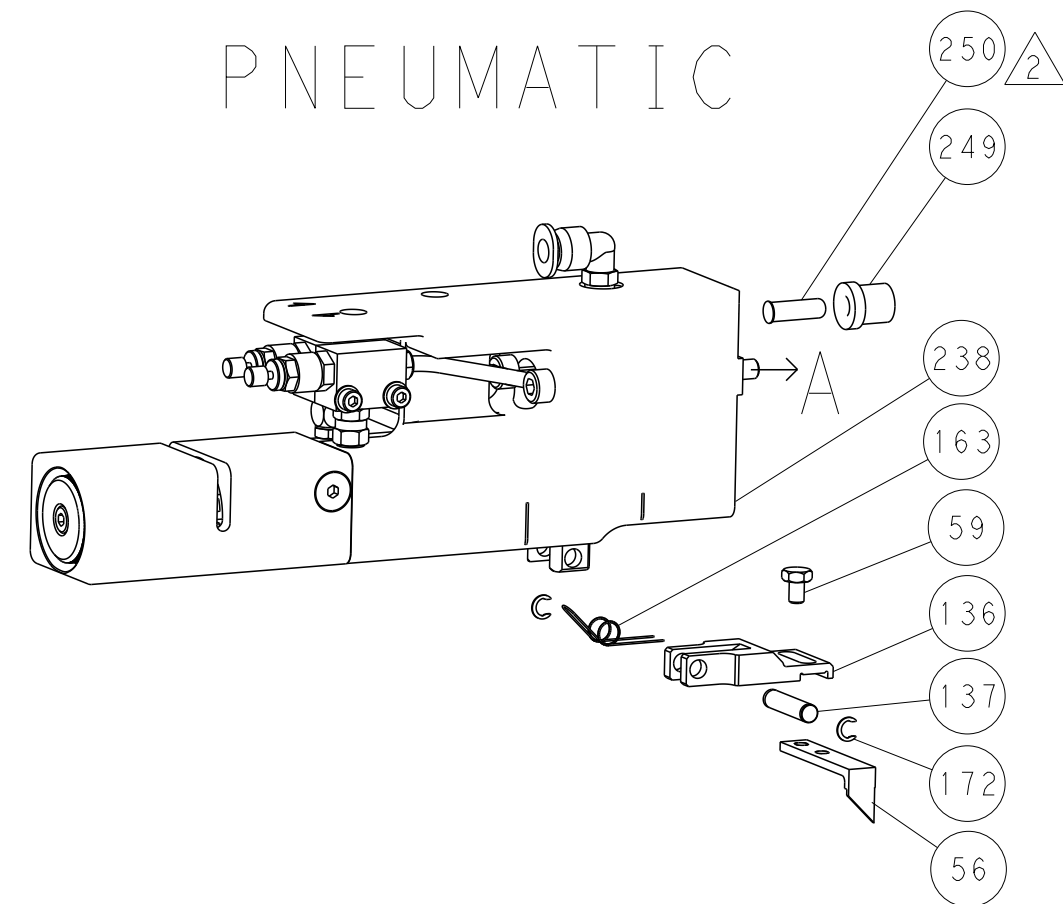
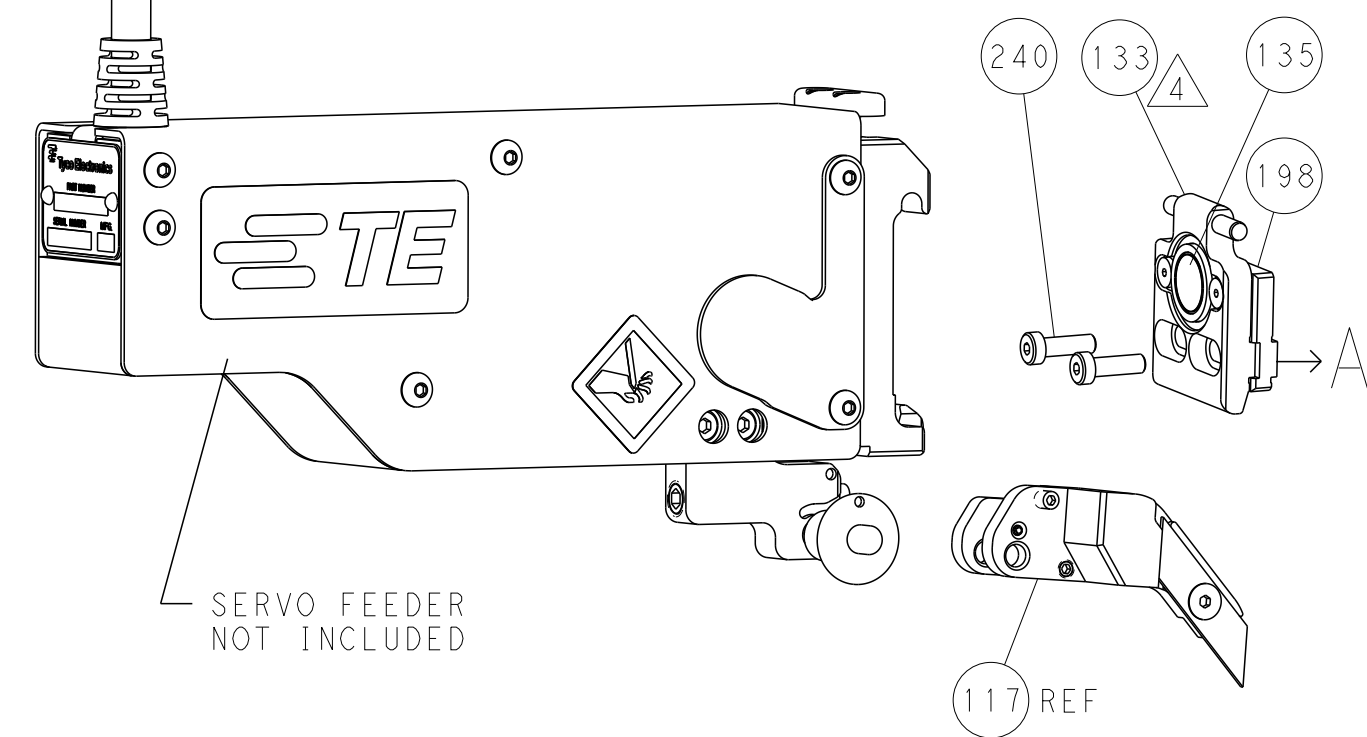
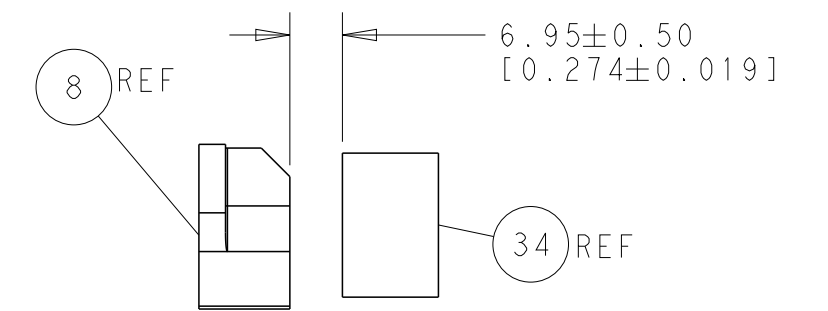
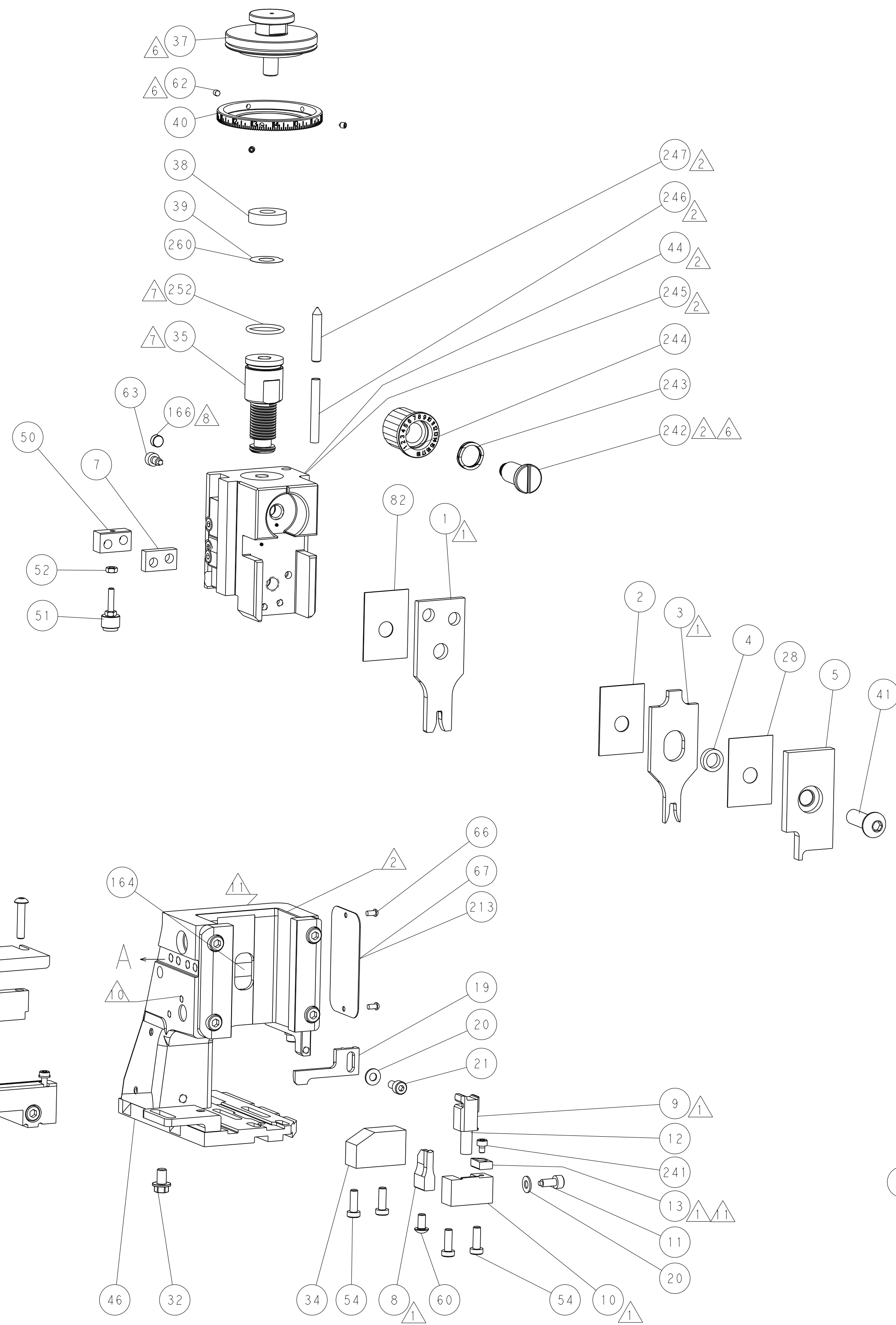




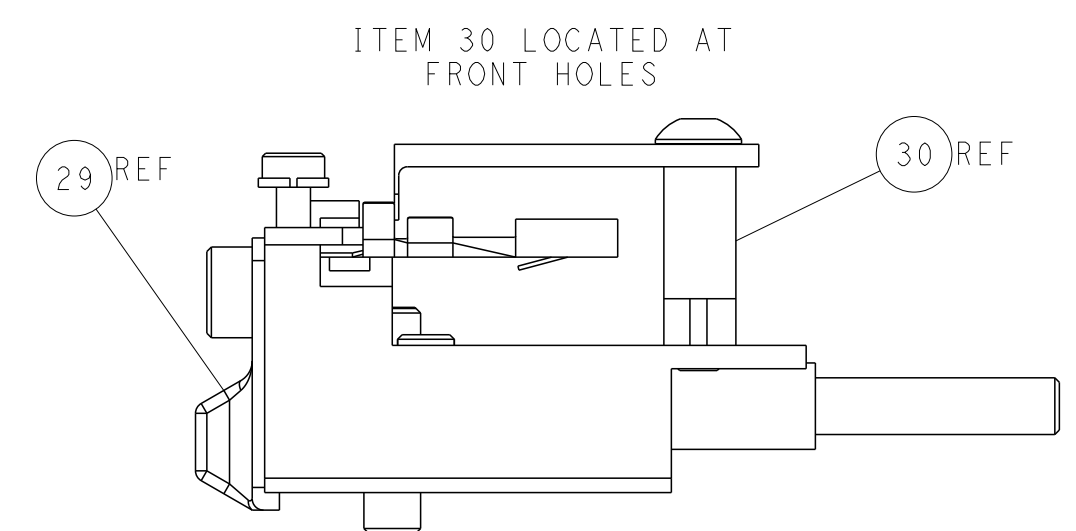
# PNEUMATIC

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)

|                                                                                                                                                                                                                                            |  |                                                                                                            |  |                                                                                                                                    |                    |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--------------------|
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| DIMENSIONS:<br>mm<br>                                                                                                                                 |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>PRODUCT SPEC<br>APPLICATION SPEC                                 |  | NAME<br>Ocean Side Feed<br>Applicator                                                                                              |                    |
| MATERIAL<br>-                                                                                                                                                                                                                              |  | WEIGHT<br>-                                                                                                |  | SIZE<br>A1                                                                                                                         | CAGE CODE<br>00779 |
| FINISH<br>-                                                                                                                                                                                                                                |  | RESTRICTED TO<br>-                                                                                         |  | C=2266391                                                                                                                          |                    |
| Customer Accessible Production Drawing                                                                                                                                                                                                     |  |                                                                                                            |  | SCALE<br>1:2                                                                                                                       | SHEET 2 OF 4       |
|                                                                                                                                                                                                                                            |  |                                                                                                            |  | REV<br>A                                                                                                                           |                    |

8

7

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5

4

3

2

1

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RELEASED FOR PUBLICATION

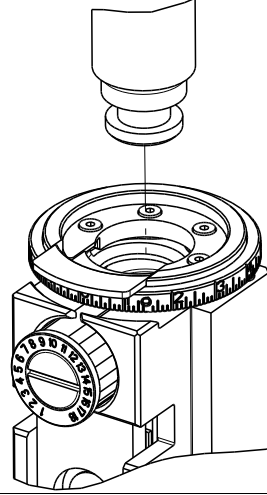
20

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PACIFIC VERSION  
TERMINATOR  
INTERFACE ADAPTER



PART  
NUMBER

2-2266391-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

CONVERT TO

SERVO LATCH PLATE

2119951-1

-

8-2266391-5

1901094-3

-

2168400-6 (QUANTITY 2)

CONVERT TO

SMART APPLICATOR

2161326-1

-

8-2266391-4

-

-

-

CONVERT TO

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

CONVERT TO

SERVO LATCH PLATE

2119951-1

-

8-2266391-5

1901094-3

-

2168400-6 (QUANTITY 2)

CONVERT TO

SMART APPLICATOR

2161326-1

-

8-2266391-4

-

-

-

CONVERT TO

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

CONVERT TO

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

CONVERT TO

-

-

-

-

-

-

-

CONVERT TO

-

-

-

-

-

-

-

CRIMP

SIZE

TYPE

WIRE

2.79 mm [.110]

F

INSUL

3.94 mm [.155]

F

APPLICATOR INSTRUCTIONS

408-10389



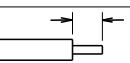
TERMINAL DATA: THB TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH

4.58-5.34 mm [.180-.210 IN]



INSULATION DIAMETER RANGE

Ø1.62-2.16 mm [.064-.085 IN]

TERMINAL APPLICATION SPECIFICATION

NONE

-

-

-

-

-

-

TERMINALS APPLIED

TE TERMINAL

THB TERMINAL

TE TERMINAL

THB TERMINAL

2113506-1

PP0100312

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



1.50mm2

1.60+/-0.05 [.063+/-0.002]

7.8

1.00mm2

1.46+/-0.05 [.057+/-0.002]

9.3



△

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: 8-2266391-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266391-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266391-5

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 ITEM 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

△

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

△

MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

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

AMP 4805 REV 31MAR2000

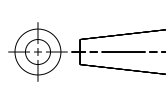
| SET UP GAUGE<br>2119599-1 |     | LOC<br>A    | DIST<br>66 | REVISIONS |             |                                     |         |
|---------------------------|-----|-------------|------------|-----------|-------------|-------------------------------------|---------|
| P                         | 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         | 2119082-4   | 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         | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 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         | 1-2119644-2 | RAM WASHER, PRECISION               | 38      |
| -                         | 1   | 1           | 1          | 1         | 1752356-6   | 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         | 1320908-7   | 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         | 1-356885-4  | STOP, SHEAR                         | 11      |
| -                         | 1   | 1           | 1          | 1         | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| -                         | 1   | 1           | 1          | 1         | 454276-5    | FLOATING SHEAR, FRONT               | 9       |
| △                         | 1   | 1           | 1          | 1         | 1-1803058-2 | ANVIL, COMBINATION                  | 8       |
| -                         | 1   | 1           | 1          | 1         | 1-240641-2  | SPACER                              | 7       |
| -                         | -   | -           | -          | -         | -           | -                                   | 6       |
| -                         | 1   | 1           | 1          | 1         | 2119757-4   | DEPRESSOR, SHEAR                    | 5       |
| -                         | 1   | 1           | 1          | 1         | 238011-2    | BLOCK, CRIMPER SPACER               | 4       |
| △                         | 1   | 1           | 1          | 1         | 3-2119582-6 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -                         | 1   | 1           | 1          | 1         | 455888-7    | SPACER, CRIMPER                     | 2       |
| △                         | 1   | 1           | 1          | 1         | 7-456408-2  | CRIMPER, WIRE PREMIUM               | 1       |
| -                         | 77  | -27         | -25        | -22       | -21         | PART NO                             |         |
| -                         | -   | -           | -          | -         | -           | DESCRIPTION                         | ITEM NO |

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OWN  
T. YIN  
CHK  
G. BAILEY  
APVD  
J. GUO

27JUN2014  
27JUN2014  
27JUN2014

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

FINISH

MATERIAL  
-

FINISH  
-

PRODUCT SPEC  
-

APPLICATION SPEC  
-

SIZE  
A

CAGE CODE  
00779

DRAWING NO  
C=2266391

RESTRICTED TO  
-

Customer Accessible Production Drawing

SCALE  
1:2

SHEET  
3

OF  
4

REV  
A

TE Connectivity  
Harrisburg, PA 17105-3608

Ocean Side Feed  
Applicator

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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