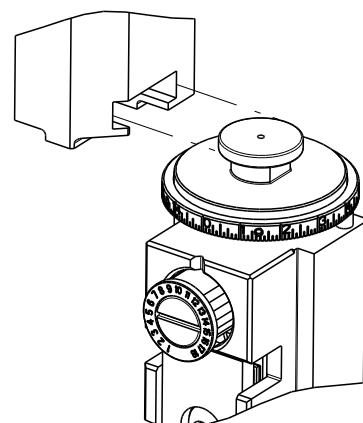








8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2266119-1	A	FINE CRIMP HEIGHT ADJUST
	2266119-2	A	FINE CRIMP HEIGHT ADJUST
	2266119-5	A	FINE CRIMP HEIGHT ADJUST
	2266119-6	A	NON-CRIMP HEIGHT ADJUST
	2266119-7	A	FINE CRIMP HEIGHT ADJUST
	7-2266119-7	A	CRIMP TOOLING KIT
	7-2266119-8	A	APPLICATOR CONVERSION KIT


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	1.73 mm [.068]	O
APPLICATOR INSTRUCTIONS 408-10389		

13	APPLICATOR CONVERSION KITS	
PART NUMBER	INSULATION DIAMETER RANGE	
7-2266116-8	Ø 2.67-3.18mm [.105-.125]	
7-2266117-8	Ø 2.16-2.82mm [.085-.111]	
7-2266118-8	Ø 1.91-2.67mm [.075-.105]	
7-2266119-8	Ø 1.62-2.16mm [.064-.085]	
7-2266120-8	Ø 1.27-1.91mm [.050-.075]	

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT PIN SIZE 20			
WIRE STRIP LENGTH 3.81-5.09 mm [1.50-.200 IN]		INSULATION DIAMETER RANGE Ø1.62-2.16 mm [0.064-.085 IN]	
TERMINAL APPLICATION  0425-059-0000 Rev L		-	-
SPECIFICATION		-	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
1572032-3	1060-20-0222	1572032-4	1060-20-0244
1572032-8	1060-20-0277		

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20			
WIRE STRIP LENGTH 3.81-5.09 mm [1.50-.200 IN]		INSULATION DIAMETER RANGE Ø1.62-2.16 mm [1.064-.085 IN]	
TERMINAL APPLICATION SPECIFICATION 0425-059-0000 Rev L		- -	
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
286680-3	1062-20-0222	286680-4	1062-20-0244
1-286680-1	1062-20-0277		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
1.50mm2			1.47+0.03/-0.05 [0.058+0.001/-0.002]		3.4	
16 AWG			1.27+0.03/-0.05 [0.050+0.001/-0.002]		5.4	
1.00mm2			1.27+0.03/-0.05 [0.050+0.001/-0.002]		5.4	
18 AWG			1.24+0.03/-0.05 [0.049+0.001/-0.002]		5.7	
0.75mm2			1.22+0.03/-0.05 [0.048+0.001/-0.002]		5.9	
0.60mm2			1.07+0.03/-0.05 [0.042+0.001/-0.002]		7.4	
20 AWG			0.99+0.03/-0.05 [0.039+0.001/-0.002]		8.2	
0.50mm2			0.97+0.03/-0.05 [0.038+0.001/-0.002]		8.4	
22 AWG			0.94+0.03/-0.05 [0.037+0.001/-0.002]		8.7	
0.35mm2			0.94+0.03/-0.05 [0.037+0.001/-0.002]		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: 8-2266119-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266119-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266119-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266119-6
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 3
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 P

-	-	-	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)

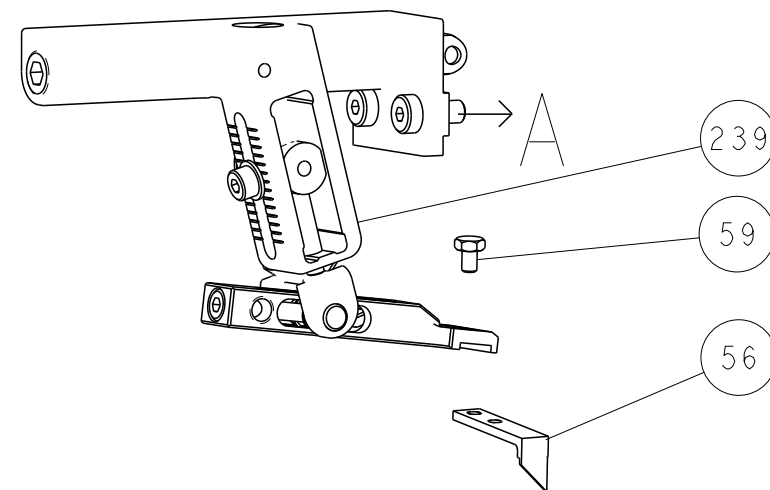
SET UP GAUGE 2119599-1				LOC A	DIST 66	REVISIONS						
		P	LTR	DESCRIPTION			DATE	DWN	APVD			
		A2		ECR-15-005520			09APR2015	MR	TE			
1	-	-	-	2119758-1			RAM, AMP STYLE, SIDE FEED, NON-ADJ.		245			
1	1	1	1	2119082-9			CAM, SNAIL, INSULATION ADJUSTMENT		244			
1	1	1	1	2079764-1			WASHER, WAVE SPRING, CREST-TO-CREST		243			
1	1	1	1	2119083-1			RETAINER, INSULATION DIAL		242			
1	1	1	1	7-18023-7			SCR, SKT HD CAP M3 X 4.0		24			
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	994969-1			MAGNET, RARE EARTH HIGH ENERGY		166			
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	1-18028-2			WASHER, FLAT, REG M4		119			
REF	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			
-	-	-	-	2266119			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	2119740-1			TAG IDENTIFICATION		67			
2	2	2	2	2168078-1			SCREW, DRIVE, RH, RoHS, 2 x .188		66			
-	1	1	1	2119793-1			LIMITER, ADJUSTMENT BOLT		63			
-	3	3	3	992763-5			SCR, SET, SOC, CONE POINT, M3 x 4.0		62			
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	21028-2			PIN, SLOTTED SPRING .062 X .250		58			
-	-	1	1	1338685-1			PAWL, FEED		56			
4	4	4	4	2168400-1			SHCS, LOW HEAD, RoHS, M4 X 12		54			
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	2119653-1			FEED CAM, POST FEED		47			
1	1	1	1	2119656-9			APPLICATOR BASIC ASSEMBLY, SF		46			
-	1	1	1	2119370-1			RAM, AMP STYLE, SIDE FEED		44			
1	1	1	1	2079383-7			SCR, BHSC, RoHS (M8 X 25)		41			
-	1	1	1	2119645-1			DISC, NUMBERED FA WIRE ADJUSTMENT		40			
-	1	1	1	2119957-1			APPLICATOR SHIM PACK		39			
1	1	1	1	2119644-1			RAM WASHER, PRECISION		38			
1	1	1	1	2119085-1			FA HEAD, ATLANTIC STYLE		37			
-	1	1	1	2119092-1			BOLT, ADJUSTMENT		35			
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	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	2-1803054-6			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	1803019-7			CRIMPER, INSULATION O		3			
1	1	1	1	455888-4			SPACER, CRIMPER		2			
1	1	1	1	4-1633713-4			CRIMPER, WIRE PREMIUM		1			

-	-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245		
-	-	-	1	1	1	1	2119082-9	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		
-	-	-	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		
-	-	-	-	-	-	-	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	
-	-	-	-	-	-	-	-	240638-1	SPRING, FEED FINGER	163	
-	-	-	-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	-	-	-	-	-	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	1	455888-7	SPACER, CRIMPER	82
-	-	-	1	1	1	1	1	1	22278-8	SPRING, COMPRESSION	77
-	-	-	1	1	1	1	1	1	854769-4	HOLDER, INS	74
1	-	-	-	-	-	-	-	-	2266119	PRINT, APPLICATOR LOG SHEET	72
-	-	-	1	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	-	-	1	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	-	-	1	-	-	-	-	-	2119740-1	TAG, IDENTIFICATION	67
-	-	-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	-	1	-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	-	-	3	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	1	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	-	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	-	-	-	1	1	1	1338685-1	PAWL, FEED	56
-	-	-	4	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	-	2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	-	-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	-	-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	-	-	1	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	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	-	1	-	1	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	-	-	1	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	-	-	1	-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	-	-	1	-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	-	-	1	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	-	-	1	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	-	-	1	-	1	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	-	-	1	1	1	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	-	-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	-	1	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	-	-	1	1	1	1	1	1	1-1320908-0	SPACER, STRIP GUIDE	30
-	-	-	1	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	-	-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	-	-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	-	-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	-	-	1	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	-	-	1	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	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	-	-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	-	-	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1	1	1	2-1803054-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	-	-	6
-	-	-	1	1	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	-	-	1	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1	1	1	1803019-7	CRIMPER, INSULATION O	3
-	-	-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	-	-	1	1	1	1	1	1	4-1633713-4	CRIMPER, WIRE PREMIUM	1

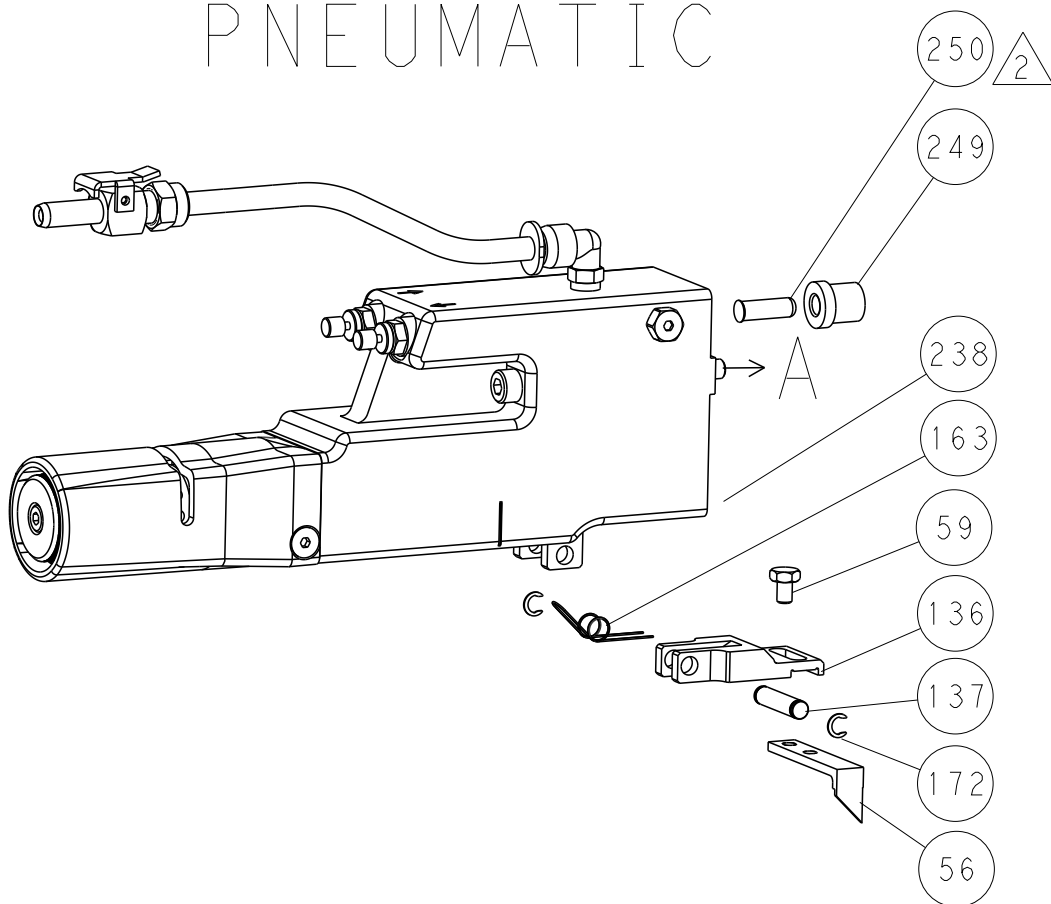
1. IT IS REQUESTED THAT YOU COMPLETE THIS FORM FOR ALL CUSTOMER ORDER INFORMATION. 2. IT IS REQUESTED THAT YOU COMPLETE THIS FORM FOR ALL CUSTOMER ORDER INFORMATION.		DWG E. KNEPPER 16-Oct-13		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
		0 P L C ±. 1 P L C ±0.5 2 P L C ±0.13 3 P L C ±0.013 4 P L C ±0.0001 ANGLES ±° FINISH		Ocean Side Feed Applicator -	
MATERIAL -		WEIGHT -		SIZE CAGE CODE DRAWING NO RESTRICTED TO A 00779 C-2266119 -	
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	-	-	-	

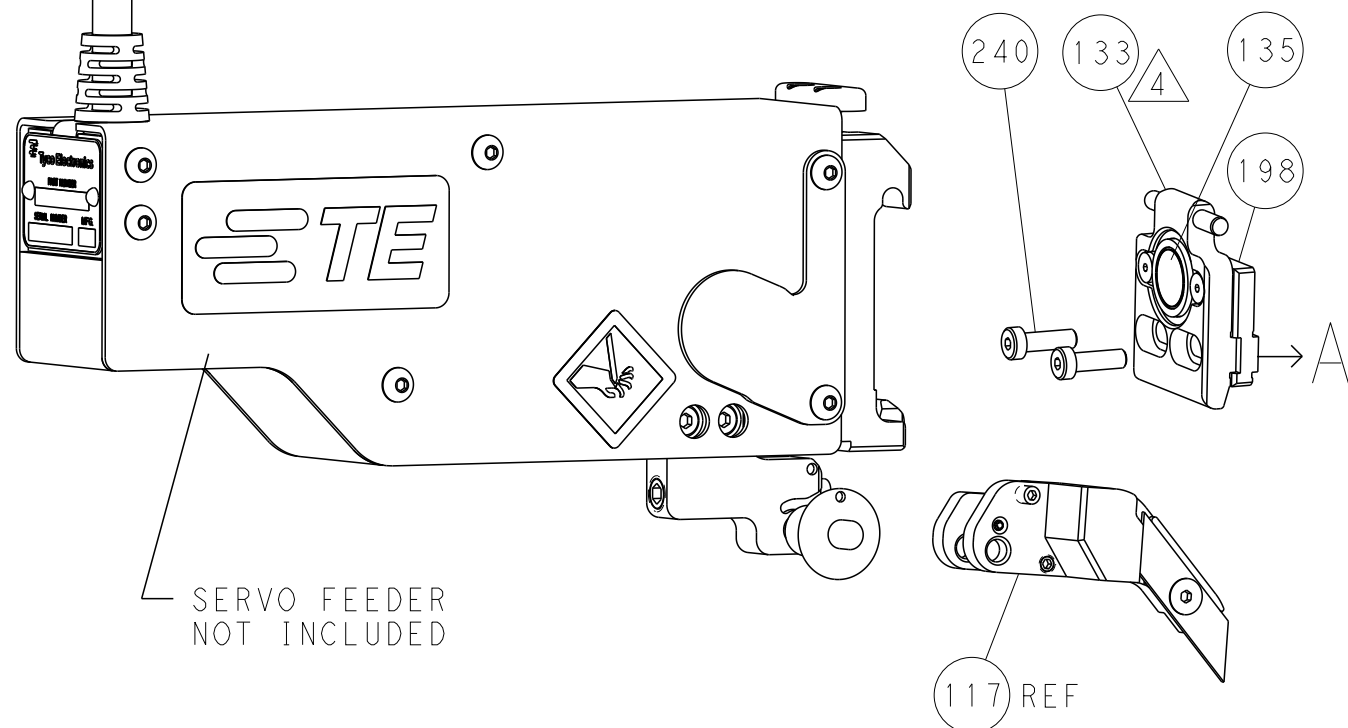
FEED TYPE MECHANICAL



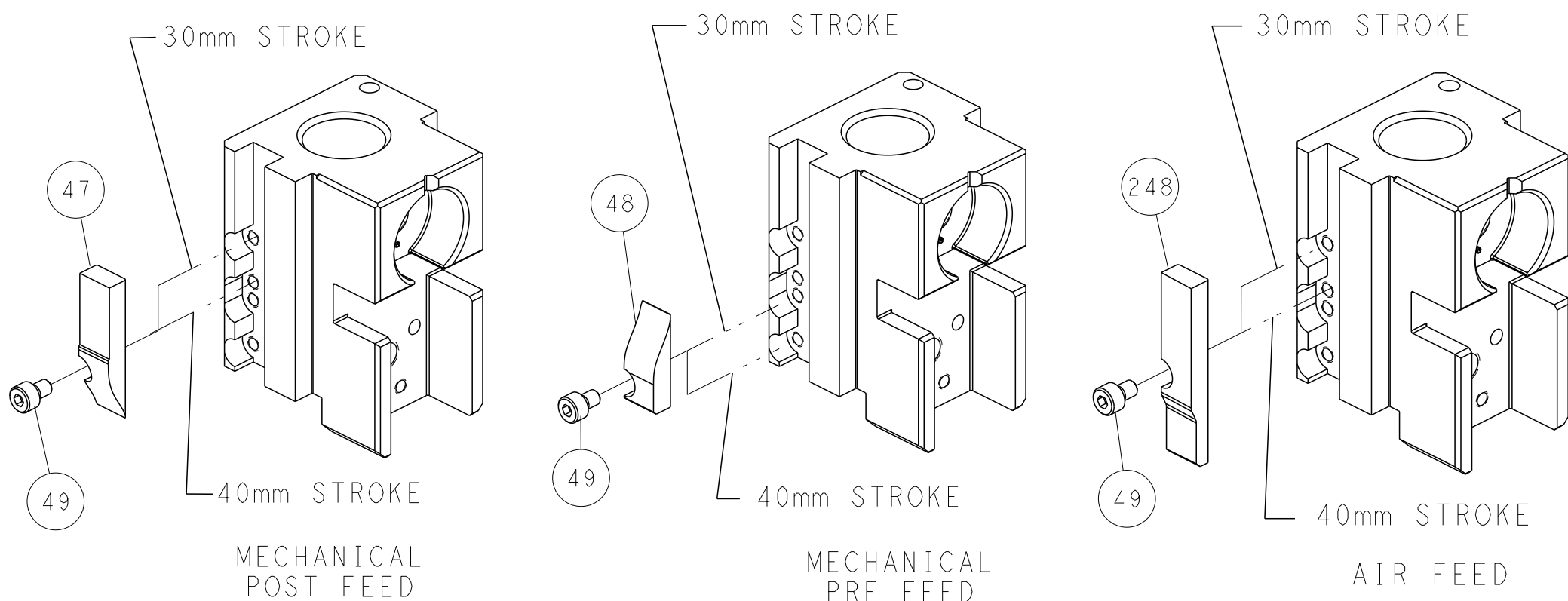
PNEUMATIC



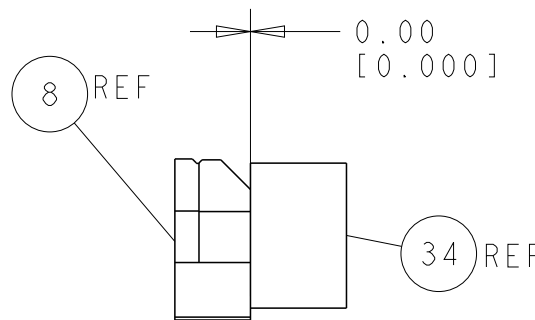
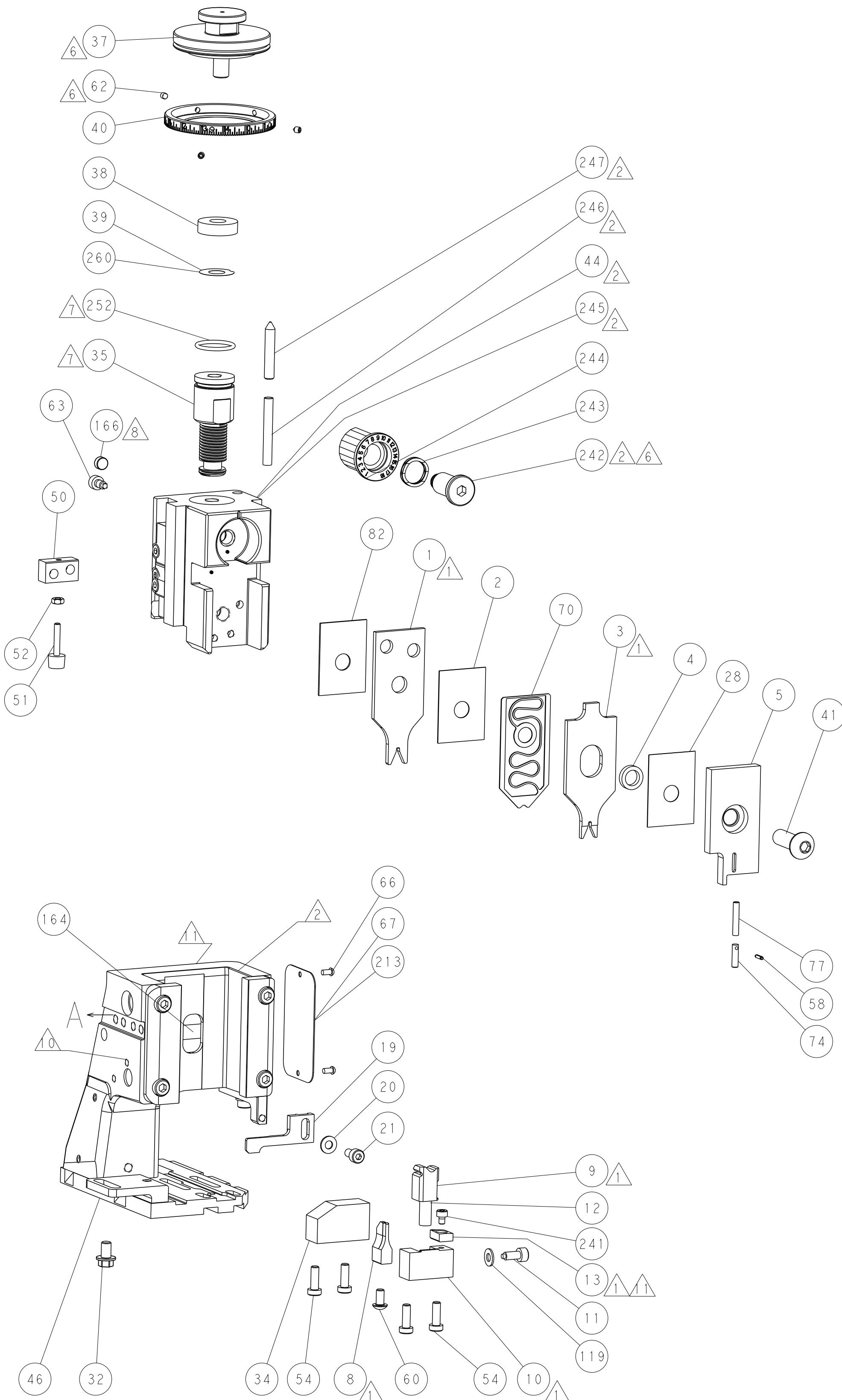
SERVO LATCH PLATE



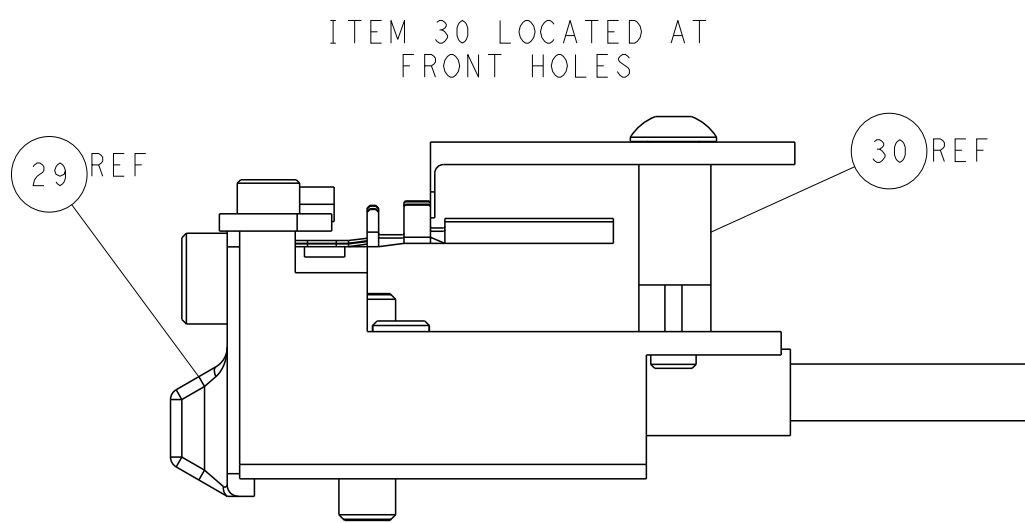
CAM POSITIONS



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.				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: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH				NAME Ocean Side Feed Applicator			
MATERIAL				WEIGHT				SIZE CAGE CODE DRAWING NO. 00779 C=2266119			
				Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV A2			


SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2266119-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2-2266119-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2266119-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 
	2-2266119-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2266119-7	A	CRIMP TOOLING KIT	-
	7-2266119-8	A	APPLICATOR CONVERSION KIT	- 

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	1.73 mm [.068]	O





APPLICATOR INSTRUCTIONS
408-10389



APPLICATOR CONVERSION KITS	
PART NUMBER	INSULATION DIAMETER RANGE
7-2266116-8	Ø 2.67-3.18mm [.105-.125]
7-2266117-8	Ø 2.16-2.82mm [.085-.111]
7-2266118-8	Ø 1.91-2.67mm [.075-.105]
7-2266119-8	Ø 1.62-2.16mm [.064-.085]
7-2266120-8	Ø 1.27-1.91mm [.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 Ø1.62-2.16 mm [.064-.085 IN]	
TERMINAL APPLICATION  0425-059-0000 Rev L		-	-
SPECIFICATION		-	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
1572032-3	1060-20-0222	1572032-4	1060-20-0244
1572032-8	1060-20-0277		

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20			
WIRE STRIP LENGTH 3.81-5.09 mm [1.50-.200 IN]		INSULATION DIAMETER RANGE Ø1.62-2.16 mm [1.064-.085 IN]	
TERMINAL APPLICATION 0425-059-0000 Rev L		-	
SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
286680-3	1062-20-0222	286680-4	1062-20-0244
1-286680-1	1062-20-0277		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
1.50mm2			1.47+0.03/-0.05 [0.058+0.001/-0.002]		3.4	
16 AWG			1.27+0.03/-0.05 [0.050+0.001/-0.002]		5.4	
1.00mm2			1.27+0.03/-0.05 [0.050+0.001/-0.002]		5.4	
18 AWG			1.24+0.03/-0.05 [0.049+0.001/-0.002]		5.7	
0.75mm2			1.22+0.03/-0.05 [0.048+0.001/-0.002]		5.9	
0.60mm2			1.07+0.03/-0.05 [0.042+0.001/-0.002]		7.4	
20 AWG			0.99+0.03/-0.05 [0.039+0.001/-0.002]		8.2	
0.50mm2			0.97+0.03/-0.05 [0.038+0.001/-0.002]		8.4	
22 AWG			0.94+0.03/-0.05 [0.037+0.001/-0.002]		8.7	
0.35mm2			0.94+0.03/-0.05 [0.037+0.001/-0.002]		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: 8-2266119-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266119-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266119-5
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



	5		4	3		
APPLICATOR STYLE CONVERSION CHART						
CONVERT TO	PART NUMBERS REQUIRED					
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
SERVO LATCH PLATE	2119951-1	-	8-2266119-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2266119-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
SERVO LATCH PLATE	2119951-1	-	8-2266119-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2266119-4	-	-	-
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
-	-	-	-	-	-	-
-	-	-	-	-	-	-

-	-	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)

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

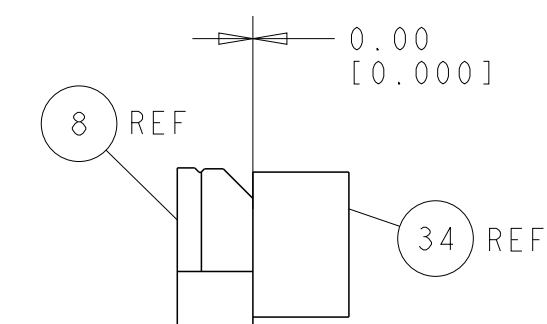
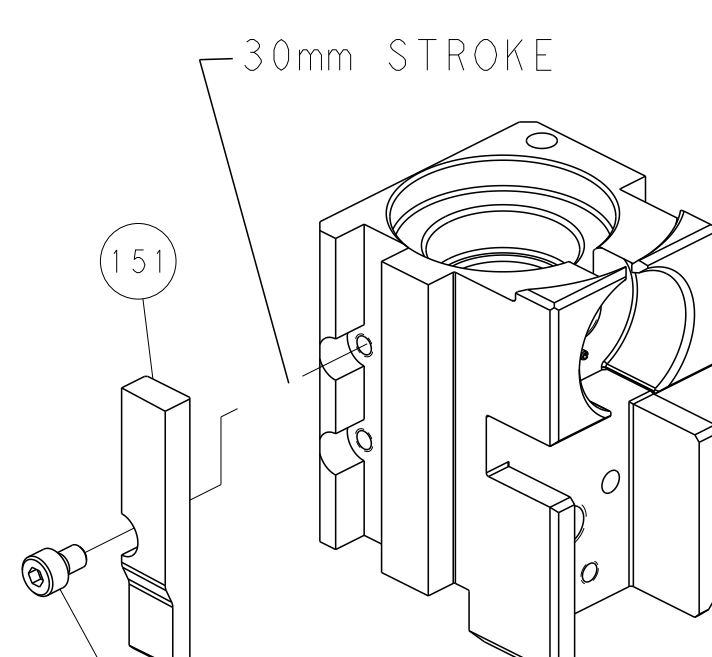
6	-	-	1	1	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
8	-	-	-	-	1	-	2063440-1	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
7	-	-	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
7	-	-	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
6	-	-	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
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	-	-	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
6	-	-	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
6	-	-	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
6	-	-	-	-	-	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
6	-	-	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	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	1	2-1803054-6	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	1803019-7	CRIMPER, INSULATION O	3
	-	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	-	1	1	1	1	1	4-1633713-4	CRIMPER, WIRE PREMIUM	1
	-78	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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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 ±°		OWN R. KNEPPER 16-Oct-13 CHK C. BAILEY 16-Oct-13 APVD M. CLIFFORD 16-Oct-13		 TE Connectivity Harrisburg, PA 17105-3608			
				NAME Ocean Side Feed Applicator		SIZE CASE CODE DRAWING NO RESTRICTED TO A1 00779 C=2266119 -			
MATERIAL -		FINISH -		WEIGHT -		SCALE 1:2 SHEET 3 OF 4 REV. A2			
Customer Accessible Production Drawing									

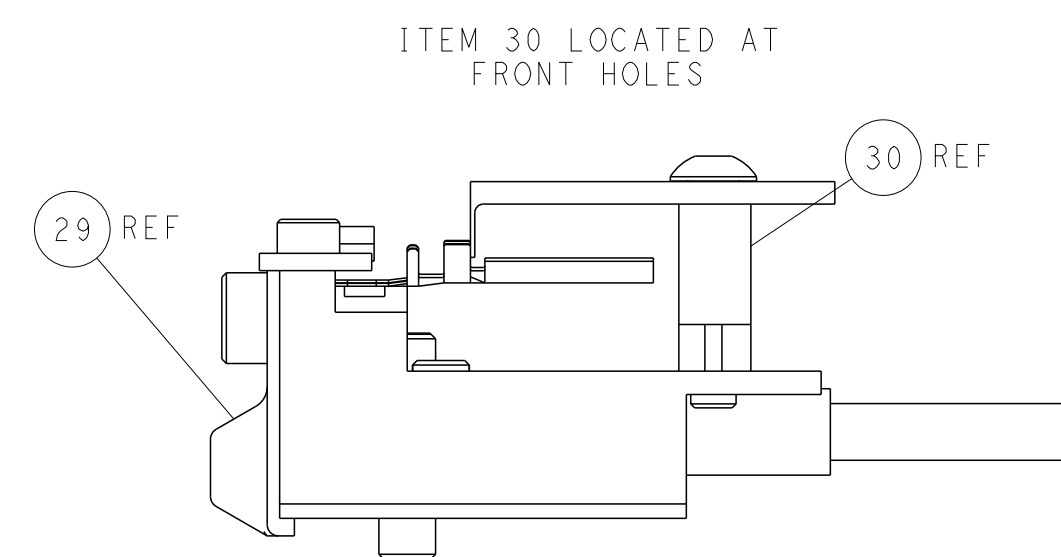
PNEUMATIC

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)

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		WEIGHT -	
				DRAWING NO C=2266119	
				RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:1 SHEET 4 of 4 REV A2	