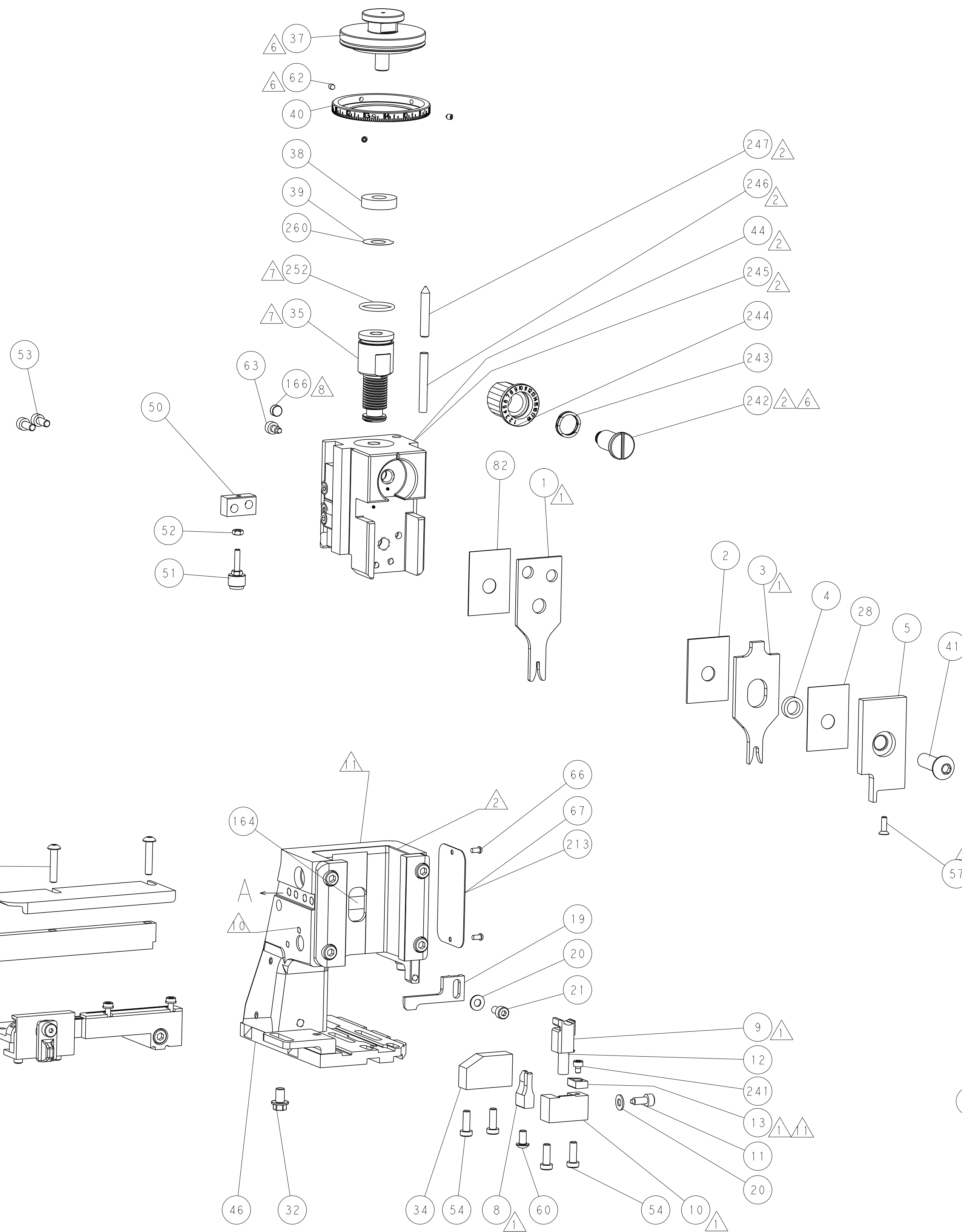
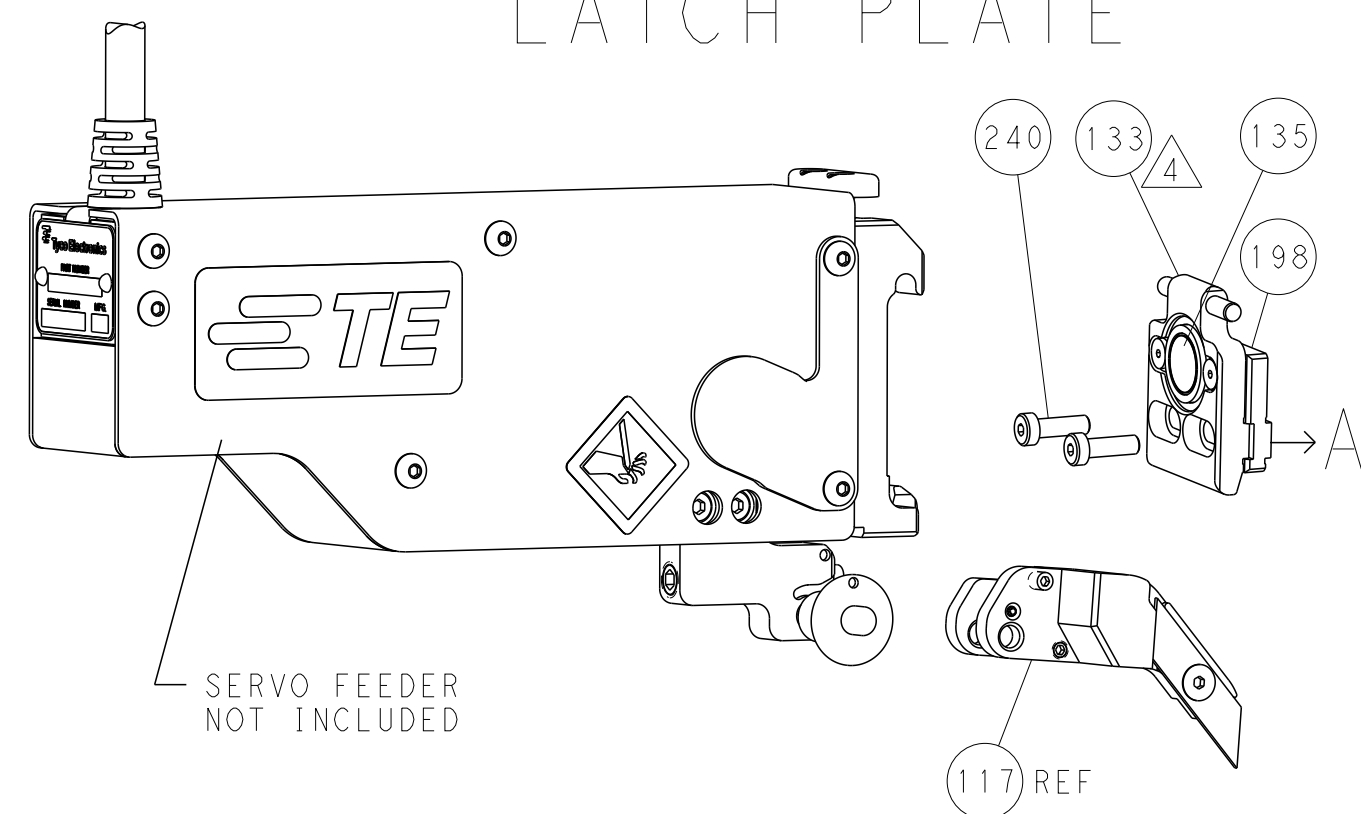


PNEUMATIC

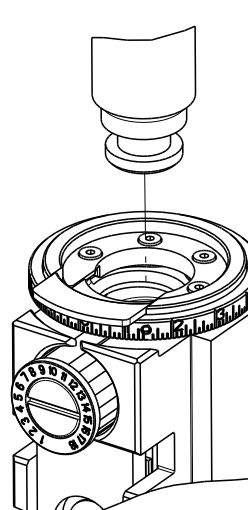
SERVO
LATCH PLATE

CAM POSITIONS



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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TFCO. TFCO PRINTING CORPORATION IT IS SUBJECT TO THE PROVISIONS OF THE TFCO PRINTING CORPORATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN Y. YIN 02JUL2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK G. BAILEY 02JUL2014			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD U. GUO 02JUL2014		NAME	
mm		PRODUCT SPEC		Ocean Side Feed Applicator	
		APPLICATION SPEC		-	
0 PLC ±.0 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		SIZE		RESTRICTED TO	
MATERIAL		WEIGHT		CAGE CODE	
FINISH		A		DRAWING NO	
-		-		00779	
-		-		C=2266400	
-		-		-	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 of 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
	2-2266400-1	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	-	8-2266400-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2266400-4	-	-	-	
	2-2266400-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	
					SERVO LATCH PLATE	2119951-1	-	8-2266400-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2266400-4	-	-	-	
	2-2266400-5	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	
	2-2266400-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
	7-2266400-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.30 mm [.130]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: HULANE TERMINAL TE CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL				
WIRE STRIP LENGTH 3.46-4.22 mm [.136-.166 IN]		INSULATION DIAMETER RANGE Ø ¹²		
TERMINAL APPLICATION SPECIFICATION	NONE	-	-	-
TERMINALS APPLIED				
TE TERMINAL	HULANE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER ¹²
2113516-1	893708PSS	963530-1		Ø1.4-1.9 mm

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
0.50mm2		1.12+/-0.05 [.044+/- .002]		9.6



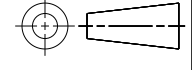
- ¹ RECOMMENDED SPARE PARTS
- ² GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- ⁴ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266400-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266400-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266400-5
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 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.

*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 A	DIS 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	2119082-3	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	455888-4	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	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	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	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	3-1752356-3	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	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-2	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	5-1803054-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	5-1633965-4	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

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				CHK G.BAILEY	02JUL2014				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J.GUO	02JUL2014	NAME			
mm		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001		PRODUCT SPEC		SIZE			
		FINISH		APPLICATION SPEC		CAGE CODE		DRAWING NO	
MATERIAL		-		WEIGHT		A1 00779		C=2266400	
				Customer Accessible Production Drawing		SCALE		SHEET 3 OF 4	
						1:2		REV A	

PNEUMATIC

250
249
238
163
59
136
137
172
56

Diagram illustrating the STE servo feeder assembly. The main unit is labeled "STE". A callout shows the servo motor assembly with callouts 240, 133, 135, 198, and A. Another callout shows a reference point 117 REF.

30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

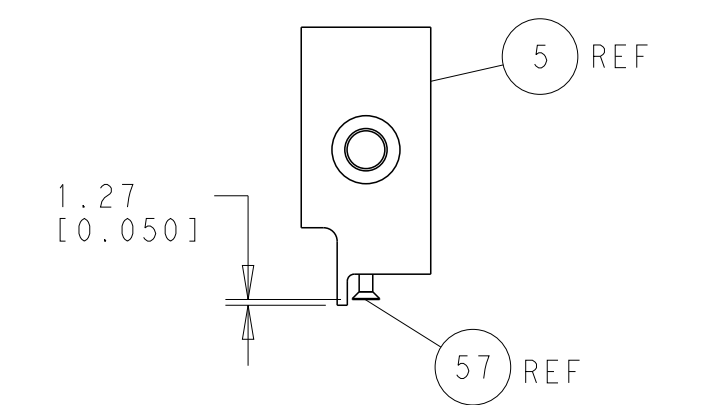
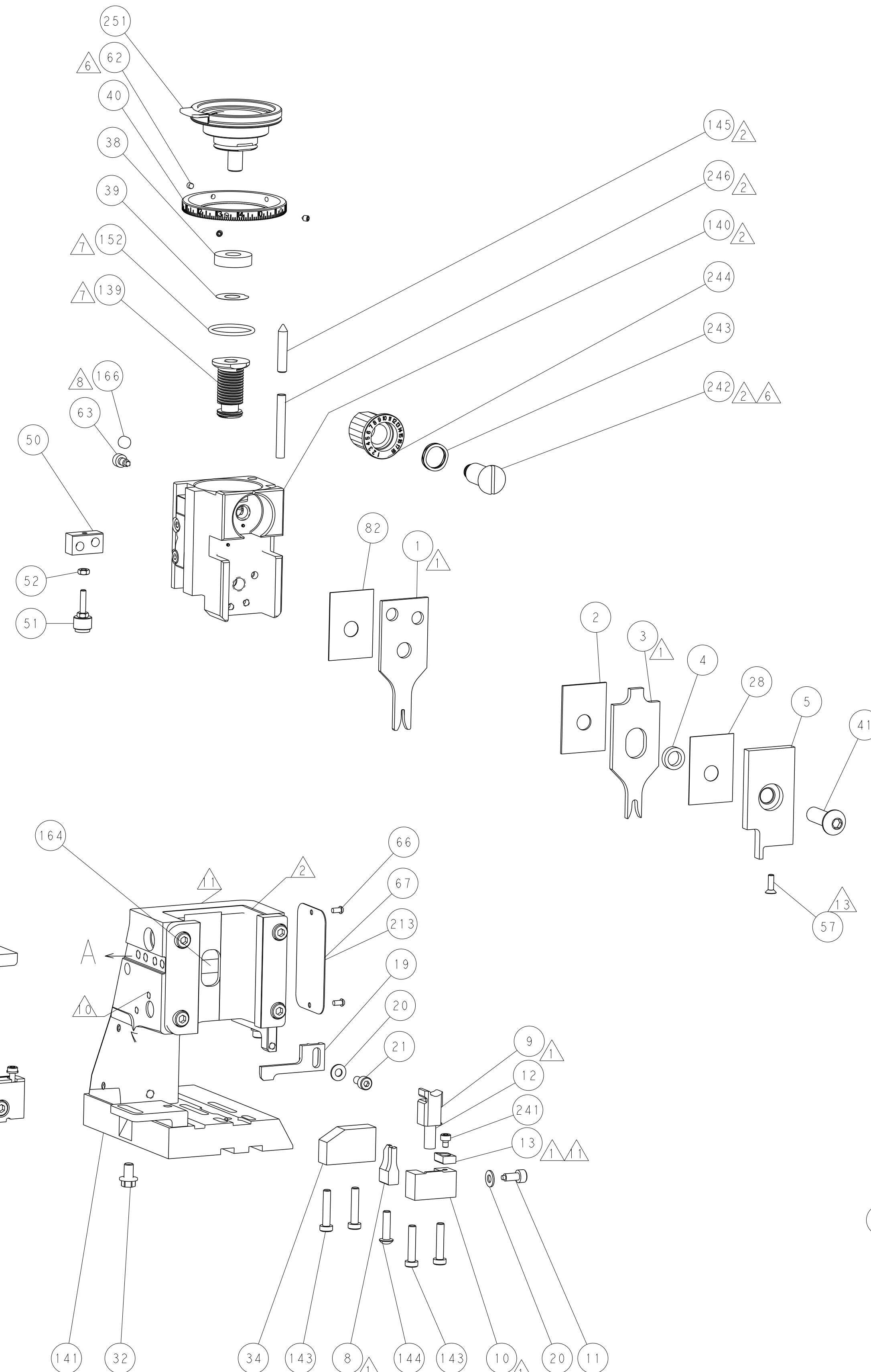
MECHANICAL PRE FEED

30mm STROKE

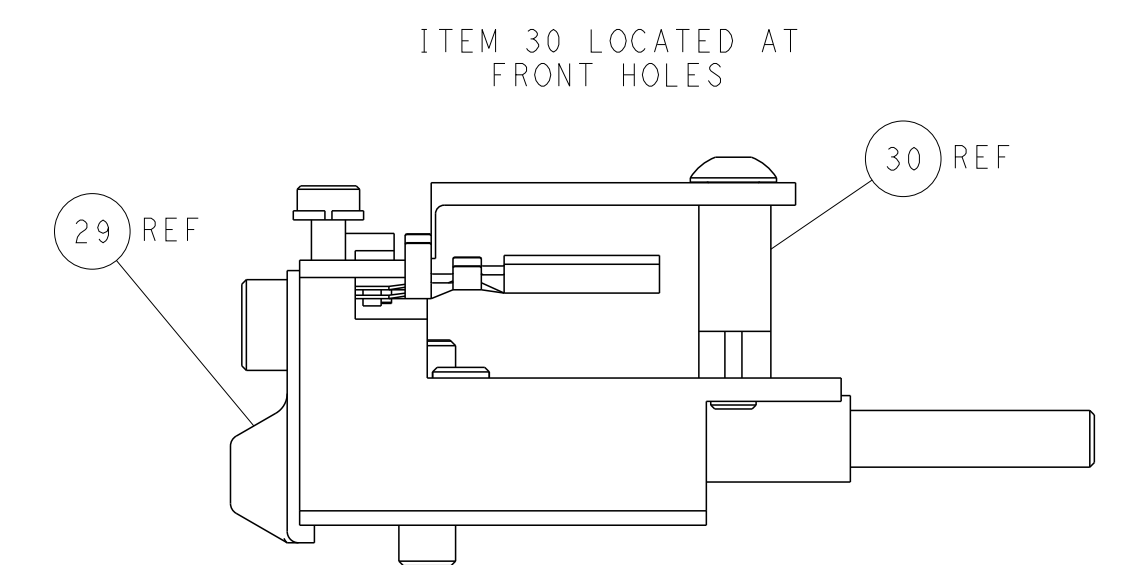
151

49

AIR FEED



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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: 0.015 0.010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.00005 0.000025 0.000015 0.000010 0.000005 0.0000025 0.0000015 0.0000010 0.0000005 0.00000025 0.00000015 0.00000010 0.00000005 0.000000025 0.000000015 0.000000010 0.000000005 0.0000000025 0.0000000015 0.0000000010 0.0000000005 0.00000000025 0.00000000015 0.00000000010 0.00000000005 0.000000000025 0.000000000015 0.000000000010 0.000000000005 0.0000000000025 0.0000000000015 0.0000000000010 0.0000000000005 0.00000000000025 0.00000000000015 0.00000000000010 0.00000000000005 0.000000000000025 0.000000000000015 0.000000000000010 0.000000000000005 0.0000000000000025 0.0000000000000015 0.0000000000000010 0.0000000000000005 0.00000000000000025 0.00000000000000015 0.00000000000000010 0.00000000000000005 0.000000000000000025 0.000000000000000015 0.000000000000000010 0.000000000000000005 0.0000000000000000025 0.0000000000000000015 0.0000000000000000010 0.0000000000000000005 0.00000000000000000025 0.00000000000000000015 0.00000000000000000010 0.00000000000000000005 0.000000000000000000025 0.000000000000000000015 0.000000000000000000010 0.000000000000000000005 0.0000000000000000000025 0.0000000000000000000015 0.0000000000000000000010 0.0000000000000000000005 0.00000000000000000000025 0.00000000000000000000015 0.00000000000000000000010 0.00000000000000000000005 0.000000000000000000000025 0.000000000000000000000015 0.000000000000000000000010 0.000000000000000000000005 0.0000000000000000000000025 0.0000000000000000000000015 0.0000000000000000000000010 0.0000000000000000000000005 0.00000000000000000000000025 0.00000000000000000000000015 0.00000000000000000000000010 0.00000000000000000000000005 0.000000000000000000000000025 0.000000000000000000000000015 0.000000000000000000000000010 0.000000000000000000000000005 0.0000000000000000000000000025 0.0000000000000000000000000015 0.0000000000000000000000000010 0.0000000000000000000000000005 0.00000000000000000000000000025 0.00000000000000000000000000015 0.00000000000000000000000000010 0.00000000000000000000000000005 0.000000000000000000000000000025 0.000000000000000000000000000015 0.000000000000000000000000000010 0.000000000000000000000000000005 0.0000000000000000000000000000025 0.0000000000000000000000000000015 0.0000000000000000000000000000010 0.0000000000000000000000000000005 0.00000000000000000000000000000025 0.00000000000000000000000000000015 0.00000000000000000000000000000010 0.00000000000000000000000000000005 0.000000000000000000000000000000025 0.000000000000000000000000000000015 0.000000000000000000000000000000010 0.000000000000000000000000000000005 0.0000000000000000000000000000000025 0.0000000000000000000000000000000015 0.0000000000000000000000000000000010 0.0000000000000000000000000000000005 0.00000000000000000000000000000000025 0.00000000000000000000000000000000015 0.00000000000000000000000000000000010 0.00000000000000000000000000000000005 0.000000000000000000000000000000000025 0.000000000000000000000000000000000015 0.000000000000000000000000000000000010 0.000000000000000000000000000000000005 0.0000000000000000000000000000000000025 0.0000000000000000000000000000000000015 0.0000000000000000000000000000000000010 0.0000000000000000000000000000000000005 0.00000000000000000000000000000000000025 0.00000000000000000000000000000000000015 0.00000000000000000000000000000000000010 0.00000000000000000000000000000000000005 0.000000000000000000000000000000000000025 0.000000000000000000000000000000000000015 0.000000000000000000000000000000000000010 0.000000000000000000000000000000000000005 0.0000000000000000000000000000000000000025 0.0000000000000000000000000000000000000015 0.0000000000000000000000000000000000000010 0.0000000000000000000000000000000000000005 0.00000000000000000000000000000000000000025 0.00000000000000000000000000000000000000015 0.00000000000000000000000000000000000000010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.0005 0.00025 0.00015 0.00010 0.005 0.0025 0.0015 0.0010 0.00000000000000000000			

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