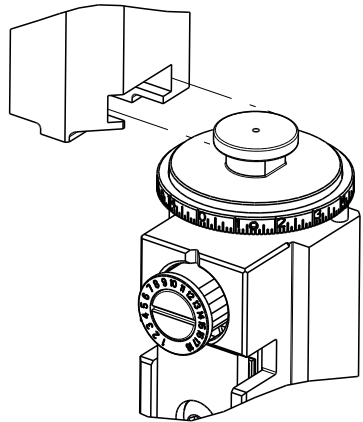
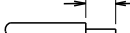


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266090-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266090-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266090-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266090-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266090-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.54 mm [1.00]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: ITT CANNON TERMINAL ITT CANNON CRIMP SPECIFICATION			
TERMINAL NAME: SURE SEAL 0.5-1.0MM SS20 CONTACT			
WIRE STRIP LENGTH 3.20-4.20 mm [1.26-.165 IN]			INSULATION DIAMETER RANGE Ø1.80-2.40 mm [1.071-.094 IN]
TERMINAL APPLICATION SPECIFICATION		CAS25064	-
TERMINALS APPLIED		-	-
TERMINALS APPLIED			
TE TERMINAL	ITT CANNON TERMINAL	TE TERMINAL	ITT CANNON TERMINAL
1949062-1	SS121348-20	1572488-1	SS121347-20

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
17 AWG OR 1.00mm2	1.32+/-0.03 [1.052+/-0.001]	7.9
18 AWG OR 0.75mm2	1.30+/-0.03 [1.051+/-0.001]	8.1
20 AWG OR 0.50mm2	1.18+/-0.03 [1.046+/-0.001]	9.5



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. 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
		I		DEVELOPMENT	29OCT2013	KH	UG
		A		RELEASED	27DEC2013	BH	GB
		B		ECR-21-122594	30NOV2021	JWC	TE

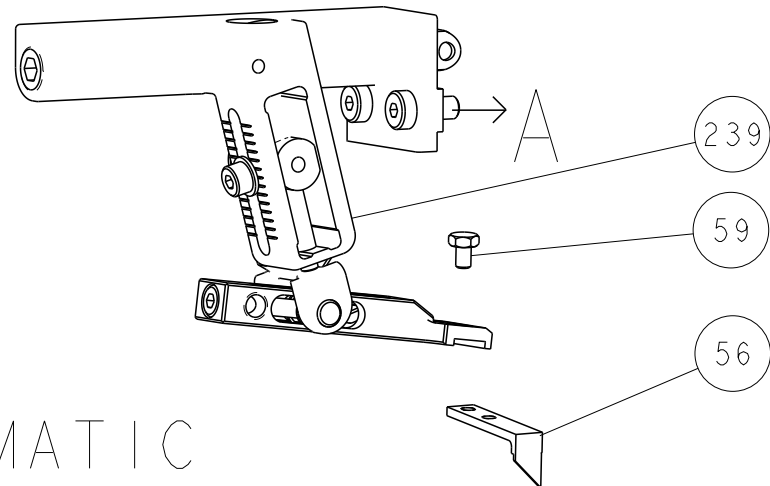
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-3	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
	-	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	1-1424186-6	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	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
	-	1	1	1	1	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
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	6-1333203-6	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1633965-3	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	2	2	1	1	1-456404-5	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST EDITION.		DWN R. HUANG CHK L. ZHANG APVD J. GUO	29OCT2013 29OCT2013 29OCT2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH		± ± ± ± ± ± ±		PRODUCT SPEC APPLICATION SPEC	
MATERIAL		WEIGHT		SIZE 00779	
-		-		C=2266090	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 OF 4	
				REV B	

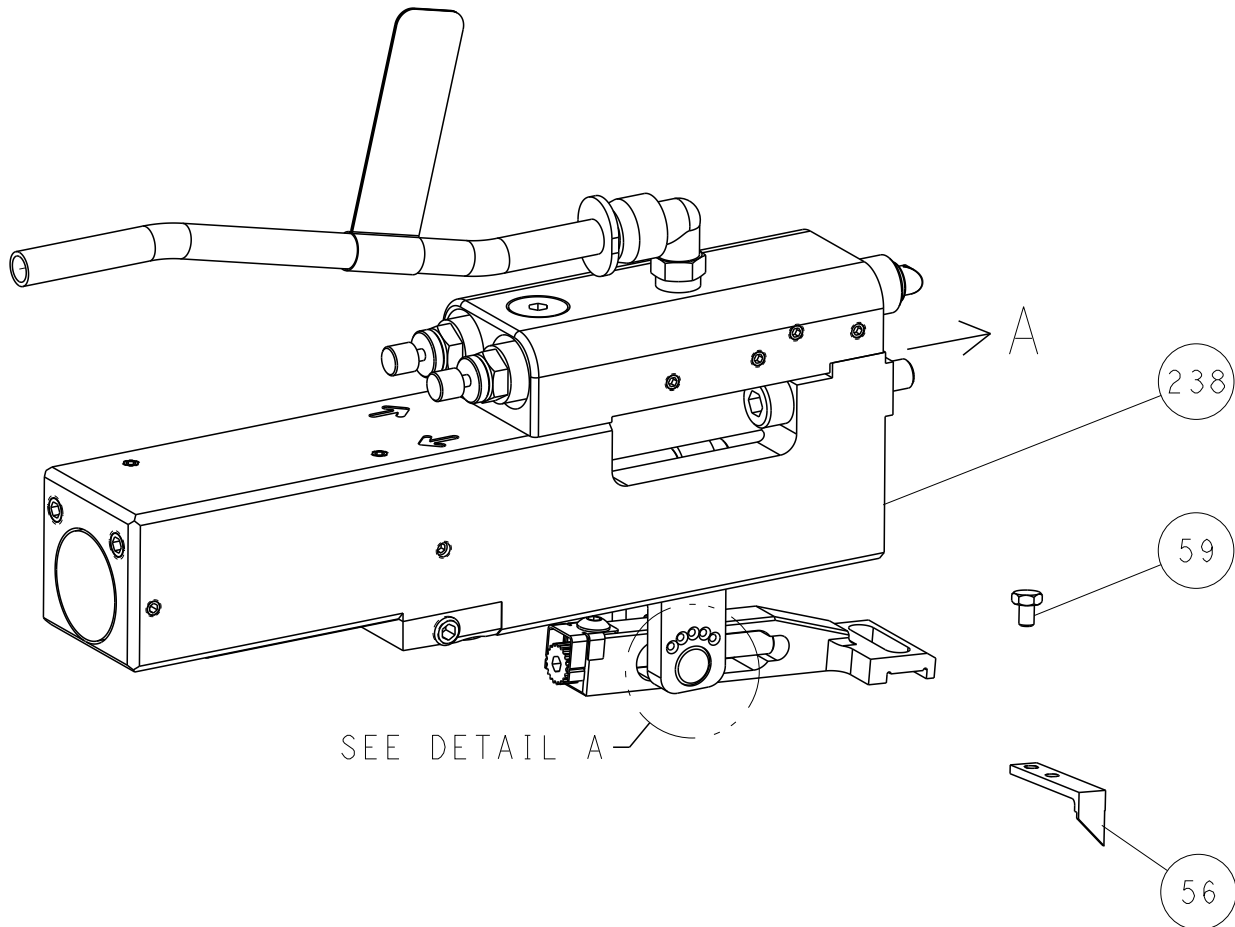
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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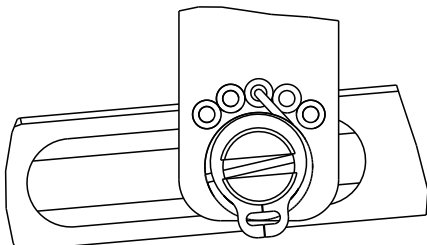
FEED TYPE MECHANICAL



PNEUMATIC

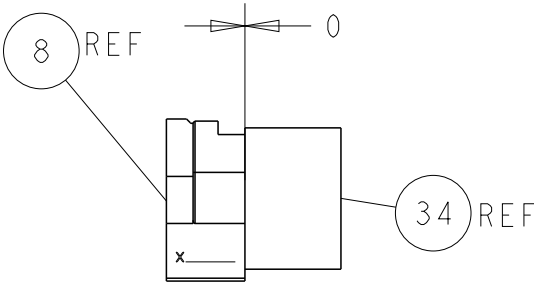
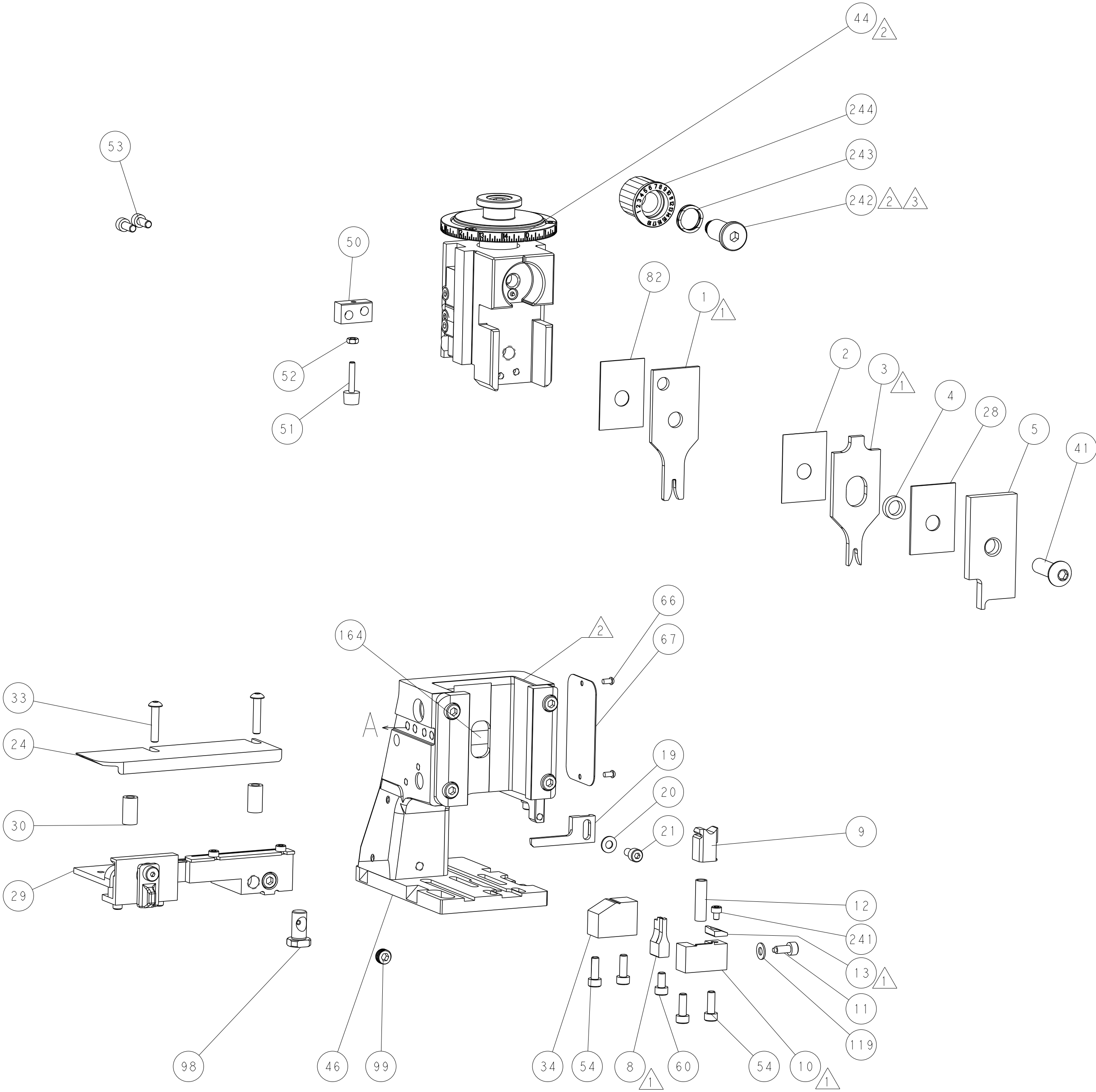
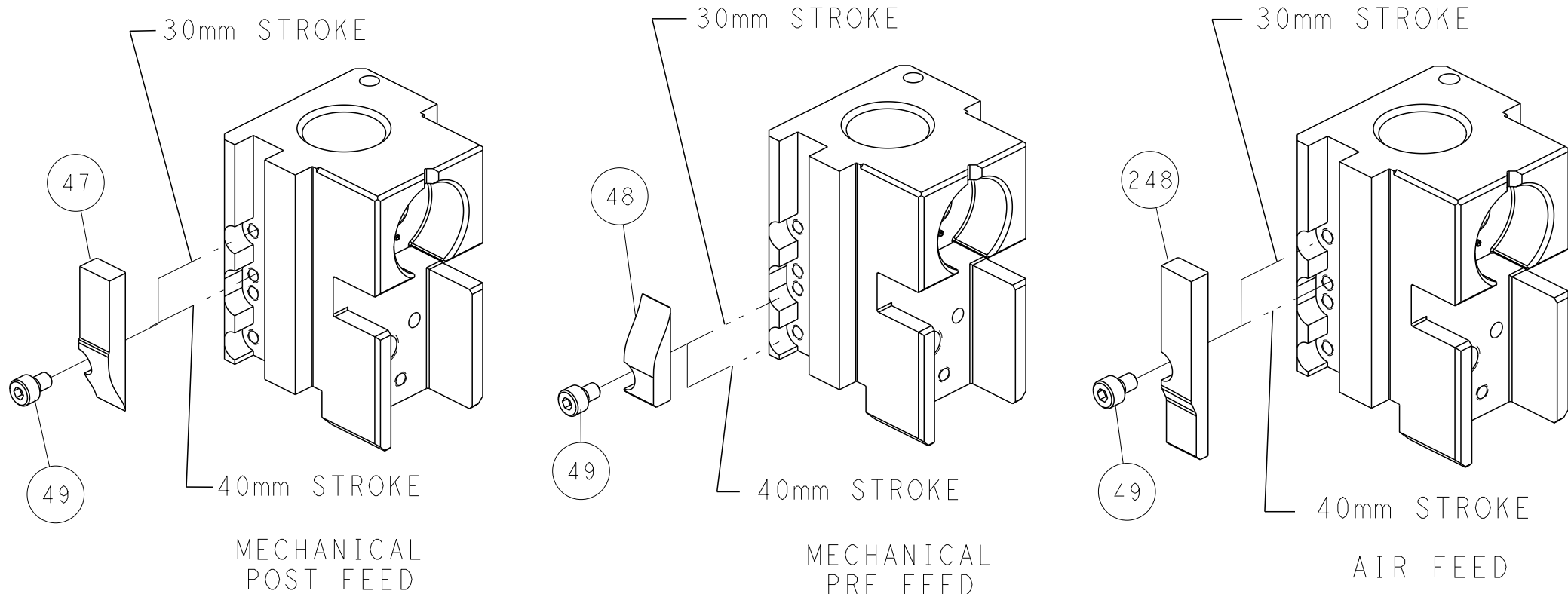


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

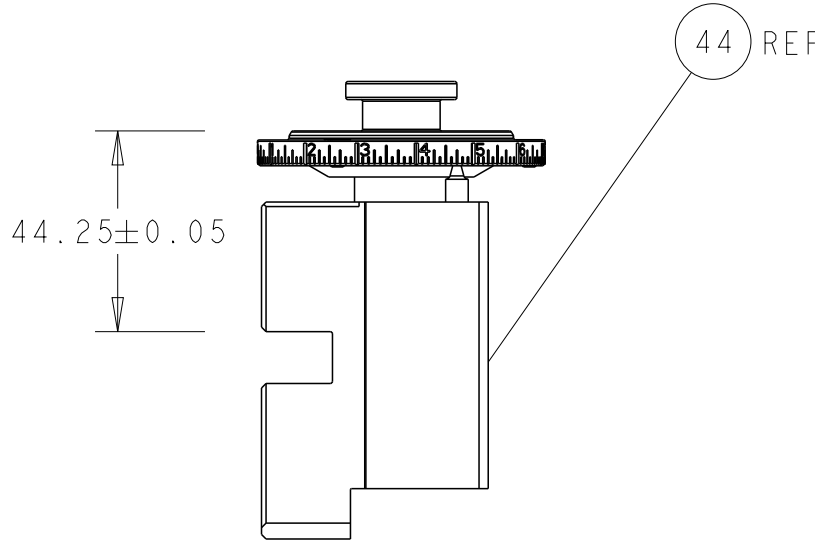


DETAIL A

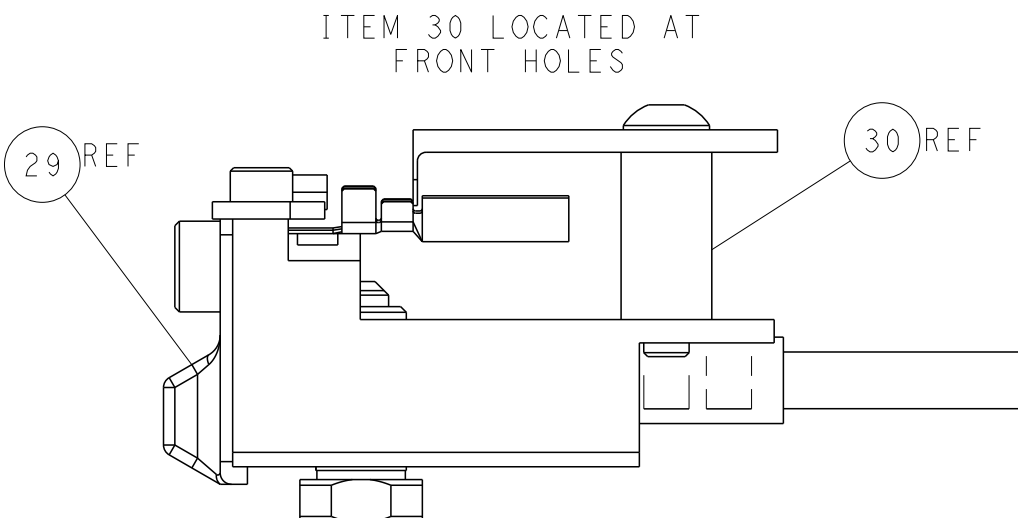
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

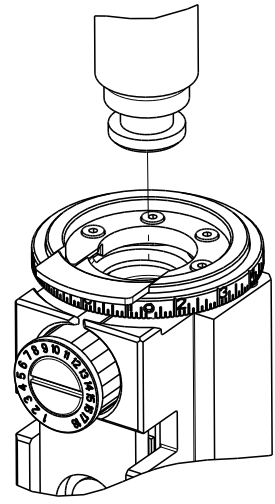
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO COMPANY'S QUALITY CONTROL AND INSPECTION ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN K. HUANG 29OCT2013	TE Connectivity Harrisburg, PA 17105-3608	
CHK L. ZHANG 29OCT2013				NAME	Ocean Side Feed Applicator	
APVD J. GUO 29OCT2013				PRODUCT SPEC	RESTRICTED TO	
APPLICATION SPEC				SIZE	A1	
MATERIAL				CAGE CODE	00779	
FINISH				DRAWING NO	C=2266090	
WEIGHT				Customer Accessible Production Drawing	SCALE 1:2	
				SHEET 2 of 4	REV B	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266090-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266090-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266090-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.54 mm [.100]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: ITT CANNON TERMINAL ITT CANNON CRIMP SPECIFICATION			
TERMINAL NAME: SURE SEAL 0.5-1.0MM SS20 CONTACT			
WIRE STRIP LENGTH 3.20-4.20 mm [.126-.165 IN]		INSULATION DIAMETER RANGE Ø1.80-2.40 mm [.071-.094 IN]	
TERMINAL APPLICATION SPECIFICATION	CAS25064	-	-
TERMINALS APPLIED			
TE TERMINAL	ITT CANNON TERMINAL	TE TERMINAL	ITT CANNON TERMINAL
1949062-1	SS121348-20	1572488-1	SS121347-20

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
17 AWG OR 1.00mm2	1.32+/-0.03 [.052+/- .001]	7.9
18 AWG OR 0.75mm2	1.30+/-0.03 [.051+/- .001]	8.1
20 AWG OR 0.50mm2	1.18+/-0.03 [.046+/- .001]	9.5



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

5. 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	REVISIONS				
		P	LTR	DESCRIPTION	DATE	DWN
A	66	-	-	SEE SHEET 1	-	-

-	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	-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	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	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	1-1424186-6	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	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	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	6-1333203-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1-456404-5	CRIMPER, WIRE PREMIUM	1

-77-22-21			PART NO		DESCRIPTION			ITEM NO	
FOR PRODUCTION CONSTRUCTION OR FOR ENGINEERING ORGANIZATION LATEST REVISION			OWN 29OCT2013		 TE Connectivity Harrisburg, PA 17105-3608				
			CHK 29OCT2013						
			APVD 29OCT2013						
			U GUO 29OCT2013						
TO DIMENSIONS UNLESS OTHERWISE SPECIFIED:			PRODUCT SPEC		NAME			Ocean Side Feed Applicator	
			-						
			APPLICATION SPEC						
			-						
SIZE			CAGE CODE		DRAWING NO			RESTRICTED TO	
A1			00779		C=2266090			-	
WEIGHT			-		SCALE			1:2	
SHEET			3		OF			4	
REV			B		REV			B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	DWN	APVD
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D

C

B

A

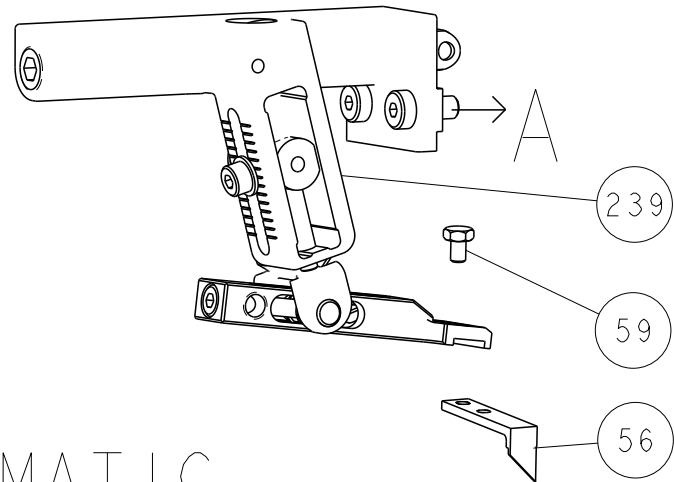
D

C

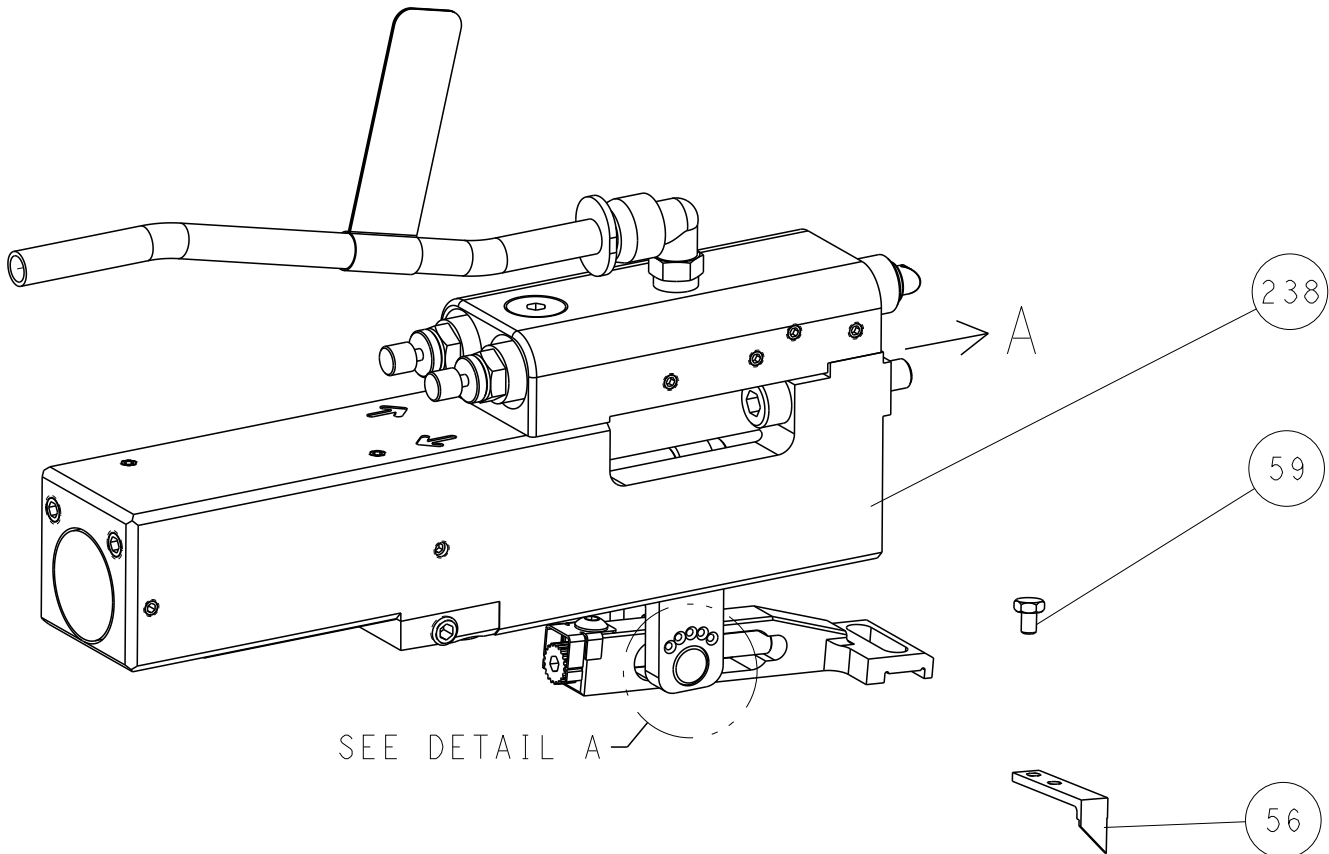
B

A

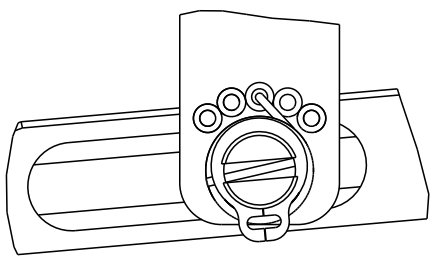
FEED TYPE MECHANICAL



PNEUMATIC

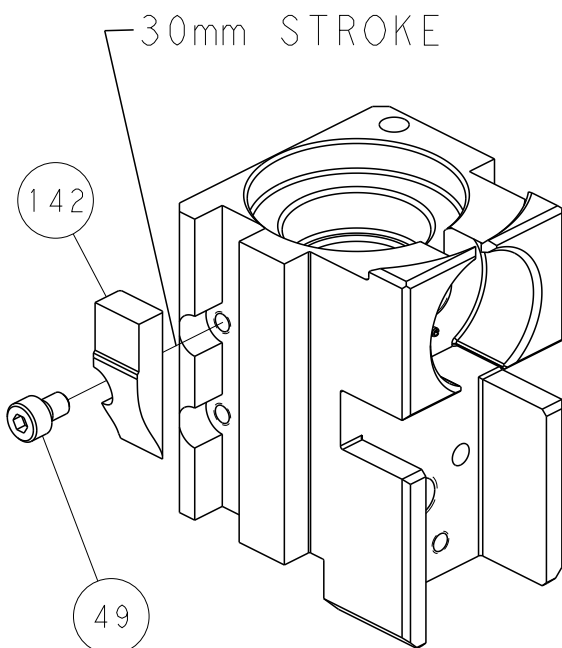


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

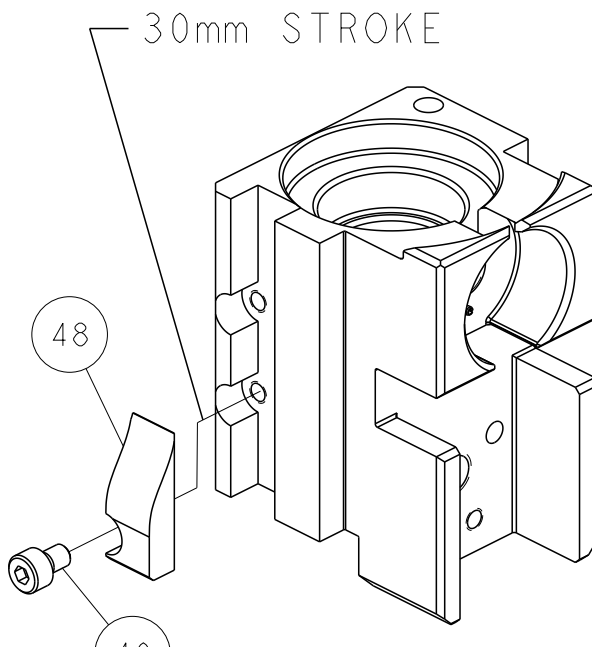


DETAIL A

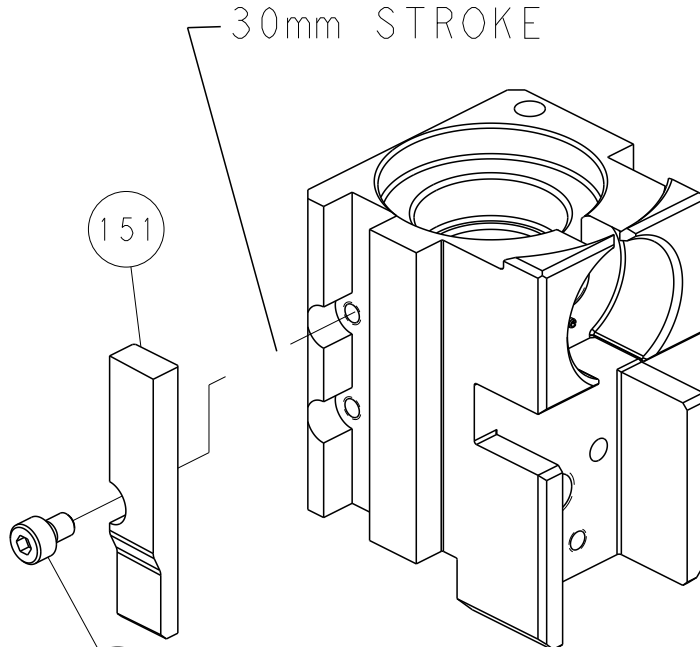
CAM POSITIONS



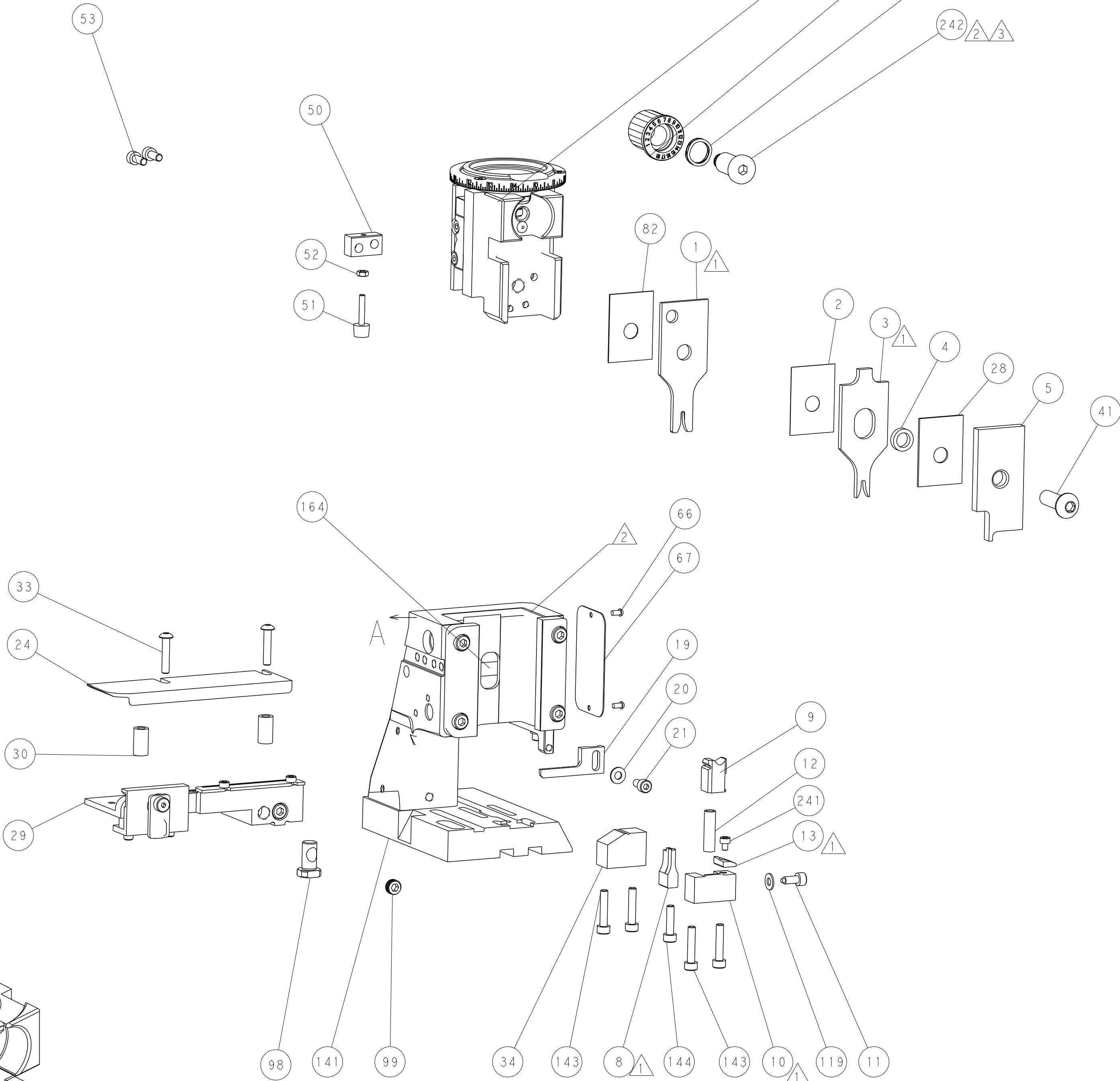
MECHANICAL
POST FEED



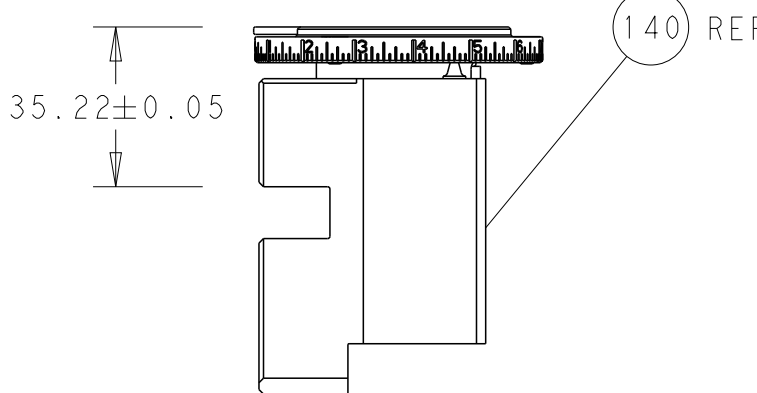
MECHANICAL
PRE FEED



AIR FEED

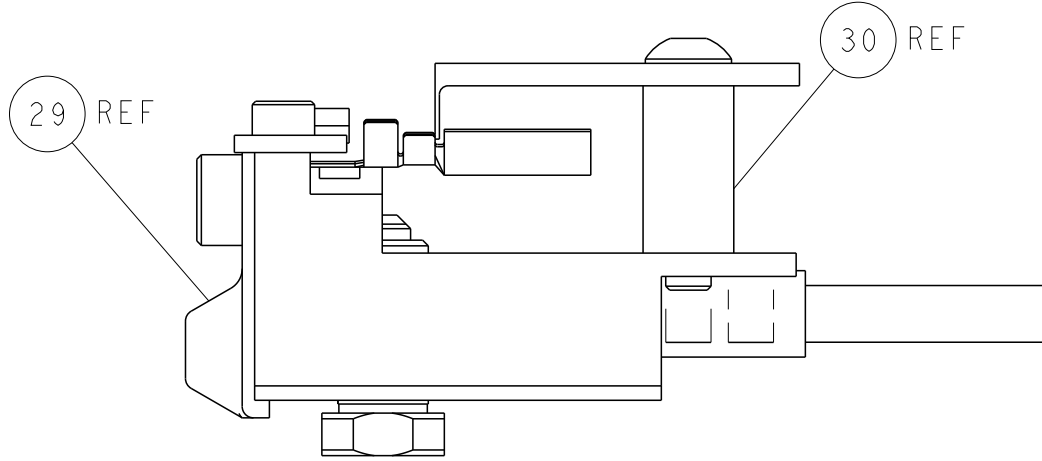


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY WIRE 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 SHALL BE RESPONSIBLE FOR THE LATEST VERSION.				DWN: K. HUANG 29OCT2013 CHK: L. ZHANG 29OCT2013 APVD: J. GUO 29OCT2013				STE 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 -				SIZE: A1			
MATERIAL: -				WEIGHT: -				CAGE CODE: 00779			
				Customer Accessible Production Drawing				SCALE: 1:2			
								SHEET: 4 OF 4			
								REV: B			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[7-2266090-7](#)