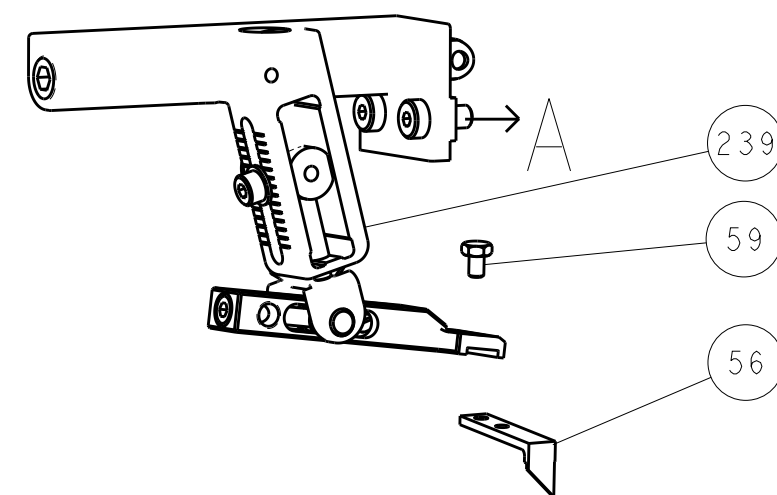
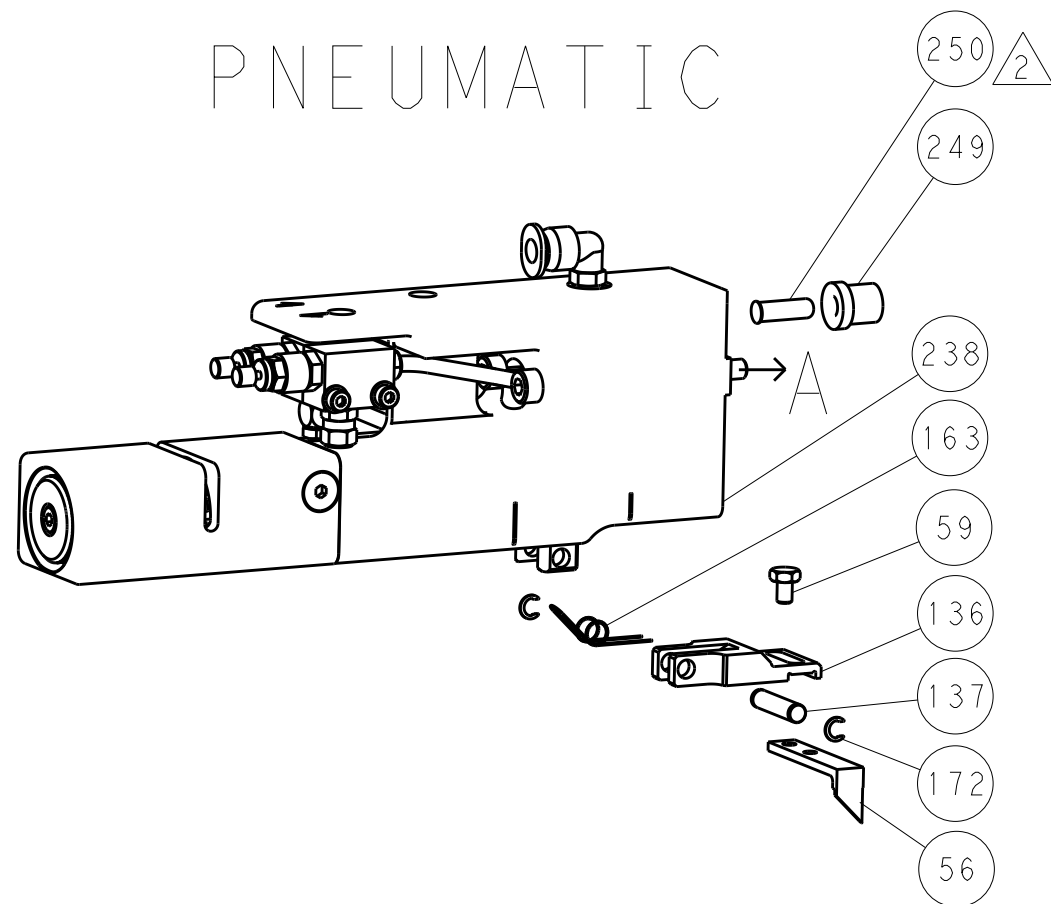


LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL



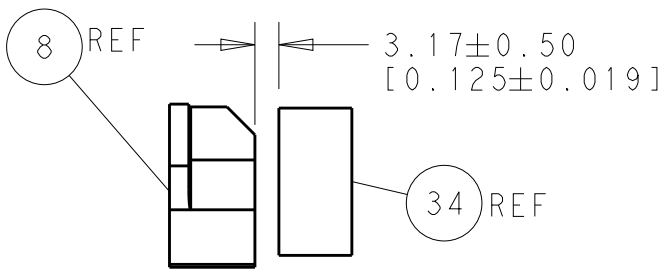
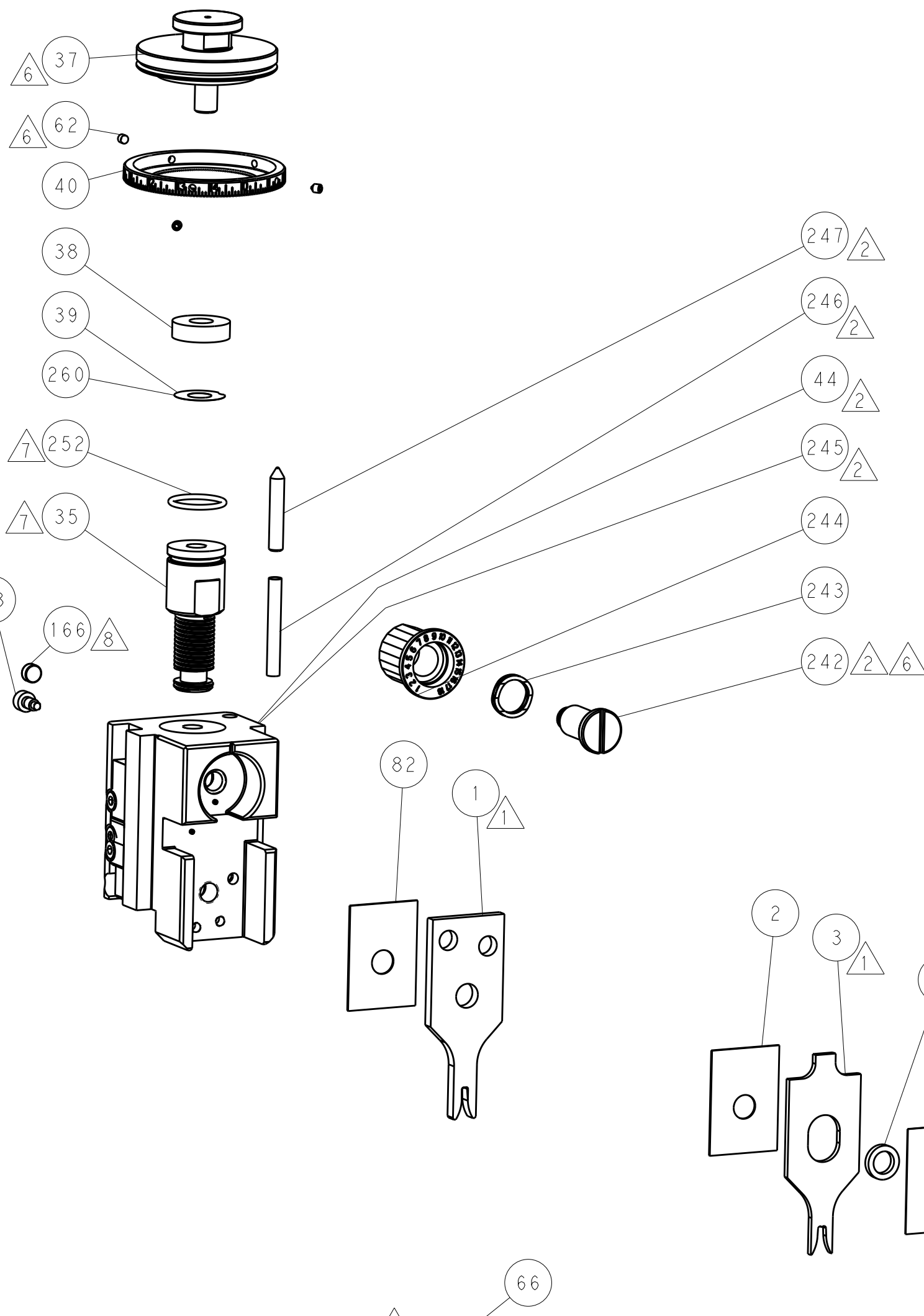
PNEUMATIC



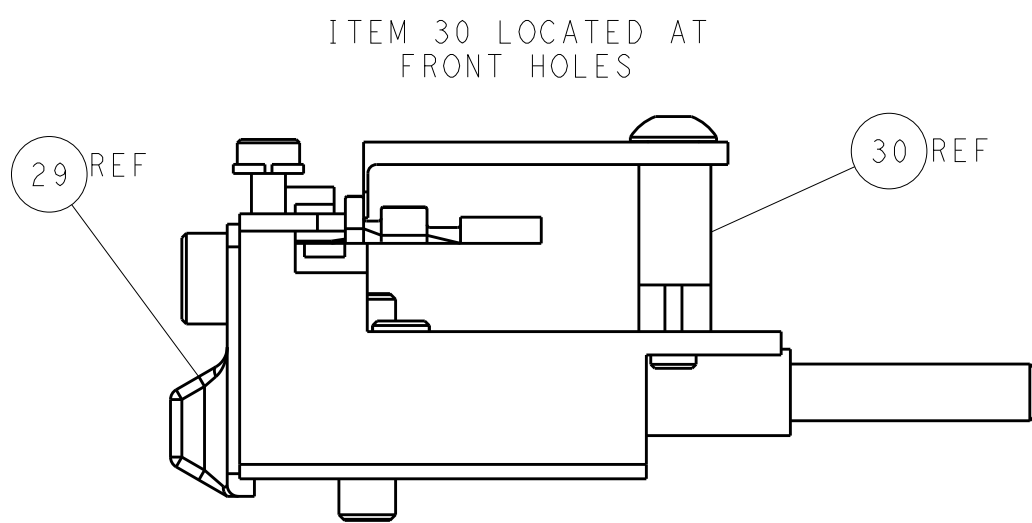
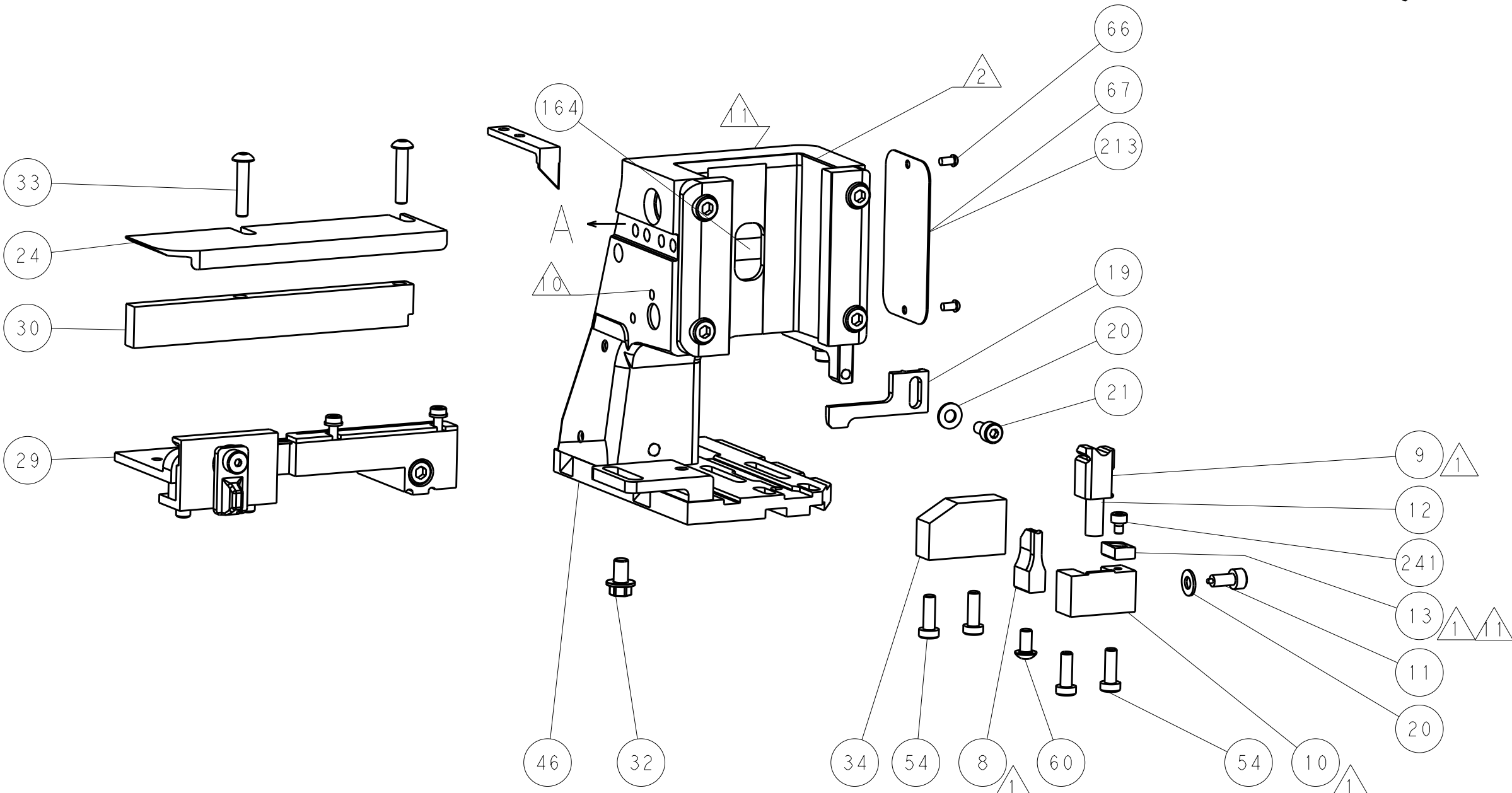
SERVO LATCH PLATE



CAM POSITIONS



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		30JUN2014		TE Connectivity	
mm		0 PLC ±.5		CHK		30JUN2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APVD		30JUN2014		NAME	
H		2 PLC ±0.13		D. STOUGH		30JUN2014		Ocean Side Feed	
MATERIAL		4 PLC ±0.001		PRODUCT SPEC		APPLICATION SPEC		SIZE	
FINISH		ANGLES		WEIGHT		A1 00779		CAGE CODE	
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					
	2-2266318-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266318-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266318-4	-	-	-
	2-2266318-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266318-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266318-4	-	-	-
	2-2266318-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2266318-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266318-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.17 mm [.125]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: KET TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 2.3mm SLIP-ON RECEPTACLE			
WIRE STRIP LENGTH 4.34-5.11 mm [.171-.201 IN]		INSULATION DIAMETER RANGE Ø1.60-3.00 mm [.063-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
2113470-1	ST730366-3	2286482-1	PSR102PT

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
16 AWG OR 1.25mm2	1.30+/-0.05 [.051+/-0.002]	6.2
1.00mm2	1.20+/-0.05 [.047+/-0.002]	7.1
18 AWG OR 0.85mm2	1.14+/-0.05 [.045+/-0.002]	7.8
0.75mm2	1.10+/-0.05 [.043+/-0.002]	8.3



- 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: 8-2266318-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266318-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266318-5
- 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 ITEM 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

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11

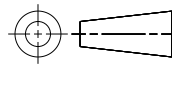
TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

*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.

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

-	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	2119082-3	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
-	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
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	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
-	-	-	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	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	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	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1-1803058-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1-2119582-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	1	1	2-456405-7	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. NO OTHER ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				OWN BOB HIGMAN 30JUN2014	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm				CHK G.BAILEY 30JUN2014	NAME Ocean Side Feed Applicator		
				APVD D. STOUGH 30JUN2014	PRODUCT SPEC		
					APPLICATION SPEC		
MATERIAL -					WEIGHT -		
					FINISH -		
					Customer Accessible Production Drawing		
					SCALE 1:2		
					SHEET 3 of 4		
					REV A		

A detailed line drawing of a microscope. The main body is labeled with a circled '1'. The eyepiece is labeled with a circled '2'. The objective lenses are labeled with a circled '3'. The stage is labeled with a circled '4'. The base is labeled with a circled '5'. The slide holder is labeled with a circled '6'.

PNEUMATIC

250 1

249 1

238 1

163 1

59 1

136 1

137 1

172 1

56 1

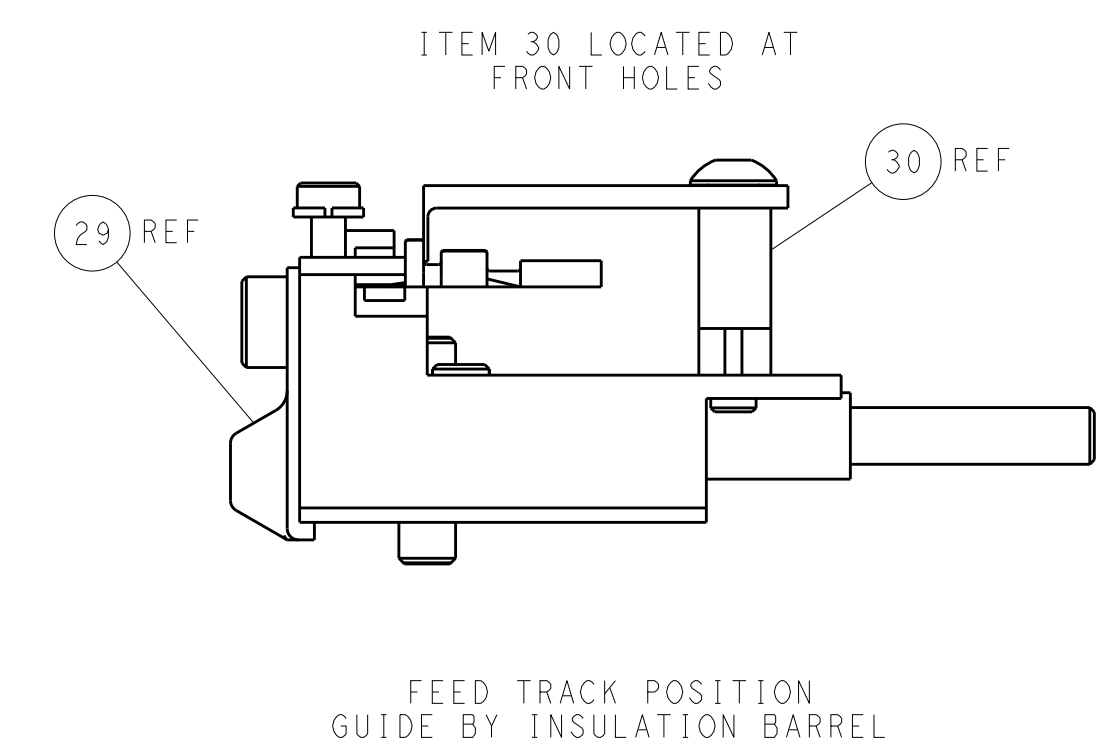
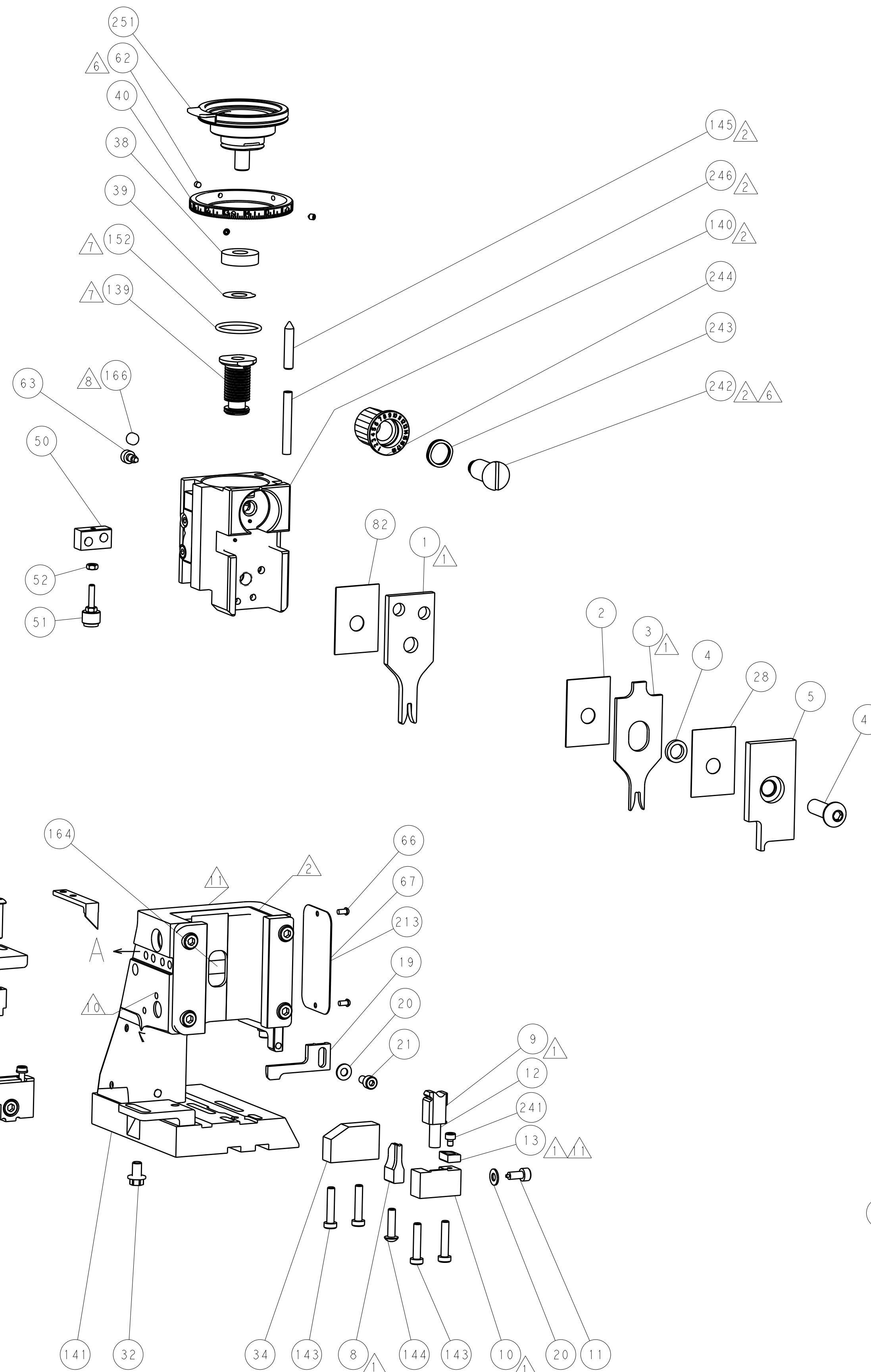
C 1

A

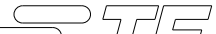
SERVO FEEDER
NOT INCLUDED

The diagrams illustrate three types of mechanical feed systems:

- MECHANICAL POST FEED:** Shows a 30mm STROKE and a 49mm distance from the tool tip to the feed mechanism.
- MECHANICAL PRE FEED:** Shows a 30mm STROKE and a 49mm distance from the tool tip to the feed mechanism.
- AIR FEED:** Shows a 30mm STROKE and a 49mm distance from the tool tip to the feed mechanism.



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

THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLS AND ENGINEERING ORGANIZATION SHOULD BE NOTIFIED FOR THE LATEST REVISION		DWN BOB HIGMAN 30JUN2014 CKM G. BAILEY 30JUN2014 APVU D. STOUGH 30JUN2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A 1	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C=2266318		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET A OF A REV A	

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