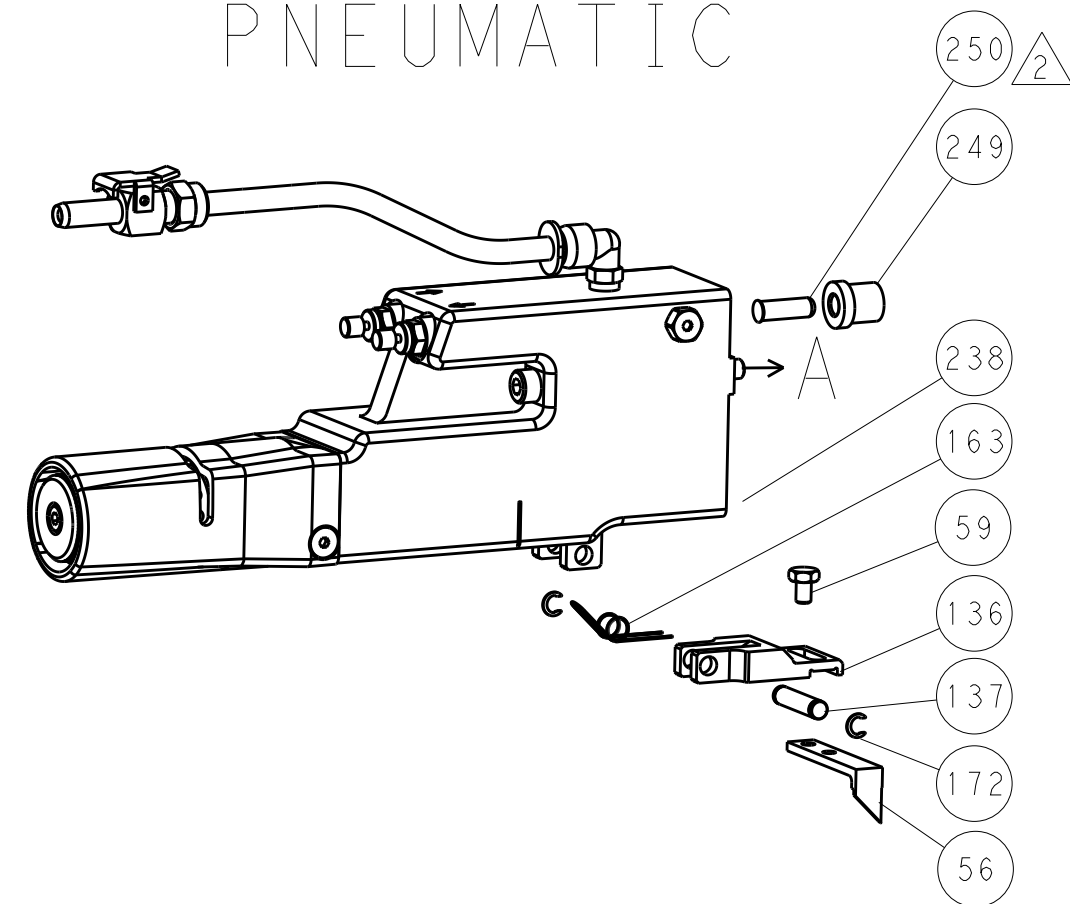


PNEUMATIC



30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

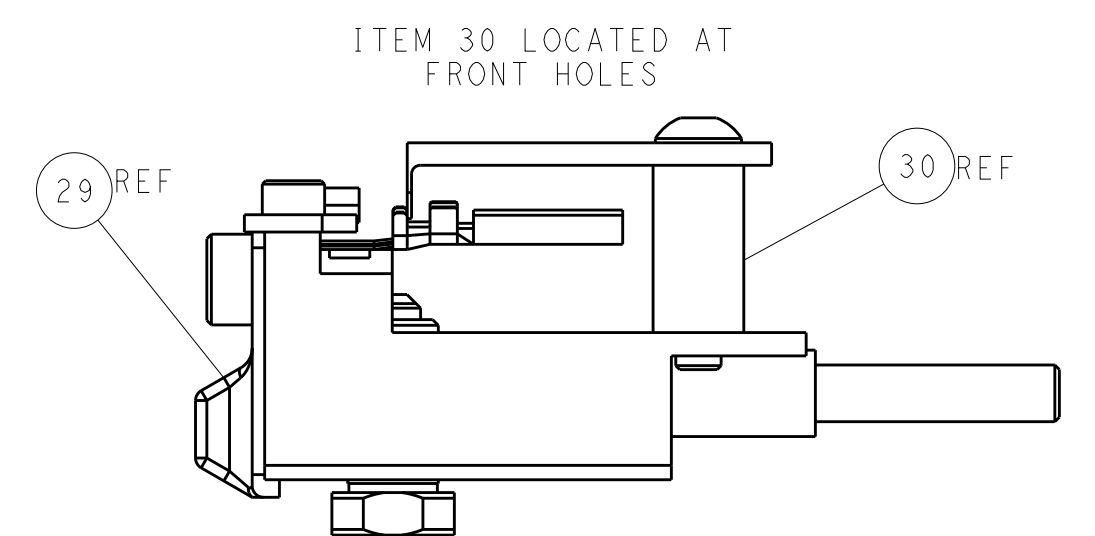
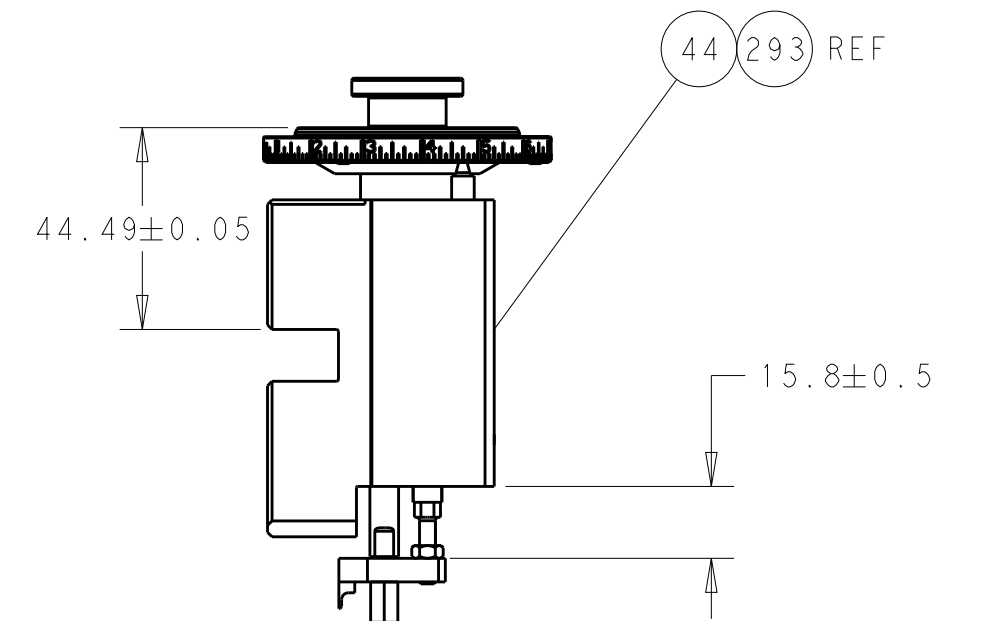
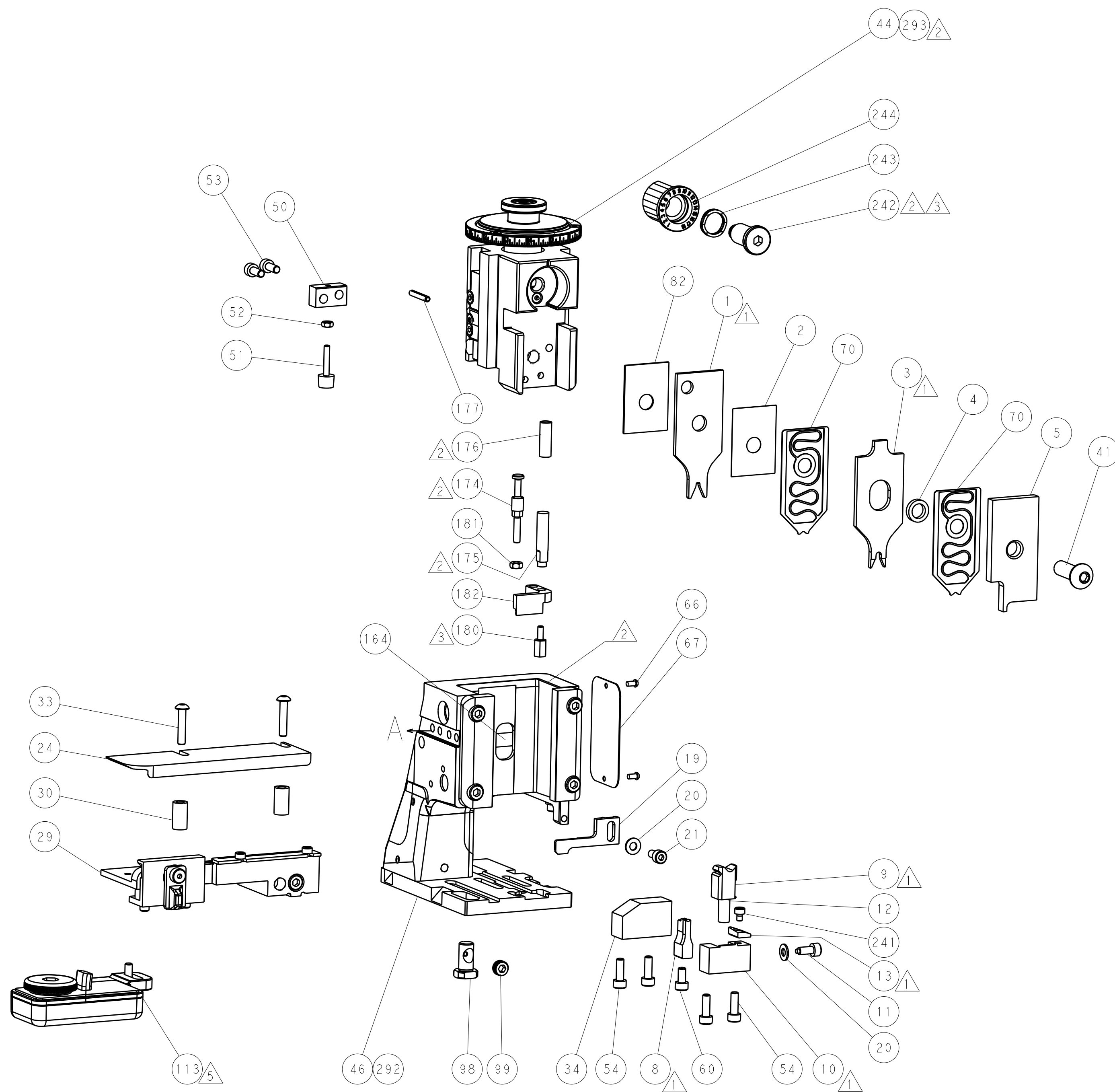
30mm STROKE

248

49

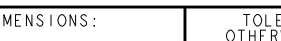
40mm STROKE

AIR FEED



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)

FILE OPERATING IN 2. CONTAINED DOCUMENT FOR FLYCO-TECHNICS CORPORATION IT IS SUBJECT TO THE TERMS AND CONDITIONS OF THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWG R. KNEPPER 23AUG2013 CHK G. BAILEY 23AUG2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±.		NAME JEFF M. CLIFFORD 23AUG2013 PRODUCT SPEC - APPLICATION SPEC -	
		SIZE A 00779		DRAWING NO C-2266100	
MATERIAL -		FINISH -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV. C	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266100-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266100-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266100-7	B	CRIMP TOOLING KIT	-
7-2266100-8	B	APPLICATOR CONVERSION KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.20 mm [.126]	O
APPLICATOR INSTRUCTIONS 408-35042		

APPLICATOR CONVERSION KITS	
PART NUMBER	INSULATION DIAMETER RANGE
7-2266100-8	Ø 3.05-3.81mm [.120-.150]
7-2266101-8	Ø 2.67-3.02mm [.105-.119]
7-2266102-8	Ø 2.26-2.64mm [.089-.104]
7-2266103-8	Ø 1.93-2.24mm [.076-.088]
7-2266104-8	Ø 1.60-1.91mm [.063-.075]

TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT PIN SIZE 16			
WIRE STRIP LENGTH 3.81-5.09 mm [.150-.200 IN]		INSULATION DIAMETER RANGE Ø 3.05-3.81 mm [.120-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-151000	-	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
286505-1	1060-14-0122	286505-2	1060-14-0144
286505-3	1060-14-0177	286505-5	1060-14-1077
286505-6	1060-14-1088	286503-1	1060-16-0122
286503-2	1060-16-0144	286503-3	1060-16-0177
286503-7	1060-16-0722	286503-8	1060-16-0744
286503-9	1060-16-0777	1-286503-1	1060-16-0977
1-286503-2	1060-16-0988	1-286503-4	AT60-16-0122
1-286503-5	AT60-16-0144		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.40+0.03/-0.05 [.055+.001/- .002]	4.6
2.00mm2	1.40+0.03/-0.05 [.055+.001/- .002]	4.6
1.50mm2	1.35+0.03/-0.05 [.053+.001/- .002]	5.2
16 AWG	1.27+0.03/-0.05 [.050+.001/- .002]	6.0
1.00mm2	1.27+0.03/-0.05 [.050+.001/- .002]	6.0
18 AWG	1.24+0.03/-0.05 [.049+.001/- .002]	6.2
0.75mm2	1.22+0.03/-0.05 [.048+.001/- .002]	6.4



1 RECOMMENDED SPARE PARTS

2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

4 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.

5 TERMINAL LUBRICANT IS RECOMMENDED.

6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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

TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 16			
WIRE STRIP LENGTH 3.81-5.09 mm [.150-.200 IN]		INSULATION DIAMETER RANGE Ø 3.05-3.81 mm [.120-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-151000	-	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
286506-1	1062-14-0122	286506-2	1062-14-0144
286506-3	1062-14-0177	286506-6	1062-14-1088
286506-5	1062-14-1077	286504-2	1062-16-0144
286504-1	1062-16-0122	286504-7	1062-16-0722
286504-3	1062-16-0177	286504-9	1062-16-0777
286504-8	1062-16-0744	1-286504-2	1062-16-0988
1-286504-1	1062-16-0977	1-286504-6	AT62-16-0144
1-286504-5	AT62-16-0122		

*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

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

-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	1	-	1803259-1	BUSHING, FLANGED	249
-	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	-	1	1	2844908-1	SCREW, LOCKING	99
-	-	1	1	2844907-1	POST, LOCKING	98
1	-	1	1	455888-8	SPACER, CRIMPER	82
1	-	-	-	2266100	PRINT, APPLICATOR LOG SHEET	72
-	-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	-	2	2	2119791-9	DEPRESSOR, WIRE	70
-	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	1	1338685-1	PAWL, FEED	56
-	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	-	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	-	1	1	1320928-2	STRIP GUIDE	24
-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	-	1	1	2119806-1	INSERT, SHEAR	13
-	-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	1	1	1-356885-4	STOP, SHEAR	11
-	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	-	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1	1	1803293-1	ANVIL, COMBINATION DEUTSCH STYLE	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1803019-3	CRIMPER, INSULATION O	3
-	-	1	1	455888-1	SPACER, CRIMPER	2
1	-	1	1	2-1633713-6	CRIMPER, WIRE PREMIUM	1
-78	-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ORGANIZATION THAT IT IS ISSUED BY. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ORGANIZATION THAT IT IS ISSUED BY. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ORGANIZATION THAT IT IS ISSUED BY.				DWN R.KNEPPER CHK G.BAILEY APVD M.CLEFFORD	23AUG2013 23AUG2013 23AUG2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME Ocean Side Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH		± ± ± ± ± ± ±		APPLICATION SPEC		SIZE 00779	
MATERIAL -		-		WEIGHT -		Customer Accessible Production Drawing	
				SCALE 1:2		SHEET 3 OF 4	
				REV C1			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

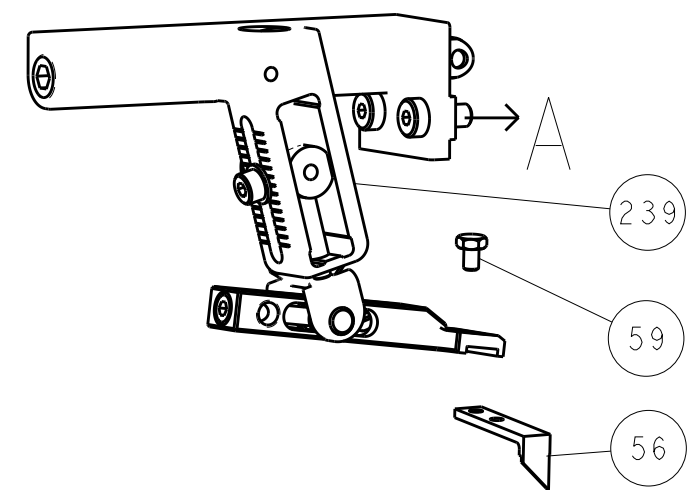
D

C

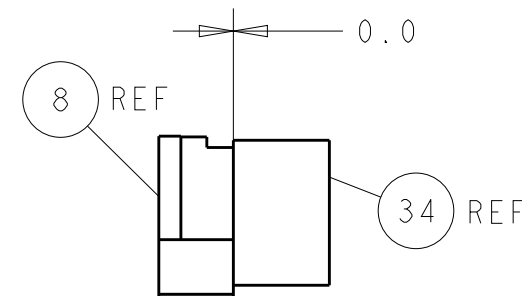
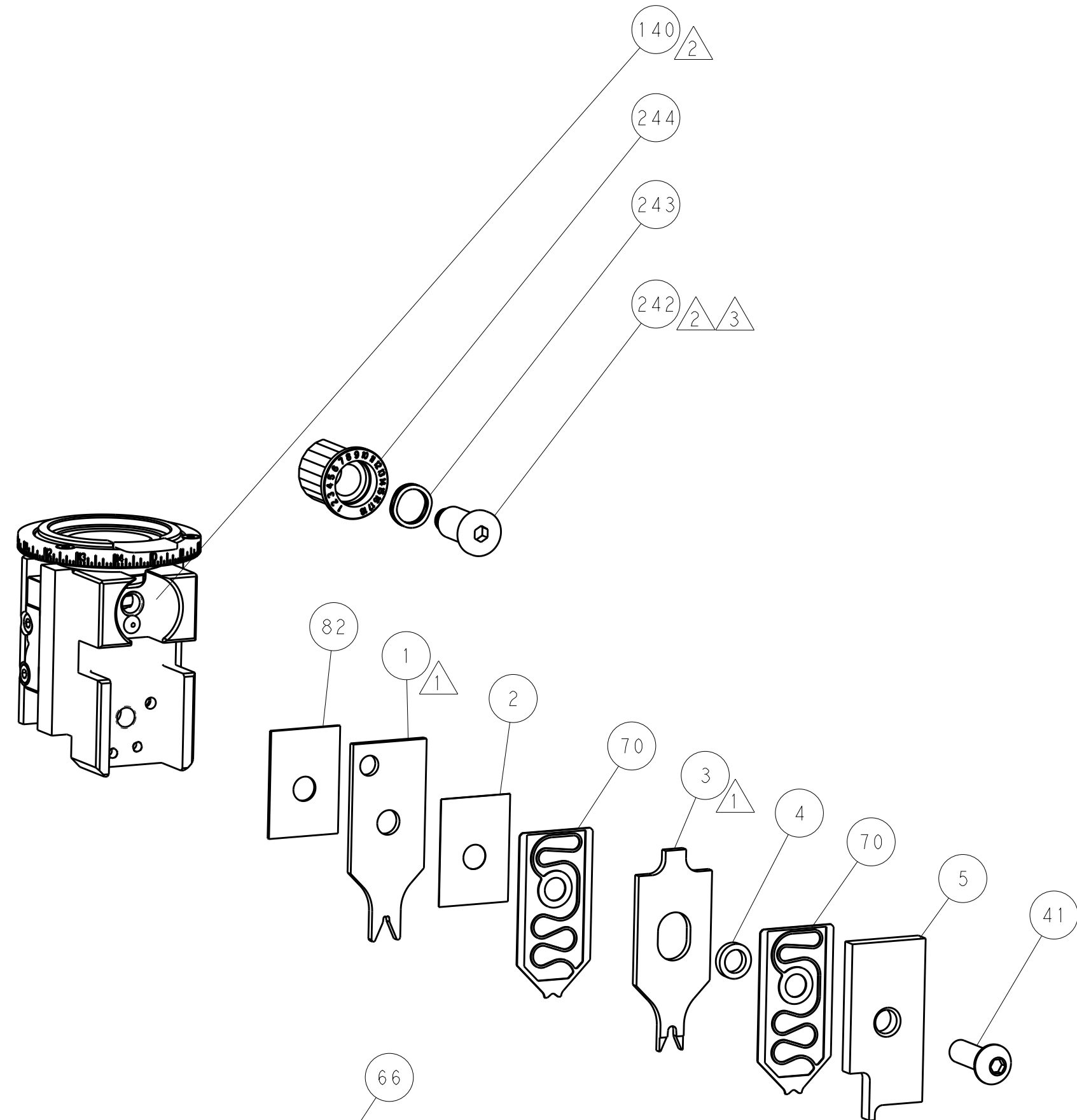
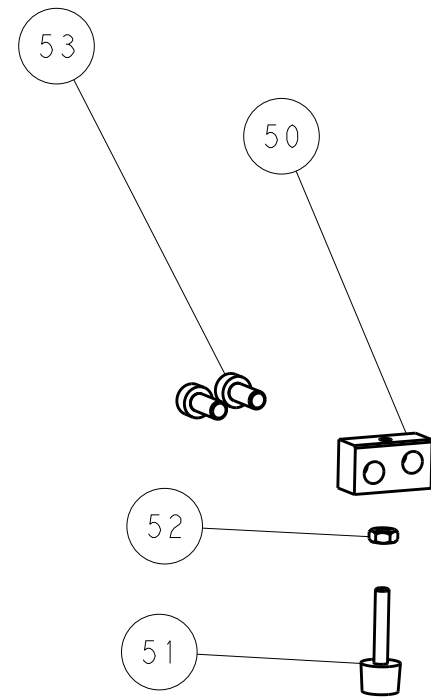
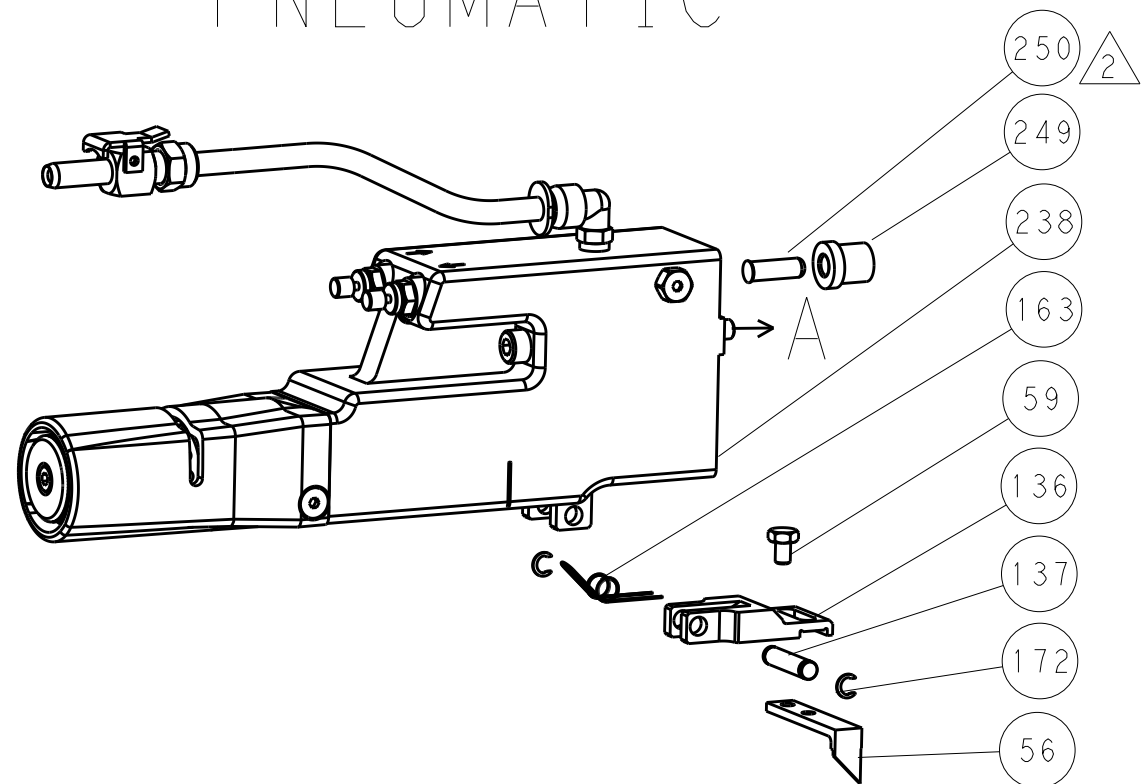
B

A

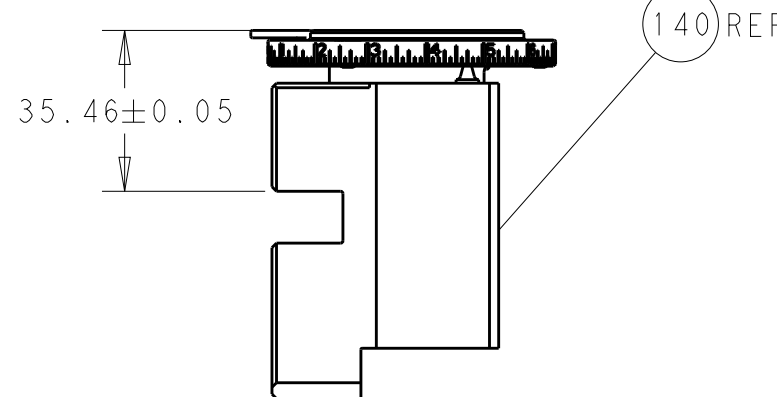
FEED TYPE MECHANICAL



PNEUMATIC

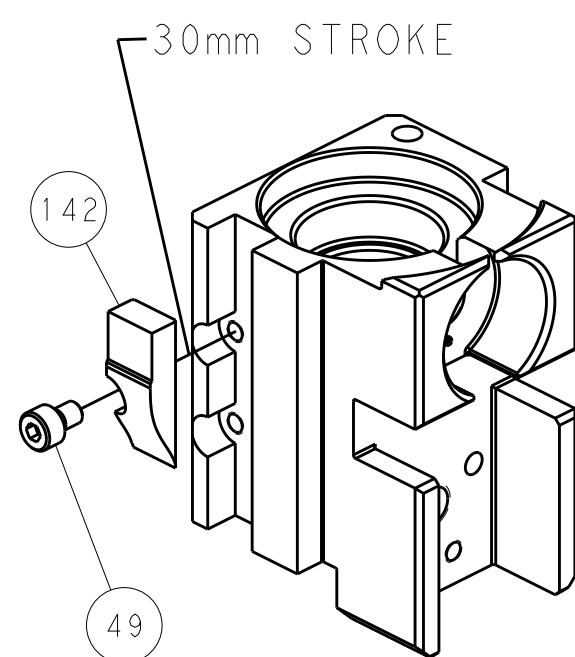


TERMINAL SUPPORT LOCATION

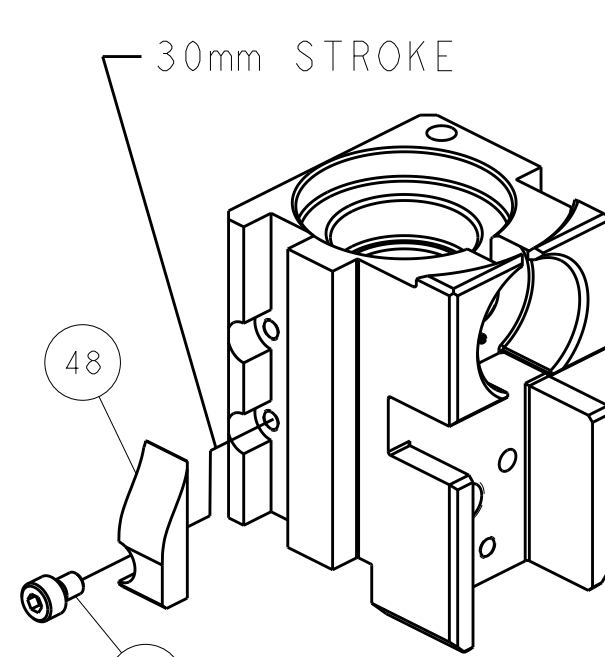


RAM SET-UP

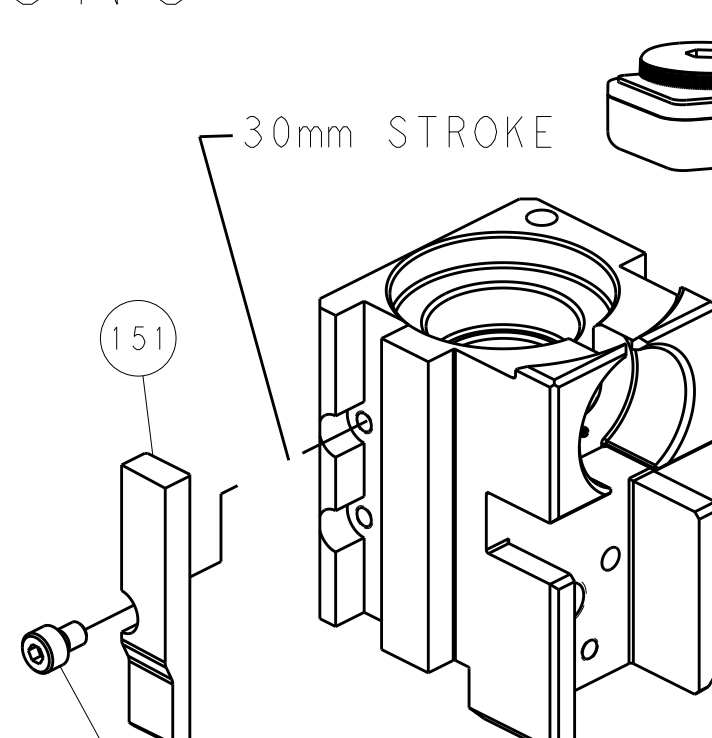
CAM POSITIONS



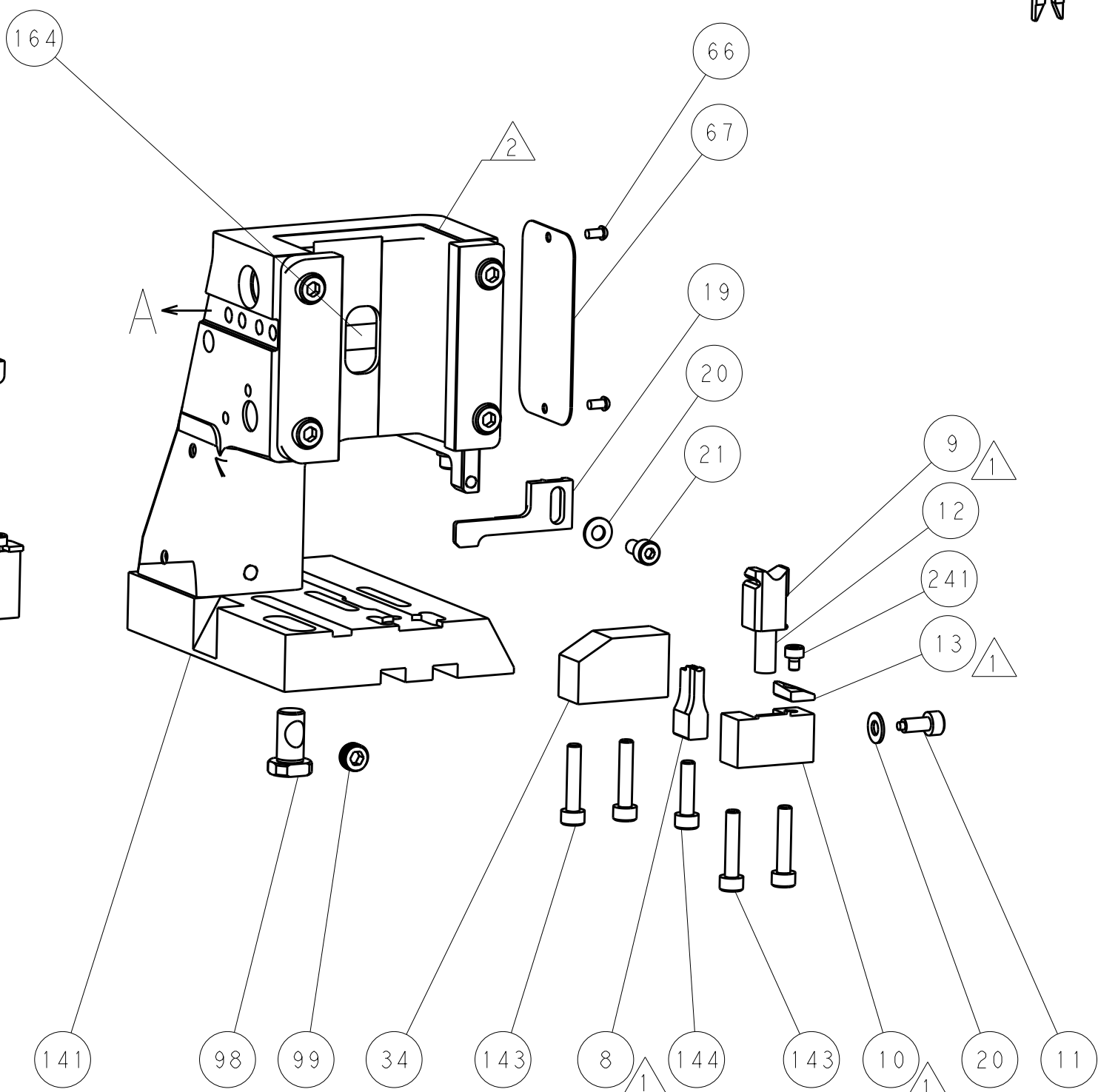
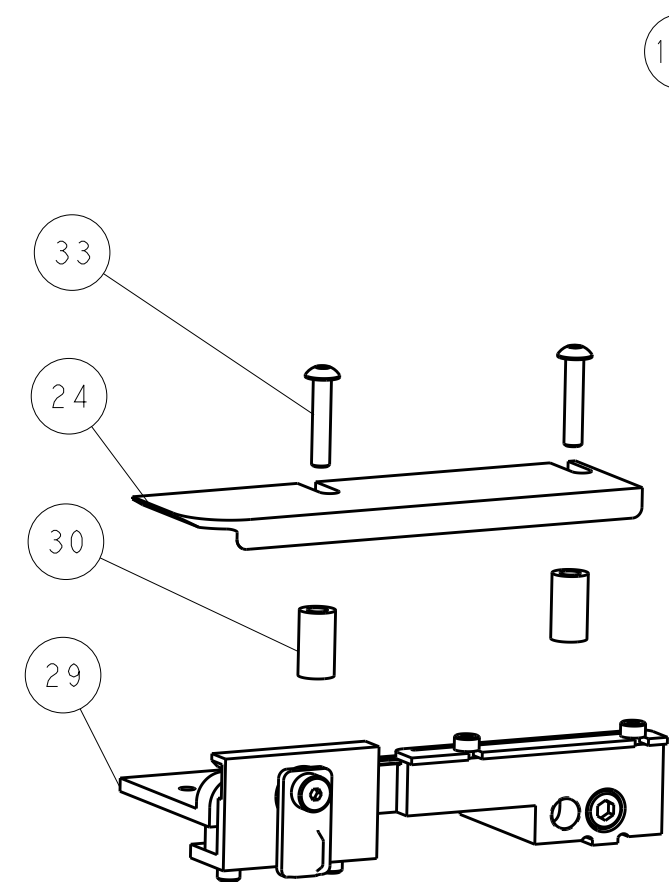
MECHANICAL
POST FEED



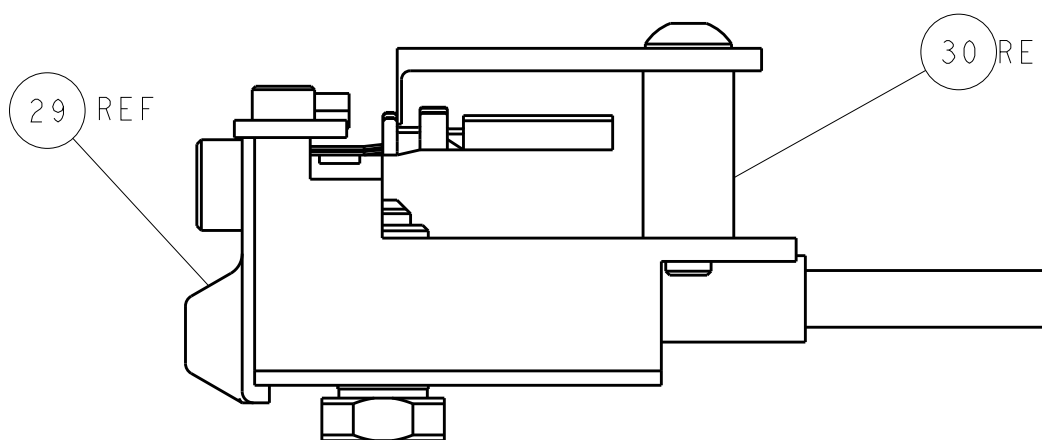
MECHANICAL
PRE FEED



AIR FEED



ITEM 30 LOCATED AT
FRONT HOLES



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)

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CHK G. BAILEY 23AUG2013		NAME W. CLIFFORD	Ocean Side Feed Applicator	
APVD M. CLIFFORD		PRODUCT SPEC	SIZE A1	
APPLICATION SPEC		WEIGHT	CAGE CODE 00779	
MATERIAL		FINISH	DRAWING NO C=2266100	
Customer Accessible Production Drawing		SCALE 1:2	SHEET 4	
			OF 4	
			REV C1	

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