

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2266117-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2266117-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2266117-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
	2266117-6	D	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴ ¹²
	2266117-7	D	FINE CRIMP HEIGHT ADJUST	NONE
	7-2266117-7	C	CRIMP TOOLING KIT	-
	7-2266117-8	C	APPLICATOR CONVERSION KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	2.29 mm [.090]	O

APPLICATOR INSTRUCTIONS 408-10389

APPLICATOR CONVERSION KITS	
PART NUMBER	INSULATION DIAMETER RANGE
7-2266116-8	Ø2.74-3.18mm [.108-.125]
7-2266117-8	Ø2.31-2.72mm [.091-.107]
7-2266118-8	Ø1.91-2.29mm [.075-.090]
7-2266119-8	Ø1.60-2.16mm [.063-.085]
7-2266120-8	Ø1.27-1.57mm [.050-.062]

TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT PIN SIZE 20			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.81-5.08 mm [.150-.200 IN]	Ø2.31-2.72 mm [.091-.107 IN]		
TERMINAL APPLICATION SPECIFICATION	114-151003		
TERMINALS APPLIED ⁴			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
1572032-1	1060-20-0122	1572032-2	1060-20-0144
1572032-7	1060-20-0177		

TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.81-5.08 mm [.150-.200 IN]	Ø2.31-2.72 mm [.091-.107 IN]		
TERMINAL APPLICATION SPECIFICATION	114-151003		
TERMINALS APPLIED ⁴			
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

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: 8-2266117-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266117-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266117-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266117-6
- 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 37.
- 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.

- ³ SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.
- ⁴ TERMINAL LUBRICANT IS RECOMMENDED.

-78	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252

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
			B1	ECR-16-007326	20MAY2016	JH CT
			B2	ECR-16-017318	07DEC2016	MZ KZ
			C	ECR-17-004013	21MAR2017	KH JDG
			D	ECR-18-000268	10JAN2018	YY GB

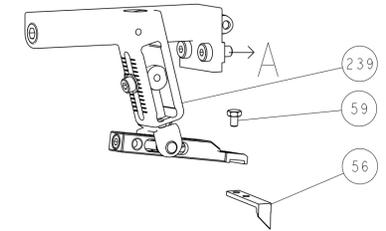
#	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV	
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	1	2119798-1	DETENT PIN	247
-	-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	-	-	1	-	2119758-1	RAM, AMP STYLE, 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	-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	-	1	1	1	1	455888-7	SPACER, CRIMPER	82
1	-	-	-	-	-	2266117	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 PNT, M3 x 4.0	62
-	-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	1338685-1	PAWL, FEED	56
-	-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	-	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	50
-	-	-	-	-	1	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	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	1-1803293-3	ANVIL, COMBINATION DEUTSCH STYLE	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	-	1	1	1	1	2119757-3	DEPRESSOR, SHEAR	5
-	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1803019-5	CRIMPER, INSULATION O	3
-	-	1	1	1	1	455888-8	SPACER, CRIMPER	2
-	-	1	1	1	1	1803364-2	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH		MATERIAL	
MATERIAL		WEIGHT		CUSTOMER DRAWING	

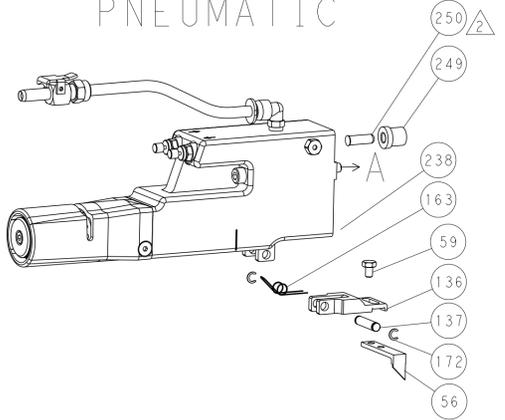
OWN: R. KNEPPER 16-Oct-13
 CHK: G. BAILEY 16-Oct-13
 APV: M. CLIFFORD 16-Oct-13
 NAME: Ocean Side Feed Applicator
 SIZE: A1 CASE CODE: 00779 DRAWING NO: C=2266117 SHEET 1 OF 4 REV D

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

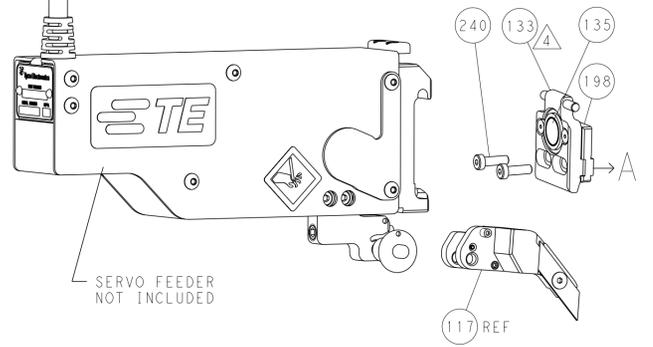
FEED TYPE MECHANICAL



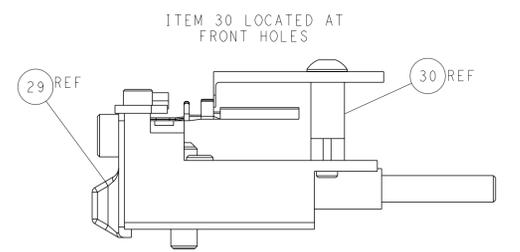
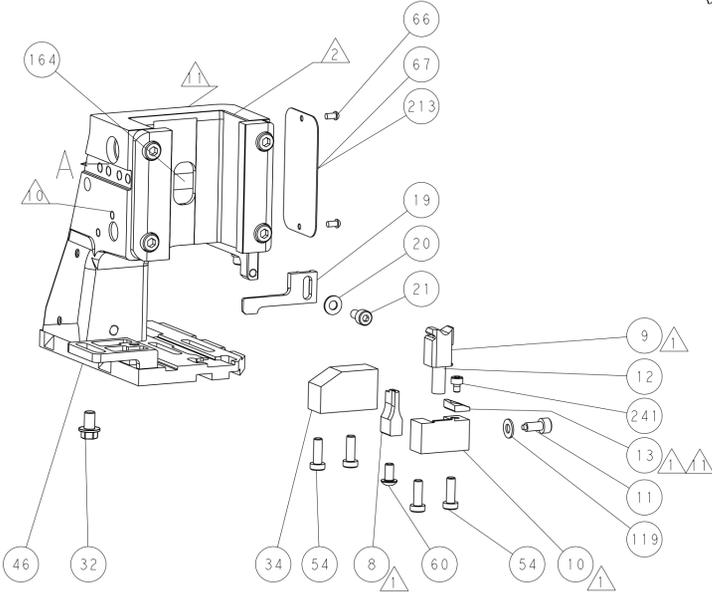
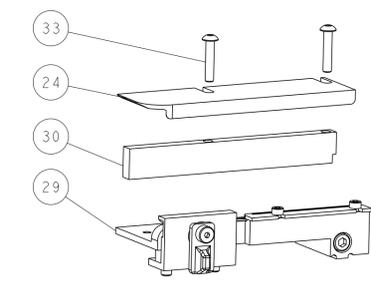
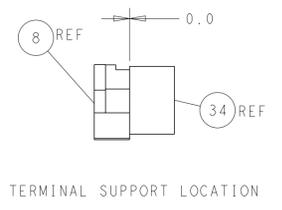
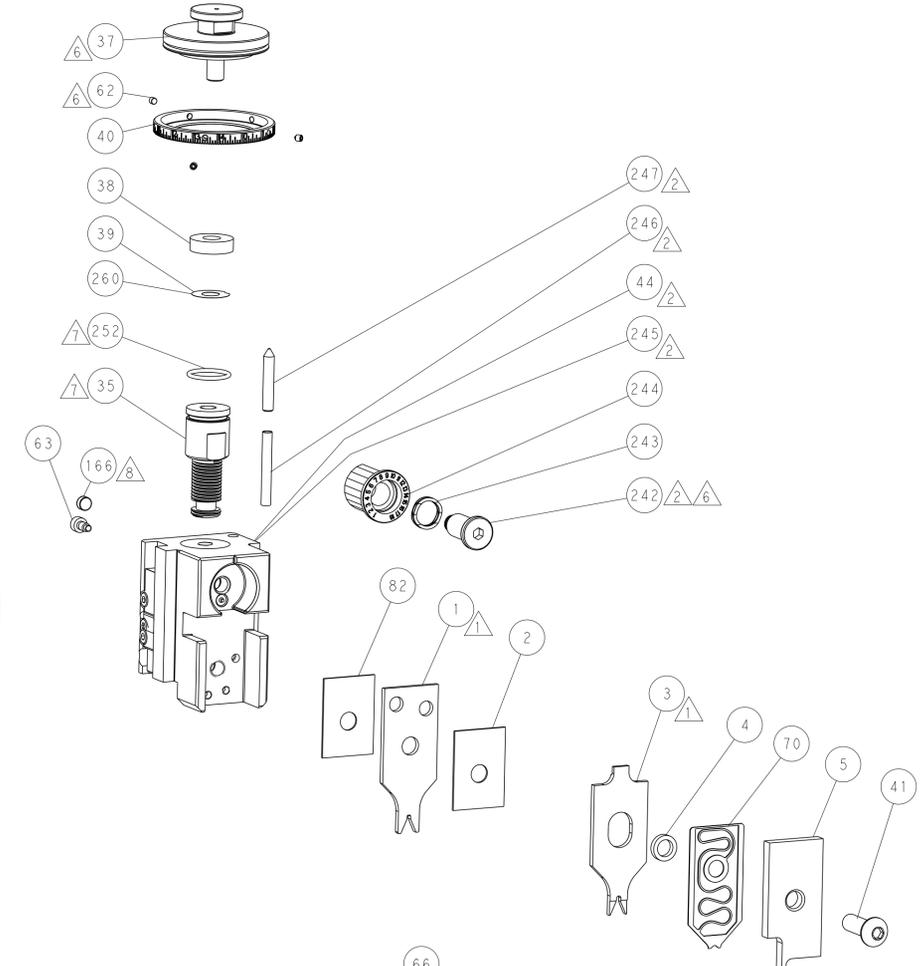
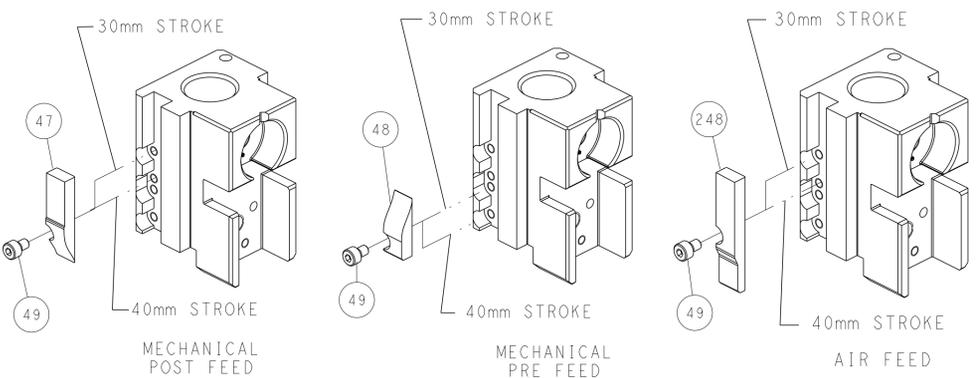
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: R. KNEPPER 16-Oct-13		TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 16-Oct-13		Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD: M. CLIFFORD 16-Oct-13		NAME: Ocean Side Feed Applicator	
CUSTOMER DRAWING		SCALE: 1:2		SIZE: A1		RESTRICTED TO:	
		SHEET 2 OF 4		CAGE CODE: 00779		DRAWING NO: C=2266117	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266117-1	D	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	-	8-2266117-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2266117-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266117-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2266117-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	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
	2-2266117-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266117-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-
7-2266117-8	C	APPLICATOR CONVERSION KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-10389		

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22 AWG	0.94+0.03/-0.05 [.037+.001/-0.002]	8.7
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- 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:
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PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266117-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266117-5
- 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.

***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.

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

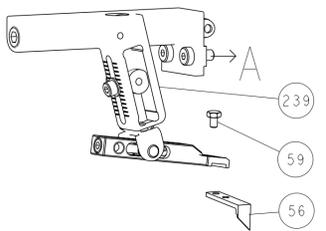
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	-	1	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
-	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
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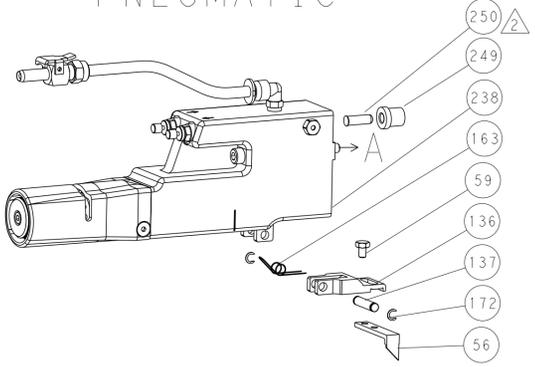
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		M. CLIFFORD	16-Oct-13		Ocean Side Feed Applicator	
MATERIAL:	FINISH	APVD	SCALE	SHEET	REV	
			1:2	3 of 4	D	

REVISONS		DATE	OWN	APVD
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- SEE SHEET 1				

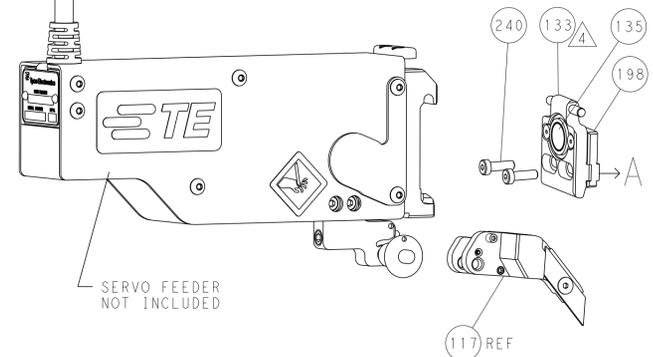
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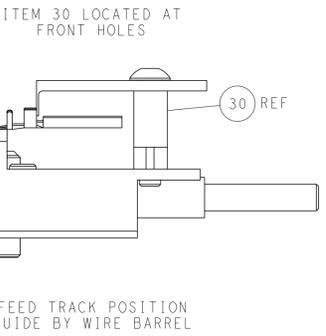
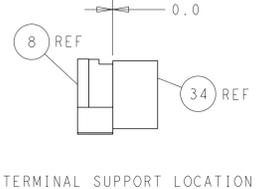
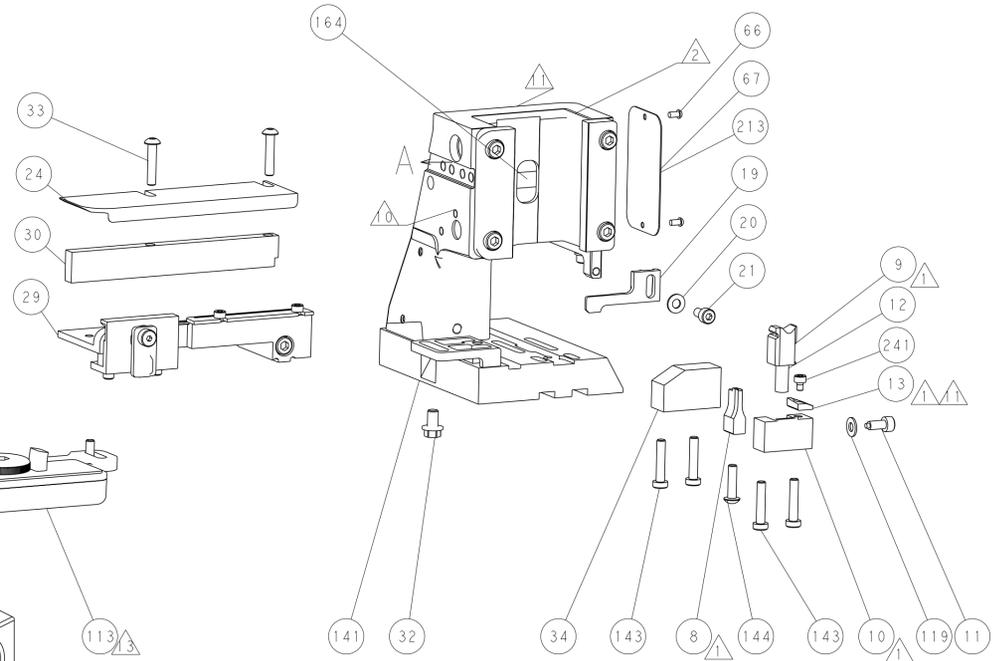
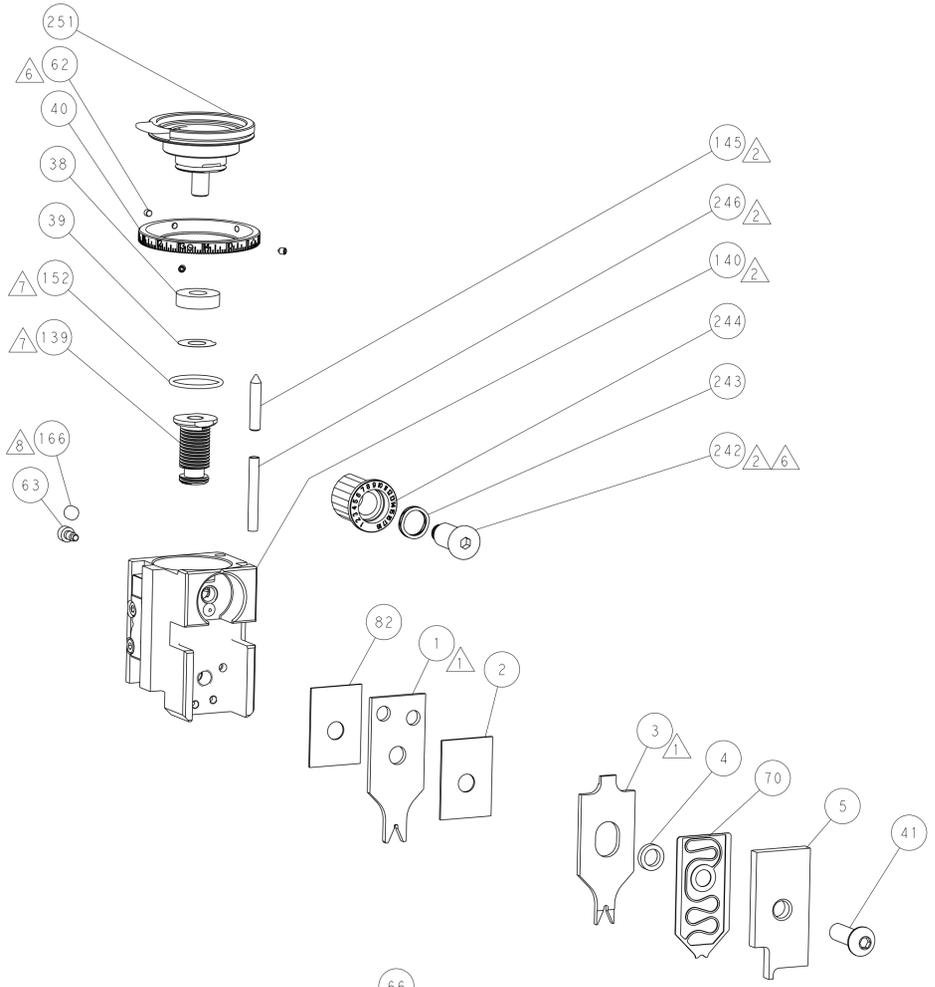
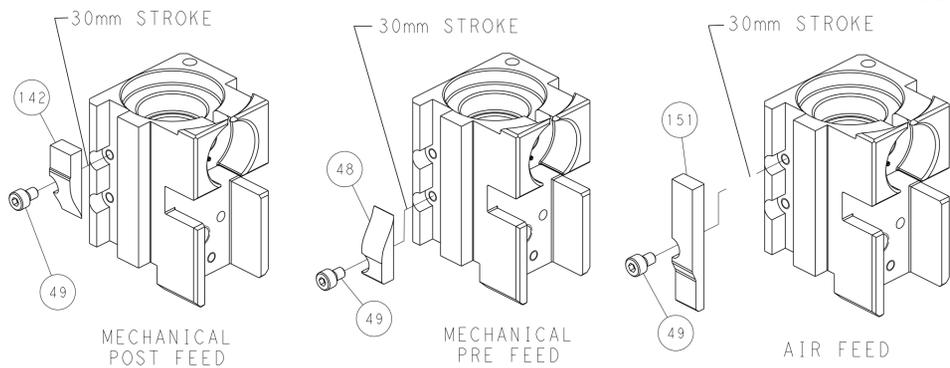
PNEUMATIC



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 CONTROLLING ENGINEERING 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 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ± ±	PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER DRAWING	SIZE CAGE CODE DRAWING NO. RESTRICTED TO A 00779 C=2266117 SCALE 1:2 SHEET 4 OF 4 REV D