

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2266547-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1
	2266547-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266547-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266547-4	-	-	
					MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-	-
	2266547-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2266547-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266547-4	-	-	
					MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-	-
2266547-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1	
				-	-	-	-	-	-	-	
2266547-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266547-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.90 mm [.154]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .090 MLC SEALED TAB CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.87-4.13 mm [.152-.163 IN]		Ø	△3
TERMINAL APPLICATION SPECIFICATION	114-61004	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
936260-1	1-936260-1	828904-1	
936260-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.13+/-0.05 [.044+/- .002]	7.1
0.30mm2	1.05+/-0.05 [.041+/- .002]	8.0

- △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: 8-2266547-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266547-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266547-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266547-6
- 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 4.67.
- △13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- △14 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.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .090 II SEALED TAB RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.87-4.13 mm [.152-.163 IN]		Ø	△3
TERMINAL APPLICATION SPECIFICATION	114-61004	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
368287-1	-	828904-1	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.94+/-0.05 [.037+/- .002]	9.1
0.30mm2	0.85+/-0.05 [.033+/- .002]	10.0

\*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
-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)

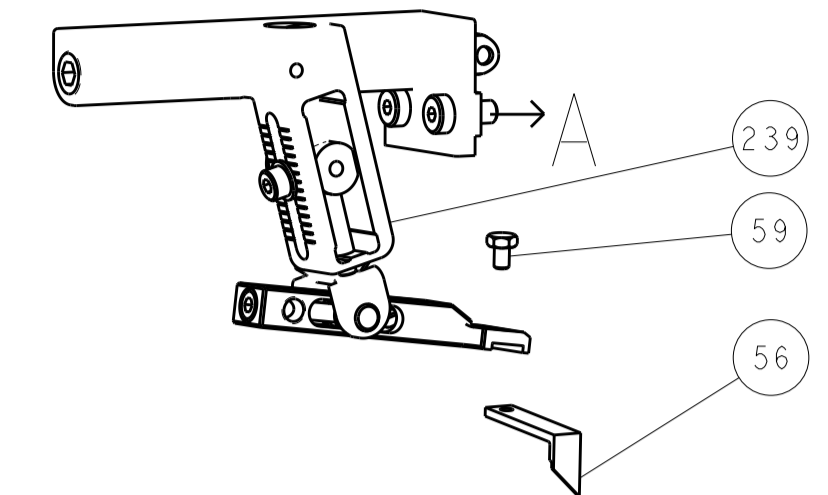
SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-1		A	66	#	DATE	BY	APPV
1	DEVELOPMENT		02DEC2014	JH	UG		
A	RELEASED		12DEC2014	JH	TE		
A1	ECR-15-000516		13JAN2015	KH	TE		
B	ECR-15-012558		25AUG2015	JH	TE		

#	QTY	DESCRIPTION	DATE	BY	APPV
-	1	O-RING, .676 ID, .070 DIA. MAT.			252
-	-	PUSH ROD, AIR FEED			250
-	-	BUSHING, LCH5-12, MISUMI			249
-	-	FEED CAM, AIR FEED			248
-	1	DETENT PIN			247
-	1	SPRING, COMPRESSION			246
-	-	RAM, AMP STYLE, SIDE FEED, NON-ADJ.			245
-	1	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	WASHER, WAVE SPRING, CREST-TO-CREST			243
△6	1	RETAINER, INSULATION DIAL			242
-	1	SCR, SKT HD CAP M3 X 4.0			241
-	-	SHCS, LOW HEAD, RoHS, M5 X 16			240
-	-	MECHANICAL FEED ASSEMBLY			239
-	-	AIR FEED MODULE			238
-	-	TAG, IDENTIFICATION			213
-	-	SPACER, FEEDER			198
-	-	RING, RETAIN, EXTERN, 3/16 CRESCENT			172
-	1	MAGNET, RARE EARTH HIGH ENERGY			166
-	REF	COUNTER, MAGNETIC			164
-	-	SPRING, FEED FINGER			163
-	-	PIN, RETAIN, GRVD, 3/16 X .854			137
-	-	HOLDER, FEED FINGER, AF			136
-	-	MEMORY CHIP, PROGRAMMED			135
-	-	SERVO FEED LATCH ASM			133
-	-	FEED FINGER ASSEMBLY, SF			117
-	1	SPACER, CRIMPER			82
-	1	DOCUMENTATION PACKAGE			71
-	1	TAG, IDENTIFICATION			67
-	2	SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	1	LIMITER, ADJUSTMENT BOLT			63
△6	3	SCR, SET, SOC, CONE POINT, M3 X 4.0			62
-	1	SCR, BHSC, RoHS (M4 X 8)			60
-	-	SCR, HEX HD CAP, M4 X 6.0			59
△4	1	SCR, FLT SKT HD CAP M3 X 10.0			57
-	-	FEED PAWL			56
-	4	SHCS, LOW HEAD, RoHS, M4 X 12			54
-	2	SCR, SKT HD CAP, RoHS, M4 X 10			53
-	1	NUT, HEX, REG, RoHS, M3			52
-	1	BUMPER, HOLD DOWN			51
-	1	SPACER, TONKER			50
-	-	SCR, SKT HD CAP M4 X 6.0			49
-	-	FEED CAM, PRE FEED			48
-	-	FEED CAM, POST FEED			47
-	1	APPLICATOR BASIC ASSEMBLY, SF			46
-	1	RAM, AMP STYLE, SIDE FEED			44
-	1	SCR, BHSC, RoHS (M8 X 25)			41
-	1	DISC, NUMBERED FA WIRE ADJUSTMENT			40
-	1	APPLICATOR SHIM PACK			39
-	1	RAM WASHER, PRECISION			38
△6	1	FA HEAD, ATLANTIC STYLE			37
-	1	BOLT, ADJUSTMENT			35
-	1	SUPPORT, TERMINAL			34
-	2	SCR, BHSC, RoHS (M4 X 20)			33
-	1	HEX HEAD, FLANGED, M5 X 8mm LONG			32
-	1	SPACER, STRIP GUIDE			30
-	1	ASSEMBLY, STRIP GUIDE			29
-	1	SPACER, CRIMPER			28
-	1	STRIP GUIDE			24
-	1	SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	2	WASHER, FLAT, REG M4			20
△1	1	STRIPPER, SIDE FEED			19
-	1	INSERT, SHEAR			13
-	1	SPRING, COMPRESSION			12
-	1	STOP, SHEAR			11
△1	1	SHEAR HOLDER, FRONT			10
△1	1	FLOATING SHEAR, FRONT			9
1	1	ANVIL, COMBINATION			8
-	-	-			6
-	1	DEPRESSOR, SHEAR			5
-	1	BLOCK, CRIMPER SPACER			4
△1	1	CRIMPER, INSULATION O			3
-	1	SPACER, CRIMPER			2
△1	1	CRIMPER, WIRE PREMIUM			1

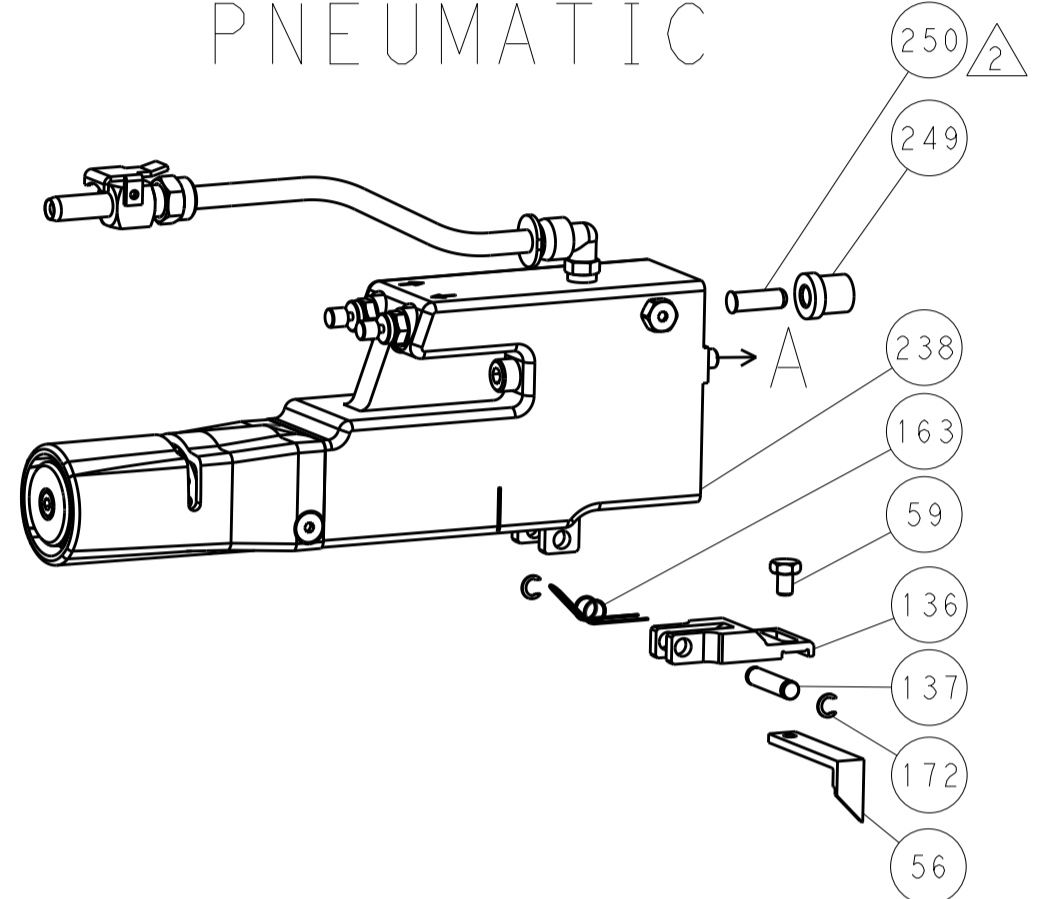
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mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	02DEC2014		
		3 PLC ±	4 PLC ±	APVD	02DEC2014	NAME Ocean Side Feed Applicator	
MATERIAL		FINISH	WEIGHT	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
-		-	-	A1	00779	©=2266547	-
Customer Accessible Production Drawing				SCALE	1:2	SHEET	1 of 4

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

### FEED TYPE MECHANICAL



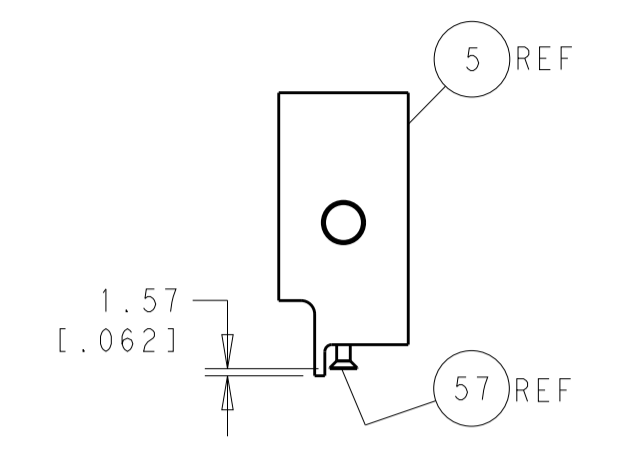
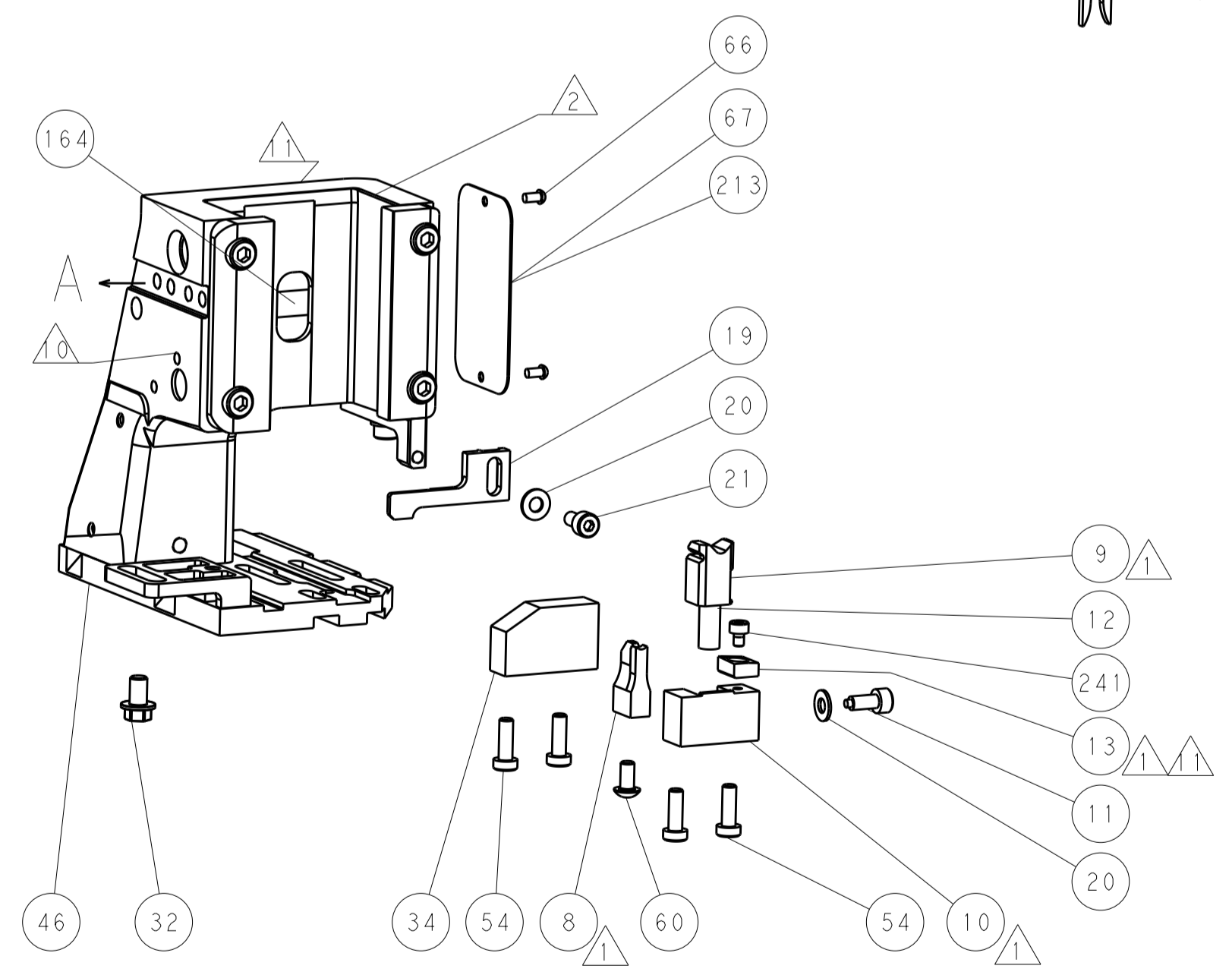
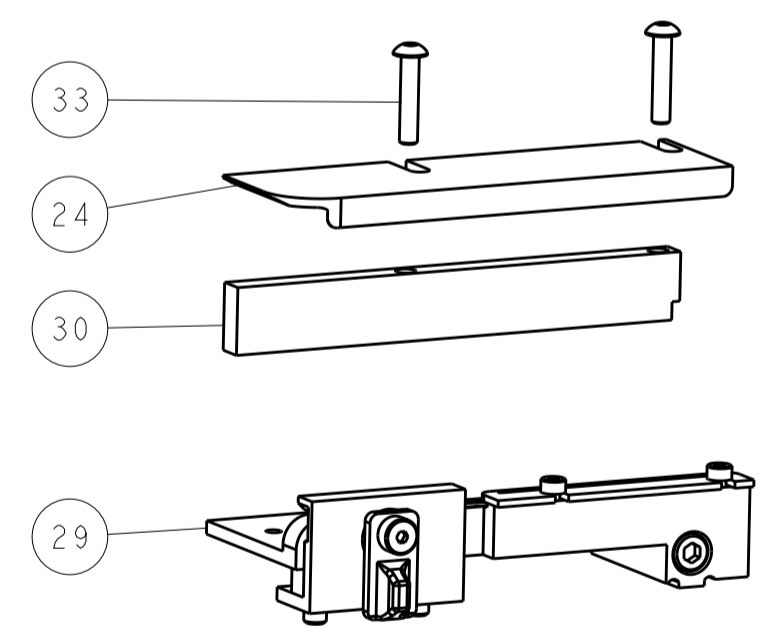
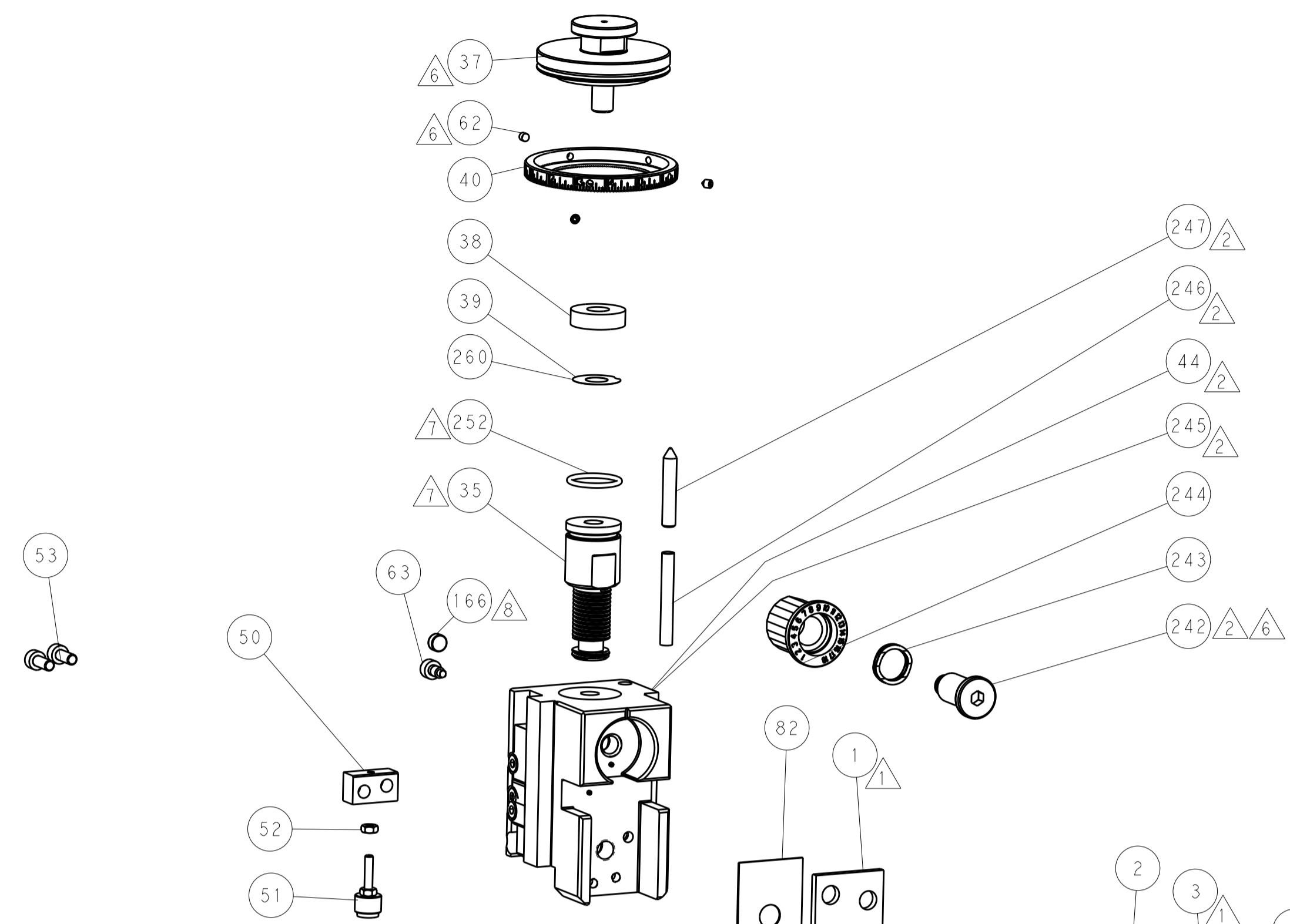
### PNEUMATIC



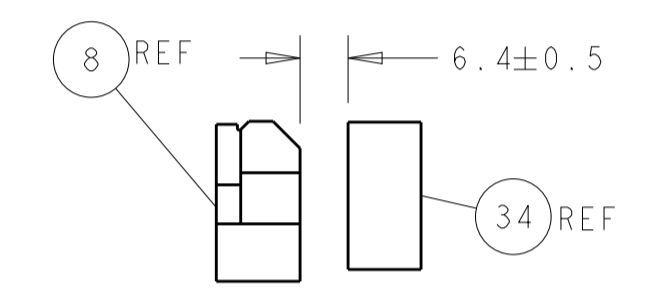
### SERVO LATCH PLATE



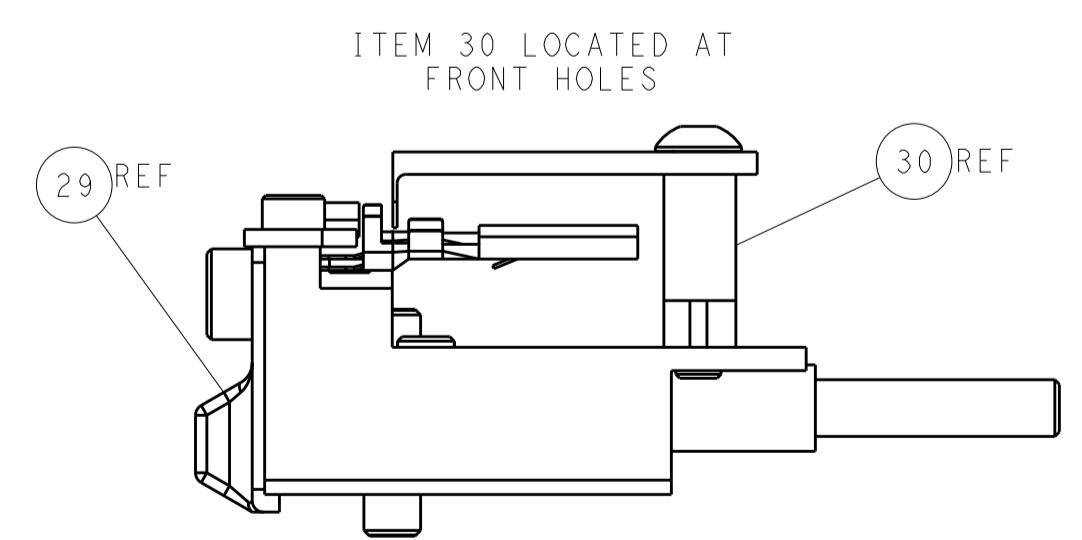
### CAM POSITIONS



SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J.HOU 02DEC2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:	FINISH:	WEIGHT:		A1 00779 ©=2266547		RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2 OF 4	REV B	

Table with columns: PACIFIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

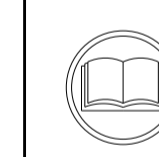
Table titled 'APPLICATOR DATA' with columns: CRIMP SIZE TYPE, WIRE SIZE, INSUL SIZE.

Table titled 'TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION' with columns for wire length, diameter, application, and terminals applied.

Table titled 'TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION' for a different terminal type, including wire length and diameter.

Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.



- 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.

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

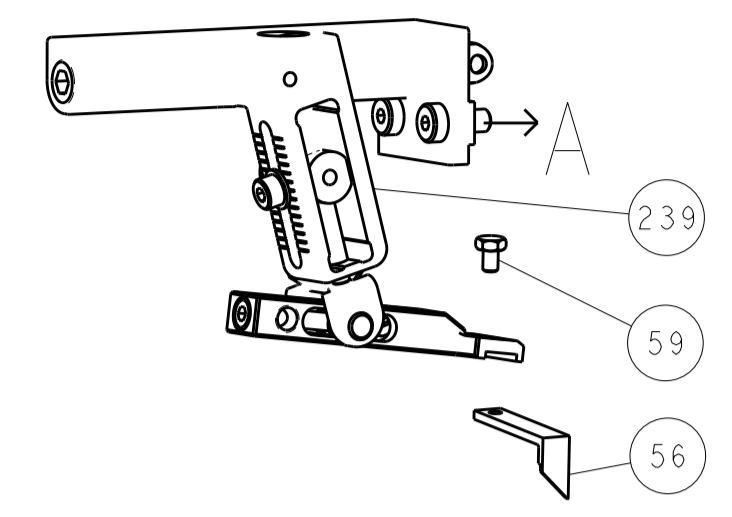
Table with columns: SET UP GAUGE, LOC, DIST, REVISIONS, DATE, DWN, APVD.

Large table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Contains a list of parts and their specifications.

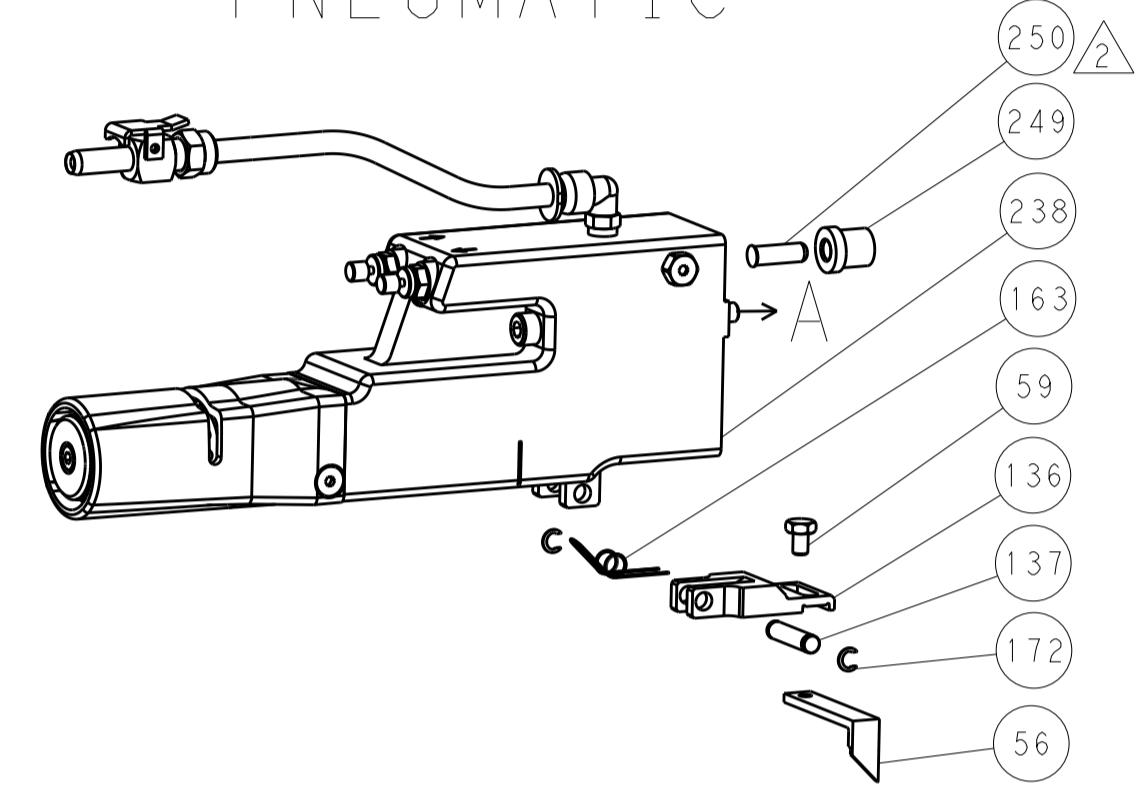
Table with columns: DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE, SHEET, OF, REV.

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

# FEED TYPE MECHANICAL



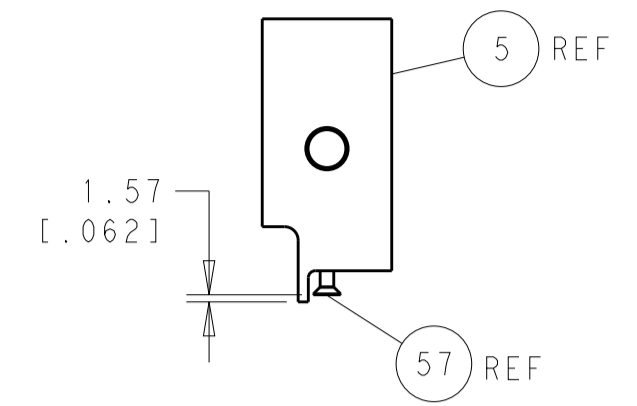
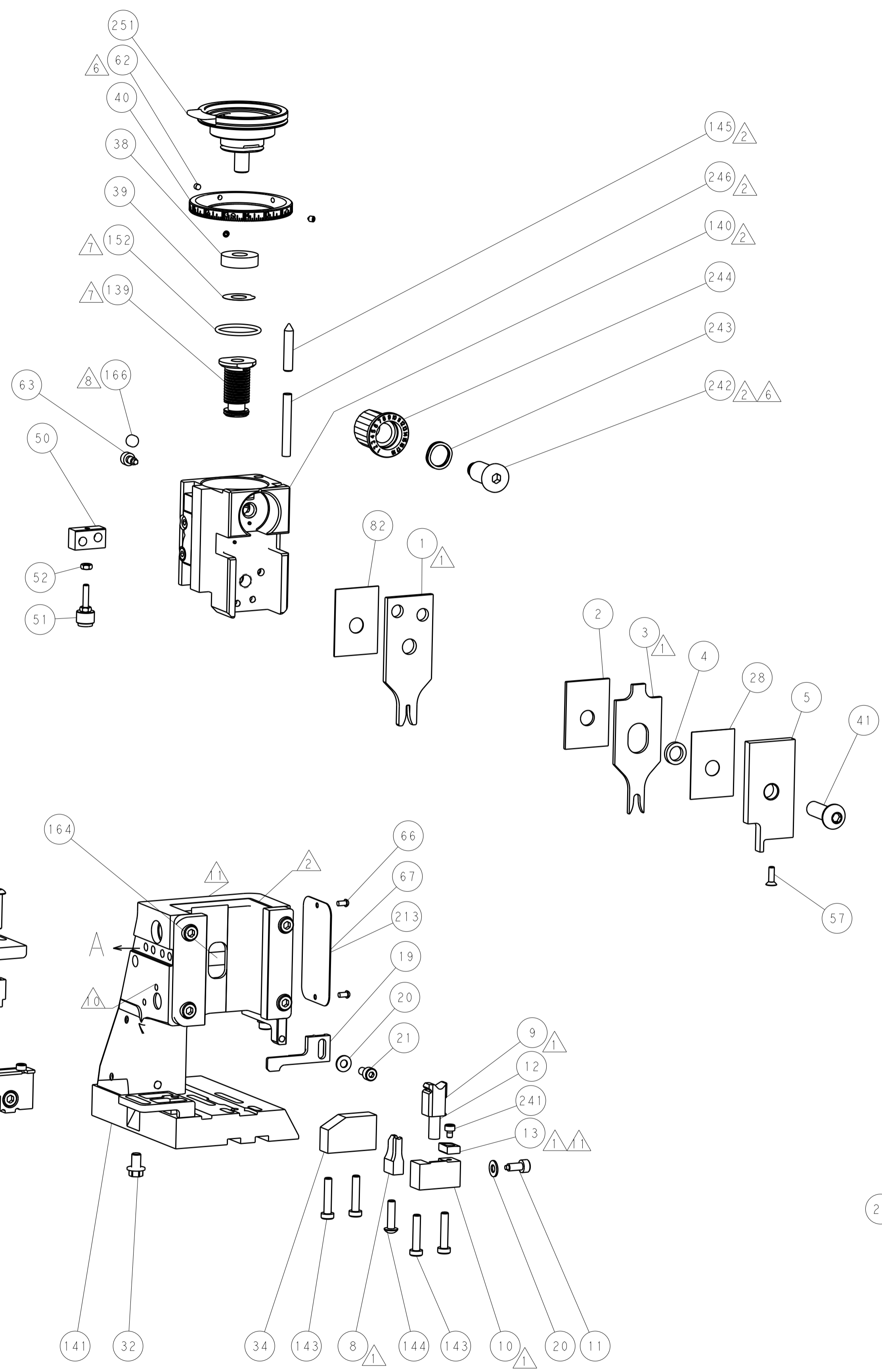
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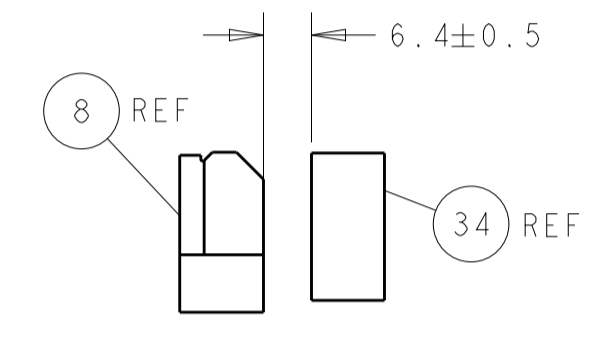
# SERVO LATCH PLATE



