

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2266083-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	
	2266083-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119951-1	-	8-2266083-5	1901094-3	-	2168400-6 (QUANTITY 2)	
	2266083-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2161326-1	-	8-2266083-4	-	-	-	
	2266083-7	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	
	7-2266083-7	A	CRIMP TOOLING KIT	NONE	-	-	-	-	-	-	
						2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
						-	-	-	-	-	-

**APPLICATOR DATA**

CRIMP WIRE	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.00 mm [.118]	F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION  
 TERMINAL NAME: FLACHSTECKHULSE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
	Ø1.40-2.15 mm [.055-.085 IN]

TERMINAL APPLICATION SPECIFICATION: 26653 Rev 3

TERMINALS APPLIED

TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113393-1	26653.213.011	2113393-2	26653.213.004
2113393-3	26653.123.211		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	FLRY WIRE STRIP LENGTH
1 mm2 FLRY	1.30 +/- 0.05 [.051 +/- .002]	5.6	4.10-4.90 mm [.161-.193 IN]
0.75 mm2 FLRY	1.20 +/- 0.05 [.047 +/- .002]	6.8	4.60-5.40 mm [.181-.213 IN]
0.5 mm2 FLRY	1.15 +/- 0.05 [.045 +/- .002]	7.3	4.60-5.40 mm [.181-.213 IN]

- 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. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266083-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266083-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266083-6
- ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 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.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.50.
- SEE CHART FOR FLRY WIRE STRIP LENGTHS.

**\*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.

QTY	PART NO	DESCRIPTION	ITEM NO				
- 2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
- 1	1	1	1	1633782-3	FENCE	267	
- 1	-	1	-	2119957-2	APPLICATOR SHIM PACK	260	
- 1	1	1	1	1803078-3	SPACER, PRECISION	259	
- 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	2119798-1	DETENT PIN	247	
-77	-7	-6	-5	-2	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	DIST	REVISIONS			
A	66	DATE	BY	CHK	APVD
		24JAN2014	RK	GB	

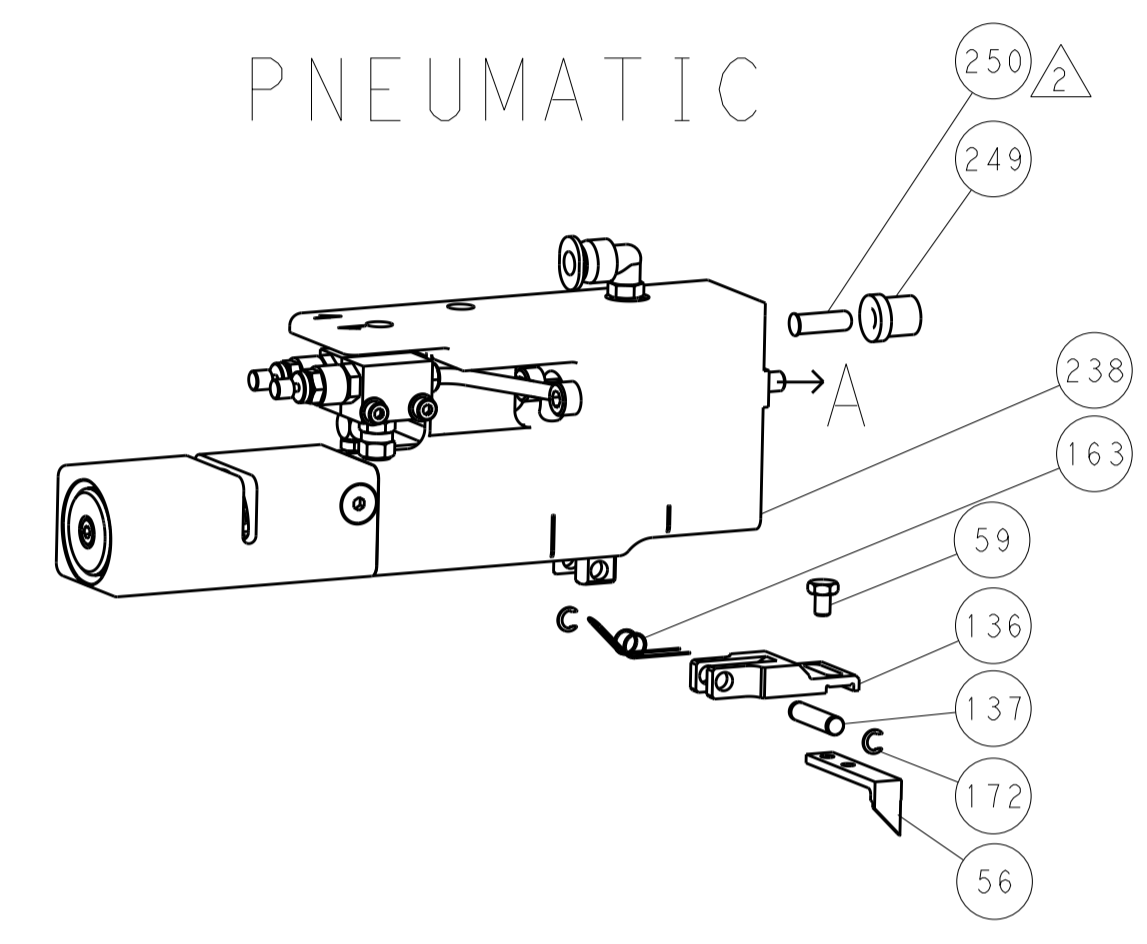
- 1	- 1	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	- 1	-	-	2161314-1	RAM, STEPPED, ATLANTIC, SF, NON-ADJ	245	
- 1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
- 1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
- 1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
- 1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	- 2	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240	
-	-	-	- 1	2063440-1	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	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	135	
-	- 1	1	-	1633743-1	SERVO FEED LATCH ASM	133	
- 1	1	1	1	1-22281-8	SPRING, COMPRESSION	121	
- 1	1	1	1	2-455888-1	SPACER, CRIMPER	120	
- 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	2-690438-2	FRONT STRIP GUIDE	96	
- 2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
- 1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
- 1	1	1	1	455888-9	SPACER, CRIMPER	82	
- 1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
- 1	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
- 1	1	1	1	2119943-1	WASHER, SPACER	69	
- 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	1338685-1	PAWL, FEED	56	
- 2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54	
-	-	-	- 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	2161311-1	RAM, STEPPED, AMP STYLE, SIDE FEED	44	
- 1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	2119644-1	RAM WASHER, PRECISION	38	
- 1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
- 1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35	
- 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	1320908-6	SPACER, STRIP GUIDE	30	
- 1	1	1	1	1-1901086-9	PLATE, STRIP GUIDE	29	
- 1	1	1	1	455888-3	SPACER, CRIMPER	28	
- 2	2	2	2	22281-8	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	1320928-2	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	1-356885-3	STOP, SHEAR	11	
- 1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
- 1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9	
1	1	1	1	1-1803057-7	ANVIL, COMBINATION	8	
-	-	-	-	-	-	7	
-	-	-	-	-	-	6	
- 1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
- 1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4	
1	1	1	1	2-1803016-5	CRIMPER, INSULATION F	3	
- 1	1	1	1	455888-4	SPACER, CRIMPER	2	
1	1	1	1	4-456406-1	CRIMPER, WIRE PREMIUM	1	
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	R. KNEPPER 02-Nov-13		TE Connectivity	
mm	mm	0 PLC ±.5	1 PLC ±0.13	CHK	G. BAILEY 02-Nov-13		Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD	M. CLIFFORD 02-Nov-13		NAME	
				PRODUCT SPEC		Ocean Side Feed		
				APPLICATION SPEC		Applicator		
				WEIGHT	A1 00779		SCALE 1:2 SHEET 1 of 4 REV A	
				Customer Accessible Production Drawing		Customer Accessible Production Drawing		

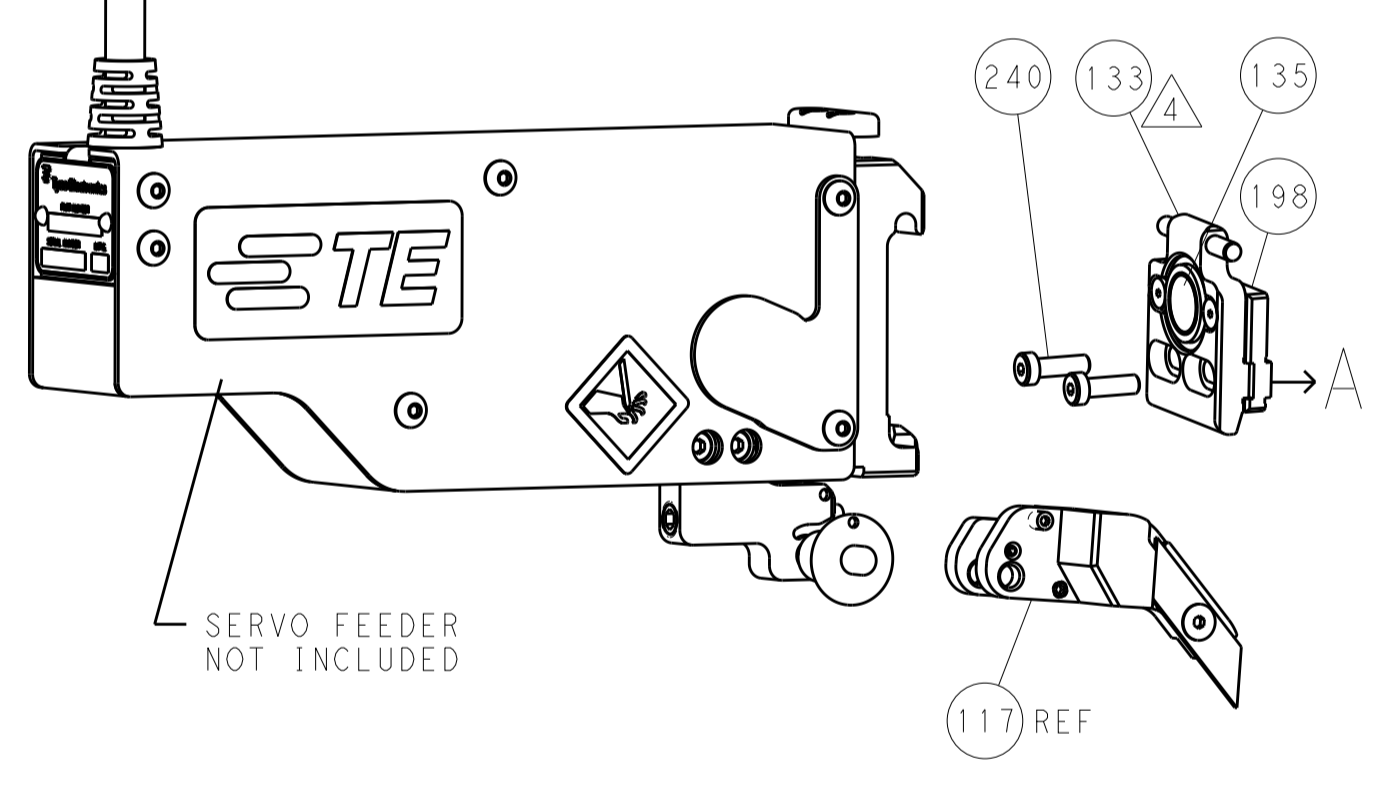
LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

### FEED TYPE

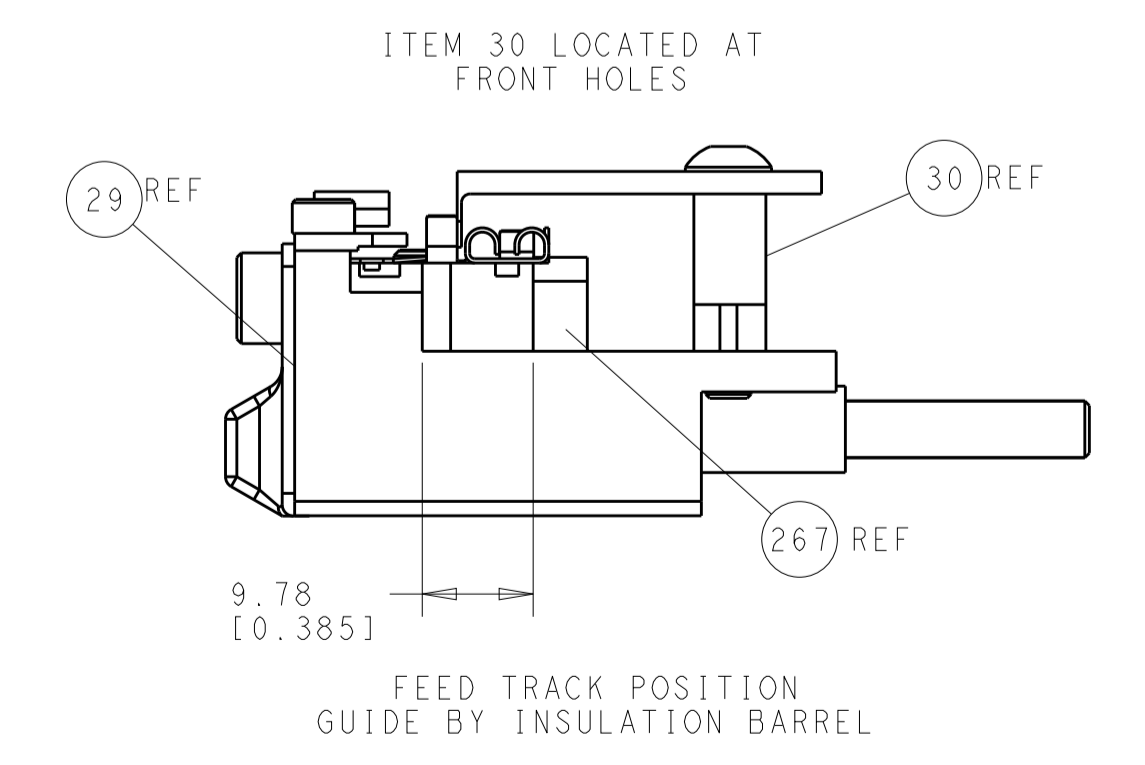
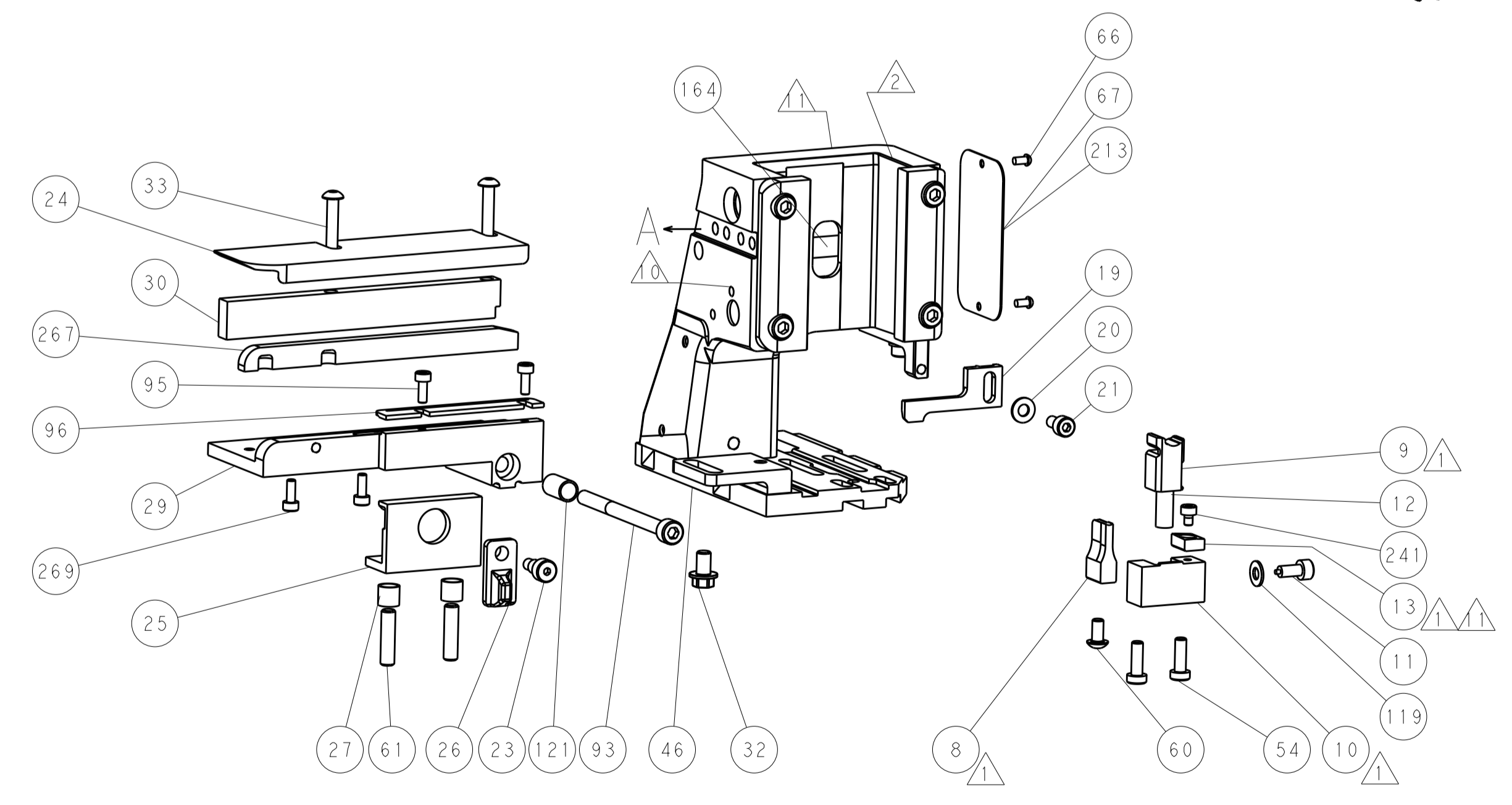
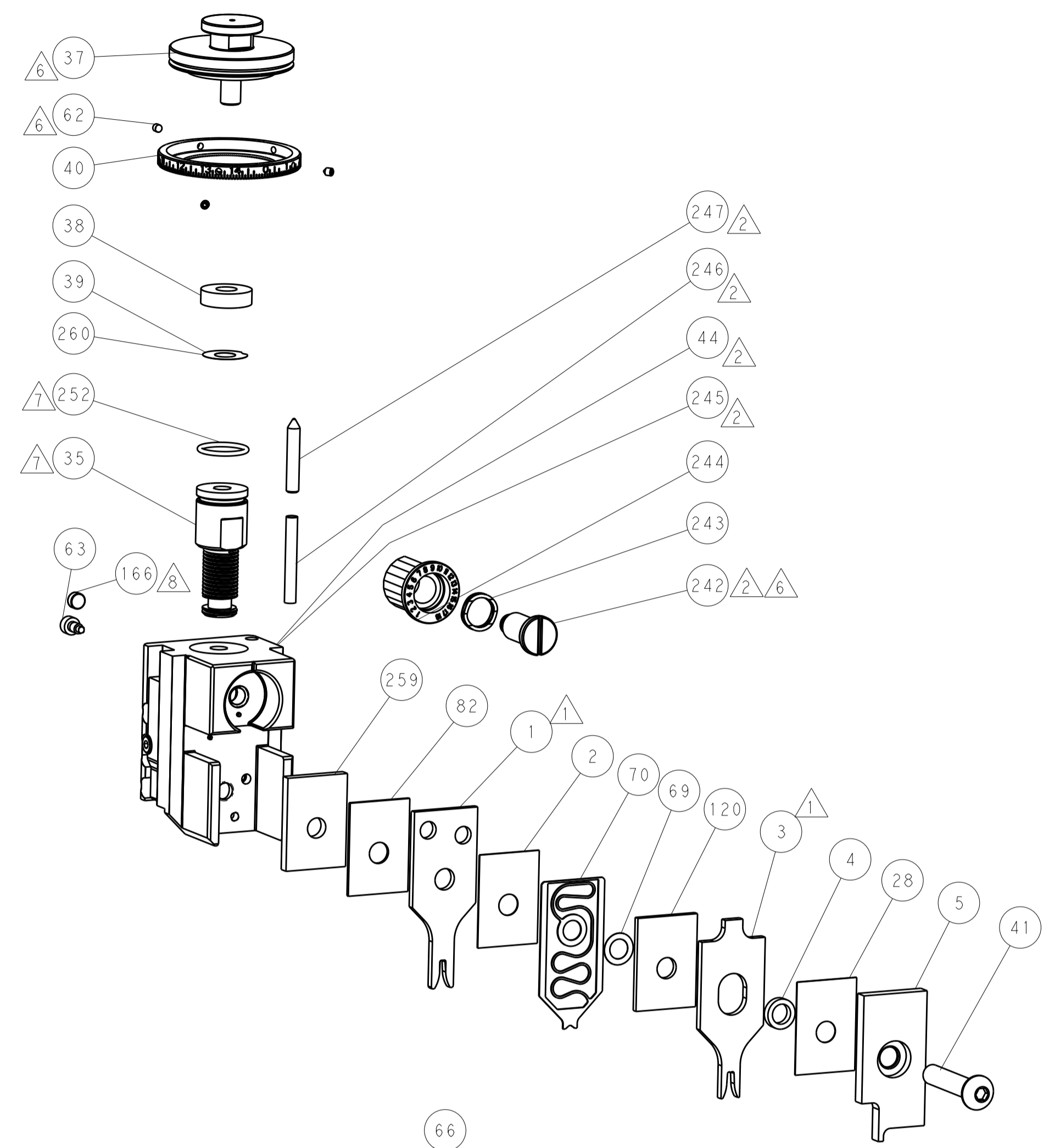
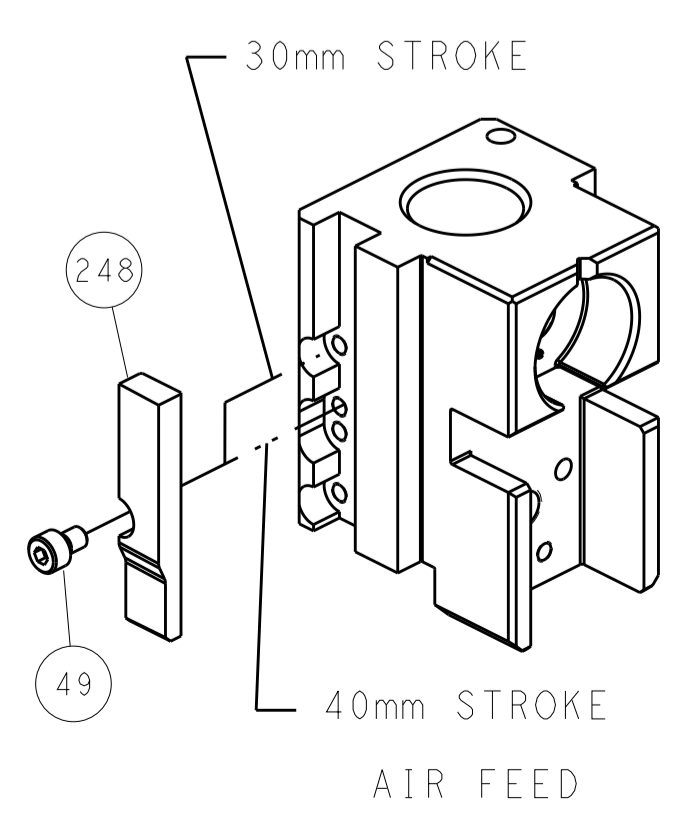
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITION



**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. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED BY THE DRAWING. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED.</small>		DWN: R. KNEPPER 02-Nov-13 CHK: G. BAILEY 02-Nov-13 APVD: M. CLIFFORD 02-Nov-13	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:	SCALE: 1:2 SHEET: 2 of 4 REV: A	RESTRICTED TO: A1 00779 ©=2266083 Customer Accessible Production Drawing

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

APPLICATOR DATA. Table with columns: CRIMP, SIZE, TYPE. Includes APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION. WIRE STRIP LENGTH. INSULATION DIAMETER RANGE. TERMINAL APPLICATION SPECIFICATION. TERMINALS APPLIED.

WIRE SIZE. CRIMP HEIGHT. CRIMP HEIGHT REFERENCE SETTING. FLY WIRE STRIP LENGTH. Table with columns for wire size and crimp specifications.

\*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 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...
5 ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED...
6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS...
7 GREASE THREADS, GROOVE AND O-RING...
8 MAGNET MUST BE ORIENTED CORRECTLY...
9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING...
10 TERMINAL PITCH NOT COMPATIBLE...
11 TO CONVERT THE APPLICATOR TO A NON-CARRIER...
12 SEE CHART FOR FLY WIRE STRIP LENGTHS.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various components like SCR, SKT HD CAP, FENCE, SPACER, etc.

LOC A DIST 66. REVISIONS table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD.

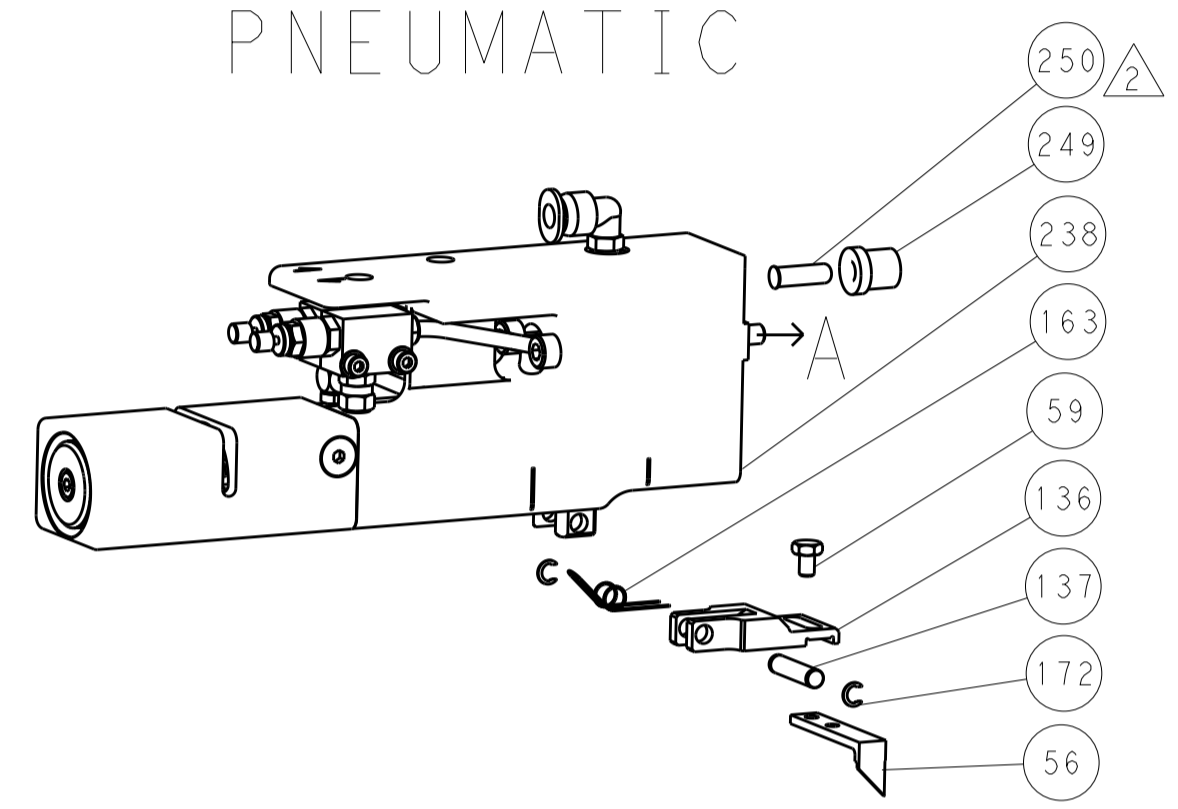
Main BOM table listing various components with columns: ITEM NO, PART NO, DESCRIPTION, ITEM NO. Lists items like CAM, SNAIL, INSULATION ADJUSTMENT, WASHER, WAVE SPRING, etc.

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

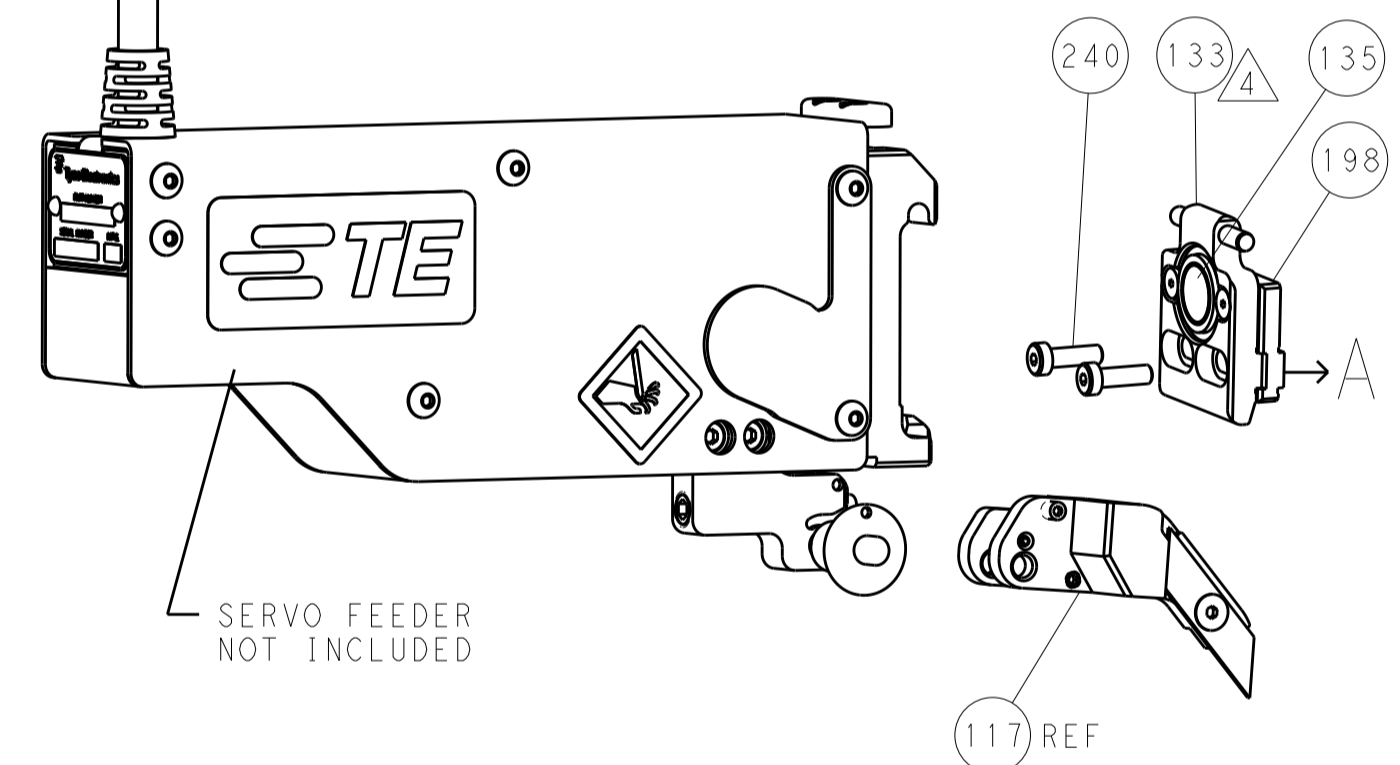
Technical drawing footer containing dimensions, tolerances, material, finish, weight, and manufacturer information (STE Connectivity).

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

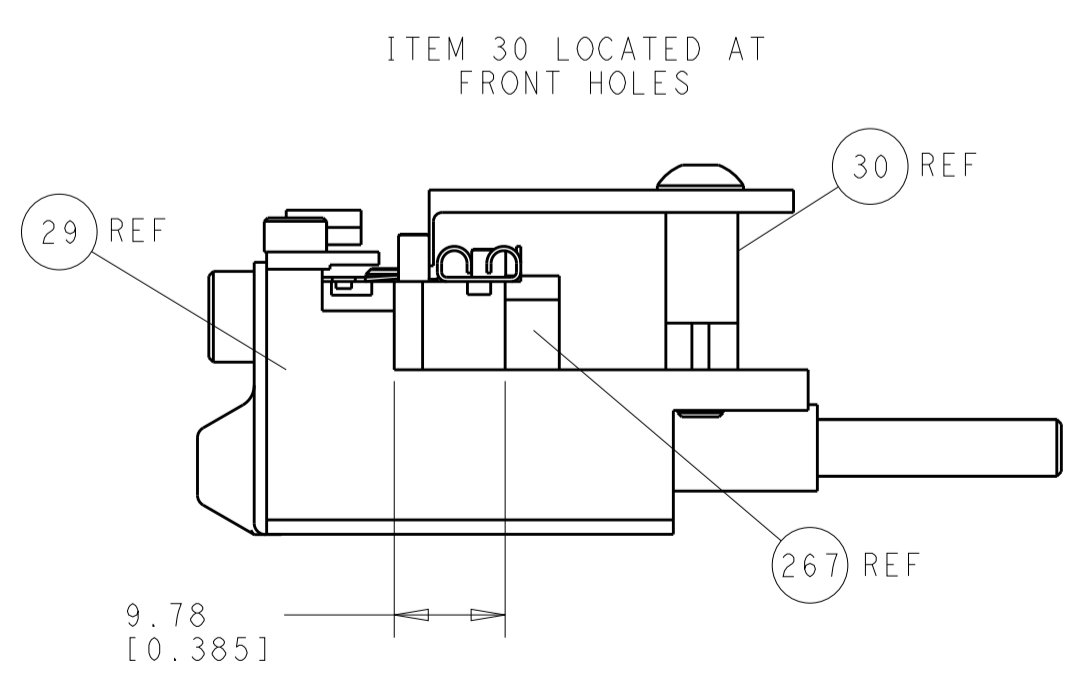
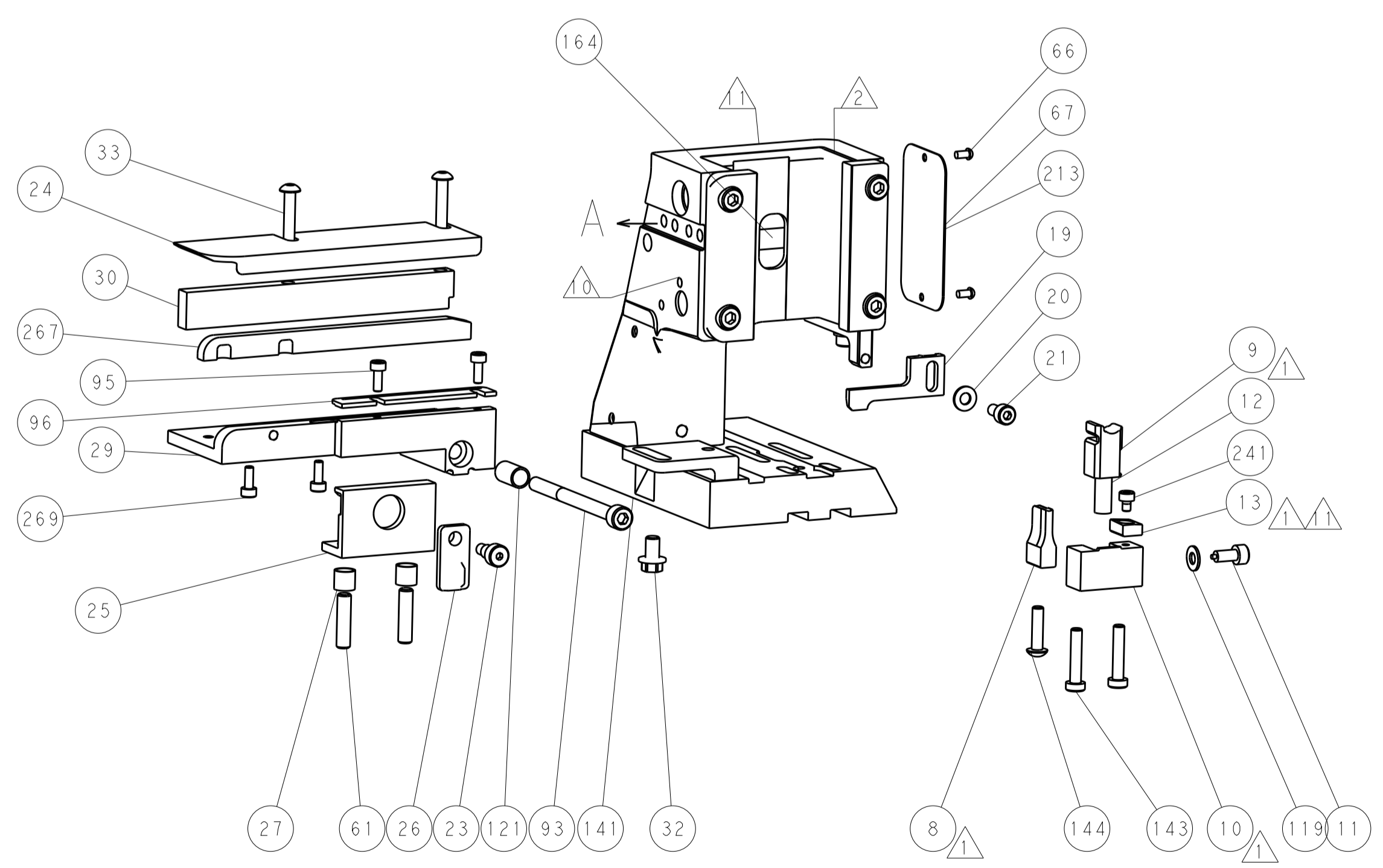
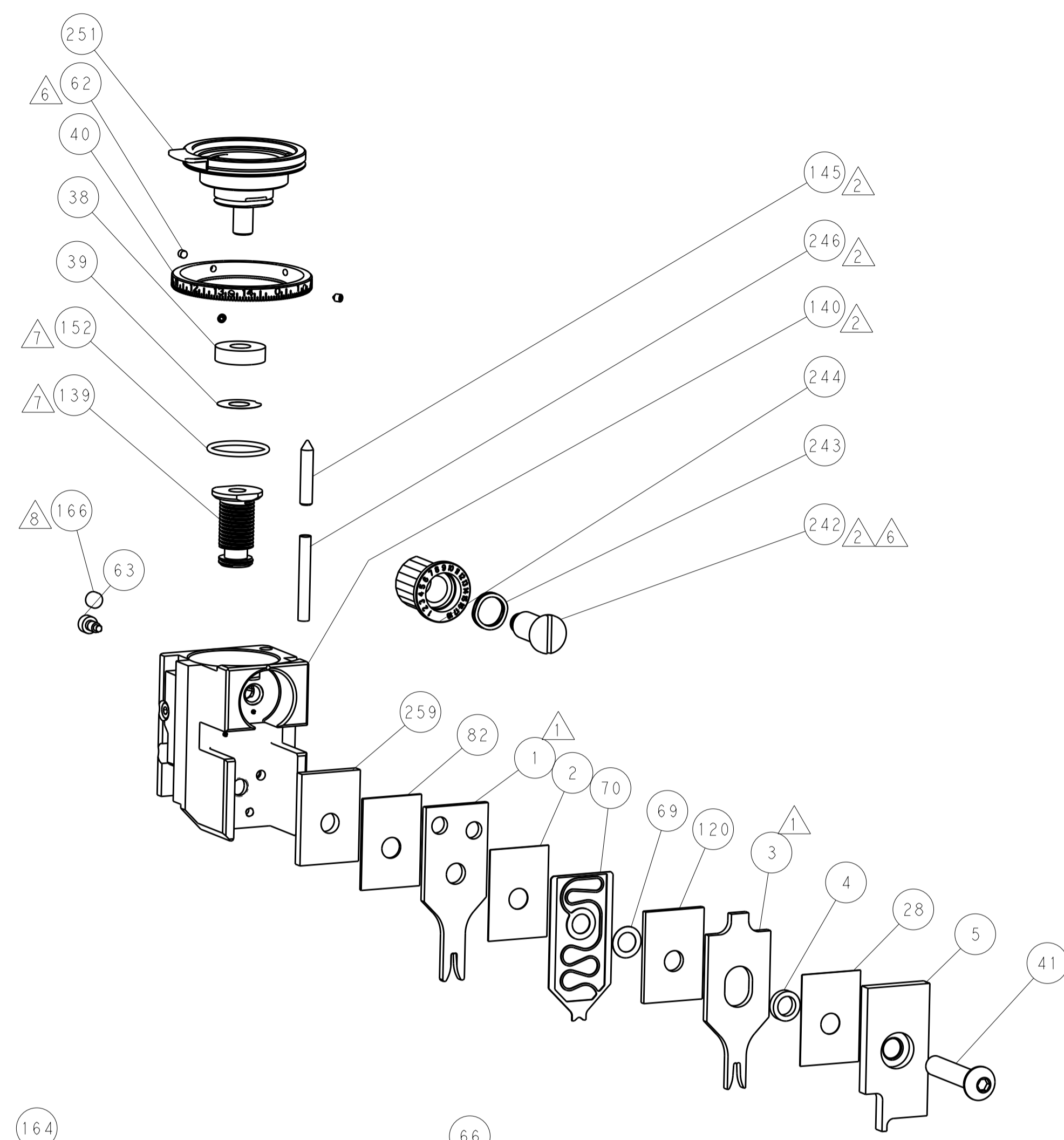
### FEED TYPE PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITION



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		DWN R. KNEPPER 02-Nov-13 CHK G. BAILEY 02-Nov-13 APVD M. CLIFFORD 02-Nov-13		NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266083	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 4 OF 4 REV A	