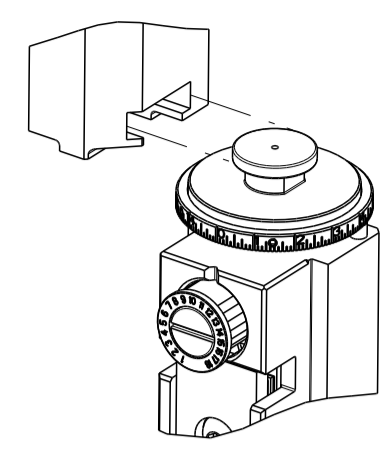


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266542-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266542-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266542-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266542-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266542-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.41 mm [.095]	F
INSUL	3.56 mm [.140]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: ITT TERMINAL ITT CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

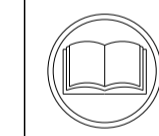
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.92-4.68 mm [.154-.184 IN]	∅

TERMINAL APPLICATION SPECIFICATION K121668-0222 Rev E

TERMINALS APPLIED

TE TERMINAL	ITT TERMINAL	TE SEAL	ITT SEAL	CABLE DIAMETER
2113606-1	121668-0222	2113388-1	121667-0023	∅1.9-2.1
2113606-2	121668-0202	2113388-2	121667-0022	∅1.4-2.0
2113606-3	121668-0272	2113388-3	121667-0024	∅1.2-1.6
2113606-4	121668-0121	963530-1		∅1.4-1.9
2113606-5	121668-0268			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.30 +/- 0.03 [.051 +/- .001]	5.8
1.00mm2	1.27 +/- 0.03 [.050 +/- .001]	6.4
0.75mm2	1.25 +/- 0.03 [.049 +/- .001]	6.5



- 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.
- 6 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 7 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.

***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	REV	DATE	BY	CHK	APPV
A	66	1	05NOV2014	JH	TE	UG
		A	16DEC2014	JH	TE	TE
		B	17JUN2021	MEH	TE	TE
		C	27JUL2021	JWC	TE	TE

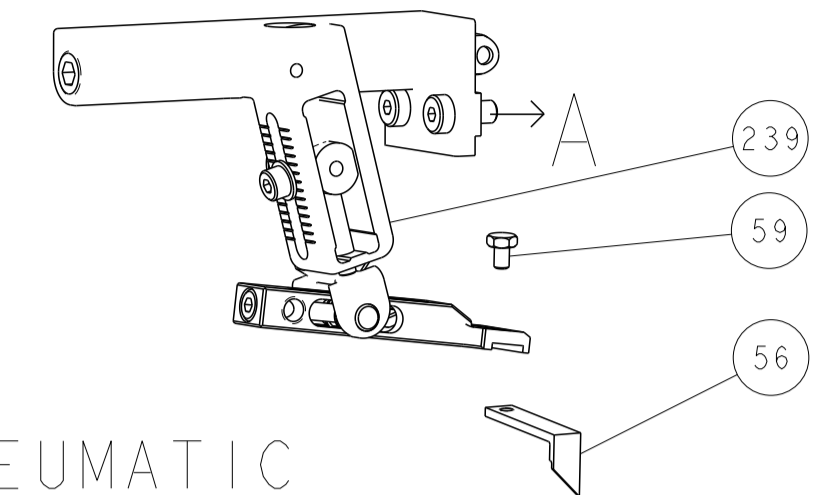
QTY	UNIT	DESCRIPTION	DATE	BY	CHK	APPV
-	1	2119641-1	FEED CAM, AIR FEED			248
-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
-	1	2119083-1	RETAINER, INSULATION DIAL			242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0			241
-	-	2119580-1	MECHANICAL FEED ASSEMBLY			239
-	1	2844940-1	AIR FEED MODULE			238
-	REF	994970-2	COUNTER, MAGNETIC			164
-	1	2844908-1	SCREW, LOCKING			99
-	1	2844907-1	POST, LOCKING			98
-	1	455888-7	SPACER, CRIMPER			82
-	1	1803607-3	DOCUMENTATION PACKAGE			71
-	1	2119740-1	TAG, IDENTIFICATION			67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			60
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0			59
-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0			57
-	1	1338683-8	FEED PAWL			56
-	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0			54
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10			53
-	1	1803382-6	HOLD DOWN, SPRING LOADED			50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0			49
-	-	2119652-1	FEED CAM, PRE FEED			48
-	-	2119653-1	FEED CAM, POST FEED			47
-	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF			46
-	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC			44
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)			41
-	1	3-1752356-3	SUPPORT, TERMINAL			34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)			33
-	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	2844992-1	ASSEMBLY, STRIP GUIDE			29
-	1	455888-3	SPACER, CRIMPER			28
-	1	1320928-6	STRIP GUIDE			24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	2	1-18028-2	WASHER, FLAT, REG M4			20
-	1	2119533-1	STRIPPER, SIDE FEED			19
-	1	2119806-1	INSERT, SHEAR			13
-	1	3-22280-3	SPRING, COMPRESSION			12
-	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10			11
-	1	2119805-1	SHEAR HOLDER, FRONT			10
-	1	318707-1	FLOATING SHEAR, FRONT			9
-	1	3-1803056-0	ANVIL, COMBINATION			8
-	-	-	-			7
-	-	-	-			6
-	1	2119781-1	DEPRESSOR, SHEAR			5
-	1	238011-4	BLOCK, CRIMPER SPACER			4
-	1	1803018-8	CRIMPER, INSULATION O			3
-	1	455888-9	SPACER, CRIMPER			2
-	1	1803188-7	CRIMPER, WIRE			1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	BY	CHK	APPV
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	05NOV2014	J.YIN	G.BAILEY	J.GUO
MATERIAL:	FINISH:	WEIGHT:	Customer Accessible Production Drawing		

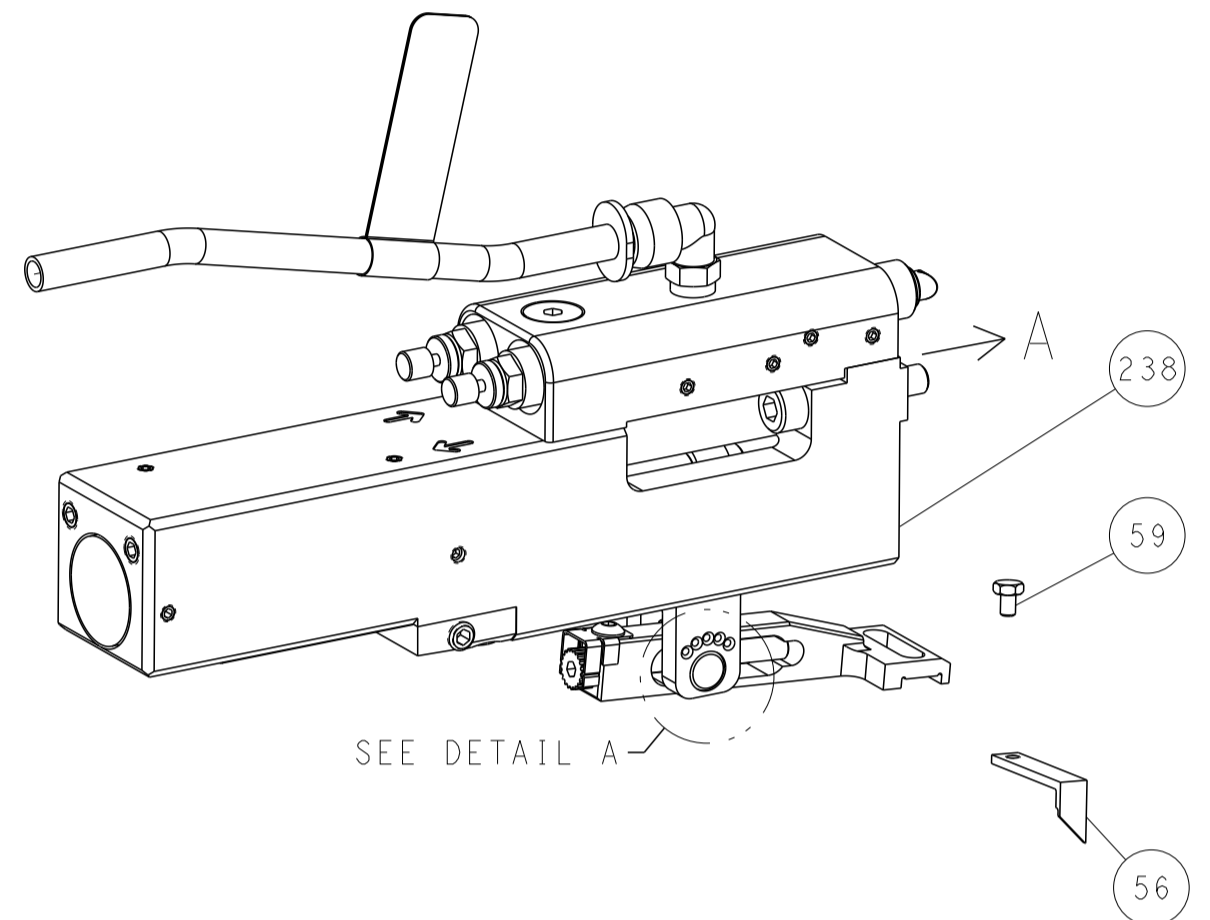
NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Ocean Side Feed Applicator	A1	00779	2266542	-

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

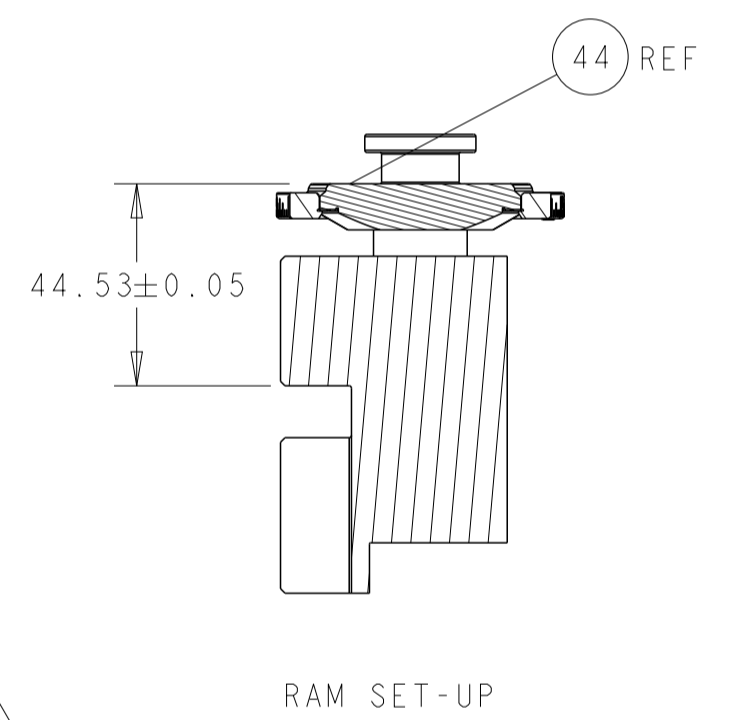
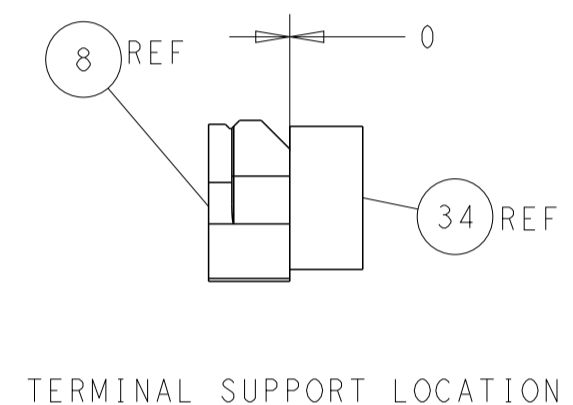
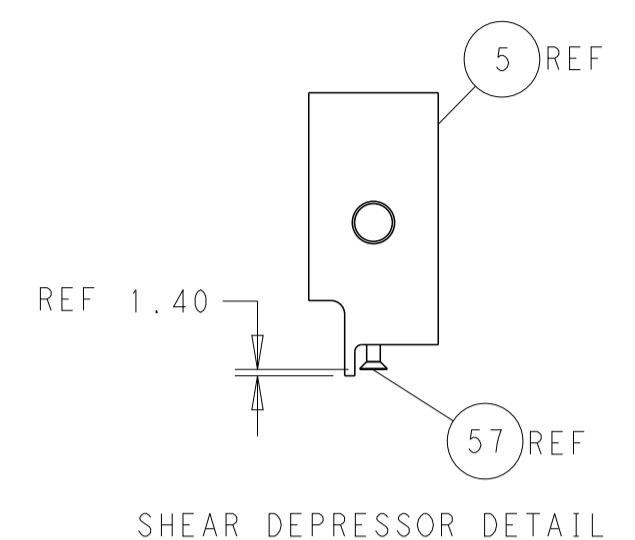
FEED TYPE MECHANICAL



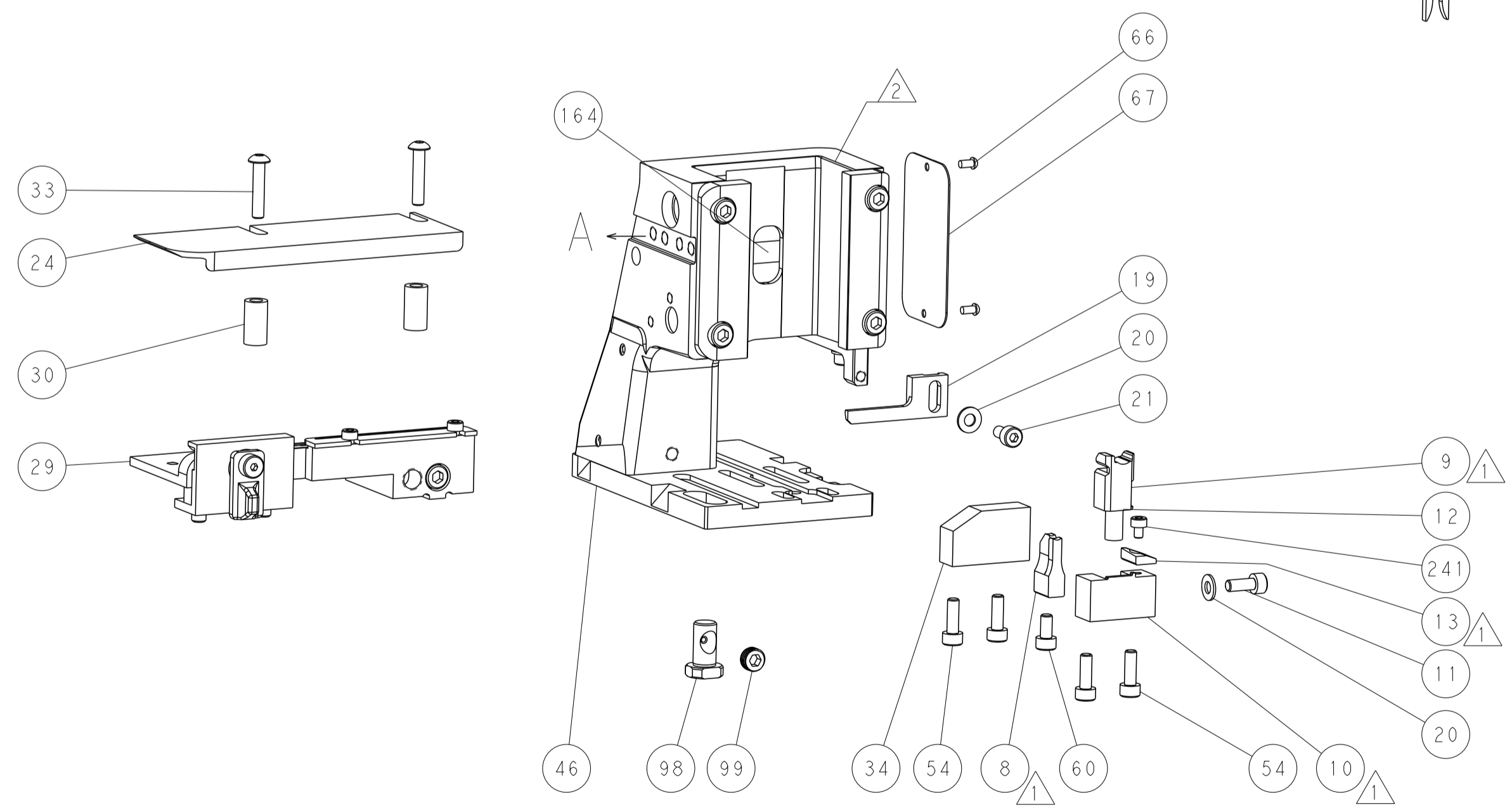
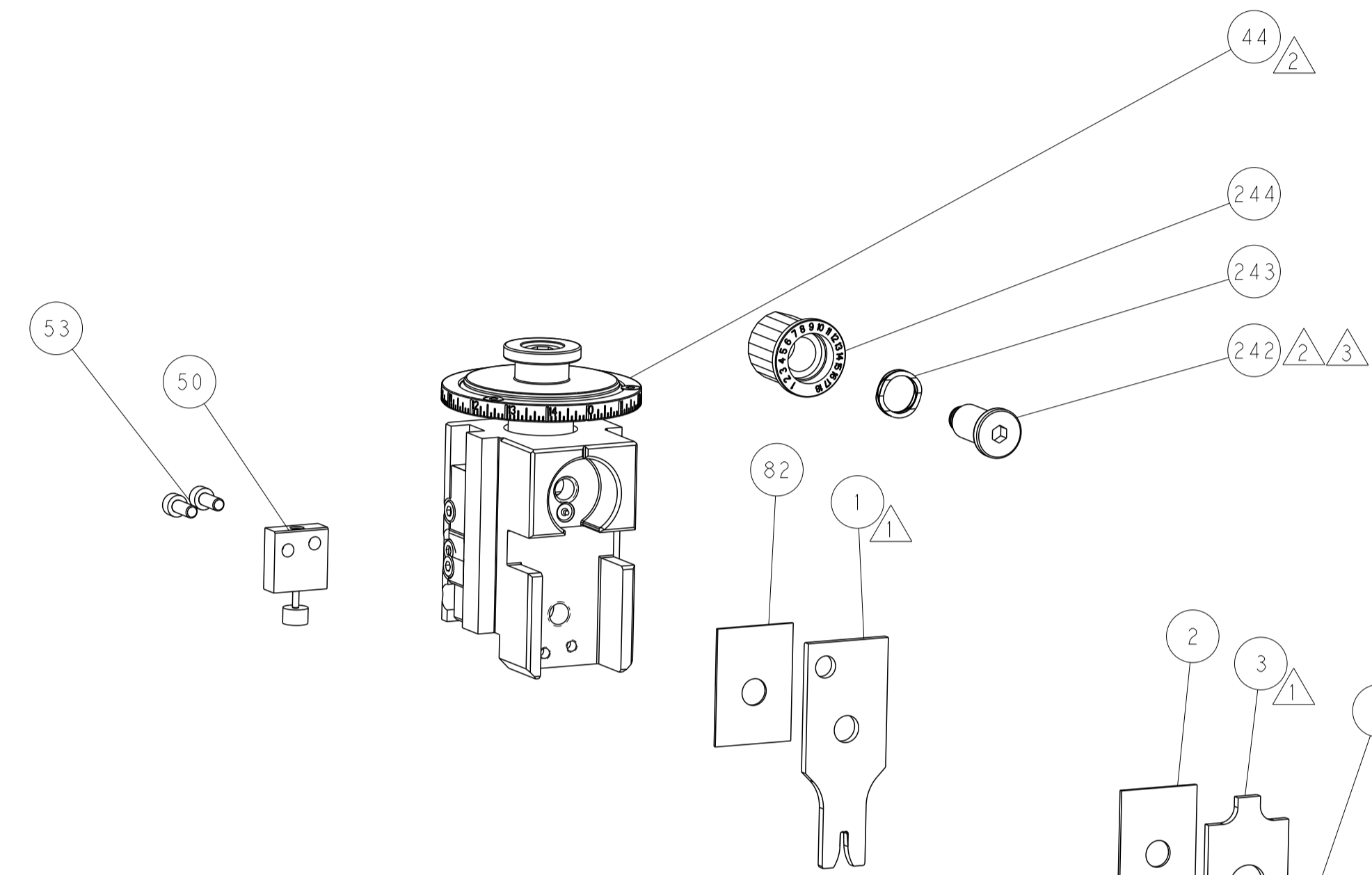
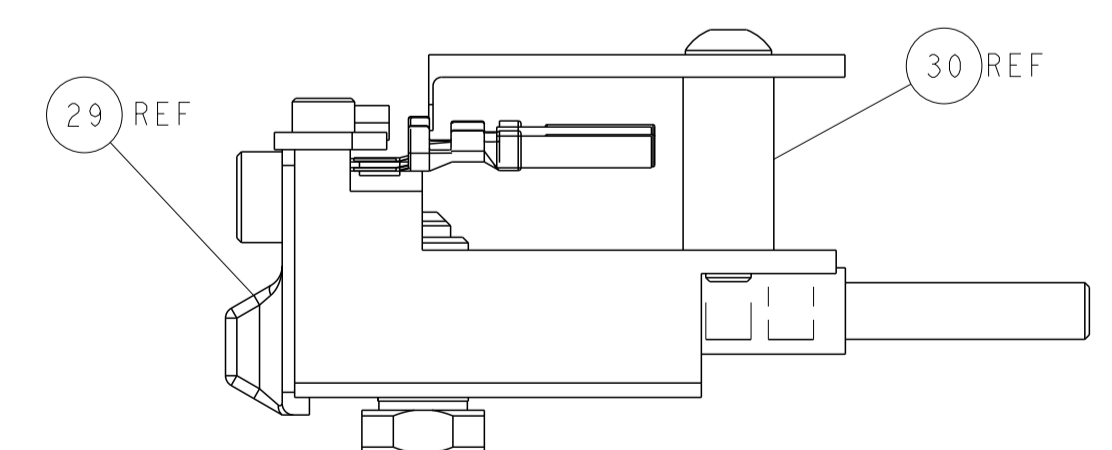
PNEUMATIC



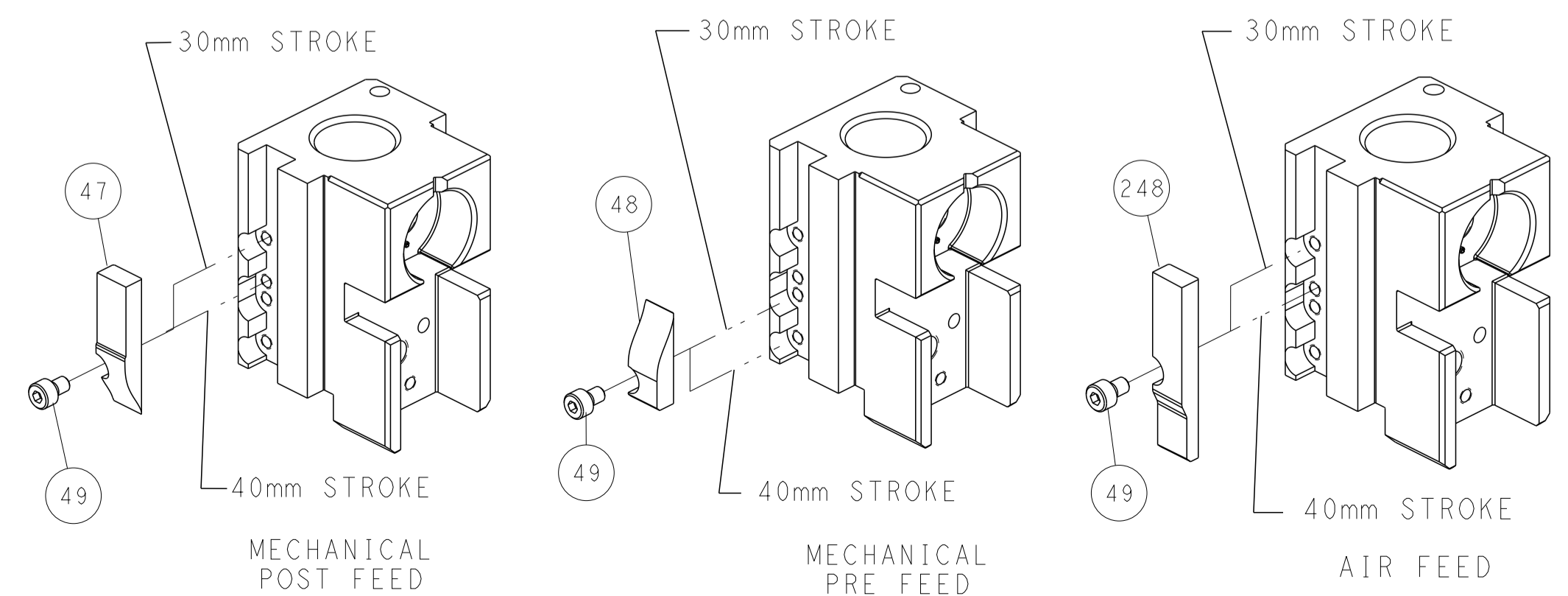
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: Y. YIN 05NOV2014 CHK: G. BAILEY 05NOV2014 APVD: J. GUO 05NOV2014	TE Connectivity Harrisburg, PA 17105-3608
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: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2266542 RESTRICTED TO: -
MATERIAL: -		SCALE: 1:2 SHEET: 2 of 4 REV: C	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266542-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266542-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266542-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.41 mm [.095]	F
INSUL	3.56 mm [1.40]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: ITT TERMINAL		ITT CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.92-4.68 mm [1.54-.184 IN]	Ø 1.6-2.1		
TERMINAL APPLICATION SPECIFICATION: K121668-0222 Rev E			
TERMINALS APPLIED			
TE TERMINAL	ITT TERMINAL	TE SEAL	ITT SEAL
2113606-1	121668-0222	2113388-1	121667-0023
2113606-2	121668-0202	2113388-2	121667-0022
2113606-3	121668-0272	2113388-3	121667-0024
2113606-4	121668-0121	963530-1	
2113606-5	121668-0268		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm ²	1.30 +/- 0.03 [1.051 +/- .001]	5.8
1.00mm ²	1.27 +/- 0.03 [1.050 +/- .001]	6.4
0.75mm ²	1.25 +/- 0.03 [1.049 +/- .001]	6.5

- 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.
- 6 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 7 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL NOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

***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	APPD
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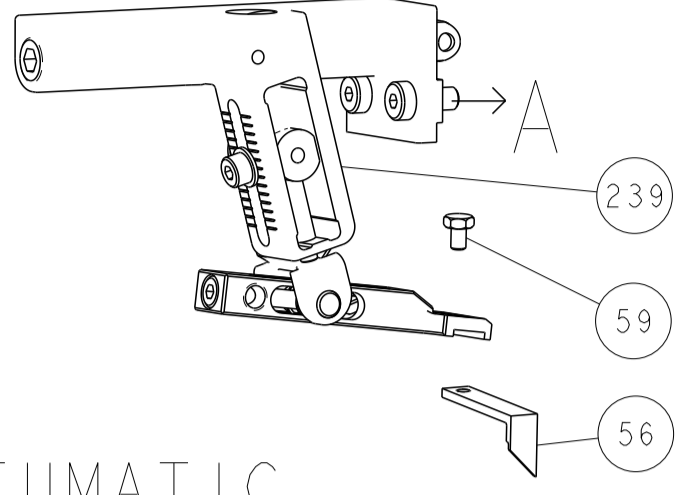
REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-	1	1		2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1		2119083-1 RETAINER, INSULATION DIAL	242
-	1	1		7-18023-7 SCR, SKT HD CAP M3 X 4.0	241
-	-	1		2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1	-		2844940-1 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		455888-7 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
-	1	1		985575-3 SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1		1338683-8 FEED PAWL	56
-	2	2		1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1		1803382-6 HOLD DOWN, SPRING LOADED	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		3-1752356-3 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		3-2844962-0 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		1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	11
-	1	1		2119805-1 SHEAR HOLDER, FRONT	10
-	1	1		318707-1 FLOATING SHEAR, FRONT	9
-	1	1		3-1803056-0 ANVIL, COMBINATION	8
-	-	-		-	7
-	-	-		-	6
-	1	1		2119781-1 DEPRESSOR, SHEAR	5
-	1	1		238011-4 BLOCK, CRIMPER SPACER	4
-	1	1		1803018-8 CRIMPER, INSULATION O	3
-	1	1		455888-9 SPACER, CRIMPER	2
-	1	1		1803188-7 CRIMPER, WIRE	1

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

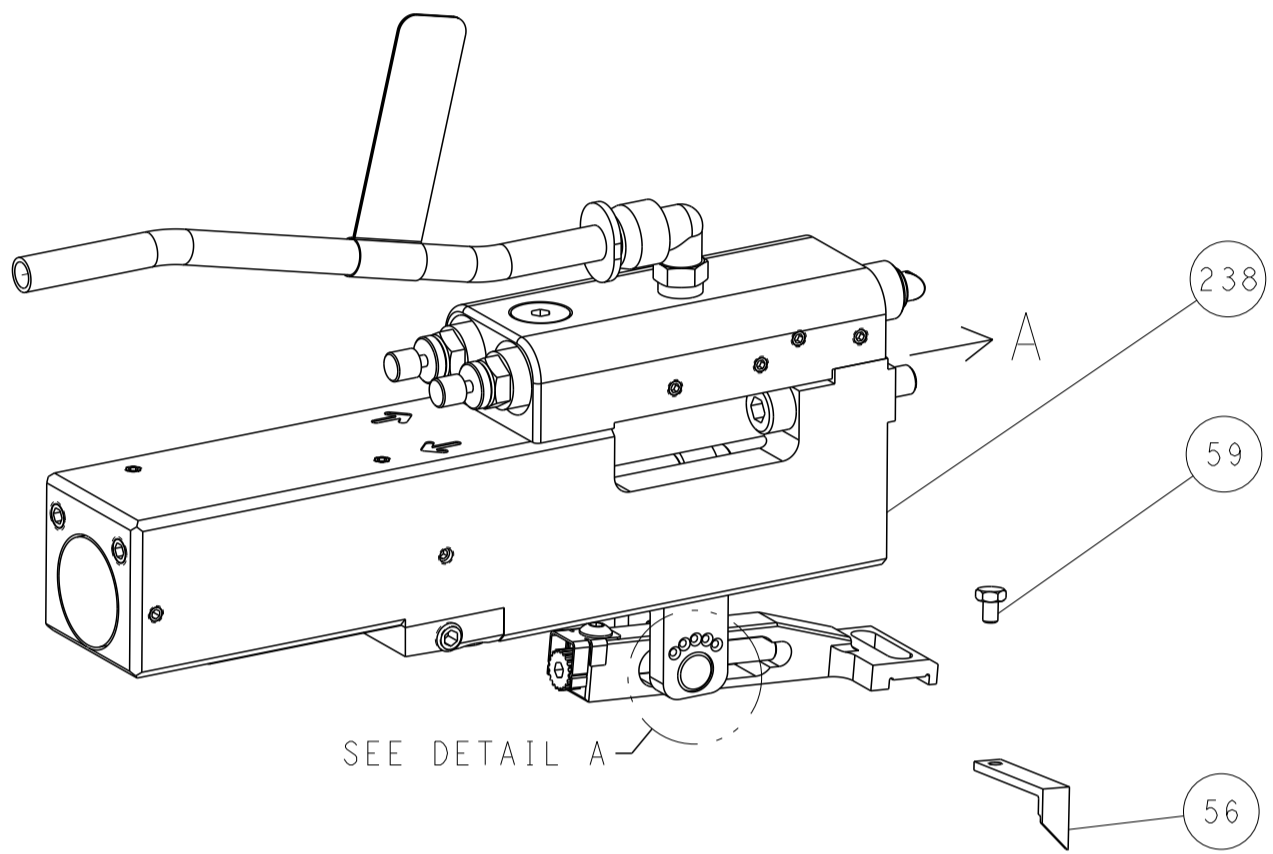
<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCOO ELECTRONICS CORPORATION. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. PERMISSION TO REPRODUCE THIS DRAWING FOR THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: Y. YIN 05NOV2014 CHK: G. BAILEY 05NOV2014 APVD: J. GUO 05NOV2014	STE TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266542 RESTRICTED TO: C
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 3 OF 4 REV: C

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

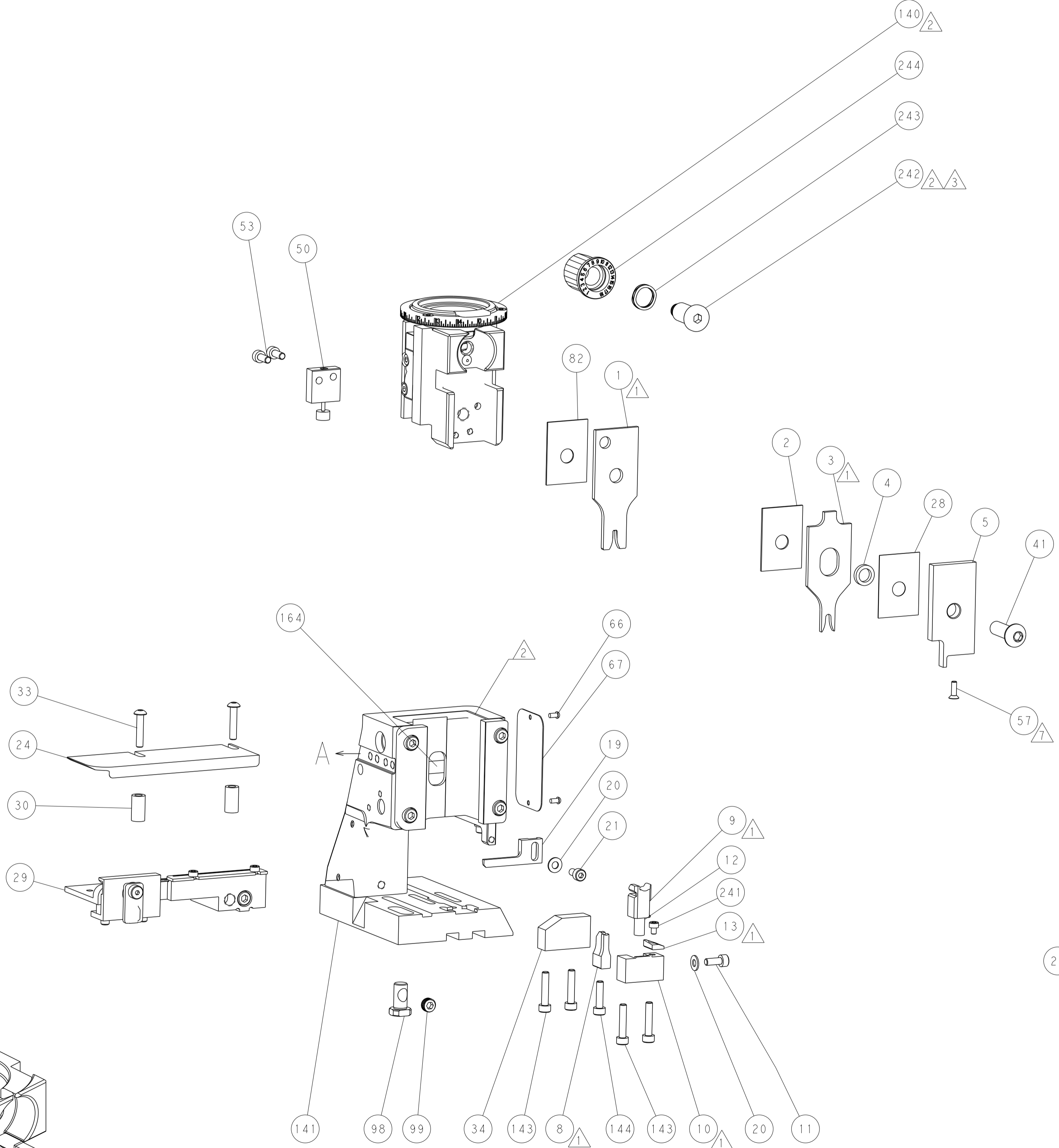
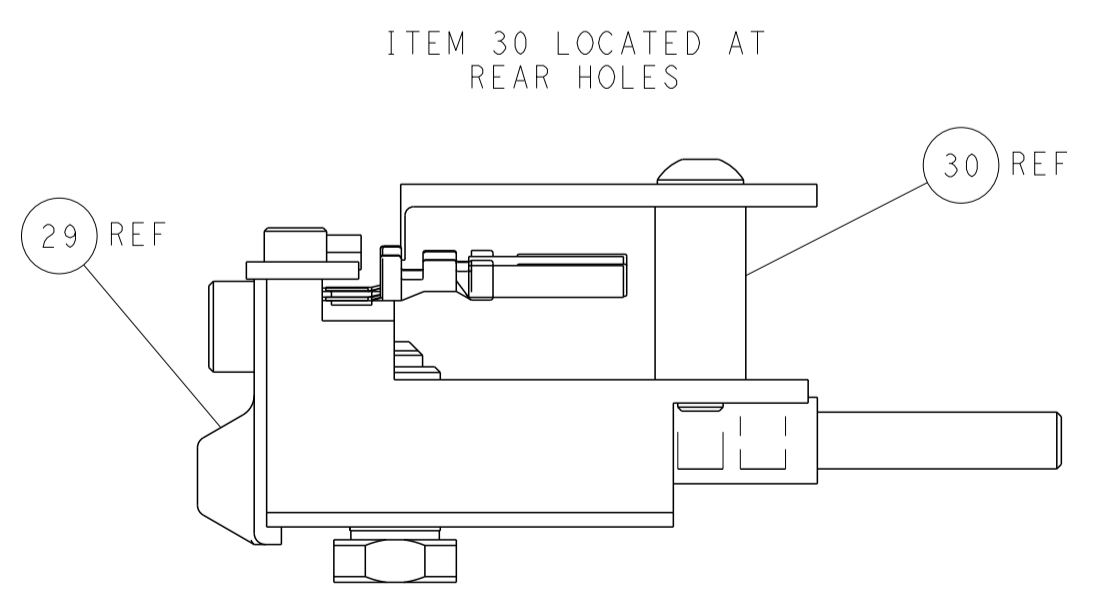
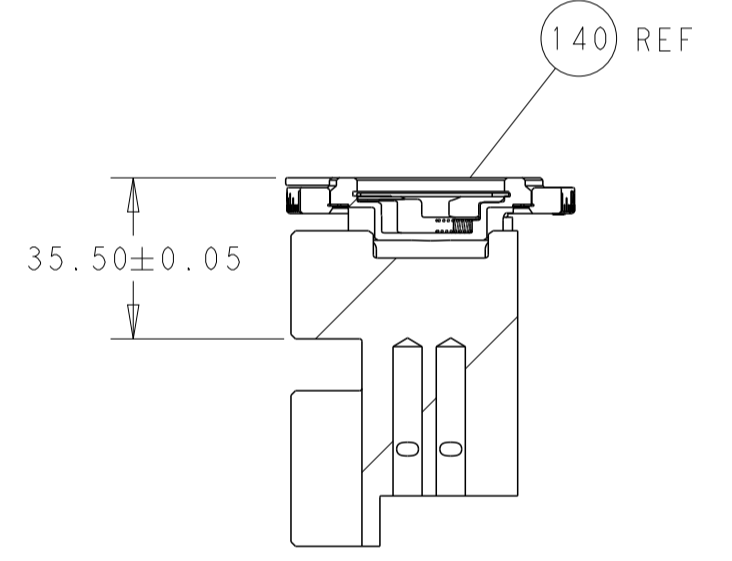
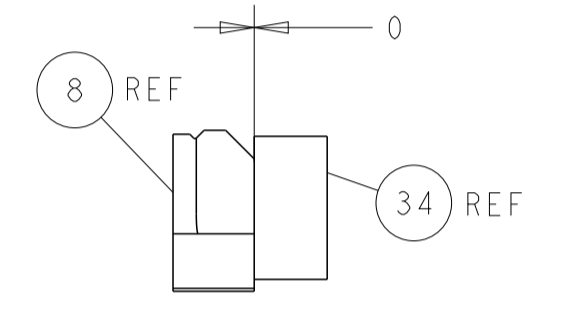
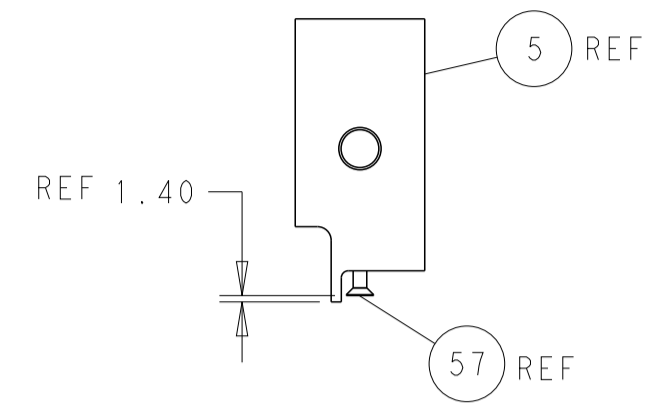
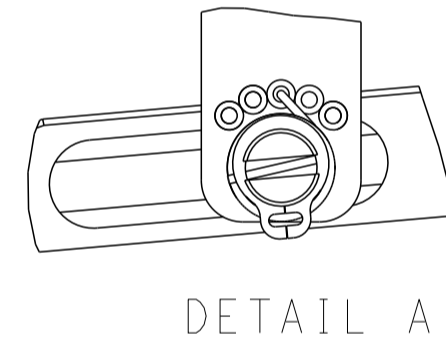
FEED TYPE MECHANICAL



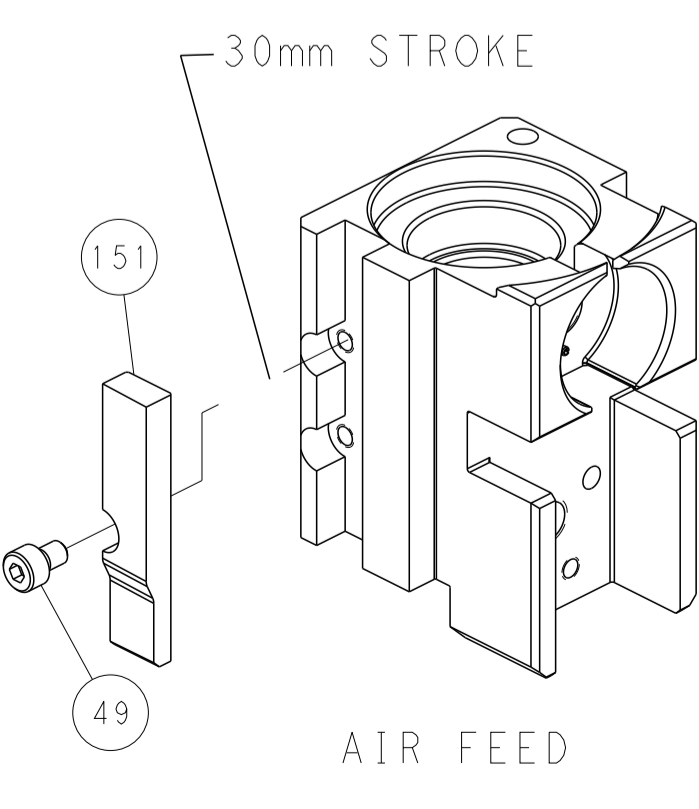
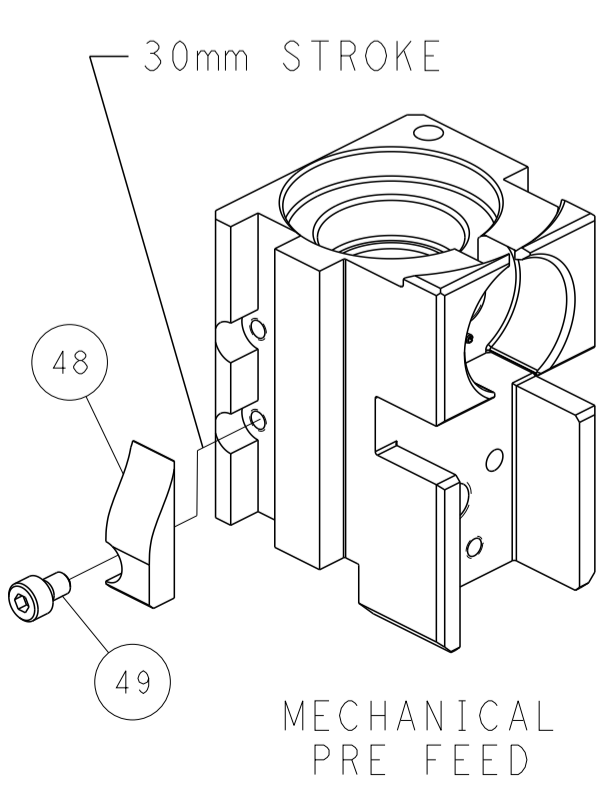
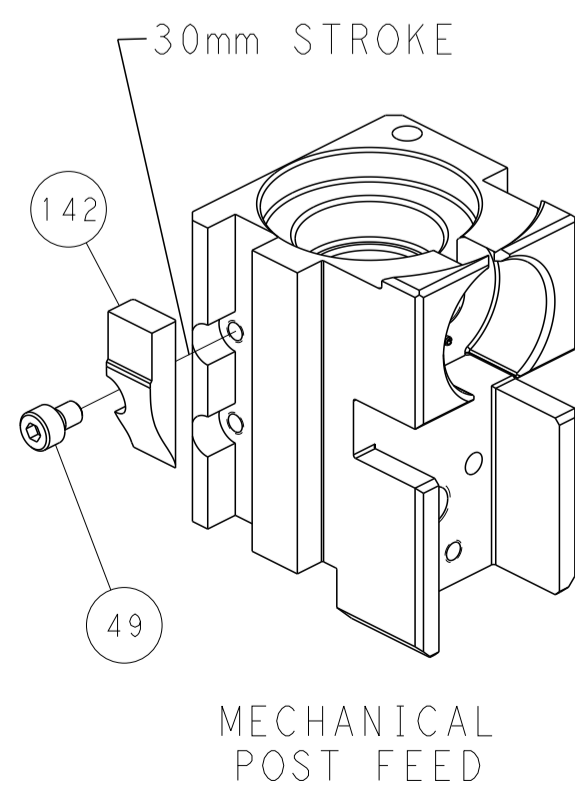
PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 05NOV2014		CHK: G. BAILEY 05NOV2014		APVD: H. GUO 05NOV2014		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: C=2266542	RESTRICTED TO: -
MATERIAL:		WEIGHT:		SCALE: 1:2	SHEET: 4	OF: 4	REV: C	Customer Accessible Production Drawing			