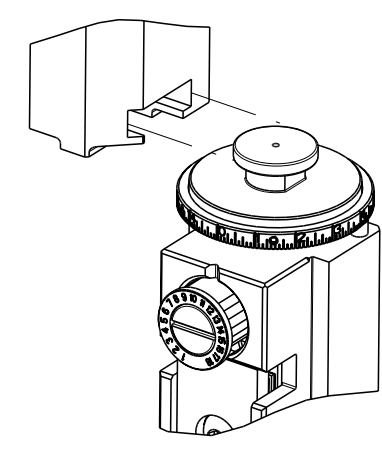


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266466-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266466-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266466-1	B	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266466-2	B	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266466-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266466-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266466-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.91 mm [.075]	F
INSUL	3.25 mm [.128]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION

TERMINAL NAME: LKS 1.5 ELA-U

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
11.00-12.00 mm [.433-.472 IN]	Ø

TERMINAL APPLICATION SPECIFICATION DOC00074179 ATTACHMENT 1, ATTACHMENT 2, ATTACHMENT 3

TERMINALS APPLIED

TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL	CABLE DIAMETER
1572439-1	22124472200	1572751-1	10800444521	Ø1.4-2.2
1572439-2	22125472200			
1572439-3	22140472200			
2113574-1	10124472580			
2113574-2	10125472580			
2113574-3	10140472580			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.34 +/- 0.03 [.053 +/- .001]	7.4
18 AWG OR 0.80mm2	1.33 +/- 0.03 [.052 +/- .001]	7.5
0.75mm2	1.32 +/- 0.03 [.052 +/- .001]	7.6
20 AWG OR 0.56mm2	1.26 +/- 0.03 [.050 +/- .001]	8.2
0.50mm2	1.20 +/- 0.03 [.047 +/- .001]	8.9

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

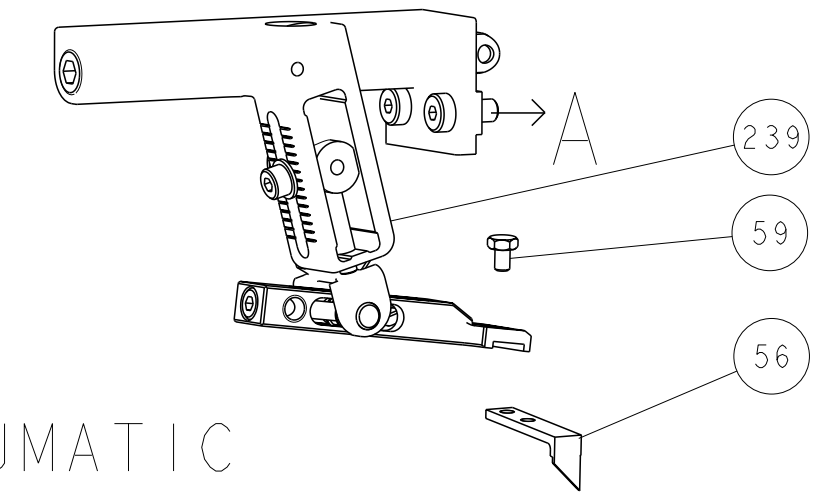
LOC	DIST	REV	DATE	OWN	APVD
A	66	A	07OCT2014	LG	GB
		B	11SEP2019	LG	RR

REV	DATE	DESCRIPTION	ITEM NO	
-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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
-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	1-1752354-9	STANDOFF, HOLD-DOWN	180
-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1338685-1	PAWL, FEED	56
-	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	811242-5	BUMPER, HOLD DOWN	51
-	1	690753-2	SPACER, TONKER	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	1	1320928-2	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	1803171-6	ANVIL, COMBINATION	8
-	1	3-240641-8	SPACER	7
-	-	-	-	6
-	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	3-1803018-3	CRIMPER, INSULATION O	3
-	1	1-455888-1	SPACER, CRIMPER	2
-	1	2-1490019-9	CRIMPER, WIRE PREMIUM	1

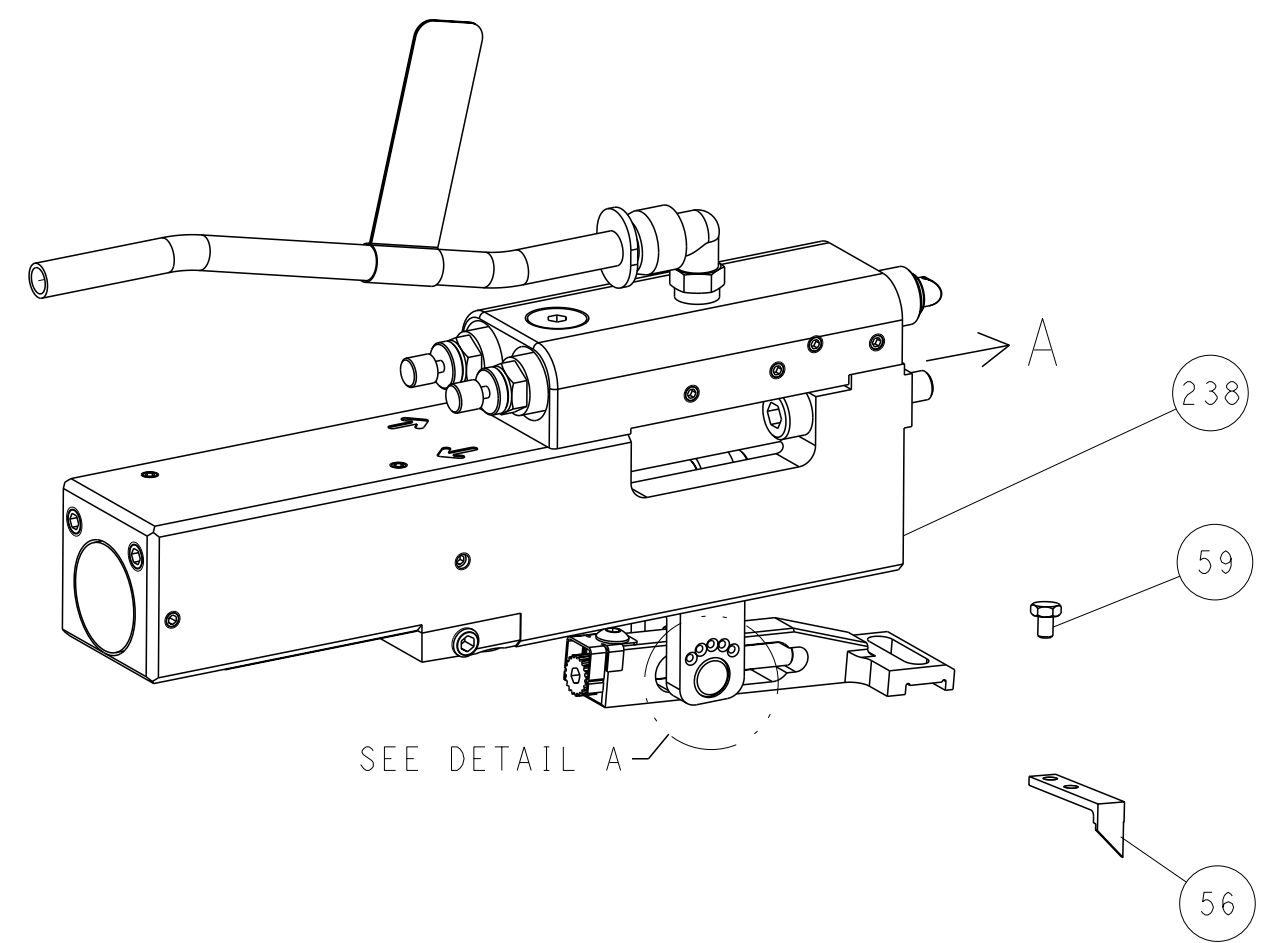
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MATERIAL:	FINISH:	APVD	U. GUO	22AUG2014	Customer Accessible Production Drawing	SCALE 1:2 SHEET 1 OF 4 REV B

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

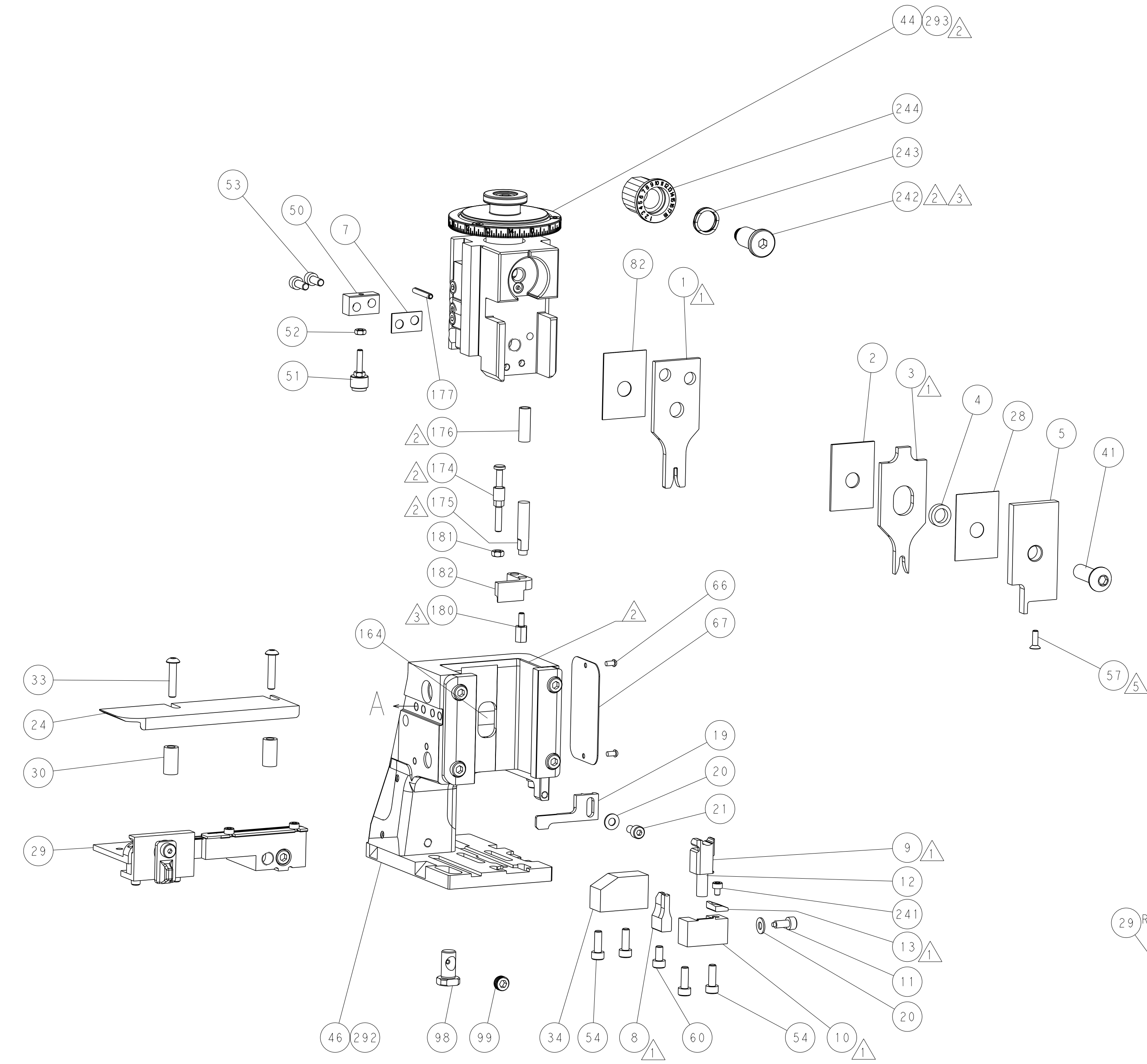
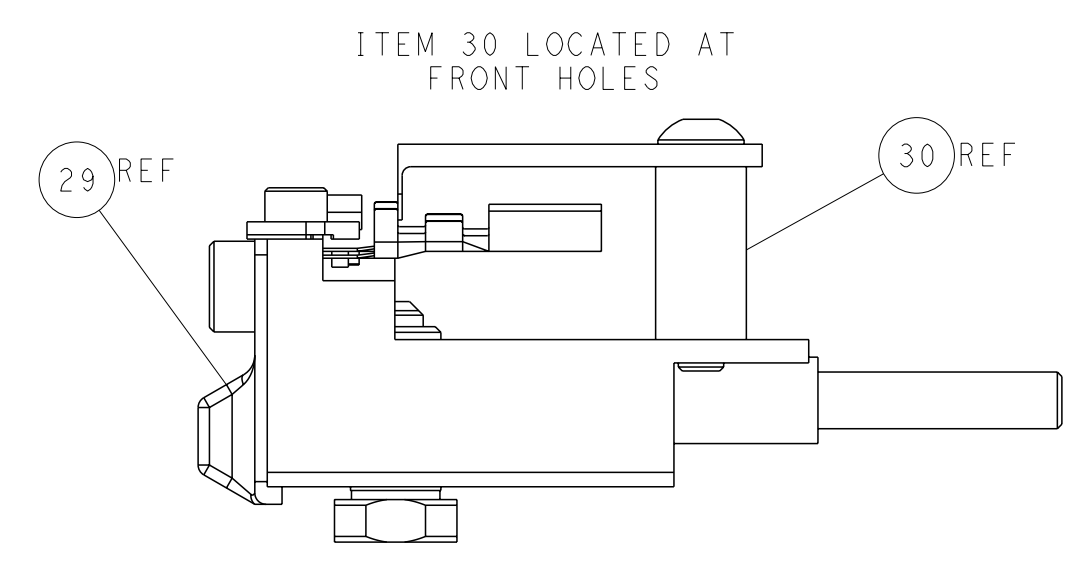
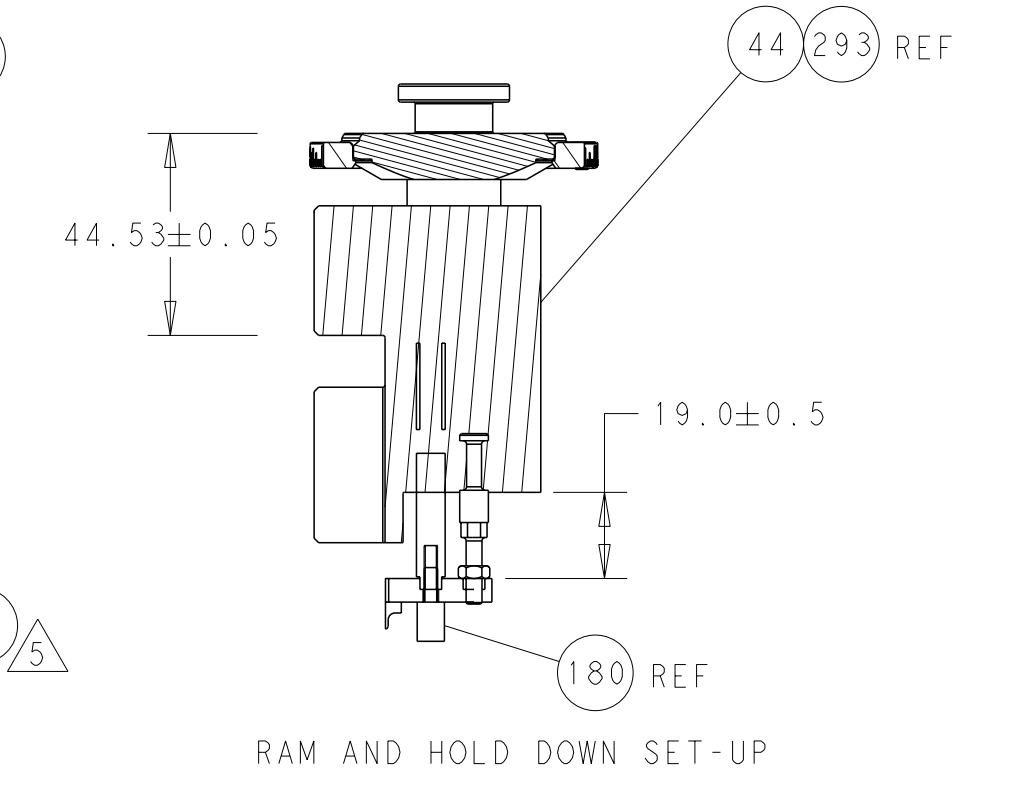
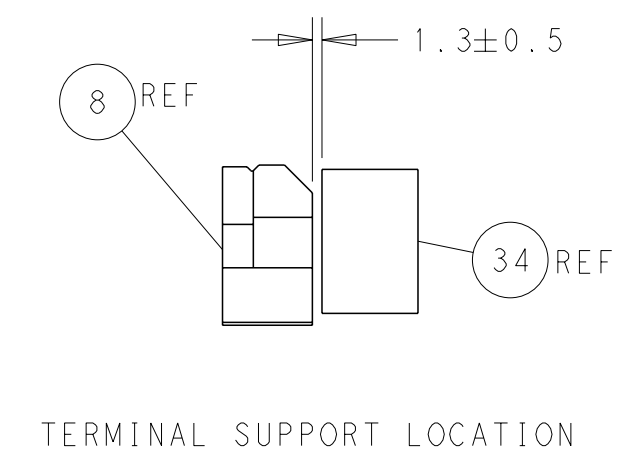
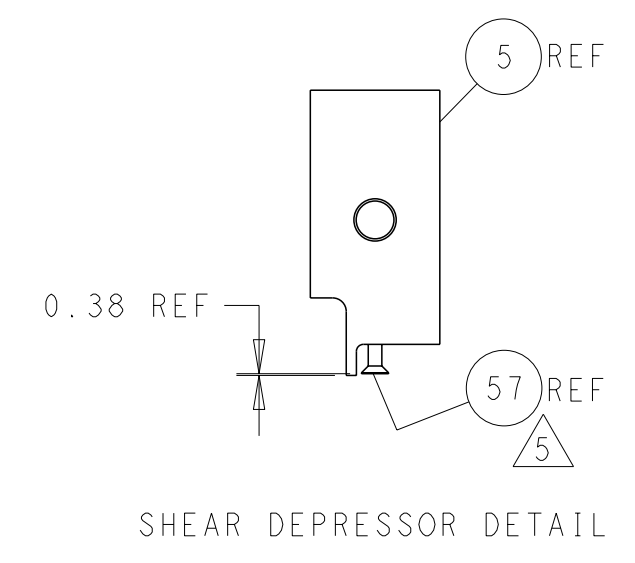
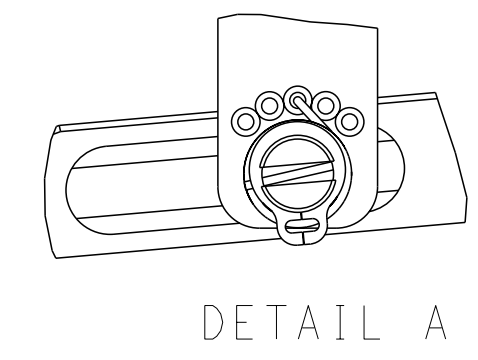
FEED TYPE MECHANICAL



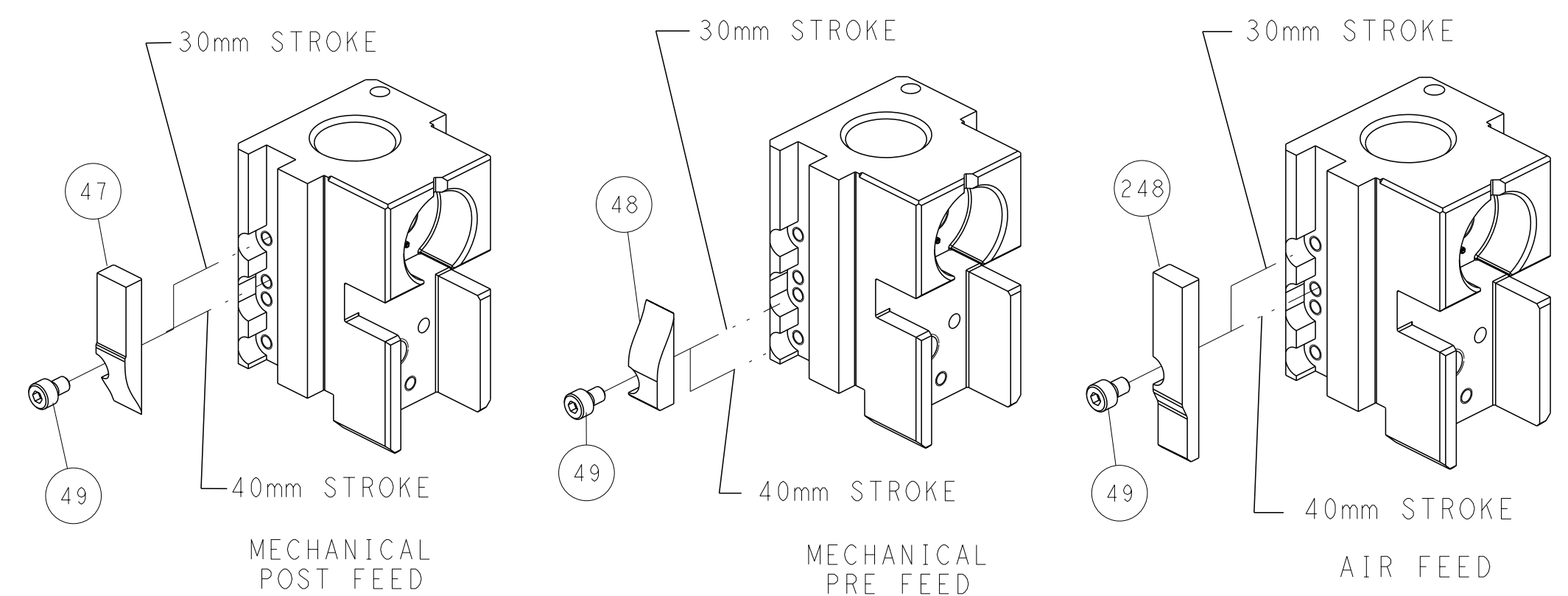
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS

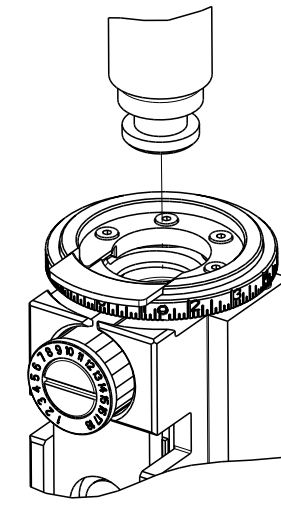


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN 22AUG2014 CHK: G. BAILEY 22AUG2014 APVD: H. GUO 22AUG2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266466 SCALE: 1:2 SHEET: 2 of 4 REV: B
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ±	MATERIAL:	WEIGHT:	RESTRICTED TO:

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266466-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266466-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266466-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.91 mm (.075)	F
INSUL	3.25 mm (.128)	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: LKS 1.5 ELA-U	
WIRE STRIP LENGTH 11.00-12.00 mm (.433-.472 IN)	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION DOC00074179 ATTACHMENT 1, ATTACHMENT 2, ATTACHMENT 3	

TERMINALS APPLIED				
TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL	CABLE DIAMETER
1572439-1	22124472200	1572751-1	10800444521	Ø1.4-2.2
1572439-2	22125472200			
1572439-3	22140472200			
2113574-1	10124472580			
2113574-2	10125472580			
2113574-3	10140472580			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.34+/-0.03 [.053+/-0.001]	7.4
18 AWG OR 0.80mm2	1.33+/-0.03 [.052+/-0.001]	7.5
0.75mm2	1.32+/-0.03 [.052+/-0.001]	7.6
20 AWG OR 0.56mm2	1.26+/-0.03 [.050+/-0.001]	8.2
0.50mm2	1.20+/-0.03 [.047+/-0.001]	8.9



- 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.
- 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.
- 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)

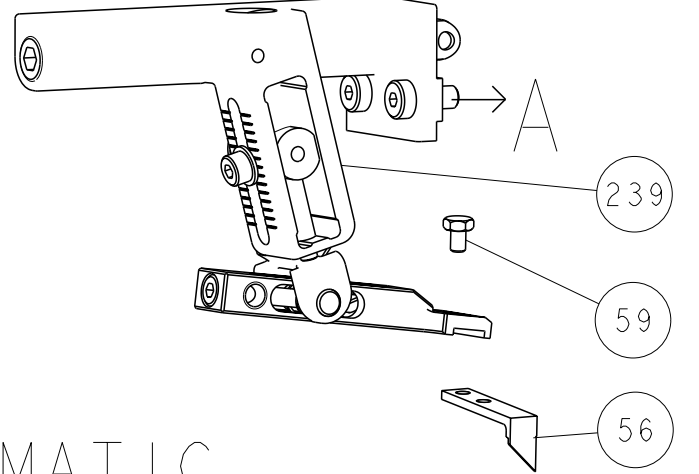
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

-	1	1	2119082-3	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	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
5	-	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	1752356-6	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	2844992-2	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
-	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	1803171-6	ANVIL, COMBINATION	8
-	1	1	3-240641-8	SPACER	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	3-1803018-3	CRIMPER, INSULATION O	3
-	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	1	2-1490019-9	CRIMPER, WIRE PREMIUM	1

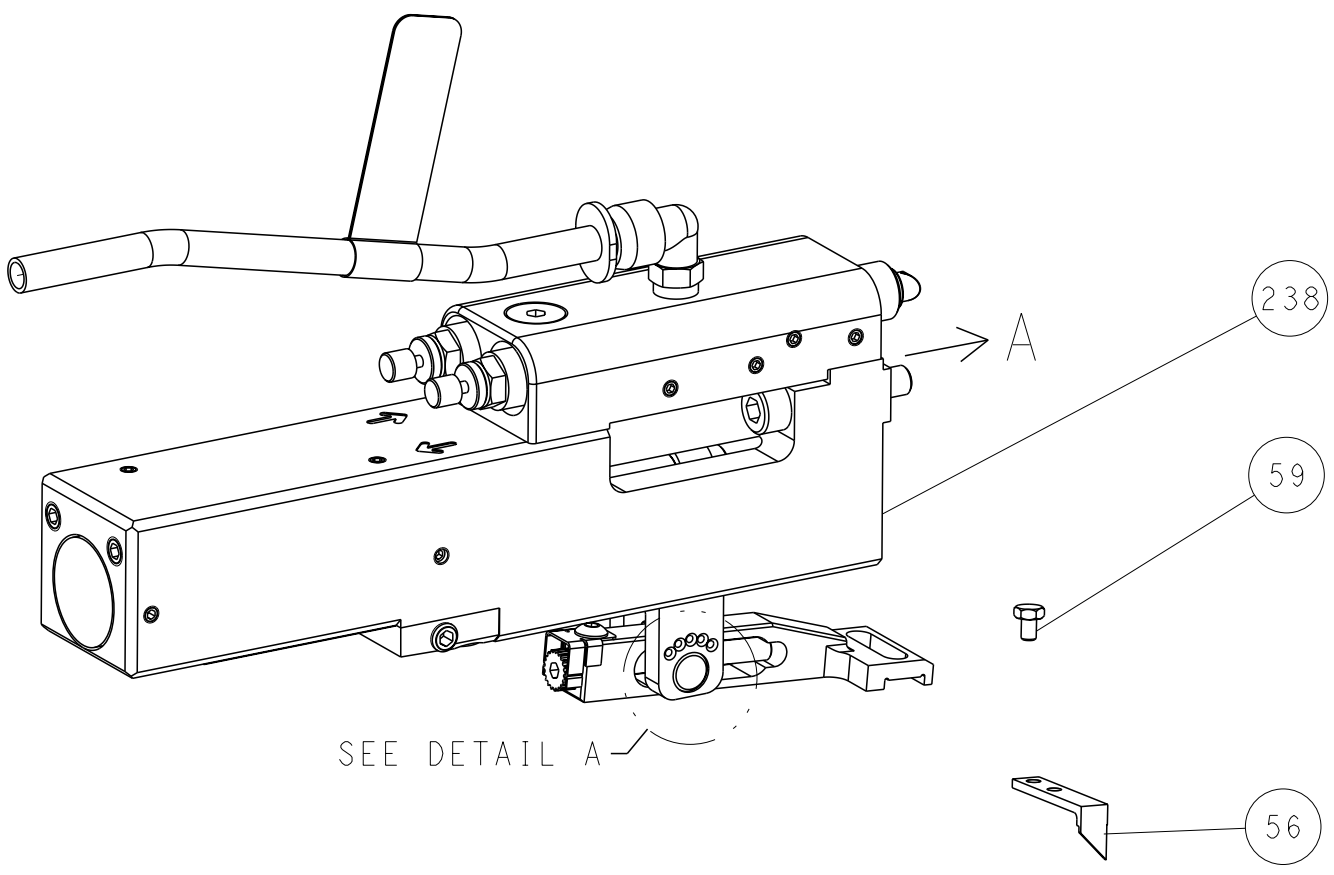
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mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK G. BAILEY 22AUG2014	Harrisburg, PA 17105-3608
	3 PLC ±	4 PLC ±	ANGLES FINISH	APVD U. GUO 22AUG2014	
MATERIAL				PRODUCT SPEC	NAME
				APPLICATION SPEC	Ocean Side Feed Applicator
				WEIGHT	SIZE CAGE CODE DRAWING NO RESTRICTED TO
					A1 00779 C=2266466
				Customer Accessible Production Drawing	SCALE 1:2 SHEET 3 OF 4 REV B

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-

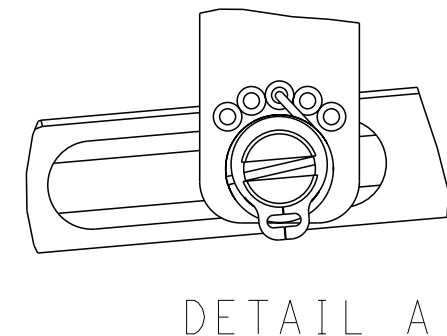
FEED TYPE MECHANICAL



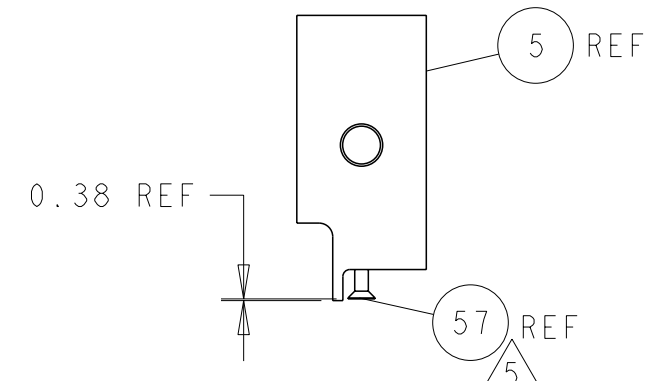
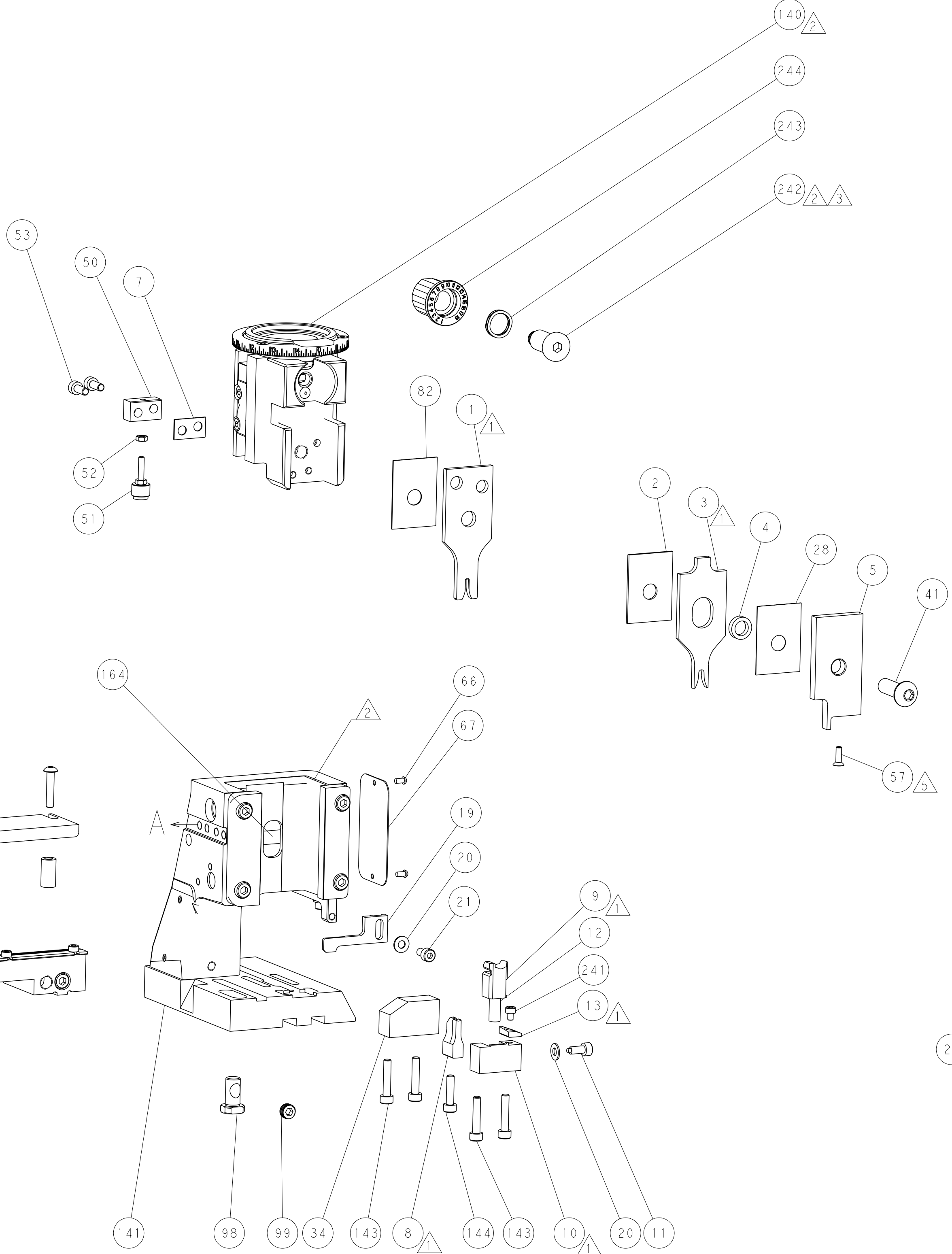
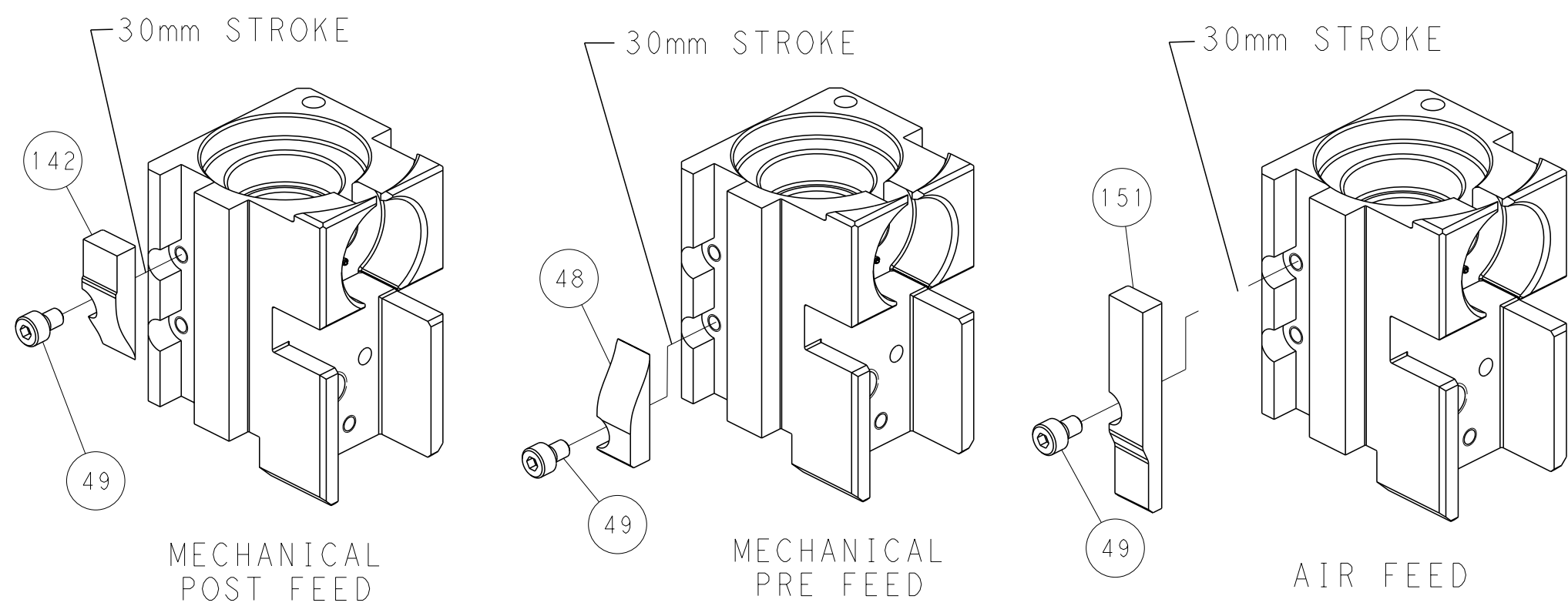
PNEUMATIC



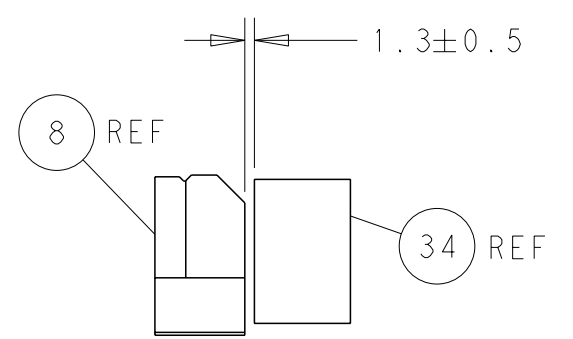
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



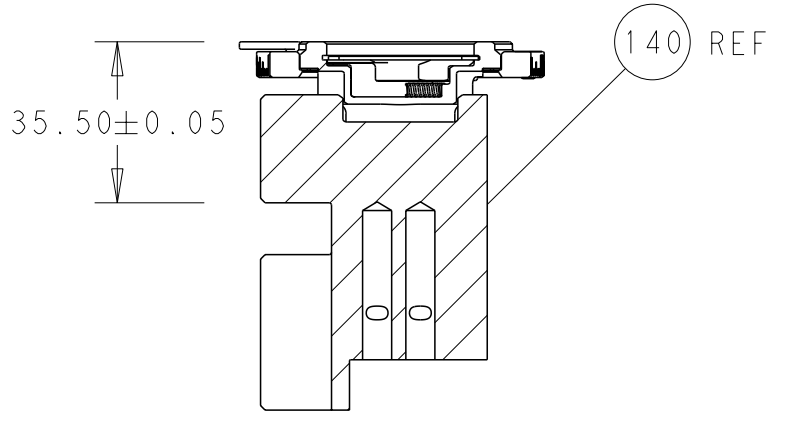
CAM POSITIONS



SHEAR DEPRESSOR DETAIL

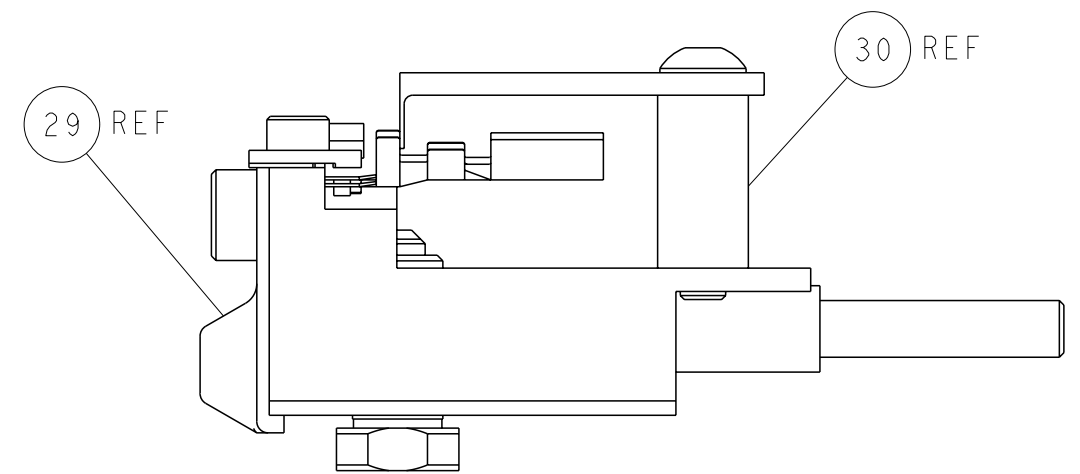


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN 22AUG2014 CHK: G. BAILEY 22AUG2014 APVD: H. GUO 22AUG2014	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266466	RESTRICTED TO: - SHEET 4 OF 4 REV B