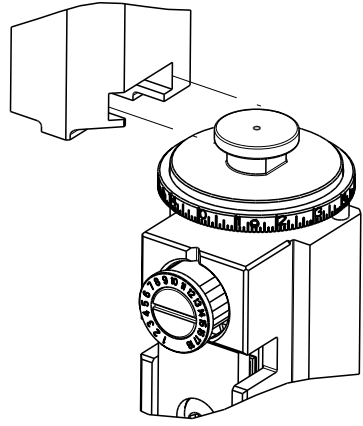
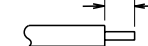


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266572-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266572-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266572-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266572-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266572-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.54 mm [.061]	F
INSUL	3.40 mm [.134]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: MX150 CABLE SEAL TERMINAL			
WIRE STRIP LENGTH 4.70-5.60 mm [.185-.220 IN]		 INSULATION DIAMETER RANGE Ø1.50-1.70 mm [.059-.067 IN]	
TERMINAL APPLICATION SPECIFICATION  ATS639018200 Rev B		-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE SEAL	MOLEX SEAL
1949235-1	34081-3005	2113614-1	E-1644-01
1949235-2	34083-3003		
1949235-3	34081-5003		
1949235-4	FORD 7C3T-14474-RA		

SEAL INSULATION DIAMETER RANGE
1.4-1.7 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.10+/-0.05 [.043+/- .002]	7.2
TXL 22 AWG	1.00+/-0.05 [.039+/- .002]	8.3



- 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 TORO-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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			A	RELEASED	31DEC2014	MR	GB
			B	ECR-19-012035	31JUL2019	FZ	TE

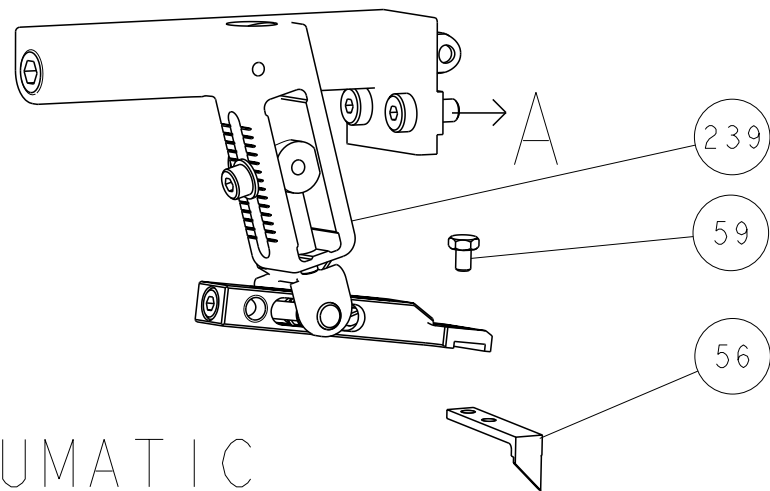
	-	1	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED 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
5	-	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	3-1752356-4	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1	1	240792-1	DRAG, TERMINAL	25
	-	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	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	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	3-1803056-2	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	2-1633965-7	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	2	2	1	1	8-1633738-2	CRIMPER, WIRE	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSES FOR WHICH IT WAS DESIGNED. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM TYCO ELECTRONICS CORPORATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN R. HUANG	13NOV2014	TE Connectivity Harrisburg, PA 17105-3608					
DIMENSIONS:				CHK L. ZHANG	13NOV2014	NAME Ocean Side Feed Applicator					
mm				APVD J. GUO	13NOV2014	PRODUCT SPEC APPLICATION SPEC SIZE A 00779 C=2266572 Customer Accessible Production Drawing					
TOLERANCES UNLESS OTHERWISE SPECIFIED:				RESTRICTED TO							
0 PLC ±				-							
1 PLC ±				-							
2 PLC ±				-							
3 PLC ±				-							
4 PLC ±				-							
ANGLES				FINISH							
-				-							
MATERIAL				WEIGHT							
-				-							
Customer Accessible Production Drawing				SCALE 1:2							
SHEET 1				OF 4							
REV B											

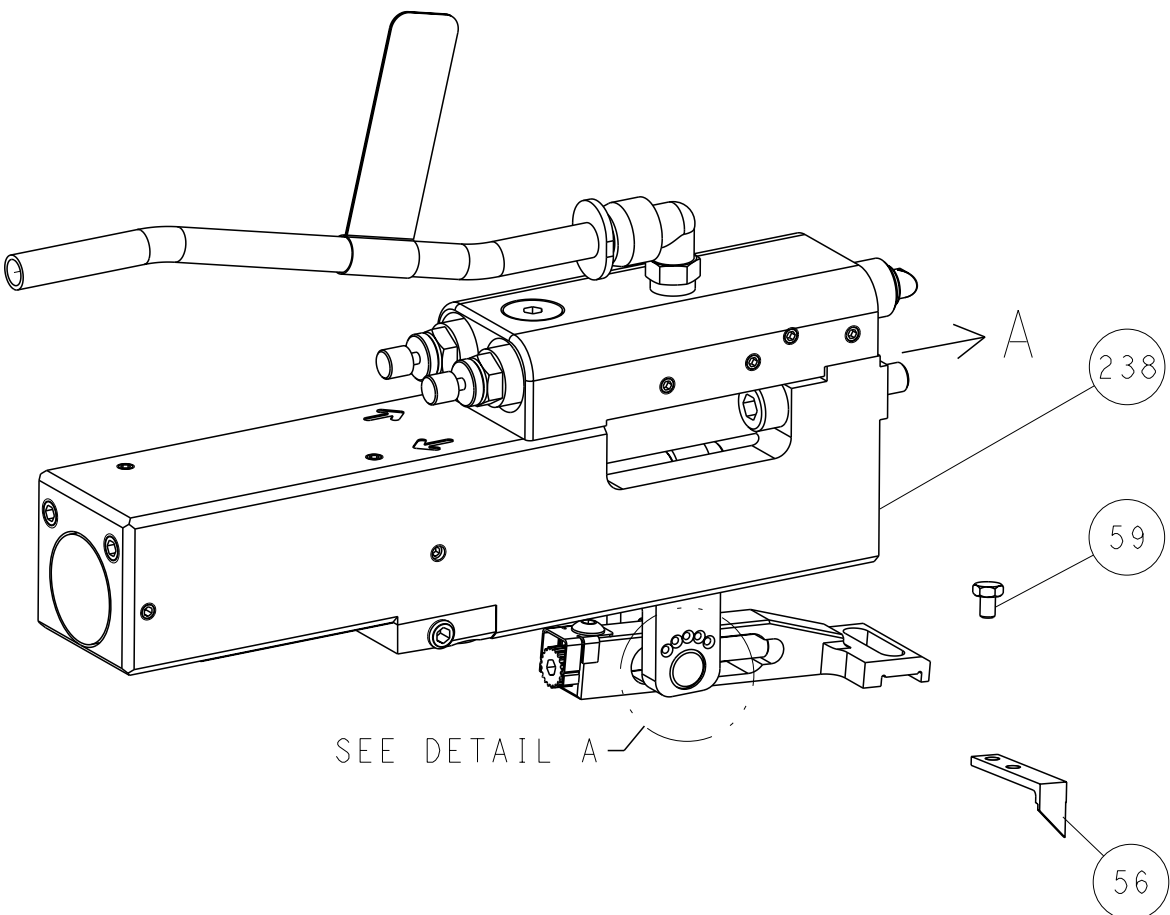
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

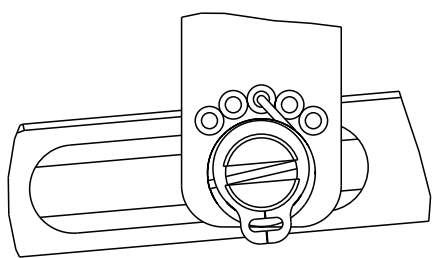
FEED TYPE MECHANICAL



PNEUMATIC

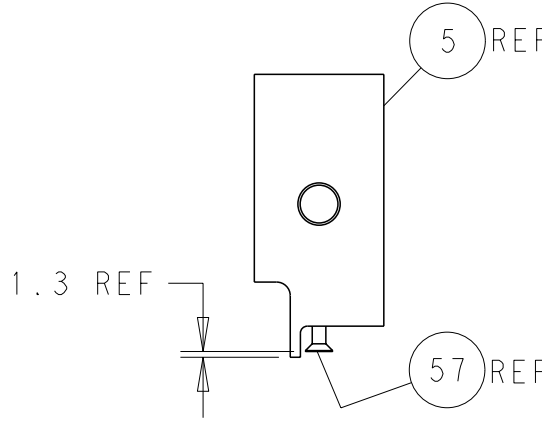
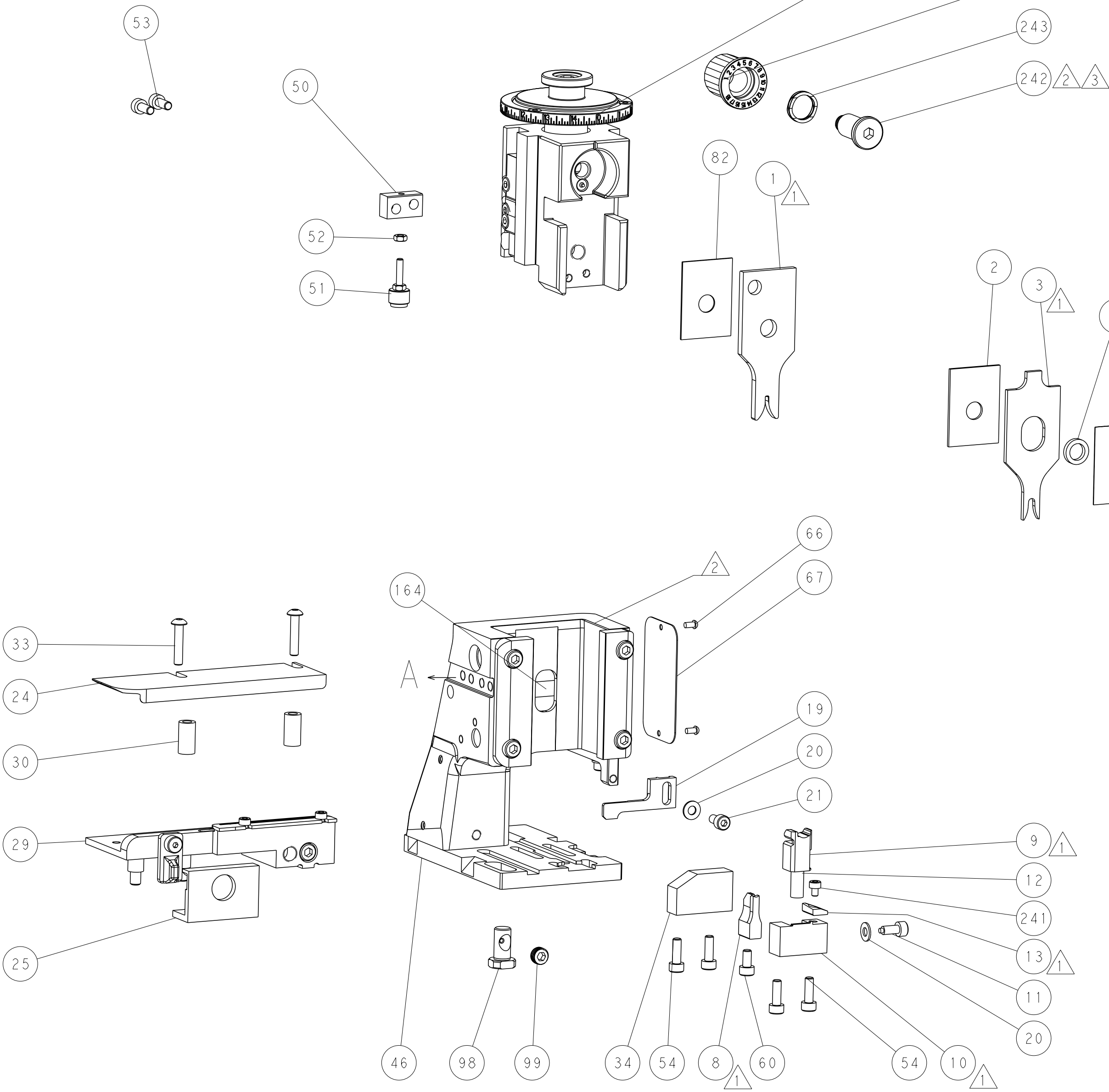
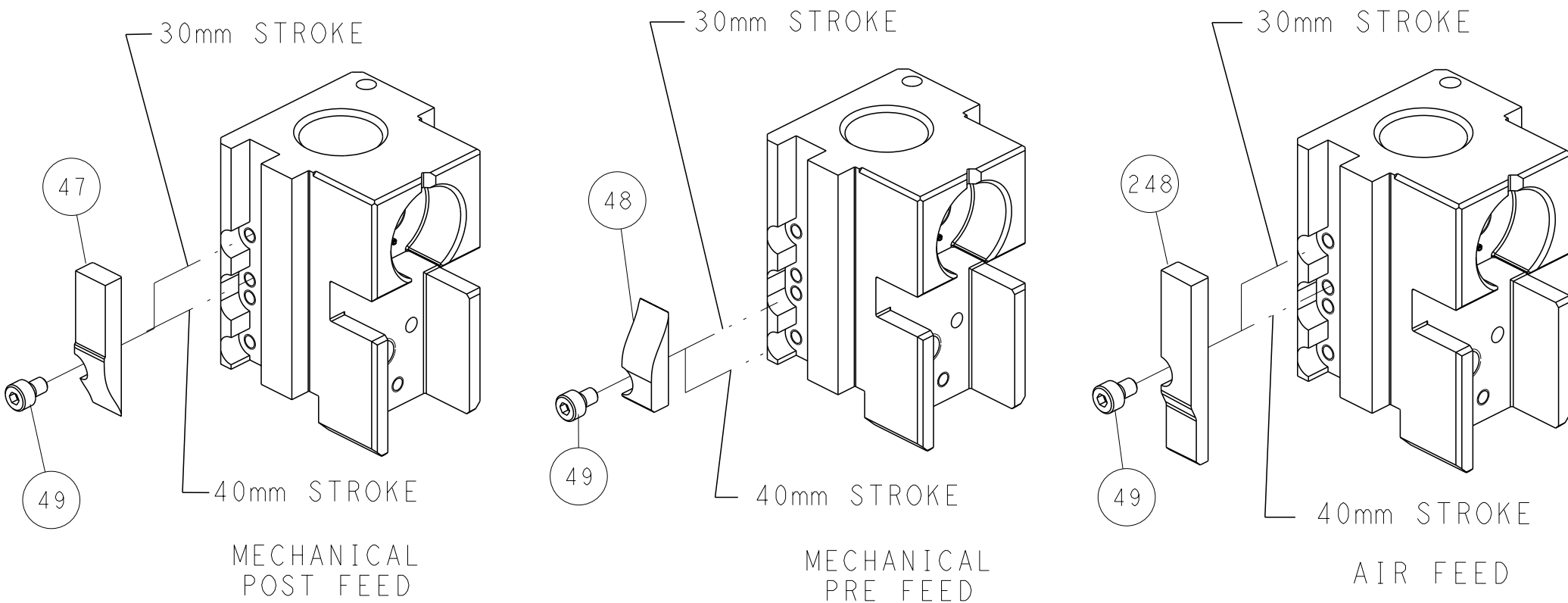


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

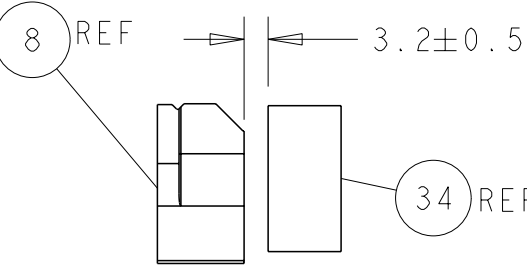


DETAIL A

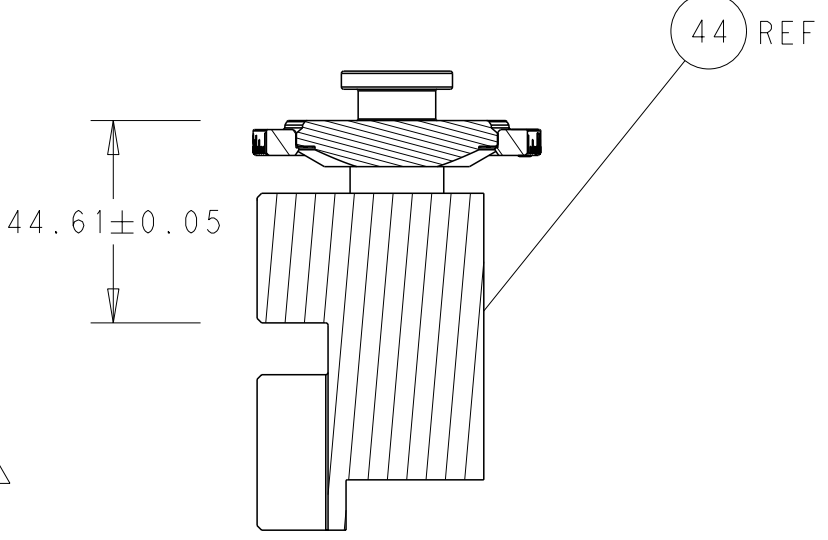
CAM POSITIONS



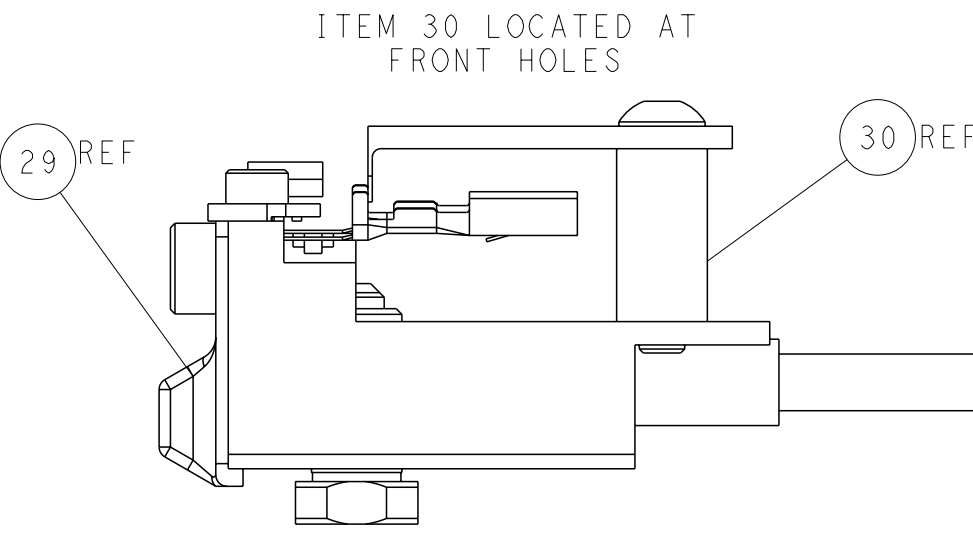
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



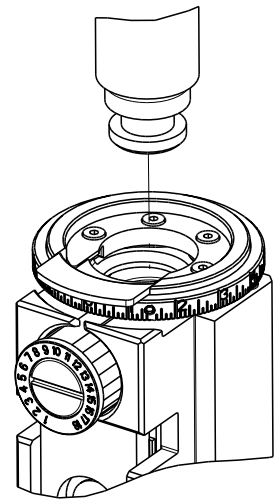
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

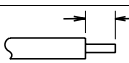
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG 13NOV2014	TE Connectivity Harrisburg, PA 17105-3608	
				CHK L. ZHANG 13NOV2014		
				APVD J. GUO 13NOV2014	NAME Ocean Side Feed Applicator	
				PRODUCT SPEC		
				APPLICATION SPEC		
				WEIGHT		
				SCALE	1:2	
				SHEET	2 of 4	
				REV	B	

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266572-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266572-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266572-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.54 mm [.061]	F
INSUL	3.40 mm [.134]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL				MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: MX150 CABLE SEAL TERMINAL					
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE		
4.70-5.60 mm [.185-.220 IN]			Ø1.50-1.70 mm [.059-.067 IN]		
TERMINAL APPLICATION SPECIFICATION			ATS639018200 Rev B		
TERMINALS APPLIED					
TE TERMINAL		MOLEX TERMINAL		TE SEAL	MOLEX SEAL
1949235-1		34081-3005		2113614-1	E-1644-01
1949235-2		34083-3003			
1949235-3		34081-5003			
1949235-4		FORD 7C3T-14474-RA			
SEAL INSULATION DIAMETER RANGE					
1.4-1.7 mm					
WIRE SIZE			CRIMP HEIGHT mm [INCH]		
0.50mm ²			1.10+/-0.05 [.043+/-0.002]		7.2
TXL 22 AWG			1.00+/-0.05 [.039+/-0.002]		8.3
			CRIMP HEIGHT REFERENCE SETTING		



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)

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

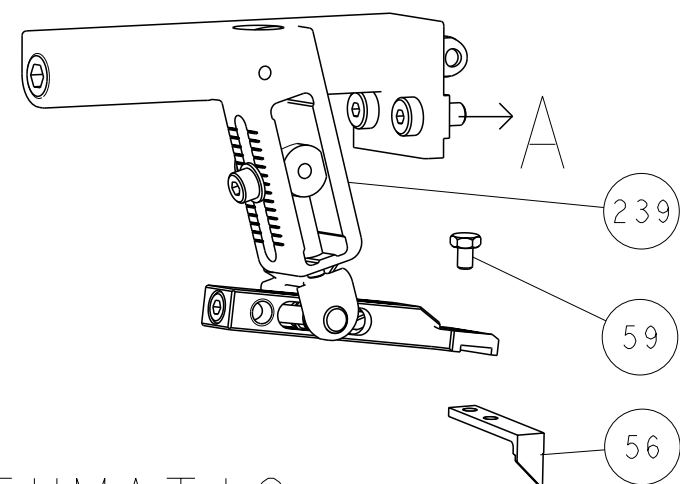
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	455888-6	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	3-1752356-4	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	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	240792-1	DRAG, TERMINAL	25
-	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	3-1803056-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	2-1633965-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	1	8-1633738-2	CRIMPER, WIRE	1

THIS DRAWING IS CONTROLLED DOCUMENT FOR YOUR FACILITY. CONTINUING REVISIONS TO THIS DRAWING WILL BE CONTROLLED BY THE ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN R. HUANG	13NOV2014	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG	13NOV2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD J. GUO	13NOV2014	PRODUCT SPEC	
MATERIAL -		APPLICATION SPEC		SIZE A1	
FINISH -		WEIGHT -		CAGE CODE 00779	
Customer Accessible Production Drawing		SCALE 1:2		DRAWING NO C=2266572	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 3	
Customer Accessible Production Drawing		SCALE 1:2		REV B	

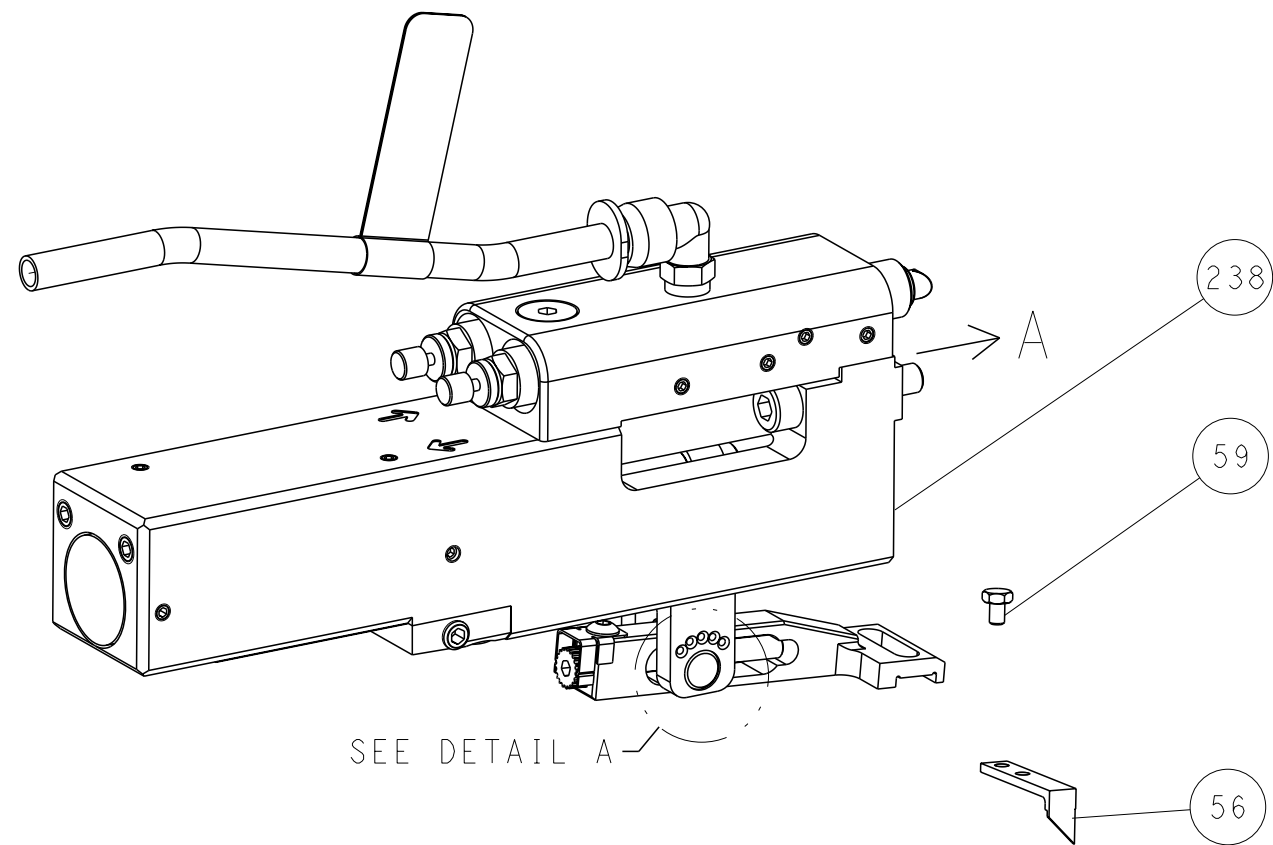
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

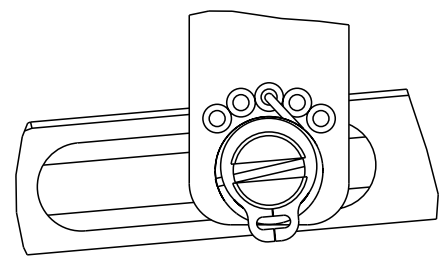
FEED TYPE MECHANICAL



PNEUMATIC

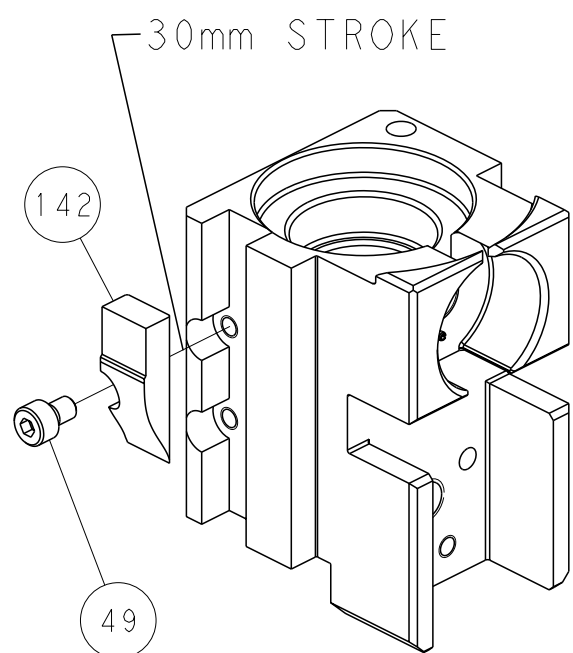


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

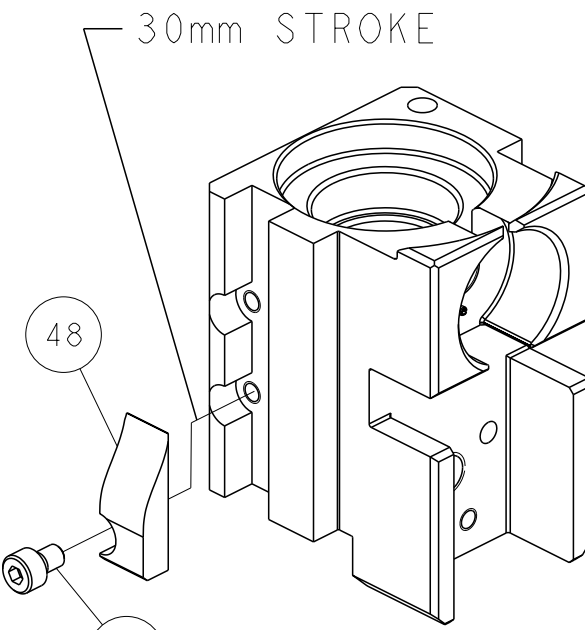


DETAIL A

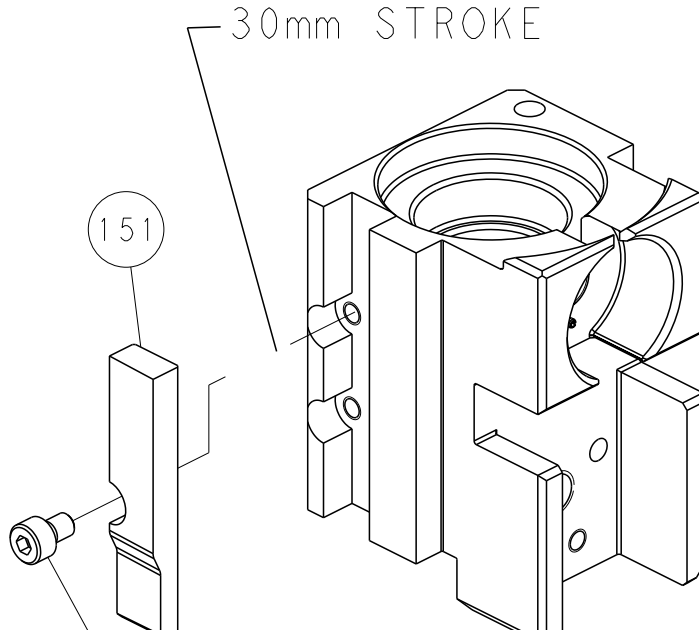
CAM POSITIONS



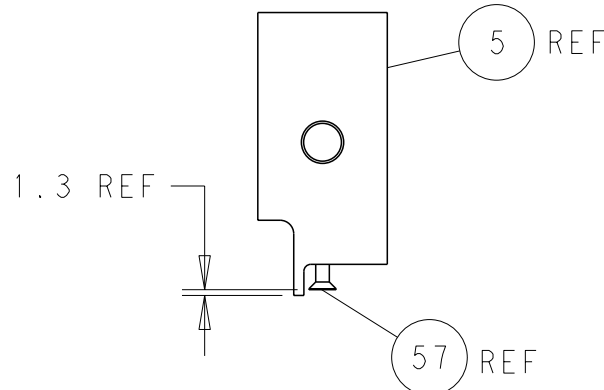
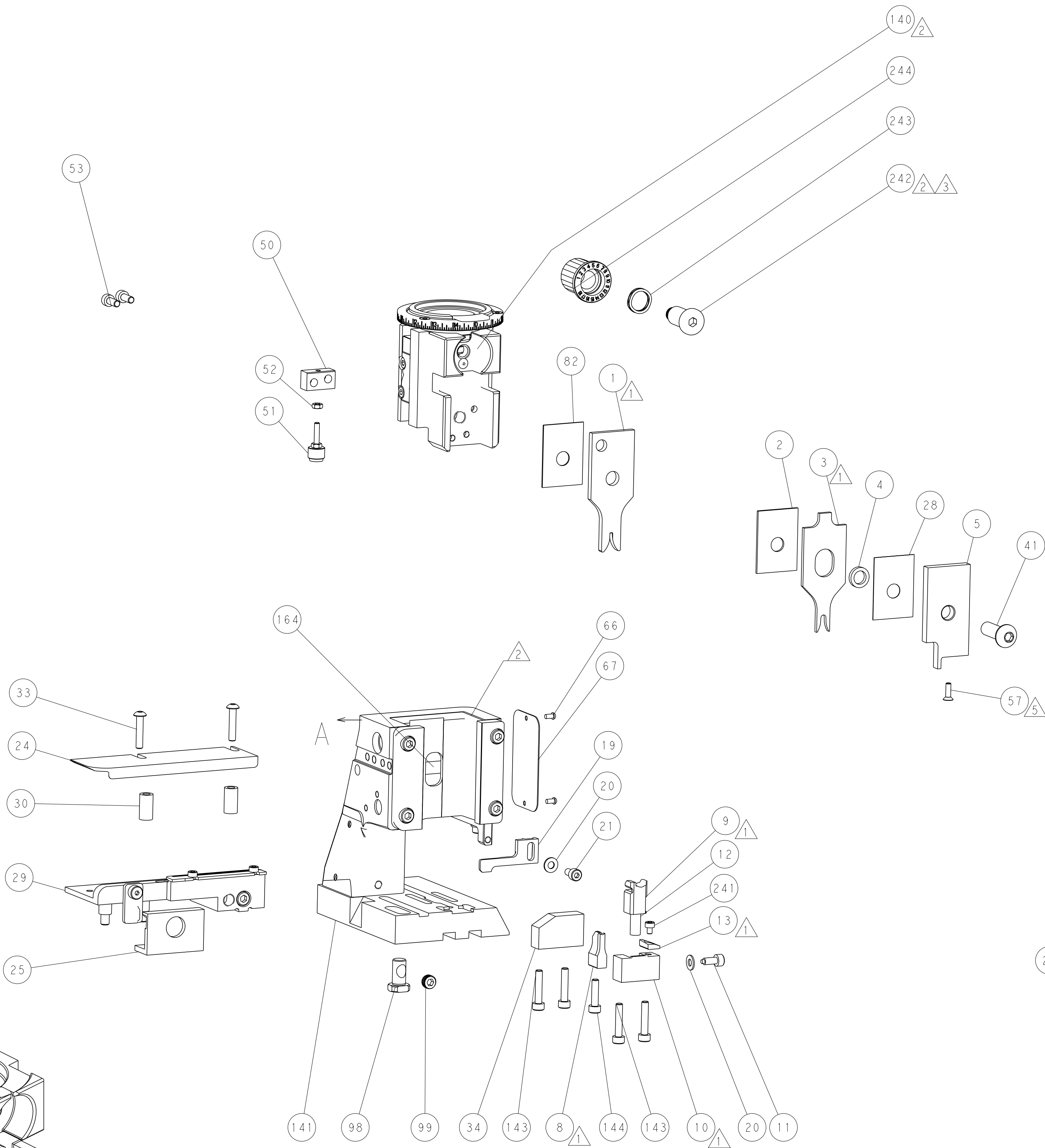
MECHANICAL
POST FEED



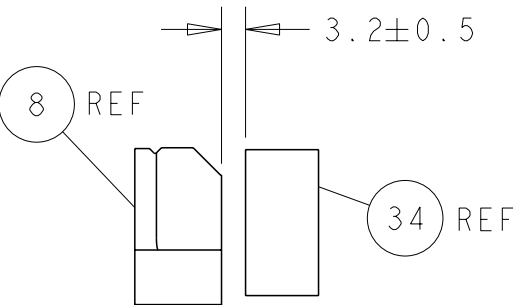
MECHANICAL
PRE FEED



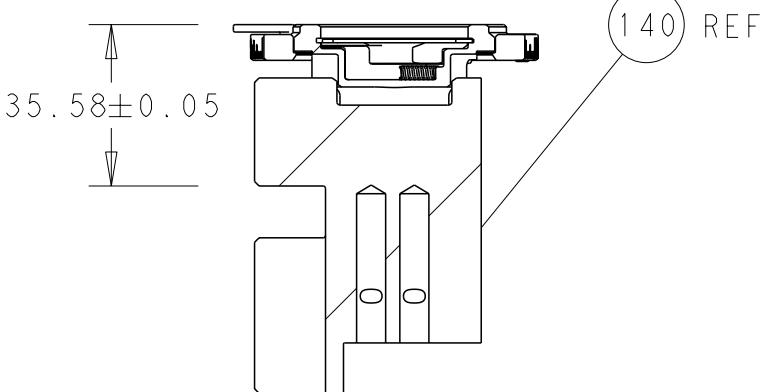
AIR FEED



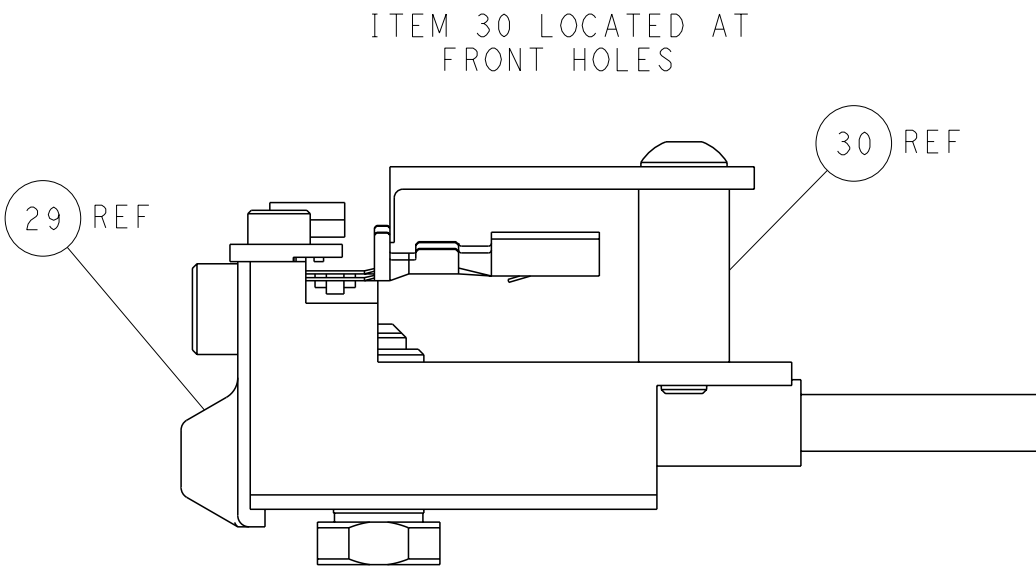
SHEAR DEPRESSOR DETAIL



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG CHK L. ZHANG APVD U. GUO	13NOV2014 13NOV2014 13NOV2014	NAME Ocean Side Feed Applicator	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE A1	
0 PLC ±		1 PLC ±		APPLICATION SPEC		CAGE CODE 00779	
2 PLC ±		3 PLC ±		WEIGHT		DRAWING NO C=2266572	
4 PLC ±		ANGLES ±		FINISH		RESTRICTED TO	
MATERIAL		SCALE		SHEET		REV	
-		1:2		4		B	
Customer Accessible Production Drawing		Customer Accessible Production Drawing		Customer Accessible Production Drawing		Customer Accessible Production Drawing	