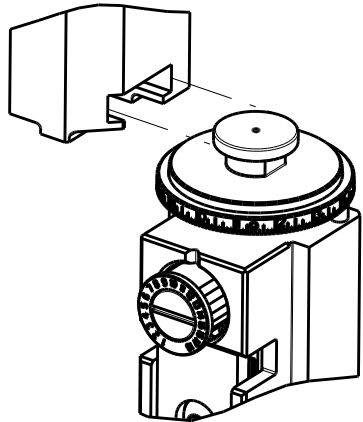
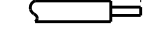




8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266513-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266513-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266513-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266513-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266513-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.57 mm [.062]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: 2.2 mm PITCH CONNECTOR, J1000 SERIES			
WIRE STRIP LENGTH 3.50-4.00 mm [.138-.157 IN]			INSULATION DIAMETER RANGE Ø1.60-2.10 mm [.063-.083 IN]
TERMINAL APPLICATION SPECIFICATION		JST SF1M-21 Rev -	-
			
TERMINALS APPLIED 			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2082172-1	SF1F-21T-P0.6	2082172-2	SF1F-21GC-P0.6
2082173-1	SF1M-21T-M0.6A	2082173-2	SF1M-21GC-M0.6A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.80mm2	1.15+/-0.05 [.045+/- .002]	6.0
20 AWG OR 0.50mm2	1.05+/-0.05 [.041+/- .002]	7.0
22 AWG OR 0.30mm2	0.95+/-0.05 [.037+/- .002]	8.0



- 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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		A		RELEASE	12APR2017	MZ	CT
		B		ECR-17-009430	28JUNE2017	TB	CT
		C		ECR-19-004880	27MAR2019	FL	CT

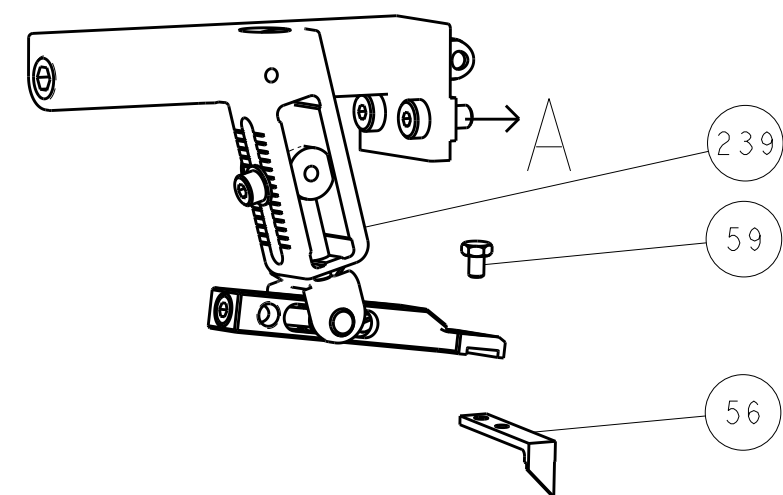
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	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
	-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	1	1	1	1	2119083-1	RETAINER, INSULATION 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	
6	-	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	455888-5	SPACER, CRIMPER	82	
	-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
	-	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1752356-3	SUPPORT, TERMINAL	34	
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
1	-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
	-	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	2119533-1	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	1803095-3	FLOATING SHEAR, FRONT -	9	
	-	1	2	2	1	1	6-1633918-1	ANVIL, COMBINATION	8
1	-	1	1	1	1	5-240641-4	SPACER	7	
	-	-	-	-	-	-	-	6	
	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
	-	1	1	1	1	1-238011-8	BLOCK, CRIMPER SPACER	4	
	-	1	2	2	1	1	3-1803246-4	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	-	-	2	
	-	1	2	2	1	1	1-1633713-5	CRIMPER, WIRE PREMIUM	1
	-	77	72	71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST EDITION.		DWN M. ZHAO 24MAR2017	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK K. ZHANG 24MAR2017	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD K. ZHANG 24MAR2017	PRODUCT SPEC APPLICATION SPEC	
MATERIAL		WEIGHT	SIZE A1	CAGE CODE 00779
Customer Accessible Production Drawing		SCALE 1:2	DRAWING NO C=2266513	RESTRICTED TO -
		SHEET 1	OF 4	REV C

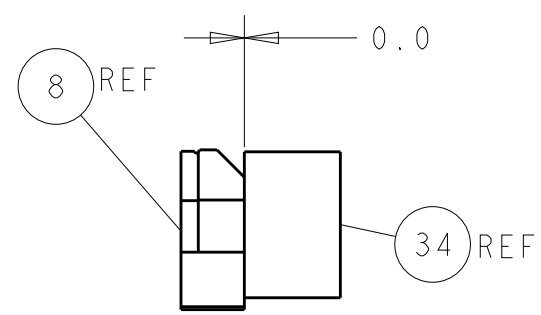
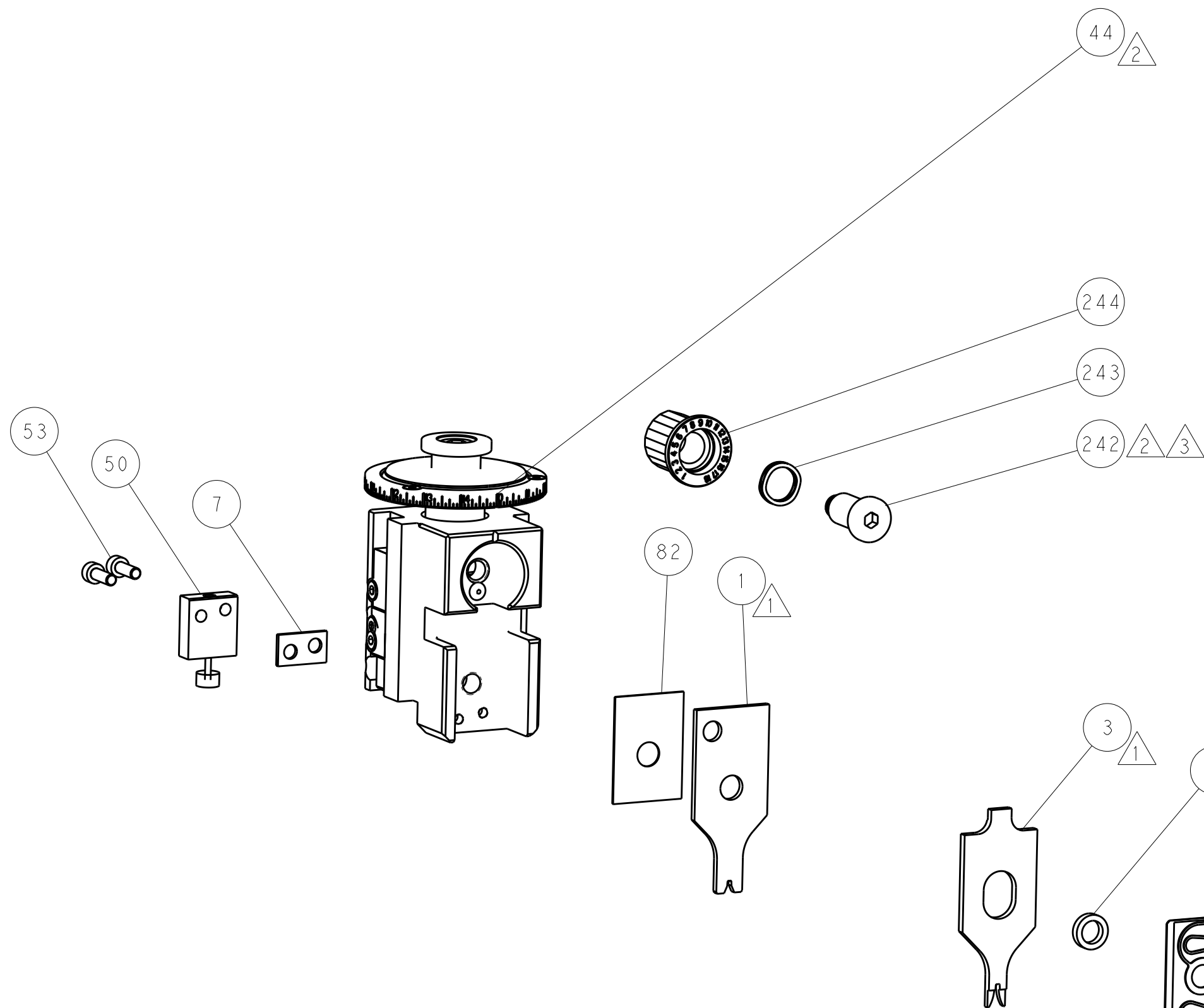
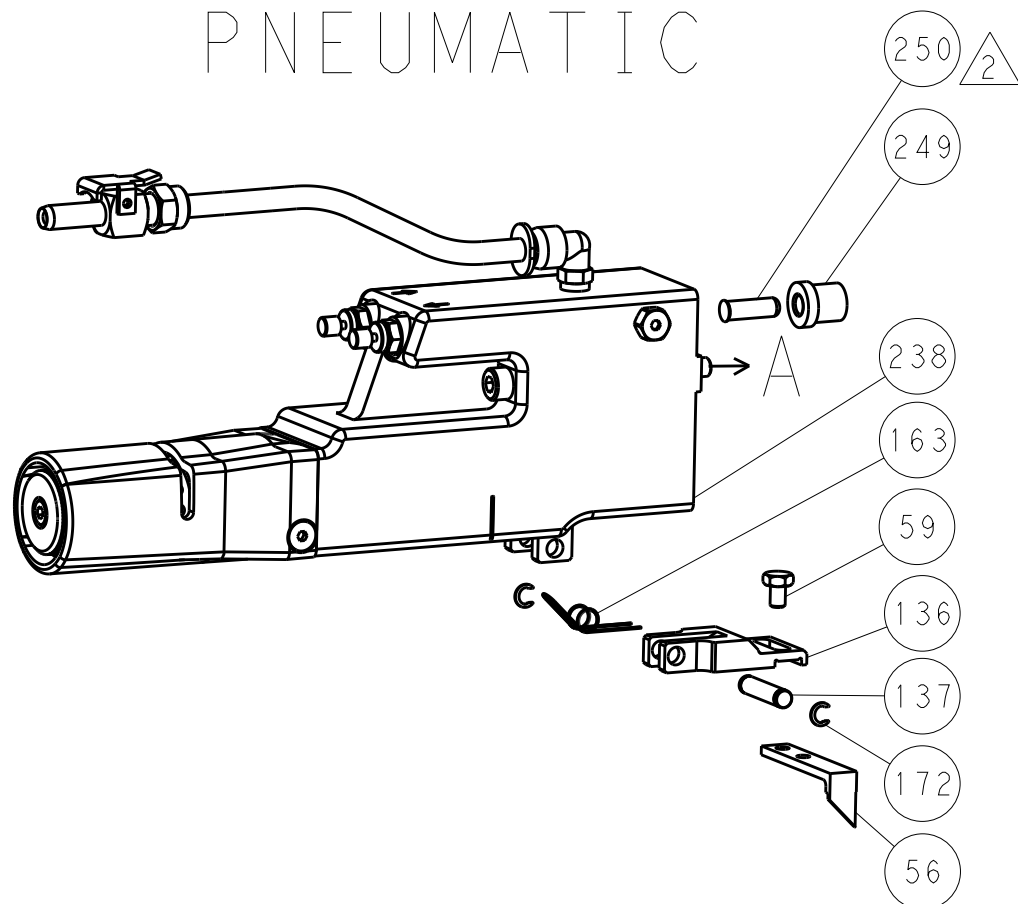
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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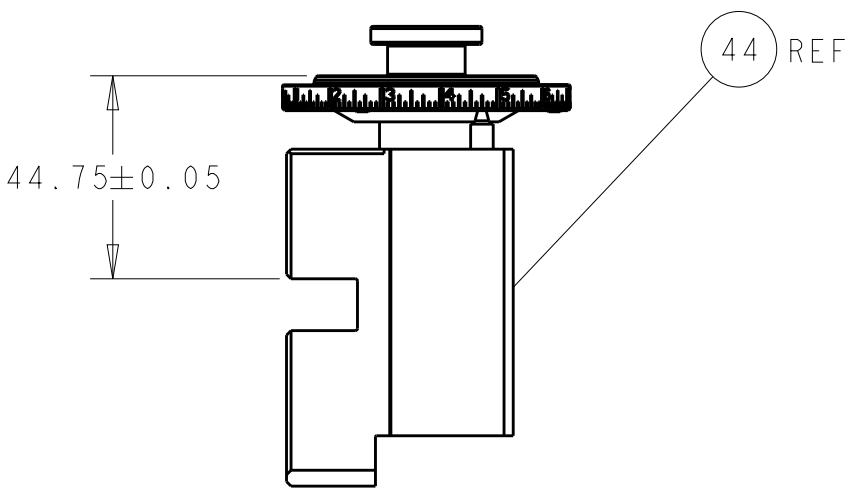
FEED TYPE
MECHANICAL



PNEUMATIC

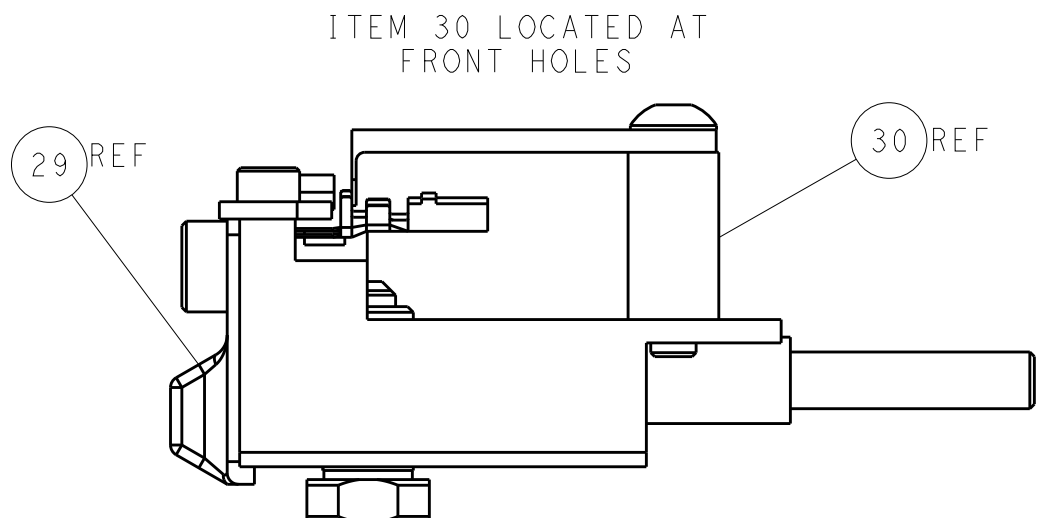
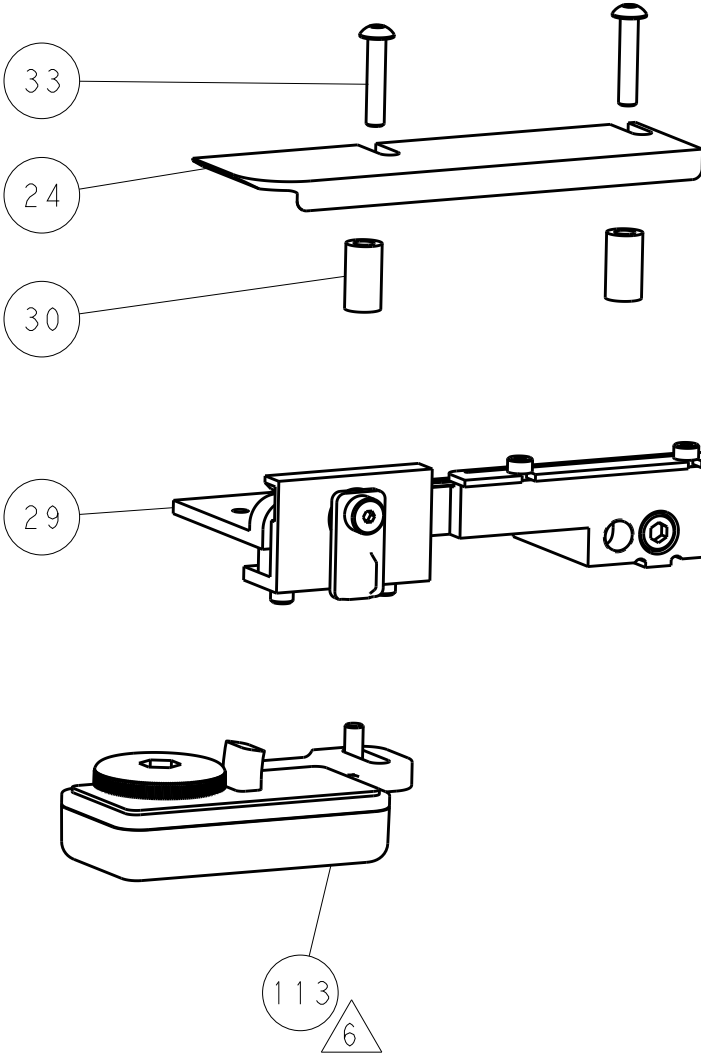
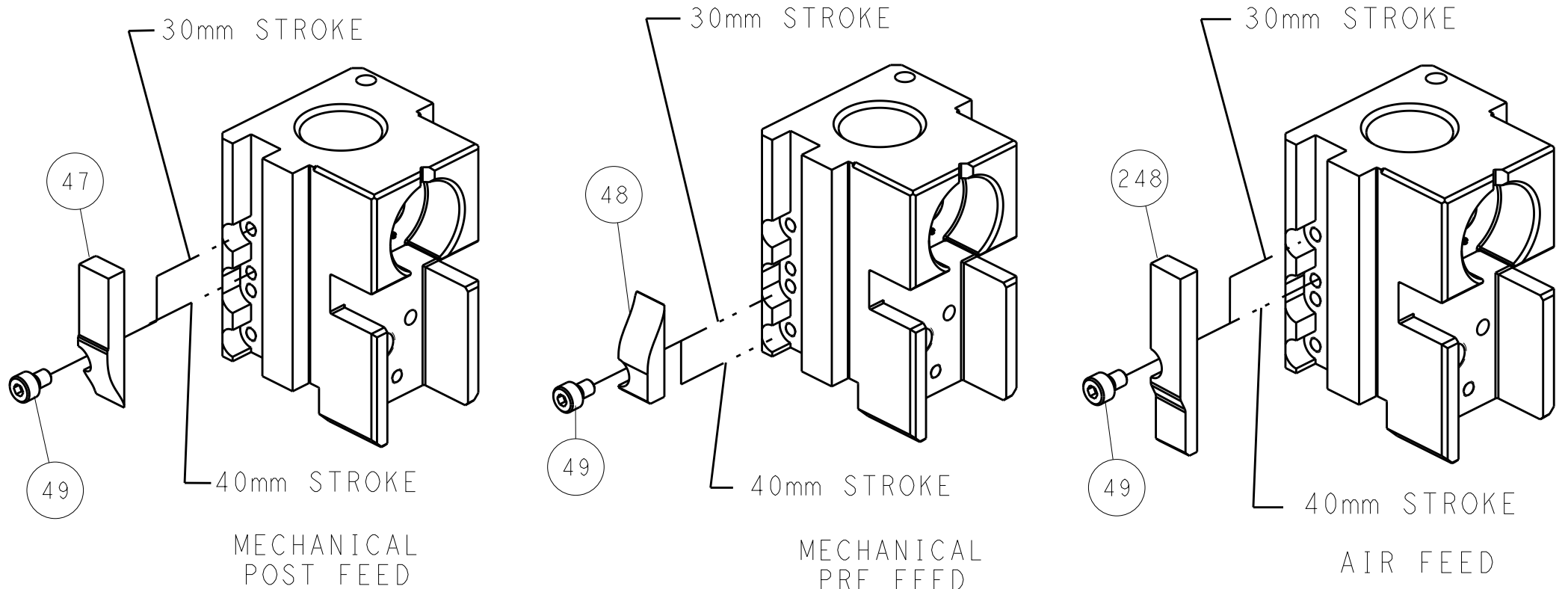


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITIONS



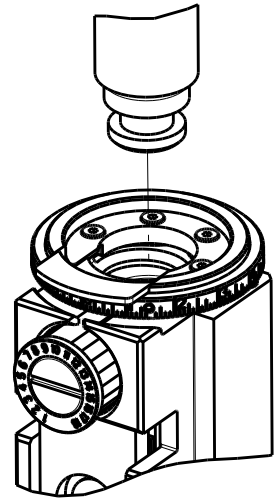
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

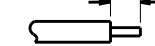

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DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME: Ocean Side Feed Applicator			
mm				0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1				SIZE: A1			
MATERIAL: -				FINISH: -				CAGE CODE: 00779			
								DRAWING NO: C=2266513			
								RESTRICTED TO: -			
								Customer Accessible Production Drawing			
								SCALE: 1:2			
								SHEET: 2 OF 4			
								REV: C			

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266513-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266513-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266513-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.57 mm [.062]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: 2.2 mm PITCH CONNECTOR, J1000 SERIES			
WIRE STRIP LENGTH 3.50-4.00 mm [.138-.157 IN]			INSULATION DIAMETER RANGE Ø1.60-2.10 mm [.063-.083 IN]
TERMINAL APPLICATION SPECIFICATION		JST SF1M-21 Rev -	-
TERMINALS APPLIED 			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2082172-1	SF1F-21T-P0.6	2082172-2	SF1F-21GC-P0.6
2082173-1	SF1M-21T-M0.6A	2082173-2	SF1M-21GC-M0.6A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.80mm2	1.15+/-0.05 [.045+/-0.002]	6.0
20 AWG OR 0.50mm2	1.05+/-0.05 [.041+/-0.002]	7.0
22 AWG OR 0.30mm2	0.95+/-0.05 [.037+/-0.002]	8.0



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.

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

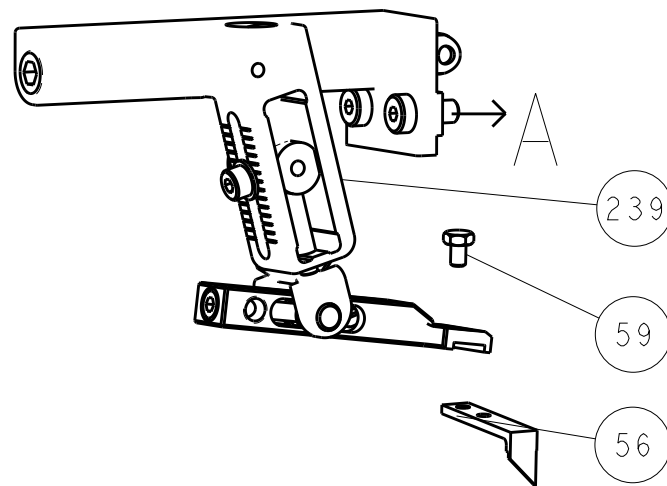
LOC		DIST		REVISONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
-	-	SEE SHEET 1		-	-	-	

	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	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
	-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
6	-	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	455888-5	SPACER, CRIMPER	82
	-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	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	2119533-1	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-3	FLOATING SHEAR, FRONT -	9
1	1	1	1	6-1633918-1	ANVIL, COMBINATION	8
	-	1	1	5-240641-4	SPACER	7
	-	-	-	-	-	6
	-	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1-238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	3-1803246-4	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	2
1	1	1	1	1-1633713-5	CRIMPER, WIRE PREMIUM	1
-77	-22	21		PART NO	DESCRIPTION	ITEM NO

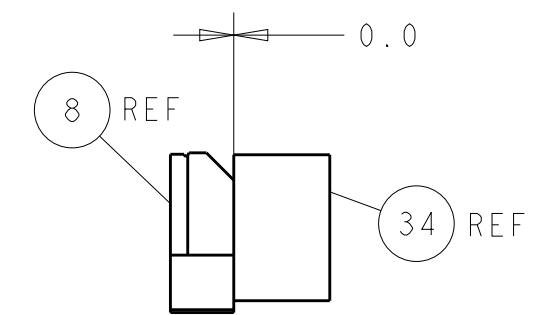
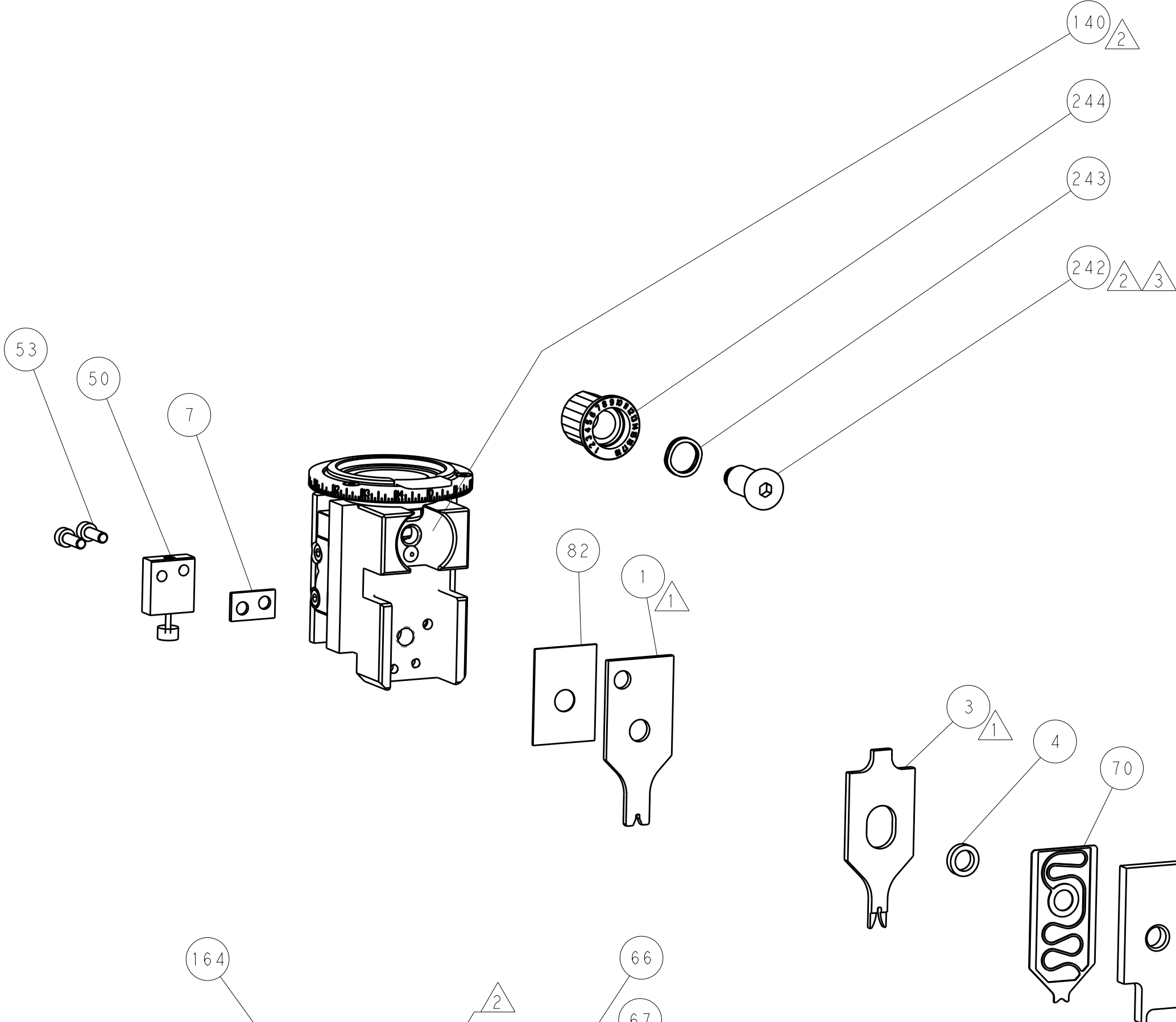
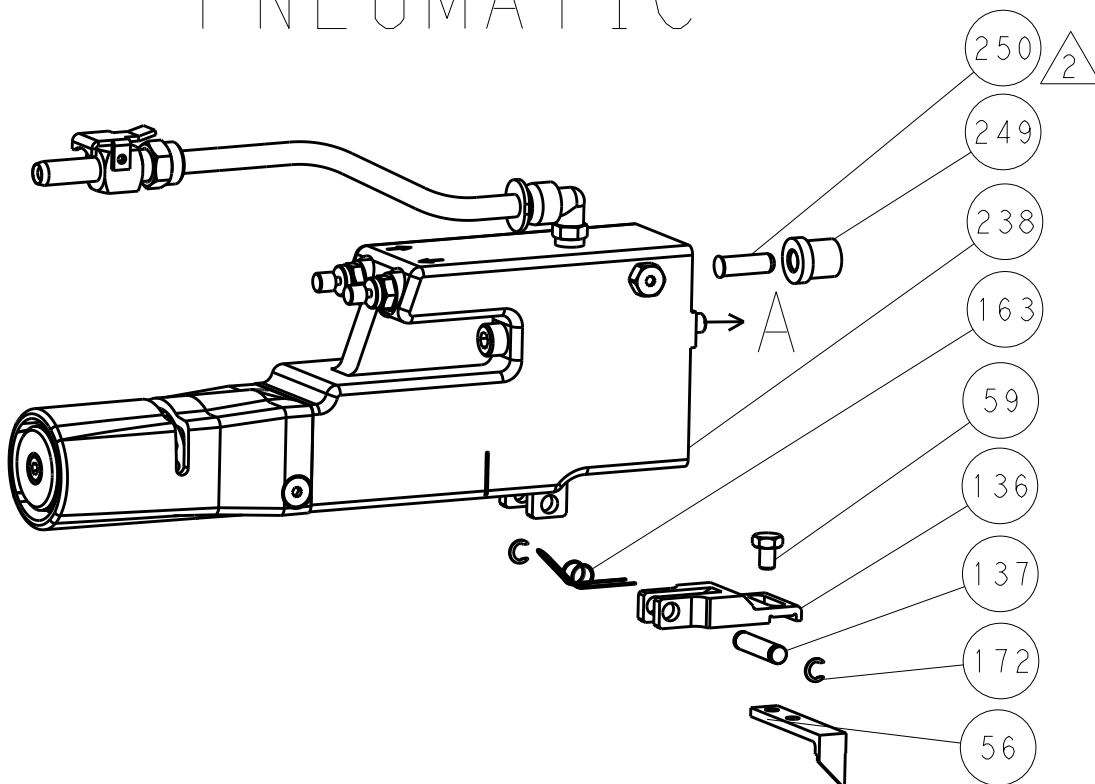
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE MANUFACTURING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN M. ZHAO 24MAR2017	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm				CHK K. ZHANG 24MAR2017	NAME	
				APVD K. ZHANG 24MAR2017	Ocean Side Feed Applicator	
				PRODUCT SPEC	SIZE	
				APPLICATION SPEC	CAGE CODE	
				FINISH	DRAWING NO	
MATERIAL				WEIGHT	RESTRICTED TO	
-				-	A1 00779 ©=2266513	
Customer Accessible Production Drawing				SCALE	REV	
				1:2	C	

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

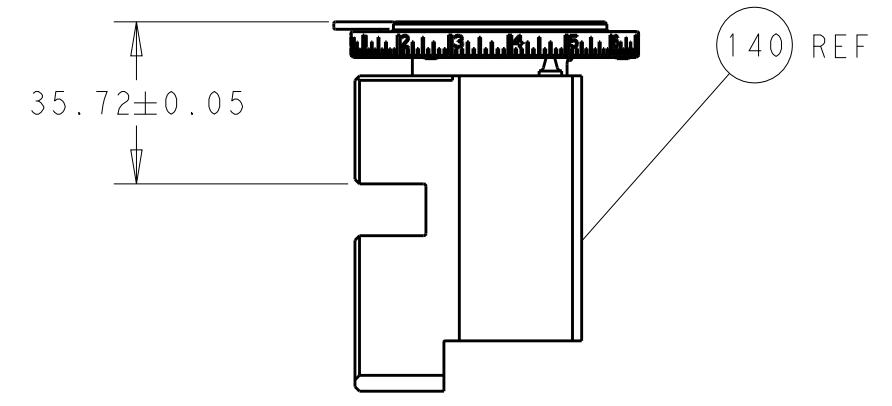
FEED TYPE
MECHANICAL



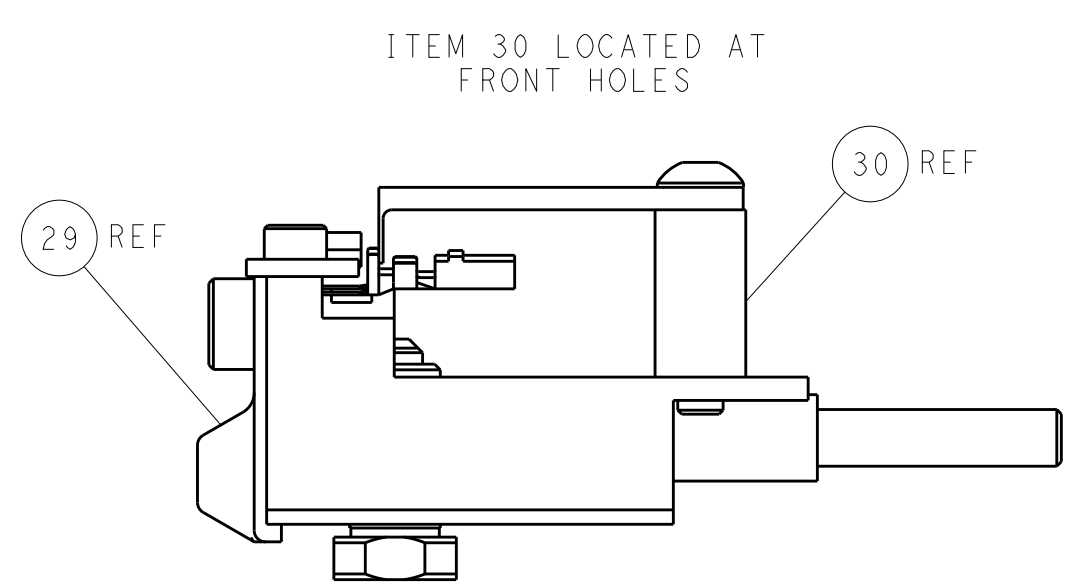
PNEUMATIC



TERMINAL SUPPORT LOCATION

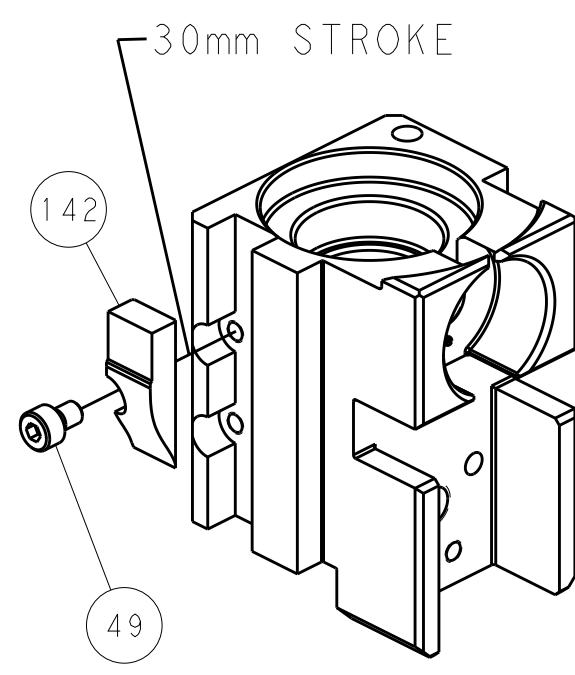


RAM SET-UP

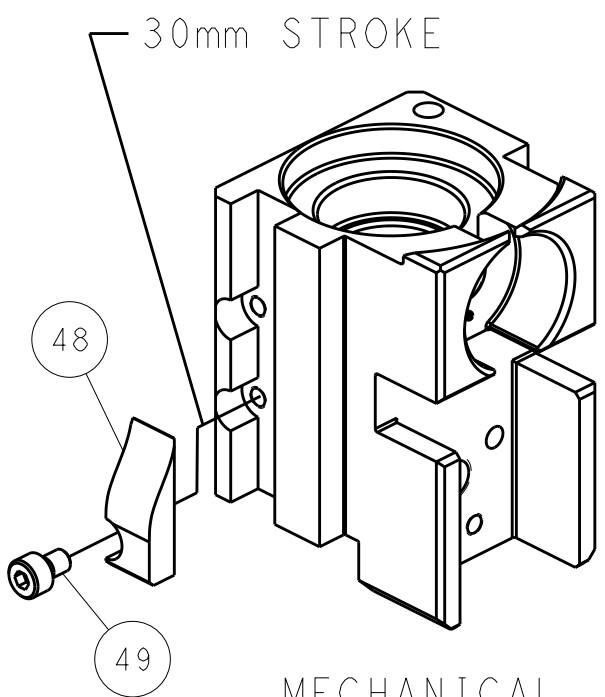


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

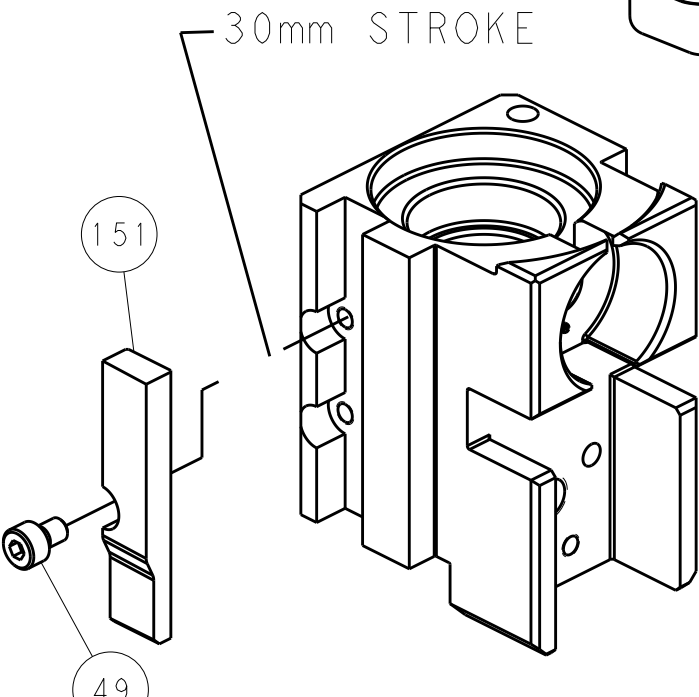
CAM POSITIONS



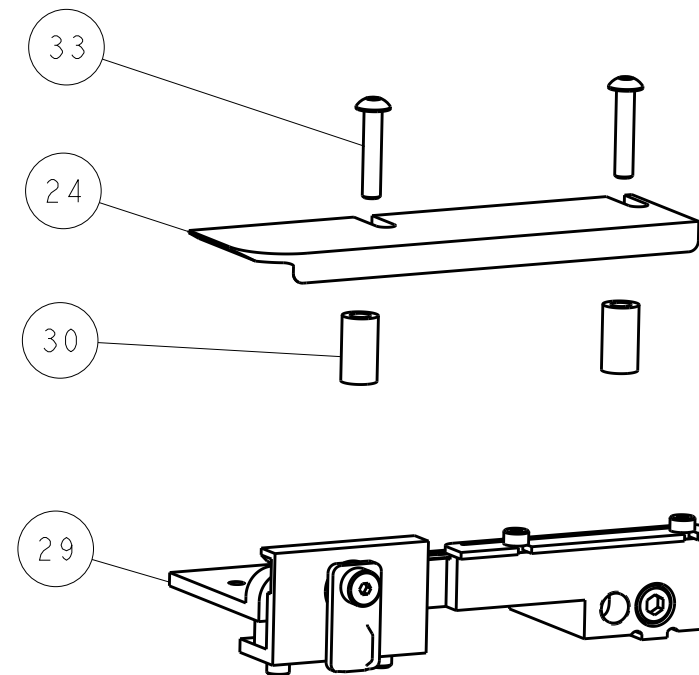
MECHANICAL
POST FEED



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN M. ZHAO 24MAR2017	Z4MAR2017		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm				CHK K. ZHANG 24MAR2017	NAME		Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				APVD K. ZHANG 24MAR2017	PRODUCT SPEC		SIZE A1	
MATERIAL					APPLICATION SPEC		CAGE CODE 00779	
					WEIGHT		DRAWING NO C=2266513	
					Customer Accessible Production Drawing		RESTRICTED TO C	
					SCALE 1:2		SHEET 4	
							OF 4	
							REV C	