

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                  | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|---|-------------|---------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   |             |                           |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|   | 2266100-1   | 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             | -         | 8-2266100-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   | 2266100-2   | B                         | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -         | -                      |
|   |             |                           |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266100-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   | 2266100-5   | B                         | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 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              |
|   | 2266100-6   | B                         | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | -                                 | -                     | -         | -           | -         | -         | -                      |
|   | 2266100-7   | B                         | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | -         | -                      |
| 7-2266100-7                                   | B           | CRIMP TOOLING KIT         | -                        | -                 | -                                 | -                     | -         | -           | -         | -         |                        |
| 7-2266100-8                                   | B           | APPLICATOR CONVERSION KIT | -                        | -                 | -                                 | -                     | -         | -           | -         | -         |                        |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 2.29 mm [.090] | F    |
| INSUL           | 3.20 mm [.126] | O    |

APPLICATOR INSTRUCTIONS  
408-10389

| APPLICATOR CONVERSION KITS |                           |
|----------------------------|---------------------------|
| PART NUMBER                | INSULATION DIAMETER RANGE |
| 7-2266100-8                | Ø 3.05-3.81mm [.120-.150] |
| 7-2266101-8                | Ø 2.67-3.18mm [.105-.125] |
| 7-2266102-8                | Ø 2.16-2.82mm [.085-.111] |
| 7-2266103-8                | Ø 1.91-2.67mm [.075-.105] |
| 7-2266104-8                | Ø 1.60-2.39mm [.063-.094] |

| TERMINAL DATA: DEUTSCH TERMINAL            |            | TE CRIMP SPECIFICATION        |  |
|--|------------|-------------------------------|--|
| TERMINAL NAME: STAMPED CONTACT PIN SIZE 16 |            |                               |  |
| WIRE STRIP LENGTH                          |            | INSULATION DIAMETER RANGE     |  |
| 3.81-5.09 mm [.150-.200 IN]                |            | Ø 3.05-3.81 mm [.120-.150 IN] |  |
| TERMINAL APPLICATION SPECIFICATION         | 114-151000 |                               |  |

| TERMINALS APPLIED |                  |             |                  |
|-------------------|------------------|-------------|------------------|
| TE TERMINAL       | DEUTSCH TERMINAL | TE TERMINAL | DEUTSCH TERMINAL |
| 286505-1          | 1060-14-0122     | 286505-2    | 1060-14-0144     |
| 286505-3          | 1060-14-0177     | 286505-5    | 1060-14-1077     |
| 286505-6          | 1060-14-1088     |             |                  |

| TERMINAL DATA: DEUTSCH TERMINAL               |            | TE CRIMP SPECIFICATION        |  |
|---|------------|-------------------------------|--|
| TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 16 |            |                               |  |
| WIRE STRIP LENGTH                             |            | INSULATION DIAMETER RANGE     |  |
| 3.81-5.09 mm [.150-.200 IN]                   |            | Ø 3.05-3.81 mm [.120-.150 IN] |  |
| TERMINAL APPLICATION SPECIFICATION            | 114-151000 |                               |  |

| TERMINALS APPLIED |                  |             |                  |
|-------------------|------------------|-------------|------------------|
| TE TERMINAL       | DEUTSCH TERMINAL | TE TERMINAL | DEUTSCH TERMINAL |
| 286506-1          | 1062-14-0122     | 286506-2    | 1062-14-0144     |
| 286506-3          | 1062-14-0177     | 286506-6    | 1062-14-1088     |
| 286506-5          | 1062-14-1077     |             |                  |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]             | CRIMP HEIGHT REFERENCE SETTING |
|-----------|------------------------------------|--------------------------------|
| 14 AWG    | 1.40+0.03/-0.05 [.055+.001/- .002] | 4.6                            |
| 2.00mm2   | 1.40+0.03/-0.05 [.055+.001/- .002] | 4.6                            |
| 1.50mm2   | 1.35+0.03/-0.05 [.053+.001/- .002] | 5.2                            |
| 16 AWG    | 1.27+0.03/-0.05 [.050+.001/- .002] | 6.0                            |
| 1.00mm2   | 1.27+0.03/-0.05 [.050+.001/- .002] | 6.0                            |
| 18 AWG    | 1.24+0.03/-0.05 [.049+.001/- .002] | 6.2                            |
| 0.75mm2   | 1.22+0.03/-0.05 [.048+.001/- .002] | 6.4                            |

- 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: 8-2266100-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266100-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266100-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266100-6
- 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 4.40.
- 13. SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.

**\*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.

|     |     |    |    |    |    |    |           |                                 |         |
|-----|-----|----|----|----|----|----|-----------|---------------------------------|---------|
| -   | -   | -  | 1  | -  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| -   | -   | -  | 1  | 1  | 1  | 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     |
| -78 | -77 | -7 | -6 | -5 | -2 | -1 | PART NO   | DESCRIPTION                     | ITEM NO |

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

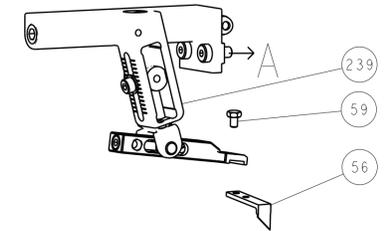
| SET UP GAUGE | LOC | DIST | REVISIONS |     |               |           |     |      |
|--------------|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|              |     |      | A1        |     | ECR-14-001856 | 07FEB2014 | RK  | GB   |
|              |     |      | A2        |     | ECR-14-003679 | 12MAR2014 | YY  | UG   |
|              |     |      | A3        |     | ECR-15-012960 | 9SEP2015  | RS  | UG   |
|              |     |      | B         |     | ECR-16-005811 | 21APR2016 | KH  | GB   |

|   |   |     |     |     |     |     |             |                                     |     |
|---|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | - | -   | -   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
| - | - | 1   | -   | 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   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | - | 1   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | - | 1   | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | - | 1   | 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   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166 |
| - | - | REF | 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   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | - | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY,SF             | 117 |
| - | - | 1   | 1   | 1   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113 |
| 1 | - | 1   | 1   | 1   | 1   | 1   | 455888-8    | SPACER, CRIMPER                     | 82  |
| 1 | - | -   | -   | -   | -   | -   | 2266100     | PRINT, APPLICATOR LOG SHEET         | 72  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | - | 2   | 2   | 2   | 2   | 2   | 2119791-9   | DEPRESSOR, WIRE                     | 70  |
| - | - | 1   | -   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| - | - | 2   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | - | 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   | 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   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54  |
| - | - | 2   | 2   | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53  |
| - | - | 1   | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
| - | - | 1   | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
| - | - | 1   | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 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   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46  |
| - | - | 1   | -   | -   | -   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | - | 1   | -   | -   | -   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
| - | - | 1   | -   | -   | -   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2119644-1   | RAM WASHER, PRECISION               | 38  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37  |
| - | - | 1   | -   | -   | -   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2-1752356-0 | SUPPORT, TERMINAL                   | 34  |
| - | - | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32  |
| - | - | 1   | 1   | 1   | 1   | 1   | 1-1320908-0 | SPACER, STRIP GUIDE                 | 30  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | - | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | - | 1   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | - | 1   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | - | 1   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| - | - | 1   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | - | 1   | 1   | 1   | 1   | 1   | 1803095-1   | FLOATING SHEAR, FRONT               | 9   |
| 1 | 1 | 1   | 1   | 1   | 1   | 1   | 1803293-1   | ANVIL, COMBINATION DEUTSCH STYLE    | 8   |
| - | - | -   | -   | -   | -   | -   | -           | -                                   | 7   |
| - | - | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | - | 1   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | - | 1   | 1   | 1   | 1   | 1   | 238011-9    | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 1 | 1   | 1   | 1   | 1   | 1   | 1803019-3   | CRIMPER, INSULATION O               | 3   |
| 1 | - | 1   | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2   |
| - | 1 | 1   | 1   | 1   | 1   | 1   | 2-1633713-6 | CRIMPER, WIRE PREMIUM               | 1   |

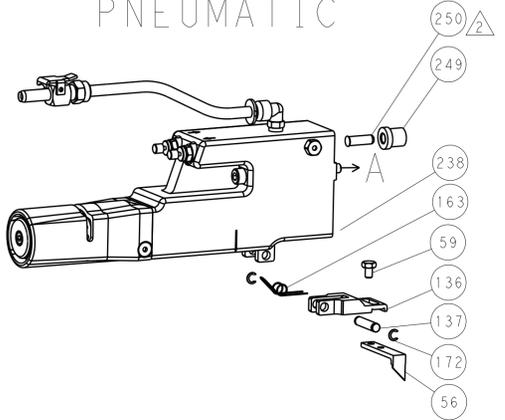
|                 |        |   |       |   |   |
|-----------------|--------|---|-------|---|---|
| DIMENSIONS:<br> |        | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.<br>1 PLC ±.<br>2 PLC ±.<br>3 PLC ±.<br>4 PLC ±.<br>ANGLES ±.<br>FINISH |       | DWN R. KNEPPER 23AUG2013<br>CHK G. BAILEY 23AUG2013<br>APVD M. CLIFFORD 23AUG2013<br>PRODUCT SPEC<br>APPLICATION SPEC | TE Connectivity<br>Harrisburg, PA 17105-3608<br>Ocean Side Feed<br>Applicator |
| MATERIAL        | FINISH | WEIGHT  | SCALE | RESTRICTED TO   |   |
|                 |        |   | 1:2   | REV B   |   |

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

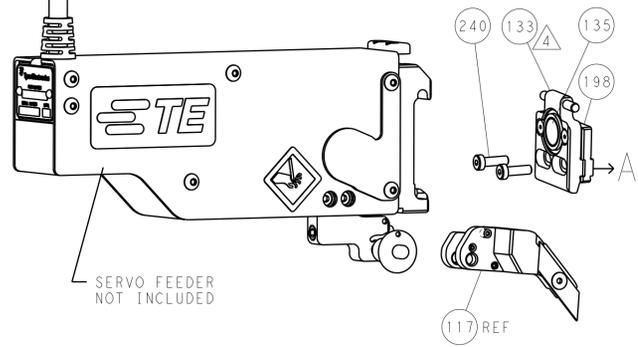
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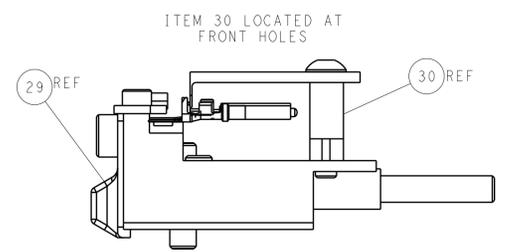
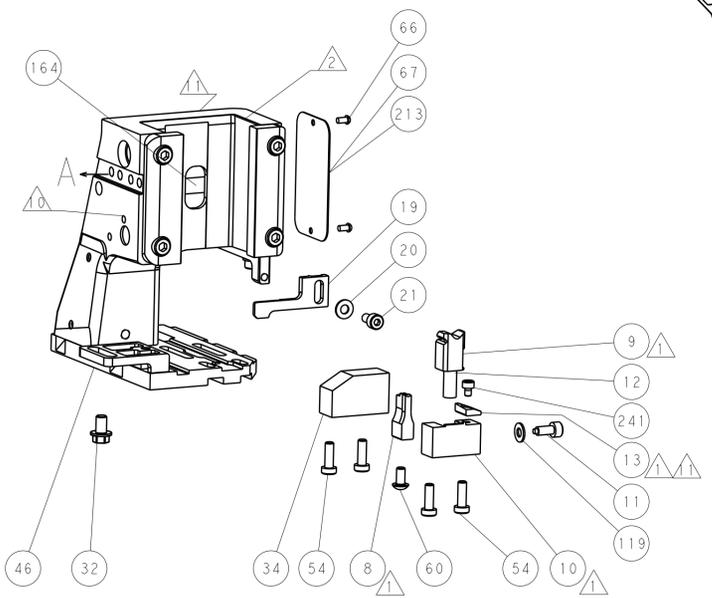
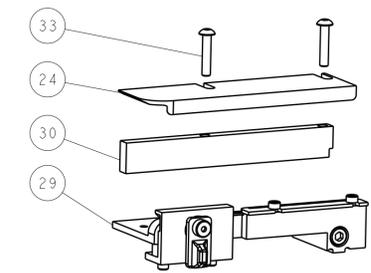
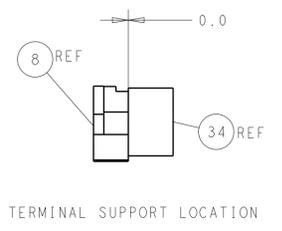
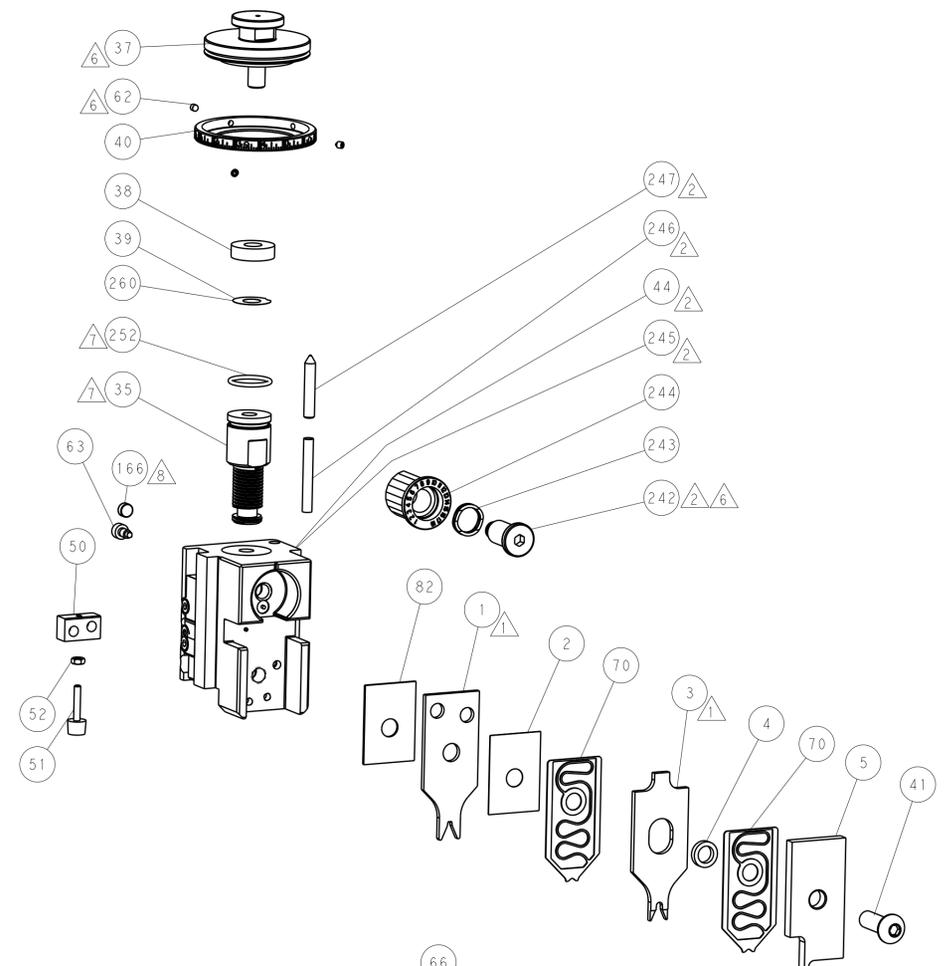
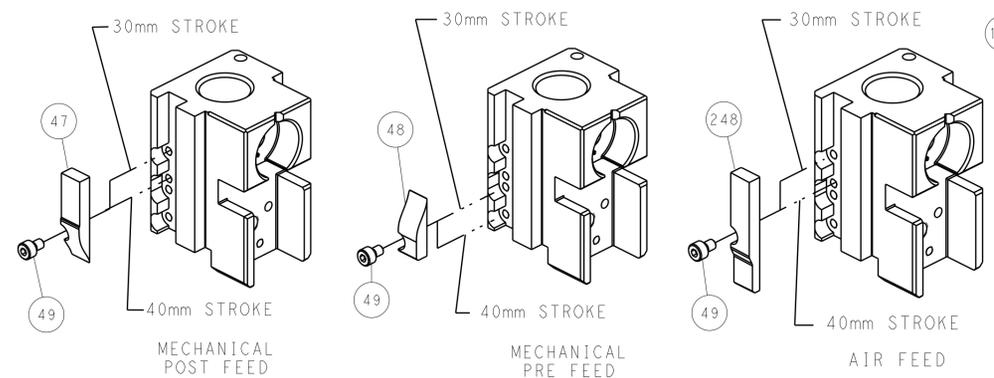
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



**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 23AUG2013              |                                  | TE Connectivity |                           |
| mm          | 0 PLC   | ±                                      |  | CHK: G. BAILEY 23AUG2013               | NAME: Ocean Side Feed Applicator |                 | Harrisburg, PA 17105-3608 |
|             | 1 PLC   | ±                                      |  | APVD: M. CLIFFORD 23AUG2013            | RESTRICTED TO:                   |                 |                           |
|             | 2 PLC   | ±                                      |  | PRODUCT SPEC:                          | SIZE: CAGE CODE: DRAWING NO:     |                 |                           |
|             | 3 PLC   | ±                                      |  | APPLICATION SPEC:                      | A11 00779 ©=2266100              |                 |                           |
|             | 4 PLC   | ±                                      |  | ANGLES:                                | WEIGHT:                          |                 |                           |
| MATERIAL:   | FINISH: |  |  | Customer Accessible Production Drawing |                                  | SCALE: 1:2      | SHEET 2 OF 4 REV B        |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                  | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|--|-------------|---------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|  |             |                           |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|  | 2-2266100-1 | B                         | 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             | -         | 8-2266100-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  | 2-2266100-2 | B                         | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266100-4 | -         | -         | -                      |
|  |             |                           |                          |                   | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  | 2-2266100-5 | B                         | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2266100-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |                           |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2266100-4 | -         | -         |                        |
|  | 2-2266100-7 | B                         | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | -         | -                      |
|  | 7-2266100-7 | B                         | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -         | -           | -         | -         | -                      |
| 7-2266100-8                                  | B           | APPLICATOR CONVERSION KIT | -                        | -                 | -                                 | -                     | -         | -           | -         | -         |                        |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.29 mm [.090] | F    |
| INSUL                                | 3.20 mm [.126] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| APPLICATOR CONVERSION KITS |                           |
|----------------------------|---------------------------|
| PART NUMBER                | INSULATION DIAMETER RANGE |
| 7-2266100-8                | Ø3.05-3.81mm [.120-.150]  |
| 7-2266101-8                | Ø2.67-3.18mm [.105-.125]  |
| 7-2266102-8                | Ø2.16-2.82mm [.085-.111]  |
| 7-2266103-8                | Ø1.91-2.67mm [.075-.105]  |
| 7-2266104-8                | Ø1.60-2.39mm [.063-.094]  |

| TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION |                  |                              |                  |
|--|------------------|------------------------------|------------------|
| TERMINAL NAME: STAMPED CONTACT PIN SIZE 16             |                  |                              |                  |
| WIRE STRIP LENGTH                                      |                  | INSULATION DIAMETER RANGE    |                  |
| 3.81-5.09 mm [.150-.200 IN]                            |                  | Ø3.05-3.81 mm [.120-.150 IN] |                  |
| TERMINAL APPLICATION SPECIFICATION                     | 114-151000       | -                            | -                |
| TERMINALS APPLIED                                      |                  |                              |                  |
| TE TERMINAL  | DEUTSCH TERMINAL | TE TERMINAL                  | DEUTSCH TERMINAL |
| 286505-1   | 1060-14-0122     | 286505-2                     | 1060-14-0144     |
| 286505-3   | 1060-14-0177     | 286505-5                     | 1060-14-1077     |
| 286505-6   | 1060-14-1088     |                              |                  |

| TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION |                  |                              |                  |
|--|------------------|------------------------------|------------------|
| TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 16          |                  |                              |                  |
| WIRE STRIP LENGTH                                      |                  | INSULATION DIAMETER RANGE    |                  |
| 3.81-5.09 mm [.150-.200 IN]                            |                  | Ø3.05-3.81 mm [.120-.150 IN] |                  |
| TERMINAL APPLICATION SPECIFICATION                     | 114-151000       | -                            | -                |
| TERMINALS APPLIED                                      |                  |                              |                  |
| TE TERMINAL  | DEUTSCH TERMINAL | TE TERMINAL                  | DEUTSCH TERMINAL |
| 286506-1   | 1062-14-0122     | 286506-2                     | 1062-14-0144     |
| 286506-3   | 1062-14-0177     | 286506-6                     | 1062-14-1088     |
| 286506-5   | 1062-14-1077     |                              |                  |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]             | CRIMP HEIGHT REFERENCE SETTING |
|-----------|------------------------------------|--------------------------------|
| 14 AWG    | 1.40+0.03/-0.05 [.055+.001/-0.002] | 4.6                            |
| 2.00mm2   | 1.40+0.03/-0.05 [.055+.001/-0.002] | 4.6                            |
| 1.50mm2   | 1.35+0.03/-0.05 [.053+.001/-0.002] | 5.2                            |
| 16 AWG    | 1.27+0.03/-0.05 [.050+.001/-0.002] | 6.0                            |
| 1.00mm2   | 1.27+0.03/-0.05 [.050+.001/-0.002] | 6.0                            |
| 18 AWG    | 1.24+0.03/-0.05 [.049+.001/-0.002] | 6.2                            |
| 0.75mm2   | 1.22+0.03/-0.05 [.048+.001/-0.002] | 6.4                            |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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: 8-2266100-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266100-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266100-5
- 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 ITEMS 62.  
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.

**\*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.

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

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

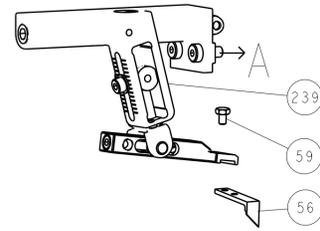
| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
|              |     |      | -         | -   | SEE SHEET 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                          | MEMORY CHIP, PROGRAMMED  | 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   | 1   | 455888-8    | SPACER, CRIMPER                     | 82                       |     |
| 1   | -   | -   | -   | -   | -   | 2266100     | PRINT, APPLICATOR LOG SHEET         | 72                       |     |
| -   | -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71                       |     |
| -   | -   | 2   | 2   | 2   | 2   | 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   | 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   | 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   | 1803293-1   | ANVIL, COMBINATION DEUTSCH STYLE    | 8                        |     |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 7                        |     |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 6                        |     |
| -   | -   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5                        |     |
| -   | -   | 1   | 1   | 1   | 1   | 238011-9    | BLOCK, CRIMPER SPACER               | 4                        |     |
| 1   | 1   | 1   | 1   | 1   | 1   | 1803019-3   | CRIMPER, INSULATION O               | 3                        |     |
| 1   | -   | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2                        |     |
| -   | -   | 1   | 1   | 1   | 1   | 2-1633713-6 | CRIMPER, WIRE PREMIUM               | 1                        |     |
| -78 | -77 | -27 | -25 | -22 | -21 | PART NO     | DESCRIPTION                         | ITEM NO                  |     |

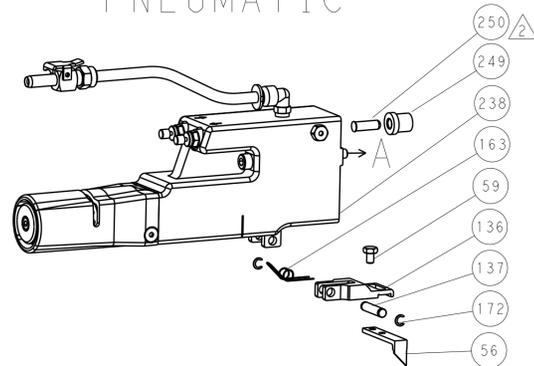
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | MATERIAL: |         | FINISH: |        | WEIGHT: |       | SCALE: |     |
|-------------|---------|--|---------|-----------|---------|---------|--------|---------|-------|--------|-----|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±   | 4 PLC ± | ANGLES  | FINISH | WT      | SCALE | SHEET  | REV |
|             |         |  |         |           |         |         |        |         | 1:2   | 3 OF 4 | B   |

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

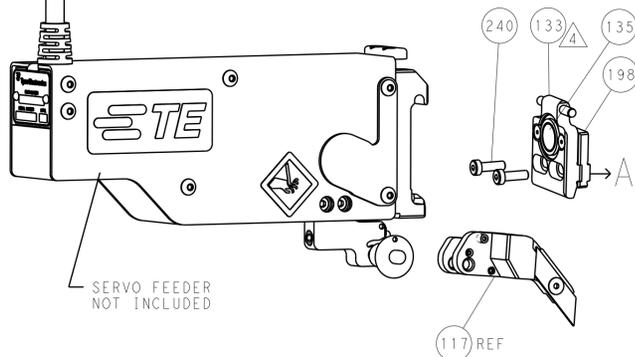
# FEED TYPE MECHANICAL



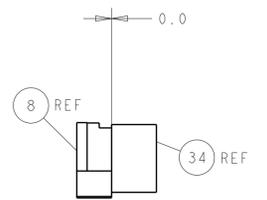
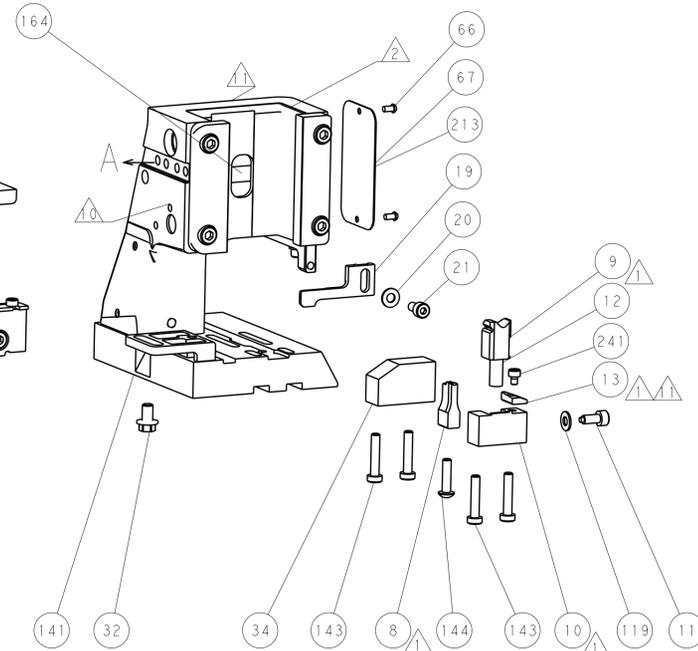
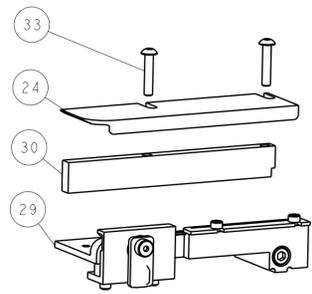
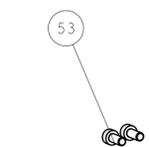
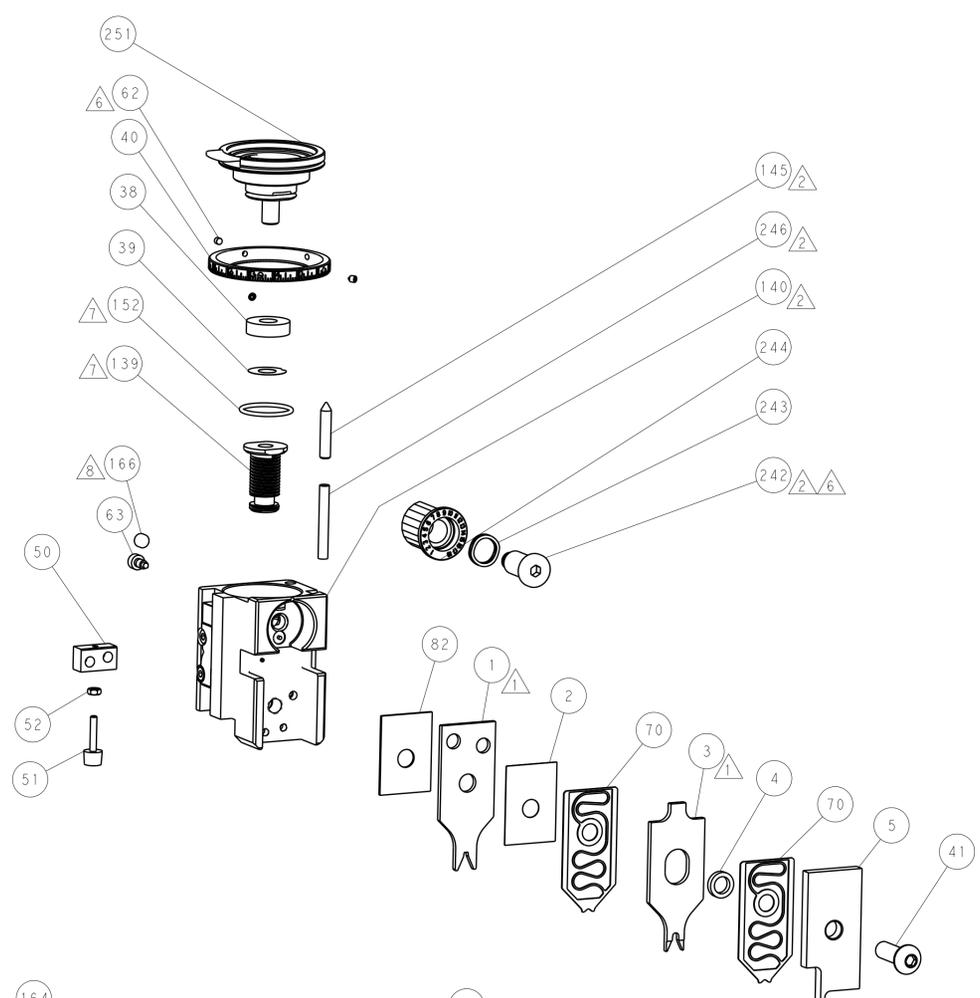
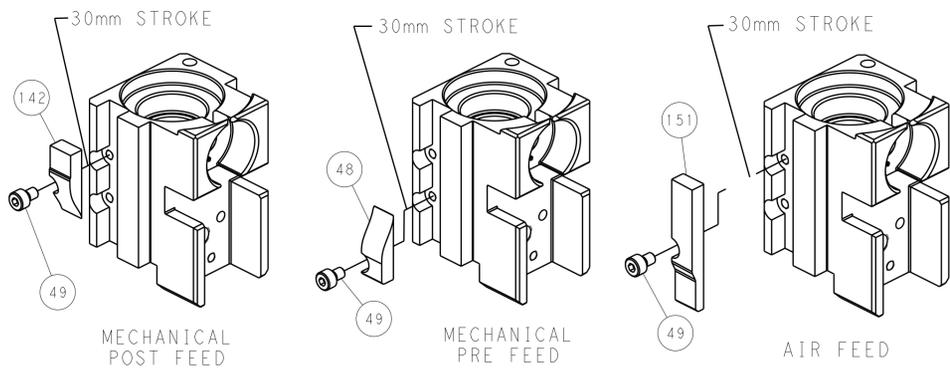
# PNEUMATIC



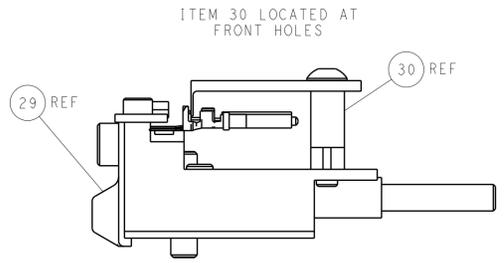
# SERVO LATCH PLATE



# 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)

|             |         |  |         |   |         |  |  |
|-------------|---------|--|---------|---|---------|--|--|
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DWN R. KNEPPER 23AUG2013<br>CHK G. BAILEY 23AUG2013<br>APVD M. CLIFFORD 23AUG2013 |         | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±   | 4 PLC ± | NAME Ocean Side Feed Applicator              |  |
| MATERIAL    |         | FINISH                                 |         | WEIGHT  |         | RESTRICTED TO                                |  |
|             |         |  |         | A 00779 ©=2266100   |         | SCALE 1:2 SHEET 4 OF 4 REV B                 |  |