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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266235-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266235-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266235-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266235-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266235-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.79 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-35042		

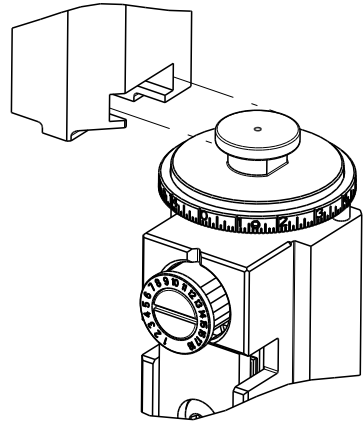
TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH 3.00-3.50 mm [.118-.138 IN]			INSULATION DIAMETER RANGE Ø1.70-3.00 mm [.067-.118 IN]
TERMINAL APPLICATION SPECIFICATION		CHM-1-2107 Rev -	
			
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1692886-1	SVH-21T-P1.1	286927-2	SVH-21T-1.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.15+/-0.05 [.045+/- .002]	6.2
20 AWG	1.10+/-0.05 [.043+/- .002]	6.6
22 AWG	1.05+/-0.05 [.041+/- .002]	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.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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

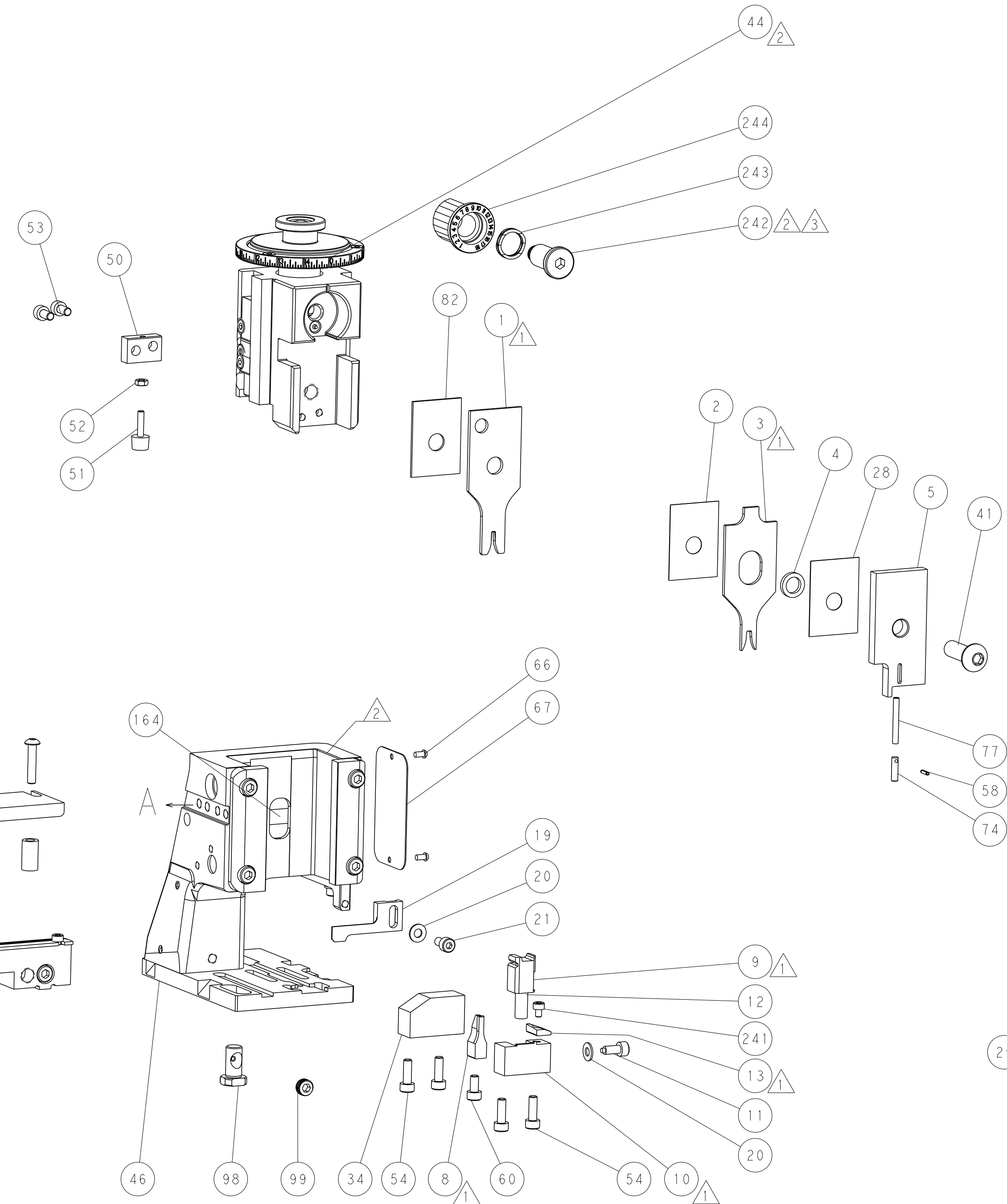
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A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD	
				I		DEVELOPMENT	21MAR2014	YY	UG	
				A		RELEASED	08APR2014	YY	UG	
				B		ECR-16-005295	12APR2016	XZ	TE	
				D		ECR-19-019713	18DEC2019	TB	GB	

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-7	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	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	82
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1	1338683-8	FEED PAWL	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1-811242-0	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-6	SPACER, TONKER	50
-	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
-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	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	2119533-3	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	462006-6	FLOATING SHEAR, FRONT	9
1	2	2	1	1	6-1633130-5	ANVIL, COMBINATION .070	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2
1	2	2	1	1	3-456404-6	CRIMPER, WIRE PREMIUM	1
-77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.		DWN	Y. YIN	21MAR2014	TE Connectivity Harrisburg, PA 17105-3608		
CHK		G. BAILEY		21MAR2014	NAME		
APVD		J. GUO		21MAR2014	PRODUCT SPEC		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC		SIZE	
mm		0 PLC ±.005		WEIGHT		CAGE CODE	
1 PLC ±.005		2 PLC ±.005		DRAWING NO		RESTRICTED TO	
3 PLC ±.005		4 PLC ±.005		00779		Customer Accessible Production Drawing	
ANGLES		FINISH		SCALE		SHEET 1 OF 4	
MATERIAL		-		REV		D	

Diagram illustrating the front view of the machine. The front plate (239) is shown being attached to the front plate bracket (59) using a screw (56).

CAM POSITIONS



44.61 ± 0.05

44 REF

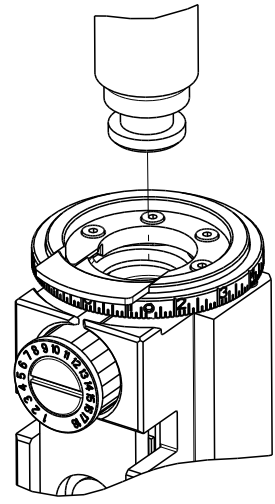
RAM SET-UP

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

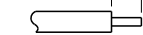
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266235-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266235-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266235-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.79 mm [.110]	F
APPLICATOR INSTRUCTIONS		
408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH 3.00-3.50 mm [.118-.138 IN]			INSULATION DIAMETER RANGE Ø1.70-3.00 mm [.067-.118 IN]
TERMINAL APPLICATION SPECIFICATION		CHM-1-2107 Rev -	-
TERMINALS APPLIED		-	-
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1692886-1	SVH-21T-P1.1	286927-2	SVH-21T-1.1

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
18 AWG		1.15+/-0.05 [.045+/- .002]		6.2
20 AWG		1.10+/-0.05 [.043+/- .002]		6.6
22 AWG		1.05+/-0.05 [.041+/- .002]		7.0



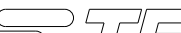
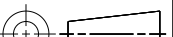
-  RECOMMENDED SPARE PARTS
-  REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
-  APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
-  CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
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.

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

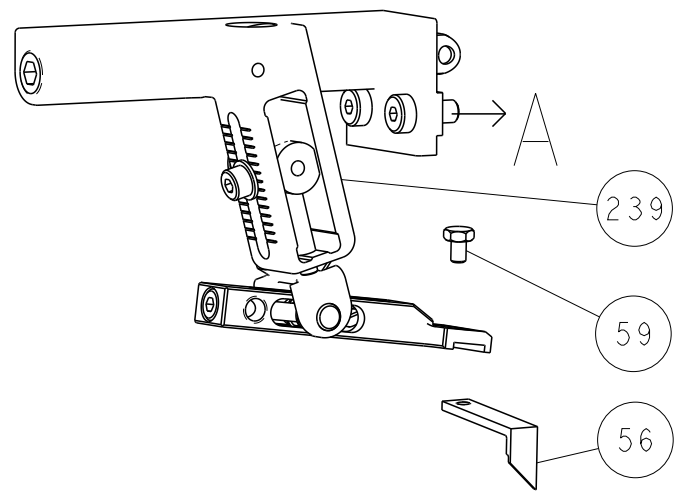
	-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	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	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-455888-0	SPACER, CRIMPER	82
	-	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	854769-4	HOLDER, INS	74
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	1	1	1338683-8	FEED PAWL	56
	-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1-811242-0	BUMPER, HOLD DOWN	51
	-	1	1	690753-6	SPACER, TONKER	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	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	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	2119533-3	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	6-1633130-5	ANVIL, COMBINATION .070	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-2	SPACER, CRIMPER	2
1	1	1	1	3-456404-6	CRIMPER, WIRE PREMIUM	1
-77	-22	-21		PART NO	DESCRIPTION	ITEM NO

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

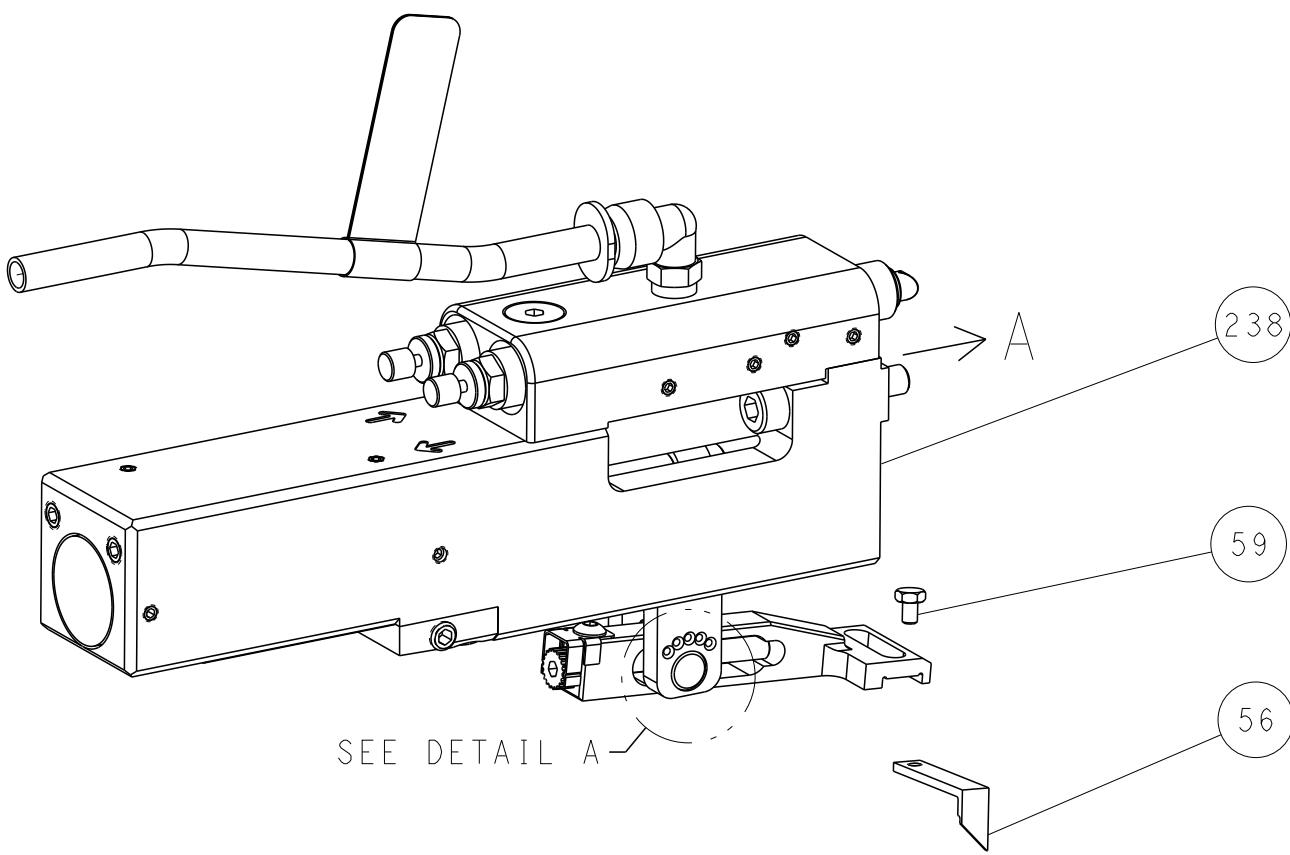
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CHK G. BAILEY 21MAR2014										APVD J. GUO 21MAR2014		NAME Ocean Side Feed Applicator							
DIMENSIONS: mm										PRODUCT SPEC									
										APPLICATION SPEC									
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005										WEIGHT									
FINISH										Customer Accessible Production Drawing									
MATERIAL										SIZE A1		CAGE CODE 00779		DRAWING NO C-2266235		RESTRICTED TO		REV D	

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

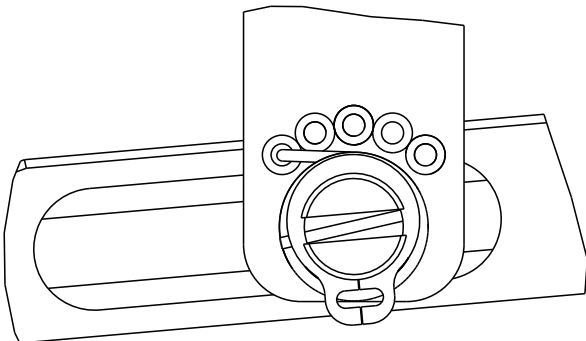
FEED TYPE
MECHANICAL



PNEUMATIC

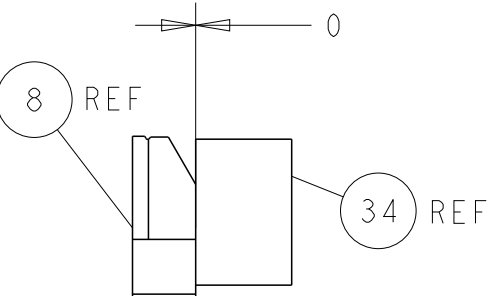
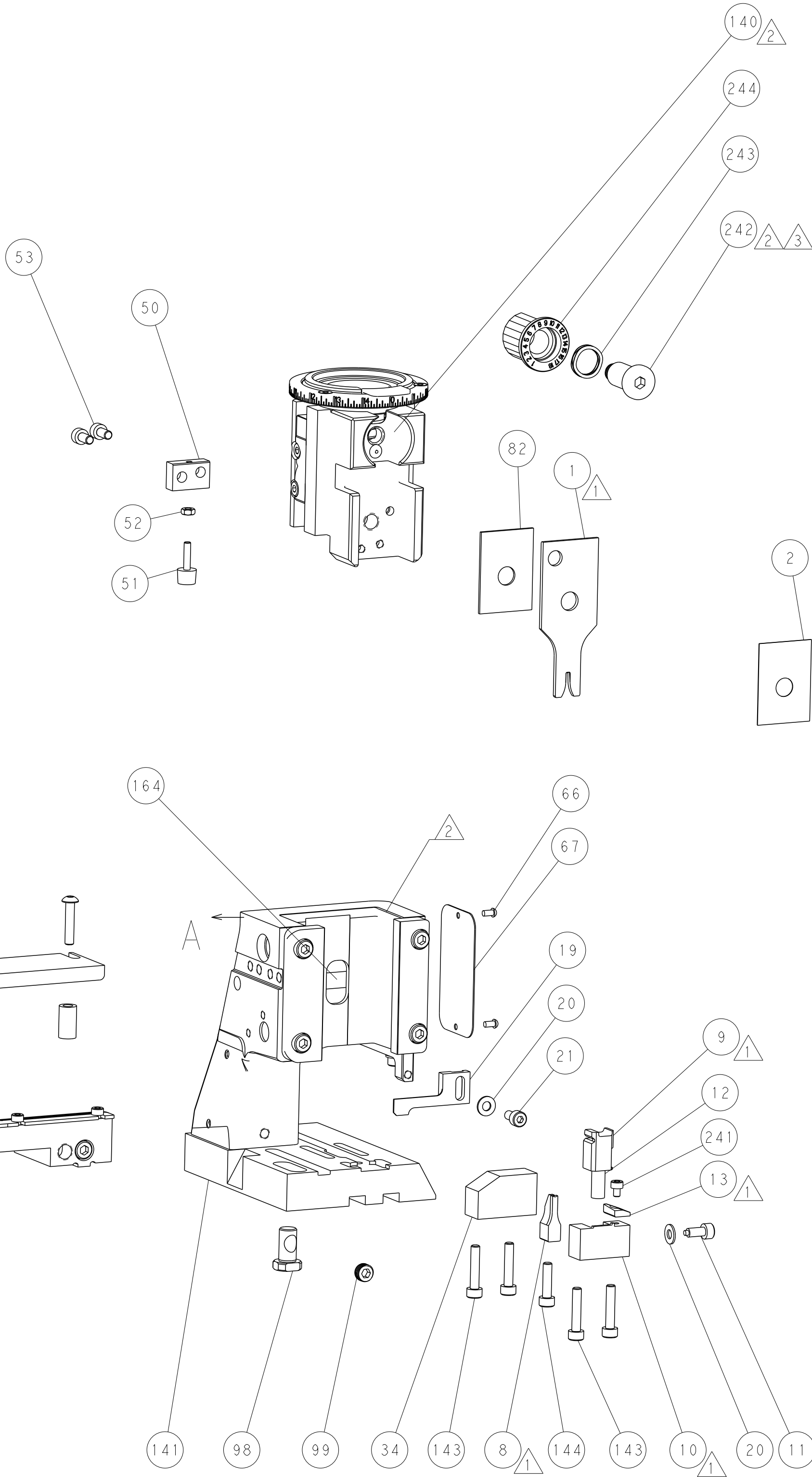
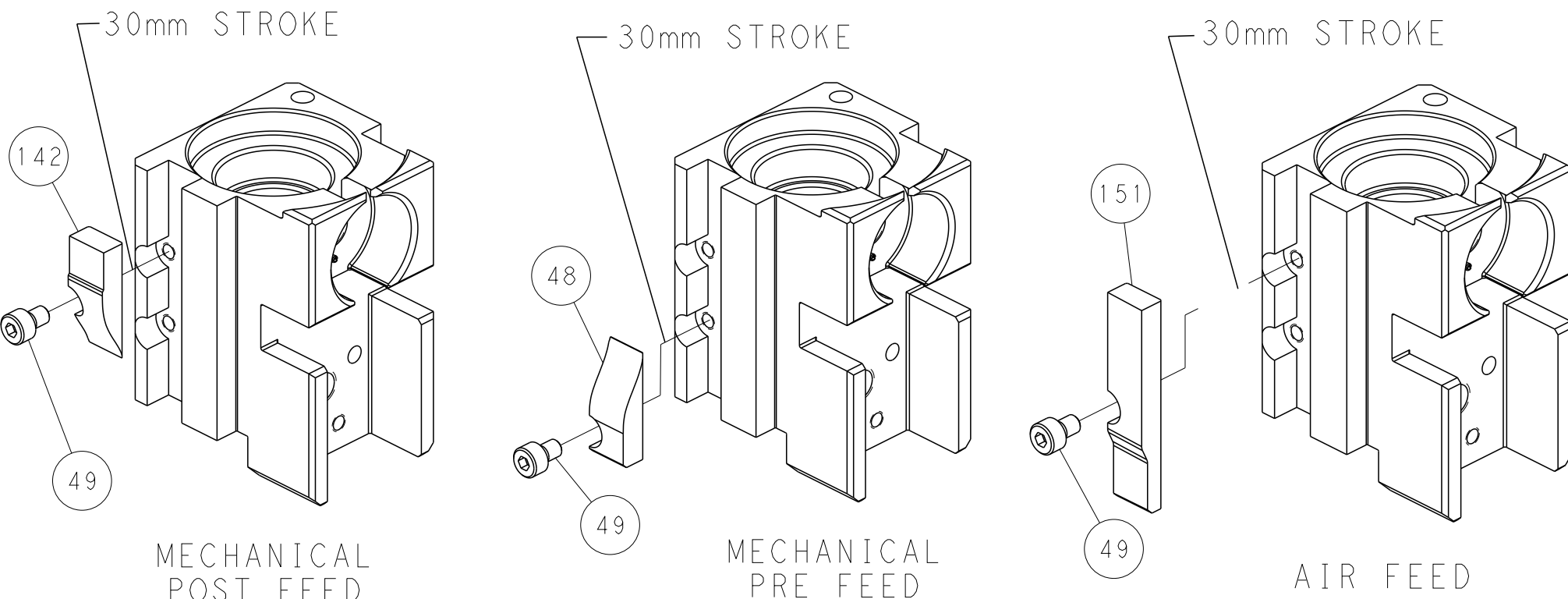


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

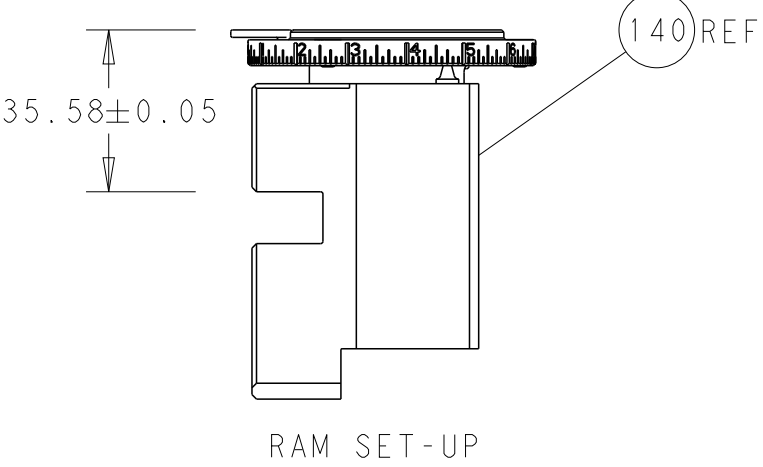


DETAIL A

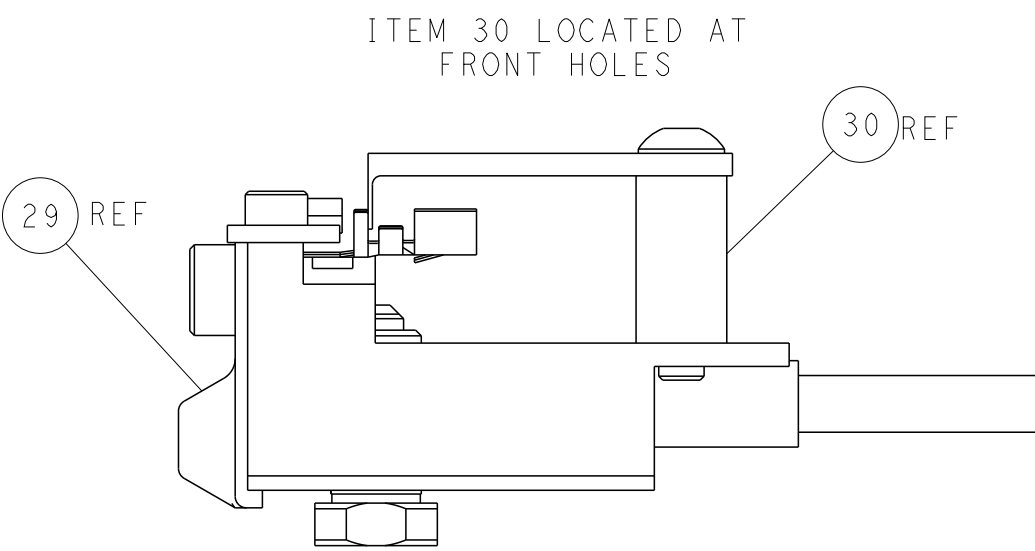
CAM POSITIONS



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)

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.		DWN	Y. YIN	21MAR2014	 TE Connectivity Harrisburg, PA 17105-3608			
		CHK	G. BAILEY	21MAR2014				
		APVD	J. GUO	21MAR2014				
		NAME			Ocean Side Feed Applicator			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:			PRODUCT SPEC			
mm		0 PLC ±.001			APPLICATION SPEC			
		1 PLC ±.001			SIZE			
		2 PLC ±.001			CAGE CODE			
		3 PLC ±.001			DRAWING NO			
		4 PLC ±.001			RESTRICTED TO			
MATERIAL		FINISH			WEIGHT			
-		-			-			
					Customer Accessible Production Drawing			
					SCALE 1:2			
					SHEET 4 of 4			
					REV D			