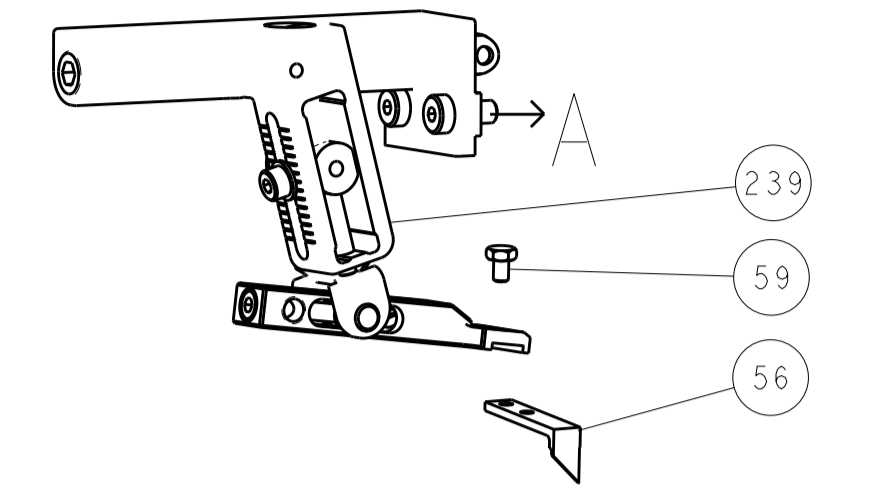
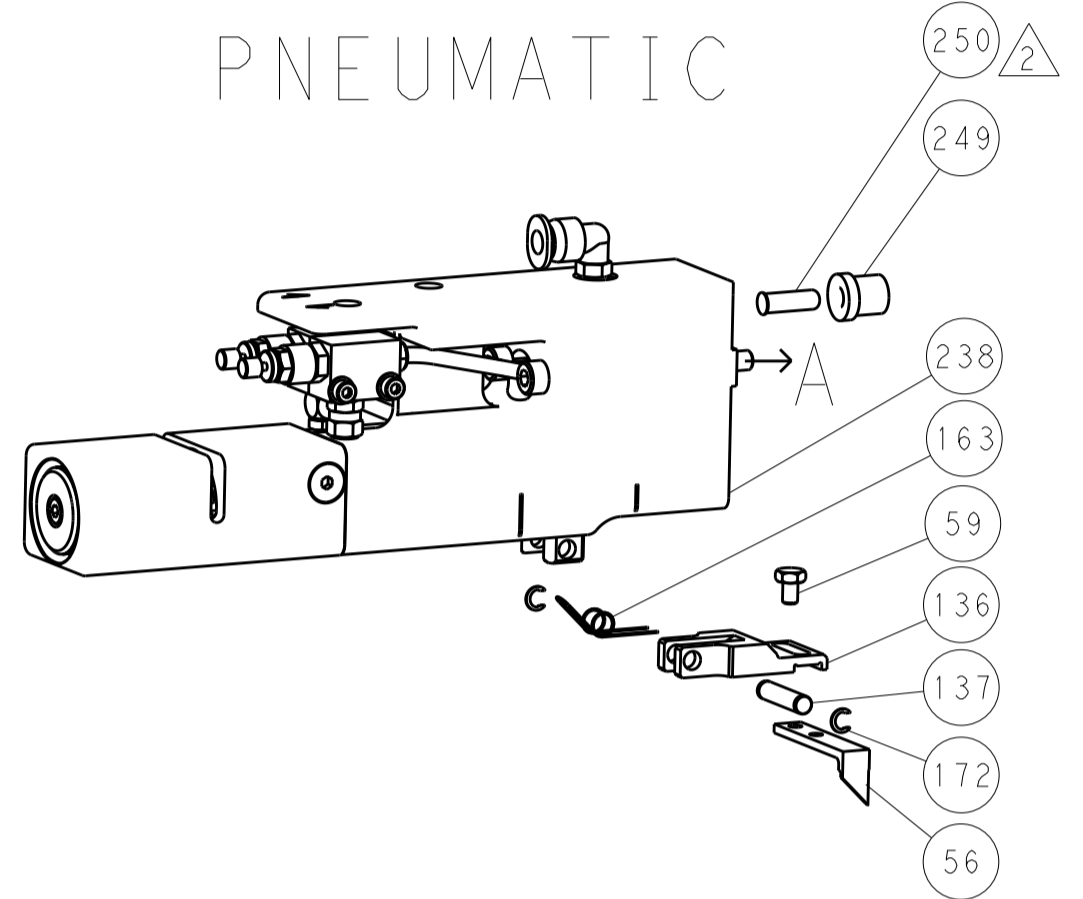


LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

FEED TYPE MECHANICAL



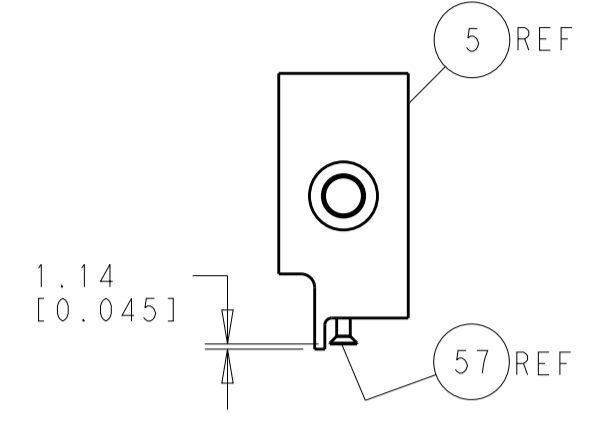
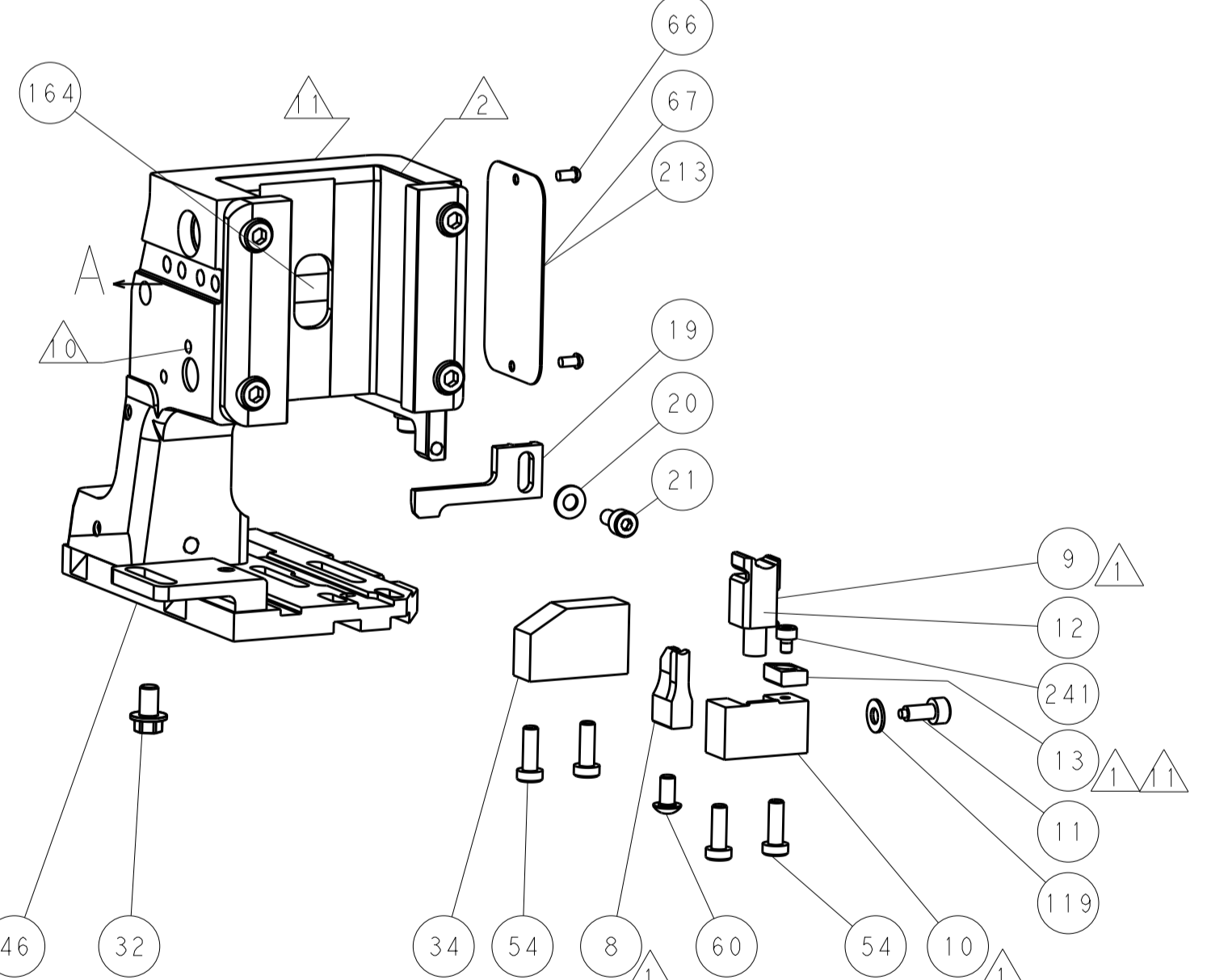
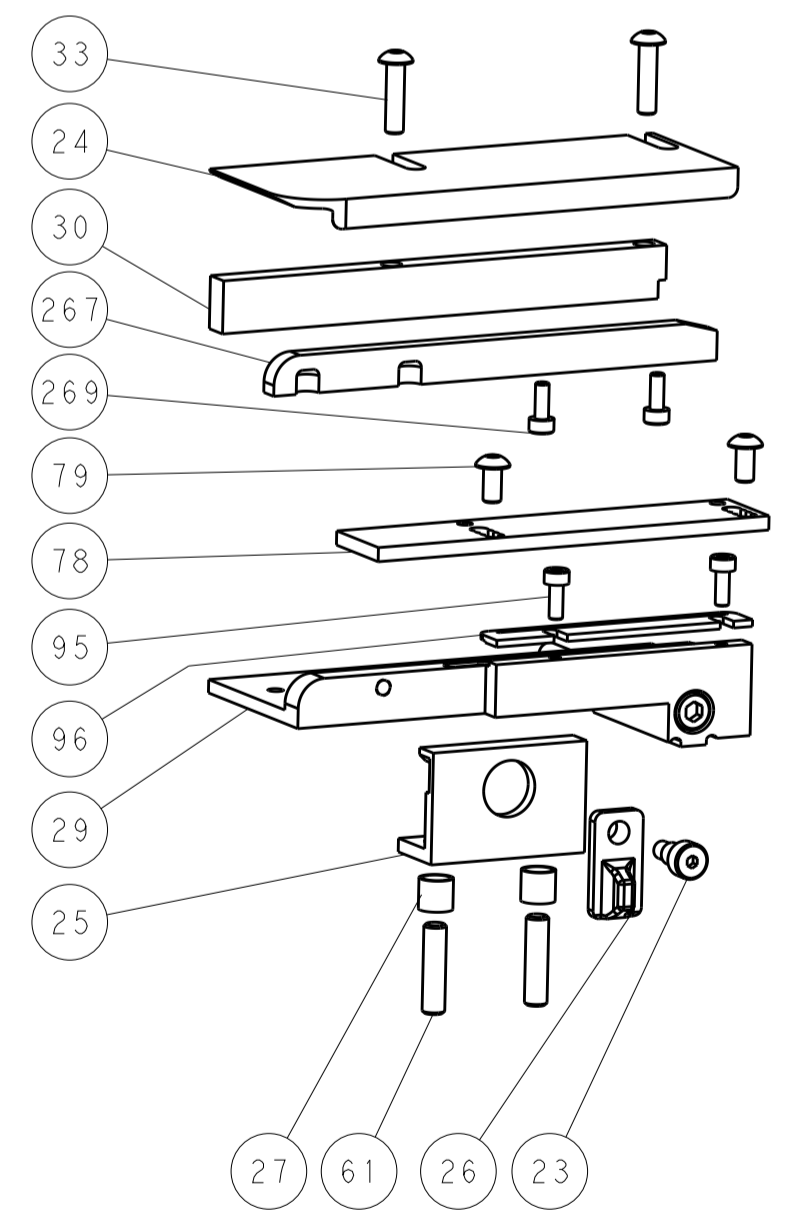
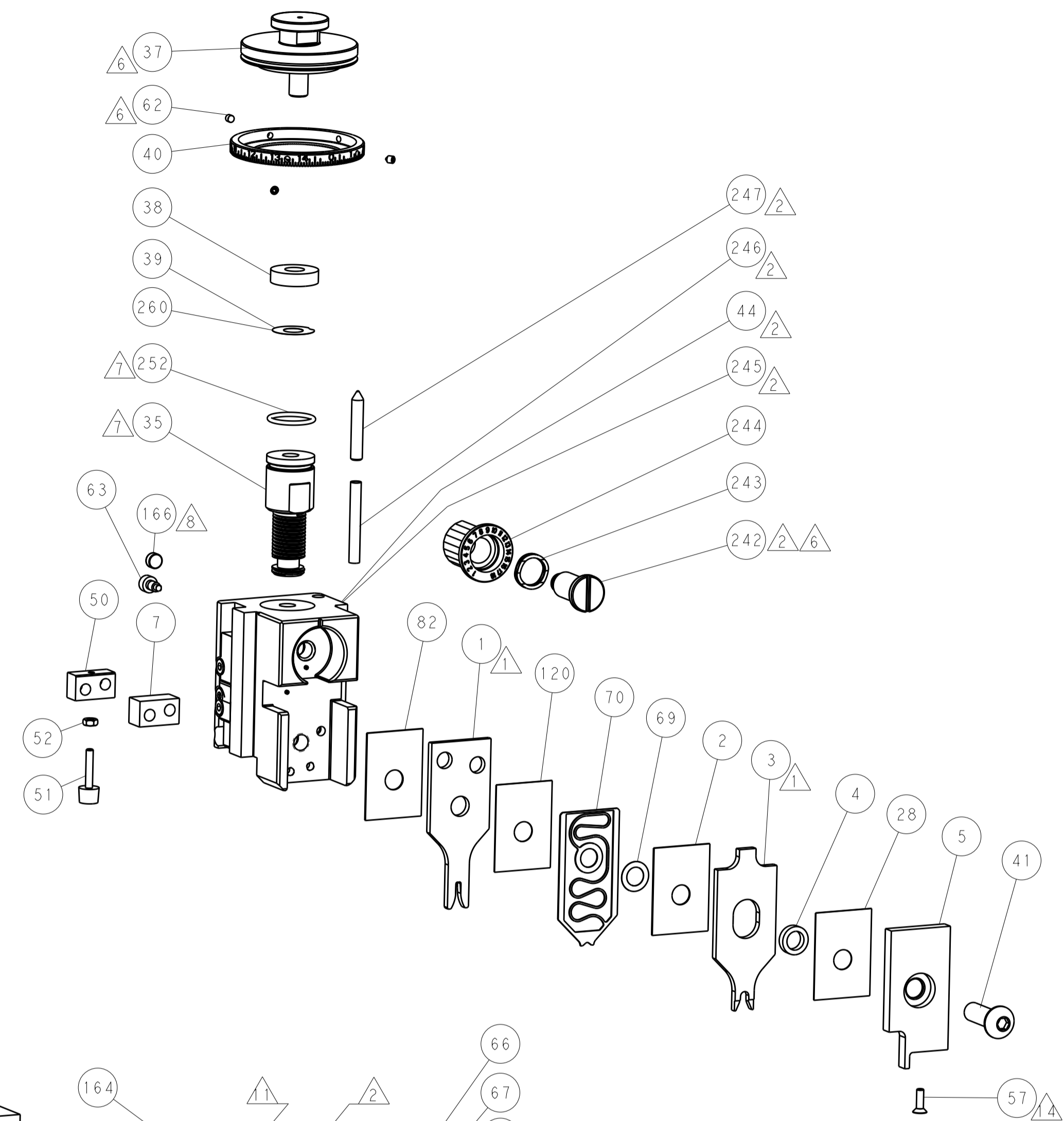
PNEUMATIC



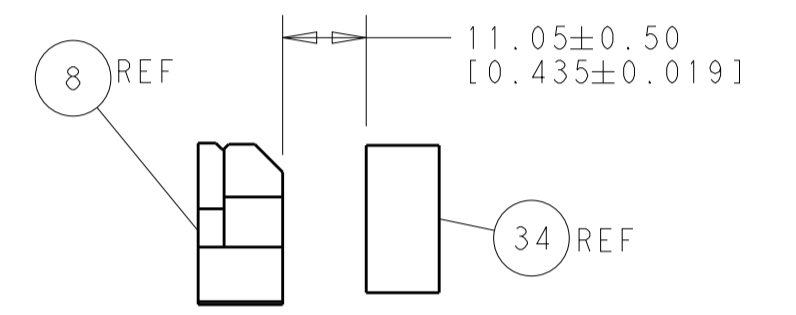
SERVO LATCH PLATE



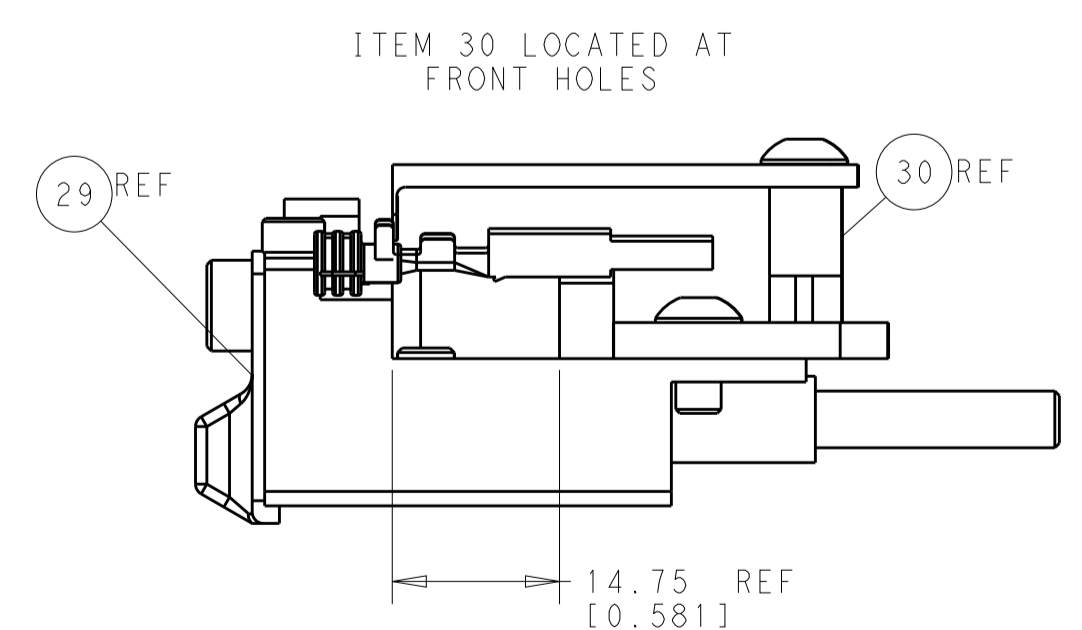
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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:		DWN: L. GROSS 21OCT2013		TE Connectivity	
mm		0 PLC ±0.5		CHK: G. BAILEY 21OCT2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APPV: M. CLIFFORD 21OCT2013		NAME: Ocean Side Feed Applicator	
H		3 PLC ±0.013		PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
ANGLES		4 PLC ±0.0001		APPLICATION SPEC:		RESTRICTED TO:	
FINISH:		5 PLC ±0.0001		WEIGHT:		A1 00779 ©=2266132	
MATERIAL:		6 PLC ±0.0001		Customer Accessible Production Drawing		SCALE: 1:2 SHEET 2 OF 4 REV A	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART								
				CONVERT TO	PART NUMBERS REQUIRED							
2-2266132-1	A	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	-	8-2266132-5	1901094-3	2-1752354-5	2168400-6 (QUANTITY 2)		
				SMART APPLICATOR	2161326-1	-	8-2266132-4	-	-	-		
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-		
2-2266132-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266132-5	1901094-3	2-1752354-5	2168400-6 (QUANTITY 2)		
				SMART APPLICATOR	2161326-1	-	8-2266132-4	-	-	-		
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-		
				PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1		
2-2266132-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	-	-
2-2266132-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-	-
7-2266132-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 1.98 mm [.078]	F	
INSUL 3.96 mm [.156]	Ø	
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: VKS plus Rundstecker 2.5			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.50 mm [.157-.177 IN]	Ø1.40-2.10 mm [.055-.083 IN]		
TERMINAL APPLICATION SPECIFICATION	26634 Rev 1		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE SEAL	LEAR SEAL
2113390-1	26634.201.184	1572316-1	16695.627.642
2113390-2	26634.306.142	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.42 +/- 0.05 [.056 +/- .002]	7.7
0.75mm2	1.32 +/- 0.05 [.052 +/- .002]	8.7
0.50mm2	1.22 +/- 0.05 [.048 +/- .002]	9.6

- 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: 8-2266132-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266132-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266132-5
- 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 ITEMS 62 & 242.
- 7 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 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. THE INSULATION RANGE LISTED ABOVE IS FOR THE TERMINAL. THE INSULATION RANGE FOR THE SEAL IS Ø1.2-2.1mm [.047-.083 IN].
- 13 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 14 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.

- 2 2 2 2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
- 1 1 1 1	1633782-4	FENCE	267
- 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	2119082-6	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
-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)

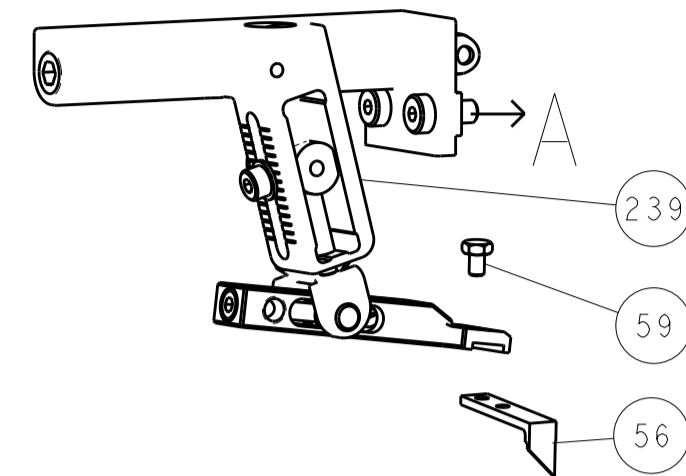
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	P	L	D	A
			-	-	-	-

- - - 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
- 1 1 1 1	455888-3	SPACER, CRIMPER	120
- 1 1 1 1	1-18028-2	WASHER, FLAT, REG M4	119
- - REF - -	2119944-1	FEED FINGER ASSEMBLY, SF	117
- 1 1 1 1	2-690438-2	FRONT STRIP GUIDE	96
- 2 2 2 2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
- 1 1 1 1	455888-5	SPACER, CRIMPER	82
- 2 2 2 2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
- 1 1 1 1	1803096-1	EXTENSION PLATE	78
- 1 1 1 1	2119956-1	DOCUMENTATION PACKAGE	71
- 1 1 1 1	2119791-9	DEPRESSOR, WIRE	70
- 1 1 1 1	2119943-1	WASHER, SPACER	69
- 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
- 2 2 2 2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
- - - 1 1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
- 1 1 1 1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
- - - 1 1	1338685-1	PAWL, FEED	56
- 2 2 2 2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	1-2119644-2	RAM WASHER, PRECISION	38
- 1 1 1 1	1752356-1	SUPPORT, TERMINAL	34
- 2 2 2 2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
- 1 1 1 1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
- 1 1 1 1	1320908-4	SPACER, STRIP GUIDE	30
- 1 1 1 1	2119959-3	ASSEMBLY, STRIP GUIDE	29
- 1 1 1 1	455888-3	SPACER, CRIMPER	28
- 2 2 2 2	22281-8	SPRING, COMPRESSION	27
- 1 1 1 1	356835-1	LEVER, DRAG RELEASE	26
- 1 1 1 1	240792-1	DRAG, TERMINAL	25
- 1 1 1 1	1320928-4	STRIP GUIDE	24
- 1 1 1 1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
- 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	318707-1	FLOATING SHEAR, FRONT	9
1 1 1 1 1 1	6-1633927-2	ANVIL, COMBINATION	8
- 1 1 1 1 1	5-240641-7	SPACER	7
- - - - -	-	-	6
- 1 1 1 1 1	2119781-1	DEPRESSOR, SHEAR	5
- 1 1 1 1 1	238011-2	BLOCK, CRIMPER SPACER	4
1 1 1 1 1 1	2-1803019-6	CRIMPER, INSULATION Ø	3
- 1 1 1 1 1	455888-5	SPACER, CRIMPER	2
1 1 1 1 1 1	3-1633738-3	CRIMPER, WIRE	1
-77 -27 -25 -22 -21	PART NO	DESCRIPTION	ITEM NO

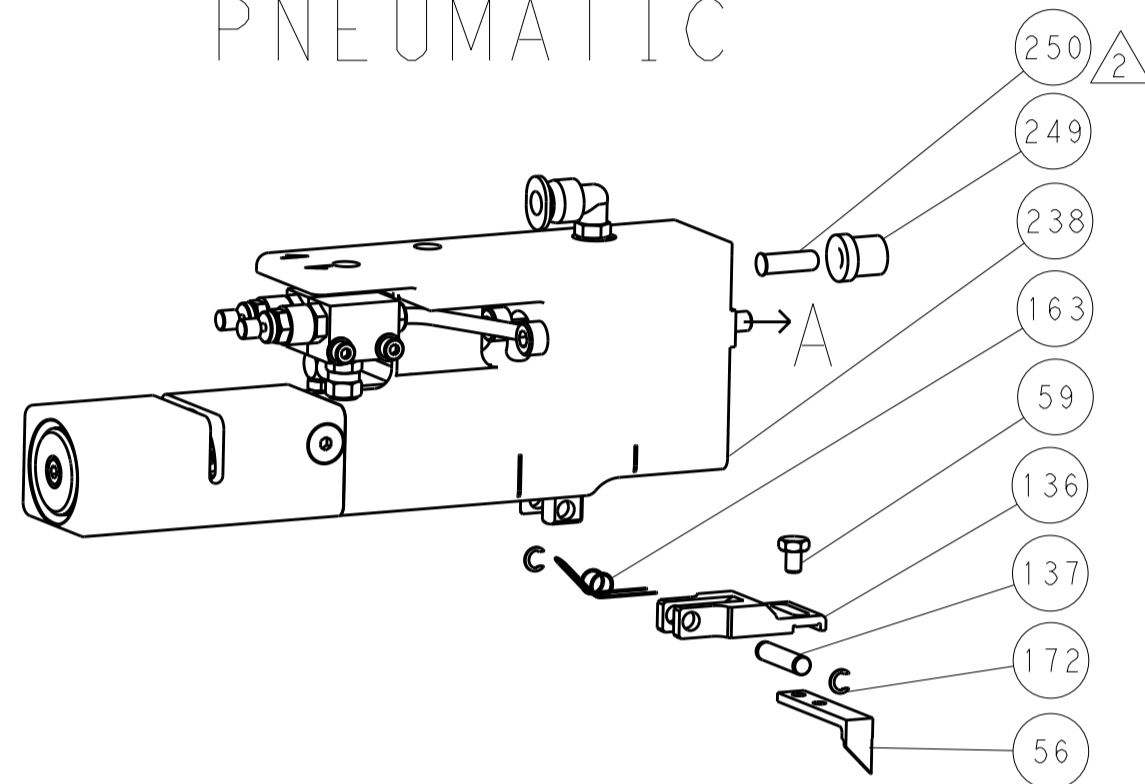
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	ANGLES ±.0001				
MATERIAL:	FINISH:	WEIGHT:	SCALE:	RESTRICTED TO:	

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

FEED TYPE MECHANICAL



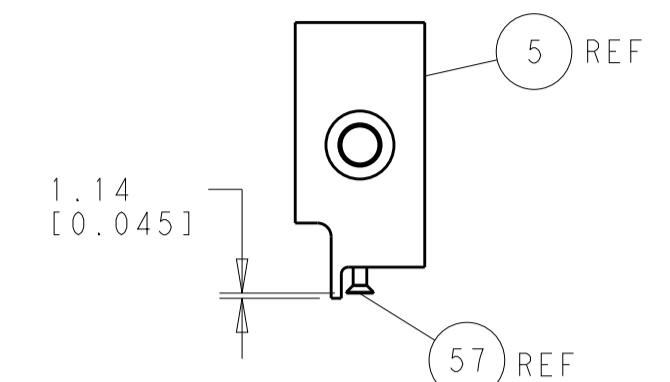
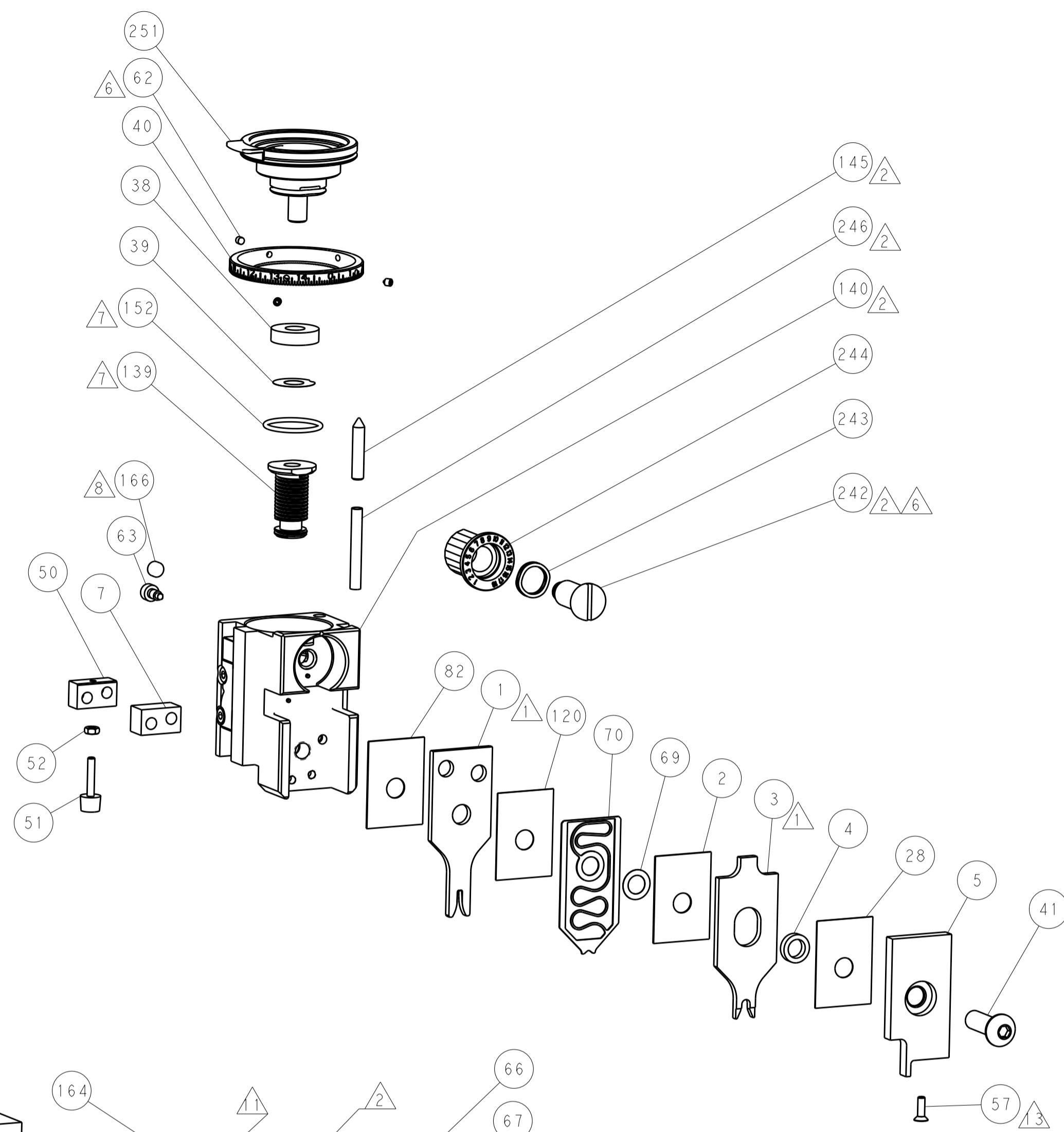
PNEUMATIC



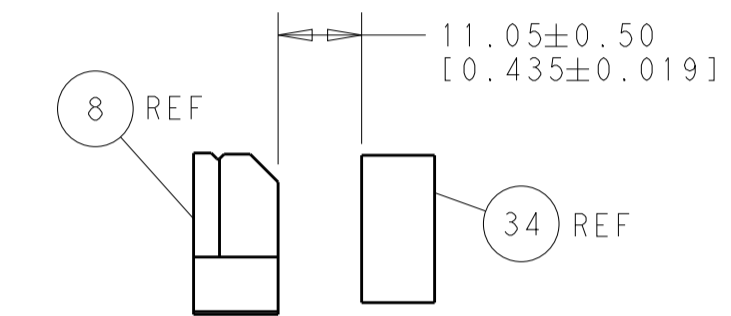
SERVO LATCH PLATE



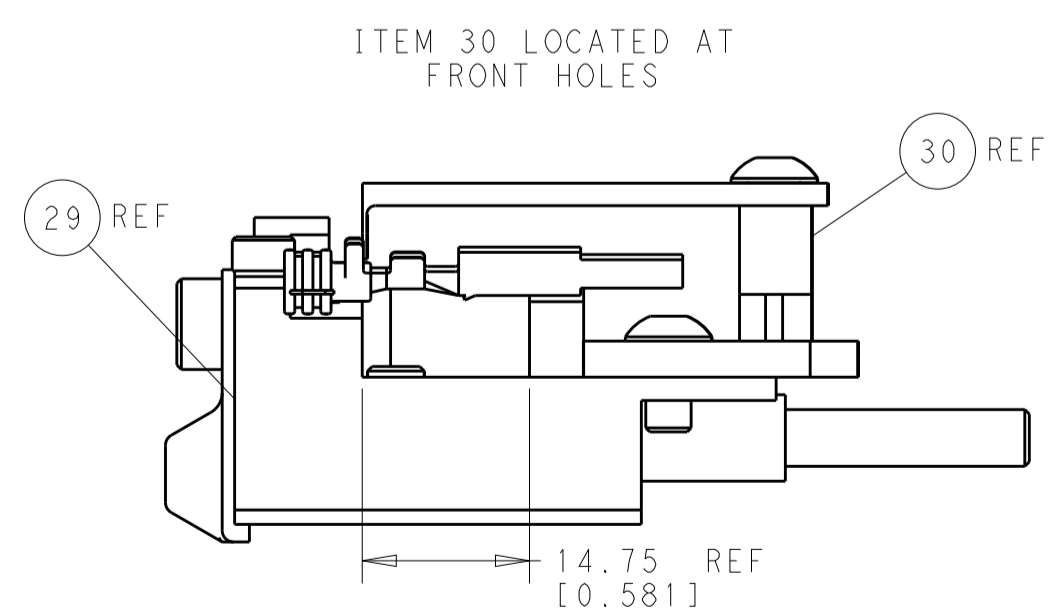
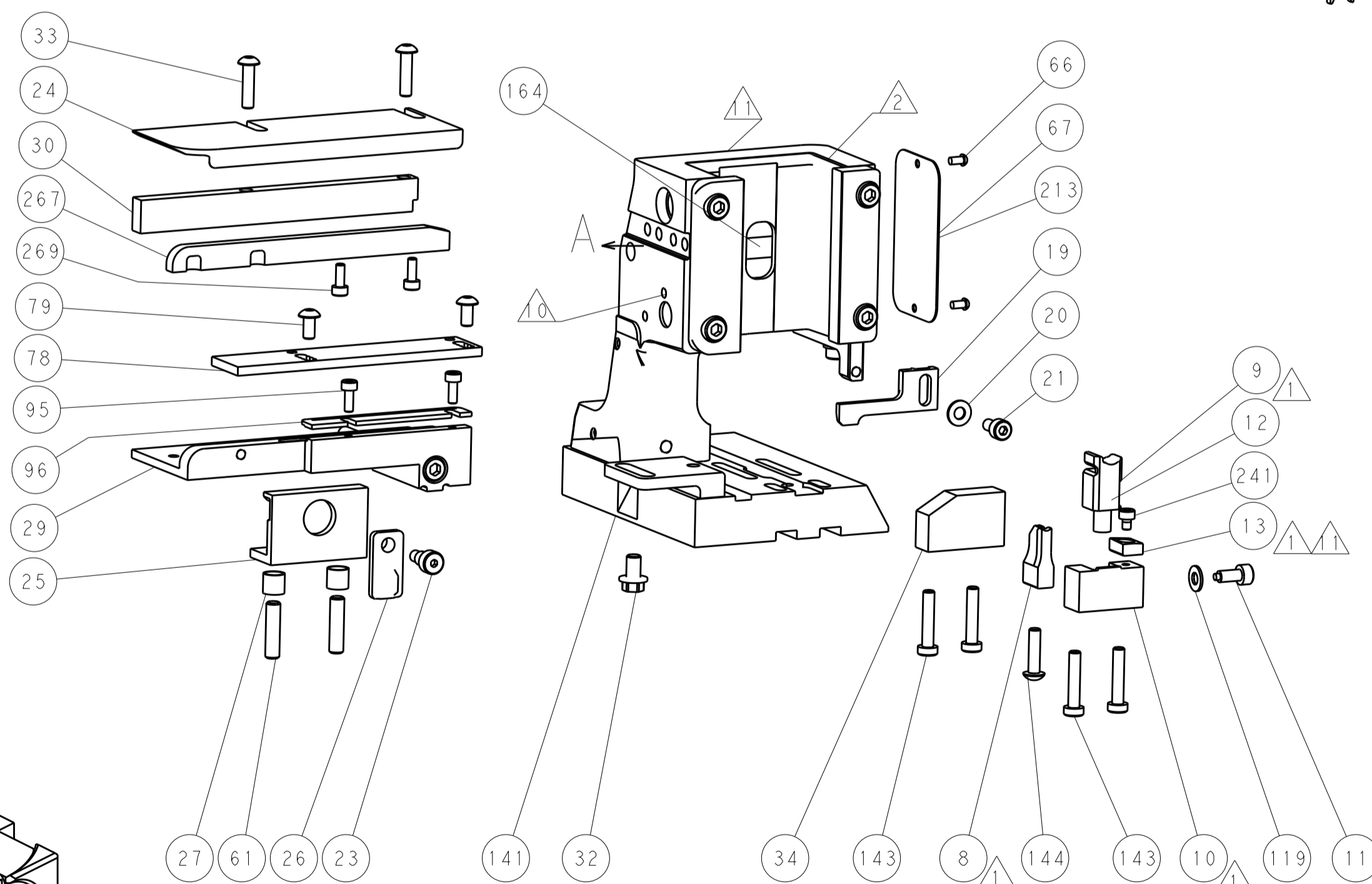
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



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: L. GROSS 21OCT2013		CHK: G. BAILEY 21OCT2013		APVD: M. CLIFFORD 21OCT2013		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.0001	FINISH		SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2266132
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET: 4 OF 4		REV: A	