

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.5mm ²	AVSS		0.90+/-0.05 [.035+/- .002]		5.5
0.3mm ²	AVSS		0.80+/-0.05 [.031+/- .002]		6.5
0.35mm ²	CHFUS		0.75+/-0.05 [.030+/- .002]		7.1
0.22mm ²	CHFUS		0.70+/-0.05 [.028+/- .002]		7.7

--

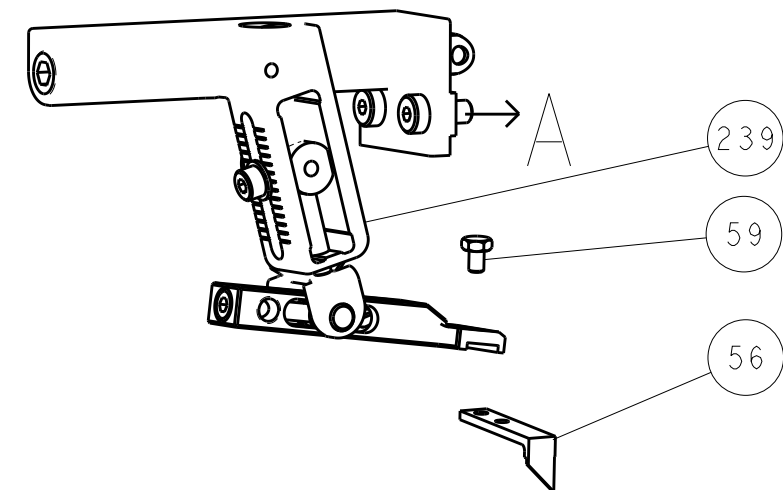
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG. D.WILSON 12MAR2015 CHG. R.J. STAKEM APP'D. T.L. FIRIN 13MAR2015	 TE Connectivity Harrisburg, PA 17105-3608	
0.1 PLG ±.01 1. PLG ±0.5 2. PLG ±0.13 3. PLG ±0.013 4. PLG ±0.0001 ANGLES ±.001 FINISH -		NAME	Ocean Side Feed Applicator	
		PRODUCT SPEC		
		APPLICATION SPEC		
	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
	A	00779	C-2266718	-
Customer Accessible Production Drawing			SCALE	1:2
			SHEET	1 of 4
			REV	A

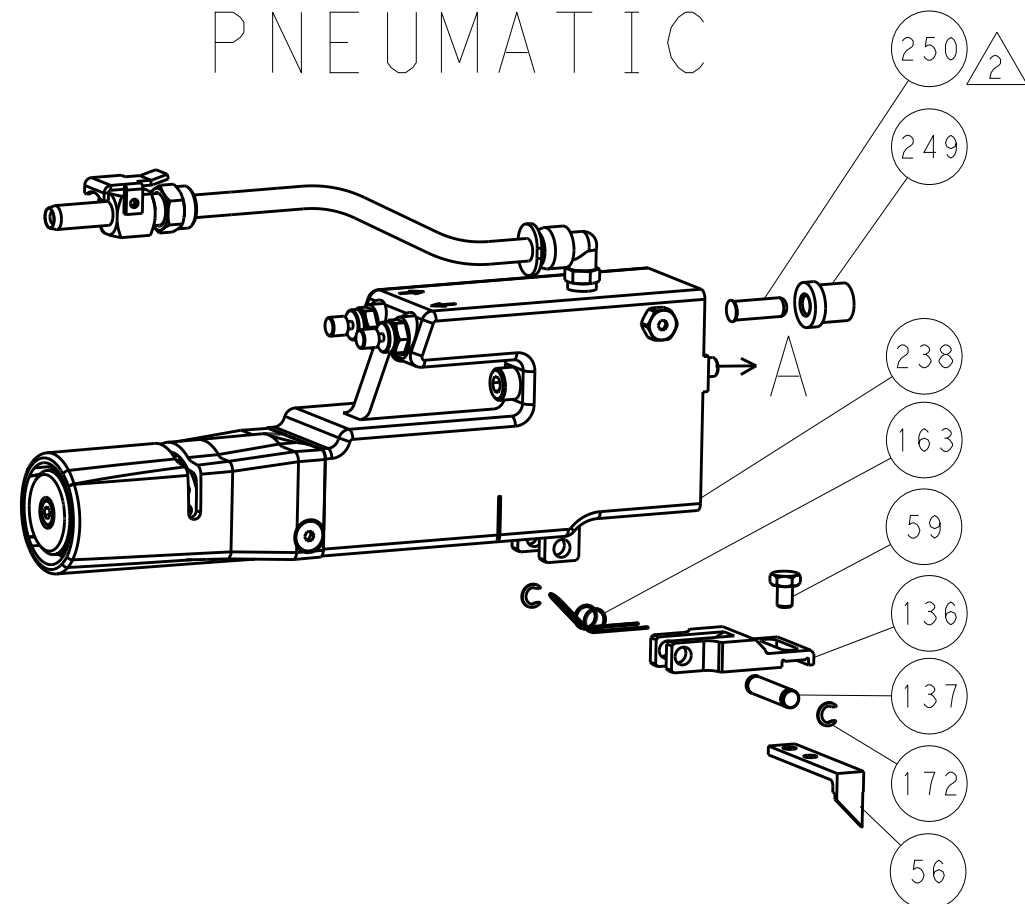
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

FEED TYPE
MECHANICAL



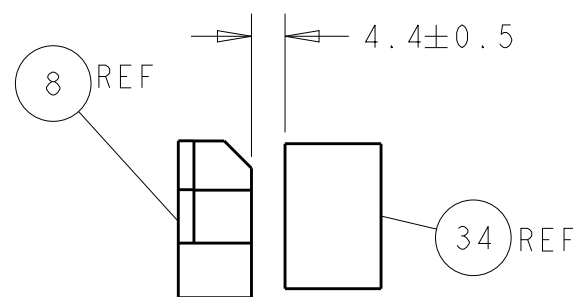
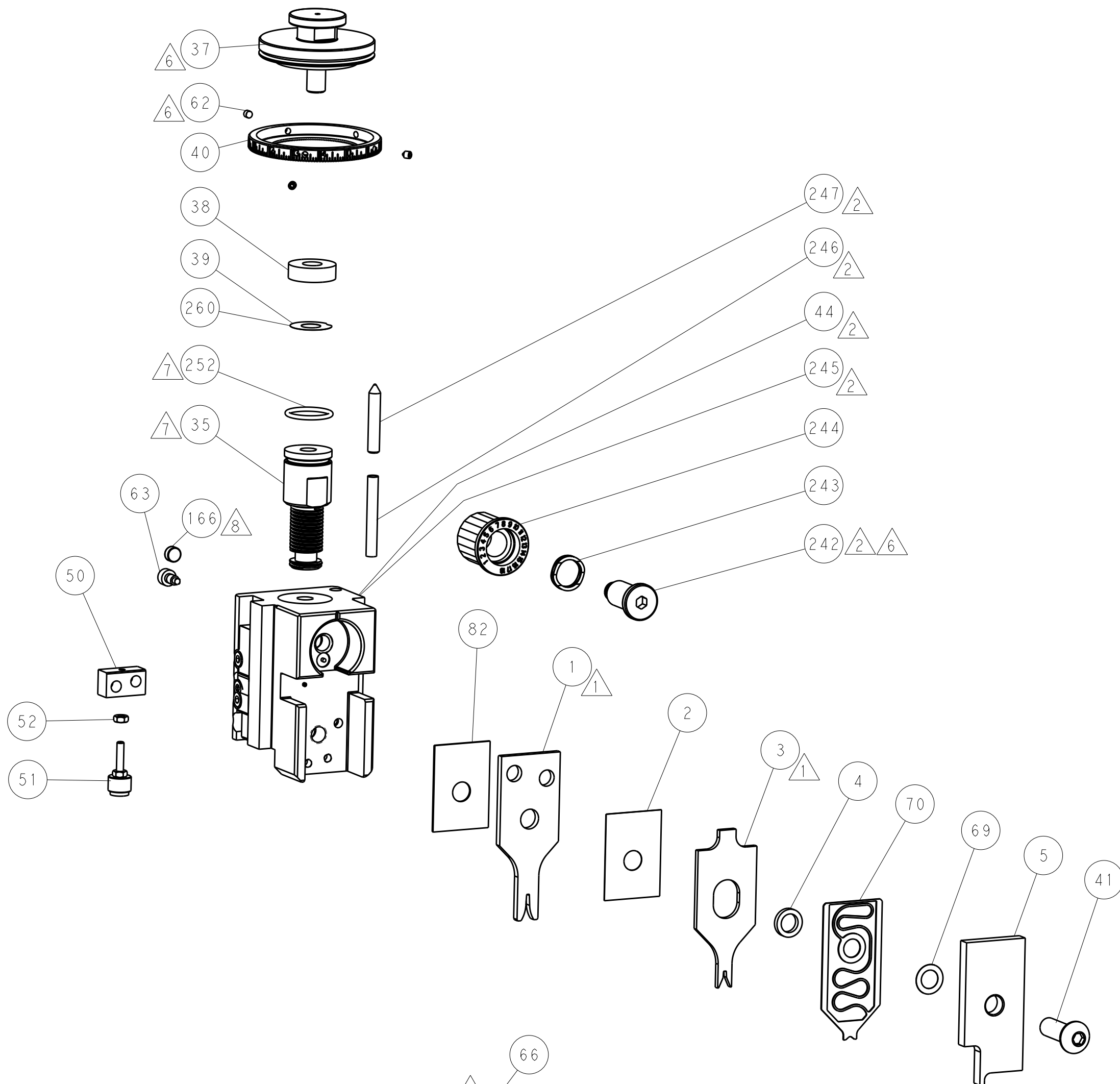
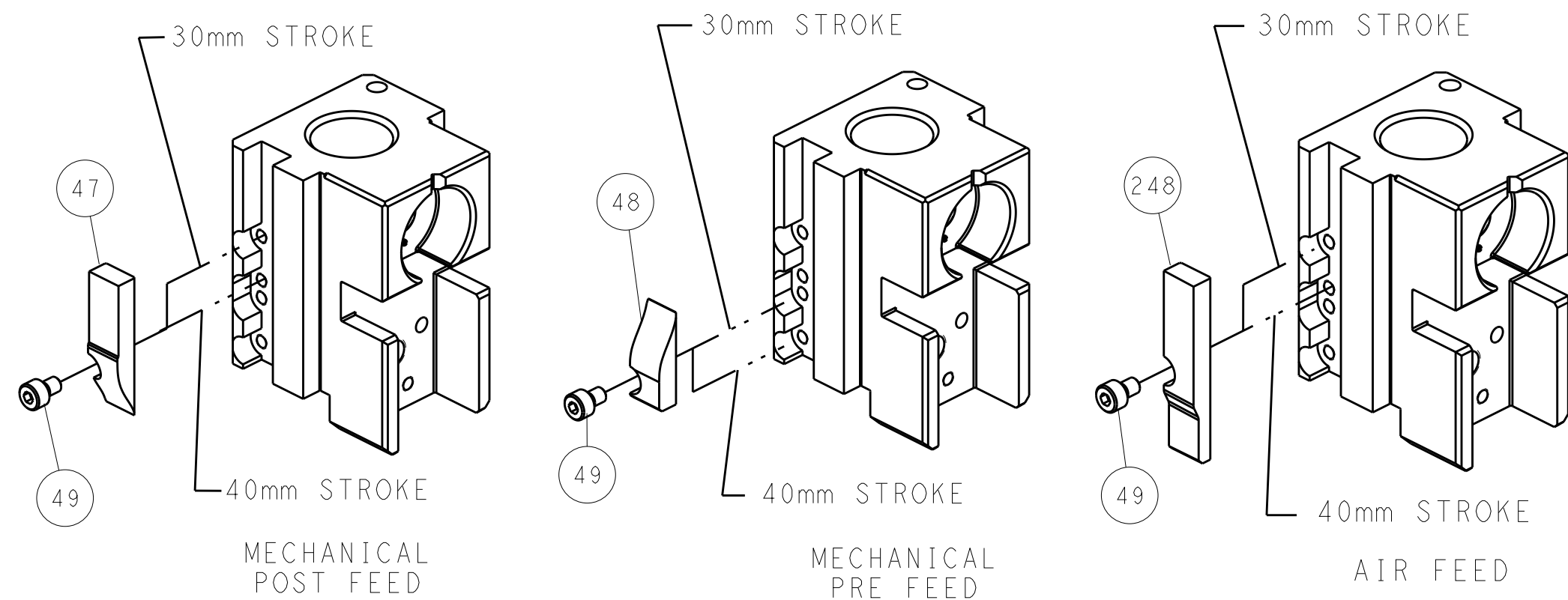
PNEUMATIC



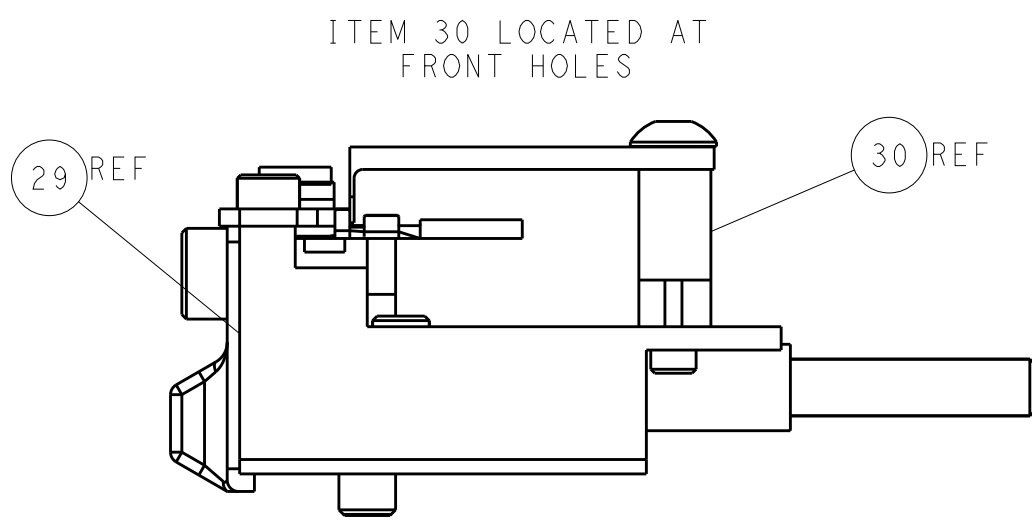
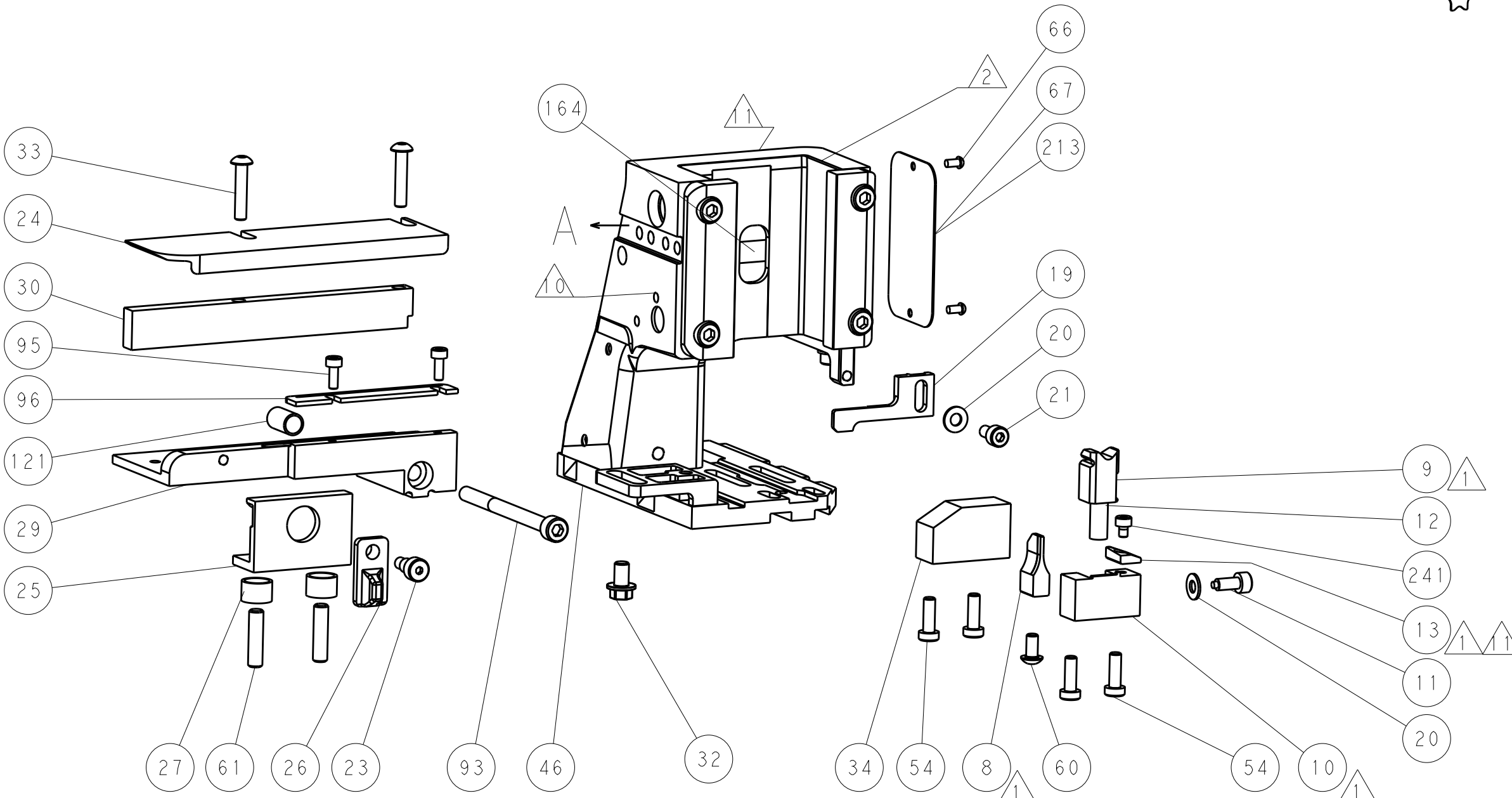
SERVO
LATCH PLATE



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)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. O. WILSON 12MAR2015		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±0.5		1 PLC ±0.13		CHK K. J. STAKEM 13MAR2015		NAME Ocean Side Feed Applicator	
2 PLC ±0.13		3 PLC ±0.013		APVD T. L. ELGIN 13MAR2015		SIZE A1	
4 PLC ±0.0001		ANGLES FINISH		PRODUCT SPEC		CAGE CODE 00779	
MATERIAL		WEIGHT		APPLICATION SPEC		DRAWING NO C=2266718	
		Customer Accessible Production Drawing		SCALE 1:2		SHEET 2 of 4	
						REV A1	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

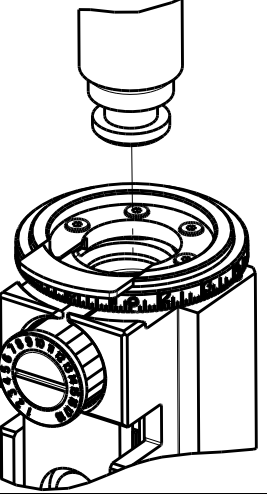
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2266718-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119951-1

-

8-2266718-5

1901094-3

-

2168400-6 (QUANTITY 2)

2161326-1

-

8-2266718-4

-

-

-

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

2119951-1

-

8-2266718-5

1901094-3

-

2168400-6 (QUANTITY 2)

2161326-1

-

8-2266718-4

-

-

-

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

-

-

-

-

-

-

-

-

-

-

-

-

2-2266718-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

2-2266718-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

2-2266718-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2266718-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.40 mm [.055]

F

INSUL

1.40 mm [.055]

F

APPLICATOR INSTRUCTIONS

408-10389



TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION

TERMINAL NAME: NH TERMINAL

WIRE STRIP LENGTH

4.00-4.50 mm [.157-.177 IN]

INSULATION DIAMETER RANGE

Ø1.40-1.60 mm [.055-.063 IN]

TERMINAL APPLICATION SPECIFICATION

T-387E-B Rev 12-DEC-12

-

-

-

-

-

TERMINALS APPLIED

TE TERMINAL

SUMITOMO TERMINAL

TE TERMINAL

SUMITOMO TERMINAL

1949694-1

8240-0180

1949923-1

8230-4877

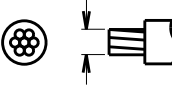
1949694-2

8240-0552

1949923-2

8230-5379

WIRE SIZE



CRIMP HEIGHT

mm [INCH]

CRIMP HEIGHT

REFERENCE SETTING

0.5mm² AVSS

0.90+/-0.05 [.035+/-0.002]

5.5

0.3mm² AVSS

0.80+/-0.05 [.031+/-0.002]

6.5

0.35mm² CHFUS

0.75+/-0.05 [.030+/-0.002]

7.1

0.22mm² CHFUS

0.70+/-0.05 [.028+/-0.002]

7.7



△

RECOMMENDED SPARE PARTS

△

GREASE BEARING SURFACES LIGHTLY

3.

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: 8-2266718-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266718-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266718-5

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.

-

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

2119082-4

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

-77

-27

-25

-22

-21

PART NO

DESCRIPTION

ITEM NO

△

6

-

-

-

-

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

-

REF

REF

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

-

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

-

1

1

1

1

1-22281-8

SPRING, COMPRESSION

121

-

-

REF

-

-

2119944-1

FEED FINGER ASSEMBLY, SF

117

-

1

1

1

1

1-690438-0

FRONT STRIP GUIDE

96

-

2

2

2

2

2168083-1

SCR, SKT HD CAP, RoHS, M3 X 8.0

95

-

1

1

1

1

2168083-6

SCR, SKT HD CAP, RoHS, M5 X 65

93

-

1

1

1

1

455888-6

SPACER, CRIMPER

82

-

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

1

1

1

2119791-5

DEPRESSOR, WIRE

70

-

1

1

1

1

2119943-1

WASHER, SPACER

69

-

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

-

2

2

2

2

2-18032-5

SCR, SET, FLT POINT M5 X 20.0

61

-

-

-

1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

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

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

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1

1

1

1

2-1752356-0

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

1320908-6

SPACER, STRIP GUIDE

30

-

1

1

1

1

1901086-1

PLATE, STRIP GUIDE

29

-

2

2

2

2

22283-1

SPRING, COMPRESSION

