

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266990-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266990-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266990-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266990-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266990-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266990-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266990-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	3.76 mm [.148]	O
APPLICATOR INSTRUCTIONS 408-35042		

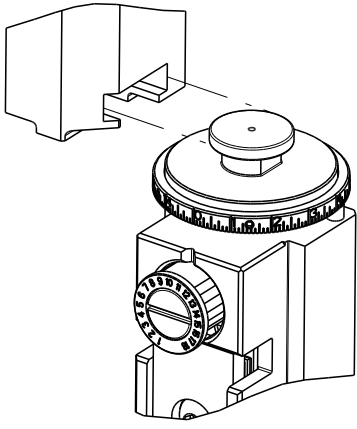
TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.50-5.50 mm [.177-.217 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION	SUMITOMO Rev 12/15/05	-	-
			
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL
1949967-1	8240-0263	1949779-1	7165-0473
1949967-2	8240-0266	1949779-2	7165-0474
1949967-3	8240-0269		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.05+/-0.05 [.041+/- .002]	7.0
0.30mm2	0.95+/-0.05 [.037+/- .002]	7.9



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



*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.

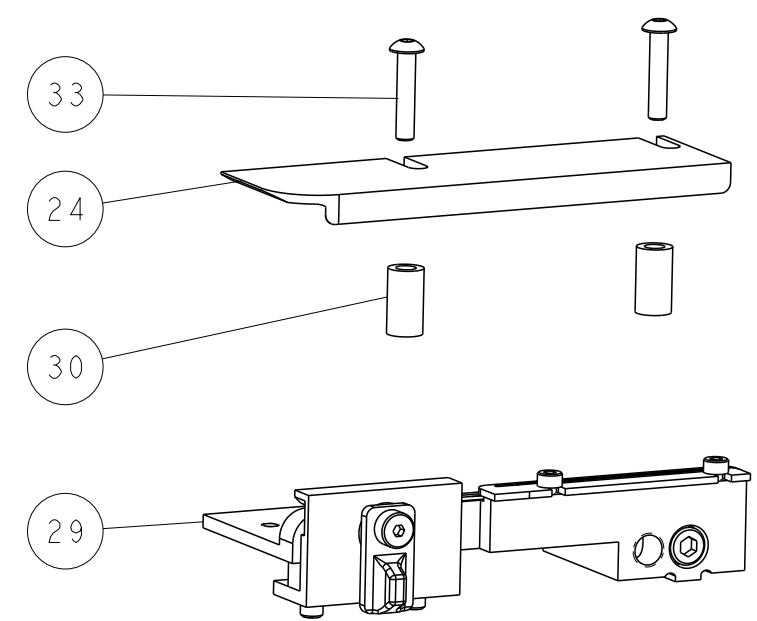
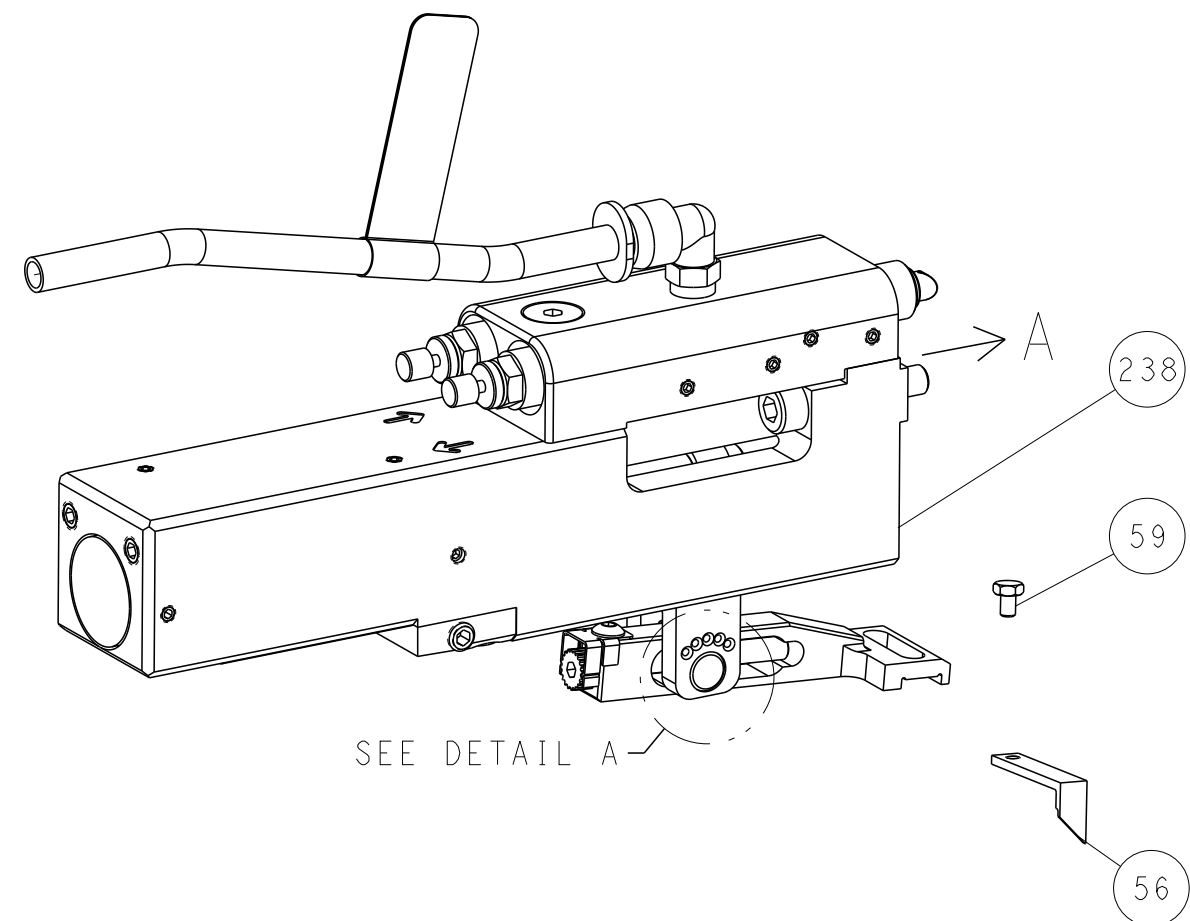
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	09OCT2015	BW	GB
		B		ECR-18-015292	03OCT2018	MS	TE
		C		ECR-19-010921	11JUL2019	TB	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	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	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
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	9931111-1	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
-	1	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	1338683-8	FEED PAWL	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	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	1752356-3	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	879657-2	HOLD DOWN	18
-	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	2	2	1	1	1	1	1-1803249-4	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	240641-2	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	2	2	1	1	1	1	3-1803018-5	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1	1-455888-6	SPACER, CRIMPER	2
1	2	2	1	1	1	1	8-1673600-5	CRIMPER, WIRE	1

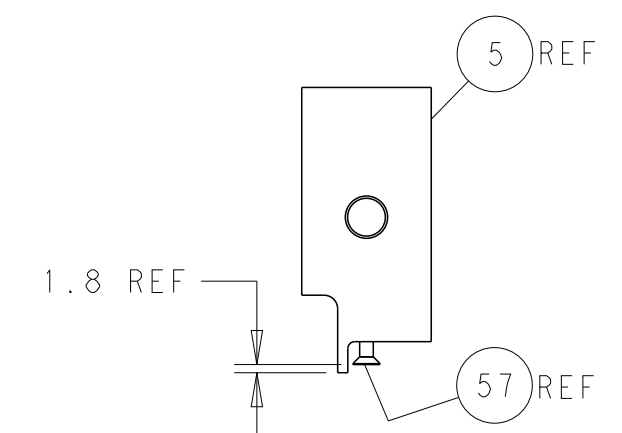
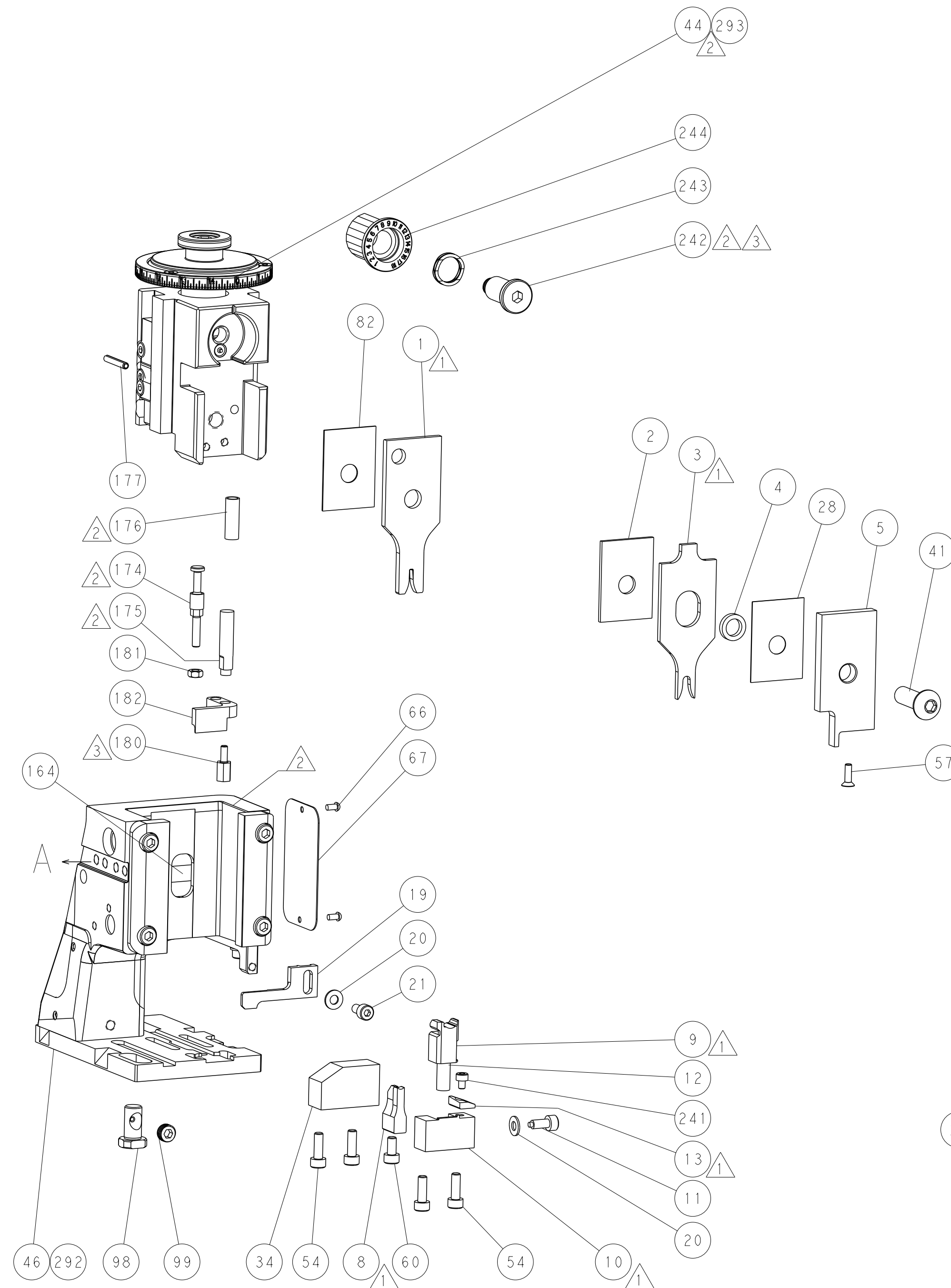
- 77 - 72 - 71 - 52 - 51 - 2 - 1			PART NO		DESCRIPTION			ITEM NO						
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE DRAWING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN	15SEP2015		TE Connectivity							
				CHK	15SEP2015		Harrisburg, PA 17105-3608							
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	15SEP2015	NAME	Ocean Side Feed Applicator							
mm				U. GUO										
		0 PLC ±		PRODUCT SPEC										
		1 PLC ±		-										
		2 PLC ±		APPLICATION SPEC										
		3 PLC ±		-										
4 PLC ±		ANGLES ±					SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
MATERIAL		FINISH		WEIGHT		A1	00779	C=2266990		-				
Customer Accessible Production Drawing							SCALE	1:2	SHEET	1	OF	4	REV	C

PNEUMATIC



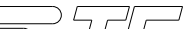
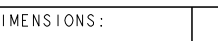
The diagrams illustrate the installation of the mechanical post feed assembly for three different feed types:

- MECHANICAL POST FEED:** Shows the assembly with a 30mm stroke and a 40mm stroke adjustment. The assembly is labeled 47 and 49.
- MECHANICAL PRE FEED:** Shows the assembly with a 30mm stroke and a 40mm stroke adjustment. The assembly is labeled 48 and 49.
- AIR FEED:** Shows the assembly with a 30mm stroke and a 40mm stroke adjustment. The assembly is labeled 248 and 49.



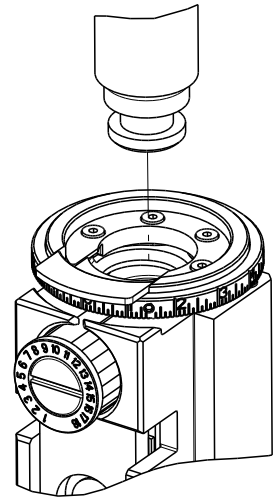
ITEM 30 LOCATED AT FRONT HOLES

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

PART DRAWING IS A CONTROLLED DOCUMENT FROM TFCO ELECTRONICS CORPORATION IT IS SUBJECT TO THE TERMS AND CONDITIONS OF THE PURCHASE ORDER. IT SHOULD BE RETURNED FOR THE LATEST REVISIONS.		DWN 15SEP2015 CHK L ZHAO 15SEP2015 APVD U GUO 15SEP2015		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm				Ocean Side Feed Applicator	
		0 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC - APPLICATION SPEC -	
MATERIAL	FINISH	WEIGHT	SIZE	CAGE CODE	DRAWING NO
	-	-	A1	00779	C=2266990
Customer Accessible Production Drawing			SCALE	SHEET	OF
			1:2	2	4
				REV	C

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PART NUMBER	REVISION
2-2266990-1	C
2-2266990-2	C
7-2266990-7	A
DESCRIPTION	
FINE CRIMP HEIGHT ADJUST	
FINE CRIMP HEIGHT ADJUST	
CRIMP TOOLING KIT	
FEED TYPE	
MECHANICAL	
PNEUMATIC	
-	

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	3.76 mm [.148]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH 4.50-5.50 mm [.177-.217 IN]	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION	SUMITOMO Rev 12/15/05

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	
1949967-1	8240-0263	1949779-1	7165-0473	Ø1.5-1.9
1949967-2	8240-0266	1949779-2	7165-0474	Ø1.0-1.4
1949967-3	8240-0269			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.05+/-0.05 [.041+/-0.002]	7.0
0.30mm2	0.95+/-0.05 [.037+/-0.002]	7.9



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)

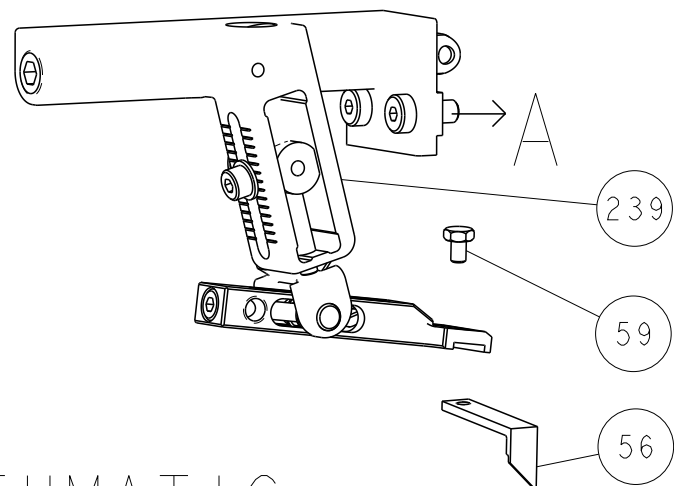
LOC	DIST	REVISONS				
A	66	P	LTR	DESCRIPTION	DATE	DWN
		-		SEE SHEET 1	-	-

-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	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
5	-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338683-8	FEED PAWL	56
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	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	1752356-3	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	879657-2	HOLD DOWN	18
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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1-1803249-4	ANVIL, COMBINATION	8
-	1	1	240641-2	SPACER	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	3-1803018-5	CRIMPER, INSULATION O	3
-	1	1	1-455888-6	SPACER, CRIMPER	2
1	1	1	8-1673600-5	CRIMPER, WIRE	1

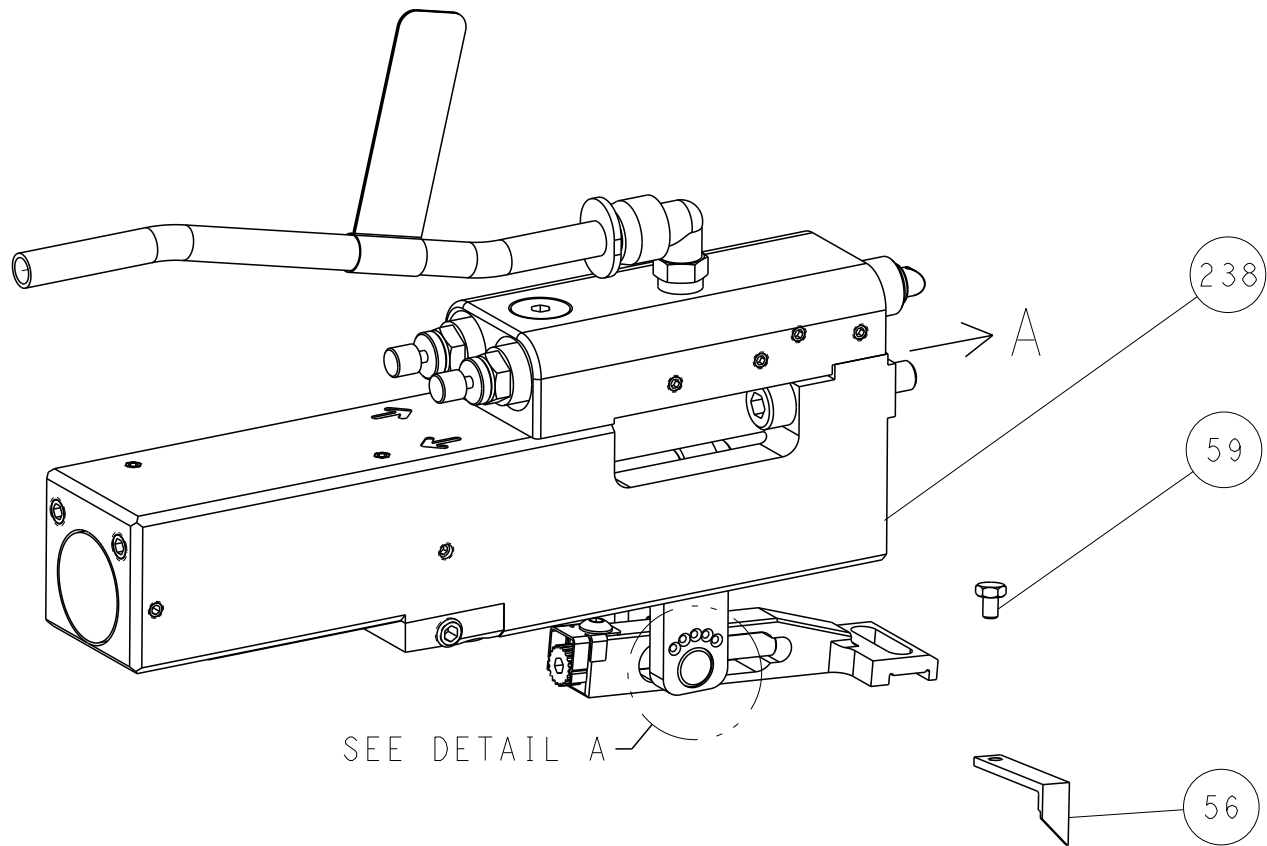
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
DWN			X.ZHAO	15SEP2015	
CHK			L.ZHANG	15SEP2015	
APVD			J.GUO	15SEP2015	
DIMENSIONS:			TOLERANCES UNLESS OTHERWISE SPECIFIED:		
mm			0 PLC	±	
			1 PLC	±	
			2 PLC	±	
			3 PLC	±	
			4 PLC	±	
			ANGLES	±	
			FINISH	±	
MATERIAL			WGT	SCALE	RESTRICTED TO
-			-	1:2	-
Customer Accessible Production Drawing			00779	3	4
			©=2266990	REV	C

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

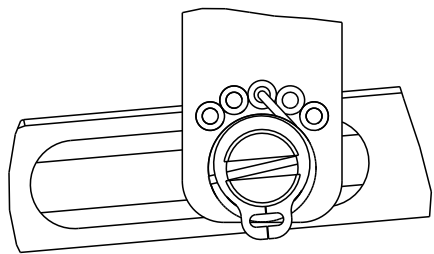
FEED TYPE MECHANICAL



PNEUMATIC

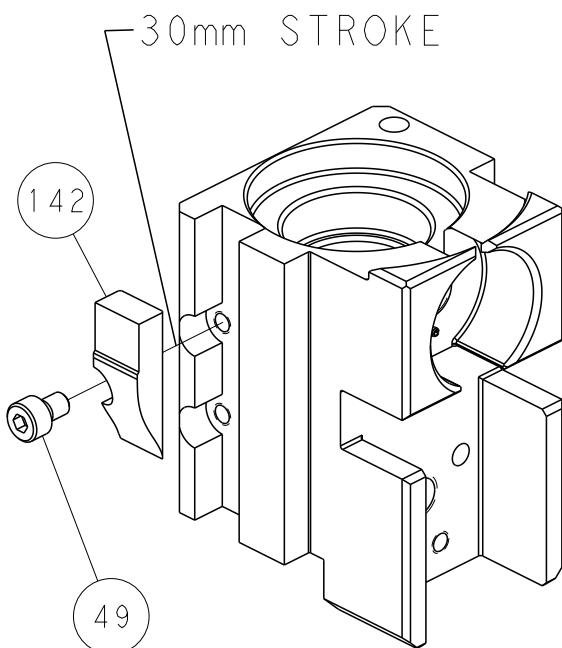


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

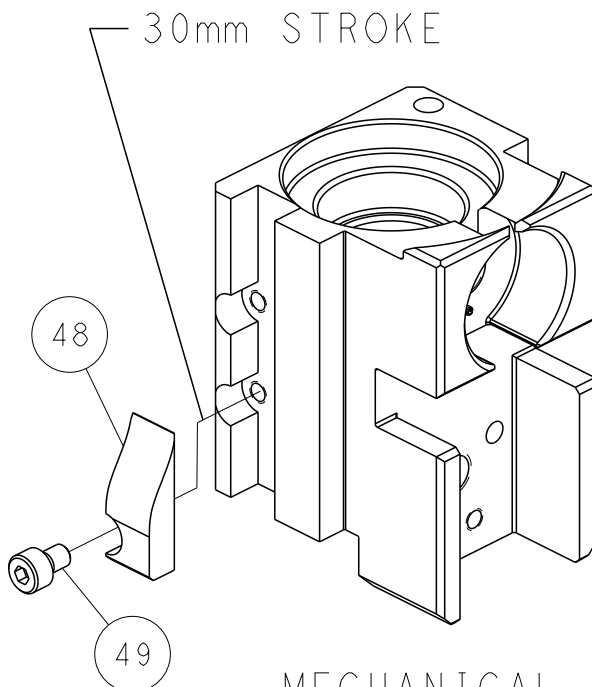


DETAIL A

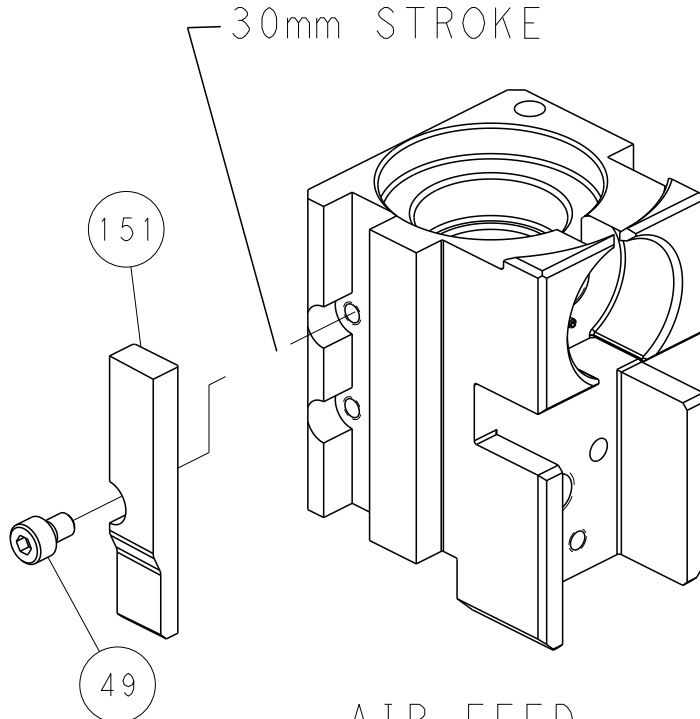
CAM POSITIONS



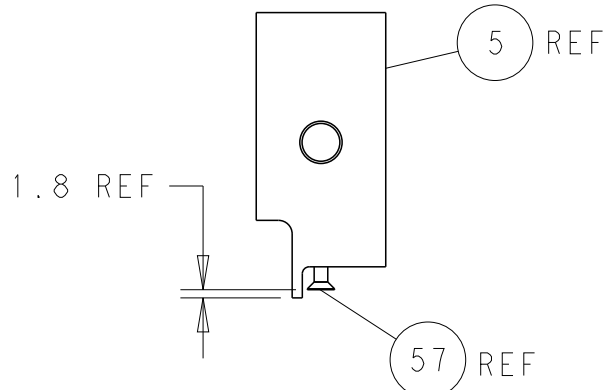
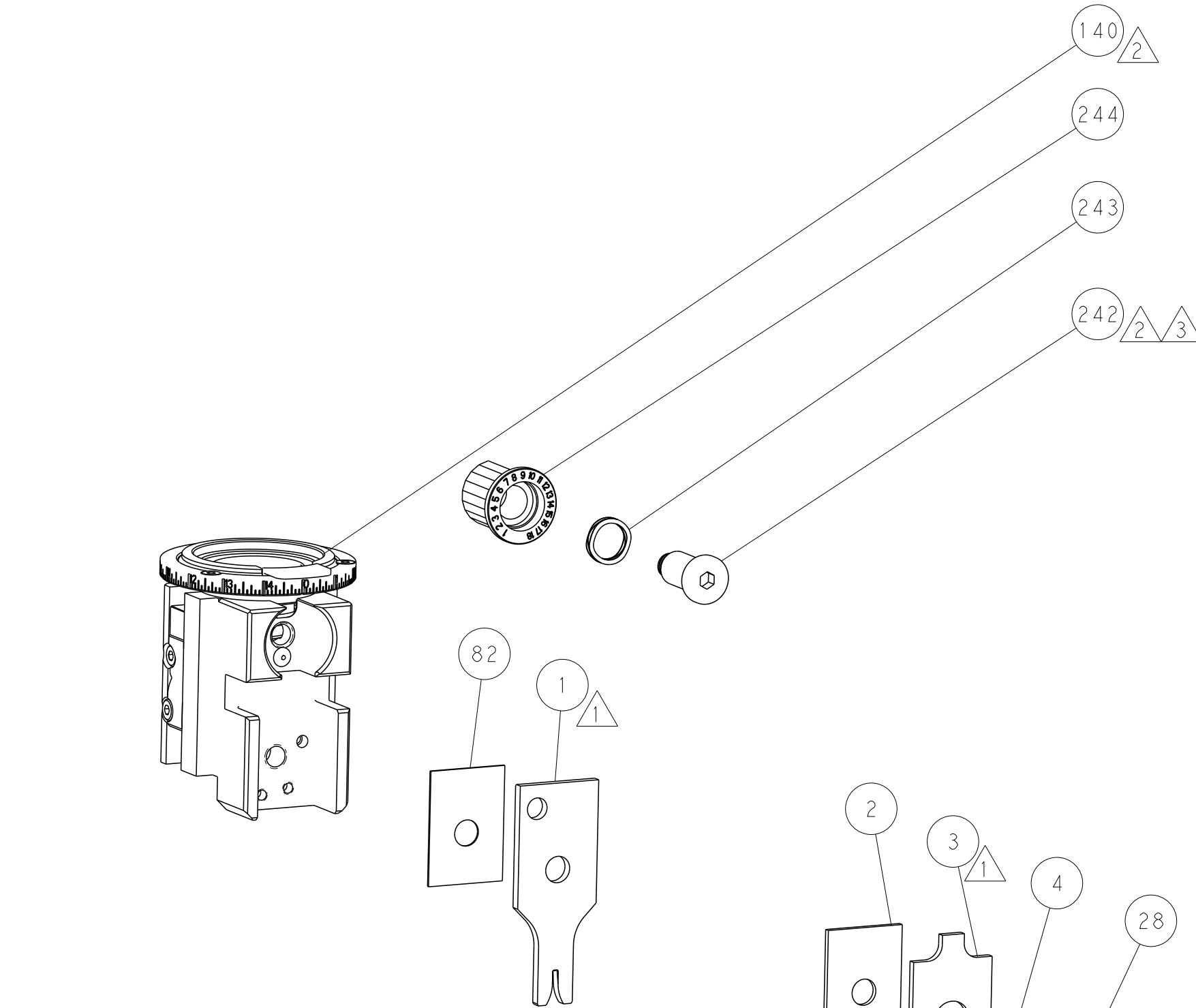
MECHANICAL
POST FEED



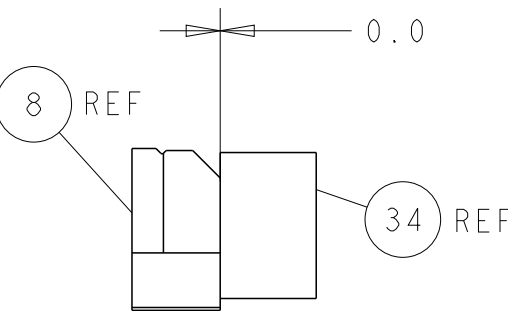
MECHANICAL
PRE FEED



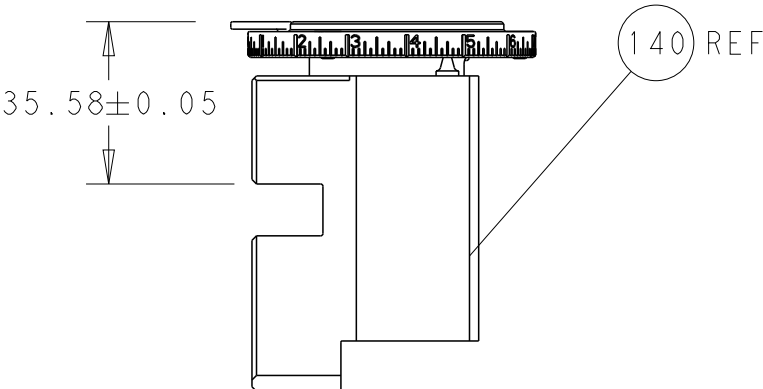
AIR FEED



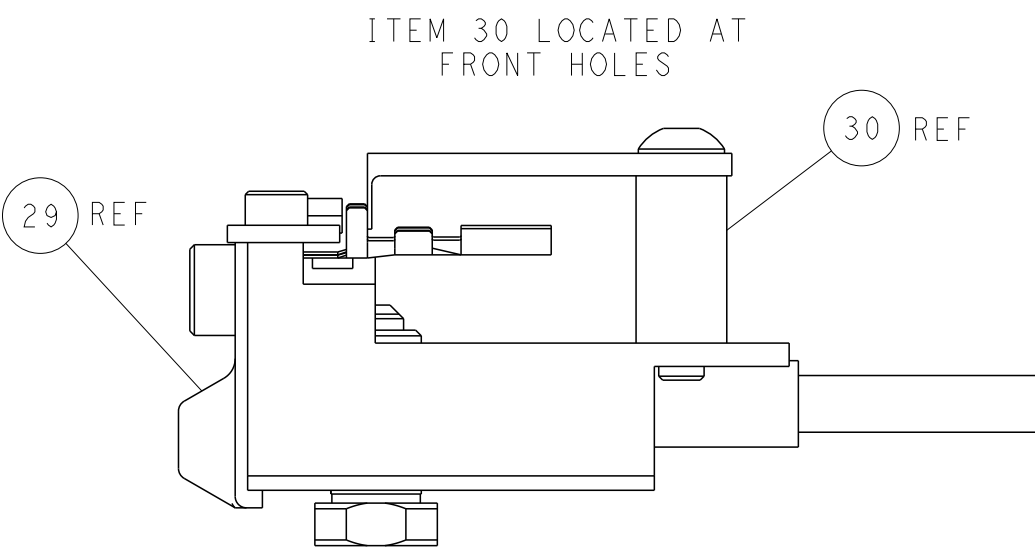
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

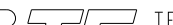


RAM SET-UP



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER OF THIS DRAWING SHALL BE RESPONSIBLE FOR THE LATEST VERSION.				DWN	15SEP2015	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK	15SEP2015				
				APVD	15SEP2015	NAME			
				PRODUCT SPEC		Ocean Side Feed Applicator			
				APPLICATION SPEC					
				WEIGHT		SIZE			
						A1 00779 C=2266990			
						Customer Accessible Production Drawing			
						SCALE 1:2 SHEET 4 OF 4 REV C			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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