

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2266379-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2266379-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2266379-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\Delta 4$
	2266379-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\Delta 4$
	2266379-7	B	FINE CRIMP HEIGHT ADJUST	NONE
	7-2266379-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MNL SOCKET 0.5-2.0 mm2			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.157-.187 IN [3.99-4.75 mm]		$\phi .060-.130$ IN [1.52-3.30 mm]	
TERMINAL APPLICATION SPECIFICATION	(A)114-1010 (B)114-1011	(C)114-1012 (D)114-5214	-

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 350536-1	(A) 350536-2	(A) 350536-3	(A) 350536-6
(A) 350536-7	(A) 350687-1	(A) 350687-2	(A) 350687-7
(A) 350687-8	(B) 350217-1	(B) 350218-1	(B) 350218-2
(B) 350218-3	(C) 61117-1	(C) 61117-2	(C) 61117-4
(C) 61117-5	(C) 61117-6	(C) 61117-7	(C) 61118-1
(C) 61118-2	(C) 61118-4	(C) 61118-5	(D) 170120-1
(D) 170120-4	(D) 917636-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.75 +/- 0.05 [.069 +/- .002]	3.8
2.00mm2	1.70 +/- 0.05 [.067 +/- .002]	4.2
1.50mm2	1.57 +/- 0.05 [.062 +/- .002]	5.7
16 AWG	1.50 +/- 0.05 [.059 +/- .002]	6.6
1.25mm2	1.45 +/- 0.05 [.057 +/- .002]	7.1
1.00mm2	1.40 +/- 0.05 [.055 +/- .002]	7.6
18 AWG	1.32 +/- 0.05 [.052 +/- .002]	8.5
0.75mm2	1.30 +/- 0.05 [.051 +/- .002]	8.7
0.50mm2	1.22 +/- 0.05 [.048 +/- .002]	9.5
20 AWG	1.19 +/- 0.05 [.047 +/- .002]	9.8

- 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: 8-2266379-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266379-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266379-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266379-6
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 ITEMS 62 & 180  
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242,  
 FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37 & 180.
- 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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT
13. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MNL SOCKET 0.5-2.0 mm2			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.157-.187 IN [3.99-4.75 mm]		$\phi .079-.130$ IN [2.01-3.30 mm]	
TERMINAL APPLICATION SPECIFICATION	(D)114-18011	-	-

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(D) 926882-1	(D) 926882-2	(D) 926882-3	(D) 926882-4
(D) 926882-7	(D) 926883-1	(D) 926883-3	(D) 926883-4
(D) 926883-5	(D) 926883-6	(D) 926883-7	(D) 926883-8
(D) 926887-1	(D) 926887-3	(D) 926887-4	(D) 926887-6
(D) 926887-7	(D) 927965-1	(D) 927965-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.73 +/- 0.05 [.068 +/- .002]	3.8
2.00mm2	1.70 +/- 0.05 [.067 +/- .002]	4.2
1.50mm2	1.53 +/- 0.05 [.060 +/- .002]	5.7
16 AWG	1.47 +/- 0.05 [.058 +/- .002]	6.6
1.25mm2	1.45 +/- 0.05 [.057 +/- .002]	7.1
1.00mm2	1.37 +/- 0.05 [.054 +/- .002]	7.6
18 AWG	1.30 +/- 0.05 [.051 +/- .002]	8.5
0.75mm2	1.30 +/- 0.05 [.051 +/- .002]	8.7
0.50mm2	1.21 +/- 0.05 [.048 +/- .002]	9.5
20 AWG	1.21 +/- 0.05 [.048 +/- .002]	9.8

-	-	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
-	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	2119082-4	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
-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)

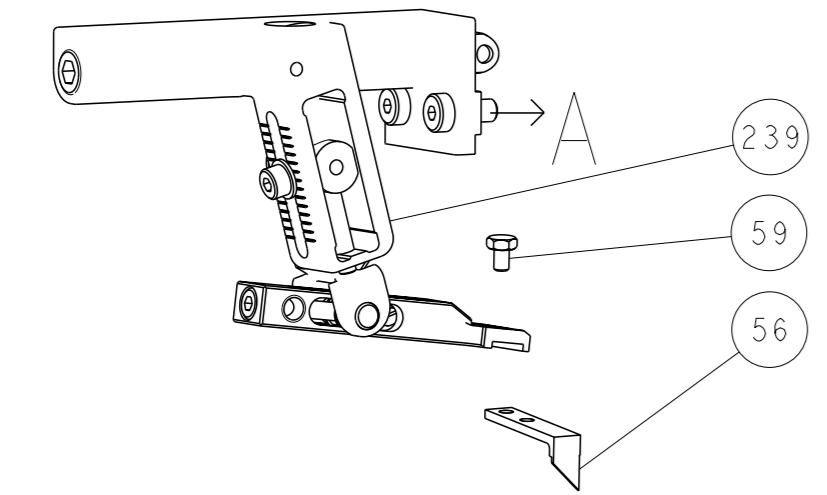
SET UP GAUGE		LOC	DIST	REVISIONS	
2119599-1		A	66		
P	LT#	DESCRIPTION	DATE	OWN	APVD
B		ECR-15-015796	28OCT2015	YY	TE
B1		ECR-18-003900	30APR2018	LG	JD

-	1	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	182
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	1	1	1	1	1	1-1752354-9	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	-	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
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
-	1	1	1	1	1	690438-1	FRONT STRIP GUIDE	95
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	5-547505-2	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	2119791-5	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 X 4.0	62
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	2-2119656-1	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	1-2119644-2	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	3-1752356-4	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	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	980371-1	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	8-1333205-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	6-240641-3	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1633962-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	1	3-456406-3	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

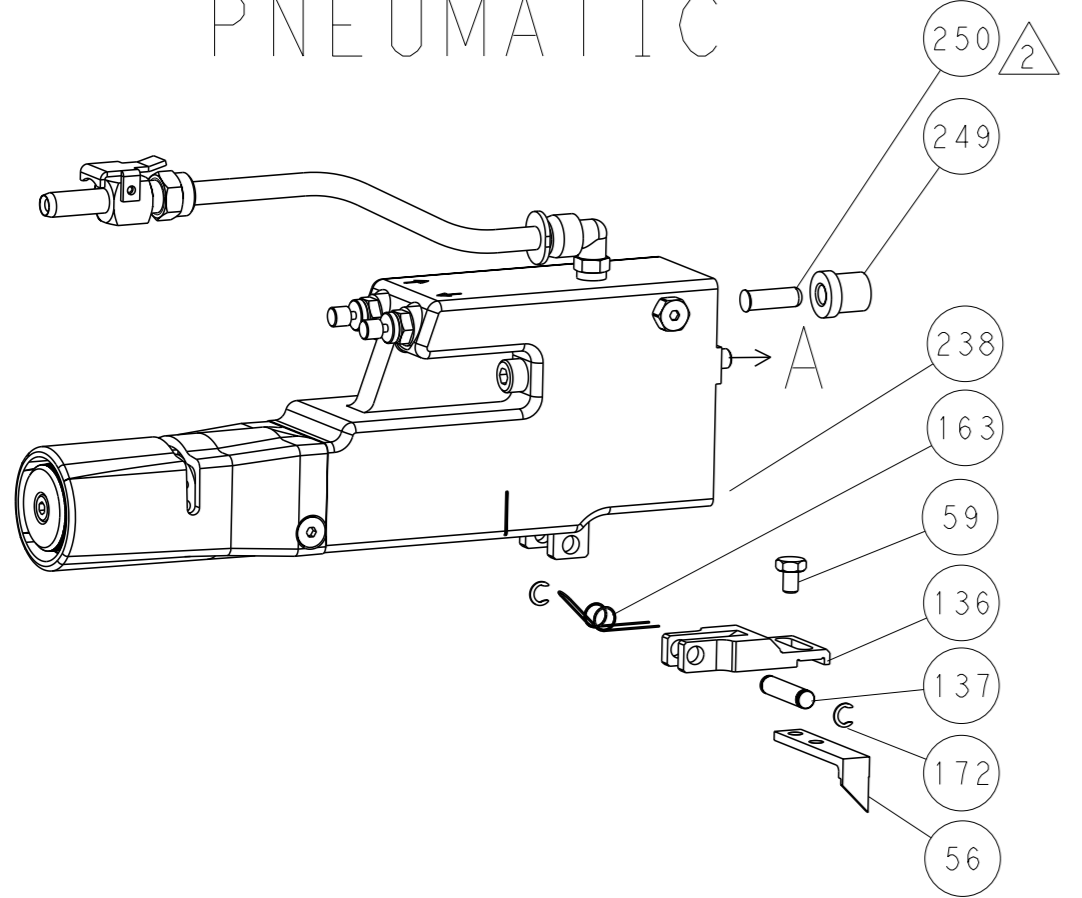
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mm	0 PLC ± .5	1 PLC ± .13	2 PLC										

