

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266325-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266325-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266325-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266325-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266325-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.99 mm [.039]	F
INSUL	1.40 mm [.055]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: CTW MINITEK			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.20-2.20 mm [.047-.087 IN]	∅ 1.40 mm [.055 IN] MAX		
TERMINAL APPLICATION SPECIFICATION	100-006 Rev F		
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1572037-1	77138-001LF	1572037-3	77138-201LF
1572037-2	77138-101LF	1572037-4	77138-T01LF

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG OR 0.13mm2	0.655+/-0.025 [.026+/-0.001]	4.9
28 AWG OR 0.08mm2	0.625+/-0.025 [.025+/-0.001]	5.2
30 AWG OR 0.05mm2	0.595+/-0.025 [.023+/-0.001]	5.6

- 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.
- 6. 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.

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	28JUL2014	RW	TE
		B		ECR-18-007814	29MAY2018	FZ	KZ
		C		ECR-19-011962	30JUL2019	FZ	TE

-	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	2119082-5	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	-	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	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	2-455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1962431-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	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
-	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	2-2844962-3	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	2119533-4	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	1333230-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119780-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	4-1633962-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2
-	1	2	2	1	1490019-8	CRIMPER, WIRE PREMIUM	1

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

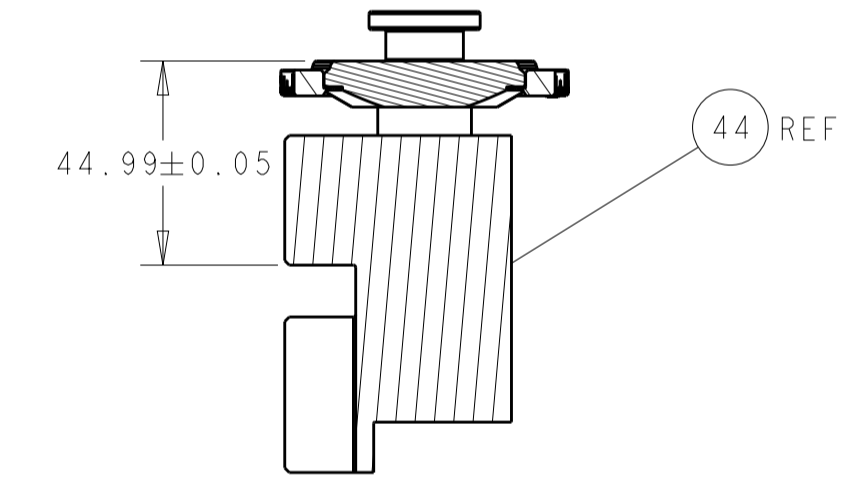
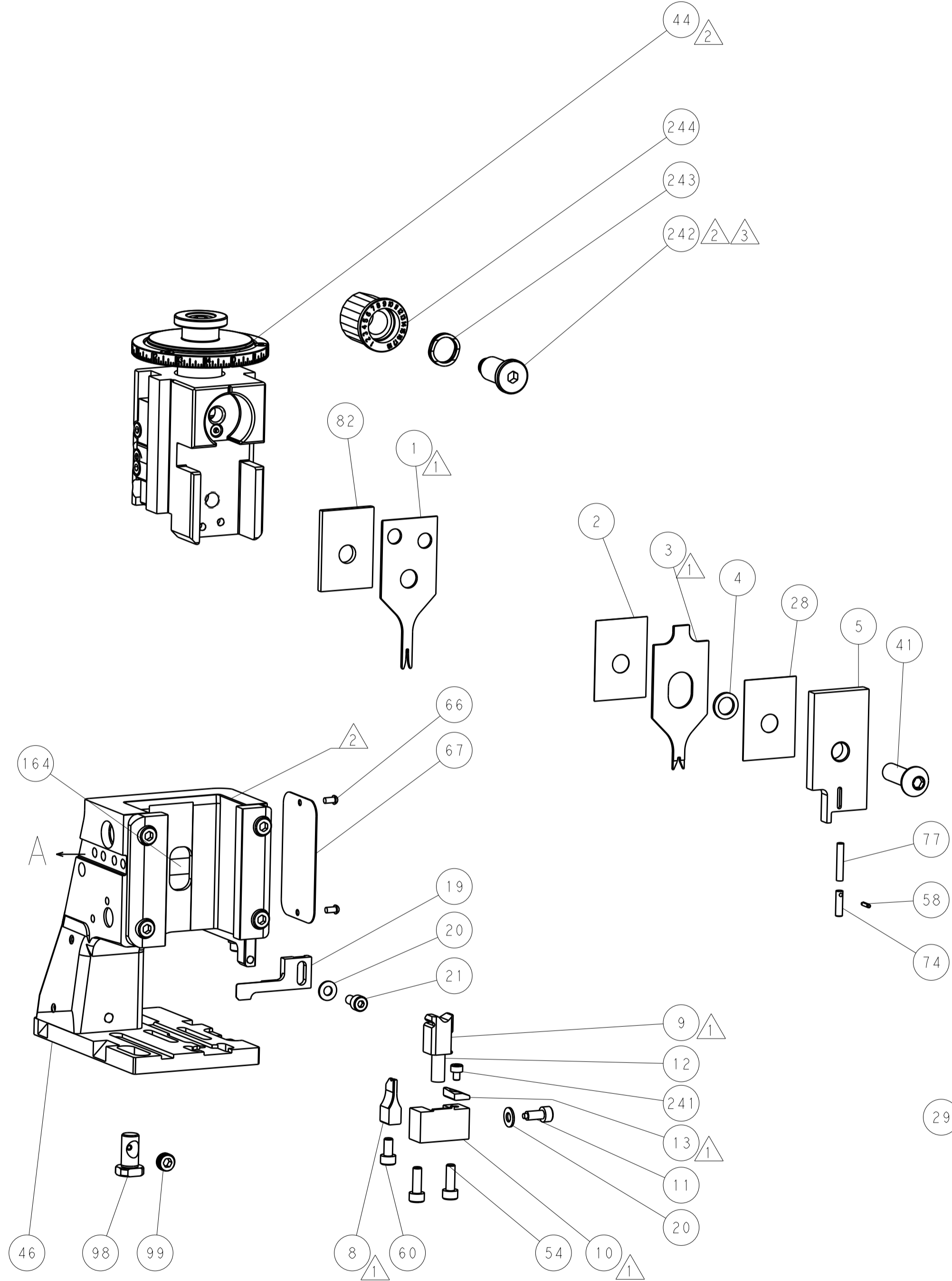
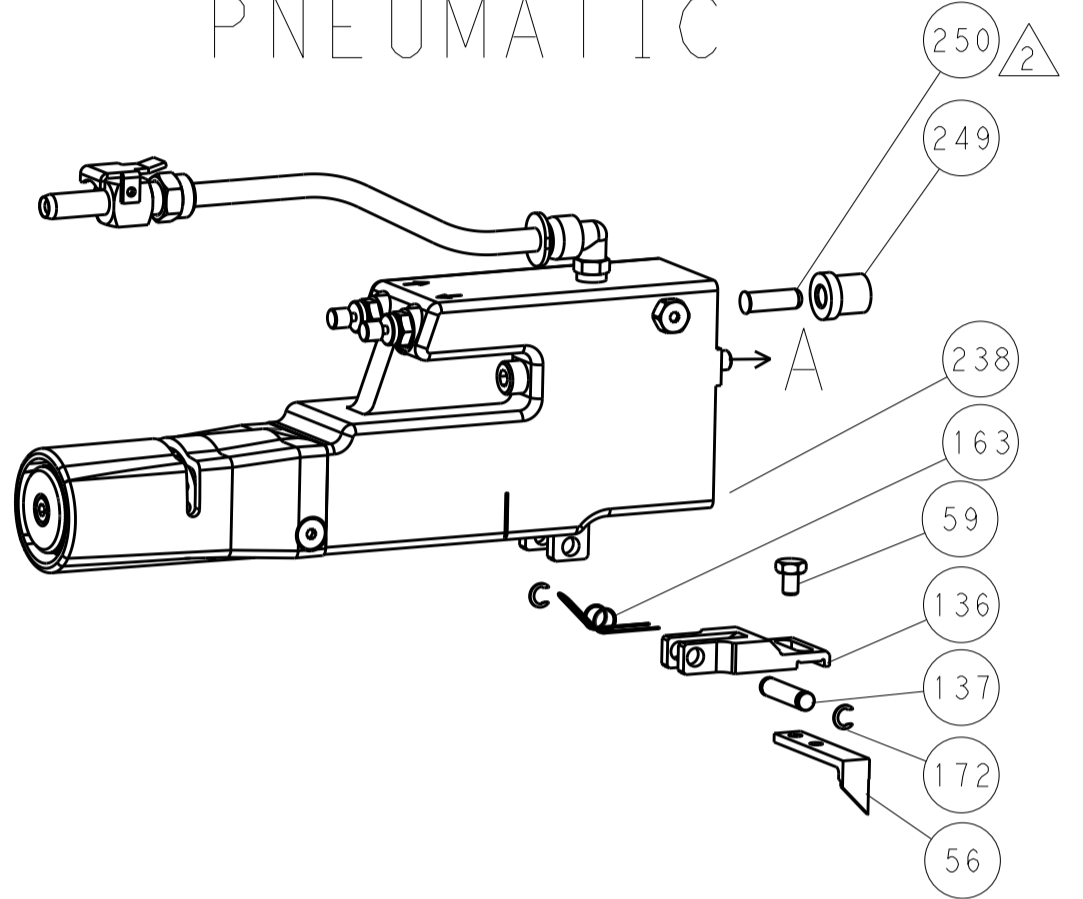
DATE	11 JUN 2014	OWN	R. O. WILSON
CHK	12 JUN 2014	CHK	K. J. STAKEM
APVD	12 JUN 2014	NAME	T. L. ELBIN
PRODUCT SPEC		APPLICATION SPEC	
SIZE	A1	CAGE CODE	00779
DRAWING NO	2266325	RESTRICTED TO	
SCALE	1:2	SHEET	1 OF 4
REV	C		

LOC	DIST	REV	DATE	BY	APPV
A	66				

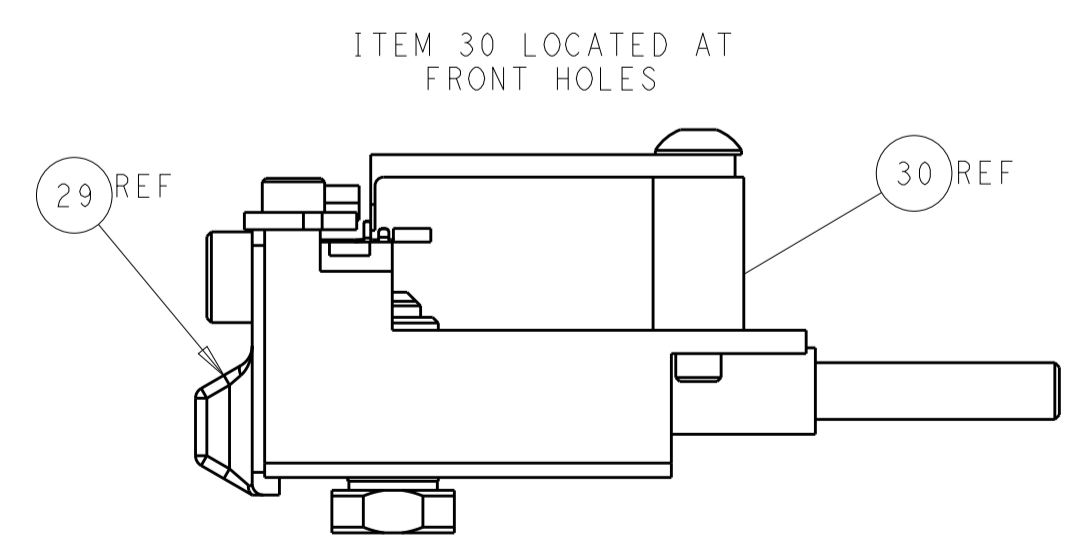
FEED TYPE MECHANICAL



PNEUMATIC

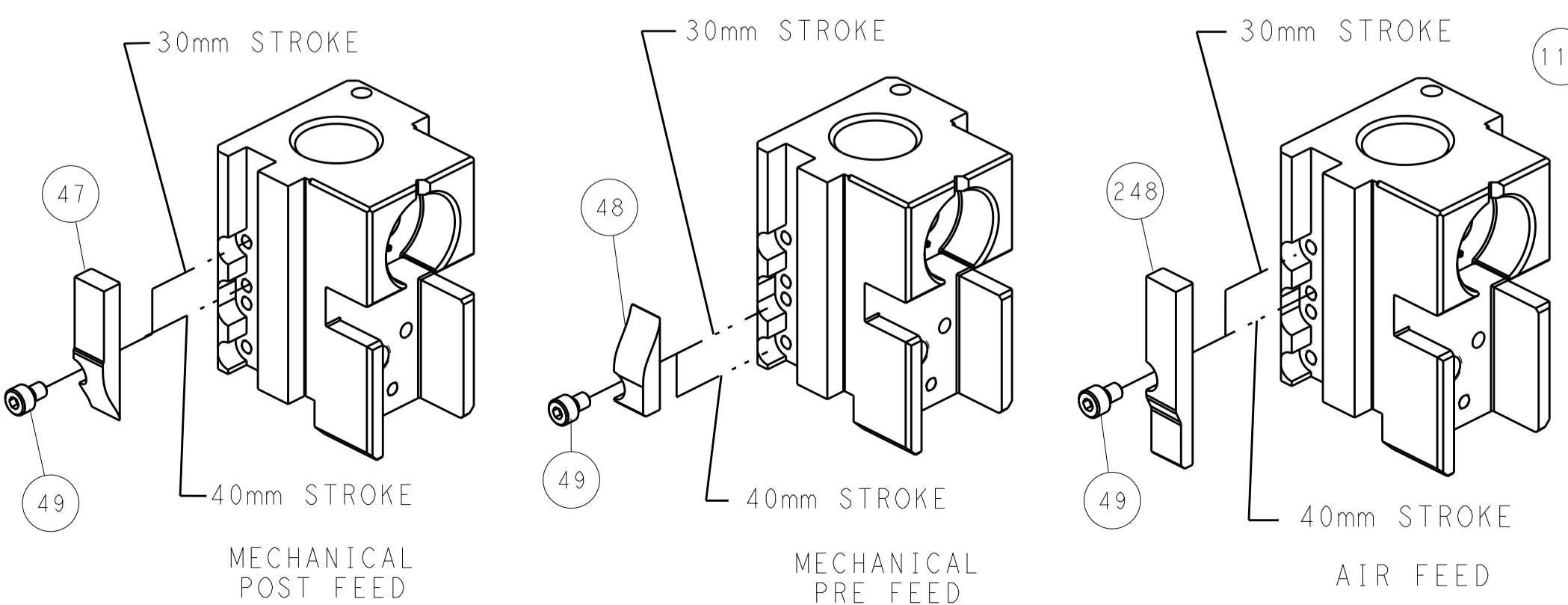


RAM SET-UP



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN R. Q. WILSON 11JUN2014 CHK K. J. STAKEM 12JUN2014 APVD T. L. ELBIN 12JUN2014 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2266325 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV C	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266325-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266325-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266325-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.99 mm [.039]	F
INSUL	1.40 mm [.055]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: CTW MINITEK			
WIRE STRIP LENGTH 1.20-2.20 mm [.047-.087 IN]		INSULATION DIAMETER RANGE Ø 1.40 mm [.055 IN] MAX	
TERMINAL APPLICATION SPECIFICATION 100-006 Rev F			
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1572037-1	77138-001LF	1572037-3	77138-201LF
1572037-2	77138-101LF	1572037-4	77138-T01LF

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG OR 0.13mm ²	0.655+/-0.025 [.026+/-0.001]	4.9
28 AWG OR 0.08mm ²	0.625+/-0.025 [.025+/-0.001]	5.2
30 AWG OR 0.05mm ²	0.595+/-0.025 [.023+/-0.001]	5.6

- 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.
- 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.

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	APPV
A	66	-	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	-	-	2119640-1 PUSH ROD, AIR FEED	250
-	1	-	-	1803259-1 BUSHING, FLANGED	249
-	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	-	-	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	-	2119955-1 ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	-	2844908-1 SCREW, LOCKING	99
-	1	1	-	2844907-1 POST, LOCKING	98
-	1	1	-	2-455888-5 SPACER, CRIMPER	82
-	1	1	-	1962431-2 SPRING, COMPRESSION	77
-	1	1	-	854769-4 HOLDER, INS	74
-	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	-	21028-2 PIN, SLOTTED SPRING .062 X .250	58
-	1	1	-	1338685-1 PAWL, FEED	56
-	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	-	2-2844962-3 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	-	2119533-4 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	1333230-3 ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	-	2119780-5 DEPRESSOR, SHEAR	5
-	1	1	-	2-238011-0 BLOCK, CRIMPER SPACER	4
-	1	1	1	4-1633962-2 CRIMPER, INSULATION F PREMIUM	3
-	1	1	-	455888-2 SPACER, CRIMPER	2
-	1	1	1	1490019-8 CRIMPER, WIRE PREMIUM	1

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

DATE	11 JUN 2014	CHK	R. O. WILSON
DATE	12 JUN 2014	CHK	K. J. STAKEM
DATE	12 JUN 2014	APPV	T. L. ELBIN

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266325	-

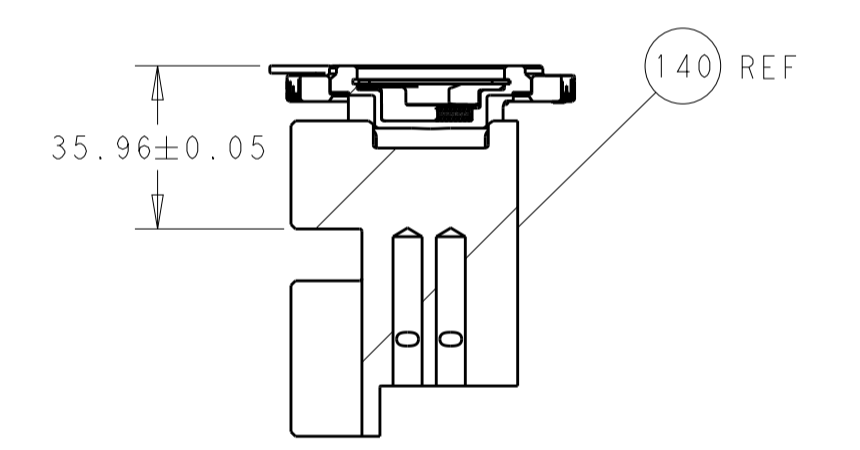
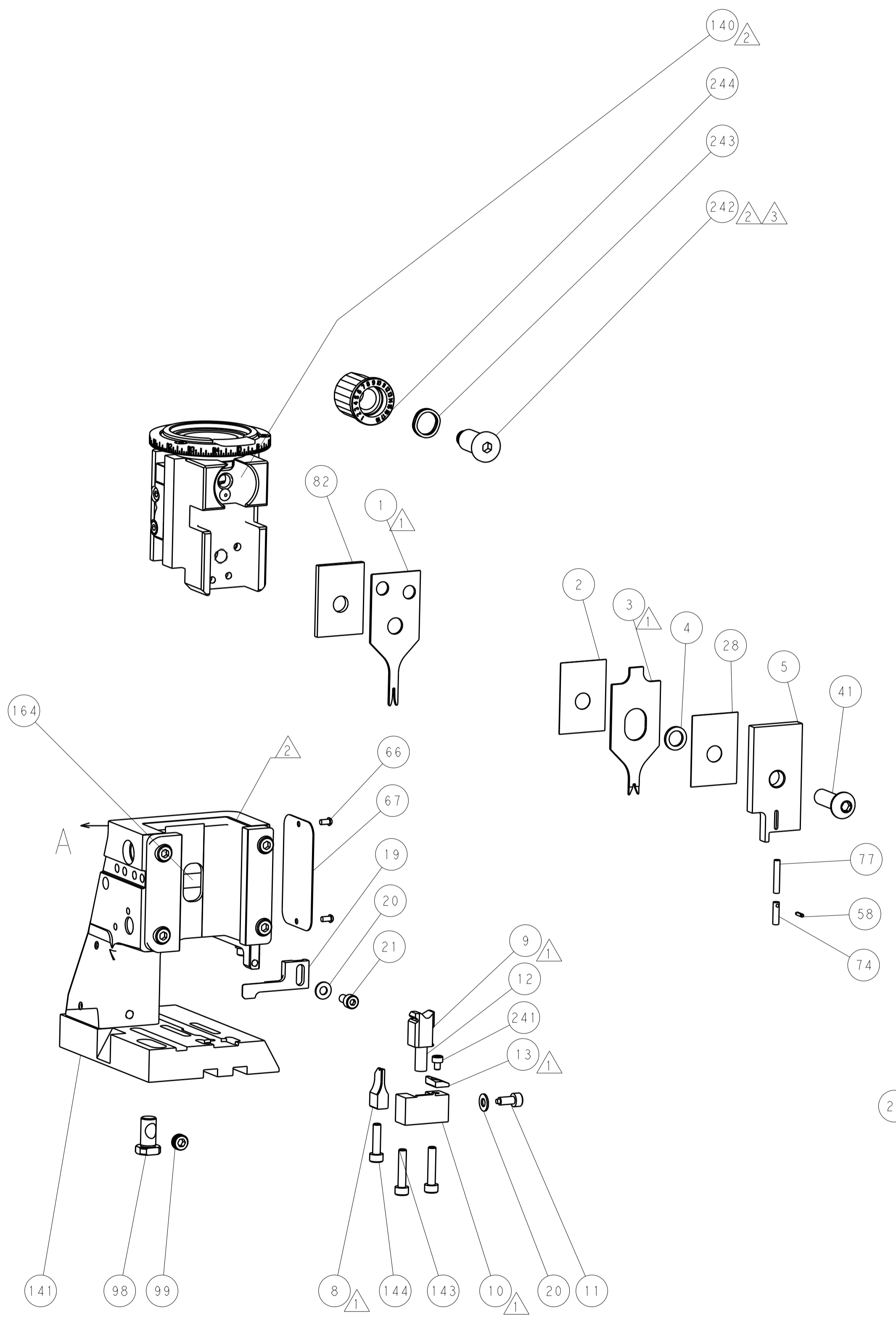
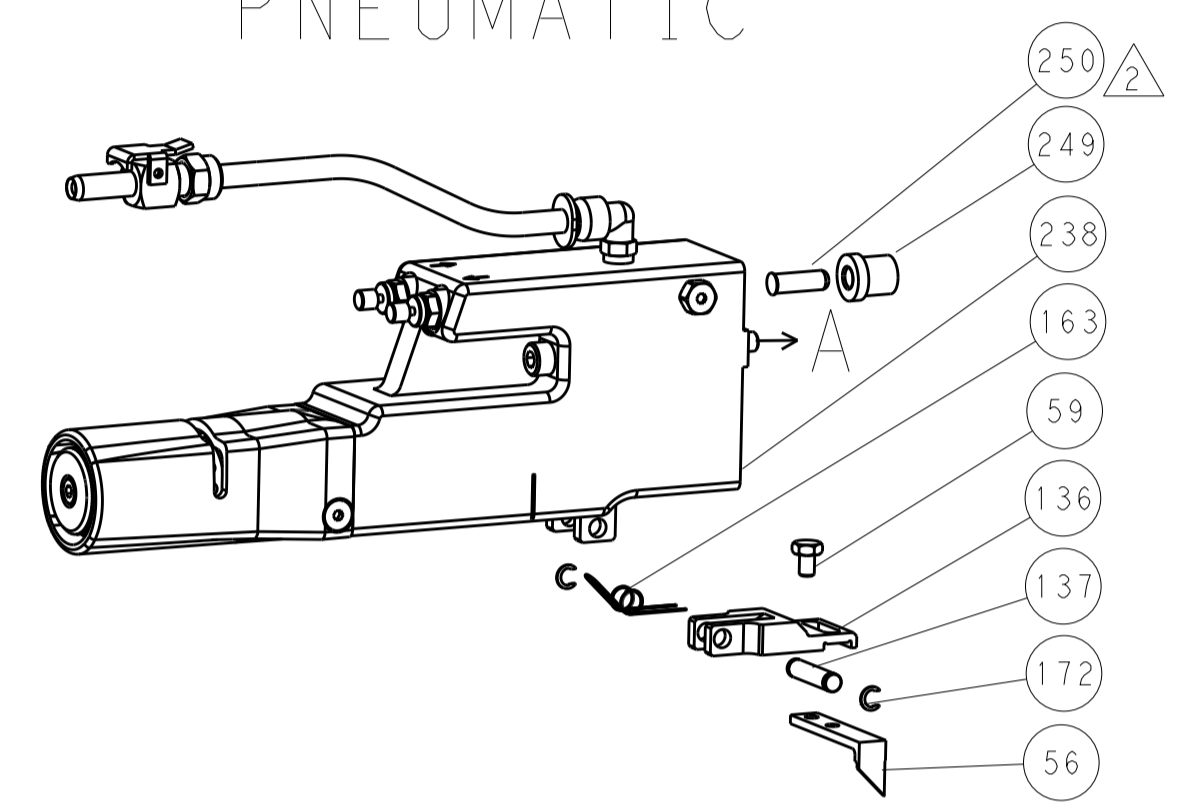
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV C

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

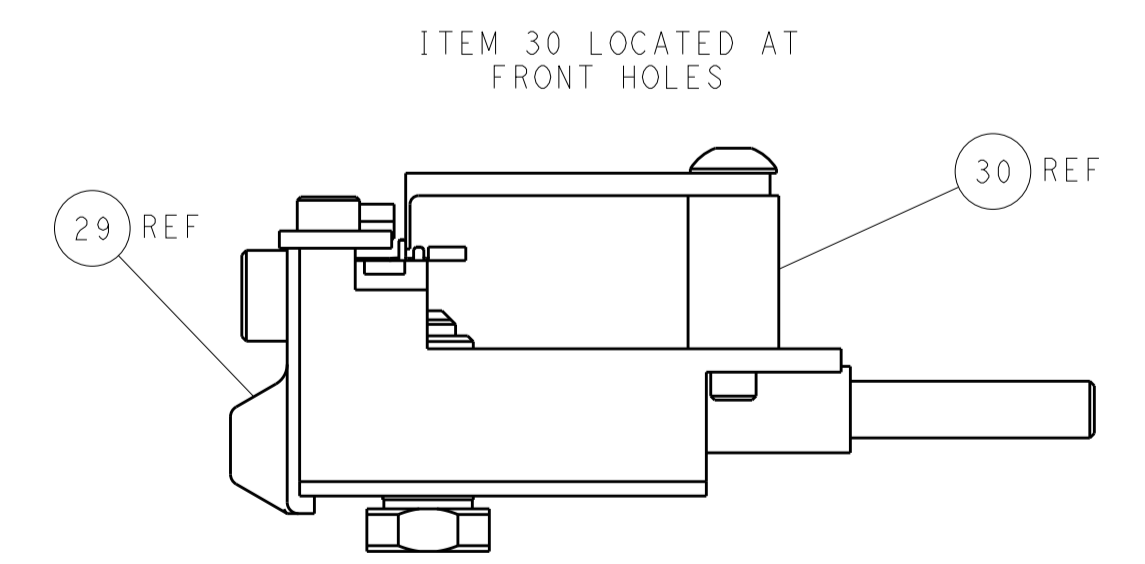
FEED TYPE MECHANICAL



PNEUMATIC

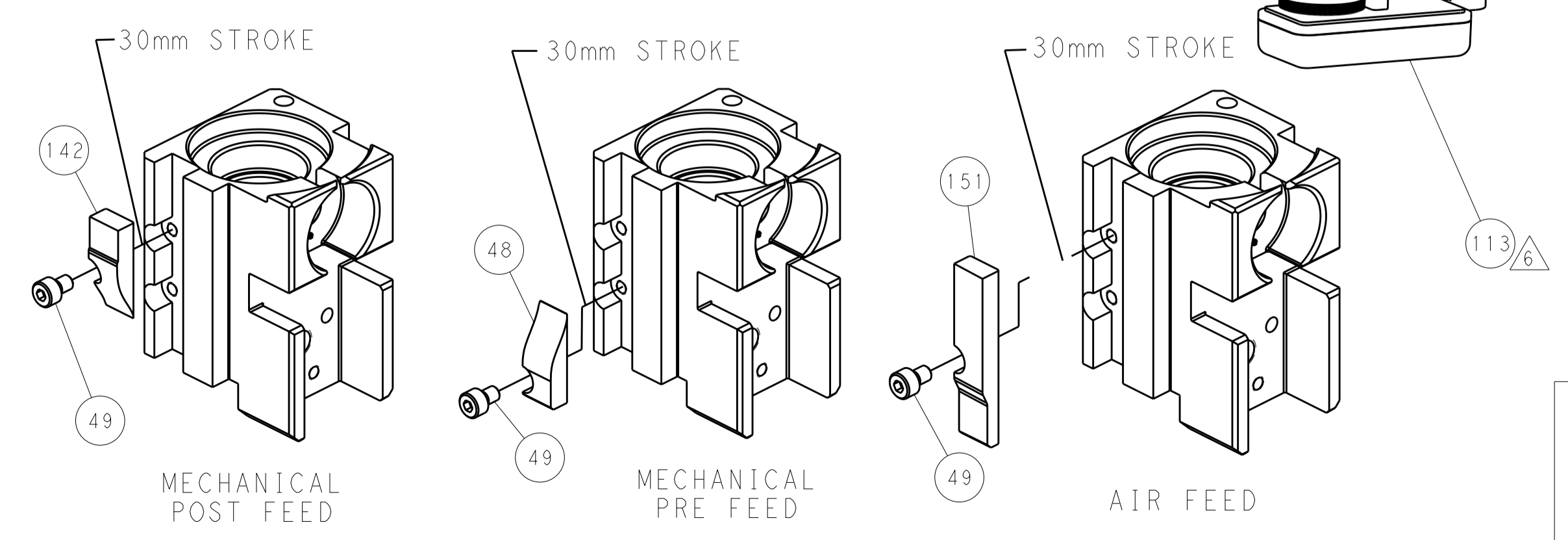


RAM SET-UP



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266325 SCALE: 1:2 SHEET: 4 OF 4 REV: C