

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266785-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266785-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266785-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266785-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266785-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	1.55 mm [.061]	F
INSUL	1.95 mm [.077]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: Molex TERMINAL MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: Terminal	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
2.54-3.18 mm [.100-.125 IN]	Ø1.24-1.65 mm [.049-.065 IN]
TERMINAL APPLICATION SPECIFICATION: ATS-638881000 Rev E	

TERMINALS APPLIED			
TE TERMINAL	MoLEx TERMINAL	TE TERMINAL	MoLEx TERMINAL
2113707-1	08-50-0018	1-2113707-6	08-58-0125
2113707-2	08-50-0061	1-2113707-7	08-59-0101
2113707-3	08-50-0065	1-2113707-8	08-60-0003
2113707-4	08-50-0107	1-2113707-9	08-65-0108
2113707-5	08-50-0111	2-2113707-0	08-65-0110
2113707-6	08-50-0133	2-2113707-1	08-65-0116
2113707-7	08-50-0504	2-2113707-2	40-01-0117
2113707-8	08-52-0116	2-2113707-3	40-07-1105
2113707-9	08-55-0105	2-2113707-4	50-29-1767
1-2113707-0	08-55-0121	2-2113707-5	50-29-1877
1-2113707-1	08-55-0123	2-2113707-6	08-04-0001
1-2113707-2	08-56-0107	2-2113707-7	08-50-0183
1-2113707-3	08-56-0121	2-2113707-8	08-52-0124
1-2113707-4	08-56-0161	2-2113707-9	08-56-0123
1-2113707-5	08-56-0162	3-2113707-0	08-56-0181
3-2113707-1	08-56-0183	3-2113707-3	08-65-0126
3-2113707-2	08-65-0121		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.35mm ²	0.99+/-0.025 [.039+/- .001]	7.9
24 AWG OR 0.20mm ²	0.94+/-0.025 [.037+/- .001]	8.4
26 AWG OR 0.12mm ²	0.89+/-0.025 [.035+/- .001]	8.9

- 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					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		B		ECR-17-001157	25JAN2017	RK	GB
		C		ECR-20-006293	30APR2020	LG	TE

-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1	1633782-1	FENCE	267
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2217068-1	BRACKET, AIR BLAST	130
-	457	457	457	457	2030758-3	TUBING, POLYURETHANE	129
-	1	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127
-	1	1	1	1	986220-2	CLAMP, CABLE, BLACK	126
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	23238-1	INSERT, COUPLING	101
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1-690487-3	GUIDE, FRONT STRIP	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	2-455888-3	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	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
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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
-	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	1803583-1	APPLICATOR BASIC ASSEMBLY, SF	46
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	45
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	43
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	36
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	1-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1-2844938-9	PLATE, STRIP GUIDE	29
-	2	2	2	2	22281-7	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	4-690754-5	DRAG, SPECIAL	25
-	1	1	1	1	1-1320928-0	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	4	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119830-8	HOLDER, SLUG BLADE	11
-	1	1	1	1	1633579-7	BLADE, SLUG	10
-	1	1	1	1	1633578-4	PLATE, REAR SHEAR	9
-	1	2	2	1	1633576-6	ANVIL, SPECIAL	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2-240641-1	SPACER	5
-	1	1	1	1	3-238009-5	BLOCK, FL CRIMPER SPACER	4
-	1	2	2	1	1-1803016-1	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	3-1633664-7	CRIMPER, WIRE	1

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

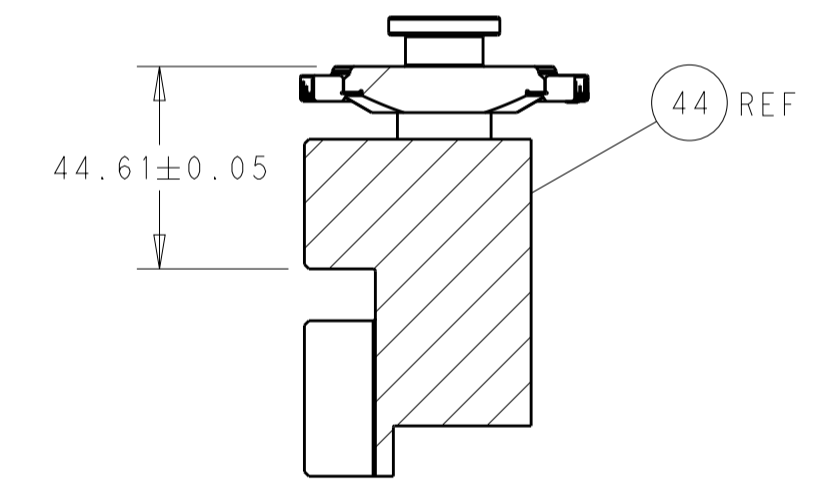
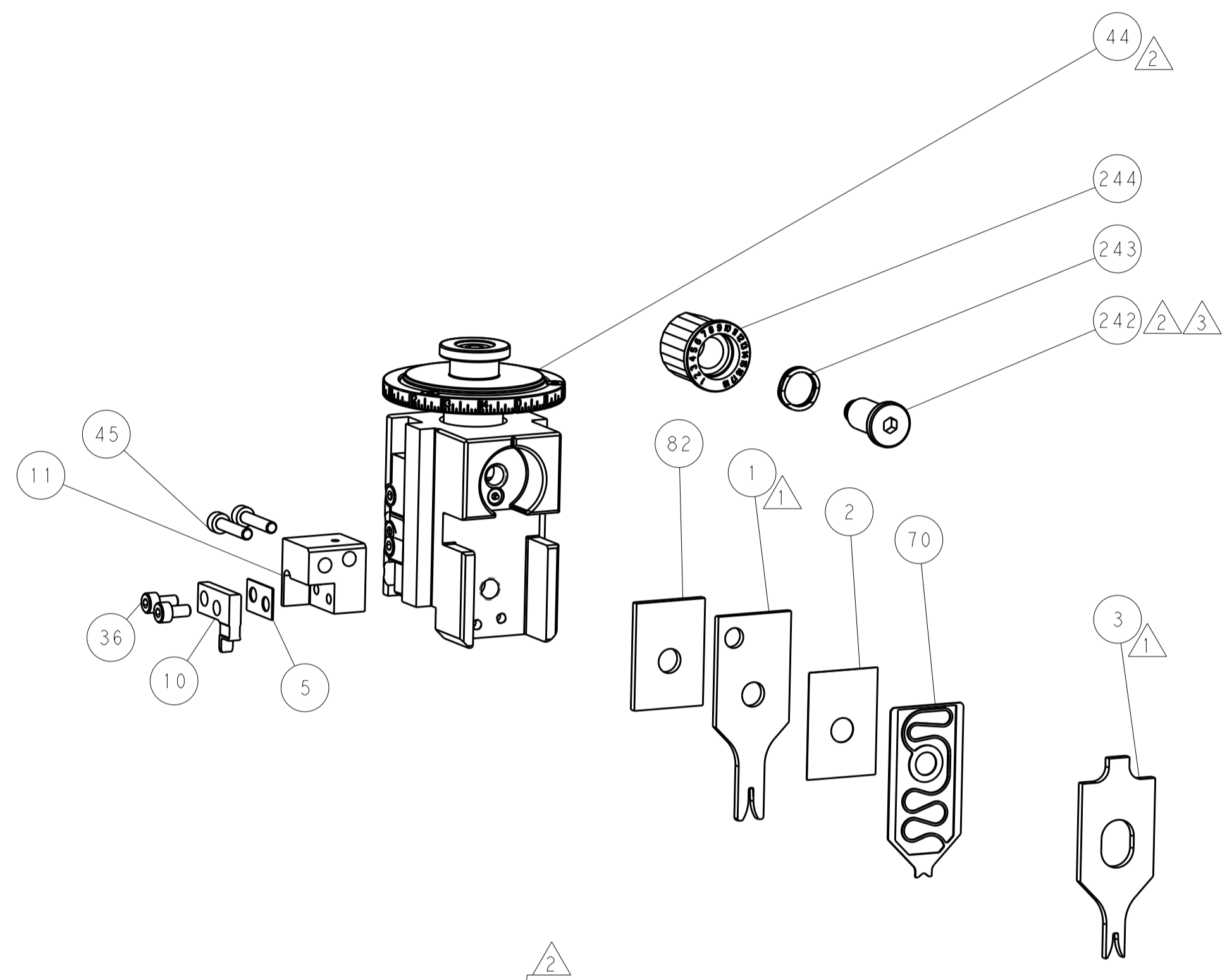
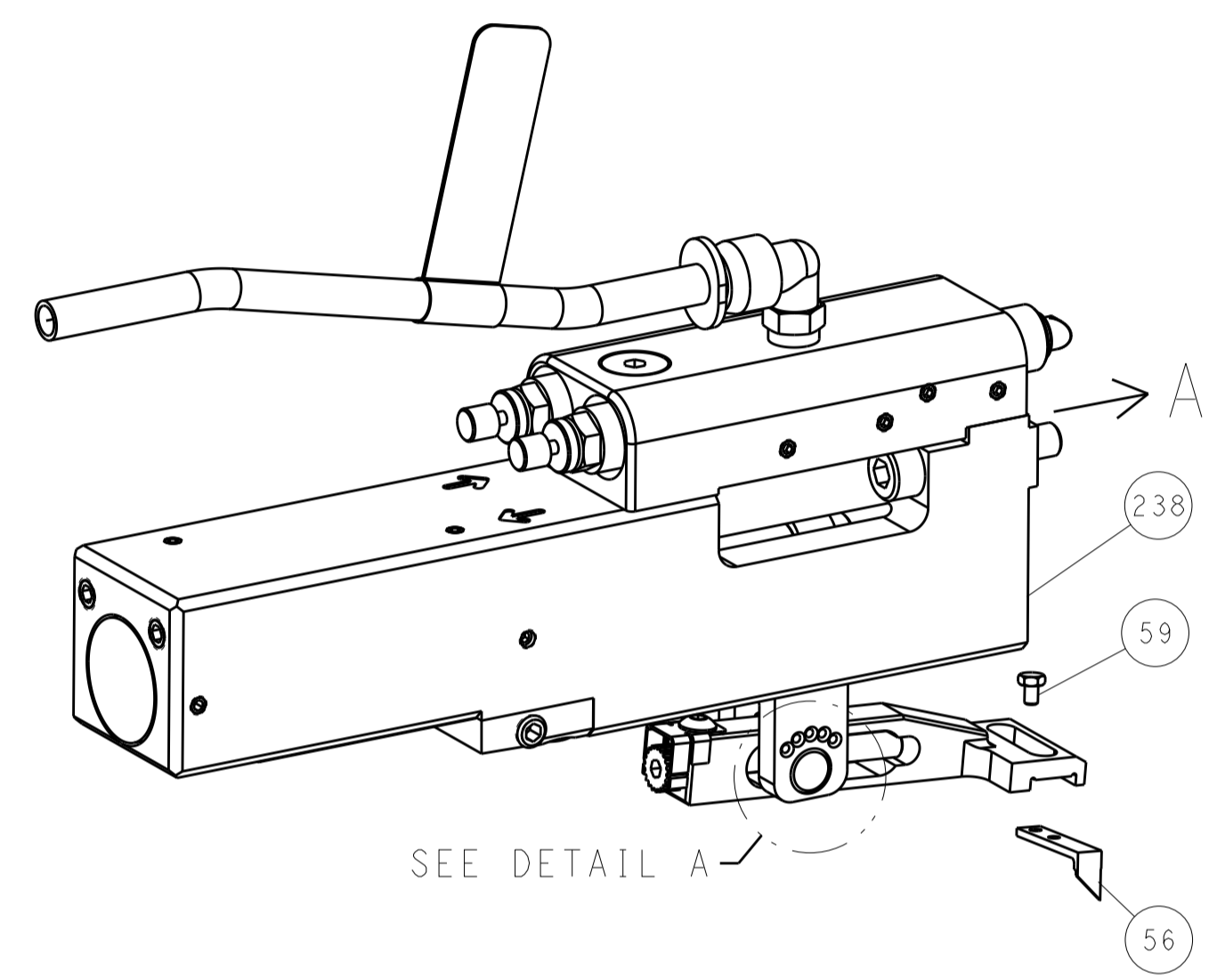
APVD	G. BAILEY	13MAY2015	NAME	Ocean Side Feed Applicator
CHK	G. BAILEY	13MAY2015	SIZE	A1
DWN	B. WEAVER	13MAY2015	CAGE CODE	00779
DATE	13MAY2015	DRAWING NO	SCALE	1:2
Customer Accessible Production Drawing		SHEET	1	OF 4
		REV	C	

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

FEED TYPE MECHANICAL

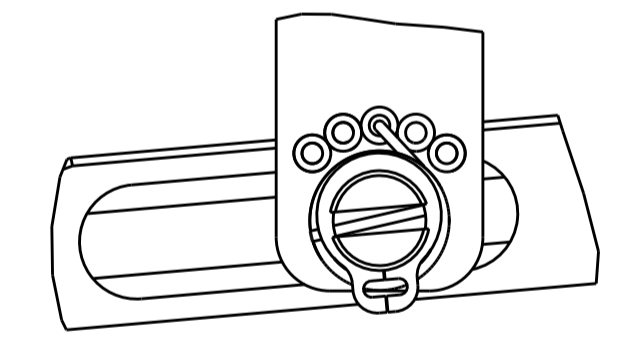


PNEUMATIC

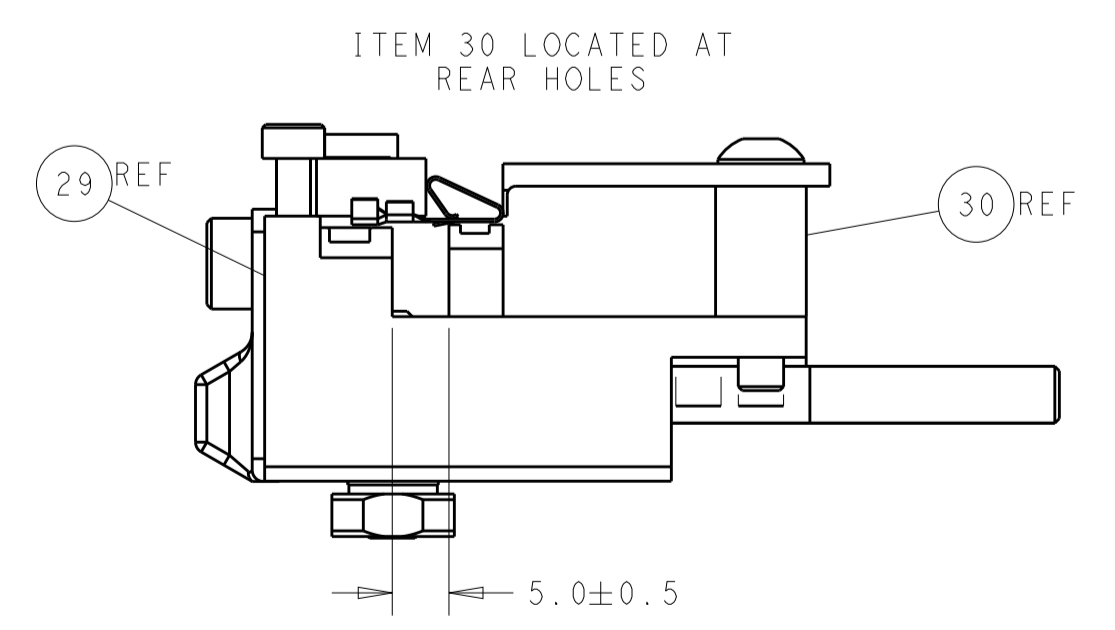
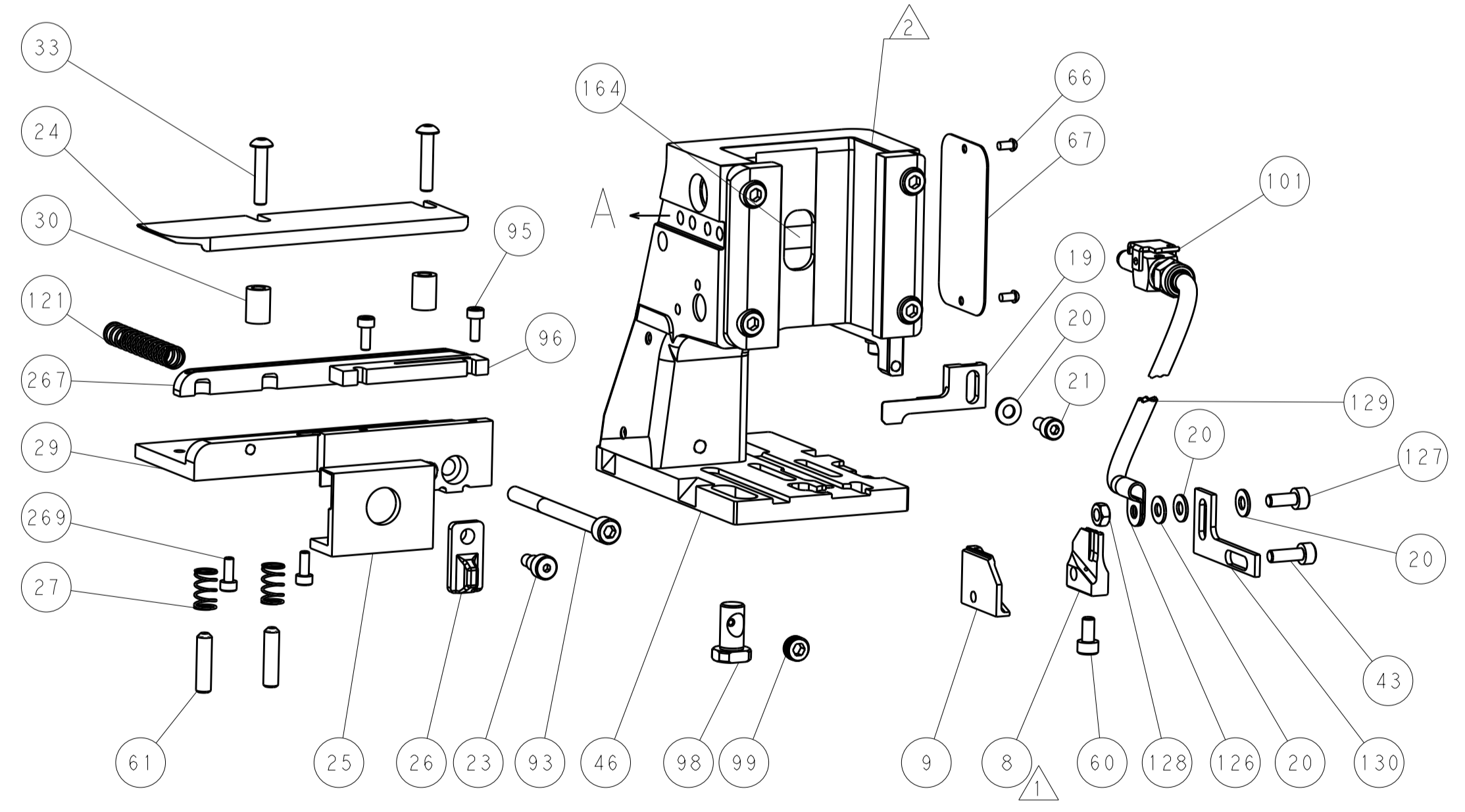


HOLDDOWN SET-UP

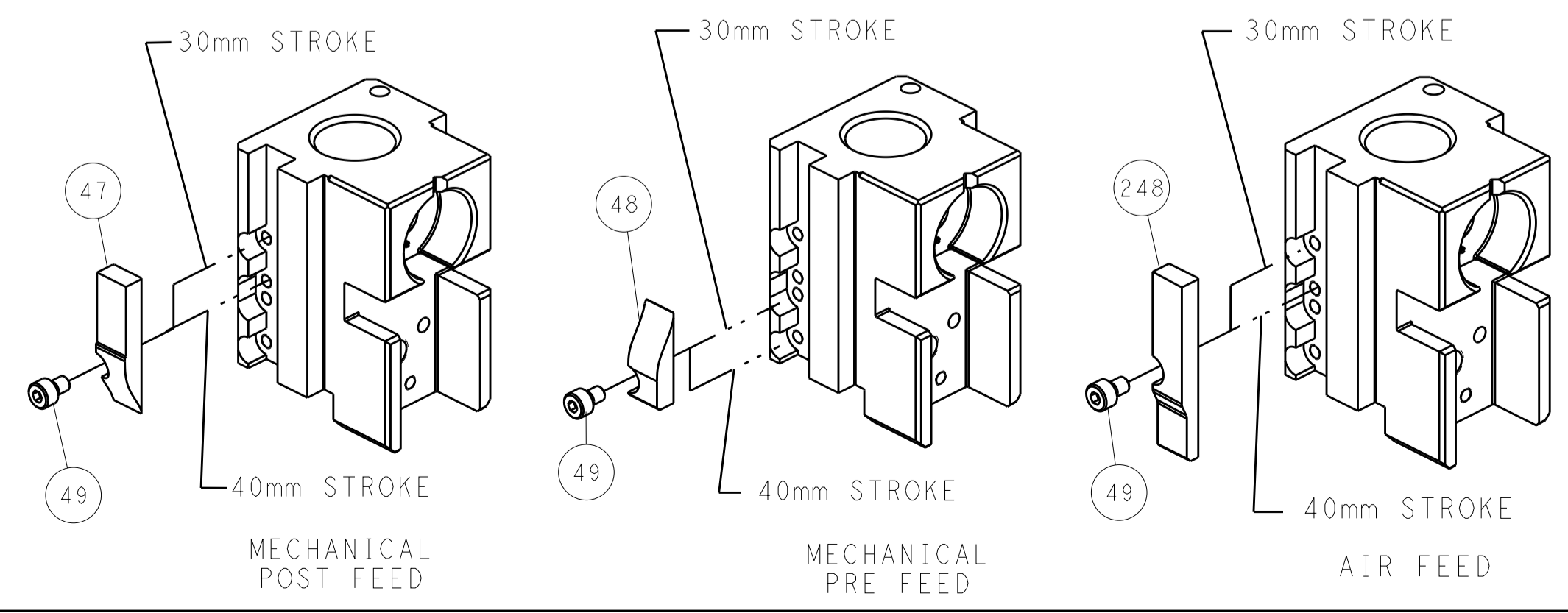
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A



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>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OR LIABILITY. REVISIONS SHOULD BE CONTACTED FOR THE LATEST POSITION.</small>		DWN: B. WEAVER 13MAY2015 CHK: G. BAILEY 13MAY2015 APVD: G. BAILEY 13MAY2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2266785	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 OF 4 REV: C
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266785-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266785-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266785-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.55 mm [.061]	F
INSUL	1.95 mm [.077]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: Molex TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: Terminal	
WIRE STRIP LENGTH 2.54-3.18 mm [.100-.125 IN]	INSULATION DIAMETER RANGE Ø1.24-1.65 mm [.049-.065 IN]
TERMINAL APPLICATION SPECIFICATION ATS-638881000 Rev E	

TERMINALS APPLIED

TE TERMINAL	Molex TERMINAL	TE TERMINAL	Molex TERMINAL
2113707-1	08-50-0018	1-2113707-6	08-58-0125
2113707-2	08-50-0061	1-2113707-7	08-59-0101
2113707-3	08-50-0065	1-2113707-8	08-60-0003
2113707-4	08-50-0107	1-2113707-9	08-65-0108
2113707-5	08-50-0111	2-2113707-0	08-65-0110
2113707-6	08-50-0133	2-2113707-1	08-65-0116
2113707-7	08-50-0504	2-2113707-2	40-01-0117
2113707-8	08-52-0116	2-2113707-3	40-07-1105
2113707-9	08-55-0105	2-2113707-4	50-29-1767
1-2113707-0	08-55-0121	2-2113707-5	50-29-1877
1-2113707-1	08-55-0123	2-2113707-6	08-04-0001
1-2113707-2	08-56-0107	2-2113707-7	08-50-0183
1-2113707-3	08-56-0121	2-2113707-8	08-52-0124
1-2113707-4	08-56-0161	2-2113707-9	08-56-0123
1-2113707-5	08-56-0162	3-2113707-0	08-56-0181
3-2113707-1	08-56-0133	3-2113707-3	08-65-0126
3-2113707-2	08-65-0121		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.35mm ²	0.99 +/- 0.025 [.039 +/- .001]	7.9
24 AWG OR 0.20mm ²	0.94 +/- 0.025 [.037 +/- .001]	8.4
26 AWG OR 0.12mm ²	0.89 +/- 0.025 [.035 +/- .001]	8.9



- 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	APPD
A	66				

REV	DATE	DESCRIPTION	ITEM NO		
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1633782-1	FENCE	267	
-	1	2119082-5	CAM, SWAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	2844940-1	AIR FEED MODULE	238	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	151	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	1803583-2	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	2217068-1	BRACKET, AIR BLAST	130	
-	457	2030758-3	TUBING, POLYURETHANE	129	
-	1	5018030-2	NUT, HEX, REG, RoHS, M4	128	
-	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127	
-	1	986220-2	CLAMP, CABLE, BLACK	126	
-	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	23238-1	INSERT, COUPLING	101	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	1-690487-3	GUIDE, FRONT STRIP	96	
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	2-455888-3	SPACER, CRIMPER	82	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	2119791-5	DEPRESSOR, WIRE	70	
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1338685-1	PAWL, FEED	56	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	2119652-1	FEED CAM, PRE FEED	48	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	45	
-	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	43	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	36	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	1-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1-2844938-9	PLATE, STRIP GUIDE	29	
-	2	22281-7	SPRING, COMPRESSION	27	
-	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	4-690754-5	DRAG, SPECIAL	25	
-	1	1-1320928-0	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	
-	4	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	2119533-4	STRIPPER, SIDE FEED	19	
-	1	2119830-8	HOLDER, SLUG BLADE	11	
-	1	1633579-7	BLADE, SLUG	10	
-	1	1633578-4	PLATE, REAR SHEAR	9	
-	1	1633576-6	ANVIL, SPECIAL	8	
-	-	-	-	7	
-	-	-	-	6	
-	1	2-240641-1	SPACER	5	
-	1	3-238009-5	BLOCK, FL CRIMPER SPACER	4	
-	1	6-1803016-1	CRIMPER, INSULATION F	3	
-	1	455888-1	SPACER, CRIMPER	2	
-	1	3-1633664-7	CRIMPER, WIRE	1	
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

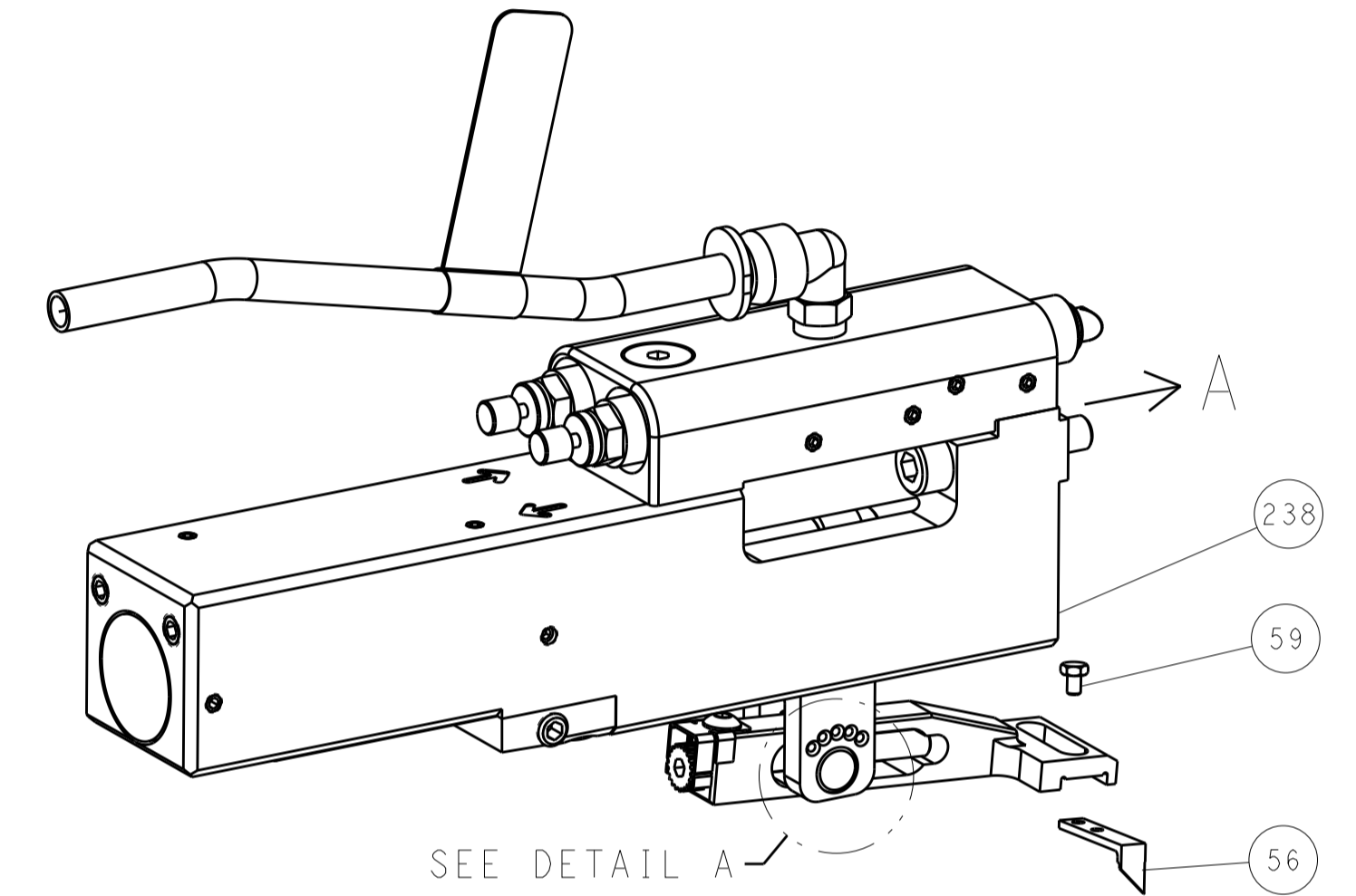
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: B. WEAVER 13MAY2015 CHK: G. BAILEY 13MAY2015 APVD: G. BAILEY 13MAY2015	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266785 SCALE: 1:2 SHEET: 3 OF 4 REV: C
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LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

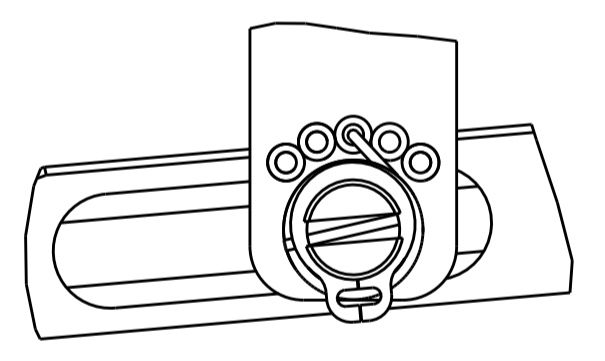
FEED TYPE MECHANICAL



PNEUMATIC

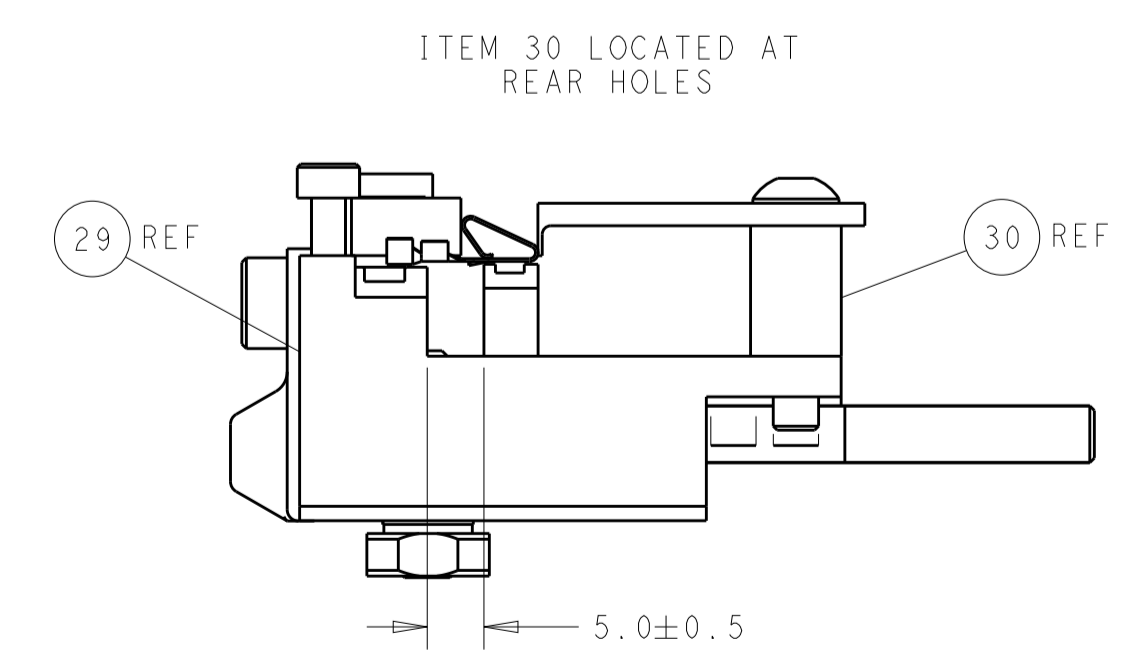
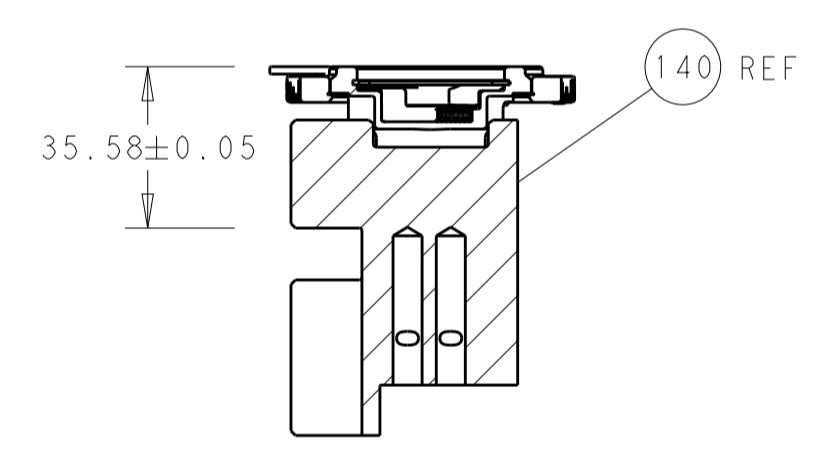
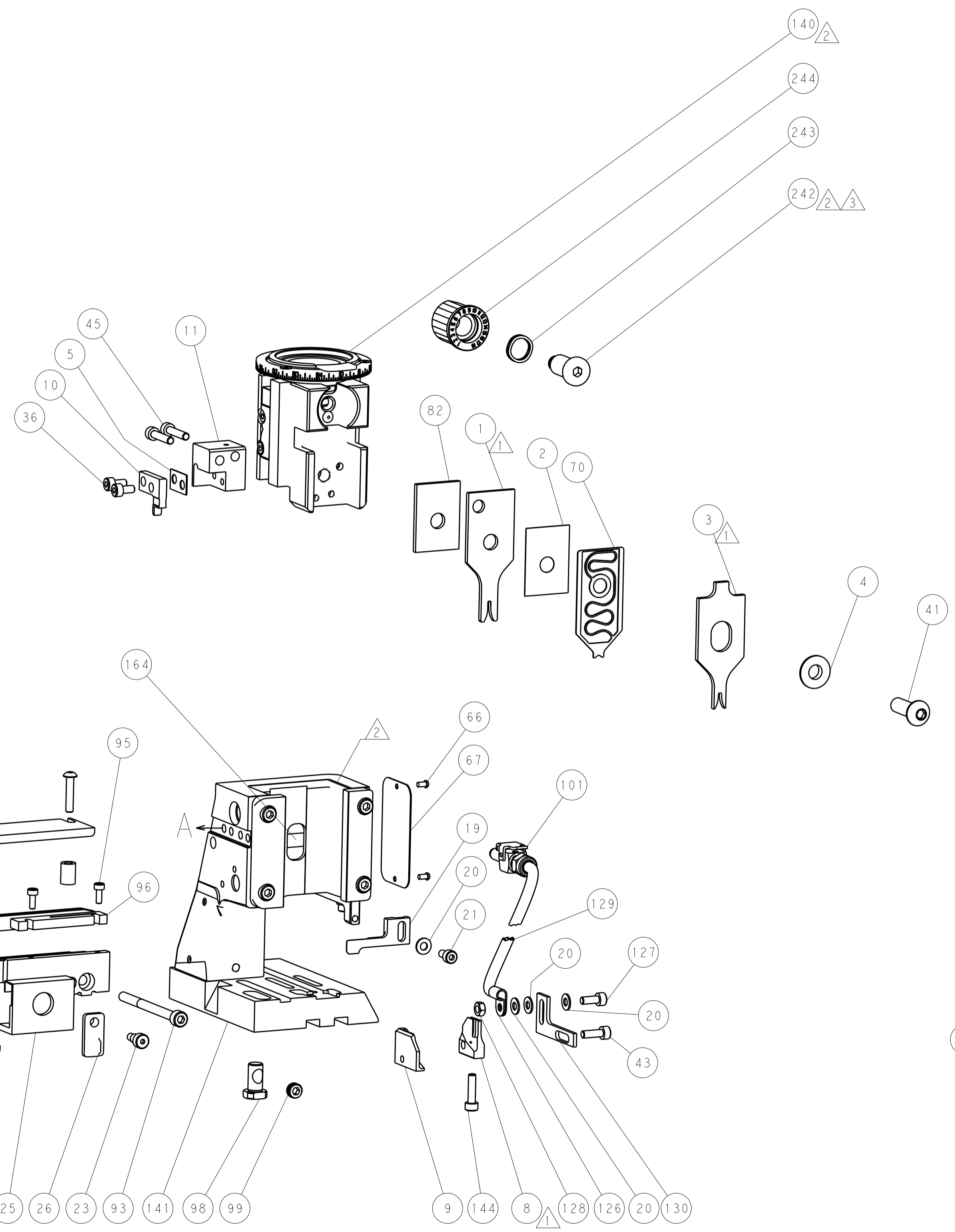
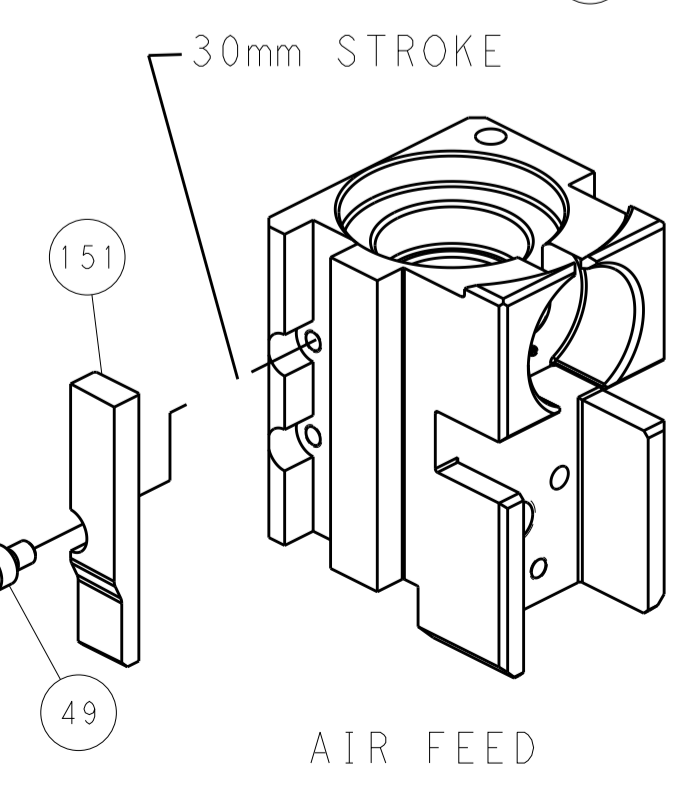
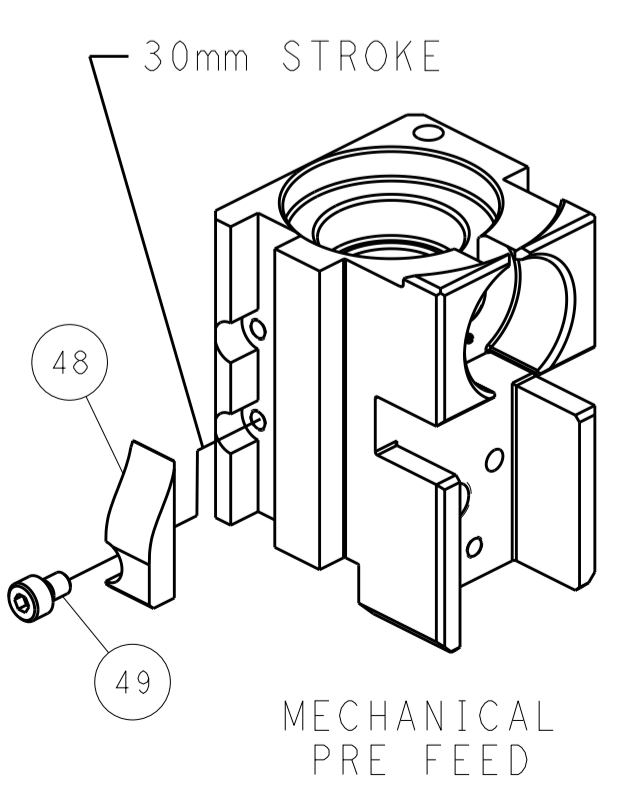
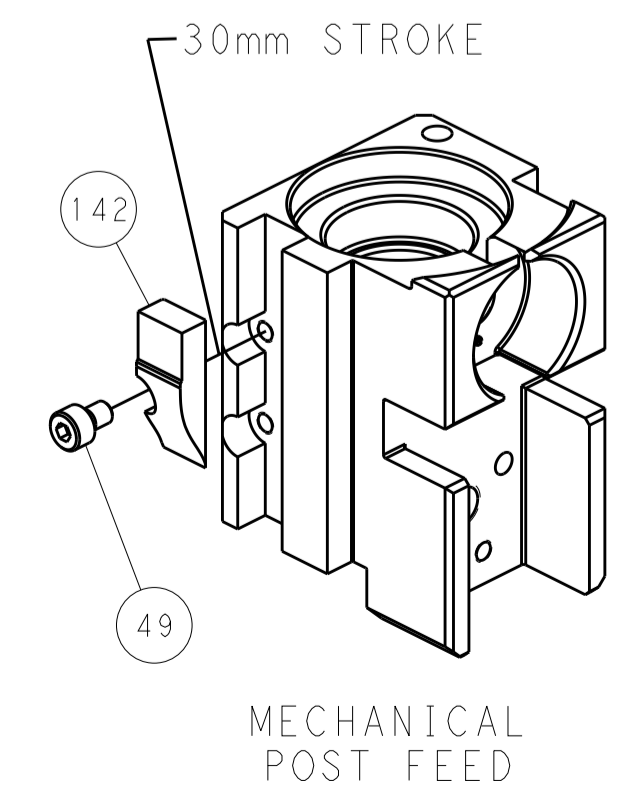


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS



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 13MAY2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK: G. BAILEY 13MAY2015		NAME: Ocean Side Feed Applicator	
MATERIAL:				APVD: G. BAILEY 13MAY2015		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
				PRODUCT SPEC:		A1 00779 ©=2266785	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2 SHEET 4 OF 4 REV C	