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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

2266055-1

C

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

2266055-2

C

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119951-1

-

8-2266055-5

1901094-3

-

2168400-6 (QUANTITY 2)

2266055-5

C

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119949-1

1338685-1

5-18022-5

2119653-1

-

-

2266055-6

C

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2161326-1

-

8-2266055-4

-

-

2266055-7

C

FINE CRIMP HEIGHT ADJUST

NONE

2119950-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

7-2266055-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.03 mm [.080]

F

INSUL

4.06 mm [1.60]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: DIA 1.5mm PIN or SOCKET CONTACT,SINGLE WIRE

WIRE STRIP LENGTH

4.20-4.80 mm [1.65-.189 IN]

INSULATION DIAMETER RANGE

Ø 1.3

TERMINAL APPLICATION SPECIFICATION

(A)114-18040

-

-

(B)114-18020

-

-

TERMINALS APPLIED

1.3

TE TERMINAL

TE TERMINAL

TE SEAL

TE SEAL

(A) 929989-1

(A) 1-1418497-0

(A) 828904-1

(B) 828920-1

(A) 929989-4

(B) 929967-1

(A) 828904-2

(B) 828920-2

(A) 929989-7

(B) 929967-7

(A) 828904-3

(B) 929989-8

(B) 929967-8

(A) 1-929989-0

(B) 1-929967-0

(B) 929974-1

(B) 1-929967-4

(B) 929974-4

(A) 1703013-1

(B) 929974-7

(A) 1703013-2

(B) 929974-8

(A) 1703013-4

(B) 929974-9

(A) 1703013-8

(B) 1-929974-4

(A) 1703049-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

1.00mm2

1.45+/-0.05 [1.057+/- .002]

3.7

0.75mm2

1.36+/-0.05 [1.054+/- .002]

5.0

0.50mm2

1.27+/-0.05 [1.050+/- .002]

6.1

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: 8-2266055-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266055-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266055-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266055-6

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.

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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION RANGE QUOTED IS THAT OF THE TERMINAL. THE SEAL INSULATION RANGE IS Ø1.2-2.1mm. FEED ADJUSTMENTS ARE REQUIRED WHEN SWITCHING TERMINALS.

14 APPLY TORQ-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.

13 WHEN CHANGING TERMINALS,TERMINAL FEED ADJUSTMENT IS REQUIRED.

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

TERMINAL PN

FEED

INSULATION RANGE

929989

12.5mm

Ø 3.4mm MAX

929974

14.5mm

Ø 3.4mm MAX

929967

14.5mm

Ø 3.4mm MAX

1703013

12.5mm

Ø 1.2-2.1mm

1418497

12.5mm

Ø 3.4mm MAX

1703049

12.5mm

Ø 1.2-2.1mm

*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.

-

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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

