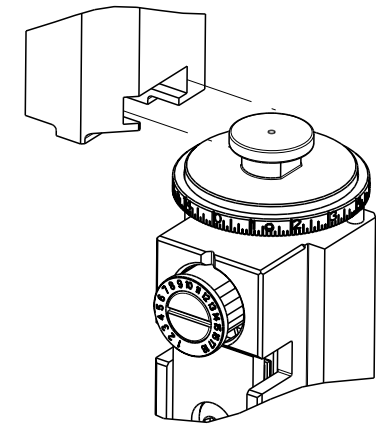


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266831-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266831-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266831-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266831-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266831-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.70 mm [.067]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 2.5 MINI WATERPROOF CONN. CRIMP PIN.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.00-2.50 mm [.079-.098 IN]		Ø1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	AS-50147-001 Rev C		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949201-1	501478000	1949200-1	501488000

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
SAE TXL 20 AWG	1.01+/-0.05 [.040+/- .002]	7.6
AVSSB 0.5Fmm ²	1.01+/-0.05 [.040+/- .002]	7.6
ISO FLY 0.5mm ²	1.01+/-0.05 [.040+/- .002]	7.6
JASO CAVS 0.5mm ²	1.01+/-0.05 [.040+/- .002]	7.6
JASO AVSS 0.5/0.5Fmm ²	1.01+/-0.05 [.040+/- .002]	7.6
SAE TXL 22 AWG	0.97+/-0.025 [.038+/- .001]	8.0
AVSSB 0.3Fmm ²	0.97+/-0.025 [.038+/- .001]	8.0
JASO CAVS 0.3mm ²	0.97+/-0.025 [.038+/- .001]	8.0
JASO AVSS 0.3/0.3Fmm ²	0.97+/-0.025 [.038+/- .001]	8.0

- 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.

LOC	DIST	REVISIONS			
		REV	DATE	BY	CHK
A	66	A	21AUG2015	MR	GB
		B	24OCT2018	MS	CT
		B1	21DEC2020	JWC	GB

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	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	1-455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	1-2119791-4	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	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	3-1752356-4	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-4	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	9-1633932-0	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119757-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-6	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2-1803019-0	CRIMPER, INSULATION O	3
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	7-456402-7	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	DESCRIPTION	ITEM NO

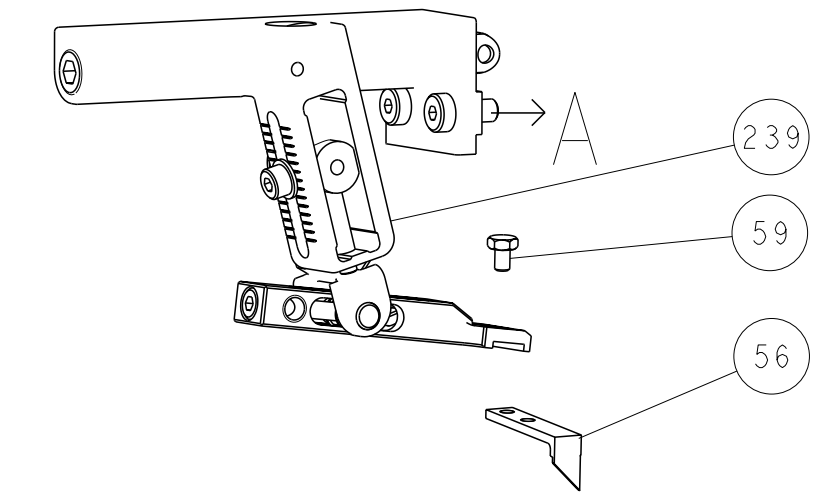
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		DATE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	30 JUN 2015	30 JUN 2015
	ANGLES	FINISH					
MATERIAL							

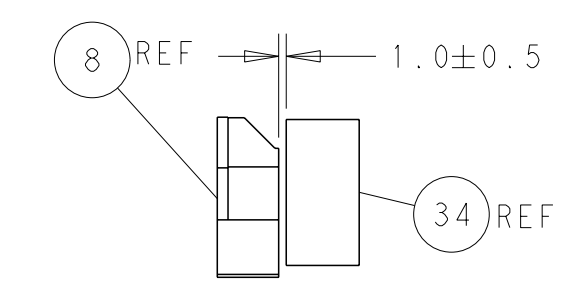
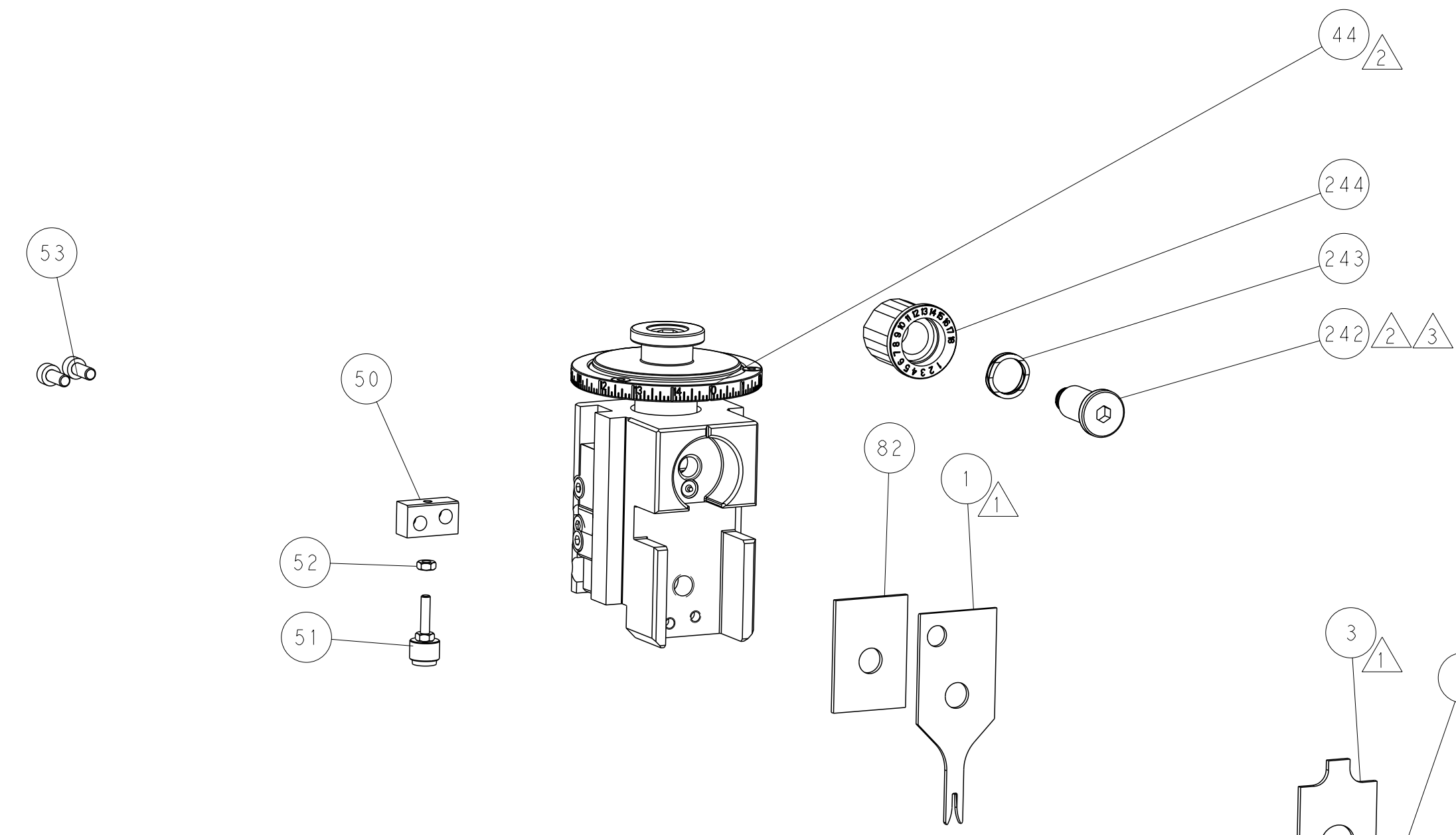
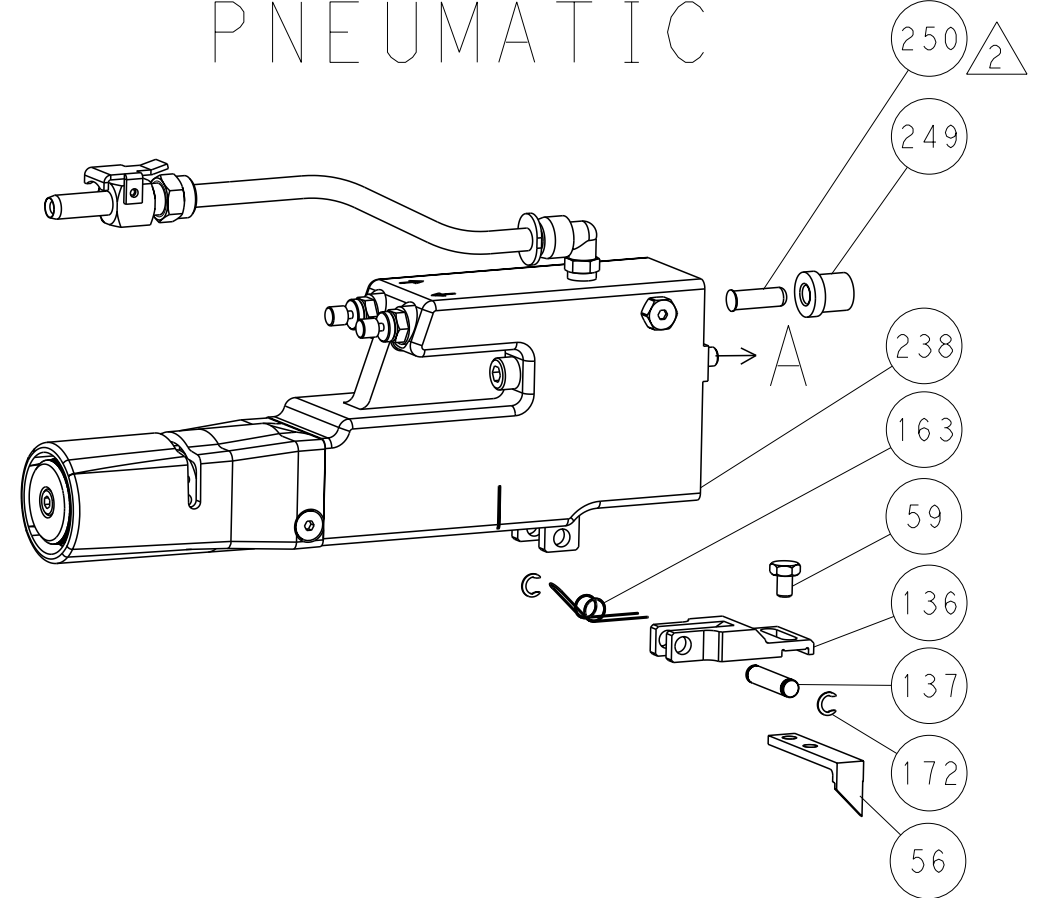
OWN	J. HUANG	30 JUN 2015	
CHK	L. ZHANG	30 JUN 2015	
APVD	J. GUO	30 JUN 2015	
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266831	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV B1

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

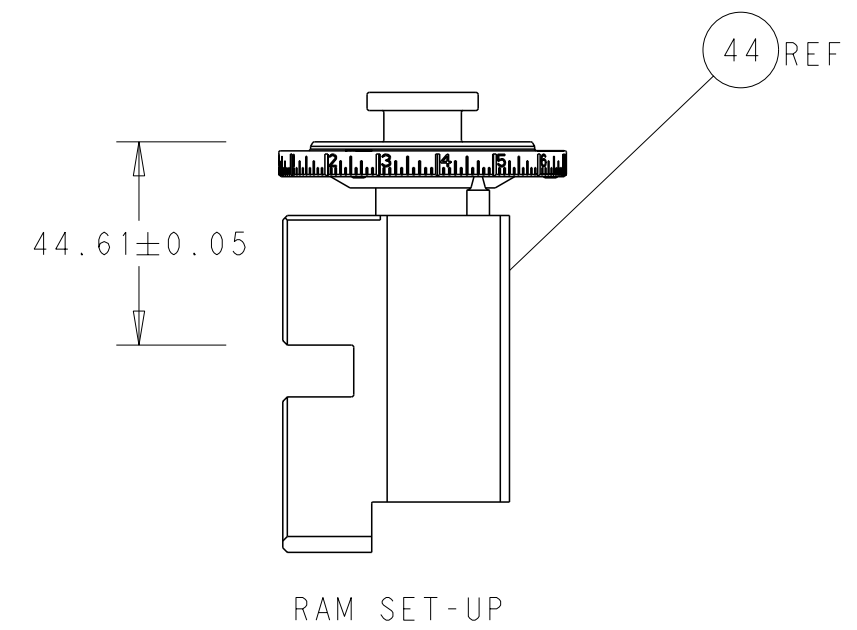
FEED TYPE MECHANICAL



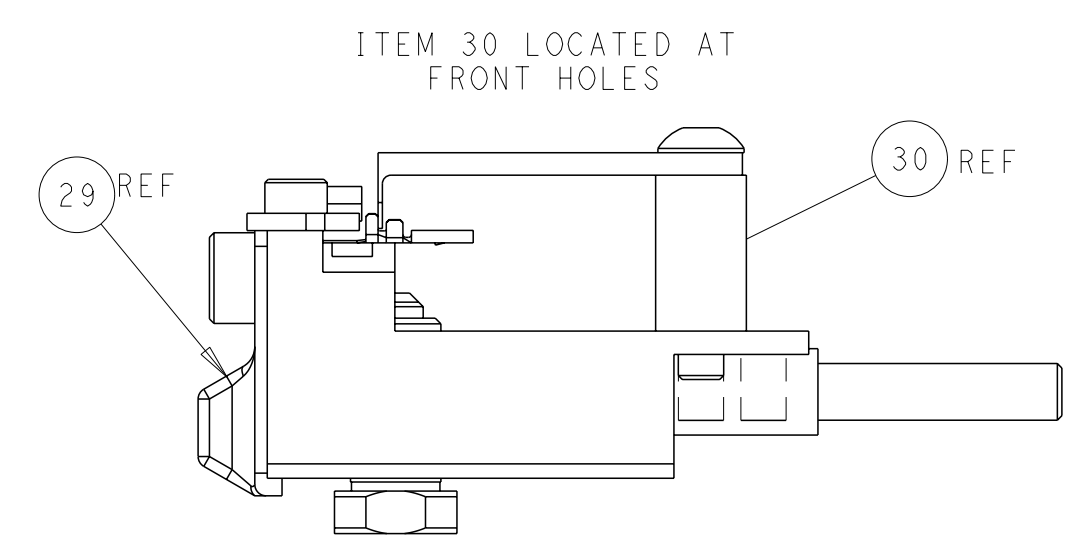
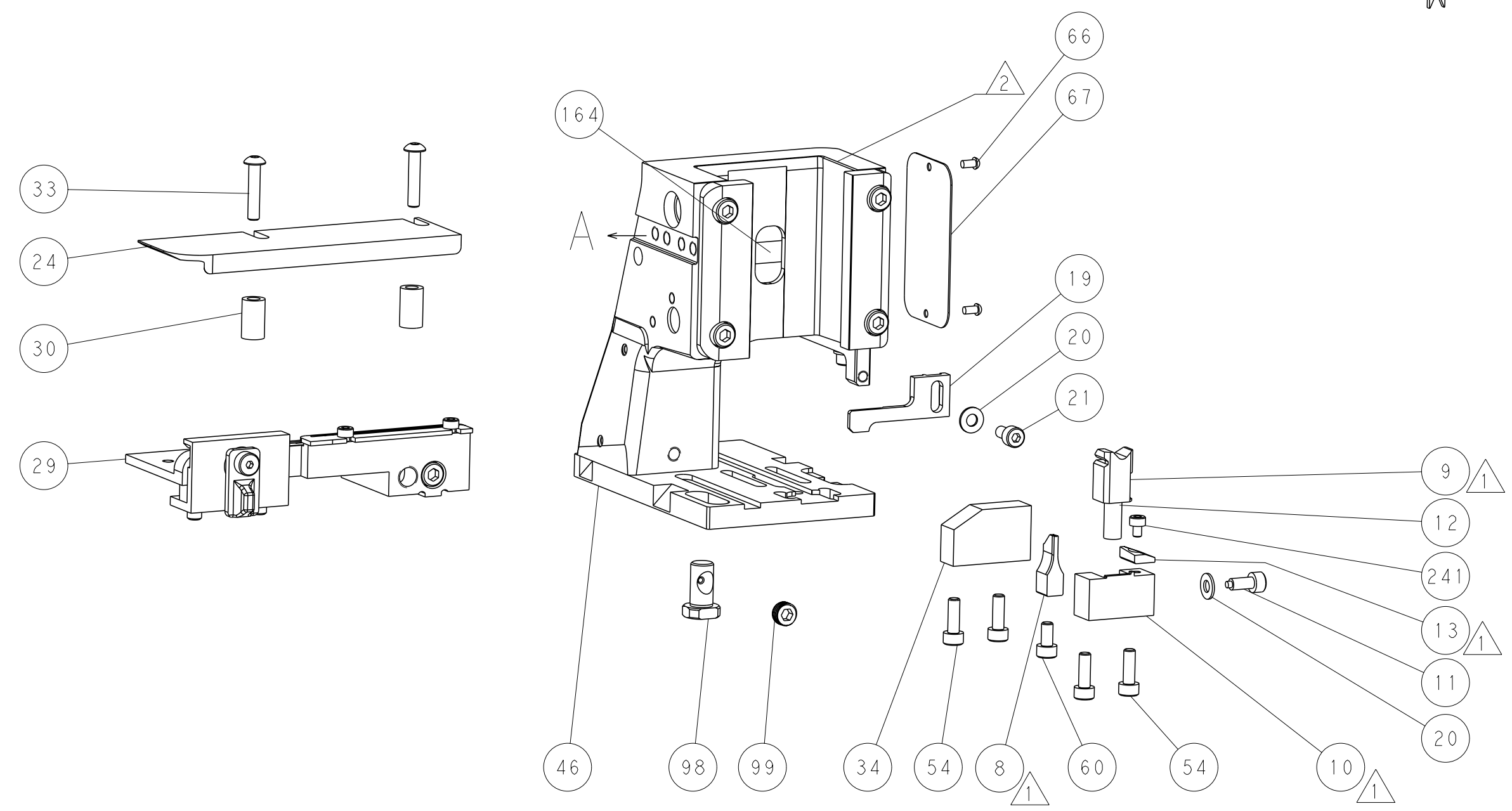
PNEUMATIC



TERMINAL SUPPORT LOCATION

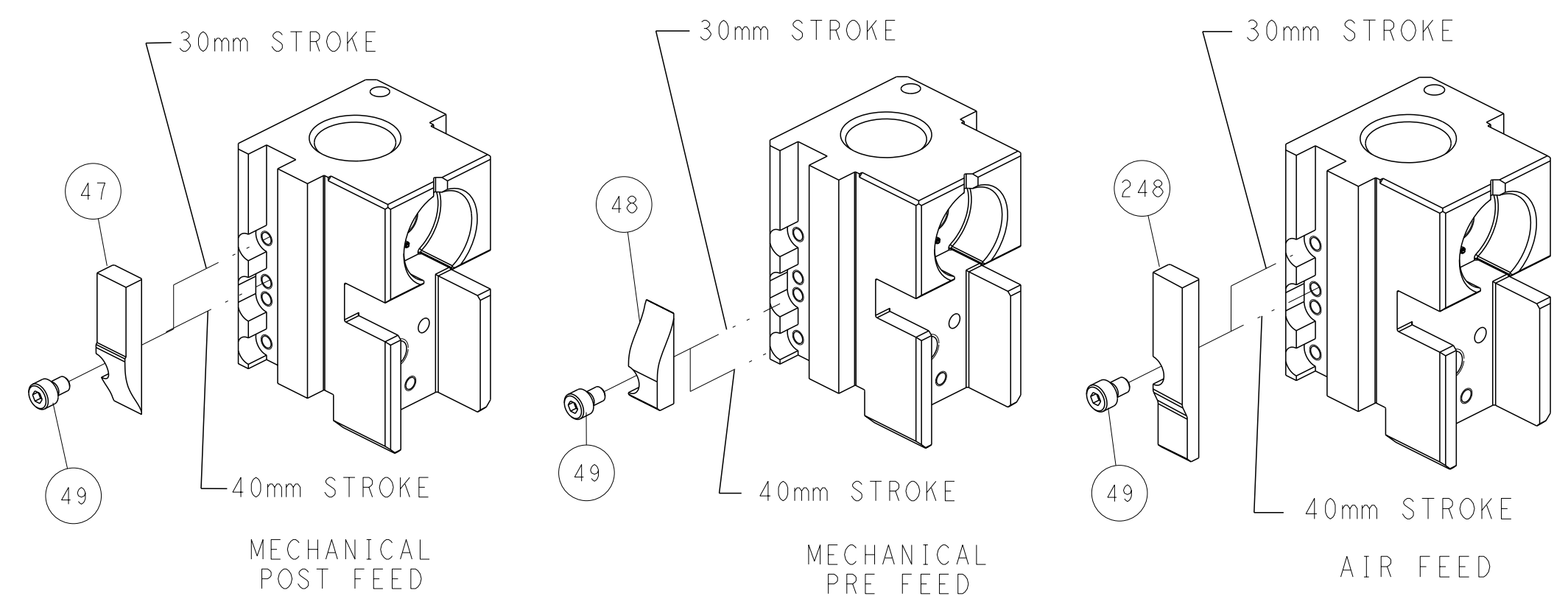


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

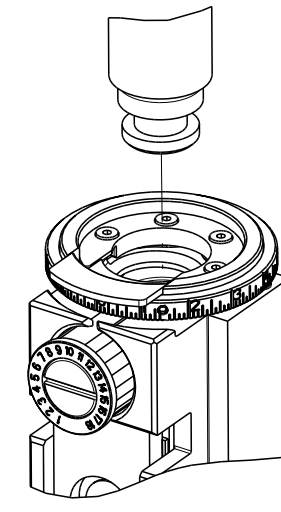


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		OWN: H. HUANG 30 JUN 2015 CHK: L. ZHANG 30 JUN 2015 APVD: J. GUO 30 JUN 2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266831 SCALE: 1:2 SHEET: 2 of 4 REV: B1		RESTRICTED TO:	
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THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266831-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266831-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266831-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.70 mm [.067]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 2.5 MINI WATERPROOF CONN. CRIMP PIN.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.00-2.50 mm [.079-.098 IN]		Ø1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	AS-50147-001 Rev C		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949201-1	501478000	1949200-1	501488000

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
SAE TXL 20 AWG	1.01+/-0.05 [.040+/-0.002]	7.6
AVSSB 0.5Fmm ²	1.01+/-0.05 [.040+/-0.002]	7.6
ISO FLYR 0.5mm ²	1.01+/-0.05 [.040+/-0.002]	7.6
JASO CAVS 0.5mm ²	1.01+/-0.05 [.040+/-0.002]	7.6
JASO AVSS 0.5/0.5Fmm ²	1.01+/-0.05 [.040+/-0.002]	7.6
SAE TXL 22 AWG	0.97+/-0.025 [.038+/-0.001]	8.0
AVSSB 0.3Fmm ²	0.97+/-0.025 [.038+/-0.001]	8.0
JASO CAVS 0.3mm ²	0.97+/-0.025 [.038+/-0.001]	8.0
JASO AVSS 0.3/0.3Fmm ²	0.97+/-0.025 [.038+/-0.001]	8.0

***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.

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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

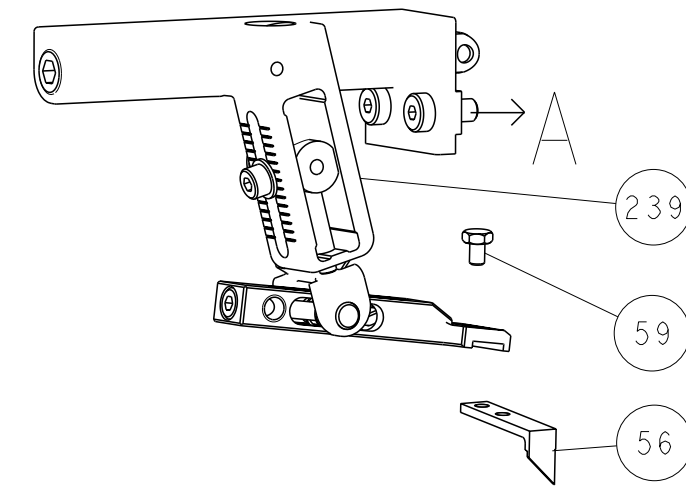
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	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	1-455888-4	SPACER, CRIMPER	82
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1-2119791-4	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	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	3-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	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	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	1803095-3	FLOATING SHEAR, FRONT	9
-	1	1	1-1633932-0	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1-238011-6	BLOCK, CRIMPER SPACER	4
-	1	1	2-1803019-0	CRIMPER, INSULATION O	3
-	-	-	-	-	2
-	1	1	7-456402-7	CRIMPER, WIRE PREMIUM	1
-	-	-	-	-	0

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

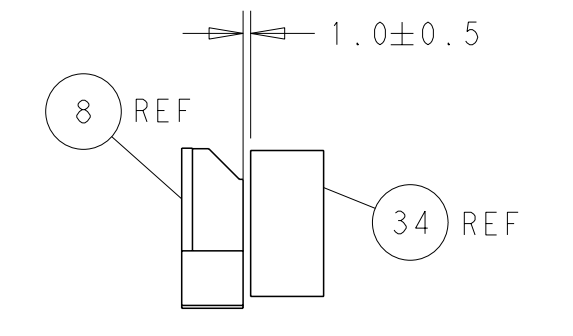
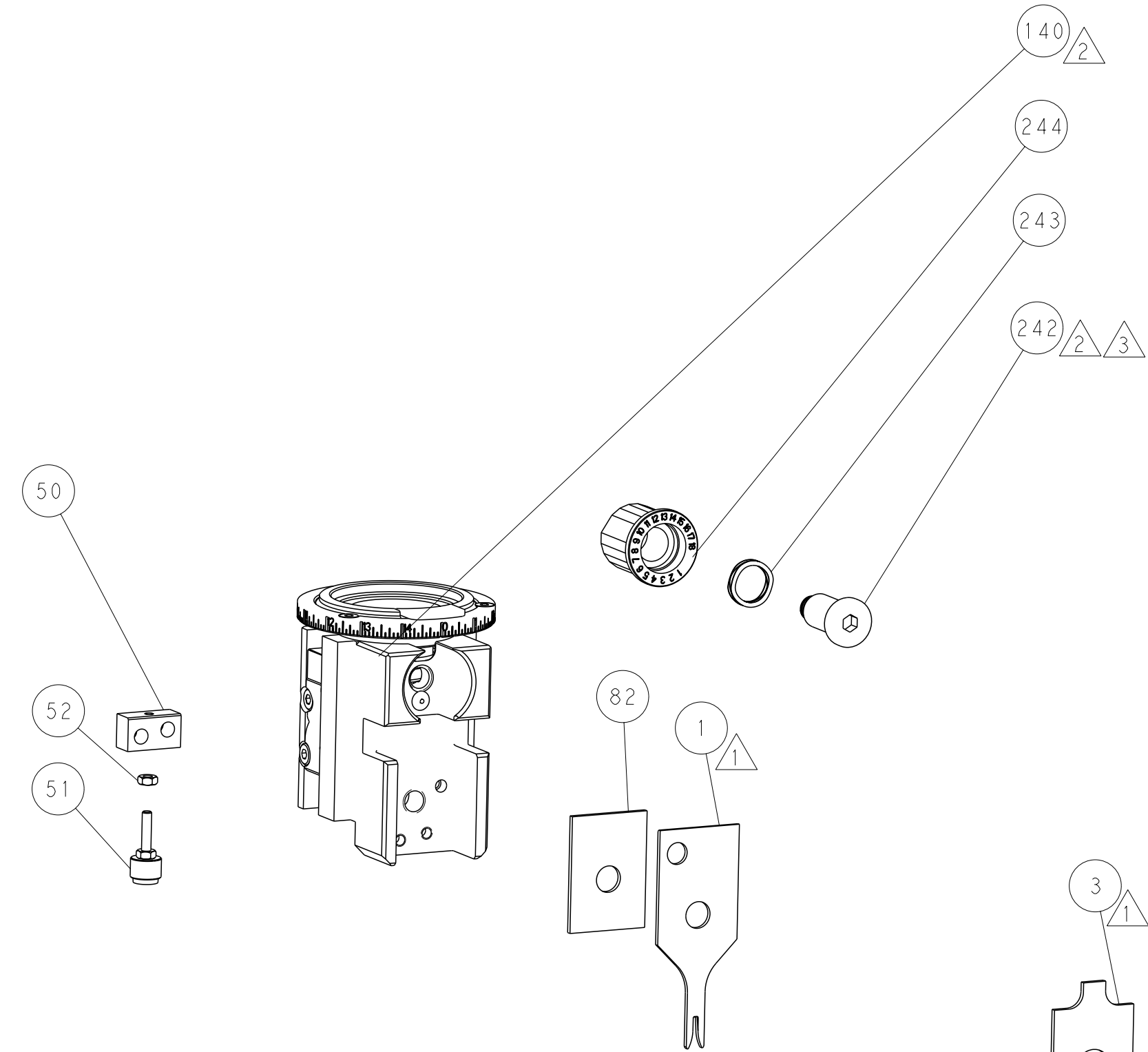
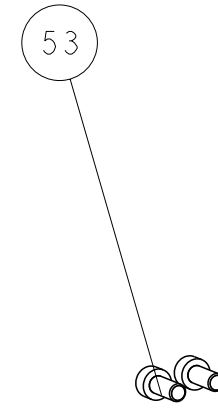
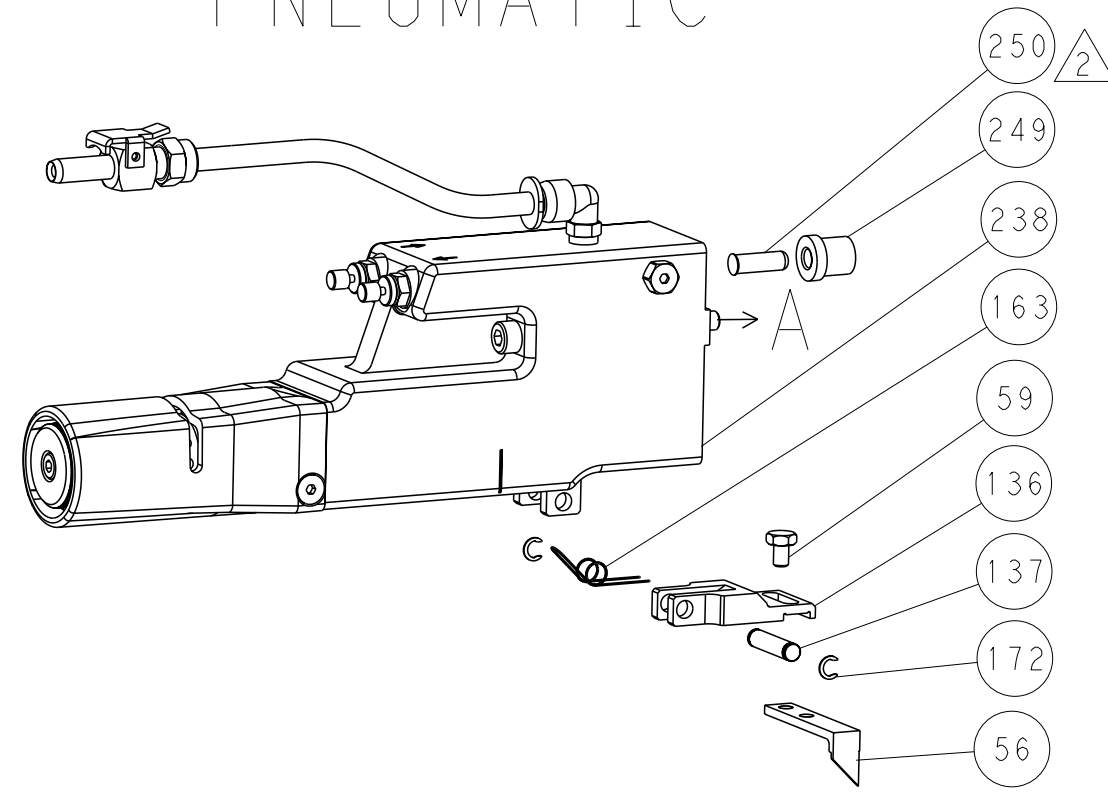
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	30 JUN 2015	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	30 JUN 2015	
	3 PLC ±	4 PLC ±	ANGLES	APVD	30 JUN 2015	NAME
	FINISH			U. GUO		Ocean Side Feed Applicator
MATERIAL				PRODUCT SPEC		SIZE
				APPLICATION SPEC		CAGE CODE
				WEIGHT		DRAWING NO
						00779
						©=2266831
						Customer Accessible Production Drawing
						SCALE 1:2 SHEET 3 OF 4 REV B1

LOC		DIST		REVISIONS			
P	LYR	DATE	OWN	APVD	DESCRIPTION	DATE	OWN
-	-	-	-	-	SEE SHEET 1	-	-

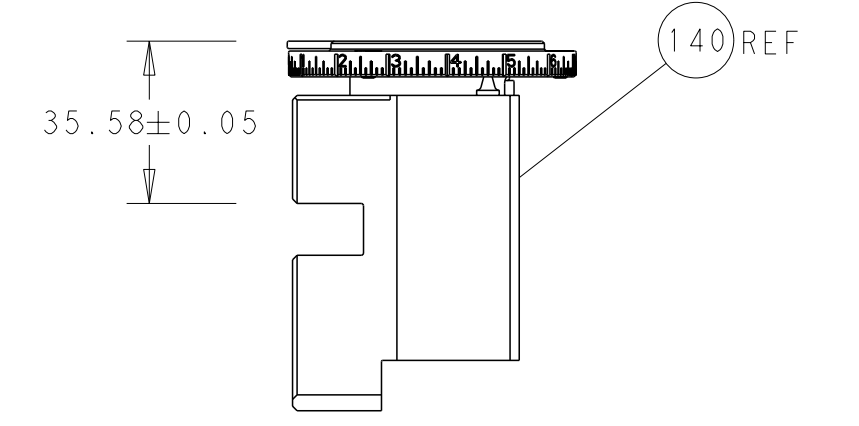
FEED TYPE MECHANICAL



PNEUMATIC

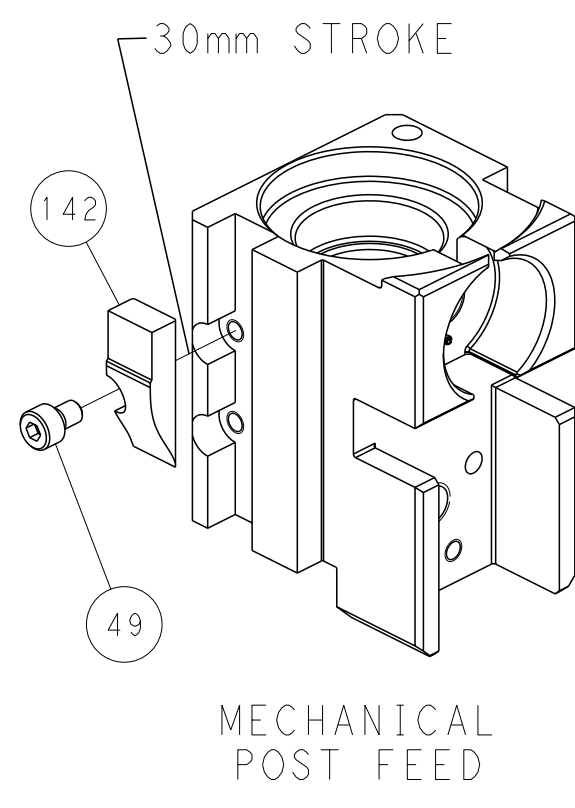


TERMINAL SUPPORT LOCATION

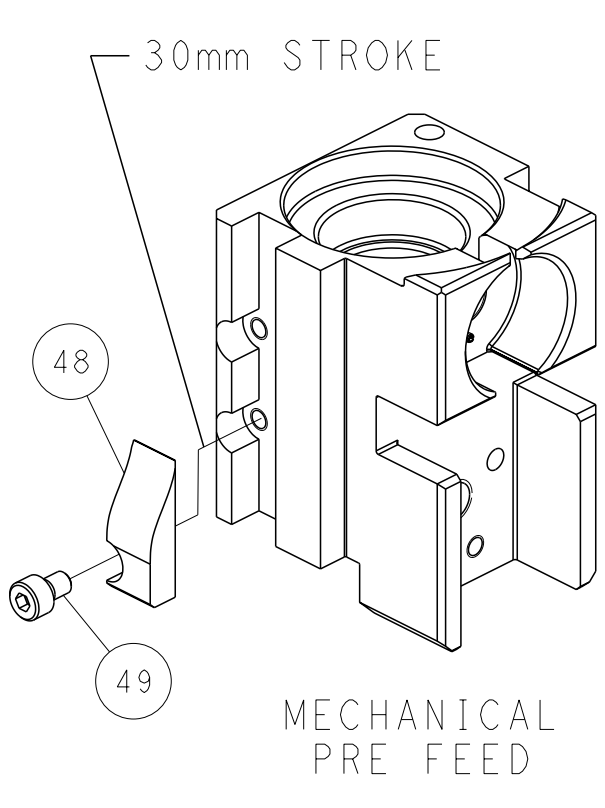


RAM SET-UP

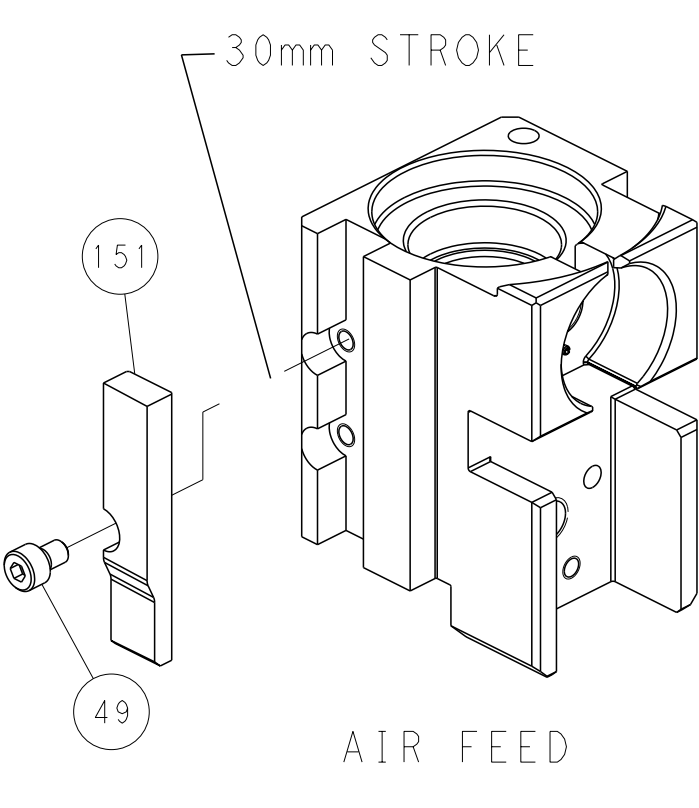
CAM POSITIONS



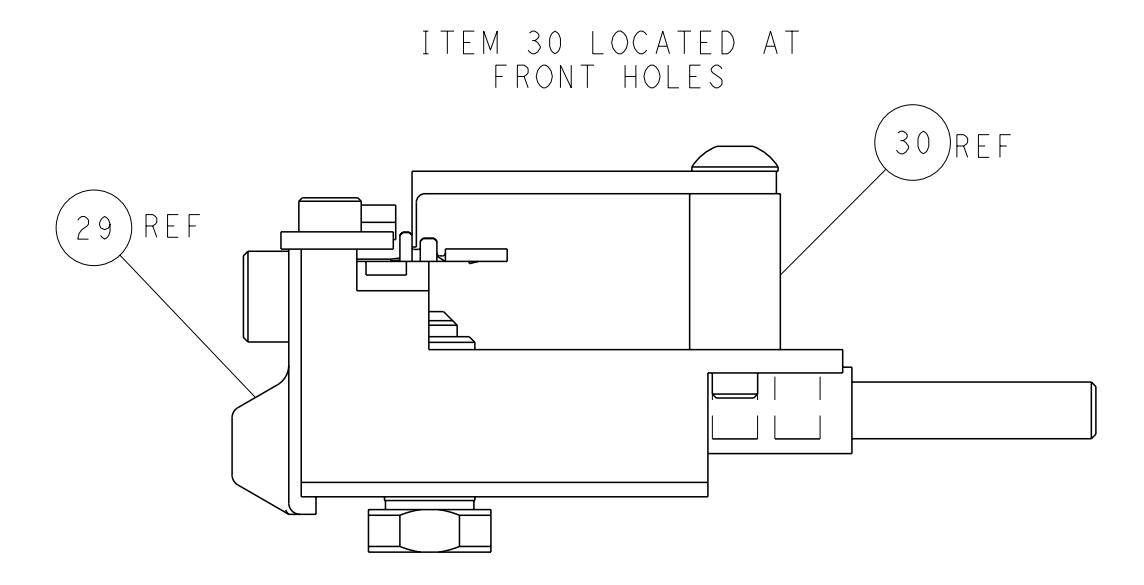
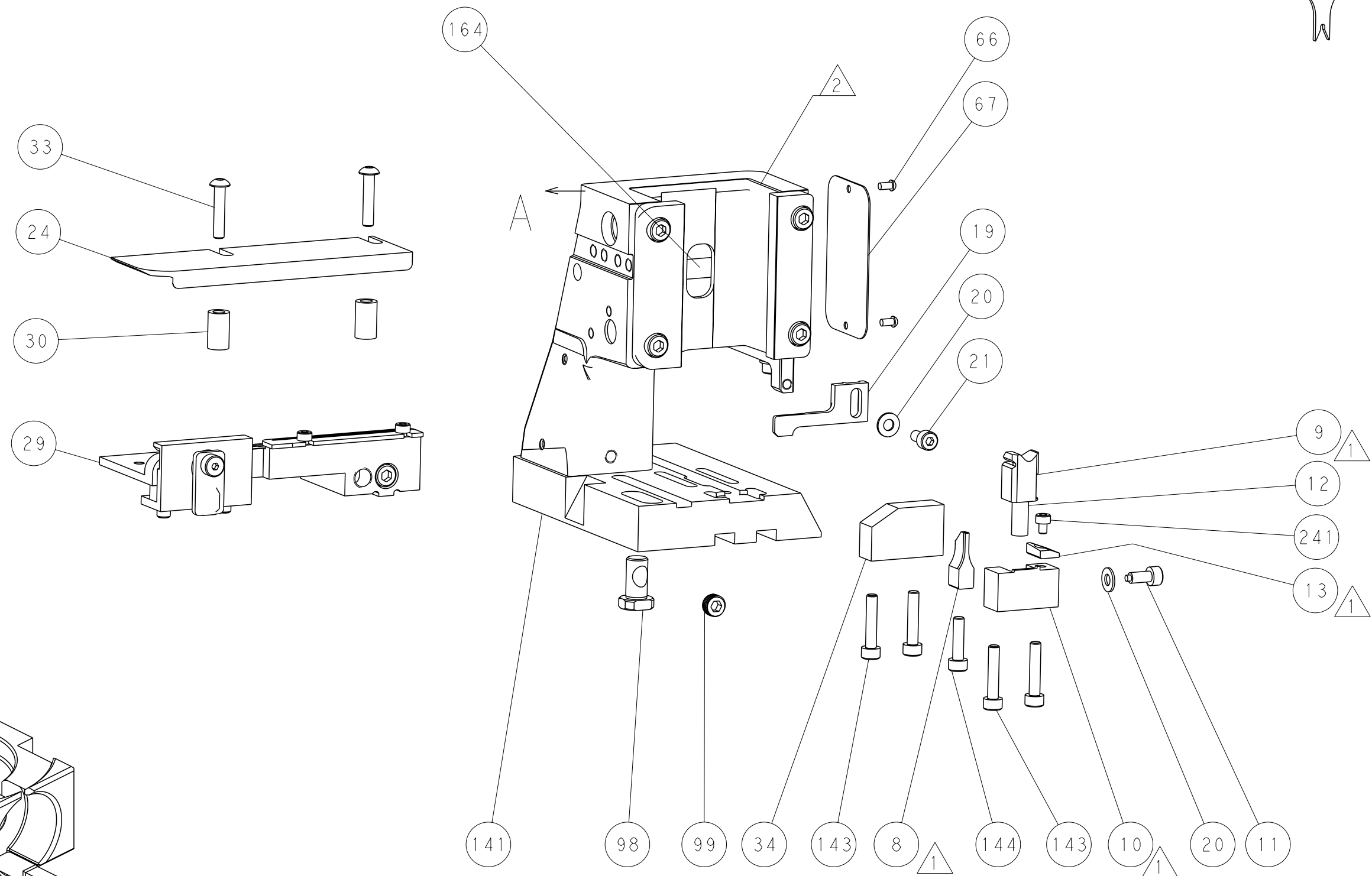
MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: H. HUANG 30 JUN 2015 CHK: L. ZHANG 30 JUN 2015 APVD: J. GUO 30 JUN 2015	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: C=2266831	RESTRICTED TO: - SHEET 4 OF 4 REV B1