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

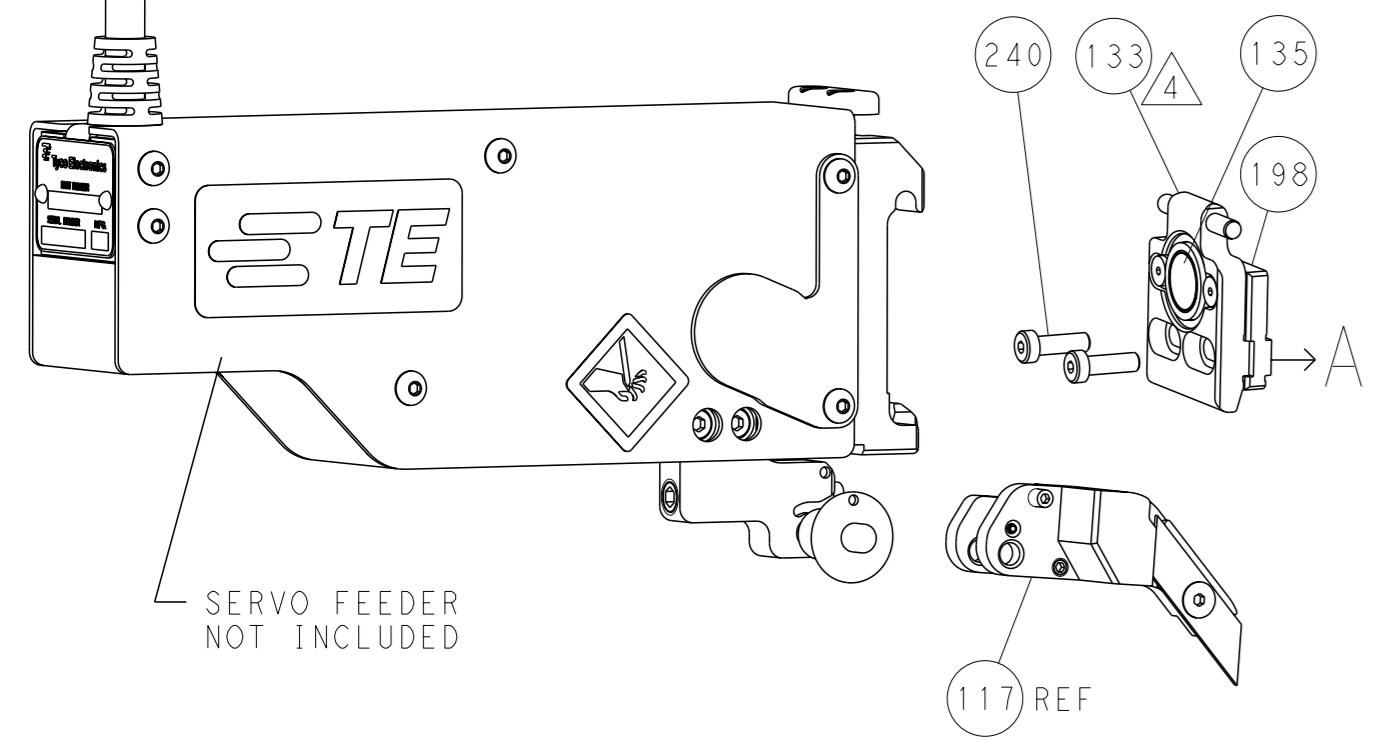
### FEED TYPE MECHANICAL



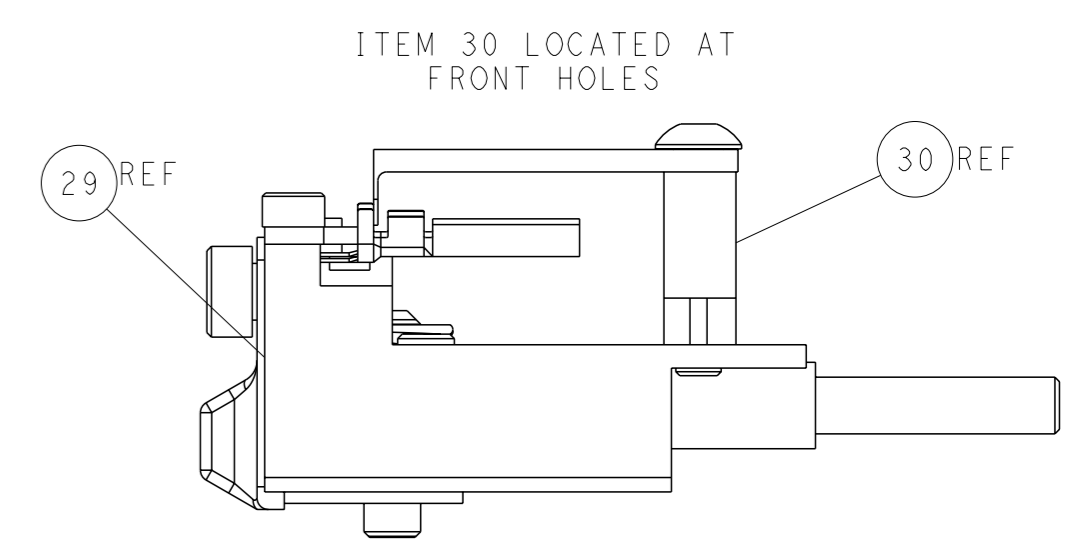
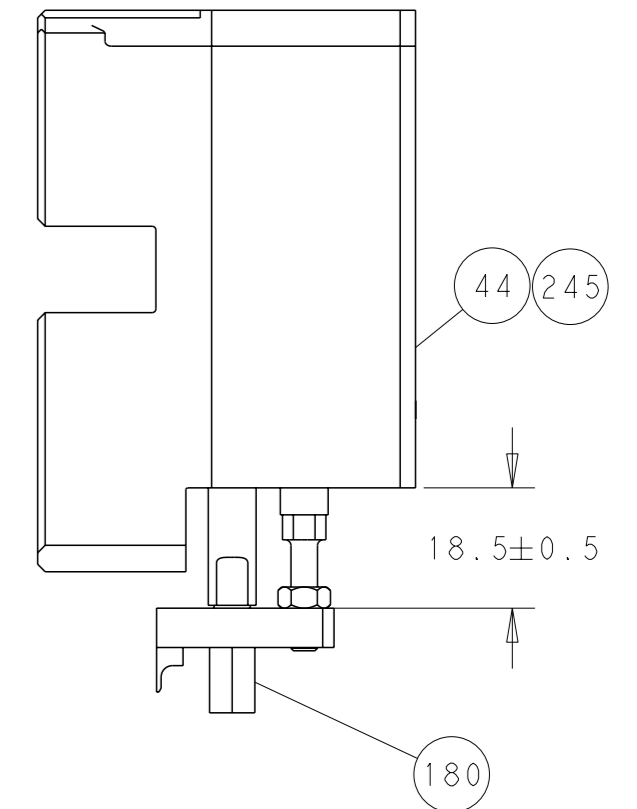
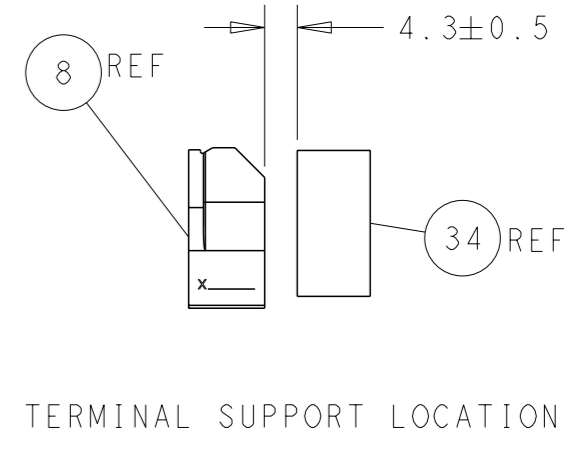
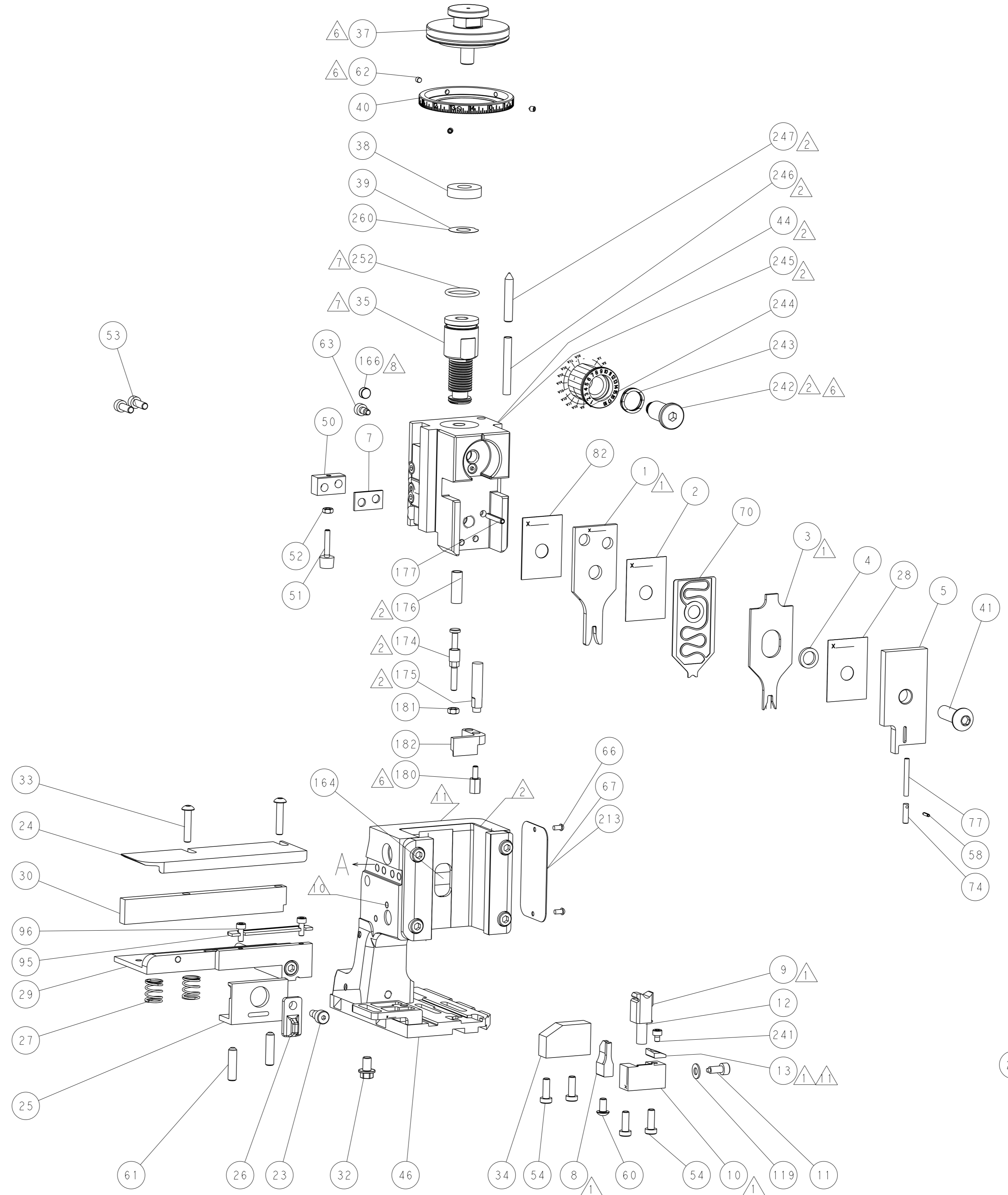
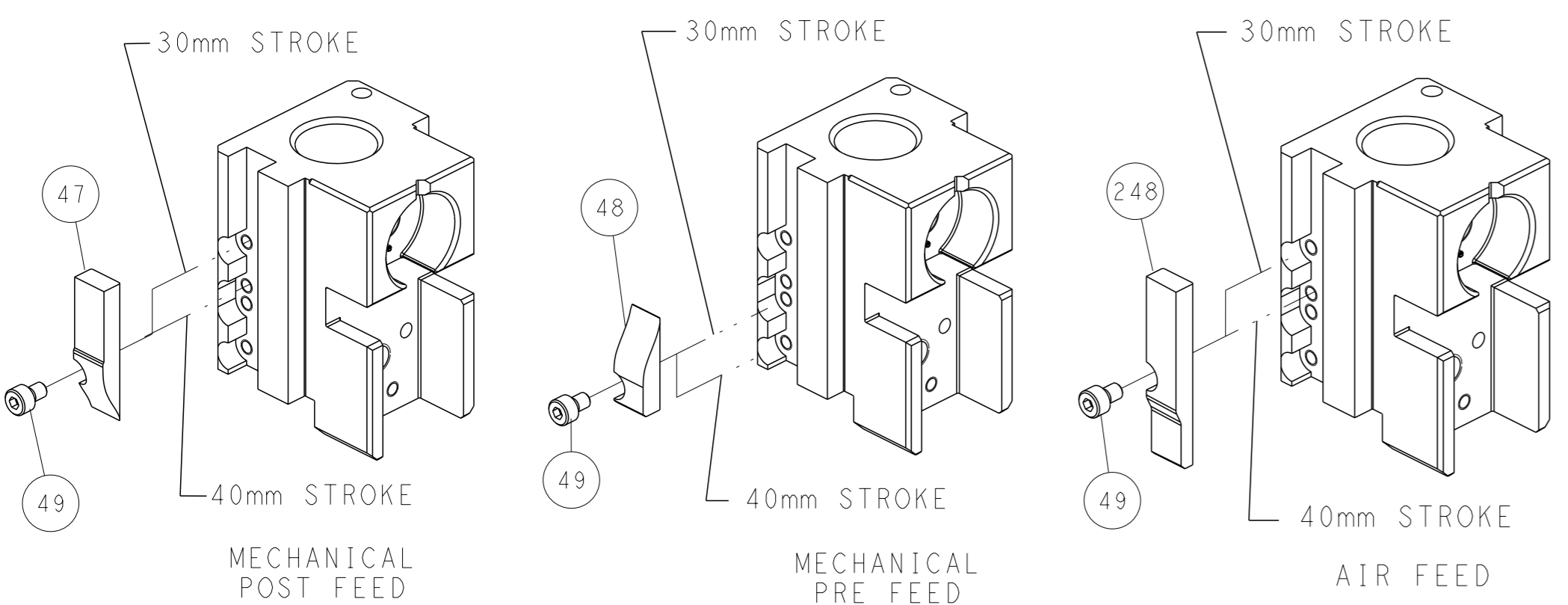
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



**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 ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0013 ANGLES ±.1		OWN: H. HUANG 03DEC2014 CHK: L. ZHANG 03DEC2014 APVD: W. GUO 03DEC2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266379 SCALE: 1:2 SHEET: 2 of 4 REV: B1		TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO	
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Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE. Includes a diagram of the applicator and various revision entries.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes wire and insulation specifications.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION table. Includes terminal name, wire strip length, and application specifications.

TERMINALS APPLIED table with columns: TE TERMINAL, TE TERMINAL, TE TERMINAL, TE TERMINAL. Lists various terminal part numbers.

Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Lists crimp height settings for various wire sizes.

- 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 ITEMS 62 & 180.
GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
MAGNET 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 BACK SIDE OF THE HOUSING.
THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION table. Includes terminal name, wire strip length, and application specifications.

TERMINALS APPLIED table with columns: TE TERMINAL, TE TERMINAL, TE TERMINAL, TE TERMINAL. Lists various terminal part numbers.

Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Lists crimp height settings for various wire sizes.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various spare parts and their descriptions.

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 table. Includes setup gauge information and revision details.

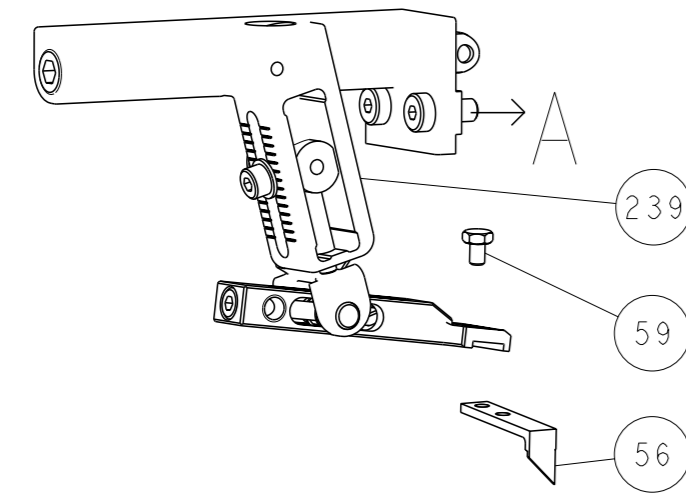
Large table with columns: QTY, LTR, DESCRIPTION, DATE, QTY, QTY. Lists various components and their quantities.

STE logo and product information: Ocean Side Feed Applicator. Includes dimensions, tolerances, and material specifications.

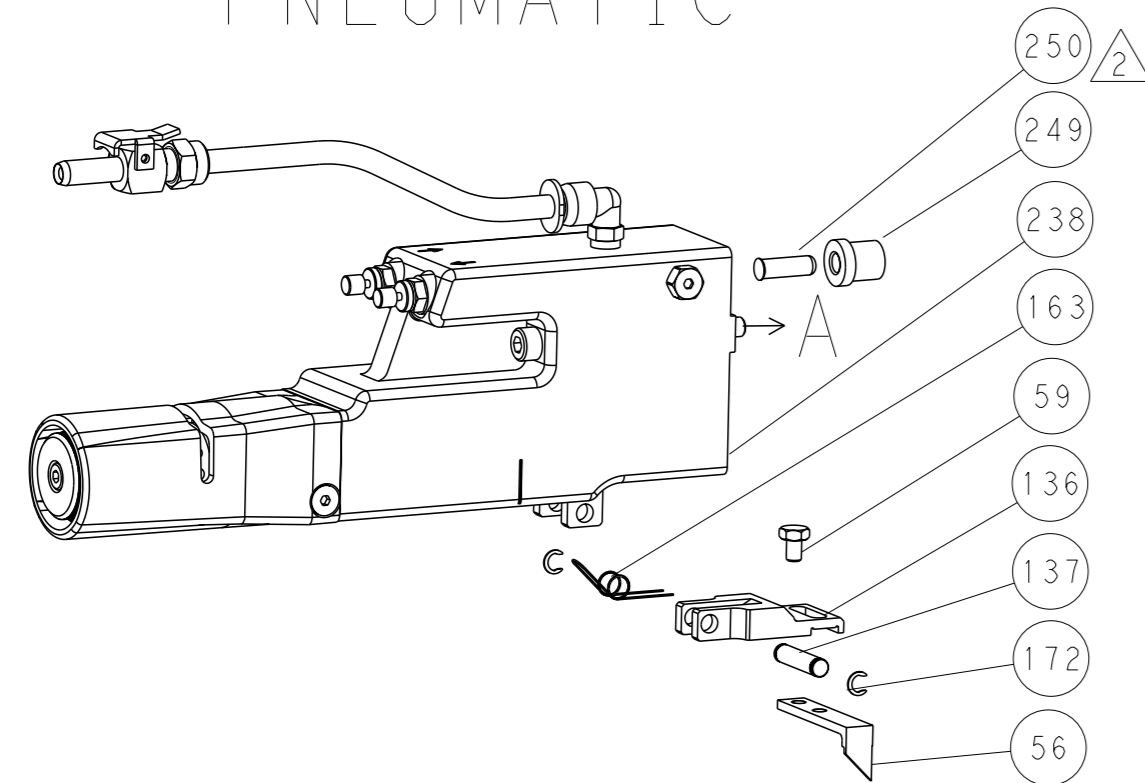


REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LYR			
		DESCRIPTION		
		SEE SHEET 1		

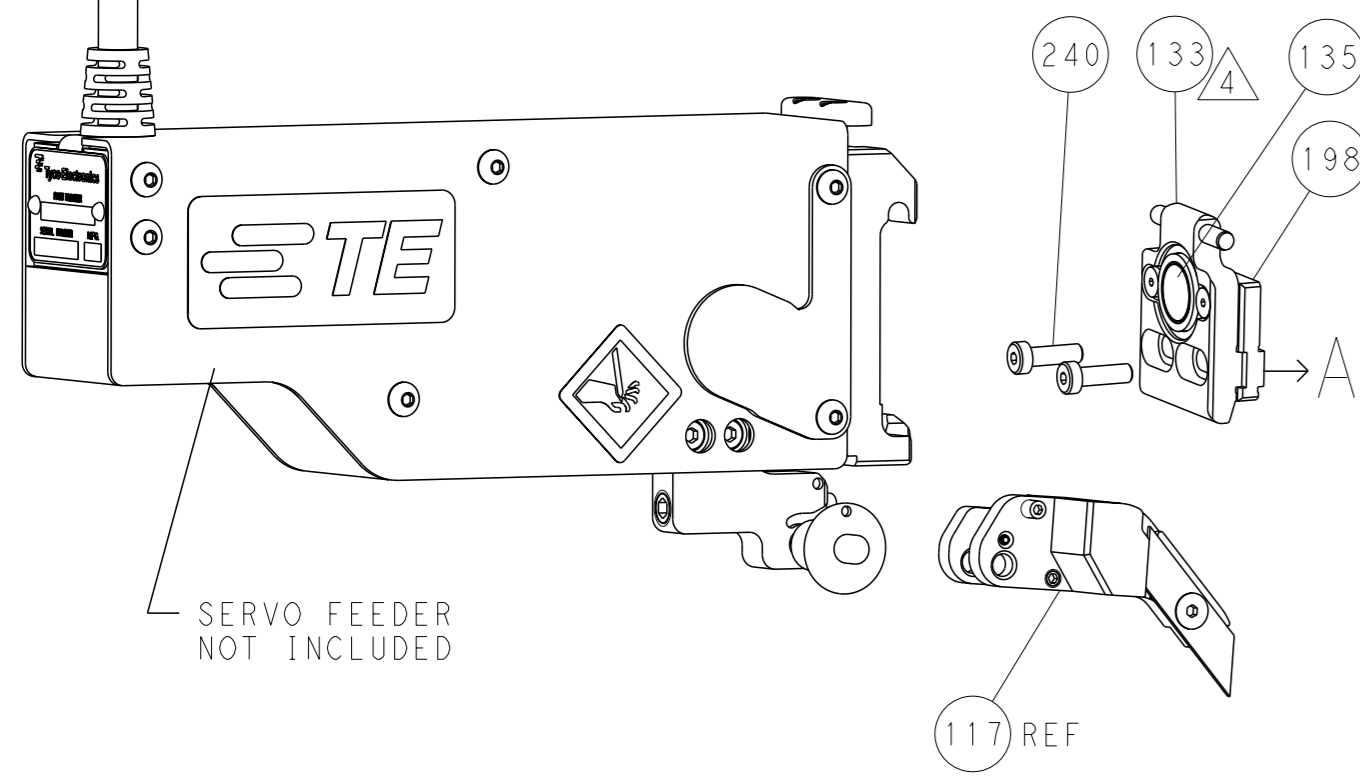
# FEED TYPE MECHANICAL



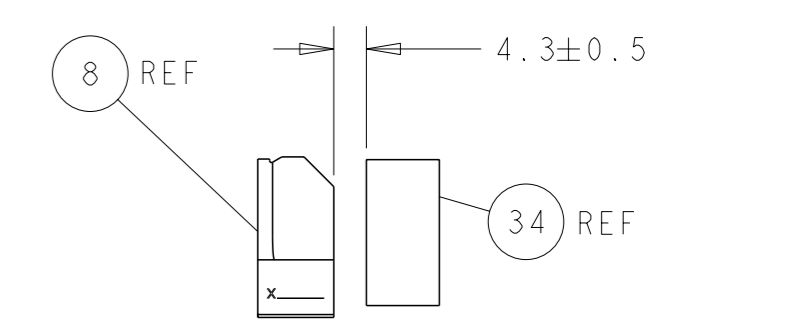
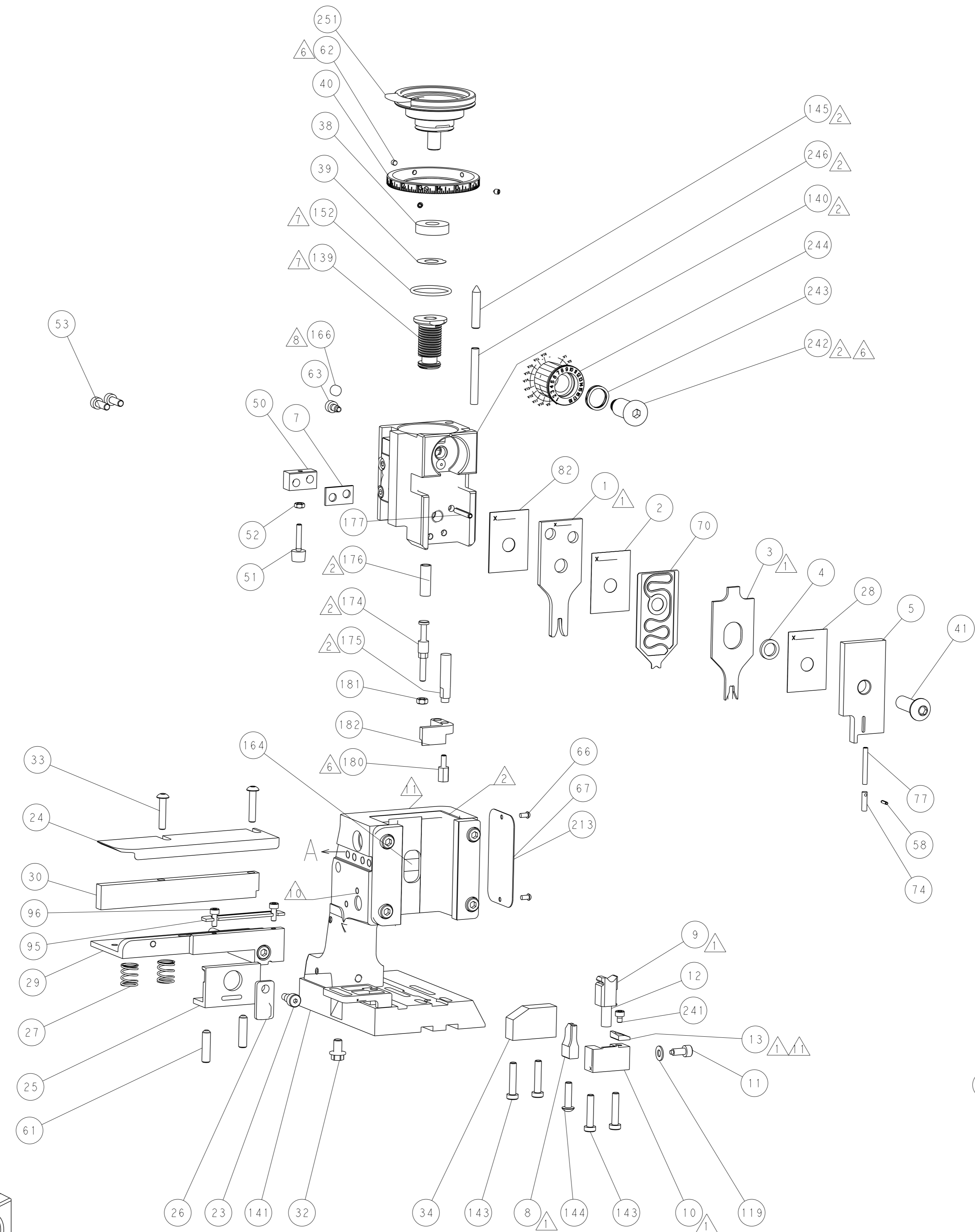
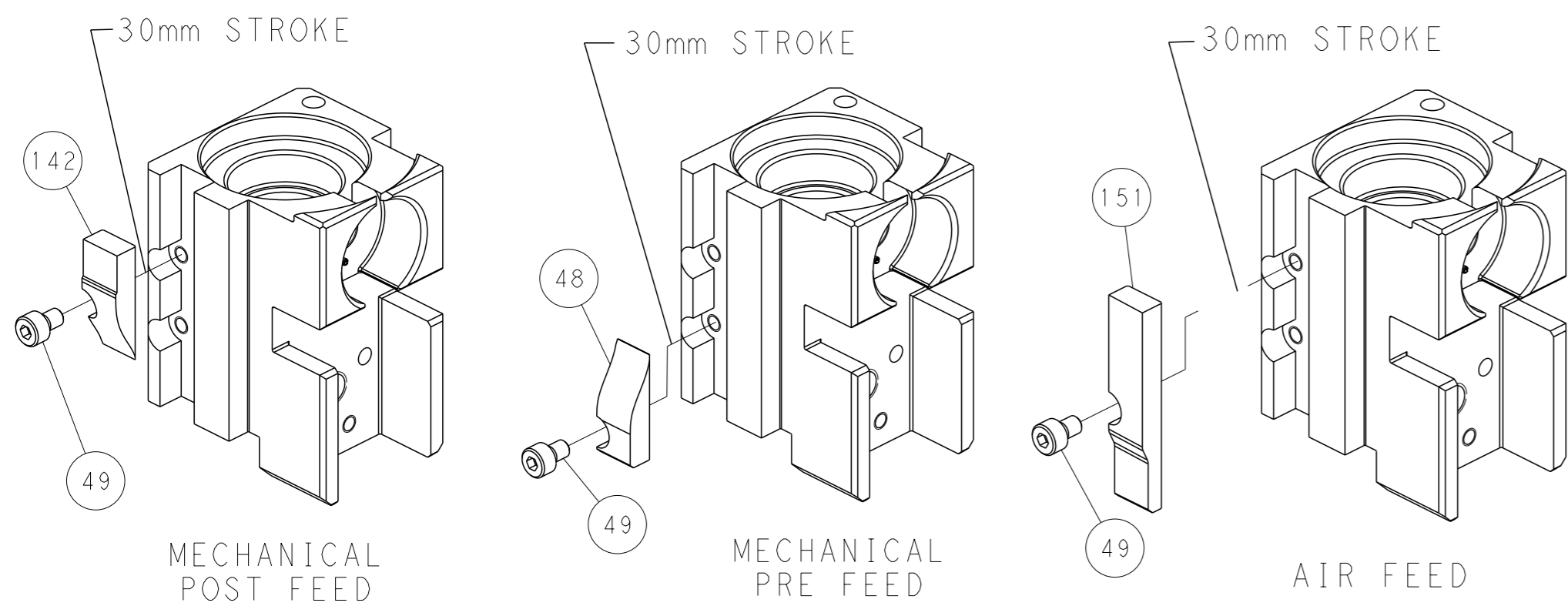
# PNEUMATIC



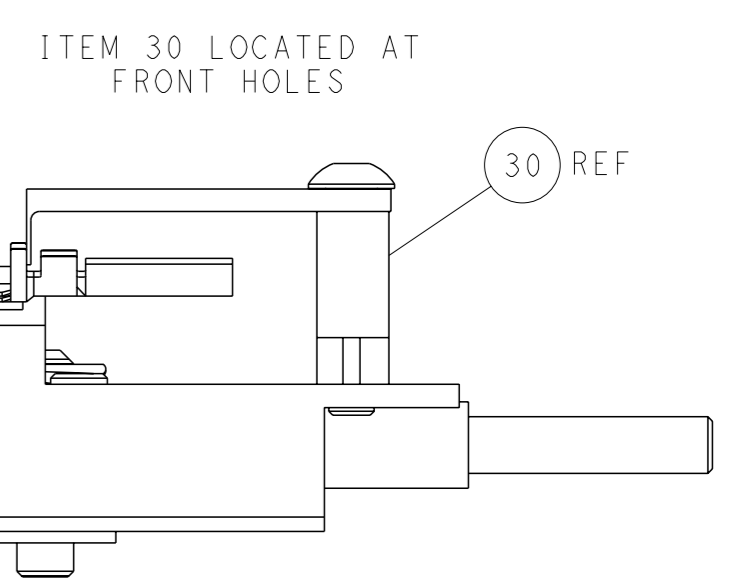
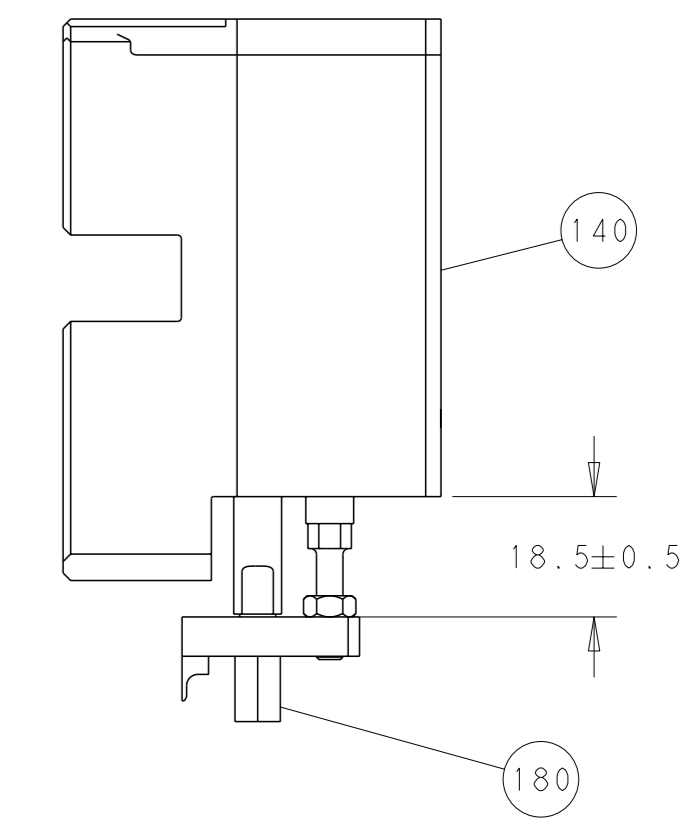
# SERVO LATCH PLATE



# 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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO PATENT AND ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN H. HUANG CHK L. ZHANG APVD J. GUO	03DEC2014 03DEC2014 03DEC2014	NAME Ocean Side Feed Applicator	SIZE A1	CAGE CODE 00779	DRAWING NO. C=2266379	RESTRICTED TO -
DIMENSIONS: mm 0 PLC ±.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH		TOLERANCES UNLESS OTHERWISE SPECIFIED: ±.5 ±0.13 ±0.013 ±0.0001		PRODUCT SPEC -		APPLICATION SPEC -		WEIGHT -
MATERIAL -		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2		SHEET 4 OF 4		REV B1