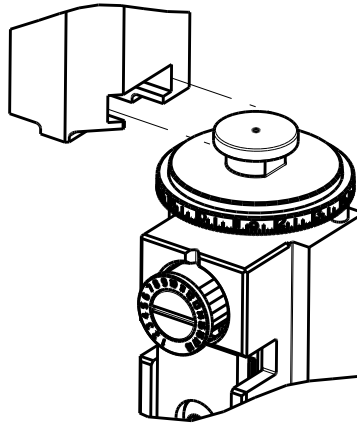
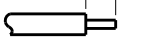


8		7	
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20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266419-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266419-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266419-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266419-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266419-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.67 mm [.066]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL		KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: KOSTAL MLK 1.2m RECEPTACLE			
WIRE STRIP LENGTH 2.60-3.60 mm [.102-.142 IN]			INSULATION DIAMETER RANGE Ø1.20-1.40 mm [.047-.055 IN]
TERMINAL APPLICATION SPECIFICATION		DOC00061540 ATTACHMENT 3 P6. 50 OF 57	
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE TERMINAL	KOSTAL TERMINAL
1949957-1	3 21 24 73401 0/3	1949957-2	3 21 25 73401 0/3
1949957-3	3 21 40 73401 0/3	1572680-1	3 21 40 65176 0/3
1572680-2	3 21 24 65176 0/3	1572680-3	3 21 25 65176 0/3
1949380-1	3 21 24 73406 0/3	1949380-2	3 21 25 73406 0/3
1949380-3	3 21 40 73406 0/3		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.35mm2		0.76+/-0.03 [.030+/- .001]		6.9



- 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. 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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		A		RELEASE	23SEP2014	MR	GD
		B		ECR-17-017161	21NOV2017	JAH	TE
		B1		ECR-18-014882	19SEP2018	KH	CT
		C		ECR-19-014046	09SEP2019	FZ	TE

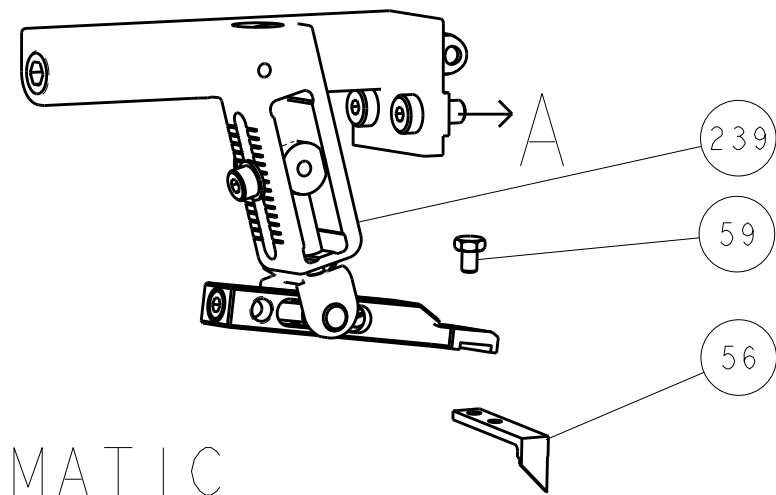
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	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	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1803382-1	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	2-1752356-0	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	2844992-2	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	1803095-6	FLOATING SHEAR, FRONT -	9
-	1	2	2	1	1-1803554-5	ANVIL, COMBINATION	8
-	1	1	1	1	240641-1	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	7-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	2	1	2-1633664-7	CRIMPER, WIRE	1
-	77	72	71	-2	-1	PART NO	ITEM NO
						DESCRIPTION	

THE INFORMATION ON THIS DOCUMENT IS UNCLASSIFIED FOR THE PRODUCTION OF THE PRODUCT. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.				DWN	J. HOU	23JULY2014	 TE Connectivity Harrisburg, PA 17105-3608					
				CHK	Y. YIN	23JULY2014						
				APVD	H. GUO	23JULY2014						
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC			NAME Ocean Side Feed Applicator					
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APPLICATION SPEC								
MATERIAL				WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO			
						A1	00779	©=2266419	-			
Customer Accessible Production Drawing				SCALE		1:2	SHEET	1 OF 4	REV	C		

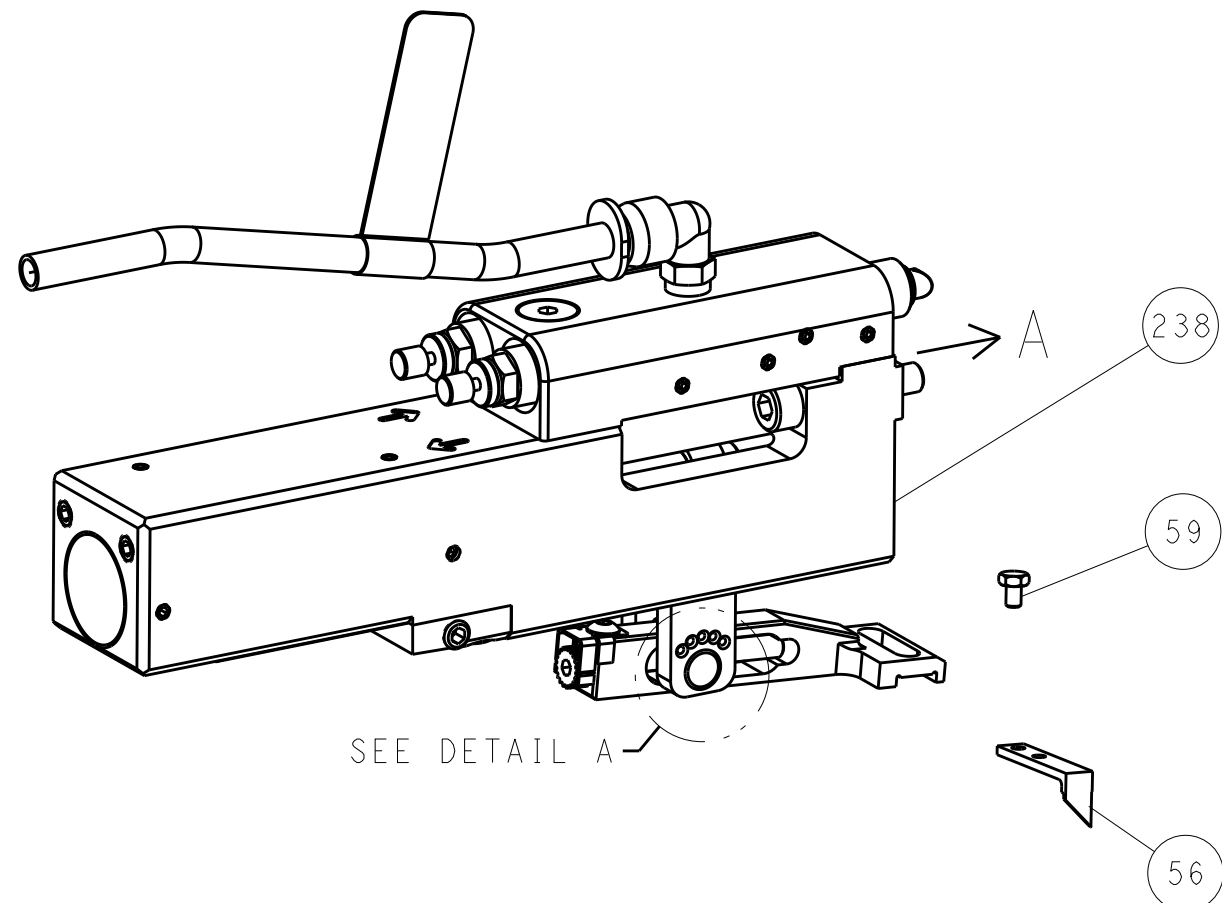
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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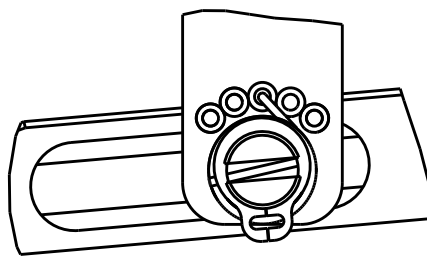
FEED TYPE MECHANICAL



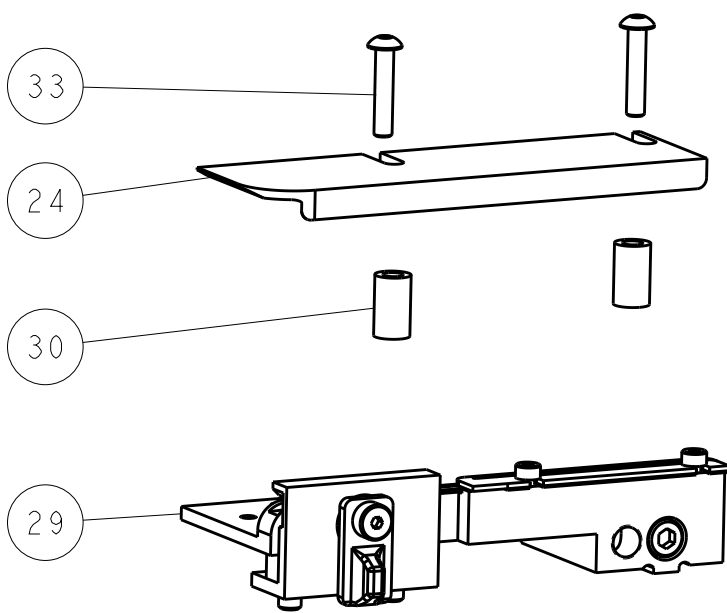
PNEUMATIC



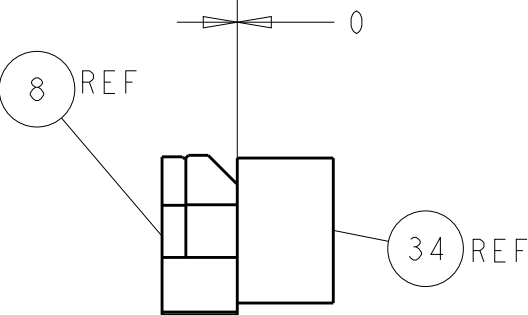
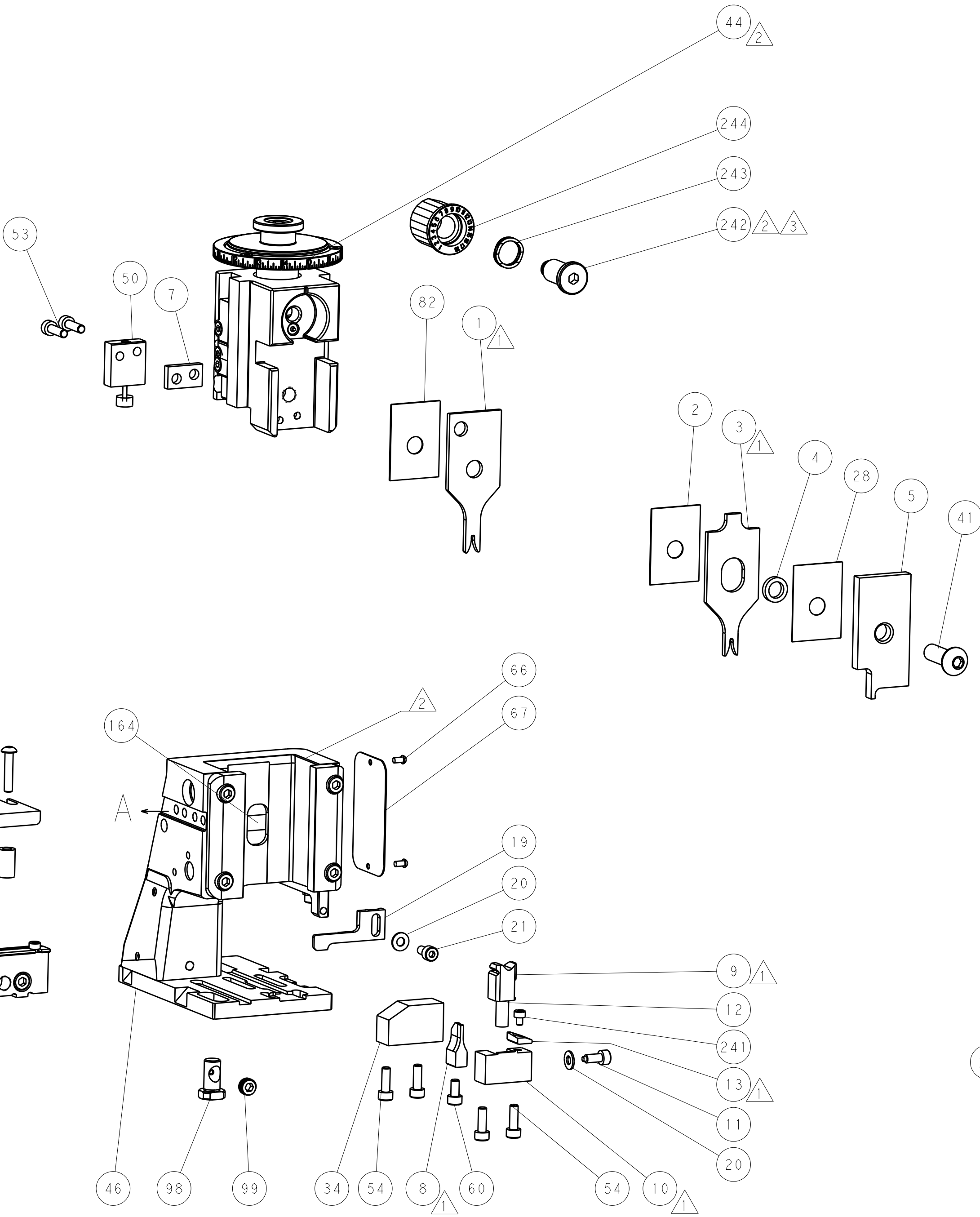
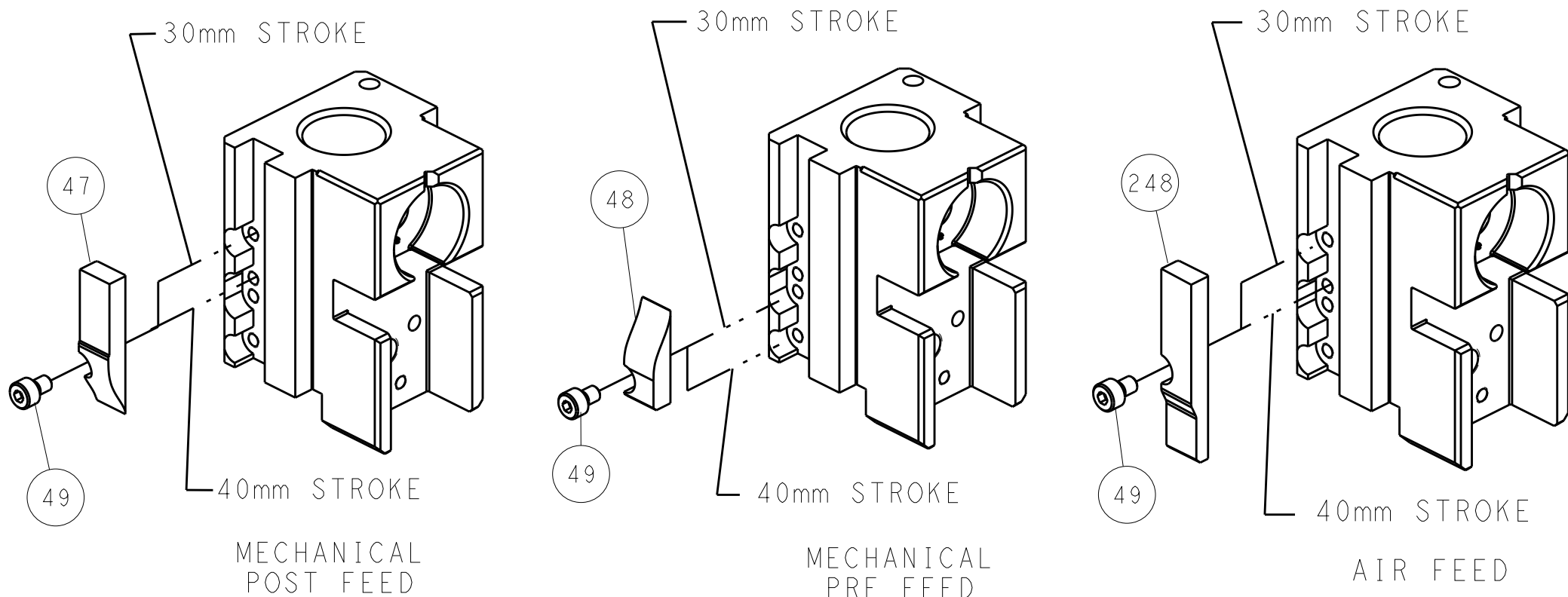
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



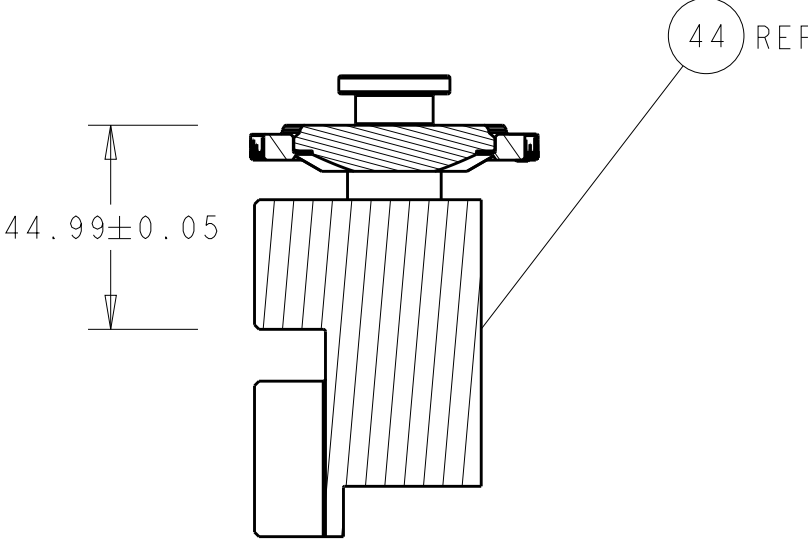
DETAIL A



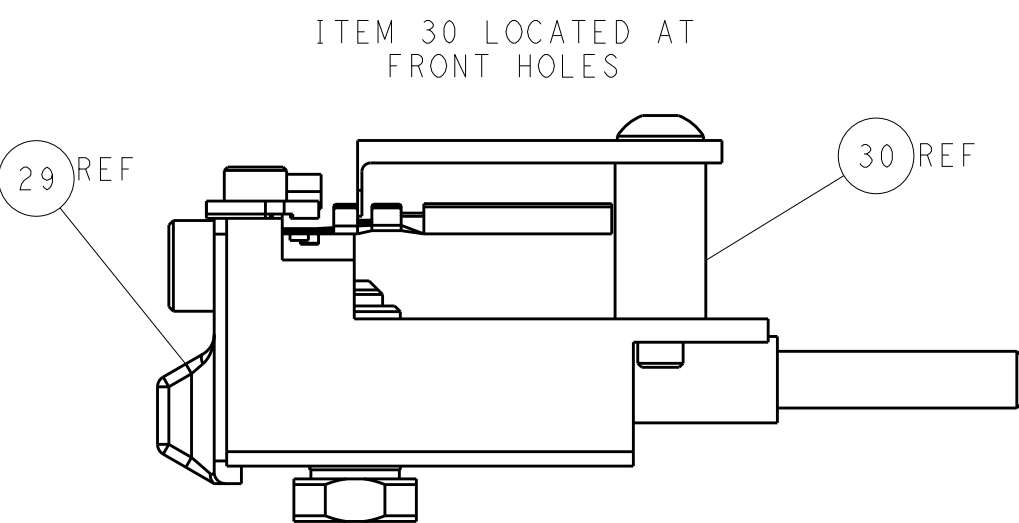
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN	J. HOU	23JULY2014	 TE Connectivity Harrisburg, PA 17105-3608					
		CHK	Y. YIN	23JULY2014						
		APVD	H. GUO	23JULY2014						
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME Ocean Side Feed Applicator -				
mm		0 PLC ±.1								
		1 PLC ±.1								
		2 PLC ±.1								
		3 PLC ±.1								
		4 PLC ±.1								
		ANGLES								
		FINISH								
MATERIAL		WEIGHT								
						SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
						A1	00779	C=2266419	-	
Customer Accessible Production Drawing					SCALE	1:2	SHEET	2 OF 4	REV	C

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266419-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266419-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266419-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.67 mm [.066]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL		KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: KOSTAL MLK 1.2m RECEPTACLE			
WIRE STRIP LENGTH 2.60-3.60 mm [.102-.142 IN]		INSULATION DIAMETER RANGE Ø1.20-1.40 mm [.047-.055 IN]	
TERMINAL APPLICATION SPECIFICATION		DOC00061540 ATTACHMENT 3 PG. 50 OF 57	
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE TERMINAL	KOSTAL TERMINAL
1949957-1	3 21 24 73401 0/3	1949957-2	3 21 25 73401 0/3
1949957-3	3 21 40 73401 0/3	1572680-1	3 21 40 65176 0/3
1572680-2	3 21 24 65176 0/3	1572680-3	3 21 25 65176 0/3
1949380-1	3 21 24 73406 0/3	1949380-2	3 21 25 73406 0/3
1949380-3	3 21 40 73406 0/3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.76+/-0.03 [.030+/-0.011]	6.9



- 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. 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	REVISIONS				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

-	1	1	2119082-5	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	455888-6	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
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-1	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2-1752356-0	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	2844992-2	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	1803095-6	FLOATING SHEAR, FRONT -	9
-	1	1	1-1803554-5	ANVIL, COMBINATION	8
-	1	1	240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
-	1	1	7-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	2-1633664-7	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			OWN J. HOU 23JULY2014 CHK Y. YIN 23JULY2014 APVD H. GUO 23JULY2014		
			TE Connectivity Harrisburg, PA 17105-3608		
			NAME Ocean Side Feed Applicator		
			SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2266419 -		
			Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV C		

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

D

C

B

A

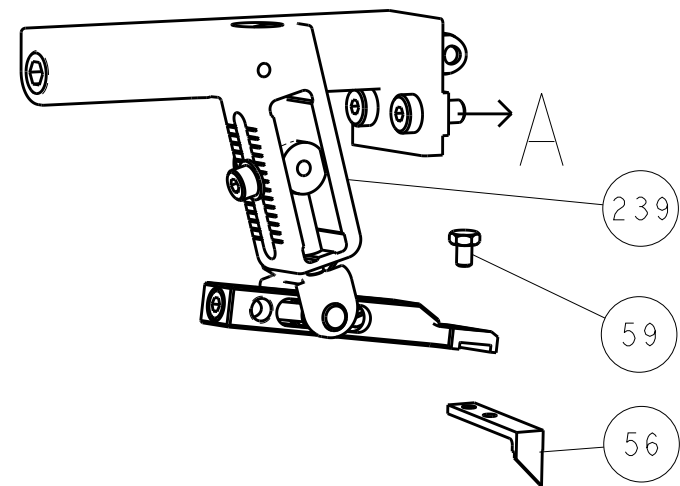
D

C

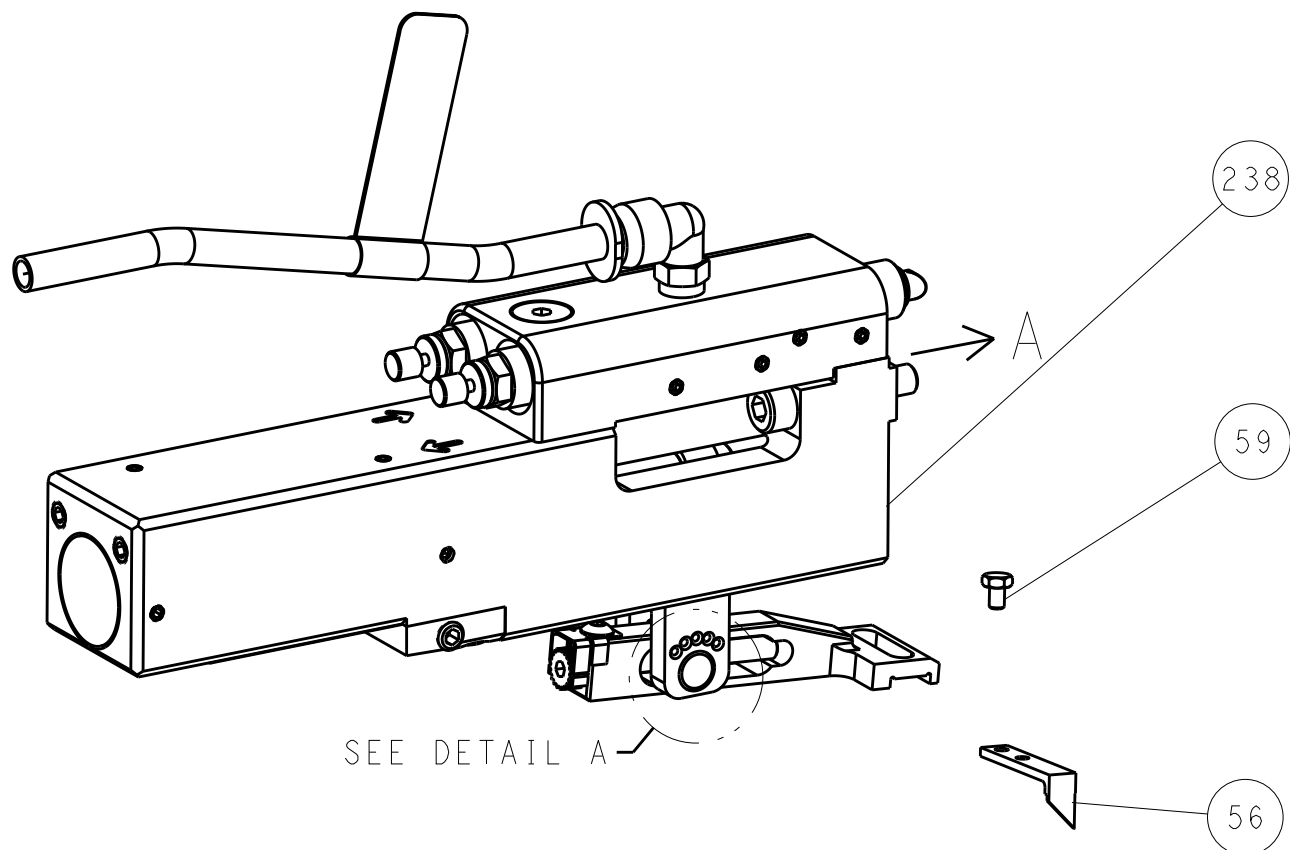
B

A

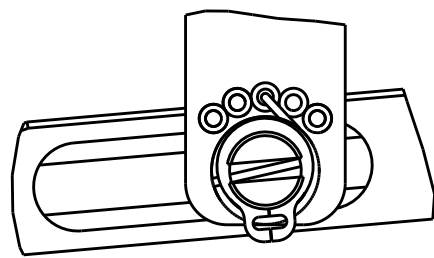
FEED TYPE MECHANICAL



PNEUMATIC

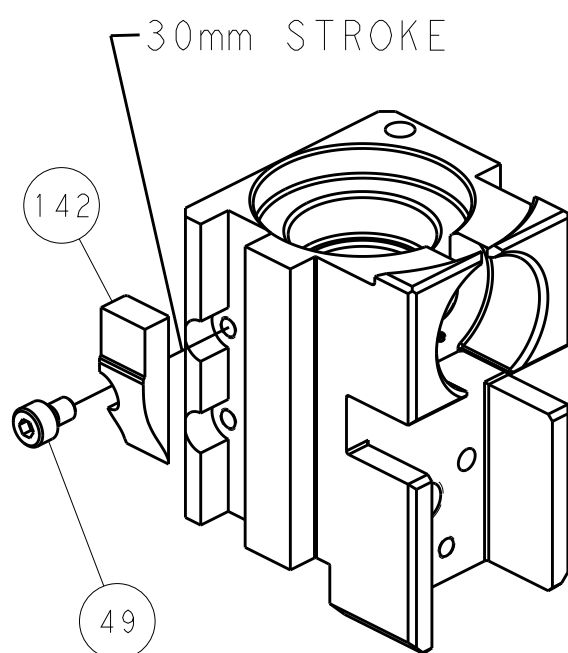


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

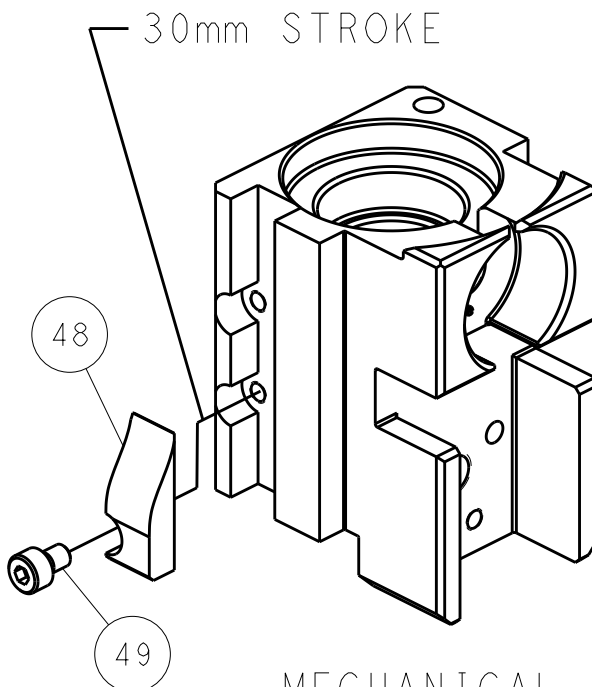


DETAIL A

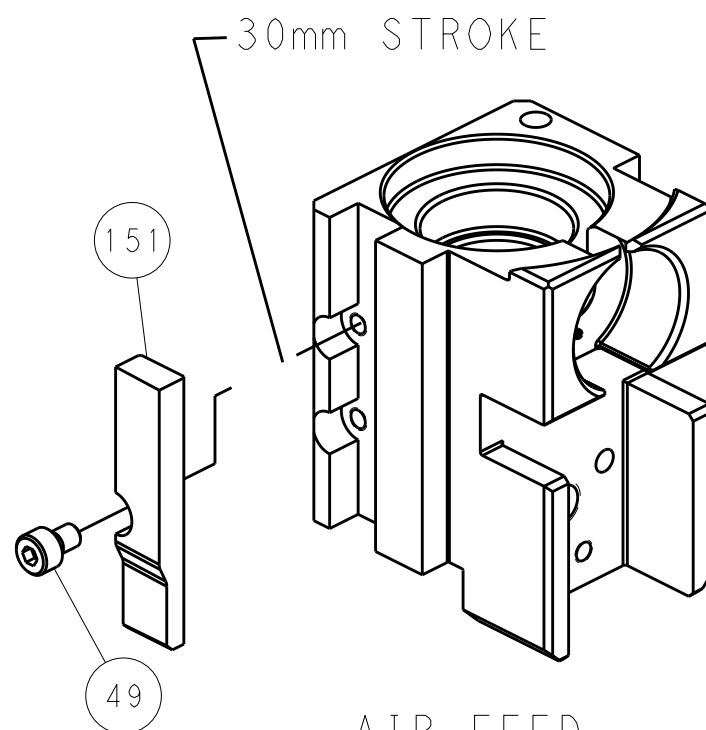
CAM POSITIONS



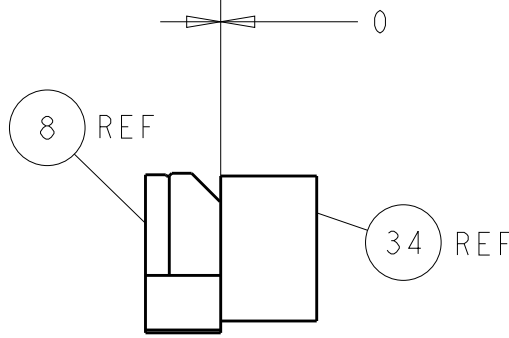
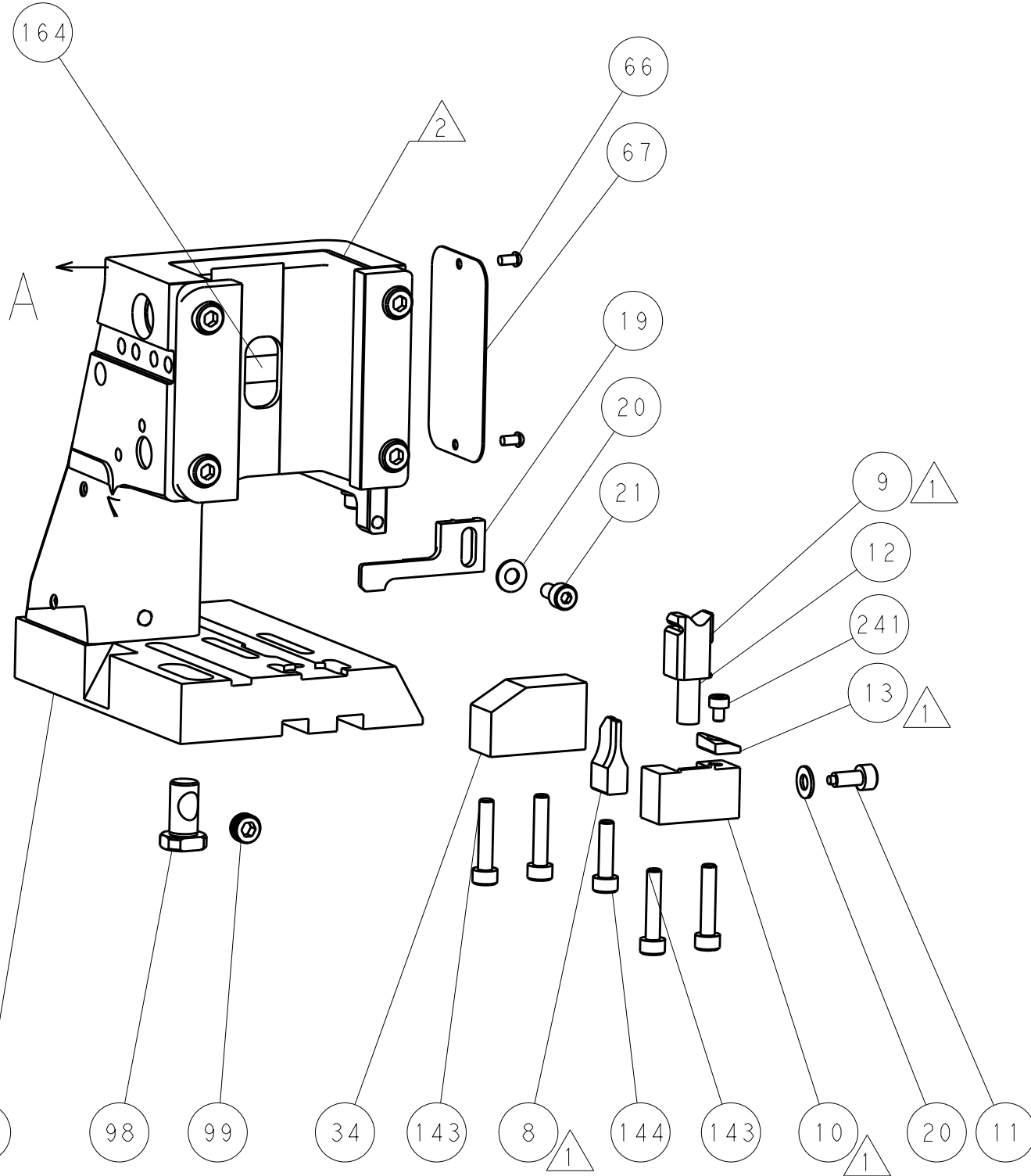
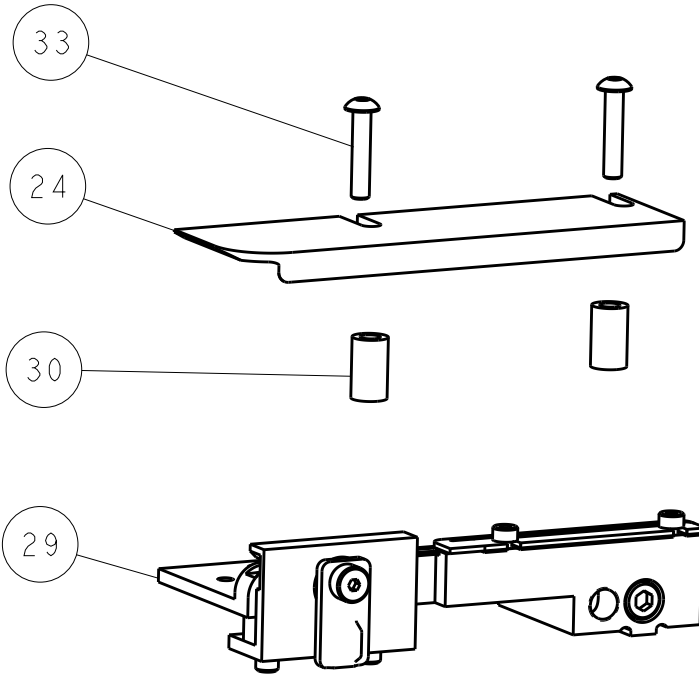
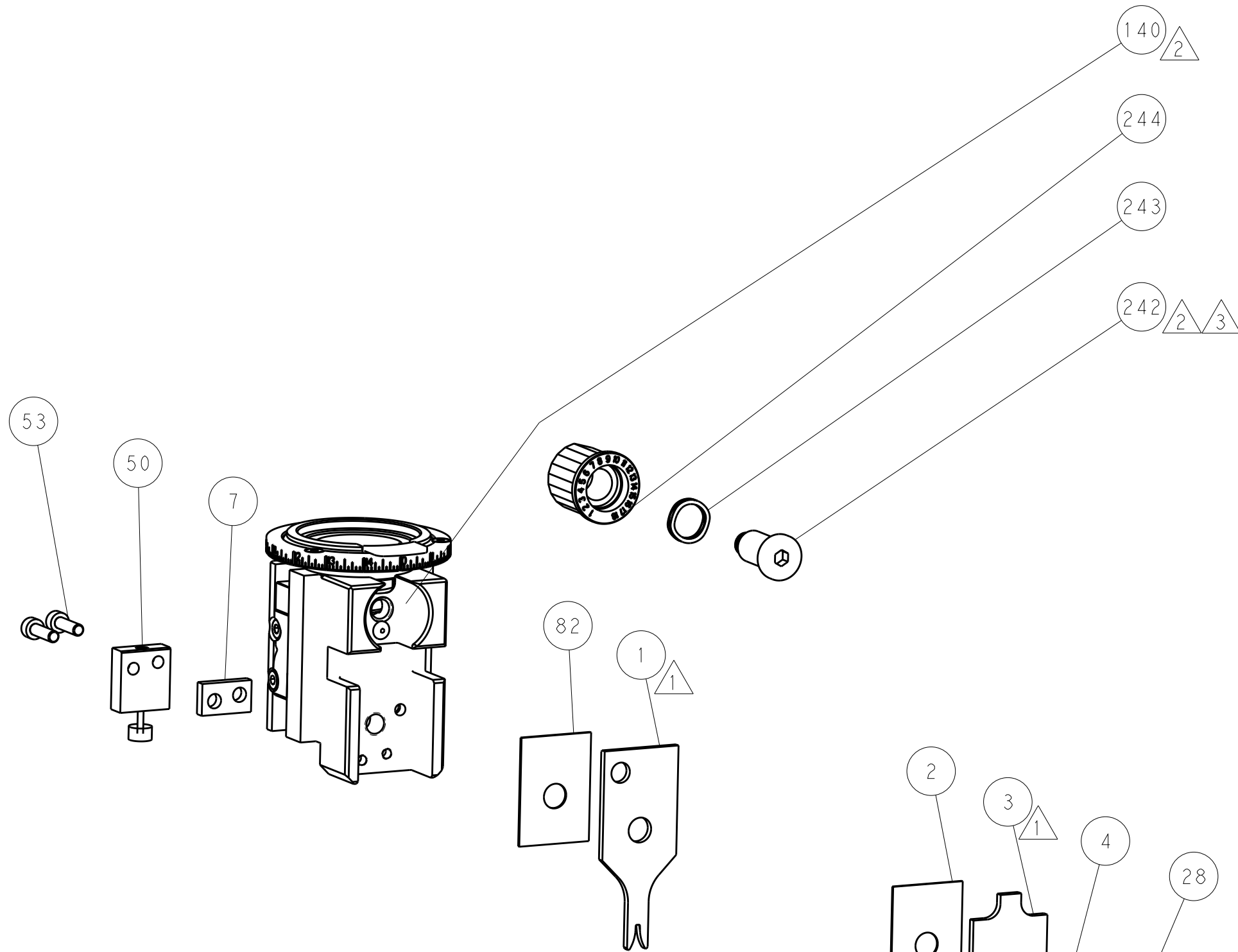
MECHANICAL
POST FEED



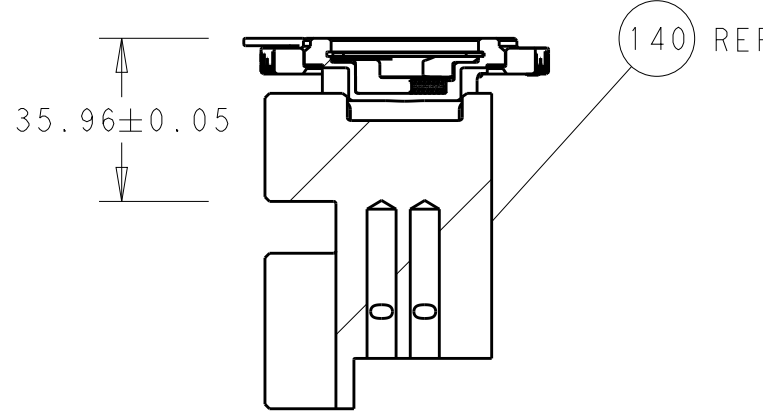
MECHANICAL
PRE FEED



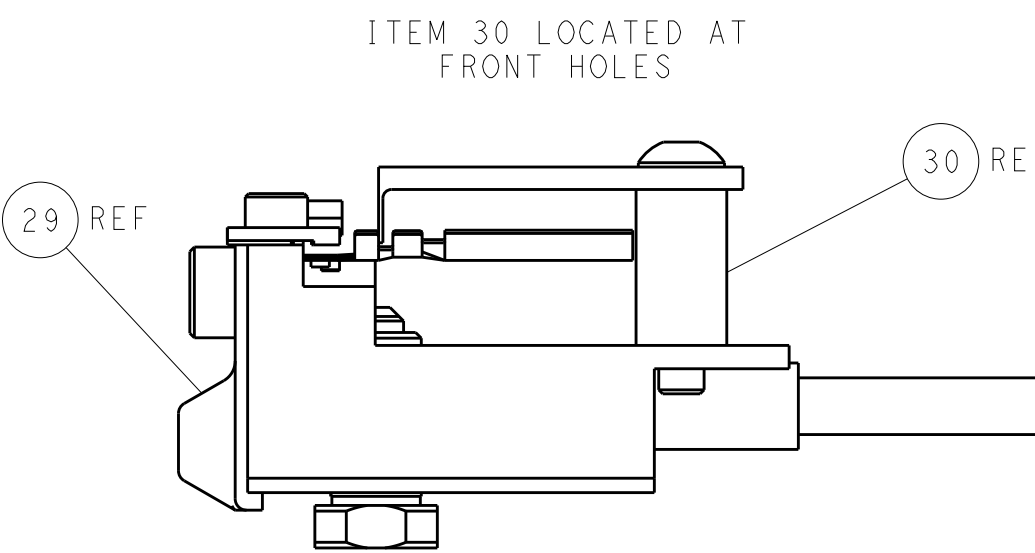
AIR FEED



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)

1ST PUBLISHED BY: COMPANY LOGO FOR THE COMPANY'S CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE COMPANY'S CORPORATION SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN J. HOU 23JULY2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK Y. YIN 23JULY2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD H. GUO 23JULY2014	SIZE A1	
0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		PRODUCT SPEC	CAGE CODE 00779	
MATERIAL		APPLICATION SPEC	DRAWING NO C=2266419	
		WEIGHT	Customer Accessible Production Drawing	
		SCALE 1:2	SHEET 4 OF 4	
		REV C		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION