

APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a diagram of the applicator assembly.

APPLICATOR DATA. Table with columns: CRIMP, SIZE, TYPE. Includes rows for WIRE and INSUL. Below is APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Table with columns: TERMINAL NAME, WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

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. SEE BELOW FOR PART NUMBER: PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266839-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266839-5 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266839-6

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 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.

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 2.96.

*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.

Table with columns: ITEM NO, PART NO, DESCRIPTION. Lists various parts like NUT, SCR, FENCE, APPLICATOR SHIM PACK, O-RING, PUSH ROD, BUSHING, FEED CAM, DETENT PIN, SPRING, RAM, CAM, WASHER.

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

REVISIONS table. Columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Shows revisions 4 (REDESIGN), 5 (DEVELOPEMENT), 6 (DEVELOPMENT), A (RELEASED).

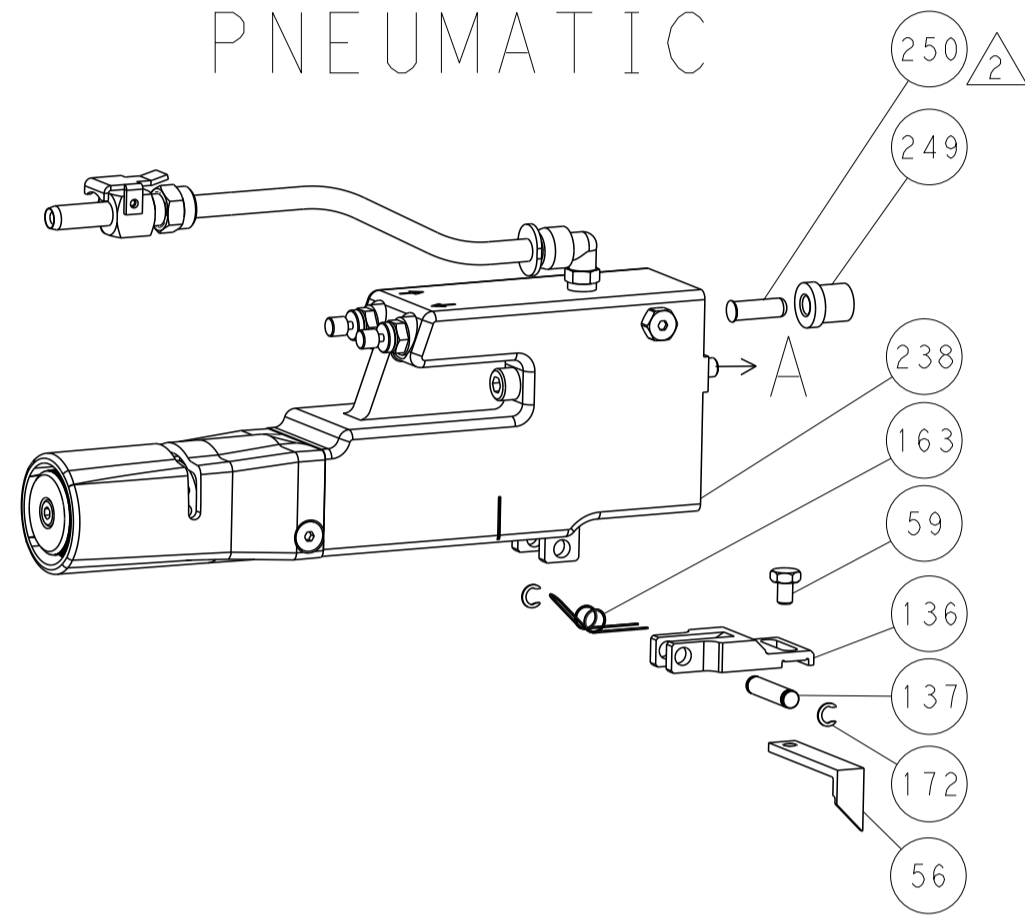
Main parts list table. Columns: ITEM NO, PART NO, DESCRIPTION, ITEM NO. Lists numerous components like RETAINER, SCR, SHCS, TAG, RING, MAGNET, COUNTER, SPRING, RAM, PIN, HOLDER, MEMORY CHIP, SERVO FEED LATCH ASM, SPRING, FEED FINGER ASSEMBLY, FRONT STRIP GUIDE, SCR, SPACER, CRIMPER, SCR, BHSC, EXTENSION PLATE, DOCUMENTATION PACKAGE, DEPRESSOR, TAG, SCREW, LIMITER, SCR, SCR, BUMPER, FEED PAWL, SHCS, SCR, HOLD DOWN, SPRING LOADED, SCR, APPLICATOR BASIC ASSEMBLY, RAM, SCR, DISC, APPLICATOR SHIM PACK, RAM WASHER, FA HEAD, BOLT, SUPPORT, SCR, HEX HEAD, SPACER, STRIP GUIDE, PLATE, STRIP GUIDE, SPACER, CRIMPER, SPRING, LEVER, DRAG, STRIP GUIDE, SCR, SCR, SCR, WASHER, STRIPPER, INSERT, SPRING, STOP, SHEAR, SHEAR HOLDER, FLOATING SHEAR, ANVIL, SPACER, DEPRESSOR, BLOCK, CRIMPER SPACER, CRIMPER, SPACER, CRIMPER, CRIMPER, WIRE.

Product specification form. Fields include: DIMENSIONS (mm), TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE (1:2), SHEET (1 of 4), REV (A). Includes a drawing of a hole and the STC logo.

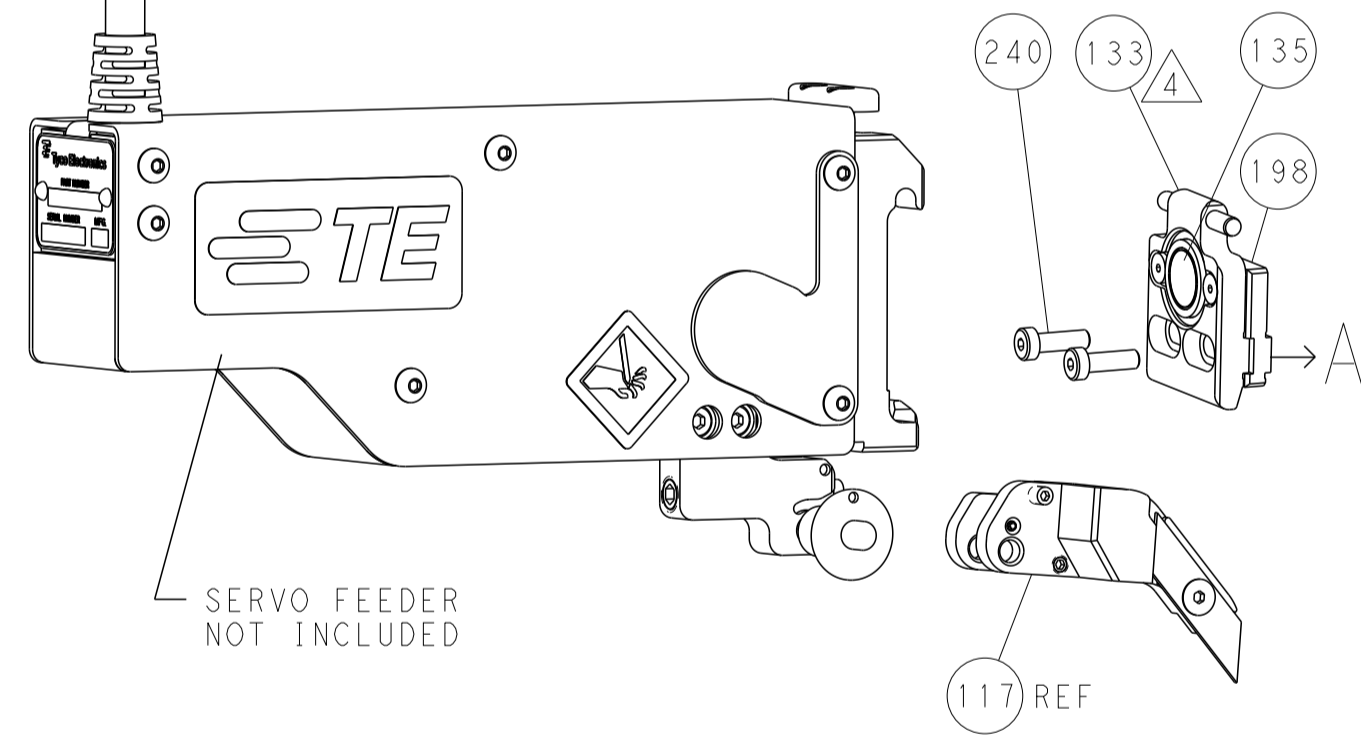
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

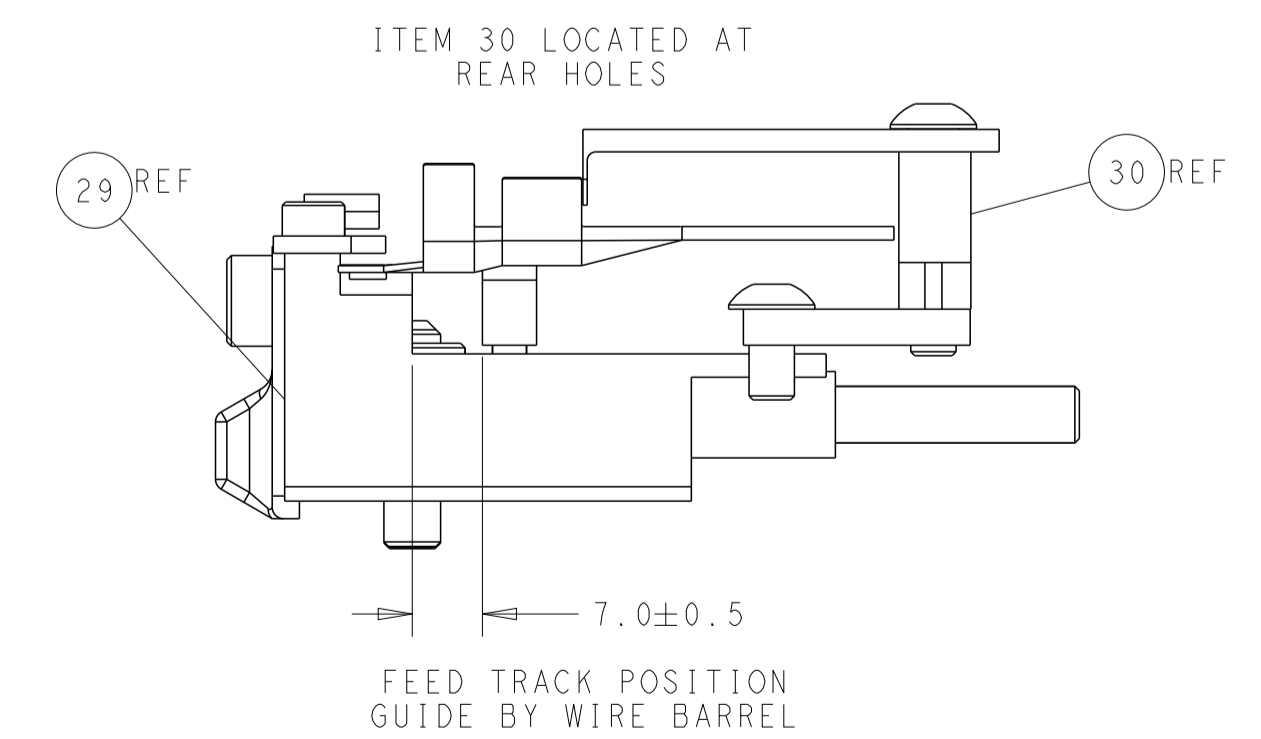
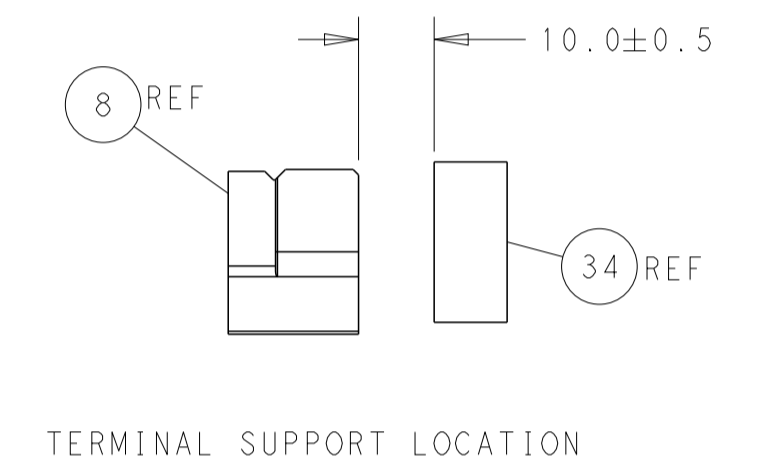
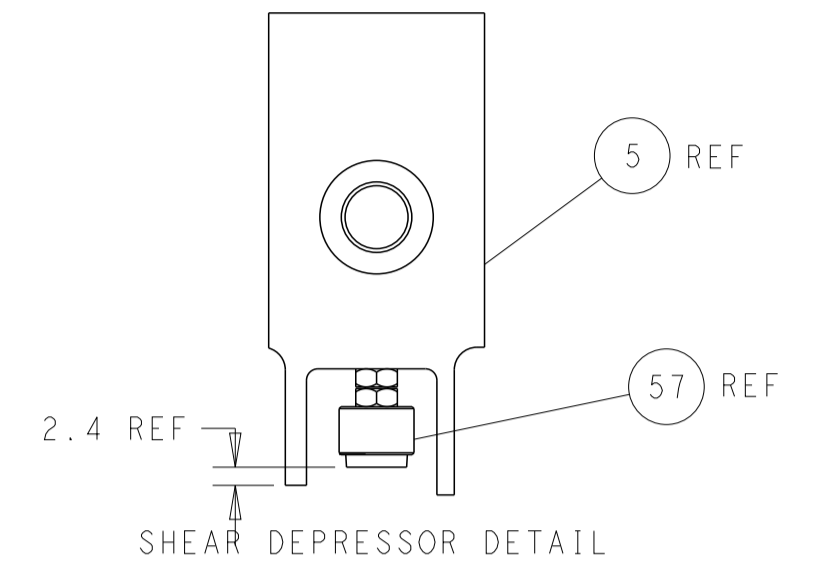
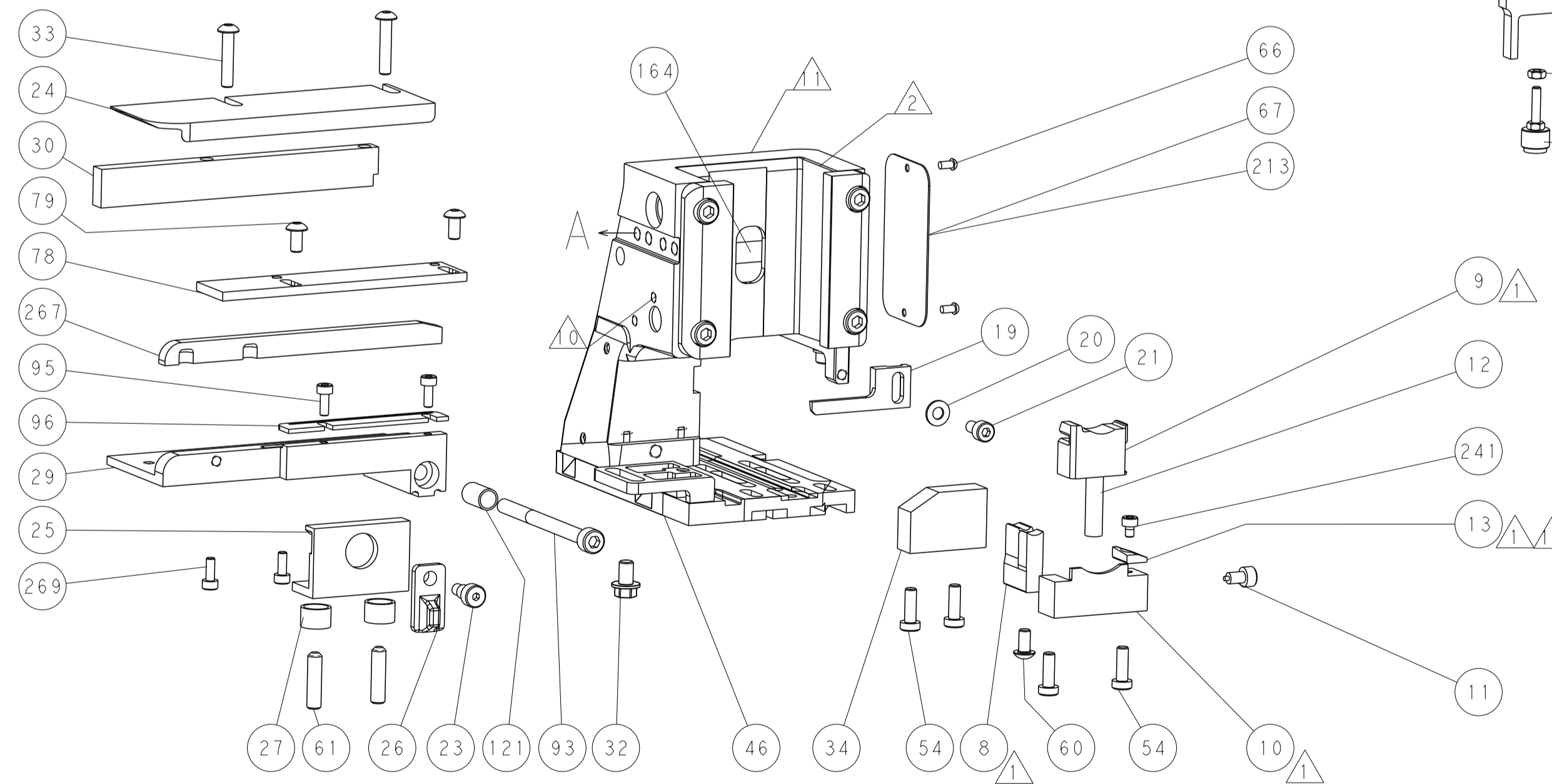
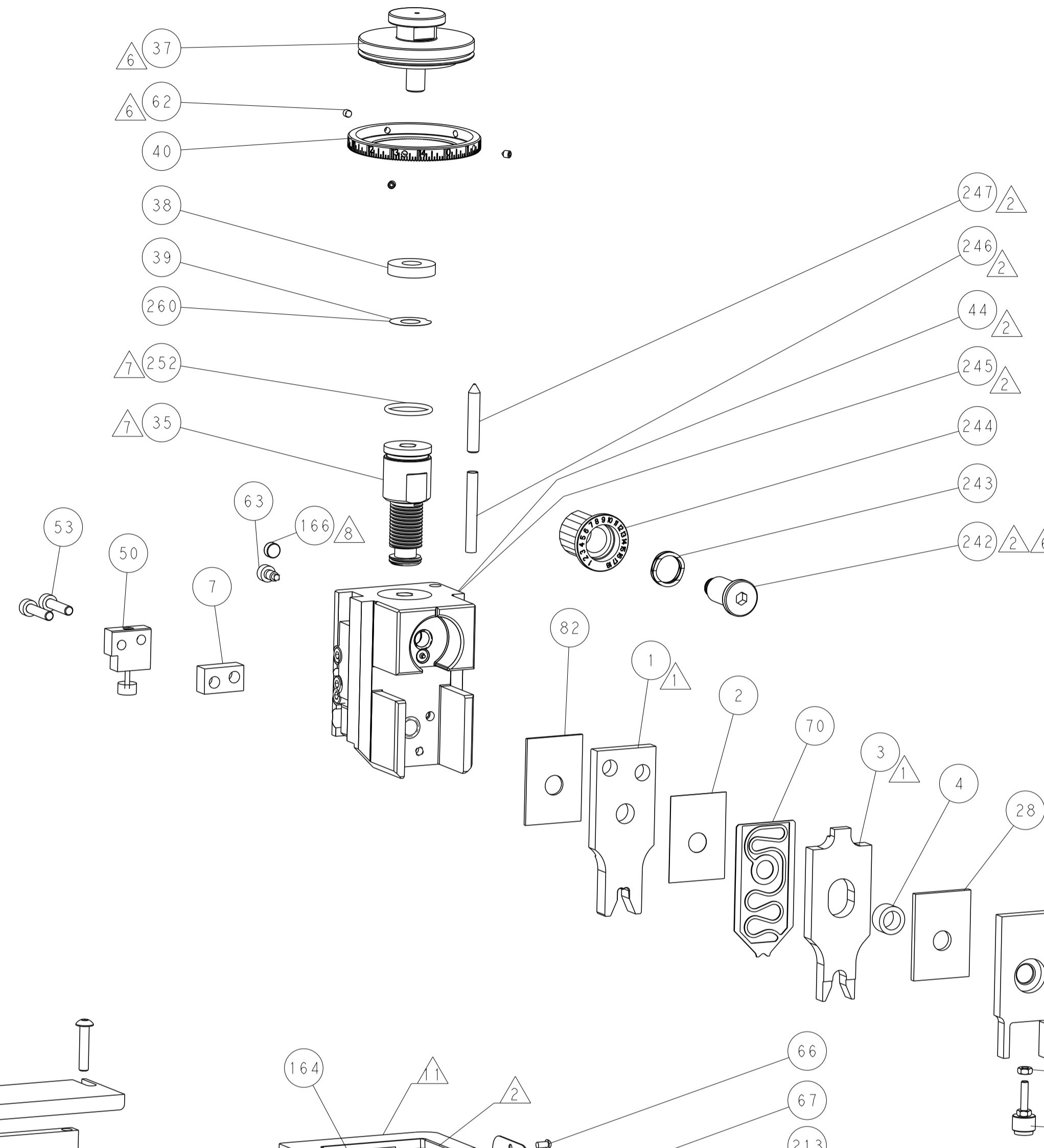
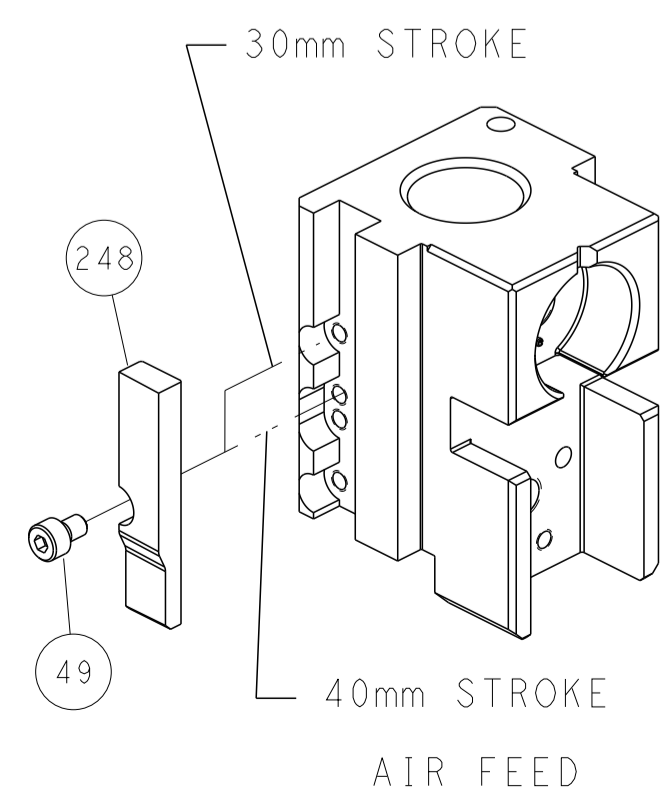
PNEUMATIC



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)

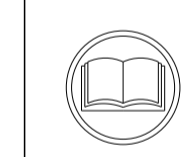
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2015. COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER 02JUL2015 CHK: T. ELBIN 02JUL2015 APVD: T. ELBIN 02JUL2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266839 WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: A	RESTRICTED TO: - Customer Accessible Production Drawing

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2-2266839-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266839-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2266839-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-
	2-2266839-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266839-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	6.60 mm [.260]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: TAB 9.5mm X 1.2mm 10mm ² UNSEALED	
WIRE STRIP LENGTH 9.00-9.80 mm [.354-.386 IN]	INSULATION DIAMETER RANGE Ø5.30-6.00 mm [.209-.236 IN]
TERMINAL APPLICATION SPECIFICATION 114-94407	
TERMINALS APPLIED ¹⁰	
TE TERMINAL	TE TERMINAL
2-2292382-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm ²	3.35+/-0.10 [.132+/- .004]	6.1
8.00mm ²	3.05+/-0.10 [.120+/- .004]	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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266839-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266839-5
- 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.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- ⁸ MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

***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	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	291	
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1	1633782-8	FENCE	267	
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251	
-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250	
-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249	
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

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

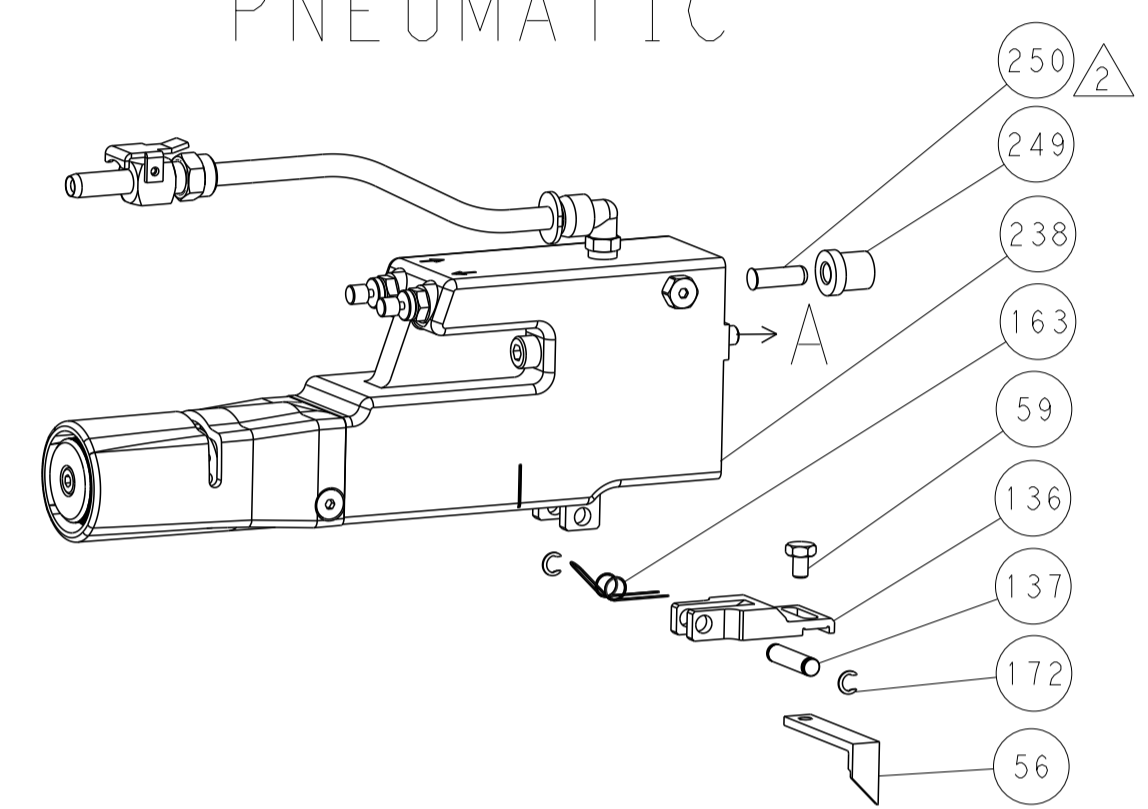
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1		

-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240	
-	-	-	1	2063440-2	AIR FEED MODULE	238	
-	-	-	1	2119740-2	TAG, IDENTIFICATION	213	
-	-	-	1	1901094-3	SPACER, FEEDER	198	
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	-	-	1	240638-1	SPRING, FEED FINGER	163	
-	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152	
-	-	-	1	2119641-2	FEED CAM, AIR FEED	151	
-	1	1	1	2119798-2	DETENT PIN	145	
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143	
-	1	1	1	1-2119656-8	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	2161312-1	RAM, STEPPED, ASIAN STYLE, SIDE FEED	140	
-	1	1	1	2119092-2	BOLT, ADJUSTMENT	139	
-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	-	1	2119799-1	HOLDER, FEED FINGER, AF	136	
-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
-	-	1	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96	
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	1-455888-1	SPACER, CRIMPER	82	
-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1-2119791-1	DEPRESSOR, WIRE	70	
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67	
-	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 PNT, M3 X 4.0	62	
-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	811242-5	BUMPER, HOLD DOWN	57	
-	-	-	1	1338683-8	FEED PAWL	56	
-	2	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53	
-	1	1	1	1803382-4	HOLD DOWN, SPRING LOADED	50	
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	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	2119644-3	RAM WASHER, PRECISION	38	
-	1	1	1	6-1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32	
-	1	1	1	1320908-6	SPACER, STRIP GUIDE	30	
-	1	1	1	2-1901086-2	PLATE, STRIP GUIDE	29	
-	1	1	1	2-455888-2	SPACER, CRIMPER	28	
-	2	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1	1320928-6	STRIP GUIDE	24	
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	2119533-2	STRIPPER, SIDE FEED	19	
-	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1-356885-2	STOP, SHEAR	11	
-	1	1	1	2-2119805-2	SHEAR HOLDER, FRONT	10	
-	1	1	1	1-318059-4	FLOATING SHEAR, FRONT	9	
-	1	1	1	9-1633930-0	ANVIL, COMBINATION	8	
-	1	1	1	1-240641-5	SPACER	7	
-	-	-	-	-	-	6	
-	1	1	1	1-1803080-5	DEPRESSOR, SHEAR	5	
-	1	1	1	5-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	1	1	6-1633966-8	CRIMPER, INSULATION O	3	
-	1	1	1	455888-1	SPACER, CRIMPER	2	
-	1	1	1	1-1633773-4	CRIMPER, WIRE, STEP	1	
-	77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

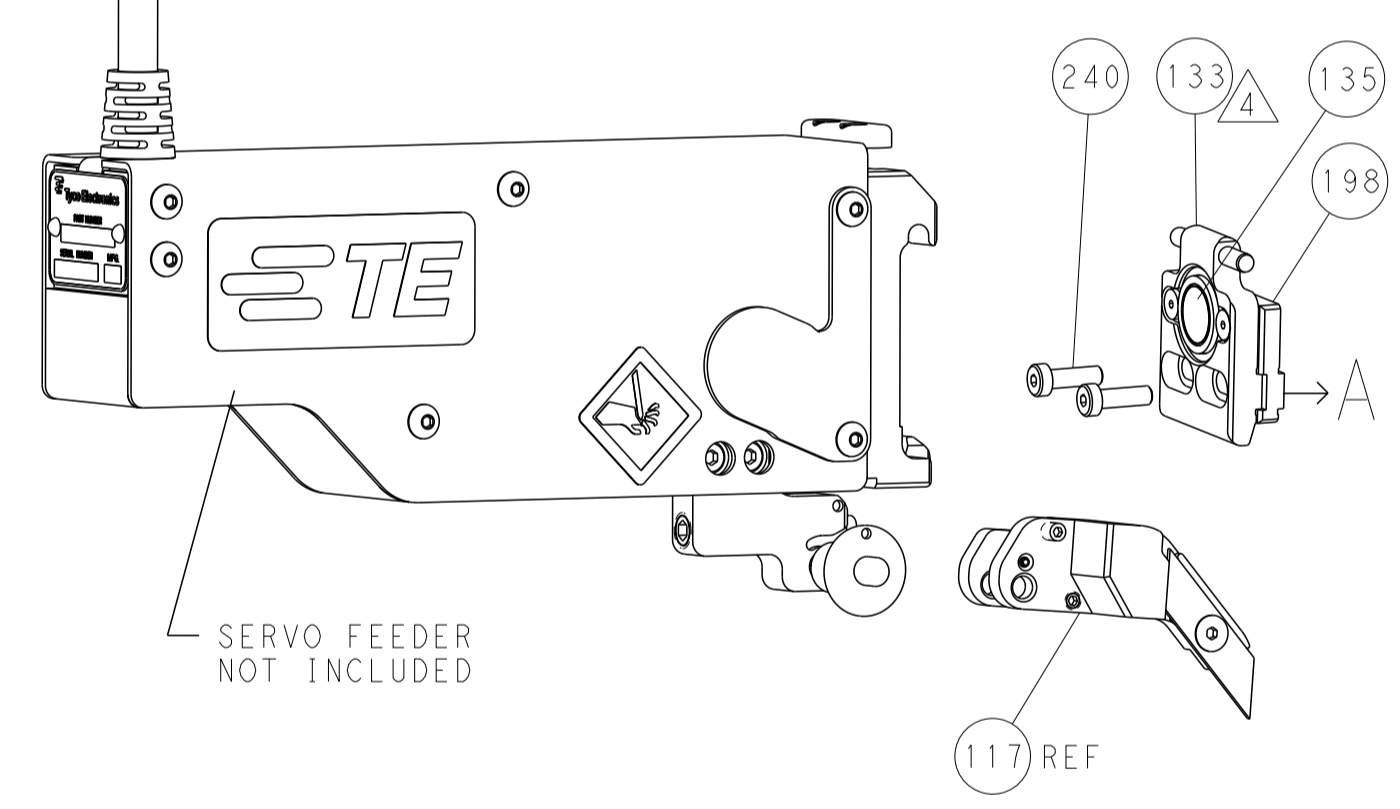
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MATERIAL		WEIGHT		SCALE		SHEET		REV	
				Customer Accessible Production Drawing		1:2		3 of 4	

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

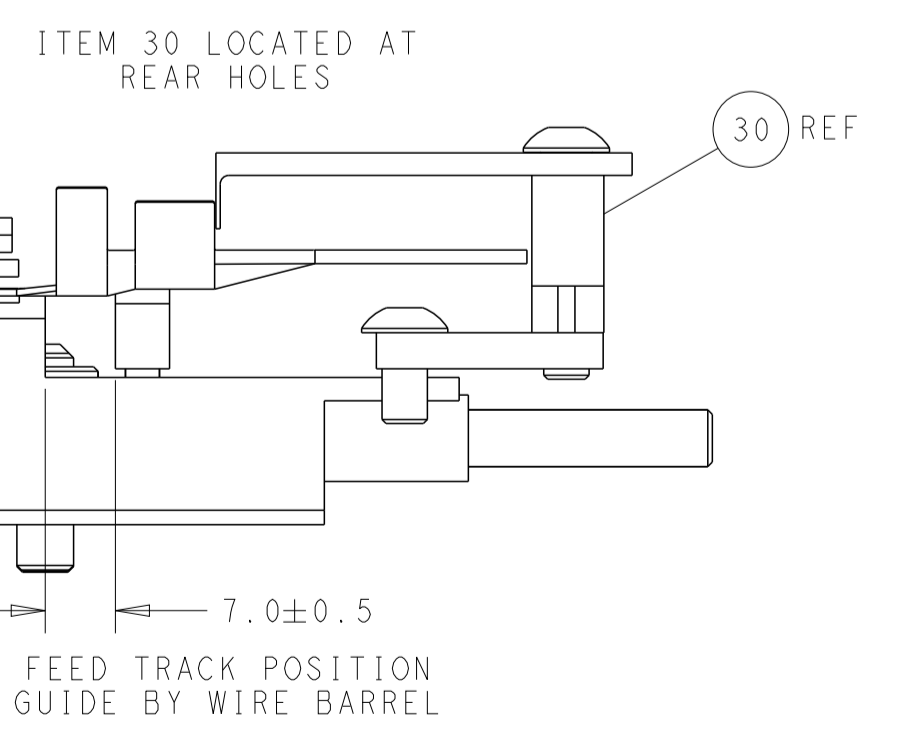
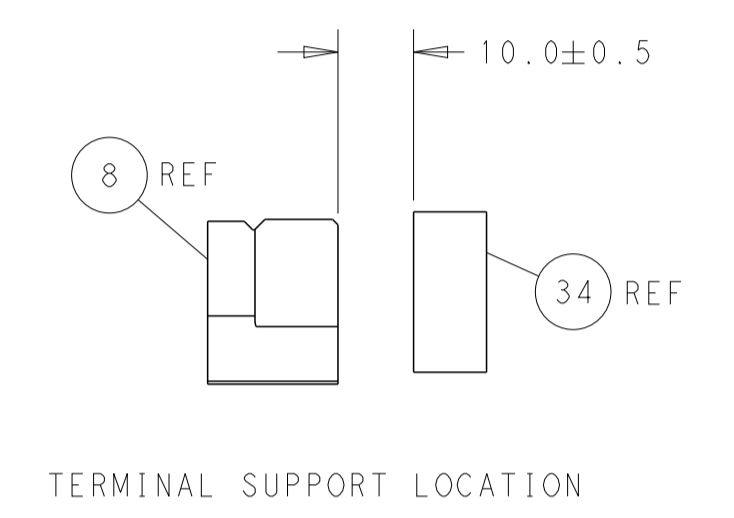
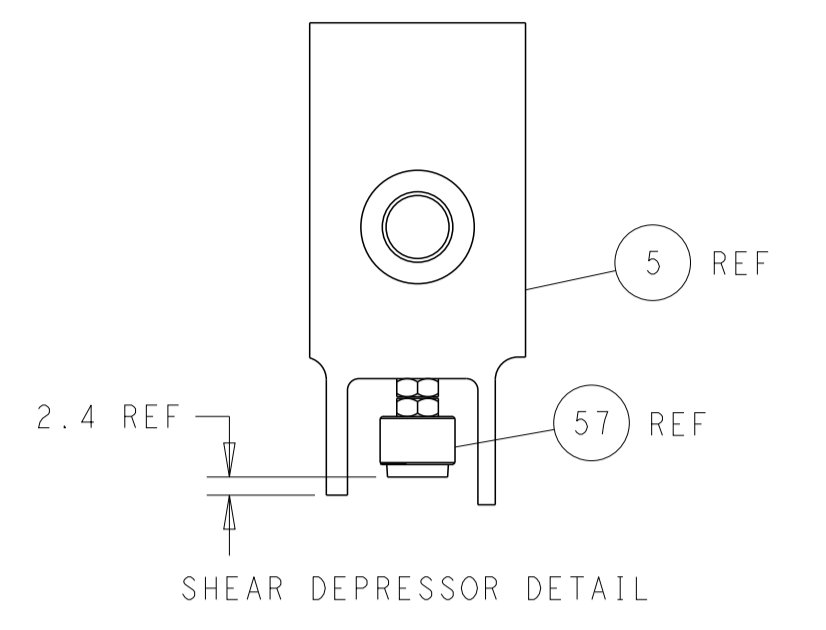
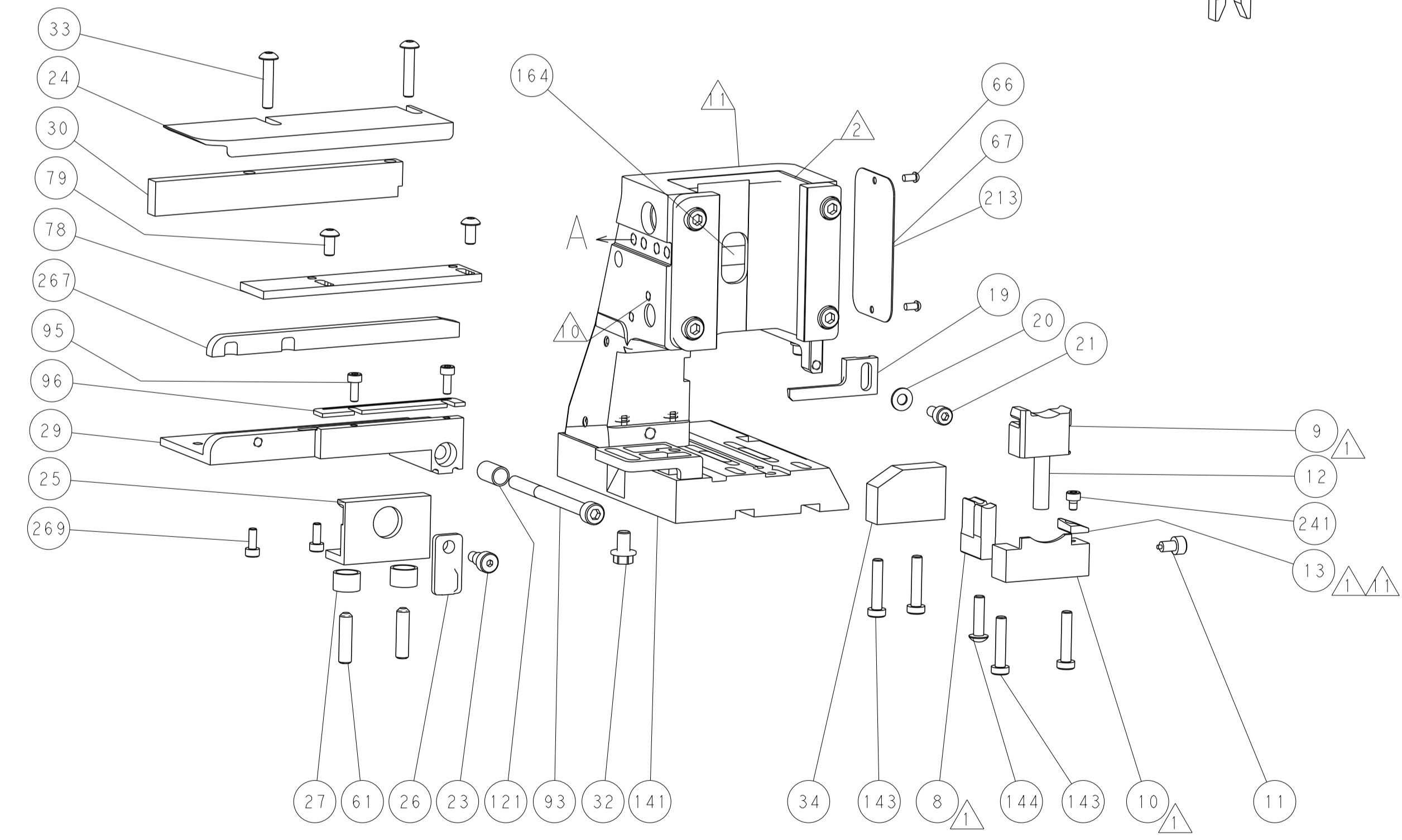
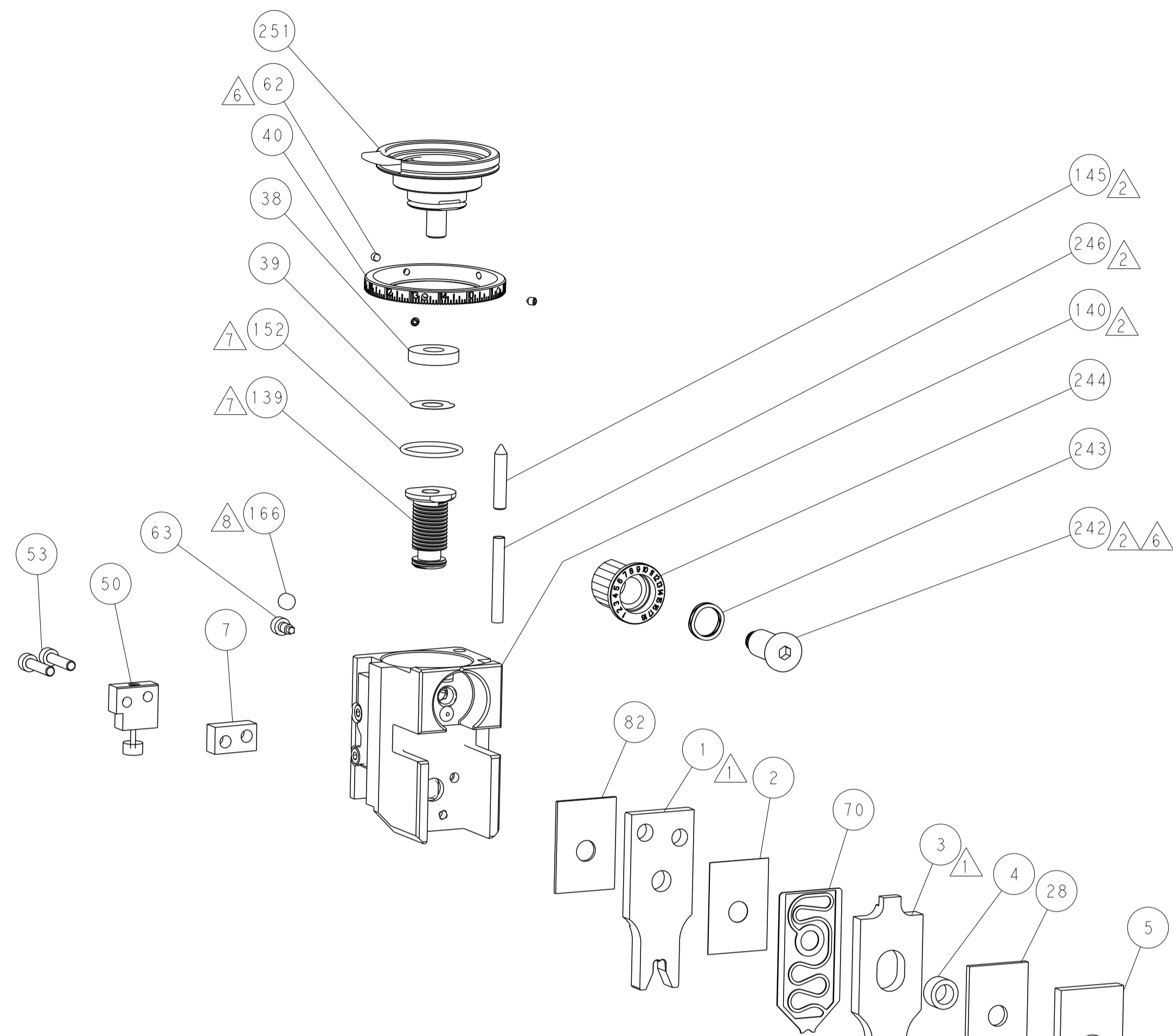
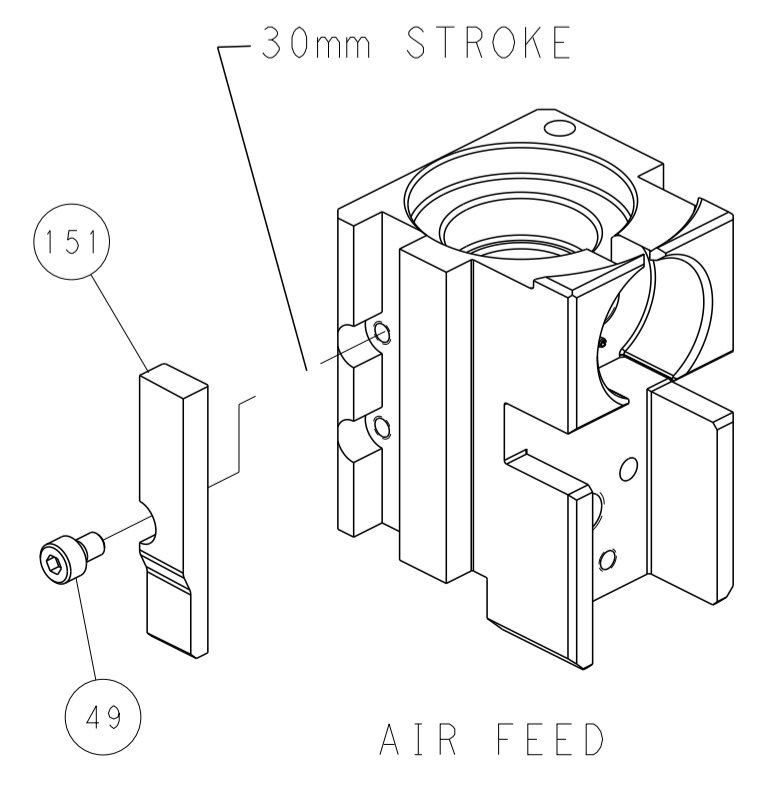
FEED TYPE PNEUMATIC



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES FINISH ±. MATERIAL: . FINISH: .	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: . SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266839	RESTRICTED TO: SHEET 4 OF 4 REV A