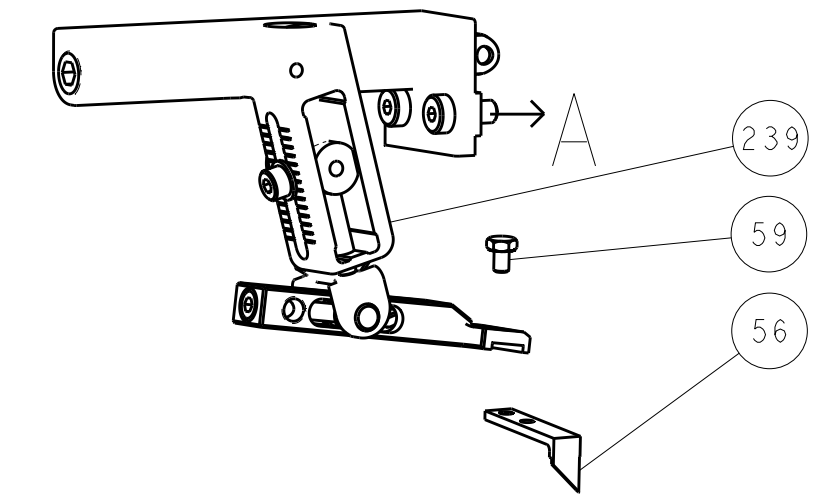
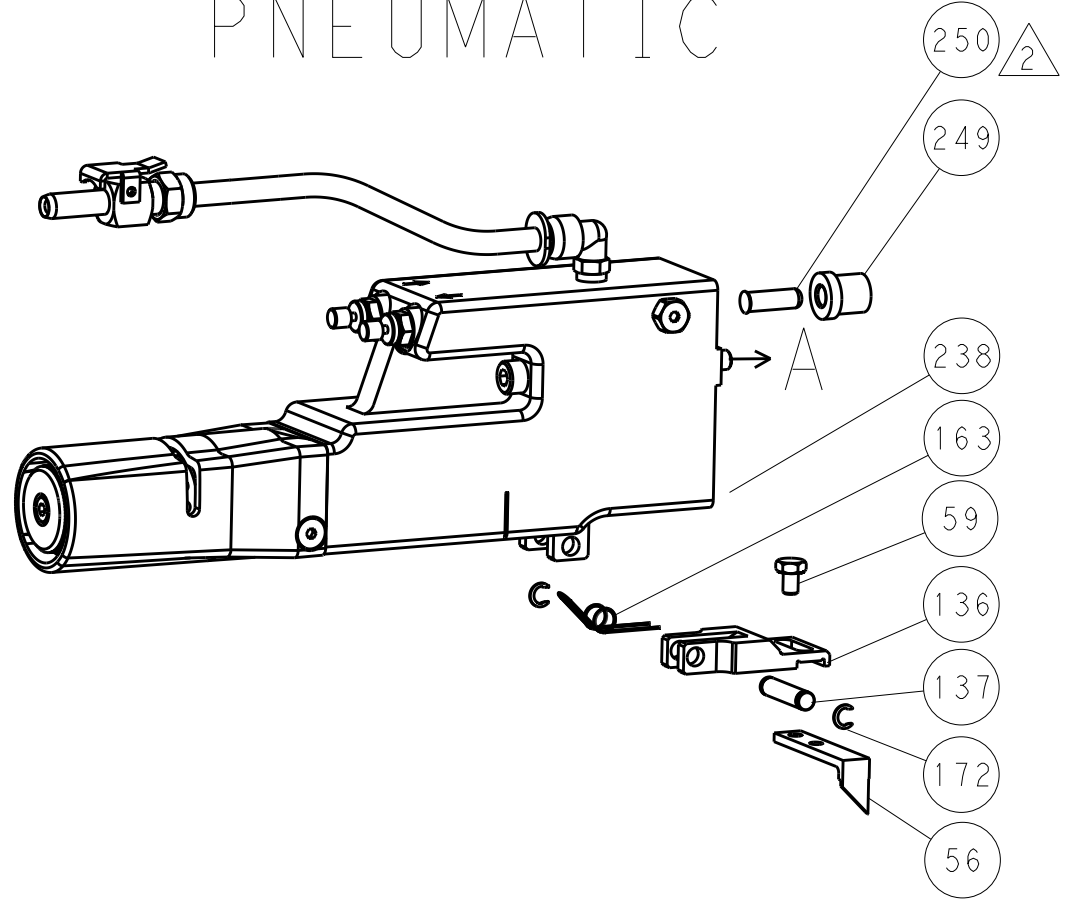


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

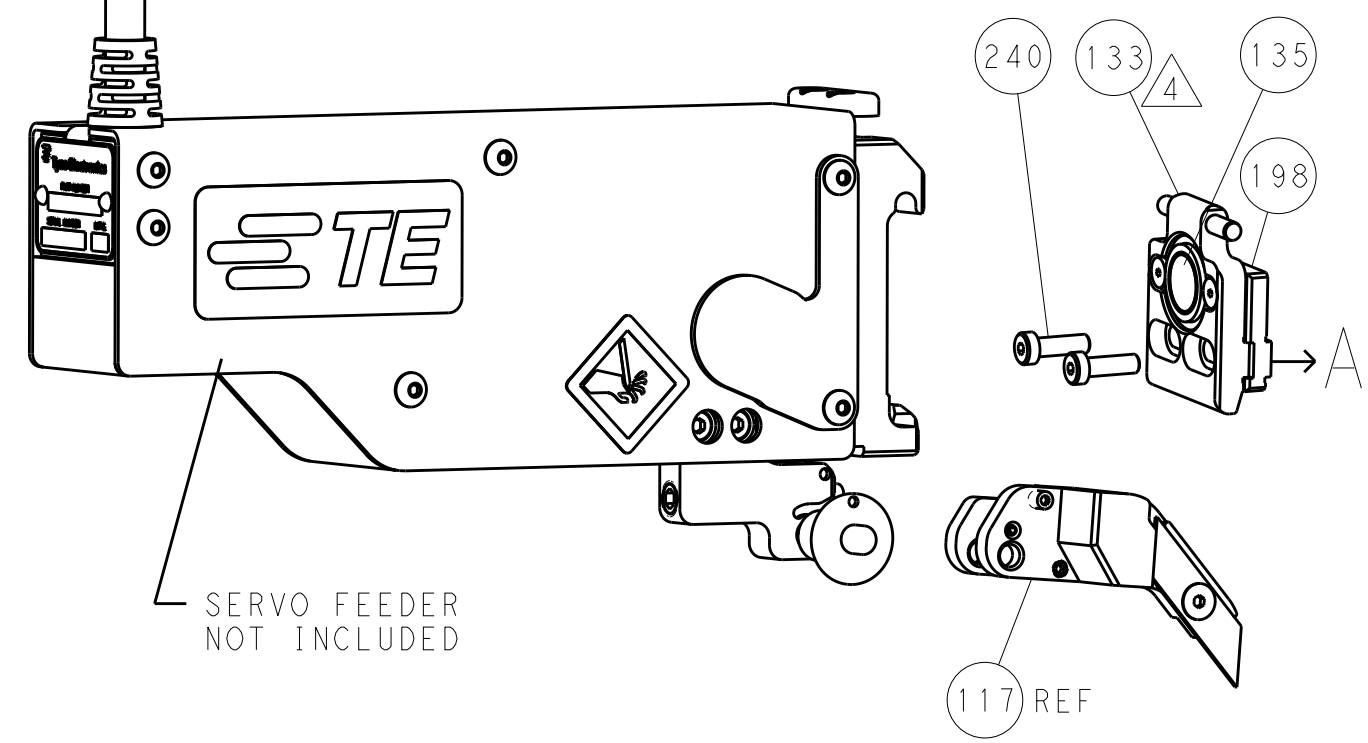
FEED TYPE MECHANICAL



