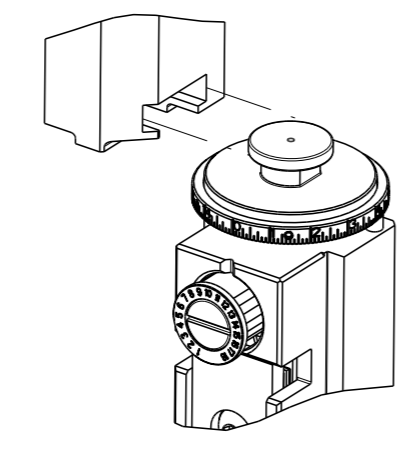


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266765-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266765-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266765-1	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266765-2	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266765-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266765-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266765-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.34 mm [.092]	F
INSUL	3.81 mm [.150]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION

TERMINAL NAME: 090 SEALED MALE TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.00-5.00 mm [.157-.197 IN]	∅

TERMINAL APPLICATION SPECIFICATION T-023 Rev 07.08.11

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION

TERMINAL NAME: 090 SEALED FEMALE TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.00-5.00 mm [.157-.197 IN]	∅

TERMINAL APPLICATION SPECIFICATION T-023 Rev 07.08.11

TERMINALS APPLIED

TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
2113698-1	8100-0459	1642378-1	7165-0349	1.4-2.0
		3311514-1	7165-0344	2.5-2.9
		963293-1		2.0-2.7

TERMINALS APPLIED

TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
2113699-1	8100-0462	1642378-1	7165-0349	1.4-2.0
		3311514-1	7165-0344	2.5-2.9
		963293-1		2.0-2.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.90+/-0.05 [.075+/- .002]	3.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.70+/-0.05 [.067+/- .002]	5.5

- 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. 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 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.

LOC	DIST	REV	DATE	OWN	APVD
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		B	06FEB2018	TB	TE
		C	20SEP2018	MS	CT
		D	19JUL2019	TB	TE

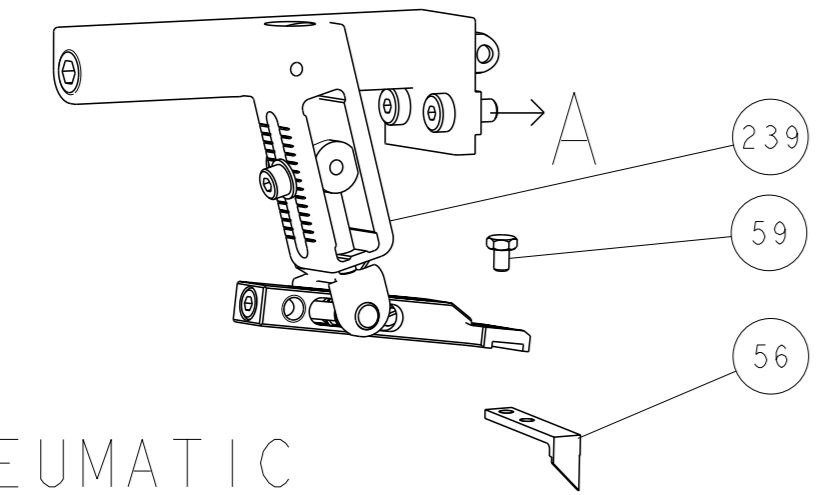
REV	DATE	DESCRIPTION	ITEM NO	
-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	2844940-1	AIR FEED MODULE	238
-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
3	-	2-1752354-2	STANDOFF, HOLD-DOWN	180
-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119791-5	DEPRESSOR, WIRE	70
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
5	-	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1338685-1	PAWL, FEED	56
-	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	811242-5	BUMPER, HOLD DOWN	51
-	1	690753-2	SPACER, TONKER	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	1	1320928-6	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
1	-	2119805-1	SHEAR HOLDER, FRONT	10
1	-	318707-1	FLOATING SHEAR, FRONT	9
1	2	4-1803171-1	ANVIL, COMBINATION	8
-	1	2-240641-0	SPACER	7
-	-	-	-	6
-	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	4-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	455888-8	SPACER, CRIMPER	2
1	2	9-1633664-1	CRIMPER, WIRE	1

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

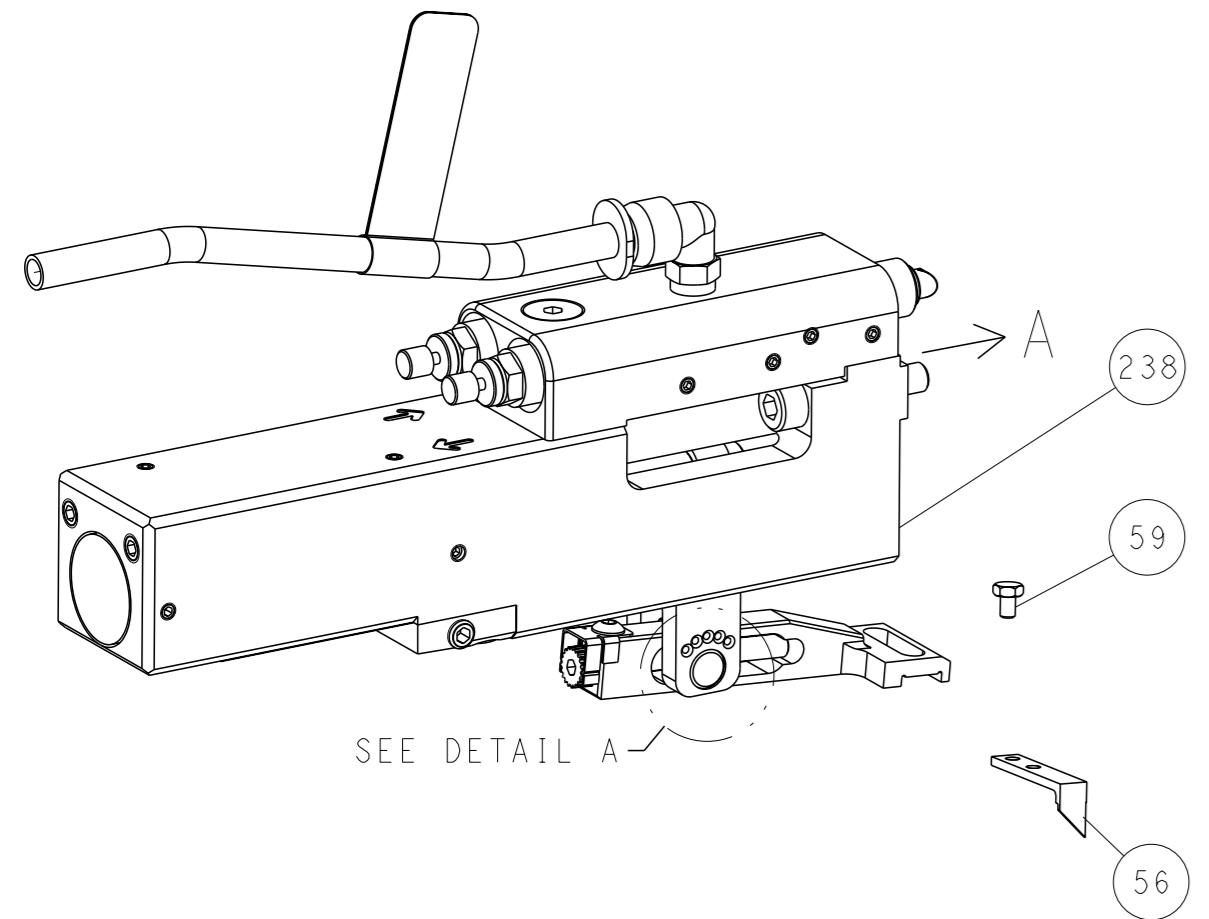
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	CHK	APVD	DATE	NAME	SCALE	SHEET	REV
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	H. HUANG	L. ZHANG	U. GUO	21APR2015	Ocean Side Feed Applicator	1:2	1 of 4	D
MATERIAL:	FINISH:	Customer Accessible Production Drawing		WEIGHT:	RESTRICTED TO				

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

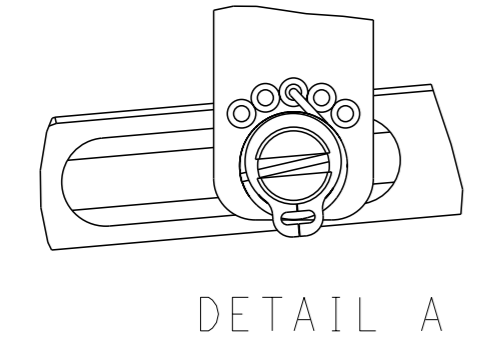
# FEED TYPE MECHANICAL



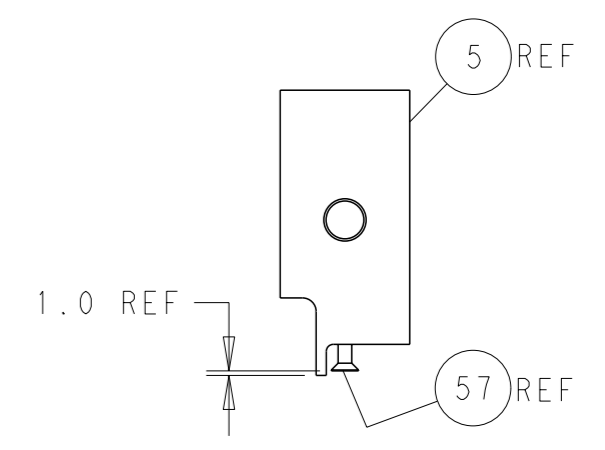
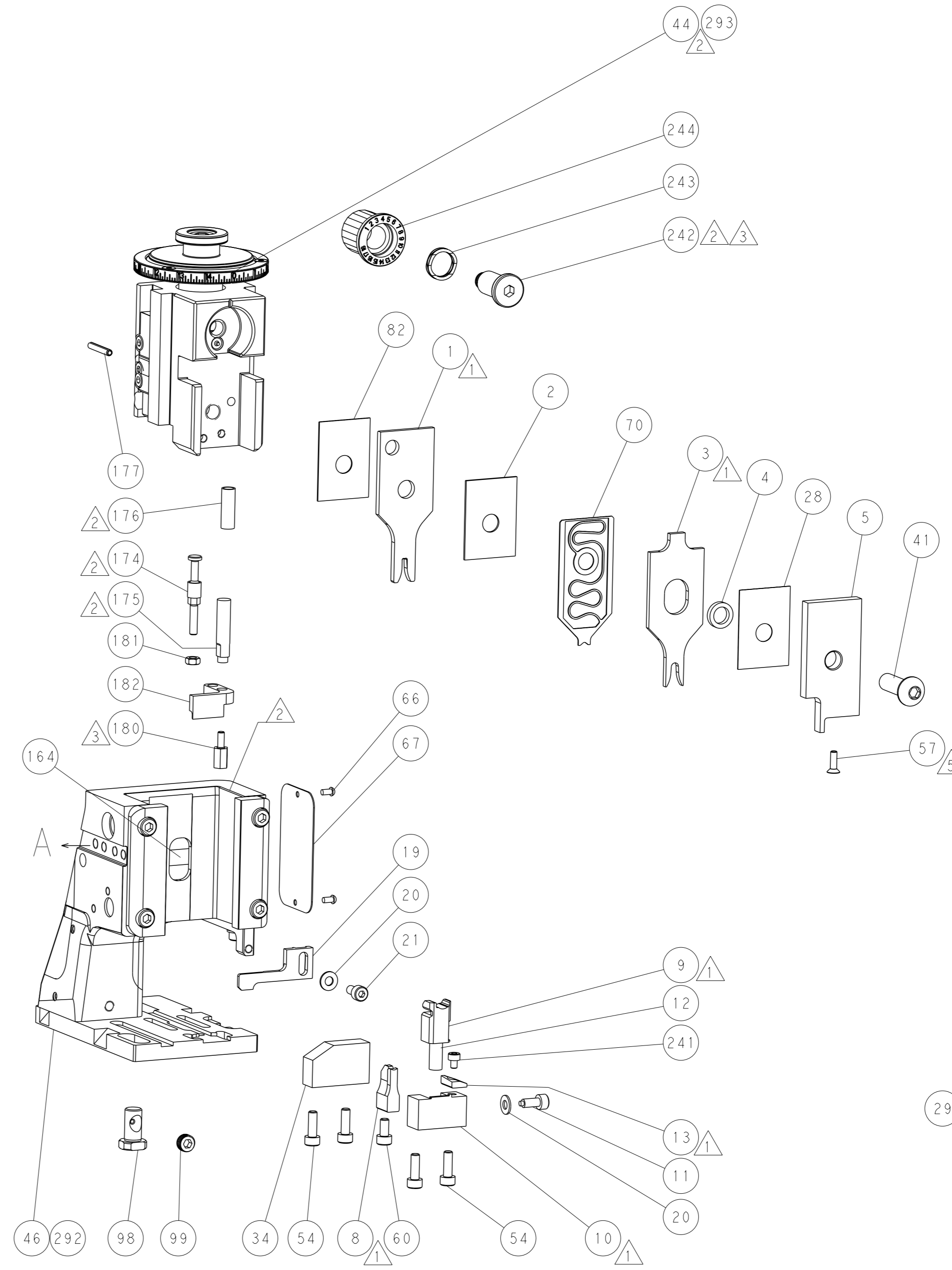
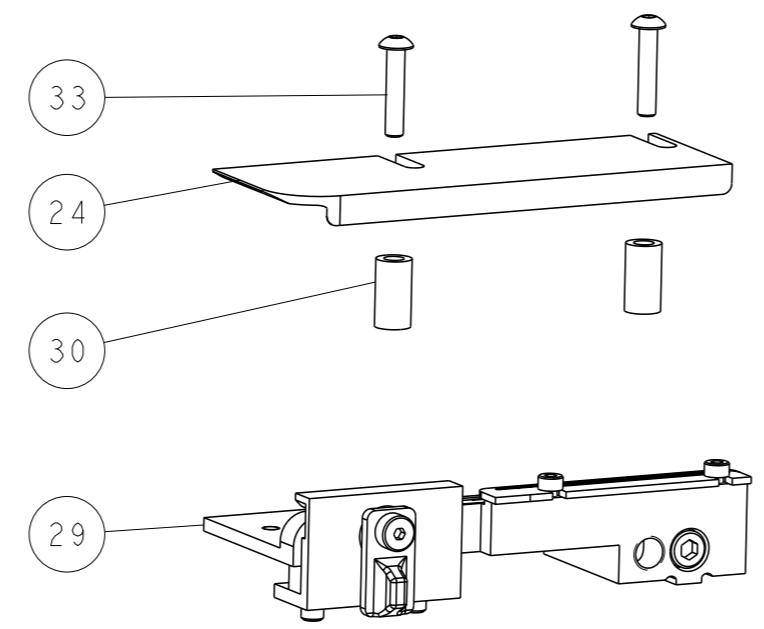
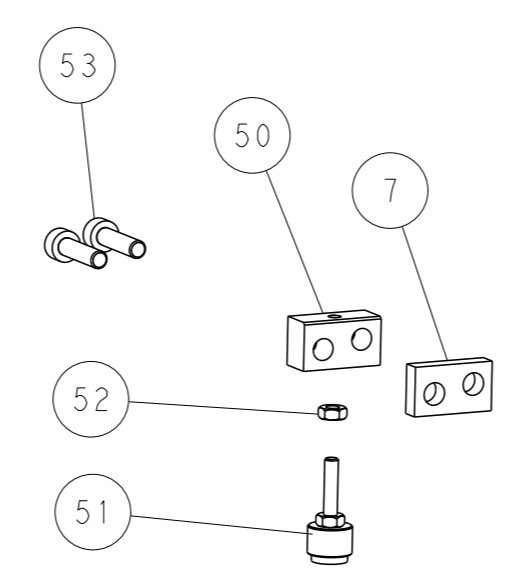
## PNEUMATIC



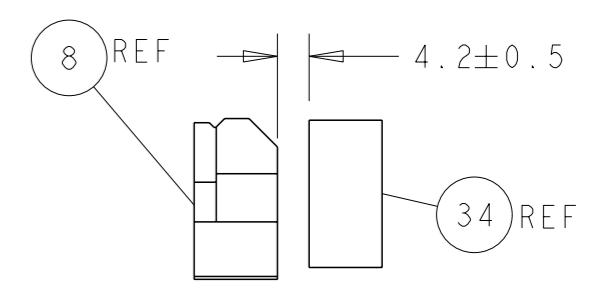
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



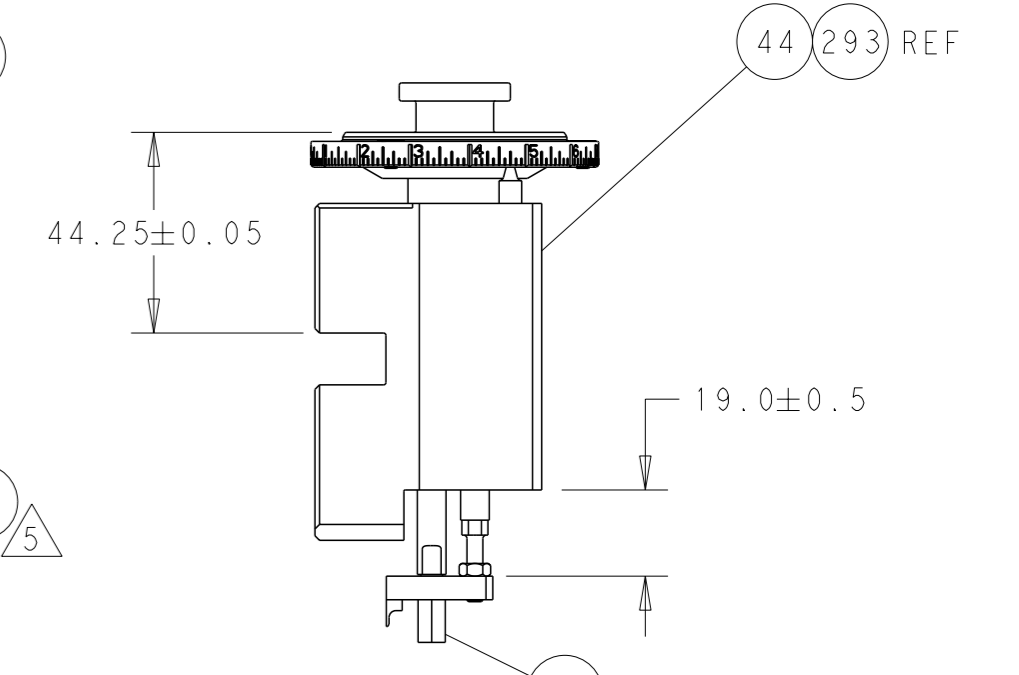
DETAIL A



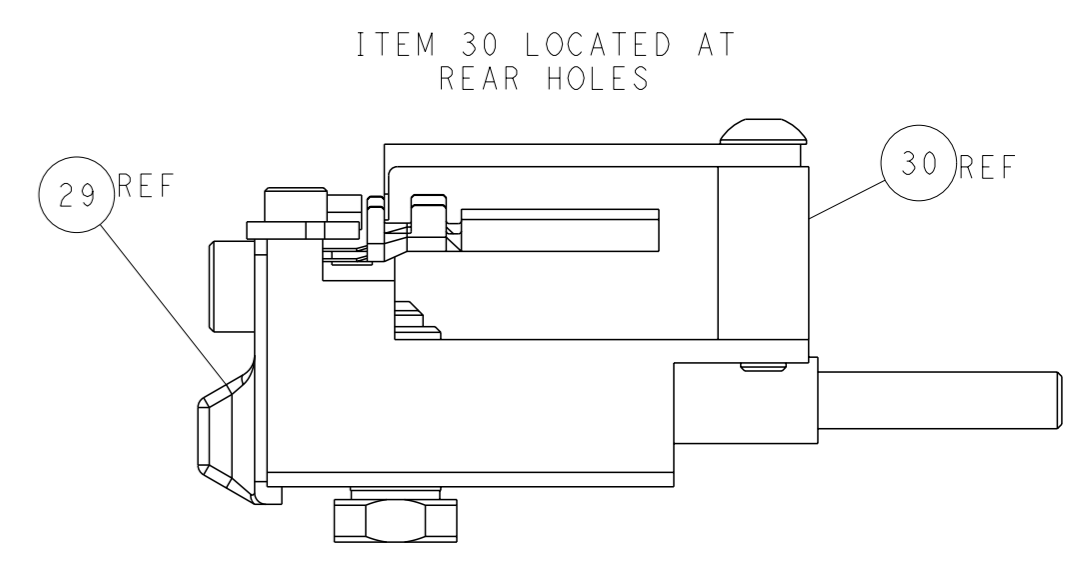
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

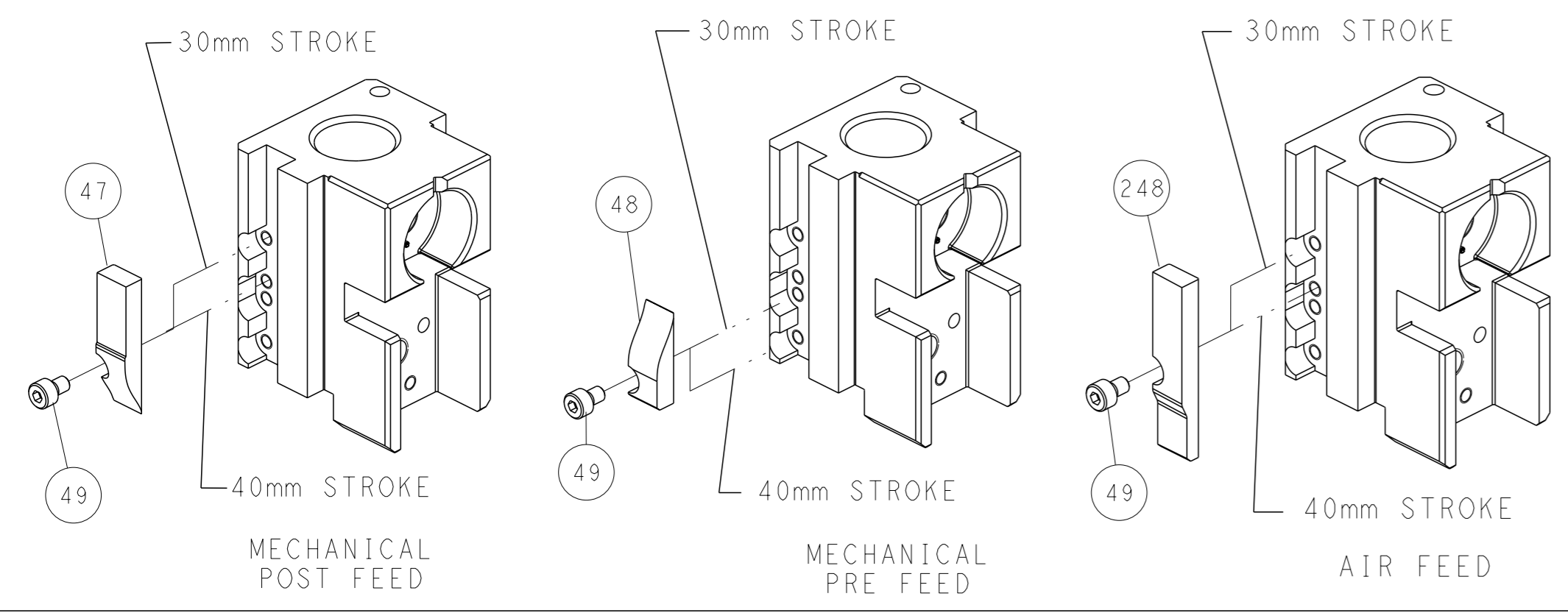


RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

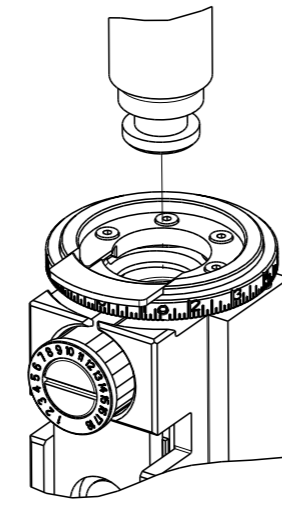


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: H. HUANG 21APR2015	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: L. ZHANG 21APR2015	
MATERIAL:		FINISH:		APVD: W. GUO 21APR2015	NAME: Ocean Side Feed Applicator
Customer Accessible Production Drawing		SCALE: 1:2	SHEET 2 of 4	REV D	RESTRICTED TO

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266765-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266765-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266765-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.34 mm [.092]	F
INSUL	3.81 mm [.150]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: 090 SEALED MALE TERMINAL				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE			
4.00-5.00 mm [.157-.197 IN]	∅			
TERMINAL APPLICATION SPECIFICATION T-023 Rev 07.08.11				
TERMINALS APPLIED				
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
2113698-1	8100-0459	1642378-1	7165-0349	1.4-2.0
		3311514-1	7165-0344	2.5-2.9
		963293-1		2.0-2.7

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: 090 SEALED FEMALE TERMINAL				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE			
4.00-5.00 mm [.157-.197 IN]	∅			
TERMINAL APPLICATION SPECIFICATION T-023 Rev 07.08.11				
TERMINALS APPLIED				
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
2113699-1	8100-0462	1642378-1	7165-0349	1.4-2.0
		3311514-1	7165-0344	2.5-2.9
		963293-1		2.0-2.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.90 +/- 0.05 [.075 +/- .002]	3.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.70 +/- 0.05 [.067 +/- .002]	5.5

**\*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.

- 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.

LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

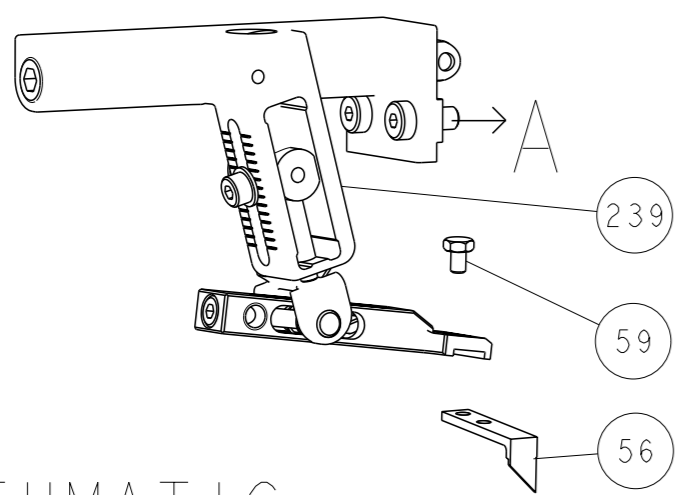
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	1338685-1	PAWL, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752356-1	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	1320928-6	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	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	4-1803171-1	ANVIL, COMBINATION	8
-	1	1	2-240641-0	SPACER	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	4-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
1	1	1	9-1633664-1	CRIMPER, WIRE	1
-	77	-22	-21	PART NO	ITEM NO

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

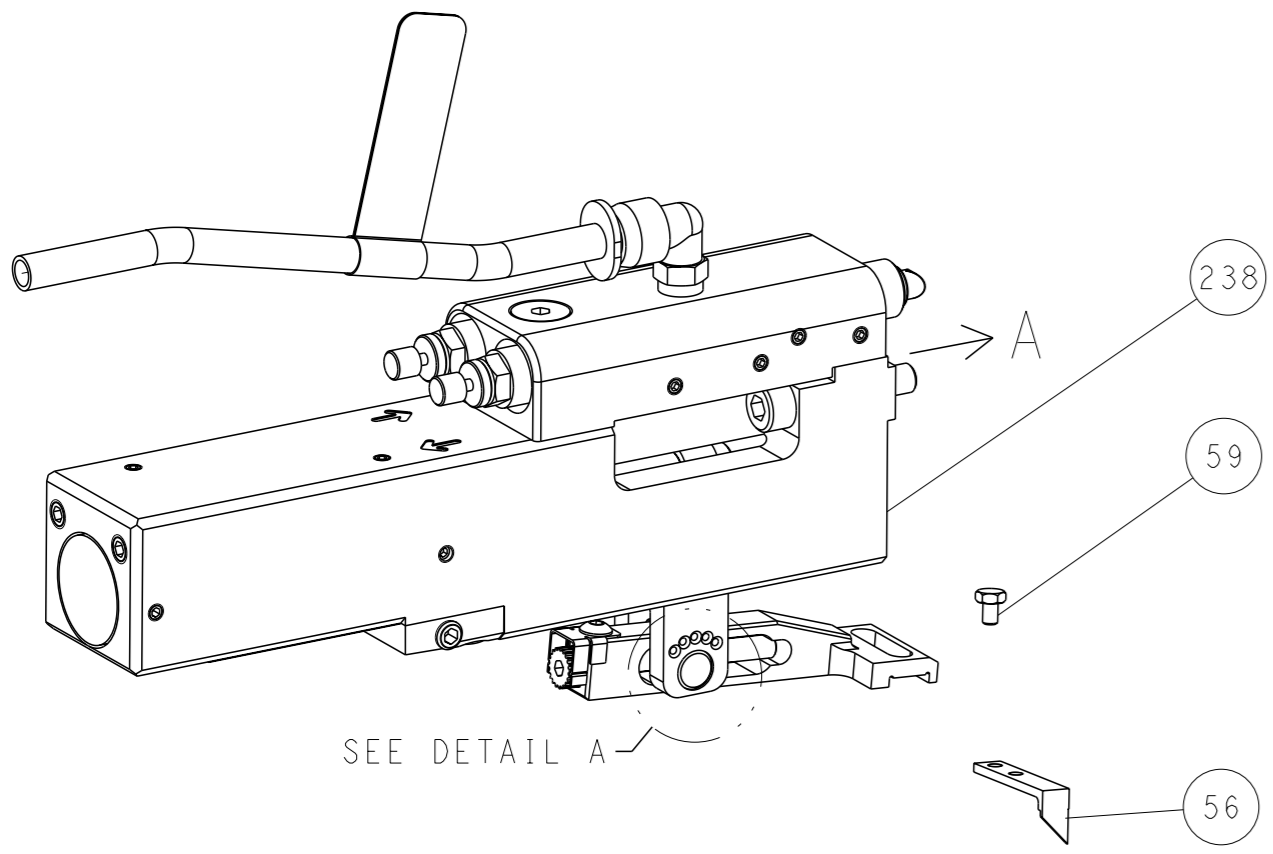
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES FINISH	SCALE
							1:2
MATERIAL				WEIGHT		RESTRICTED TO	
-				-		-	
Customer Accessible Production Drawing				SCALE		SHEET 3 of 4	
-				-		REV D	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

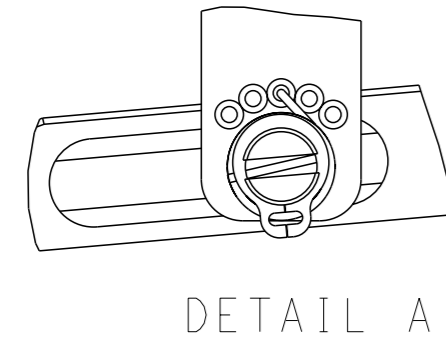
# FEED TYPE MECHANICAL



# PNEUMATIC

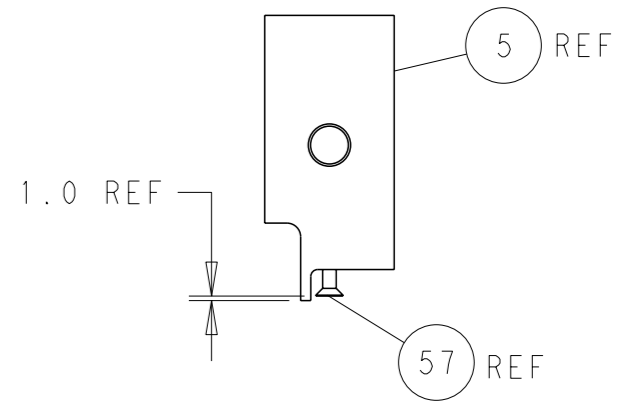
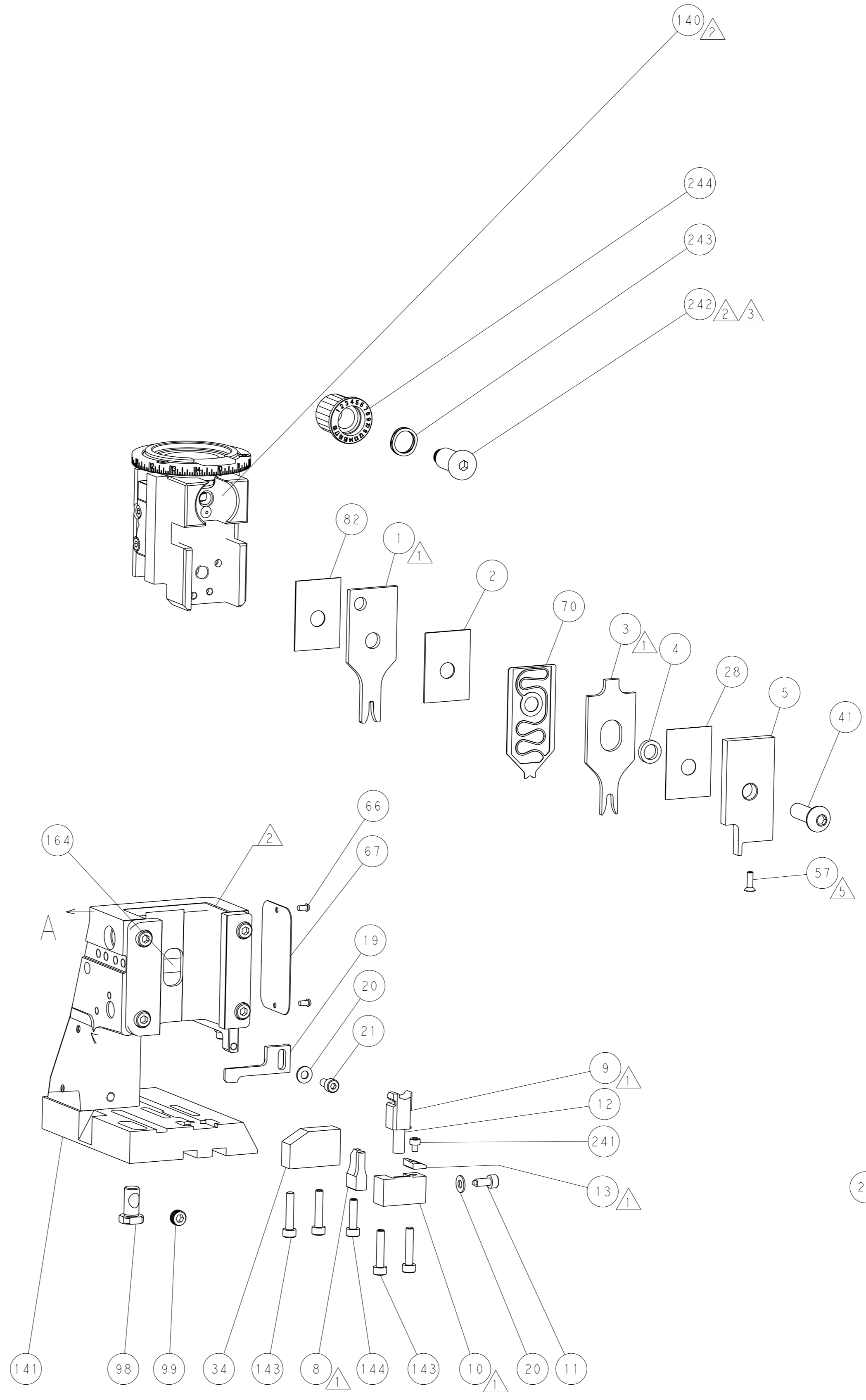
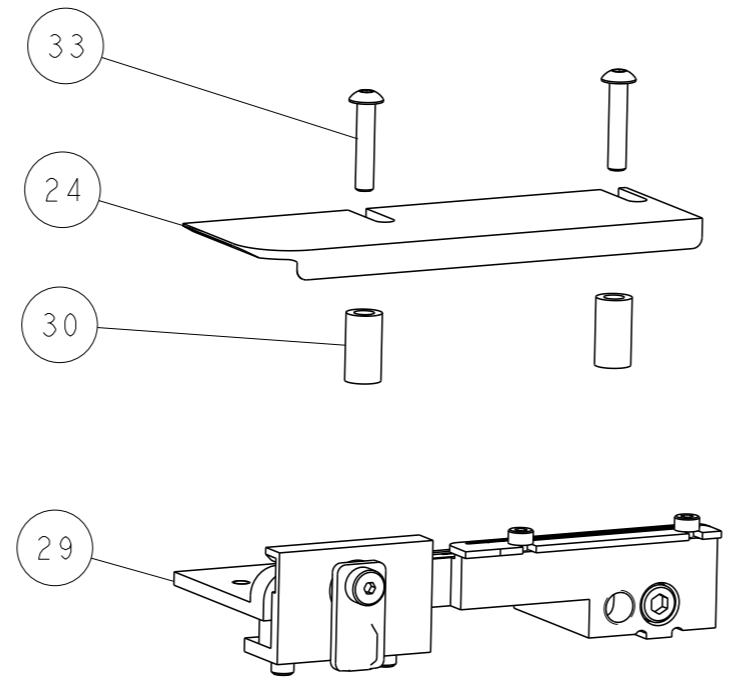
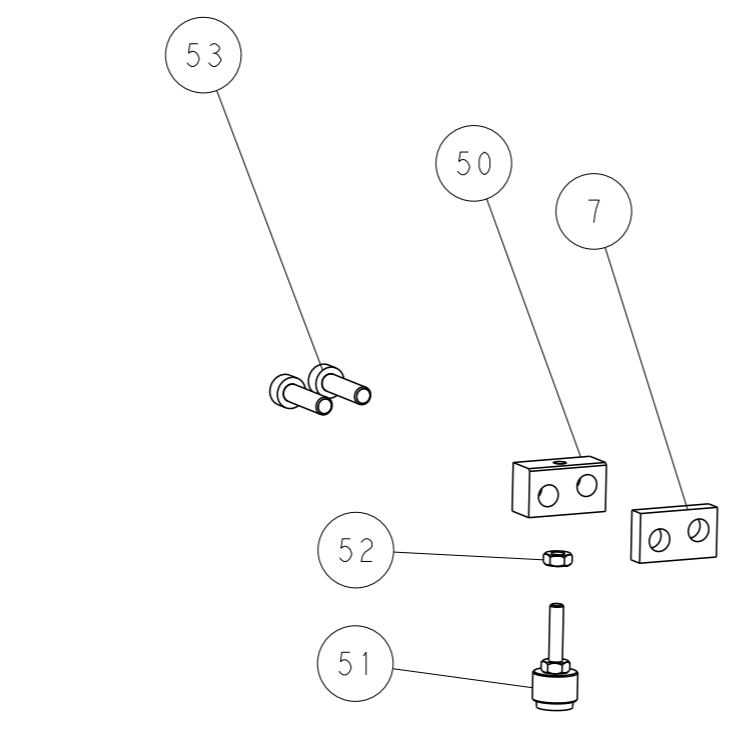
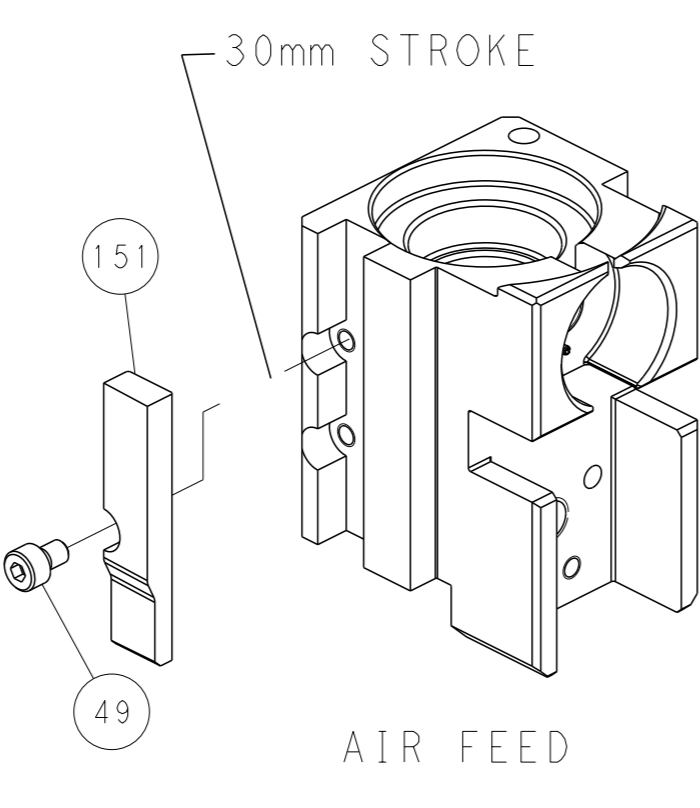
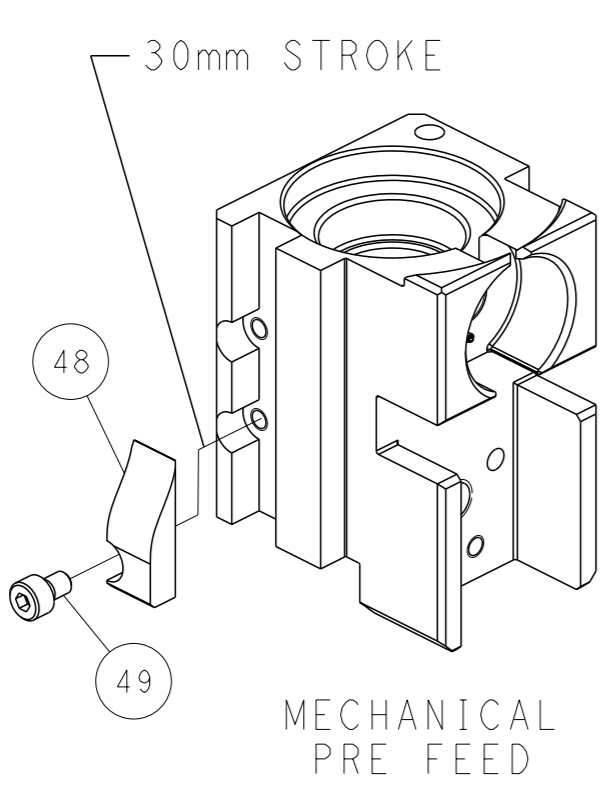
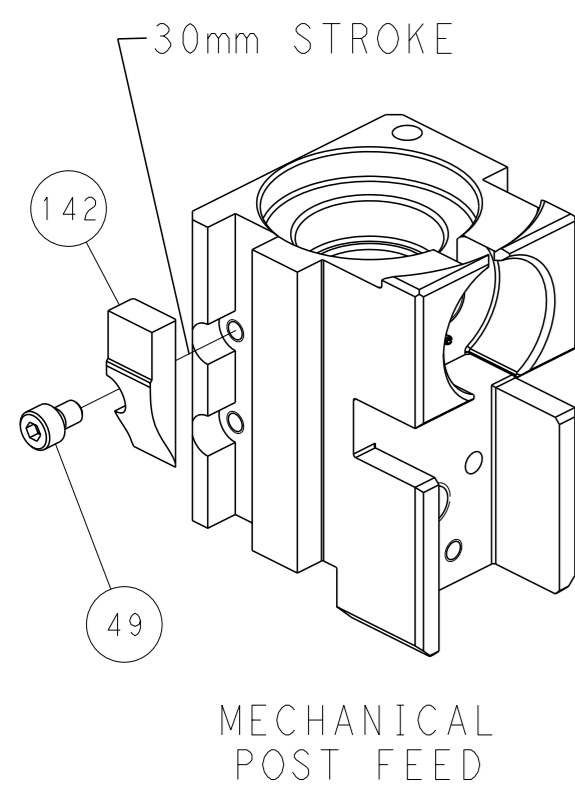


# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

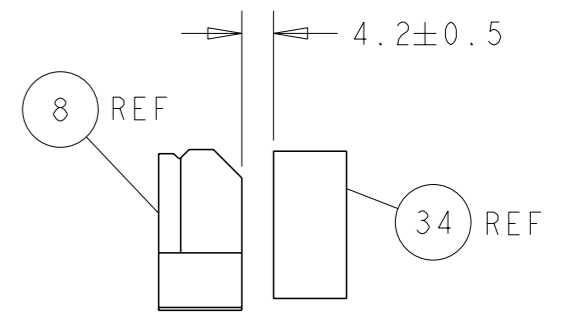


DETAIL A

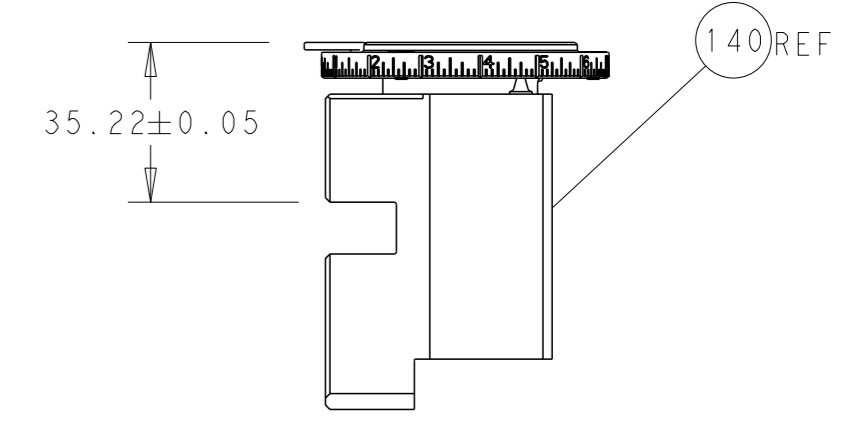
# CAM POSITIONS



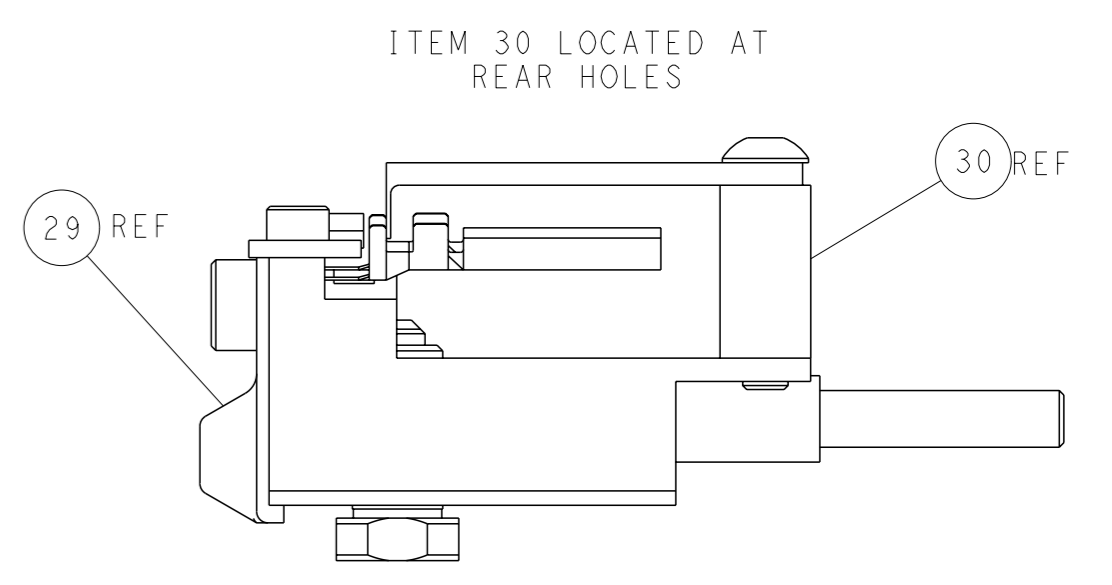
SHEAR DEPRESSOR DETAIL



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: H. HUANG CHK: L. ZHANG APVD: J. GUO	DATE: 21APR2015 PRODUCT SPEC: - APPLICATION SPEC: -	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - SCALE: 1:2 SHEET: 4 of 4 REV: D	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266765	RESTRICTED TO: -	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION