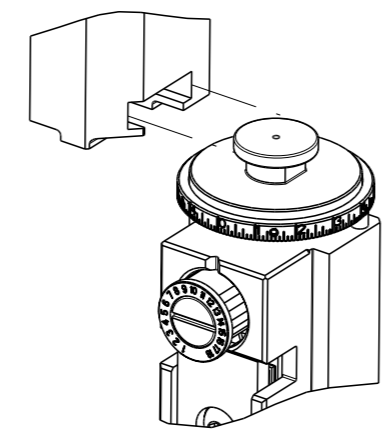


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266231-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266231-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266231-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266231-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266231-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

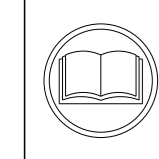


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.70 mm [.067]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: MX 64 SAE RECEPTACLE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.90-4.50 mm [.154-.177 IN]		Ø1.47-1.65 mm [.058-.065 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572968-1	33467-0004	1572968-3	34736-1001
1572968-2	33468-0002		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.36mm2	0.95+/-0.05 [.037+/- .002]	5.5



- 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.

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	CHK
		A	RELEASE	25APR2014	XZ GB
		B	ECR-20-014813	19OCT2020	TB RK
		C	ECR-20-016432	18NOV2020	JWC RK

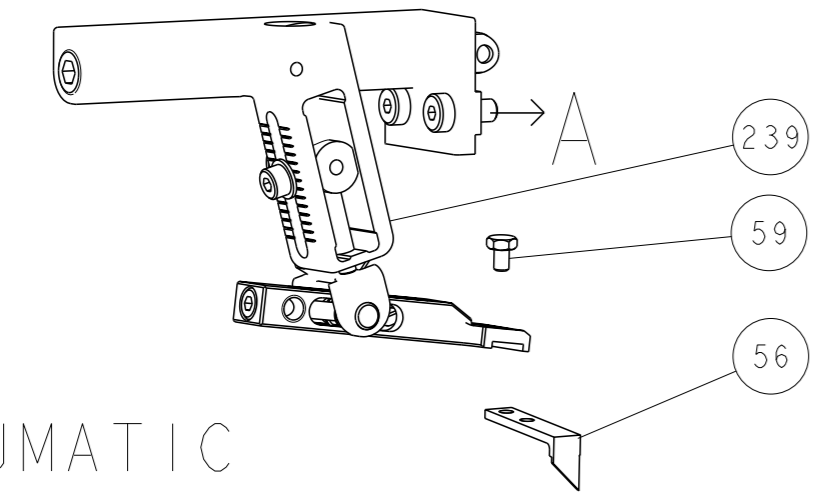
REV	DATE	BY	CHK	DESCRIPTION	ITEM NO			
-	1	-	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242		
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241		
-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239		
-	1	-	1	2844940-1	AIR FEED MODULE	238		
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119		
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113		
-	1	1	1	2844908-1	SCREW, LOCKING	99		
-	1	1	1	2844907-1	POST, LOCKING	98		
-	1	1	1	1-455888-0	SPACER, CRIMPER	82		
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71		
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70		
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67		
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66		
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60		
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59		
-	1	1	1	1338685-1	PAWL, FEED	56		
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54		
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53		
-	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50		
-	1	2	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	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46		
-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44		
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41		
-	1	1	1	1752356-6	SUPPORT, TERMINAL	34		
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33		
-	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30		
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29		
-	1	1	1	1-455888-0	SPACER, CRIMPER	28		
-	1	1	1	1320928-2	STRIP GUIDE	24		
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21		
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20		
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19		
-	1	1	1	2119806-1	INSERT, SHEAR	13		
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12		
-	1	1	1	1-356885-4	STOP, SHEAR	11		
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10		
-	1	1	1	1804709-2	FLOATING SHEAR, FRONT	9		
-	1	2	2	1803153-2	ANVIL, COMBINATION	8		
-	-	-	-	-	-	7		
-	-	-	-	-	-	6		
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5		
-	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4		
-	1	2	2	6-2119784-7	CRIMPER, INSULATION O PREMIUM	3		
-	1	1	1	455888-6	SPACER, CRIMPER	2		
-	1	2	2	1633463-5	CRIMPER, WIRE SPECIAL	1		
-	77	72	71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

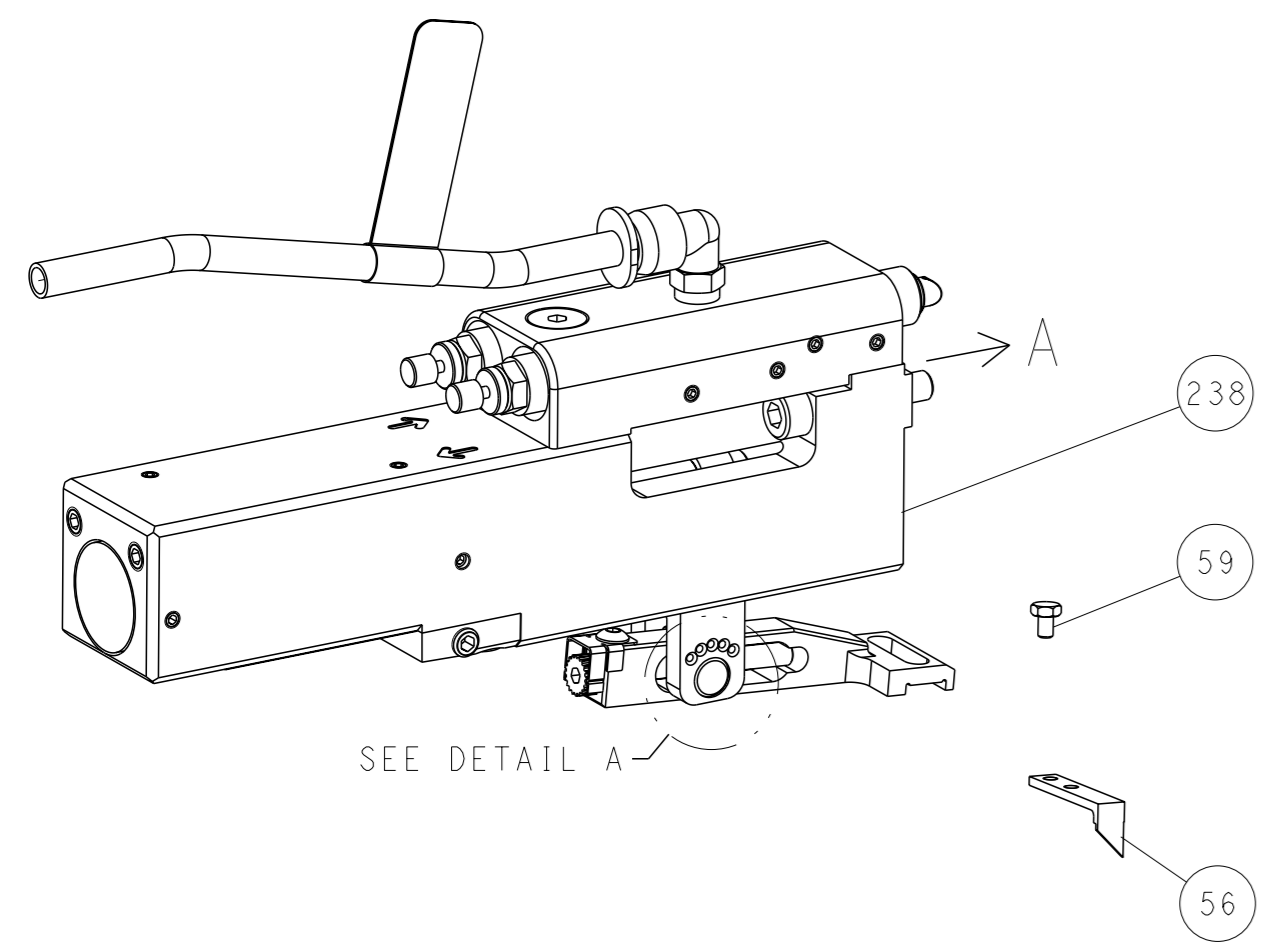
OWN	X. ZHAO	12MAR2014	
CHK	L. ZHANG	12MAR2014	
APVD	T. ELBIN	12MAR2014	
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266231	
Customer Accessible Production Drawing		SCALE	1:2
		SHEET	1 of 4
		REV	C

