

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      |                          |
|---|-------------|----------|--------------------------|--------------------------------|--------------------------|
|   | 2266080-1   | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | SUPERSEDE BY 5-2837239-1 |
|   | 2266080-2   | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | SUPERSEDE BY 5-2837239-2 |
|   | 2266080-5   | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | OBSOLETE                 |
|   | 2266080-6   | A        | NON CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | OBSOLETE                 |
|   | 2266080-7   | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | OBSOLETE                 |
|   | 7-2266080-7 | A        | CRIMP TOOLING KIT        | -                              |                          |

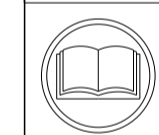
| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.98 mm [.078] | F    |
| INSUL           | 2.90 mm [.114] | OV   |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: LEAR TERMINAL         |                  | LEAR CRIMP SPECIFICATION     |  |
|--------------------------------------|------------------|------------------------------|--|
| TERMINAL NAME: RSA-2 Rundstecker 1.6 |                  |                              |  |
| WIRE STRIP LENGTH                    |                  | INSULATION DIAMETER RANGE    |  |
| 4.00-4.50 mm [.157-.177 IN]          |                  | Ø2.00-3.30 mm [.079-.130 IN] |  |
| TERMINAL APPLICATION SPECIFICATION   | LEAR 26986 Rev 5 |                              |  |

| TERMINALS APPLIED <sup>3</sup> |               |             |               |
|--------------------------------|---------------|-------------|---------------|
| TE TERMINAL                    | LEAR TERMINAL | TE TERMINAL | LEAR TERMINAL |
| 1949260-1                      | 26986.201.179 | 1949260-3   | 26986.213.178 |
| 1949260-2                      | 26986.201.409 |             |               |

| WIRE SIZE  | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|------------|----------------------------|--------------------------------|
| 2x 0.50mm2 | 1.40+/-0.05 [.055+/-0.002] | 6.9                            |
| 1.00mm2    | 1.40+/-0.05 [.055+/-0.002] | 6.9                            |
| 0.75mm2    | 1.35+/-0.05 [.053+/-0.002] | 7.3                            |
| 0.50mm2    | 1.25+/-0.05 [.049+/-0.002] | 8.3                            |
| 0.35mm2    | 1.20+/-0.03 [.047+/-0.001] | 8.9                            |



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266080-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266080-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266080-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266080-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> 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.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.40.
- <sup>13</sup> 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  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| -   | 1  | -  | 1  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252     |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO   | DESCRIPTION                     | ITEM NO |

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

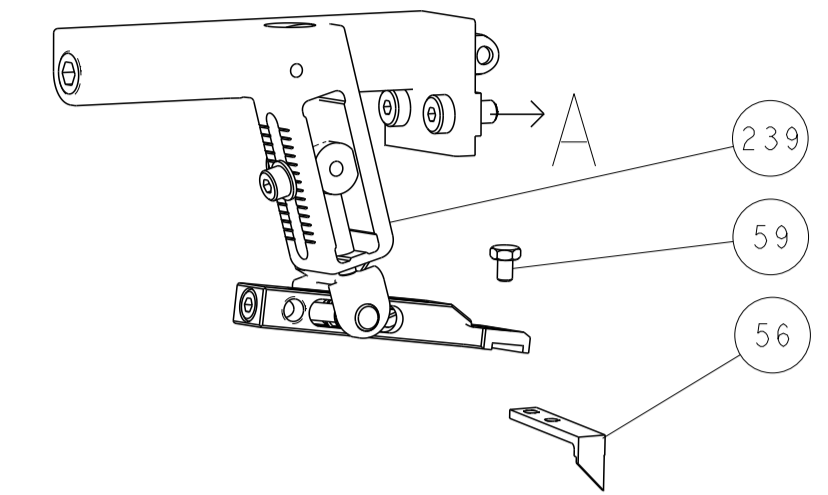
| SET UP GAUGE |  | LOC | DIST | REVISIONS |     |               |           |     |      |
|--------------|--|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-1    |  | A   | 66   | P         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|              |  |     |      | A         |     | RELEASED      | 22JAN2014 | LG  | GB   |
|              |  |     |      | A1        |     | ECR-23-167642 | 28FEB2023 | JWC | TE   |

|   |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | -   | -   | 1   | -   | 2119640-1   | PUSH ROD, AIR FEED                  | 250 |
| - | -   | -   | -   | 1   | -   | 2079988-1   | BUSHING, LCH5-12, MISUMI            | 249 |
| - | -   | -   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
| - | 1   | -   | 1   | 1   | 1   | 2119798-1   | DETENT PIN                          | 247 |
| - | 1   | -   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| - | -   | 1   | -   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| - | 1   | 1   | 1   | 1   | 1   | 2119082-8   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1   | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 1   | 1   | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241 |
| - | -   | 2   | 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   | 1   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213 |
| - | -   | 1   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      | 198 |
| - | -   | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 1   | 1   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166 |
| - | REF | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | -   | -   | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163 |
| - | -   | -   | -   | 1   | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137 |
| - | -   | -   | -   | 1   | -   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136 |
| - | -   | REF | REF | -   | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135 |
| - | -   | 1   | 1   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133 |
| - | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117 |
| - | 1   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 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   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |
| - | 3   | -   | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE PNT, M3 x 4.0   | 62  |
| - | 1   | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60  |
| - | -   | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | -   | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54  |
| - | 2   | 2   | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 53  |
| - | 1   | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
| - | 1   | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
| - | 1   | 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   | 2119653-1   | FEED CAM, POST FEED                 | 47  |
| - | 1   | 1   | 1   | 1   | 1   | 2-2119656-1 | APPLICATOR BASIC ASSEMBLY, SF       | 46  |
| - | 1   | -   | 1   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44  |
| - | 1   | 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   | 1-2119644-2 | RAM WASHER, PRECISION               | 38  |
| - | 1   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37  |
| - | 1   | -   | 1   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35  |
| - | 1   | 1   | 1   | 1   | 1   | 1752356-2   | 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   | 1-1320908-0 | SPACER, STRIP GUIDE                 | 30  |
| - | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1   | 1   | 1   | 1320928-6   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 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   | 462006-6    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 1   | 1803056-7   | ANVIL, COMBINATION                  | 8   |
| - | 1   | 1   | 1   | 1   | 1   | 5-240641-1  | SPACER                              | 7   |
| - | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 2-238011-2  | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 1   | 1-1633964-8 | CRIMPER, INSULATION OVERLAP PREMIUM | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1   | 1   | 1   | 3-1633738-3 | CRIMPER, WIRE                       | 1   |

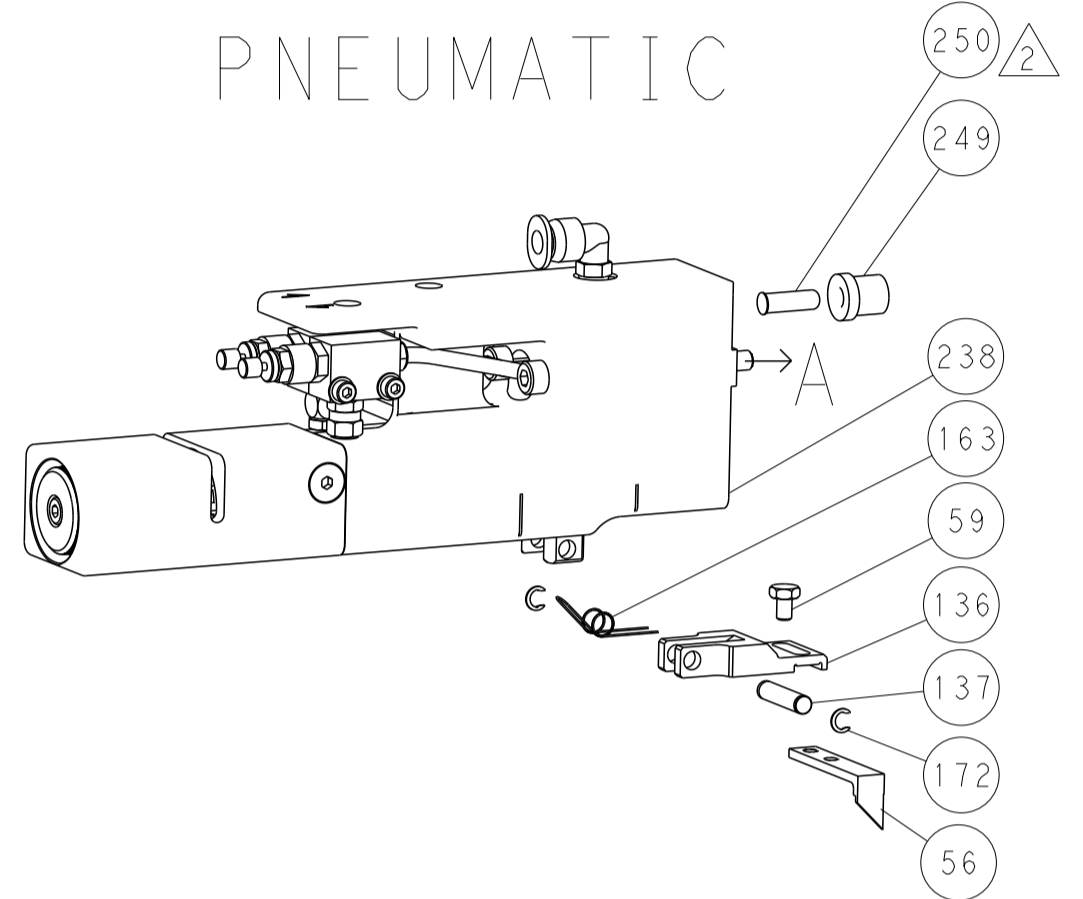
| DIMENSIONS: |           | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | MATERIAL:    |               | FINISH: |        | WEIGHT: |  | SCALE: |     | SHEET: |    | REV: |     |
|-------------|-----------|--|-------------|--------------|---------------|---------|--------|---------|--|--------|-----|--------|----|------|-----|
| mm          | 0 PLC ±.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.0001 | ANGLES  | ±.0001 |         |  |        | 1:2 | 1      | OF | 4    | REV |
| MATERIAL:   |           | FINISH:                                |             | WEIGHT:      |               | SCALE:  |        | SHEET:  |  | REV:   |     | A1     |    | A1   |     |

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

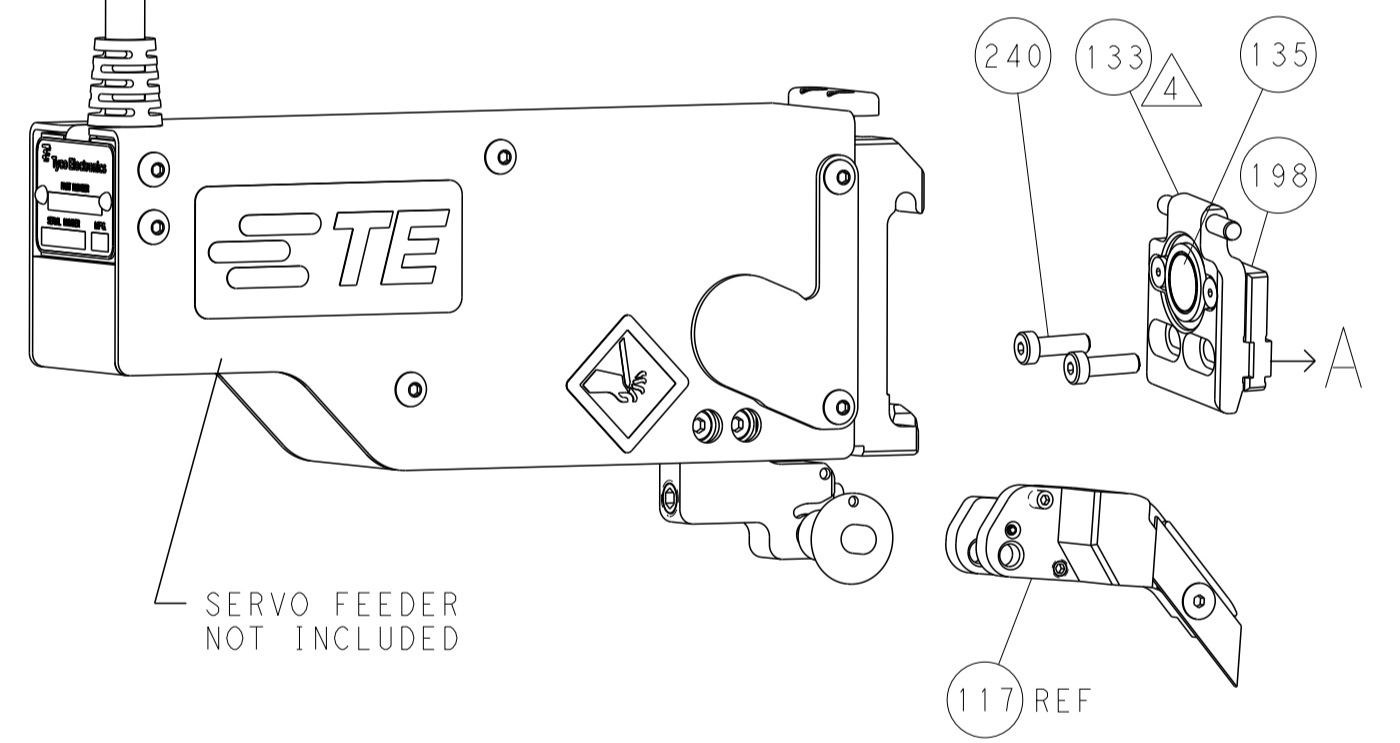
### FEED TYPE MECHANICAL



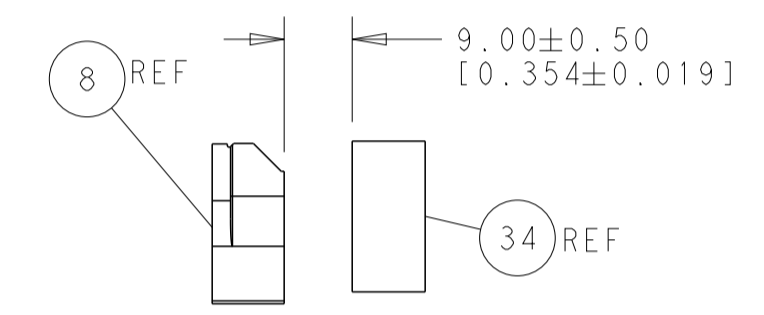
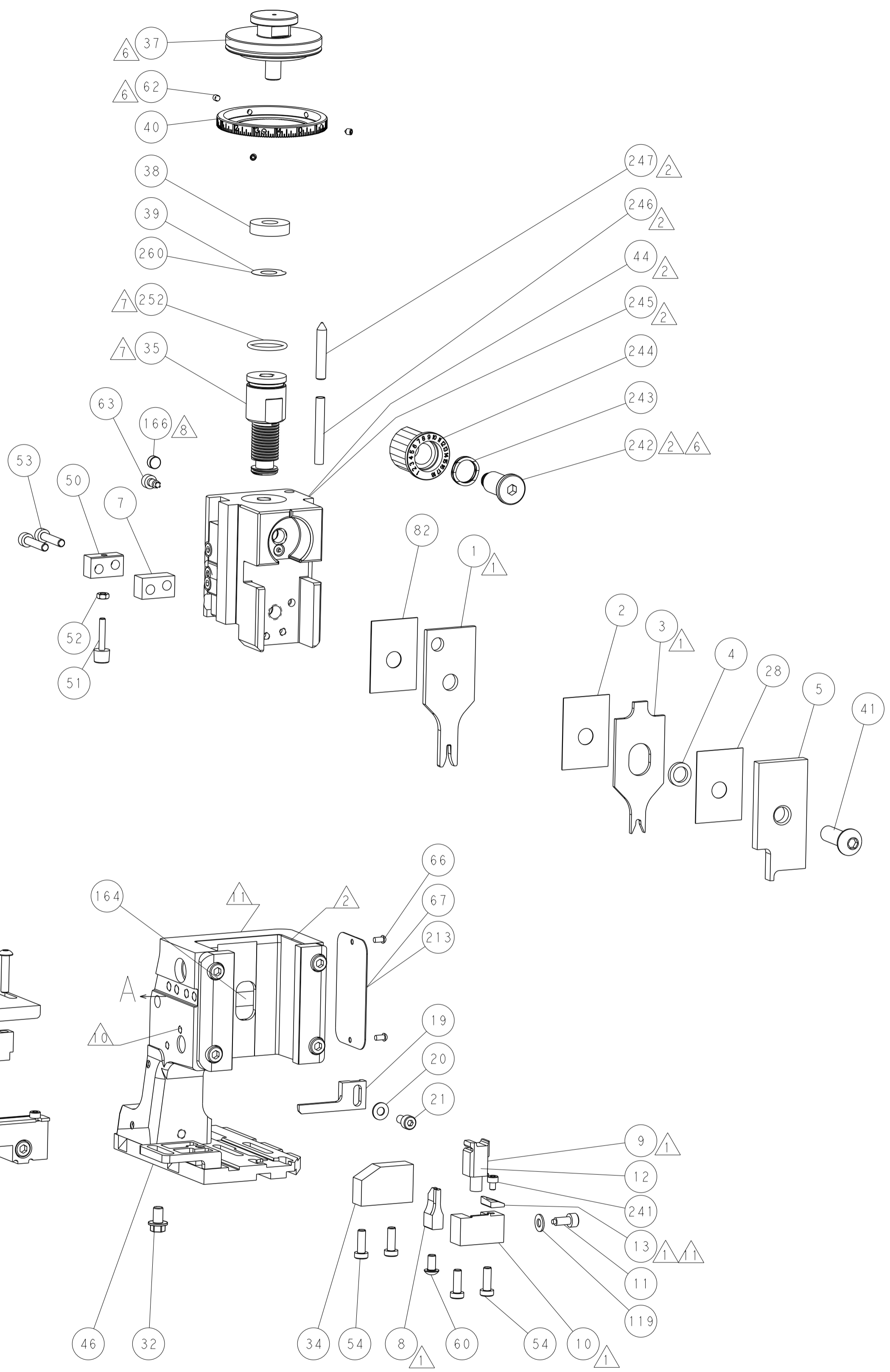
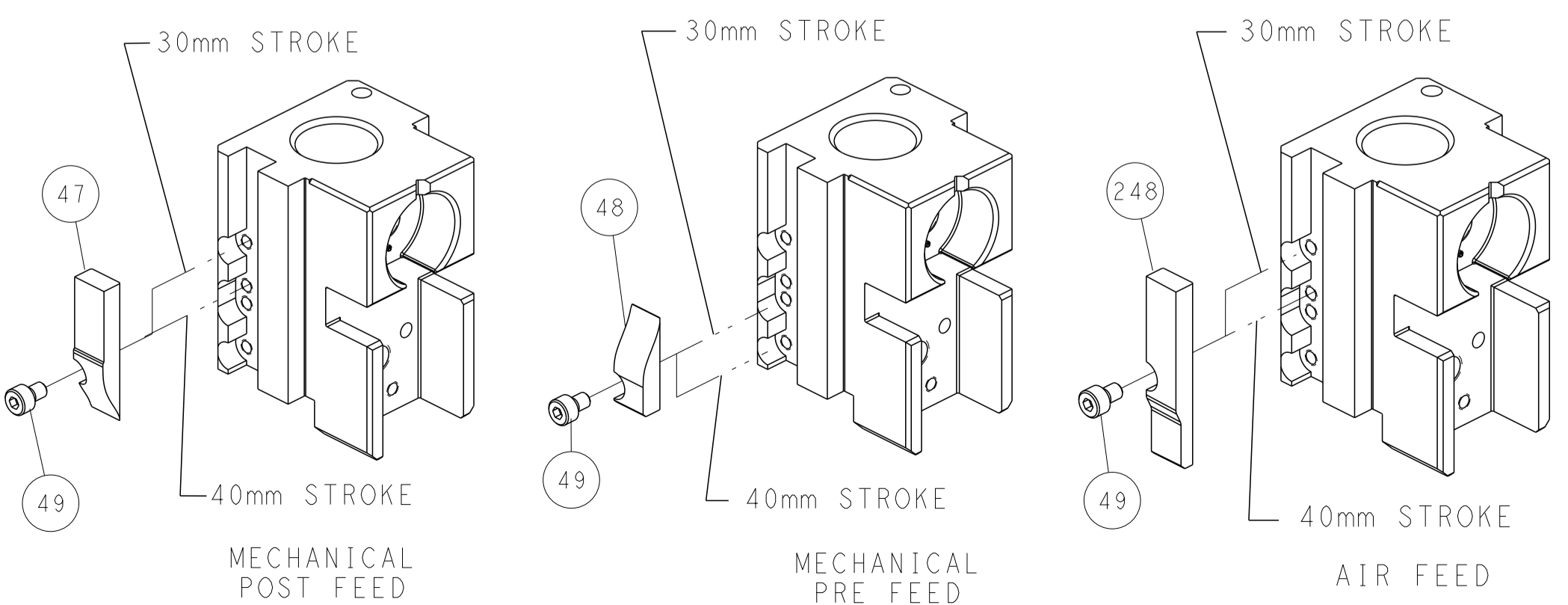
### PNEUMATIC



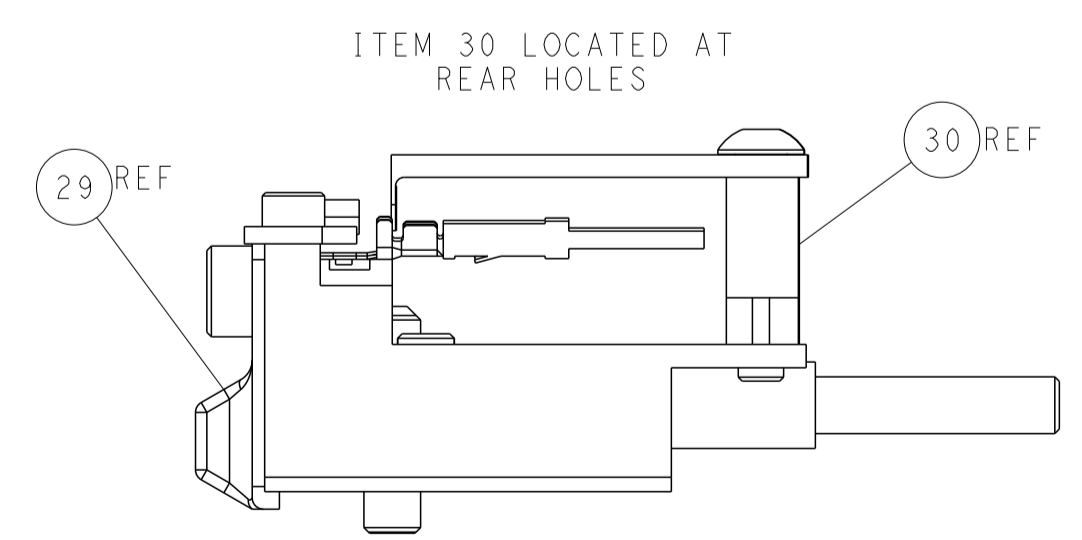
### SERVO LATCH PLATE



### CAM POSITIONS



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)

|   |  |  |   |
|---|--|--|---|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>                |  | DWN: L. GROSS 22OCT2013<br>CHK: G. BAILEY 22OCT2013<br>APVD: M. CLIFFORD 22OCT2013 | TE Connectivity<br>Harrisburg, PA 17105-3608                            |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±0.5<br>1 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.0001<br>ANGLES FINISH ± |  | NAME: Ocean Side Feed Applicator<br>PRODUCT SPEC:<br>APPLICATION SPEC:<br>WEIGHT:  | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2266080<br>RESTRICTED TO: |
| MATERIAL:   |  | SCALE: 1:2<br>SHEET: 2 of 4<br>REV: A1   | Customer Accessible Production Drawing                                  |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      |          |
|--|-------------|----------|--------------------------|--------------------------------|----------|
|  | 2-2266080-1 | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | OBSOLETE |
|  | 2-2266080-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | OBSOLETE |
|  | 2-2266080-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | OBSOLETE |
|  | 2-2266080-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | OBSOLETE |
|  | 7-2266080-7 | A        | CRIMP TOOLING KIT        | -                              |          |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.98 mm [.078] | F    |
| INSUL                                | 2.90 mm [.114] | OV   |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: LEAR TERMINAL         |               | LEAR CRIMP SPECIFICATION     |               |
|--------------------------------------|---------------|------------------------------|---------------|
| TERMINAL NAME: RSA-2 Rundstecker 1.6 |               |                              |               |
| WIRE STRIP LENGTH                    |               | INSULATION DIAMETER RANGE    |               |
| 4.00-4.50 mm [.157-.177 IN]          |               | Ø2.00-3.30 mm [.079-.130 IN] | <sup>2</sup>  |
| TERMINAL APPLICATION SPECIFICATION   |               | LEAR 26986 Rev 5             |               |
| TERMINALS APPLIED <sup>1</sup>       |               |                              |               |
| TE TERMINAL                          | LEAR TERMINAL | TE TERMINAL                  | LEAR TERMINAL |
| 1949260-1                            | 26986.201.179 | 1949260-3                    | 26986.213.178 |
| 1949260-2                            | 26986.201.409 |                              |               |

| WIRE SIZE              | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|------------------------|-------------------------------|---|
| 2x 0.50mm <sup>2</sup> | 1.40 +/- 0.05 [.055 +/- .002] | 6.9   |
| 1.00mm <sup>2</sup>    | 1.40 +/- 0.05 [.055 +/- .002] | 6.9   |
| 0.75mm <sup>2</sup>    | 1.35 +/- 0.05 [.053 +/- .002] | 7.3   |
| 0.50mm <sup>2</sup>    | 1.25 +/- 0.05 [.049 +/- .002] | 8.3   |
| 0.35mm <sup>2</sup>    | 1.20 +/- 0.03 [.047 +/- .001] | 8.9   |

- 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: 8-2266080-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266080-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266080-5
- 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 & 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.

| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE | OWN | 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   | 2119082-8   | 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 |
| - | 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   | 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 |
| - | -   | -   | 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   | 455888-5    | 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 PNT, M3 X 4.0   | 62  |
| - | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | -   | -   | 1   | 1   | 1336885-1   | PAWL, FEED                          | 56  |
| - | 2   | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 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   | 1-2119644-2 | 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   | 1320928-6   | 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   | 1803056-7   | ANVIL, COMBINATION                  | 8   |
| - | 1   | 1   | 1   | 1   | 5-240641-1  | SPACER                              | 7   |
| - | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 2-238011-2  | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 1-1633964-8 | CRIMPER, INSULATION OVERLAP PREMIUM | 3   |
| - | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1   | 1   | 3-1633738-3 | CRIMPER, WIRE                       | 1   |

**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: |             | MATERIAL:    |              | FINISH:       |        |
|-------------|------------|--|-------------|--------------|--------------|---------------|--------|
| mm          | 0 PLC ±.05 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 | ANGLES ±.0001 | FINISH |

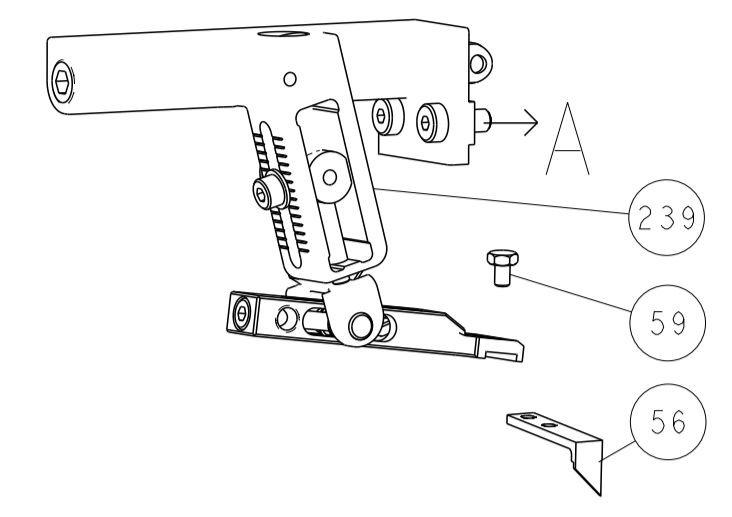
| ITEM NO | DESCRIPTION | ITEM NO |
|---------|-------------|---------|
| -77     | -           | -       |
| -27     | -           | -       |
| -25     | -           | -       |
| -22     | -           | -       |
| -21     | -           | -       |
|         | PART NO     |         |
|         | DESCRIPTION |         |

| DATE      | BY          | CHK | APPV | NAME                       | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|-----------|-------------|-----|------|----------------------------|------|-----------|------------|---------------|
| 22OCT2013 | JL GROSS    |     |      | TE Connectivity            | A1   | 00779     | 2266080    |               |
| 22OCT2013 | G. BAILEY   |     |      | Harrisburg, PA 17105-3608  |      |           |            |               |
| 22OCT2013 | M. CLIFFORD |     |      | Ocean Side Feed Applicator |      |           |            |               |

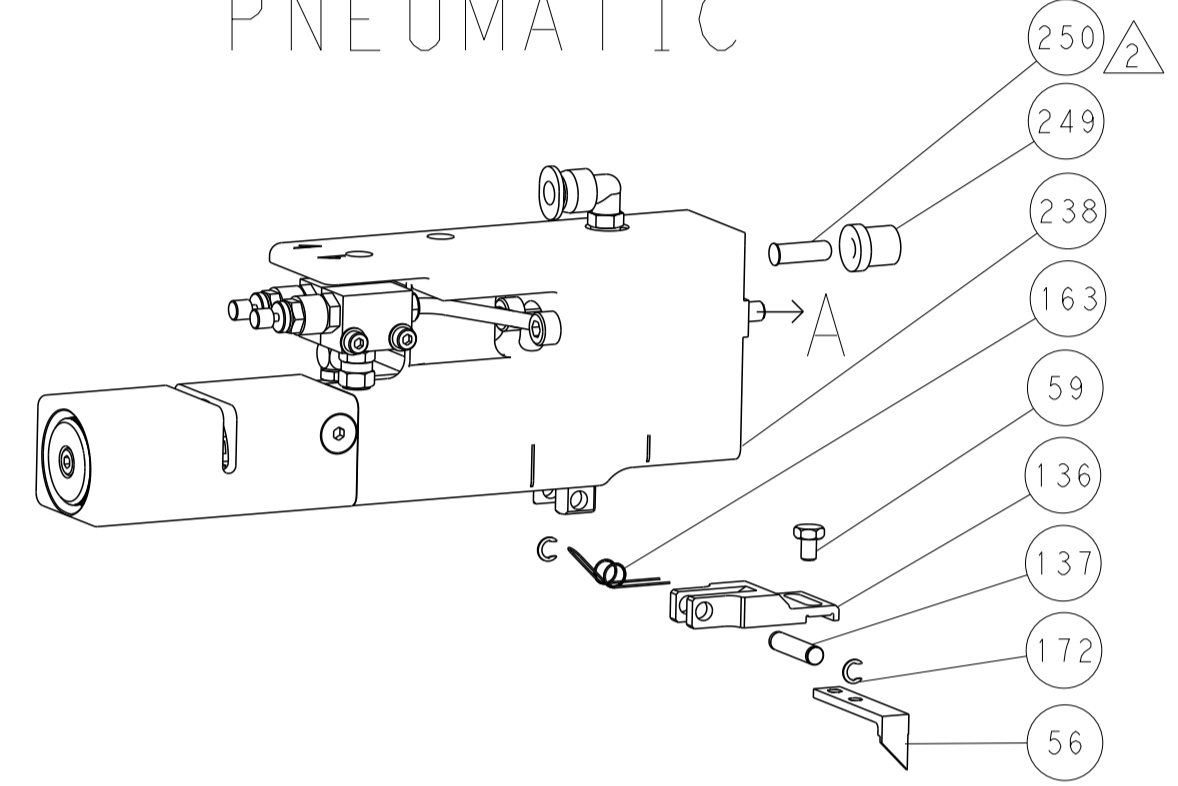
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV A1

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

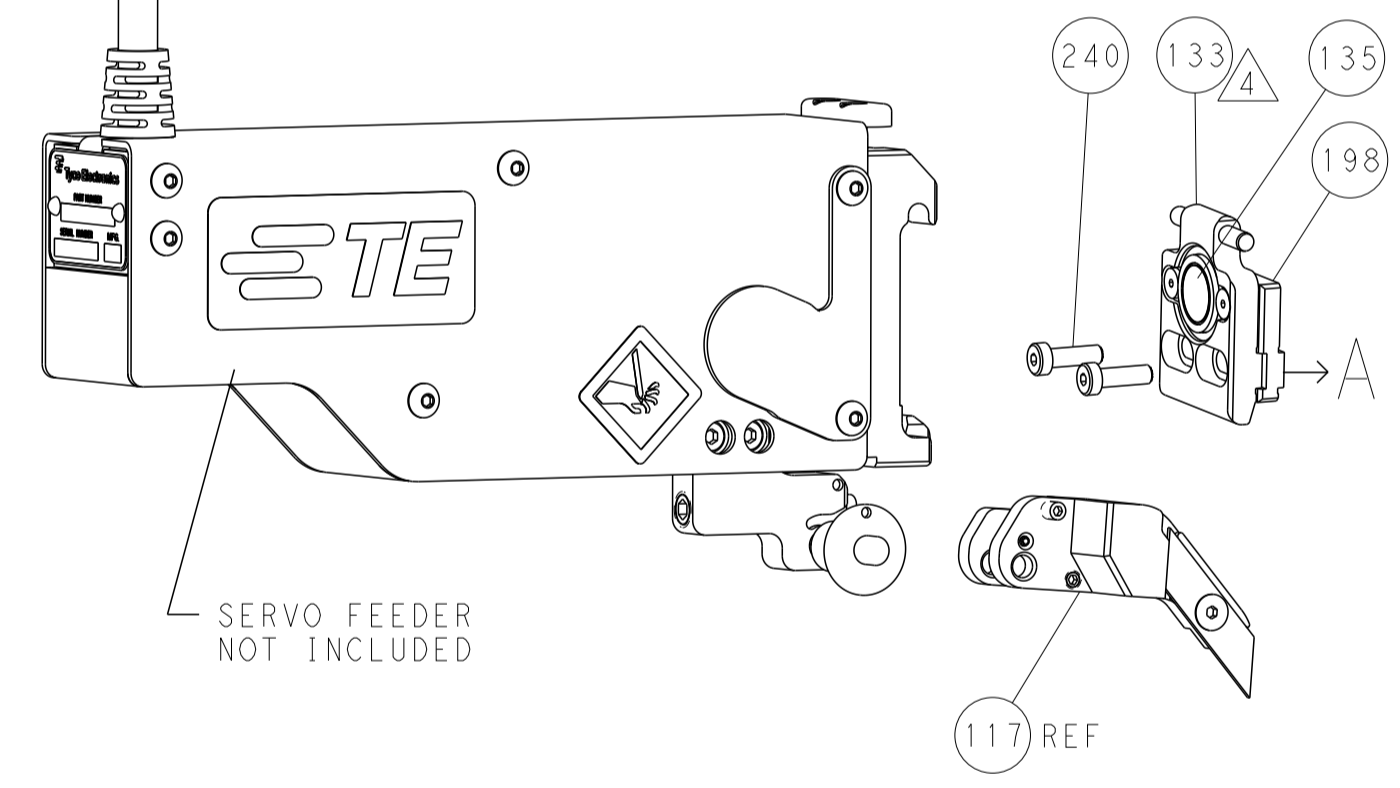
# FEED TYPE MECHANICAL



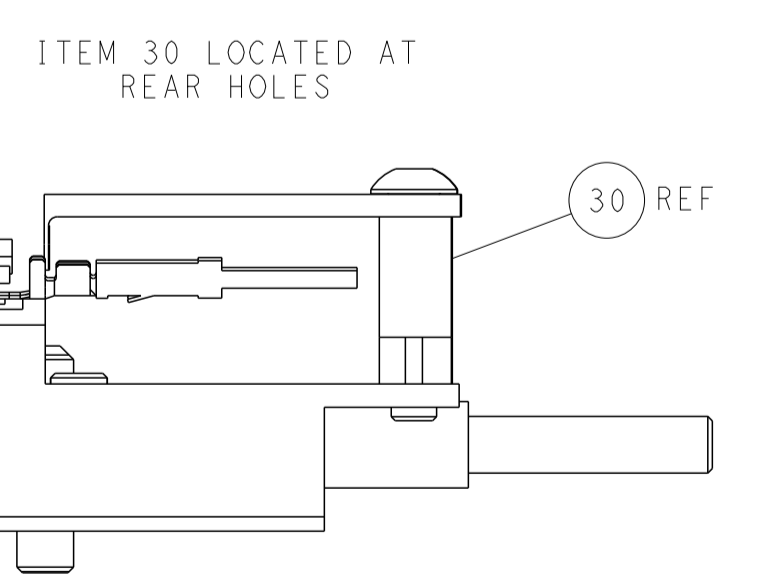
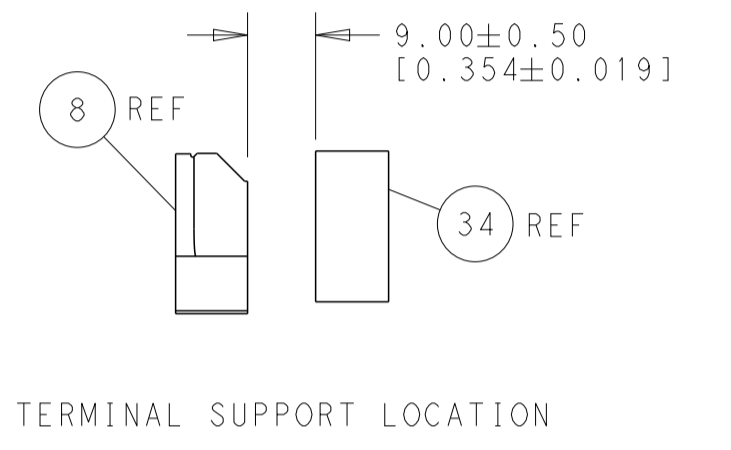
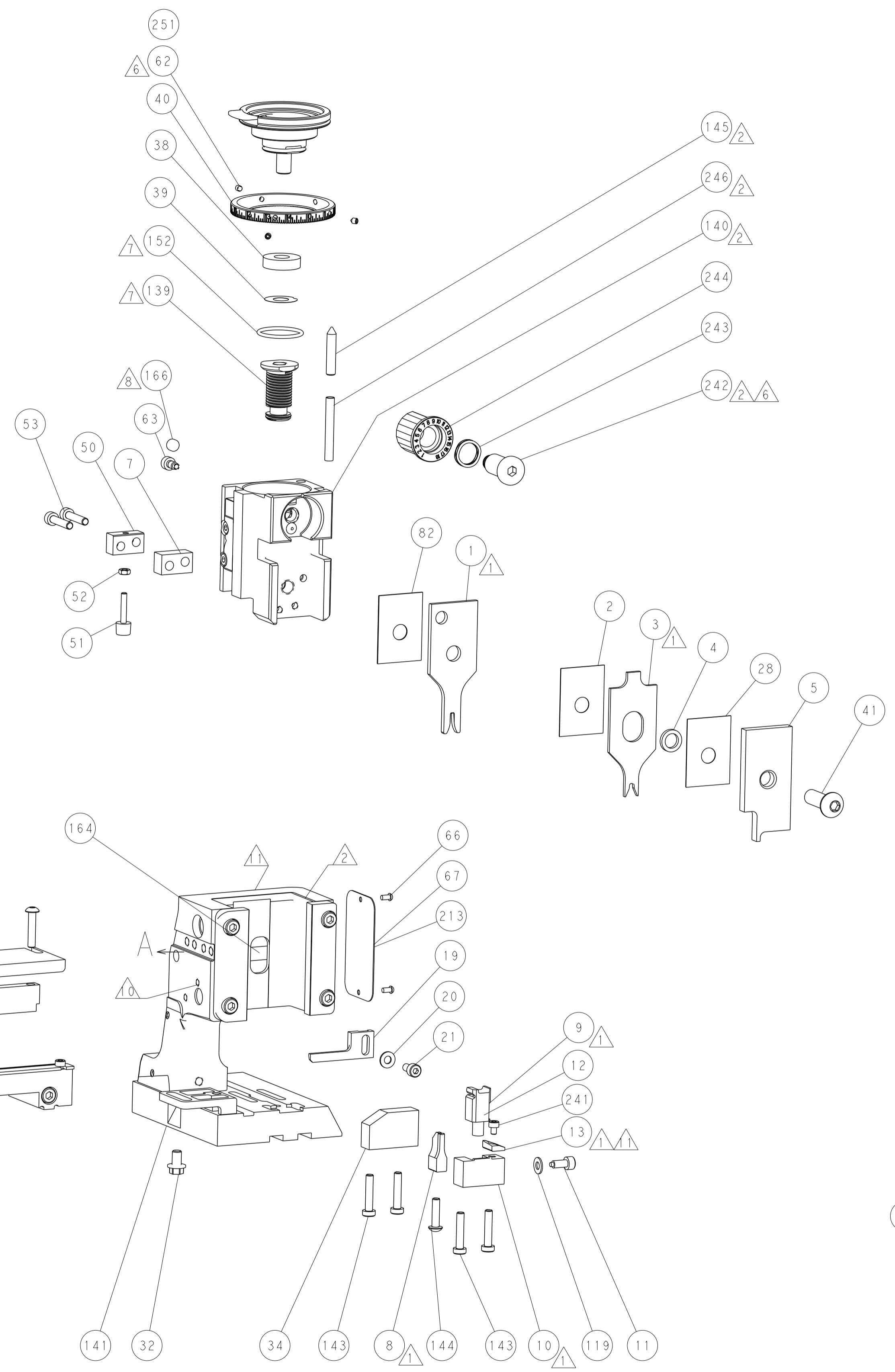
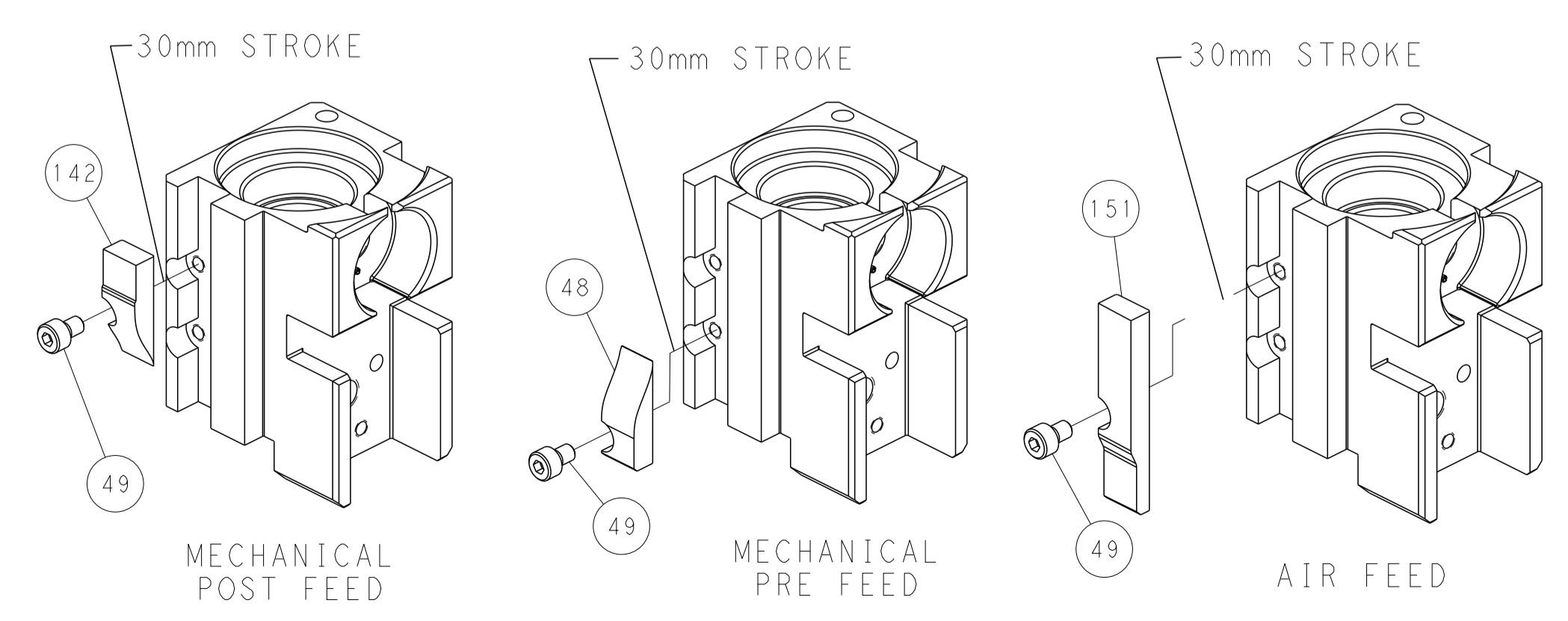
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



**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. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED IN THE ORDER. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON THE COMPLETION OF THE PROJECT.</small> |   | DWN: L. GROSS 22OCT2013<br>CHK: G. BAILEY 22OCT2013<br>APVD: M. CLIFFORD 22OCT2013 | NAME: TE Connectivity<br>Harrisburg, PA 17105-3608         |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.5<br>1 PLC ±0.5<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±0.001<br>ANGLES FINISH ±.  | PRODUCT SPEC: -<br>APPLICATION SPEC: -<br>WEIGHT: - | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2266080                              | RESTRICTED TO: -<br>SCALE: 1:2<br>SHEET: 4 of 4<br>REV: A1 |