

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266004-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266004-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266004-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266004-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266004-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.73 mm [.068]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-35042		

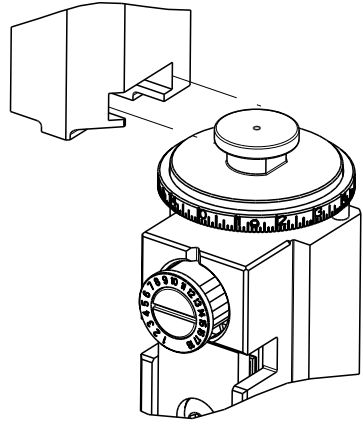
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GET FEMALE TERMINAL 1.2mm, THIN, 1.00mm SQ			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.00-4.40 mm [.157-.173 IN]			Ø1.90-2.10 mm [.075-.083 IN]
TERMINAL APPLICATION SPECIFICATION		114-13236	
			
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1924782-1	1924782-2	1924782-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.12+/-0.05 [.044+/- .002]	7.0



- 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 TERMINAL LUBRICANT IS RECOMMENDED

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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

*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.

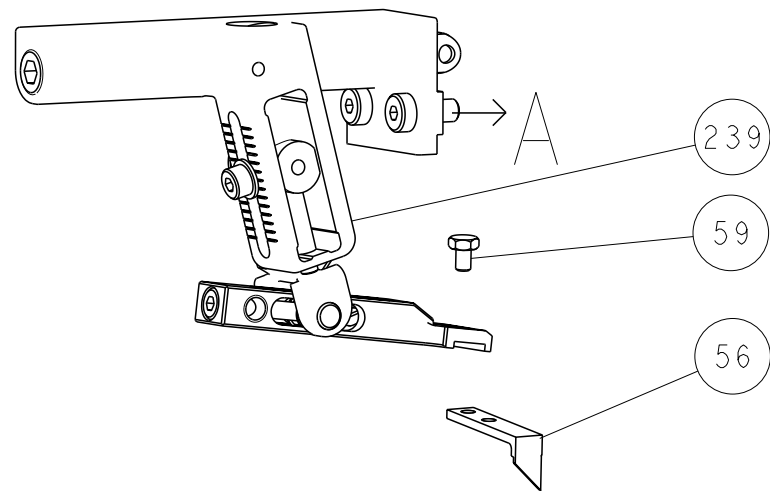
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		C		ECR-19-006806	29APR2019	FZ	TE	
		D		ECR-18-007259	07MAY2019	TB	CT	
		E		ECR-20-005821	21APR2020	JWC	GB	

3	-	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	2119082-8	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
6	-	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	1-22281-8	SPRING, COMPRESSION	121
	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	1	1	854769-4	HOLDER, INS	74	
-	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	
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	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	1803382-6	HOLD DOWN, SPRING LOADED	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	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844938-5	PLATE, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-2	DRAG, TERMINAL	25	
-	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	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	318707-9	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	2-1633928-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	3-1803019-6	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2	
-	1	2	2	1	1	1803892-1	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	DESCRIPTION	ITEM NO

