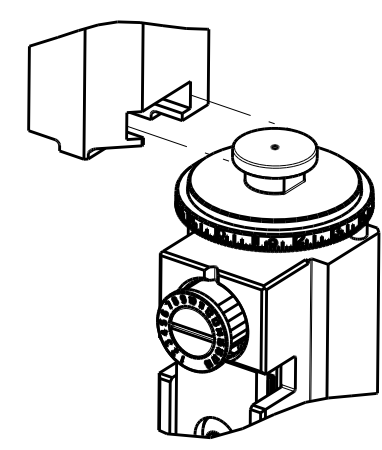


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266541-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266541-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266541-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266541-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266541-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



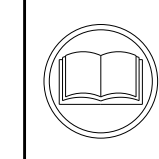
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.08 mm [.082]	F
INSUL	4.32 mm [.170]	O

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	

TERMINALS APPLIED				
TE TERMINAL	ITT CANNON TERMINAL	TE SEAL	ITT CANNON SEAL	SEAL INSULATION DIAMETER RANGE
1949474-1	121668-0125	2113613-1	121668-0033	Ø 2.1-2.9
1949474-2	121668-0022	828905-1		Ø 2.2-3.0
1949474-3	121668-0024	281934-2		Ø 2.5-3.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.45 +/- 0.03 [.057 +/- .001]	6.7
0.75mm2	1.35 +/- 0.03 [.053 +/- .001]	8.0
0.50mm2	1.26 +/- 0.03 [.050 +/- .001]	8.9



- 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.

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

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		A	RELEASED	10DEC2014	KH TE
		B	ECR-19-006777	28APR2019	FJ TE

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-2	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	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	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	1803607-1	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	1320928-2	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	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	2-1803056-9	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	2-1633965-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-6	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

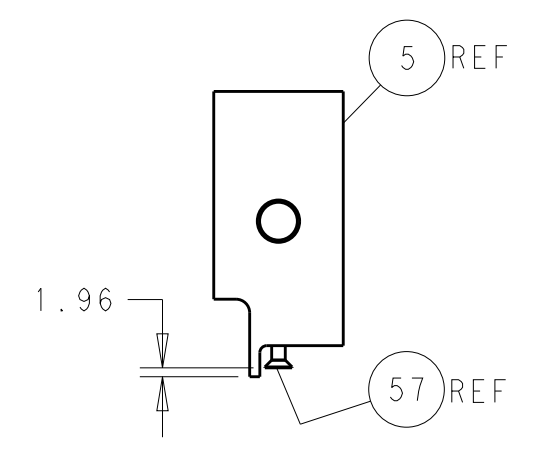
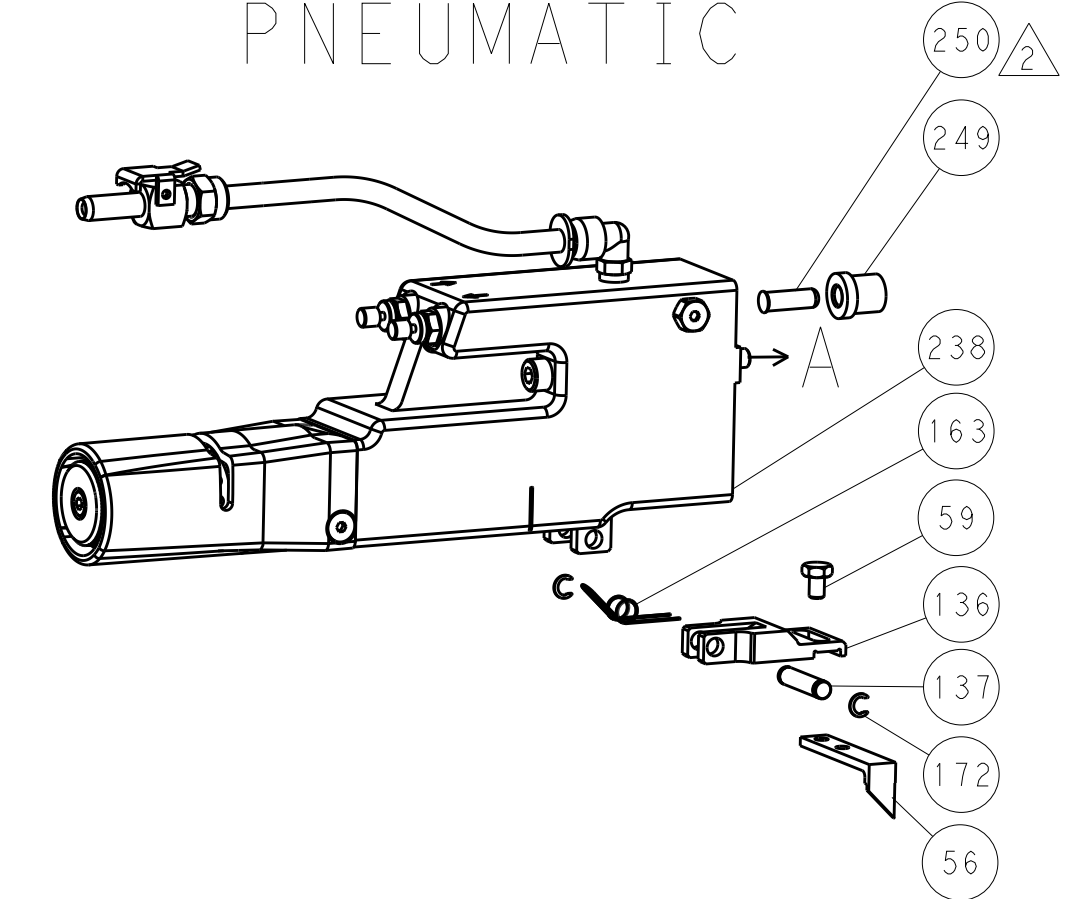
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: H. HUANG 03NOV2014	TE Connectivity Harrisburg, PA 17105-3608
		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.01		CHK: L. ZHANG 03NOV2014	
MATERIAL:		FINISH:		APVD: H. GUO 03NOV2014	NAME: Ocean Side Feed Applicator
				PRODUCT SPEC:	SIZE: A1
				APPLICATION SPEC:	CAGE CODE: 00779
				WEIGHT:	DRAWING NO: 2266541
				Customer Accessible Production Drawing	RESTRICTED TO: B
				SCALE: 1:2	SHEET 1 OF 4

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1	-	-	-

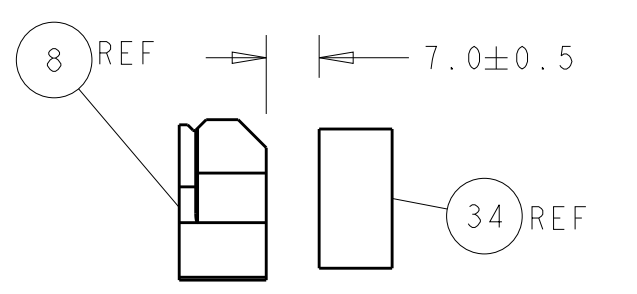
# FEED TYPE MECHANICAL



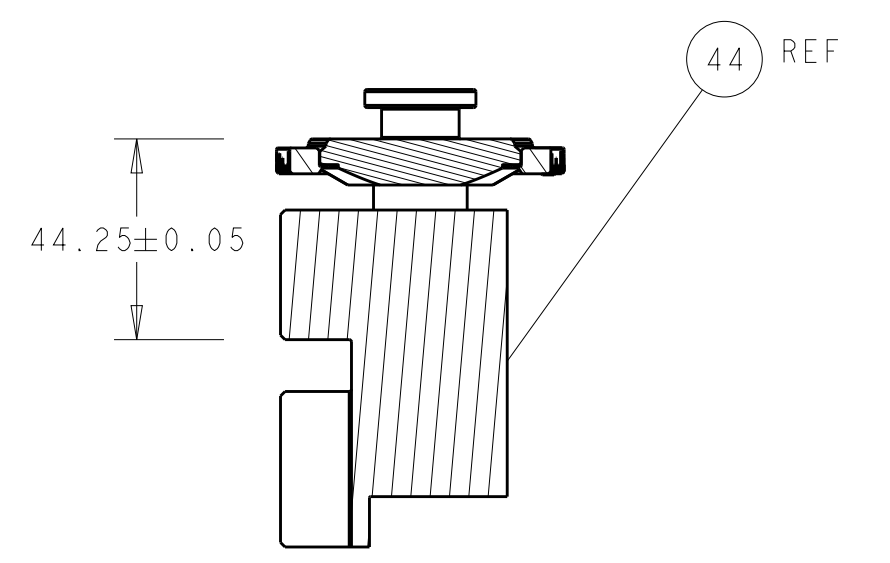
# PNEUMATIC



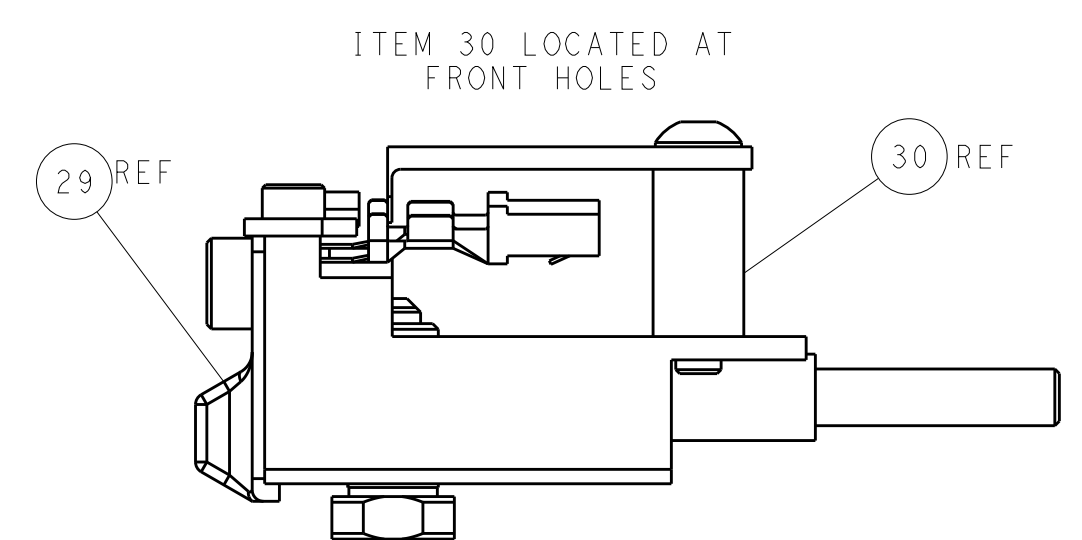
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

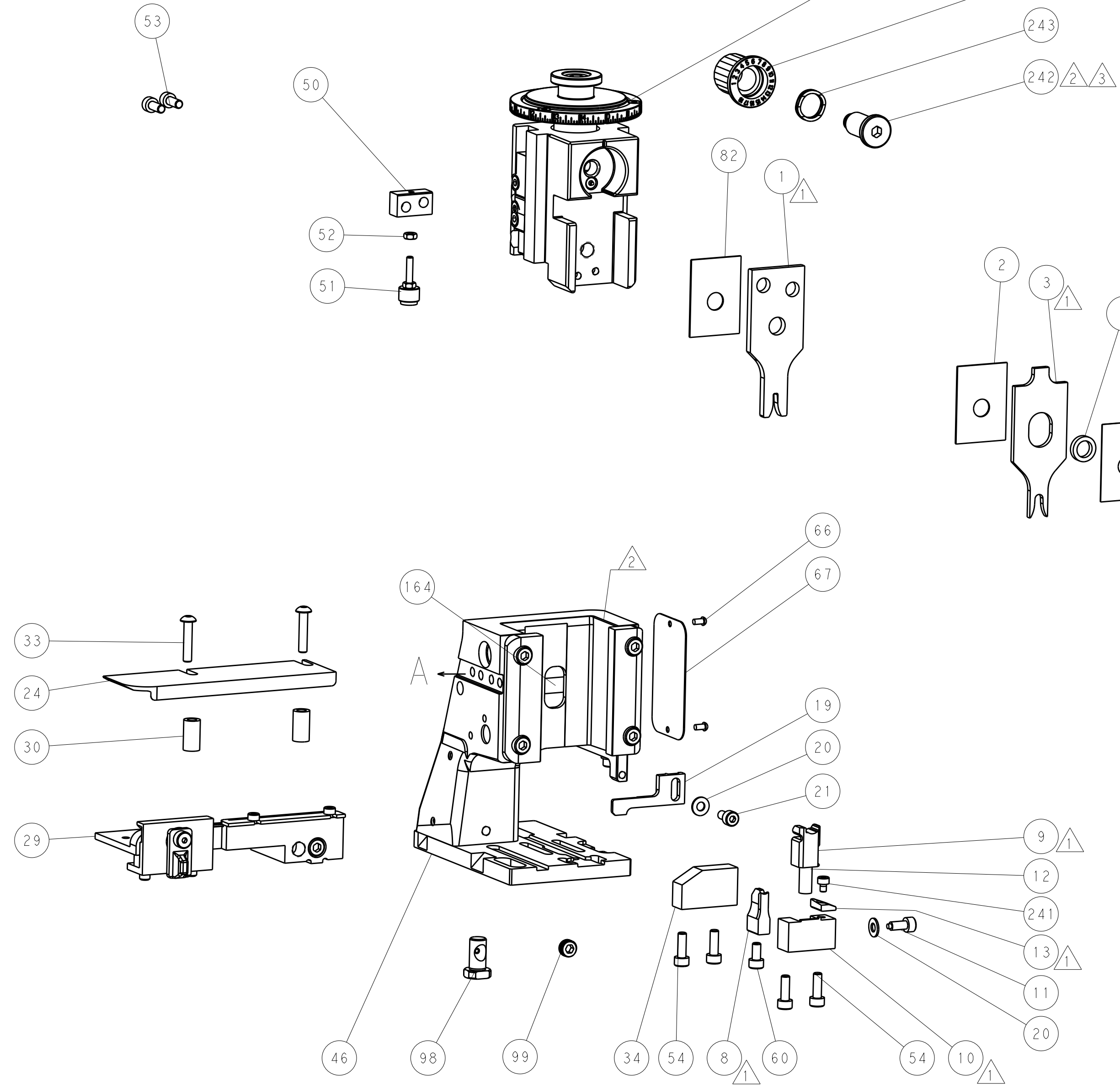
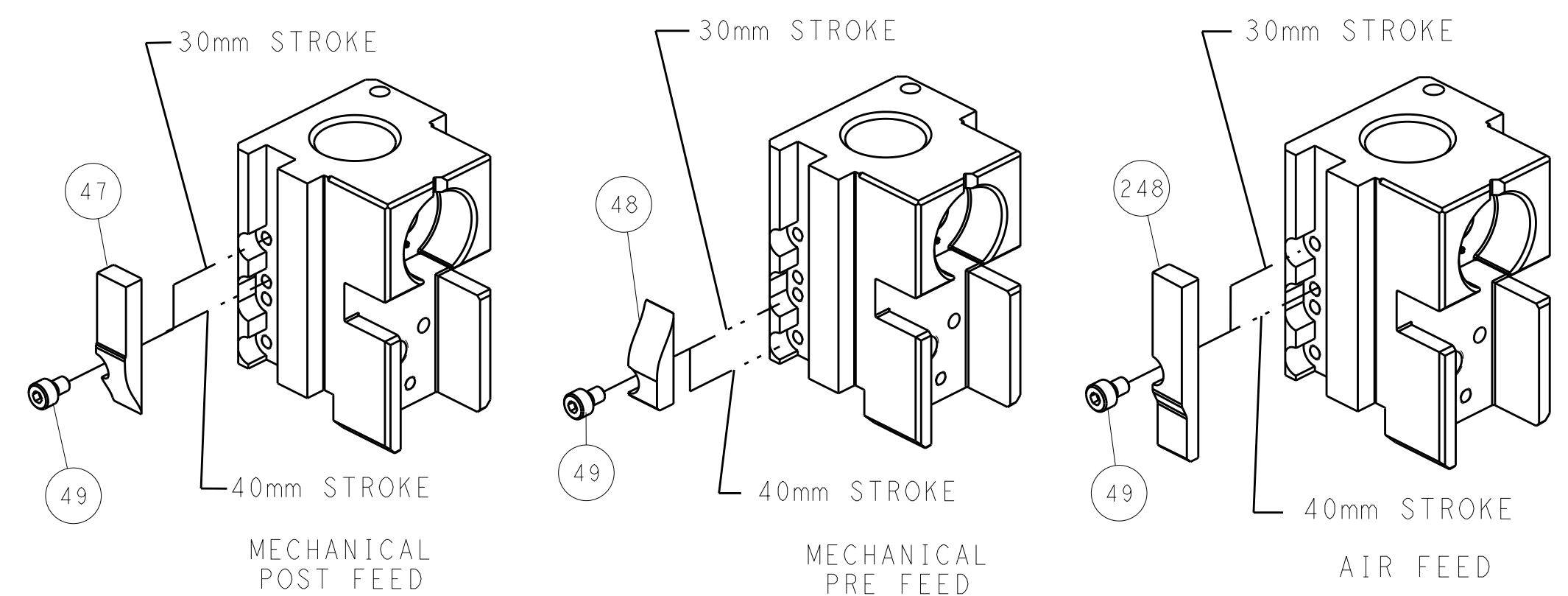


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

# CAM POSITIONS

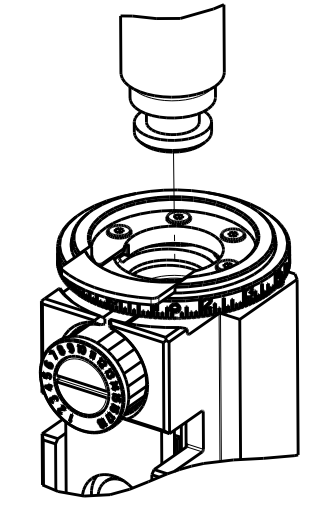


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 03NOV2014		TE Connectivity	
mm		0 PLC ±0.5		CHK: L. ZHANG 03NOV2014		Harrisburg, PA 17105-3608	
Ø		2 PLC ±0.13		APPV: H. GUO 03NOV2014		NAME: Ocean Side Feed Applicator	
H		3 PLC ±0.013		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
D		4 PLC ±0.001		APPLICATION SPEC		A1 00779 ©=2266541	
R		FINISH		WEIGHT		SCALE: 1:2 SHEET 2 OF 4 REV B	
MATERIAL		FINISH		Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266541-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266541-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266541-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.08 mm [.082]	F
INSUL	4.32 mm [.170]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: ITT CANNON TERMINAL ITT CANNON CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, SOCKET	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.89-5.65 mm [1.93-.223 IN]	Ø
TERMINAL APPLICATION SPECIFICATION	K031-8500-169

TERMINALS APPLIED				
TE TERMINAL	ITT CANNON TERMINAL	TE SEAL	ITT CANNON SEAL	SEAL INSULATION DIAMETER RANGE
1949474-1	121668-0125	2113613-1	121668-0033	Ø 2.1-2.9
1949474-2	121668-0022	828905-1		Ø 2.2-3.0
1949474-3	121668-0024	281934-2		Ø 2.5-3.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm <sup>2</sup>	1.45 +/- 0.03 [0.057 +/- .001]	6.7
0.75mm <sup>2</sup>	1.35 +/- 0.03 [0.053 +/- .001]	8.0
0.50mm <sup>2</sup>	1.26 +/- 0.03 [0.050 +/- .001]	8.9



- 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	REV	DATE	BY	APPV
A	66				

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	2119640-1			250
-	1	1803259-1			249
-	1	2119082-2			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	7-18023-7			241
-	-	2119580-1			239
-	1	2063440-1			238
-	2	21045-3			172
-	REF	994970-2			164
-	1	240638-1			163
-	1	2119641-2			151
-	1	2168083-8			144
-	4	2168083-9			143
-	-	2119653-2			142
-	1	1-1803583-0			141
-	1	1803516-1			140
-	1	3-23627-7			137
-	1	2119799-1			136
-	1	2844908-1			99
-	1	2844907-1			98
-	1	455888-6			82
-	1	1803607-1			71
-	1	2119740-1			67
-	2	2168078-1			66
-	1	5-18022-5			59
-	1	985575-3			57
-	1	1338685-1			56
-	2	1-2168083-0			53
-	1	5018030-1			52
-	1	811242-5			51
-	1	690753-2			50
-	1	18023-9			49
-	-	2119652-1			48
-	1	1803602-1			41
-	1	1-1752356-7			34
-	2	2079383-5			33
-	2	2-2844962-8			30
-	1	2844992-1			29
-	1	455888-3			28
-	1	1320928-2			24
-	1	2168083-2			21
-	2	1-18028-2			20
-	1	2119533-1			19
-	1	2119806-1			13
-	1	3-22280-3			12
-	1	1-356885-4			11
-	1	2119805-1			10
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-	1	2-1633965-0			3
-	1	455888-6			2
-	1	3-1490019-5			1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0001	ANGLES ±0.0001	

ITEM NO	PART NO	DESCRIPTION
-77	-22	-21

CHK	H. HUANG	03NOV2014
CHK	L. ZHANG	03NOV2014
APVD	J. GUO	03NOV2014

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266541	

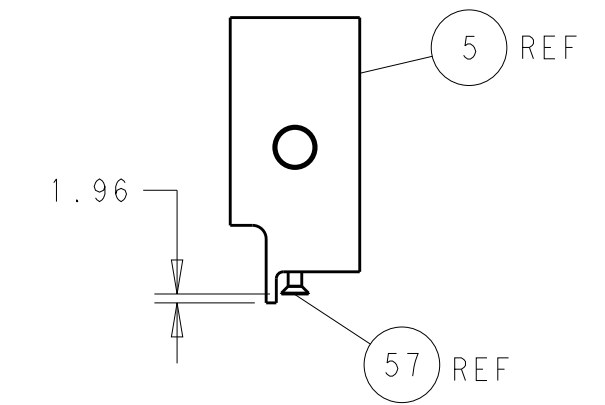
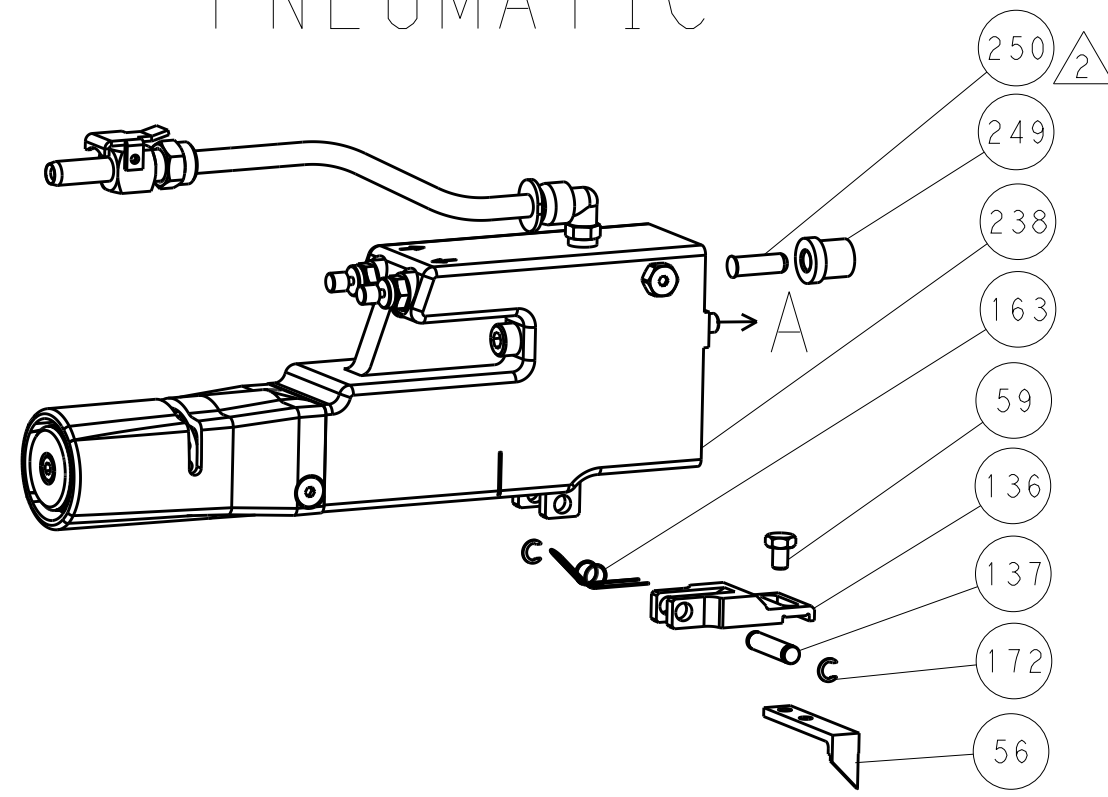
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B

LOC	DIST	REV	DATE	BY	APPV
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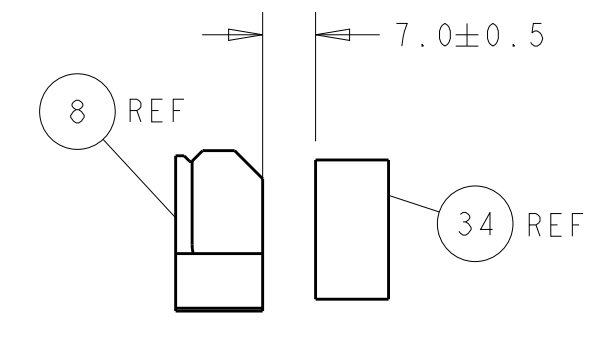
# FEED TYPE MECHANICAL



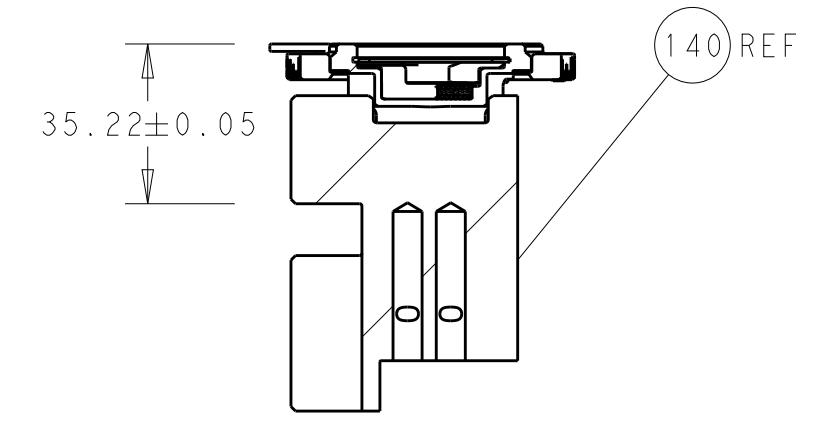
# PNEUMATIC



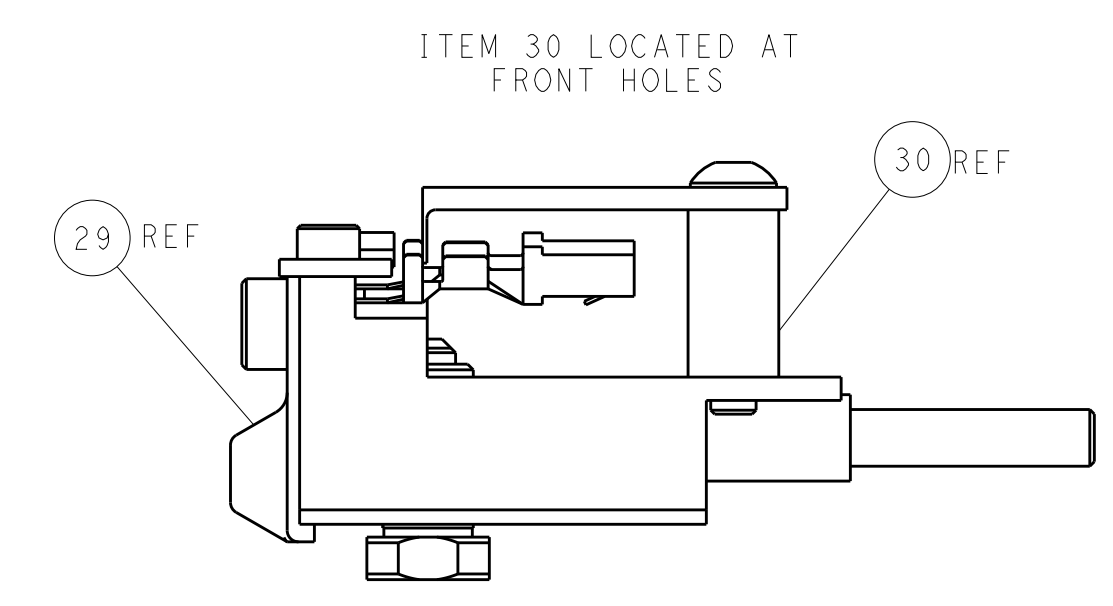
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

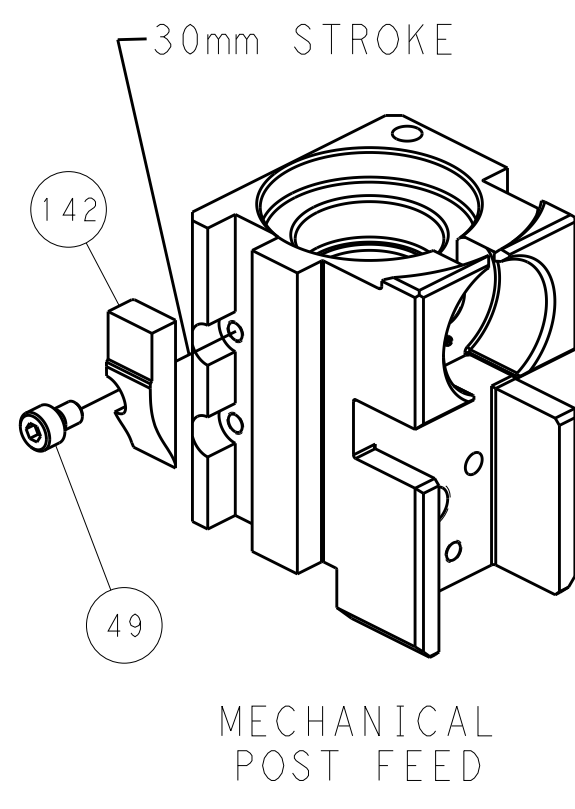


RAM SET-UP

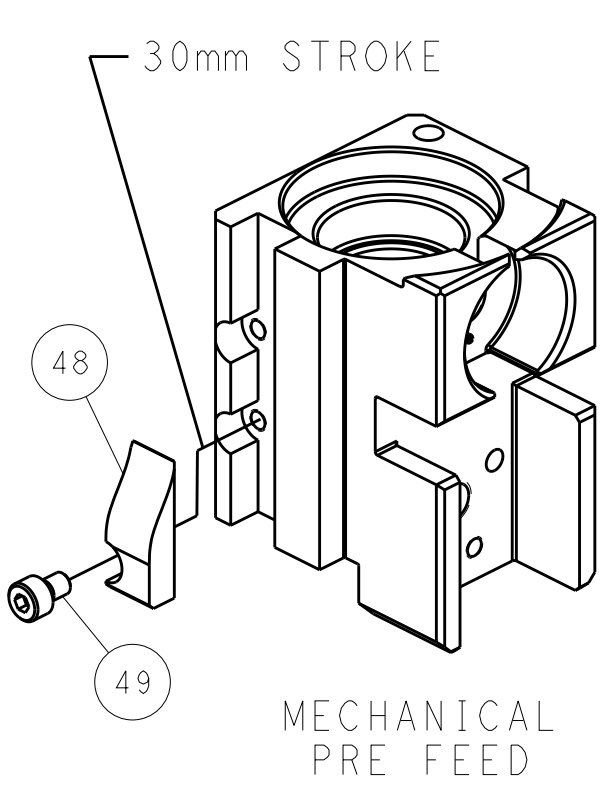


FEED TRACK POSITION GUIDE BY INSULATION BARREL

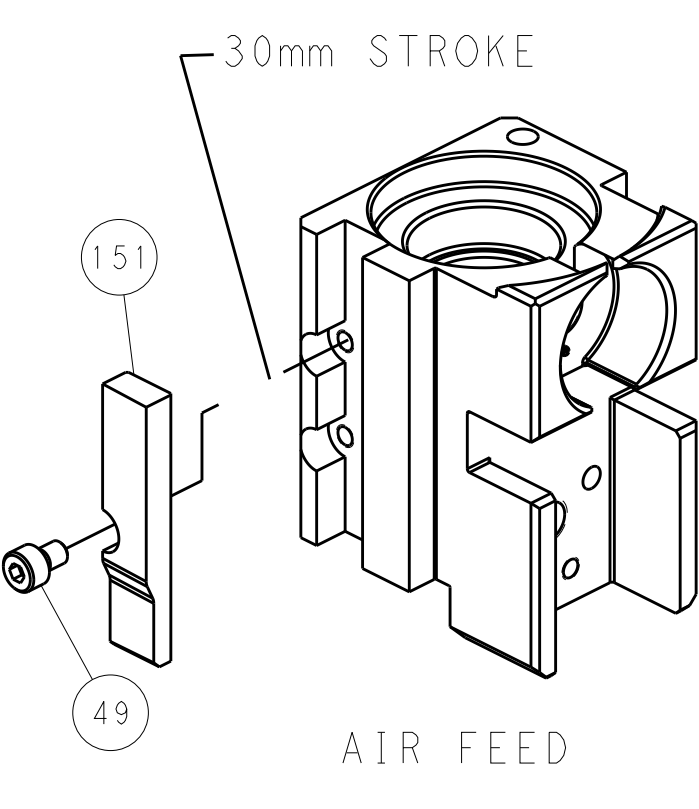
# CAM POSITIONS



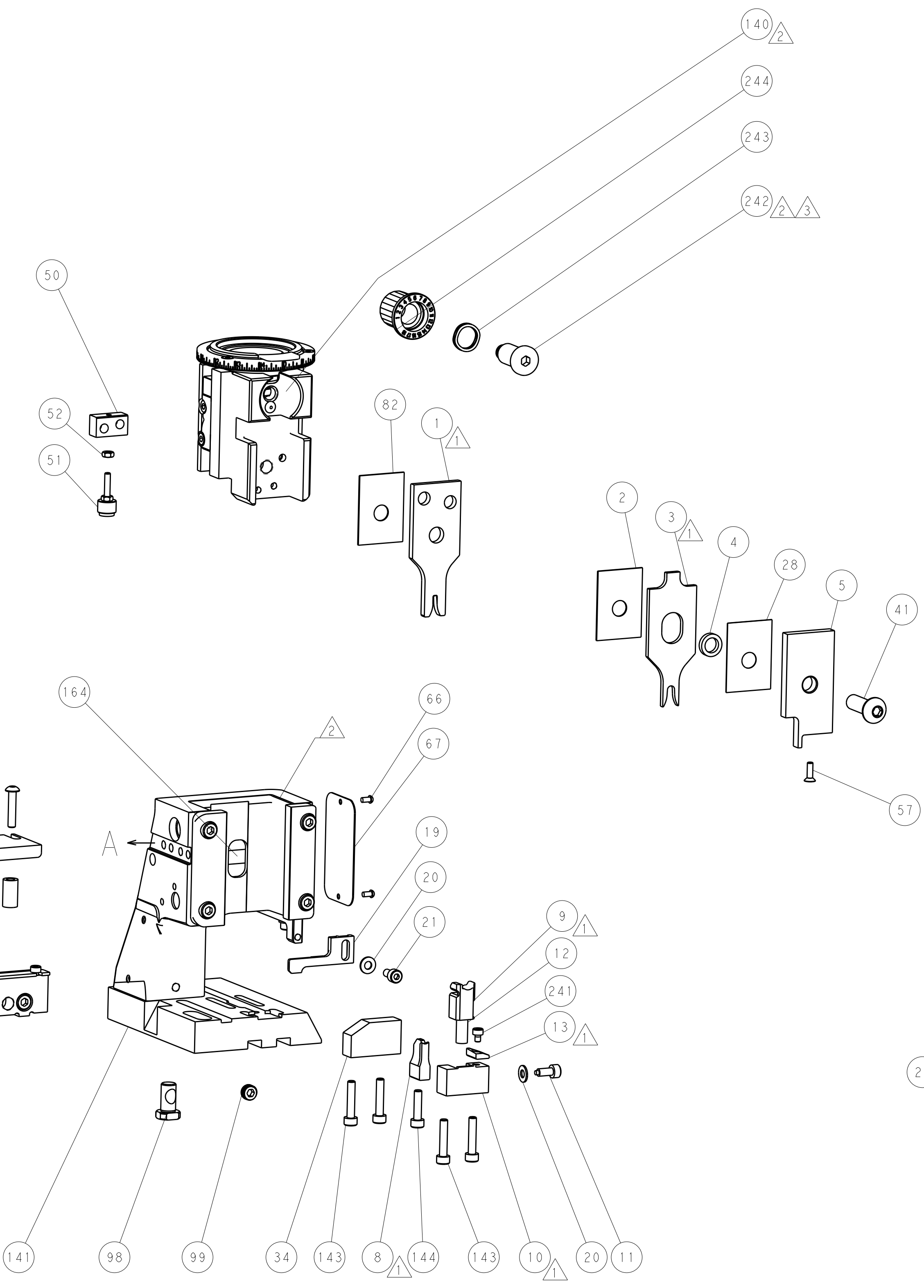
MECHANICAL POST FEED



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.		DWN H. HUANG 03NOV2014 CHK L. ZHANG 03NOV2014 APVD H. GUO 03NOV2014 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 4 OF 4 REV B		STE TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2266541 Customer Accessible Production Drawing	
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