

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2266220-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2266220-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266220-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266220-4	-	-	
	2266220-5	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
	2266220-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	-	-	-	-	-	-	-
	2266220-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2266220-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.05 mm [.120]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: LEAR TERMINAL	LEAR CRIMP SPECIFICATION
TERMINAL NAME: AFK FEMALE TERMINAL SWS	
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]	INSULATION DIAMETER RANGE Ø 1.2-2.1 mm
TERMINAL APPLICATION SPECIFICATION LEAR SPEC 26041	REVISION S

TERMINALS APPLIED				
TE TERMINAL	LEAR TERMINAL	TE SEAL	LEAR SEAL	CABLE DIAMETER
2113434-1	26041.201.716	1572552-1	14000.627.670	Ø 1.2-2.1 mm
2113434-2	26041.331.185	963530-1		Ø 1.4-1.9 mm
2113434-3	26041.201.702			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.25+/-0.05 [.049+/- .002]	6.1
0.75mm2	1.20+/-0.05 [.047+/- .002]	6.6
0.50mm2	1.15+/-0.05 [.045+/- .002]	7.1

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: 8-2266220-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266220-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266220-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266220-6
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 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
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.
11. 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.
12. WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.55.
13. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.REFER TO TABLE FOR INSULATION RANGES.
14. APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

***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
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250

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	REVISONS	DATE	OWN	APPV
2119599-1	A	66		20MAR2014	XZ	GB

F	LTN	DESCRIPTION	DATE	OWN	APPV
-	-	-	-	-	-
-	-	2079988-1			249
-	-	2119641-1			248
-	1	2119798-1			247
-	1	1-22279-3			246
-	-	2119758-1			245
-	1	2119082-8			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	7-18023-7			241
-	-	2168400-6			240
-	-	2119580-1			239
-	-	2063440-1			238
-	-	2119740-2			213
-	-	1901094-3			198
-	-	21045-3			172
-	1	994969-1			166
-	REF	994970-2			164
-	-	240638-1			163
-	-	3-23627-7			137
-	-	2119799-1			136
-	-	SEE NOTE 4			135
-	-	1633743-1			133
-	1	1-18028-2			119
-	-	2119944-1			117
-	1	455888-7			82
-	1	2119956-1			71
-	1	2119740-1			67
-	2	2168078-1			66
-	1	2119793-1			63
-	3	992763-5			62
-	1	2079383-4			60
-	-	5-18022-5			59
-	1	985575-3			57
-	-	1338685-1			56
-	4	2168400-1			54
-	2	1-2168083-0			53
-	1	5018030-1			52
-	1	811242-5			51
-	1	690753-2			50
-	-	18023-9			49
-	-	2119652-1			48
-	-	2119653-1			47
-	1	2119656-9			46
-	1	2119370-1			44
-	1	2079383-7			41
-	1	2119645-1			40
-	1	2119957-1			39
-	1	2119644-1			38
-	1	2119085-1			37
-	1	2119092-1			35
-	1	1-1752356-3			34
-	2	2079383-5			33
-	1	2161328-1			32
-	1	1-1320908-2			30
-	1	2119959-2			29
-	1	1-455888-0			28
-	1	1320928-2			24
-	1	2168083-2			21
-	1	1-18028-2			20
-	1	2119533-1			19
-	1	2119806-1			13
-	1	3-22280-3			12
-	1	1-356885-4			11
-	1	2119805-1			10
-	1	318707-1			9
1	1	2-1633919-3			8
-	-	-			7
-	-	-			6
-	1	2119781-1			5
-	1	238011-4			4
1	1	1633965-2			3
-	1	455888-5			2
1	1	3-456404-0			1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	CHK	DATE	REV
mm	0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001	X ZHAO	L ZHANG	04MAR2014	04MAR2014
MATERIAL:		FINISH:		WEIGHT:	
				A1 00779 C=2266220	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 1 OF 4 REV A	

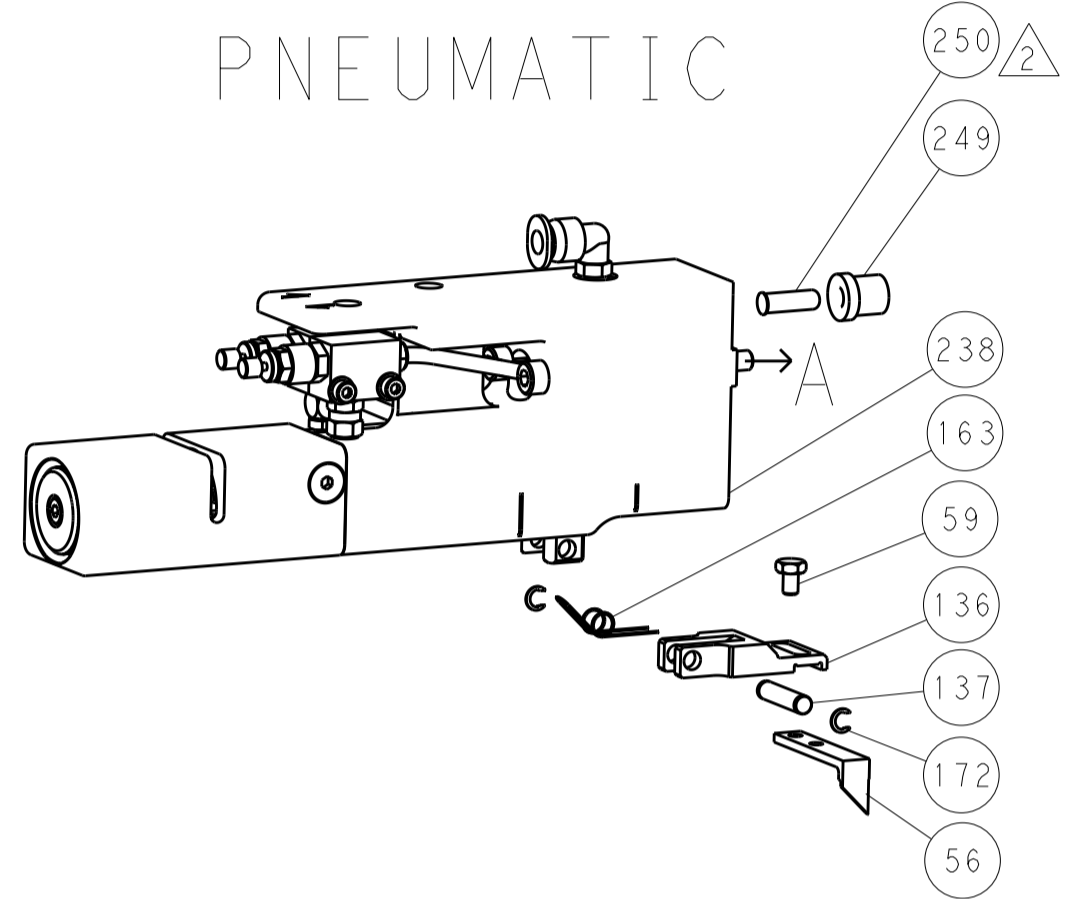
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

REVISONS		DATE	DWN	APVD
P. LTM	DESCRIPTION			
-	SEE SHEET 1	-	-	-

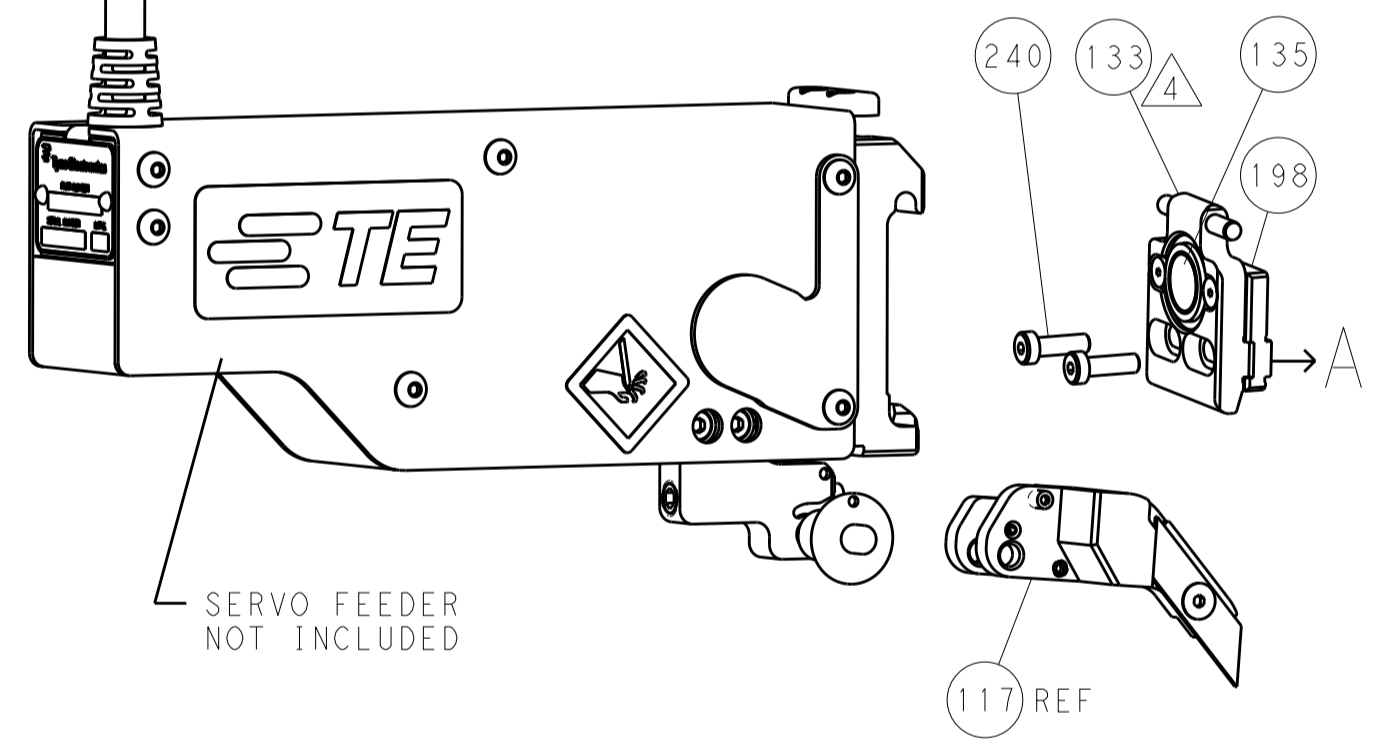
FEED TYPE MECHANICAL



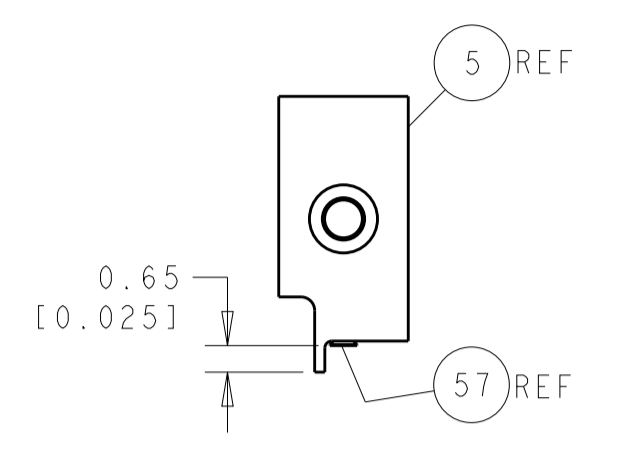
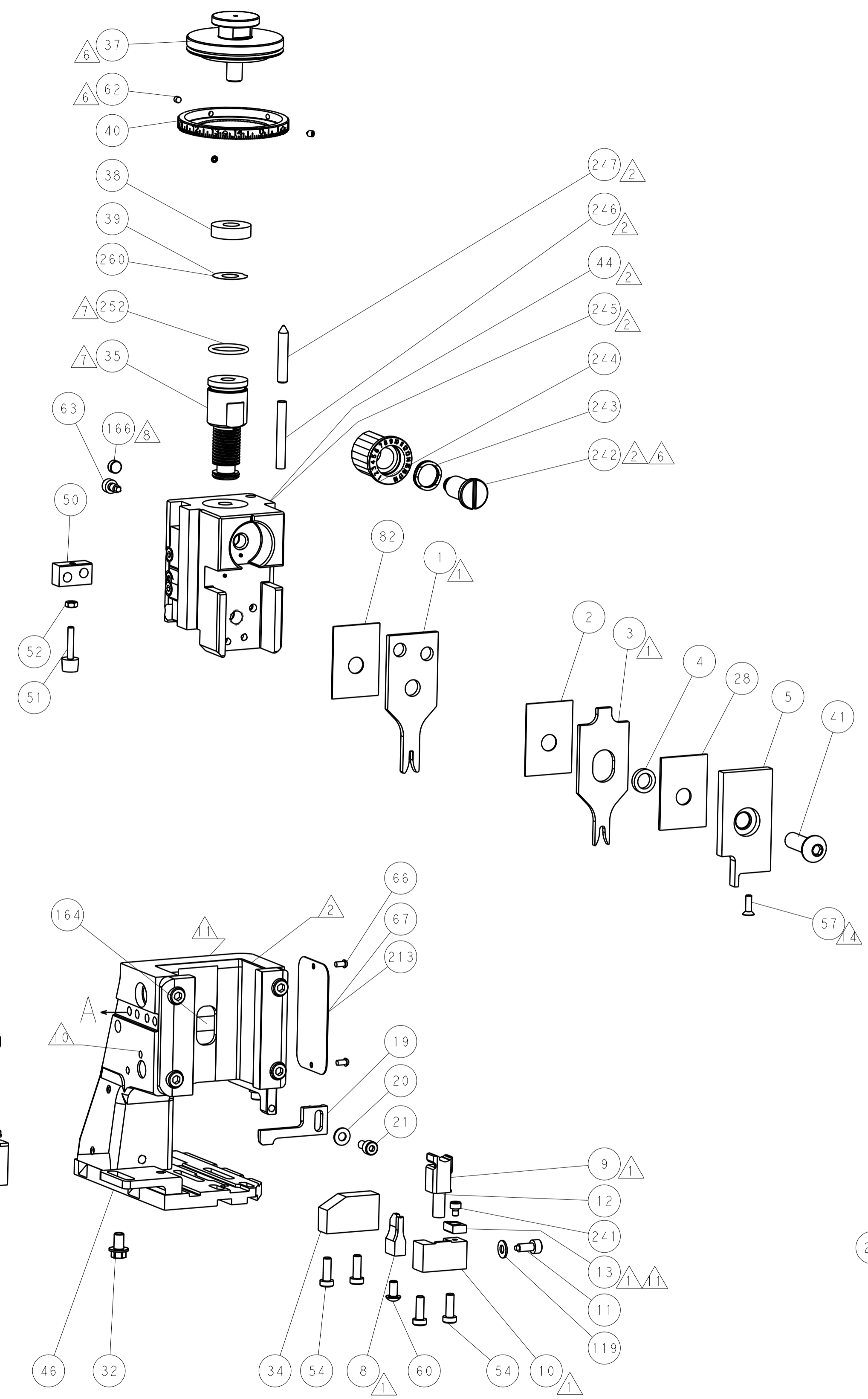
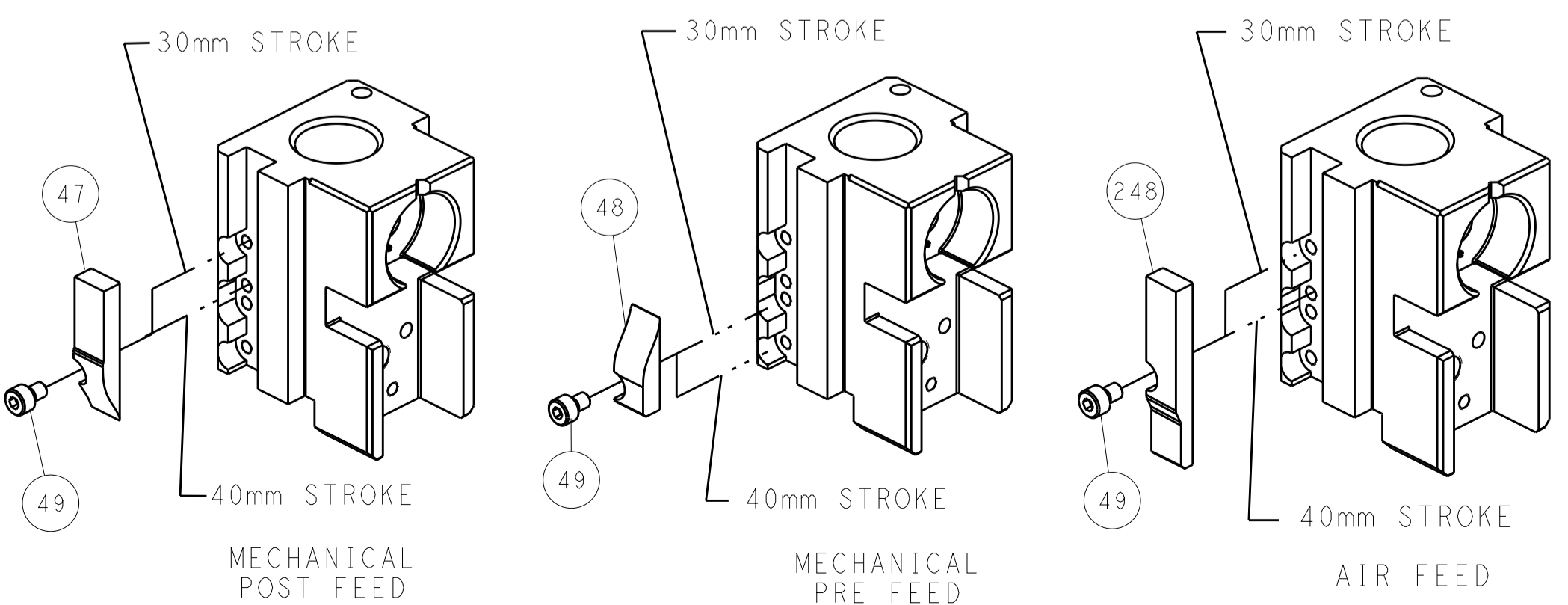
PNEUMATIC



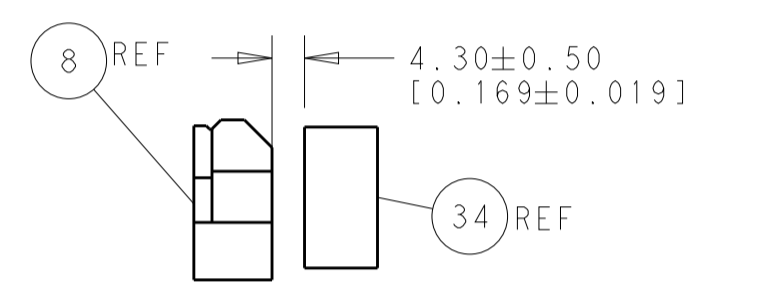
SERVO LATCH PLATE



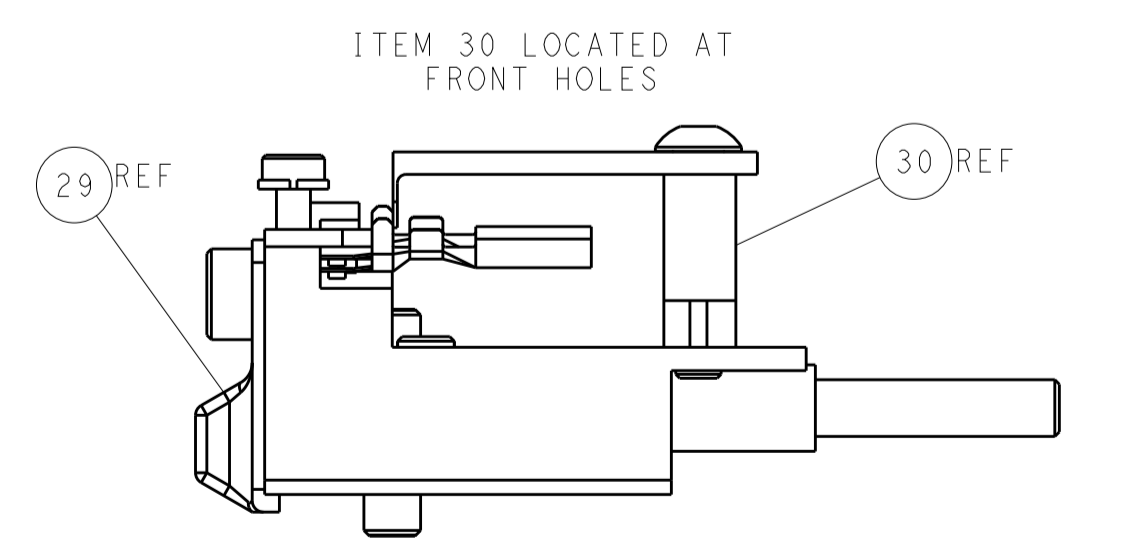
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



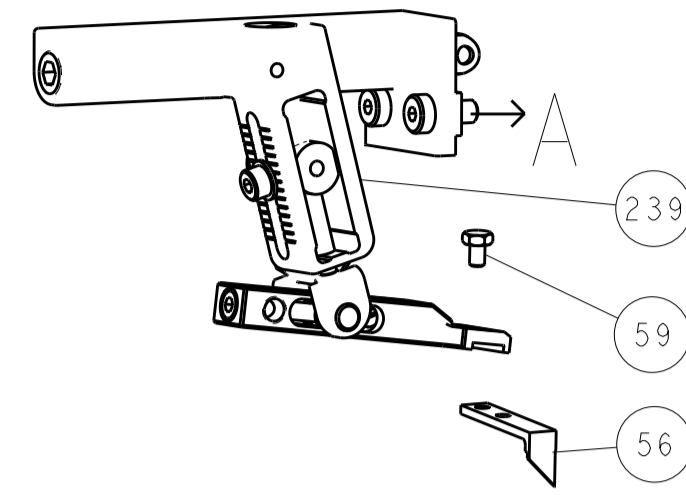
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

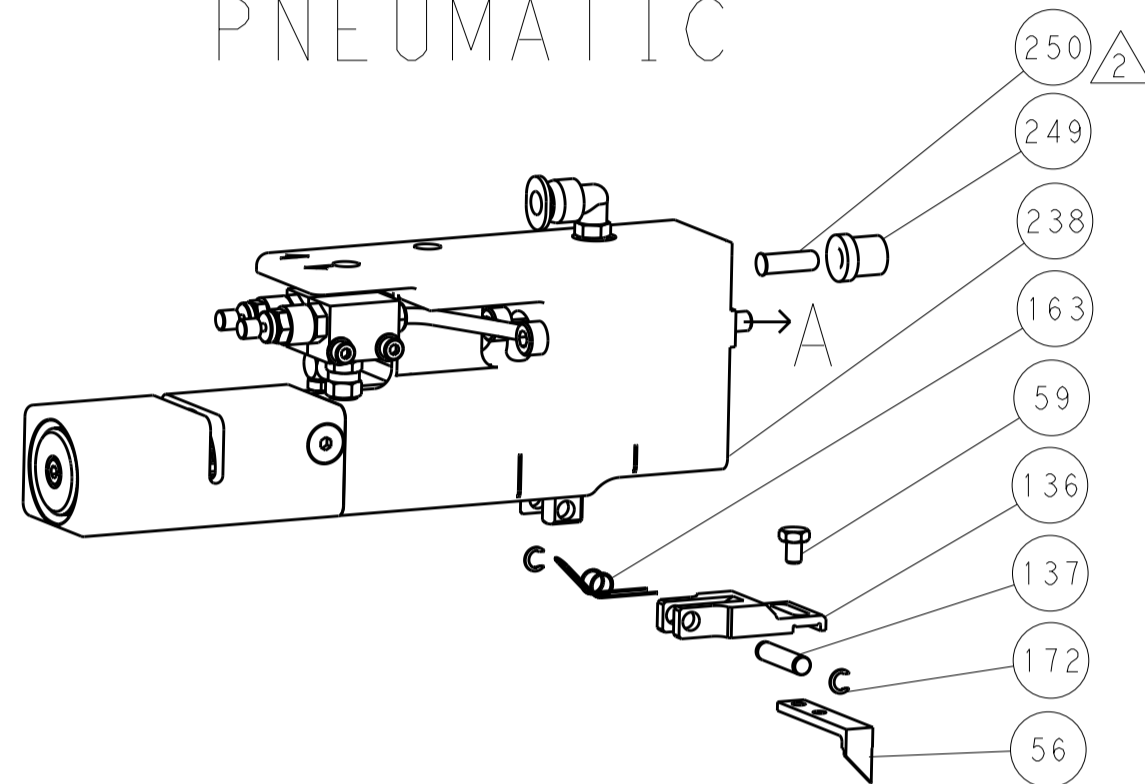
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mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD L ZHANG 04MAR2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME		Ocean Side Feed Applicator	
				SIZE		RESTRICTED TO	
				A1 00779 ©=2266220		Customer Accessible Production Drawing	
				SCALE		SHEET 2 of 4 REV A	

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

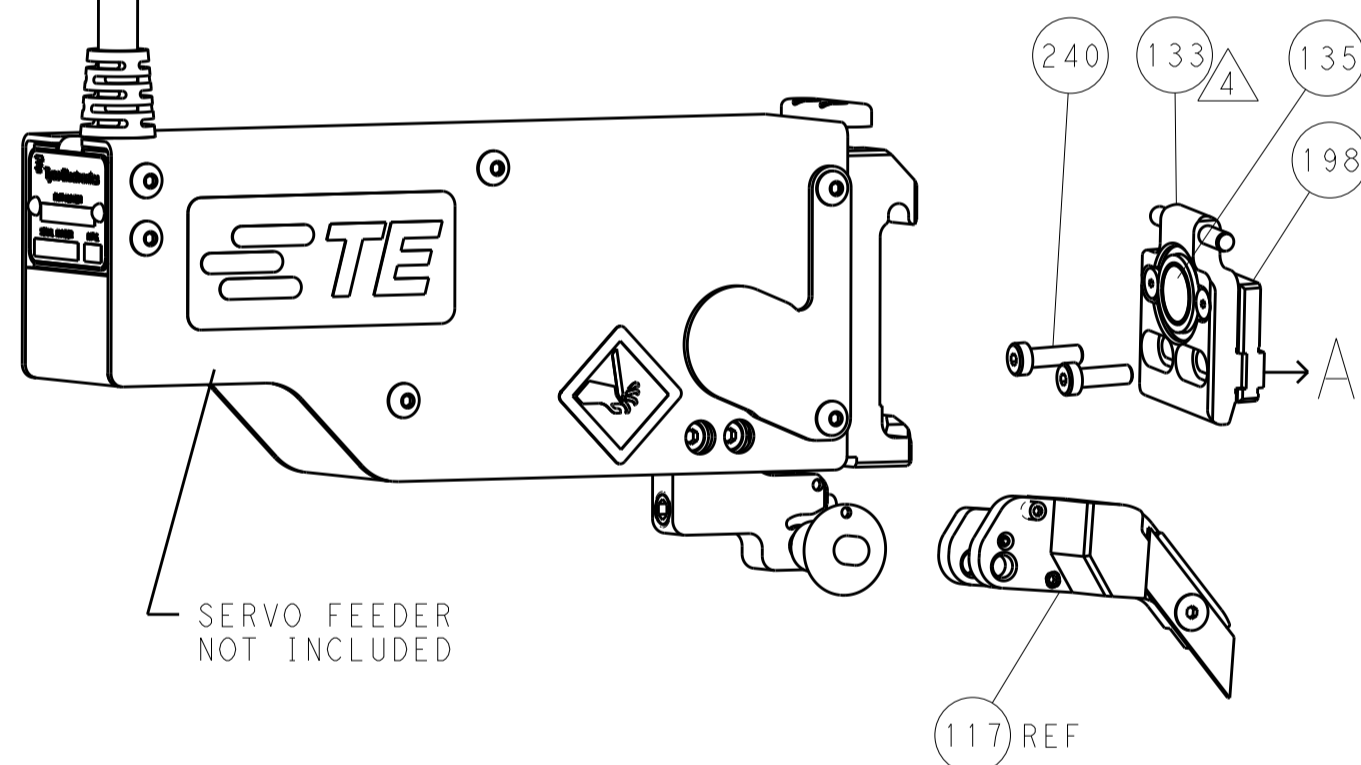
FEED TYPE MECHANICAL



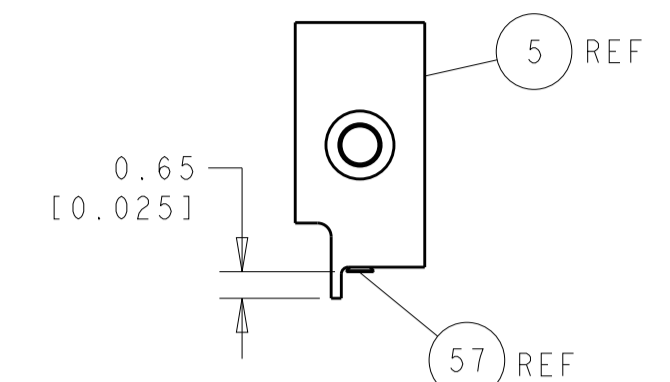
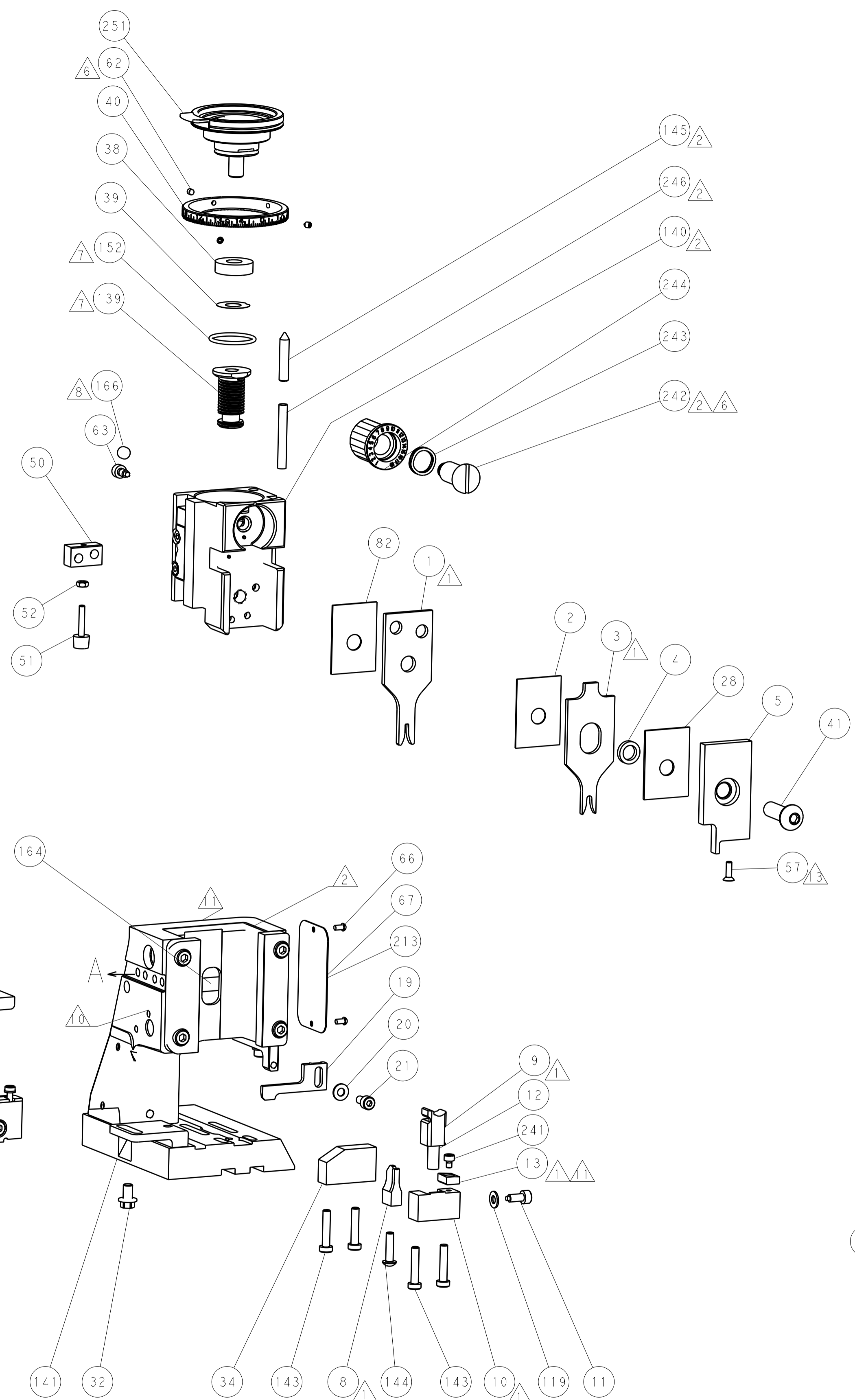
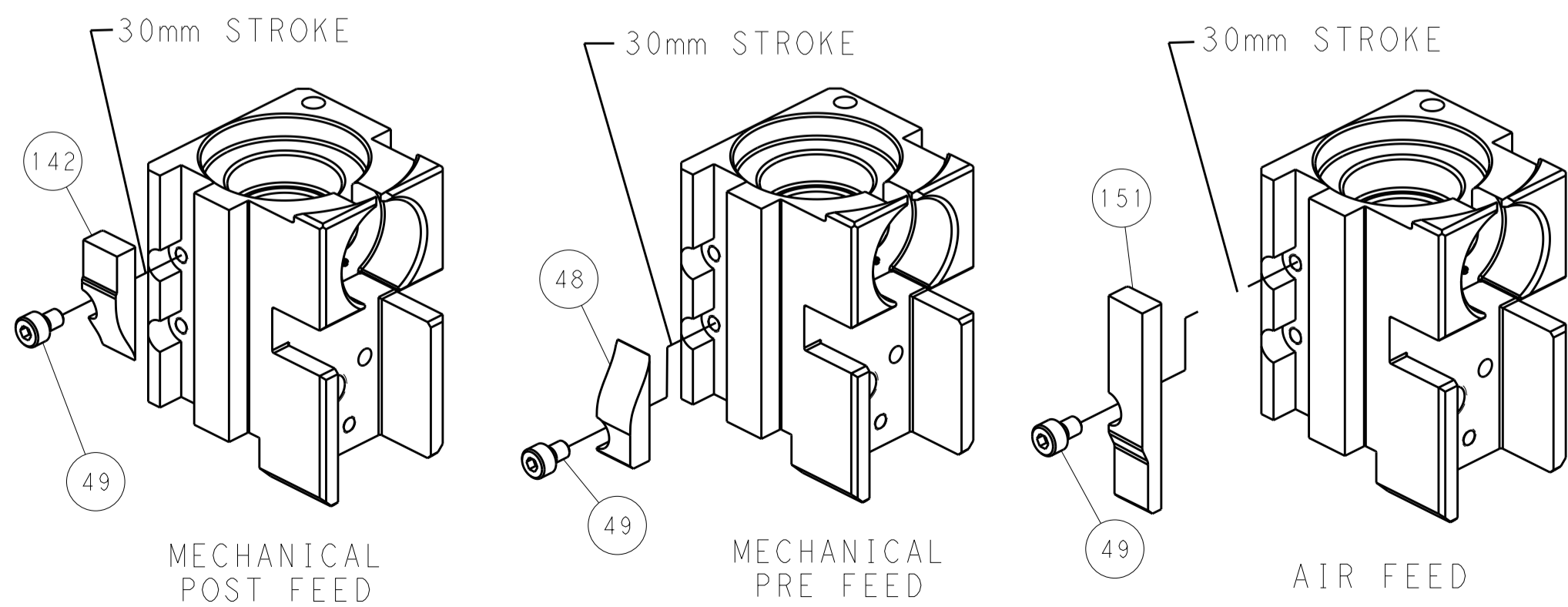
PNEUMATIC



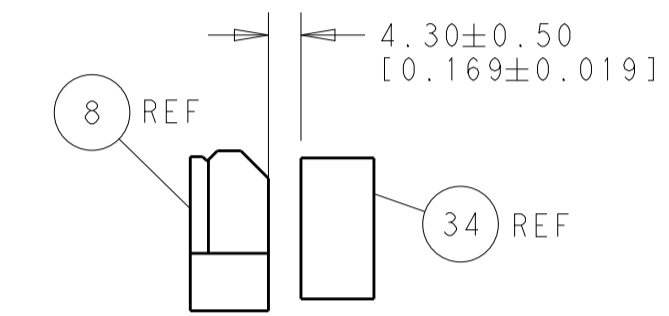
SERVO LATCH PLATE



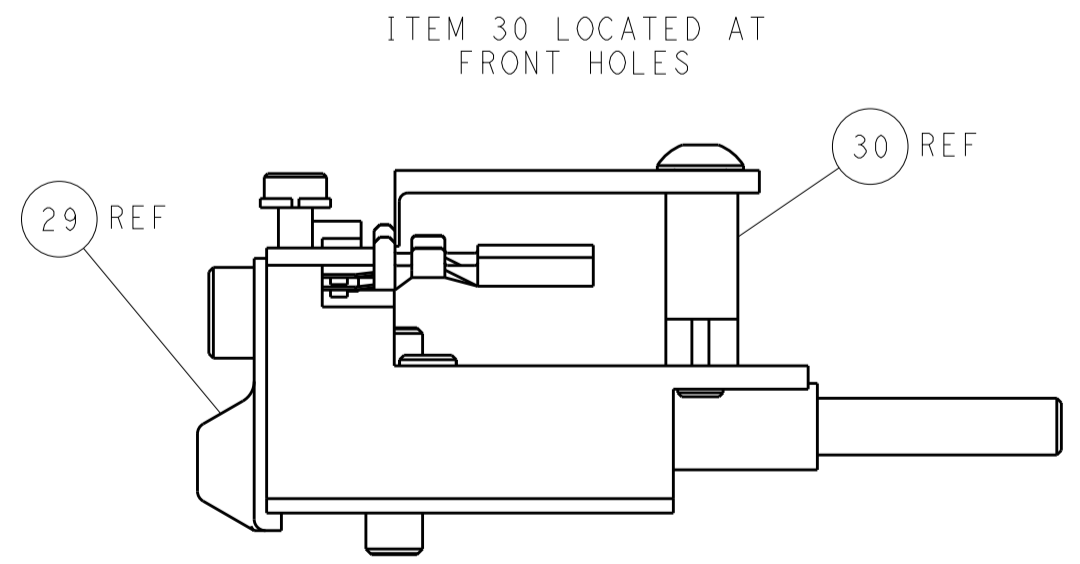
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X. ZHAO 04MAR2014		CHK: L. ZHANG 04MAR2014		APVD: T. ELBIN 04MAR2014		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.001	PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: A11 00779 C=2266220		RESTRICTED TO:
MATERIAL:	FINISH:	WEIGHT:		SCALE: 1:2		SHEET 4 OF 4		REV A		Customer Accessible Production Drawing	