

REV	DATE	DESCRIPTION	BY	CHKD
A	27JAN2015	RELEASED	RW	GB

SET UP GAUGE 2119599-1  
 LOC A  
 DIST 66

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2266609-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
	2266609-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	SERVO LATCH PLATE 2119951-1	-	8-2266609-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2266609-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 12	SMART APPLICATOR 2161326-1	-	8-2266609-4	-	-	-
	2266609-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-
	7-2266609-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 4.06 mm [ .160 ]	F	
INSUL 5.23 mm [ .206 ]	O	
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: DELPHI TERMINAL VW CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE, DUCON 9, 5x12			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.05-6.81 mm [ .238-.268 IN ]		Ø3.40-4.30 mm [ .134-.169 IN ]	
TERMINAL APPLICATION SPECIFICATION	N907572		
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1949655-1	10724458	404711	N90757201

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm <sup>2</sup>	3.00 +/- 0.05 [ .118 +/- .002 ]	5.7
4.00mm <sup>2</sup>	2.65 +/- 0.05 [ .104 +/- .002 ]	9.1



- 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: 8-2266609-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266609-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266609-6
- 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. 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 ITEMS 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 2.80.

**\*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.

ITEM NO	DESCRIPTION	ITEM NO
269	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
267	FENCE	267
260	APPLICATOR SHIM PACK	260
259	SPACER, PRECISION	259
252	O-RING, .676 ID, .070 DIA. MAT.	252
250	PUSH ROD, AIR FEED	250
249	BUSHING, LCH5-12, MISUMI	249
248	FEED CAM, AIR FEED	248
247	DETENT PIN	247
246	SPRING, COMPRESSION	246
ITEM NO	DESCRIPTION	ITEM NO

6

6

6

1

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1

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1

ITEM NO	DESCRIPTION	ITEM NO
245	RAM, STEPPED, ATLANTIC, SF, NON-ADJ	245
244	CAM, SNAIL, INSULATION ADJUSTMENT	244
243	WASHER, WAVE SPRING, CREST-TO-CREST	243
242	RETAINER, INSULATION DIAL	242
241	SCR, SKT HD CAP M3 X 4.0	241
240	SHCS, LOW HEAD, RoHS, M5 X 16	240
238	AIR FEED MODULE	238
213	TAG, IDENTIFICATION	213
198	SPACER, FEEDER	198
172	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
166	MAGNET, RARE EARTH HIGH ENERGY	166
164	COUNTER, MAGNETIC	164
163	SPRING, FEED FINGER	163
137	PIN, RETAIN, GRVD, 3/16 X .854	137
136	HOLDER, FEED FINGER, AF	136
135	MEMORY CHIP, PROGRAMMED	135
133	SERVO FEED LATCH ASM	133
117	FEED FINGER ASSEMBLY, SF	117
96	FRONT STRIP GUIDE	96
95	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
82	SPACER, CRIMPER	82
79	SCR, BHSC, RoHS (M4 X 8)	79
78	EXTENSION PLATE	78
71	DOCUMENTATION PACKAGE	71
67	TAG, IDENTIFICATION	67
66	SCREW, DRIVE, RH, RoHS, 2 x .188	66
63	LIMITER, ADJUSTMENT BOLT	63
62	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
61	SCR, SET, FLT POINT M5 X 20.0	61
60	SCR, BHSC, RoHS (M4 X 8)	60
59	SCR, HEX HD CAP, M4 X 6.0	59
56	FEED PAWL	56
54	SHCS, LOW HEAD, RoHS, M4 X 12	54
53	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
52	NUT, HEX, REG, RoHS, M3	52
51	BUMPER, HOLD DOWN	51
50	SPACER, TONKER	50
49	SCR, SKT HD CAP M4 X 6.0	49
46	APPLICATOR BASIC ASSEMBLY, SF	46
44	RAM, STEPPED, AMP STYLE, SIDE FEED	44
41	SCR, BHSC, RoHS (M8 X 25)	41
40	DISC, NUMBERED FA WIRE ADJUSTMENT	40
39	APPLICATOR SHIM PACK	39
38	RAM WASHER, PRECISION	38
37	FA HEAD, ATLANTIC STYLE	37
35	BOLT, ADJUSTMENT	35
34	SUPPORT, TERMINAL	34
33	SCR, BHSC, RoHS (M4 X 20)	33
32	HEX HEAD, FLANGED, M5 X 8mm LONG	32
30	SPACER, STRIP GUIDE	30
29	ASSEMBLY, STRIP GUIDE	29
28	SPACER, CRIMPER	28
27	SPRING, COMPRESSION	27
26	LEVER, DRAG RELEASE	26
25	DRAG, TERMINAL	25
24	STRIP GUIDE	24
23	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
21	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
20	WASHER, FLAT, REG M4	20
19	STRIPPER, SIDE FEED	19
13	INSERT, SHEAR	13
12	SPRING, COMPRESSION	12
11	STOP, SHEAR	11
10	SHEAR HOLDER, FRONT	10
9	FLOATING SHEAR, FRONT	9
8	ANVIL, COMBINATION	8
7	SPACER	7
6		6
5	DEPRESSOR, SHEAR	5
4	BLOCK, CRIMPER SPACER	4
3	CRIMPER, INSULATION O PREMIUM	3
2	SPACER, CRIMPER	2
1	CRIMPER, WIRE	1
ITEM NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
mm	0 PLC ± .5	APPROX	15DEC2014
	1 PLC ± 0.5	PRODUCT SPEC	
	2 PLC ± 0.13	APPLICATION SPEC	
	3 PLC ± 0.013		
	4 PLC ± 0.001		
	ANGLES ± .5		
MATERIAL:		WEIGHT:	SCALE
-		Customer Accessible Production Drawing	1:2