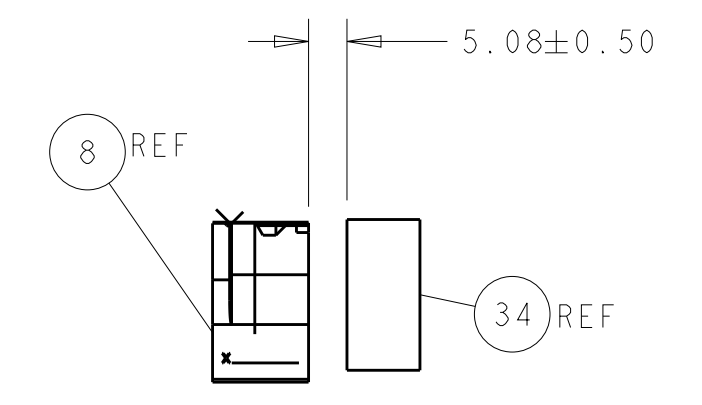
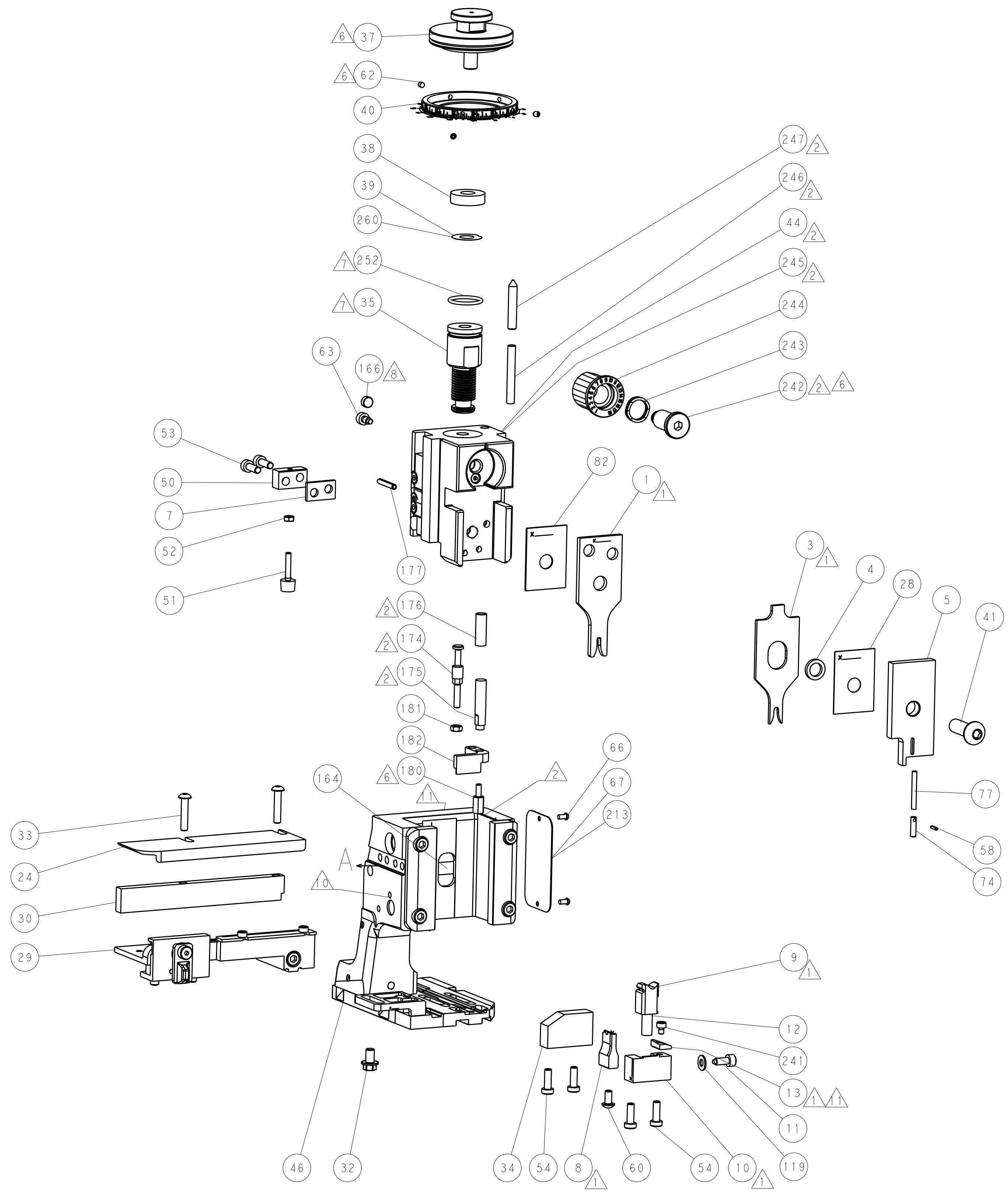
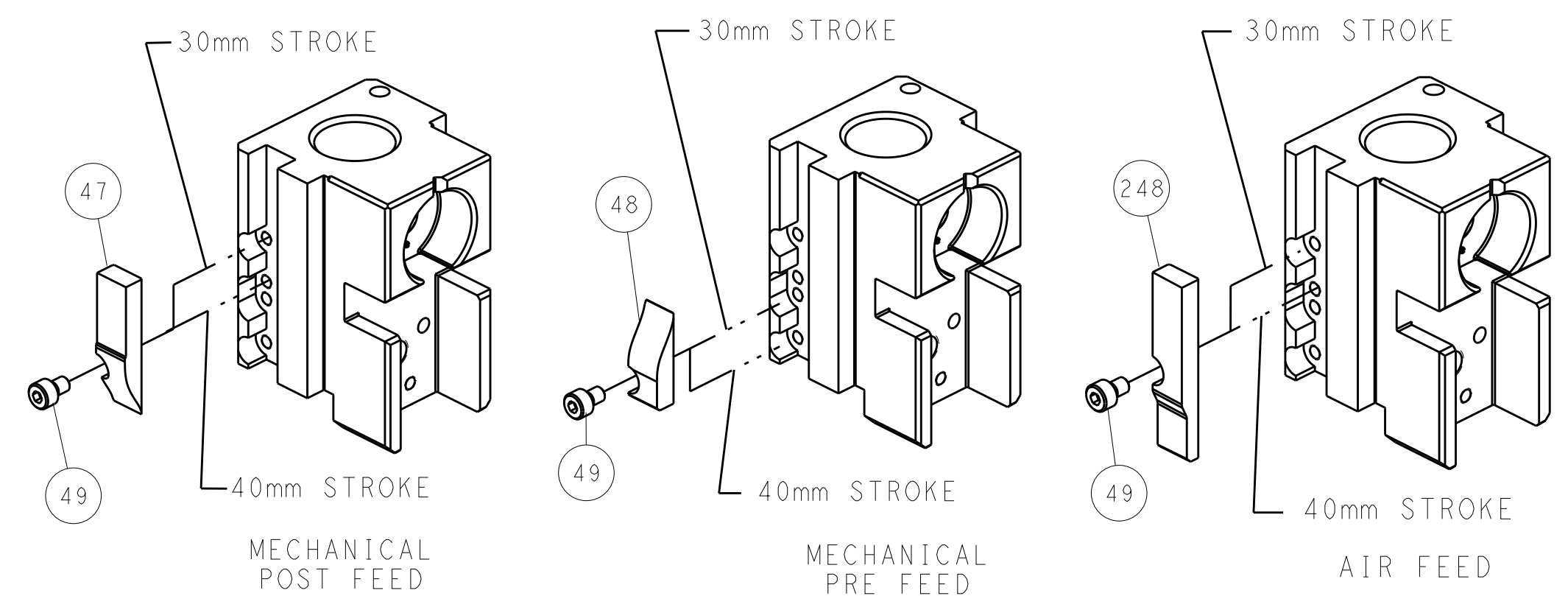
PNEUMATIC



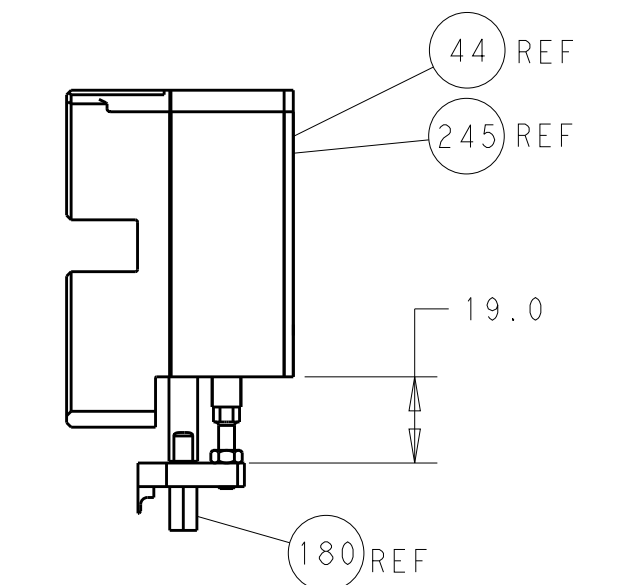
SERVO LATCH PLATE



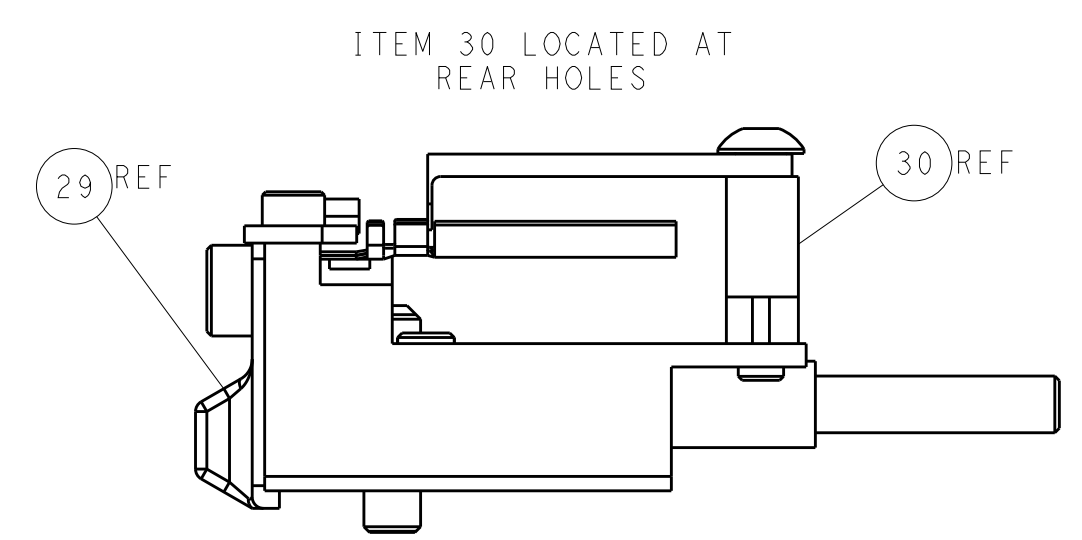
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: H. HUANG 09DEC2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: L. ZHANG 09DEC2014		NAME: Ocean Side Feed Applicator	
				APVD: H. GUO 09DEC2014		RESTRICTED TO:	
				PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				APPLICATION SPEC:		A1 00779 ©=2266601	
				WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV: B1	
				Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
	2-2266601-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	OBSOLETE
	2-2266601-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	OBSOLETE
	2-2266601-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	OBSOLETE
	2-2266601-7	B	FINE CRIMP HEIGHT ADJUST	NONE	OBSOLETE
	7-2266601-7	A	CRIMP TOOLING KIT	-	

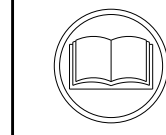
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.05 mm [1.20]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN ASSEMBLY .062 TYPE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.141-.171 IN [3.58-4.34 mm]		∅.080-.100 IN [2.03-2.54 mm]	
TERMINAL APPLICATION SPECIFICATION	(A)114-10004		
	(B)114-10007		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 66098-6	(A) 66098-7	(A) 66098-8	(A) 66098-9
(A) 66100-6	(A) 66100-7	(A) 66100-8	(A) 66100-9
(B) 66579-2	(B) 66579-4	(B) 66579-7	(B) 66580-2
(B) 66580-4	(B) 66580-7	(A) 1-66098-8	(A) 1-66100-9

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STRIP ASSY .062 SOCKET TYPE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.141-.171 IN [3.58-4.34 mm]		∅.080-.100 IN [2.03-2.54 mm]	
TERMINAL APPLICATION SPECIFICATION	(C)114-19000		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 163081-7	(C) 163081-8	(C) 1-163081-1	(C) 1-163081-3
(C) 1-163081-5	(C) 1-163081-7	(C) 163083-7	(C) 163083-8
(C) 1-163083-1	(C) 1-163083-2	(C) 1-163083-4	(C) 163766-1
(C) 163766-2	(C) 163766-4	(C) 163767-4	(C) 163767-5
(C) 164161-3	(C) 164161-4	(C) 164161-7	(C) 164161-9
(C) 1-164161-1	(C) 1-164161-3	(C) 1-164161-5	(C) 1-164161-7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.50mm2	1.42 +/- 0.05 [.056 +/- .002]	4.3
18 AWG	1.30 +/- 0.05 [.051 +/- .002]	5.4
0.75mm or 1.00mm	1.30 +/- 0.05 [.051 +/- .002]	5.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.50mm2	1.40 +/- 0.05 [.055 +/- .002]	4.5
1.00mm2	1.32 +/- 0.05 [.052 +/- .002]	5.2
18 AWG OR 0.75mm2	1.27 +/- 0.05 [.050 +/- .002]	5.1



- 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:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266601-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266601-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266601-5
- 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.
- 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. 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

***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
-	1	1	1	1	2119082-4	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
-	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)

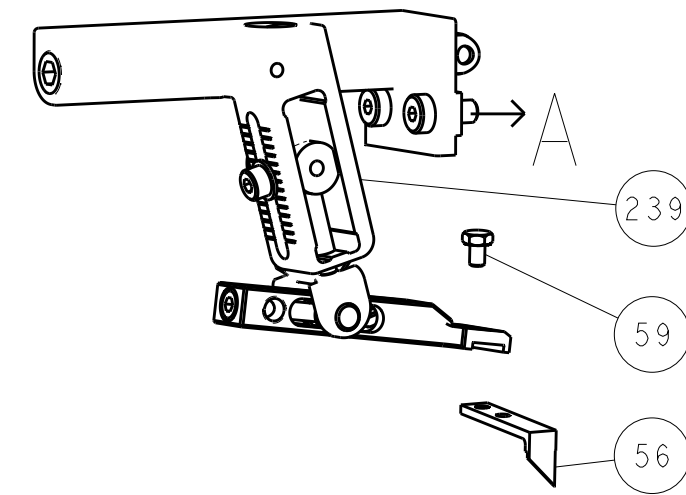
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1			

-	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	
-	-	-	-	-	2119740-2	TAG, IDENTIFICATION	213	
-	-	-	-	-	1901094-3	SPACER, FEEDER	198	
-	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	182	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181	
-	1	1	1	1	2-1752354-3	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	-	-	-	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	
-	-	-	-	-	240638-1	SPRING, FEED FINGER	163	
-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA, MAT.	152	
-	-	-	-	-	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	
-	-	-	-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	1	1	1	2-2119656-2	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	
-	-	-	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	-	-	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
-	-	-	-	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	1	455888-7	SPACER, CRIMPER	82	
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	1	1	854769-4	HOLDER, INS	74	
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	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	992763-5	SCR, SET, SOC, CONE PNT, M3 X 4.0	62	
-	-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	-	-	-	-	1338685-1	PAWL, FEED	56	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	
-	-	-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	-	-	-	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	2119644-1	RAM WASHER, PRECISION	38	
-	1	1	1	1	1752356-2	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	1-1320908-0	SPACER, STRIP GUIDE	30	
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	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	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	1	1	1	1333228-1	ANVIL	8	
-	1	1	1	1	1-240641-1	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
-	1	1	1	1	2119784-7	CRIMPER, INSULATION O PREMIUM	3	
-	-	-	-	-	-	-	2	
-	1	1	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1	
-	77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

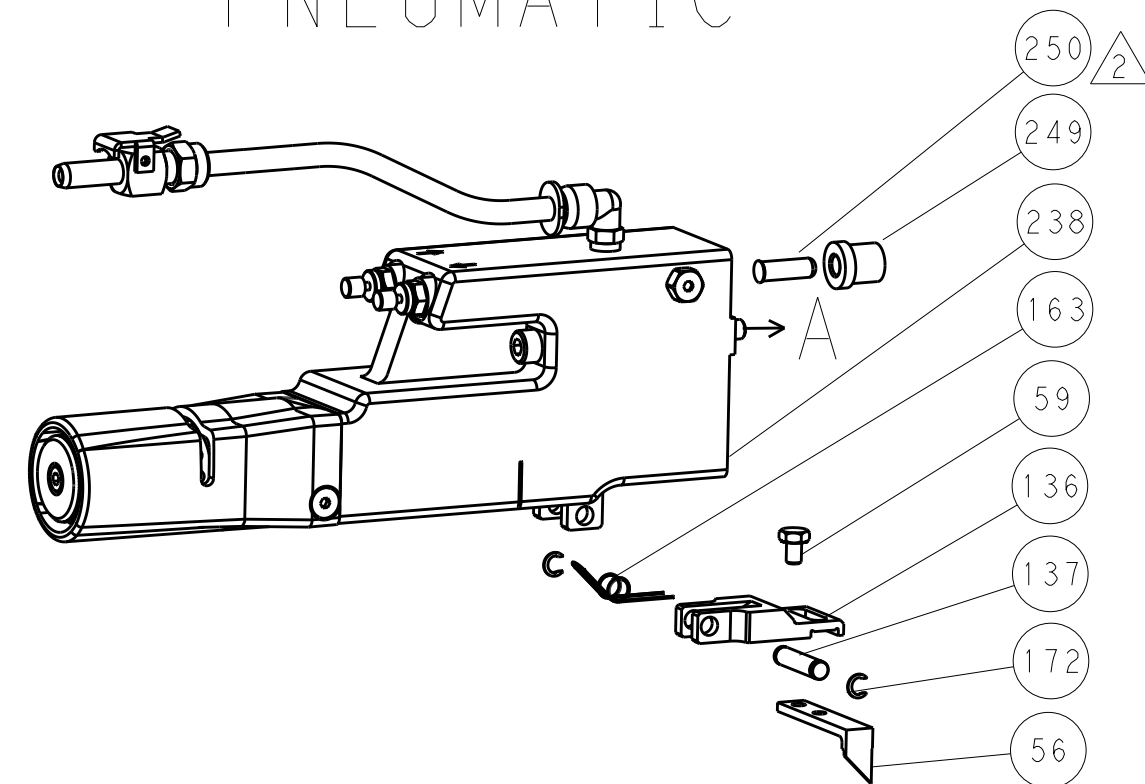
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
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	1 PLC	±	09DEC2014	CHK	
	2 PLC	±		CHK	
	3 PLC	±		CHK	
	4 PLC	±		CHK	
	ANGLES	±		CHK	
	FINISH	±		CHK	
MATERIAL				APVD	U. GUO 09DEC2014
				NAME	L. ZHANG
				PRODUCT SPEC	
				APPLICATION SPEC	
				SIZE	A1
				CAGE CODE	00779
				DRAWING NO	2266601
				RESTRICTED TO	
				Customer Accessible Production Drawing	SCALE 1:2 SHEET 3 OF 4 REV B1

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

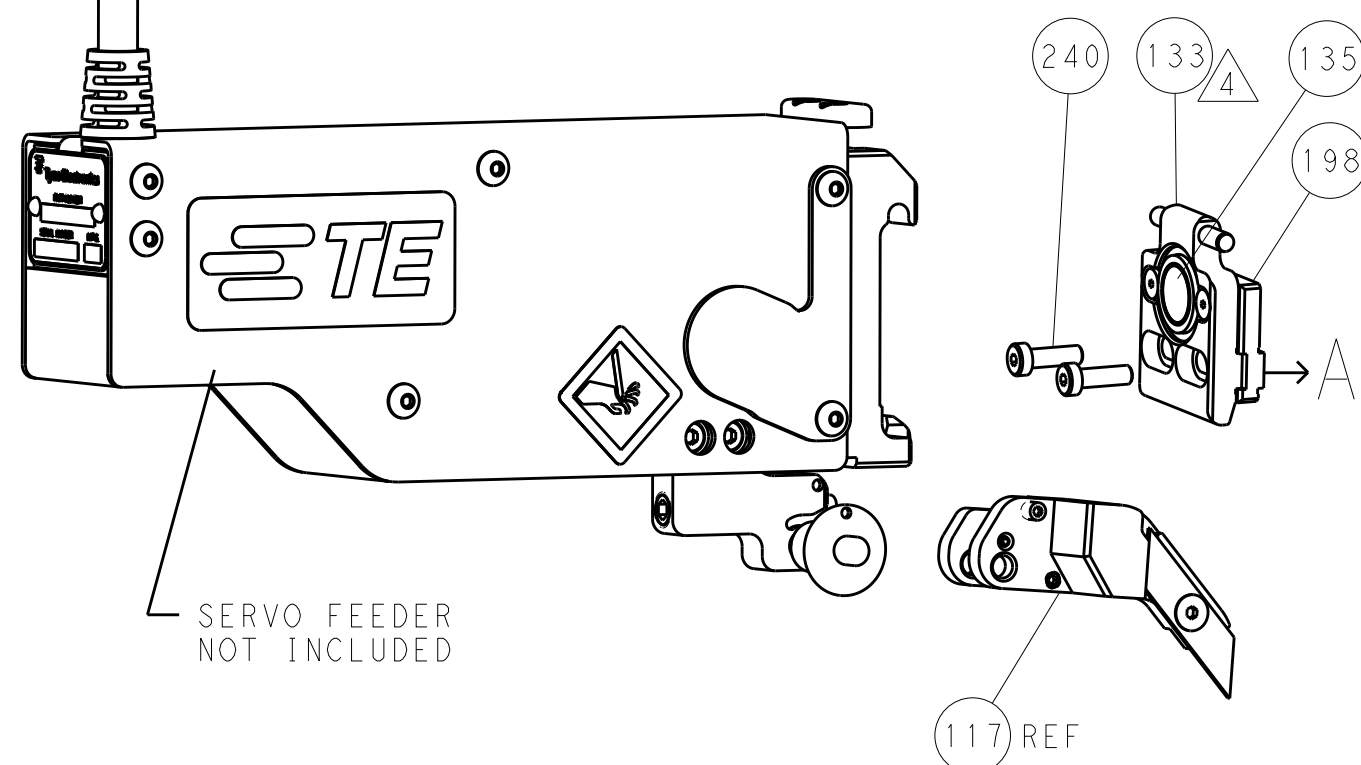
FEED TYPE MECHANICAL



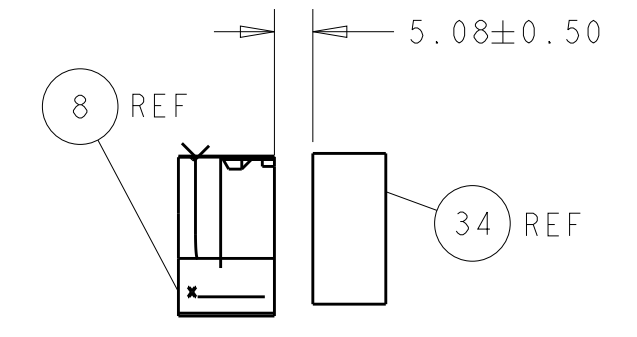
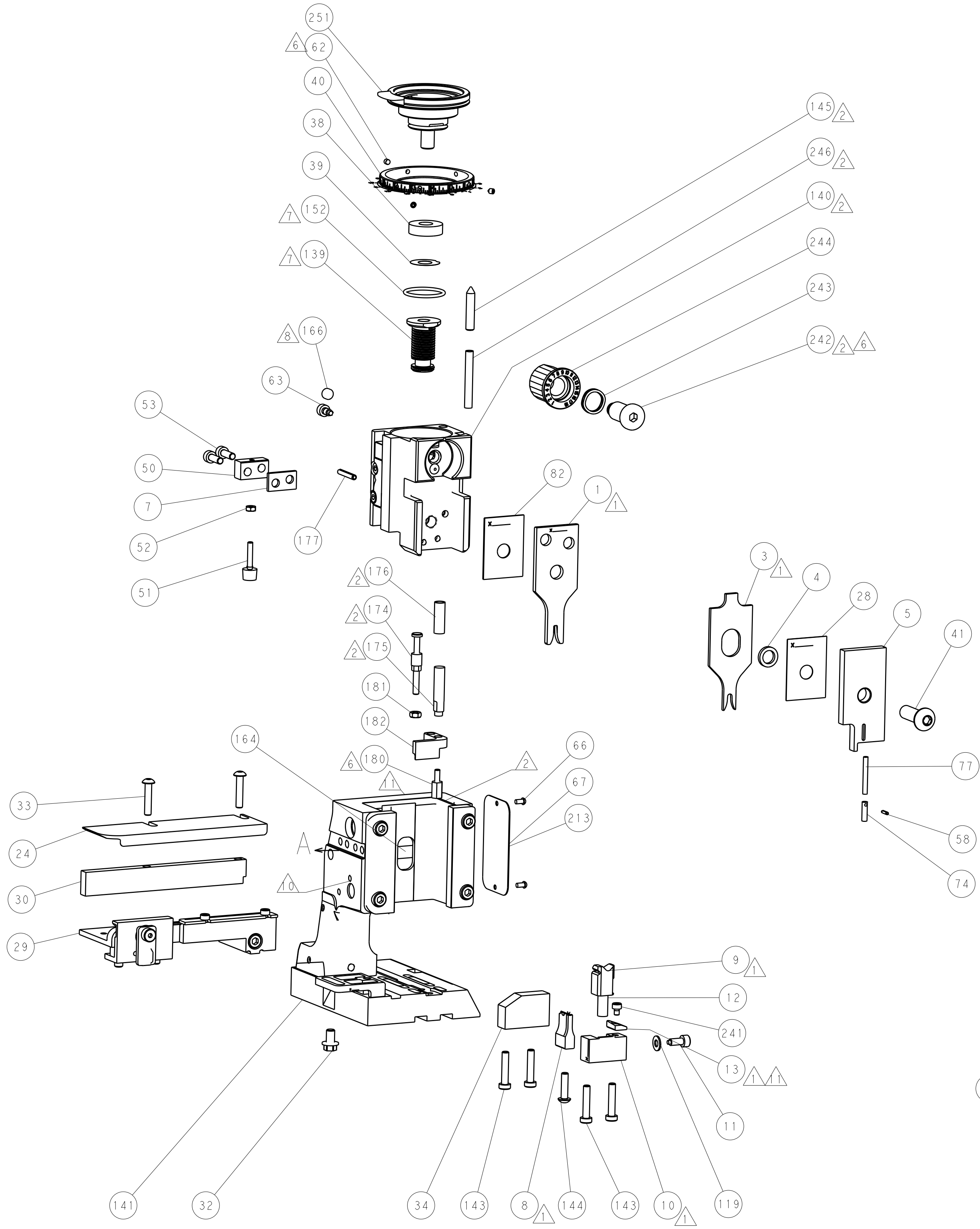
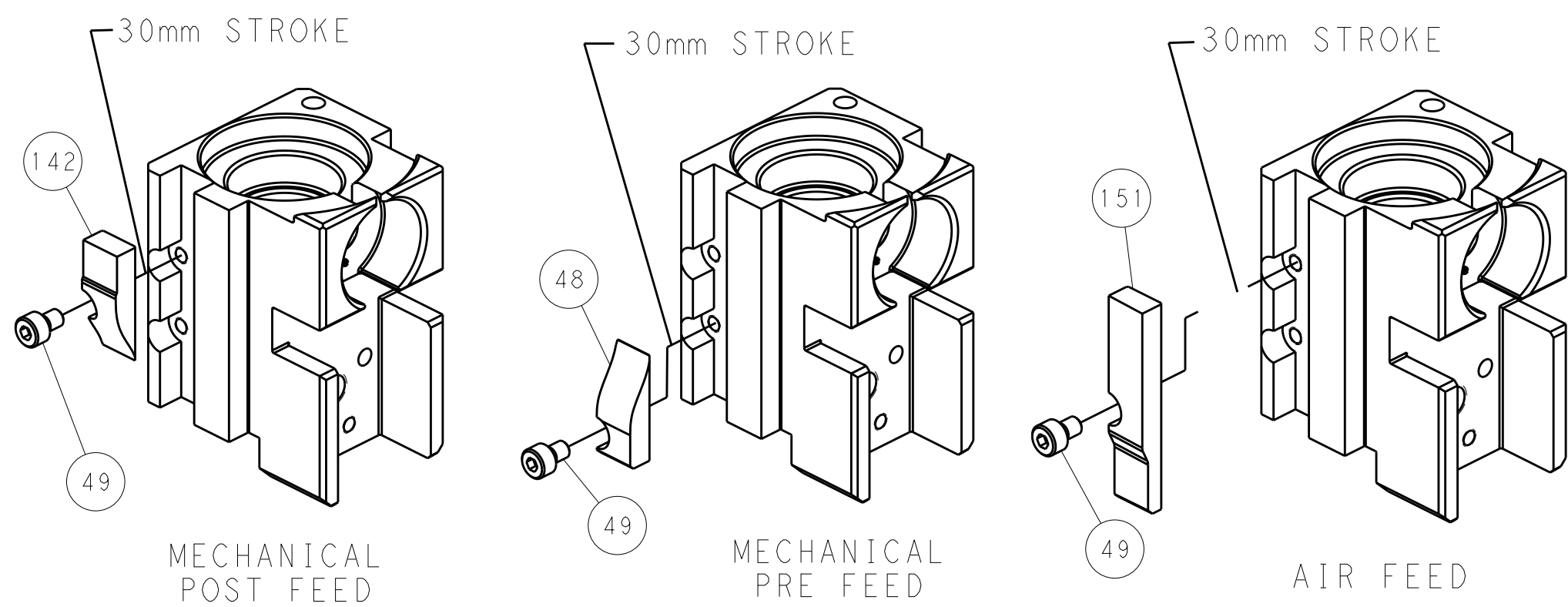
PNEUMATIC



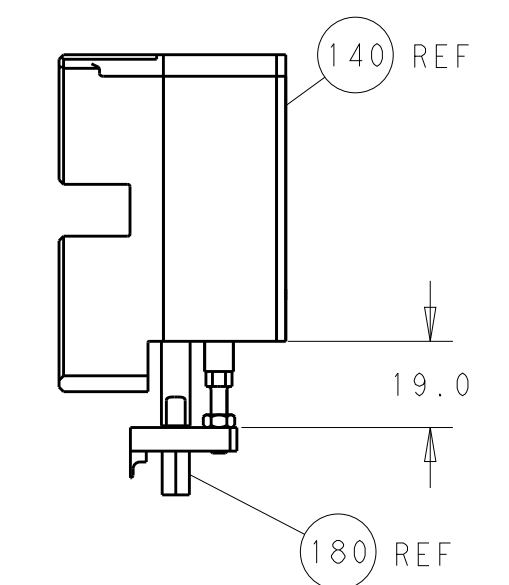
SERVO LATCH PLATE



CAM POSITIONS

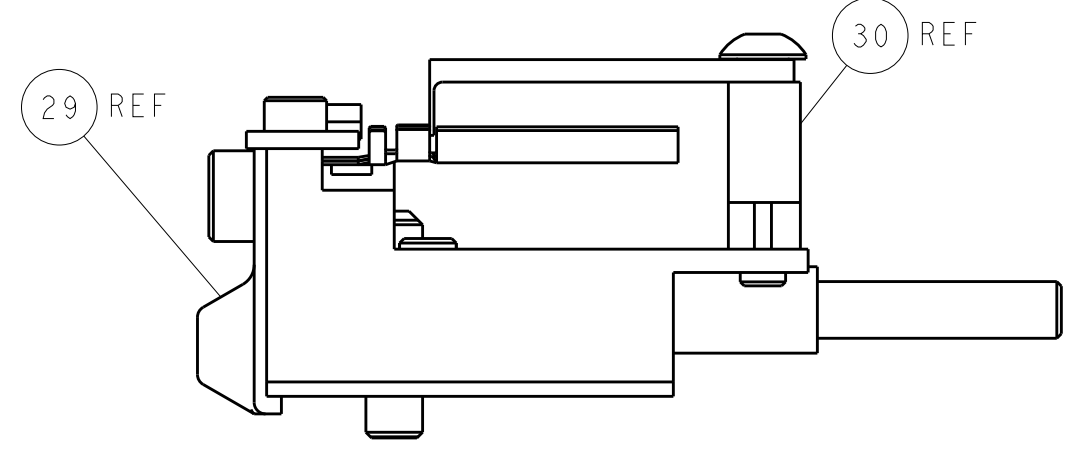


TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 09DEC2014		CHK: L. ZHANG 09DEC2014		APVD: H. GUO 09DEC2014		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WEIGHT	SCALE	SHEET	OF
									1:2	4	4
MATERIAL:								Customer Accessible Production Drawing		REV: B1	