

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2266010-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2266010-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266010-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266010-4	-	-	
	2266010-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
						2119951-1	-	8-2266010-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2266010-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
						2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
2266010-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266010-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
INSUL	1.07 mm [.042]	F
INSUL	1.40 mm [.055]	F

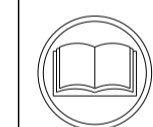
APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION			
TERMINAL NAME: SMALL TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.75-2.25 mm [.069-.089 IN]		Ø0.75-1.45 mm [.030-.057 IN]	
TERMINAL APPLICATION SPECIFICATION		HIROSE SPECIFICATION	-
DF3-EP2428PCFA		-	-
TERMINALS APPLIED			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
1949747-1	DF3-EP2428PCFA		

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION			
TERMINAL NAME: SMALL TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.75-2.25 mm [.069-.089 IN]		Ø0.75-1.45 mm [.030-.057 IN]	
TERMINAL APPLICATION SPECIFICATION		HIROSE SPECIFICATION	-
DF3-EP2428PCF		-	-
TERMINALS APPLIED			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
1949747-2	DF3-EP2428PCF		

WIRE SIZE		CRIMP HEIGHT mm [INCH] (A)		CRIMP HEIGHT REFERENCE SETTING
24 AWG		0.67+/-0.03 [.0264+/- .0012]		6.0
26 AWG		0.65+/-0.03 [.0256+/- .0012]		6.3
28 AWG		0.63+/-0.03 [.0248+/- .0012]		6.4

WIRE SIZE		CRIMP HEIGHT mm [INCH] (B)		CRIMP HEIGHT REFERENCE SETTING
24 AWG		0.72+/-0.04 [.0283+/- .0016]		5.5
26 AWG		0.70+/-0.04 [.0276+/- .0016]		5.7
28 AWG		0.68+/-0.04 [.0268+/- .0016]		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: 8-2266010-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266010-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266010-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266010-6

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 5.08.

*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

-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				LOC		DIST		REVISIONS					
2119599-1				A	A	66		P	LTN	DESCRIPTION	DATE	OWN	APPV
-	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	2119082-4	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					
-	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	1-455888-5	SPACER, CRIMPER	82					
-	1	1	1	1	1	1962431-2	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	1	1	2119791-9	DEPRESSOR, WIRE	70					
-	1	-	-	1	1	2119740-1	TAG IDENTIFICATION	67					
-	1	1	1	1	1	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	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	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	1752356-3	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	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21					
-	1	1	1	1	1	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	1633861-1	SHEAR, FLOATING	9					
-	1	1	1	1	1	1803335-7	ANVIL, COMBINATION	8					
-	-	-	-	-	-	-	-	7					
-	-	-	-	-	-	-	-	6					
-	1	1	1	1	1	2119780-6	DEPRESSOR, SHEAR	5					
-	1	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4					
-	1	1	1	1	1	1-1803326-5	CRIMPER, INSULATION F	3					
-	-	-	-	-	-	-	-	2					
-	1	1	1	1	1	1803324-4	CRIMPER, WIRE	1					

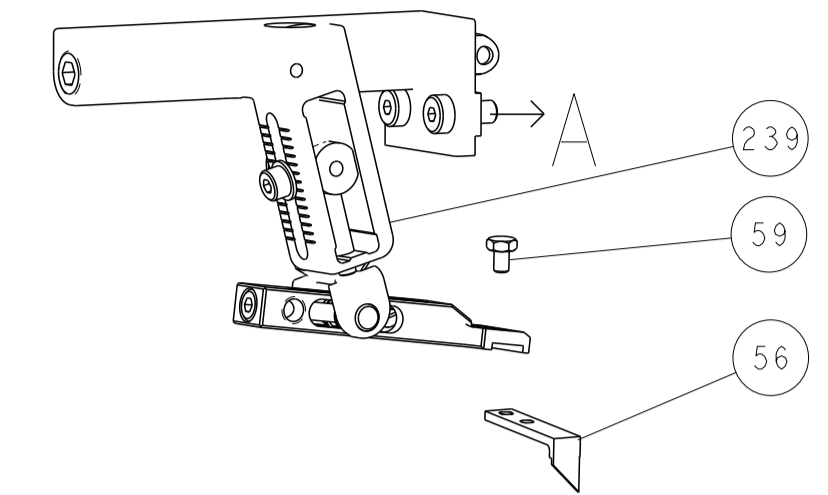
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
mm	0 PLC ±	1 PLC ±	2 PLC ±
	3 PLC ±	4 PLC ±	ANGLES ±
	FINISH		

DATE	BY	CHK	APPV	NAME
31 JUL 2013	J. STAKEM		G. BAILEY	G. BAILEY
31 JUL 2013	T. ELBIN			T. ELBIN

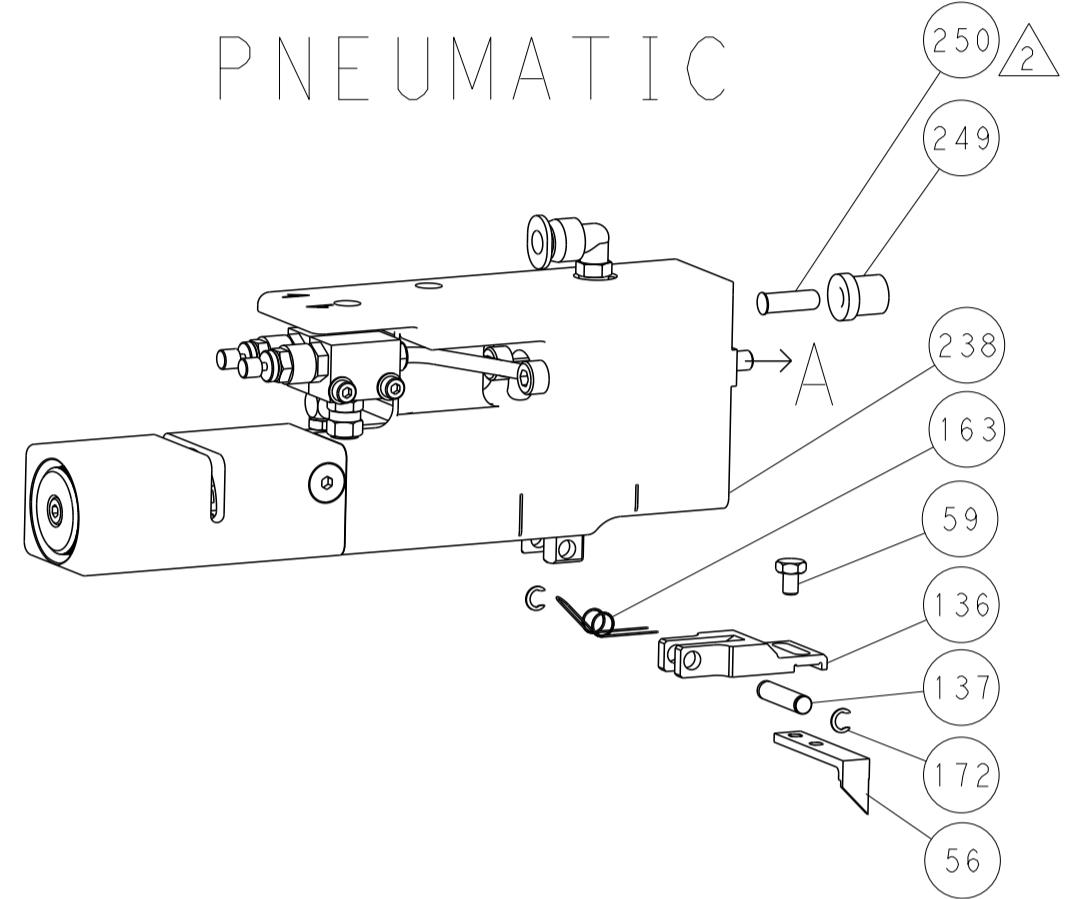
MATERIAL		WEIGHT	A1 00779	SCALE	1:2
CAGE CODE	00779	DRAWING NO	2266010	SHEET	1 OF 4
RESTRICTED TO				REV	B

LOC		DIST		REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD		
-	-	SEE SHEET 1	-	-	-	-	-

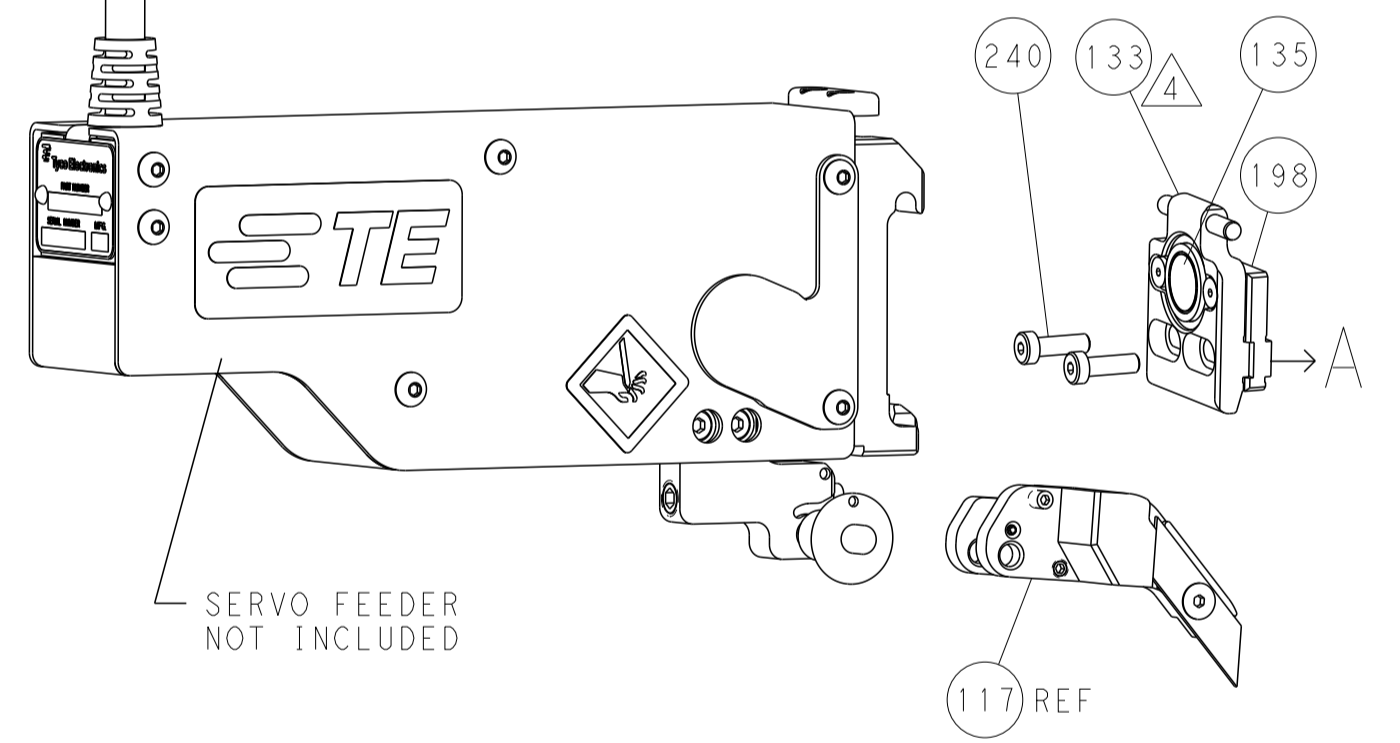
FEED TYPE MECHANICAL



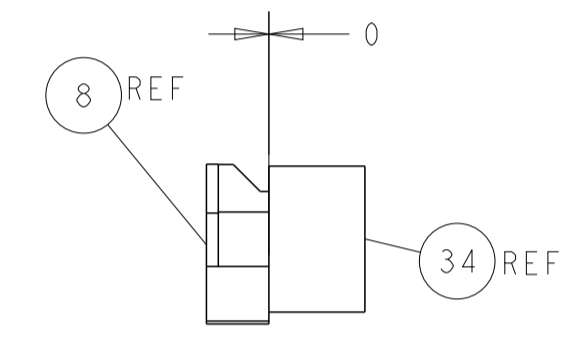
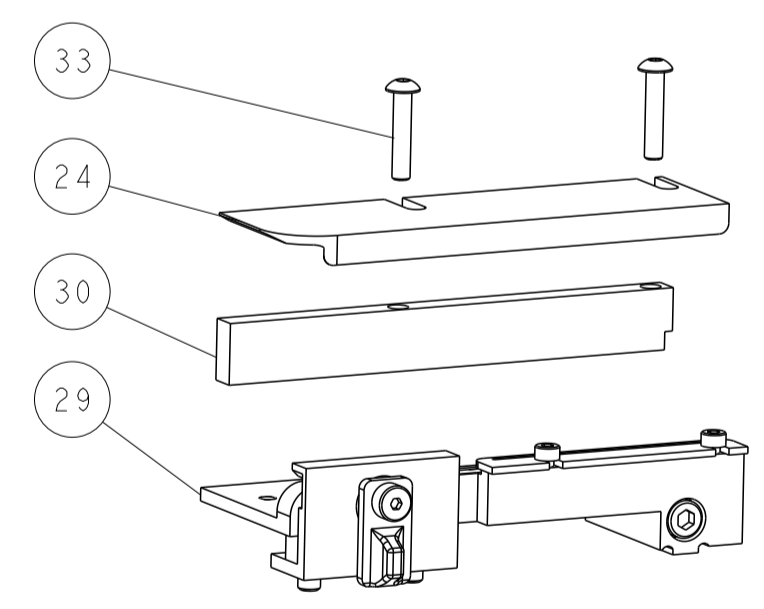
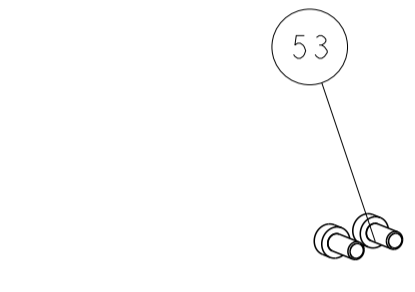
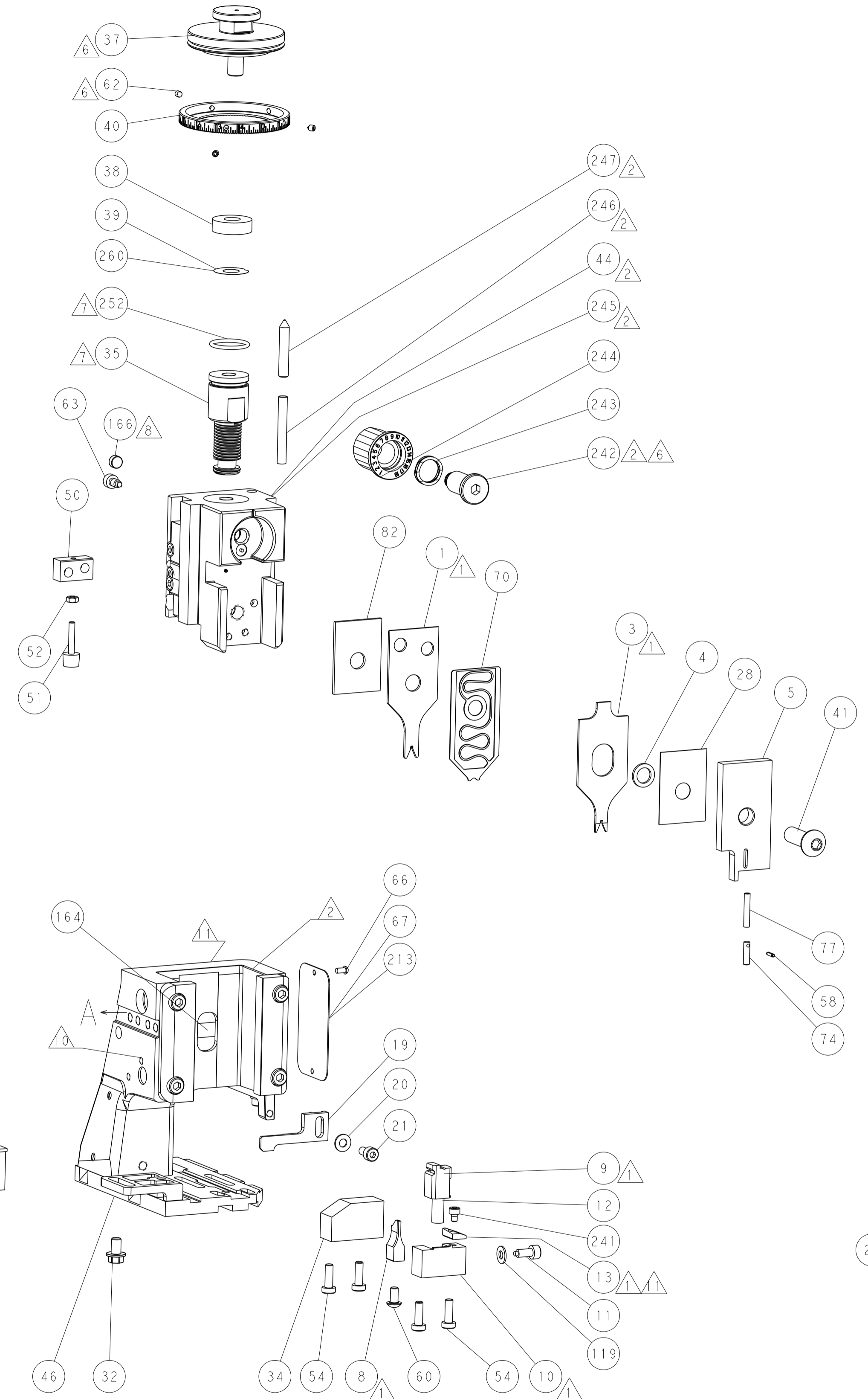
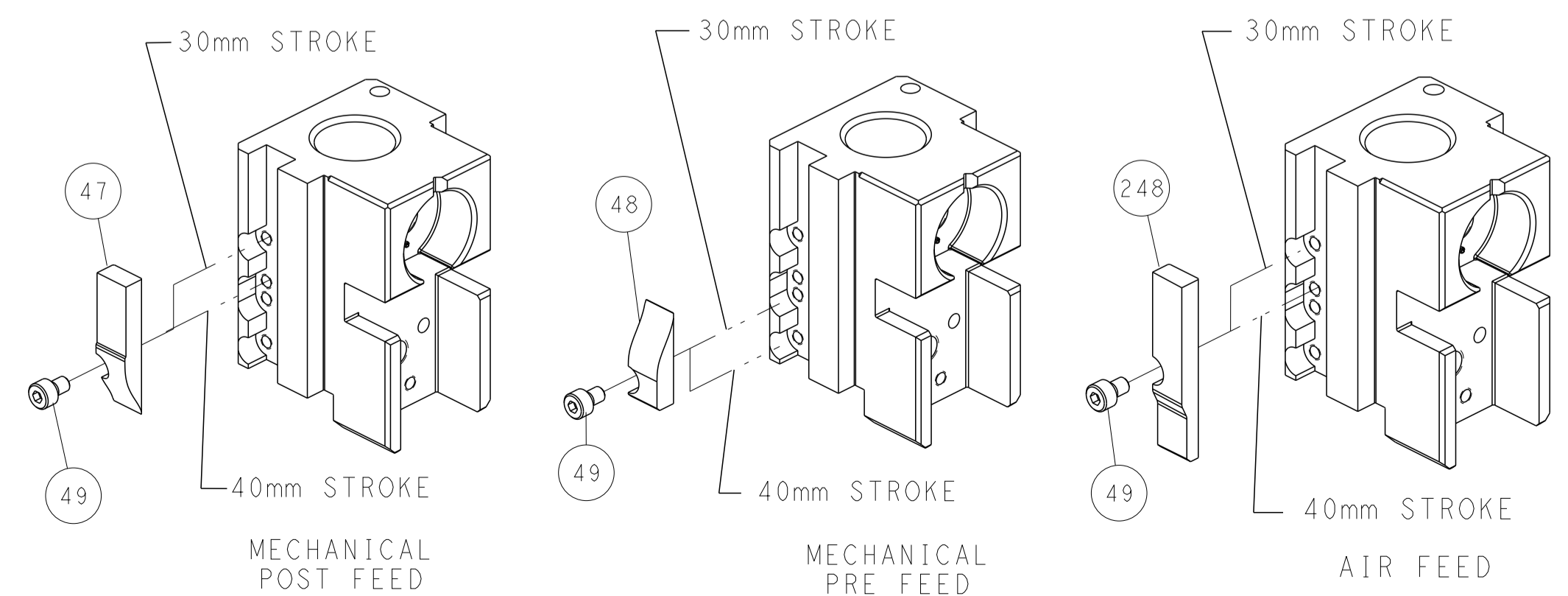
PNEUMATIC



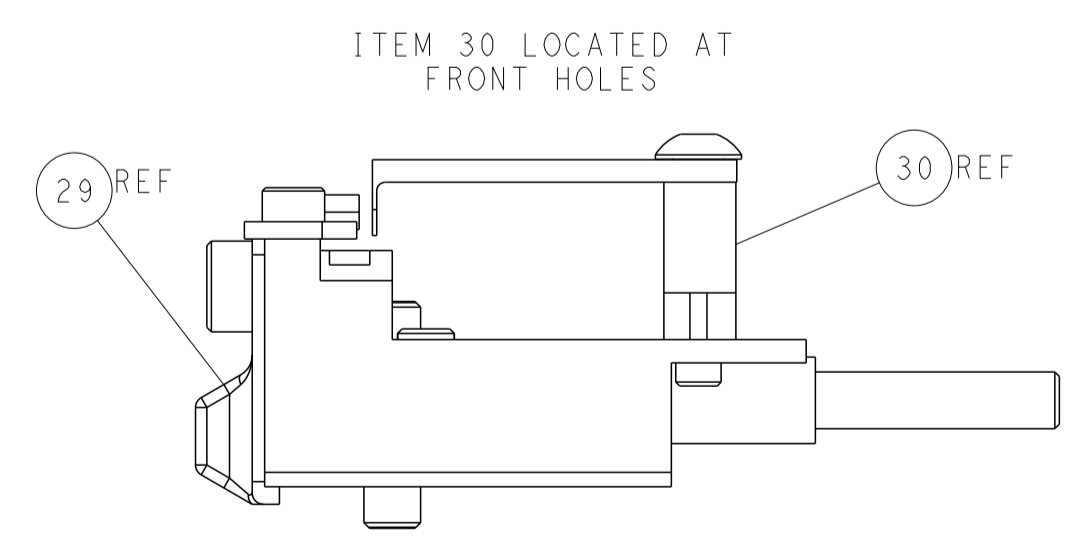
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. STAKEM 31JUL2013 CHK: G. BAILEY 31JUL2013 APVD: T. ELBIN 31JUL2013	
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266010	RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 1 of 4 REV: B

APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED. Includes sub-tables for PNEUMATIC FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, and PNEUMATIC FEED.

APPLICATOR DATA. Table with columns: CRIMP, SIZE, TYPE. Includes WIRE (1.07 mm), INSUL (1.40 mm), and APPLICATOR INSTRUCTIONS (408-10389).

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED table.

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED table.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table for 24 AWG, 26 AWG, 28 AWG.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table for 24 AWG, 26 AWG, 28 AWG.

REVISIONS table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD. Includes entry: SEE SHEET 1.

Main parts list table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD. Lists various components like CAM, SNAIL, WASHER, WAVE SPRING, etc.

- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP 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.

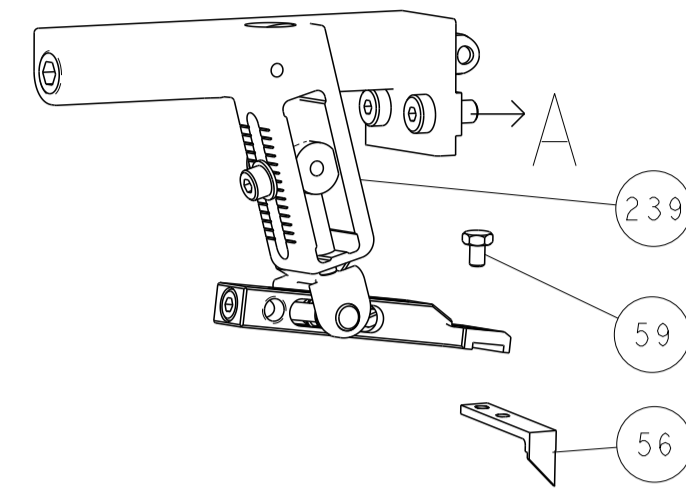
Table with columns: P, LTM, DESCRIPTION, ITEM NO. Includes items like FINE ADJUST HEAD ASM, PUSH ROD, AIR FEED, etc.

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

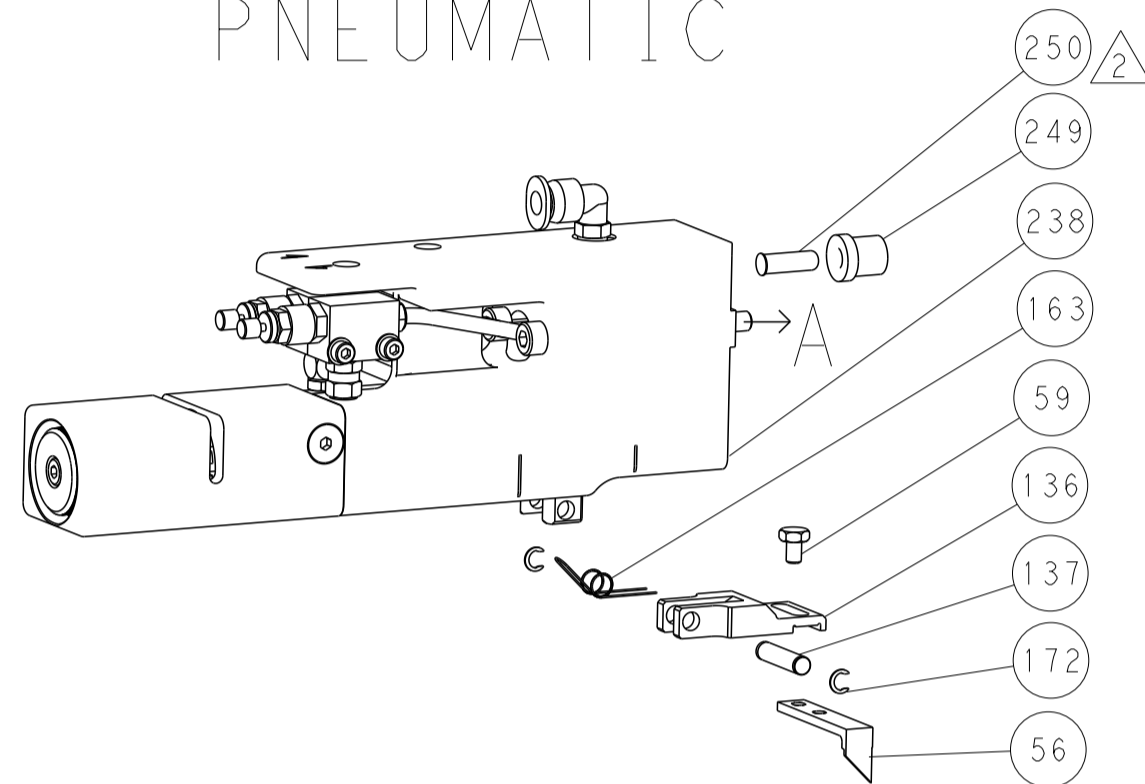
STE logo, DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, WEIGHT, SCALE 1:2, SHEET 1 OF 4.

LOC		DIST		REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD		
-	-	SEE SHEET 1	-	-	-		

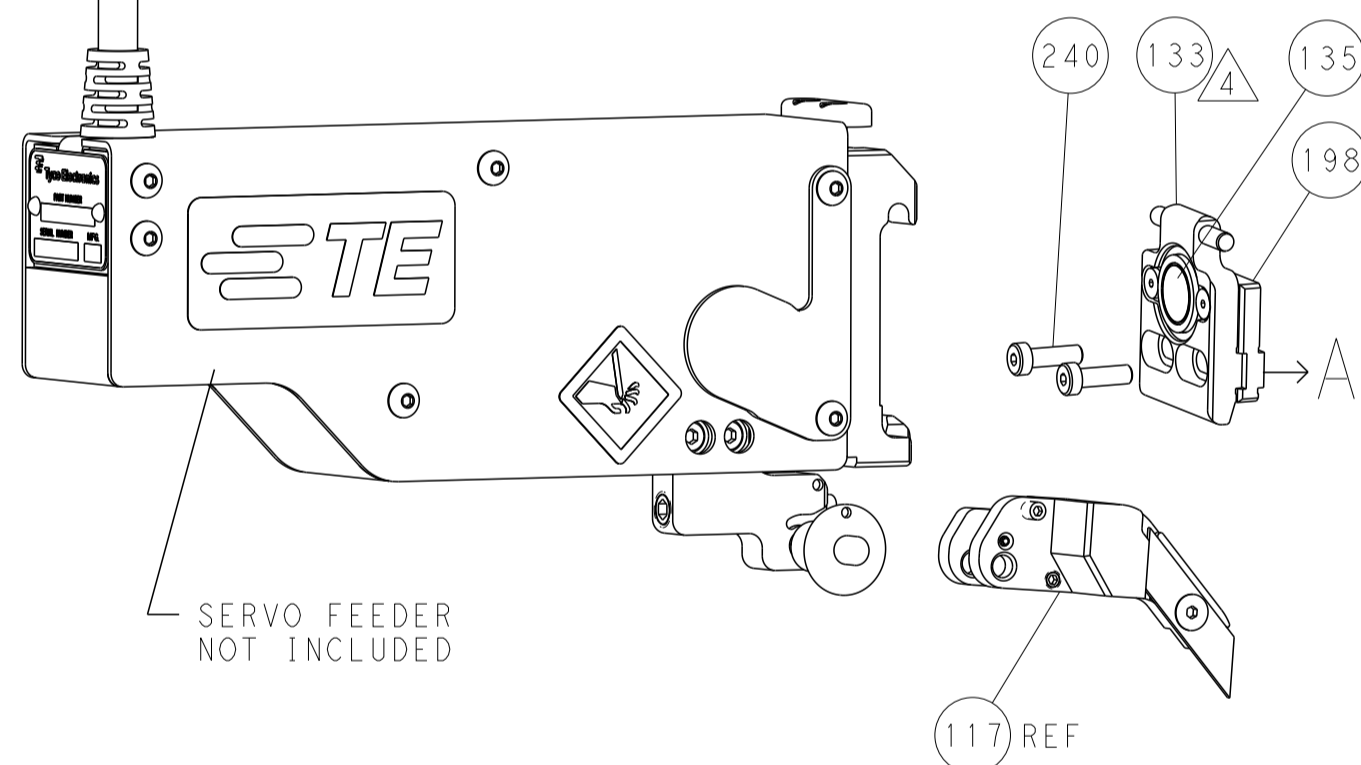
FEED TYPE MECHANICAL



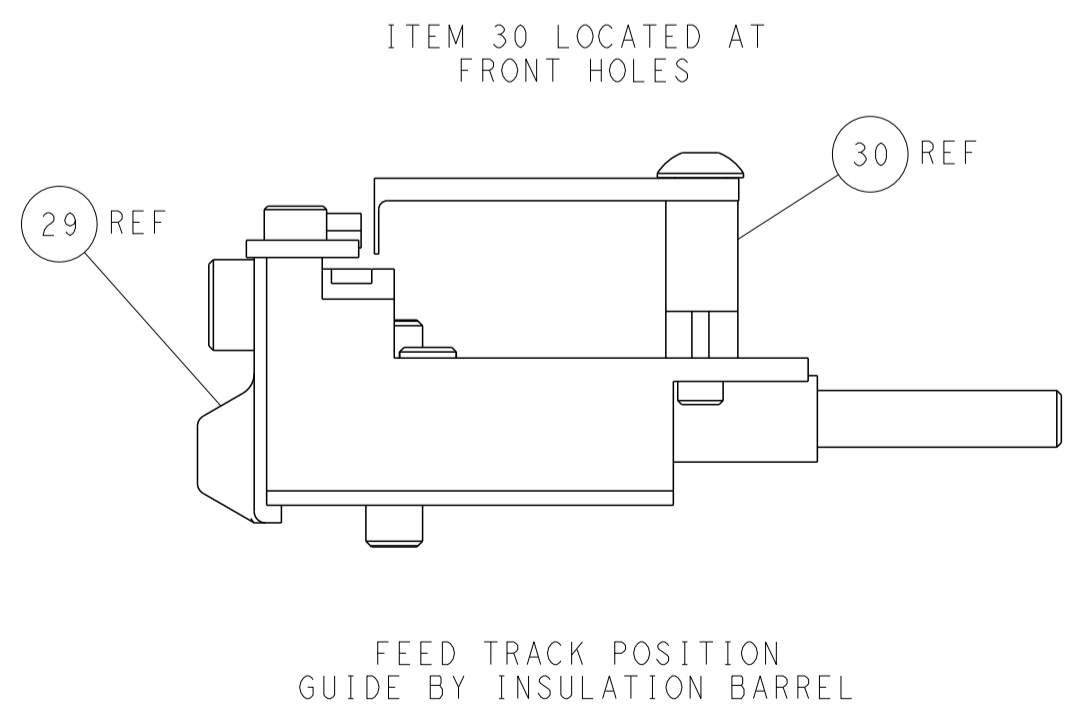
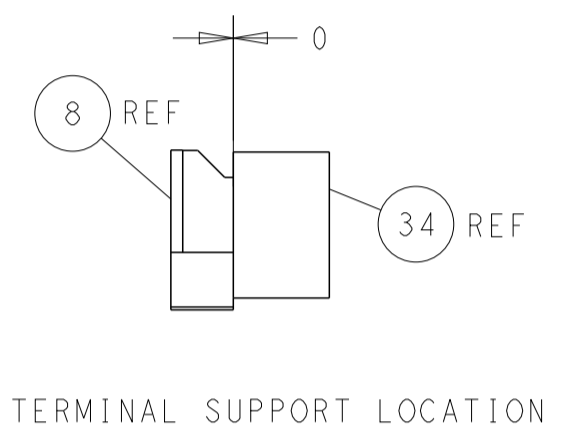
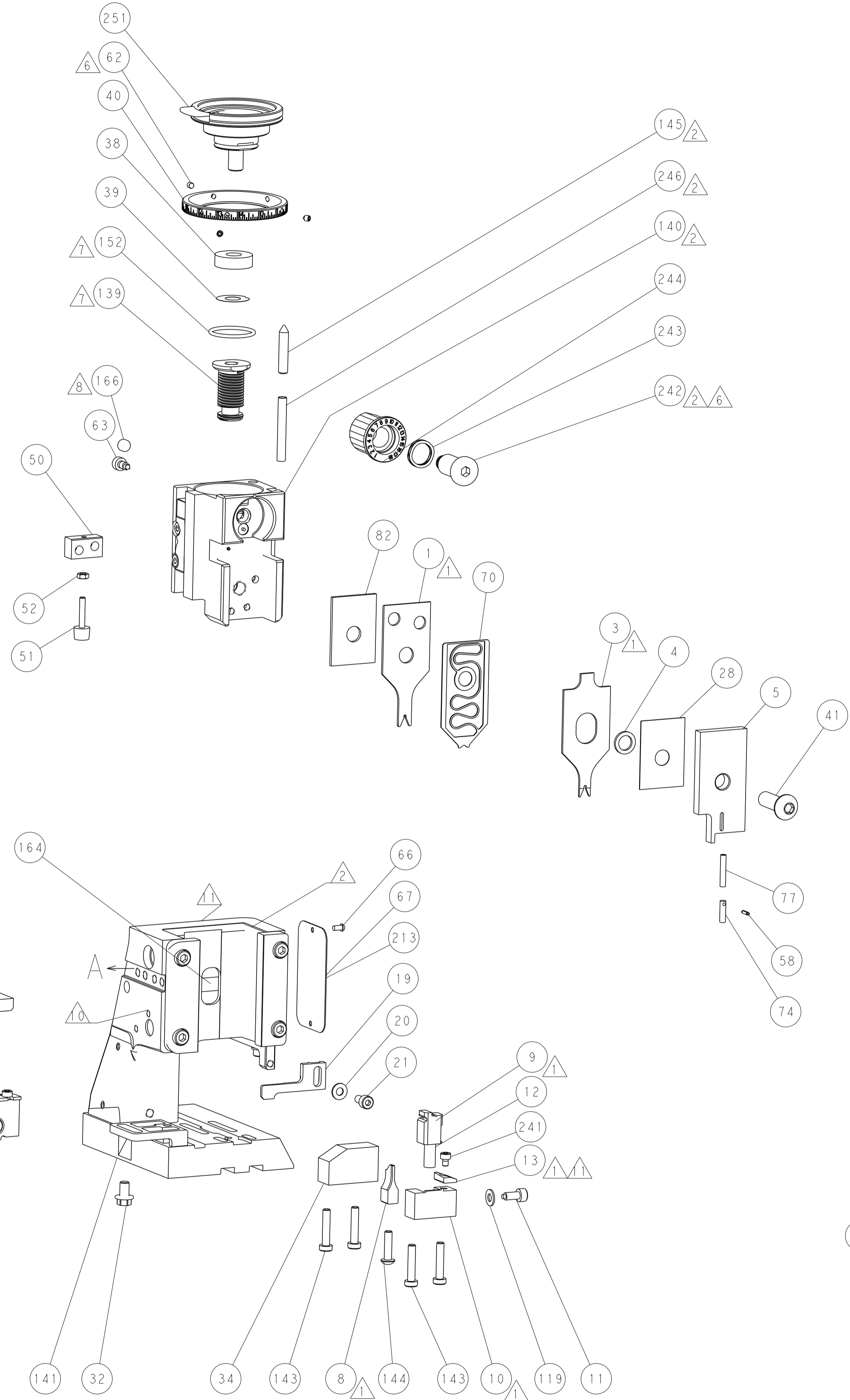
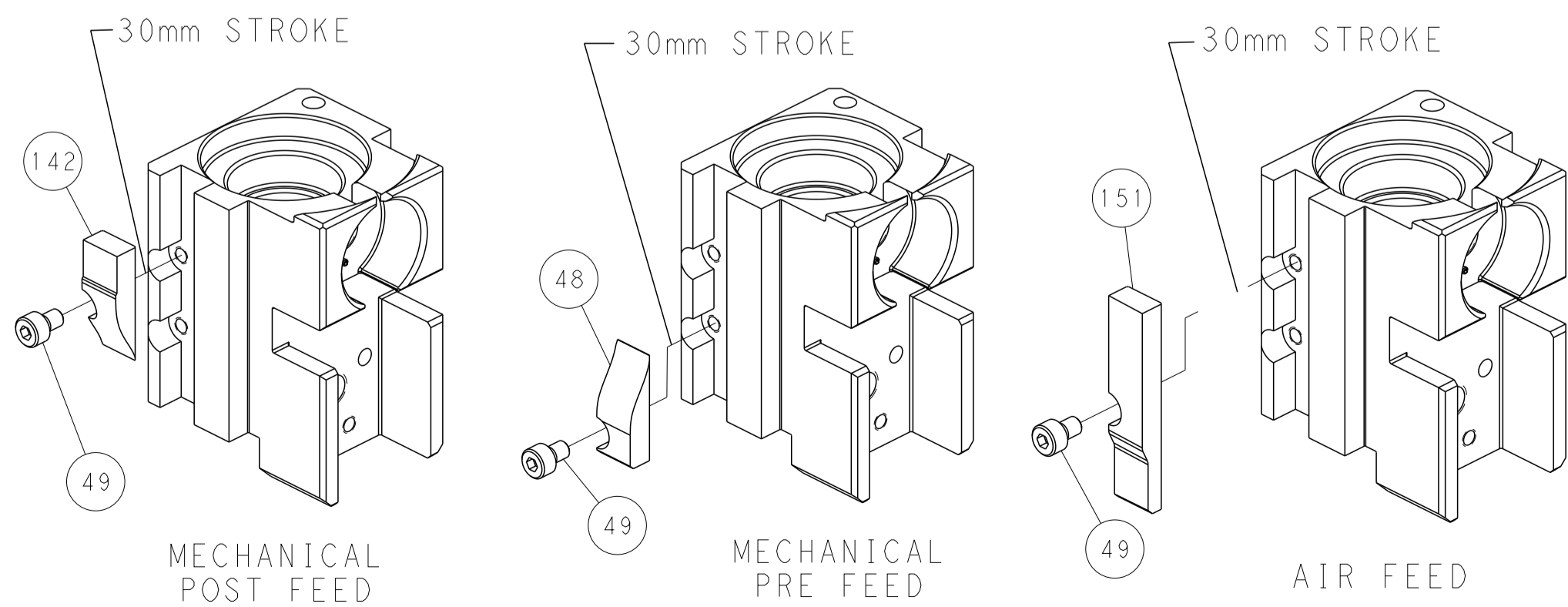
PNEUMATIC



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED IN THE ORDER. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DMN: STAKEM 31JUL2013 CHK: G. BAILEY 31JUL2013 APVD: T. ELBIN 31JUL2013	
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266010	RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 1 of 4 REV: B