

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.70 mm [.106]	F

TERMINAL DATA: HU LANE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 070 TYPE FEMALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.25-4.42 mm [.128-.174 IN]		Ø0.00-2.29 mm [.000-.090 IN]	
TERMINAL APPLICATION SPECIFICATION			
NONE			

TERMINALS APPLIED			
TE TERMINAL	HU LANE TERMINAL	TE TERMINAL	HU LANE TERMINAL
2113488-1	6618604KSS	2113488-3	6618604BSS
2113488-2	6618604KS5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.94 +/- 0.05 [.037 +/- .002]	5.4
0.30mm2	0.84 +/- 0.05 [.033 +/- .002]	6.4

- 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: 8-2266348-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266348-5  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266348-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266348-6
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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- 7** GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8** MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12** WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.86.

**\*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	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-77	-7	-6	-5	-2	-1	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)

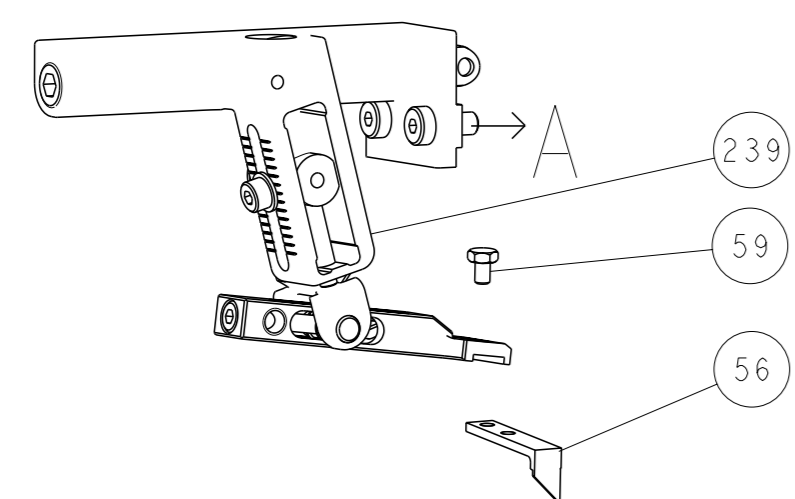
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1		ORIGINAL	02JUL2014	GH	TE
A		RELEASED	11AUG2014	GH	GB

F	LT#	DESCRIPTION	DATE	OWN	APPD			
-	-	1	-	-	-			
-	-	-	1	-	2119640-1			
-	-	-	-	-	2079988-1			
-	-	-	1	-	2119641-1			
-	1	-	1	1	2119798-1			
-	1	-	1	1	1-22279-3			
-	1	-	1	1	2119758-1			
-	1	1	1	1	2119082-3			
-	1	1	1	1	2079764-1			
-	1	1	1	1	2119083-1			
-	1	1	1	1	7-18023-7			
-	-	2	2	-	2168400-6			
-	-	-	-	1	2119580-1			
-	-	-	-	1	2063440-1			
-	-	1	1	-	2119740-2			
-	-	1	1	-	1901094-3			
-	-	-	2	-	21045-3			
-	1	1	1	1	994969-1			
-	REF	REF	REF	REF	994970-2			
-	-	-	1	-	240638-1			
-	-	-	-	1	3-23627-7			
-	-	-	-	1	2119799-1			
-	-	REF	REF	-	SEE NOTE 4			
-	1	1	-	-	1633743-1			
-	-	REF	REF	-	2119944-1			
-	1	1	1	1	2119955-1			
-	1	1	1	1	455888-4			
-	1	1	1	1	2119956-1			
-	1	-	-	1	2119740-1			
-	2	2	2	2	2168078-1			
-	1	-	1	1	2119793-1			
-	3	-	3	3	992763-5			
-	1	1	1	1	2079383-4			
-	-	-	-	1	5-18022-5			
-	-	-	-	1	1338685-1			
-	4	4	4	4	2168400-1			
-	2	2	2	2	1-2168083-0			
-	1	1	1	1	5018030-1			
-	1	1	1	1	811242-5			
-	1	1	1	1	690753-2			
-	-	-	-	1	2			
-	-	-	-	1	2119652-1			
-	-	-	-	1	2119653-1			
-	1	1	1	1	2119656-9			
-	1	-	-	1	2119370-1			
-	1	1	1	1	2079383-7			
-	1	-	-	1	2119645-1			
-	1	-	-	1	2119957-1			
-	1	1	1	1	1-2119644-4			
-	1	1	1	1	2119085-1			
-	1	-	-	1	2119092-1			
-	1	1	1	1	1752356-1			
-	2	2	2	2	2079383-5			
-	1	1	1	1	2161328-1			
-	1	1	1	1	1-1320908-0			
-	1	1	1	1	2119959-1			
-	1	1	1	1	455888-3			
-	1	1	1	1	1320928-2			
-	1	1	1	1	2168083-2			
-	2	2	2	2	1-18028-2			
-	1	1	1	1	2119533-1			
-	1	1	1	1	2119806-1			
-	1	1	1	1	3-22280-3			
-	1	1	1	1	1-356885-4			
-	1	1	1	1	2119805-1			
-	1	1	1	1	1803095-1			
-	1	1	1	1	1-1803058-5			
-	-	-	-	-	-			
-	-	-	-	-	-			
-	1	1	1	1	2119757-8			
-	1	1	1	1	1-238011-8			
-	1	1	1	1	5-2119582-6			
-	1	1	1	1	455888-5			
-	1	1	1	1	456403-4			
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

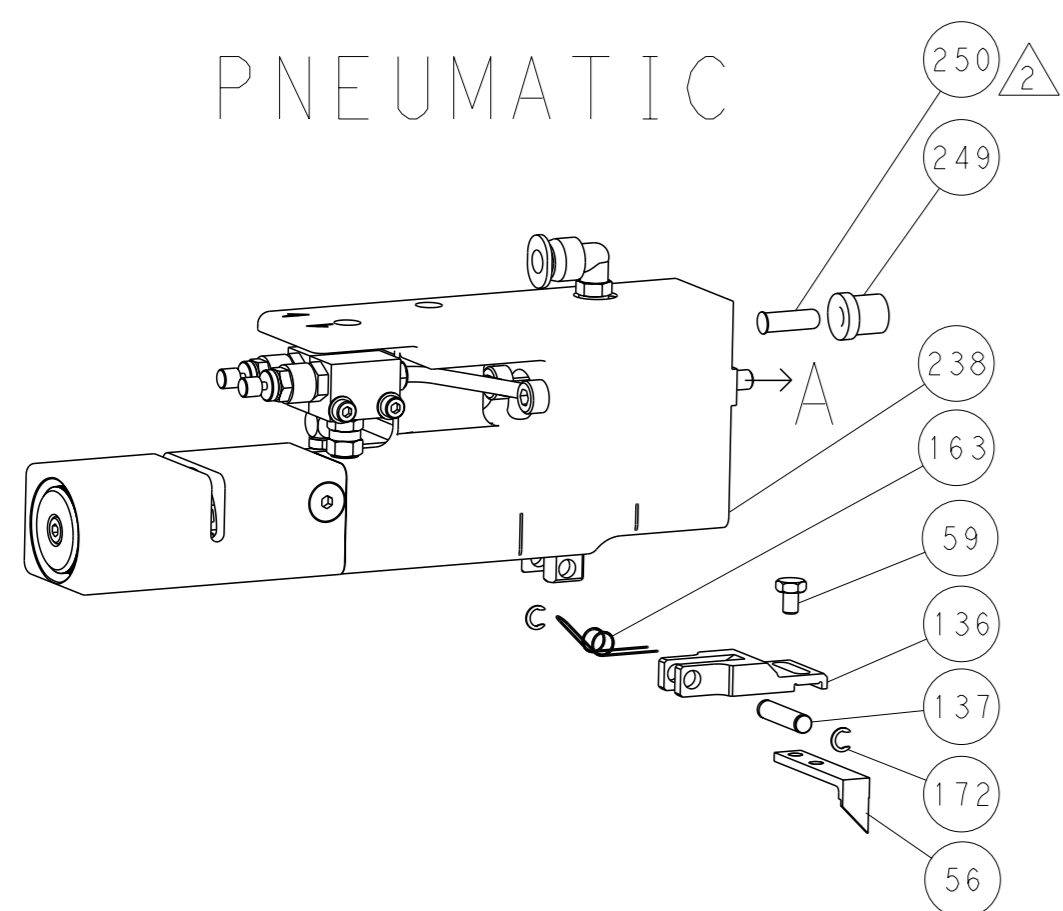
IF IT IS DIFFICULT TO CRIMP AND THE CONTACTS ARE IN THE CORRECT POSITION, THE CONTACTS SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN HOFFNER DATE 1 JULY 2014	CHK T. ELBIN DATE 2 JULY 2014	NAME Ocean Side Feed Applicator			RESTRICTED TO -		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED T. ELBIN PRODUCT SPEC	APPLICATION SPEC -	SCALE 1:2	SHEET 1 of 4	REV A	
mm		0 PLC ±.5 1 PLC ±.5 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1°		FINISH -	WEIGHT -	SIZE A1	CAGE CODE 00779	DRAWING NO. C=2266348	
MATERIAL -				Customer Accessible Production Drawing			SCALE 1:2	SHEET 1 of 4	REV A

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

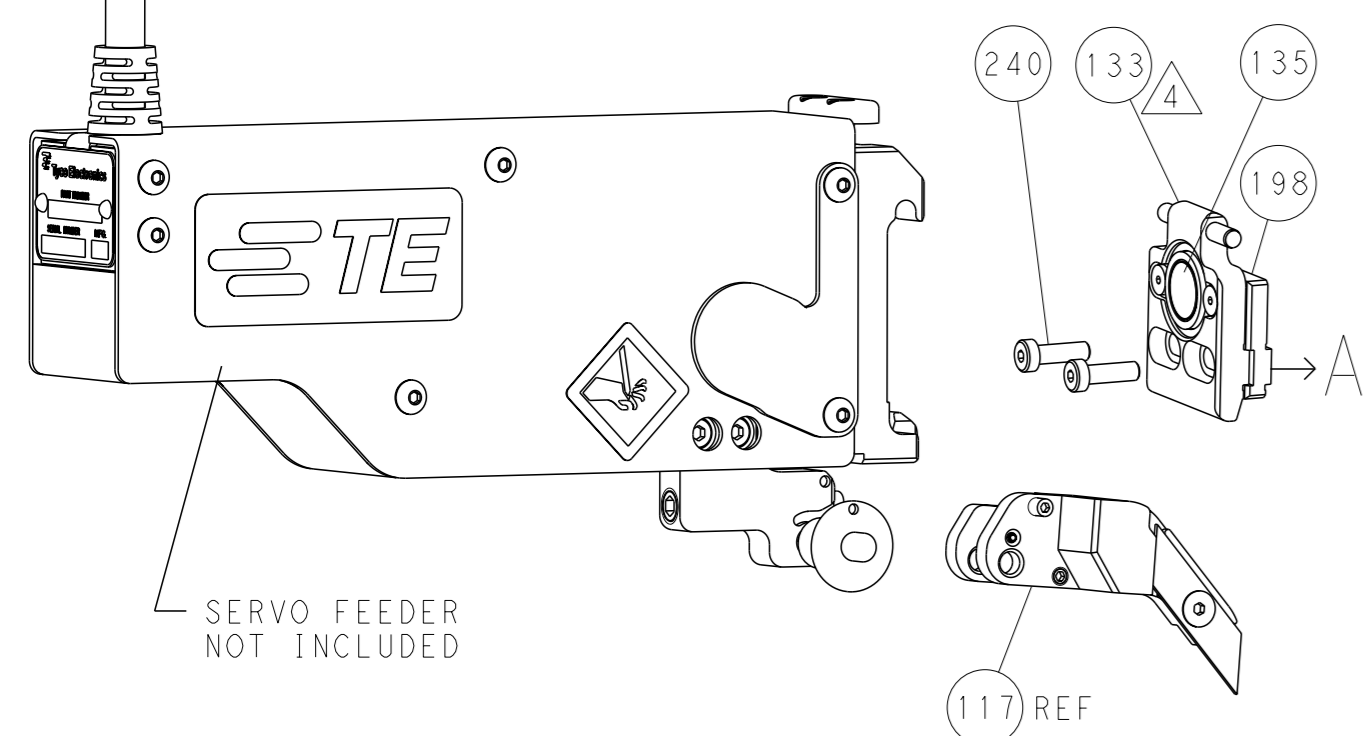
### FEED TYPE MECHANICAL



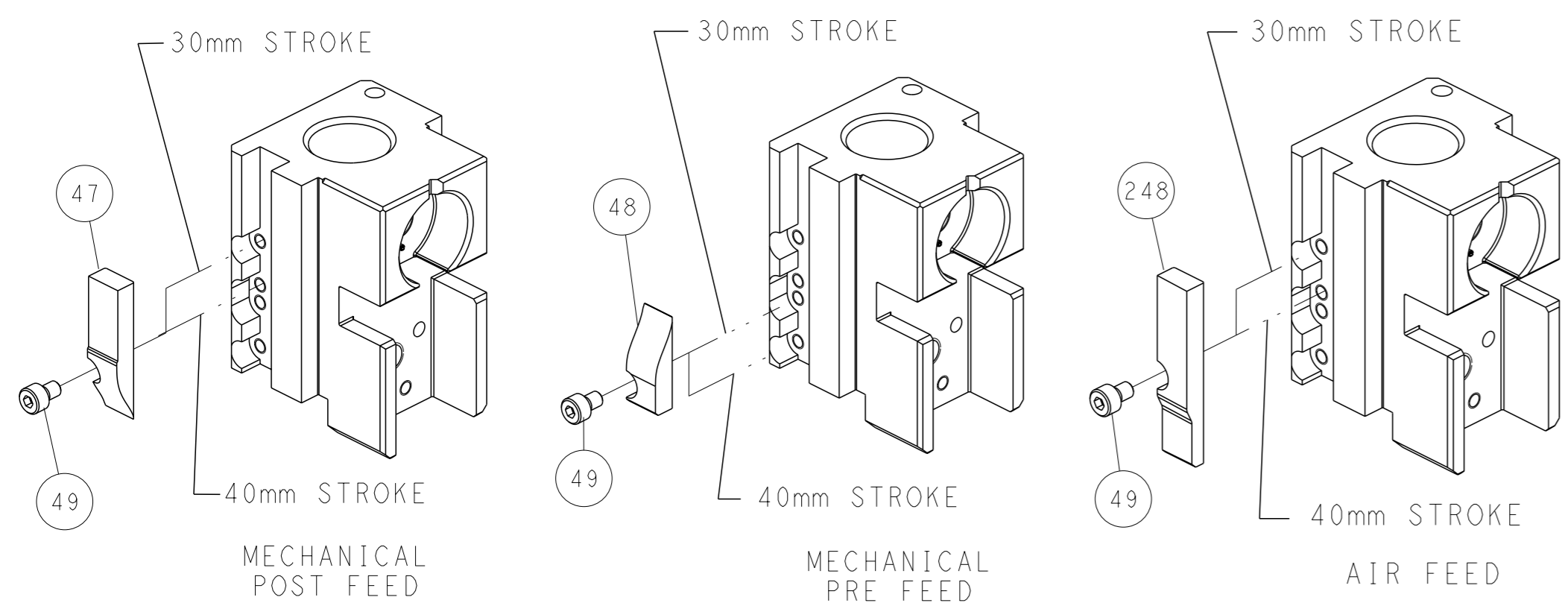
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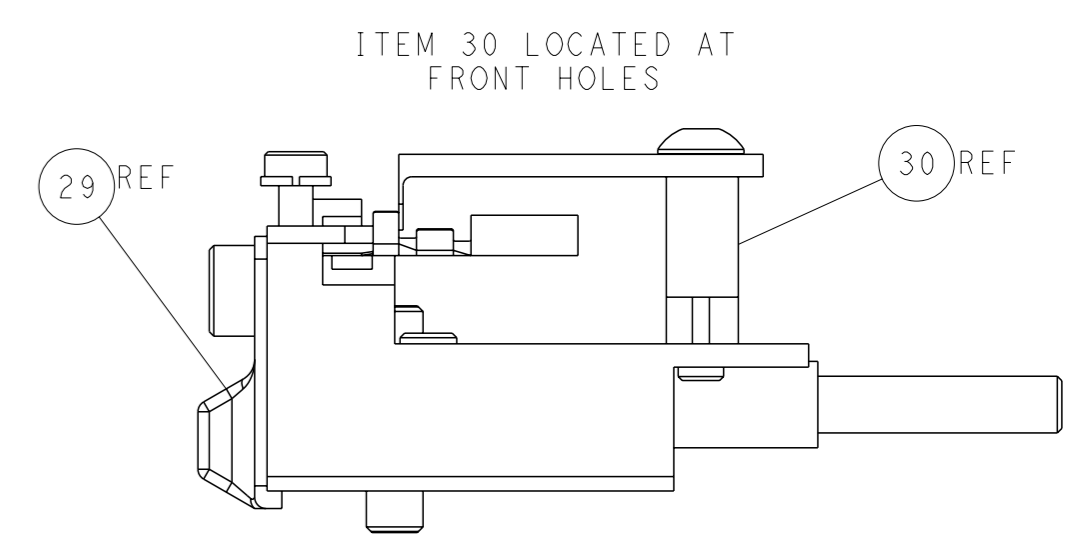
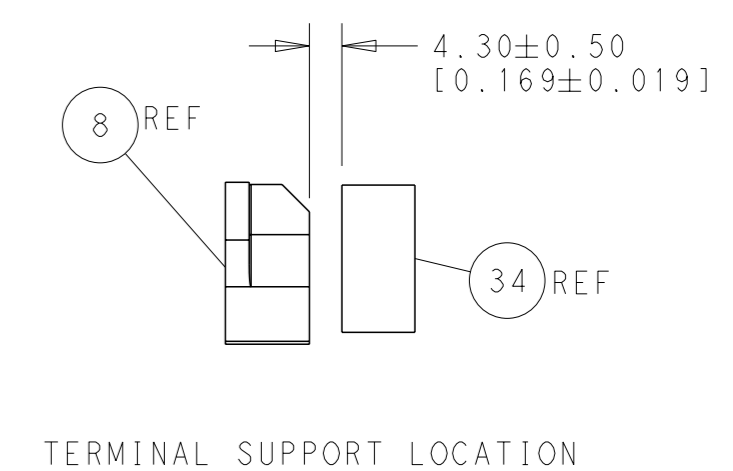
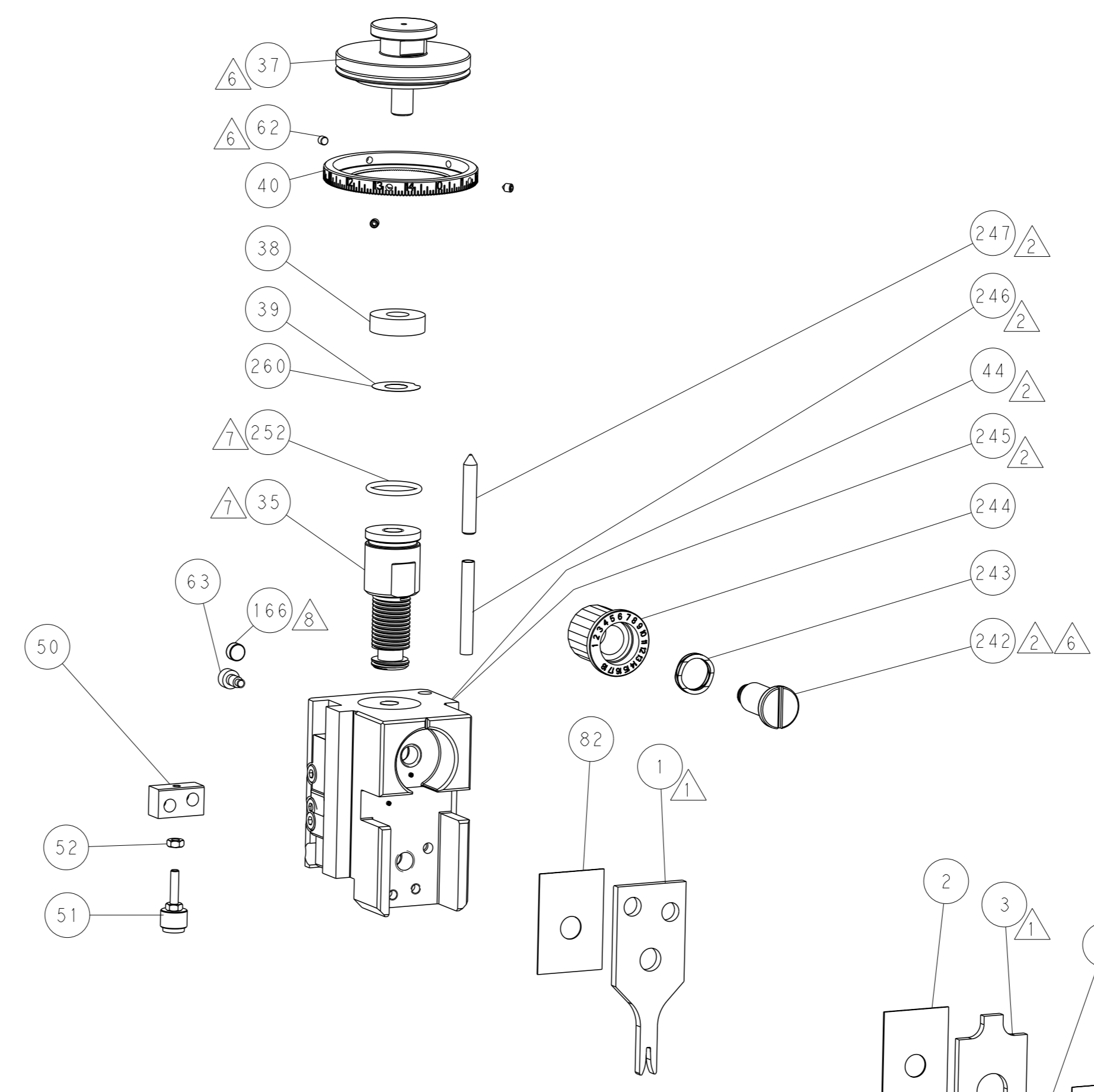
### SERVO LATCH PLATE



### CAM POSITIONS



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



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		REV	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±	FINISH -
MATERIAL	-	WEIGHT	-	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
-	-	-	-	A	00779	©=2266348	-
Customer Accessible Production Drawing				SCALE	1:2	SHEET	2 of 4
				REV	A		

**APPLICATOR STYLE CONVERSION CHART**

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
					PNEUMATIC FEED	MECHANICAL FEED	MECHANICAL FEED	PNEUMATIC FEED	MECHANICAL FEED	PNEUMATIC FEED
2-2266348-1	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	-	8-2266348-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2266348-4	-	-	
2-2266348-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
				SERVO LATCH PLATE	2119951-1	-	8-2266348-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2266348-4	-	-	
2-2266348-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	
2-2266348-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2266348-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

**APPLICATOR DATA**

CRIMP	SIZE	TYPE
WIRE	1.57 mm (.062)	F
INSUL	2.70 mm (.106)	F

APPLICATOR INSTRUCTIONS 408-10389

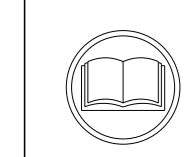
TERMINAL DATA: HU LANE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 070 TYPE FEMALE TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.25-4.42 mm (.128-.174 IN)	Ø0.00-2.29 mm (.000-.090 IN)

TE TERMINAL	HU LANE TERMINAL	TE TERMINAL	HU LANE TERMINAL
2113488-1	6618604KSS	2113488-3	6618604BSS
2113488-2	6618604KS5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.94 +/- 0.05 [0.037 +/- .002]	5.4
0.30mm2	0.84 +/- 0.05 [0.033 +/- .002]	6.4



- △ 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: 8-2266348-4
  - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266348-4
  - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266348-5
- 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.
- △ 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.

REVISIONS			
REV	DATE	OWN	APPV
-	-	-	-
-	-	-	-

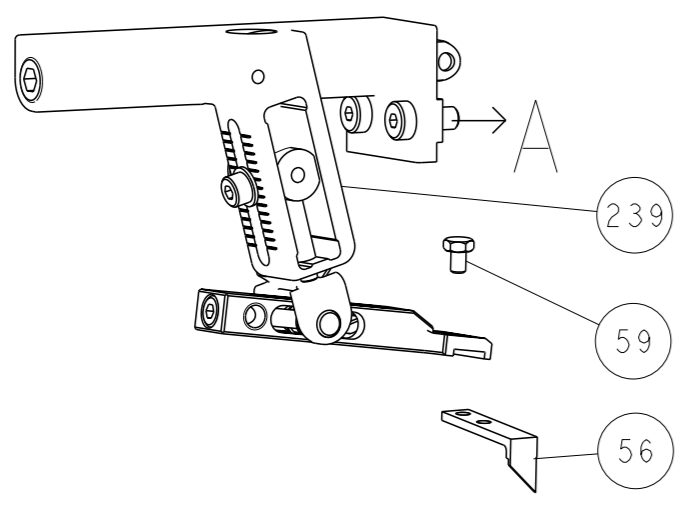
REV	DATE	OWN	APPV	DESCRIPTION
-	-	-	-	SEE SHEET 1
-	1	1	1	2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE
-	-	-	1	2119640-1 PUSH ROD, AIR FEED
-	-	-	1	2079988-1 BUSHING, LCH5-12, MISUMI
-	1	1	1	1-22279-3 SPRING, COMPRESSION
-	1	1	1	2119082-3 CAM, SNAIL, INSULATION ADJUSTMENT
-	1	1	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST
-	1	1	1	2119083-1 RETAINER, INSULATION DIAL
-	1	1	1	7-18023-7 SCR, SKT HD CAP M3 X 4.0
-	-	2	-	2168400-6 SHCS, LOW HEAD, RoHS, M5 X 16
-	-	-	-	2119580-1 MECHANICAL FEED ASSEMBLY
-	-	-	1	2063440-1 AIR FEED MODULE
-	-	1	-	2119740-2 TAG, IDENTIFICATION
-	-	1	-	1901094-3 SPACER, FEEDER
-	-	-	2	21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT
-	1	1	1	994969-1 MAGNET, RARE EARTH HIGH ENERGY
-	REF	REF	REF	994970-2 COUNTER, MAGNETIC
-	-	-	1	240638-1 SPRING, FEED FINGER
-	1	1	1	8-21084-1 O-RING, .801 ID, .070 DIA, MAT.
-	-	-	1	2119641-2 FEED CAM, AIR FEED
-	1	1	1	2119798-2 DETENT PIN
-	1	1	1	2079383-8 SCR, BHSC, RoHS (M4 X 16)
-	4	4	4	2168400-5 SHCS, LOW HEAD, RoHS, M4 X 20
-	-	-	-	2119653-2 FEED CAM, POST FEED
-	1	1	1	1-2119656-0 APPLICATOR BASIC ASSEMBLY, SF
-	1	1	1	2119650-1 RAM, ASIAN STYLE, SIDE FEED
-	1	1	1	2119092-2 BOLT, ADJUSTMENT
-	-	-	-	3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854
-	-	-	1	2119799-1 HOLDER, FEED FINGER, AF
-	-	REF	-	SEE NOTE 4 MEMORY CHIP, PROGRAMMED
-	-	1	-	1633743-1 SERVO FEED LATCH ASM
-	-	REF	-	2119944-1 FEED FINGER ASSEMBLY, SF
-	1	1	1	2119955-1 ASSY, LUBRICATOR, SIDE FEED
-	1	1	1	455888-4 SPACER, CRIMPER
-	1	1	1	2119956-1 DOCUMENTATION PACKAGE
-	1	-	1	2119740-1 TAG, IDENTIFICATION
-	2	2	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188
-	1	1	1	2119793-1 LIMITER, ADJUSTMENT BOLT
-	3	3	3	992763-5 SCR, SET, SOC, CONE POINT, M3 X 4.0
-	-	-	1	5-18022-5 SCR, HEX HD CAP, M4 X 6.0
-	-	-	1	1338685-1 PAWL, FEED
-	2	2	2	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10
-	1	1	1	5018030-1 NUT, HEX, REG, RoHS, M3
-	1	1	1	811242-5 BUMPER, HOLD DOWN
-	1	1	1	690753-2 SPACER, TONKER
-	-	-	1	18023-9 SCR, SKT HD CAP M4 X 6.0
-	-	-	-	2119652-1 FEED CAM, PRE FEED
-	1	1	1	2079383-7 SCR, BHSC, RoHS (M8 X 25)
-	1	1	1	2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT
-	1	1	1	2119957-1 APPLICATOR SHIM PACK
-	1	1	1	1-2119644-4 RAM WASHER, PRECISION
-	1	1	1	1752356-1 SUPPORT, TERMINAL
-	2	2	2	2079383-5 SCR, BHSC, RoHS (M4 X 20)
-	1	1	1	2161328-1 HEX HEAD, FLANGED, M5 X 8mm LONG
-	1	1	1	1-1320908-0 SPACER, STRIP GUIDE
-	1	1	1	2119959-1 ASSEMBLY, STRIP GUIDE
-	1	1	1	455888-3 SPACER, CRIMPER
-	1	1	1	1320928-2 STRIP GUIDE
-	1	1	1	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0
-	2	2	2	1-18028-2 WASHER, FLAT, REG M4
-	1	1	1	2119533-1 STRIPPER, SIDE FEED
-	1	1	1	2119806-1 INSERT, SHEAR
-	1	1	1	3-22280-3 SPRING, COMPRESSION
-	1	1	1	1-356885-4 STOP, SHEAR
-	1	1	1	2119805-1 SHEAR HOLDER, FRONT
-	1	1	1	1803095-1 FLOATING SHEAR, FRONT
1	1	1	1	1-1803058-5 ANVIL, COMBINATION
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	1	1	1	2119757-8 DEPRESSOR, SHEAR
-	1	1	1	1-238011-8 BLOCK, CRIMPER SPACER
1	1	1	1	5-2119582-6 CRIMPER, INSULATION F PREMIUM
-	1	1	1	455888-5 SPACER, CRIMPER
1	1	1	1	456403-4 CRIMPER, WIRE PREMIUM

**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

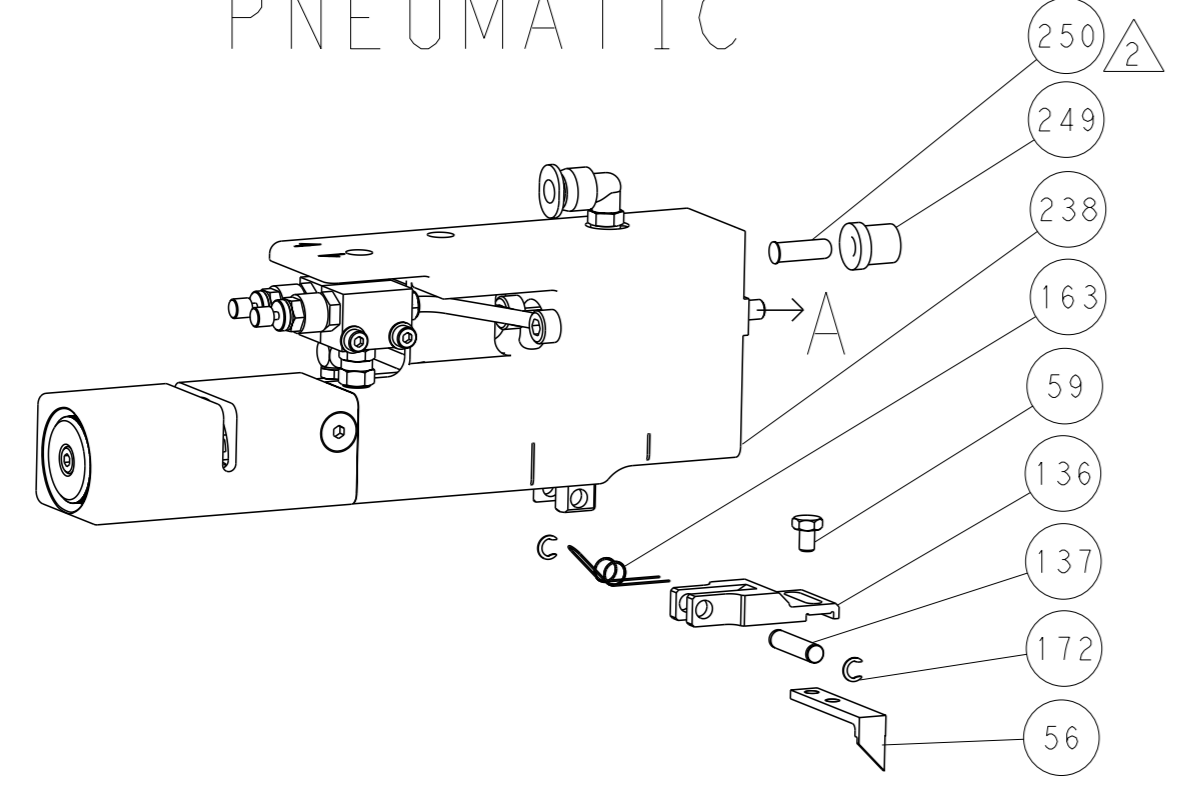
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.	OWN HOFFNER 1 JULY 2014 CHK T. ELBIN 2 JULY 2014 APPV T. ELBIN 2 JULY 2014 PRODUCT SPEC APPLICATION SPEC	NAME <b>STE</b> TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator	SIZE <b>A1</b> 00779 C=2266348	RESTRICTED TO Customer Accessible Production Drawing	SCALE 1:2 SHEET 3 OF 4 REV A
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REVISONS		DATE	OWN	APVD
P	LYR			
SEE SHEET 1				

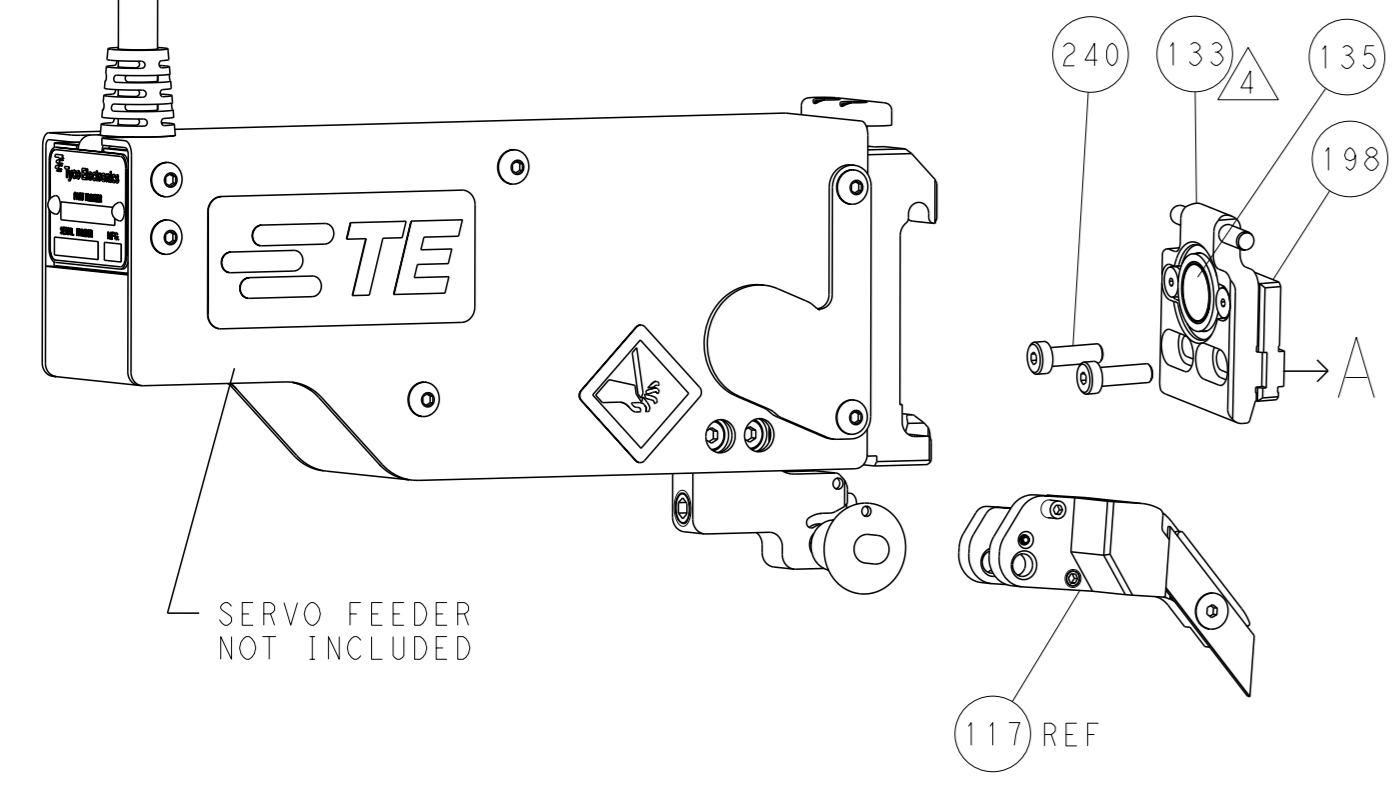
# FEED TYPE MECHANICAL



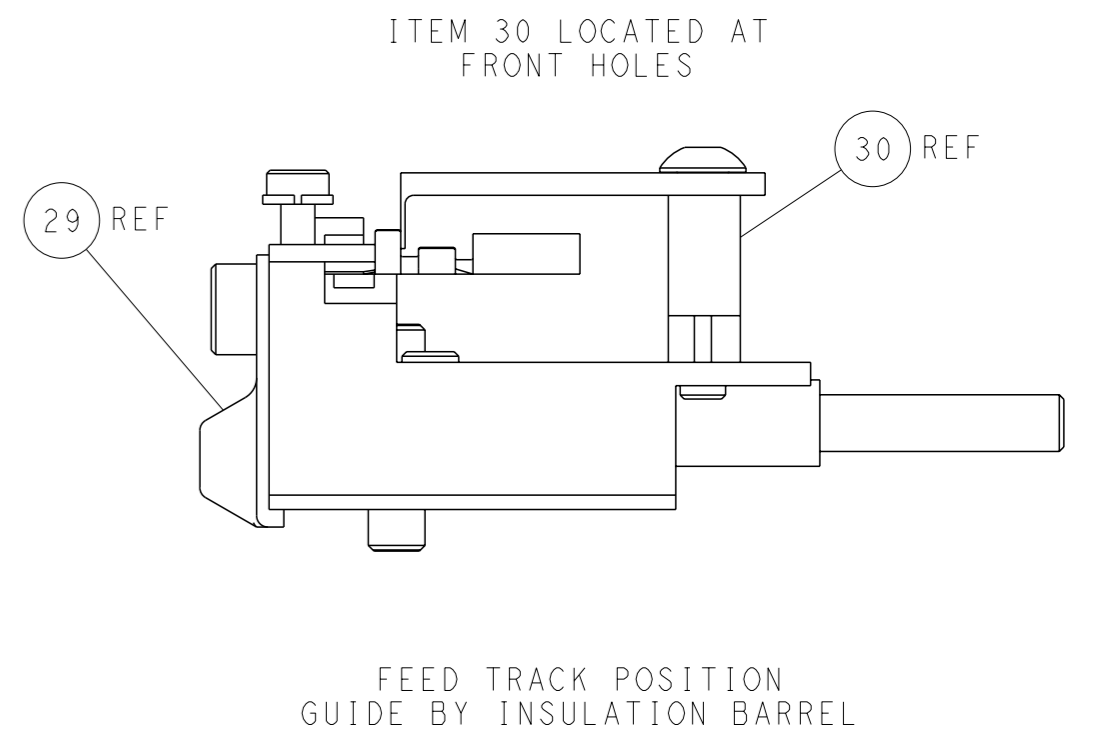
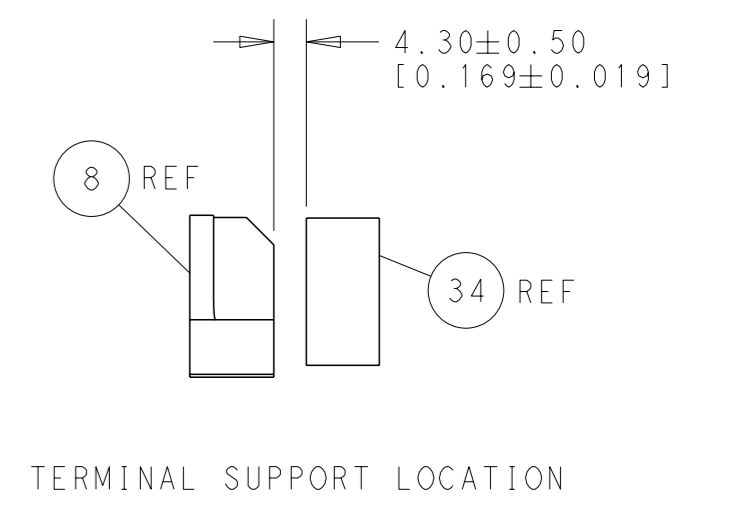
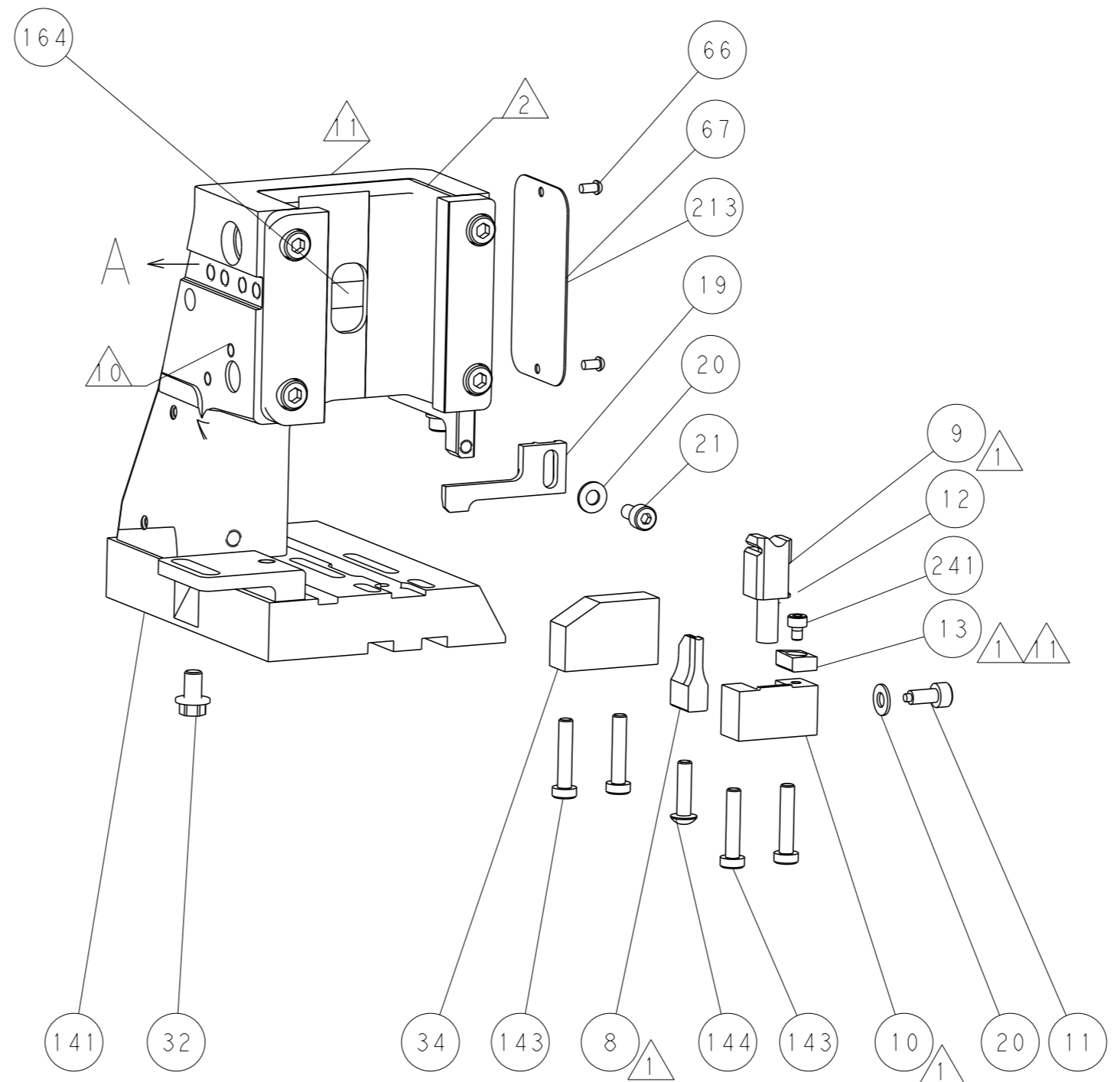
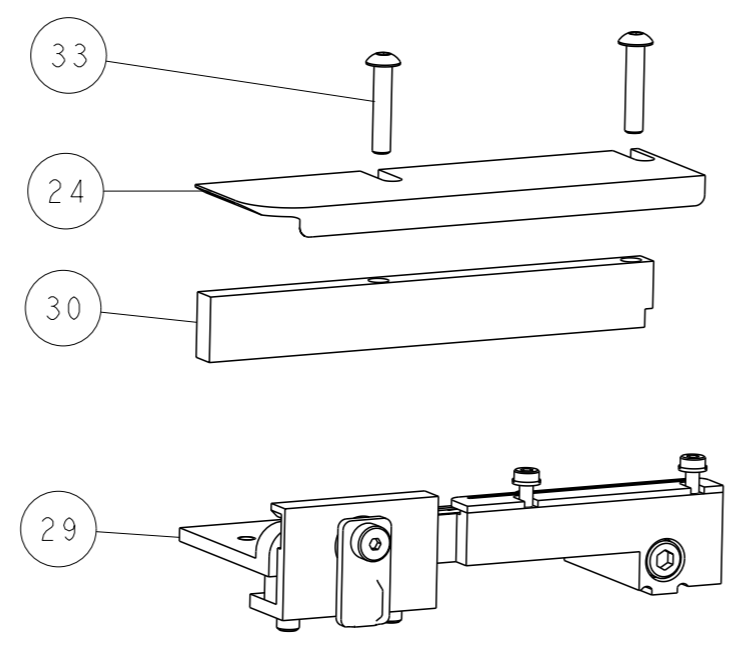
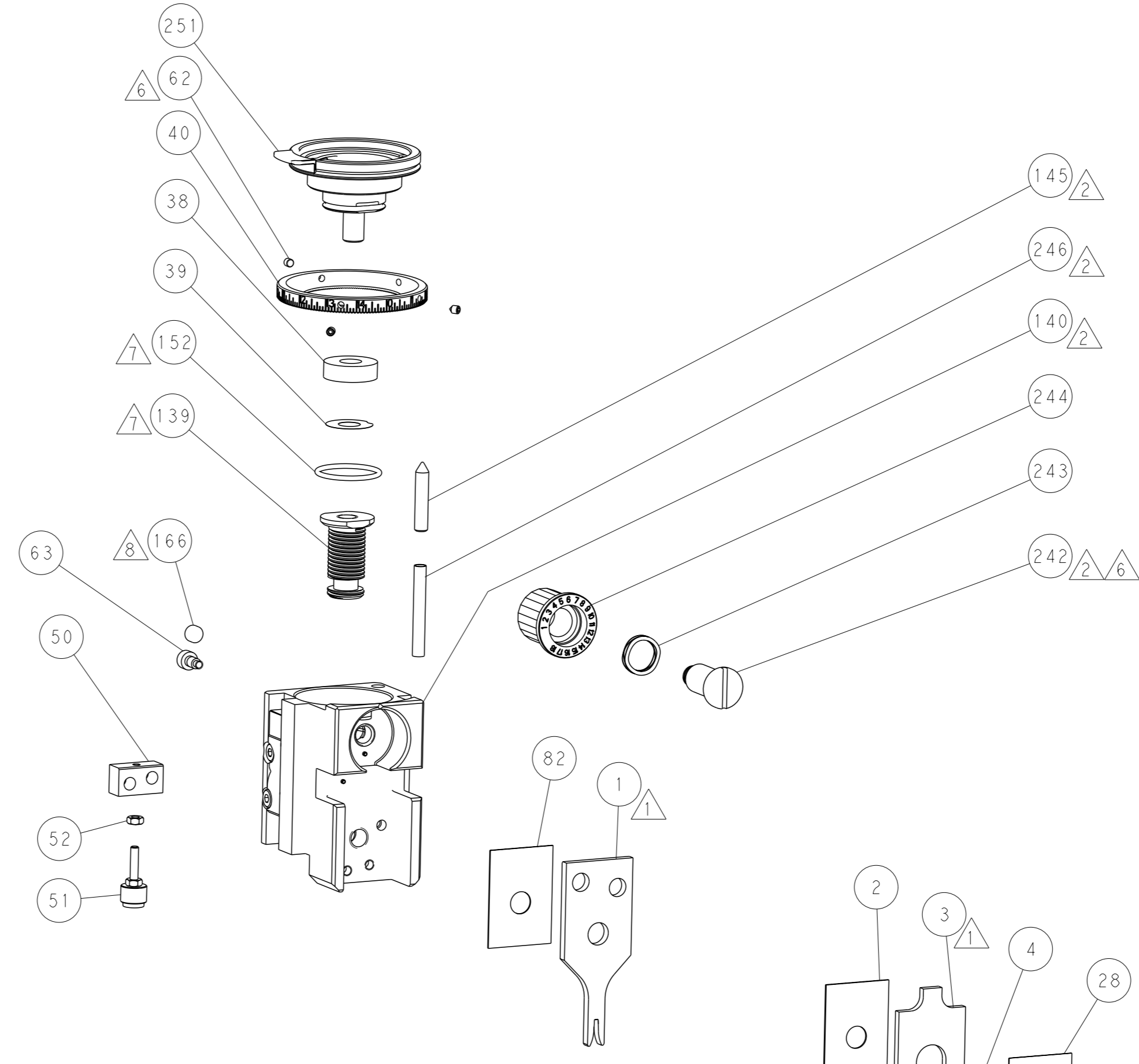
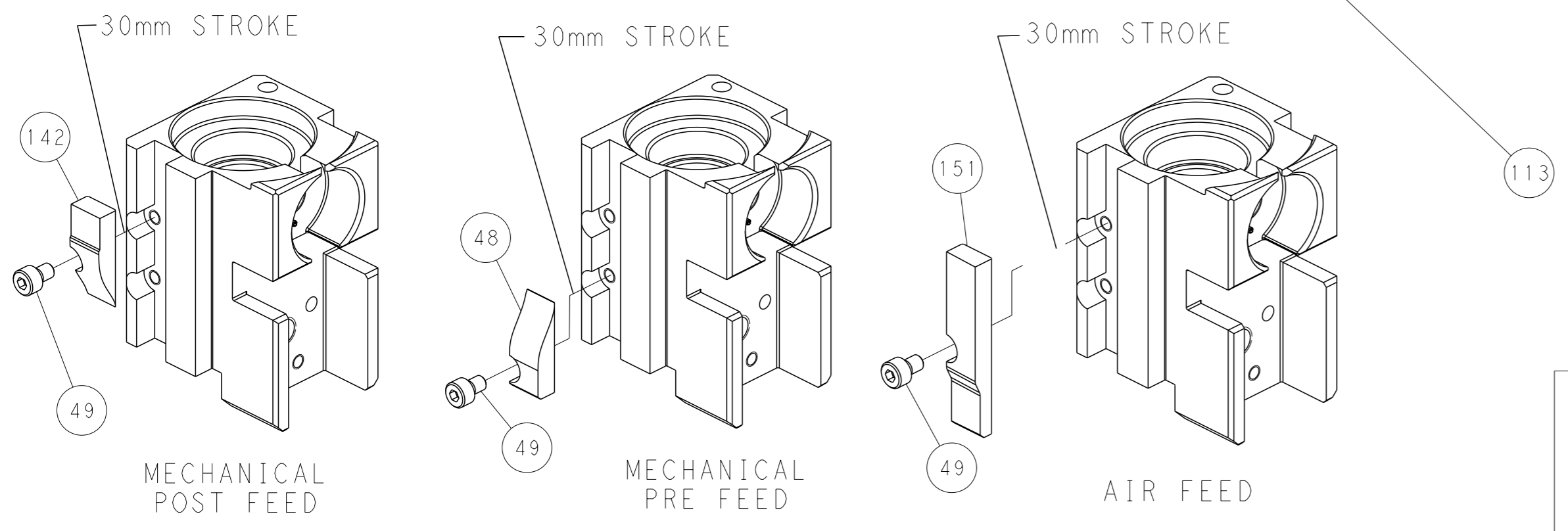
# PNEUMATIC



# 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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: HOFFNER 1JULY2014 CHK: TELBIN 2JULY2014 APVD: TELBIN 2JULY2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266348	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: A
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH: *	MATERIAL: - FINISH: -	WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION