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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

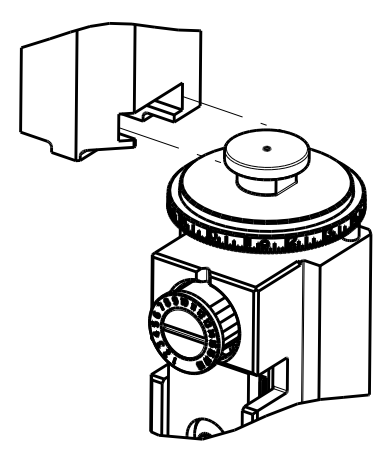
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2266255-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338683-8

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5-18022-5

8-2266255-5

8-2266255-4

2119641-1

1901094-3

-

2119799-1

-

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2063440-1

2168400-6 (QUANTITY 2)

-

2266255-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338683-8

-

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5-18022-5

8-2266255-5

8-2266255-4

2119653-1

1901094-3

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2266255-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

1338683-8

1338683-8

5-18022-5

5-18022-5

2119653-1

2119641-1

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2063440-1

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2266255-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴¹²

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2266255-7

A

FINE CRIMP HEIGHT ADJUST

NONE

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7-2266255-7

A

CRIMP TOOLING KIT

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APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 1.78 mm [.070] F

INSUL 4.32 mm [1.70] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: XENIA TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH 3.27-4.03 mm [1.29-.159 IN]

INSULATION DIAMETER RANGE Ø 2.4mm MAX [1.094 IN MAX]

TERMINAL APPLICATION SPECIFICATION

NONE

-

-

TERMINALS APPLIED

TE TERMINAL

XENIA TERMINAL

TE SEAL

XENIA SEAL

2113446-1

938746-18

2113447-1

949600-85

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

0.50mm2

1.20+/-0.05 [1.047+/-1.002]

9.6

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: 8-2266255-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266255-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266255-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266255-6

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 ITEMS 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.

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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.55.

13

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

14

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.

15

CUT TO LENGTH AT ASSEMBLY.

APPLICATOR STYLE CONVERSION CHART

PART NUMBERS REQUIRED

2119950-1

2119951-1

2161326-1

1338683-8

5-18022-5

2119641-1

2119799-1

2063440-1

2119949-1

2119951-1

2161326-1

1338683-8

5-18022-5

2119653-1

1901094-3

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2119950-1

2119950-1

1338683-8

5-18022-5

2119641-1

2119799-1

2063440-1

2119949-1

2119951-1

2161326-1

1338683-8

5-18022-5

2119653-1

1901094-3

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2119950-1

2119950-1

1338683-8

5-18022-5

2119641-1

2119799-1

2063440-1

2119949-1

2119951-1

2161326-1

1338683-8

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1901094-3

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1338683-8

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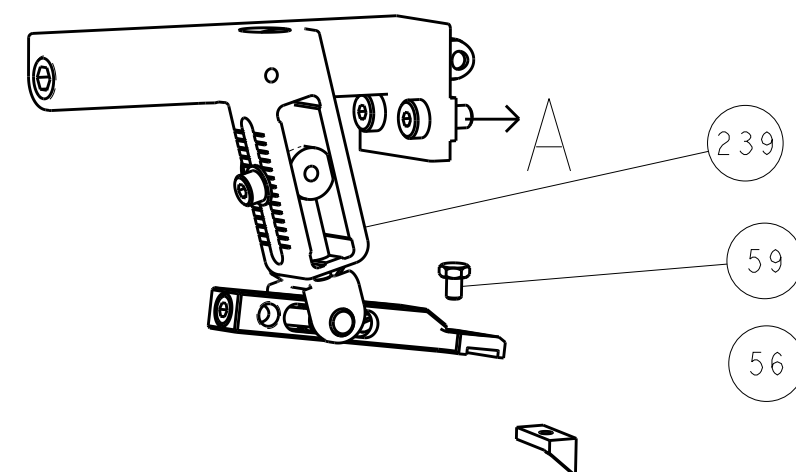
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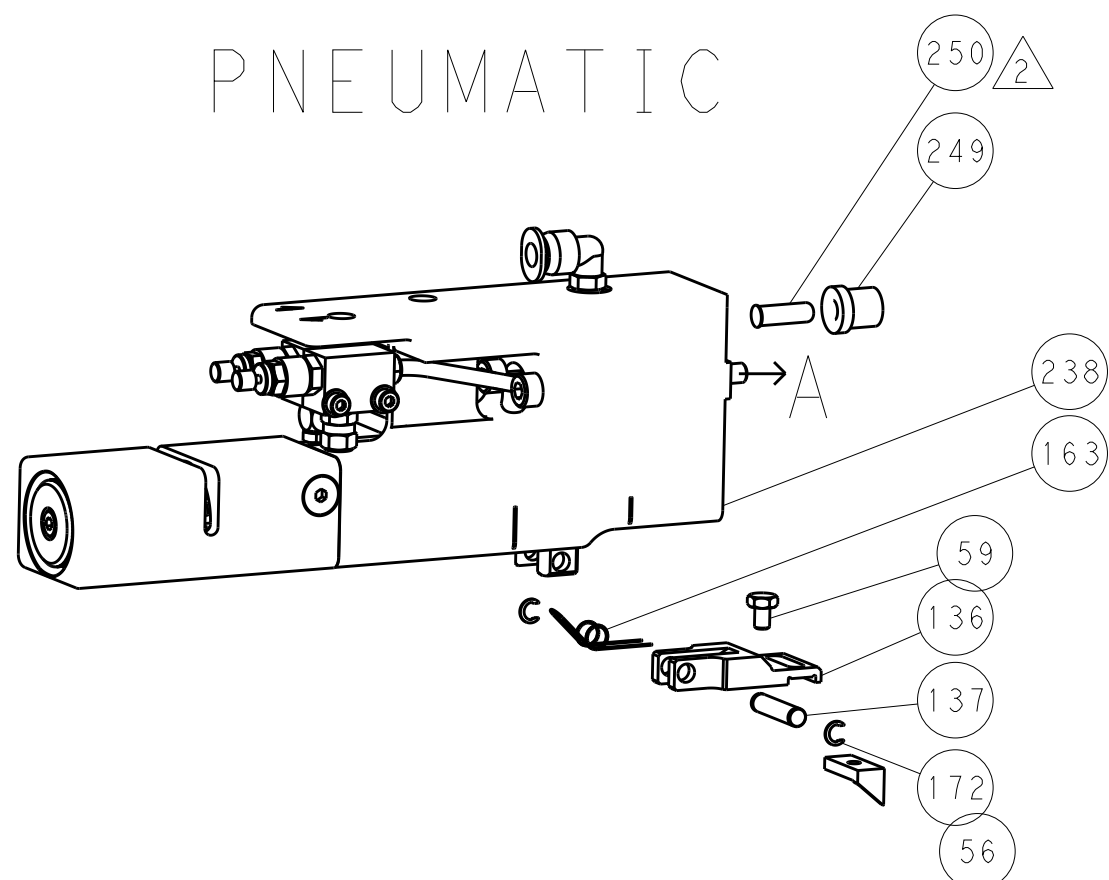
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		-		SEE SHEET 1	-	-	-

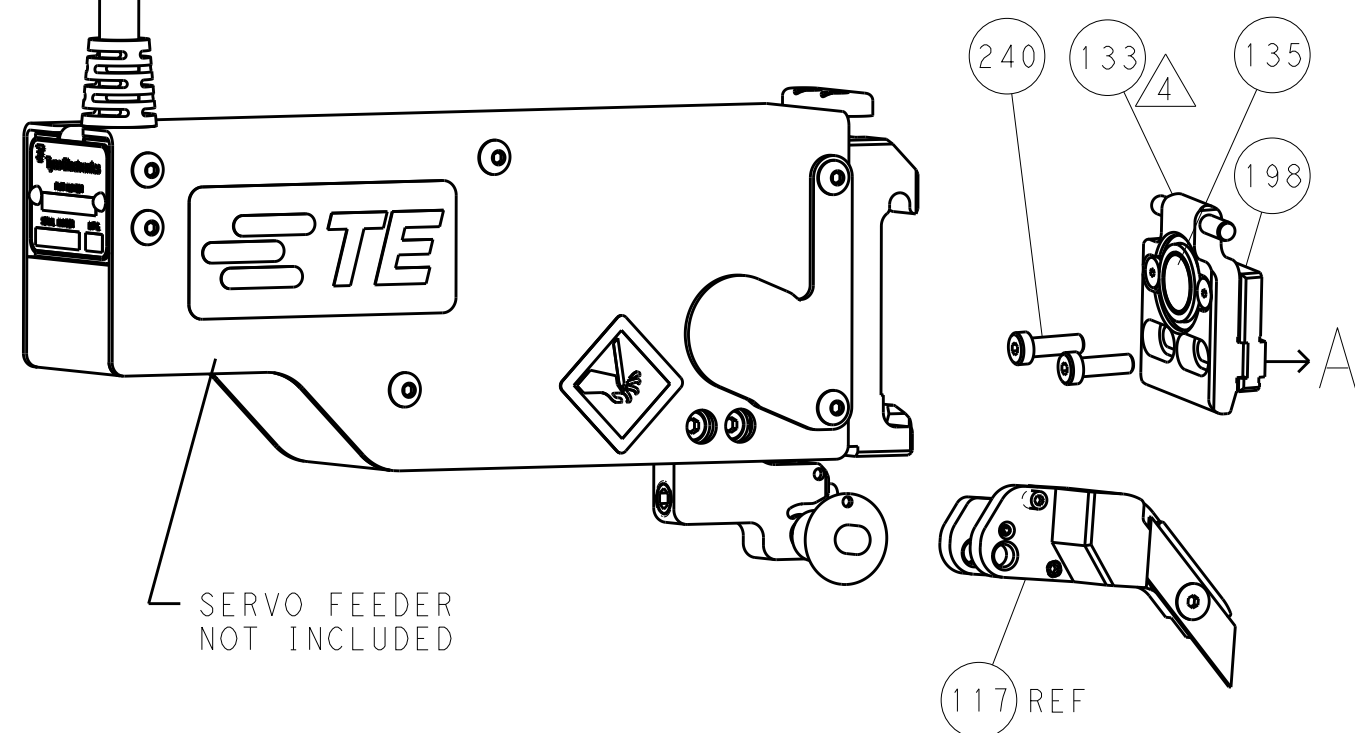
FEED TYPE
MECHANICAL



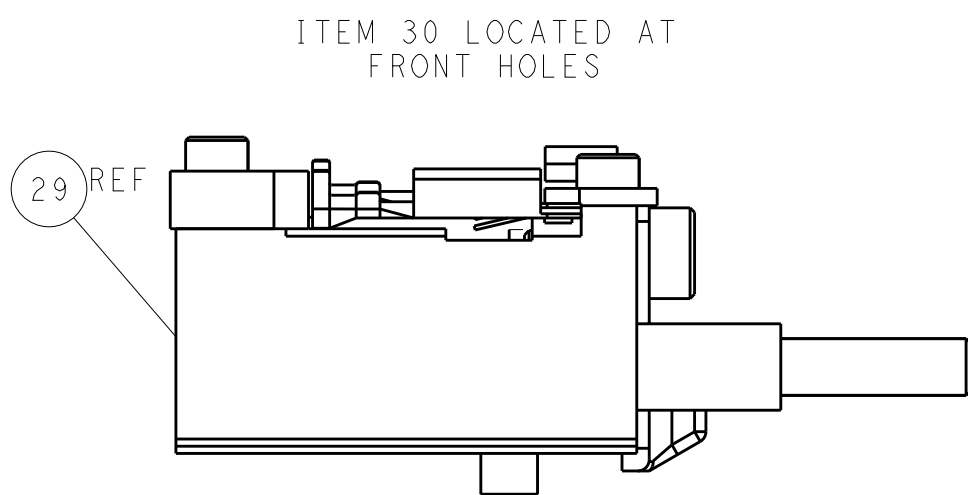
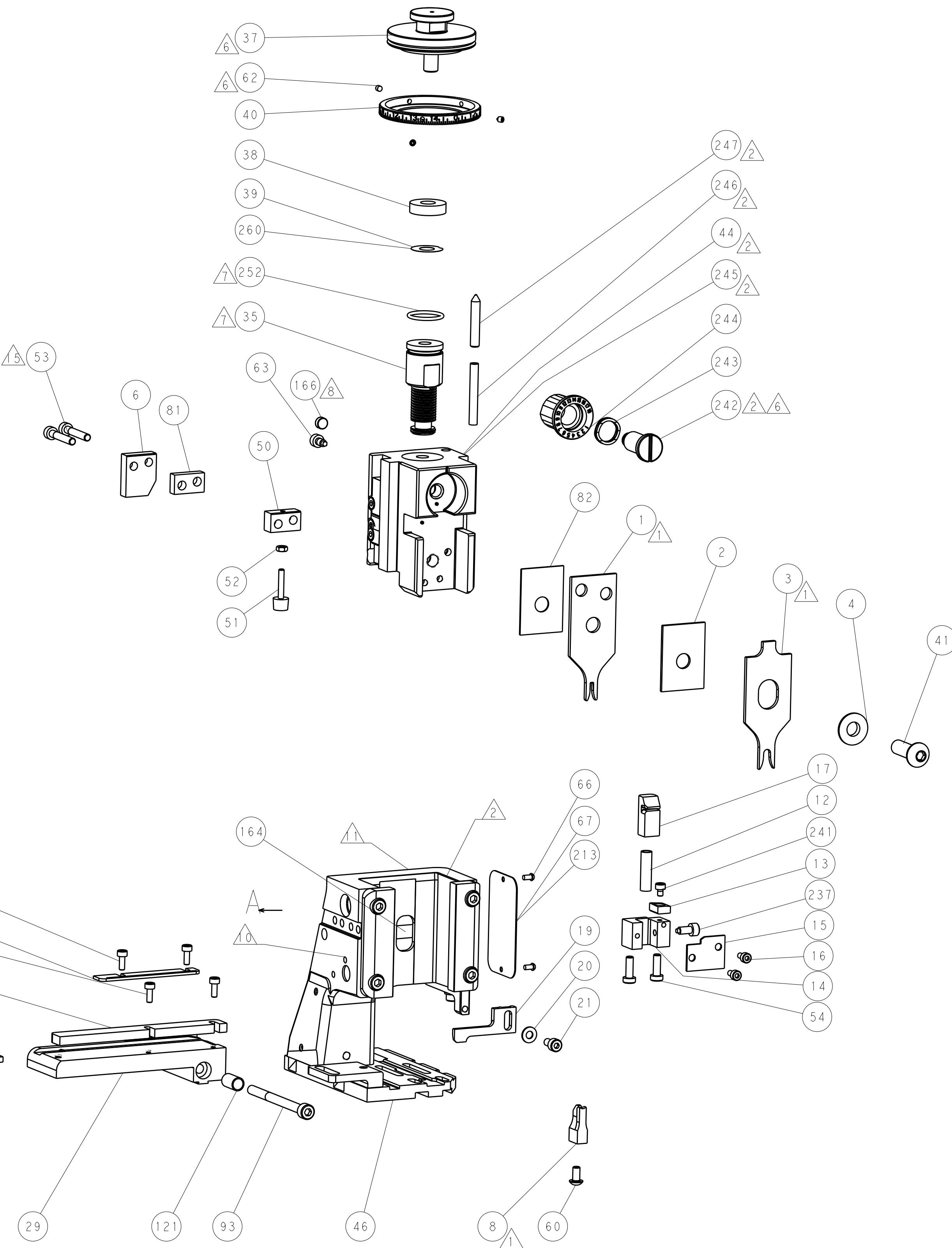
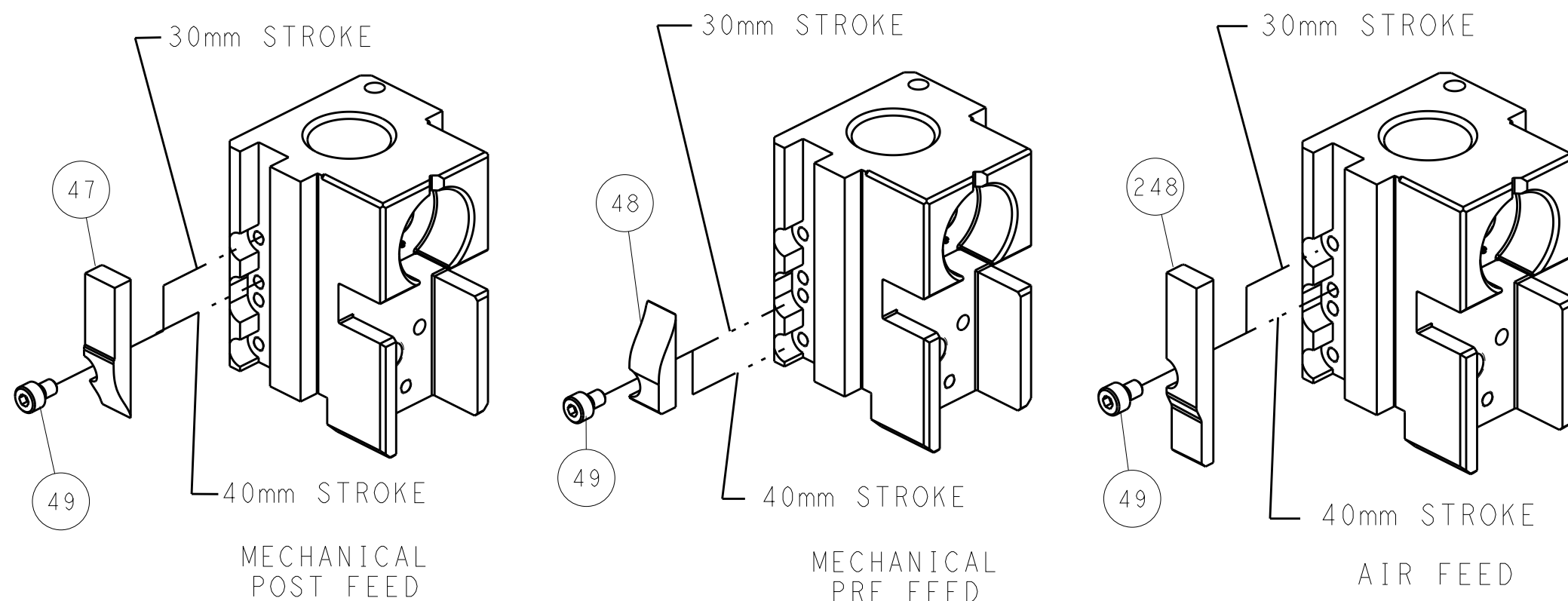
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



FEED TRACK POSITION
GUIDE BY GUIDE_BY_STR

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		11APR2014		TE Connectivity	
mm		0 PLC ±0.5		CHK		Y. YIN		Harrisburg, PA 17105-3608	
		1 PLC ±0.5		APVD		G. BAILEY		NAME	
		2 PLC ±0.13		U. GUO		11APR2014		Ocean Side Feed	
		3 PLC ±0.013		PRODUCT SPEC				Applicator	
		4 PLC ±0.001		APPLICATION SPEC					
		ANGLES ±0.0001		WEIGHT		A		SIZE	
		FINISH		Customer Accessible Production Drawing		00779		CAGE CODE	
				SCALE		1:2		DRAWING NO	
				SHEET		2		REV	
				4		A			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

D

C

B

A

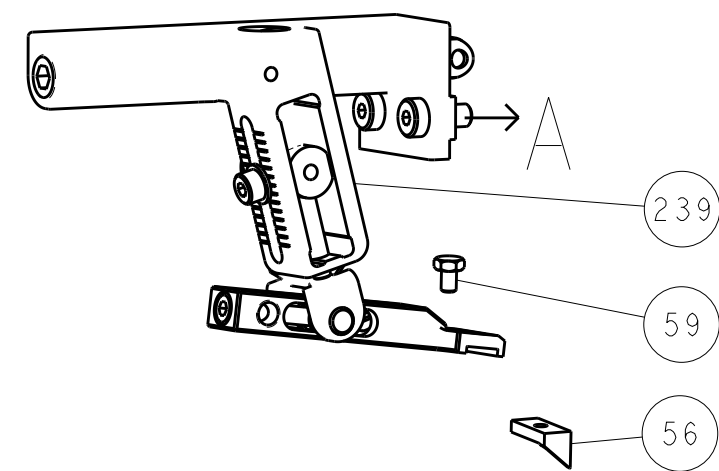
D

C

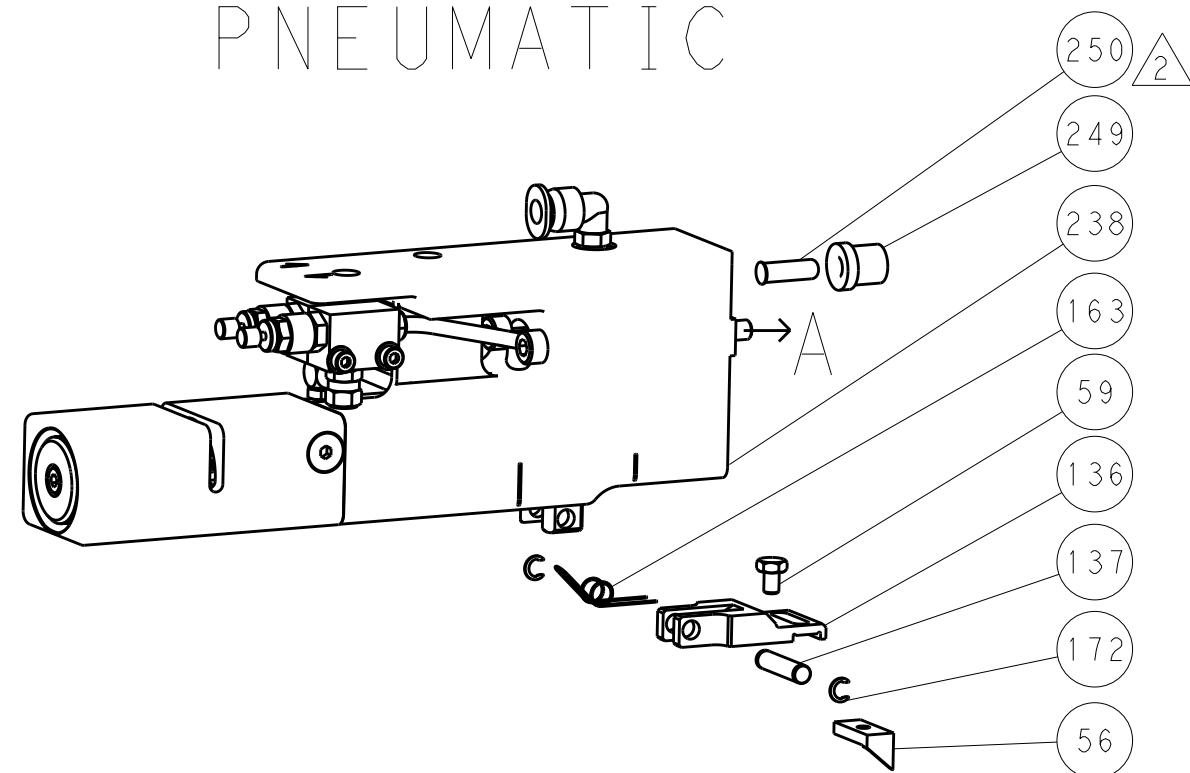
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A

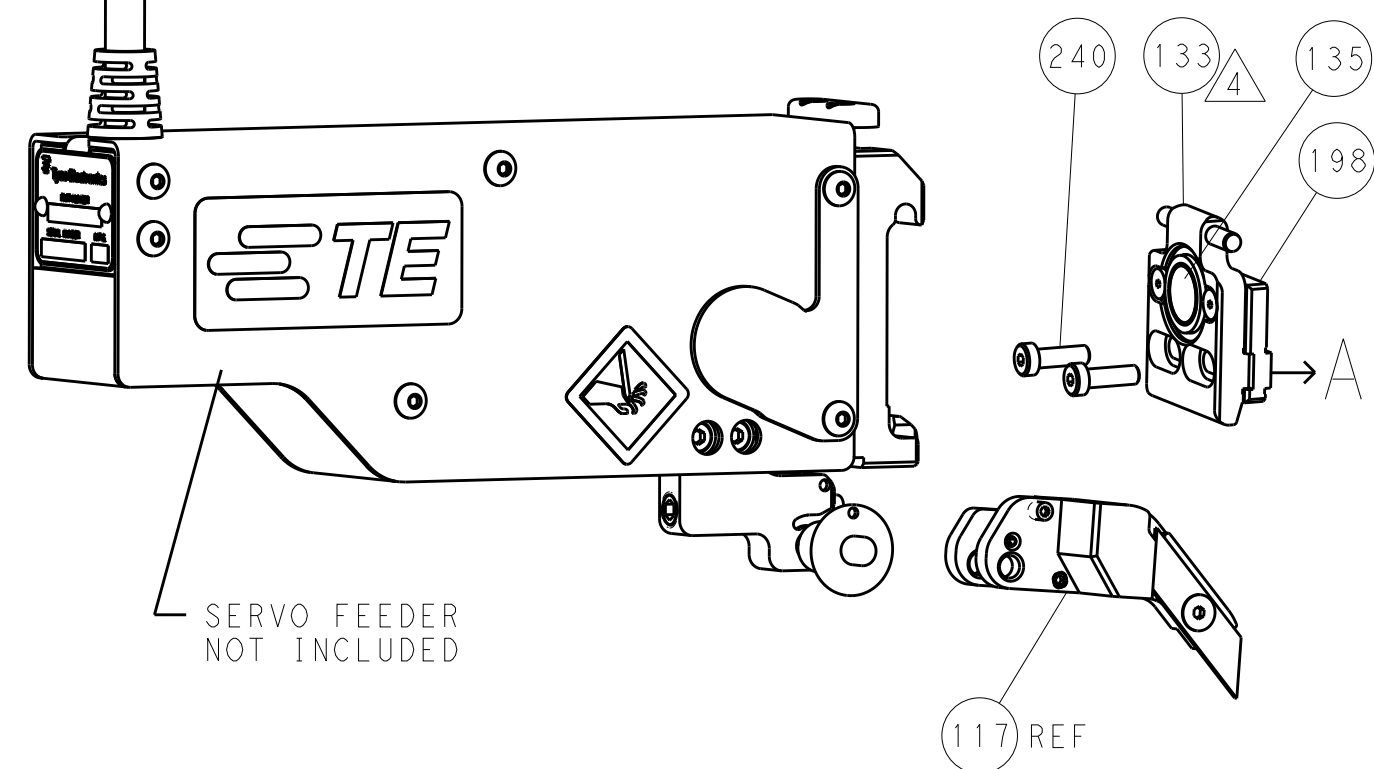
FEED TYPE MECHANICAL



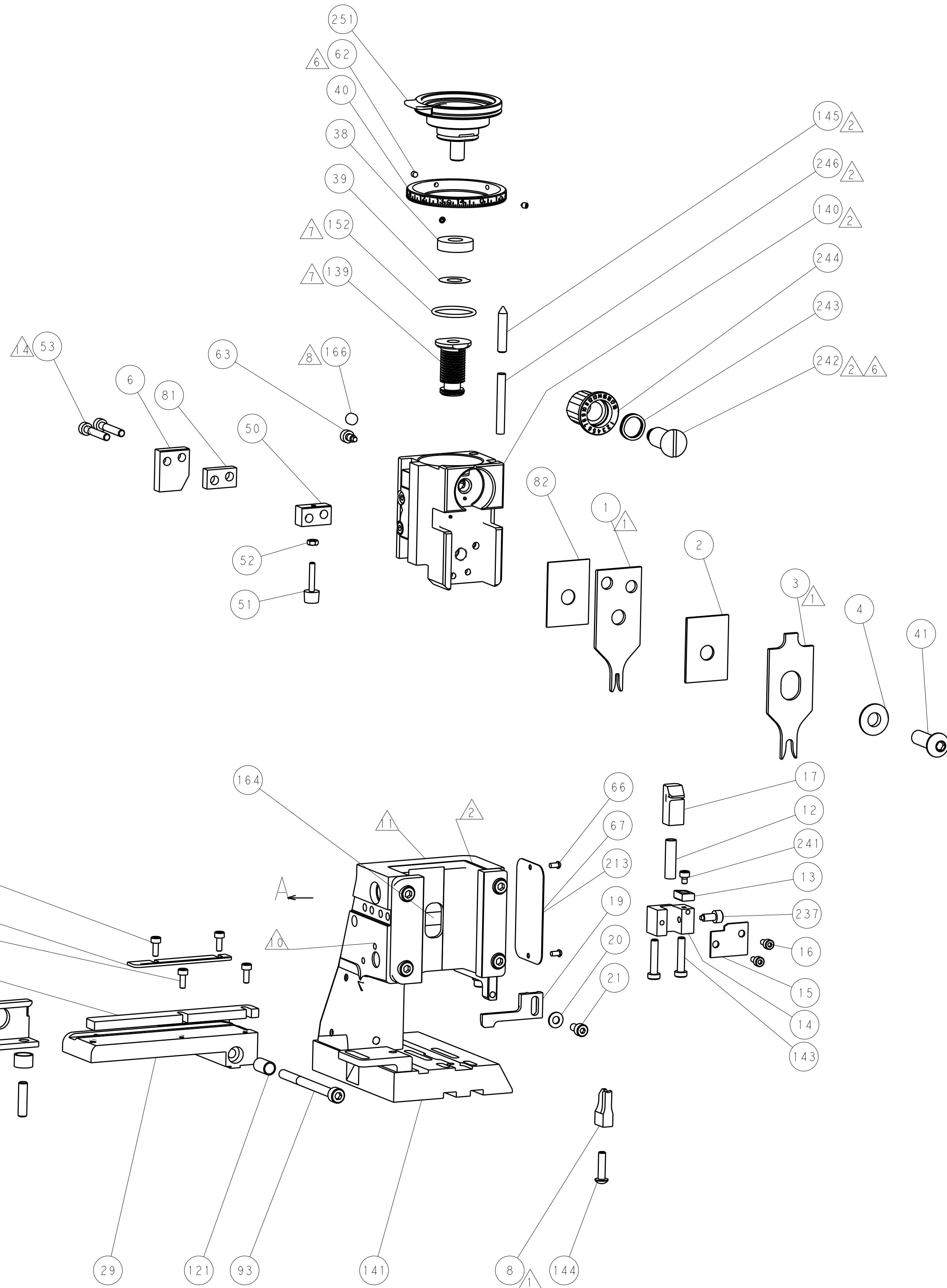
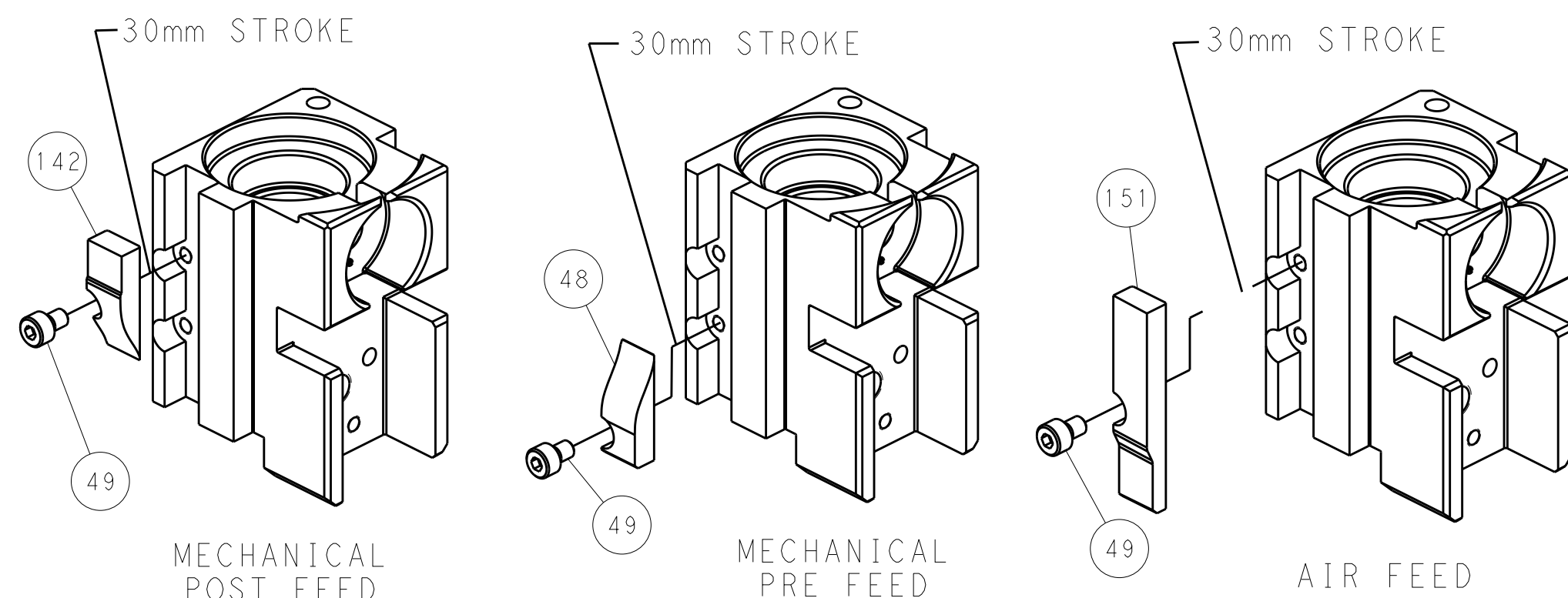
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



ITEM 30 LOCATED AT
FRONT HOLES

FEED TRACK POSITION
GUIDE BY GUIDE_BY_STR

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 (TYCO ELECTRONICS CORPORATION) IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF ANY KIND. SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN Y. YIN 11APR2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 11APR2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.0001		APVD J. GUO 11APR2014	PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -	SIZE CAGE CODE DRAWING NO 00779 C=2266255	
FINISH -		Customer Accessible Production Drawing	SCALE 1:2	SHEET 4 OF 4
		REV A		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION