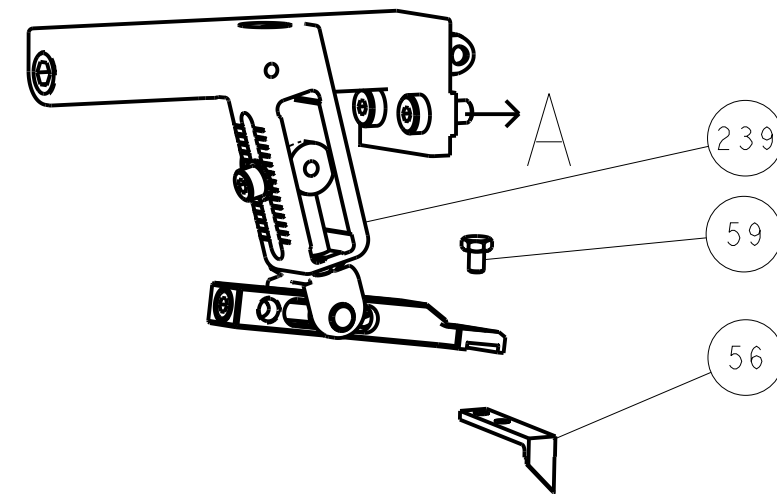
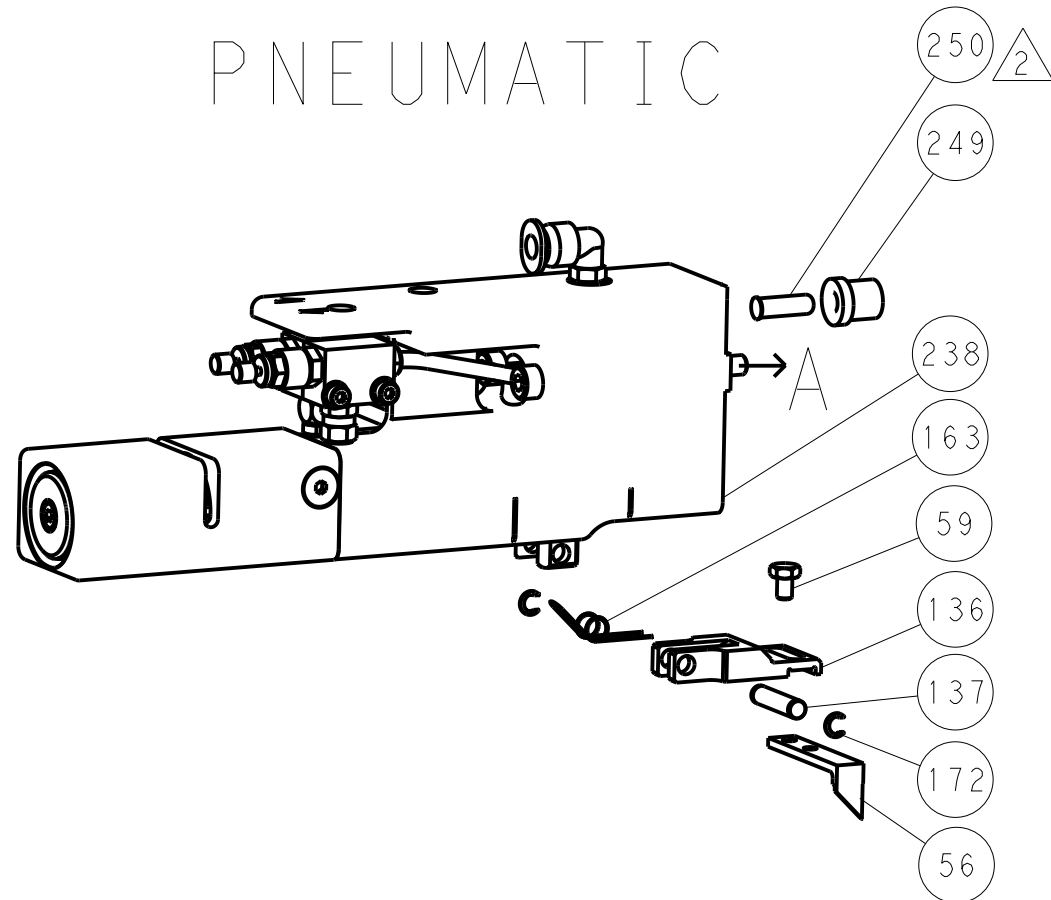


LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

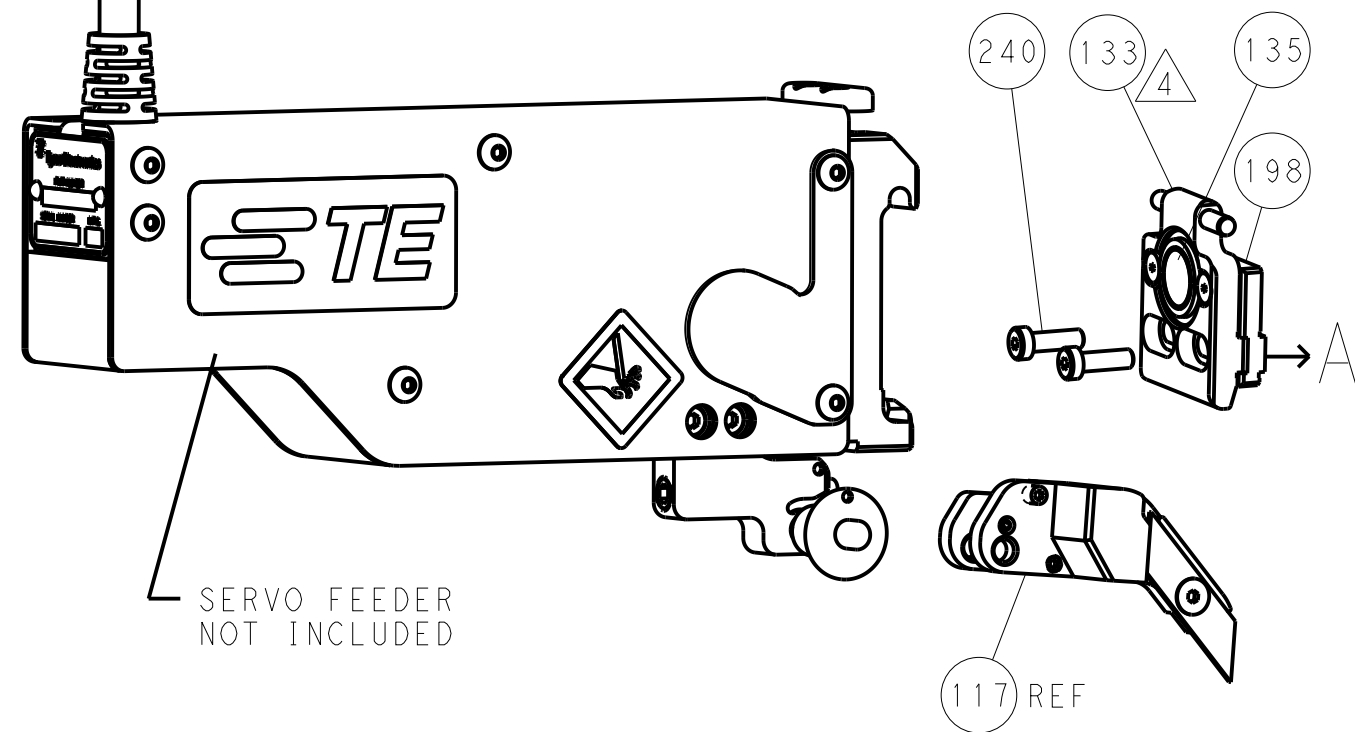
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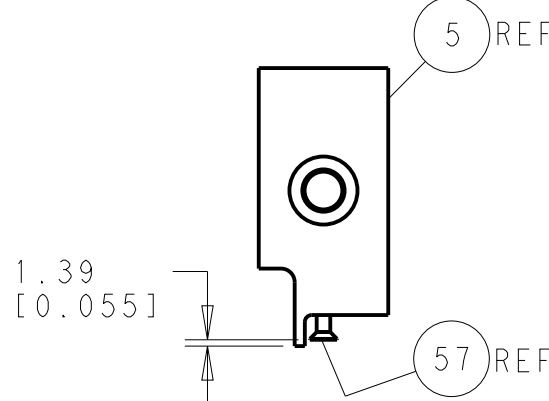
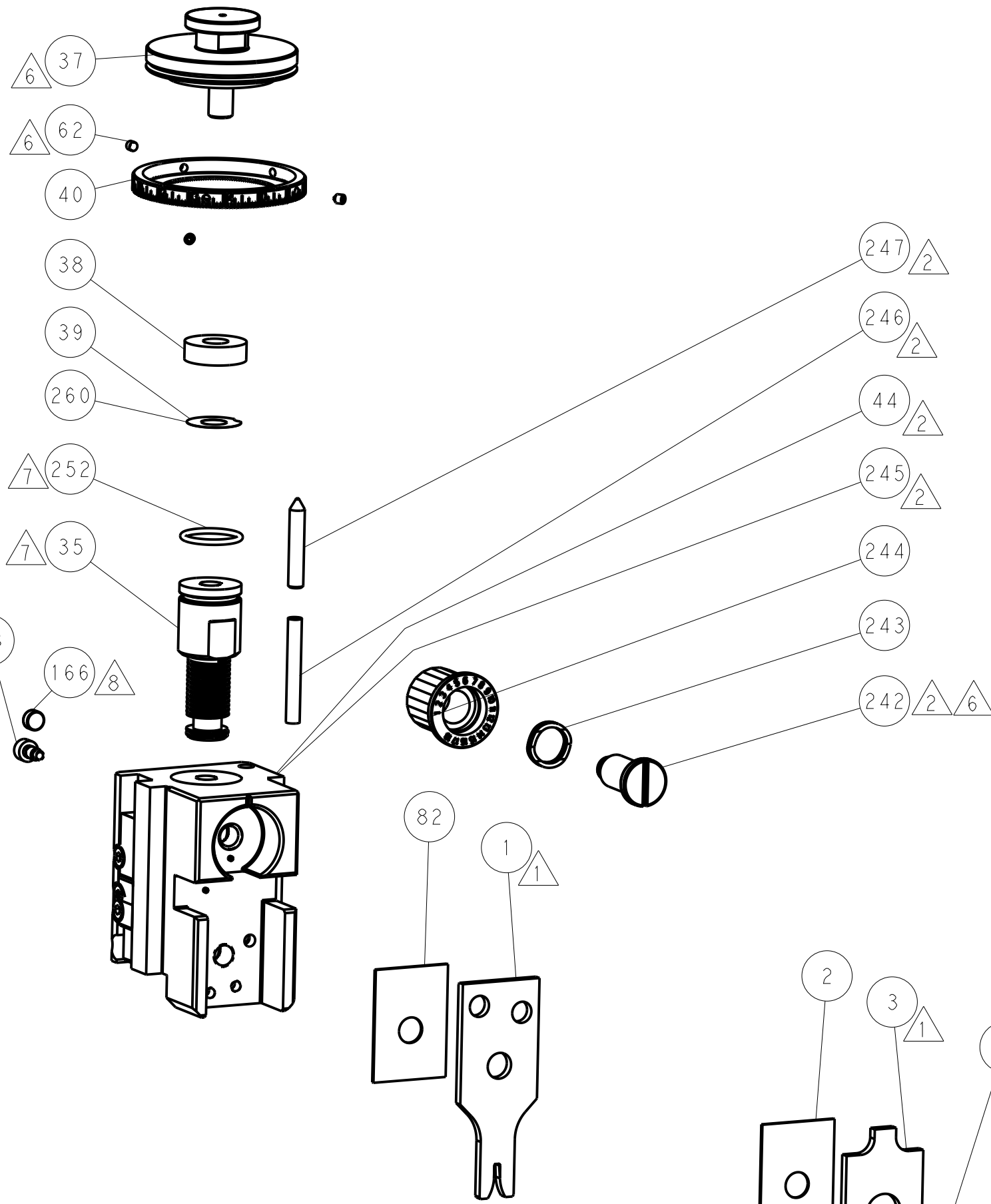
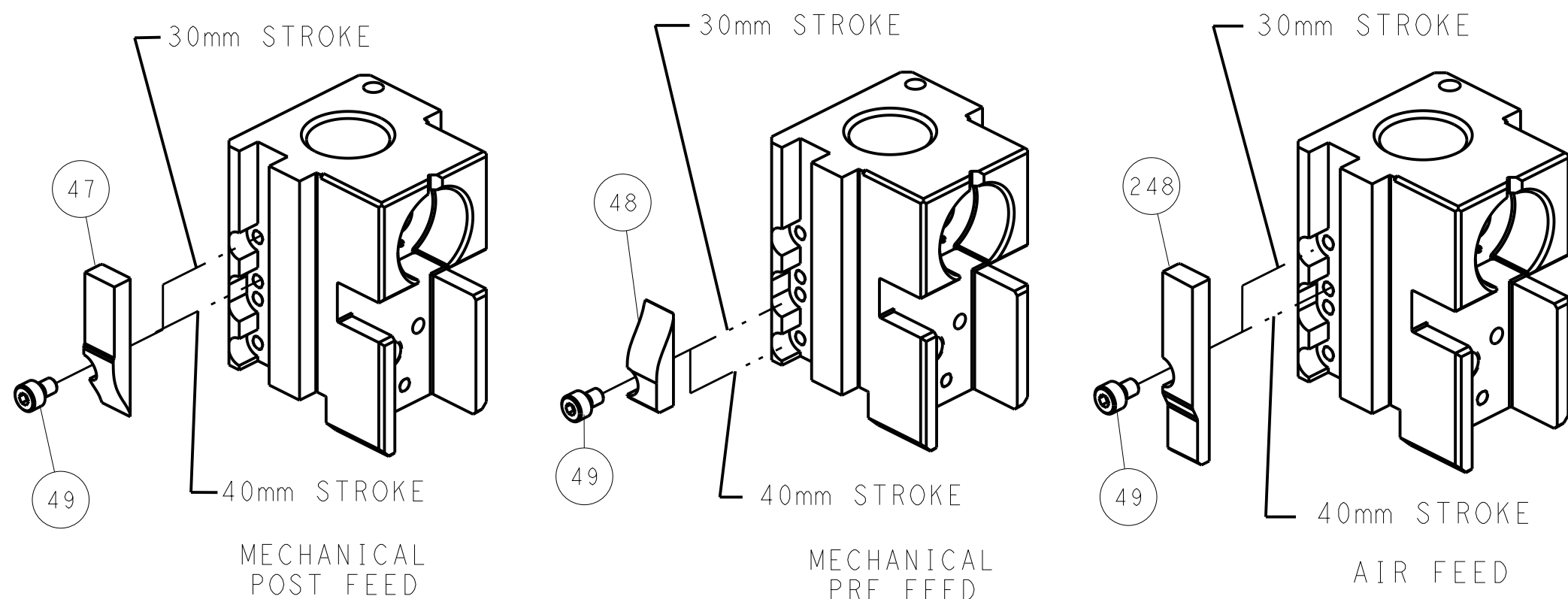
PNEUMATIC



