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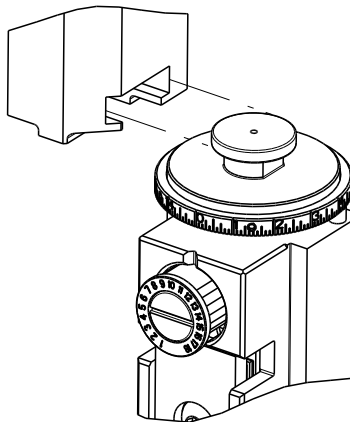
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2266958-1	B	FINE CRIMP HEIGHT ADJUST
	2266958-2	B	FINE CRIMP HEIGHT ADJUST
	2266958-5	B	FINE CRIMP HEIGHT ADJUST
	2266958-6	B	NON-CRIMP HEIGHT ADJUST
	2266958-7	B	FINE CRIMP HEIGHT ADJUST
	7-2266958-7	B	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL,CRIMP CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø3.15-3.60 mm [.124-.142 IN]	
TERMINAL APPLICATION SPECIFICATION	TAD-P-0506 Rev 1	-	-
TERMINALS APPLIED			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
2113838-1	DF22A-1416PCF		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.46+/-0.04 [.057+/- .002]	7.2
16 AWG	1.34+/-0.04 [.053+/- .002]	8.4



- 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: 8-2266958-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266958-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266958-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266958-6
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 4.34.

*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
-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
	I	DEVELOPMENT			24AUG2015	XZ	UG
	A	RELEASED			01OCT2015	CT	TE
	B	ECR-15-017076			23NOV2015	TT	TE

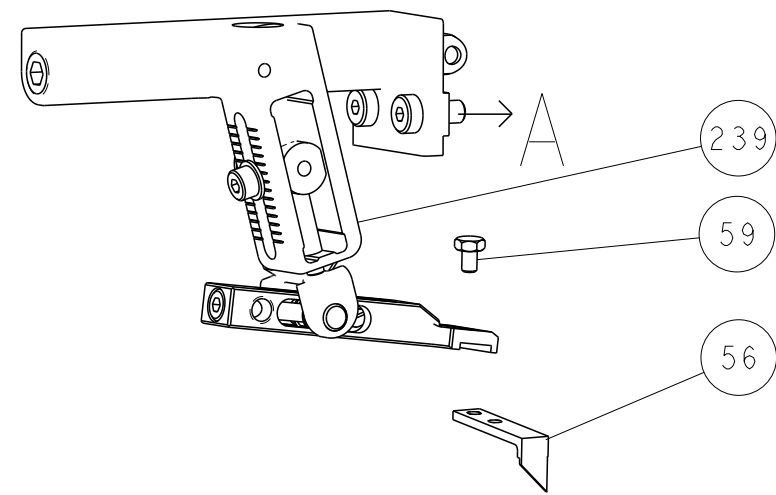
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-2	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
-	-	-	-	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	455888-5	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 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	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	1-2119644-2	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	3-1752356-3	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	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	2119791-7	DEPRESSOR, WIRE	28
-	1	1	1	1	1	2119943-1	WASHER, SPACER	27
-	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	2119533-3	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	1803334-4	ANVIL, COMBINATION	8
-	1	1	1	1	1	240641-9	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1803327-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	1	1	1803325-8	CRIMPER, WIRE	1

-77 -7 -6 -5 -2 -1			PART NO		DESCRIPTION			ITEM NO			
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				CHK	24AUG2015						
DIMENSIONS: mm				L	Z.HANG	24AUG2015	NAME				
				APVD	J.GUO	24AUG2015	Ocean Side Feed Applicator				
				TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE			CAGE CODE	DRAWING NO	RESTRICTED TO
				0 PLC ±.01					PRODUCT SPEC	-	-
				1 PLC ±.01		APPLICATION SPEC			-	-	-
				2 PLC ±.01					-	-	-
				3 PLC ±.01					-	-	-
				4 PLC ±.01					-	-	-
				FINISH		WEIGHT			-	-	-
				-					-	-	-
				Customer Accessible Production Drawing		SCALE			1:2	SHEET	1 OF 4
									REV	B	

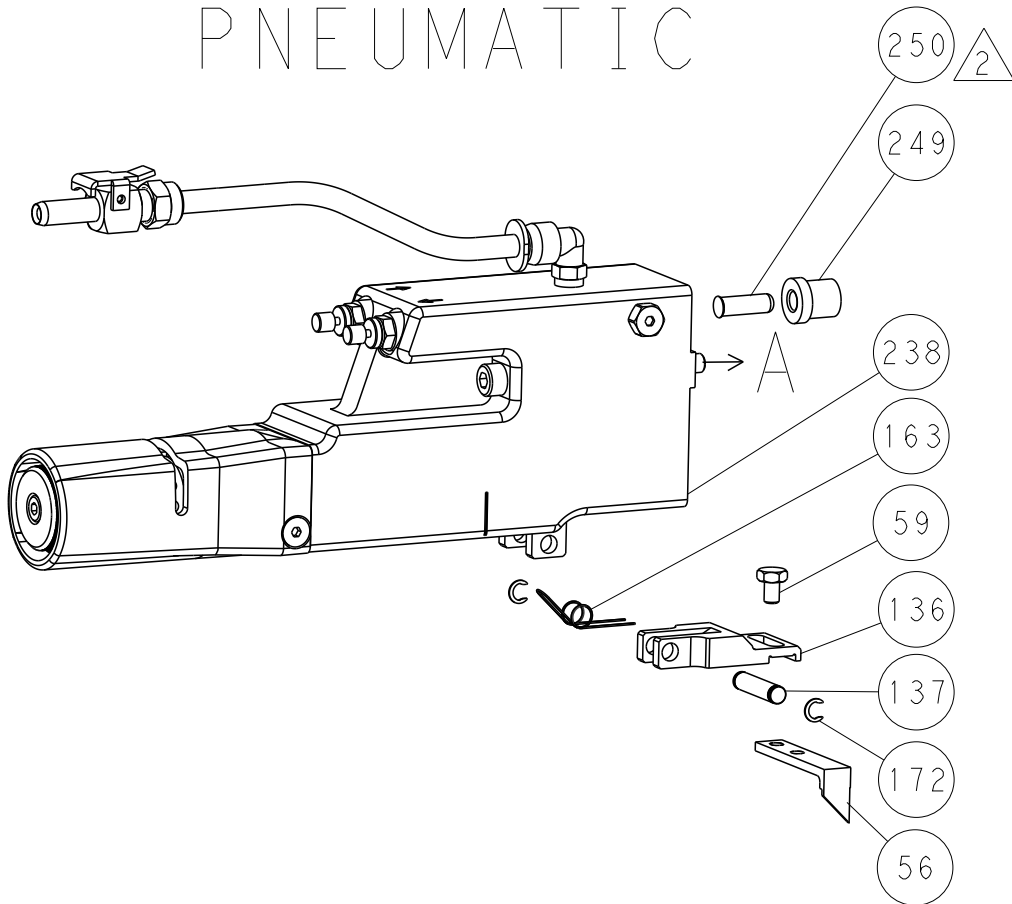
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

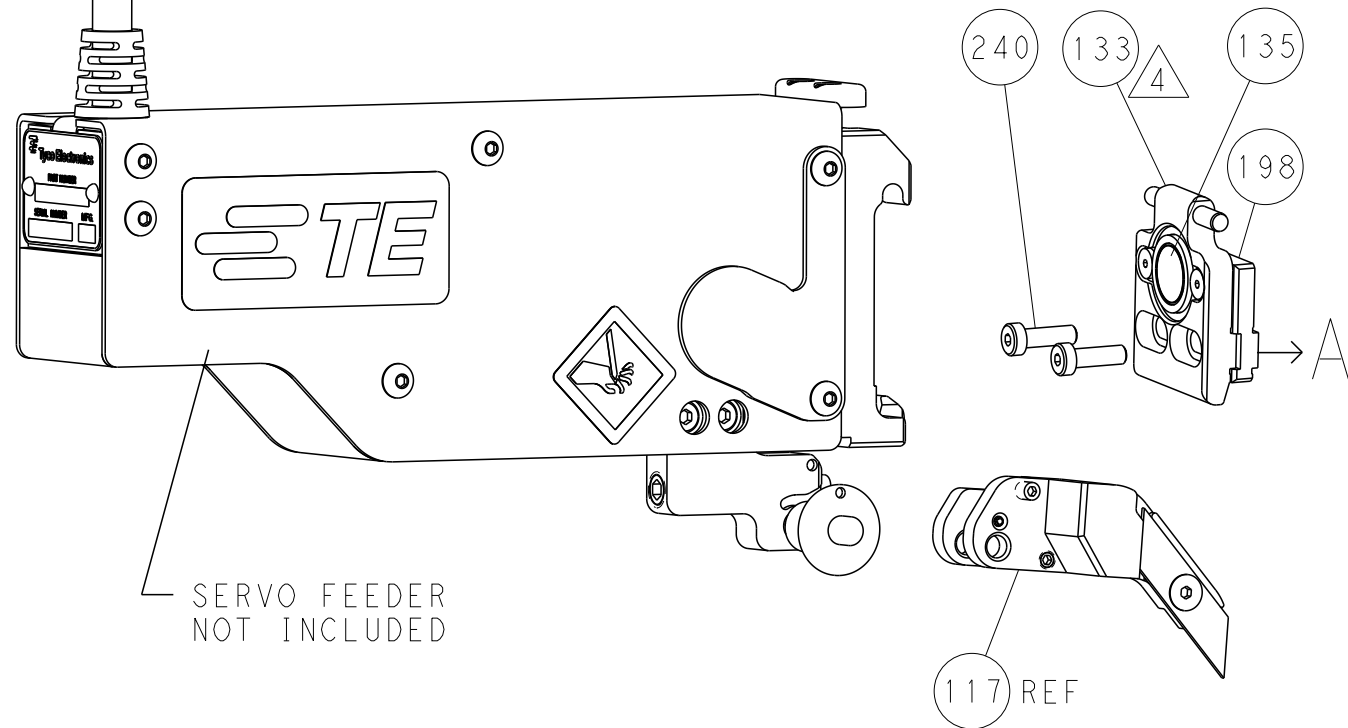
FEED TYPE
MECHANICAL



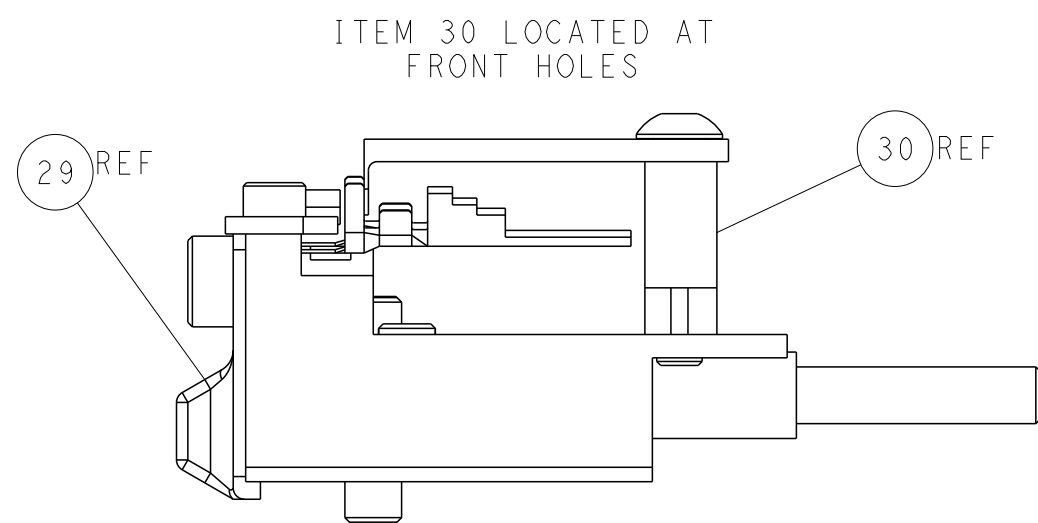
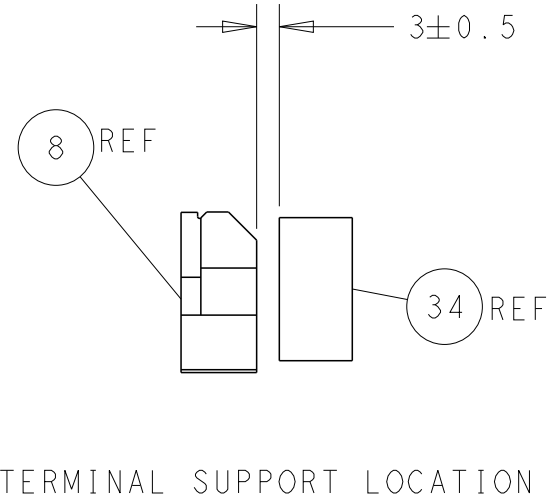
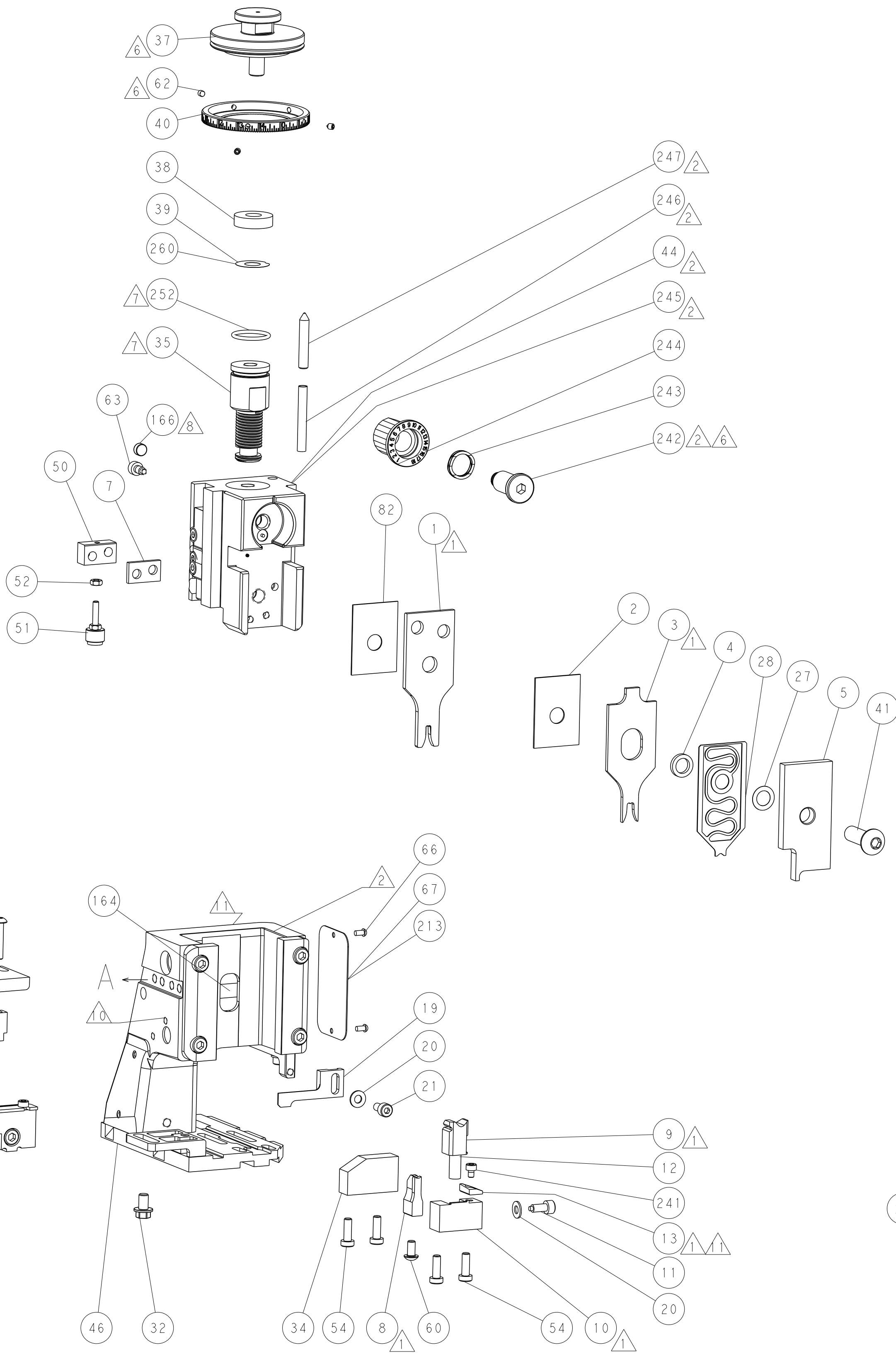
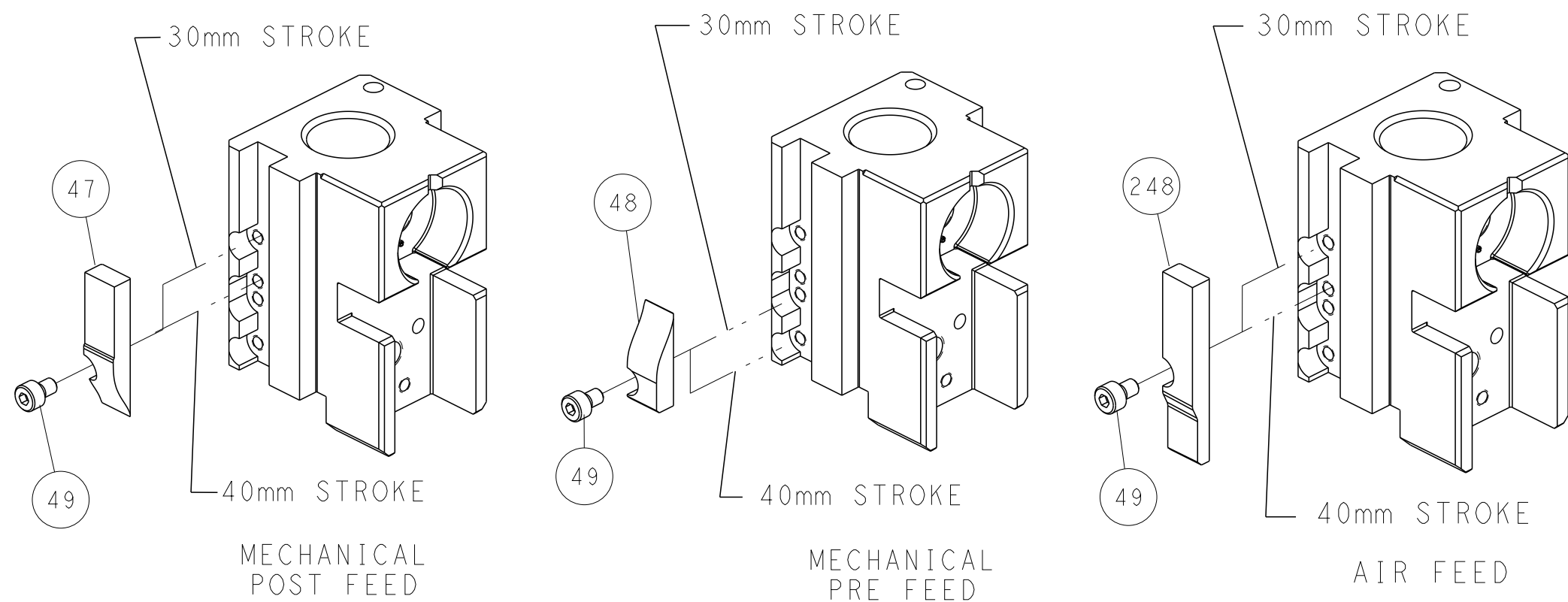
PNEUMATIC



SERVO
LATCH PLATE



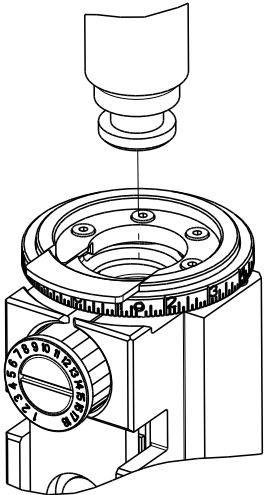
CAM POSITIONS



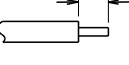
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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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		CHK	L. ZHANG	24AUG2015	Harrisburg, PA 17105-3608		
DIMENSIONS:		APVD	J. GUO	24AUG2015	NAME Ocean Side Feed Applicator -		
mm		PRODUCT SPEC					
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC					
0 PLC ±		SIZE		CAGE CODE			
1 PLC ±		DRAWING NO		RESTRICTED TO			
2 PLC ±		WEIGHT					
3 PLC ±		Customer Accessible Production Drawing		SCALE			
4 PLC ±		SCALE		SHEET			
ANGLES		SCALE		REV			
FINISH		SHEET		REV			
MATERIAL		REV					

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2266958-1	B	FINE CRIMP HEIGHT ADJUST
	2-2266958-2	B	FINE CRIMP HEIGHT ADJUST
	2-2266958-5	B	FINE CRIMP HEIGHT ADJUST
	2-2266958-7	B	FINE CRIMP HEIGHT ADJUST
	7-2266958-7	B	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-10389 		

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TERMINAL NAME: TERMINAL,CRIMP CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		 INSULATION DIAMETER RANGE Ø3.15-3.60 mm [.124-.142 IN]	
TERMINAL APPLICATION SPECIFICATION 	TAD-P-0506 Rev 1	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
2113838-1	DF22A-1416PCF		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
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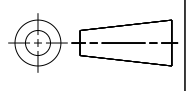
- ¹ RECOMMENDED SPARE PARTS
- ² GREASE BEARING SURFACES LIGHTLY
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- ⁴ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266958-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266958-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266958-5
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- 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.
- 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.

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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	LTR	DESCRIPTION		DATE	OWN	APVD
	-	SEE SHEET 1		-	-	-

-	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	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
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-	-	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
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-	-	-	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
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
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-	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
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-	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
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-	1	1	1	1	3-1752356-3	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	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	2119791-7	DEPRESSOR, WIRE	28
-	1	1	1	1	2119943-1	WASHER, SPACER	27
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	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	2119533-3	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1803334-4	ANVIL, COMBINATION	8
-	1	1	1	1	240641-9	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1803327-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	1	1	1803325-8	CRIMPER, WIRE	1

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY TO THE ORGANIZATION WHICH BE CONTACTED FOR THE LATEST EDITION.		OWN X.ZHAO	24AUG2015	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK L.ZHANG	24AUG2015	NAME	
mm		APVD J.GUO	24AUG2015	Ocean Side Feed Applicator	
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
				APPLICATION SPEC	
MATERIAL		FINISH		WEIGHT	
-		-		-	
Customer Accessible Production Drawing		SCALE		RESTRICTED TO	
		1:2		-	

LOC		DIST		REVISIONS			
P	LYR	DESCRIPTION		DATE	DWN	APVD	
-	-	SEE SHEET 1		-	-	-	

D

C

B

A

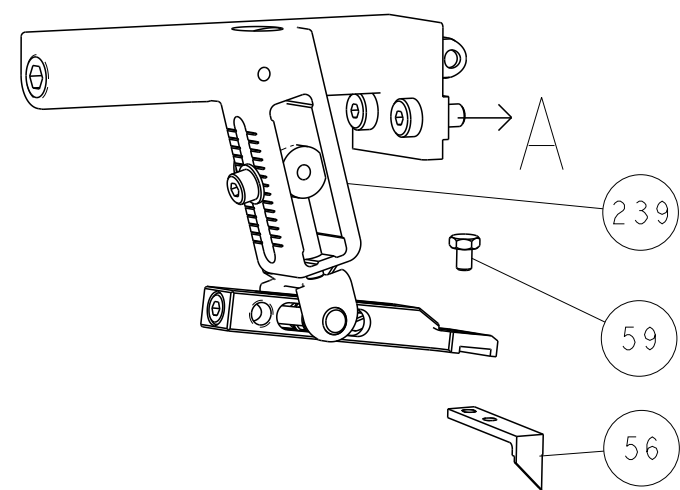
D

C

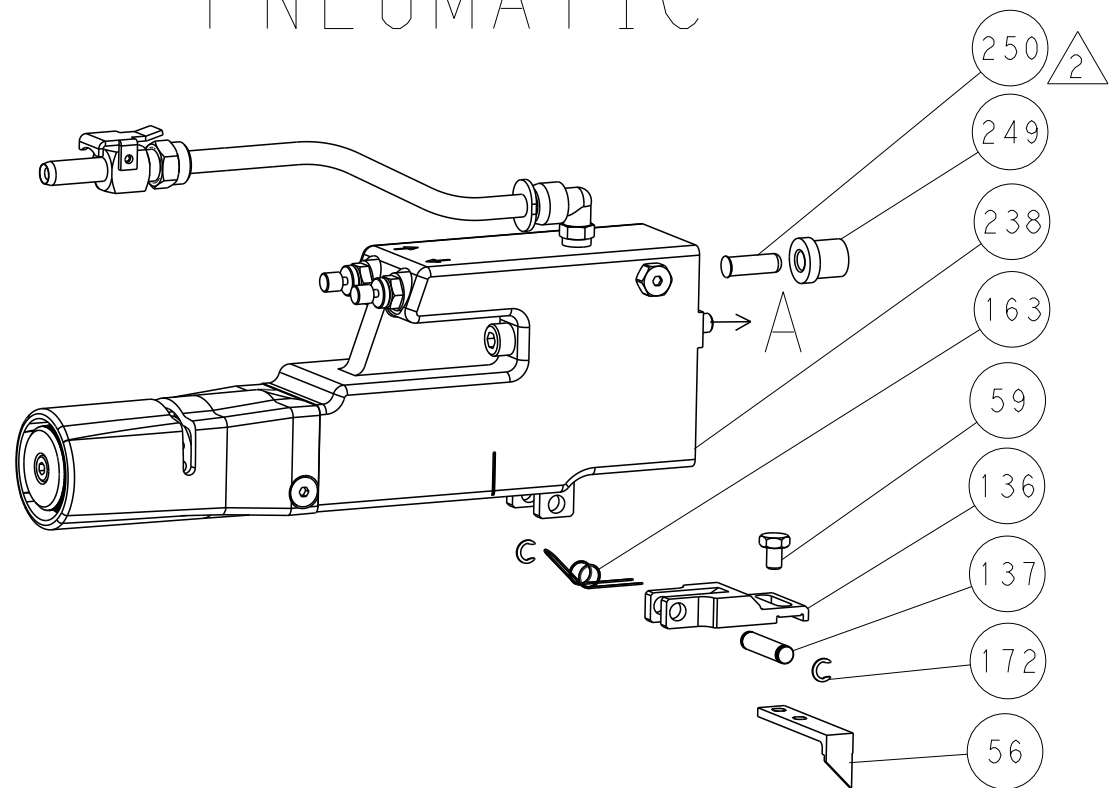
B

A

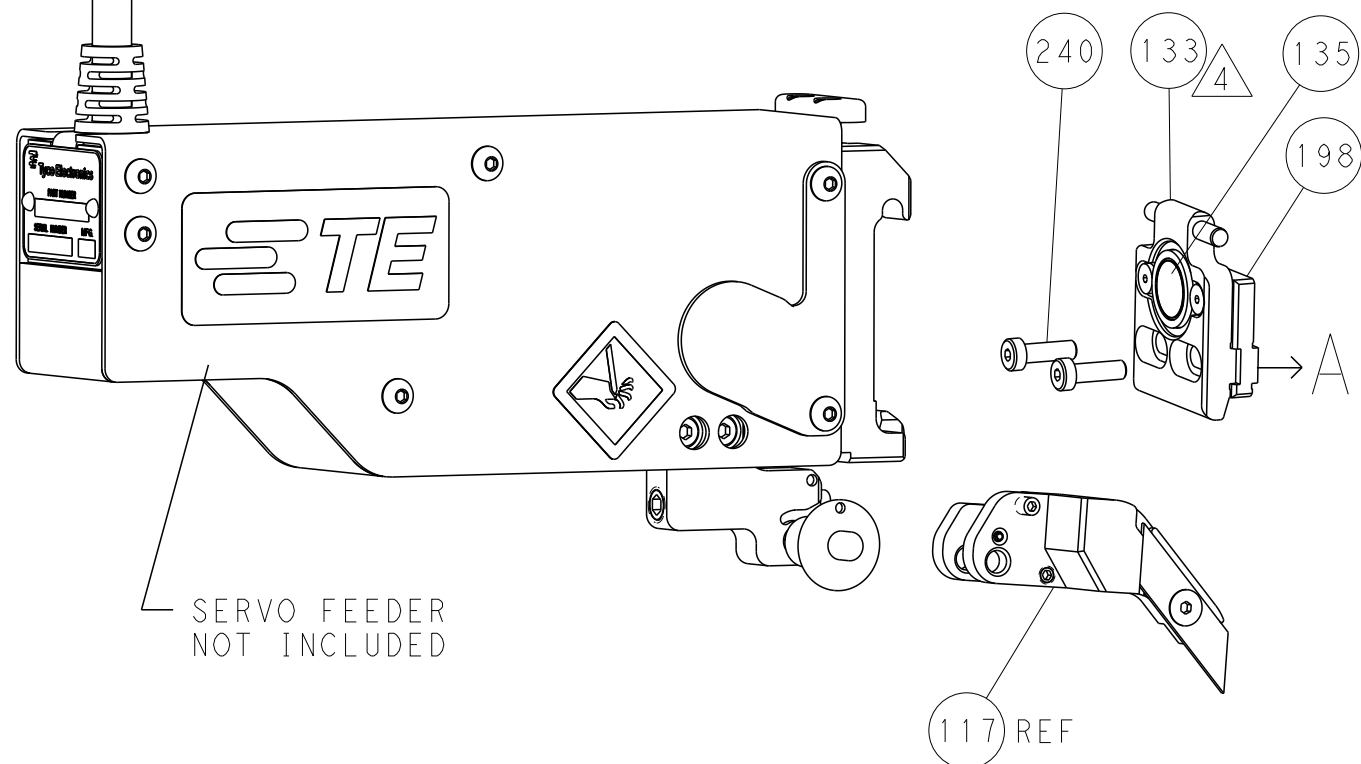
FEED TYPE MECHANICAL



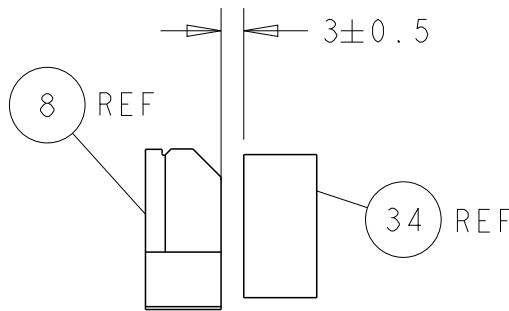
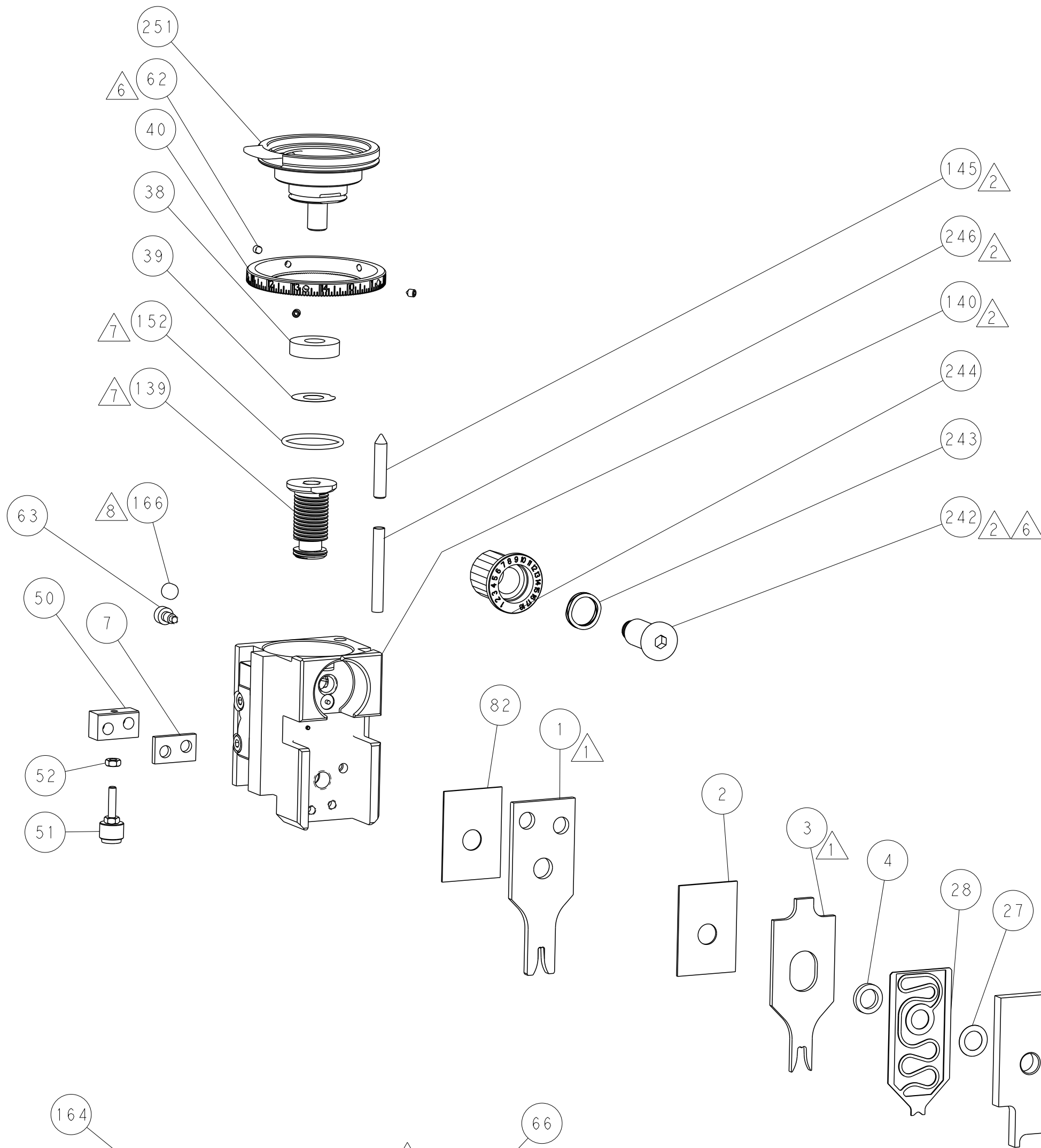
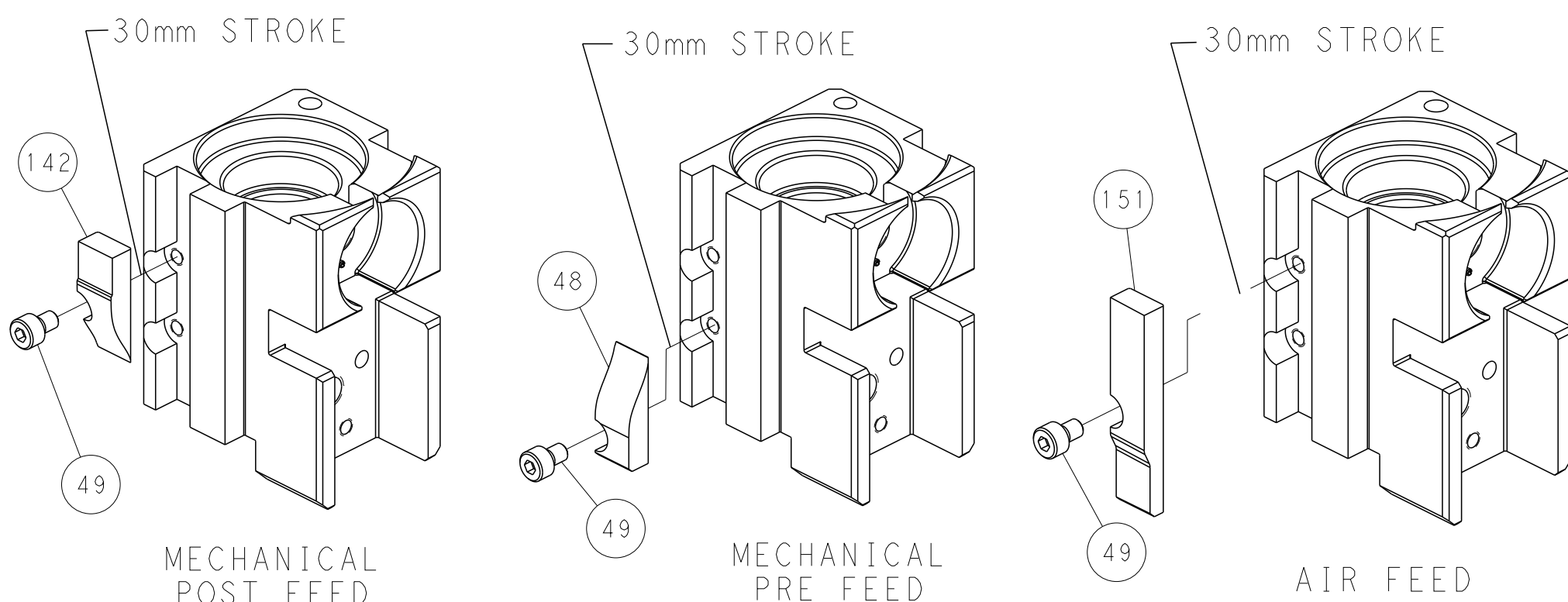
PNEUMATIC



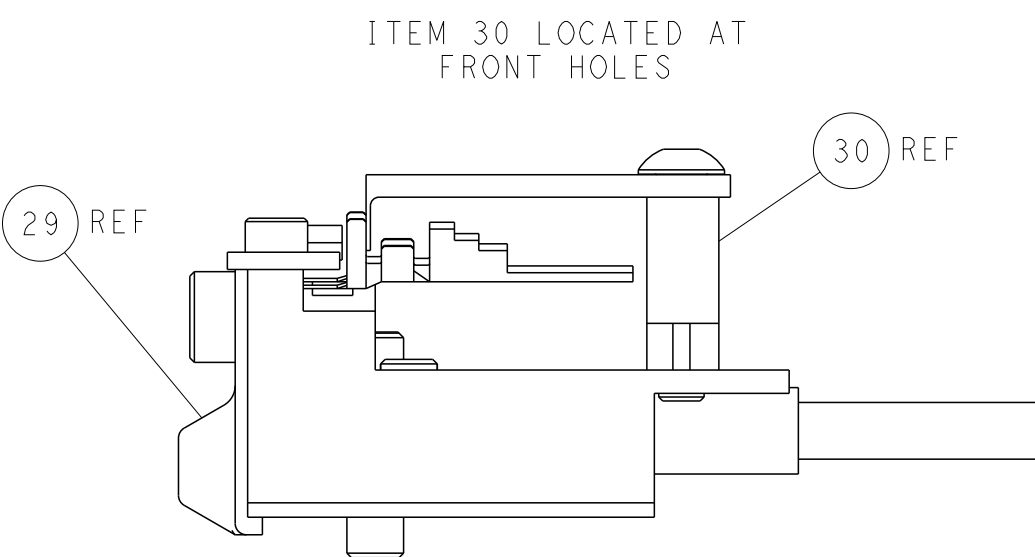
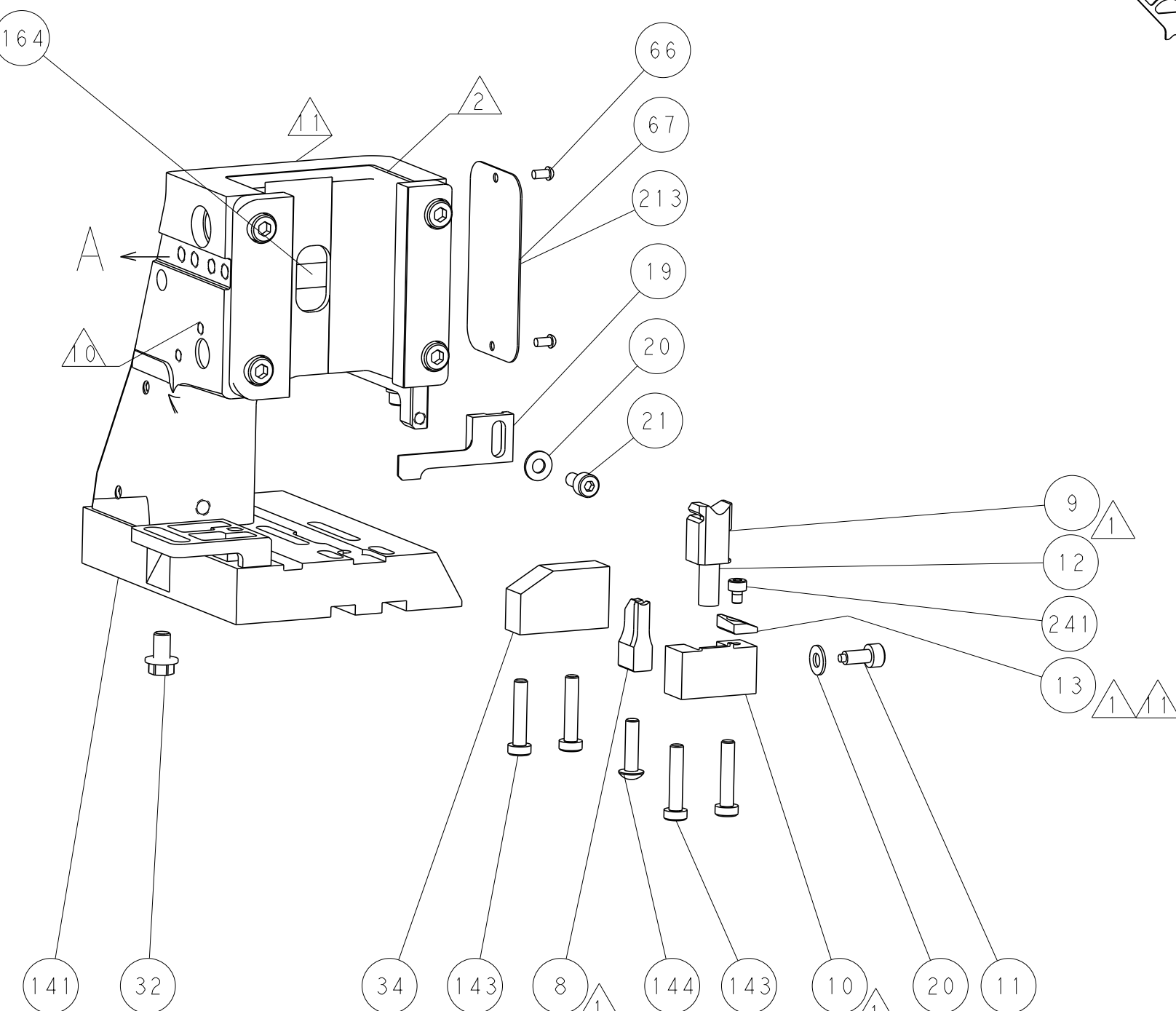
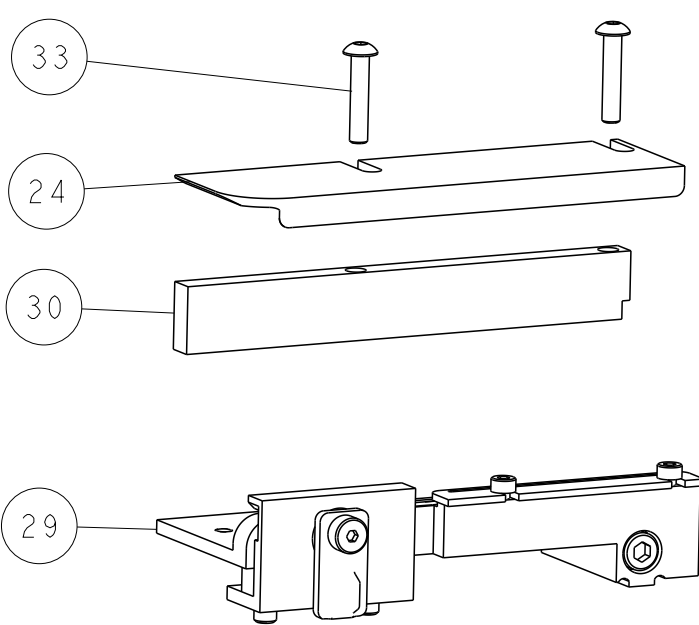
SERVO LATCH PLATE



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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		CHK	L. ZHANG	24AUG2015		
		APVD	J. GUO	24AUG2015	NAME	
		PRODUCT SPEC			Ocean Side Feed Applicator	
		APPLICATION SPEC			-	
		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
		A1	00779	C=2266958	-	
		Customer Accessible Production Drawing			SCALE	1:2
					SHEET	4 of 4
					REV	B

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION