

8

7

6

5

4

3

2

1

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED

2266393-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1

1338683-8

5-18022-5

2119641-1

2119799-1

2063440-1

2266393-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119951-1

-

8-2266393-5

1901094-3

-

2168400-6 (QUANTITY 2)

2266393-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

2119949-1

1338683-8

5-18022-5

2119653-1

-

-

2266393-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

12

2119950-1

1338683-8

5-18022-5

2119641-1

2119799-1

2063440-1

2266393-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2266393-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.29 mm [.090]

F

INSUL

4.06 mm [1.60]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: THB GROUP TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH

4.34-5.11 mm [.171-.201 IN]

INSULATION DIAMETER RANGE

Ø

1.3

TERMINAL APPLICATION SPECIFICATION

NONE

-

-

TERMINALS APPLIED

TE TERMINAL

THB GROUP TERMINAL

TE SEAL

FANGYUAN SEAL

3

CABLE DIAMETER

2113508-1

PP0137601

2113500-1

7165-33541A

Ø 1.6mm-2.1mm

2113509-1

DJ90112

Ø 1.6mm-2.1mm

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

0.85mm2

1.22+/-0.05 [.048+/- .002]

8.6

0.50mm2

1.09+/-0.05 [.043+/- .002]

10.2

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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266393-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266393-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266393-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266393-6

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.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.

7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

8 MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.58.

13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

14 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.

15 CUT TO LENGTH AT ASSEMBLY.

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

DWN

APVD

A

RELEASED

22SEP2014

BH

GB

-

-

-

-

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

-

1

-

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

2119082-3

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

-

-

-

-

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

-

-

REF

REF

-

-

2119944-1

FEED FINGER ASSEMBLY, SF

117

-

1

1

1

1

1

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

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

1

1

1

985575-3

SCR, FLT SKT HD CAP M3 X 10.0

57

-

-

-

-

1

1

1338685-1

PAWL, FEED

56

-

4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

-

2

2

2

2

2

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

53

-

1

1

1

1

1

5018030-1

NUT, HEX, REG, RoHS, M3

52

-

1

1

1

1

1

811242-5

BUMPER, HOLD DOWN

51

-

1

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

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

1-2119644-2

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

1320908-7

SPACER, STRIP GUIDE

30

-

1

1

1

1

1

2119959-1

ASSEMBLY, STRIP GUIDE

29

-

1

1

1

1

1

455888-3

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

-

2

2

2

2

2

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

318707-1

FLOATING SHEAR, FRONT

9

-

1

1

1

1

1

1-1633921-3

ANVIL, COMBINATION

8

-

1

1

1

1

1

240641-5

SPACER

7

-

-

-

-

-

-

-

-

6

-

1

1

1

1

1

2-2119781-4

DEPRESSOR, SHEAR

5

-

1

1

1

1

1

1-238011-7

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1

7-2119784-1

CRIMPER, INSULATION O PREMIUM

3

-

1

1

1

1

1

1-455888-4

SPACER, CRIMPER

2

-

1

1

1

1

1

3-456406-3

CRIMPER, WIRE PREMIUM

1

-

-

1

-

-

-

2119957-2

APPLICATOR SHIM PACK

260

-

1

-

1

1

1

8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

111 IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER OF THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.

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

MATERIAL

DWN

BOB HIGMAN

10JUL2014

CHK

T. ELBIN

10JUL2014

APVD

D. STOUGH

10JUL2014

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2266393

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

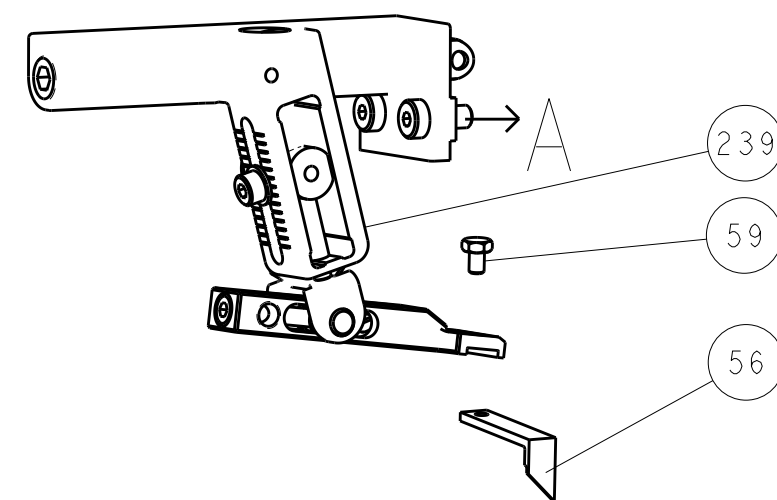
A

AMP 4805 REV 31MAR2000

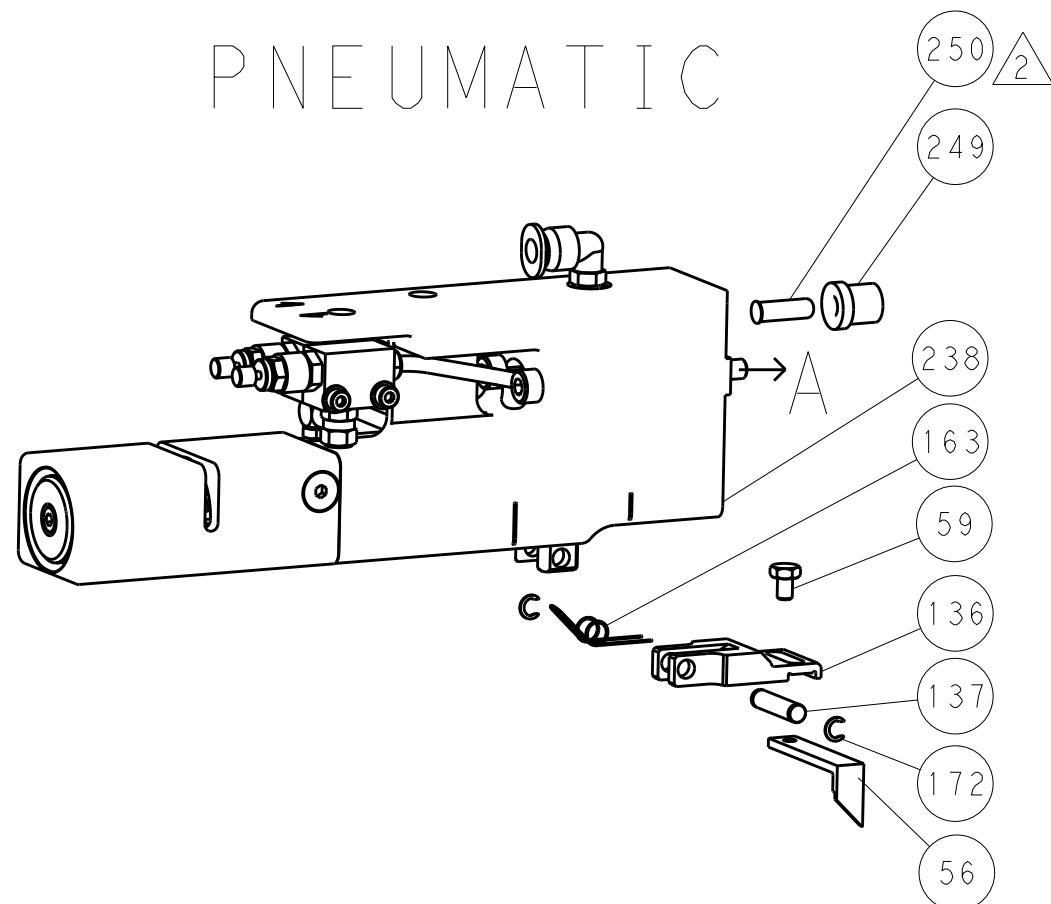
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

FEED TYPE MECHANICAL



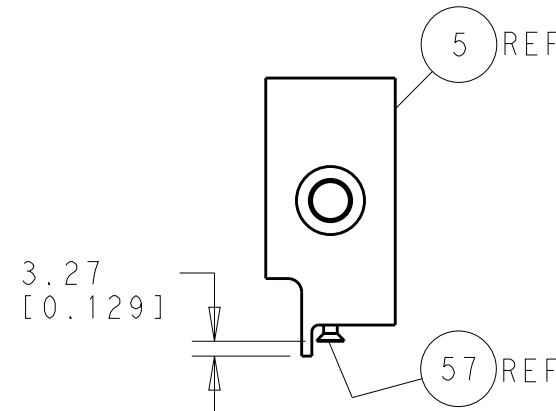
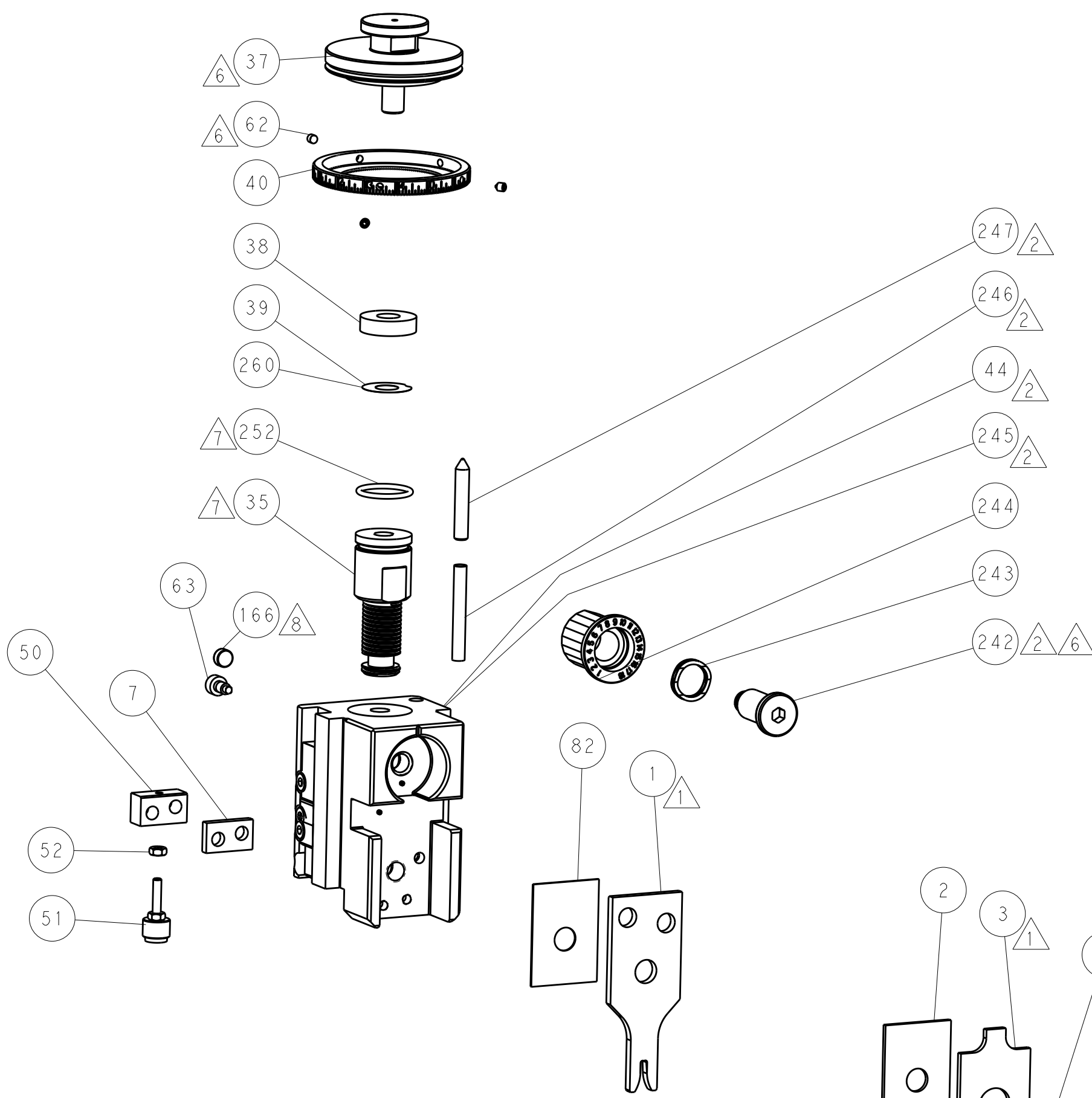
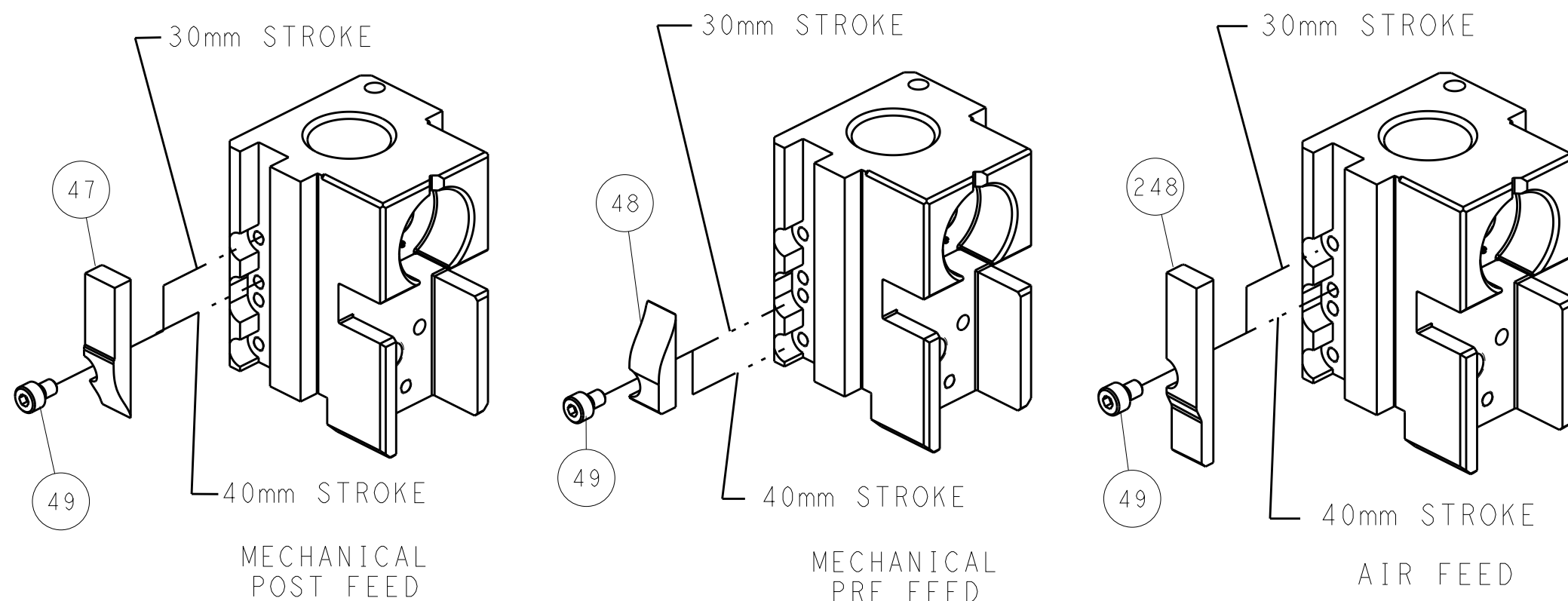
PNEUMATIC



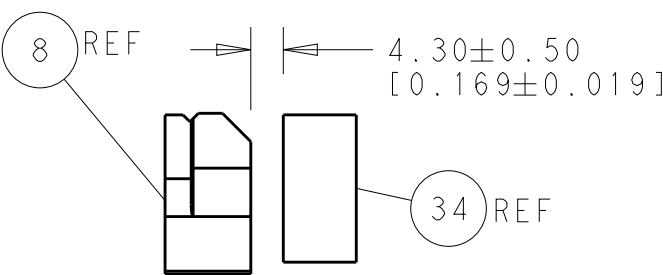
SERVO LATCH PLATE



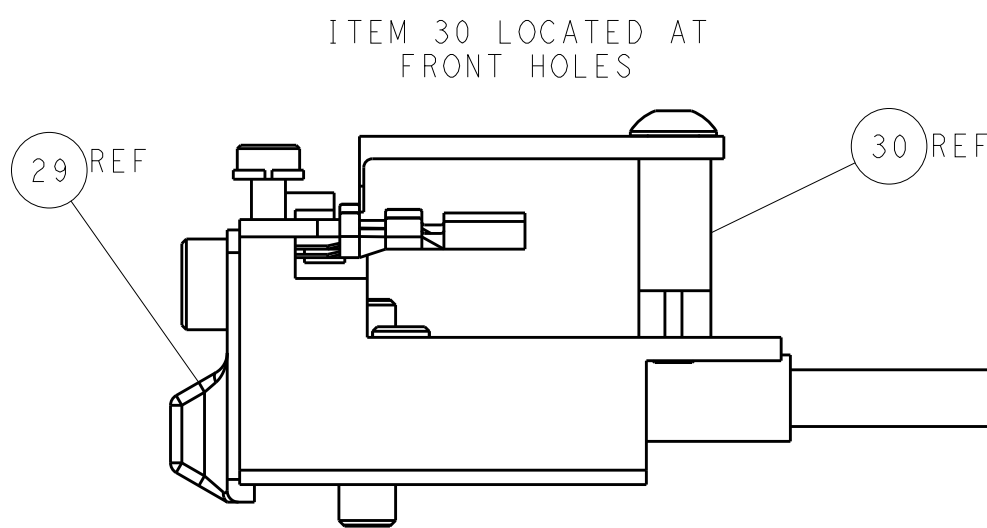
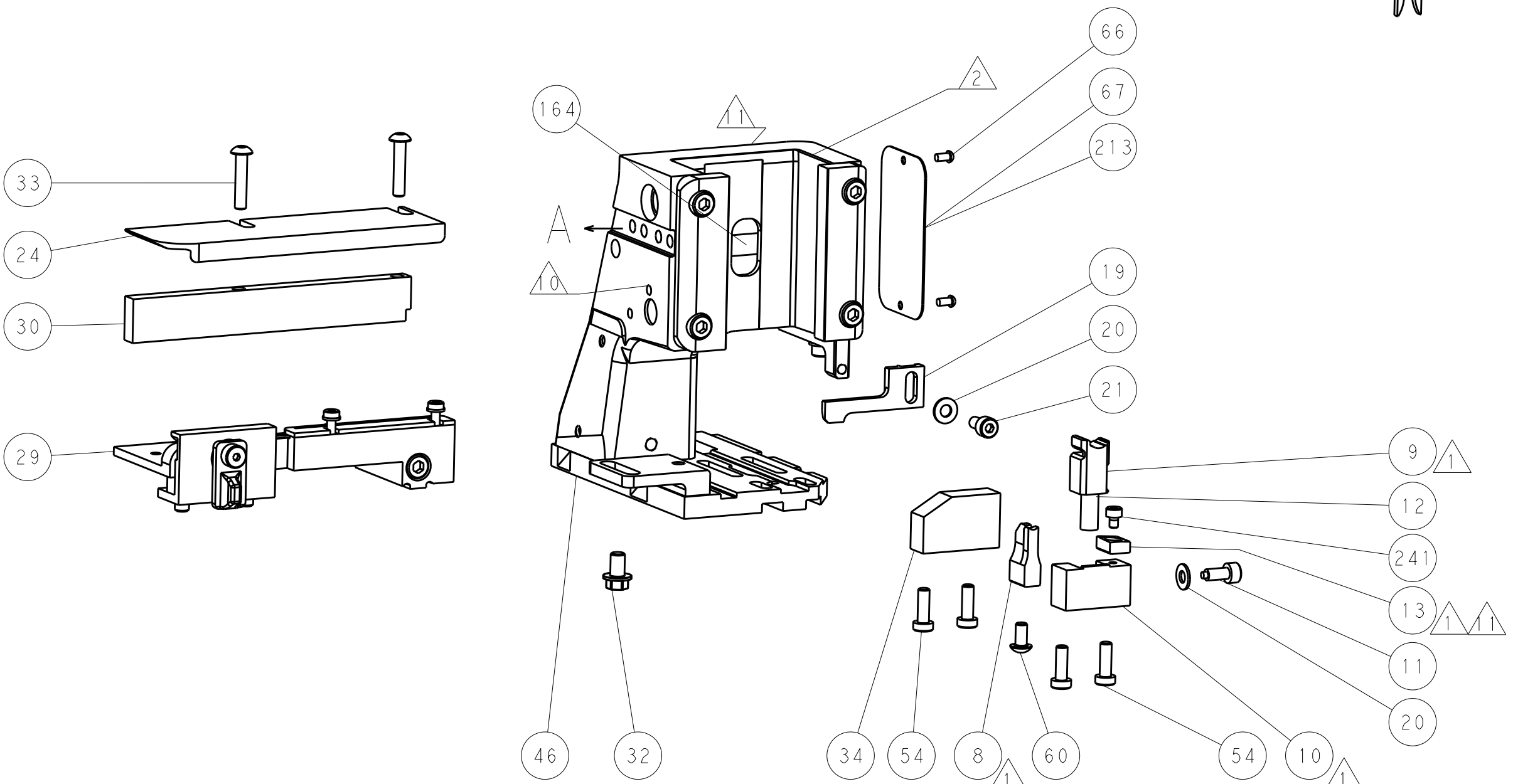
CAM POSITIONS



SHEAR DEPRESSOR DETAIL

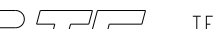


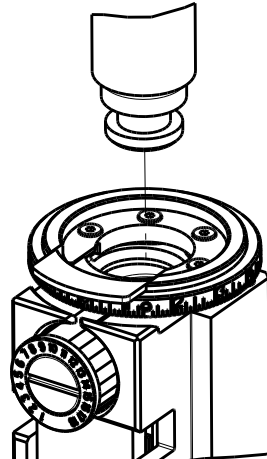
TERMINAL SUPPORT LOCATION



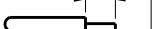
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

TE CONNECTIVITY IS A REGISTERED TRADEMARK OF TE CONNECTIVITY CORPORATION ALL OTHERS ARE TRADEMARKS OF THEIR RESPECTIVE OWNERS. TE CONNECTIVITY SHALL BE CONTACTED FOR THE LATEST REVISIONS.		DWN 10JUL2014 BOB HIGMAN				TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHG 10JUL2014 T. ELBIN		NAME	
mm		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001		APPR 10JUL2014 D. STOUGH		Ocean Side Feed Applicator	
				PRODUCT SPEC			
				APPLICATION SPEC			
				SIZE		CAGE CODE	
				DRAWING NO		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		A 00779 C-2266393	
						SCALE 1:2	
				Customer Accessible Drawing		SHEET 2 OF 4	
						REV A	

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					
		2-2266393-1	1	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	-	8-2266393-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2266393-4	-	-	-
		2-2266393-2	1	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2266393-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2266393-4	-	-	-
		2-2266393-5	1	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	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
		2-2266393-7	1	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
		7-2266393-7	1	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.06 mm [1.60]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: THB GROUP TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.34-5.11 mm [1.71-.201 [N]		INSULATION DIAMETER RANGE  $\varnothing$ 	
TERMINAL APPLICATION SPECIFICATION 	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	THB GROUP TERMINAL	TE SEAL	FANGYUAN SEAL 
2113508-1	PP0137601	2113500-1	7165-33541A
		2113509-1	DJ90112
			$\varnothing$ 1.6mm-2.1mm
			$\varnothing$ 1.6mm-2.1mm

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.85mm2		1.22+/-0.05 [.048+/- .002]		-
0.50mm2		1.09+/-0.05 [.043+/- .002]		-



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: 8-2266393-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266393-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266393-5
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.
12. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
13. APPLY TORO-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. CUT TO LENGTH AT ASSEMBLY

2				1		
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS		
P	LTN	DESCRIPTION		DATE	DRN	APVD
	-	SEE SHEET 1		-	-	-

6	-	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
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0. PLC ±. 1. PLC ±0.5 2. PLC ±0.13 3. PLC ±0.013 4. PLC ±0.001 ANGLES .0001		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE CAGE CODE DRAWING NO A 00779 C 2266393	
MATERIAL -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 3 of 4 REV A	

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

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

D

C

B

A

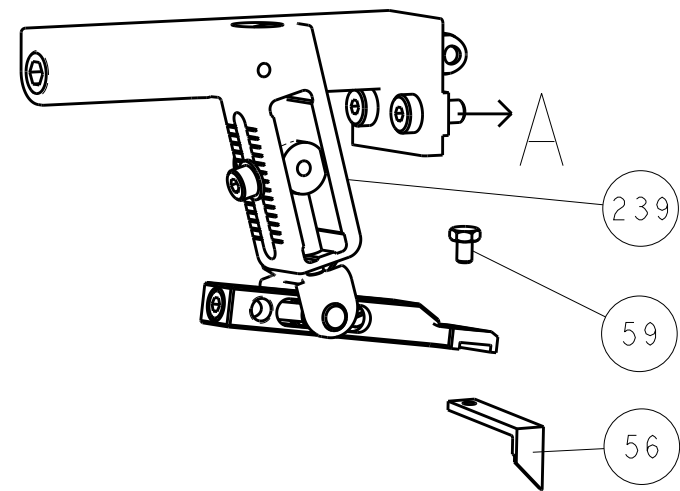
D

C

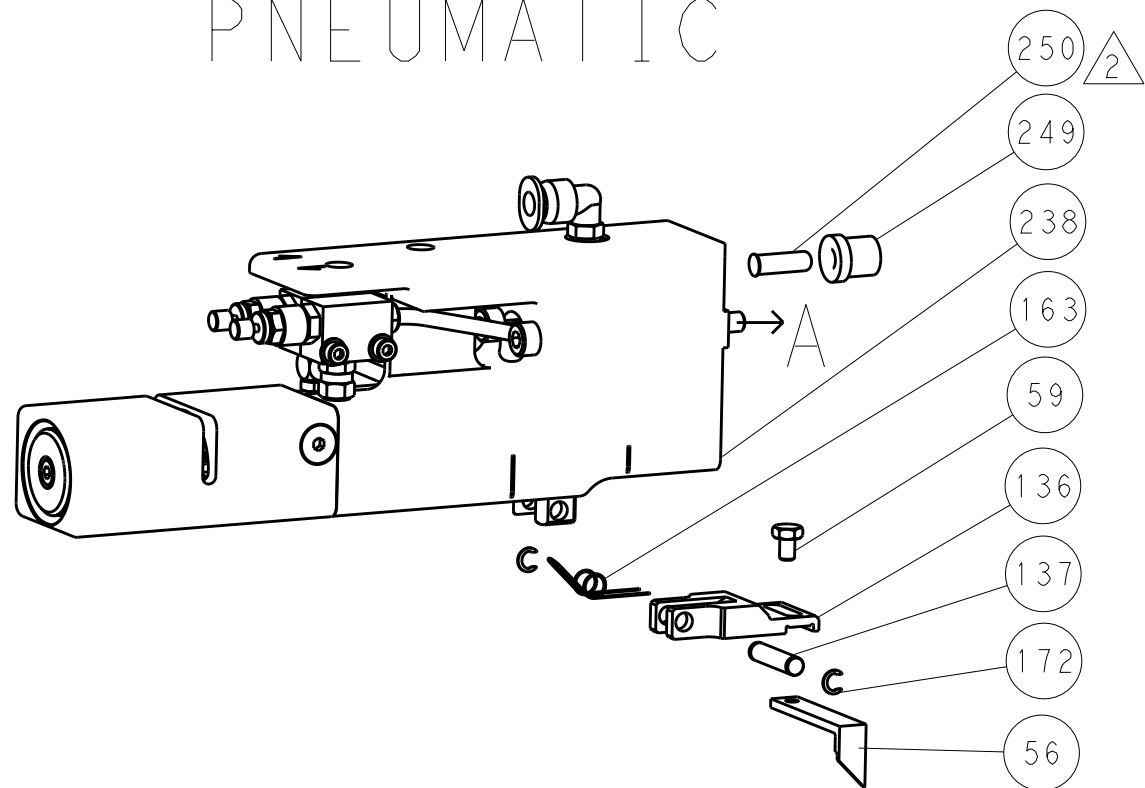
B

A

FEED TYPE MECHANICAL



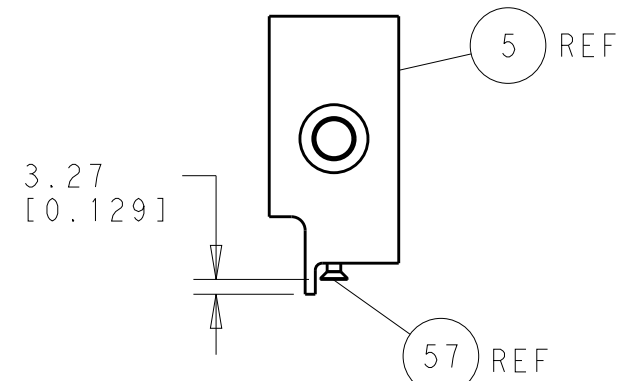
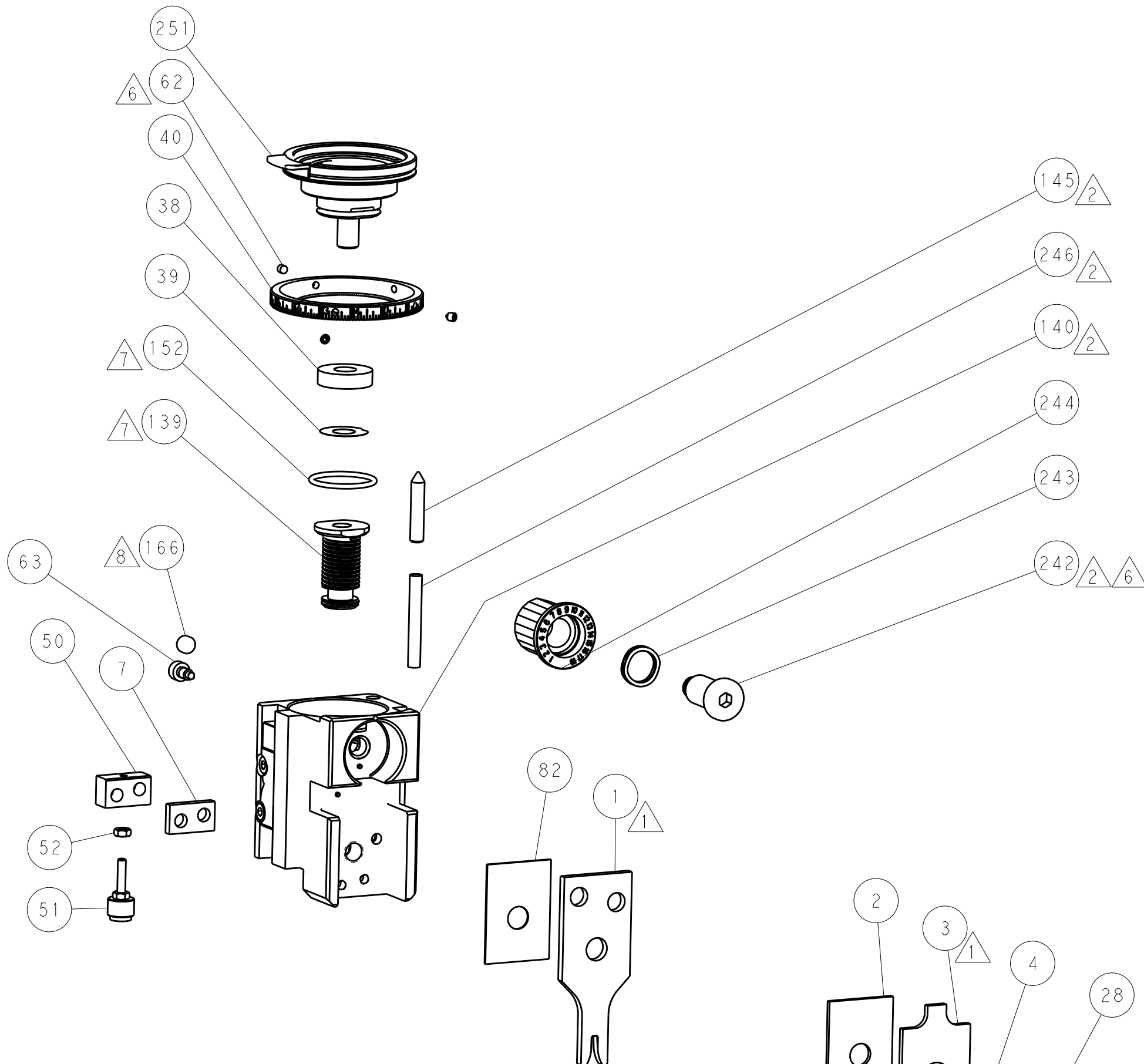
PNEUMATIC



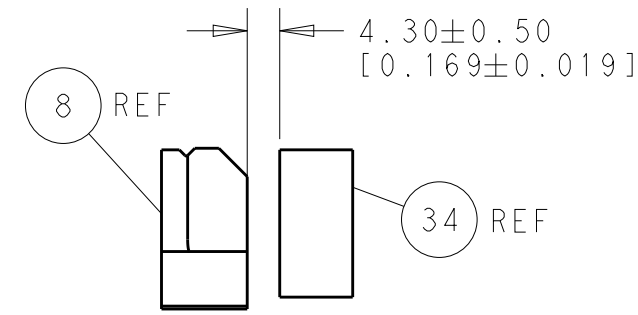
SERVO LATCH PLATE



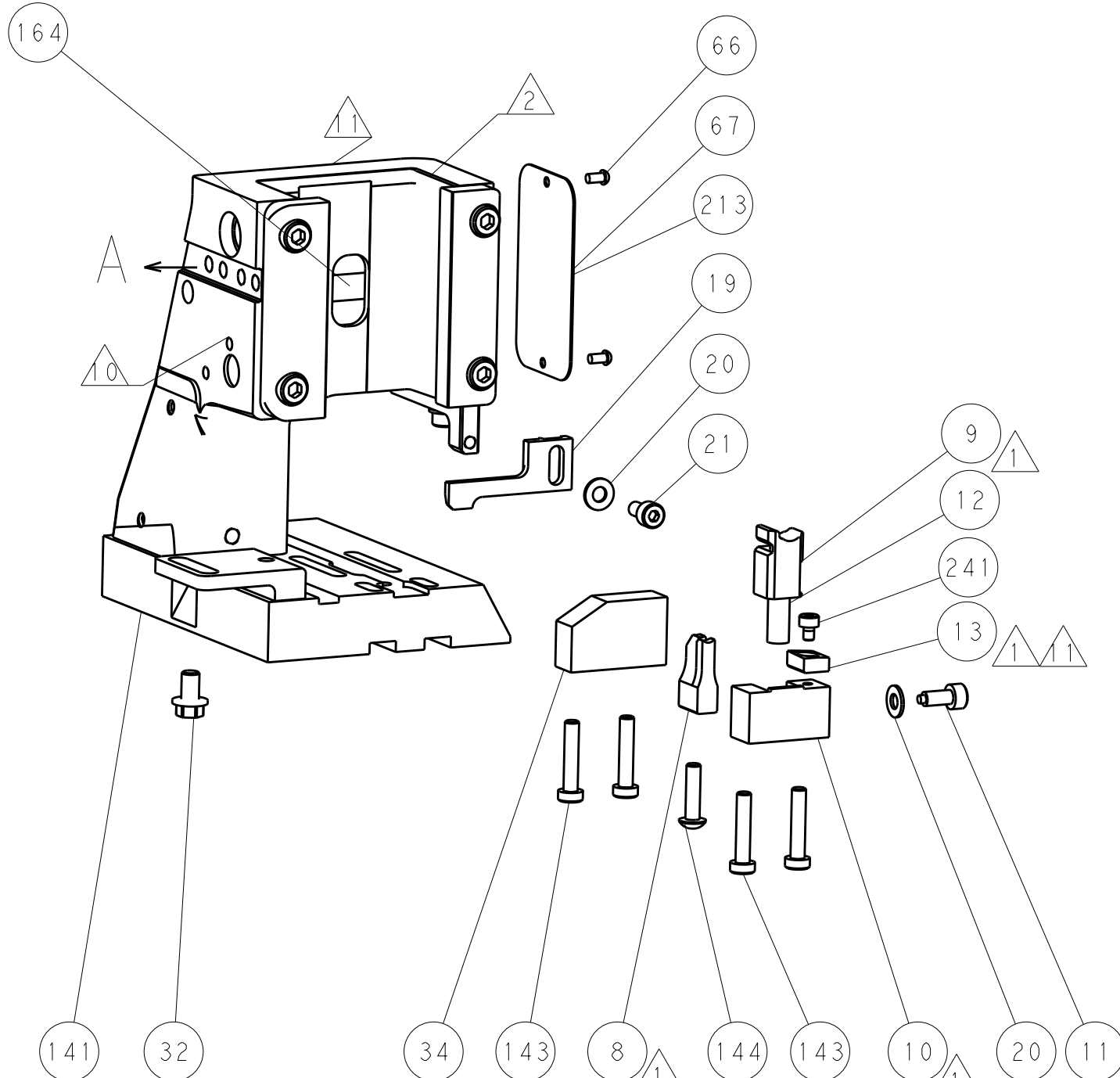
CAM POSITIONS



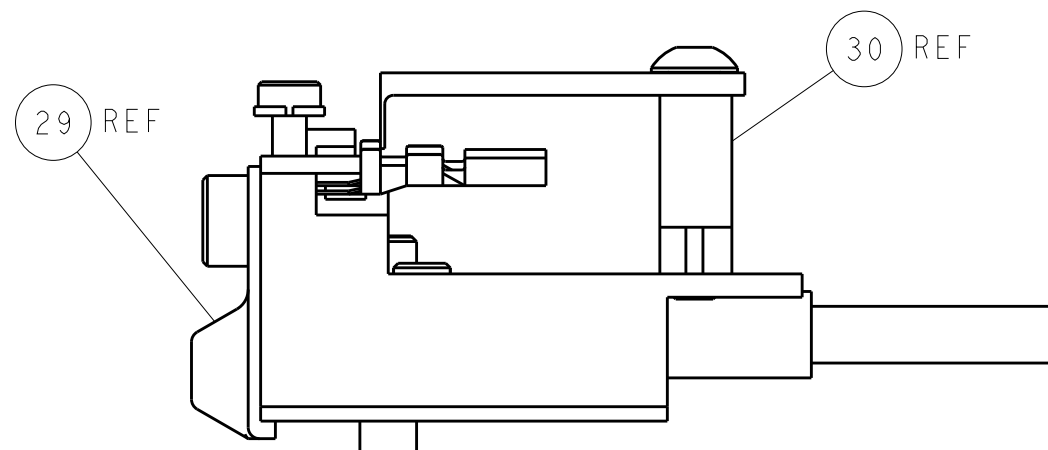
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

PACIFIC VERSION
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(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 ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH		SIZE A1
MATERIAL		WEIGHT		RESTRICTED TO
Customer Accessible Production Drawing		SCALE 1:2		SHEET 4 OF 4 REV A

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