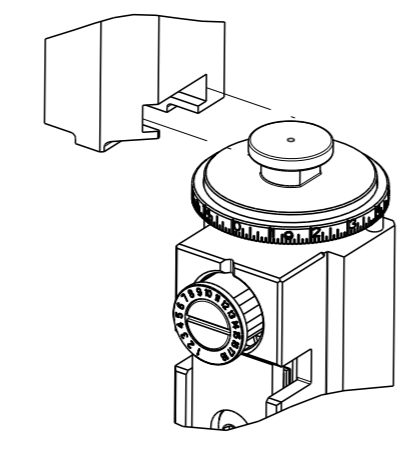


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266013-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266013-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266013-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266013-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266013-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266013-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266013-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



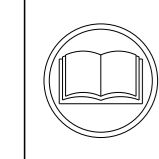
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	3.05 mm [.120]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON-1.2 CB SWS (SINGLE WIRE SEAL)			
WIRE STRIP LENGTH	3.00-3.60 mm [.118-.142 IN]	TERMINAL INSULATION DIAMETER RANGE	Ø
TERMINAL APPLICATION SPECIFICATION	114-18464		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
1418844-1			967067-1	Ø 1.4-2.1mm
1418844-2			967067-2	Ø 0.9-1.4mm
1418844-3			963142-2	Ø 0.9-1.3mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm ²	0.87+/-0.03 [.034+/-0.001]	7.0
22 AWG	0.86+/-0.03 [.034+/-0.001]	7.1
24 AWG	0.80+/-0.03 [.031+/-0.001]	8.1



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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 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.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

***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	#	LYR	DESCRIPTION	DATE	OWN	APVD
		C		ECR-18-014923	12OCT2018	MEH	TE
		C1		ECR-18-019256	11DEC2018	FL	CT
		D		ECR-19-010982	12JUL2019	MZ	YY
		E		ECR-20-016170	12NOV2020	MEH	TE

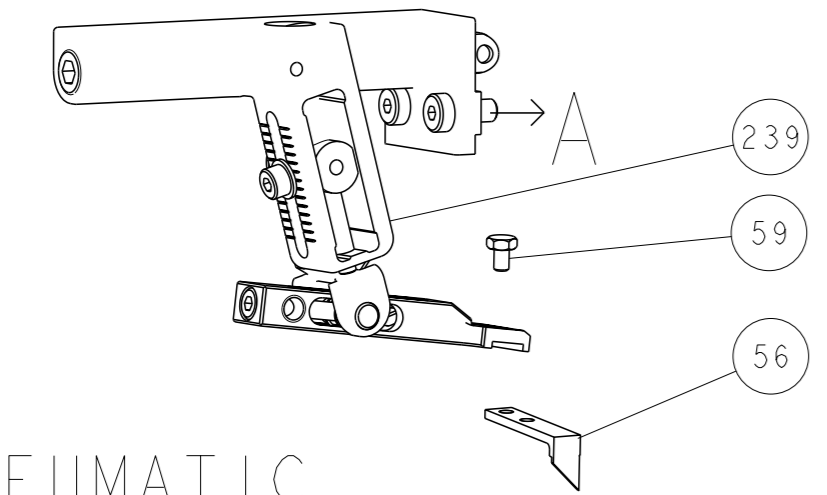
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	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
-	-	-	1	1	-	-	1-1752354-6	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	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
-	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
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	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	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	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	1-356885-5	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	2	2	1	1	1	3-1333225-9	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	4-240641-1	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	2	2	1	1	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	2	1	1	1	1-1673600-0	CRIMPER, WIRE	1

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

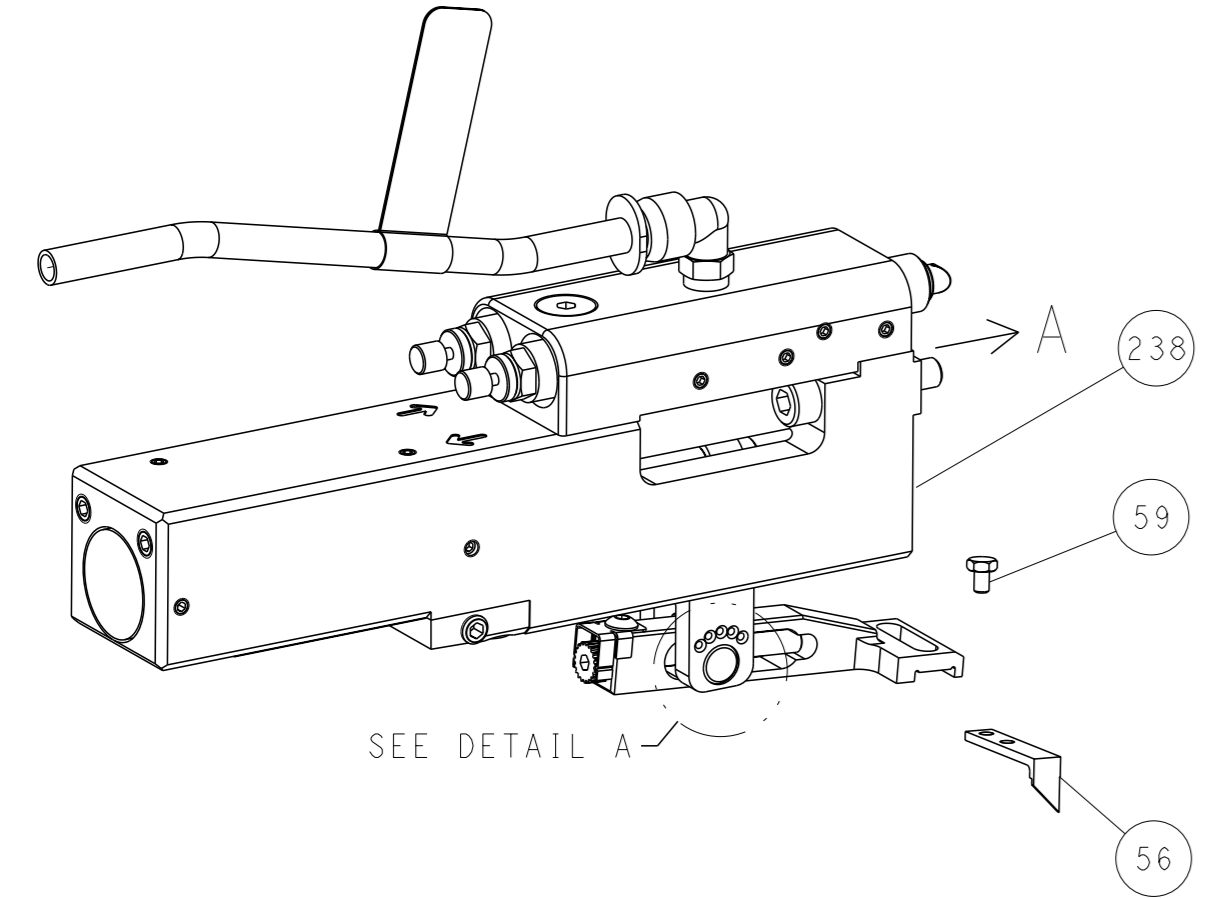
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	3 PLC ±	4 PLC ±	ANGLES ±	APPLICATOR SPEC		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO		RESTRICTED TO
MATERIAL	FINISH	WEIGHT		SCALE		SHEET		REV		
		-		1:2		1 of 4		E		

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

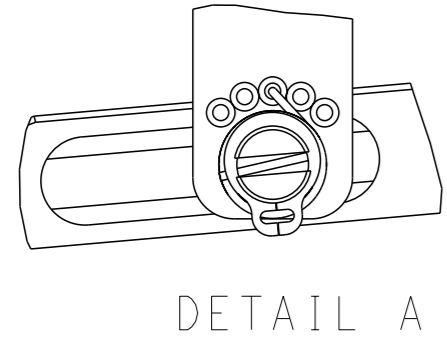
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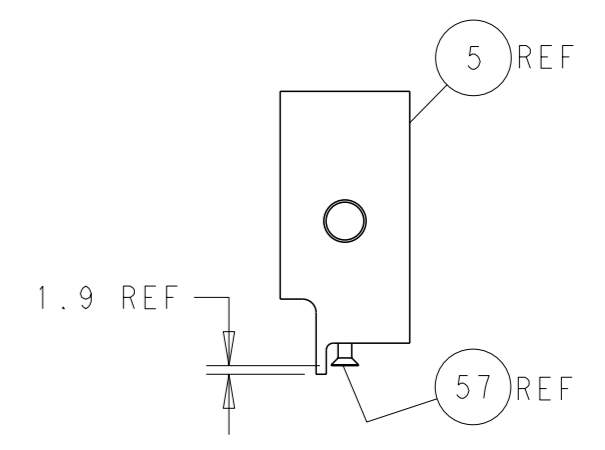
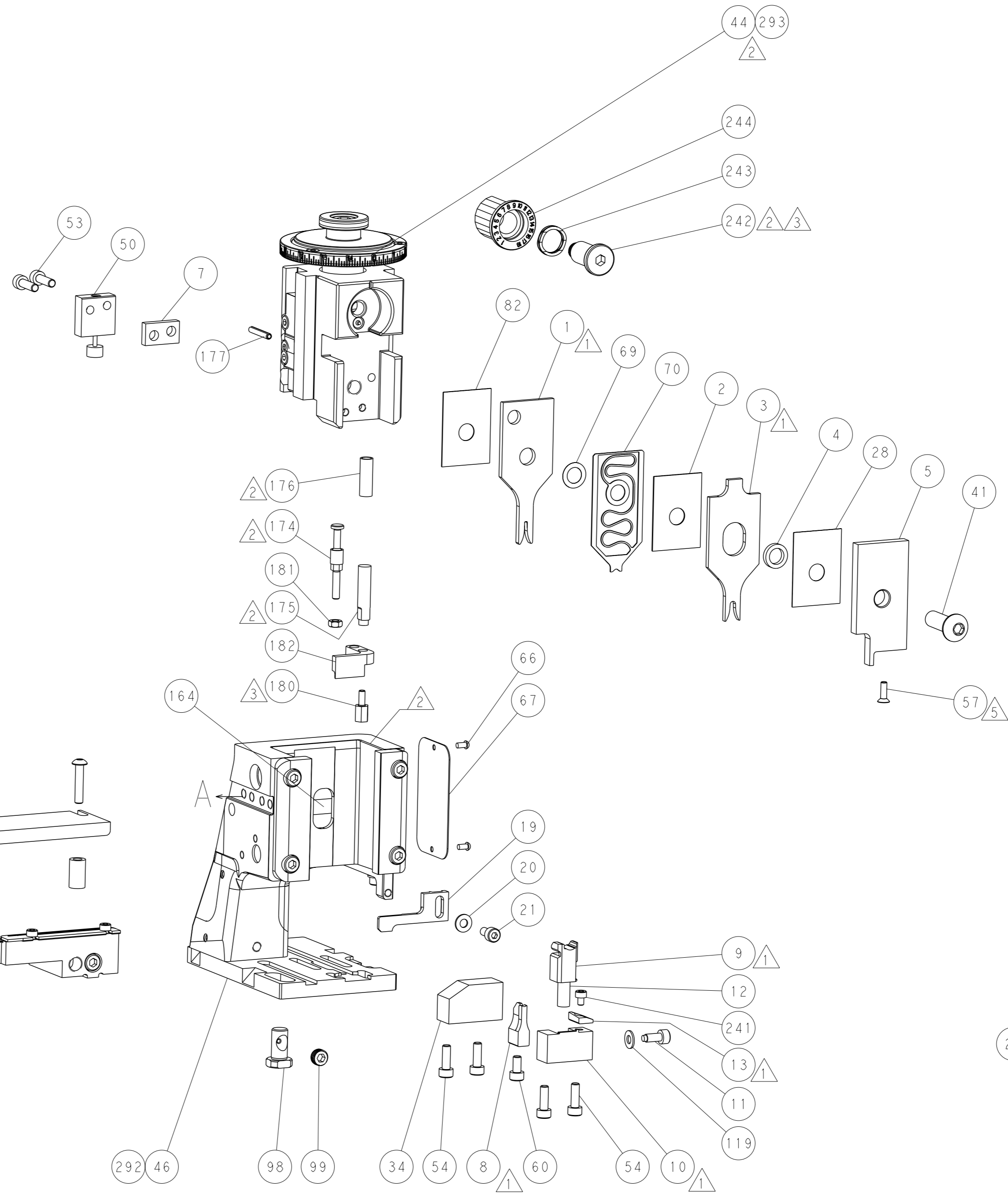
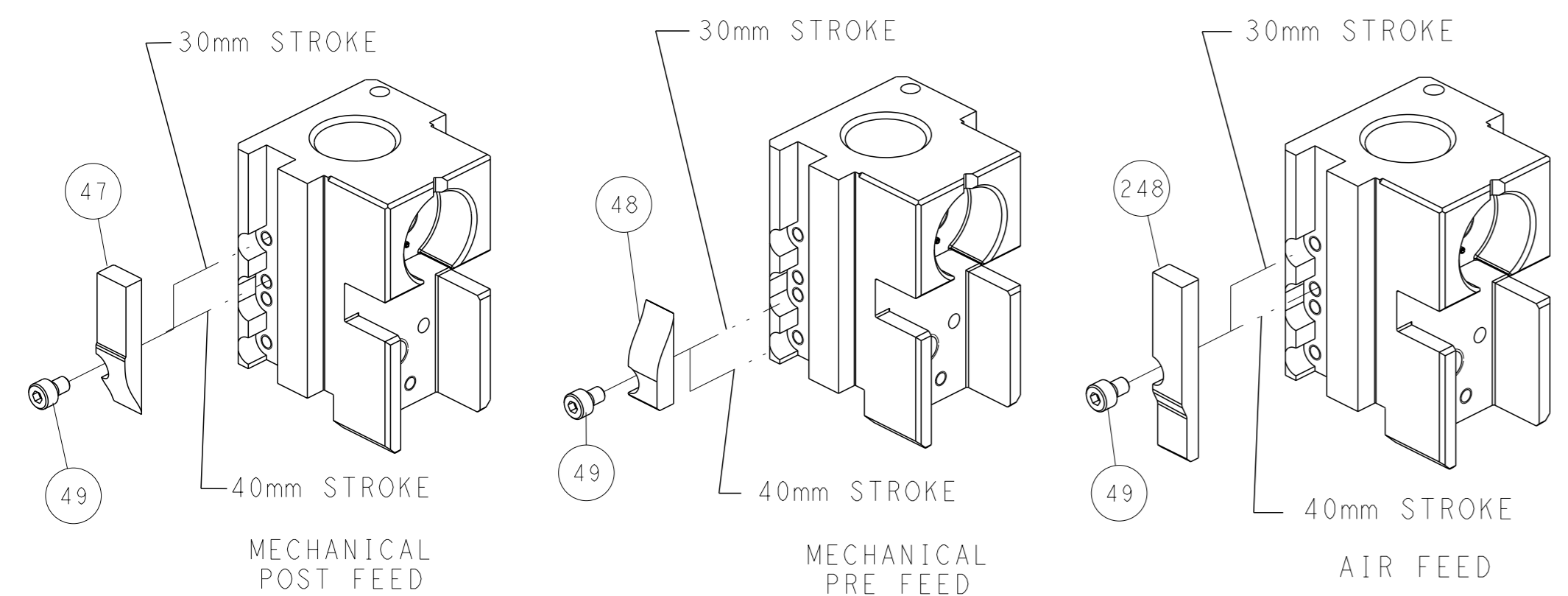
PNEUMATIC



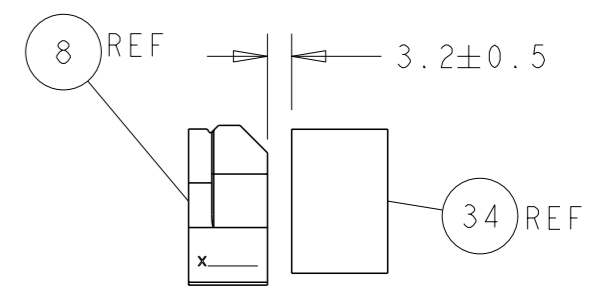
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



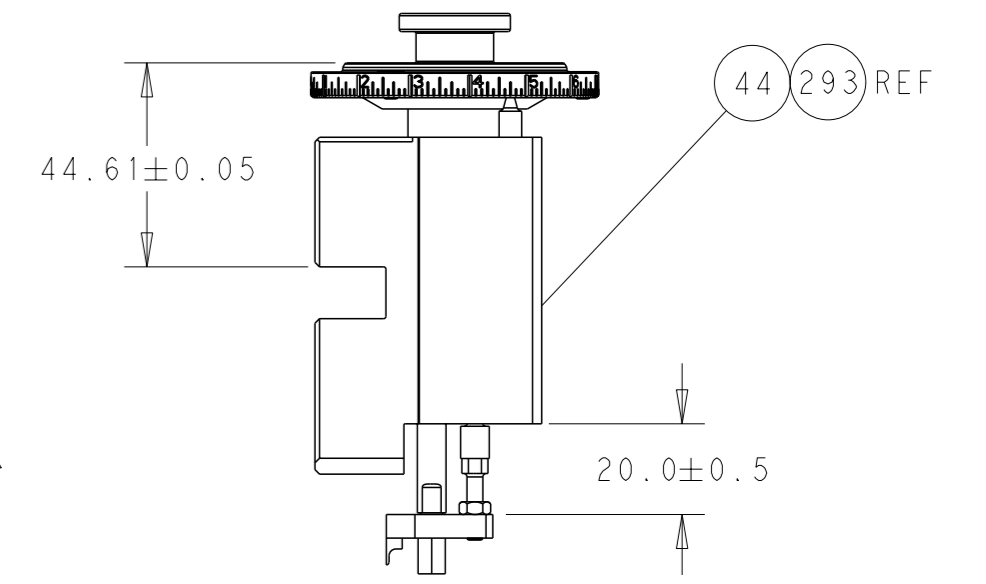
CAM POSITIONS



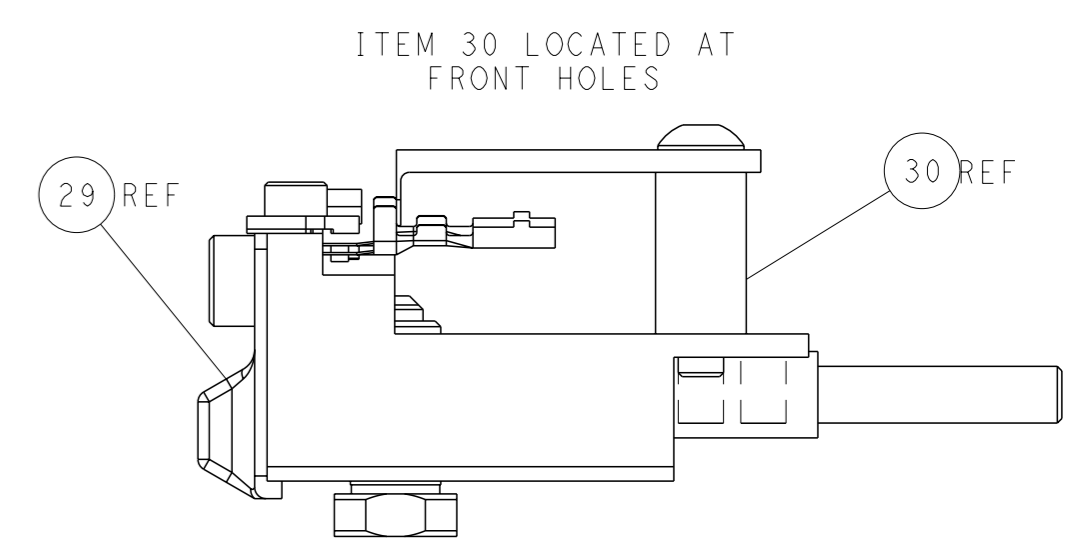
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLD DOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

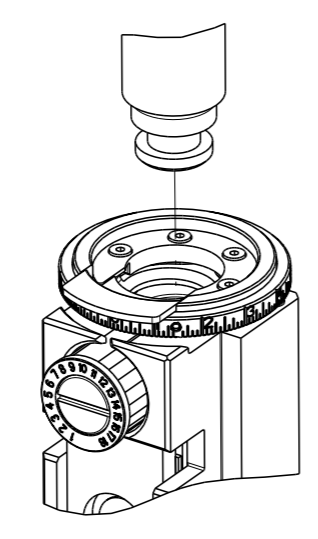
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: R. HUANG CHK: L. ZHANG APVD: J. GUO	23AUG2013 23AUG2013 23AUG2013	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266013	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: E	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266013-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266013-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266013-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm (.050)	F
INSUL	3.05 mm (.120)	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION
 TERMINAL NAME: MCON-1.2 CB SWS (SINGLE WIRE SEAL)

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
3.00-3.60 mm (.118-.142 IN)	\varnothing
TERMINAL APPLICATION SPECIFICATION	114-18464

TERMINALS APPLIED					SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL		
1418844-1			967067-1		\varnothing 1.4-2.1mm
1418844-2			967067-2		\varnothing 0.9-1.4mm
1418844-3			963142-2		\varnothing 0.9-1.3mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm ²	0.87+/-0.03 [.034+/-0.001]	7.0
22 AWG	0.86+/-0.03 [.034+/-0.001]	7.1
24 AWG	0.80+/-0.03 [.031+/-0.001]	8.1

- 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 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

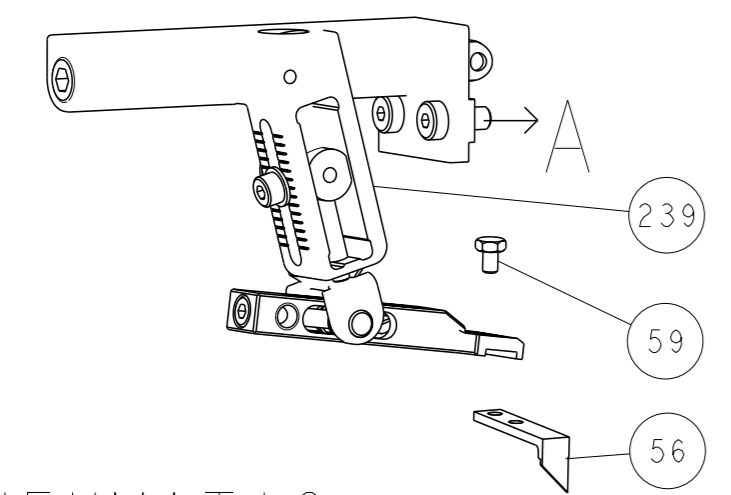
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	1-18028-2	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	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	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
-	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	1338685-1	PAWL, FEED	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	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
-	1	1	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	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	3-1333225-9	ANVIL, COMBINATION	8
-	1	1	4-240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	1-1673600-0	CRIMPER, WIRE	1

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

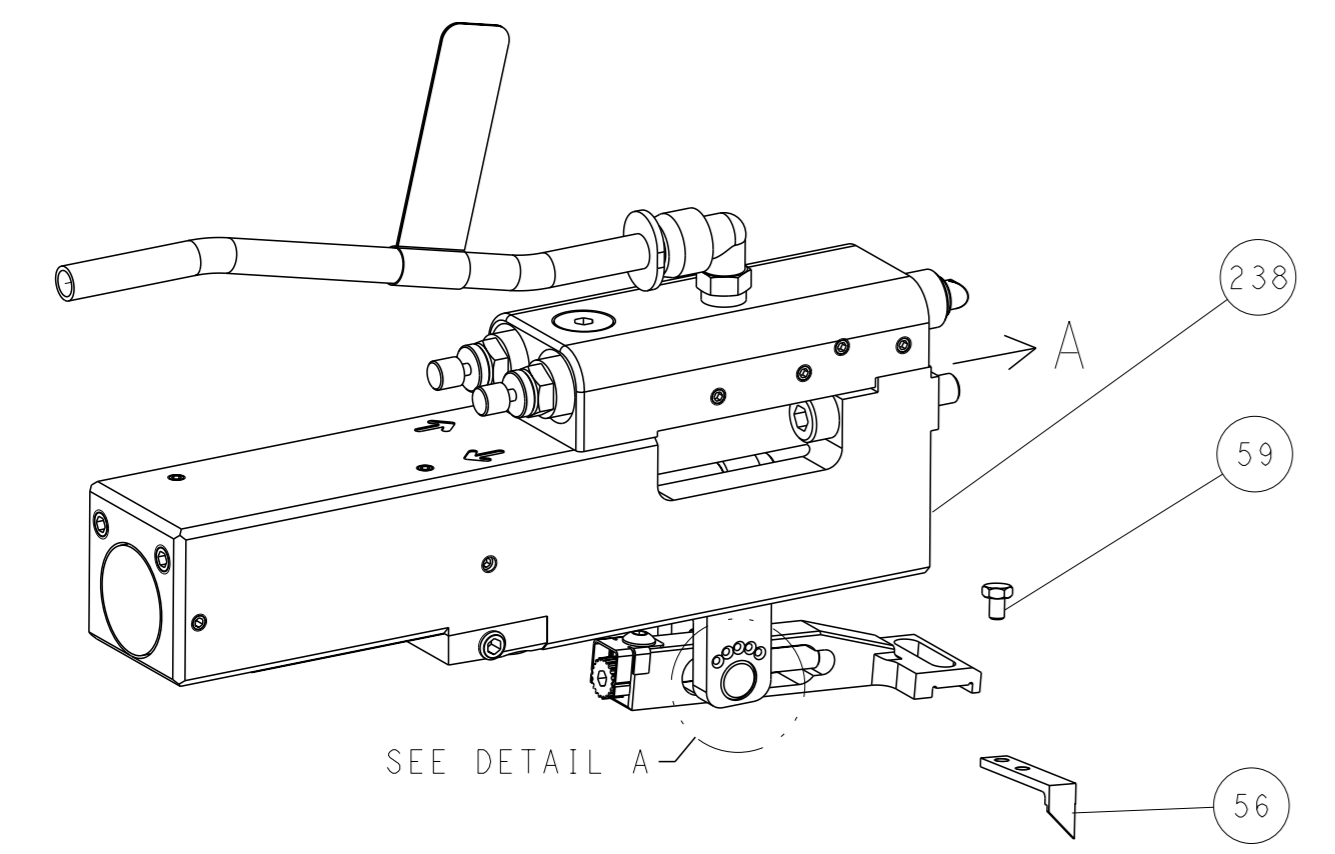
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LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

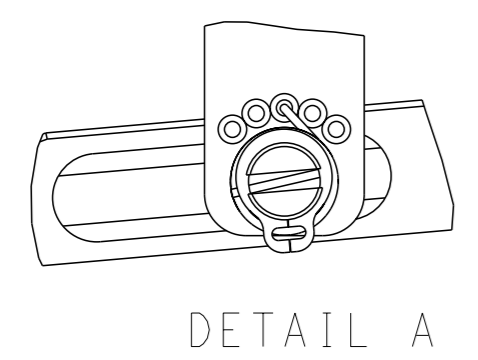
FEED TYPE MECHANICAL



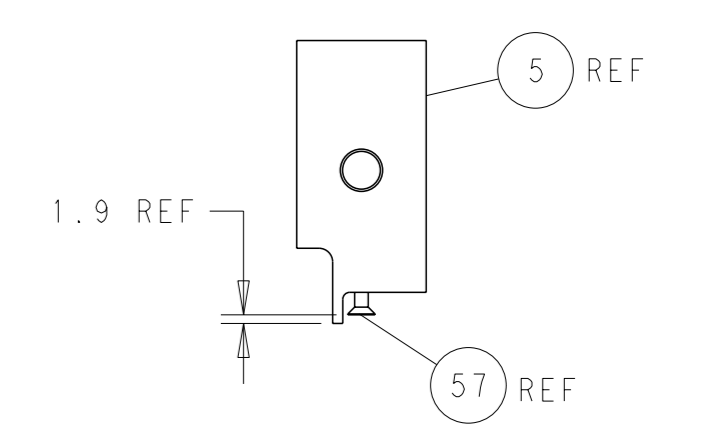
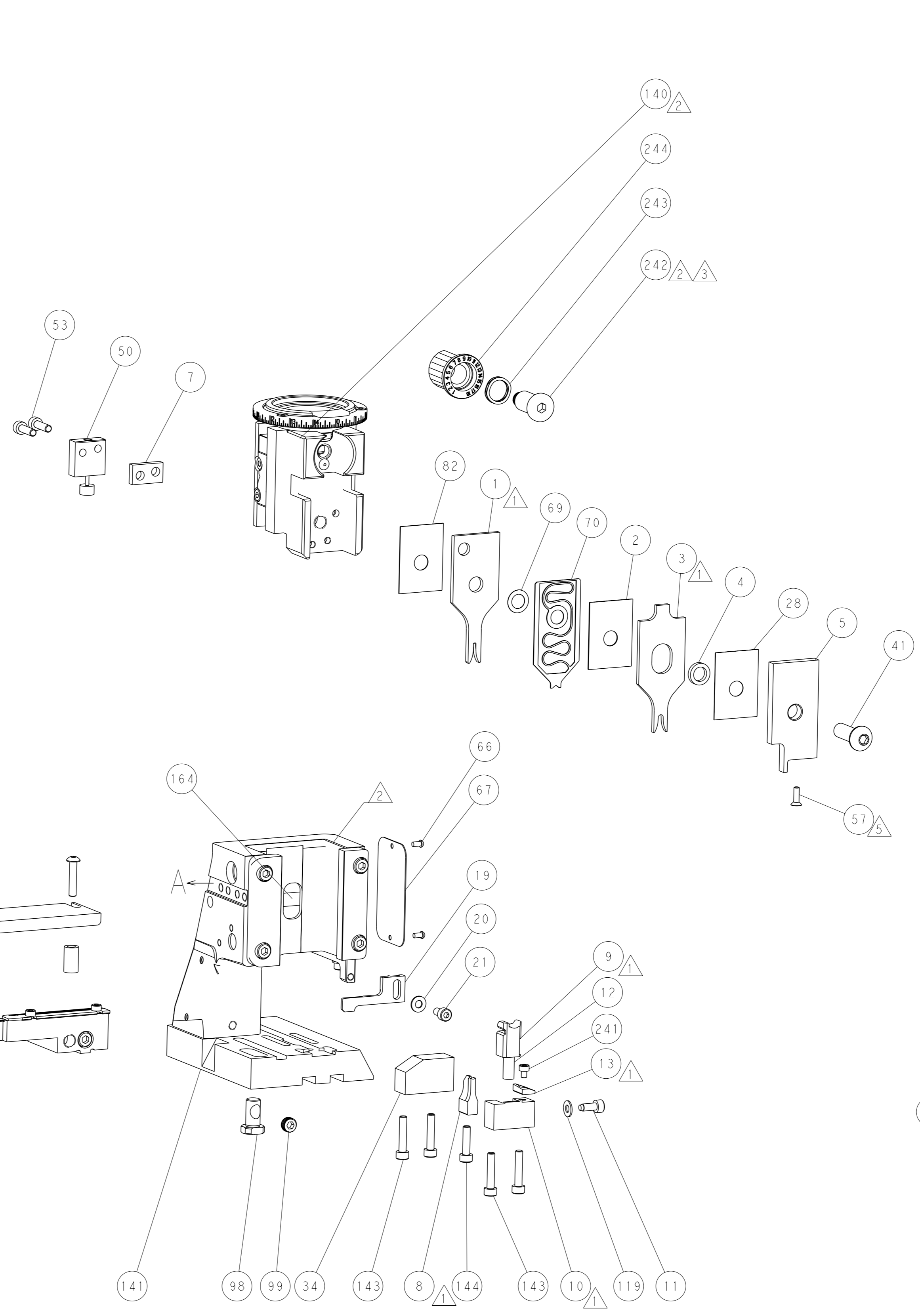
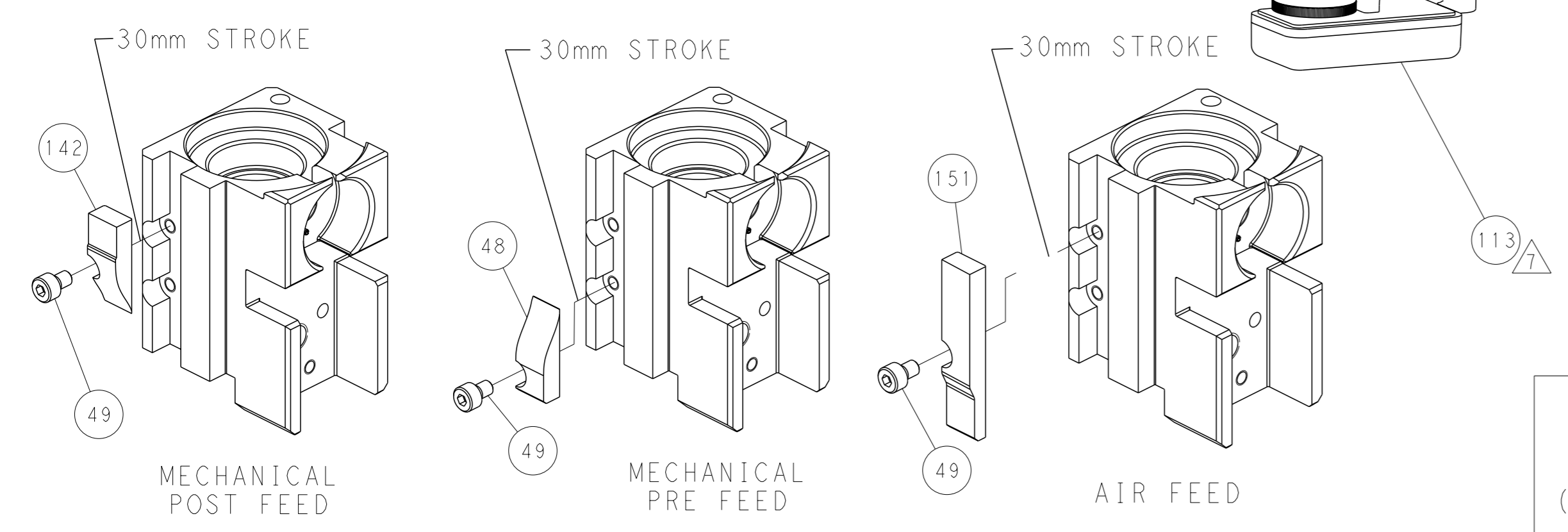
PNEUMATIC



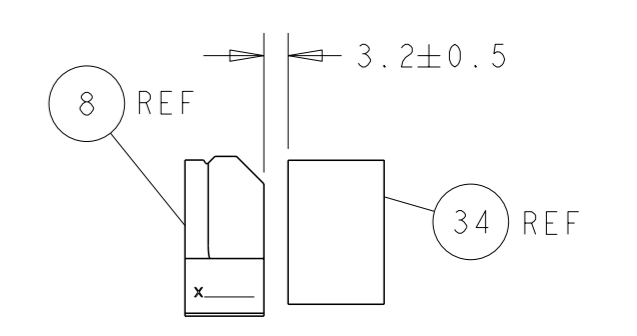
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



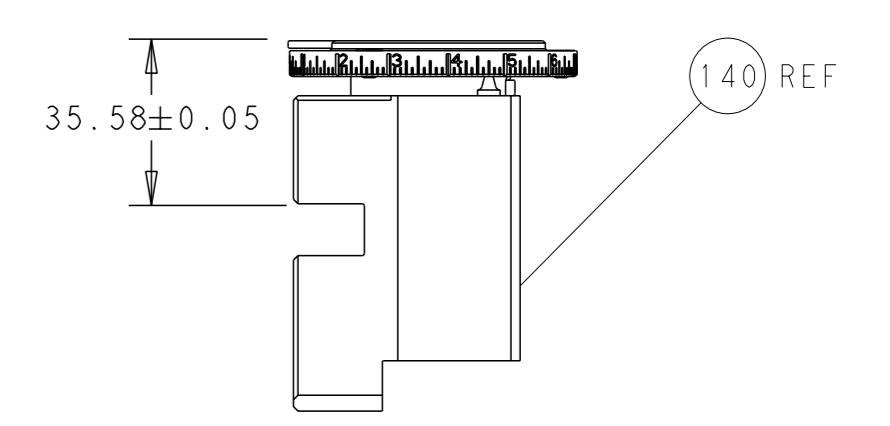
CAM POSITIONS



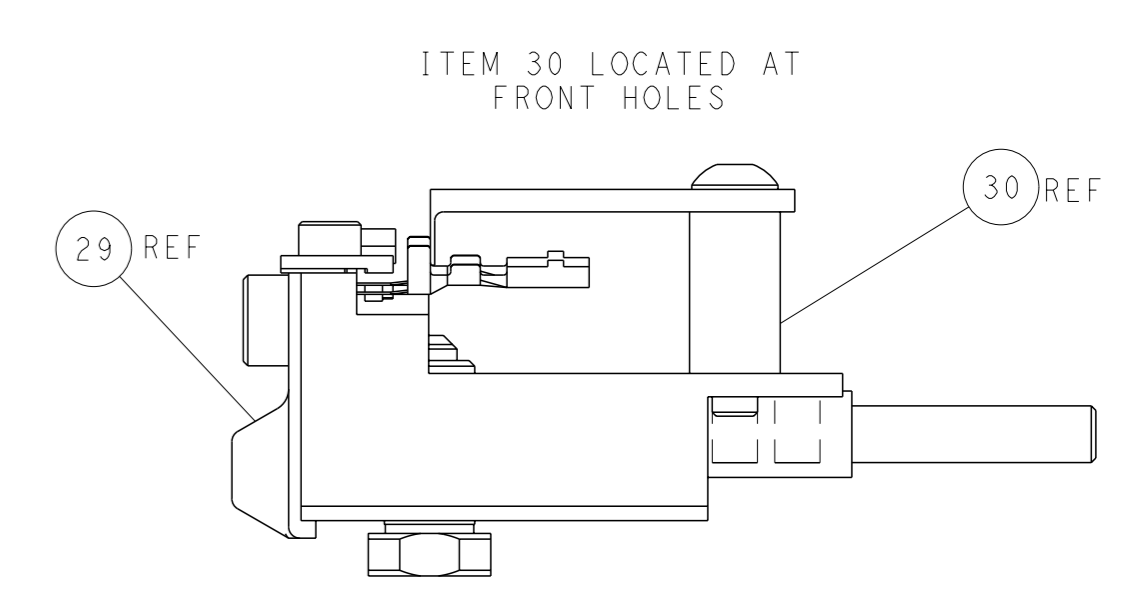
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		OWN: H. HUANG CHK: L. ZHANG APVD: J. GUO DATE: 23AUG2013 PRODUCT SPEC APPLICATION SPEC		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266013 SCALE: 1:2 SHEET: 4 of 4 REV: E	
MATERIAL: .		WEIGHT: .		RESTRICTED TO:		Customer Accessible Production Drawing	