

87

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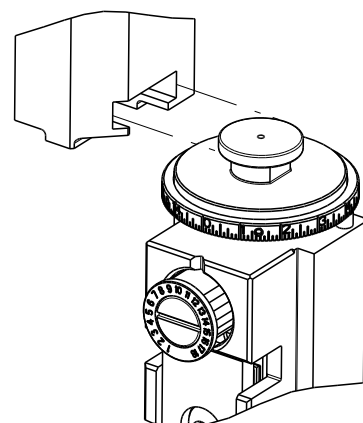
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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

REVISION

DESCRIPTION



2266556-1

B

FINE CRIMP HEIGHT ADJUST

2266556-2

B

FINE CRIMP HEIGHT ADJUST

2266556-5

B

FINE CRIMP HEIGHT ADJUST

2266556-6

B

NON-CRIMP HEIGHT ADJUST

2266556-7

B

FINE CRIMP HEIGHT ADJUST

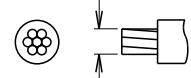
7-2266556-7

B

CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.84 mm [.033]	F
INSUL	1.40 mm [.055]	O
STABILIZER	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP QUICK CRIMP CONTACT			
WIRE STRIP LENGTH 2.80-3.20 mm [.110-.126 IN]			INSULATION DIAMETER RANGE Ø 1.10mm MAX [.043 IN MAX]
TERMINAL APPLICATION SPECIFICATION	114-18013	-	-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927985-1	1-927985-1	1-927985-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
24 AWG		0.72+/-0.05 [.028+/- .002]		4.7
26 AWG		0.66+/-0.05 [.026+/- .002]		5.4
28 AWG		0.63+/-0.05 [.025+/- .002]		5.7



- 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: 8-2266556-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266556-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266556-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266556-6
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 5.08.
- 13 TERMINAL LUBRICANT IS RECOMMENDED.

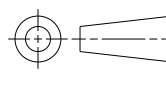
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	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	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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	OWN	APVD
	A	RELEASED		20JAN2015	RK	GB
	B	ECR-19-000387		10JAN2019	TB	GB

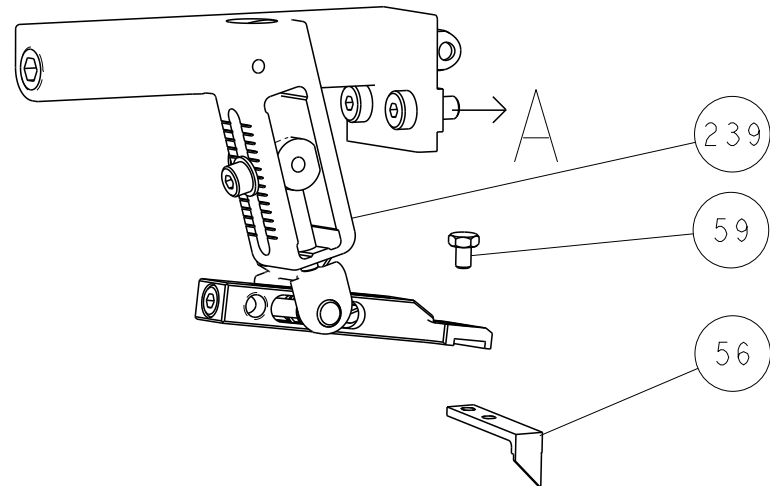
6	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
	-	-	1	1	-	-	2119740-2	TAG,IDENTIFICATION	213
	-	-	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
	-	1	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
	-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
13	-	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	-	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
6	-	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
	-	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	1-2119644-4	RAM WASHER, PRECISION	38
6	-	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	1752356-3	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	1320908-6	SPACER, STRIP GUIDE	30
	-	1	1	1	1	1	1901086-5	PLATE, STRIP GUIDE	29
	-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
	-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	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	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	1	1803095-5	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1	1803798-1	ANVIL, WITH STABILIZER	8
	-	-	-	-	-	-	-	-	7
	1	1	1	1	1	1	7-456402-5	CRIMPER, WIRE PREMIUM	6
	-	1	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1	1-1803019-8	CRIMPER, INSULATION O	3
	-	-	-	-	-	-	-	-	2
	1	1	1	1	1	1	5-1633713-9	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO	

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS OF THIS DRAWING. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.		OWN T. YIN	23OCT2014	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY	23OCT2014		
		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator	RESTRICTED TO
MATERIAL -		APVD J. GUO		SIZE A1	
		APPLICATION SPEC		CAGE CODE 00779	DRAWING NO 2266556
		WEIGHT -		Customer Accessible Production Drawing	
		SCALE 1:2		SHEET 1	OF 4
		REV B			

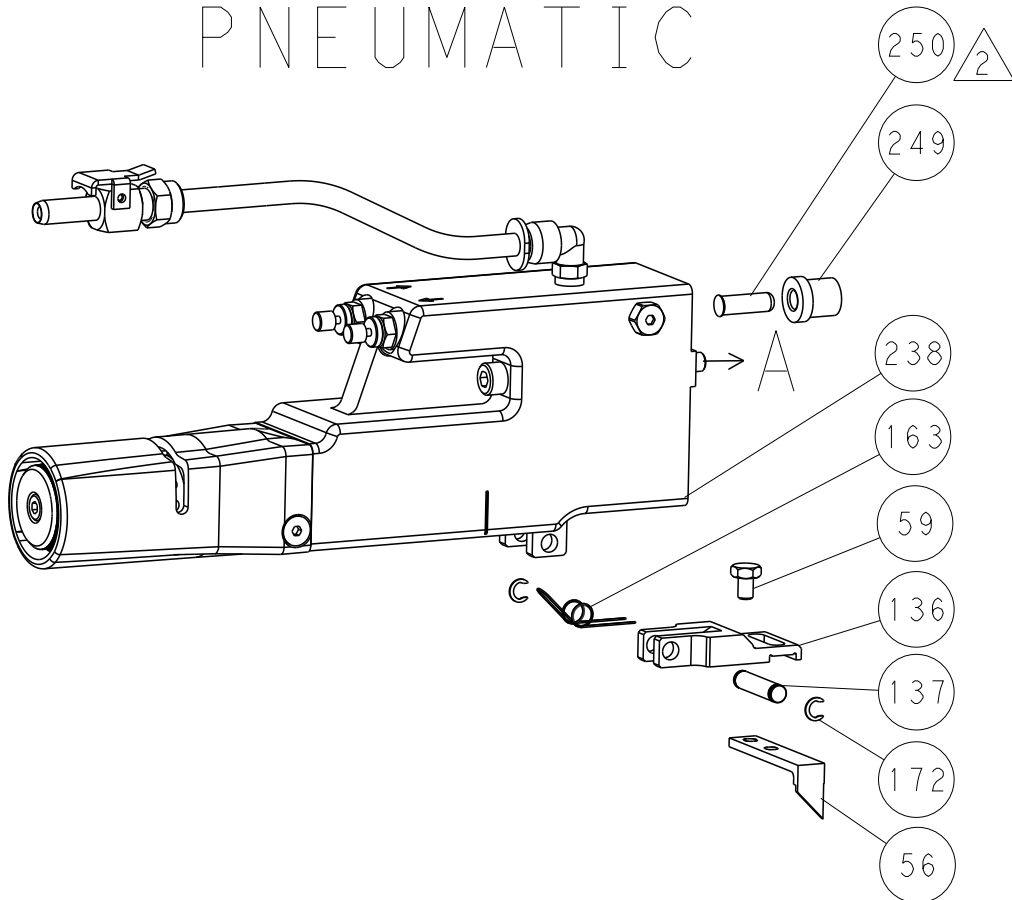
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

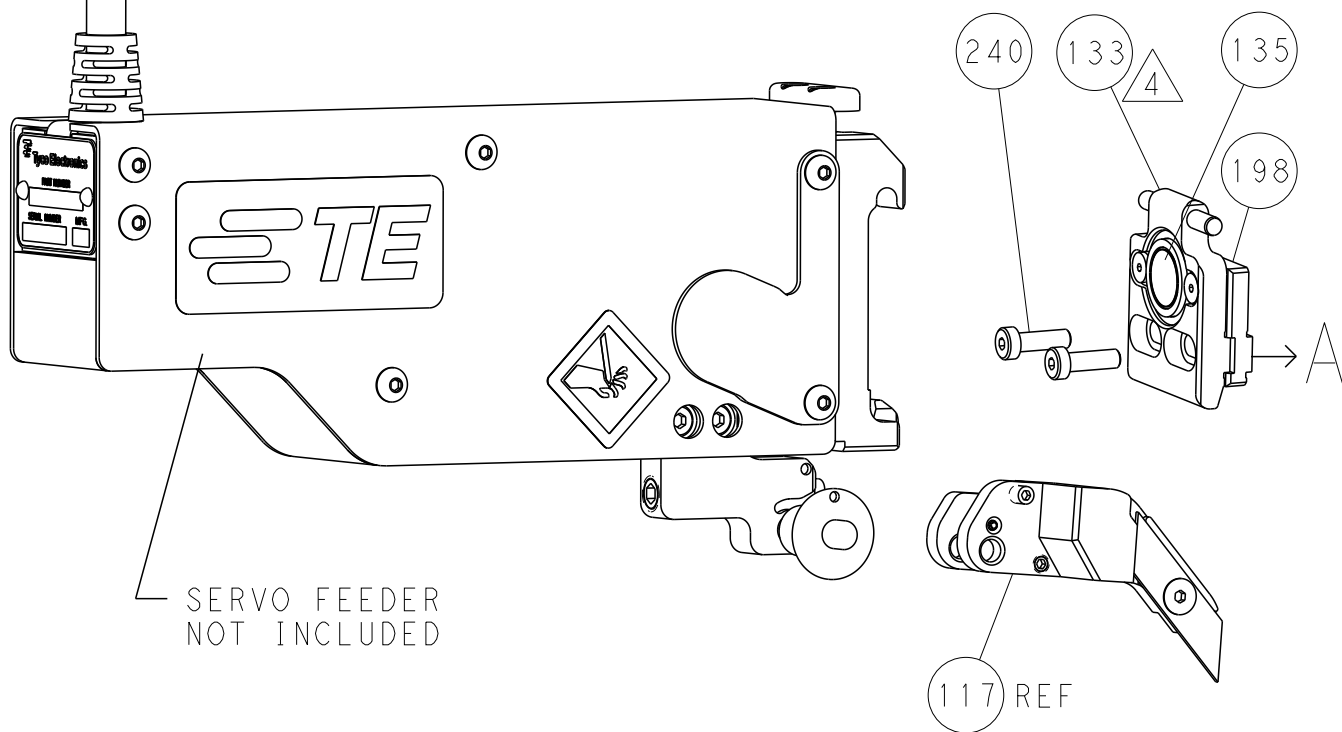
FEED TYPE
MECHANICAL



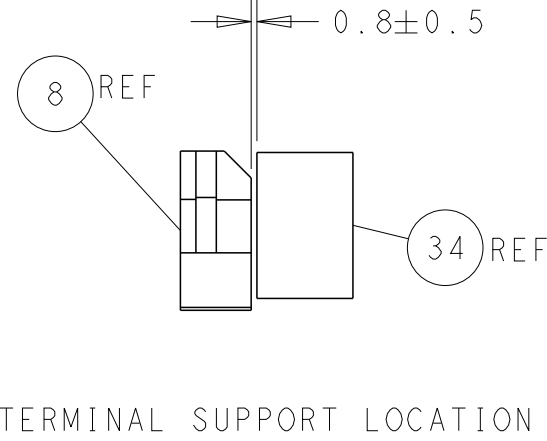
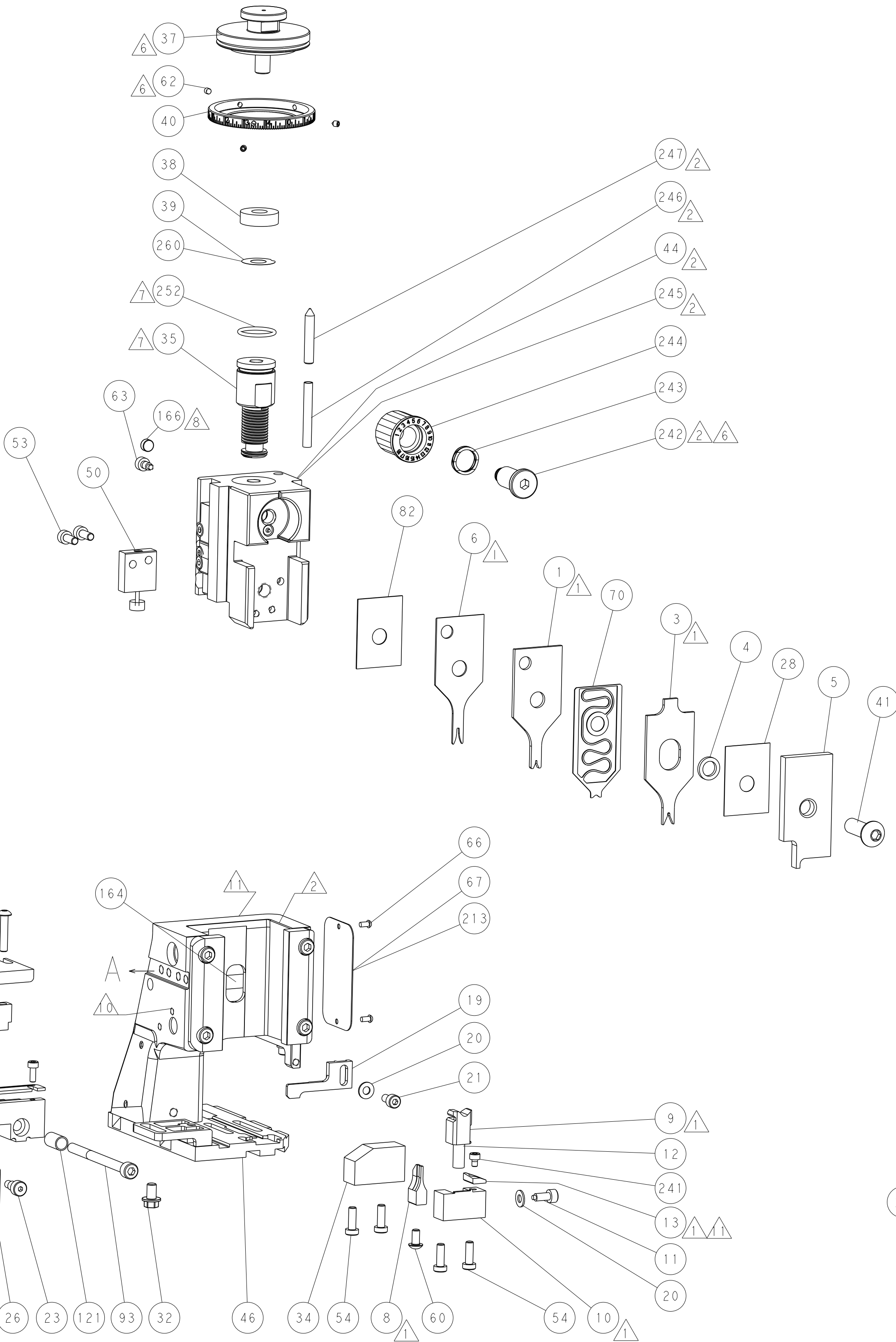
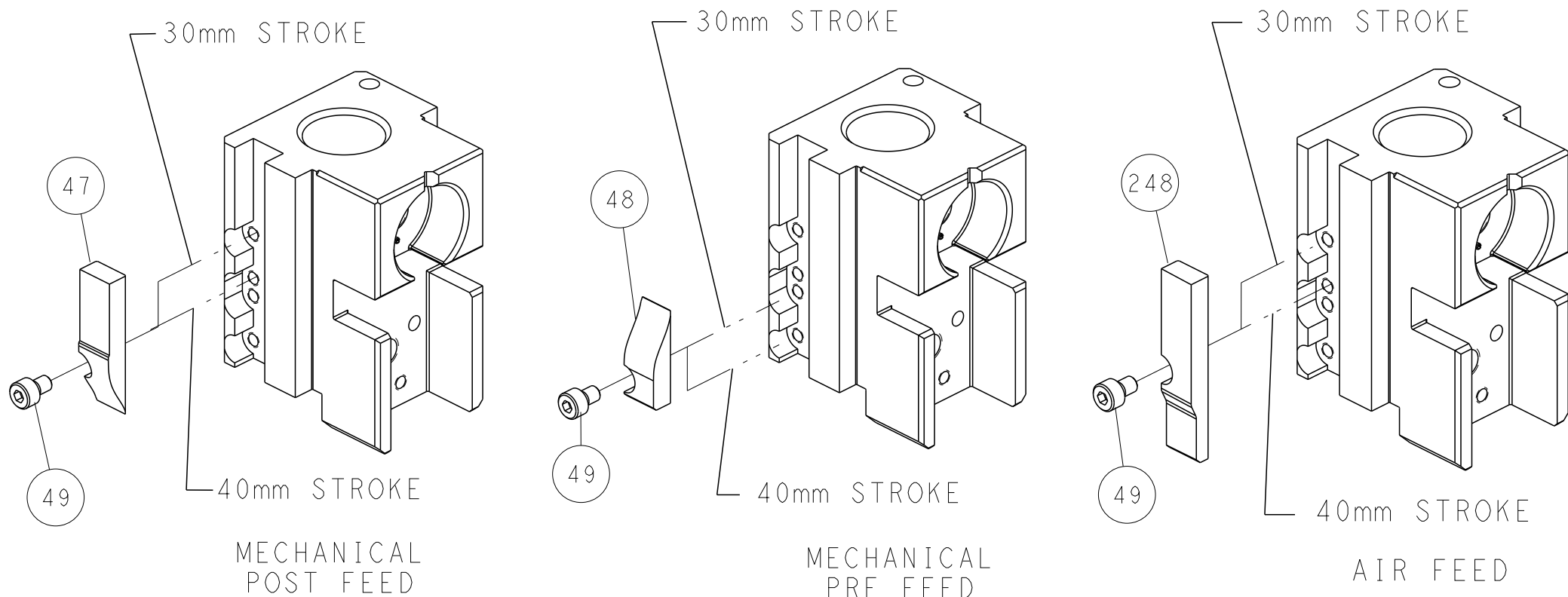
PNEUMATIC



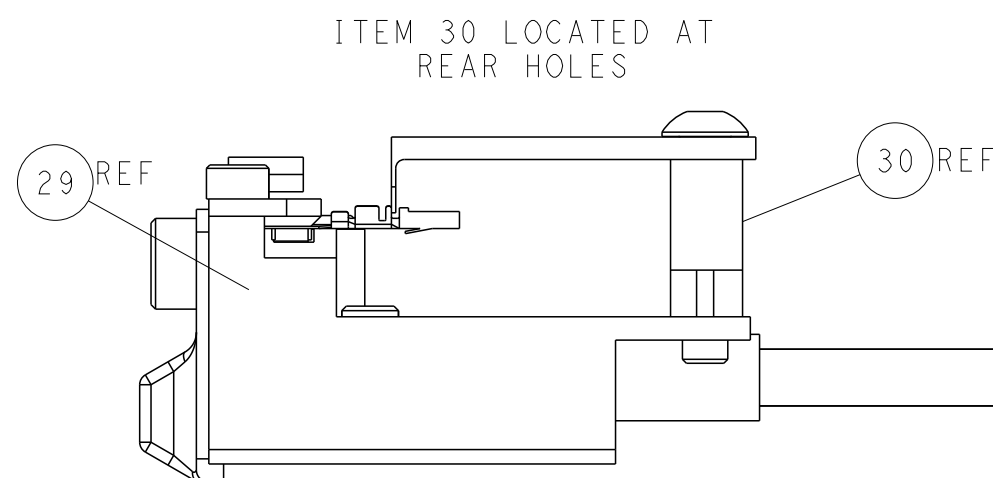
SERVO
LATCH PLATE



CAM POSITIONS

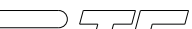


TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

(1) UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO CONTACT THE MANUFACTURER FOR THE LATEST VERSION.					DWN	23OCT2014		 TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS:					CHK	23OCT2014				
mm					APVD	23OCT2014		NAME Ocean Side Feed Applicator -		
TOLERANCES UNLESS OTHERWISE SPECIFIED:					PRODUCT SPEC		SIZE			
0 PLC					±		CAGE CODE			
1 PLC					±		DRAWING NO			
2 PLC					±		RESTRICTED TO			
3 PLC					±		00779			
4 PLC					±		©=2266556			
ANGLES					FINISH		Customer Accessible Production Drawing			
MATERIAL					WEIGHT		SCALE			
-					-		1:2			
							SHEET 2 OF 4			
							REV B			

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

D

C

B

A

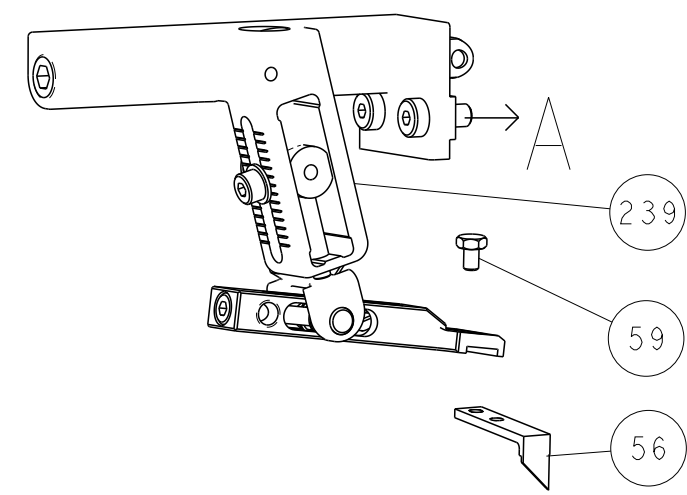
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C

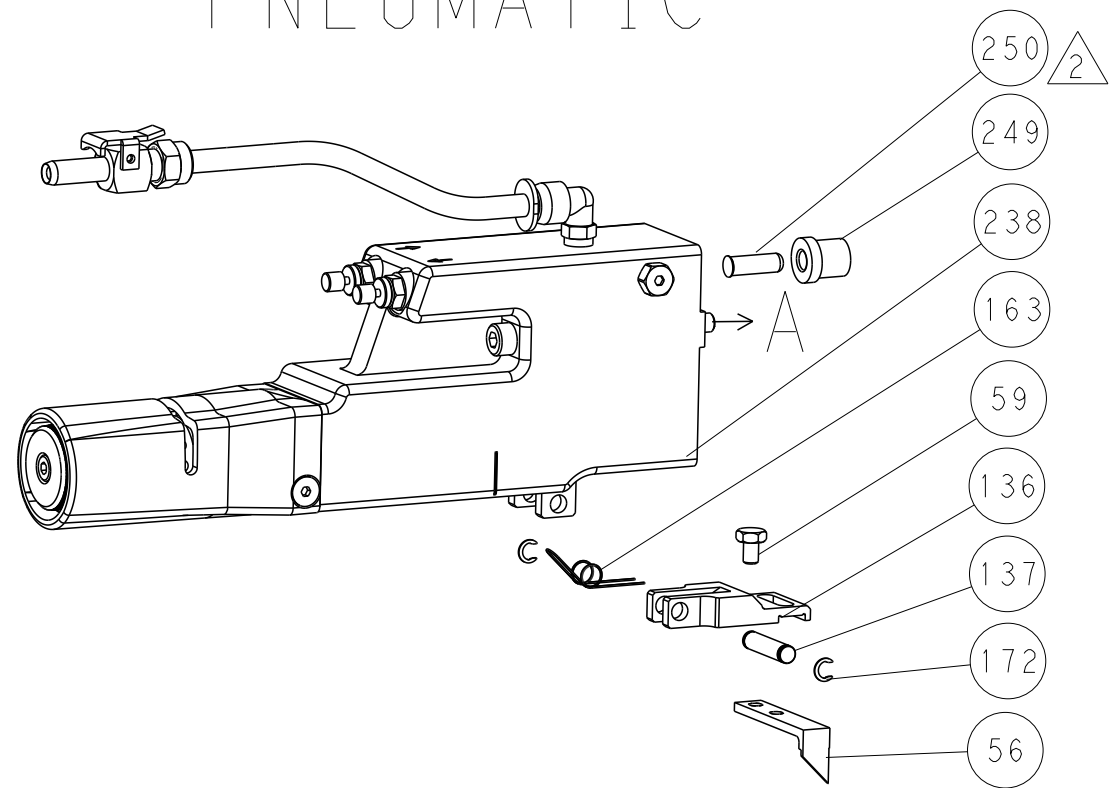
B

A

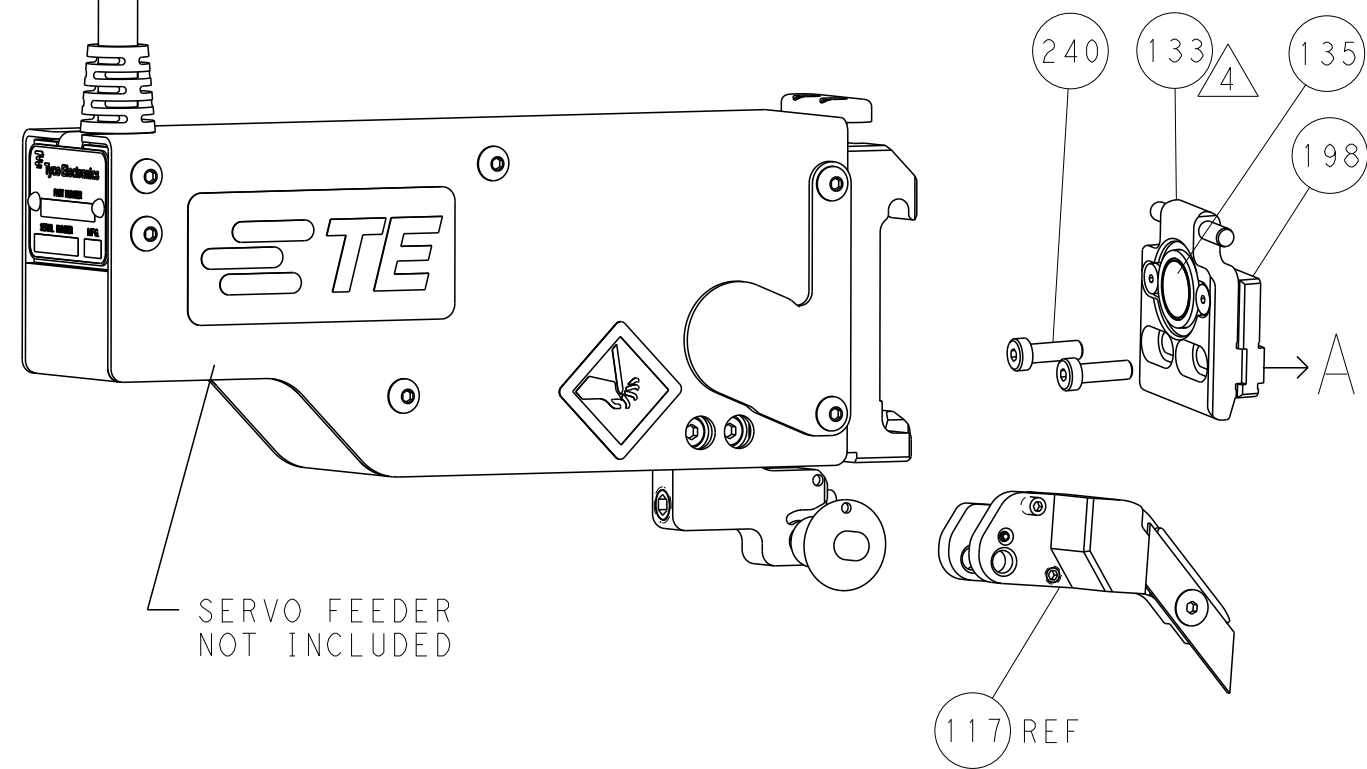
FEED TYPE MECHANICAL



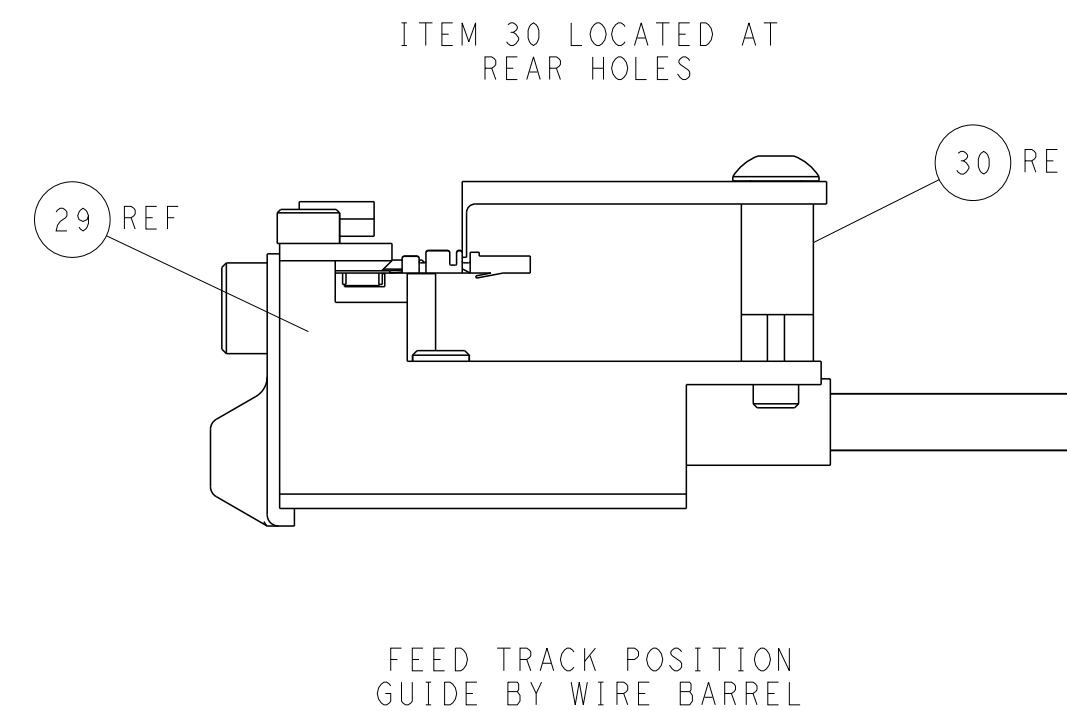
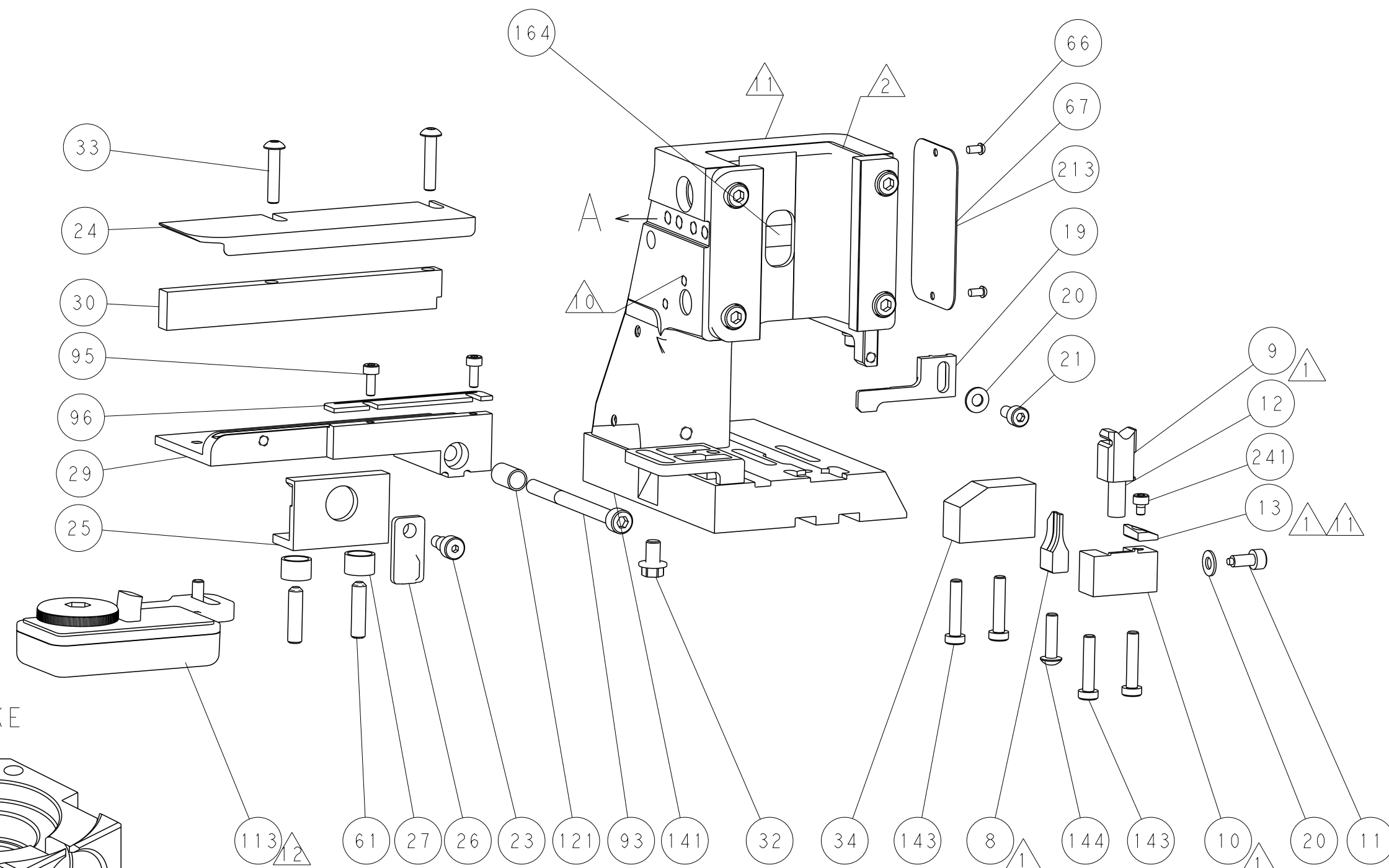
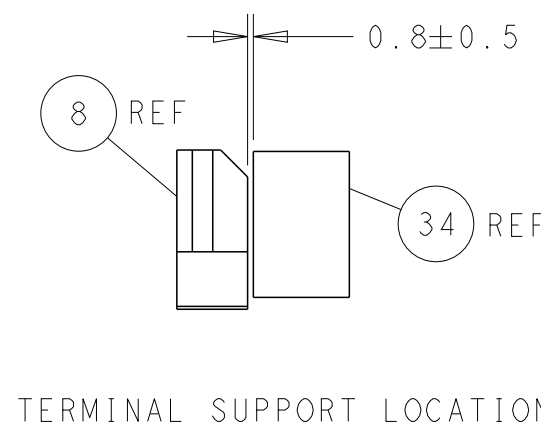
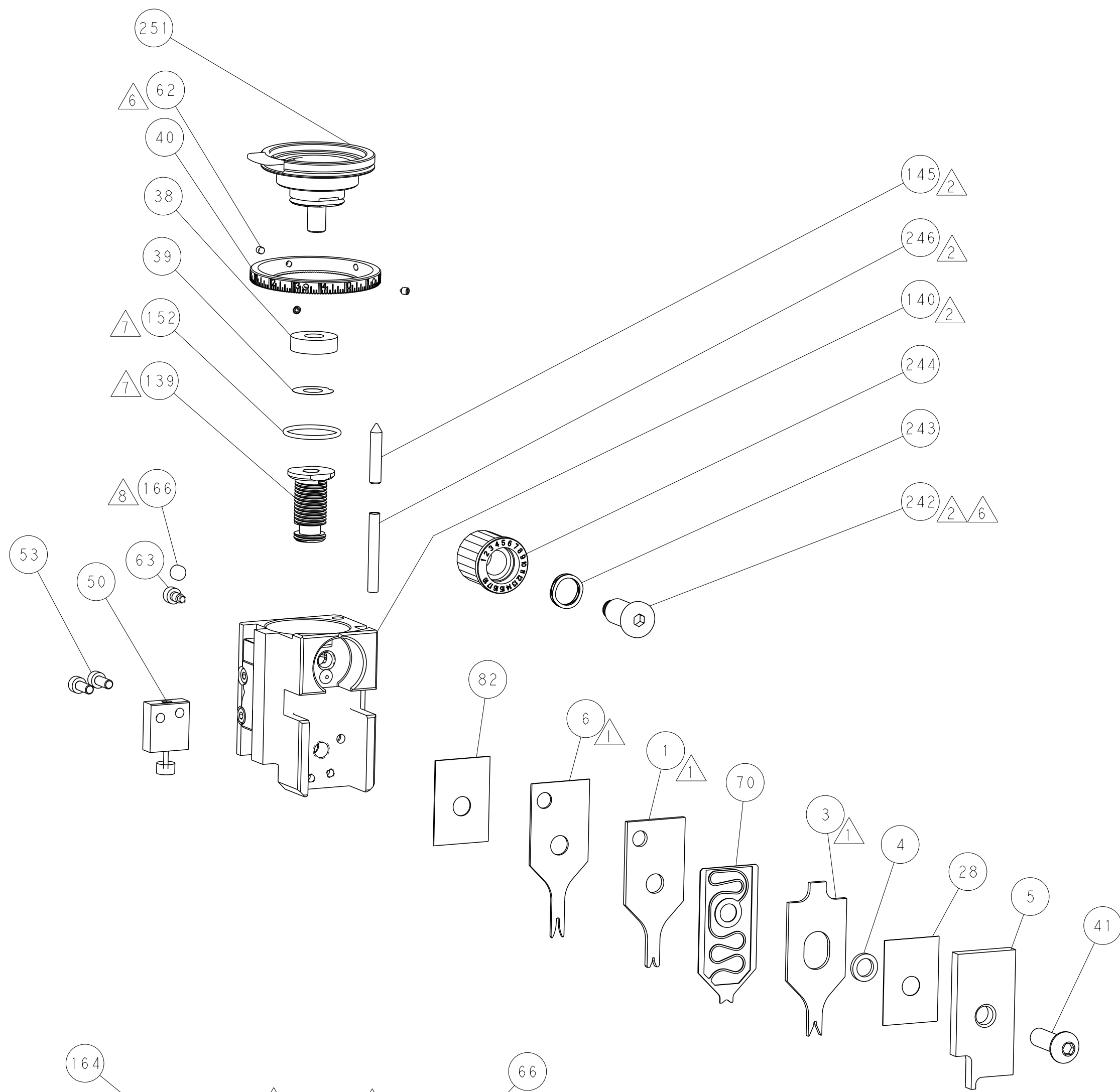
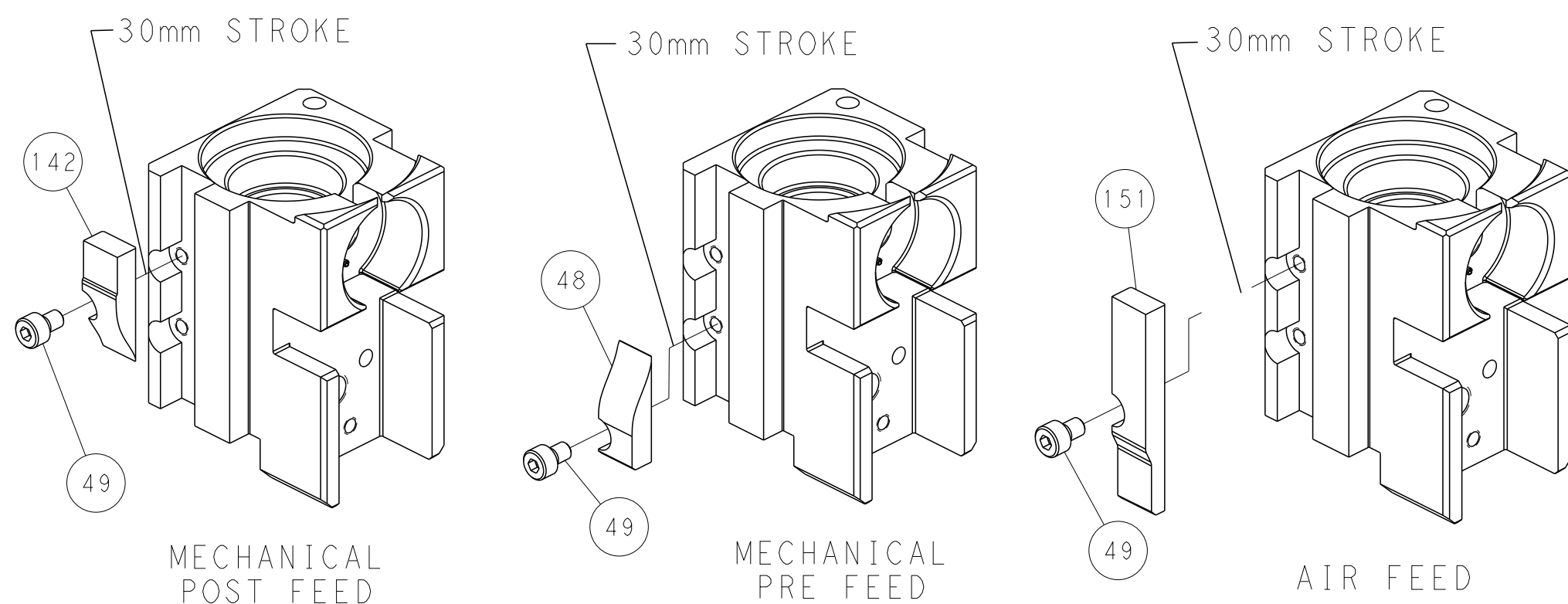
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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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		CHK G. BAILEY	23OCT2014		
		APVD J. GUO	23OCT2014	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE A1	
		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH -		CAGE CODE 00779	
MATERIAL -		WEIGHT -		Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 4 of 4	
				REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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[2266556-1](#)