

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2266273-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	1338683-8	5-18022-5	-	-	-
	2266273-5	E	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	-	8-2266273-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2266273-6	E	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ¹²	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-2
	2266273-7	E	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266273-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.83 mm [.190]	F

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: REC CONTACT S SIZE DYNAMIC CONN D-5 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-5.30 mm [.169-.209 IN]		Ø3.00-3.80 mm [.118-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-5206		
	(B) 114-51009		
TERMINALS APPLIED ^{10,13}			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 179955-2	(A) 917802-2	(A) 1-917802-6	
(A) 179955-3	(A) 917802-3	(B) 84696-1	
(A) 179955-6	(A) 1-917802-0	(B) 84696-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.11+/-0.05 [.083+/- .002]	5.2
16 AWG	1.90+/-0.05 [.075+/- .002]	7.1

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266273-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266273-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266273-6
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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 3.69.
- ¹³ TERMINAL LUBRICANT RECOMMENDED.

***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.

- 2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
- 1	1	1	1	1-1633782-2	FENCE	267
-	-	1	-	2119957-2	APPLICATOR SHIM PACK	260
- 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, MITSUMI	249
-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
- 1	-	1	1	2119798-1	DETENT PIN	247
- 1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
- 1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-7	-6	-5	-2	PART NO	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	66	REV	DATE	BY	APPD
			B	04NOV2014	YY	JT
			C	13NOV2014	YY	JT
			D	16JUN2016	YY	JT
			E	14SEP2016	MZ	JDG

- 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	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
- -	-	-	1	2063440-2	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	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	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
- 1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
- 2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
- 1	1	1	1	318563-1	GUARD, FRONT CHIP	89
- 1	1	1	1	455888-5	SPACER, CRIMPER	82
- 2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
- 1	1	1	1	1803096-1	EXTENSION PLATE	78
- 1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
- 1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
- 1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
- 2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
- 1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
- 3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
- 2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
- 1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
- -	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
- -	-	-	1	1338683-8	FEED PAWL	56
- 4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
- 2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
- 1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
- 1	1	1	1	1-811242-0	BUMPER, HOLD DOWN	51
- 1	1	1	1	690753-2	SPACER, TONKER	50
- -	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
- 1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
- 1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
- 1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
- 1	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
- 1	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
- 1	1	1	1	2119644-2	RAM WASHER, PRECISION	38
- 1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
- 1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
- 1	1	1	1	1752356-1	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	1320908-1	SPACER, STRIP GUIDE	30
- 1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
- 2	2	2	2	22283-1	SPRING, COMPRESSION	27
- 1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
- 1	1	1	1	240792-1	DRAG, TERMINAL	25
- 1	1	1	1	1320928-6	STRIP GUIDE	24
- 1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
- 1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
- 1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
- 1	1	1	1	2119533-1	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	454276-5	FLOATING SHEAR, FRONT	9
1	1	1	1	1-1333207-4	ANVIL, COMBINATION .110	8
- -	-	-	-	-	-	7
- -	-	-	-	-	-	6
- 1	1	1	1	2119757-9	DEPRESSOR, SHEAR	5
- 1	1	1	1	4-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1	1-1803016-2	CRIMPER, INSULATION F	3
- 1	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	1	1	456408-8	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
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	1 PLC	±	08AUG2014	CHK	L. ZHANG
	2 PLC	±	08AUG2014	APPD	T. FLBIN
	3 PLC	±			
	4 PLC	±			
	ANGLES	±			
	FINISH	±			

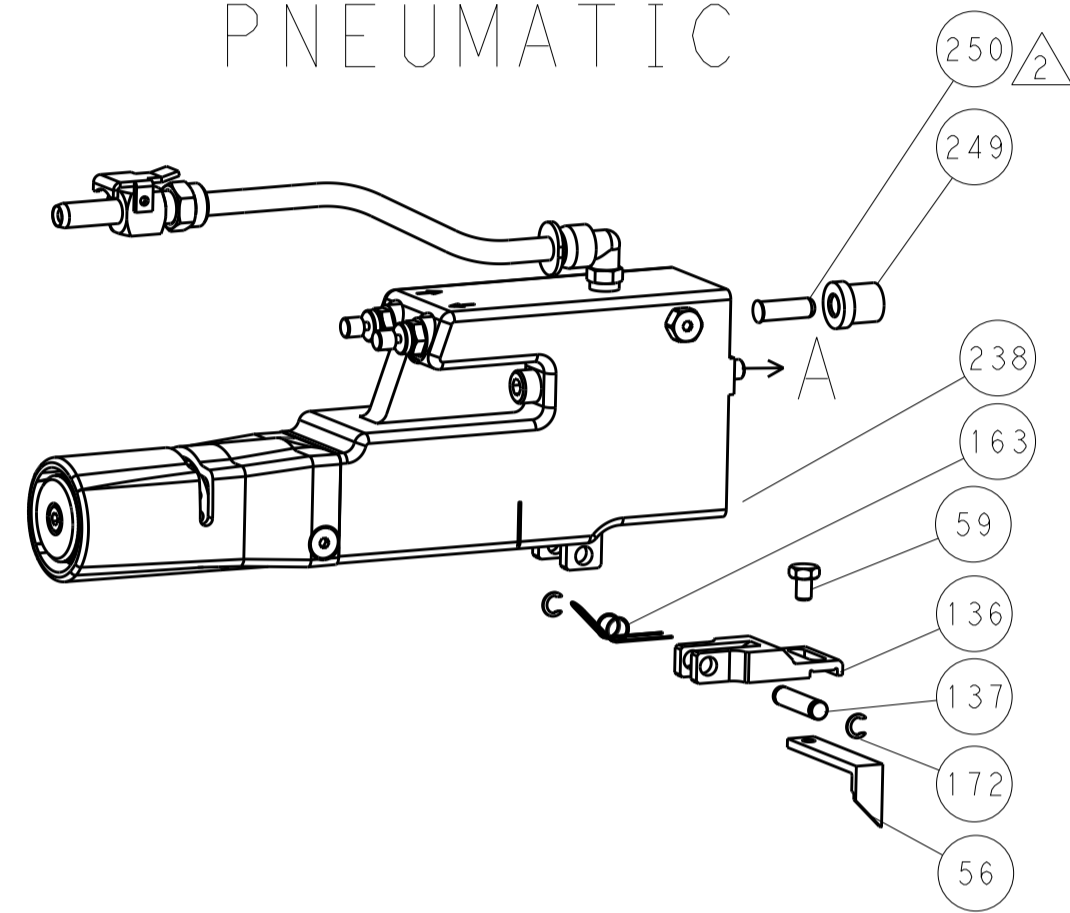
NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Ocean Side Feed Applicator	A1	00779	2266273	

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

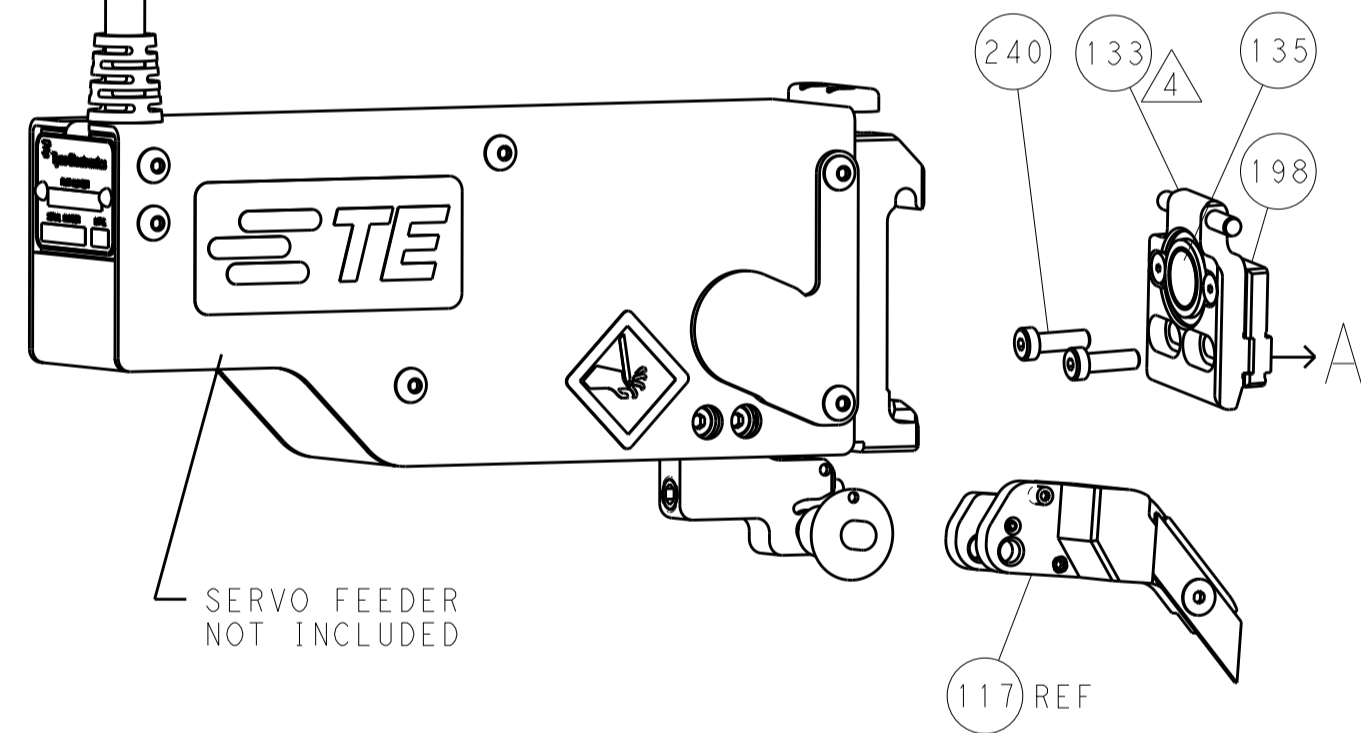
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A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

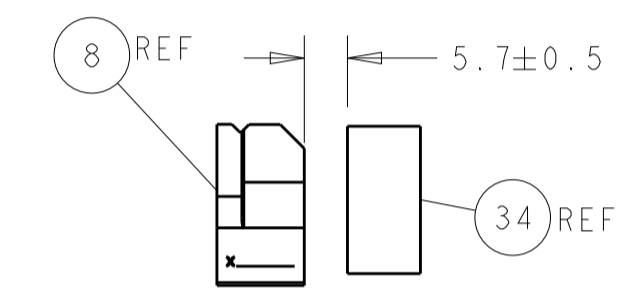
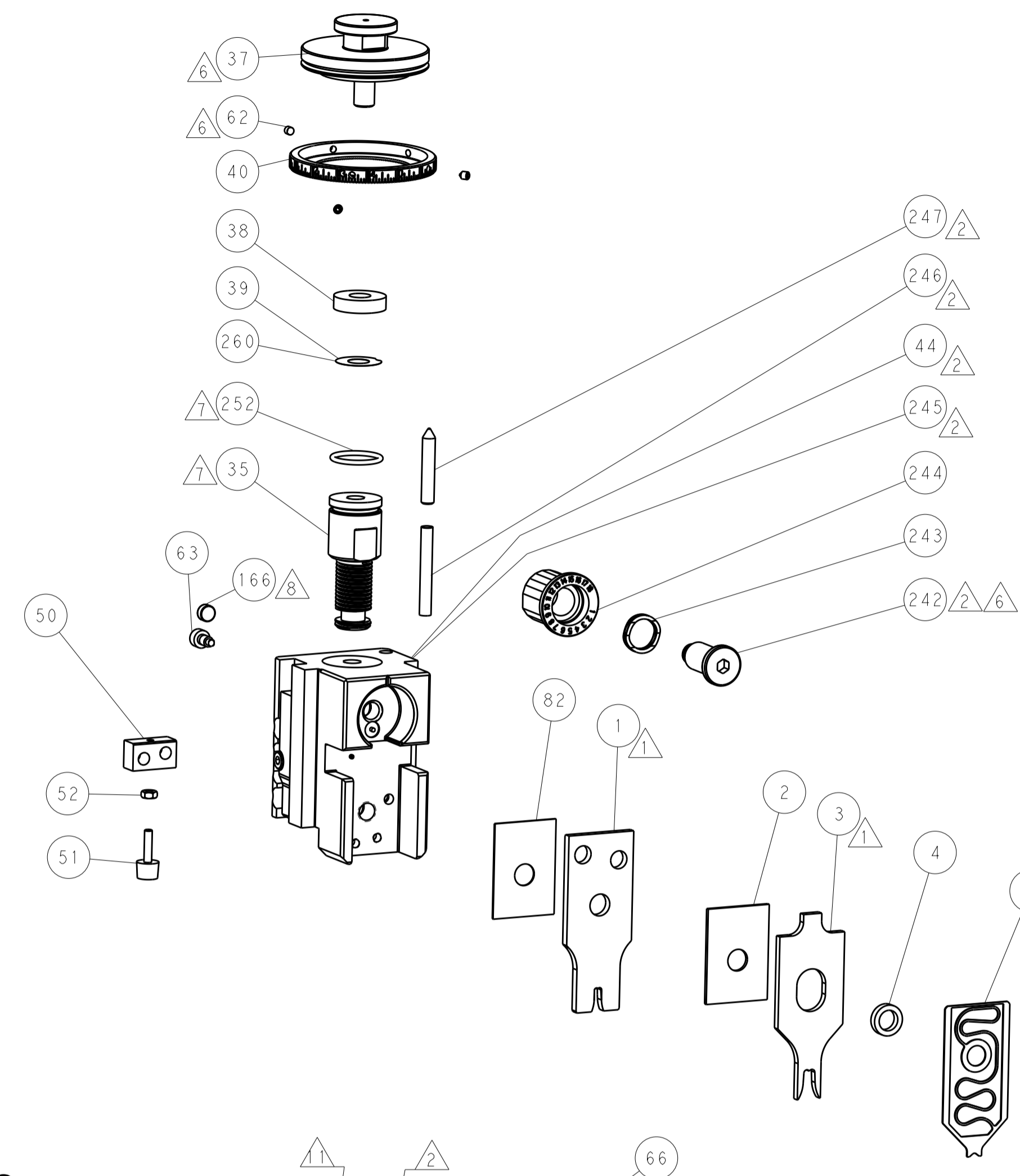
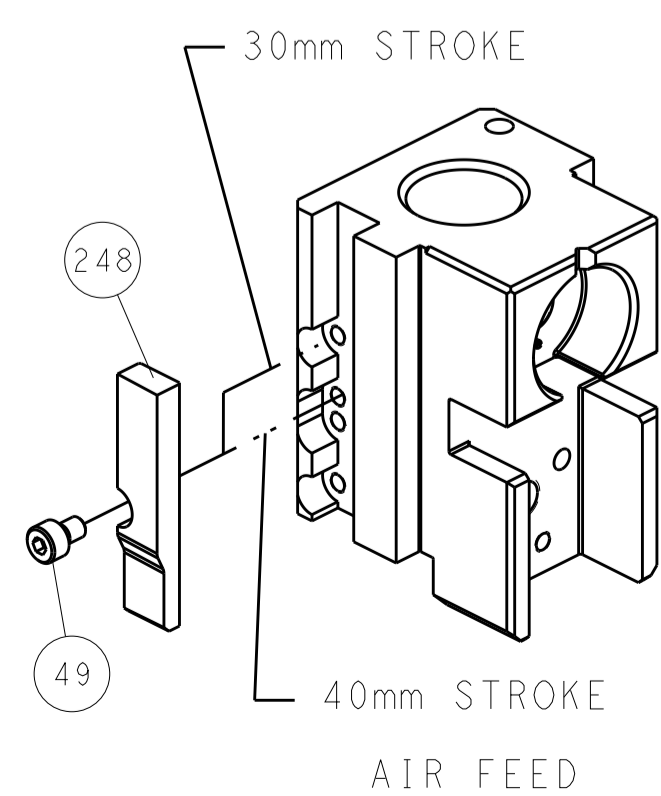
PNEUMATIC



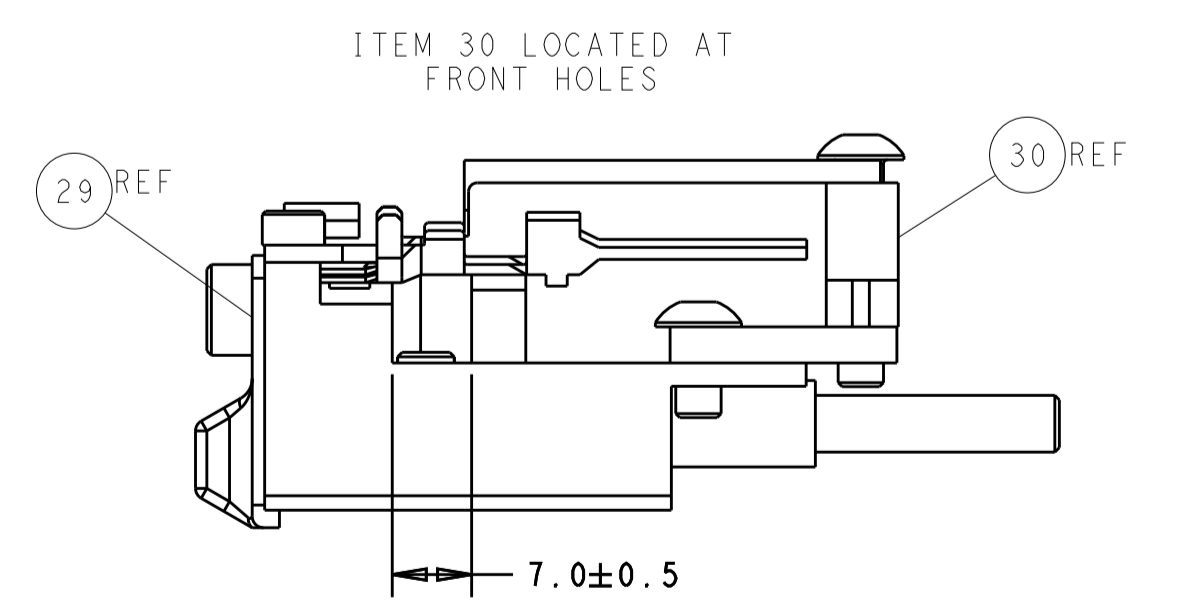
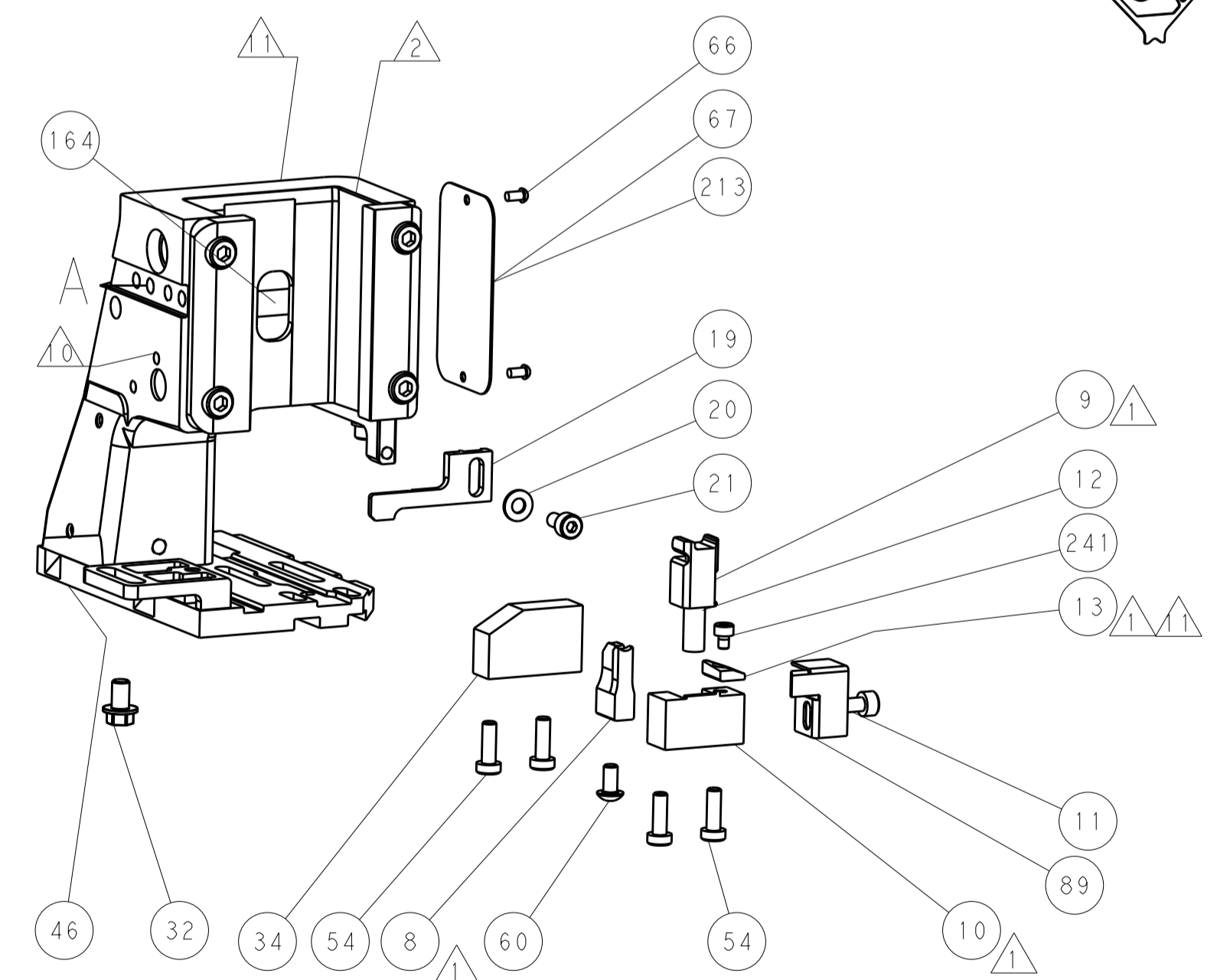
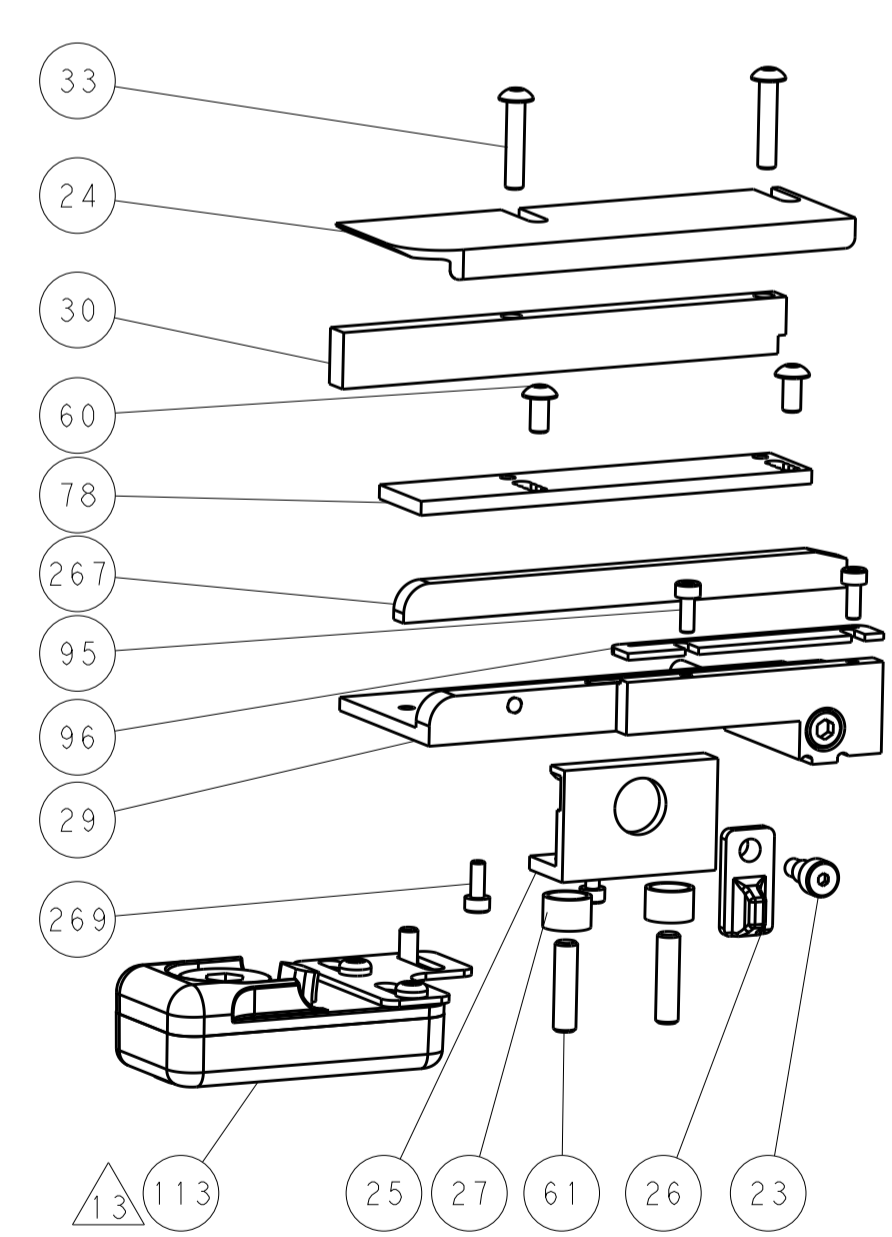
SERVO LATCH PLATE



CAM POSITION



TERMINAL SUPPORT LOCATION



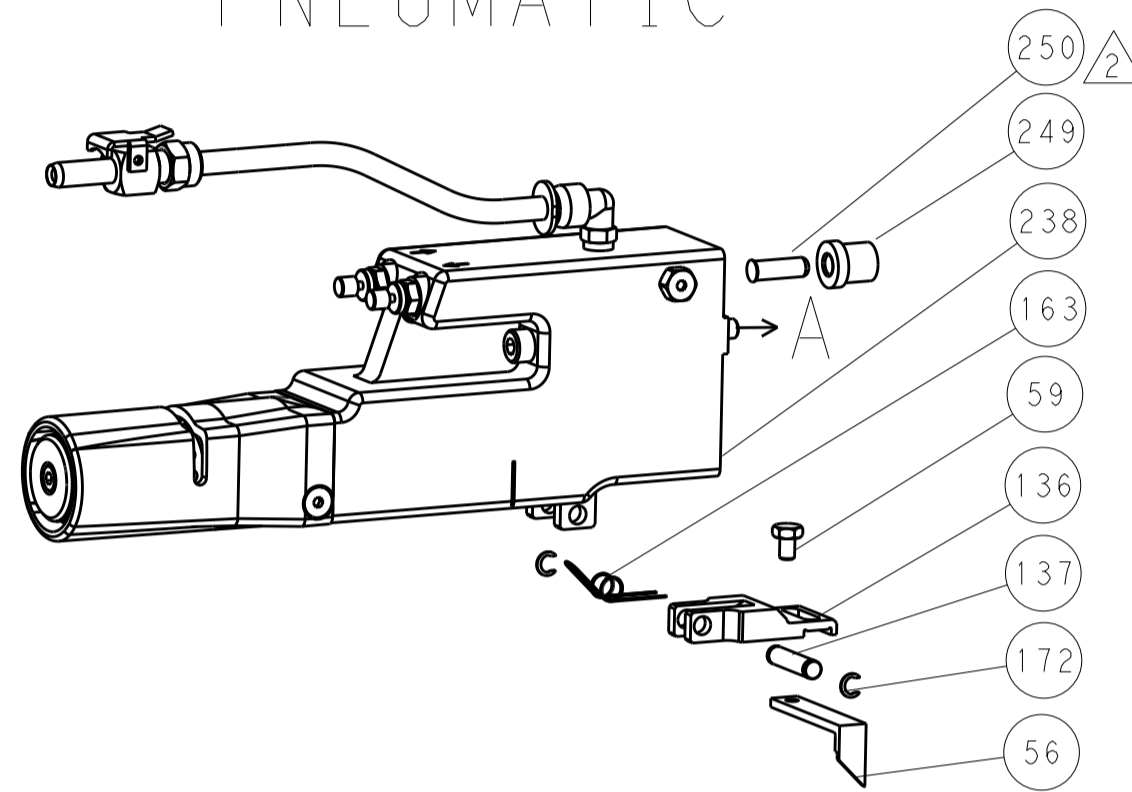
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

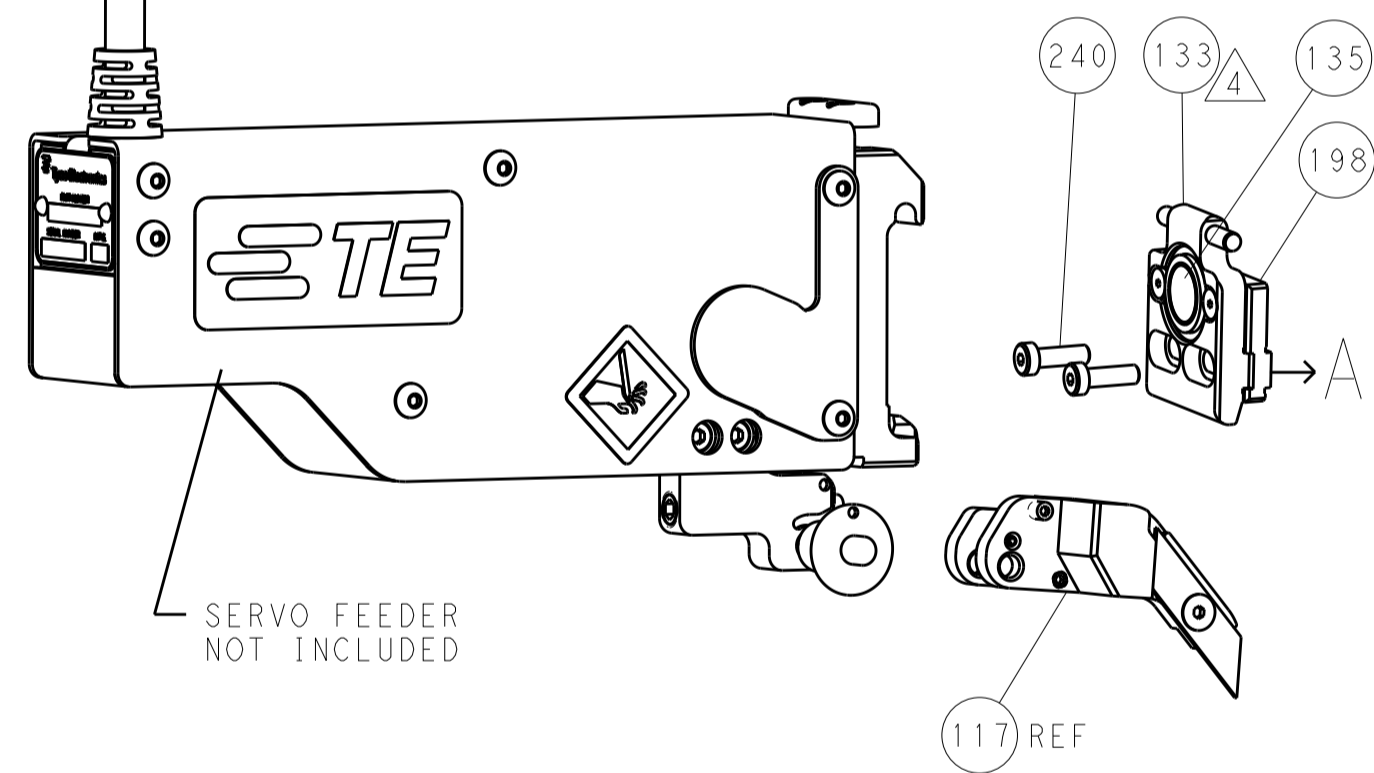
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	ANGLES ±			CHK L.ZHANG 08AUG2014		NAME	
				APVD T.ELBIN 08AUG2014		Ocean Side Feed Applicator	
MATERIAL	FINISH			PRODUCT SPEC		RESTRICTED TO	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A1 00779 C=2266273	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 2 OF 4 REV E	

FEED TYPE

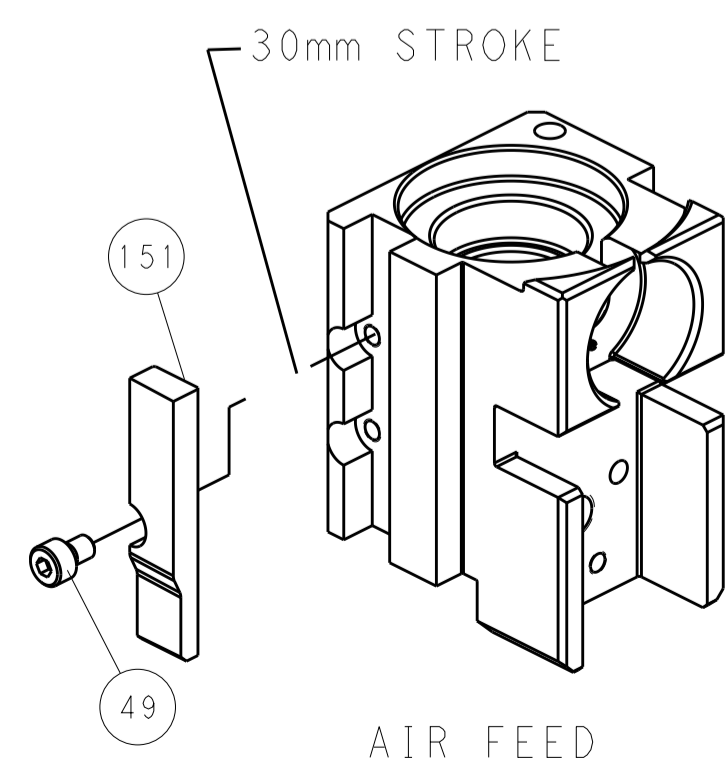
PNEUMATIC



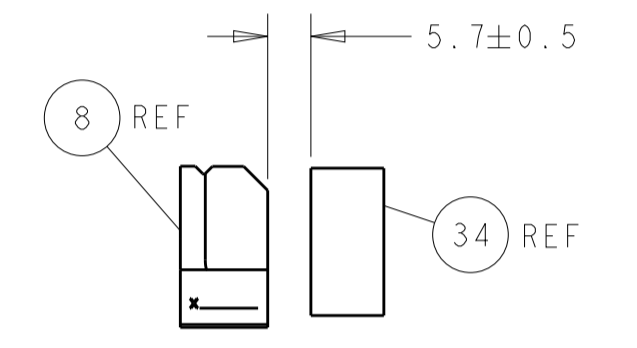
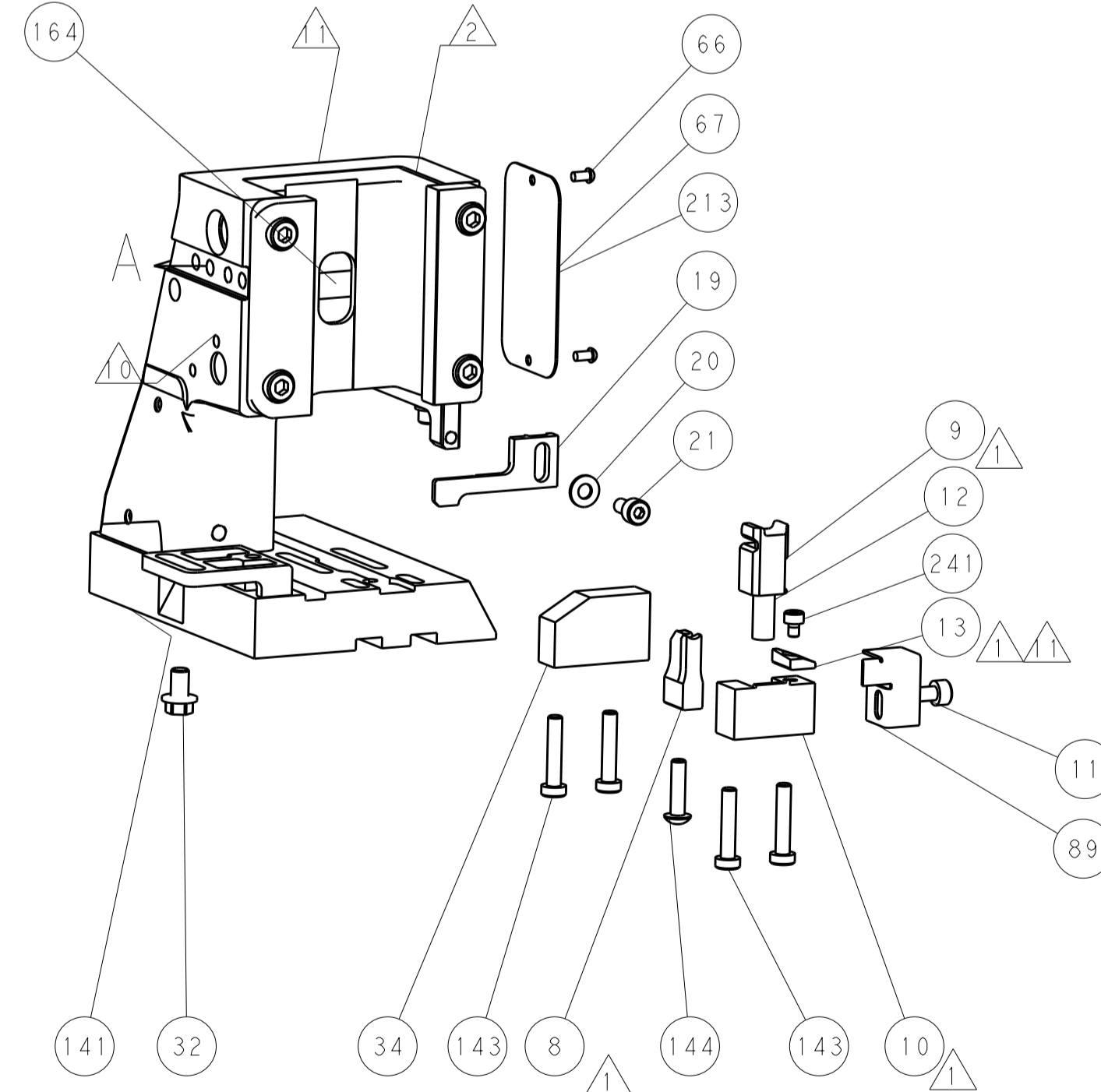
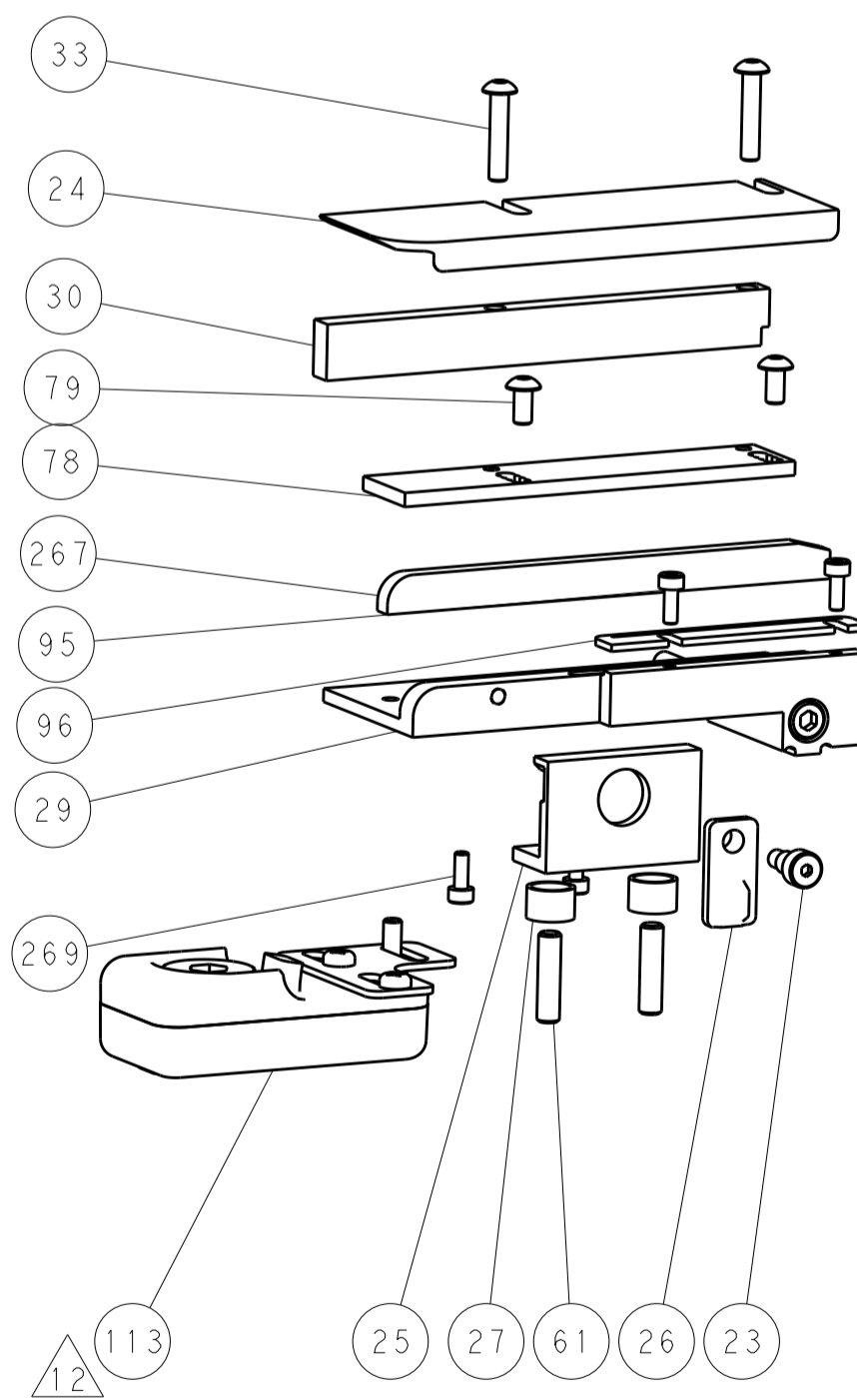
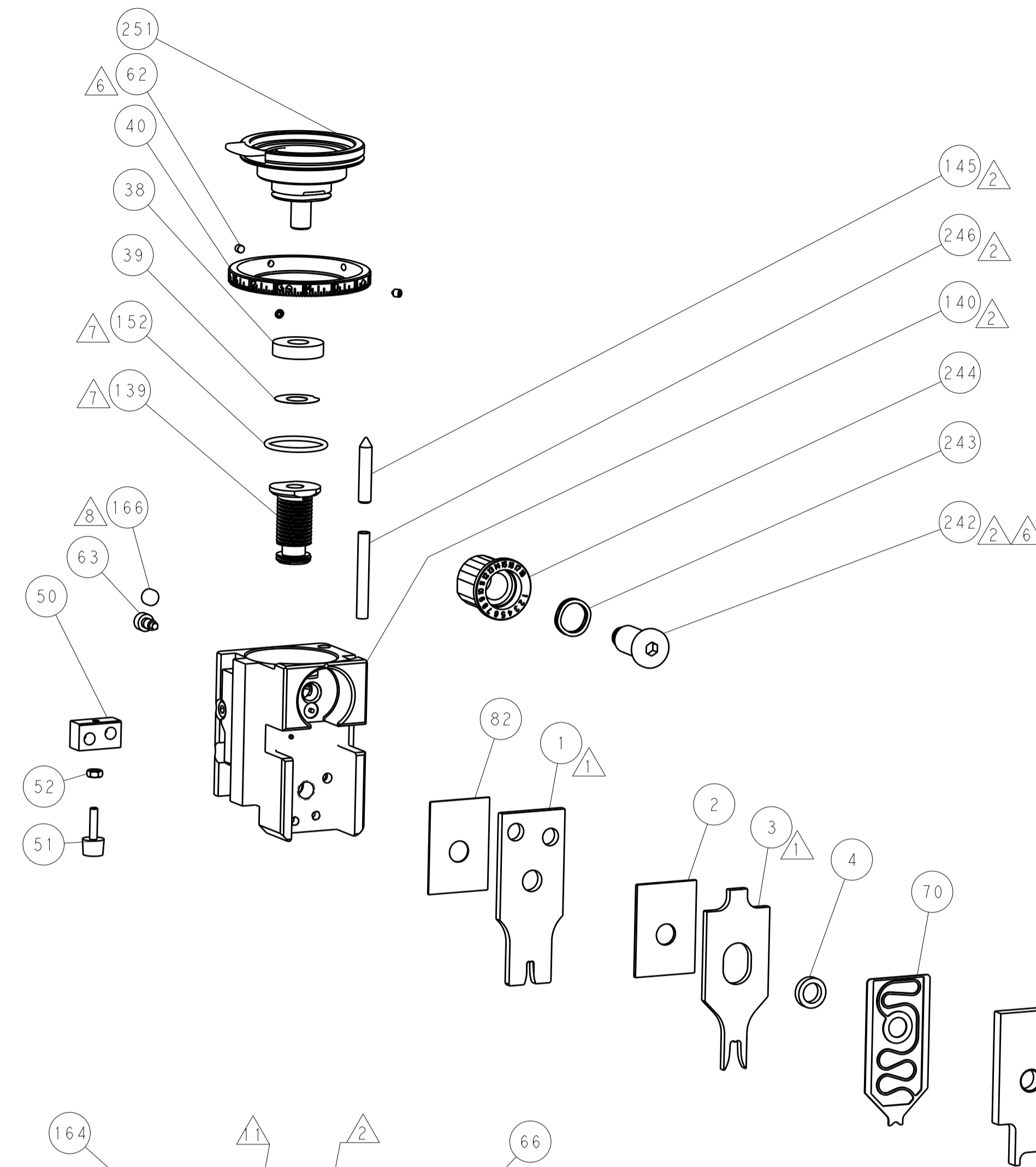
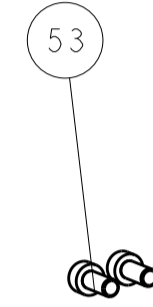
SERVO LATCH PLATE



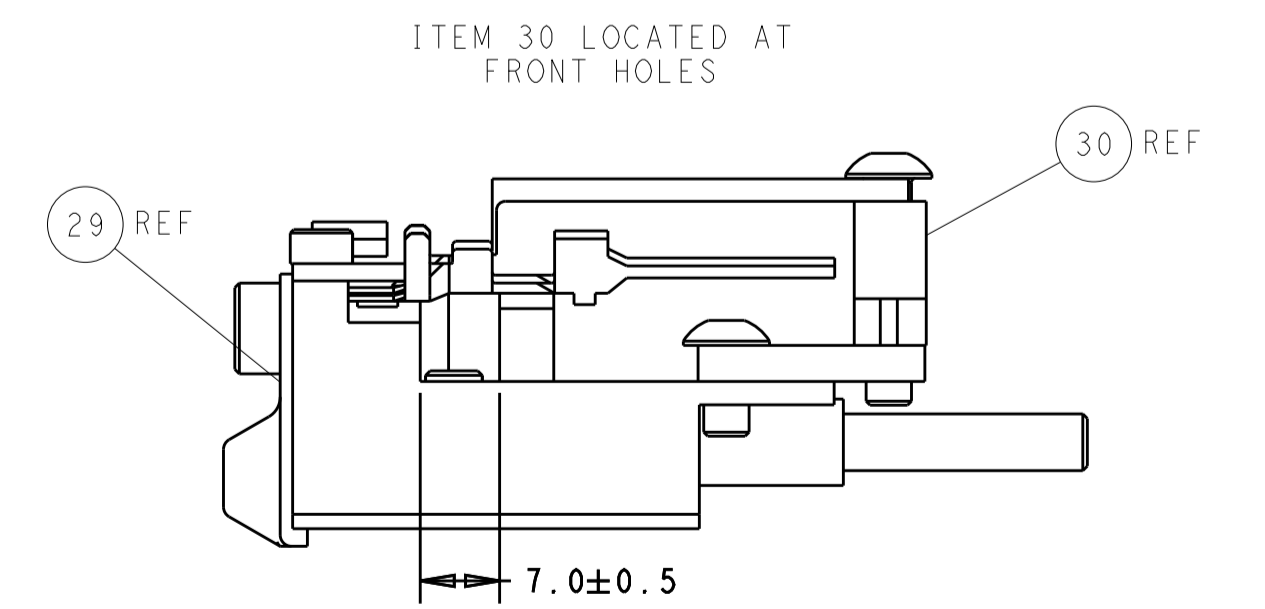
CAM POSITION



AIR FEED



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

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LOC	DIST	REVISIONS							
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD		
				SEE SHEET 1					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:							
mm	0 PLC	±							
	1 PLC	±							
	2 PLC	±							
	3 PLC	±							
	4 PLC	±							
	ANGLES	±							
MATERIAL	FINISH								
DWN		CHK		APVD		NAME		RESTRICTED TO	
X. ZHAO		L. ZHANG		T. ELBRIN		Ocean Side Feed Applicator		-	
08AUG2014		08AUG2014		08AUG2014		STE TE Connectivity Harrisburg, PA 17105-3608		-	
SIZE		CAGE CODE		DRAWING NO		SCALE		SHEET	
A1		00779		C=2266273		1:2		4 OF 4	
Customer Accessible Production Drawing		SCALE		SHEET		OF		REV	
		1:2		4		4		E	