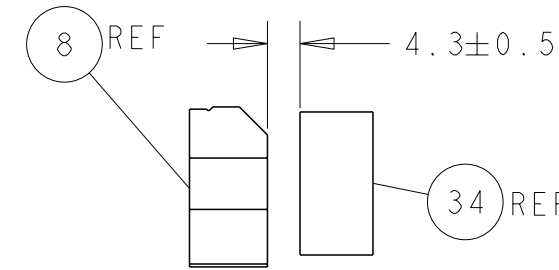
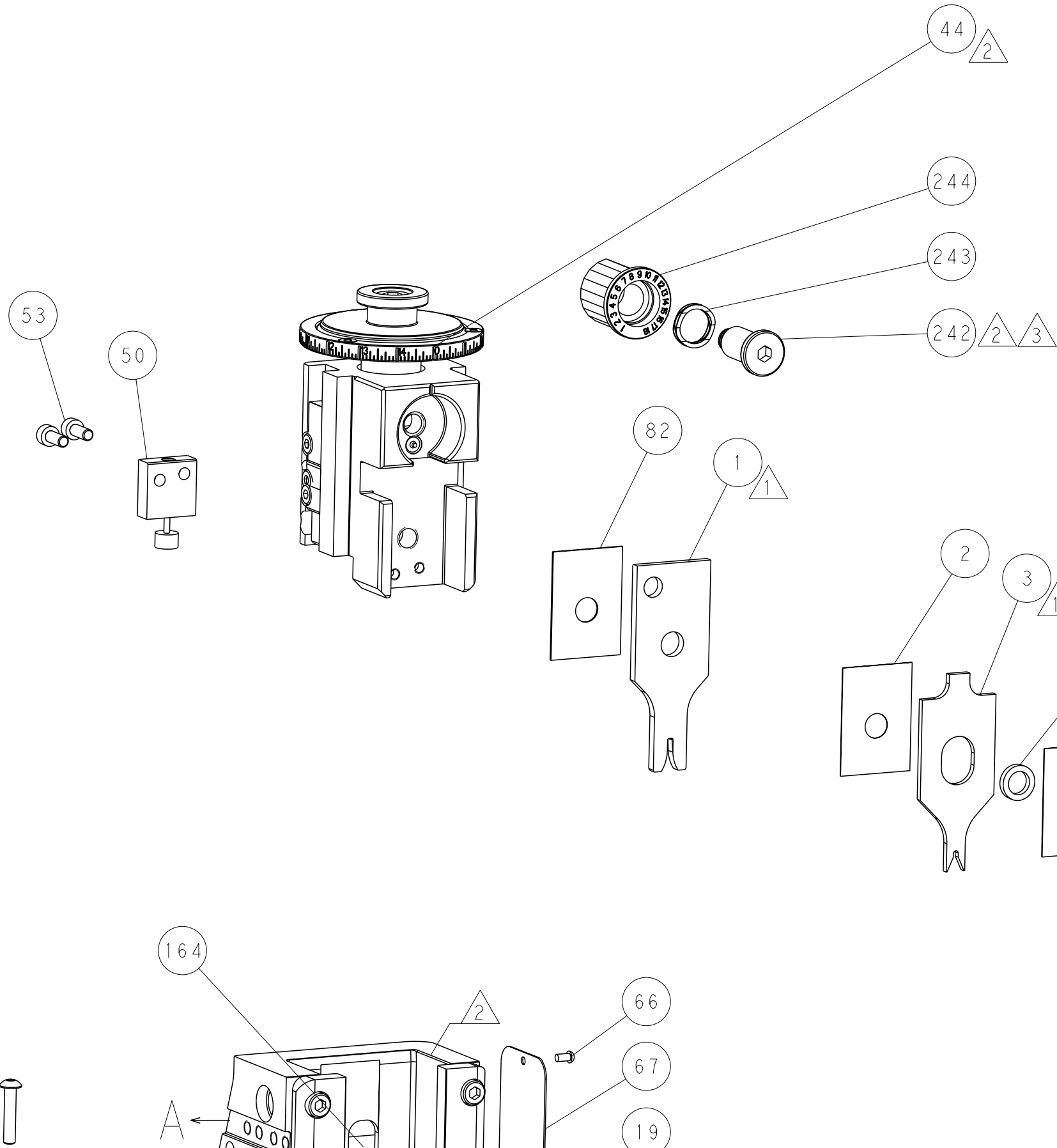
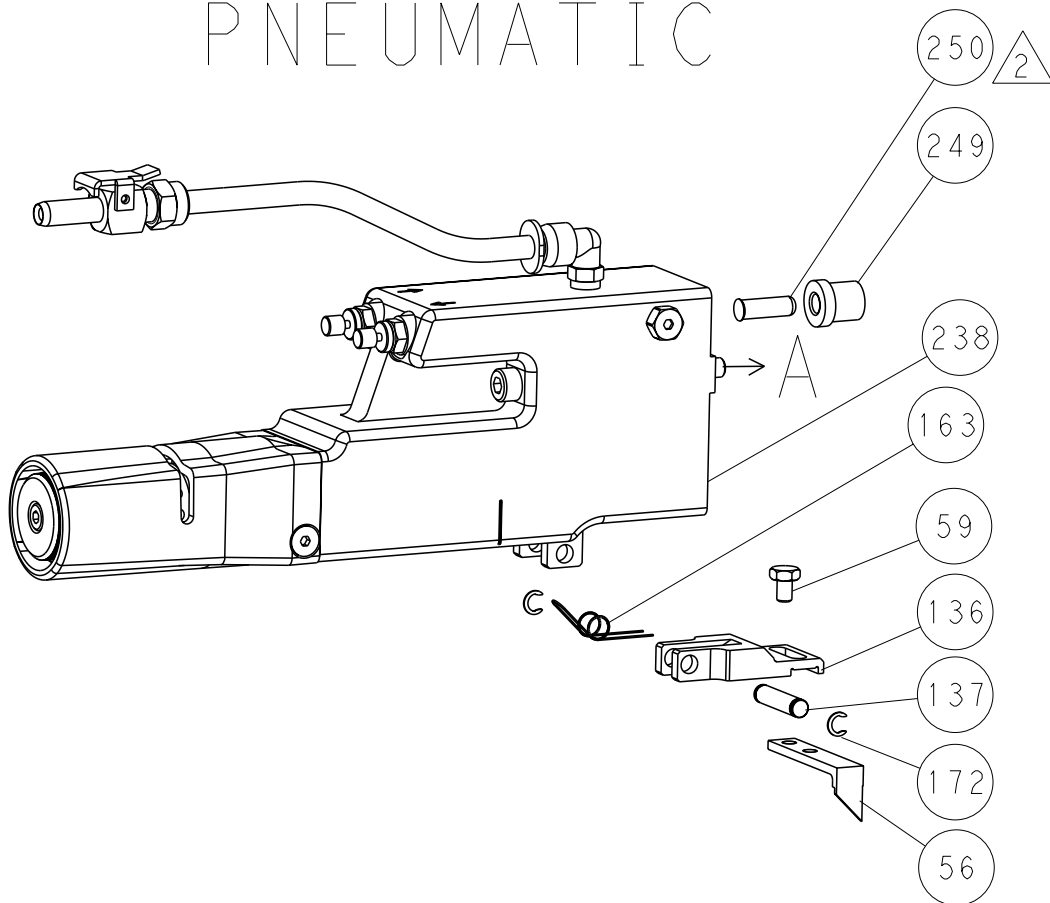
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN R. HUANG 19JUL2013	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS:				CHK L. ZHANG 19JUL2013			
mm				APVD J. GUO 19JUL2013			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC			
0 PLC ±				APPLICATION SPEC	NAME Ocean Side Feed Applicator		
1 PLC ±				-	SIZE		
2 PLC ±				-	CASE CODE		
3 PLC ±				-	DRAWING NO		
4 PLC ±				-	RESTRICTED TO		
ANGLES				-	A1 00779 ©=2266004		
FINISH				-	Customer Accessible Production Drawing		
MATERIAL				-	SCALE 1:2		
-				-	SHEET 1 of 4		
-				-	REV E		

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

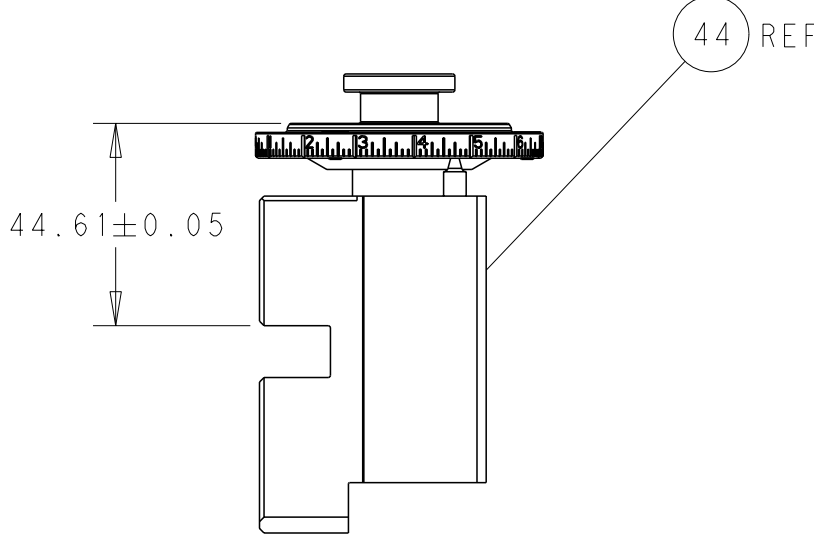
FEED TYPE
MECHANICAL



PNEUMATIC

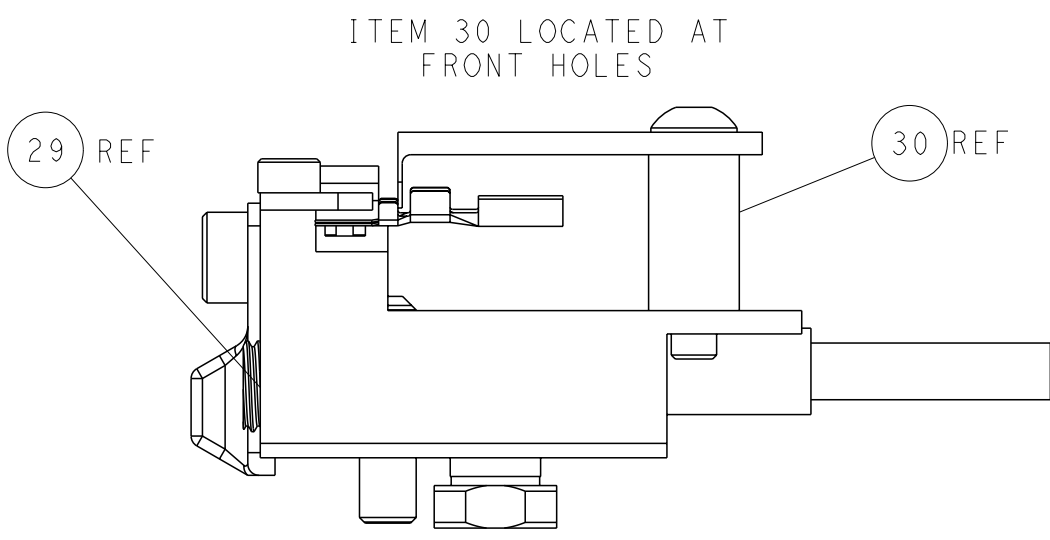
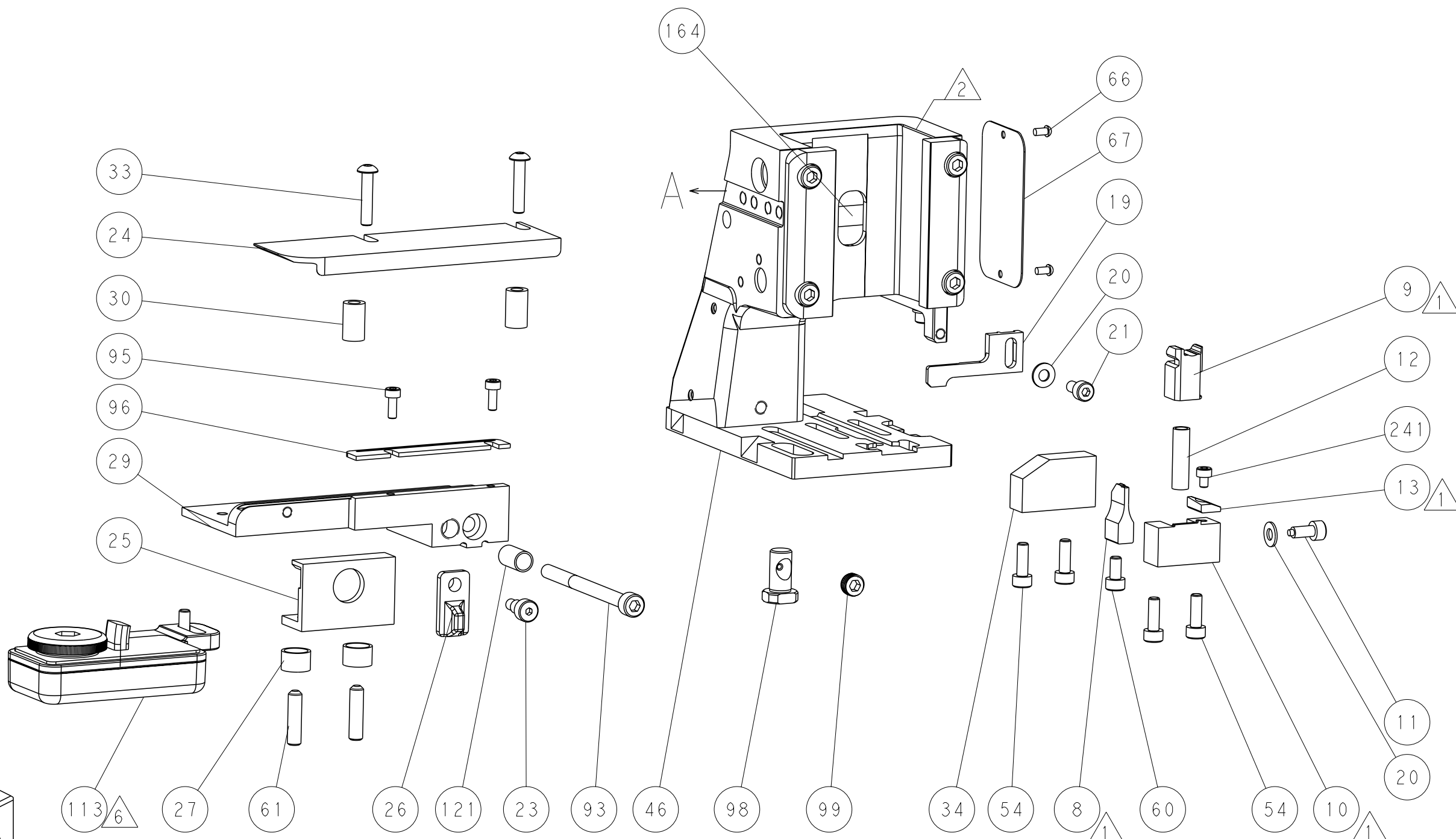
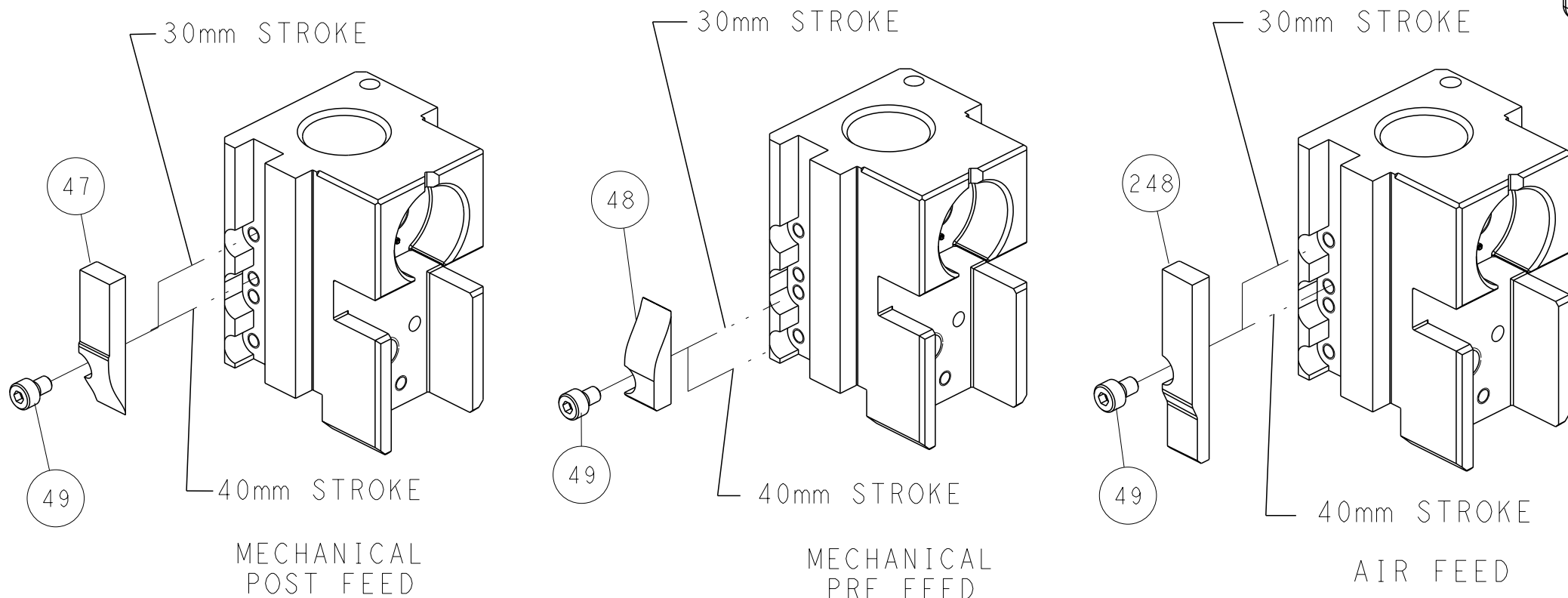


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITIONS



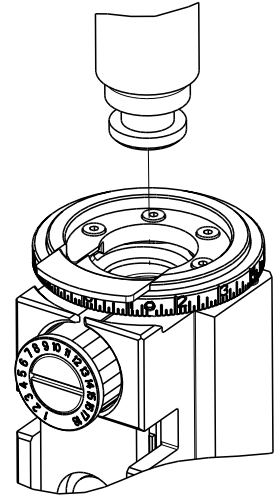
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

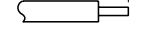
1. THIS DRAWING IS CONTROLLED DOCUMENT. NO ALTERATIONS ARE TO BE MADE WITHOUT THE AUTHORIZATION OF THE DESIGN ENGINEER. 2. THIS DRAWING IS THE PROPERTY OF TE CONNECTIVITY. IT IS TO BE KEPT IN THE ORIGINAL FILED IN THE COMPANY RECORDS. 3. THIS DRAWING IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF TE CONNECTIVITY.				DWN	19JUL2013	 TE Connectivity Harrisburg, PA 17105-3608									
DIMENSIONS:				CHK	19JUL2013										
mm				APVD	19JUL2013										
TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME											
				PRODUCT SPEC		Ocean Side Feed Applicator									
				APPLICATION SPEC											
				SIZE	CASE CODE		DRAWING NO	RESTRICTED TO							
				WEIGHT											
MATERIAL					A	00779	C=2266004	-							
				Customer Accessible Production Drawing				SCALE	1:2	SHEET	2	of	4	REV	E

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266004-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266004-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266004-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.73 mm [.068]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GET FEMALE TERMINAL 1.2mm, THIN, 1.00mm SQ			
WIRE STRIP LENGTH 4.00-4.40 mm [.157-.173 IN]			INSULATION DIAMETER RANGE Ø1.90-2.10 mm [.075-.083 IN]
TERMINAL APPLICATION SPECIFICATION	114-13236	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1924782-1	1924782-2	1924782-3	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.12+/-0.05 [.044+/- .002]		7.0



- 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 TERMINAL LUBRICANT IS RECOMMENDED

*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	LYR	DESCRIPTION	DATE	OWN	APVD	
		-		SEE SHEET 1	-	-	-	

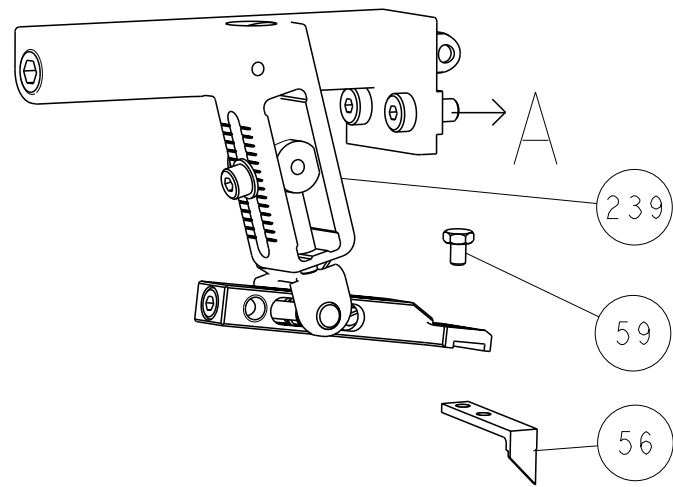
3	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2063440-1	AIR FEED MODULE	238
1	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	2119641-2	FEED CAM, AIR FEED	151
6	-	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	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
	-	1	1	1-22281-8	SPRING, COMPRESSION	121
6	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-690438-0	FRONT STRIP GUIDE	96
1	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	5-547505-2	SPRING, COMPRESSION	77
1	-	1	1	854769-4	HOLDER, INS	74
	-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
1	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	1	1	1338685-1	PAWL, FEED	56
1	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	2119652-1	FEED CAM, PRE FEED	48
1	-	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	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
1	-	1	1	2844938-5	PLATE, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
1	-	1	1	240792-2	DRAG, TERMINAL	25
	-	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
1	-	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	1-356885-4	STOP, SHEAR	11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	318707-9	FLOATING SHEAR, FRONT	9
	1	1	1	2-1633928-8	ANVIL, COMBINATION	8
1	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	3-1803019-6	CRIMPER, INSULATION O	3
	-	1	1	455888-2	SPACER, CRIMPER	2
	1	1	1	1803892-1	CRIMPER, WIRE PREMIUM	1

- 77 - 22 - 21			PART NO		DESCRIPTION			ITEM NO
OWN 19JUL2013								 TE Connectivity Harrisburg, PA 17105-3608
CHK K. HUANG 19JUL2013								
APVD L. ZHANG 19JUL2013								
APVD U. GUO 19JUL2013								
NAME								
Ocean Side Feed Applicator								
-								
SIZE								
CAGE CODE								
DRAWING NO								
RESTRICTED TO								
A1 00779 ©=2266004								
Customer Accessible Production Drawing								
SCALE								
1:2								
SHEET								
3 OF 4								
REV								
E								

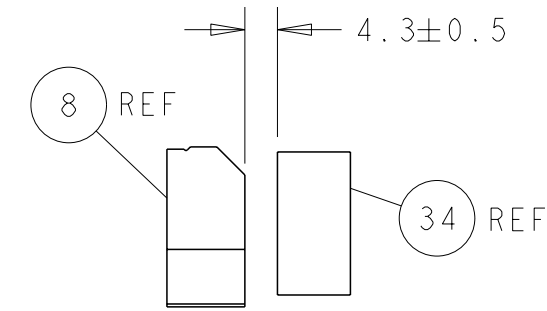
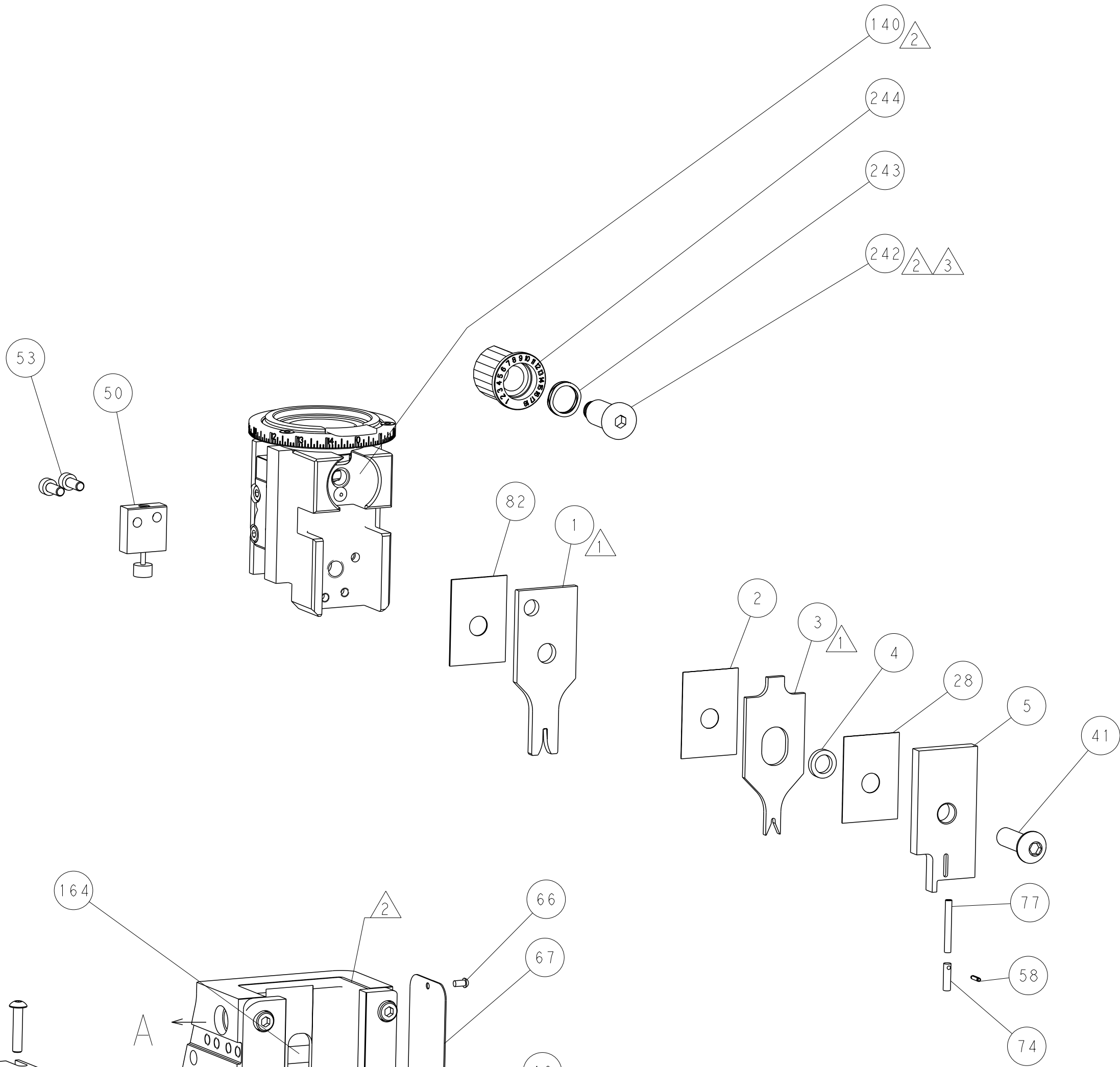
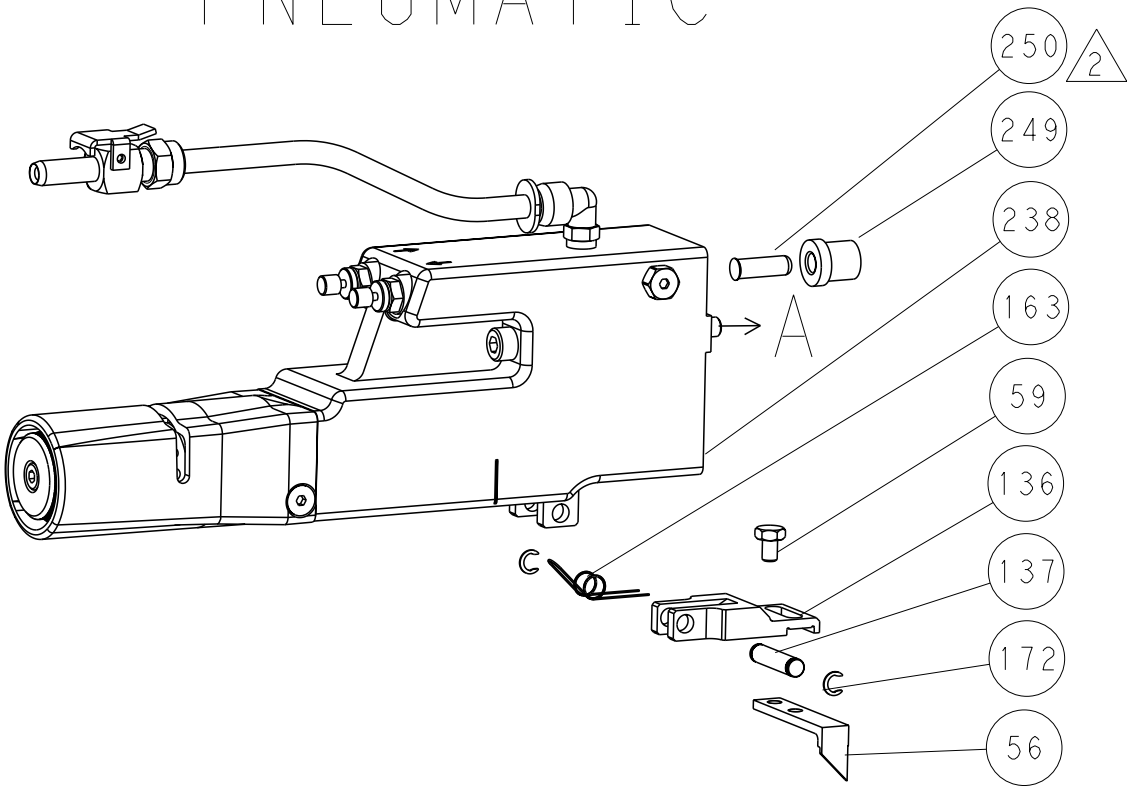
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

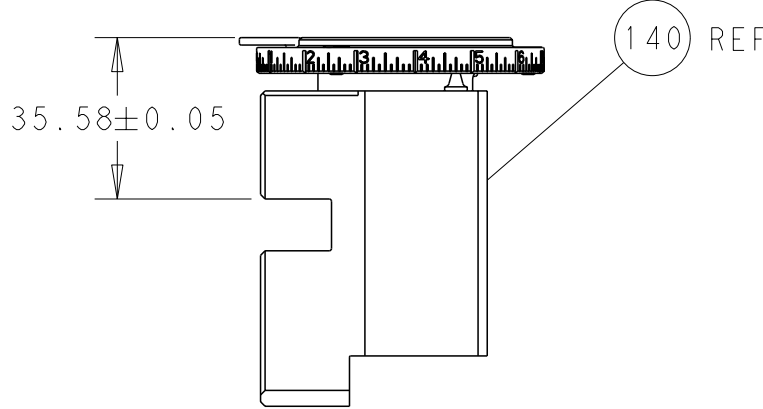
FEED TYPE
MECHANICAL



PNEUMATIC

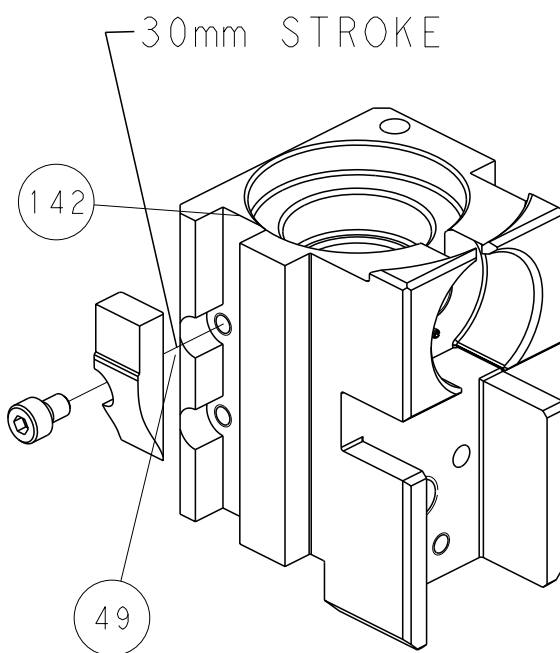


TERMINAL SUPPORT LOCATION

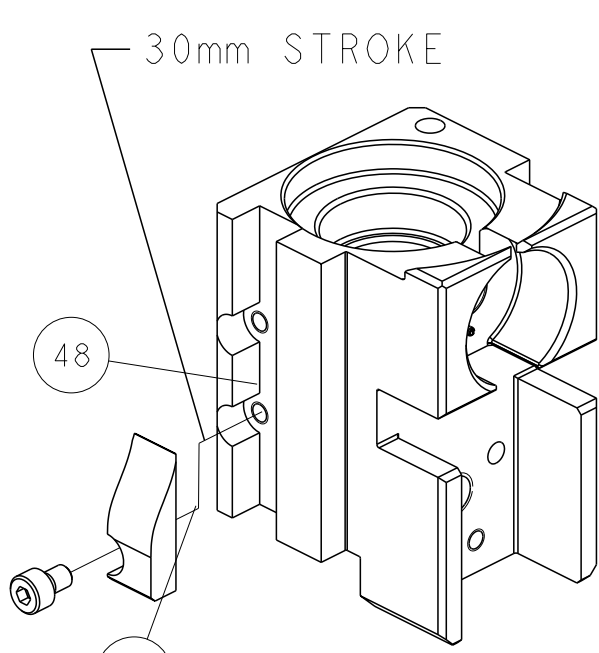


RAM SET-UP

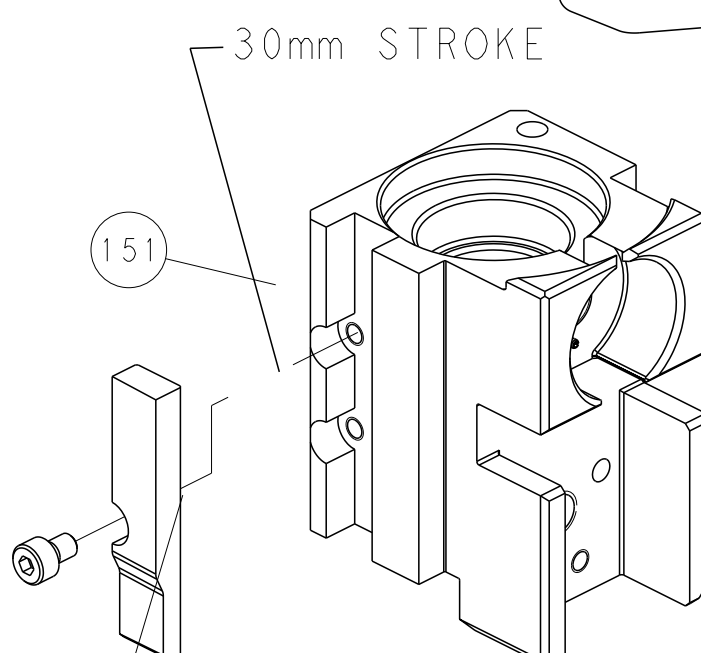
CAM POSITIONS



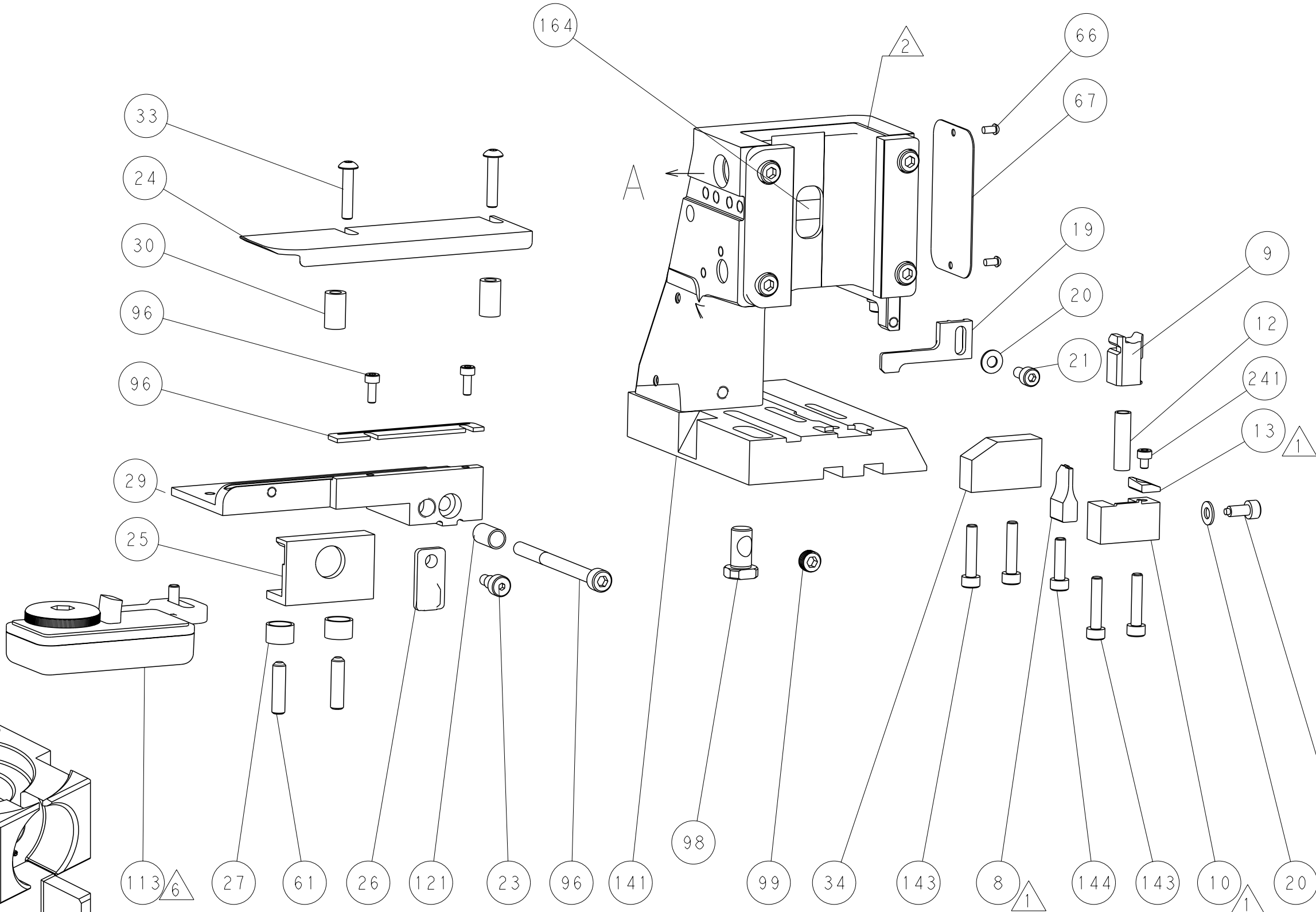
MECHANICAL
POST FEED



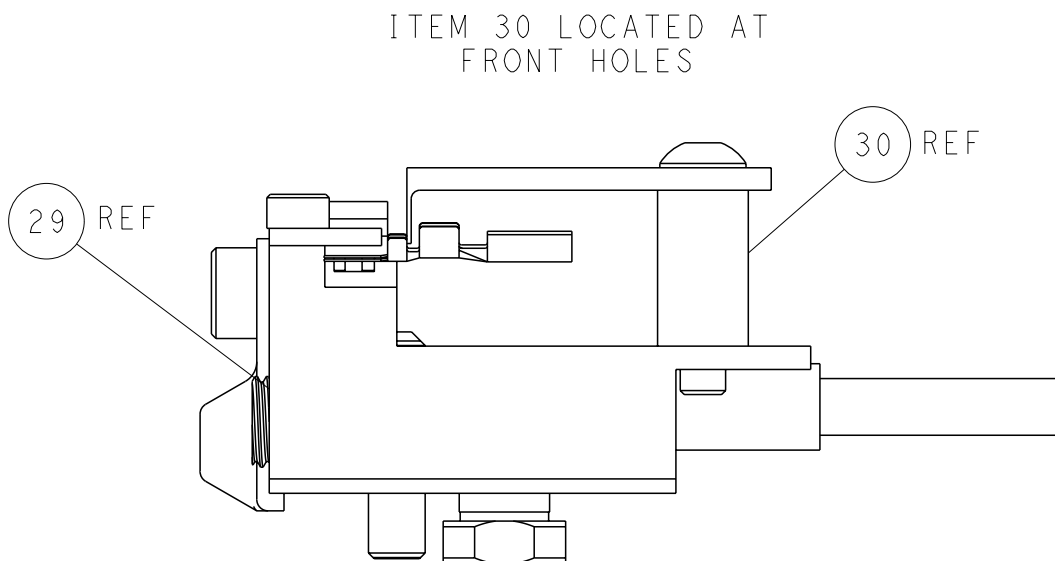
MECHANICAL
PRE FEED



AIR FEED



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



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG 19JUL2013		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±		CHK L. ZHANG 19JUL2013		NAME Ocean Side Feed Applicator	
FINISH		1 PLC ±		APVD U. GUO 19JUL2013		SIZE A1	
MATERIAL		2 PLC ±		PRODUCT SPEC		CAGE CODE 00779	
		3 PLC ±		APPLICATION SPEC		DRAWING NO C=2266004	
		4 PLC ±		WEIGHT		RESTRICTED TO	
		ANGLES		Customer Accessible Production Drawing		SCALE 1:2	
		FINISH		SHEET 4		OF 4	
						REV E	