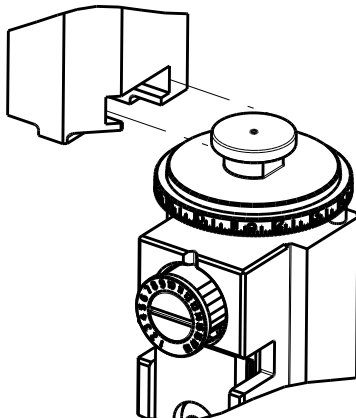


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
© COPYRIGHT 20		20	
BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2266324-1	B	FINE CRIMP HEIGHT ADJUST
	2266324-2	B	FINE CRIMP HEIGHT ADJUST
	2266324-5	B	FINE CRIMP HEIGHT ADJUST
	2266324-6	B	NON-CRIMP HEIGHT ADJUST
	2266324-7	B	FINE CRIMP HEIGHT ADJUST
	7-2266324-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: JST TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 2.63-3.39 mm [.104-.134 IN]		INSULATION DIAMETER RANGE Ø0.85-1.43 mm [.033-.056 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2113472-1	SF1M-002GC-M0.6A	2113472-2	SF1M-022T-M0.6A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.72+/-0.05 [.028+/- .002]	6.7
26 AWG	0.65+/-0.05 [.026+/- .002]	7.4
28 AWG	0.62+/-0.05 [.024+/- .002]	8.2

-
- 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: 8-2266324-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266324-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266324-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266324-6
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 62,180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37,180.
- 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 5.08.
- 13

THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

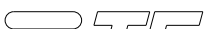
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	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	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-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)

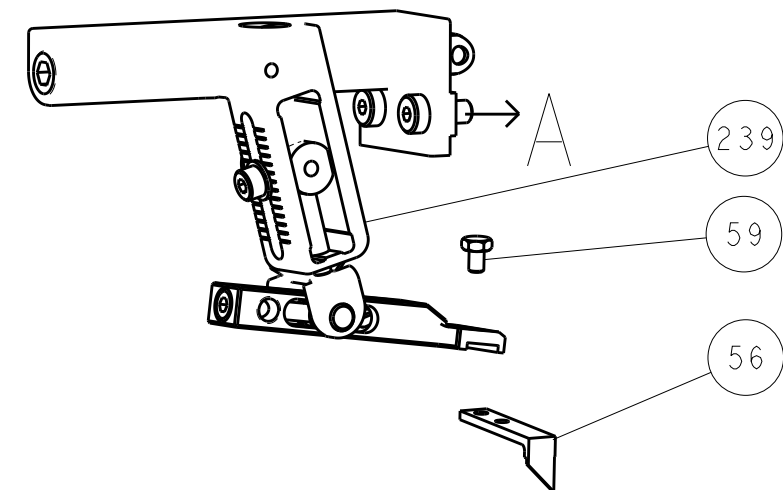
SET UP GAUGE 2119599-1	LOC	DIST	REVISIONS					
	A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
				B	ECR-15-017919	10DEC2015	KH	TE

6	-	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
	-	1	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	182
6	-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
	-	1	1	1	1	1	2-1752354-2	STANDOFF,HOLD-DOWN	180
	-	1	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176
	-	1	1	1	1	1	1752353-3	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	-	-	-	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	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	1	1	1	854769-4	HOLDER, INS	74	
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	-	-	1	1	2119740-1	TAG,IDENTIFICATION	67	
6	-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	-	-	-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	
6	-	1	1	1	1	1	1-2119644-4	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	1752356-6	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	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24	
1	-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	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	1633861-1	SHEAR, FLOATING	9
	1	1	1	1	1	1	2-1633917-7	ANVIL, COMBINATION	8
	-	1	1	1	1	1	2-240641-0	SPACER	7
	-	-	-	-	-	-	-	-	6
1	-	1	1	1	1	1	2119780-5	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	2-238011-3	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	1	3-1633962-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
	1	1	1	1	1	1	3-1633713-4	CRIMPER, WIRE PREMIUM	1
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

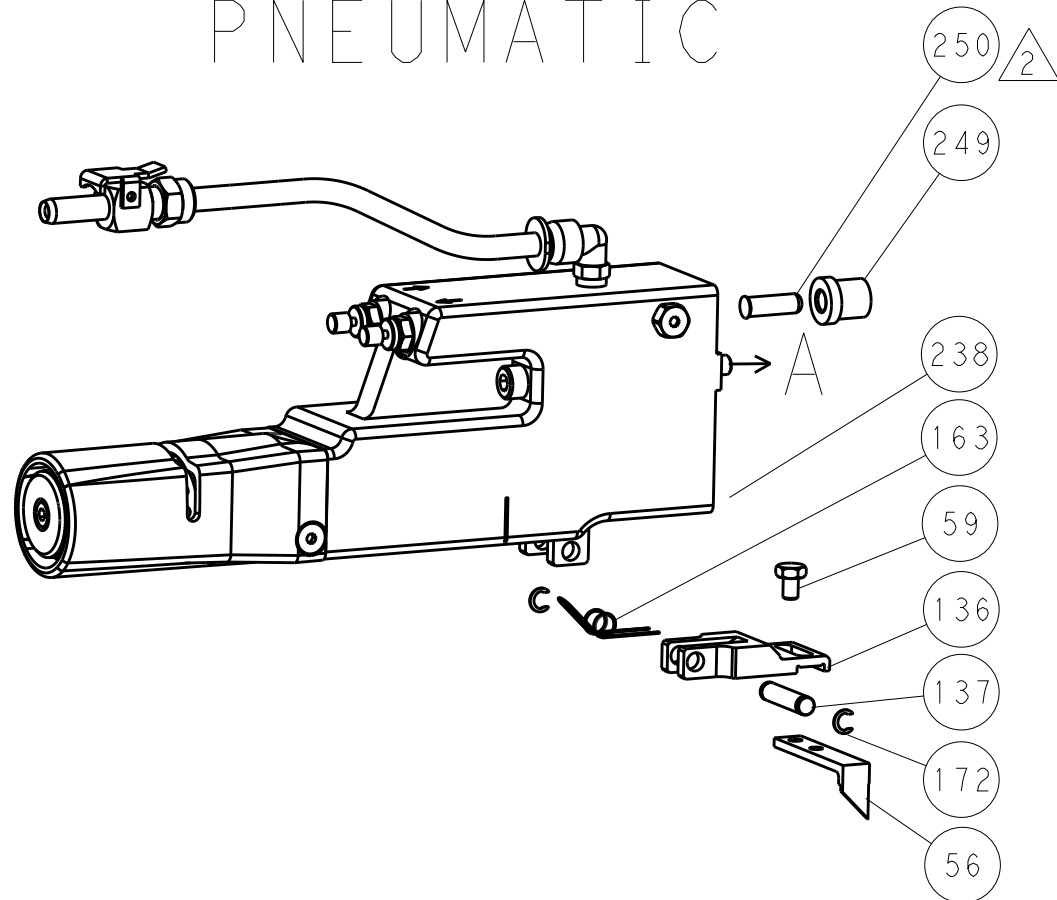
THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER'S DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.				DWN T.YIN	20JUN2014	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK G.BAILEY	20JUN2014					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD H.GUO	20JUN2014	NAME				
mm		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001		PRODUCT SPEC		Ocean Side Feed Applicator				
		FINISH		APPLICATION SPEC						
MATERIAL				WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
						A 00779	©=2266324		-	
Customer Accessible Production Drawing				SCALE	1:2	SHEET	1 OF 4	REV		
				B						

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

FEED TYPE
MECHANICAL



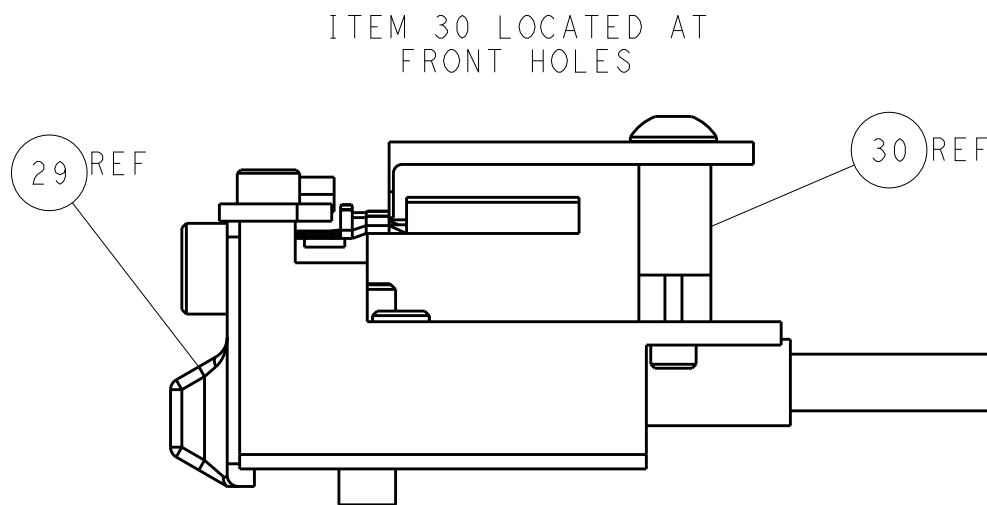
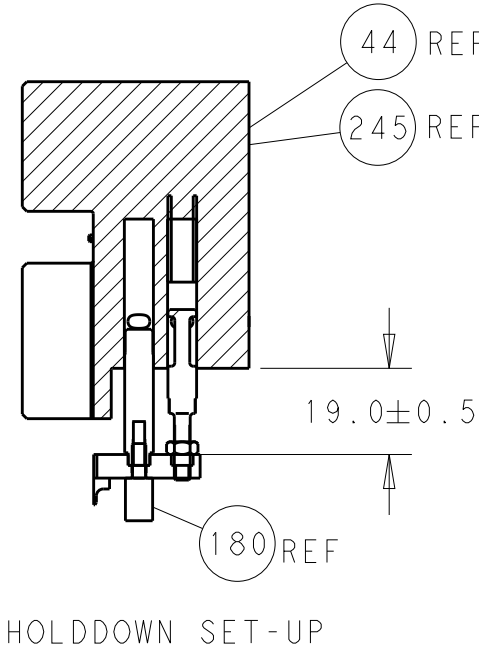
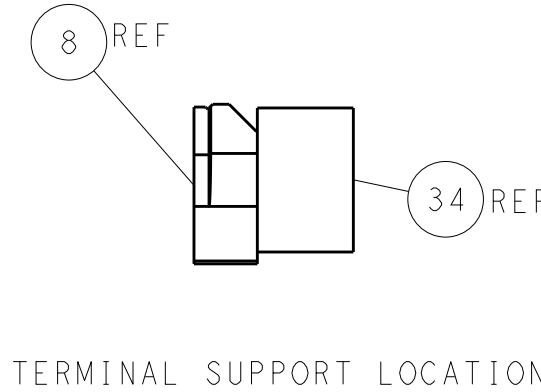
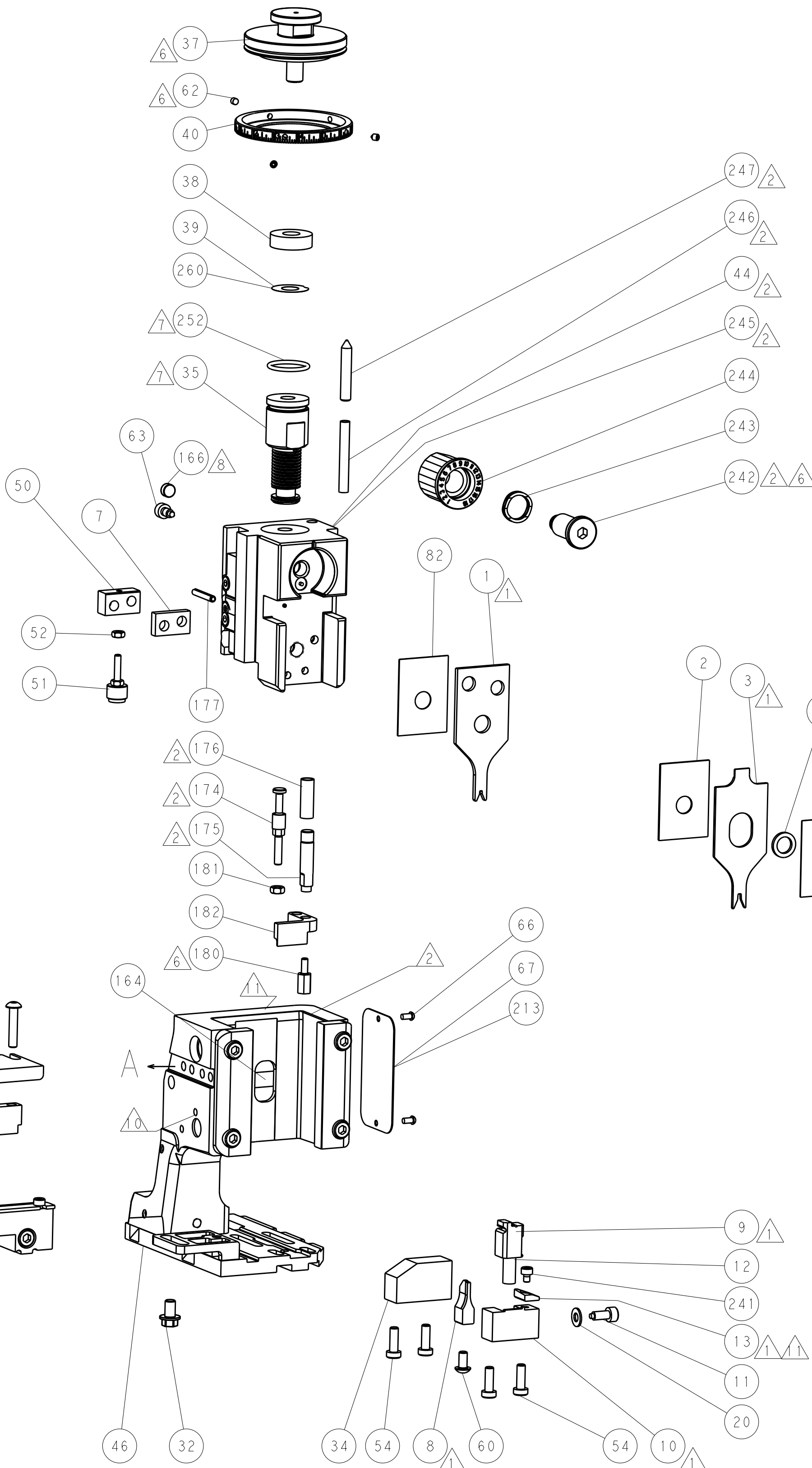
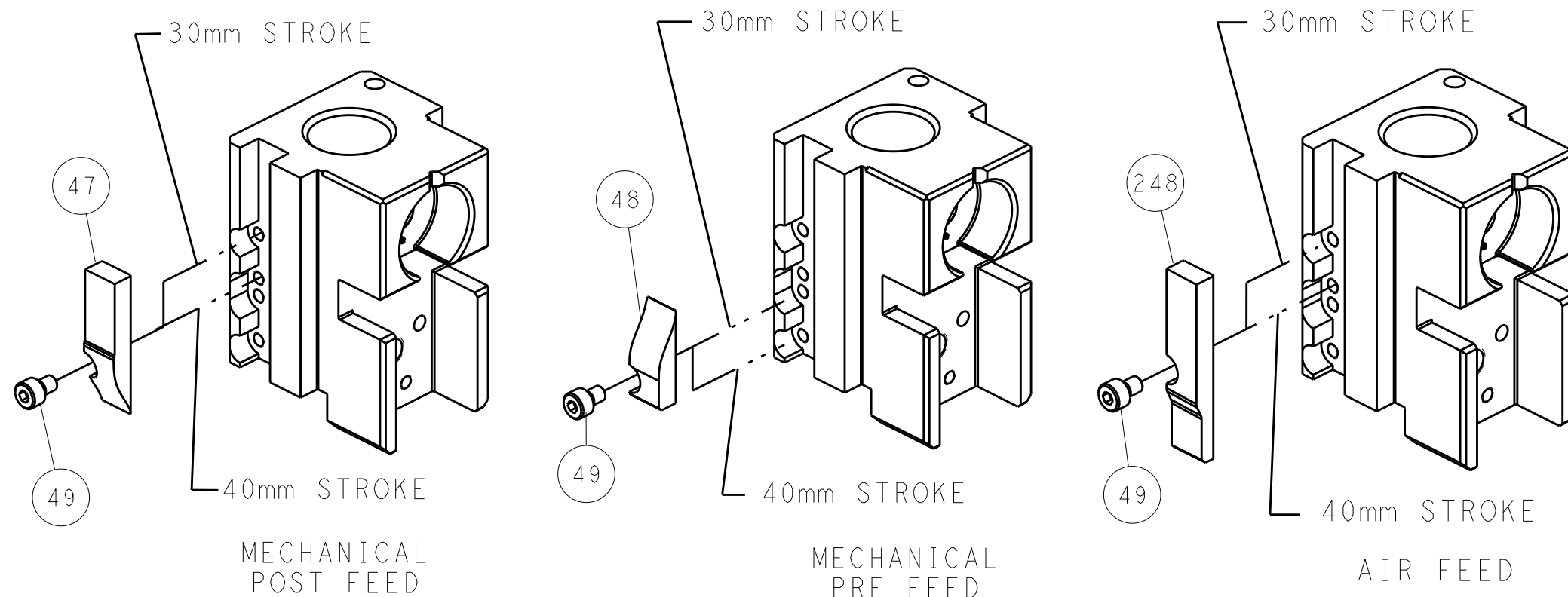
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



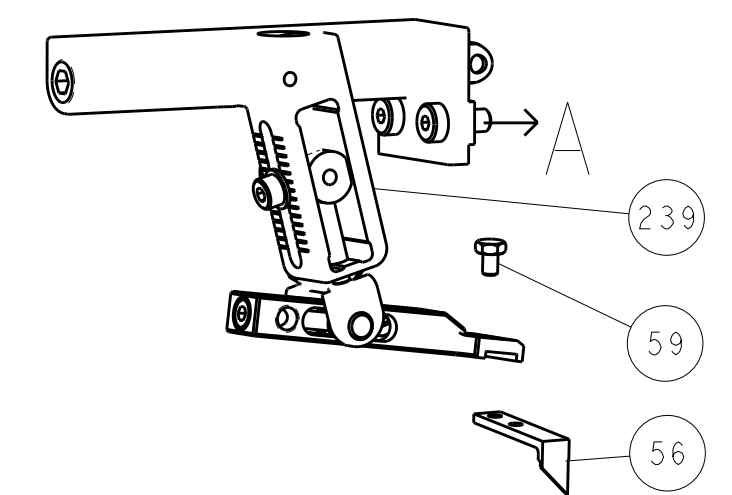
FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

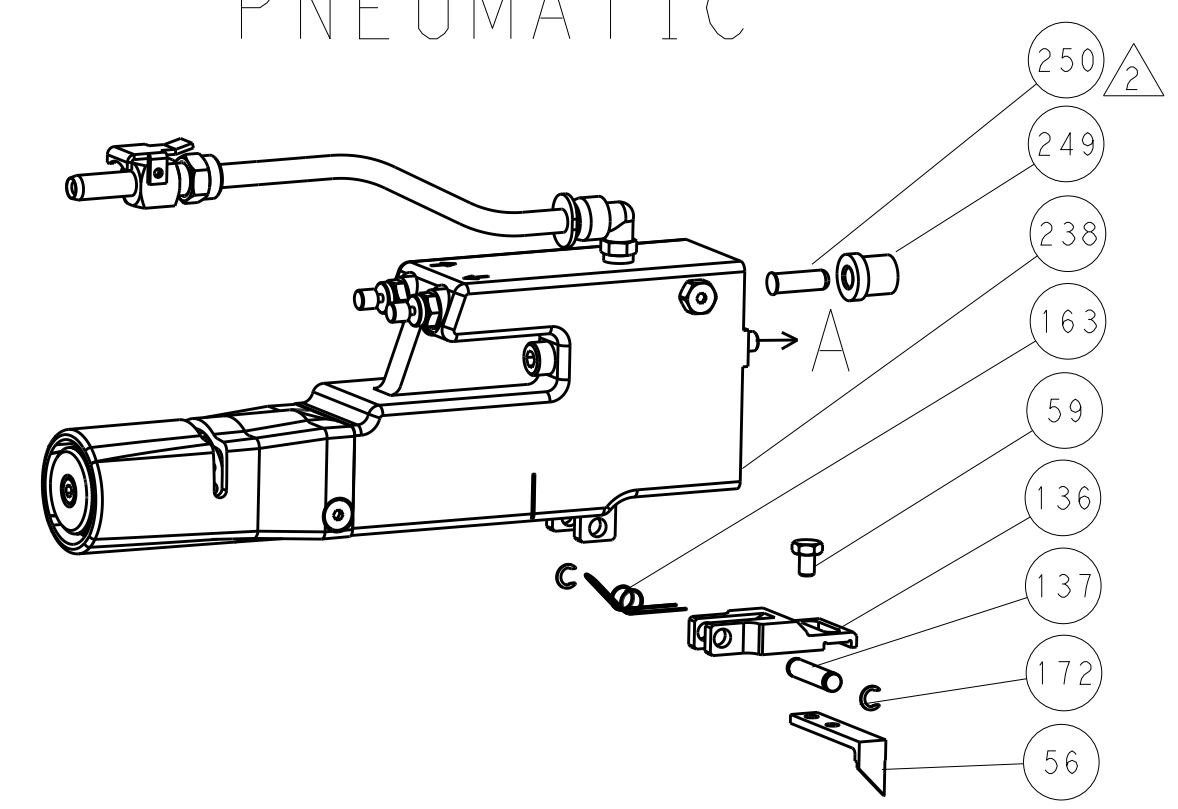
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. NO PARTS SHOULD BE ORDERED OR MANUFACTURED WITHOUT THE LATEST REVISION.		DWN	Y. YIN	20JUN2014	TE Connectivity	
DIMENSIONS:		CHK	G. BAILEY	20JUN2014	Harrisburg, PA 17105-3608	
mm		APVD	J. GUO	20JUN2014	NAME Ocean Side Feed Applicator -	

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

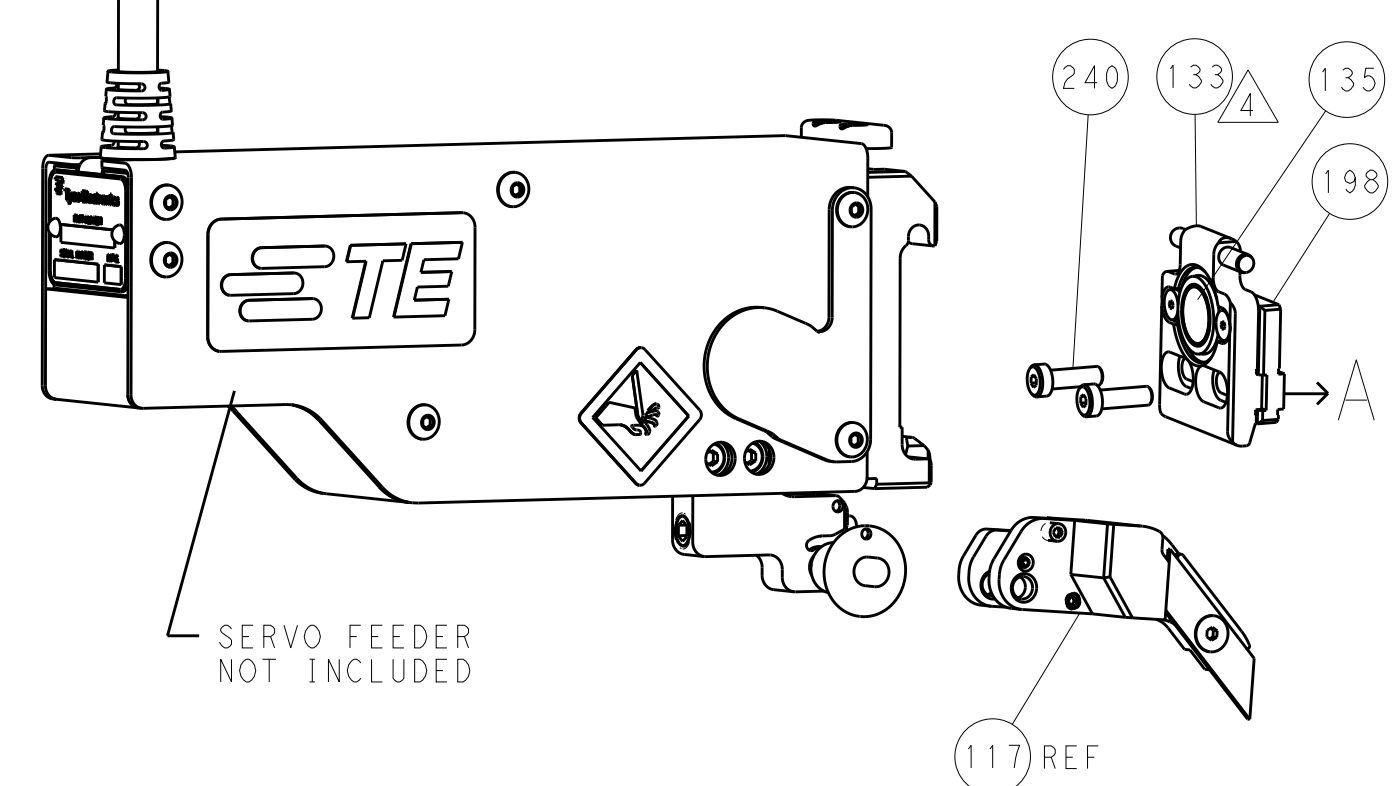
FEED TYPE
MECHANICAL



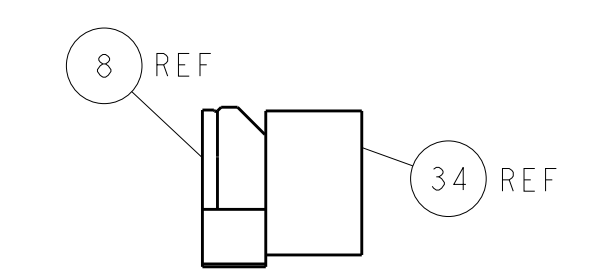
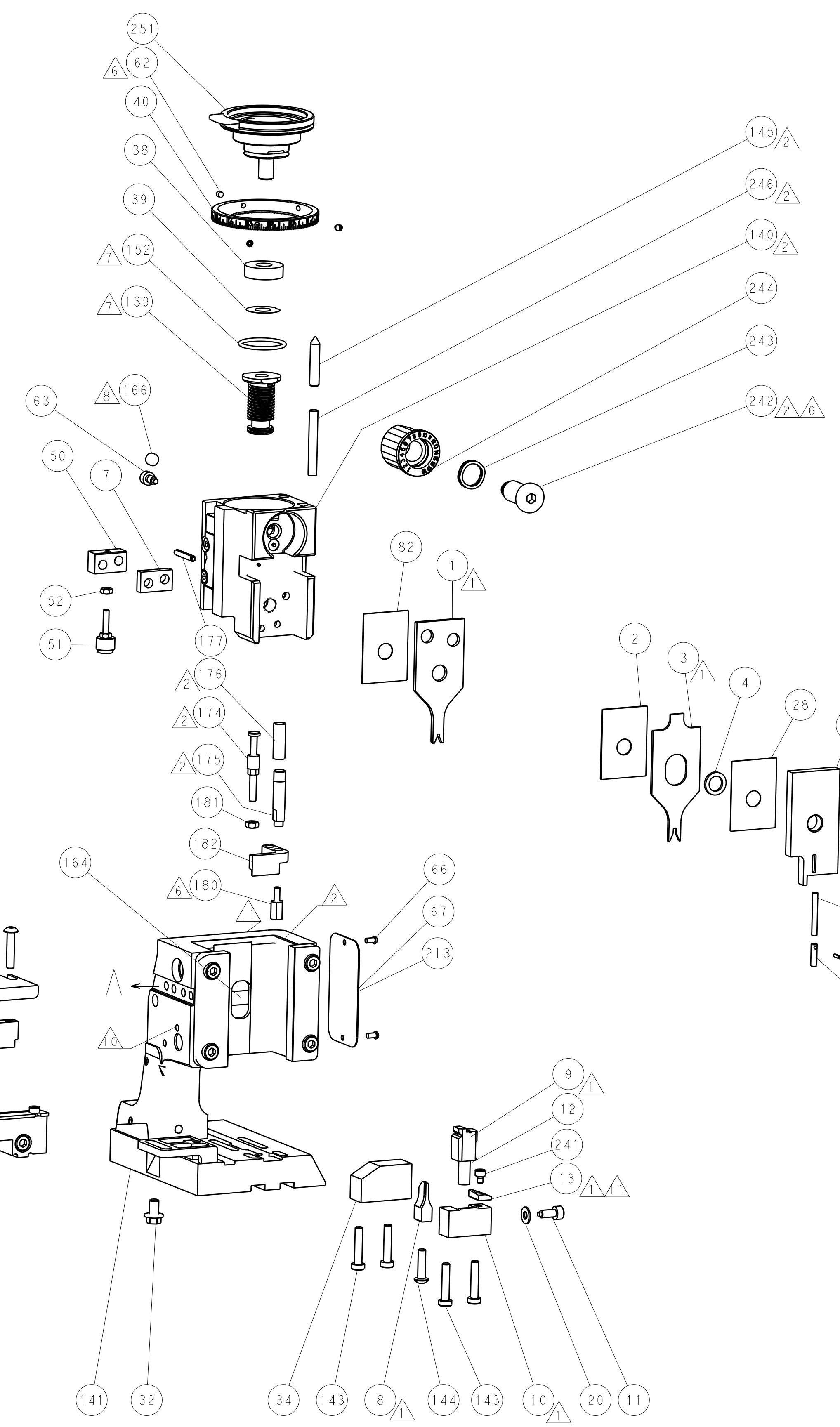
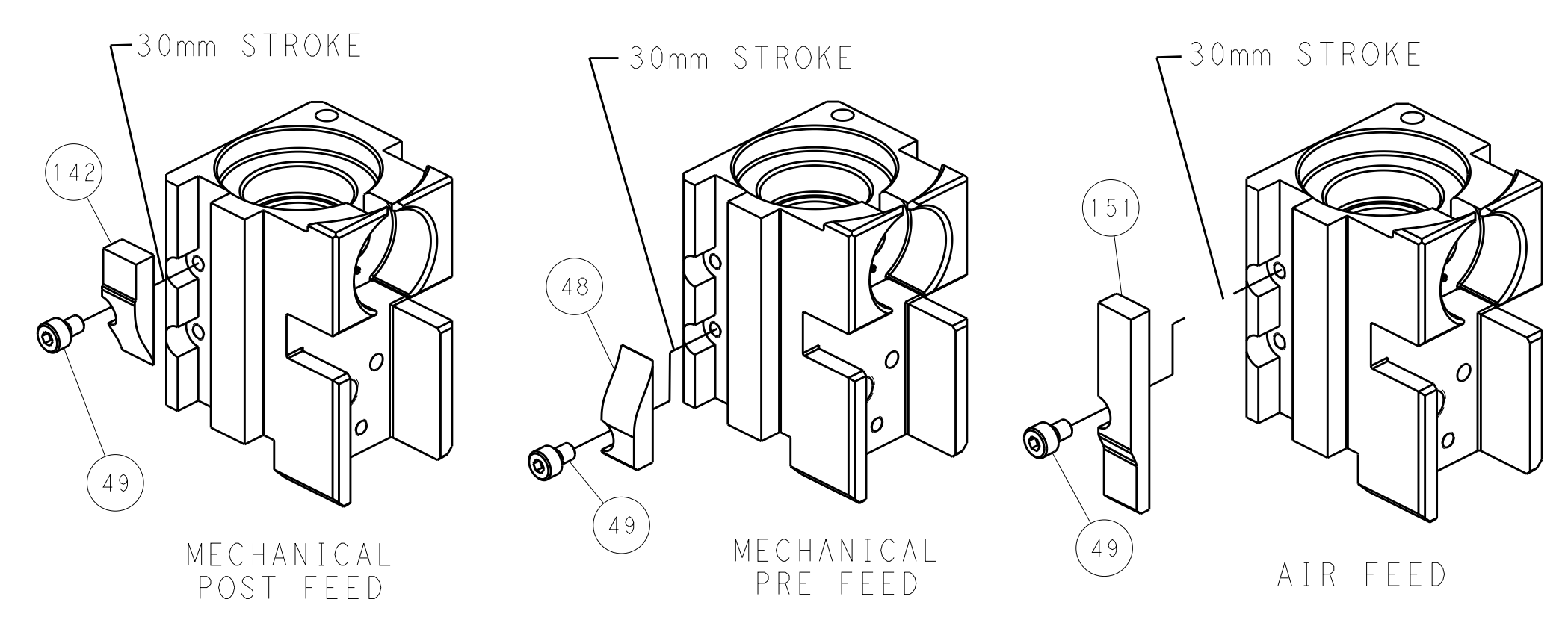
PNEUMATIC



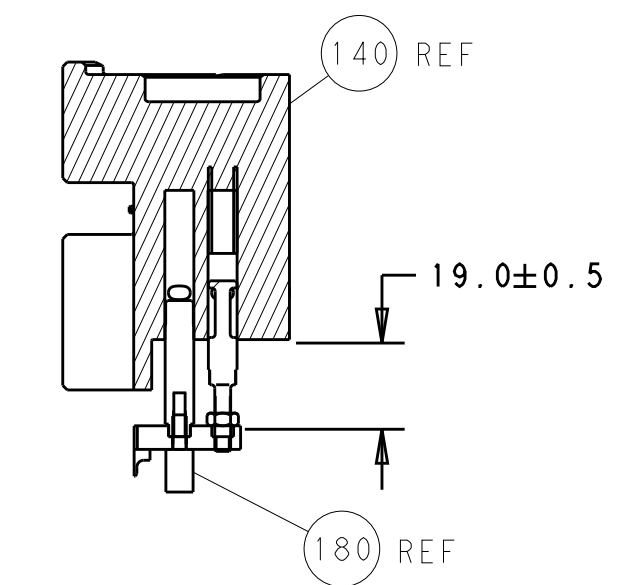
SERVO
LATCH PLATE



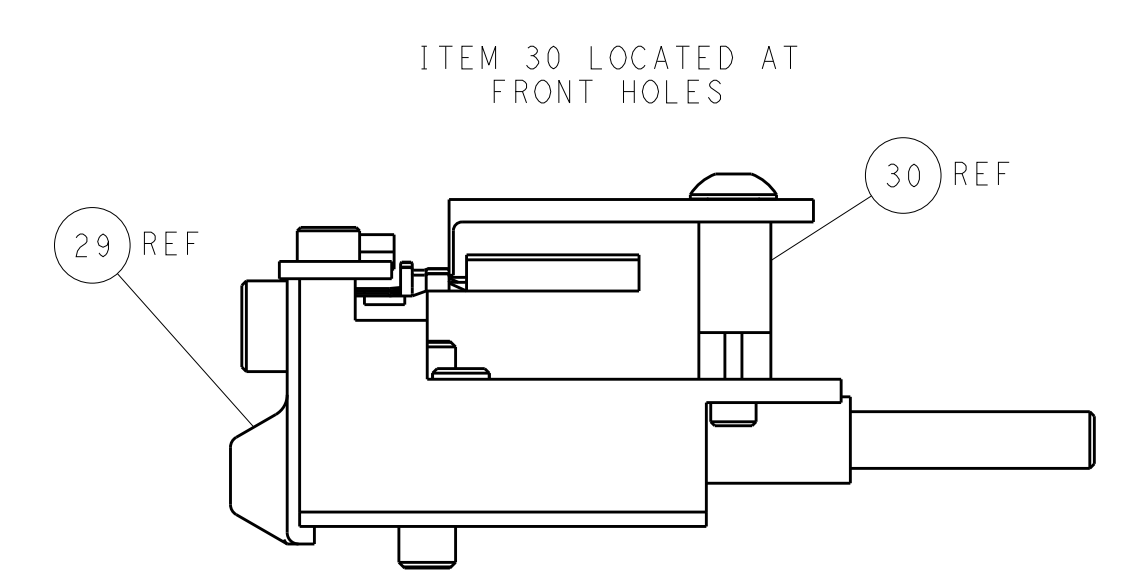
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 20JUN2014		CHK G. BAILEY 20JUN2014		APVD H. GUO 20JUN2014		NAME Ocean Side Feed Applicator	
0 PLC ±.5		1 PLC ±0.13		2 PLC ±0.13		3 PLC ±0.013		4 PLC ±0.001		SIZE A1	
MATERIAL		FINISH		WEIGHT		CAGE CODE 00779		DRAWING NO C=2266324		RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 4		OF 4		REV B			