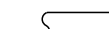


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266485-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266485-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266485-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266485-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266485-7	D	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.00 mm [.118]	F
INSUL	3.05 mm [.120]	F
APPLICATOR INSTRUCTIONS 408-35042		

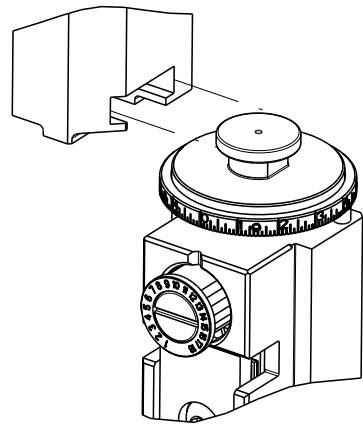
TERMINAL DATA: YAZAKI TERMINAL				YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: 2.3 II (090 II) TERMINAL FEMALE							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
5.00-5.50 mm [.197-.217 IN]				Ø2.90-3.10 mm [.114-.122 IN]			
TERMINAL APPLICATION SPECIFICATION			YAZAKI 7116-4022 Rev		-	-	-
		-			-	-	-
TERMINALS APPLIED 							
TE TERMINAL		YAZAKI TERMINAL		TE TERMINAL		YAZAKI TERMINAL	
1949886-1		7116-4022		1949886-2		7B16-4022	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.40+/-0.05 [.055+/- .002]	8.4



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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)

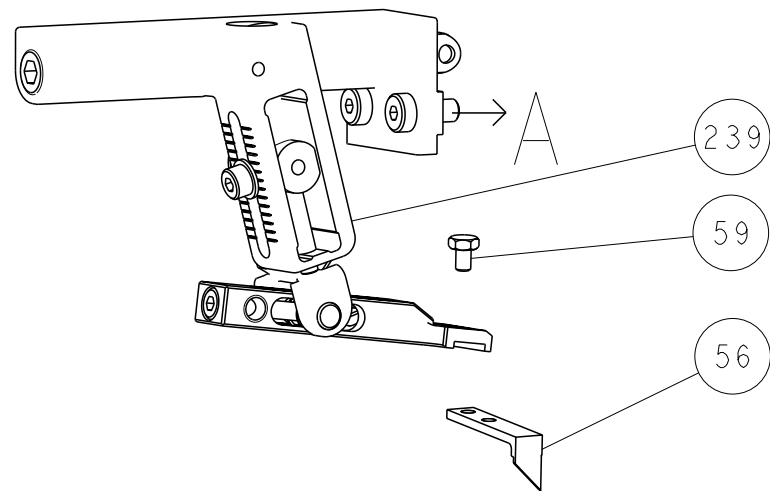
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LOC	DIST	REVISIONS							
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			E	ECR-17-008036			05JUN2017	KH	LZ
			F	ECR-17-011472			08AUG2017	TB	JDG
			G	ECR-18-007144			09MAY2018	VLA	JDG

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	2119082-3	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
5	-	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	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	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	22278-8	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
	-	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	1803382-1	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	1752356-1	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	1-455888-5	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	2	2	1	1	7-1633932-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119780-7	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	5-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1803242-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	2
1	1	2	2	1	1	6-1333281-5	CRIMPER, WIRE PREMIUM	1
-77 -72 -71 -2 -1 PART NO							DESCRIPTION	ITEM NO

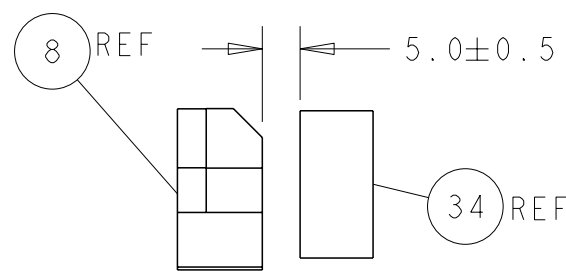
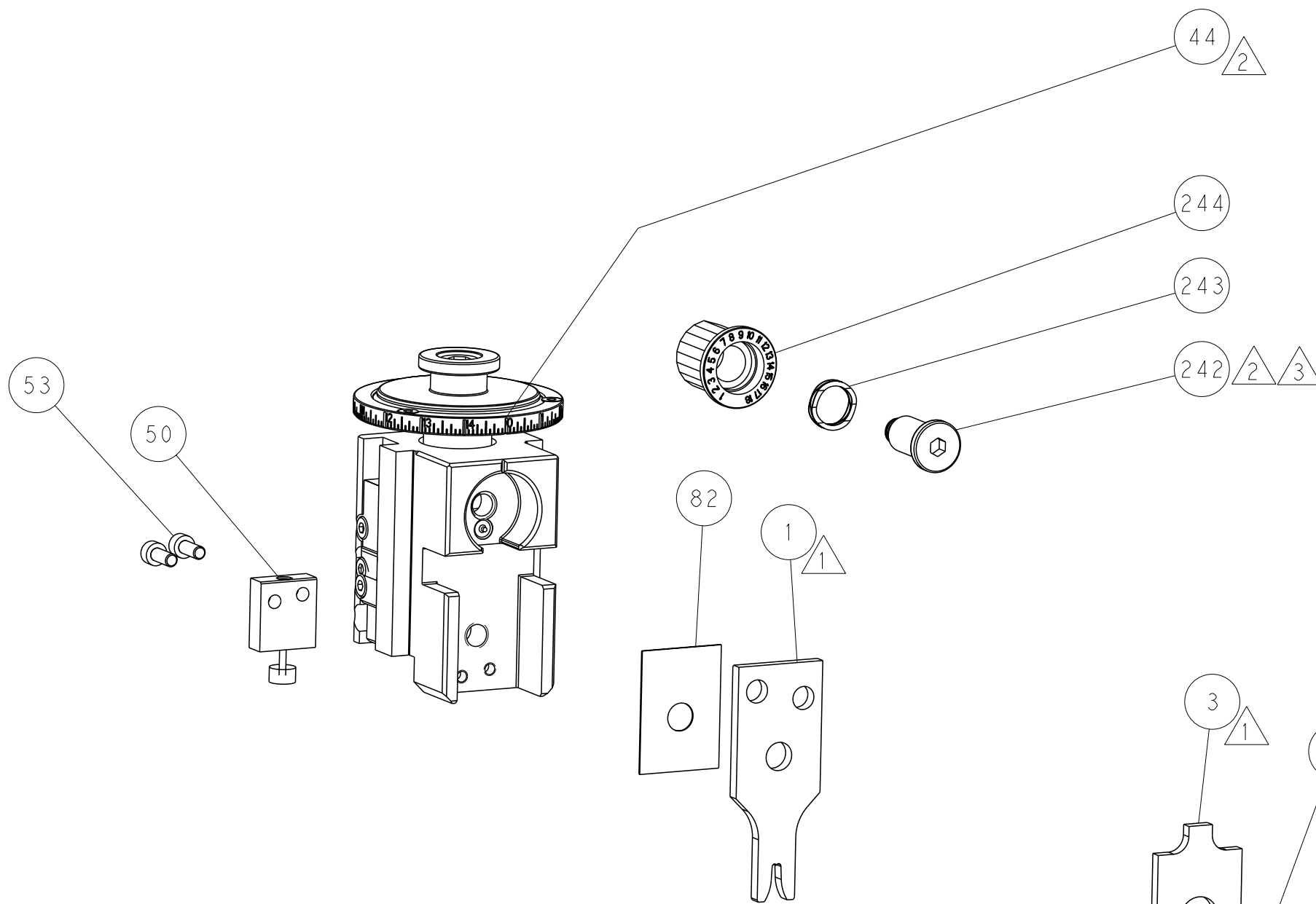
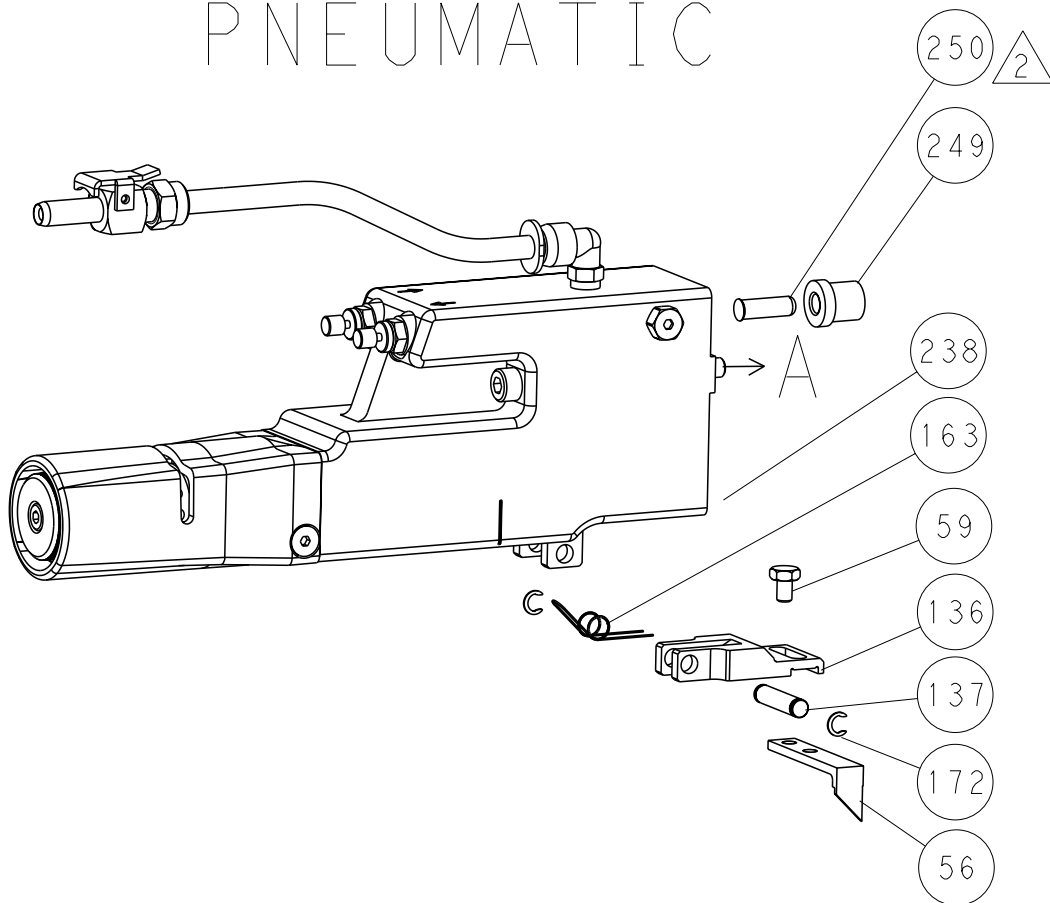
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	J. HOW	29AUGUST2014	 TE Connectivity Harrisburg, PA 17105-3608				
DIMENSIONS:				CHK	Y. YIN	29AUGUST2014	NAME				
mm				APVD	U. GUO	29AUGUST2014	Ocean Side Feed Applicator				
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC		SIZE					
0 PLC ±				APPLICATION SPEC		CAGE CODE					
1 PLC ±				FINISH		DRAWING NO					
2 PLC ±				MATERIAL		RESTRICTED TO					
3 PLC ±				WEIGHT		00779					
4 PLC ±				Customer Accessible Production Drawing		©=2266485					
ANGLES				SCALE		1:2					
FINISH				SHEET		1 of 4					
-				REV		G					

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

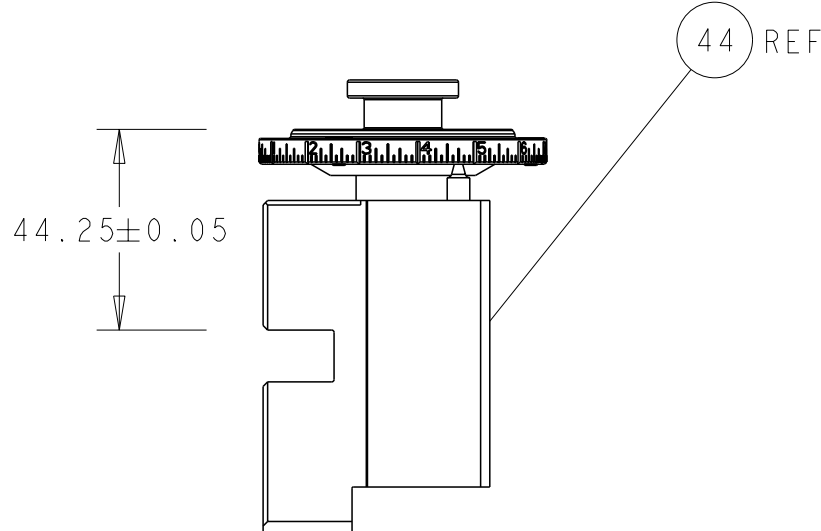
FEED TYPE
MECHANICAL



PNEUMATIC

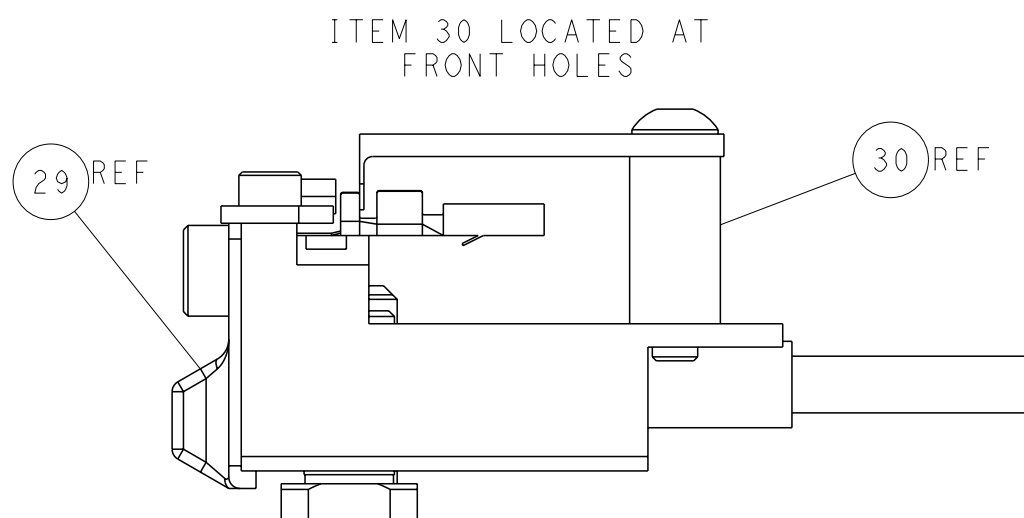
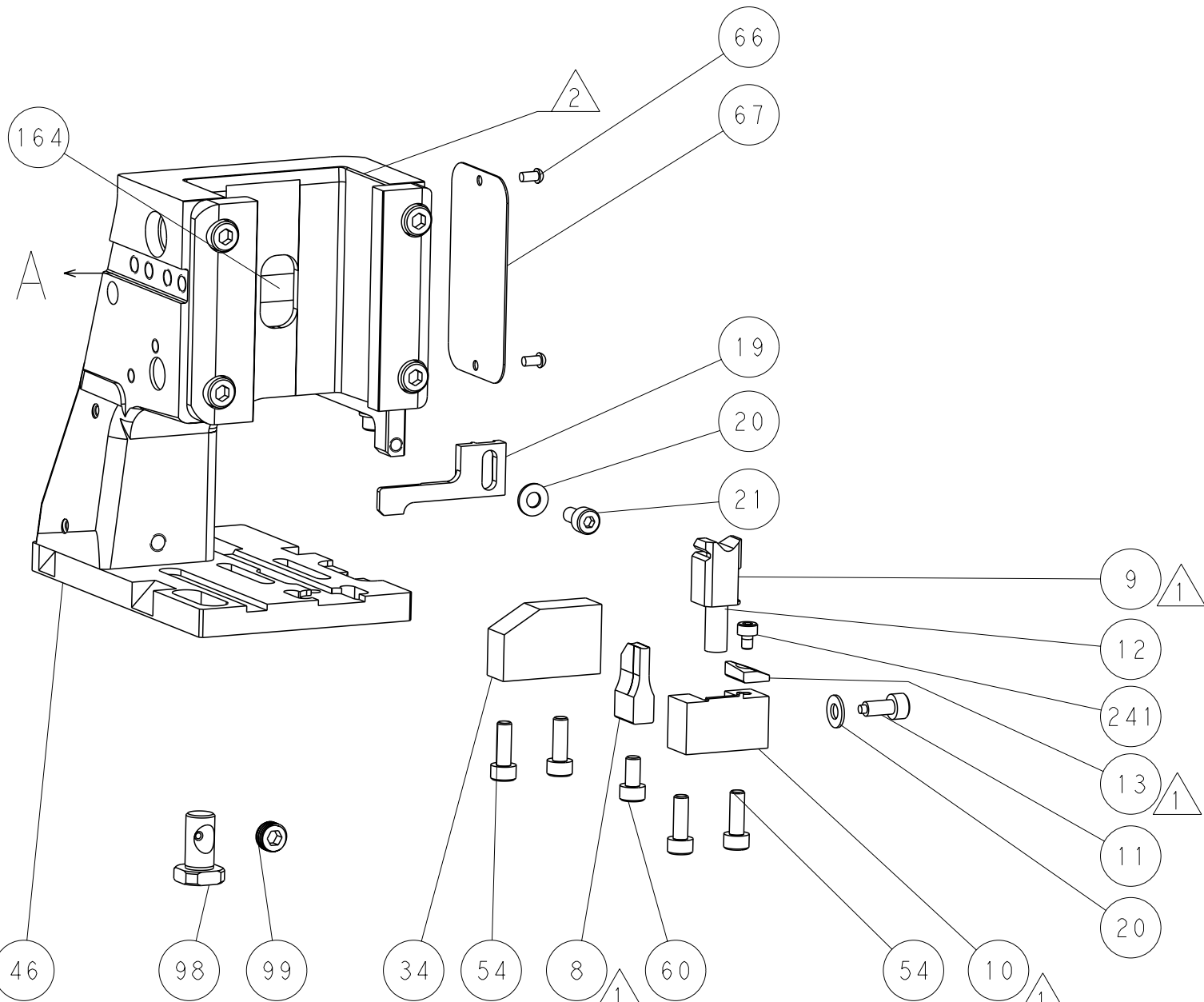
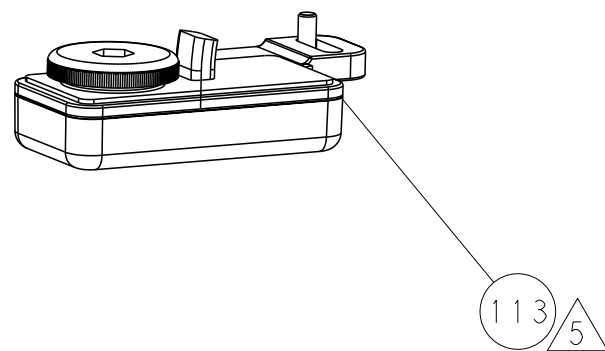
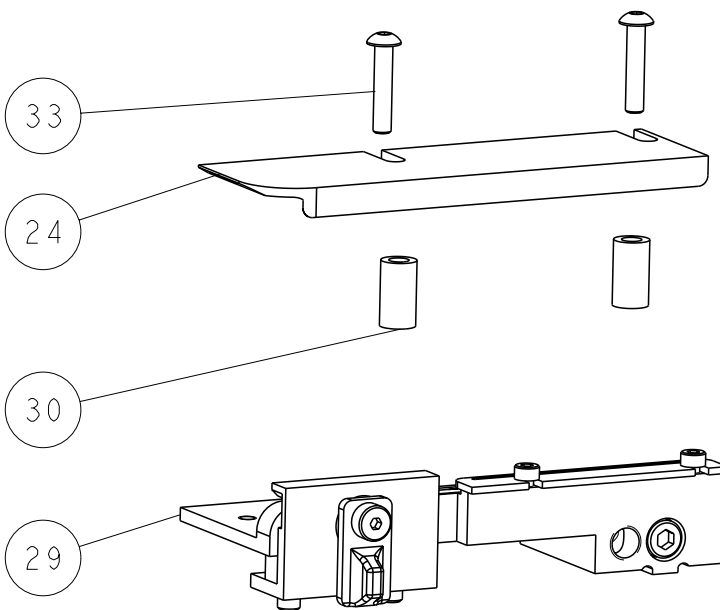
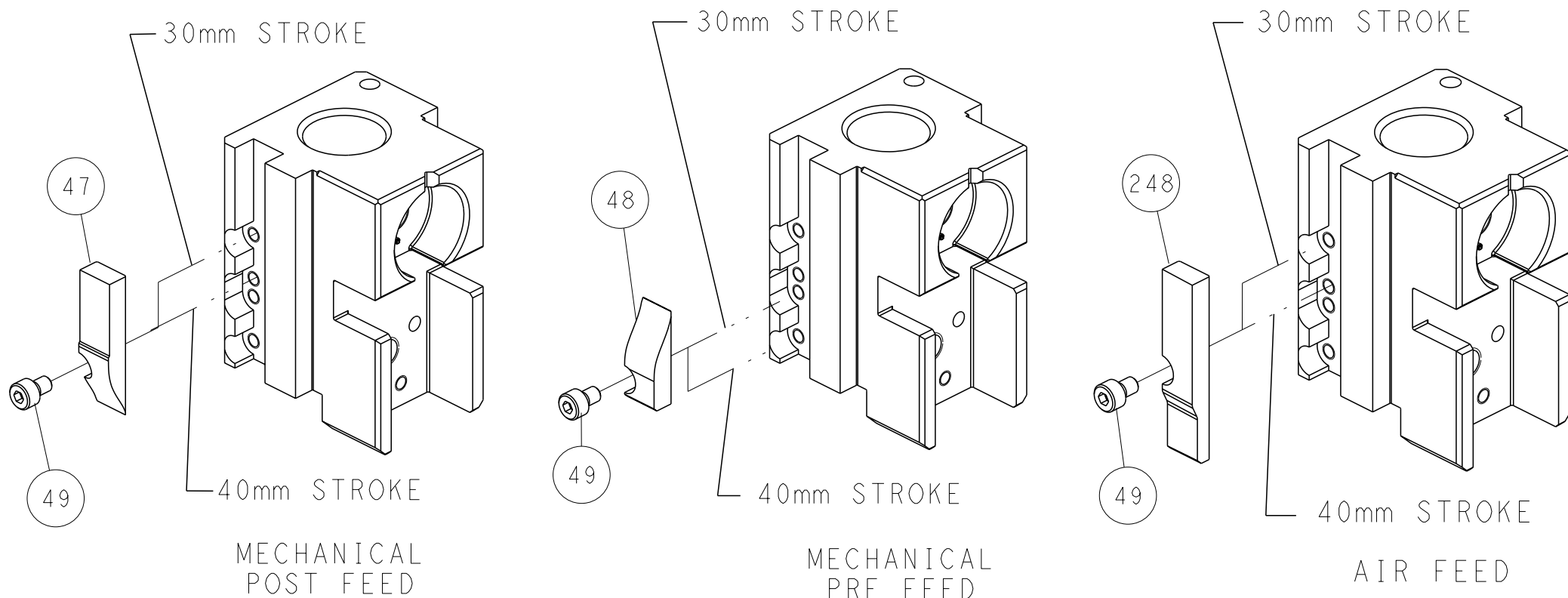


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITIONS



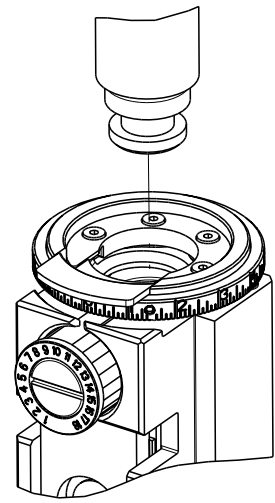
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

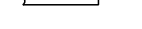
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HOW 29AUGUST2014		TE Connectivity	
mm		0 PLC ±		CHK Y. YIN 29AUGUST2014		Harrisburg, PA 17105-3608	
FINISH		1 PLC ±		APVD U. GUO 29AUGUST2014		NAME Ocean Side Feed Applicator	
MATERIAL		2 PLC ±		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
		3 PLC ±		APPLICATION SPEC		A1 00779 C=2266485	
		4 PLC ±		WEIGHT		RESTRICTED TO	
		ANGLES		Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 of 4 REV G	

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266485-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266485-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266485-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.00 mm [.118]	F
INSUL	3.05 mm [.120]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL		YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: 2.3 II (090 II) TERMINAL FEMALE			
WIRE STRIP LENGTH 5.00-5.50 mm [.197-.217 IN]			INSULATION DIAMETER RANGE Ø2.90-3.10 mm [.114-.122 IN]
TERMINAL APPLICATION SPECIFICATION	YAZAKI 7116-4022 Rev	-	-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1949886-1	7116-4022	1949886-2	7B16-4022

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 4
2.00mm2		1.40+/-0.05 [.055+/-0.02]		8.4



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
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.

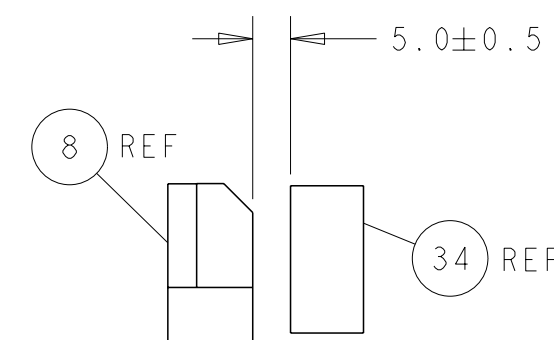
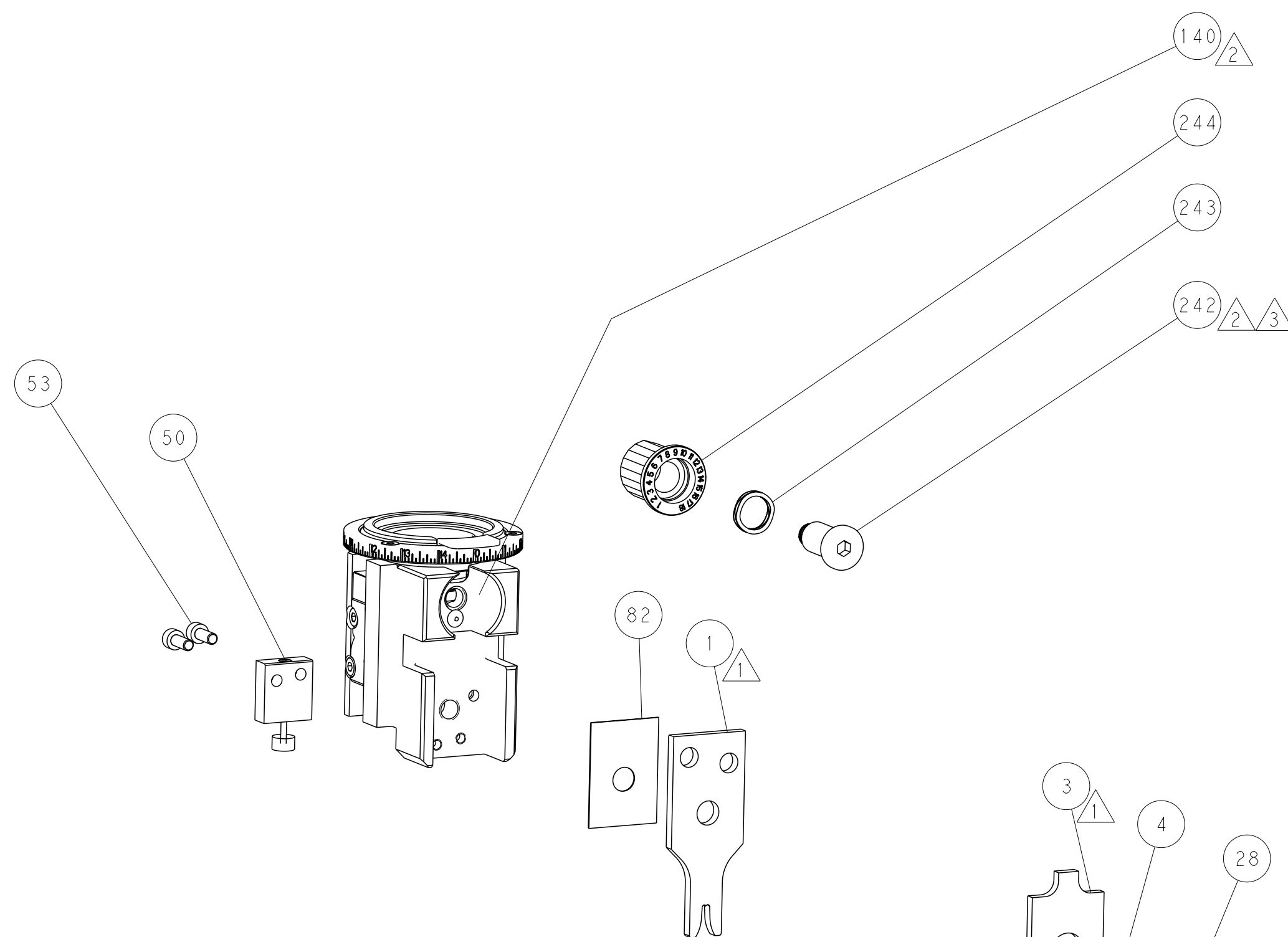
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

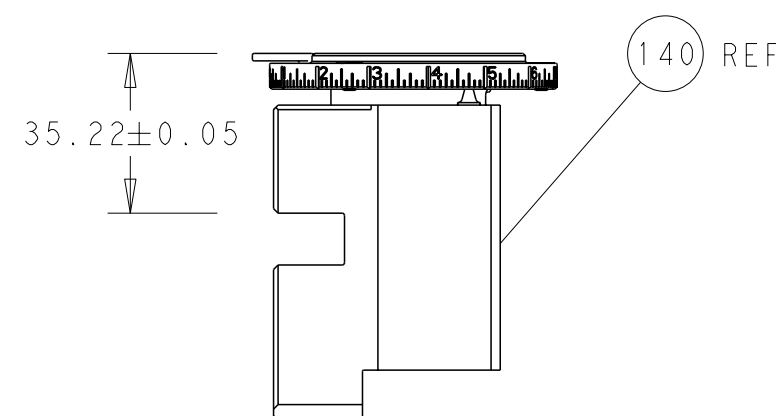
3	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2063440-1	AIR FEED MODULE	238
	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
1	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	22278-8	SPRING, COMPRESSION	77
	-	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	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	1	1338685-1	PAWL, FEED	56
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752356-1	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	1	1-455888-5	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	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1	1	7-1633932-5	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119780-7	DEPRESSOR, SHEAR	5
	-	1	1	5-238011-2	BLOCK, CRIMPER SPACER	4
	1	1	1	1803242-1	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	2
	1	1	1	6-1333281-5	CRIMPER, WIRE PREMIUM	1
	-77	-22	21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE REASON THAT IT CONTAINS INFORMATION THAT IS SUBJECT TO CHANGE AND TO CONTROL THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN J. HOW 29AUGUST2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK Y. YIN 29AUGUST2014	NAME Ocean Side Feed Applicator	
		APVD U. GUO 29AUGUST2014	PRODUCT SPEC	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APPLICATION SPEC		SIZE A1
MATERIAL -		WEIGHT -		
FINISH -		Customer Accessible Production Drawing		SCALE 1:2
		SHEET 3		OF 4
		REV G		

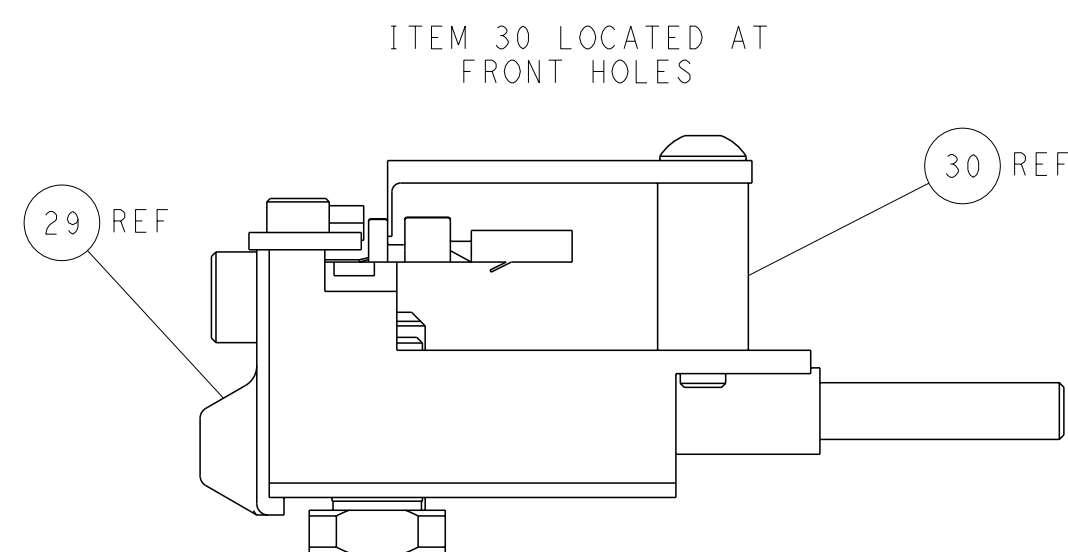
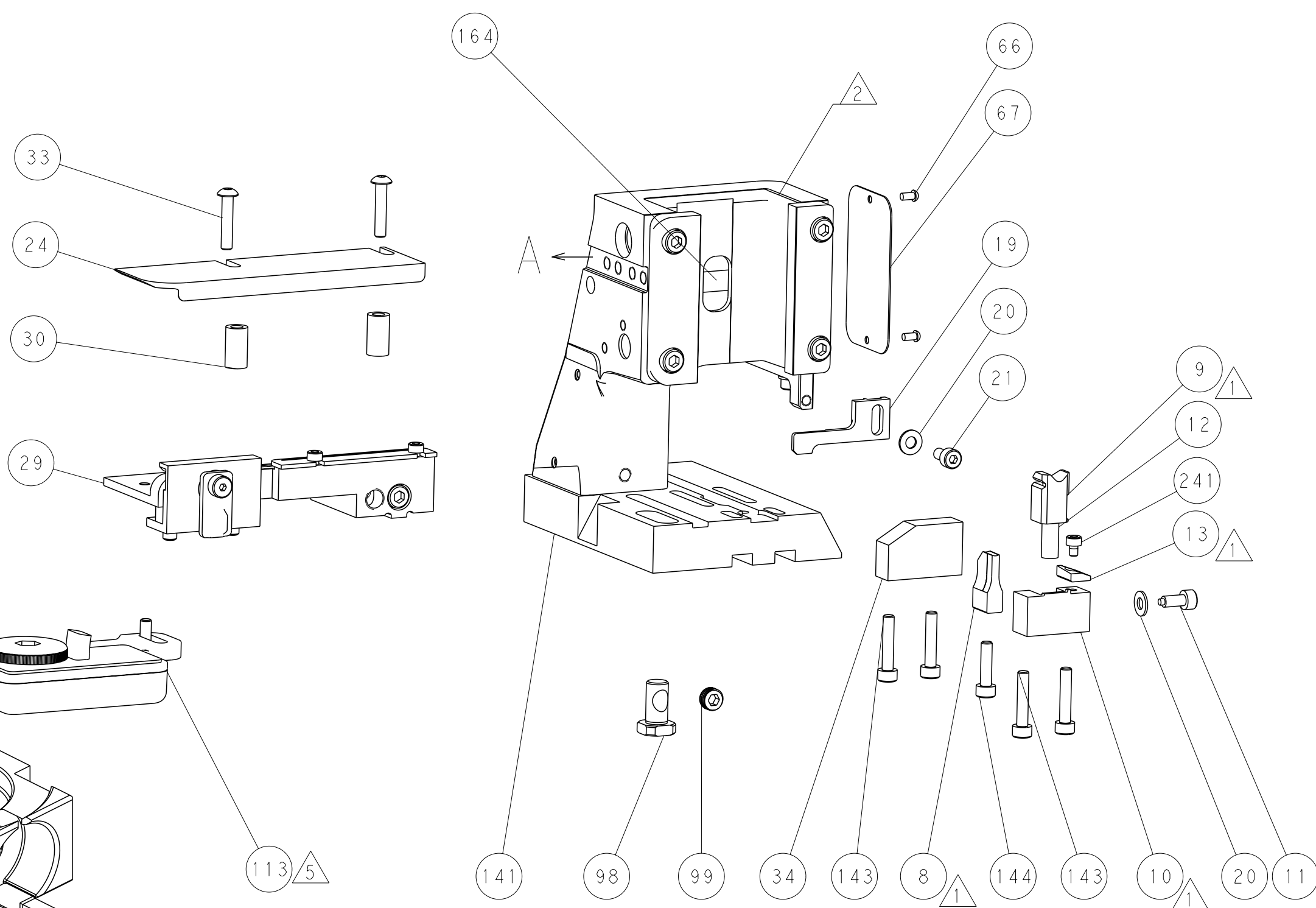
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

MECHANICAL PRE FEED

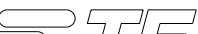
30mm STROKE

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 CONTROLLED DOCUMENT FOR TWO ELECTRIFIED CORPORATION 17115 DODD RD. HARRISBURG, PA 17105-3608 FOR CONTRACT AND MANUFACTURING INFORMATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 29AUGUST2014 CHK J. HOW 29AUGUST2014 U. LIN 29AUGUST2014 APVD U. GUO 29AUGUST2014		TE Connectivity Harrisburg, PA 17105-3608 	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator -	
MATERIAL FINISH - -		PRODUCT SPEC - APPLICATION SPEC - WEIGHT -		SIZE A 00779	
				DRAWING NO C=2266485	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 of 4 REV G	