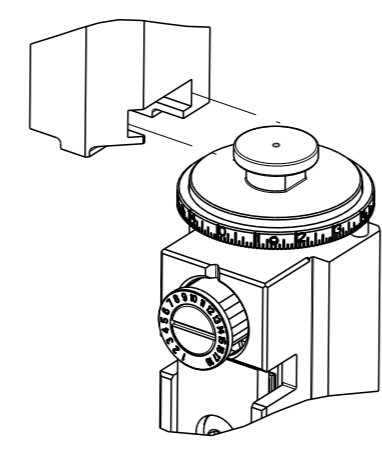


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266991-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266991-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266991-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266991-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266991-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266991-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266991-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.39 mm [.094]	F
INSUL	4.00 mm [.157]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION

TERMINAL NAME: TER-RSF-L

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
3.50-4.50 mm [.138-.177 IN]	Ø 2.50-2.90mm

TERMINAL APPLICATION SPECIFICATION SUMITOMO Rev 9/10/15

TERMINALS APPLIED

TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
2113855-1	8240-0265	1949796-1	7165-0471	Ø 2.50-2.90mm
2113855-2	8240-0268	1949797-1	7165-0472	Ø 2.00-2.40mm
2113855-3	8240-0271			
3311476-1	8100-4172			
3311476-2	8100-4173			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2mm ²	1.50 +/- 0.05 [.059 +/- .002]	6.4
1.5mm ²	1.40 +/- 0.05 [.055 +/- .002]	7.3

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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. APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6. 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.

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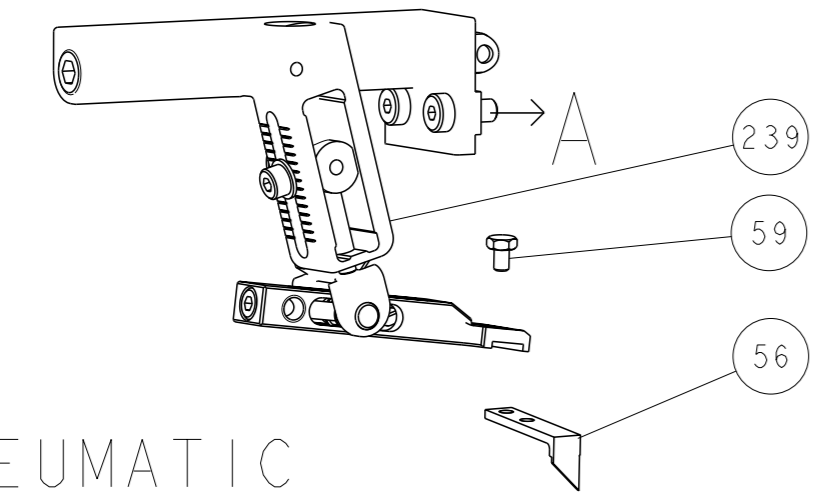
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-	-	1803515-3				293
-	-	2-1803583-1				292
-	1	2119641-1				248
-	1	2119082-2				244
-	1	2079764-1				243
-	1	2119083-1				242
-	1	7-18023-7				241
-	1	2119580-1				239
-	1	2844940-1				238
-	-	4-1722335-3				182
-	-	1-5018030-0				181
-	-	1-1752354-9				180
-	-	993111-1				177
-	-	5-22280-0				176
-	-	1752353-3				175
-	-	1901680-2				174
-	REF	994970-2				164
-	1	2844908-1				99
-	1	2844907-1				98
-	1	455888-5				82
-	1	1803607-3				71
-	1	2119740-1				67
-	2	2168078-1				66
-	1	2168083-2				60
-	1	5-18022-5				59
-	1	985575-3				57
-	1	1338685-1				56
-	4	2168083-3				54
-	2	2168083-8				53
-	1	5018030-1				52
-	1	811242-5				51
-	1	690753-2				50
-	1	18023-9				49
-	-	2119652-1				48
-	-	2119653-1				47
-	1	1803583-9				46
-	1	1803515-1				44
-	1	1803602-1				41
-	1	1752356-1				34
-	2	2079383-5				33
-	2	2-2844962-8				30
-	1	2844992-1				29
-	1	455888-3				28
-	1	1320928-2				24
-	1	2168083-2				21
-	2	1-18028-2				20
-	1	2119533-1				19
-	1	2119806-1				13
-	1	3-22280-3				12
-	1	1-356885-4				11
-	1	2119805-1				10
-	1	318707-1				9
-	1	9-1803054-6				8
-	1	1-240641-0				7
-	-	-				6
-	1	2-2119781-4				5
-	1	238011-4				4
-	1	6-1633965-9				3
-	1	1-455888-5				2
-	1	6-1633860-8				1

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

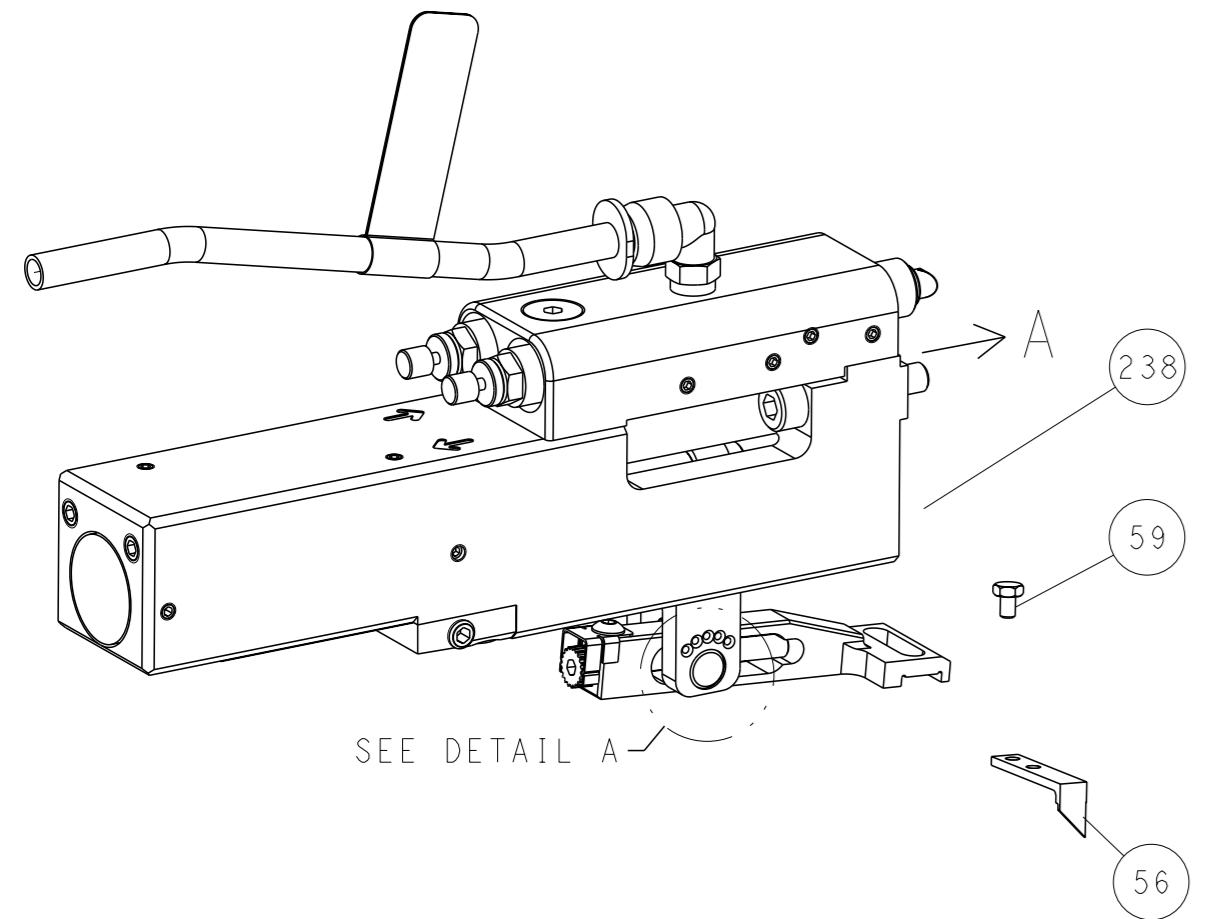
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	CHK	APPV	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	H. HUANG	L. ZHANG	U. GUO	Ocean Side Feed Applicator	A1	00779	2266991	Customer Accessible Production Drawing

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL



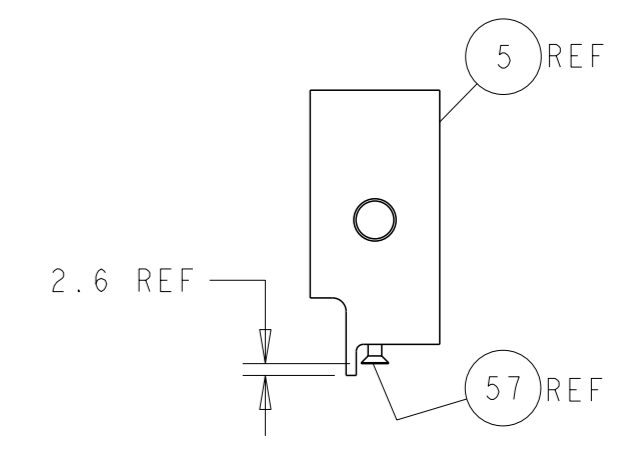
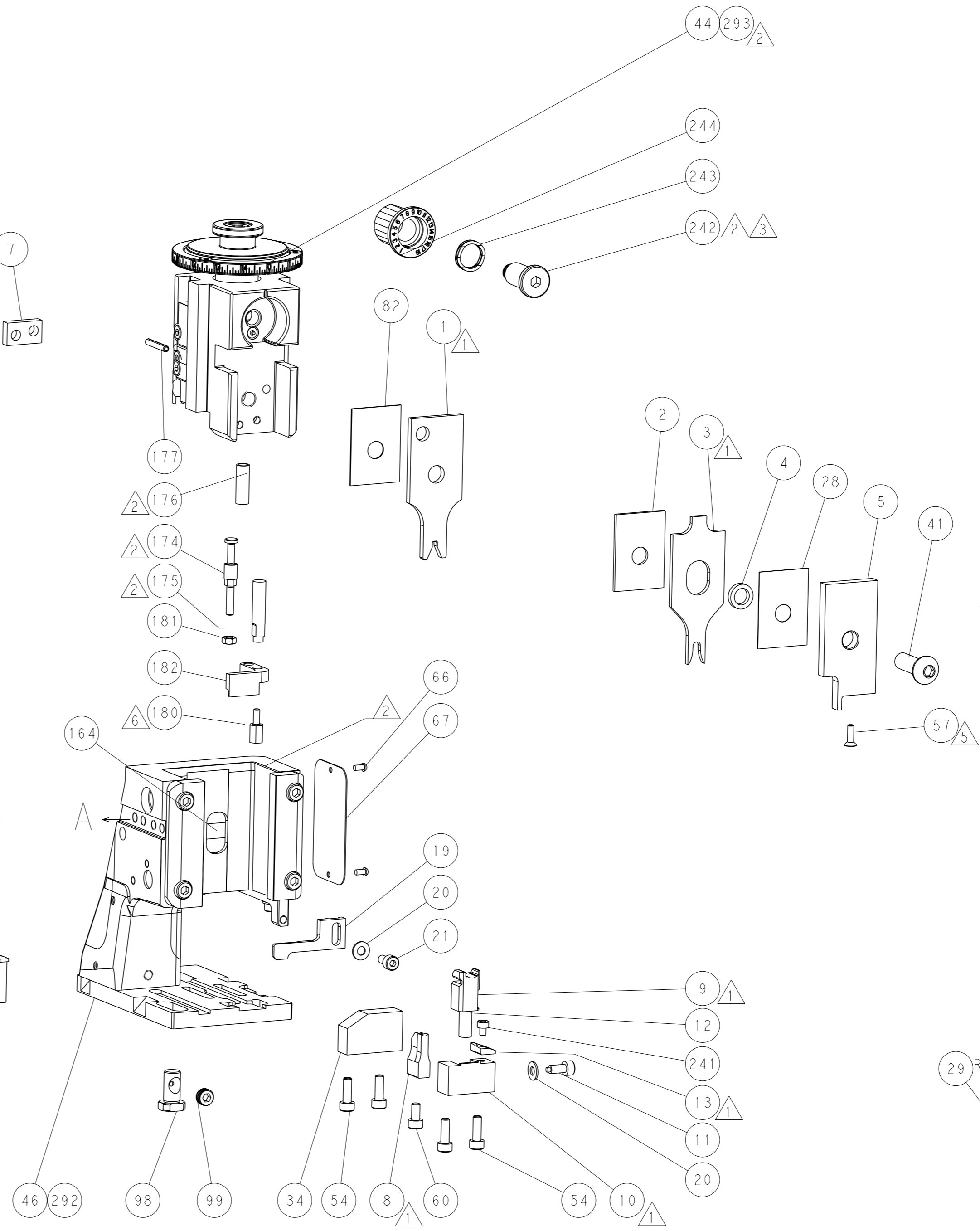
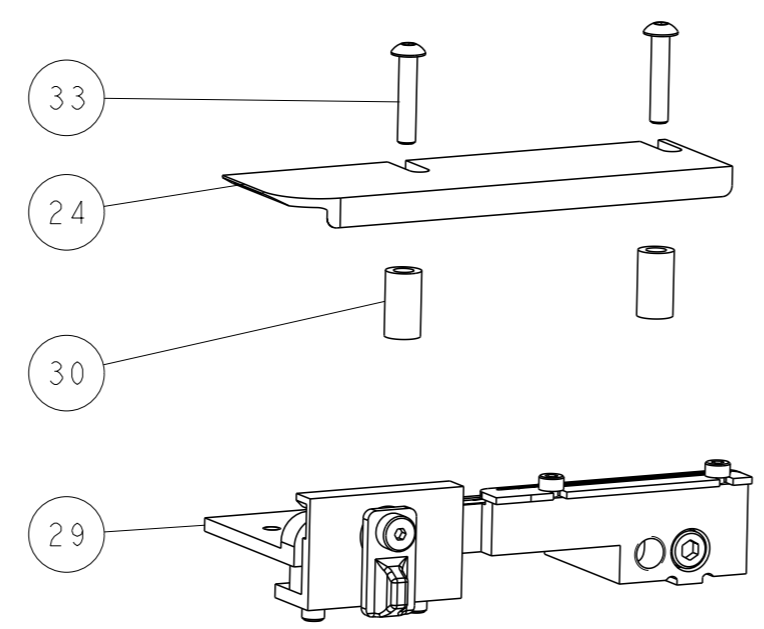
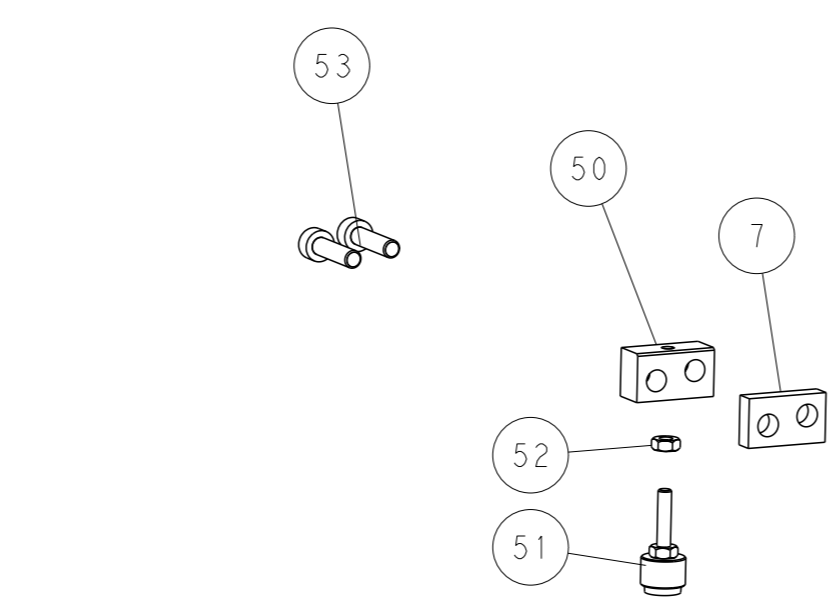
PNEUMATIC



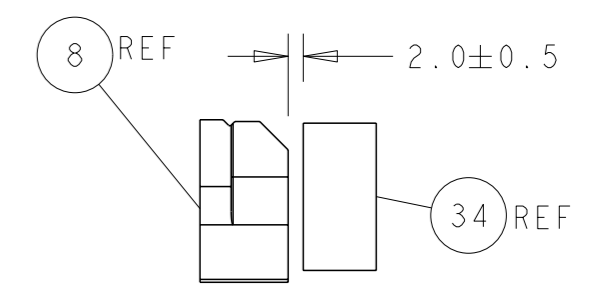
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



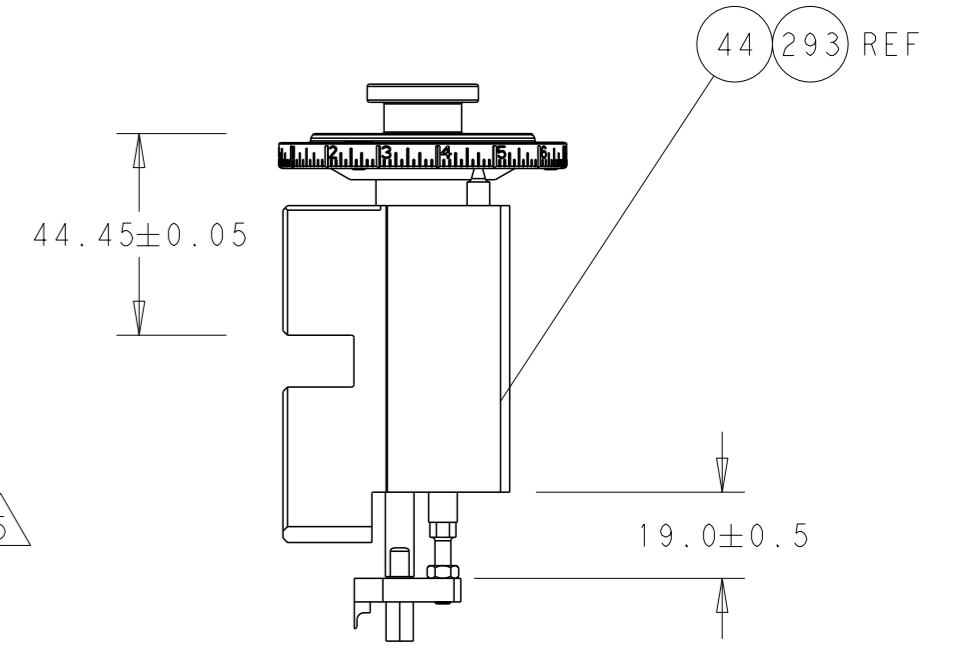
DETAIL A



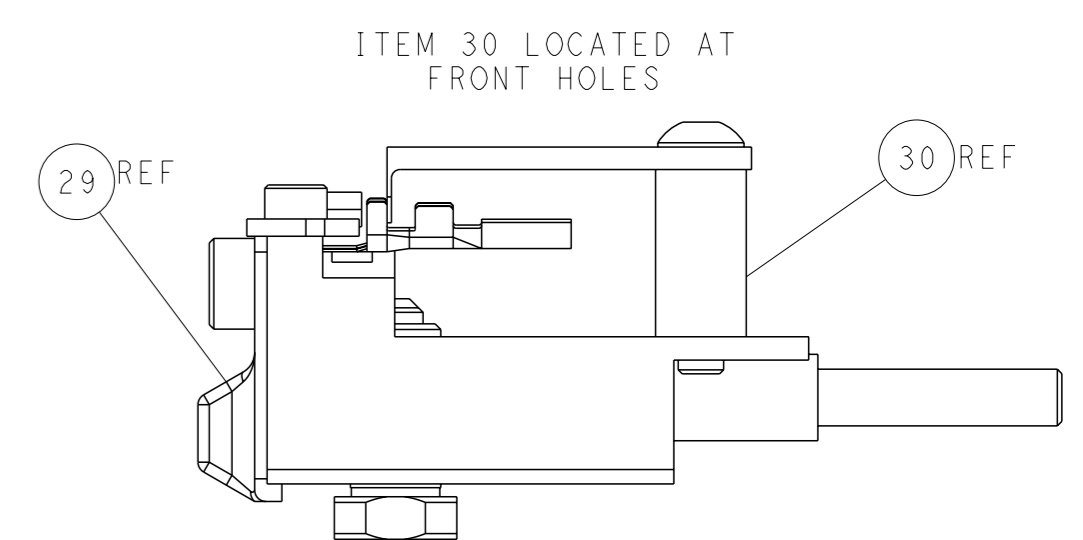
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

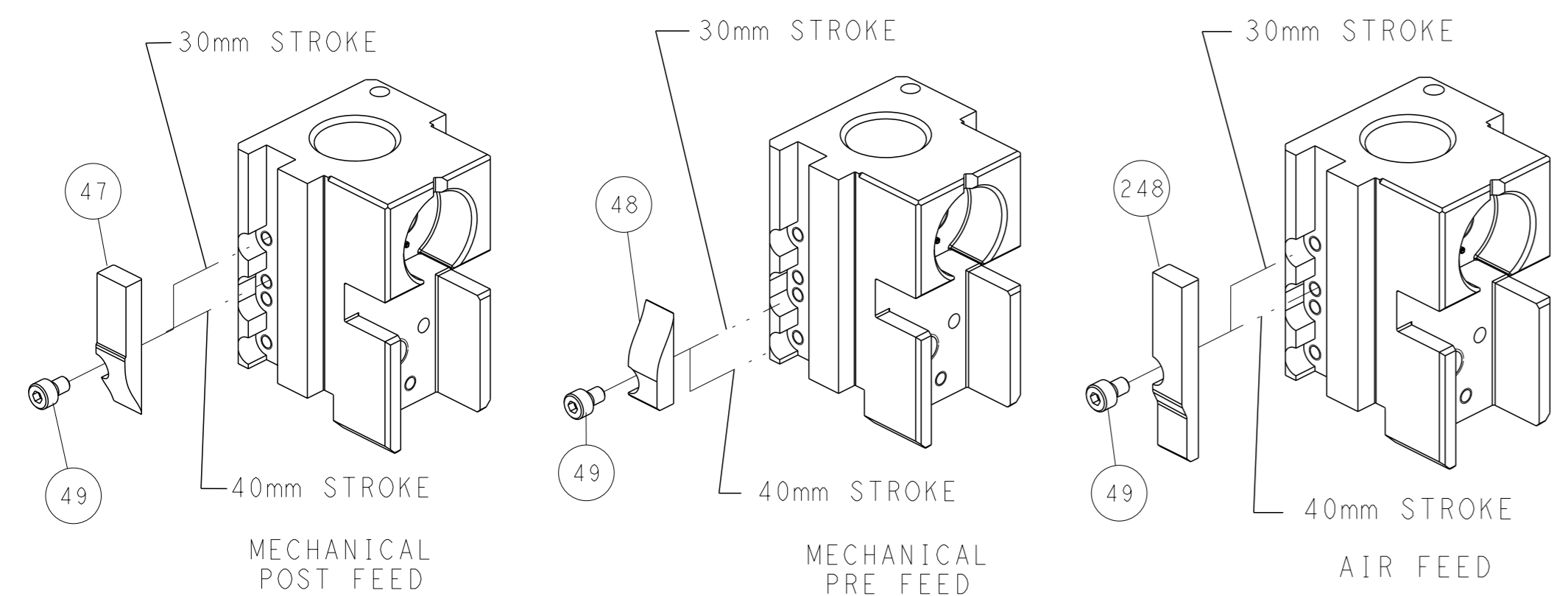


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

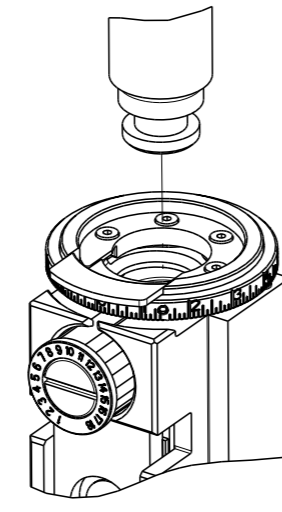


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		OWN: H. HUANG CHK: L. ZHANG APVD: J. GUO PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: C	DATE: 23SEP2015 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266991 RESTRICTED TO: -	TE Connectivity Harrisburg, PA 17105-3608
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THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266991-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266991-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266991-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

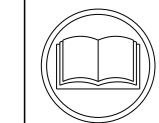


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.39 mm (.094)	F
INSUL	4.00 mm (.157)	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: TER-RSF-L			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.50-4.50 mm (.138-.177 IN)		Ø	
TERMINAL APPLICATION SPECIFICATION		SUMITOMO Rev 9/10/15	
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL
2113855-1	8240-0265	1949796-1	7165-0471
2113855-2	8240-0268	1949797-1	7165-0472
2113855-3	8240-0271		
3311476-1	8100-4172		
3311476-2	8100-4173		

SEAL INSULATION DIAMETER RANGE
Ø2.50-2.90mm
Ø2.00-2.40mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2mm ²	1.50 +/- 0.05 [.059 +/- .002]	6.4
1.5mm ²	1.40 +/- 0.05 [.055 +/- .002]	7.3



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. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
6. 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	REV	DATE	BY	APPV
A	66				

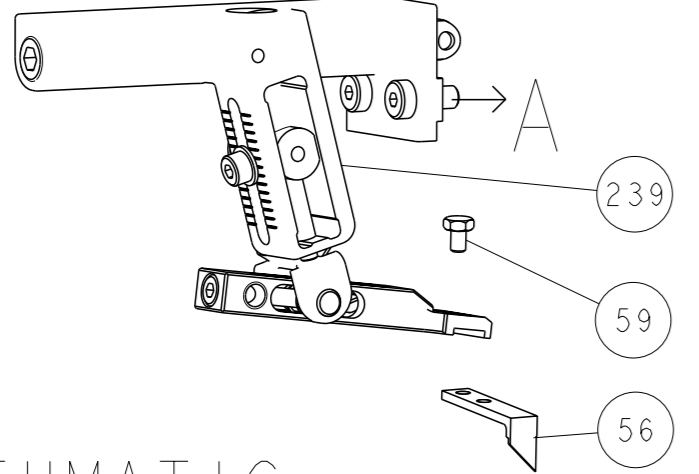
REVISIONS					
REV	DATE	BY	DESCRIPTION	DATE	APPV
-	-	-	SEE SHEET 1	-	-
-	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	2119580-1	MECHANICAL FEED 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	455888-5	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
6	-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-1	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	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	2119533-1	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	9-1803054-6	ANVIL, COMBINATION	8
-	1	1	1-240641-0	SPACER	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	6-1633965-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-5	SPACER, CRIMPER	2
1	1	1	6-1633860-8	CRIMPER, WIRE	1

<small>THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE CUSTOMER'S RESPONSIBILITY TO VERIFY THE DIMENSIONS AND TOLERANCES OF THE PARTS TO BE ORDERED. DIMENSIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: H. HUANG 23SEP2015 CHK: L. ZHANG 23SEP2015 APVD: J. GUO 23SEP2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266991 SHEET 3 OF 4 REV C

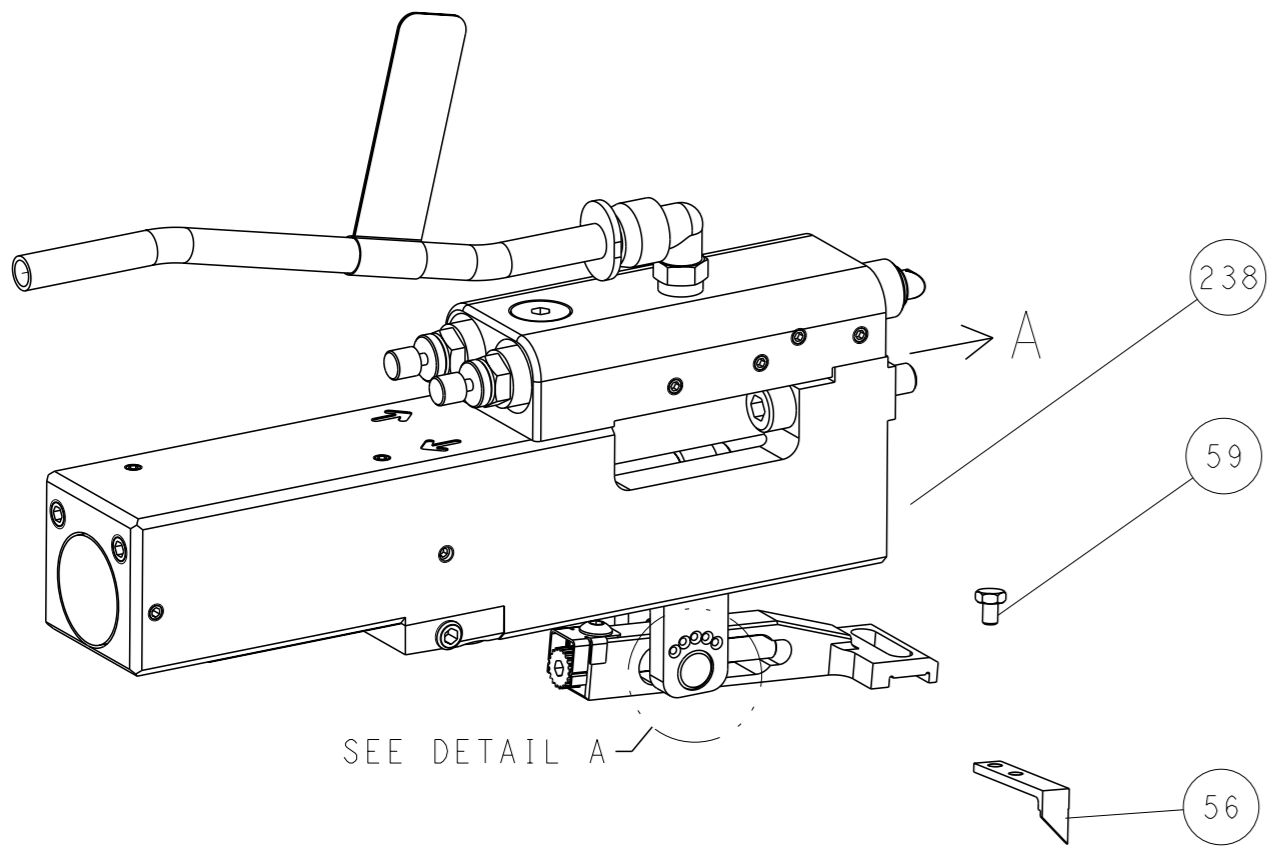
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

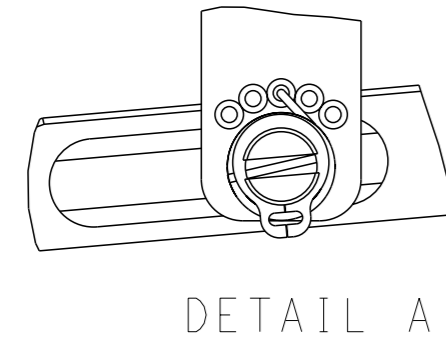
FEED TYPE MECHANICAL



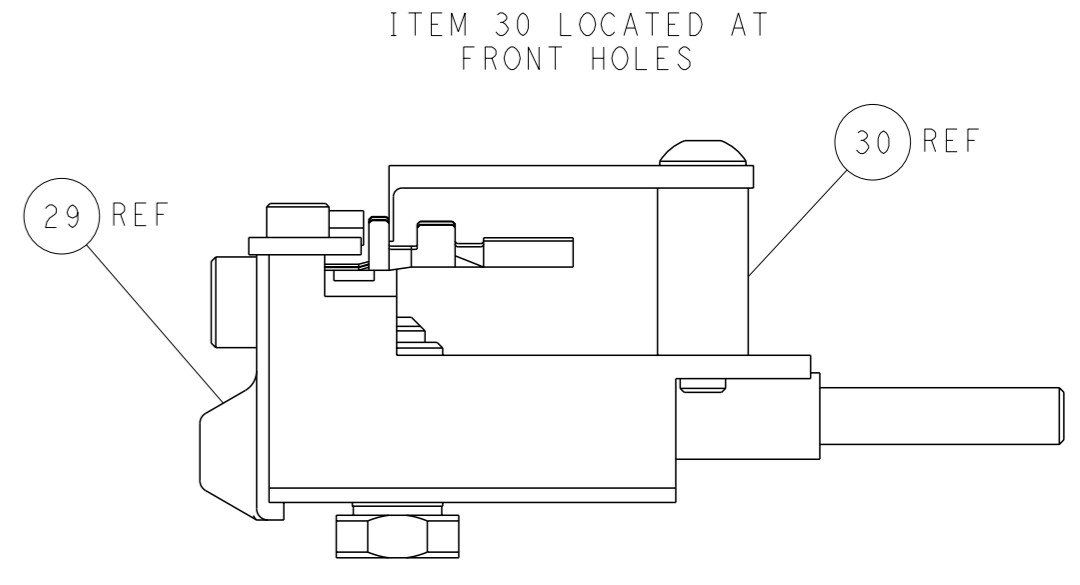
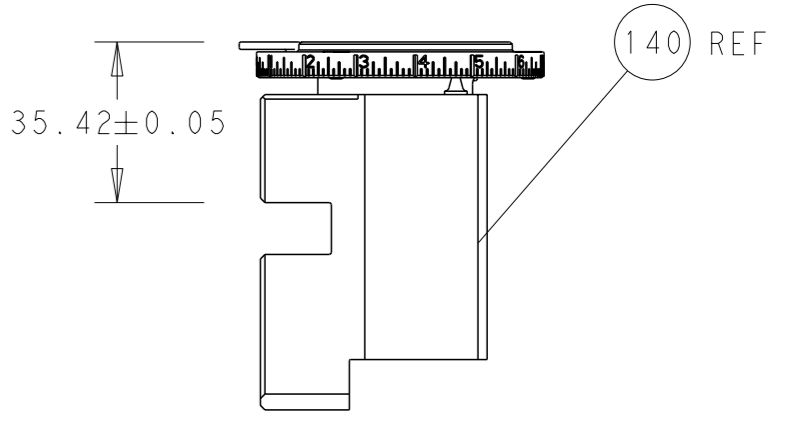
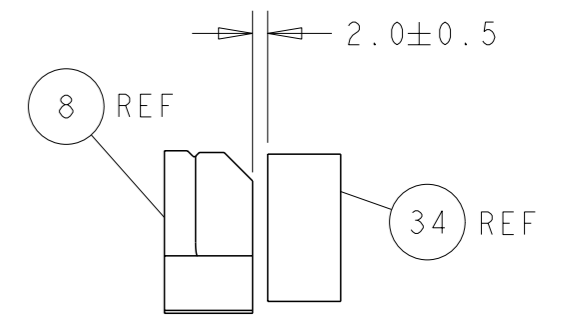
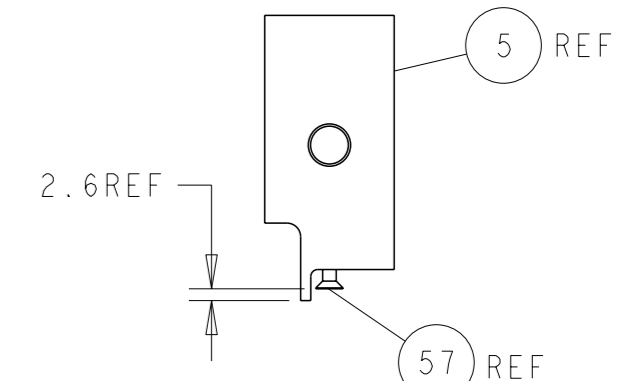
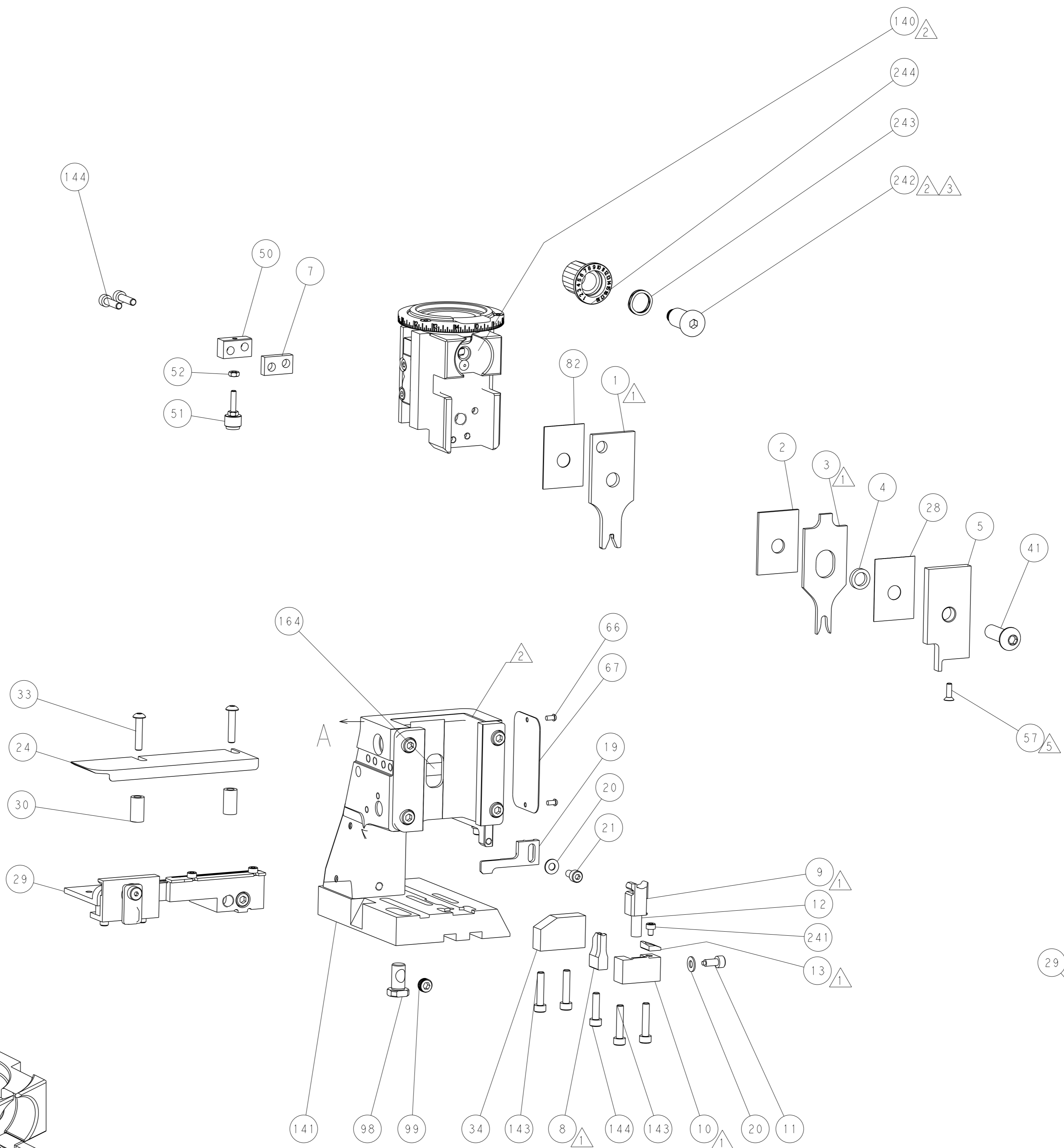
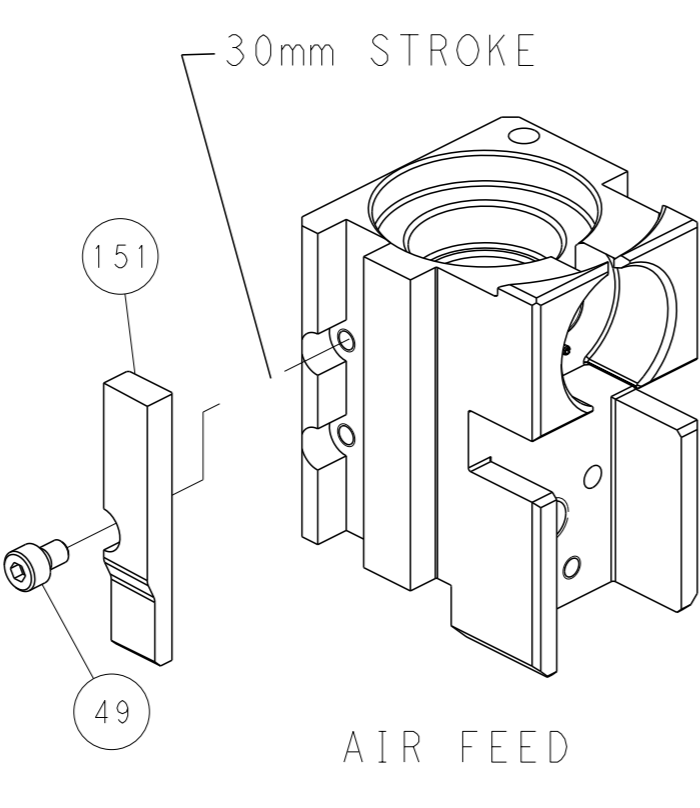
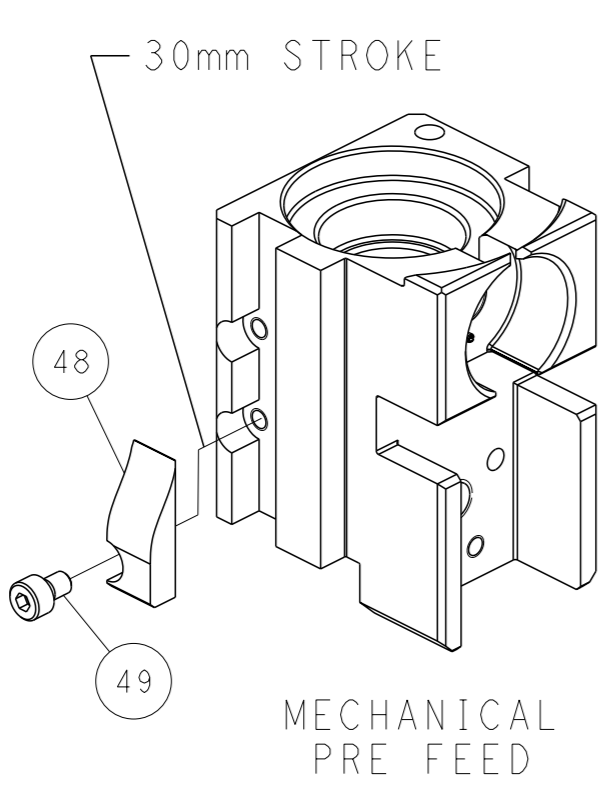
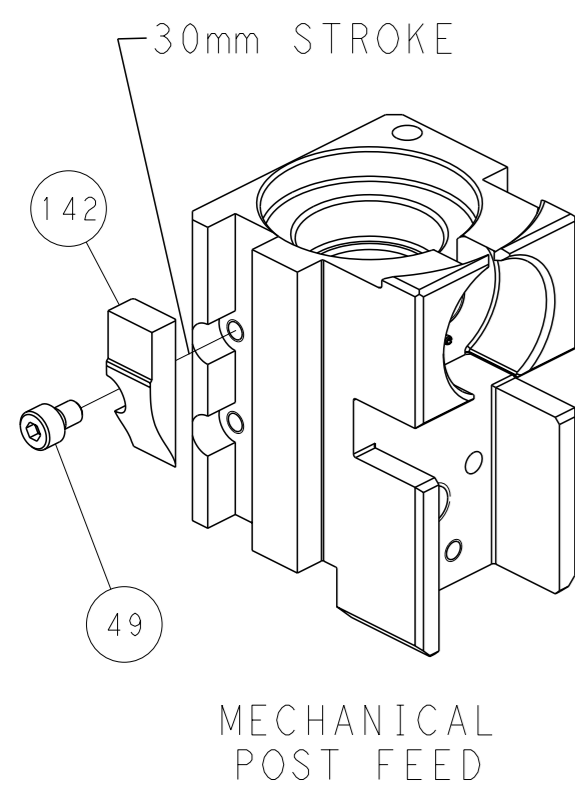
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: H. HUANG CHK: L. ZHANG APVD: J. GUO PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2	DATE: 23SEP2015 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266991 SHEET: 4 of 4 REV: C	TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO Customer Accessible Production Drawing
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