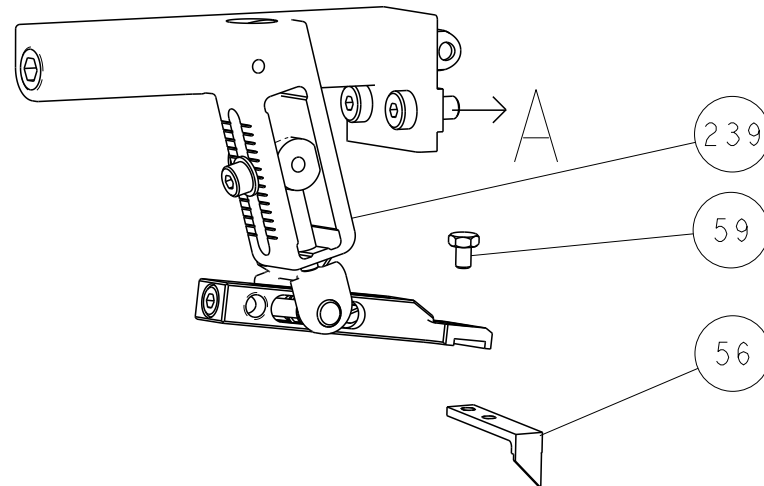


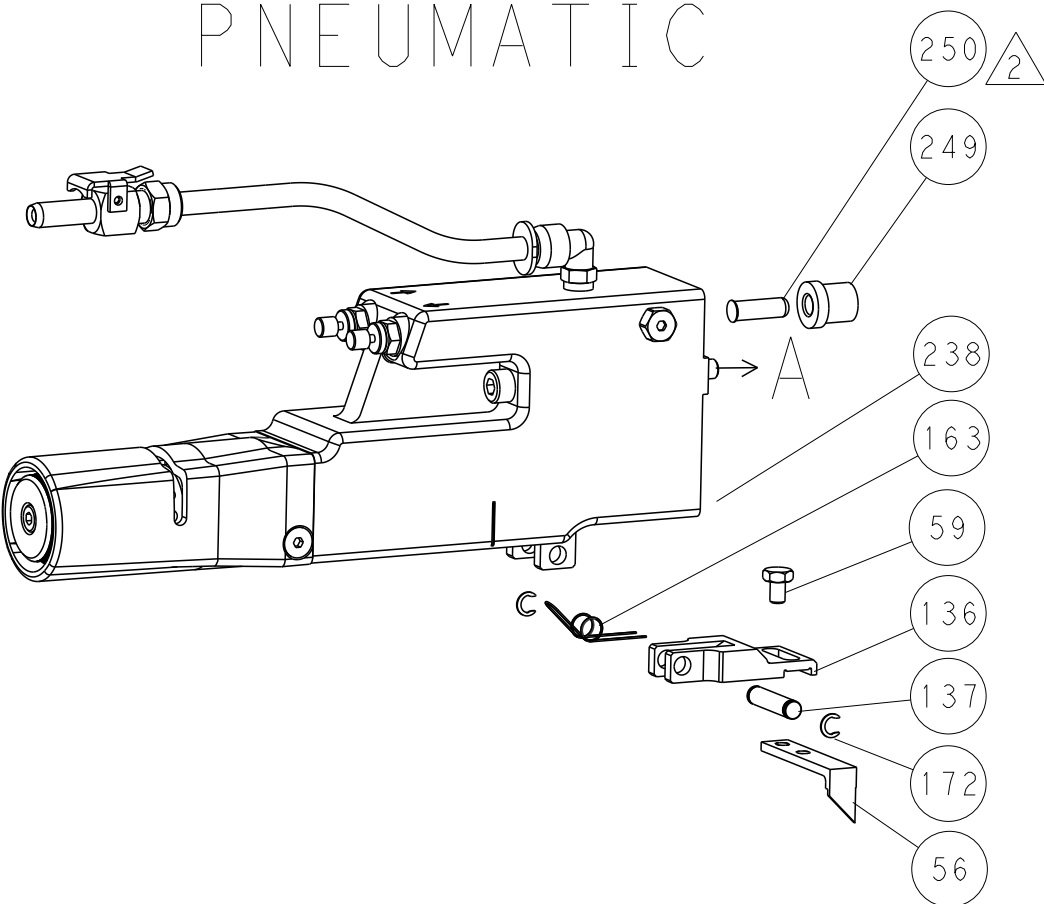


LOC		DIST		REVISIONS				
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

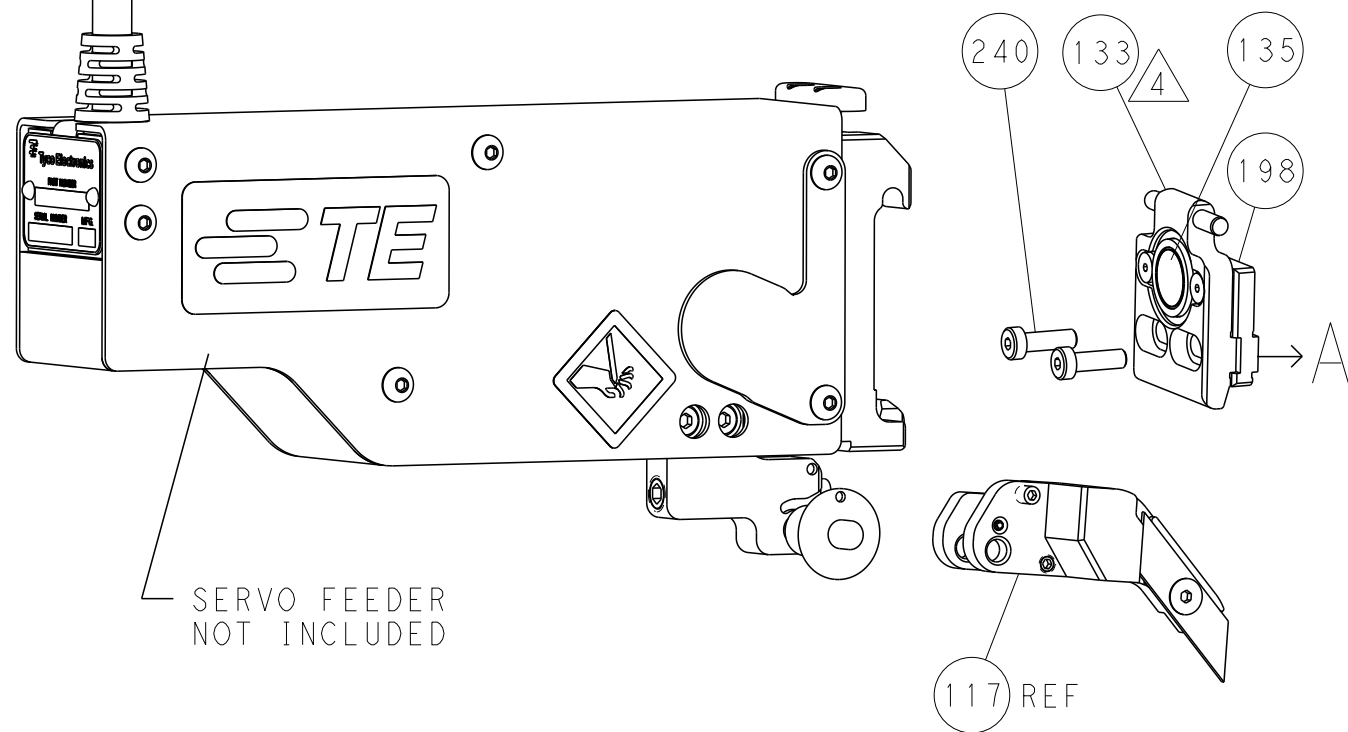
# FEED TYPE MECHANICAL



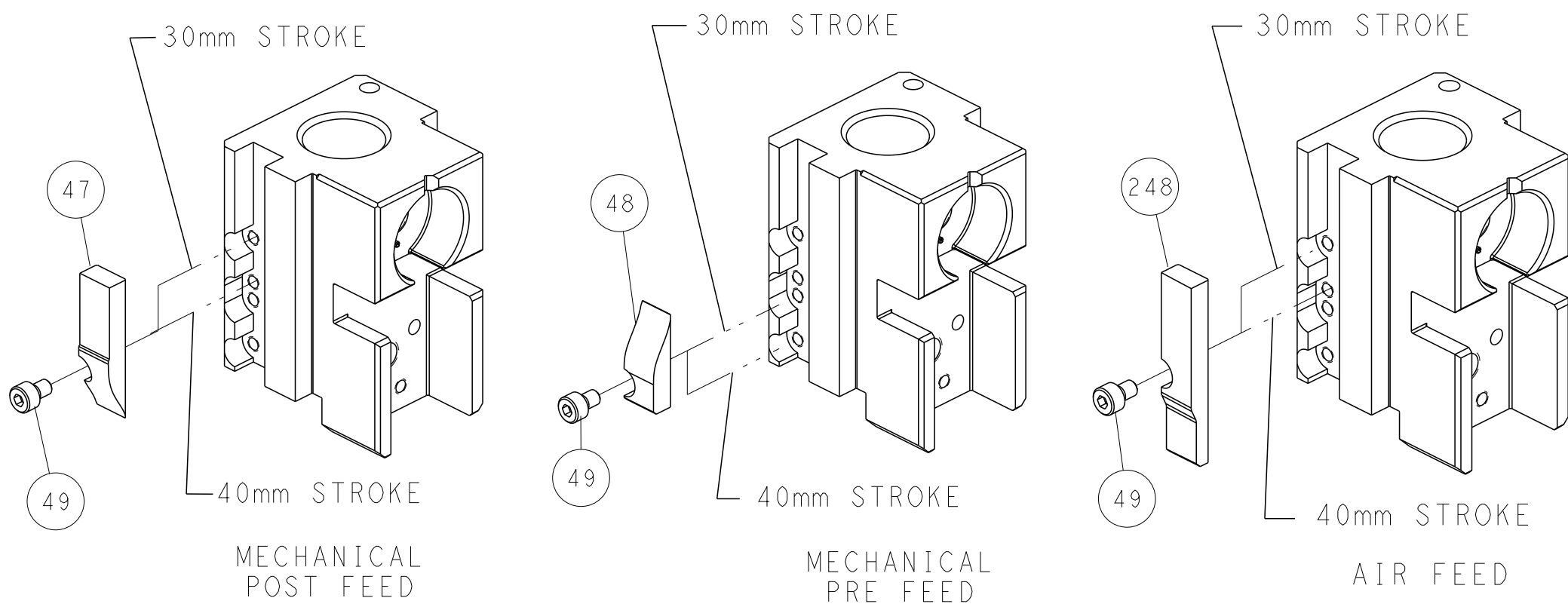
# PNEUMATIC



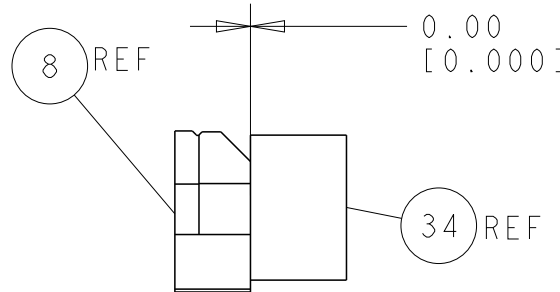
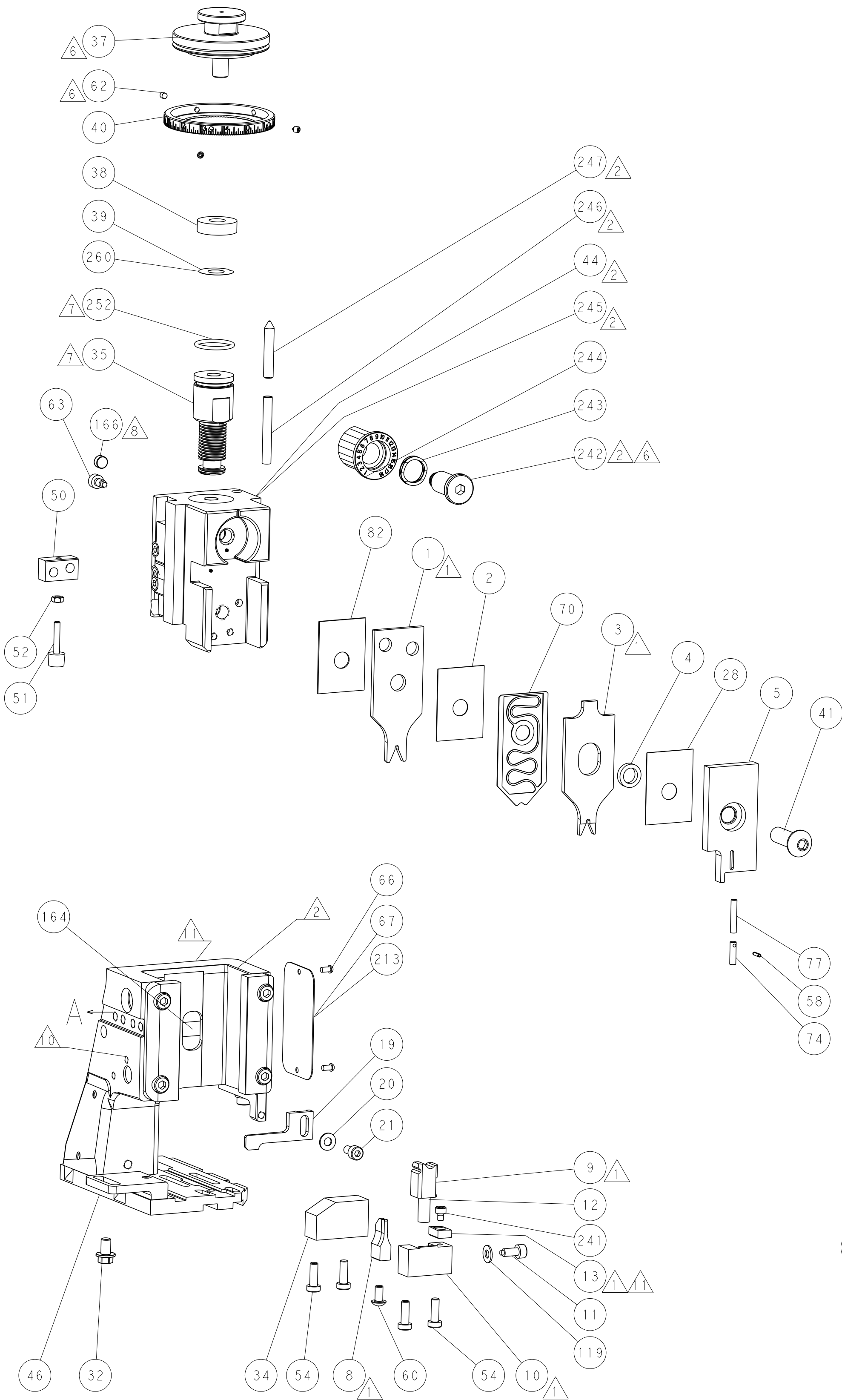
# SERVO LATCH PLATE



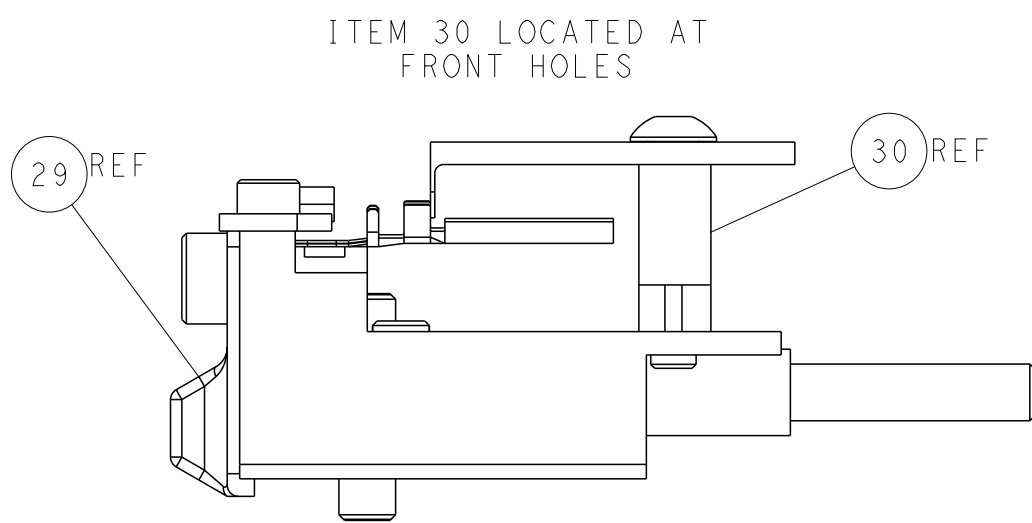
# CAM POSITIONS



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



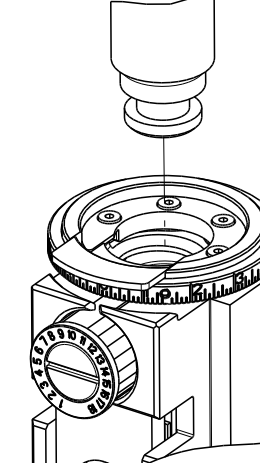
TERMINAL SUPPORT LOCATION



FEED TRACK POSITION  
GUIDE BY WIRE BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO VERIFY THE DIMENSIONS AND TOLERANCES OF THE PARTS AND ASSEMBLY BEFORE USE. IT IS THE RESPONSIBILITY OF THE USER TO CONTACT THE SUPPLIER FOR THE LATEST REVISIONS.				DWN R. KNEPPER 16-Oct-13 CHK G. BAILEY 16-Oct-13 APVD M. CLIFFORD 16-Oct-13				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME Ocean Side Feed Applicator			
mm				0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001				SIZE A1			
MATERIAL				FINISH				CAGE CODE 00779			
								DRAWING NO C=2266118			
								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					
	2-2266118-1	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	-	8-2266118-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266118-4	-	-	-
	2-2266118-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266118-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266118-4	-	-	-
	2-2266118-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	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
	2-2266118-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266118-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-
	7-2266118-8	A	APPLICATOR CONVERSION KIT	-	<sup>4</sup>						

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	2.03 mm [.080]	O
APPLICATOR INSTRUCTIONS 408-10389		

<sup>12</sup>	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 Ø1.91-2.67 mm [.075-.105 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 <sup>9</sup>
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



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266118-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266118-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266118-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- <sup>8</sup> MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> 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 Ø1.91-2.67 mm [.075-.105 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	DIS 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

<sup>6</sup>	-	-	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
<sup>8</sup>	-	-	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
<sup>7</sup>	-	-	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
<sup>7</sup>	-	-	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
1	-	-	-	-	-	-	2266118	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
<sup>6</sup>	-	-	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
	-	-	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	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
<sup>1</sup>	-	-	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
<sup>1</sup>	-	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
<sup>1</sup>	-	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
<sup>1</sup>	1	1	1	1	1	1	2-1803054-5	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	-	6
	-	-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
<sup>1</sup>	1	1	1	1	1	1	1803019-6	CRIMPER, INSULATION O	3
	-	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
<sup>1</sup>	-	1	1	1	1	1	4-1633713-4	CRIMPER, WIRE PREMIUM	1

-78 -77 -27 -25 -22 -21			PART NO		DESCRIPTION			ITEM NO
THIS DRAWING IS A CONTROLLED DOCUMENT FOR FICO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHOULD BE CONTACTED FOR THE LATEST EDITION.				OWN R.KNEPPER	16-Oct-13	 TE Connectivity Harrisburg, PA 17105-3608		
				CHK G.BAILEY	16-Oct-13			
				APVD M.CLIFFORD	16-Oct-13			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME				
mm				PRODUCT SPEC		Ocean Side Feed		
		0 PLC ±.5		APPLICATION SPEC		Applicator		
		1 PLC ±.13						
		2 PLC ±.13						
		3 PLC ±.013						
		4 PLC ±.0001						
		ANGLES ±.						
FINISH				WEIGHT		RESTRICTED TO		
MATERIAL				A1		00779		C=2266118
Customer Accessible Production Drawing				SCALE		1:2		SHEET 3 of 4
								REV A2

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

D

C

B

A

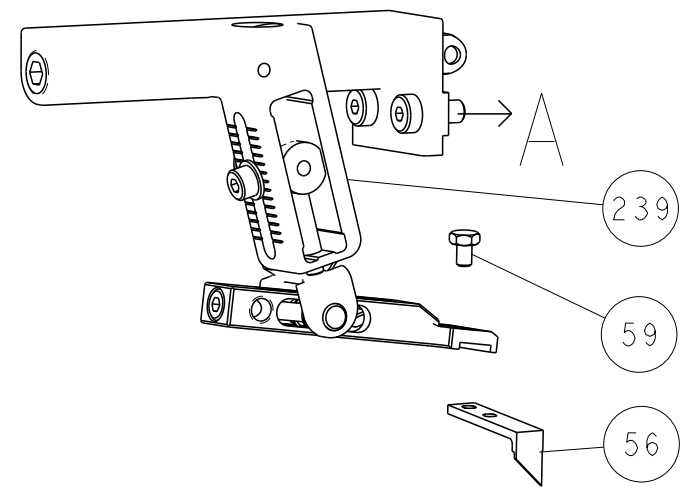
D

C

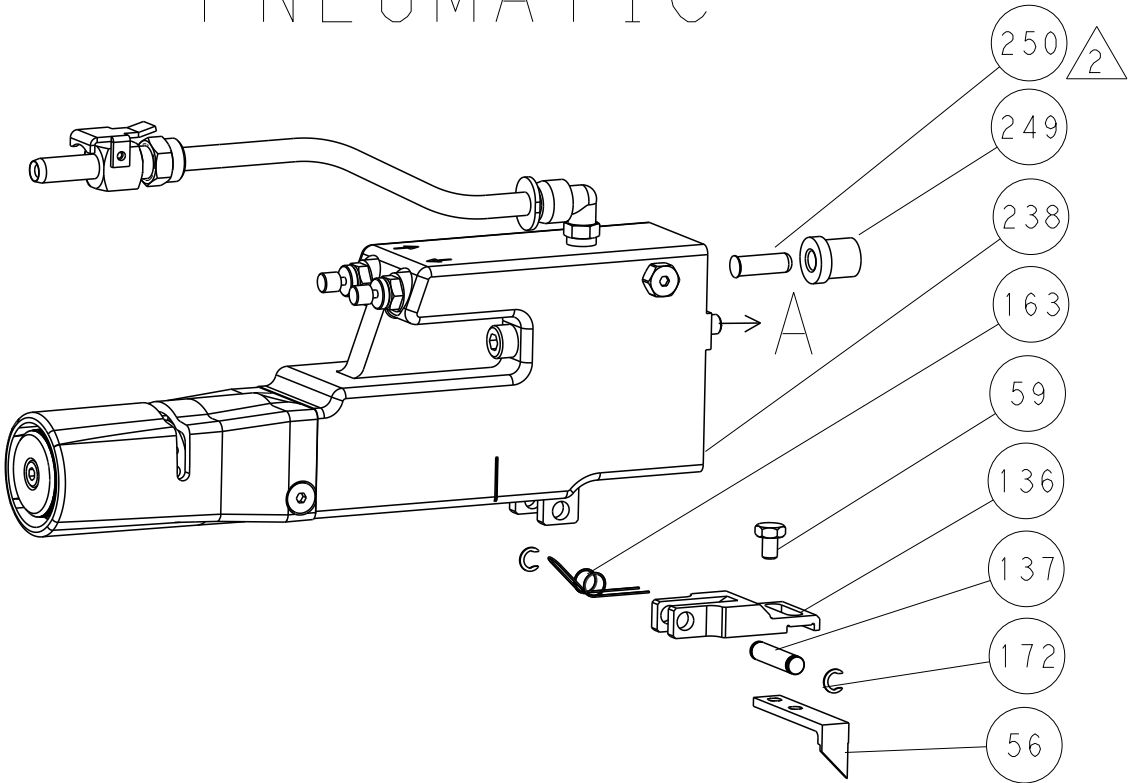
B

A

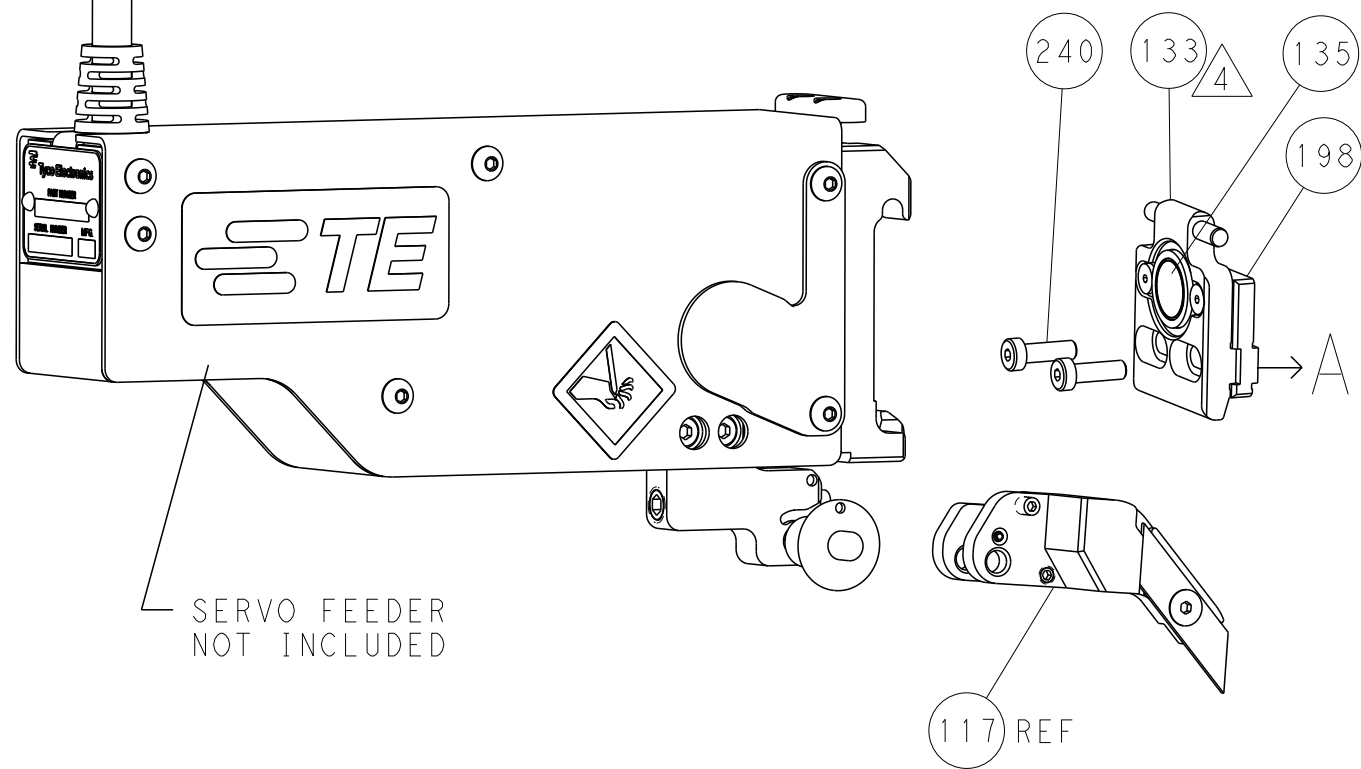
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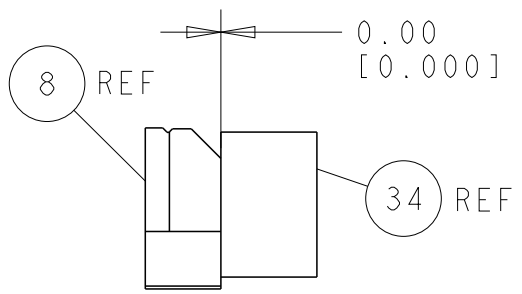
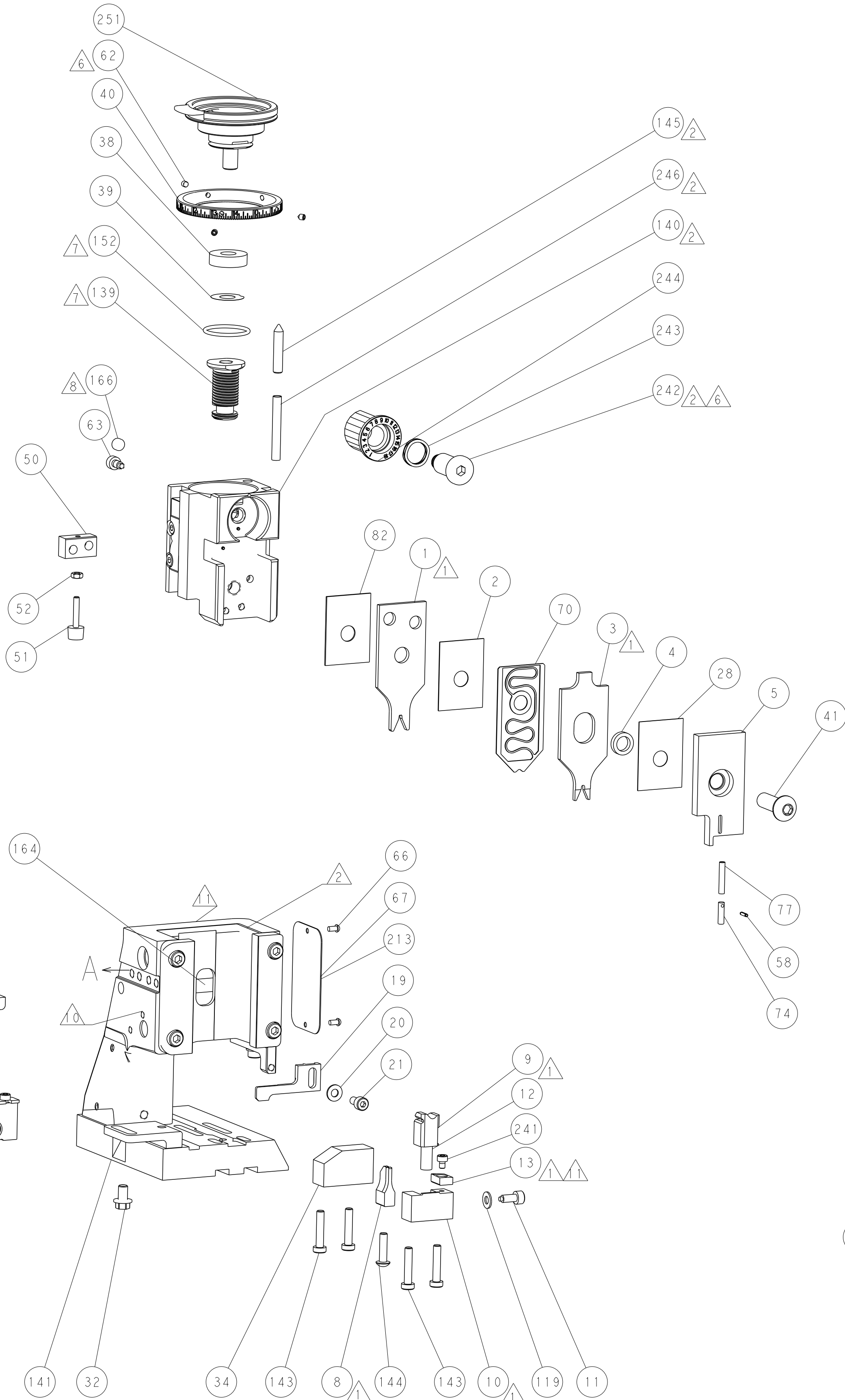
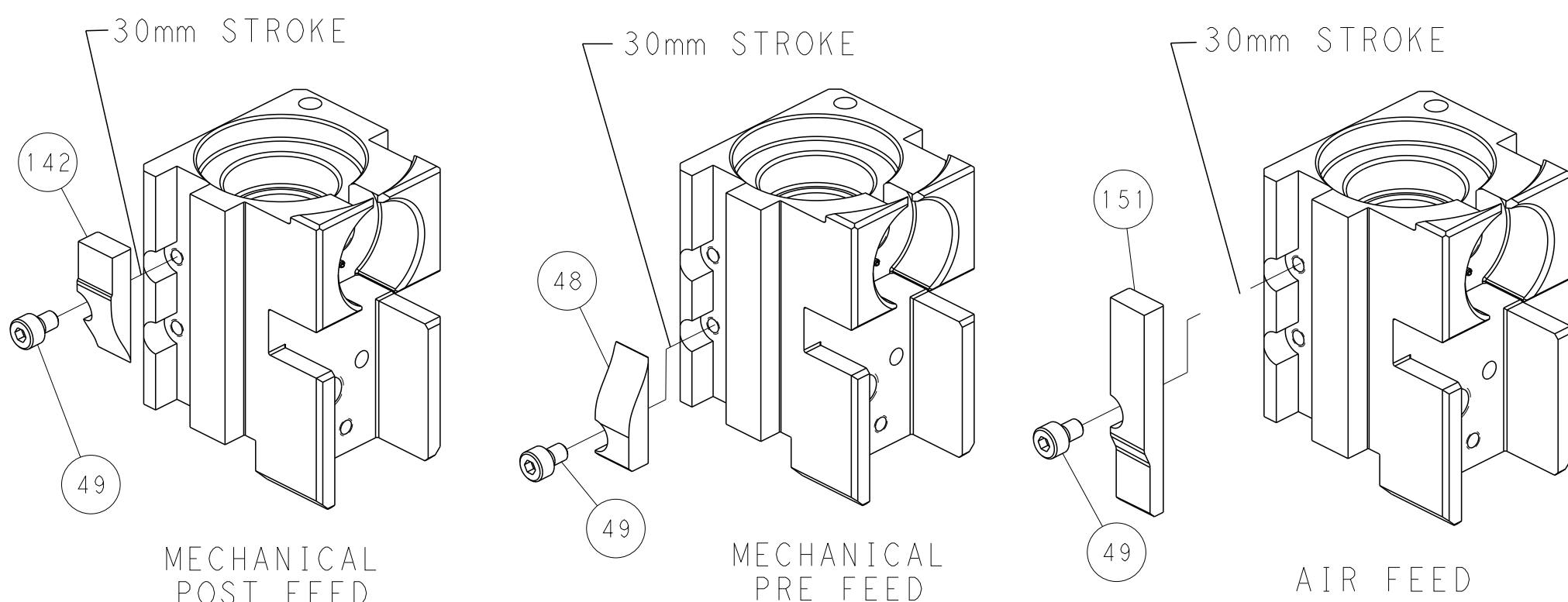
# PNEUMATIC



# SERVO LATCH PLATE

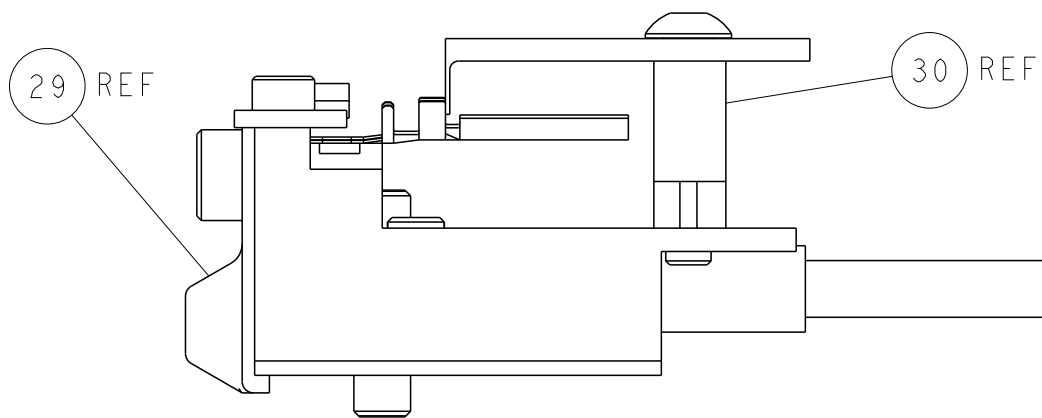


# CAM POSITIONS



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT  
FRONT HOLES



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISIONS.		DWN R. KNEPPER 16-Oct-13	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 16-Oct-13	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.5 FINISH		APVD M. CLIFFORD 16-Oct-13	SIZE A1	
MATERIAL -		PRODUCT SPEC -	CAGE CODE 00779	
		APPLICATION SPEC -	DRAWING NO C=2266118	
		WEIGHT -	RESTRICTED TO -	
		Customer Accessible Production Drawing	SCALE 1:2	
			SHEET 4	
			OF 4	
			REV A2	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION