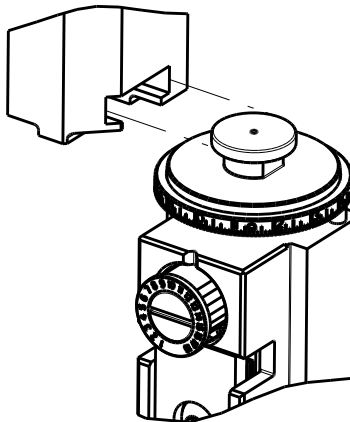


|                                                                                  |             |                                                       |                          |
|----------------------------------------------------------------------------------|-------------|-------------------------------------------------------|--------------------------|
| 8                                                                                |             | 7                                                     |                          |
| THIS DRAWING IS UNPUBLISHED.                                                     |             | RELEASED FOR PUBLICATION                              |                          |
| © COPYRIGHT 20                                                                   |             | BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. |                          |
| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              |             | PART<br>NUMBER                                        | REVISION                 |
|                                                                                  |             |                                                       | DESCRIPTION              |
|  | 2266075-1   | A                                                     | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2266075-2   | A                                                     | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2266075-5   | A                                                     | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2266075-6   | A                                                     | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2266075-7   | A                                                     | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2266075-7 | A                                                     | CRIMP TOOLING KIT        |

|                                   |                 |      |
|-----------------------------------|-----------------|------|
| APPLICATOR DATA                   |                 |      |
| CRIMP                             | SIZE            | TYPE |
| WIRE                              | 2.29 mm [ .090] | F    |
| INSUL                             | 2.54 mm [ .100] | O    |
| APPLICATOR INSTRUCTIONS 408-10389 |                 |      |

|                                                   |             |                                                                                   |                                                            |
|---------------------------------------------------|-------------|-----------------------------------------------------------------------------------|------------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                        |             | TE CRIMP SPECIFICATION                                                            |                                                            |
| TERMINAL NAME: CLIP 6.35 NGI RECEPTACLE           |             |                                                                                   |                                                            |
| WIRE STRIP LENGTH<br>4.50-5.50 mm [ .177-.217 IN] |             |  | INSULATION DIAMETER RANGE<br>Ø1.30-1.80 mm [ .051-.071 IN] |
| TERMINAL APPLICATION SPECIFICATION                | 114-15095   | -                                                                                 | -                                                          |
|                                                   | -           | -                                                                                 | -                                                          |
| TERMINALS APPLIED                                 |             |                                                                                   |                                                            |
| TE TERMINAL                                       | TE TERMINAL | TE TERMINAL                                                                       | TE TERMINAL                                                |
| 1544615-1                                         |             |                                                                                   |                                                            |

|                 |                             |                                |
|-----------------|-----------------------------|--------------------------------|
| WIRE SIZE       | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
| 0.75mm2         | 1.40+/-0.05 [ .055+/- .002] | 4.8                            |
| 0.35mm2+0.35mm2 | 1.37+/-0.05 [ .054+/- .002] | 5.3                            |
| 0.60mm2         | 1.33+/-0.05 [ .052+/- .002] | 5.6                            |
| 0.50mm2         | 1.30+/-0.05 [ .051+/- .002] | 6.1                            |
| 0.35mm2         | 1.24+/-0.05 [ .049+/- .002] | 6.9                            |

- 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: 8-2266075-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266075-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266075-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266075-6
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 4.40.

|     |    |    |    |    |    |           |                                     |         |
|-----|----|----|----|----|----|-----------|-------------------------------------|---------|
| -   | -  | 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     |
| -   | -  | -  | -  | 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  | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -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 2119599-1 | LOC A | DIST 66 | REVISIONS |     |             |           |     |
|                        |       |         | P         | LTR | DESCRIPTION | DATE      | OWN |
|                        |       |         |           | A   | RELEASED    | 13NOV2013 | RK  |
|                        |       |         |           |     |             |           | TE  |

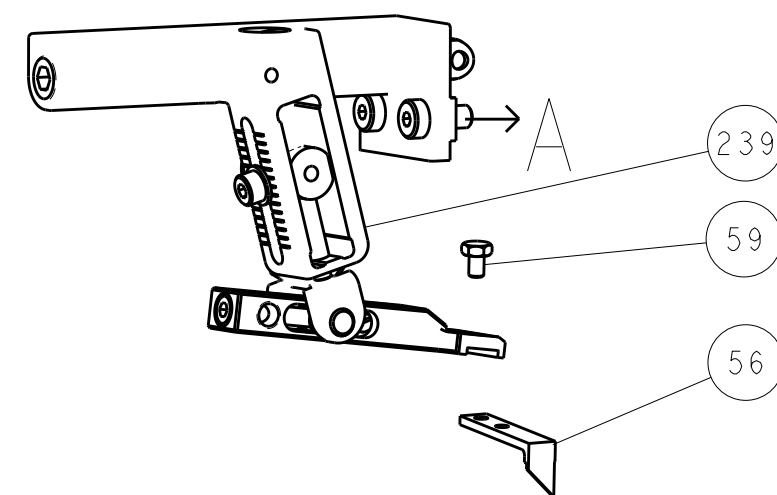
|     |     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -   | 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   | 1-22281-8   | SPRING, COMPRESSION                 | 121     |
| -   | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
| -   | 1   | 1   | 1   | 1   | 1   | 693855-8    | FRONT STRIP GUIDE                   | 96      |
| -   | 2   | 2   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95      |
| -   | 1   | 1   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 93      |
| -   | 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 POINT, M3 x 4.0 | 62      |
| -   | 2   | 2   | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61      |
| -   | 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   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 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   | 2119656-9   | 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   | 2119644-1   | 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   | 2-1752356-0 | SUPPORT, TERMINAL                   | 34      |
| -   | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| -   | 1   | 1   | 1   | 1   | 1   | 1-1320908-0 | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 1   | 1901086-1   | PLATE, STRIP GUIDE                  | 29      |
| -   | 1   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| -   | 2   | 2   | 2   | 2   | 2   | 22283-1     | SPRING, COMPRESSION                 | 27      |
| -   | 1   | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26      |
| -   | 1   | 1   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25      |
| -   | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 1   | 1   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23      |
| -   | 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   | 1   | 1803055-4   | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 1   | 238011-2    | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 1   | 1   | 1   | 1633965-3   | CRIMPER, INSULATION O PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-9    | SPACER, CRIMPER                     | 2       |
| 1   | 1   | 1   | 1   | 1   | 1   | 2-456406-0  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                                                                    |                                                                                                                          |                          |                                           |                                           |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------|--------------------------|-------------------------------------------|-------------------------------------------|
| THIS IS SUBJECT TO CHANGE AND WITHOUT WARRANTY. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE DIMENSIONS OF THE PARTS AND THE DIMENSIONS OF THE PARTS SHALL BE CONTACTED FOR THE LATEST TESTING. |                                                                                                                          | OWN R. KNEPPER 02-Oct-13 | TE Connectivity Harrisburg, PA 17105-3608 |                                           |
| DIMENSIONS: mm                                                                                                                                                                                     |                                                                                                                          | CHK T. ELBIN 02-Oct-13   | NAME M. CLIFFORD 02-Oct-13                | Ocean Side Feed Applicator                |
|                                                                                                                                                                                                    |                                                                                                                          | APVD                     |                                           |                                           |
|                                                                                                                                                                                                    | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.0001 FINISH | PRODUCT SPEC             | APPLICATION SPEC                          | SIZE CASE CODE DRAWING NO 00779 ©=2266075 |
|                                                                                                                                                                                                    |                                                                                                                          |                          |                                           |                                           |
| MATERIAL                                                                                                                                                                                           |                                                                                                                          | WEIGHT                   |                                           | RESTRICTED TO                             |
|                                                                                                                                                                                                    |                                                                                                                          |                          |                                           |                                           |
| Customer Accessible Production Drawing                                                                                                                                                             |                                                                                                                          | SCALE 1:2                | SHEET 1 OF 4                              | REV A                                     |

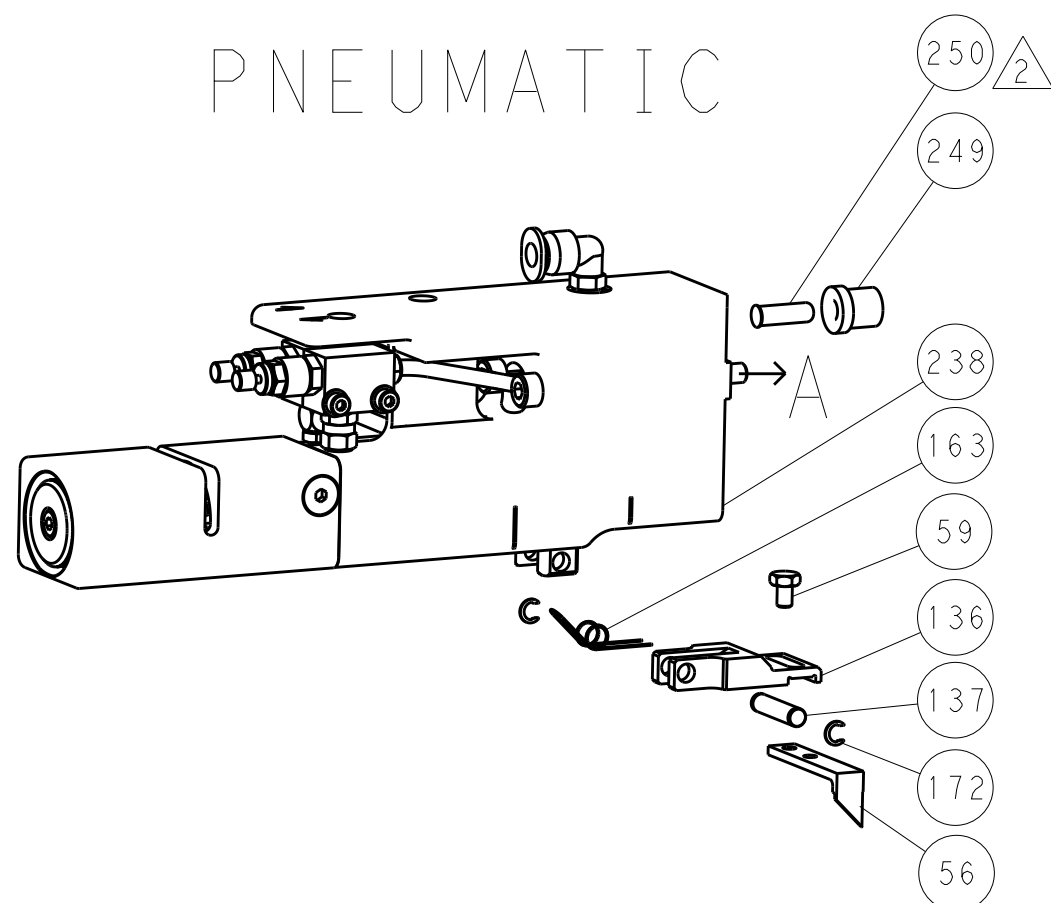


| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
|     |      | P         | LTR | DESCRIPTION | DATE | DWN | APVD |
| A   | 66   | -         | -   | SEE SHEET 1 | -    | -   | -    |
|     |      |           |     |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

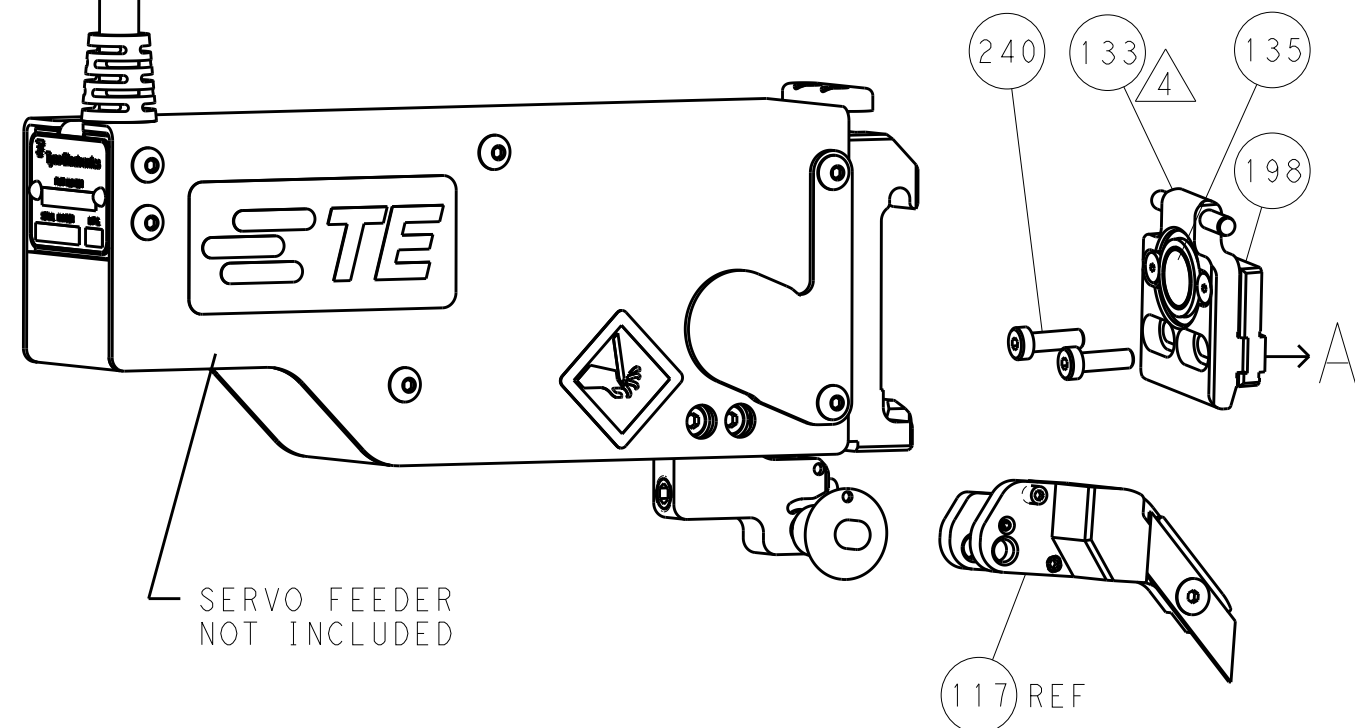
# FEED TYPE MECHANICAL



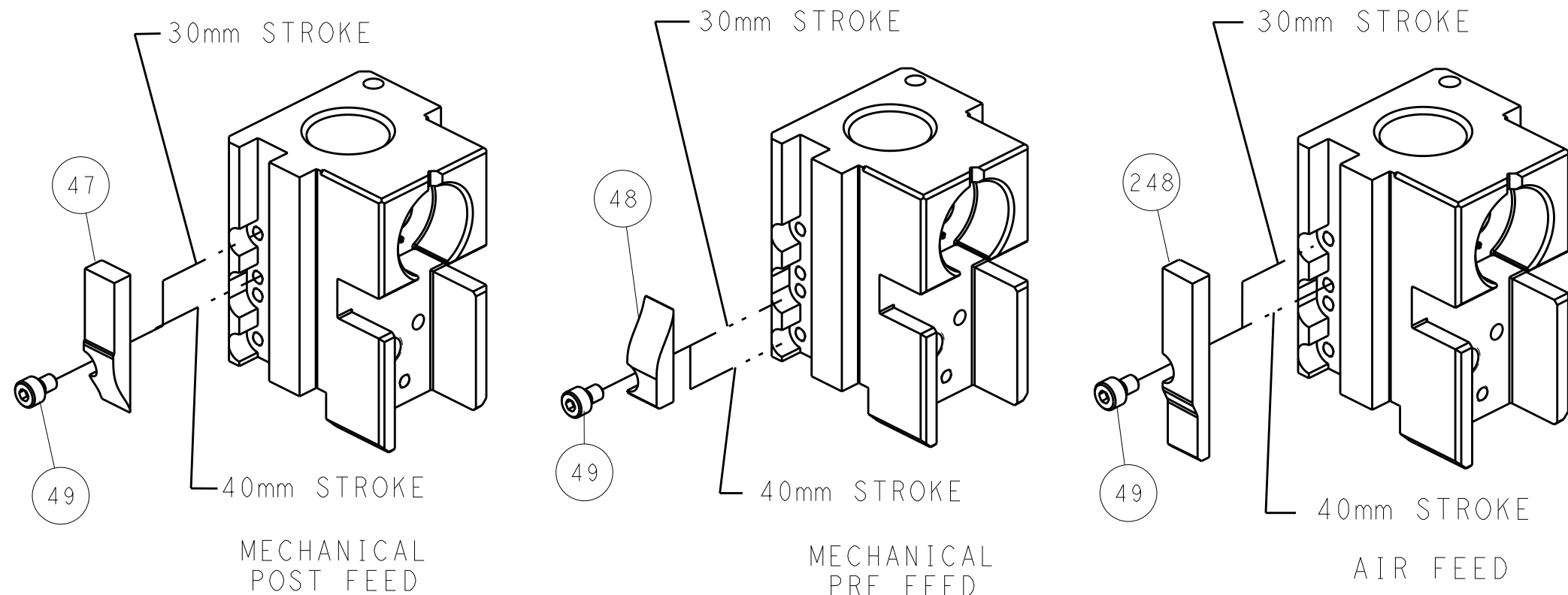
# PNEUMATIC



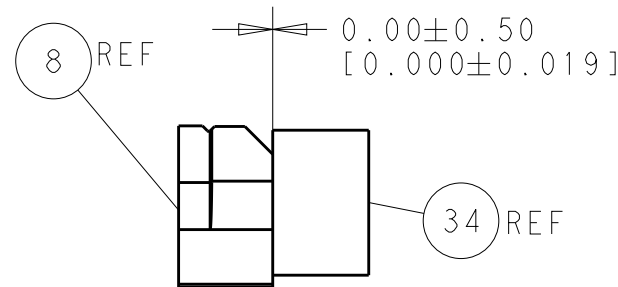
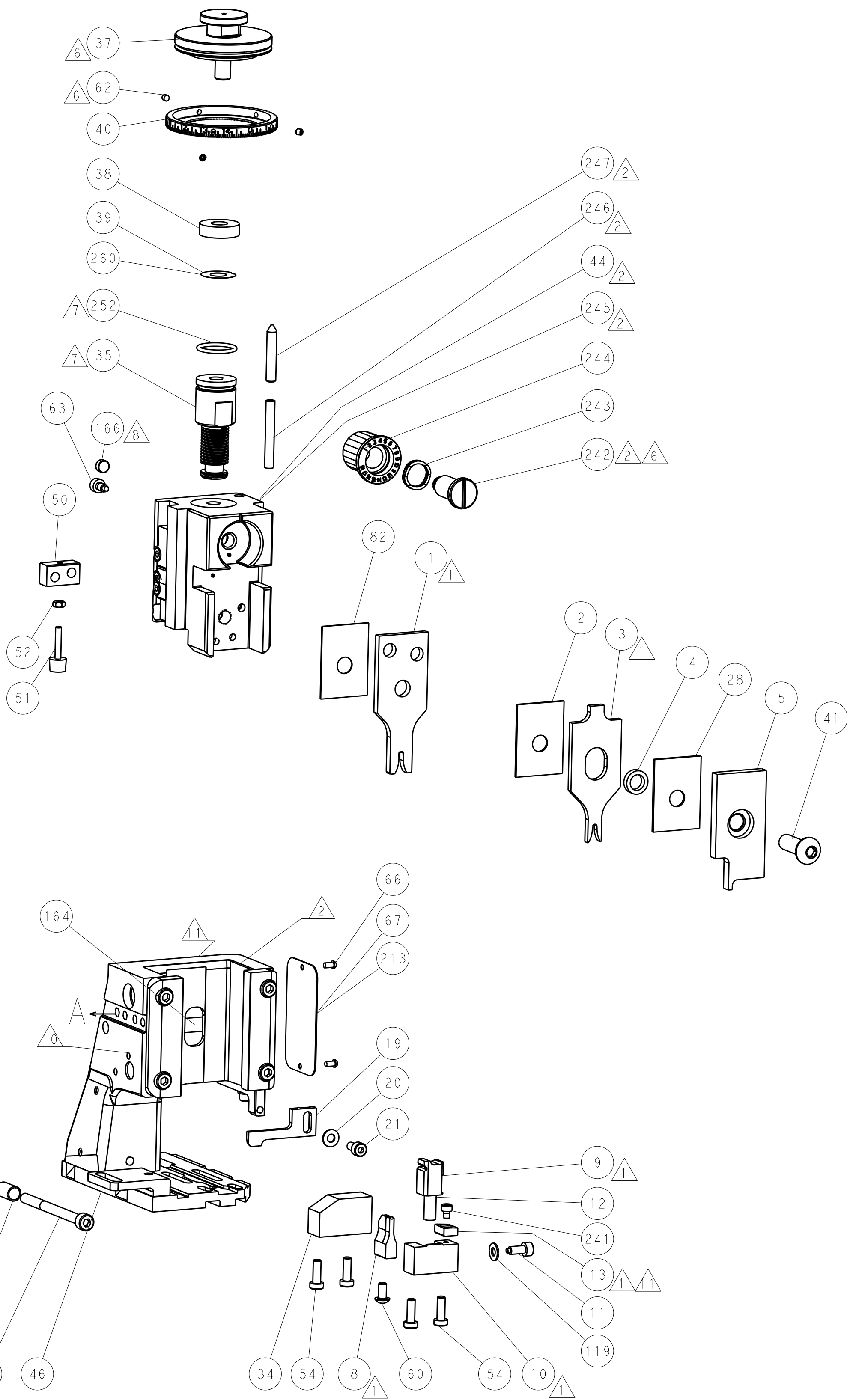
# SERVO LATCH PLATE



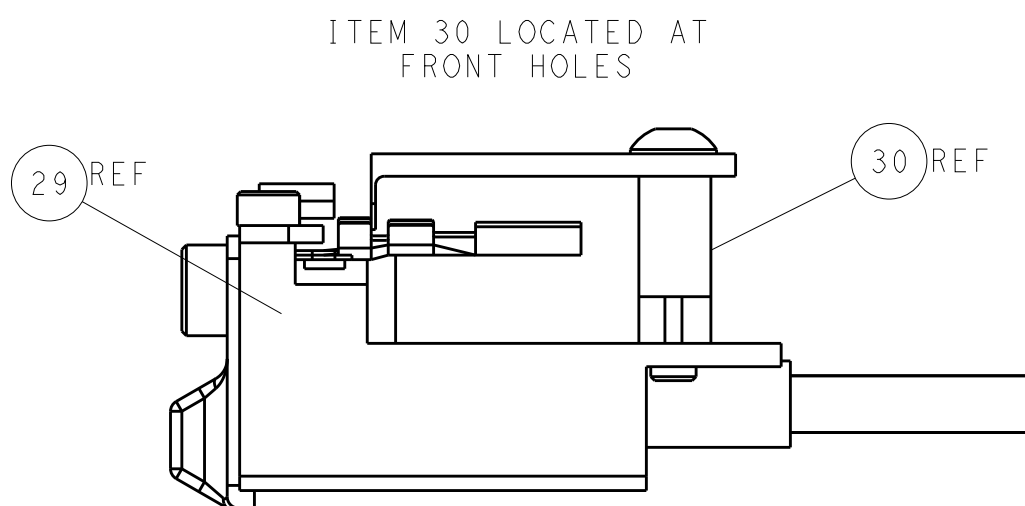
# CAM POSITIONS



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



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION  
GUIDE BY GUIDE\_BY\_STR

|                                                                                                                                              |  |  |  |                                                                                                                                    |  |  |  |                                                  |  |  |  |
|----------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--------------------------------------------------|--|--|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION. |  |  |  | DWN: R. KNEPPER 02-Oct-13<br>CHK: T. ELBIN 02-Oct-13<br>APVD: W. CLIFFORD 02-Oct-13                                                |  |  |  | TE Connectivity<br>Harrisburg, PA 17105-3608     |  |  |  |
| DIMENSIONS:<br>mm                                                                                                                            |  |  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.5<br>1 PLC ±0.13<br>2 PLC ±0.13<br>3 PLC ±0.13<br>4 PLC ±0.0001<br>ANGLES FINISH |  |  |  | NAME: Ocean Side Feed Applicator                 |  |  |  |
| MATERIAL: -                                                                                                                                  |  |  |  | WEIGHT: -                                                                                                                          |  |  |  | SIZE: A11 CAGE CODE: 00779 DRAWING NO: C=2266075 |  |  |  |
| Customer Accessible Production Drawing                                                                                                       |  |  |  | SCALE: 1:2                                                                                                                         |  |  |  | SHEET 2 OF 4 REV A                               |  |  |  |



|  | PART<br>NUMBER | REVISION          | DESCRIPTION              | FEED TYPE                         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|----------------------------------------------------------------------------------|----------------|-------------------|--------------------------|-----------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|                                                                                  |                |                   |                          |                                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|                                                                                  |                |                   |                          |                                   |                                   |                       |           |             |           |           |                        |
|                                                                                  | 2-2266075-1    | 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             | -         | 8-2266075-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|                                                                                  |                |                   |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266075-4 | -         | -         | -                      |
|                                                                                  | 2-2266075-2    | A                 | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                         | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|                                                                                  |                |                   |                          |                                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266075-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|                                                                                  |                |                   |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266075-4 | -         | -         | -                      |
|                                                                                  | 2-2266075-5    | A                 | FINE CRIMP HEIGHT ADJUST | SERVO<br>LATCH PLATE <sup>4</sup> | 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              |
|                                                                                  | 2-2266075-7    | A                 | FINE CRIMP HEIGHT ADJUST | NONE                              | -                                 | -                     | -         | -           | -         | -         | -                      |
| 7-2266075-7                                                                      | A              | CRIMP TOOLING KIT | -                        | -                                 | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.29 mm [.090] | F    |
| INSUL                                | 2.54 mm [.100] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

|                                         |             |                              |             |                        |
|-----------------------------------------|-------------|------------------------------|-------------|------------------------|
| TERMINAL DATA: TE TERMINAL              |             |                              |             | TE CRIMP SPECIFICATION |
| TERMINAL NAME: CLIP 6.35 NGI RECEPTACLE |             |                              |             |                        |
| WIRE STRIP LENGTH                       |             | INSULATION DIAMETER RANGE    |             |                        |
| 4.50-5.50 mm [.177-.217 IN]             |             | Ø1.30-1.80 mm [.051-.071 IN] |             |                        |
| TERMINAL APPLICATION SPECIFICATION      | 114-15095   | -                            | -           | -                      |
| TERMINALS APPLIED                       |             |                              |             |                        |
| TE TERMINAL                             | TE TERMINAL | TE TERMINAL                  | TE TERMINAL |                        |
| 1544615-1                               |             |                              |             |                        |

| WIRE SIZE       | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------------|----------------------------|--------------------------------|
| 0.75mm2         | 1.40+/-0.05 [.055+/- .002] | 4.8                            |
| 0.35mm2+0.35mm2 | 1.37+/-0.05 [.054+/- .002] | 5.3                            |
| 0.60mm2         | 1.33+/-0.05 [.052+/- .002] | 5.6                            |
| 0.50mm2         | 1.30+/-0.05 [.051+/- .002] | 6.1                            |
| 0.35mm2         | 1.24+/-0.05 [.049+/- .002] | 6.9                            |



- RECOMMENDED SPARE PARTS

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: 8-2266075-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266075-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266075-5
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 ITEMS 62 & 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.

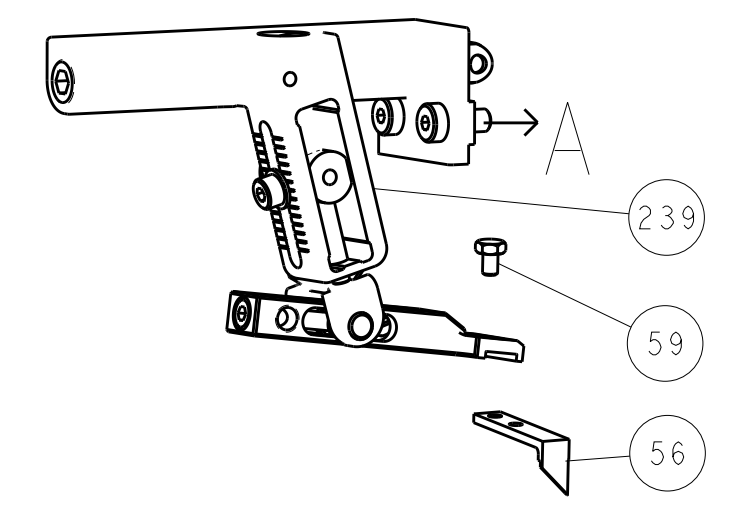
10. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11. TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON 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.
- |     |     |     |     |     |           |                                     |         |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 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   | 2119082-9 | 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<br>2119599-1 | LOC<br>A | DIST<br>66 | REVISIONS |     |             |      |     |      |
|---------------------------|----------|------------|-----------|-----|-------------|------|-----|------|
|                           |          |            | P         | LTR | 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     |
| -   | -   | 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     |
| -   | 1   | 1   | 1   | 1   | 1-22281-8   | SPRING, COMPRESSION                 | 121     |
| -   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
| -   | 1   | 1   | 1   | 1   | 693855-8    | FRONT STRIP GUIDE                   | 96      |
| -   | 2   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95      |
| -   | 1   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 93      |
| -   | 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 POINT, M3 x 4.0 | 62      |
| -   | 2   | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61      |
| -   | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | -   | -   | 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   | 2119644-1   | RAM WASHER, PRECISION               | 38      |
| -   | 1   | 1   | 1   | 1   | 2-1752356-0 | SUPPORT, TERMINAL                   | 34      |
| -   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| -   | 1   | 1   | 1   | 1   | 1-1320908-0 | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 1901086-1   | PLATE, STRIP GUIDE                  | 29      |
| -   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| -   | 2   | 2   | 2   | 2   | 22283-1     | SPRING, COMPRESSION                 | 27      |
| -   | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26      |
| -   | 1   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25      |
| -   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 1   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23      |
| -   | 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   | 1803055-4   | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 238011-2    | BLOCK, CRIMPER SPACER               | 4       |
| -   | 1   | 1   | 1   | 1   | 1633965-3   | CRIMPER, INSULATION O PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 455888-9    | SPACER, CRIMPER                     | 2       |
| -   | 1   | 1   | 1   | 1   | 2-456406-0  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -27 | -25 | -22 | -21 | PART NO     | DESCRIPTION                         | ITEM NO |
- |                                                                                                                                                                                                    |  |                                                                                                                  |  |                                  |                                              |                                        |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------|--|----------------------------------|----------------------------------------------|----------------------------------------|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION. |  |                                                                                                                  |  | OWN<br>R. KNEPPER<br>02-Oct-13   | TE Connectivity<br>Harrisburg, PA 17105-3608 |                                        |  |
| DIMENSIONS:<br>mm                                                                                                                                                                                  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.5<br>1 PLC ±0.13<br>3 PLC ±0.13<br>4 PLC ±0.0001<br>ANGLES ±.1 |  | CHK<br>T. ELBIN<br>02-Oct-13     | NAME<br>Ocean Side Feed<br>Applicator        |                                        |  |
|                                                                                                                                                                                                    |  | PRODUCT SPEC                                                                                                     |  | APVD<br>M. CLIFFORD<br>02-Oct-13 | SIZE<br>00779                                |                                        |  |
| MATERIAL                                                                                                                                                                                           |  | FINISH                                                                                                           |  | APPLICATION SPEC                 |                                              | DRAWING NO<br>00779                    |  |
| -                                                                                                                                                                                                  |  | -                                                                                                                |  | WEIGHT                           |                                              | Customer Accessible Production Drawing |  |
| -                                                                                                                                                                                                  |  | -                                                                                                                |  | SCALE                            |                                              | 1:2                                    |  |
| -                                                                                                                                                                                                  |  | -                                                                                                                |  | SHEET                            |                                              | 3 of 4                                 |  |
| -                                                                                                                                                                                                  |  | -                                                                                                                |  | REV                              |                                              | A                                      |  |
- SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION
- AMP 4805 REV 31MAR2000

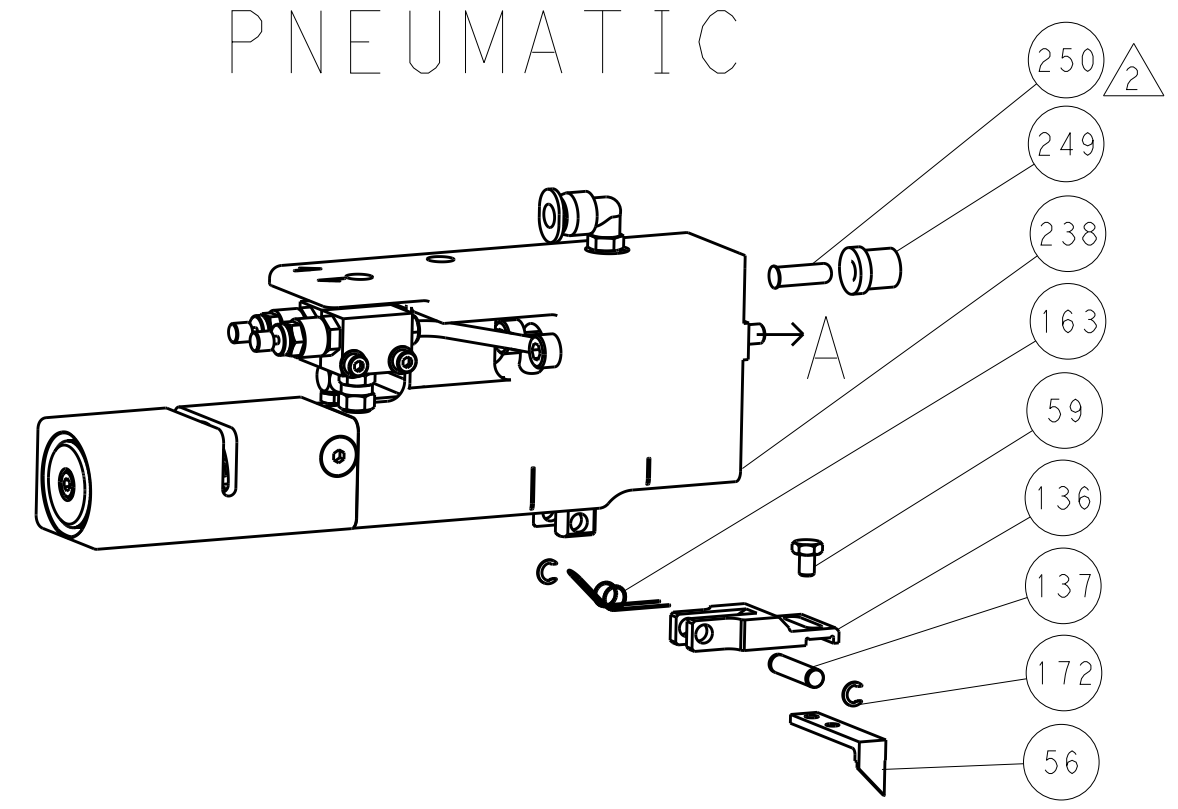


| LOC |    | DIST |     | REVISIONS   |  |      |     |      |
|-----|----|------|-----|-------------|--|------|-----|------|
| A   | 66 | P    | LYR | DESCRIPTION |  | DATE | DWN | APVD |
|     |    | -    |     | SEE SHEET 1 |  | -    | -   | -    |
|     |    |      |     |             |  |      |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

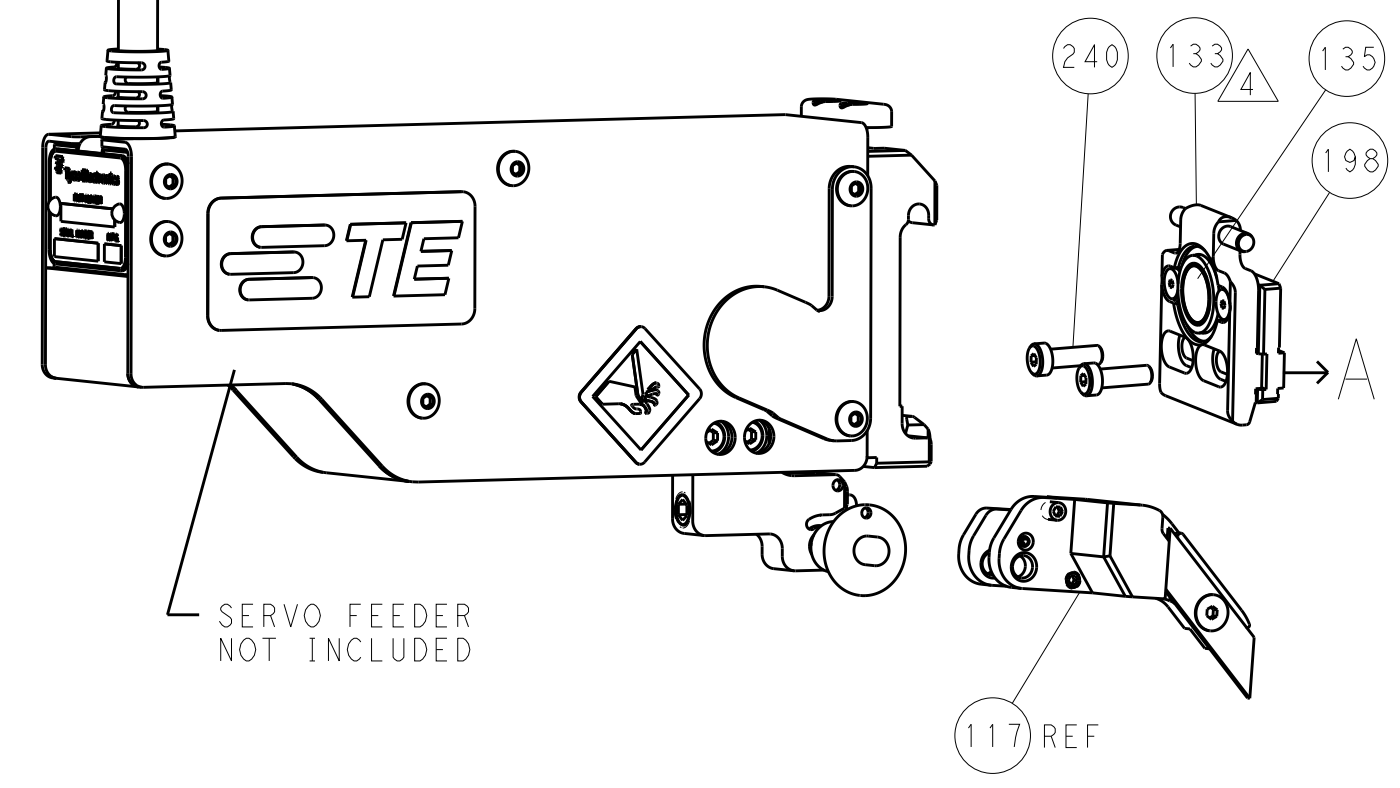
FEED TYPE  
MECHANICAL



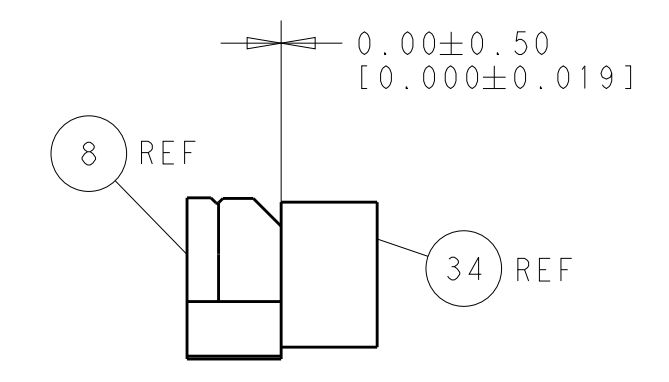
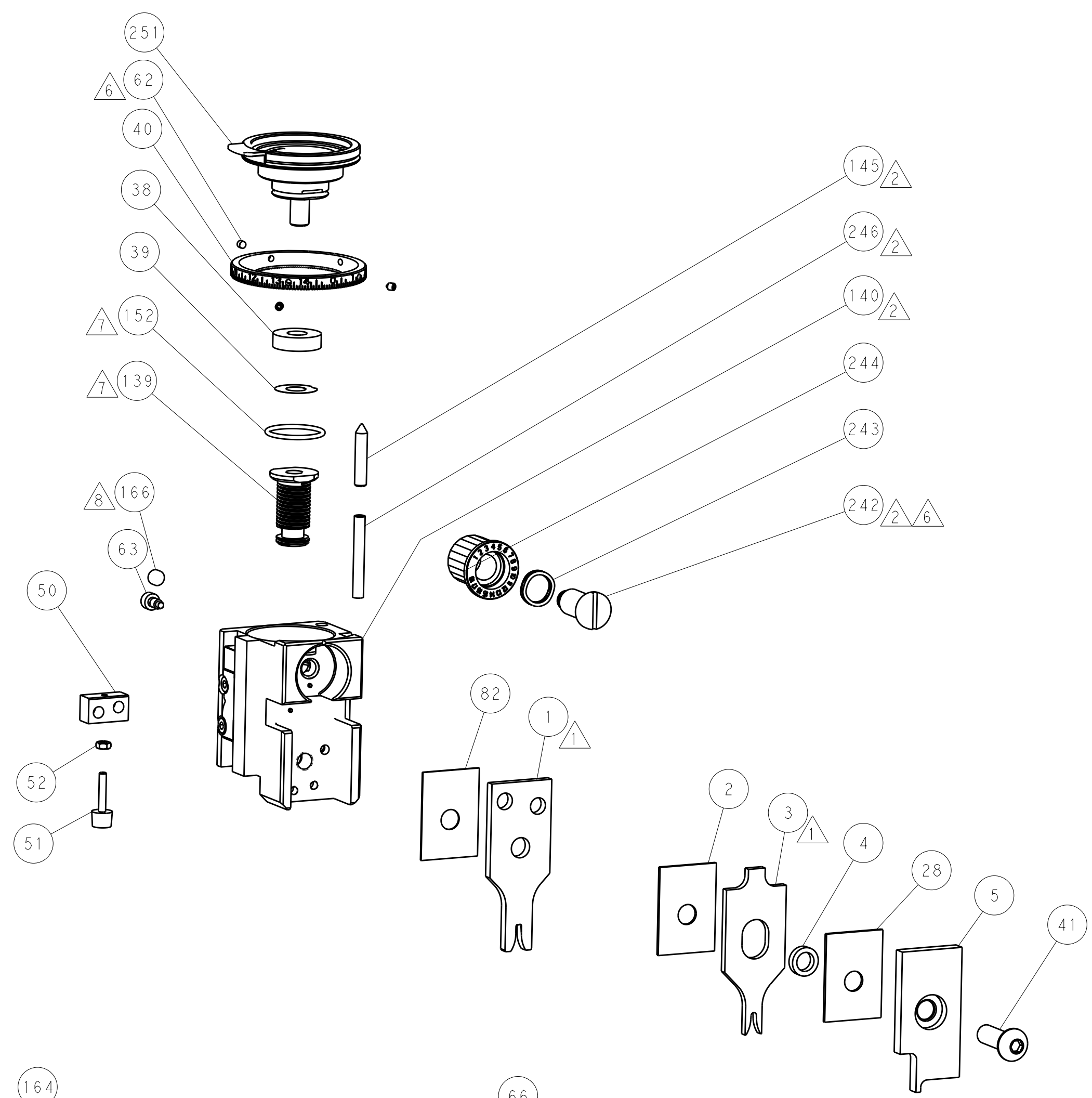
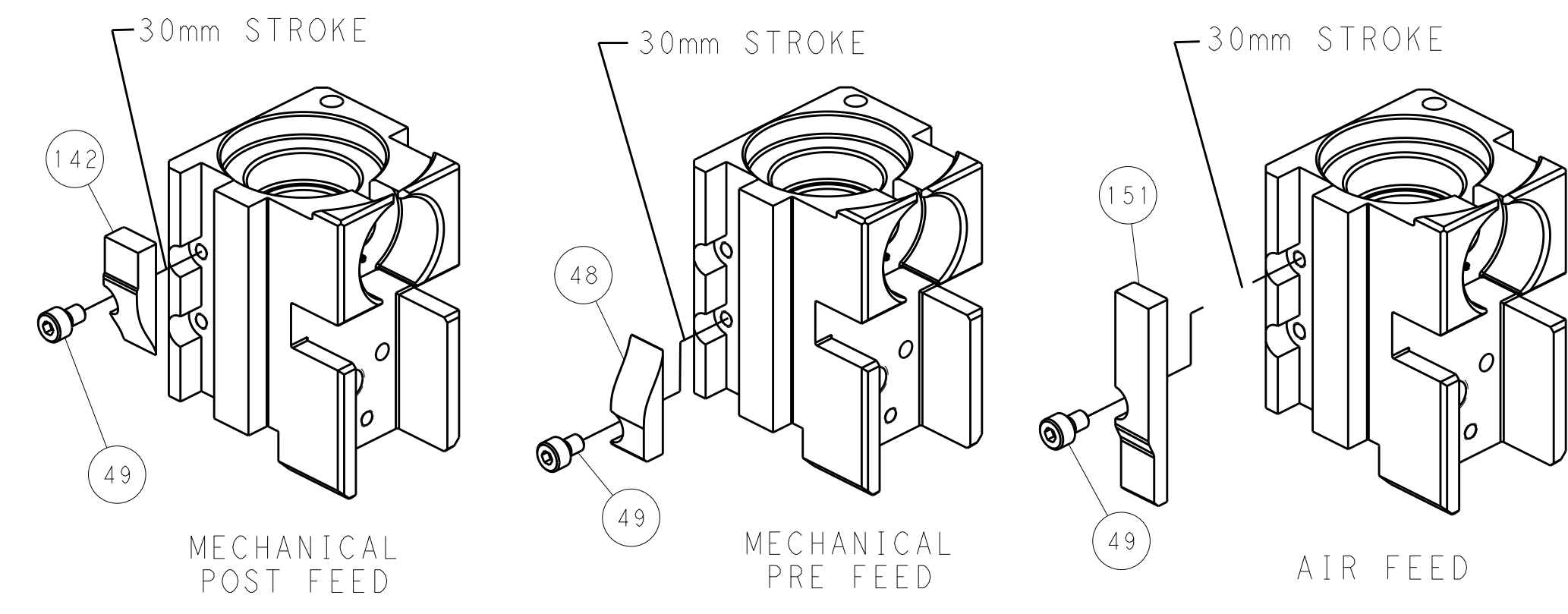
PNEUMATIC



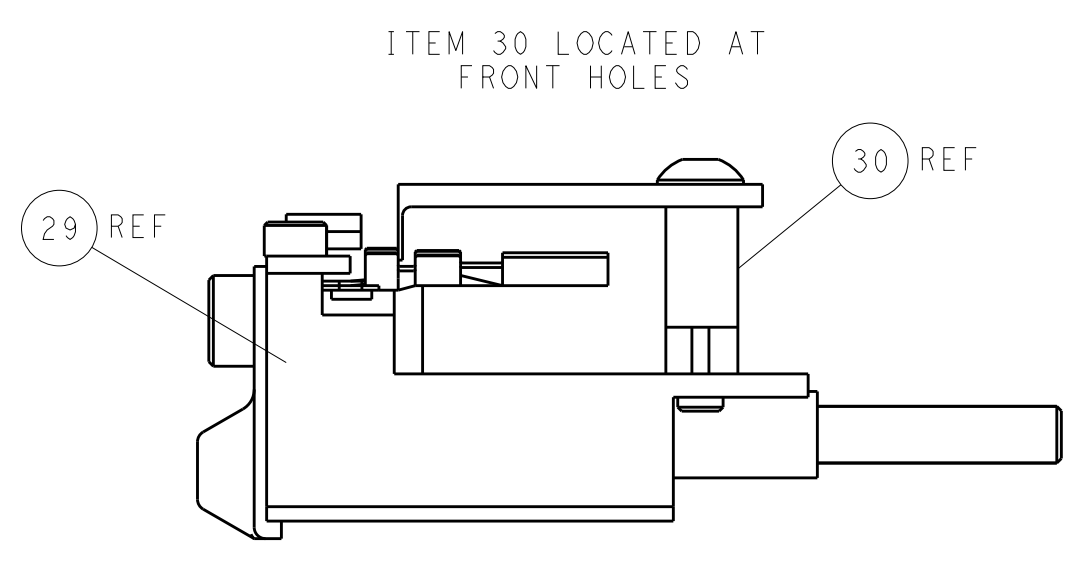
SERVO  
LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION  
GUIDE BY GUIDE\_BY\_STR

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

|                                        |  |                                           |  |                             |  |                           |  |                               |  |                                       |  |
|----------------------------------------|--|-------------------------------------------|--|-----------------------------|--|---------------------------|--|-------------------------------|--|---------------------------------------|--|
| DIMENSIONS:<br>mm                      |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED: |  | DWN<br>R. KNEPPER 02-Oct-13 |  | CHK<br>T. ELBIN 02-Oct-13 |  | APVD<br>W. CLIFFORD 02-Oct-13 |  | NAME<br>Ocean Side Feed<br>Applicator |  |
| 0 PLC ±.5                              |  | 1 PLC ±0.5                                |  | 2 PLC ±0.13                 |  | 3 PLC ±0.013              |  | 4 PLC ±0.001                  |  | RESTRICTED TO                         |  |
| MATERIAL                               |  | FINISH                                    |  | WEIGHT                      |  | SIZE                      |  | CAGE CODE                     |  | DRAWING NO                            |  |
|                                        |  |                                           |  |                             |  | A1                        |  | 00779                         |  | C=2266075                             |  |
| Customer Accessible Production Drawing |  | SCALE                                     |  | 1:2                         |  | SHEET                     |  | 4                             |  | OF 4                                  |  |
|                                        |  |                                           |  |                             |  |                           |  |                               |  | REV                                   |  |
|                                        |  |                                           |  |                             |  |                           |  |                               |  | A                                     |  |

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