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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266021-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266021-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266021-1	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266021-2	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266021-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266021-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266021-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
STAB	1.78 mm [.070]	O
INSUL	1.78 mm [.070]	O
APPLICATOR INSTRUCTIONS 408-35042		

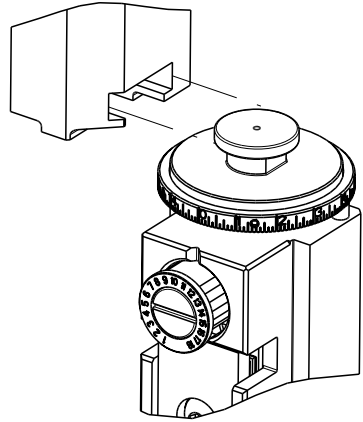
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT-LOCKING CLIP			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.58-4.34 mm [.141-.171 IN]			Ø0.96-1.57 mm [.038-.062 IN]
TERMINAL APPLICATION SPECIFICATION	114-25006		-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
87124-1	87124-2	87124-3	5-87124-2
2267356-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER CRIMP HEIGHT mm [INCH]	TE HOUSING
22 AWG	0.86+/-0.05 [.034+/- .002]	7.9	2.08 +0/-0.10 [.0819 +.0000/- .0039]	-
24 AWG	0.76+/-0.05 [.030+/- .002]	8.9	2.08 +0/-0.10 [.0819 +.0000/- .0039]	-
26 AWG	0.76+/-0.05 [.030+/- .002]	9.0	2.08 +0/-0.10 [.0819 +.0000/- .0039]	-



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- APPLICATOR WAS QUALIFIED TO STABILIZER CRIMP HEIGHT LISTED FOR ALL TERMINALS AND HOUSING COMBINATION ONLY. APPLICABLE HOUSINGS: 926657, 926209, 926659, AND 926663.

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT-LOCKING CLIP			
WIRE STRIP LENGTH 3.58-4.34 mm [.141-.171 IN]		INSULATION DIAMETER RANGE Ø1.27-2.54 mm [.050-.100 IN]	
TERMINAL APPLICATION SPECIFICATION		114-25006	
TERMINALS APPLIED		6	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
867052-1	867052-2	5-867052-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER CRIMP HEIGHT mm [INCH]	TE HOUSING
20 AWG	1.02+/-0.05 [.040+/- .002]	6.1	2.08 +0/-0.10 [.0819 +.0000/- .0039]	-

*WARNING
ON INSTALLATION, SET WIRE DISC TO 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.

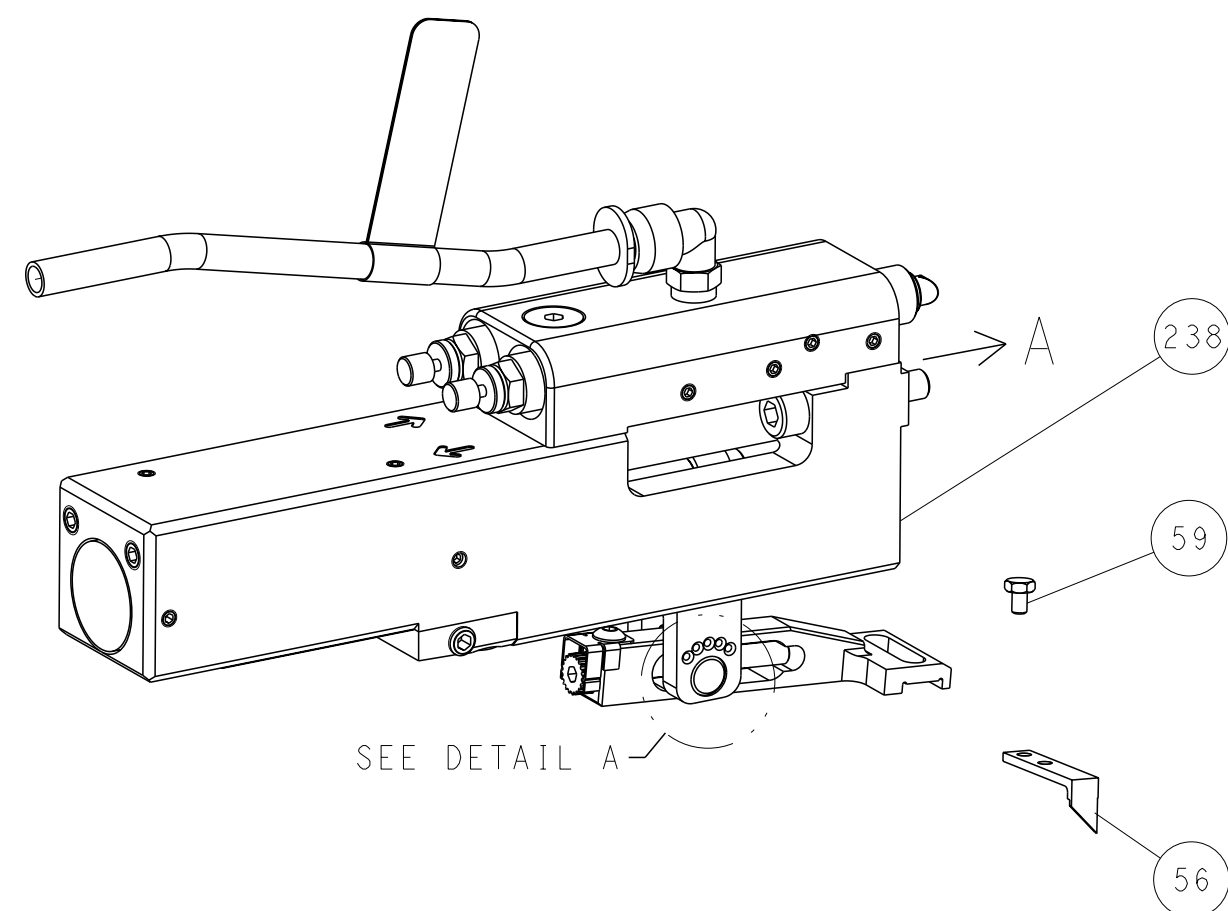
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC		DIST		REVISIONS						
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD	
					B2	ECR-17-012792	31AUG2017	TB	TE	
					B3	ECR-18-000786	18JAN2018	JAH	TE	
					C	ECR-20-003074	03MAR2020	TB	TE	
					D	ECR-20-009140	06JUL2020	JWC	GB	

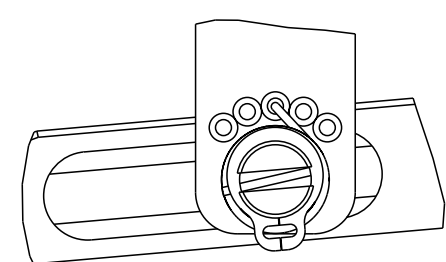
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	263
-	1	1	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	262
1	2	2	1	1	1	1	4-1803019-1	CRIMPER, INSULATION O	261
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
3	-	-	-	1	1	-	1-1752354-9	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	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	-	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	-	-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	-	-	1	1	690753-2	SPACER, TONKER	50
-	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	3-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-4	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	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	1803095-6	FLOATING SHEAR, FRONT -	9
1	2	2	1	1	1	1	1-1633917-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	9-2119784-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-2	SPACER, CRIMPER	2
1	2	2	1	1	1	1	2-456402-5	CRIMPER, WIRE PREMIUM	1

-77-72-71-52-51-2-1		PART NO	DESCRIPTION		ITEM NO
111 IS SUBJECT TO CHANGE AND TO BE CANCELED FOR THE LATEST REVISION. FOR THE LATEST REVISION, CONTACT THE ENGINEERING ORGANIZATION.		DWN C. CHEN 20AUG2013	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS:		CHK U. GUO 20AUG2013	NAME Ocean Side Feed Applicator		
mm		APVD J. CRUZ 20AUG2013	PRODUCT SPEC		
TOLERANCES UNLESS OTHERWISE SPECIFIED:			APPLICATION SPEC		
0 PLC ±			1 PLC ±		
1 PLC ±			2 PLC ±		
2 PLC ±			3 PLC ±		
3 PLC ±			4 PLC ±		
4 PLC ±			5 PLC ±		
MATERIAL			FINISH		
-			-		
WEIGHT			-		
CUSTOMER DRAWING			SCALE 1:2		
SHEET 1 OF 4			REV D		

PNEUMATIC



FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

30mm STROKE

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

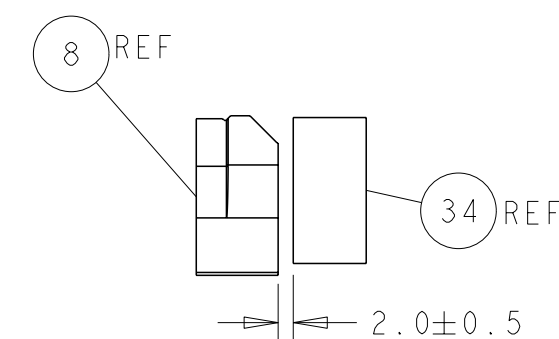
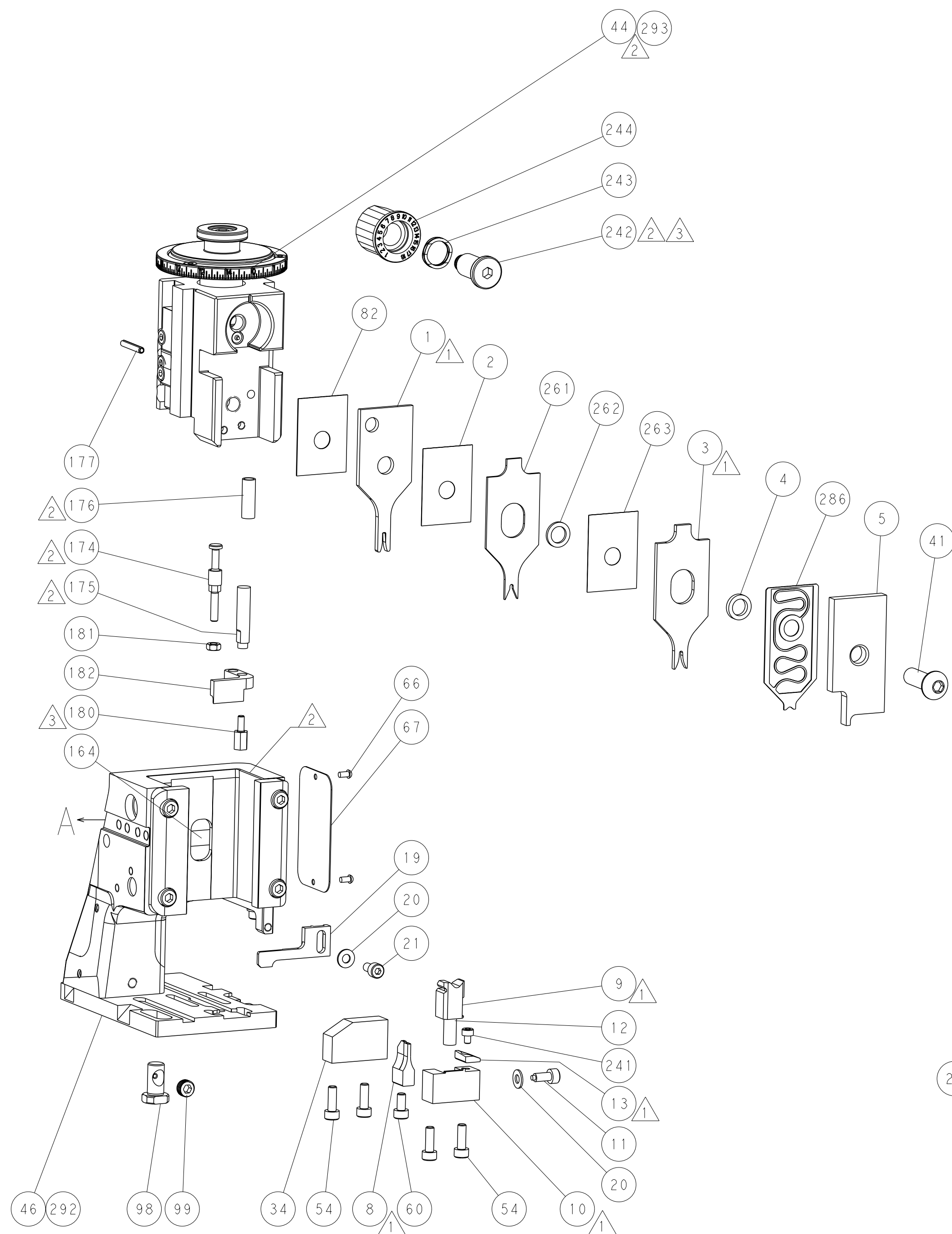
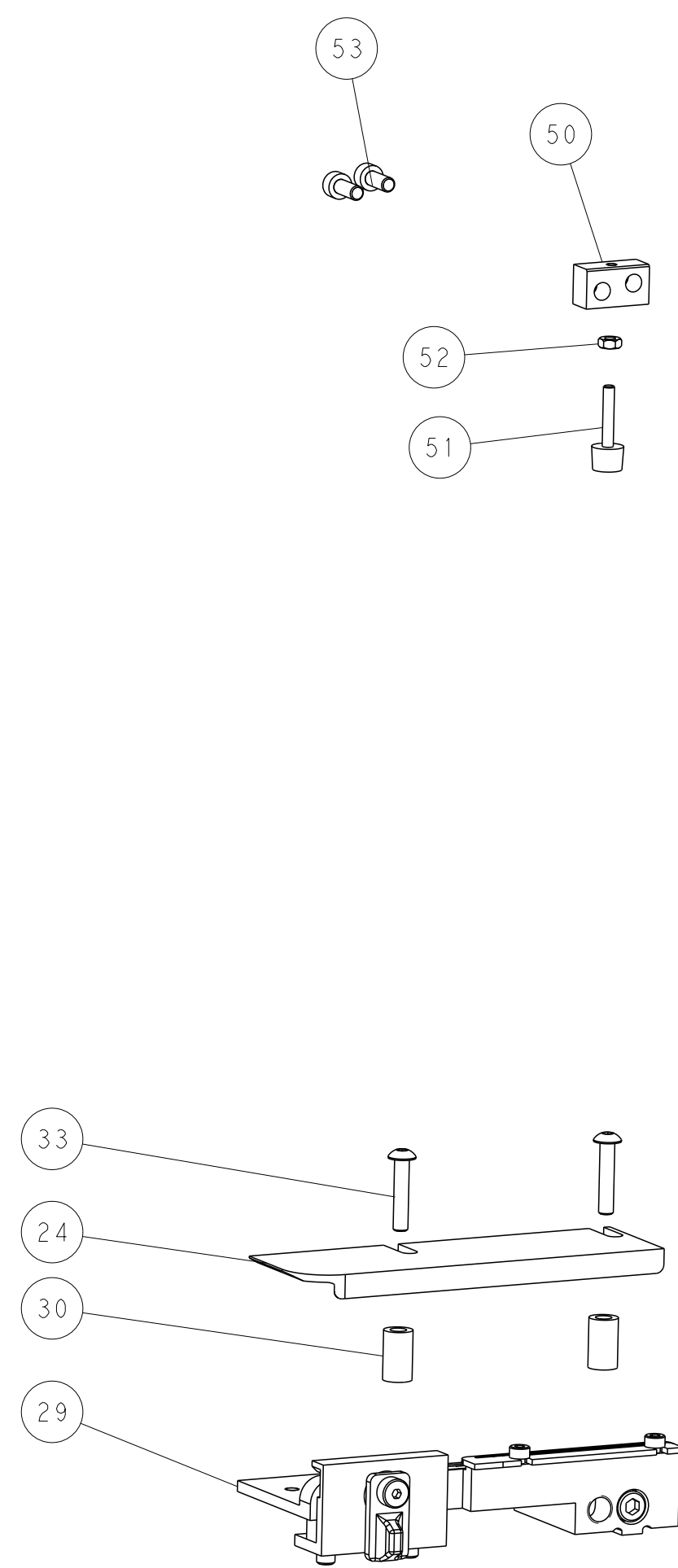
40mm STROKE

MECHANICAL PRE FEED

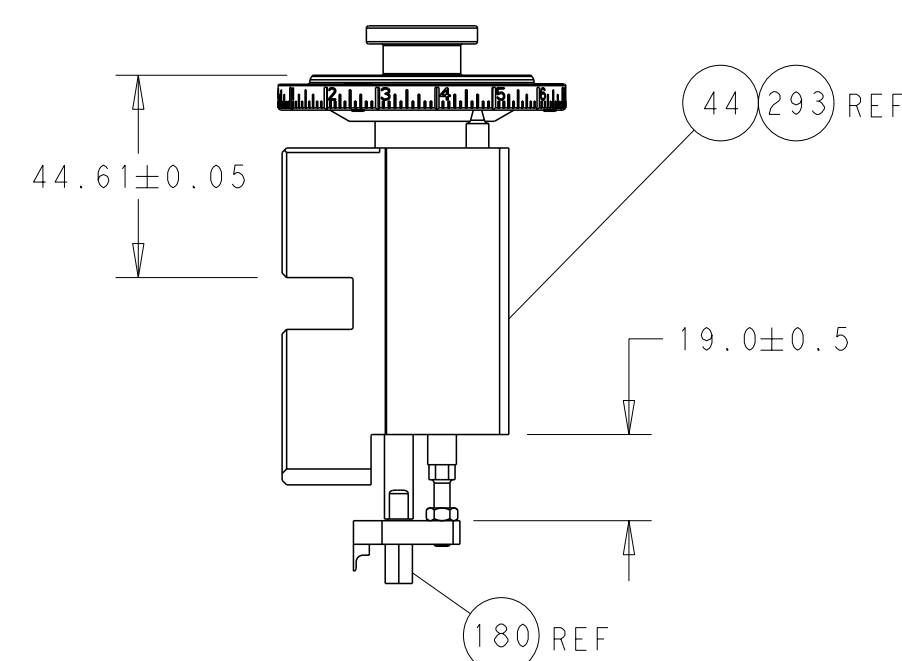
30mm STROKE

40mm STROKE

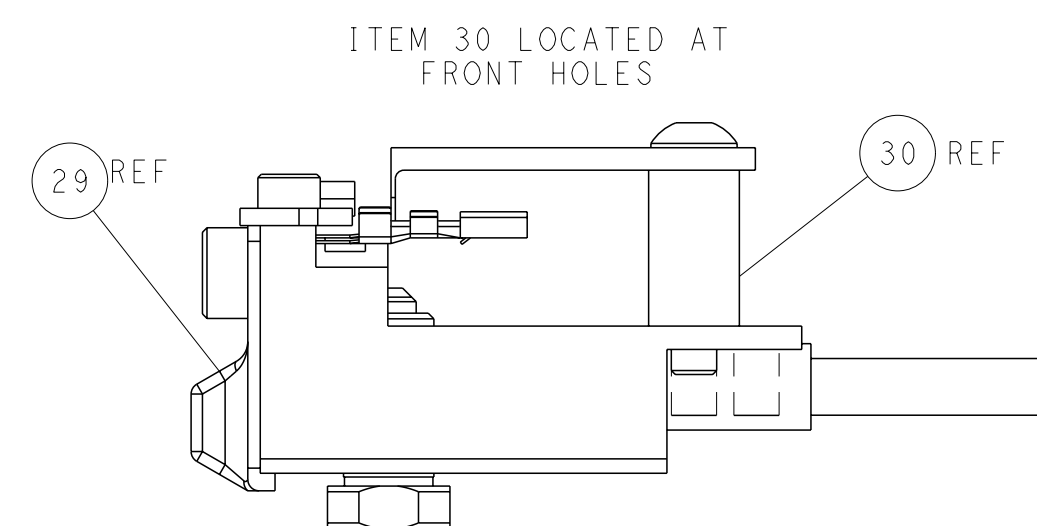
AIR FEED



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)

[illegible]

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

D

C

B

A

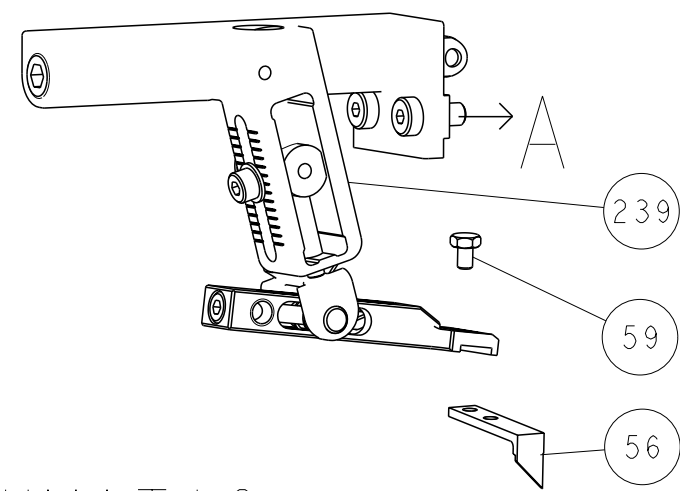
D

C

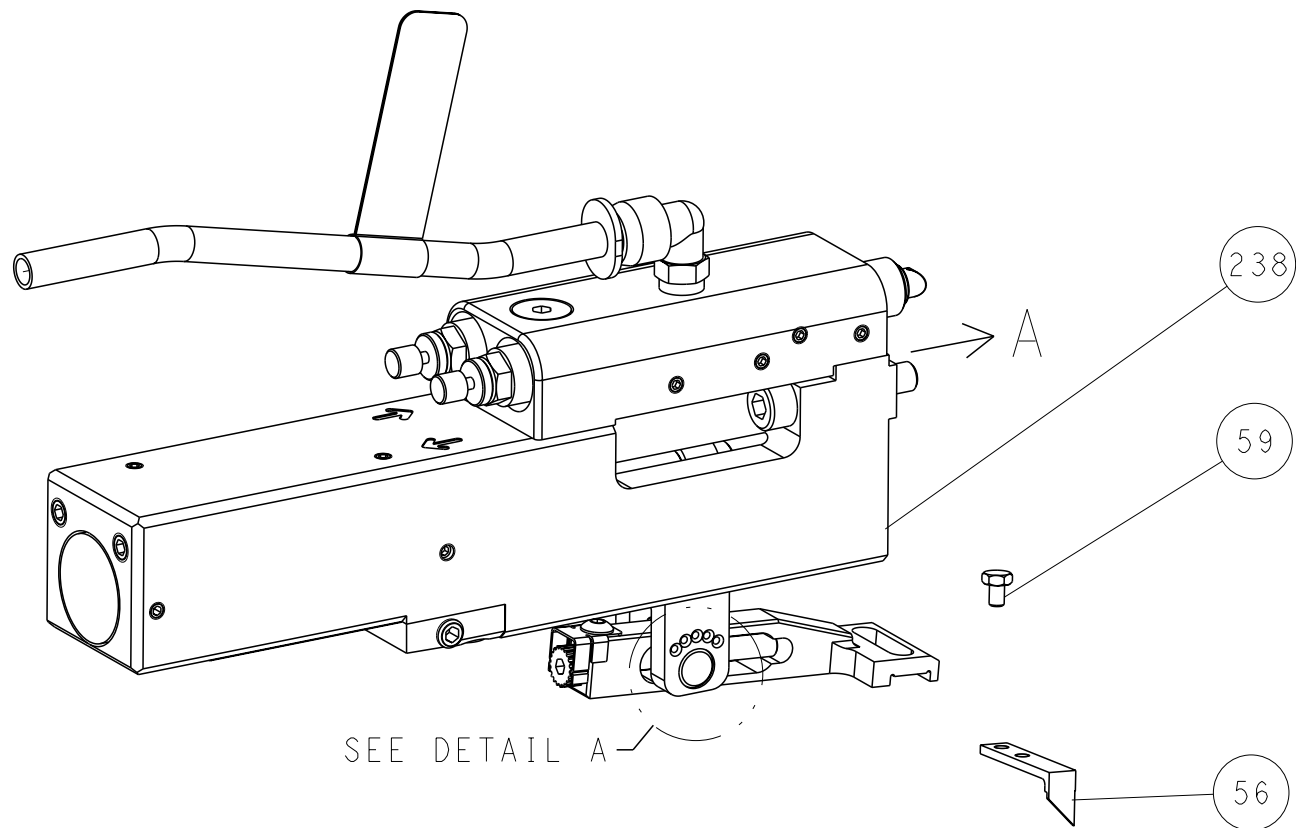
B

A

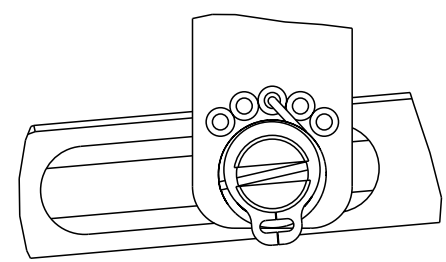
FEED TYPE MECHANICAL



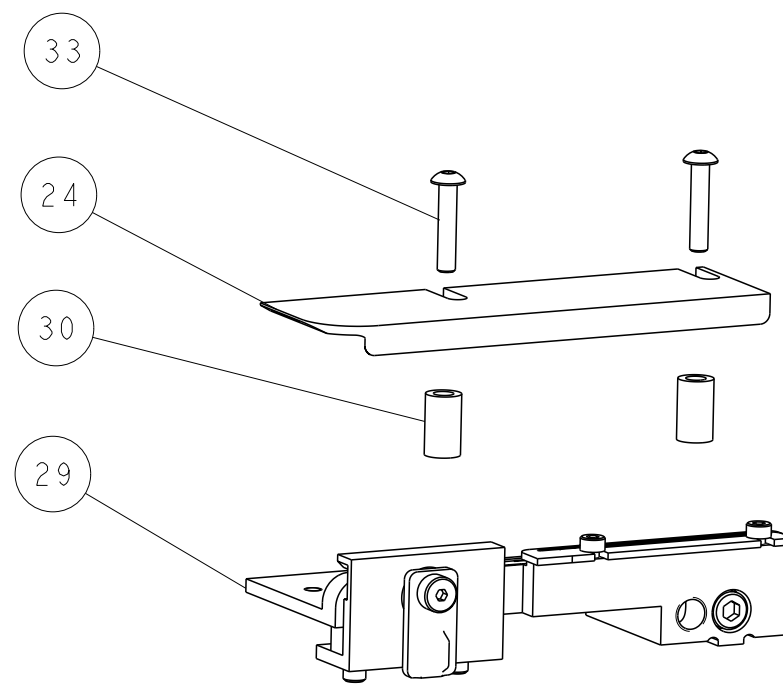
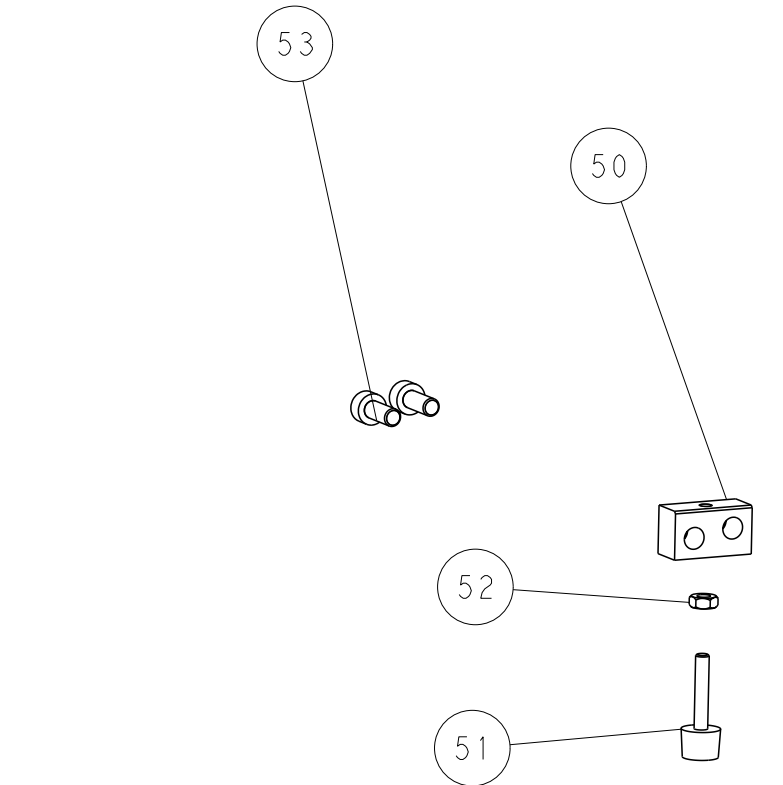
PNEUMATIC



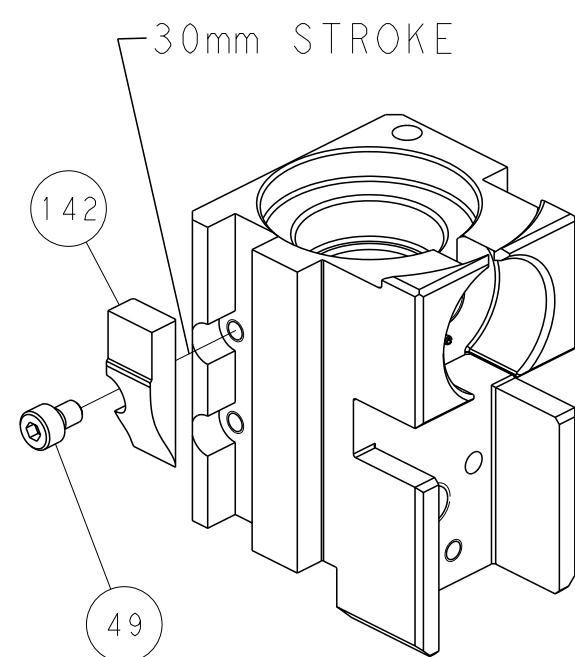
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



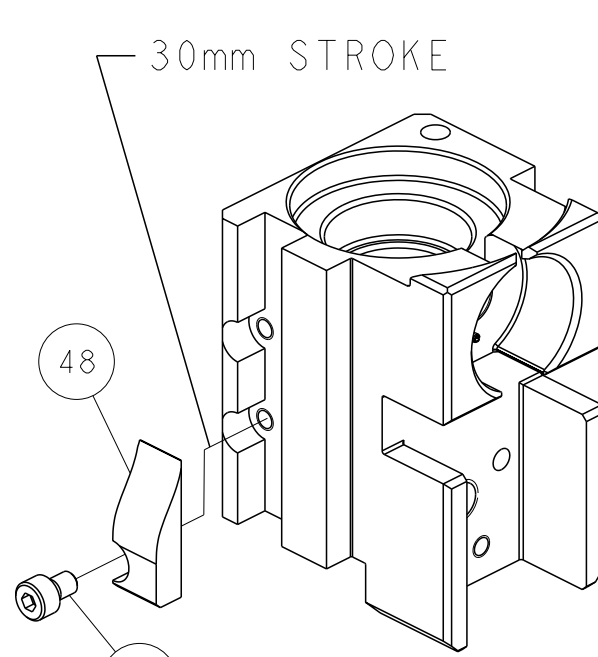
DETAIL A



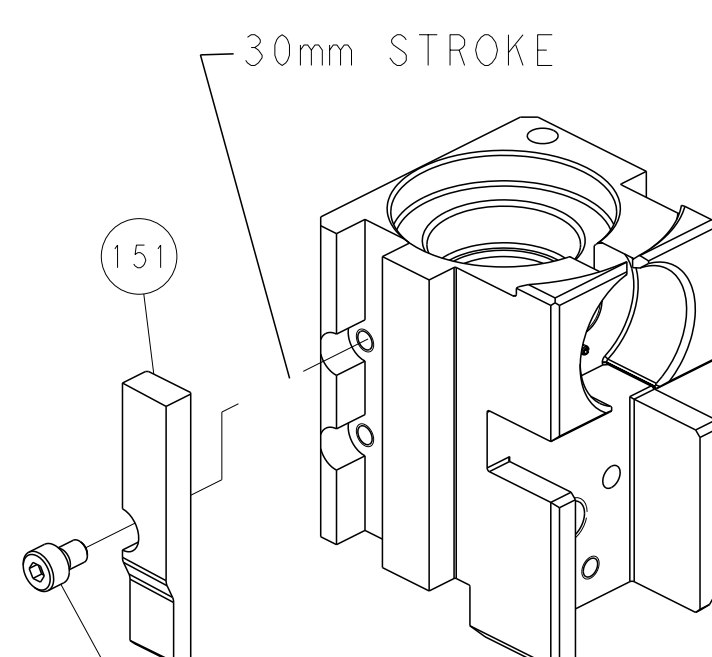
CAM POSITIONS



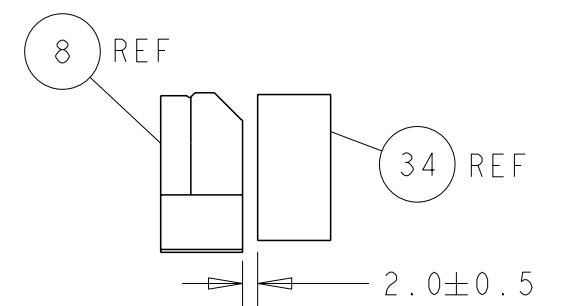
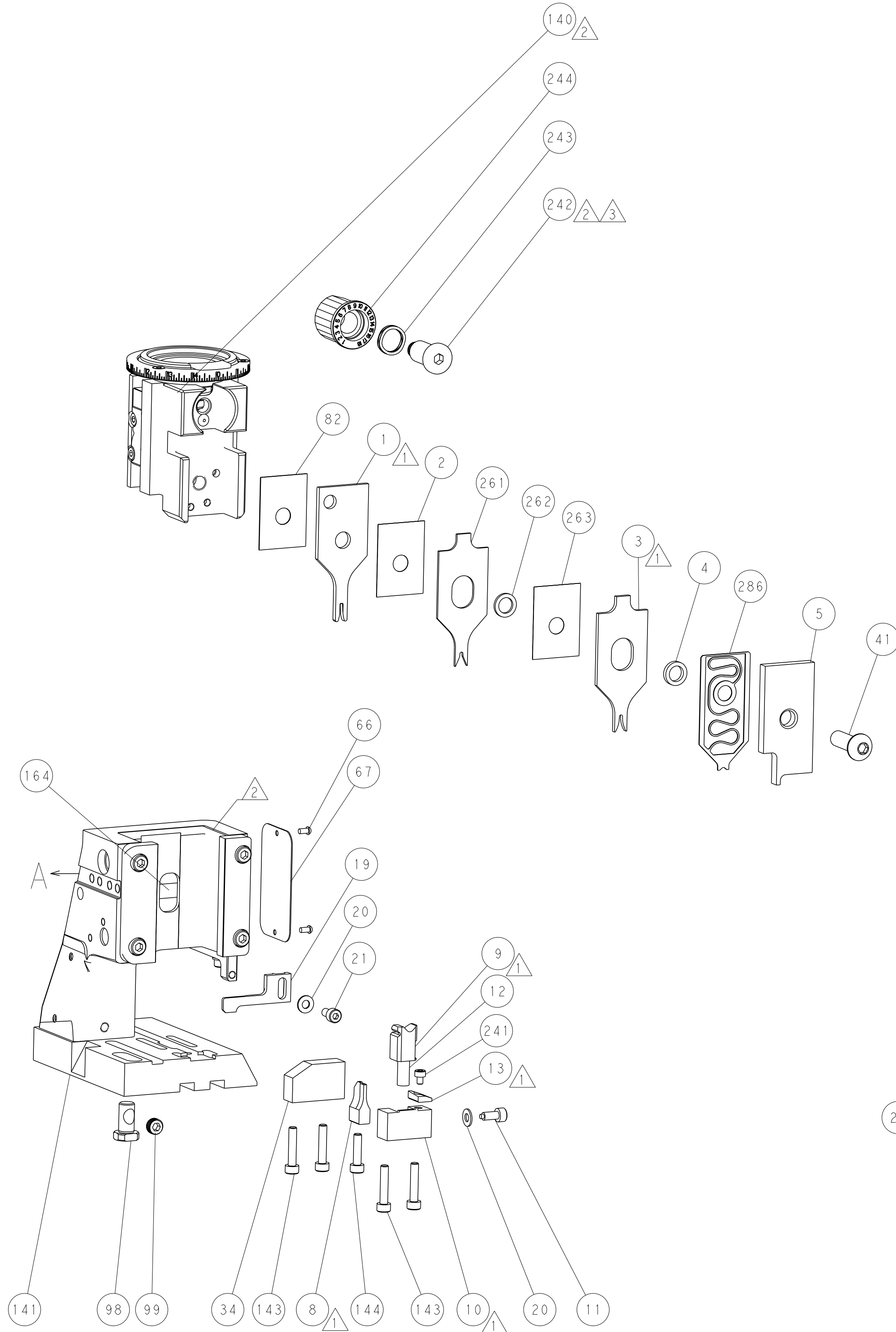
MECHANICAL
POST FEED



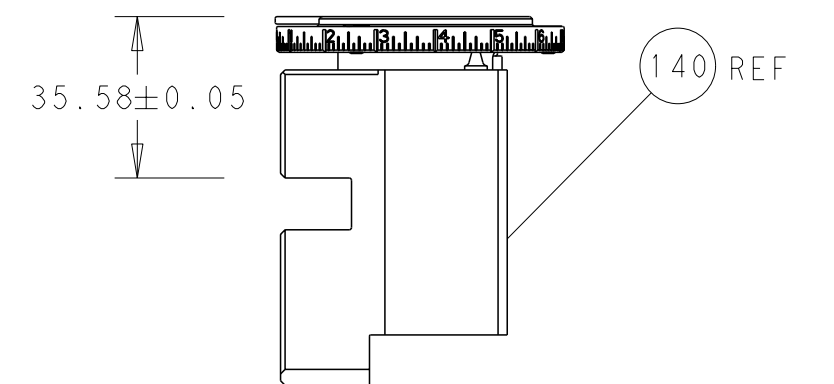
MECHANICAL
PRE FEED



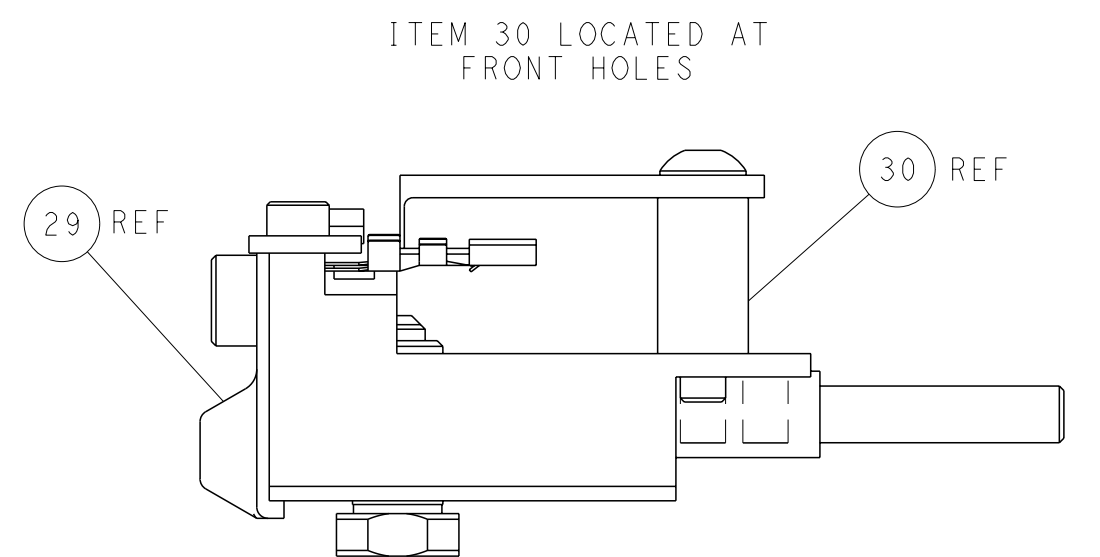
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING DEPARTMENT. SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN C. CHEN 20AUG2013	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK U. GUO 20AUG2013		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD J. CRUZ 20AUG2013	NAME Ocean Side Feed Applicator	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
FINISH -		APPLICATION SPEC -	CAGE CODE DRAWING NO 00779 C=2266021	
WEIGHT -		CUSTOMER DRAWING	RESTRICTED TO -	
SCALE 1:2		SHEET 4		REV D

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION