



8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266991-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266991-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266991-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266991-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266991-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266991-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266991-7	A	CRIMP TOOLING KIT	-


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.39 mm [.094]	F
INSUL	4.00 mm [.157]	O
APPLICATOR INSTRUCTIONS 408-35042		

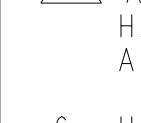
TERMINAL DATA: SUMITOMO TERMINAL				SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: TER-RSF-L							
WIRE STRIP LENGTH				TERMINAL INSULATION DIAMETER RANGE			
3.50-4.50 mm [.138-.177 IN]				Ø			
TERMINAL APPLICATION SPECIFICATION		SUMITOMO Rev 9/10/15		-		-	
TERMINAL APPLICATION SPECIFICATION		-		-		-	
TERMINALS APPLIED							
TE TERMINAL		SUMITOMO TERMINAL		TE SEAL		SUMITOMO SEAL	
2113855-1		8240-0265		1949796-1		7165-0471	
2113855-2		8240-0268		1949797-1		7165-0472	
2113855-3		8240-0271					
3311476-1		8100-4172					
3311476-2		8100-4173					


WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2mm <sup>2</sup>	1.50+/-0.05 [.059+/-0.002]	6.4
1.5mm <sup>2</sup>	1.40+/-0.05 [.055+/-0.002]	7.3

- 

RECOMMENDED SPARE PARTS
- 

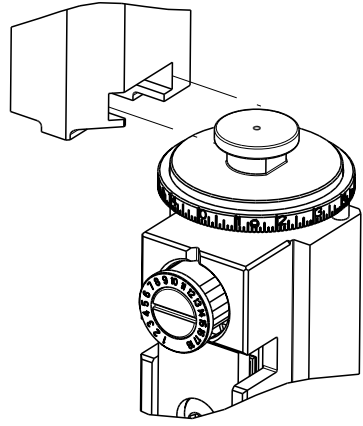
REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 

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.
- 

APPLY TORO-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.

ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



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

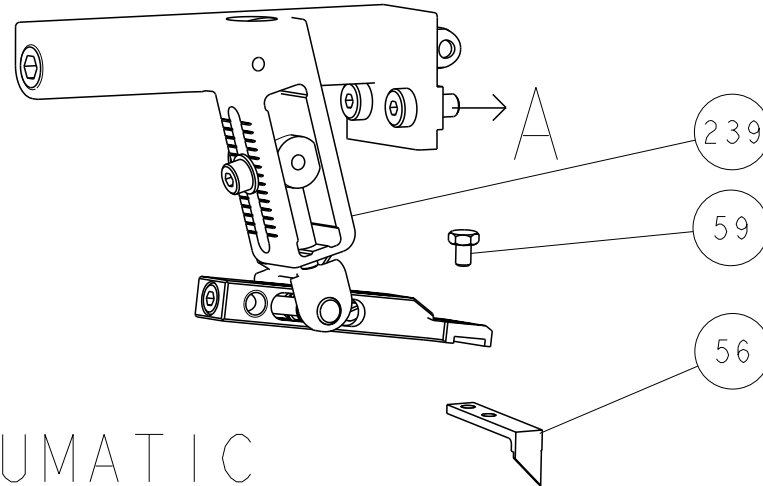
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LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			C	ECR-19-011038	15JUL2019	JAH	TE

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
3	-	-	-	1	1	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	-	1	1	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	-	-	-	1	1	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	-	1	1	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	-	1	1	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	-	1	1	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
5	-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	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	1	1	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	1	9-1803054-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1-240641-0	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	6-1633965-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1-455888-5	SPACER, CRIMPER	2
1	1	2	2	1	1	1	6-1633860-8	CRIMPER, WIRE	1

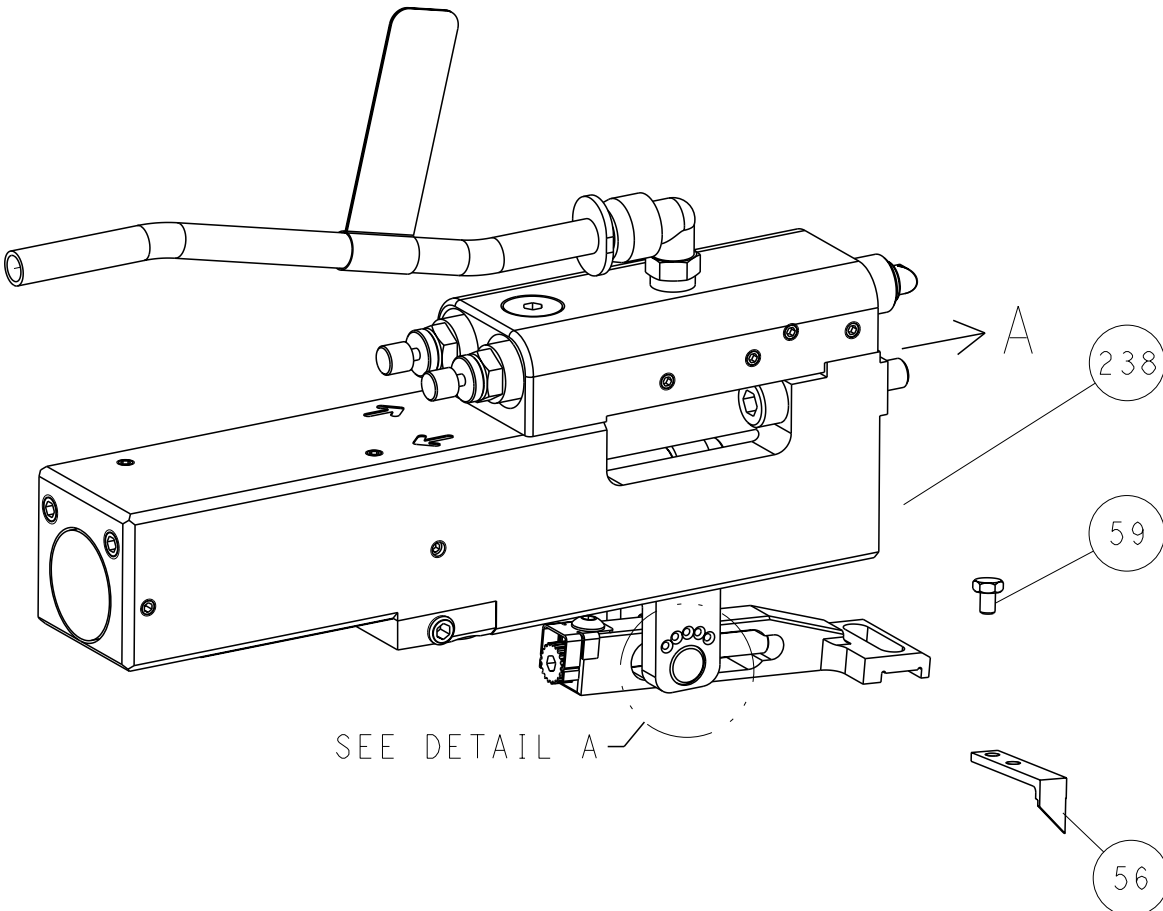
-77-72-71-52-51-2-1		PART NO	DESCRIPTION		ITEM NO
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. THE USER SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN CHK APVD U. GUO	R. HUANG L. ZHANG 23SEP2015 23SEP2015 23SEP2015		TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH		NAME Ocean Side Feed Applicator	
MATERIAL -		WEIGHT -		SIZE A1	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 of 4	
				REV C	

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

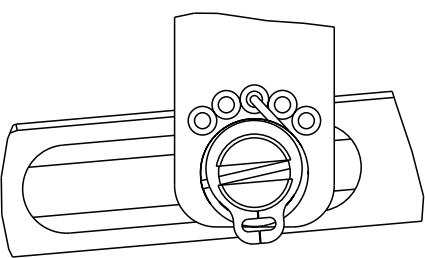
# FEED TYPE MECHANICAL



PNEUMATIC

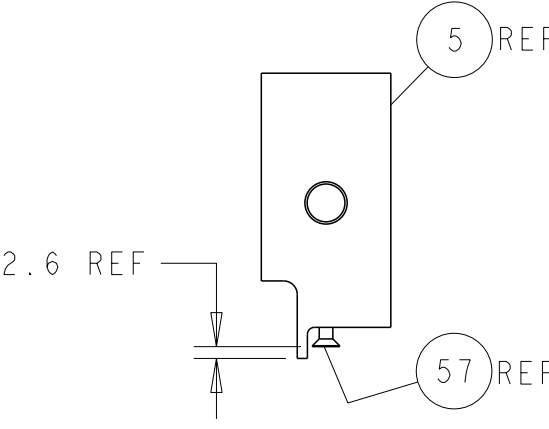
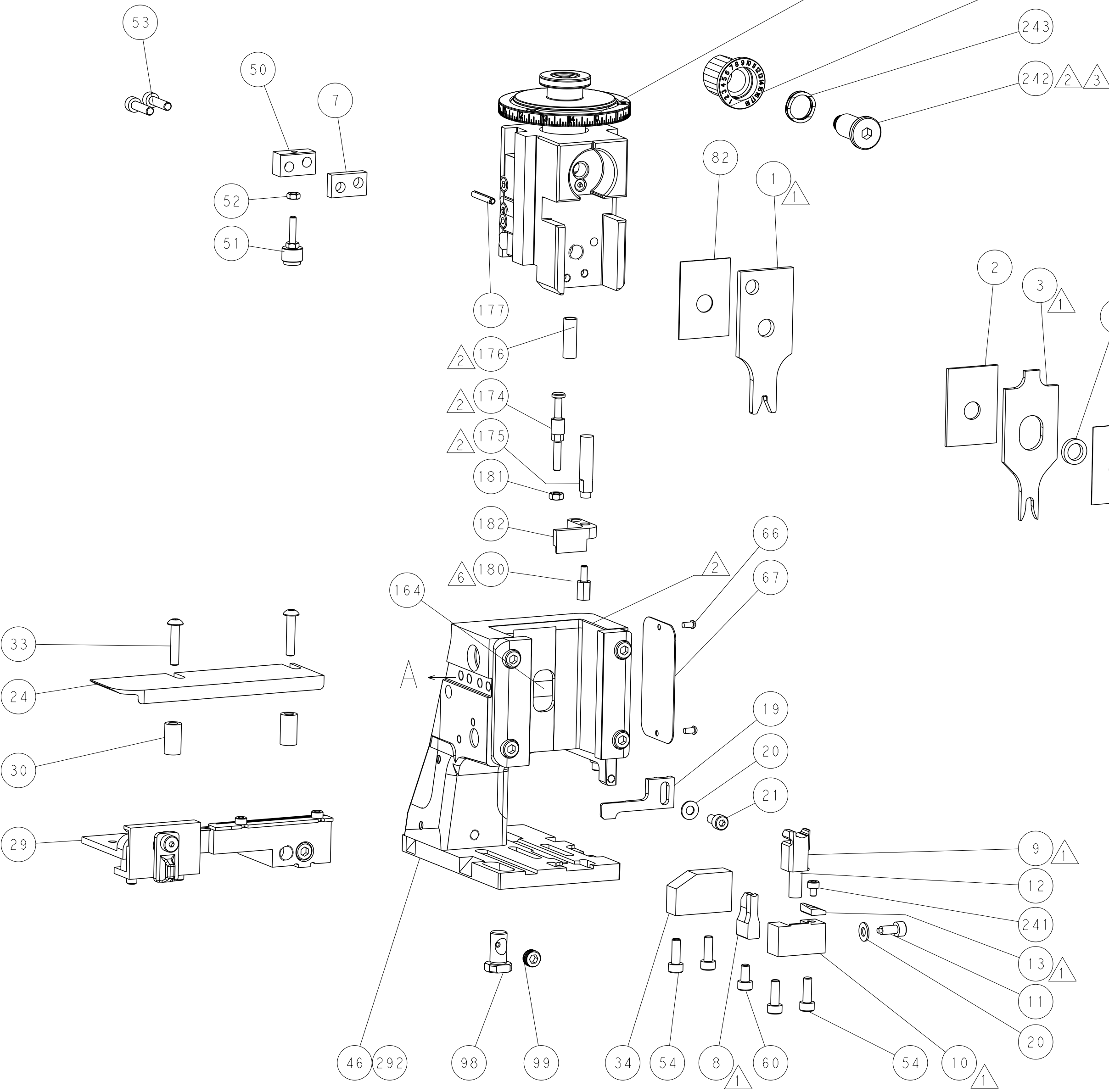
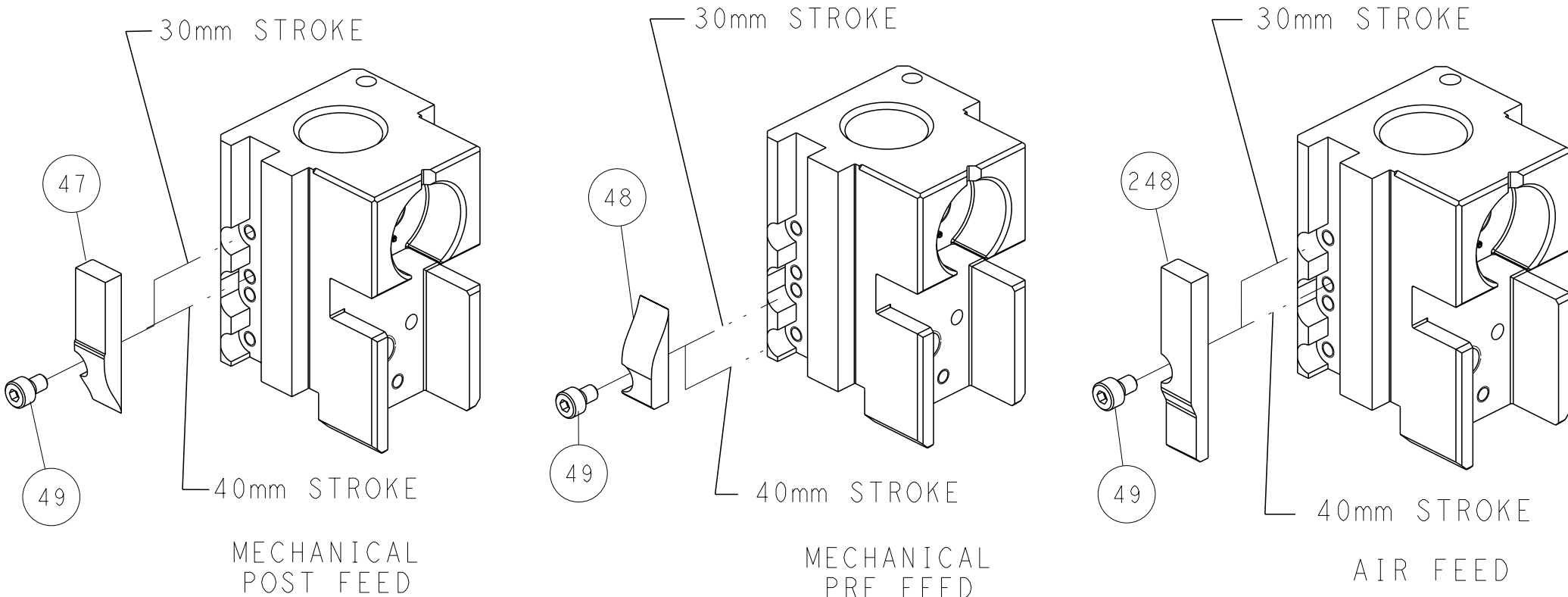


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

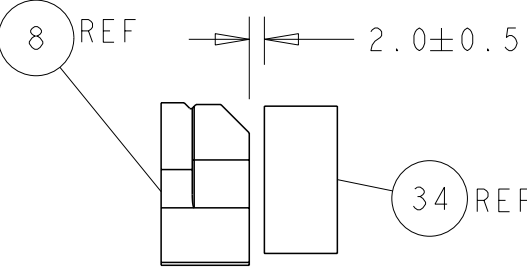


DETAIL A

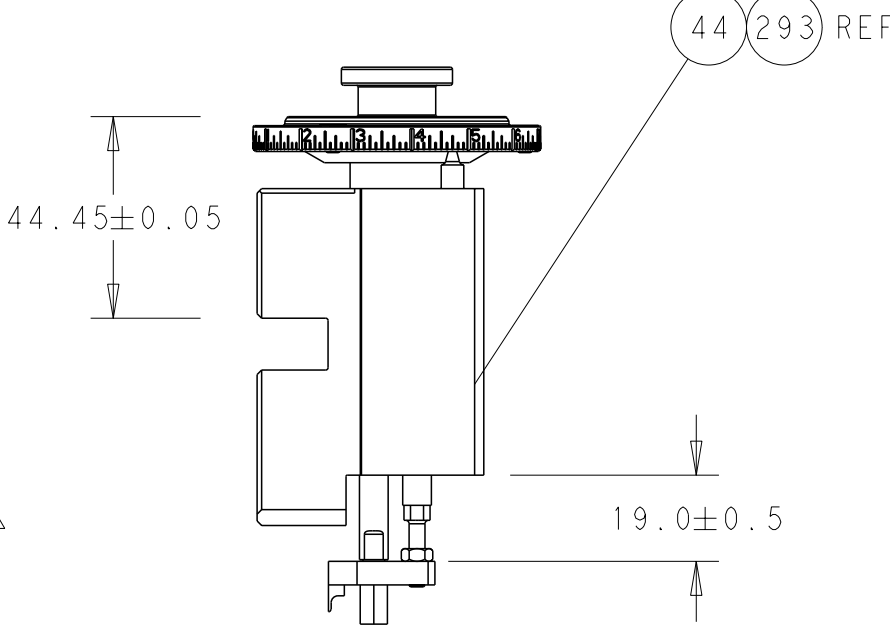
# CAM POSITIONS



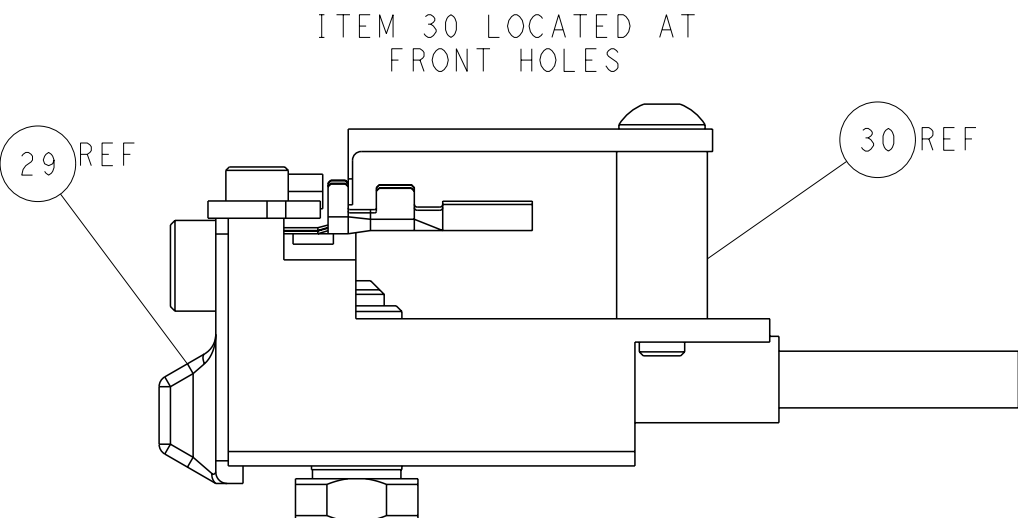
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



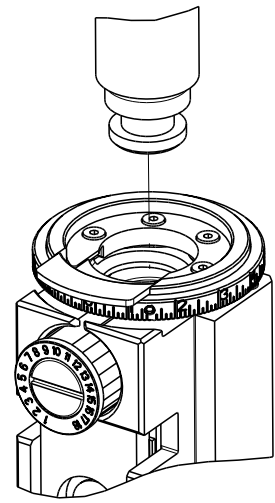
FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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


DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		23SEP2015		TE Connectivity	
mm		0 PLC ±		K. HUANG		23SEP2015		Harrisburg, PA 17105-3608	
		1 PLC ±		L. ZHANG		23SEP2015		Ocean Side Feed	
		2 PLC ±		U. GUO		23SEP2015		Applicator	
		3 PLC ±		PRODUCT SPEC					
		4 PLC ±		APPLICATION SPEC					
		ANGLES ±		WEIGHT		-			
MATERIAL		FINISH		SIZE		CAGE CODE		DRAWING NO	
-		-		A1		00779		C=2266991	
				Customer Accessible Production Drawing		SCALE		1:2	
						SHEET		2 of 4	
						REV		C	

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266991-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266991-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266991-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.39 mm [.094]	F
INSUL	4.00 mm [.157]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: SUMITOMO TERMINAL    SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: TER-RSF-L			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]			TERMINAL INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION		SUMITOMO Rev 9/10/15 -	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2mm <sup>2</sup>	1.50+/-0.05 [.059+/- .002]	6.4
1.5mm <sup>2</sup>	1.40+/-0.05 [.055+/- .002]	7.3



- 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 TORO-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.

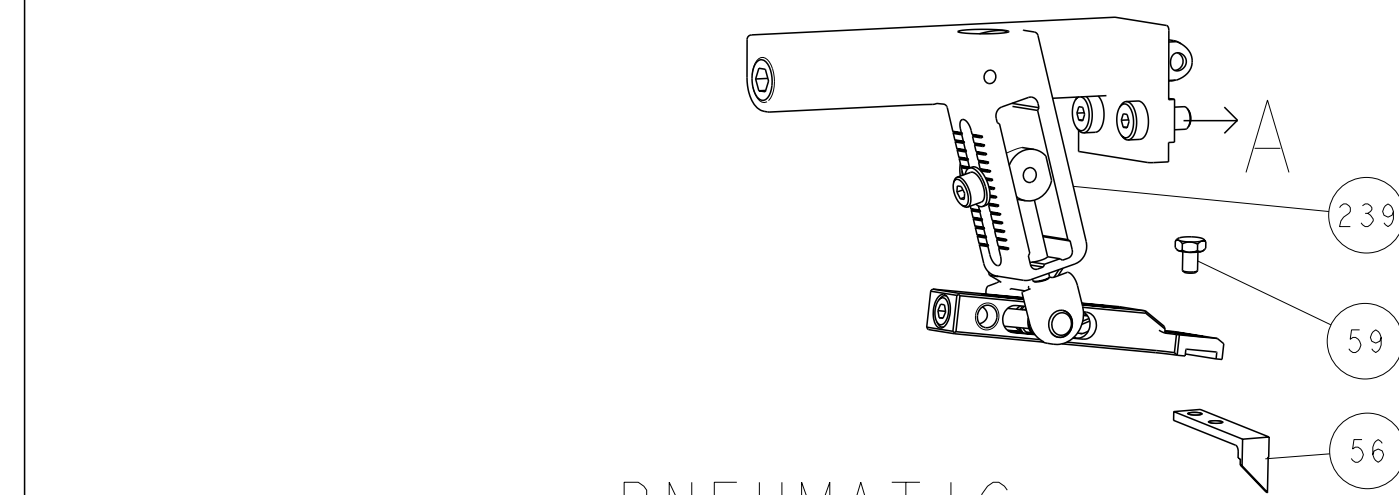
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

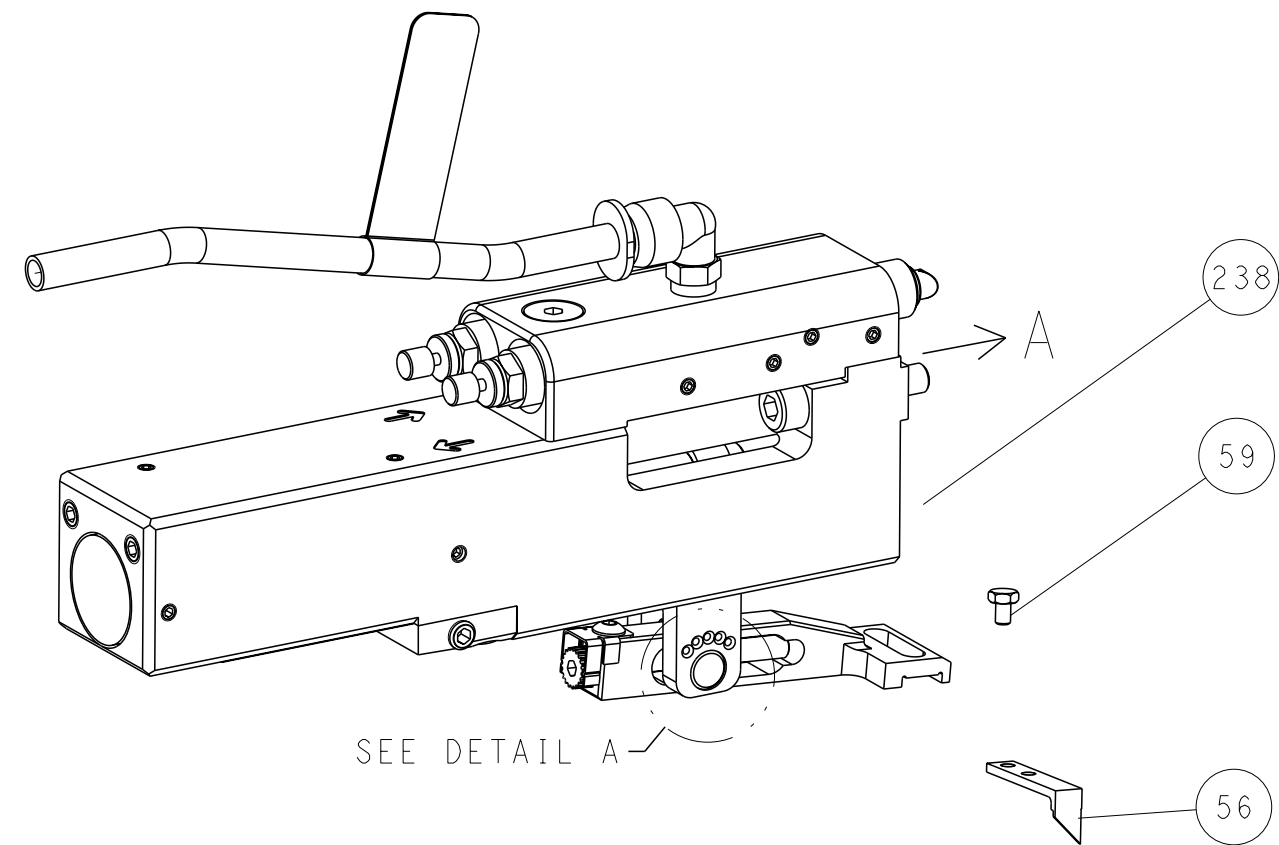
3	-	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
6	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	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	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1803607-3	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
	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51	
1	-	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	1752356-1	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	455888-3	SPACER, CRIMPER	28
	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	9-1803054-6	ANVIL, COMBINATION	8
1	-	1	1	1-240641-0	SPACER	7
	-	-	-	-	-	6
	-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	6-1633965-9	CRIMPER, INSULATION O PREMIUM	3
1	-	1	1	1-455888-5	SPACER, CRIMPER	2
1	1	1	1	6-1633860-8	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
OWN R. HUANG CHK L. ZHANG APVD U. GUO			23SEP2015 23SEP2015 23SEP2015	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 ±			APPLICATION SPEC	SIZE 00779	
MATERIAL -			WEIGHT -	CAGE CODE 00779	
FINISH -			Customer Accessible Production Drawing	SCALE 1:2	SHEET 3 OF 4

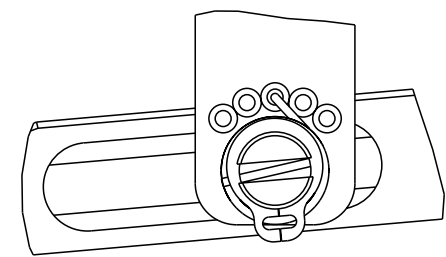
# FEED TYPE MECHANICAL



## PNEUMATIC

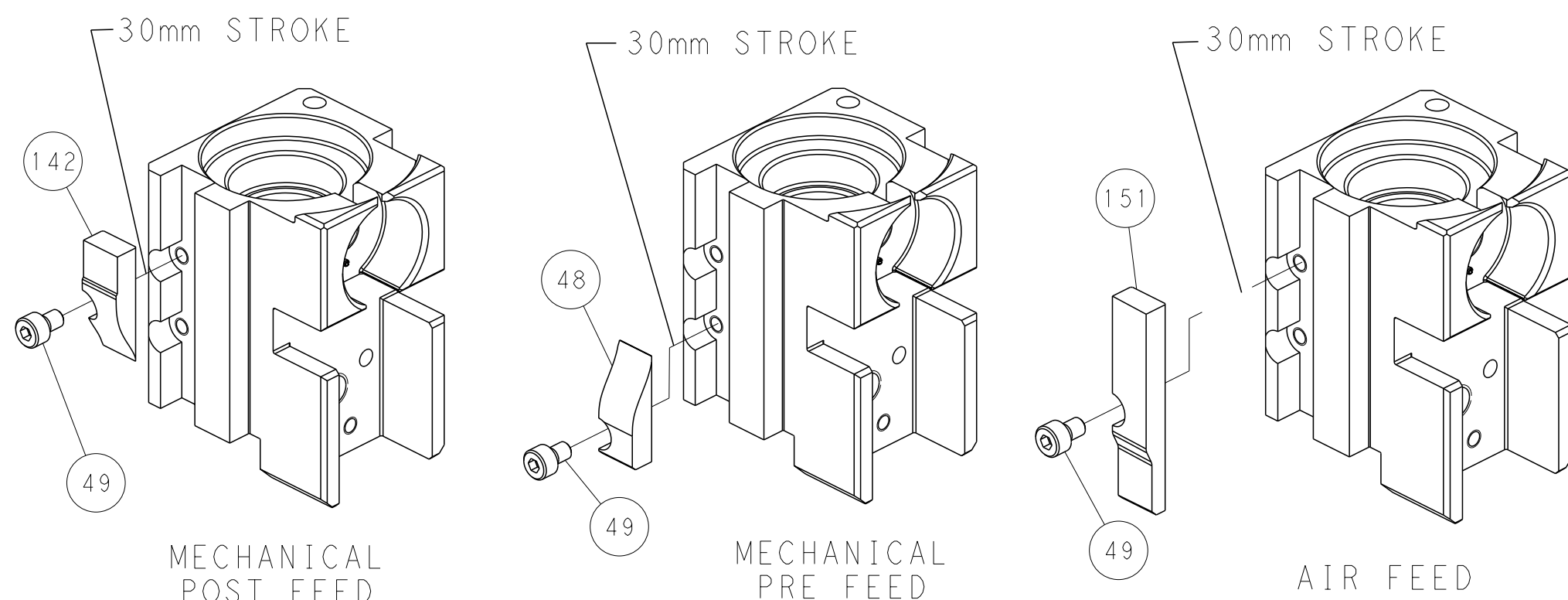


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



DETAIL A

## CAM POSITIONS

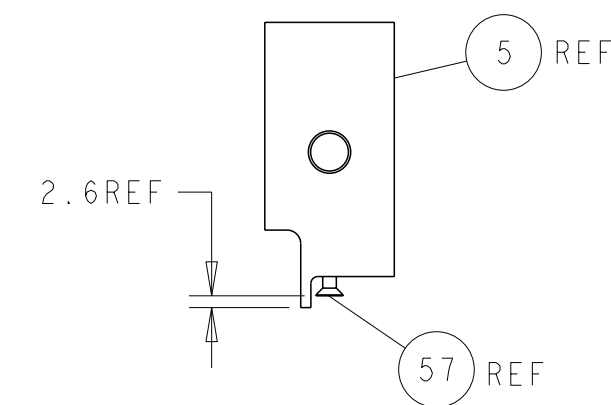


MECHANICAL  
POST FEED

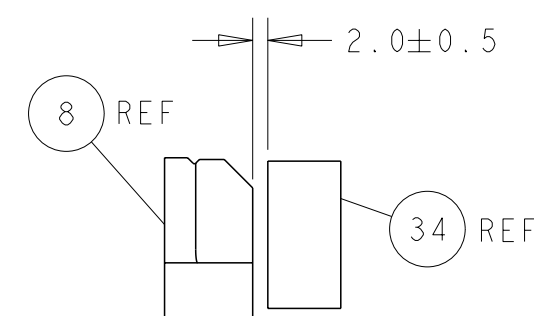
MECHANICAL  
PRE FEED

AIR FEED

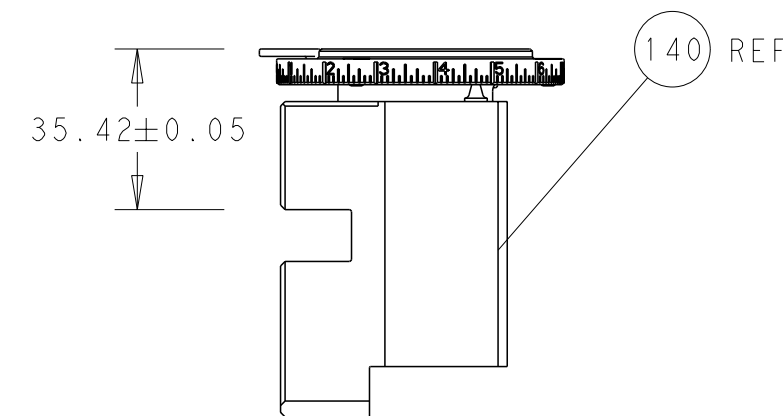
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



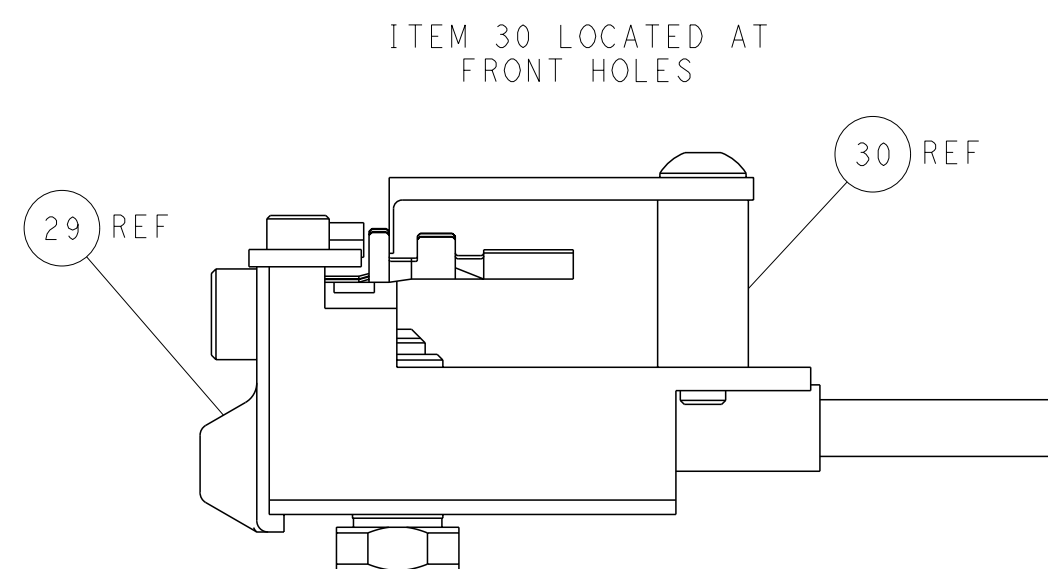
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING DEPARTMENT. SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN K. HUANG 23SEP2015	NAME Ocean Side Feed Applicator
DIMENSIONS: mm		CHK L. ZHANG 23SEP2015	SIZE A1
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing	DRAWING NO 00779 SCALE 1:2
MATERIAL -		RESTRICTED TO -	SHEET 4
		REV C	OF 4

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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[2266991-2](#)