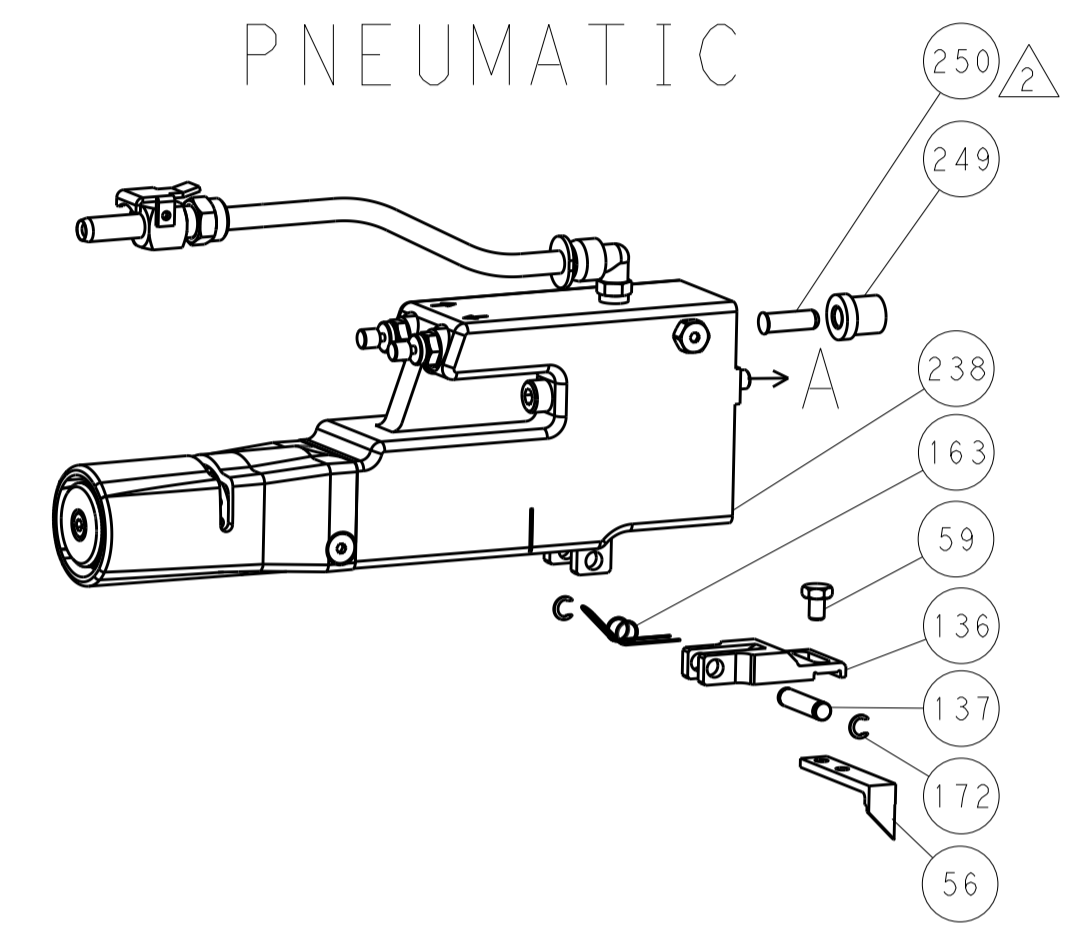


LOC	DIST	REV	DATE	BY	APPV
A	66	1			

FEED TYPE

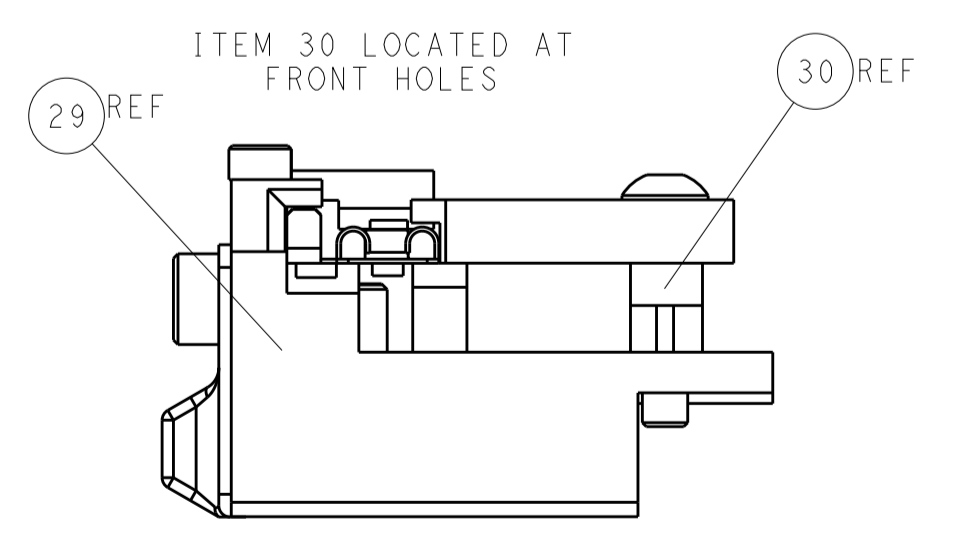
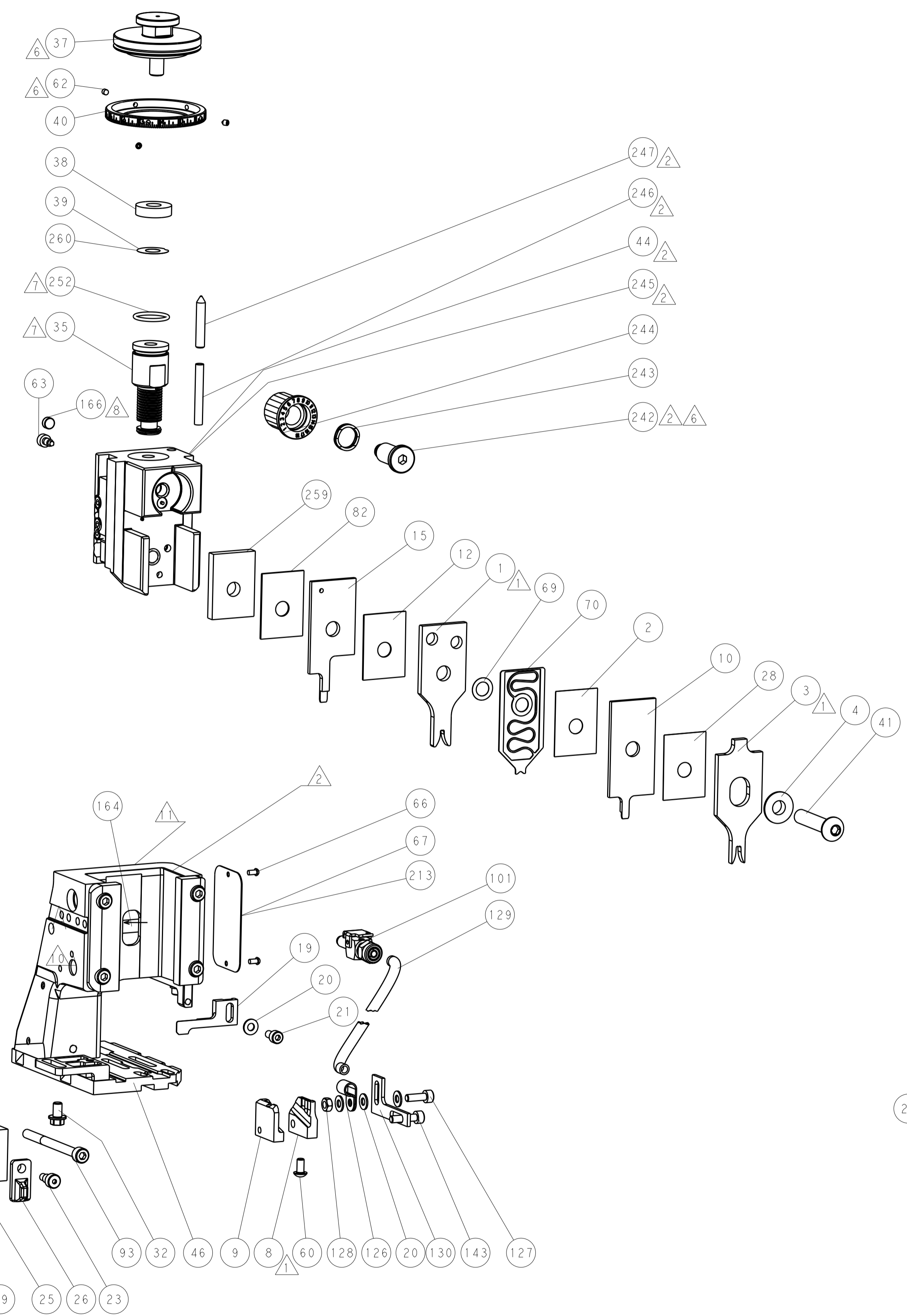
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



FEED TRACK POSITION
GUIDE BY GUIDE_BY_STR

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		REVISIONS	
mm	0 PLC	±		DATE	BY
	1 PLC	±			
	2 PLC	±			
	3 PLC	±			
	4 PLC	±			
	ANGLES	±			
MATERIAL	FINISH				

OWN	BOB HIGMAN	29 JUL 2015	TE Connectivity Harrisburg, PA 17105-3608
CHK	T. ELBIN	29 JUL 2015	
APVD	T. ELBIN	29 JUL 2015	NAME
PRODUCT SPEC			Ocean Side Feed
APPLICATION SPEC			Applicator
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	©=2266898	
Customer Accessible Production Drawing			SCALE
			1:2
			SHEET
			2 of 4
			REV
			A

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2266898-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2266898-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
	2-2266898-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2266898-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.05 mm [.120]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: KET TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, .312 SLIP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.75-6.51 mm [.226-.256 IN]		Ø2.10-2.60 mm [.083-.102 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED ¹⁰			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
2113812-1	ST730707-1	2113812-3	ST730707-3
2113812-2	ST730707-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
AVS 0.85mm ²	1.46 +/- 0.05 [.057 +/- .002]	7.4
AVS 0.5mm ²	1.32 +/- 0.05 [.052 +/- .002]	8.8



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266898-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266898-5
- 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 ITEM 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

***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	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO
-	1	1	1	1803078-4	SPACER, PRECISION	259
-	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240

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	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

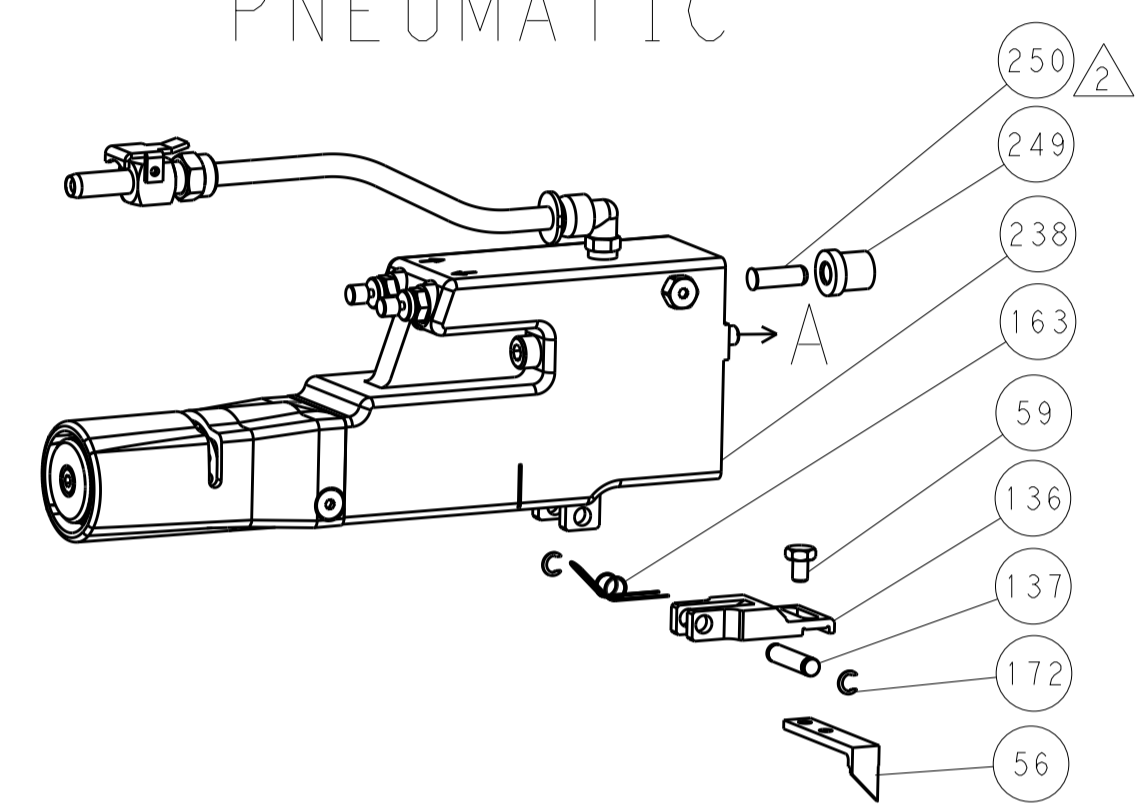
REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	-	-	1	2063440-1	AIR FEED MODULE		238
-	-	1	-	2119740-2	TAG IDENTIFICATION		213
-	-	1	-	1901094-3	SPACER, FEEDER		198
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT		172
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY		166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC		164
-	-	-	1	240638-1	SPRING, FEED FINGER		163
-	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	2119798-2	DETENT PIN		145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)		144
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		143
-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1	1	2161312-1	RAM, STEPPED, ASIAN STYLE, SIDE FEED		140
-	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	2217068-1	BRACKET, AIR BLAST		130
-	1	1	1	2030758-3	TUBING, POLYURETHANE		129
-	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4		128
-	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		127
-	1	1	1	986220-3	CLAMP, CABLE, BLACK		126
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		122
-	1	1	1	1-22281-8	SPRING, COMPRESSION		121
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF		117
-	1	1	1	23238-1	INSERT, COUPLING		101
-	2	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16		95
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65		93
-	1	1	1	455888-8	SPACER, CRIMPER		82
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE		71
-	1	1	1	2119791-5	DEPRESSOR, WIRE		70
-	1	1	1	2119943-1	WASHER, SPACER		69
-	1	-	1	2119740-1	TAG IDENTIFICATION		67
-	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
-	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0		61
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	-	-	1	1338685-1	PAWL, FEED		56
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)		41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT		40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK		39
-	1	1	1	1-2119644-2	RAM WASHER, PRECISION		38
-	1	1	1	1-2119928-9	FENCE		35
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG		32
-	1	1	1	1-1320908-1	SPACER, STRIP GUIDE		30
-	1	1	1	1-1901086-9	PLATE, STRIP GUIDE		29
-	1	1	1	455888-1	SPACER, CRIMPER		28
-	2	2	2	22281-6	SPRING, COMPRESSION		27
-	1	1	1	356835-1	LEVER, DRAG RELEASE		26
-	1	1	1	690792-4	DRAG, STOCK		25
-	1	1	1	1-690440-8	GUIDE, REAR STRIP		24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
-	1	1	1	3-690712-5	FRONT STRIP GUIDE		22
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	4	4	4	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	2119533-4	STRIPPER, SIDE FEED		19
-	1	1	1	4-853720-0	BLADE, SLUG		15
-	1	1	1	455888-6	SPACER, CRIMPER		12
-	1	1	1	1-853721-9	BLADE, SLUG		10
-	1	1	1	3-1803012-0	PLATE, REAR SHEAR		9
-	1	1	1	1803010-6	ANVIL, SPECIAL, COMBINATION		8
-	-	-	-	-	-		7
-	-	-	-	-	-		6
-	-	-	-	-	-		5
-	1	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER		4
-	1	1	1	7-2119582-2	CRIMPER, INSULATION F PREMIUM		3
-	1	1	1	455888-2	SPACER, CRIMPER		2
-	1	1	1	2-1633738-6	CRIMPER, WIRE		1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC	±		BOB HIGMAN	29 JUL 2015		
	1 PLC	±		CHS	29 JUL 2015		
	2 PLC	±		T. ELBIN			
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
	FINISH	±					

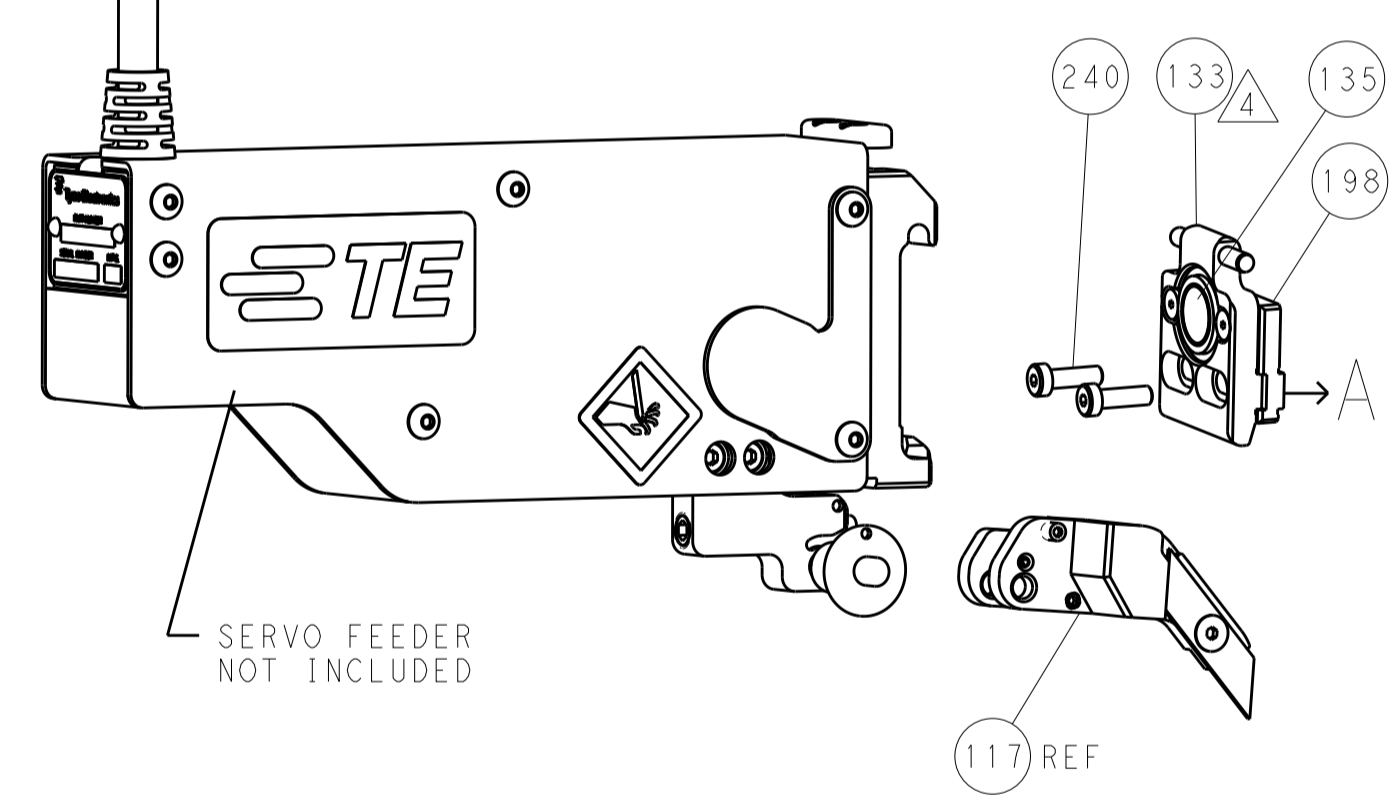
Customer Accessible Production Drawing	SCALE	1:2	SHEET	3	OF	4	REV	A
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LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC



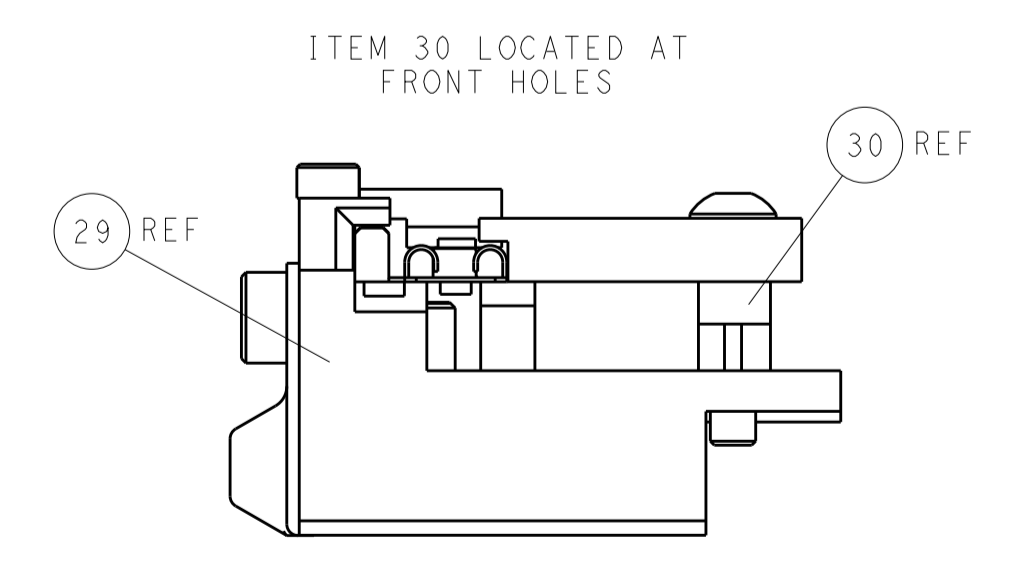
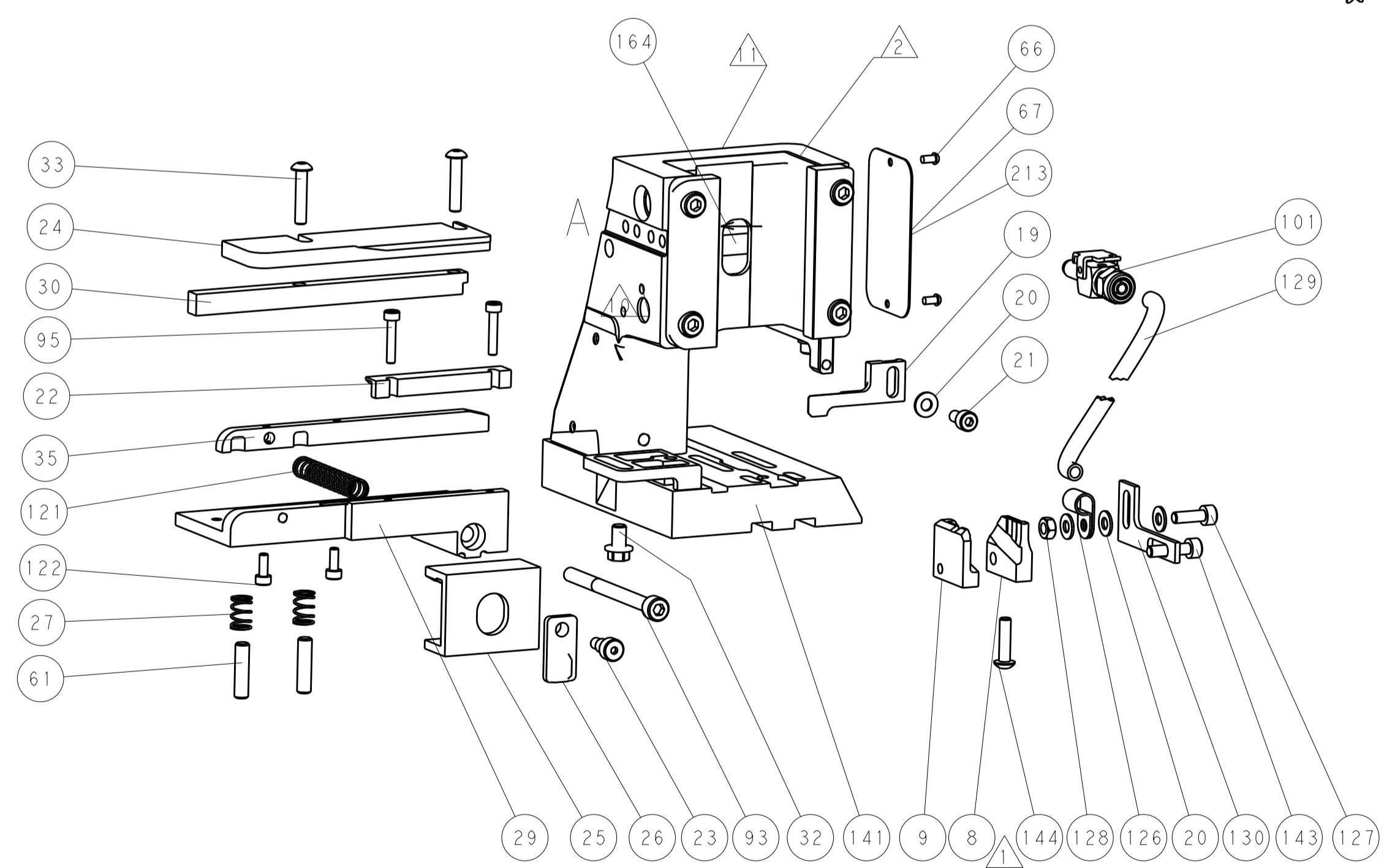
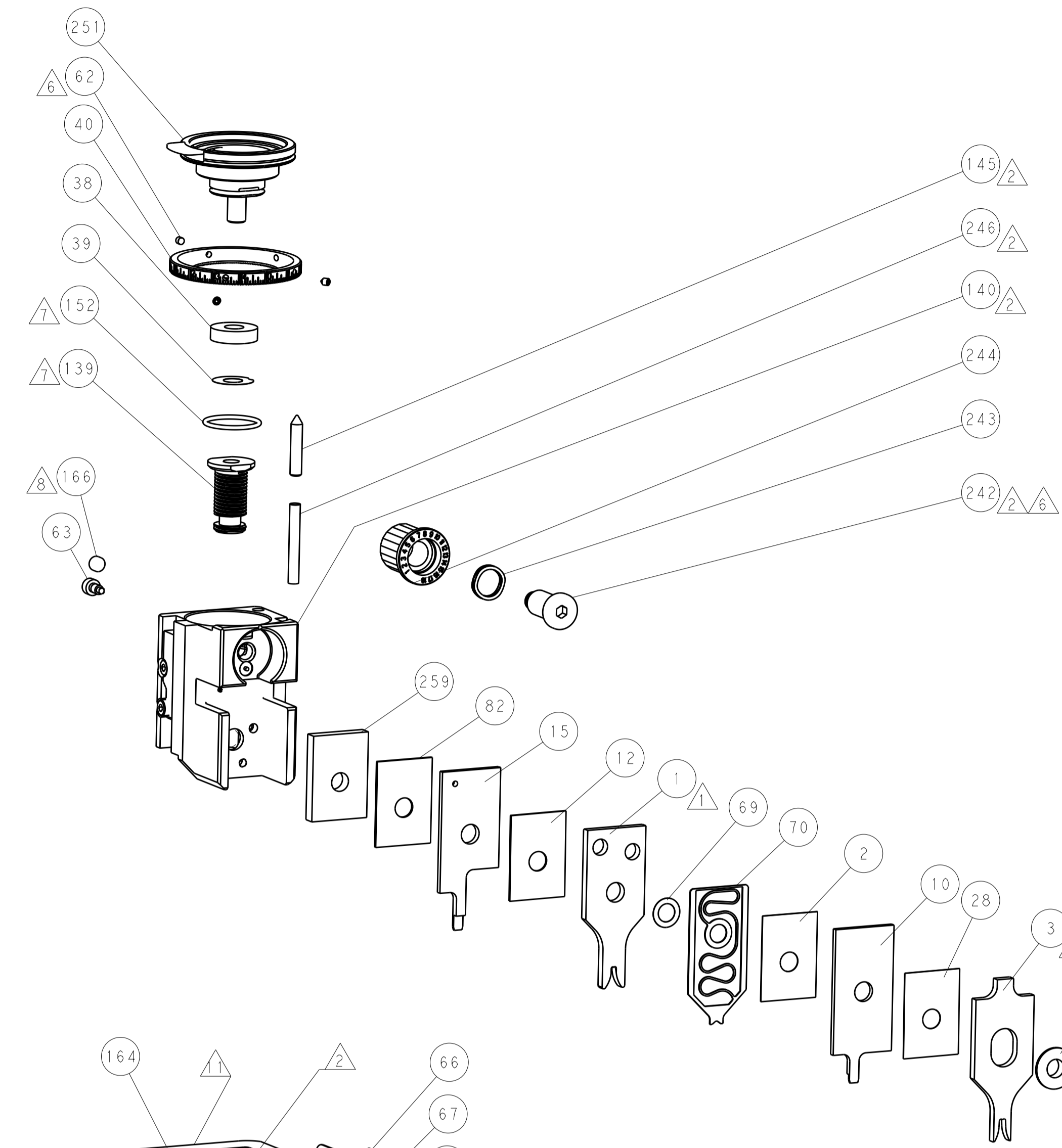
SERVO LATCH PLATE



CAM POSITION



AIR FEED



FEED TRACK POSITION
GUIDE BY GUIDE_BY_STR

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN BOB_HIGMAN 29JUL2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
			1:2	A1	00779	2266898	
Customer Accessible Production Drawing				SHEET 4 OF 4 REV A			