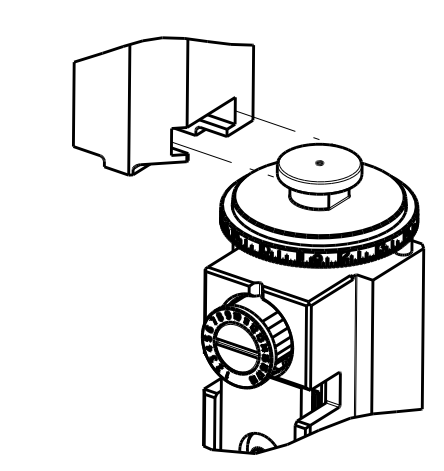


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266219-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266219-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266219-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266219-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266219-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.10-2.60 mm [.083-.102 IN]		Ø0.90-1.90 mm [.035-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	T-1-2187-D		
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
286576-1	SXH-001T-(P)0.6	286576-2	SXH-001T-0.6
4-1569314-1	SXH-001T-P0.6		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.75 +/- 0.05 [.030 +/- .002]	5.7
24 AWG	0.70 +/- 0.05 [.028 +/- .002]	6.2
26 AWG	0.65 +/- 0.05 [.026 +/- .002]	6.6
28 AWG	0.62 +/- 0.02 [.024 +/- .001]	7.0

- 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.

***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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	1		DEVELOPMENT	04MAR2014	YY	UG
		A		RELEASED	03APR2014	YY	UG
		B		ECR-17-011682	10AUG2017	TB	GB
		C		ECR-18-006669	02MAY2018	MZ	KZ

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	2-455888-3	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	1338685-1	PAWL, FEED	56	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	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	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	4-1803054-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-3	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1633962-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
-	1	2	2	1	1	5-1633713-1	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

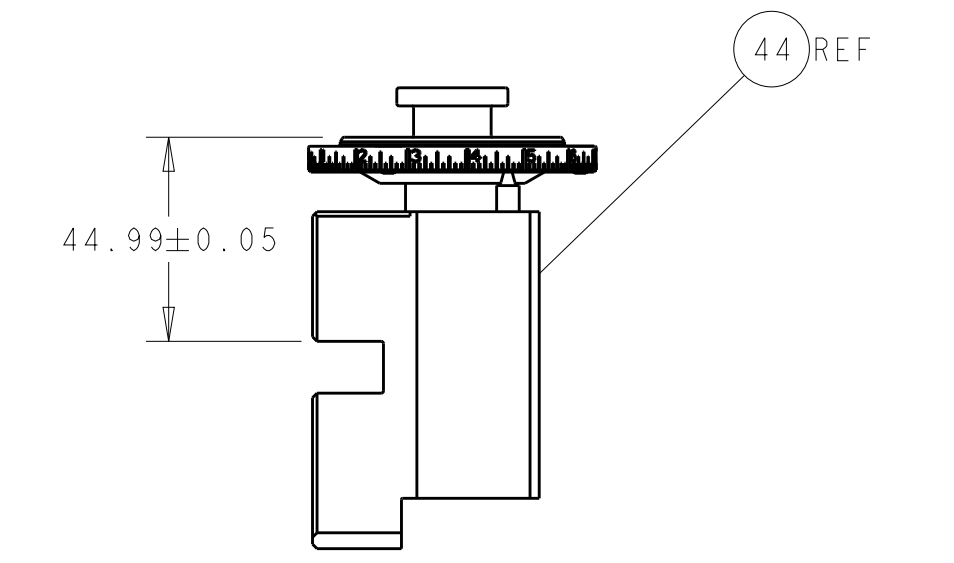
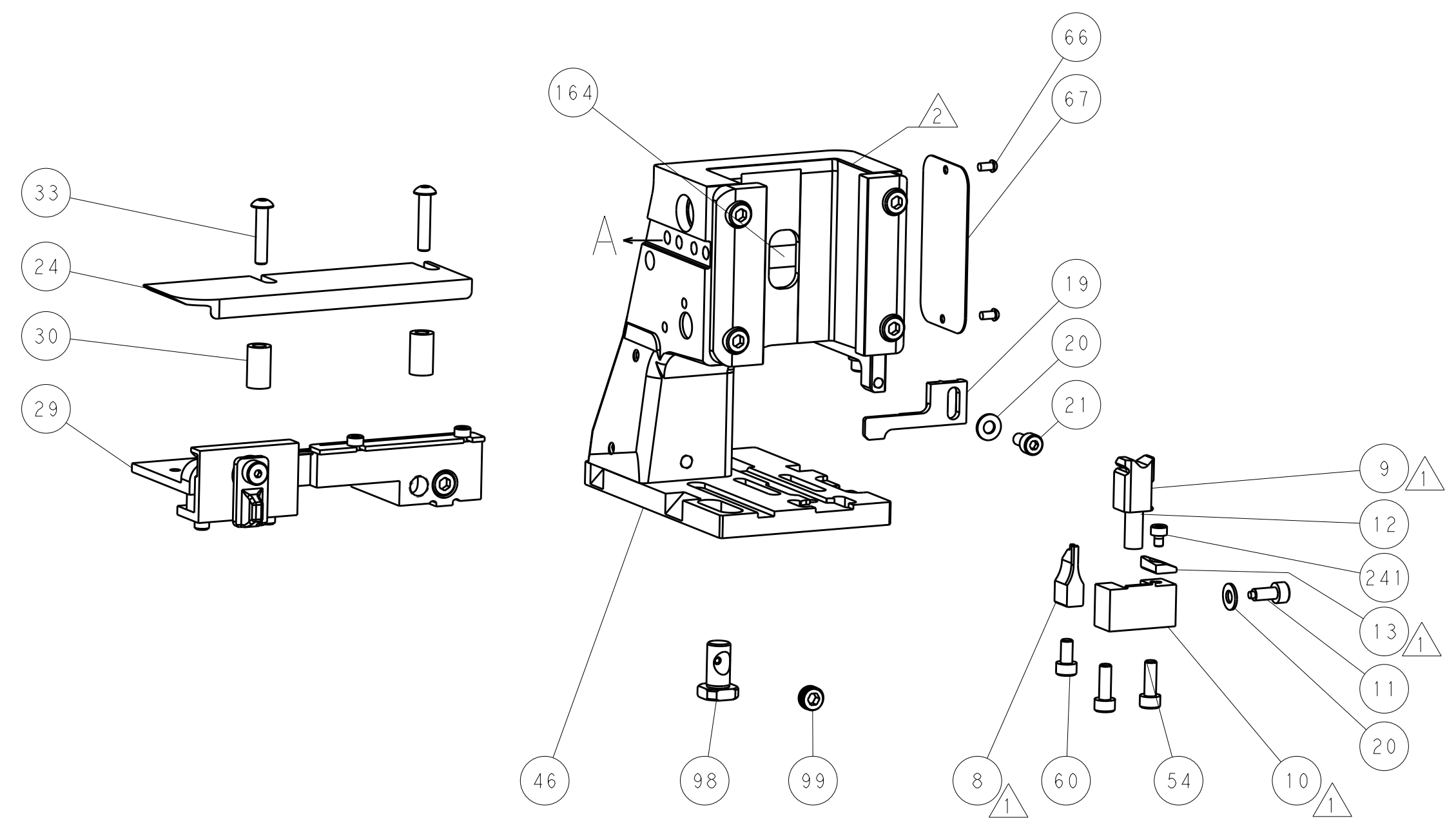
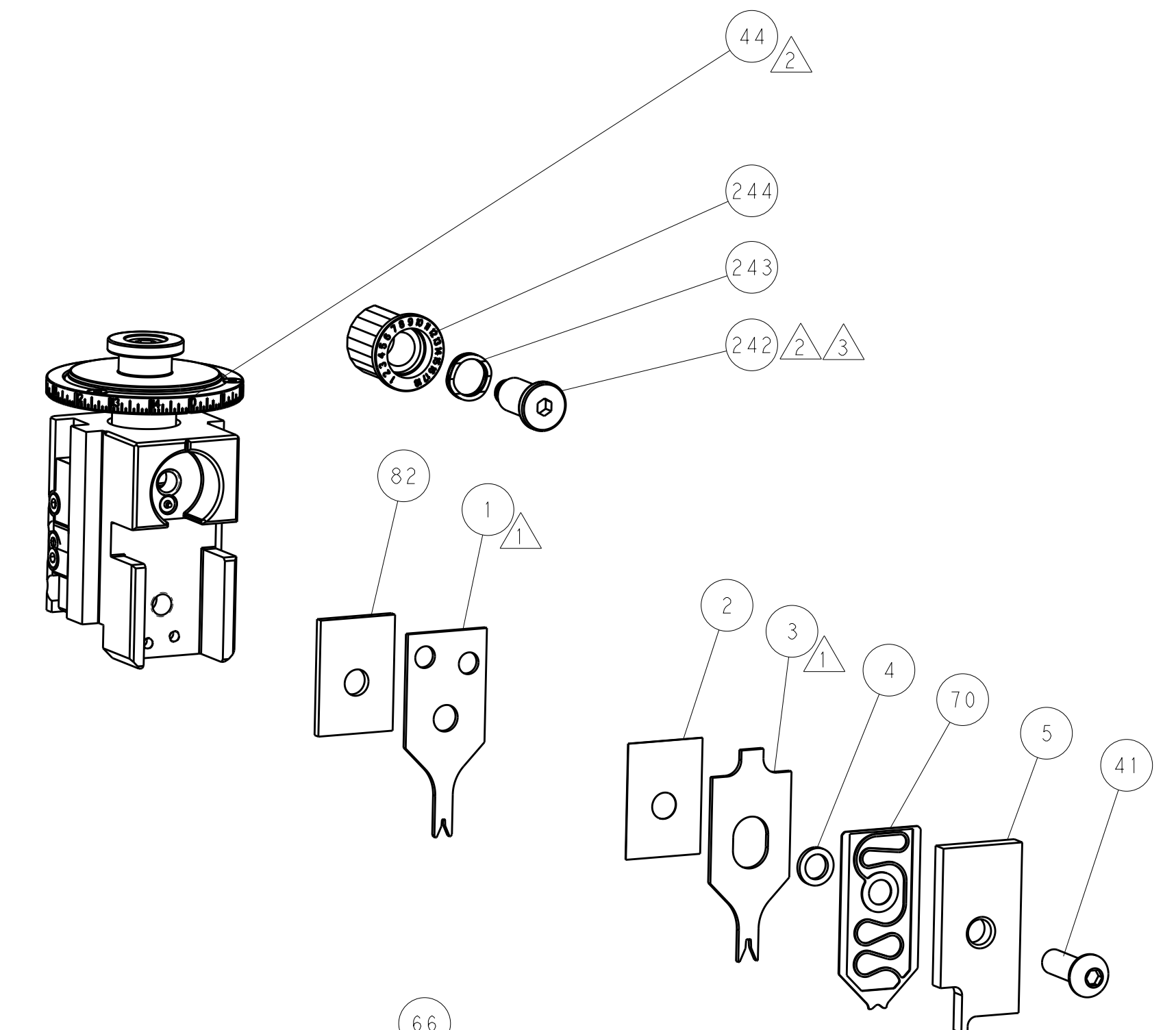
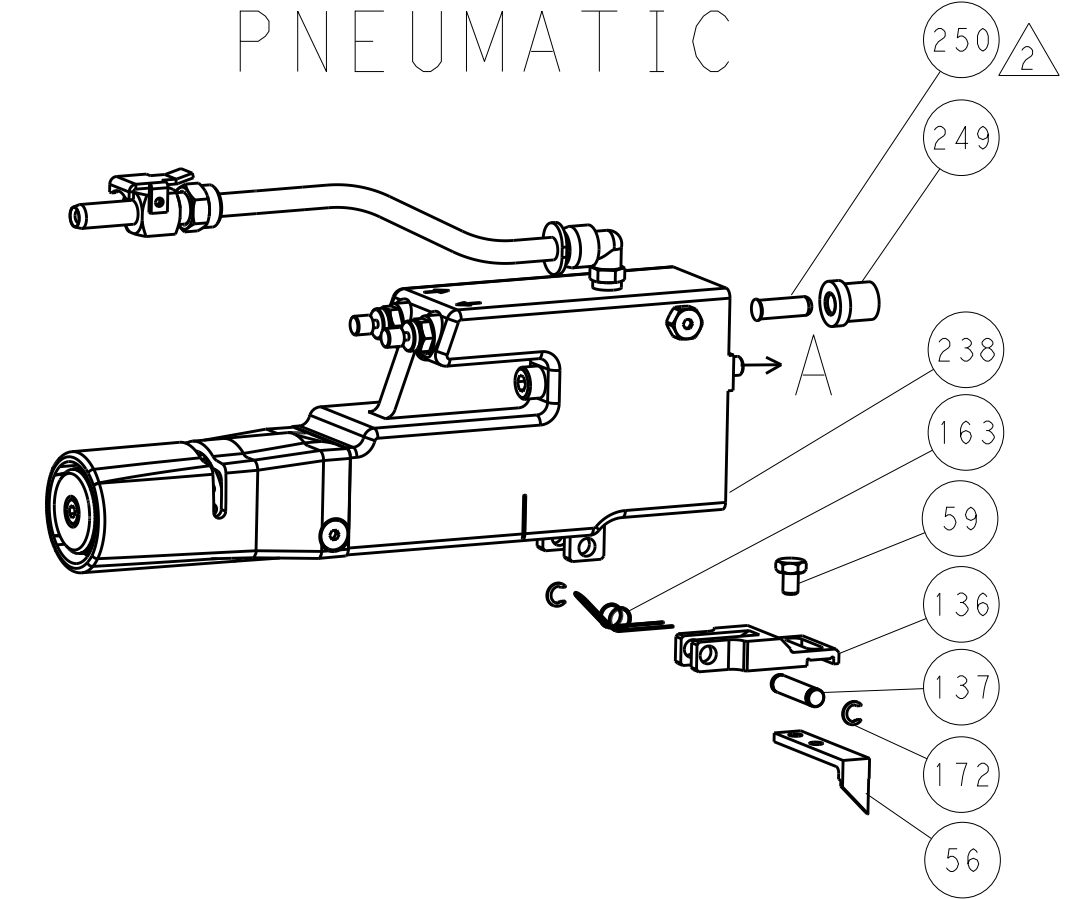
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:				
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE	1:2	SHEET	1	OF	4	REV	C

LOC		DIST		REVISIONS			
NO.	REV.	DATE	BY	DESCRIPTION	DATE	BY	APPROV.
A	66			SEE SHEET 1			

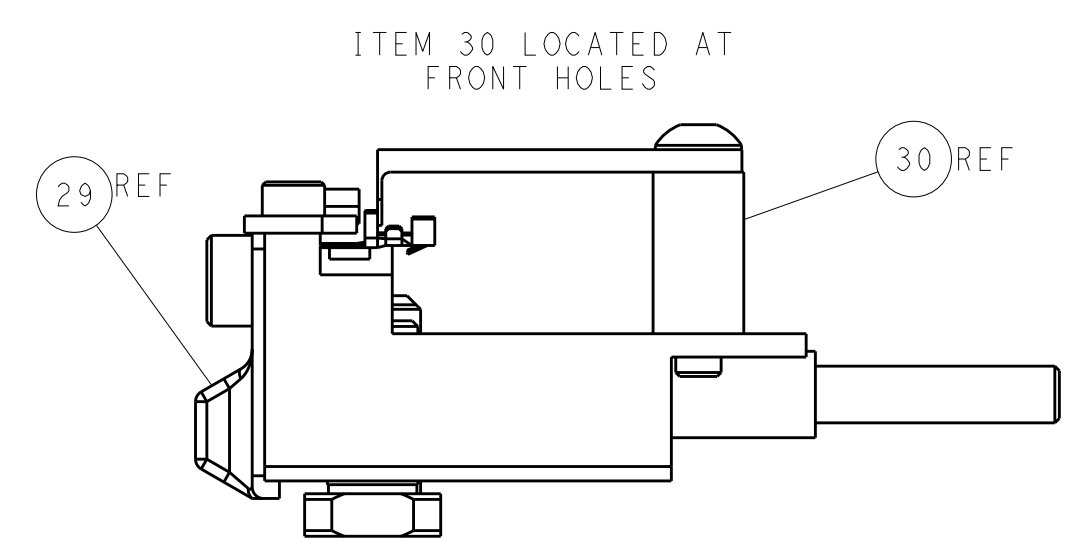
FEED TYPE MECHANICAL



PNEUMATIC

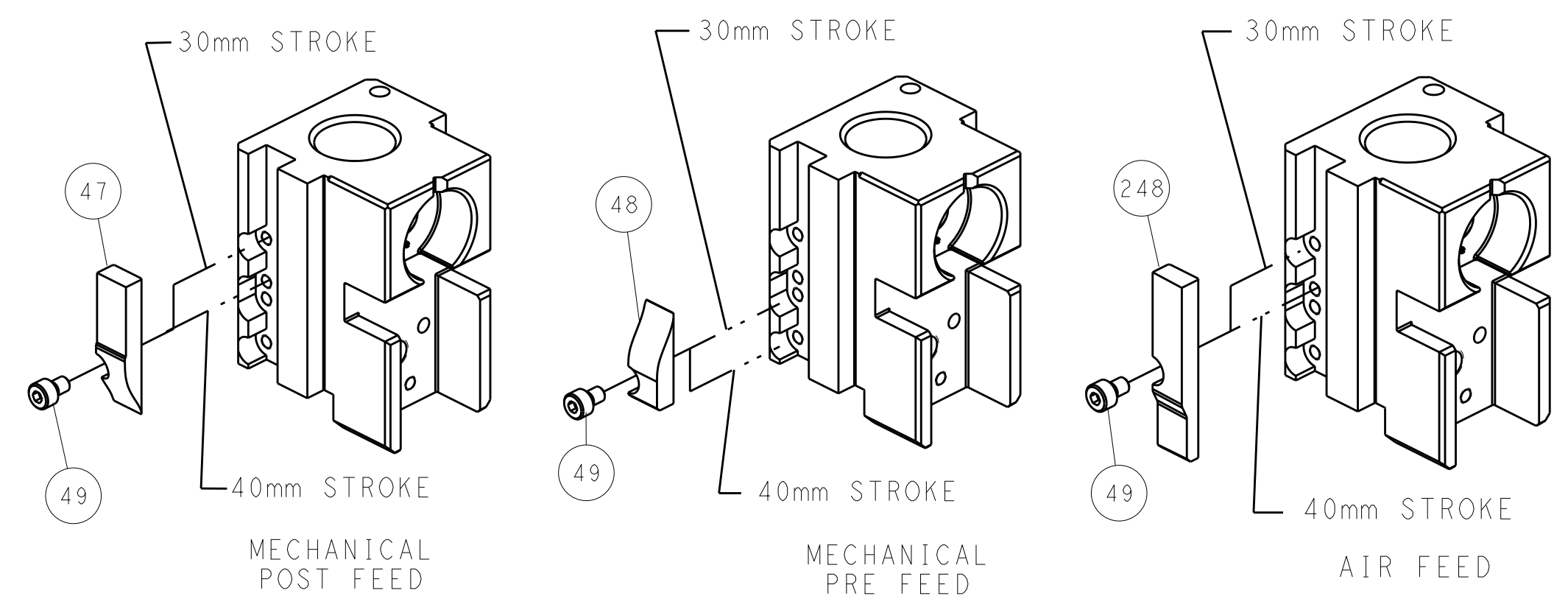


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T.YIN 04MAR2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK G.BAILEY 04MAR2014		NAME	
				APVD H.GUO 04MAR2014		Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=2266219	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV C	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266219-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266219-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266219-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 2.10-2.60 mm [.083-.102 IN]		INSULATION DIAMETER RANGE Ø0.90-1.90 mm [.035-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	T-1-2187-D	-	-
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
286576-1	SXH-001T-(P)0.6	286576-2	SXH-001T-0.6
4-1569314-1	SXH-001T-P0.6		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.75 +/- 0.05 [.030 +/- .002]	5.7
24 AWG	0.70 +/- 0.05 [.028 +/- .002]	6.2
26 AWG	0.65 +/- 0.05 [.026 +/- .002]	6.6
28 AWG	0.62 +/- 0.02 [.024 +/- .001]	7.0

- 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.
- 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	REV	DATE	BY	CHKD	APVD
A	66	-	-	-	-	-

REV	DATE	BY	CHKD	APVD	DESCRIPTION	ITEM NO
-	1	-	-	-	2119640-1 PUSH ROD, AIR FEED	250
-	1	-	-	-	1803259-1 BUSHING, FLANGED	249
-	1	1	-	-	2119082-8 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	-	-	-	2063440-1 AIR FEED MODULE	238
-	2	-	-	-	21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	-	-	994970-2 COUNTER, MAGNETIC	164
-	1	-	-	-	240638-1 SPRING, FEED FINGER	163
-	1	-	-	-	2119641-2 FEED CAM, AIR FEED	151
-	1	1	-	-	2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	144
-	2	2	-	-	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	-	-	-	3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	-	-	2119799-1 HOLDER, FEED FINGER, AF	136
-	1	1	-	-	2844908-1 SCREW, LOCKING	99
-	1	1	-	-	2844907-1 POST, LOCKING	98
-	1	1	-	-	2-455888-3 SPACER, CRIMPER	82
-	1	1	-	-	1803607-1 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
-	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
-	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	-	-	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	-	-	4-1803054-2 ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	-	-	2119757-1 DEPRESSOR, SHEAR	5
-	1	1	-	-	1-238011-3 BLOCK, CRIMPER SPACER	4
1	1	1	-	-	1633962-9 CRIMPER, INSULATION F PREMIUM	3
-	1	1	-	-	455888-1 SPACER, CRIMPER	2
1	1	1	-	-	5-1633713-1 CRIMPER, WIRE PREMIUM	1
-77	-22	-21	-	-	PART NO	ITEM NO

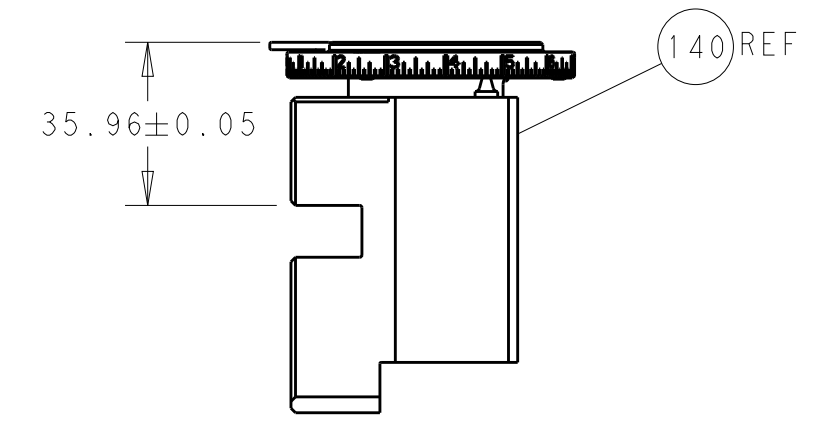
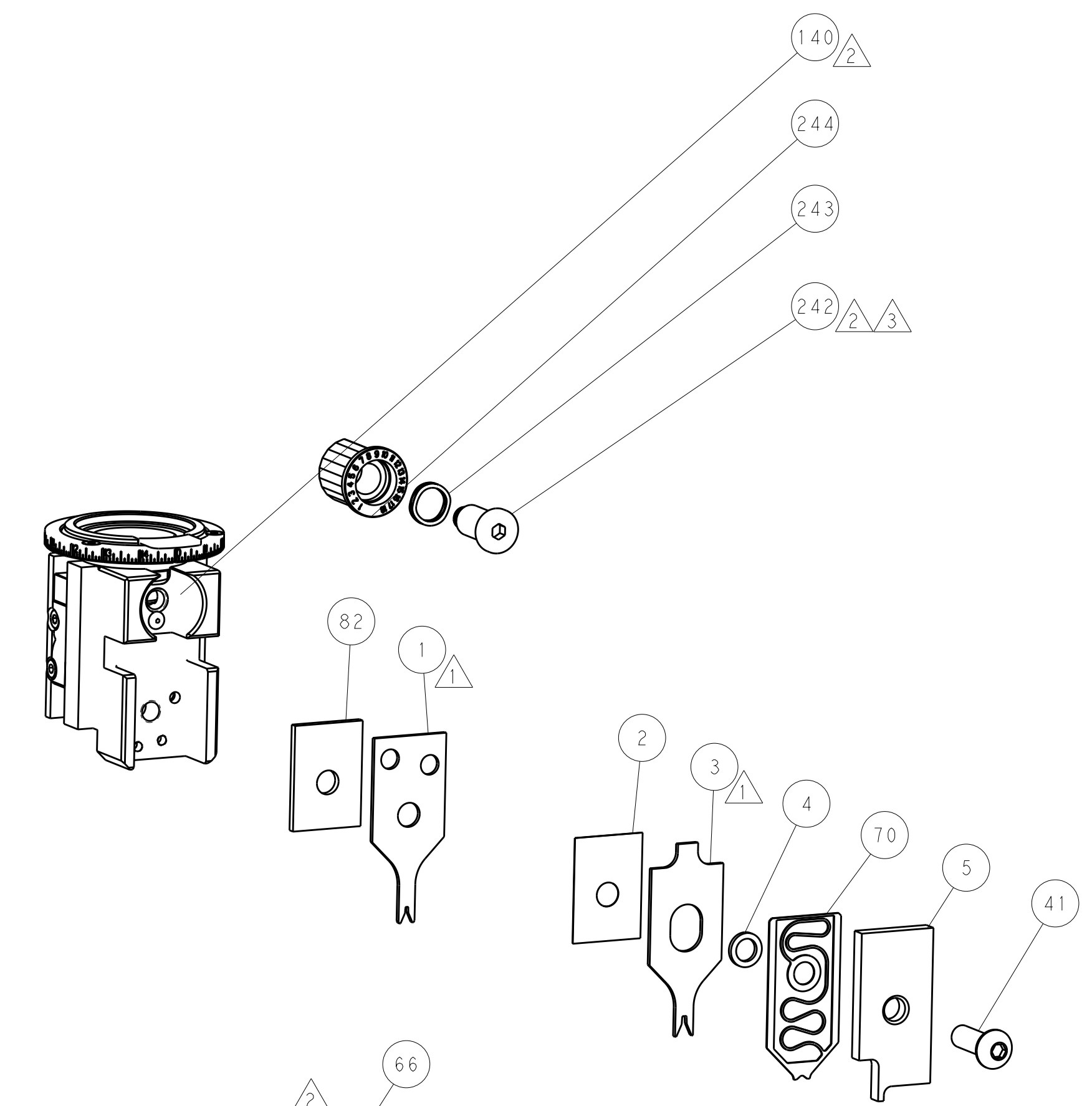
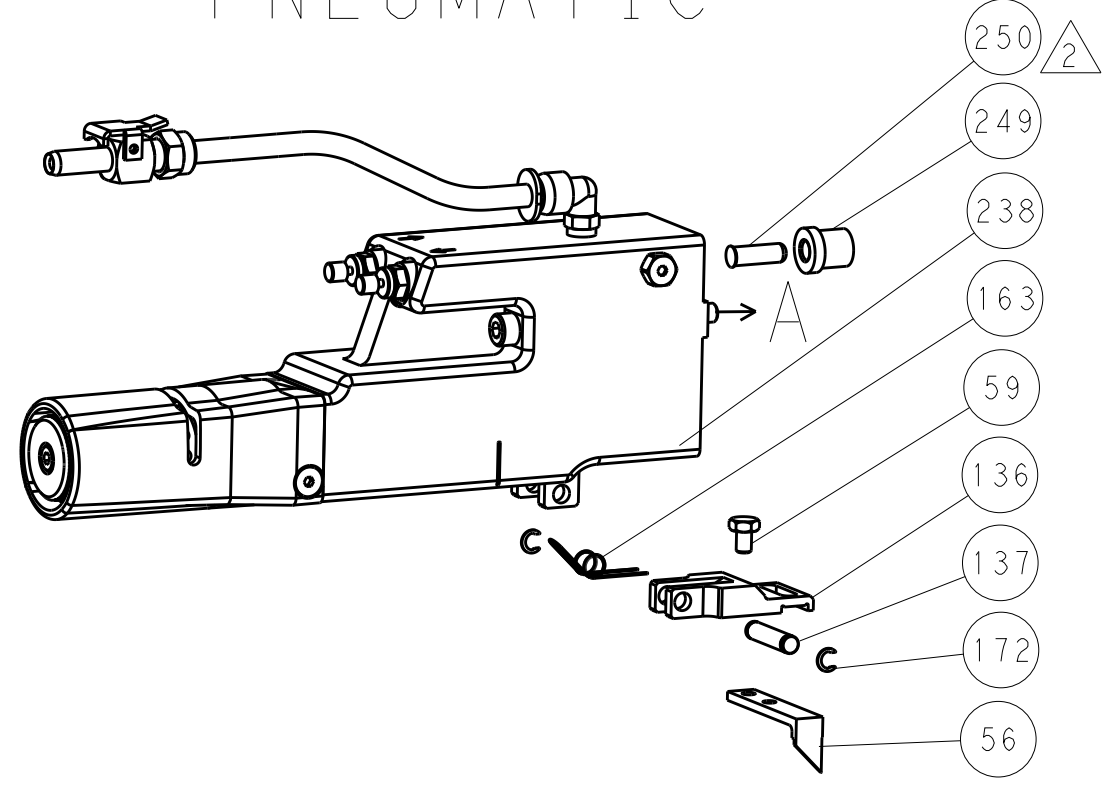
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: A1 00779 C=2266219		SHEET: 3 OF 4		REV: C	

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

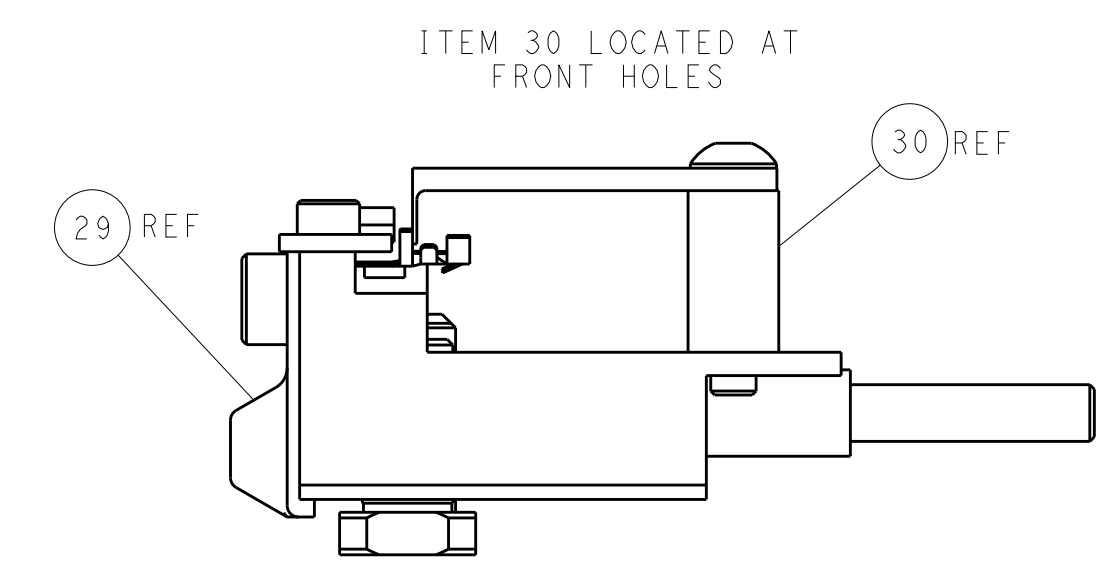
FEED TYPE MECHANICAL



PNEUMATIC

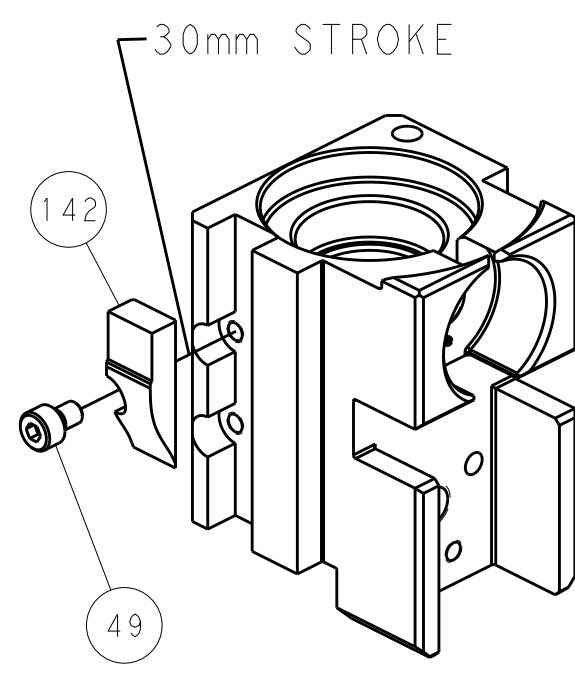


RAM SET-UP

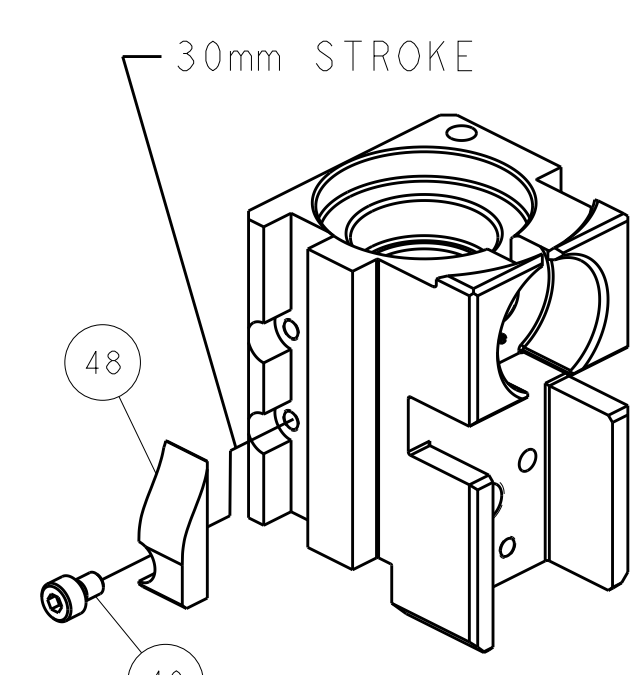


FEED TRACK POSITION GUIDE BY INSULATION BARREL

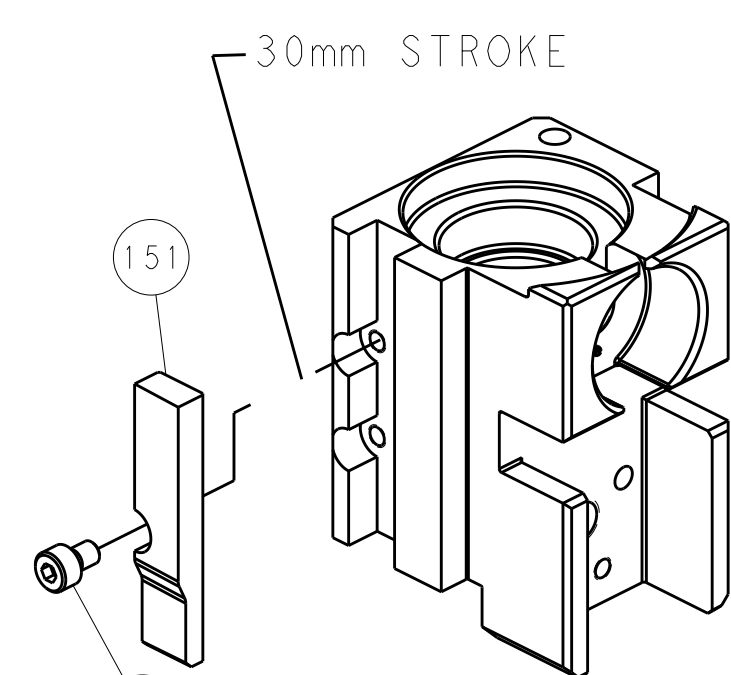
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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 04MAR2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
			1:2	A1	00779	2266219	
Customer Accessible Production Drawing				SHEET 4 OF 4		REV C	