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

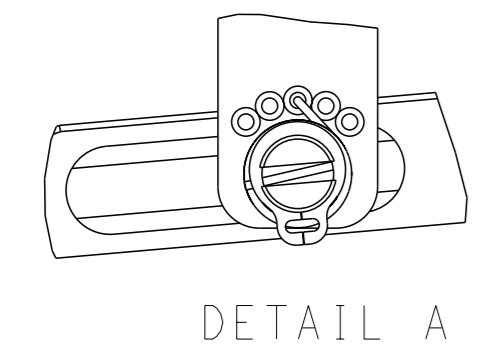
FEED TYPE MECHANICAL



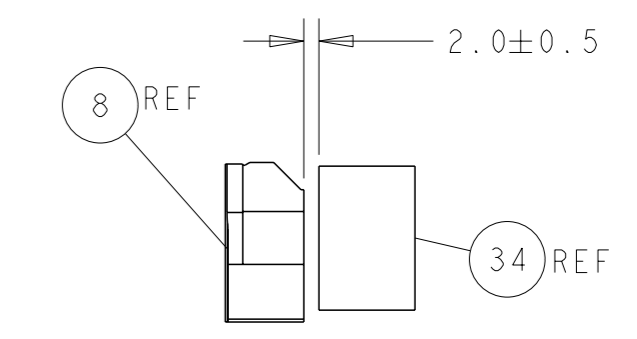
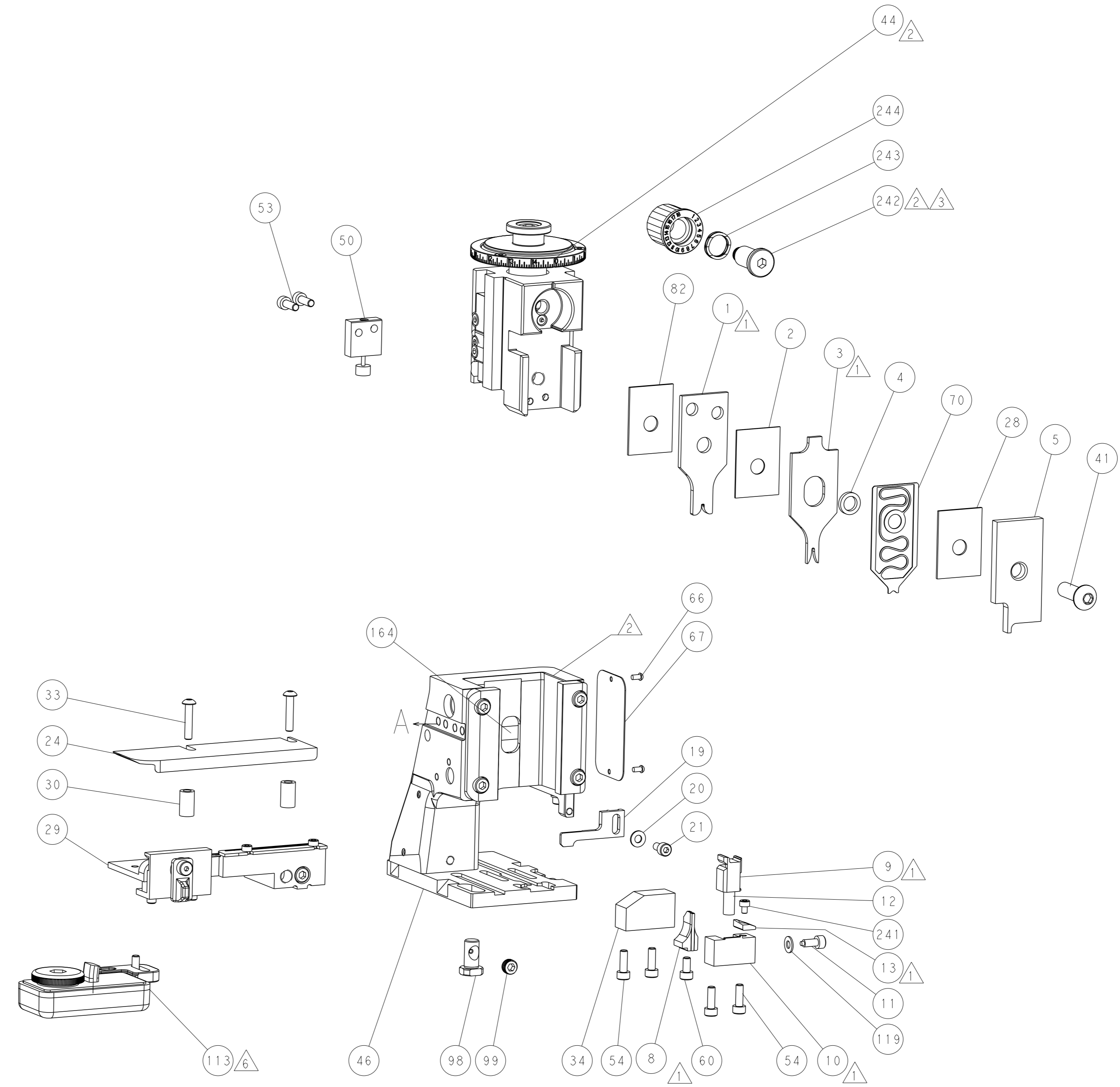
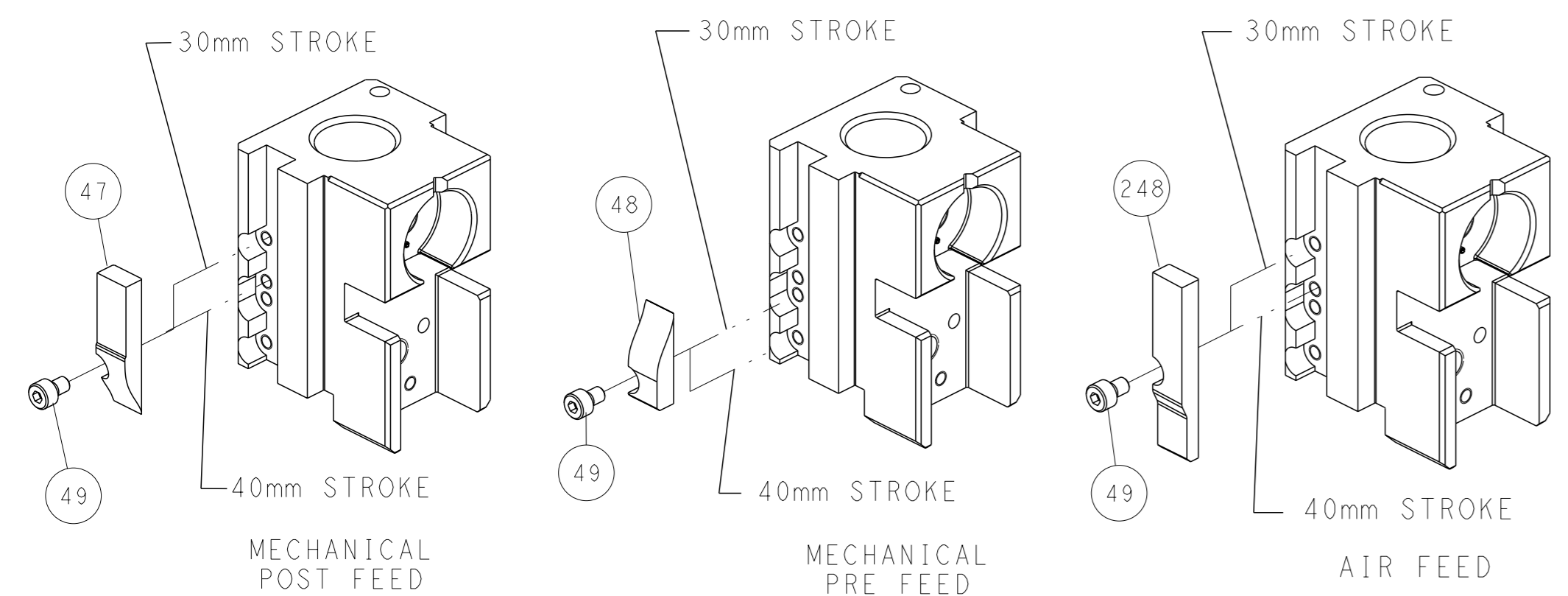
PNEUMATIC



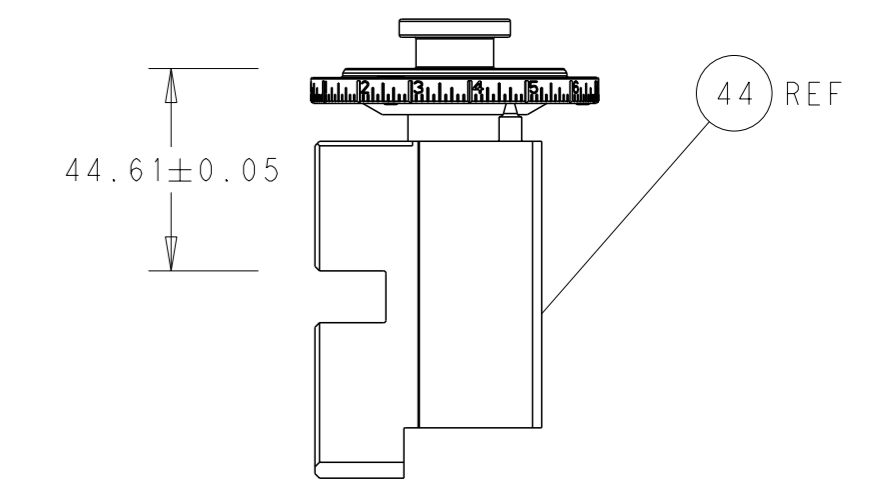
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



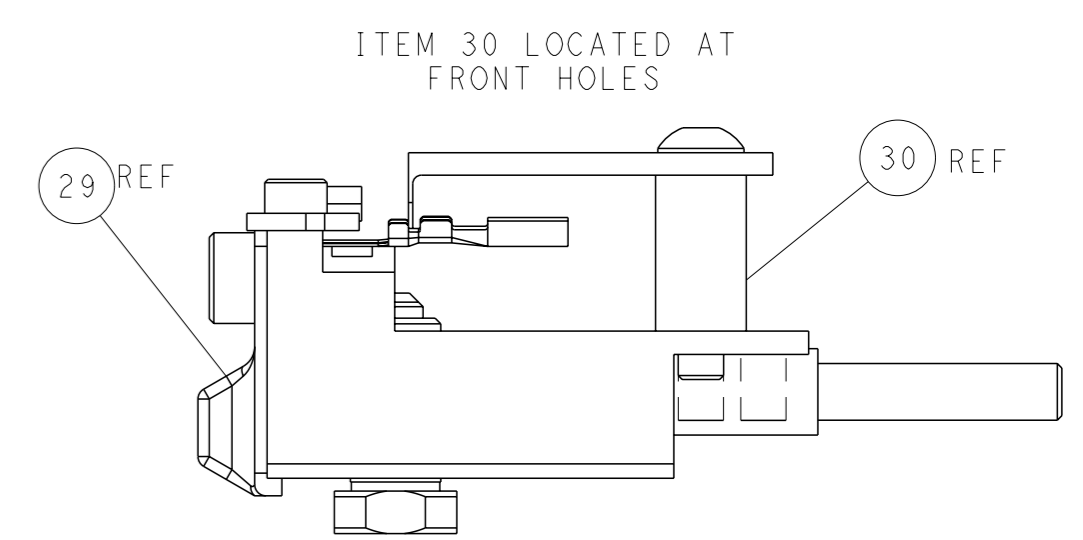
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



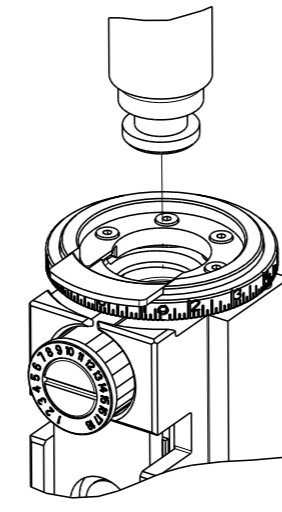
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 FINISH ±		OWN: X. ZHAO CHK: L. ZHANG APVD: J. ELBIN DATE: 12MAR2014 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266231 WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: C	TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO Customer Accessible Production Drawing
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8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2266231-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2266231-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2266231-7	A	CRIMP TOOLING KIT	-				

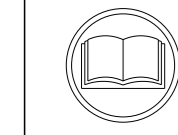
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm (.055)	F
INSUL	1.70 mm (.067)	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: MX 64 SAE RECEPTACLE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.90-4.50 mm (.154-.177 IN)		Ø1.47-1.65 mm (.058-.065 IN)	
TERMINAL APPLICATION SPECIFICATION	MOLEX SPECIFICATION	63867-3100	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572968-1	33467-0004	1572968-3	34736-1001
1572968-2	33468-0002		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.36mm2	0.95+/-0.05 [.037+/-0.002]	5.5



- 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.

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

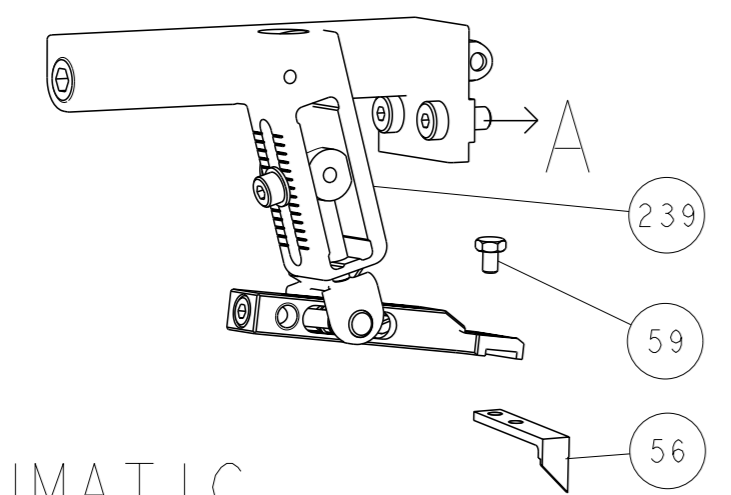
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		-	SEE SHEET 1	-	-

-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	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	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-0	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1752356-6	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	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	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	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
	-	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1804709-2	FLOATING SHEAR, FRONT	9
	1	1	1803153-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
	1	1	6-2119784-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
	1	1	1633463-5	CRIMPER, WIRE SPECIAL	1

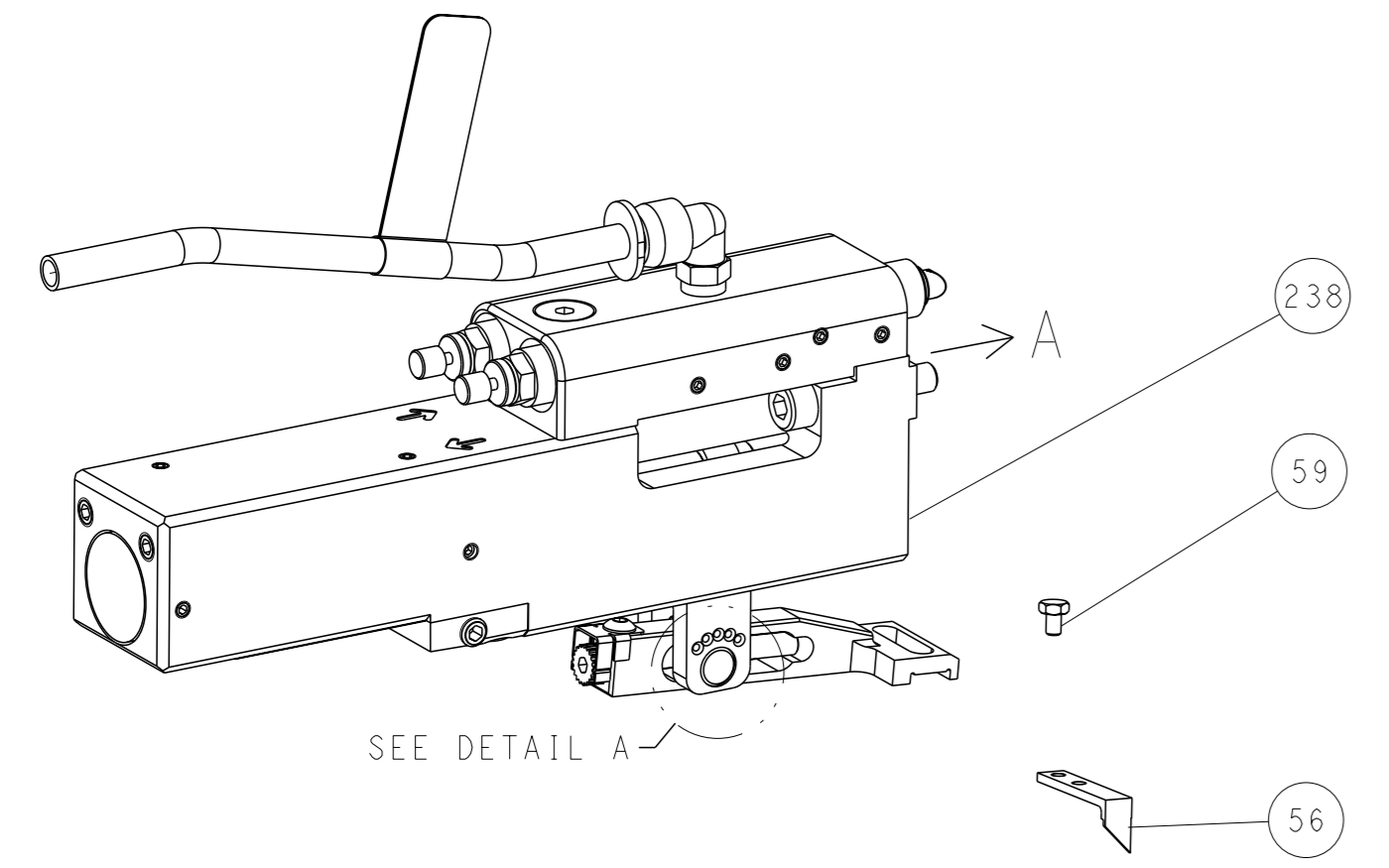
THE DRAWING IS CONTROLLED DOCUMENT FOR THE PRODUCT. ANY CHANGES TO THE DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE QUALITY ENGINEER. THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST VERSION.		OWN	X. ZHAO	12MAR2014	STE TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS:		CHK	L. ZHANG	12MAR2014	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APV	T. ELBIN	12MAR2014	NAME
mm		APPLICATION SPEC		Ocean Side Feed Applicator	
0 PLC ±		RESTRICTED TO		SIZE	
1 PLC ±		SCALE		CAGE CODE	
2 PLC ±		DRAWING NO		DRAWING NO	
3 PLC ±		00779		2266231	
4 PLC ±		Customer Accessible Production Drawing		SCALE	
ANGLES FINISH		1:2		SHEET	
MATERIAL		3		OF 4	
		REV		C	

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

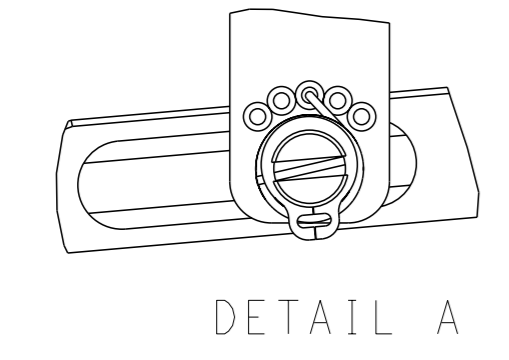
FEED TYPE MECHANICAL



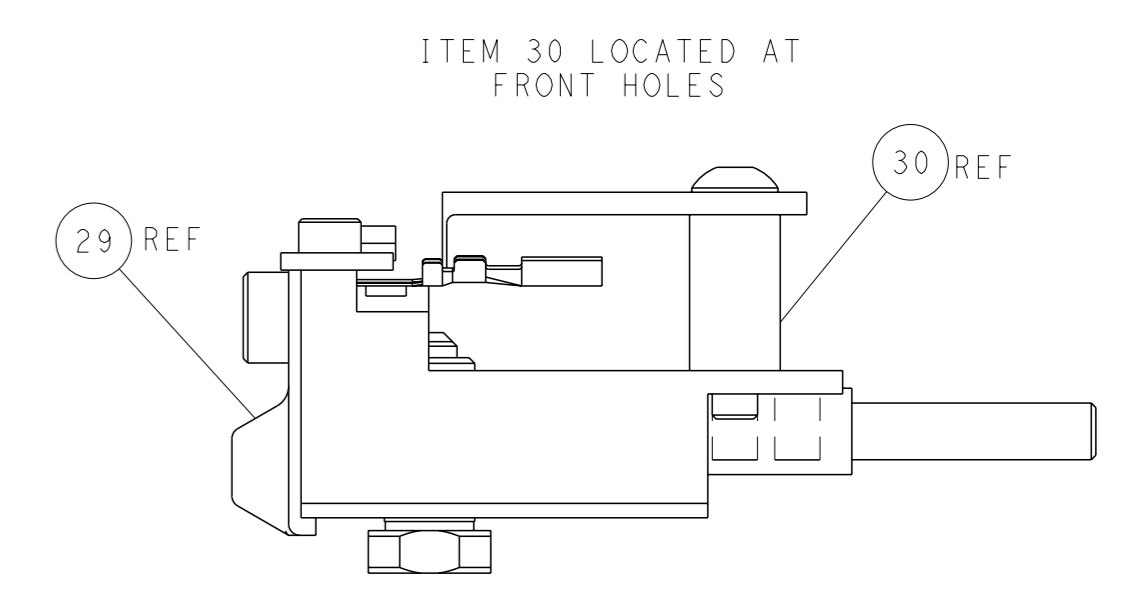
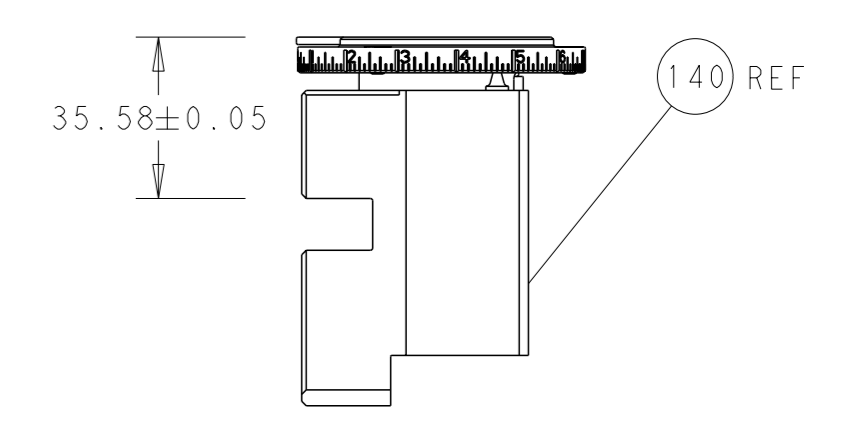
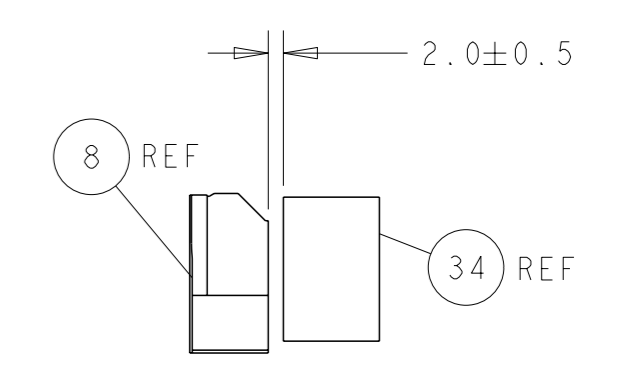
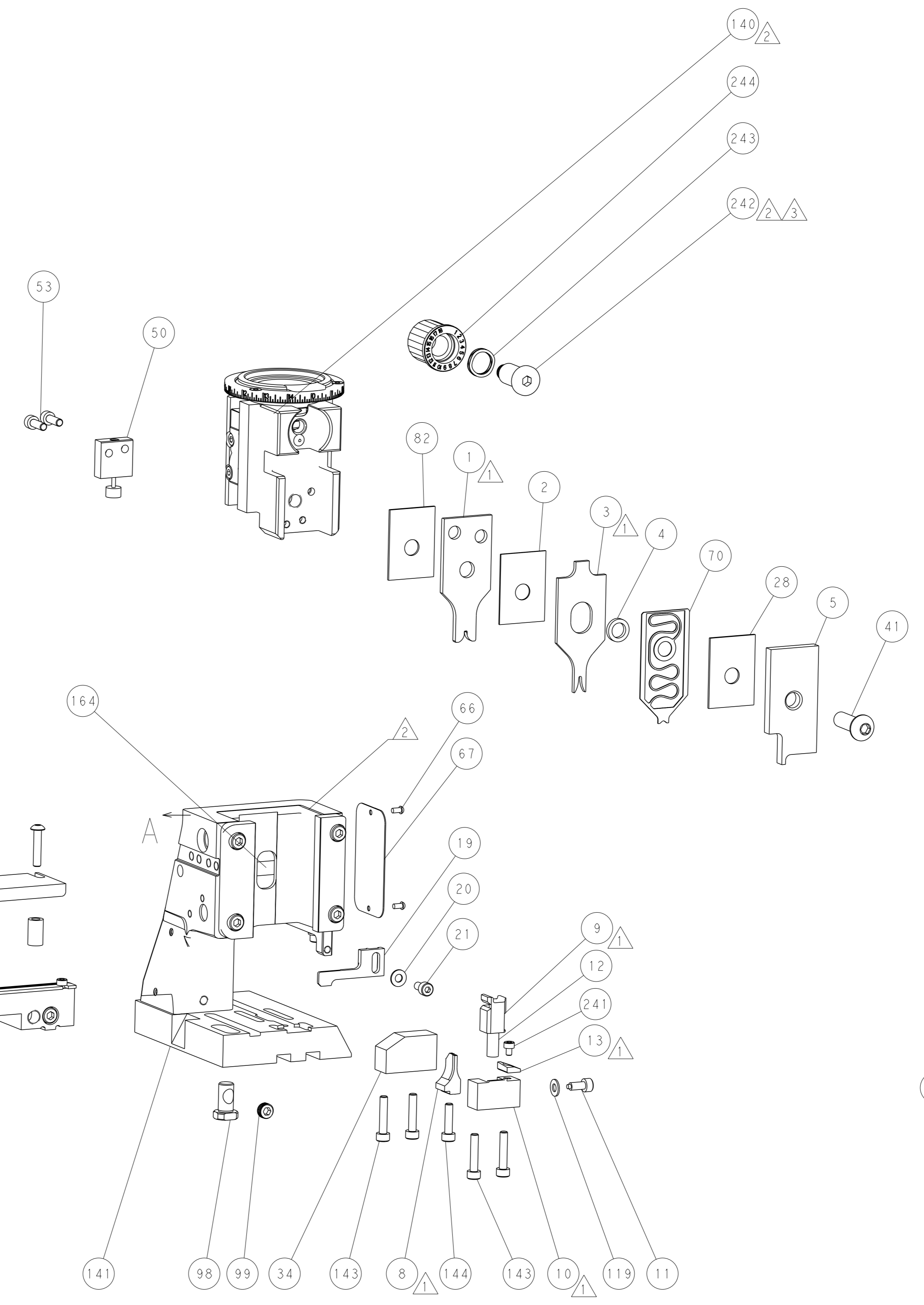
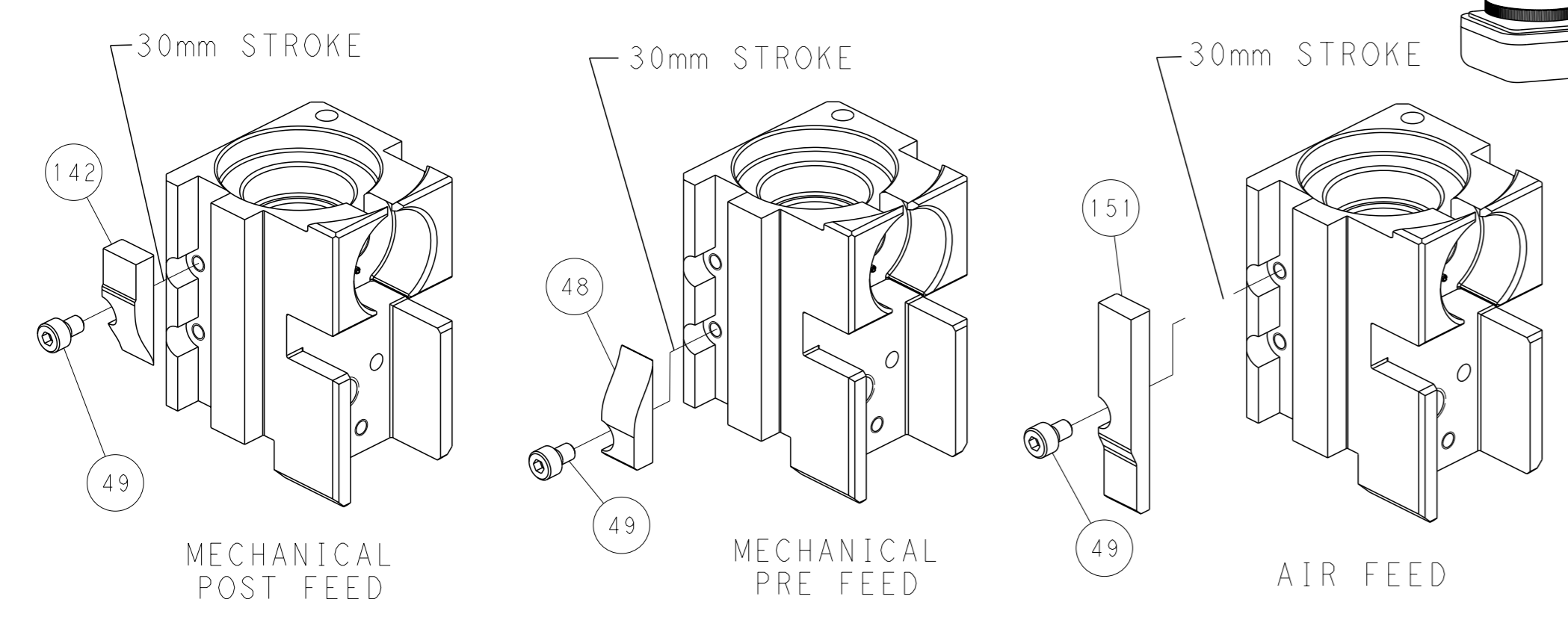
PNEUMATIC



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 USER'S RESPONSIBILITY TO VERIFY THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: X. ZHAO 12MAR2014 CHK: L. ZHANG 12MAR2014 APVD: J. ELBIN 12MAR2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	NAME: Ocean Side Feed Applicator APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266231	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: C	CUSTOMER ACCESSIBLE PRODUCTION DRAWING