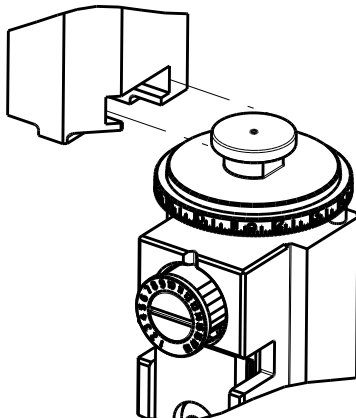
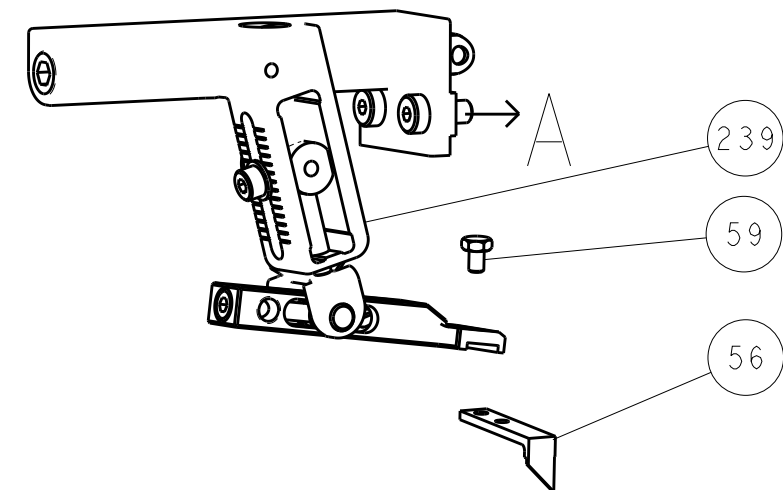


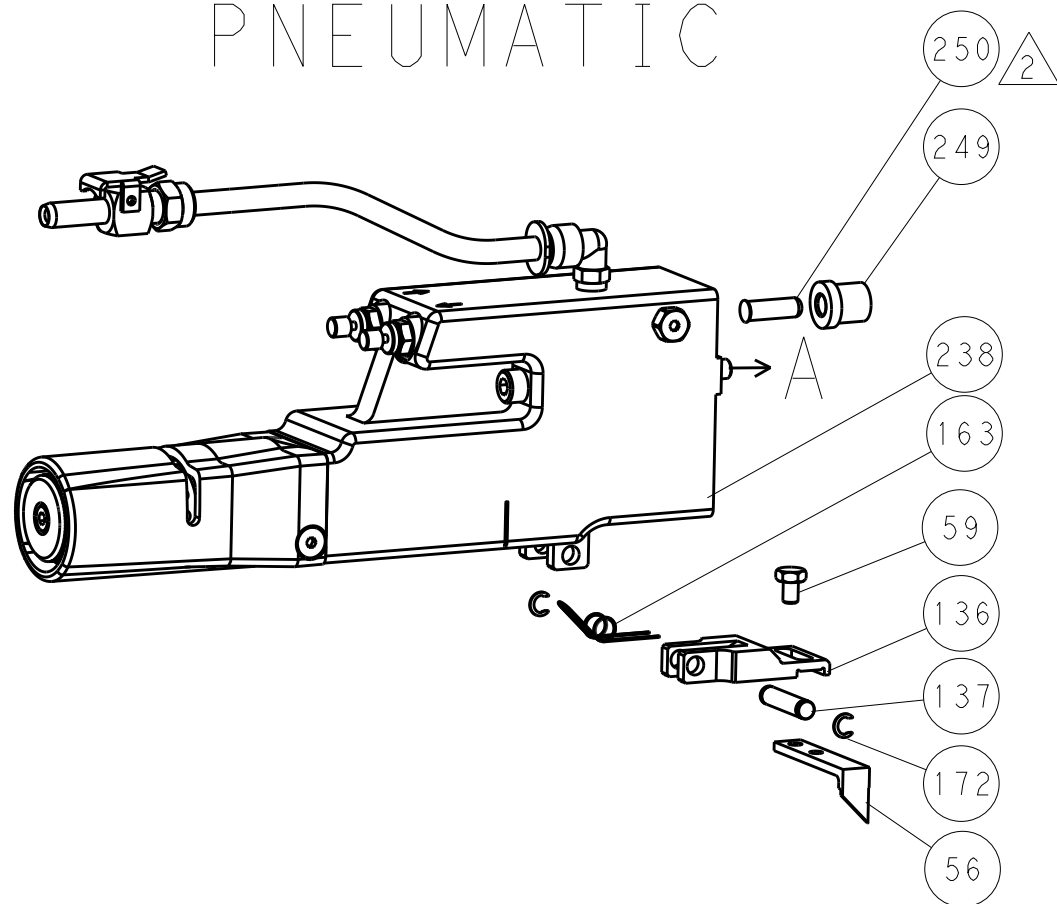
8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2266121-1	B	FINE CRIMP HEIGHT ADJUST
	2266121-2	B	FINE CRIMP HEIGHT ADJUST
	2266121-5	B	FINE CRIMP HEIGHT ADJUST
	2266121-6	B	NON-CRIMP HEIGHT ADJUST
	2266121-7	B	FINE CRIMP HEIGHT ADJUST
	7-2266121-7	B	CRIMP TOOLING KIT
	7-2266121-8	B	APPLICATOR CONVERSION KIT

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE
MECHANICAL



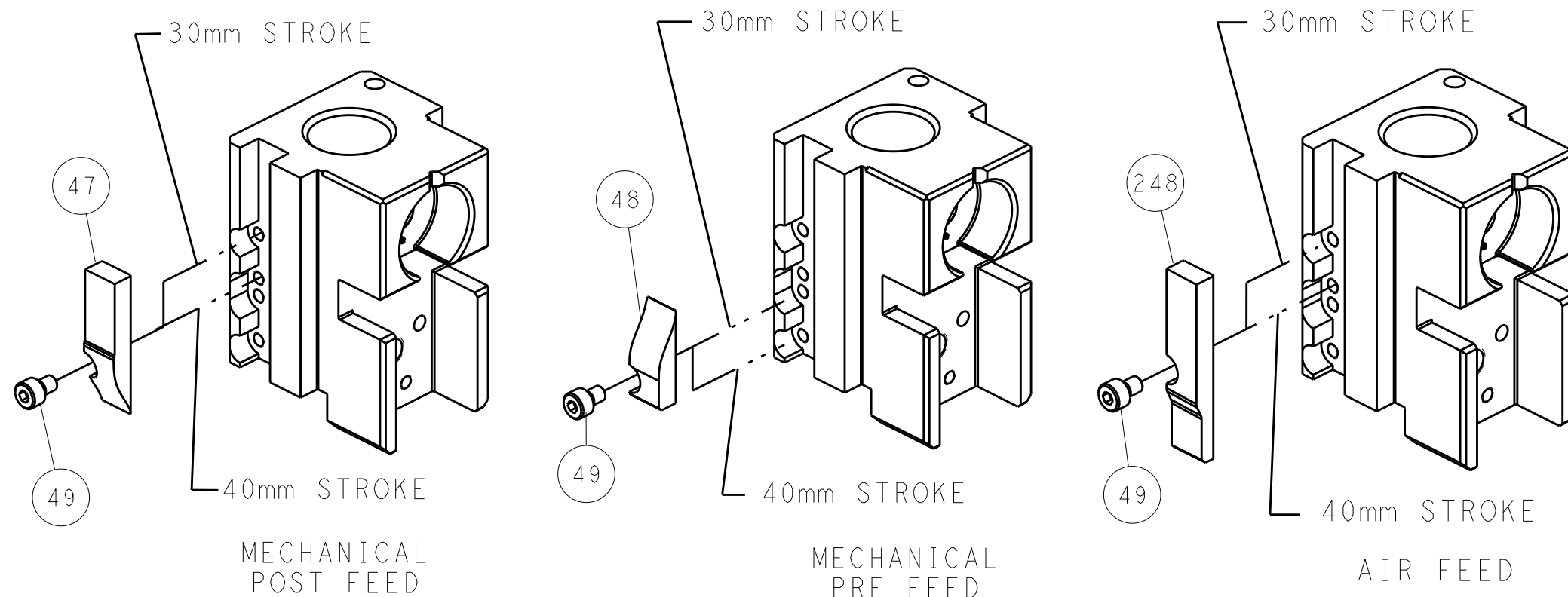
PNEUMATIC



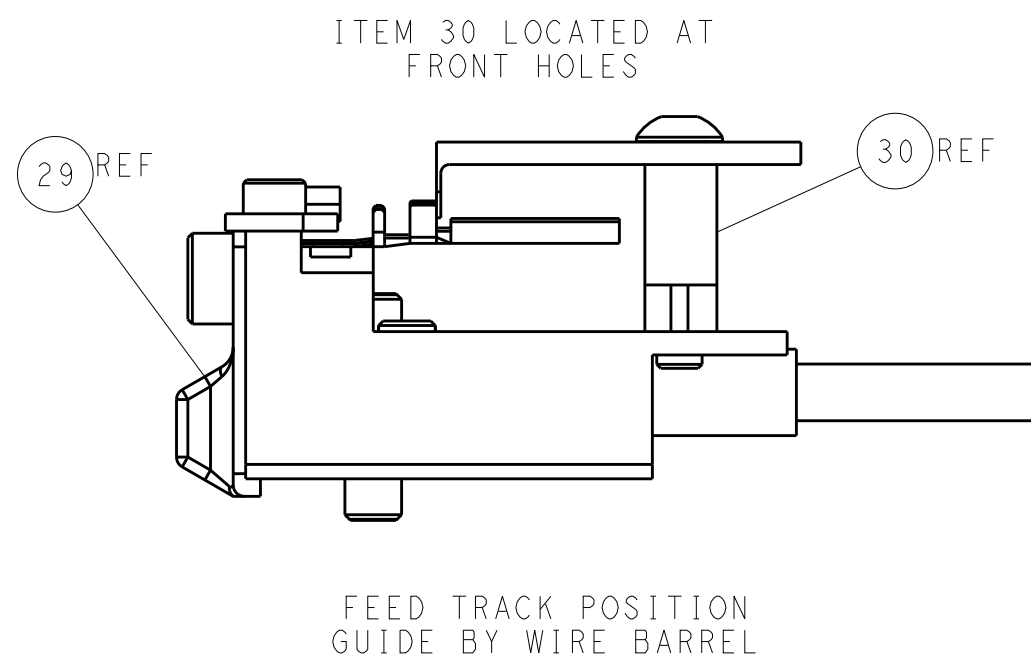
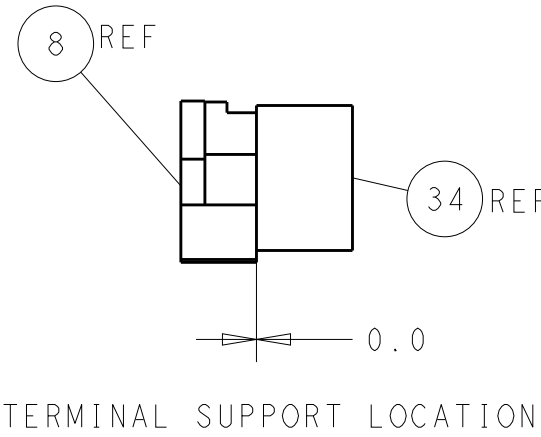
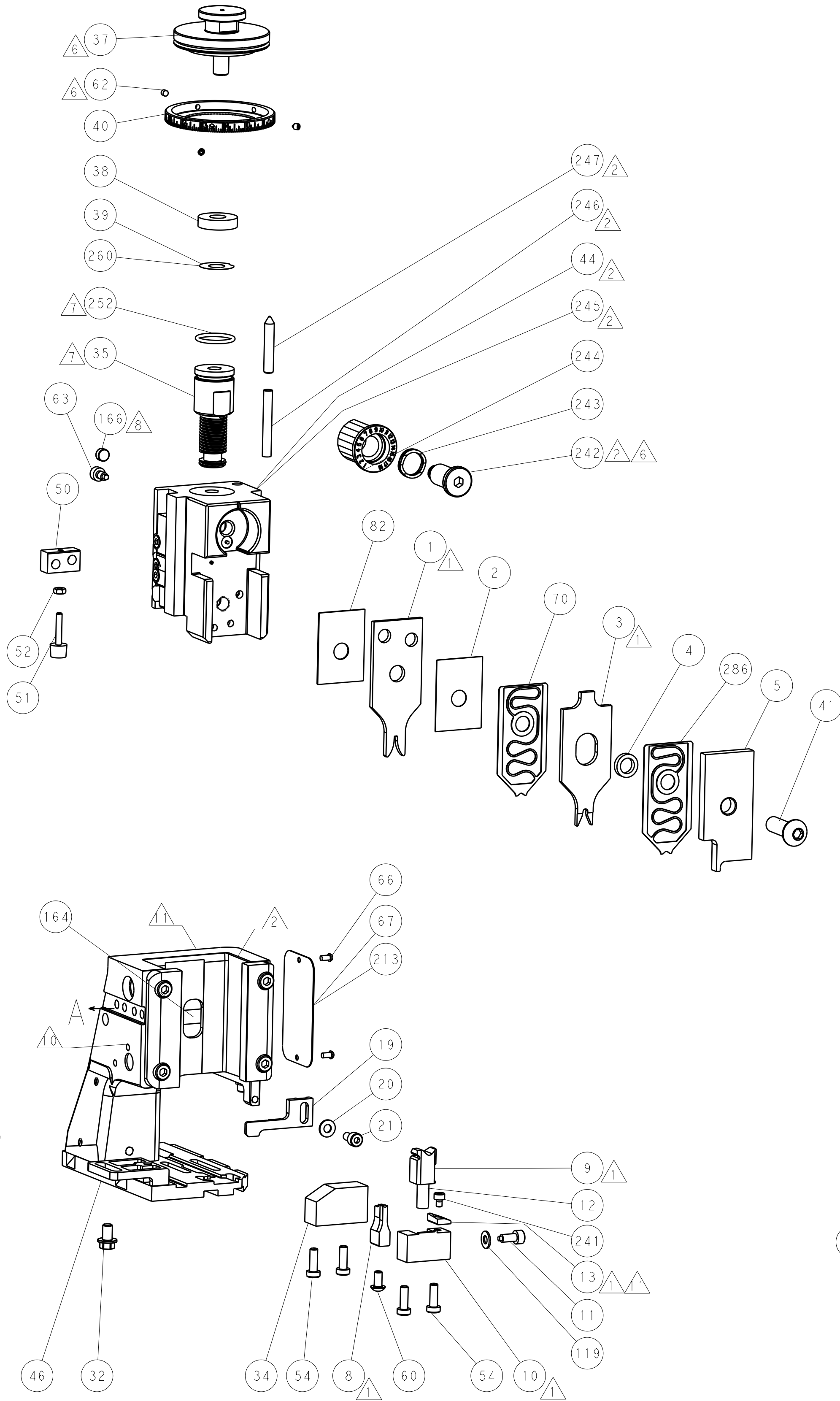
SERVO
LATCH PLATE



