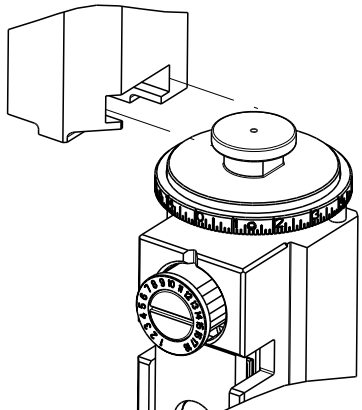
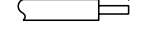


8		7		6		5		4		3		
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
		2266419-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
						SERVO LATCH PLATE	2119951-1	-	8-2266419-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2266419-4	-	-	-
		2266419-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2266419-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2266419-4	-	-	-
		2266419-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
		2266419-6	B	NON-CRIMP HEIGHT ADJUST	⁴ LATCH PLATE ¹²	-	-	-	-	-	-	-
						-	-	-	-	-	-	-
2266419-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-		
7-2266419-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.67 mm [.066]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: KOSTAL TERMINAL		KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: KOSTAL MLK 1.2m RECEPTACLE			
WIRE STRIP LENGTH 2.60-3.60 mm [.102-.142 IN]		 INSULATION DIAMETER RANGE $\varnothing 1.20-1.40$ mm [.047-.055 IN]	
TERMINAL APPLICATION SPECIFICATION 		DOC00061540 ATTACHMENT 3 Pg. 50 OF 57 - - -	
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE TERMINAL	KOSTAL TERMINAL
1949957-1	32124734010	1949957-2	32125734010
1949957-3	32140734010	1572680-1	32140651760
1572680-2	32124651760	1572680-3	32125651760
1949380-1	32124734060	1949380-2	32125734060
1949380-3	32140734060		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.35mm2		0.76 +/- 0.03 [0.030 +/- .001]		6.9



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: 8-2266419-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266419-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266419-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266419-6

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 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.

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.

 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.

12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6)
USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 5.04.

 CUT TO LENGTH AT ASSEMBLY.

2

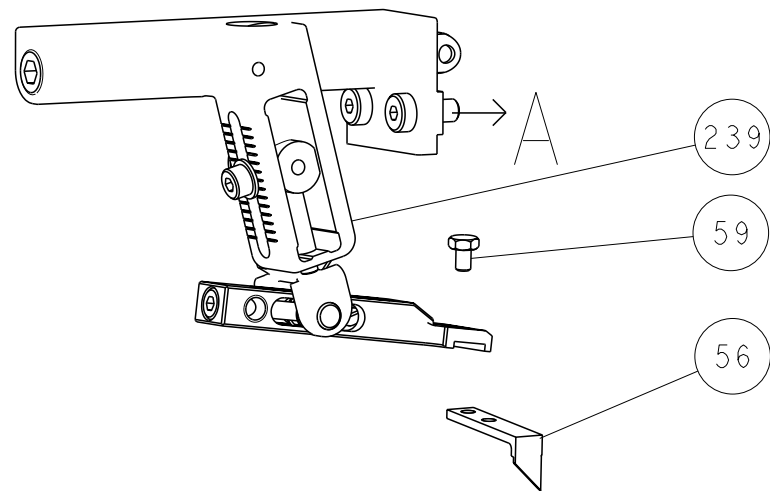
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SET UP GAUGE		LOC	DIST	REVISIONS					
2119599-1		A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
					I	DEVELOPMENT	23JUL2014	JH	UG
					A	RELEASE	23SEP2014	MR	GD
					B	ECR-17-017161	21NOV2017	JA	TE
1	-	-	-	2119957-2	APPLICATOR SHIM PACK				260
-	1	1	1	8-21084-0	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	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	2119082-5	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
-	-	-	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
REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF				117
1	1	1	1	455888-6	SPACER, CRIMPER				82
1	1	1	1	2119956-1	DOCUMENTATION PACKAGE				71
-	-	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	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0				59
-	-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16				53
1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED				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	1-2119644-4	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	1320908-6	SPACER, STRIP GUIDE				30
1	1	1	1	2119959-2	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
2	2	2	2	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	1-1803554-5	ANVIL, COMBINATION				8
1	1	1	1	240641-1	SPACER				7
-	-	-	-	-	-				6
1	1	1	1	2119757-1	DEPRESSOR, SHEAR				5
1	1	1	1	3-238011-3	BLOCK, CRIMPER SPACER				4
1	1	1	1	7-1633965-6	CRIMPER, INSULATION O PREMIUM				3
1	1	1	1	455888-5	SPACER, CRIMPER				2
1	1	1	1	2-1633664-7	CRIMPER, WIRE				1

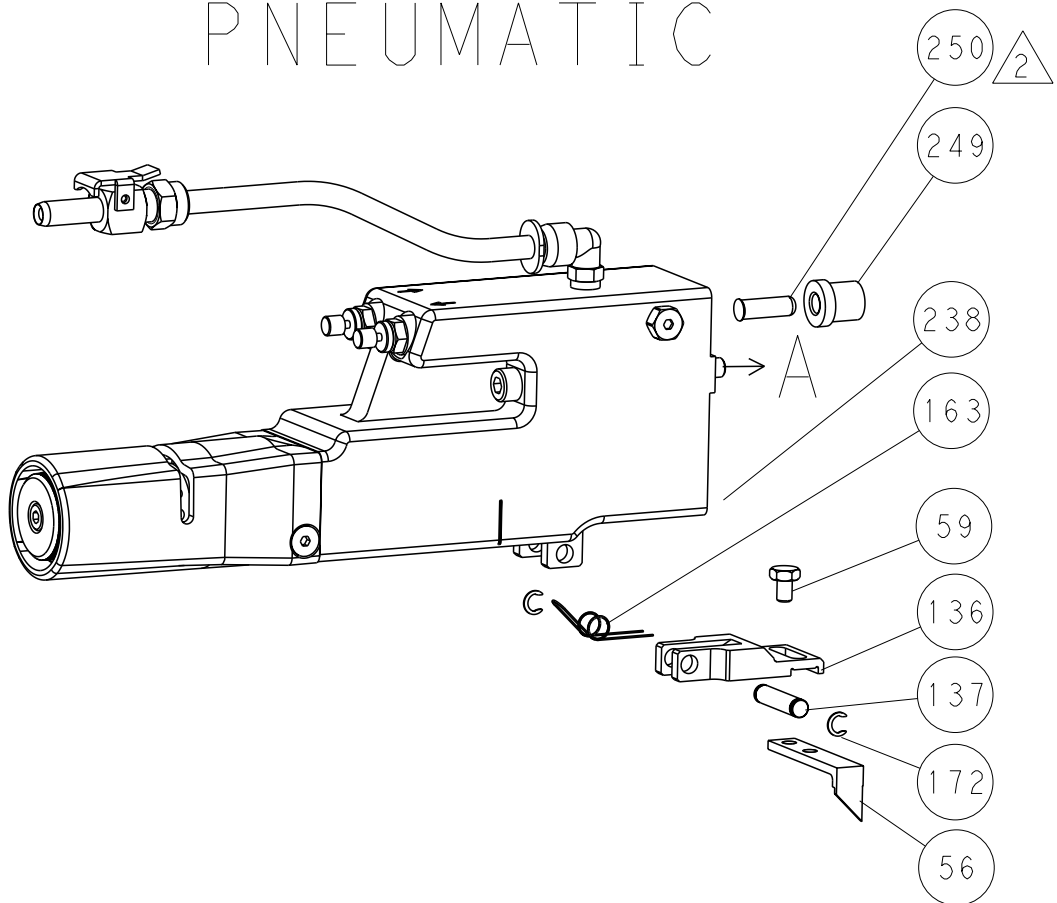
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE INTERFERENCE PROTECTION CATEGORY CABLES ARE CONTACTED FOR THE LIFE OF OPERATION DIMENSIONS: mm						TOL. UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG 23JULY2014 CHK Y. YIN 23JULY2014 APP'D U. GUO 23JULY2014 PRODUCT SPEC - APPLICATION SPEC -		TE Connectivity Harrisburg, PA 17105-3608	
								NAME Ocean Side Feed Applicator			
MATERIAL -						SIZE A		CAGE CODE 00779	DRAWING NO. C=2266419	RESTRICTED TO -	
WEIGHT -						Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV B					

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

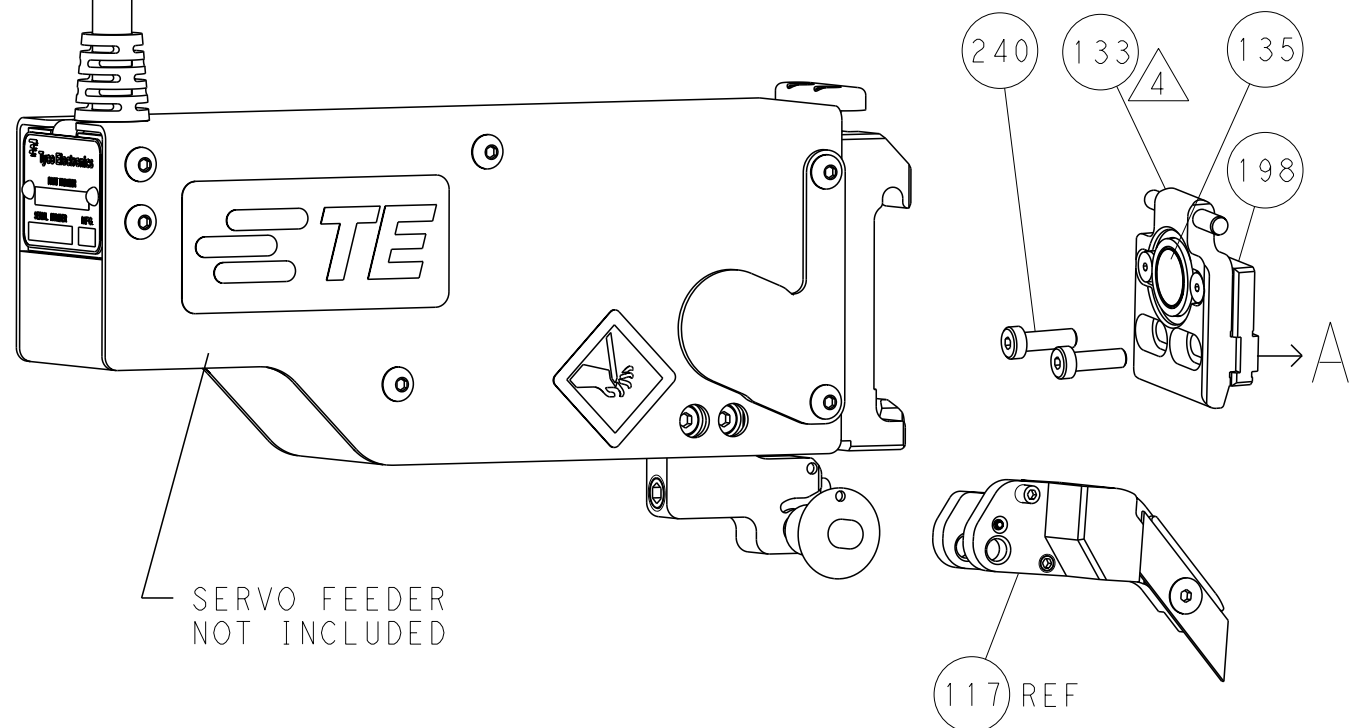
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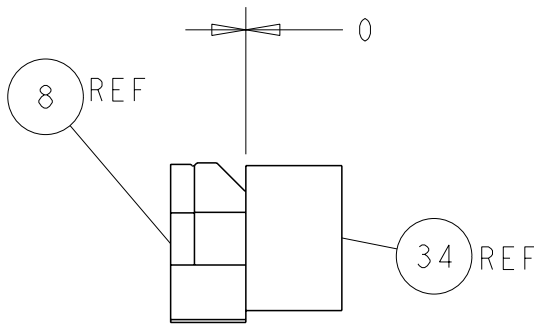
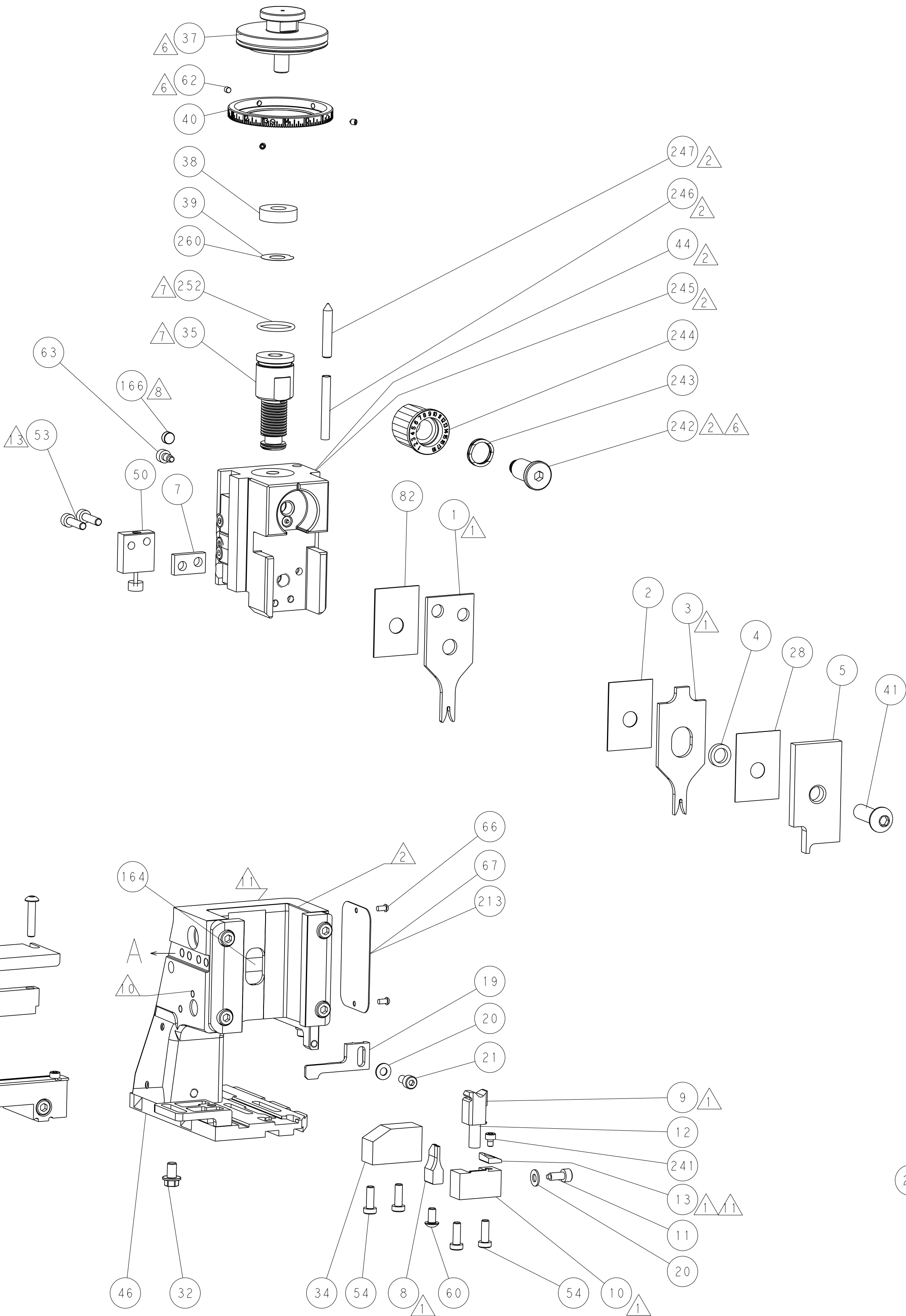
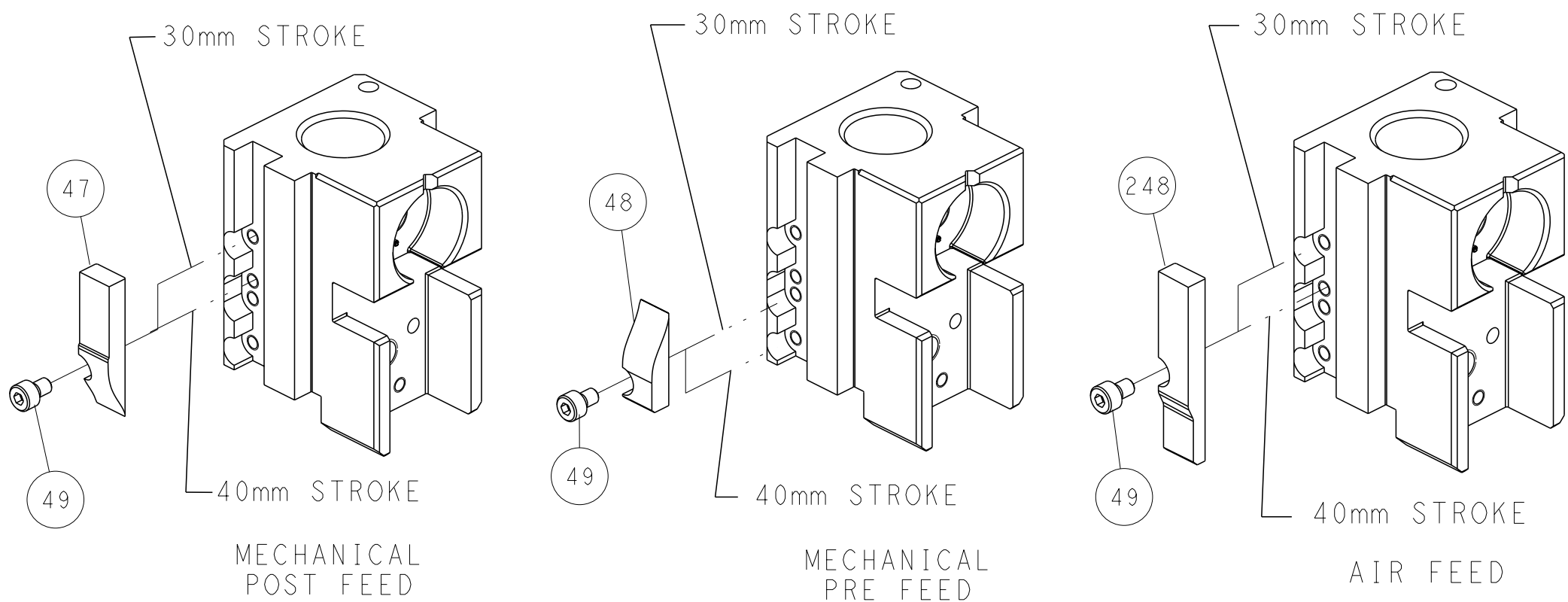
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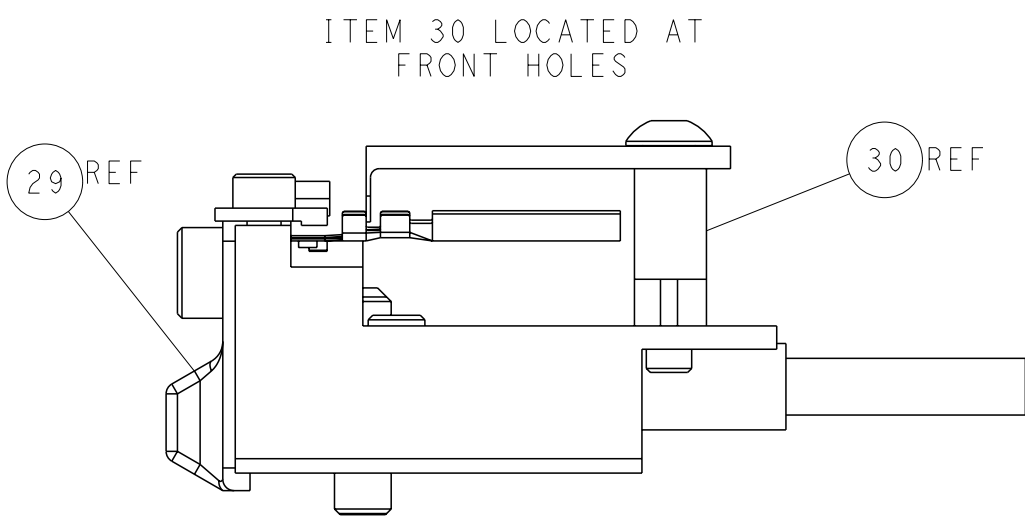
SERVO
LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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				CHK	Y. YIN	23JULY2014		
				APVD	U. GUO	23JULY2014	NAME	
				PRODUCT SPEC			Ocean Side Feed Applicator	
				APPLICATION SPEC			-	
				WEIGHT			-	
				Customer Accessible Production Drawing			SCALE	
							1:2	
							SHEET	
							2 of 4	
							REV	
							B	

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

D

C

B

A

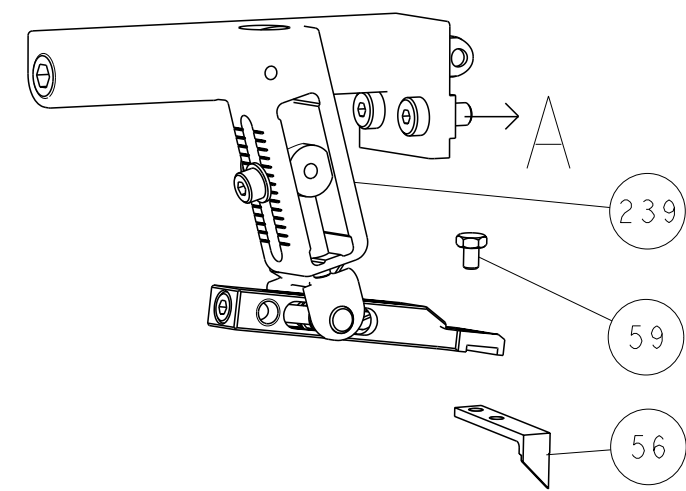
D

C

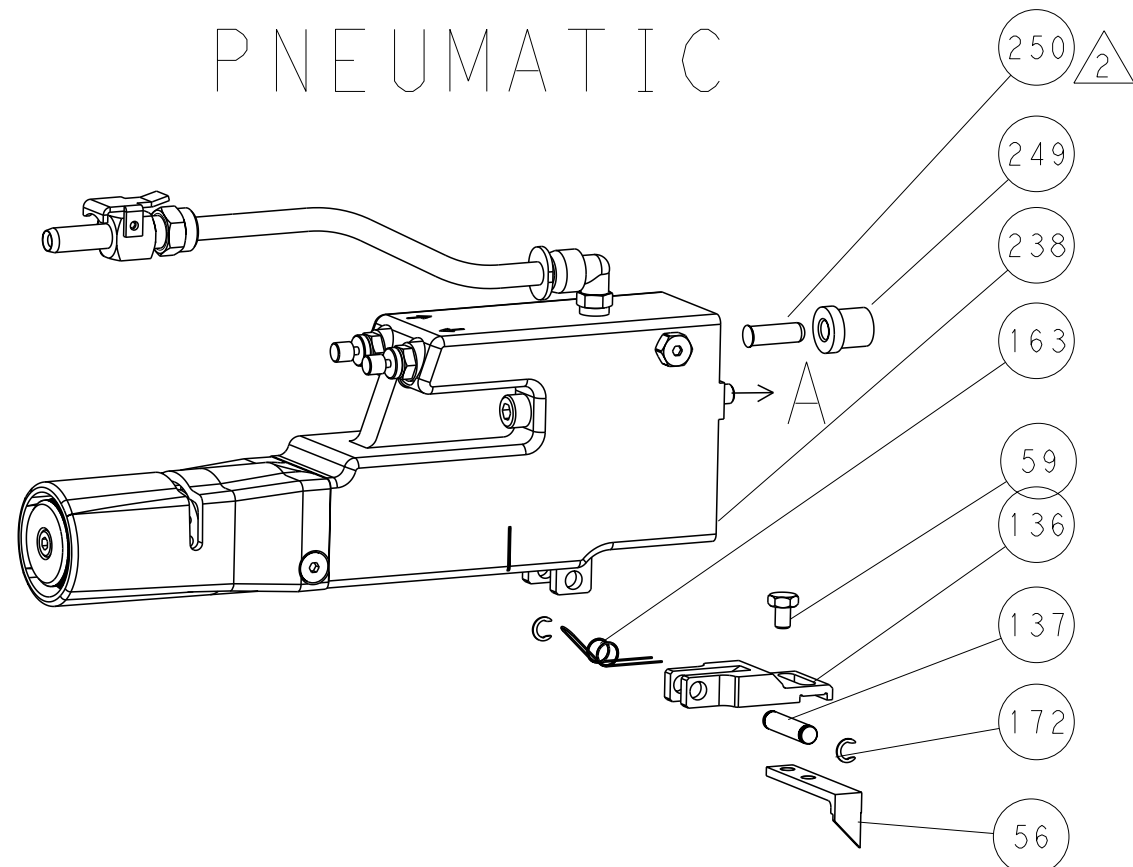
B

A

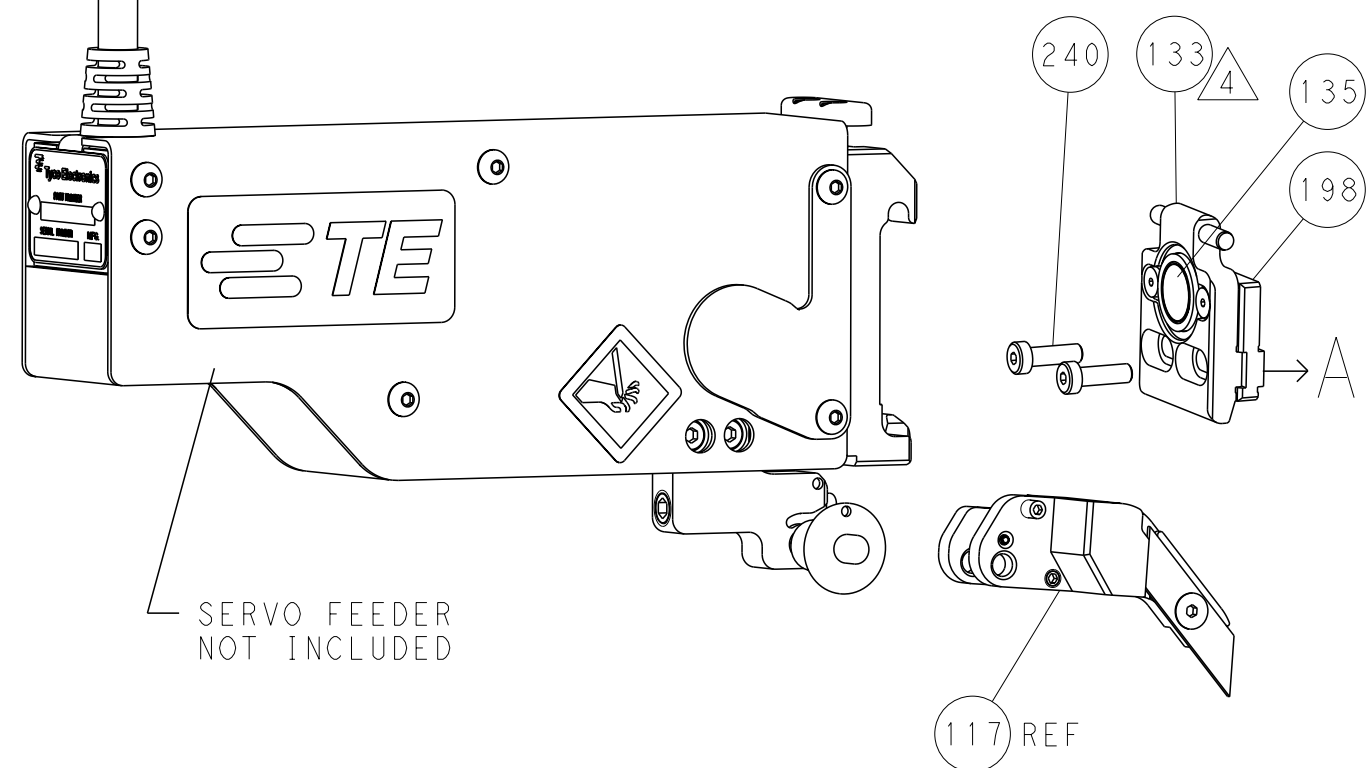
FEED TYPE MECHANICAL



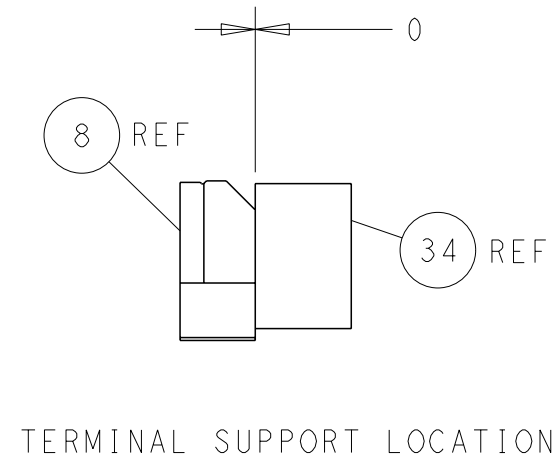
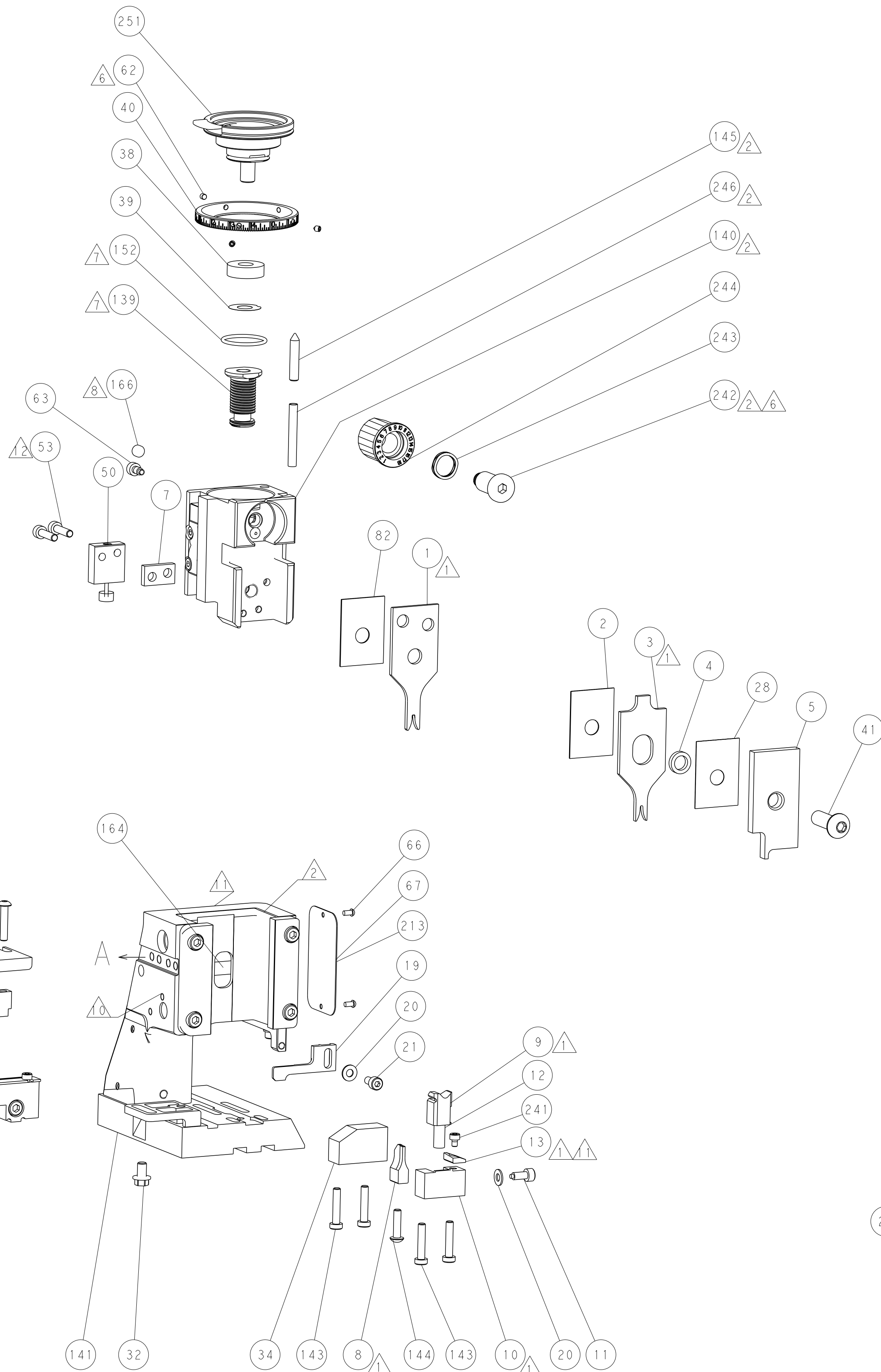
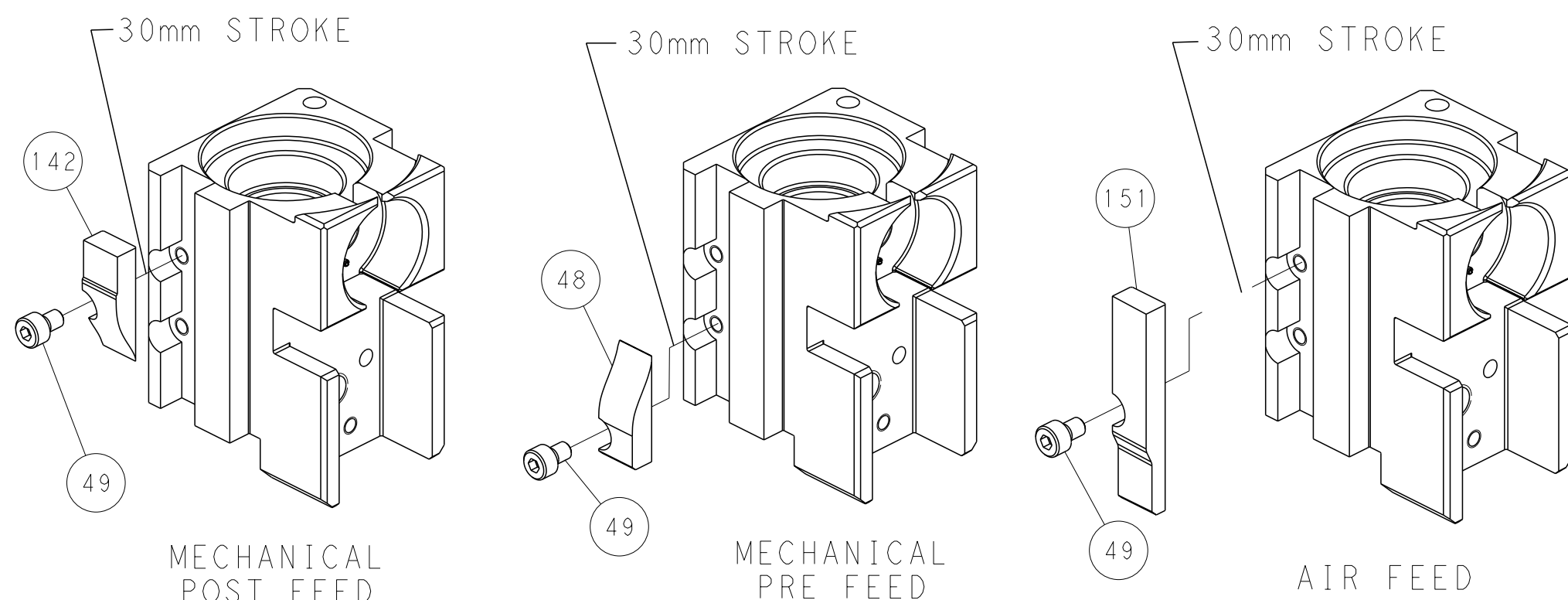
PNEUMATIC



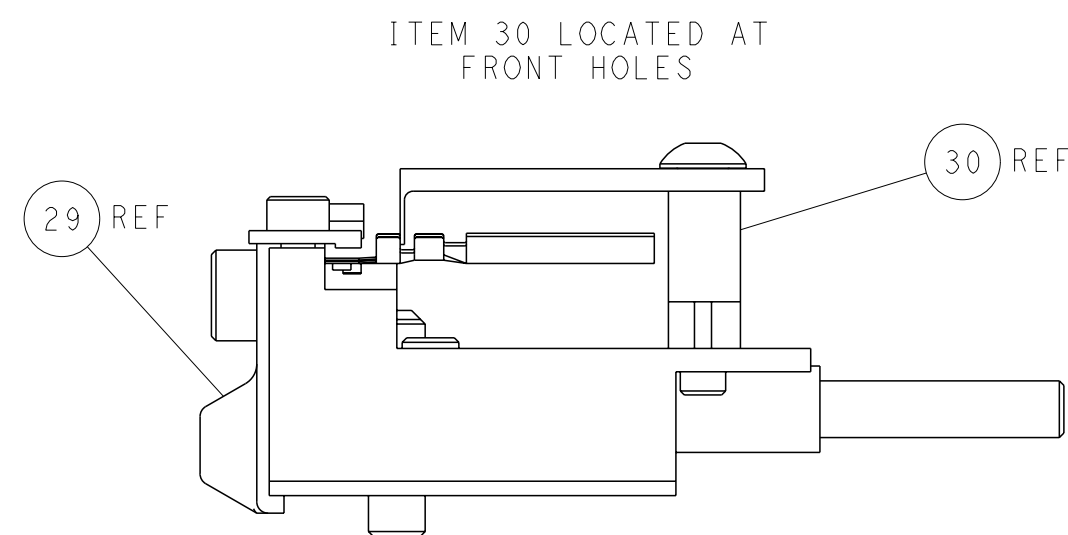
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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)

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DIMENSIONS: mm		CHK Y. YIN 23JULY2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD U. GUO 23JULY2014	PRODUCT SPEC	
MATERIAL -		FINISH -	APPLICATION SPEC	
		WEIGHT -	SIZE A1	
		Customer Accessible Production Drawing	SCALE 1:2	
			SHEET 4	
			OF 4	
			REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION