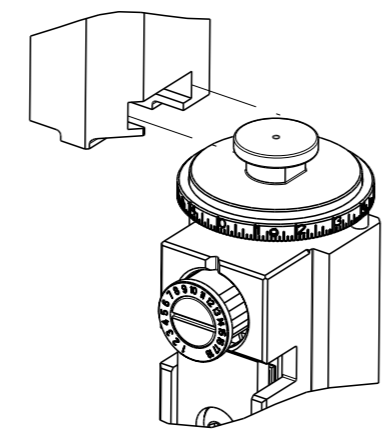


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266172-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266172-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266172-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266172-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266172-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.79 mm [.031]	F
INSUL	0.70 mm [.028]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL Molex CRIMP SPECIFICATION			
TERMINAL NAME: 1.5 WIRE TO WIRE CONN. CRIMP PLUG TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.40-1.90 mm [.055-.075 IN]	Ø0.50-1.00 mm [.020-.039 IN]		
TERMINAL APPLICATION SPECIFICATION 63900-4200-A Rev -			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113413-1	500618000	2113413-2	500618018
2113413-3	500618028	2113413-4	500618099
2113413-5	501338000		

TERMINAL DATA: MOLEX TERMINAL Molex CRIMP SPECIFICATION			
TERMINAL NAME: 1.5 WIRE TO WIRE CONN. CRIMP PLUG TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.40-1.90 mm [.055-.075 IN]	Ø 0.50-1.00 mm [.020-.039 IN]		
TERMINAL APPLICATION SPECIFICATION 63900-4200-A Rev -			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113413-6	501258000	2113413-7	500808000

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG	0.51+/-0.03 [.020+/- .001]	6.6
30 AWG	0.50+/-0.025 [.019+/- .001]	6.7
32 AWG	0.47+/-0.025 [.018+/- .001]	7.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.62+/-0.025 [.024+/- .001]	9.1
28 AWG	0.58+/-0.025 [.023+/- .001]	9.6

- 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.
- 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			
		REV	DATE	BY	CHKD
A	66	B1	20JAN2016	JH	GB
		B2	03MAR2016	JH	TE
		C	29APR2021	JAH	RK
		D	16AUG2021	FJ	TE

REV	DATE	BY	CHKD	DESCRIPTION	ITEM NO	
-	1	1	1	2119791-9	DEPRESSOR, WIRE	286
-	1	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	97
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1-455888-6	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53
-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	2-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	2-2844938-0	PLATE, STRIP GUIDE	31
-	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	980371-4	SCR, SKT HD SHLD 5.0 DIA X 6.0	23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	1	2-690518-8	HOLD DOWN, TERMINAL	18
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1633861-1	SHEAR, FLOATING	9
-	1	2	2	7-1633927-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	2-238011-8	BLOCK, CRIMPER SPACER	4
-	1	2	2	2-1803017-5	CRIMPER, INSULATION F	3
-	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	2	1633713-3	CRIMPER, WIRE PREMIUM	1

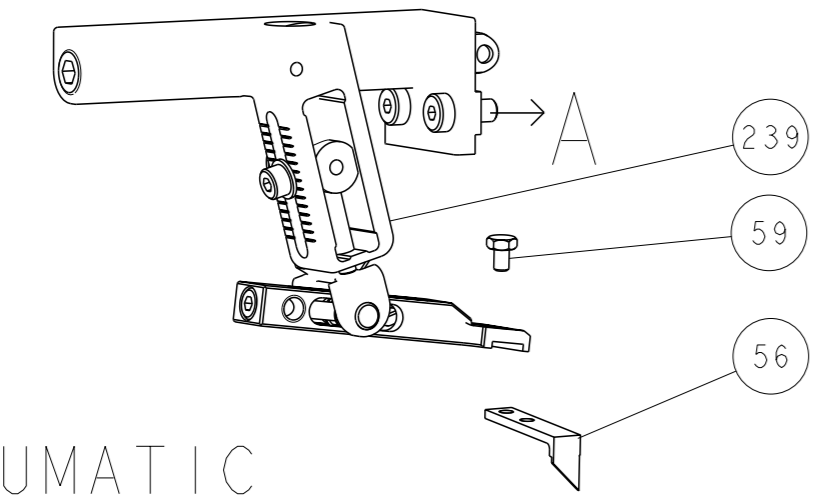
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

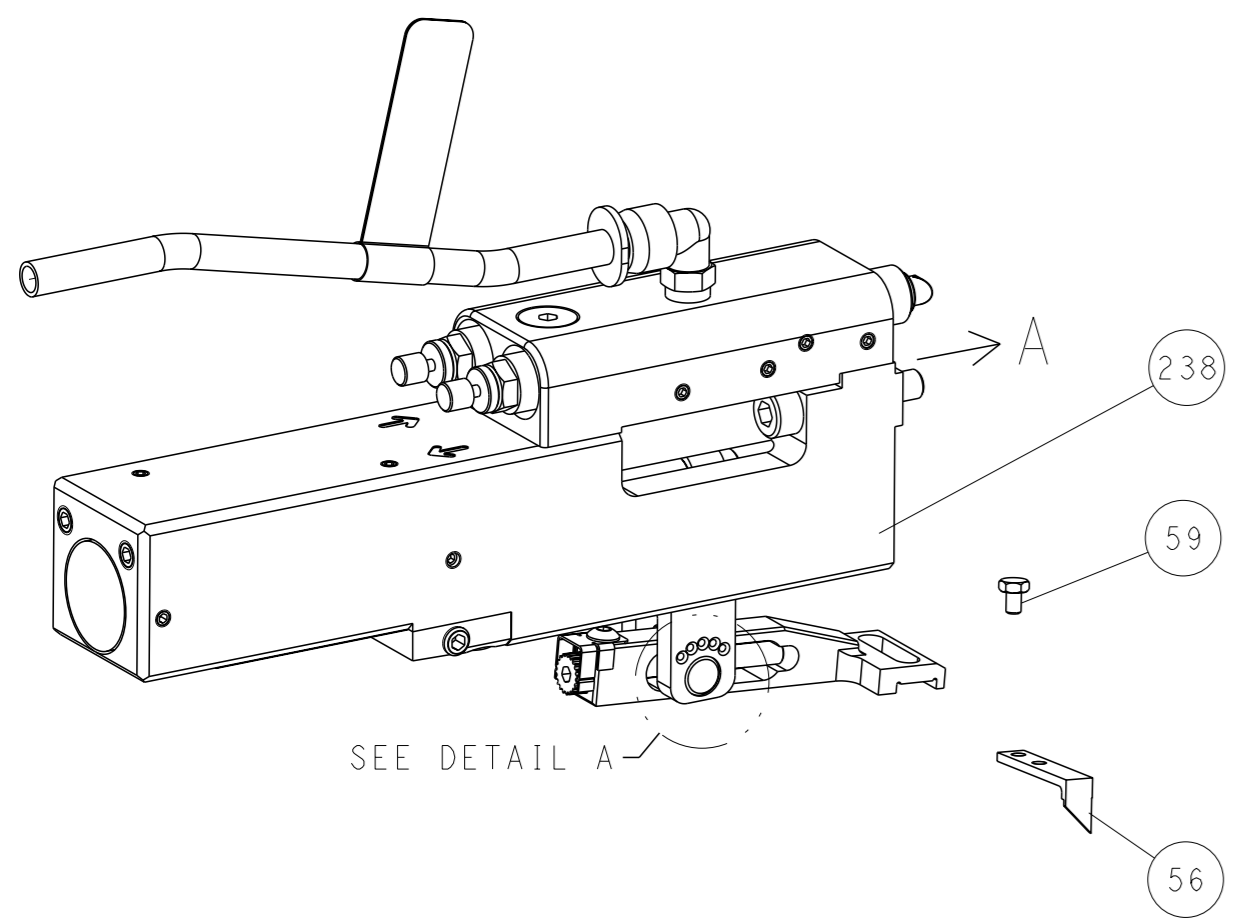
OWN	X. ZHAO	12DEC2013
CHK	L. ZHANG	12DEC2013
APVD	T. ELBIN	12DEC2013
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266172
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	D	

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

FEED TYPE MECHANICAL



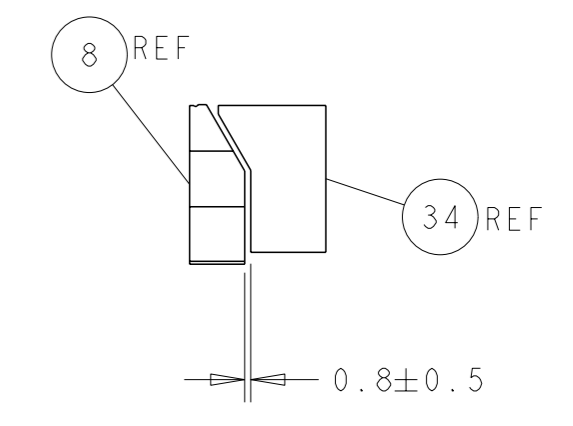
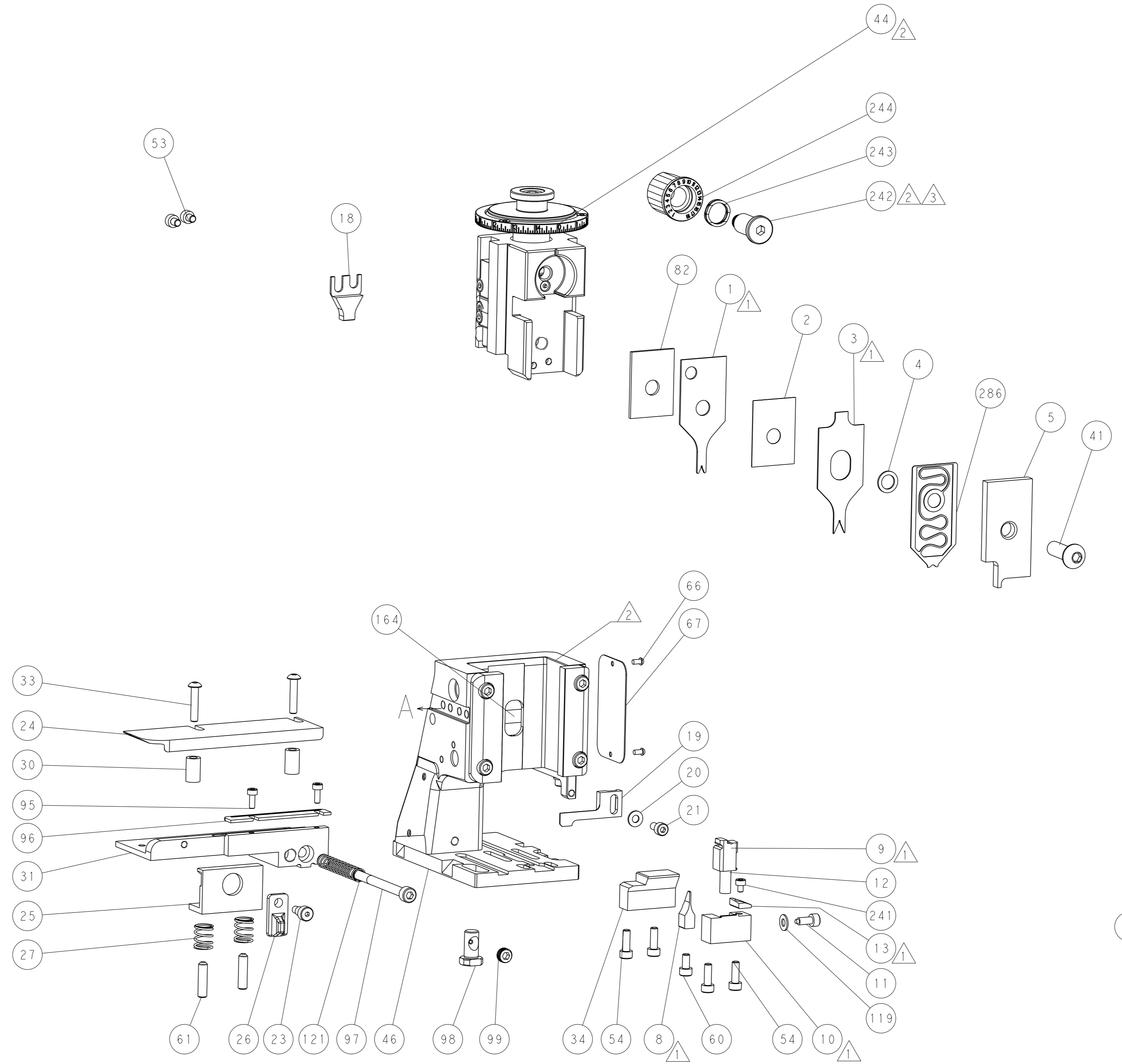
PNEUMATIC



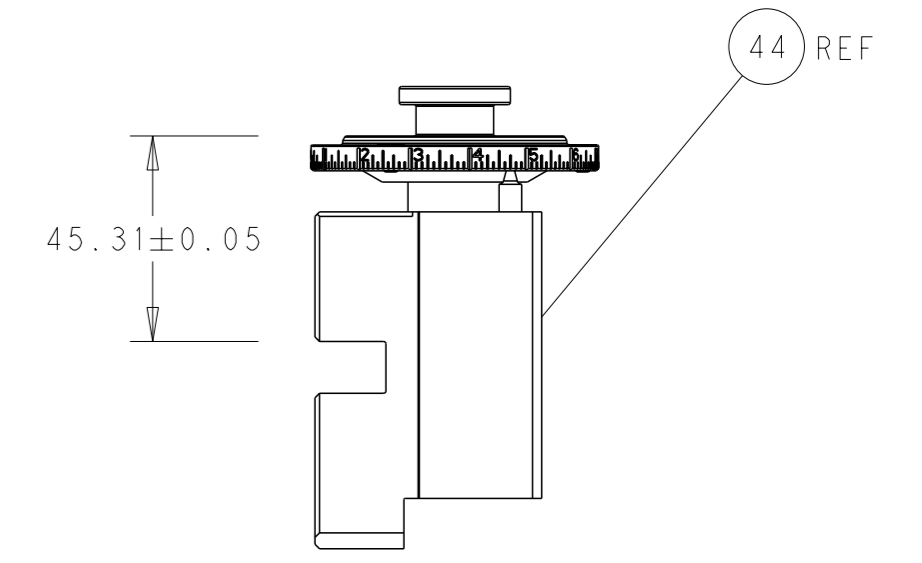
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



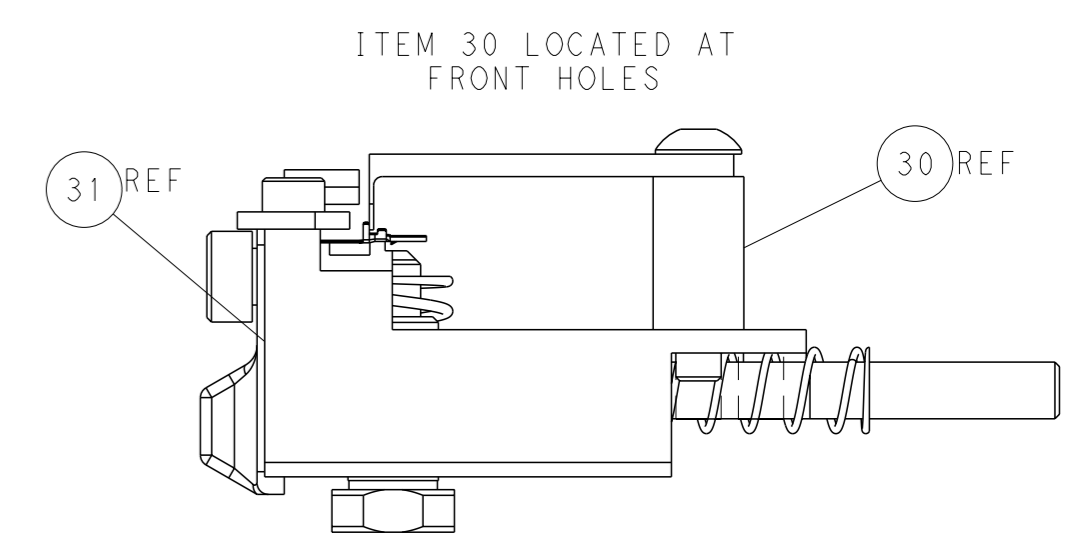
DETAIL A



TERMINAL SUPPORT LOCATION

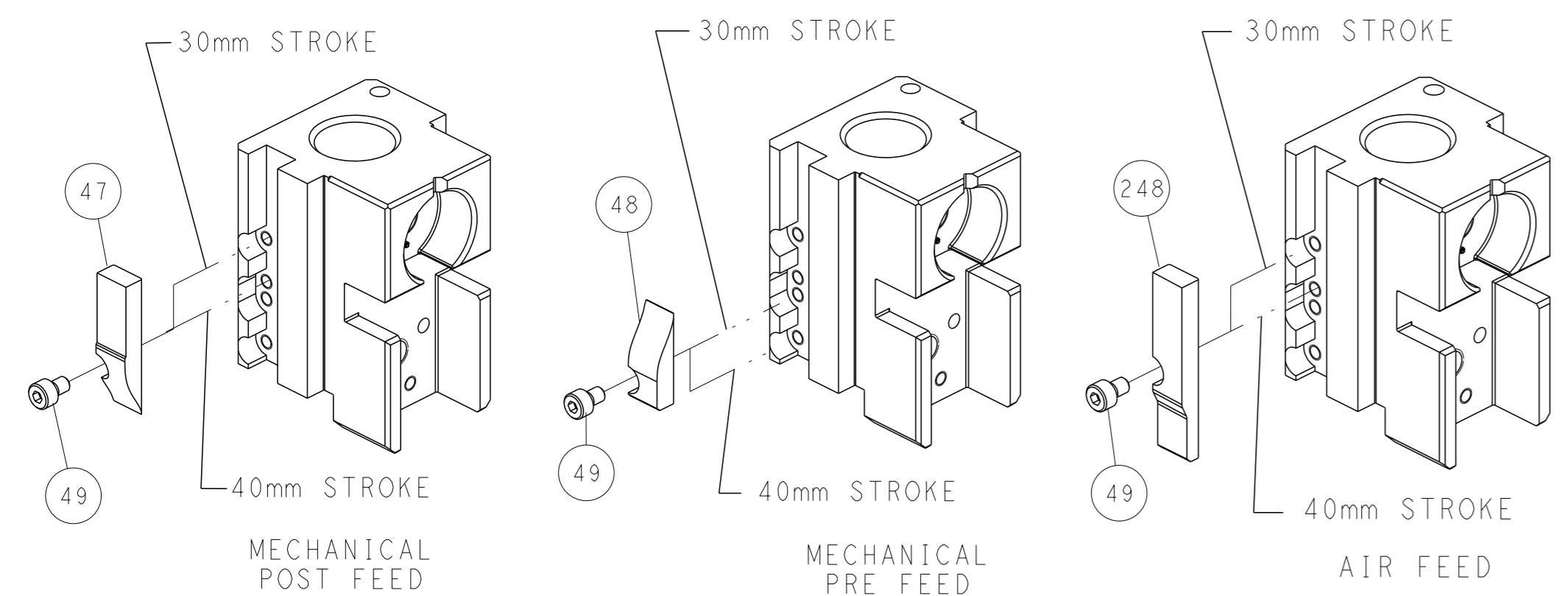


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

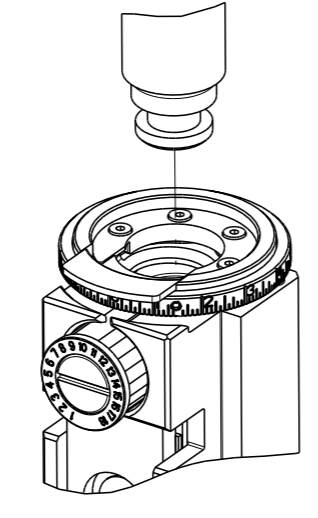


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<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 X ZHAO 12DEC2013 CHK T. ELBIN 12DEC2013 APVD L. ZHANG 12DEC2013	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 CAGE CODE DRAWING NO. A1 00779 ©=2266172 WEIGHT -	RESTRICTED TO - SCALE 1:2 SHEET 2 of 4 REV D
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266172-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266172-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266172-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	0.79 mm [.031]	F
INSUL	0.70 mm [.028]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: MOLEX TERMINAL Molex CRIMP SPECIFICATION
 TERMINAL NAME: 1.5 WIRE TO WIRE CONN. CRIMP PLUG TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
1.40-1.90 mm [.055-.075 IN]	Ø0.50-1.00 mm [.020-.039 IN]

TERMINAL APPLICATION SPECIFICATION 63900-4200-A Rev -

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113413-1	500618000	2113413-2	500618018
2113413-3	500618028	2113413-4	500618099
2113413-5	501338000		

TERMINAL DATA: MOLEX TERMINAL Molex CRIMP SPECIFICATION
 TERMINAL NAME: 1.5 WIRE TO WIRE CONN. CRIMP PLUG TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
1.40-1.90 mm [.055-.075 IN]	Ø 0.50-1.00 mm [.020-.039 IN]

TERMINAL APPLICATION SPECIFICATION 63900-4200-A Rev -

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113413-6	501258000	2113413-7	500808000

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG	0.51+/-0.03 [.020+/- .001]	6.6
30 AWG	0.50+/-0.025 [.019+/- .001]	6.7
32 AWG	0.47+/-0.025 [.018+/- .001]	7.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.62+/-0.025 [.024+/- .001]	9.1
28 AWG	0.58+/-0.025 [.023+/- .001]	9.6

- 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.
- 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 A DIST 66

REVISIONS			
REV	DATE	DESCRIPTION	BY
-	-	SEE SHEET 1	-

-	1	1	2119791-9	DEPRESSOR, WIRE	286
-	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	97
-	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	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
-	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	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53
-	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	2-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	2-2844938-0	PLATE, STRIP GUIDE	31
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	2	2	22283-1	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	2-690518-8	HOLD DOWN, TERMINAL	18
-	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	1633861-1	SHEAR, FLOATING	9
-	1	1	7-1633927-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	2-1803017-5	CRIMPER, INSULATION F	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	1633713-3	CRIMPER, WIRE PREMIUM	1

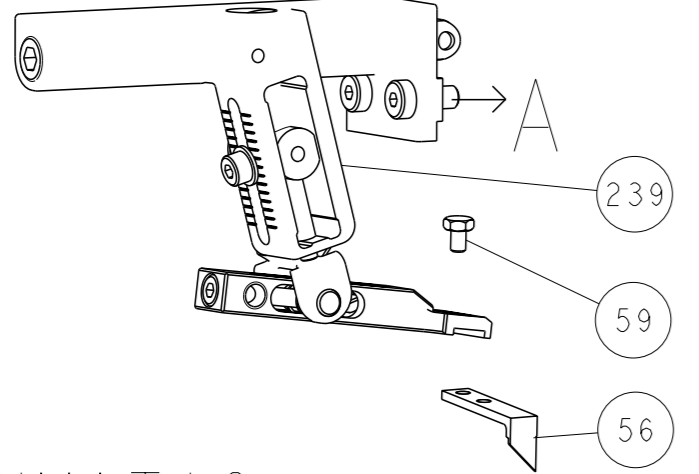
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±	FINISH *			
MATERIAL			WEIGHT	SCALE	RESTRICTED TO
				1:2	

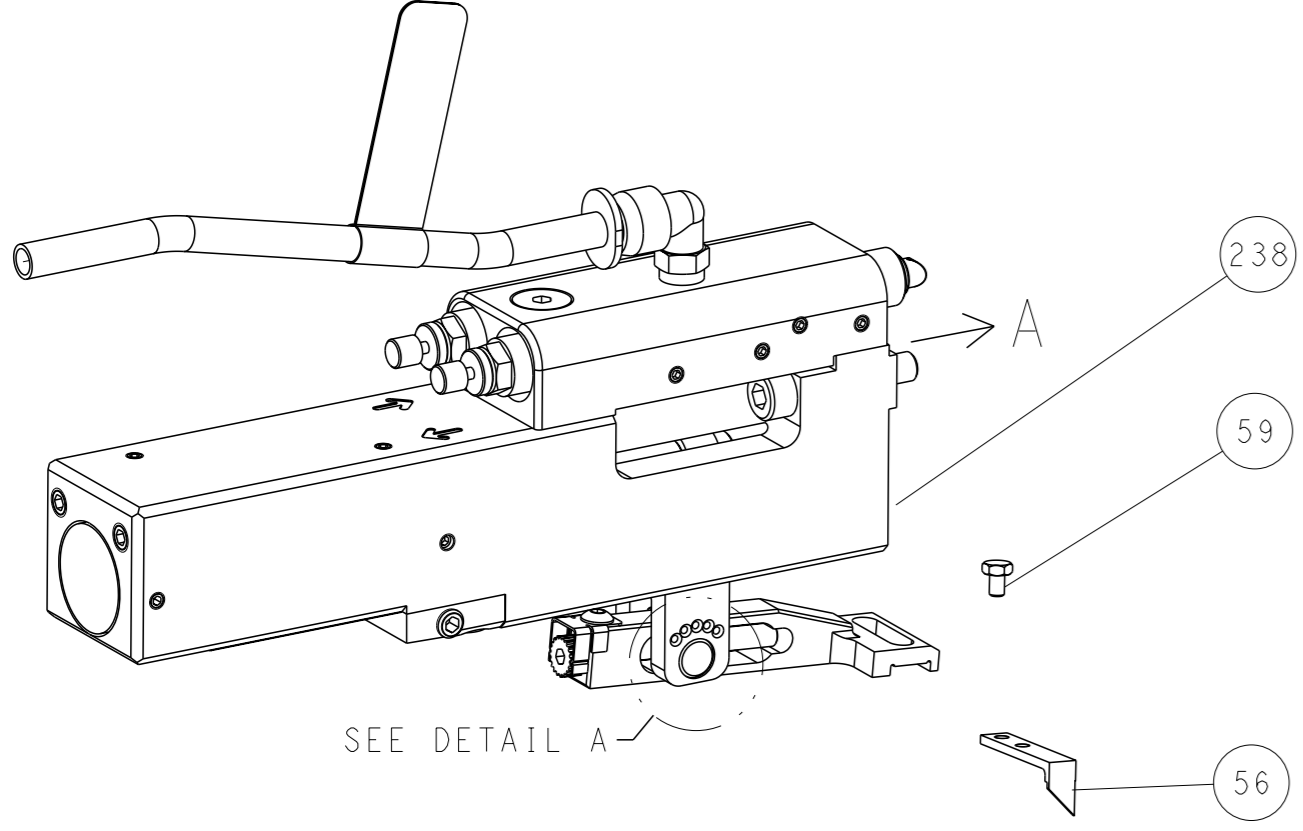
Customer Accessible Production Drawing

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

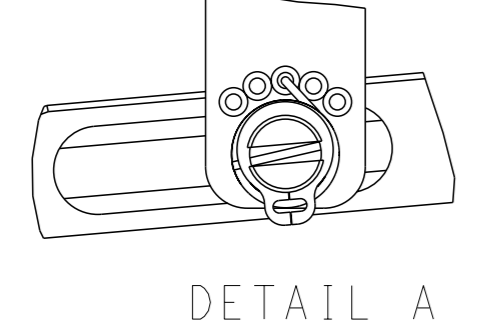
FEED TYPE MECHANICAL



PNEUMATIC

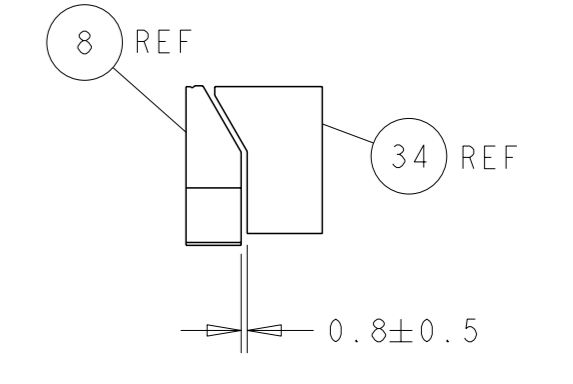
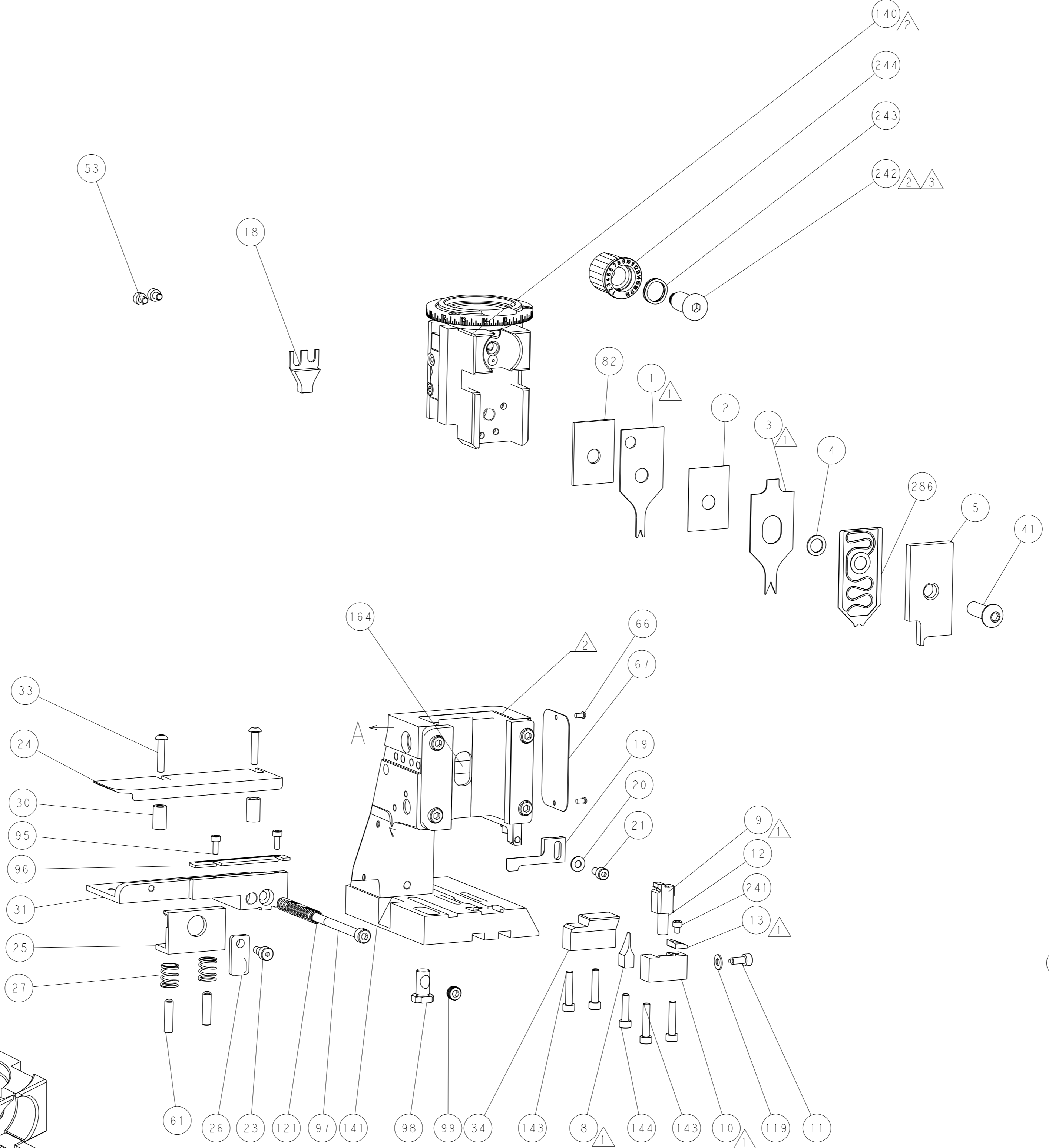
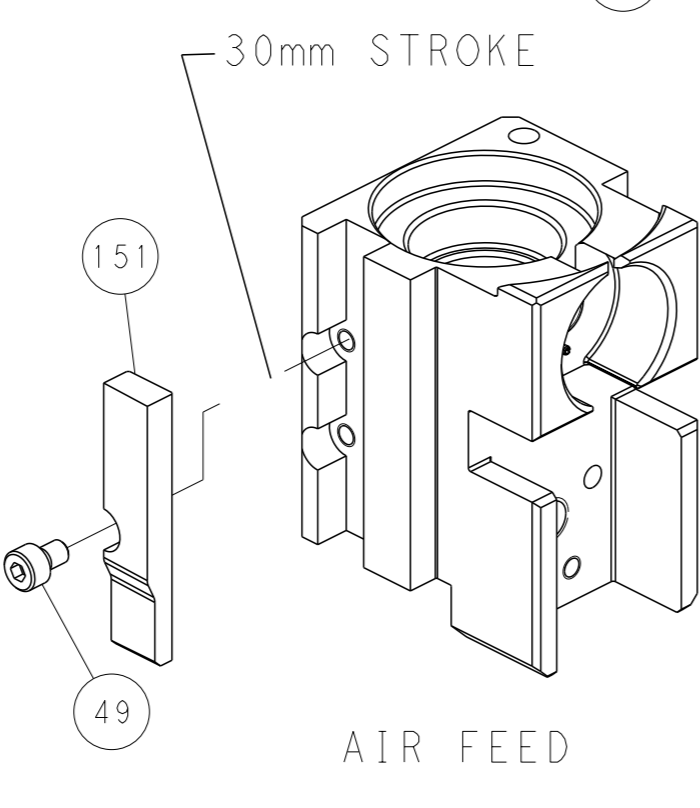
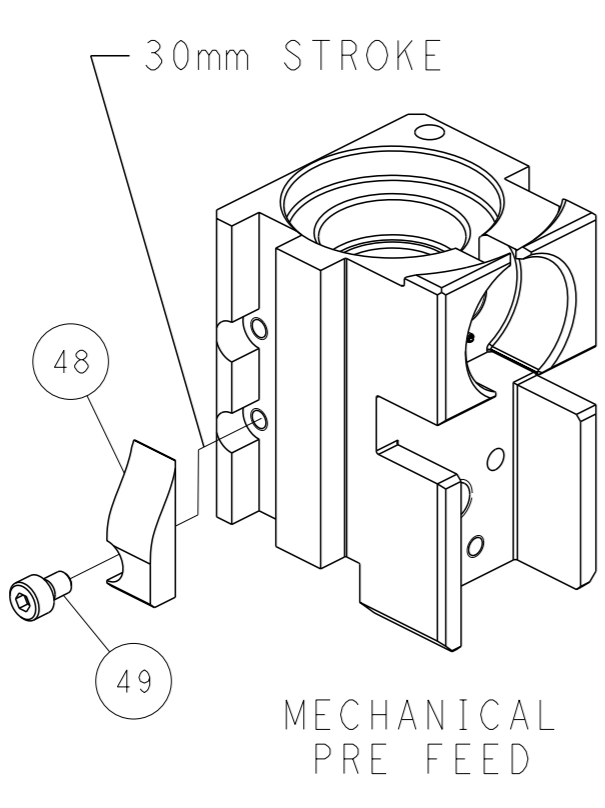
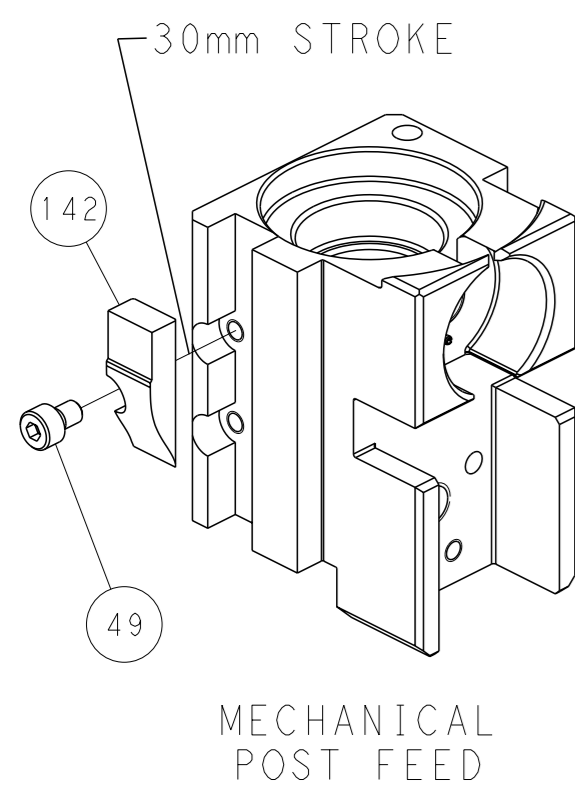


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

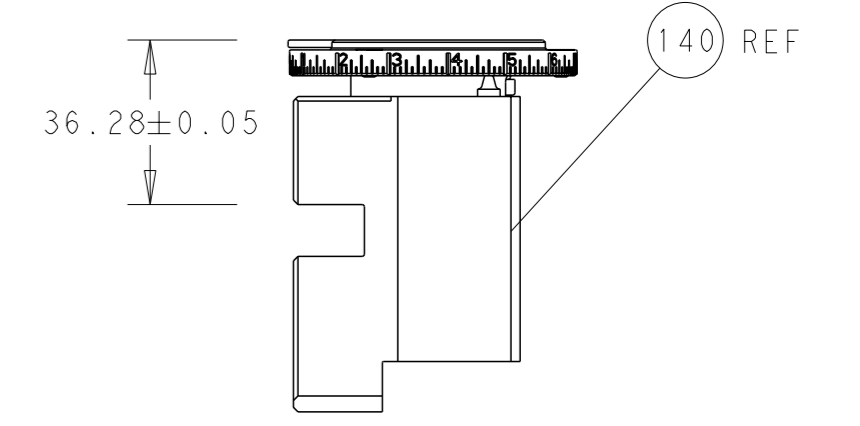


DETAIL A

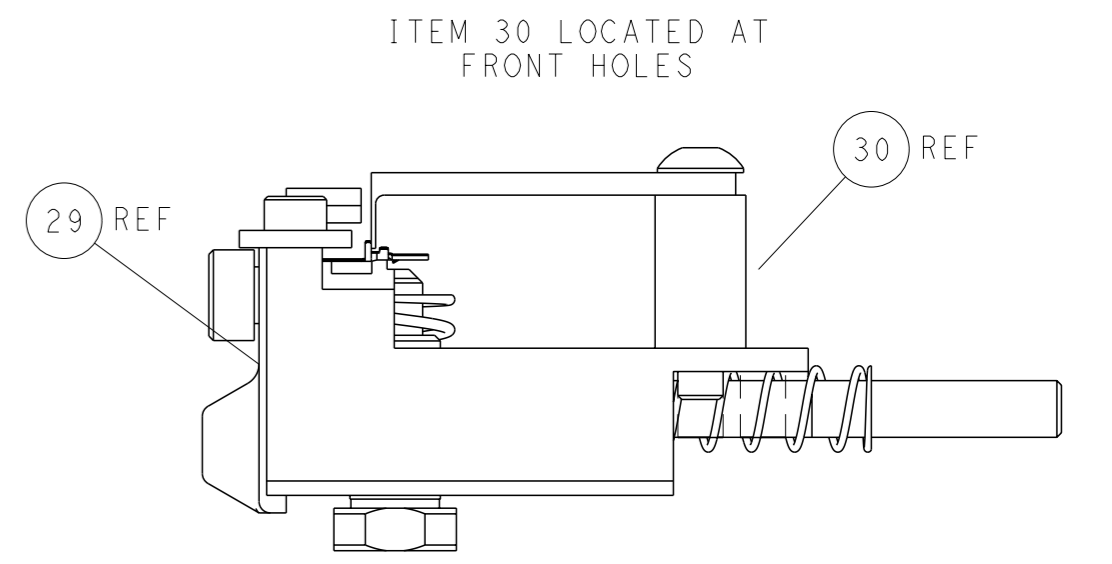
CAM POSITIONS



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)

<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: X. ZHAO 12DEC2013 CHK: L. ZHANG 12DEC2013 APVD: J. ELBIN 12DEC2013	STE 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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266172	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: D
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION