

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART									
					CONVERT TO	PART NUMBERS REQUIRED								
	2266089-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	-	-	-	-
	2266089-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119951-1	-	8-2266089-5	1901094-3	3-1752354-0	2168400-6 (QUANTITY 2)	-	-	-	-
	2266089-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2161326-1	-	8-2266089-4	-	-	-	-	-	-	-
	2266089-7	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-2	-	-	-	-
	7-2266089-7	B	CRIMP TOOLING KIT	NONE	-	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [1.160]	F
INSUL	5.84 mm [1.230]	F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL POWER F800			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.75-7.51 mm [1.266-.296 IN]		Ø 5.33 mm MAX [1.210 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	MTA SPECIFICATION	B0-018.004A	
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
1949296-1	17.07660		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.85+/-0.05 [1.112+/-0.002]	7.6
4.0+2.5	2.75+/-0.05 [1.08+/-0.002]	8.5
4.00mm2	2.50+/-0.05 [1.098+/-0.002]	11.3

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266089-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266089-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266089-6
- 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. 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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 3.56.

***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	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	1	1	1	1803078-2	SPACER, PRECISION	259
-	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	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2161314-1	RAM, STEPPED, ATLANTIC, SF, NON-ADJ	245
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	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	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-77	-7	-6	-5	-2	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	#	DATE	OWN	APPD
				1	25OCT2013	YY	UG
				A	11DEC2013	YY	UG
				A1	10JAN2014	XZ	GB
				B	10MAR2015	YY	TE

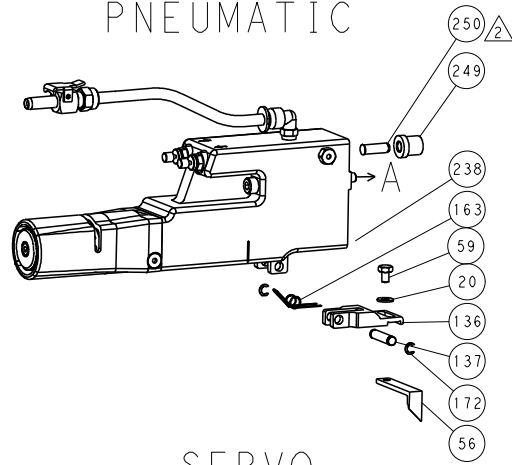
-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	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
-	1	1	1	1	318563-1	GUARD, FRONT CHIP	119
-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1-455888-2	SPACER, CRIMPER	82
-	2	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	1	1	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1	1	1633782-6	FENCE	72
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	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	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1338683-8	FEED PAWL	56
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	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	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	2161311-1	RAM, STEPPED, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1752356-6	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	1320908-3	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	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	1320928-6	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
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	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	1	3-1803171-6	ANVIL, COMBINATION	8
	-	1	1	1	5-240641-0	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-3	BLOCK, CRIMPER SPACER	4
	1	1	1	1	8-2119582-5	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1-455888-2	SPACER, CRIMPER	2
	1	1	1	1	1-456414-2	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	24OCT2013
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	CHK	Y. YIN
	3 PLC ±0.013	4 PLC ±0.001	ANGLES	G. BAILEY	24OCT2013
MATERIAL:	FINISH:	PRODUCT SPEC	APPLICATION SPEC	U. GUO	24OCT2013
				NAME	
				TE Connectivity	
				Harrisburg, PA 17105-3608	
				Ocean Side Feed	
				Applicator	
				SHEET	00779
				CAGE CODE	2266089
				DRAWING NO	
				RESTRICTED TO	
				Customer Accessible Production Drawing	
				SCALE	1:2
				SHEET	1 of 4
				REV	B

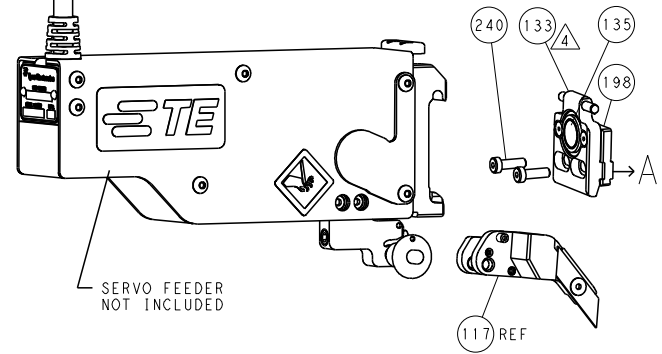
REVISONS		DATE	DWN	APVD
#	LYR	DESCRIPTION		
-	-	SEE SHEET 1	-	-

FEED TYPE

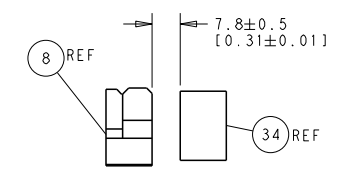
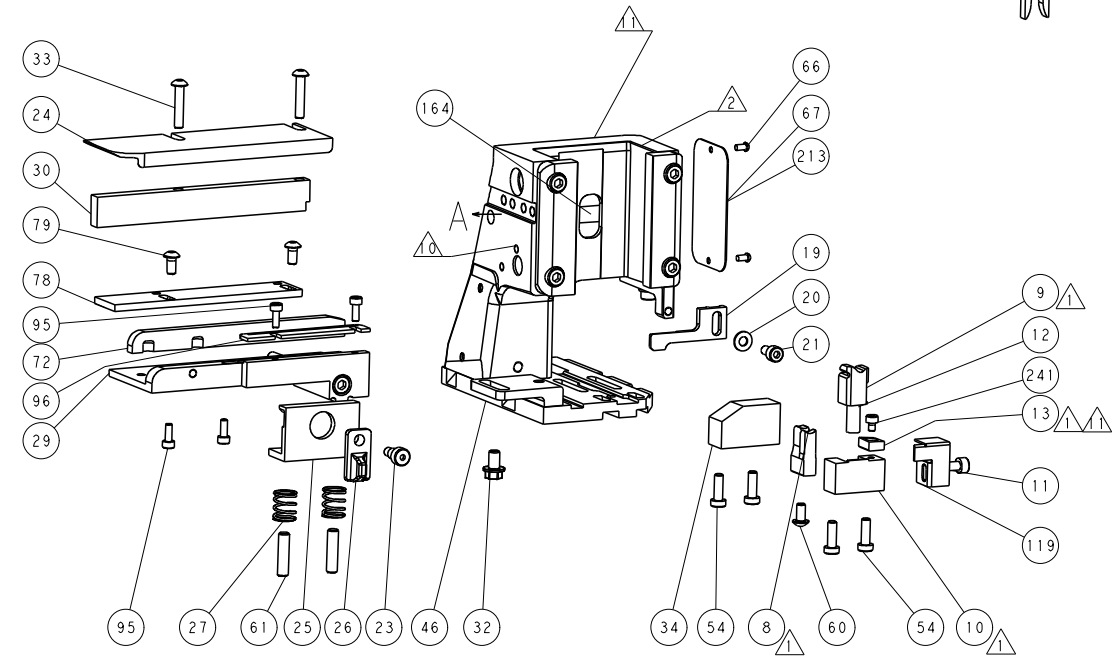
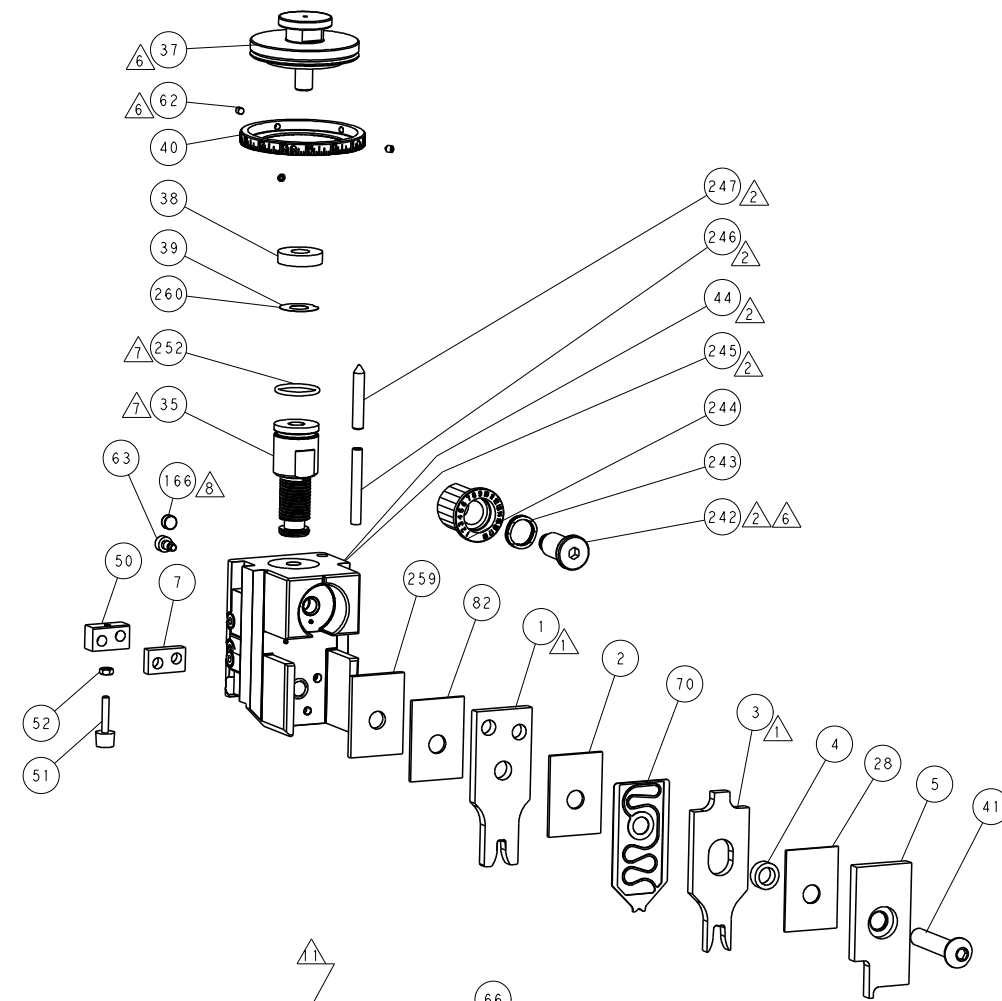
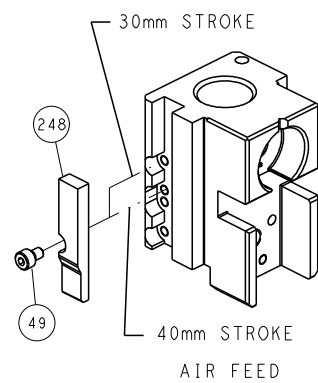
PNEUMATIC



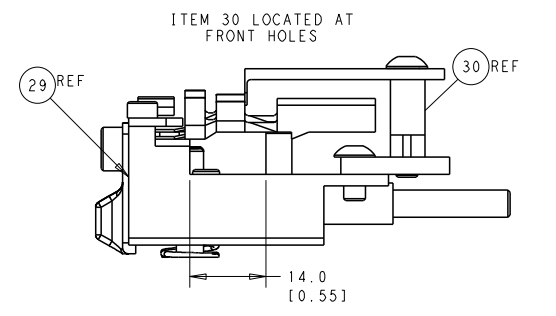
SERVO LATCH PLATE



CAM POSITION



TERMINAL SUPPORT LOCATION



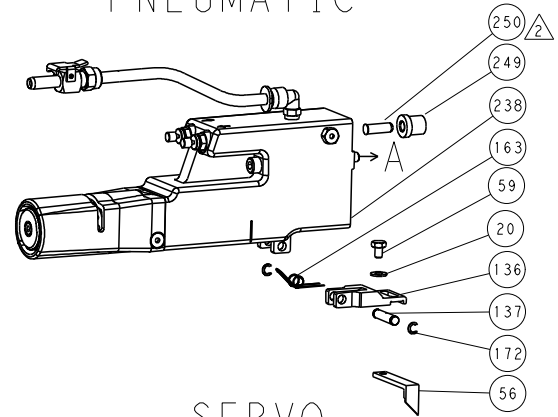
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

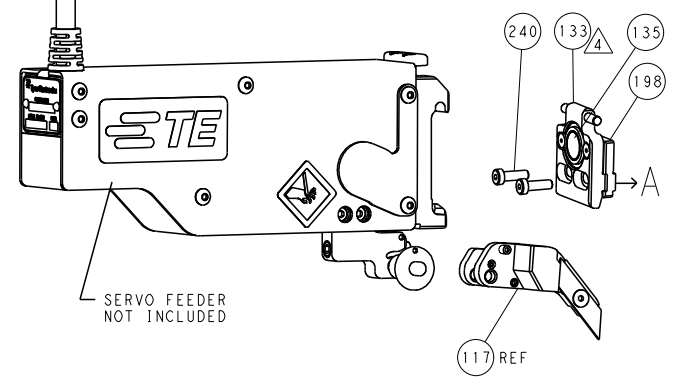
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN	Y. YIN	24OCT2013	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	CHK	G. BAILEY	24OCT2013	
	3 PLC ±0.013	4 PLC ±0.0001	ANGLES ±	APVD	U. GUO	24OCT2013	NAME
MATERIAL:	FINISH:	WEIGHT:	SCALE	APPLICATION SPEC		SHEET	2 of 4
			1:2	Customer Accessible Production Drawing		00779	REV B

LOC		DIST		REVISIONS			
A	66	#	LTN	DESCRIPTION	DATE	OWN	APPD
		-	-	SEE SHEET 1			

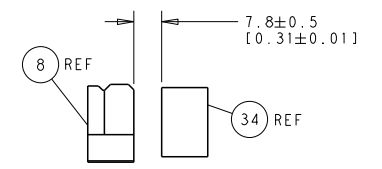
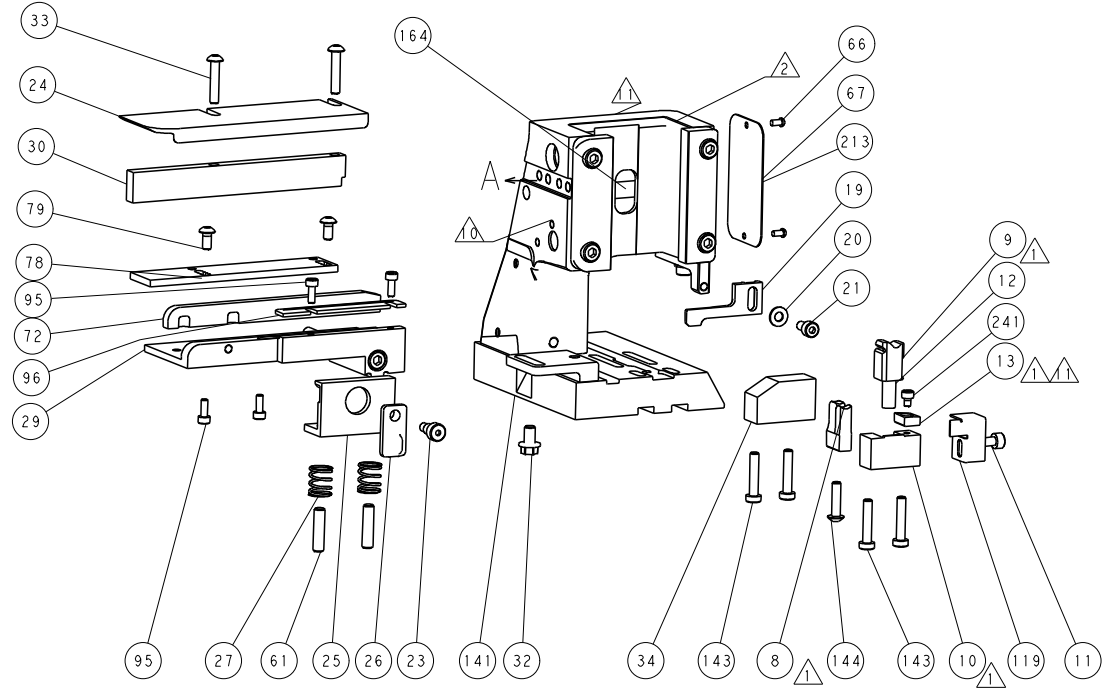
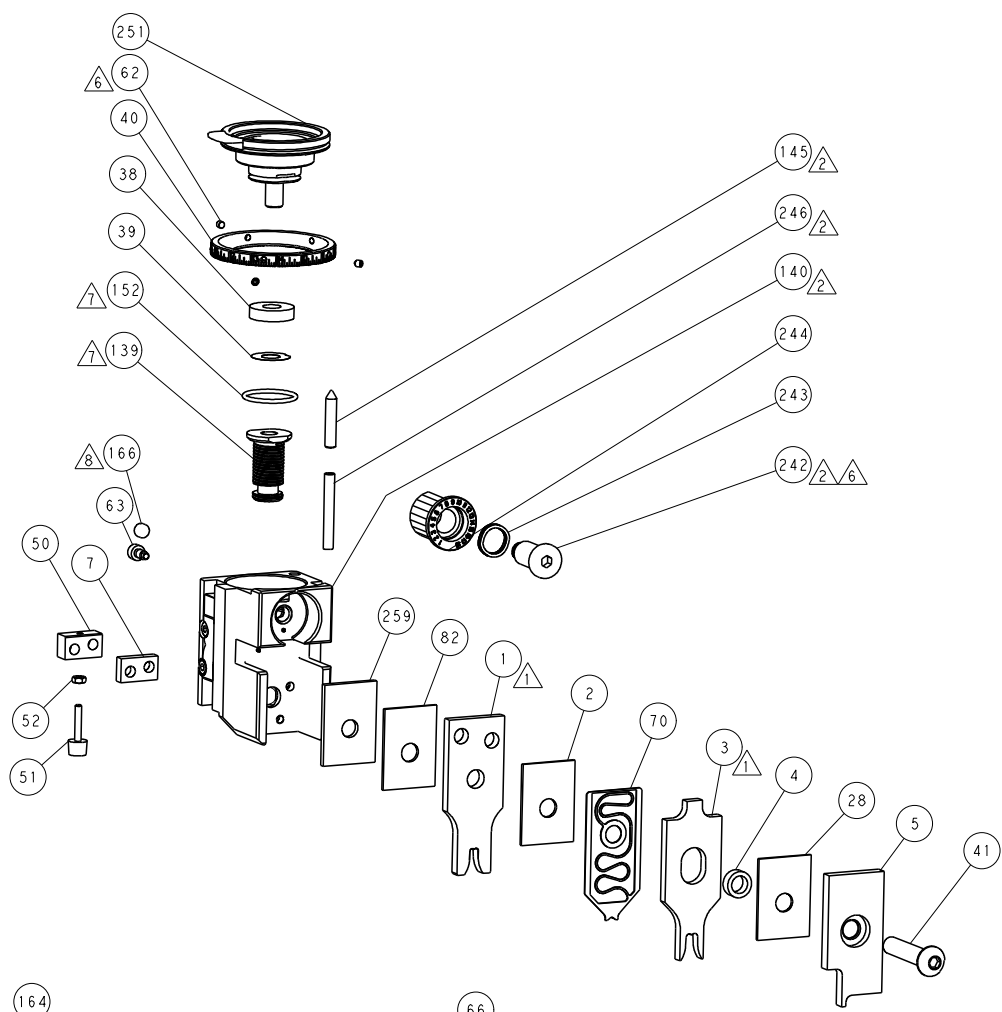
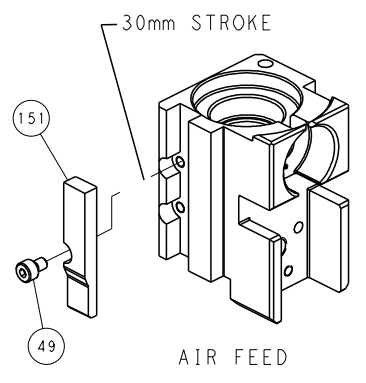
FEED TYPE PNEUMATIC



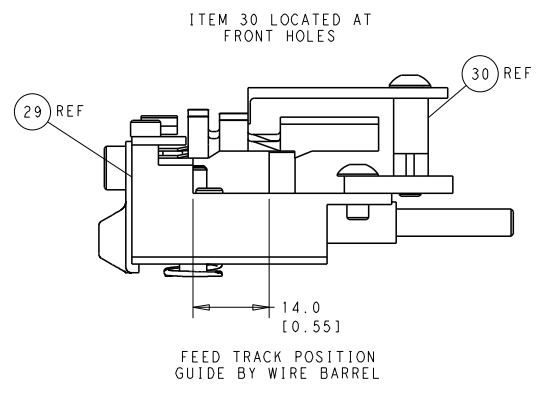
SERVO LATCH PLATE



CAM POSITION



TERMINAL SUPPORT LOCATION



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:		DWN Y. YIN 24OCT2013		CHK G. BAILEY 24OCT2013		APPRO U. GUO 24OCT2013		NAME	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0001	PRODUCT SPEC		APPLICATION SPEC		OCEAN SIDE FEED APPLICATOR	
MATERIAL:	FINISH:	WEIGHT:		SCALE 1:2		SHEET 4 of 4		REV B		RESTRICTED TO	