

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2266884-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1
	2266884-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266884-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266884-4	-	-	
					MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-	-
	2266884-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	-	8-2266884-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266884-4	-	-	
	2266884-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE ¹²	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-
PNEUMATIC FEED						2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1
2266884-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
7-2266884-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	WIRE	TYPE
2.29 mm [.090]	2.29 mm [.090]	F
INSUL	3.81 mm [.150]	F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: KET TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: 187 II RECEPTACLE	
WIRE STRIP LENGTH 4.83-5.59 mm [.190-.220 IN]	INSULATION DIAMETER RANGE Ø1.80-2.90 mm [.071-.114 IN]
TERMINAL APPLICATION SPECIFICATION NONE	-
TERMINALS APPLIED	
TE TERMINAL 2113775-1	KET TERMINAL ST730645-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.84+/-0.05 [.072+/- .002]	6.1
AVS, AVSS or CAVS 1.25mm ²	1.82+/-0.05 [.072+/- .002]	6.2
18 AWG	1.69+/-0.05 [.067+/- .002]	7.7
AVS, AVSS or CAVS 0.85mm ²	1.68+/-0.05 [.066+/- .002]	7.7

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266884-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266884-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266884-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266884-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.96.

***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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260

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

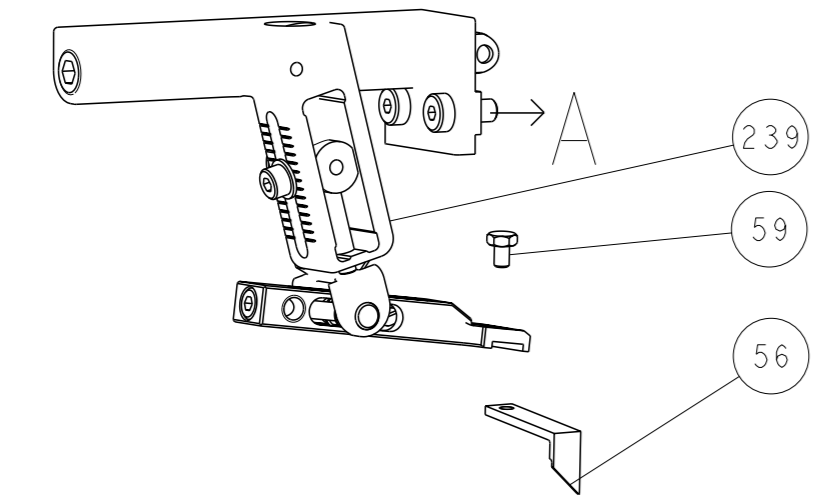
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	#	DATE	BY	APPV
			1	03AUG2015	BW	TE
			A	14SEP2015	GH	TE

#	QTY	DESCRIPTION	DATE	OWN	APPV
-	1	8-21084-0 O-RING, .676 ID, .070 DIA. MAT.			252
-	-	2119640-1 PUSH ROD, AIR FEED			250
-	-	2079988-1 BUSHING, LCH5-12, MISUMI			249
-	-	2119641-1 FEED CAM, AIR FEED			248
-	1	2119798-1 DETENT PIN			247
-	1	1-22279-3 SPRING, COMPRESSION			246
-	-	2119758-1 RAM, AMP STYLE, SIDE FEED, NON-ADJ.			245
-	1	2119082-7 CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST			243
-	1	2119083-1 RETAINER, INSULATION DIAL			242
-	1	7-18023-7 SCR, SKT HD CAP M3 X 4.0			241
-	2	2168400-6 SHCS, LOW HEAD, RoHS, M5 X 16			240
-	-	2119580-1 MECHANICAL FEED ASSEMBLY			239
-	-	2063440-1 AIR FEED MODULE			238
-	1	2119740-2 TAG, IDENTIFICATION			213
-	1	1901094-3 SPACER, FEEDER			198
-	-	21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT			172
-	1	994969-1 MAGNET, RARE EARTH HIGH ENERGY			166
-	REF	994970-2 COUNTER, MAGNETIC			164
-	-	240638-1 SPRING, FEED FINGER			163
-	-	3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854			137
-	-	2119799-1 HOLDER, FEED FINGER, AF			136
-	REF	SEE NOTE 4 MEMORY CHIP, PROGRAMMED			135
-	1	1633743-1 SERVO FEED LATCH ASM			133
-	REF	2119944-1 FEED FINGER ASSEMBLY, SF			117
-	1	455888-5 SPACER, CRIMPER			82
-	1	2119956-1 DOCUMENTATION PACKAGE			71
-	1	2119740-1 TAG, IDENTIFICATION			67
-	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	1	2119793-1 LIMITER, ADJUSTMENT BOLT			63
-	3	992763-5 SCR, SET, SOC, CONE POINT, M3 X 4.0			62
-	1	2079383-4 SCR, BHSC, RoHS (M4 X 8)			60
-	-	5-18022-5 SCR, HEX HD CAP, M4 X 6.0			59
-	-	1338683-8 FEED PAWL			56
-	4	2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12			54
-	2	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10			53
-	1	5018030-1 NUT, HEX, REG, RoHS, M3			52
-	1	811242-5 BUMPER, HOLD DOWN			51
-	1	690753-2 SPACER, TONKER			50
-	-	18023-9 SCR, SKT HD CAP M4 X 6.0			49
-	-	2119652-1 FEED CAM, PRE FEED			48
-	-	2119653-1 FEED CAM, POST FEED			47
-	1	2119656-9 APPLICATOR BASIC ASSEMBLY, SF			46
-	1	2119370-1 RAM, AMP STYLE, SIDE FEED			44
-	1	2079383-7 SCR, BHSC, RoHS (M8 X 25)			41
-	1	2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT			40
-	1	2119957-1 APPLICATOR SHIM PACK			39
-	1	2119644-2 RAM WASHER, PRECISION			38
-	1	2119085-1 FA HEAD, ATLANTIC STYLE			37
-	1	2119092-1 BOLT, ADJUSTMENT			35
-	1	1752356-1 SUPPORT, TERMINAL			34
-	2	2079383-5 SCR, BHSC, RoHS (M4 X 20)			33
-	1	2161328-1 HEX HEAD, FLANGED, M5 X 8mm LONG			32
-	1	1320908-7 SPACER, STRIP GUIDE			30
-	1	2119959-1 ASSEMBLY, STRIP GUIDE			29
-	1	455888-5 SPACER, CRIMPER			28
-	1	1320928-2 STRIP GUIDE			24
-	1	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	2	1-18028-2 WASHER, FLAT, REG M4			20
-	1	2119533-1 STRIPPER, SIDE FEED			19
-	1	2119806-1 INSERT, SHEAR			13
-	1	3-22280-3 SPRING, COMPRESSION			12
-	1	1-356885-4 STOP, SHEAR			11
-	1	2119805-1 SHEAR HOLDER, FRONT			10
-	1	1803095-1 FLOATING SHEAR, FRONT			9
-	1	2-1633921-0 ANVIL, COMBINATION			8
-	-	-			7
-	-	-			6
-	1	1-2119757-0 DEPRESSOR, SHEAR			5
-	1	238011-4 BLOCK, CRIMPER SPACER			4
-	1	7-1633961-7 CRIMPER, INSULATION F PREMIUM			3
-	1	455888-7 SPACER, CRIMPER			2
-	1	6-456406-6 CRIMPER, WIRE PREMIUM			1

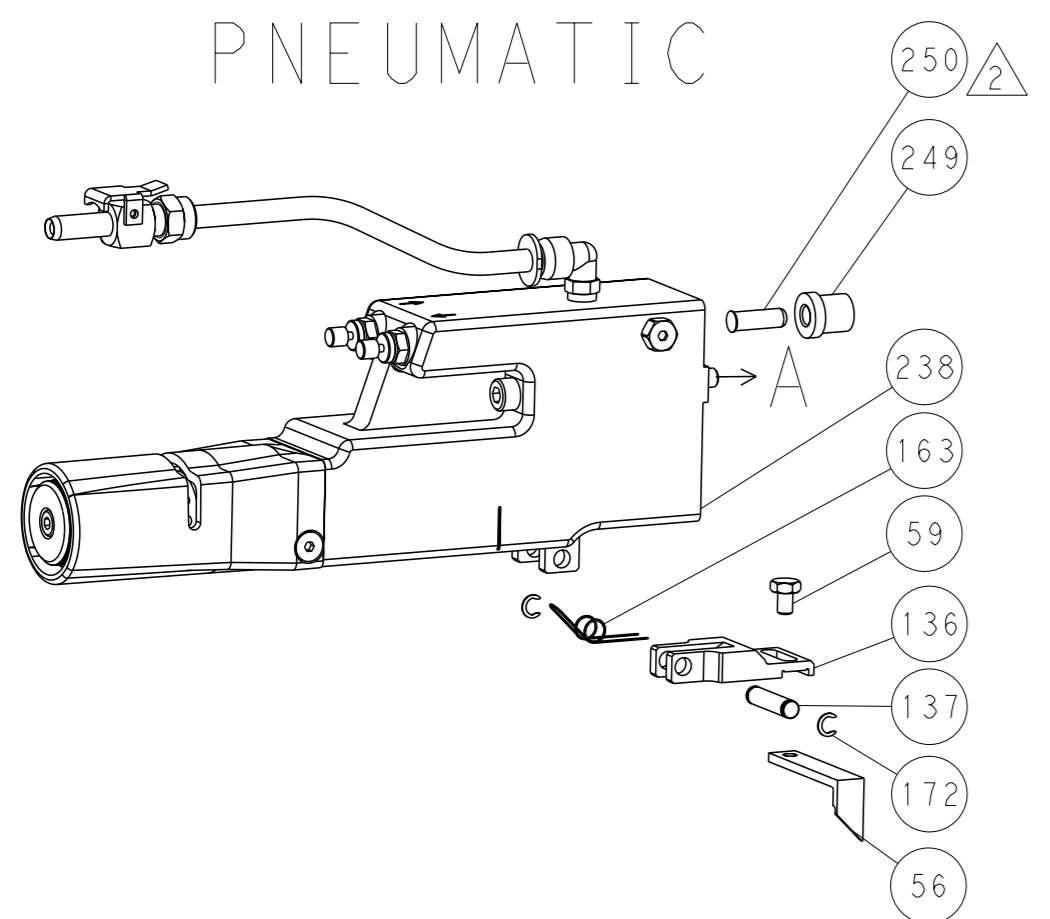
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	DATE	NAME
mm	0 PLC ±	B. WEAVER	03AUG2015	TE Connectivity
	1 PLC ±	T. ELBIN	03AUG2015	Harrisburg, PA 17105-3608
	2 PLC ±			
	3 PLC ±			
	4 PLC ±			
	ANGLES ±			
MATERIAL:	FINISH	APV	DATE	PRODUCT SPEC
		T. ELBIN	03AUG2015	
				APPLICATION SPEC
		WEIGHT		RESTRICTED TO
		Customer Accessible Production Drawing	SCALE 1:2	SHEET 1 of 4 REV A

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

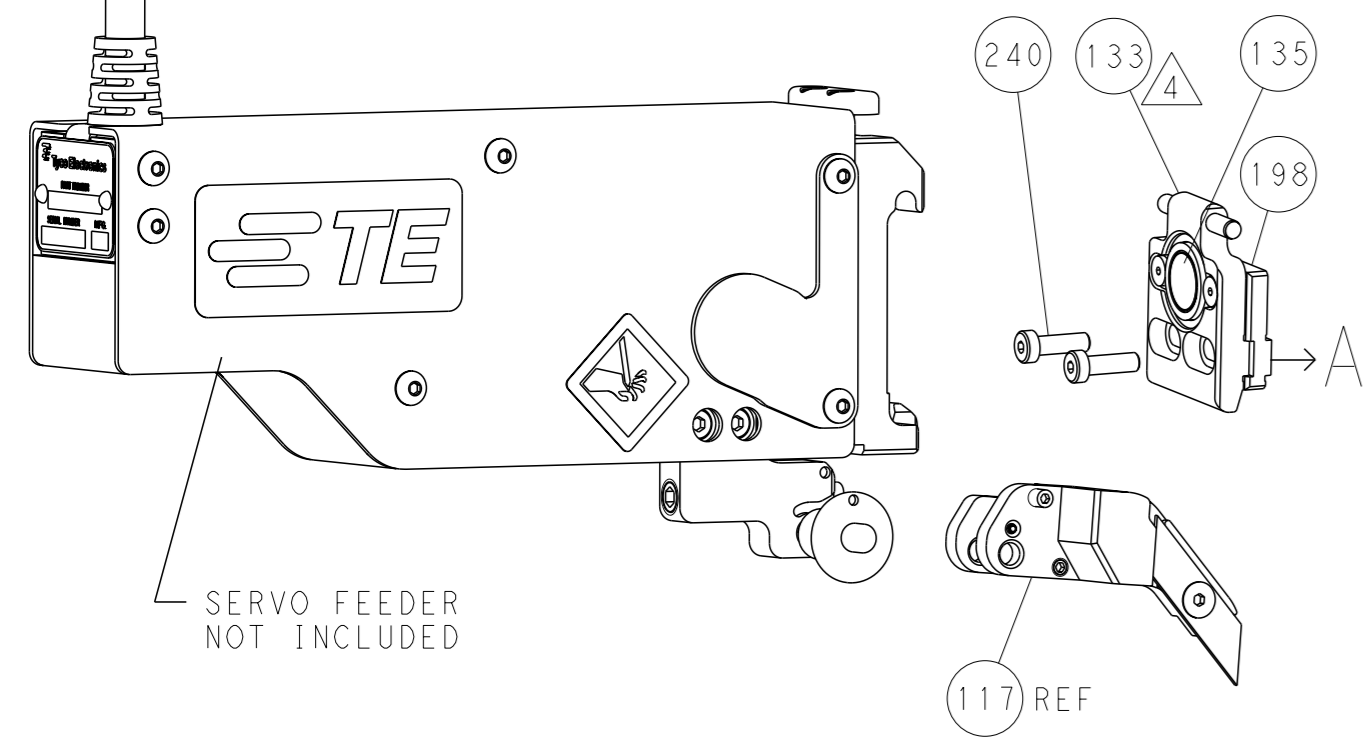
FEED TYPE MECHANICAL



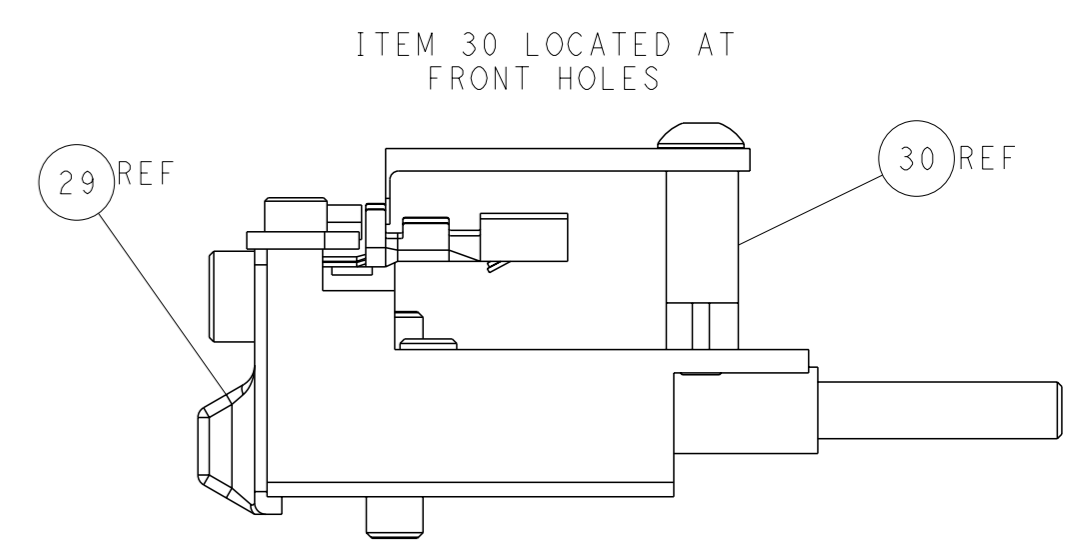
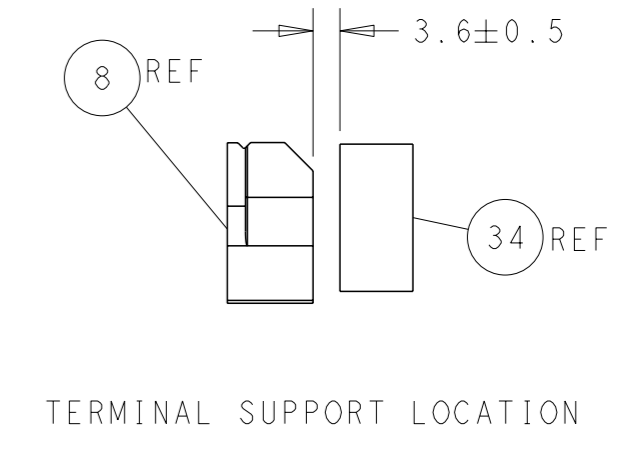
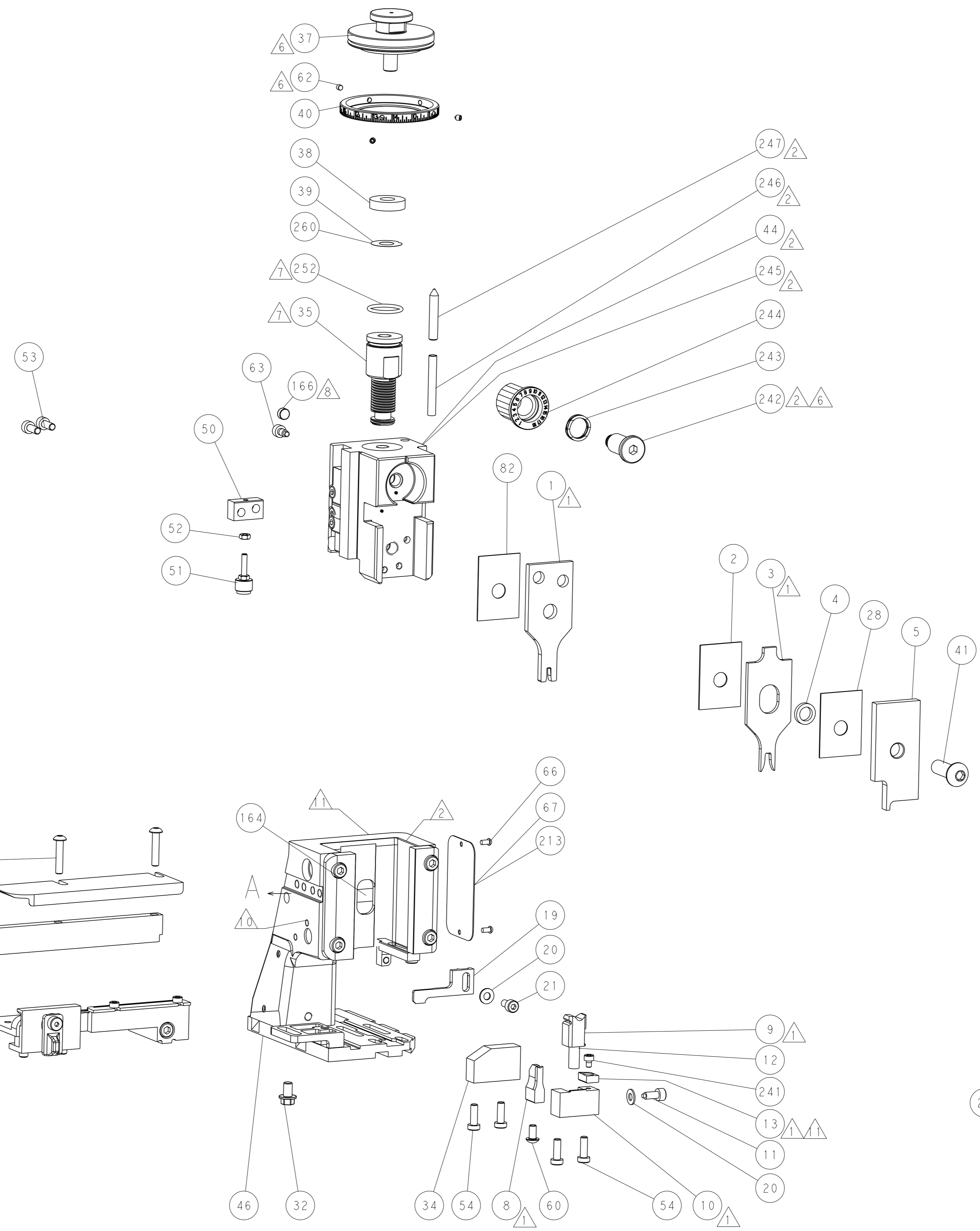
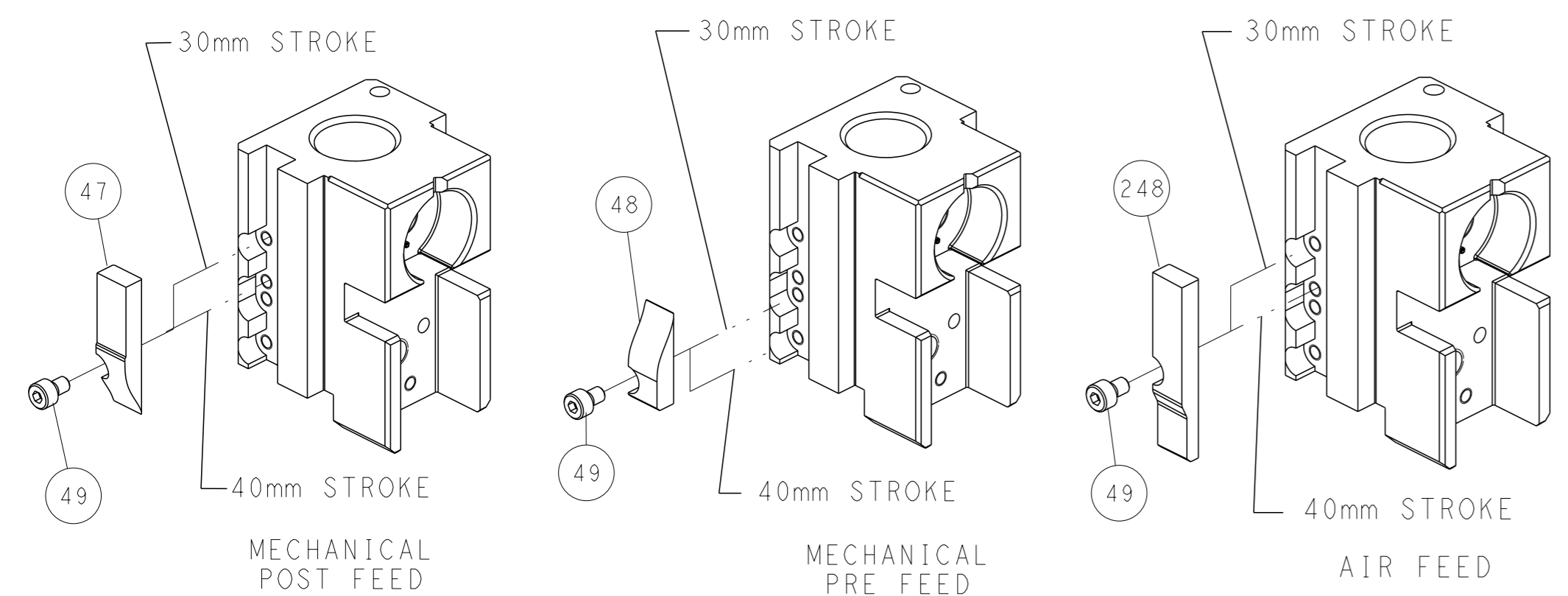
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS

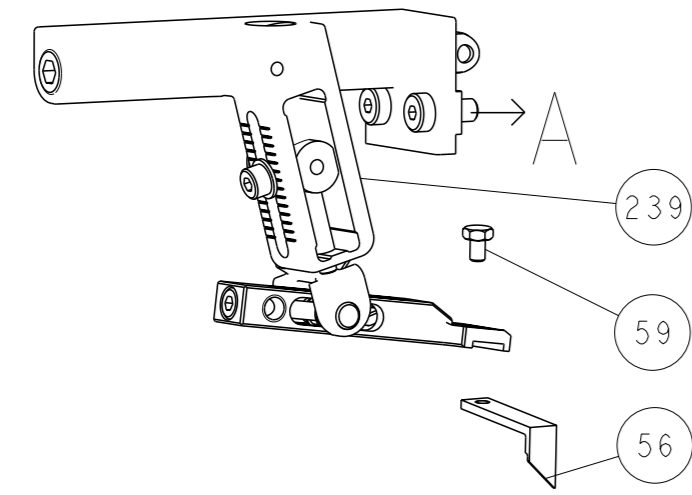


ATLANTIC VERSION
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 (Pacific version shown on sheets 3 of 4 & 4 of 4)

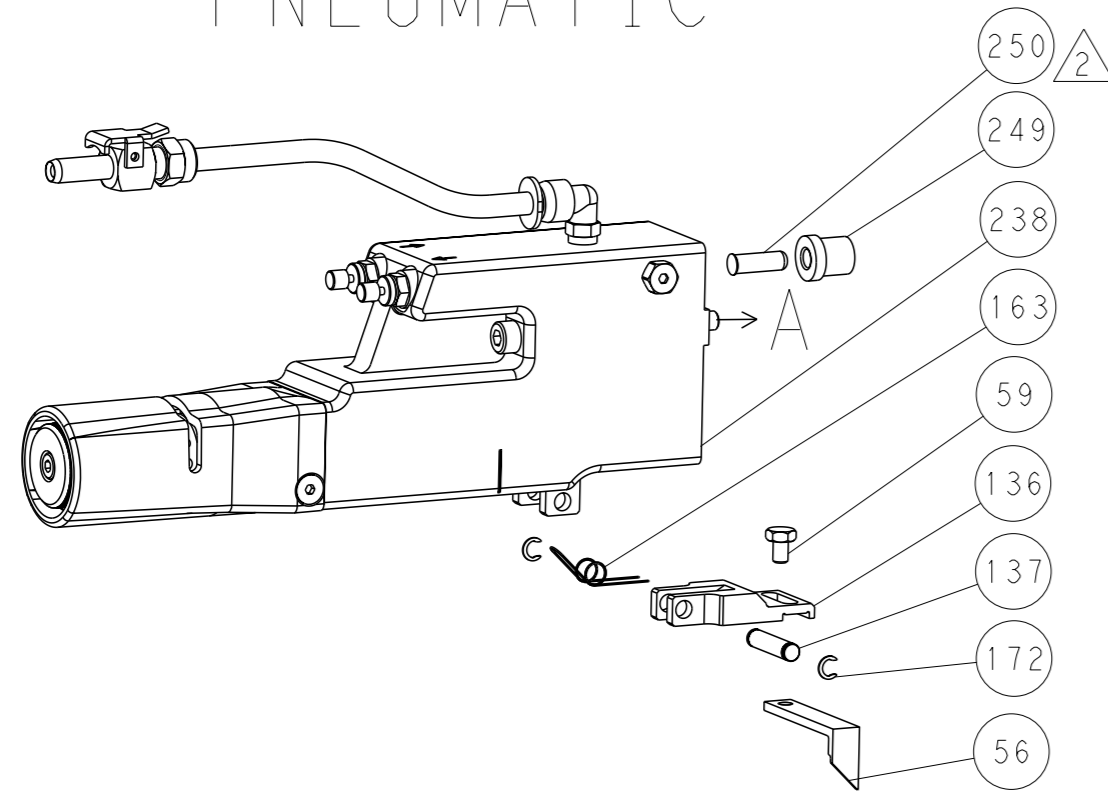
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REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LYR			
		DESCRIPTION		
		SEE SHEET 1		

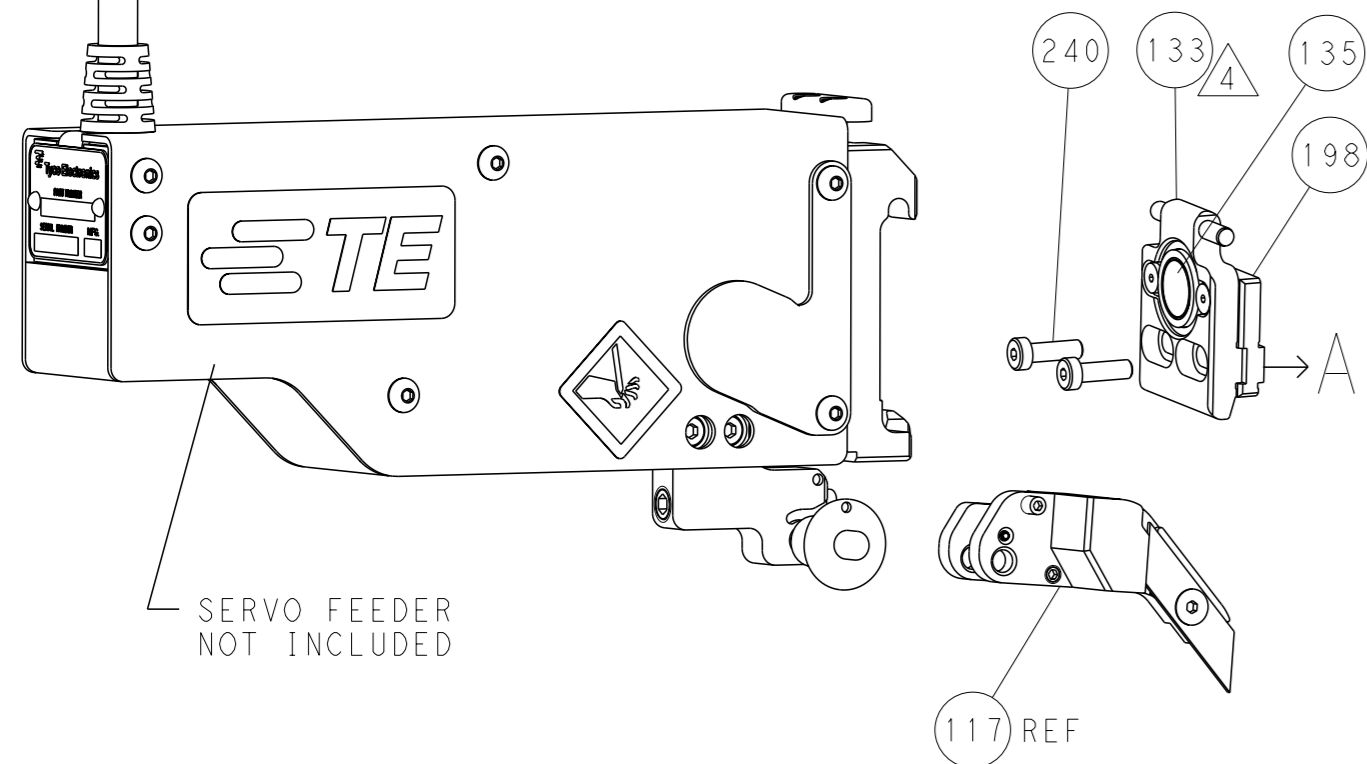
FEED TYPE MECHANICAL



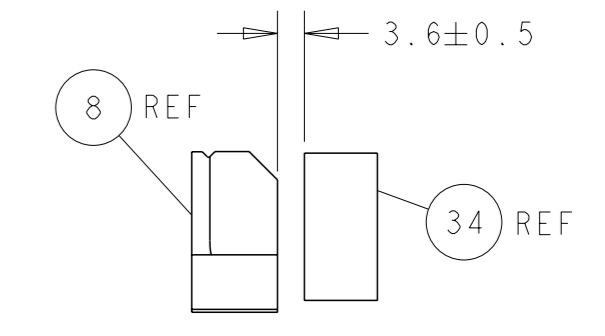
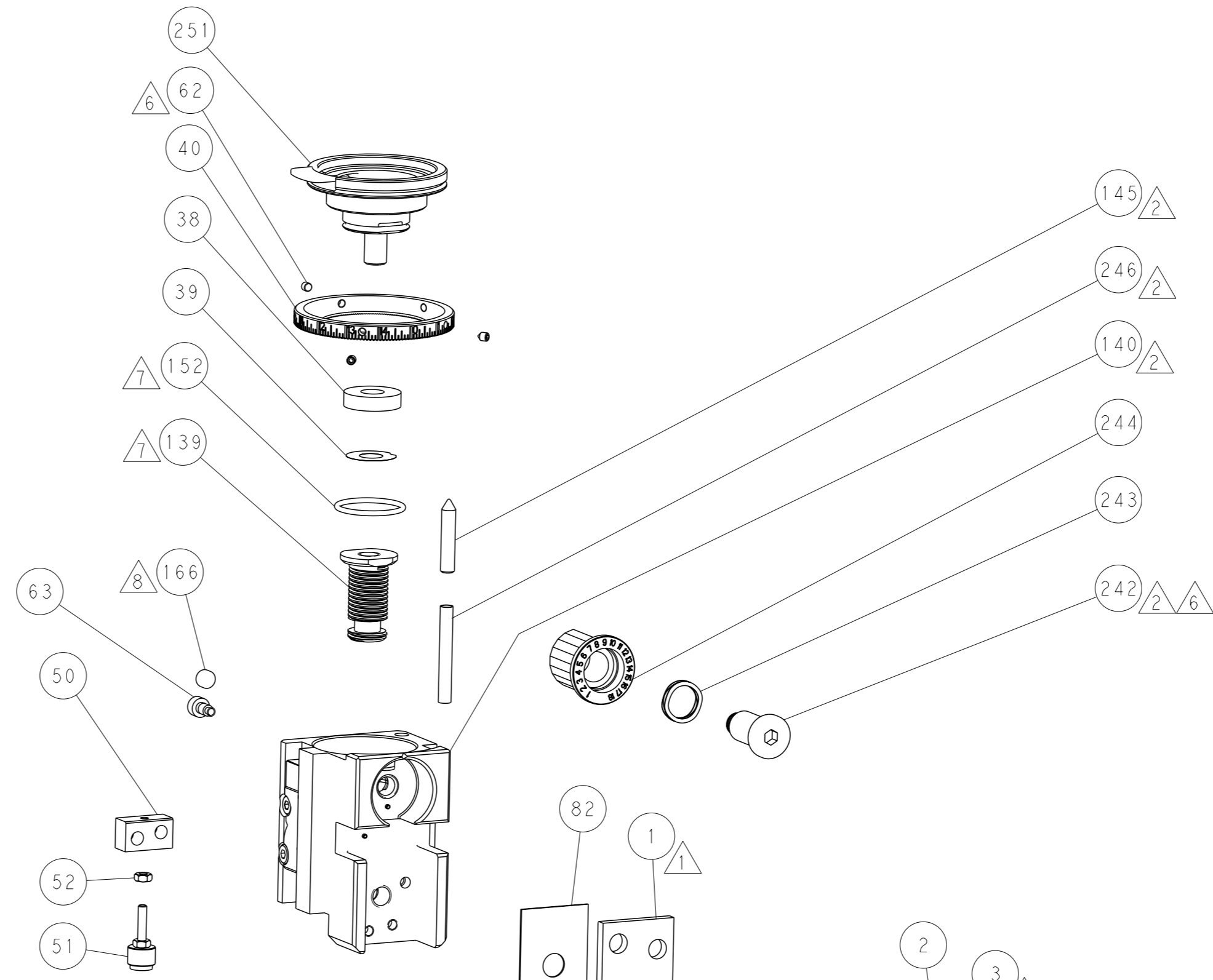
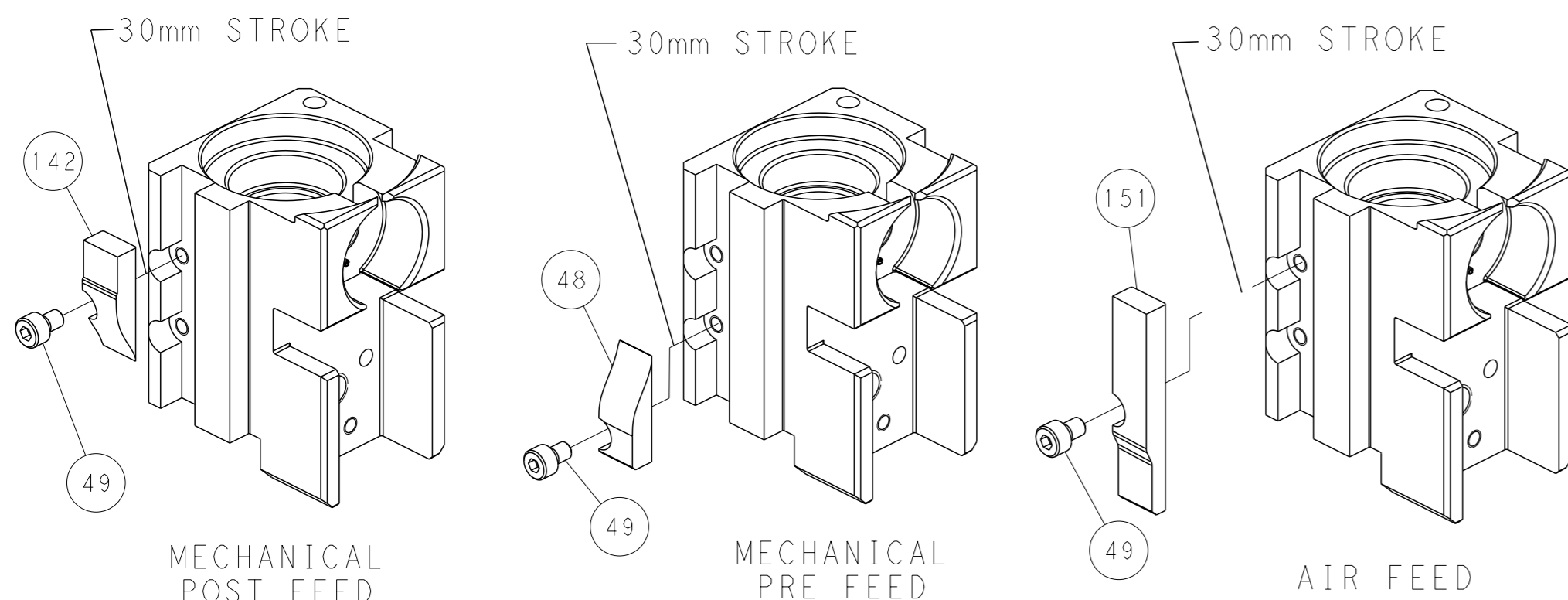
PNEUMATIC



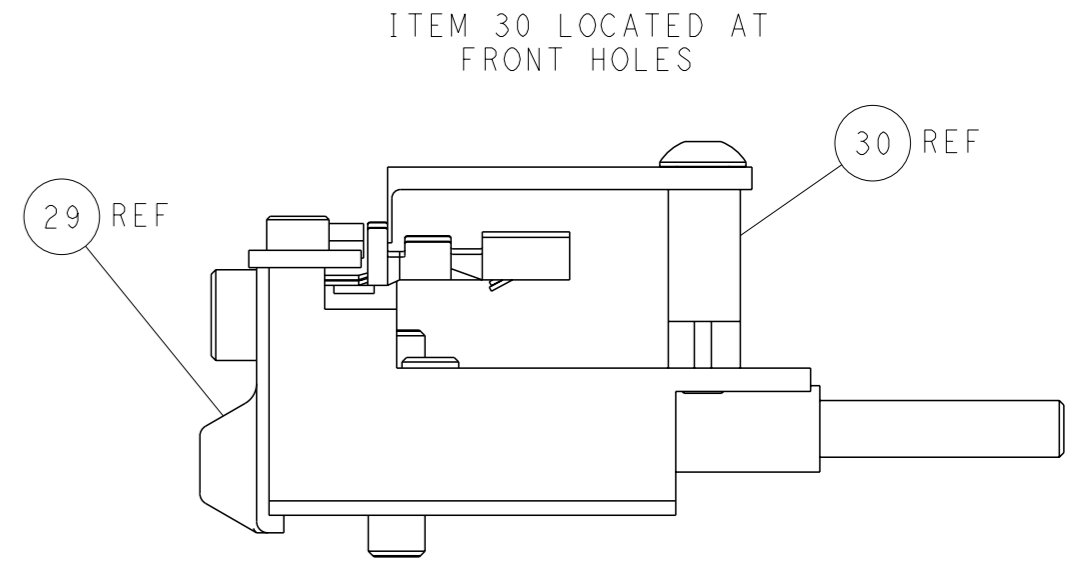
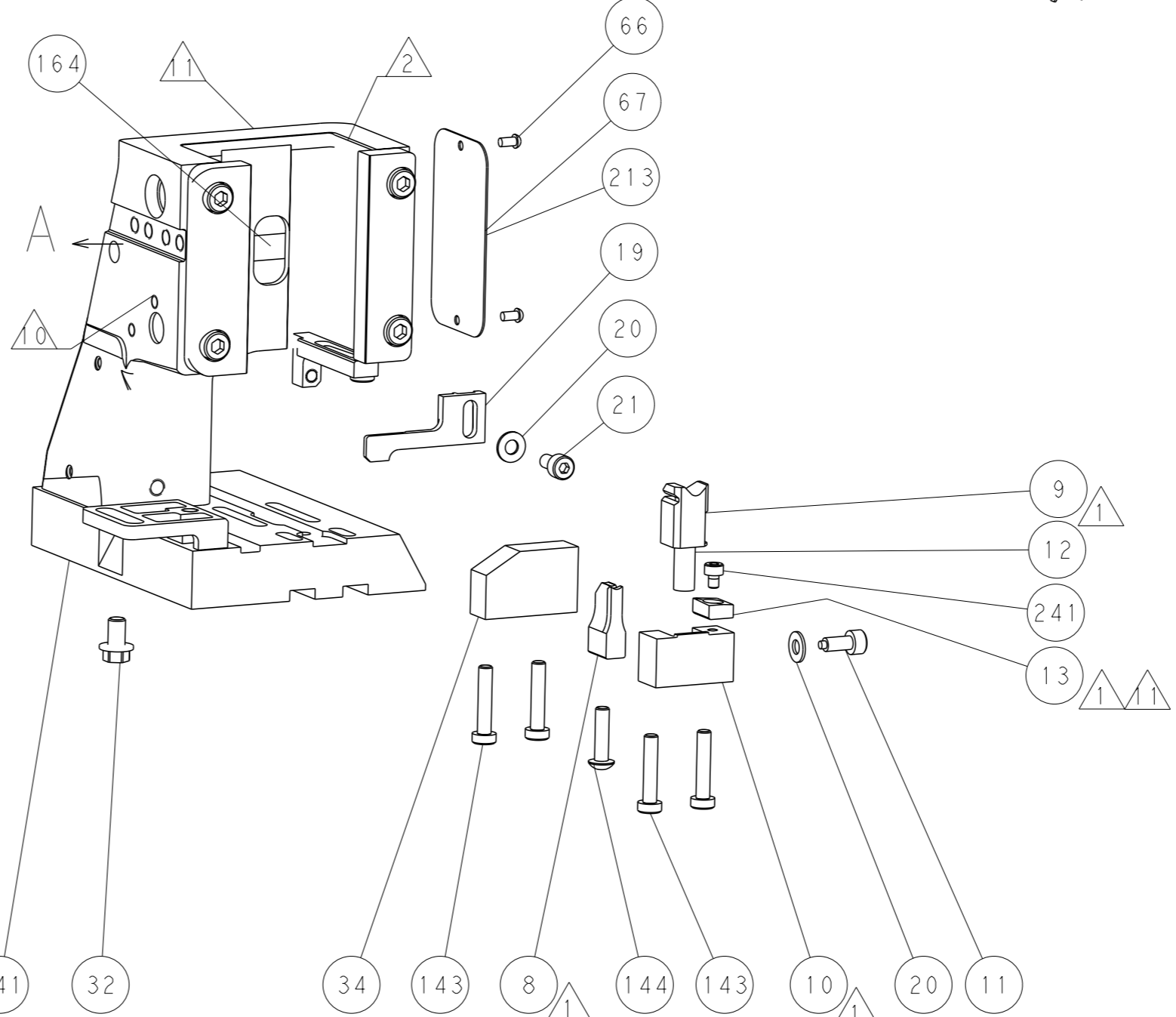
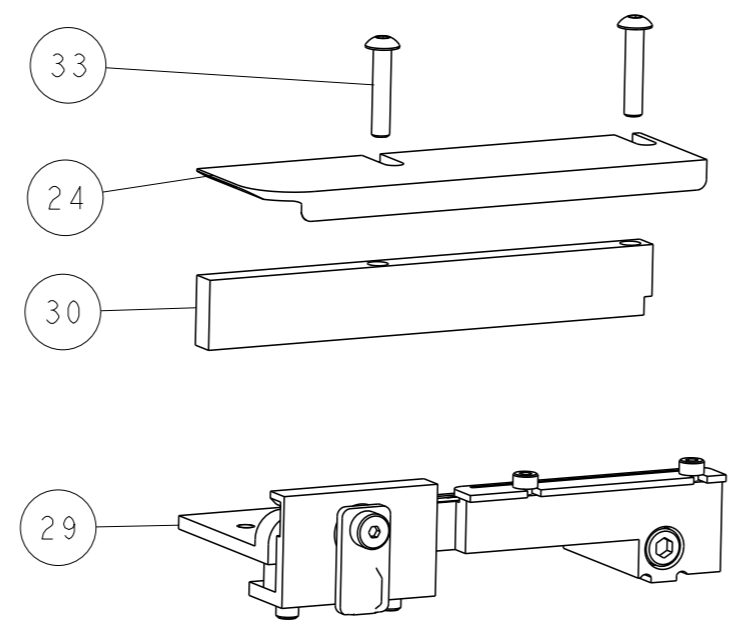
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT FRONT HOLES

FEED TRACK POSITION GUIDE BY INSULATION 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 TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN B. WEAVER 03AUG2015 CHK T. ELBIN 03AUG2015 APVD T. ELBIN 03AUG2015	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 FINISH ±	PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing	SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266884 SCALE 1:2 SHEET 4 of 4 REV A