

8

7

6

5

4

3

2

1

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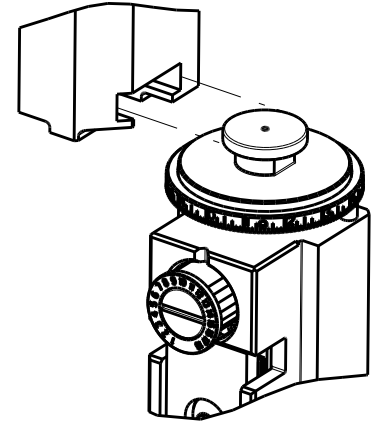
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20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2266145-2

REVISION

B

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

PNEUMATIC

PART
NUMBER

2266145-5

REVISION

B

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

SERVO
LATCH PLATE⁴

PART
NUMBER

2266145-6

REVISION

B

DESCRIPTION

NON-CRIMP HEIGHT ADJUST

FEED TYPE

SERVO
LATCH PLATE⁴¹¹

PART
NUMBER

2266145-7

REVISION

B

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

NONE

PART
NUMBER

7-2266145-7

REVISION

A

DESCRIPTION

CRIMP TOOLING KIT

FEED TYPE

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

4.57 mm [.180]

F

INSUL

6.85 mm [.270]

O

APPLICATOR INSTRUCTIONS

408-10389



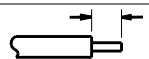
TERMINAL DATA: LEAR TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH

6.61-6.62 mm [.260-.261 IN]



INSULATION DIAMETER RANGE

Ø6.00-7.00 mm [.236-.276 IN]

TERMINAL APPLICATION SPECIFICATION

LEAR

-

-

-

-

-

TERMINALS APPLIED



TE TERMINAL

2113404-1

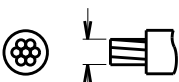
LEAR TERMINAL

28142.201.178

TE TERMINAL

LEAR TERMINAL

WIRE
SIZE



CRIMP HEIGHT
mm [INCH]



CRIMP HEIGHT
REFERENCE SETTING⁹

(3)1.0 + 1.5

2.95+/-0.05 [.116+/- .002]

5.7

(4)0.75 + 1.50

2.95+/-0.05 [.116+/- .002]

5.7

(6)0.75

2.95+/-0.05 [.116+/- .002]

5.7

(3)0.75 + 1.00 +1.50

3.00+/-0.05 [.118+/- .002]

6.5

(5)0.75 + 1.00

3.00+/-0.05 [.118+/- .002]

6.5

(2)1.0 + (2)1.50

3.05+/-0.05 [.120+/- .002]

7.0

(5)1.00

3.10+/-0.05 [.122+/- .002]

7.5

(2)0.75 + (2)1.00 + 1.50

3.10+/-0.05 [.122+/- .002]

7.5

(5)0.75 + 1.50

3.15+/-0.05 [.124+/- .002]

8.2

1.00 + (3)1.50

3.15+/-0.05 [.124+/- .002]

8.2

(4)1.00 + 1.50

3.15+/-0.05 [.124+/- .002]

8.2



-  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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266145-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266145-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266145-6
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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
-  MAGNET, ITEM 166 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.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
-  WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6)
USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.03.
-  TERMINAL LUBRICANT IS RECOMMENDED.

*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	1803078-2	SPACER, PRECISION	259
-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-77	-7	-6	-5	-2	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
			A	RELEASED		28FEB2014
			B	ECR-17-010970		27JUL2017

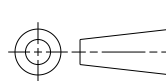
-	-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2161314-1	RAM, STEPPED, ATLANTIC, SF, NON-ADJ	245
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-2	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	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	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1-690438-0	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	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	2161311-1	RAM, STEPPED, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	1-2119644-3	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1320908-7	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	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	6-454276-5	FLOATING SHEAR, FRONT	9
1	1	1	1	1	2-1633930-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-3	DEPRESSOR, SHEAR	5
-	1	1	1	1	4-238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	4-1803019-2	CRIMPER, INSULATION O	3
-	1	1	1	1	1-455888-7	SPACER, CRIMPER	2
1	1	1	1	1	456412-7	CRIMPER, WIRE .180 F PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

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CHK
G. BAILEY

DATE
01NOV2013

DIMENSIONS:
mm



0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.013

4 PLC ±0.0001

ANGLES ±.5

FINISH

APVD
T. ELBIN

DATE
01NOV2013

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

Customer Accessible Production Drawing

NAME
Ocean Side Feed
Applicator

SIZE
A1

CAGE CODE
00779

DRAWING NO
©=2266145

RESTRICTED TO

SCALE
1:2

SHEET
1

OF
4

REV
B

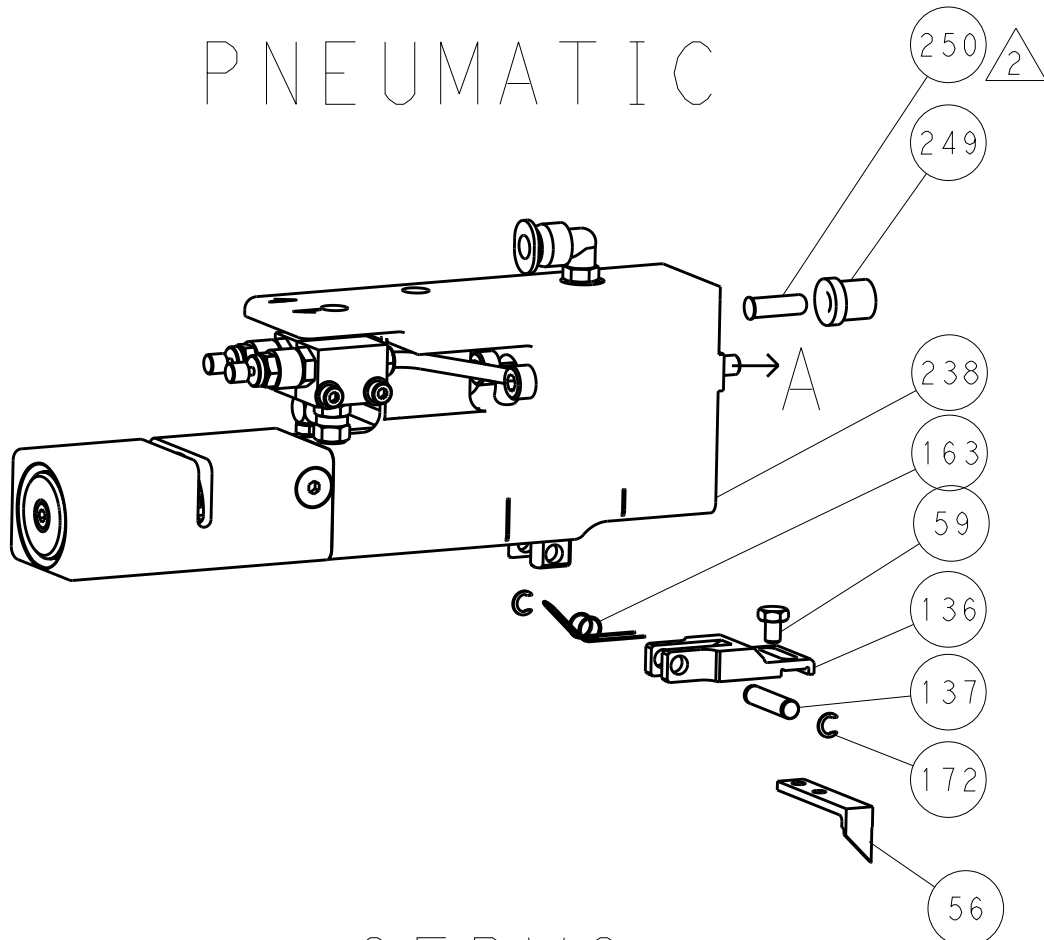
AMP 4805 REV 31MAR2000

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

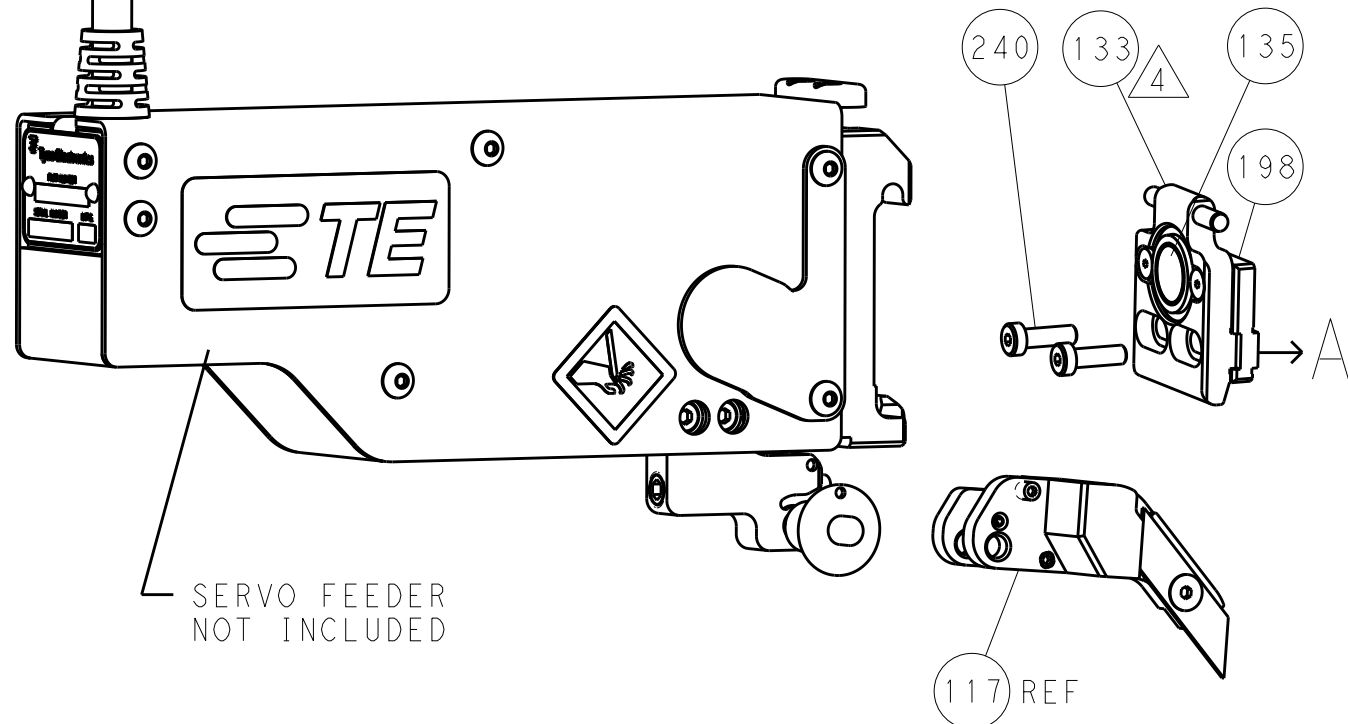
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

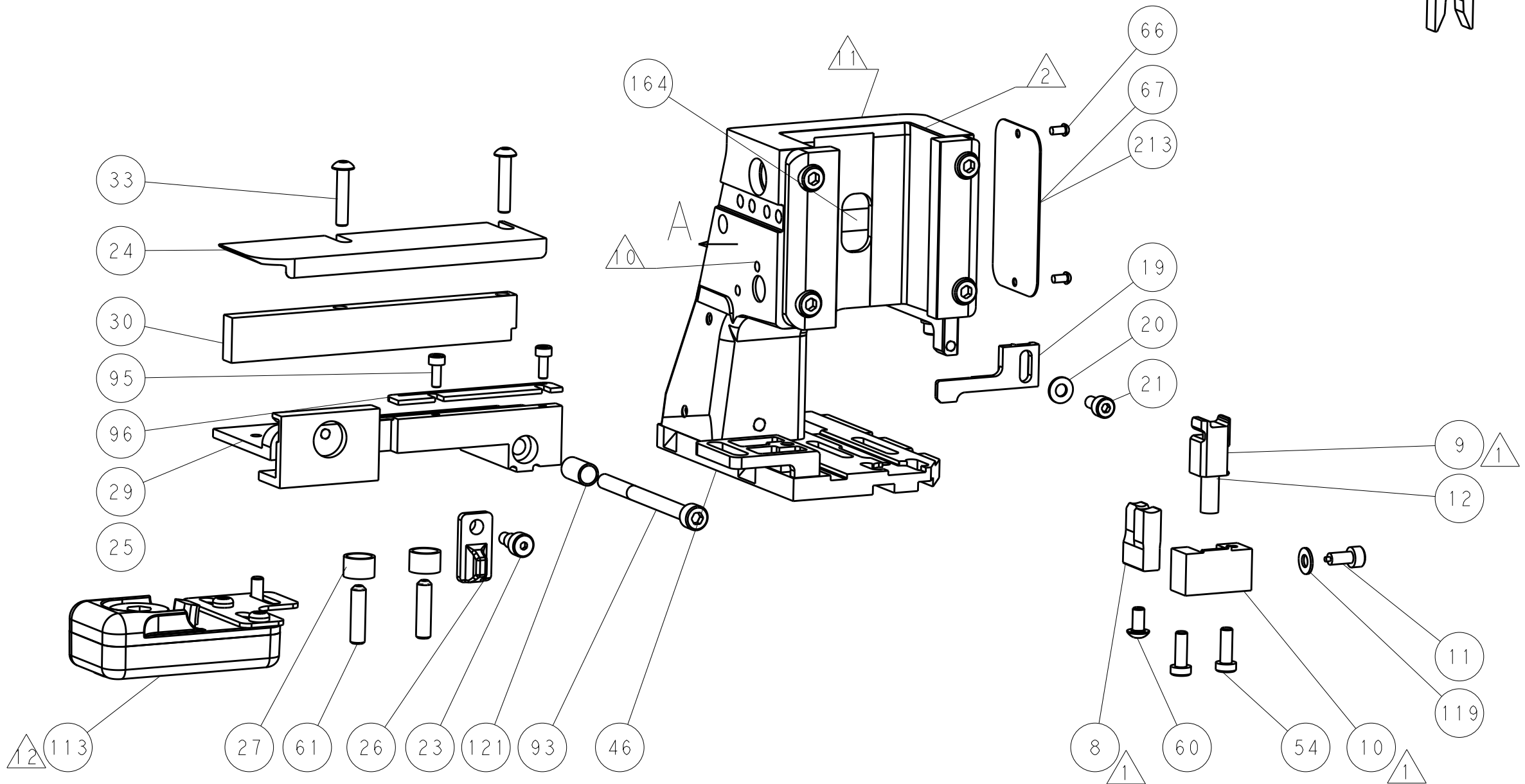
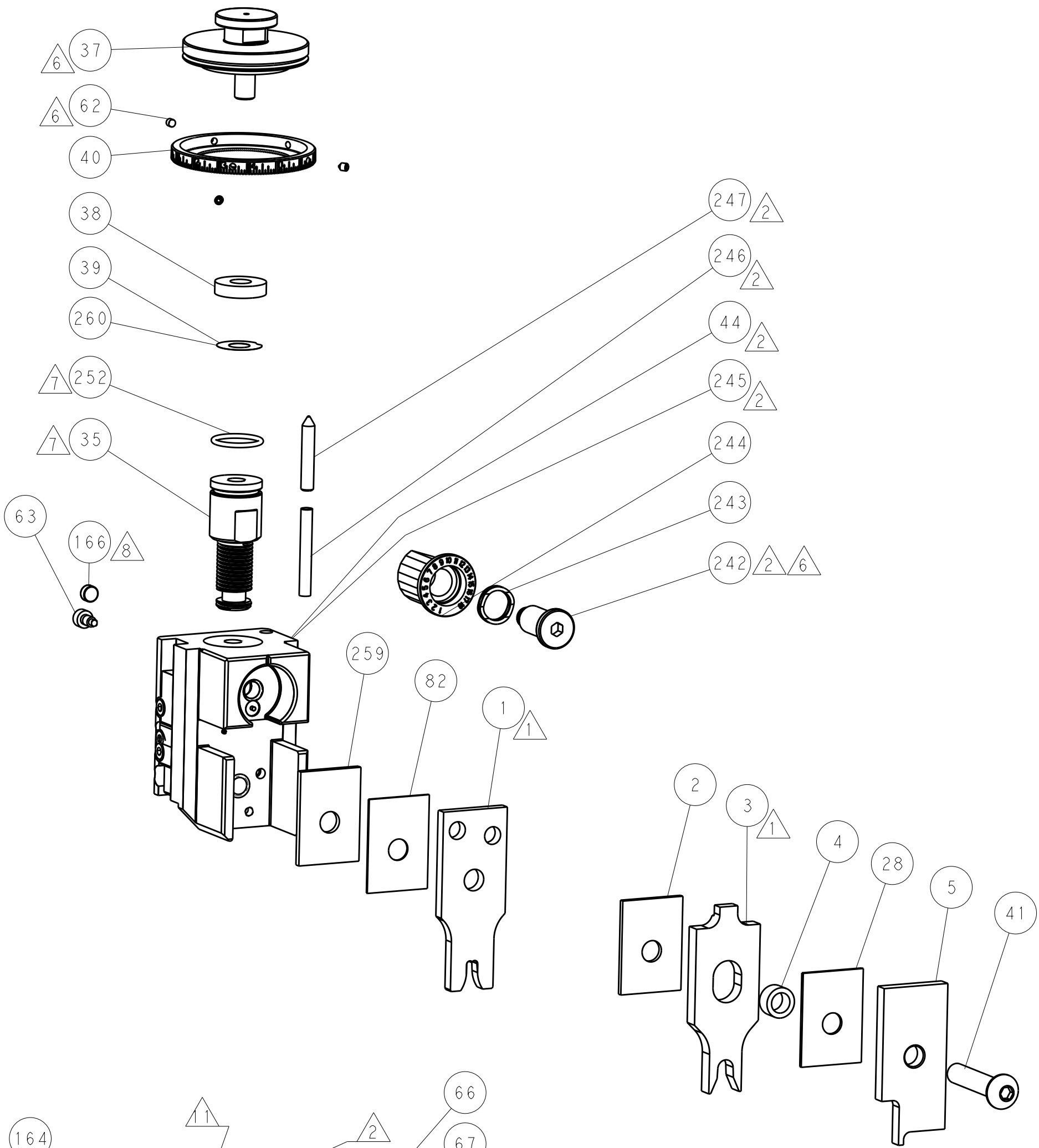
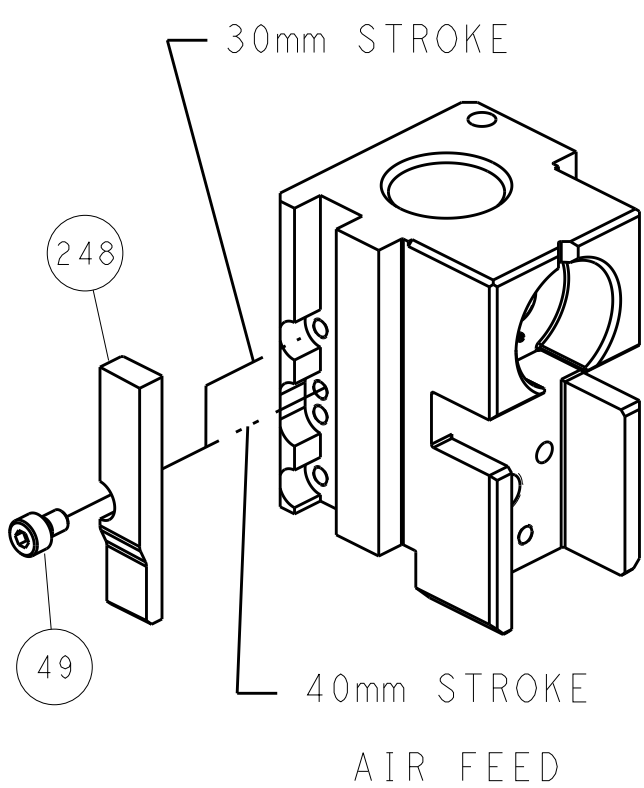
PNEUMATIC



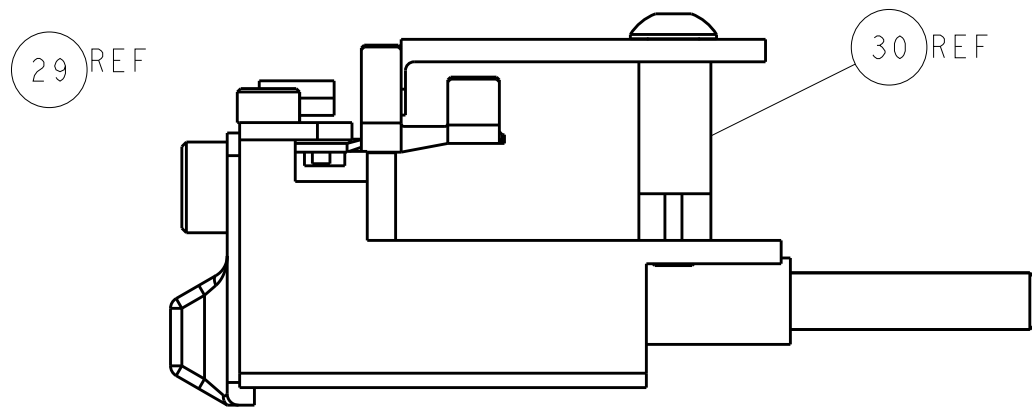
SERVO LATCH PLATE



CAM POSITION



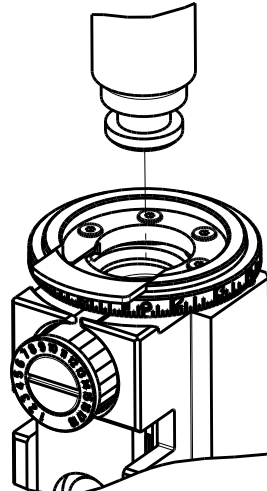
ITEM 30 LOCATED AT
FRONT HOLES



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)

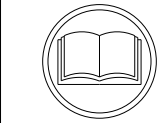
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. STANEM 01NOV2013		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001		CHK G. BAILEY 01NOV2013		NAME Ocean Side Feed Applicator	
FINISH		FINISH		APVD T. ELBIN 01NOV2013		SIZE 00779	
MATERIAL		MATERIAL		WEIGHT		CAGE CODE 2266145	
				Customer Accessible Production Drawing		RESTRICTED TO	
				SCALE 1:2		SHEET 2 of 4	
						REV B	

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2266145-2	B	FINE CRIMP HEIGHT ADJUST
	2-2266145-5	B	FINE CRIMP HEIGHT ADJUST
	2-2266145-7	B	FINE CRIMP HEIGHT ADJUST
	7-2266145-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	6.85 mm [.270]	O
APPLICATOR INSTRUCTIONS		
408-10389		

TERMINAL DATA: LEAR TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 6.61-6.62 mm [.260-.261 IN]			INSULATION DIAMETER RANGE Ø6.00-7.00 mm [.236-.276 IN]
TERMINAL APPLICATION SPECIFICATION	LEAR	-	-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113404-1	28142, 201, 178		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
(3)1.0 + 1.5		2.95+/-0.05 [.116+/- .002]		5.7
(4)0.75 + 1.50		2.95+/-0.05 [.116+/- .002]		5.7
(6)0.75		2.95+/-0.05 [.116+/- .002]		5.7
(3)0.75 + 1.00 +1.50		3.00+/-0.05 [.118+/- .002]		6.5
(5)0.75 + 1.00		3.00+/-0.05 [.118+/- .002]		6.5
(2)1.0 + (2)1.50		3.05+/-0.05 [.120+/- .002]		7.0
(5)1.00		3.10+/-0.05 [.122+/- .002]		7.5
(2)0.75 + (2)1.00 + 1.50		3.10+/-0.05 [.122+/- .002]		7.5
(5)0.75 + 1.50		3.15+/-0.05 [.124+/- .002]		8.2
1.00 + (3)1.50		3.15+/-0.05 [.124+/- .002]		8.2
(4)1.00 + 1.50		3.15+/-0.05 [.124+/- .002]		8.2



- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266145-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266145-5
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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- 8 MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 11 TERMINAL LUBRICANT IS RECOMMENDED.

-	1	1	1	1803078-2	SPACER, PRECISION	259
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-77	-27	-25	-22	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 2119599-1	LOC A	DIST 66	REVISIONS				
			P	LTR	DESCRIPTION	DATE	OWN
				-	SEE SHEET 1	-	-

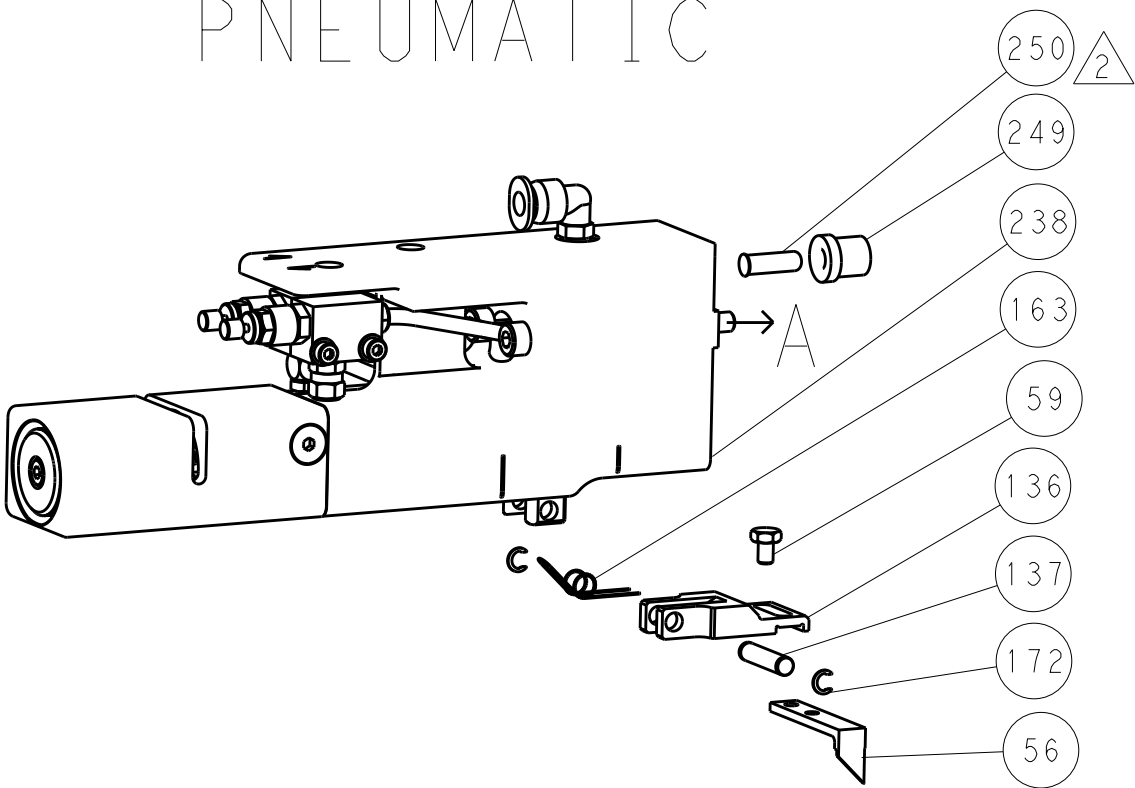
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	2063440-2	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
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	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
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2161312-1	RAM, STEPPED, 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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	455888-6	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
-	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC		SIZE CASE CODE DRAWING NO	
MATERIAL		APPLICATION SPEC		RESTRICTED TO	
-		WEIGHT		A1 00779 ©=2266145	
-		Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV B	

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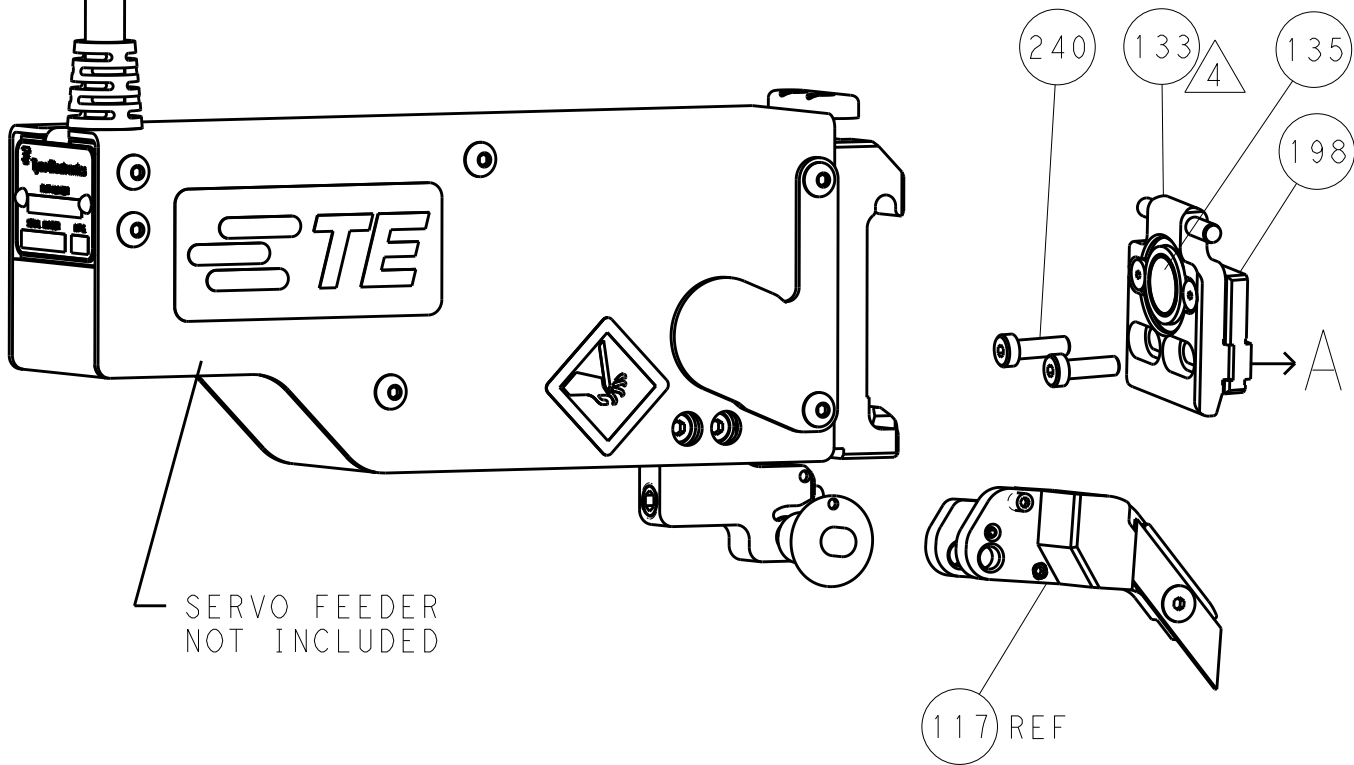
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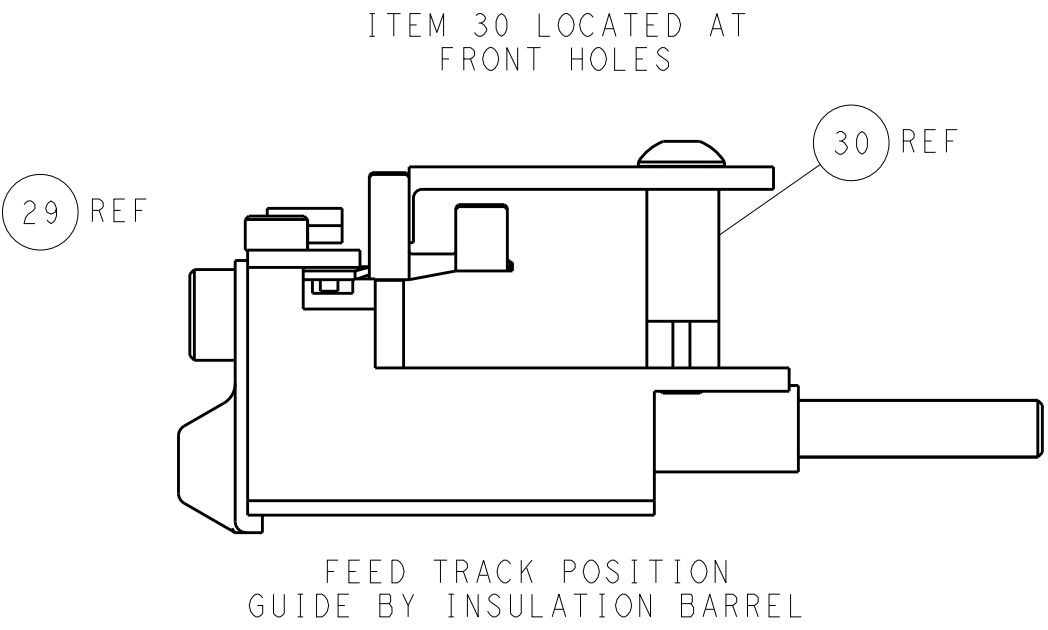
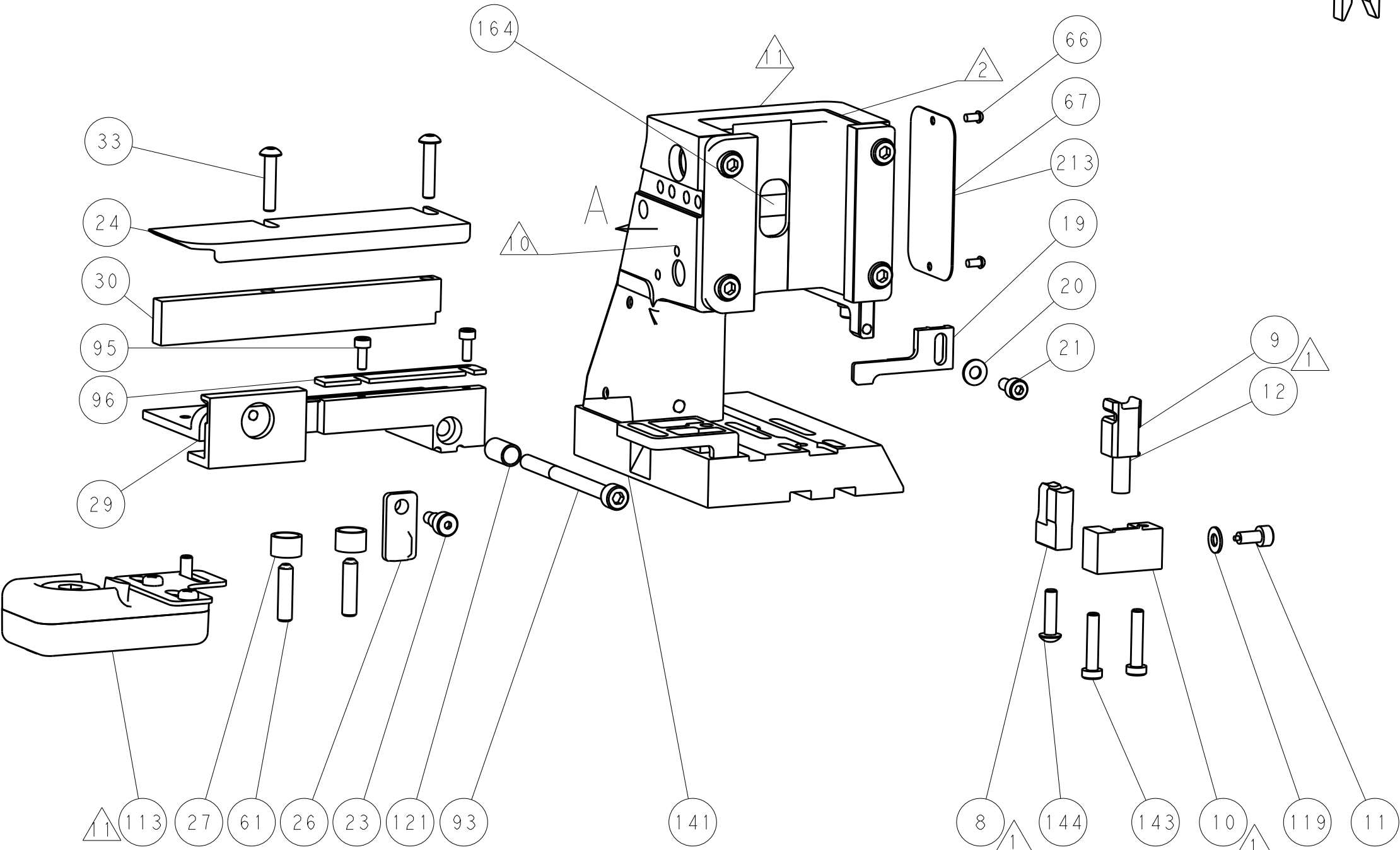
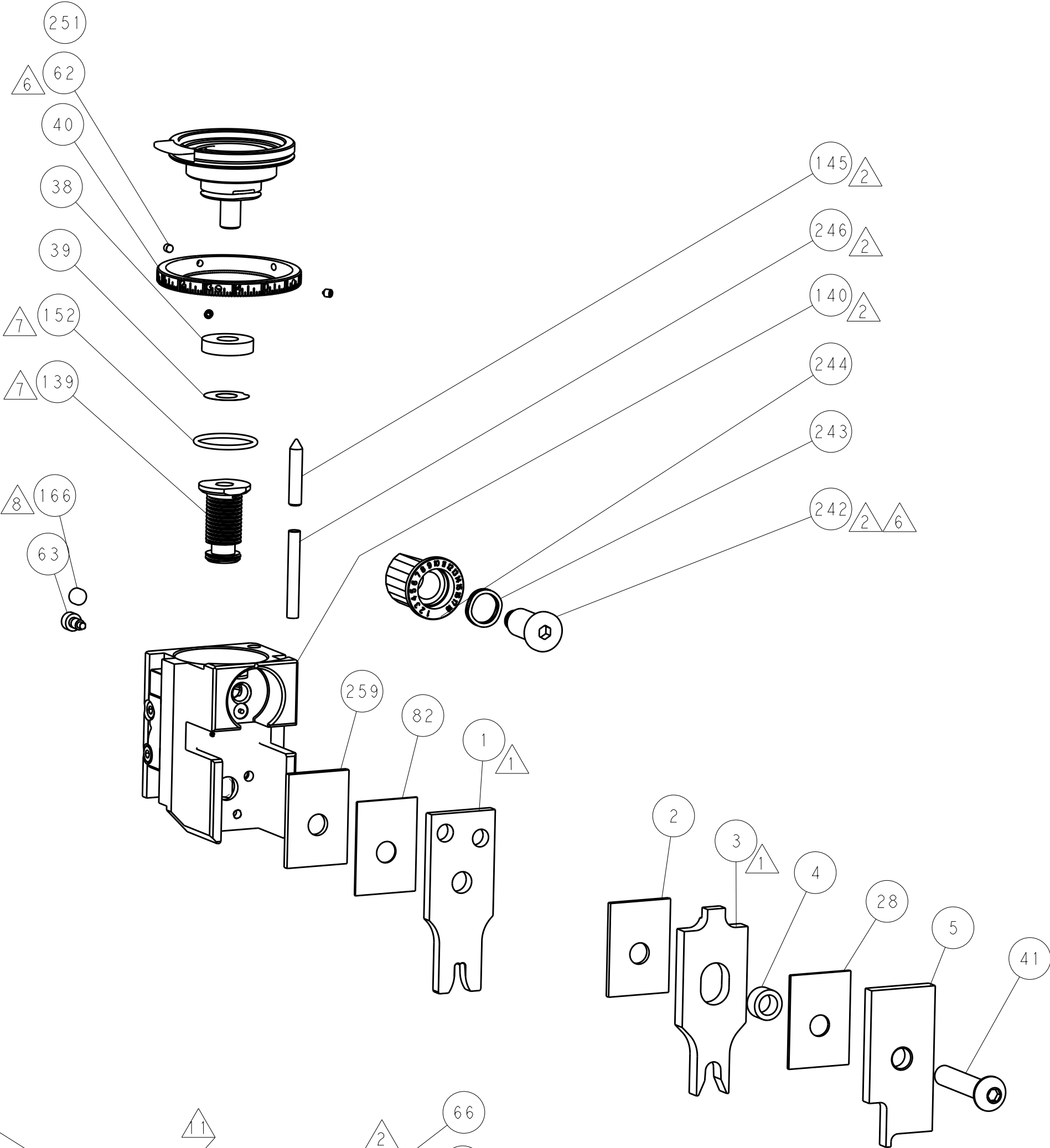
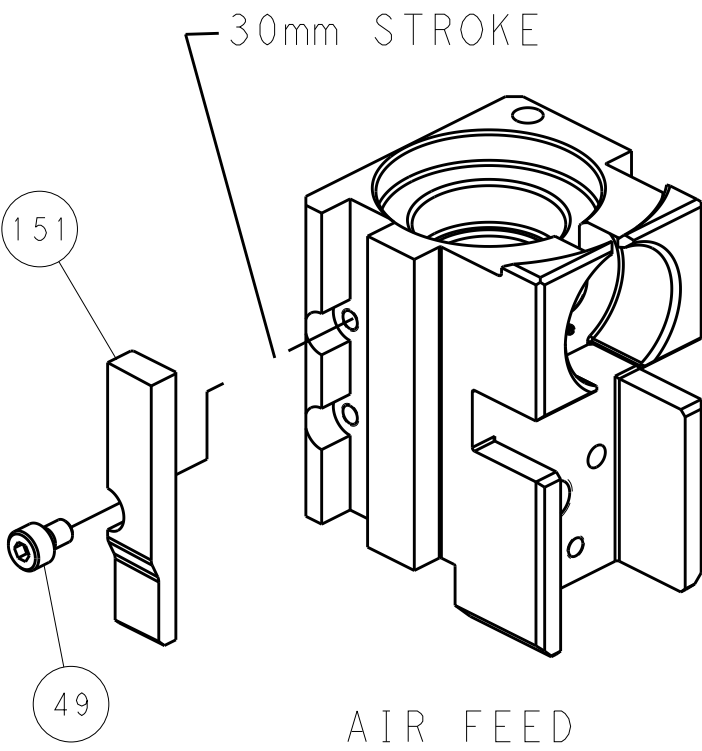


SERVO

LATCH PLATE



CAM POSITION



PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH		PRODUCT SPEC: APPLICATION SPEC:
MATERIAL:		WEIGHT:		RESTRICTED TO:
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