

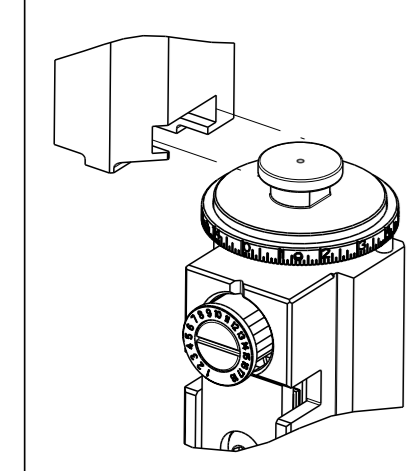
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
	2266152-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SUPERSEDED BY 5-2151493-1
	2266152-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SUPERSEDED BY 5-2151493-2
	2266152-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	OBSOLETE
	2266152-6	D	NON CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	OBSOLETE
	2266152-7	D	FINE CRIMP HEIGHT ADJUST	NONE	OBSOLETE
	3-2266152-2	D	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS	OBSOLETE
	7-2266152-7	A	CRIMP TOOLING KIT	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADOCK SYSTEM			
WIRE STRIP LENGTH 3.05-3.35 mm [1.20-.132 IN]		INSULATION DIAMETER RANGE Ø1.15-1.60 mm [0.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION 114-18021			
TERMINALS APPLIED			
GROUP 1		GROUP 2	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928999-1	5-928918-2	968220-1	1703296-1
928999-5	5-928918-1	968220-5	1703296-5
928999-6	6-928918-1	968220-6	1534116-1
5-928999-1	6-928918-2	5-968220-1	1534116-2
968893-1	6-928918-3	5-968220-5	5-1534116-1
928918-1	1394702-1	5-968220-6	5-1534116-2
928918-2	1394702-2		1241918-1
1-928918-1	5-1394702-1		
1-928918-2	5-1394702-2		
5-928999-5	5-928999-6		
6-928999-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.86 +/- 0.03 [0.034 +/- .001]	5.0
0.35mm2	0.76 +/- 0.03 [0.030 +/- .001]	6.1
0.25mm2	0.72 +/- 0.03 [0.028 +/- .001]	6.6

- 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:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266152-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266152-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266152-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266152-6
- 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 ITEMS 50, 62  
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.
- 7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8. MAGNET, ITEM 166 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.



- 1. 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.
- 2. WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 1.00mm.
- 3. REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm2 WIRE.
- 4. POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS. REFER TO SHEET 2.
- 5. POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS. REFER TO SHEET 2.
- 6. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.
- 7. THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.



**\*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	-32	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	-	-	-	-	-	1803430-1	AIR FEED MODULE	290
-	-	-	-	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	-	-	-	-	-	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	-	-	-	2119641-1	FEED CAM, AIR FEED	248
-	-	-	-	-	-	-	2119798-1	DETENT PIN	247
-	-	-	-	-	-	-	1-22279-3	SPRING, COMPRESSION	246
-	-	-	-	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	-	-	-	-	-	-	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	-	-	-	-	-	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	-	-	-	-	-	2119083-1	RETAINER, INSULATION DIAL	242
-	-	-	-	-	-	-	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	-	-	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240

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

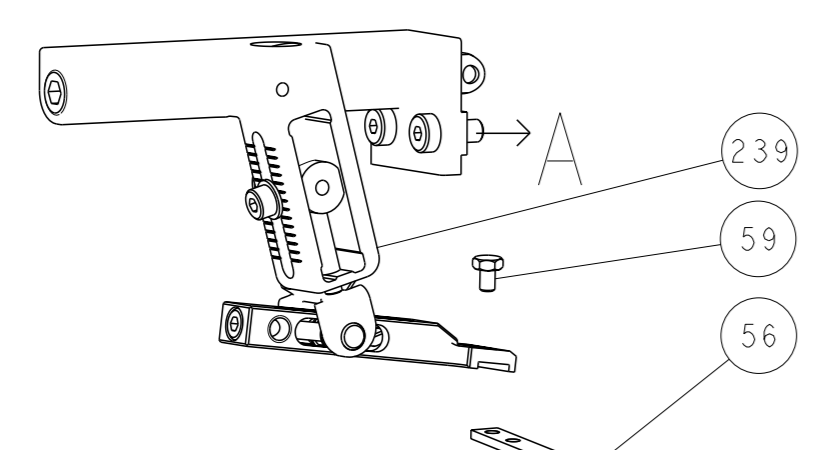
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			C1	14SEP2015	YY	UG
			D	17NOV2017	MEH	JDG
			D1	12APR2018	LG	JD

#	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	-	-	-	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	AIR FEED MODULE	238
-	-	-	-	TAG, IDENTIFICATION	213
-	-	-	-	SPACER, FEEDER	198
-	-	-	-	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	-	SPRING, COMPRESSION	176
-	-	-	-	GUIDE PIN, HOLDDOWN	175
-	-	-	-	GUIDE PIN, HOLDDOWN	174
-	-	-	-	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	-	-	-	MAGNET, RARE EARTH HIGH ENERGY	166
-	-	-	-	COUNTER, MAGNETIC	164
-	-	-	-	SPRING, FEED FINGER	163
-	-	-	-	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	HOLDER, FEED FINGER, AF	136
-	-	-	-	MEMORY CHIP, PROGRAMMED	135
-	-	-	-	SERVO FEED LATCH ASM	133
-	-	-	-	WASHER, FLAT, REG M4	119
-	-	-	-	FEED FINGER ASSEMBLY, SF	117
-	-	-	-	FRONT STRIP GUIDE	96
-	-	-	-	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	-	-	-	SPACER, CRIMPER	82
-	-	-	-	SPACER	81
-	-	-	-	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	-	-	-	FENCE	78
-	-	-	-	DOCUMENTATION PACKAGE	71
-	-	-	-	DEPRESSOR, WIRE	70
-	-	-	-	WASHER, SPACER	69
-	-	-	-	TAG, IDENTIFICATION	67
-	-	-	-	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	-	-	LIMITER, ADJUSTMENT BOLT	63
-	-	-	-	SCR, SET, SOC, CONE PNT, M3 X 4.0	62
-	-	-	-	SCR, SET, FLT PNT, M5 X 20.0	61
-	-	-	-	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	PAWL, FEED	56
-	-	-	-	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	-	-	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	-	-	-	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	-	STRIPPER, SIDE FEED	51
-	-	-	-	STANDOFF, HOLD-DOWN	50
-	-	-	-	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	FEED CAM, PRE FEED	48
-	-	-	-	FEED CAM, POST FEED	47
-	-	-	-	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	-	-	RAM, AMP STYLE, SIDE FEED	44
-	-	-	-	SCR, BHSC, RoHS (M8 X 25)	41
-	-	-	-	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	-	-	-	APPLICATOR SHIM PACK	39
-	-	-	-	RAM WASHER, PRECISION	38
-	-	-	-	FA HEAD, ATLANTIC STYLE	37
-	-	-	-	BOLT, ADJUSTMENT	35
-	-	-	-	SUPPORT, TERMINAL	34
-	-	-	-	SCR, BHSC, RoHS (M4 X 20)	33
-	-	-	-	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	-	-	-	SPACER, STRIP GUIDE	30
-	-	-	-	ASSEMBLY, STRIP GUIDE	29
-	-	-	-	SPACER, CRIMPER	28
-	-	-	-	SPRING, COMPRESSION	27
-	-	-	-	LEVER, DRAG RELEASE	26
-	-	-	-	DRAG, TERMINAL	25
-	-	-	-	STRIP GUIDE	24
-	-	-	-	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	-	-	-	HOLD DOWN, TERMINAL	18
-	-	-	-	INSERT, SHEAR	13
-	-	-	-	SPRING, COMPRESSION	12
-	-	-	-	STOP, SHEAR	11
-	-	-	-	SHEAR HOLDER, FRONT	10
-	-	-	-	FLOATING SHEAR, FRONT	9
-	-	-	-	ANVIL, COMBINATION .055	8
-	-	-	-	SPACER	7
-	-	-	-	DEPRESSOR, SHEAR	5
-	-	-	-	BLOCK, CRIMPER SPACER	4
-	-	-	-	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	SPACER, CRIMPER	2
-	-	-	-	CRIMPER, WIRE, F	1

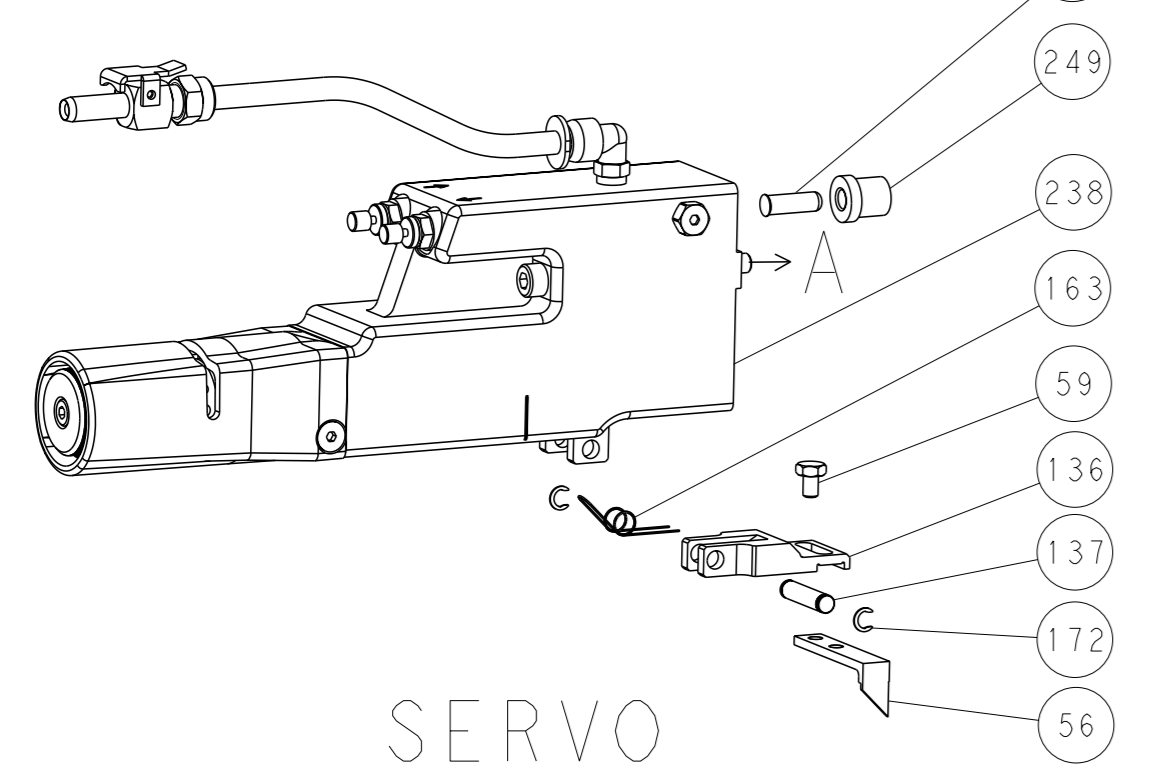
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APPV		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Y. YIN	G. BAILEY	U. GUO	TE Connectivity	Ocean Side Feed Applicator	
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV	Customer Accessible Production Drawing		SCALE 5:1		SHEET 1 of 4	REV D1

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

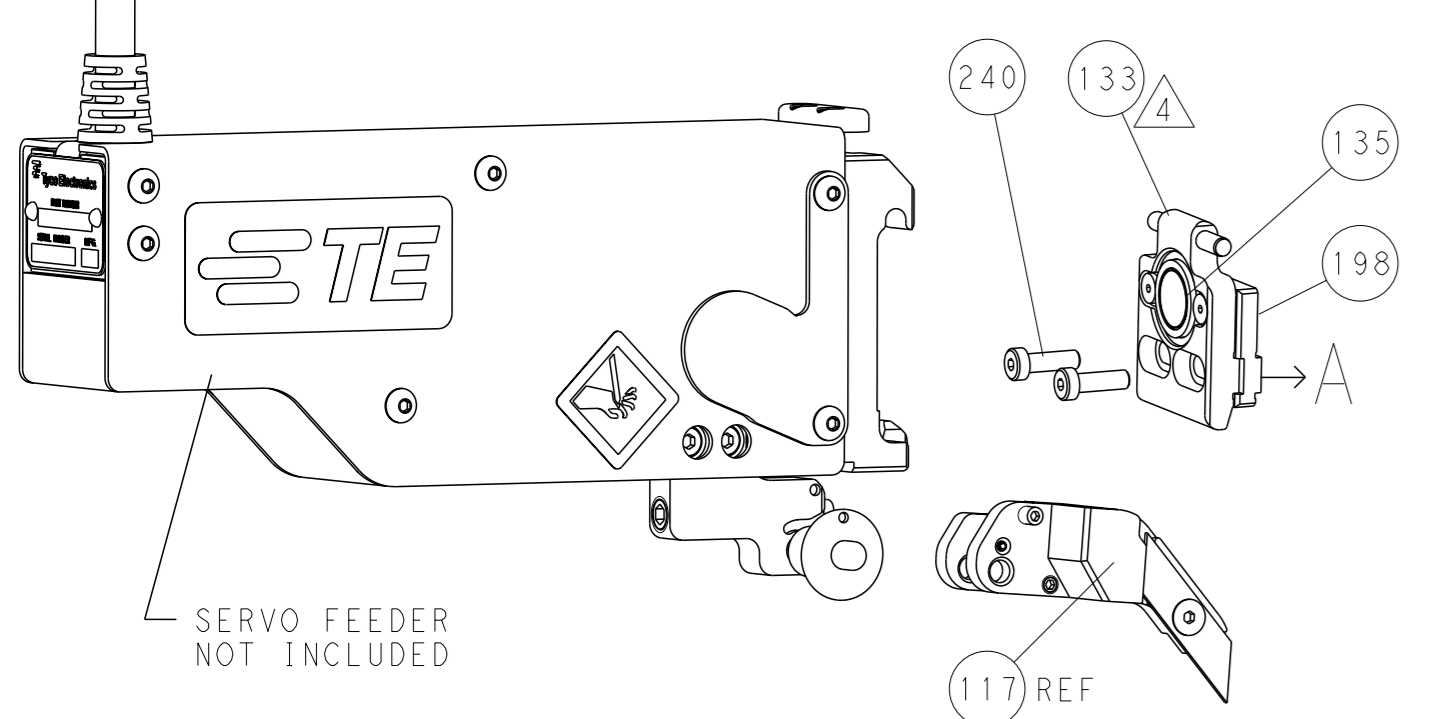
### FEED TYPE MECHANICAL



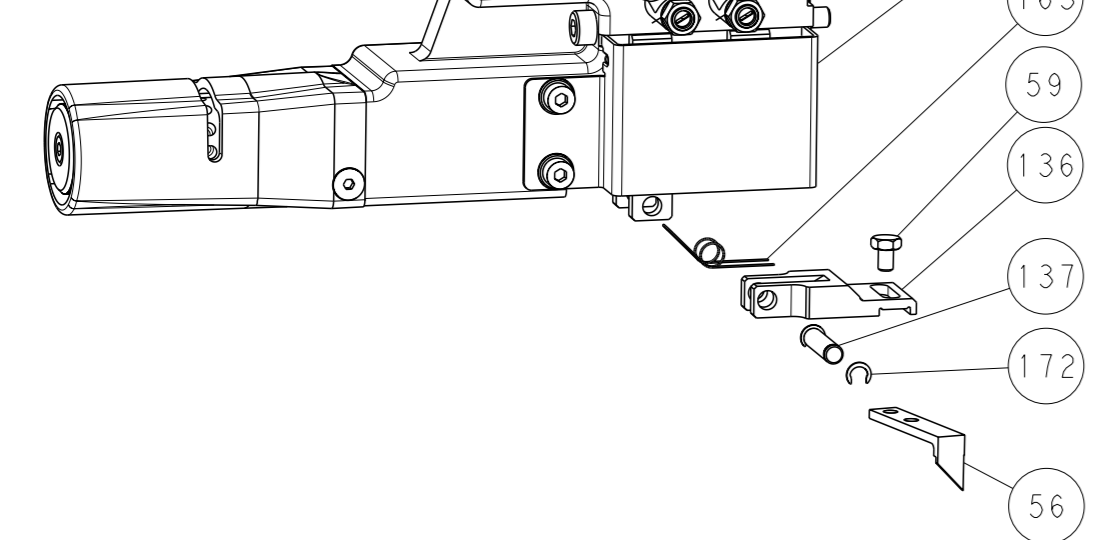
### PNEUMATIC



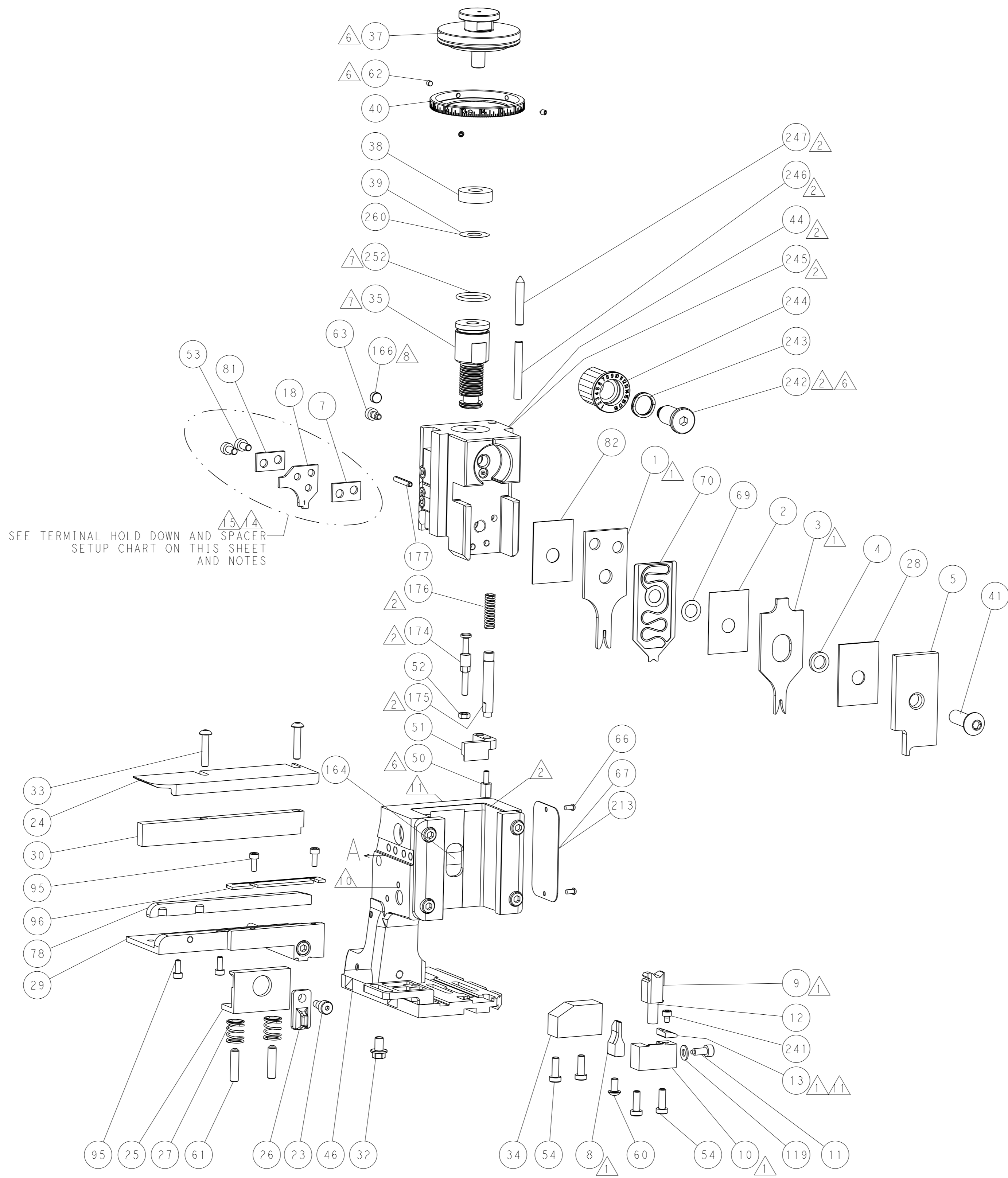
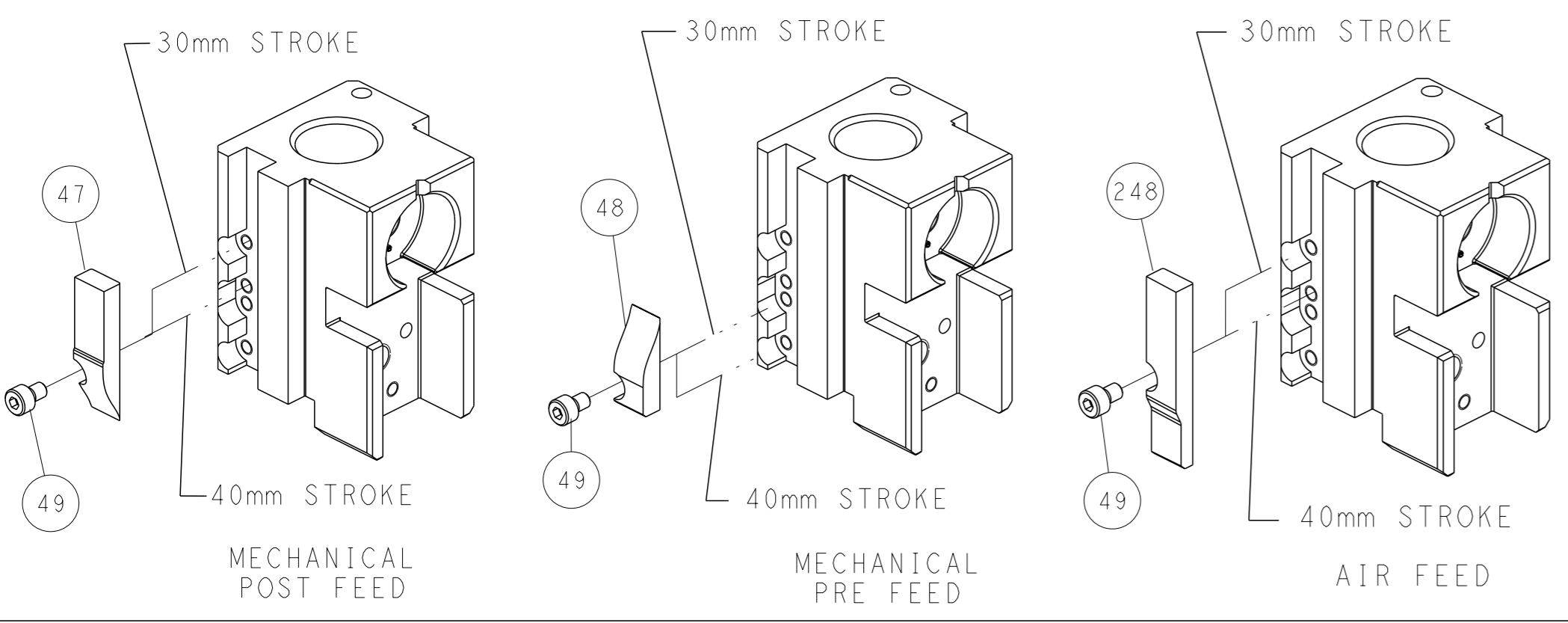
### SERVO LATCH PLATE



### DOUBLE ACTING PNEUMATIC WITH SENSORS



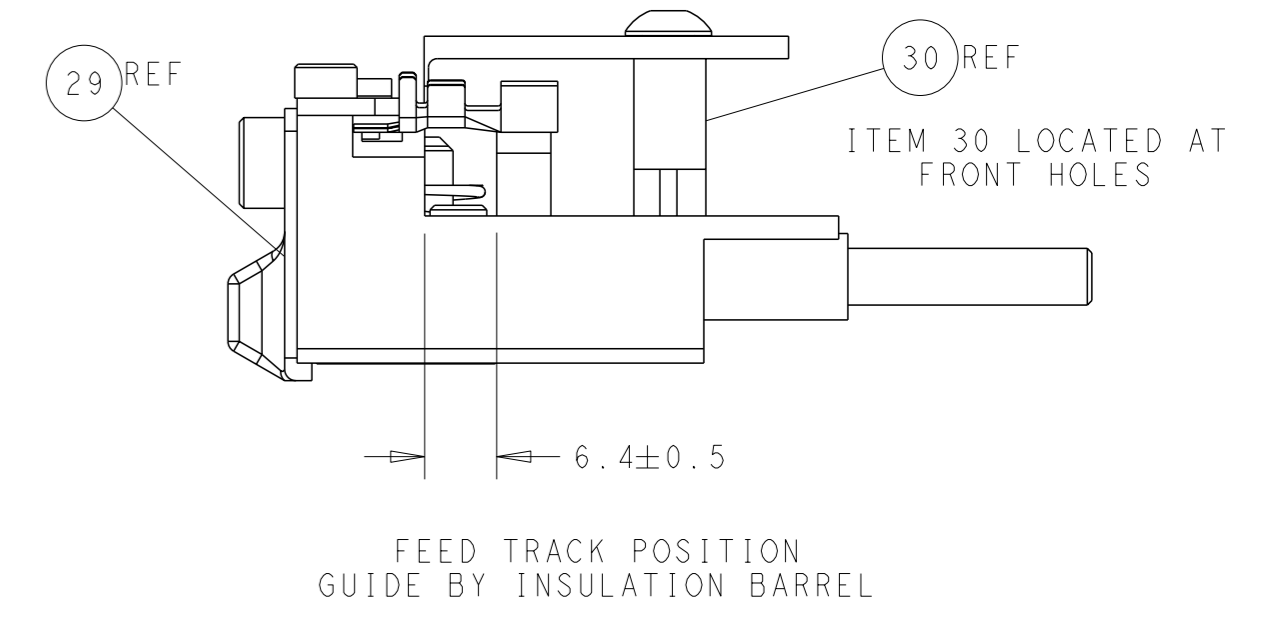
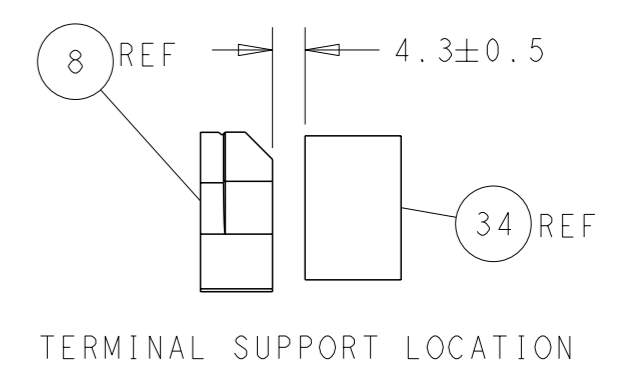
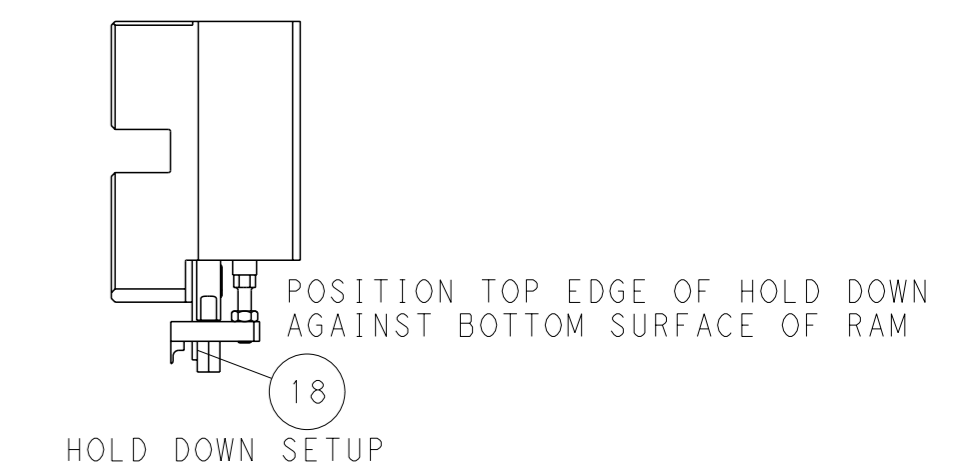
### CAM POSITIONS



SEE TERMINAL HOLD DOWN AND SPACER SETUP CHART ON THIS SHEET AND NOTES

### TERMINAL HOLD DOWN & SPACER SETUP CHART

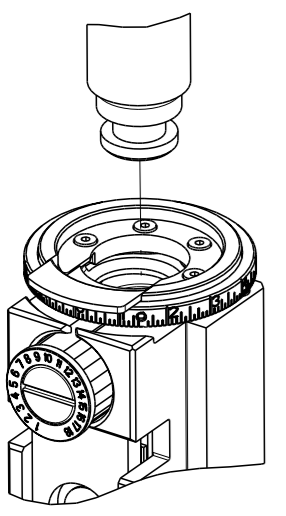
GROUP	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	POSITION
GROUP 1	928999-1 1-928918-2	POSITION 1
	928999-5 2-928918-2	
	928999-6 3-928918-2	
	5-928999-1 5-928918-1	
	5-928999-5 6-928918-1	
GROUP 2	928918-1 1394702-1	POSITION 2
	928918-2 1394702-2	
	1-928918-1 5-1394702-1	
	5-928918-1 5-1394702-2	
	968893-1	
GROUP 2	968220-1 5-968220-6	POSITION 2
	968220-5 1703296-1	
	968220-6 1703296-5	
	5-968220-1 1534116-1	
	5-968220-5 1534116-2	
GROUP 2	1241918-1	POSITION 2



**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 ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: Y. YIN 26DEC2013 CHK: G. BAILEY 26DEC2013 APVD: H. GUO 26DEC2013 PRODUCT SPEC APPLICATION SPEC WEIGHT: - Customer Accessible Production Drawing	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266152 SCALE: 5:1 SHEET: 2 of 4 REV: D1	TE Connectivity Harrisburg, PA 17105-3608
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	STATUS
2-2266152-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	OBSOLETE
2-2266152-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	OBSOLETE
2-2266152-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	OBSOLETE
2-2266152-7	D	FINE CRIMP HEIGHT ADJUST	NONE	OBSOLETE
4-2266152-2	D	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS	OBSOLETE
7-2266152-7	A	CRIMP TOOLING KIT	-	



APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL		TE TE CRIMP SPECIFICATION
TERMINAL NAME: MICRO QUADOCK SYSTEM		
WIRE STRIP LENGTH	3.05-3.35 mm [.120-.132 IN]	INSULATION DIAMETER RANGE
TERMINAL APPLICATION SPECIFICATION	114-18021	

TERMINALS APPLIED			
GROUP 1		GROUP 2	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928999-1	5-928918-2	968220-1	1703296-1
928999-5	5-928918-1	968220-5	1703296-5
928999-6	6-928918-1	968220-6	1534116-1
5-928999-1	6-928918-2	5-968220-1	1534116-2
968893-1	6-928918-3	5-968220-5	5-1534116-1
928918-1	1394702-1	5-968220-6	5-1534116-2
928918-2	1394702-2		1241918-1
1-928918-1	5-1394702-1		
1-928918-2	5-1394702-2		
5-928999-5	5-928999-6		
6-928999-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.86 +/- 0.03 [.034 +/- .001]	5.0
0.35mm2	0.76 +/- 0.03 [.030 +/- .001]	6.1
0.25mm2	0.72 +/- 0.03 [.028 +/- .001]	6.6

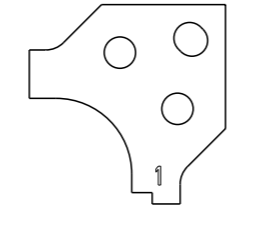
- 1. RECOMMENDED SPARE PARTS
- 2. GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER: MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266152-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266152-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266152-5
- 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 ITEMS 50, 62 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

**\*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.

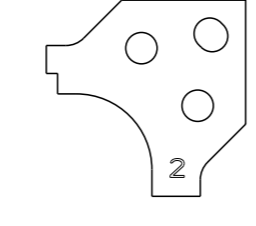
1. TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

2. REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm2 WIRE.

3. POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS. REFER TO SHEET 4.



4. POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS. REFER TO SHEET 4.



5. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

6. THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATOR SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.

ITEM NO	PART NO	DESCRIPTION	ITEM NO				
290	1803430-1	AIR FEED MODULE	290				
251	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251				
250	2119640-1	PUSH ROD, AIR FEED	250				
249	2079988-1	BUSHING, LCH5-12, MISUMI	249				
246	1-22279-3	SPRING, COMPRESSION	246				
244	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244				
243	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243				
242	2119083-1	RETAINER, INSULATION DIAL	242				
241	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241				
240	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240				
239	2119580-1	MECHANICAL FEED ASSEMBLY	239				
238	2063440-1	AIR FEED MODULE	238				
213	2119740-2	TAG, IDENTIFICATION	213				
198	1901094-3	SPACER, FEEDER	198				
ITEM NO	PART NO	DESCRIPTION	ITEM NO				
-77	-42	-27	-25	-22	-21		

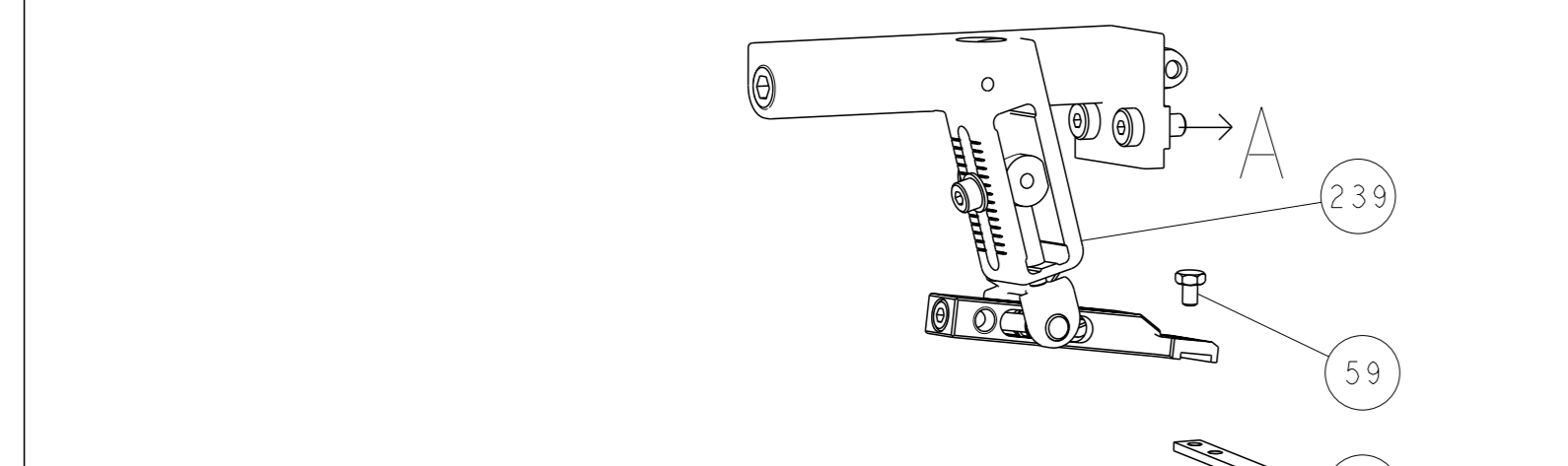
**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

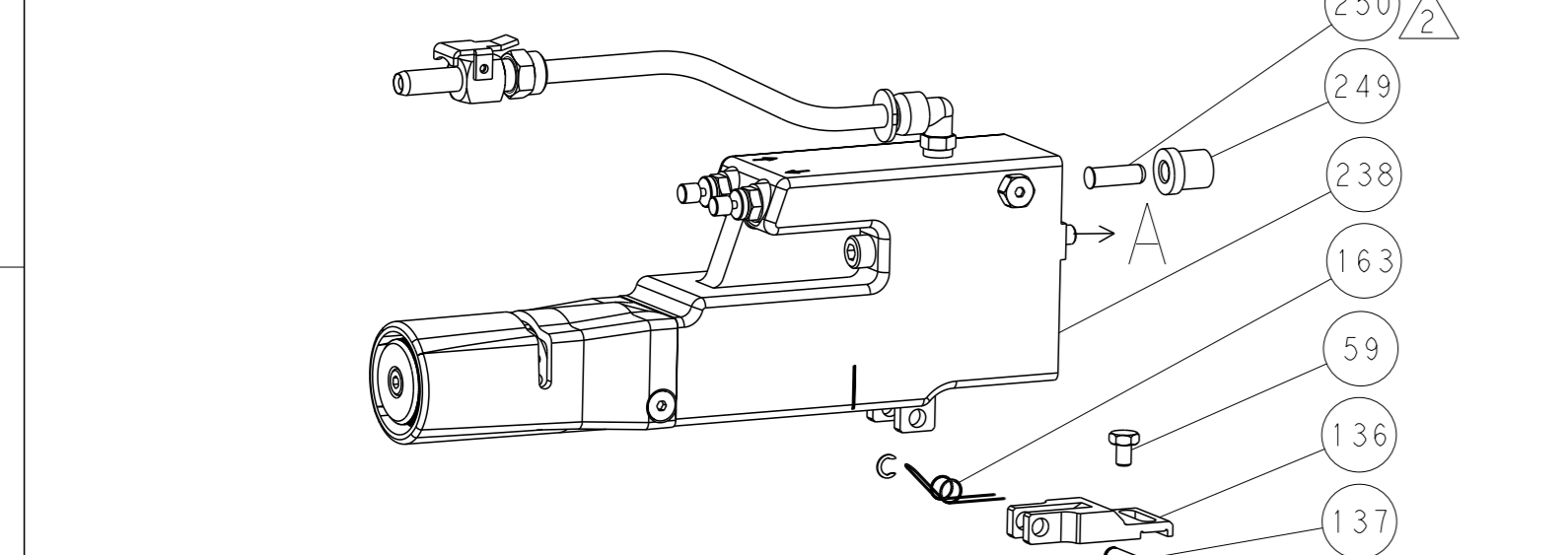
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-	1	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN. 3/16 CRESCENT	172
8	-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	-	1	-	240638-1	SPRING, FEED FINGER	163
7	-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
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-	1	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	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	2-2119656-2	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
7	-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	1	-	-	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
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-	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
14	-	1	1	1	1	1-240641-3	SPACER	81
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1	1	1633782-2	FENCE	78
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	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	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
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-	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	51
6	-	1	1	1	1	1-1752354-7	STANDOFF, HOLD-DOWN	50
16	-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	1-2119644-4	RAM WASHER, PRECISION	38
-	1	1	1	1	1	1752356-6	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	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	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	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
13	-	1	1	1	1	1803155-1	HOLD DOWN, TERMINAL	18
11	-	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	1-1338690-2	ANVIL, COMBINATION .055	8
13	-	1	1	1	1	4-240641-2	SPACER	7
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
1	-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	1	1-562108-5	CRIMPER, WIRE, F	1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	CHK	APPV	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
mm	0 PLC ±.1 1 PLC ±.15 3 PLC ±.2 4 PLC ±.25 ANGLES ±.1	Y. YIN	G. BAILEY	U. GUO	26DEC2013	Ocean Side Feed Applicator	A1	00779	2266152	
MATERIAL:		Customer Accessible Production Drawing		SCALE	5:1	SHEET	3 of 4	REV	D1	

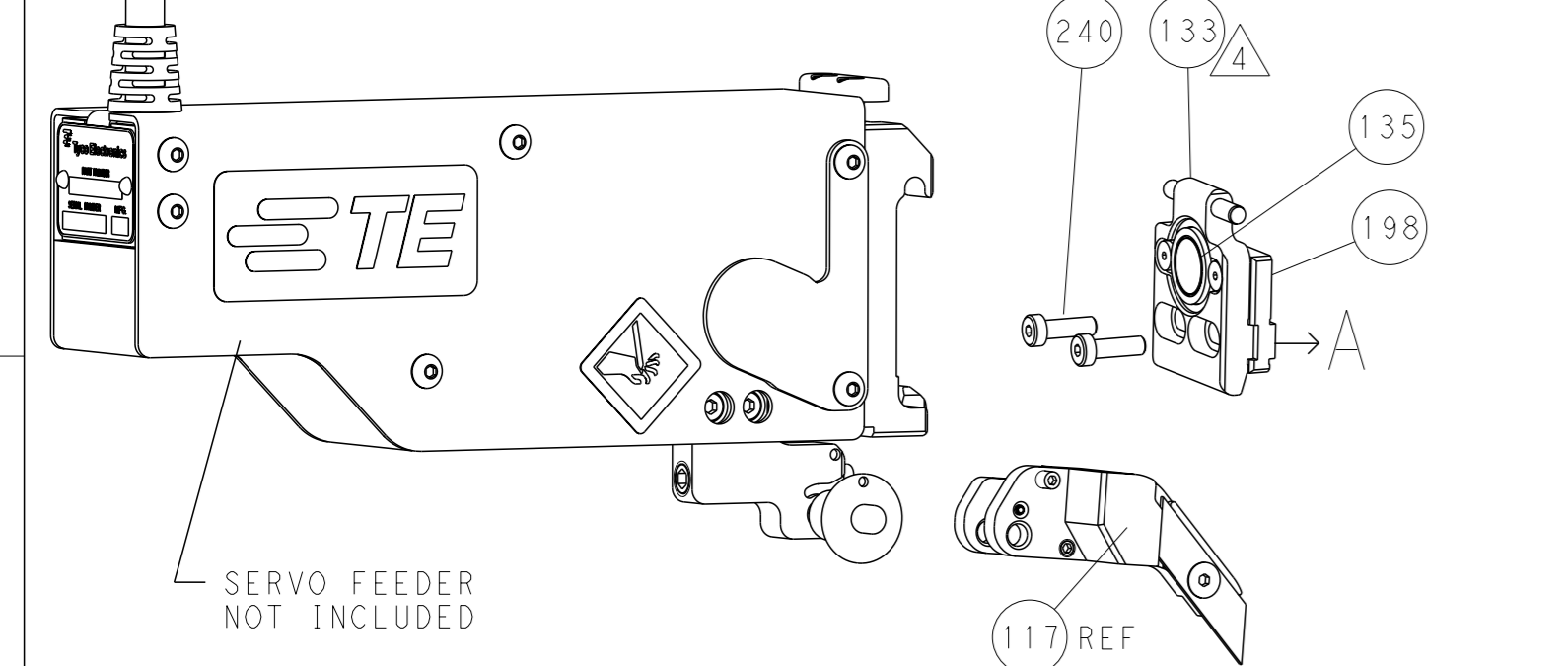
# FEED TYPE MECHANICAL



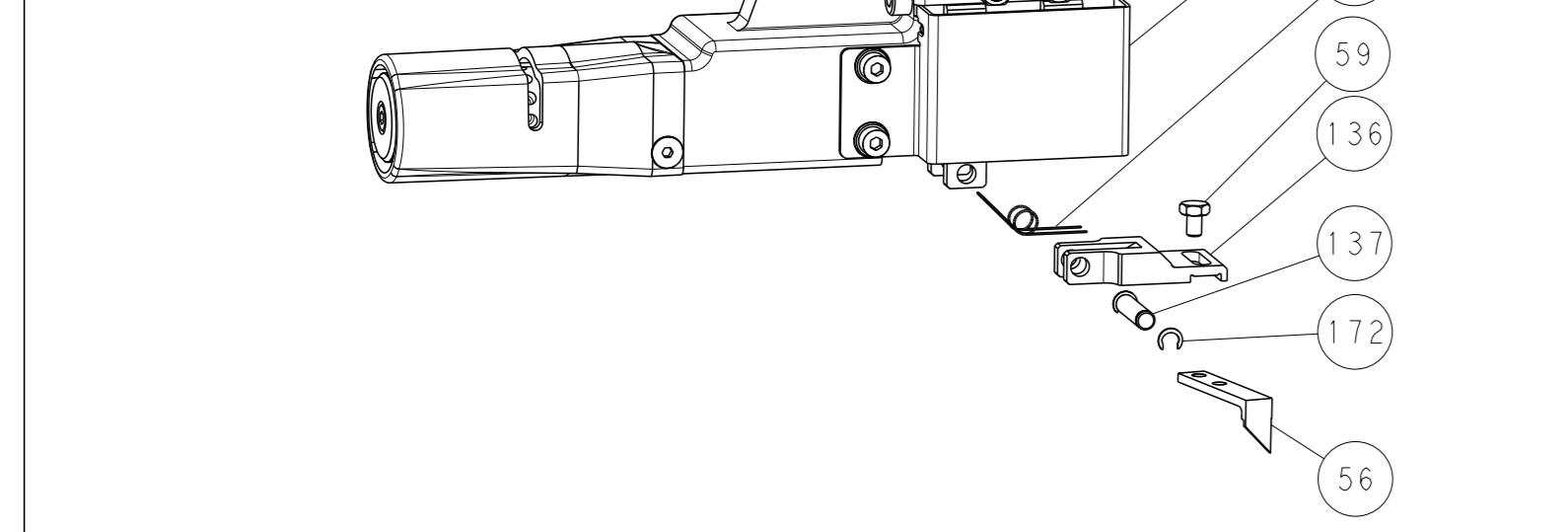
# PNEUMATIC



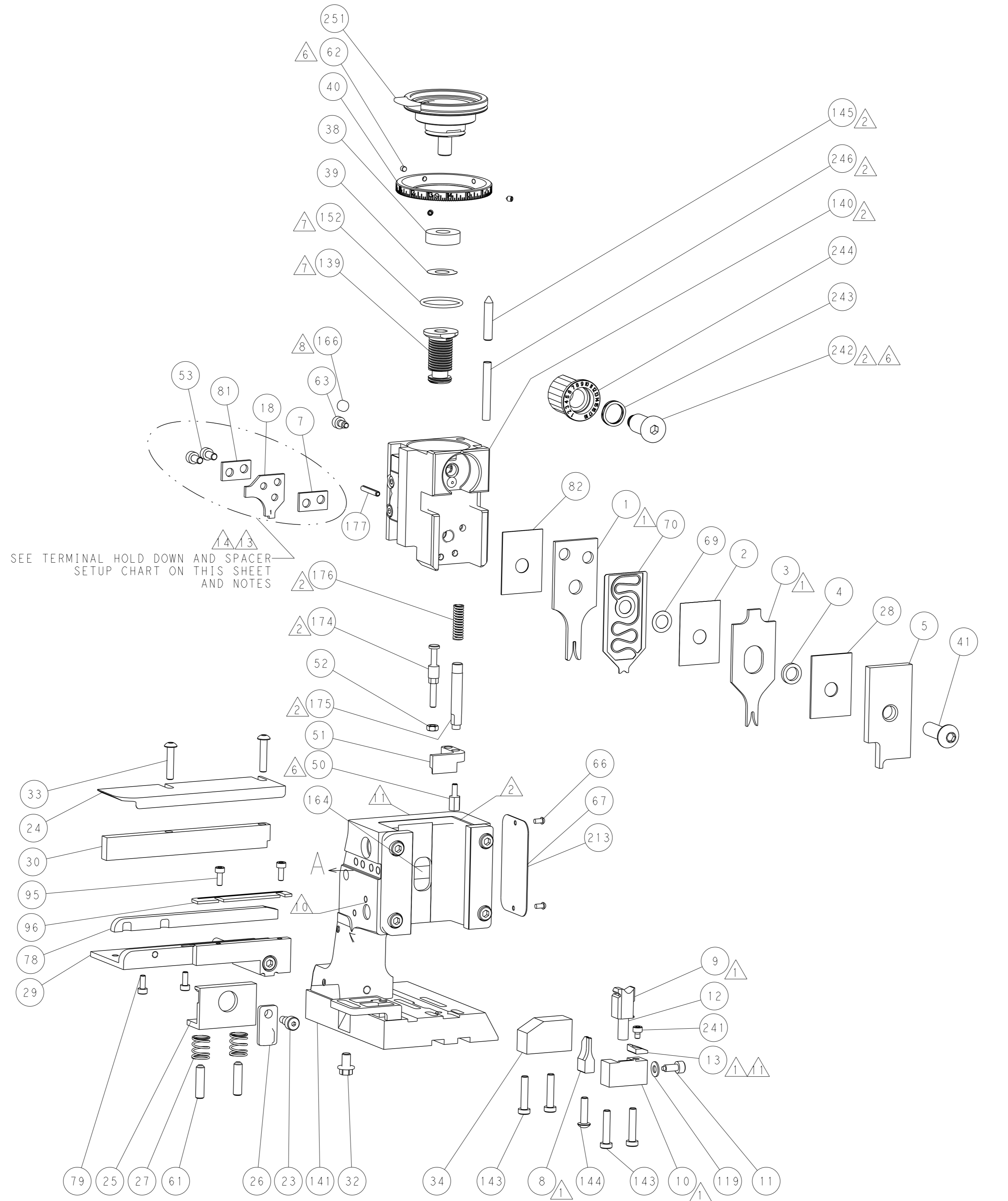
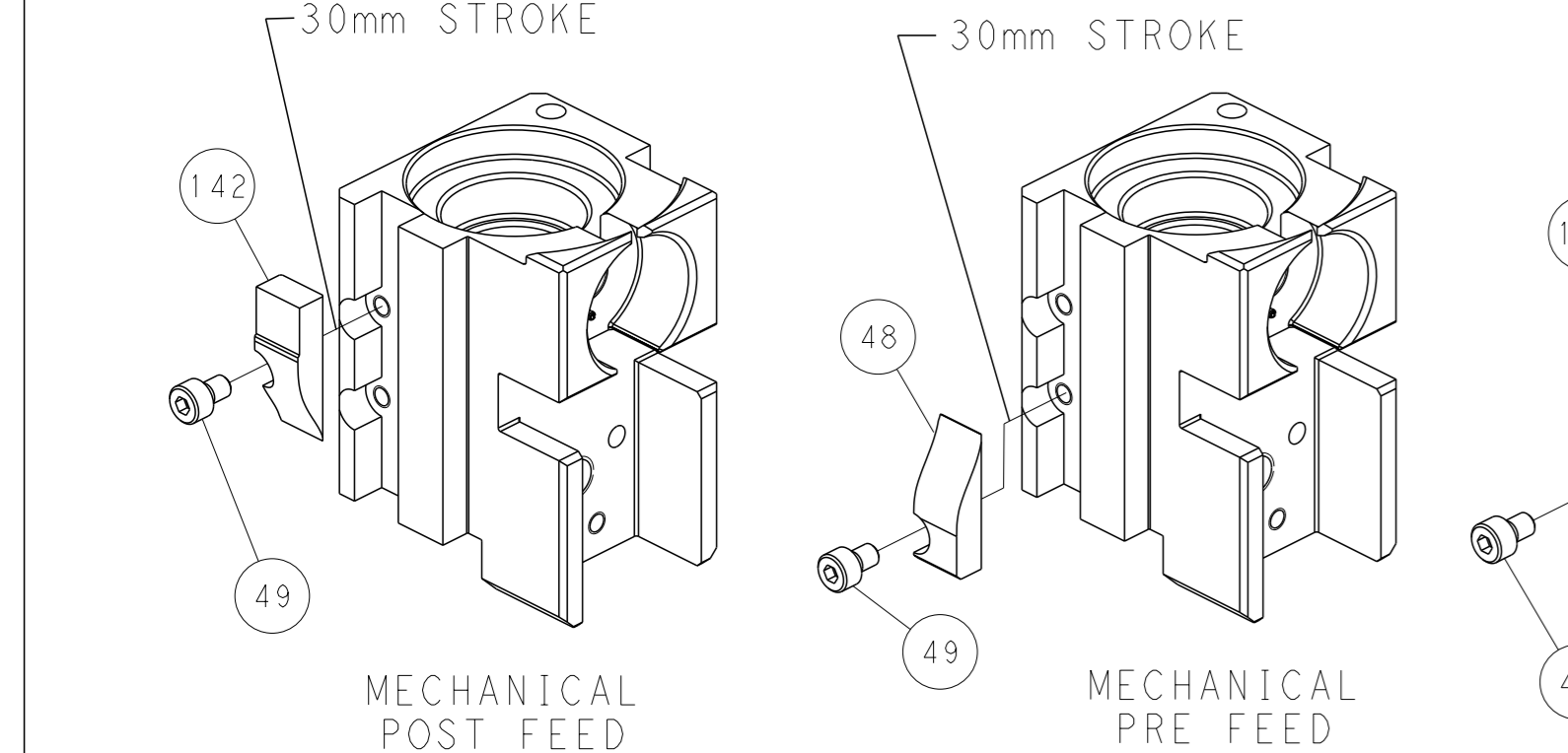
# SERVO LATCH PLATE



# DOUBLE ACTING PNEUMATIC WITH SENSORS



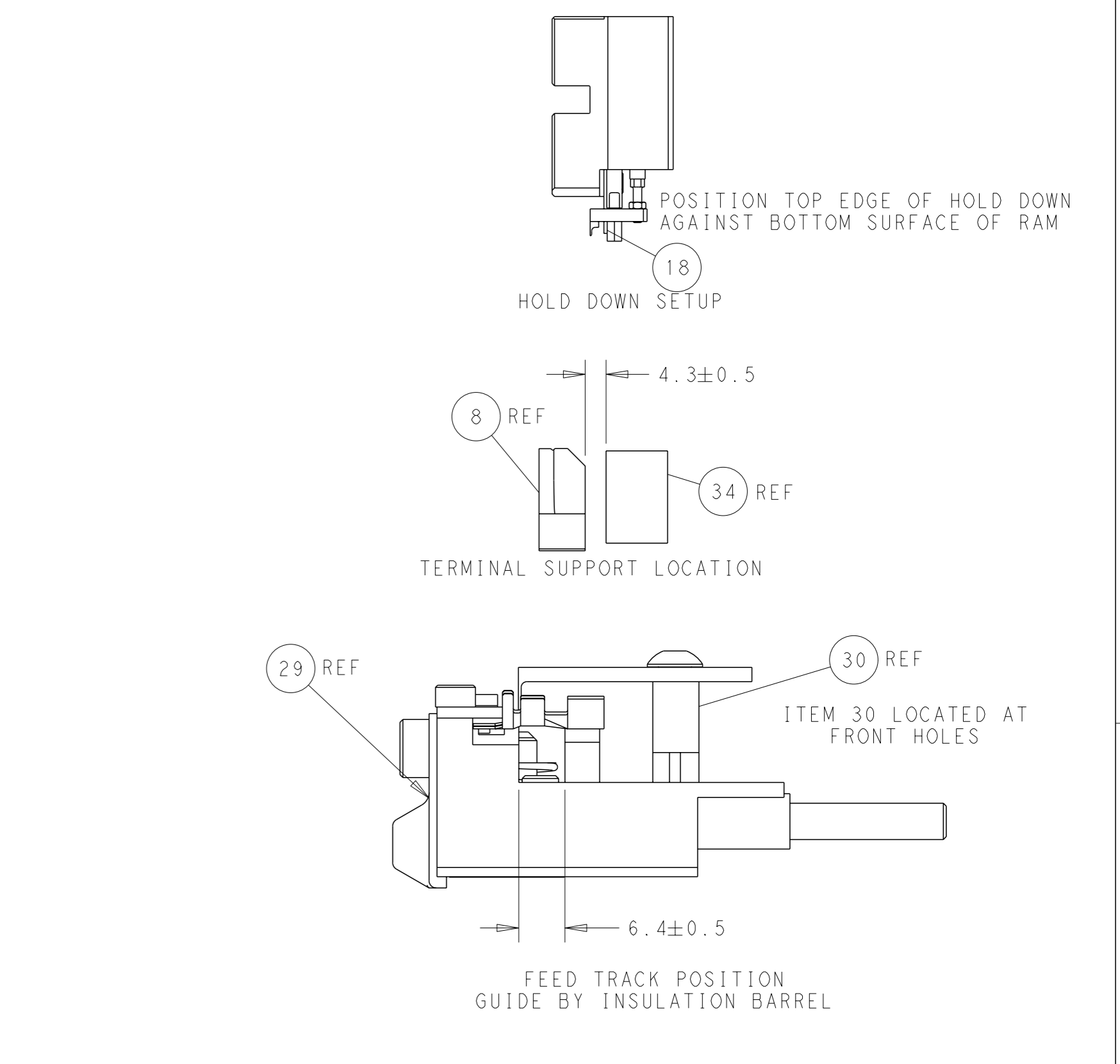
# CAM POSITIONS



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

### TERMINAL HOLD DOWN AND SPACER SETUP CHART

GROUP	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	POSITION
GROUP 1	1-928918-2 2-928918-2 3-928918-2 5-928918-1 6-928918-1 5-928999-5 6-928918-2 5-928999-6 6-928918-3 1394702-1 1394702-2 5-1394702-1 5-1394702-2	POSITION 1
	968893-1	POSITION 1
GROUP 2	5-968220-6 1703296-1 1703296-5 1534116-1 1534116-2 5-968220-5	POSITION 2
	1241918-1	POSITION 2



**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 UNPUBLISHED. RELEASED FOR PUBLICATION. 20                  COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: Y. YIN CHK: G. BAILEY APVD: H. GUO DATE: 26DEC2013	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266152	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - SCALE: 5:1 SHEET: 4 of 4 REV: D1	Customer Accessible Production Drawing		