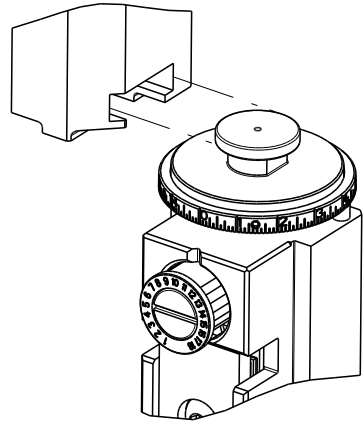


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266420-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266420-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266420-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266420-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266420-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.81 mm [1.50]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: FCI TERMINAL		VW CRIMP SPECIFICATION	
TERMINAL NAME: 2.8mm FEMALE TERMINAL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.90-4.70 mm [1.54-1.85 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	N104427	-	-

TE TERMINAL	FCI TERMINAL	TE SEAL	FCI SEAL	SEAL INSULATION DIAMETER RANGE
1572981-1	6 001 24 31	2113590-1	60994015	Ø 1.2~2.0mm
1572981-2	6 001 30 31	963294-1		Ø 1.2~2.1mm
1572981-3	6 001 32 32			
1572981-4	6 001 33 32			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30+/-0.04 [.051+/- .002]	8.4
0.75mm2	1.25+/-0.04 [.049+/- .002]	8.8
0.50mm2	1.20+/-0.04 [.047+/- .002]	9.2



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

*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.

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

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			A	RELEASED	19AUG2014	KH	GB
			A1	ECR-18-013461	24AUG2018	FL	CT
			B	ECR-18-017907	14NOV2018	TB	CT

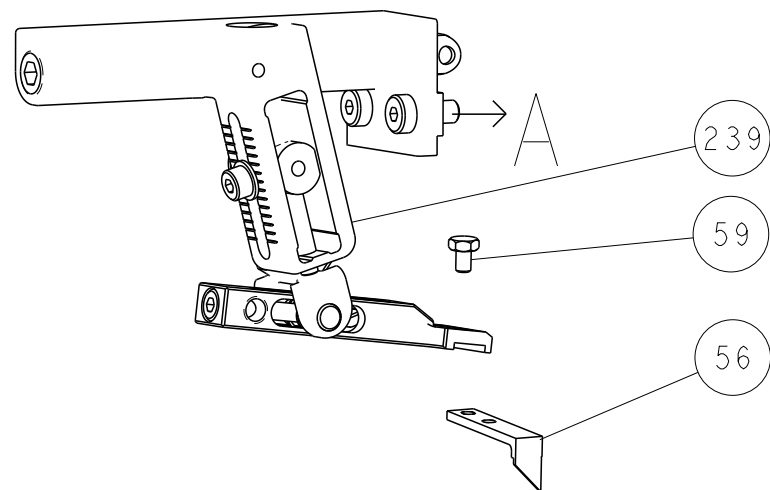
	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-8	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
5	-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1	1	1338685-1	PAWL, FEED	56
	-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
	-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1	1-1752356-7	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	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	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
4	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
4	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	9-1633927-7	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	4-1633965-3	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	2	2	1	1	7-1633738-3	CRIMPER, WIRE	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER OF THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN R. HUANG CHK L. ZHANG APVD J. GUO	17JUL2014 17JUL2014 17JUL2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator	
mm		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		PRODUCT SPEC		SIZE	
MATERIAL		WEIGHT		APPLICATION SPEC		CAGE CODE	
-		-		-		DRAWING NO	
						RESTRICTED TO	
						A1 00779 ©=2266420	
						Customer Accessible Production Drawing	
						SCALE 1:2	
						SHEET 1 OF 4	
						REV B	

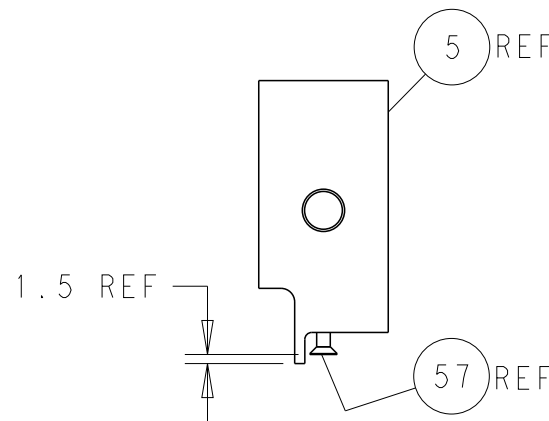
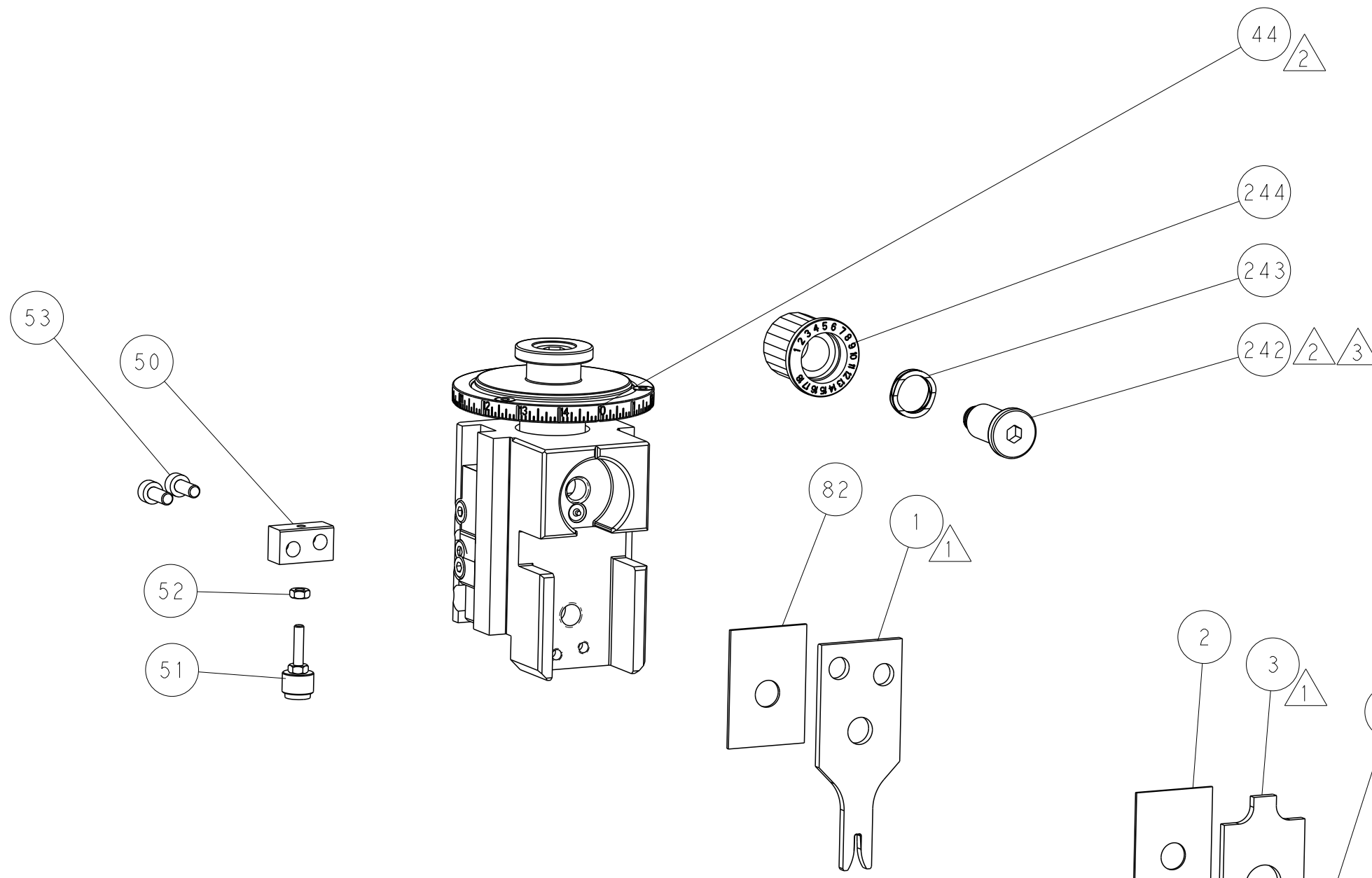
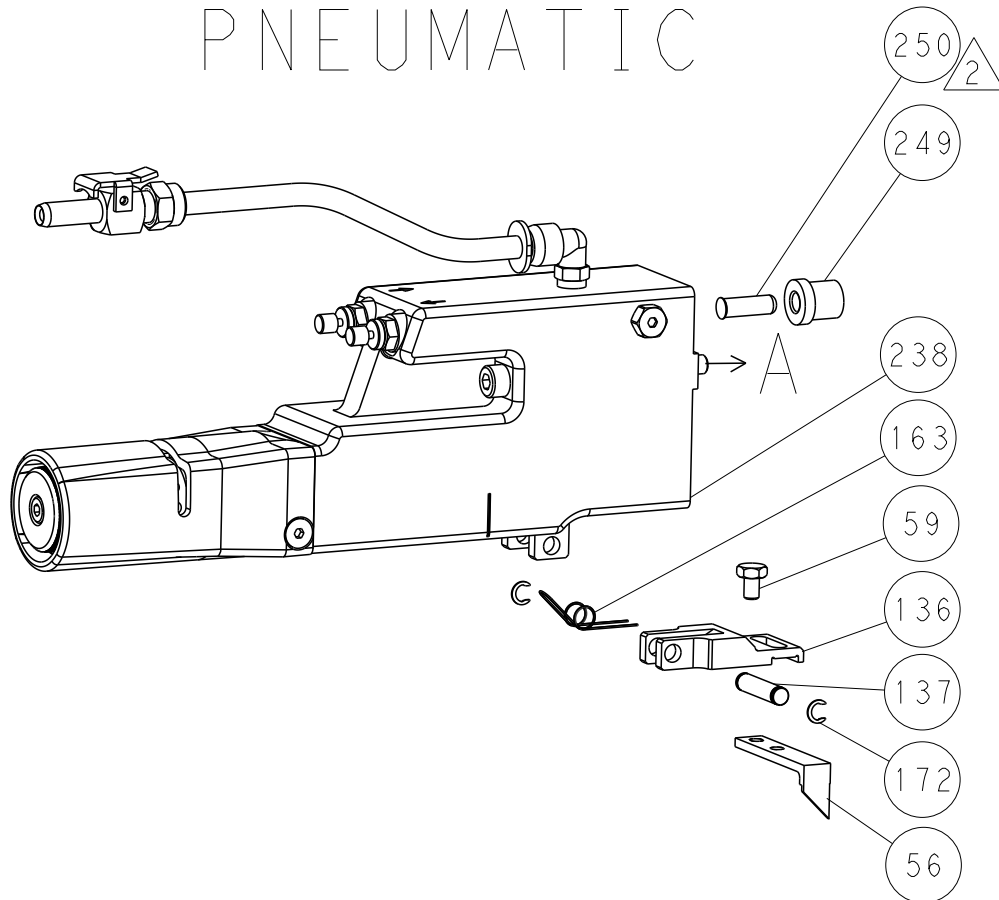
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

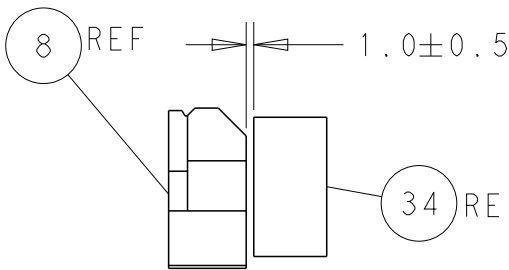
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MECHANICAL



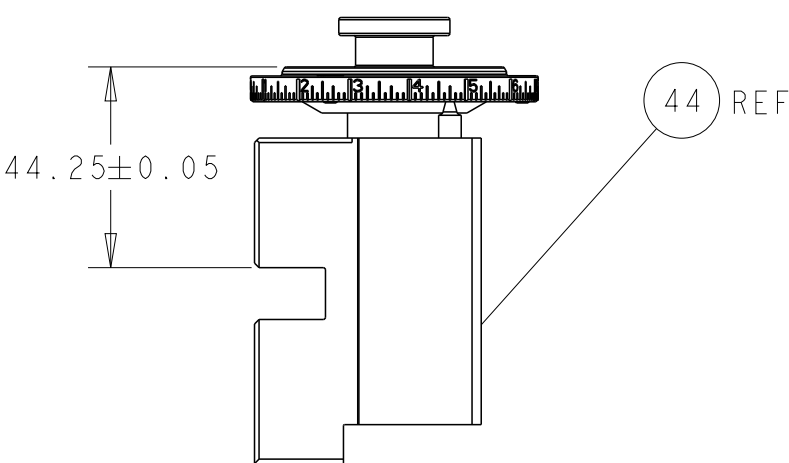
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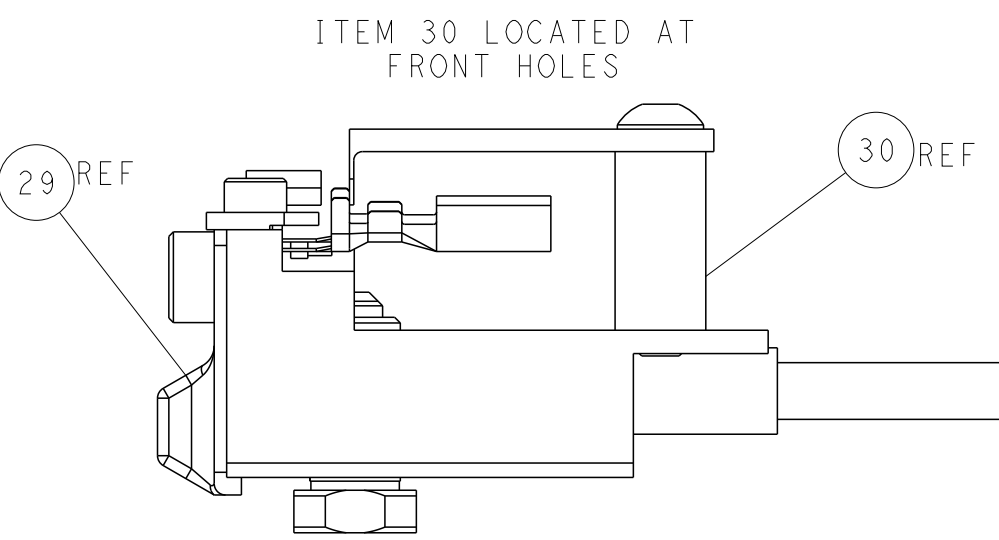
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

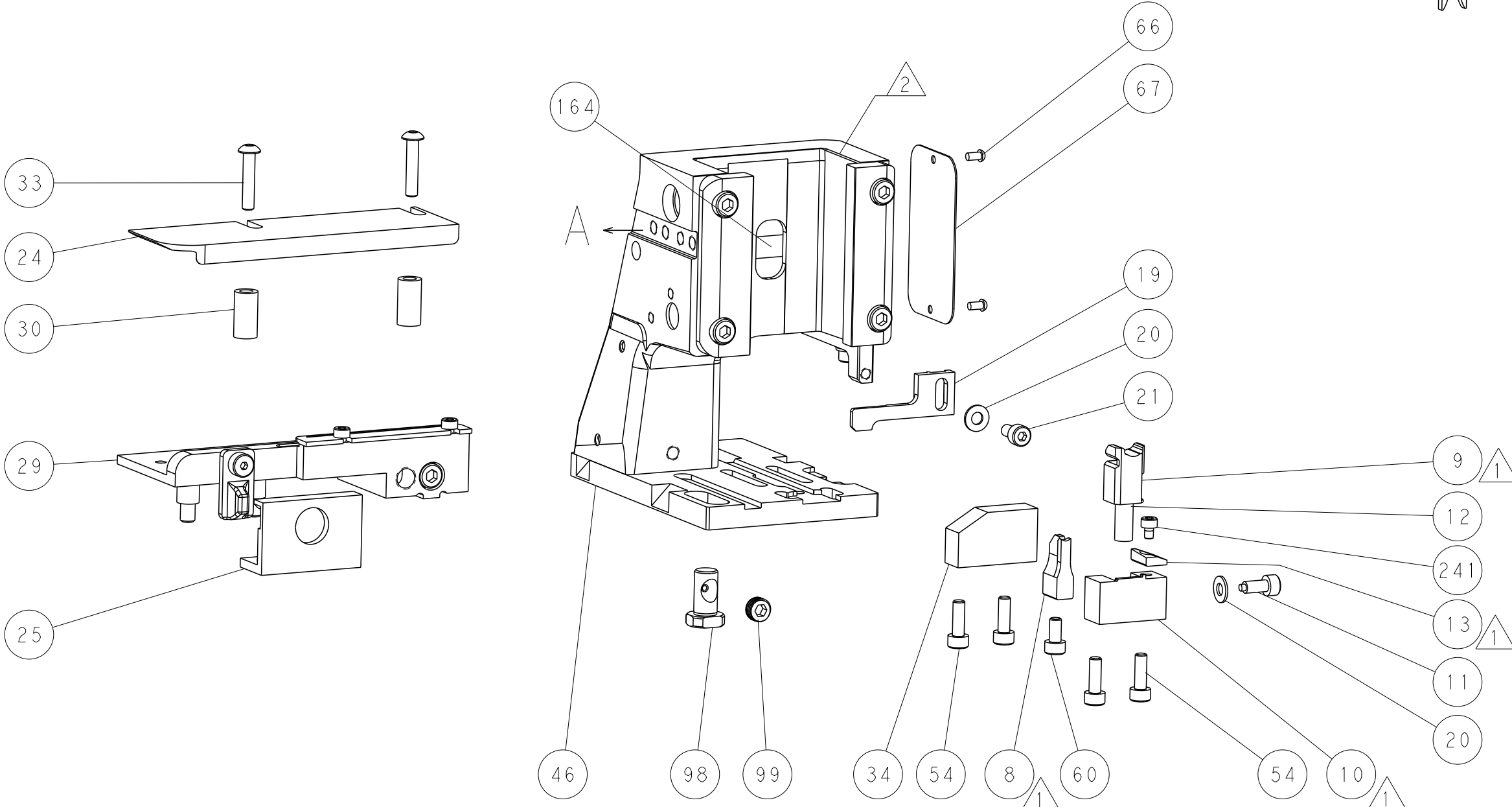
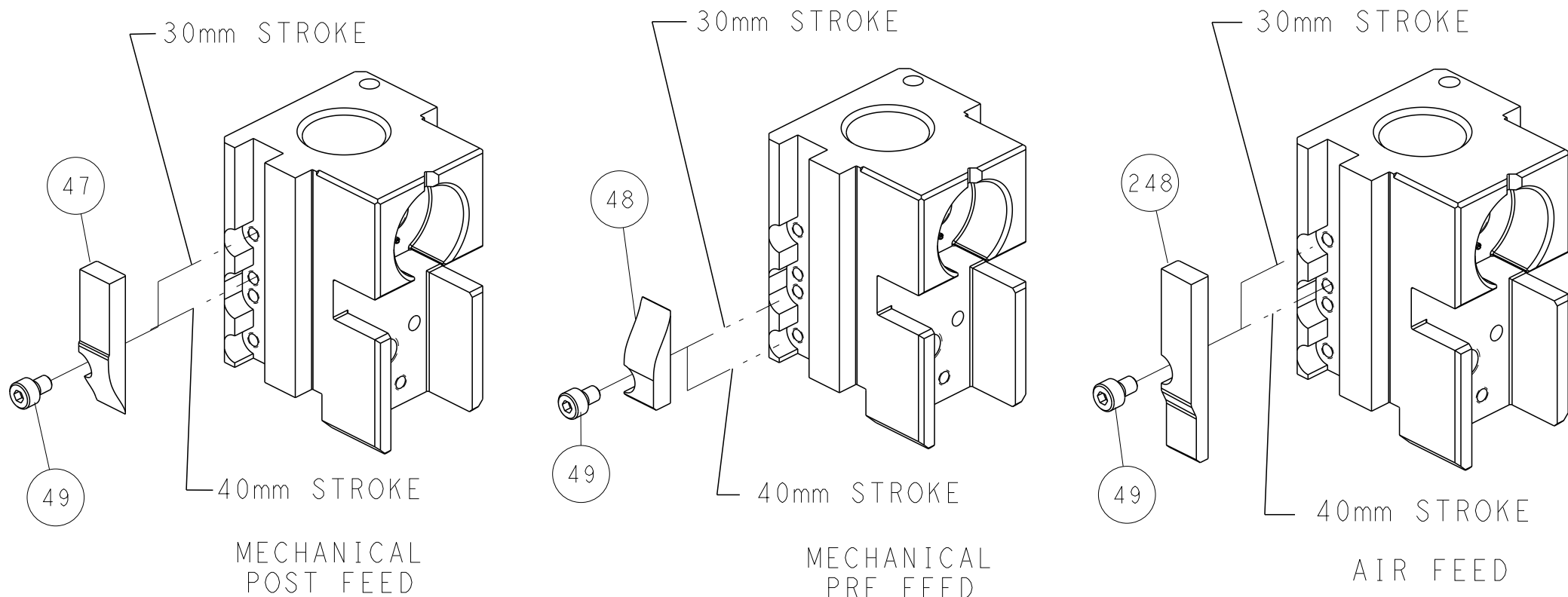


RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS

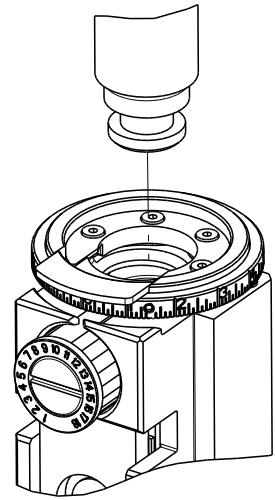


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

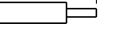
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				CHK	L. ZHANG	17JUL2014	Harrisburg, PA 17105-3608				
				APVD	J. GUO	17JUL2014	NAME Ocean Side Feed Applicator - SIZE CAGE CODE DRAWING NO REV SCALE SHEET OF 4 REV B				
				PRODUCT SPEC							
				APPLICATION SPEC							
				WEIGHT		RESTRICTED TO					
				MATERIAL		SIZE					
						CAGE CODE					
						DRAWING NO					
						REV					
						SCALE					
						SHEET					
						OF					
						4					
						REV					
						B					

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266420-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266420-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266420-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.81 mm [.150]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: FCI TERMINAL		VW CRIMP SPECIFICATION	
TERMINAL NAME: 2.8mm FEMALE TERMINAL			
WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION		N104427	- -
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE SEAL	FCI SEAL
1572981-1	6 001 24 31	2113590-1	60994015
1572981-2	6 001 30 31	963294-1	
1572981-3	6 001 32 32		
1572981-4	6 001 33 32		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30+/-0.04 [.051+/-0.002]	8.4
0.75mm2	1.25+/-0.04 [.049+/-0.002]	8.8
0.50mm2	1.20+/-0.04 [.047+/-0.002]	9.2



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

*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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

3	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-3	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	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	455888-8	SPACER, CRIMPER	82	
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	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	
5	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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	1-1752356-7	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	9-1633927-7	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	2119781-1	DEPRESSOR, SHEAR	5	
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	1	4-1633965-3	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	455888-6	SPACER, CRIMPER	2	
1	1	1	7-1633738-3	CRIMPER, WIRE	1	

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
THIS DOCUMENT IS A CONTROLLED DOCUMENT AND ITS DISTRIBUTION OUTSIDE THE COMPANY IS RESTRICTED TO CONTROLLED DOCUMENTS. ANY DISTRIBUTION OUTSIDE THE COMPANY SHOULD BE CONTROLLED FOR THE LATEST REVISION.			DWN A. HUANG CHK L. ZHANG APVD J. GUO 17JUL2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm			PRODUCT SPEC	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH			APPLICATION SPEC	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL			WEIGHT	A 00779 C=2266420	
Customer Accessible Production Drawing			SCALE	1:2	SHEET 3 OF 4
					REV B

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

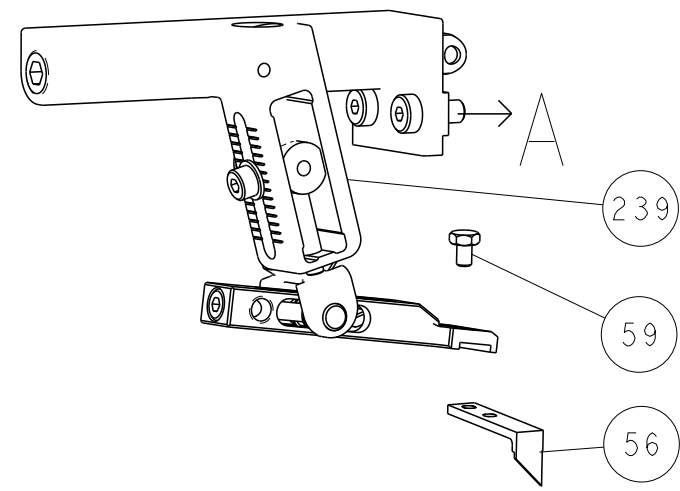
D

C

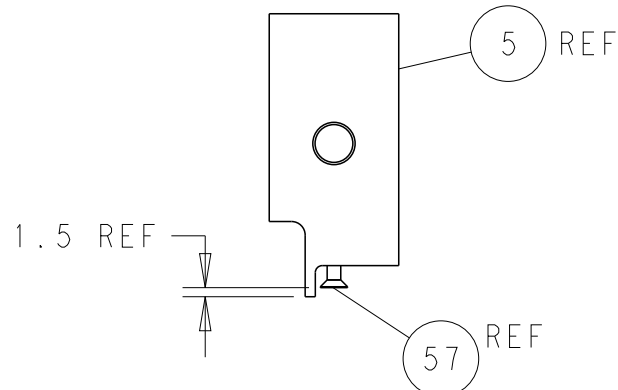
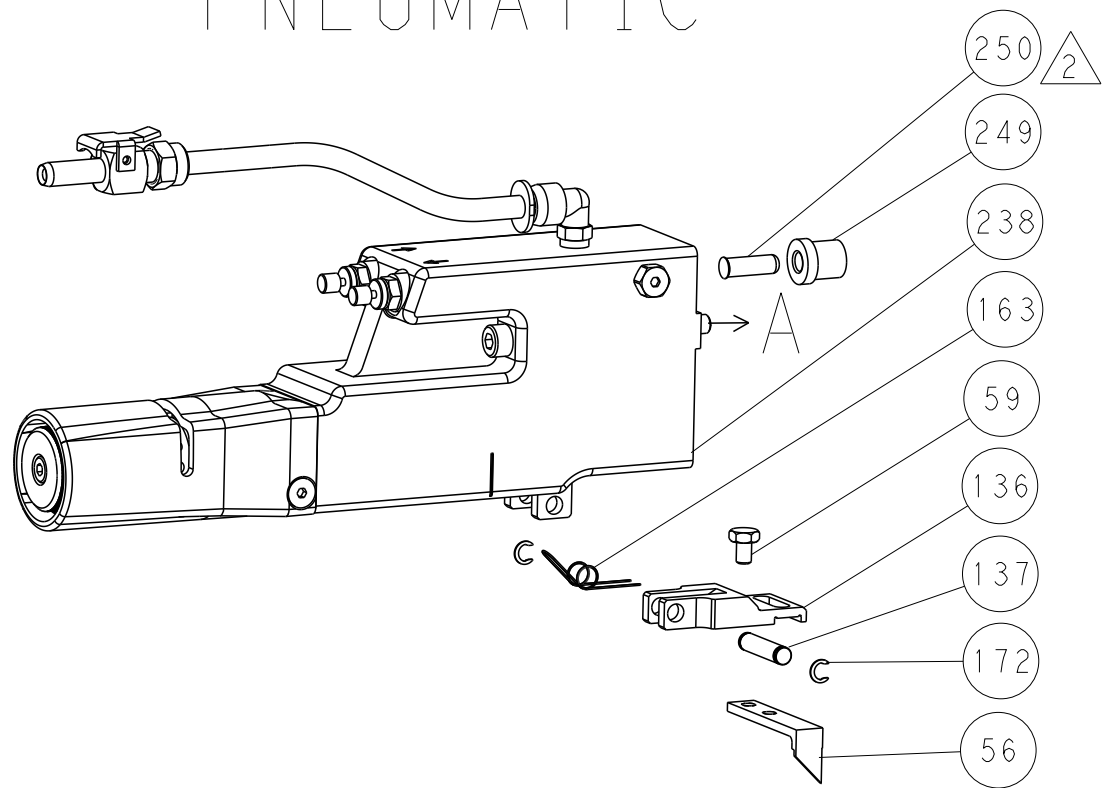
B

A

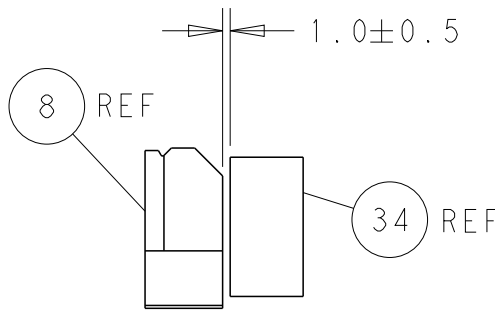
FEED TYPE MECHANICAL



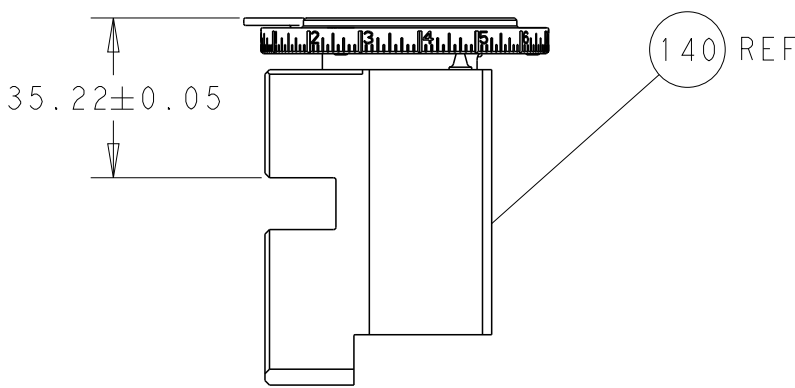
PNEUMATIC



SHEAR DEPRESSOR DETAIL

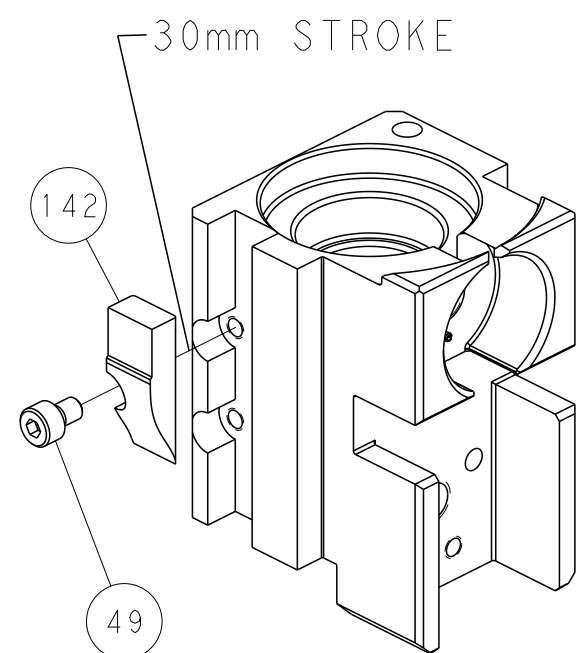


TERMINAL SUPPORT LOCATION

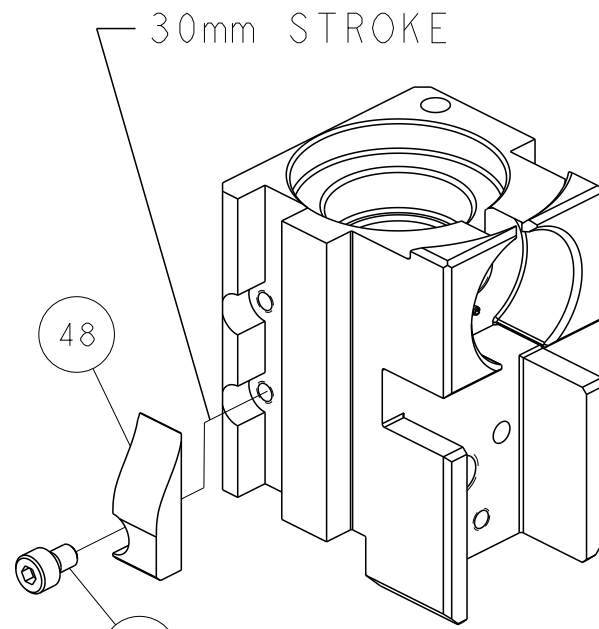


RAM SET-UP

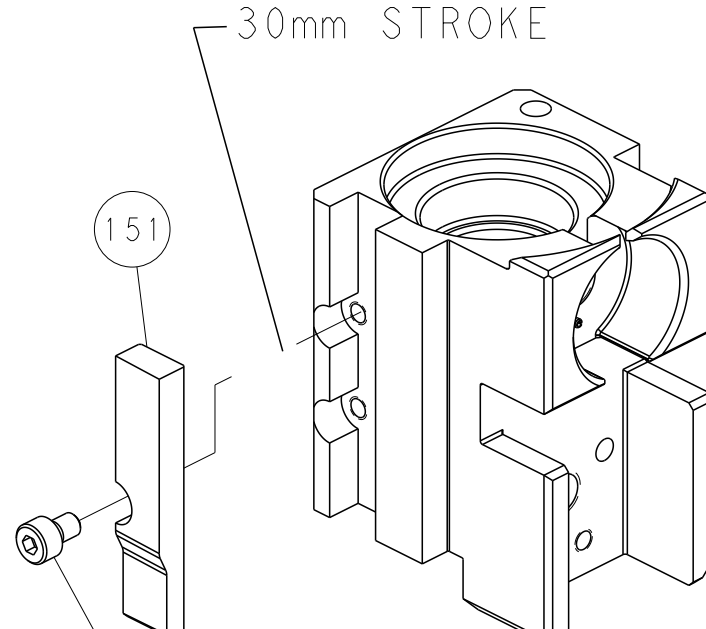
CAM POSITIONS



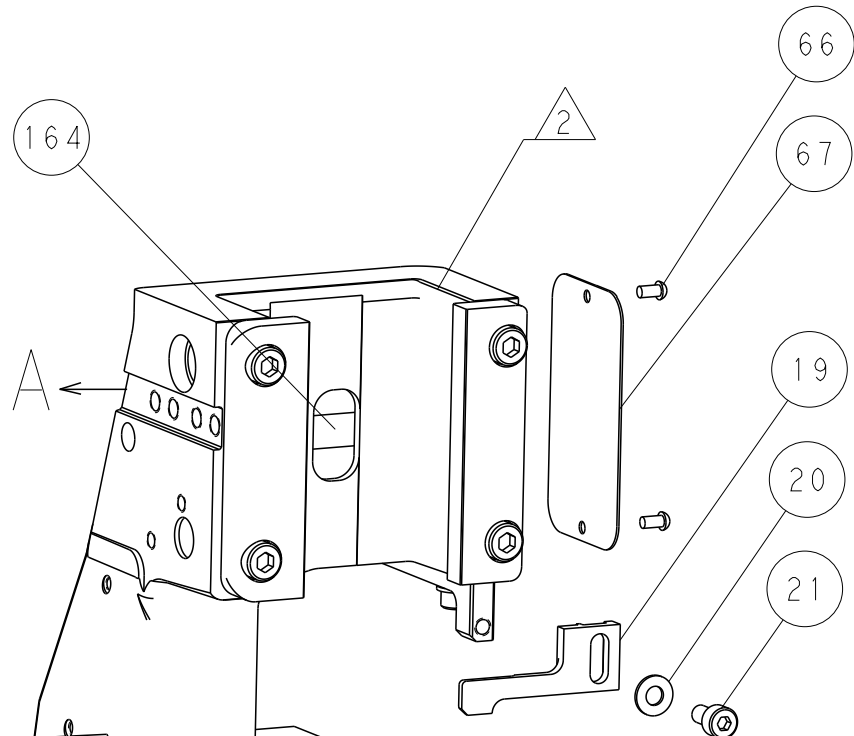
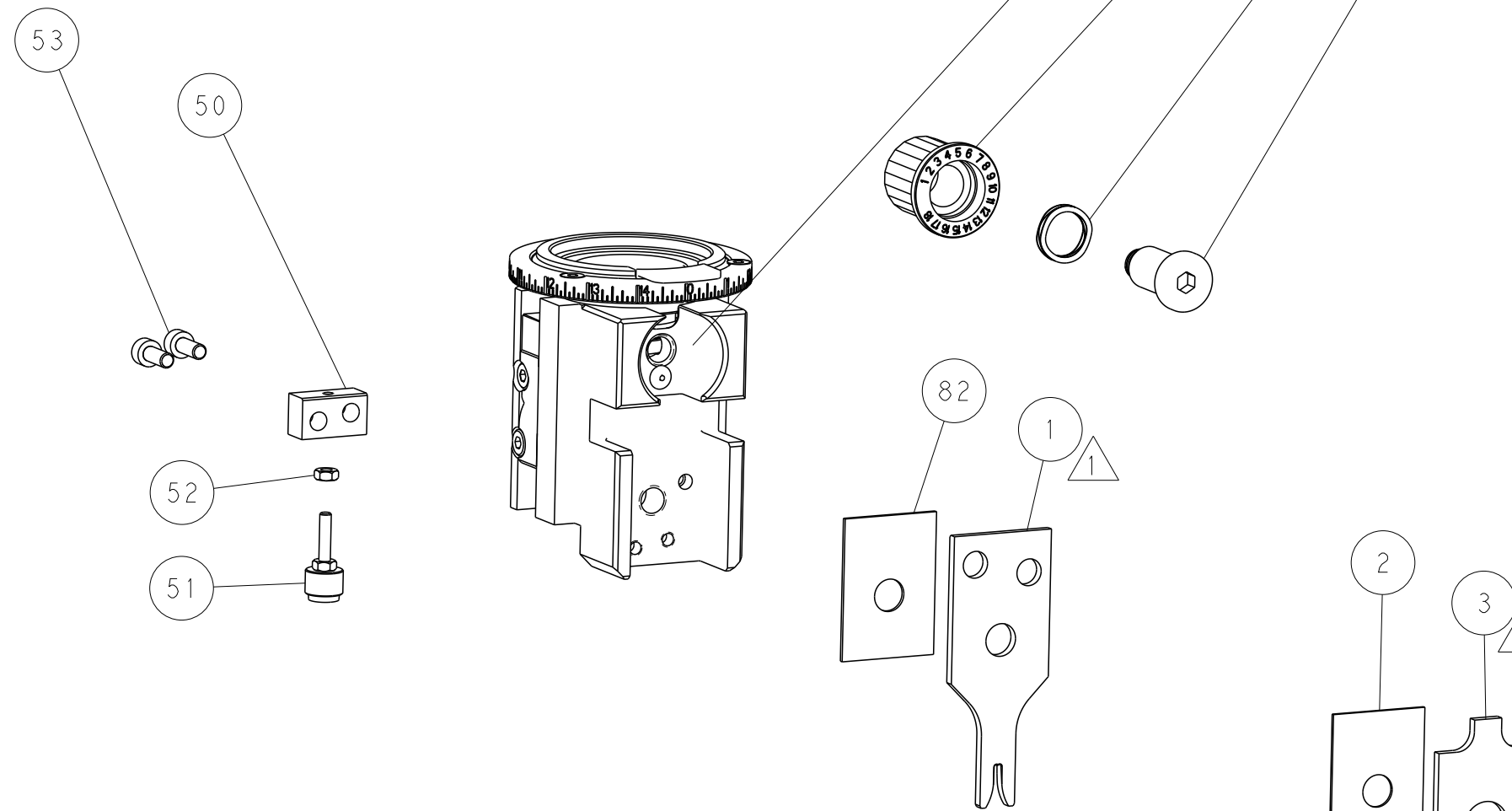
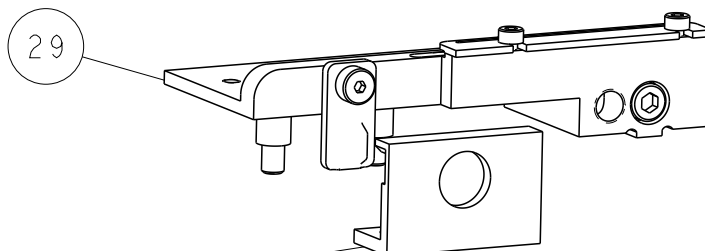
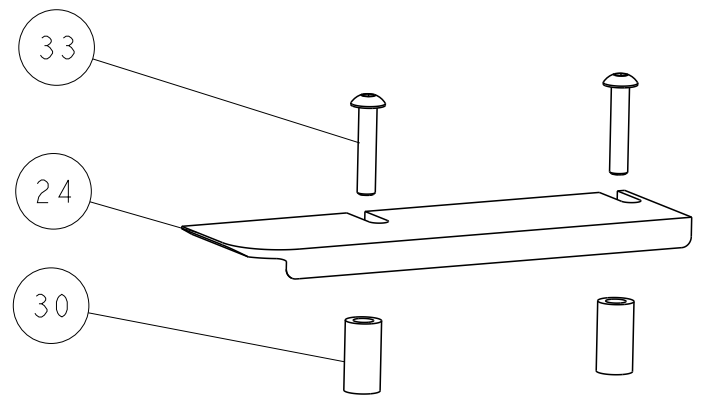
MECHANICAL
POST FEED



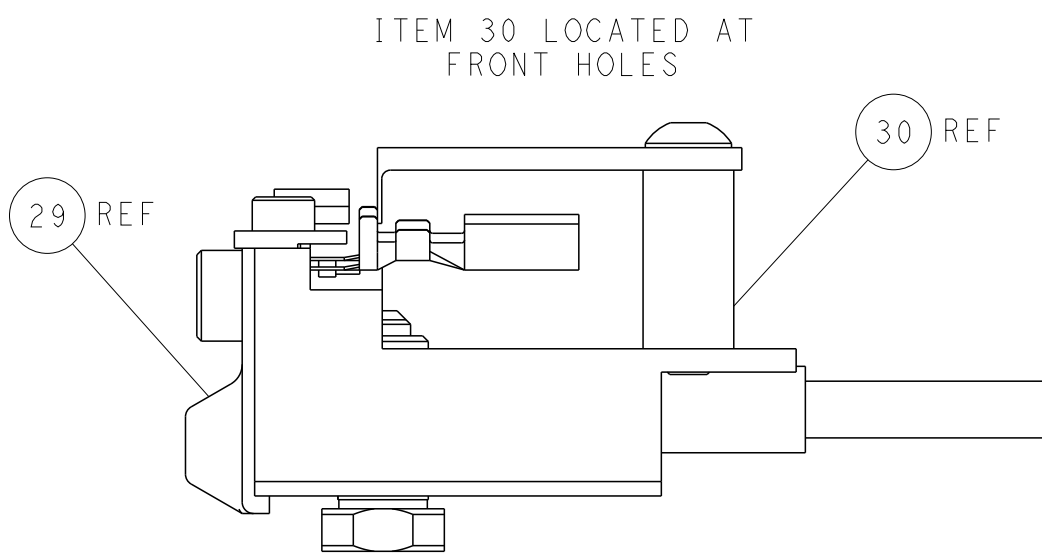
MECHANICAL
PRE FEED



AIR FEED



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



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO CONTACT THE ORGANIZATION FOR THE LATEST VERSION.		DWN K. HUANG 17JUL2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 17JUL2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J. GUO 17JUL2014	SIZE A1	
0 PLC ±.015 1 PLC ±.010 2 PLC ±.008 3 PLC ±.005 4 PLC ±.003 ANGLES ±.010 FINISH		PRODUCT SPEC	CAGE CODE 00779	
MATERIAL -		APPLICATION SPEC	DRAWING NO 2266420	
		WEIGHT -	RESTRICTED TO -	
		Customer Accessible Production Drawing		
		SCALE 1:2	SHEET 4	REV B

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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