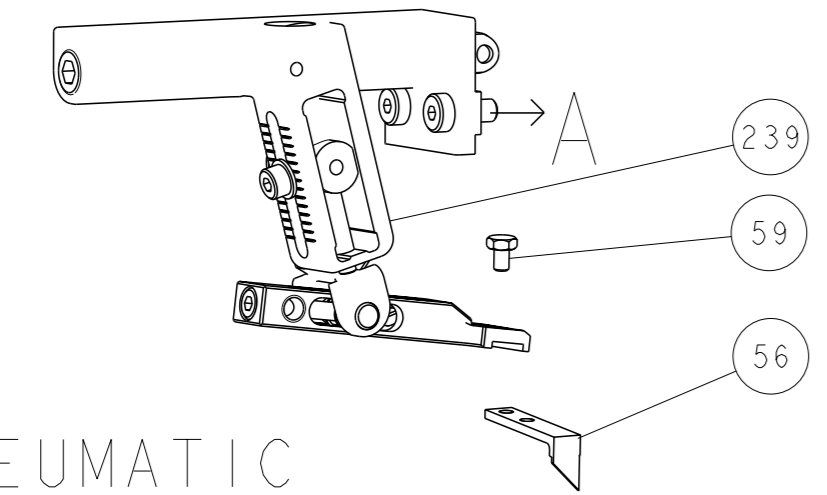
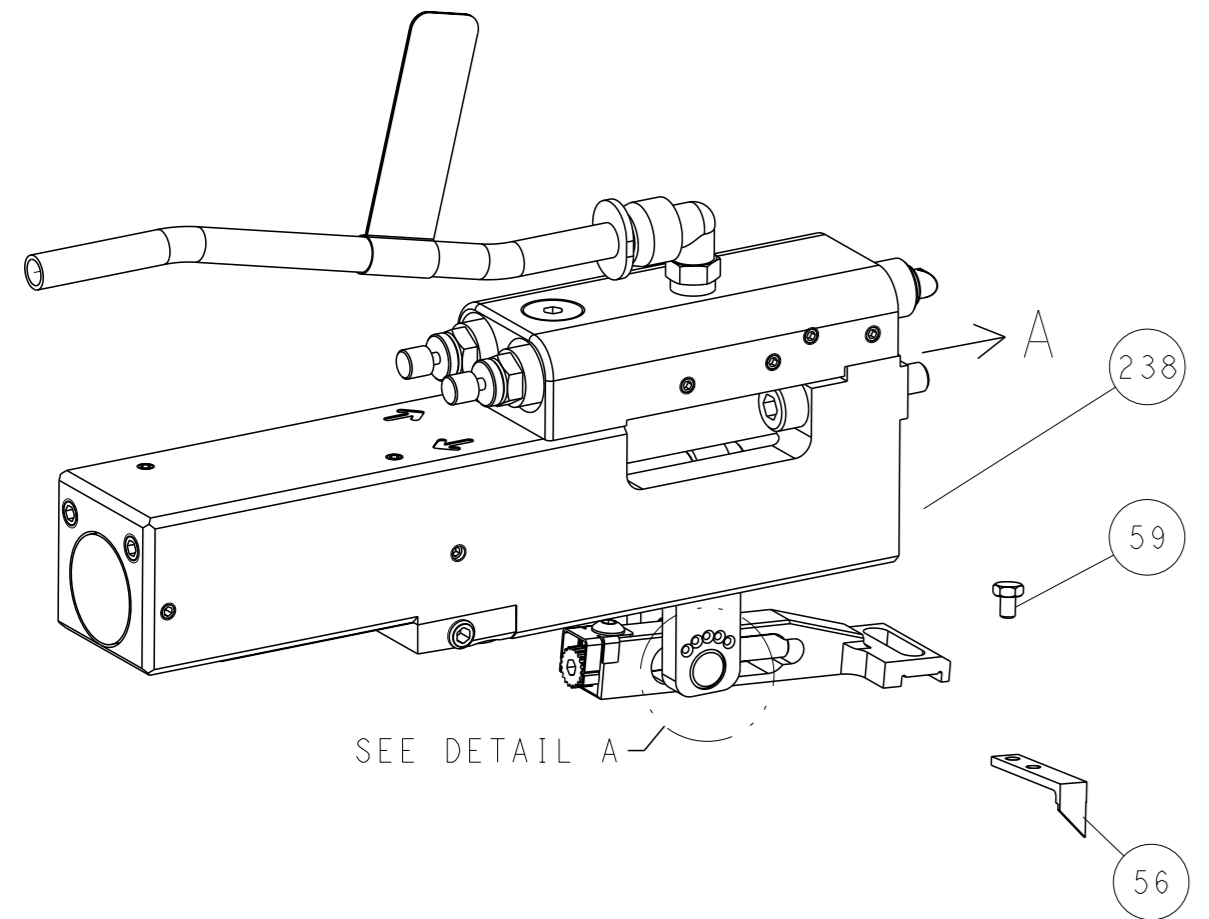


| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LYR | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | - | - | - |

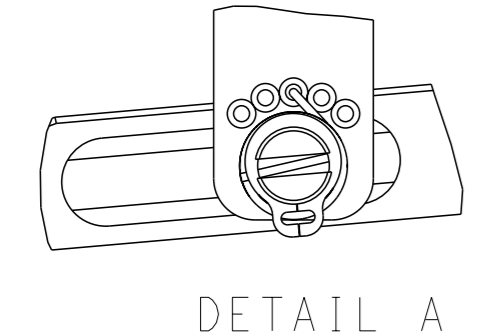
FEED TYPE MECHANICAL



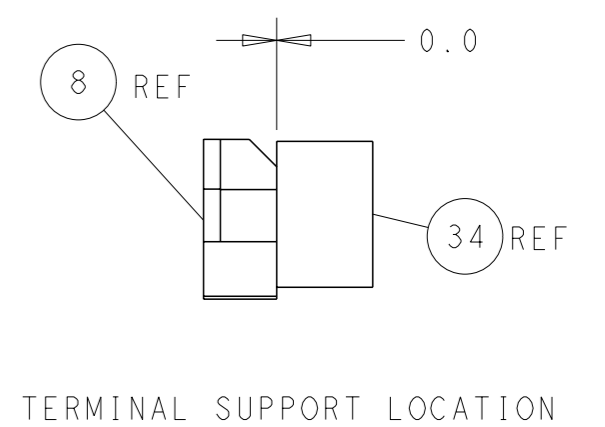
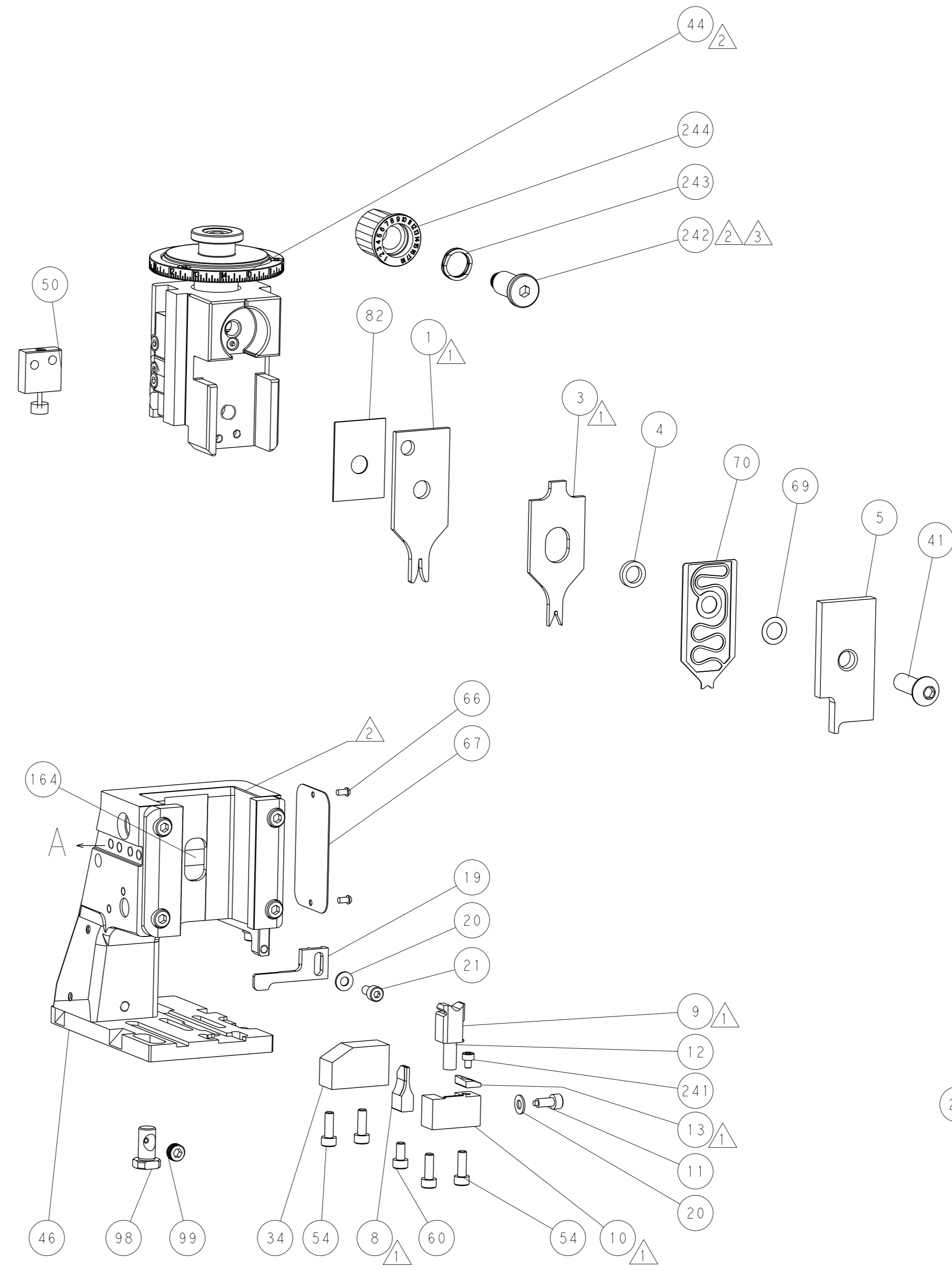
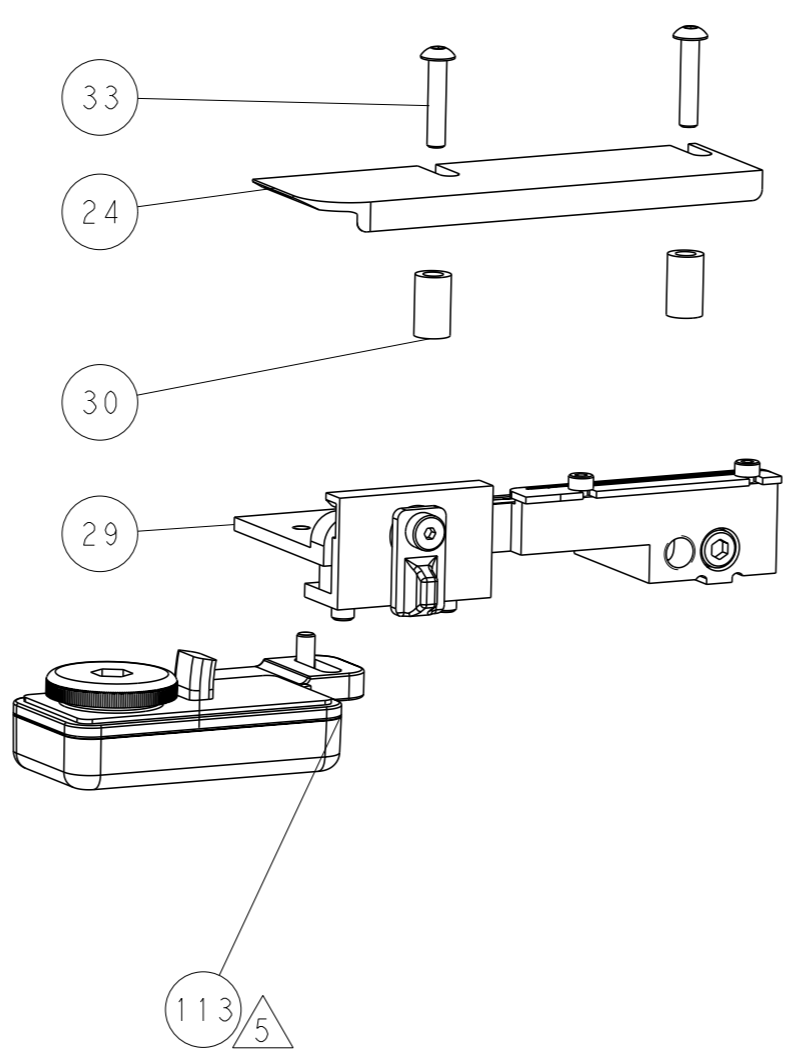
PNEUMATIC



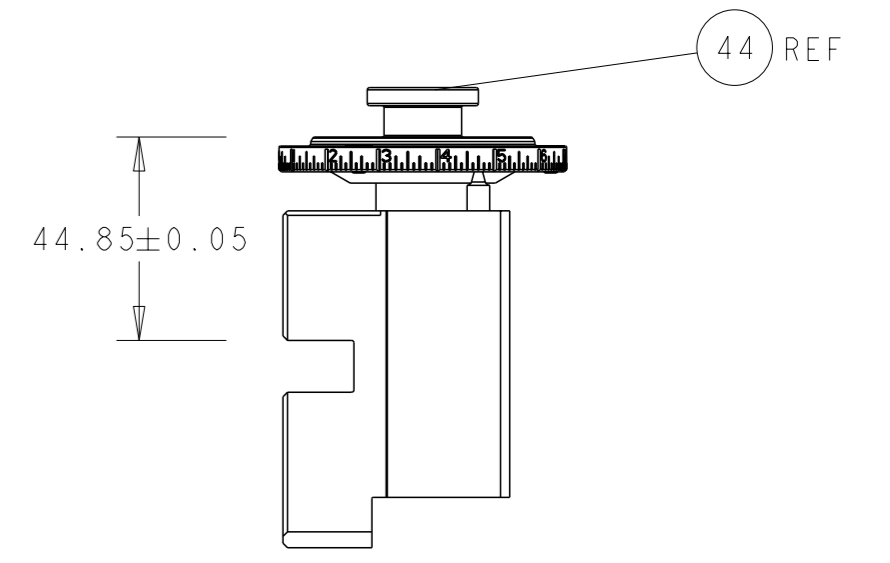
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



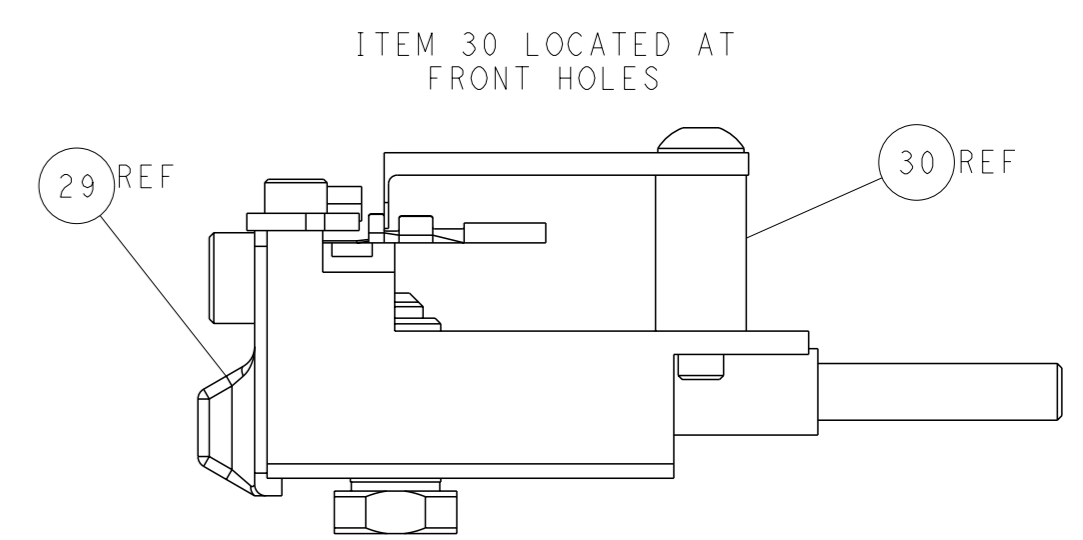
DETAIL A



TERMINAL SUPPORT LOCATION

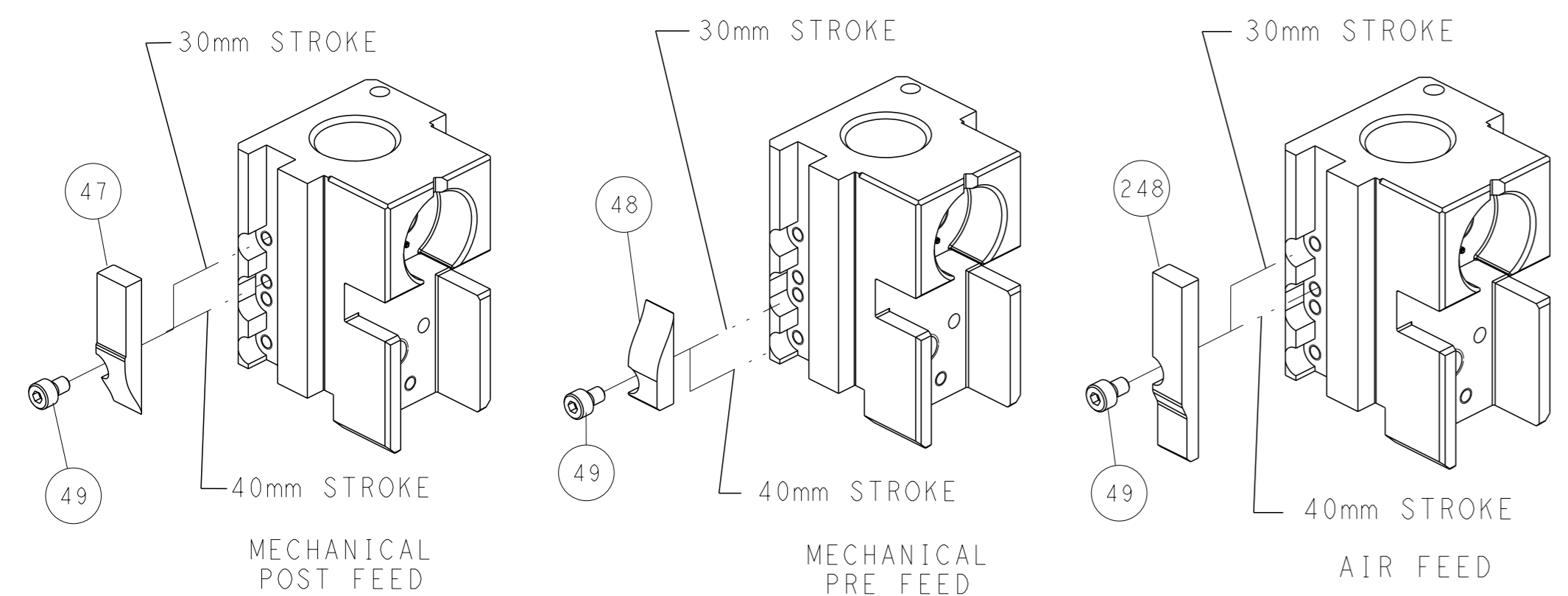


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

CAM POSITIONS

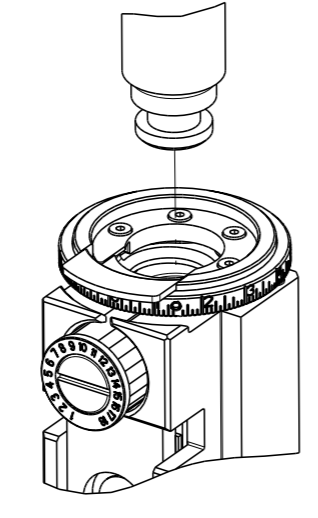


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | | | |
|---|-----------|--|---|----------------------------------|---|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: J. HOU CHK: L. ZHANG APVD: H. GUO | DATE: 19DEC2014 DATE: 19DEC2014 DATE: 19DEC2014 | NAME: Ocean Side Feed Applicator | SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266618 | RESTRICTED TO: |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | MATERIAL: | WEIGHT: | SCALE: 1:2 | SHEET: 2 of 4 | REV: D | Customer Accessible Production Drawing |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2266618-1 | D | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2266618-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266618-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.57 mm [.062] | F |
| INSUL | 1.57 mm [.062] | F |

APPLICATOR INSTRUCTIONS
 408-35042

| TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION | | | |
|---|------------------------------|-------------|-------------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 4.00-4.50 mm [.157-.177 IN] | Ø1.35-1.70 mm [.053-.067 IN] | | |
| TERMINAL APPLICATION SPECIFICATION NEWS03300029 Rev 23-Dec-10 | | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | SUMITOMO TERMINAL | TE TERMINAL | SUMITOMO TERMINAL |
| 1949973-1 | 8100-4030 | | |

| TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION | | | |
|---|------------------------------|-------------|-------------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 4.00-4.50 mm [.157-.177 IN] | Ø1.35-1.70 mm [.053-.067 IN] | | |
| TERMINAL APPLICATION SPECIFICATION NEWS03300029 Rev 23-Dec-10 | | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | SUMITOMO TERMINAL | TE TERMINAL | SUMITOMO TERMINAL |
| 1832368-1 | 8100-4027 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.75mm2 | 1.00 +/- 0.05 [.039 +/- .002] | 8.0 |
| 0.50mm2 | 0.90 +/- 0.05 [.035 +/- .002] | 9.1 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.75mm2 | 1.20 +/- 0.05 [.047 +/- .002] | 9.6 |
| 0.50mm2 | 1.05 +/- 0.05 [.041 +/- .002] | 10.3 |

- 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.

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| | | P | LY# | 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 | 2119791-6 | 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 | |
| - | 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 | 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 | 1752356-3 | 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 | 8-1633932-1 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 | |
| - | - | - | - | - | 6 | |
| - | 1 | 1 | 1-2119757-0 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 238011-4 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 1 | 5-1803017-6 | CRIMPER, INSULATION F | 3 | |
| - | - | - | - | - | 2 | |
| - | 1 | 1 | 1 | 3-1333281-7 | CRIMPER, WIRE PREMIUM | 1 |

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: | | APPROVED: | | DATE: | |
|-------------|---------|--|---------|-----------|---------|--------|--------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | FINISH | ANGLES |
| MATERIAL | | FINISH | | WEIGHT | | SCALE | |
| - | | - | | - | | 1:2 | |

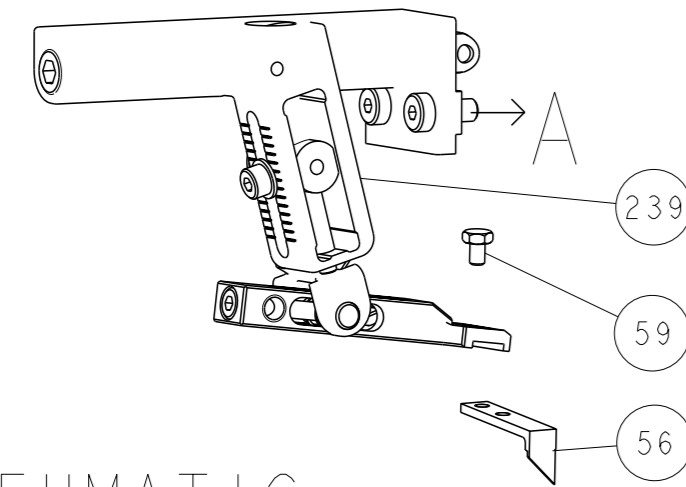
| OWN | CHK | APVD | U. GUO | DATE |
|--------|----------|--------|--------|-----------|
| J. HOU | L. ZHAGN | U. GUO | | 19DEC2014 |

| NAME | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|----------------------------|------|-----------|------------|---------------|
| Ocean Side Feed Applicator | A1 | 00779 | 2266618 | - |

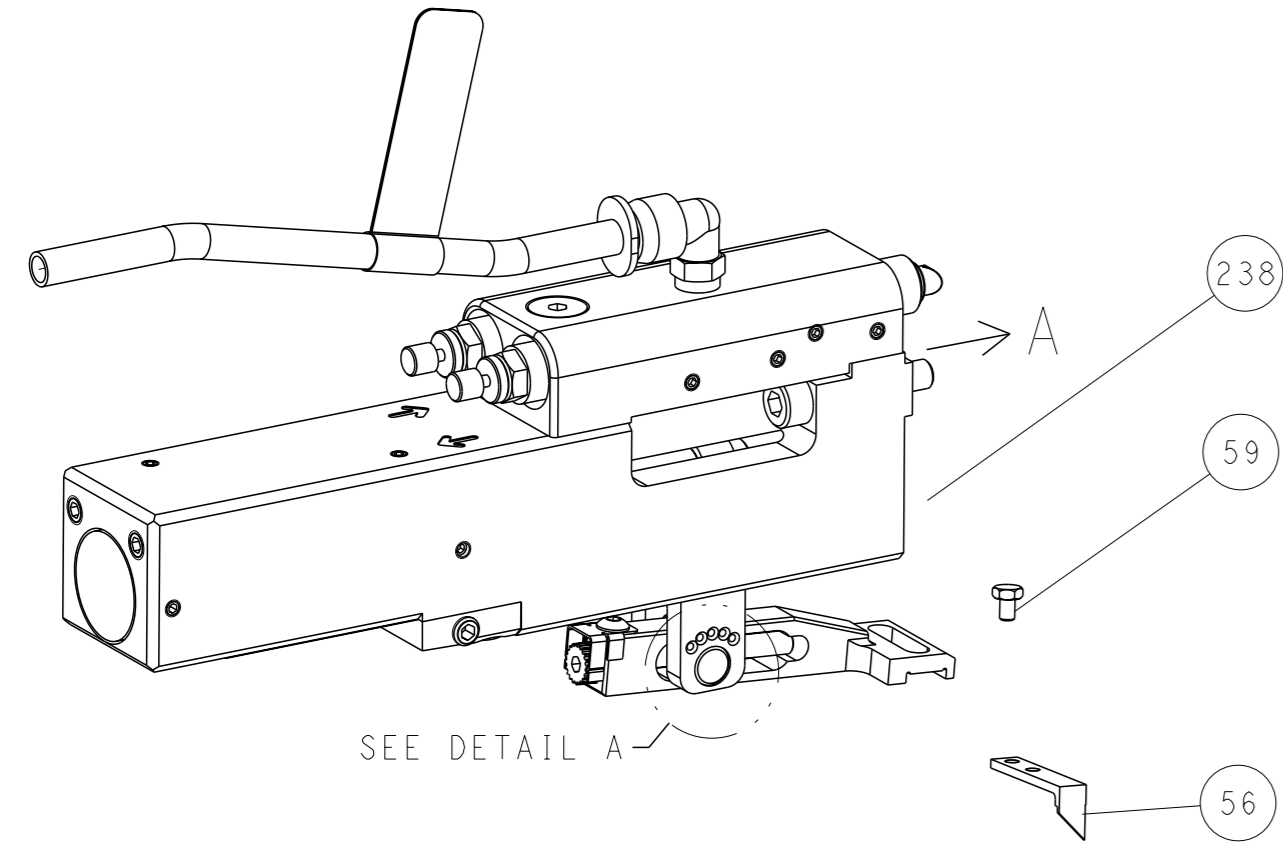
Customer Accessible Production Drawing SHEET 3 OF 4 REV D

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

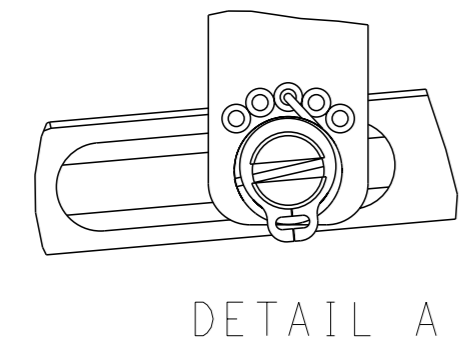
FEED TYPE MECHANICAL



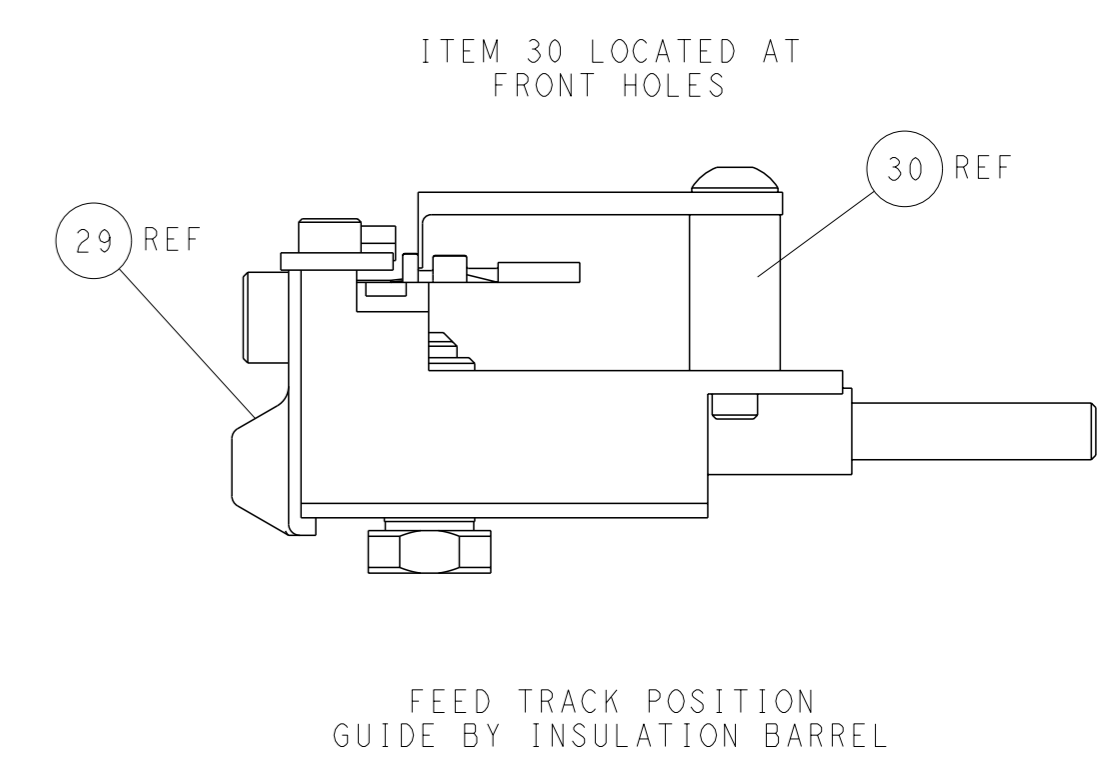
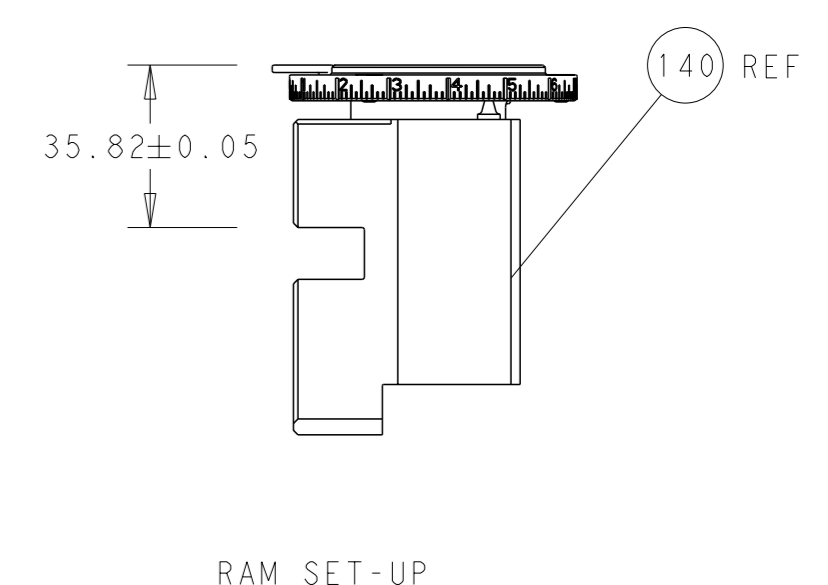
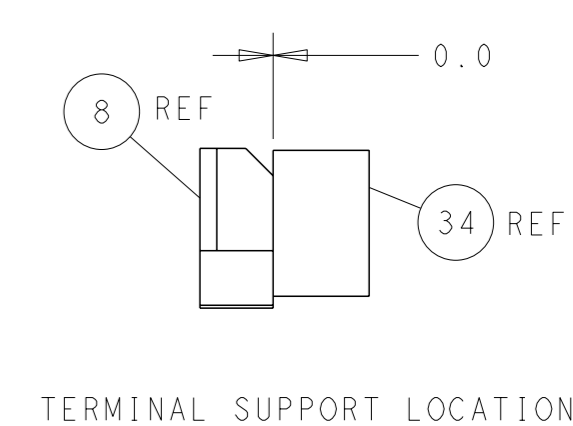
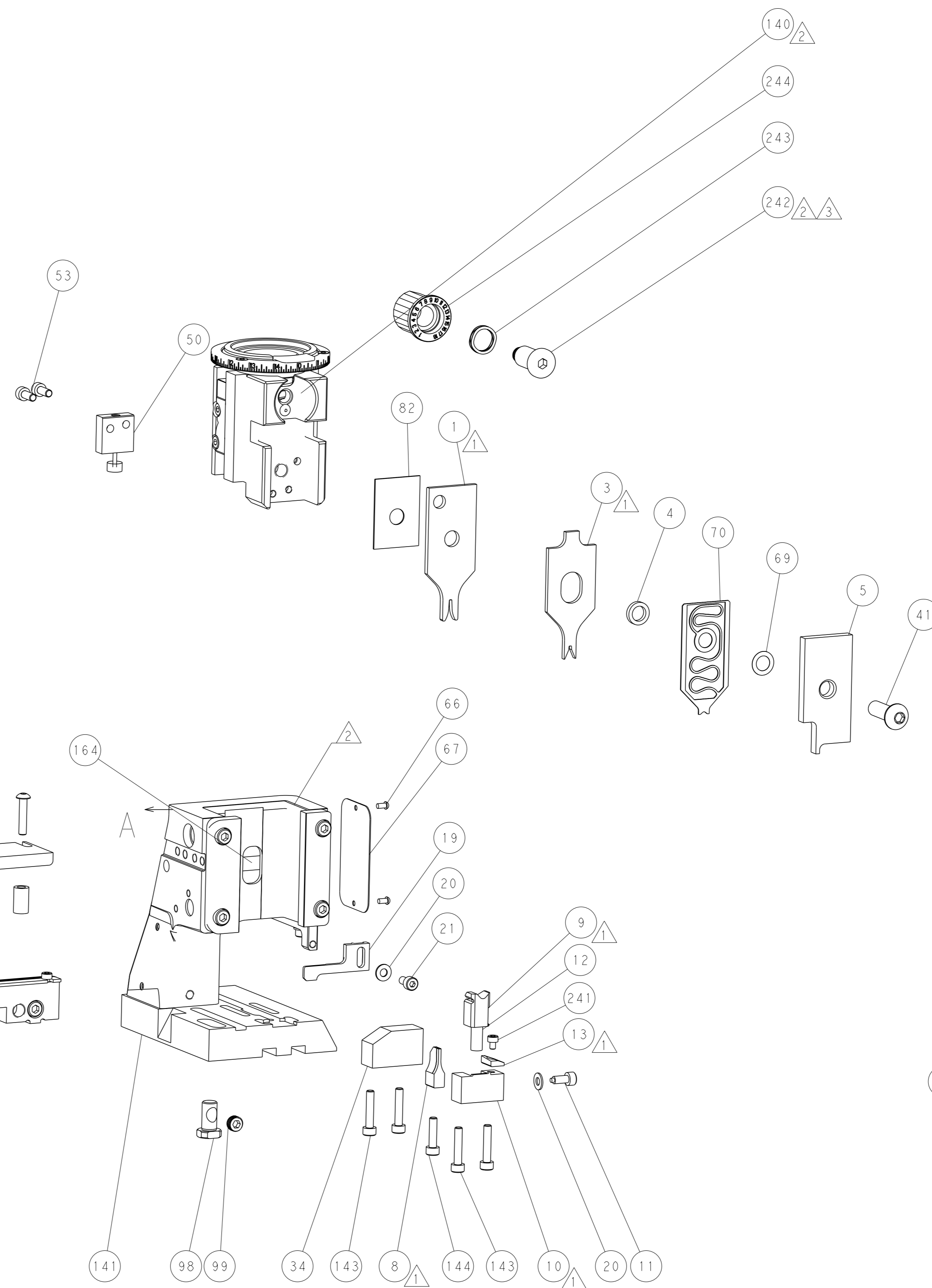
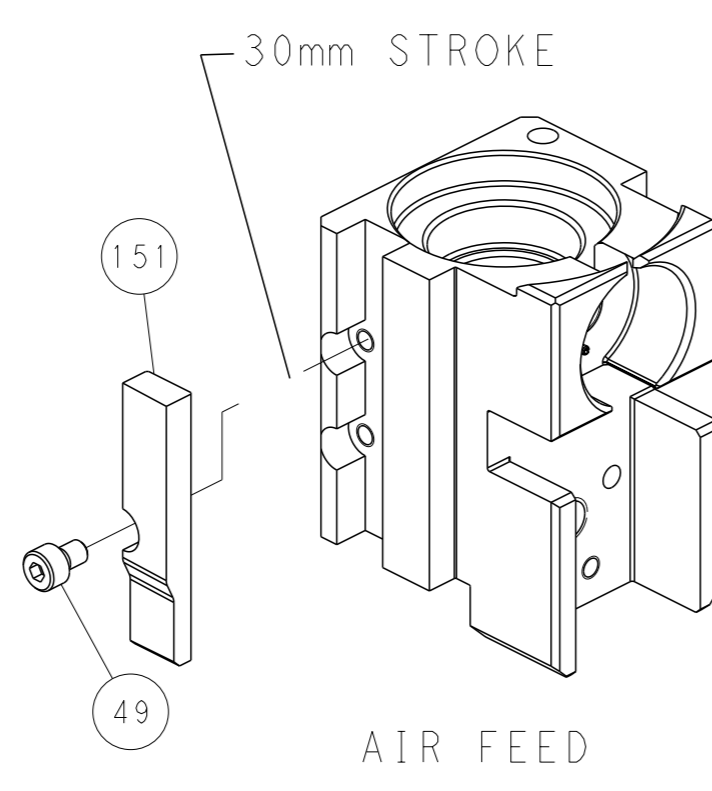
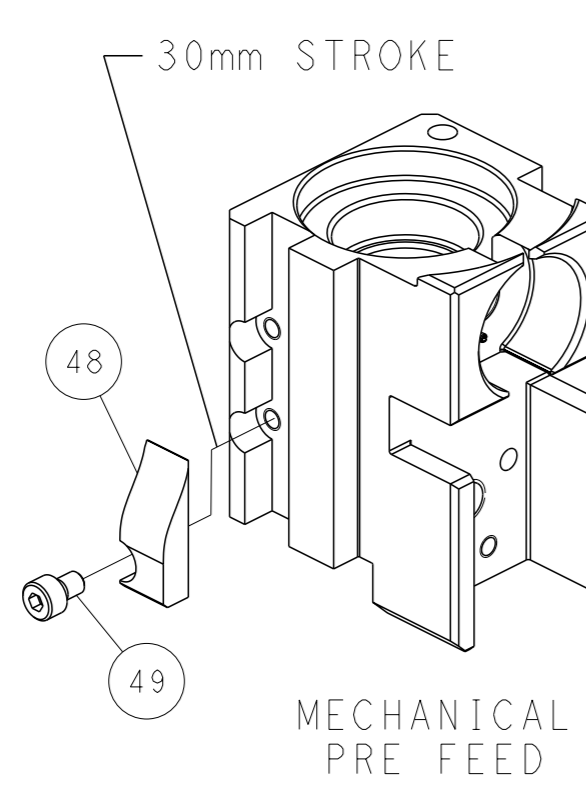
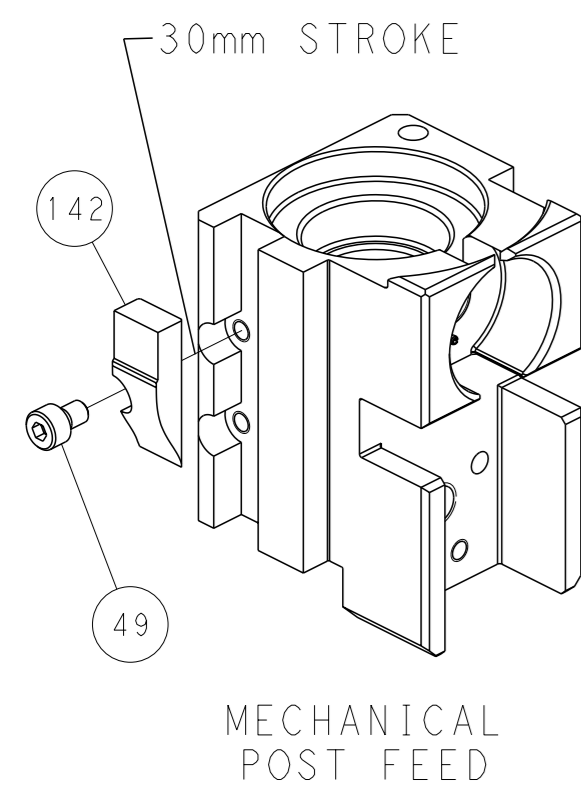
PNEUMATIC



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)

| | | | | |
|--|--|---|---|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: J. HOU CHK: L. ZHANG APVD: H. GUO | DATE: 19DEC2014 DATE: 19DEC2014 DATE: 19DEC2014 | 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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266618 | | RESTRICTED TO: |
| MATERIAL: | | WEIGHT: | | SCALE: 1:2 SHEET: 4 of 4 REV: D |