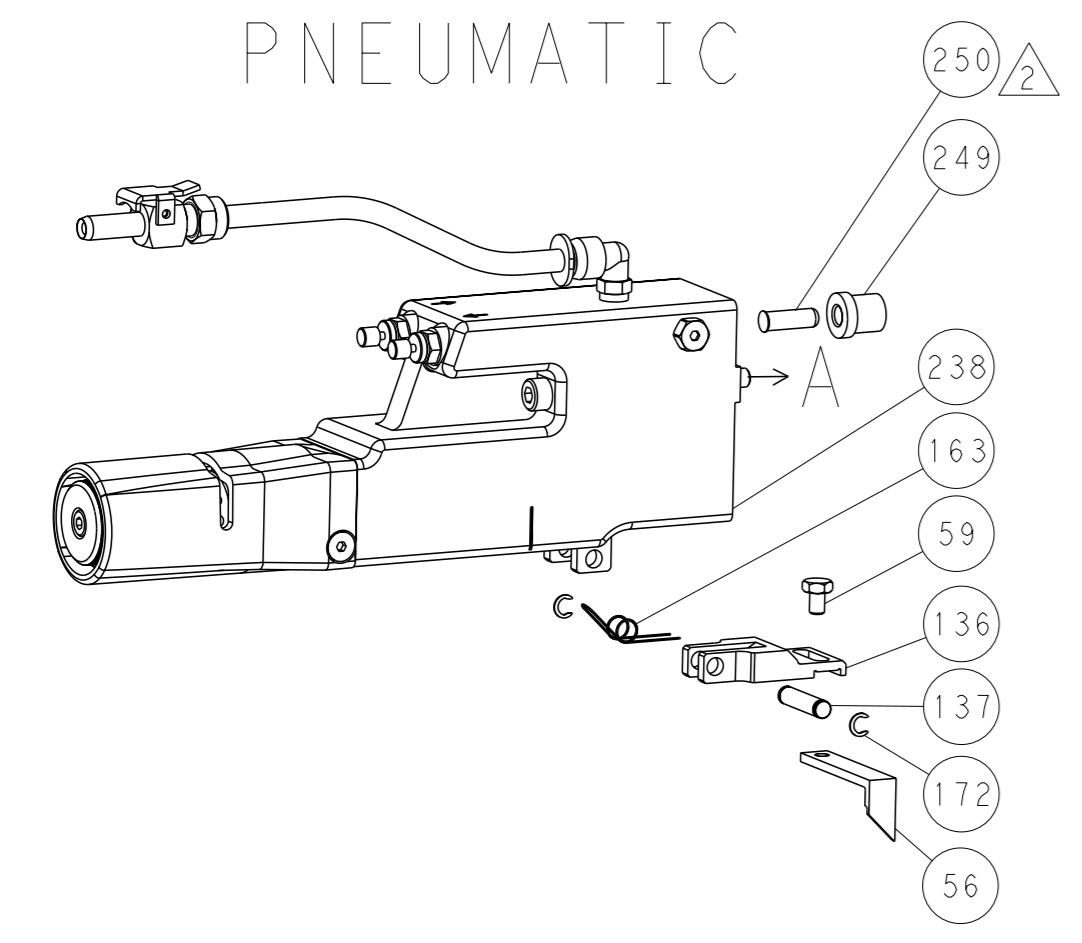
NAME: Ocean Side Feed Applicator  
 SIZE: A1  
 SHEET 1 OF 4  
 REV A

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

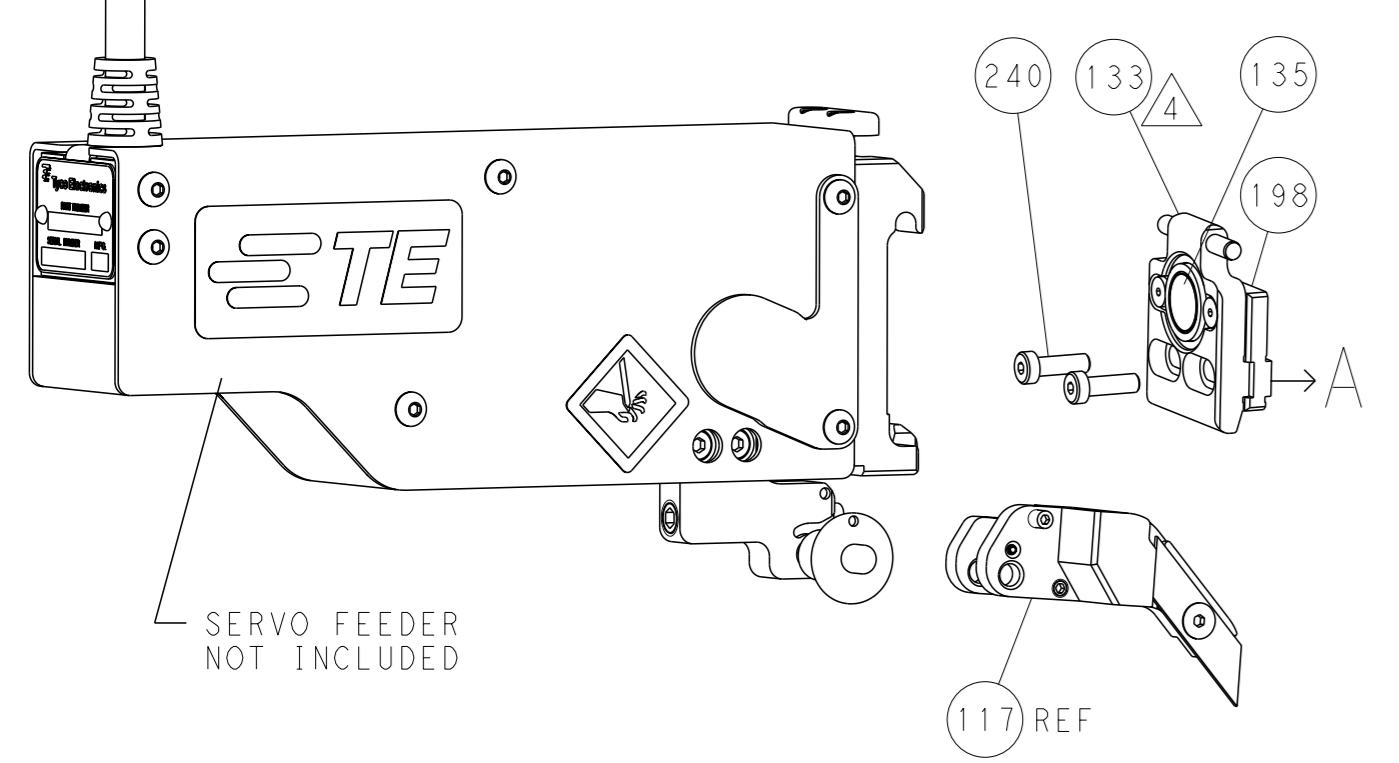
LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

