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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

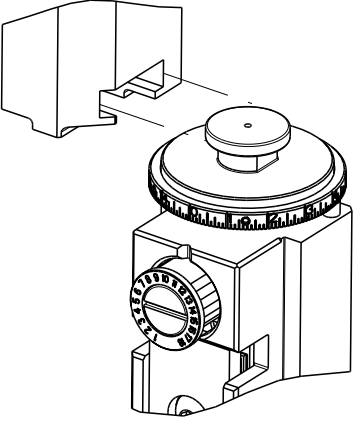
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2266452-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1 1338683-8 5-18022-5 2119641-1 2119799-1 2063440-1

2266452-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119949-1 1338683-8 5-18022-5 2119653-1 2119799-1 2063440-1

2266452-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119949-1 1338683-8 5-18022-5 2119653-1 2119799-1 2063440-1

2266452-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119949-1 1338683-8 5-18022-5 2119653-1 2119799-1 2063440-1

2266452-7

A

FINE CRIMP HEIGHT ADJUST

NONE

2119949-1 1338683-8 5-18022-5 2119653-1 2119799-1 2063440-1

7-2266452-7

A

CRIMP TOOLING KIT

-

2119949-1 1338683-8 5-18022-5 2119653-1 2119799-1 2063440-1

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.78 mm [.070]

F

INSUL

2.54 mm [.100]

F

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: MPE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: MPE TERMINAL

WIRE STRIP LENGTH

2.53-3.29 mm [.100-.130 IN]

INSULATION DIAMETER RANGE

Ø1.60-2.10 mm [.063-.083 IN]

TERMINAL APPLICATION SPECIFICATION

NONE

-

TERMINALS APPLIED

TE TERMINAL

MPE TERMINAL

TE TERMINAL

MPE TERMINAL

2113558-1

707-1-TX-XR

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

18 AWG

1.13+/-0.05 [.044+/- .002]

6.0

20 AWG

0.97+/-0.05 [.038+/- .002]

7.7

22 AWG

0.90+/-0.05 [.035+/- .002]

8.3

RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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: 8-2266452-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266452-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266452-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266452-6

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

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 4.67.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

2119950-1

1338683-8

5-18022-5

2119641-1

2119799-1

2063440-1

SERVO LATCH PLATE

2119951-1

-

8-2266452-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266452-4

-

-

-

MECHANICAL FEED

2119949-1

1338683-8

5-18022-5

2119653-1

-

-

SERVO LATCH PLATE

2119951-1

-

8-2266452-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2266452-4

-

-

-

MECHANICAL FEED

2119949-1

1338683-8

5-18022-5

2119653-1

-

-

PNEUMATIC FEED

2119950-1

1338683-8

5-18022-5

2119641-1

2119799-1

2063440-1

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SET UP GAUGE

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REVISIONS

DESCRIPTION

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ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

111 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING DEPARTMENT. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE ENGINEERING DEPARTMENT AND THE CUSTOMER. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE ENGINEERING DEPARTMENT AND THE CUSTOMER. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE ENGINEERING DEPARTMENT AND THE CUSTOMER.

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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

-

FINISH

-

OWN

X ZHAO

18AUG2014

CHK

L ZHANG

18AUG2014

APVD

T ELBIN

18AUG2014

PRODUCT SPEC

-

APPLICATION SPEC

-

WEIGHT

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

A

TE Connectivity

Harrisburg, PA 17105-3608

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

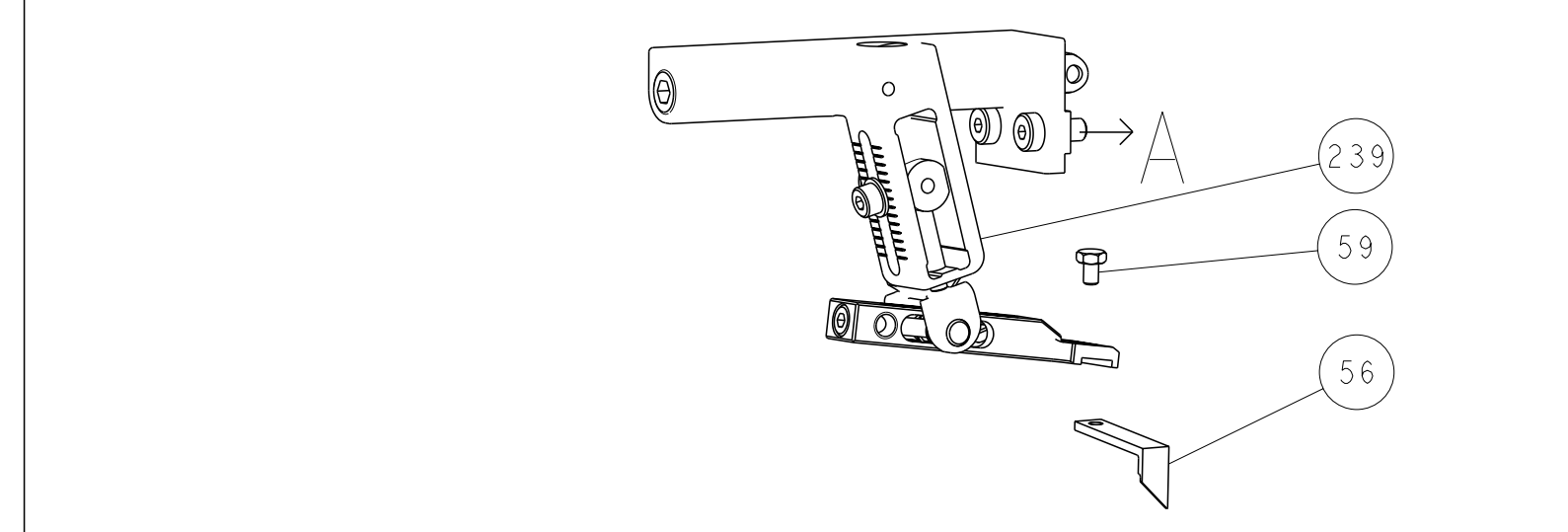
DRAWING NO

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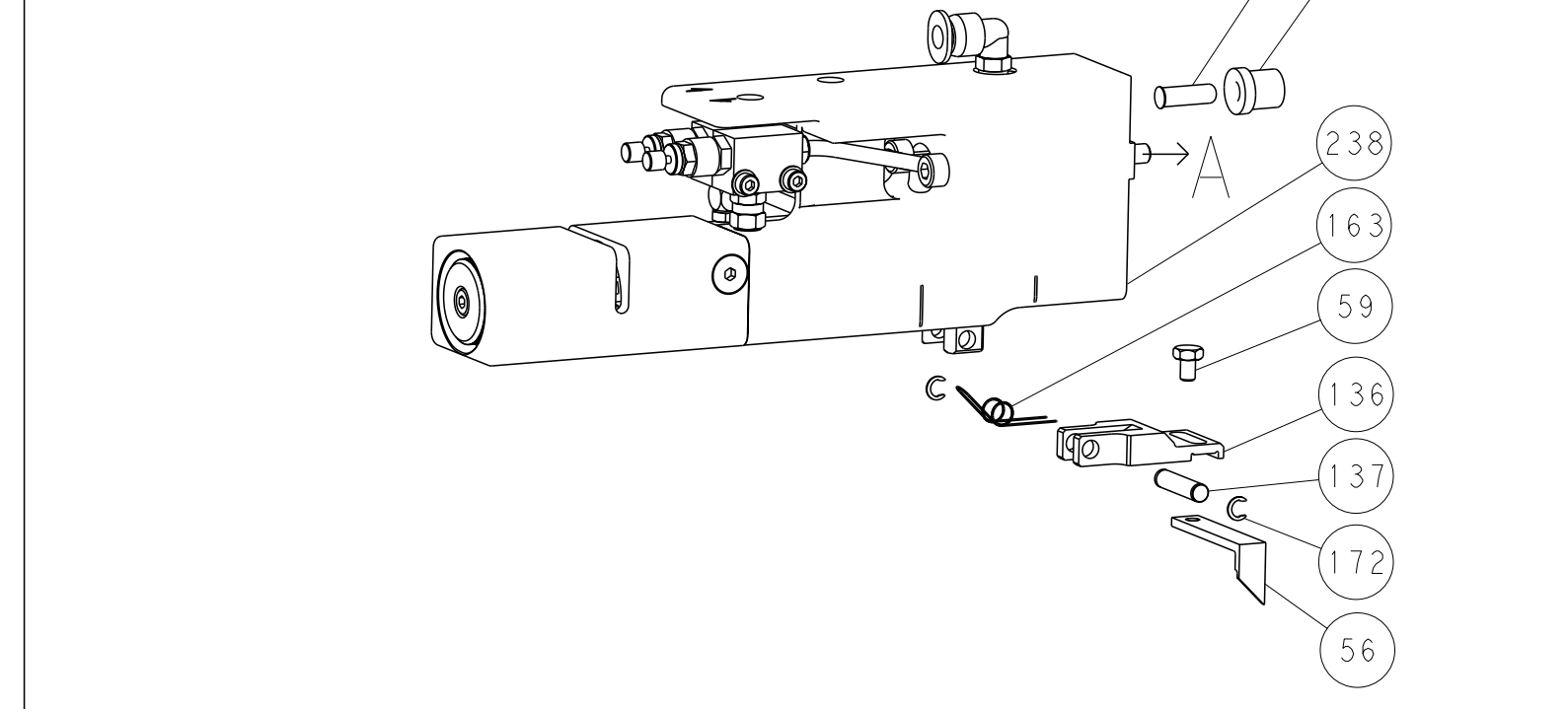
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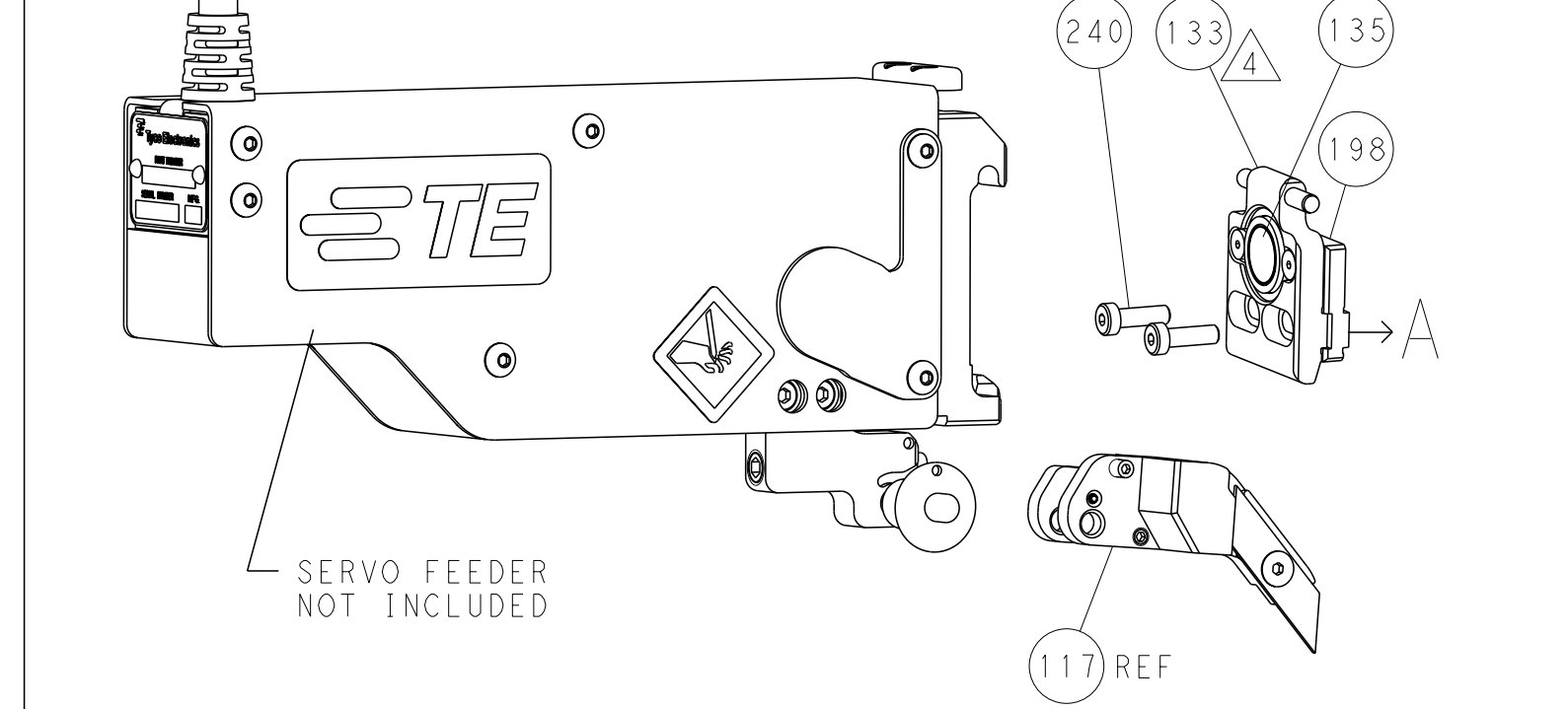
FEED TYPE MECHANICAL



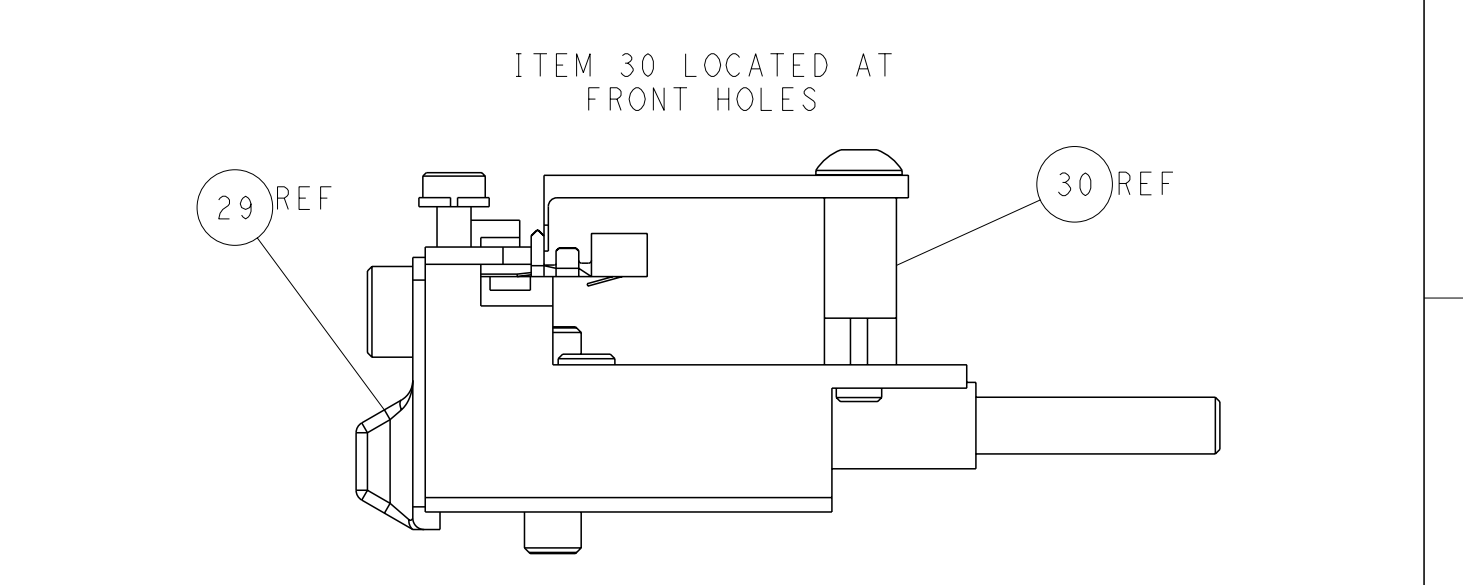
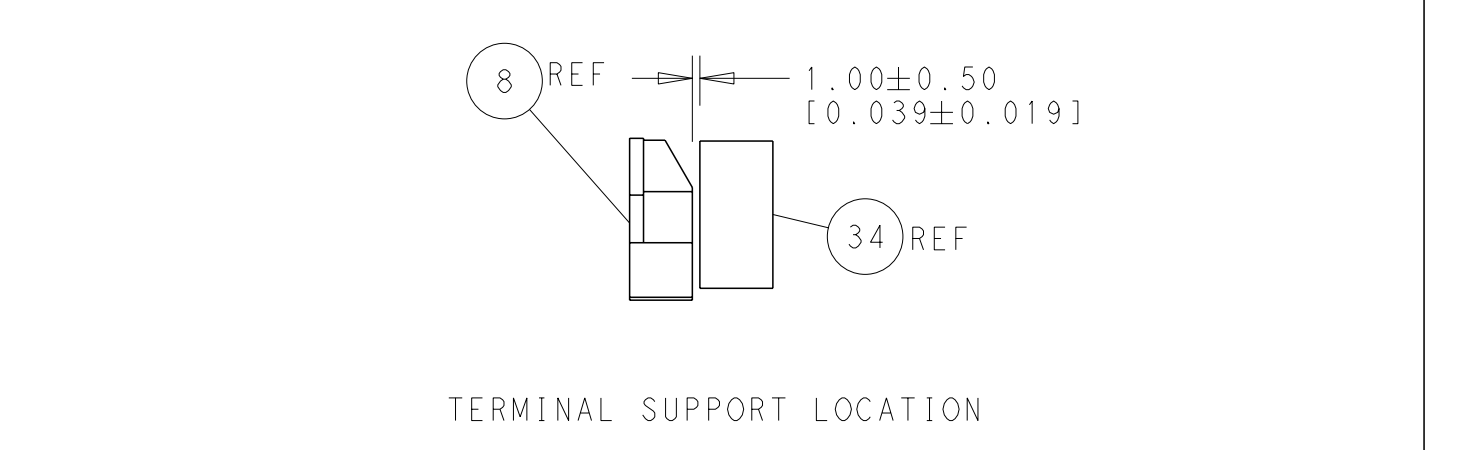
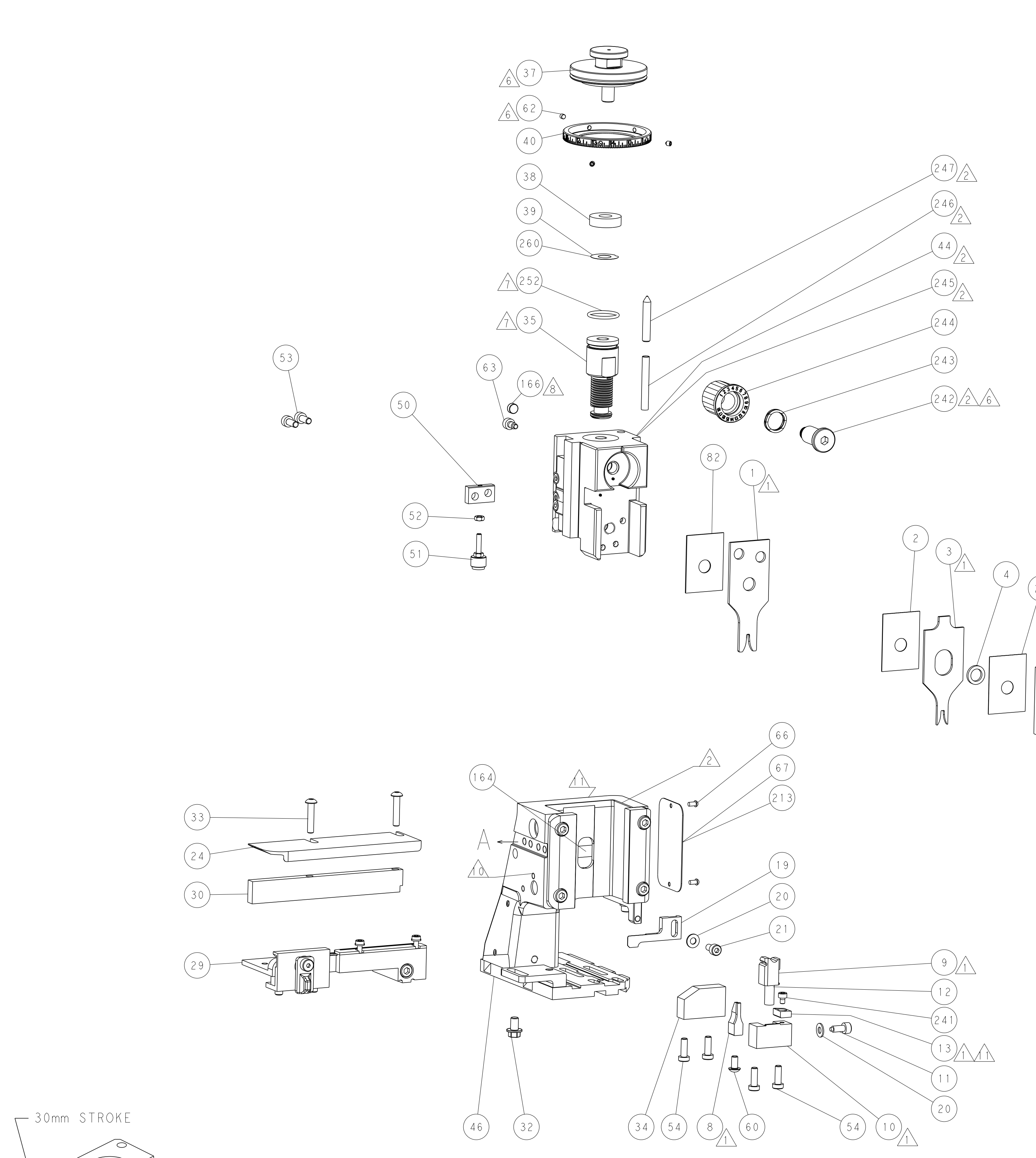
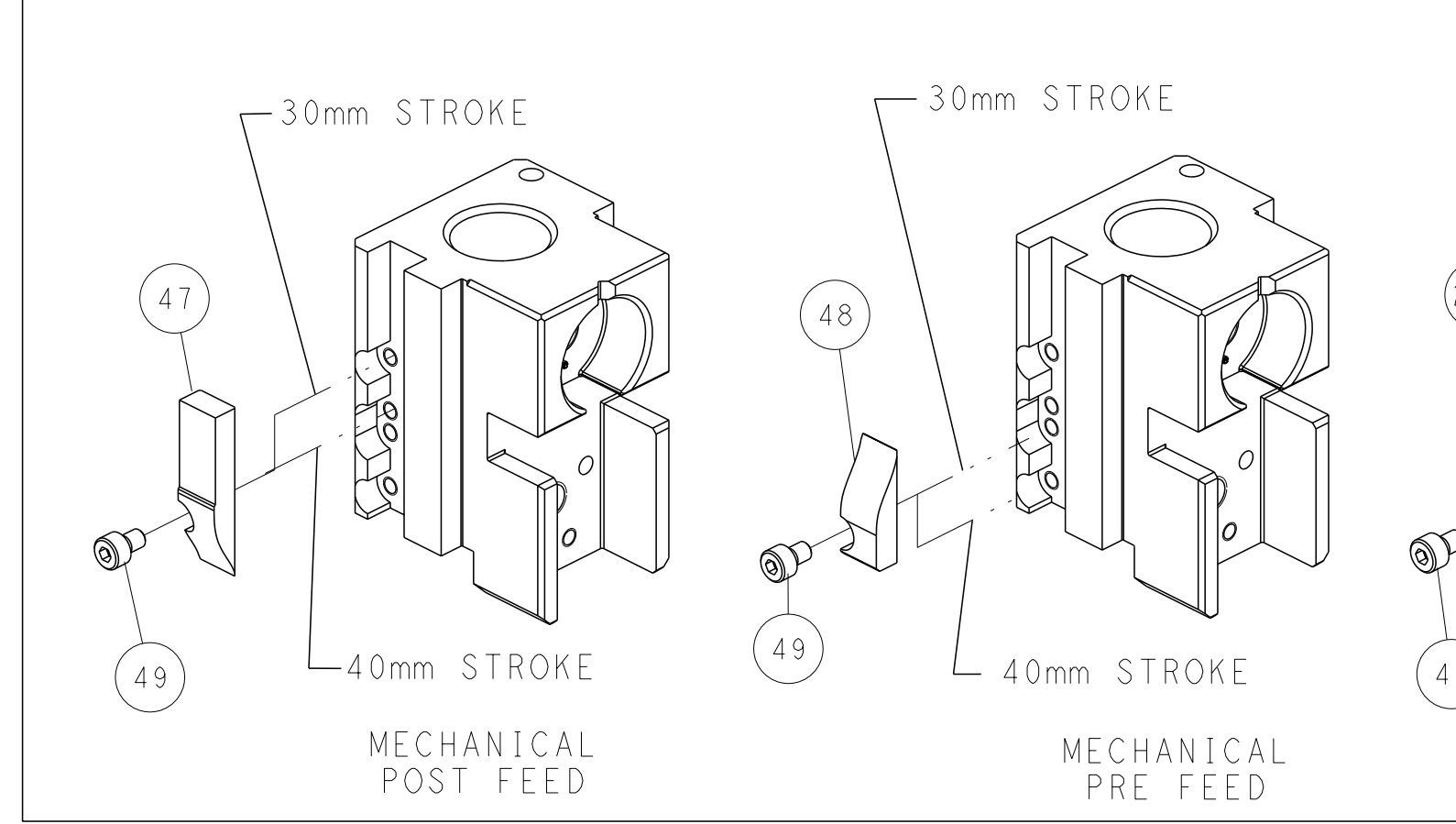
PNEUMATIC



SERVO LATCH PLATE

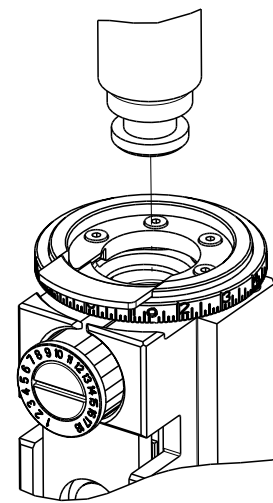


CAM POSITIONS

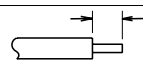


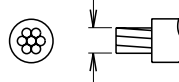
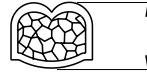
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X. ZHAO 18AUG2014		CHK L. ZHANG 18AUG2014		APVD T. ELBIN 18AUG2014		NAME Ocean Side Feed Applicator	
mm		0 PLC ±.5		1 PLC ±0.5		2 PLC ±0.13		3 PLC ±0.013		4 PLC ±0.0001	
FINISH		-		-		-		-		-	
MATERIAL		-		-		-		-		-	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 2 of 4		REV A		RESTRICTED TO		-	

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266452-1	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	-	8-2266452-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266452-4	-	-	-
	2-2266452-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266452-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266452-4	-	-	-
	2-2266452-5	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
2-2266452-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266452-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.54 mm [.100]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MPE		TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: MPE		TERMINAL	
WIRE STRIP LENGTH 2.53-3.29 mm [.100-.130 IN]			INSULATION DIAMETER RANGE Ø1.60-2.10 mm [.063-.083 IN]
TERMINAL APPLICATION SPECIFICATION		NONE	-
TERMINALS APPLIED			
TE TERMINAL	MPE	TERMINAL	TE TERMINAL
2113558-1		707-1-TX-XR	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
18 AWG		1.13+/-0.05 [.044+/- .002]		6.0
20 AWG		0.97+/-0.05 [.038+/- .002]		7.7
22 AWG		0.90+/-0.05 [.035+/- .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: 8-2266452-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266452-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266452-5
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.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-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	DIST 66	REVISIONS			
P	LYR	DESCRIPTION		DATE	OWN	APVD
	-	SEE SHEET 1		-	-	-

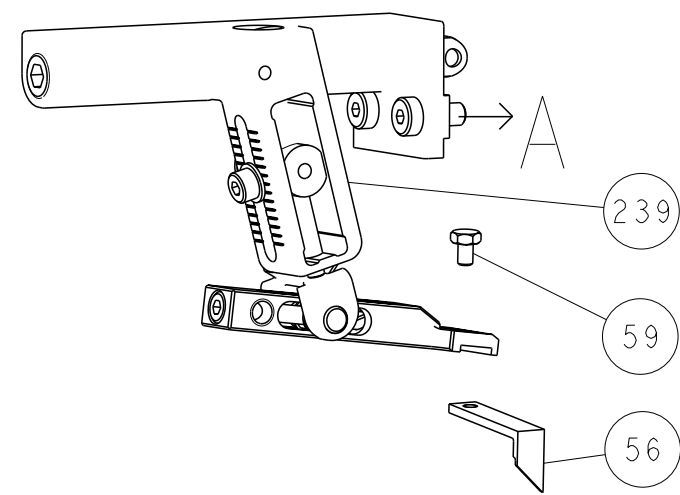
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 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	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	1	1	1338683-8	FEED PAWL	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	690753-6	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	2119533-4	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	3-1803057-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119780-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	1-238011-6	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	5-2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1	1	4-456404-6	CRIMPER, WIRE PREMIUM	1

-77-27-25-22-21		PART NO		DESCRIPTION			ITEM NO
UNCONTROLLED DOCUMENT FOR TEO ELECTRONICS CORPORATION THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. FOR THE LATEST REVISION, CONTACT THE ENGINEERING DEPARTMENT. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	18AUG2014		
				CHK	18AUG2014		
				APVD	18AUG2014		
TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME			
0 PLC ±.5				PRODUCT SPEC			
1 PLC ±0.5				APPLICATION SPEC			
2 PLC ±0.13				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
3 PLC ±0.013				A1	00779	C=2266452	-
4 PLC ±0.0001				WEIGHT	-	SCALE	1:2
ANGLES FINISH				Customer Accessible Production Drawing	SHEET	3	OF 4
				REV	A		

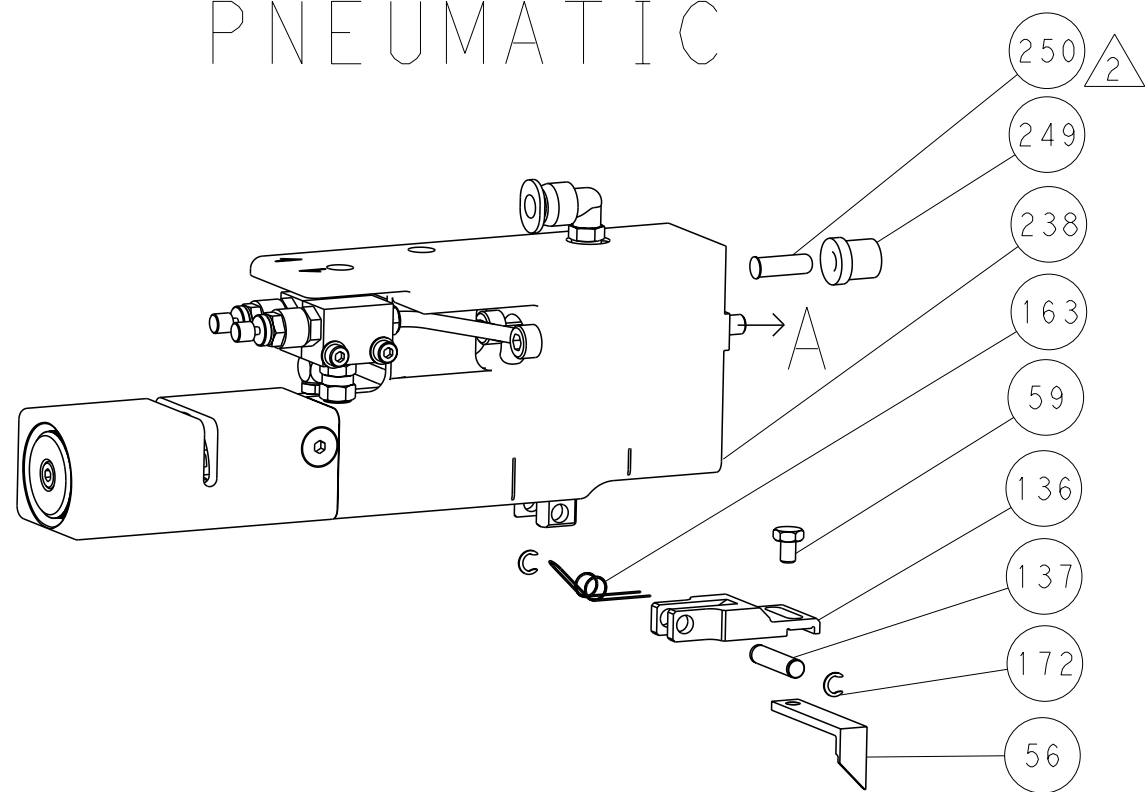
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

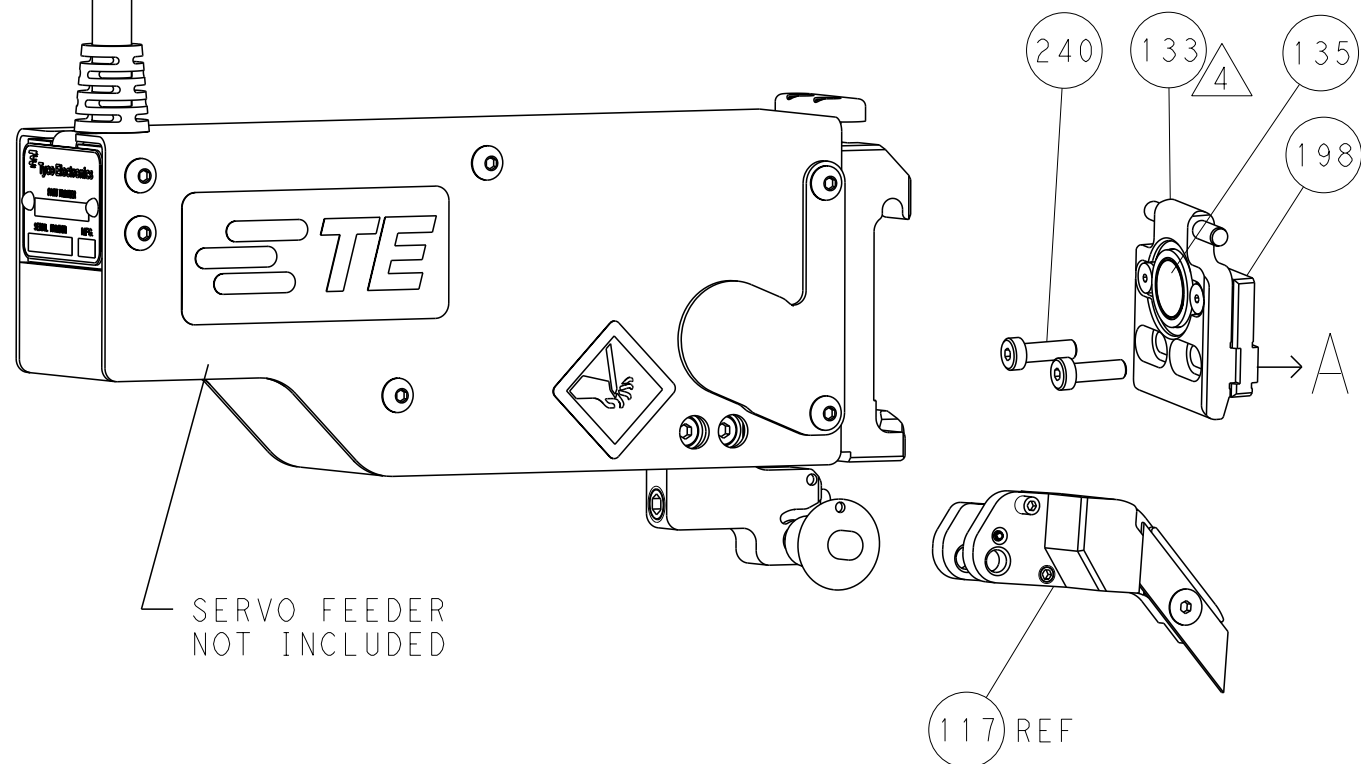
FEED TYPE MECHANICAL



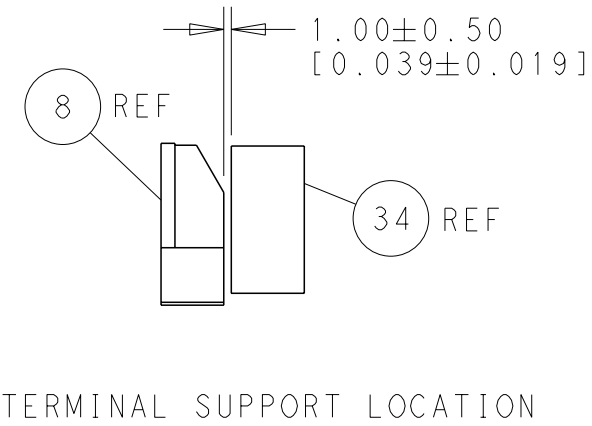
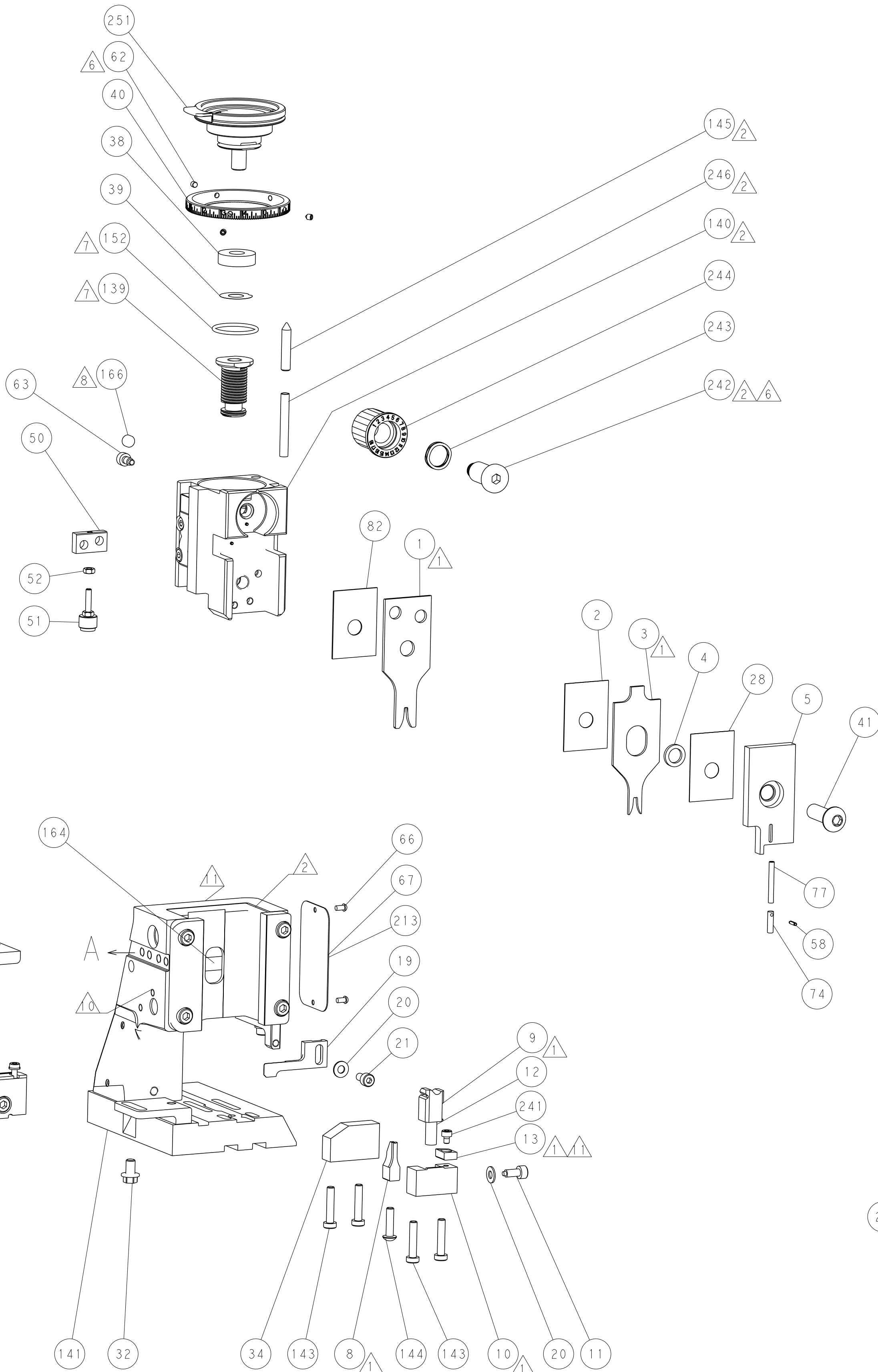
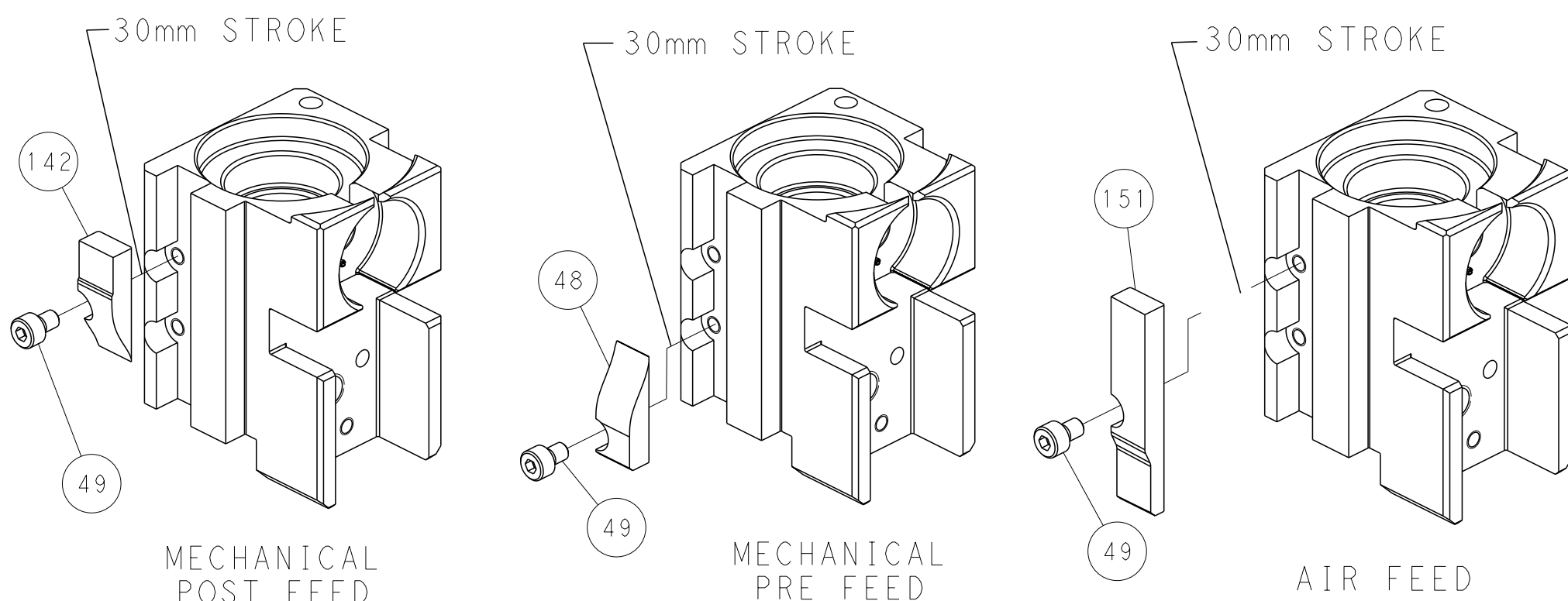
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT
FRONT HOLES

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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X. ZHAO 18AUG2014		NAME Ocean Side Feed Applicator	
mm		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001		CHK L. ZHANG 18AUG2014		RESTRICTED TO	
FINISH		-		APVD T. ELBIN 18AUG2014		SIZE A1	
MATERIAL		-		PRODUCT SPEC		CAGE CODE 00779	
				APPLICATION SPEC		DRAWING NO C=2266452	
				WEIGHT		SCALE 1:2	
				Customer Accessible Production Drawing		SHEET 4	
						OF 4	
						REV A	

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