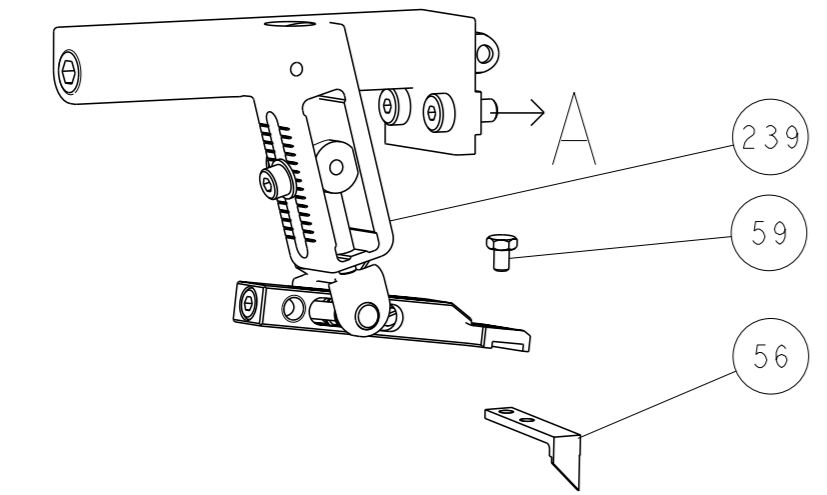
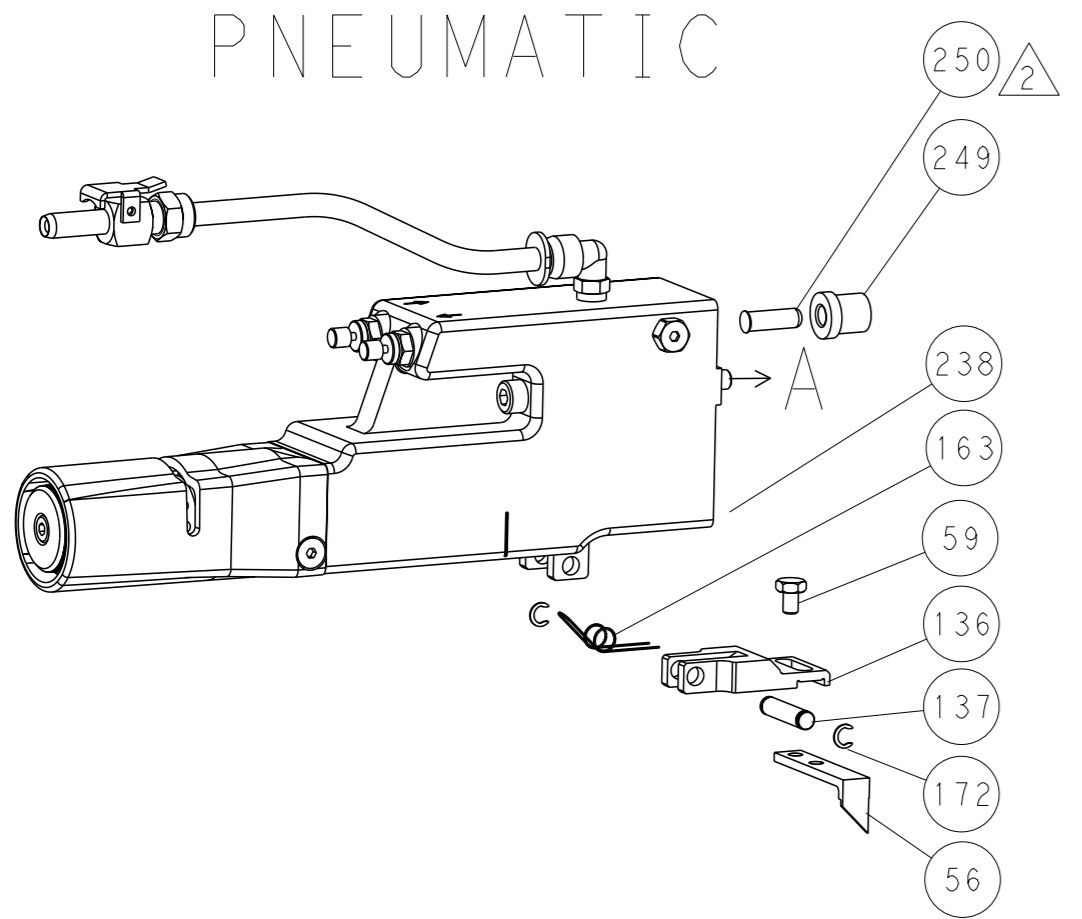


LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

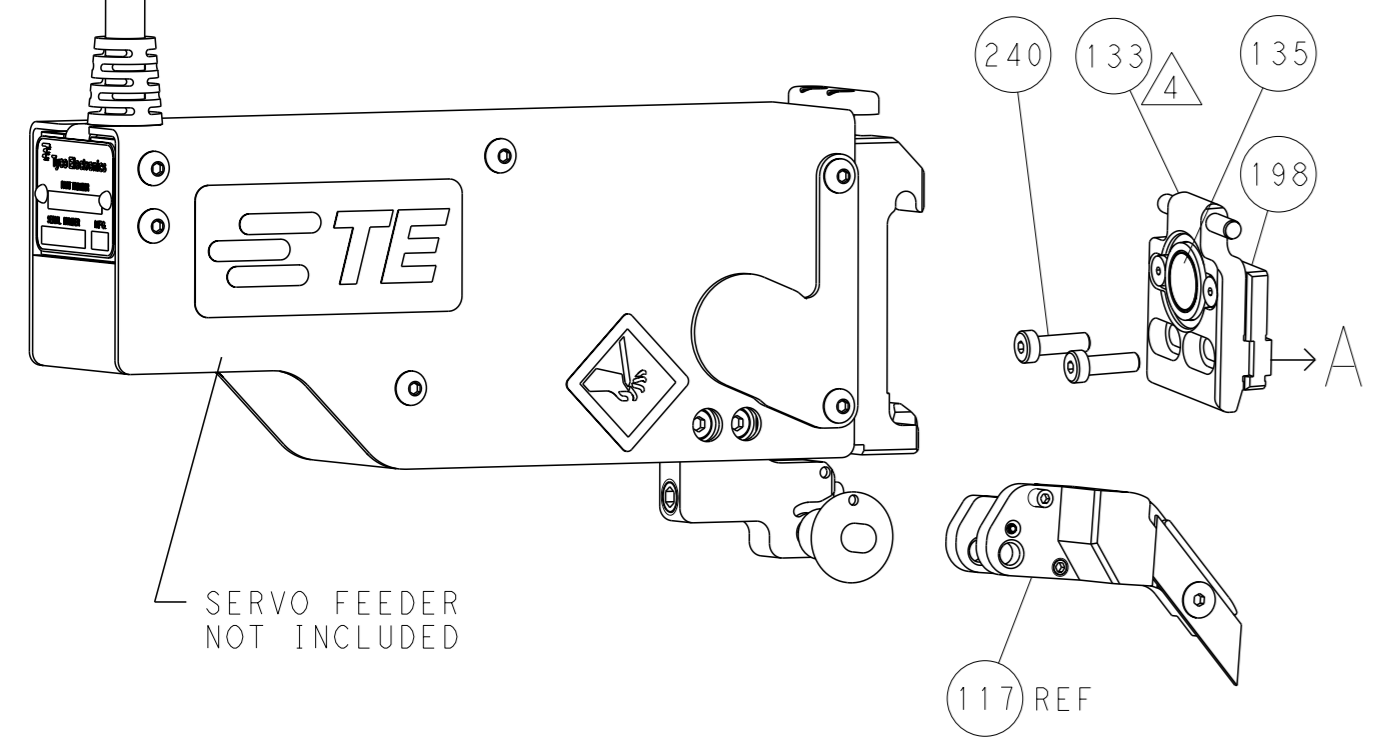
FEED TYPE MECHANICAL



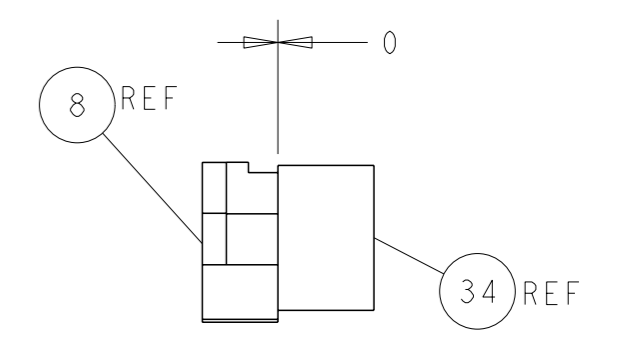
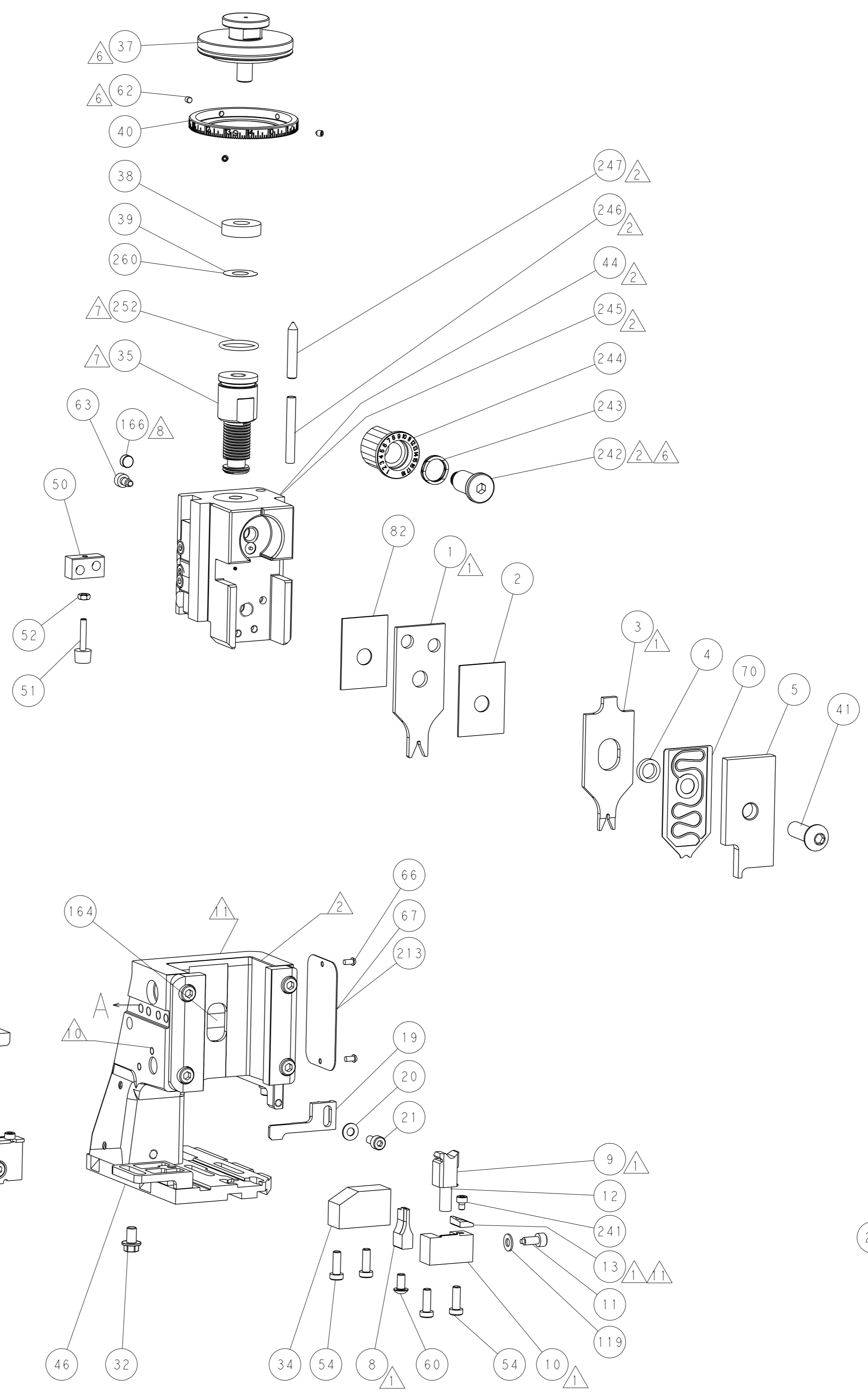
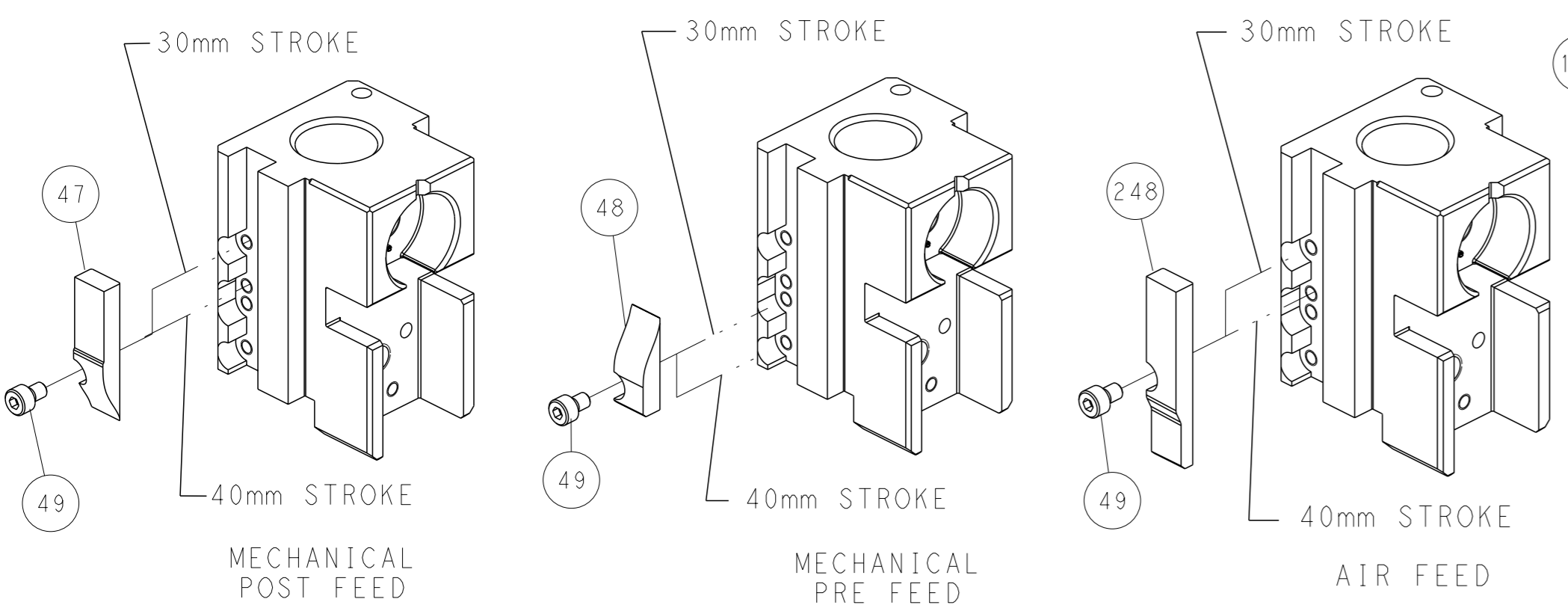
PNEUMATIC



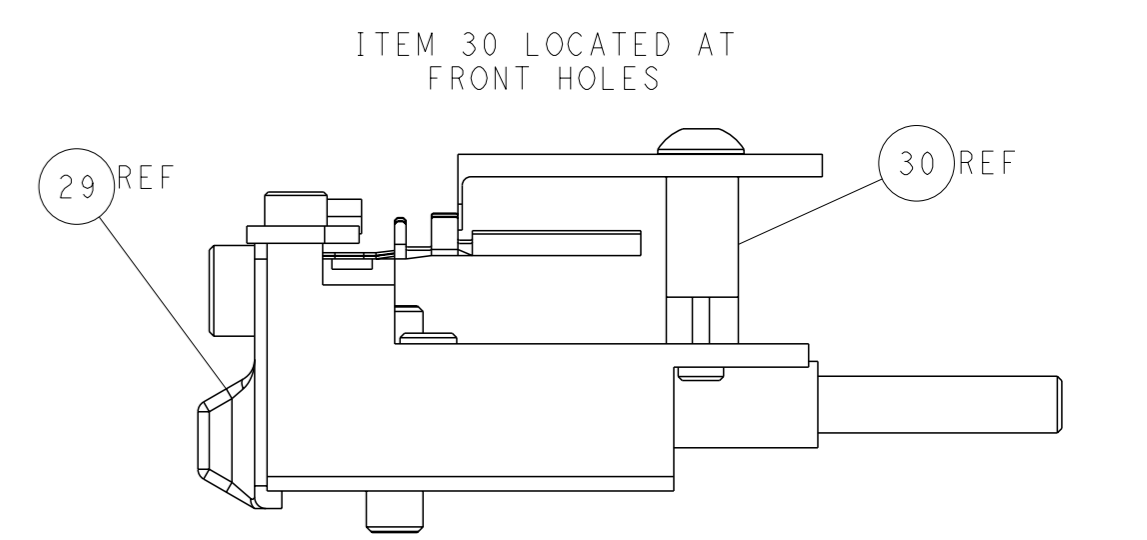
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: R. KNEPPER CHK: G. BAILEY APVD: M. CLIFFORD	DATE: 16-Oct-13 DATE: 16-Oct-13 DATE: 16-Oct-13	NAME: Ocean Side Feed Applicator	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266119	RESTRICTED TO: -
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: C	Customer Accessible Production Drawing				

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266119-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266119-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
2-2266119-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
2-2266119-7	C	FINE CRIMP HEIGHT ADJUST	NONE
7-2266119-7	C	CRIMP TOOLING KIT	-
7-2266119-8	C	APPLICATOR CONVERSION KIT	- ⁴

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 2.74-3.18mm [.108-.125]
7-2266117-8	Ø 2.31-2.72mm [.091-.107]
7-2266118-8	Ø 1.91-2.29mm [.075-.090]
7-2266119-8	Ø 1.60-2.16mm [.063-.085]
7-2266120-8	Ø 1.27-1.57mm [.050-.062]

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT PIN SIZE 20			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TE TERMINAL	DEUTSCH TERMINAL
3.81-5.09 mm [.150-.200 IN]	Ø 1.60-2.16 mm [.063-.085 IN]	1572032-3	1060-20-0222
3.81-5.09 mm [.150-.200 IN]	Ø 1.60-2.16 mm [.063-.085 IN]	1572032-4	1060-20-0244
3.81-5.09 mm [.150-.200 IN]	Ø 1.60-2.16 mm [.063-.085 IN]	1572032-8	1060-20-0277

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TE TERMINAL	DEUTSCH TERMINAL
3.81-5.09 mm [.150-.200 IN]	Ø 1.60-2.16 mm [.063-.085 IN]	286680-3	1062-20-0222
3.81-5.09 mm [.150-.200 IN]	Ø 1.60-2.16 mm [.063-.085 IN]	286680-4	1062-20-0244
3.81-5.09 mm [.150-.200 IN]	Ø 1.60-2.16 mm [.063-.085 IN]	1-286680-1	1062-20-0277

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.47+0.03/-0.05 [.058+.001/-0.002]	3.4
16 AWG	1.27+0.03/-0.05 [.050+.001/-0.002]	5.4
1.00mm2	1.27+0.03/-0.05 [.050+.001/-0.002]	5.4
18 AWG	1.24+0.03/-0.05 [.049+.001/-0.002]	5.7
0.75mm2	1.22+0.03/-0.05 [.048+.001/-0.002]	5.9
0.60mm2	1.07+0.03/-0.05 [.042+.001/-0.002]	7.4
20 AWG	0.99+0.03/-0.05 [.039+.001/-0.002]	8.2
0.50mm2	0.97+0.03/-0.05 [.038+.001/-0.002]	8.4
22 AWG	0.94+0.03/-0.05 [.037+.001/-0.002]	8.7
0.35mm2	0.94+0.03/-0.05 [.037+.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 RANGE AND MEMORY CHIP.
- 13 TERMINAL LUBRICANT IS RECOMMENDED.

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			

-78	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO
-	-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250

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

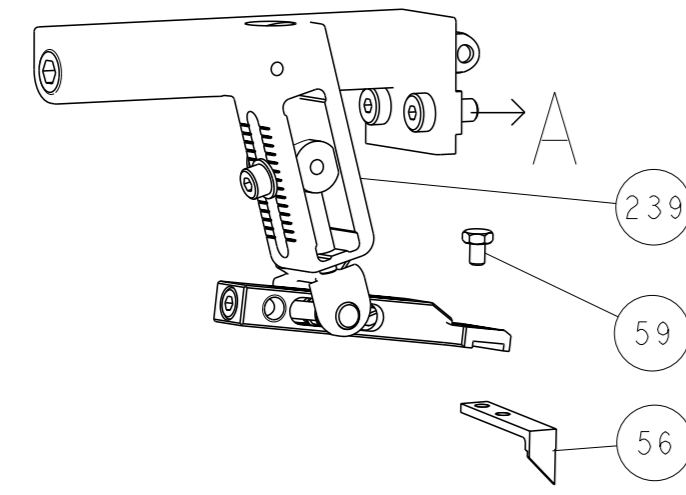
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	-	-	-	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
-	-	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
-	-	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
-	-	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	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	-	1	1	1	1	455888-7	SPACER, CRIMPER	82
1	-	-	-	-	-	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	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	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	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	1	1	1-1803293-5	ANVIL, COMBINATION DEUTSCH STYLE	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	-	1	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1803019-7	CRIMPER, INSULATION O	3
-	-	1	1	1	1	455888-8	SPACER, CRIMPER	2
-	-	1	1	1	1	1803364-2	CRIMPER, WIRE PREMIUM	1

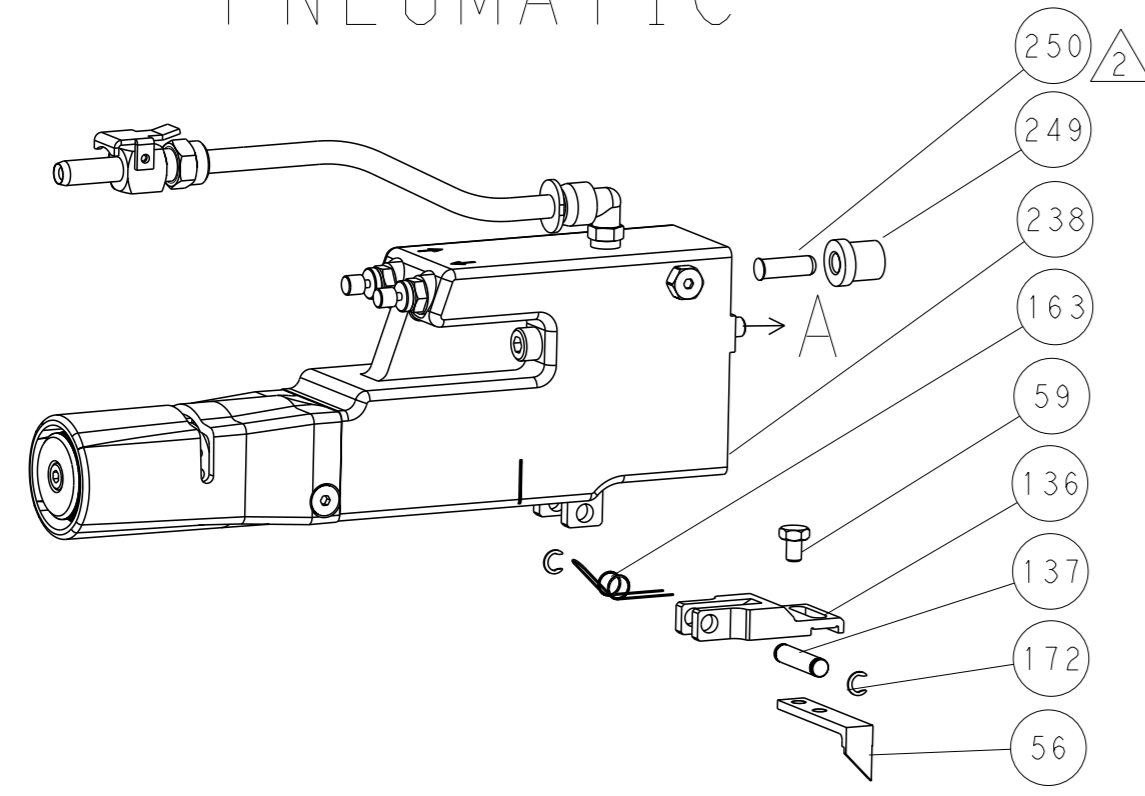
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mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES °	R. KNEPPER G. BAILEY M. CLIFFORD	16-Oct-13 16-Oct-13 16-Oct-13	1 2 3	TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SHEET:	REV:
			1:2	3 of 4	C

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

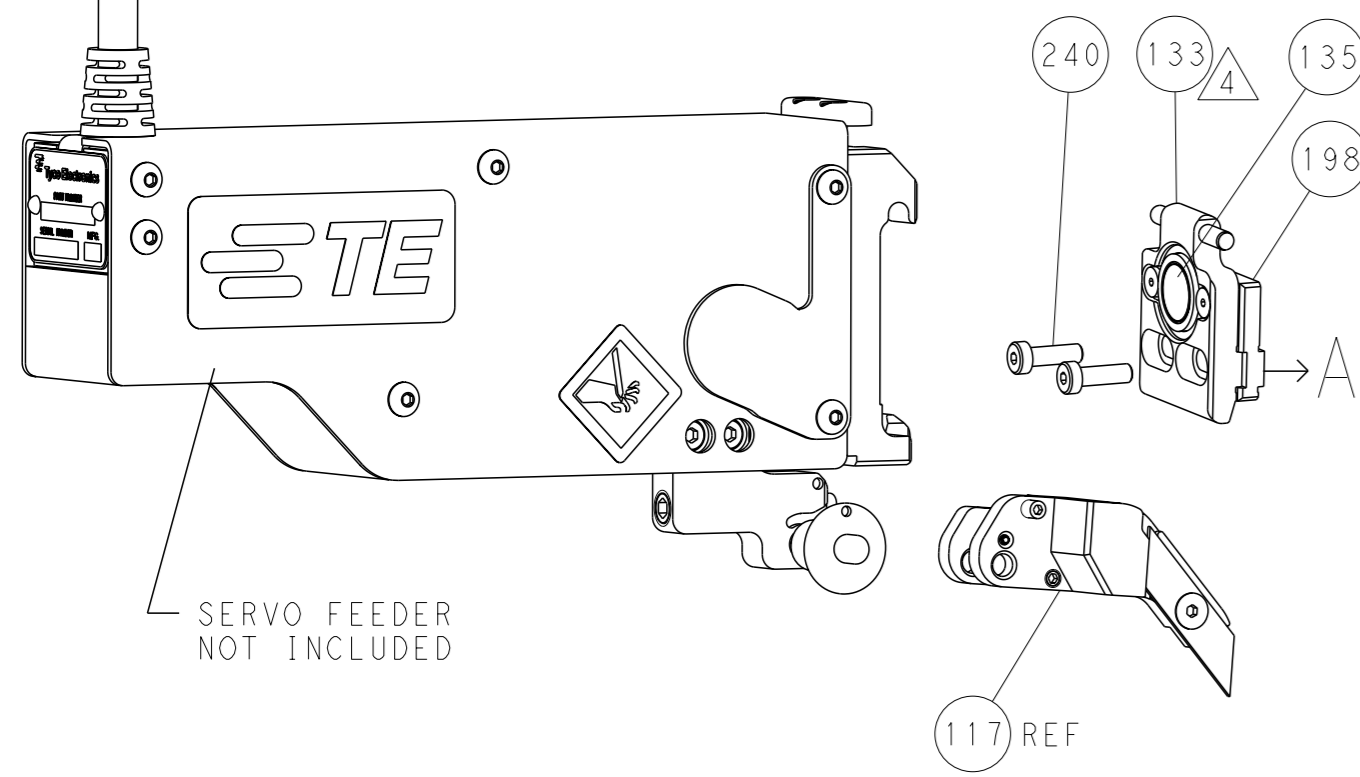
FEED TYPE MECHANICAL



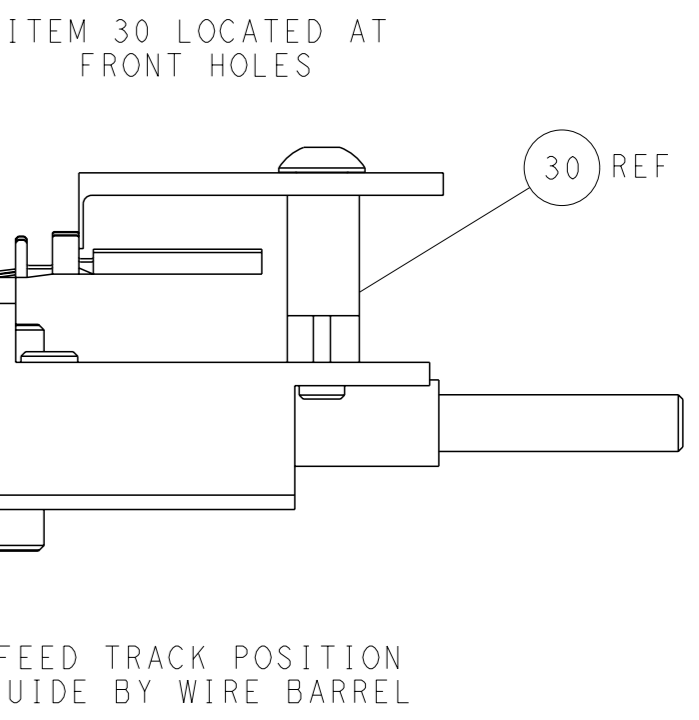
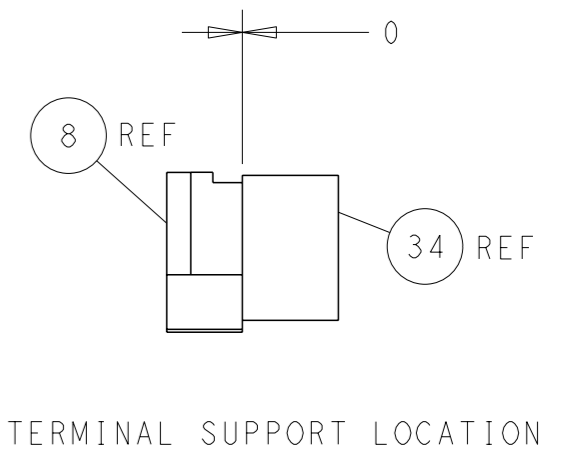
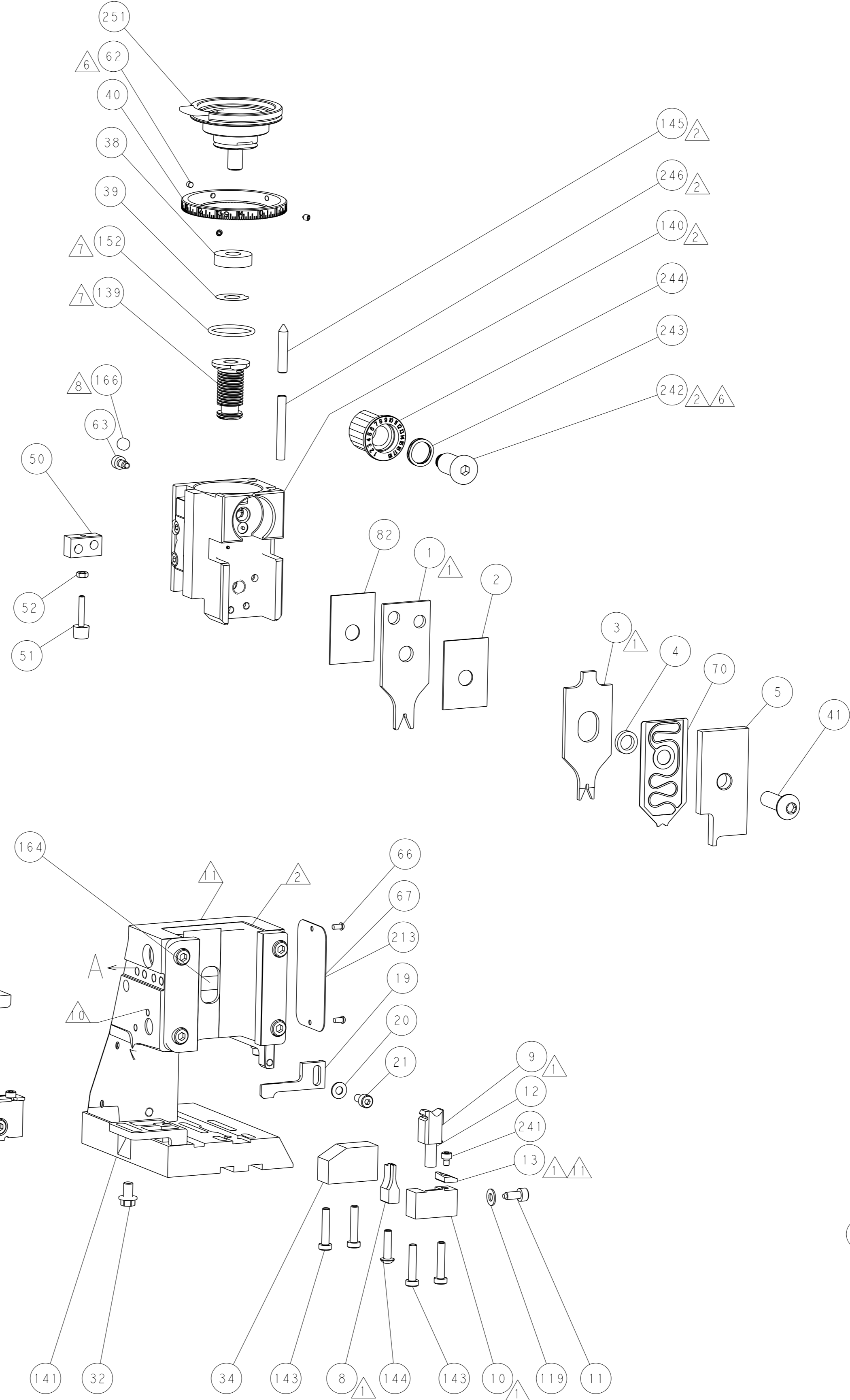
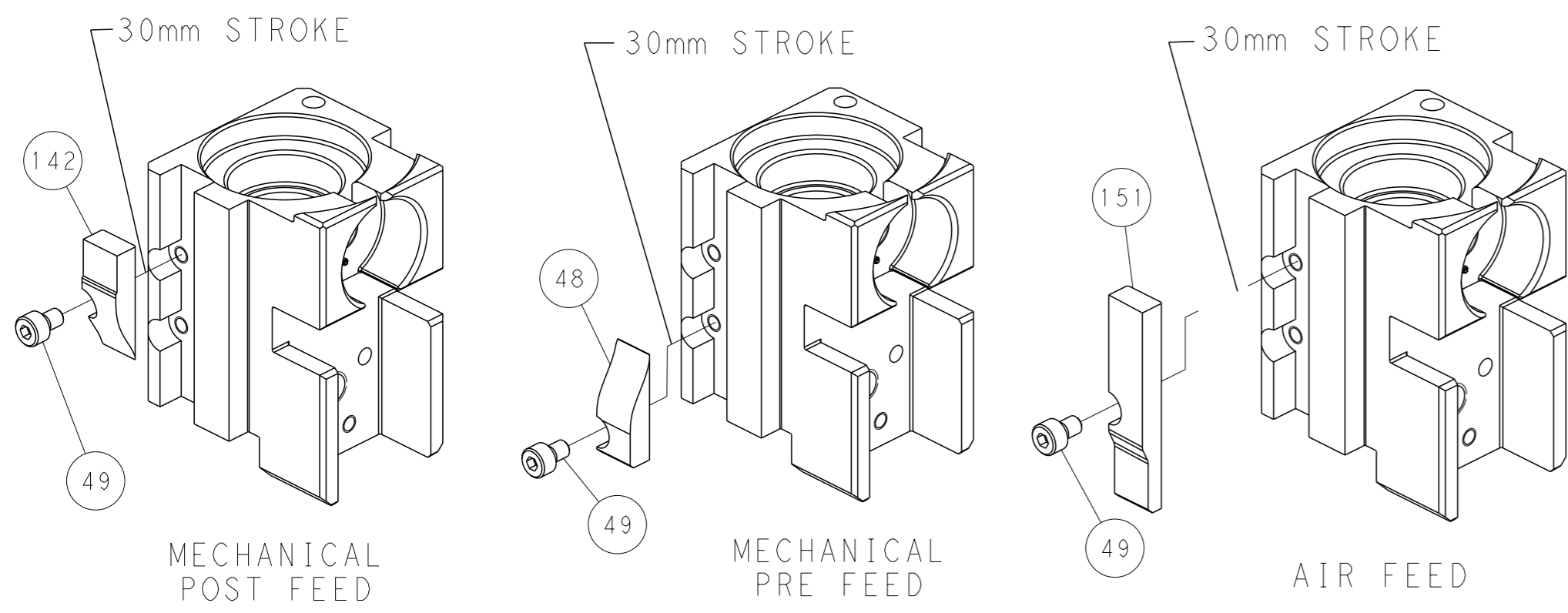
PNEUMATIC



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN R. KNEPPER 16-Oct-13 CHK G. BAILEY 16-Oct-13 APVD M. CLIFFORD 16-Oct-13	NAME STE TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266119 Customer Accessible Production Drawing SHEET 4 OF 4 REV C