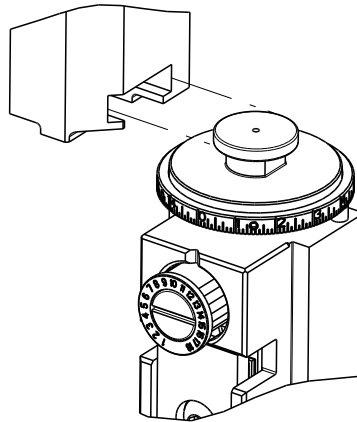


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266732-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266732-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266732-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266732-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266732-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.08 mm [.082]	F
INSUL	4.06 mm [1.60]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: ITT CANNON TERMINAL ITT CANNON CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, SOCKET			
WIRE STRIP LENGTH 4.89-5.65 mm [.193-.223 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION	K031-8500-169 Rev G	-	-
TERMINALS APPLIED			
TE TERMINAL	ITT CANNON TERMINAL	TE SEAL	ITT CANNON SEAL
1949474-1	121668-0125	1572322-1	121668-0032
1949474-2	121668-0022		
1949474-3	121668-0024		

SEAL INSULATION DIAMETER RANGE
Ø 1.4-2.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.45+/-0.03 [.057+/- .001]	7.1
18 AWG OR 0.75mm2	1.35+/-0.03 [.053+/- .001]	8.2
0.50mm2	1.26+/-0.03 [.050+/- .001]	9.1



- 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 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.
- 7 18 AWG WIRE IS NOT LISTED ON TERMINAL MANUFACTURER SPECIFICATION.

*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
		B		ECR-16-002887	25FEB2016	MR	GB
		C		ECR-21-004067	06APR2021	LG	TE

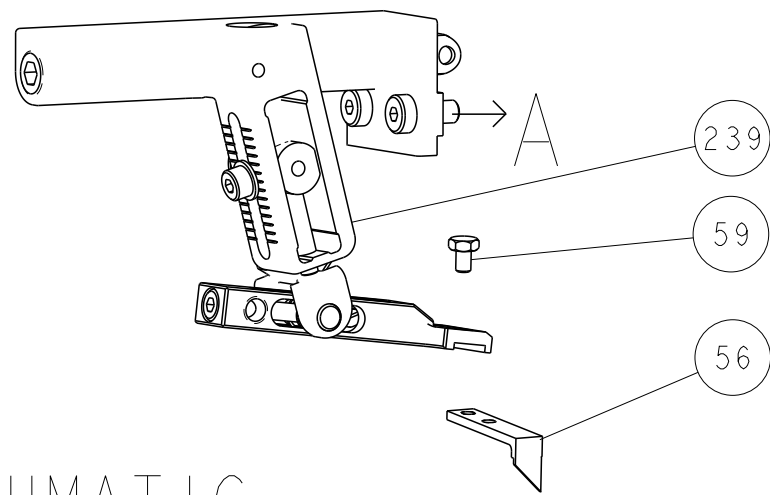
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	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	455888-6	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	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	2-2844962-8	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	1320928-6	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	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	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	3-1803171-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	3-2119784-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	2	2	1	1	3-1490019-5	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 23MAR2015	STE TE Connectivity Harrisburg, PA 17105-3608					
CHK L. ZHANG 23MAR2015				APVD J. GUO 23MAR2015	NAME Ocean Side Feed Applicator					
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±						
MATERIAL -				WEIGHT -						
Customer Accessible Production Drawing				SCALE 1:2	SHEET 1	OF 4	REV C			

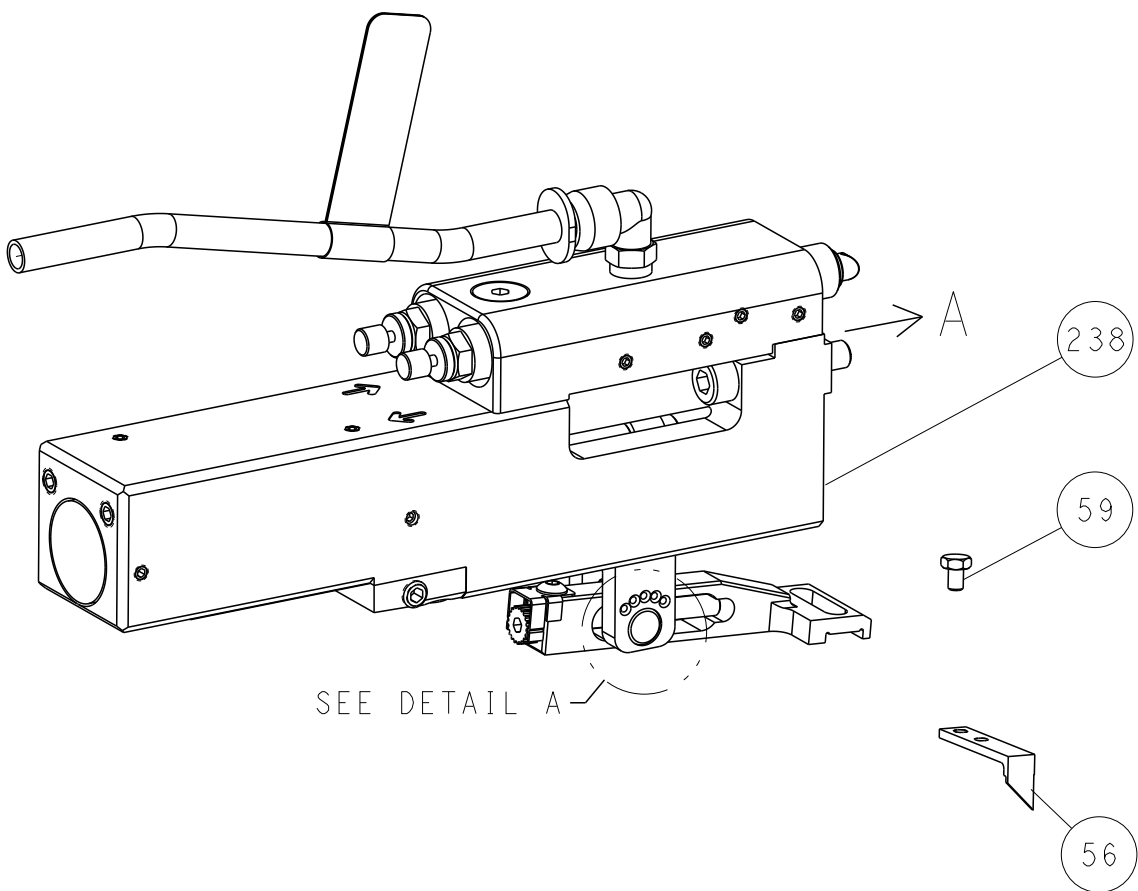
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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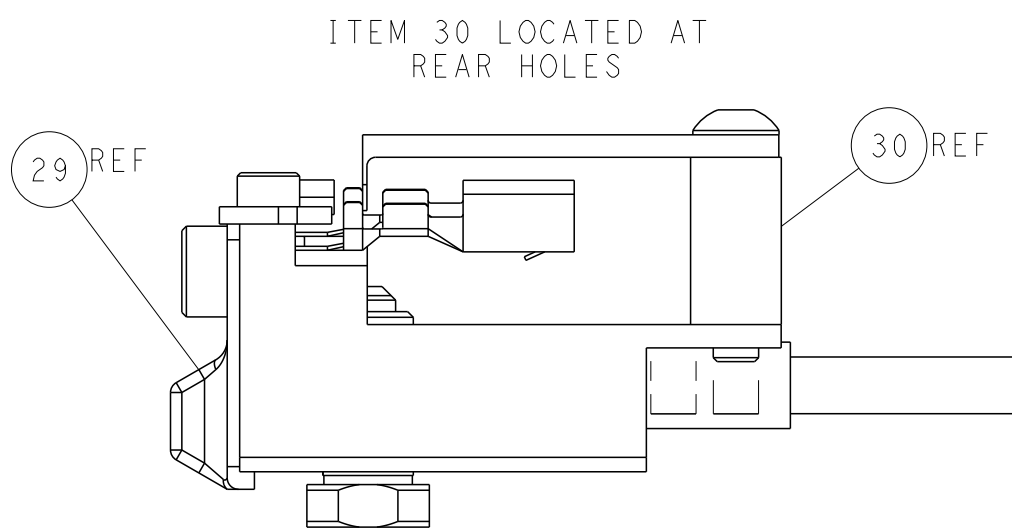
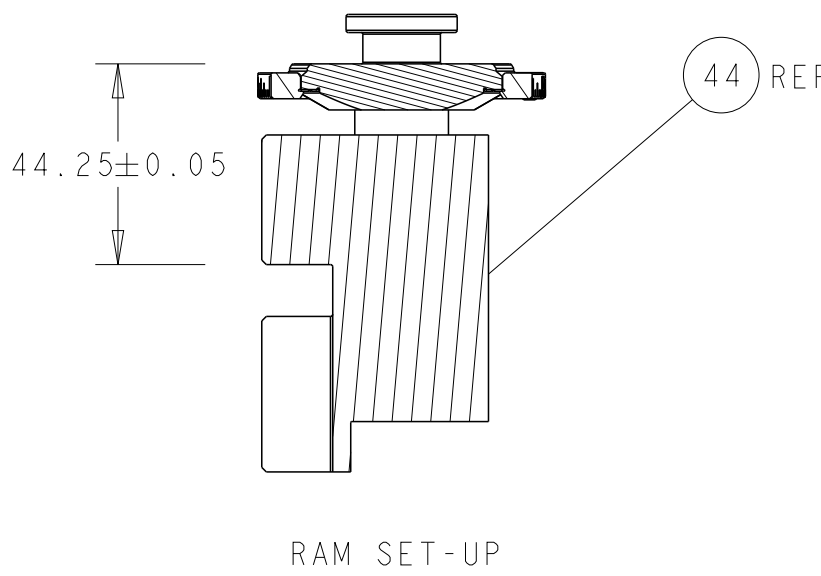
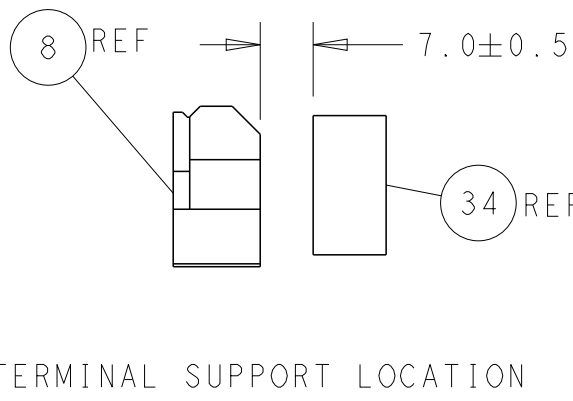
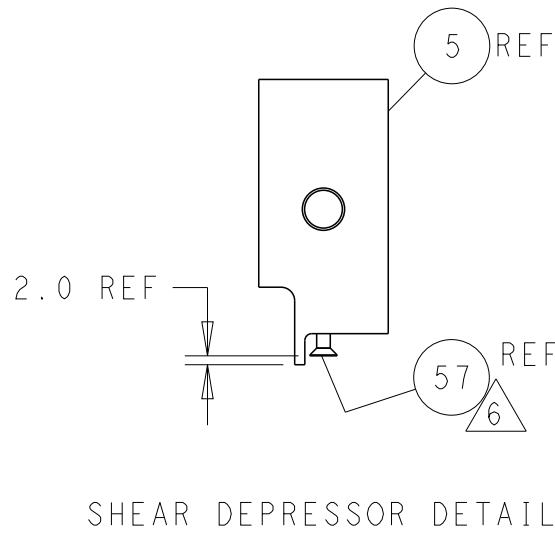
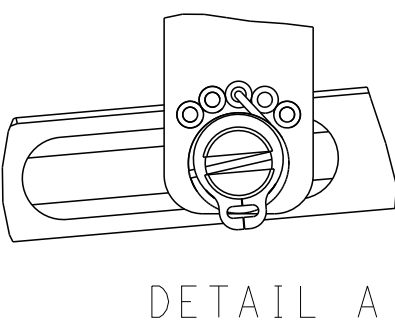
FEED TYPE MECHANICAL



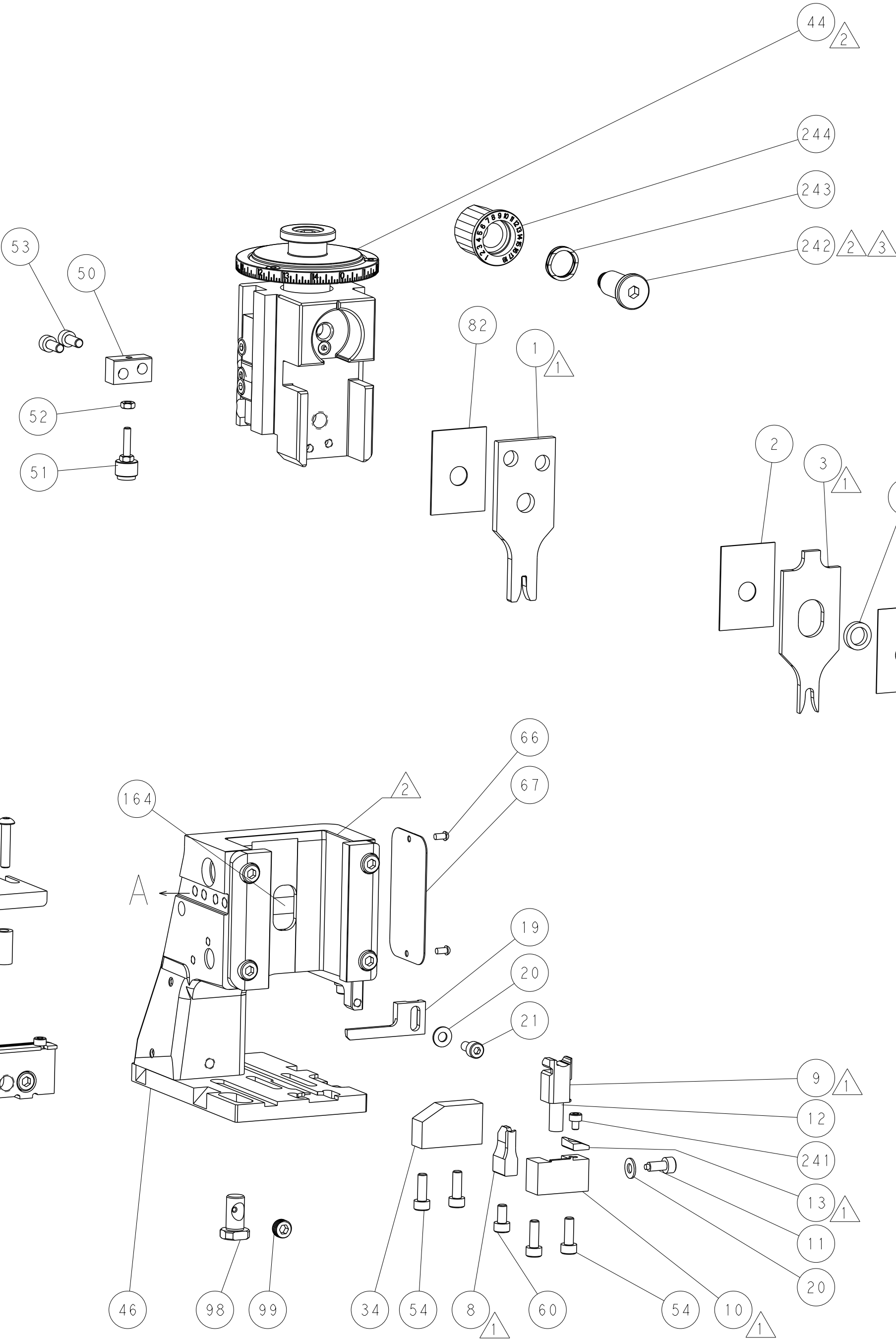
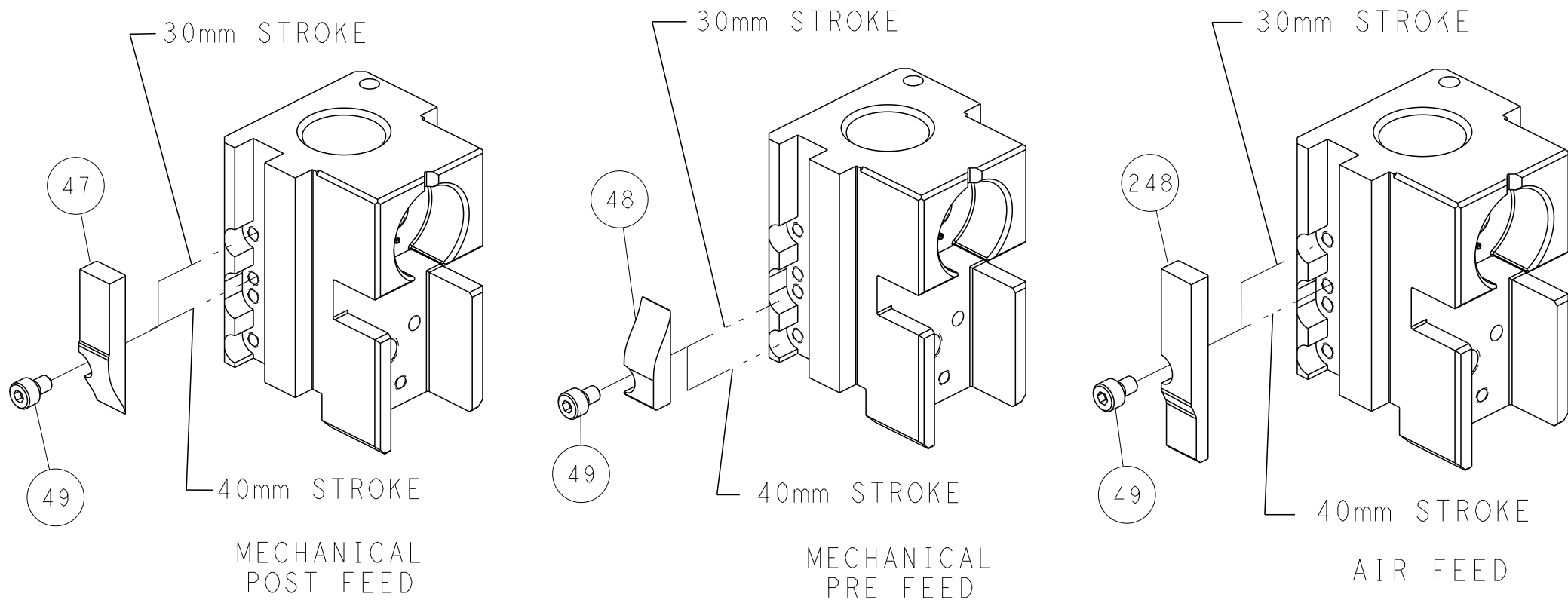
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

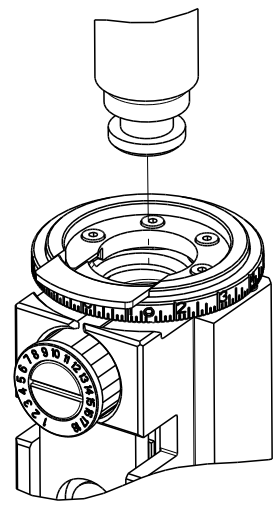


CAM POSITIONS



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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN K. HUANG 23MAR2015	TE Connectivity Harrisburg, PA 17105-3608			
CHK L. ZHANG 23MAR2015				APVD J. GUO 23MAR2015	NAME Ocean Side Feed Applicator			
DIMENSIONS: mm				PRODUCT SPEC				RESTRICTED TO
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				APPLICATION SPEC				
MATERIAL				WEIGHT	SIZE A1	CASE CODE 00779	DRAWING NO C=2266732	REV C
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2 of 4		REV C	



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.08 mm [.082]	F
INSUL	4.06 mm [.160]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: ITT CANNON TERMINAL ITT CANNON CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, SOCKET			
WIRE STRIP LENGTH 4.89-5.65 mm [.193-.223 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION  K031-8500-169 Rev G		-	-
-		-	-
TERMINALS APPLIED			
TE TERMINAL	ITT CANNON TERMINAL	TE SEAL	ITT CANNON SEAL
1949474-1	121668-0125	1572322-1	121668-0032
1949474-2	121668-0022		
1949474-3	121668-0024		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.45+/-0.03 [0.057+/-0.001]		7.1
18 AWG OR 0.75mm2		1.35+/-0.03 [0.053+/-0.001]		8.2
0.50mm2		1.26+/-0.03 [0.050+/-0.001]		9.1



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. 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.
7. 18 AWG WIRE IS NOT LISTED ON TERMINAL MANUFACTURER SPECIFICATION.

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

[illegible]

	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	1-1803563-0	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	455888-6	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
6	-	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	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	1320928-6	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	3-1803171-8	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
	-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	3-2119784-1	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	3-1490019-5	CRIMPER, WIRE PREMIUM	1

THIS DRAWING IS A CONTROLLED DOCUMENT AND ANY ELECTRICAL INFORMATION SHOULD BE CONFIRMED FOR THE LATEST VERSION.										OWN J. HUANG 23MAR2015		 TE Connectivity Harrisburg PA 17105-3608			
DIMENSIONS: mm										CHK J. ZHANG 23MAR2015					
										TOLERANCES UNLESS OTHERWISE SPECIFIED:  0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. ANGLES ±. FINISH					
MATERIAL -															
										WEIGHT -					
Customer Accessible Production Drawing															

DETAIL A

30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

MECHANICAL PRE FEED

30mm STROKE

151

49

AIR FEED

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

(THIS DRAWING IS A COMPUTER GENERATED FILE FOR ELECTRONIC PRODUCTION) IT MAY BE DIFFERENT FROM THE ORIGINAL DRAWING AND SHOULD NOT BE USED FOR FABRICATION UNLESS CONTACTED FOR THE LATEST VERSION						DWN : 23MAR2015 CHN : L HUANG 23MAR2015 L ZHANG 23MAR2015		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME					
mm				APVD		Ocean Side Feed Applicator			
		9 PLC ±		PRODUCT SPEC		SIZE CASE CODE DRAWING NO RESTRICTED TO A 00779 C=2266732			
		9 PLC ±		APPLICATION SPEC					
		9 PLC ±							
ANGLES ±		±		WEIGHT		Customer Accessible Product Drawing SCALE 1:2 SHEET 4 OF 4 REV C			
MATERIAL		FINISH							

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[2266732-2](#)