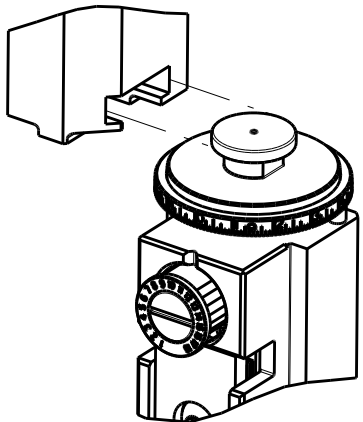


8		7		
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION
	2266574-1	A	FINE CRIMP HEIGHT ADJUST	
	2266574-2	A	FINE CRIMP HEIGHT ADJUST	
	2266574-5	A	FINE CRIMP HEIGHT ADJUST	
	2266574-6	A	NON-CRIMP HEIGHT ADJUST	4
	2266574-7	A	FINE CRIMP HEIGHT ADJUST	
	7-2266574-7	A	CRIMP TOOLING KIT	

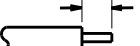
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN/SOCKET, MINI UNIVERSAL MATE-N-LOK			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.20-3.71 mm [.126-.146 IN]			Ø 1.50-2.40 mm [.059-.094 IN]
TERMINAL APPLICATION 		114-16017	-
SPECIFICATION		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794440-1	794440-2	794440-3	
794831-1	794831-2	794831-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.07+/-0.05 [.042+/- .002]	7.5
20 AWG	0.91+/-0.05 [.036+/- .002]	8.9
(2) 22 AWG	0.91+/-0.05 [.036+/- .002]	9.0
22 AWG	0.81+/-0.05 [.032+/- .002]	10.0



- 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: 8-2266574-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266574-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266574-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266574-6
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 ITEM 62. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- 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 4.73.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN/SOCKET, MINI UNIVERSAL MATE-N-LOK			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.20-3.71 mm [.126-.146 IN]			Ø 2.47-3.30 mm [.097-.130 IN]
TERMINAL APPLICATION SPECIFICATION		114-16017	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1586537-1	1586538-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.40+/-0.05 [.055+/- .002]	4.0

*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.

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

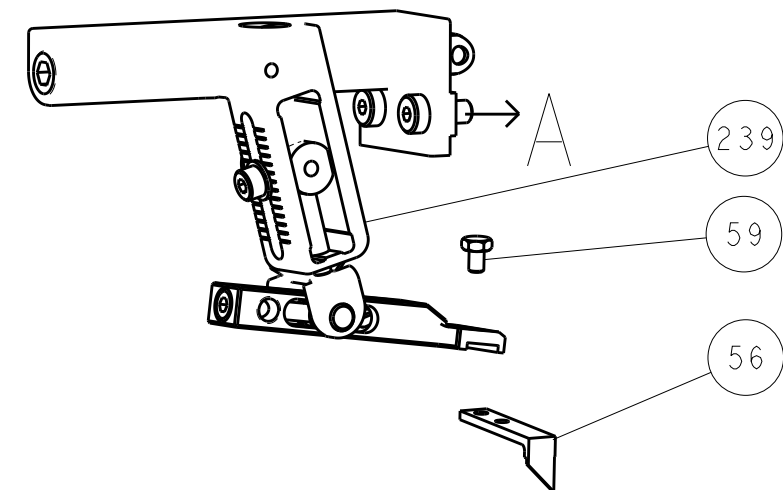
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				1	DEVELOPMENT	12AUG2015
				A	RELEASED	24SEP2015

-	-	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
-	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
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	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
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1	1-455888-5	SPACER, CRIMPER	82
-	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	2119656-9	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	2119644-1	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	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	2	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	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	5-1633933-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	-	2
1	1	1	1	1	1	6-456403-0	CRIMPER, WIRE PREMIUM	1

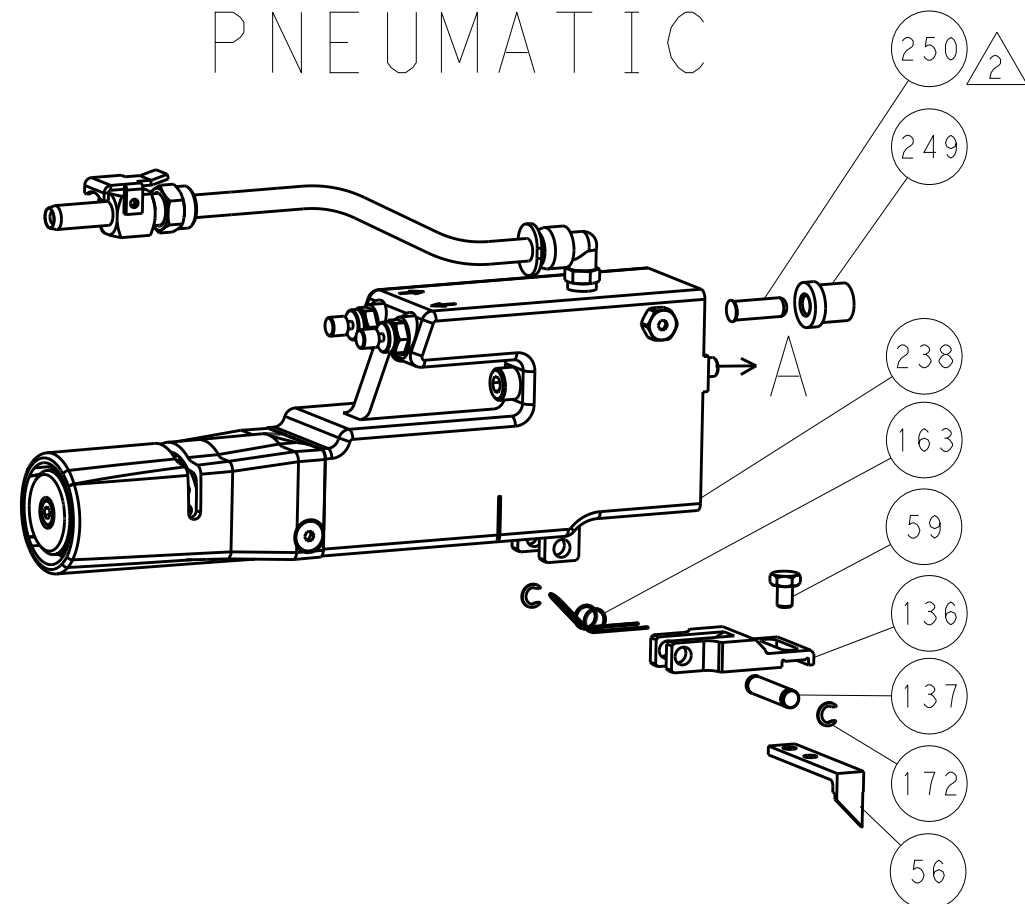
THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE CURRENT REVISIONS OF THIS DRAWING. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.		OWN J. HOU	12AUG2015	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK L. ZHANG	12AUG2015	NAME Ocean Side Feed Applicator	
mm		APVD J. GUO	12AUG2015	SIZE 00779	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		CAGE CODE DRAWING NO	
0 PLC ±.1		APPLICATION SPEC		RESTRICTED TO	
1 PLC ±.1		WEIGHT		A	
2 PLC ±.1		Customer Accessible Production Drawing		SCALE	
3 PLC ±.1		1:2		SHEET 1 OF 4	
4 PLC ±.1		REV		A	
ANGLES		FINISH			

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

FEED TYPE
MECHANICAL



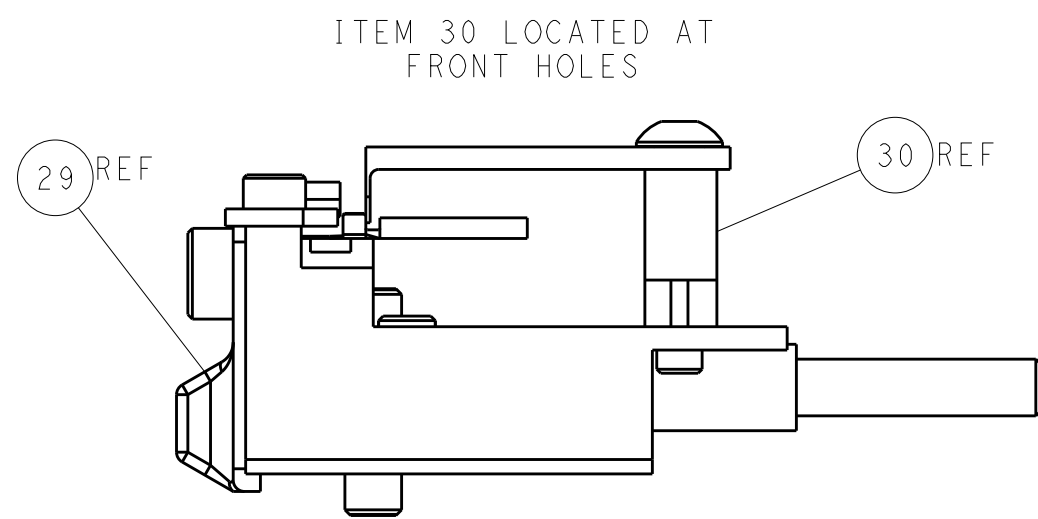
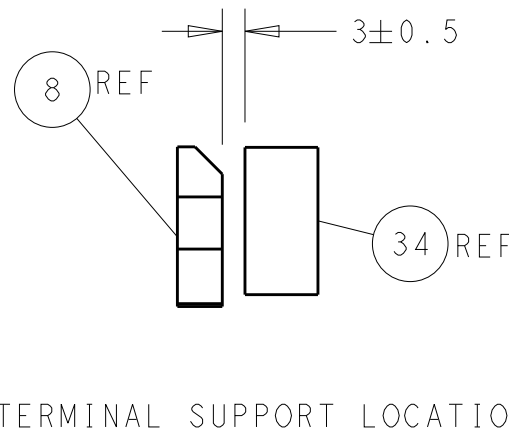
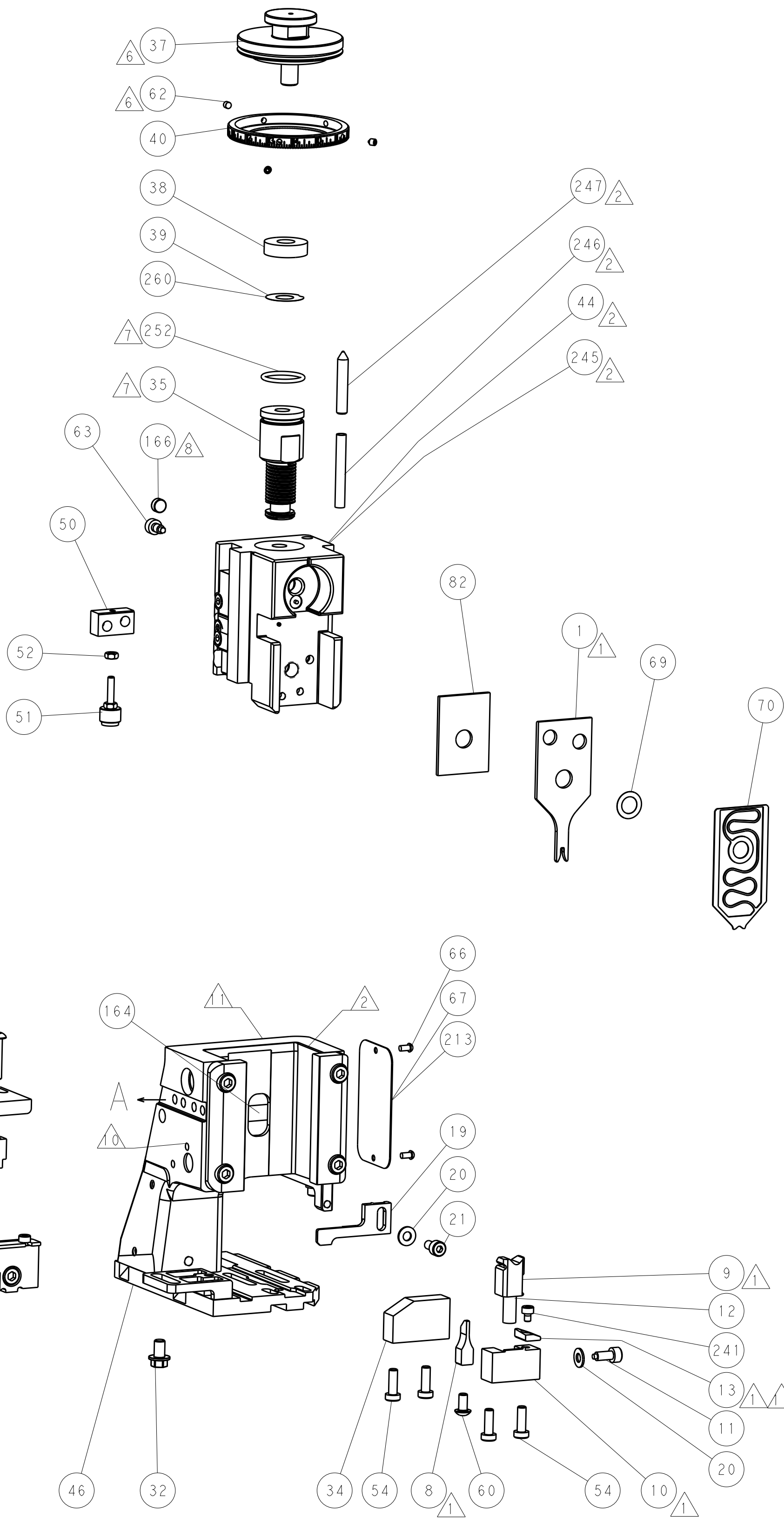
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



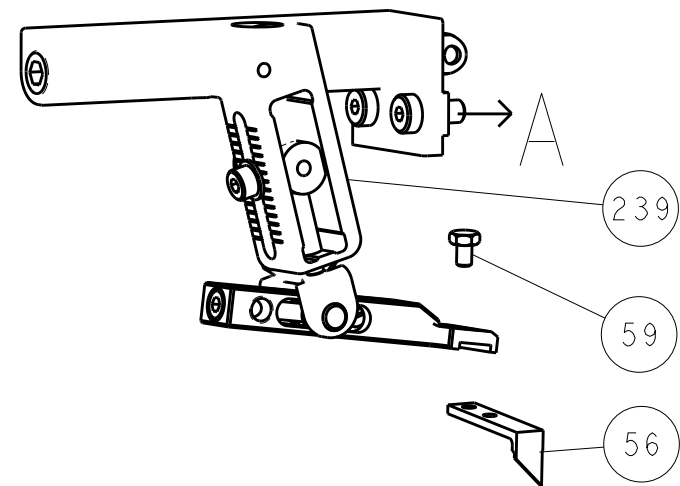
FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

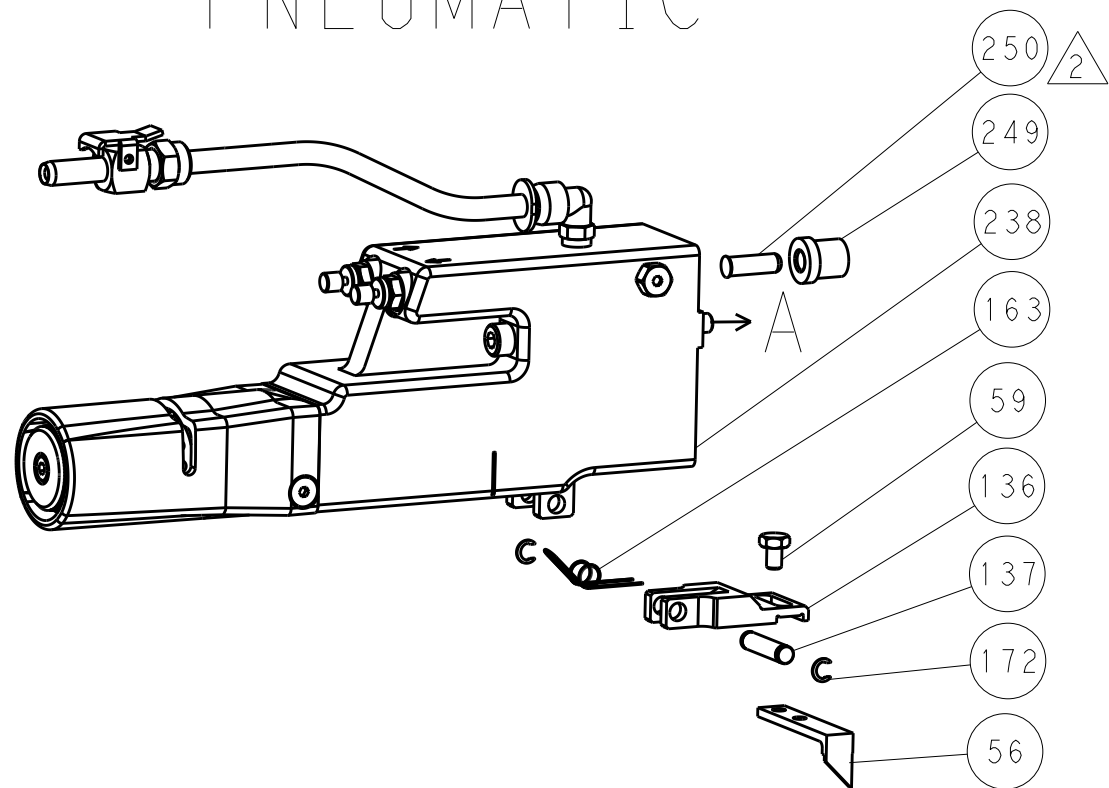
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		1 PLC ±		L. ZHANG		NAME	
		2 PLC ±		U. GUO		Ocean Side Feed	
		3 PLC ±		APVD		Applicator	
		4 PLC ±		PRODUCT SPEC		-	
		ANGLES ±		APPLICATION SPEC		SIZE	
		FINISH ±		WEIGHT		CAGE CODE	
				Customer Accessible Production Drawing		DRAWING NO	
				SCALE		RESTRICTED TO	
				1:2		A1 00779 ©=2266574	
				SHEET		REV	
				2		A	
				OF			
				4			

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

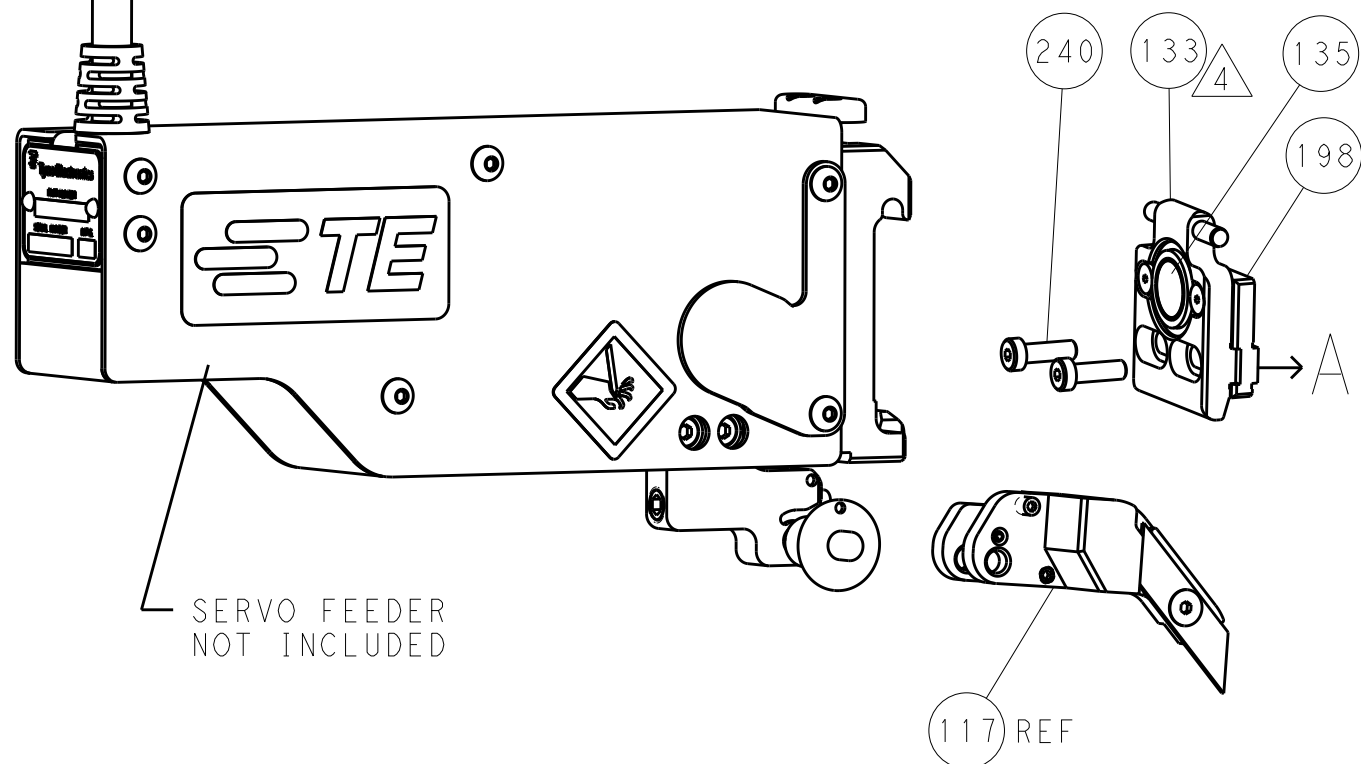
FEED TYPE MECHANICAL



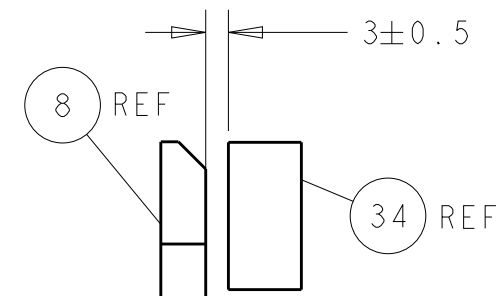
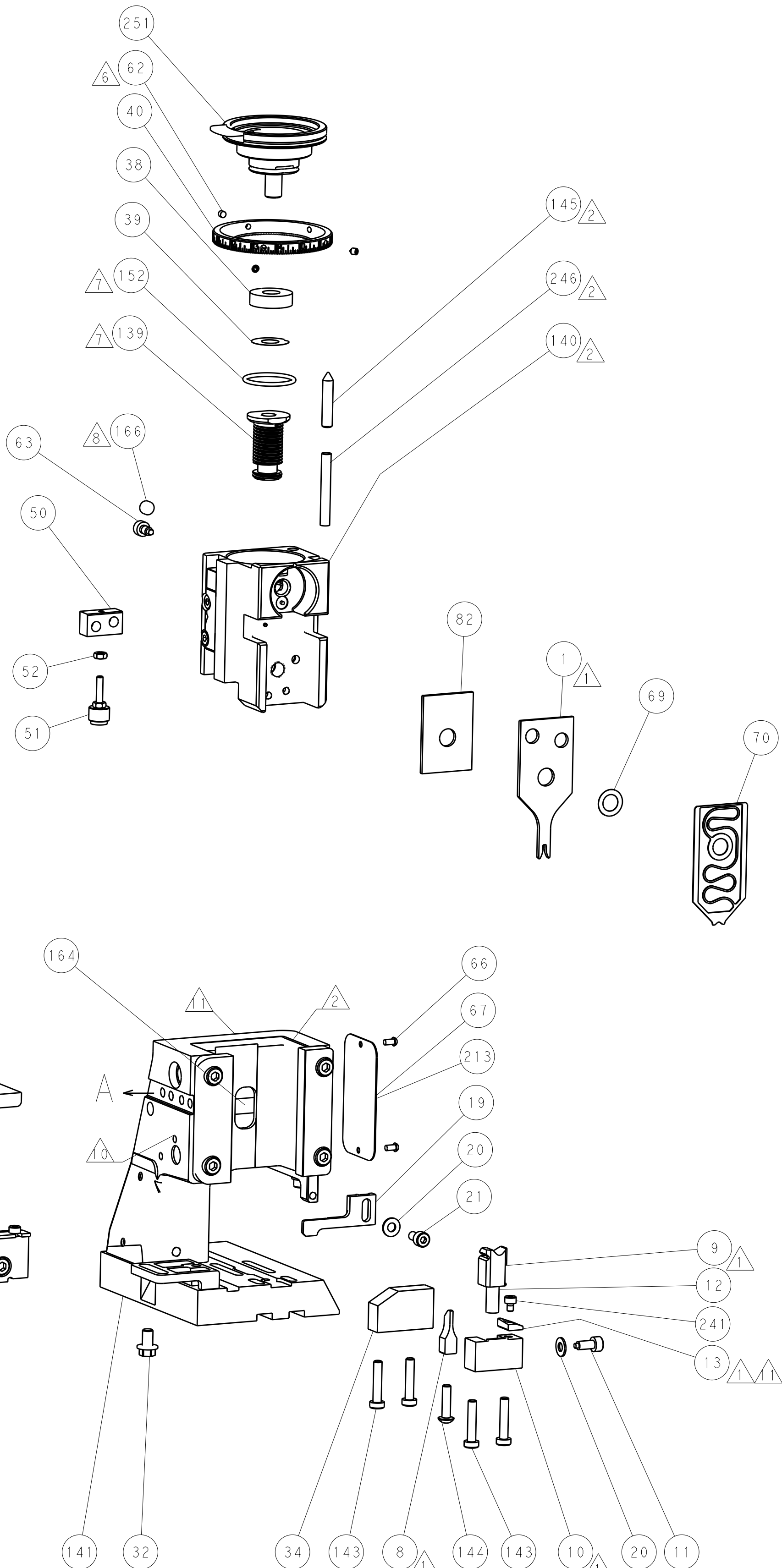
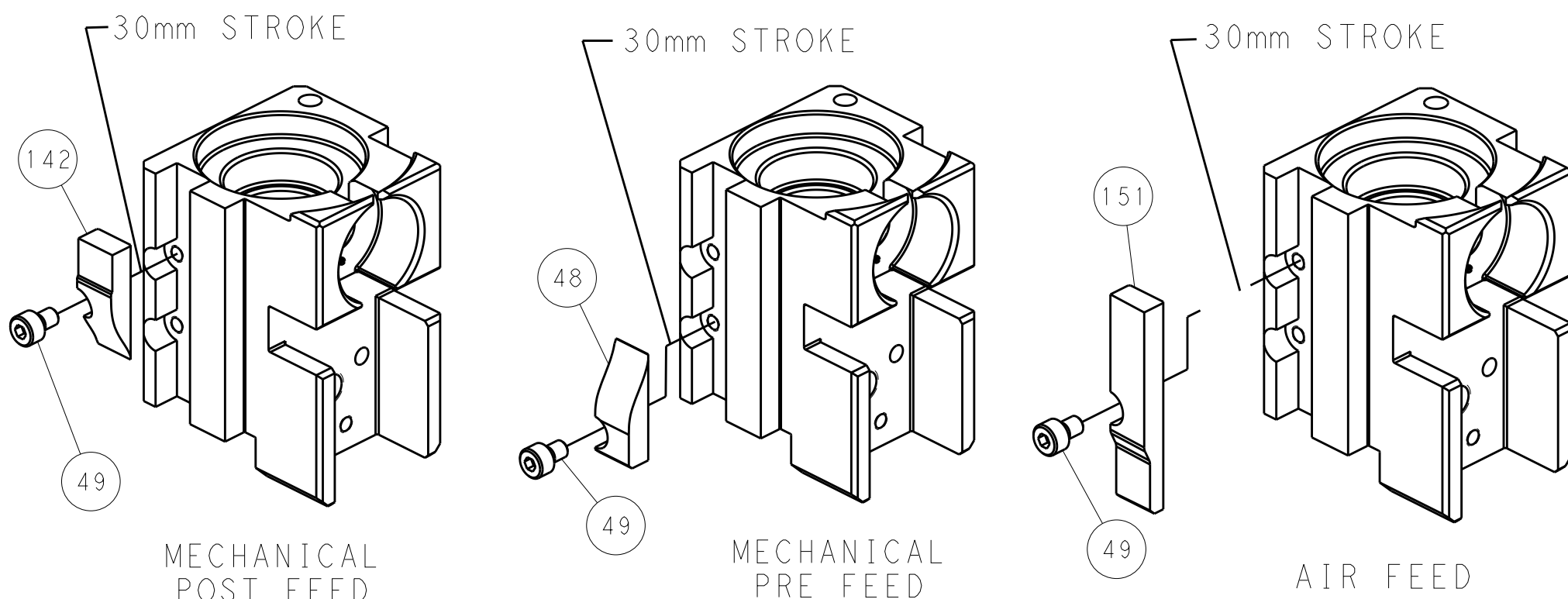
PNEUMATIC



SERVO LATCH PLATE

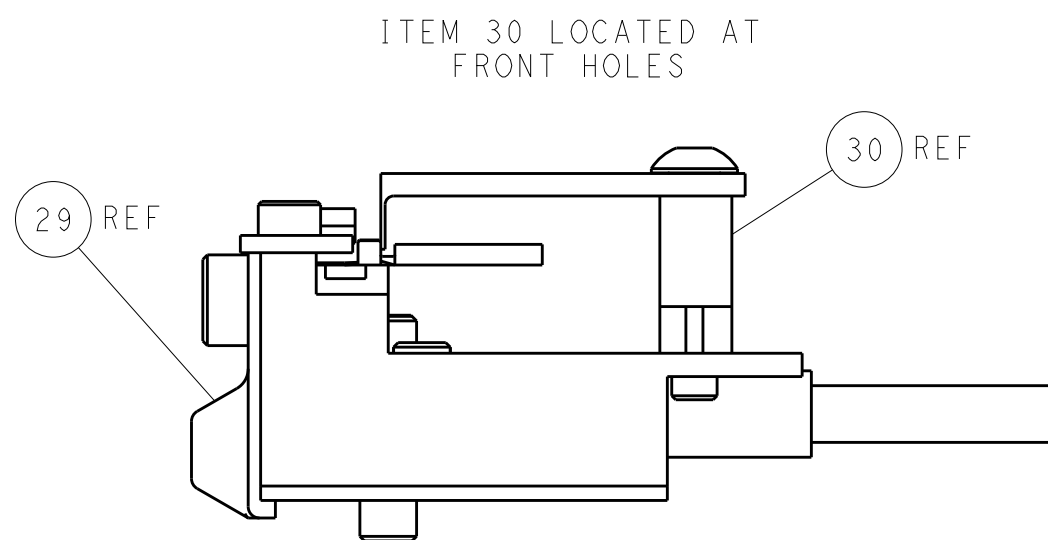


CAM POSITIONS



TERMINAL SUPPORT LOCATION

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



FEED TRACK POSITION
GUIDE BY WIRE BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		12AUG2015		STE		TE Connectivity	
mm		0 PLC ±		CHK		12AUG2015		Harrisburg, PA 17105-3608			
		1 PLC ±		APVD		12AUG2015		NAME		Ocean Side Feed	
		2 PLC ±		PRODUCT SPEC						Applicator	
		3 PLC ±		APPLICATION SPEC							
		4 PLC ±		WEIGHT							
		ANGLES		MATERIAL							
		FINISH		Customer Accessible Production Drawing		SCALE		1:2		SHEET 4 OF 4	
										REV A	