-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

A

DIST

66

REVISIONS

P

LTR

DESCRIPTION

DATE

DWN

APVD

B

ECR-15-016316

06NOV2015

MR

JDG

C

ECR-15-018711

29DEC2015

KH

TE

-

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

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

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

-

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

993111-1

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

-

1

1

1

1

1

1-18028-2

WASHER, FLAT, REG M4

119

-

-

REF

REF

-

-

2119944-1

FEED FINGER ASSEMBLY,SF

117

-

1

1

1

1

1

455888-5

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

-

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 SKT HD CAP, M4 X 6.0

59

-

1

1

1

1

1

985575-3

SCR, FLT SKT HD CAP M3 X 10.0

57

-

-

-

-

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

2168083-3

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

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

-

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

1-1752356-7

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

1-1320908-0

SPACER, STRIP GUIDE

30

-

1

1

1

1

1

2119959-1

ASSEMBLY, STRIP GUIDE

29

-

1

1

1

1

1

455888-5

SPACER, CRIMPER

28

-

1

1

1

1

1

1320928-6

STRIP GUIDE

24

-

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

318707-1

FLOATING SHEAR, FRONT

9

-

1

1

1

1

1

1338693-1

ANVIL, COMBINATION .080

8

-

1

1

1

1

1

3-240641-8

SPACER

7

-

1

1

1

1

1

2119781-1

DEPRESSOR, SHEAR

5

-

1

1

1

1

1

3-238011-3

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1

3-2119784-1

CRIMPER, INSULATION O PREMIUM

3

-

1

1

1

1

1

1-455888-1

SPACER, CRIMPER

2

-

1

1

1

1

1

1-456405-6

CRIMPER, WIRE PREMIUM

1

77

7

7

7

7

7

PART NO

DESCRIPTION

ITEM NO

TE Connectivity

Harrisburg, PA 17105-3608

Ocean Side Feed

Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2266055

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

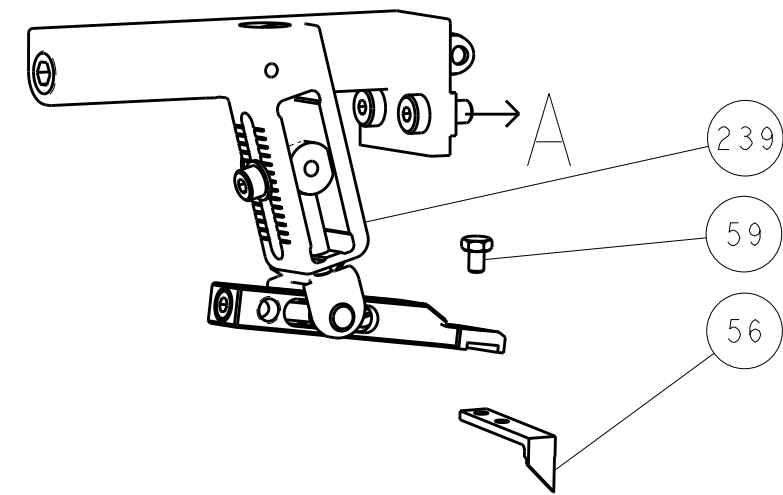
C

AMP 4805 REV 31MAR2000

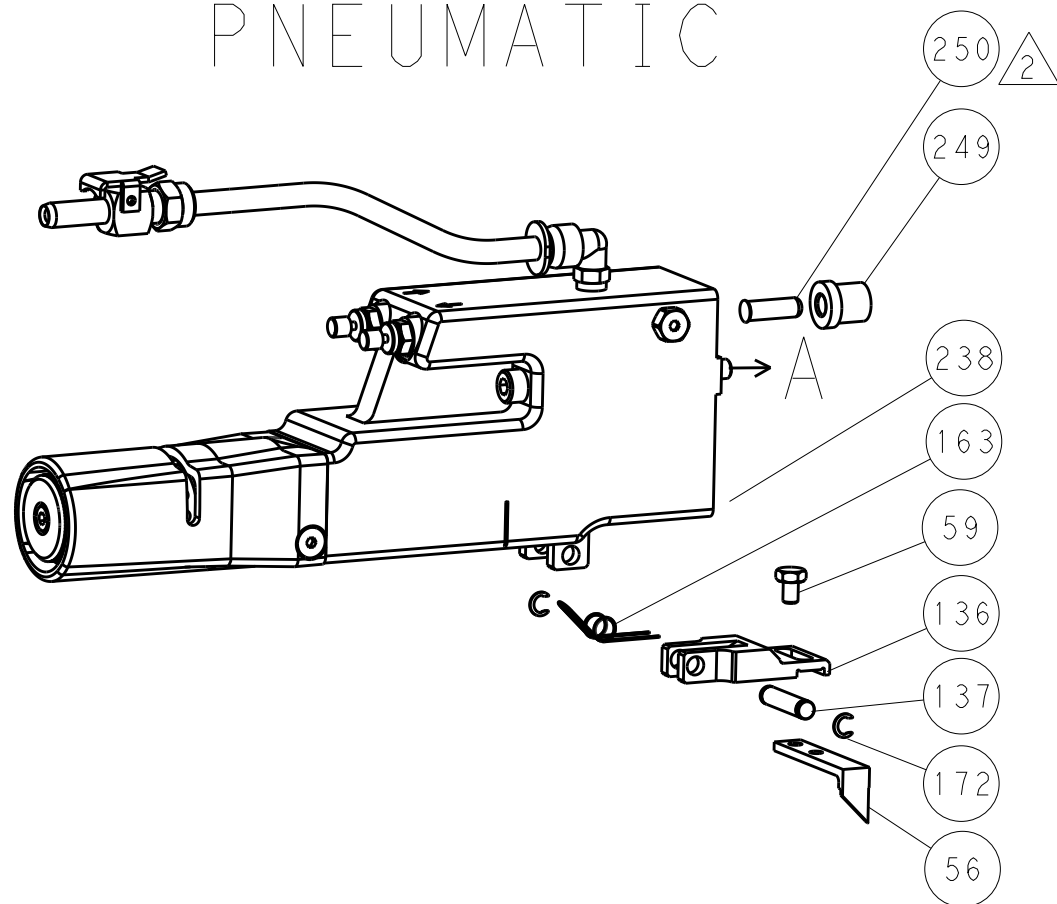
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

FEED TYPE
MECHANICAL



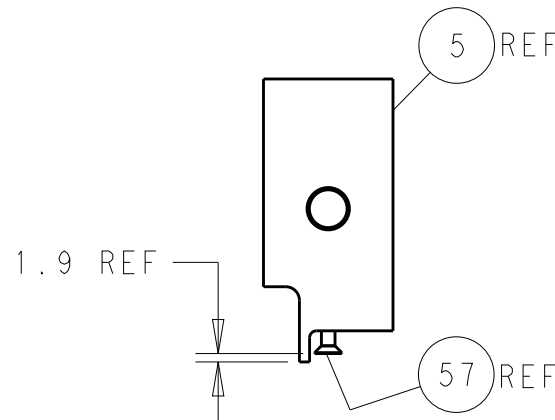
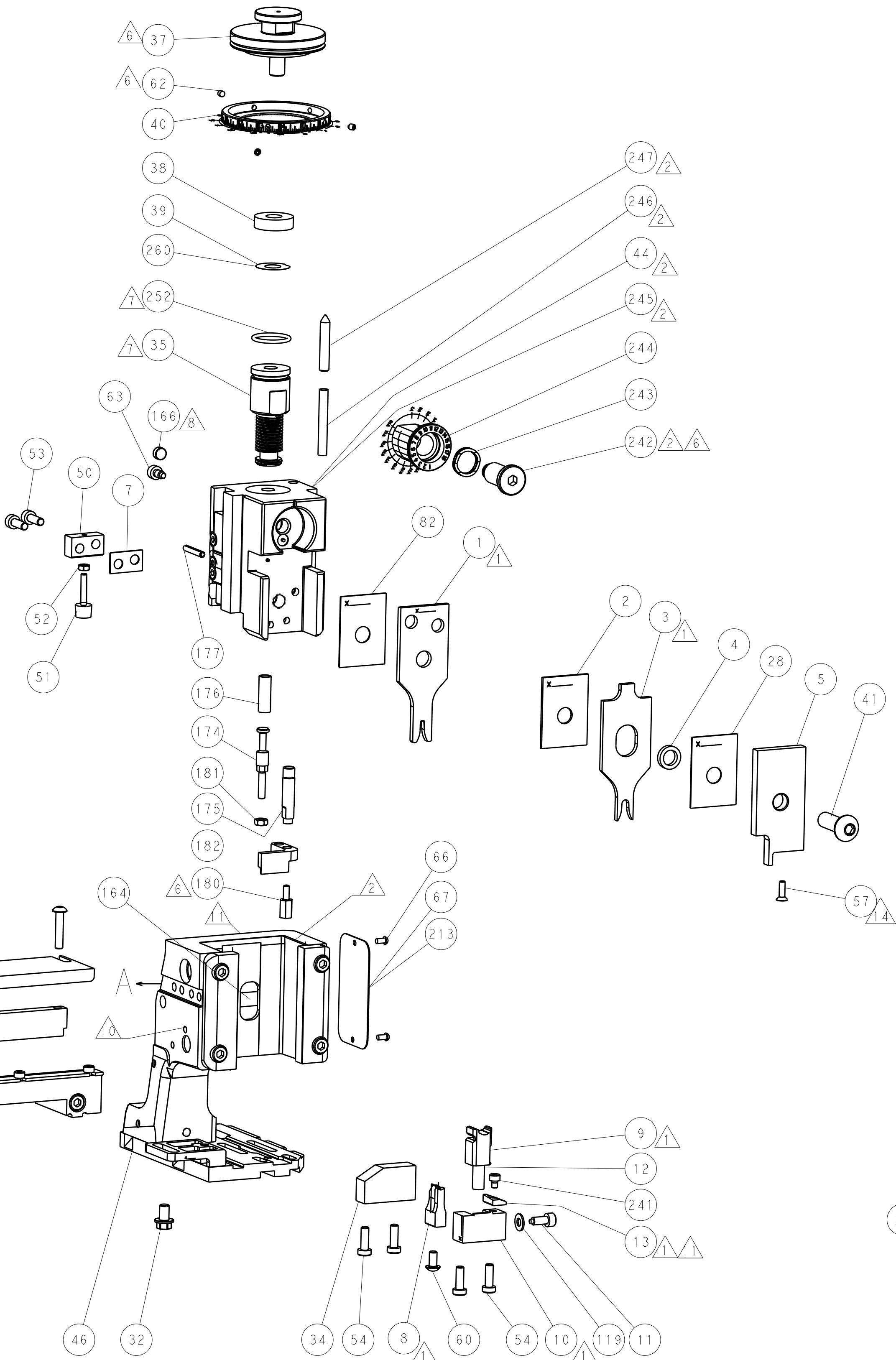
PNEUMATIC



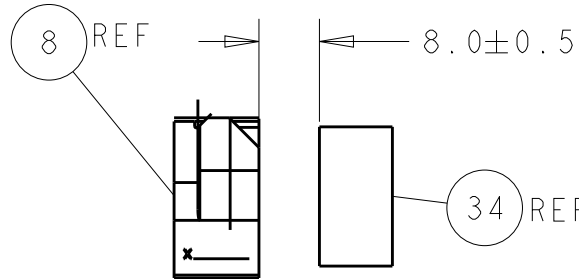
SERVO
LATCH PLATE



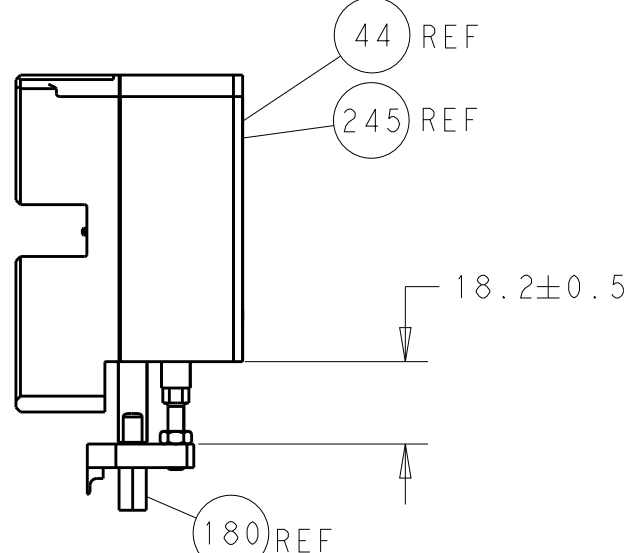
CAM POSITIONS



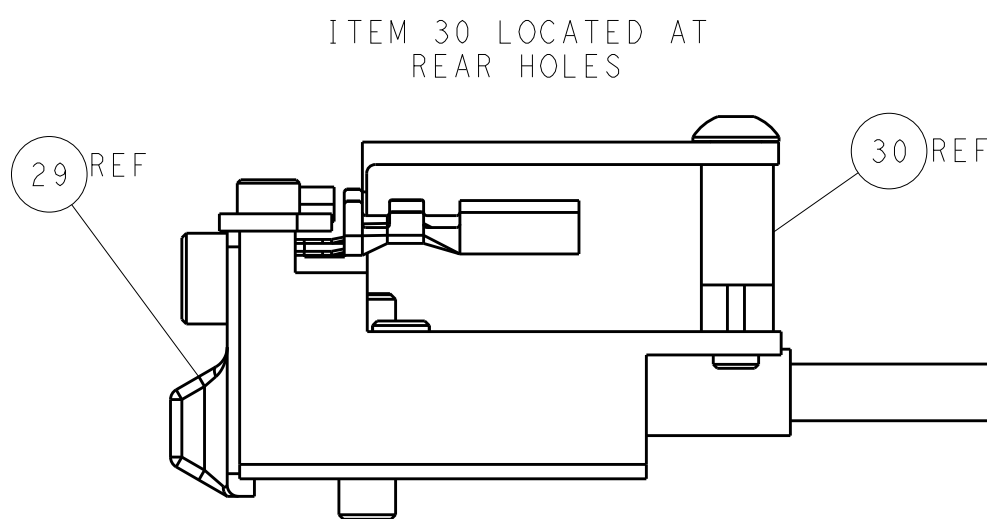
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

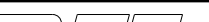


HOLDDOWN SET-UP



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	X. ZHAO	26SEP2013	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK	T. ELBIN	26SEP2013				
				APVD	L. ZHANG	26SEP2013				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator				
mm				PRODUCT SPEC						
				APPLICATION SPEC						
		0 PLC	±.1			SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO
		1 PLC	±.1			A1		00779	©=2266055	-
		2 PLC	±.1							
		3 PLC	±.1							
		4 PLC	±.1							
ANGLES		±.1								
FINISH										
MATERIAL				WEIGHT						
Customer Accessible Production Drawing						SCALE		1:2	SHEET	2 of 4
										REV C

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RELEASED FOR PUBLICATION

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

2-2266055-1

REVISION

C

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119951-1

-

8-2266055-5

2119641-2

2119799-1

2063440-1

2161326-1

-

8-2266055-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2266055-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266055-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

-

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-

2-2266055-2

C

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2266055-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266055-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

-

-

-

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-

2-2266055-5

C

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

2-2266055-7

C

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2266055-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: DIA 1.5mm PIN or SOCKET CONTACT,SINGLE WIRE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.20-4.80 mm [.165-.189 IN]	Ø

TERMINAL APPLICATION SPECIFICATION

(A)114-18040

-

-

(B)114-18020

-

-

TERMINALS APPLIED

TE TERMINAL

TE SEAL

TE TERMINAL

TE SEAL

(A) 929989-1

(A) 1-1418497-0

(A) 828904-1

(B) 828920-1

(A) 929989-4

(B) 929967-1

(A) 828904-2

(B) 828920-2

(A) 929989-7

(B) 929967-7

(A) 828904-3

(B) 929989-8

(B) 929967-8

(A) 1-929989-0

(B) 1-929967-0

(B) 929974-1

(B) 1-929967-4

(B) 929974-4

(A) 1703013-1

(B) 929974-7

(A) 1703013-2

(B) 929974-8

(A) 1703013-4

(B) 929974-9

(A) 1703013-8

(B) 1-929974-4

(A) 1703049-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

1.00mm2

1.45+/-0.05 [.057+/- .002]

3.7

0.75mm2

1.36+/-0.05 [.054+/- .002]

5.0

0.50mm2

1.27+/-0.05 [.050+/- .002]

6.1

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: 8-2266055-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266055-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266055-5

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.

7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

8

MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION RANGLE QUOTED IS THAT OF THE TERMINAL. THE SEAL INSULATION RANGE IS Ø1.2-2.1mm.
FEED ADJUSTMENTS ARE REQUIRED WHEN SWITCHING TERMINALS.

13

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.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

SERVO LATCH PLATE

2119951-1

-

8-2266055-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266055-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

-

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

-

-

-

-

-

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: DIA 1.5mm PIN or SOCKET CONTACT,SINGLE WIRE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.20-4.80 mm [.165-.189 IN]	Ø

TERMINAL APPLICATION SPECIFICATION

(A)114-18040

-

-

(B)114-18020

-

-

TERMINALS APPLIED

TE TERMINAL

TE SEAL

TE TERMINAL

TE SEAL

(A) 929989-1

(A) 1-1418497-0

(A) 828904-1

(B) 828920-1

(A) 929989-4

(B) 929967-1

(A) 828904-2

(B) 828920-2

(A) 929989-7

(B) 929967-7

(A) 828904-3

(B) 929989-8

(B) 929967-8

(A) 1-929989-0

(B) 1-929967-0

(B) 929974-1

(B) 1-929967-4

(B) 929974-4

(A) 1703013-1

(B) 929974-7

(A) 1703013-2

(B) 929974-8

(A) 1703013-4

(B) 929974-9

(A) 1703013-8

(B) 1-929974-4

(A) 1703049-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

1.00mm2

1.45+/-0.05 [.057+/- .002]

3.7

0.75mm2

1.36+/-0.05 [.054+/- .002]

5.0

0.50mm2

1.27+/-0.05 [.050+/- .002]

6.1

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: 8-2266055-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266055-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266055-5

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.

7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

8

MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION RANGLE QUOTED IS THAT OF THE TERMINAL. THE SEAL INSULATION RANGE IS Ø1.2-2.1mm.
FEED ADJUSTMENTS ARE REQUIRED WHEN SWITCHING TERMINALS.

13

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.

WHEN CHANGING TERMINALS,TERMINAL FEED ADJUSTMENT IS REQUIRED.

TERMINAL PN	FEED	INSULATION RANGE
929989	12.5mm	Ø 3.4mm MAX
929974	14.5mm	Ø 3.4mm MAX
929967	14.5mm	Ø 3.4mm MAX
1703013	12.5mm	Ø 1.2-2.1mm
1418497	12.5mm	Ø 3.4mm MAX
1703049	12.5mm	Ø 1.2-2.1mm

THE APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL

*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
-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

2119599-1

LOC

A

DIST

66

REVISIONS

P	LYR	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119082-9	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
-	-	-	-	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
-	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	182
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	1	1	1	1	2-1752354-2	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-3	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	-	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
-	-	-	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	2-2119656-2	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	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1-1752356-7	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	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1	1	1320928-6	STRIP GUIDE	24
-	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1338693-1	ANVIL, COMBINATION .080	8
-	1	1	1	1	3-240641-8	SPACER	7
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	3-2119784-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: DIA 1.5mm PIN or SOCKET CONTACT,SINGLE WIRE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.20-4.80 mm [.165-.189 IN]	Ø

TERMINAL APPLICATION SPECIFICATION

(A)114-18040

-

-

(B)114-18020

-

-

TERMINALS APPLIED

TE TERMINAL

TE SEAL

TE TERMINAL

TE SEAL

(A) 929989-1

(A) 1-1418497-0

(A) 828904-1

(B) 828920-1

(A) 929989-4

(B) 929967-1

(A) 828904-2

(B) 828920-2

(A) 929989-7

(B) 929967-7

(A) 828904-3

(B) 929989-8

(B) 929967-8

(A) 1-929989-0

(B) 1-929967-0

(B) 929974-1

(B) 1-929967-4

(B) 929974-4

(A) 1703013-1

(B) 929974-7

(A) 1703013-2

(B) 929974-8

(A) 1703013-4

(B) 929974-9

(A) 1703013-8

(B) 1-929974-4

(A) 1703049-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

1.00mm2

1.45+/-0.05 [.057+/- .002]

3.7

0.75mm2

1.36+/-0.05 [.054+/- .002]

5.0

0.50mm2

1.27+/-0.05 [.050+/- .002]

6.1

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

D

C

B

A

D

C

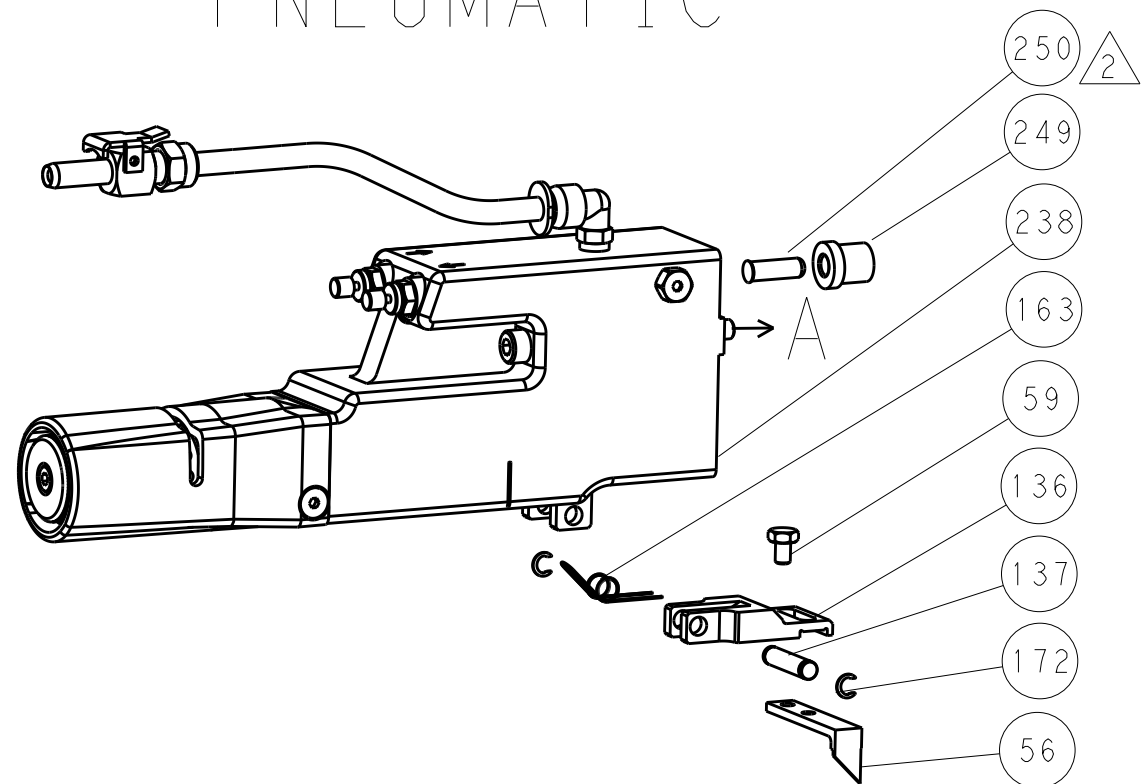
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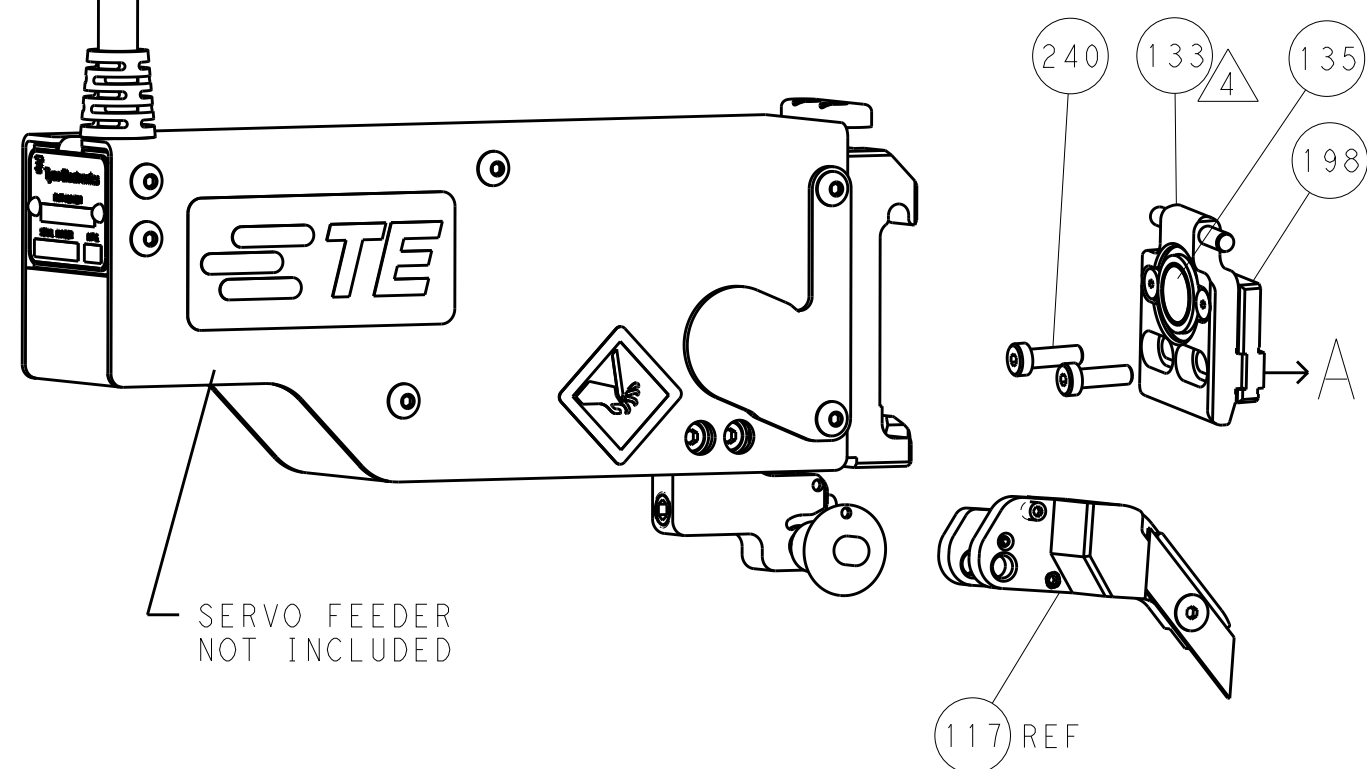
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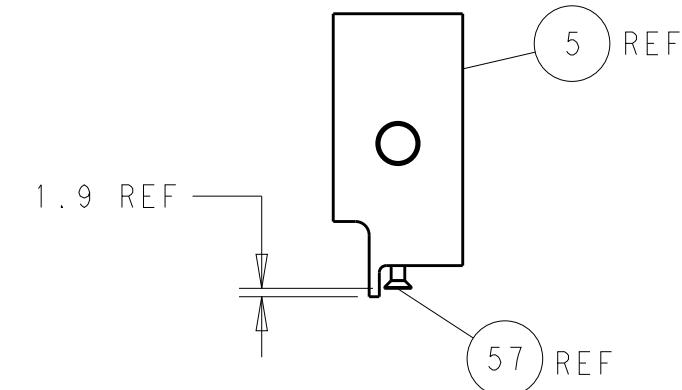
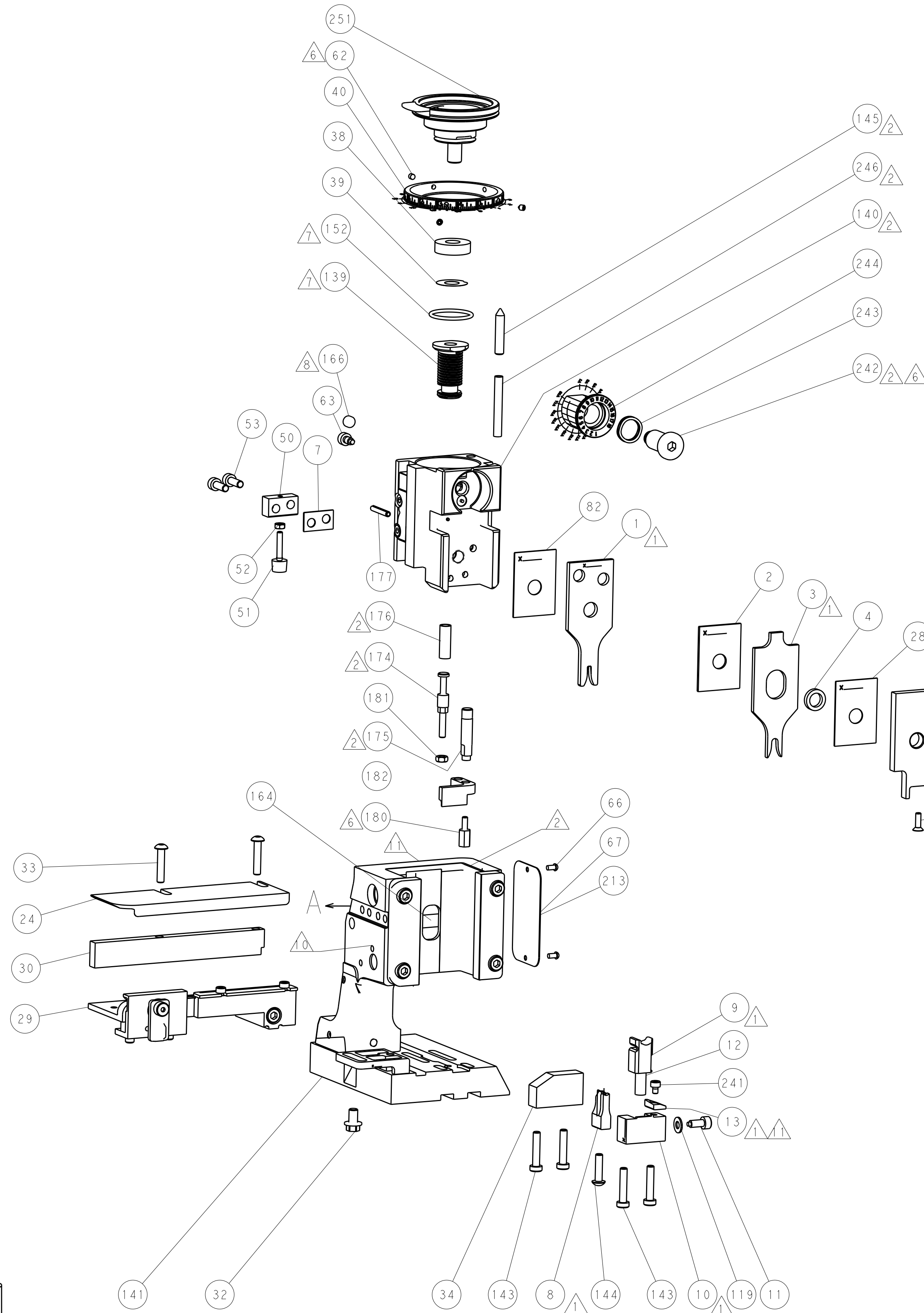
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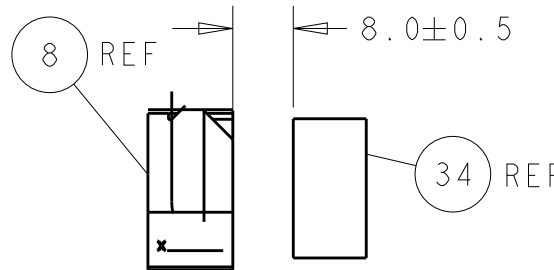
SERVO LATCH PLATE



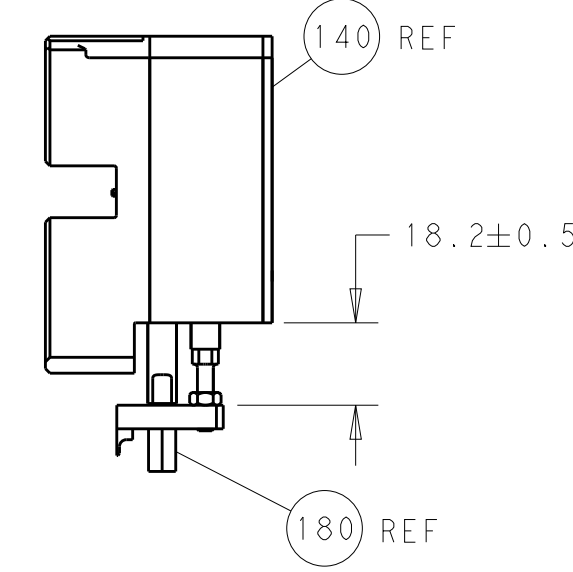
CAM POSITIONS



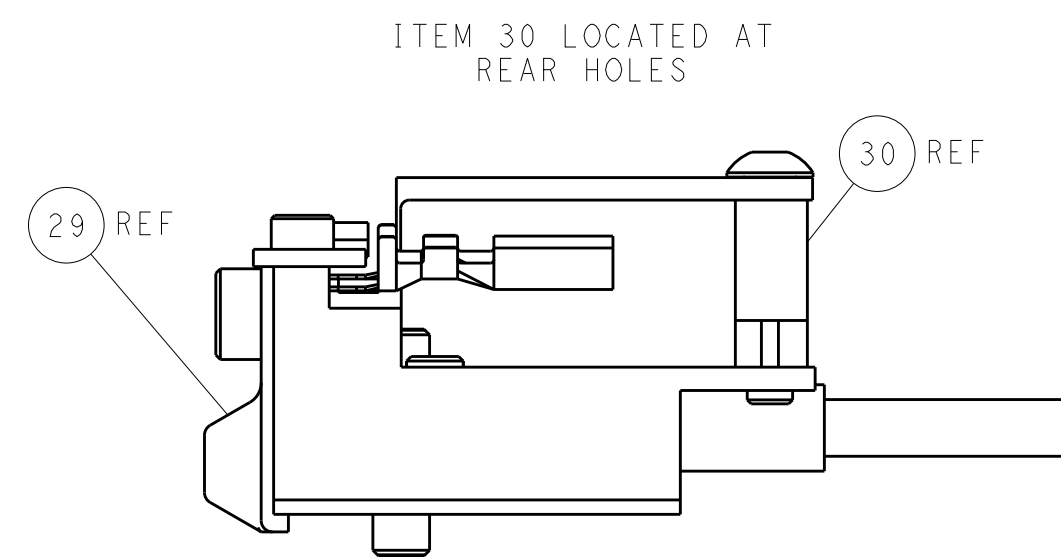
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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)

1ST FORMERLY A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN X. ZHAO 26SEP2013	TE Connectivity Harrisburg, PA 17105-3608	
CHK T. ELBIN 26SEP2013		NAME	Ocean Side Feed Applicator	
APVD L. ZHANG 26SEP2013		PRODUCT SPEC	-	
APPLICATION SPEC		SIZE	A1	
MATERIAL		WEIGHT	00779	
FINISH		Customer Accessible Production Drawing	SCALE 1:2 SHEET 4 OF 4 REV C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION