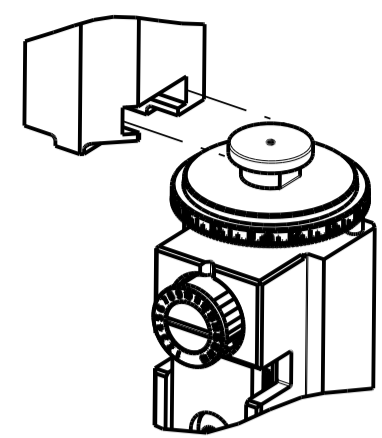


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266530-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266530-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266530-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266530-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266530-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266530-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266530-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



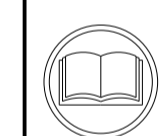
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.70 mm [.067]	F
INSUL	1.75 mm [.069]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: JAE TERMINAL		JAE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, FEMALE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.80-4.80 mm [.150-.189 IN]		Ø1.00-1.90 mm [.039-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) J AHL-1754 Rev 14		
TERMINALS APPLIED			
TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
(A) 1832424-1	(A) M34S75C4F2		

TERMINAL DATA: JAE TERMINAL		JAE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, MALE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.80-4.80 mm [.150-.189 IN]		Ø1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	(B) J AHL-1754-3 Rev 1		
TERMINALS APPLIED			
TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
(B) 2303607-1	(B) M34P75C4F2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.10 +/- 0.05 [.043 +/- .002]	7.8
0.50mm2	1.00 +/- 0.05 [.039 +/- .002]	9.0



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.

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			
		REV	DATE	BY	CHKD
A	66	C	18-013033	16AUG2018	KH GB
		D	19-009593	19JUN2019	FJ TE
		E	20-005045	03APR2020	TB RK
		F	21-000941	04FEB2021	FZ RK

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	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	2119082-4	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
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-7	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	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	2119791-9	DEPRESSOR, WIRE	70
-	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	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	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	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	690518-4	HOLD DOWN, TERMINAL	18
-	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	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	3-1803057-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	4-1633966-0	CRIMPER, INSULATION O	3
-	-	-	-	-	-	-	-	-	2
1	2	2	1	1	1	1	1333281-8	CRIMPER, WIRE PREMIUM	1

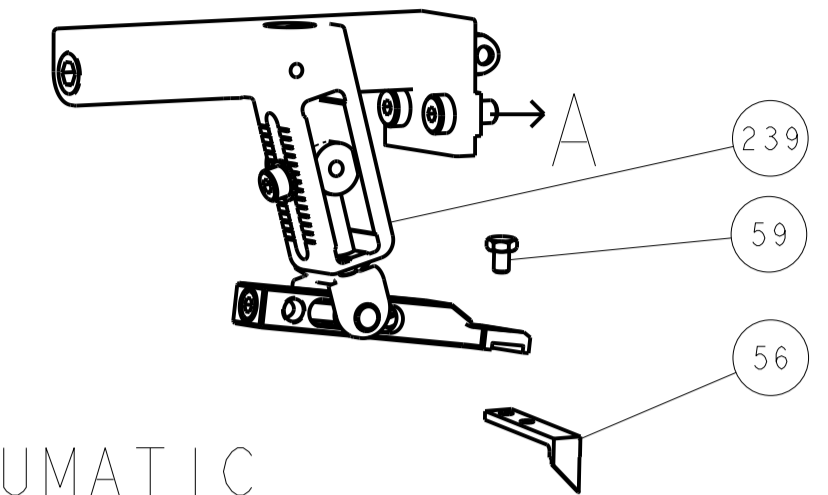
ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-51	-2	-1	

DATE: 14OCT2014	CHKD: T. ELBIN	APVD: T. ELBIN	NAME: Ocean Side Feed Applicator
DATE: 14OCT2014	DATE: 14OCT2014	DATE: 14OCT2014	DATE: 14OCT2014
DATE: 14OCT2014	DATE: 14OCT2014	DATE: 14OCT2014	DATE: 14OCT2014

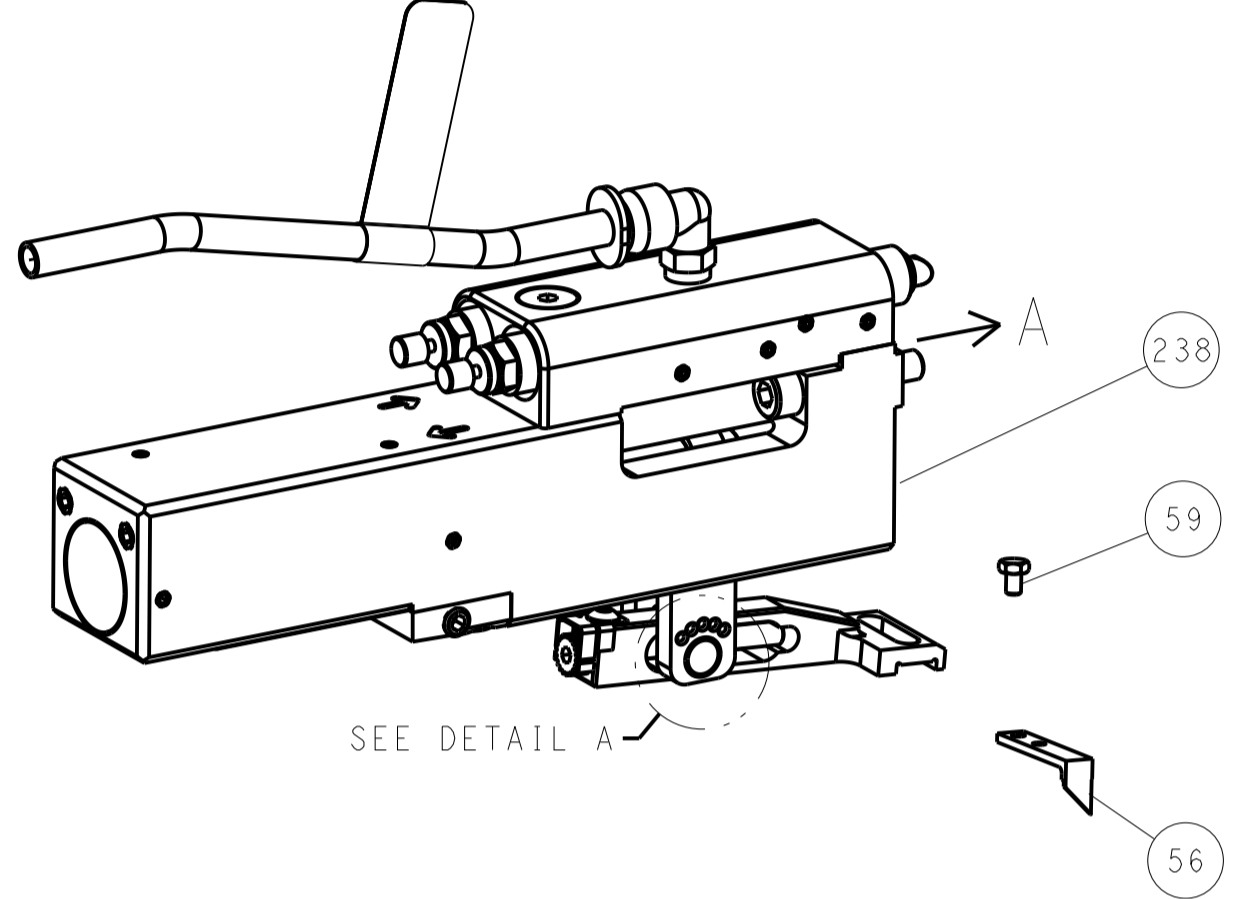
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV F

LOC	DIST	REV	DATE	BY	APPV
A	66				

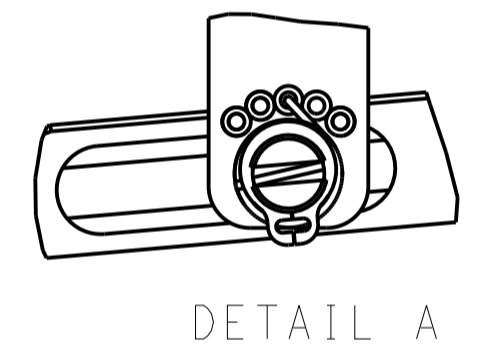
FEED TYPE MECHANICAL



PNEUMATIC

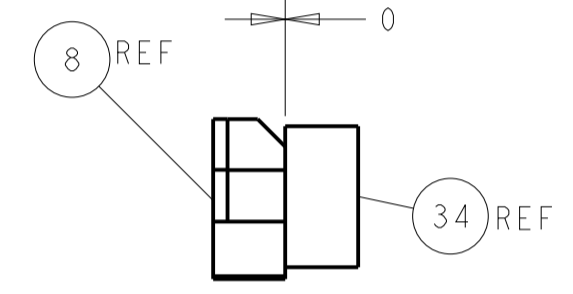
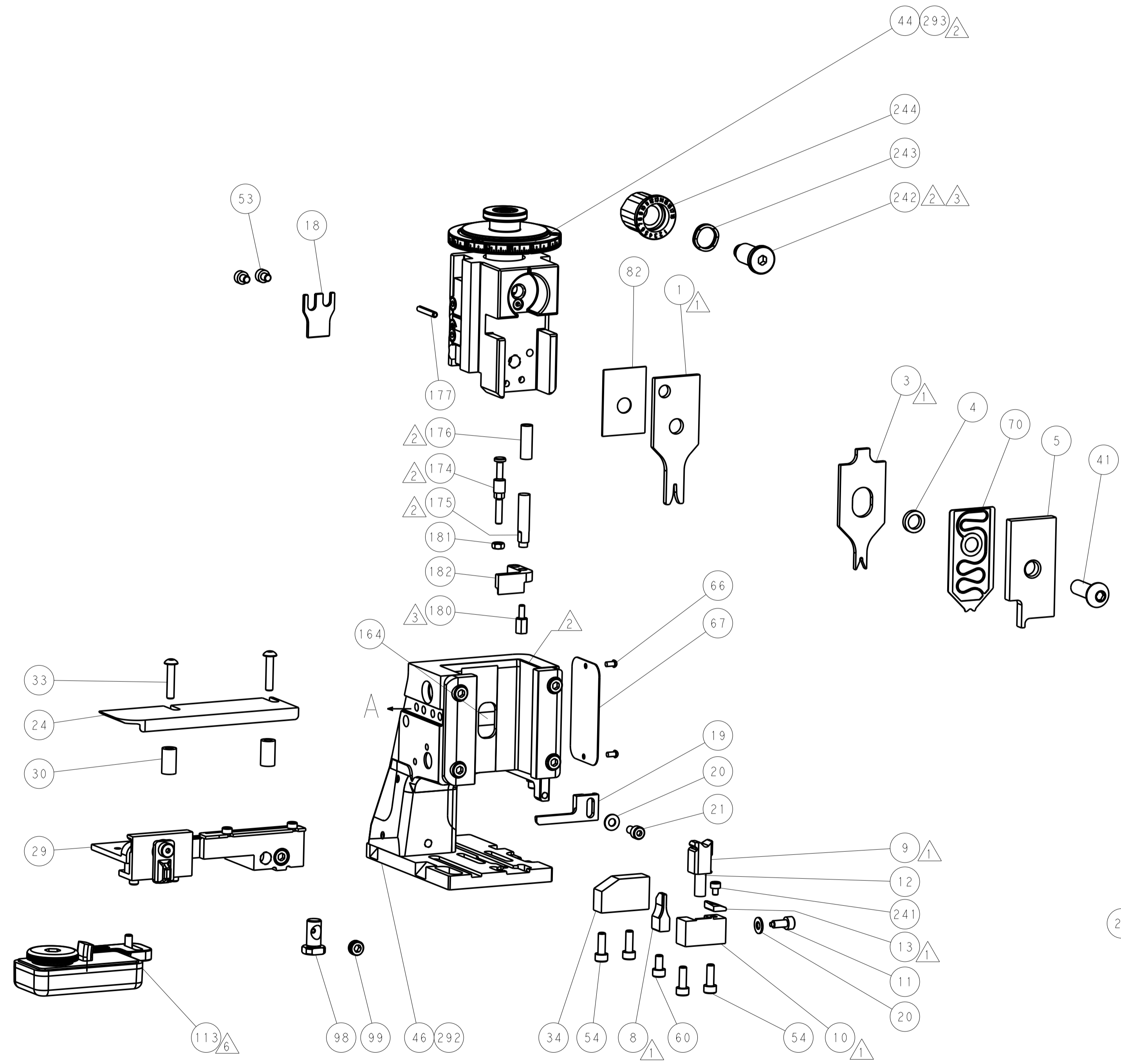
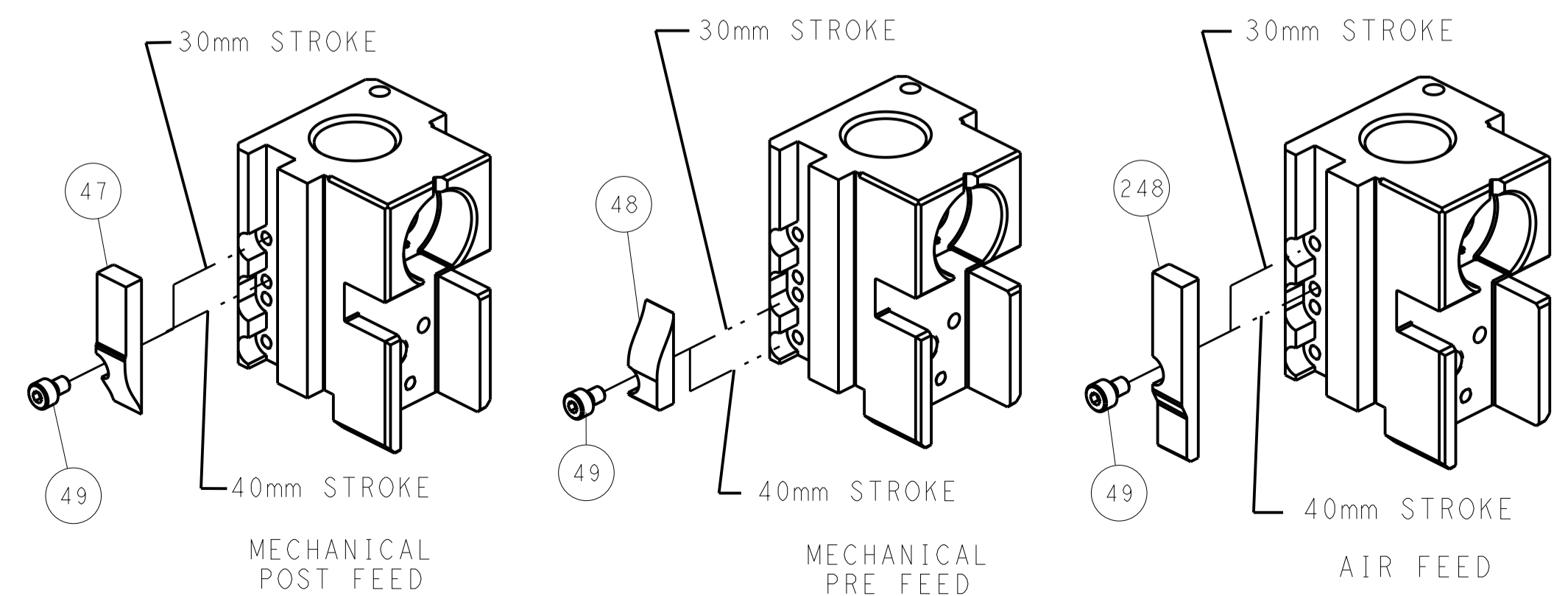


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

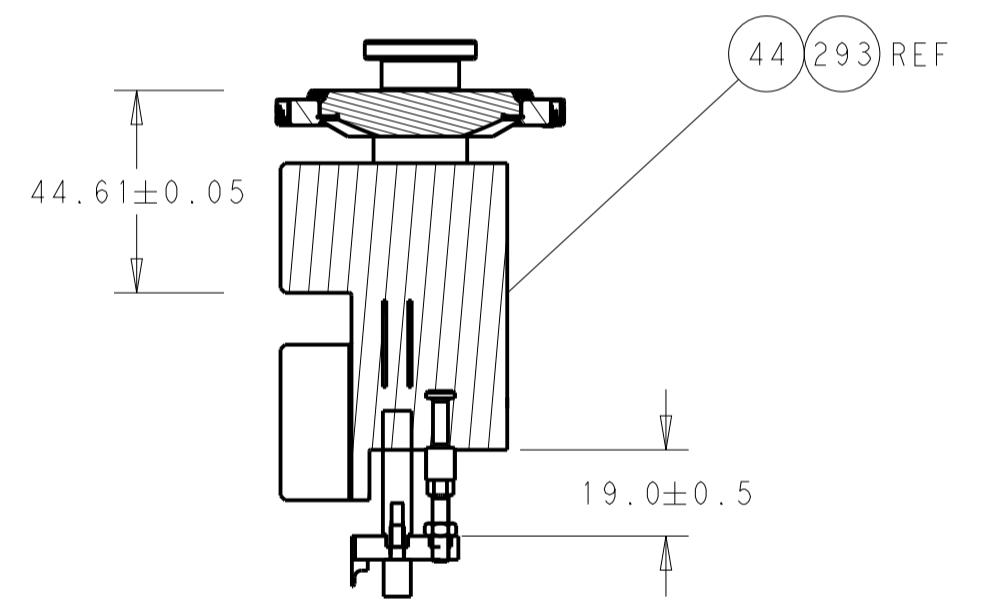


DETAIL A

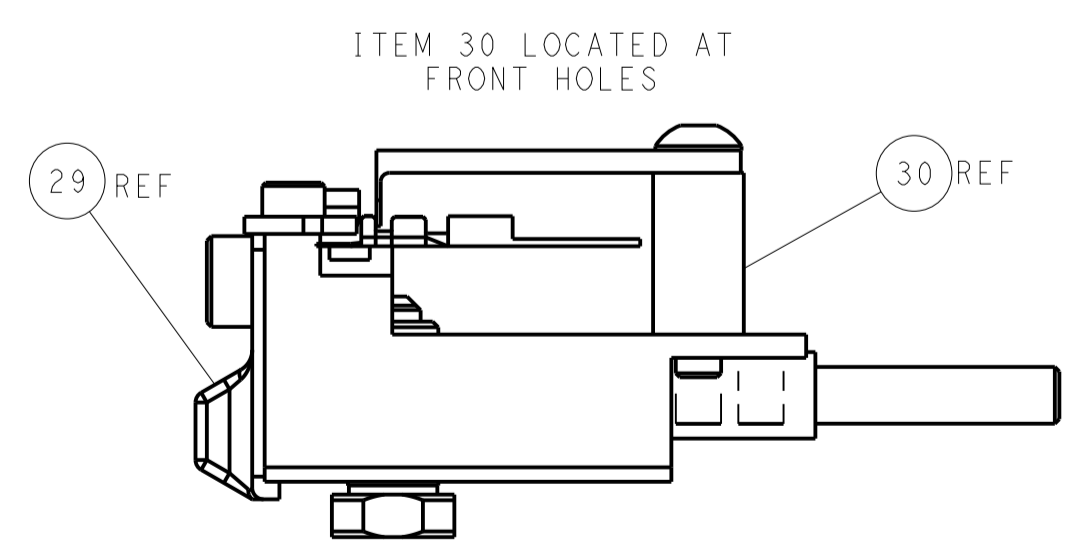
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



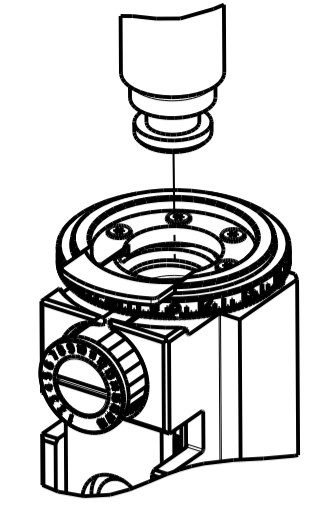
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN B. WEAVER 14OCT2014 CHK T. ELBIN 14OCT2014 APVD T. ELBIN 14OCT2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		TE Connectivity Harrisburg, PA 17105-3608 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 ©=2266530 SCALE 1:2 SHEET 2 OF 4 REV F	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266530-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266530-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266530-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.70 mm [.067]	F
INSUL	1.75 mm [.069]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: JAE TERMINAL JAE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, FEMALE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.80-4.80 mm [.150-.189 IN]	Ø1.00-1.90 mm [.039-.075 IN]		
TERMINAL APPLICATION SPECIFICATION (A)J AHL-1754 Rev 14	-		
TERMINALS APPLIED 6			
TE TERMINAL (A) 1832424-1	JAE TERMINAL (A) M34S75C4F2	TE TERMINAL	JAE TERMINAL

TERMINAL DATA: JAE TERMINAL JAE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, MALE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.80-4.80 mm [.150-.189 IN]	Ø1.40-1.90 mm [.055-.075 IN]		
TERMINAL APPLICATION SPECIFICATION (B)J AHL-1754-3 Rev 1	-		
TERMINALS APPLIED 6			
TE TERMINAL (B) 2303607-1	JAE TERMINAL (B) M34P75C4F2	TE TERMINAL	JAE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.10+/-0.05 [.043+/-0.002]	7.8
0.50mm2	1.00+/-0.05 [.039+/-0.002]	9.0



- 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.

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

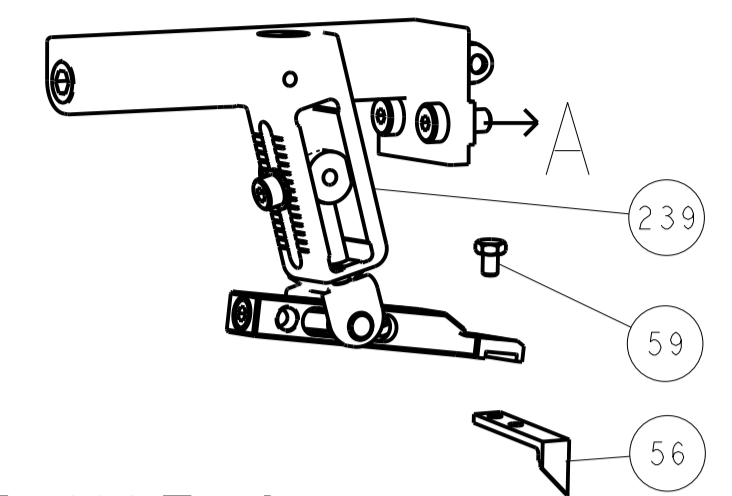
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	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	2119791-9	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	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	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	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	690518-4	HOLD DOWN, TERMINAL	18
-	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1-1803057-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	4-1633966-0	CRIMPER, INSULATION O	3
-	-	-	-	-	2
-	1	1	1333281-8	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)

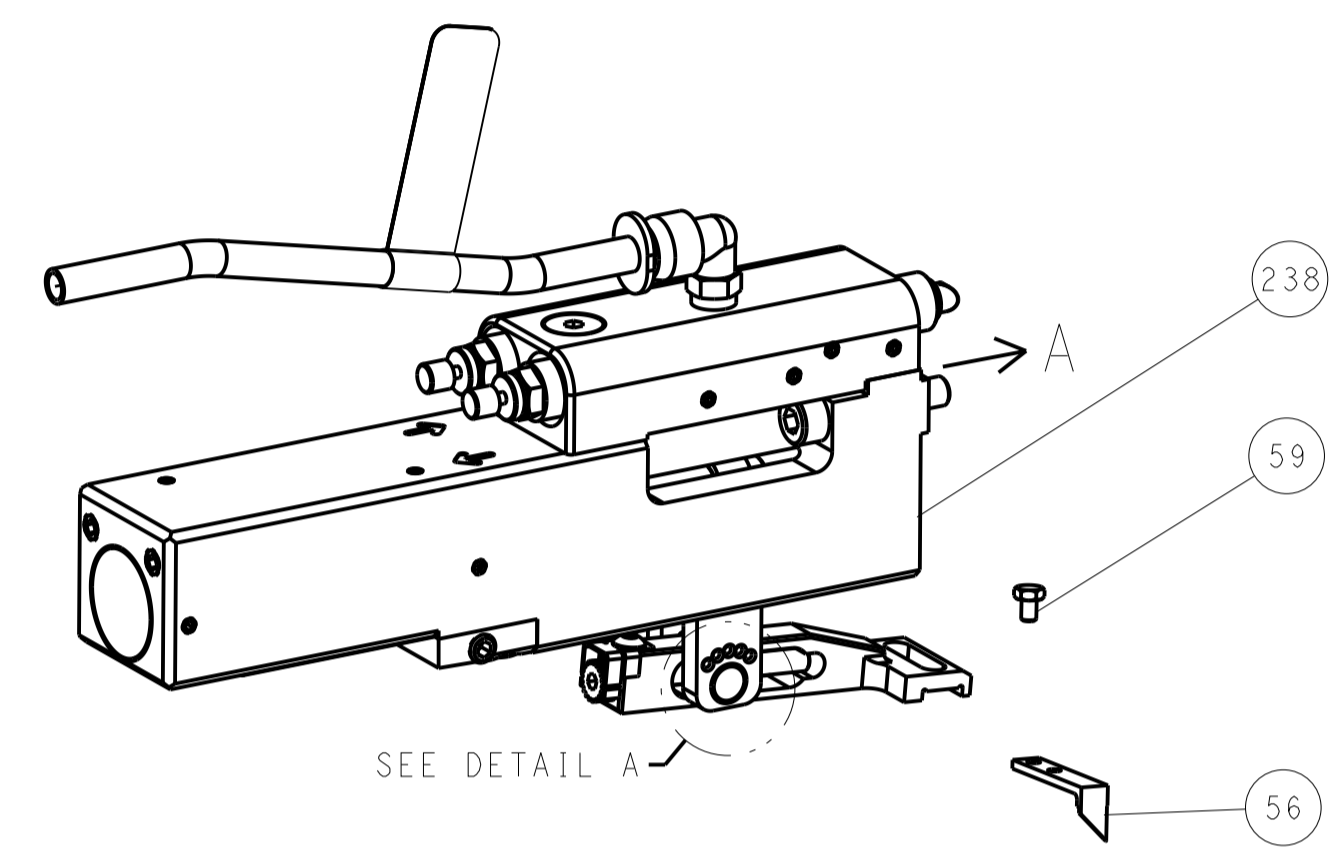
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: B. WEAVER 14OCT2014		CHK: T. ELBIN 14OCT2014		APVD: T. ELBIN 14OCT2014		NAME: TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		PRODUCT SPEC	
ANGLES		FINISH		APPLICATION SPEC		SIZE: CAGE CODE: DRAWING NO: A1 00779 C=2266530		RESTRICTED TO		SCALE: 1:2 SHEET 3 OF 4 REV F	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE: 1:2		SHEET 3 OF 4 REV F	

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

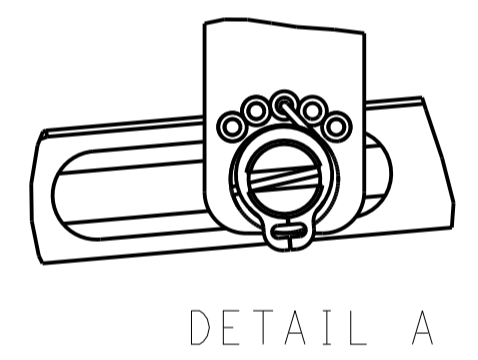
FEED TYPE MECHANICAL



PNEUMATIC

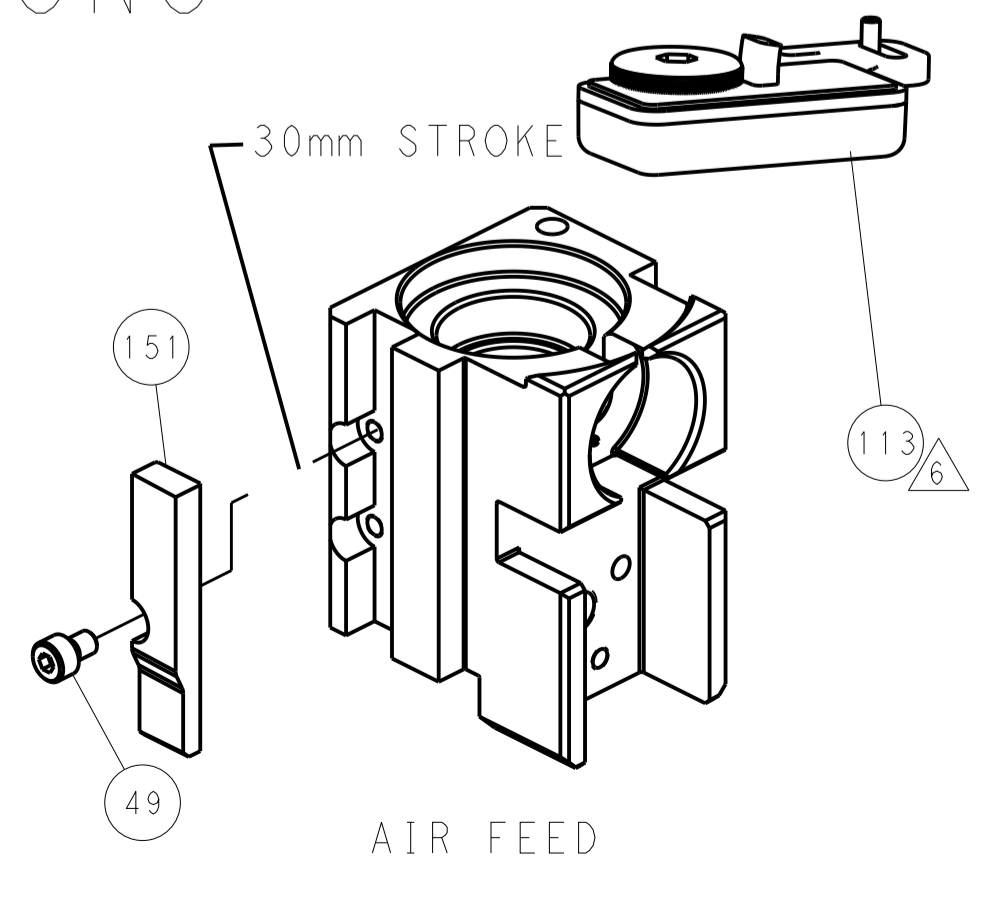
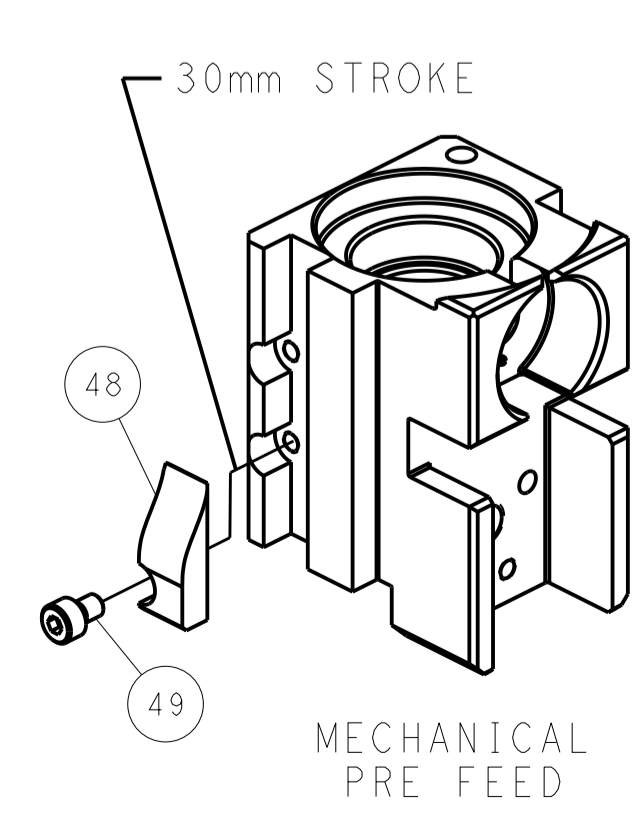
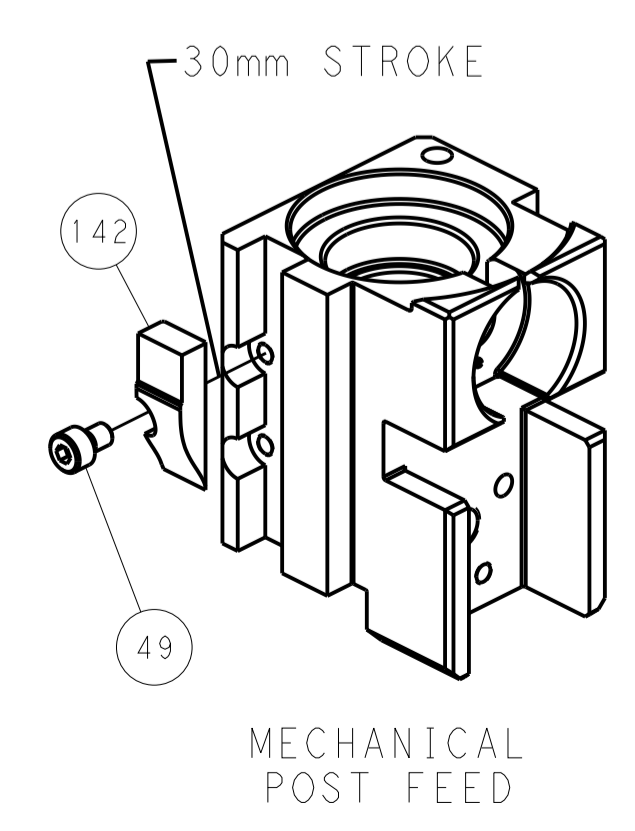


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

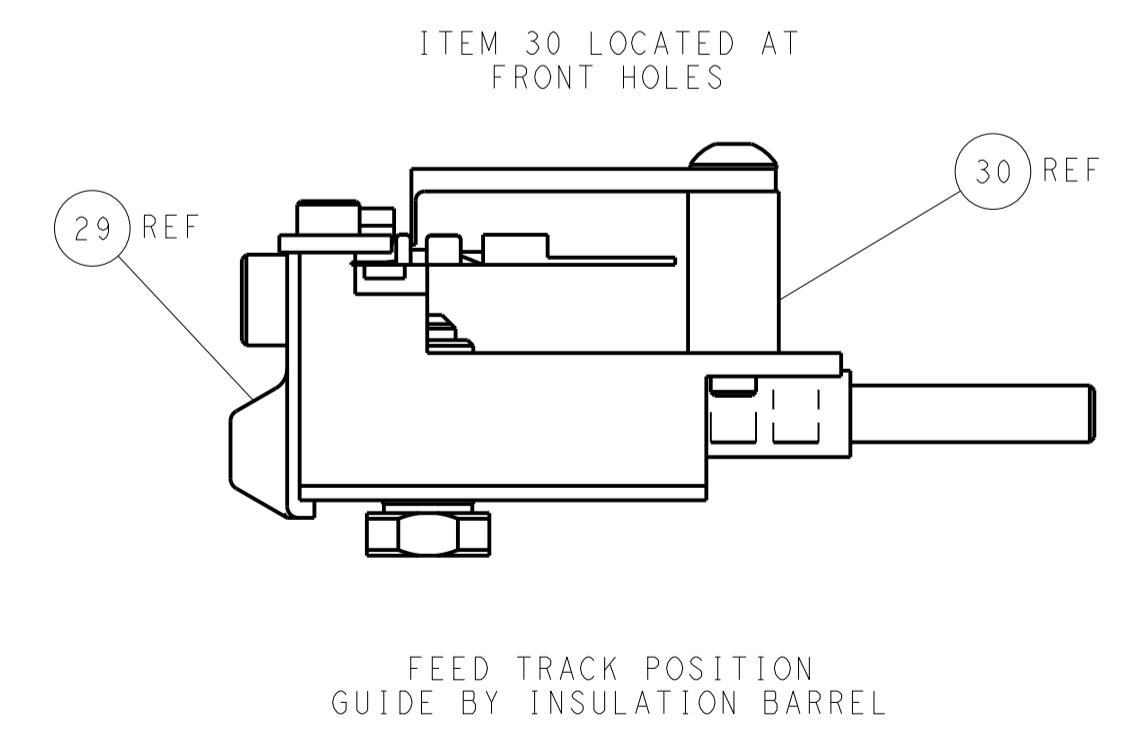
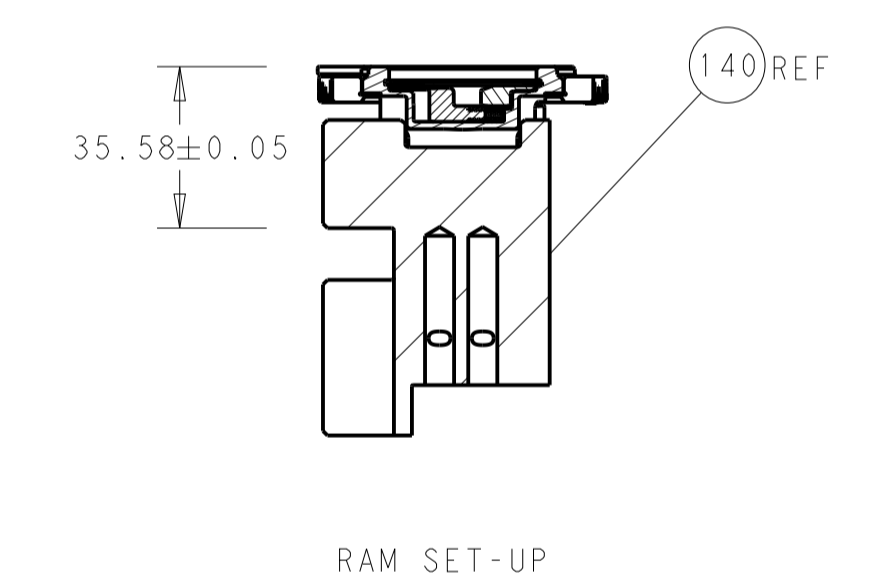
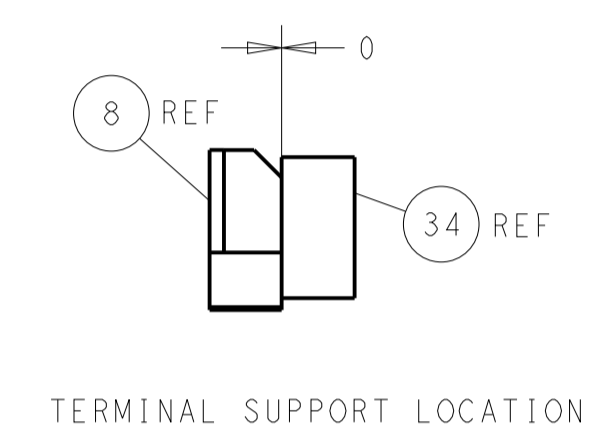
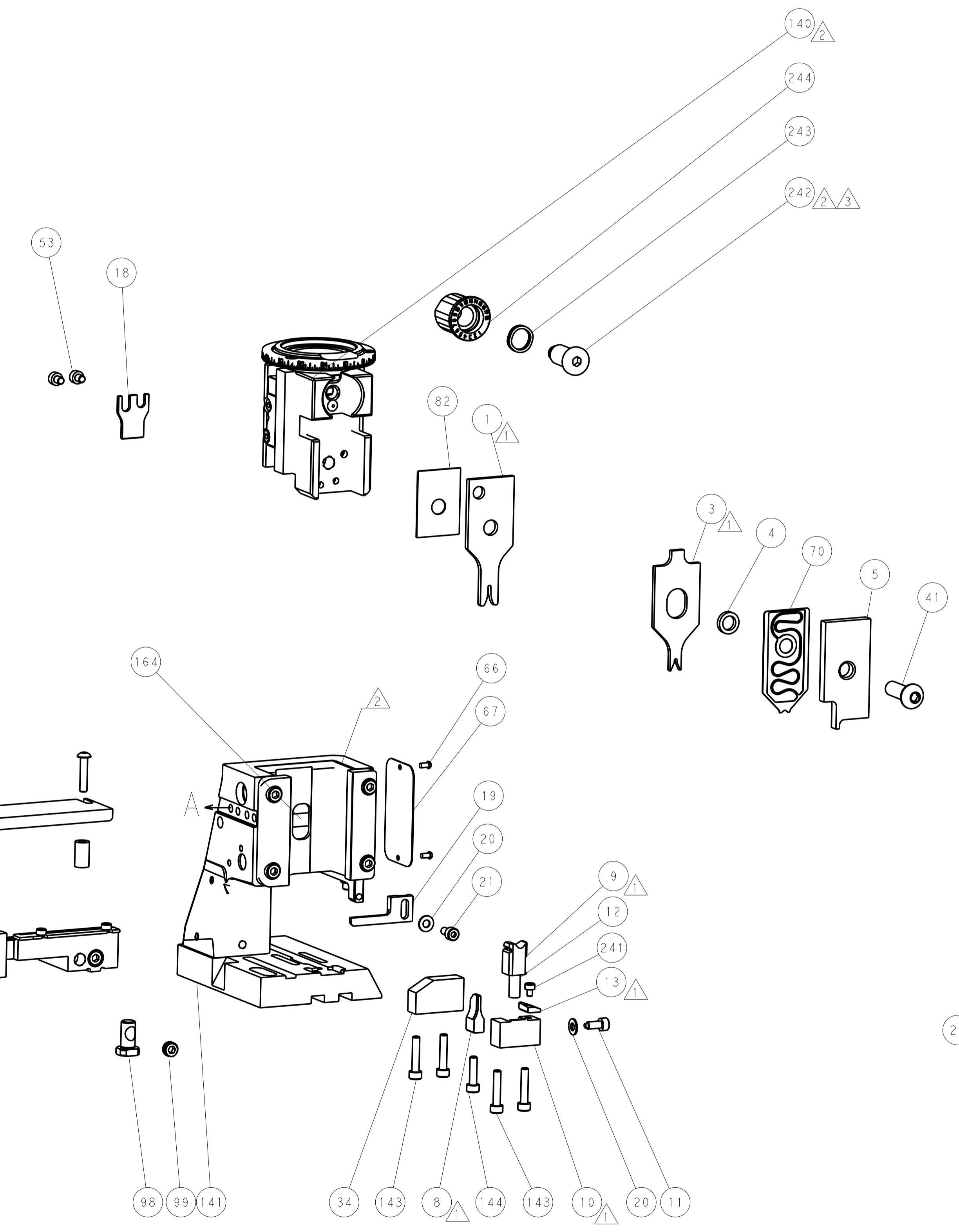


DETAIL A

CAM POSITIONS



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: B. WEAVER 14OCT2014		TE Connectivity	
mm		0 PLC	±	CHK: T. ELBIN 14OCT2014		Harrisburg, PA 17105-3608	
HOLE		1 PLC	±	APPV: T. ELBIN 14OCT2014		NAME: Ocean Side Feed Applicator	
MATERIAL:		2 PLC	±	PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
FINISH:		3 PLC	±	APPLICATION SPEC:		RESTRICTED TO:	
		4 PLC	±	WEIGHT:		A 00779 C=2266530	
		ANGLES	±	Customer Accessible Production Drawing		SCALE: 1:2 SHEET 4 OF 4 REV F	