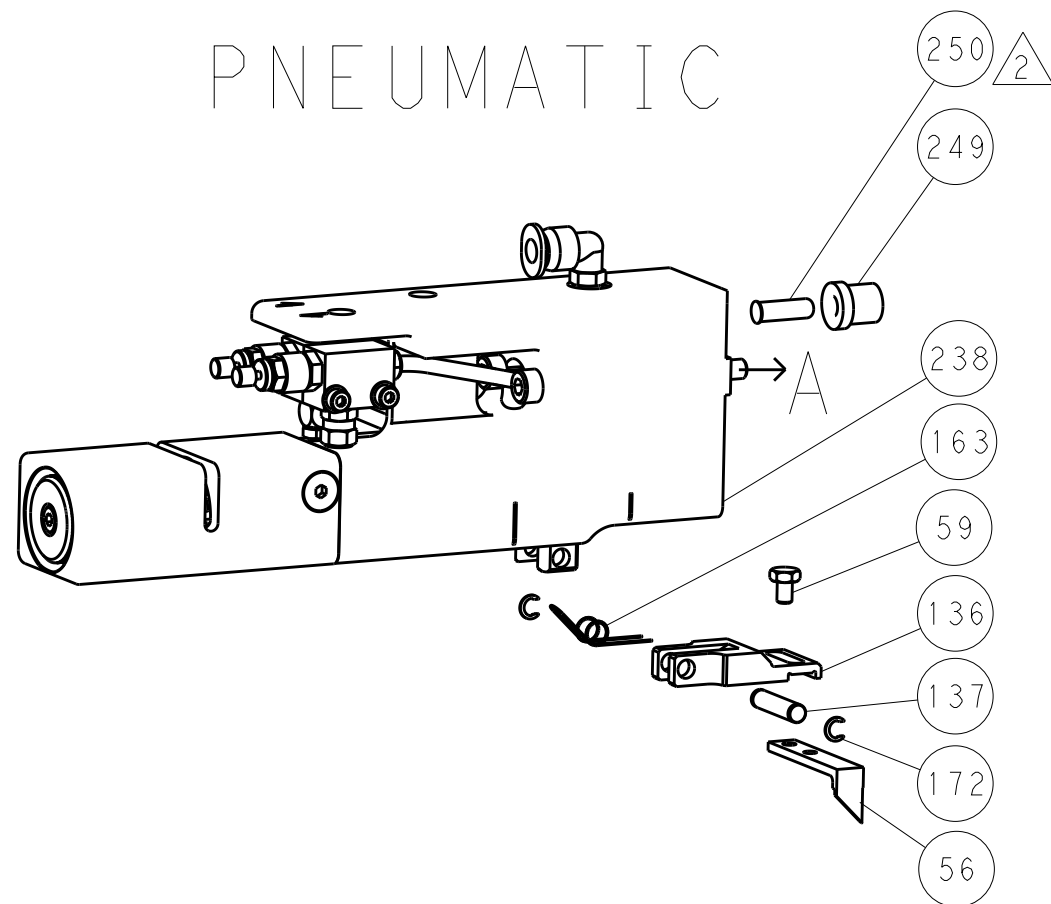


LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE
MECHANICAL



PNEUMATIC



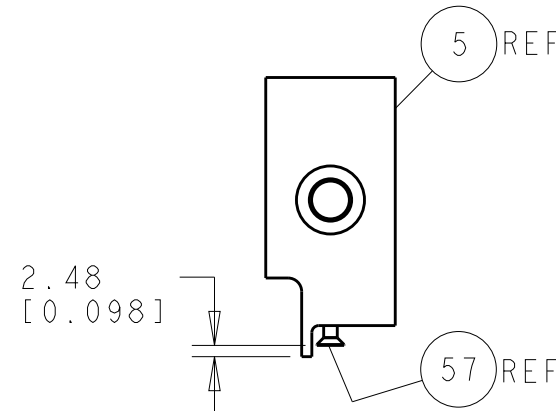
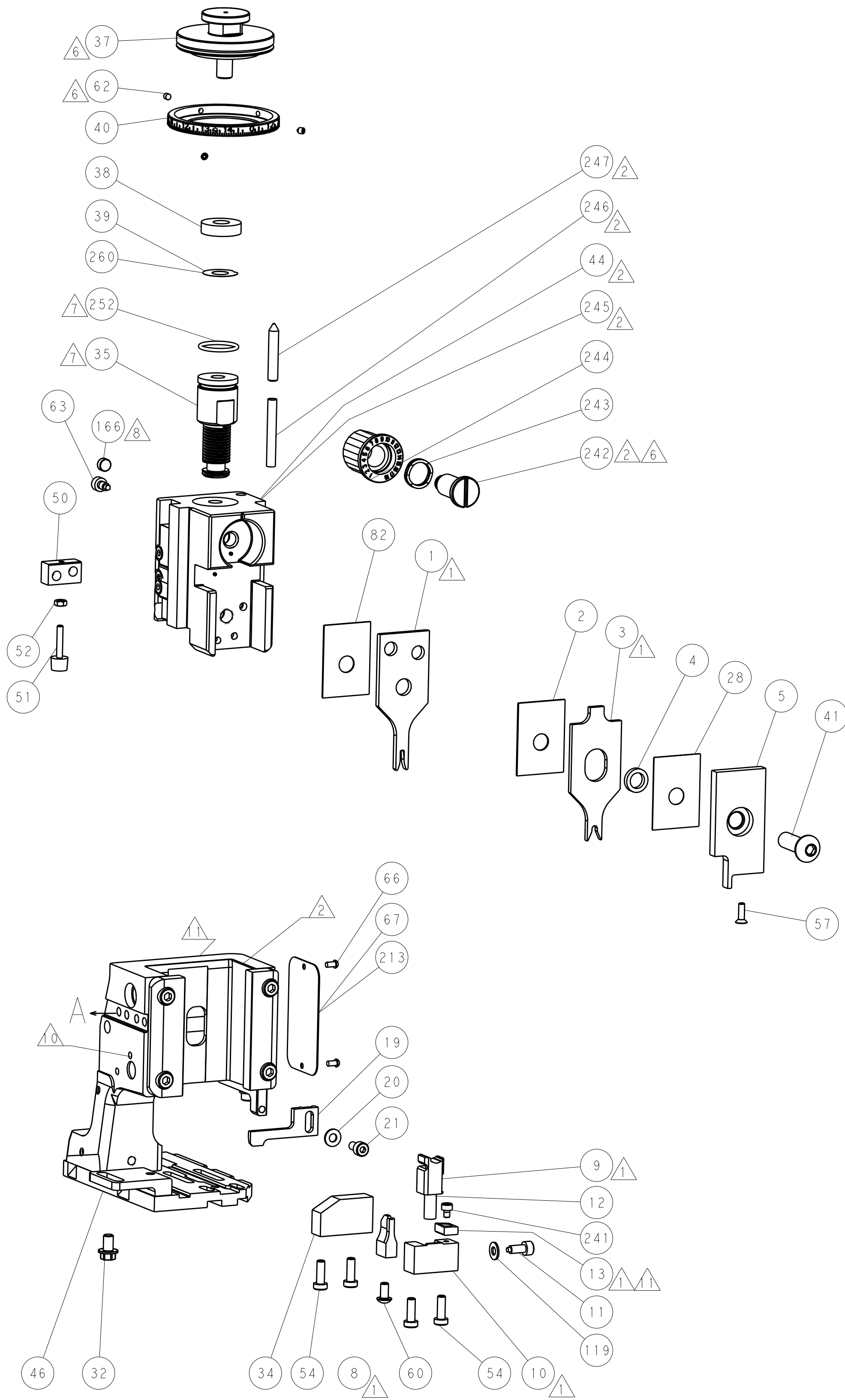
SERVO
LATCH PLATE



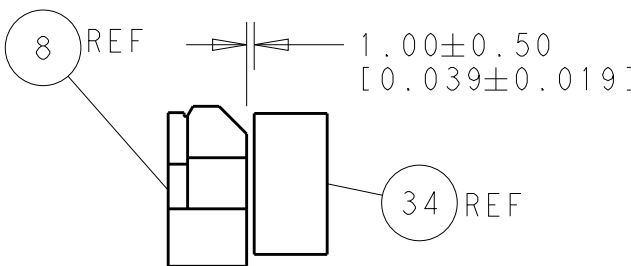
CAM POSITIONS



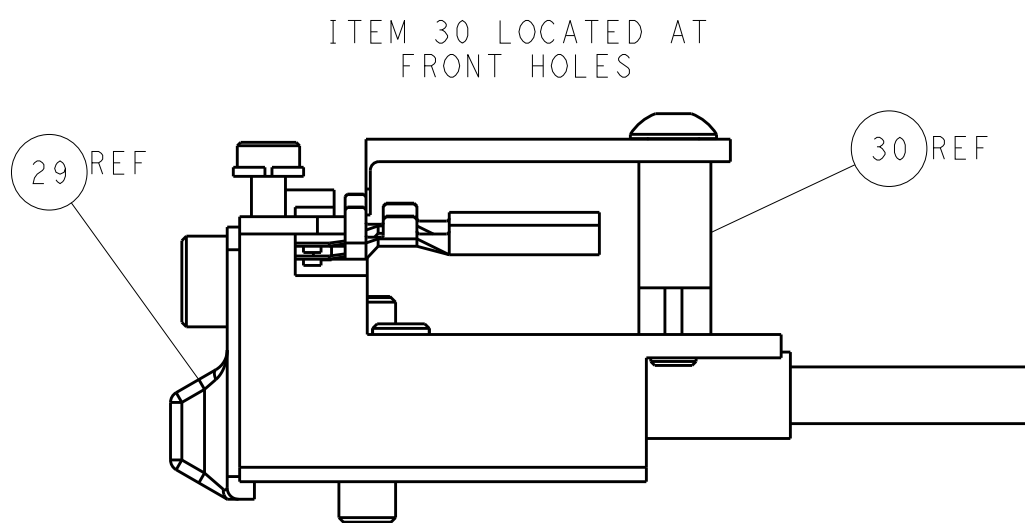
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



SHEAR DEPRESSOR DETAIL



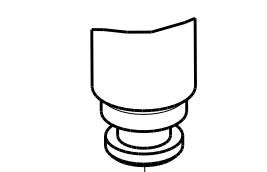
TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN: K. HUANG 05NOV2013 CHK: L. ZHANG 05NOV2013 APVD: J. GUO 05NOV2013				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME: Ocean Side Feed Applicator			
mm				0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001				SIZE: A1			
MATERIAL:				FINISH:				CAGE CODE: 00779			
								DRAWING NO: C=2266141			
								RESTRICTED TO: -			
								SCALE: 1:2			
								SHEET: 2 of 4			
								REV: A			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7		6		5		4		3	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1				
		SERVO LATCH PLATE	2119951-1	-	8-2266141-5	1901094-3	-	2168400-6 (QUANTITY 2)			
		SMART APPLICATOR	2161326-1	-	8-2266141-4	-	-	-			
	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-				
		SERVO LATCH PLATE	2119951-1	-	8-2266141-5	1901094-3	-	2168400-6 (QUANTITY 2)			
		SMART APPLICATOR	2161326-1	-	8-2266141-4	-	-	-			
	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			
-	-	-	-	-	-	-	-	-	-	-	
-	-	-	-	-	-	-	-	-	-	-	

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

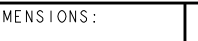
TERMINAL DATA: G&H TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: AFS PLUS-FLACHSTECKER 1.5X 0.6-1			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]		INSULATION DIAMETER RANGE Ø1.40-2.00 mm [.055-.079 IN]	
TERMINAL APPLICATION  26595 Rev 4		-	
SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE SEAL	G&H SEAL
2113401-1	26595.330.185	963530-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.25+/- 0.05 [.049+/- .002]		8.1
0.75mm2		1.20+/- 0.05 [.047+/- .002]		8.5
0.50mm2		1.15+/- 0.05 [.045+/- .002]		9.0

```
*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. 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: 8-2266141-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266141-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266141-5
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.
12. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
13. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
APPLY #1-23419-5 LOC-TITE TO THREADS.
14. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING

		2		1			
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS			
		P	LYR	DESCRIPTION	DATE	DRN	APVD
			-	SEE SHEET 1	-	-	-
6	-	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	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	
-	-	-	-	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	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
-	-	-	1	240638-1	SPRING, FEED FINGER	163	
-	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	2119798-2	DETENT PIN	145	
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143	
-	-	-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	1	1	2-2119656-2	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140	
-	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
6	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	-	-	1	1338685-1	PAWL, FEED	56
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	690753-2	SPACER, TONKER	50	
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	-	-	2119652-1	FEED CAM, PRE FEED	48	
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38	
-	1	1	1	1-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32	
-	1	1	1	1-1320908-2	SPACER, STRIP GUIDE	30	
-	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
1	-	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11	
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1-1633919-8	ANVIL, COMBINATION	8
	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	3-1803019-2	CRIMPER, INSULATION O	3
	-	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	1	3-456404-5	CRIMPER, WIRE PREMIUM	1
	-77	-27	-25	-22	-21	PART NO	DESCRIPTION

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±- 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±-		NAME U GUO		Ocean Side Feed Applicator -	
		PRODUCT SPEC -		APPLICATION SPEC -		SIZE A	
MATERIAL -		FINISH -		WEIGHT -		CAGE CODE 00779	
				DRAWING NO C=2266141		RESTRICTED TO -	
Customer Accessible Production Drawing						SCALE 1:2 SHEET 3 of 4 REV A	

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

D

C

B

A

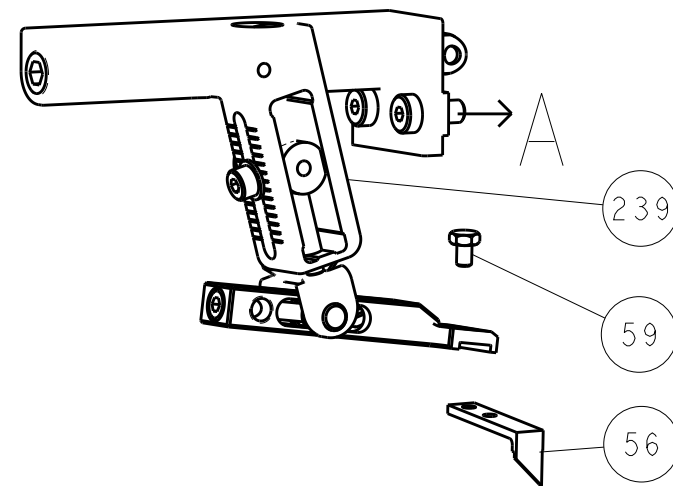
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C

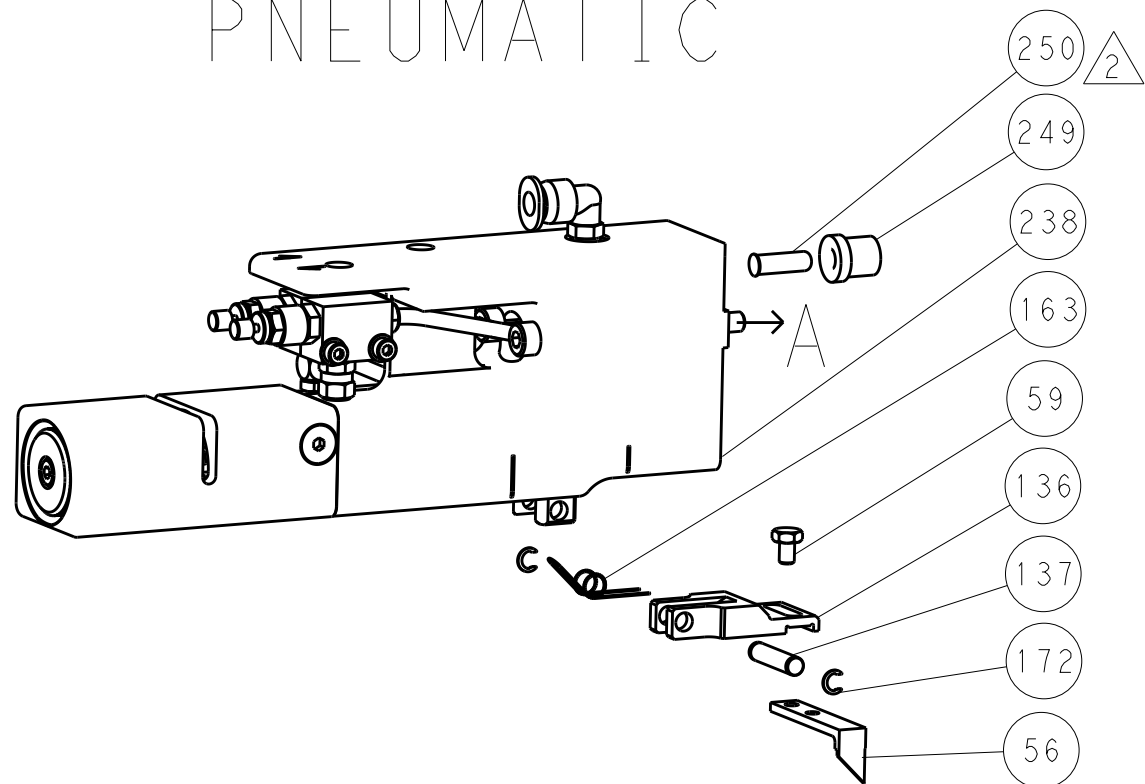
B

A

FEED TYPE MECHANICAL



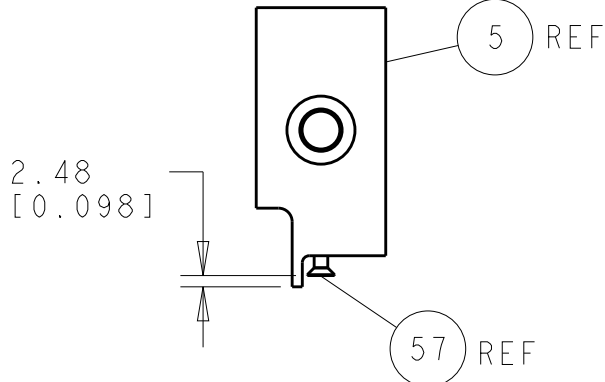
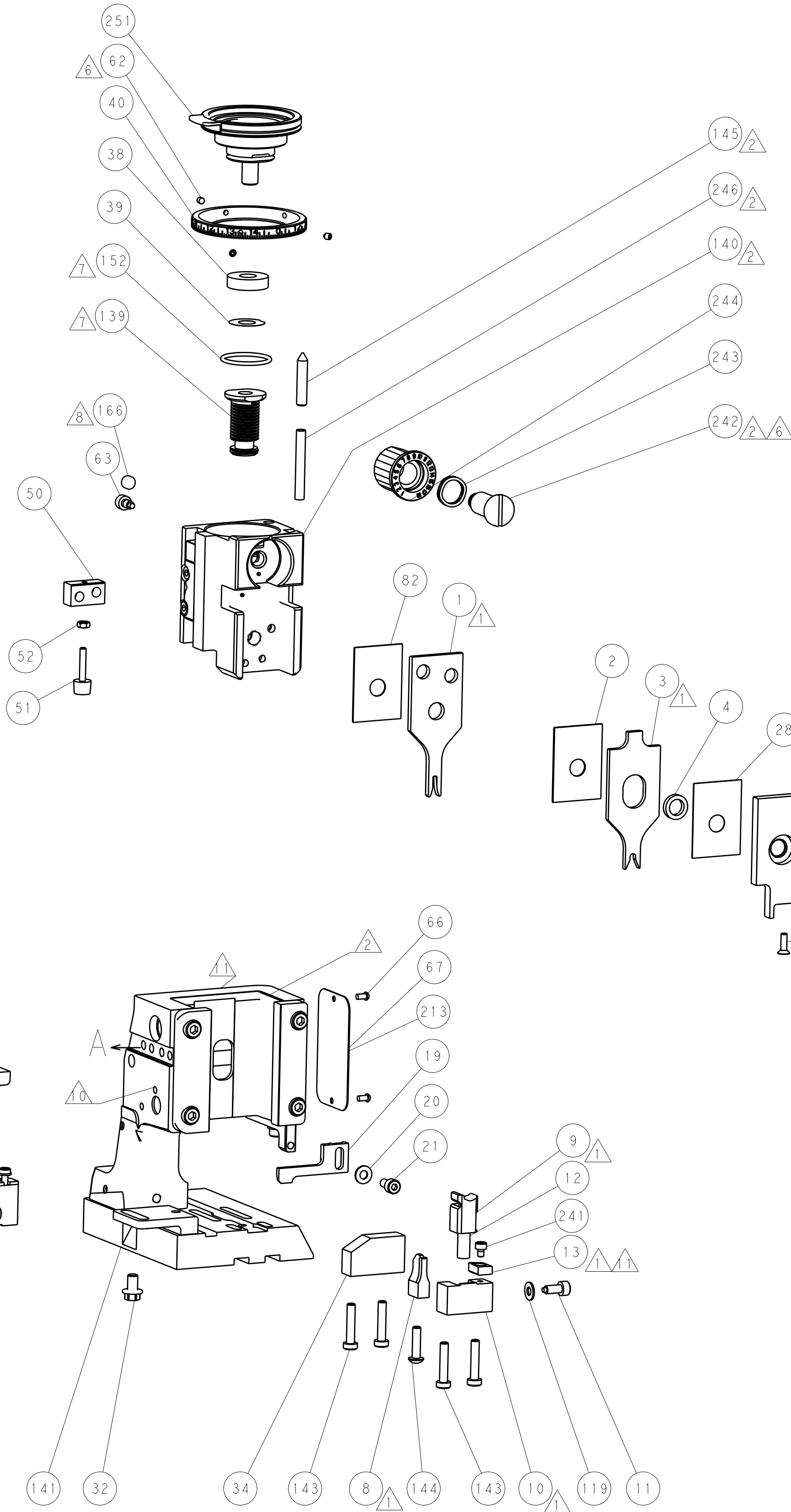
PNEUMATIC



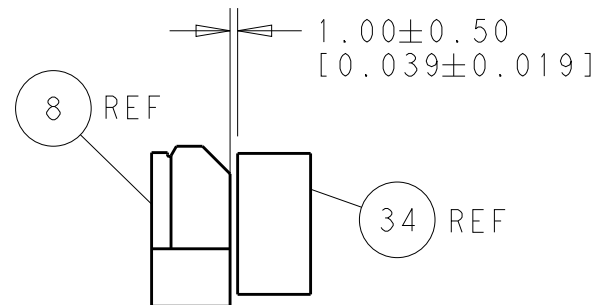
SERVO LATCH PLATE



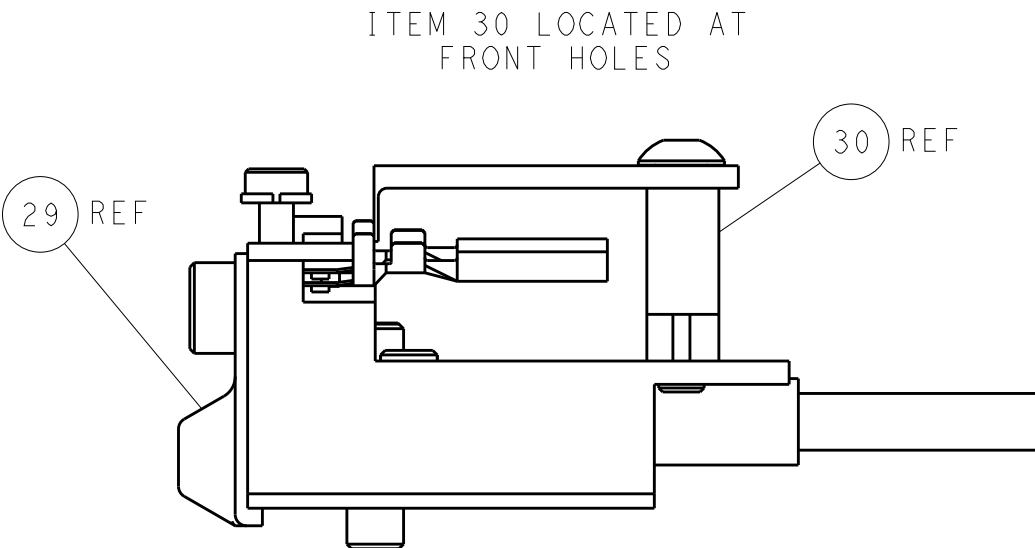
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		CKM		APVD		NAME	
mm		0 PLC ±0.5		K. HUANG		L. ZHANG		U. GUO		Ocean Side Feed Applicator	
1 PLC ±0.13		2 PLC ±0.13		3 PLC ±0.13		4 PLC ±0.001		5 PLC ±0.001		SIZE	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE		SHEET 4 OF 4	
										REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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