

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266685-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266685-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266685-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266685-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266685-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.96 mm [.156]	F
INSUL	3.96 mm [.156]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.68-5.44 mm [.184-.214 IN]		Ø3.05-3.18 mm [.120-.125 IN]	
TERMINAL APPLICATION SPECIFICATION	USCAR-21		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113663-1	381425-JL48	2113663-2	1L5T-14421-CA

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3mm ² or 12 AWG	2.95 +/- 0.05 [.116 +/- .002]	3.8
2.50mm ²	2.80 +/- 0.05 [.110 +/- .002]	5.4
14 AWG	2.75 +/- 0.05 [.108 +/- .002]	6.1
2.00mm ²	2.70 +/- 0.05 [.106 +/- .002]	6.4
1.50mm ²	2.60 +/- 0.05 [.102 +/- .002]	7.7
16 AWG	2.55 +/- 0.05 [.100 +/- .002]	8.3

- 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)

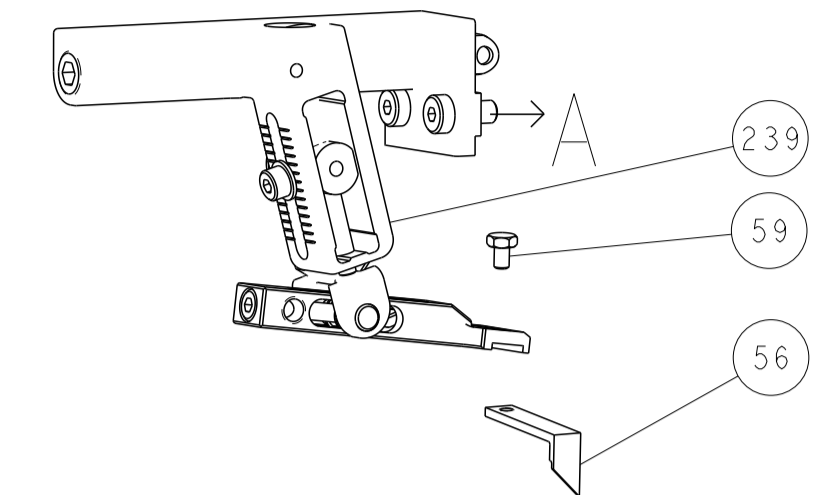
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	20MAR2015	BW	GB
		B		ECR-19-007971	19MAY2019	TB	TE

-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1	1	1633782-4	FENCE	267	
-	1	1	1	1	2119640-1	PUSH ROD, AIR FEED	250	
-	1	1	1	1	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	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	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	240638-1	SPRING, FEED FINGER	163	
-	1	1	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	1	1	2119799-1	HOLDER, FEED FINGER, AF	136	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1	1	1803096-1	EXTENSION PLATE	78	
-	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	1338683-8	FEED PAWL	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	1	690753-2	SPACER, TONKER	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	1752356-2	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-8	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1320928-4	STRIP GUIDE	24	
-	1	1	1	1	2-690438-2	FRONT STRIP GUIDE	23	
-	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	454276-5	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	7-1803054-7	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-8	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	6-1803017-0	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
-	1	2	2	1	1	2-1633738-3	CRIMPER, WIRE	1
-	77	72	71	2	1	PART NO	DESCRIPTION	ITEM NO

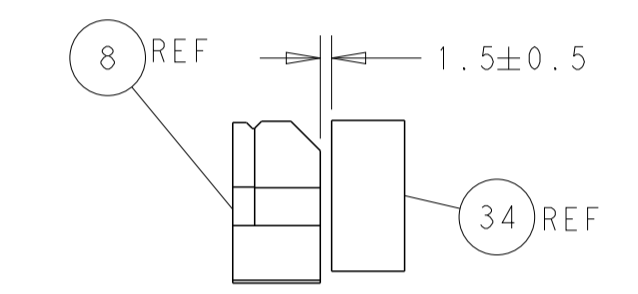
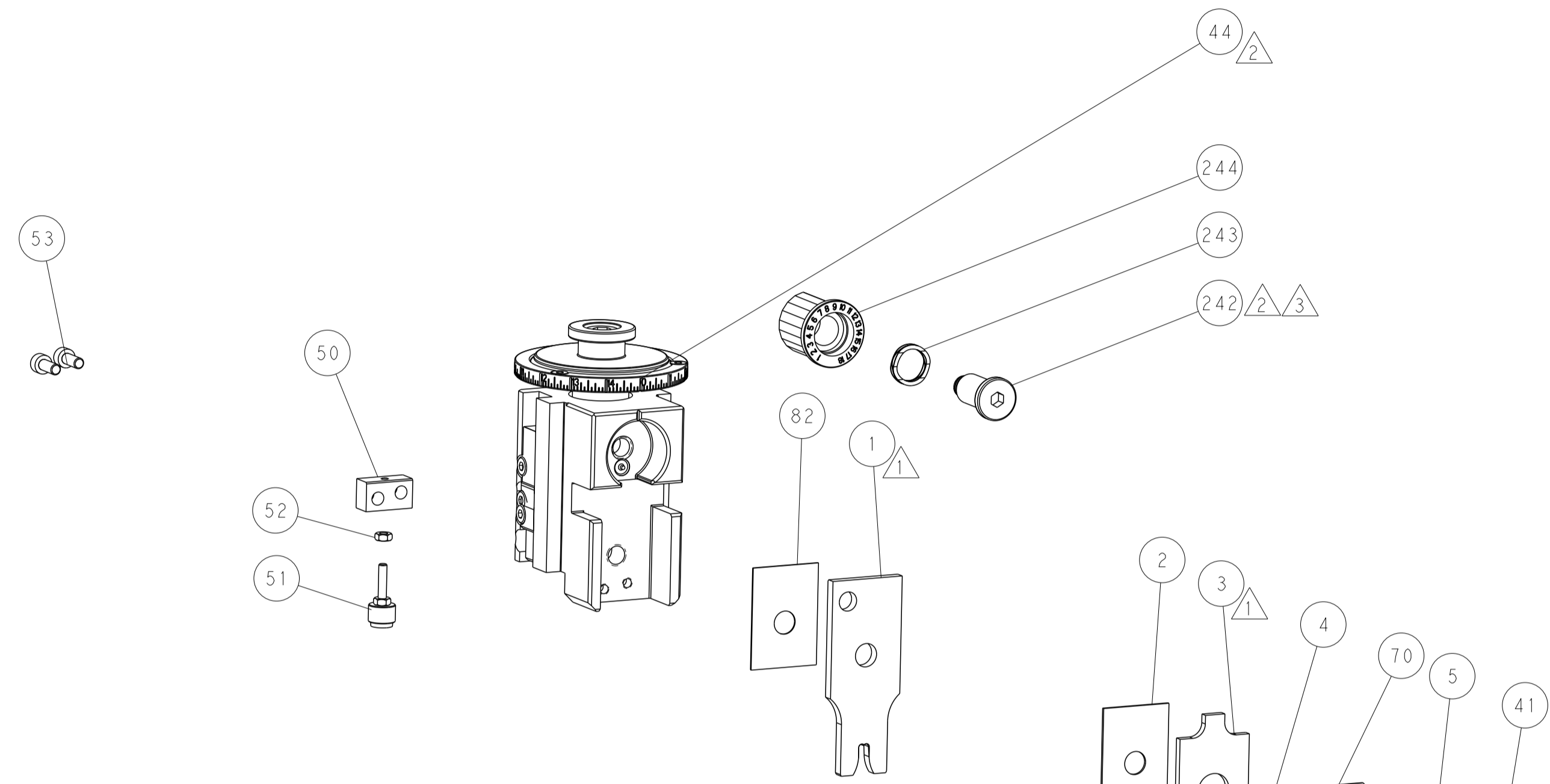
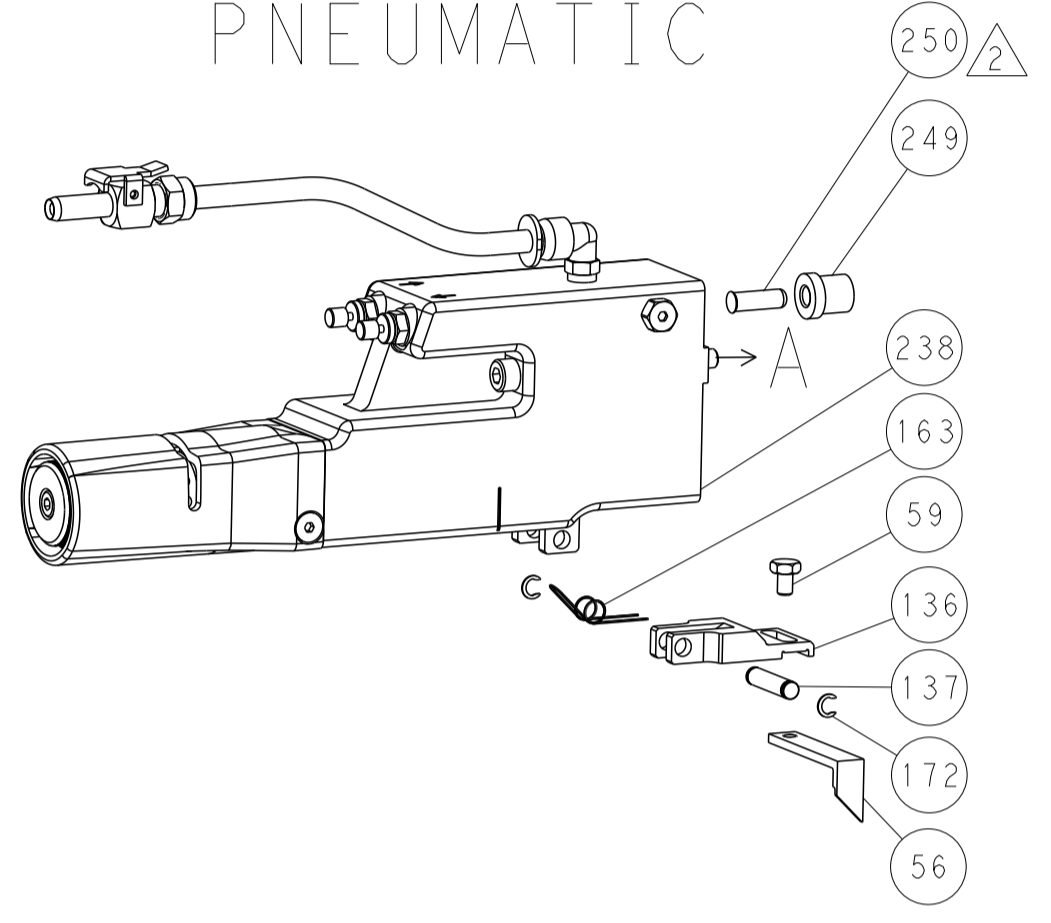
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 27FEB2015		CHK: G. BAILEY 27FEB2015		APVD: G. BAILEY 27FEB2015		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2266685	RESTRICTED TO: -
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET: 1 of 4		REV: B	

LOC	DIST	REV	DATE	BY	APPV
A	66				

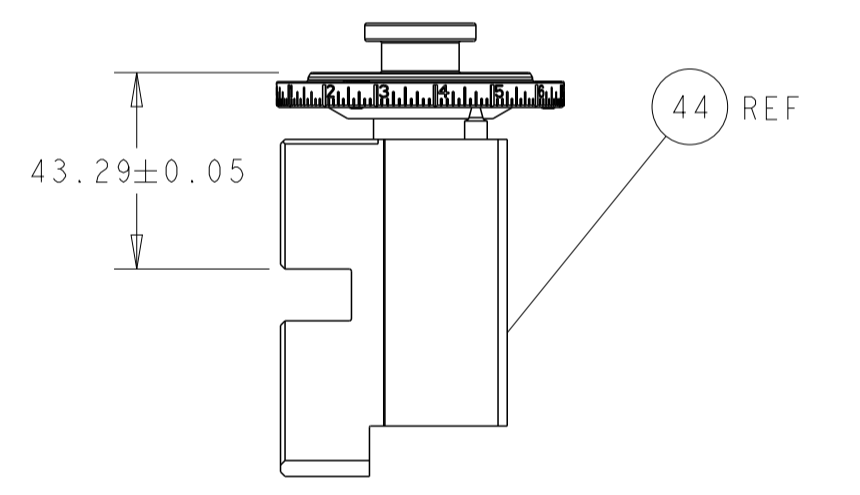
FEED TYPE MECHANICAL



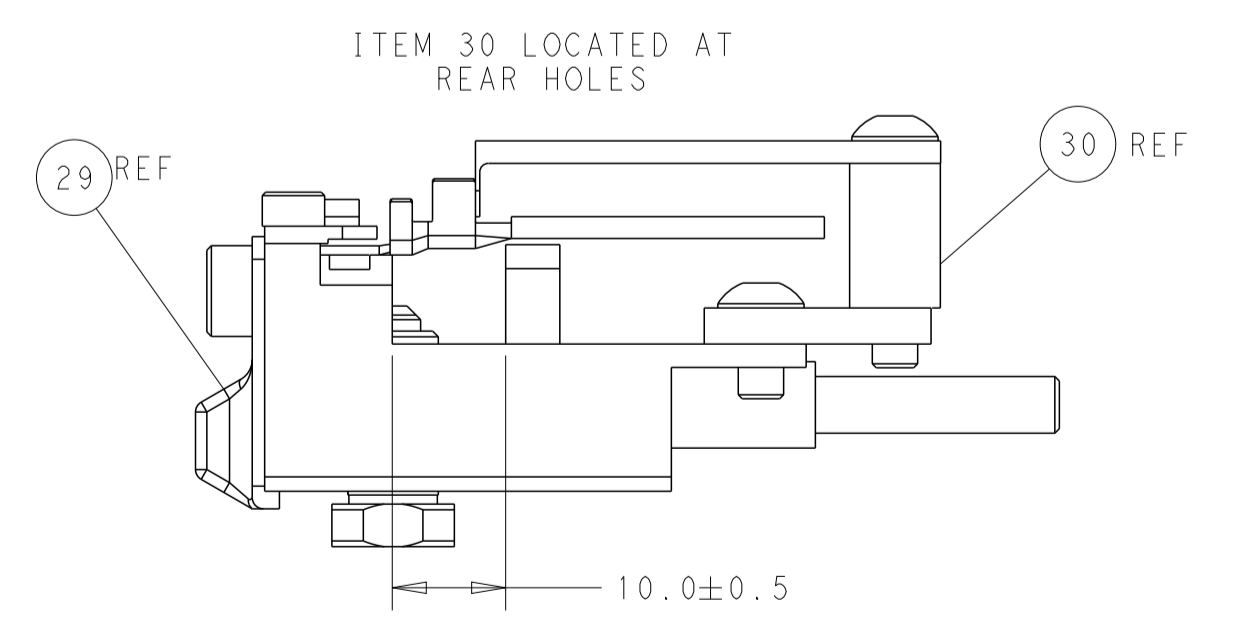
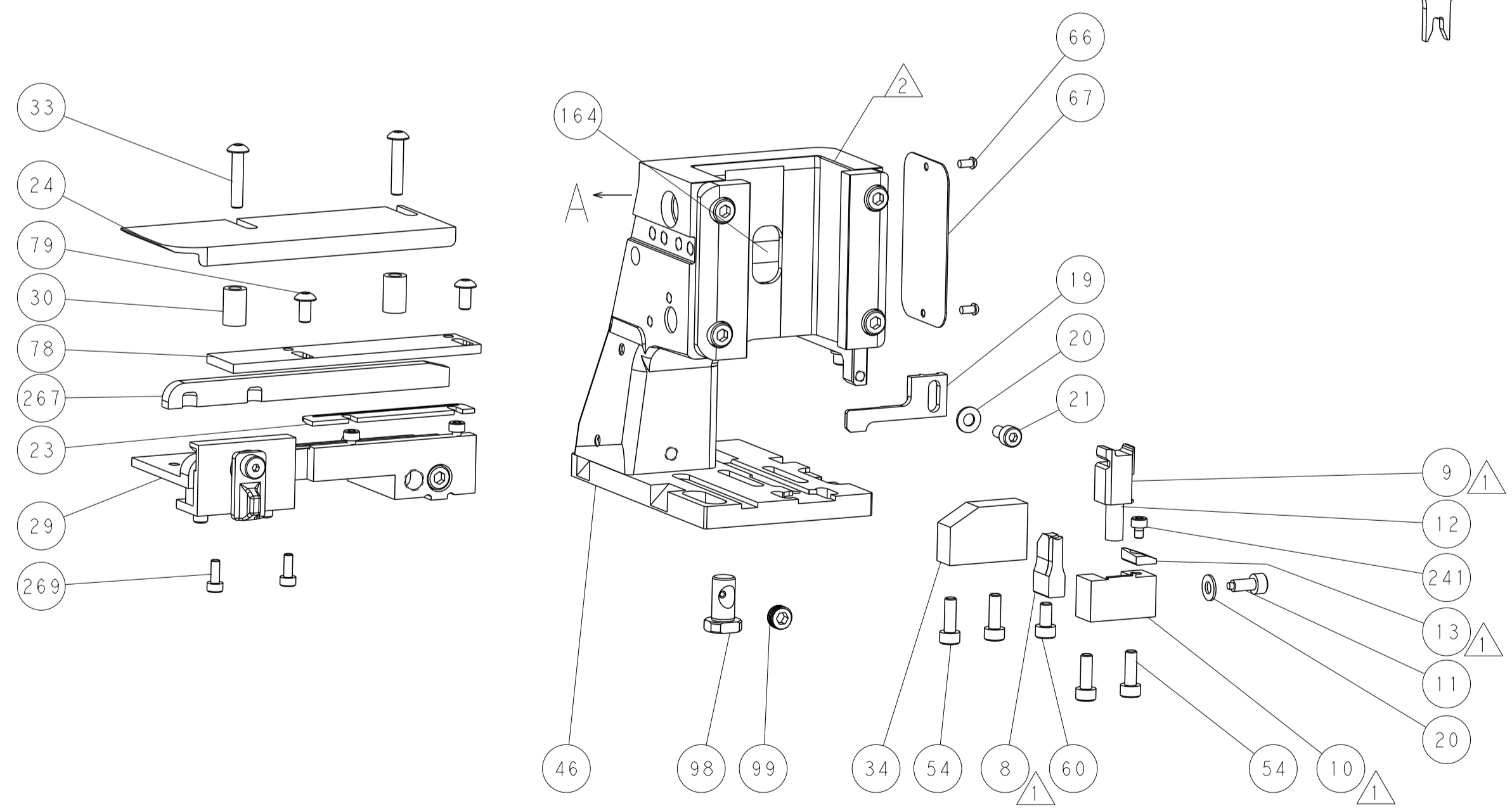
PNEUMATIC



TERMINAL SUPPORT LOCATION

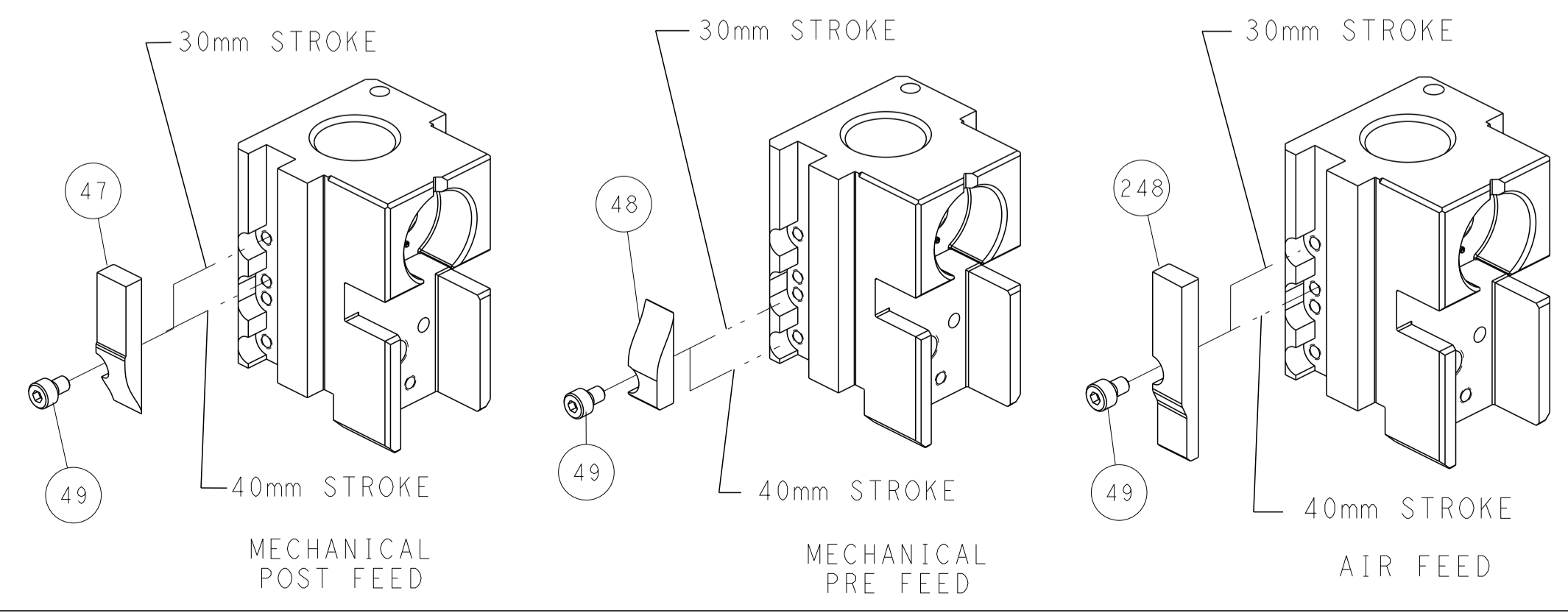


RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC	±		B	WEAVER	27FEB2015	
	1 PLC	±		CHK	G. BAILEY	27FEB2015	
	2 PLC	±		APPV	G. BAILEY	27FEB2015	
	3 PLC	±		NAME			
	4 PLC	±		Ocean Side Feed			
	ANGLES	±		Applicator			
MATERIAL	FINISH	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	2266685	
Customer Accessible Production Drawing				SCALE	1:2	SHEET	2 of 4
				REV	B		

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	2015	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266685-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266685-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266685-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.96 mm [.156]	F
INSUL	3.96 mm [.156]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.68-5.44 mm [1.84-.214 IN]		INSULATION DIAMETER RANGE Ø3.05-3.18 mm [1.20-.125 IN]	
TERMINAL APPLICATION SPECIFICATION	USCAR-21	-	-
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113663-1	381425-JL48	2113663-2	1L5T-14421-CA

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3mm ² or 12 AWG	2.95+/-0.05 [1.16+/-0.02]	3.8
2.50mm ²	2.80+/-0.05 [1.10+/-0.02]	5.4
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1.50mm ²	2.60+/-0.05 [1.02+/-0.02]	7.7
16 AWG	2.55+/-0.05 [1.00+/-0.02]	8.3

- 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.

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

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

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1633782-4	FENCE	267
-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
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-	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	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	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	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	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	1338683-8	FEED PAWL	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
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-	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	1	7-1803054-7	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	1-238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	6-1803017-0	CRIMPER, INSULATION F	3
-	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	2-1633738-3	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 27FEB2015		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME: Ocean Side Feed Applicator	
MATERIAL:		FINISH:		APVD: G. BAILEY 27FEB2015		SIZE: A1	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET: 3 OF 4		REV: B	

