

APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

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

TERMINAL DATA: HULANE TERMINAL TE CRIMP SPECIFICATION. Table with columns: 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.
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.
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.
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.
WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.38.
APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.

\*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: PART NO, DESCRIPTION, ITEM NO. Lists spare parts like APPLICATOR SHIM PACK, O-RING, PUSH ROD, etc.

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

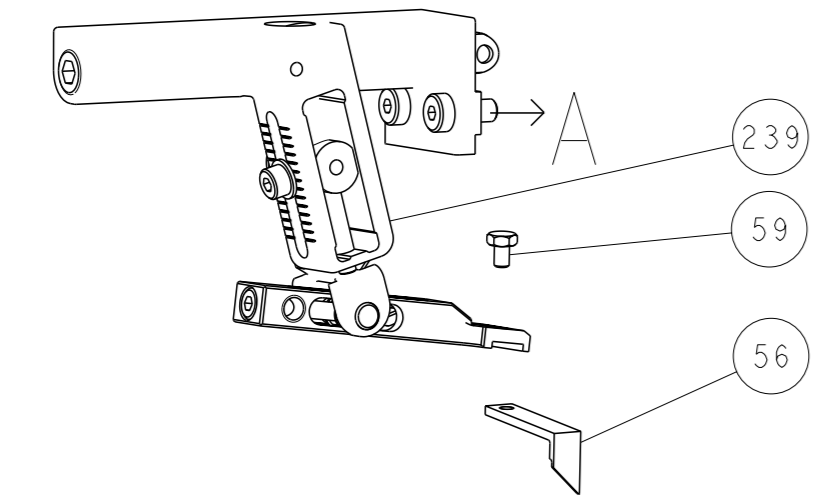
REVISIONS table with columns: P, L, R, DESCRIPTION, DATE, DWN, APVD.

Main parts list table with columns: P, L, R, DESCRIPTION, DATE, DWN, APVD. Lists various components like SPRING, RAM, CAM, WASHER, etc.

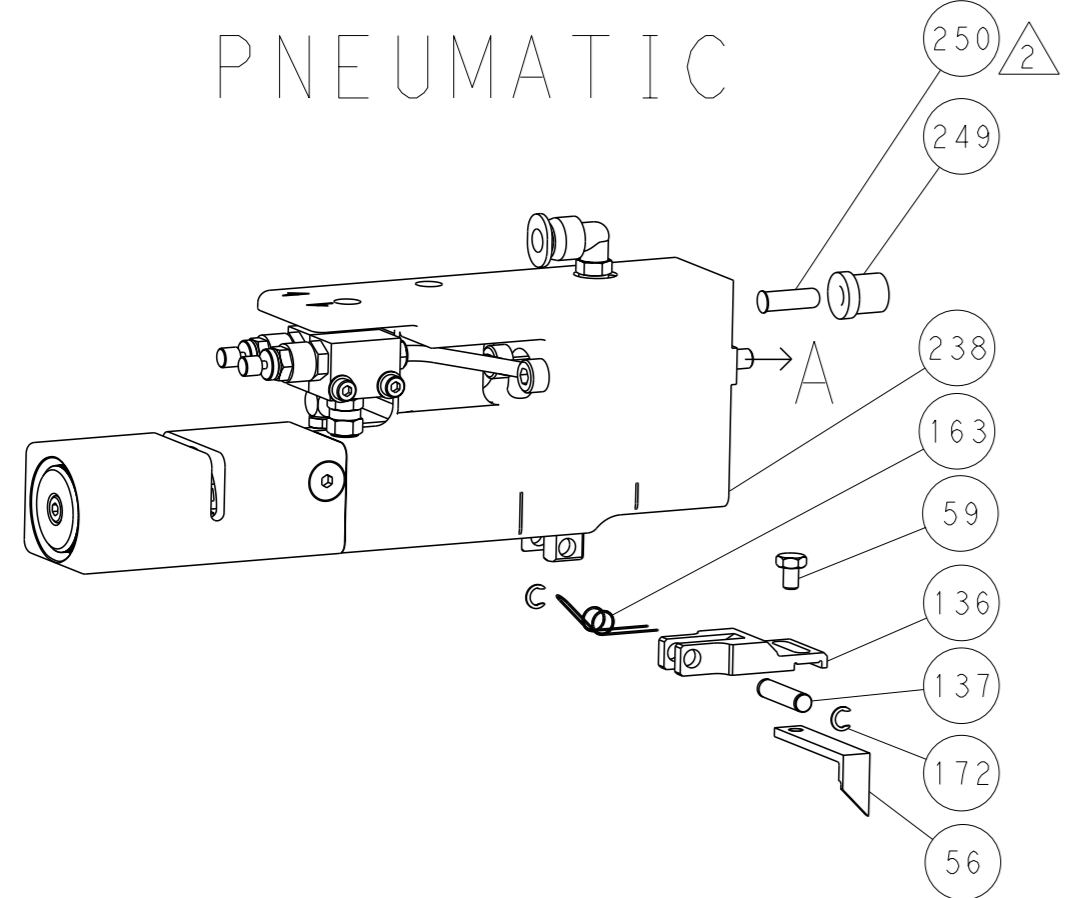
TE Connectivity Ocean Side Feed Applicator. Includes dimensions, tolerances, material, and drawing information.

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	1	SEE SHEET 1	-	-

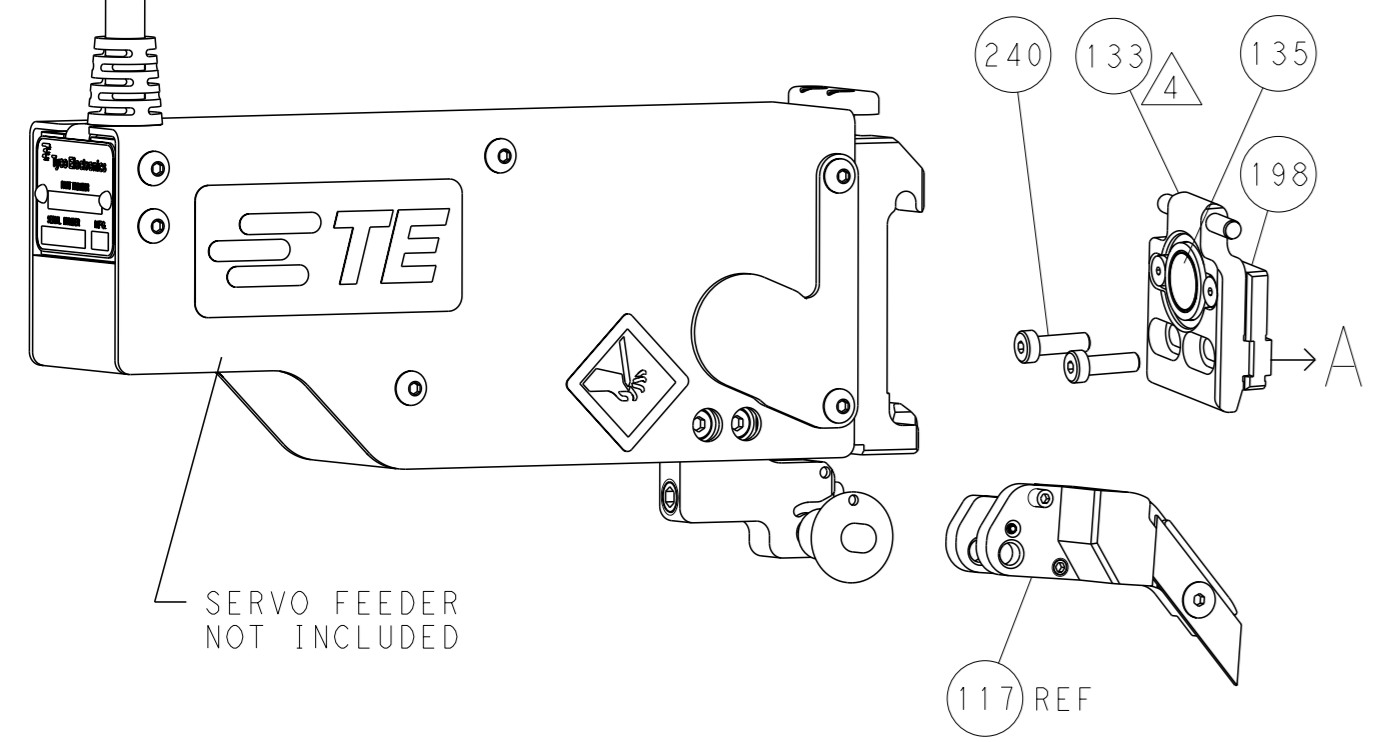
### FEED TYPE MECHANICAL



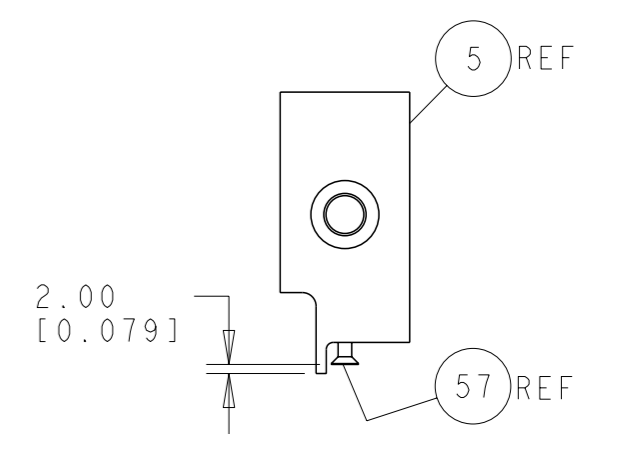
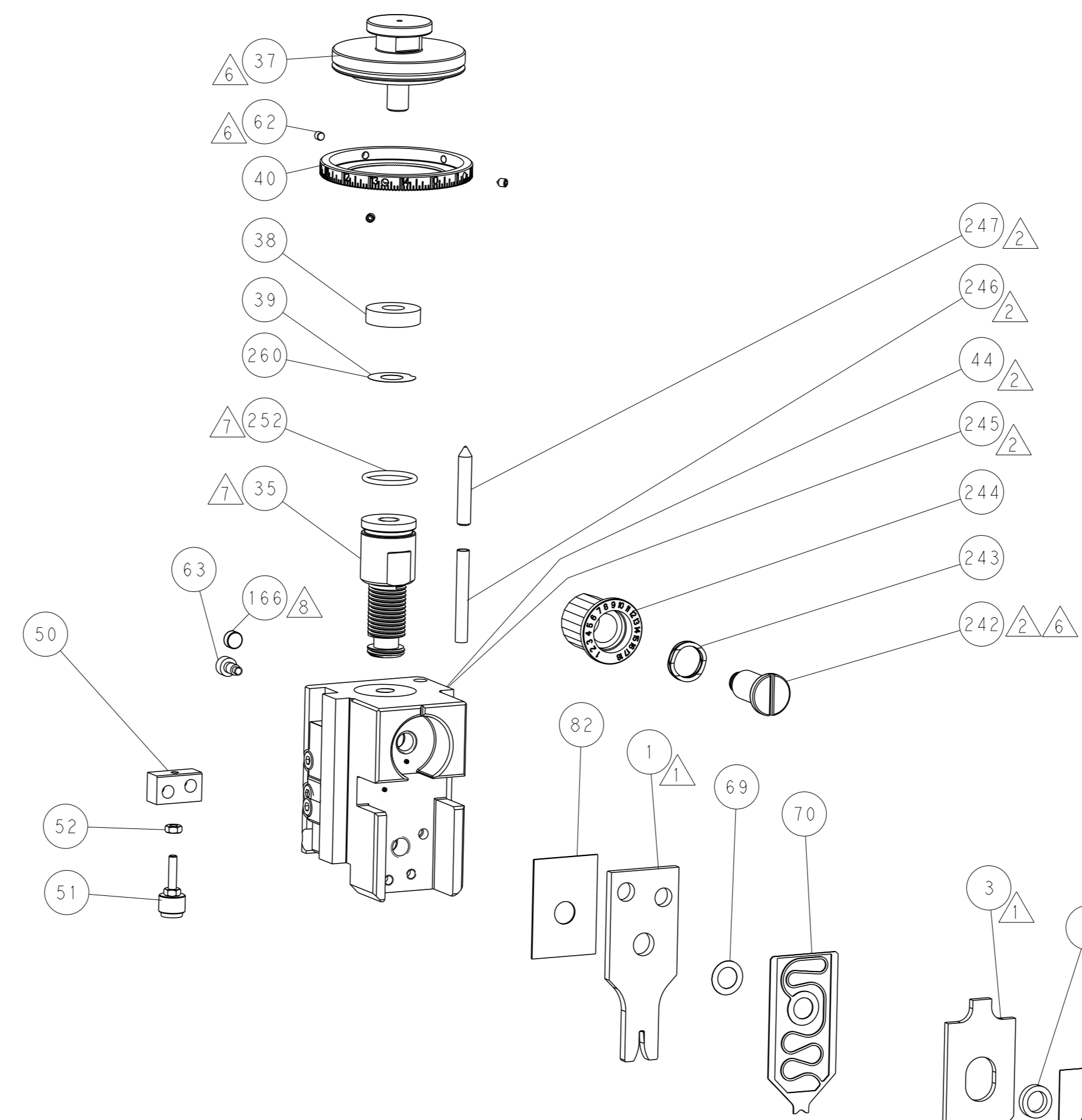
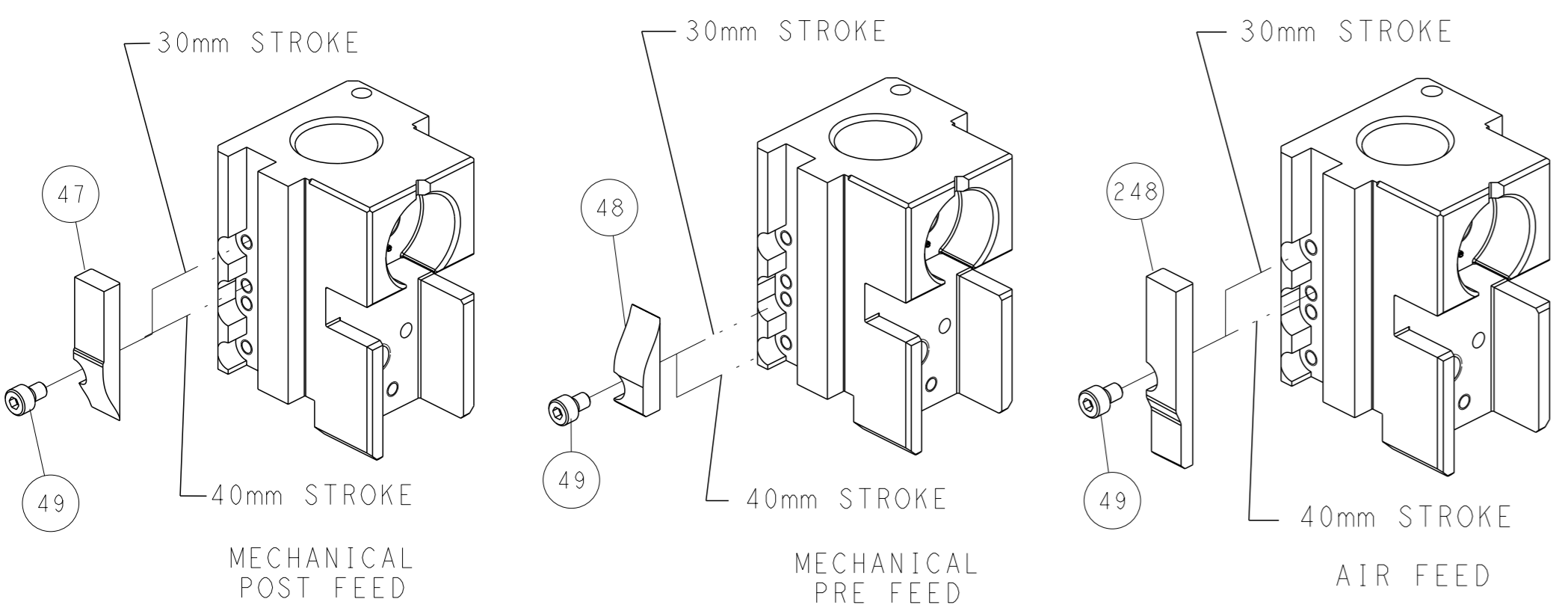
### PNEUMATIC



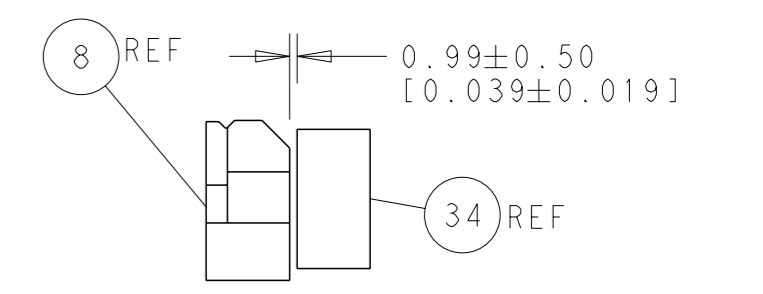
### SERVO LATCH PLATE



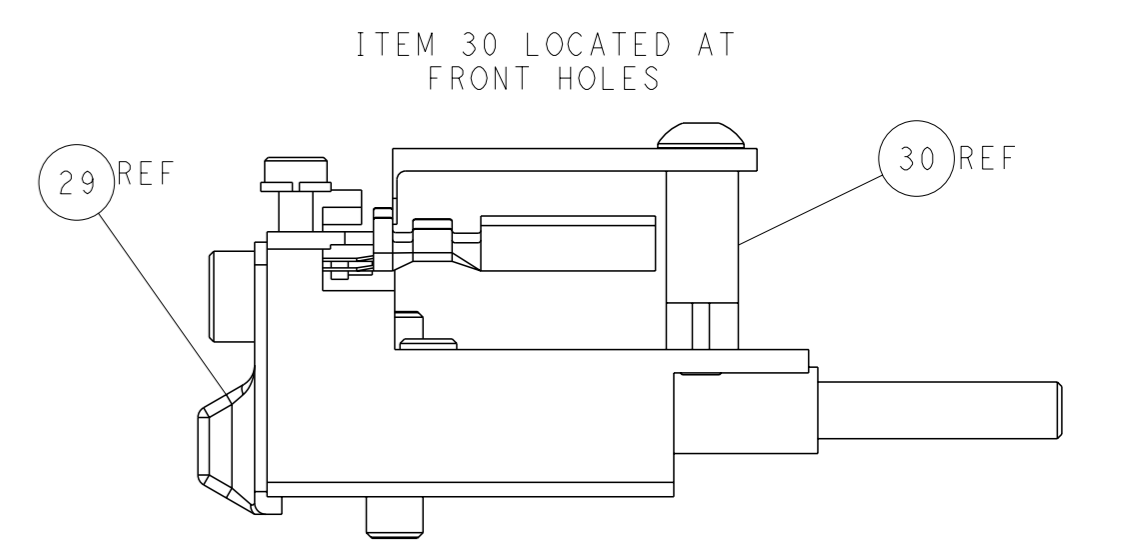
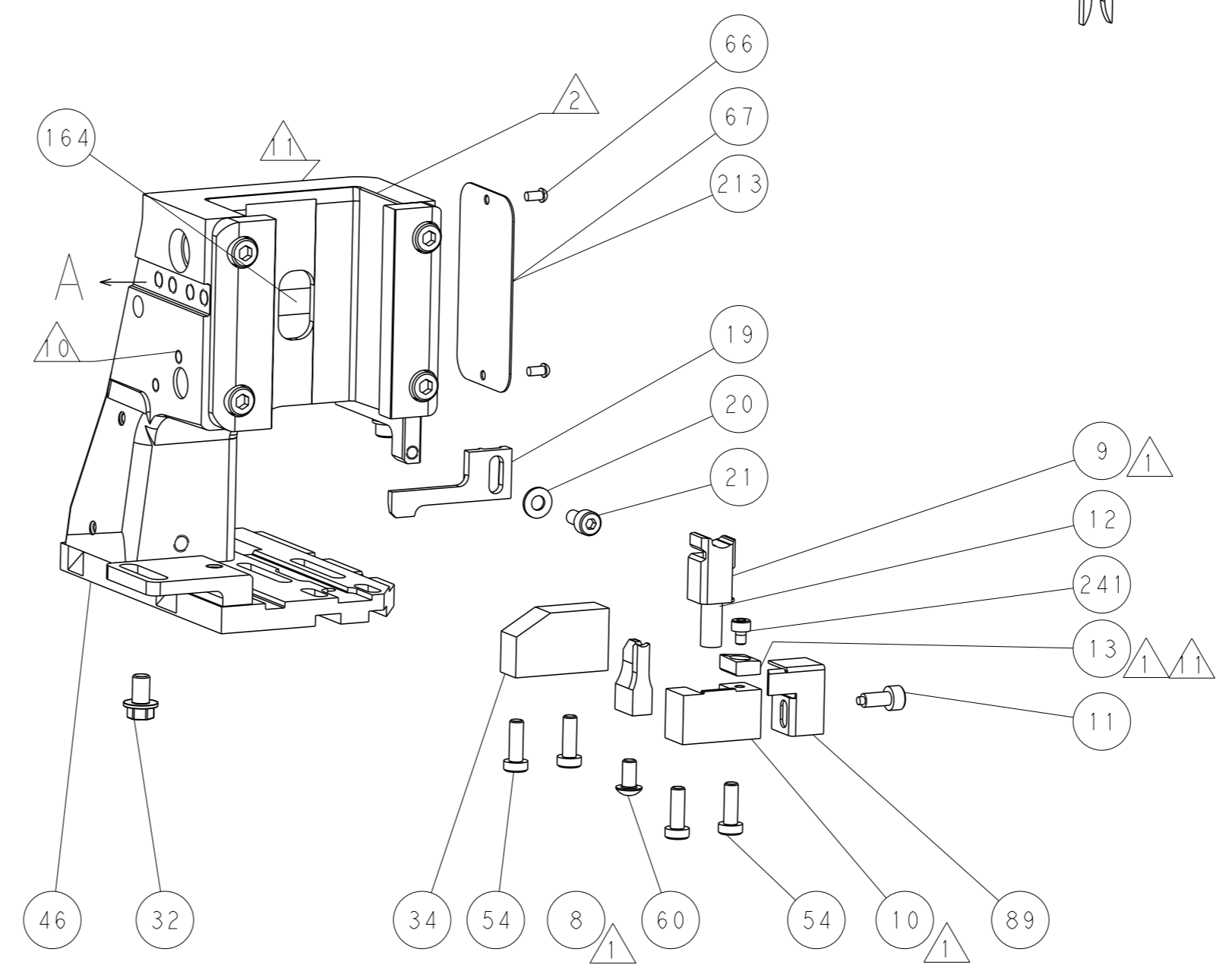
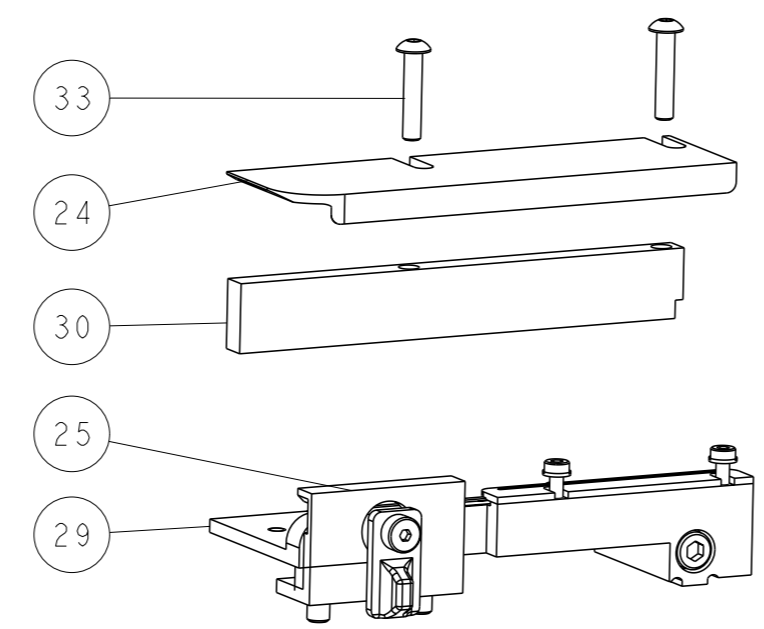
### CAM POSITIONS



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: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±		OWN: BOB HIGMAN 08JUL2014 CHK: G. BAILEY 08JUL2014 APVD: D. STOUGH 08JUL2014 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: A	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2266402 RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: A
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266402-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266402-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266402-4	-	-	-
	2-2266402-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266402-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266402-4	-	-	-
	2-2266402-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2266402-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266402-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	4.06 mm [1.60]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: HULANE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.35-5.11 mm [1.71-.201 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION NONE	-	-	-
TERMINALS APPLIED			
TE TERMINAL 2113518-1	HULANE TERMINAL 891507KSS	TE SEAL 2113500-1	HULANE SEAL 7165-33541
CABLE DIAMETER 1.6-2.1mm			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.42 +/- 0.05 [0.056 +/- .002]	6.8
0.85mm2	1.36 +/- 0.05 [0.053 +/- .002]	7.5
0.50mm2	1.20 +/- 0.05 [0.047 +/- .002]	9.0

- RECOMMENDED SPARE PARTS
- 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: 8-2266402-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266402-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266402-5
- 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. 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 13. APPLY TORQ-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.

**\*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	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-77	-27	-25	-22	-21	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)

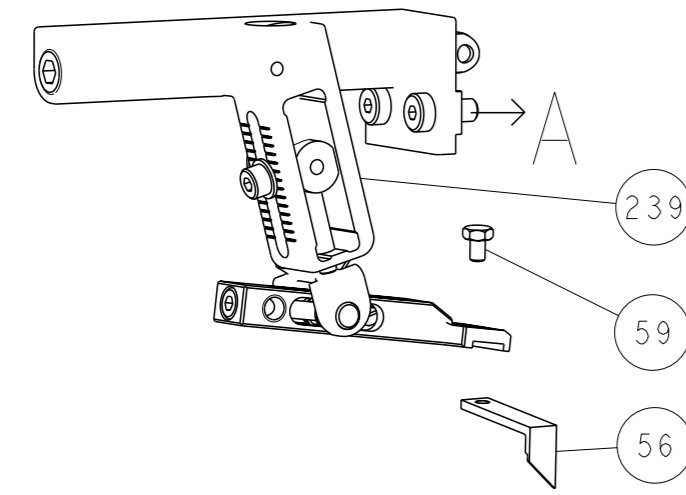
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119082-3	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	-	-	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	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	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	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	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	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
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	318563-1	GUARD, FRONT CHIP	89
-	1	1	1	1	455888-5	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	1	2119740-1	TAG, IDENTIFICATION	67
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	1	1	1338683-8	FEED PAWL	56
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	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	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	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1-1752356-7	SUPPORT, TERMINAL	34
-	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	1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	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	1-356885-4	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	3-1633919-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119781-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	3-2119784-1	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	-	-	2
-	1	1	1	1	7-456404-1	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

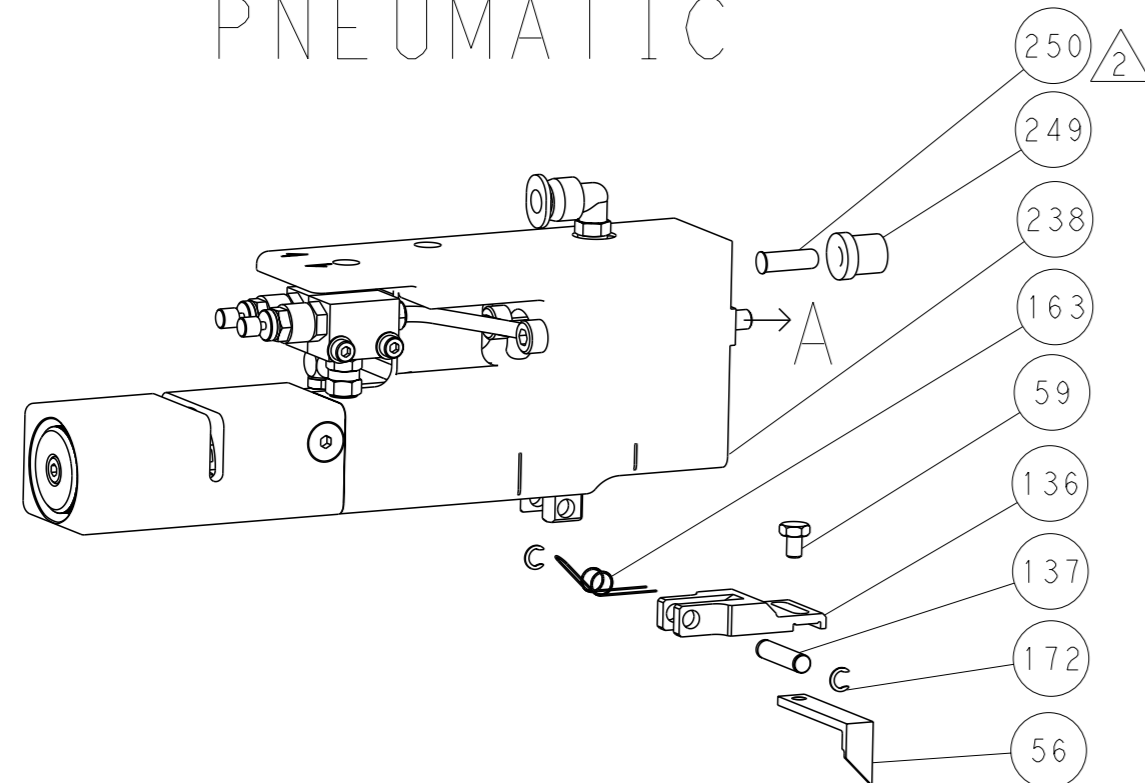
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE	NAME	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	ANGLES ±.1	APVD	D. STOUGH
MATERIAL		FINISH		APPLICATOR SPEC		WEIGHT		RESTRICTED TO
				A1		00779		Customer Accessible Production Drawing
				SCALE		SHEET		REV
				1:2		3 of 4		A

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-

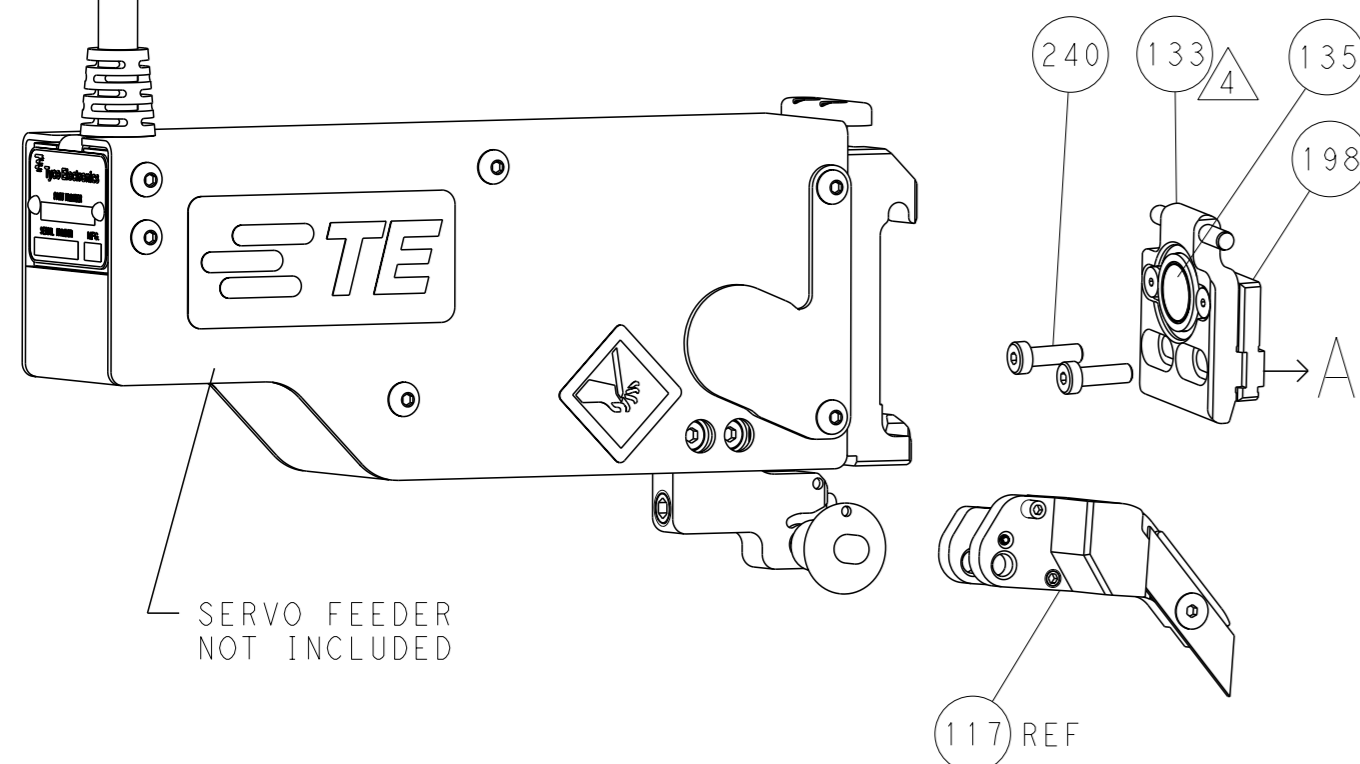
# FEED TYPE MECHANICAL



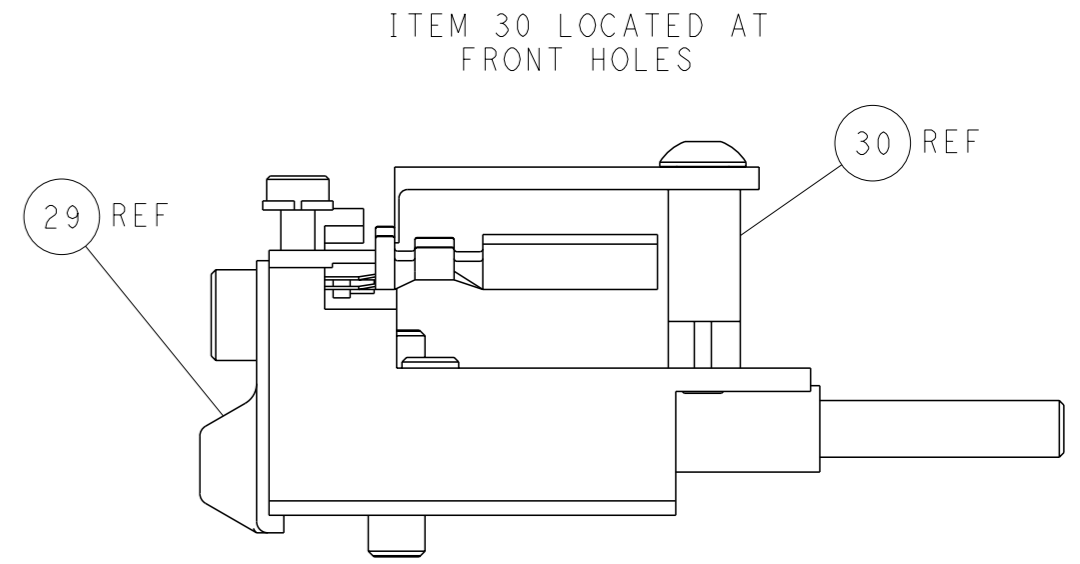
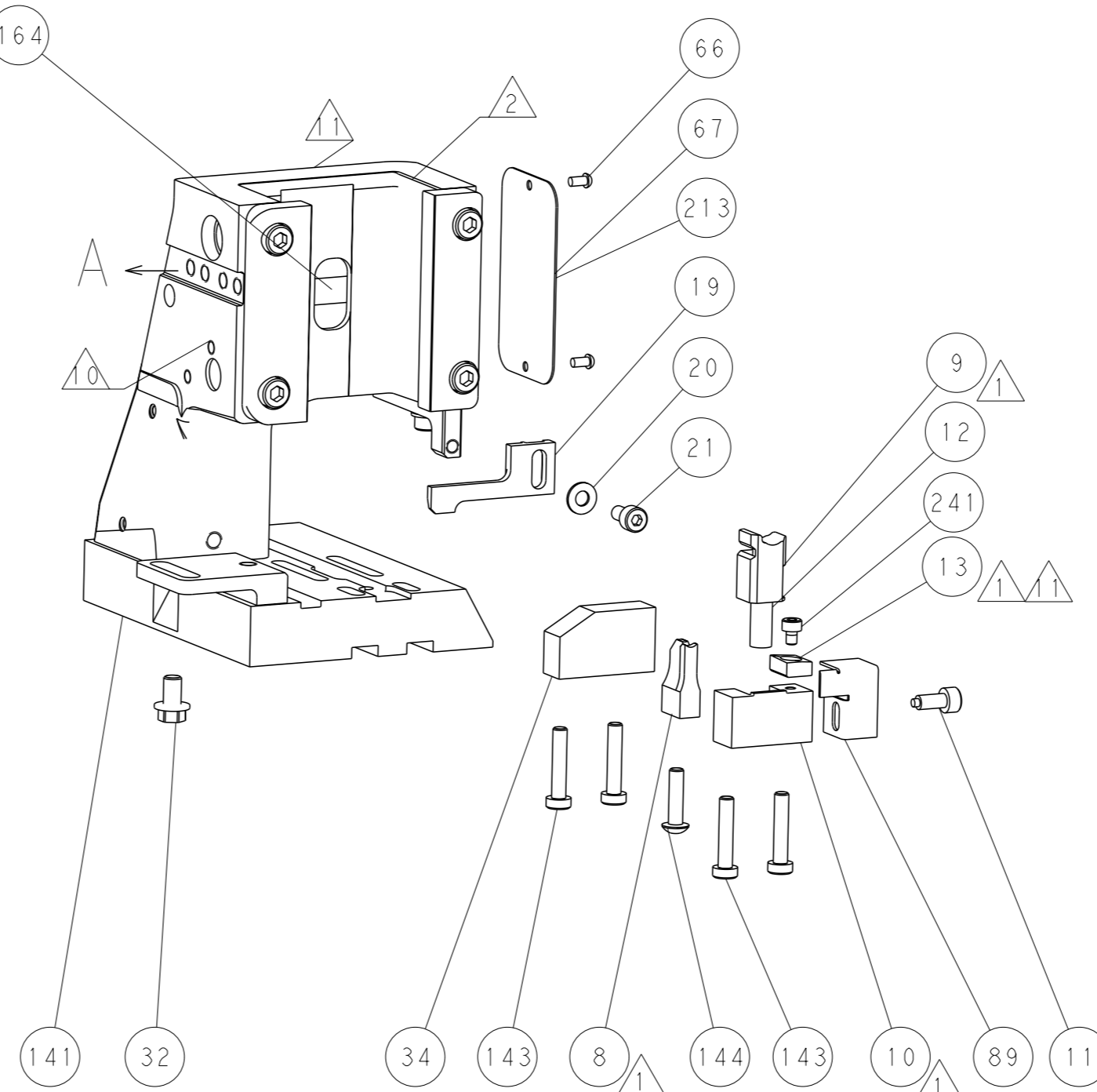
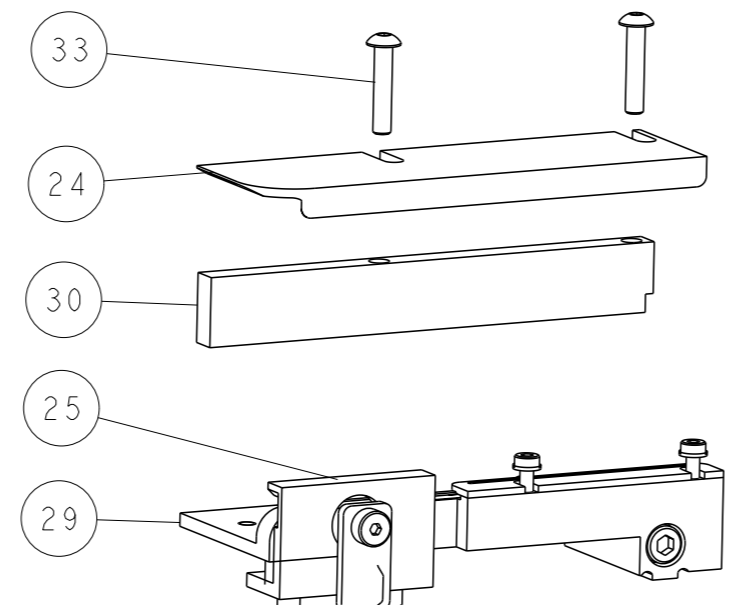
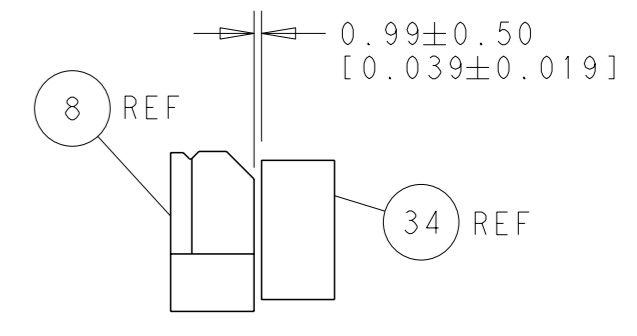
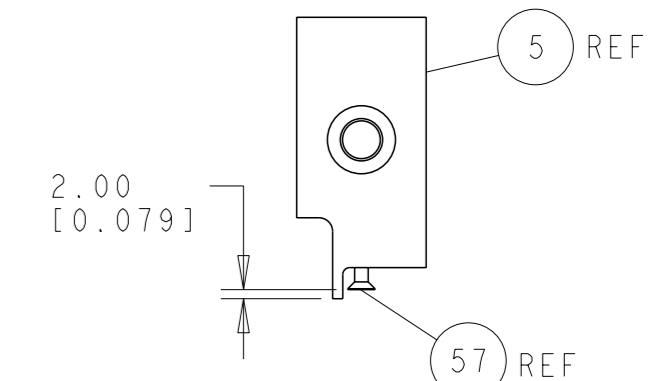
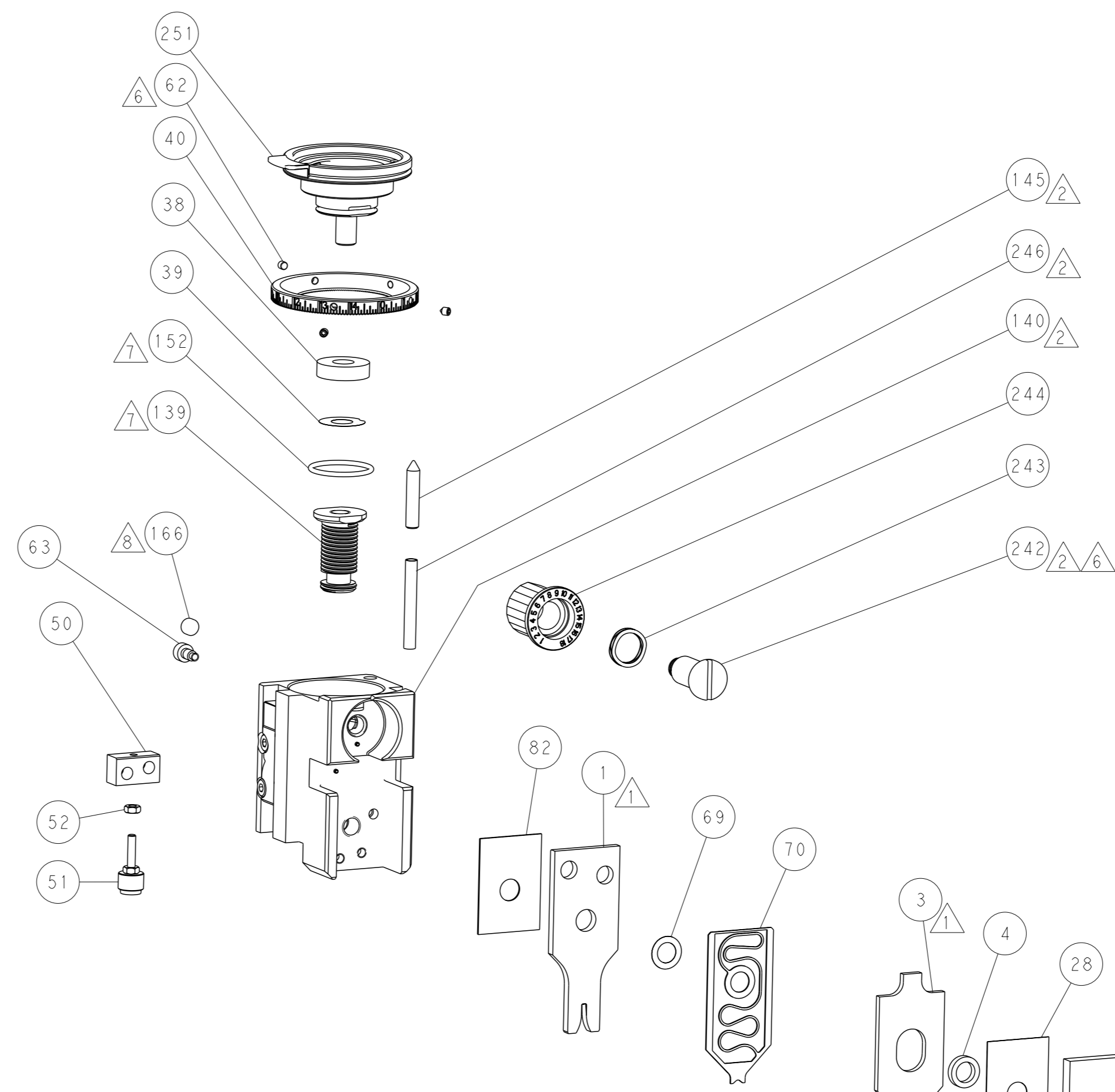
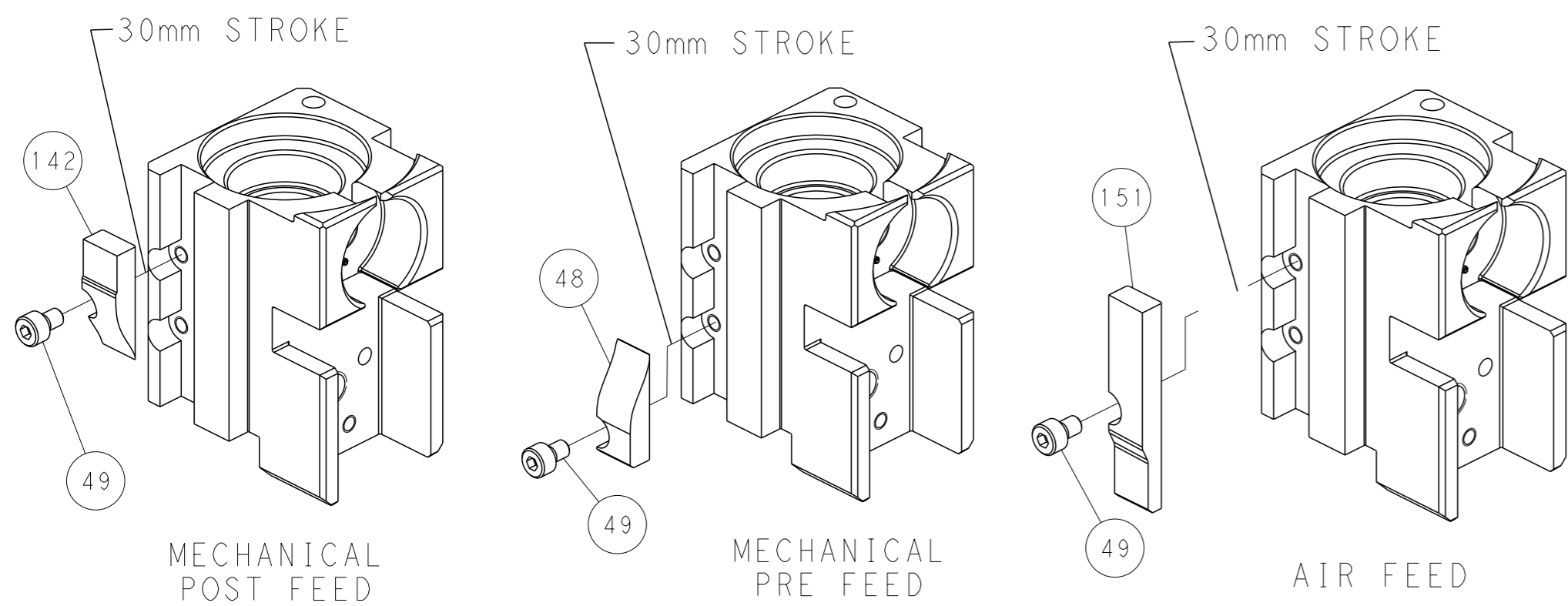
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: BOB HIGMAN 08JUL2014 CHK: G. BAILEY 08JUL2014 APVD: D. STOUGH 08JUL2014	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 FINISH ±.	APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	PRODUCT SPEC: - CAGE CODE: 00779 DRAWING NO: C=2266402	RESTRICTED TO: - SHEET 4 OF 4 REV A