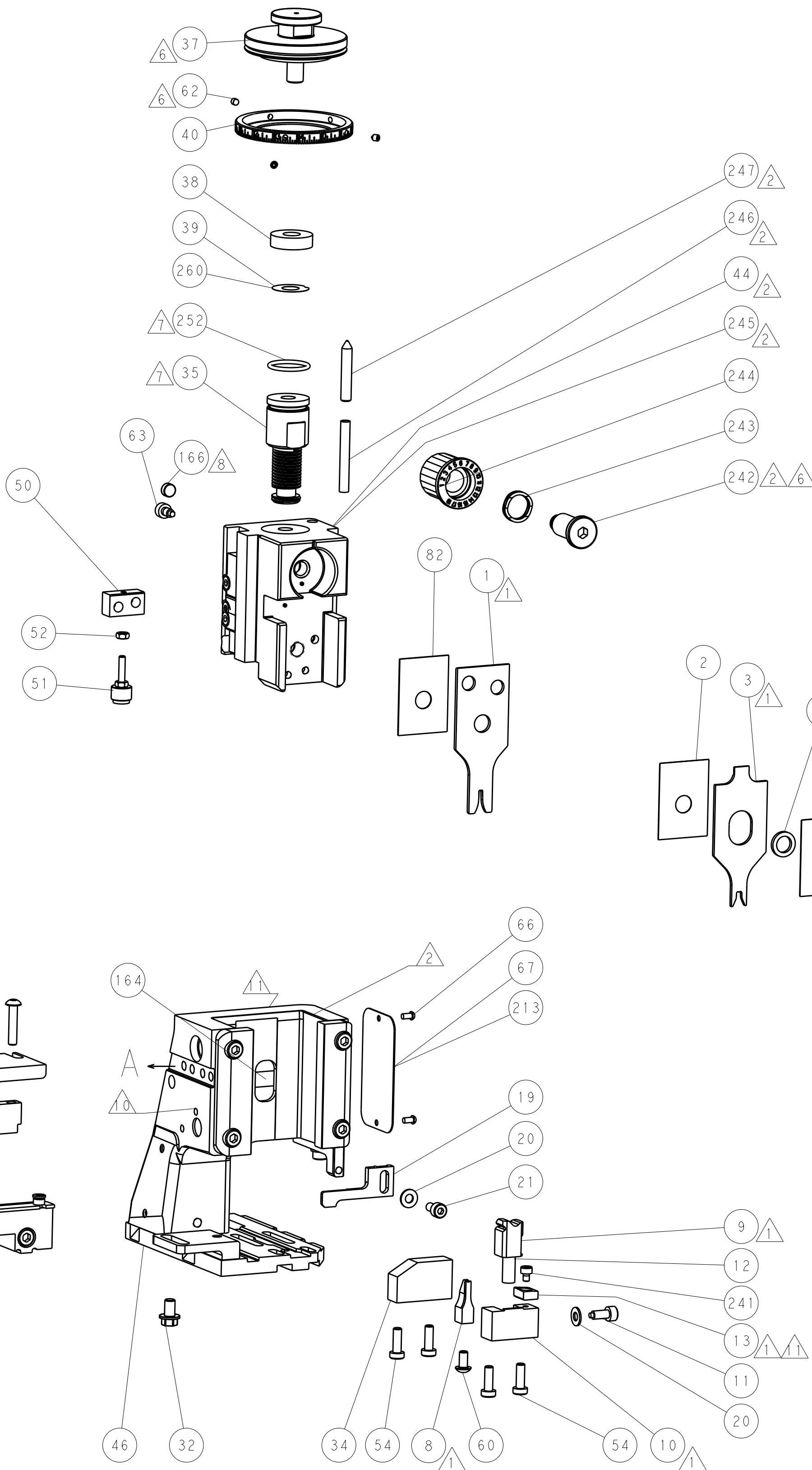
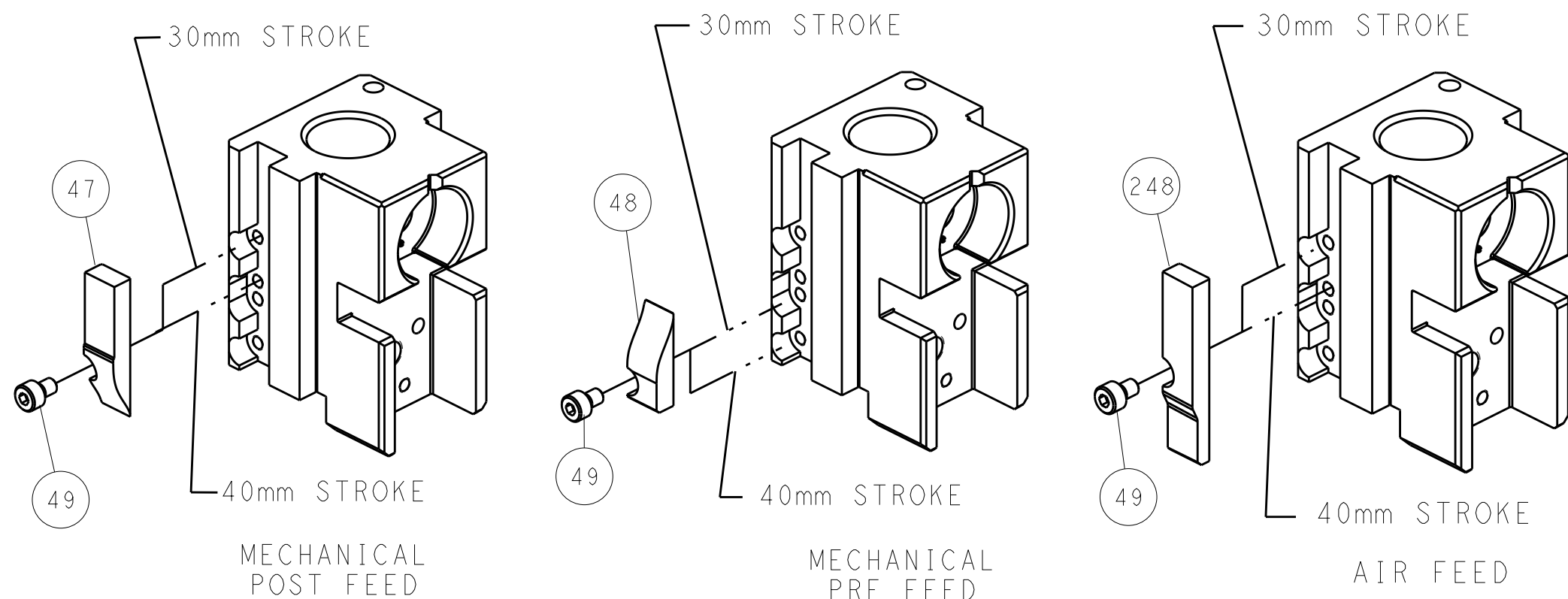
PNEUMATIC



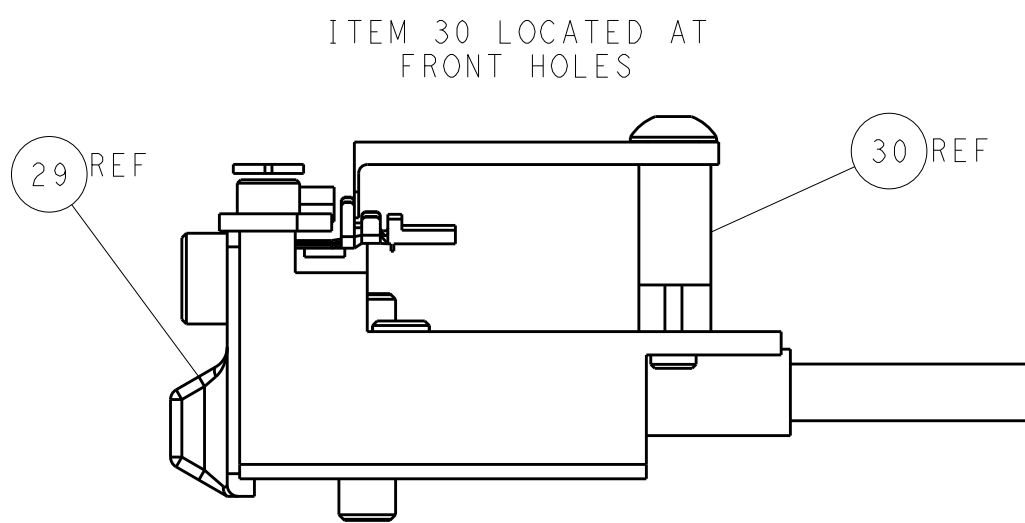
SERVO
LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION.				DWN: K. HUANG 23OCT2014 CHK: L. ZHANG 23OCT2014 APVD: J. GUO 23OCT2014				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES FINISH				NAME: Ocean Side Feed Applicator			
MATERIAL: -				WEIGHT: -				SIZE: A11 00779 C=2266554			
Customer Accessible Production Drawing				SCALE: 1:2				SHEET 2 OF 4 REV A			

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

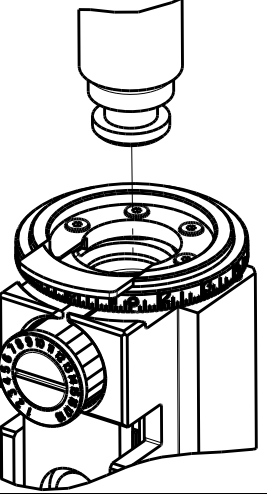
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2266554-1

2-2266554-2

2-2266554-5

2-2266554-7

7-2266554-7

REVISION

A

A

A

A

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FINE CRIMP HEIGHT ADJUST

FINE CRIMP HEIGHT ADJUST

FINE CRIMP HEIGHT ADJUST

CRIMP TOOLING KIT

FEED TYPE

MECHANICAL

PNEUMATIC

SERVO
LATCH PLATE

NONE

-

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

MECHANICAL FEED

PNEUMATIC FEED

-

-

PART NUMBERS REQUIRED

2119950-1

2119951-1

2161326-1

2119949-1

2119951-1

2161326-1

2119949-1

2119950-1

-

-

-

2138685-1

-

-

1338685-1

-

-

1338685-1

1338685-1

-

-

-

5-18022-5

8-2266554-5

8-2266554-4

5-18022-5

8-2266554-5

8-2266554-4

5-18022-5

5-18022-5

-

-

-

2119641-2

1901094-3

-

2119653-2

-

-

2119653-2

2119641-2

-

-

-

2119799-1

-

-

-

-

-

-

2119799-1

-

-

-

2063440-1

2168400-6 (QUANTITY 2)

-

-

2168400-6 (QUANTITY 2)

-

-

2063440-1

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.78 mm [.070]

F

INSUL

2.90 mm [.114]

F

APPLICATOR INSTRUCTIONS

408-10389



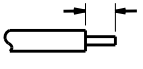
TERMINAL DATA: JST TERMINAL

JST CRIMP SPECIFICATION

TERMINAL NAME: SDN CONNECTOR

WIRE STRIP LENGTH

1.90-2.30 mm [.075-.091 IN]



INSULATION DIAMETER RANGE

Ø1.60-3.00 mm [.063-.118 IN]

TERMINAL APPLICATION SPECIFICATION

HM-0004 Rev R1

-

-

-

TERMINALS APPLIED

TE TERMINAL

JST TERMINAL

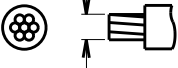
TE TERMINAL

JST TERMINAL

1572485-1

SDN-21T-P1.5

WIRE SIZE



CRIMP HEIGHT

mm [INCH]



CRIMP HEIGHT

REFERENCE SETTING



18 AWG

1.05+/-0.05 [.041+/-0.002]

7.0

20 AWG

1.00+/-0.05 [.039+/-0.002]

7.4

22 AWG

0.925+/-0.025 [.036+/-0.001]

8.3



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: 8-2266554-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266554-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266554-5

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 ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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

-

-

-

-

-

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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

-

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

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-

-

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

-

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

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

-

-

REF

-

-

2119944-1

FEED FINGER ASSEMBLY,SF

117

-

1

1

1

1

455888-4

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

-

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

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

53

-

1

1

1

1

5018030-1

NUT, HEX, REG, RoHS, M3

52

-

1

1

1

1

811242-5

BUMPER, HOLD DOWN

51

-

1

1

1

1

690753-2

SPACER, TONKER

50

-

1

-

1

2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

-

-

-

-

1

2119652-1

FEED CAM, PRE FEED

48

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1

1

1

1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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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

-

1

1

1

1

3-1752356-4

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

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1

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455888-3

SPACER, CRIMPER

28

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1

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1320928-2

STRIP GUIDE

24

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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2

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1-18028-2

WASHER, FLAT, REG M4

20

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1

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1

2119533-1

STRIPPER, SIDE FEED

19

-

1

1

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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

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1

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1803095-1

FLOATING SHEAR, FRONT

9

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1-1633919-8

ANVIL, COMBINATION

8

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2119780-9

DEPRESSOR, SHEAR

5

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1-238011-6

BLOCK, CRIMPER SPACER

4

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1

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1-1633962-1

CRIMPER, INSULATION F PREMIUM

3

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455888-2

SPACER, CRIMPER

2

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1-456404-4

CRIMPER, WIRE PREMIUM

1

-77

-27

-25

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-21

PART NO

DESCRIPTION

ITEM NO

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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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2119782-1

FINE ADJUST HEAD ASM, PACIFIC STYLE

251

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2119640-1

PUSH ROD, AIR FEED

250

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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

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ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

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ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

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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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PART NO

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ITEM NO

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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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PART NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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2119782-1

FINE ADJUST HEAD ASM, PACIFIC STYLE

251

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2119640-1

PUSH ROD, AIR FEED

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PART NO

DESCRIPTION

ITEM NO

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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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PART NO

DESCRIPTION

ITEM NO

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2119782-1

FINE ADJUST HEAD ASM, PACIFIC STYLE

251

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2119640-1

PUSH ROD, AIR FEED

250

77

27

25

22

21

PART NO

DESCRIPTION

ITEM NO

-

1

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1

2119

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

D

C

B

A

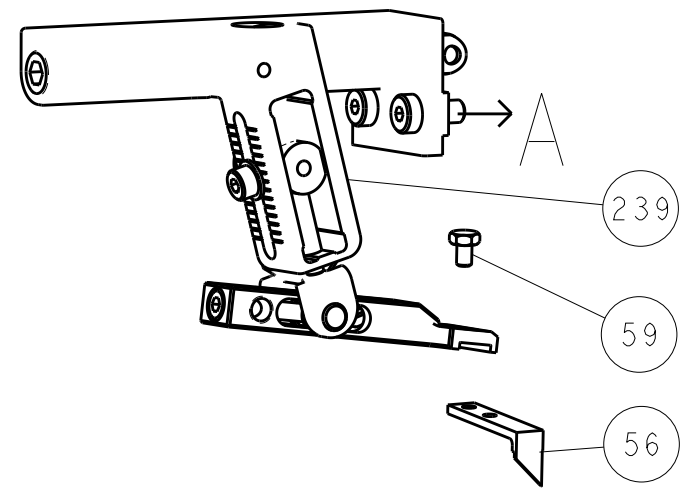
D

C

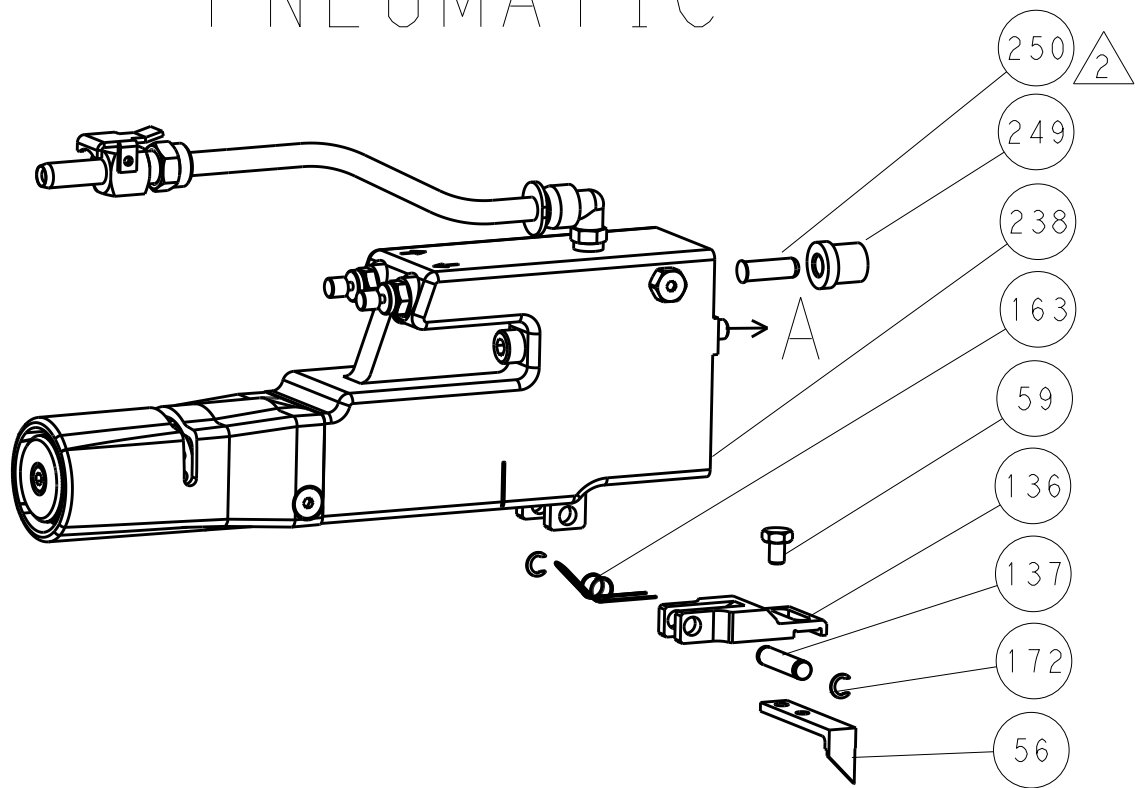
B

A

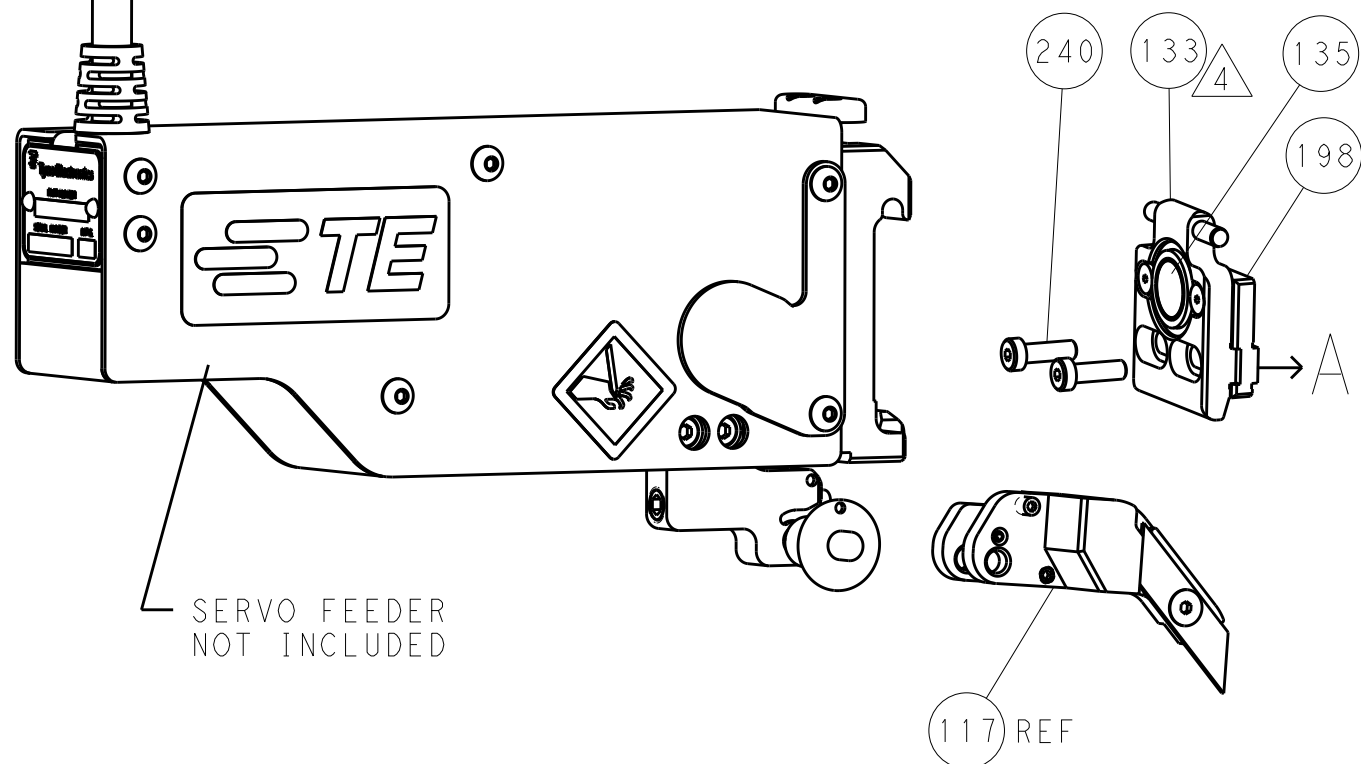
FEED TYPE MECHANICAL



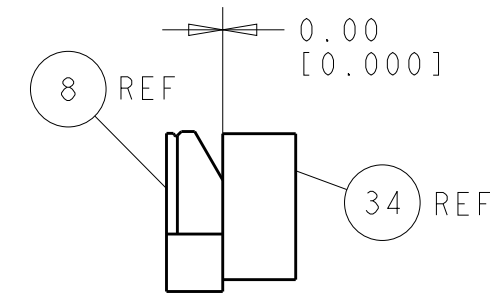
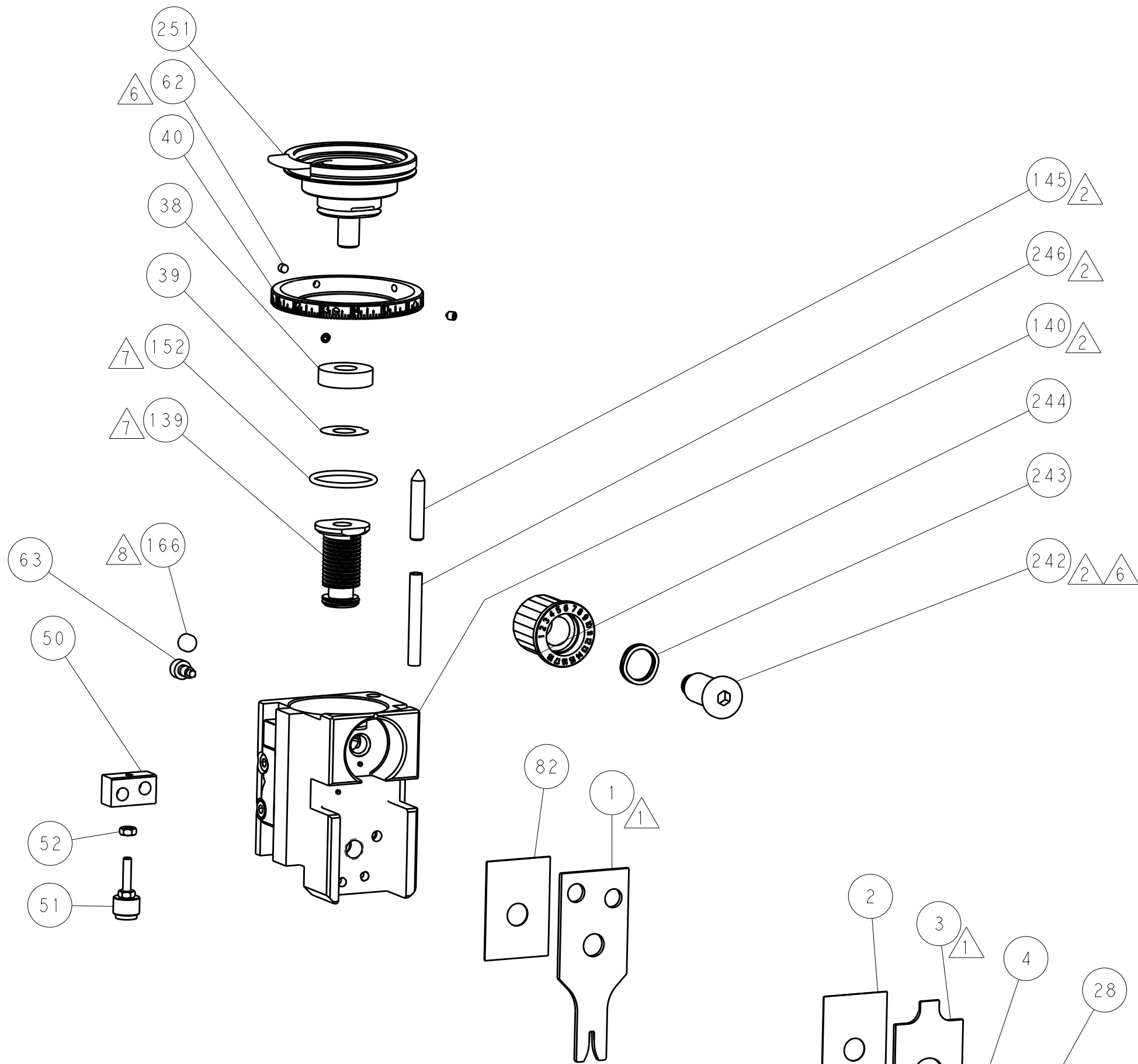
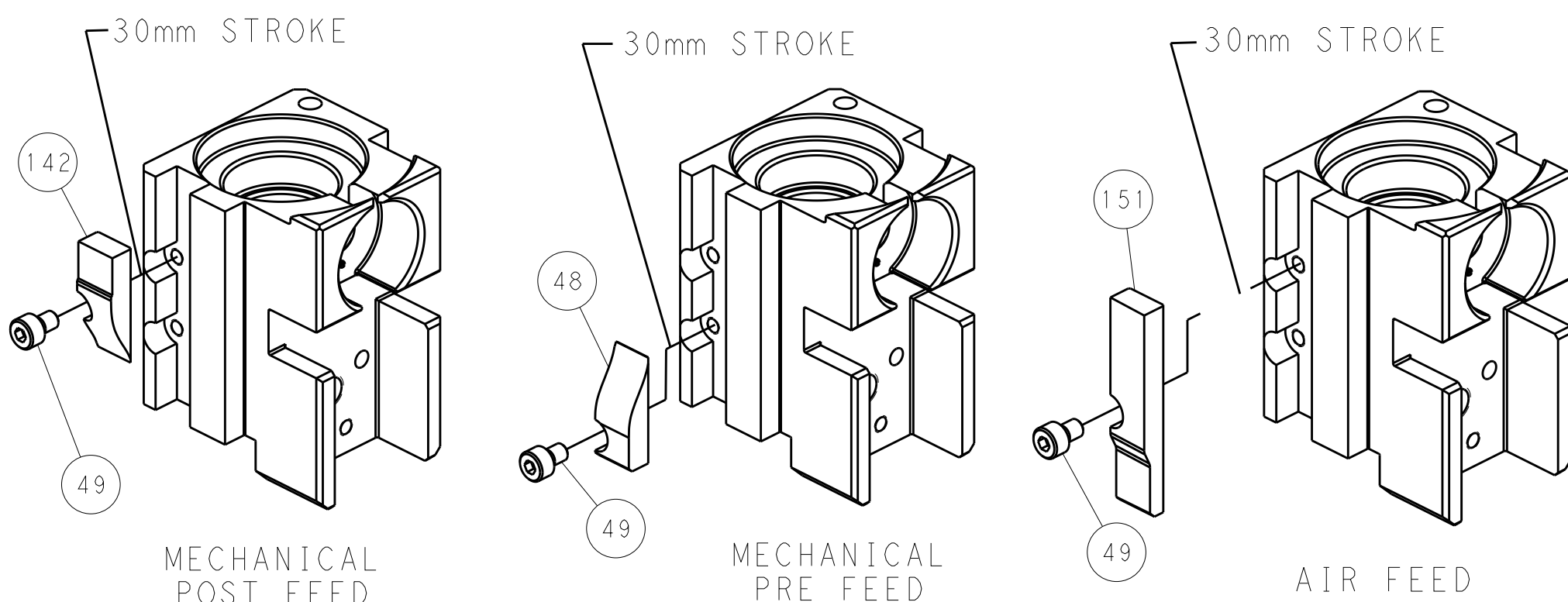
PNEUMATIC



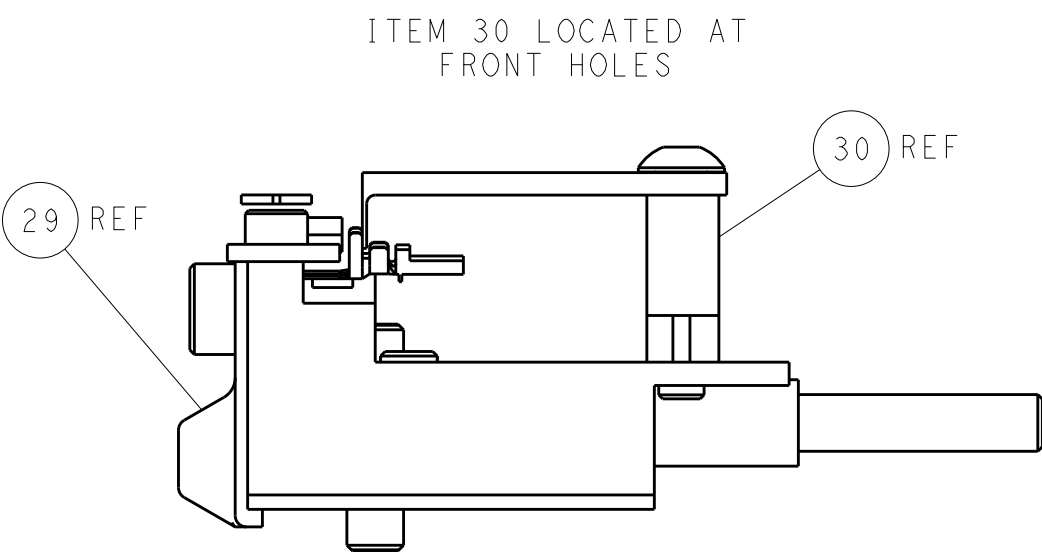
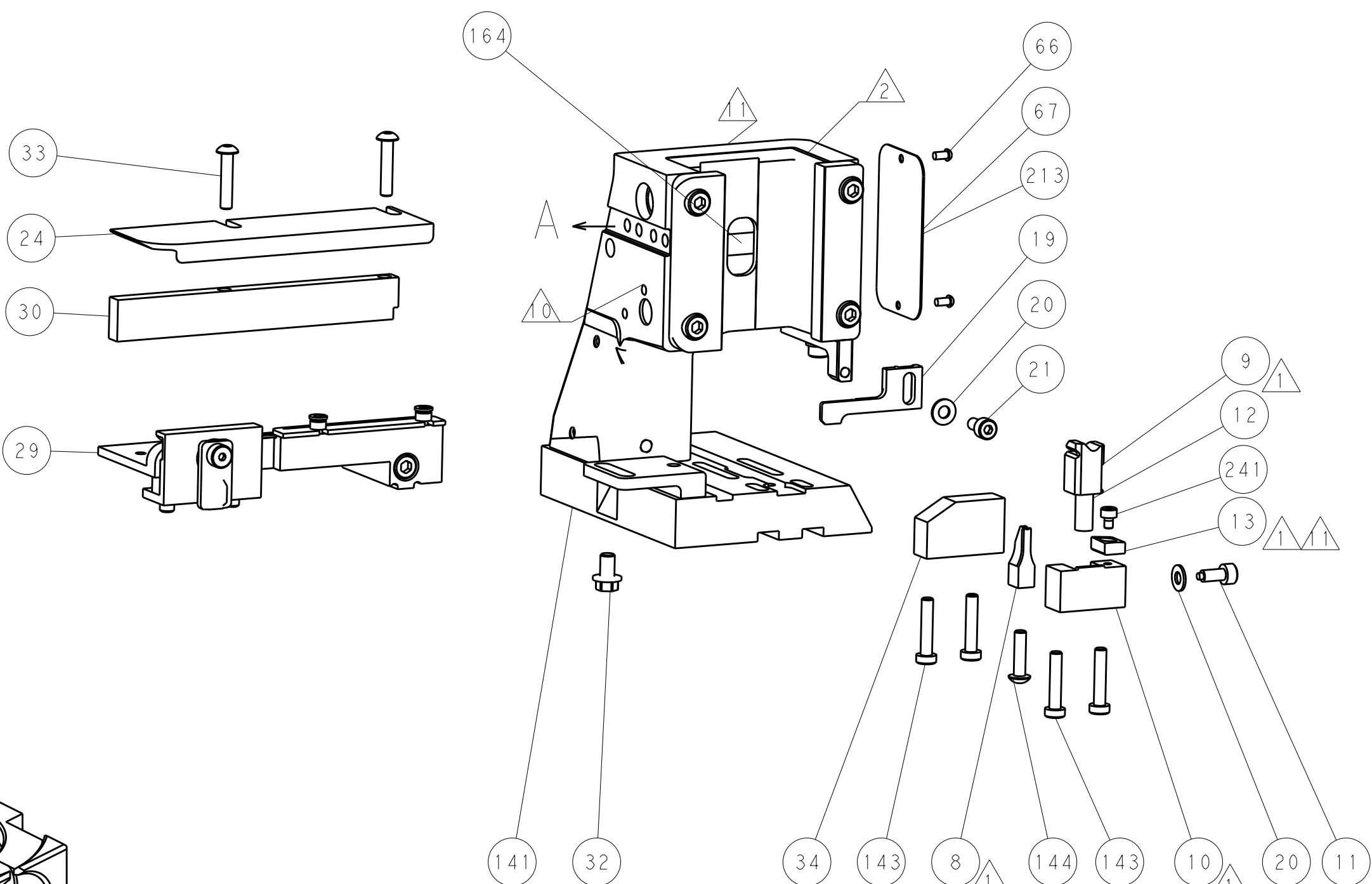
SERVO LATCH PLATE



CAM POSITIONS



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)

FIRST PUBLISHED BY: COMPANY NAME FOR THE COMPANY'S ORGANIZATION IT IS SUBJECT TO CHANGE AND THE COMPANY'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN K. HUANG 23OCT2014	STE TE Connectivity Harrisburg, PA 17105-3608	
CHK L. ZHANG 23OCT2014				NAME	Ocean Side Feed Applicator	
APVD J. GUO 23OCT2014				PRODUCT SPEC	-	
APPLICATION SPEC				SIZE	A1 00779 C=2266554	
MATERIAL				WEIGHT	-	
FINISH				Customer Accessible Production Drawing	SCALE 1:2 SHEET 4 OF 4 REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION