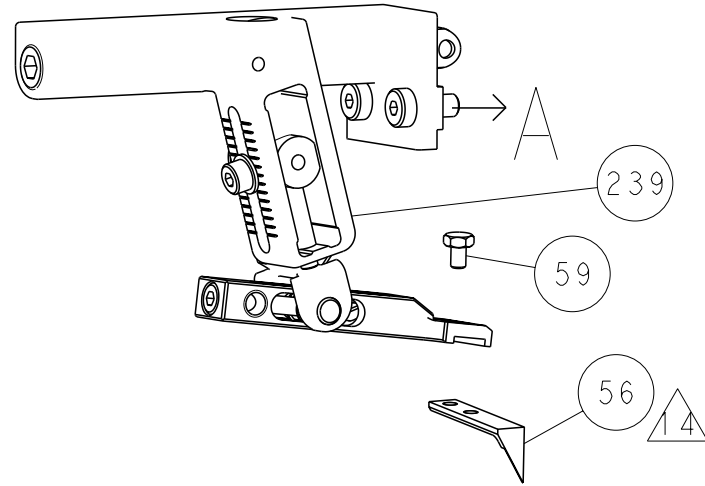
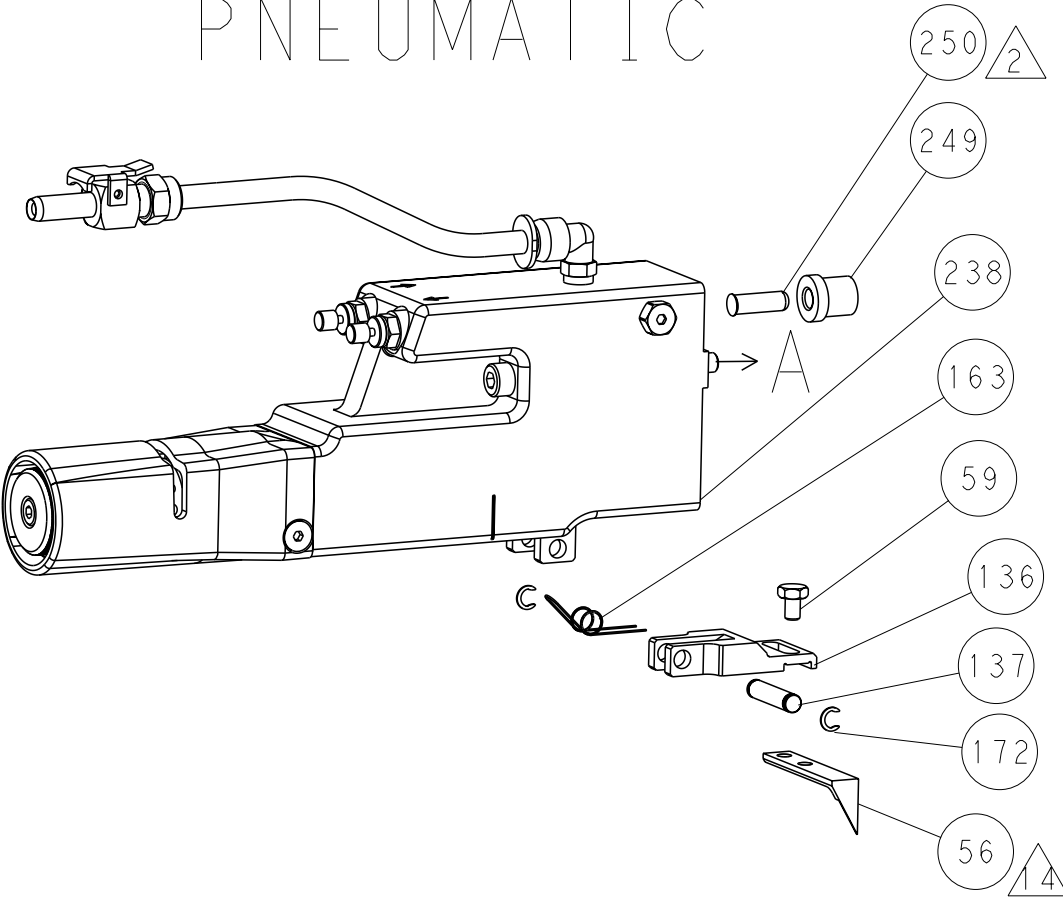


LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

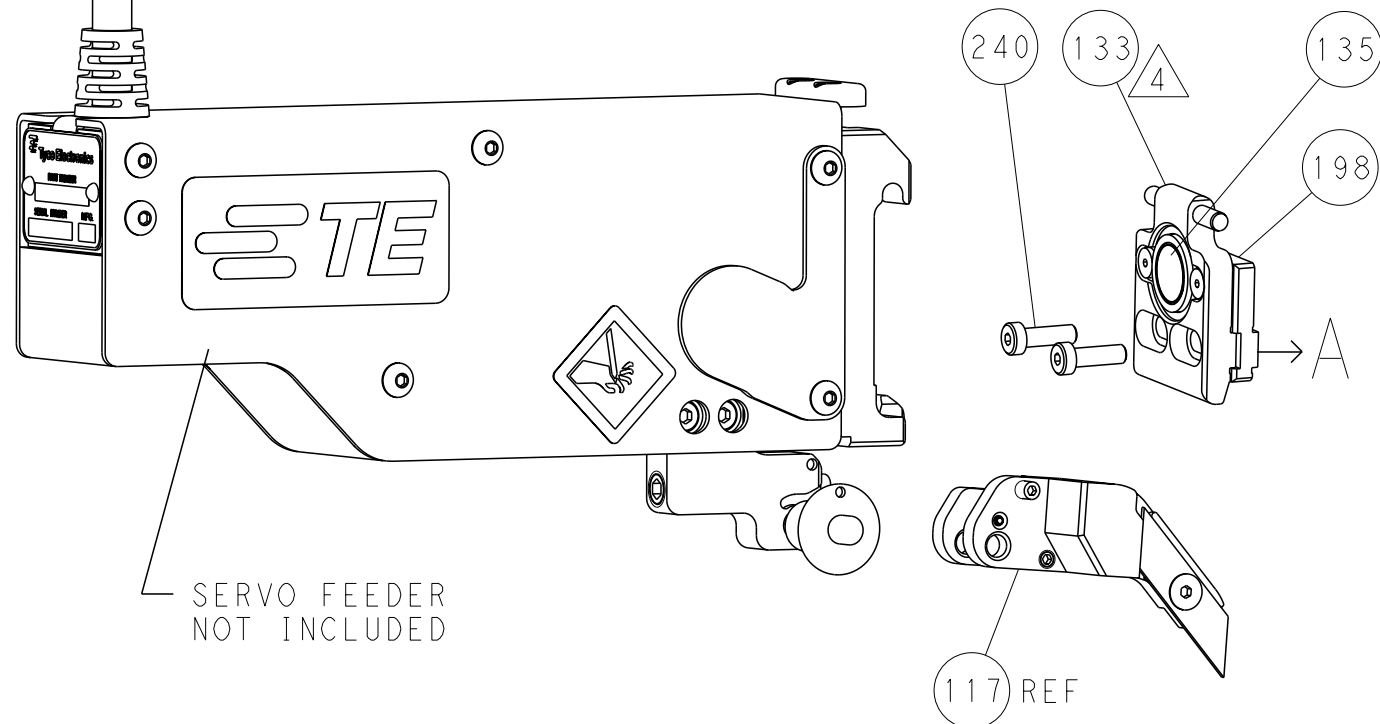
FEED TYPE MECHANICAL



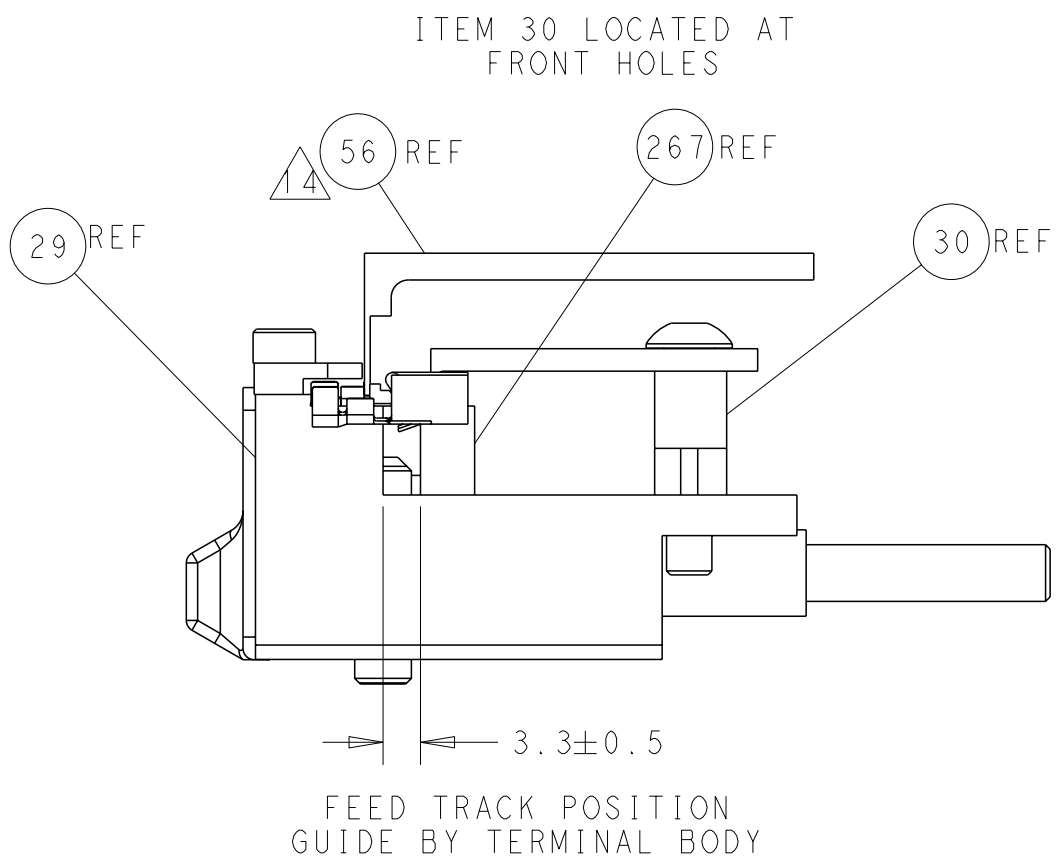
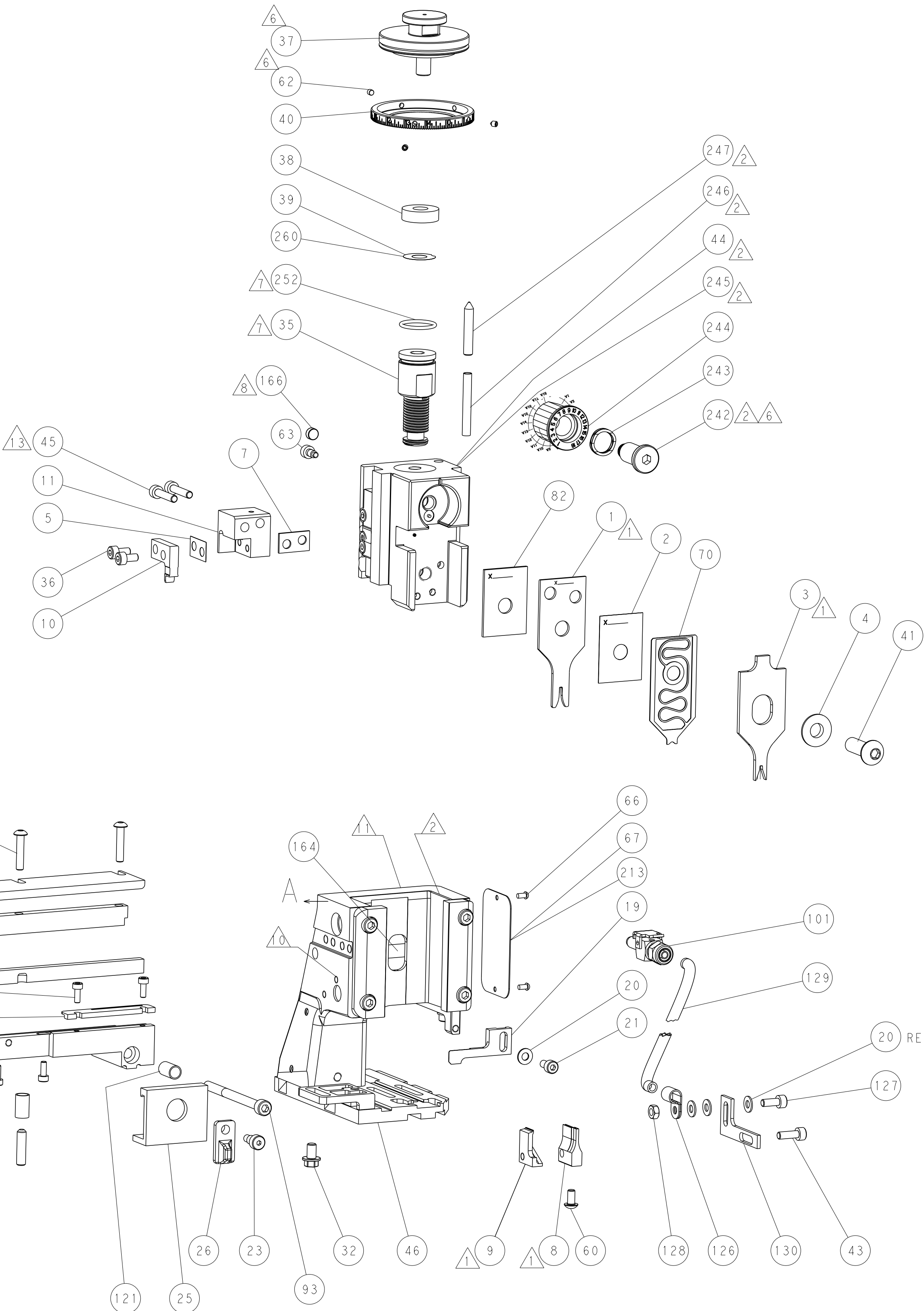
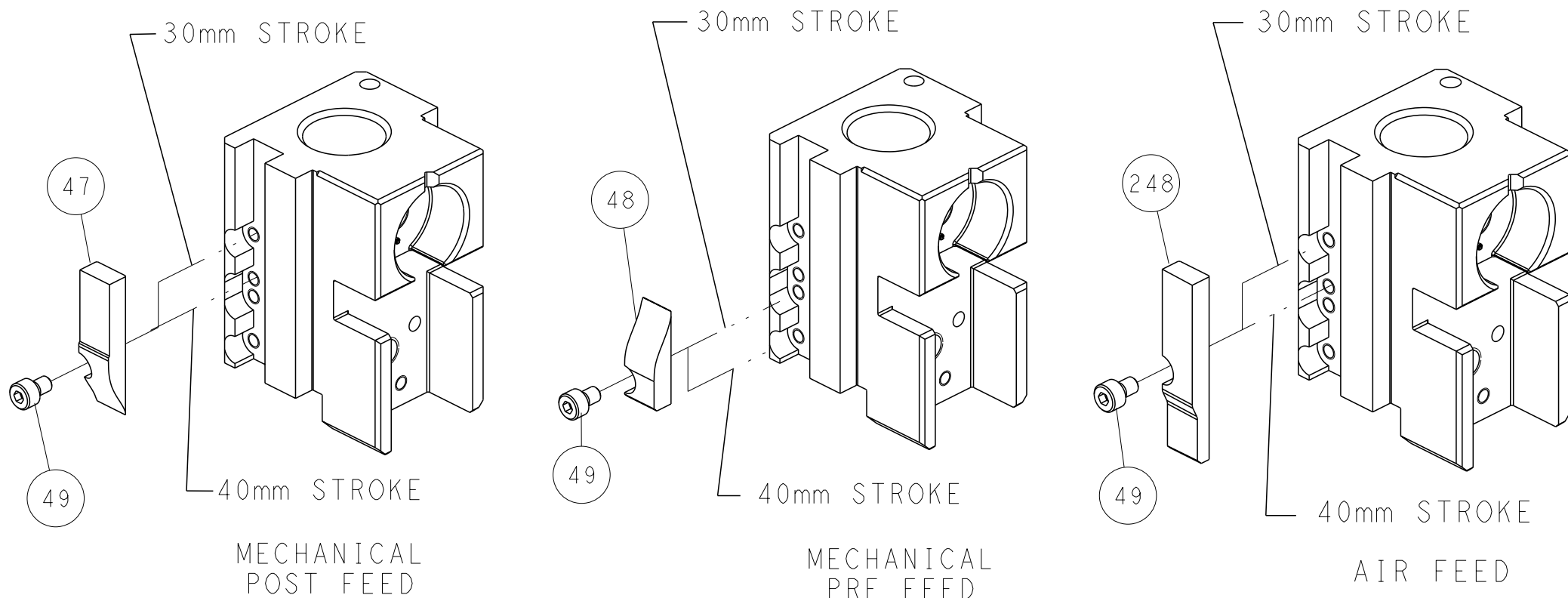
PNEUMATIC



SERVO LATCH PLATE



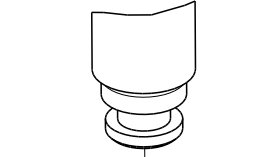
CAM POSITIONS



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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. STAKEM 17JAN2015	TE Connectivity Harrisburg, PA 17105-3608			
				CHK G. BAILEY 17JAN2015	NAME Ocean Side Feed Applicator			
				APVD T. ELBIN 17JAN2015	SIZE A1			
				PRODUCT SPEC	CAGE CODE 00779			
				APPLICATION SPEC	DRAWING NO C=2266610			
				WEIGHT	RESTRICTED TO			
				Customer Accessible Production Drawing	SCALE 1:2			
					SHEET 2			
					OF 4			
					REV B			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7		6		5		4		3	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20							
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.									
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266610-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-3	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266610-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266610-4	-	-	-
	2-2266610-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-3	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266610-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266610-4	-	-	-
	2-2266610-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	MECHANICAL FEED	2119949-1	1338685-3	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-3	5-18022-5	2119641-2	2119799-1	2063440-1
2-2266610-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266610-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	1.68 mm [.066]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MOLEX TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CAT EAR TERMINAL			
WIRE STRIP LENGTH 2.54-3.18 mm [.100-.125 IN]		INSULATION DIAMETER RANGE Ø1.12-1.57 mm [.044-.062 IN]	
 TERMINAL APPLICATION SPECIFICATION		ATS-638887100 Rev C - - -	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949166-1	08-50-0031	1949166-6	08-56-0120
1949166-2	08-50-0030	1949166-7	97-00-0450
1949166-3	08-50-0135	1949166-8	08-52-0150
1949166-4	08-55-0110	1949166-9	08-65-0150
1949166-5	08-55-0112	1-1949166-0	97-00-0225

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
22 AWG OR 0.35mm ²		0.82+/-0.025 [0.032+/-0.011]		5.4
24 AWG OR 0.20mm ²		0.77+/-0.025 [0.030+/-0.011]		6.0
26 AWG OR 0.12mm ²		0.71+/-0.030 [0.028+/-0.011]		6.6
28 AWG OR 0.08mm ²		0.69+/-0.025 [0.027+/-0.011]		6.9
30 AWG OR 0.05mm ²		0.65+/-0.015 [0.025+/-0.011]		7.4



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: 8-2266610-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266610-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266610-5
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. CUT TO LENGTH AT ASSEMBLY.

-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1	1-1633782-6	FENCE	267
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	1803259-1	BUSHING, FLANGED	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
-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

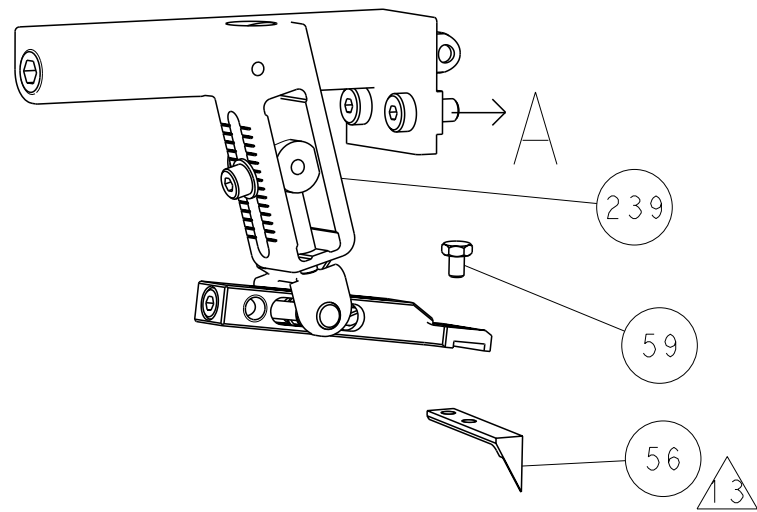
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

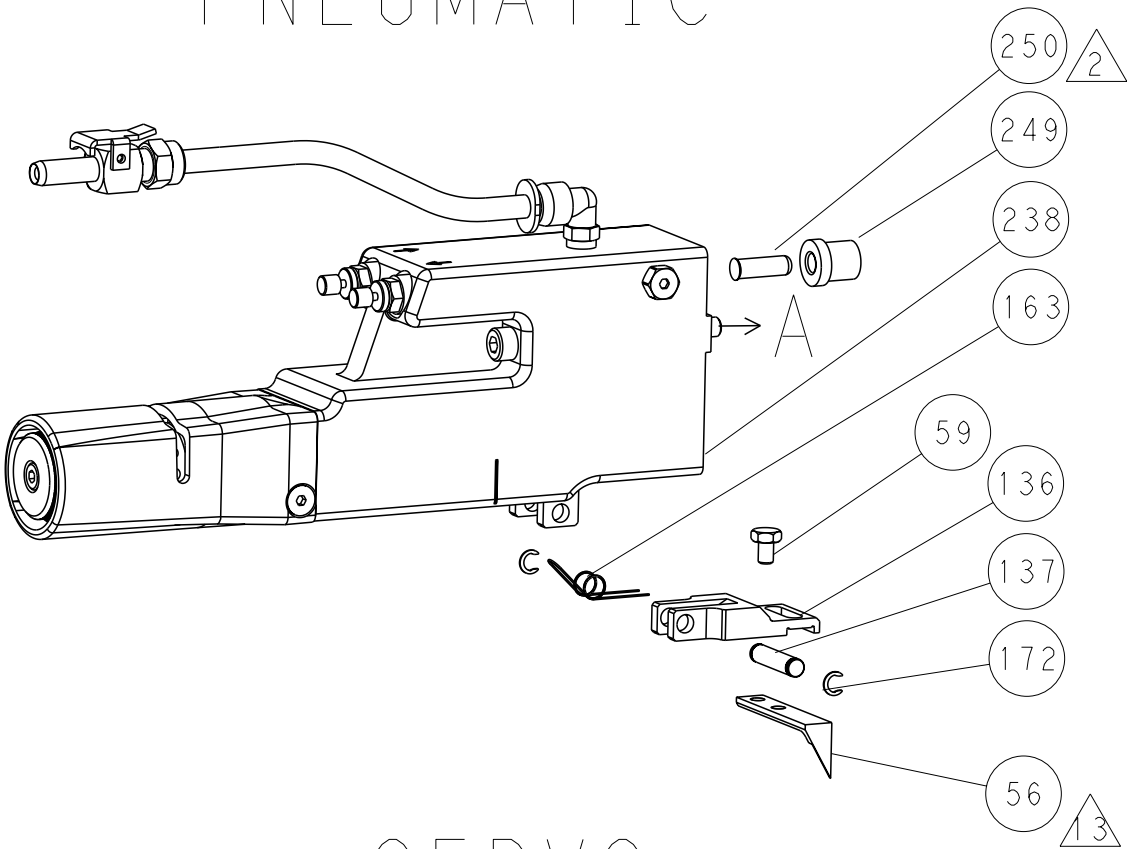
	-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
	-	-	1	-	-	2119740-2	TAG,IDENTIFICATION	213
	-	-	1	-	-	1901094-3	SPACER, FEEDER	198
	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
8	-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
7	-	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
	-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1	1	2119656-2	APPLICATOR BASIC ASSEMBLY, SF	14
	-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
7	-	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
	-	1	1	1	1	2217068-1	BRACKET, AIR BLAST	130
	-	457	457	457	457	2030758-3	TUBING, POLYURETHANE	129
	-	1	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
	-	1	1	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127
	-	1	1	1	1	986220-3	CLAMP, CABLE, BLACK	126
	-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
	-	1	1	1	1	23238-1	INSERT, COUPLING	101
	-	1	1	1	1	2-690487-8	GUIDE, FRONT STRIP	96
	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	1	1	1-455888-3	SPACER, CRIMPER	82
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	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
4	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
	-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
3	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	-	1	1	1338685-3	PAWL, FEED	56
	-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
2	-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	45
	-	1	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	43
	-	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	1-2119644-4	RAM WASHER, PRECISION	38
	-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	36
	-	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	1320908-5	SPACER, STRIP GUIDE	30
	-	1	1	1	1	2-1901086-9	PLATE, STRIP GUIDE	29
	-	2	2	2	2	22281-7	SPRING, COMPRESSION	27
	-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1	5-690754-0	DRAG, SPECIAL	25
	-	1	1	1	1	1-1320928-0	STRIP GUIDE	24
	-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	4	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
	-	1	1	1	1	2119830-8	HOLDER, SLUG BLADE	11
1	-	1	1	1	1	1633579-6	BLADE, SLUG	10
1	-	1	1	1	1	1803150-2	PLATE, REAR SHEAR	9
1	1	1	1	1	1	1633481-8	ANVIL, SPECIAL, COMBINATION	8
	-	1	1	1	1	5-240641-9	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	4-240641-9	SPACER	5
	-	1	1	1	1	1-238009-0	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	7-1633962-8	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	1	8-1633738-9	CRIMPER, WIRE	1
	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A COMPUTER GENERATED DRAWING FOR THE ELECTRONIC COMPONENTS IT IS SUBJECT TO THE FOLLOWING CONDITIONS: THE CONTRACTOR SHALL BE RESPONSIBLE FOR THE INFORMATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWG K STAKEM 17JAN2015 CHK 66 BAILEY 17JAN2015 APP'D T ELBIN 17JAN2015		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator -	
MATERIAL FINISH		WEIGHT -		SIZE A1	
				CAGE CODE 00779	
				DRAWING NO C2266610	
				RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2	
				SHEET 3 of 4	
				REV B	

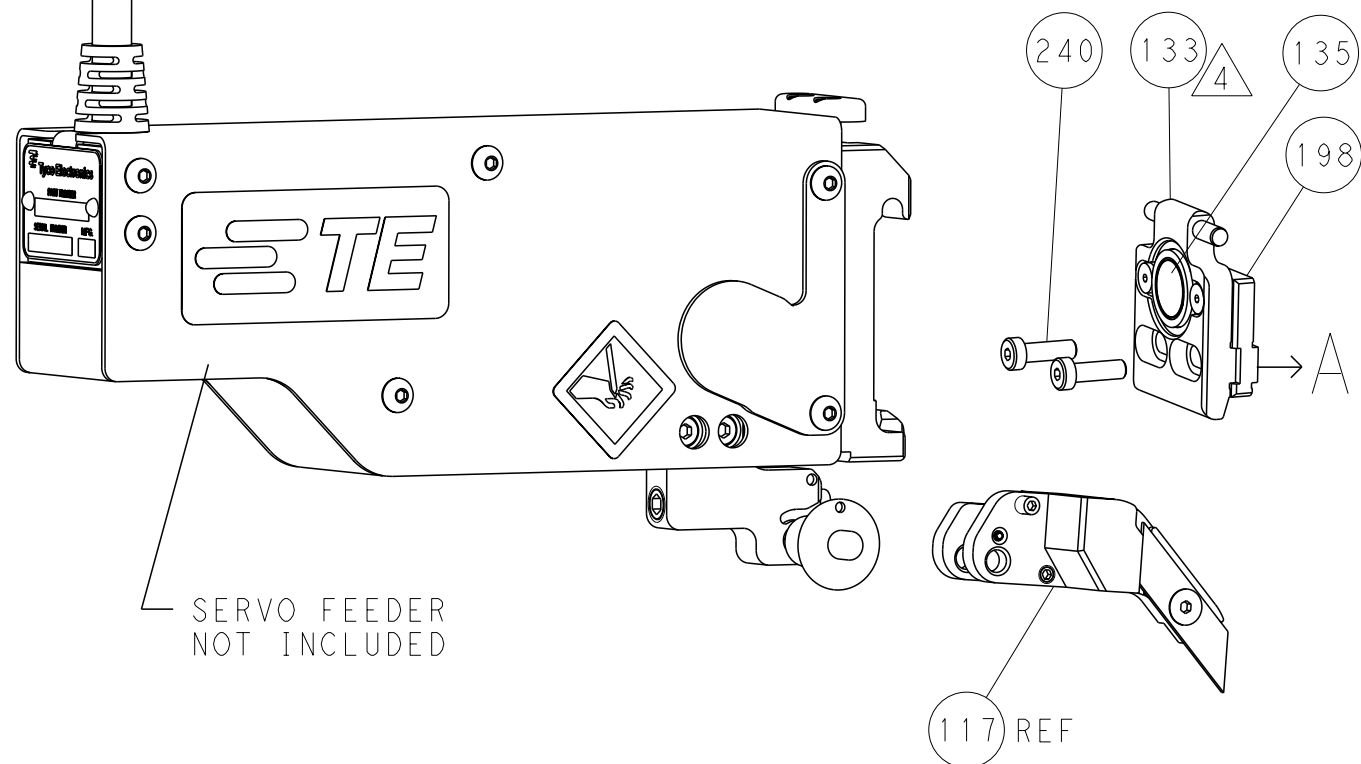
FEED TYPE MECHANICAL



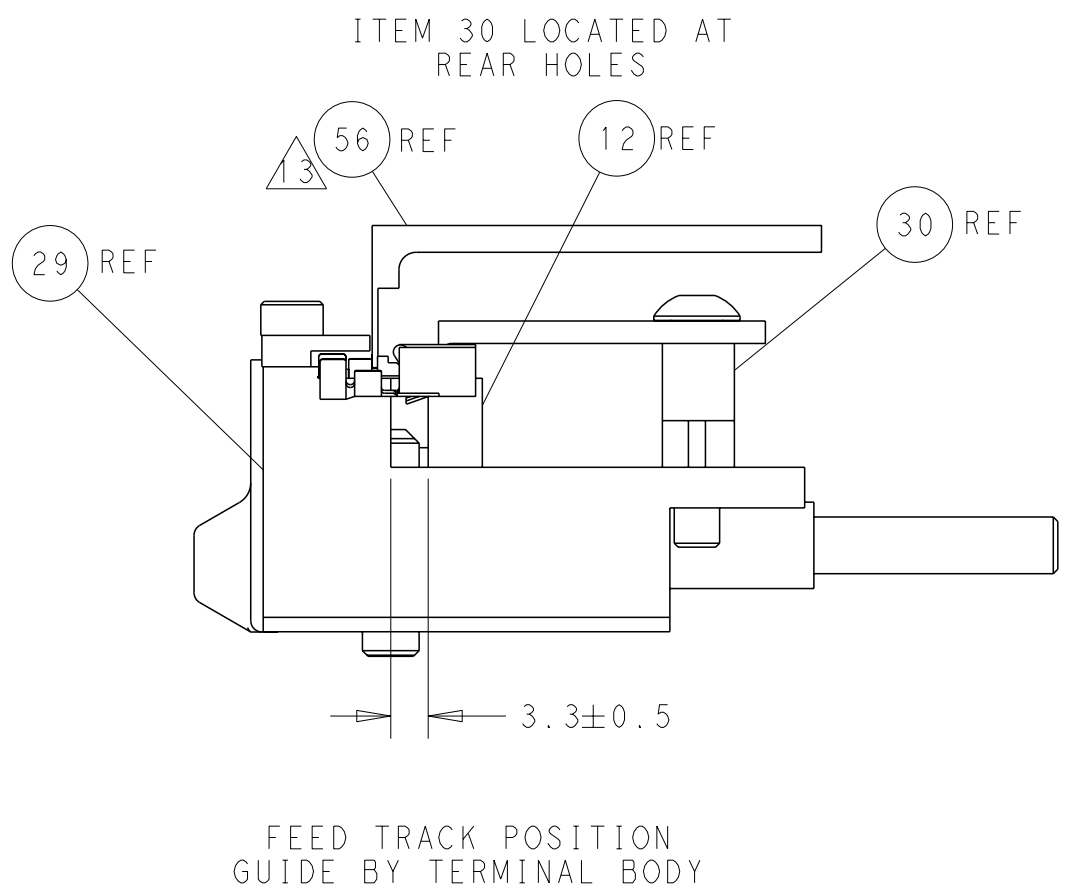
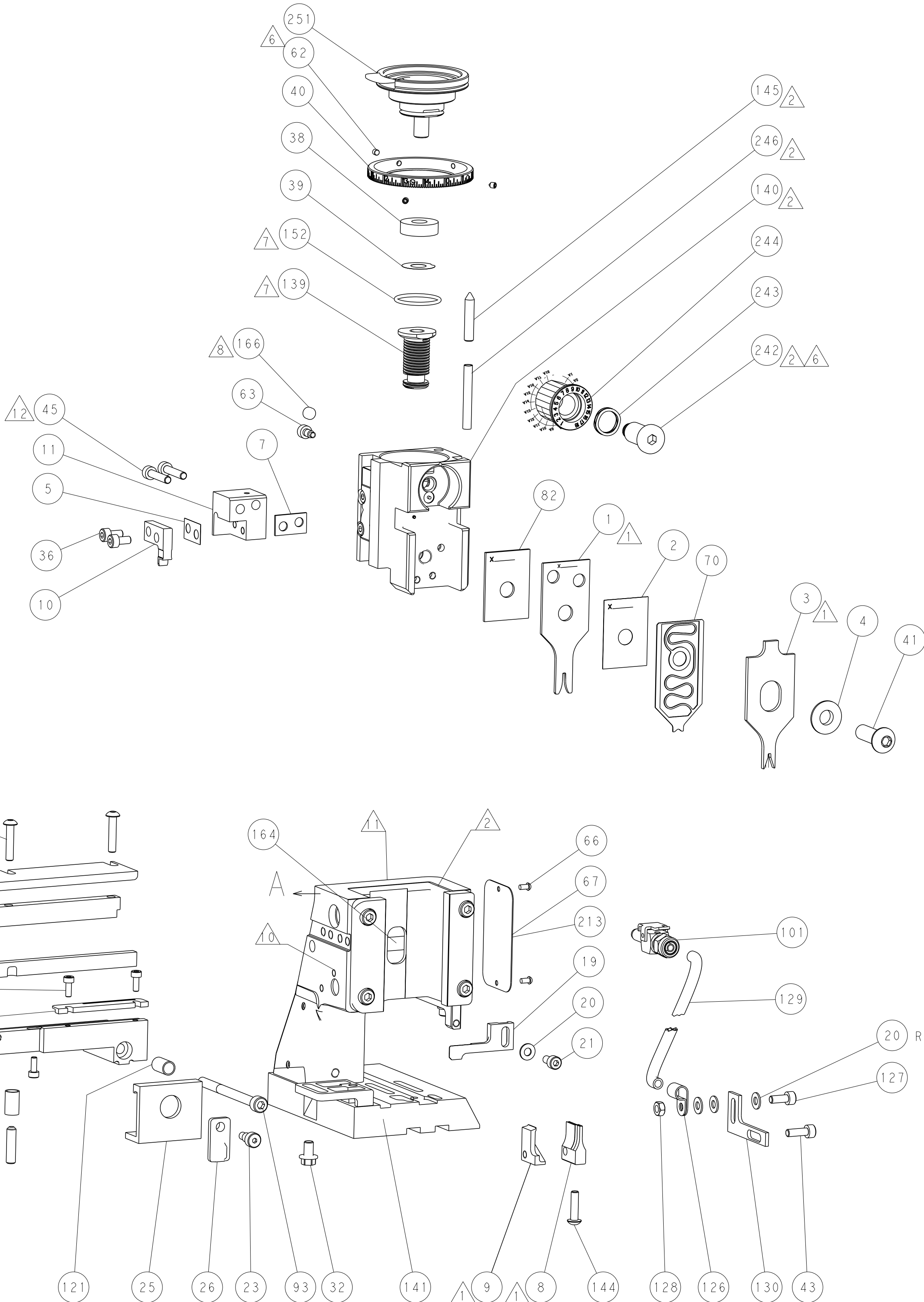
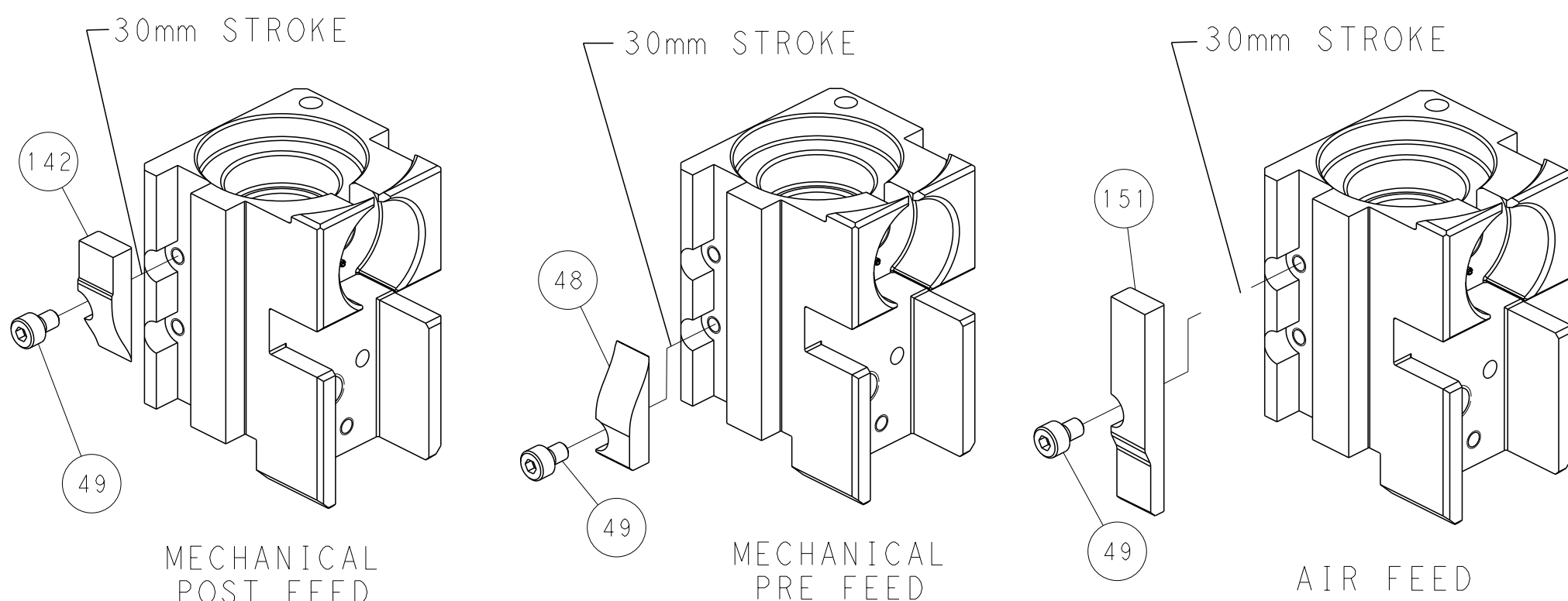
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		17JAN2015		TE Connectivity	
mm		0 PLC ±		K. STAKEM		17JAN2015		Harrisburg, PA 17105-3608	
1 PLC ±		2 PLC ±		G. BAILEY		17JAN2015		NAME	
3 PLC ±		4 PLC ±		T. ELBIN		17JAN2015		Ocean Side Feed	
MATERIAL		FINISH		PRODUCT SPEC		APPLICATION SPEC		-	
-		-		WEIGHT		-		SIZE	
-		-		Customer Accessible Production Drawing		SCALE		1:2	
-		-		SHEET		4		OF	
-		-		REV		B		REV	