

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2266396-1	A	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	-	8-2266396-5	1901094-3	455053-2	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266396-4	-	-	-
	2266396-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266396-5	1901094-3	455053-2	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266396-4	-	-	-
	2266396-5	A	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
	2266396-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
	2266396-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266396-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	-	-
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN CONTACT, HEADER, 0.64 mm CONNECTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	\emptyset
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
638550-7	1-638550-0		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
N/A	N/A	5.0

- 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: 8-2266396-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266396-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266396-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266396-6
- 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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.53.
- CUT TO LENGTH AT ASSEMBLY.

***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	1	23238-1	INSERT, COUPLING	278
-	1	1	1	1	1	2030758-3	TUBING, POLYURETHANE	277
-	1	1	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	276
-	1	1	1	1	1	986220-3	CLAMP, CABLE, BLACK	275
-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)

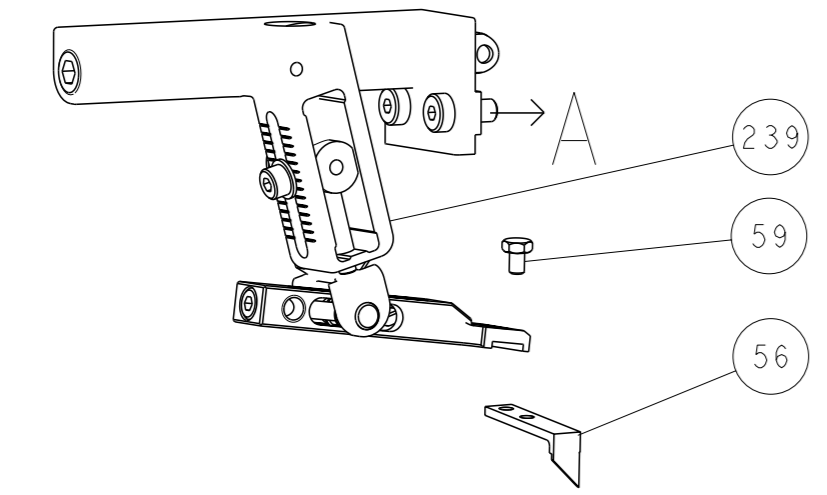
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	OWN	APPV
			A	RELEASED	160CT2014	LG GB

-	1	1	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	274
-	1	1	1	1	1	2217068-1	BRACKET, AIR BLAST	273
-	4	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1	1	1633782-8	FENCE	268
-	1	1	1	1	1	1633782-9	FENCE	267
-	1	1	1	1	1	3-853720-5	BLADE, SLUG	264
-	1	1	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	263
-	1	1	1	1	1	1803182-1	PLATE, REAR SHEAR	262
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	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	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	-	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
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	1-690438-9	FRONT STRIP GUIDE	96
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	1803183-1	SHOOT, LOOSE PIECE	89
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	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
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	1	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
-	-	-	-	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	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	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	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	2	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1-1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	6-690754-7	DRAG, SPECIAL	25
-	1	1	1	1	1	1-1320928-8	STRIP GUIDE	24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	5	5	5	5	5	1-18028-2	WASHER, FLAT, REG M4	20
-	-	-	-	-	-	-	-	10
-	-	-	-	-	-	-	-	9
-	1	1	1	1	1	1803181-1	ANVIL, WIRE	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	-	-	-	-	-	-	-	5
-	-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	-	2
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

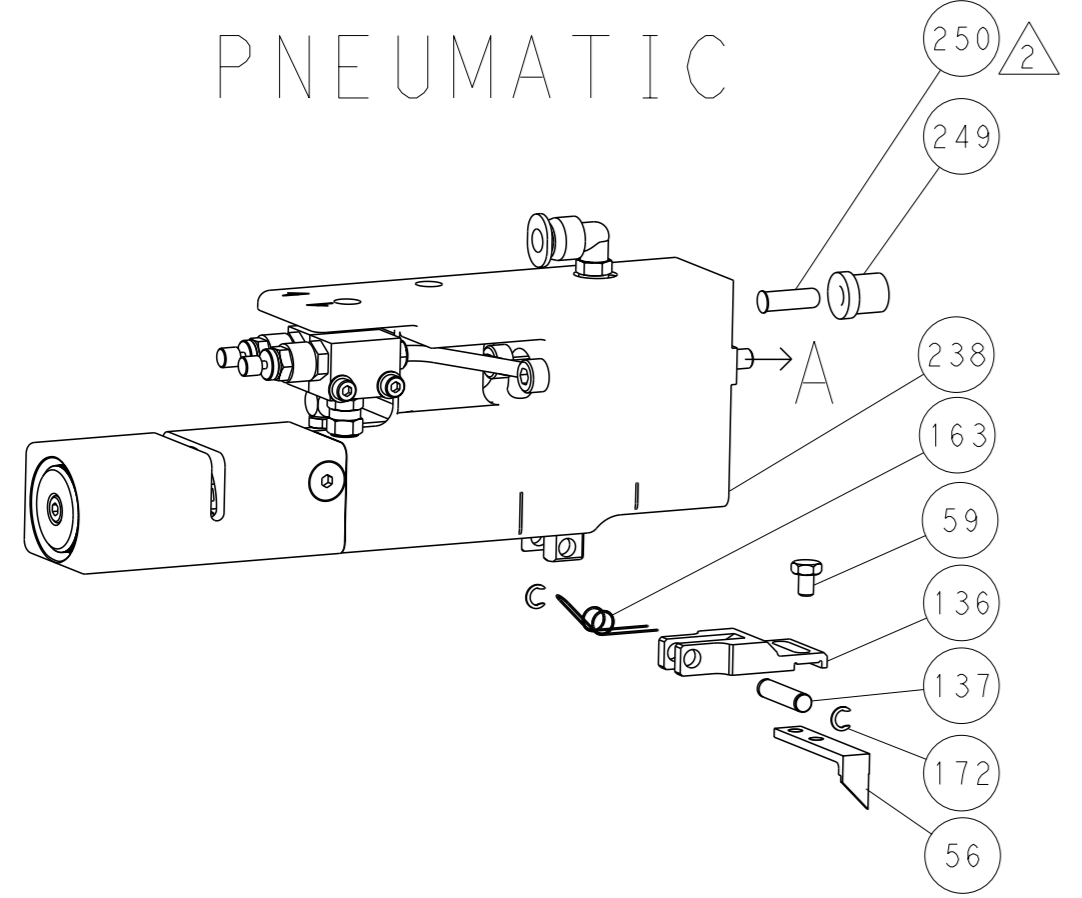
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mm	0 PLC ± .1 1 PLC ± .15 2 PLC ± .2 3 PLC ± .3 4 PLC ± .4 ANGLES ± .0001 FINISH	1.1. GROSS	18 JUL 2014	TE Connectivity Harrisburg, PA 17105-3608	
		1.1. ELBIN	18 JUL 2014	NAME Ocean Side Feed Loose Piece Applicator	
MATERIAL		1.1. STOUGH	18 JUL 2014	SIZE CASE CODE DRAWING NO RESTRICTED TO	
		PRODUCT SPEC		A1 00779 ©=2266396	
		APPLICATION SPEC		Customer Accessible Production Drawing SCALE 1:2 SHEET 1 of 4 REV A	

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

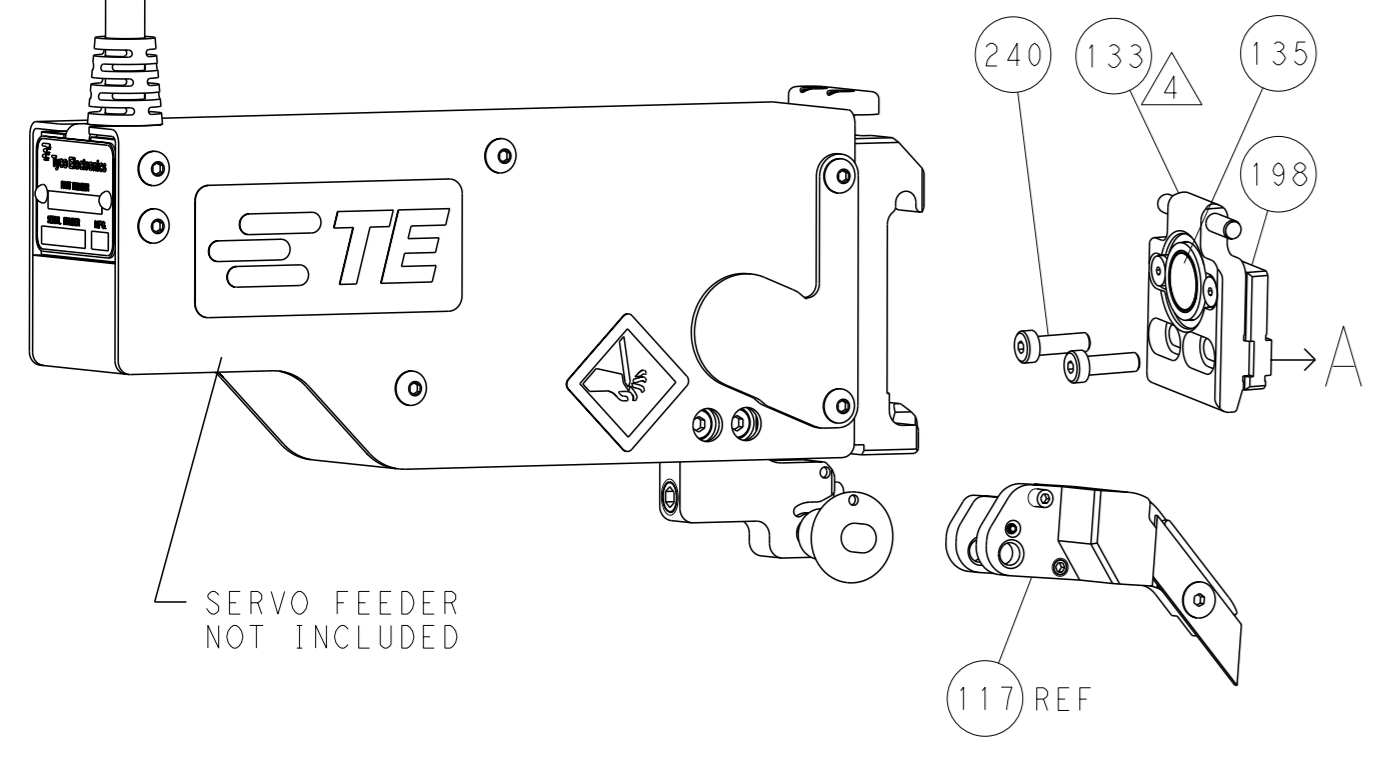
FEED TYPE MECHANICAL



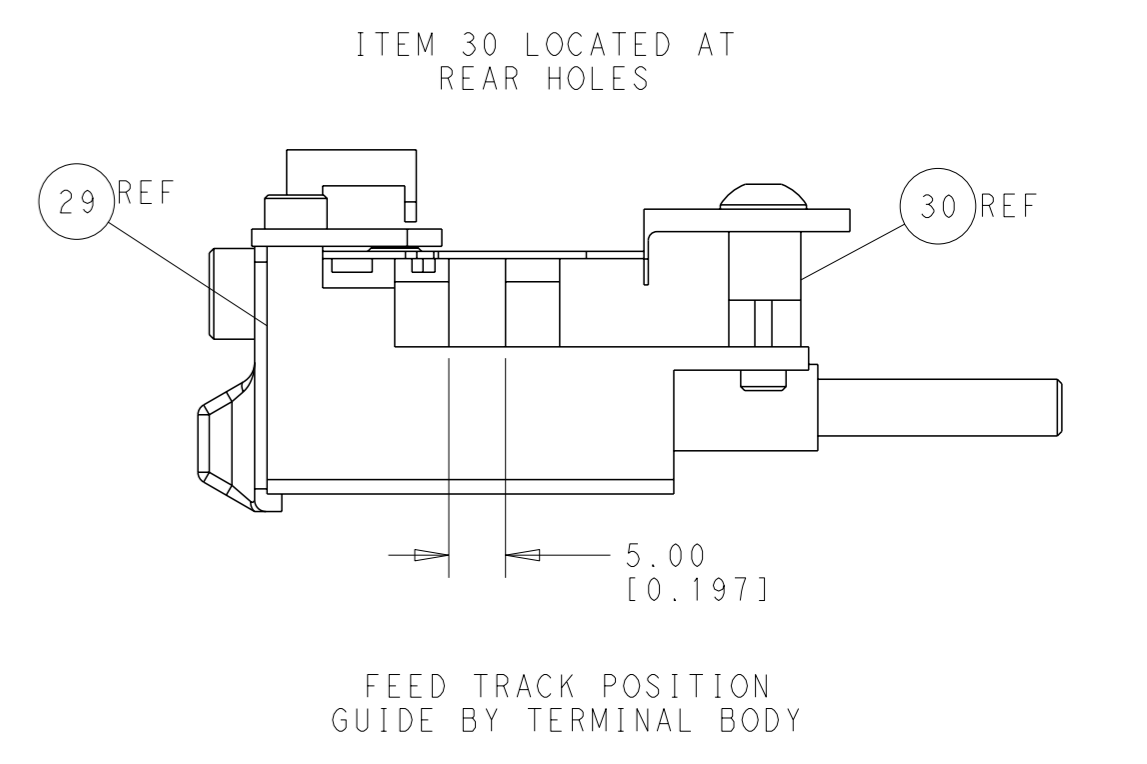
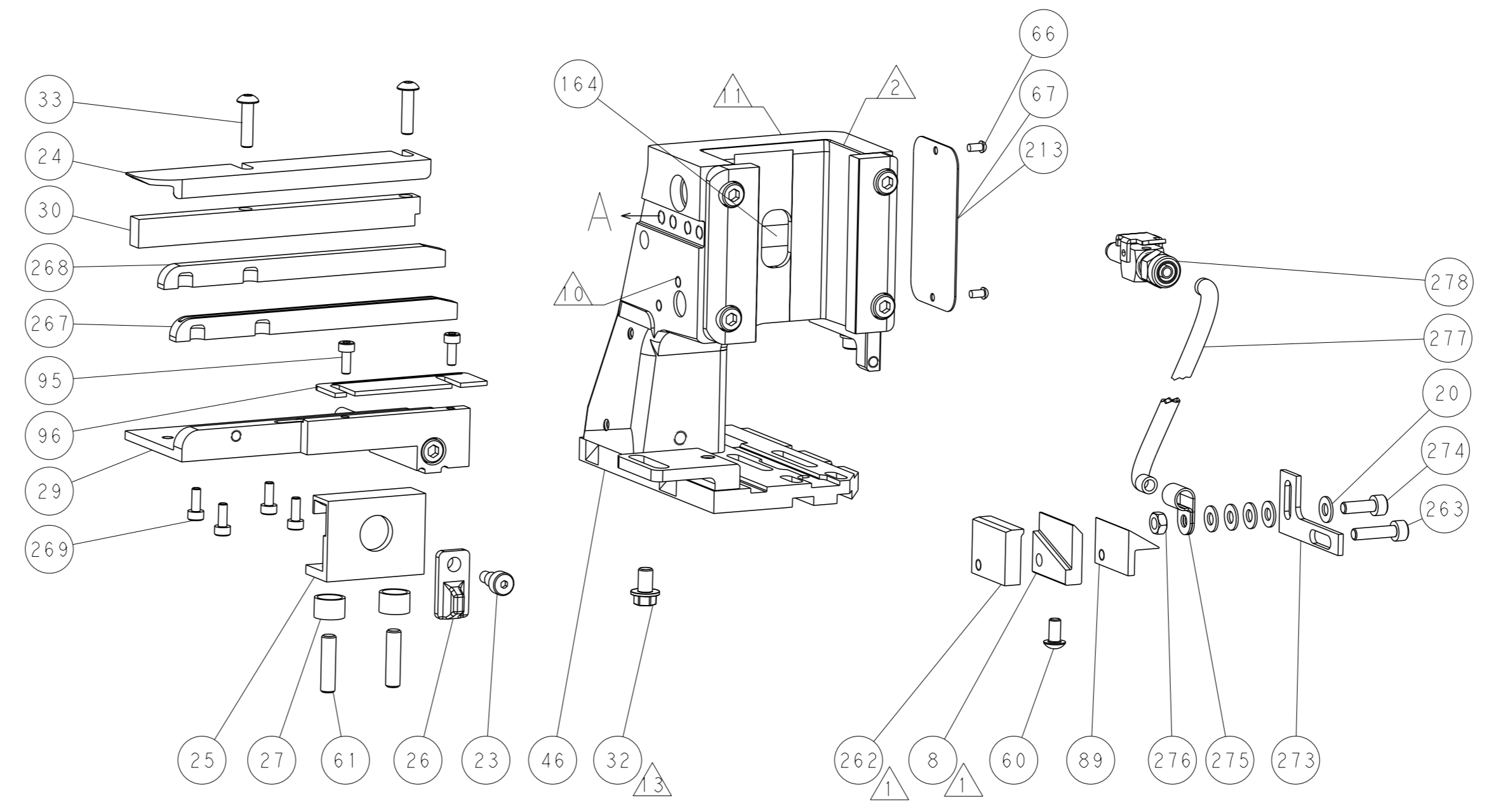
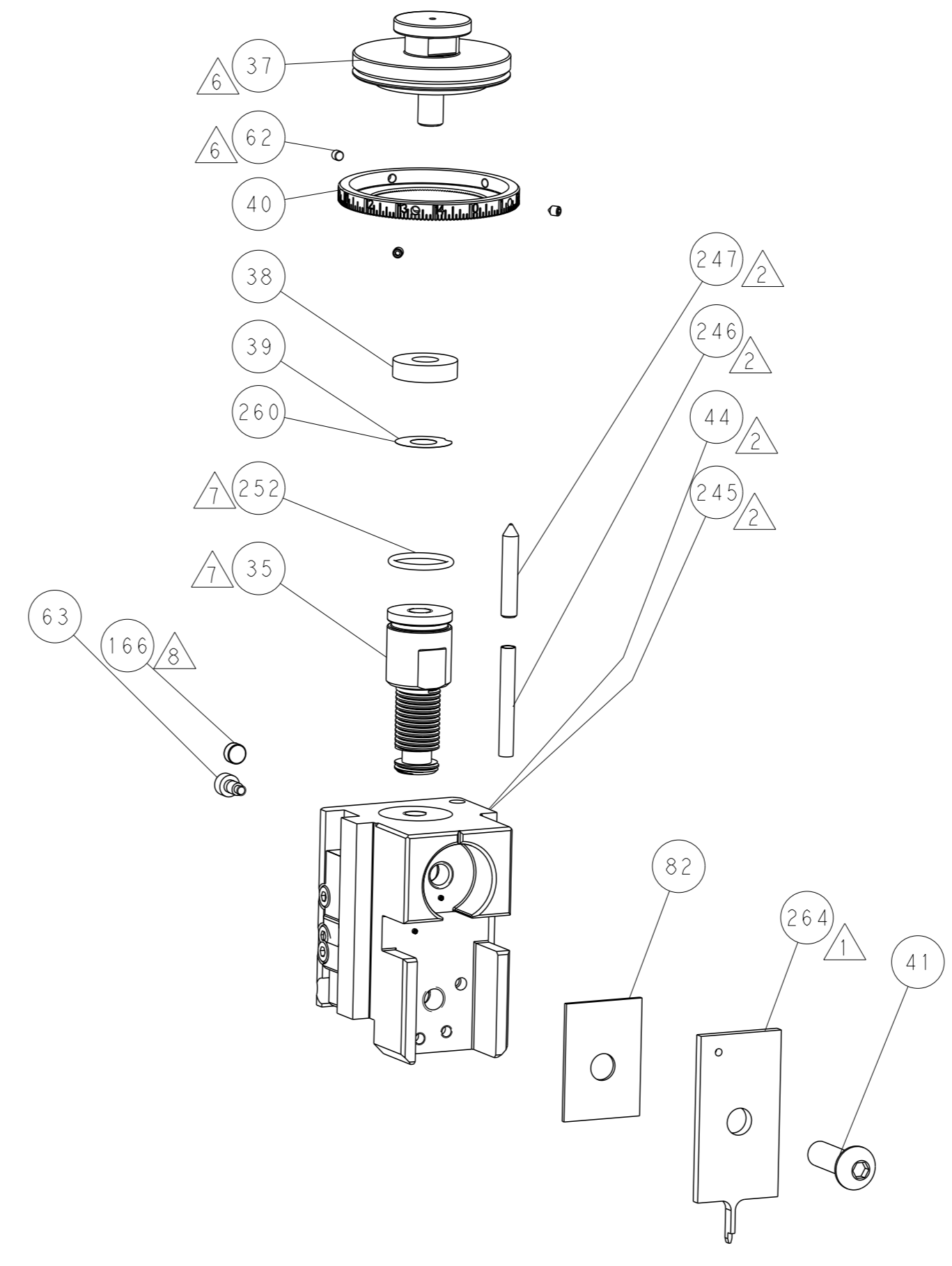
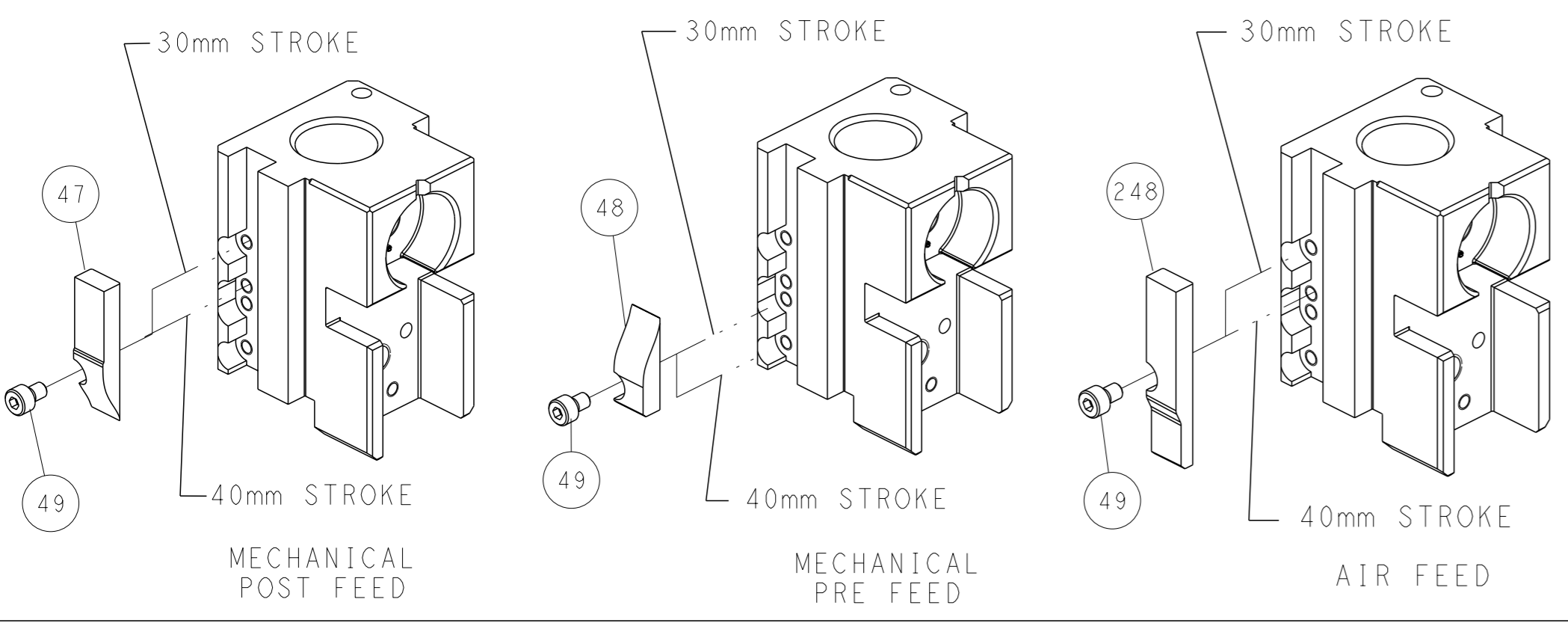
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS

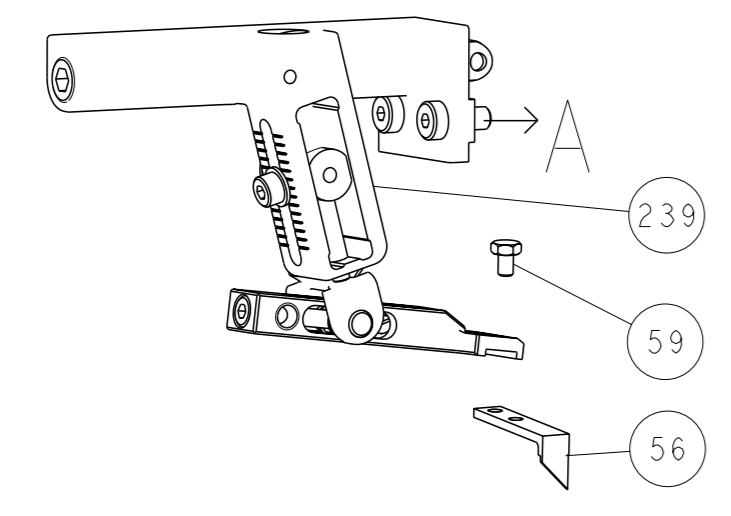


ATLANTIC VERSION
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 (Pacific version shown on sheets 3 of 4 & 4 of 4)

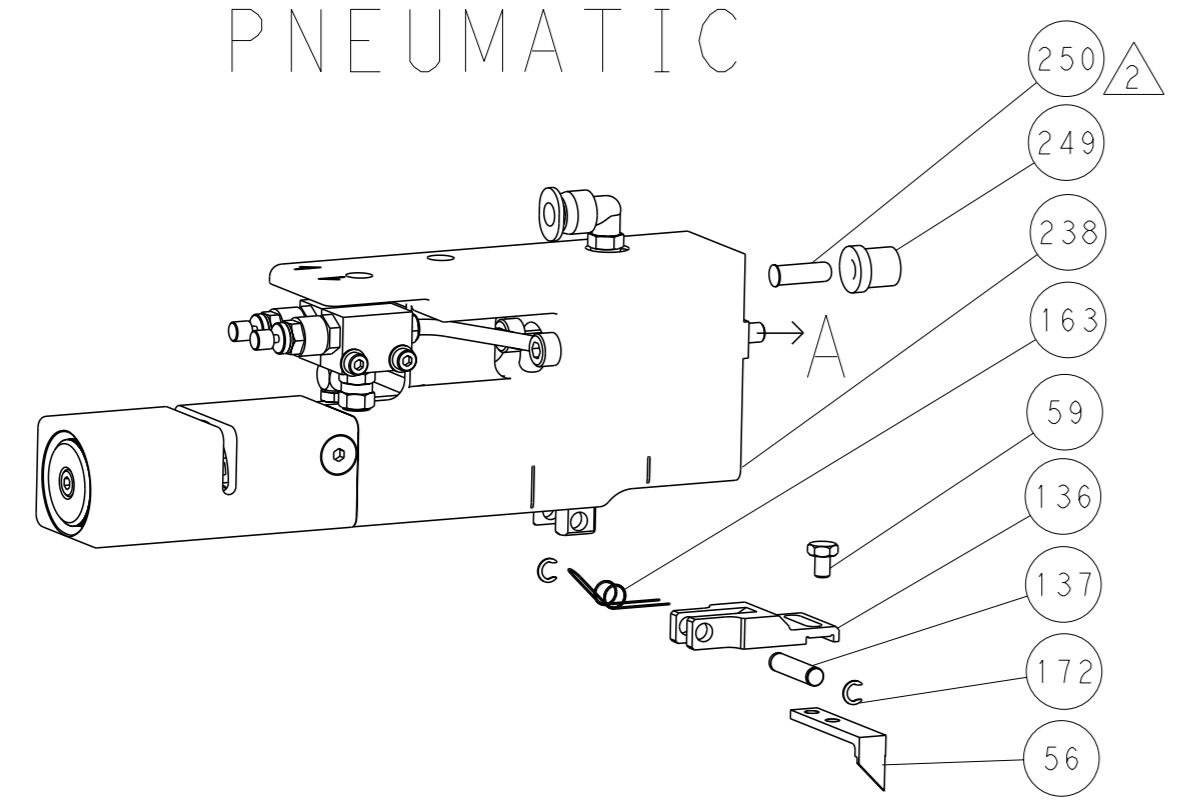
<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN L. GROSS 18JUL2014 CHK T. ELBIN 18JUL2014 APVD D. STOUGH 18JUL2014	NAME Ocean Side Feed Loose Piece Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2266396 RESTRICTED TO -
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1	MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:2	SHEET 2 OF 4 REV A Customer Accessible Production Drawing

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

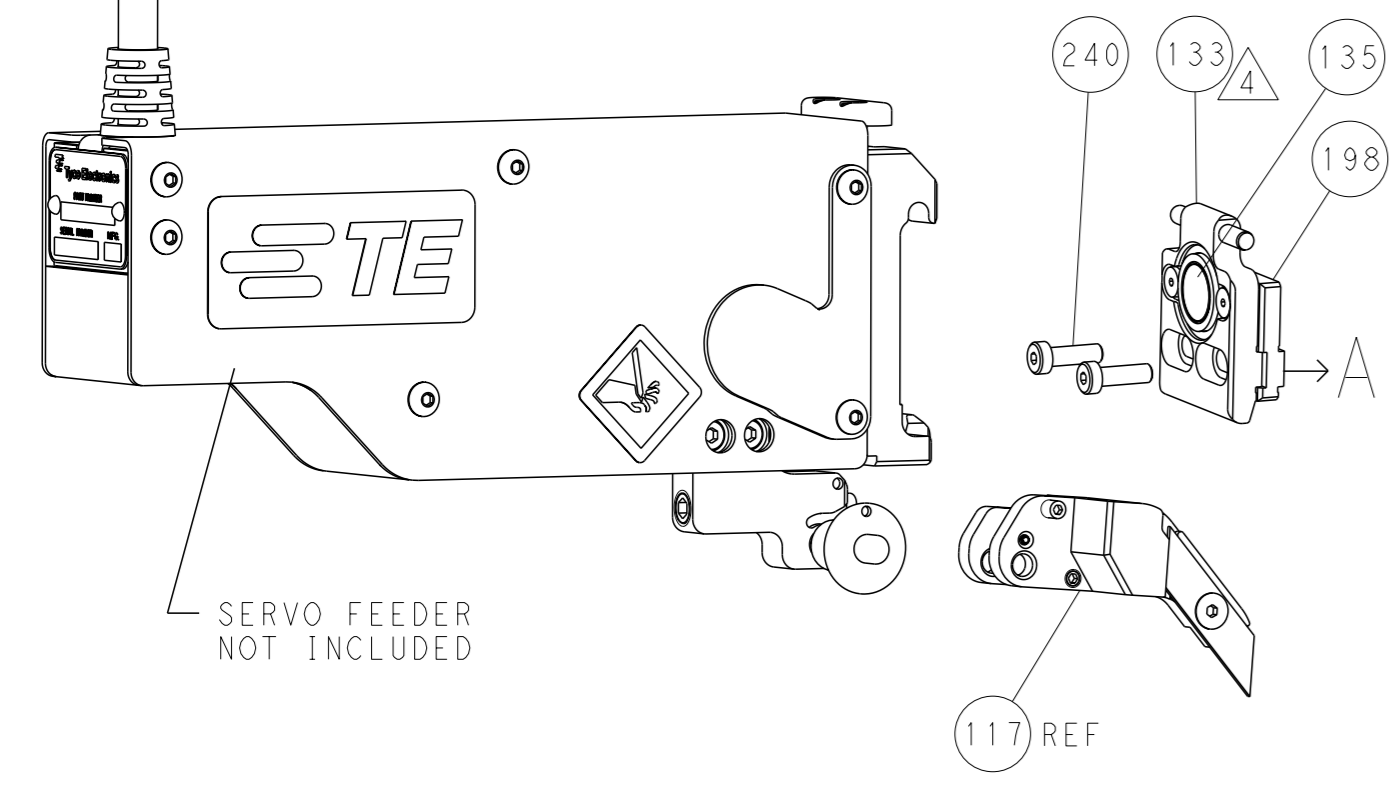
FEED TYPE MECHANICAL



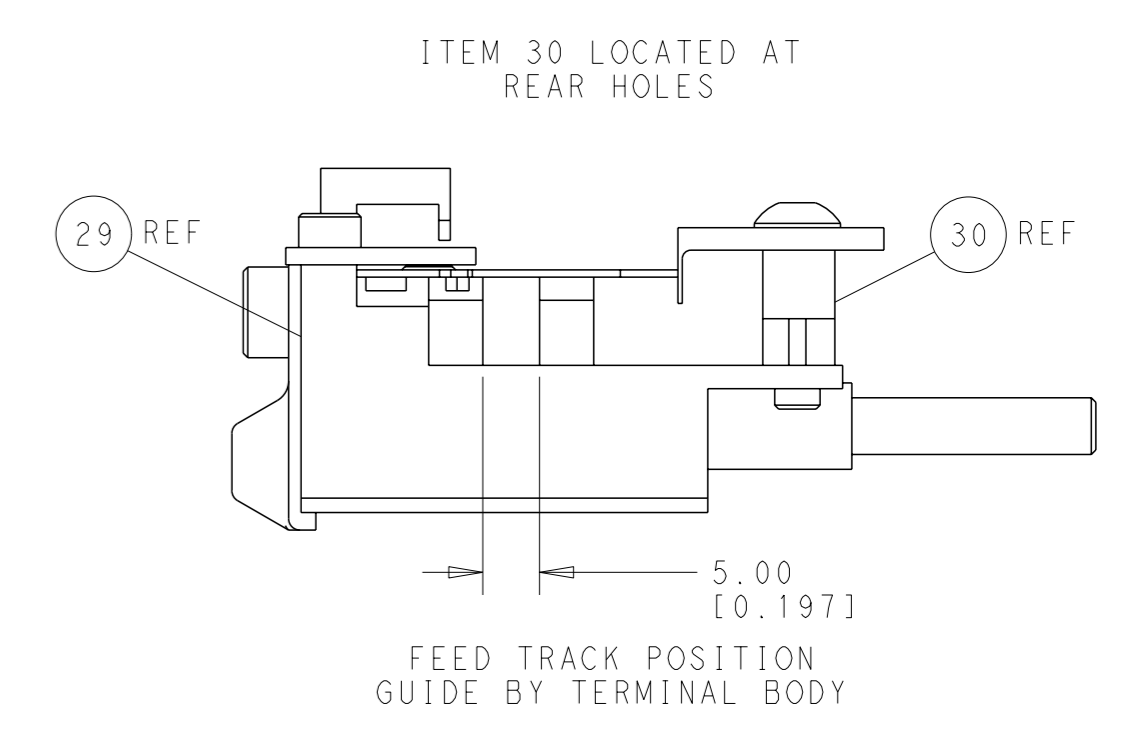
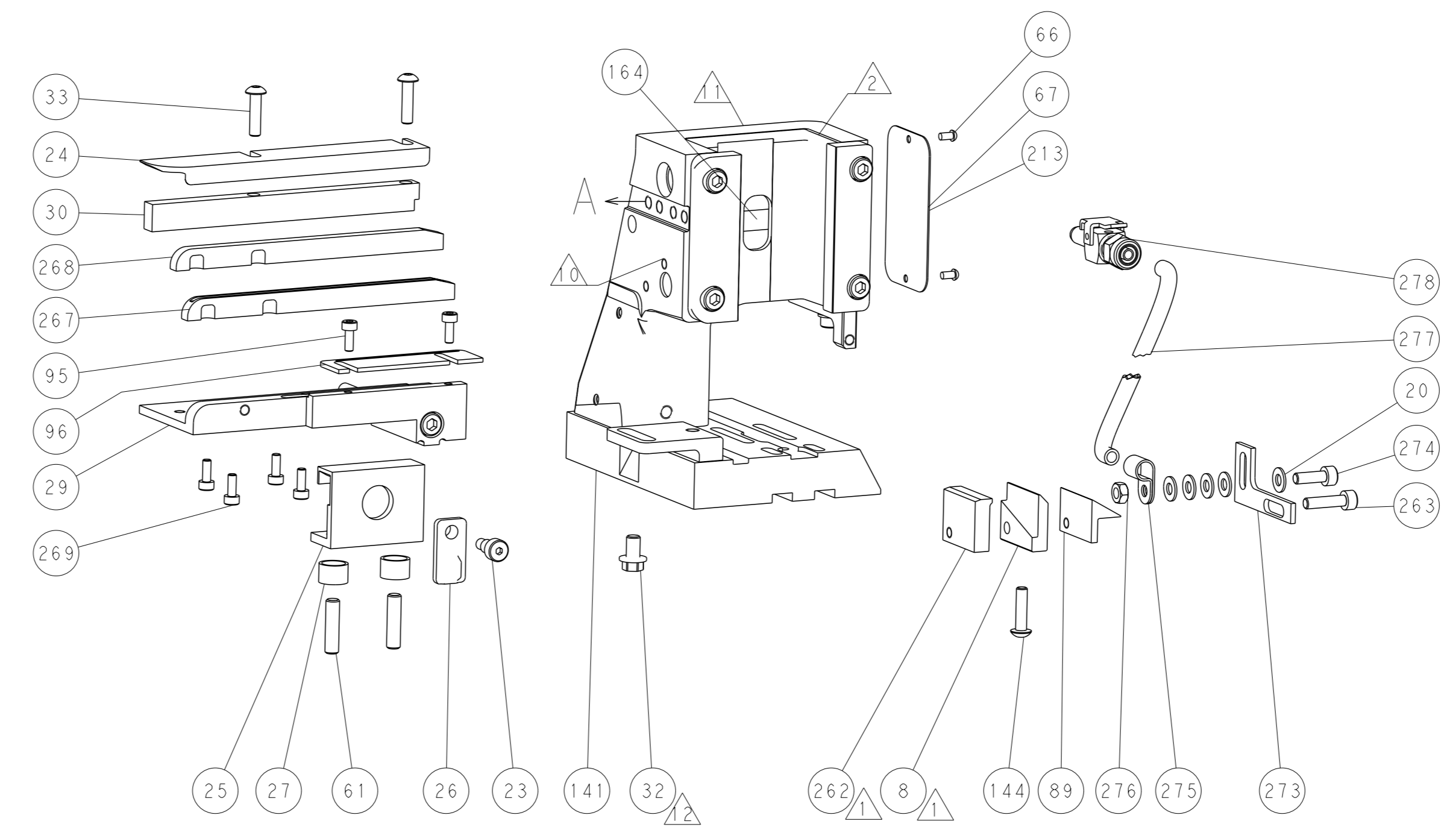
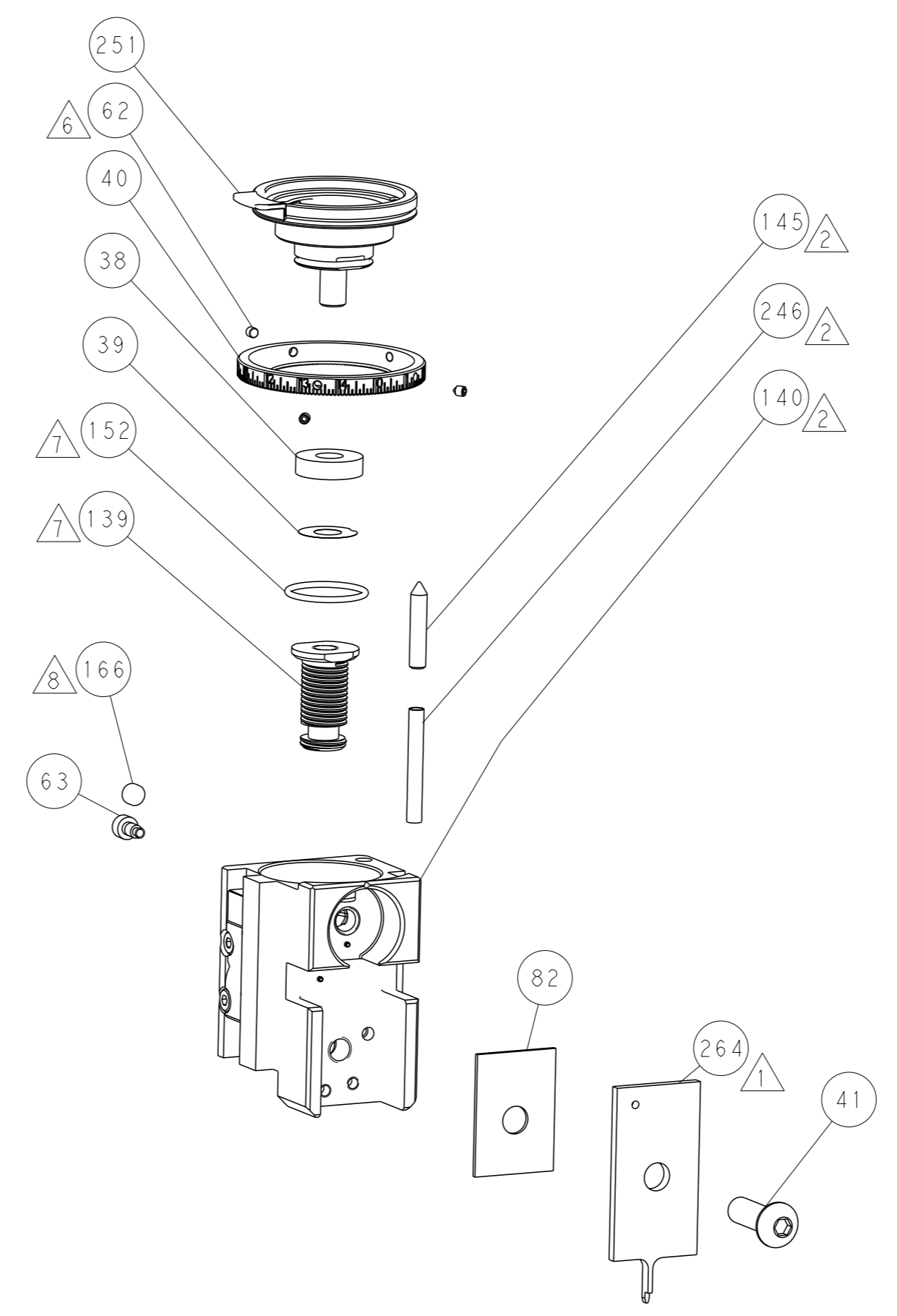
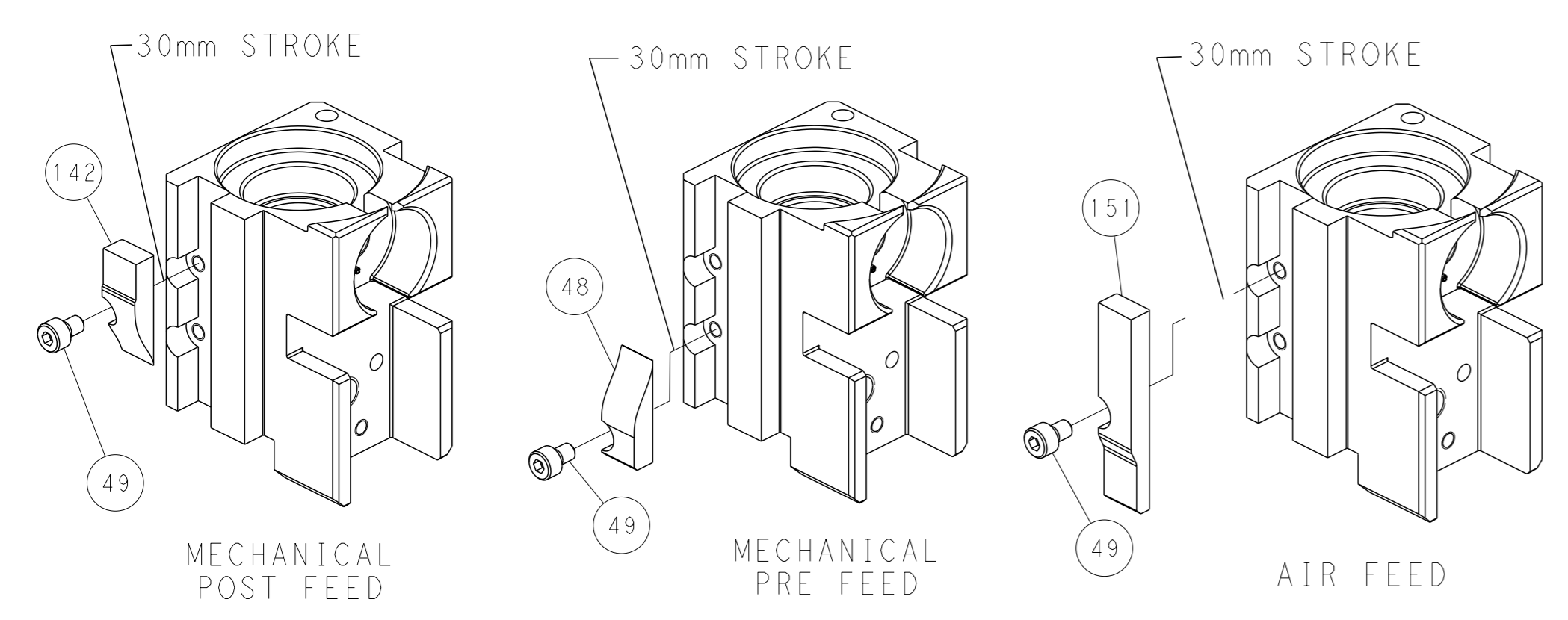
PNEUMATIC



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±.	APPLICATION SPEC: - MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266396 RESTRICTED TO: -
Customer Accessible Production Drawing		SCALE: 1:2	SHEET 4 of 4 REV A