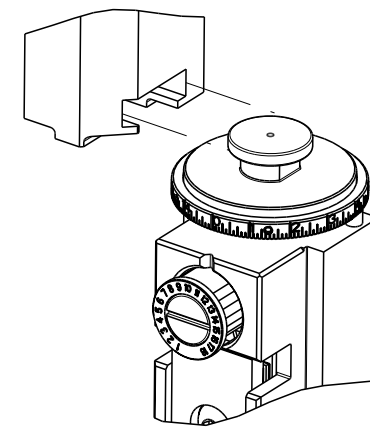


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266536-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266536-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266536-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266536-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266536-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266536-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266536-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.63 mm [.064]	F
INSUL	3.00 mm [.118]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: KOSTAL TERMINAL KOSTEL CRIMP SPECIFICATION				
TERMINAL NAME: MLK 1.2 STECKER				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE			
3.10-3.60 mm [.122-.142 IN]	Ø1.70-2.10 mm [.067-.083 IN]			
TERMINAL APPLICATION SPECIFICATION	DOC00061540 Rev 19			
TERMINALS APPLIED				
TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL	SEAL INSULATION DIAMETER RANGE
1949856-1	3 21 24 65182 0/3	1949520-1	10800507250	Ø1.70-2.10
1949856-2	3 21 25 65182 0/3			
1949856-3	3 21 40 65182 0/3			
2113111-1	3 21 XX 73418 0/3			
2113111-2	3 21 XX 73413 0/3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.17 +/- 0.03 [.046 +/- .001]	8.0
18 AWG	1.13 +/- 0.03 [.044 +/- .001]	8.5
0.75mm2	1.07 +/- 0.03 [.042 +/- .001]	9.0

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 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.

***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)

LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	C		ECR-17-008161	07JUN2017	TB	CT
		D		ECR-18-009908	26JUN2018	FL	TE
		D1		ECR-18-012297	02AUG2018	KH	CT
		E		ECR-19-014339	12SEP2019	JAH	TE

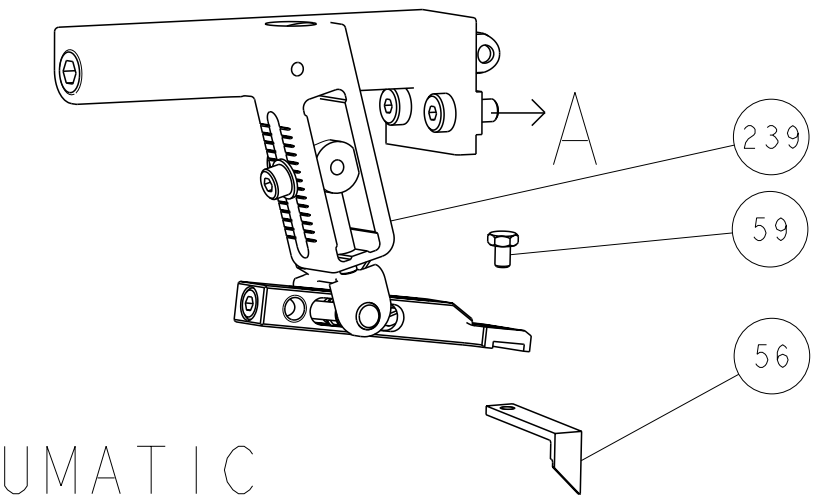
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
3	-	-	1	1	-	-	1-1752354-5	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
6	-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338683-8	FEED PAWL	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844938-5	PLATE, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	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	1	1	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	1	2-1633703-8	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	240641-4	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	7-1633965-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-8	SPACER, CRIMPER	2
1	1	2	2	1	1	1	5-1633738-9	CRIMPER, WIRE	1

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-51	-2	-1	

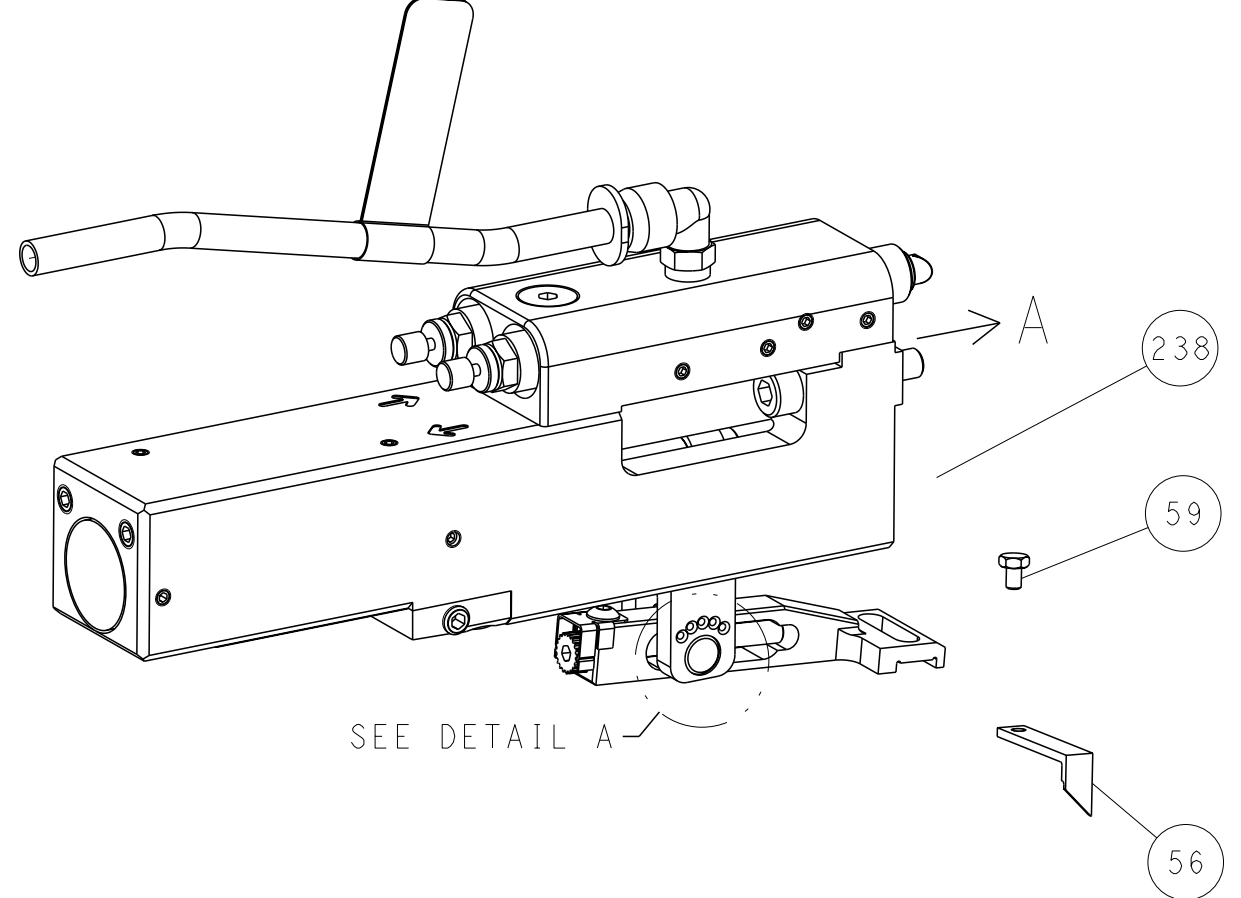
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HOFFNER	T. ELBIN	T. ELBIN
NAME	NAME	NAME
Ocean Side Feed	Ocean Side Feed	Ocean Side Feed
Applicator	Applicator	Applicator
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266536
Customer Accessible Production Drawing	SCALE	SHEET
	1:2	1 of 4
REV	E	

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

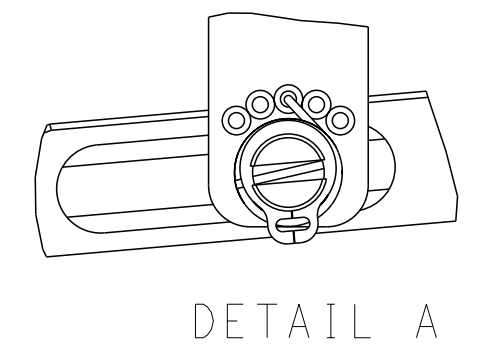
FEED TYPE MECHANICAL



PNEUMATIC

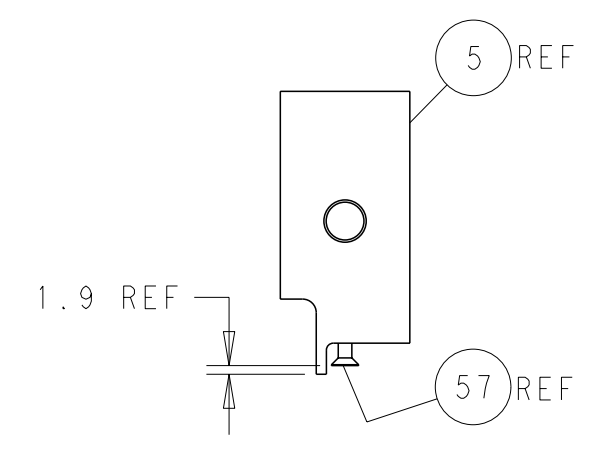
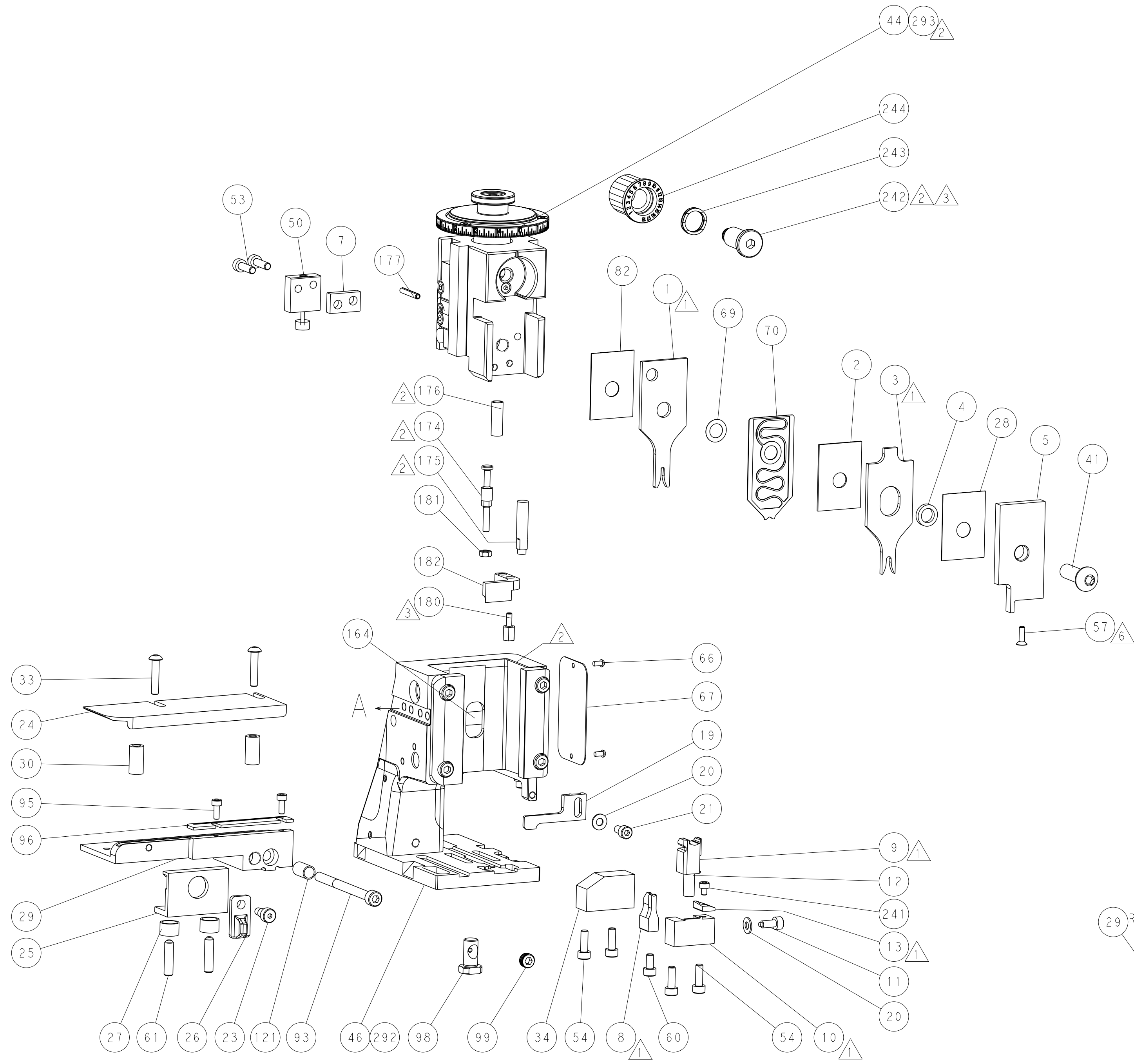
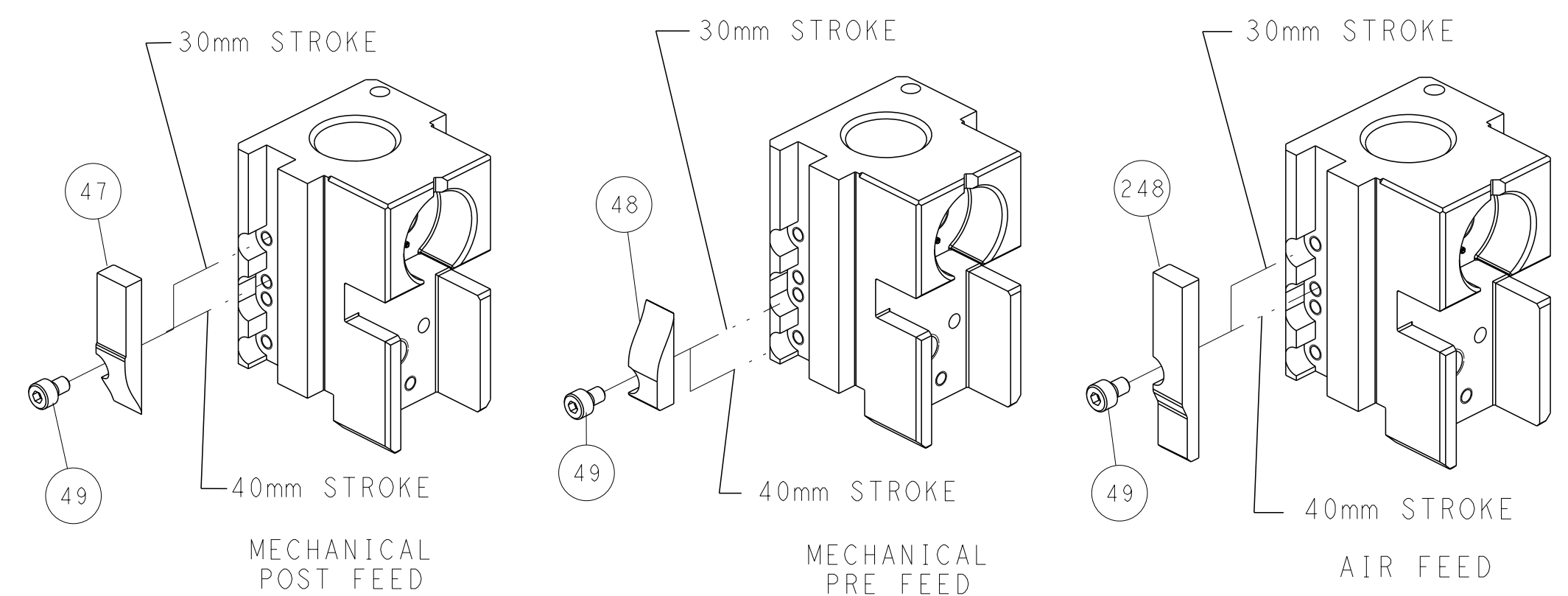


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

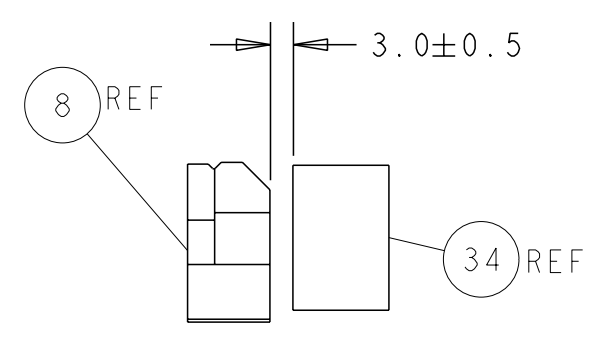


DETAIL A

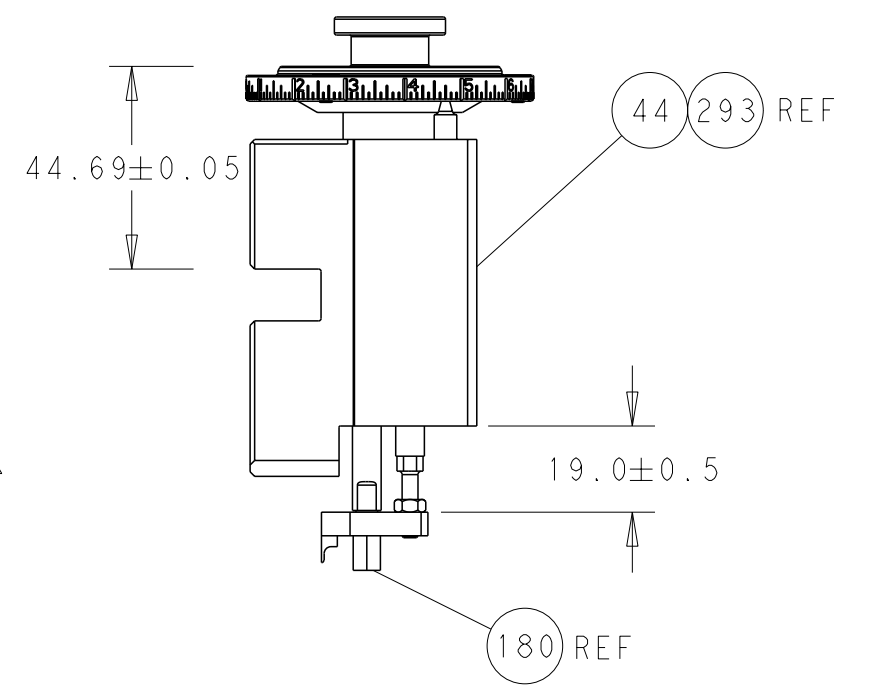
CAM POSITIONS



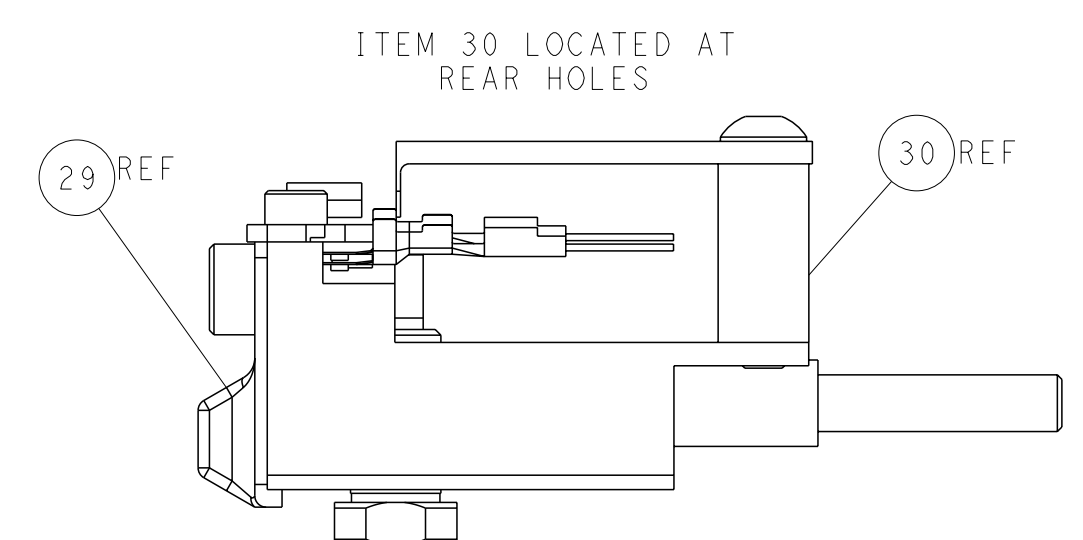
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



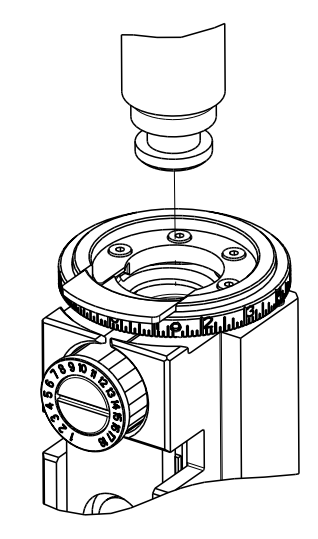
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND RESTRICTION DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: HOFFNER 10OCT2014 CHK: TELBIN 13OCT2014 APVD: TELBIN 13OCT2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266536 SHEET 2 OF 4 REV E
MATERIAL: - FINISH: -		RESTRICTED TO: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266536-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266536-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266536-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.63 mm [.064]	F
INSUL	3.00 mm [.118]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL KOSTEL CRIMP SPECIFICATION	
TERMINAL NAME: MLK 1.2 STECKER	
WIRE STRIP LENGTH 3.10-3.60 mm [.122-.142 IN]	INSULATION DIAMETER RANGE Ø1.70-2.10 mm [.067-.083 IN]
TERMINAL APPLICATION SPECIFICATION DOC00061540 Rev 19	

TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL	SEAL INSULATION DIAMETER RANGE
1949856-1	3 21 24 65182 0/3	1949520-1	10800507250	Ø1.70-2.10
1949856-2	3 21 25 65182 0/3			
1949856-3	3 21 40 65182 0/3			
2113111-1	3 21 XX 73418 0/3			
2113111-2	3 21 XX 73413 0/3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.17+/-0.03 [.046+/-0.001]	8.0
18 AWG	1.13+/-0.03 [.044+/-0.001]	8.5
0.75mm2	1.07+/-0.03 [.042+/-0.001]	9.0

- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

***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)

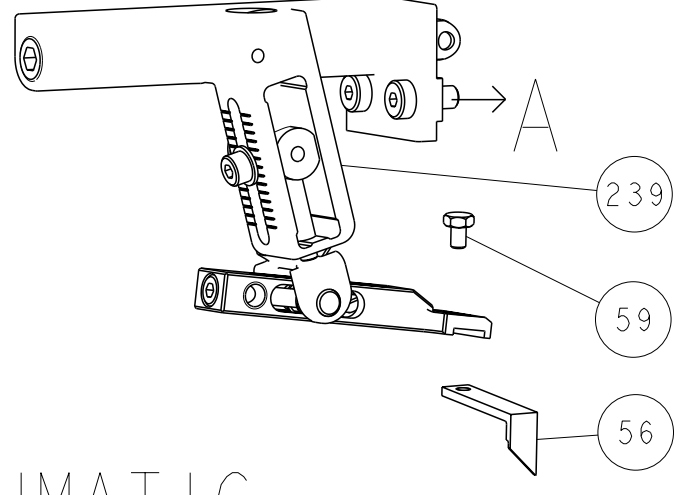
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	1		2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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		1-22281-8 SPRING, COMPRESSION	121
-	1	1		2844908-1 SCREW, LOCKING	99
-	1	1		2844907-1 POST, LOCKING	98
-	1	1		1-690438-0 FRONT STRIP GUIDE	96
-	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		1803607-3 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
-	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
6	-	1		985575-3 SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1		1338683-8 FEED PAWL	56
-	2	2		2-2168083-5 SCR, SKT HD CAP, RoHS, M4 X 14	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		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		3-2844962-2 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	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		240792-1 DRAG, TERMINAL	25
-	1	1		1320928-6 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
-	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		2-1633703-8 ANVIL, COMBINATION	8
-	1	1		240641-4 SPACER	7
-	-	-		-	6
-	1	1		2119781-1 DEPRESSOR, SHEAR	5
-	1	1		238011-4 BLOCK, CRIMPER SPACER	4
1	1	1		7-1633965-9 CRIMPER, INSULATION O PREMIUM	3
-	1	1		455888-8 SPACER, CRIMPER	2
1	1	1		5-1633738-9 CRIMPER, WIRE	1

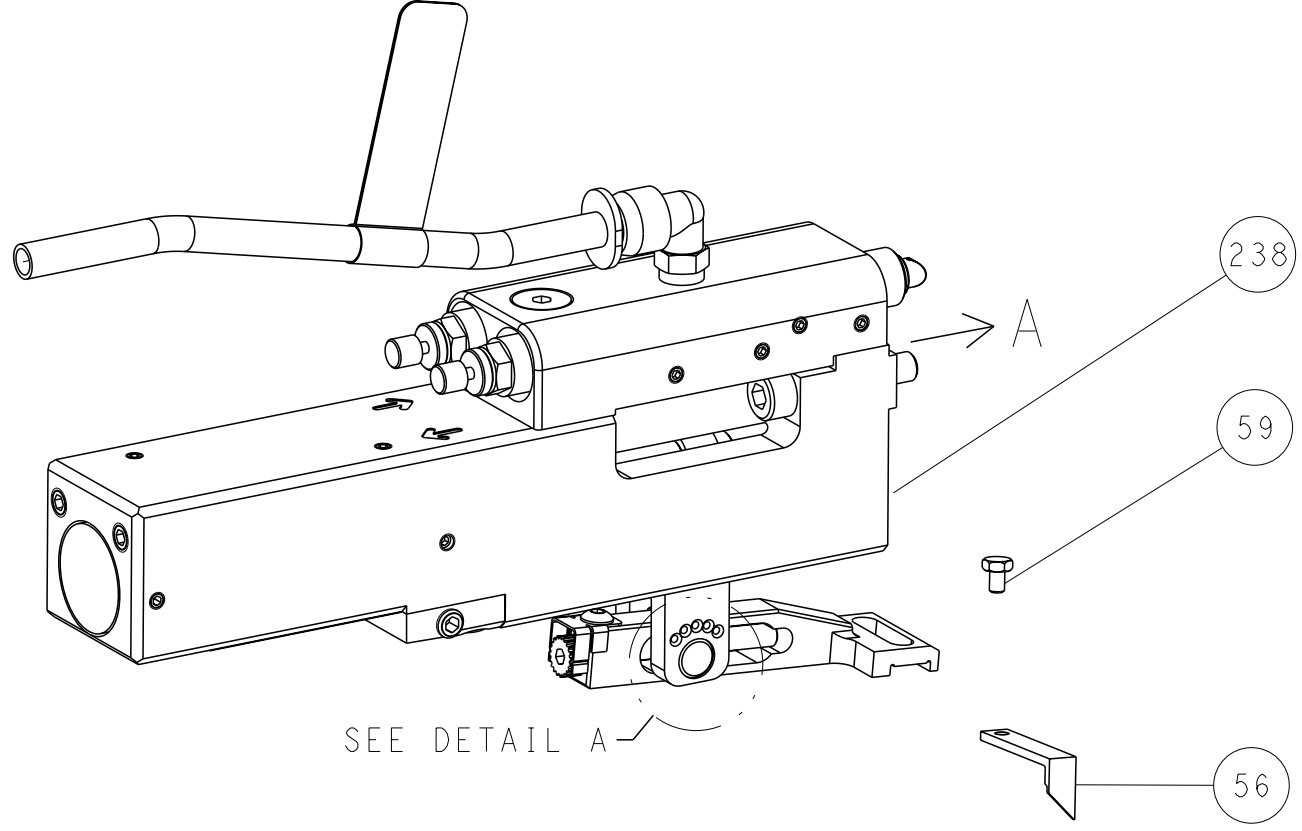
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	100CT2014	TE Connectivity Harrisburg, PA 17105-3608
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	3 PLC ±	4 PLC ±	ANGLES ±	APPV	130CT2014	NAME
	FINISH					Ocean Side Feed Applicator
MATERIAL				WEIGHT		SIZE
						00779
						Customer Accessible Production Drawing
						SCALE 1:2 SHEET 3 OF 4 REV E

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

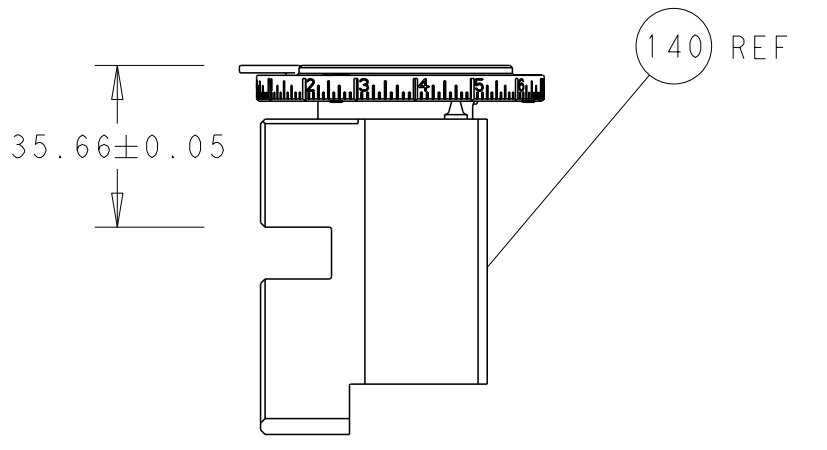
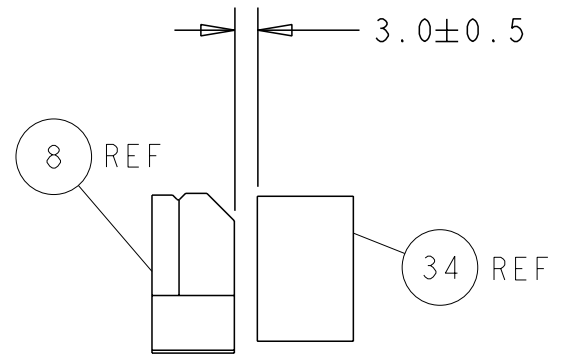
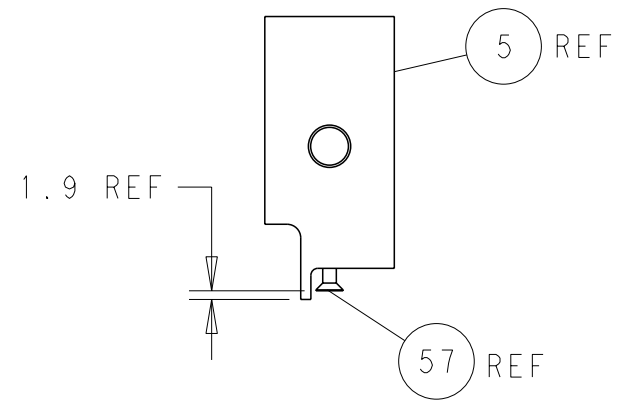
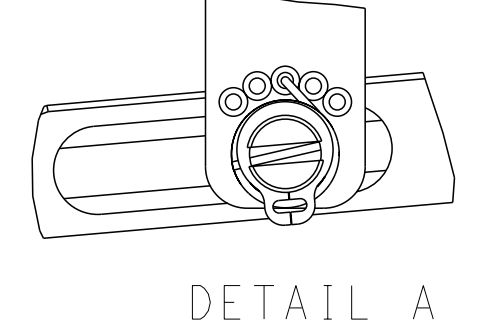
FEED TYPE MECHANICAL



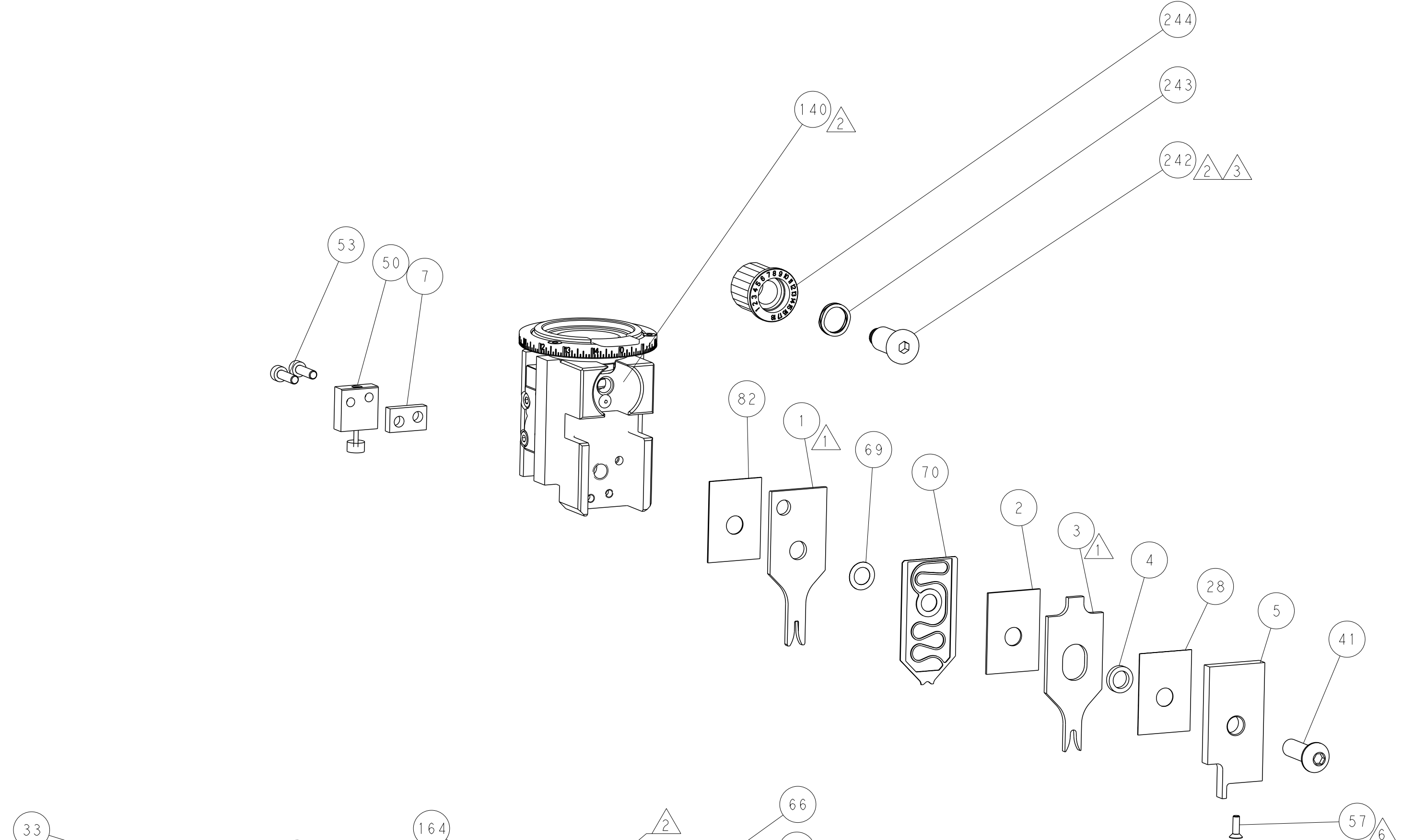
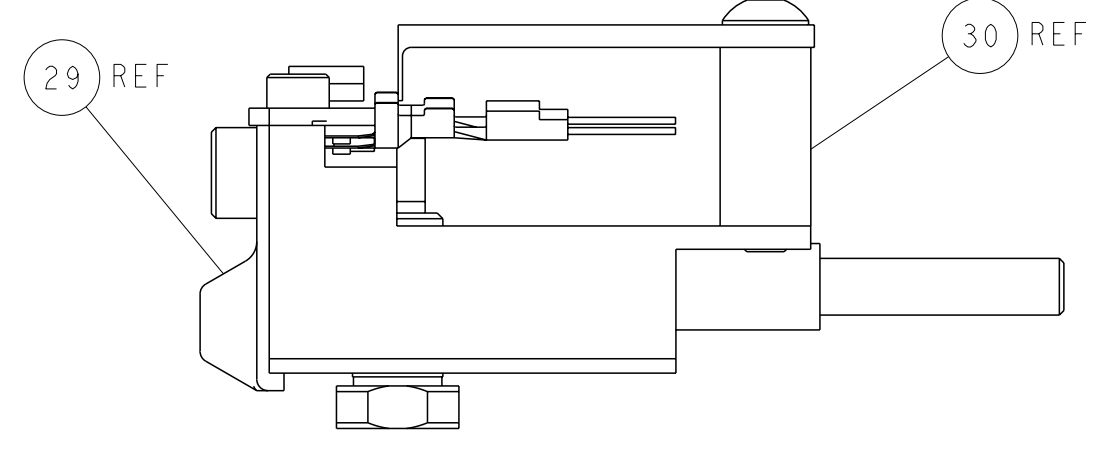
PNEUMATIC



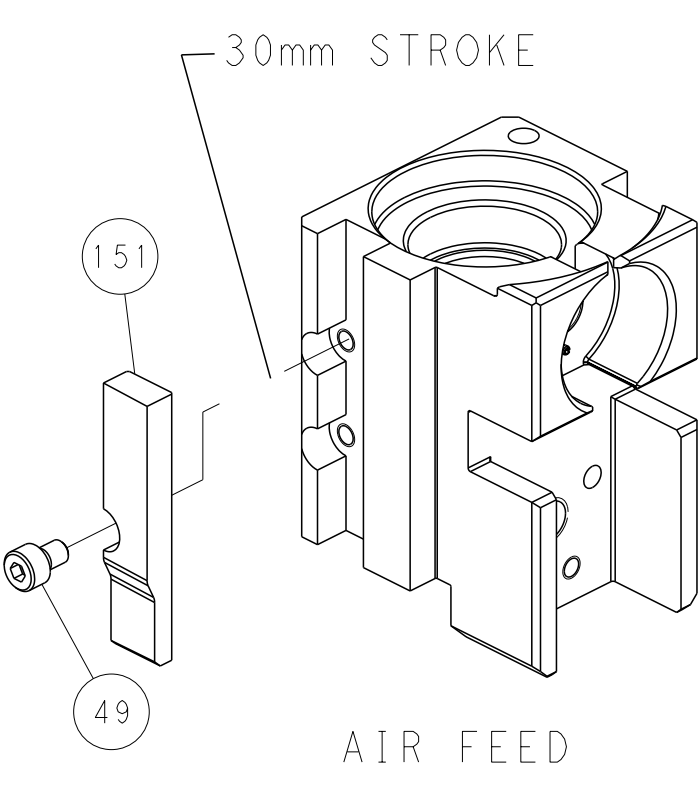
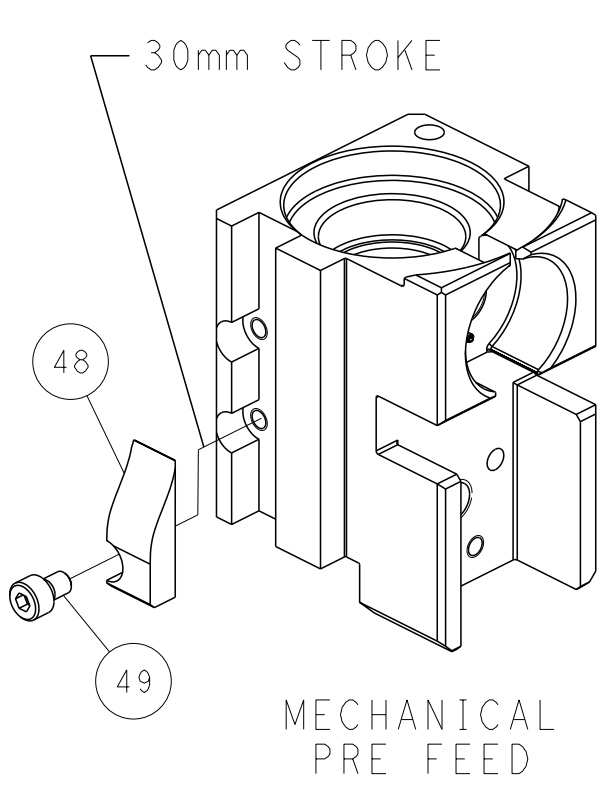
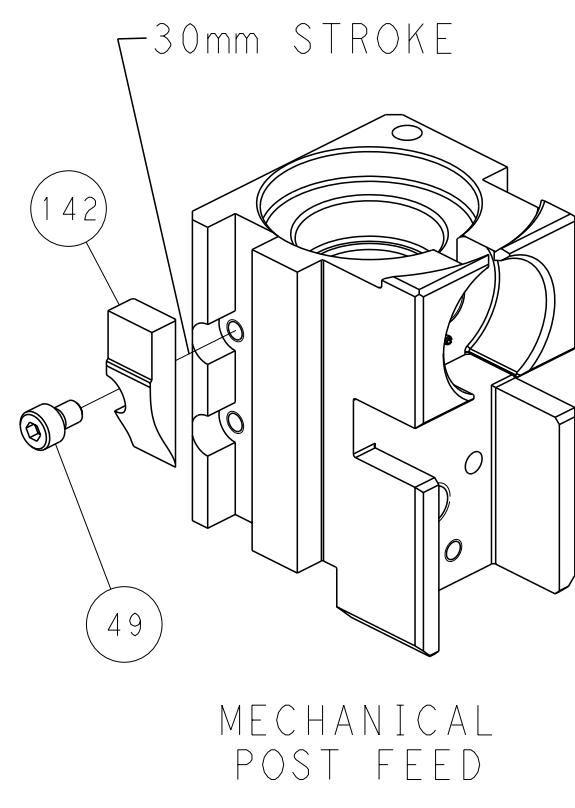
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



ITEM 30 LOCATED AT REAR HOLES



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: HOFFNER 10OCT2014		TE Connectivity	
mm		0 PLC ±		CITY: T. ELBIN 13OCT2014		Harrisburg, PA 17105-3608	
MATERIAL:		1 PLC ±		APVD: T. ELBIN 13OCT2014		NAME: Ocean Side Feed Applicator	
		2 PLC ±		PRODUCT SPEC:		SIZE: CAGE CODE DRAWING NO. RESTRICTED TO	
		3 PLC ±		APPLICATION SPEC:		A1 00779 ©=2266536	
		4 PLC ±		WEIGHT:		SCALE: 1:2 SHEET 4 OF 4 REV E	
		ANGLES FINISH *		Customer Accessible Production Drawing		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	