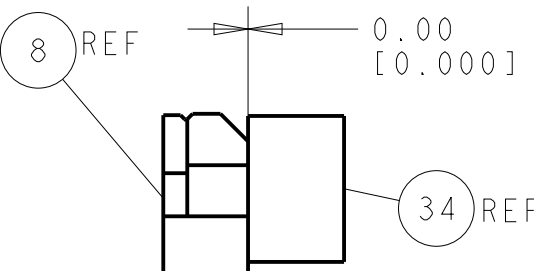
SERVO
LATCH PLATE



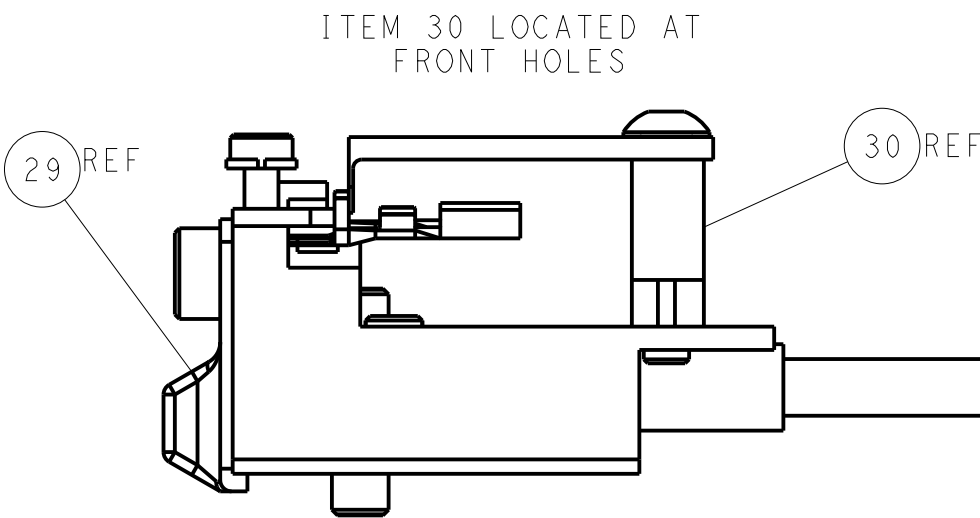
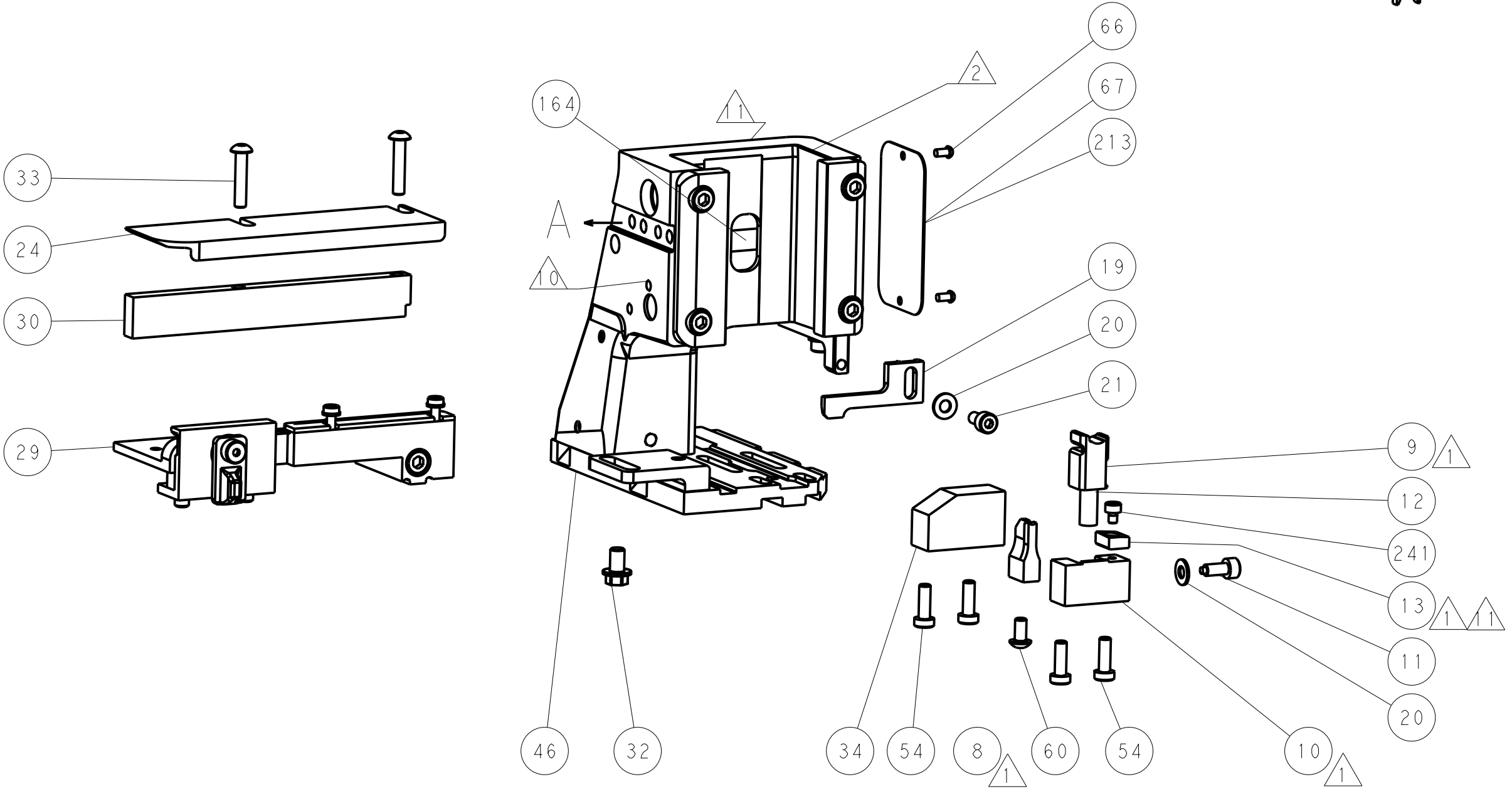
CAM POSITIONS



SHEAR DEPRESSOR DETAIL




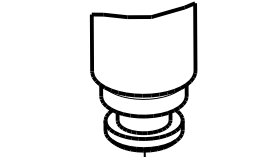

TERMINAL SUPPORT LOCATION




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)

1. THIS DRAWING IS TO BE CONSIDERED VALID FOR THE ENTIRE LIFE OF THE ORGANIZATION UNLESS SPECIFICALLY REVISED BY THE ORGANIZATION. REVISED DRAWINGS SHALL BE IDENTIFIED BY THE ORGANIZATION AND THE DATE OF REVISION.				DWN		10 JUL 2014		TE Connectivity	
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:		Y. YIN		Harrisburg, PA 17105-3608	
mm				0 PLC ±0.5		G. BIALEY			
				1 PLC ±0.13		J. GUO		NAME Ocean Side Feed Applicator	
				2 PLC ±0.13				-	
				3 PLC ±0.013				PRODUCT SPEC	
				4 PLC ±0.0001				APPLICATION SPEC	
				ANGLES				SIZE CASE CODE DRAWING NO	
				FINISH				RESTRICTED TO	
MATERIAL				WEIGHT		A 00779 C=2266409		-	
-				-		Customer Accessible Product Drawing		SCALE 1:2 SHEET 2 OF 4 REV A	

8		7		6		5		4		3	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		28							
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.									
<div>PACIFIC VERSION TERMINATOR INTERFACE ADAPTER</div> <div></div>	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266409-1	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	-	8-2266409-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266409-4	-	-	-
	2-2266409-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266409-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266409-4	-	-	-
	2-2266409-5	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
2-2266409-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266409-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	5.59 mm [.220]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: HULANE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.47-5.24 mm [.176-.206 IN]		INSULATION DIAMETER RANGE Ø 1.3mm MAX [.051 IN MAX]	
APPLICATION SPECIFICATION		NONE - - -	
TERMINALS APPLIED			
TE TERMINAL 2113525-1	HULANE TERMINAL 617008BSS	TE SEAL 2113500-1	HULANE SEAL 7165-33541A

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		0.98+/-0.05 [0.039+/-0.002]		4.2



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: 8-2266409-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266409-5
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266409-5

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 ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12 INFORMATION.
THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

13 APPLY TORQ-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.

2				1		
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS		
P	LTR	DESCRIPTION		DATE	DRN	APVD
	-	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	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
6	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	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
	-	-	-	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
	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
	-	1	1	1	1	455888-7	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
6	-	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	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	-	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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
	-	-	-	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	1-2119644-4	RAM WASHER, PRECISION	38
	-	1	1	1	1	1752356-3	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	3-1633919-1	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	3-1803019-1	CRIMPER, INSULATION O	3
	-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1	1	1	7-456404-0	CRIMPER, WIRE PREMIUM	1

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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		NAME APVD H.GUO 10JUL2014 PRODUCT SPEC - APPLICATION SPEC -	
		SIZE A 00779		DRAWING NO C=2266409	
MATERIAL -		FINISH -		RESTRICTED TO -	
		WEIGHT -		SCALE 1:2	
		SHEET 3 of 4		REV A	
Customer Accessible Production Drawing					

