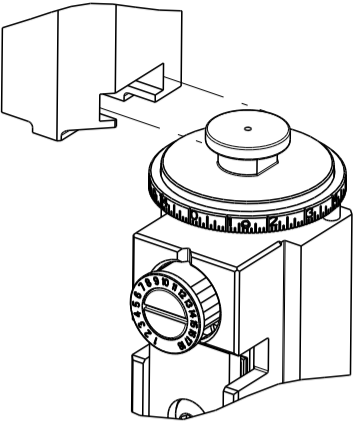


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART								
					CONVERT TO	PART NUMBERS REQUIRED							
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
	2266320-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2266320-5	1901094-3	-	2168400-6 (QUANTITY 2)		
	2266320-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-		
					SERVO LATCH PLATE	2119951-1	-	8-2266320-5	1901094-3	-	2168400-6 (QUANTITY 2)		
					SMART APPLICATOR	2161326-1	-	8-2266320-4	-	-			
	2266320-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-		
	2266320-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴ ¹²	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1		
	2266320-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-		
7-2266320-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-			

SET UP GAUGE	LOC	DIST	REVISIONS												
2119599-1	A	66	<table border="1"> <thead> <tr> <th>#</th> <th>DATE</th> <th>DESCRIPTION</th> <th>DATE</th> <th>OWN</th> <th>APVD</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>RELEASED</td> <td></td> <td>16JUL2014</td> <td>RW</td> <td>TE</td> </tr> </tbody> </table>	#	DATE	DESCRIPTION	DATE	OWN	APVD	A	RELEASED		16JUL2014	RW	TE
#	DATE	DESCRIPTION	DATE	OWN	APVD										
A	RELEASED		16JUL2014	RW	TE										

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.50 mm [.059]	F
INSUL	1.90 mm [.075]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, SOCKET	
WIRE STRIP LENGTH 2.00-2.50 mm [.079-.098 1N]	INSULATION DIAMETER RANGE ∅1.20-1.90 mm [.047-.075 1N]
TERMINAL APPLICATION SPECIFICATION TAD-P-0506 Rev 1	
TERMINALS APPLIED	
TE TERMINAL	HIROSE TERMINAL
1572023-1	DF1E-2022SCF

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.93+/-0.05 [.037+/-0.002]	4.6
22 AWG	0.83+/-0.05 [.033+/-0.002]	5.5

- 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: 8-2266320-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266320-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266320-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266320-6

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. 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.

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 4.87.

13 CUT TO LENGTH AT ASSEMBLY.

*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
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-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)

6	-	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
-	-	-	-	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	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
-	1	1	1	1	1	-	1-22281-8	SPRING, COMPRESSION	121
-	-	REF	REF	-	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1	-	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2	-	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	-	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	1	-	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	-	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	1	-	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	-	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
6	-	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	-	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	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
3	-	4	4	4	4	-	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	-	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	1-2119644-4	RAM WASHER, PRECISION	38
6	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	-	2-1752356-3	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	-	1901086-1	PLATE, STRIP GUIDE	29
-	1	1	1	1	1	-	455888-3	SPACER, CRIMPER	28
-	2	2	2	2	2	-	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	-	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	-	240792-3	DRAG, TERMINAL	25
-	1	1	1	1	1	-	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	-	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	-	-	-	-	-	-	-	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1	1803328-1	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1	455888-2	SPACER, CRIMPER	2
1	1	1	1	1	1	1	1803325-3	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	-	PART NO	DESCRIPTION	ITEM NO

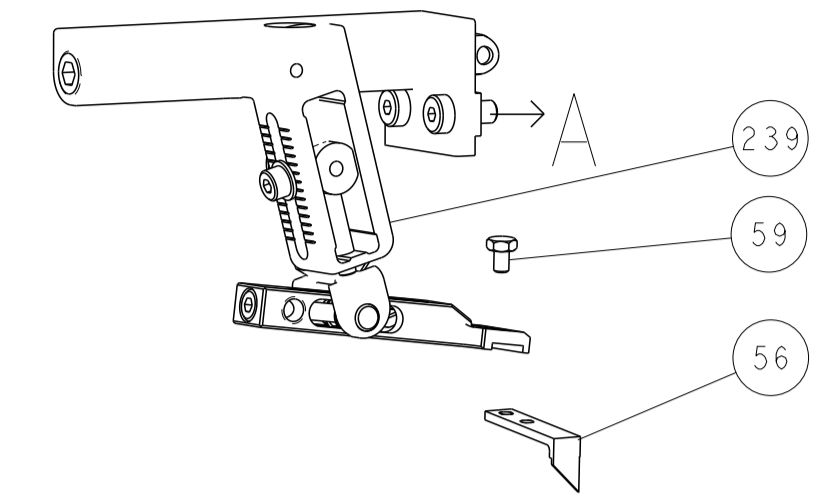
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	NAME
mm	0 PLC ±.1 1 PLC ±.05 3 PLC ±.03 4 PLC ±.02 ANGLES ±.1	06 JUN 2014	R.O. WILSON
		06 JUN 2014	G. I. HOFFNER
		09 JUN 2014	T. L. ELBIN

PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
-	-	A1	00779	2266320	-

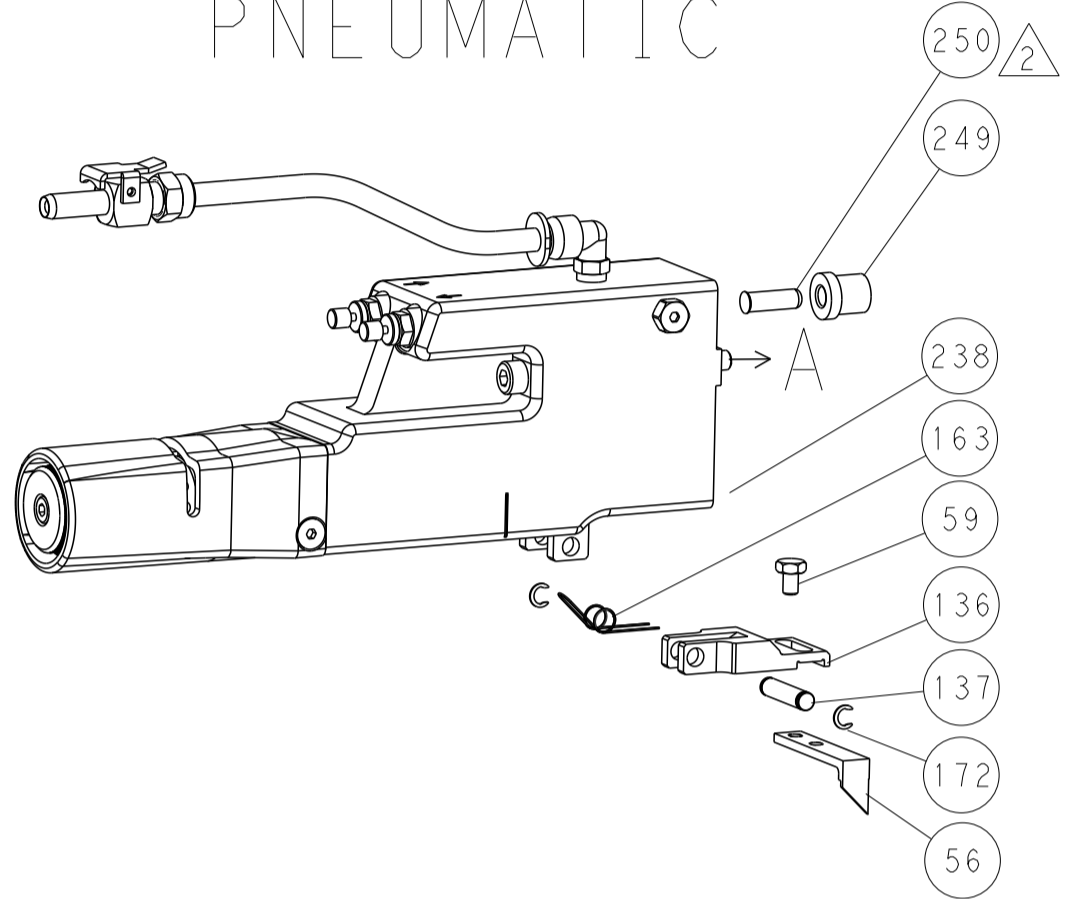
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV B

LOC	DIST	REV	DATE	BY	APPV
A	66				

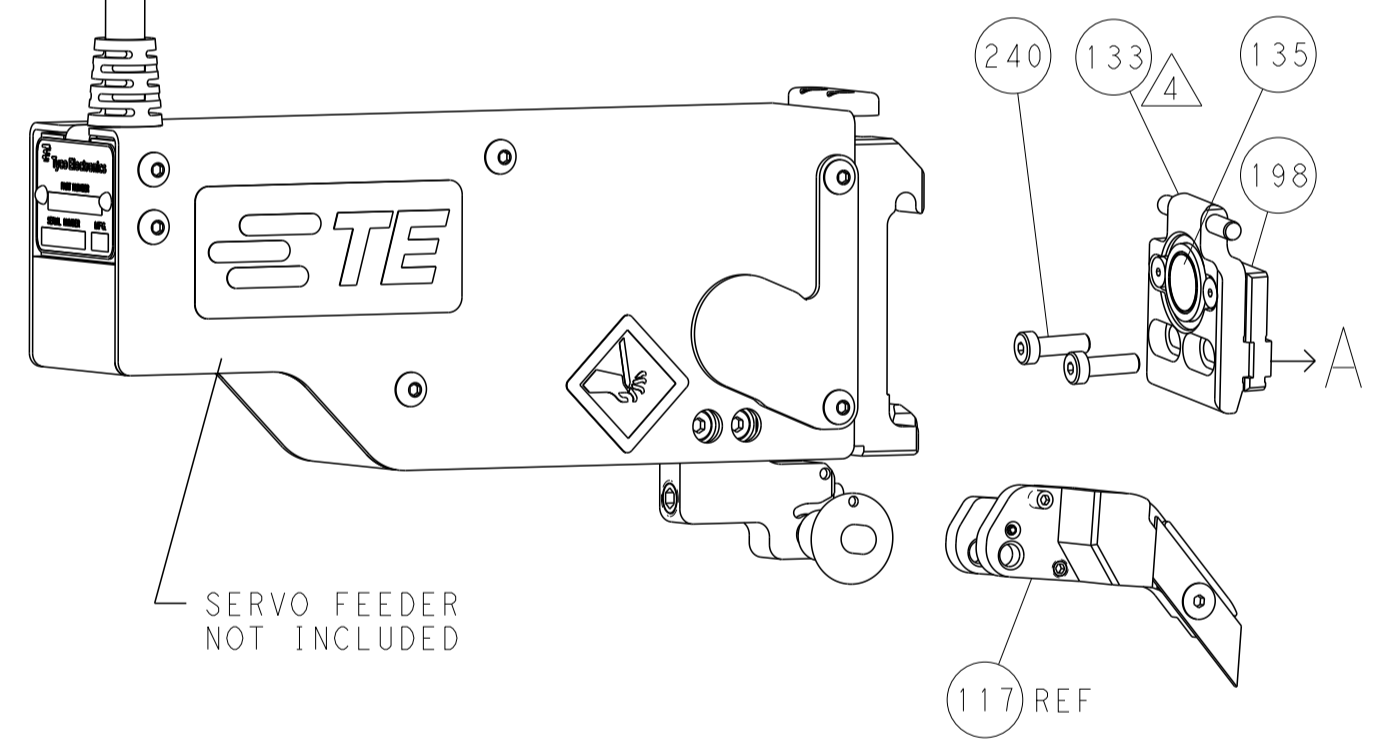
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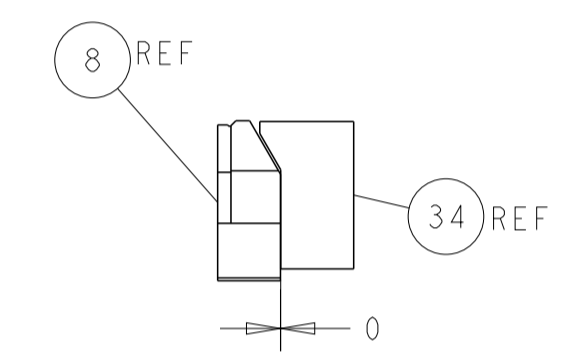
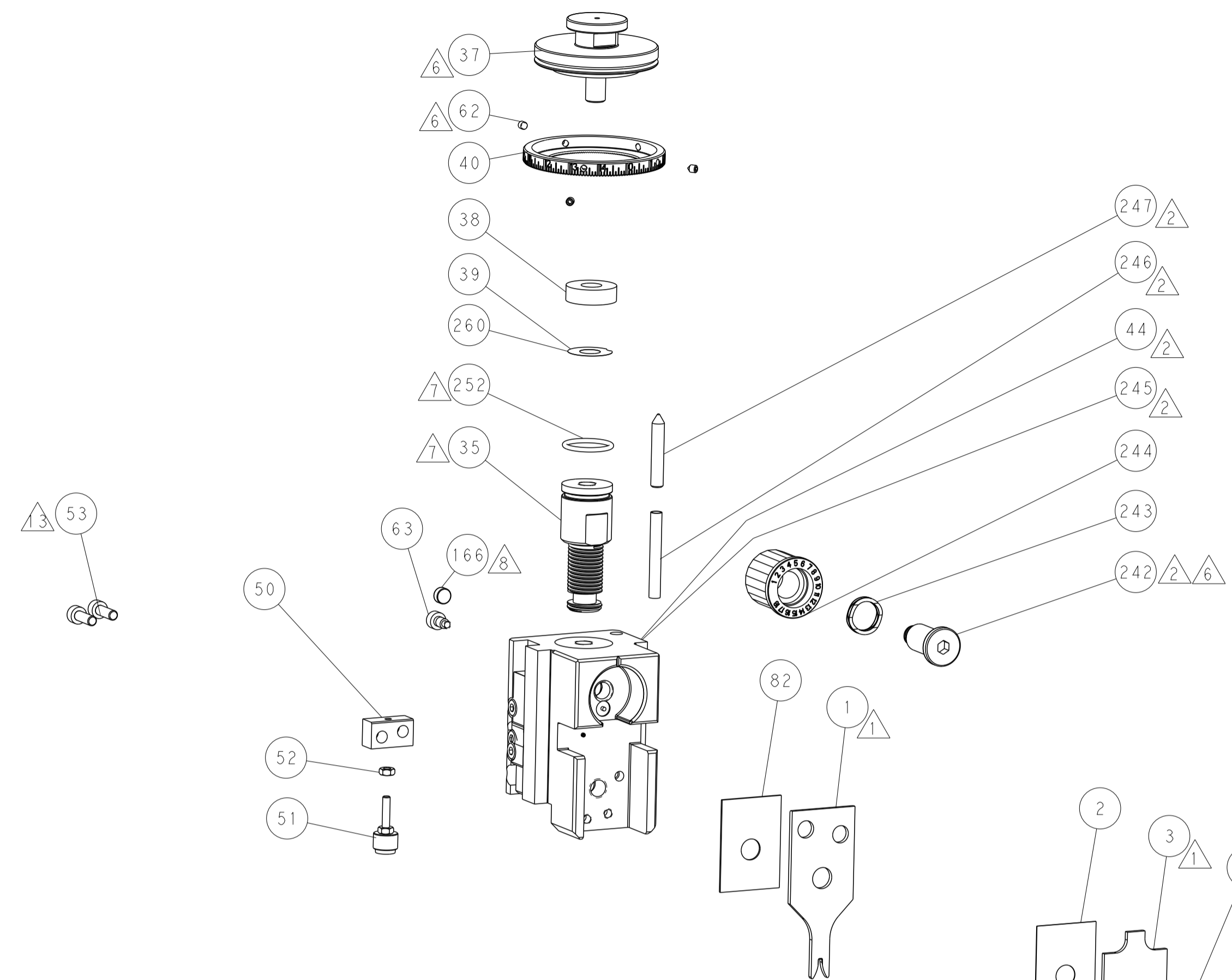
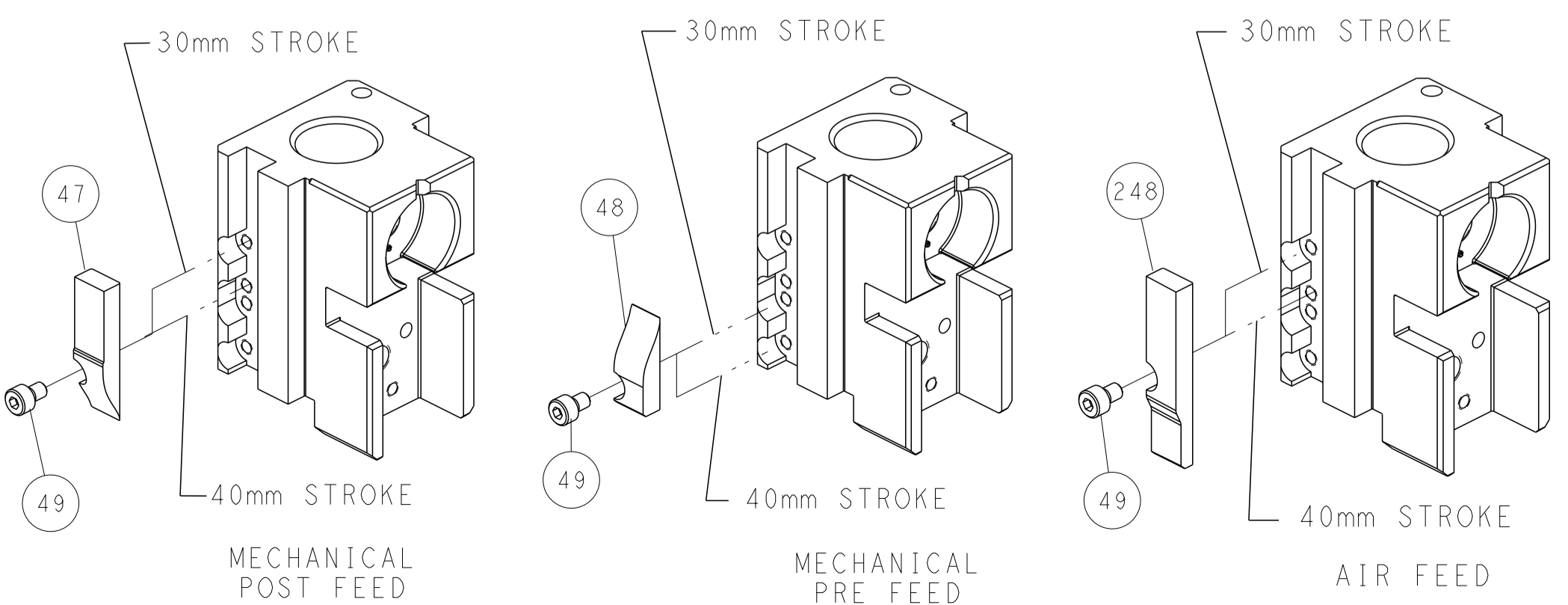
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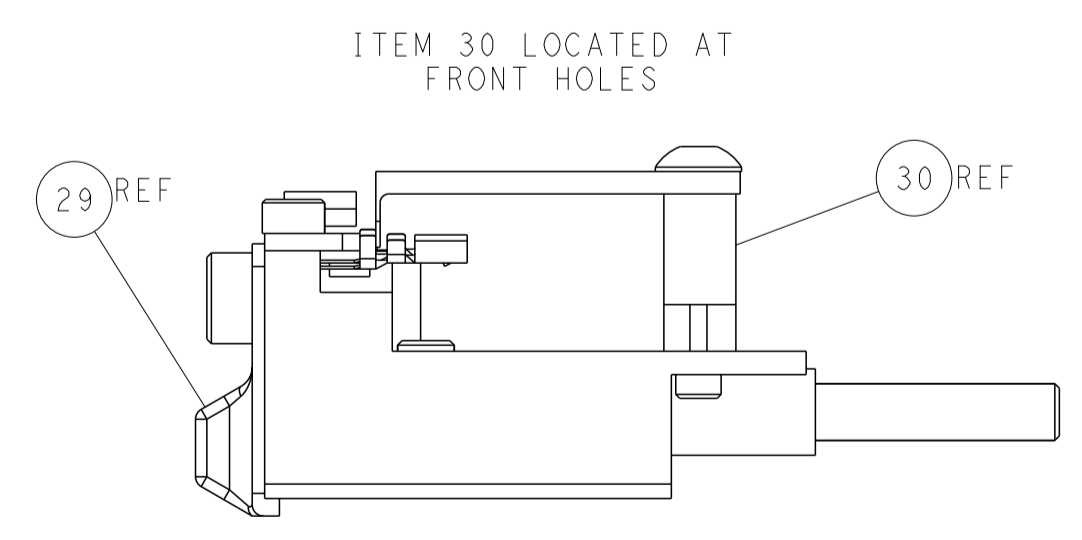
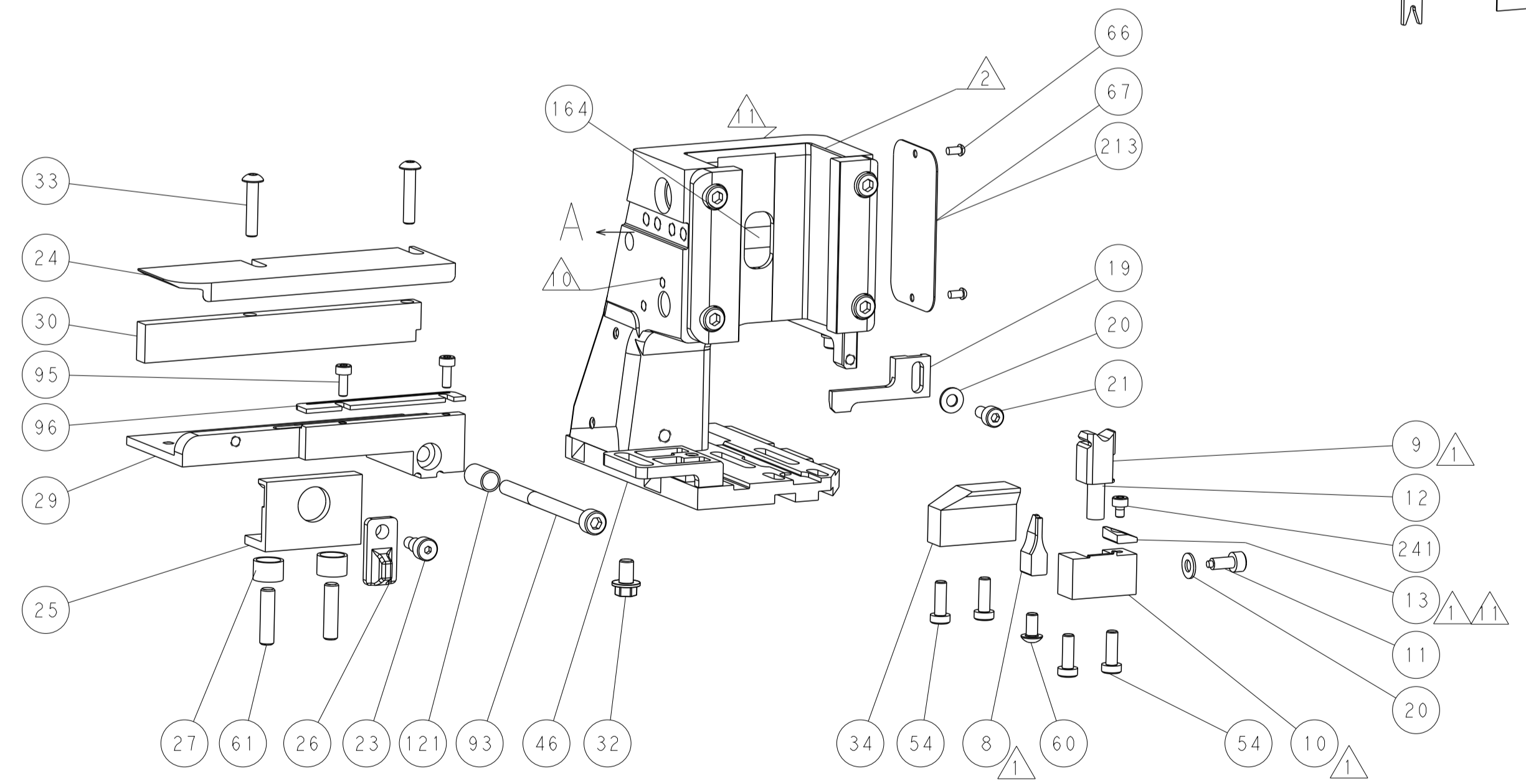
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION

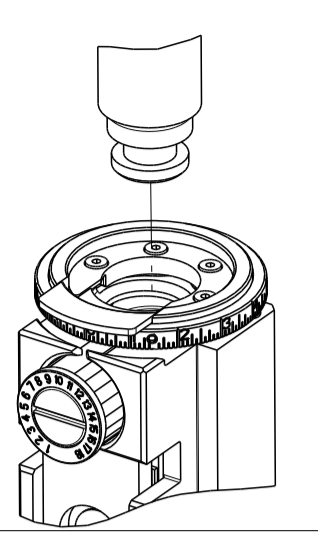



ITEM 30 LOCATED AT FRONT HOLES

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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R. O. WILSON 06JUN2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME: G. J. HOFFNER 06JUN2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: T. L. ELBIN 09JUN2014		Ocean Side Feed Applicator	
				PRODUCT SPEC:		RESTRICTED TO:	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				WEIGHT:		A1 00779 ©=2266320	
				Customer Accessible Production Drawing		SCALE: 1:2 SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
				CONVERT TO	PART NUMBERS REQUIRED						
	2-2266320-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2266320-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266320-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266320-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
	2-2266320-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	-	8-2266320-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR					2161326-1	-	8-2266320-4	-	-		
2-2266320-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266320-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE		TYPE
WIRE	1.50 mm [.059]	F
INSUL	1.90 mm [.075]	O
APPLICATOR INSTRUCTIONS 408-10389 		

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, SOCKET	
WIRE STRIP LENGTH 2.00-2.50 mm [.079-.098 IN]	INSULATION DIAMETER RANGE Ø1.20-1.90 mm [.047-.075 IN]
TERMINAL APPLICATION SPECIFICATION TAD-P-0506 Rev 1	-
TERMINALS APPLIED	
TE TERMINAL	HIROSE TERMINAL
1572023-1	DF1E-2022SCF

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
20 AWG	0.93+/-0.05 [.037+/-0.002]	4.6
22 AWG	0.83+/-0.05 [.033+/-0.002]	5.5

-  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: 8-2266320-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266320-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266320-5
- 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.
-  CUT TO LENGTH AT ASSEMBLY.


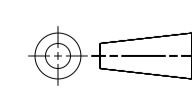
*WARNING
 ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	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	2119082-5	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
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

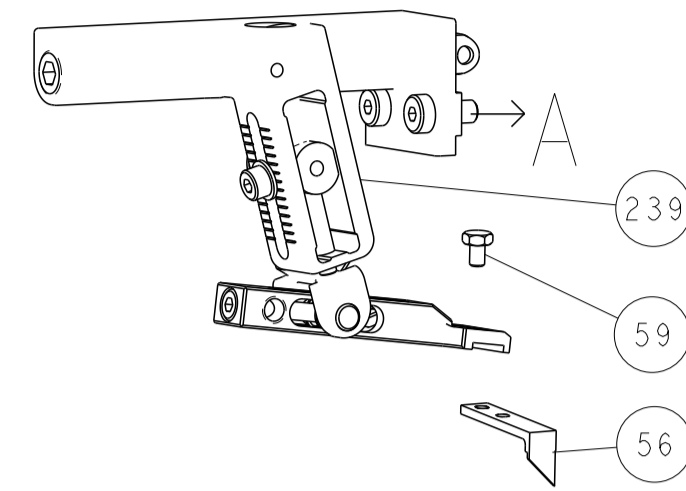
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE		LOC	DIST	REVISIONS					
2119599-1		A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	-	-	SEE SHEET 1	-	-	-

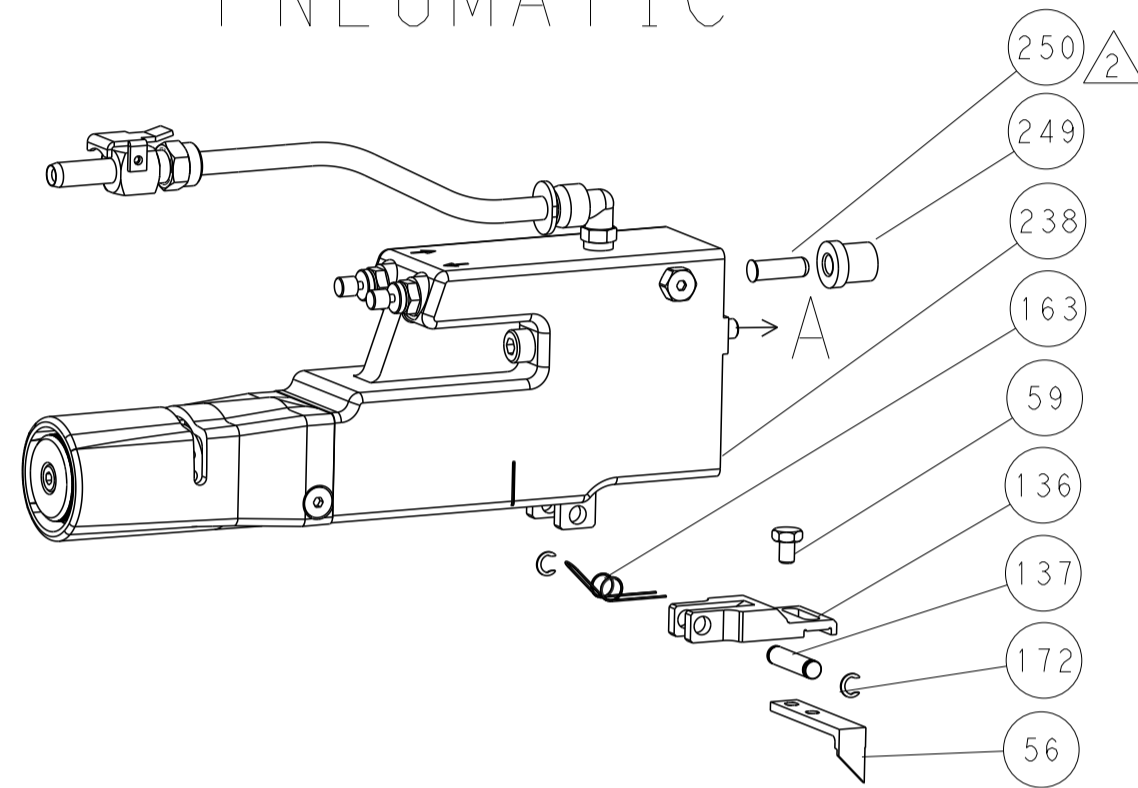
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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME: Ocean Side Feed Applicator SIZE: A1 CASE CODE: 00779 DRAWING NO: ©=2266320 RESTRICTED TO:
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing SCALE: 1:2 SHEET 3 OF 4 REV B

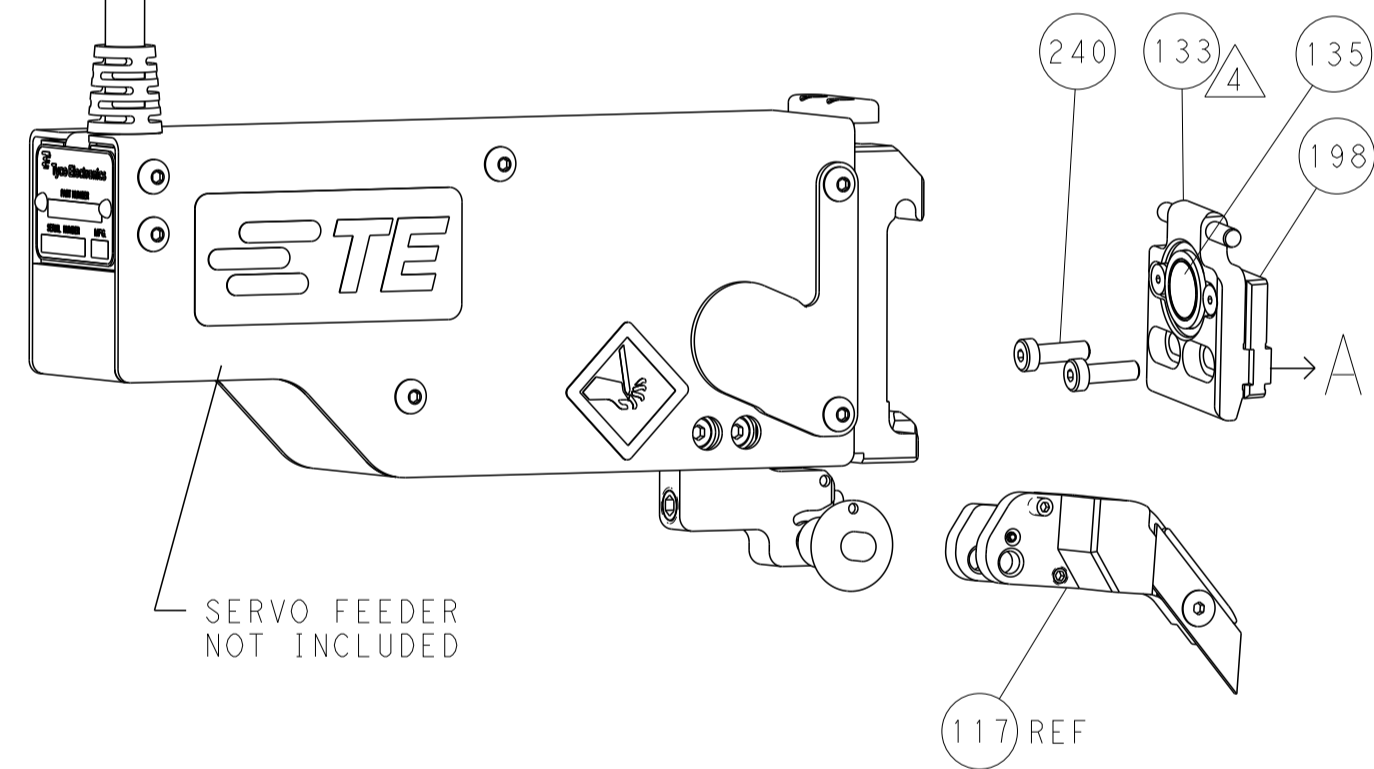
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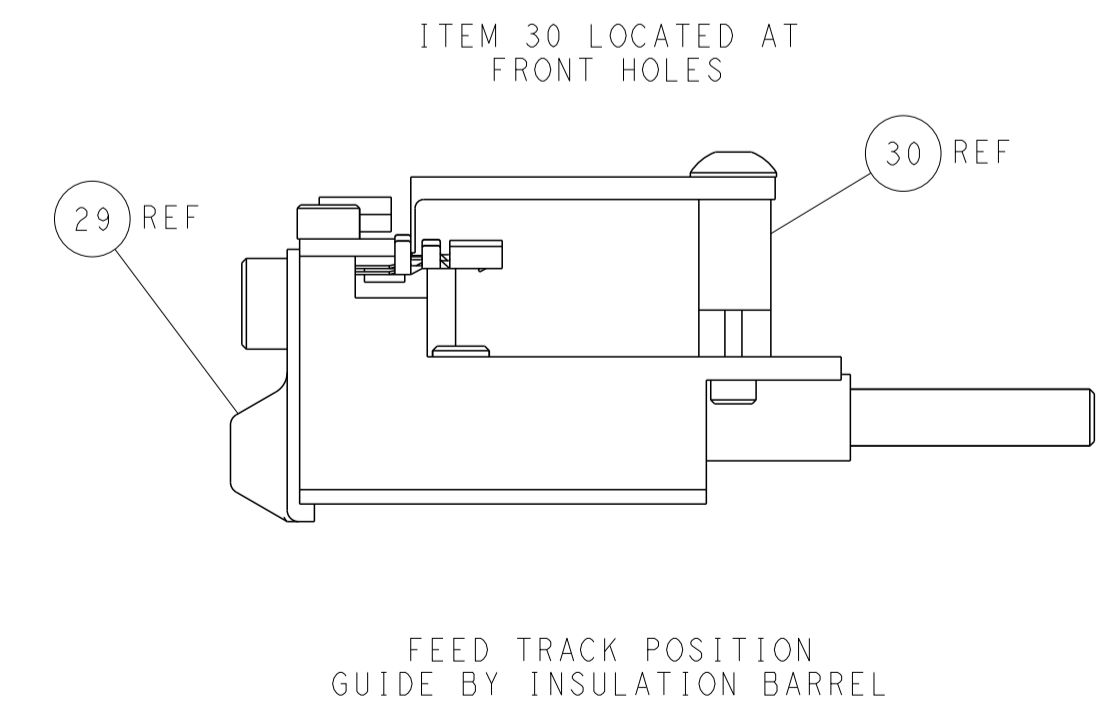
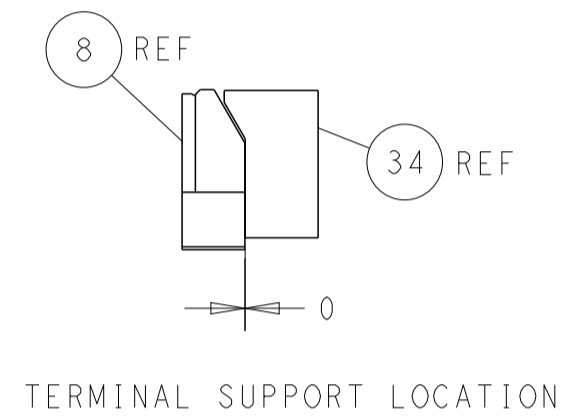
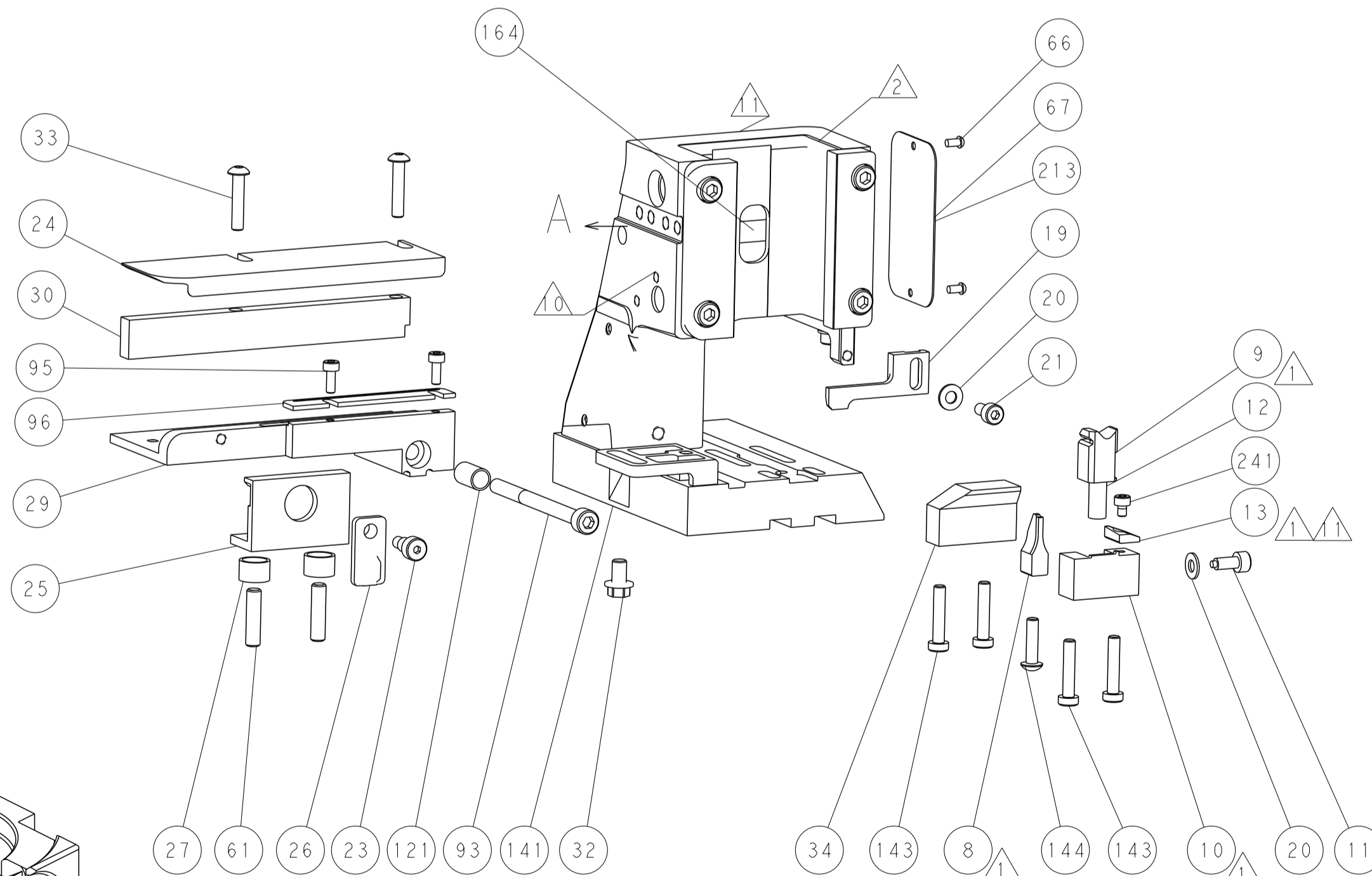
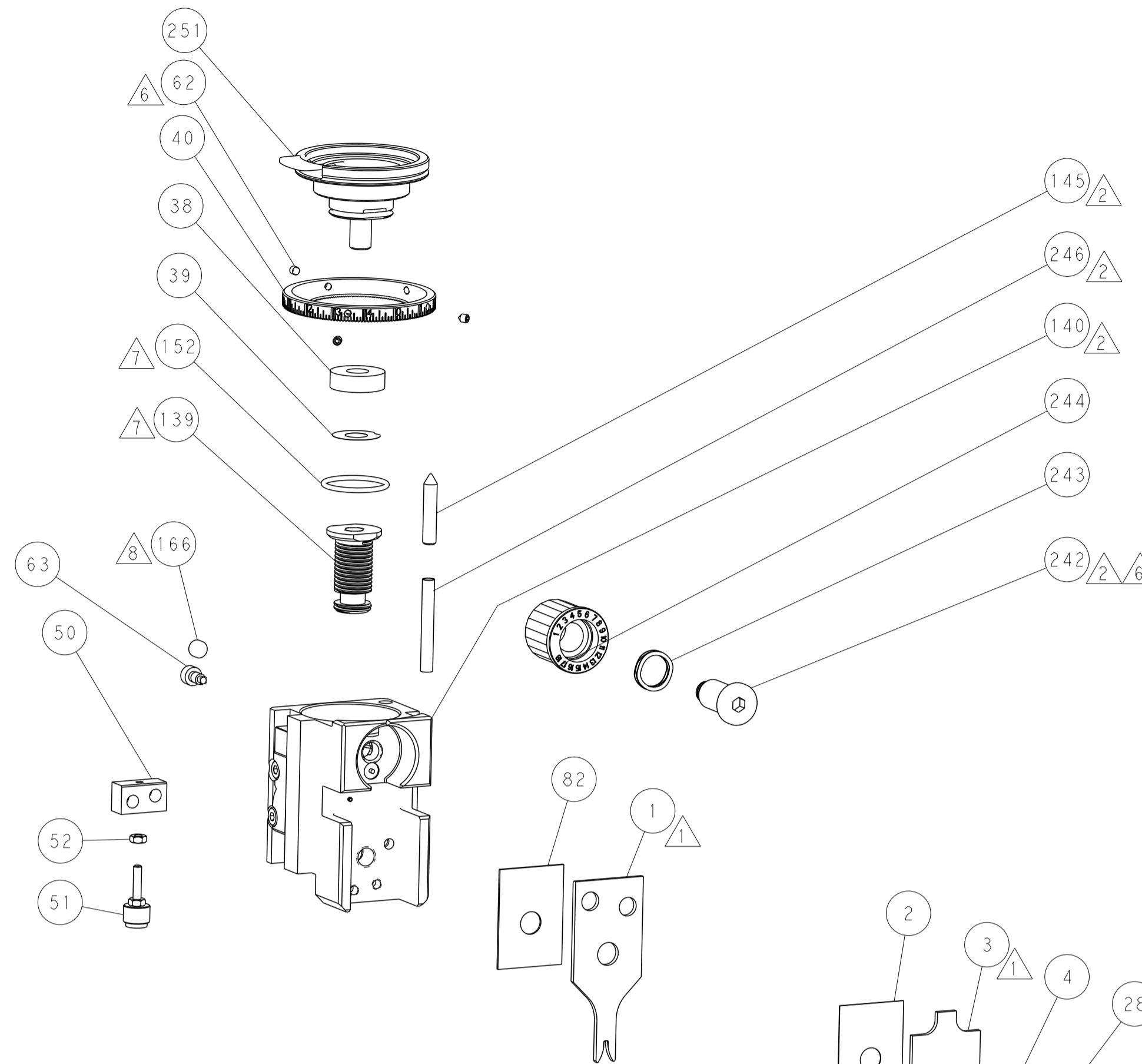
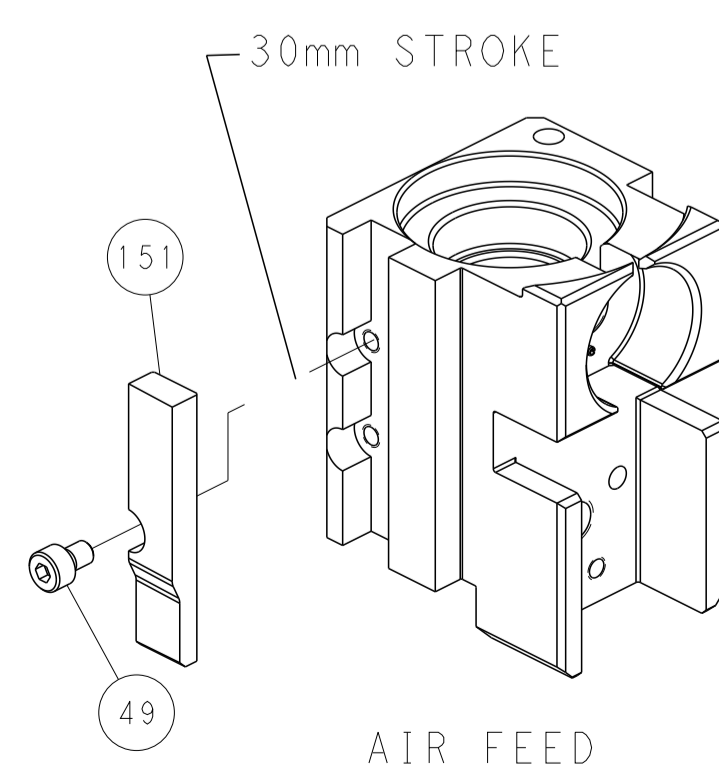
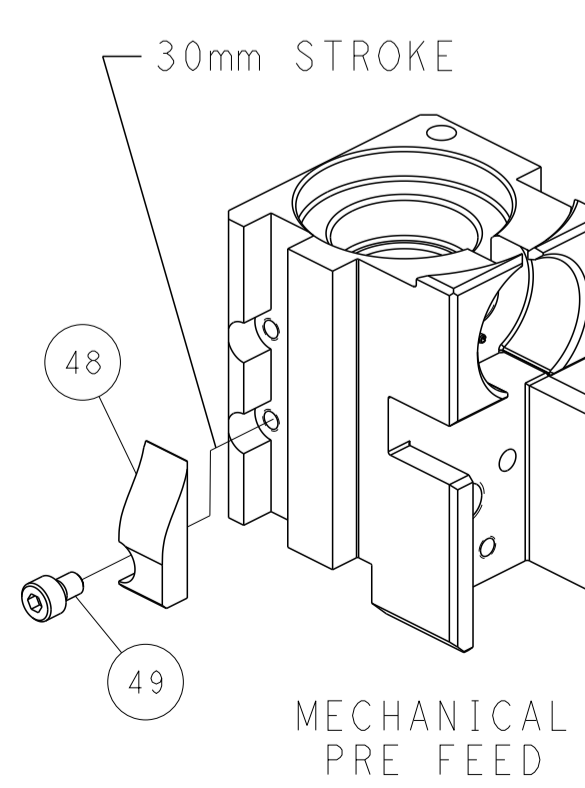
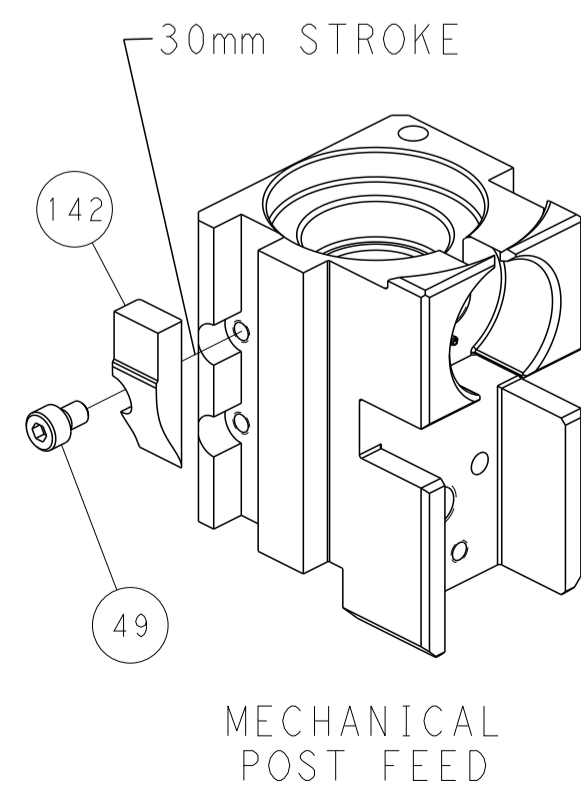
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		REVISIONS	
mm	0 PLC	±		LOC	DIST
	1 PLC	±		A	66
	2 PLC	±		P	LTN
	3 PLC	±		DESCRIPTION	
	4 PLC	±		SEE SHEET 1	
	ANGLES	±		DATE	DWN
	FINISH	±			APVD
MATERIAL				REV	
				B	

NO	DATE	BY	CHK	APPV	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
1	06JUN2014	R.O.WILSON							
2	06JUN2014	G.J.HOFFNER							
3	09JUN2014	T.L.ELBIN							
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NAME: Ocean Side Feed Applicator

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