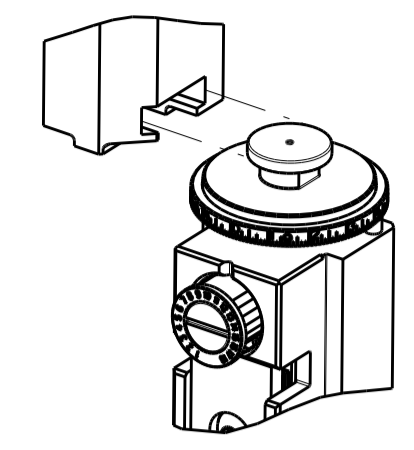


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266546-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266546-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266546-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266546-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266546-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

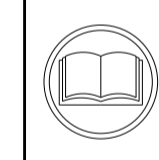


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [.140]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: REC, FASTON, PIGGYBACK, .110 SRS			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
4.32-4.32 mm [.170-.170 IN]	Ø2.03-3.05 mm [.080-.120 IN]	5	
TERMINAL APPLICATION SPECIFICATION	114-2082		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62003-1	62003-4	63961-1	1217083-1
62003-2	63242-1	1217145-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.17+/-0.05 [.046+/- .002]	5.8
20 AWG	1.02+/-0.05 [.040+/- .002]	7.6
22 AWG	0.94+/-0.05 [.037+/- .002]	8.5



- 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 INSULATION RANGE OF 62003 IS .060-.100 IN.
- 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		1		DEVELOPMENT	16OCT2014	KH	UG
		A		RELEASED	20NOV2014	RK	GB
		B		ECR-19-001127	23JAN2019	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	2119082-3	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	-	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	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	1803607-1	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	1338685-1	PAWL, FEED	56	
-	2	2	2	2	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	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	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	1803095-1	FLOATING SHEAR, FRONT	9	
1	2	2	1	1	6-1333203-8	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	1803018-8	CRIMPER, INSULATION O	3	
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
1	2	2	1	1	1-456404-8	CRIMPER, WIRE PREMIUM	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

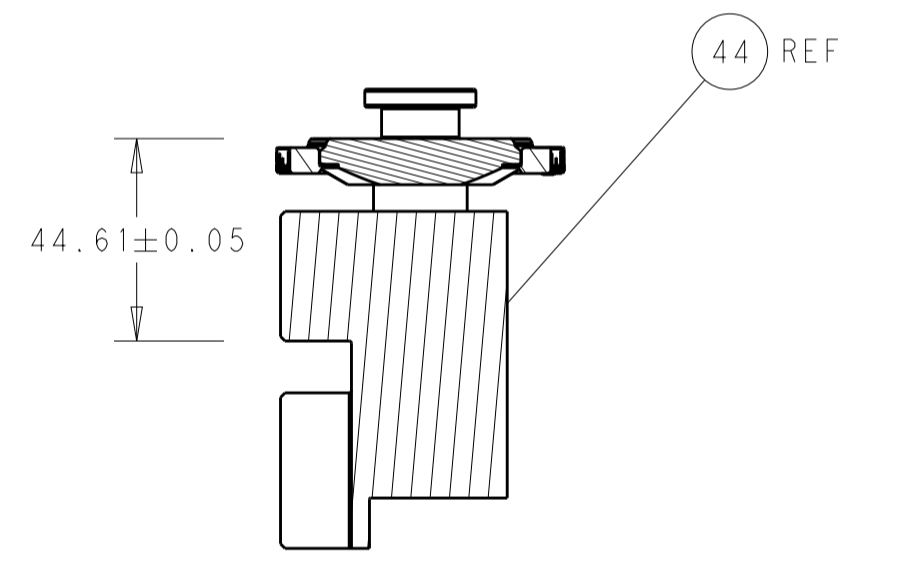
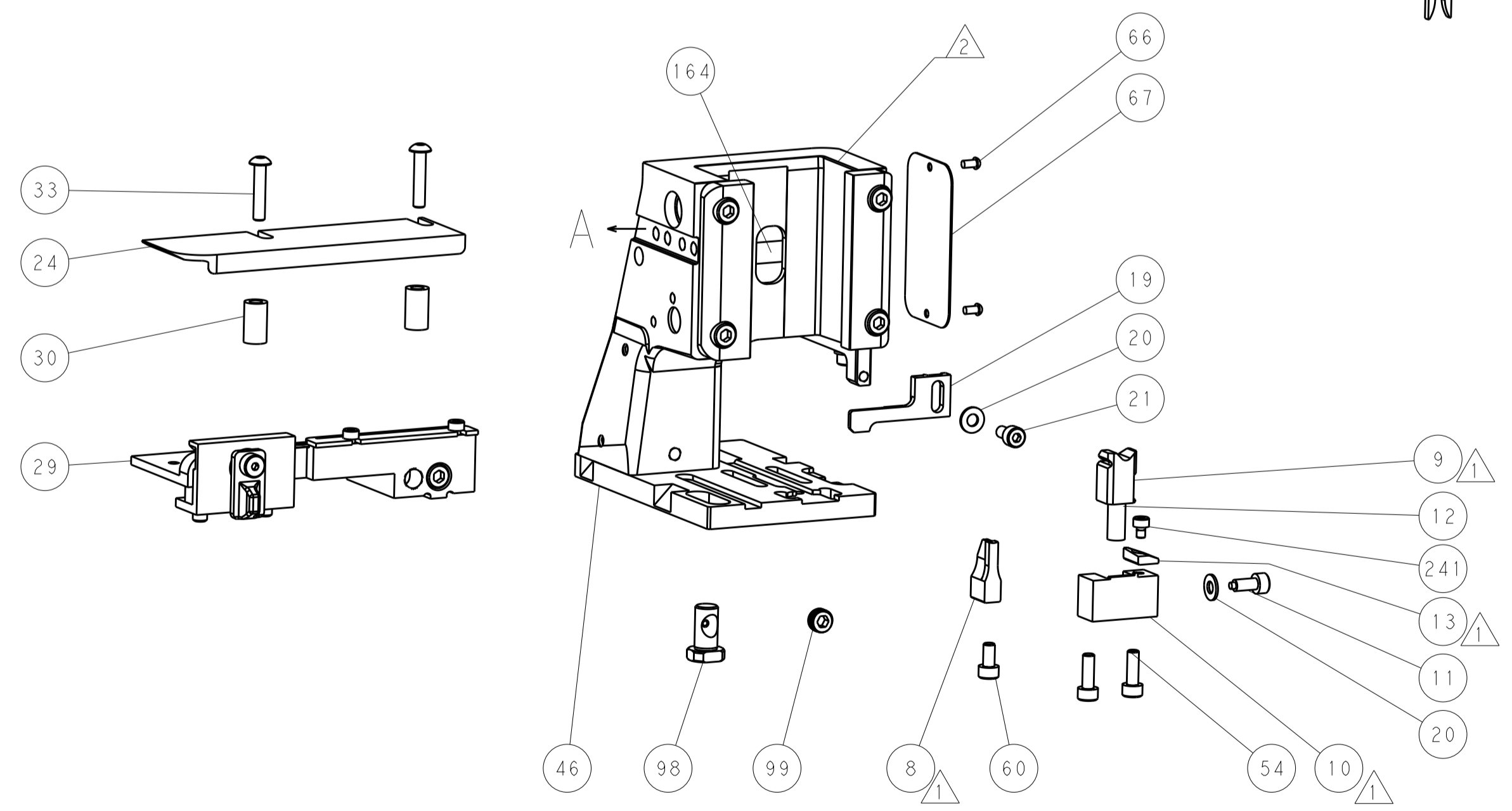
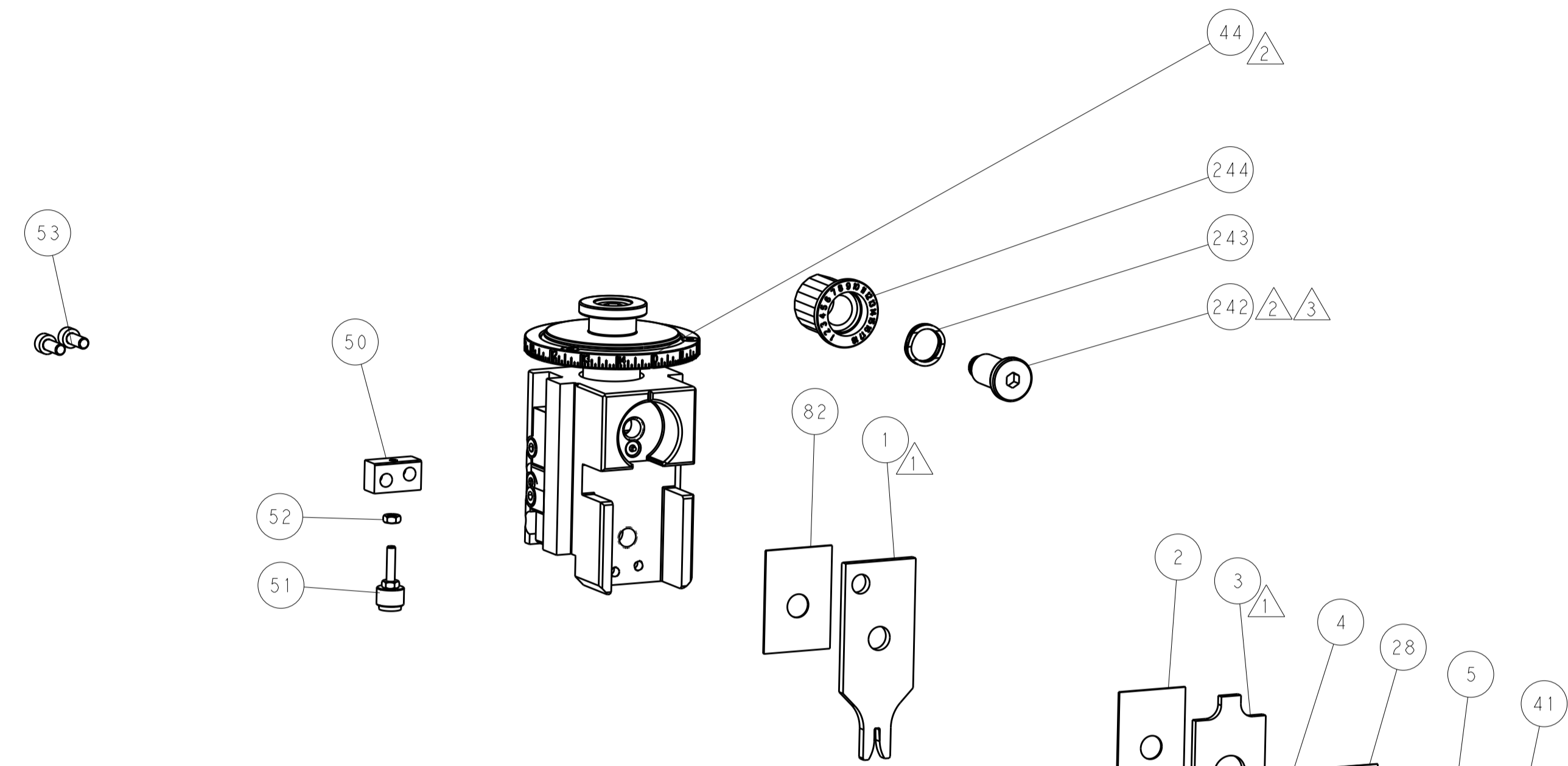
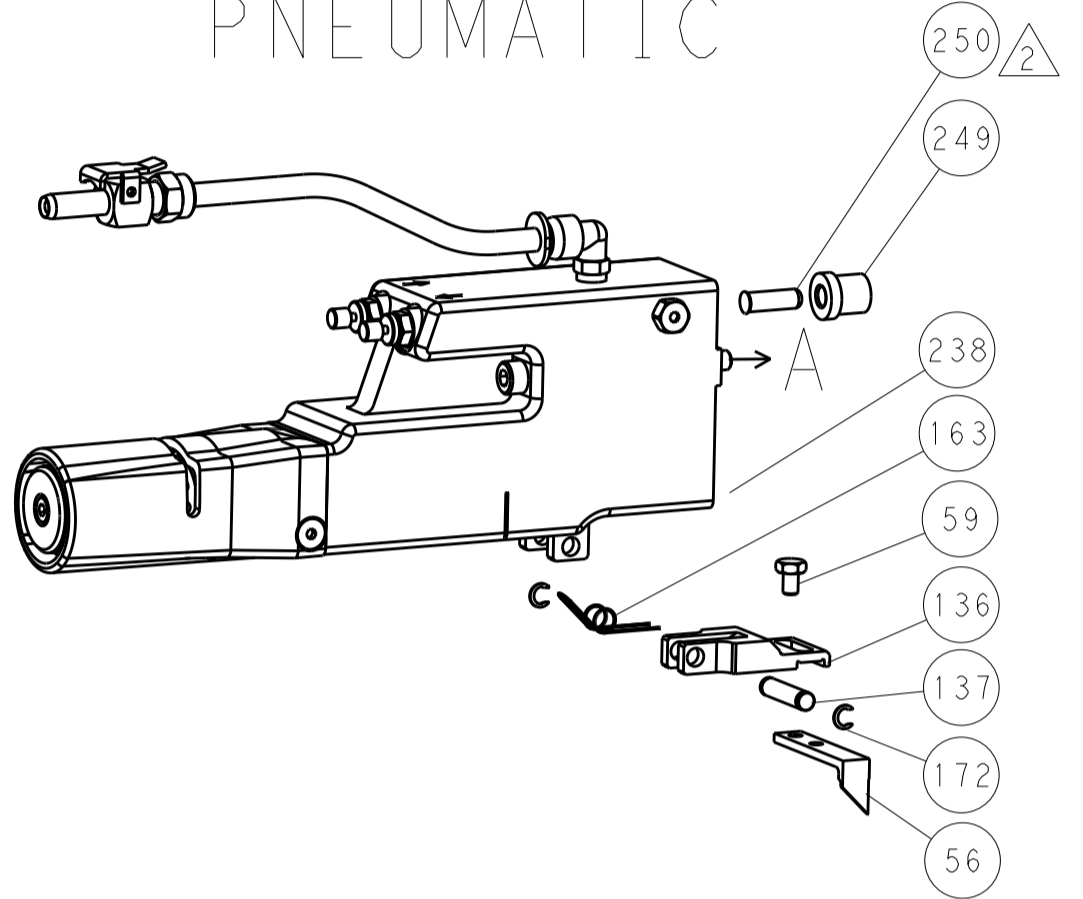
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN H. HUANG CHK L. ZHANG APVD J. GUO		16OCT2014 16OCT2014 16OCT2014		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	±	±	NAME Ocean Side Feed Applicator		SIZE A1		CAGE CODE 00779	
MATERIAL		FINISH		WEIGHT		SCALE 1:2		SHEET 1 of 4	
						REV B		Customer Accessible Production Drawing	

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

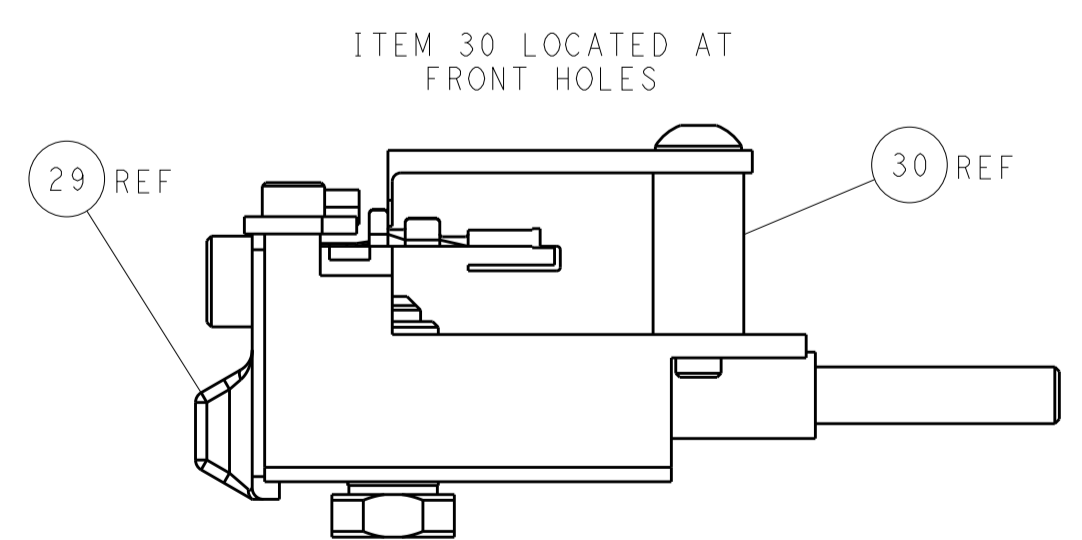
FEED TYPE MECHANICAL



PNEUMATIC

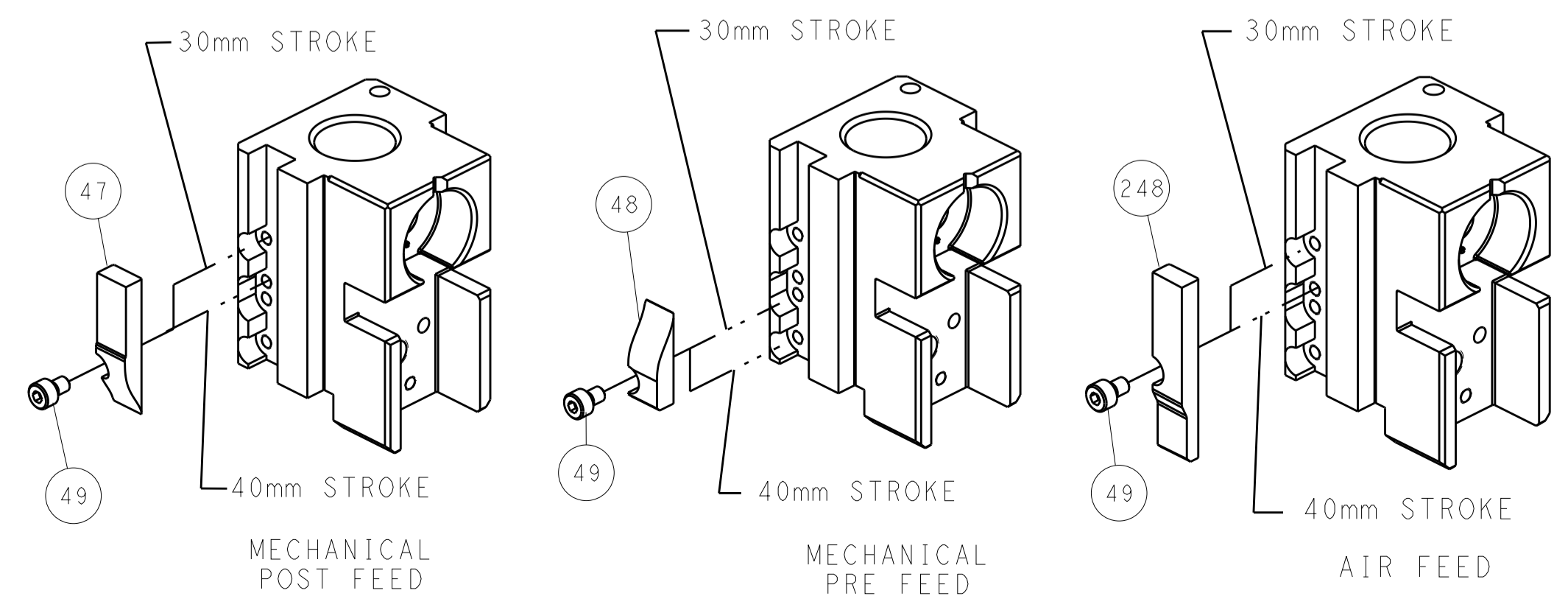


RAM SET-UP



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:		DWN H. HUANG 16OCT2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	CHK L. ZHANG 16OCT2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD H. GUO 16OCT2014		NAME	
				PRODUCT SPEC		Ocean Side Feed	
				APPLICATION SPEC		Applicator	
				WEIGHT		SIZE CAGE CODE DRAWING NO	
				Customer Accessible Production Drawing		A1 00779 ©=2266546	
				SCALE		RESTRICTED TO	
				1:2		SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266546-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266546-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266546-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [.140]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: REC, FASTON, PIGGYBACK, .110 SRS			
WIRE STRIP LENGTH 4.32-4.32 mm [.170-.170 IN]		INSULATION DIAMETER RANGE Ø2.03-3.05 mm [.080-.120 IN] ⁵	
TERMINAL APPLICATION SPECIFICATION	114-2082	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62003-1	62003-4	63961-1	1217083-1
62003-2	63242-1	1217145-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁴
18 AWG	1.17+/-0.05 [.046+/-0.002]	5.8
20 AWG	1.02+/-0.05 [.040+/-0.002]	7.6
22 AWG	0.94+/-0.05 [.037+/-0.002]	8.5

***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.

- 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 INSULATION RANGE OF 62003 IS .060-.100 IN.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REV	DATE	BY	APPD
A	66	-	-	-	-

REV	DATE	BY	APPD	DESCRIPTION	ITEM NO	
-	1	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	-	1803259-1	BUSHING, FLANGED	249
-	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	-	-	2063440-1	AIR FEED MODULE	238
-	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
-	2	2	-	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
-	1	1	-	2844908-1	SCREW, LOCKING	99
-	1	1	-	2844907-1	POST, LOCKING	98
-	1	1	-	455888-5	SPACER, CRIMPER	82
-	1	1	-	1803607-1	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	-	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
-	2	2	-	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	-	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	-	2844992-1	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	-	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	6-1333203-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	-	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	-	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1	1803018-8	CRIMPER, INSULATION O	3
-	1	1	-	455888-6	SPACER, CRIMPER	2
-	1	1	1	1-456404-8	CRIMPER, WIRE PREMIUM	1

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:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

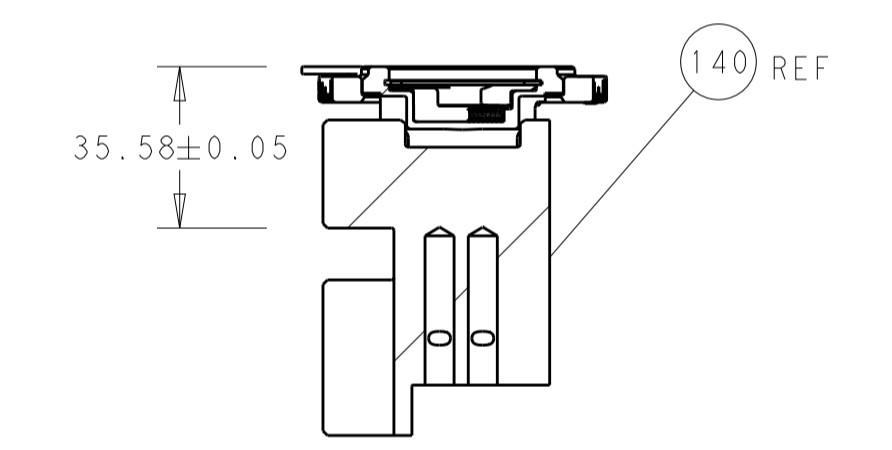
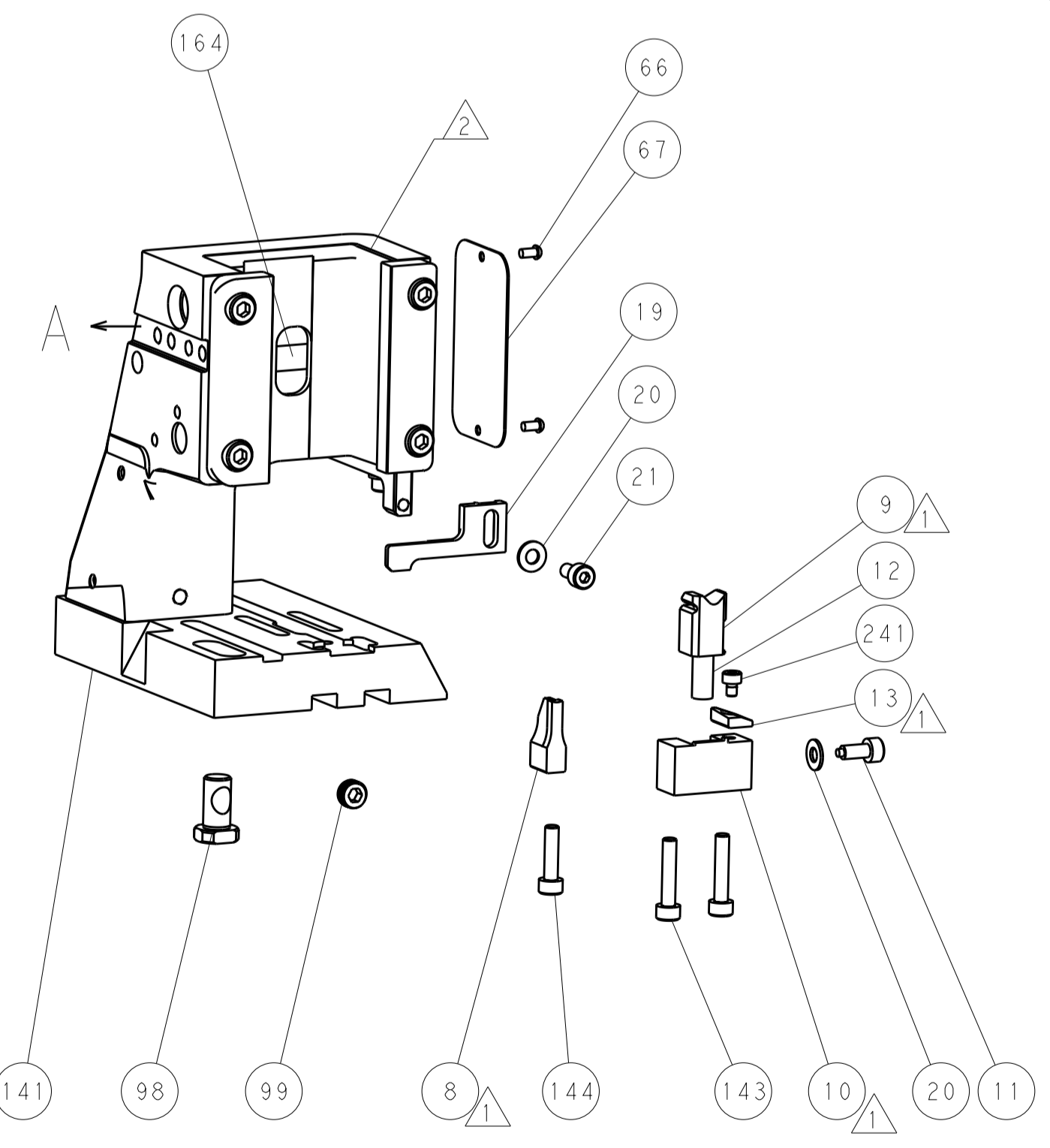
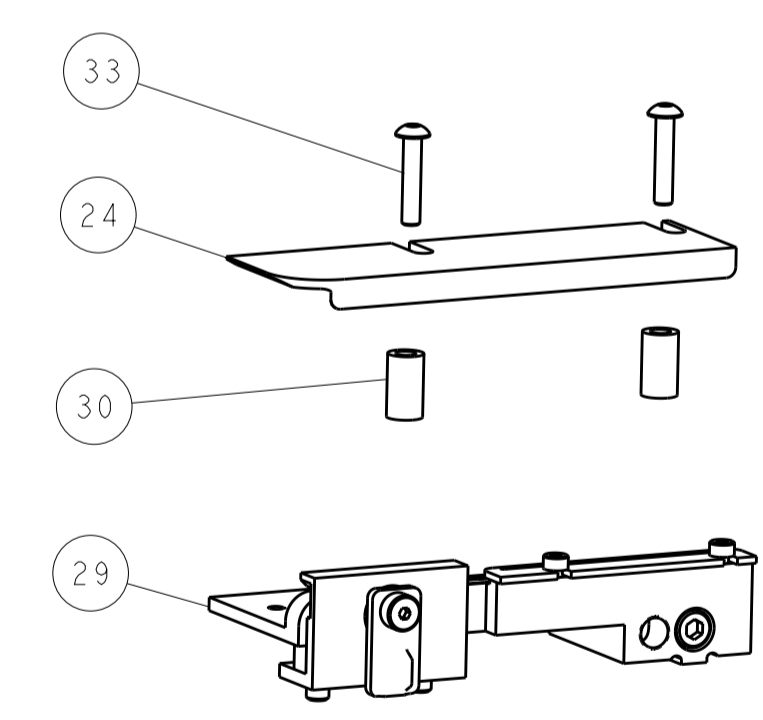
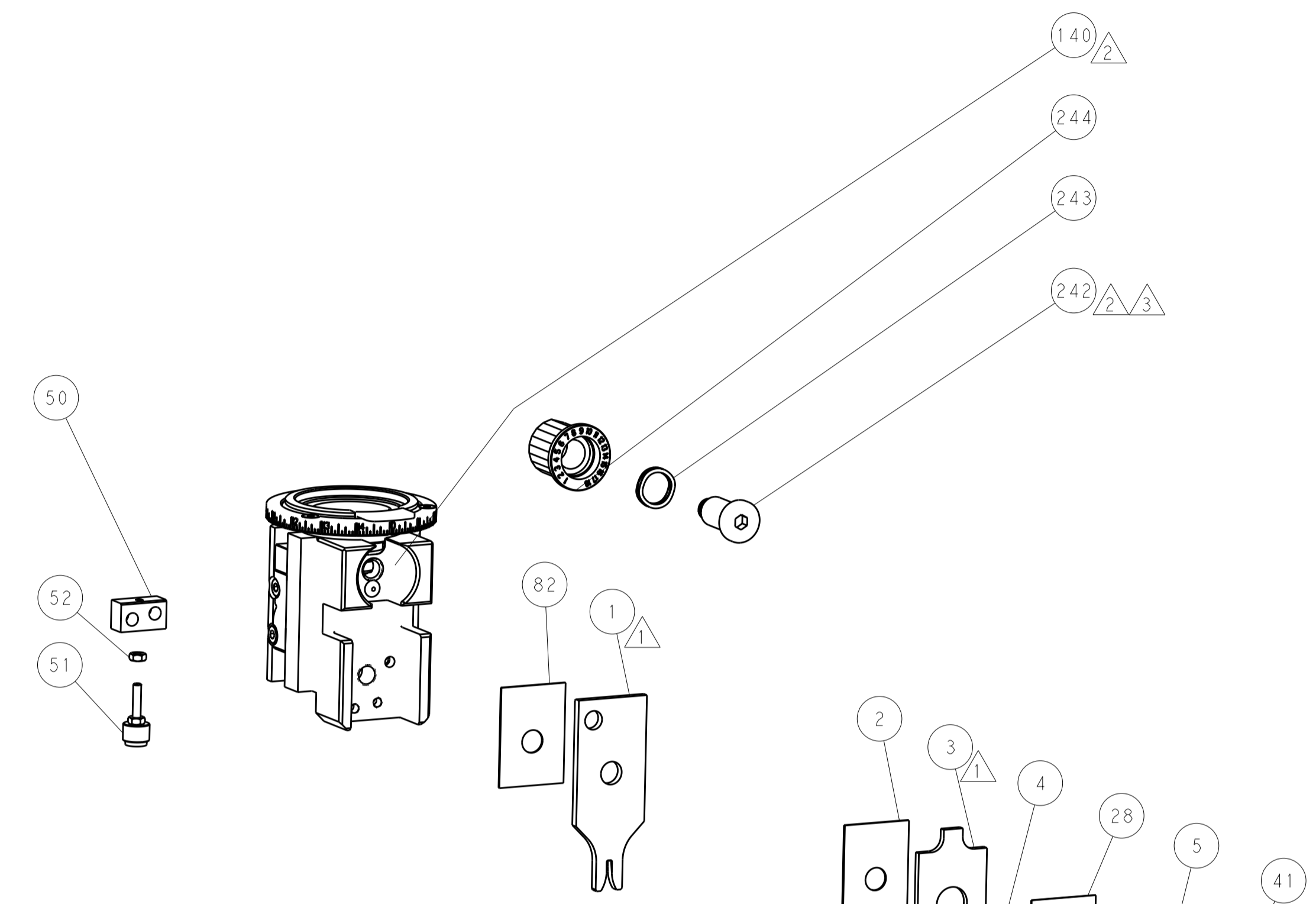
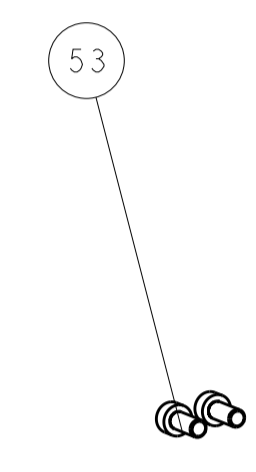
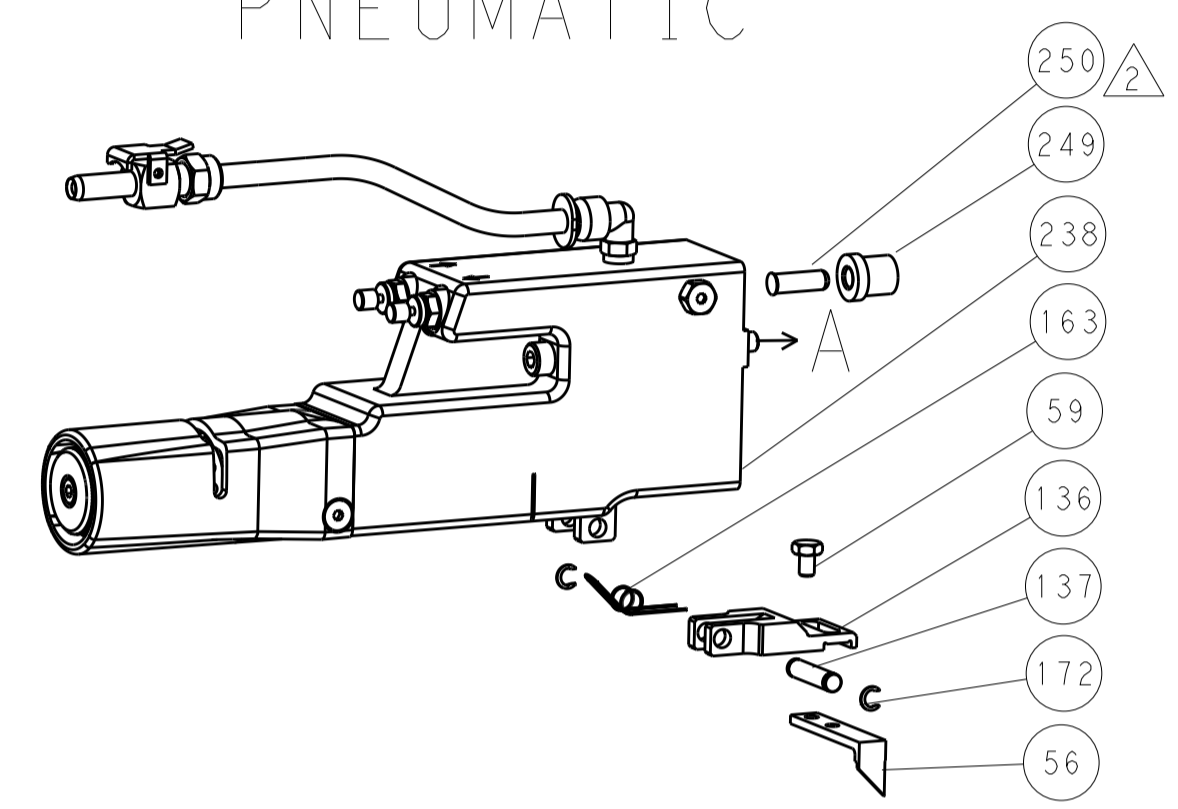
DRW	CH	16OCT2014	16OCT2014
CHK	L. ZHANG		
APVD	J. GUO	16OCT2014	
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266546	
Customer Accessible Production Drawing		SCALE	SHEET 3 OF 4
		1:2	REV B

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

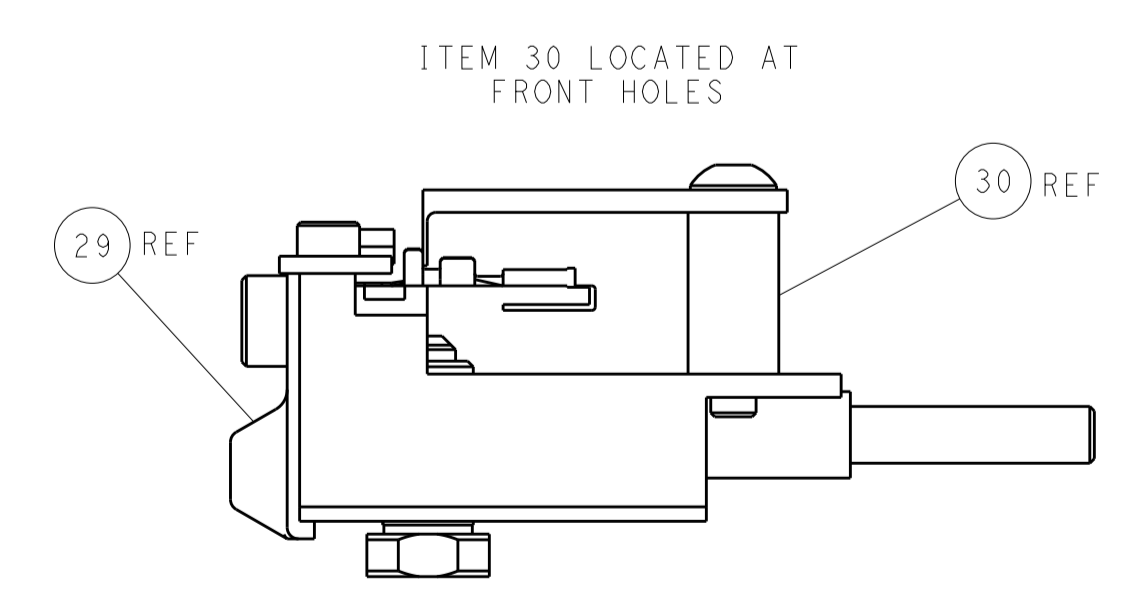
FEED TYPE MECHANICAL



PNEUMATIC

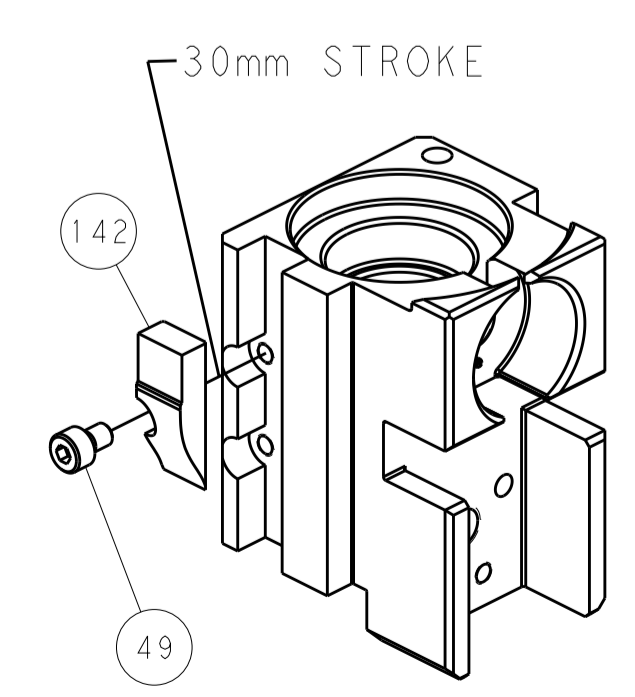


RAM SET-UP

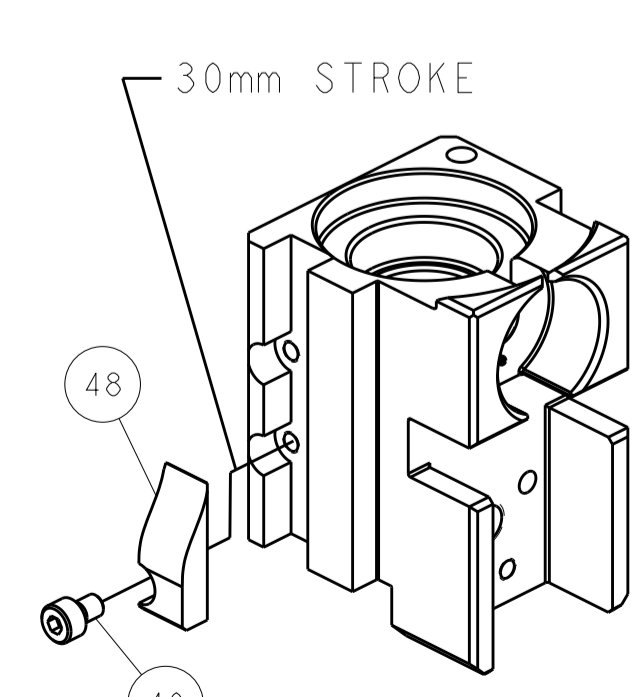


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

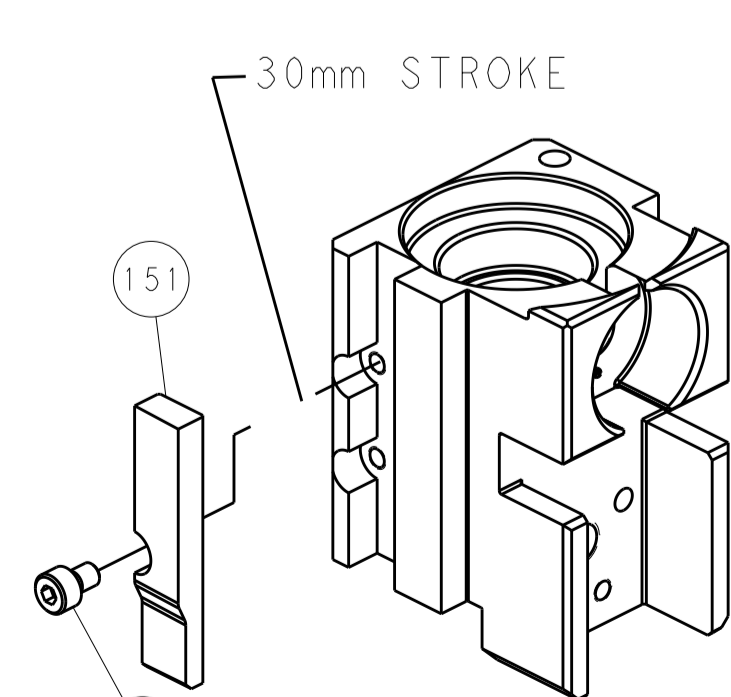
CAM POSITIONS



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG CHK L. ZHANG APVD H. GUO		16OCT2014 16OCT2014 16OCT2014		NAME Ocean Side Feed Applicator			
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	PRODUCT SPEC	APPLICATION SPEC		
MATERIAL								SIZE A1	CAGE CODE 00779		
Customer Accessible Production Drawing								SCALE 1:2	SHEET 4	OF 4	REV B