

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266772-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266772-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266772-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266772-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266772-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266772-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266772-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.95 mm [.037]	F
INSUL	1.10 mm [.043]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: ZE CONNETOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.10-2.10 mm [.083-.083 IN]		Ø0.80-1.20 mm [.031-.047 IN]	
TERMINAL APPLICATION SPECIFICATION	SZE-002T-P0.3 Rev 4/23/2015		
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2113702-1	SZE-002T-P0.3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.65 +/- 0.05 [.026 +/- .002]	5.7
26 AWG	0.60 +/- 0.05 [.024 +/- .002]	6.2
28 AWG	0.53 +/- 0.05 [.021 +/- .002]	7.1

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

**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	OWN	APVD
		C		ECR-17-005268	12APR2017	AW	GB
		D		ECR-19-014138	10SEP2019	FJ	TE
		E		ECR-21-124516	20DEC2021	RK	JH
		F		ECR-23-165530	06FEB2023	ROY	GEB

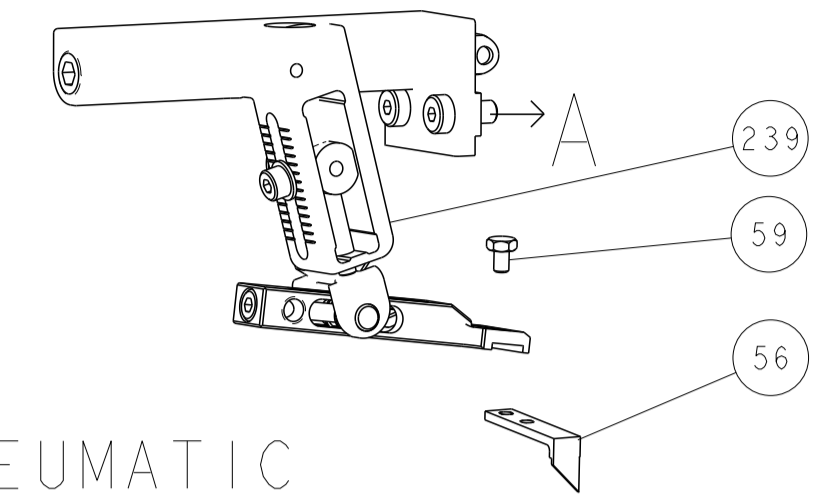
-	1	1	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	1	2119740-1	TAG IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	2-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	28
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-4	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	8-1803054-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	3-238011-7	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	8-1633962-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	2	2	1	1	1	1	6-1633713-2	CRIMPER, WIRE PREMIUM	1

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

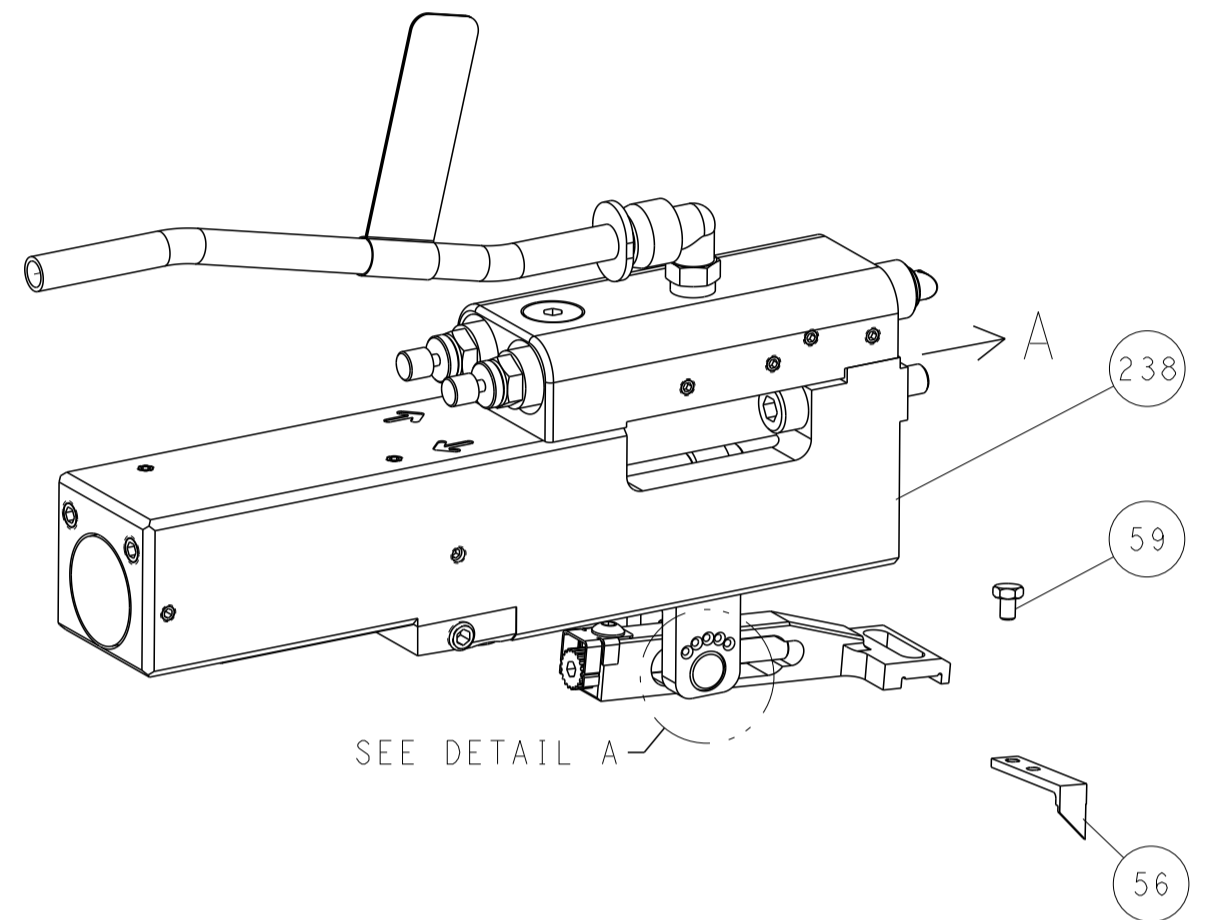
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CHK	L. ZHANG	30APR2015
APVD	J. GUO	30APR2015
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266772
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	F	

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

# FEED TYPE MECHANICAL



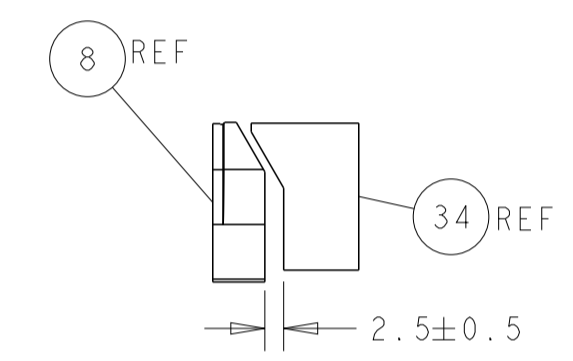
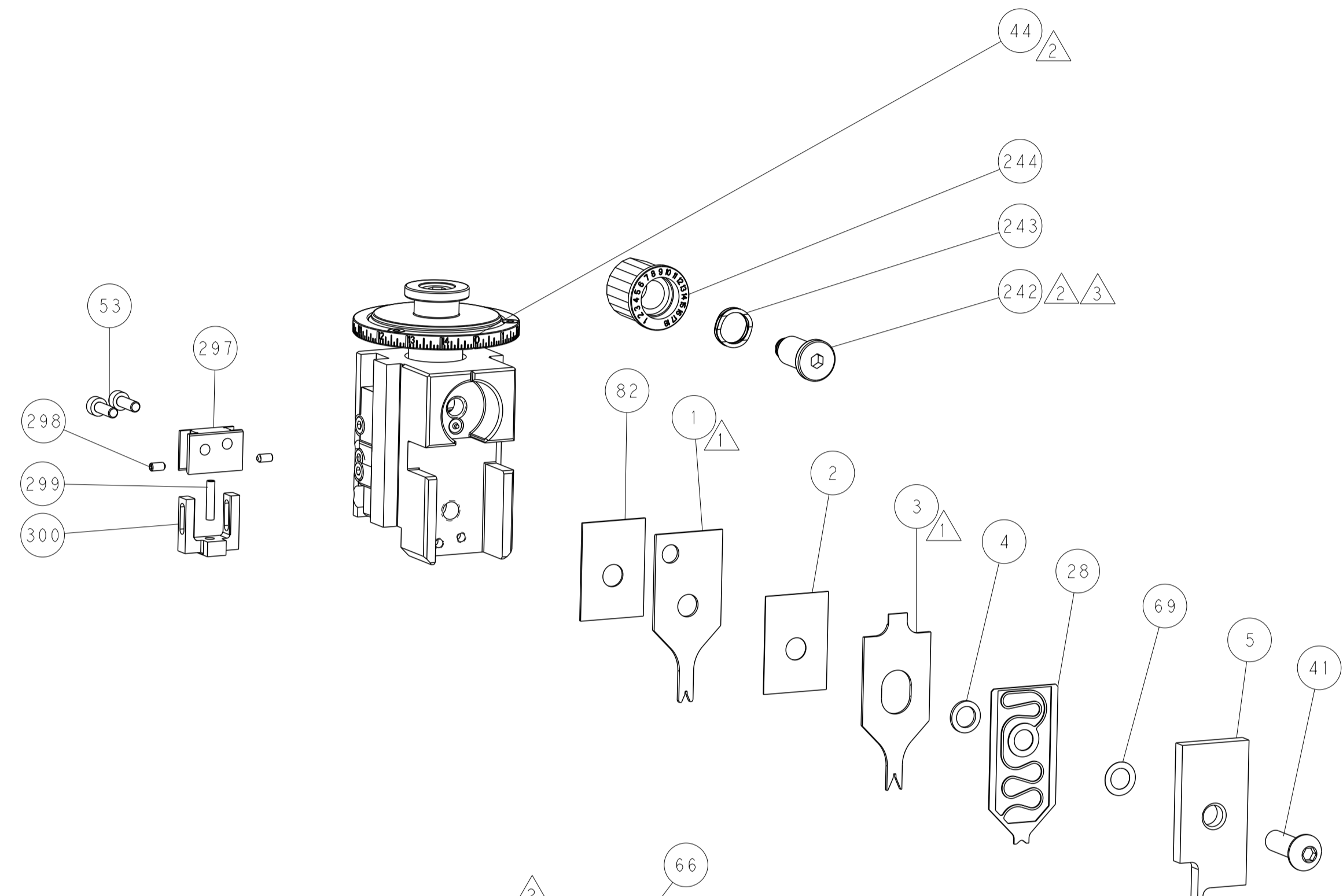
## PNEUMATIC



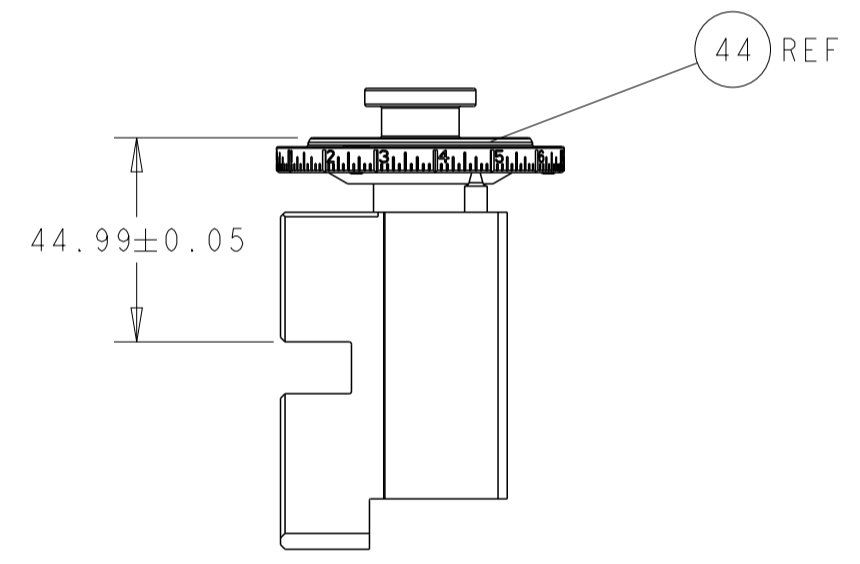
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



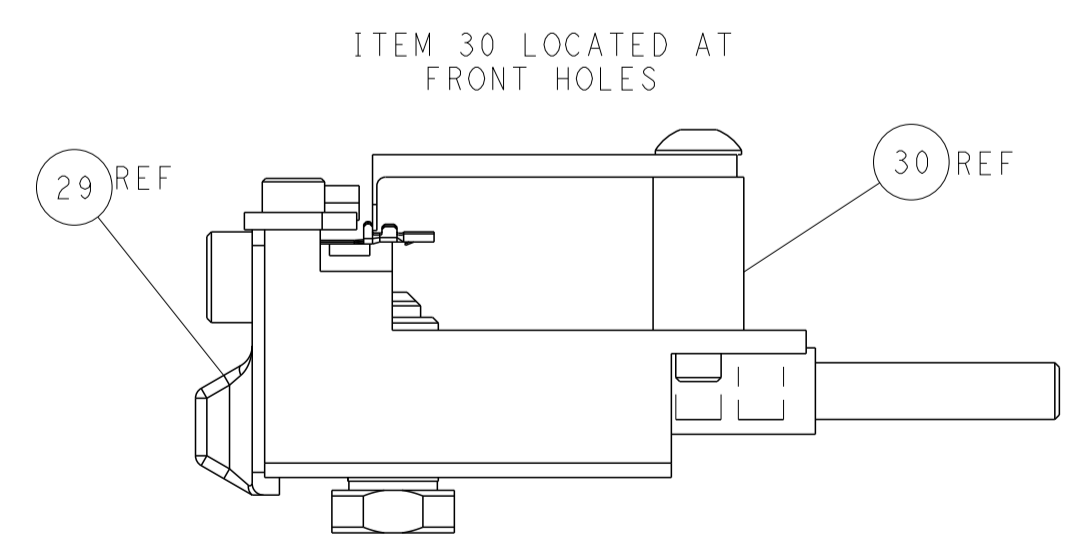
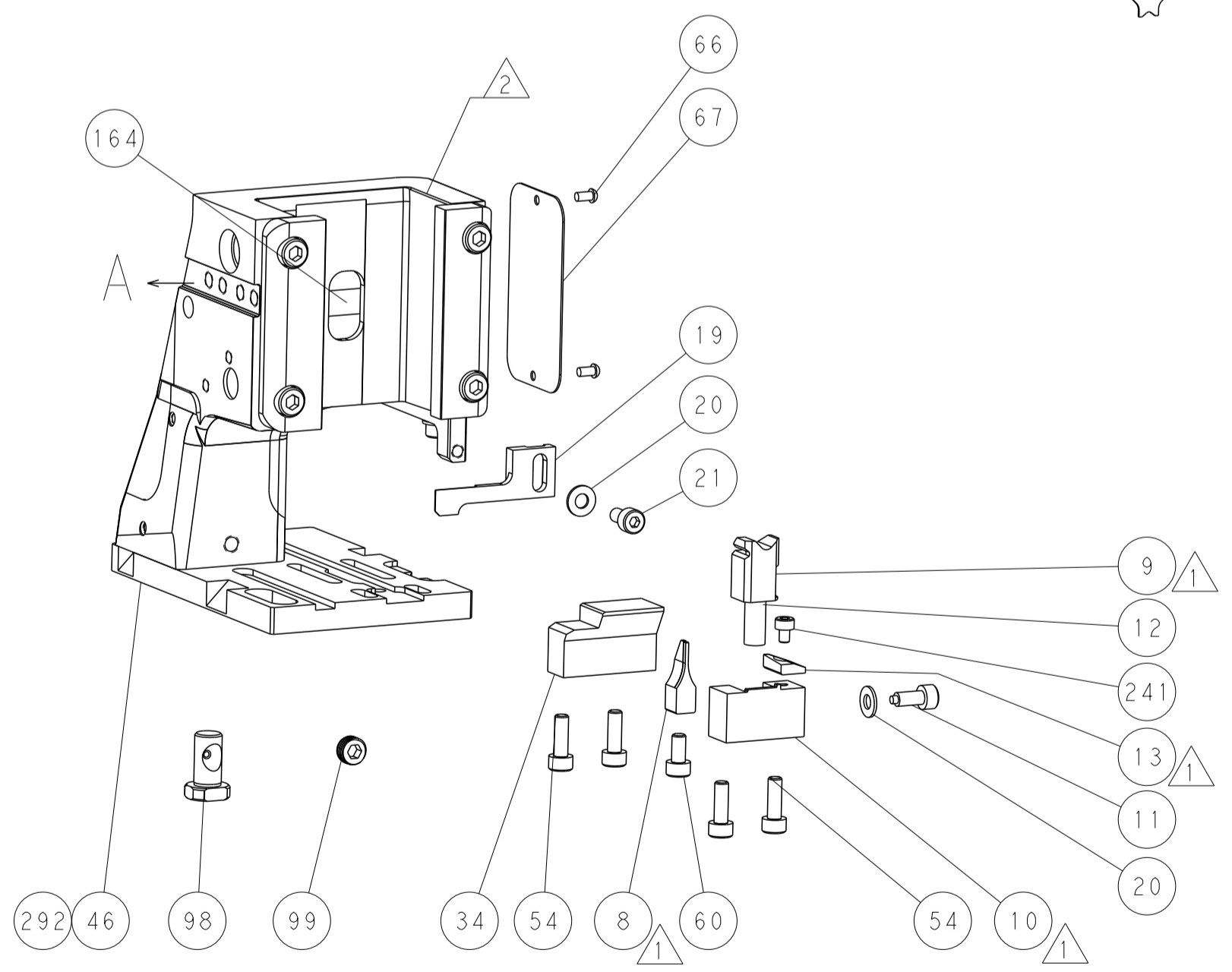
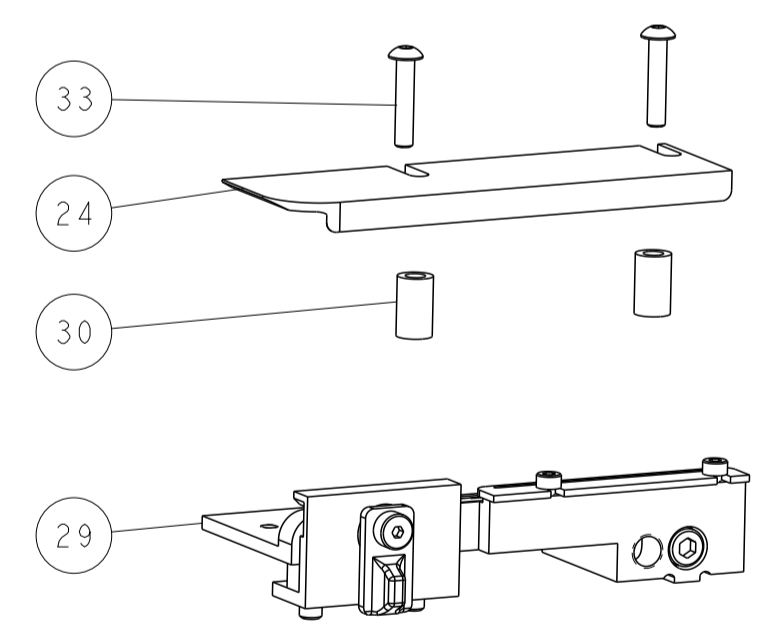
DETAIL A



TERMINAL SUPPORT LOCATION

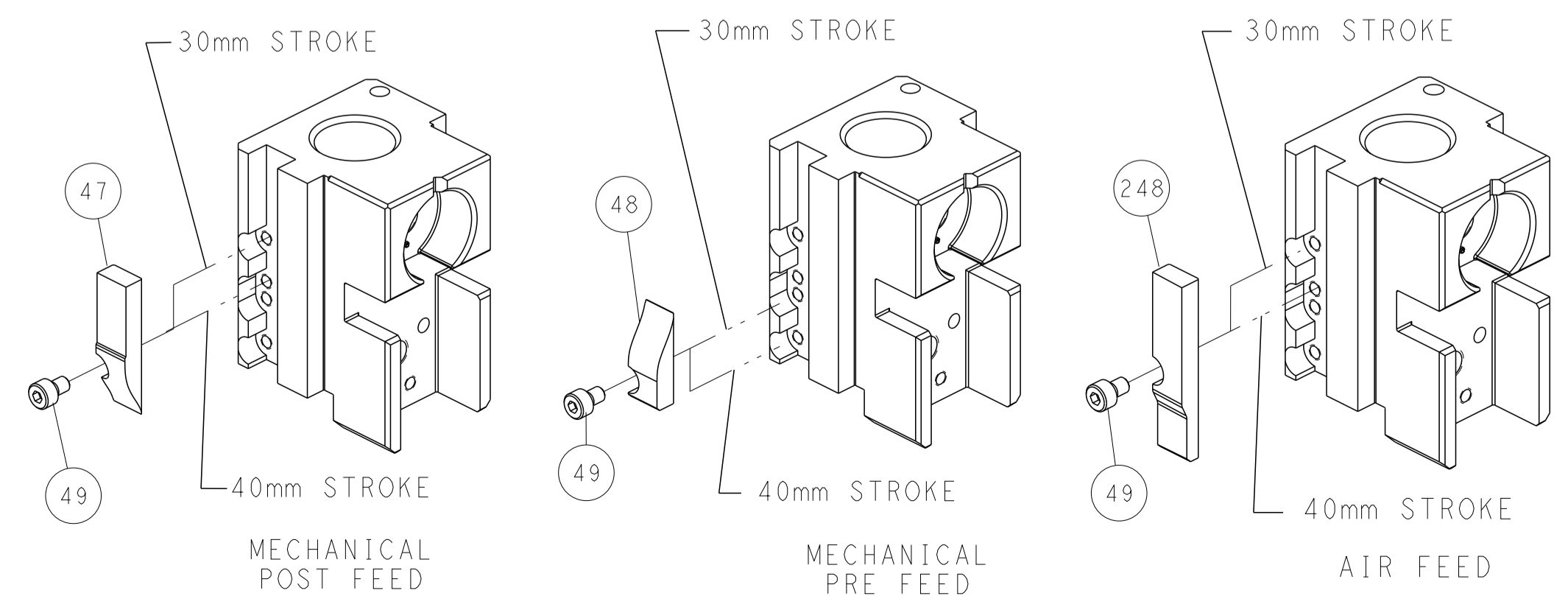


RAM AND HOLDDOWN SET-UP



ITEM 30 LOCATED AT FRONT 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: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: H. HUANG 30APR2015 CHK: L. ZHANG 30APR2015 APVD: J. GUO 30APR2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266772 SCALE: 1:2 SHEET: 2 of 4 REV: F		RESTRICTED TO:	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266772-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266772-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266772-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.95 mm [.037]	F
INSUL	1.10 mm [.043]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: ZE CONNETOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.10-2.10 mm [.083-.083 IN]		∅0.80-1.20 mm [.031-.047 IN]	
TERMINAL APPLICATION SPECIFICATION	SIZE-002T-P0.3 Rev 4/23/2015		
TERMINALS APPLIED <sup>5</sup>			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2113702-1	SIZE-002T-P0.3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>4</sup>
24 AWG	0.65 +/- 0.05 [.026 +/- .002]	5.7
26 AWG	0.60 +/- 0.05 [.024 +/- .002]	6.2
28 AWG	0.53 +/- 0.05 [.021 +/- .002]	7.1



- <sup>1</sup> RECOMMENDED SPARE PARTS
  - <sup>2</sup> REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
  - <sup>3</sup> APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
  - <sup>4</sup> 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.
  - <sup>5</sup> TERMINAL LUBRICANT IS RECOMMENDED.
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.

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	-	-	-

-	1	1	1803945-4	TONKER	300
-	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
<sup>3</sup>	-	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	-	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
<sup>5</sup>	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	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	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119943-1	WASHER, SPACER	69
-	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	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	2-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	2119791-5	DEPRESSOR, WIRE	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	2119533-4	STRIPPER, SIDE FEED	19
<sup>1</sup>	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
<sup>1</sup>	-	1	2119805-1	SHEAR HOLDER, FRONT	10
<sup>1</sup>	-	1	1803095-3	FLOATING SHEAR, FRONT	9
<sup>1</sup>	1	1	8-1803054-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-2	DEPRESSOR, SHEAR	5
-	1	1	3-238011-7	BLOCK, CRIMPER SPACER	4
<sup>1</sup>	1	1	8-1633962-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
<sup>1</sup>	1	1	6-1633713-2	CRIMPER, WIRE PREMIUM	1

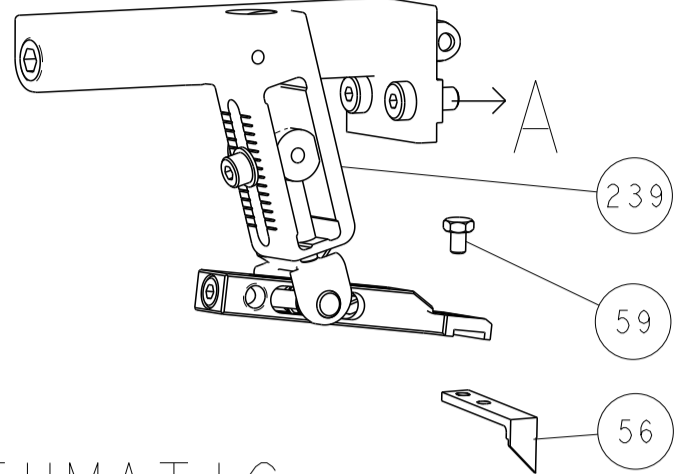
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			SCALE	
										1:2	

ITEM NO	DESCRIPTION	DATE	BY	CHK
-77-22-21	PART NO	30APR2015	H. HUANG	
	DESCRIPTION	30APR2015	L. ZHANG	
		30APR2015	J. GUO	

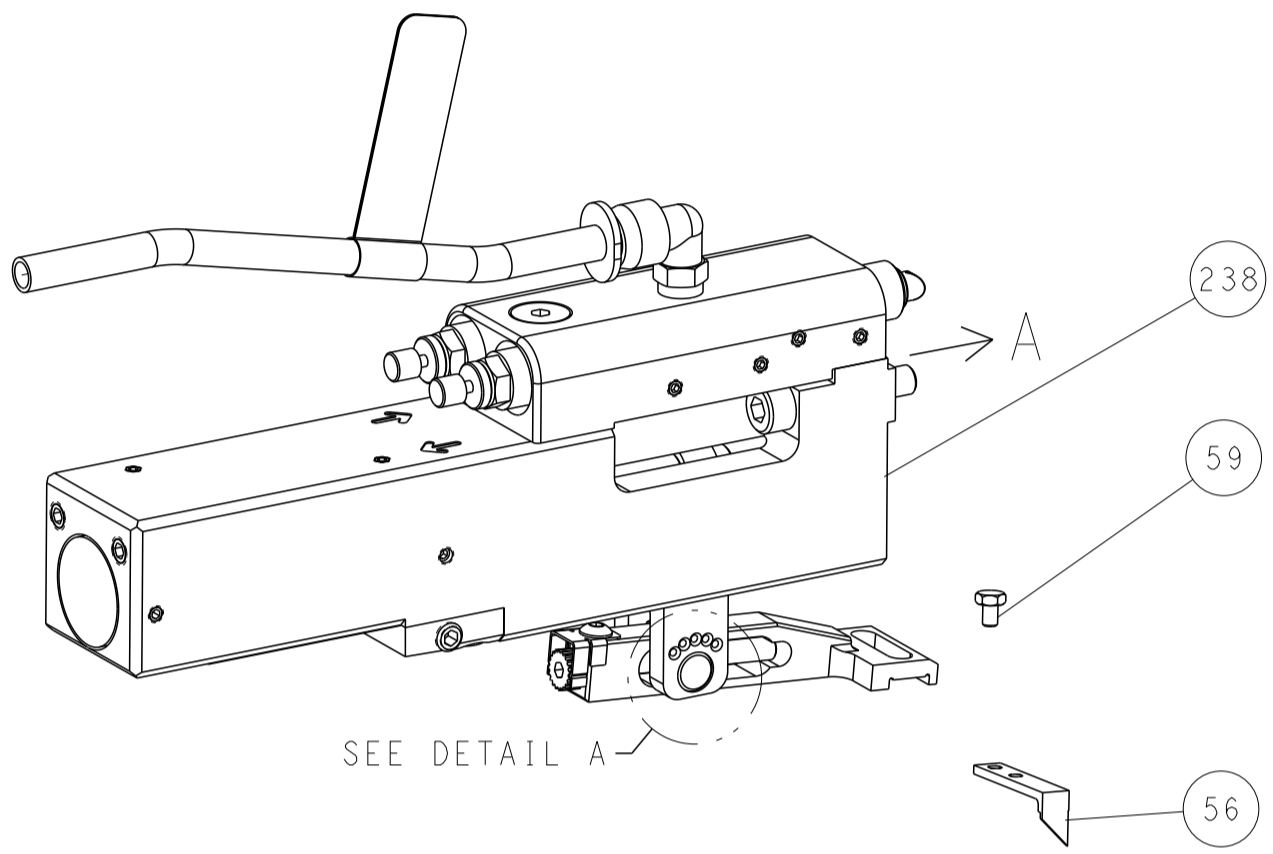
Customer Accessible Production Drawing	SCALE 1:2	SHEET 3 OF 4	REV F
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

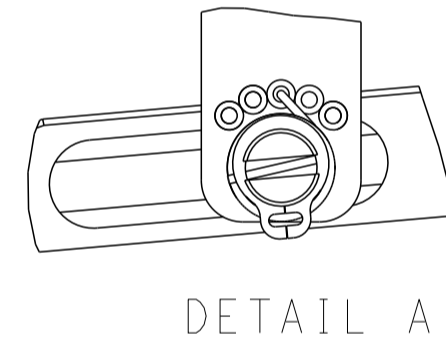
# FEED TYPE MECHANICAL



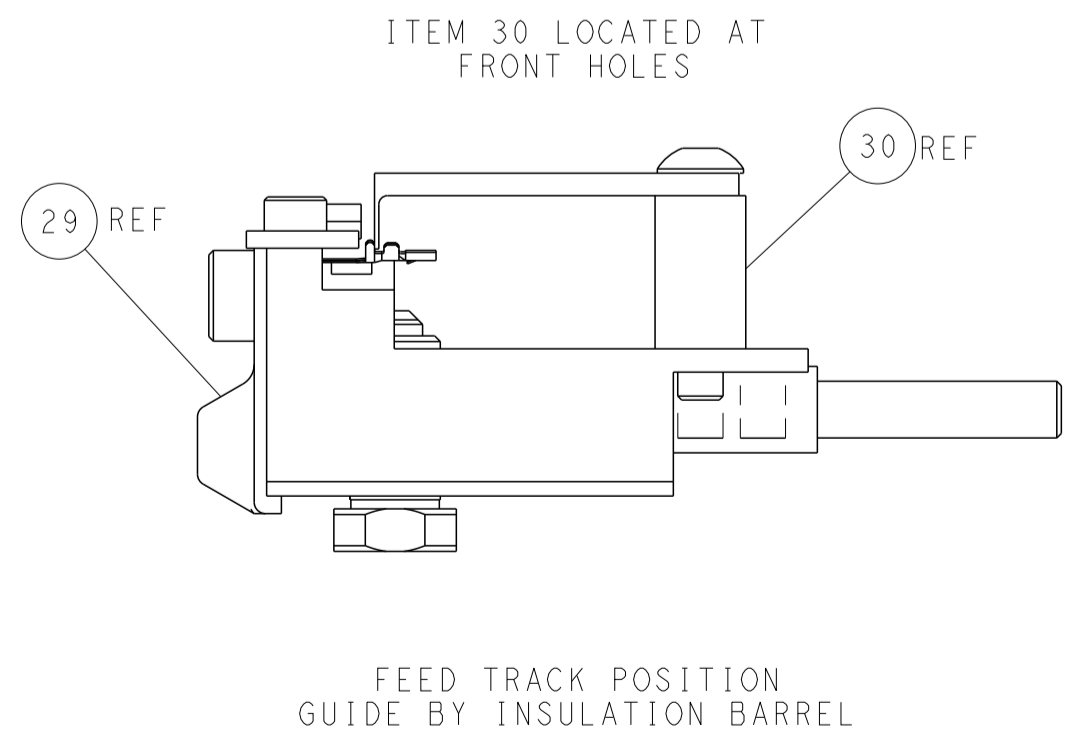
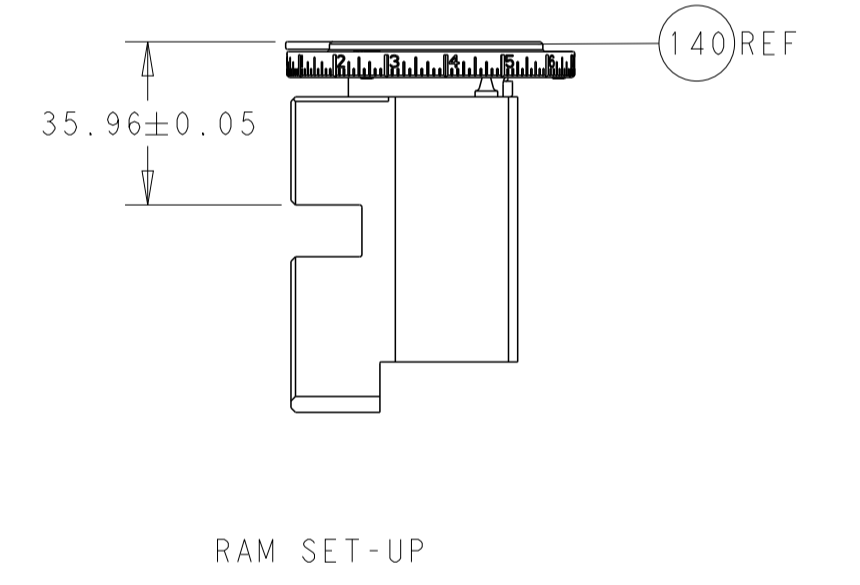
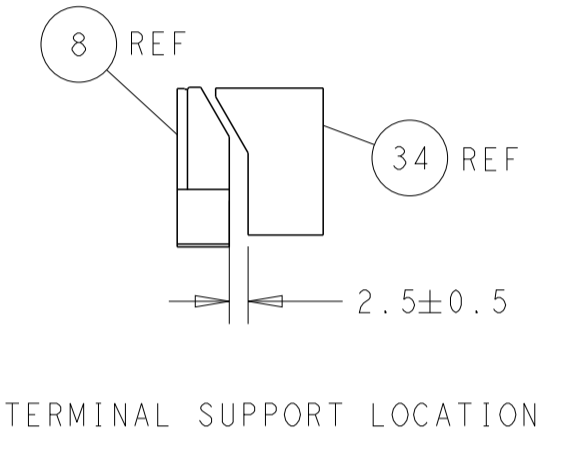
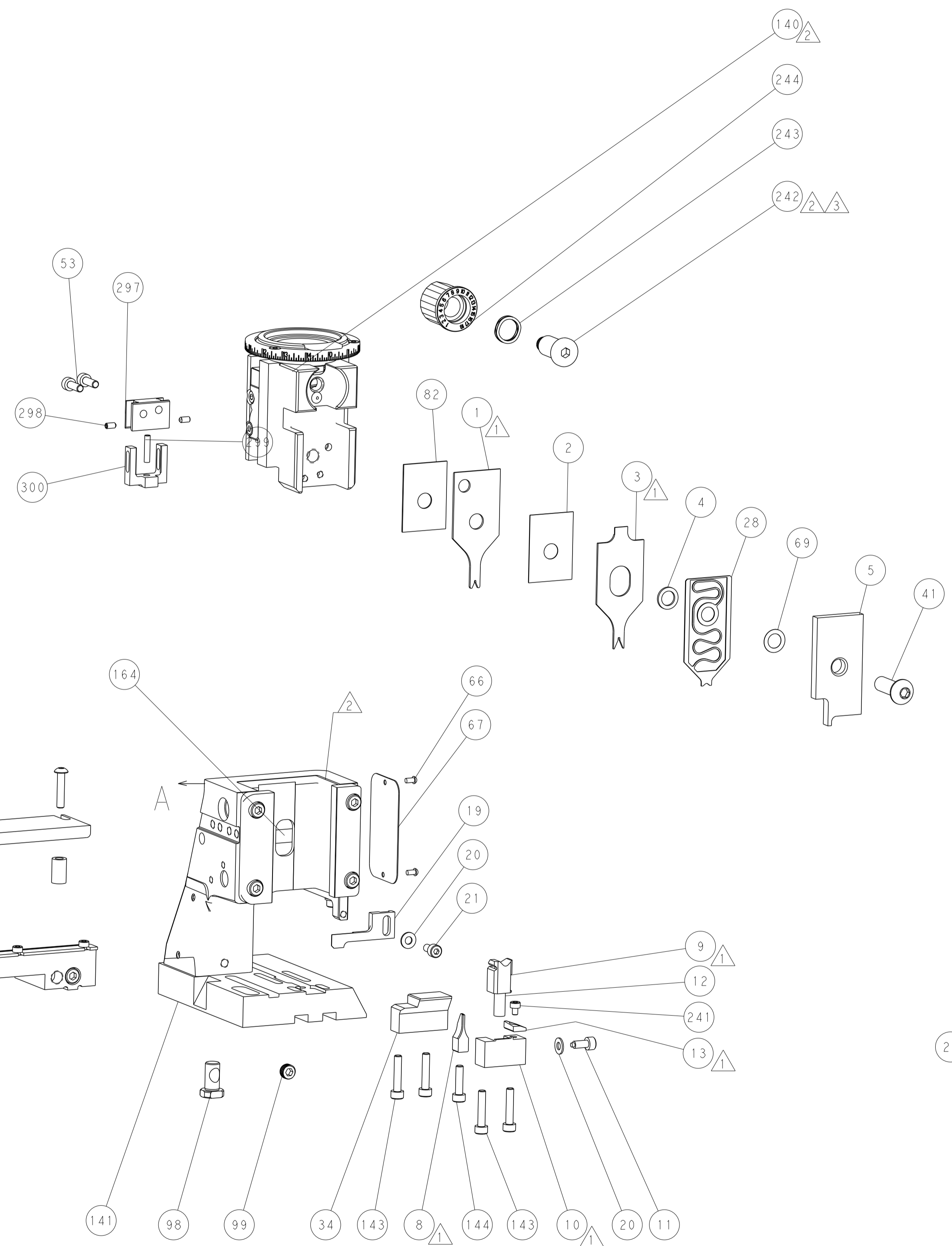
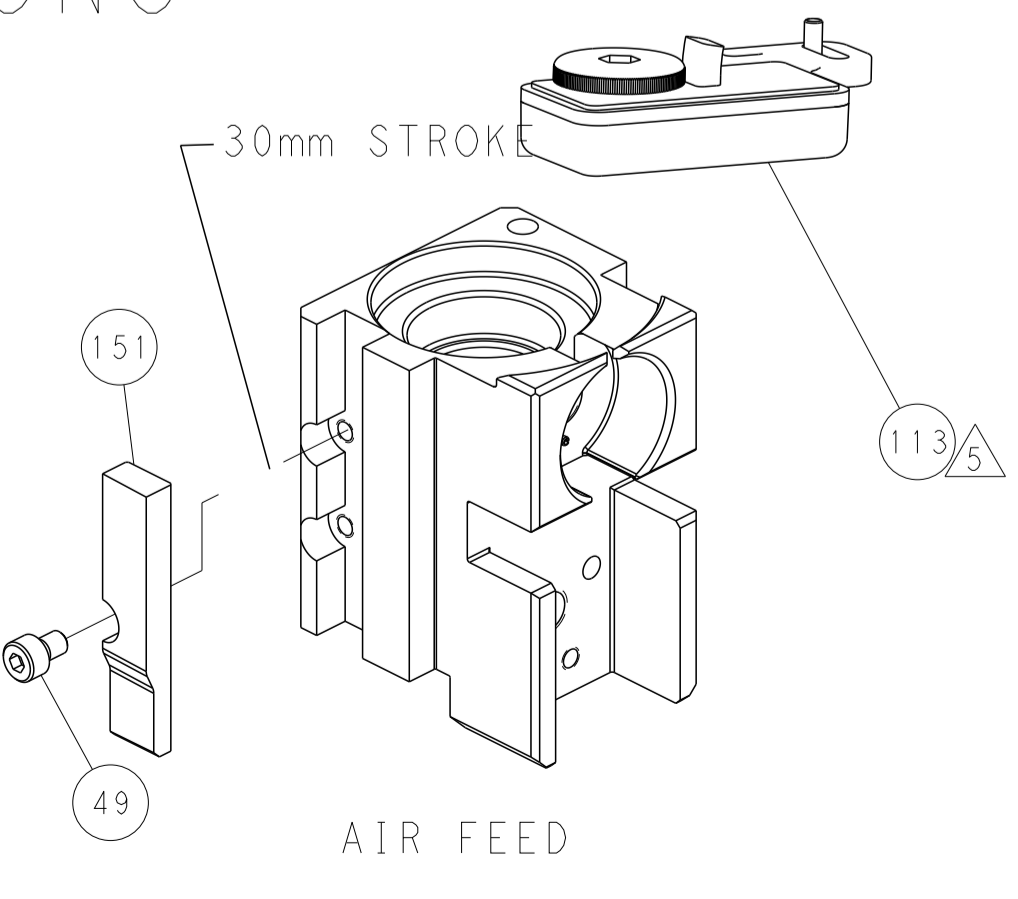
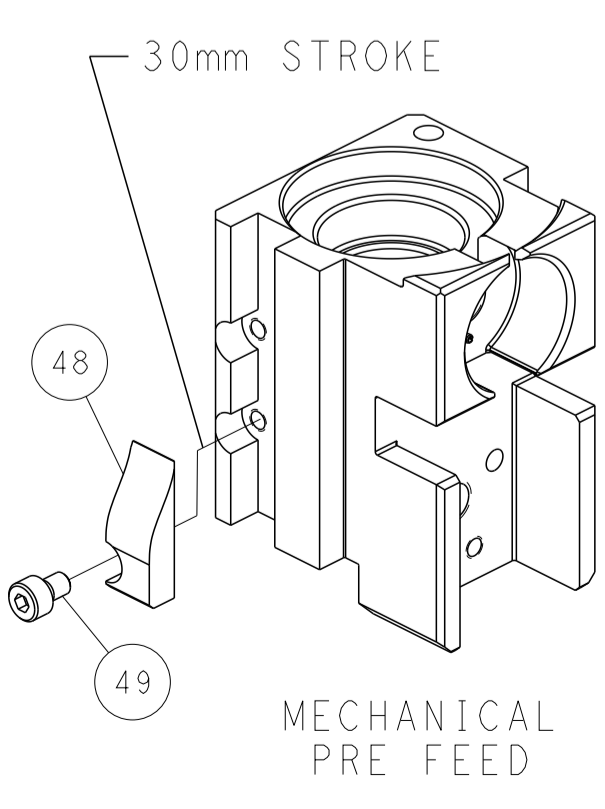
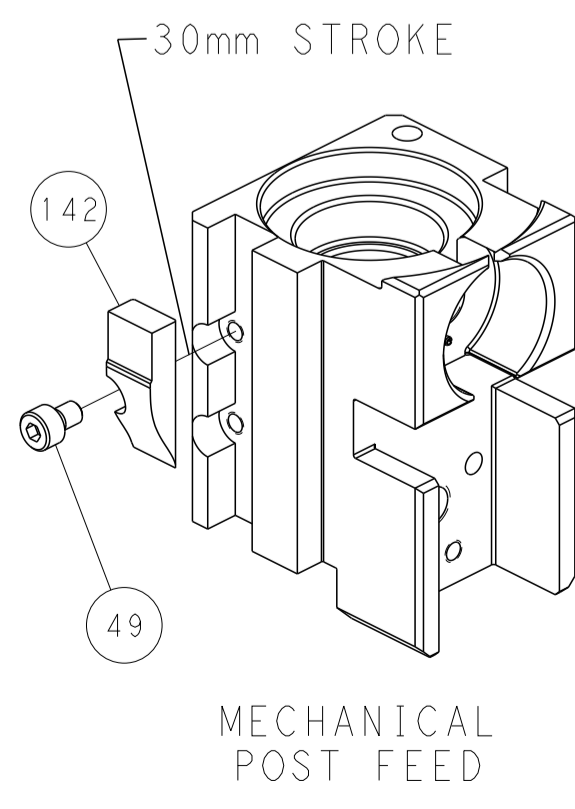
# PNEUMATIC



# 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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266772	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: F
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION