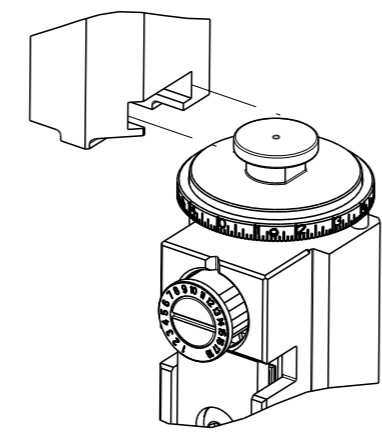


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266589-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266589-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266589-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266589-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266589-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

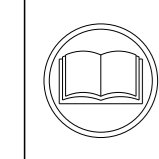


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.18 mm [.046]	F
INSUL	2.90 mm [.114]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION			
TERMINAL NAME: MLK 1.2			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.10-3.60 mm [.122-.142 IN]	Ø1.10-1.50 mm [.043-.059 IN]		
TERMINAL APPLICATION SPECIFICATION	DOC00061540 Rev 13		
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL
2113624-1	32140680630	1949520-1	10800507250
2113624-2	32124680630		
2113624-3	32125680630		
2113624-4	221XX492670		
2113624-5	221XX614100		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG OR 0.14mm2	0.73 +/- 0.03 [.029 +/- .001]	6.4



- 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. 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.

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

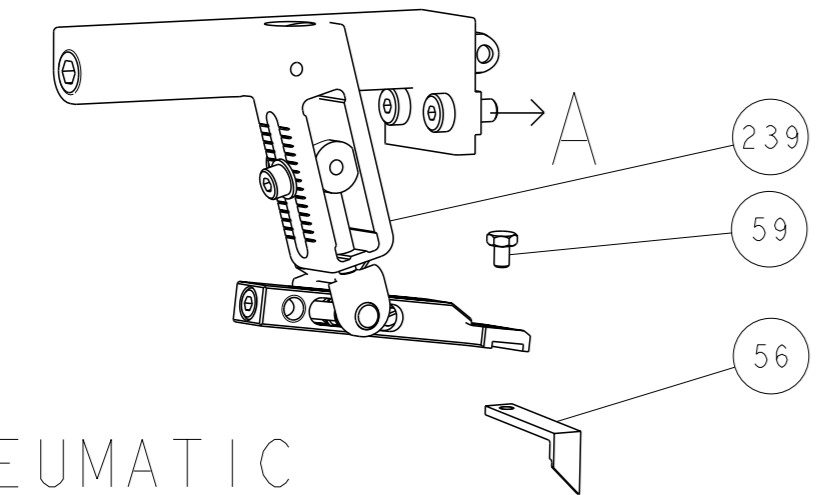
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				ECR-19-016842	30OCT2019	FJ	TE
				ECR-19-019880	20OCT2019	MEH	GB

-	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	-	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	455888-5	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	1	1	1	1	1338683-8	FEED PAWL	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	1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-2	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	1633861-1	SHEAR, FLOATING	9	
-	1	2	2	1	1	7-1803054-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-8	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2-1803143-0	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-9	SPACER, CRIMPER	2	
-	1	2	2	1	1	1633893-5	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	ITEM NO	

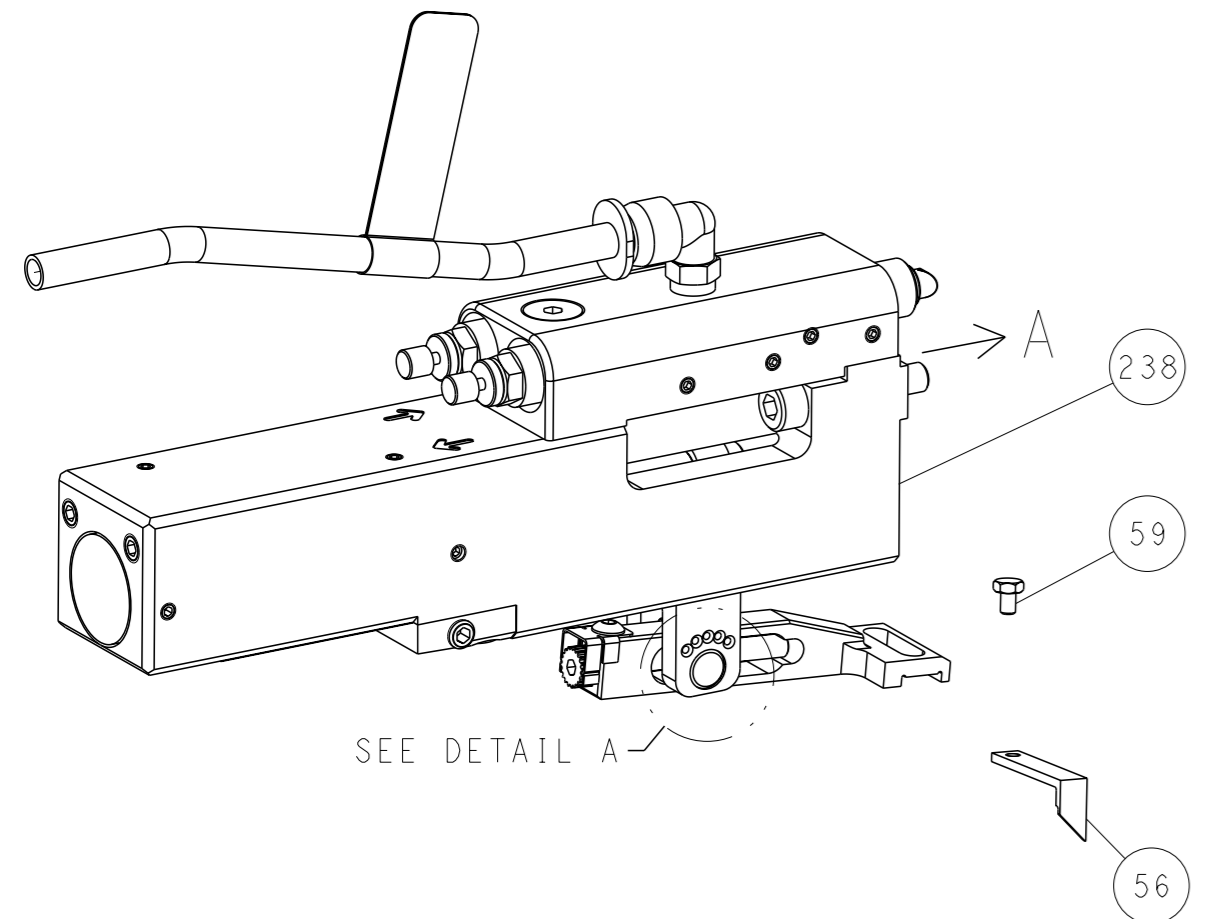
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mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0001	Y. YIN	05FEB2015
	ANGLES ±.0001	FINISH		CHK	G. BAILEY	05FEB2015	
				APVD	U. GUO	05FEB2015	
				PRODUCT SPEC			
				APPLICATION SPEC			
MATERIAL				WEIGHT			
Customer Accessible Production Drawing				SCALE	1:2	SHEET	1 of 4
				REV	D		

LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
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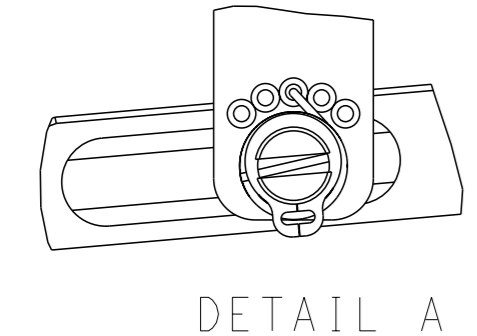
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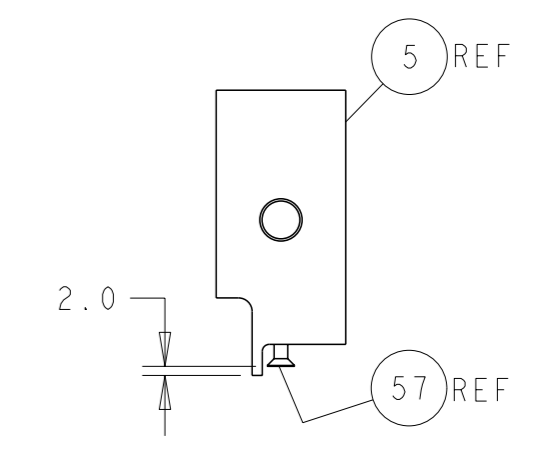
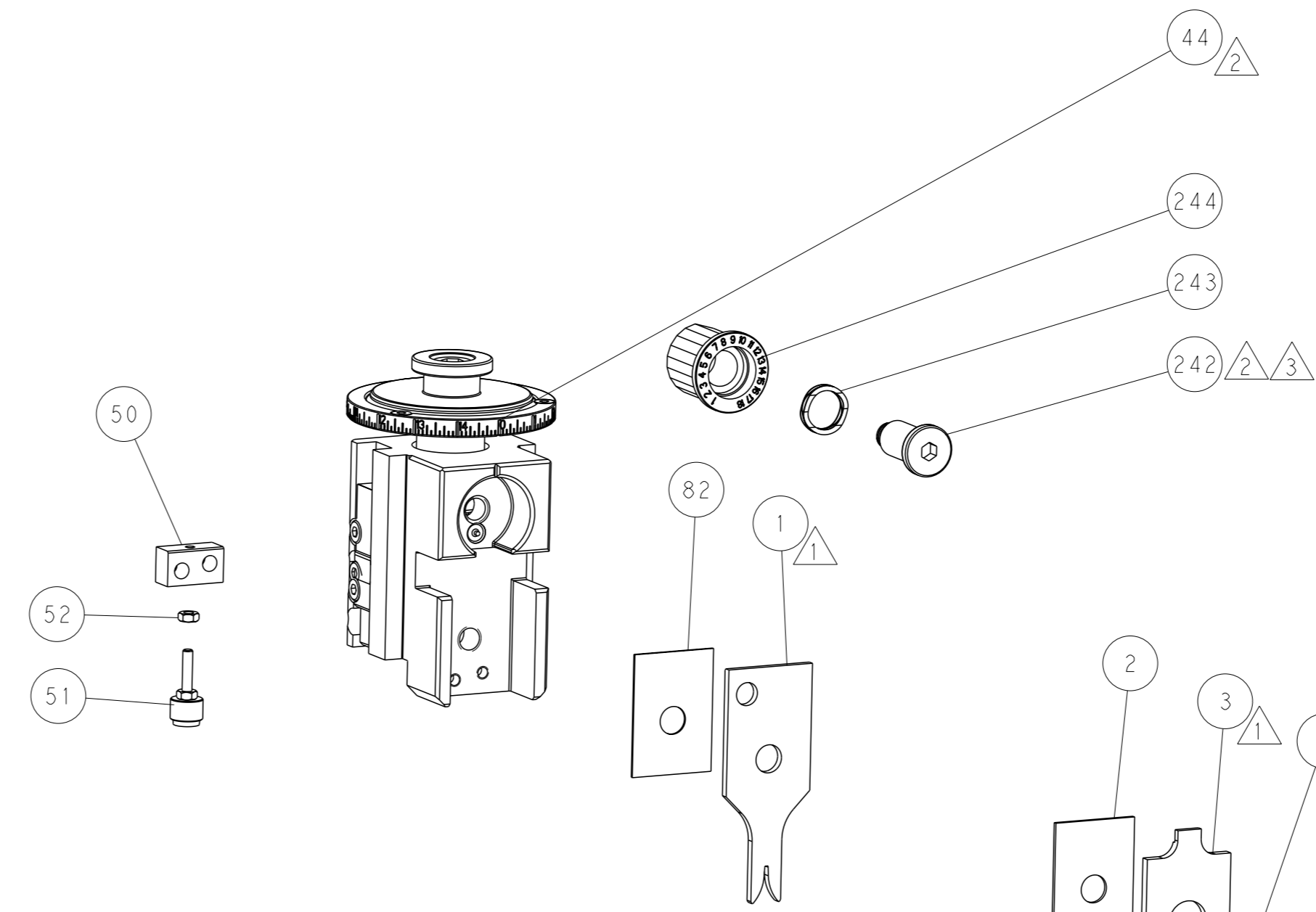
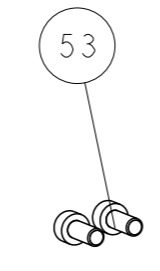
PNEUMATIC



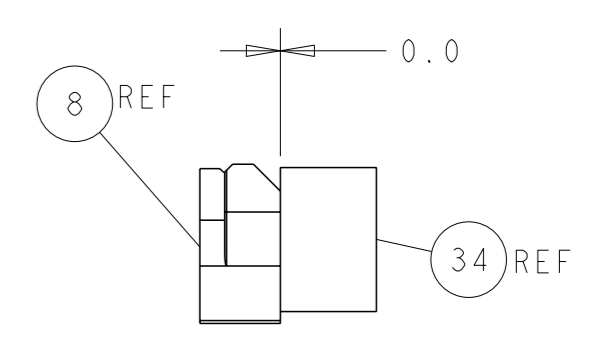
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



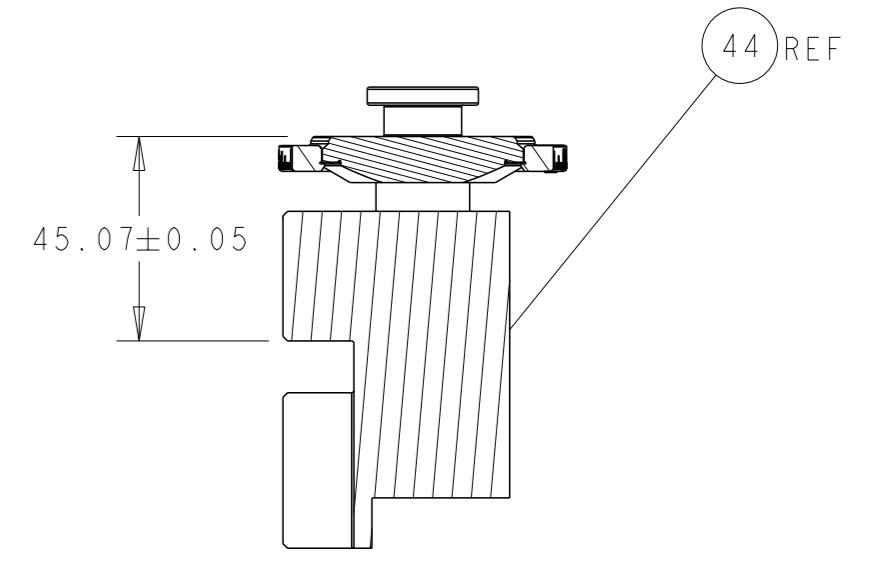
DETAIL A



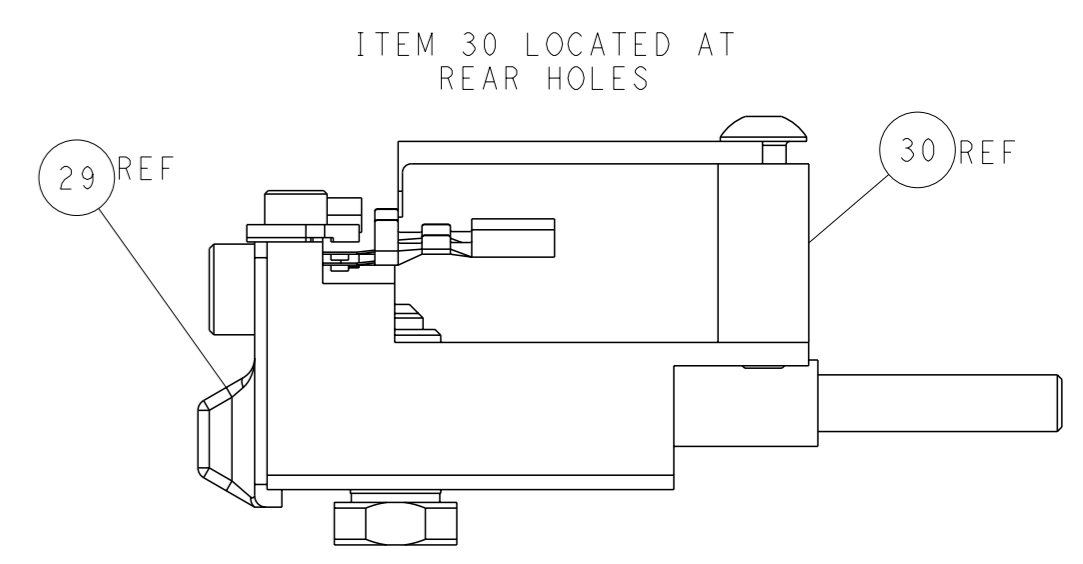
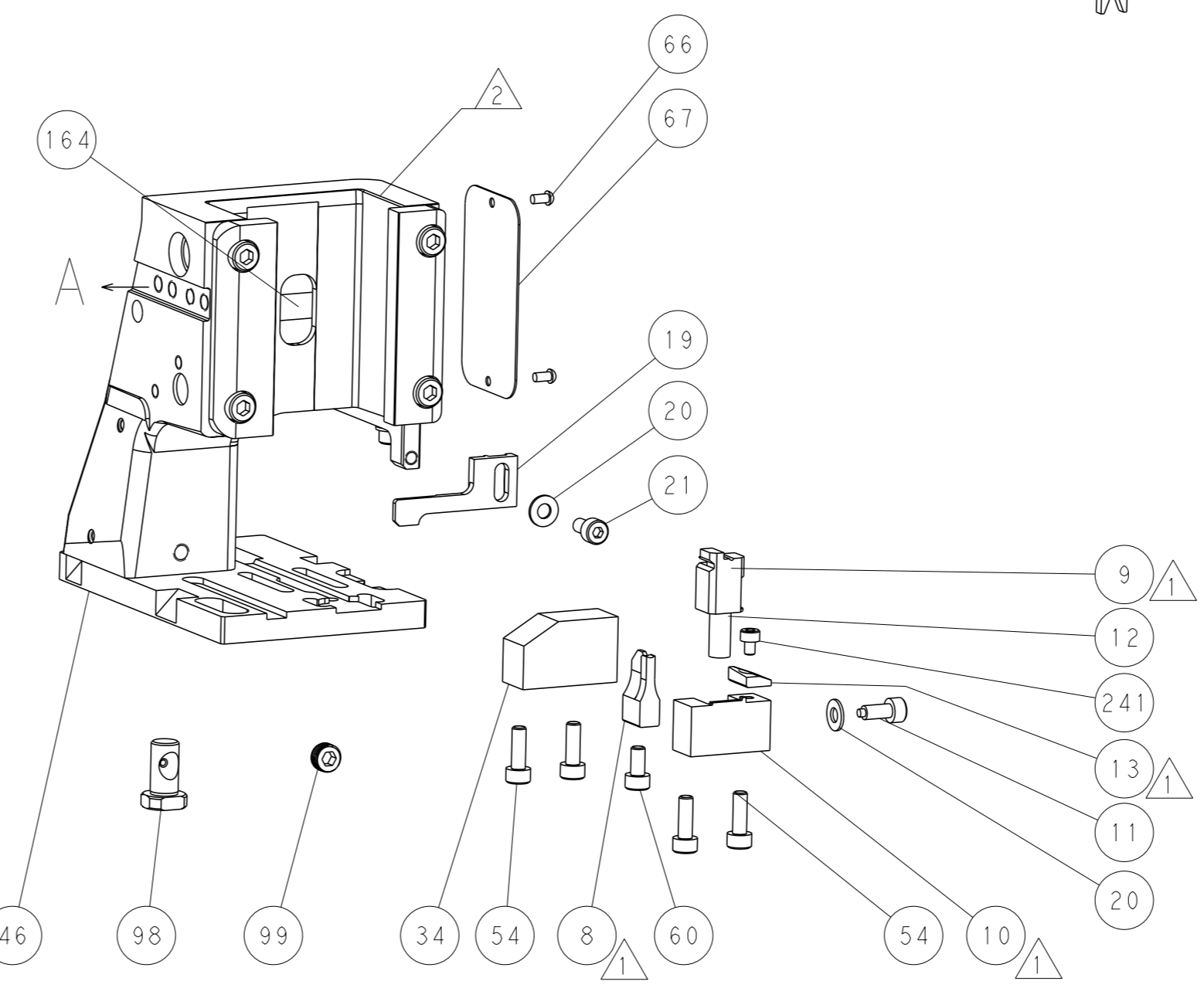
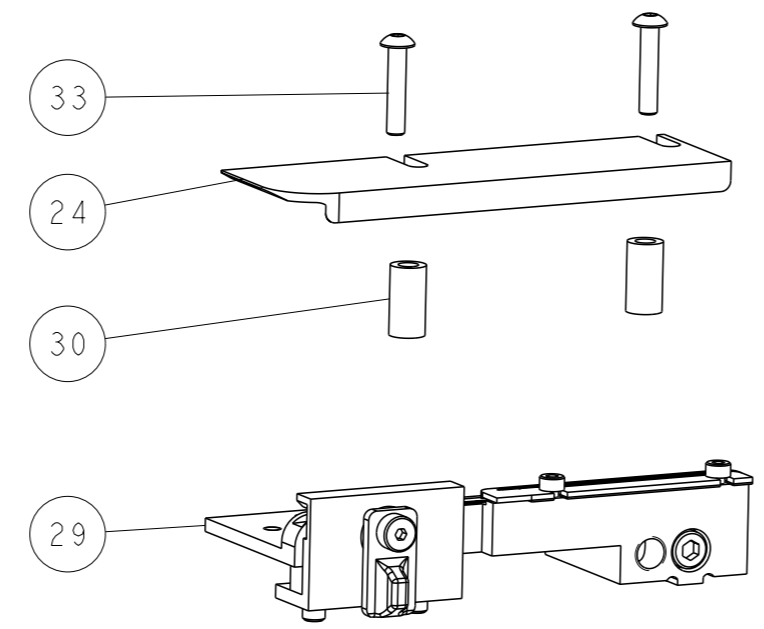
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

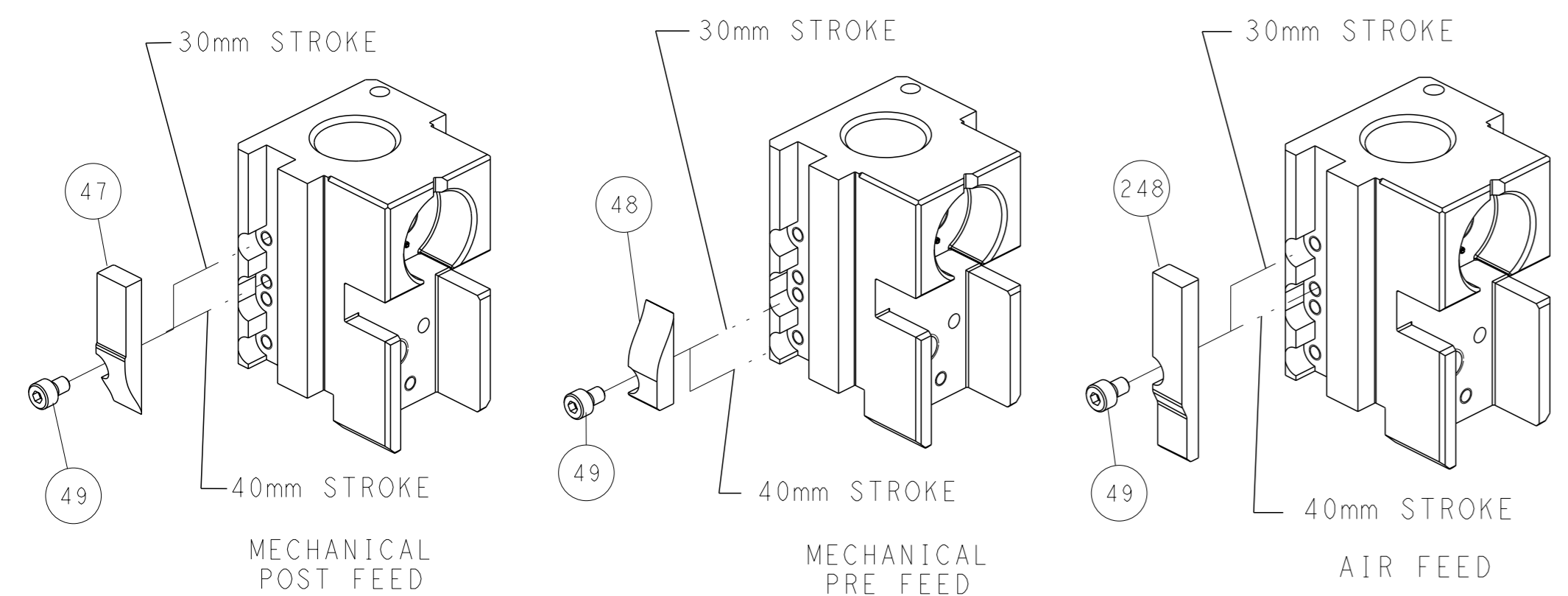


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

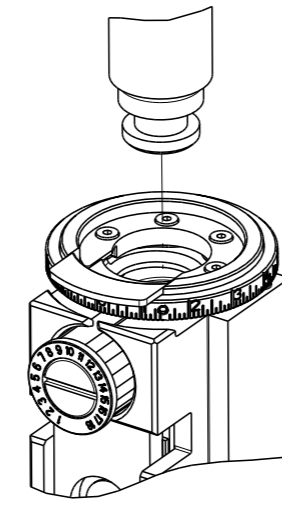


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN Y. YIN 05FEB2015	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	CHK G. BAILEY 05FEB2015	
MATERIAL:		FINISH:		APVD U. GUO 05FEB2015	NAME Ocean Side Feed Applicator
-		-		PRODUCT SPEC	SIZE CAGE CODE DRAWING NO
-		-		APPLICATION SPEC	A1 00779 ©=2266589
-		-		RESTRICTED TO	Customer Accessible Production Drawing
-		-		SCALE 1:2	SHEET 2 of 4 REV D

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266589-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266589-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266589-7	D	CRIMP TOOLING KIT	-

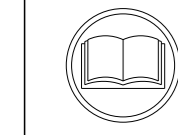
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.18 mm (.046)	F
INSUL	2.90 mm (.114)	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL		KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: MLK 1.2			
WIRE STRIP LENGTH 3.10-3.60 mm [.122-.142 IN]		INSULATION DIAMETER RANGE Ø1.10-1.50 mm [.043-.059 IN]	
TERMINAL APPLICATION SPECIFICATION DOC00061540 Rev 13			
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL
2113624-1	32140680630	1949520-1	10800507250
2113624-2	32124680630		
2113624-3	32125680630		
2113624-4	221XX492670		
2113624-5	221XX614100		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG OR 0.14mm2	0.73+/-0.03 [.029+/-0.001]	6.4



- 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 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)

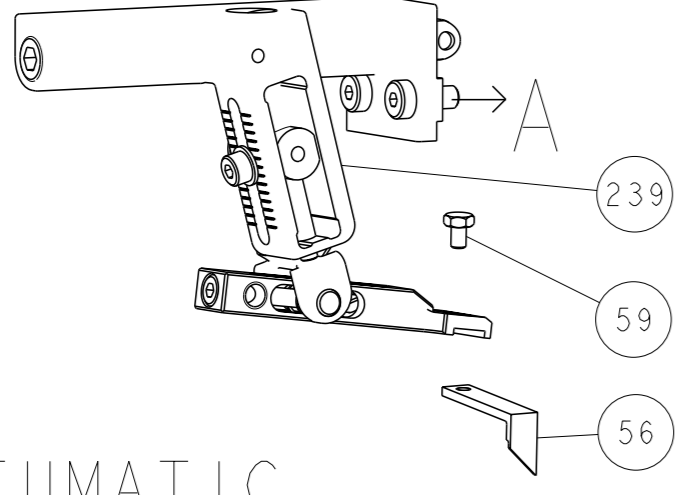
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A	66				

REVISIONS					
REV	DATE	BY	DESCRIPTION	DATE	APPV
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-	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
-	-	-	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	455888-5	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	1338683-8	FEED PAWL	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	1752356-6	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	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
3	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
3	-	1	2119805-1	SHEAR HOLDER, FRONT	10
3	-	1	1633861-1	SHEAR, FLOATING	9
3	1	1	7-1803054-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1-238011-8	BLOCK, CRIMPER SPACER	4
3	1	1	2-1803143-0	CRIMPER, INSULATION O	3
-	1	1	455888-9	SPACER, CRIMPER	2
3	1	1	1633893-5	CRIMPER, WIRE PREMIUM	1
-	-	-	-77-22-21	PART NO	ITEM NO

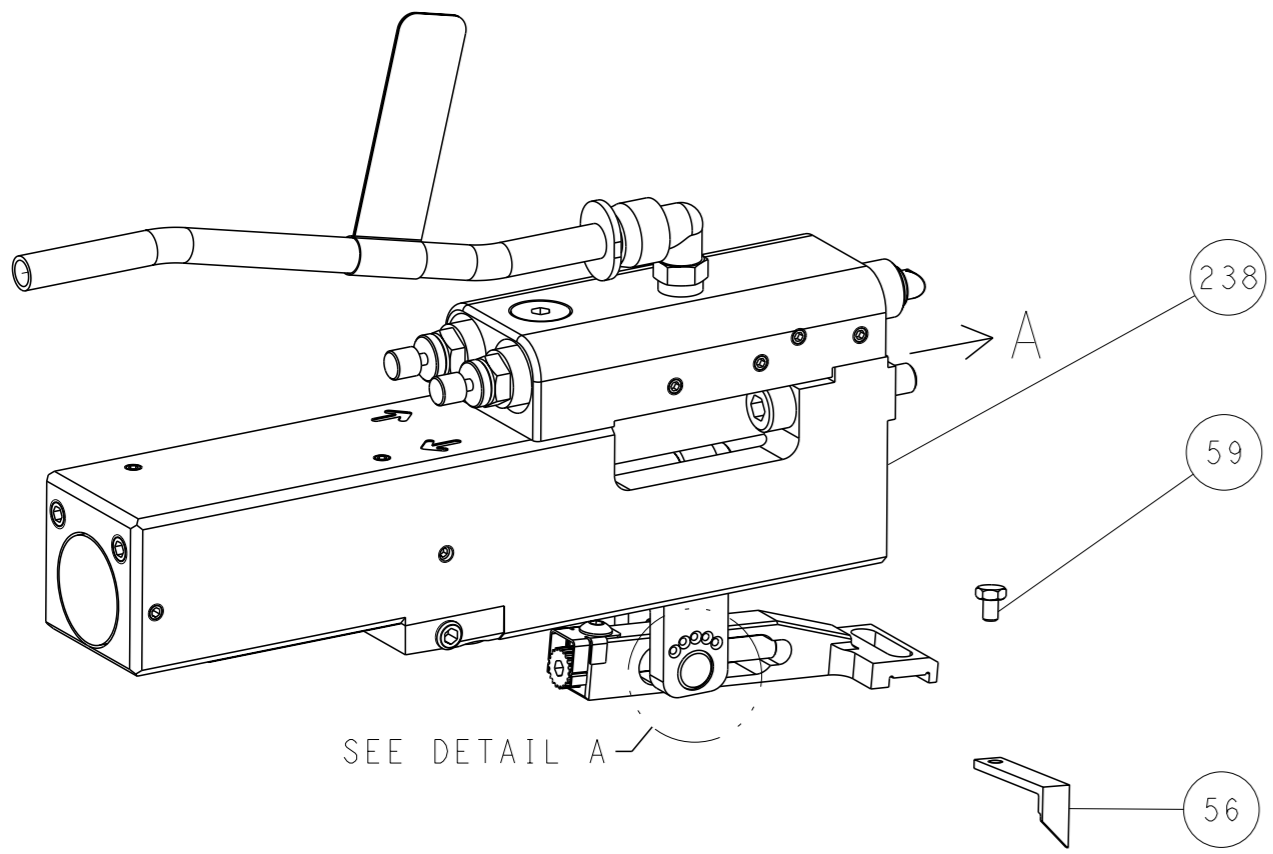
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mm		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		CHK G. BAILEY 05FEB2015	
MATERIAL		FINISH		APVD U. GUO 05FEB2015	NAME Ocean Side Feed Applicator
				PRODUCT SPEC	SIZE CAGE CODE DRAWING NO
				APPLICATION SPEC	RESTRICTED TO
				WEIGHT	A1 00779 C=2266589
				Customer Accessible Production Drawing	SCALE 1:2 SHEET 3 of 4 REV D

REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LYR			
		SEE SHEET 1		

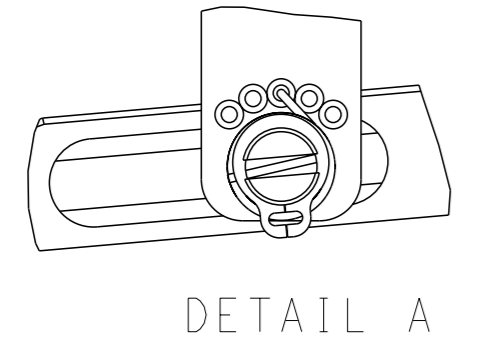
FEED TYPE MECHANICAL



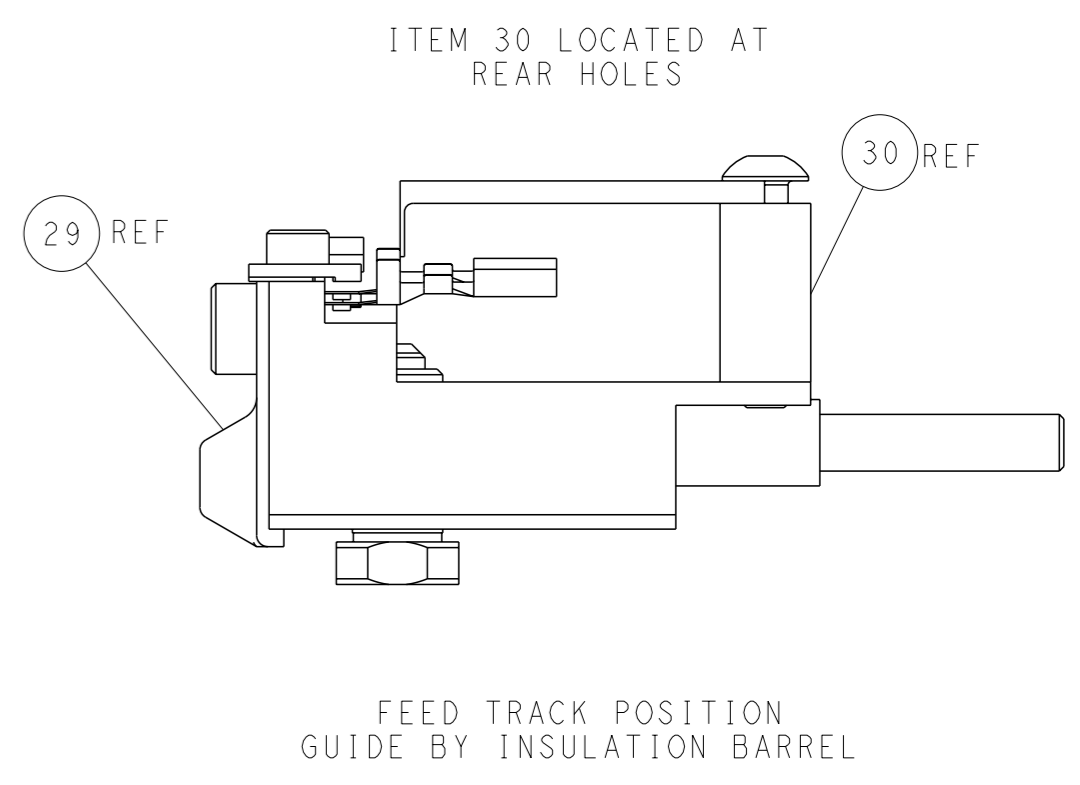
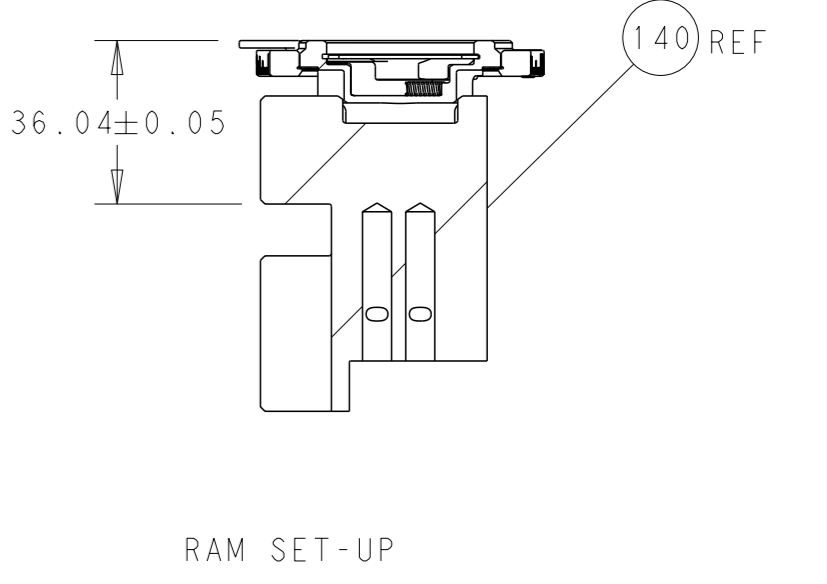
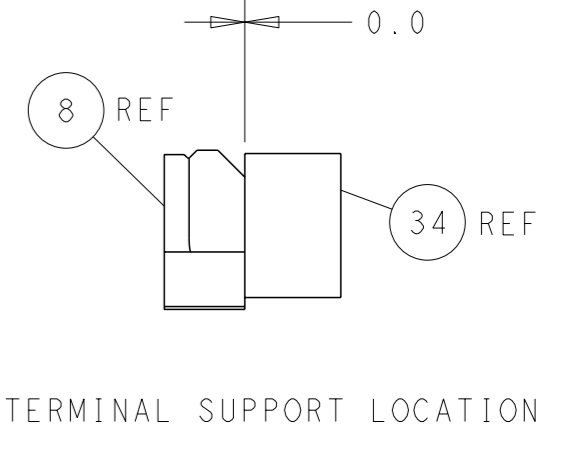
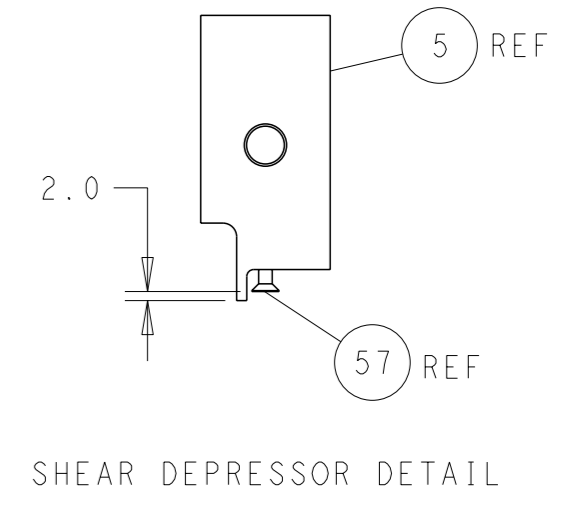
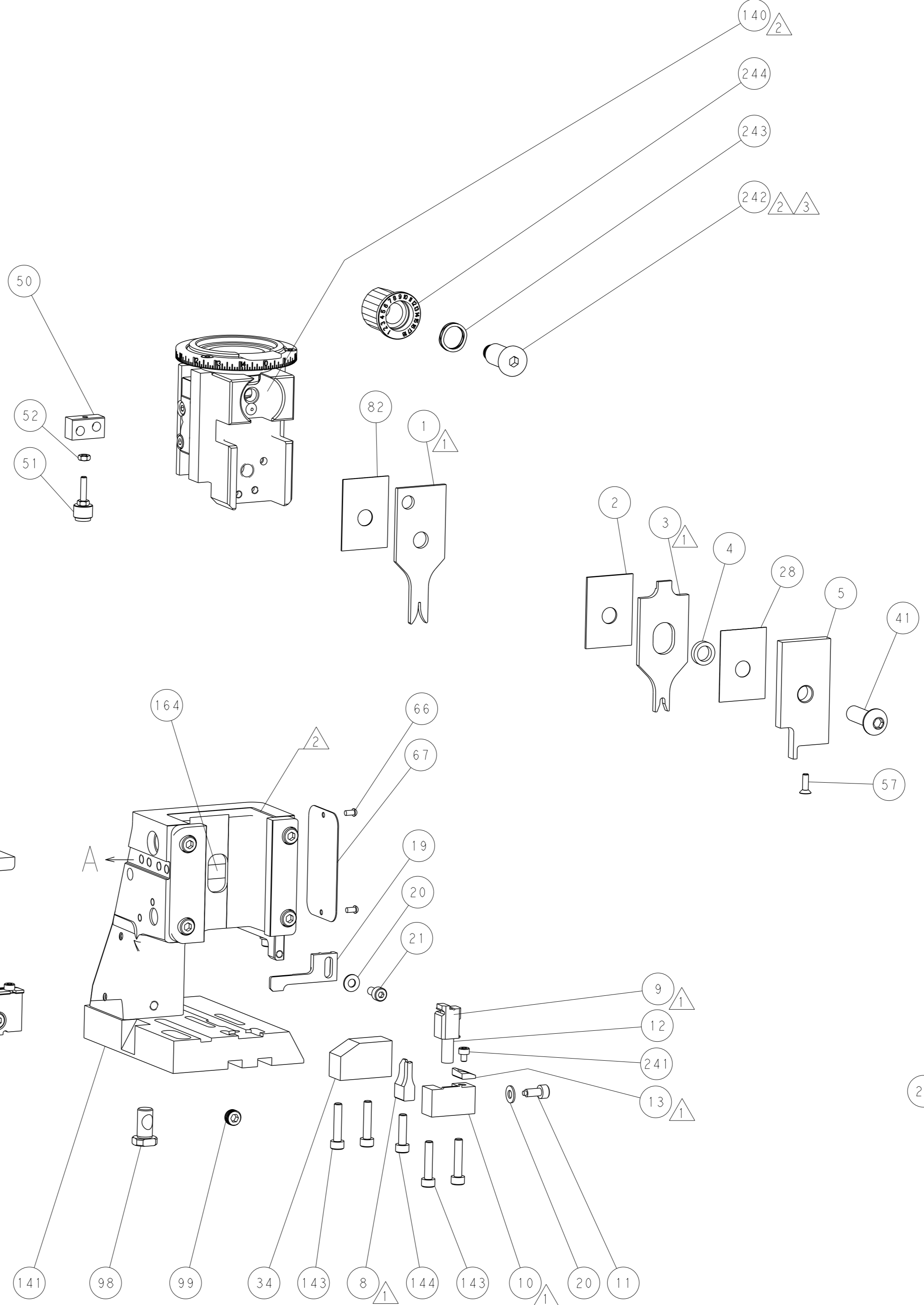
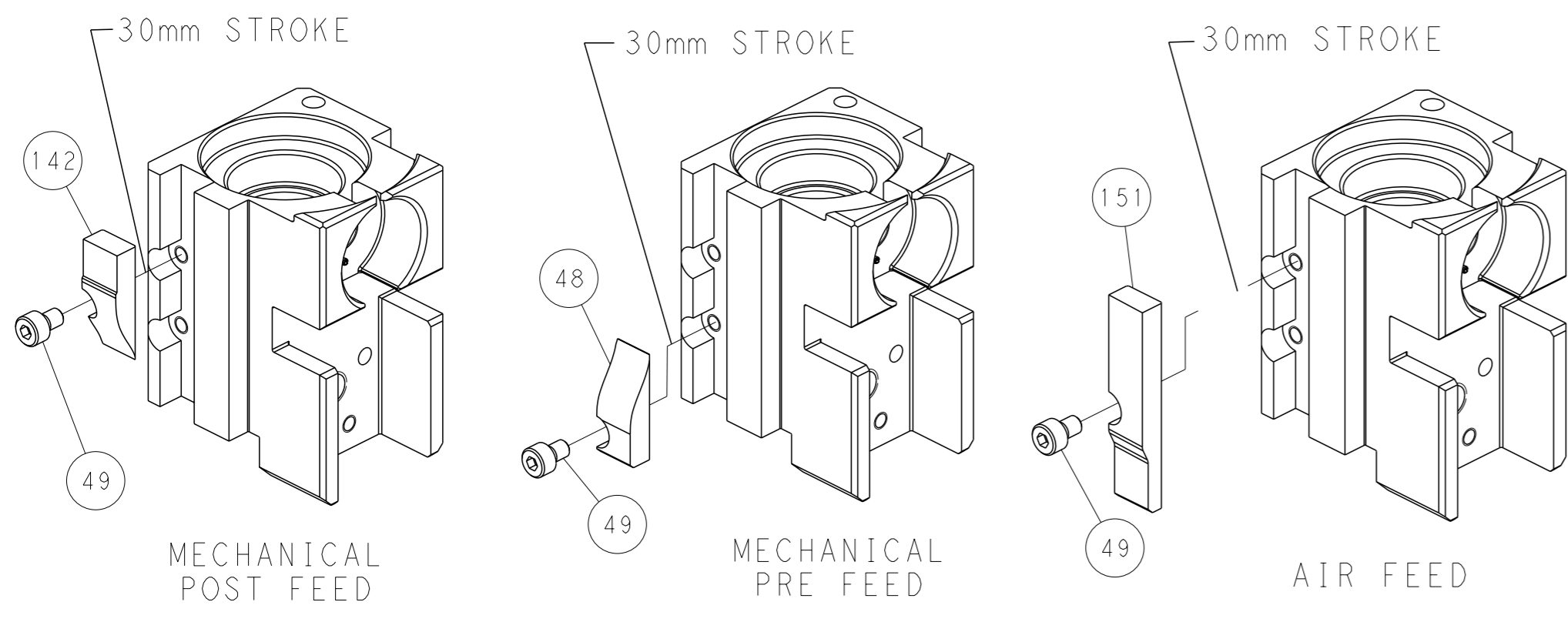
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN 05FEB2015 CHK: G. BAILEY 05FEB2015 APVD: H. GUO 05FEB2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH: *	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266589	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: D
MATERIAL: -		Customer Accessible Production Drawing	