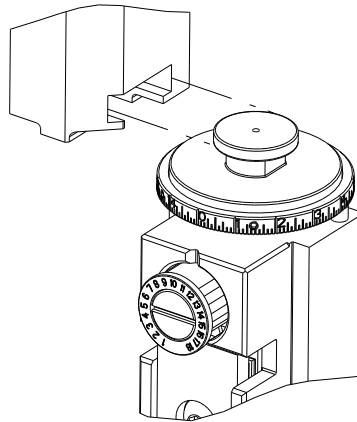
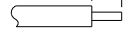


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266419-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266419-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266419-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266419-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266419-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.67 mm [.066]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL		KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: KOSTAL MLK 1.2m RECEPTACLE			
WIRE STRIP LENGTH 2.60-3.60 mm [.102-.142 IN]			INSULATION DIAMETER RANGE Ø1.20-1.40 mm [.047-.055 IN]
TERMINAL APPLICATION SPECIFICATION		DOC00061540 ATTACHMENT 3 P6. 50 OF 57	
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE TERMINAL	KOSTAL TERMINAL
1949957-1	3 21 24 73401 0/3	1949957-2	3 21 25 73401 0/3
1949957-3	3 21 40 73401 0/3	1572680-1	3 21 40 65176 0/3
1572680-2	3 21 24 65176 0/3	1572680-3	3 21 25 65176 0/3
1949380-1	3 21 24 73406 0/3	1949380-2	3 21 25 73406 0/3
1949380-3	3 21 40 73406 0/3	2380009-1	32124734013

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.76+/-0.03 [.030+/- .001]	6.9



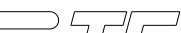
- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. 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	REVISONS			
A	66	P	LTR	DESCRIPTION	DATE DWN APVD
			B1	ECR-18-014882	19SEP2018 KH CT
			C	ECR-19-014046	09SEP2019 FZ TE
			D	ECR-20-015755	04NOV2020 JWC GB
			D1	ECR-22-139858	20MAY2022 FZ JAH

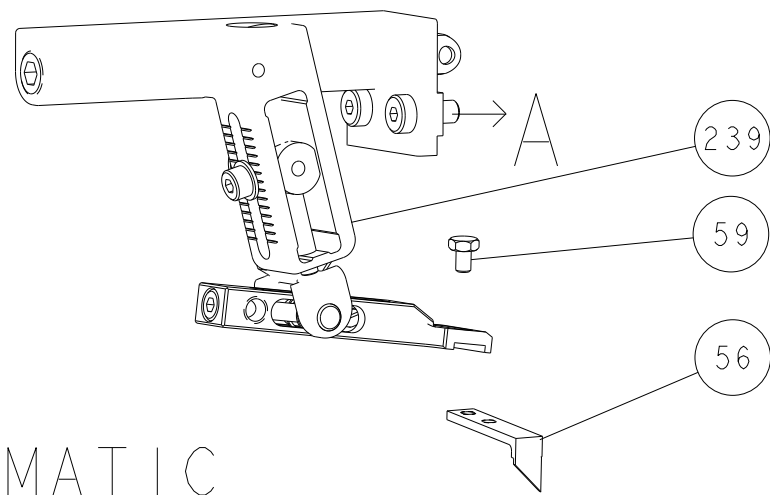
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	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	455888-6	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	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	1320928-6	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1-1803554-5	ANVIL, COMBINATION	8
-	1	1	1	1	240641-1	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	7-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	2	1	2-1633664-7	CRIMPER, WIRE	1
-	77	72	71	-2	-1	PART NO	ITEM NO
						DESCRIPTION	

THIS DRAWING IS TO REMAIN UNPUBLISHED FOR THE ENTIRE LIFE OF THE PRODUCT. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER.				DWN	J. HOU	23JULY2014	 TE Connectivity Harrisburg, PA 17105-3608				
DIMENSIONS:				CHK	Y. YIN	23JULY2014	NAME				
mm				APVD	U. GUO	23JULY2014	Ocean Side Feed Applicator -				
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC		SIZE					
0 PLC ±				APPLICATION SPEC		CAGE CODE					
1 PLC ±				WEIGHT		DRAWING NO					
2 PLC ±				MATERIAL		00779					
3 PLC ±				FINISH		C=2266419					
4 PLC ±				Customer Accessible Production Drawing		SCALE					
ANGLES				SHEET		1 OF 4					
FINISH				REV		D1					

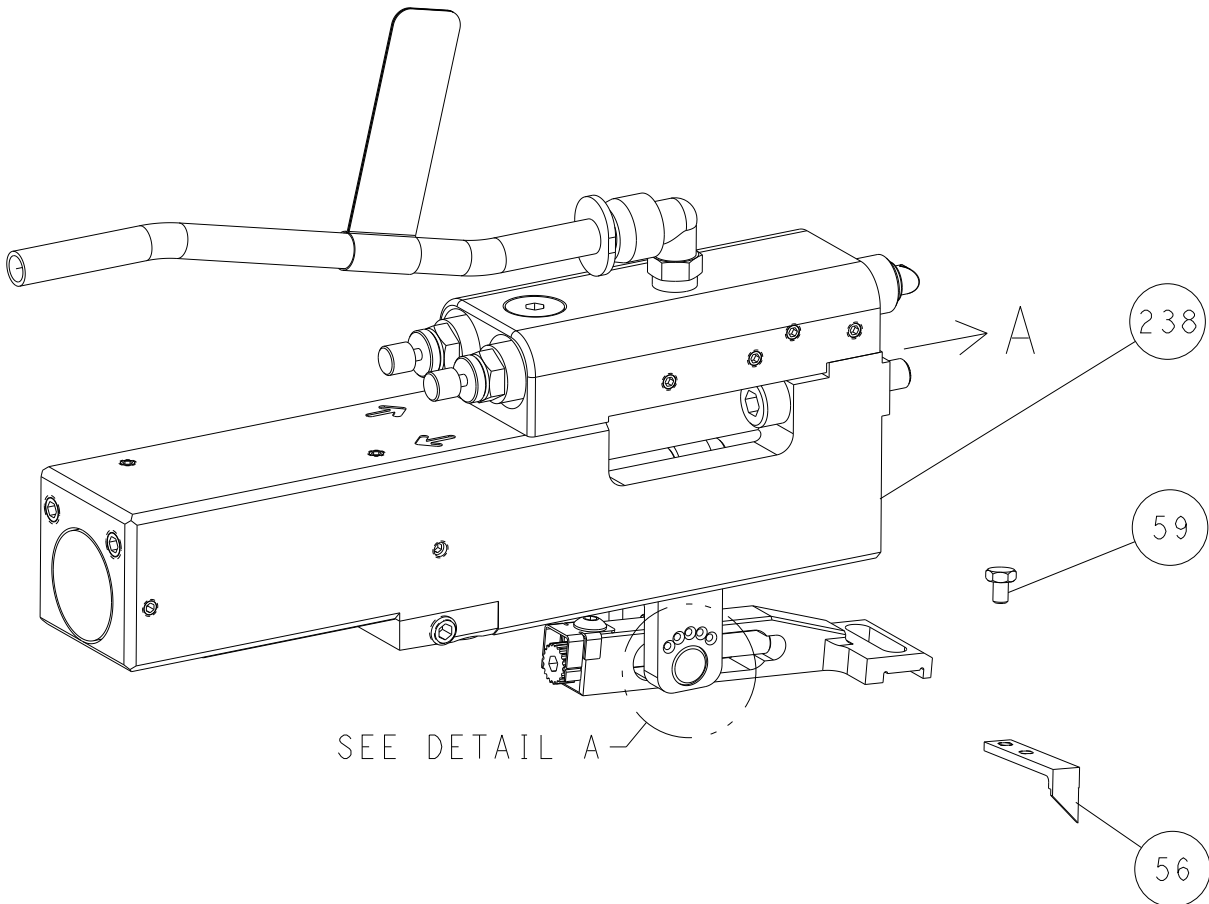
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

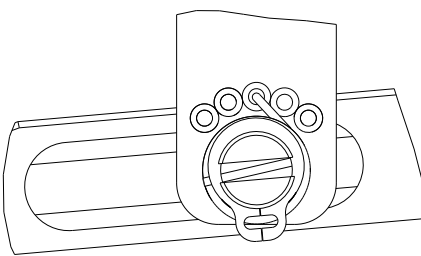
FEED TYPE MECHANICAL



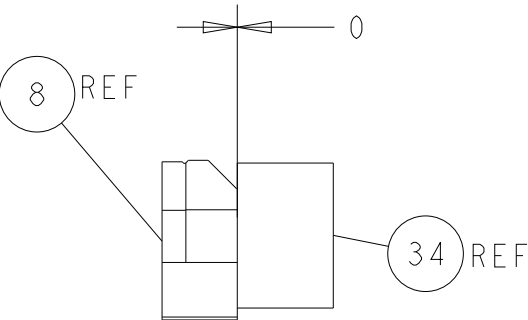
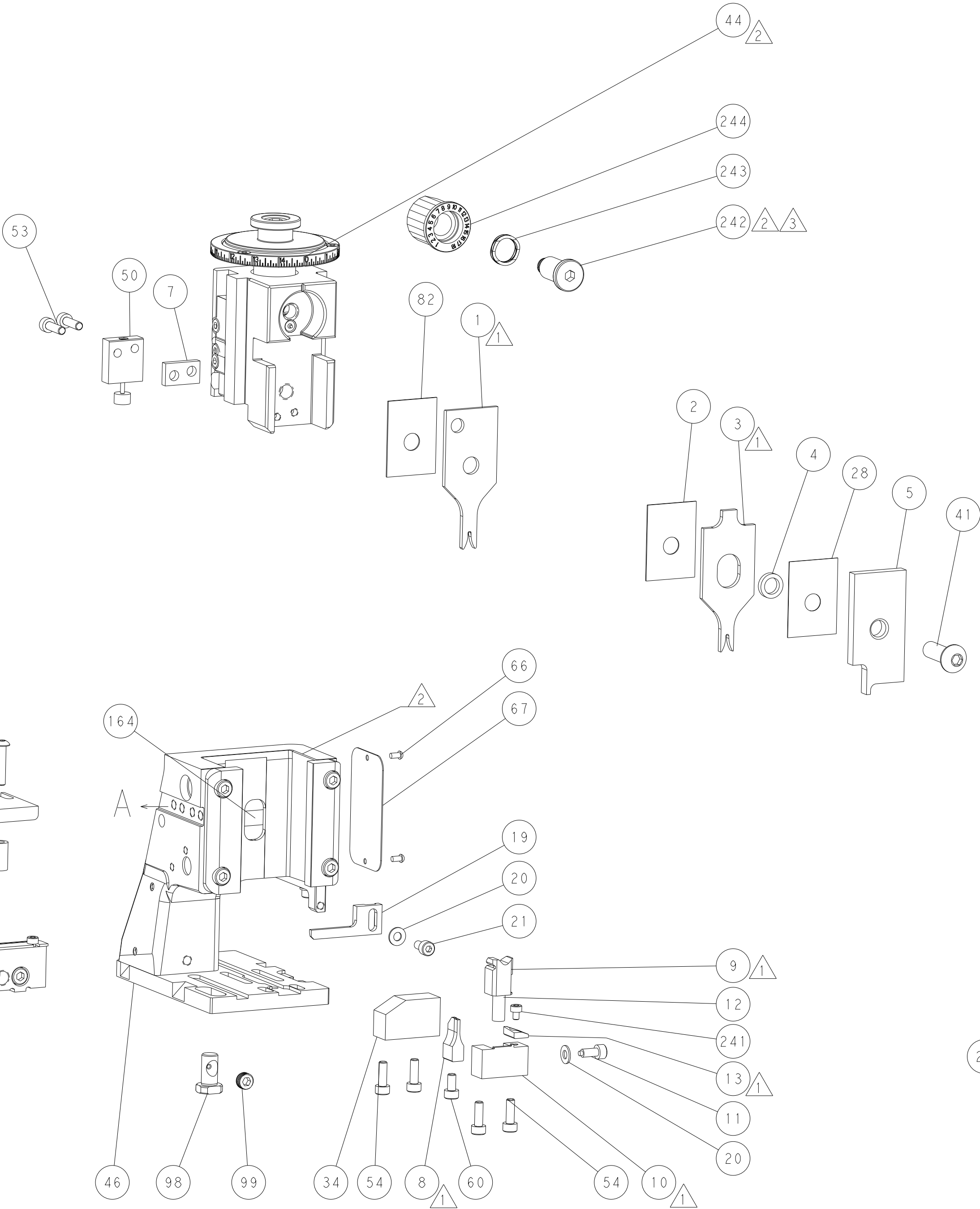
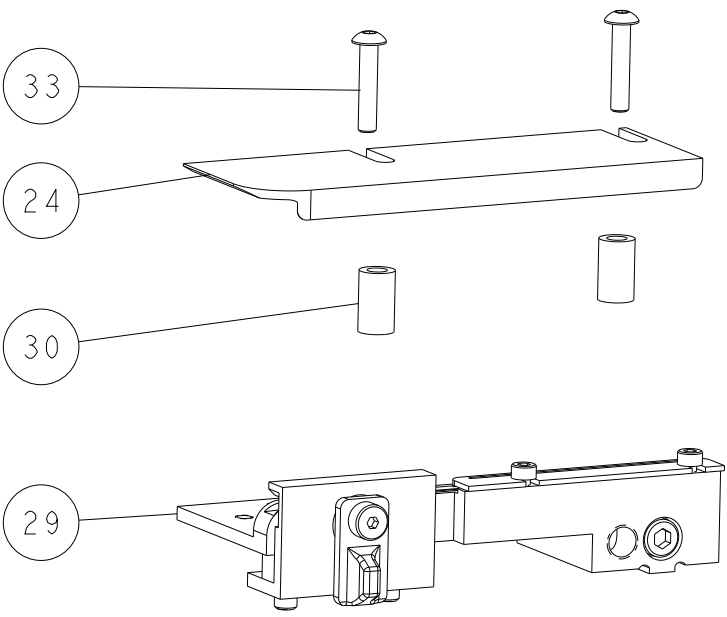
PNEUMATIC



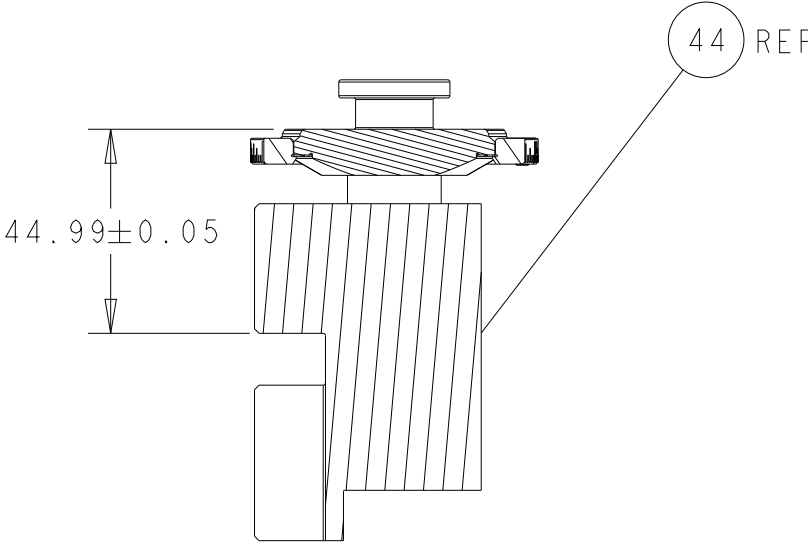
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



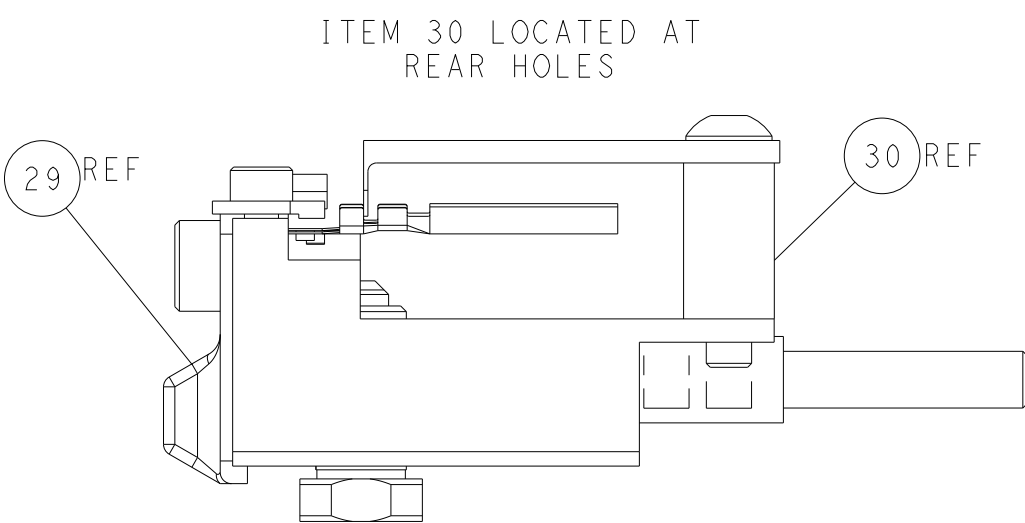
DETAIL A



TERMINAL SUPPORT LOCATION

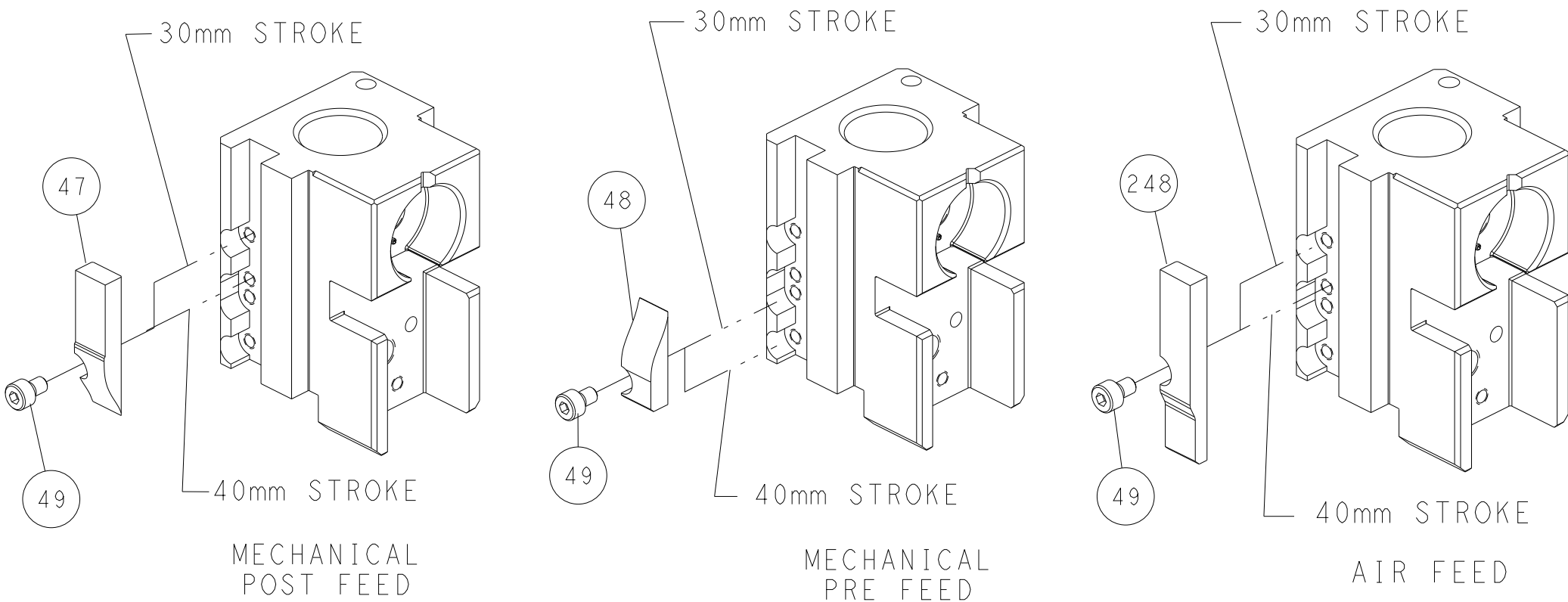


RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS



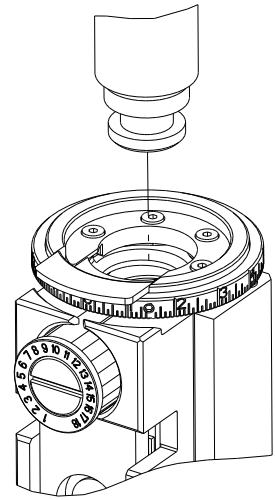
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO COMPANY CONTROL AND THE ISSUING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	J. HOU	23JULY2014	TE Connectivity Harrisburg, PA 17105-3608	
				CHK	Y. YIN	23JULY2014		
				APVD	V. GUO	23JULY2014	NAME	
				PRODUCT SPEC			Ocean Side Feed Applicator	
				APPLICATION SPEC			-	
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
				A1	00779	C=2266419	-	
				Customer Accessible Production Drawing			SCALE	1:2
							SHEET	2 of 4
							REV	D1

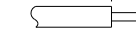
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8	7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION
20		20
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		
PART NUMBER	REVISION	DESCRIPTION
2-2266419-1	D	FINE CRIMP HEIGHT ADJUST
2-2266419-2	D	FINE CRIMP HEIGHT ADJUST
7-2266419-7	B	CRIMP TOOLING KIT
		FEED TYPE
		MECHANICAL
		PNEUMATIC
		-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.67 mm [.066]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL		KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: KOSTAL MLK 1.2m RECEPTACLE			
WIRE STRIP LENGTH 2.60-3.60 mm [.102-.142 IN]			INSULATION DIAMETER RANGE Ø1.20-1.40 mm [.047-.055 IN]
TERMINAL APPLICATION SPECIFICATION		DOC00061540 ATTACHMENT 3 PG. 50 OF 57	-
TERMINALS APPLIED		-	-
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE TERMINAL	KOSTAL TERMINAL
1949957-1	3 21 24 73401 0/3	1949957-2	3 21 25 73401 0/3
1949957-3	3 21 40 73401 0/3	1572680-1	3 21 40 65176 0/3
1572680-2	3 21 24 65176 0/3	1572680-3	3 21 25 65176 0/3
1949380-1	3 21 24 73406 0/3	1949380-2	3 21 25 73406 0/3
1949380-3	3 21 40 73406 0/3	2380009-1	32124734013

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.76+/-0.03 [.030+/- .001]	6.9



- 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. 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	REVISONS			
A	66	P	LTR	DESCRIPTION	DATE
		-		SEE SHEET 1	-

-	1	1	2119082-5	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	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	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-1	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	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-6	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	1-1803554-5	ANVIL, COMBINATION	8
-	1	1	240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
-	1	1	7-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	2-1633664-7	CRIMPER, WIRE	1

THIS DOCUMENT IS A CONTROLLED DOCUMENT FOR THE PROTECTING ORGANIZATION. IT IS SUBJECT TO CONTROLLED DOCUMENT AND INFORMATION CONTROLS. IT SHOULD BE CONTROLLED FOR THE LATEST EDITION.		OWN J. HOU 23JULY2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK Y. YIN 23JULY2014	NAME	
mm		APVD U. GUO 23JULY2014	Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	SIZE CAGE CODE DRAWING NO	
0 PLC ±		APPLICATION SPEC	RESTRICTED TO	
1 PLC ±		WEIGHT	00779 C=2266419	
2 PLC ±			Customer Accessible Production Drawing	
3 PLC ±			SCALE 1:2	
4 PLC ±			SHEET 3 OF 4	
ANGLES FINISH			REV D1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

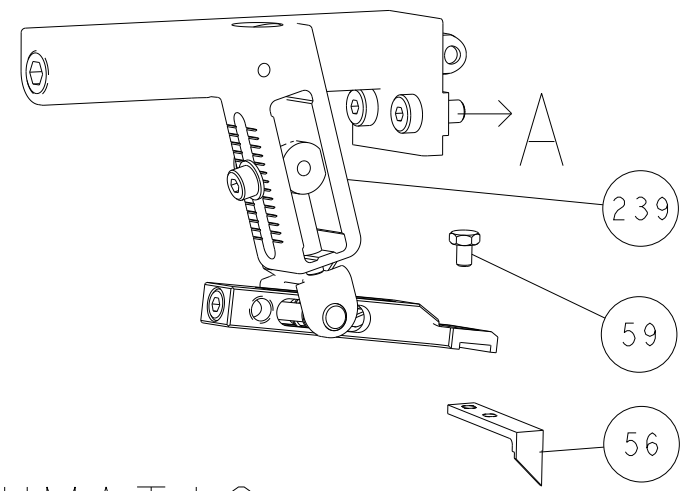
D

C

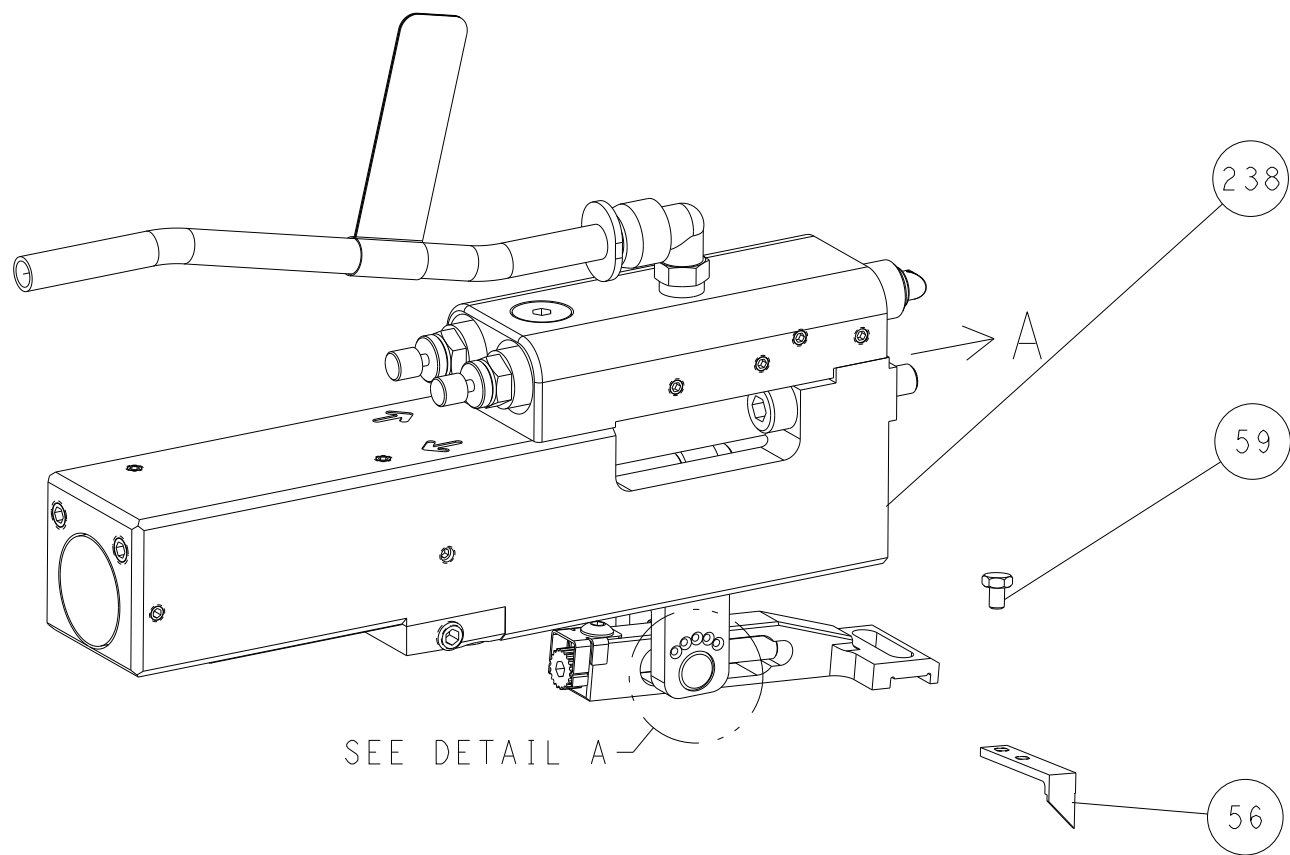
B

A

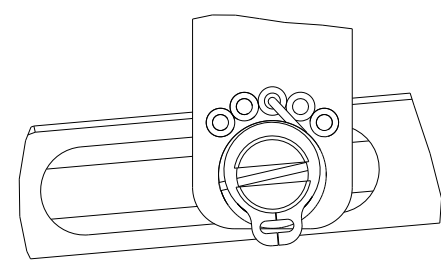
FEED TYPE MECHANICAL



PNEUMATIC

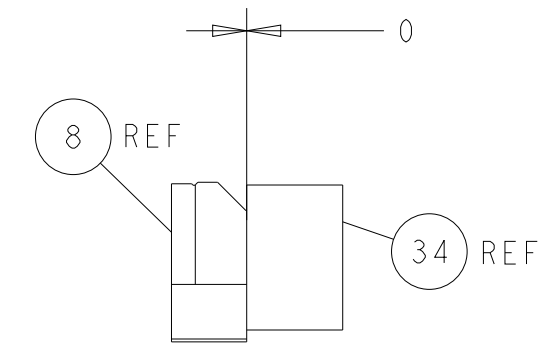
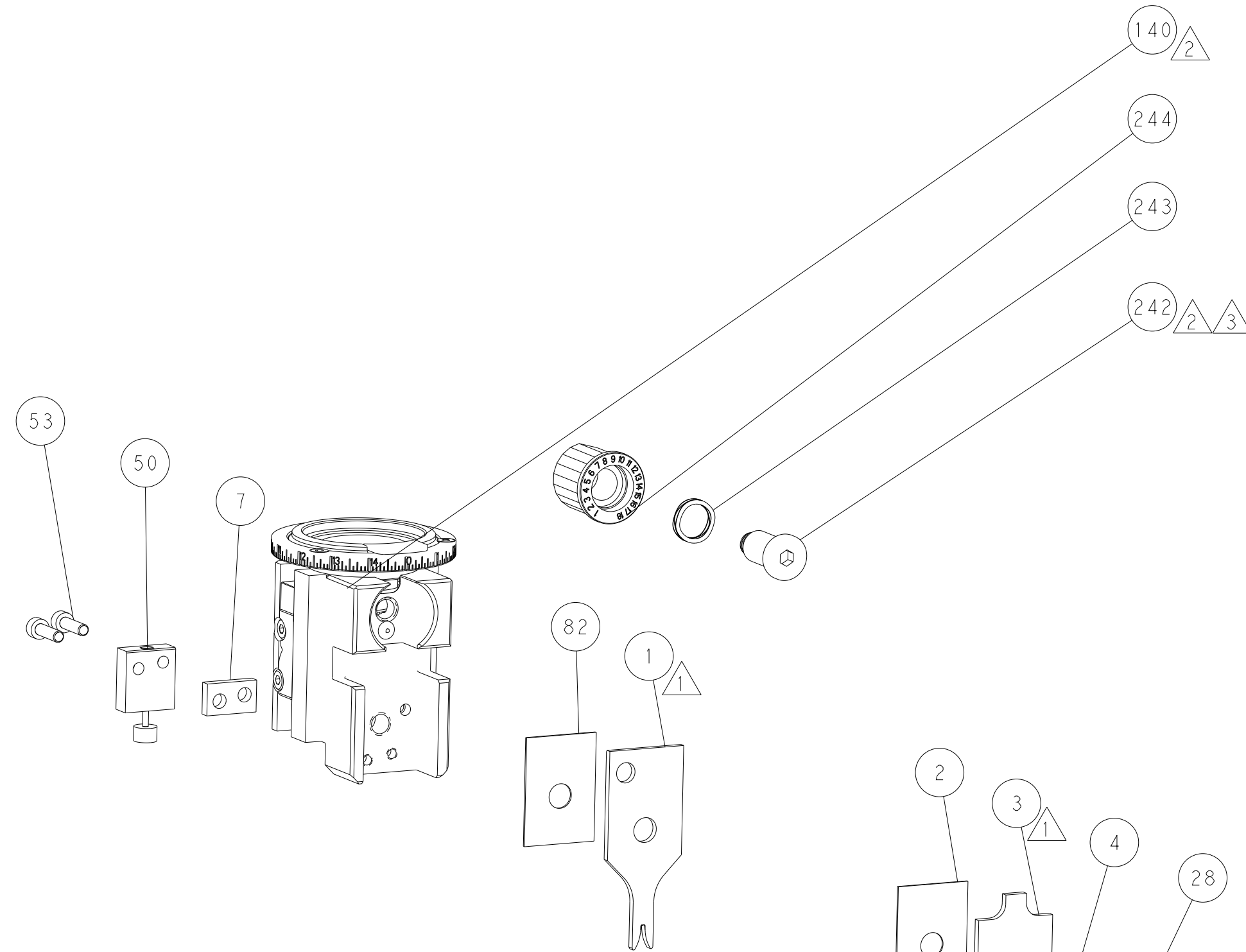
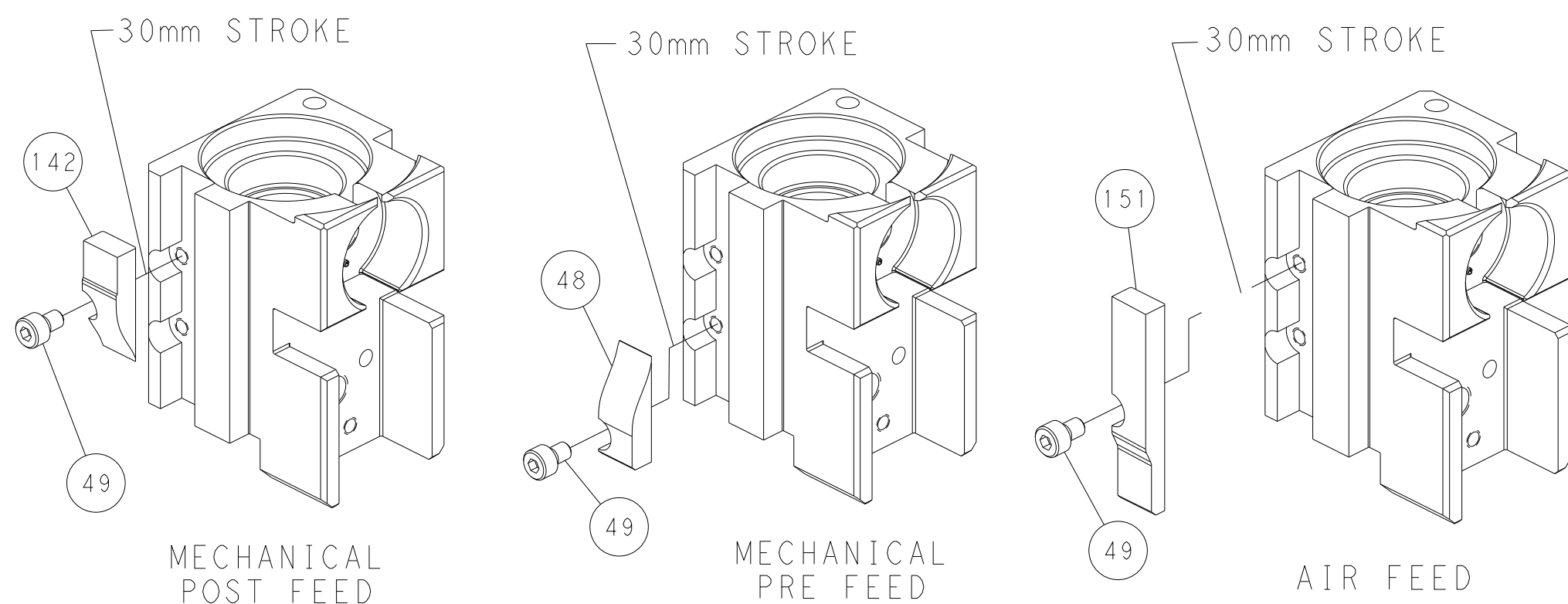


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

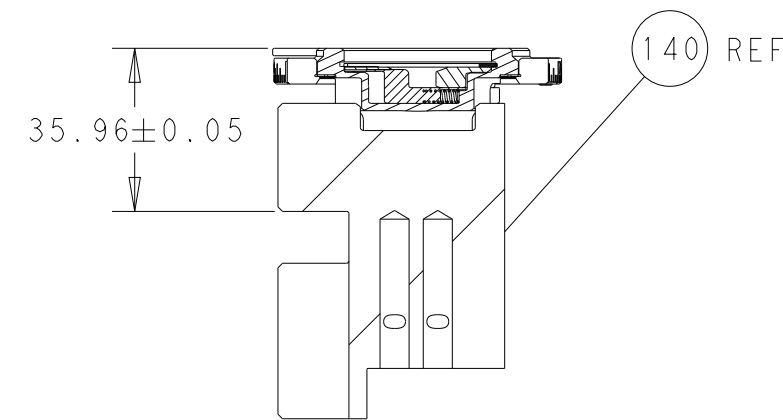


DETAIL A

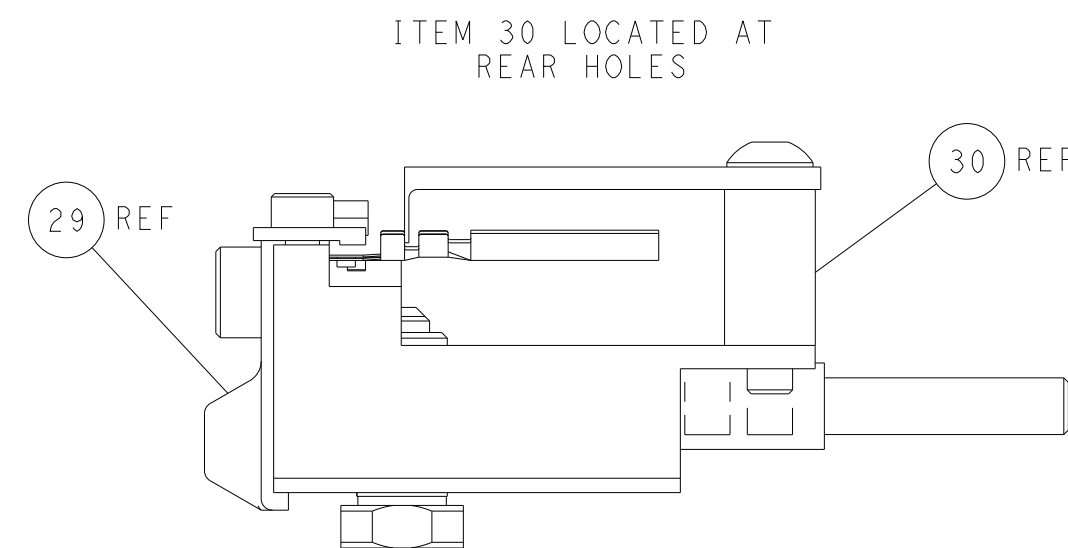
CAM POSITIONS



TERMINAL SUPPORT LOCATION

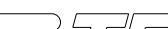


RAM SET-UP



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO COMPANY'S QUALITY CONTROL AND INSPECTION ORGANIZATION. SHOULD BE CONTROLLED FOR THE LATEST VERSION.				DWN	J. HOU	23JULY2014	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK	Y. YIN	23JULY2014					
				APVD	V. GUO	23JULY2014					
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:			NAME	Ocean Side Feed Appliator			
mm											
				0 PLC	±		PRODUCT SPEC	SIZE			
				1 PLC	±						
				2 PLC	±		APPLICATION SPEC	CAGE CODE			
				3 PLC	±						
				4 PLC	±			DRAWING NO			
				ANGLES							
MATERIAL				FINISH			WEIGHT	RESTRICTED TO			
							A 00779 C=2266419	SCALE			
							Customer Accessible Production Drawing	SHEET			
								4 of 4			
								REV D			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION