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	ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
		2266066-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
		2266066-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
		2266066-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
		2266066-6	A	NON-CRIMP HEIGHT ADJUST	⁴ SERVO LATCH PLATE ¹²
		2266066-7	A	FINE CRIMP HEIGHT ADJUST	NONE
		7-2266066-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	3.30 mm [1.130]	O

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION	
TERMINAL NAME: DLO40 SEALED TERMINAL, FEMALE S TYPE	
WIRE STRIP LENGTH 4.50-5.00 mm [.177-.197 IN]	INSULATION DIAMETER RANGE Ø 2.84mm MAX [.112 IN MAX]
TERMINAL APPLICATION SPECIFICATION	SUMITOMO SPECIFICATION

TERMINALS APPLIED				
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	CABLE DIAMETER
1572256-1	8100-1466	1572386-1	7165-0621	1.6mm-1.9mm
		1832971-1	7165-0621	1.6mm-1.9mm

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		0.90+/-0.05 [.035+/-0.002]		8.8
0.30mm2		0.80+/-0.05 [.031+/-0.002]		9.8



- 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: 8-2266066-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266066-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266066-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266066-6
- 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 ITEMS 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
- 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 4.90.
- 13

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 14

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.

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION	
TERMINAL NAME: DLO40 SEALED TERMINAL, MALE S TYPE	
WIRE STRIP LENGTH 4.50-5.00 mm [.177-.197 IN]	INSULATION DIAMETER RANGE Ø 2.84mm MAX [.112 IN MAX]
TERMINAL APPLICATION SPECIFICATION	SUMITOMO SPECIFICATION

TERMINALS APPLIED				
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	CABLE DIAMETER
1572255-1	8100-2566	2113386-1	7165-0547	1.4mm-1.8mm

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		1.05+/-0.000 [.041+/-0.000]		7.3
0.30mm2		0.95+/-0.000 [.037+/-0.000]		8.3

*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.

							TEC Standard Metric Part Template	
-	-	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
-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)

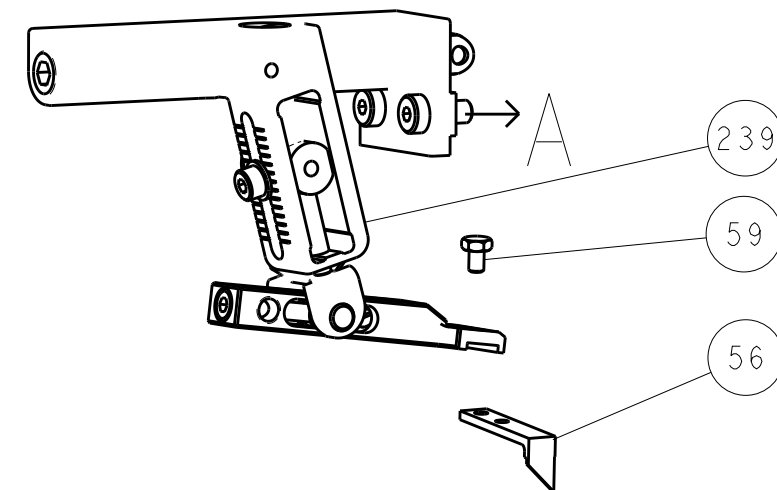
SET UP GAUGE 2119599-1	LOC A	DIS 66	REVISIONS						
			P	LTR	DESCRIPTION	DATE	DWN	APVD	
				A	RELEASED	31OCT2013	BH	GB	

-	-	-	-	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	2119082-7	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
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2119644-1	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	1752356-6	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	1320908-3	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-2	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
-	1	1	1	1	1	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	3-1633928-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	1-240641-7	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	3-1803018-4	CRIMPER, INSULATION O	3
-	1	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1	1	1	8-1673600-5	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

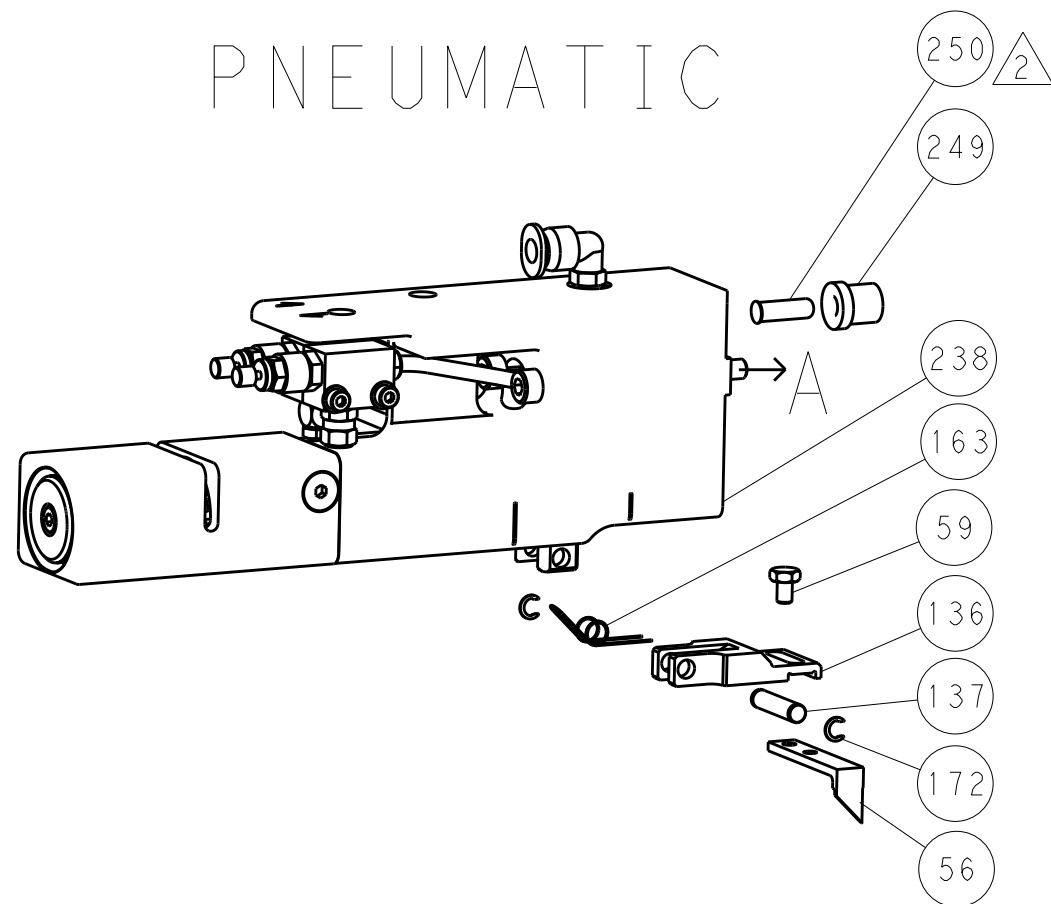
THIS IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE MANUFACTURING ORGANIZATION. NO CHANGES SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN BOB HIGMAN 28SEPT2013	TE Connectivity Harrisburg, PA 17105-3608
				CHK G.BAILEY 28SEPT2013	
				APVD M.CLIFFORD 28SEPT2013	
				NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001		APPLICATION SPEC	
MATERIAL -		FINISH -		WEIGHT -	SIZE A1
				Customer Accessible Production Drawing	SCALE 1:2
				SHEET 1	OF 4
				REV A	

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

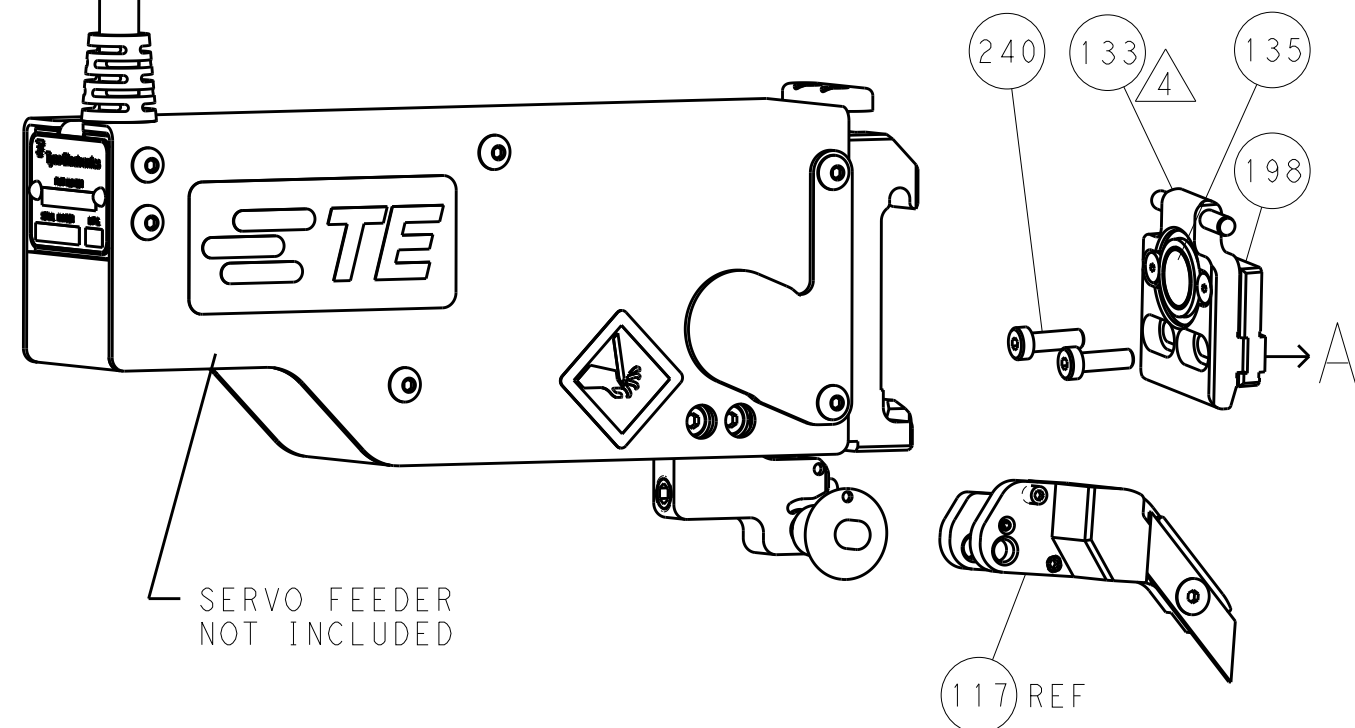
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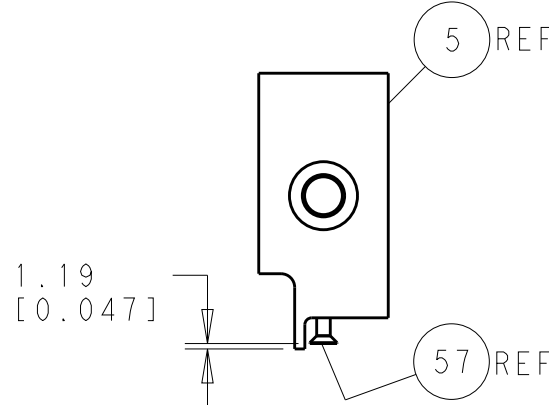
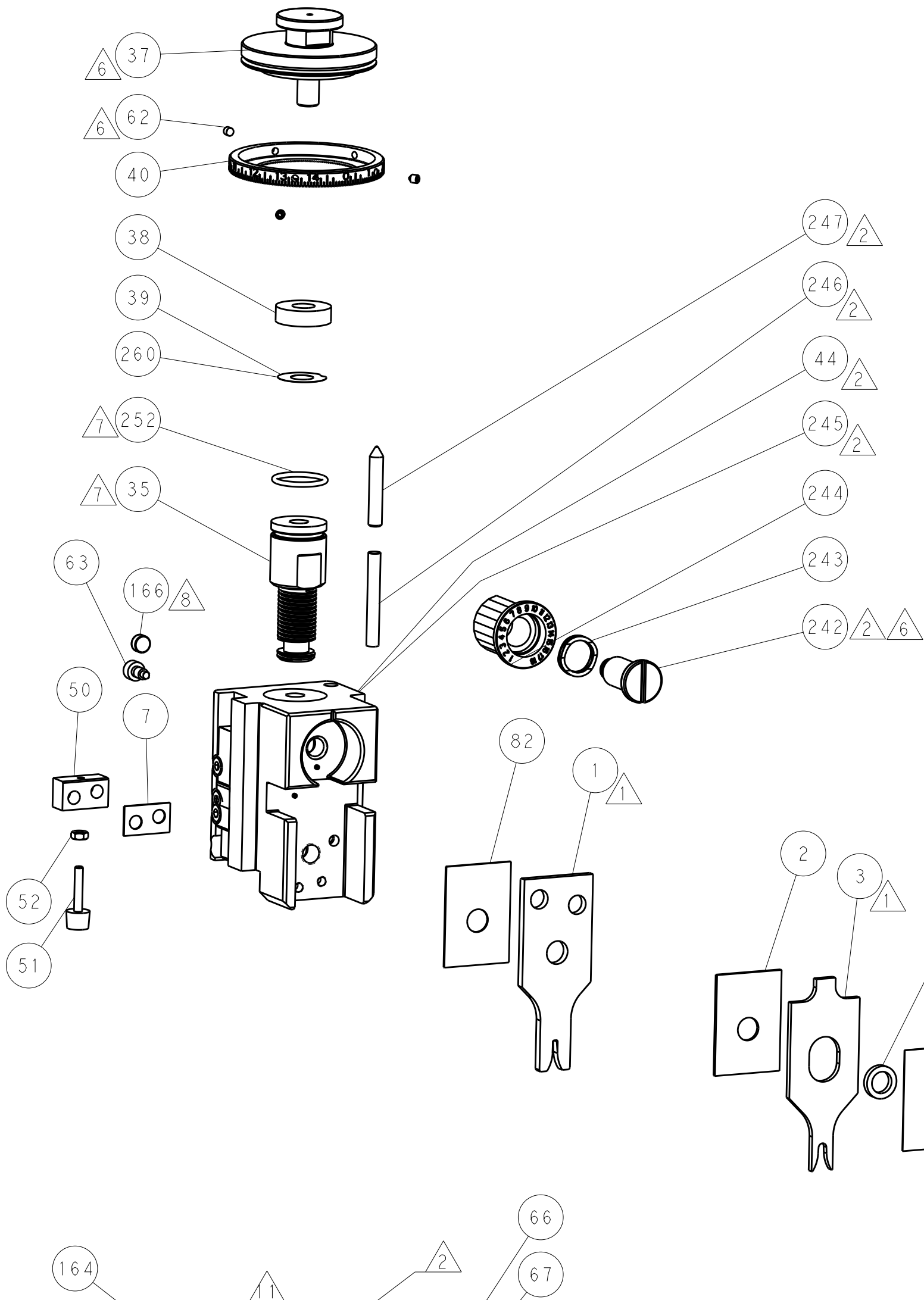
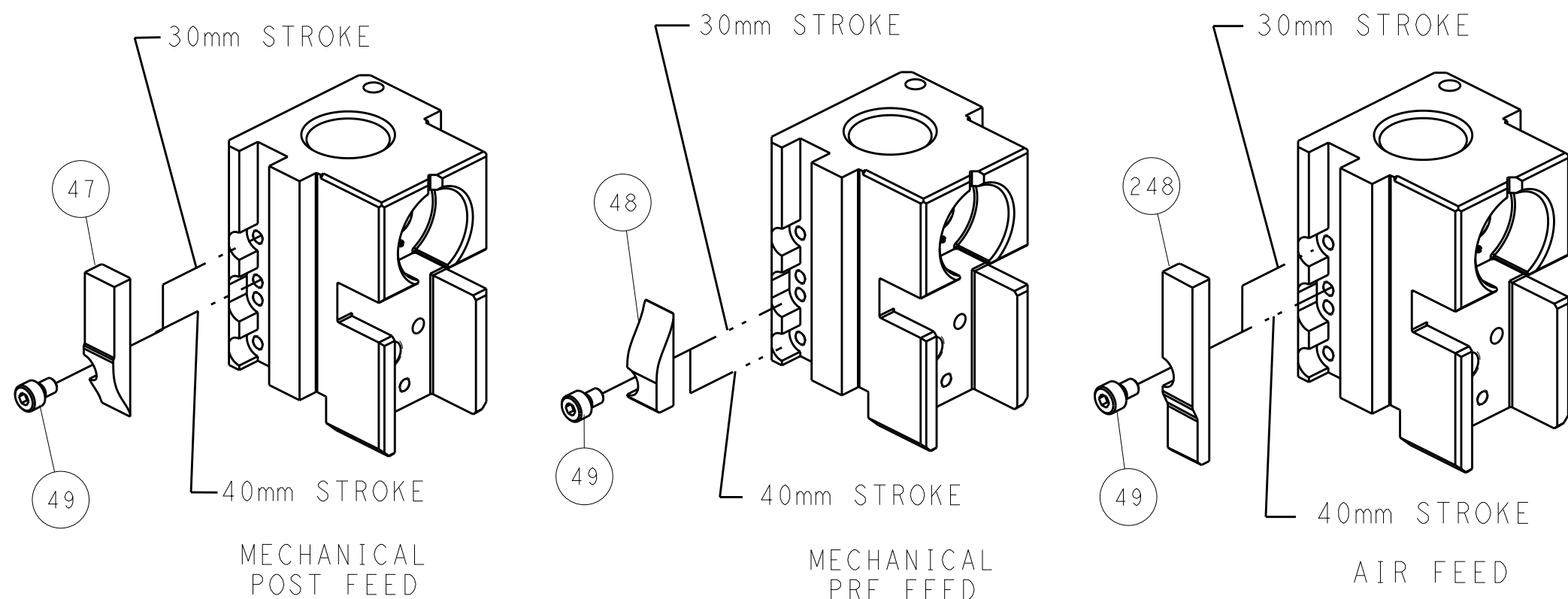
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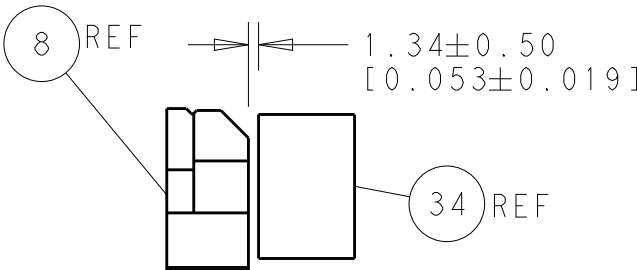
SERVO
LATCH PLATE



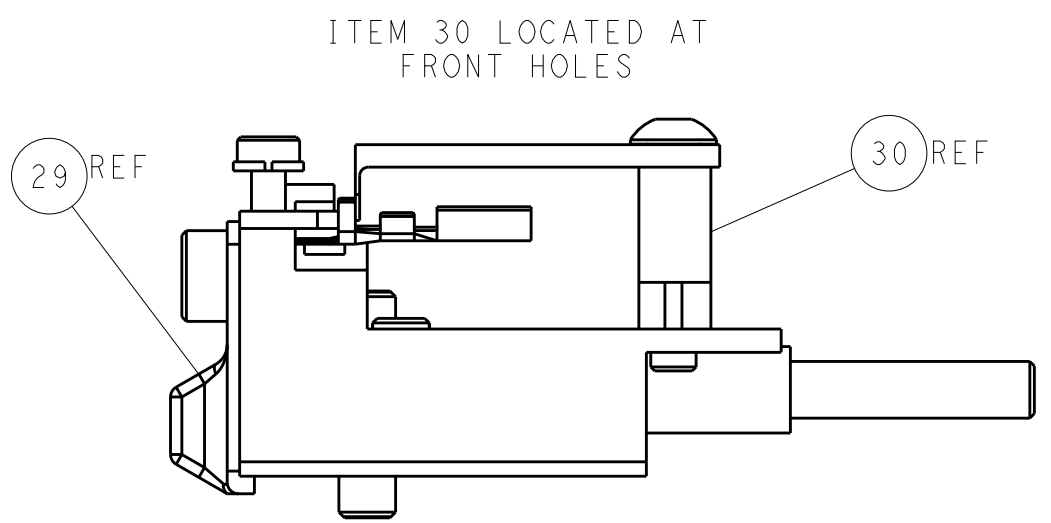
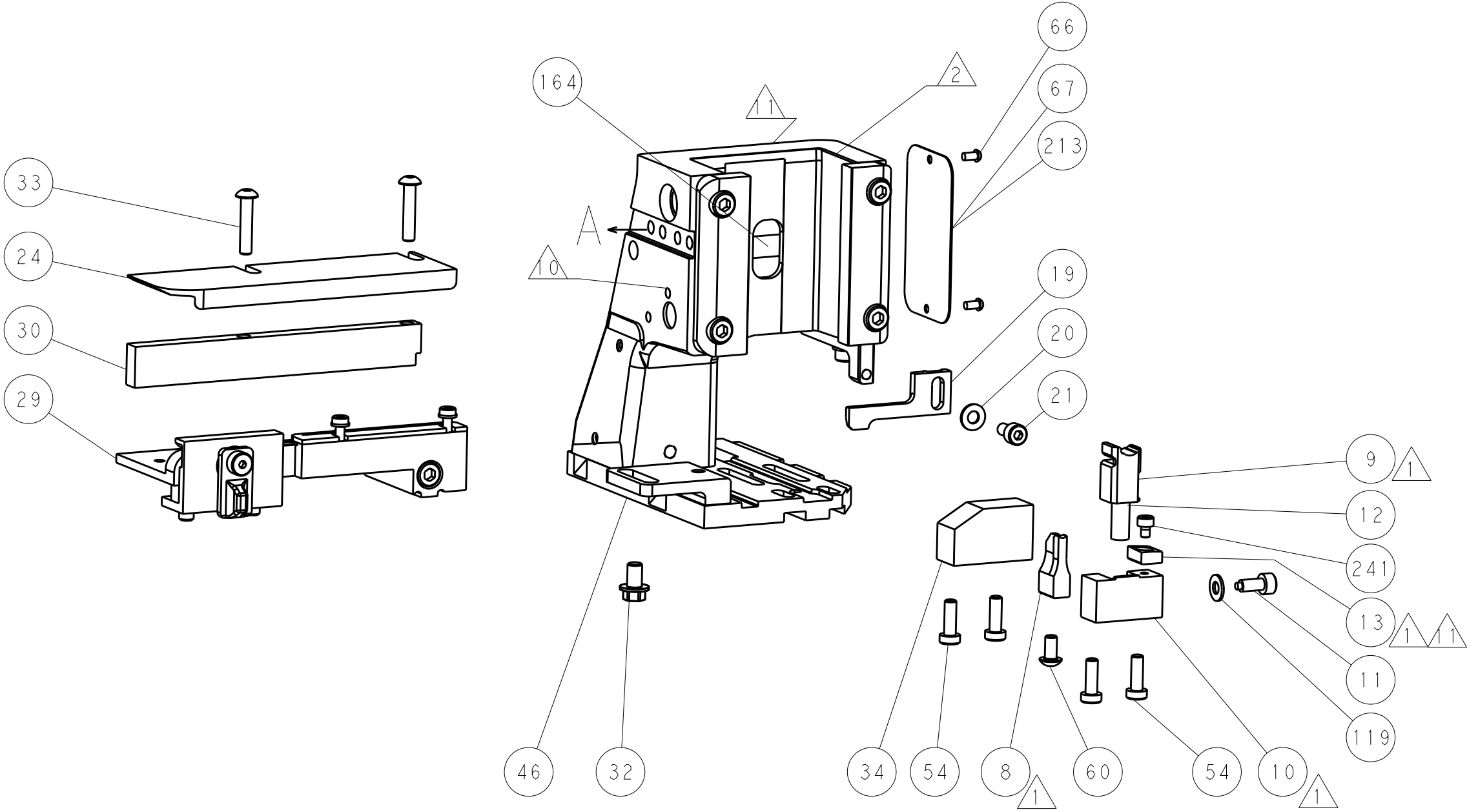
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		28SEPT2013		TE Connectivity	
mm		0 PLC ±0.5		G.BAILEY		28SEPT2013		Harrisburg, PA 17105-3608	
FINISH		1 PLC ±0.13		M.CLIFFORD		28SEPT2013		NAME	
MATERIAL		2 PLC ±0.013		PRODUCT SPEC		-		Ocean Side Feed	
		4 PLC ±0.0001		APPLICATION SPEC		-		Applicator	
		ANGLES		WEIGHT		-		SIZE	
				Customer Accessible Production Drawing		SCALE		1:2	
								SHEET	
								2	
								OF	
								4	
								REV	
								A	

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

D

C

B

A

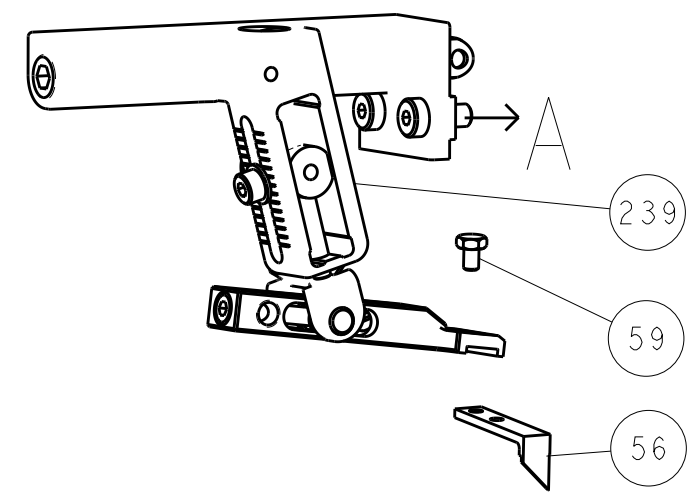
D

C

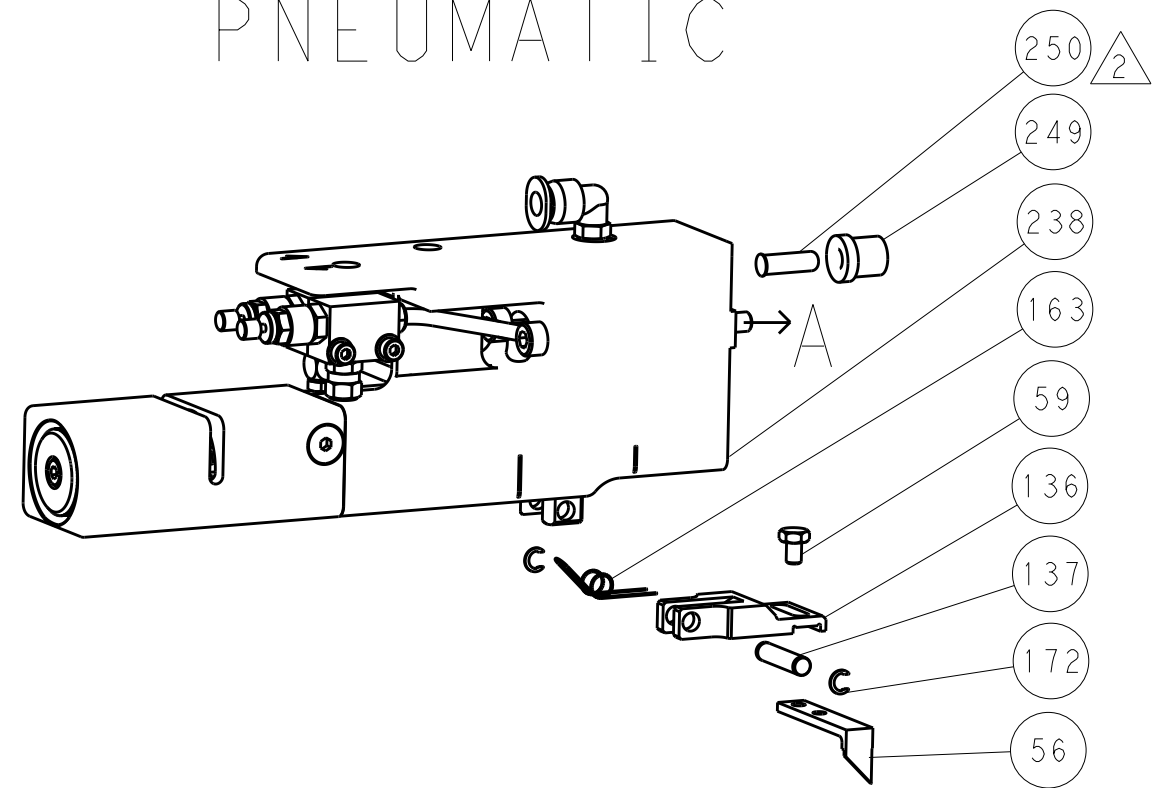
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A

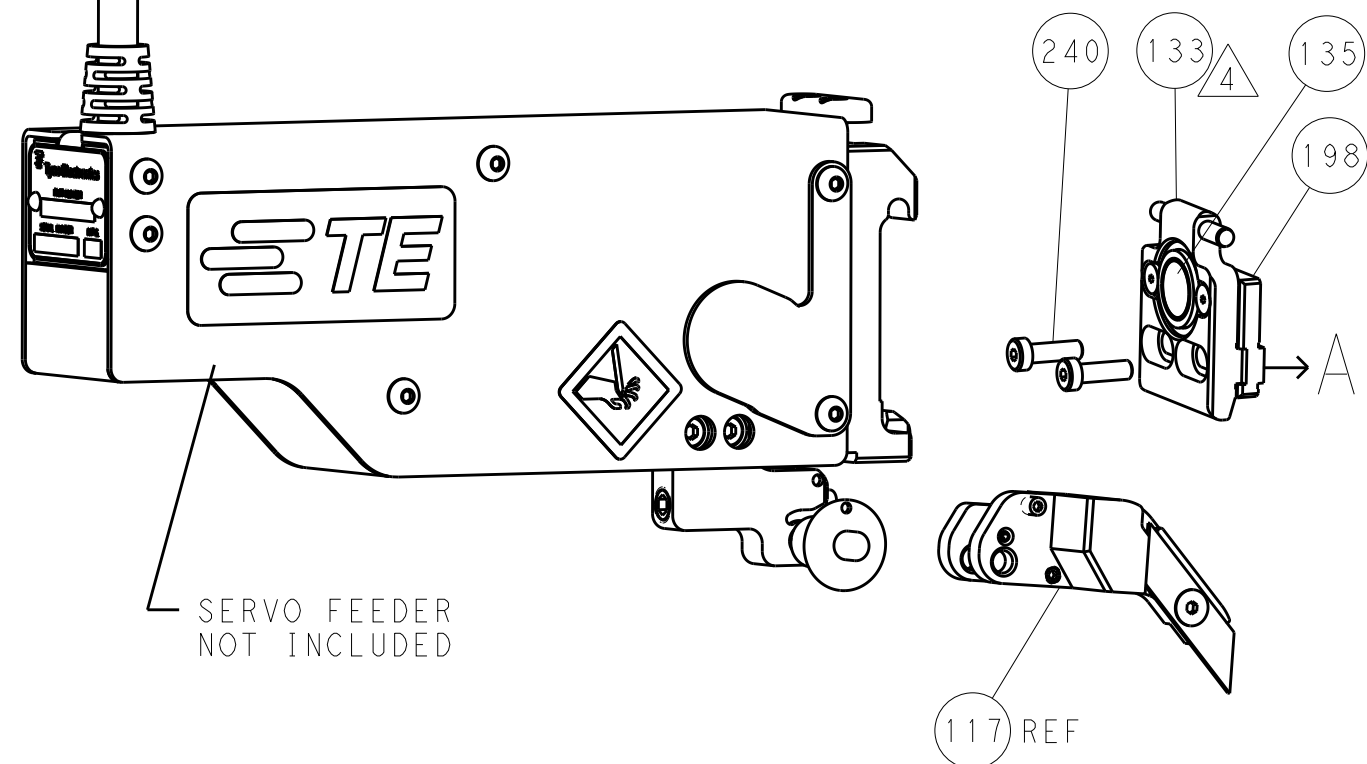
FEED TYPE MECHANICAL



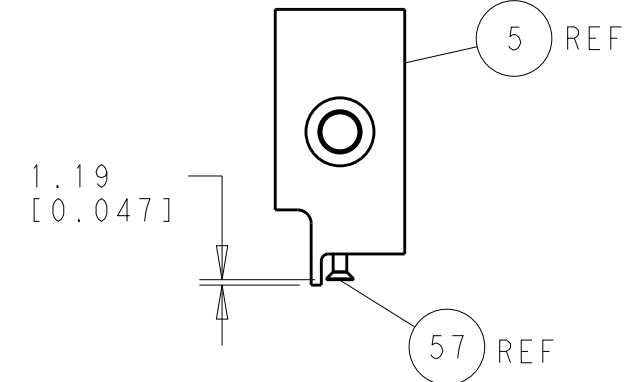
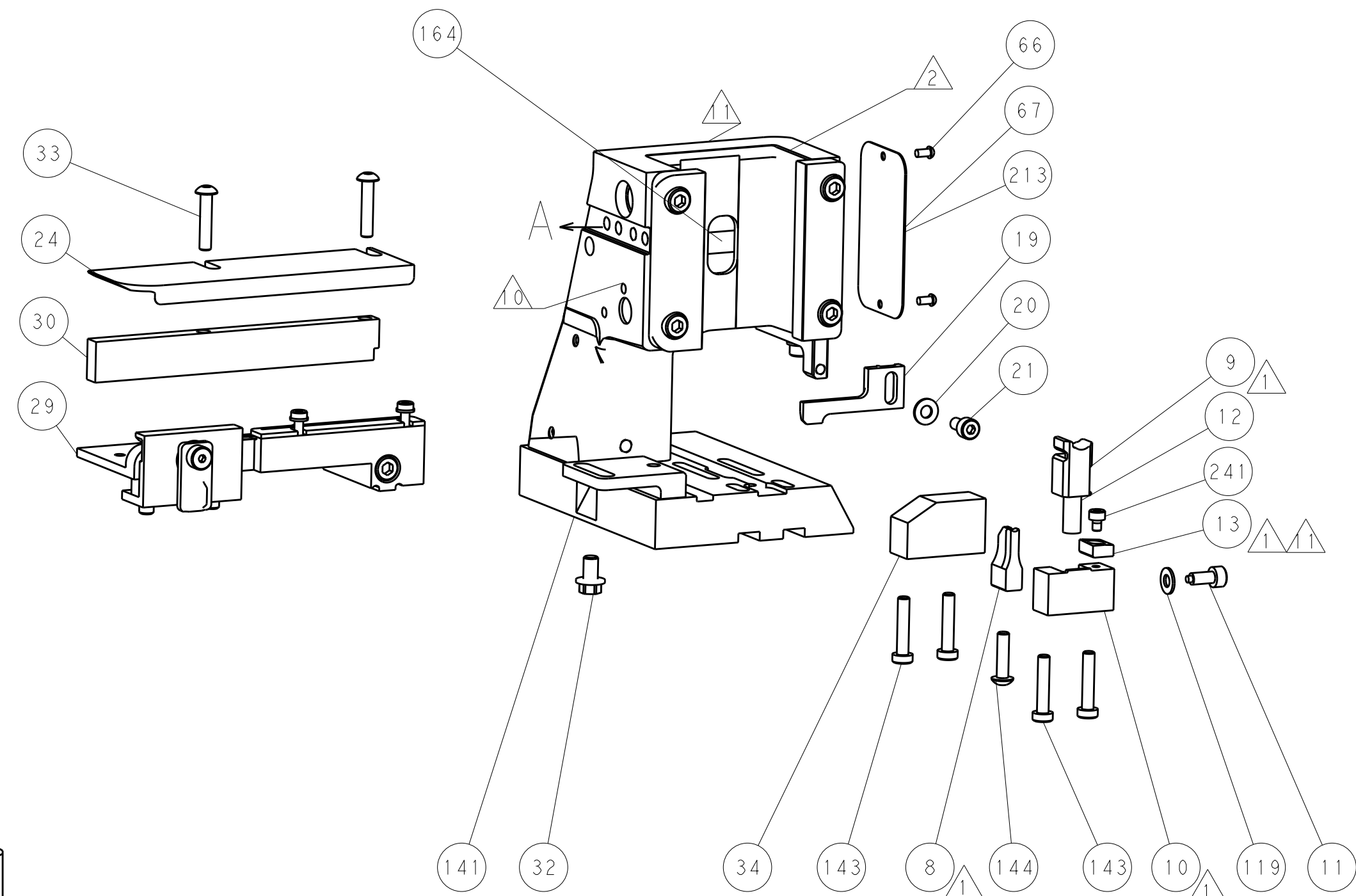
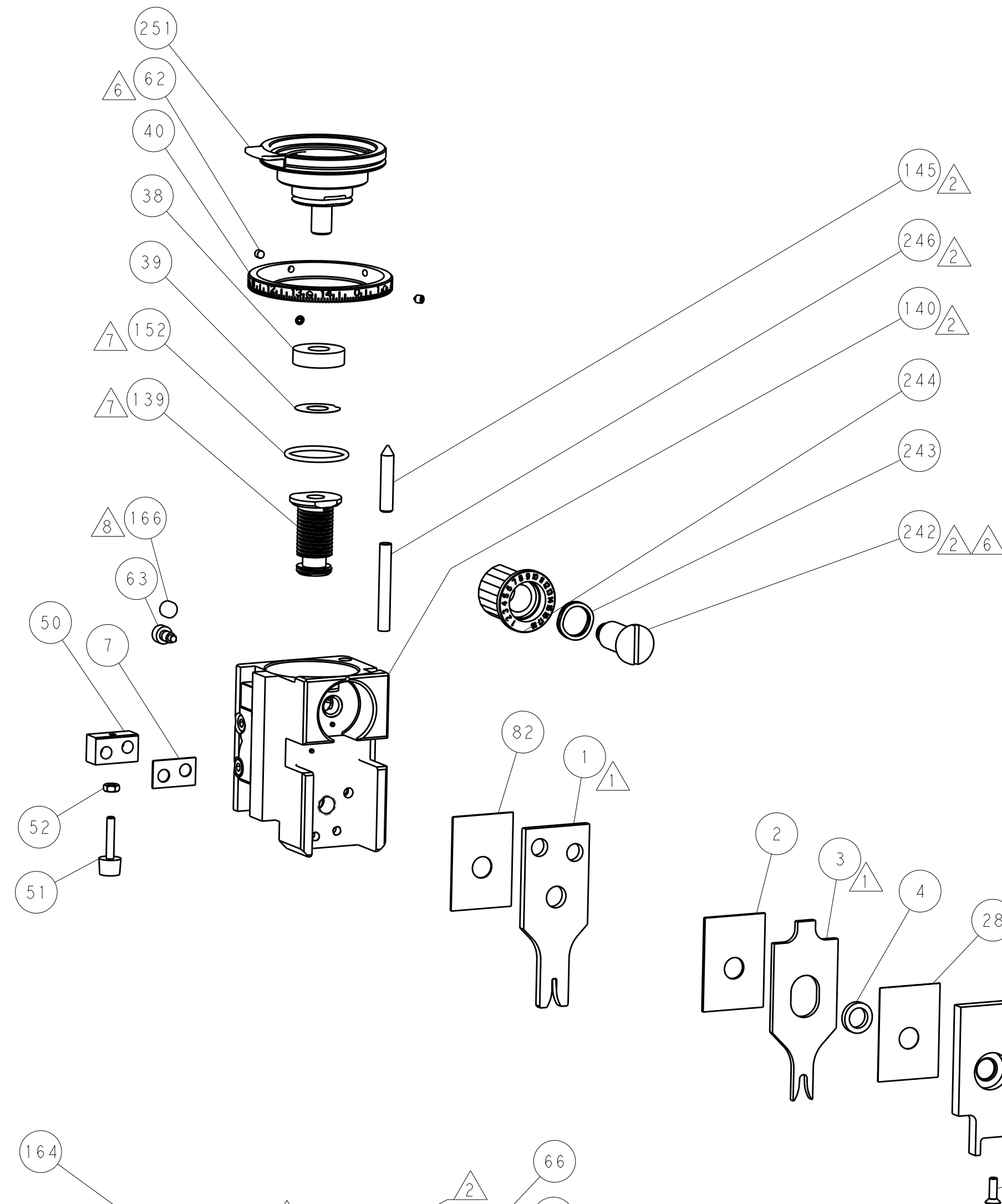
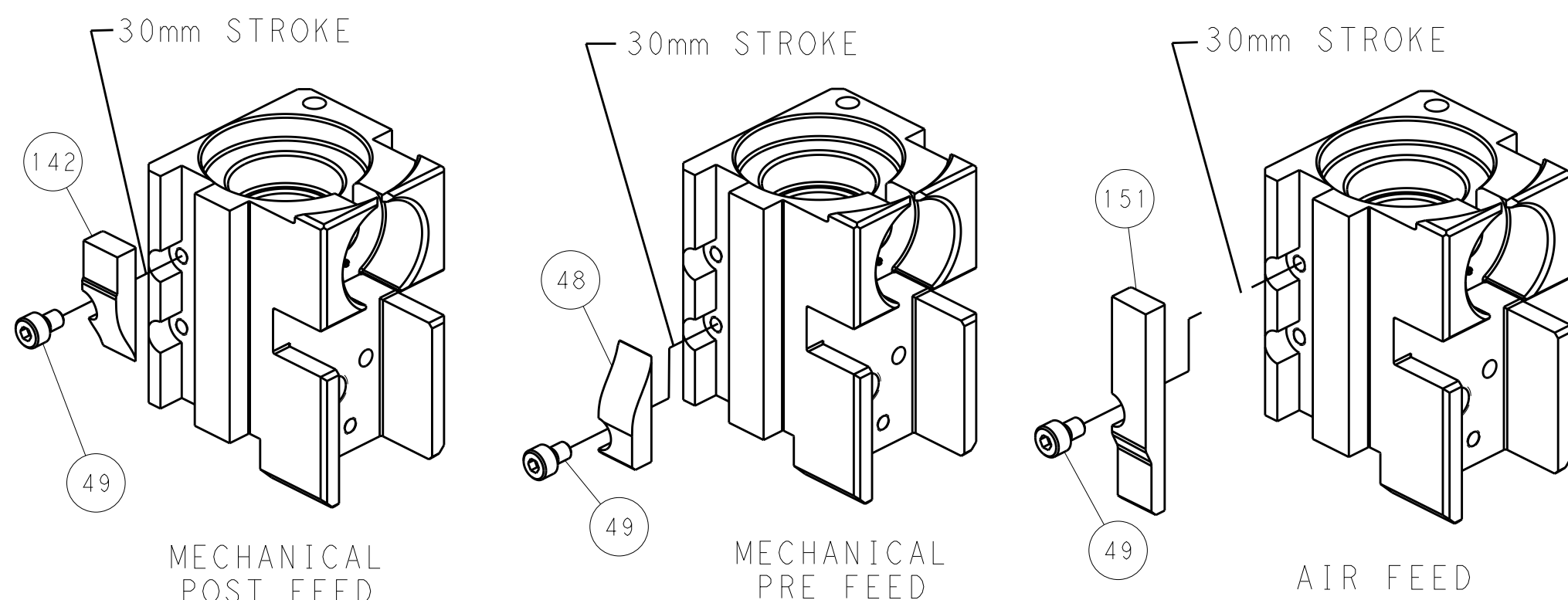
PNEUMATIC



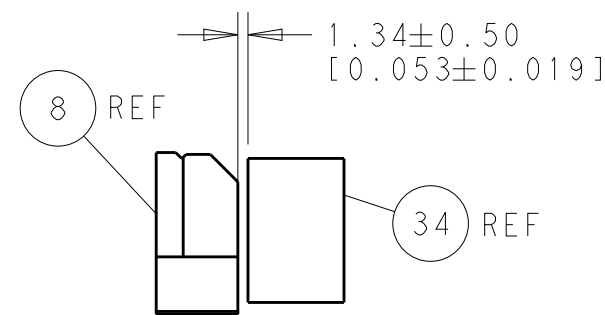
SERVO LATCH PLATE



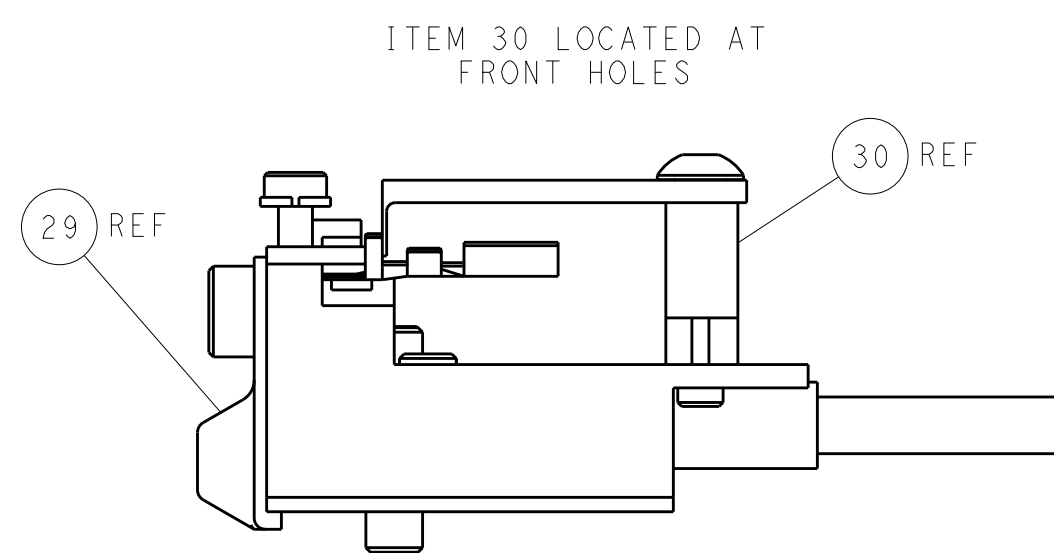
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		28SEPT2013		TE Connectivity	
mm		0 PLC ±0.5		G.BAILEY		28SEPT2013		Harrisburg, PA 17105-3608	
MATERIAL		FINISH		APVD		28SEPT2013		NAME	
				M. CLIFFORD				Ocean Side Feed Applicator	
				PRODUCT SPEC				SIZE	
				APPLICATION SPEC				CAGE CODE	
				WEIGHT				DRAWING NO	
				Customer Accessible Production Drawing				00779	
				SCALE				RESTRICTED TO	
				1:2				SHEET 4 OF 4	
								REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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[TE Connectivity:](#)

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