

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2266019-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266019-5	1901094-3	1752354-9	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266019-4	-	-	-
	2266019-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266019-5	1901094-3	1752354-9	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266019-4	-	-	-
	2266019-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
				PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
2266019-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	SERVO LATCH PLATE 12	-	-	-	-	-	-	
2266019-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266019-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [1.080]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: BLADE CONTACT, WIRE TO BOARD CONNECTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.20-2.60 mm [0.087-.102 IN]		Ø1.65-2.03 mm [0.065-.080 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13252	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2058301-1	2058302-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.48+/-0.05 [0.058+/-0.002]	5.5
20 AWG	1.36+/-0.05 [0.054+/-0.002]	6.8
22 AWG	1.33+/-0.05 [0.052+/-0.002]	7.0

- 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: 8-2266019-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266019-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266019-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266019-6
- 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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.32.

**\*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	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252

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

LOC	DIST	REV	DATE	BY	CHK	APP'D
A	66	1	14AUG2013	HUANG		
		2	14AUG2013	ZHANG		
		3	14AUG2013	GUO		

REV	DATE	BY	CHK	APP'D	DESCRIPTION	ITEM NO
1	14AUG2013	HUANG			DEVELOPMENT	UG
A	30AUG2013	ZHANG			RELEASED	GB
-	-	-	-	-	1	250
-	-	-	-	-	2	249
-	-	-	-	-	3	248
-	-	-	-	-	4	247
-	-	-	-	-	5	246
-	-	-	-	-	6	245
-	-	-	-	-	7	241
-	-	-	-	-	8	240
-	-	-	-	-	9	239
-	-	-	-	-	10	238
-	-	-	-	-	11	213
-	-	-	-	-	12	198
-	-	-	-	-	13	180
-	-	-	-	-	14	177
-	-	-	-	-	15	176
-	-	-	-	-	16	175
-	-	-	-	-	17	174
-	-	-	-	-	18	172
-	-	-	-	-	19	166
-	-	-	-	-	20	164
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-	-	-	-	-	26	119
-	-	-	-	-	27	117
-	-	-	-	-	28	82
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-	-	-	-	-	69	5
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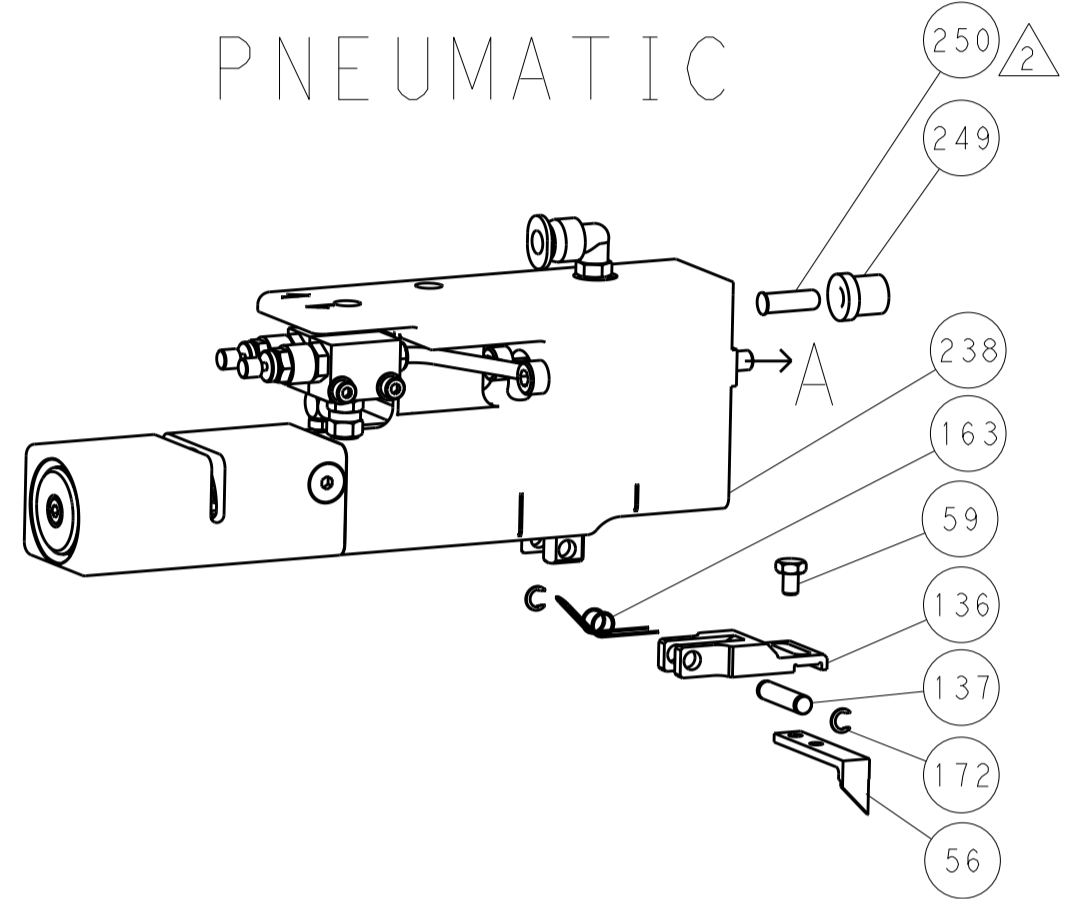
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mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	14AUG2013	HUANG			TE Connectivity
	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.001	14AUG2013	ZHANG			Harrisburg, PA 17105-3608
MATERIAL	FINISH	WEIGHT		14AUG2013	GUO			Ocean Side Feed Applicator
								SIZE CASE CODE DRAWING NO RESTRICTED TO
								A1 00779 C=2266019
Customer Accessible Production Drawing			SCALE	SHEET	1	OF	4	REV
			1:2					A

LOC		DIST		REVISIONS				
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD	
		-		SEE SHEET 1				

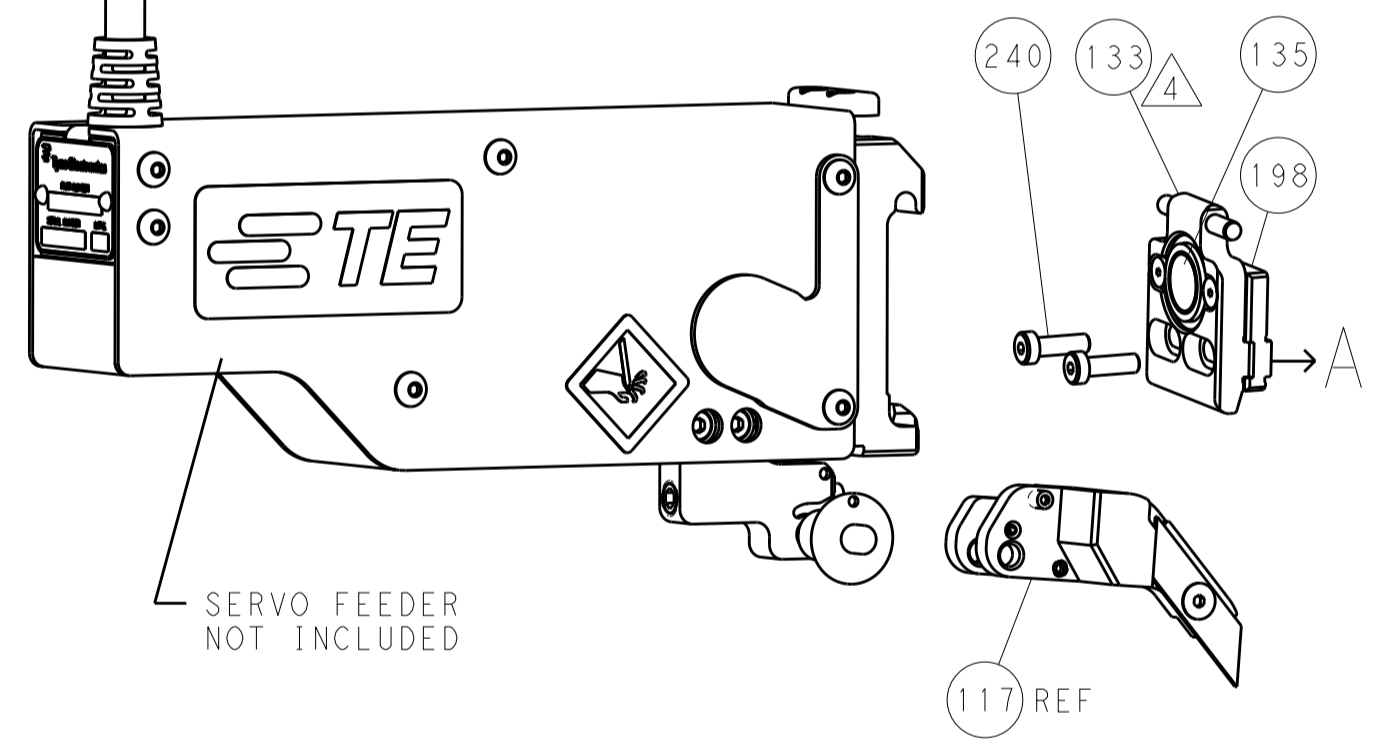
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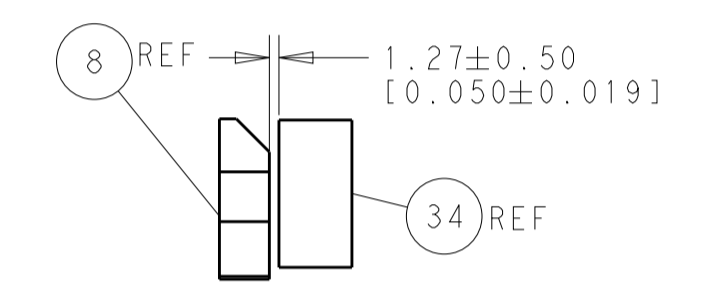
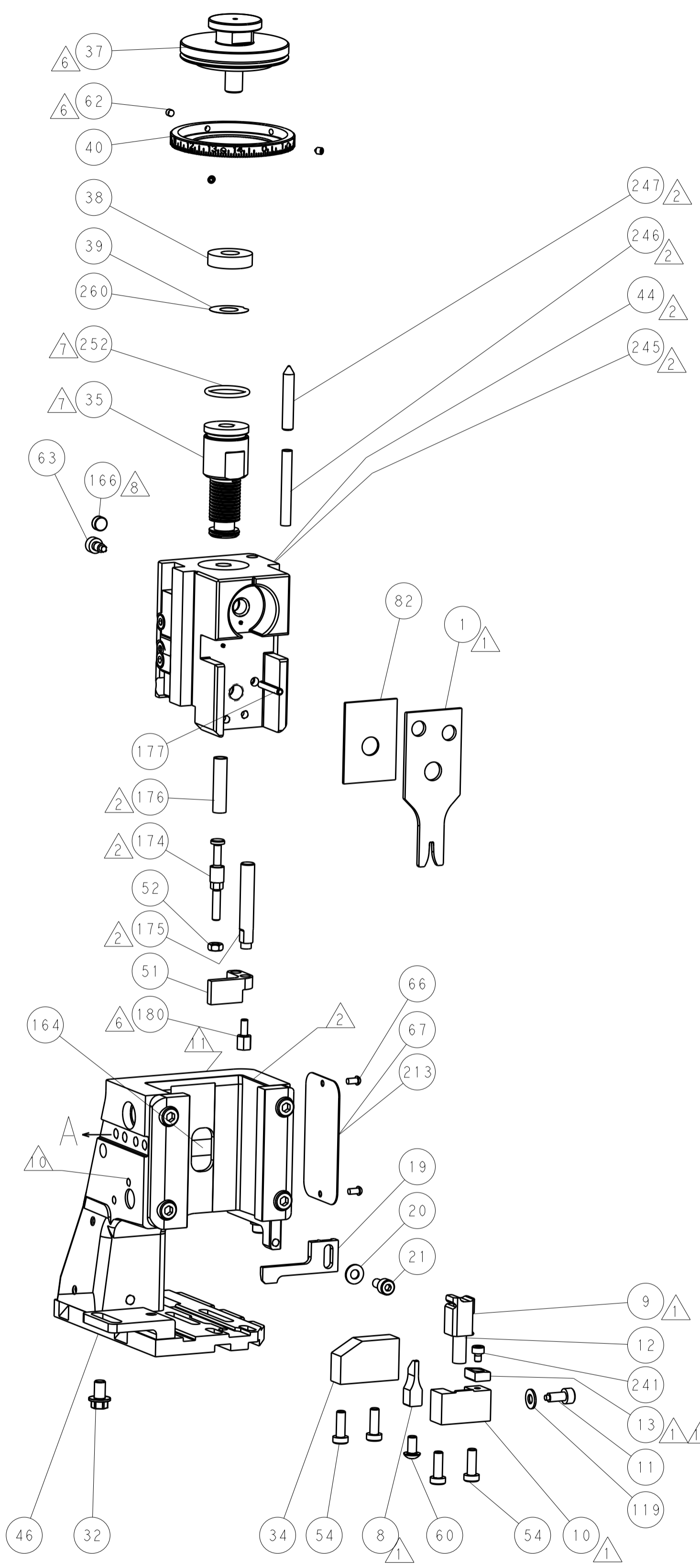
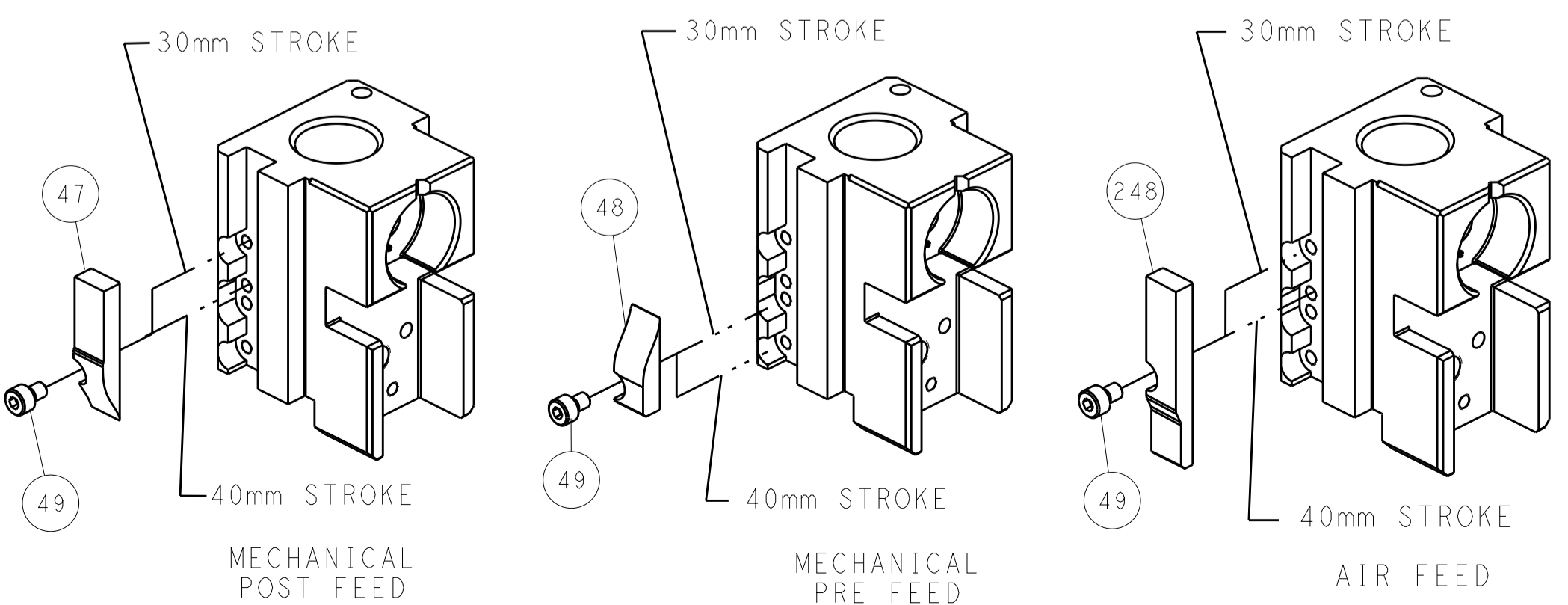
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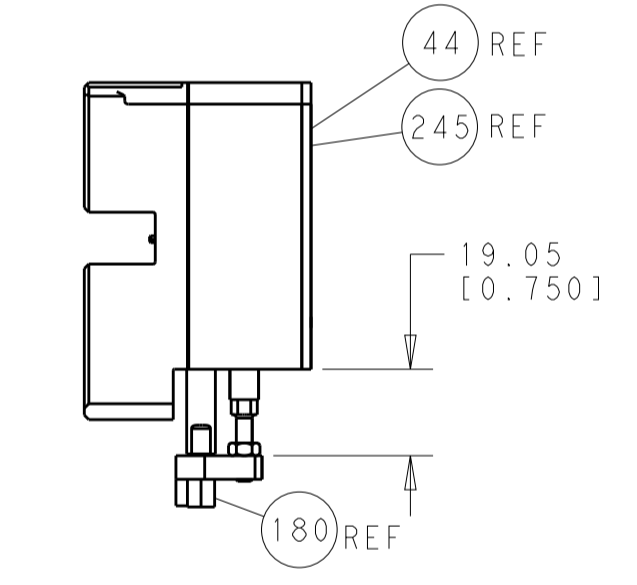
### SERVO LATCH PLATE



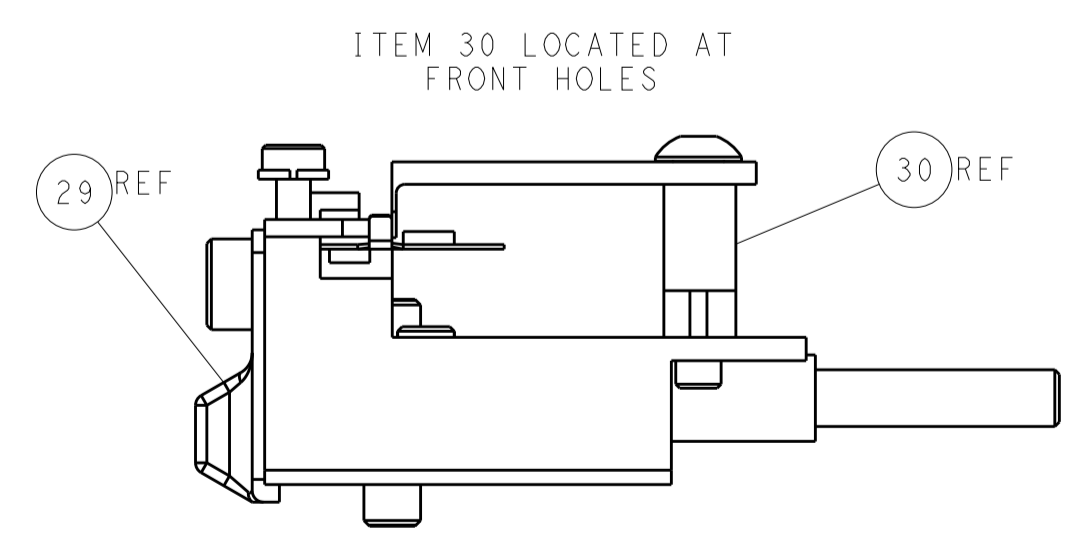
### CAM POSITIONS



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:		DWG: R. HUANG 14AUG2013		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	CHK: L. ZHANG 14AUG2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
				SIZE: A1		CAGE CODE: 00779	
				DRAWING NO: C=2266019		SCALE: 1:2	
				SHEET: 2 of 4		REV: A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266019-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266019-5	1901094-3	1752354-9	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266019-4	-	-	-
	2-2266019-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266019-5	1901094-3	1752354-9	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266019-4	-	-	-
	2-2266019-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2266019-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266019-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: BLADE CONTACT, WIRE TO BOARD CONNECTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.20-2.60 mm [ .087-.102 IN ]		Ø1.65-2.03 mm [ .065-.080 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-13252	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2058301-1	2058302-1		

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.48 +/- 0.05 [ .058 +/- .002 ]	5.5
20 AWG	1.36 +/- 0.05 [ .054 +/- .002 ]	6.8
22 AWG	1.33 +/- 0.05 [ .052 +/- .002 ]	7.0

- 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: 8-2266019-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266019-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266019-5
- 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.
- 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.

**\*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.

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	-	-	-

-	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	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
-	1	1	1	1	1752354-9	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	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
-	-	-	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
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-9	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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	1338685-1	PAWL, FEED	56
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	-	-	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	1752356-1	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	1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	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	462006-6	FLOATING SHEAR, FRONT	9
-	1	1	1	1	3-1633621-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
-	1	1	1	1	5-456405-4	CRIMPER, WIRE PREMIUM	1

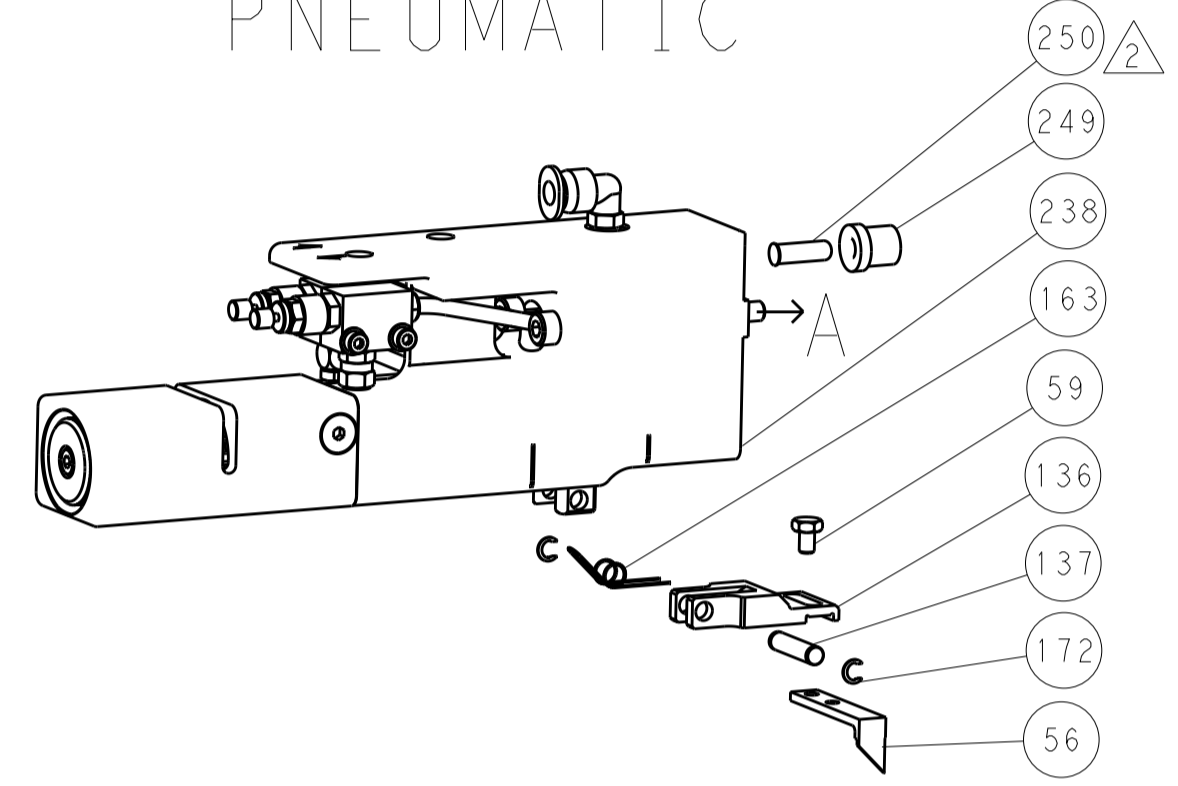
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE	NAME
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	ANGLES ±0.0001	FINISH
MATERIAL		FINISH		WTG	SCALE		
-		-		-	1:2 SHEET 3 OF 4 REV A		

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

# FEED TYPE MECHANICAL



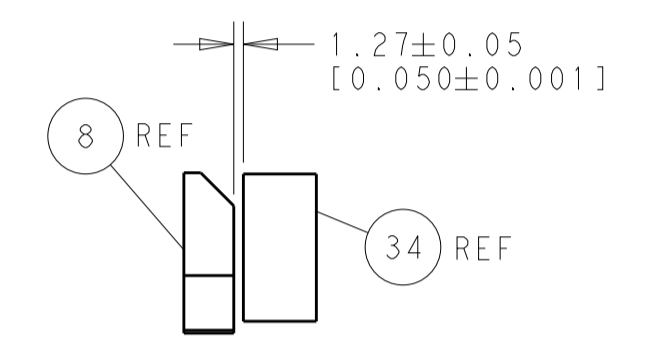
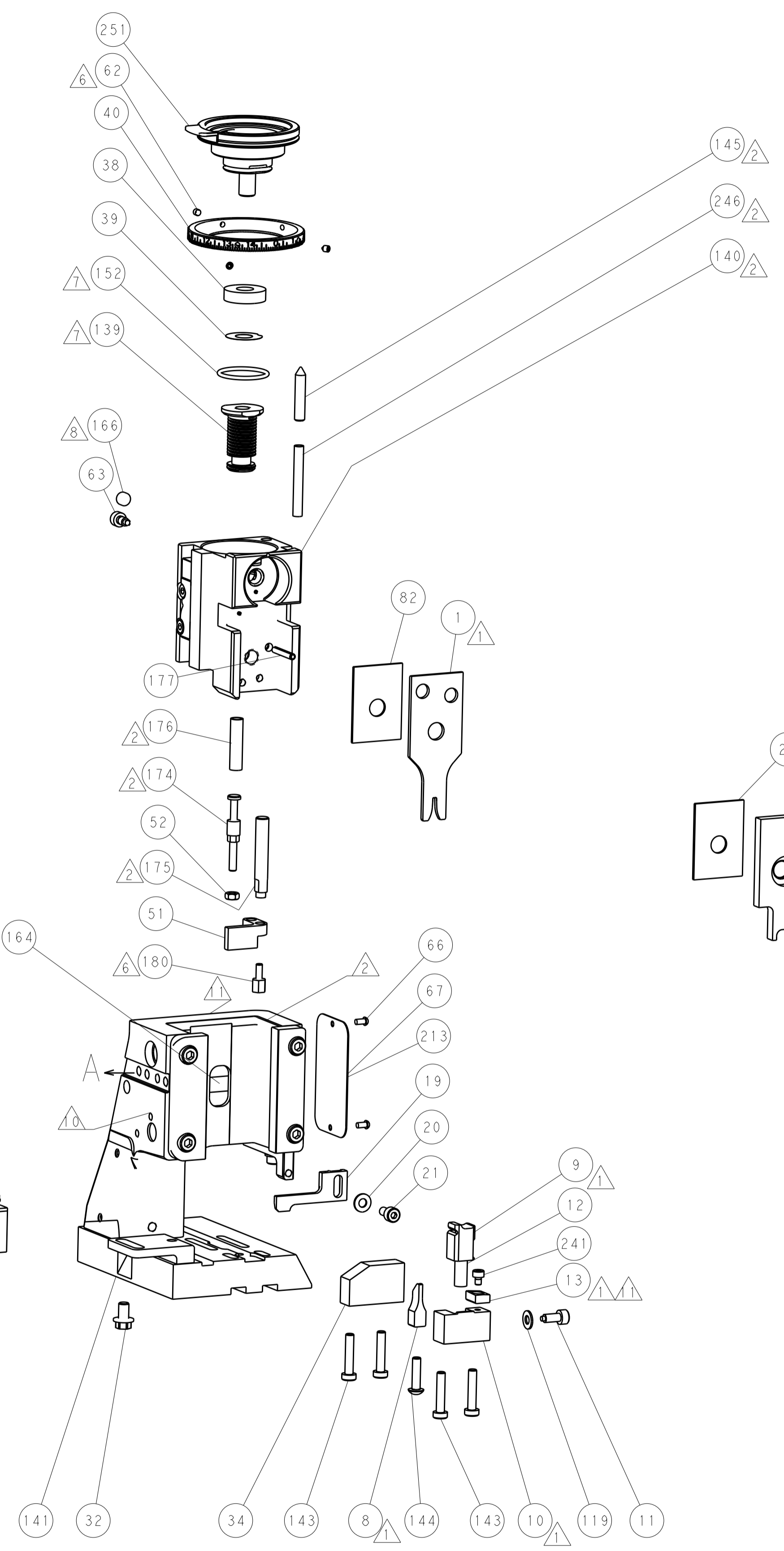
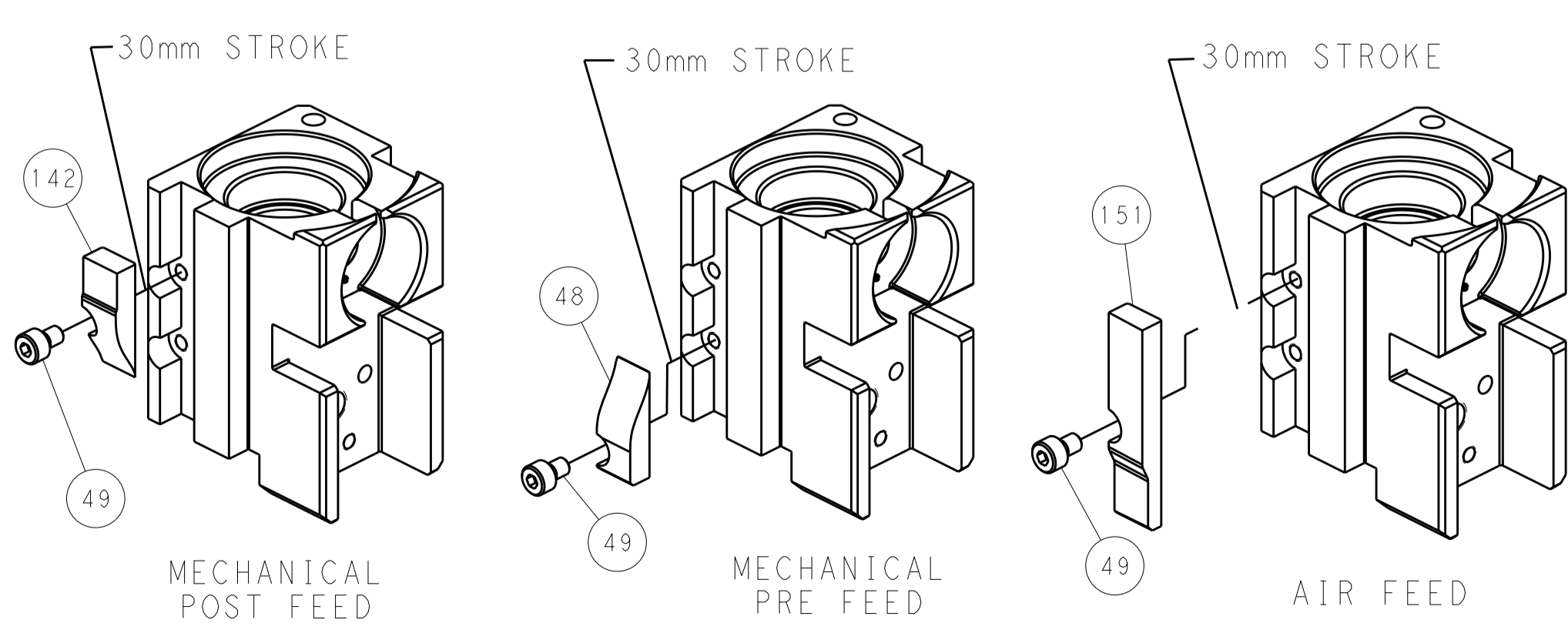
# PNEUMATIC



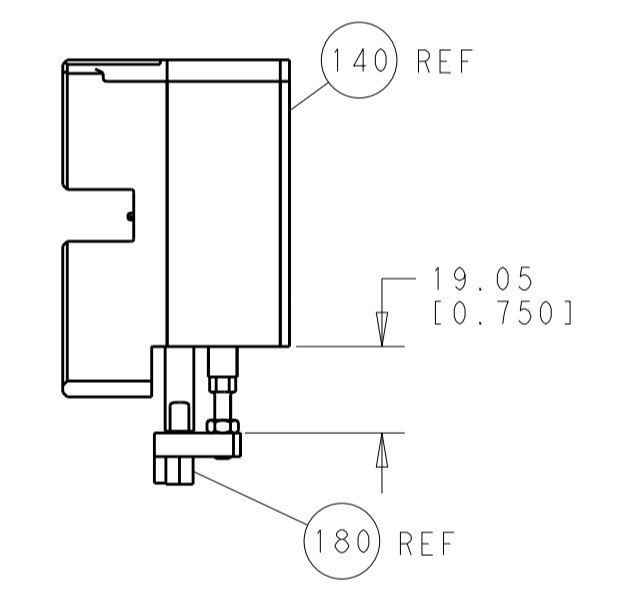
# SERVO LATCH PLATE



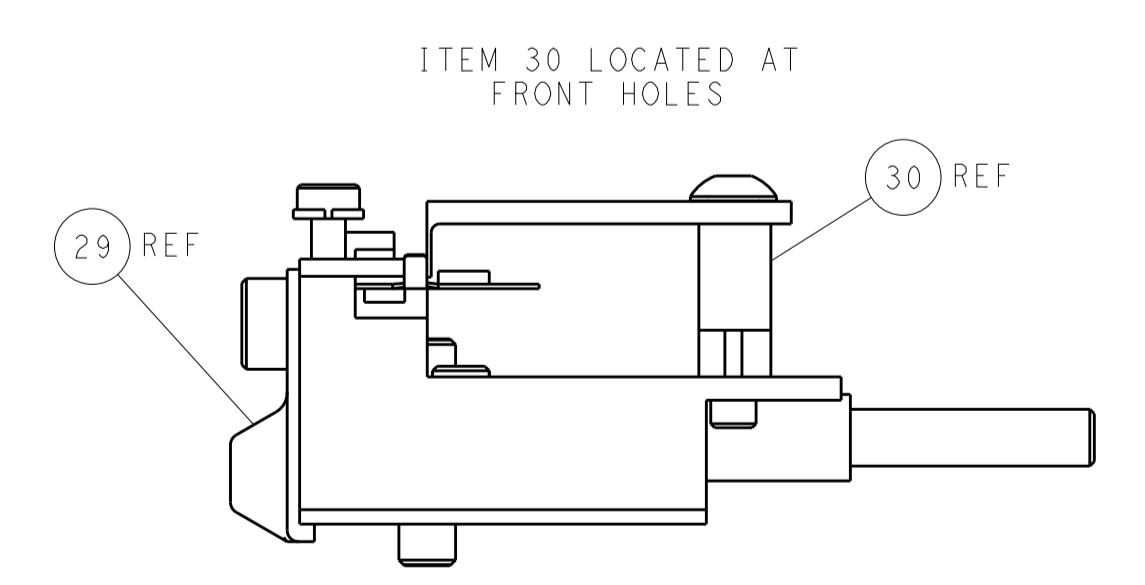
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

**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:		DWN: H. HUANG 14AUG2013		STE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD: L. ZHANG 14AUG2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
				SIZE: A   00779   C=2266019		SCALE: 1:2 SHEET 4 OF 4 REV A	