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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

REVISION

DESCRIPTION

2266117-1

A

FINE CRIMP HEIGHT ADJUST

2266117-2

A

FINE CRIMP HEIGHT ADJUST

2266117-5

A

FINE CRIMP HEIGHT ADJUST

2266117-6

A

NON-CRIMP HEIGHT ADJUST

2266117-7

A

FINE CRIMP HEIGHT ADJUST

7-2266117-7

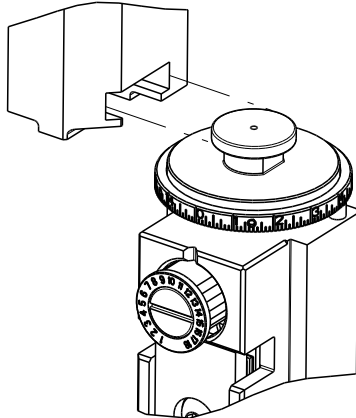
A

CRIMP TOOLING KIT

7-2266117-8


A

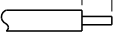

APPLICATOR CONVERSION KIT




APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-10389		

APPLICATOR CONVERSION KITS	
PART NUMBER	INSULATION DIAMETER RANGE
7-2266116-8	Ø2.67-3.18mm [.105-.125]
7-2266117-8	Ø2.16-2.82mm [.085-.111]
7-2266118-8	Ø1.91-2.67mm [.075-.105]
7-2266119-8	Ø1.62-2.16mm [.064-.085]
7-2266120-8	Ø1.27-1.91mm [.050-.075]

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT PIN SIZE 20			
WIRE STRIP LENGTH 3.81-5.09 mm [.150-.200 IN]		 INSULATION DIAMETER RANGE Ø2.16-2.82 mm [.085-.111 IN]	
TERMINAL APPLICATION SPECIFICATION 0425-059-0000 Rev L		-	-
TERMINAL APPLICATION SPECIFICATION		-	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
1572032-1	1060-20-0122	1572032-2	1060-20-0144
1572032-7	1060-20-0177		

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20			
WIRE STRIP LENGTH 3.81-5.09 mm [.150-.200 IN]		 INSULATION DIAMETER RANGE Ø2.16-2.82 mm [.085-.111 IN]	
TERMINAL APPLICATION SPECIFICATION  0425-059-0000 Rev L		-	-
TERMINALS APPLIED		-	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
286680-1	1062-20-0122	286680-2	1062-20-0144
286680-9	1062-20-0177	286680-5	1062-20-0322
286680-6	1062-20-0344	1-286680-0	1062-20-0377

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.47+0.03/-0.05 [.058+.001/- .002]	3.4
16 AWG	1.27+0.03/-0.05 [.050+.001/- .002]	5.4
1.00mm2	1.27+0.03/-0.05 [.050+.001/- .002]	5.4
18 AWG	1.24+0.03/-0.05 [.049+.001/- .002]	5.7
0.75mm2	1.22+0.03/-0.05 [.048+.001/- .002]	5.9
0.60mm2	1.07+0.03/-0.05 [.042+.001/- .002]	7.4
20 AWG	0.99+0.03/-0.05 [.039+.001/- .002]	8.2
0.50mm2	0.97+0.03/-0.05 [.038+.001/- .002]	8.4
22 AWG	0.94+0.03/-0.05 [.037+.001/- .002]	8.7
0.35mm2	0.94+0.03/-0.05 [.037+.001/- .002]	8.7

- 
- 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: 8-2266117-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266117-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266117-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266117-6
- 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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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 4.33.
- 13

SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.

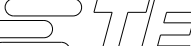

*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	-	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
-78	-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)

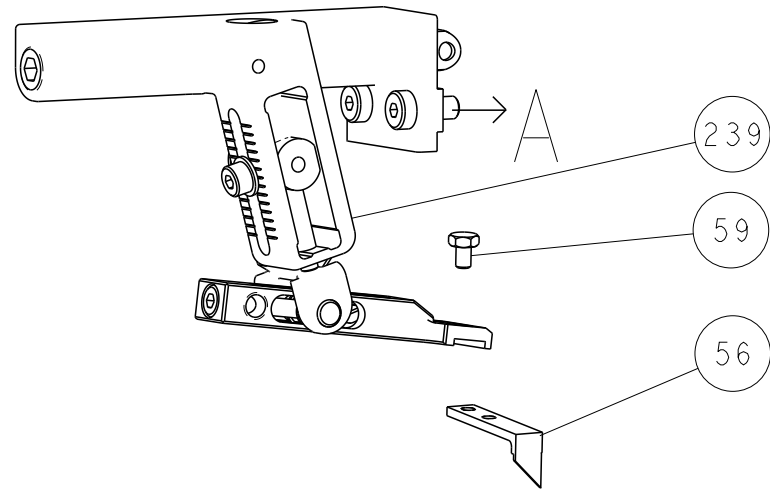
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
P	LTR	DESCRIPTION		DATE	OWN	APVD
	A2	ECR-15-005520		08APR2015	MR	TE

-	-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	-	1	1	1	1	1	2119082-9	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	-	-	-	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	455888-7	SPACER, CRIMPER	82
-	-	1	1	1	1	1	22278-8	SPRING, COMPRESSION	77
-	-	1	1	1	1	1	854769-4	HOLDER, INS	74
1	-	-	-	-	-	-	2266117	PRINT, APPLICATOR LOG SHEET	72
-	-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	-	1	1	1	1	1	2119791-9	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
-	-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	-	-	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	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	2-1752356-0	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	1-1320908-0	SPACER, STRIP GUIDE	30
-	-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	-	1	1	1	1	1	455888-3	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	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1	2-1803054-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	-	1	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	-	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1	1803019-5	CRIMPER, INSULATION O	3
-	-	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1	1	1	1	4-1633713-4	CRIMPER, WIRE PREMIUM	1

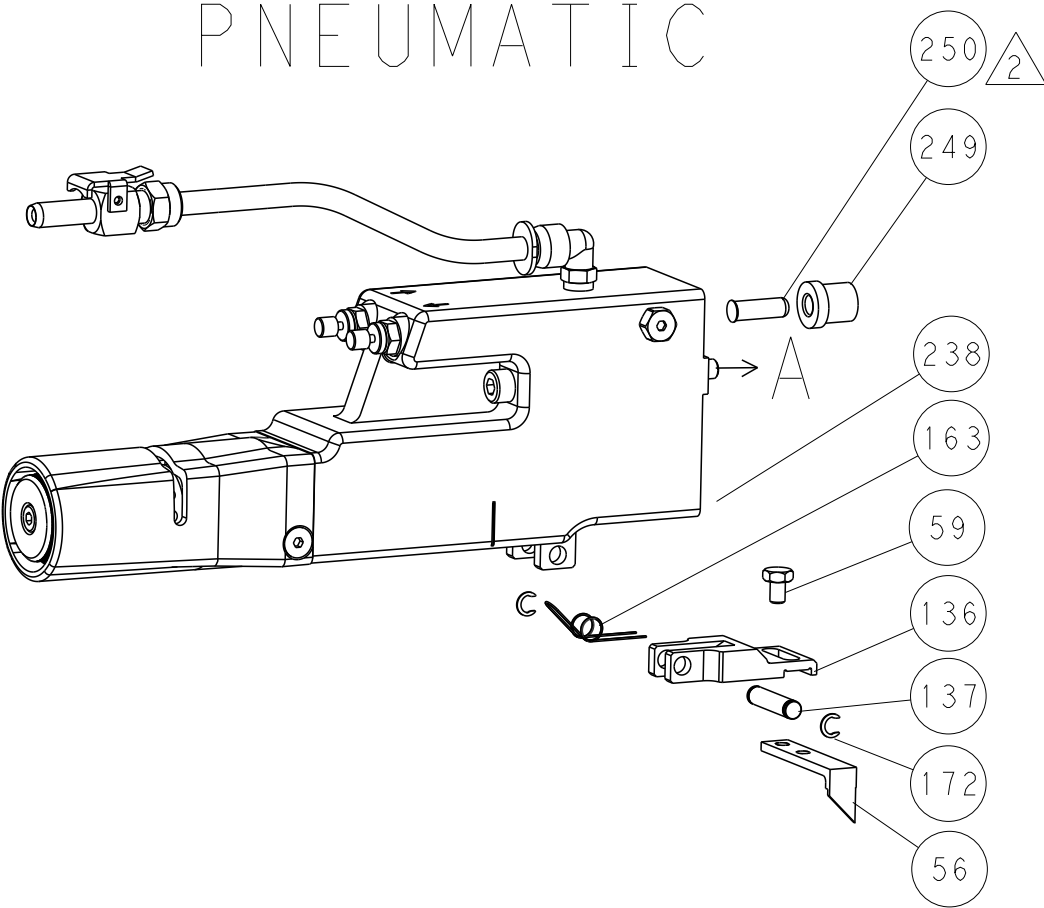
-78 -77 -7 -6 -5 -2 -1				PART NO		DESCRIPTION				ITEM NO	
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION 15175 DODGE ROAD, HARRISBURG, PA 17105-3608 FOR THE LATEST REVISIONS, SEE THE DRAWING OR CONTACT THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.						OWN R. KNEPPER 16-Oct-13		 TE Connectivity Harrisburg, PA 17105-3608			
						CHK G. BAILEY 16-Oct-13					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:				APVD M. CLIFFORD 16-Oct-13		NAME			
mm		0 PLC ±.5 1 PLC ±.13 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1				PRODUCT SPEC		Ocean Side Feed Applicator			
						APPLICATION SPEC					
MATERIAL		FINISH				WEIGHT		SIZE		CASE CODE DRAWING NO	
								A1		00779 ©=2266117	
Customer Accessible Production Drawing						SCALE		1:2		SHEET 1 OF 4 REV A2	

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

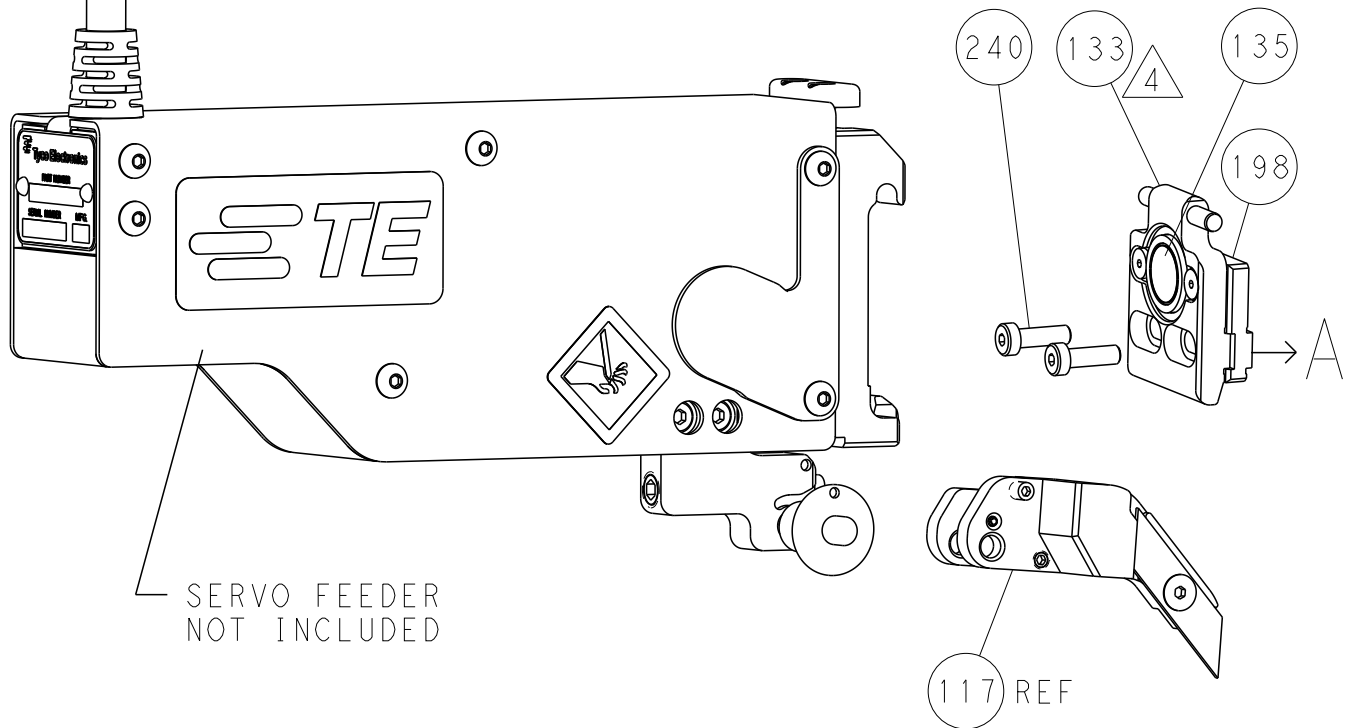
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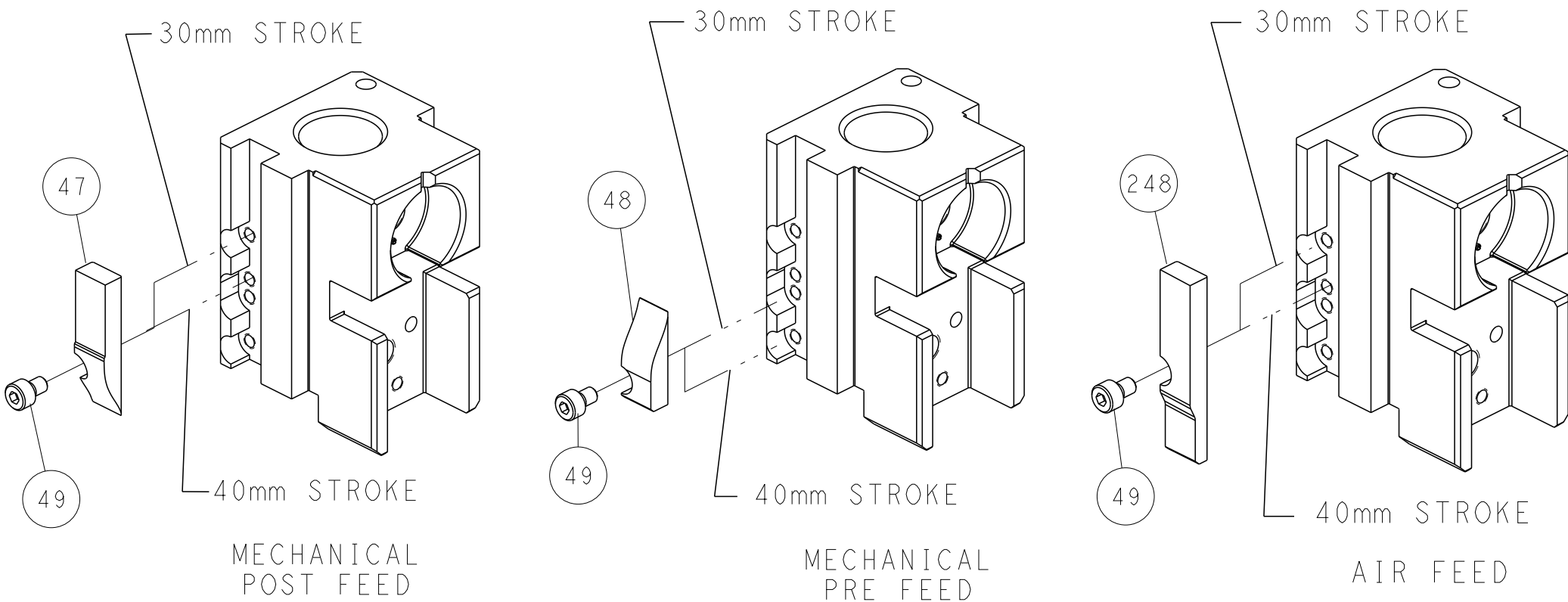
PNEUMATIC



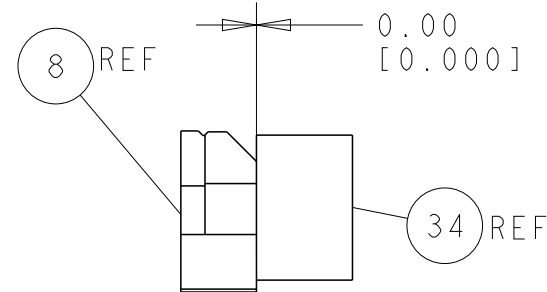
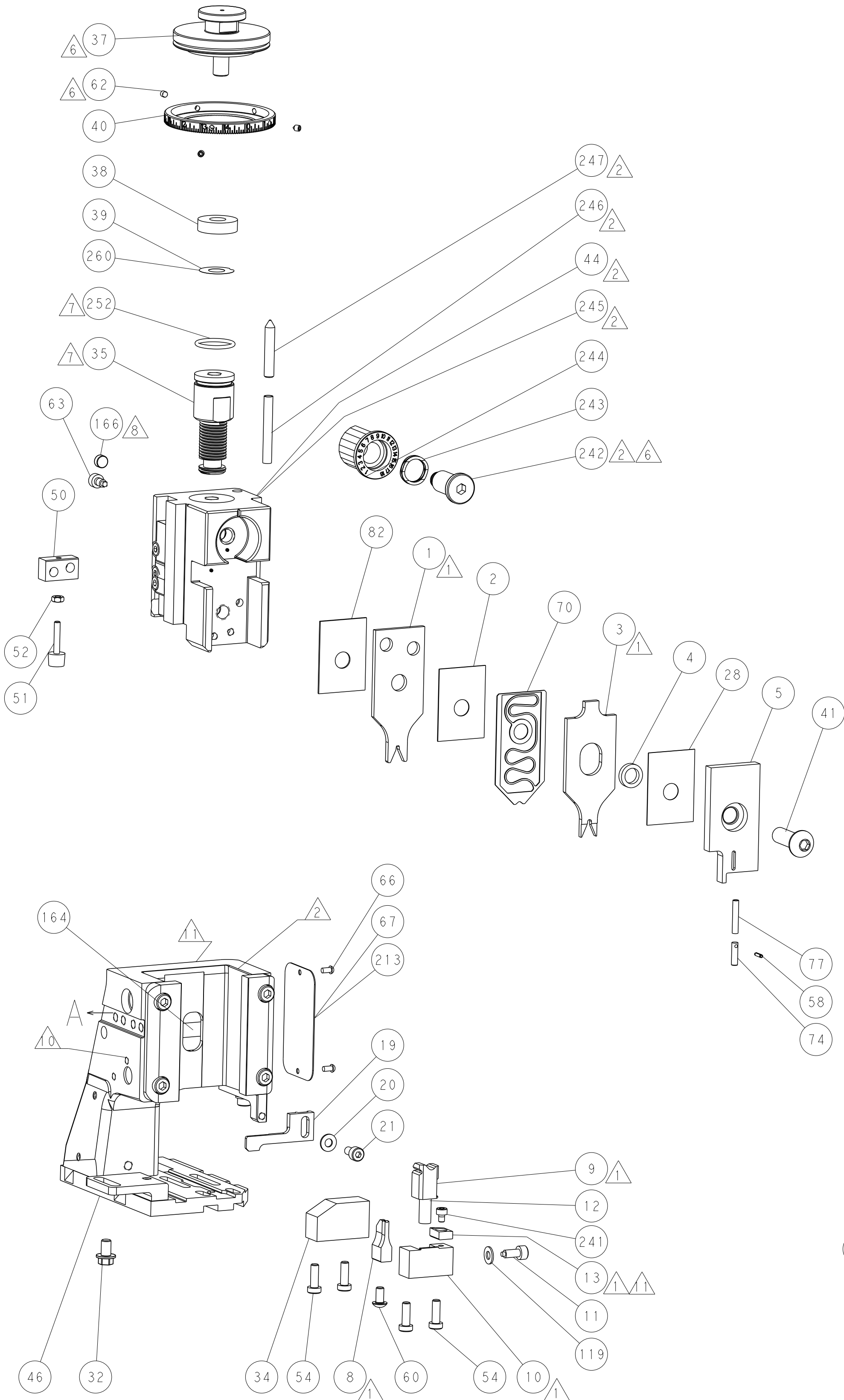
SERVO
LATCH PLATE



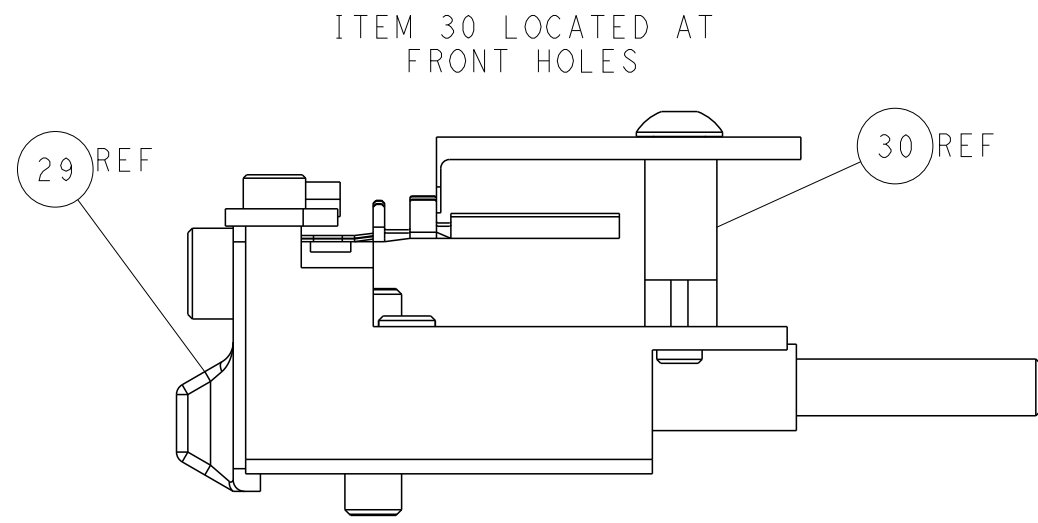
CAM POSITIONS



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



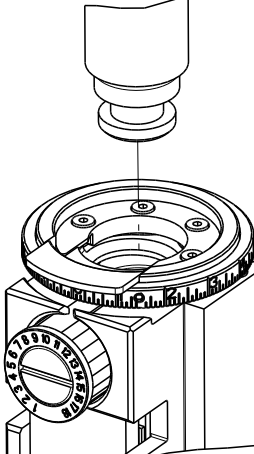
TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY WIRE BARREL

1. THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. 2. THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.		DWN R. KNEPPER 16-Oct-13	TE Connectivity Harrisburg, PA 17105-3608	
CHK G. BAILEY 16-Oct-13		APVD M. CLIFFORD 16-Oct-13	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		RESTRICTED TO
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC		±.5 ±0.13 ±0.013 ±0.0001		
MATERIAL		FINISH		
-		-		
Customer Accessible Production Drawing		SCALE 1:2	SHEET 2 of 4	REV A2

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266117-1	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	-	8-2266117-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266117-4	-	-	-
	2-2266117-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266117-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266117-4	-	-	-
	2-2266117-5	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
	2-2266117-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266117-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-
7-2266117-8	A	APPLICATOR CONVERSION KIT	-	⁴							

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-10389		

¹² APPLICATOR CONVERSION KITS	
PART NUMBER	INSULATION DIAMETER RANGE
7-2266116-8	Ø2.67-3.18mm [.105-.125]
7-2266117-8	Ø2.16-2.82mm [.085-.111]
7-2266118-8	Ø1.91-2.67mm [.075-.105]
7-2266119-8	Ø1.62-2.16mm [.064-.085]
7-2266120-8	Ø1.27-1.91mm [.050-.075]

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT PIN SIZE 20			
WIRE STRIP LENGTH 3.81-5.09 mm [.150-.200 IN]		INSULATION DIAMETER RANGE Ø2.16-2.82 mm [.085-.111 IN]	
TERMINAL APPLICATION SPECIFICATION	0425-059-0000 Rev L	-	-
-	-	-	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
1572032-1	1060-20-0122	1572032-2	1060-20-0144
1572032-7	1060-20-0177		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
1.50mm2		1.47+0.03/-0.05 [.058+.001/- .002]		3.4
16 AWG		1.27+0.03/-0.05 [.050+.001/- .002]		5.4
1.00mm2		1.27+0.03/-0.05 [.050+.001/- .002]		5.4
18 AWG		1.24+0.03/-0.05 [.049+.001/- .002]		5.7
0.75mm2		1.22+0.03/-0.05 [.048+.001/- .002]		5.9
0.60mm2		1.07+0.03/-0.05 [.042+.001/- .002]		7.4
20 AWG		0.99+0.03/-0.05 [.039+.001/- .002]		8.2
0.50mm2		0.97+0.03/-0.05 [.038+.001/- .002]		8.4
22 AWG		0.94+0.03/-0.05 [.037+.001/- .002]		8.7
0.35mm2		0.94+0.03/-0.05 [.037+.001/- .002]		8.7



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: 8-2266117-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266117-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266117-5

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 ITEMS 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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 SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20			
WIRE STRIP LENGTH 3.81-5.09 mm [.150-.200 IN]		INSULATION DIAMETER RANGE Ø2.16-2.82 mm [.085-.111 IN]	
TERMINAL APPLICATION SPECIFICATION	0425-059-0000 Rev L	-	-
-	-	-	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
286680-1	1062-20-0122	286680-2	1062-20-0144
286680-9	1062-20-0177	286680-5	1062-20-0322
286680-6	1062-20-0344	1-286680-0	1062-20-0377

*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
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-78	-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	LTR	DESCRIPTION	DATE	DWN	APVD	
			-	-	SEE SHEET 1	-	-	-	

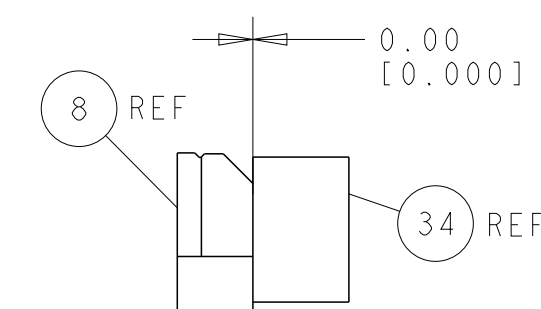
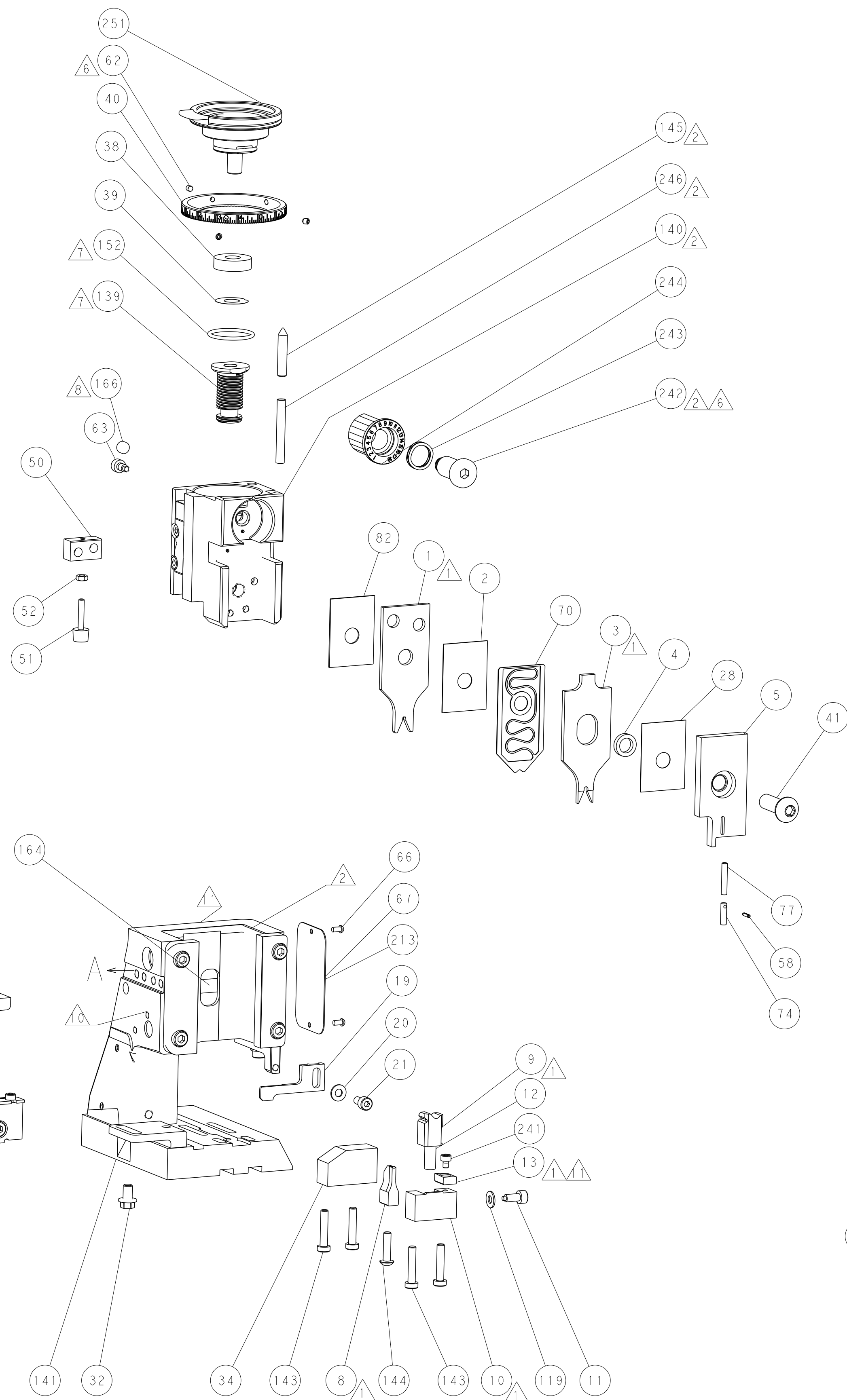
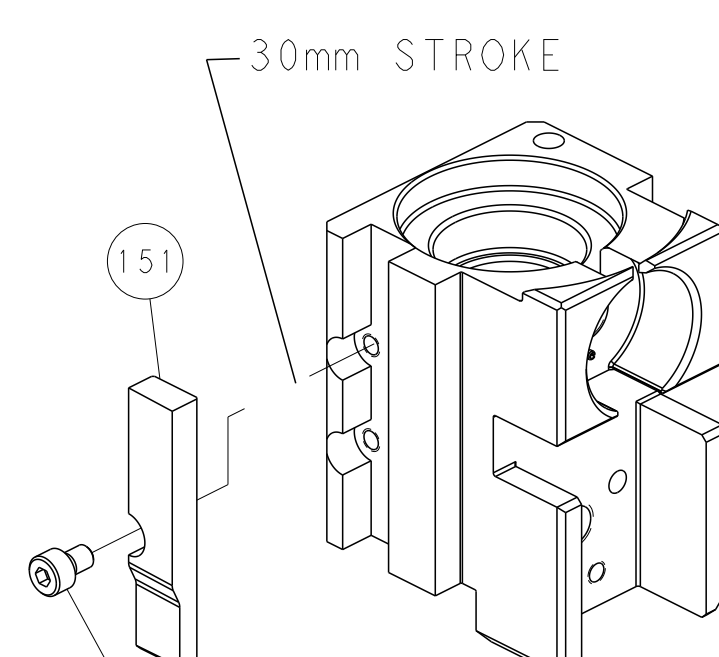
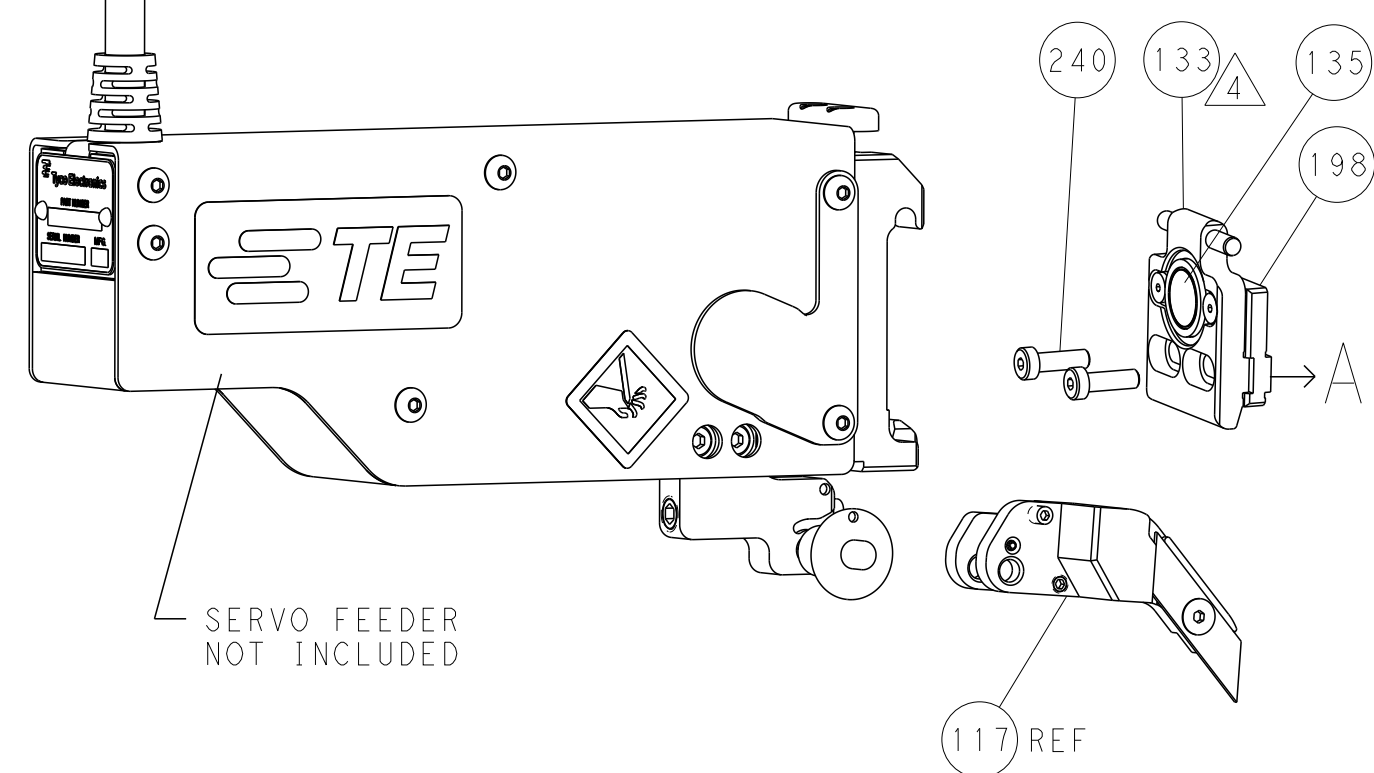
⁶	-	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	-	1	-	2063440-1	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
⁸	-	-	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
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	1-18028-2	WASHER, FLAT, REG M4	119
	-	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
	-	-	1	1	1	1	455888-7	SPACER, CRIMPER	82
	-	-	1	1	1	1	22278-8	SPRING, COMPRESSION	77
	-	-	1	1	1	1	854769-4	HOLDER, INS	74
⁶	1	-	-	-	-	-	2266117	PRINT, APPLICATOR LOG SHEET	72
	-	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	-	1	1	1	1	2119791-9	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
	-	-	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	1338685-1	PAWL, FEED	56
¹	-	-	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	2119644-1	RAM WASHER, PRECISION	38
¹	-	-	1	1	1	1	2-1752356-0	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
	-	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
¹	-	-	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	1	1	2-1803054-4	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	-	6
	-	-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
¹	1	1	1	1	1	1	1803019-5	CRIMPER, INSULATION O	3
	-	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
	-	1	1	1	1	1	4-1633713-4	CRIMPER, WIRE PREMIUM	1
	-78	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS IS A DRAFT. TO CORRELATE TO THE CORRECT DRAWING, THE DRAWING NUMBER SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN R.KNEPPER CHK G.BAILEY APVD M.CLIFFORD	16-Oct-13 16-Oct-13 16-Oct-13	TE Connectivity Harrisburg, PA 17105-3608	
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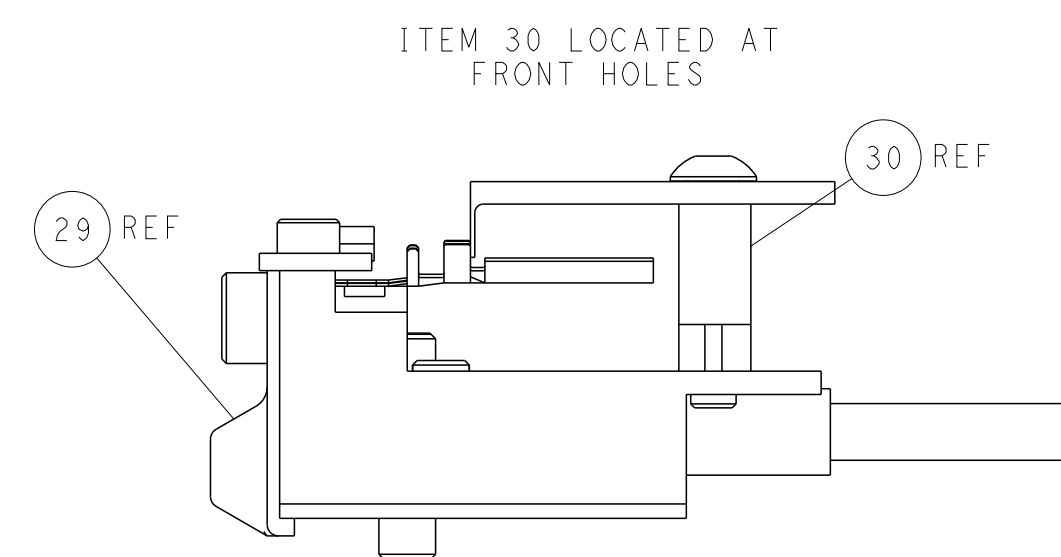
PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS




TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY WIRE BARREL

PACIFIC VERSION

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR ETCO ELECTRONICS CORPORATION IT IS THE PROPERTY OF ETCO ELECTRONICS CORPORATION IT SHOULD BE CONTACTED FOR THE LATEST REVISION</small>		DWN 16-Oct-13 CKR 16-Oct-13 G. BAILEY 16-Oct-13 APWD M. CLIFFORD 16-Oct-13		ETE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±		NAME Ocean Side Feed Applicator -	
MATERIAL -		FINISH -		WEIGHT -	
		SIZE A1		CASE CODE 00779	
		DRAWING NO C=2266117		RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:5 SHEET 4 of 4 REV A2	