

8

7

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1

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

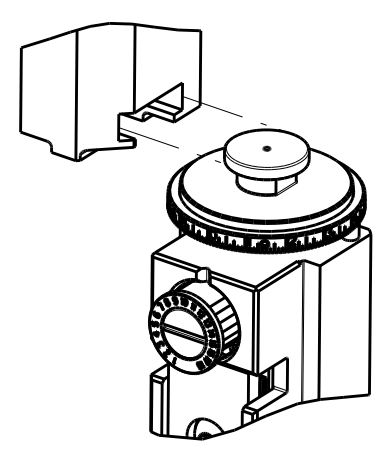
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2266081-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2266081-5

8-2266081-4

2119641-1

1901094-3

-

2119799-1

2-1752354-1

-

2063440-1

2168400-6 (QUANTITY 2)

-

2266081-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2266081-5

8-2266081-4

2119653-1

1901094-3

-

-

2-1752354-1

-

-

2168400-6 (QUANTITY 2)

-

2266081-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

-

1338685-1

-

-

5-18022-5

5-18022-5

-

2119653-1

2119641-1

-

-

2119799-1

2063440-1

2266081-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

-

-

-

-

-

-

-

-

-

-

2266081-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

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-

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-

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7-2266081-7

A

CRIMP TOOLING KIT

-

-

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-

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-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.60 mm [1.02]

F

INSUL

4.06 mm [1.60]

O

APPLICATOR INSTRUCTIONS

408-10389



TERMINAL DATA: LEAR TERMINAL

LEAR CRIMP SPECIFICATION

TERMINAL NAME: MKS-Plus ROUND PIN PLUG 1.5

WIRE STRIP LENGTH

4.80-5.20 mm [1.89-.205 IN]

INSULATION DIAMETER RANGE

Ø

1.3

TERMINAL APPLICATION SPECIFICATION

LEAR 25719 Rev 3

-

-

-

TERMINALS APPLIED

TE TERMINAL

LEAR TERMINAL

TE SEAL

LEAR SEAL

CABLE DIAMETER³

2113391-1

25719.201.184

1572316-1

16695.627.642

2.20-3.00

1572316-2

16695.627.619

2.20-3.00

1572316-3

7814140

2.20-3.00

1572316-4

1533994

2.20-3.00

1572316-5

16276.627.642

2.20-3.00

1572316-6

801DL2

2.20-3.00

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

2.50mm2

1.55+/-0.05 [1.061+/-0.002]

7.1

1.50mm2

1.40+/-0.05 [1.055+/-0.002]

8.7



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: 8-2266081-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266081-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266081-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266081-6

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 4.25.

¹³ THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

¹⁴ APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
APPLY #1-23419-5 LOC-TITE TO THREADS.

¹⁵ THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL.

-

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1

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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

-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

REVISONS

P

LTR

DESCRIPTION

DATE

OWN

APVD

A

RELEASED

30DEC2013

LG

GB

-

1

1

1

1

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2119082-2

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

1

1

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1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

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1

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2119083-1

RETAINER, INSULATION DIAL

242

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1

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1

1

7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

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-

2

2

-

-

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

-

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

-

1

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2063440-1

AIR FEED MODULE

238

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-

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

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-

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1

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240638-1

SPRING, FEED FINGER

163

-

-

-

-

1

-

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

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-

-

-

1

-

2119799-1

HOLDER, FEED FINGER, AF

136

-

-

REF

REF

-

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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1

1

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1633743-1

SERVO FEED LATCH ASM

133

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1

1

1

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1

455888-3

SPACER, CRIMPER

120

-

1

1

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1

1-18028-2

WASHER, FLAT, REG M4

119

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REF

REF

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2119944-1

FEED FINGER ASSEMBLY, SF

117

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1

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455888-6

SPACER, CRIMPER

82

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2

2

2

2

2

2079383-4

SCR, BHSC, RoHS (M4 X 8)

79

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1

1

1

1

1

1803096-1

EXTENSION PLATE

78

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1

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

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1

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1

1

1

2119791-9

DEPRESSOR, WIRE

70

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1

1

1

1

1

2119943-1

WASHER, SPACER

69

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1

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1

1

2119740-1

TAG, IDENTIFICATION

67

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2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

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1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

-

3

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3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 X 4.0

62

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1

1

1

1

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2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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1

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5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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1

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985575-3

SCR, FLT SKT HD CAP M3 X 10.0

57

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-

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

2168083-3

SCR, SKT HD CAP, RoHS, M4 X 12.0

53

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1

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5018030-1

NUT, HEX, REG, RoHS, M3

52

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811242-5

BUMPER, HOLD DOWN

51

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690753-2

SPACER, TONKER

50

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18023-9

SCR, SKT HD CAP M4 X 6.0

49

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2119652-1

FEED CAM, PRE FEED

48

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2119653-1

FEED CAM, POST FEED

47

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2-2119656-1

APPLICATOR BASIC ASSEMBLY, SF

46

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1

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2119370-1

RAM, AMP STYLE, SIDE FEED

44

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2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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1

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1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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1

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1

1

2119957-1

APPLICATOR SHIM PACK

39

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1-2119644-2

RAM WASHER, PRECISION

38

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1

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1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

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1

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1

2119092-1

BOLT, ADJUSTMENT

35

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1

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1752356-3

SUPPORT, TERMINAL

34

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2

2

2

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2

2079383-8

SCR, BHSC, RoHS (M4 X 16)

33

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2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

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1320908-4

SPACER, STRIP GUIDE

30

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2119959-4

ASSEMBLY, STRIP GUIDE

29

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455888-4

SPACER, CRIMPER

28

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240792-1

DRAG, TERMINAL

25

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1320928-4

STRIP GUIDE

24

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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1-18028-2

WASHER, FLAT, REG M4

20

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2119533-1

STRIPPER, SIDE FEED

19

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1

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2119806-1

INSERT, SHEAR

13

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3-22280-3

SPRING, COMPRESSION

12

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1-356885-4

STOP, SHEAR

11

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1

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2119805-1

SHEAR HOLDER, FRONT

10

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318707-1

FLOATING SHEAR, FRONT

9

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1

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1

3-1803054-9

ANVIL, COMBINATION

8

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1-240641-9

SPACER

7

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6

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2119781-5

DEPRESSOR, SHEAR

5

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238011-7

BLOCK, CRIMPER SPACER

4

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1

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1

3-1633996-0

CRIMPER, INSULATION SPECIAL

3

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1

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1

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455888-6

SPACER, CRIMPER

2

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1

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1

1

1

1633588-6

CRIMPER, WIRE

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE CURRENT REVISION OF THIS DRAWING. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.13

4 PLC ±0.0001

ANGLES ±.5

FINISH

MATERIAL

FINISH

WT

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

A

RESTRICTED TO

-

OWN

R.O.WILSON

29OCT2013

CHK

K.J.STAKEM

29OCT2013

APVD

T.L.FLIN

29OCT2013

NAME

Ocean Side Feed

Applicator

SIZE

CAGE CODE

DRAWING NO

00779

©=2266081

TE Connectivity

Harrisburg, PA 17105-3608

8

7

6

5

4

3

2

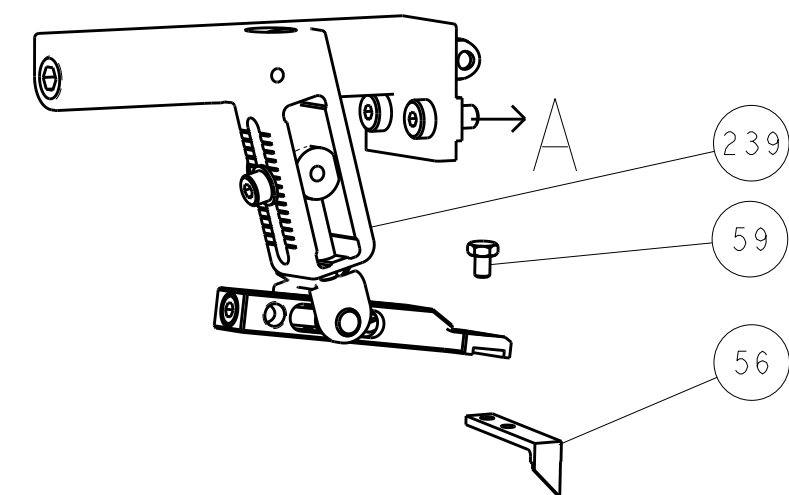
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AMP 4805 REV 31MAR2000

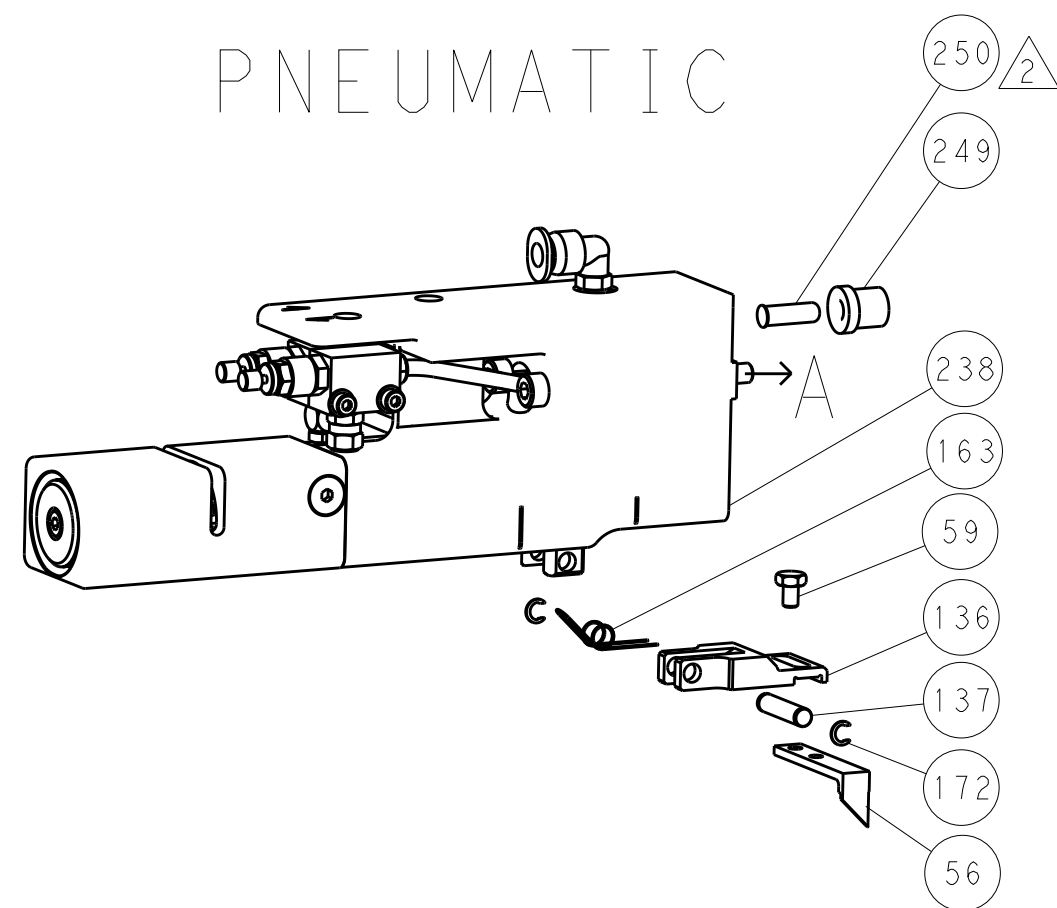
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

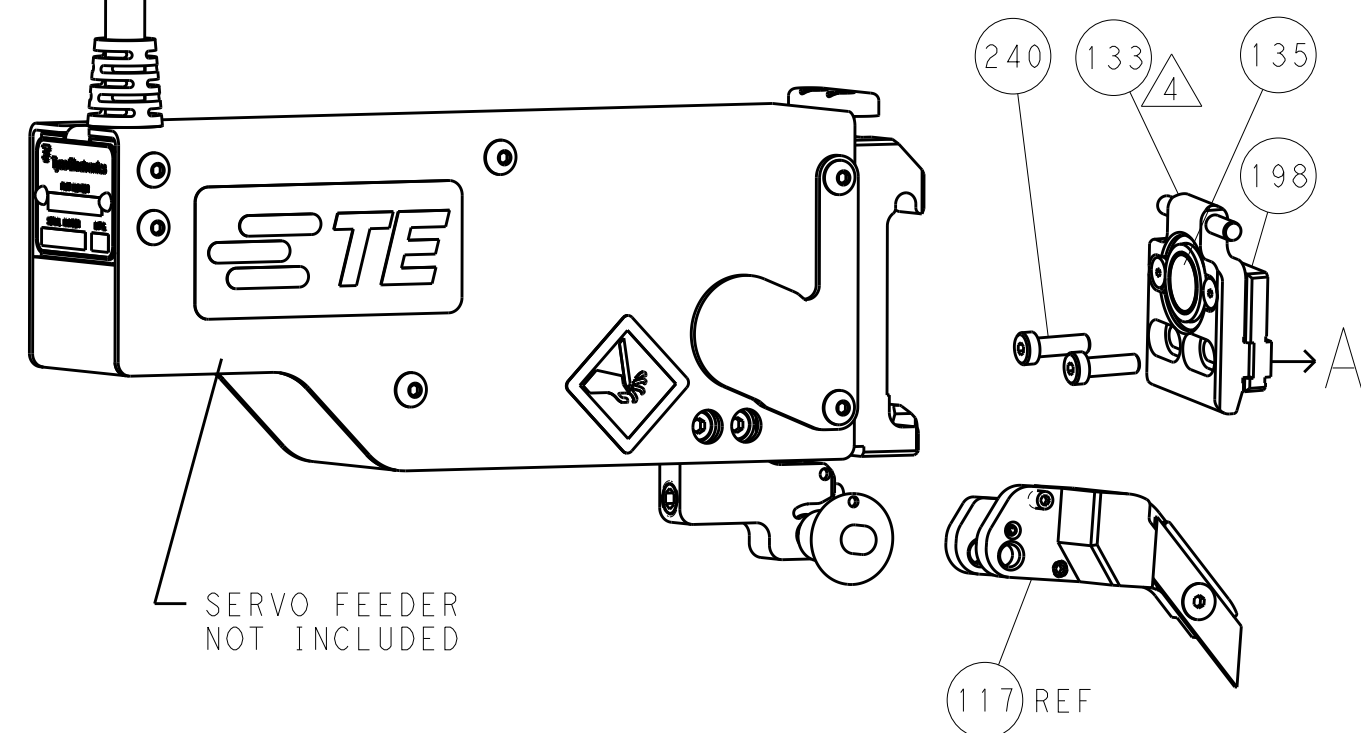
FEED TYPE MECHANICAL



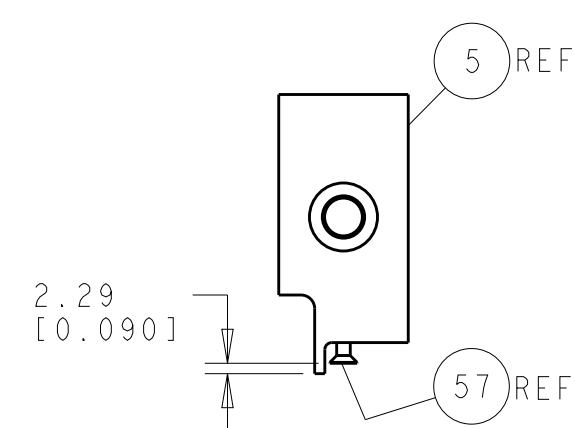
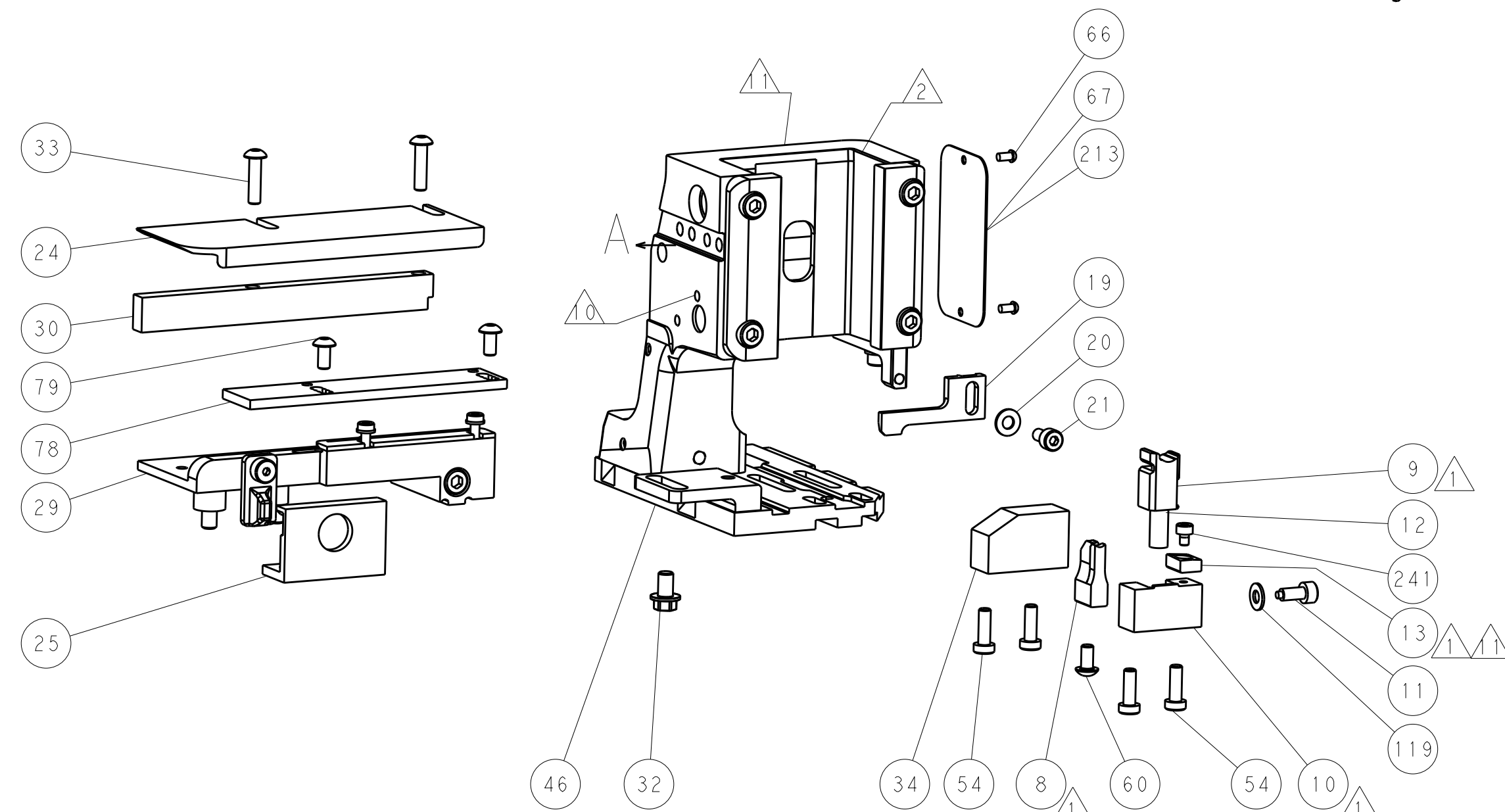
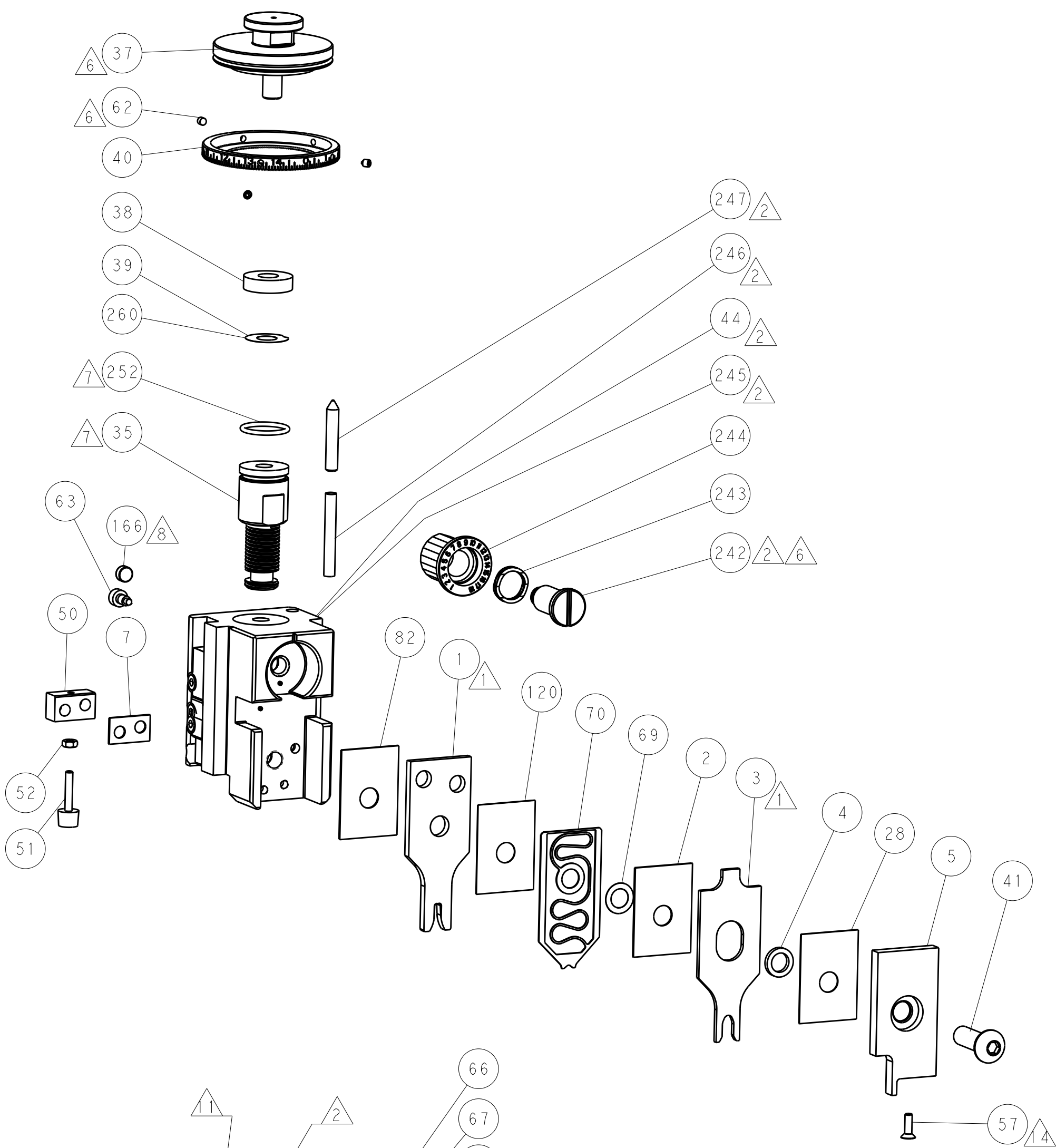
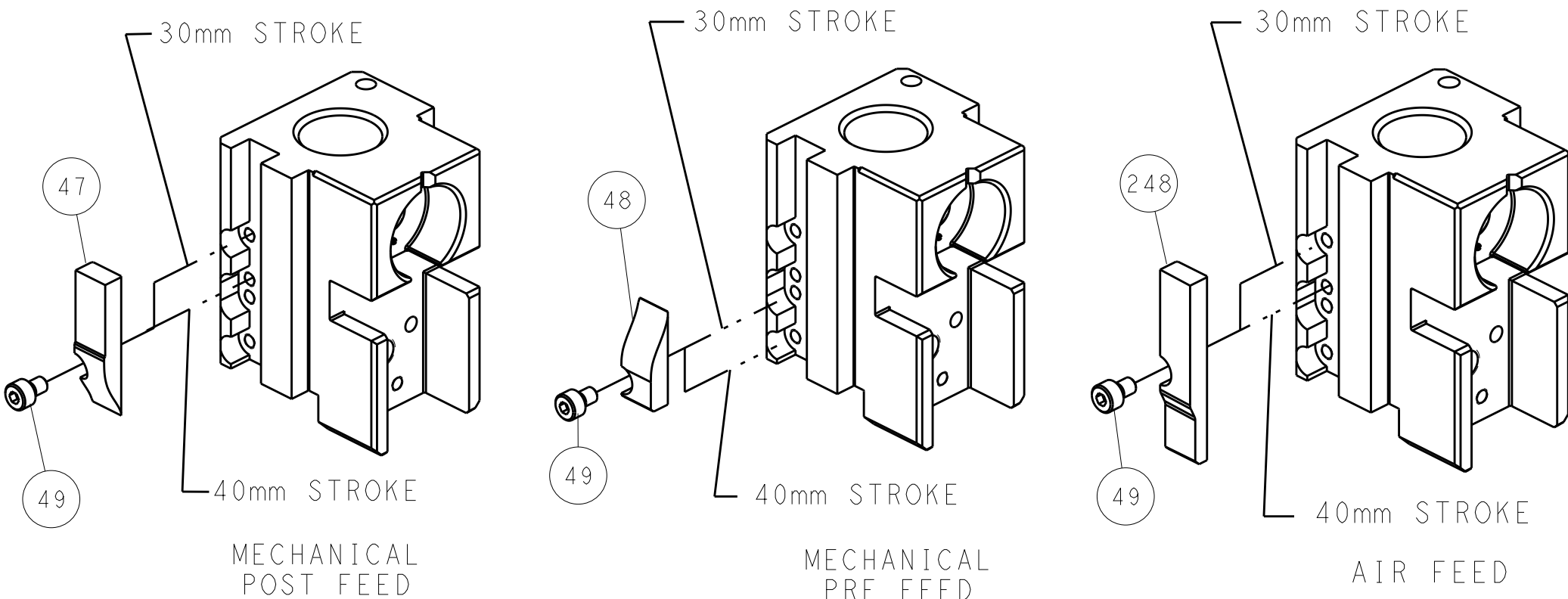
PNEUMATIC



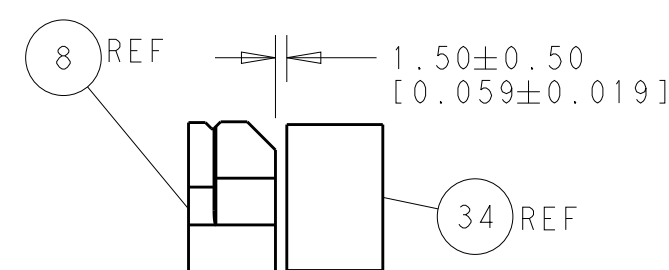
SERVO LATCH PLATE



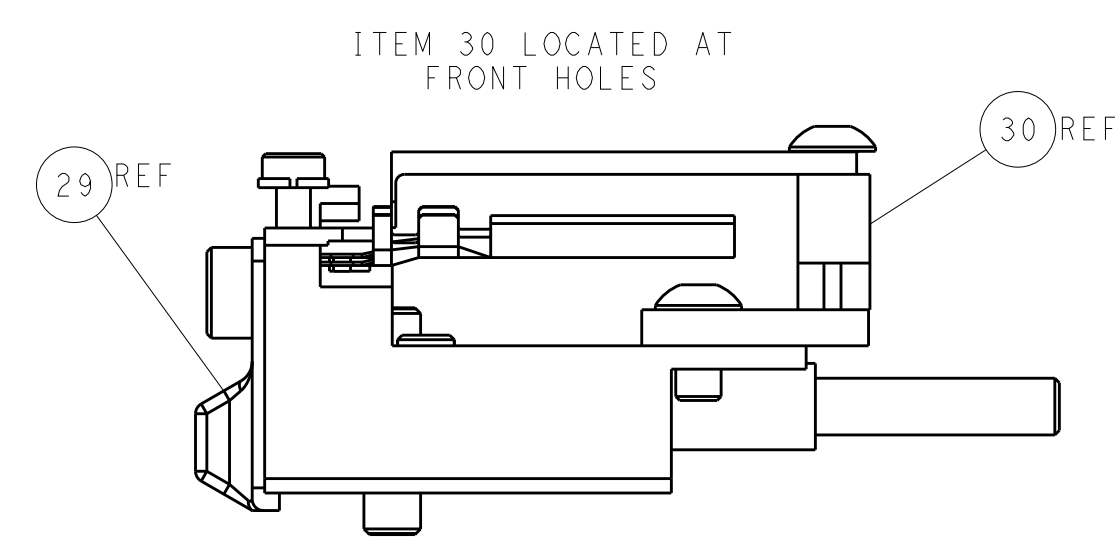
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. Q. WILSON 26OCT2013		TE Connectivity	
mm		0 PLC ±.5		CHK K. J. STAKEM 29OCT2013		Harrisburg, PA 17105-3608	
		1 PLC ±0.13		APVD T. L. ELBIN 29OCT2013		NAME Ocean Side Feed	
		2 PLC ±0.13		PRODUCT SPEC		-	
		3 PLC ±0.13		APPLICATION SPEC		-	
		4 PLC ±0.0001		WEIGHT		-	
MATERIAL		FINISH		Customer Accessible Production Drawing		RESTRICTED TO	
				SCALE 1:2		SHEET 2 OF 4	
						REV A	

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

D

C

B

A

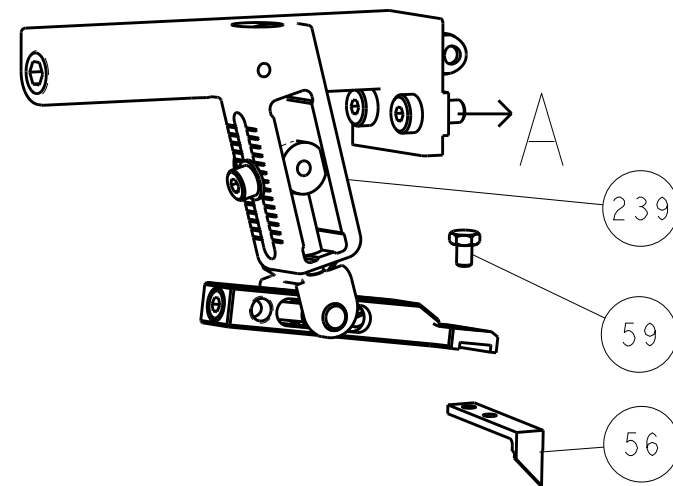
D

C

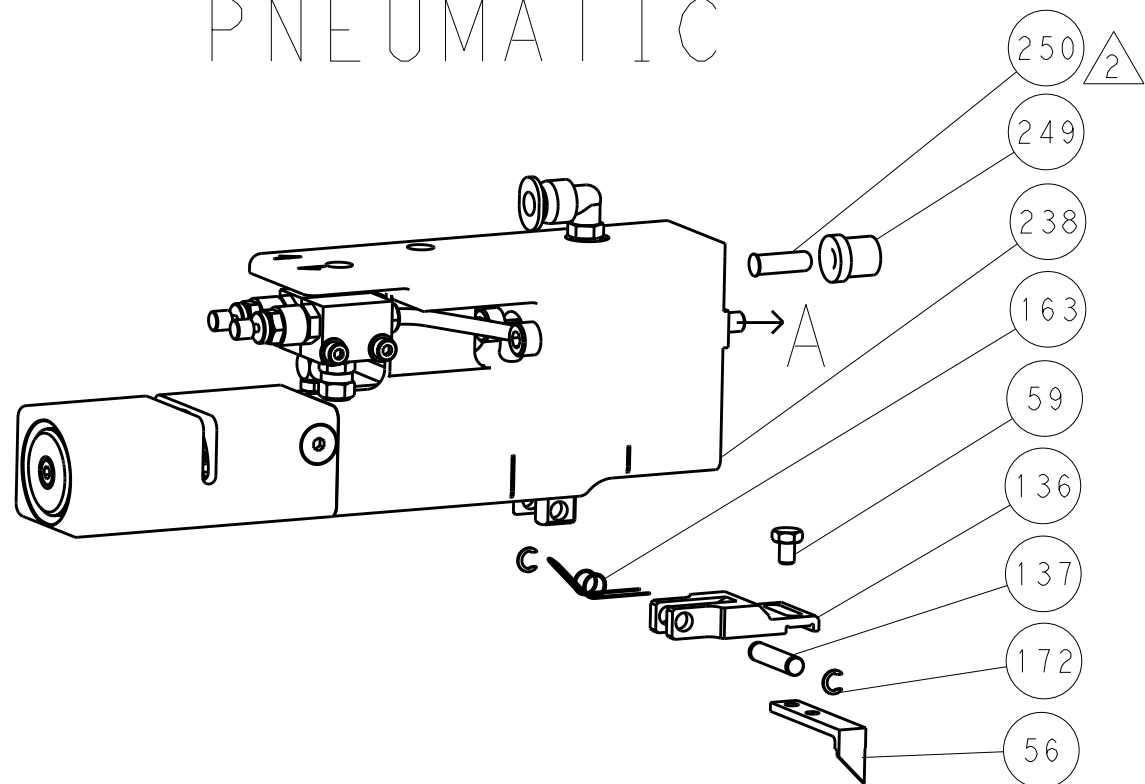
B

A

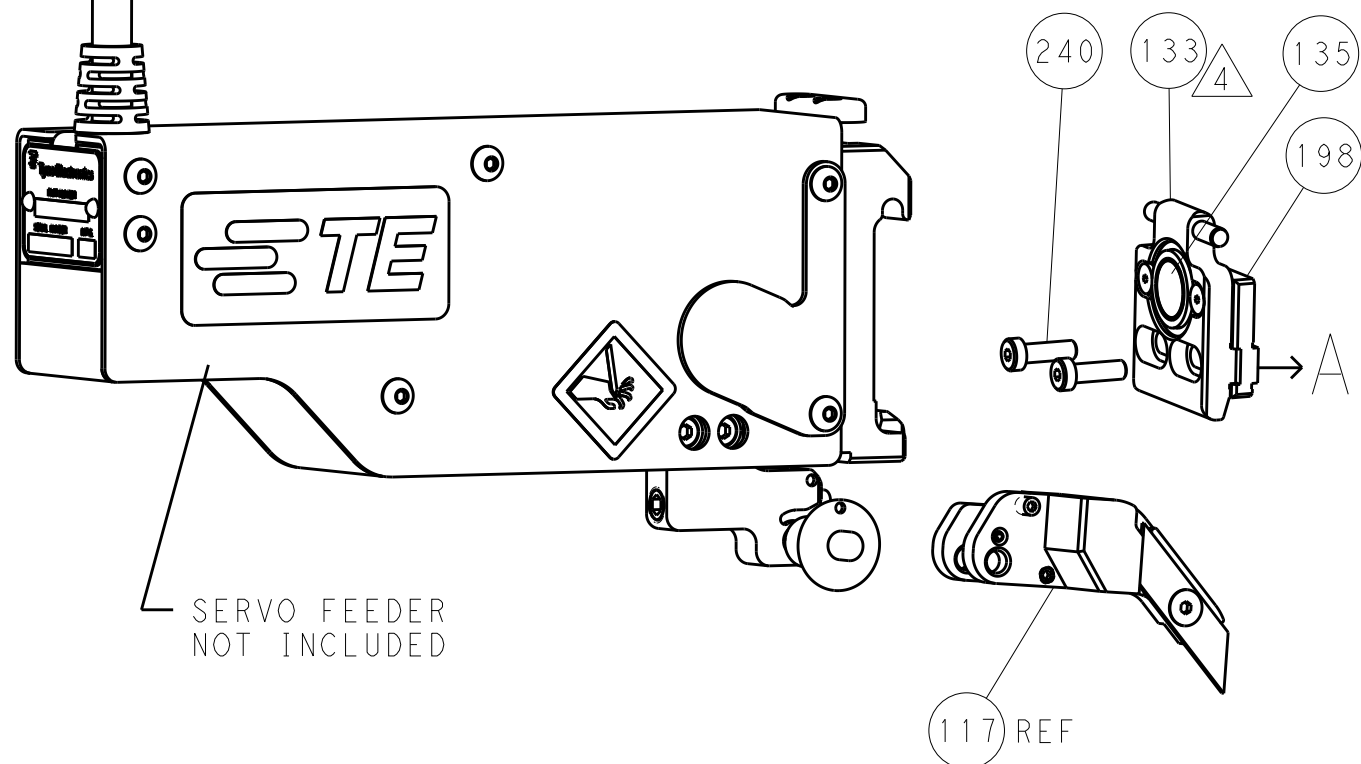
FEED TYPE MECHANICAL



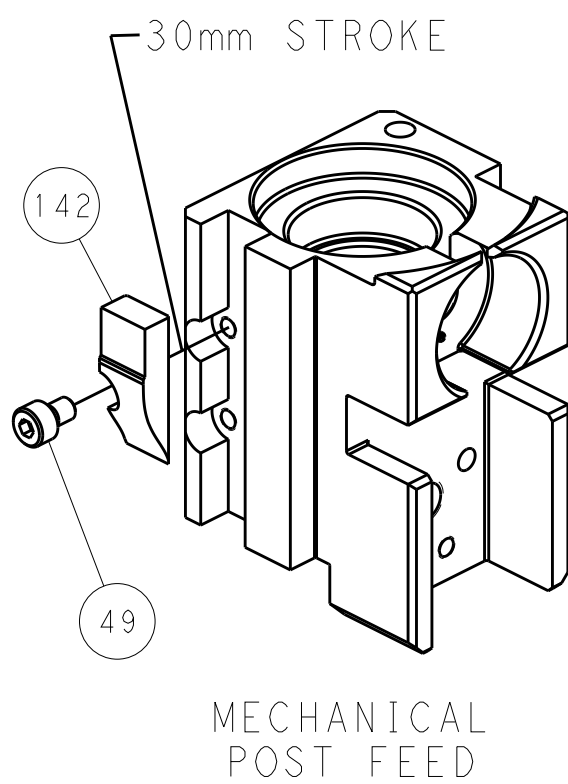
PNEUMATIC



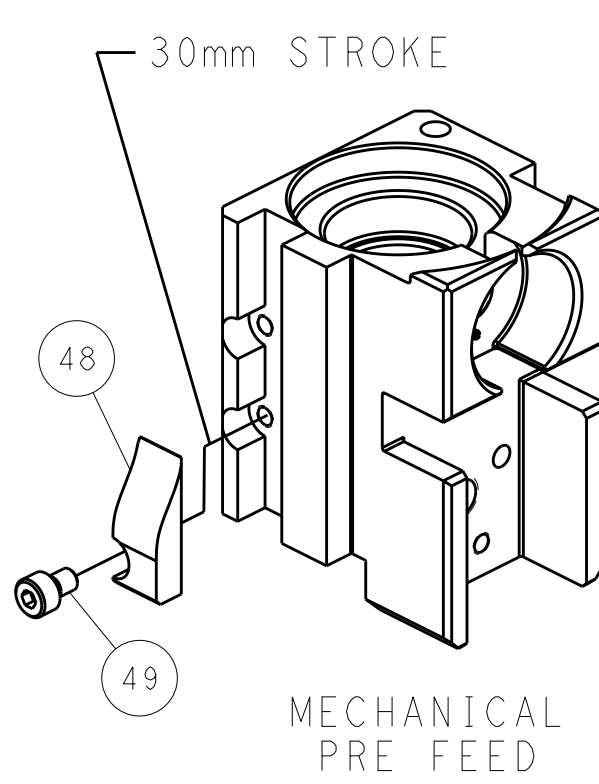
SERVO LATCH PLATE



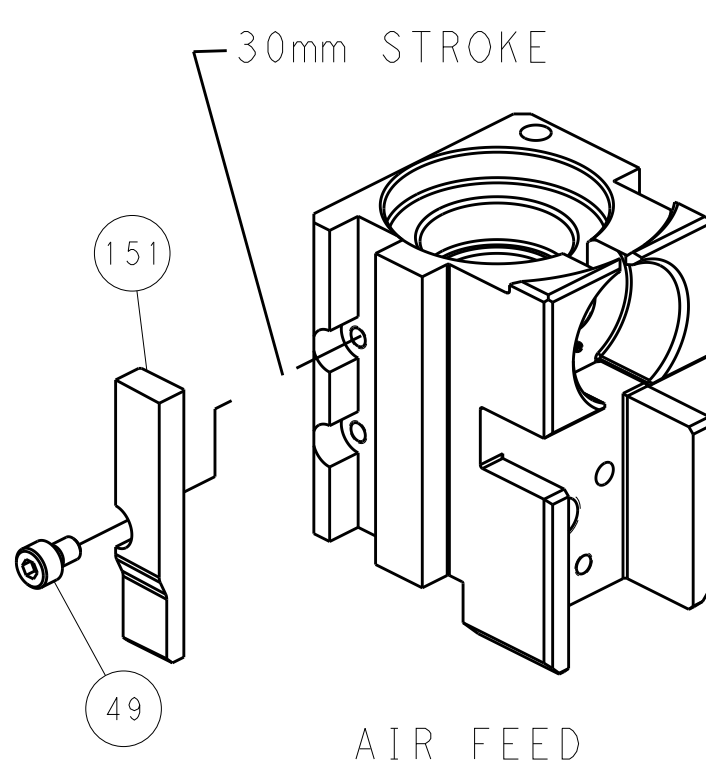
CAM POSITIONS



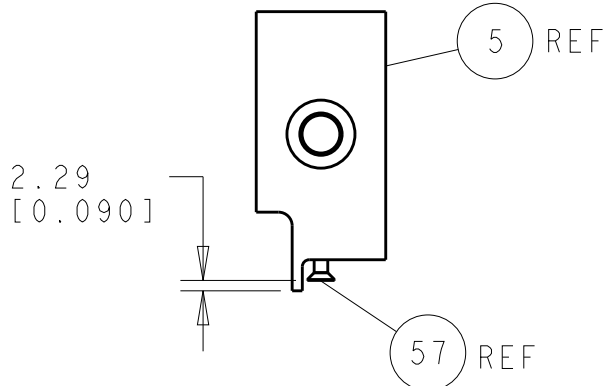
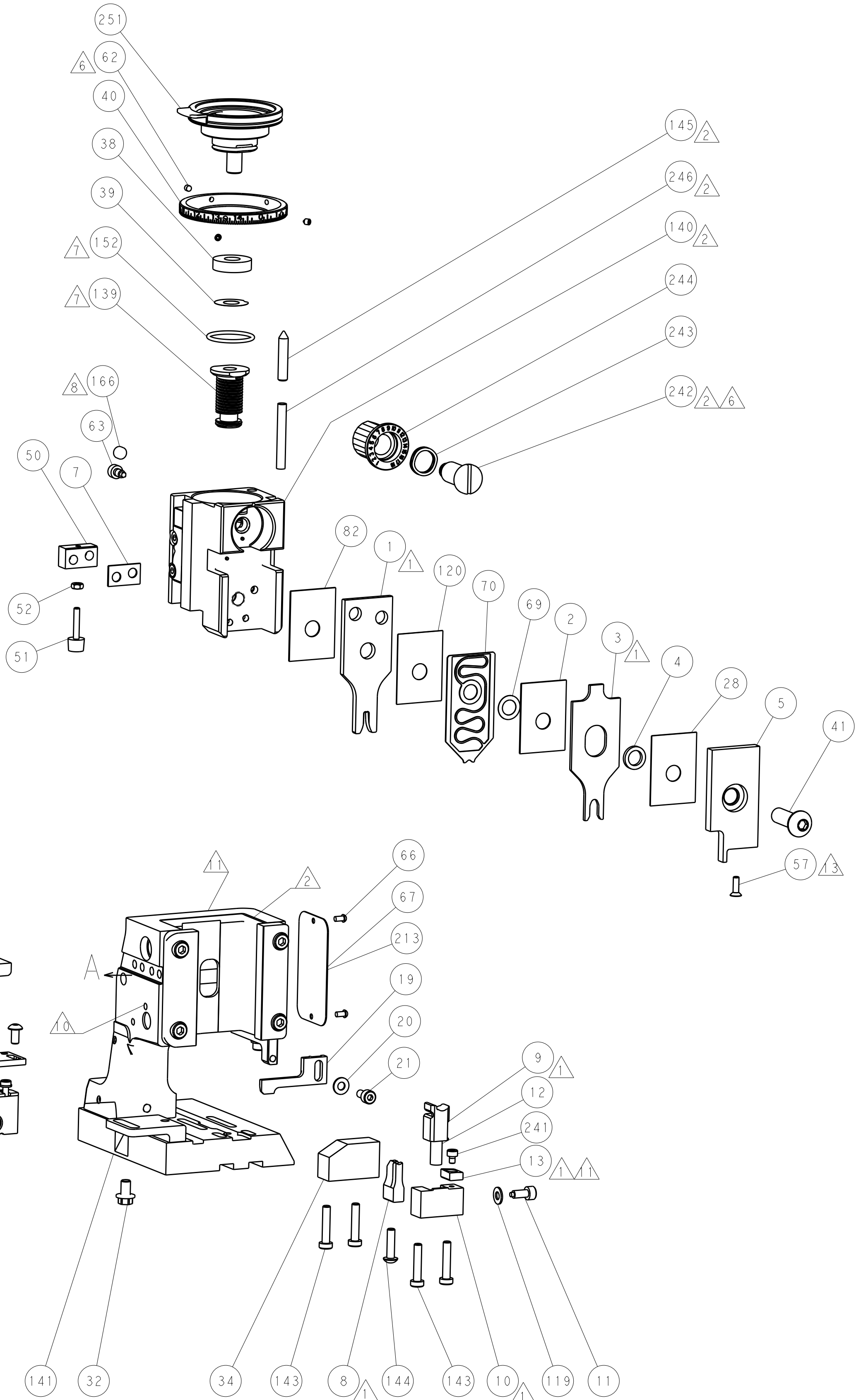
MECHANICAL
POST FEED



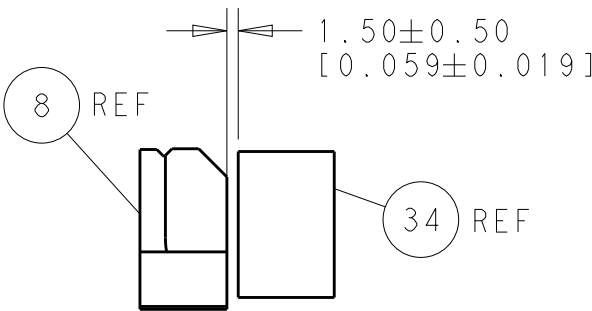
MECHANICAL
PRE FEED



AIR FEED

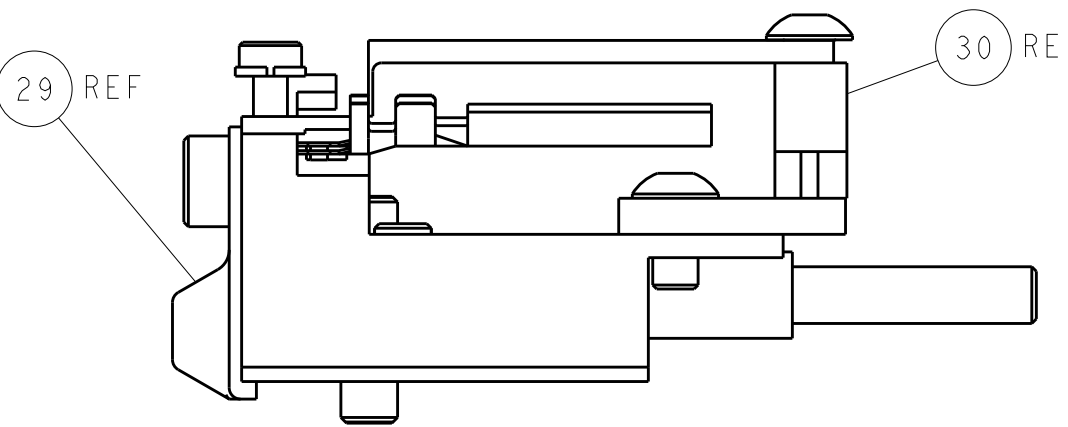


SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT
REAR HOLES



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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION.				OWN: R. Q. WILSON 26OCT2013 CHK: K. J. STAKEM 29OCT2013 APVD: T. L. ELGIN 29OCT2013				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.5 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES FINISH				NAME: Ocean Side Feed Applicator			
MATERIAL: -				WEIGHT: -				SIZE: A1 00779 C=2266081			
Customer Accessible Production Drawing				SCALE: 1:2				SHEET 4 OF 4 REV A			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2266081-2](#)