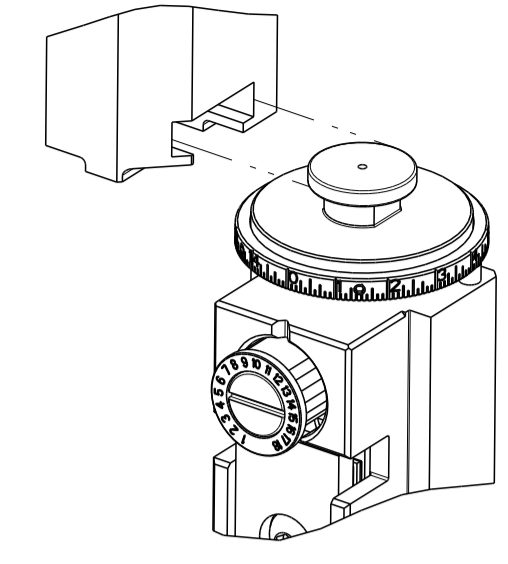


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266023-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266023-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266023-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266023-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266023-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.76 mm [1.030]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: AMPHENOL TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: OPEN END BARREL CONTACT PIN			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
0.17-0.19 mm [0.007-0.007 IN]	∅ -		
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	AMPHENOL TERMINAL	TE TERMINAL	AMPHENOL TERMINAL
2113368-1	X-X81-110-2828		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.711+0.025/-0 [1.028+0.001/-0]	5.0

- 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 ITEMS 180.
- 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. 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)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	17OCT2013	LG	TE
		B		ECR-20-003556	10MAR2020	FJ	TE

-	1	1	1	1	1803078-2	SPACER, PRECISION	259
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
3	-	1	1	1	1-1752354-0	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	7-459492-1	CRIMPER, WIRE O	178
-	1	1	1	1	993111-1	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
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
5	-	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	455888-8	SPACER, CRIMPER	82
-	1	1	1	1	547505-3	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-6	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
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	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	1-1901681-9	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	3-1752356-1	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	2844938-1	PLATE, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-5	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	1-1633933-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119780-3	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	2	2	1	1	7-1633609-9	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

APPROVED	DATE	APPROVED	DATE
H. HUANG	03SEP2013	L. ZHANG	03SEP2013
J. GUO	03SEP2013		

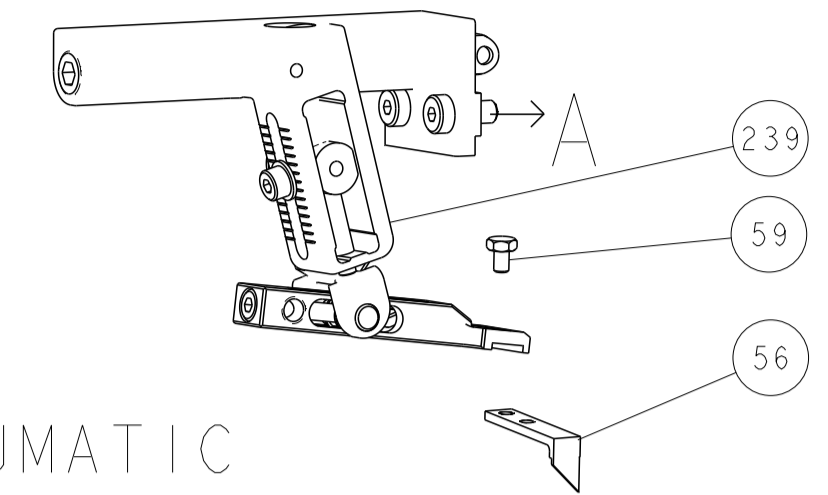
NAME	DESCRIPTION	ITEM NO
Ocean Side Feed Applicator		

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266023	

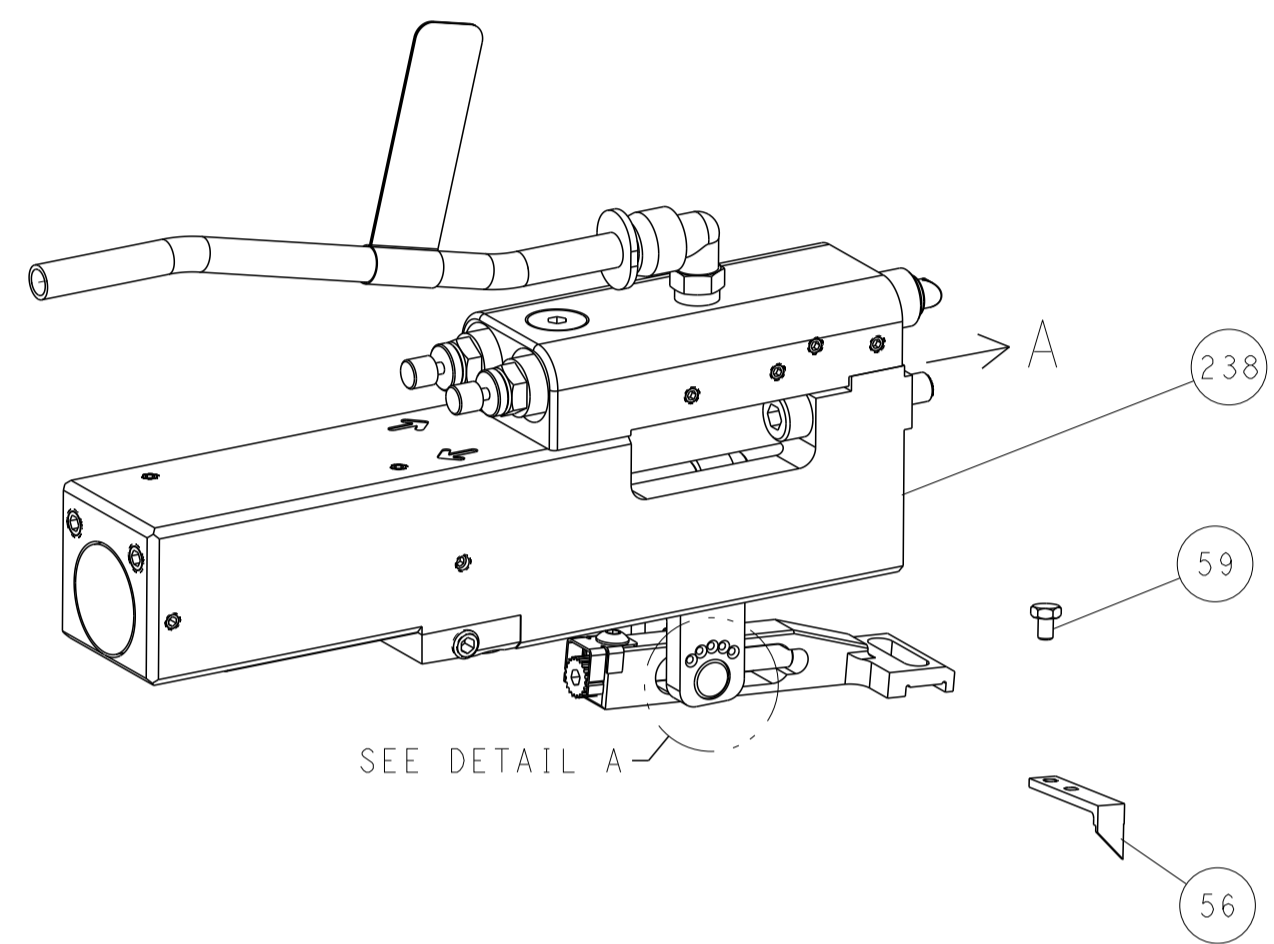
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV B

LOC	DIST	REVISIONS					
A	66	P	LYN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

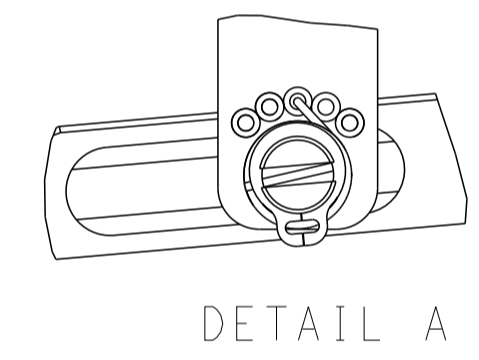
FEED TYPE MECHANICAL



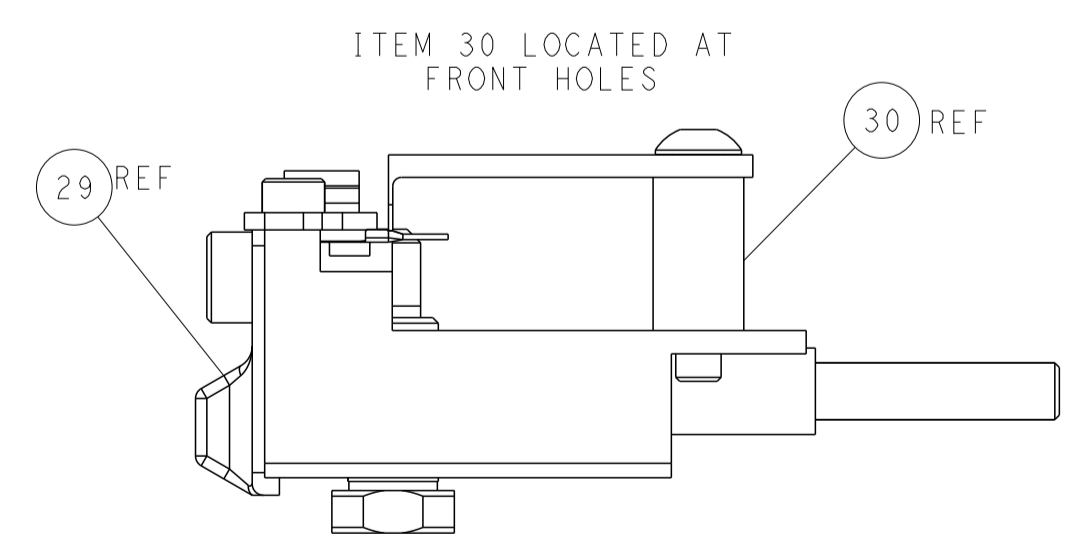
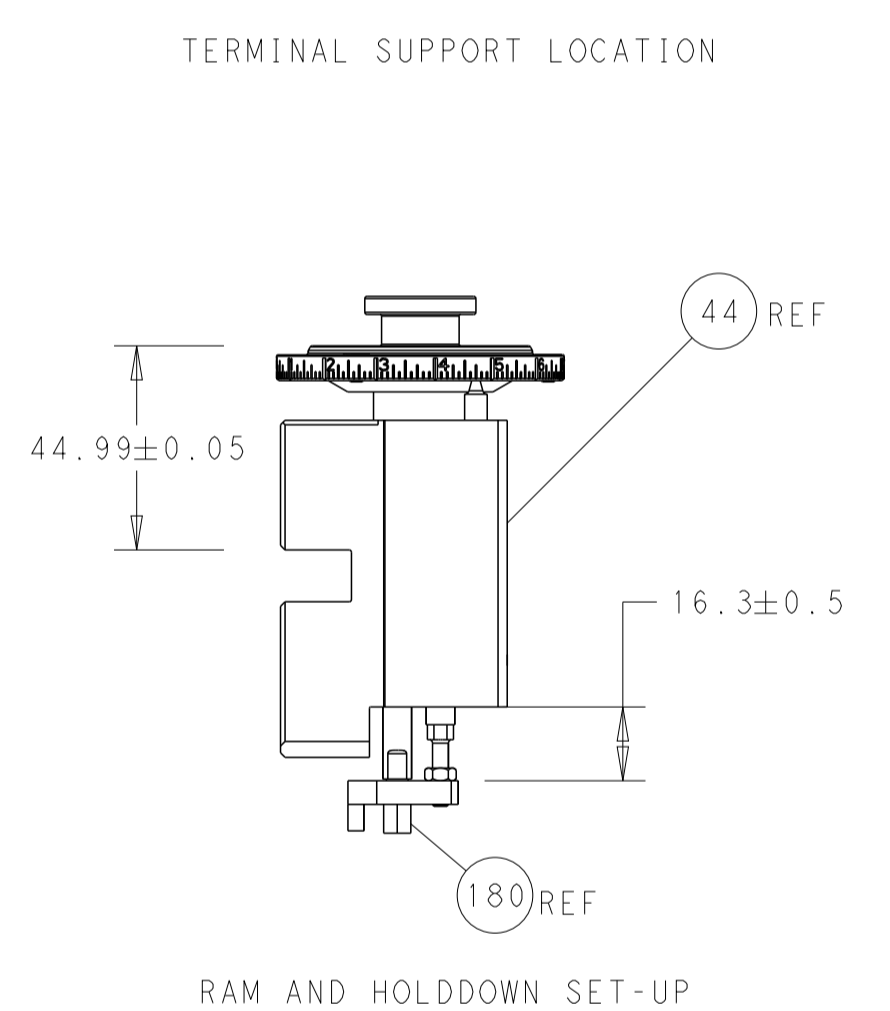
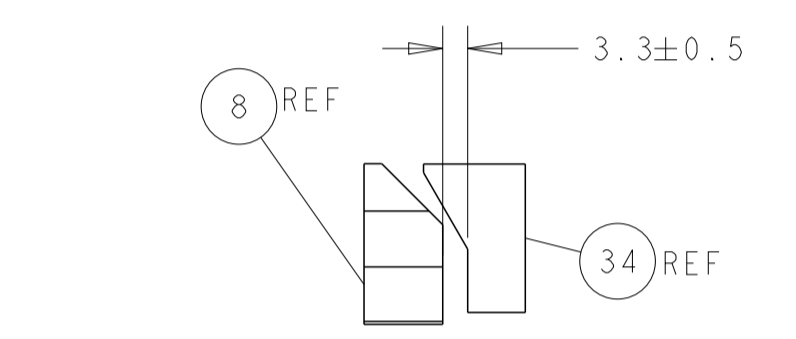
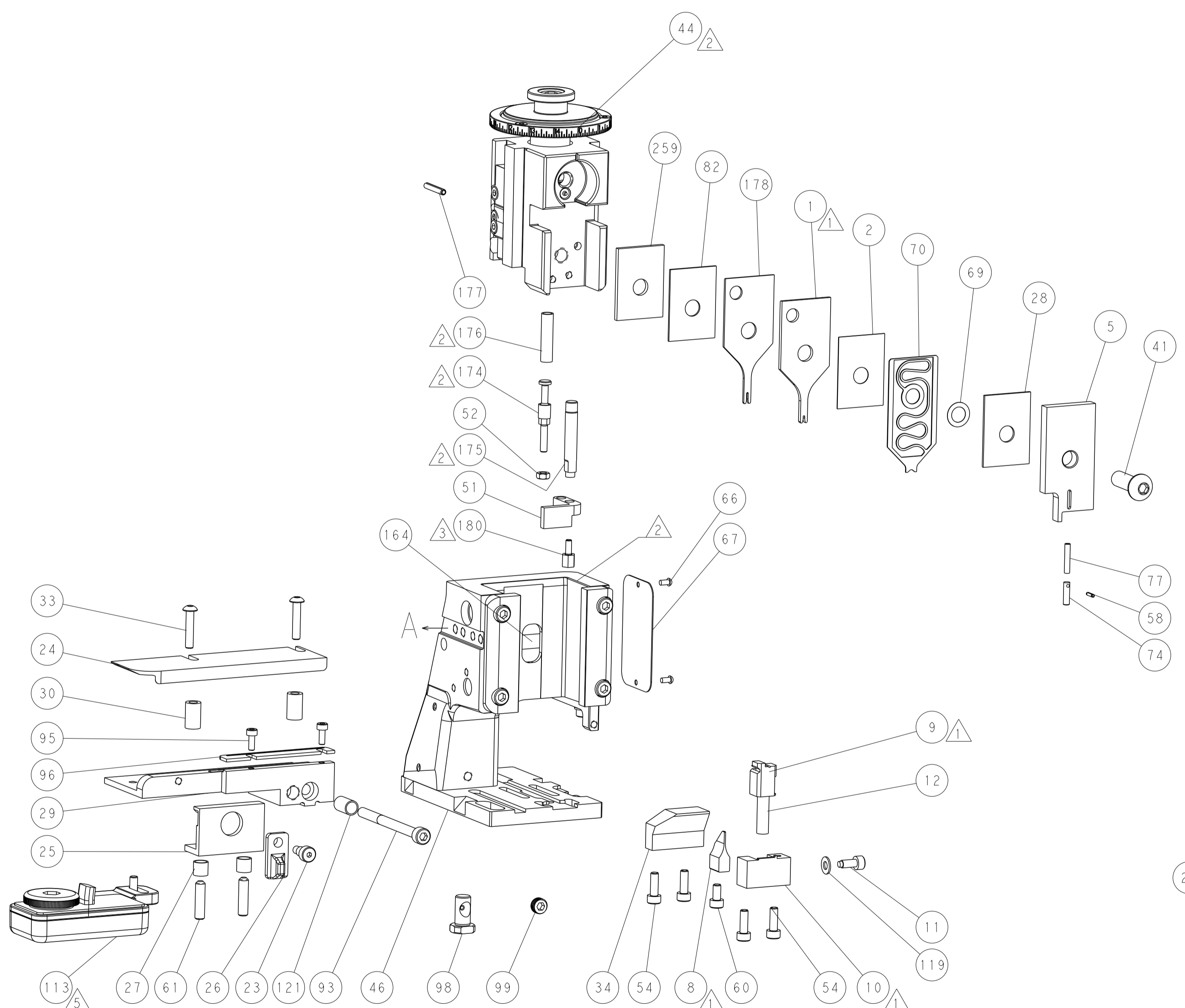
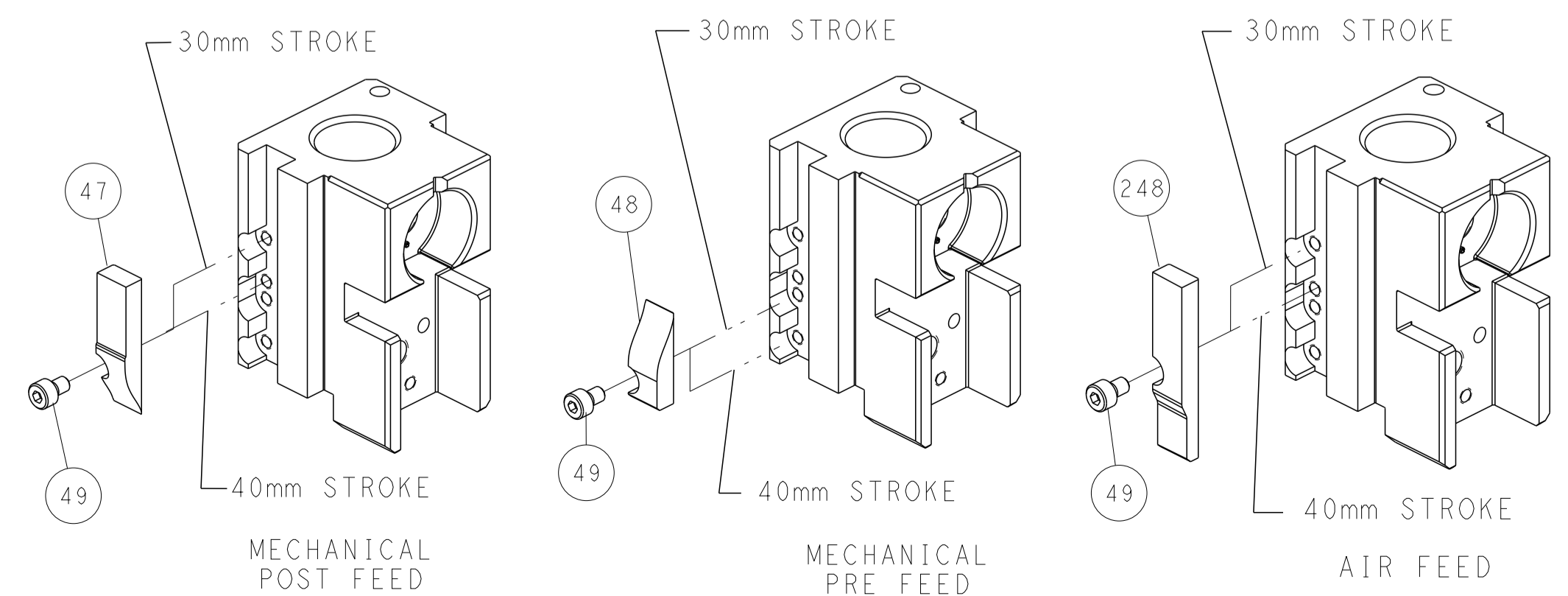
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS

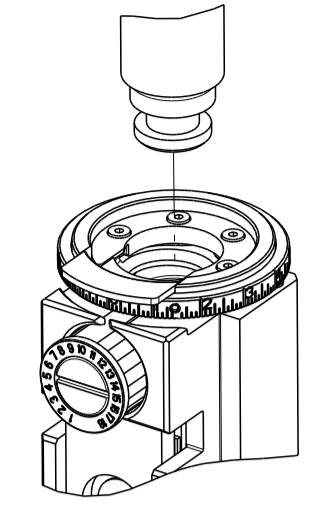


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN H. HUANG 03SEP2013 CHK L. ZHANG 03SEP2013 APVD J. GUO 03SEP2013 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2266023 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV B	
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.				SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266023-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266023-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266023-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	0.76 mm [.030]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: AMPHENOL TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: OPEN END BARREL CONTACT PIN

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
0.17-0.19 mm [.007-.007 IN]	∅ -

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	AMPHENOL TERMINAL	TE TERMINAL	AMPHENOL TERMINAL
2113368-1	X-X81-110-2828		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.711+0.025/-0 [.028+.001/-0]	5.0



- 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 ITEMS 180.
- 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 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.

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	APPD
A	66	-	-	-	-

QTY	LOC	DIST	REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-	1	1					1803078-2 SPACER, PRECISION	259
-	-	1					2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1	-					2844940-1 AIR FEED MODULE	238
-	1	1					1-1752354-0 STANDOFF, HOLD-DOWN	180
-	1	1					7-459492-1 CRIMPER, WIRE O	178
-	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
-	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					1-18028-2 WASHER, FLAT, REG M4	119
-	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					1-690438-0 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					455888-8 SPACER, CRIMPER	82
-	1	1					547505-3 SPRING, COMPRESSION	77
-	1	1					854769-4 HOLDER, INS	74
-	1	1					1803607-3 DOCUMENTATION PACKAGE	71
-	1	1					2119791-6 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
-	1	1					21028-2 PIN, SLOTTED SPRING .062 X .250	58
-	1	1					1338685-1 PAWL, FEED	56
-	1	1					1-5018030-0 NUT, HEX, REG, RoHS, M3.5	52
-	1	1					1-1901681-9 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					3-1752356-1 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					2844938-1 PLATE, STRIP GUIDE	29
-	1	1					1-455888-0 SPACER, CRIMPER	28
-	2	2					22281-8 SPRING, COMPRESSION	27
-	1	1					356835-1 LEVER, DRAG RELEASE	26
-	1	1					240792-1 DRAG, TERMINAL	25
-	1	1					1320928-2 STRIP GUIDE	24
-	1	1					980371-4 SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1					3-22280-3 SPRING, COMPRESSION	12
-	1	1					1-356885-5 STOP, SHEAR	11
-	1	1					2119805-1 SHEAR HOLDER, FRONT	10
-	1	1					1633861-1 SHEAR, FLOATING	9
1	1	1					1-1633933-8 ANVIL, COMBINATION	8
-	-	-					-	7
-	-	-					-	6
-	1	1					2119780-3 DEPRESSOR, SHEAR	5
-	-	-					-	4
-	-	-					-	3
-	1	1					455888-3 SPACER, CRIMPER	2
1	1	1					7-1633609-9 CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OTHERWISE SPECIFIED:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

OWN	H. HUANG	03SEP2013	
CHK	L. ZHANG	03SEP2013	
APPD	J. GUO	03SEP2013	
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266023	
Customer Accessible Production Drawing		SCALE	1:2 SHEET 3 OF 4 REV B