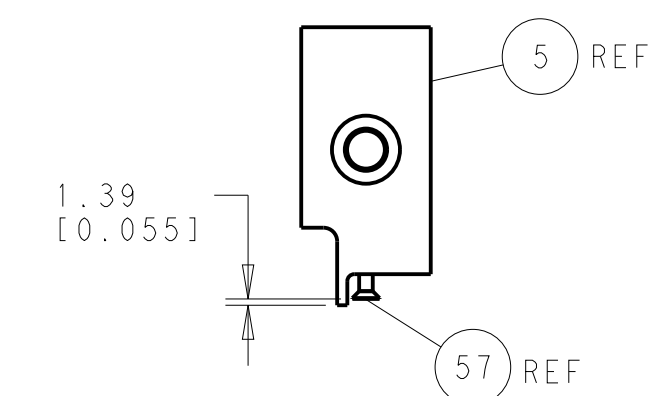
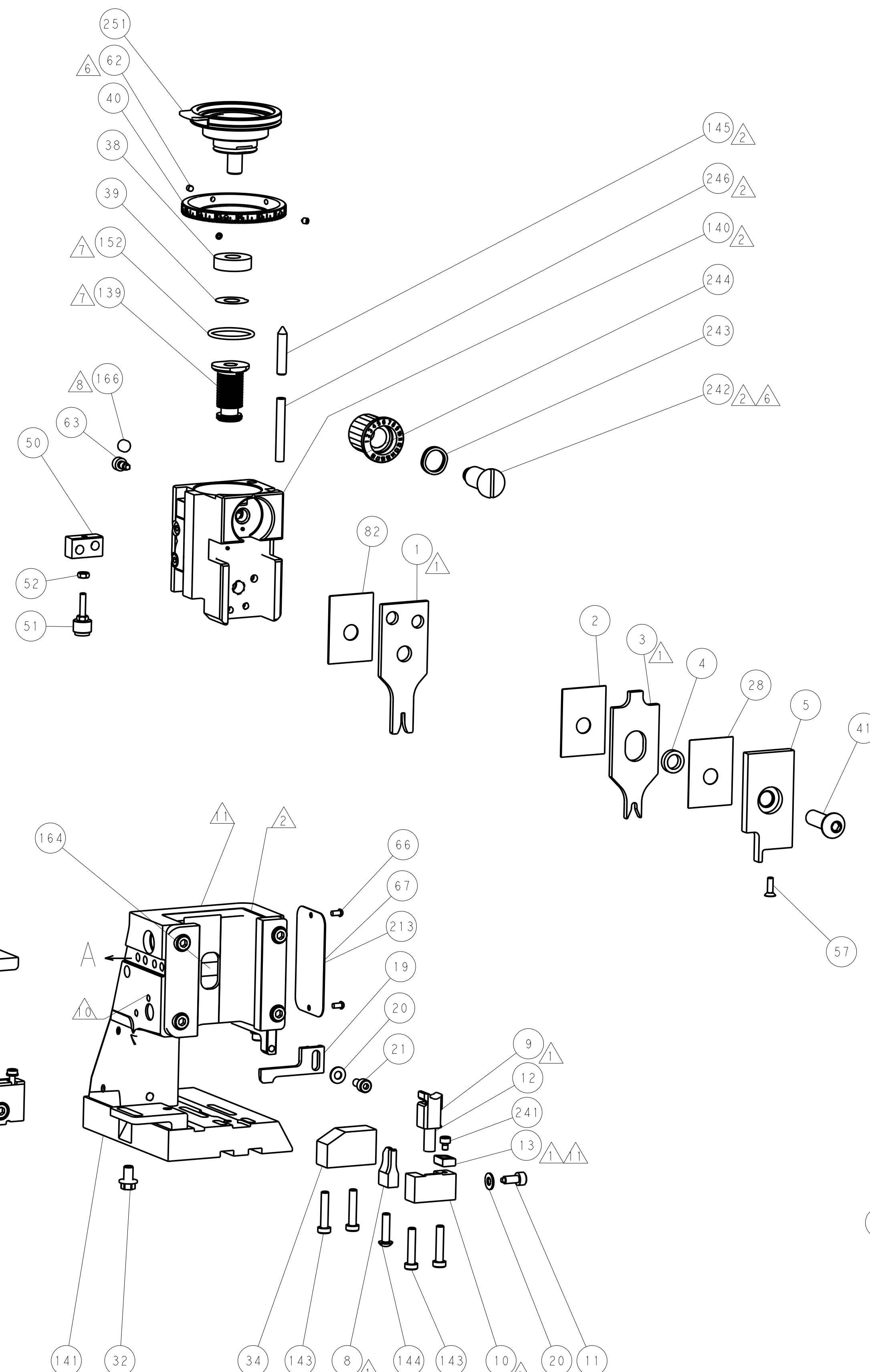
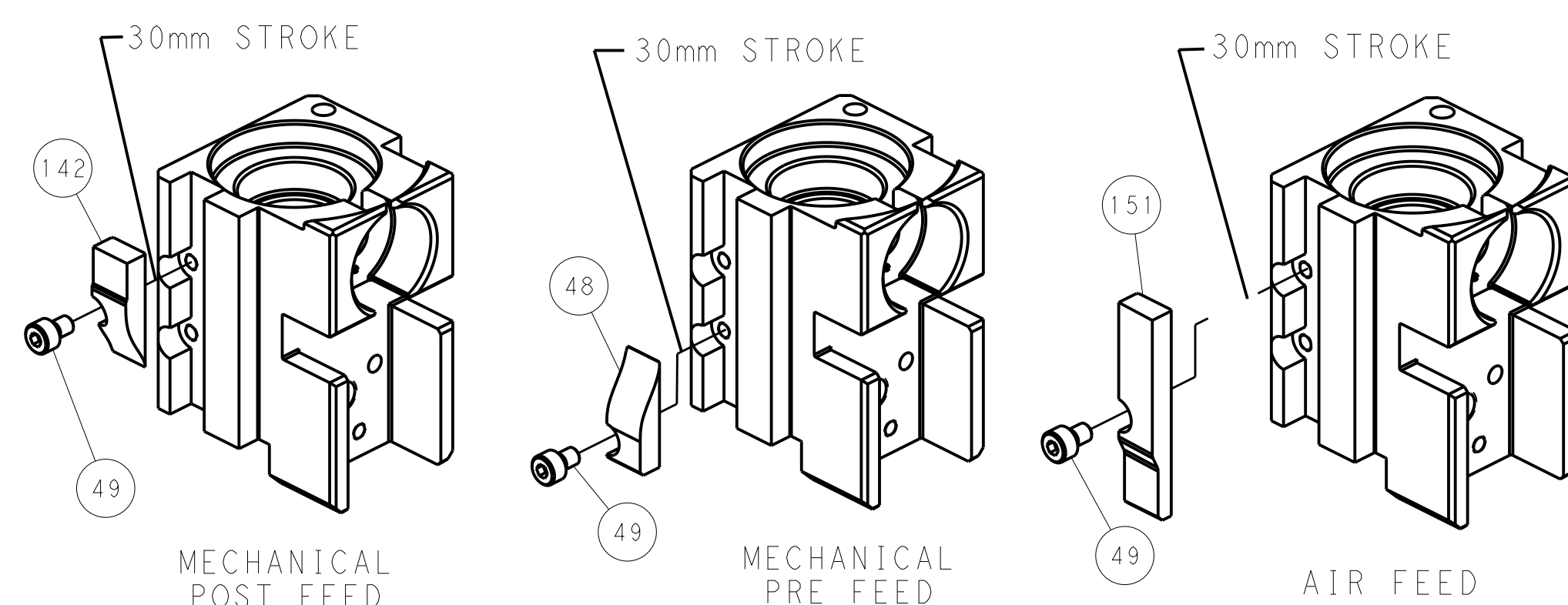
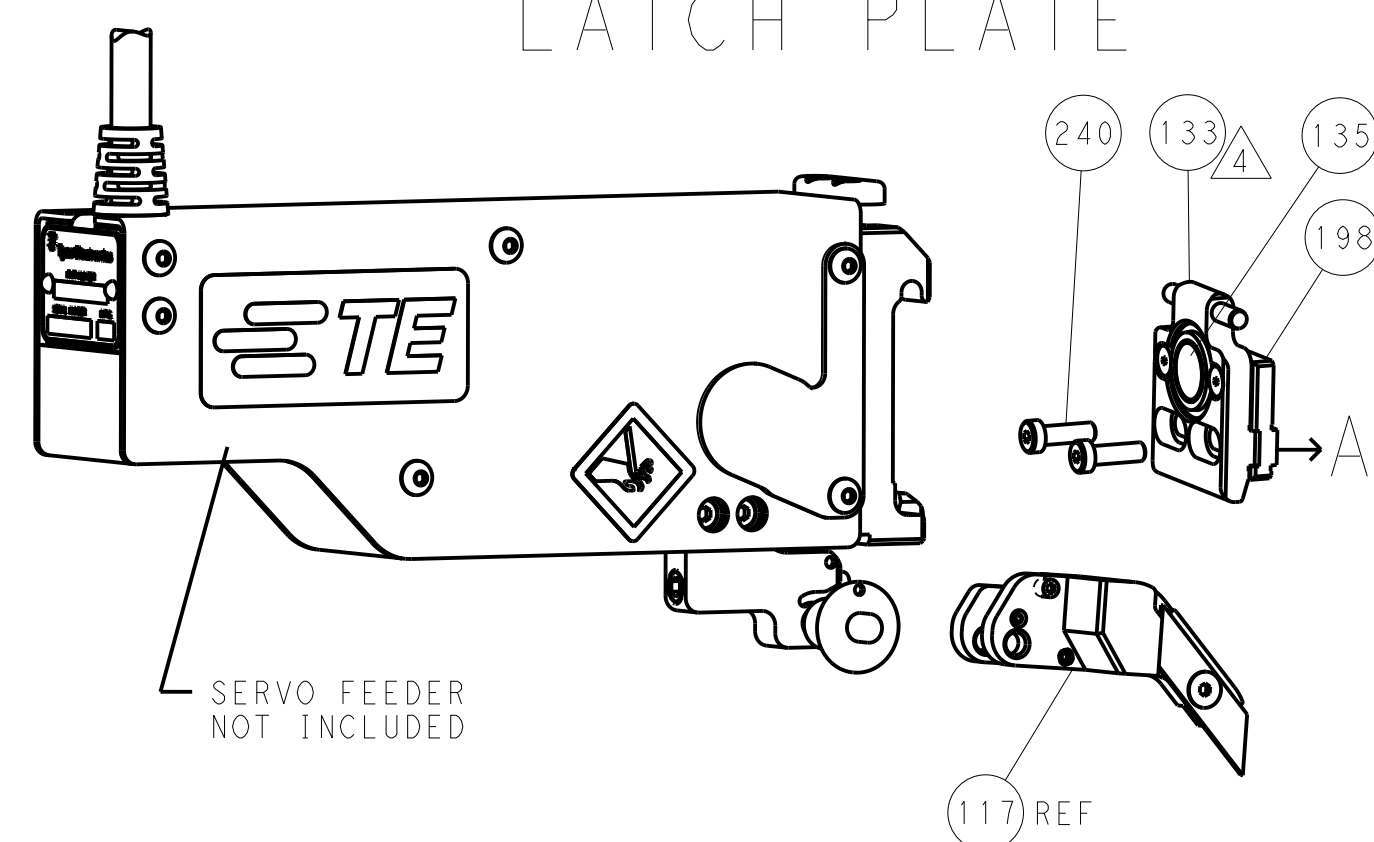
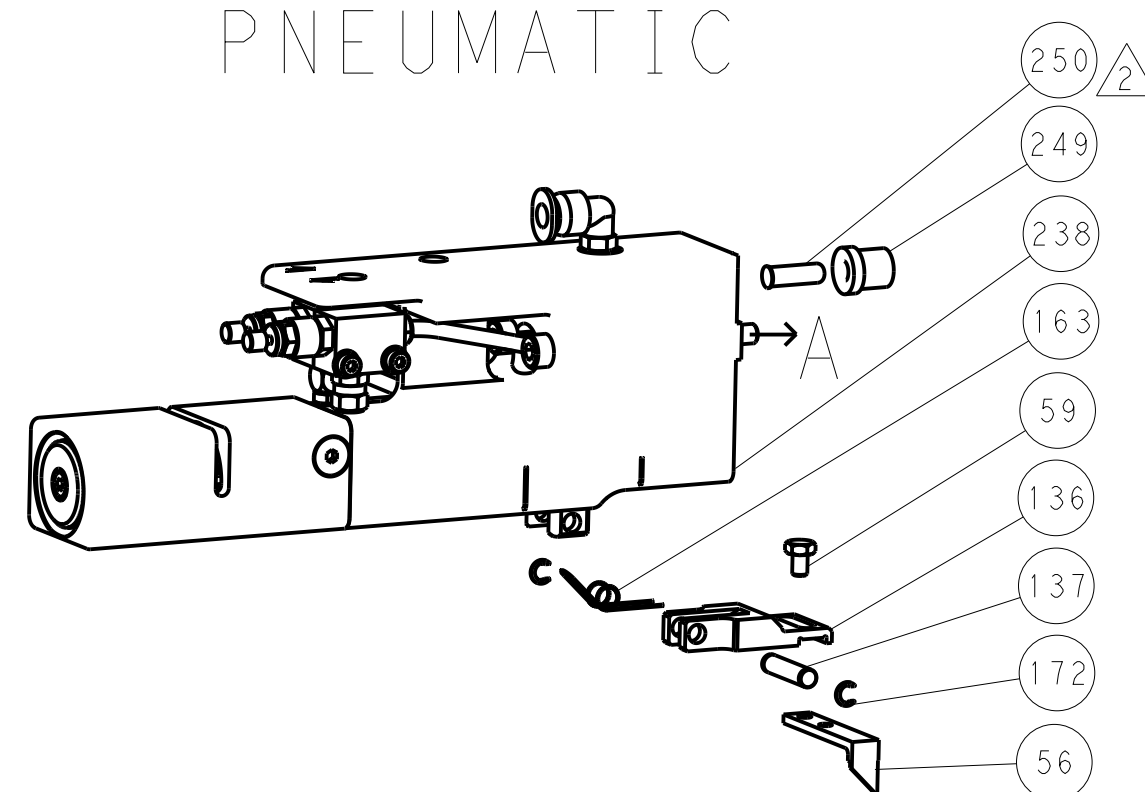
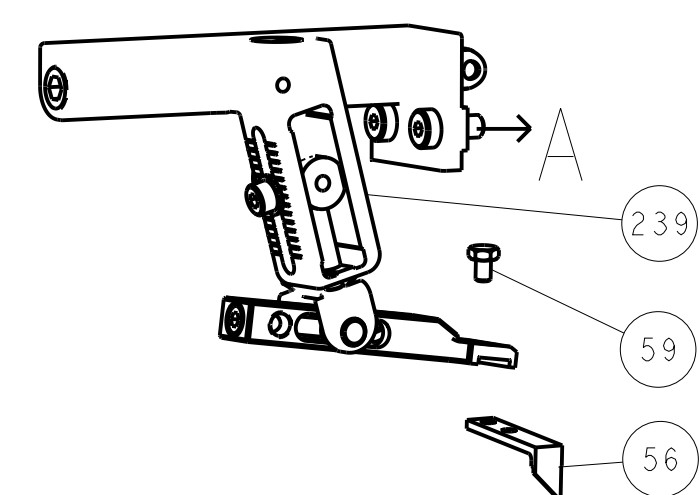
AMP 4805 REV 31MAR2000

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

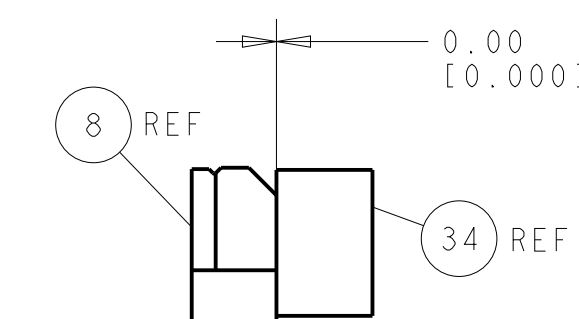
PNEUMATIC

SERVO
LATCH PLATE

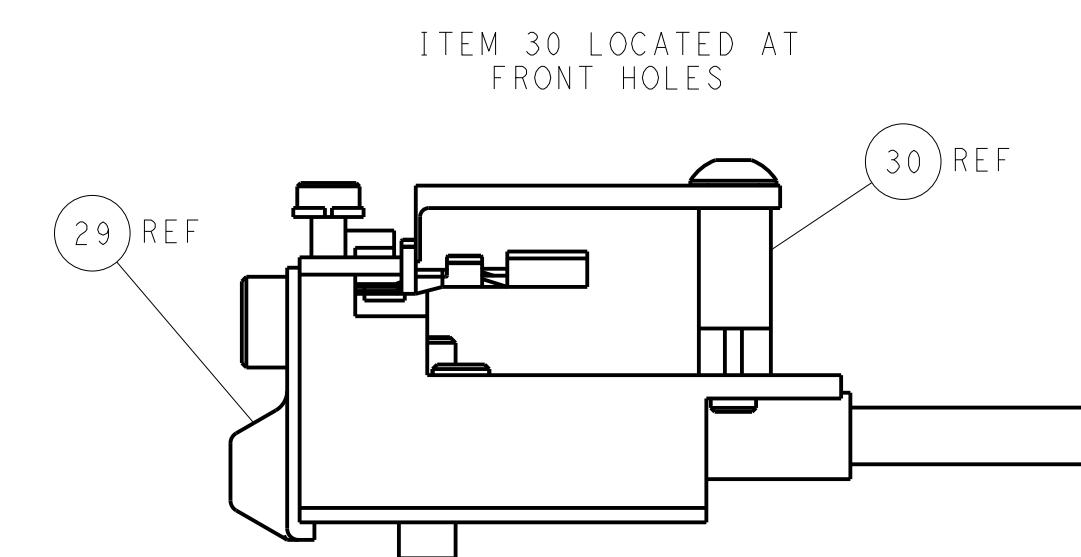
CAM POSITIONS



SHEAR DEPRESSOR DETAIL




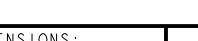
TERMINAL SUPPORT LOCATION



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)

<small>*SEE DRAWING 1 & 2 FOR DIMENSIONS FOR FOUR PRODUCTS COMBINATIONS IF IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISIONS</small>		DWN Y. YIN CHK G. BAILEY APP'D U. GUO	10JUL2014 10JUL2014 10JUL2014	 TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		NAME Ocean Side Feed Applicator -
		PRODUCT SPEC -		
MATERIAL -		APPLICATION SPEC -		
FINISH -		WEIGHT -		SIZE A 00779 C=2266409
		Customer Accessible Production Drawing		SCALE 1:2 SHEET A OF A REV A