### FEED TYPE

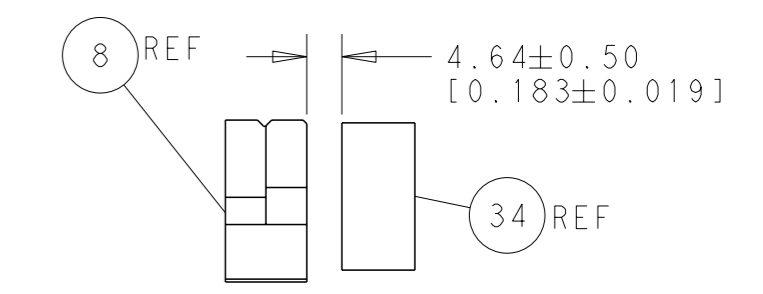
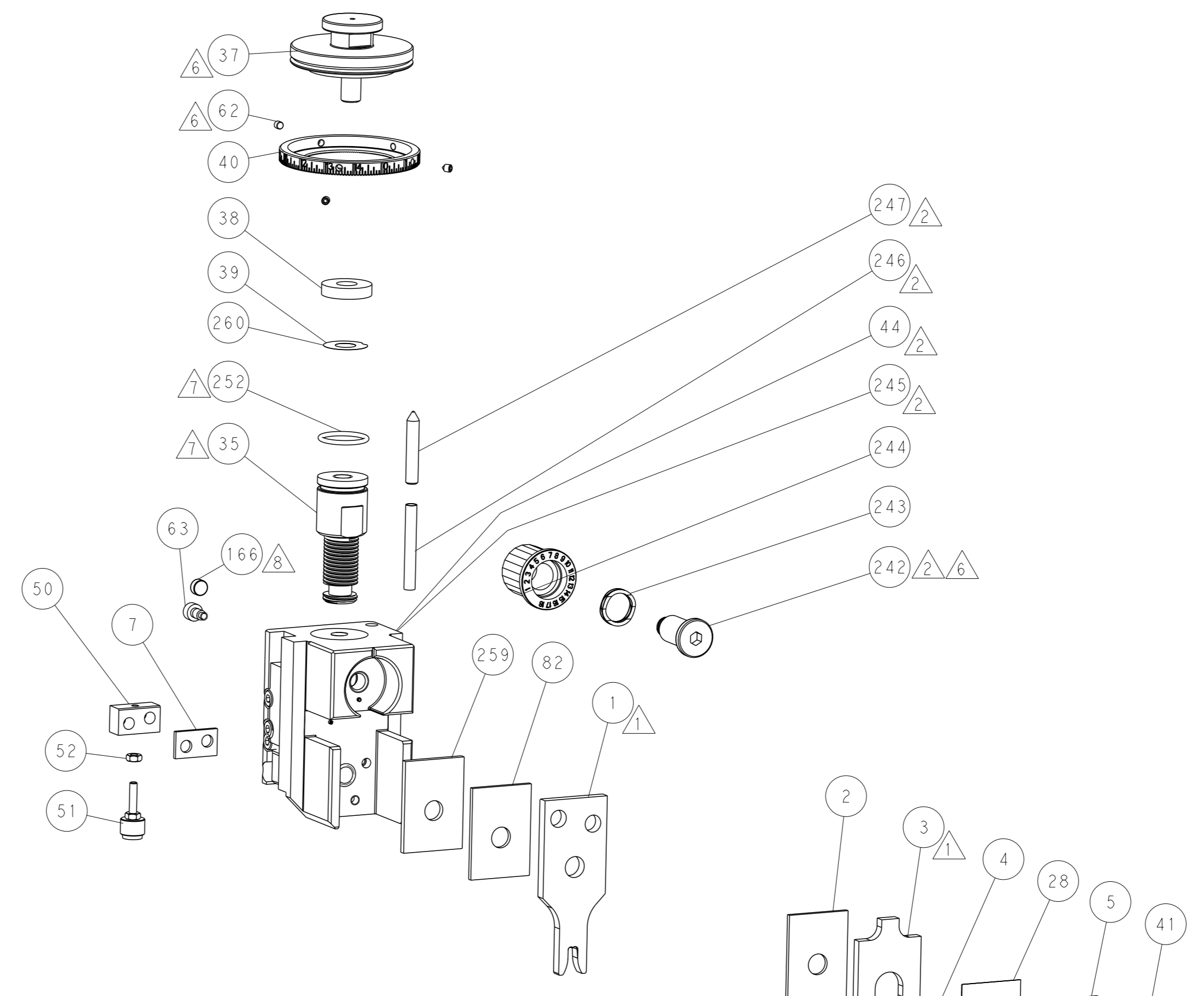
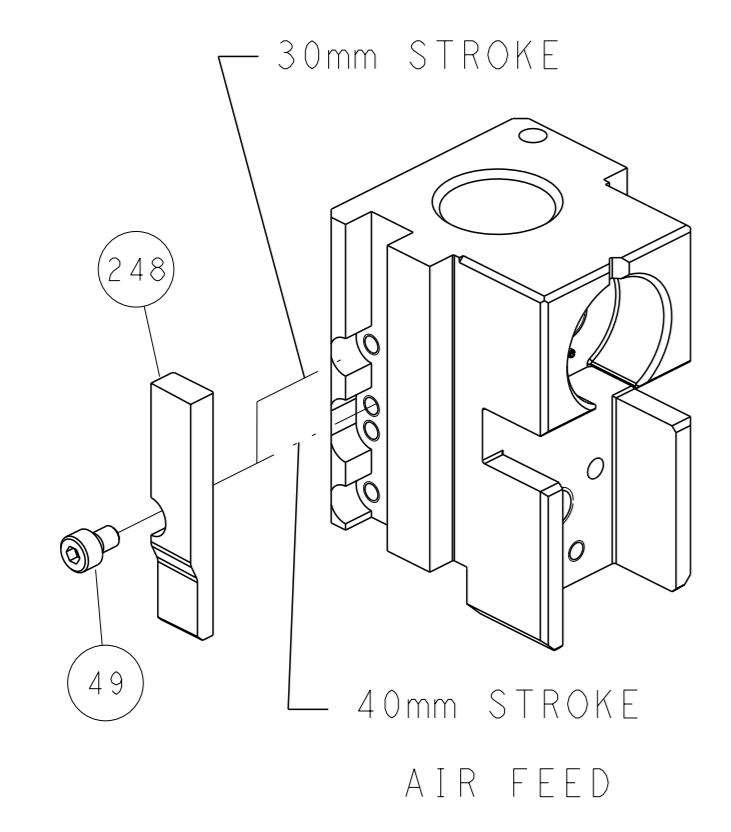
### PNEUMATIC



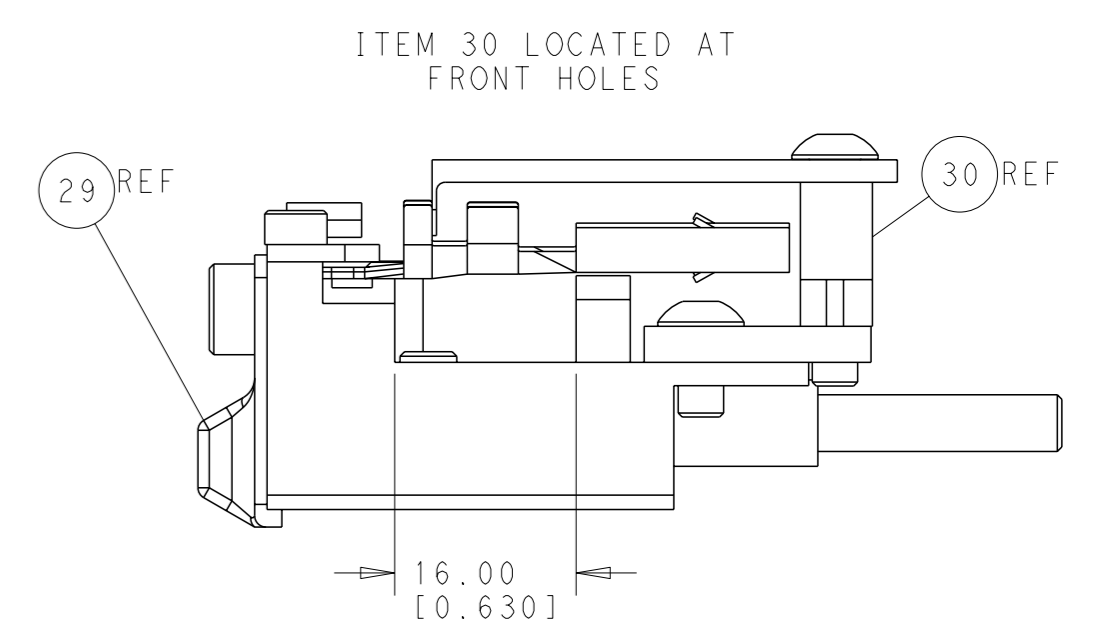
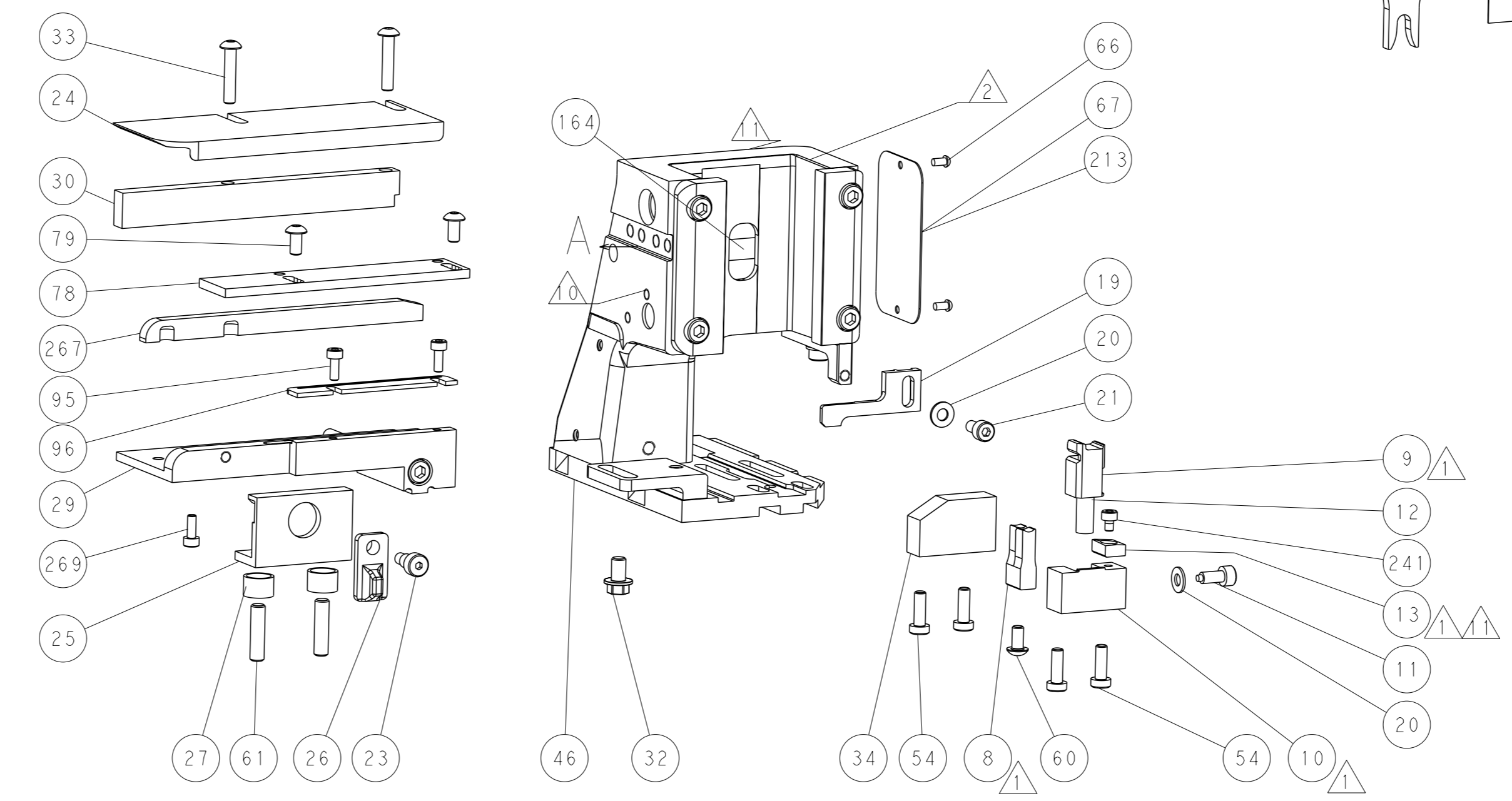
### SERVO LATCH PLATE



### CAM POSITION



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

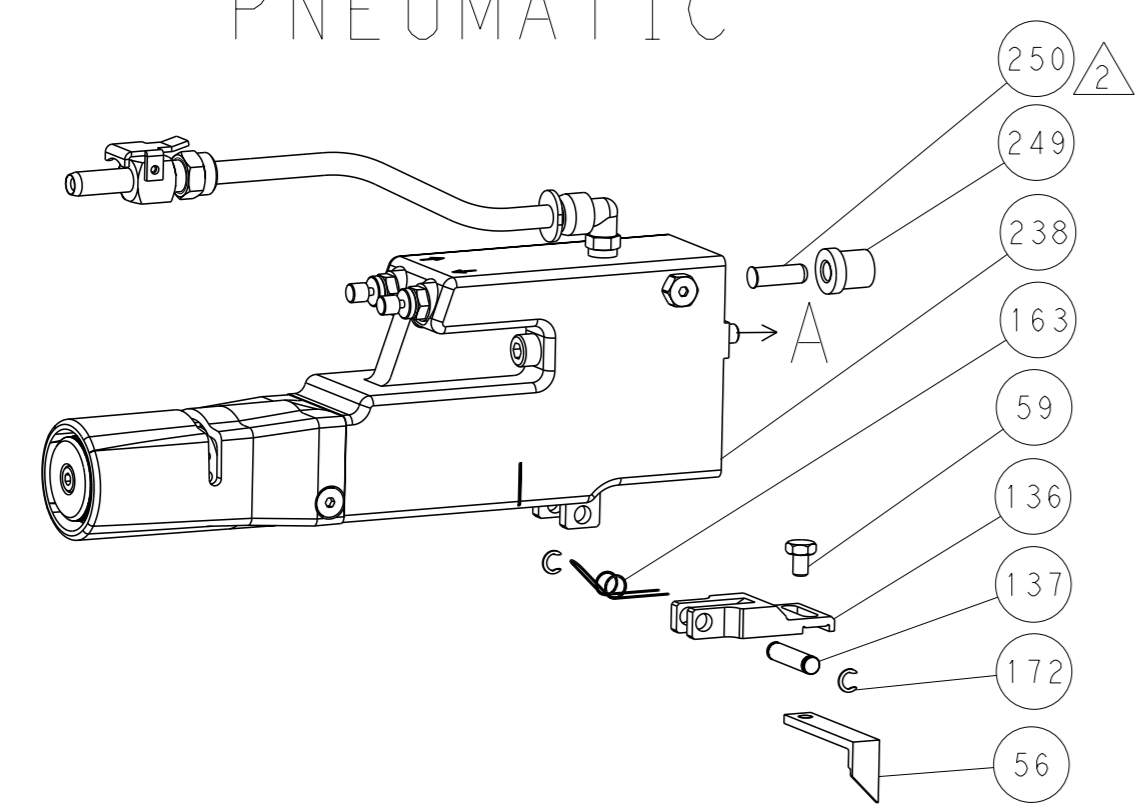
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: R. O. WILSON CHK: K. J. STAKEM APVD: J. L. ELBIN	DATE: 12DEC2014 DATE: 15DEC2014 DATE: 15DEC2014	NAME: Ocean Side Feed Applicator	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.001 4 PLC ±0.001 ANGLES FINISH: ±	MATERIAL:	WEIGHT:	SCALE: 1:2 SHEET: 2 of 4 REV: A	RESTRICTED TO:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

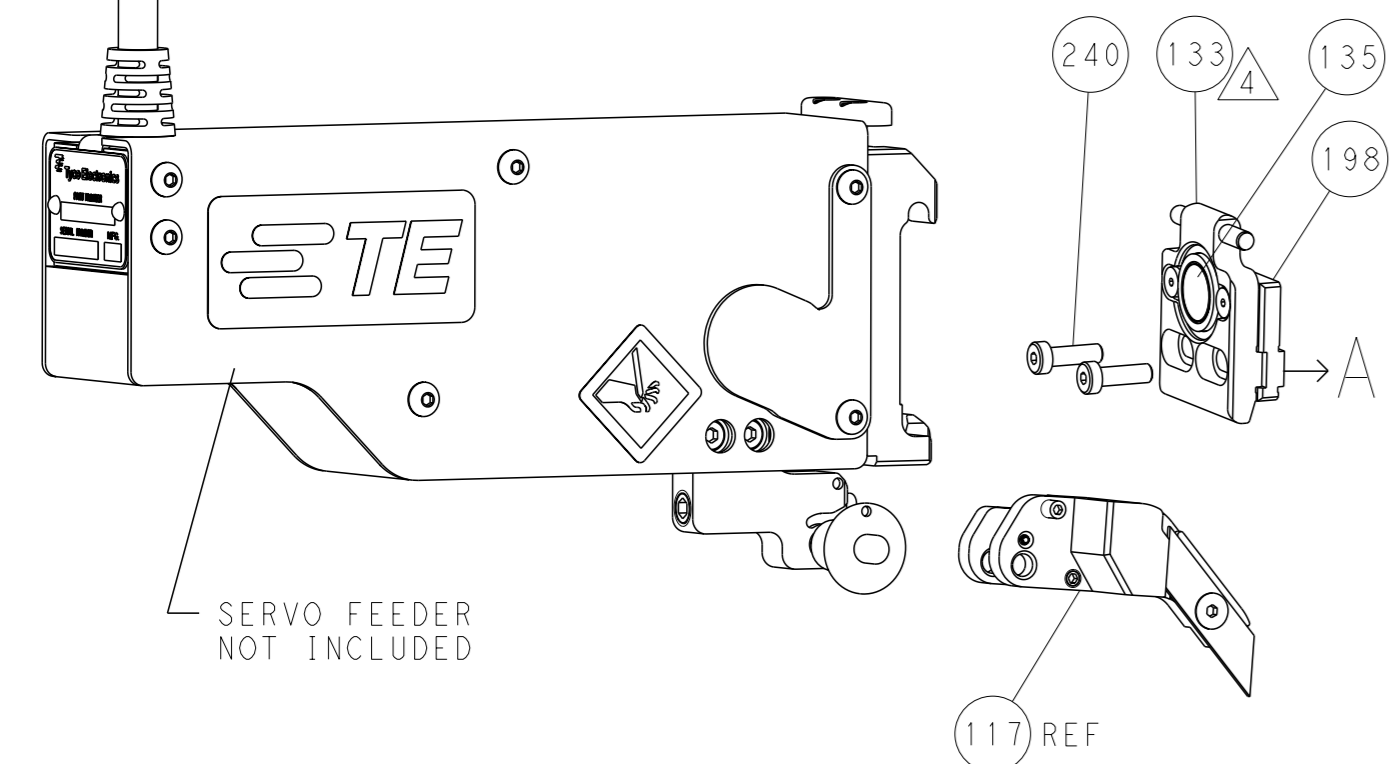


LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

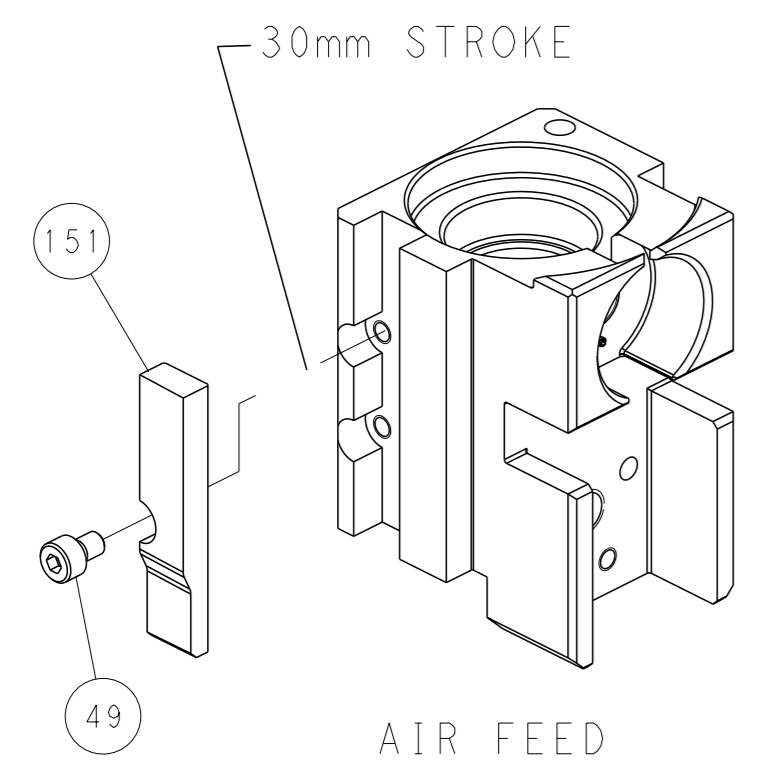
### FEED TYPE PNEUMATIC



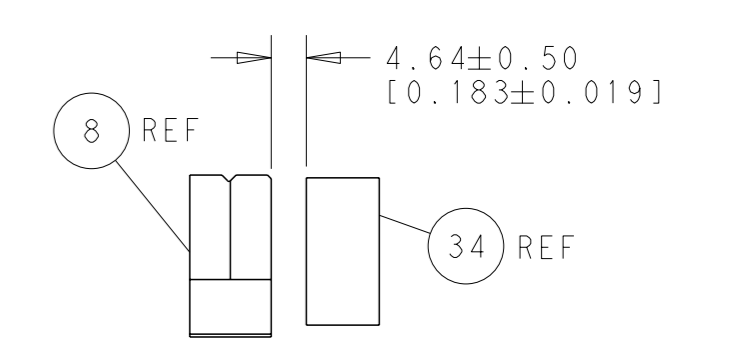
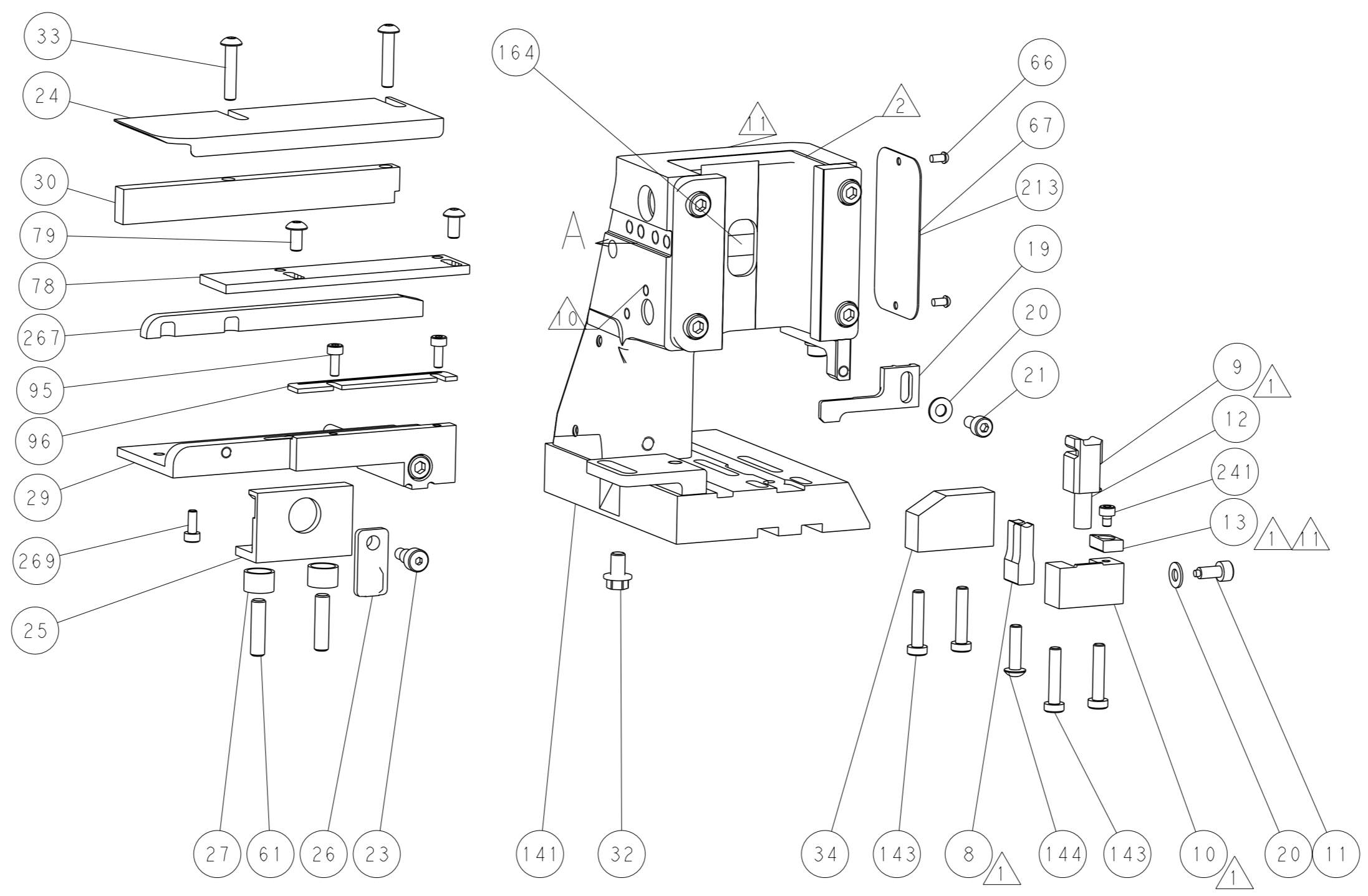
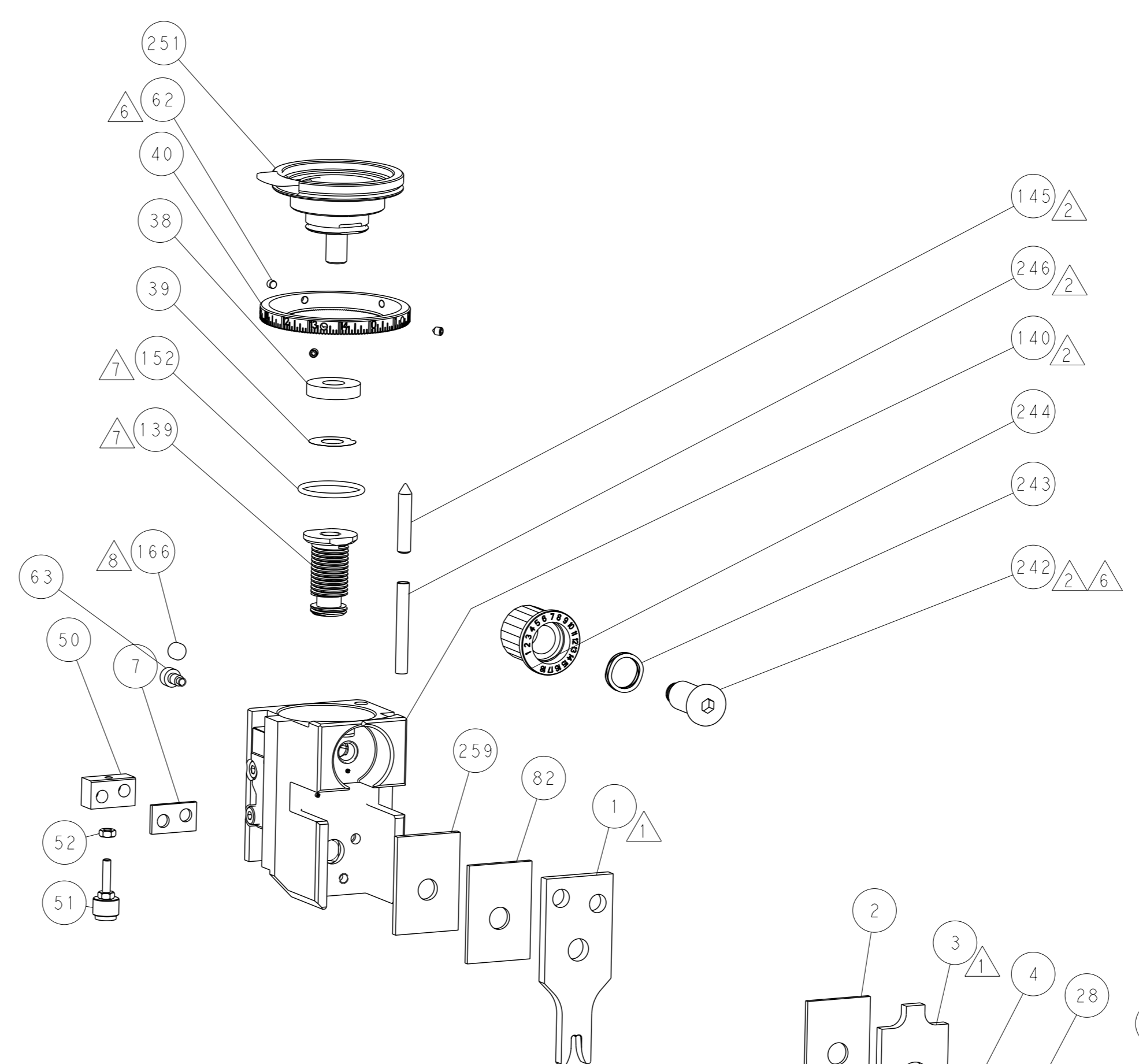
### SERVO LATCH PLATE



### CAM POSITION

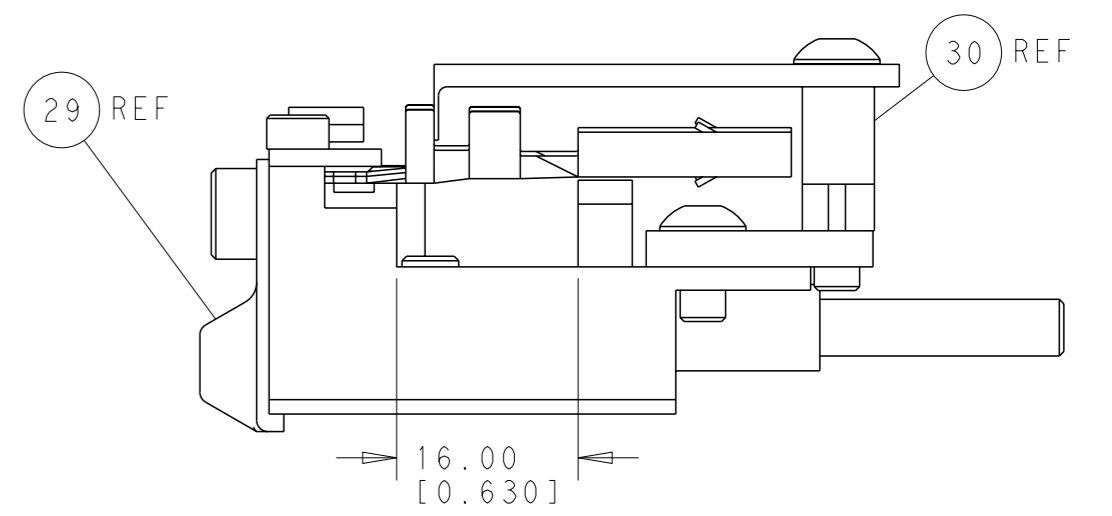


AIR FEED



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT FRONT HOLES



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH: *	WEIGHT: - MATERIAL: -	APPLICATION SPEC: - PRODUCT SPEC: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING		