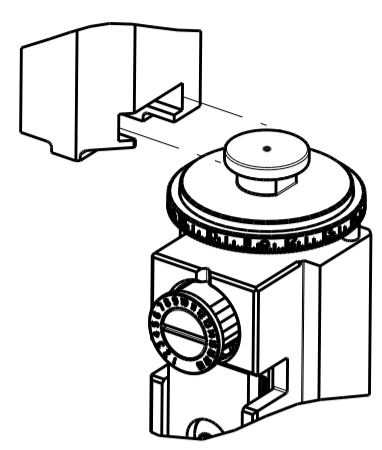


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
	2266460-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1	
					SERVO LATCH PLATE	2119951-1	-	8-2266460-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2266460-4	-	-		
	2266460-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266460-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2266460-4	-	-		
	2266460-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	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	
	2266460-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
	2266460-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
	7-2266460-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.16 mm [.085]	F
INSUL	2.55 mm [.100]	OV

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: YAZAKI TERMINAL	YAZAKI CRIMP SPECIFICATION		
TERMINAL NAME: 1.5 SYSTEM CONNECTOR			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.00-5.50 mm [.197-.217 IN]	Ø1.90-2.40 mm [.075-.094 IN]		
TERMINAL APPLICATION SPECIFICATION	YPES 72-WT10-1622 Rev WA2116		
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1572465-1	7116-4104-02		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm ²	1.35+/-0.05 [.053+/- .002]	6.4
1.25mm ²	1.30+/-0.05 [.051+/- .002]	7.0
1.00mm ²	1.25+/-0.05 [.049+/- .002]	7.6
0.5mm ² +0.5mm ²	1.15+/-0.05 [.045+/- .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:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266460-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266460-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266460-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266460-6
- 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.
- 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 4.45.

***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.

		ITEM NO
-	-	260
-	1	252
-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)

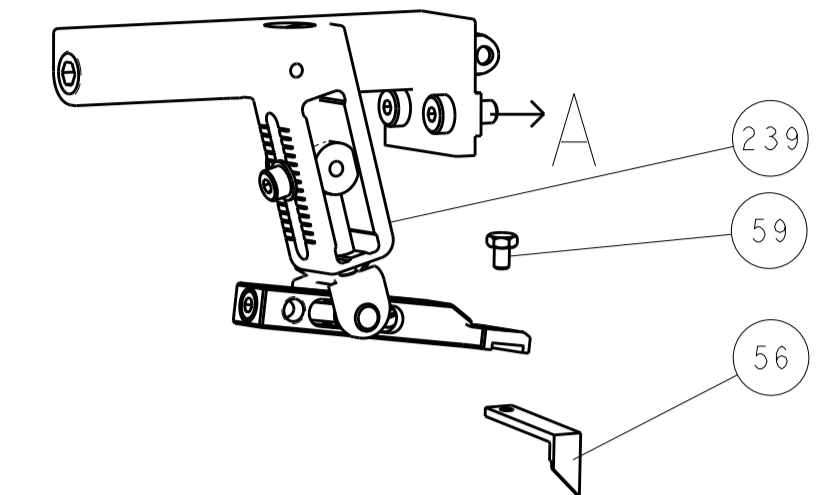
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2119599-1	A	66	REV	DATE	BY
			A	RELEASED	13OCT2014 BH GB
			B	ECR-14-018677	15DEC2014 YY UG
			C	ECR-16-018219	27DEC2016 WZ KZ

REV	DATE	DESCRIPTION	BY
-	-	-	250
-	-	-	249
-	-	-	248
-	1	-	247
-	1	-	246
-	-	-	245
-	1	1	244
-	1	1	243
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-	-	-	198
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-	REF	REF	164
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-	-	-	137
-	-	-	136
-	REF	REF	135
-	-	-	133
-	REF	REF	117
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-	1	1	71
-	1	-	67
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-	1	1	8
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-	1	1	5
-	1	1	4
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-77	-7	-6	
-5	-2	-1	
PART NO	DESCRIPTION		ITEM NO

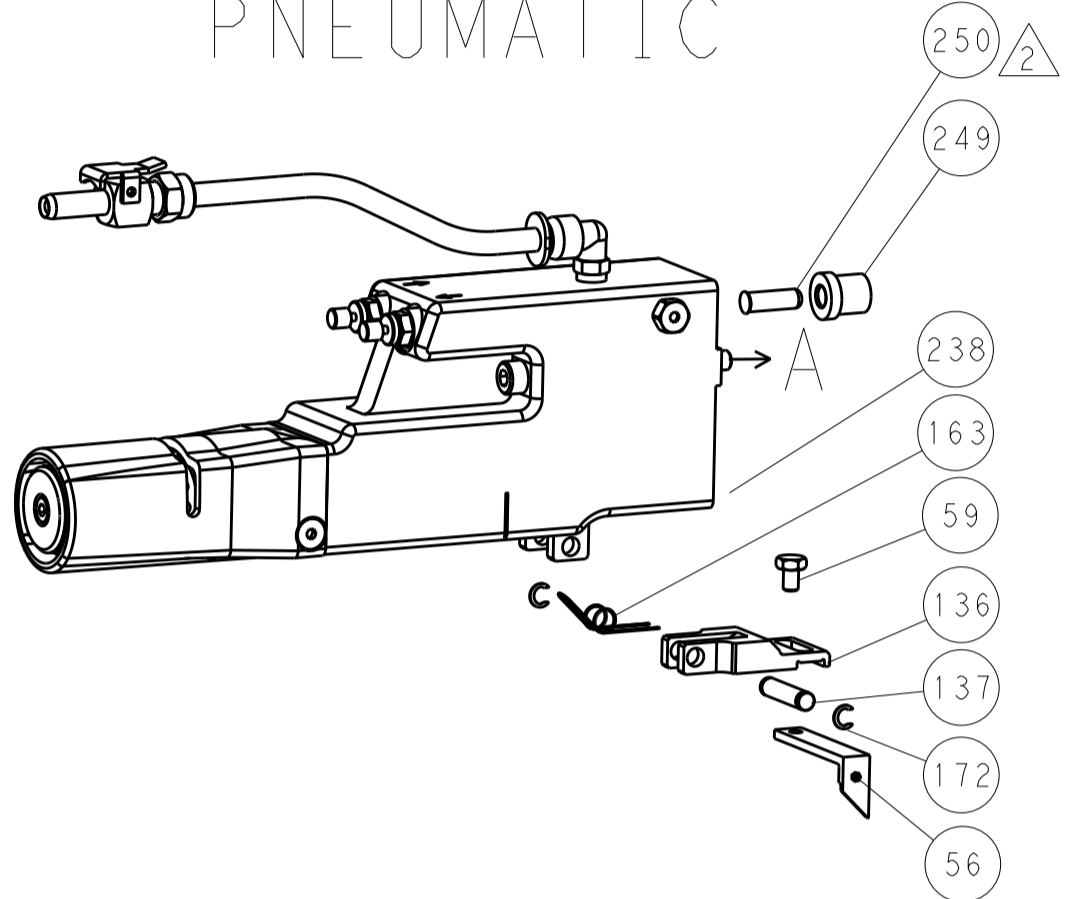
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MATERIAL		NAME Ocean Side Feed Applicator			SIZE CAGE CODE DRAWING NO A1 00779 C=2266460		RESTRICTED TO

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

FEED TYPE MECHANICAL



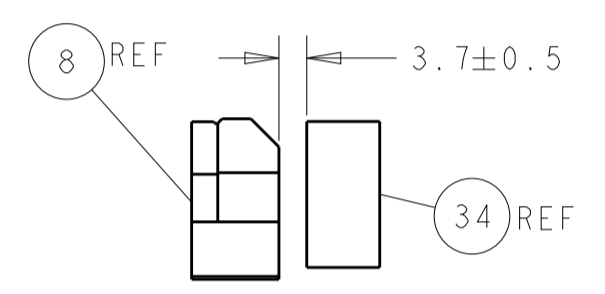
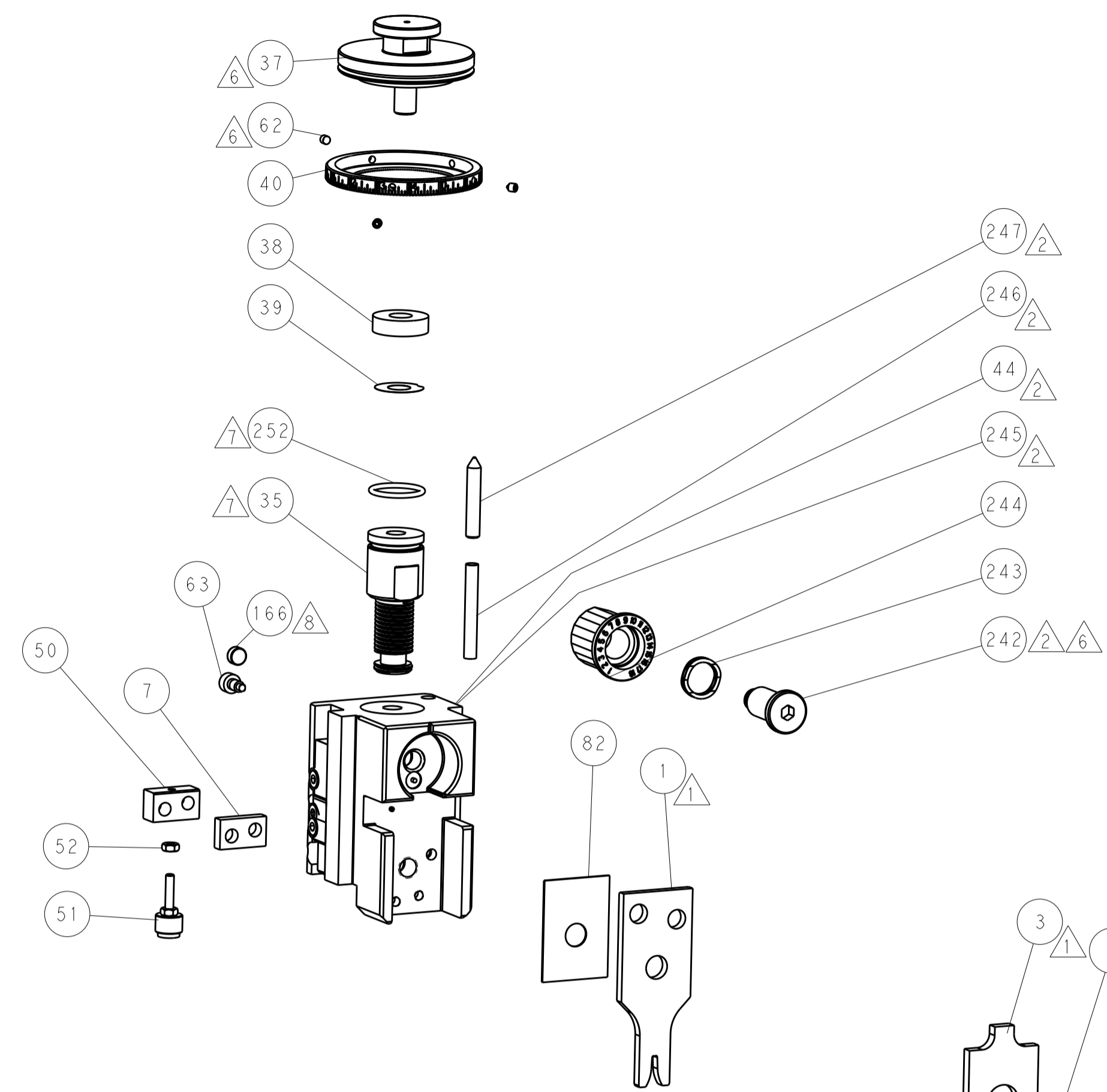
PNEUMATIC



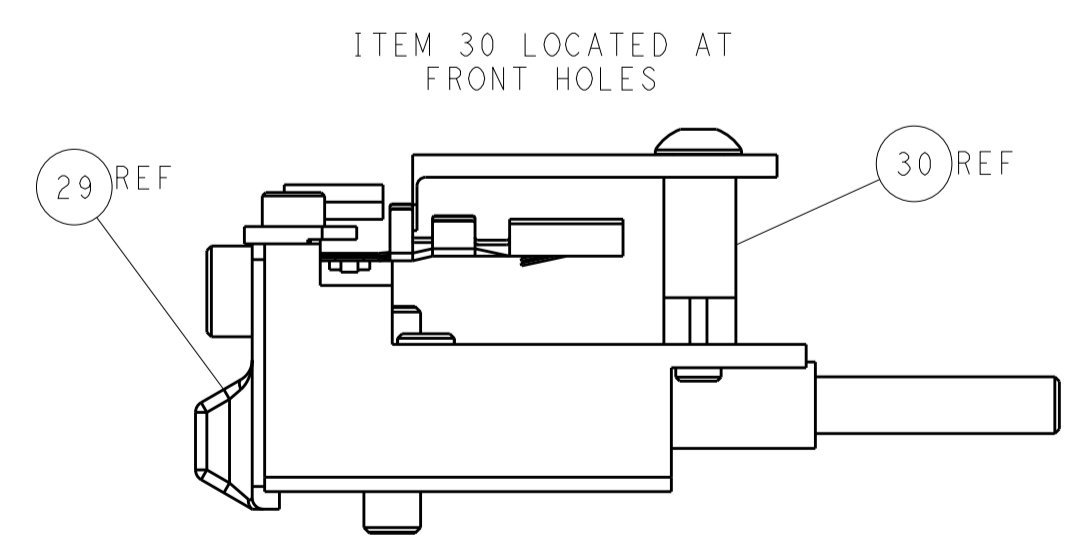
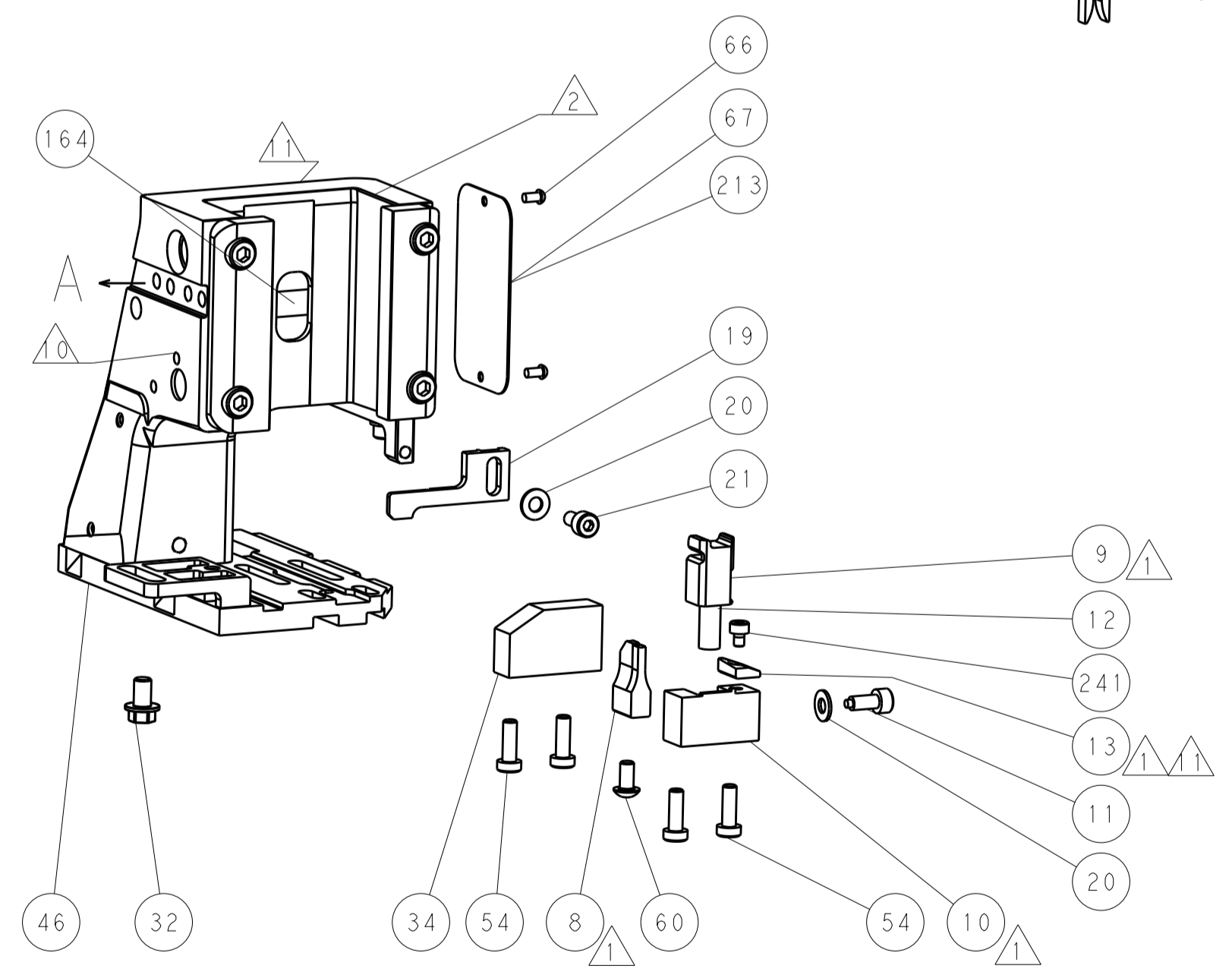
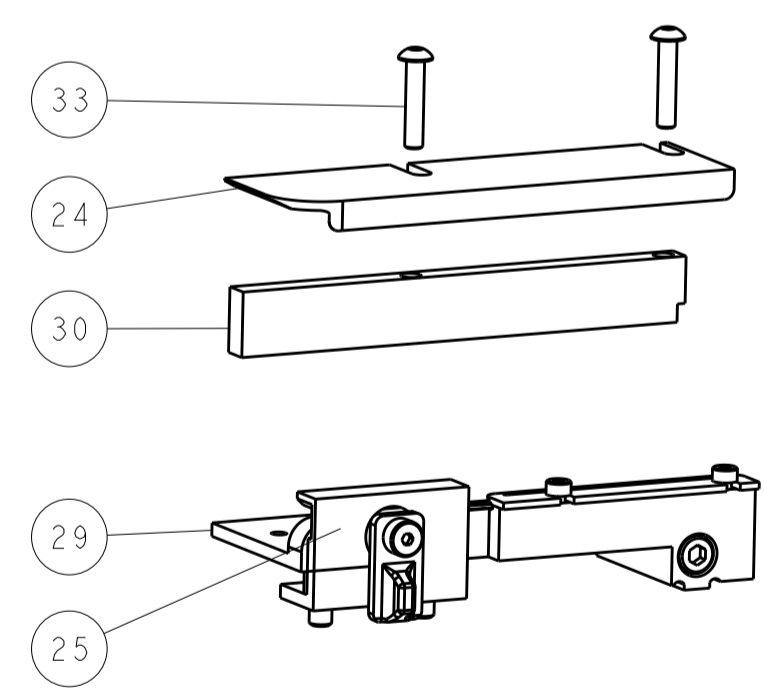
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT FRONT HOLES

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:		DWN: STAKEM 09AUG2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD: G. RALBY 09AUG2014		NAME: Ocean Side Feed Applicator	
				PRODUCT SPEC:		RESTRICTED TO:	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				WEIGHT:		A1 00779 ©=2266460	
				Customer Accessible Production Drawing		SCALE: 1:2 SHEET 2 OF 4 REV C	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266460-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266460-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266460-4	-	-	-
	2-2266460-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266460-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266460-4	-	-	-
	2-2266460-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2266460-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266460-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.16 mm [.085]	F
INSUL	2.55 mm [.100]	OV
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: 1.5 SYSTEM CONNECTOR	
WIRE STRIP LENGTH 5.00-5.50 mm [1.97-.217 IN]	INSULATION DIAMETER RANGE Ø1.90-2.40 mm [.075-.094 IN]
TERMINAL APPLICATION SPECIFICATION YPES 72-WT10-1622 Rev WA2146	-
TERMINALS APPLIED	
TE TERMINAL	YAZAKI TERMINAL
1572465-1	7116-4104-02

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm ²	1.35 +/- 0.05 [0.053 +/- .002]	6.4
1.25mm ²	1.30 +/- 0.05 [0.051 +/- .002]	7.0
1.00mm ²	1.25 +/- 0.05 [0.049 +/- .002]	7.6
0.5mm ² + 0.5mm ²	1.15 +/- 0.05 [0.045 +/- .002]	8.8

- 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: 8-2266460-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266460-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266460-5
- 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.
- 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.

***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)

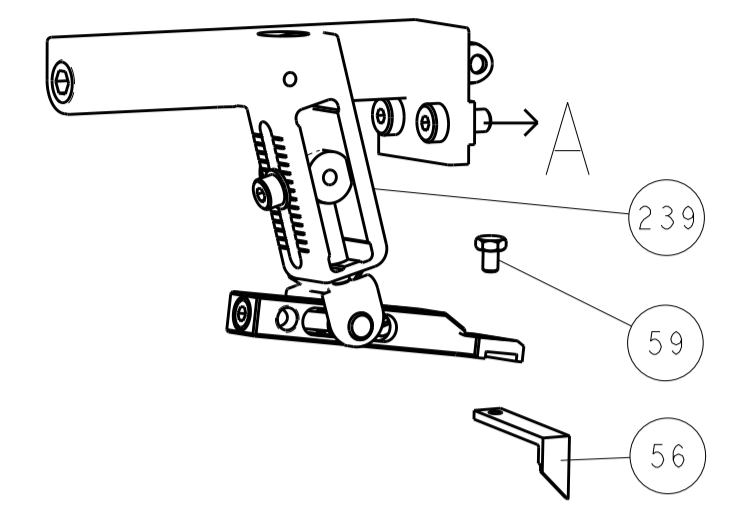
SET UP GAUGE	LOC	DIST	REVISIONS					
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			-	-	SEE SHEET 1	-	-	-

-	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	2119082-4	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	
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	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	1	1338683-8	FEED PAWL	56	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2	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	3-1752356-4	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	2119959-4	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	240792-2	DRAG, TERMINAL	25	
-	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	454276-5	FLOATING SHEAR, FRONT	9	
-	1	1	1	1	1-1803055-7	ANVIL, COMBINATION	8	
-	1	1	1	1	240641-4	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	4-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	1	1	1	1-1803221-4	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	-	-	-	-	-	-	2	
-	1	1	1	1	1-1803179-0	CRIMPER, WIRE PREMIUM	1	
-	77	27	25	22	21	PART NO	DESCRIPTION	ITEM NO

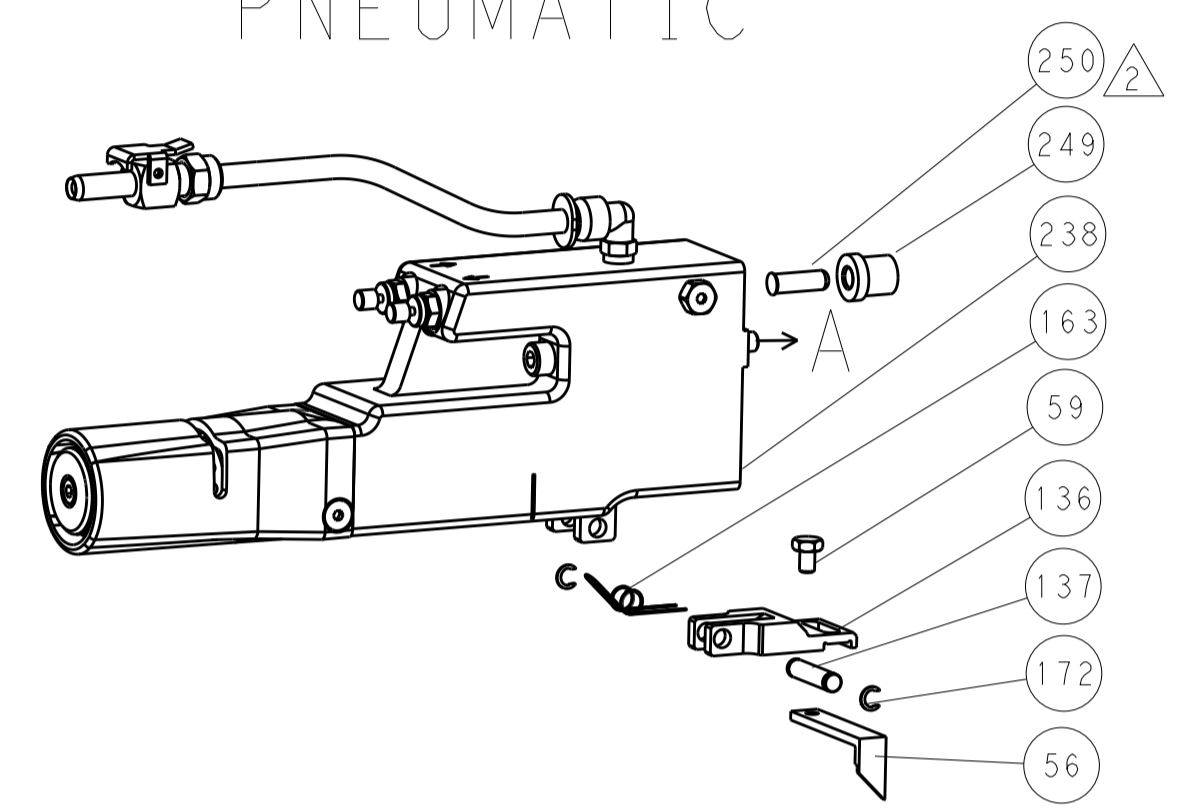
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE	1:2	SHEET	3	OF	4	REV	C

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

FEED TYPE MECHANICAL



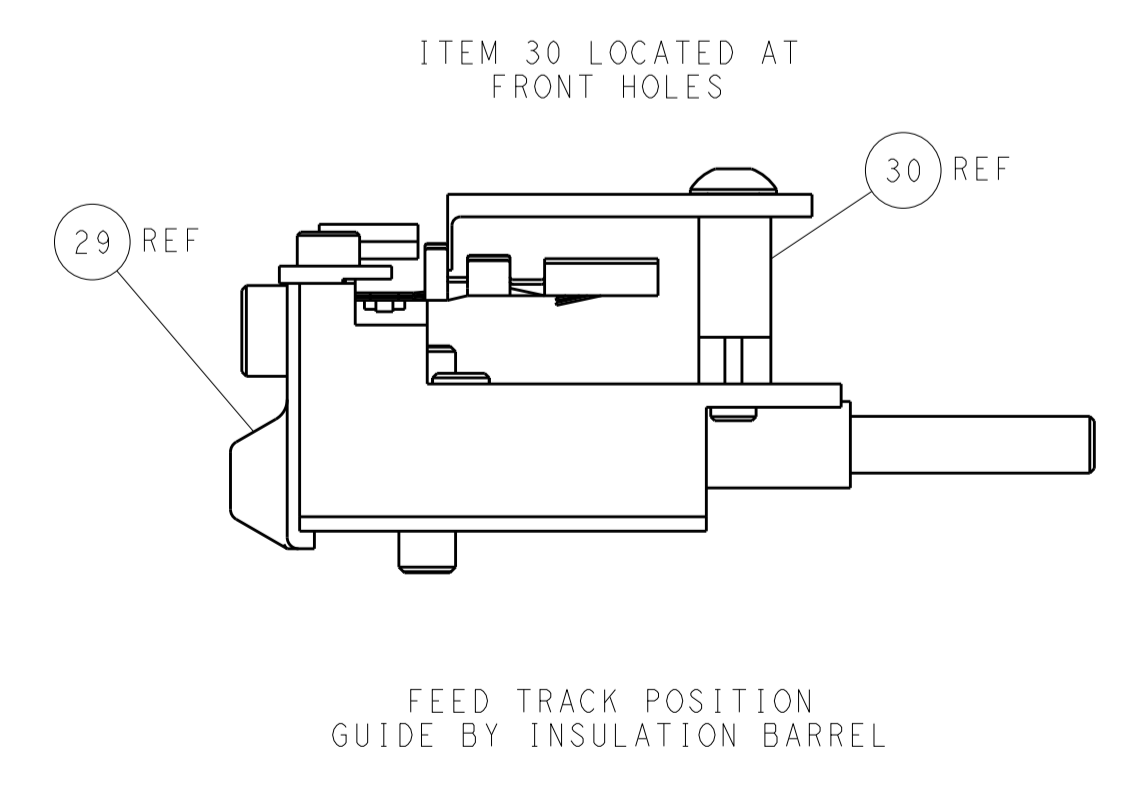
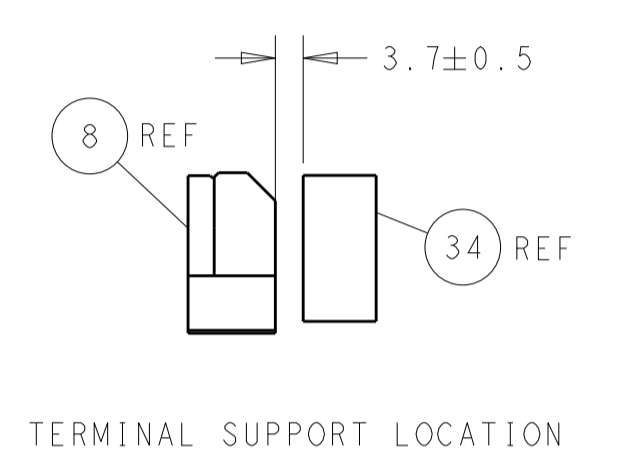
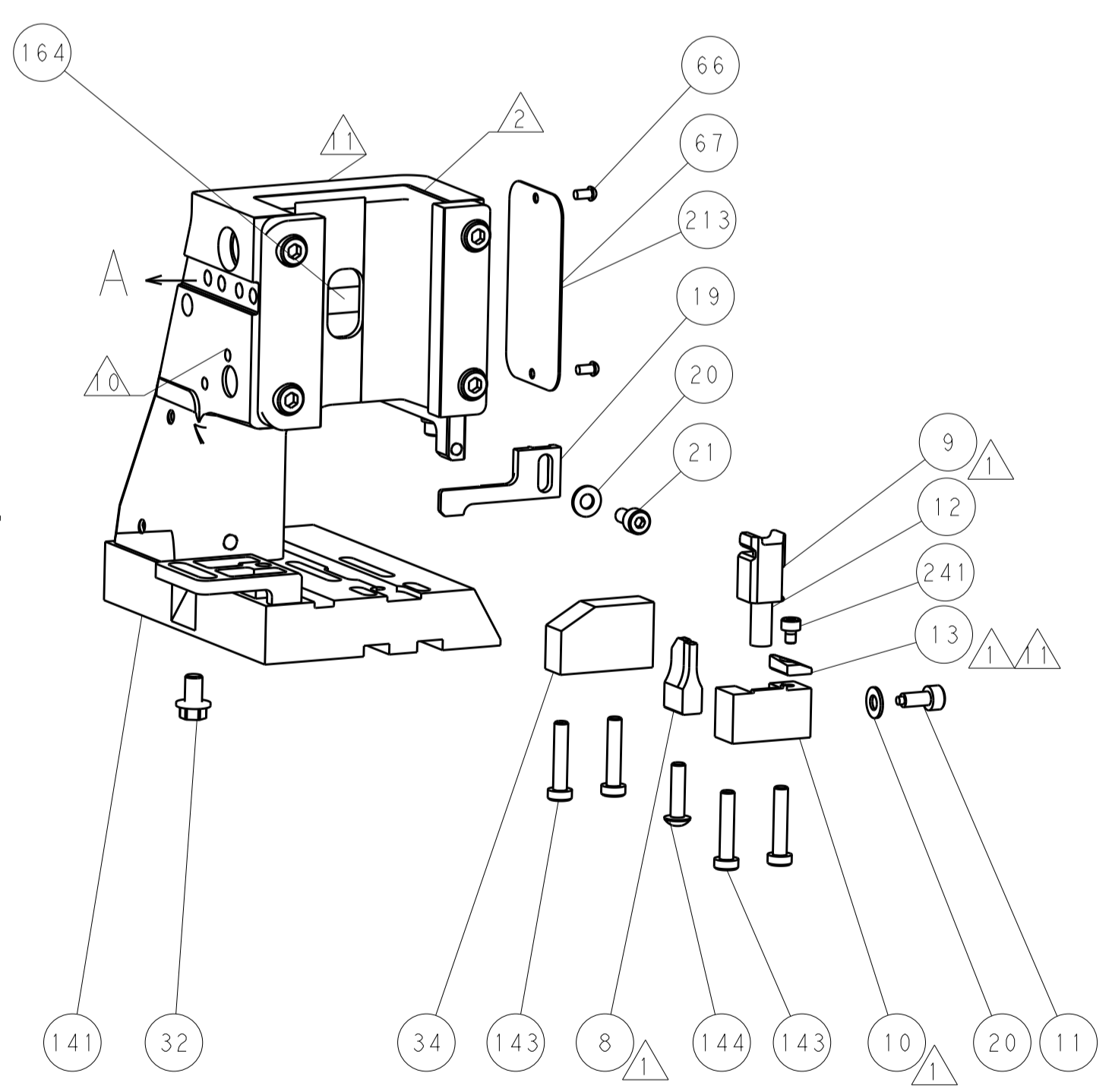
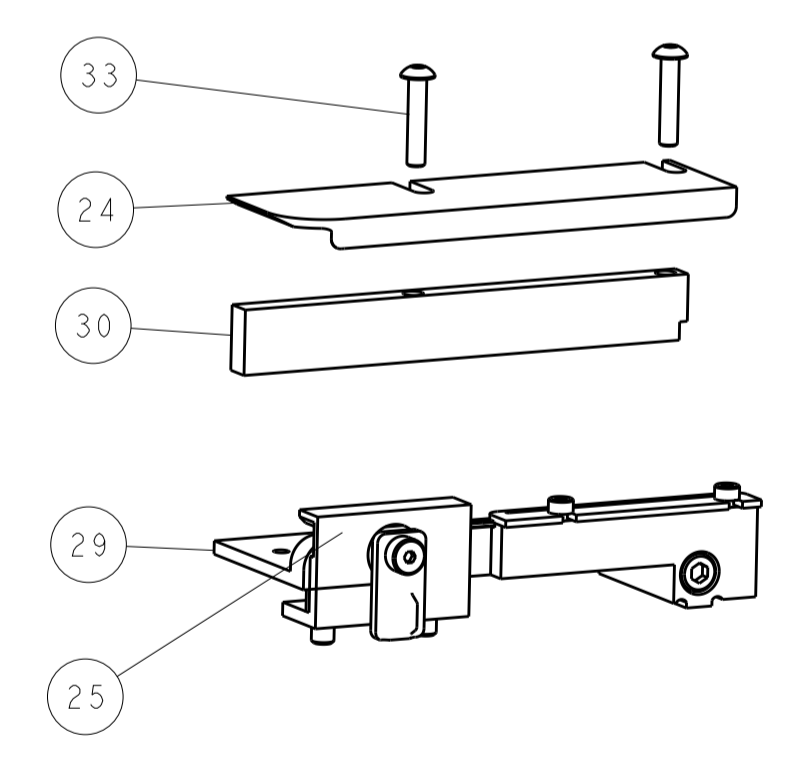
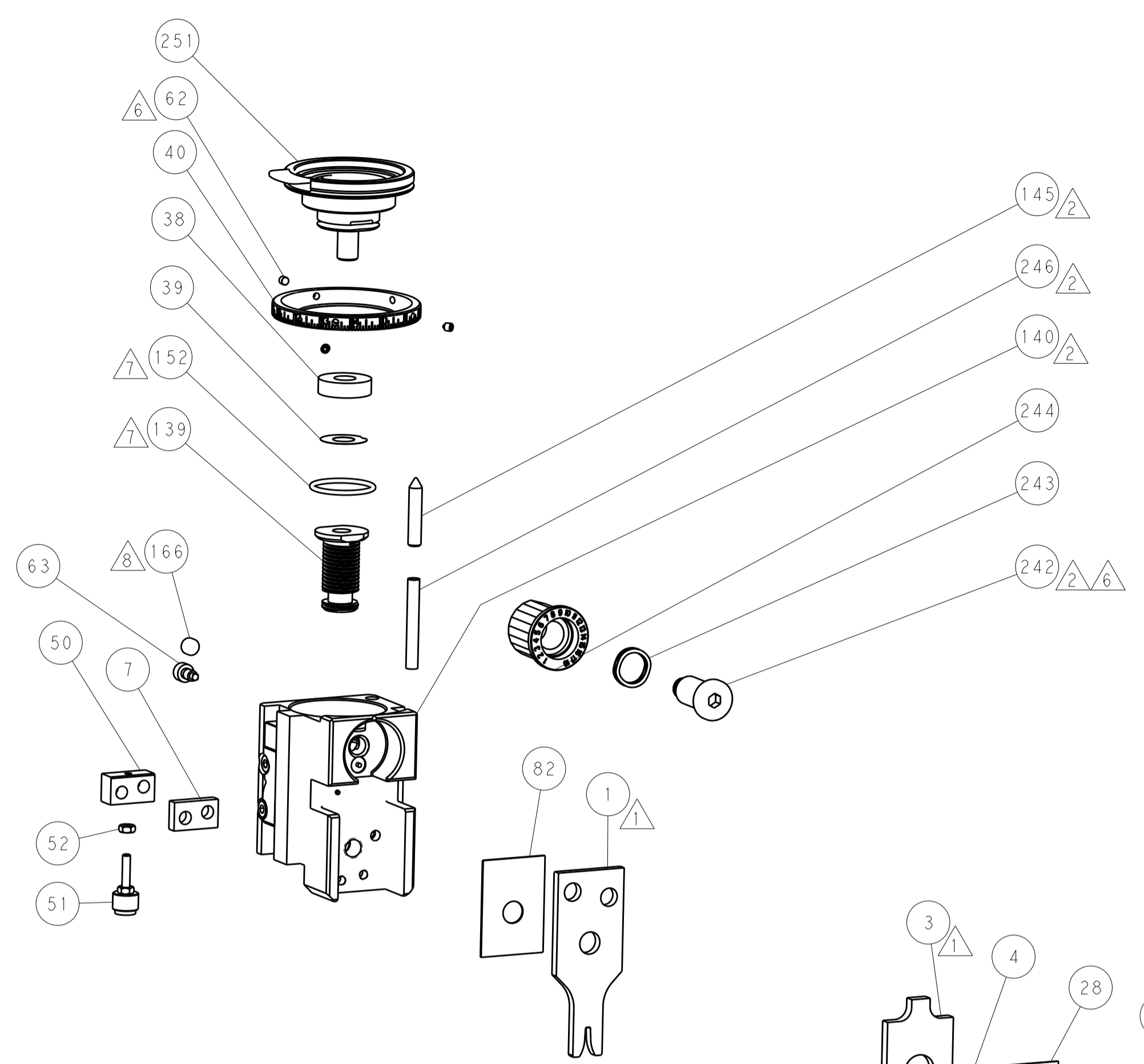
PNEUMATIC



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: R. STAKEM 09AUG2014 CHK: T. ELBIN 09AUG2014 APVD: G. RALLEY 09AUG2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266460 SCALE: 1:2 SHEET: 4 of 4 REV: C	
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