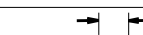


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2266197-1	A	FINE CRIMP HEIGHT ADJUST
	2266197-2	A	FINE CRIMP HEIGHT ADJUST
	2266197-5	A	FINE CRIMP HEIGHT ADJUST
	2266197-6	A	NON-CRIMP HEIGHT ADJUST
	2266197-7	A	FINE CRIMP HEIGHT ADJUST
	7-2266197-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	2.03 mm [.080]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: STOCKO TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 2.57-2.59 mm [.101-.102 IN]		 INSULATION DIAMETER RANGE Ø 1.65 mm MAX[.065 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	STOCKO TERMINAL	TE TERMINAL	STOCKO TERMINAL
2113420-1	RBB8230.020		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.83+/-0.05 [.033+/- .002]	8
22 AWG	0.73+/-0.05 [.029+/- .002]	9.2
24 AWG	0.66+/-0.05 [.026+/- .002]	9.9

- 

RECOMMENDED SPARE PARTS
- 

GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266197-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266197-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266197-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266197-6
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, 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37,180 & 242.
- 

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.
- 

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

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 

WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.97.

*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	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
-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)

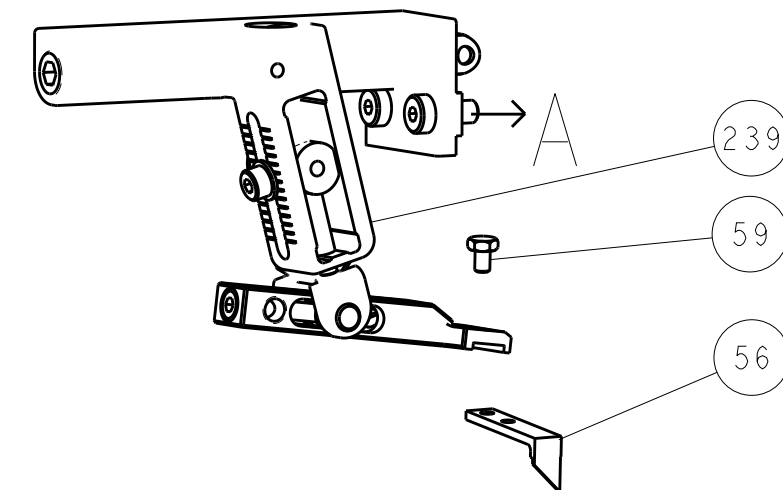
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				I	DEVELOPMENT	16JAN2014
				A	RELEASED	07FEB2014

-	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
-	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
-	1	1	1	1	1	1-1752354-5	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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
-	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
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	-	-	-	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	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	4-1803054-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	5-2119582-9	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	2
-	1	1	1	1	1	2-568176-5	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

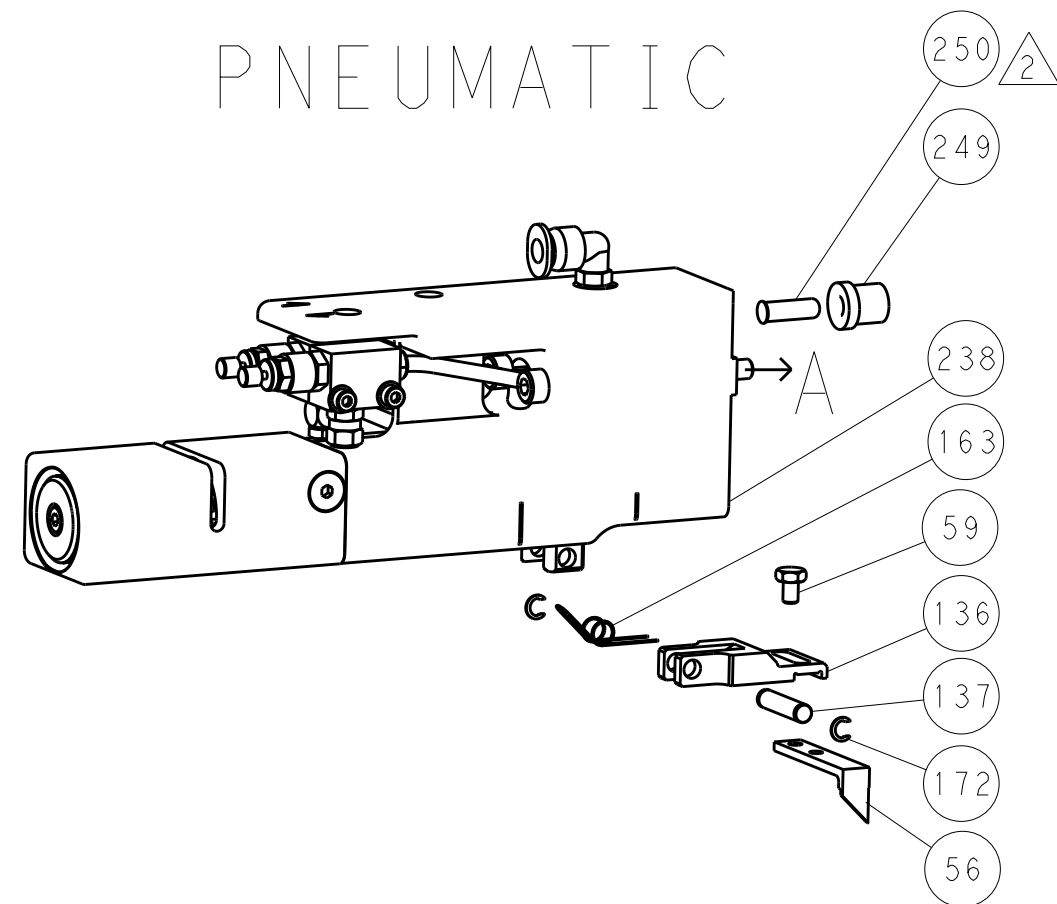
THIS IS SUBJECT TO CHANGE AND TO BE USED FOR THE LATEST REVISIONS. ANY CHANGES TO THIS DRAWING MUST BE CONTACTED FOR THE LATEST REVISION.		DWN Y. YIN 16JAN2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK G. BAILEY 16JAN2014	NAME Ocean Side Feed Applicator	
mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD H. GUO 16JAN2014	PRODUCT SPEC	
			APPLICATION SPEC	
MATERIAL	FINISH		SIZE A1	CAGE CODE 00779
-	-		DRAWING NO C=2266197	RESTRICTED TO -
Customer Accessible Production Drawing			SCALE 1:2	SHEET 1 OF 4
			REV A	

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

FEED TYPE
MECHANICAL



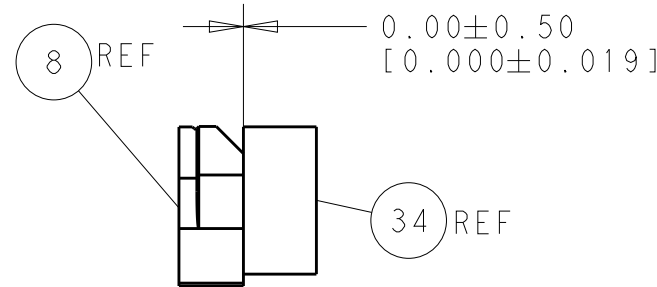
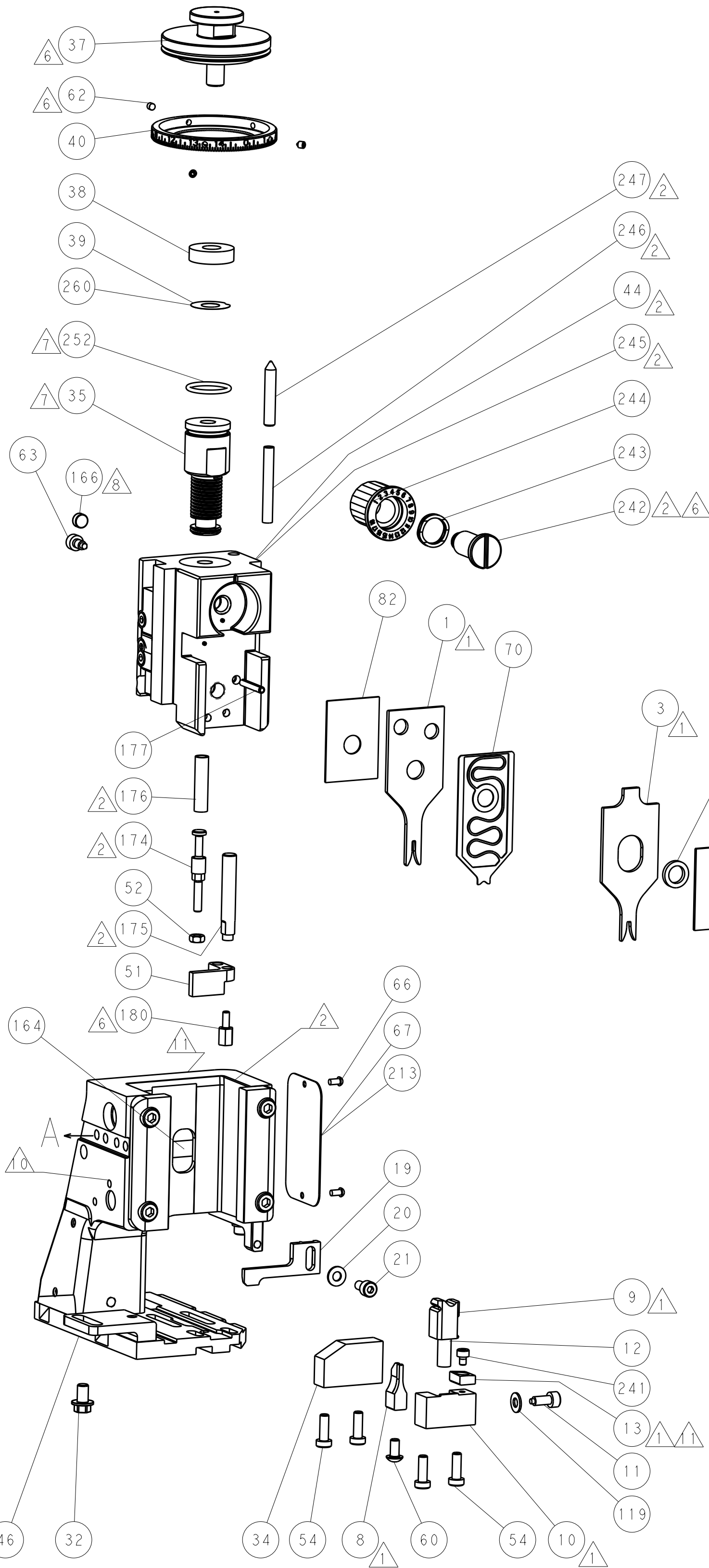
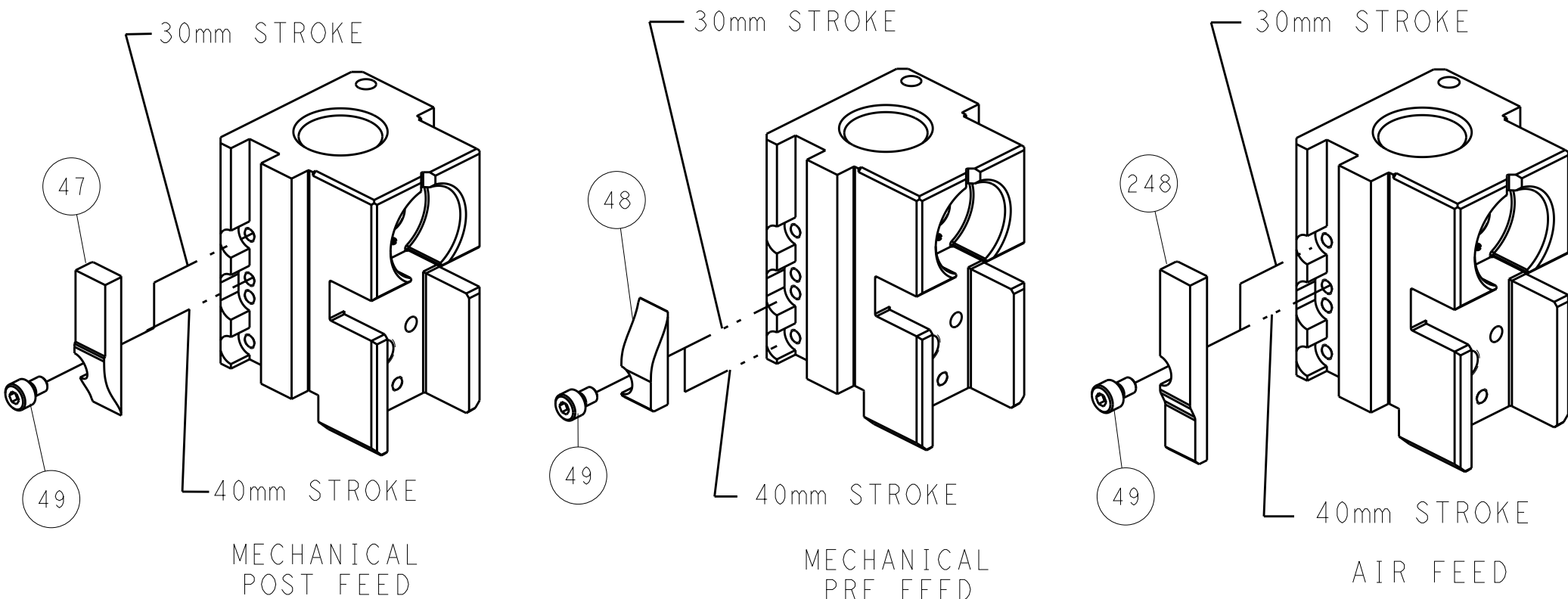
PNEUMATIC



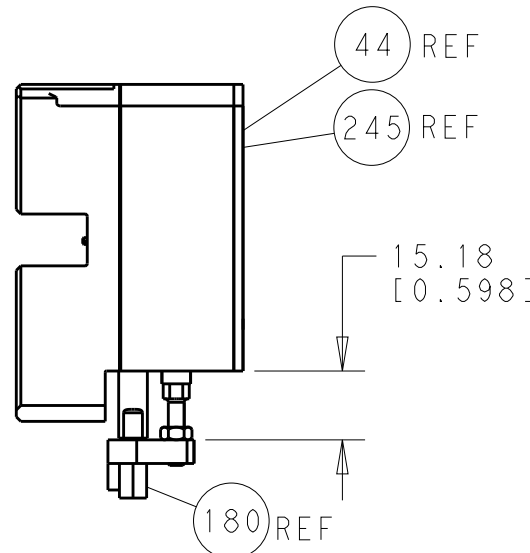
SERVO
LATCH PLATE



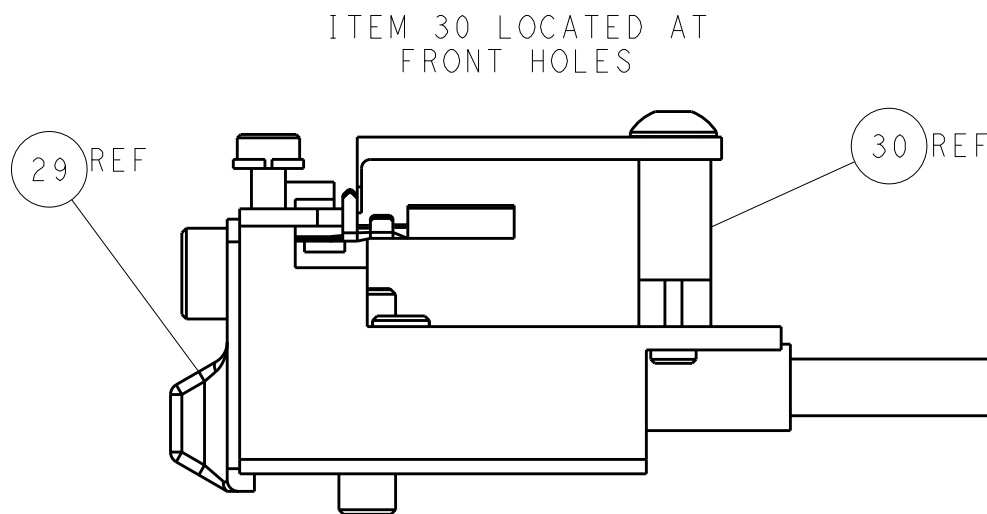
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 16JAN2014		CHK G. BAILEY 16JAN2014		APVD J. GUO 16JAN2014		NAME Ocean Side Feed Applicator	
0 PLC ±.5		1 PLC ±0.13		2 PLC ±0.13		3 PLC ±0.13		4 PLC ±0.0001		SIZE A1	
MATERIAL -		FINISH -		WEIGHT -		Customer Accessible Production Drawing		SCALE 1:2		SHEET 2 of 4	
										REV A	

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266197-1	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	-	8-2266197-5	1901094-3	2-1752354-0	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266197-4	-	-	-
	2-2266197-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266197-5	1901094-3	2-1752354-0	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266197-4	-	-	-
	2-2266197-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 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
	2-2266197-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2266197-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	2.03 mm [.080]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: STOCKO TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 2.57-2.59 mm [.101-.102 IN]		INSULATION DIAMETER RANGE Ø 1.65 mm MAX [.065 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED	-	-	-
TE TERMINAL	STOCKO TERMINAL	TE TERMINAL	STOCKO TERMINAL
2113420-1	RBB8230.020		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
20 AWG		0.83+/-0.05 [.033+/- .002]		8
22 AWG		0.73+/-0.05 [.029+/- .002]		9.2
24 AWG		0.66+/-0.05 [.026+/- .002]		9.9



- 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: 8-2266197-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266197-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266197-5
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, 180 & 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.

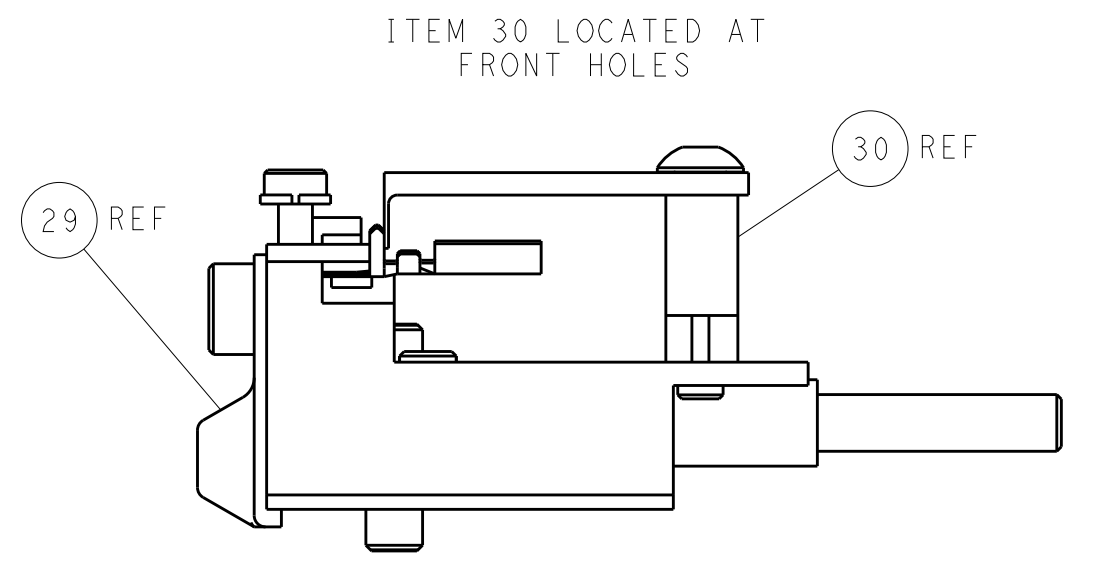
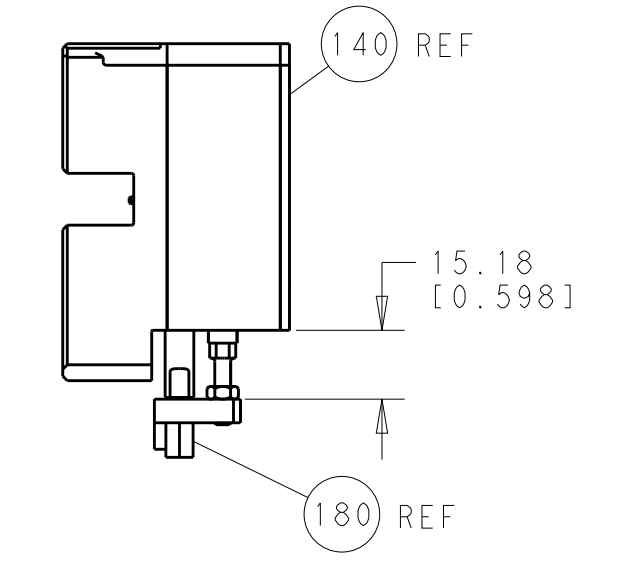
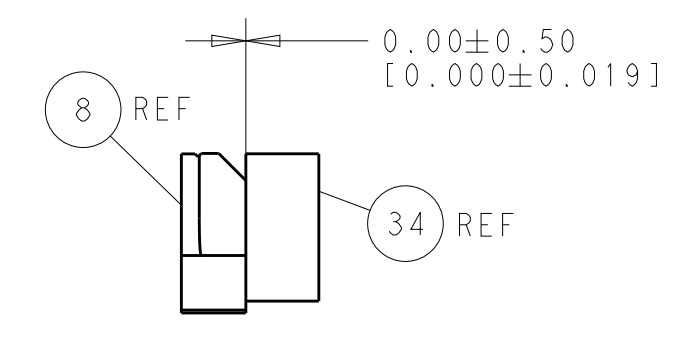
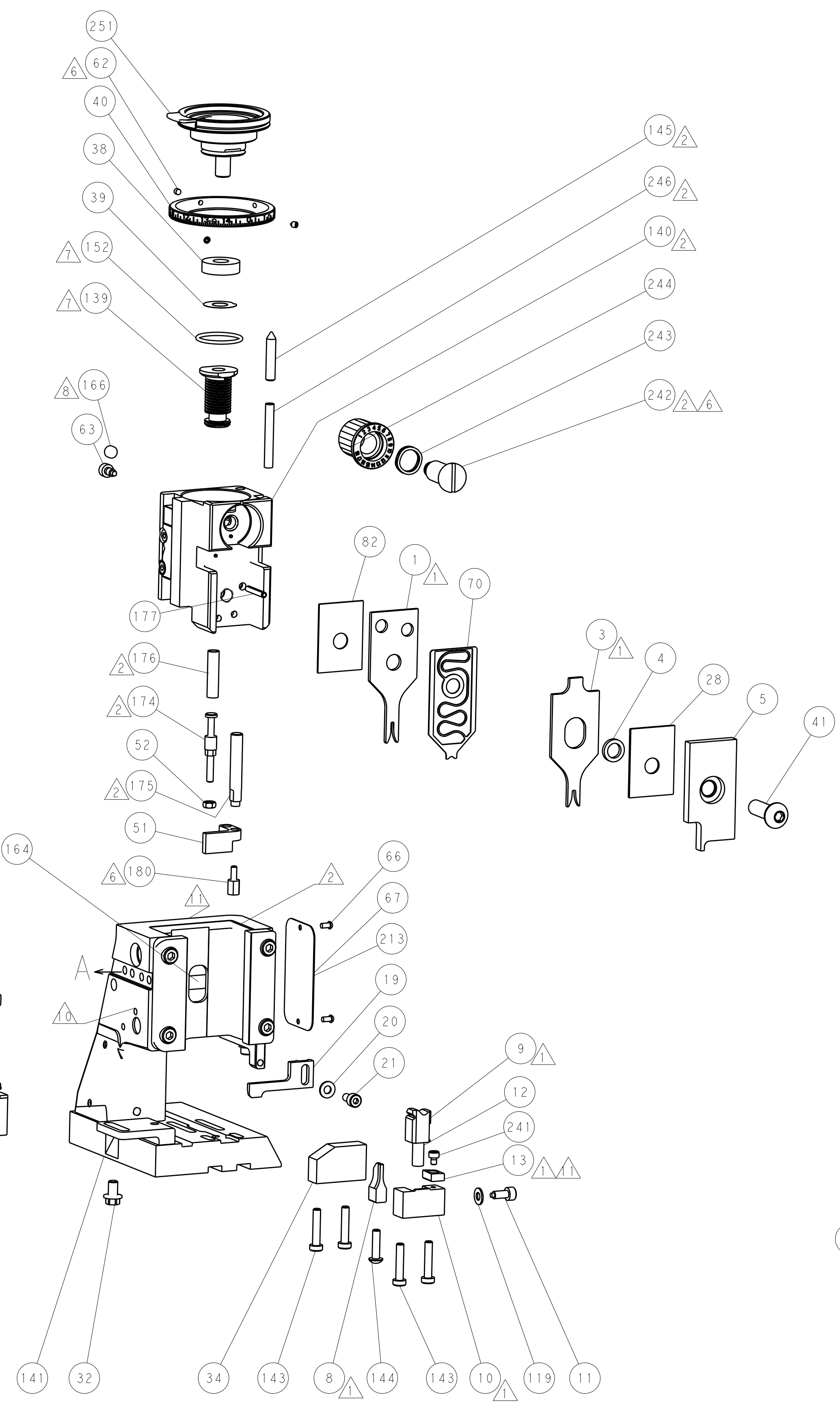
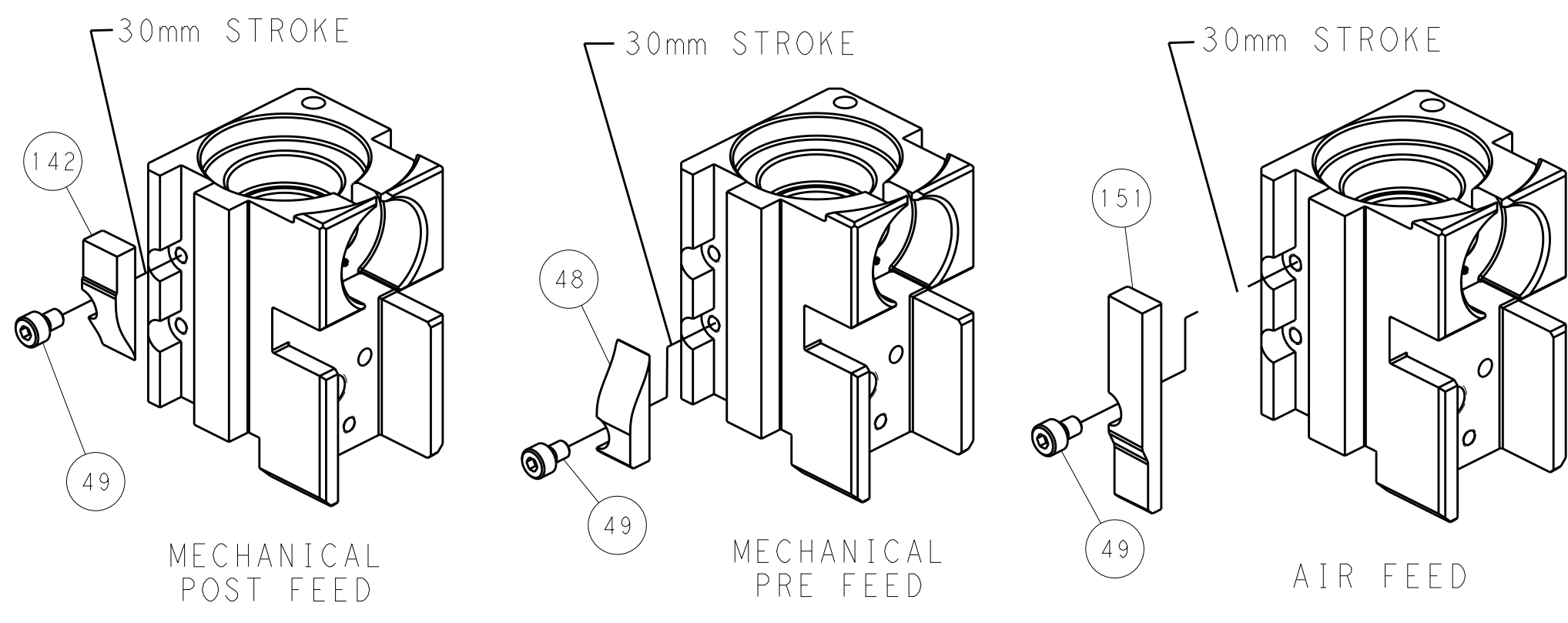
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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 2119599-1	LOC A	DIS 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	-	1	2063440-1	AIR FEED MODULE	238
	-	-	1	-	-	2119740-2	TAG,IDENTIFICATION	213
6	-	-	1	-	-	1901094-3	SPACER, FEEDER	198
	-	1	1	1	1	1-1752354-5	STANDOFF,HOLD-DOWN	180
	-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	-	-	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	1-18028-2	WASHER, FLAT, REG M4	119
	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
	-	1	1	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	-	1	1	2119740-1	TAG,IDENTIFICATION	67
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		0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.5		APPLICATION SPEC		SIZE A1	
MATERIAL -		FINISH -		WEIGHT -		CAGE CODE 00779	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 3		REV A	



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