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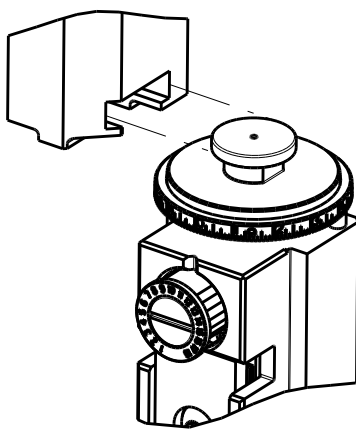
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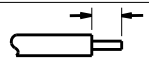
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2266131-1	A	FINE CRIMP HEIGHT ADJUST
	2266131-2	A	FINE CRIMP HEIGHT ADJUST
	2266131-5	A	FINE CRIMP HEIGHT ADJUST
	2266131-6	A	NON-CRIMP HEIGHT ADJUST
	2266131-7	A	FINE CRIMP HEIGHT ADJUST
	7-2266131-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.20 mm [.126]	F
INSUL	4.10 mm [.161]	OV

APPLICATOR INSTRUCTIONS
408-10389



TERMINAL DATA: FCI TERMINAL		CI__CRIMP-SPEC-SRC-STR
TERMINAL NAME: SICMA2 2.8 X 0.8 MALE		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
4.40-4.42 mm [.173-.174 IN]		Ø3.20-3.90 mm [.126-.154 IN]
TERMINAL APPLICATION SPECIFICATION		
TERMINALS APPLIED		
TE TERMINAL	FCI TERMINAL	TE TERMINAL
1949190-1	SICMA2 2.8 X 0.8 MALE	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
5.00mm2		2.65+/-0.05 [.104+/- .002]		4.7
4.00mm2		2.34+/-0.05 [.092+/- .002]		8.0
3.00mm2		2.10+/-0.05 [.083+/- .002]		10.5



- 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: 8-2266131-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266131-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266131-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266131-6
- 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 ITEMS 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 242.
- 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 3.15.

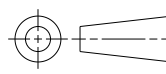
APPLICATOR STYLE CONVERSION CHART									
CONVERT TO		PART NUMBERS REQUIRED							
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1			
SERVO LATCH PLATE	2119951-1	-	8-2266131-5	1901094-3	1-1752354-7	2168400-6 (QUANTITY 2)			
SMART APPLICATOR	2161326-1	-	8-2266131-4	-	-	-			
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-			
SERVO LATCH PLATE	2119951-1	-	8-2266131-5	1901094-3	1-1752354-7	2168400-6 (QUANTITY 2)			
SMART APPLICATOR	2161326-1	-	8-2266131-4	-	-	-			
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-			
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1			
-	-	-	-	-	-	-			
-	-	-	-	-	-	-			
-	-	-	-	-	-	-			
-	-	-	-	-	-	-			

SET UP GAUGE 2119599-1	LOC	DIST	REVISIONS							
	A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
				A	RELEASED			26DEC2013	KS	TE

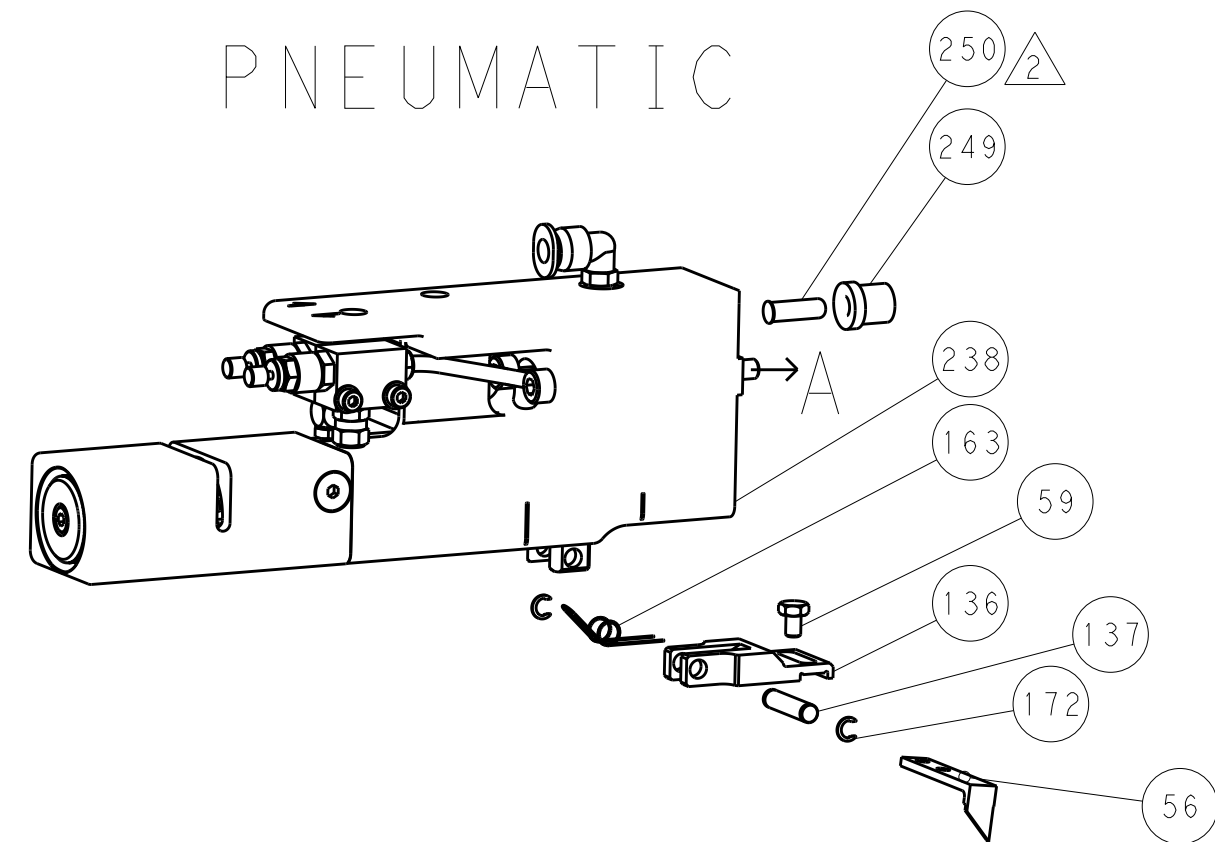
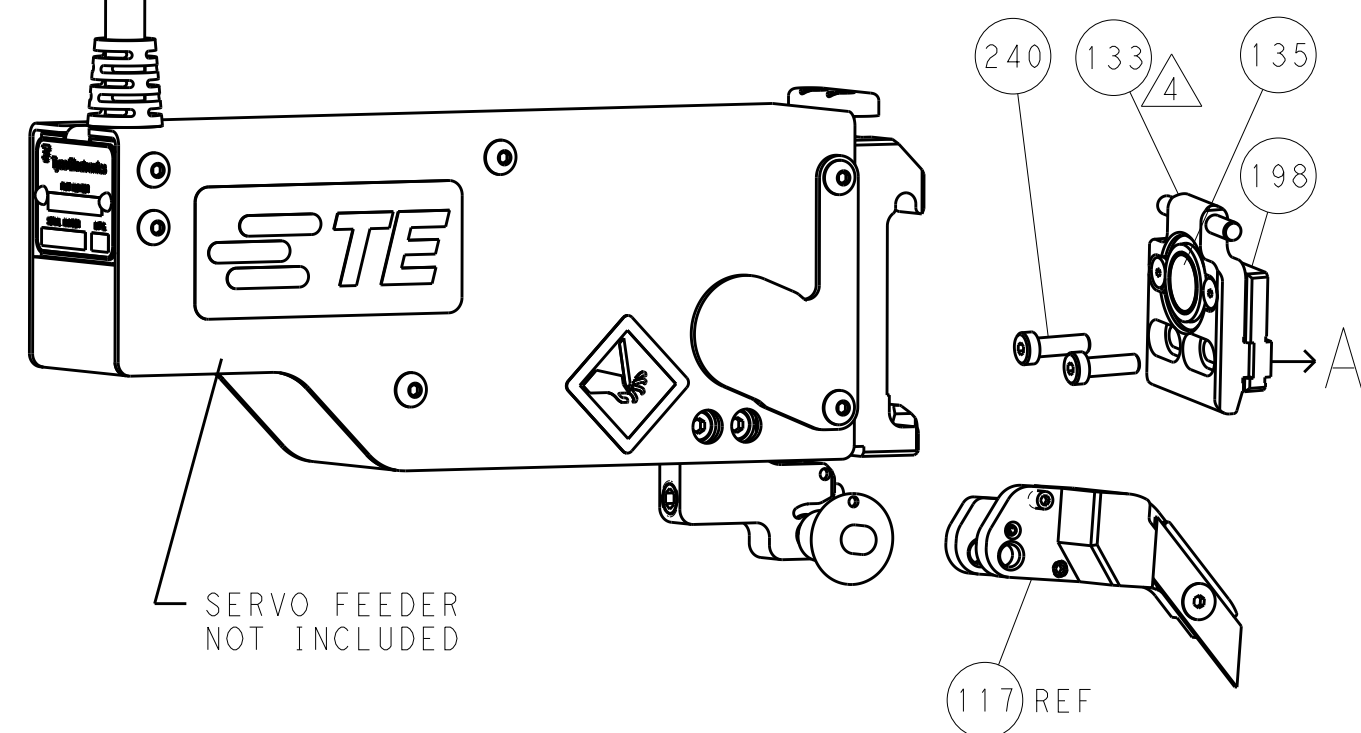
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	22878-8	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
-	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	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	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	2119644-3	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	1752356-1	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	1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-6	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	3-1803054-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1-2119780-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	1-1633964-4	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	1	1	1	2-1633860-8	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

-	-	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

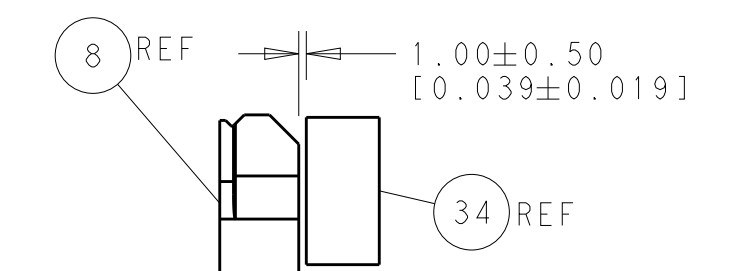
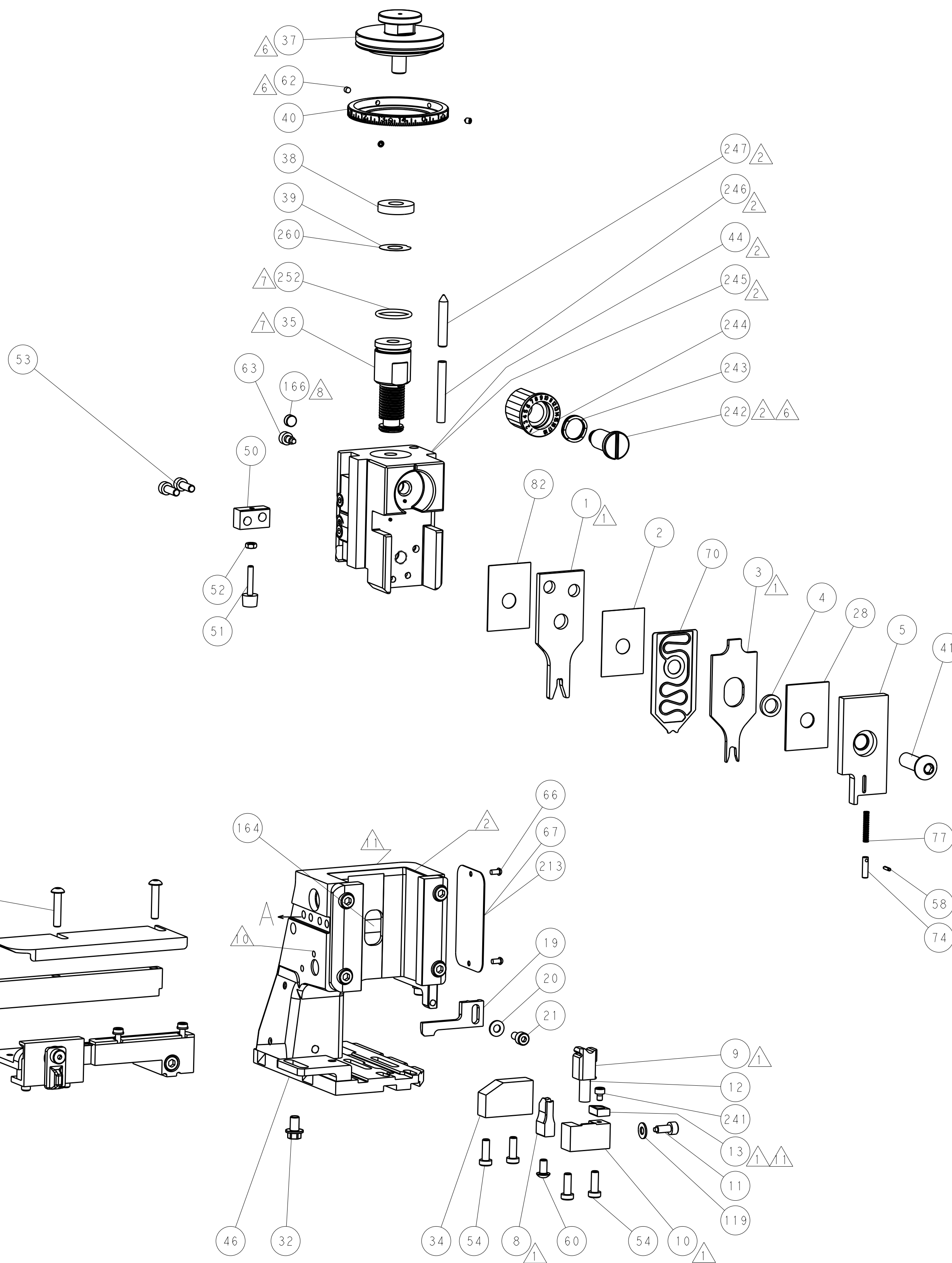
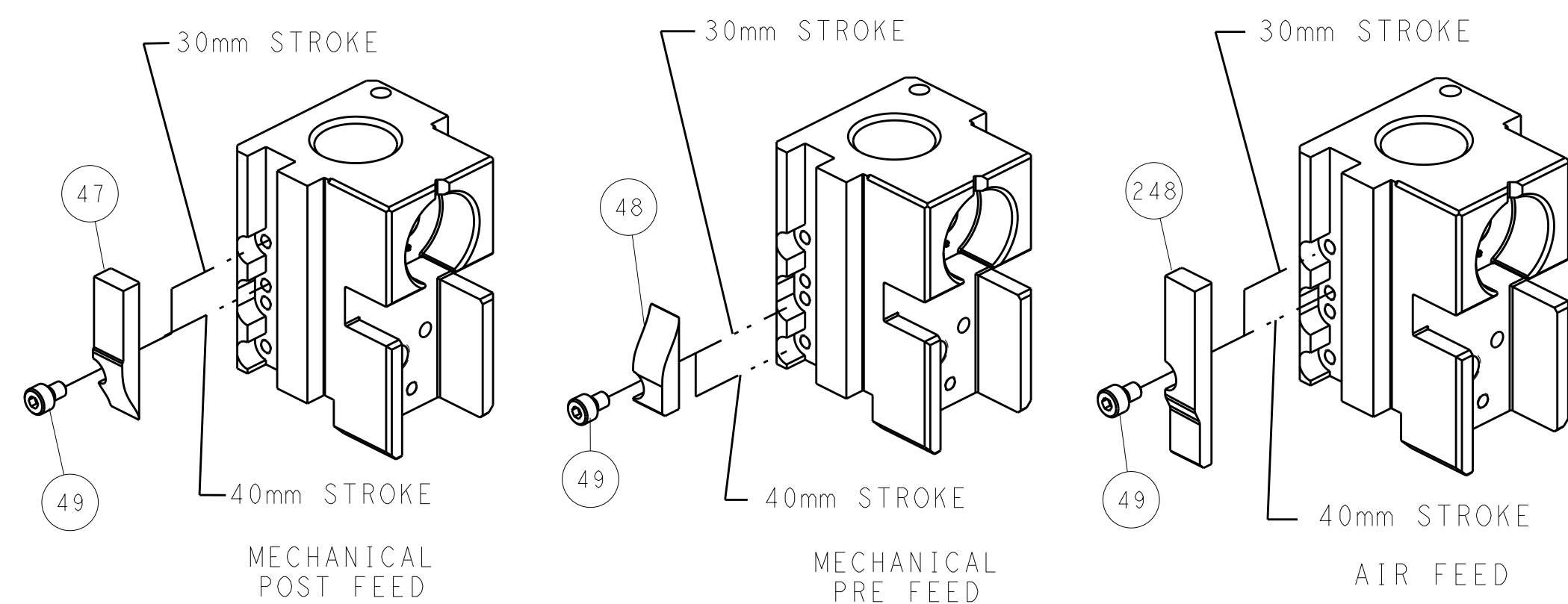
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS IS SUBJECT TO CHANGE AND TO BE USED FOR THE LATEST REVISIONS. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST REVISIONS. THIS IS SUBJECT TO CHANGE AND TO BE USED FOR THE LATEST REVISIONS.				OWN G. STAKEM	290CT2013	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:				CHK G. BAILEY	290CT2013		
mm				APVD T. ELBIN	290CT2013	NAME Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE A1	
				APPLICATION SPEC		CAGE CODE 00779	
MATERIAL				WEIGHT		DRAWING NO C=2266131	
				FINISH		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2	
				SHEET 1		REV A	

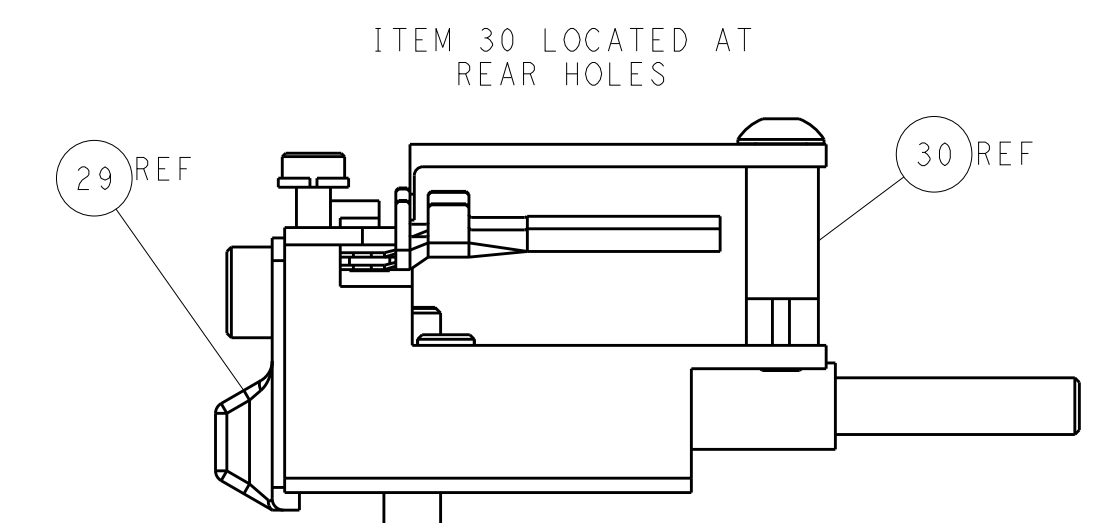
PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

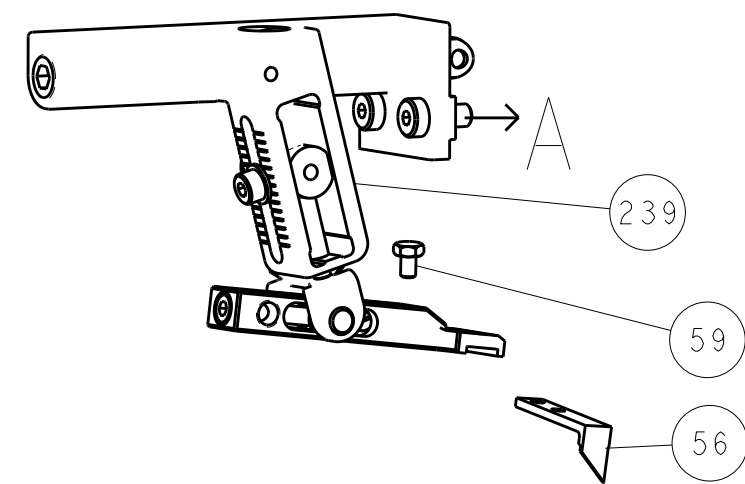
ATLANTIC VERSION

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

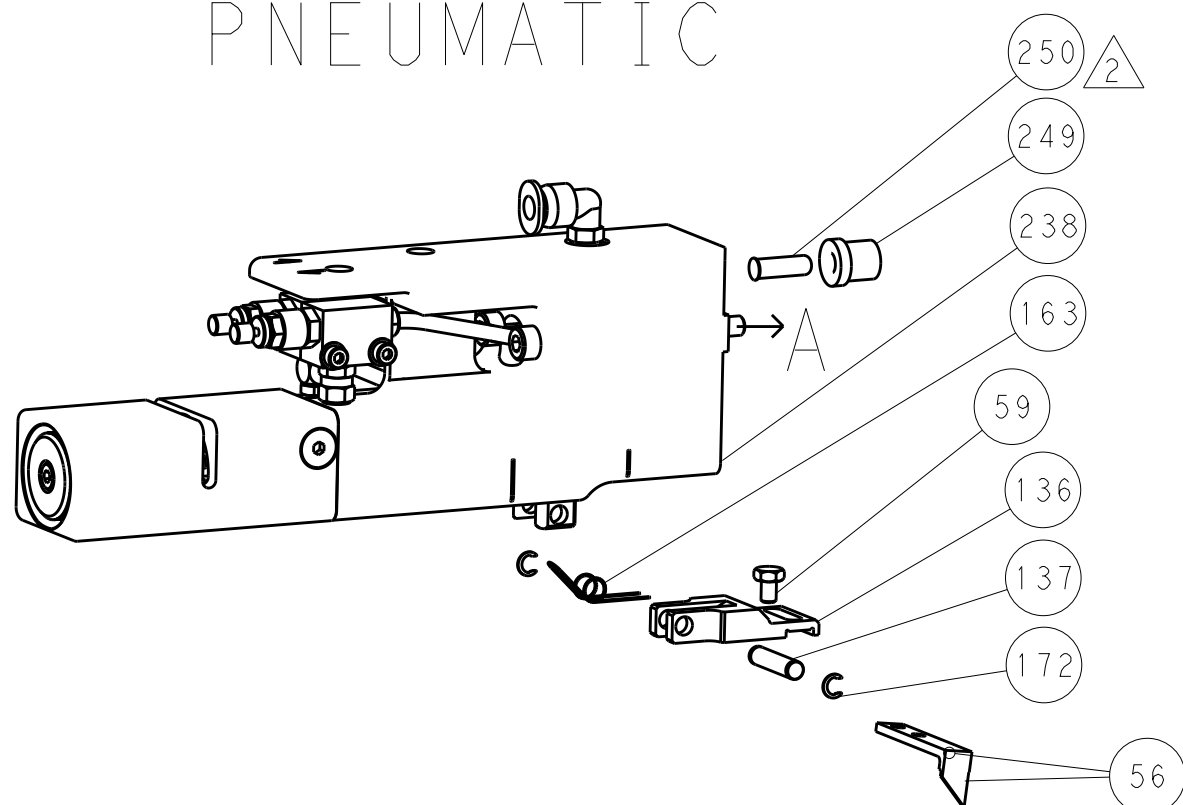
THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO ENGINEERING CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLS AND ENGINEERING ORGANIZATION SHOULD BE ADVISED FOR THE LATEST REVISION		DWN 290C12013 STAKEM CHK 290C12013 G. BAILEY APVD 290C12013 T. FLIRIN		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC WEIGHT	
MATERIAL FINISH		SIZE A CAGE CODE 00779 DRAWING NO C=2266131		RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV A	

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

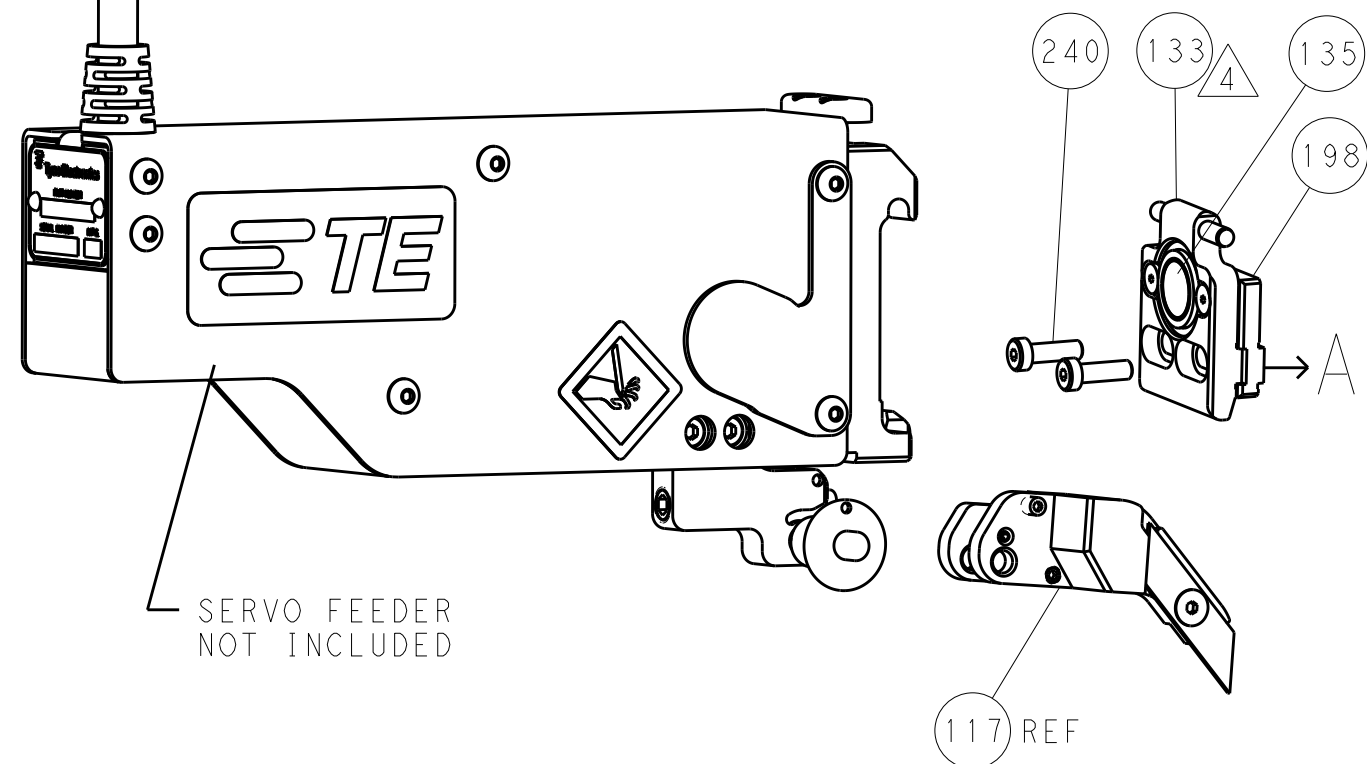
FEED TYPE MECHANICAL



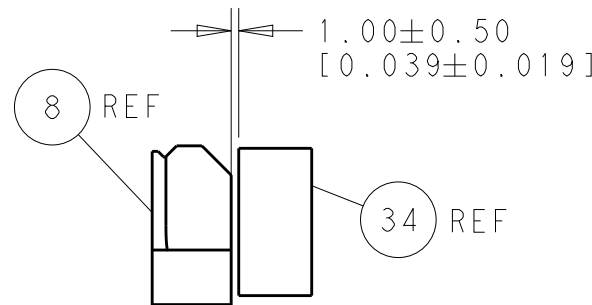
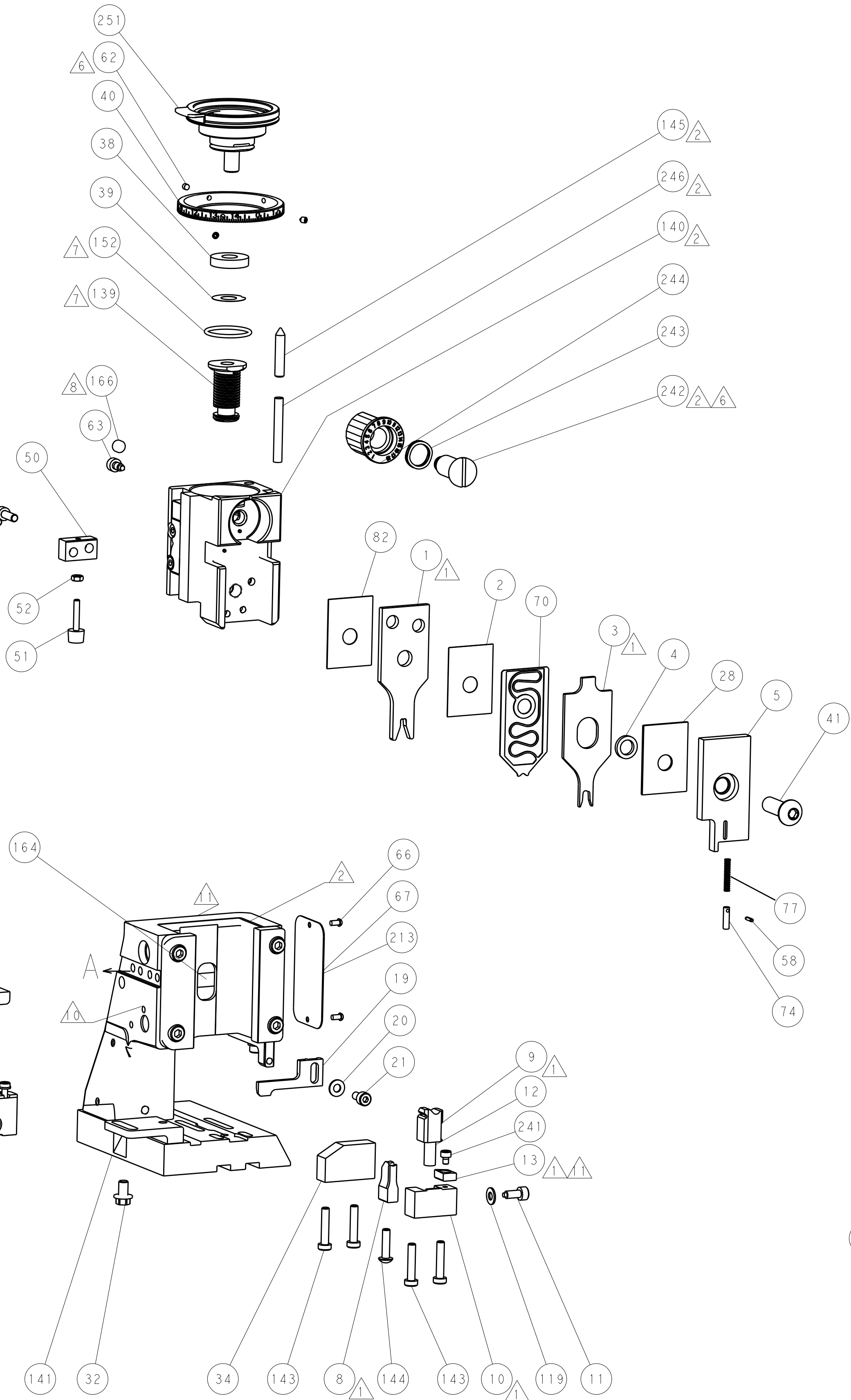
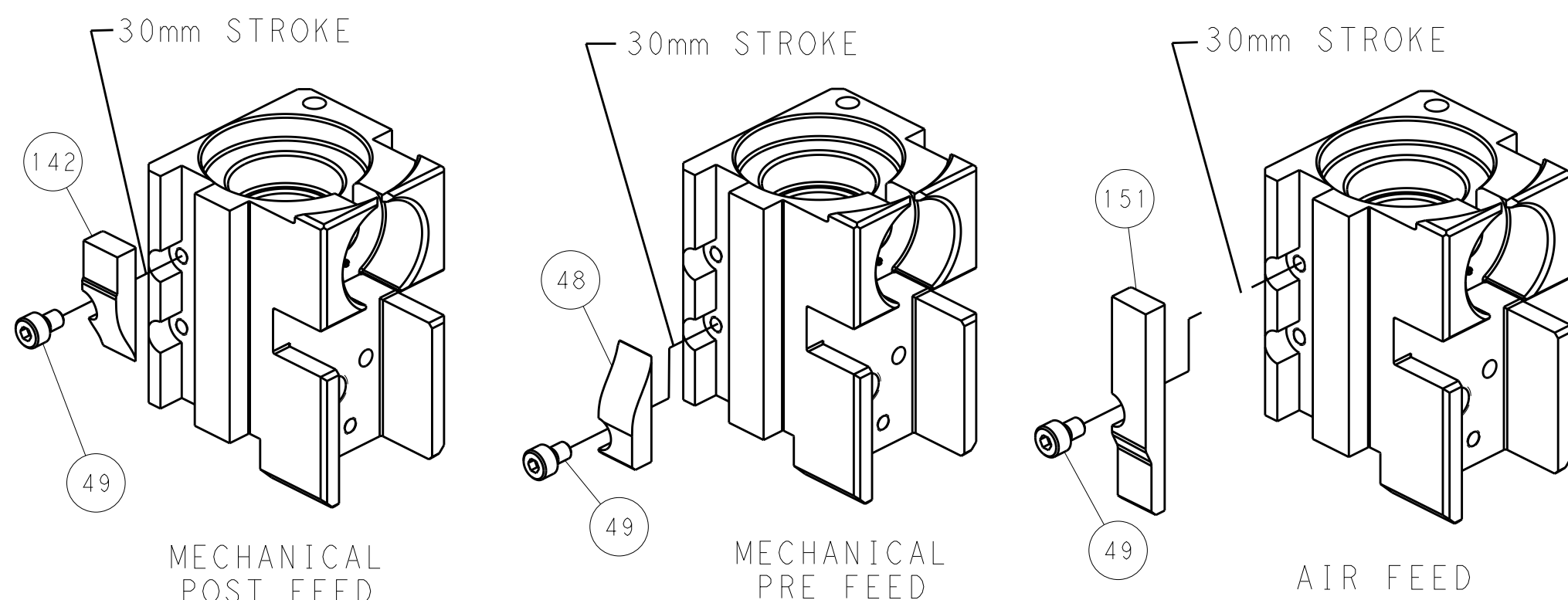
PNEUMATIC



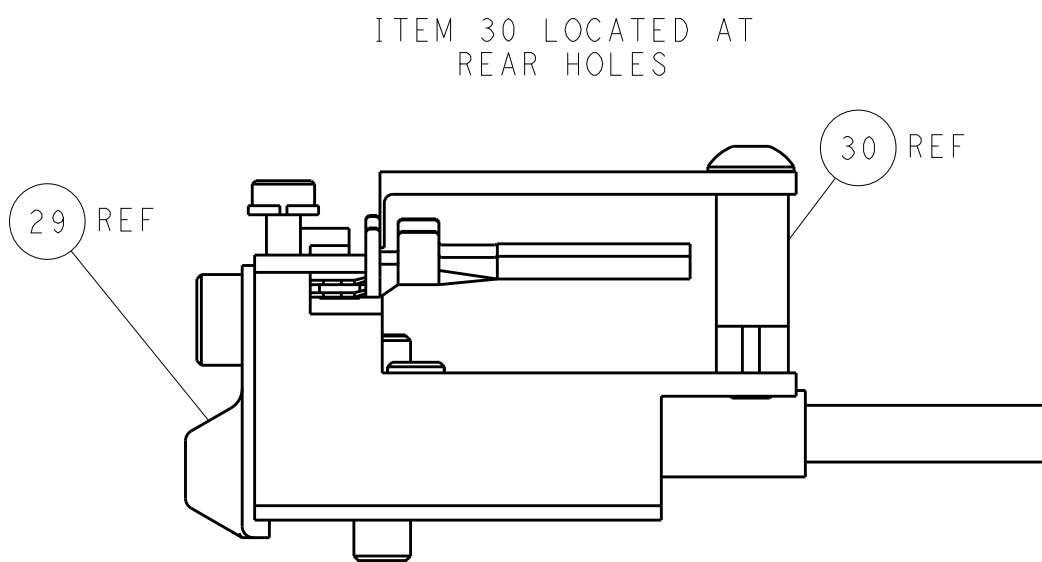
SERVO LATCH PLATE



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		29OCT2013		STE		TE Connectivity	
mm		0 PLC ±0.5		CHK		29OCT2013		Harrisburg, PA 17105-3608			
		1 PLC ±0.13		APVD		29OCT2013		NAME		Ocean Side Feed	
		2 PLC ±0.013						PRODUCT SPEC			
		3 PLC ±0.001						APPLICATION SPEC			
		4 PLC ±0.0001						WEIGHT			
MATERIAL		FINISH						SIZE		RESTRICTED TO	
								A 00779 C=2266131			
								Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV A	