

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2266533-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266533-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266533-4	-	-	-
	2266533-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266533-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266533-4	-	-	-
	2266533-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	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	
2266533-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	-	-	-	-	-	-	-	
				-	-	-	-	-	-	-	
2266533-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266533-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.30 mm [.091]	OV

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-6.50 mm [.217-.256 IN]		1.30 mm MAX	
TERMINAL APPLICATION SPECIFICATION	6C-5522-147 Rev COH	-	-
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113598-1	320100340		
2113598-2	7703497732		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm <sup>2</sup>	1.25+/-0.05 [.049+/- .002]	6.3

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266533-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266533-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266533-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266533-6
- 5. 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 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.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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 4.55.

**\*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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260

**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	P	LTN	DESCRIPTION	DATE	OWN	APVD
			A		RELEASED	01DEC2014	MR	TE

	-	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
	-	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	2119082-5	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
	-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
	-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	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	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	811242-6	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	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	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	-	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
	-	1	-	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	1	3-1752356-3	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	1320908-3	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
	-	2	2	2	2	2	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	1	3-1633919-7	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	-	6
	-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	1	3-1633963-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	1	1	1	455888-6	SPACER, CRIMPER	2
	1	1	1	1	1	1	3-456404-9	CRIMPER, WIRE PREMIUM	1

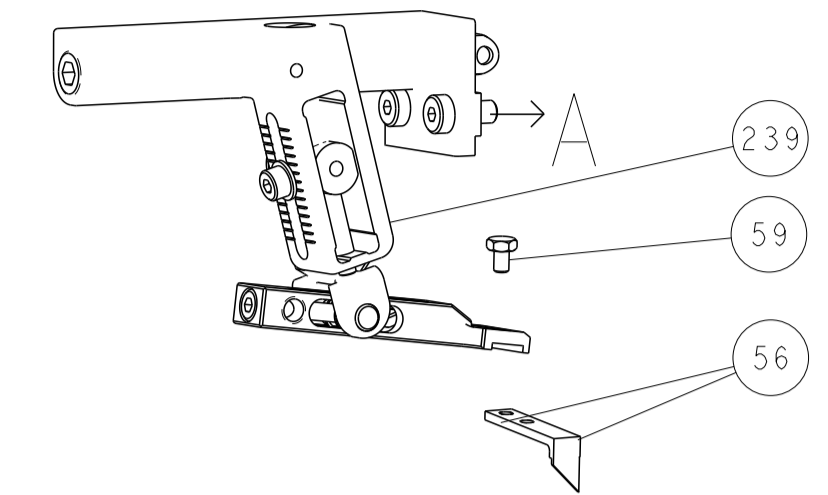
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	ANGLES ±.0001	FINISH			

OWN	CHK	APVD	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
D. WEAVER	T. ELBIN	T. ELBIN	14OCT2014	Ocean Side Feed Applicator	A1	00779	2266533	

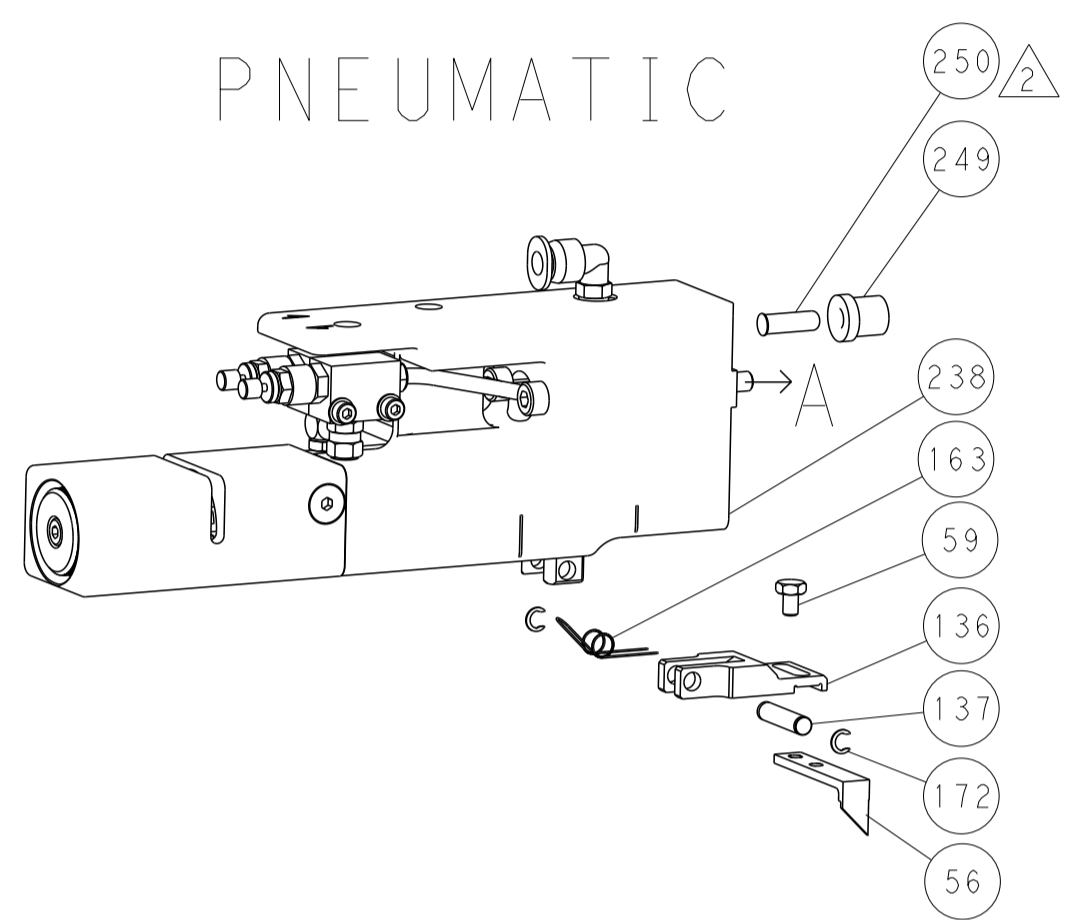
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 of 4 REV A

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

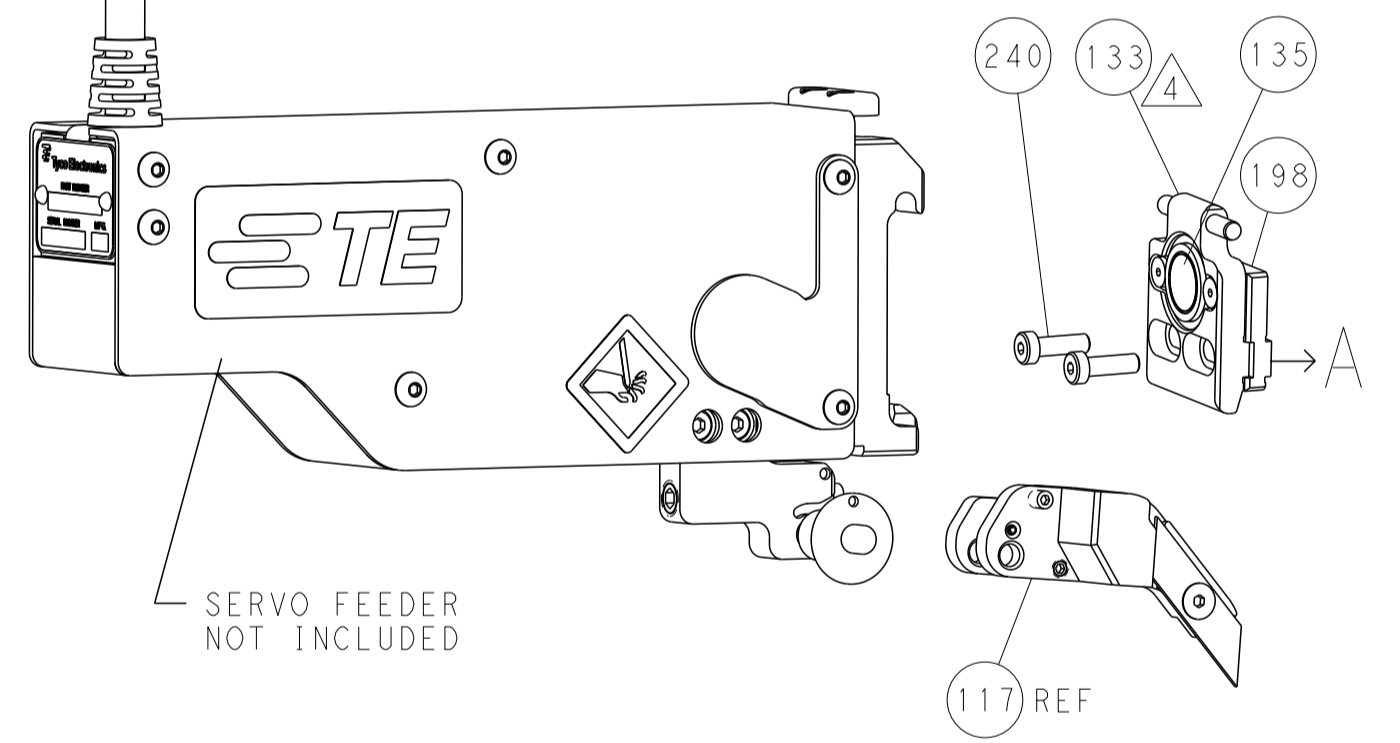
### FEED TYPE MECHANICAL



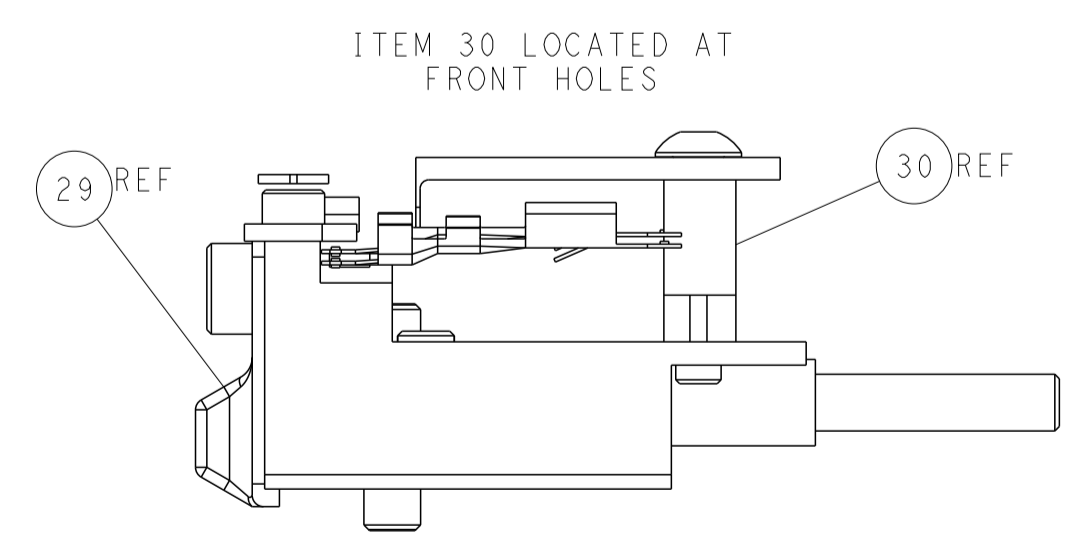
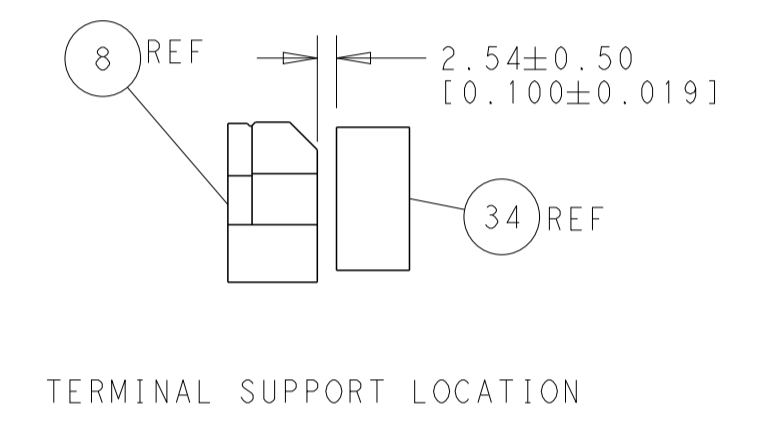
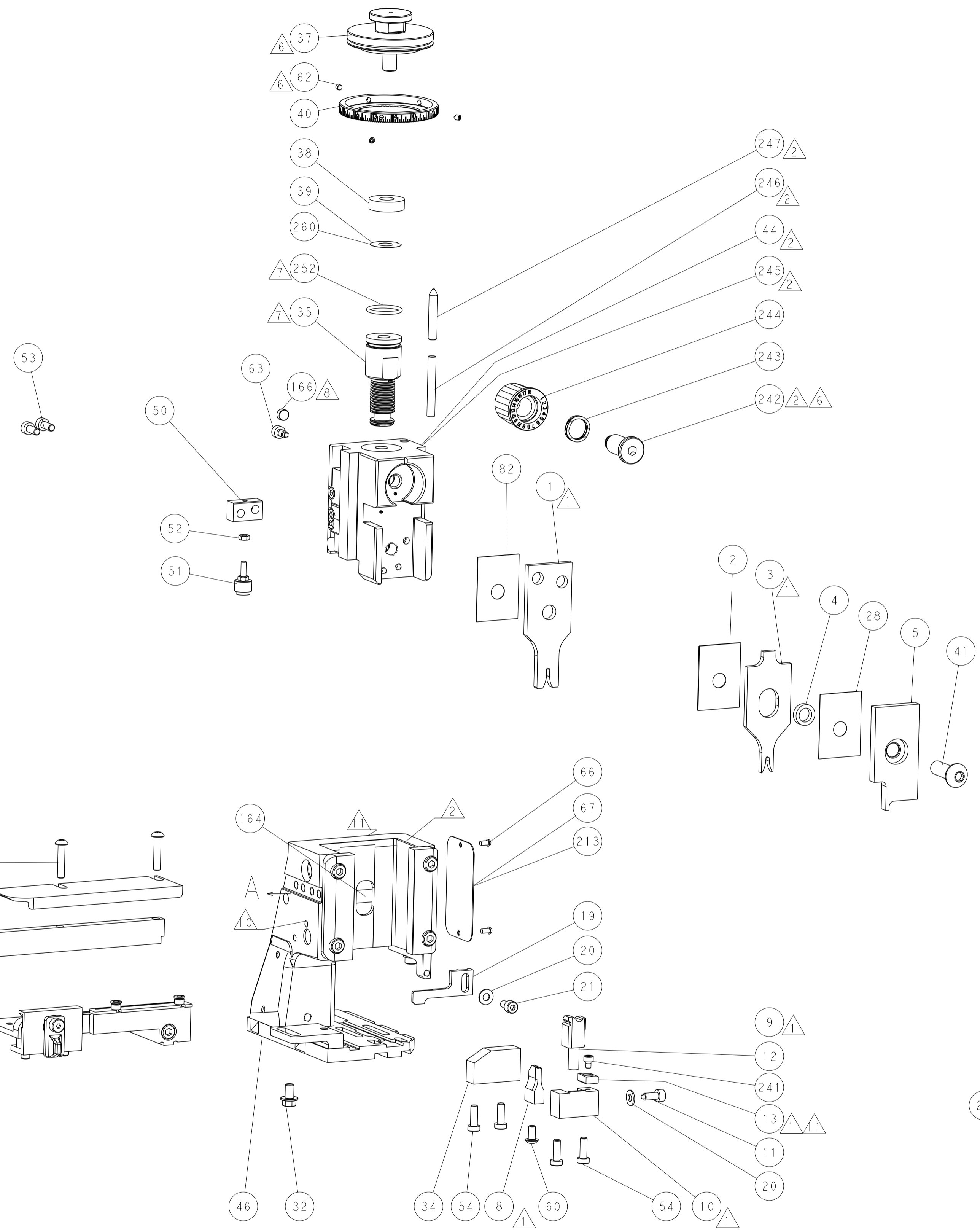
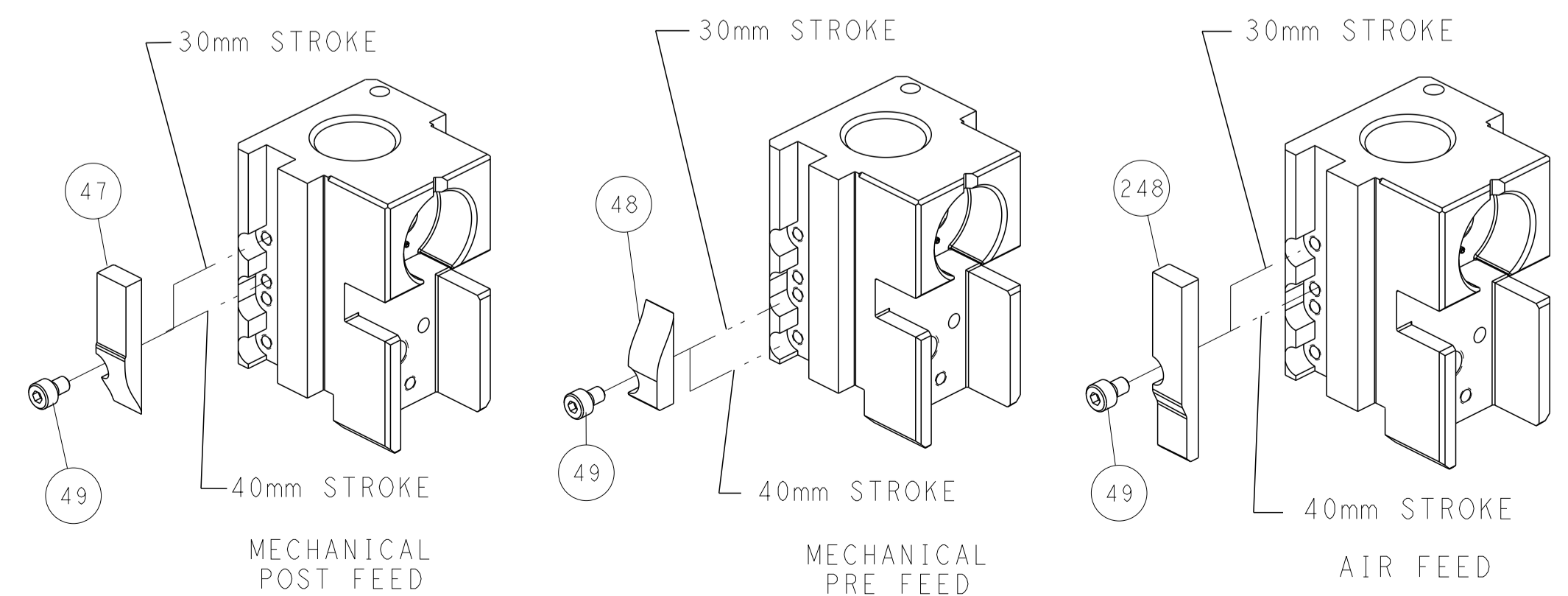
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



FEED TRACK POSITION GUIDE BY INSULATION BARREL

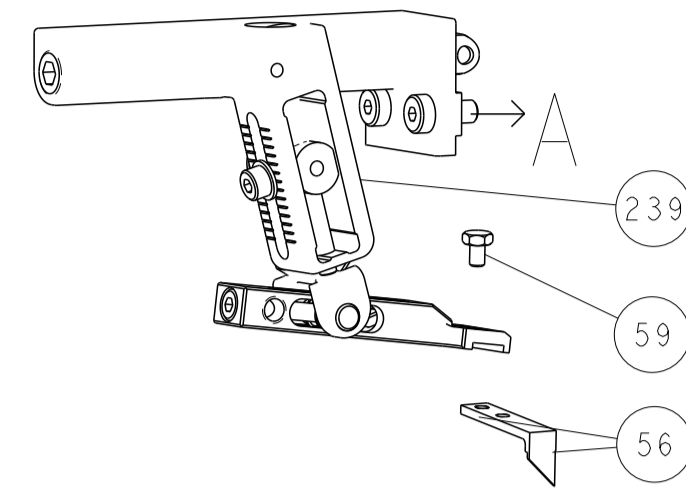
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: 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 ±.0001 FINISH:		DWN B. WEAVER 14OCT2014 CHK T. ELBIN 14OCT2014 APVD T. ELBIN 14OCT2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266533 SCALE: 1:2 SHEET: 2 of 4 REV: A		RESTRICTED TO:	
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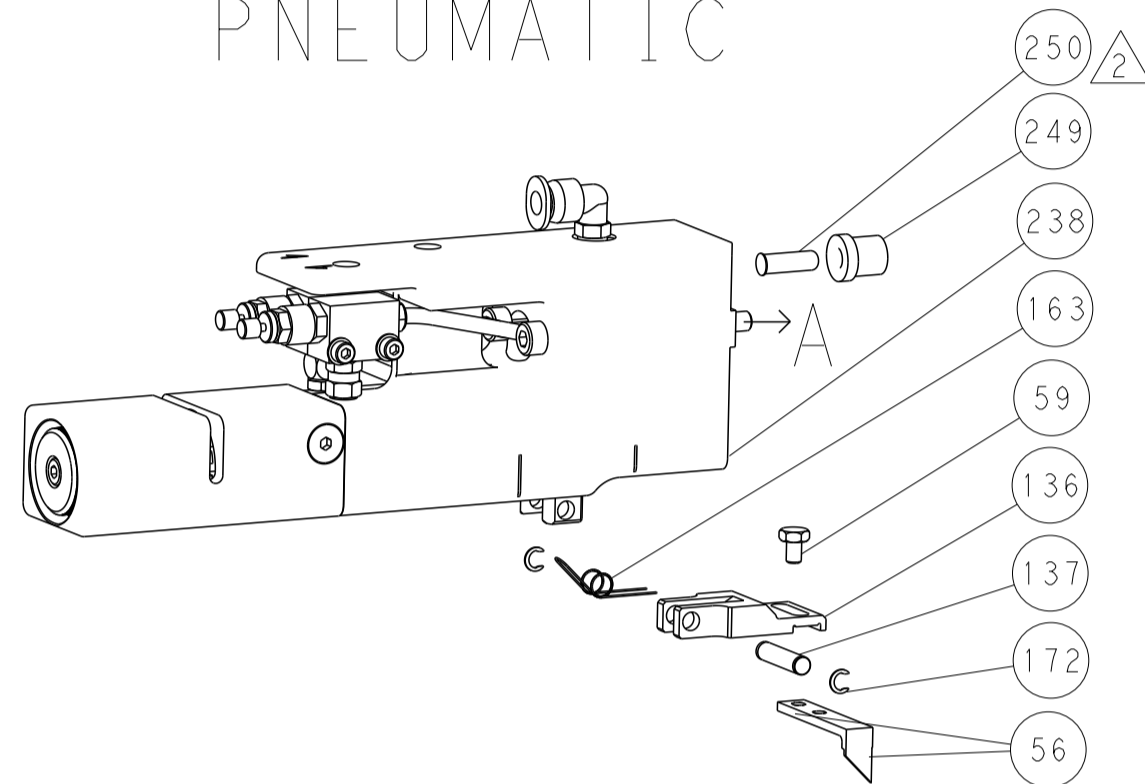


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

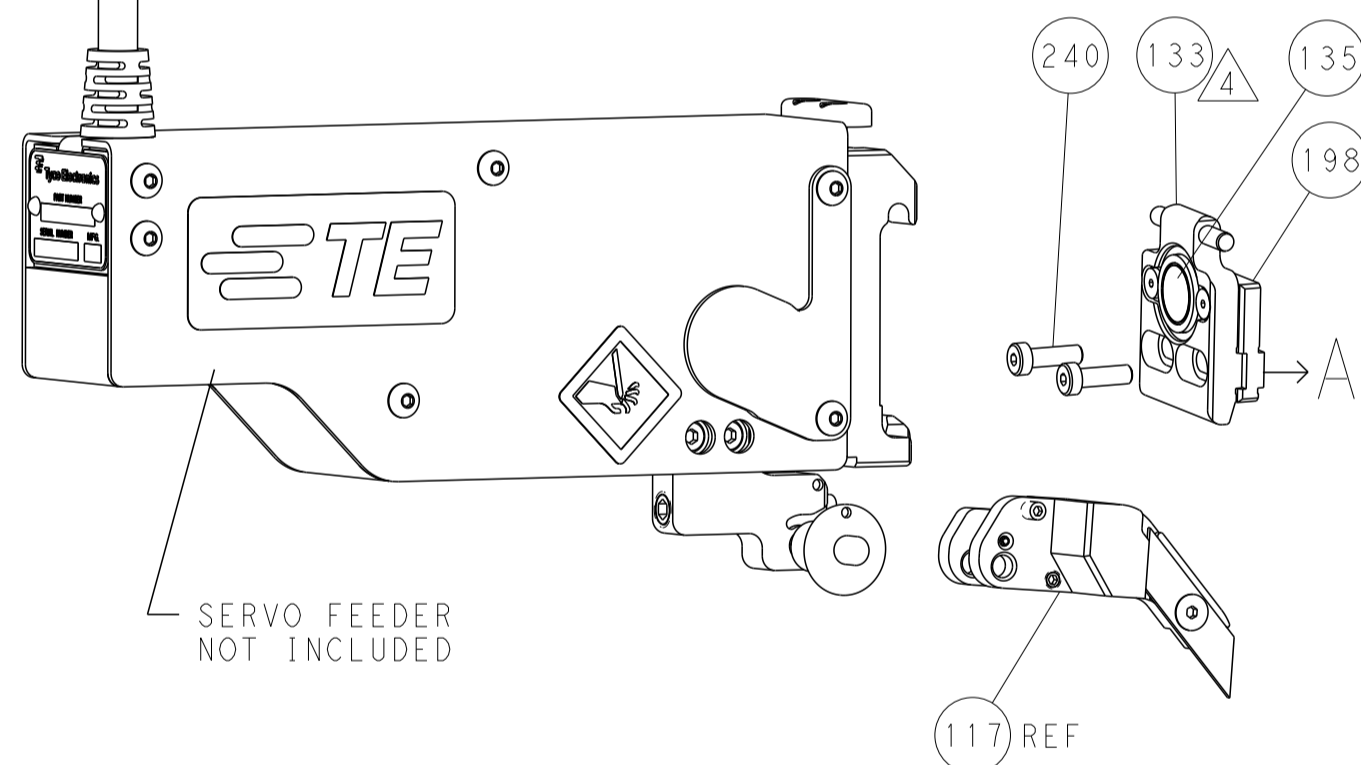
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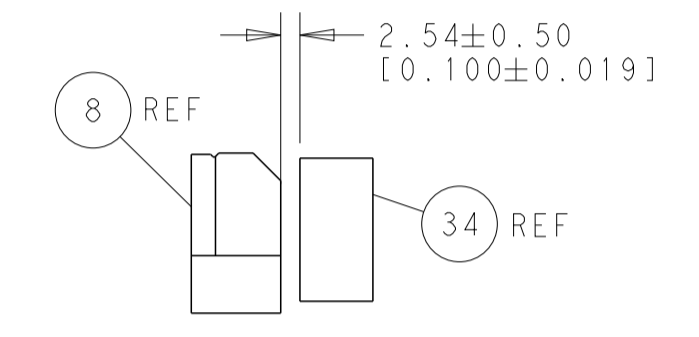
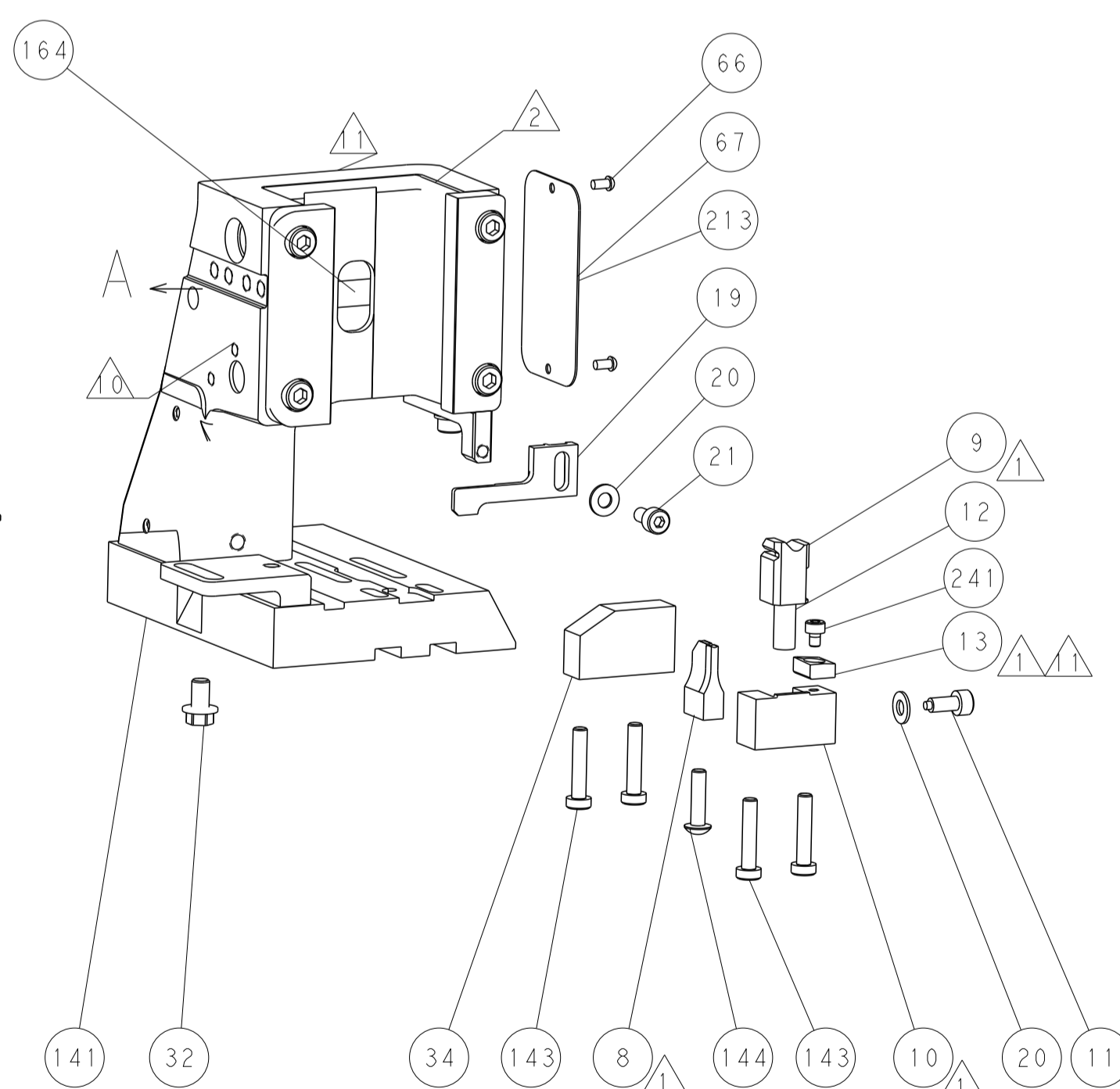
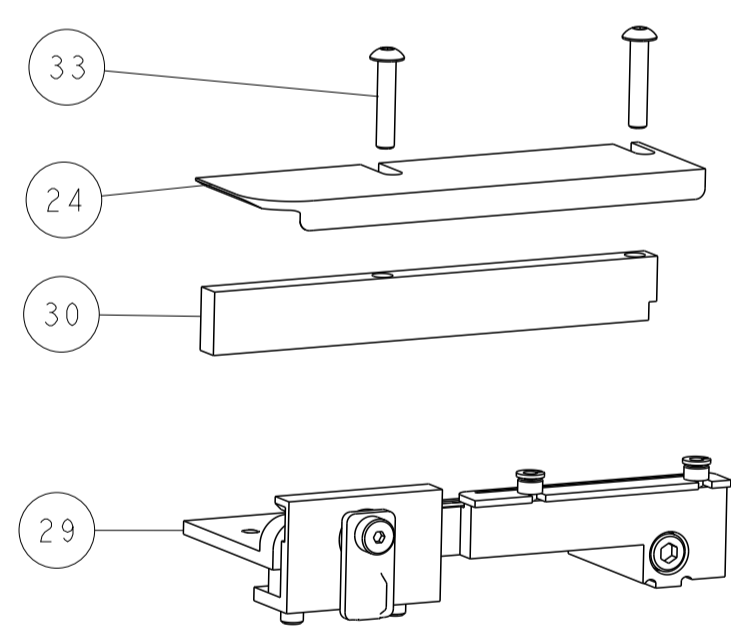
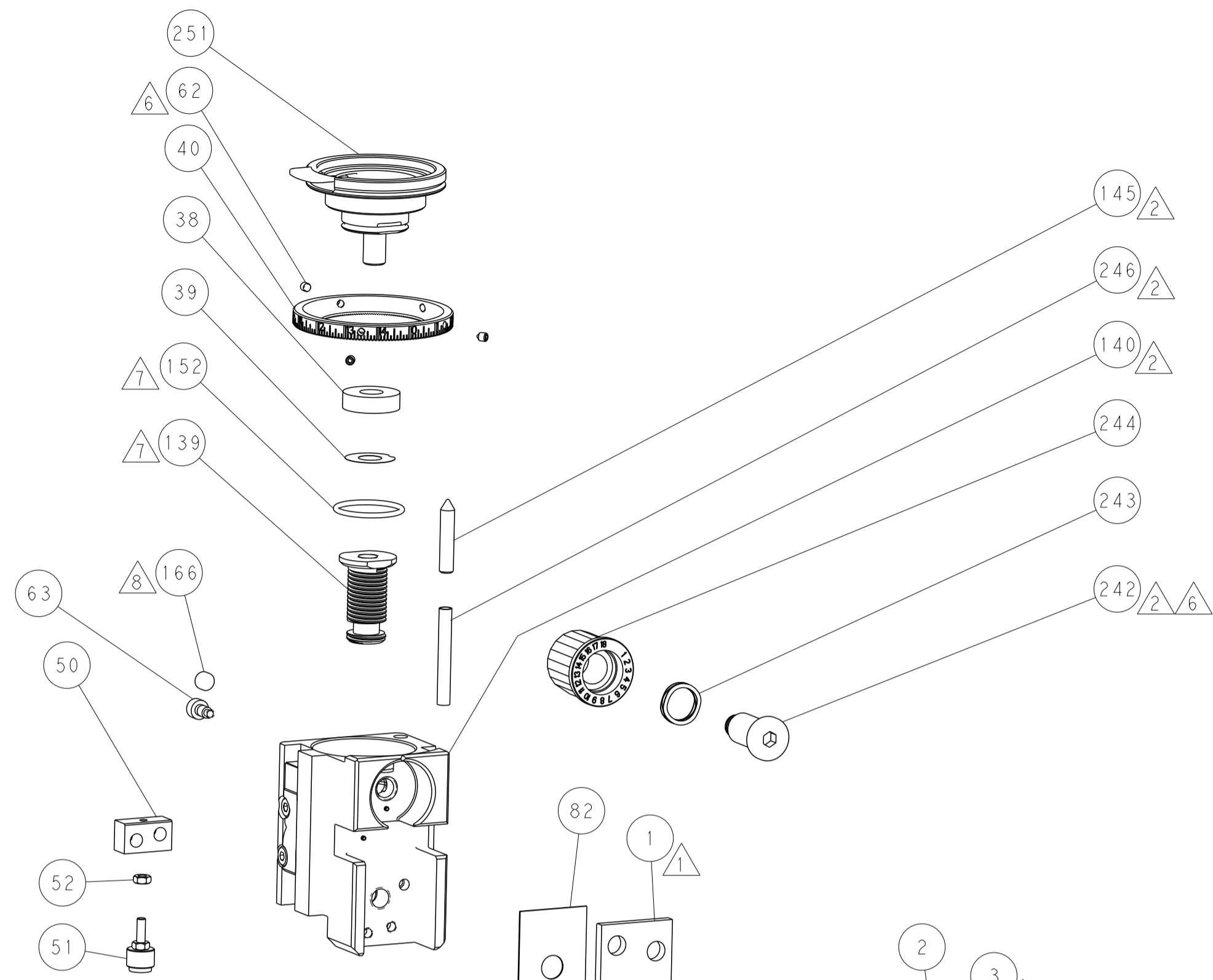
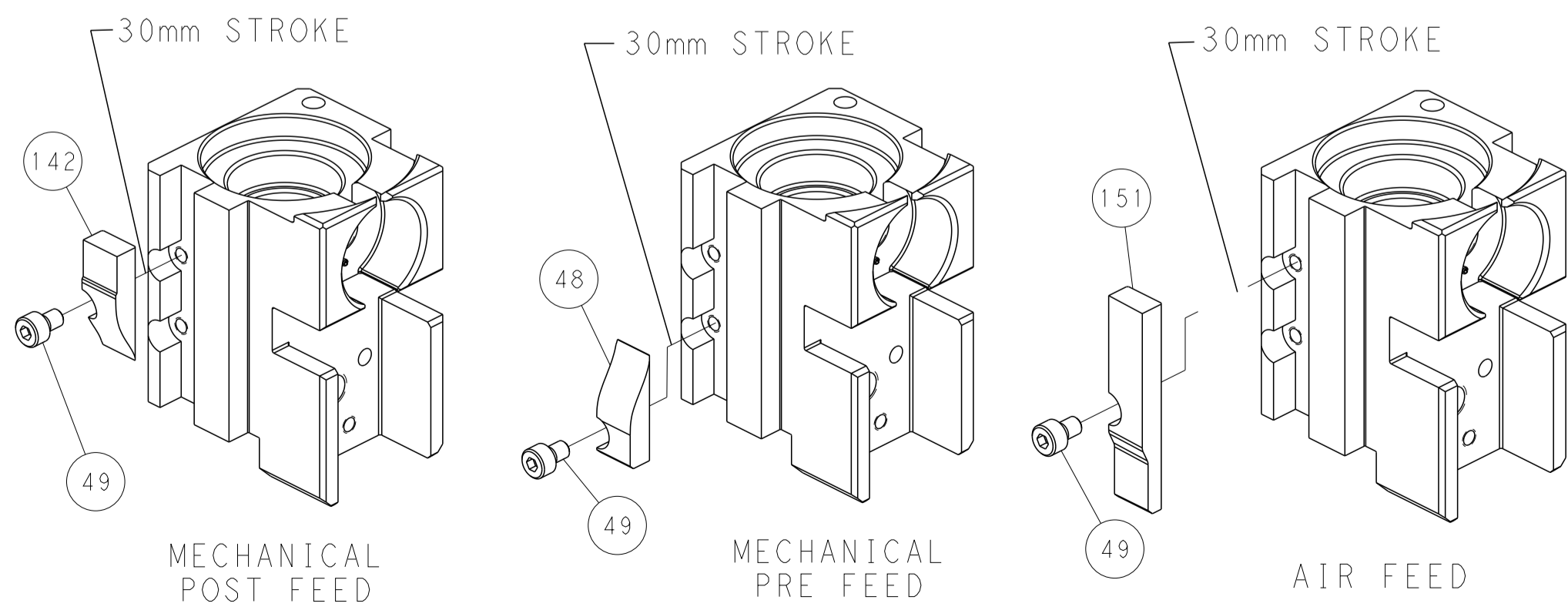
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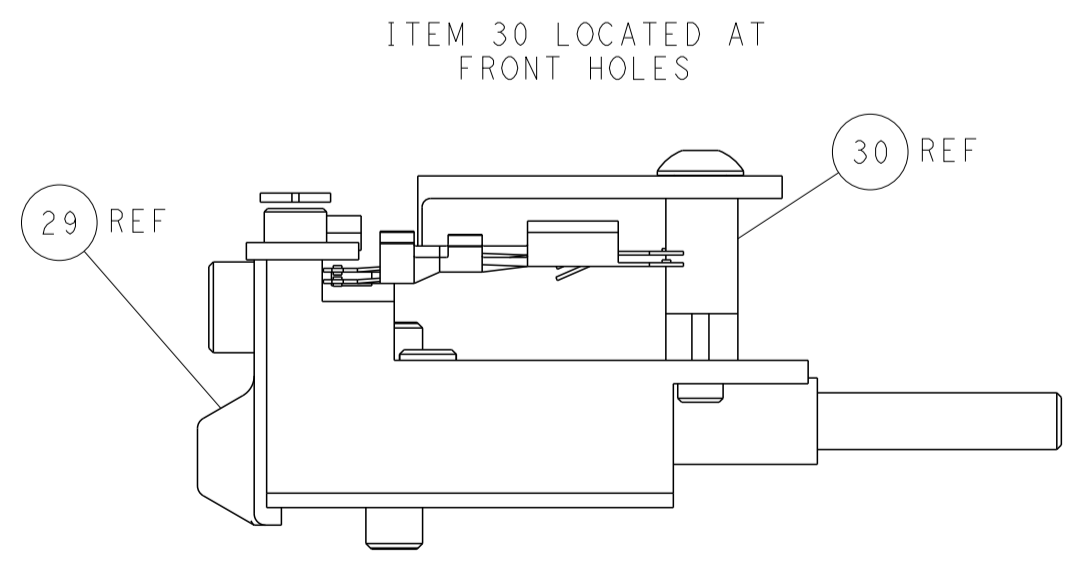
# SERVO LATCH PLATE



# 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 B. WEAVER 14OCT2014		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD T. ELBIN 14OCT2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME		Ocean Side Feed Applicator	
				SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
				A   00779 C=2266533			
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV A	