27

-

1

1

1

1

356835-1

LEVER, DRAG RELEASE

26

-

1

1

1

1

240792-3

DRAG, TERMINAL

25

-

1

1

1

1

1320928-2

STRIP GUIDE

24

-

1

1

1

1

980371-4

SCR, SKT HD SHLDR 5.0 DIA X 6.0

23

-

1

1

1

1

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

-

2

2

2

2

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

1803095-3

FLOATING SHEAR, FRONT

9

-

1

1

1

1

1-1633932-1

ANVIL, COMBINATION

8

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-

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7

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-

6

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1

1

1

1

1-2119757-0

DEPRESSOR, SHEAR

5

-

1

1

1

1

1-238011-0

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1633962-2

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

455888-1

SPACER, CRIMPER

2

-

1

1

1

1

1-1333281-0

CRIMPER, WIRE PREMIUM

1

-77

-27

-25

-22

-21

PART NO

DESCRIPTION

ITEM NO

△

6

-

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

2119082-4

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

-77

-27

-25

-22

-21

PART NO

DESCRIPTION

ITEM NO

△

6

-

-

-

-

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

-

REF

REF

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

-

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

-

1

1

1

1

1-22281-8

SPRING, COMPRESSION

121

-

-

REF

-

-

2119944-1

FEED FINGER ASSEMBLY, SF

117

-

1

1

1

1

1-690438-0

FRONT STRIP GUIDE

96

-

2

2

2

2

2168083-1

SCR, SKT HD CAP, RoHS, M3 X 8.0

95

-

1

1

1

1

2168083-6

SCR, SKT HD CAP, RoHS, M5 X 65

93

-

1

1

1

1

455888-6

SPACER, CRIMPER

82

-

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

1

1

1

2119791-5

DEPRESSOR, WIRE

70

-

1

1

1

1

2119943-1

WASHER, SPACER

69

-

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

-

2

2

2

2

2-18032-5

SCR, SET, FLT POINT M5 X 20.0

61

-

-

-

1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

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

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

2-175

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

D

C

B

A

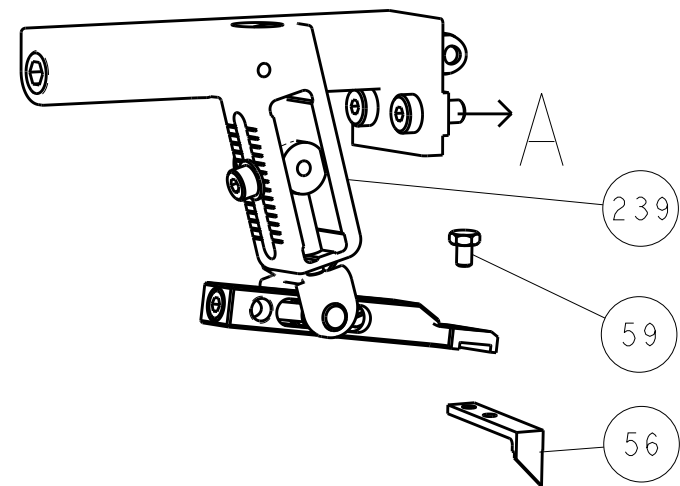
D

C

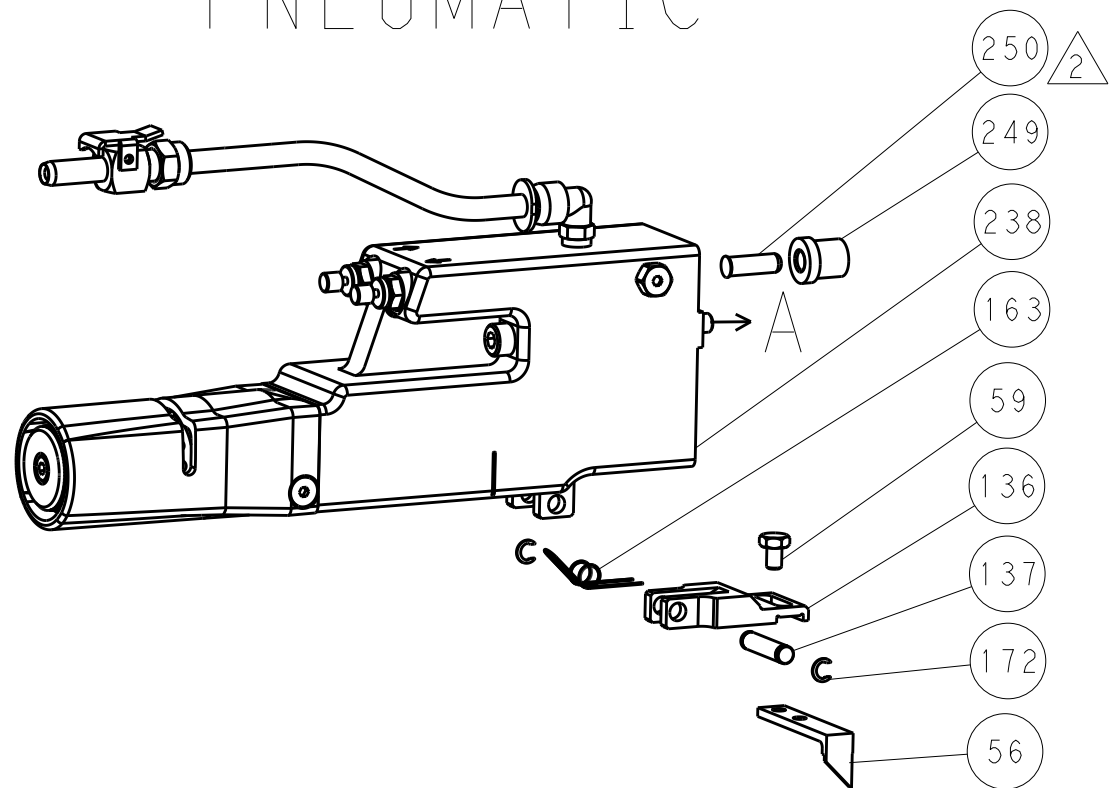
B

A

FEED TYPE MECHANICAL



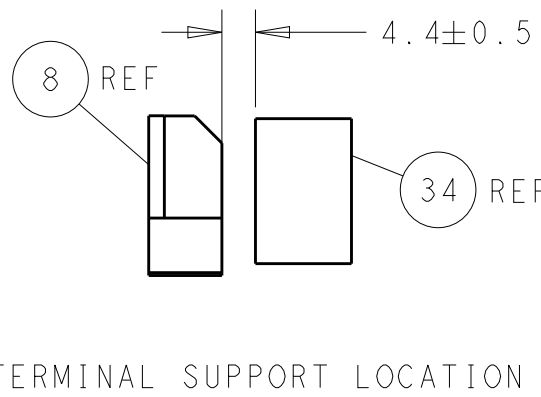
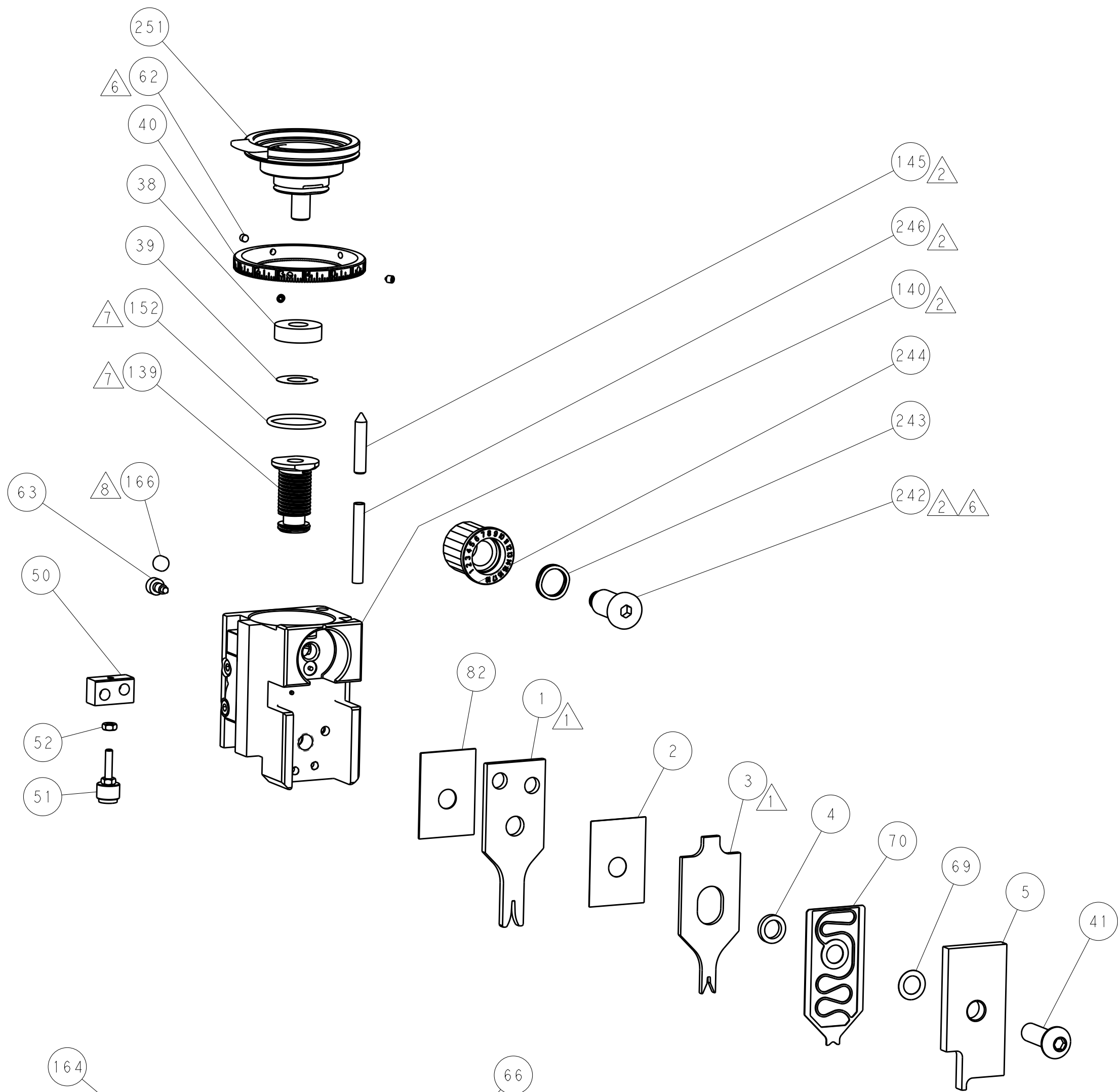
PNEUMATIC



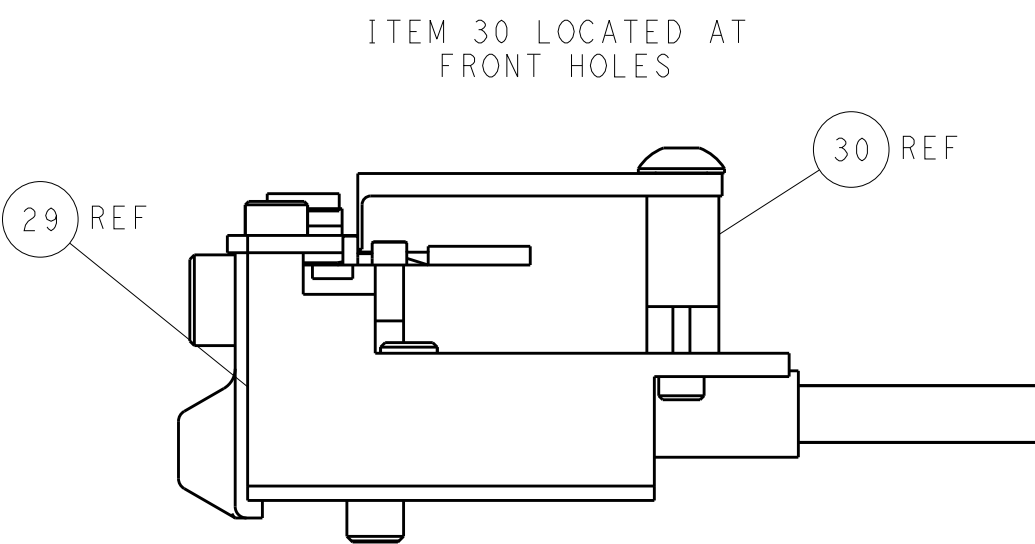
SERVO LATCH PLATE



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)

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DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT	SIZE A1	Customer Accessible Production Drawing
MATERIAL			00779	SCALE 1:2
			©=2266718	SHEET 4 OF 4
				REV A1

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION