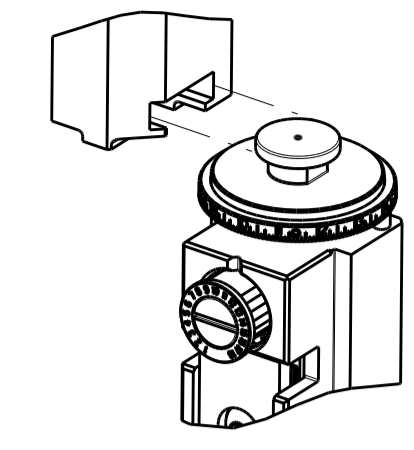


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266698-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266698-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266698-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266698-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266698-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.10 mm [.083]	F
INSUL	3.40 mm [.134]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: MALE PIN TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.20-5.00 mm [.165-.197 IN]	Ø2.36-2.74 mm [.093-.108 IN]		
TERMINAL APPLICATION SPECIFICATION: ATS-639008300 Rev A			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113242-1	194170024	2113242-3	194170028
2113242-2	194170026	2113242-4	194170030

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.40 +/- 0.05 [.055 +/- .002]	7.6
20 AWG	1.30 +/- 0.05 [.051 +/- .002]	8.6
22 AWG	1.20 +/- 0.05 [.047 +/- .002]	9.6
24 AWG	1.10 +/- 0.05 [.043 +/- .002]	10.7

- 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.

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					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	1		ORIGINAL	13MAR2015	GH	TE
		A		RELEASED	07APR2015	GH	TE
		B		ECR-19-006795	28APR2019	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	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	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	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	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	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	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	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-6	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	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1-1803171-7	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-1633965-3	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
-	1	2	2	1	1-1633305-4	CRIMPER, WIRE PREMIUM	1	
-	77	-72	-71	-2	-1	PART NO	ITEM NO	
							DESCRIPTION	

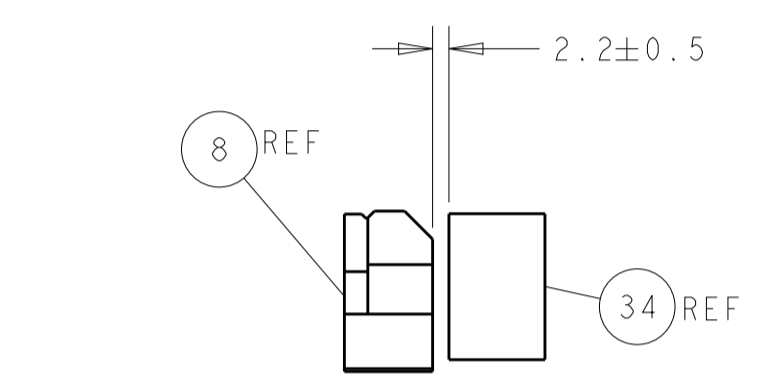
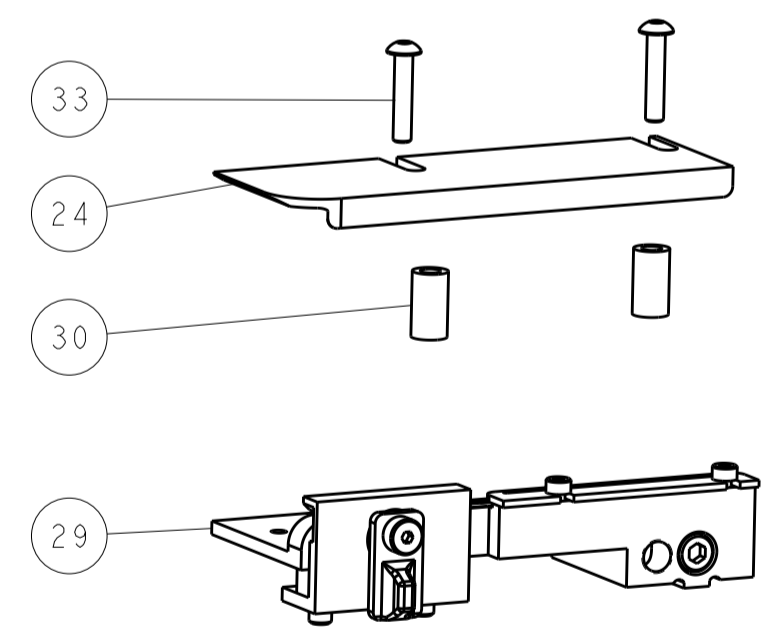
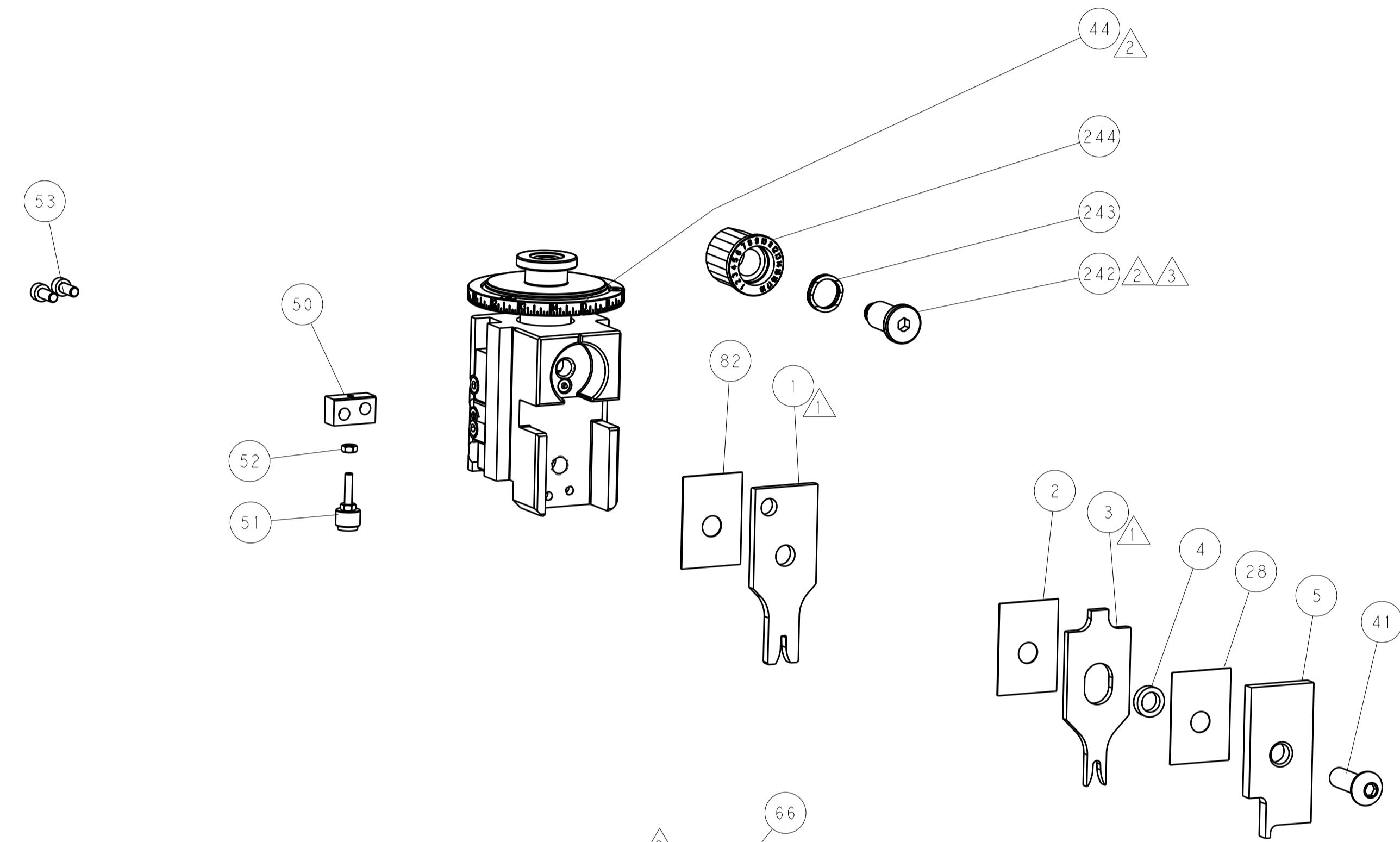
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: HOFFNER 13MAR2015		TE Connectivity Harrisburg, PA 17105-3608	
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2 PLC ±		3 PLC ±		APVD: T. ELBIN 16MAR2015		SIZE: A1	
4 PLC ±		ANGLES ±		PRODUCT SPEC		CAGE CODE: 00779	
MATERIAL		FINISH		APPLICATION SPEC		DRAWING NO: 2266698	
				WEIGHT		RESTRICTED TO: B	
				Customer Accessible Production Drawing			
				SCALE: 1:2 SHEET 1 OF 4 REV B			

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DATE	BY	APPV
- SEE SHEET 1			-	-	-

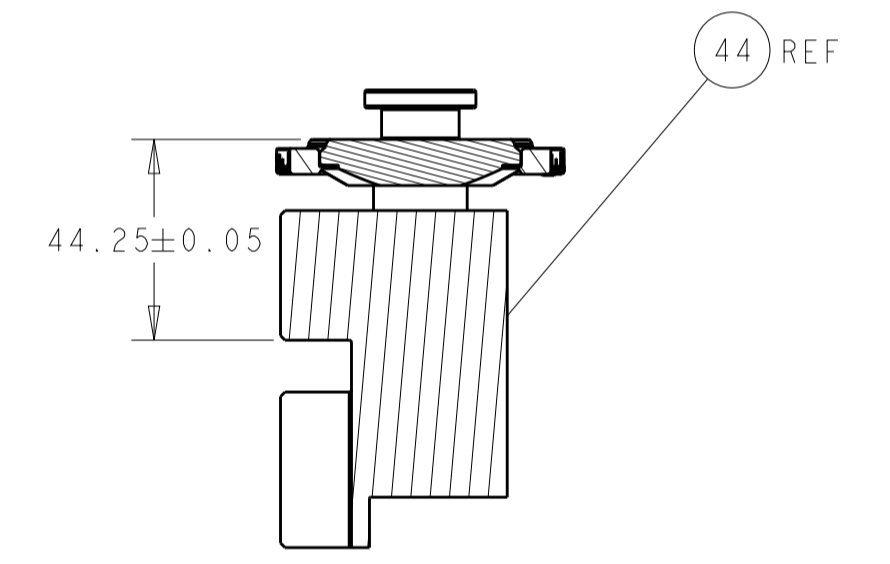
FEED TYPE MECHANICAL



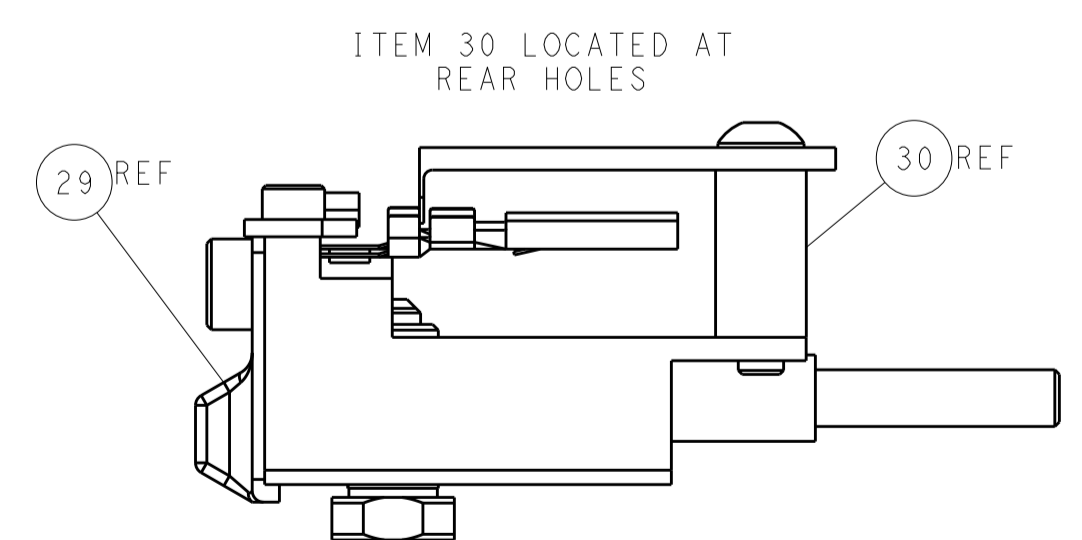
PNEUMATIC



TERMINAL SUPPORT LOCATION



RAM SET-UP



ITEM 30 LOCATED AT REAR HOLES

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: HOFFNER 13MAR2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 2 OF 4		REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266698-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266698-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266698-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.10 mm [.083]	F
INSUL	3.40 mm [.134]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: MALE PIN TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.20-5.00 mm [1.65-.197 IN]	Ø2.36-2.74 mm [.093-.108 IN]		
TERMINAL APPLICATION SPECIFICATION ATS-639008300 Rev A			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113242-1	194170024	2113242-3	194170028
2113242-2	194170026	2113242-4	194170030

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.40+/-0.05 [1.055+/-0.002]	7.6
20 AWG	1.30+/-0.05 [1.051+/-0.002]	8.6
22 AWG	1.20+/-0.05 [1.047+/-0.002]	9.6
24 AWG	1.10+/-0.05 [1.043+/-0.002]	10.7

- 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	REV	DATE	BY	CHKD	APVD
A	66	-	-	-	-	-

REV	DATE	BY	CHKD	APVD	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
-	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
-	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	-	-	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	-	-	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
-	-	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	-	-	455888-3 SPACER, CRIMPER	28
-	1	1	-	-	1320928-6 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	-	-	1803095-6 FLOATING SHEAR, FRONT	9
-	1	1	1	-	3-1803171-7 ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	-	-	2119757-8 DEPRESSOR, SHEAR	5
-	1	1	-	-	2-238011-1 BLOCK, CRIMPER SPACER	4
-	1	1	1	-	3-1633965-3 CRIMPER, INSULATION O PREMIUM	3
-	1	1	-	-	455888-4 SPACER, CRIMPER	2
-	1	1	1	-	8-1633305-4 CRIMPER, WIRE PREMIUM	1

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

APPROVED	DATE	BY	CHKD	APVD
T. ELBIN	16MAR2015	T. ELBIN	T. ELBIN	T. ELBIN

NAME	DESCRIPTION	ITEM NO
Ocean Side Feed Applicator		

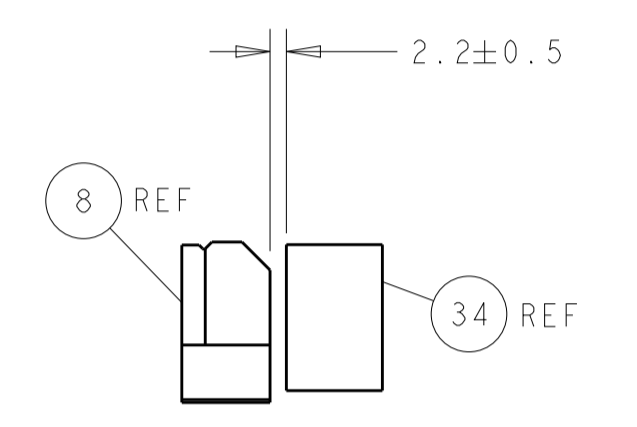
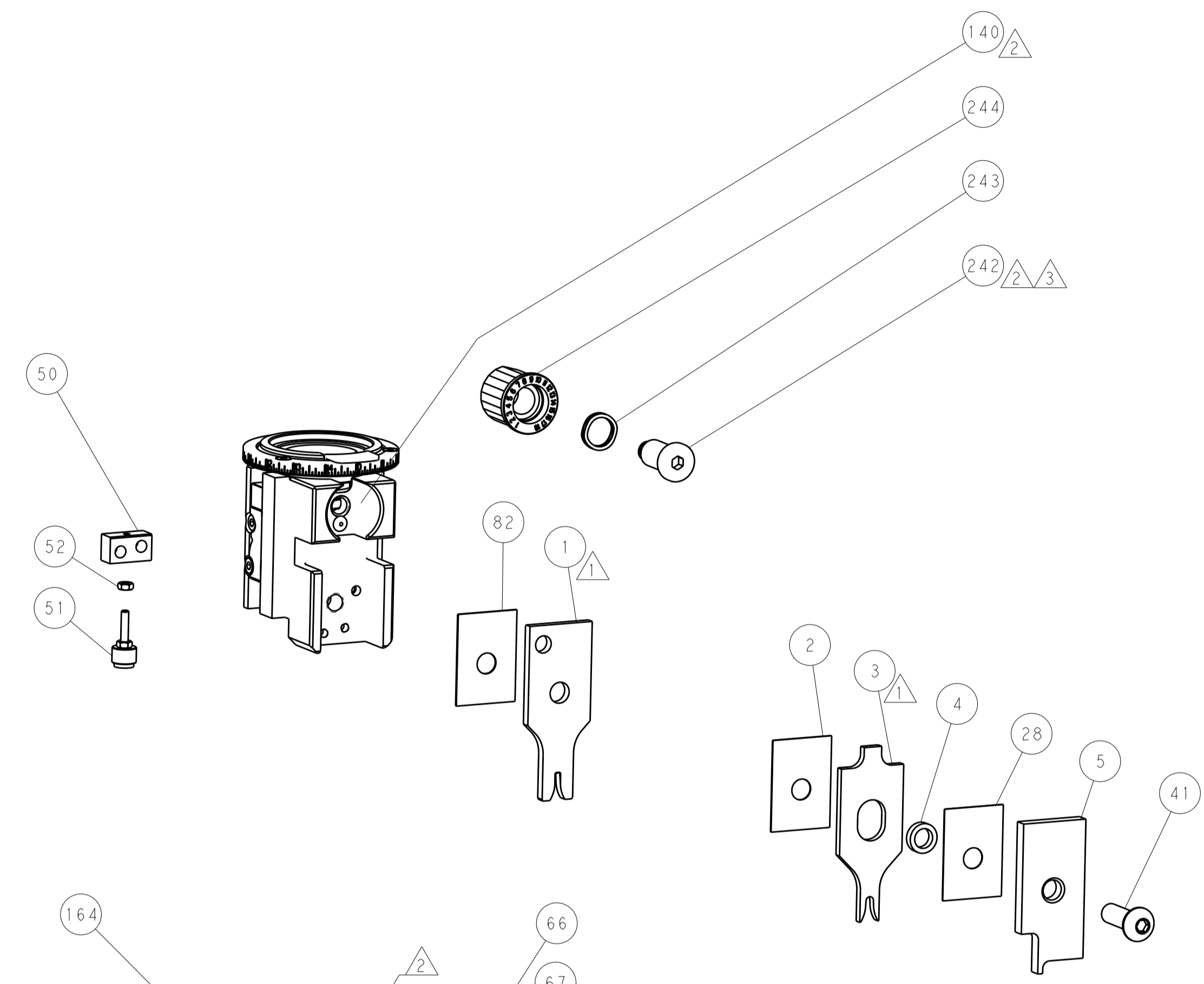
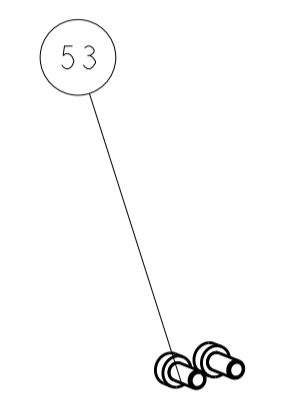
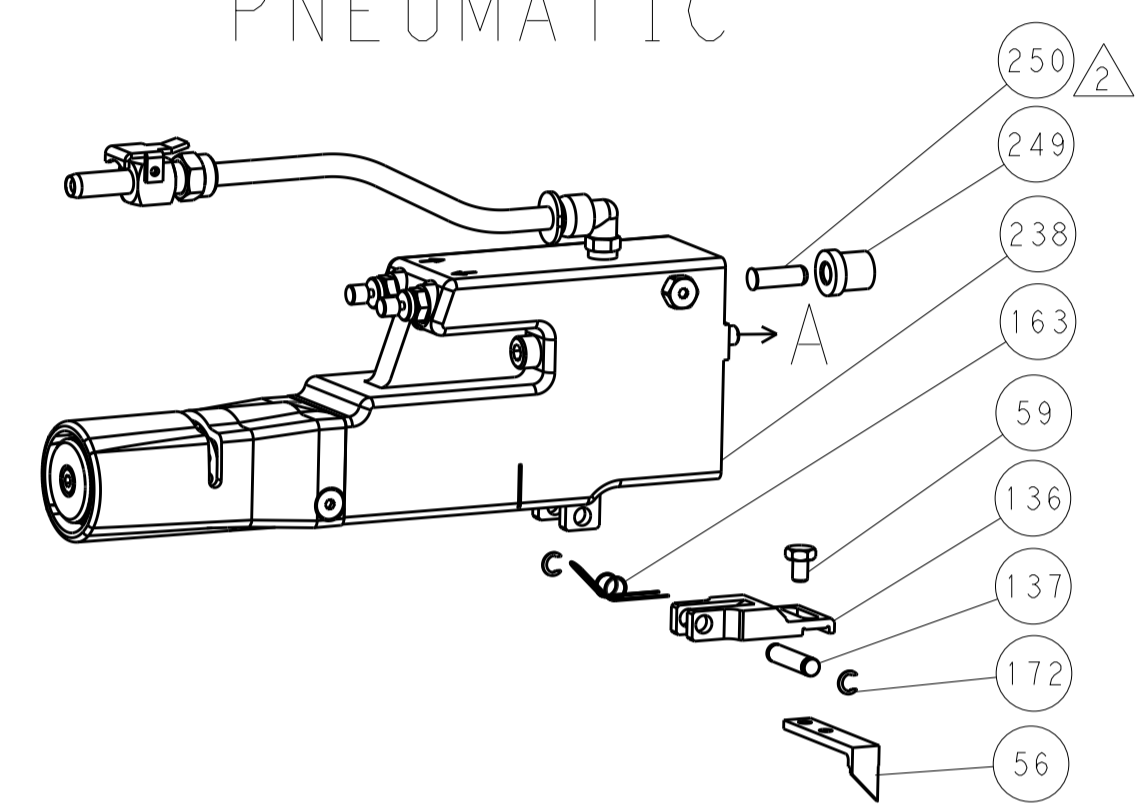
SCALE	SHEET	OF	REV
1:2	3	4	B

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

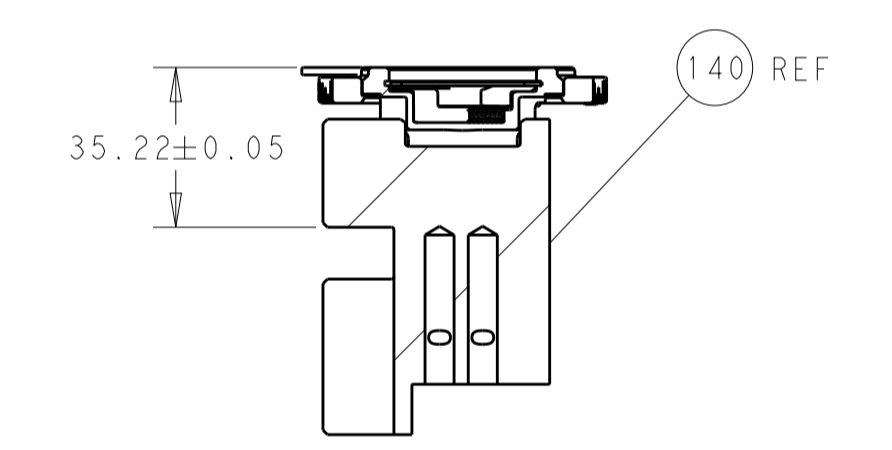
FEED TYPE MECHANICAL



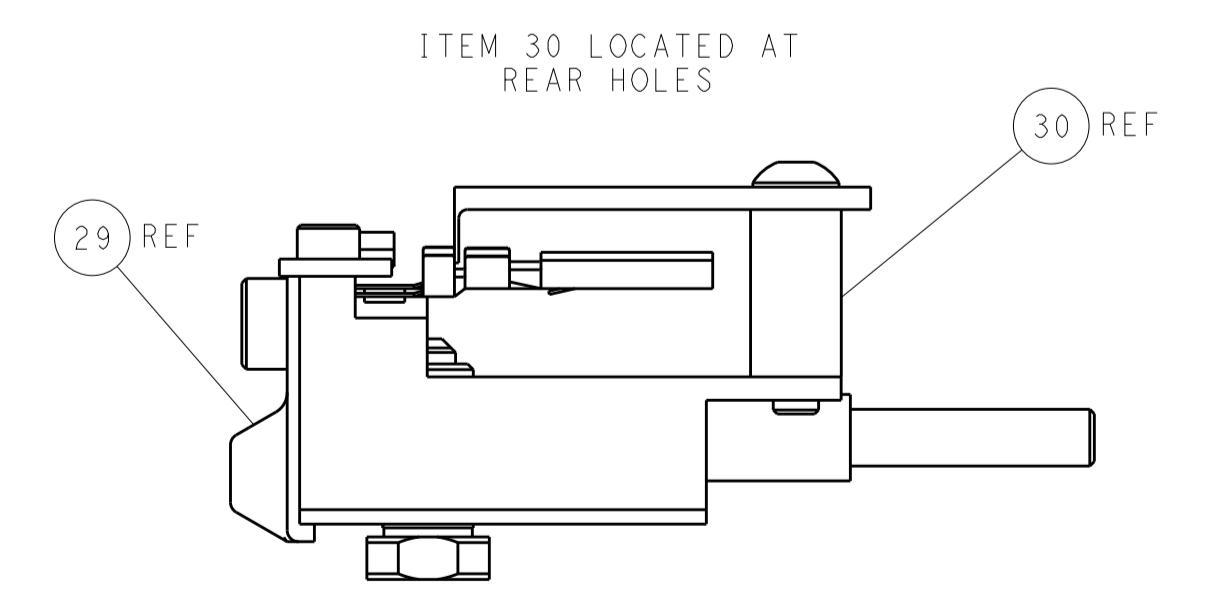
PNEUMATIC



TERMINAL SUPPORT LOCATION

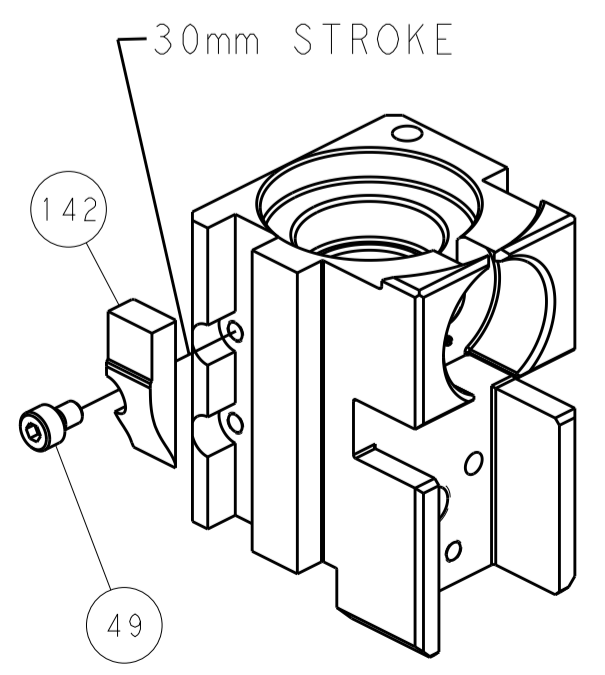


RAM SET-UP

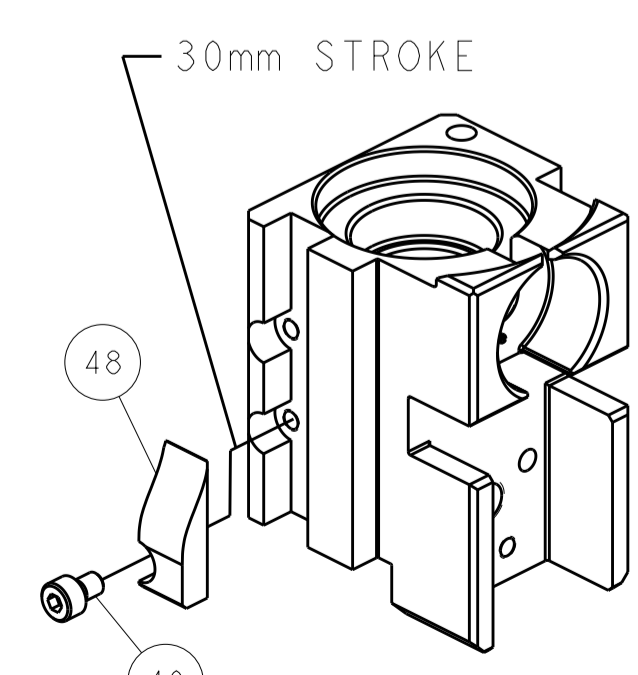


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

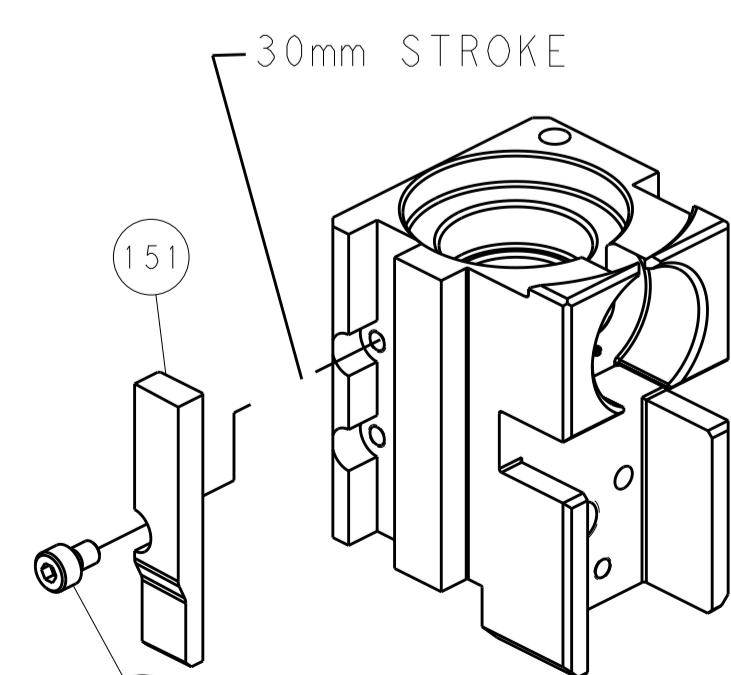
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: HOFFNER 13MAR2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		NAME: Ocean Side Feed Applicator		RESTRICTED TO	
MATERIAL:		WEIGHT:	SCALE: 1:2	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2266698	REV: B
Customer Accessible Production Drawing				SHEET 4 OF 4			