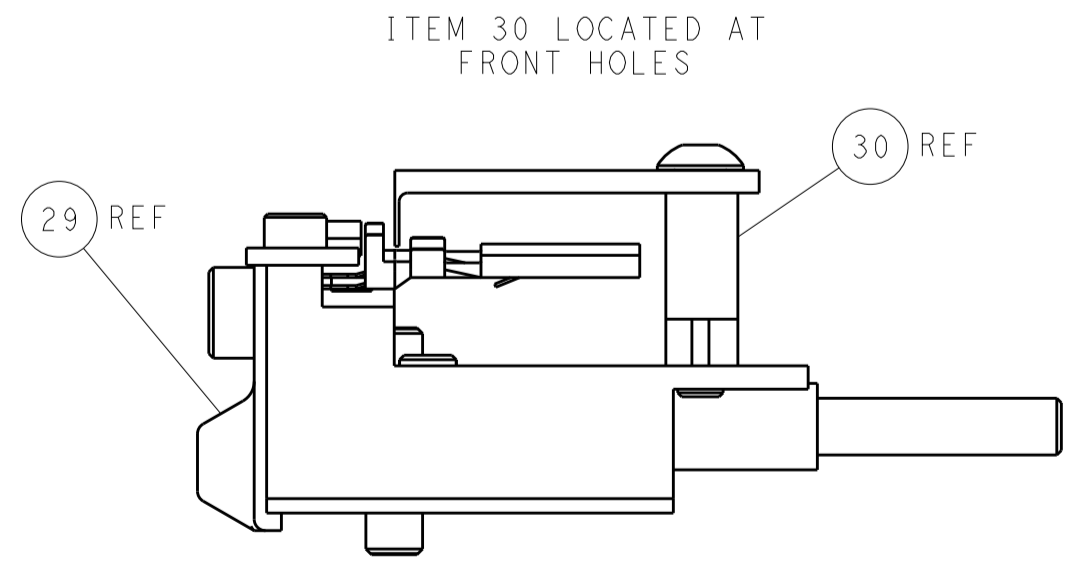
# CAM POSITIONS



SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: J.HOU 02DEC2014		CHK: Y.YIN 02DEC2014		APVD: H.GUO 02DEC2014		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	MATERIAL:		SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2266547
FINISH:		RESTRICTED TO:		WEIGHT:		SCALE: 1:2		SHEET: 4		REV: B	