

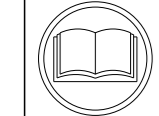
Table with columns: ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE. Includes a drawing of the terminator interface adapter.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes WIRE and INSUL values.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION table with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION.

TERMINALS APPLIED table with columns: TE TERMINAL, TE CRIMP SPECIFICATION.

WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.



- 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: 8-2266674-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266674-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266674-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266674-6
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 & 180.
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.
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 5.02.
13. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION table with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION.

TERMINALS APPLIED table with columns: TE TERMINAL, TE CRIMP SPECIFICATION.

WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

\*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various components like APPLICATOR SHIM PACK, O-RING, PUSH ROD, AIR FEED, BUSHING, MISUMI, FEED CAM, DETENT PIN.

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

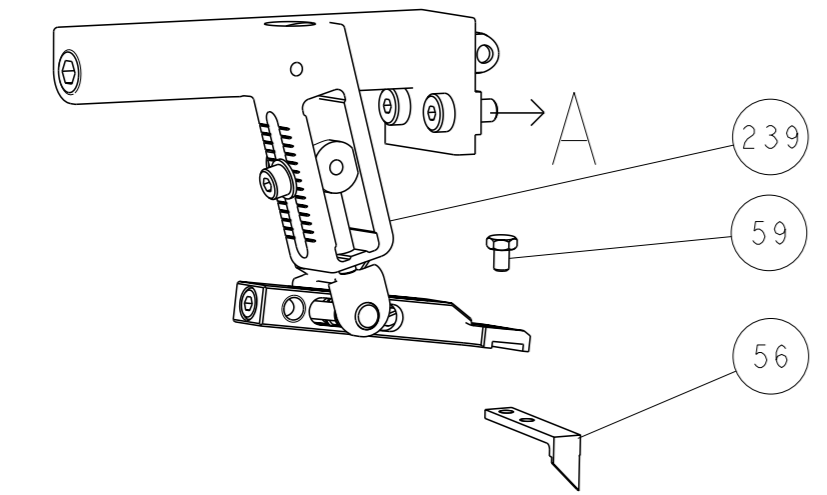
REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, OWN, APVD. Shows revisions from ORIGINAL to ECR-18-008334.

Main parts list table with columns: QTY, PART NO, DESCRIPTION, ITEM NO. Lists numerous components like SPRING, RAM, CAM, WASHER, RETAINER, SCR, SHCS, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, TAG, IDENTIFICATION, SPACER, FEEDER, STRIPPER, NUT, STANDOFF, PIN, GUIDE PIN, RING, MAGNET, COUNTER, FEED FINGER, HOLDER, MEMORY CHIP, SERVO FEED LATCH ASM, FEED FINGER ASSEMBLY, SPACER, CRIMPER, DOCUMENTATION PACKAGE, TAG, IDENTIFICATION, SCREW, DRIVE, RH, RoHS, LIMITER, SCR, SET, SOC, CONE PNT, FEED FINGER, SCREW, DRIVE, RH, RoHS, PAWL, FEED, SHCS, LOW HEAD, RoHS, SCR, SKT HD CAP, NUT, HEX, REG, RoHS, BUMPER, HOLD DOWN, SPACER, TONKER, SCR, SKT HD CAP, FEED CAM, FEED CAM, POST FEED, APPLICATOR BASIC ASSEMBLY, SF, RAM, AMP STYLE, SIDE FEED, SCR, BHSC, RoHS, DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, PRECISION, FA HEAD, ATLANTIC STYLE, BOLT, ADJUSTMENT, SUPPORT, TERMINAL, SCR, BHSC, RoHS, HEX HEAD, FLANGED, SPACER, STRIP GUIDE, ASSEMBLY, STRIP GUIDE, SPACER, CRIMPER, STRIP GUIDE, WASHER, FLAT, REG M4, INSERT, SHEAR, SPRING, COMPRESSION, STOP, SHEAR, SHEAR HOLDER, FRONT, FLOATING SHEAR, FRONT, ANVIL, COMBINATION, SPACER, DEPRESSOR, SHEAR, BLOCK, CRIMPER SPACER, CRIMPER, INSULATION F PREMIUM, SPACER, CRIMPER, CRIMPER, WIRE.

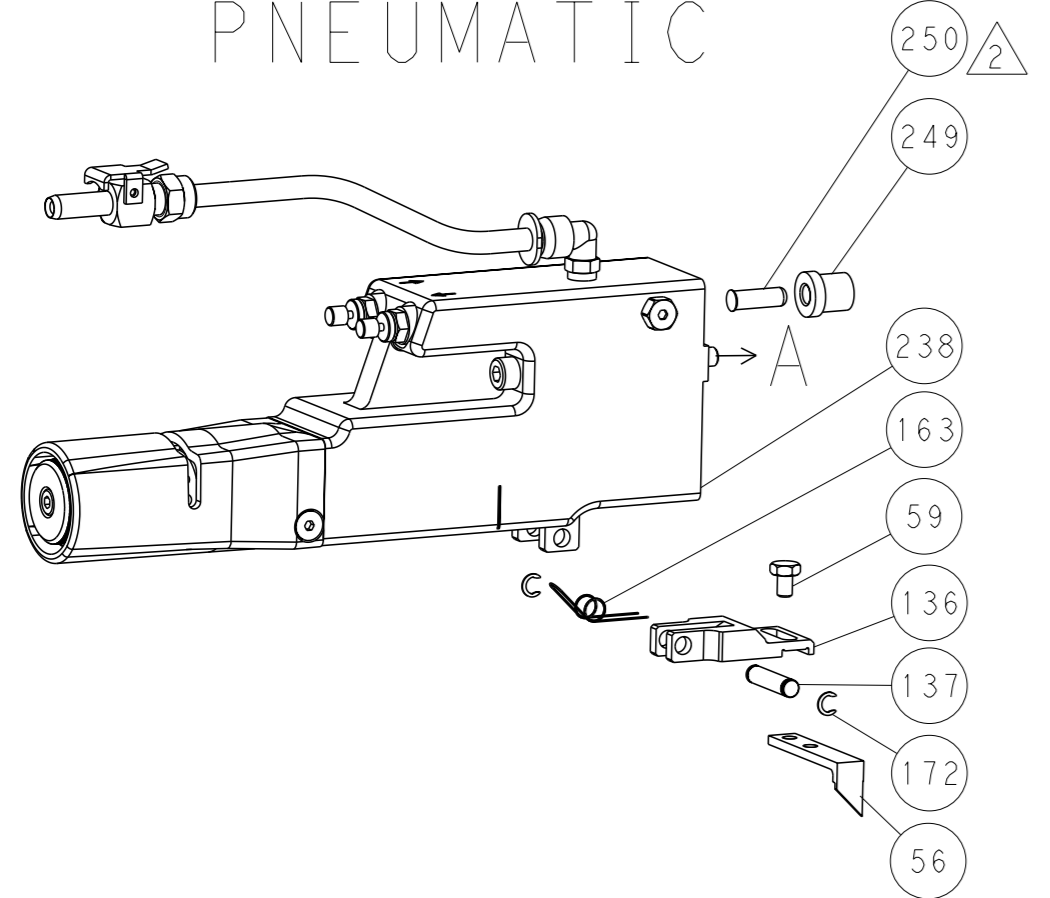
Technical drawing header area including DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, and customer information (OFFNER, T. ELBIN, 11FEB2015, Ocean Side Feed Applicator).

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

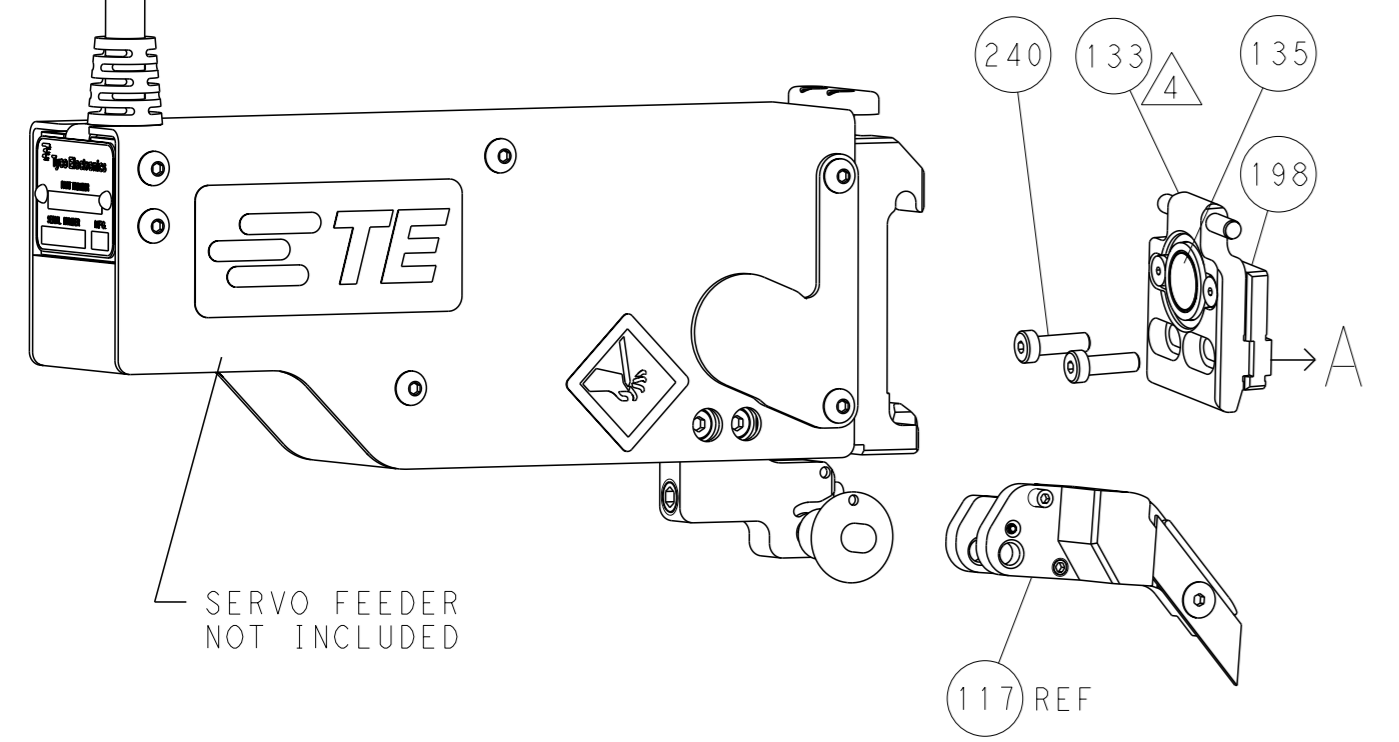
### FEED TYPE MECHANICAL



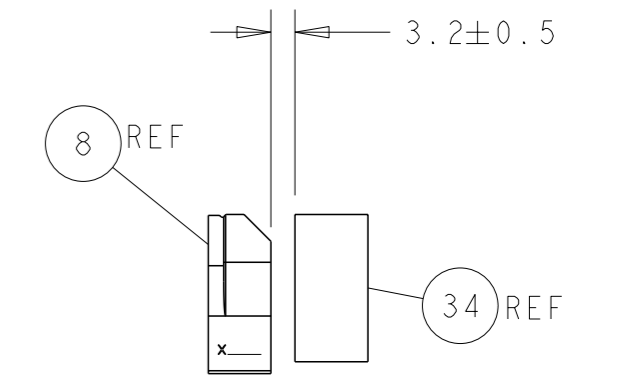
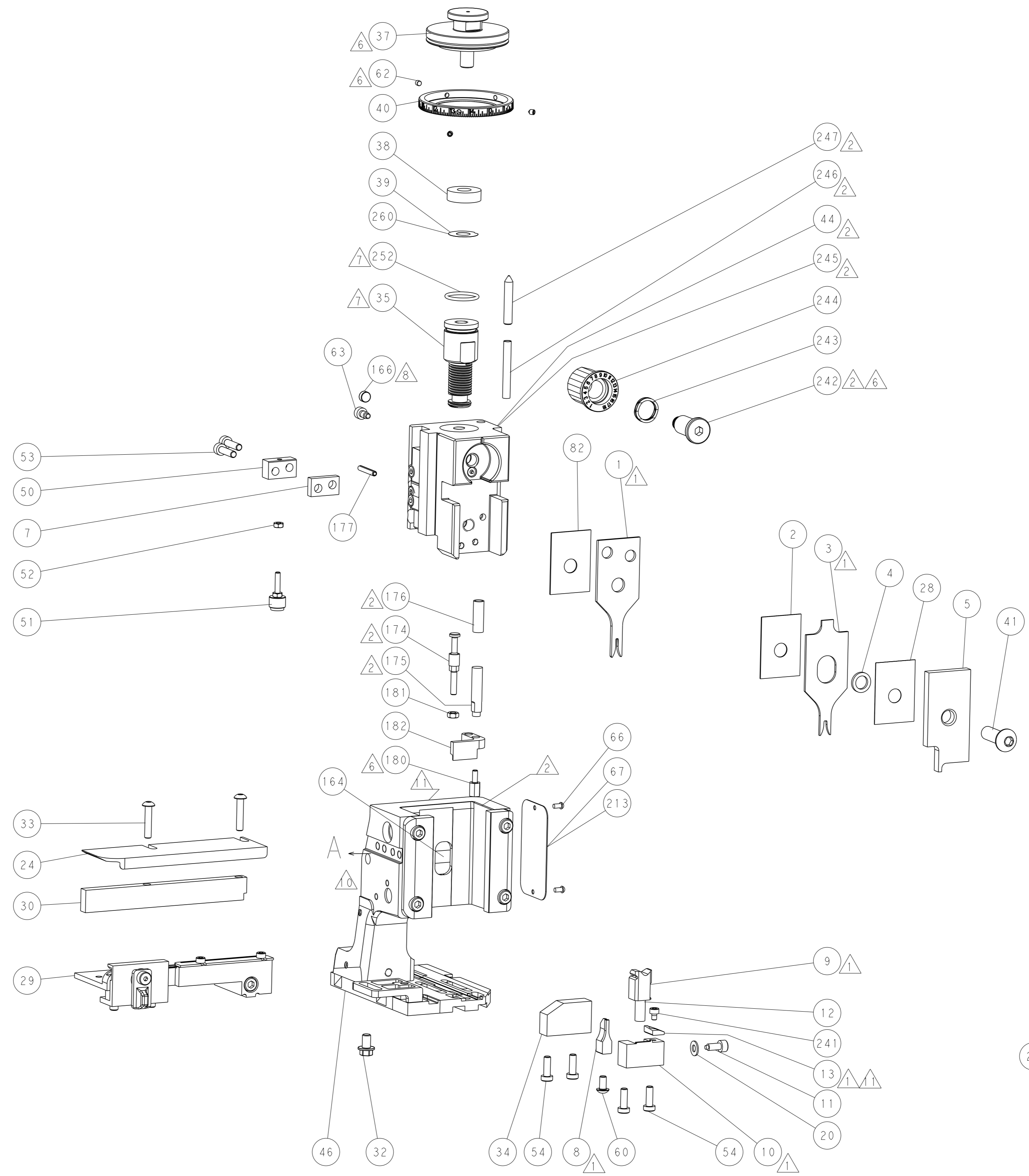
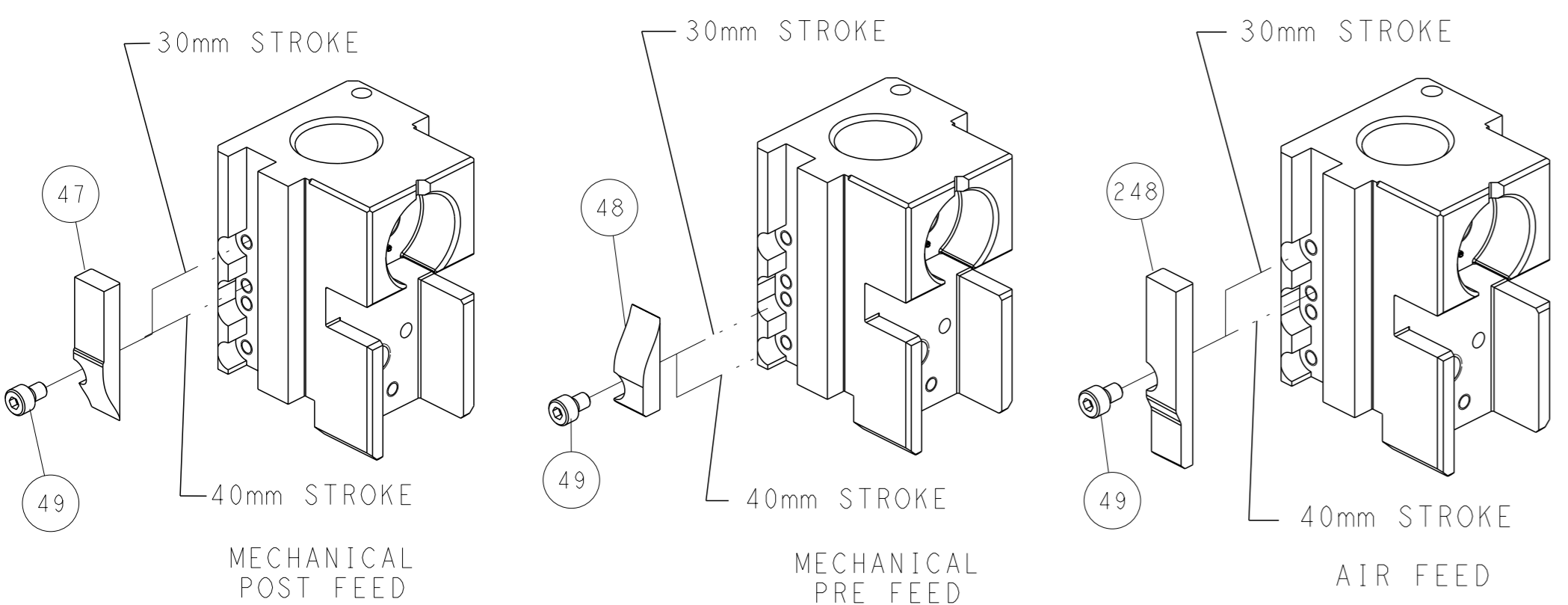
### PNEUMATIC



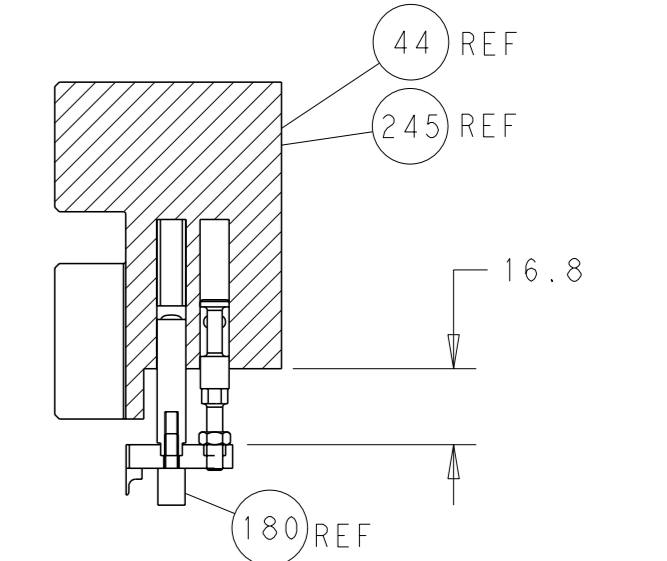
### SERVO LATCH PLATE



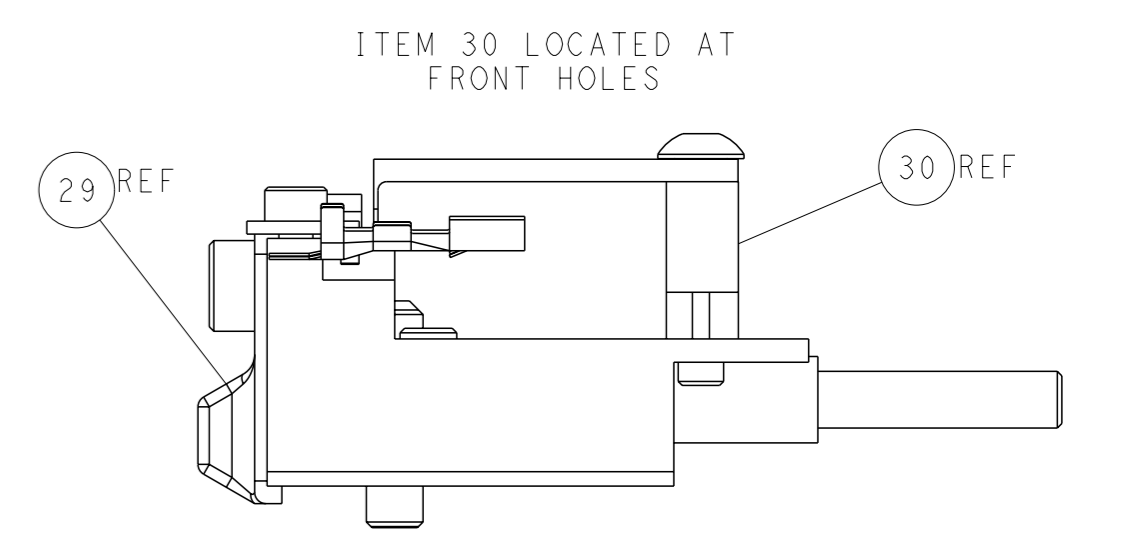
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: HOFFNER 10FEB2015	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±0.5	1 PLC ±0.13	2 PLC ±0.13	CHE: TELBIN 11FEB2015	
	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.001	APVD: TELBIN 11FEB2015	NAME: Ocean Side Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2	SHEET 2 of 4	RESTRICTED TO: A1 00779 ©=2266674
Customer Accessible Production Drawing				REV: A2	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
	2-2266674-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	OBSOLETE
	2-2266674-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	OBSOLETE
	2-2266674-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	OBSOLETE
	2-2266674-7	A	FINE CRIMP HEIGHT ADJUST	NONE	OBSOLETE
	7-2266674-7	A	CRIMP TOOLING KIT	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.22 mm [.048]	F
INSUL	2.03 mm [.080]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIV MATE-N-LOK PIN CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.70 mm [.126-.146 IN]		Ø1.20-1.75 mm [.047-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5050	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 170359-1	(A) 170359-2	(A) 170359-3	(A) 170359-4
(A) 170359-5	(A) 170361-1	(A) 170361-2	(A) 170361-3
(A) 170361-4	(A) 170361-7		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIV MATE-N-LOK PIN CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.70 mm [.126-.146 IN]		Ø1.20-1.75 mm [.047-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	(B)114-16017	(C)114-1111	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 770901-3	(B) 1-770901-0	(B) 770901-1	(B) 770901-2
(B) 770902-3	(B) 770902-4	(B) 770902-1	(B) 770902-2
(B) 1-770902-0	(B) 1-770902-1	(B) 770902-5	(B) 770902-6
(C) 794218-3	(C) 1-794218-0	(C) 794218-1	(C) 794218-2
(C) 794219-3	(C) 1-794219-0	(C) 794219-1	(C) 794219-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.34mm2	0.78+/-0.05 [.031+/- .002]	7.0
0.22mm2	0.69+/-0.05 [.027+/- .002]	8.0
0.14mm2	0.63+/-0.05 [.025+/- .002]	8.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.78+/-0.05 [.031+/- .002]	7.2
24 AWG	0.69+/-0.05 [.027+/- .002]	8.1
26 AWG	0.63+/-0.05 [.025+/- .002]	8.7

- 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: 8-2266674-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266674-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266674-5
- 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 & 180. 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.

12. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

**\*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
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-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)

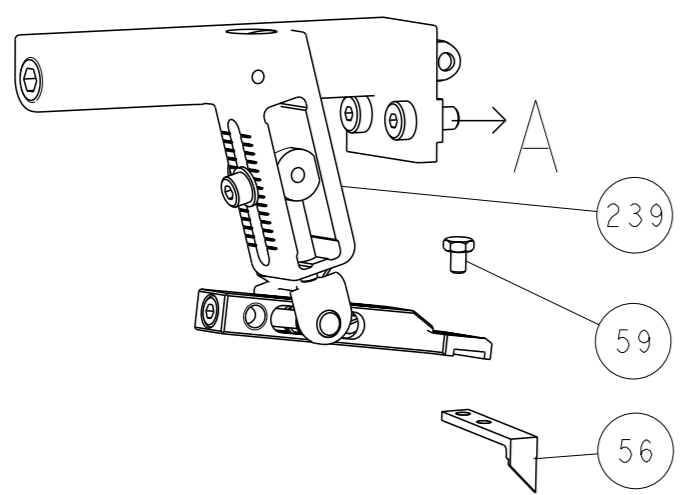
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	#	LYR	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	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
-	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	182
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	1	1	1	1	1-1752354-7	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	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	2-2119656-2	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	455888-6	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 PNT, M3 X 4.0	62
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1338685-1	PAWL, FEED	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	1-2119644-4	RAM WASHER, PRECISION	38
-	1	1	1	1	1752356-1	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	1-18028-2	WASHER, FLAT, REG M4	20
-	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	1333225-9	ANVIL, COMBINATION	8
-	1	1	1	1	1-240641-0	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1-238011-3	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1-2119582-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	1	1	568176-6	CRIMPER, WIRE	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

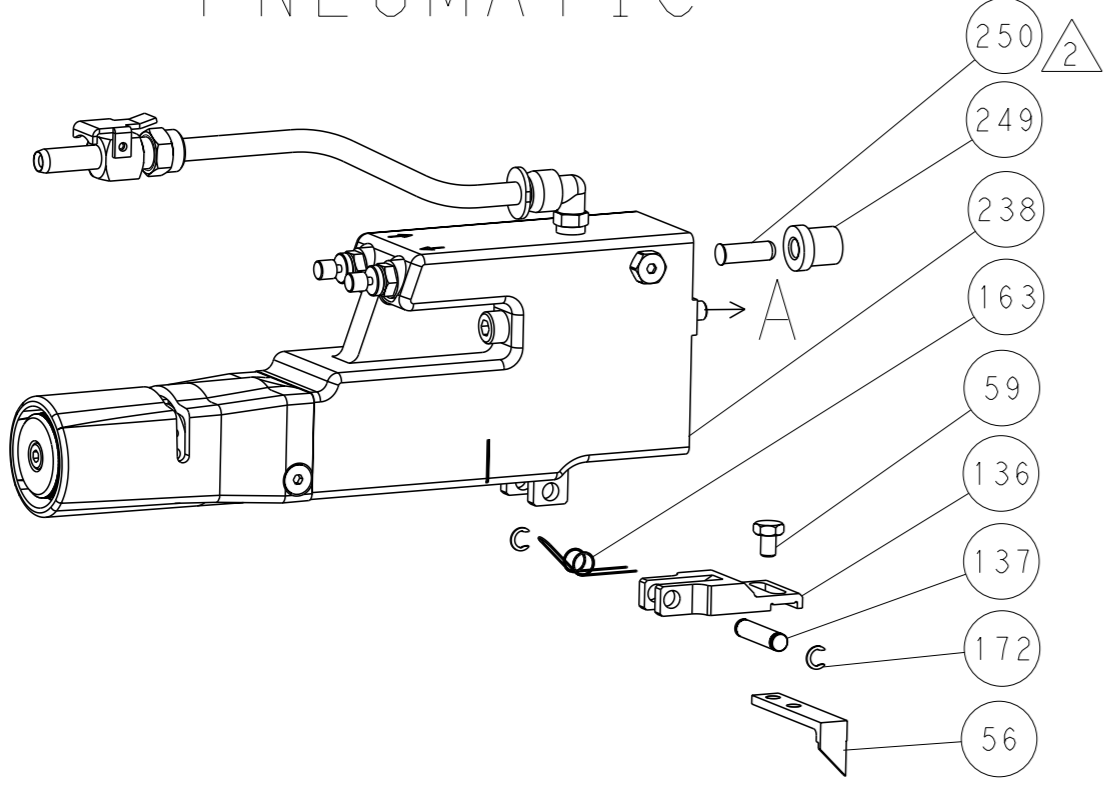
<p>THE DIMENSIONS AND TOLERANCES SHOWN ARE UNLESS OTHERWISE SPECIFIED.</p> <p>UNLESS OTHERWISE SPECIFIED:</p> <p>FINISH</p>	<p>OWN: HOFFNER 10FEB2015</p> <p>CHK: T. ELBIN 11FEB2015</p> <p>APVD: T. ELBIN 11FEB2015</p> <p>PRODUCT SPEC</p> <p>APPLICATION SPEC</p> <p>WEIGHT</p>	<p>TE Connectivity Harrisburg, PA 17105-3608</p> <p><b>STE</b></p> <p>Ocean Side Feed Applicator</p> <p>SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266674</p> <p>Customer Accessible Production Drawing SCALE: 1:2 SHEET 3 OF 4 REV: A2</p>
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LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

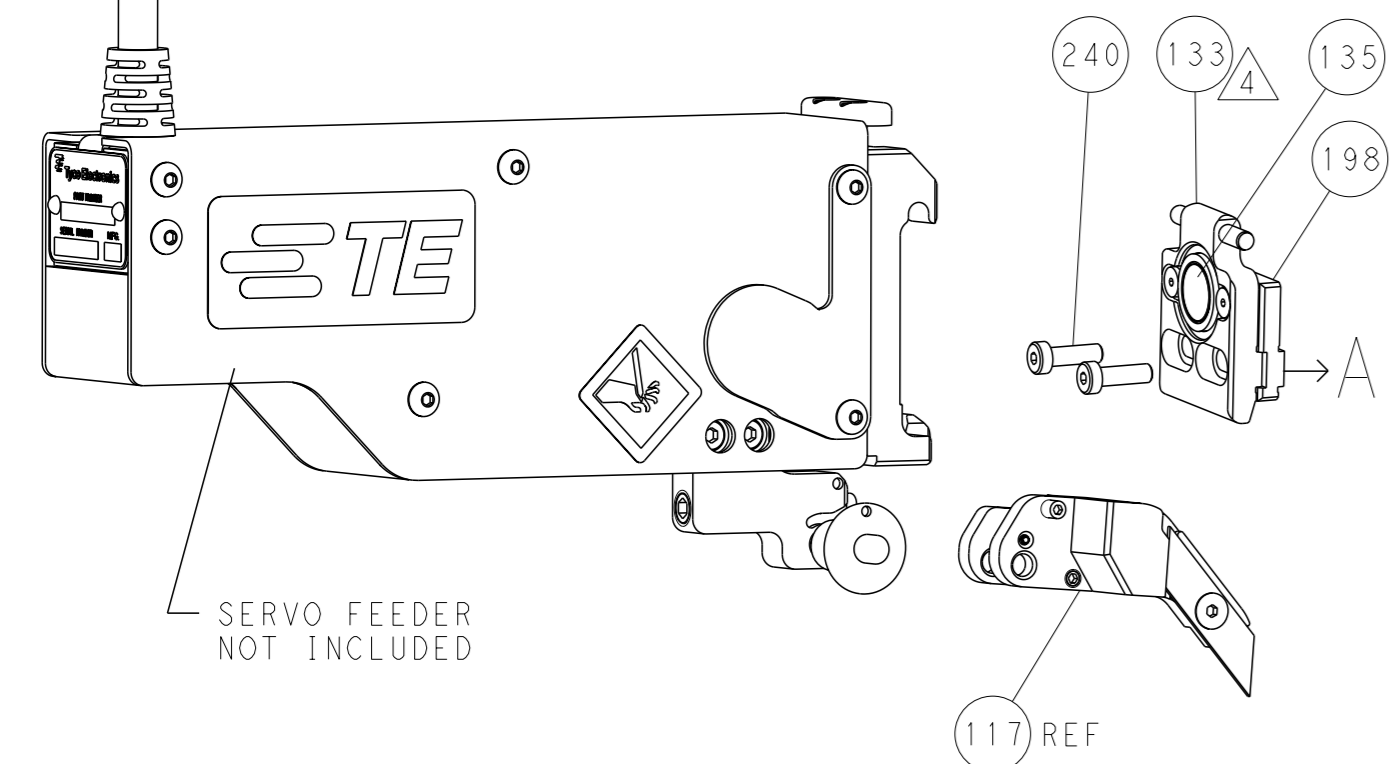
# FEED TYPE MECHANICAL



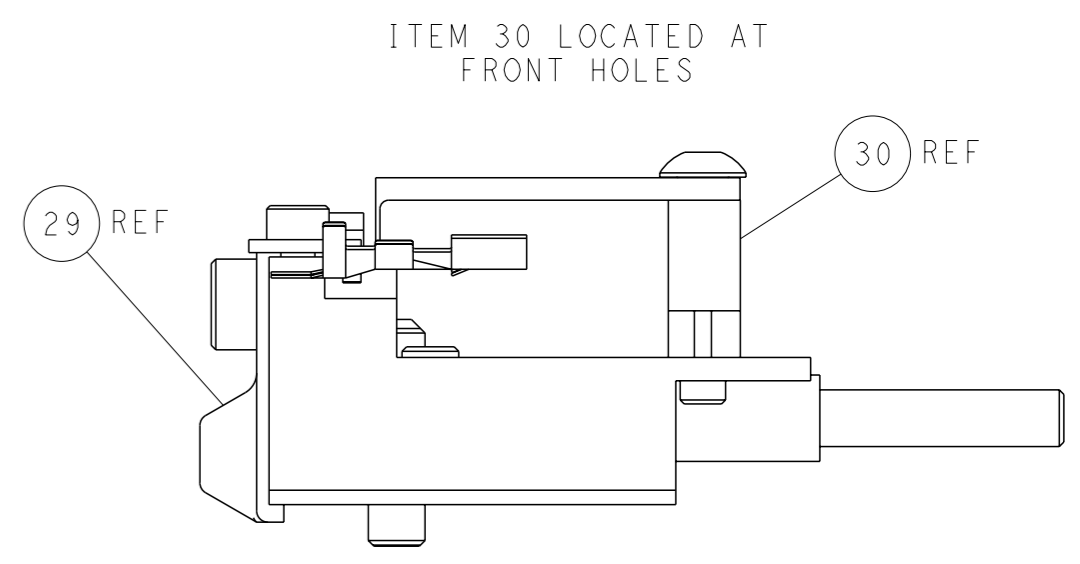
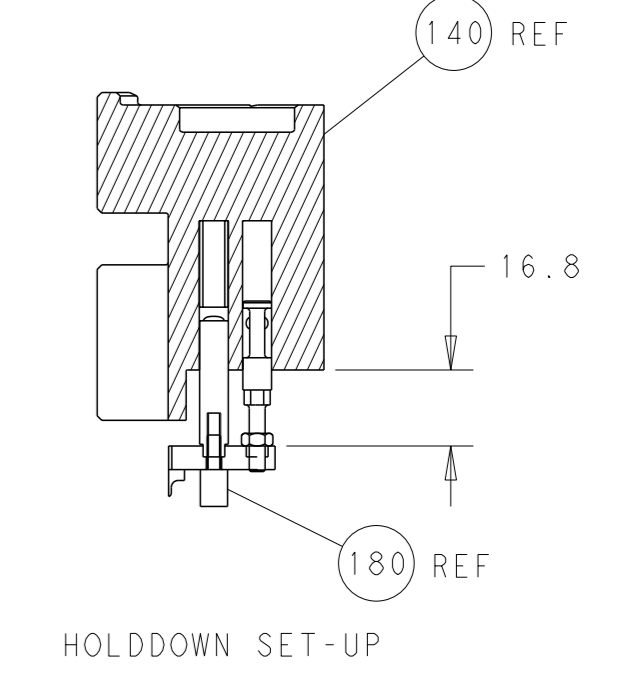
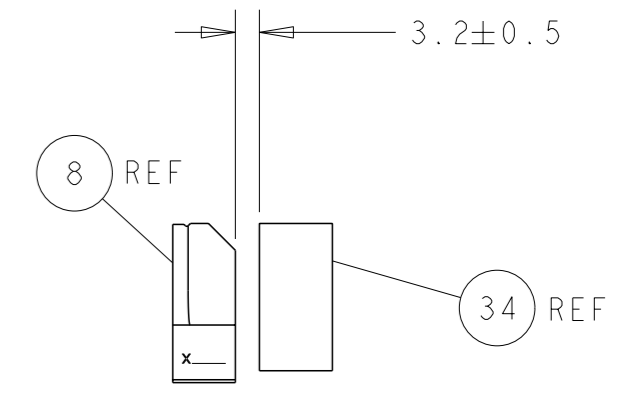
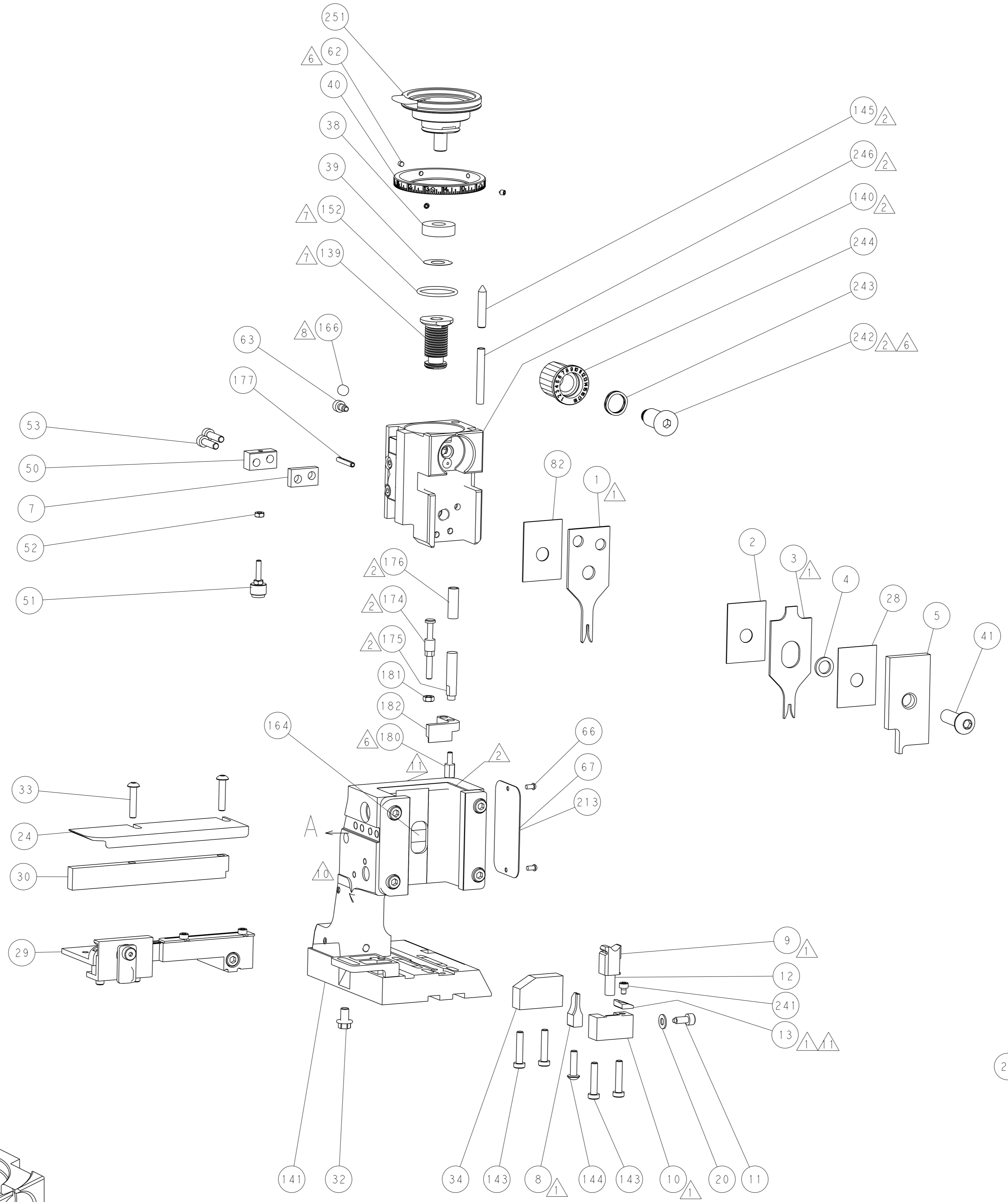
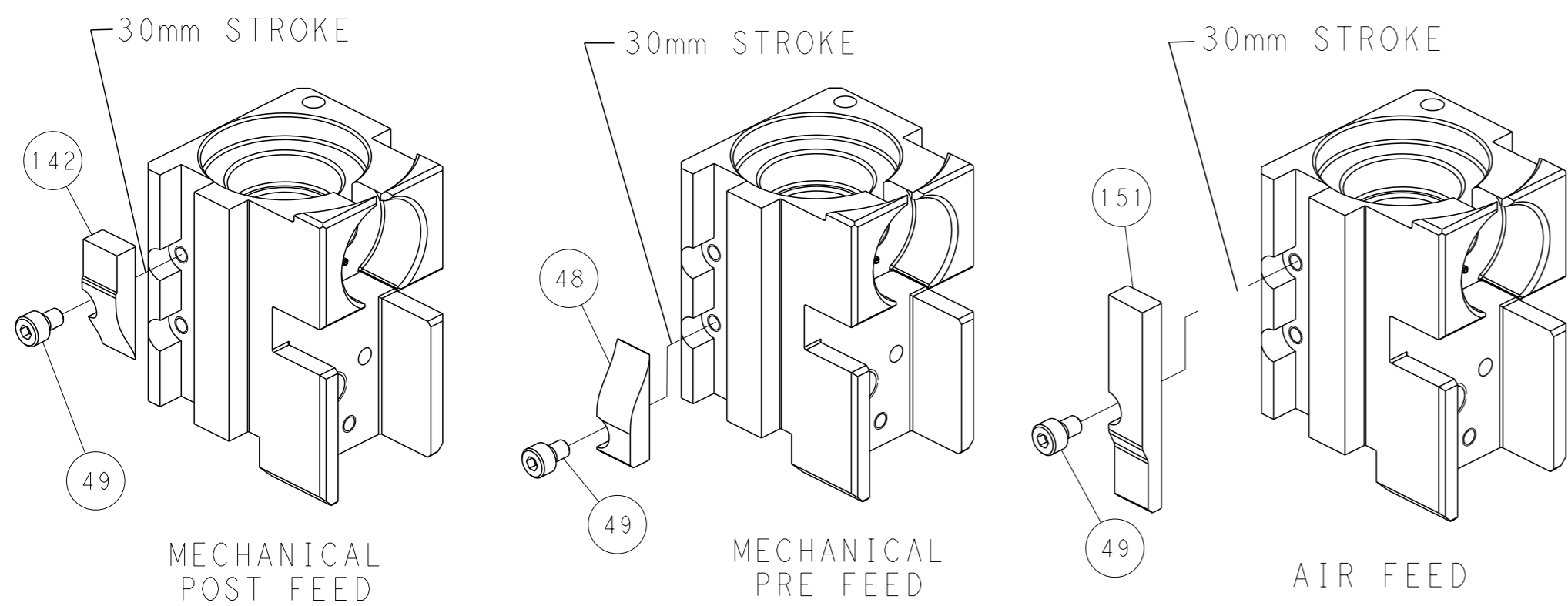
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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 UNPUBLISHED. RELEASED FOR PUBLICATION 20. IT IS SUBJECT TO CHANGE AND THE CONTROLLER ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: HOFFNER 10FEB2015 CBY: T. ELBIN 11FEB2015 APVD: T. ELBIN 11FEB2015	TE Connectivity Harrisburg, PA 17105-3608
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 *	NAME: Ocean Side Feed Applicator APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266674	RESTRICTED TO: - WEIGHT: - SCALE: 1:2 SHEET: 4 of 4 REV: A2	CUSTOMER ACCESSIBLE PRODUCTION DRAWING