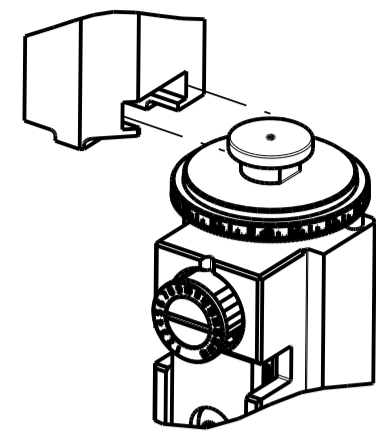


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266158-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266158-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266158-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266158-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266158-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.70 mm [.185]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: LANGUETTE 6.3mm			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.56-3.99 mm [.140-.157 IN]		Ø2.80-4.40 mm [.110-.173 IN]	
TERMINAL APPLICATION SPECIFICATION	2252 C 001		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544218-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.65 +/- 0.05 [.104 +/- .002]	4.0
5.00mm2	2.50 +/- 0.05 [.098 +/- .002]	6.3
4.00mm2	2.35 +/- 0.05 [.093 +/- .002]	7.5
3.00mm2	2.25 +/- 0.05 [.089 +/- .002]	8.6

- 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. TERMINAL LUBRICANT IS RECOMMENDED.

***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	REV	DATE	BY	CHKD
		B	18MAY2018	VLA	JDG
		C	07SEP2018	KH	GB
		D	17APR2021	TB	RK
		E	12MAY2021	FJ	RK

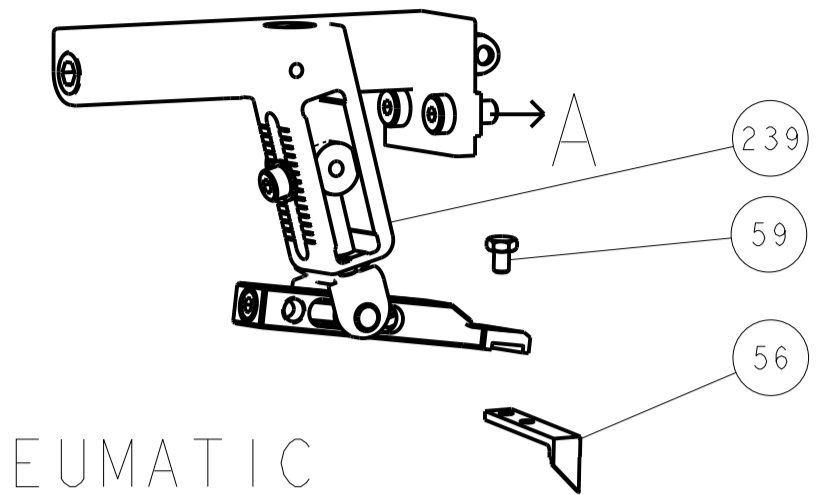
QTY	DESCRIPTION	DATE	BY	CHKD
- 2	2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0			269
- 1	1633782-3 FENCE			267
- 1	1803078-3 SPACER, PRECISION			259
- 1	2119641-1 FEED CAM, AIR FEED			248
- 1	2119082-7 CAM, SNAIL, INSULATION ADJUSTMENT			244
- 1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST			243
- 1	2119083-1 RETAINER, INSULATION DIAL			242
- 1	7-18023-7 SCR, SKT HD CAP M3 X 4.0			241
- 1	2119580-1 MECHANICAL FEED ASSEMBLY			239
- 1	2844940-1 AIR FEED MODULE			238
- REF	994970-2 COUNTER, MAGNETIC			164
- 1	455888-5 SPACER, CRIMPER			120
- 1	1-18028-2 WASHER, FLAT, REG M4			119
- 1	2119955-1 ASSY, LUBRICATOR, SIDE FEED			113
- 1	2844908-1 SCREW, LOCKING			99
- 1	2844907-1 POST, LOCKING			98
- 1	1-690438-0 FRONT STRIP GUIDE			96
- 2	2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0			95
- 1	1-455888-8 SPACER, CRIMPER			82
- 2	2079383-4 SCR, BHSC, RoHS (M4 X 8)			79
- 1	1803096-1 EXTENSION PLATE			78
- 1	1803607-3 DOCUMENTATION PACKAGE			71
- 1	2119791-9 DEPRESSOR, WIRE			70
- 1	2119943-1 WASHER, SPACER			69
- 1	2119740-1 TAG, IDENTIFICATION			67
- 2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188			66
- 2	2-18032-5 SCR, SET, FLT PNT, M5 X 20.0			61
- 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	1338685-1 PAWL, FEED			56
- 4	2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0			54
- 2	2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0			53
- 1	5018030-1 NUT, HEX, REG, RoHS, M3			52
- 1	811242-5 BUMPER, HOLD DOWN			51
- 1	690753-2 SPACER, TONKER			50
- 1	18023-9 SCR, SKT HD CAP M4 X 6.0			49
- 1	2119652-1 FEED CAM, PRE FEED			48
- 1	2119653-1 FEED CAM, POST FEED			47
- 1	1803583-9 APPLICATOR BASIC ASSEMBLY, SF			46
- 1	1803515-2 RAM ASSEMBLY, SF ATLANTIC			44
- 1	1803602-2 SCR, BHSC, RoHS (M8 X 40)			41
- 1	1752356-1 SUPPORT, TERMINAL			34
- 2	2079383-8 SCR, BHSC, RoHS (M4 X 16)			33
- 2	2-2844962-3 SPACER, CYLINDRICAL, STRIP GUIDE			30
- 1	2844992-3 ASSEMBLY, STRIP GUIDE			29
- 1	455888-3 SPACER, CRIMPER			28
- 2	22283-1 SPRING, COMPRESSION			27
- 1	356835-1 LEVER, DRAG RELEASE			26
- 1	240792-1 DRAG, TERMINAL			25
- 1	1320928-4 STRIP GUIDE			24
- 1	980371-4 SCR, SKT HD SHLDR 5.0 DIA X 6.0			23
- 1	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0			21
- 1	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	1-356885-4 STOP, SHEAR			11
- 1	2119805-1 SHEAR HOLDER, FRONT			10
- 1	454276-5 FLOATING SHEAR, FRONT			9
- 1	1633926-5 ANVIL, COMBINATION			8
- 1	1-240641-7 SPACER			7
- 1	1-2119757-0 DEPRESSOR, SHEAR			5
- 1	238011-1 BLOCK, CRIMPER SPACER			4
- 1	6-1633964-9 CRIMPER, INSULATION OVERLAP PREMIUM			3
- 1	455888-5 SPACER, CRIMPER			2
- 1	3-456411-1 CRIMPER, WIRE PREMIUM			1

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

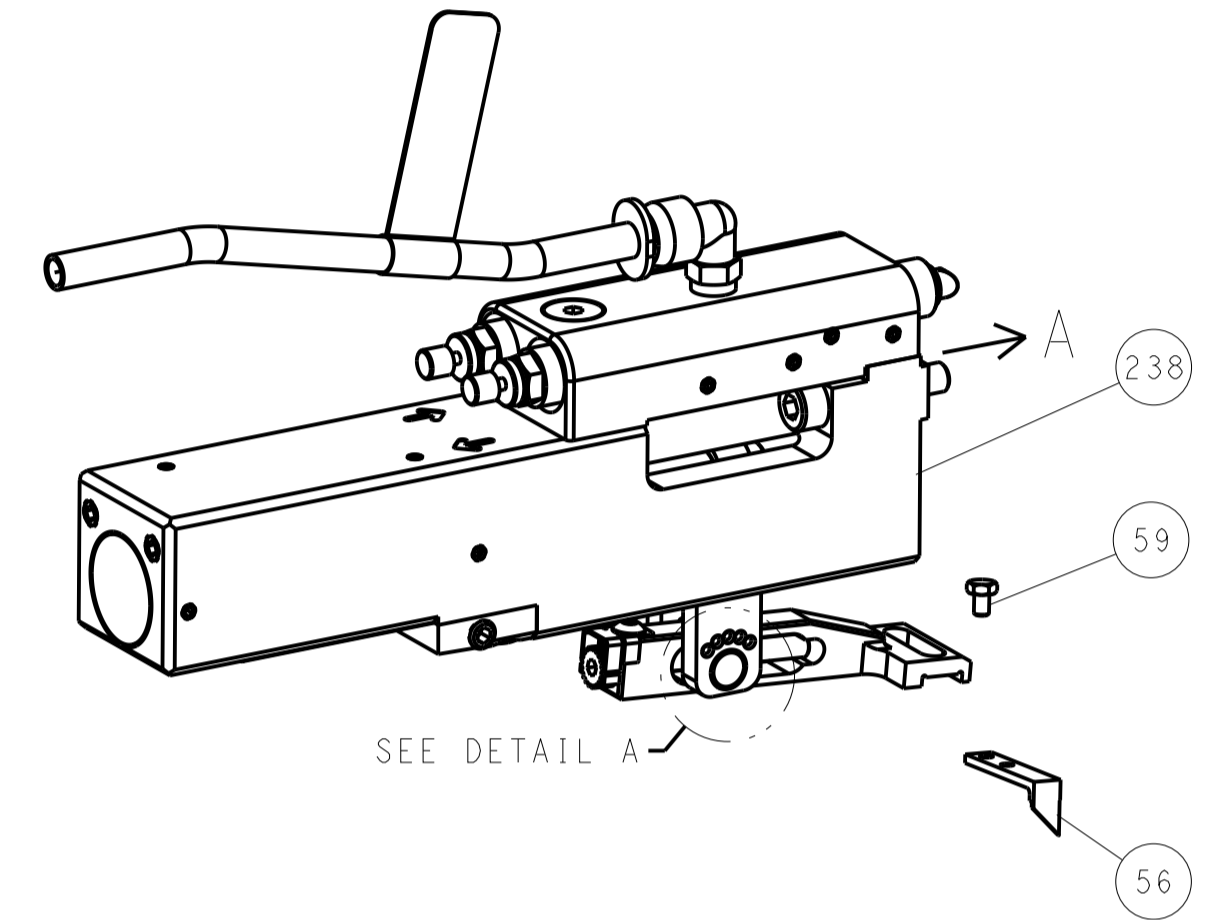
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DATE	20NOV2013	CHKD	T. ELBIN
DATE	20NOV2013	APVD	L. ZHANG
PRODUCT SPEC	-		
APPLICATION SPEC	-		
SIZE	A1	CAGE CODE	00779
DRAWING NO	2266158		
RESTRICTED TO	-		
Customer Accessible Production Drawing	SCALE	1:2	SHEET 1 OF 4

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

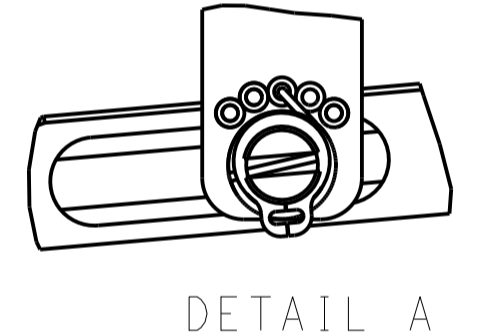
FEED TYPE MECHANICAL



PNEUMATIC

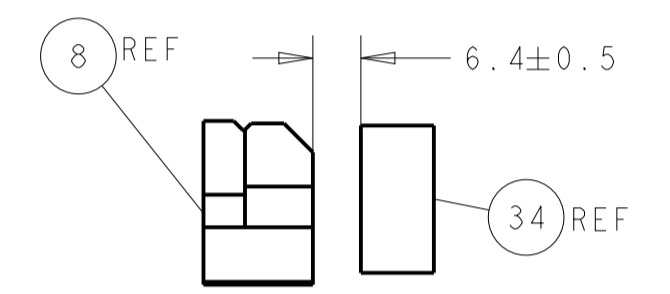
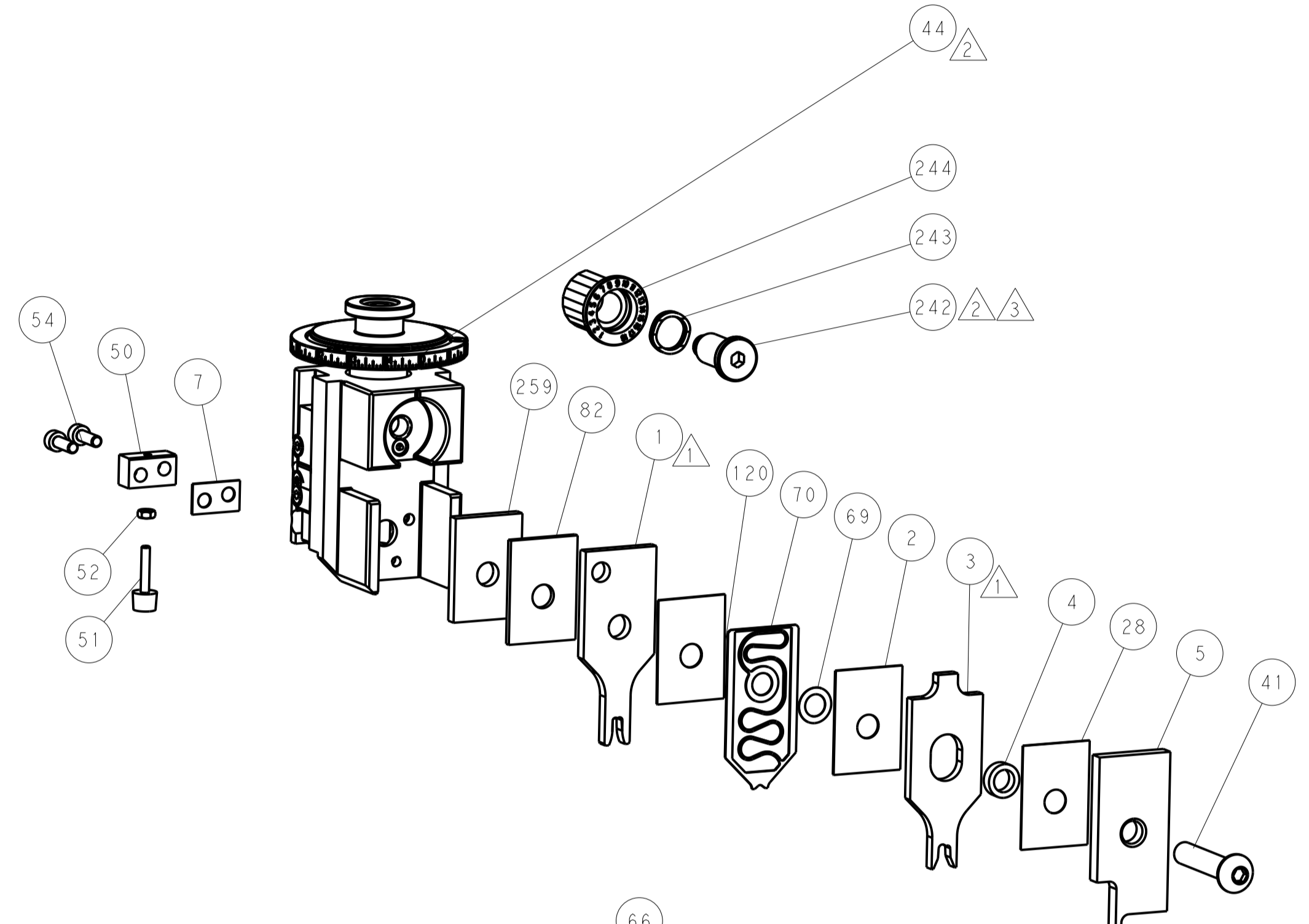
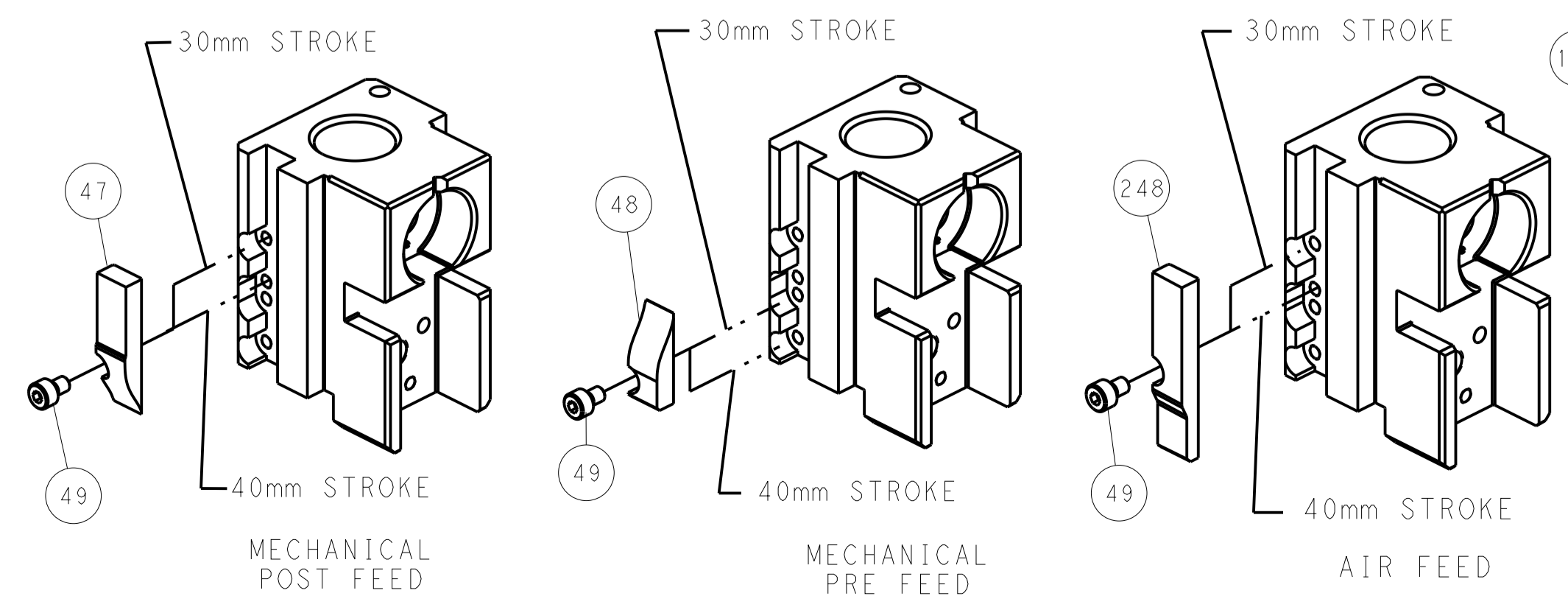


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

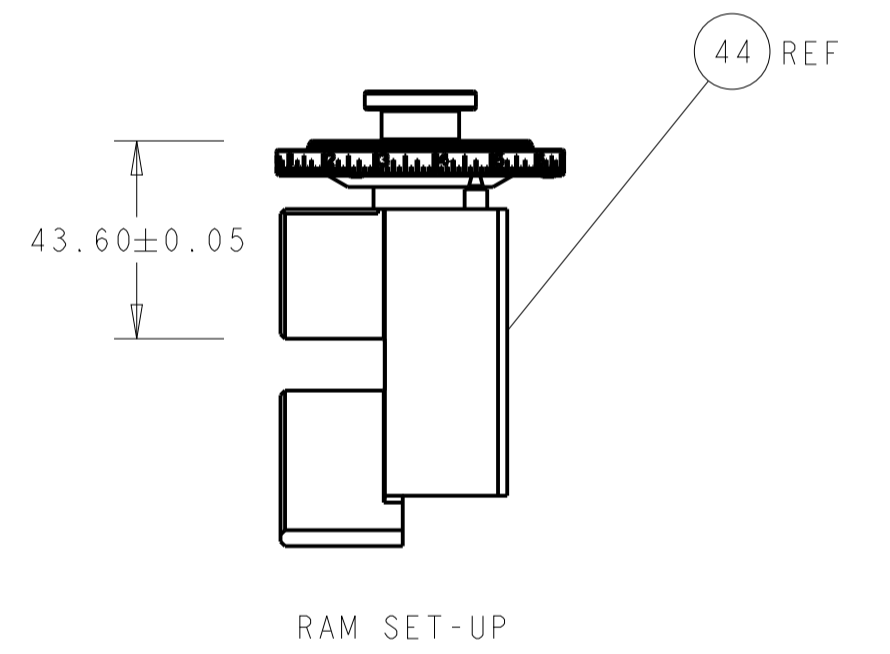


DETAIL A

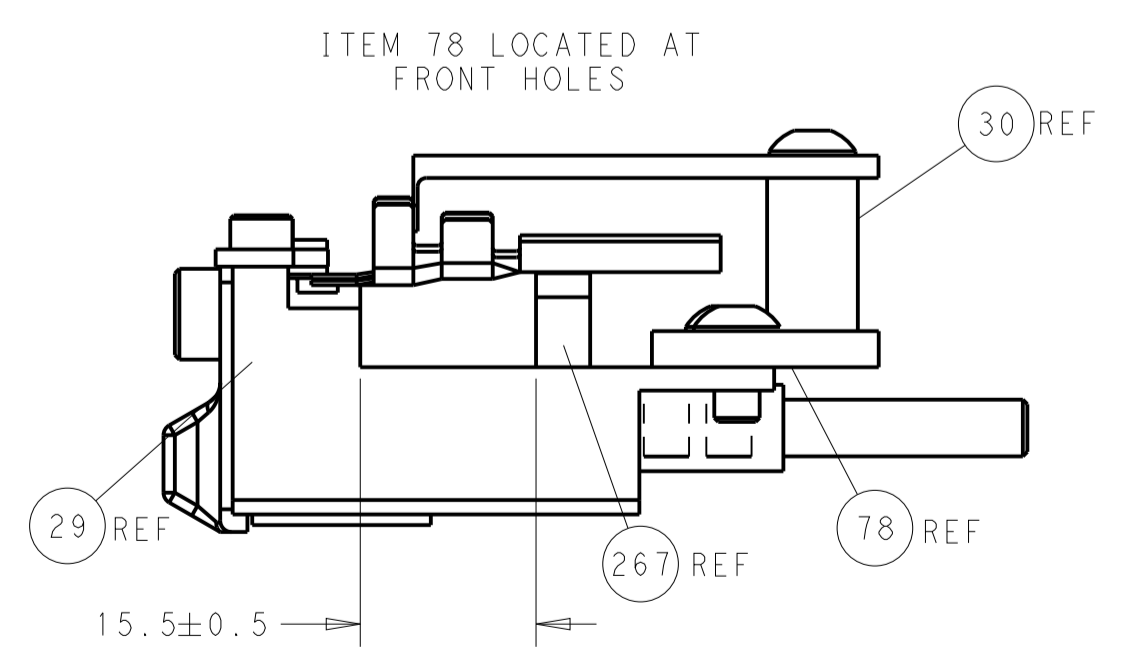
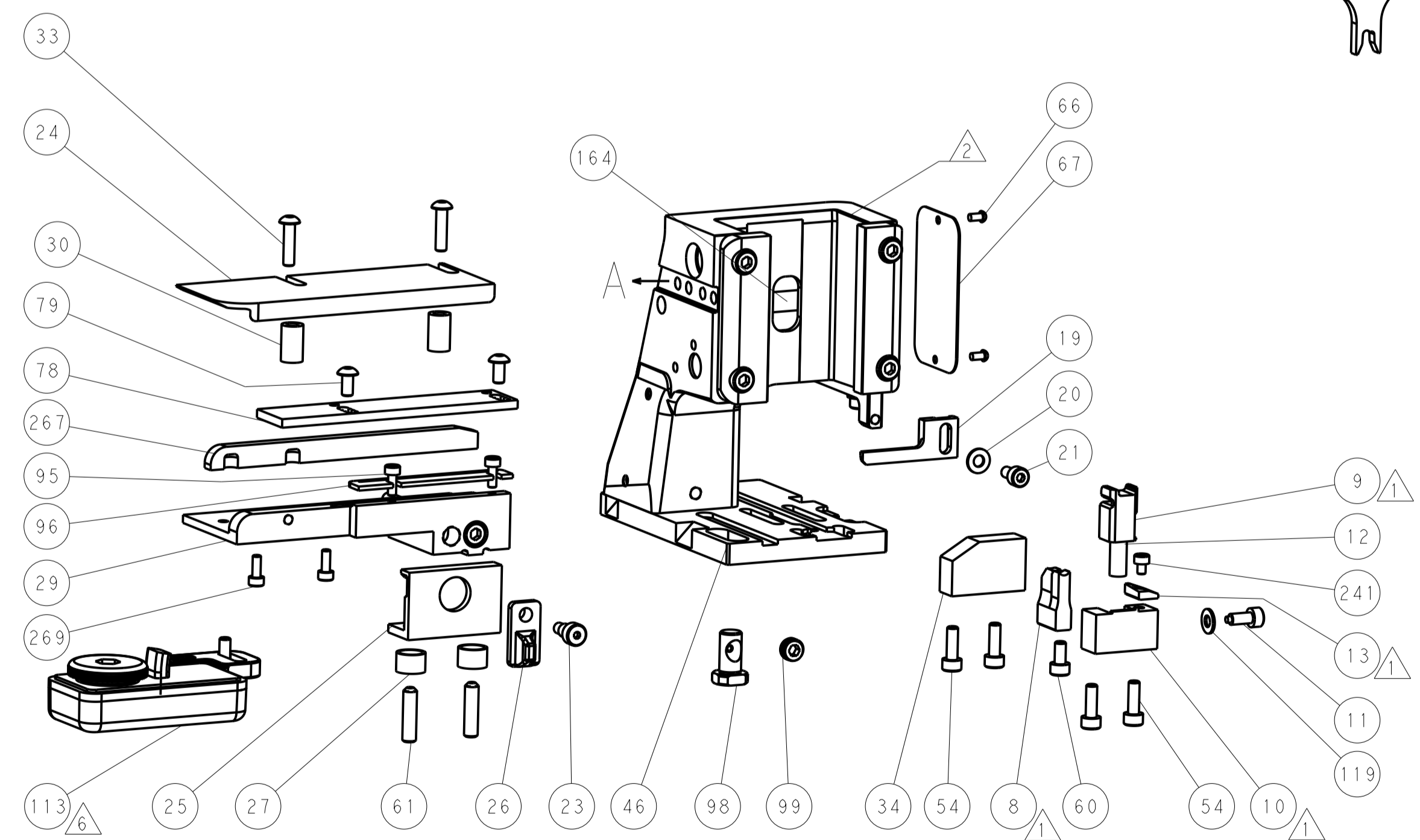
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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:		DWN X ZHAO 20NOV2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME	Harrisburg, PA 17105-3608
	ANGLES			APVD T. ELBIN 20NOV2013		Ocean Side Feed Applicator	
MATERIAL		FINISH		PRODUCT SPEC		RESTRICTED TO	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A1 00779 C=2266158	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266158-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266158-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266158-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [1.40]	F
INSUL	4.70 mm [1.85]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: LANGUETTE 6.3mm			
WIRE STRIP LENGTH 3.56-3.99 mm [1.40-.157 IN]		INSULATION DIAMETER RANGE Ø2.80-4.40 mm [1.10-.173 IN]	
TERMINAL APPLICATION SPECIFICATION	2252 C 001	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544218-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.65+/-0.05 [1.04+/-0.02]	4.0
5.00mm2	2.50+/-0.05 [1.098+/-0.02]	6.3
4.00mm2	2.35+/-0.05 [1.093+/-0.02]	7.5
3.00mm2	2.25+/-0.05 [1.089+/-0.02]	8.6

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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	-	-	-	-

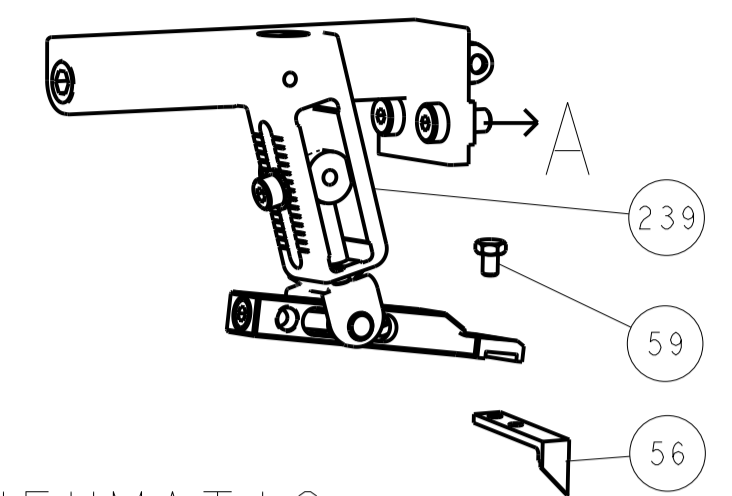
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	2	2		2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1		1633782-3 FENCE	267	
-	1	1		1803078-3 SPACER, PRECISION	259	
-	1	1		2119082-7 CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1		2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1		2119083-1 RETAINER, 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		1803516-2 RAM ASSEMBLY, SF PACIFIC	140	
-	1	1		455888-5 SPACER, CRIMPER	120	
-	1	1		1-18028-2 WASHER, FLAT, REG M4	119	
-	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		1-690438-0 FRONT STRIP GUIDE	96	
-	2	2		2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1		1-455888-8 SPACER, CRIMPER	82	
-	2	2		2079383-4 SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1		1803096-1 EXTENSION PLATE	78	
-	1	1		1803607-3 DOCUMENTATION PACKAGE	71	
-	1	1		2119791-9 DEPRESSOR, WIRE	70	
-	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	
-	2	2		2-18032-5 SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	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		1803602-2 SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1		1752356-1 SUPPORT, TERMINAL	34	
-	2	2		2079383-8 SCR, BHSC, RoHS (M4 X 16)	33	
-	2	2		2-2844962-3 SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1		2844992-3 ASSEMBLY, STRIP GUIDE	29	
-	1	1		455888-3 SPACER, CRIMPER	28	
-	2	2		22283-1 SPRING, COMPRESSION	27	
-	1	1		356835-1 LEVER, DRAG RELEASE	26	
-	1	1		240792-1 DRAG, TERMINAL	25	
-	1	1		1320928-4 STRIP GUIDE	24	
-	1	1		980371-4 SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1		2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1		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		454276-5 FLOATING SHEAR, FRONT	9	
-	1	1		1633926-5 ANVIL, COMBINATION	8	
-	1	1		1-240641-7 SPACER	7	
-	-	-		-	6	
-	1	1		1-2119757-0 DEPRESSOR, SHEAR	5	
-	1	1		238011-1 BLOCK, CRIMPER SPACER	4	
-	1	1		6-1633964-9 CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1		455888-5 SPACER, CRIMPER	2	
-	1	1		3-456411-1 CRIMPER, WIRE PREMIUM	1	
-	77	-22	-21	PART NO	DESCRIPTION	ITEM NO

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

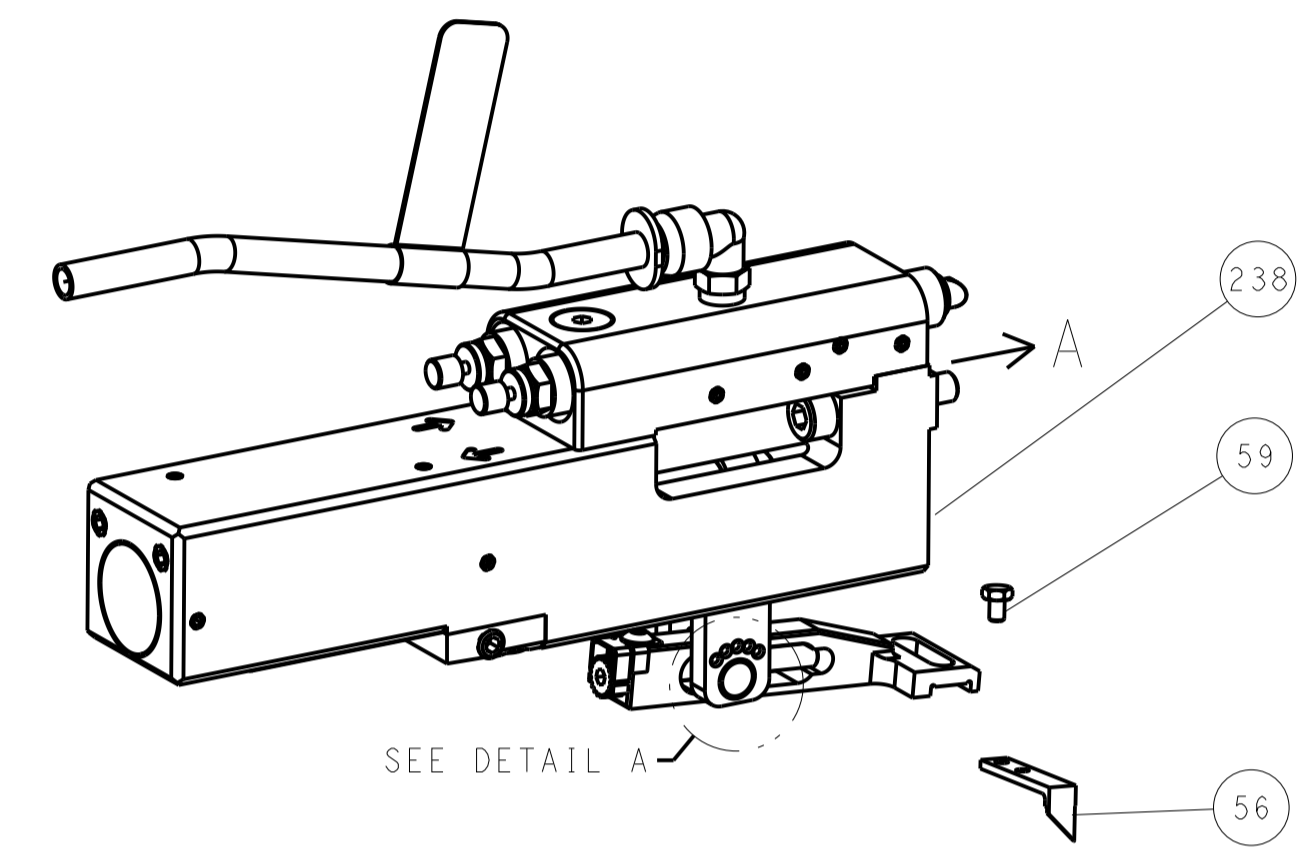
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0 PLC	±	1 PLC	±	2 PLC	±	3 PLC	±	4 PLC	±	ANGLE	±
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2		SHEET 3 OF 4		REV E	

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

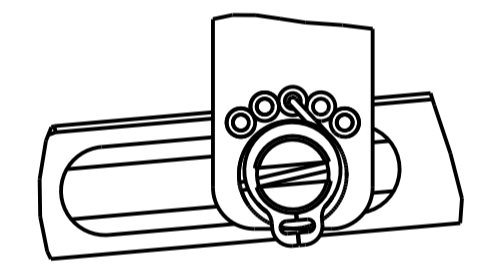
FEED TYPE MECHANICAL



PNEUMATIC

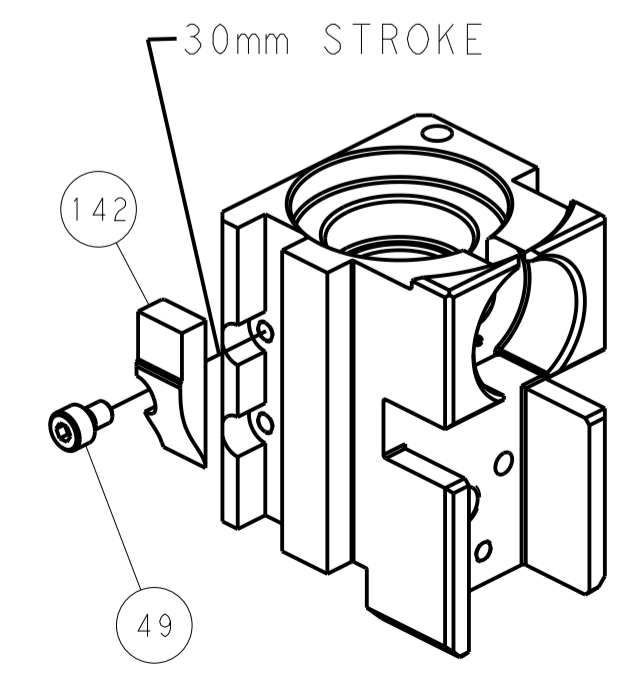


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

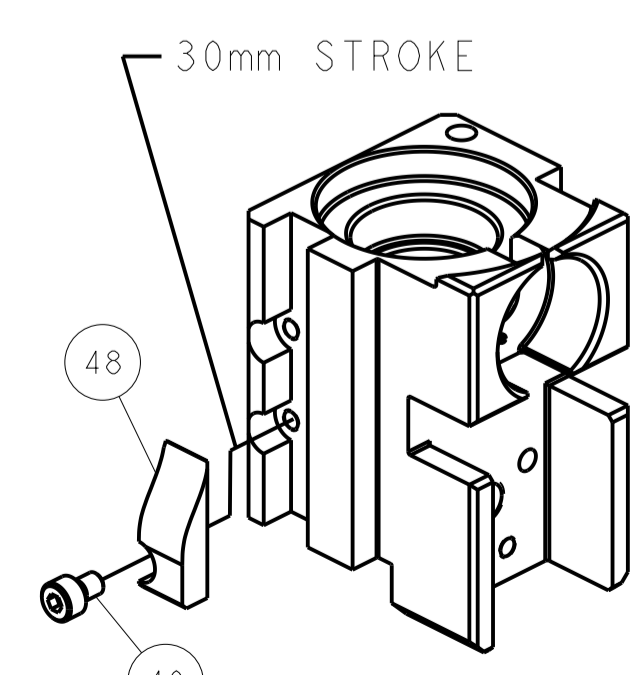


DETAIL A

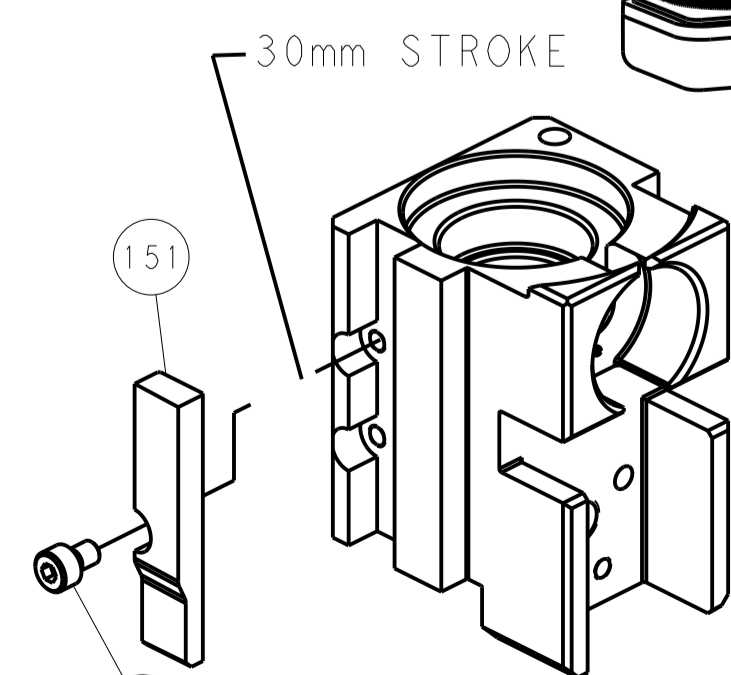
CAM POSITIONS



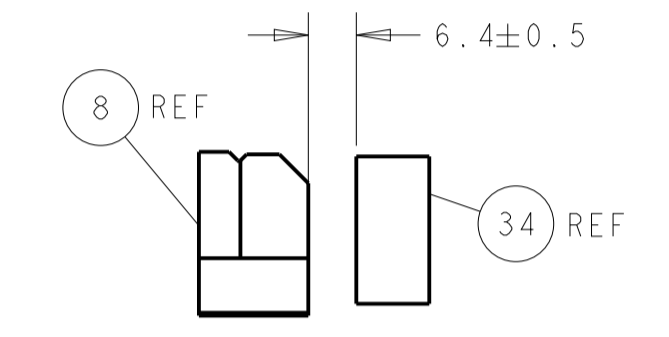
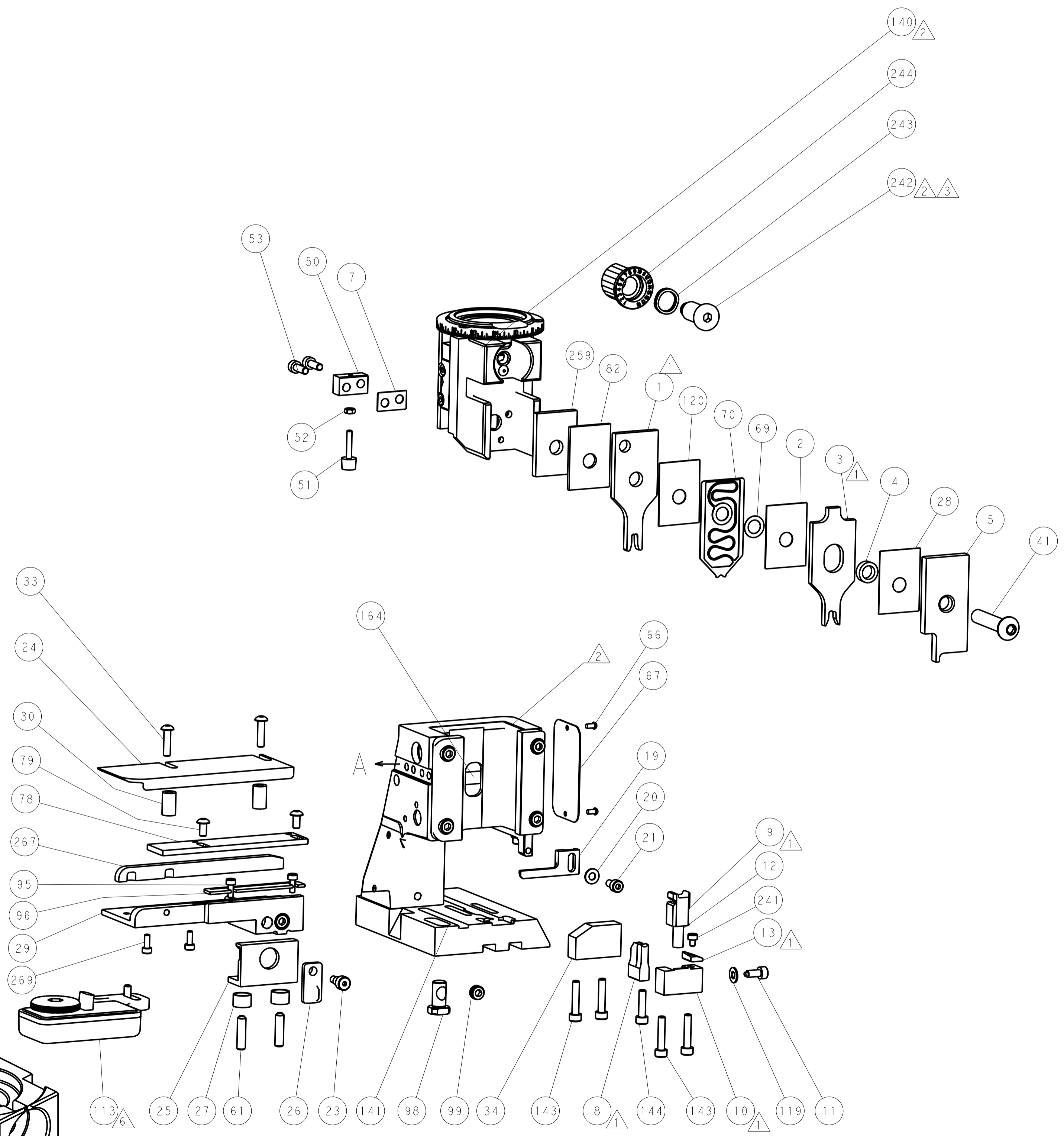
MECHANICAL
POST FEED



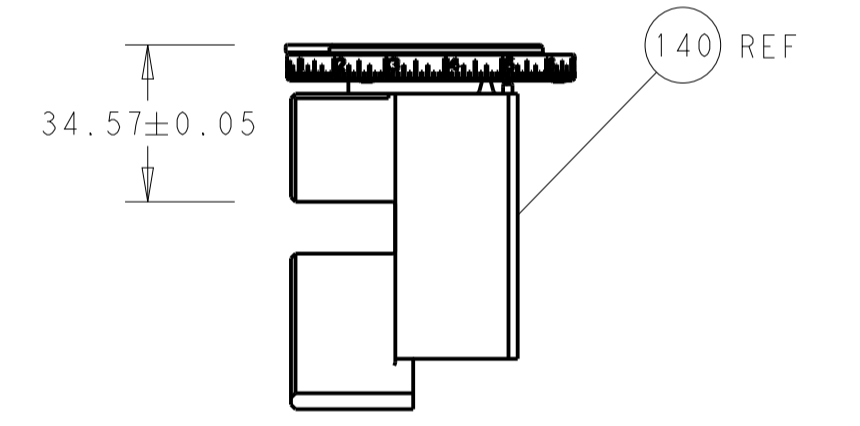
MECHANICAL
PRE FEED



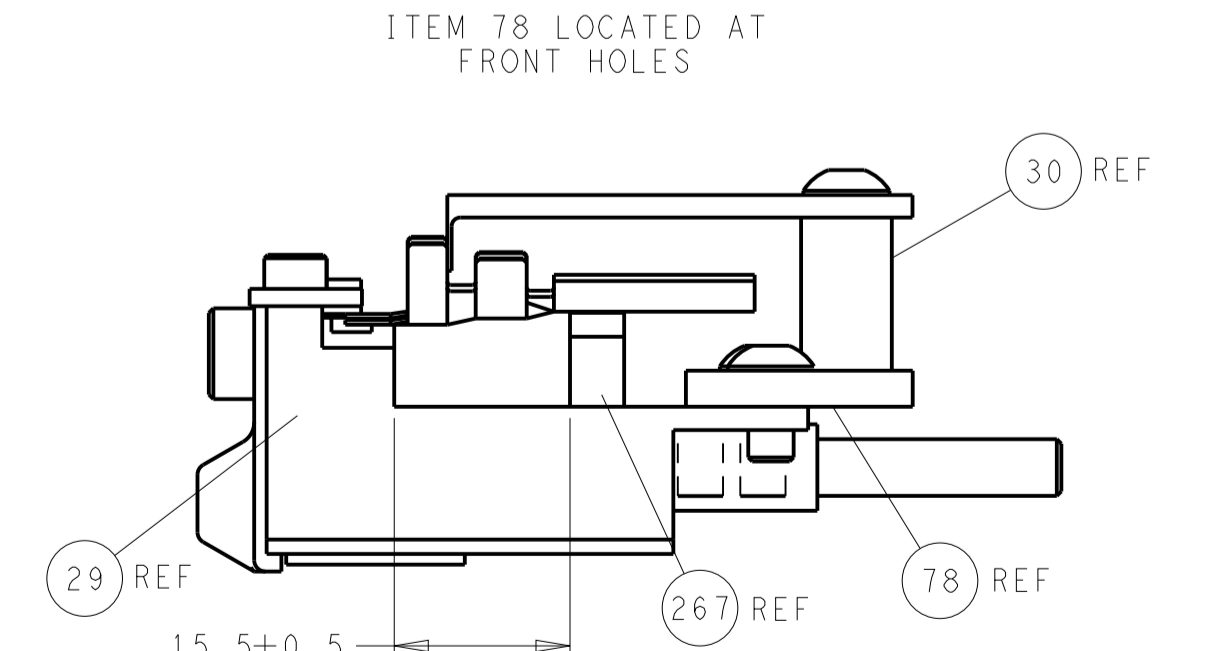
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X_ZHAO 20NOV2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES			CHK: T_ELFIN 20NOV2013	NAME: Ocean Side Feed Applicator		
MATERIAL:	FINISH:	WTG:	SCALE: 1:2	APVD: L_ZHANG 20NOV2013	SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2266158
Customer Accessible Production Drawing				SHEET 4 OF 4		REV E	