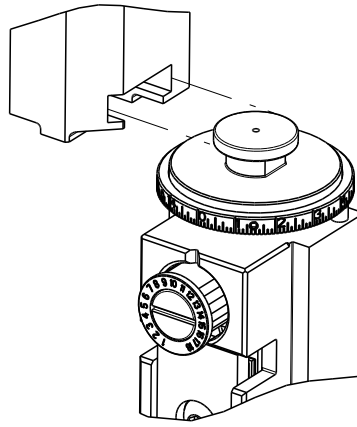
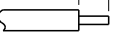


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266542-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266542-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266542-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266542-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266542-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.41 mm [.095]	F
INSUL	3.56 mm [.140]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: ITT TERMINAL		ITT CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 3.92-4.68 mm [.154-.184 IN]			INSULATION DIAMETER RANGE  
TERMINAL APPLICATION SPECIFICATION	 K121668-0222 Rev E	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	ITT TERMINAL	TE SEAL	ITT SEAL
2113606-1	121668-0222	2113388-1	121667-0023
2113606-2	121668-0202	2113388-2	121667-0022
2113606-3	121668-0272	2113388-3	121667-0024
2113606-4	121668-0121	963530-1	
2113606-5	121668-0268		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.30+/-0.03 [.051+/- .001]	6.8
1.00mm2	1.27+/-0.03 [.050+/- .001]	7.4
0.75mm2	1.25+/-0.03 [.049+/- .001]	7.5



- 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.
- 6 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 7 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.

*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	05NOV2014	YY	UG
		A		RELEASED	16DEC2014	JH	TE
		B		ECR-21-006336	17JUN2021	MEH	TE

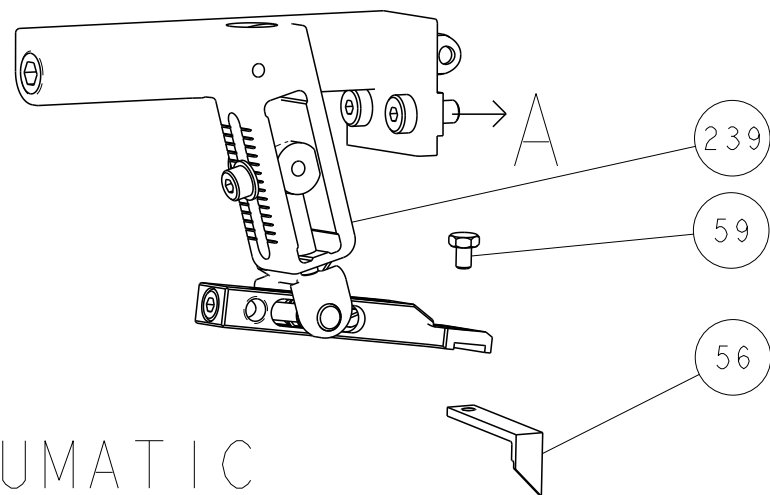
	-	1	-	1		2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-7	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
7	-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1	1	1338683-8	FEED PAWL	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	3-1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-3	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
	-	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	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	3-1803056-0	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1803018-8	CRIMPER, INSULATION O	3
	-	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	1	2	2	1	1	1803188-7	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 SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN Y. YIN	05NOV2014	TE Connectivity Harrisburg, PA 17105-3608			
CHK G. BAILEY				05NOV2014	NAME Ocean Side Feed Applicator				
APVD J. GUO				05NOV2014					
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
		0 PLC ±		APPLICATION SPEC					
		1 PLC ±							
		2 PLC ±							
3 PLC ±		4 PLC ±		3		C		2266542	
MATERIAL		FINISH		WEIGHT		A 00779		-	
Customer Accessible Production Drawing				SCALE		1:2		SHEET 1 OF 4	
								REV B	

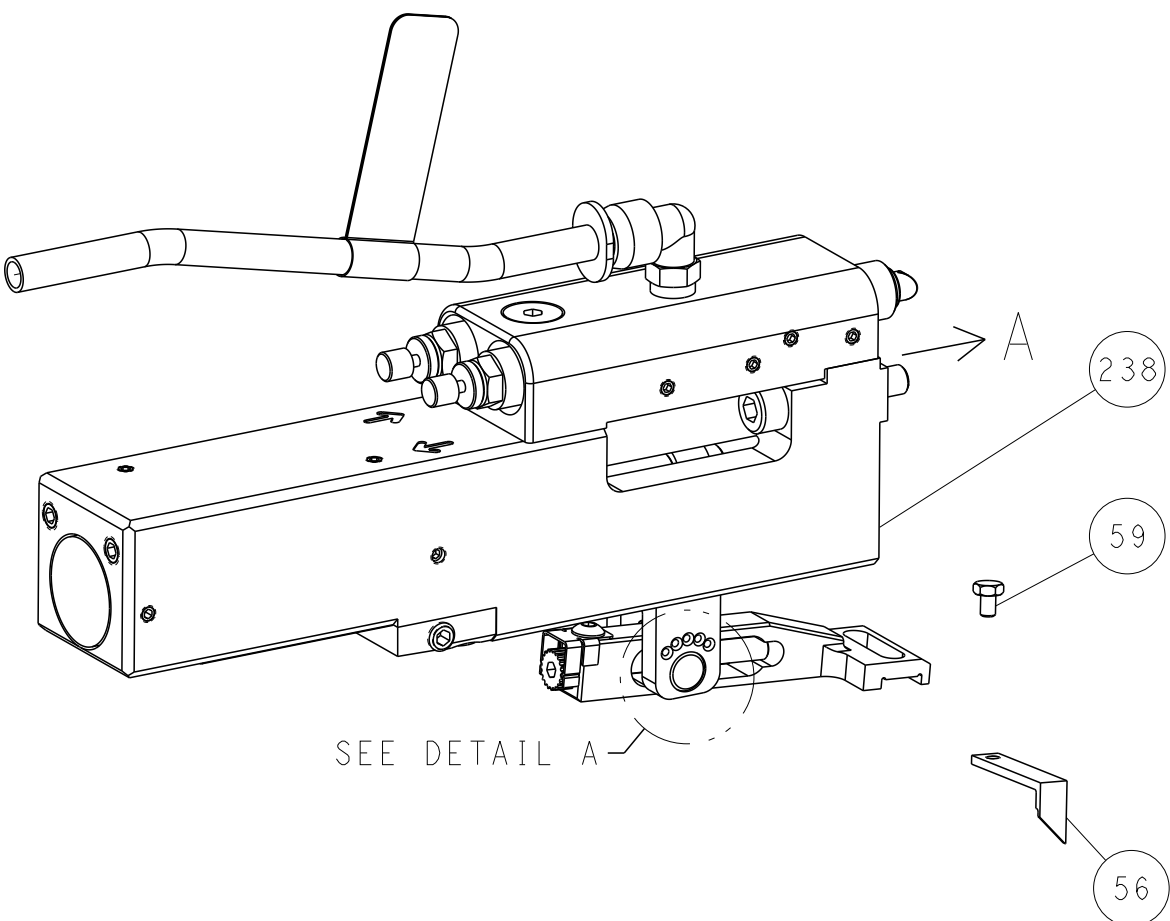
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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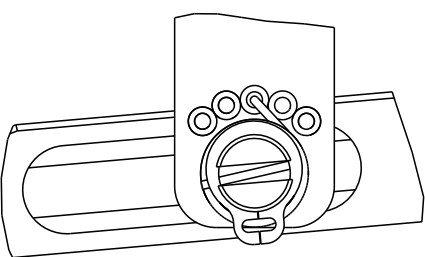
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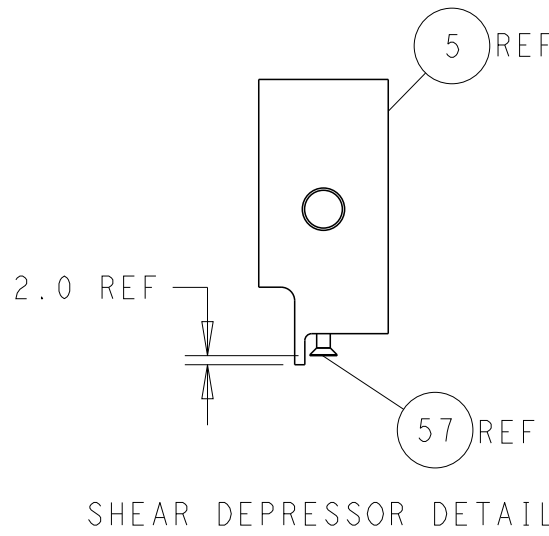
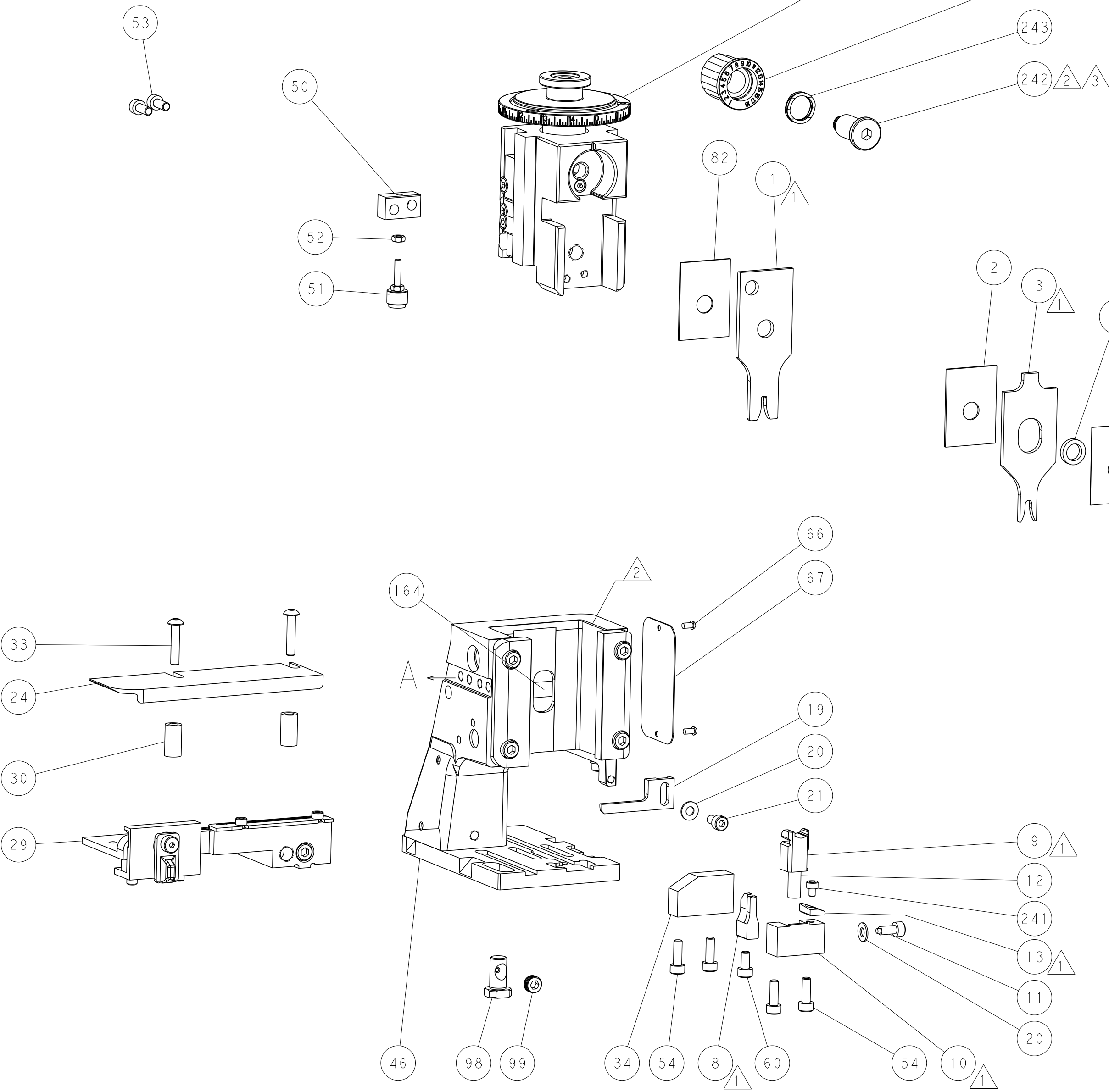
PNEUMATIC



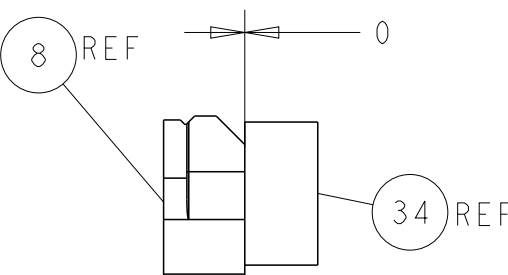
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



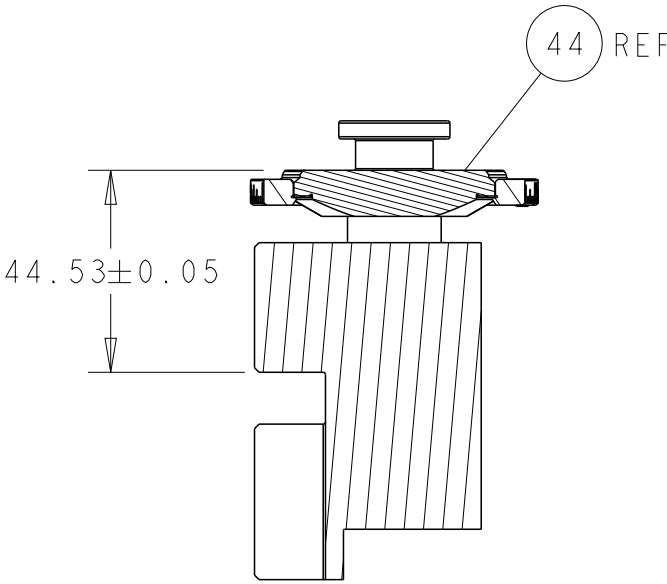
DETAIL A



SHEAR DEPRESSOR DETAIL

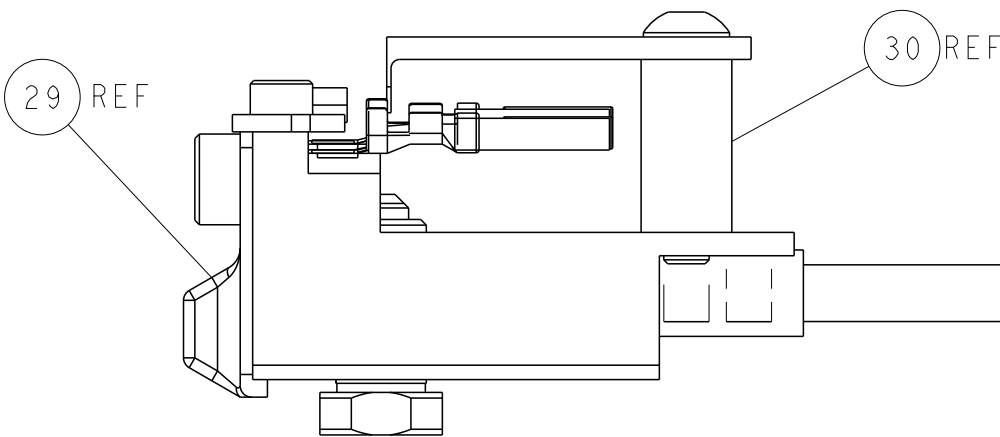


TERMINAL SUPPORT LOCATION



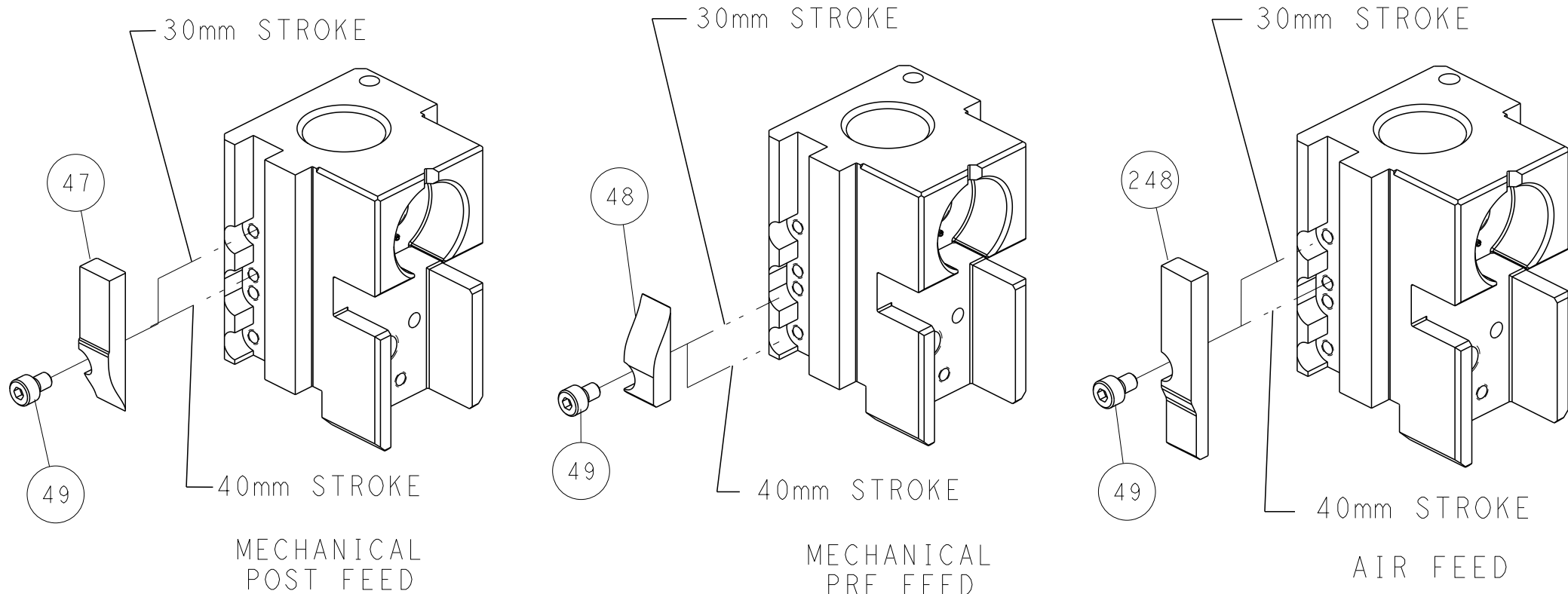
RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES

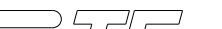


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS



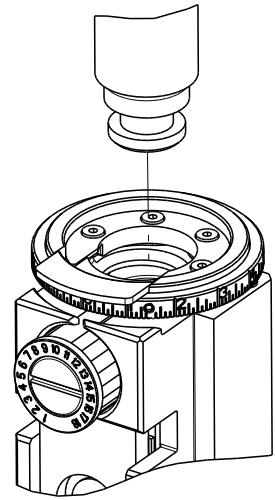
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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				CHK	G. BAILEY	05NOV2014										
				APVD	J. GUO	05NOV2014	NAME Ocean Side Feed Applicator -									
				PRODUCT SPEC												
				APPLICATION SPEC												
				WEIGHT												
				Customer Accessible Production Drawing												
DIMENSIONS:				TOLERANCES, UNLESS OTHERWISE SPECIFIED:				SIZE				CAGE CODE	DRAWING NO	RESTRICTED TO		
mm								A				00779	C	2266542		

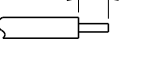
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266542-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266542-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266542-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.41 mm [.095]	F
INSUL	3.56 mm [.140]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: ITT TERMINAL		ITT CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 3.92-4.68 mm [.154-.184 IN]			INSULATION DIAMETER RANGE 
TERMINAL APPLICATION SPECIFICATION	 K121668-0222 Rev E	-	-
TERMINALS APPLIED			
TE TERMINAL	ITT TERMINAL	TE SEAL	ITT SEAL
2113606-1	121668-0222	2113388-1	121667-0023
2113606-2	121668-0202	2113388-2	121667-0022
2113606-3	121668-0272	2113388-3	121667-0024
2113606-4	121668-0121	963530-1	
2113606-5	121668-0268		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.30+/-0.03 [.051+/-0.001]	6.8
1.00mm2	1.27+/-0.03 [.050+/-0.001]	7.4
0.75mm2	1.25+/-0.03 [.049+/-0.001]	7.5



- 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.
- 6 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 7 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL NOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

*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	-	-	-

-	1	1	2119082-4	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-7	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	1338683-8	FEED PAWL	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	3-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	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	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	3-1803056-0	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1803018-8	CRIMPER, INSULATION O	3
-	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1803188-7	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION		ITEM NO
			DWN Y. YIN CHK G. BAILEY APVD J. GUO	05NOV2014 05NOV2014 05NOV2014		
			TE Connectivity Harrisburg, PA 17105-3608			
			NAME Ocean Side Feed Applicator			
			SIZE A	CAGE CODE 00779	DRAWING NO C=2266542	
			WEIGHT -	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					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

D

C

B

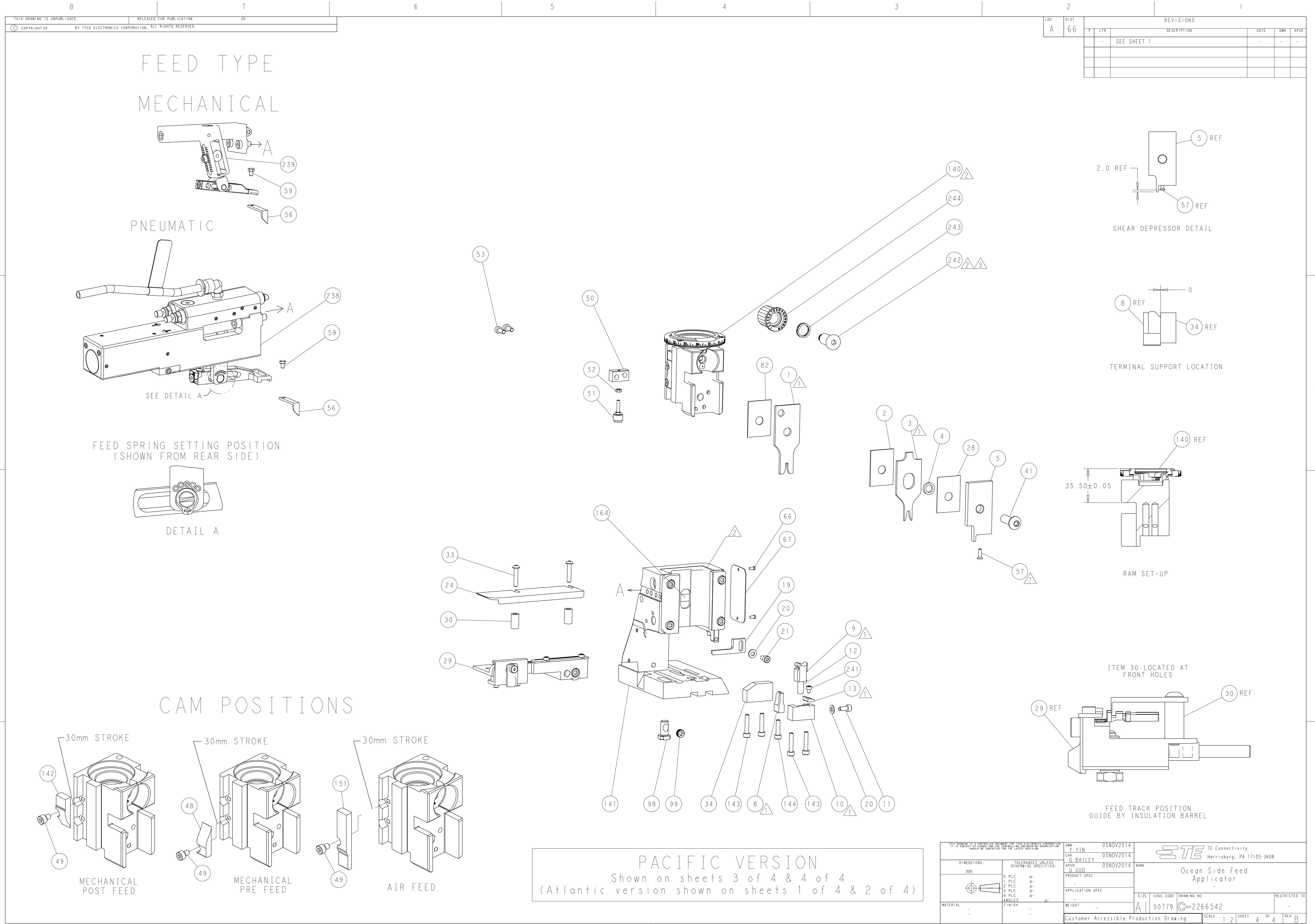
A

D

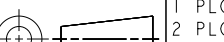
C

B

A



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	05NOV2014				
				APVD	J. GUO	05NOV2014	NAME Ocean Side Feed Applicator -			
				PRODUCT SPEC						
				APPLICATION SPEC						
				WEIGHT						
				SCALE						
				SHEET						
				REV						
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:						
mm										
				0 PLC	±					
				1 PLC	±					
				2 PLC	±					
				3 PLC	±					
				4 PLC	±					
				ANGLES	±	±				
FINISH										
MATERIAL										
-				-						
				WEIGHT						
				-						
				SCALE						
				A1 00779 C=2266542						
				Customer Accessible Production Drawing						
				SCALE						
				1:2						
				SHEET						
				4 of 4						
				REV						
				B						

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[TE Connectivity:](#)

[2266542-1](#)