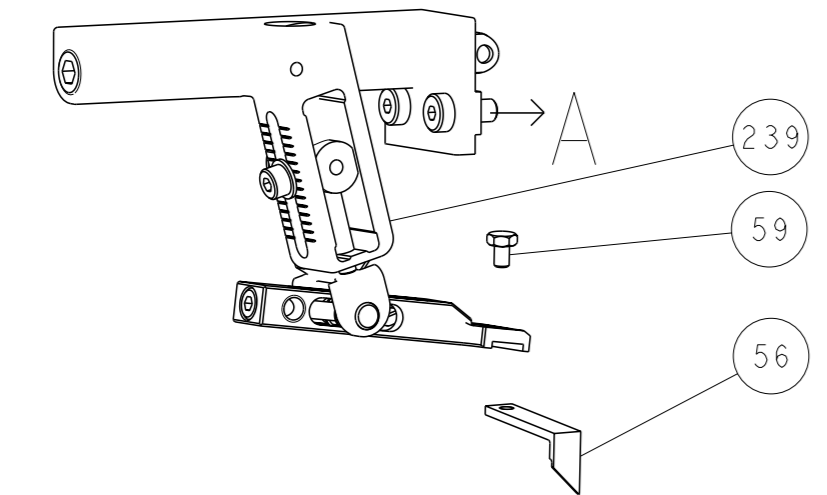
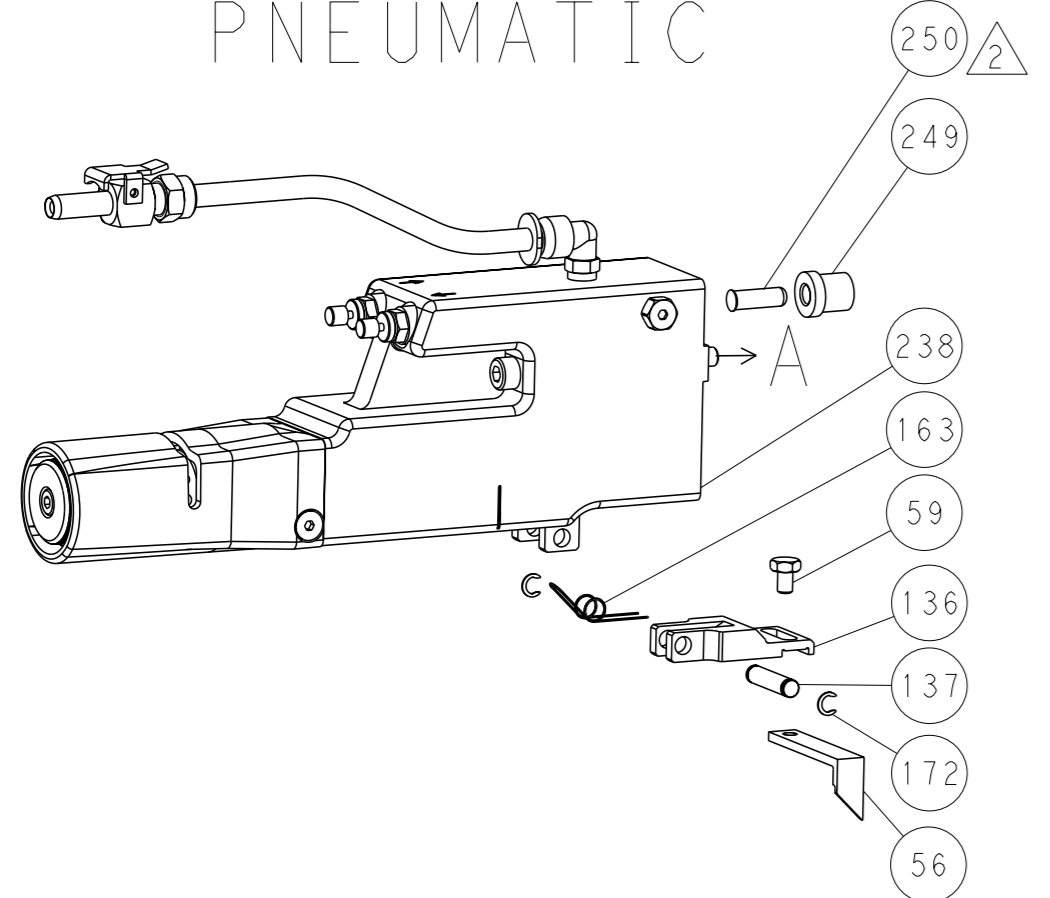


LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

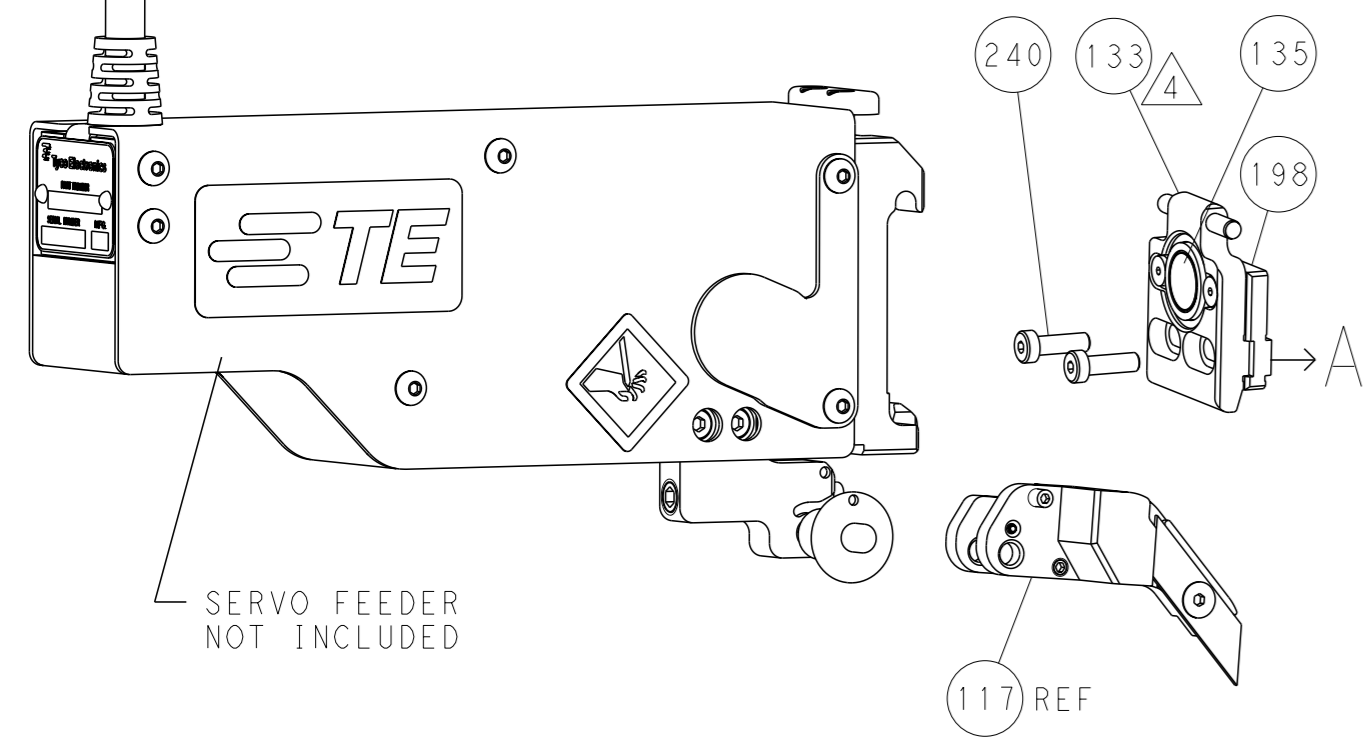
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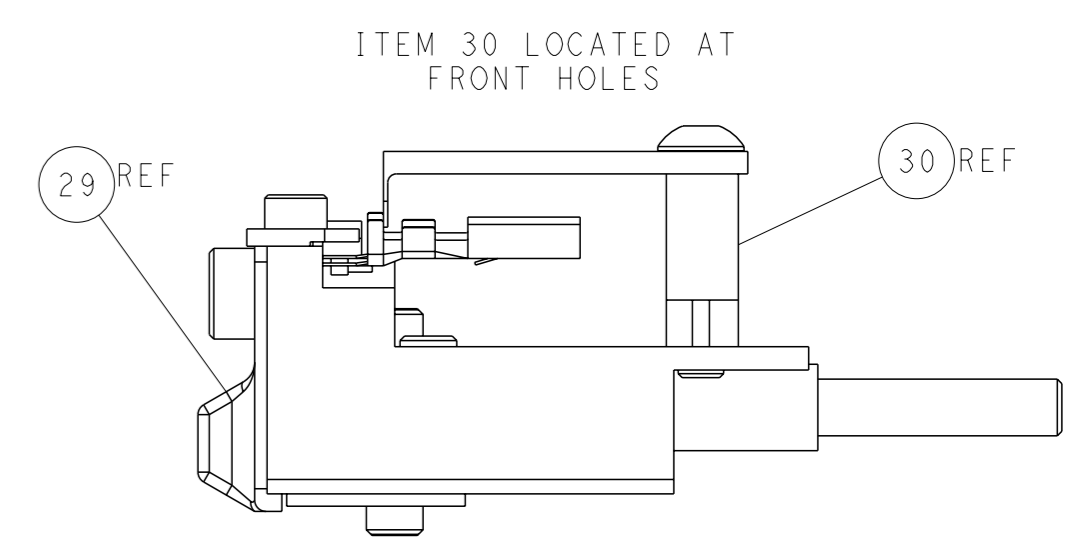
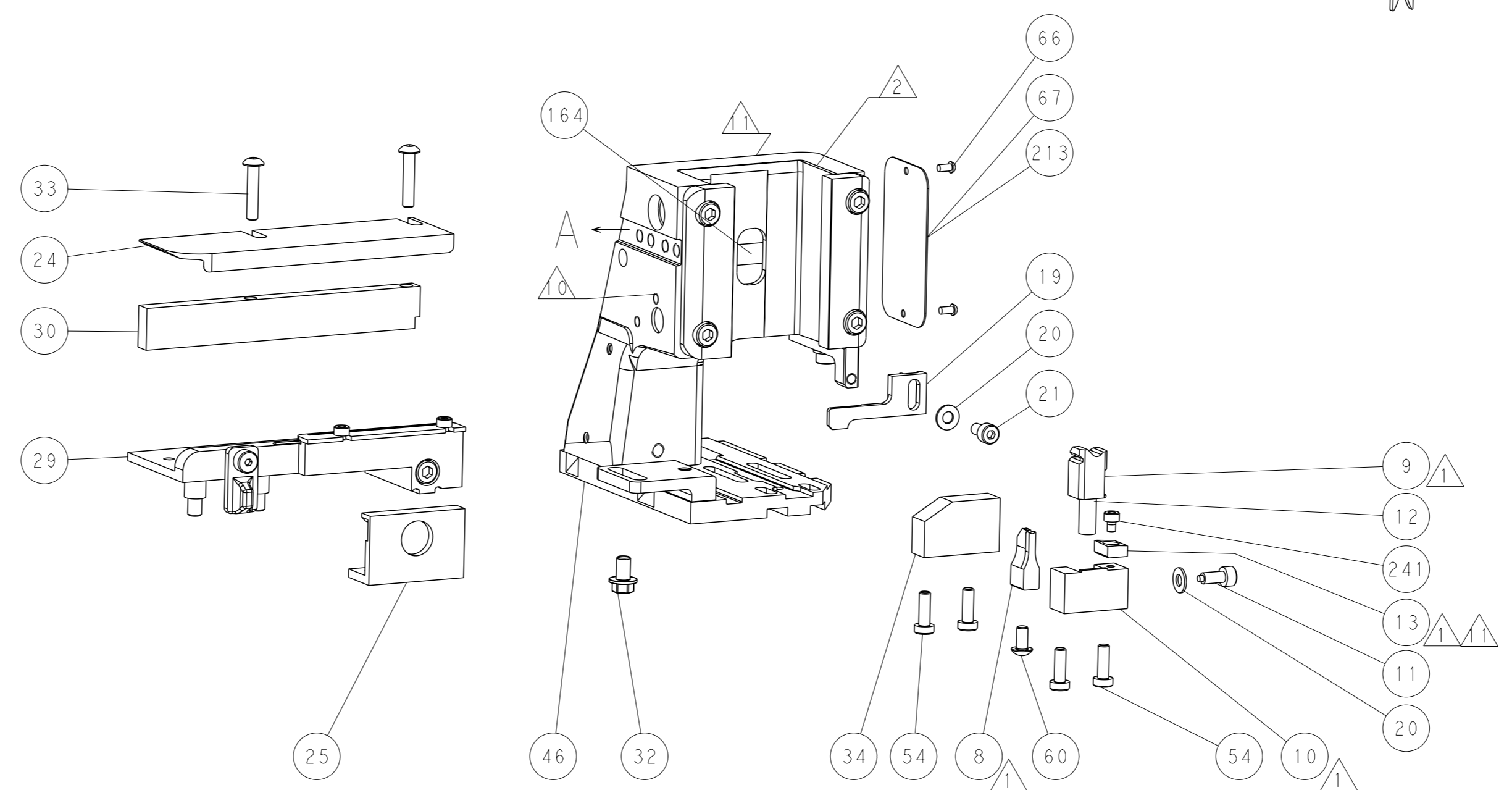
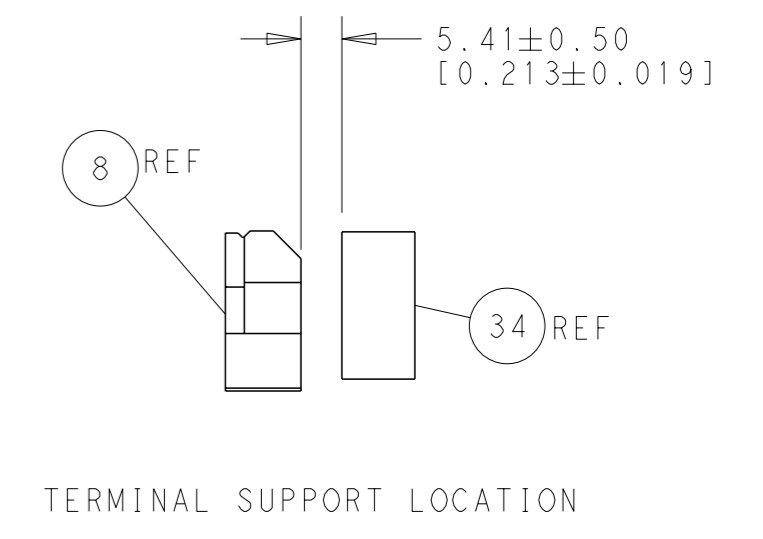
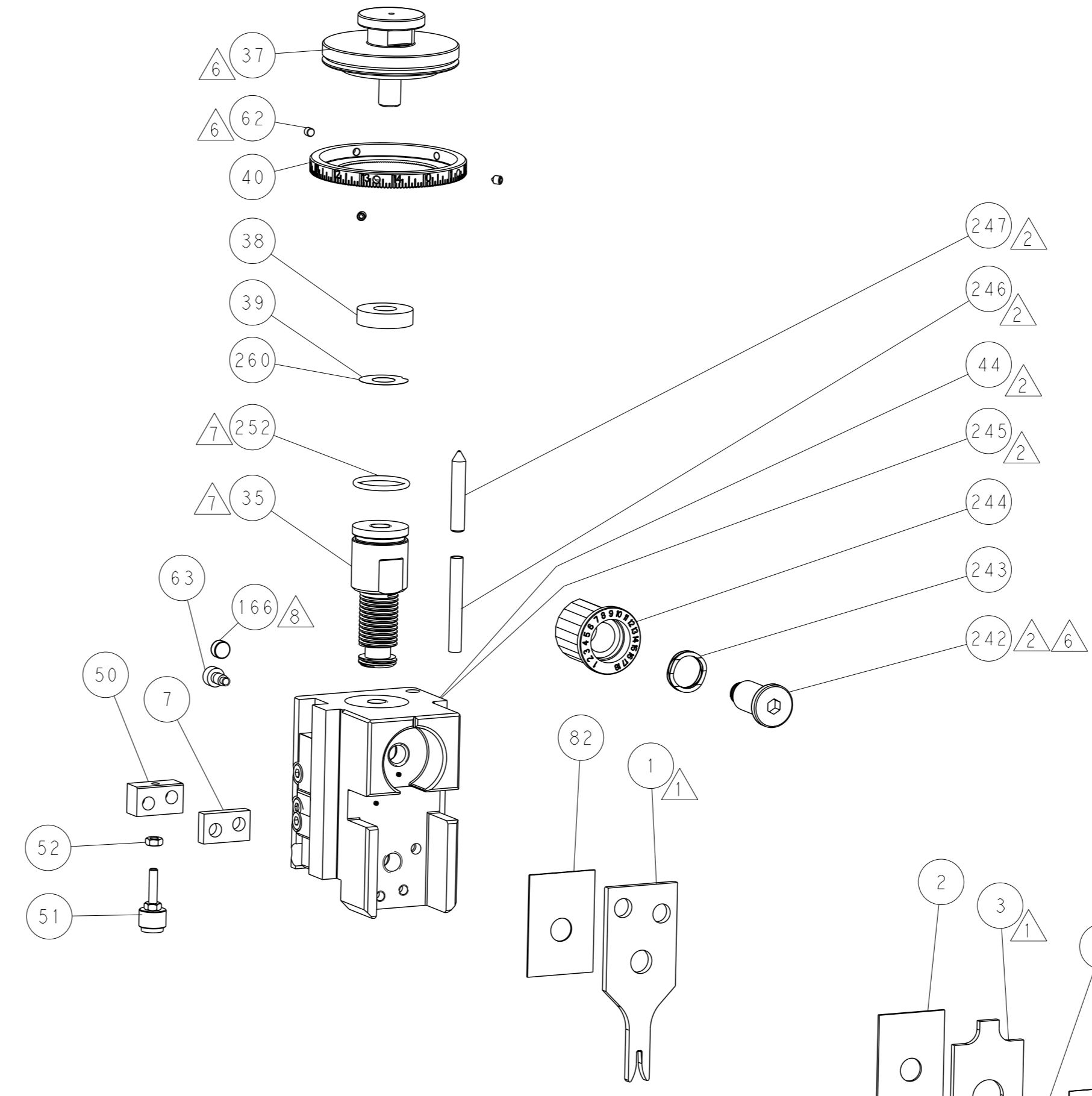
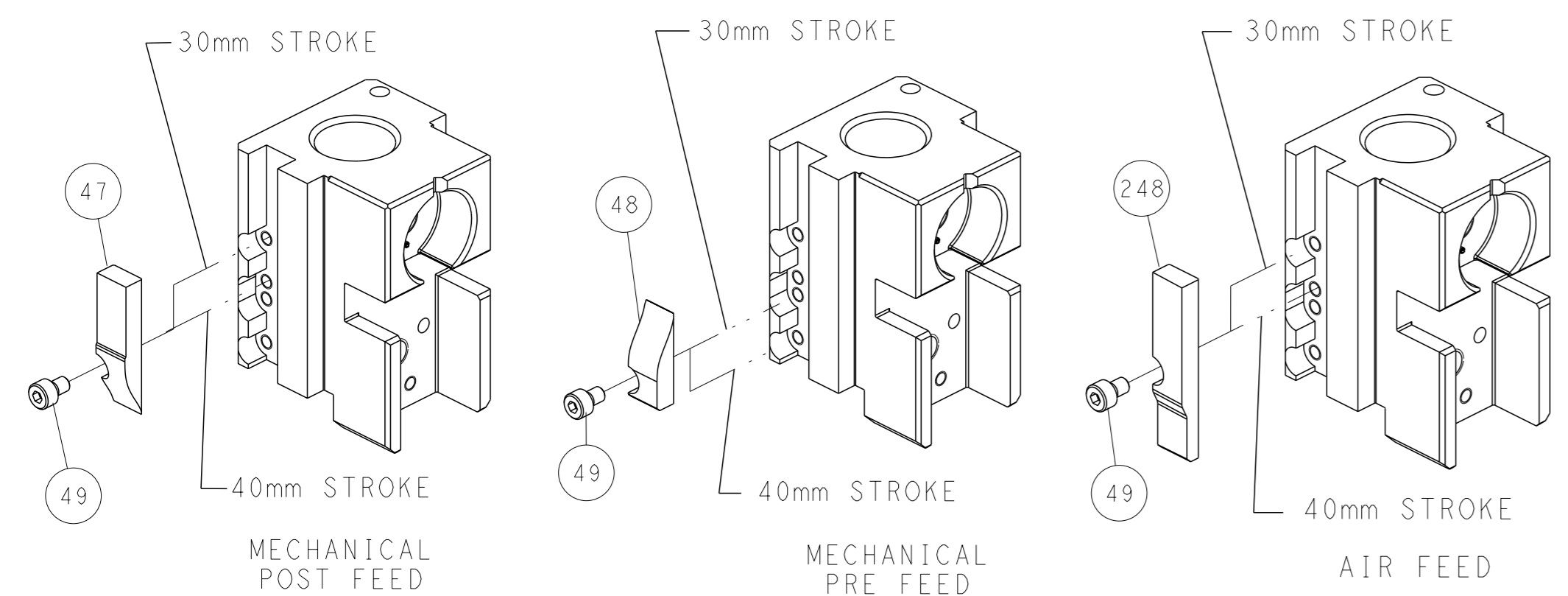
PNEUMATIC



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: HOFFNER 17FEB2015 CBY: TELBIN 18FEB2015 APVD: TELBIN 18FEB2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.001 4 PLC ±0.001 ANGLES FINISH		NAME: Ocean Side Feed Applicator APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266687 SHEET 2 OF 4 REV A
MATERIAL: - FINISH: -		RESTRICTED TO: - Customer Accessible Production Drawing	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266687-1	A	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	-	8-2266687-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266687-4	-	-	-
	2-2266687-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266687-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266687-4	-	-	-
	2-2266687-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	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
	2-2266687-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266687-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.80 mm [.071]	F
INSUL	2.74 mm [.108]	OV
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: FCI/FORD TERMINAL DELPHI/FCI CRIMP SPECIFICATION			
TERMINAL NAME: DCSI 2.8 FEMALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.91-4.11 mm [.115-.162 IN]		Ø1.50-2.10 mm [.059-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	90840400 Rev D02	-	-
TERMINALS APPLIED			
TE TERMINAL	FCI/FORD TERMINAL	TE TERMINAL	FCI/FORD TERMINAL
2113665-1	60010131	2113665-2	89FG14474GBA

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.45 +/- 0.05 [.057 +/- .002]	7.7
0.5 + 0.5	1.40 +/- 0.05 [.055 +/- .002]	8.2
0.5 + 0.35	1.35 +/- 0.05 [.053 +/- .002]	8.7
0.75mm2	1.30 +/- 0.05 [.051 +/- .002]	9.5
0.50mm2	1.25 +/- 0.05 [.049 +/- .002]	10.1

- 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: 8-2266687-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266687-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266687-5
- 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)

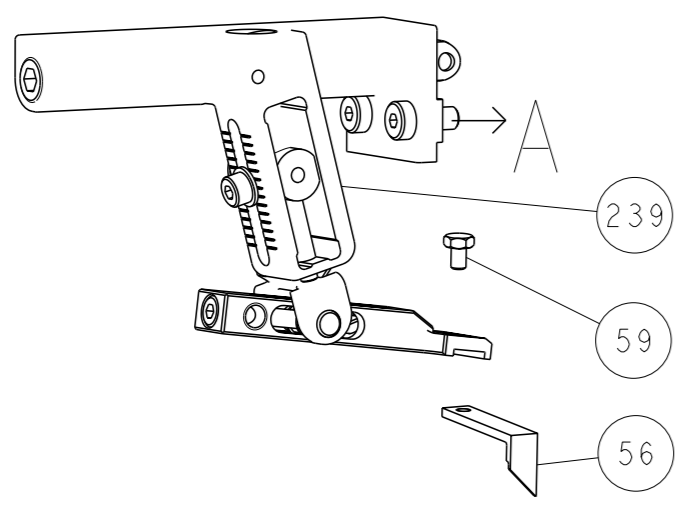
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	-	-	-	SEE SHEET 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	1-22279-3 SPRING, COMPRESSION	246
-	1	1	1	2119082-8 CAM, SMALL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1 RETAINER, INSULATION DIAL	242
-	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
-	-	-	-	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	994969-1 MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2 COUNTER, MAGNETIC	164
-	-	-	1	240638-1 SPRING, FEED FINGER	163
-	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	2119798-2 DETENT PIN	145
-	1	1	1	2079383-8 SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	2168400-5 SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	2119653-2 FEED CAM, POST FEED	142
-	1	1	1	1-2119656-0 APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2119650-1 RAM, ASIAN STYLE, SIDE FEED	140
-	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	455888-5 SPACER, CRIMPER	82
-	1	1	1	2119956-1 DOCUMENTATION PACKAGE	71
-	1	-	1	2119740-1 TAG, IDENTIFICATION	67
-	2	2	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	2119793-1 LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5 SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	1	5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1338683-8 FEED PAWL	56
-	2	2	2	2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	5018030-1 NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5 BUMPER, HOLD DOWN	51
-	1	1	1	690753-2 SPACER, TONKER	50
-	-	-	1	18023-9 SCR, SKT HD CAP M4 X 6.0	49
-	-	-	1	2119652-1 FEED CAM, PRE FEED	48
-	1	1	1	2079383-7 SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	2119957-1 APPLICATOR SHIM PACK	39
-	1	1	1	1-2119644-2 RAM WASHER, PRECISION	38
-	1	1	1	1752356-1 SUPPORT, TERMINAL	34
-	2	2	2	2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	2161328-1 HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1-1320908-2 SPACER, STRIP GUIDE	30
-	1	1	1	2119959-4 ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-3 SPACER, CRIMPER	28
-	1	1	1	240792-1 DRAG, TERMINAL	25
-	1	1	1	1320928-2 STRIP GUIDE	24
-	1	1	1	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	1-18028-2 WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1 STRIPPER, SIDE FEED	19
-	1	1	1	2119806-1 INSERT, SHEAR	13
-	1	1	1	3-22280-3 SPRING, COMPRESSION	12
-	1	1	1	1-356885-4 STOP, SHEAR	11
-	1	1	1	2119805-1 SHEAR HOLDER, FRONT	10
-	1	1	1	1803095-1 FLOATING SHEAR, FRONT	9
-	1	1	1	3-1803171-2 ANVIL, COMBINATION	8
-	1	1	1	2-240641-0 SPACER	7
-	-	-	-	-	6
-	1	1	1	2119757-8 DEPRESSOR, SHEAR	5
-	1	1	1	1-238011-0 BLOCK, CRIMPER SPACER	4
-	1	1	1	6-2119785-8 CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	455888-8 SPACER, CRIMPER	2
-	1	1	1	8-568176-7 CRIMPER, WIRE	1

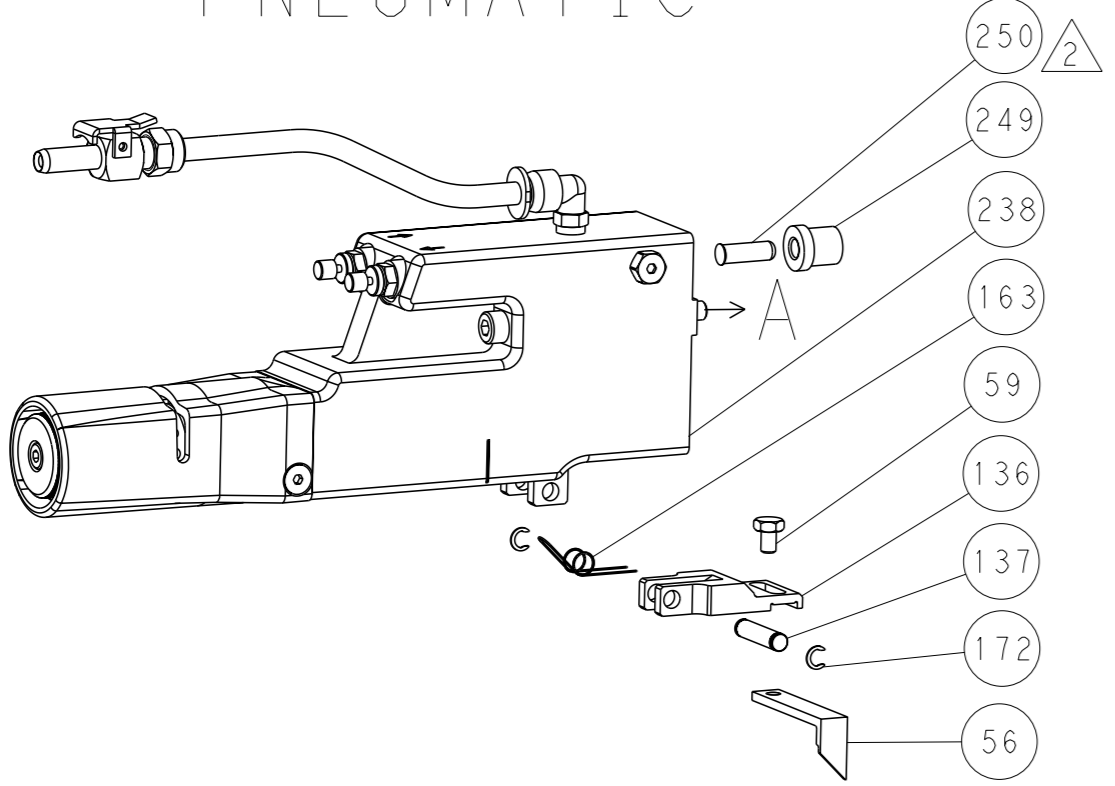
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MATERIAL		APV		NAME	18FEB2015	Ocean Side Feed Applicator
		APV		SIZE	CAGE CODE	DRAWING NO
		APV		WEIGHT	A1	00779 ©=2266687
		APV		Customer Accessible Production Drawing	SCALE	1:2 SHEET 3 of 4 REV A

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

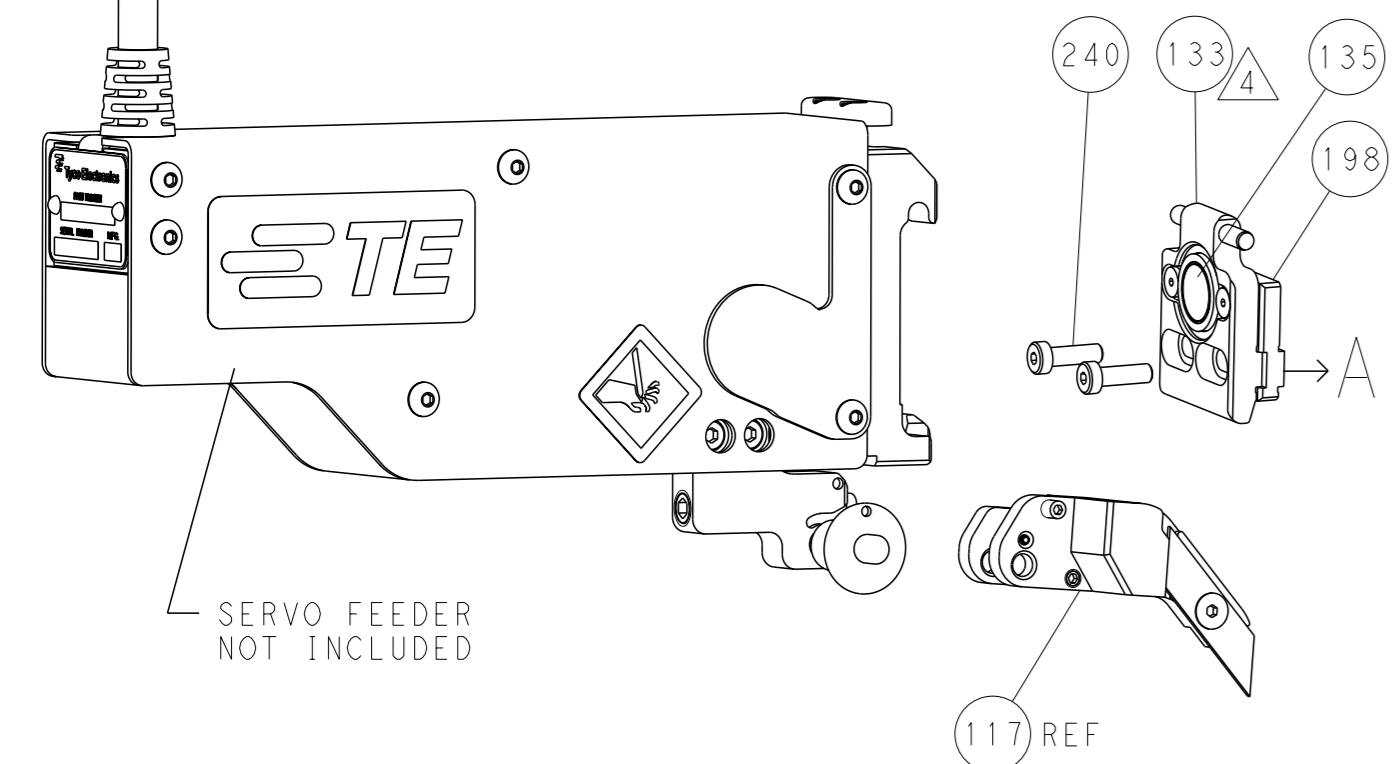
FEED TYPE MECHANICAL



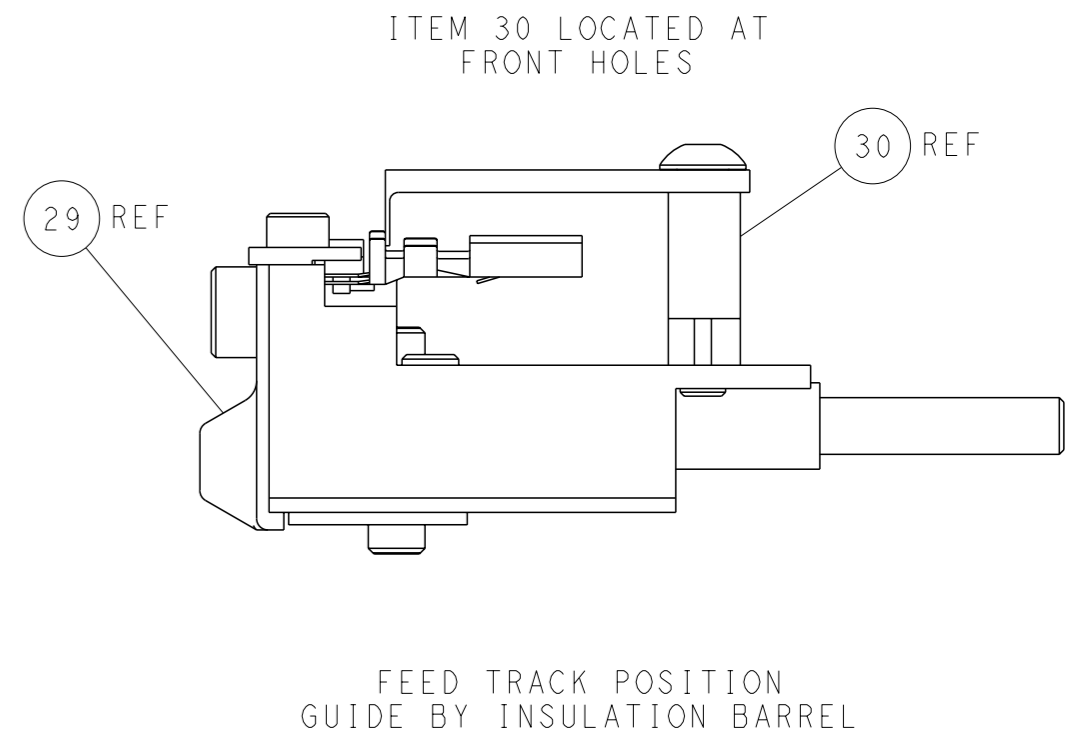
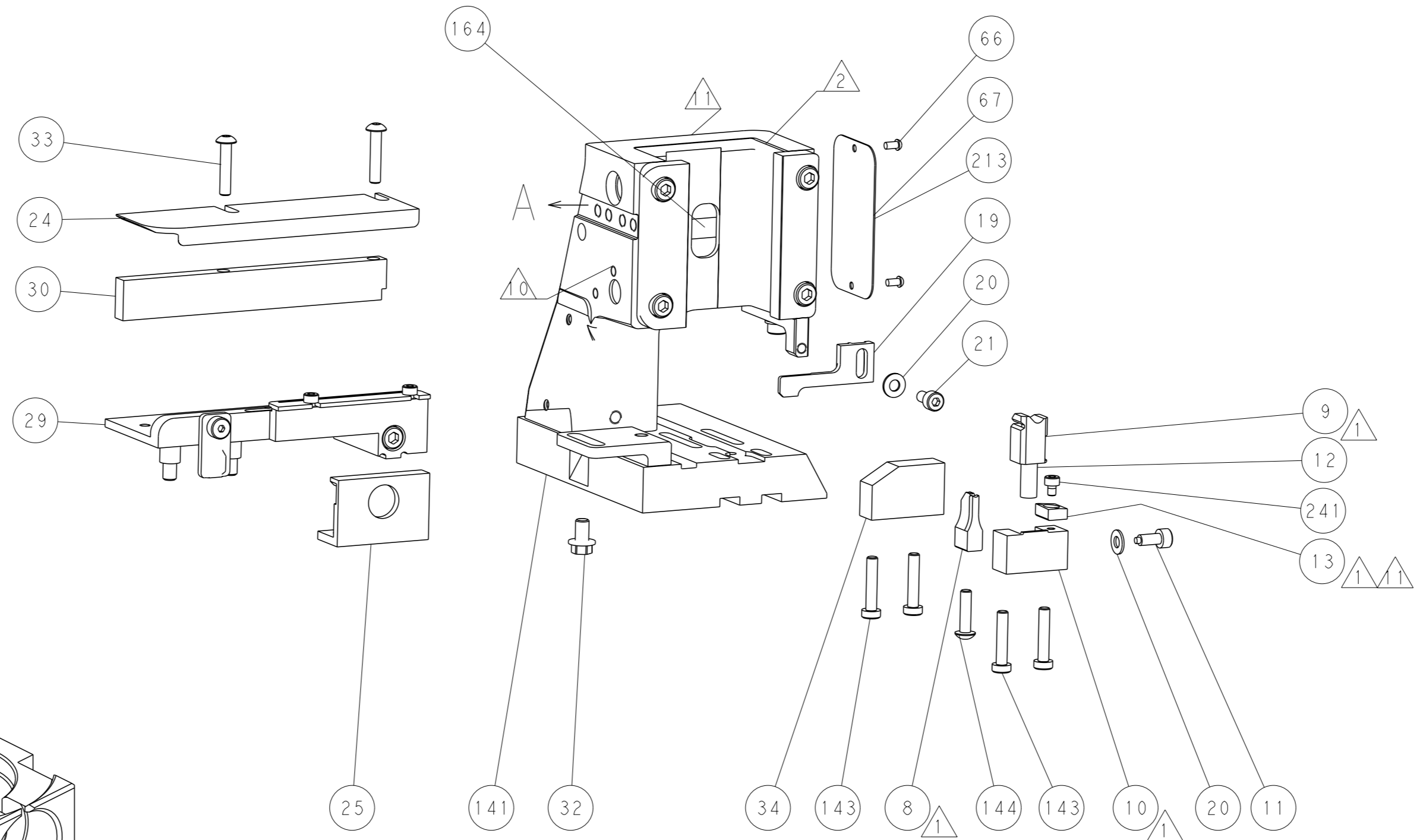
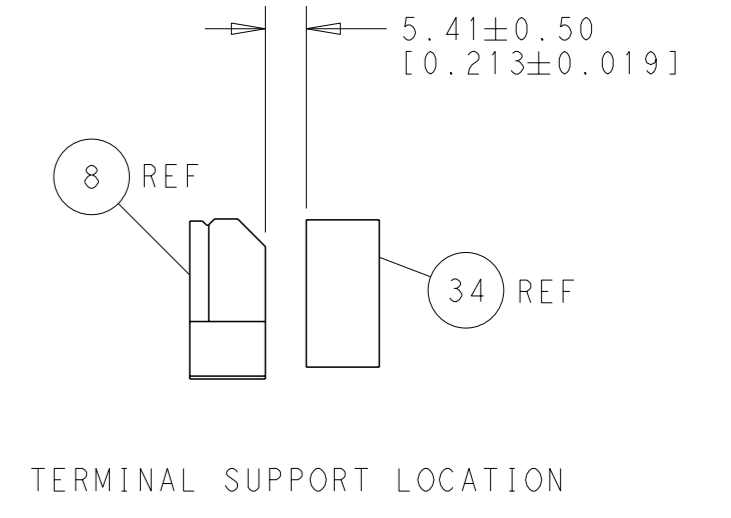
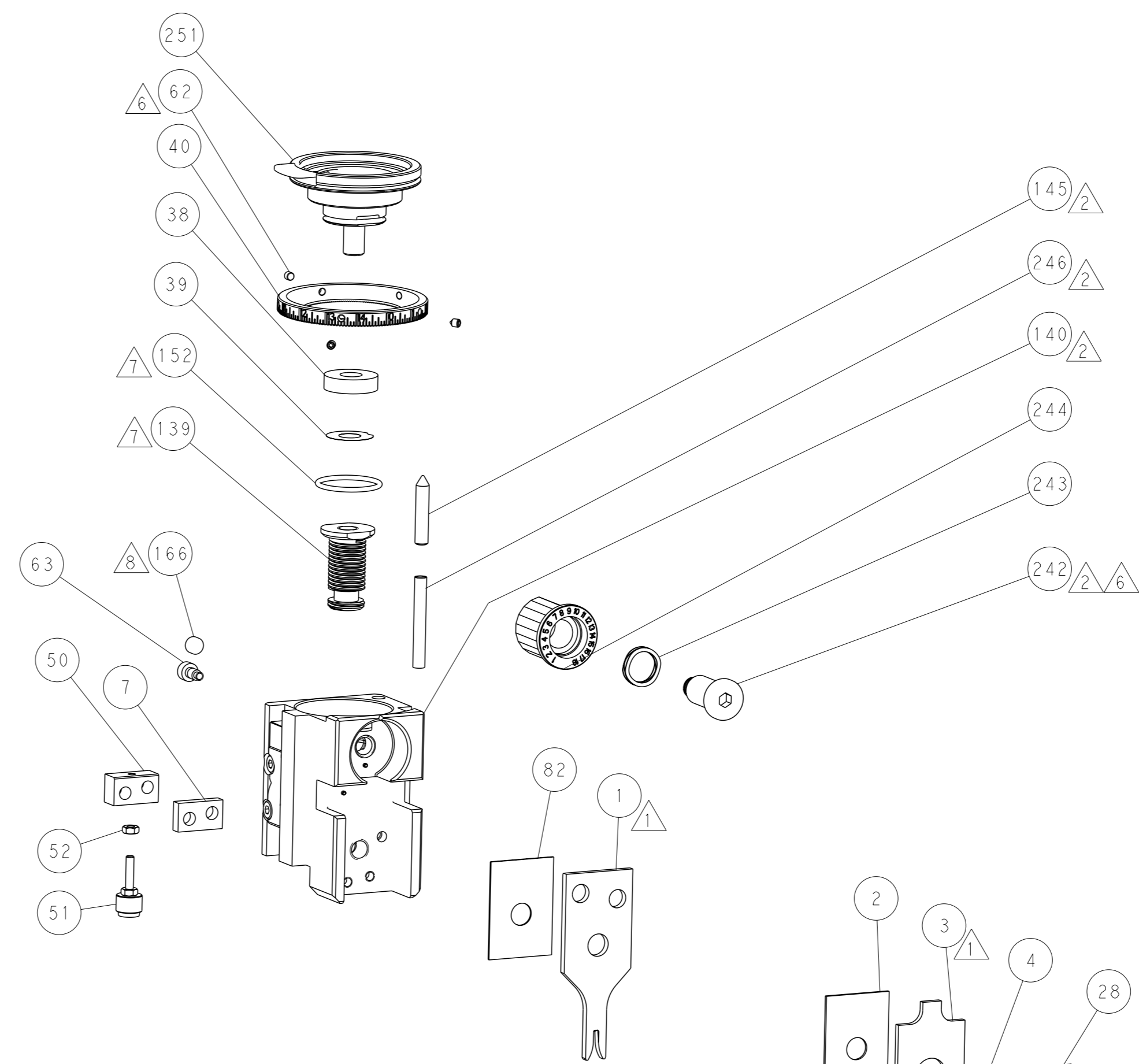
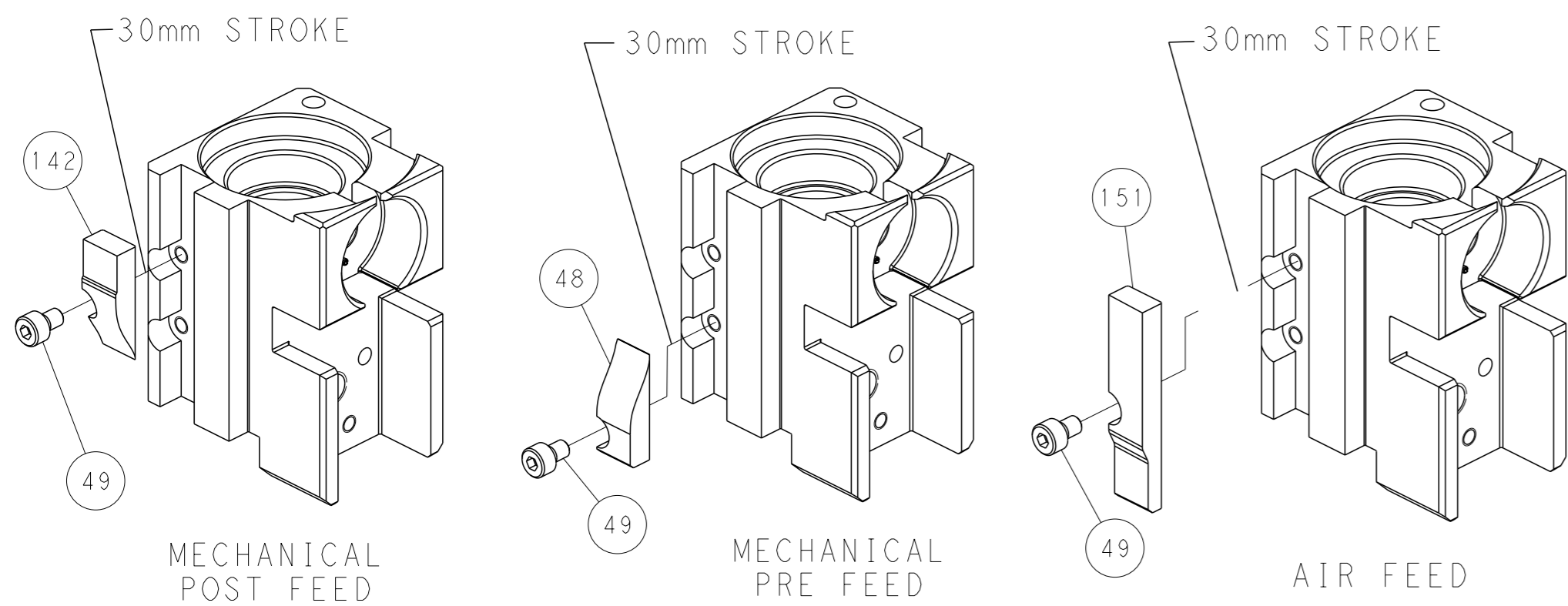
PNEUMATIC



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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MATERIAL: - FINISH: -		Customer Accessible Production Drawing	