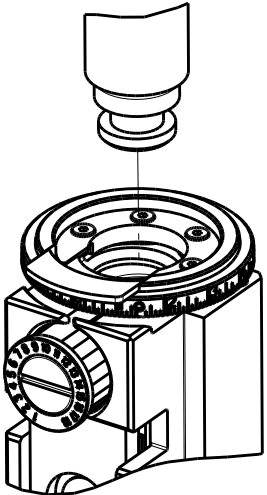
CAM POSITIONS



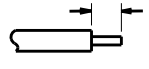
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

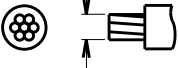


DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. KNEPPER 29-Jan-14		TE Connectivity	
mm		0 PLC ±		CHK G. BAILEY 29-Jan-14		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD W. CLIFFORD 29-Jan-14		NAME	
		2 PLC ±		PRODUCT SPEC		Ocean Side Feed	
		3 PLC ±		APPLICATION SPEC		Applicator	
		4 PLC ±		WEIGHT		SIZE	
		FINISH		Customer Accessible Production Drawing		CAGE CODE	
				SCALE		DRAWING NO	
				1:2		00779	
				SHEET		REV	
				2 of 4		B2	

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2266121-1	B	FINE CRIMP HEIGHT ADJUST
	2-2266121-2	B	FINE CRIMP HEIGHT ADJUST
	2-2266121-5	B	FINE CRIMP HEIGHT ADJUST
	2-2266121-7	B	FINE CRIMP HEIGHT ADJUST
	7-2266121-7	B	CRIMP TOOLING KIT
	7-2266121-8	B	APPLICATOR CONVERSION KIT

APPLICATOR DATA			APPLICATOR CONVERSION KITS	
CRIMP	SIZE	TYPE	PART NUMBER	INSULATION DIAMETER RANGE
WIRE	1.88 mm [.074]	F	7-2266121-8	Ø2.74-3.18mm [.108-.125]
INSUL	2.79 mm [.110]	O	7-2266122-8	Ø2.31-2.72mm [.091-.107]
APPLICATOR INSTRUCTIONS 408-10389			7-2266123-8	Ø1.91-2.29mm [.075-.090]

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT PIN SIZE 20			
WIRE STRIP LENGTH 3.81-5.09 mm [.150-.200 IN]		INSULATION DIAMETER RANGE Ø2.74-3.18 mm [.108-.125 IN]	
TERMINAL APPLICATION SPECIFICATION		114-151003	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
2113369-1	1060-20-0622	2113369-2	1060-20-0644
2113369-3	1060-20-0677		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		1.68+0.03/-0.05 [.066+.001/- .002]		8.4
14 AWG		1.65+0.03/-0.05 [.065+.001/- .002]		8.6
1.50mm2		1.60+0.03/-0.05 [.063+.001/- .002]		8.9
16 AWG		1.55+0.03/-0.05 [.061+.001/- .002]		9.3
1.00mm2		1.55+0.03/-0.05 [.061+.001/- .002]		9.3

- 
- RECOMMENDED SPARE PARTS

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: 8-2266121-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266121-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266121-5

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.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

8. MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

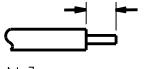
9. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12. SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.

13. TERMINAL LUBRICANT IS RECOMMENDED.

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20			
WIRE STRIP LENGTH 3.81-5.09 mm [.150-.200 IN]		INSULATION DIAMETER RANGE Ø2.74-3.18 mm [.108-.125 IN]	
TERMINAL APPLICATION SPECIFICATION		114-151003	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
2113370-1	1062-20-0622	2113370-2	1062-20-0644
2113370-3	1062-20-0677		

*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	2119791-9	DEPRESSOR, WIRE	286
-	-	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 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				-	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	455888-6	SPACER, CRIMPER	82
1	-	-	-	-	-	2266121	PRINT, APPLICATOR LOG SHEET	72
-	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	-	1	1	1	1	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	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	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	2119644-2	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	1-1803293-7	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	1803019-4	CRIMPER, INSULATION O	3
-	-	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	1	1	1	4-1333281-8	CRIMPER, WIRE PREMIUM	1
-78	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE CURRENT ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN R.KNEPPER CHK G.BAILEY APVD M.CLIFFORD	29-Jan-14 29-Jan-14 29-Jan-14	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC	NAME Ocean Side Feed Applicator	SIZE A1	CAGE CODE 00779
MATERIAL -	FINISH -	APPLICATION SPEC	DRAWING NO C=2266121	RESTRICTED TO -	REV B2
Customer Accessible Production Drawing		SCALE 1:2	SHEET 3	OF 4	REV B2

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

D

C

B

A

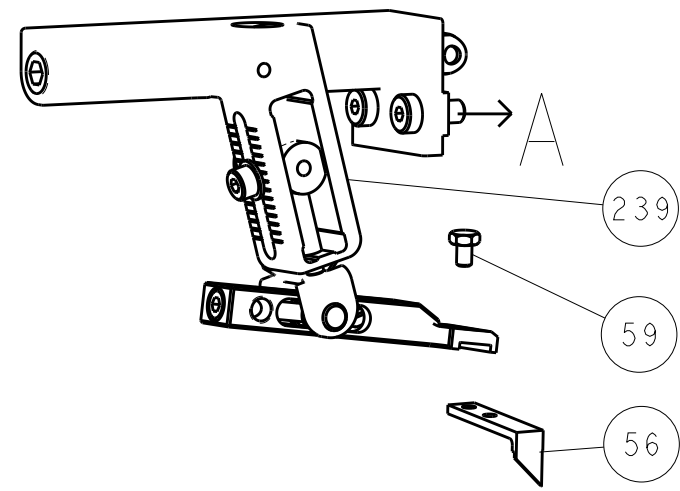
D

C

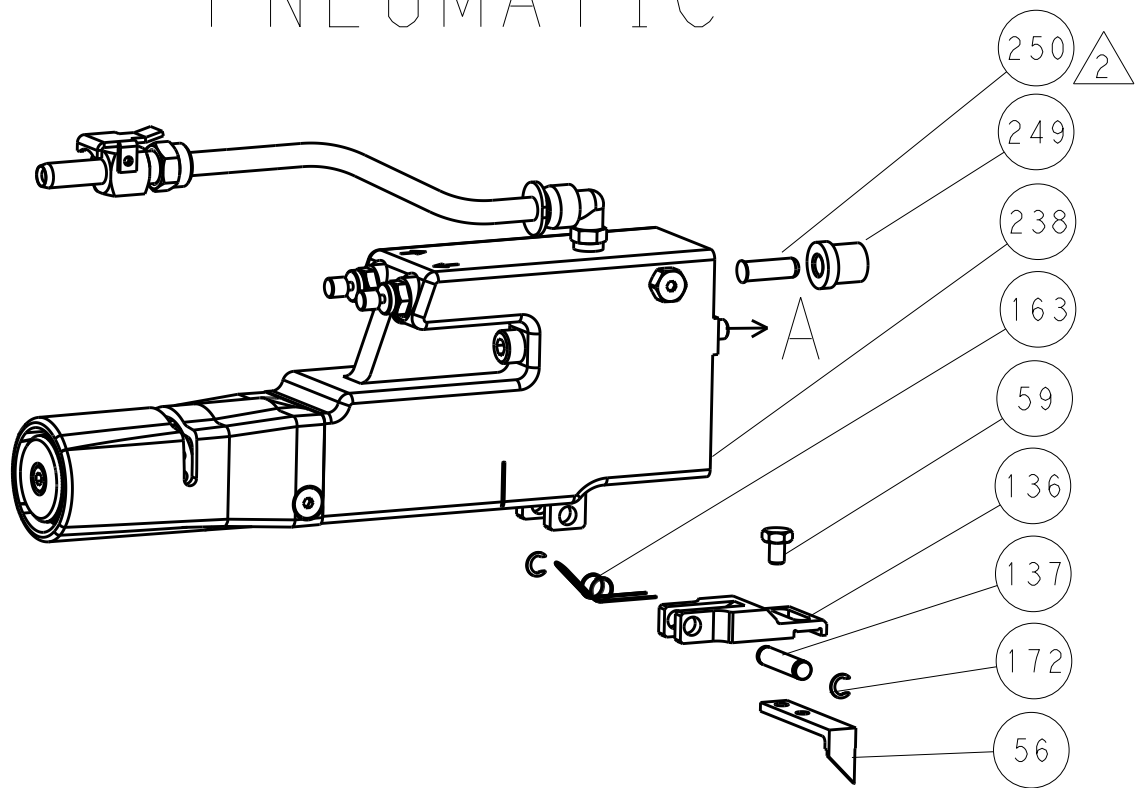
B

A

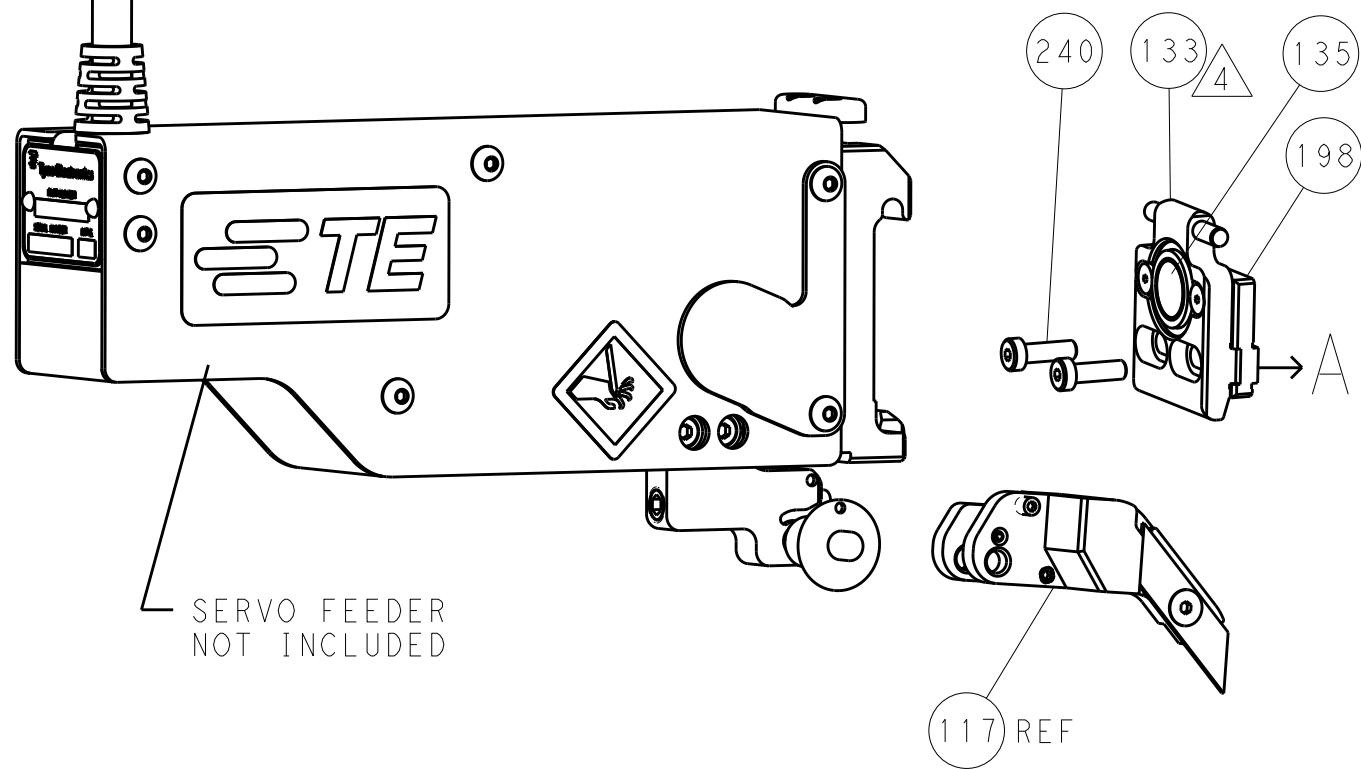
FEED TYPE MECHANICAL



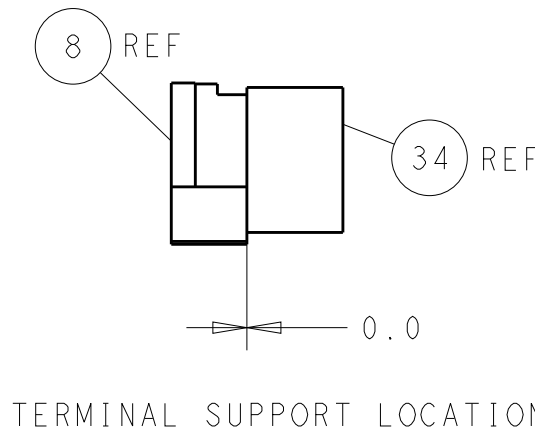
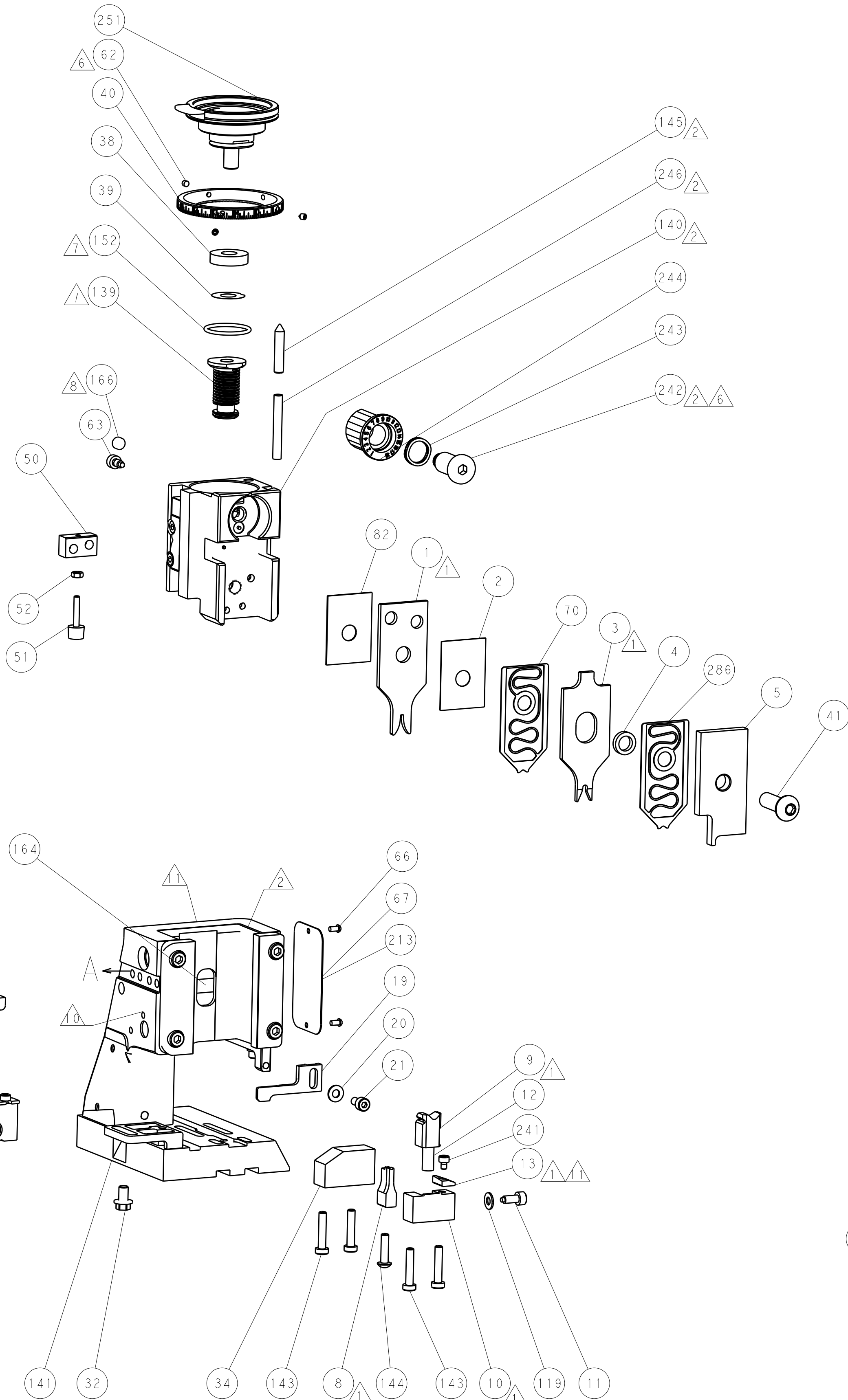
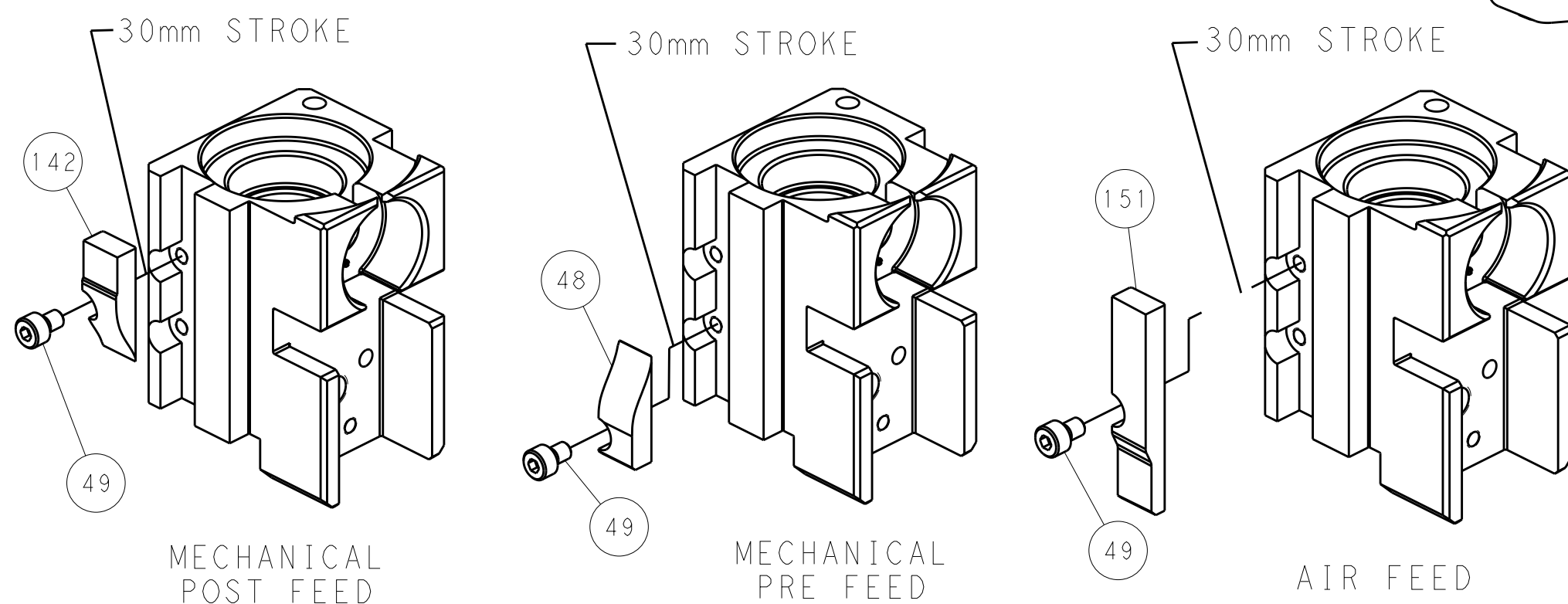
PNEUMATIC



SERVO LATCH PLATE

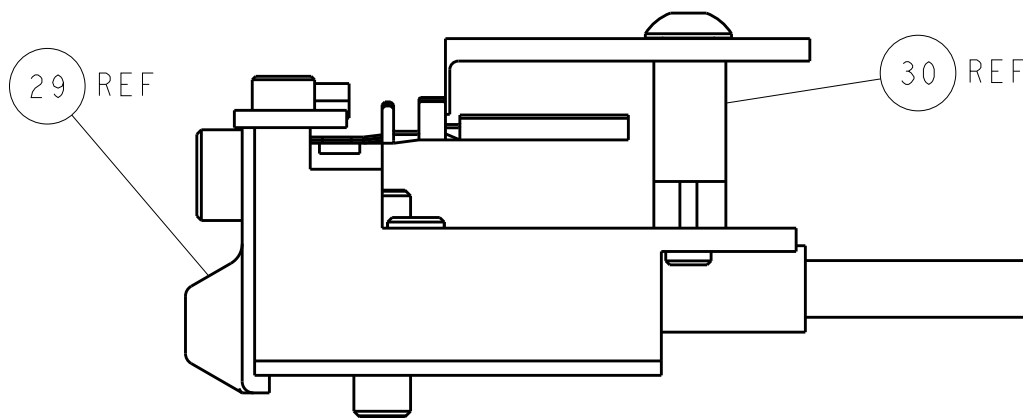


CAM POSITIONS



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY WIRE 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:		OWN		TE Connectivity	
mm		0 PLC ±.1		R. KNEPPER		Harrisburg, PA 17105-3608	
Ø		1 PLC ±.1		G. BAILEY		NAME	
H		2 PLC ±.1		W. CLIFFORD		Ocean Side Feed	
MATERIAL		3 PLC ±.1		PRODUCT SPEC		Applicator	
		4 PLC ±.1		APPLICATION SPEC		SIZE	
		ANGLES		WEIGHT		CAGE CODE	
		FINISH		Customer Accessible Production Drawing		DRAWING NO	
				SCALE		REV	
				1:2		4	
				SHEET		OF	
				4		4	
				REV		B2	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION