

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266496-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266496-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266496-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266496-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266496-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.09 mm [.043]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: EMIX CONN., 1.5mm PITCH TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.05-1.54 mm [.041-.061 IN]		Ø0.90-1.15 mm [.035-.045 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-639014200 Rev D		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949551-1	87421-0000	1949551-2	87421-0002

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG OR 0.20mm2	0.58+/- .02 [.023+/- .001]	6.7
26 AWG OR 0.12mm2	0.55+/- .03 [.022+/- .001]	7.2
28 AWG OR 0.08mm2	0.55+/- .03 [.022+/- .001]	7.2
30 AWG OR 0.05mm2	0.55+/- .03 [.022+/- .001]	7.2

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.

**\*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)

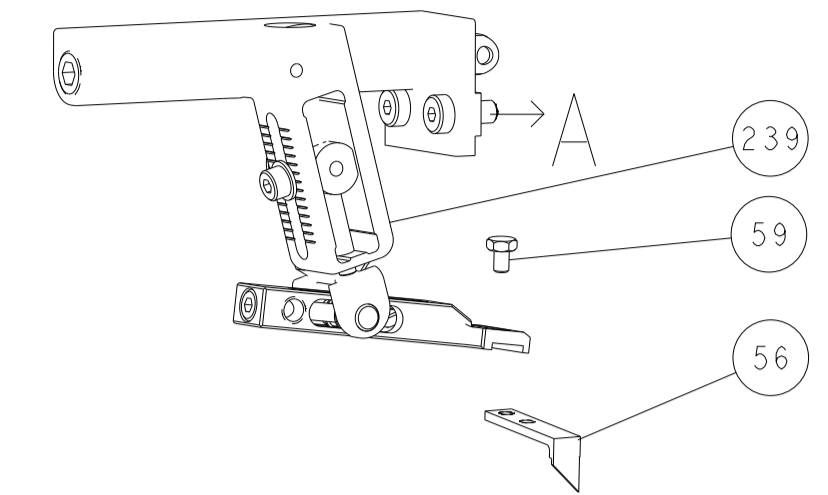
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		F		ECR-19-003138	26FEB2019	TB	CT
		G		ECR-19-012465	07AUG2019	MEH	GB
		G1		ECR-22-150434	25AUG2022	FJ	YY

-	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	2119082-4	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	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230	
-	1	1	1	1	1-1752354-4	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	1-1633764-7	HOLD DOWN, TERMINAL	179	
-	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	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	
-	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	1-455888-8	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1	1	1901681-8	HOLDDOWN, TERMINAL	51	
-	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	2-1752356-5	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	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	2119533-3	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	7-1803249-7	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-6	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	9-1633962-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
-	1	2	2	1	1	1633609-2	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO	

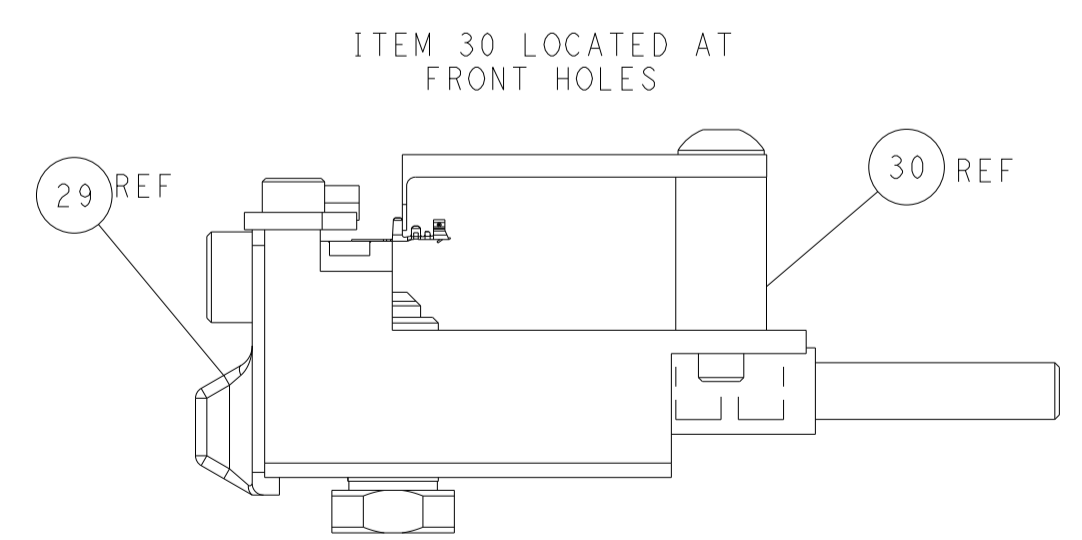
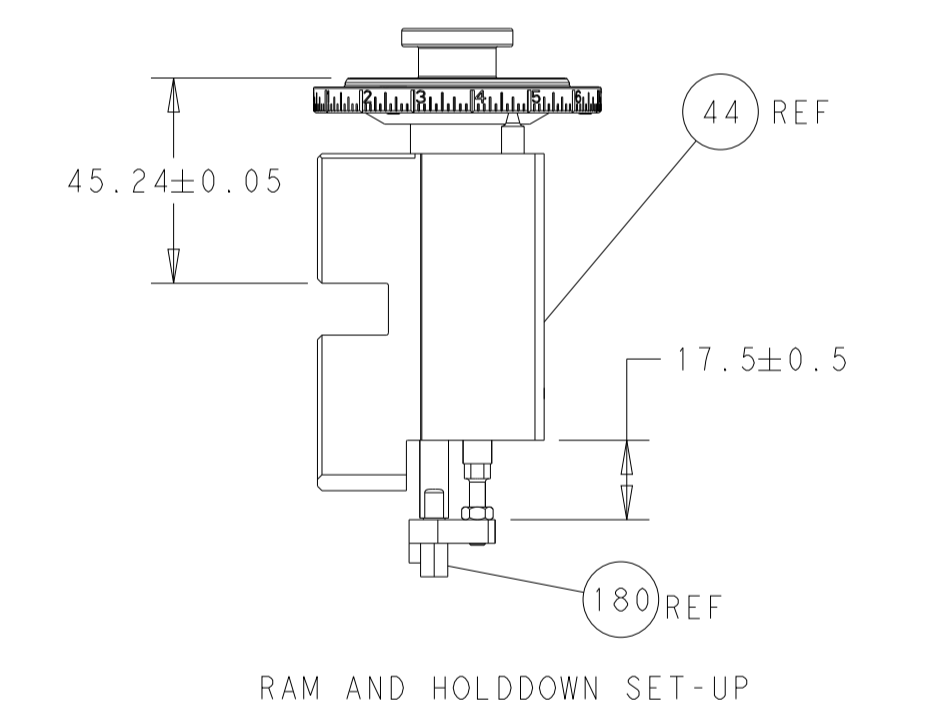
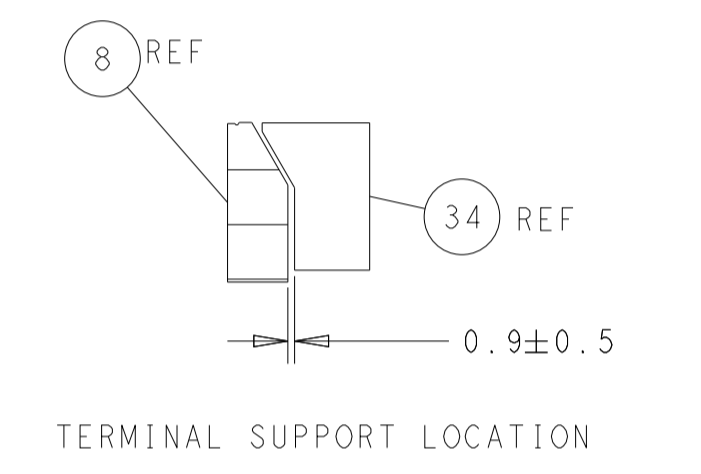
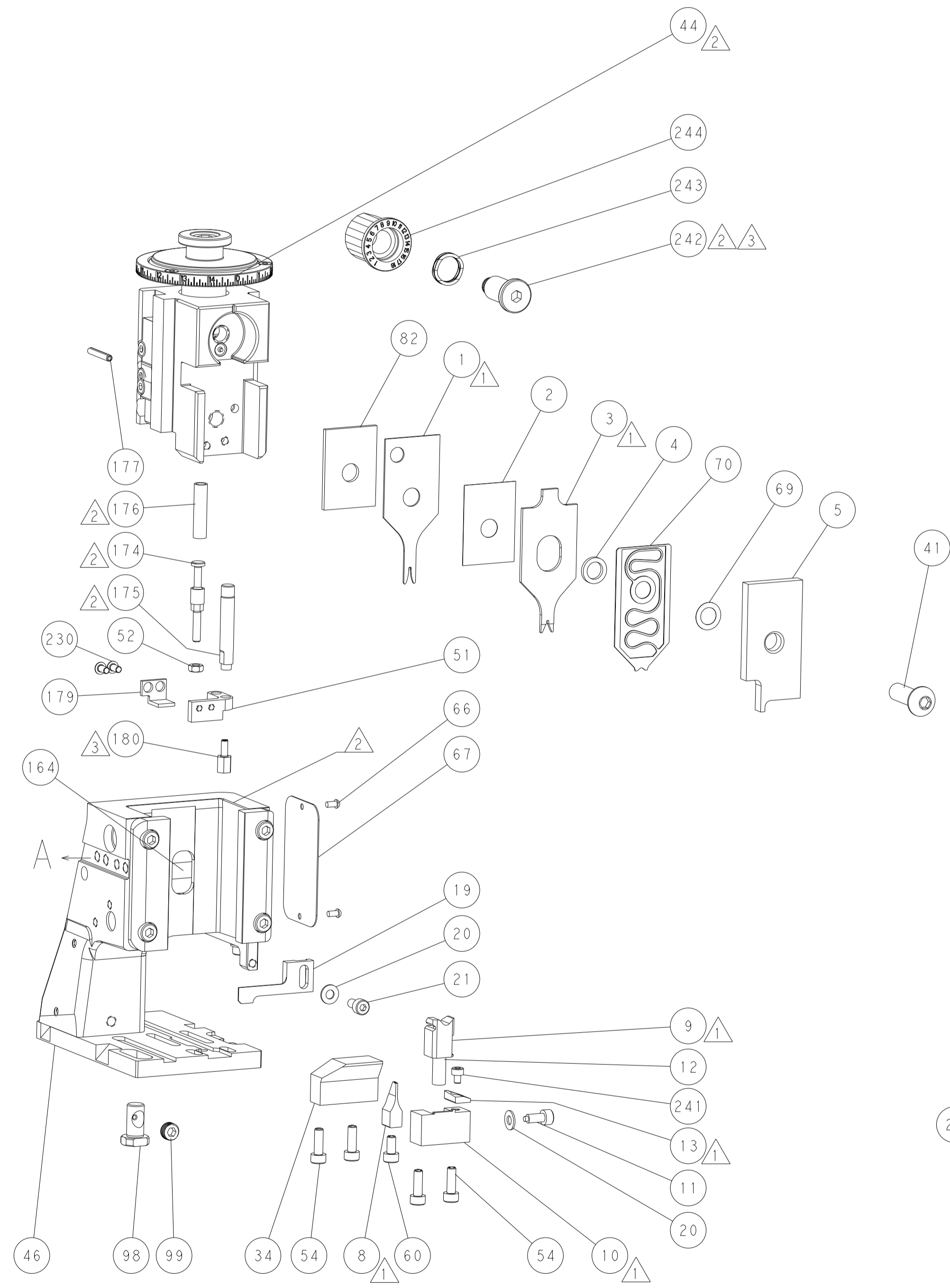
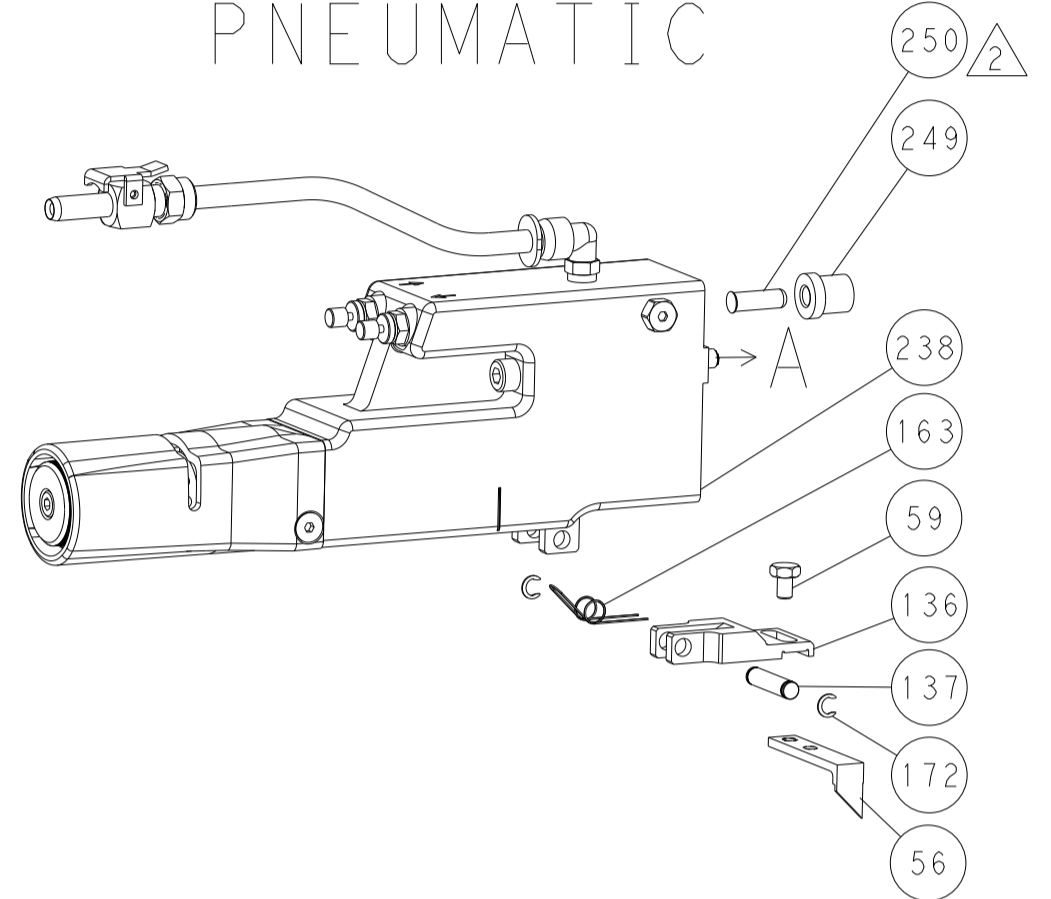
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	APVD	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
mm	0 PLC ±	1 PLC ±	2 PLC ±	M RILEY	T ELBIN	D STOUGH	Ocean Side Feed Applicator	A1	00779	2266496	Customer Accessible Production Drawing
	3 PLC ±	4 PLC ±	ANGLES ±	12MAR2014	12MAR2014	12MAR2014	TE Connectivity Harrisburg, PA 17105-3608				SCALE 1:2 SHEET 1 OF 4 REV G1

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

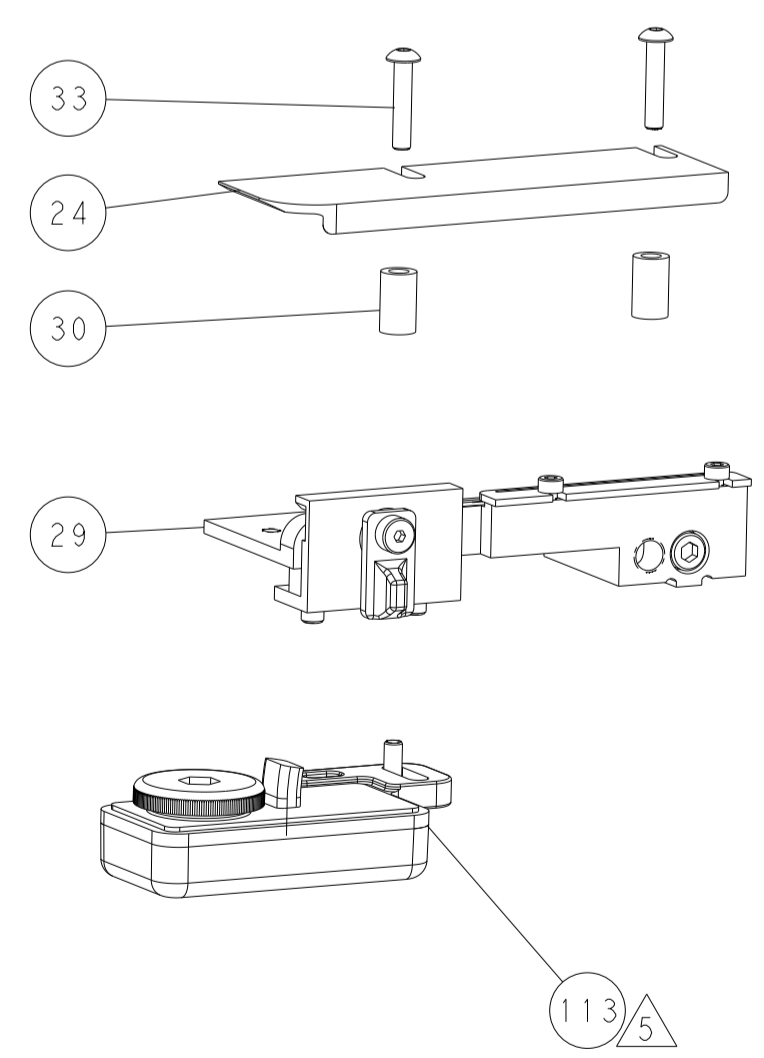
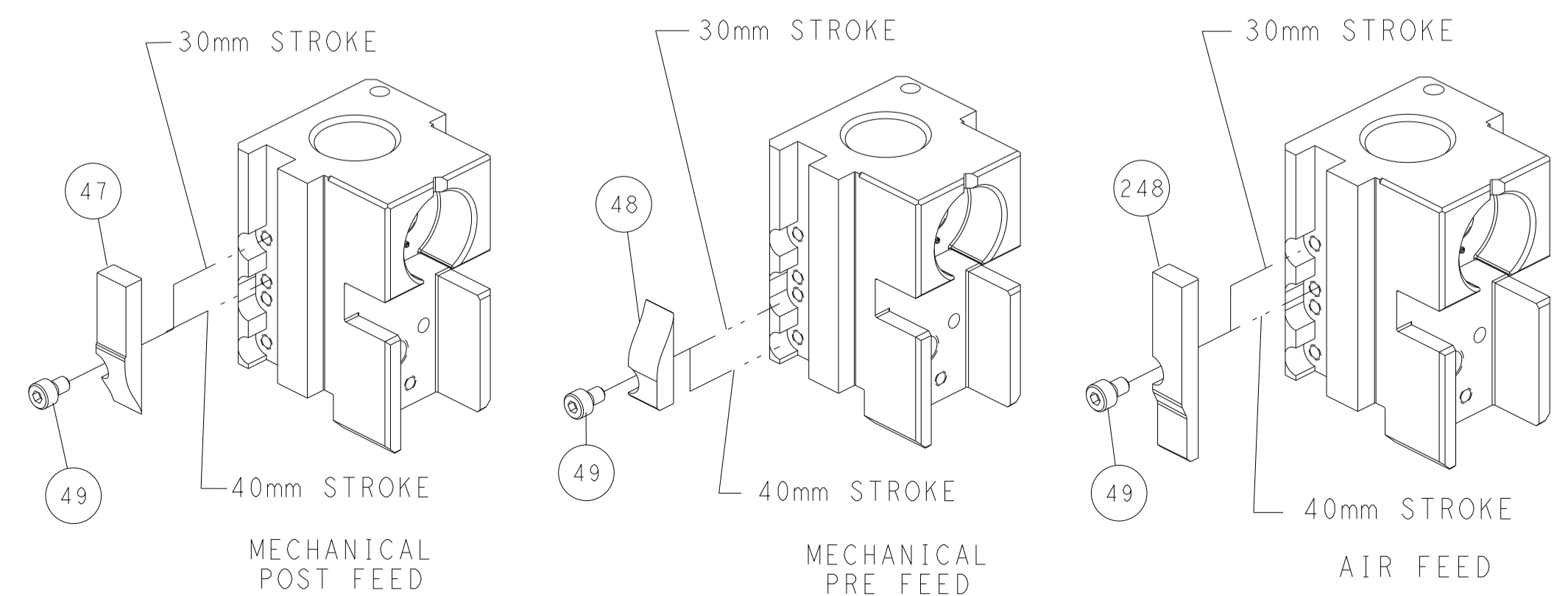
# FEED TYPE MECHANICAL



# PNEUMATIC



# CAM POSITIONS



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN M. RILEY 12MAR2014 CHK T. ELBIN 12MAR2014 APVD D. STOUGH 12MAR2014	NAME Ocean Side Feed Applicator SIZE A1 CAGE CODE 00779 DRAWING NO. C=2266496 SCALE 1:2 SHEET 2 OF 4 REV G1
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	WEIGHT Customer Accessible Production Drawing	RESTRICTED TO REV G1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266496-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266496-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266496-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.09 mm [.043]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: EMIX CONN., 1.5mm PITCH TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.05-1.54 mm [.041-.061 IN]	Ø0.90-1.15 mm [.035-.045 IN]		
TERMINAL APPLICATION SPECIFICATION	ATS-639014200 Rev D		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949551-1	87421-0000	1949551-2	87421-0002

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG OR 0.20mm2	0.58+/- .02 [.023+/- .001]	6.7
26 AWG OR 0.12mm2	0.55+/- .03 [.022+/- .001]	7.2
28 AWG OR 0.08mm2	0.55+/- .03 [.022+/- .001]	7.2
30 AWG OR 0.05mm2	0.55+/- .03 [.022+/- .001]	7.2

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 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)

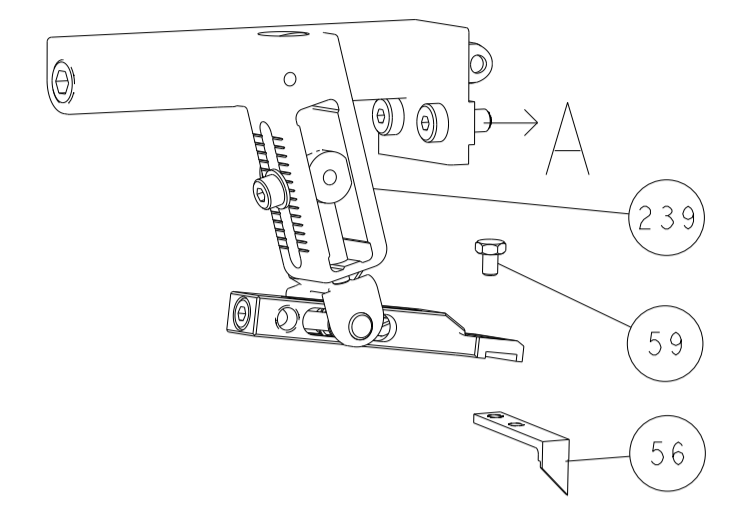
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	QTY
-	1	-		2119640-1 PUSH ROD, AIR FEED	250
-	1	-		1803259-1 BUSHING, FLANGED	249
-	1	1		2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	2		1-2079383-0 SCR, BHSC, RoHS (M3 X 6)	230
3	-	1	1	1-1752354-4 STANDOFF, HOLD-DOWN	180
-	1	1		1-1633764-7 HOLD DOWN, TERMINAL	179
-	1	1		993111-1 PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1		8-22280-7 SPRING, COMPRESSION	176
-	1	1		1752353-2 GUIDE PIN, HOLDDOWN	175
-	1	1		1901680-2 GUIDE PIN, HOLDDOWN	174
-	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
-	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
5	-	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		1-455888-8 SPACER, CRIMPER	82
-	1	1		1803607-1 DOCUMENTATION PACKAGE	71
-	1	1		2119791-9 DEPRESSOR, WIRE	70
-	1	1		2119943-1 WASHER, SPACER	69
-	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
-	1	1		1-5018030-0 NUT, HEX, REG, RoHS, M3.5	52
-	1	1		1901681-8 HOLDDOWN, TERMINAL	51
-	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		2-1752356-5 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		2-2844962-3 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-1 ASSEMBLY, STRIP GUIDE	29
-	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		2119533-3 STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1 SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-6 FLOATING SHEAR, FRONT	9
1	1	1	1	7-1803249-7 ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1		2119757-1 DEPRESSOR, SHEAR	5
-	1	1		238011-6 BLOCK, CRIMPER SPACER	4
1	1	1		9-1633962-7 CRIMPER, INSULATION F PREMIUM	3
-	1	1		455888-1 SPACER, CRIMPER	2
1	1	1		1633609-2 CRIMPER, WIRE	1

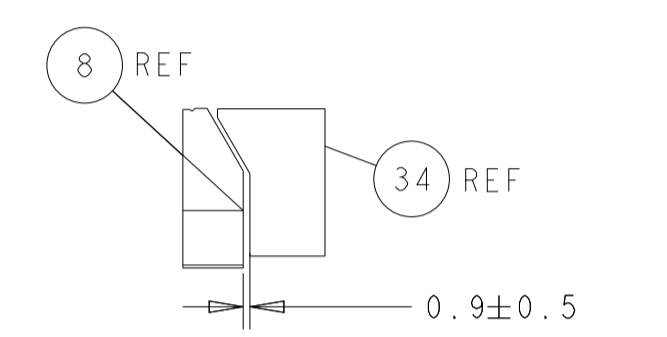
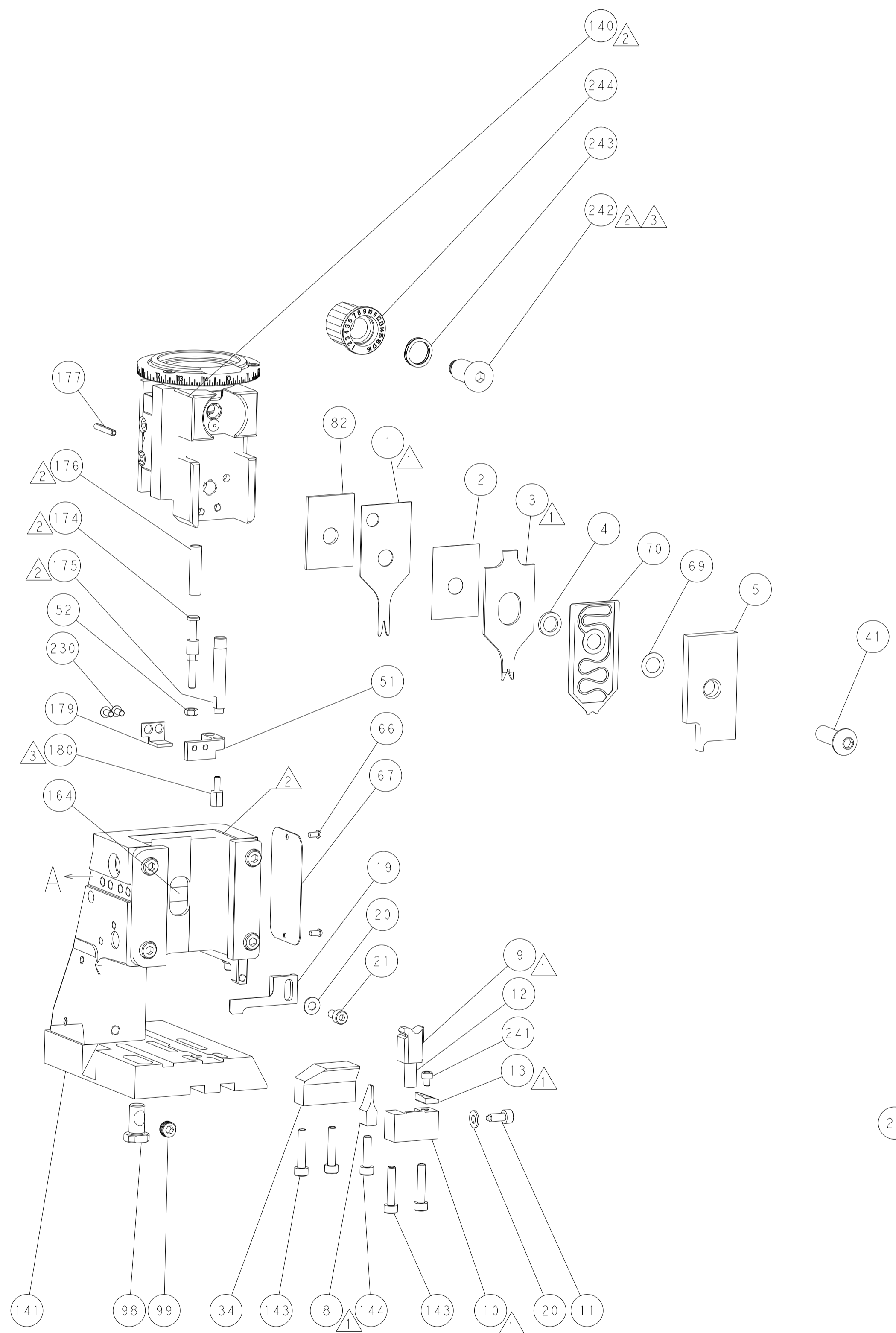
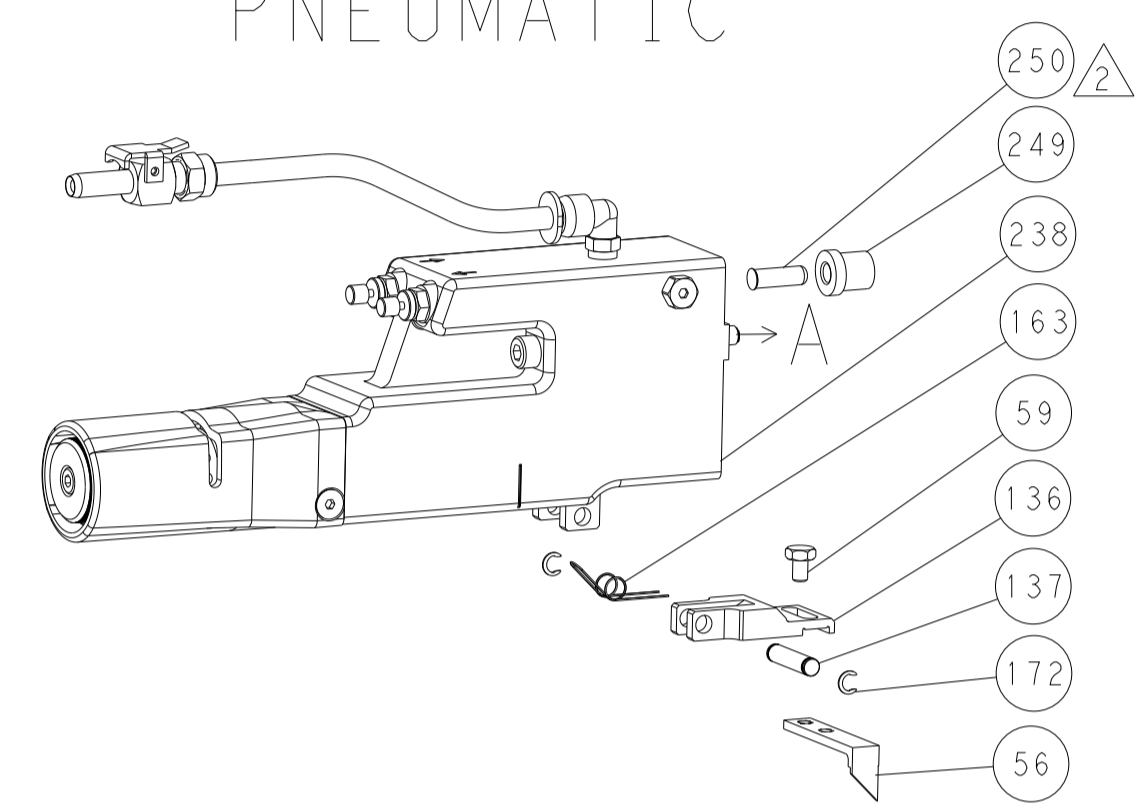
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: M RILEY 12MAR2014 CHK: T ELBIN 12MAR2014 APPV: D STOUGH 12MAR2014 PRODUCT SPEC APPLICATION SPEC WEIGHT: - MATERIAL: -		NAME: STE TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266496 RESTRICTED TO: - SCALE: 1:2 SHEET: 3 OF 4 REV: G1	
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			

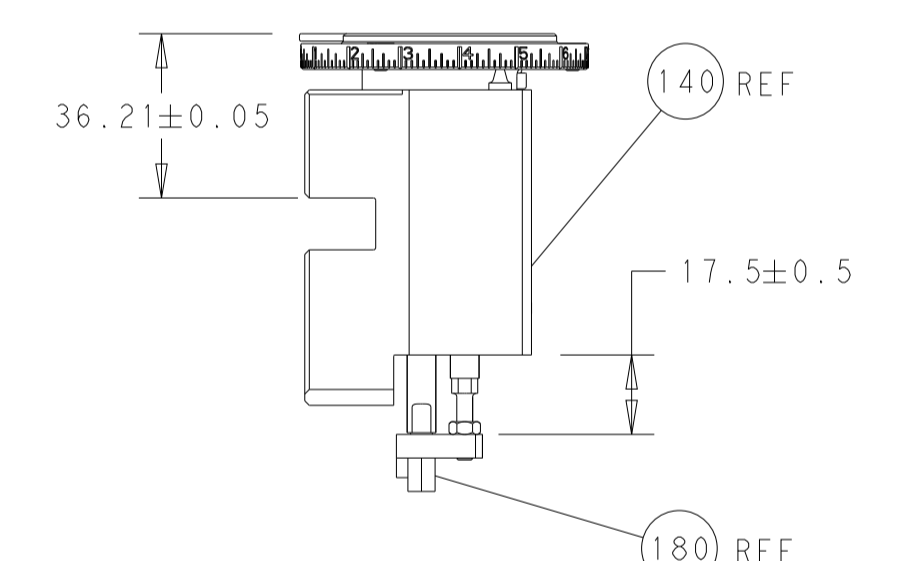
# FEED TYPE MECHANICAL



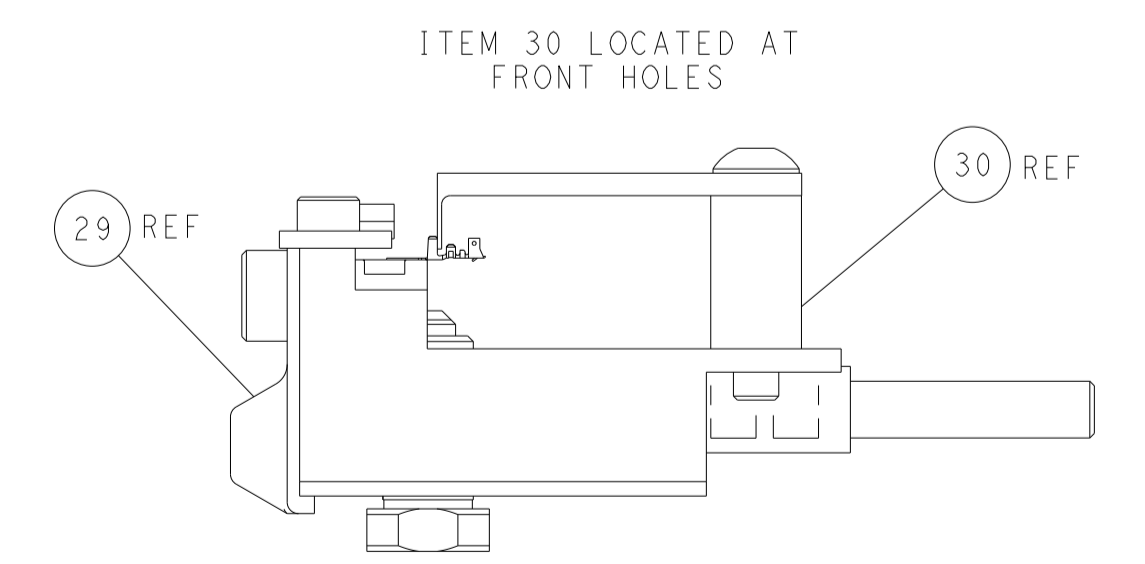
# PNEUMATIC



TERMINAL SUPPORT LOCATION

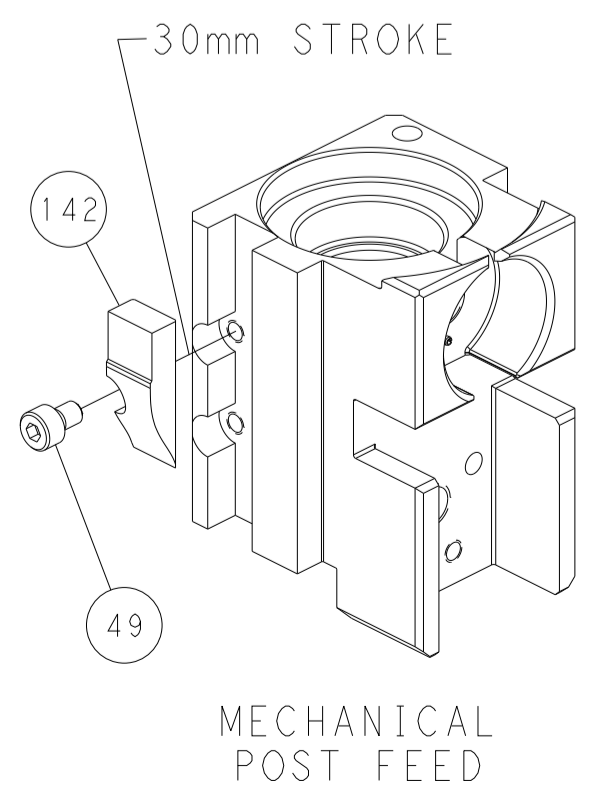


RAM AND HOLDDOWN SET-UP

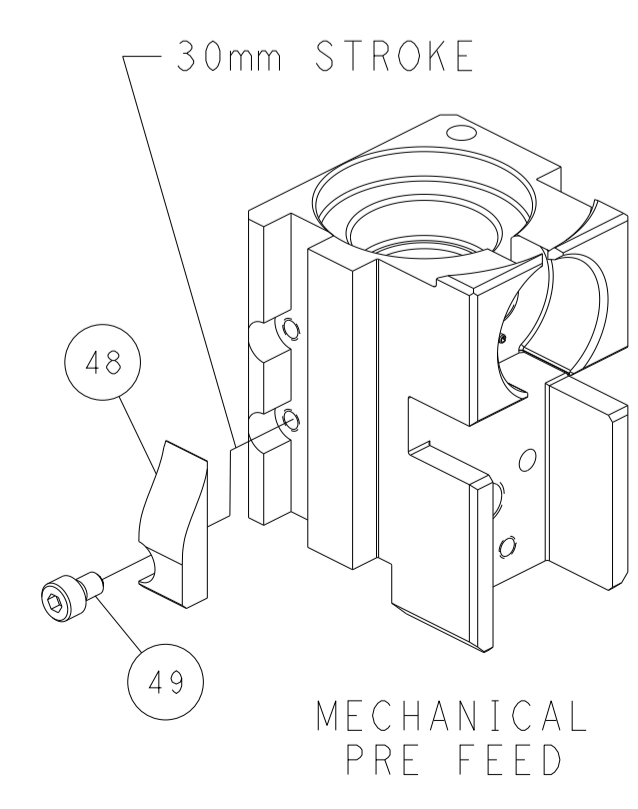


FEED TRACK POSITION GUIDE BY INSULATION BARREL

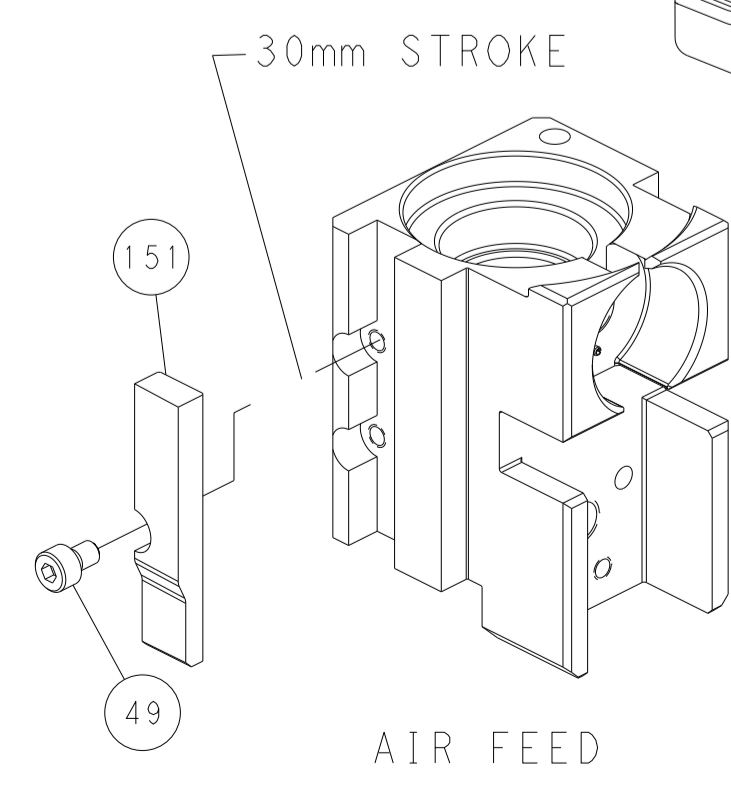
# CAM POSITIONS



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWG: M. RILEY 12MAR2014 CHK: T. ELBIN 12MAR2014 APVD: D. STOUGH 12MAR2014 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266496 SCALE: 1:2 SHEET: 4 OF 4 REV: G1	
MATERIAL: -		WEIGHT: -		RESTRICTED TO: -	