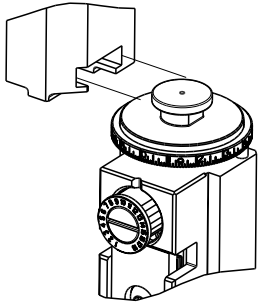


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266451-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266451-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266451-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.05 mm [.120]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL				YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 SYSTEM CONNECTOR FEMALE							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
5.00-5.50 mm [.197-.217 IN]				Ø1.40-2.20 mm [.055-.087 IN]			
TERMINAL APPLICATION SPECIFICATION		YAZAKI SPEC Rev		-		-	
TERMINALS APPLIED				5			
TE TERMINAL		YAZAKI TERMINAL		TE TERMINAL		YAZAKI TERMINAL	
2113144-1		7116-4120-02		1949028-1		7114-4120-02	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.40+/-0.05 [.055+/- .002]	3.9
0.75mm2	1.30+/-0.05 [.051+/- .002]	5.0
0.50mm2	1.25+/-0.05 [.049+/- .002]	5.3



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 GRIND TO LENGTH AT ASSEMBLY.
7. 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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		B		ECR-15-013270	08SEP2015	MR	GB	
		C		ECR-19-004700	25MAR2019	FJ	TE	
		C1		ECR-20-000343	09JAN2020	MZ	GB	
		D		ECR-20-006183	29APR2020	JWC	GB	

-	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	2119082-4	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	1	2063440-2	AIR FEED MODULE	238
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	SPACER, CRIMPER	82
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-6	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	454276-5	FLOATING SHEAR, FRONT	9
1	2	1	2-1633922-1	ANVIL, COMBINATION	8
-	1	1	3-240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	2	1	6-1633964-4	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
1	2	1	3-456407-3	CRIMPER, WIRE PREMIUM	1
-77-72	-2		PART NO	DESCRIPTION	ITEM NO

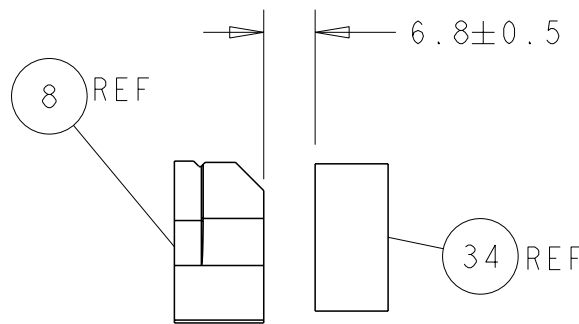
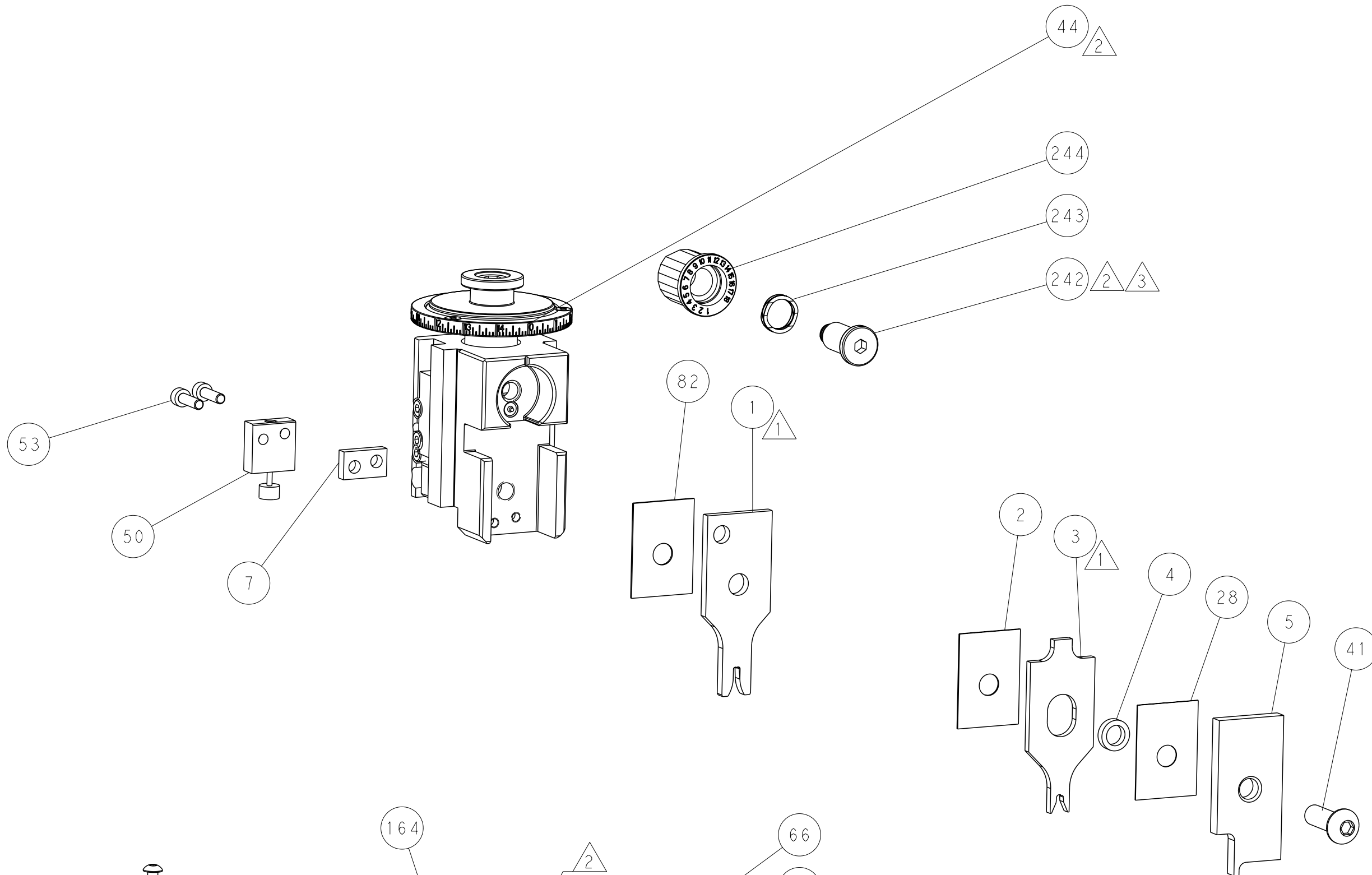
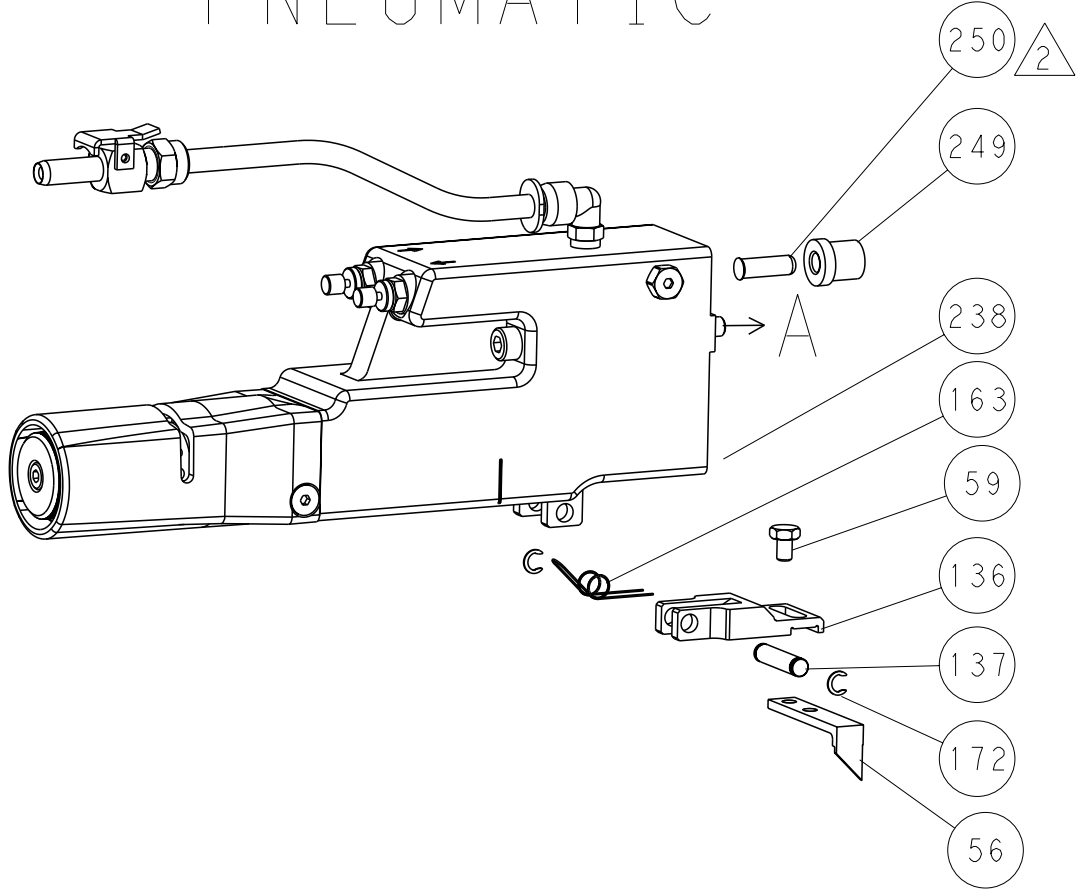
THIS DRAWING IS CONTROLLED DOCUMENT FOR THE PRODUCTION OF THE PRODUCT. IT IS SUBJECT TO CHANGE AND TO THE CONTROL OF THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN J. HOW 30 JULY 2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm				CHK Y. YIN 30 JULY 2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD U. GUO 30 JULY 2014	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -				PRODUCT SPEC -	00779 ©=2266451	
FINISH -				APPLICATION SPEC -	Customer Accessible Production Drawing	
				WEIGHT -	SCALE 1:2	
					SHEET 1 of 4	
					REV D	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

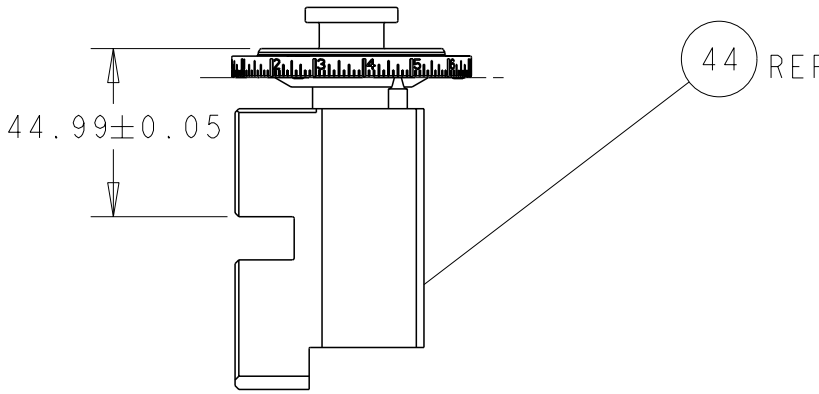
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

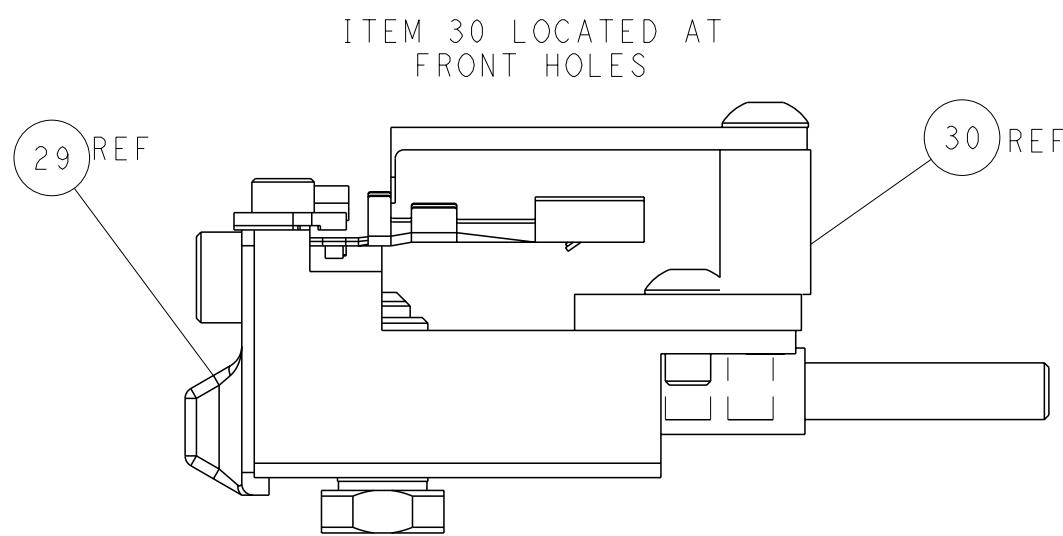
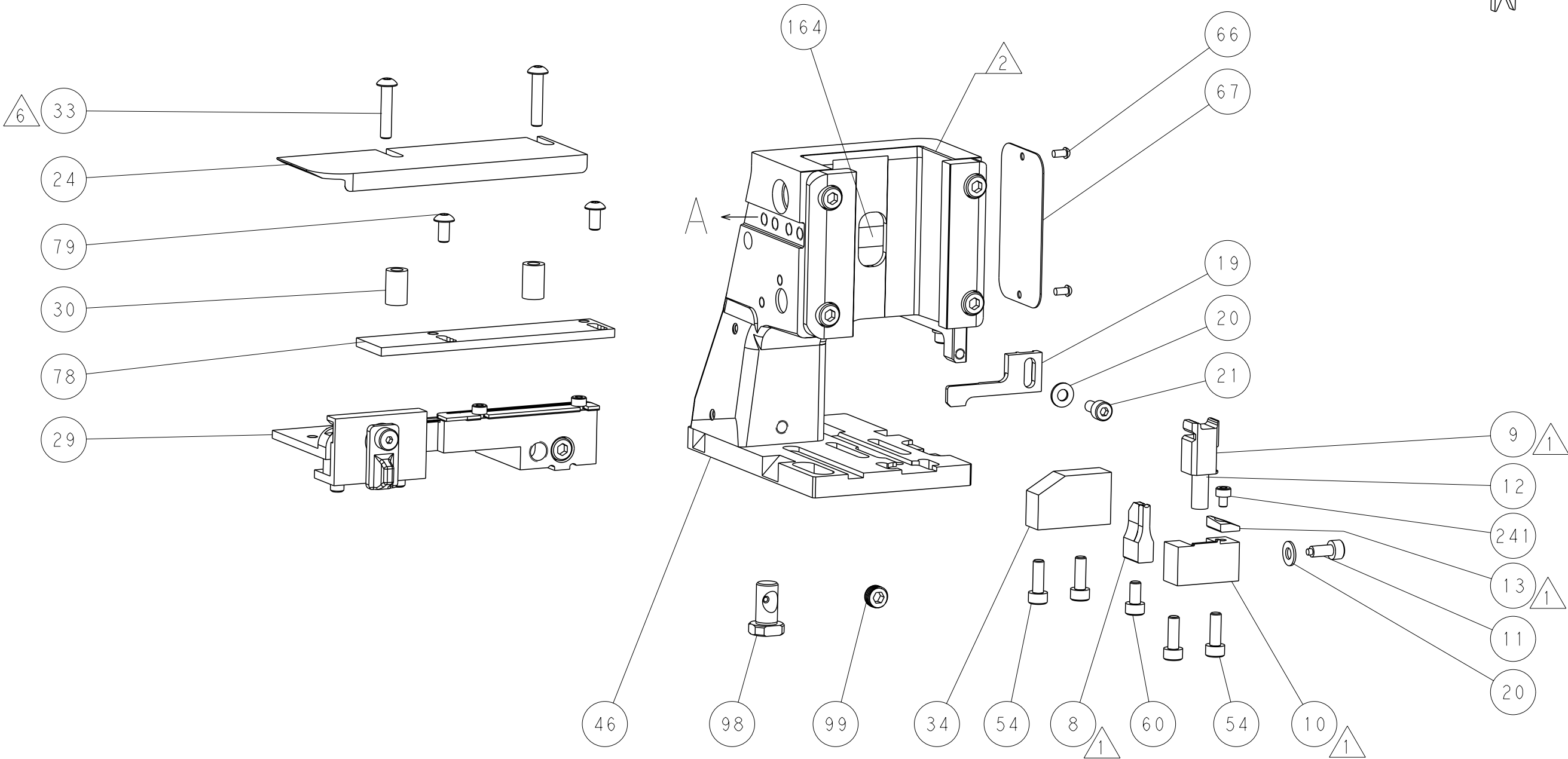
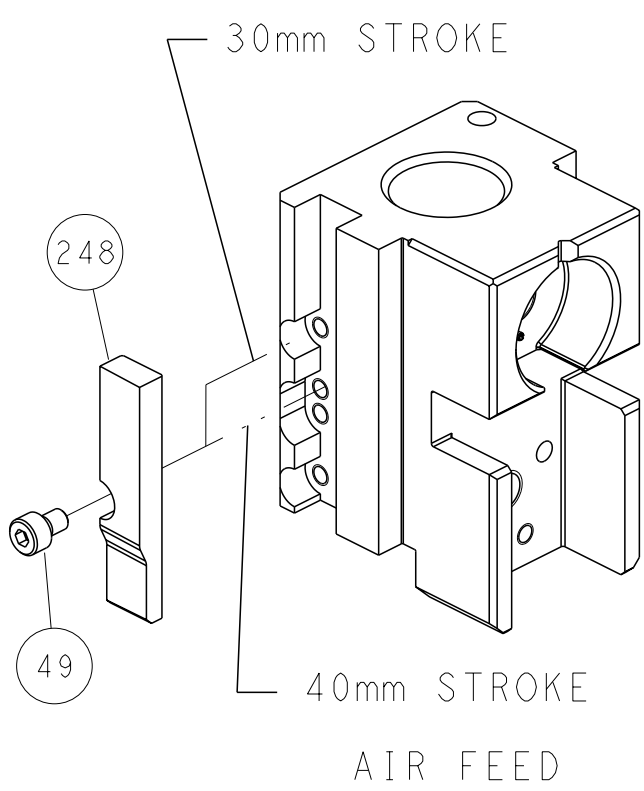


TERMINAL SUPPORT LOCATION



HOLDOWN SET-UP

CAM POSITION



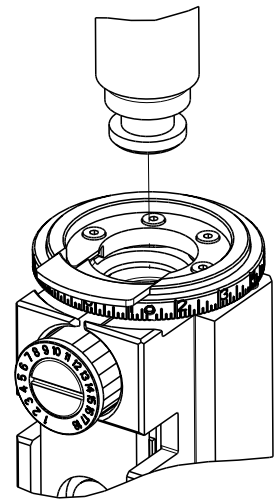
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN J. HOW 30 JULY 2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK Y. YIN 30 JULY 2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD U. GUO 30 JULY 2014	PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -	SIZE A1	CAGE CODE 00779
			DRAWING NO C=2266451	RESTRICTED TO -
		Customer Accessible Production Drawing		
		SCALE 1:2	SHEET 2	REV D

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266451-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266451-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.05 mm [.120]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 SYSTEM CONNECTOR FEMALE			
WIRE STRIP LENGTH 5.00-5.50 mm [.197-.217 IN]		INSULATION DIAMETER RANGE Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	YASAKI SPEC Rev	-	-
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
2113144-1	7116-4120-02	1949028-1	7114-4120-02

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.25mm2		1.40+/-0.05 [.055+/-0.002]		3.9
0.75mm2		1.30+/-0.05 [.051+/-0.002]		5.0
0.50mm2		1.25+/-0.05 [.049+/-0.002]		5.3



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 GRIND TO LENGTH AT ASSEMBLY.
7. 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)

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

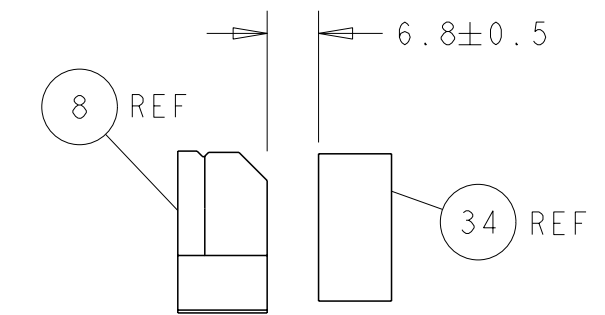
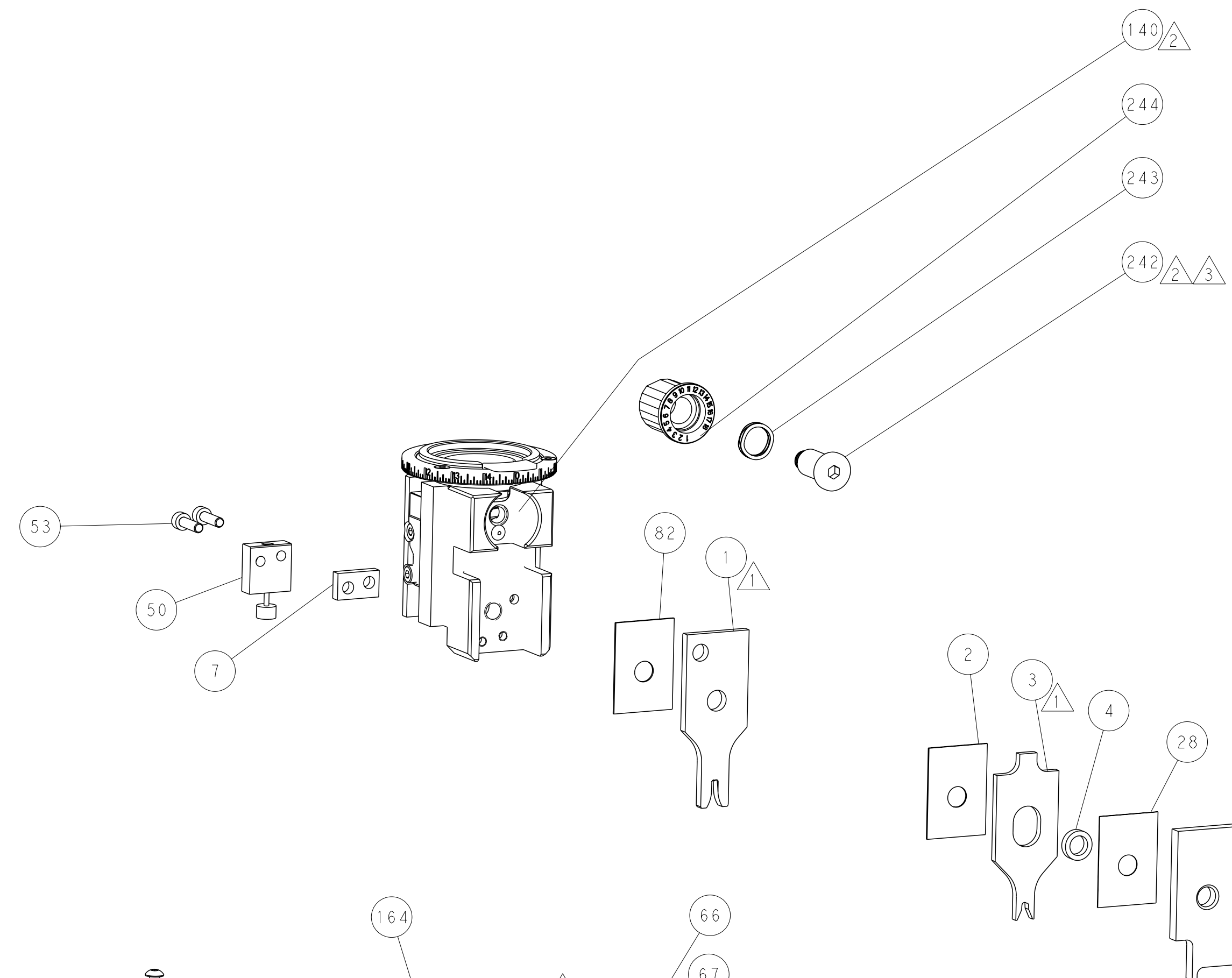
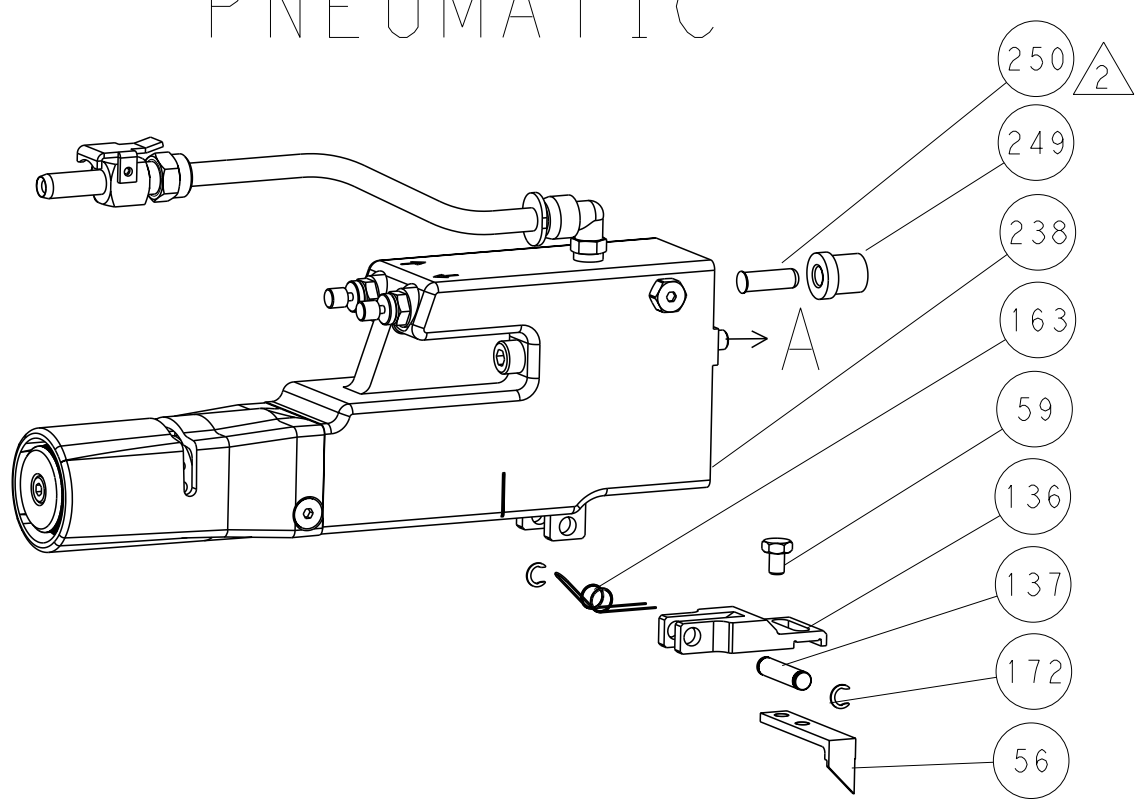
	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1803259-1	BUSHING, FLANGED	249
	-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2063440-2	AIR FEED MODULE	238
	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	240638-1	SPRING, FEED FINGER	163
	-	1	2119641-2	FEED CAM, AIR FEED	151
	-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	-	2119653-2	FEED CAM, POST FEED	142
	-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	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	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	455888-6	SPACER, CRIMPER	82
	-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
	-	1	1803096-1	EXTENSION PLATE	78
	-	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1338685-1	PAWL, FEED	56
	-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
	-	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1752356-1	SUPPORT, TERMINAL	34
6	-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
	-	1	455888-3	SPACER, CRIMPER	28
	-	1	1320928-6	STRIP GUIDE	24
	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	2119806-1	INSERT, SHEAR	13
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-4	STOP, SHEAR	11
1	-	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	454276-5	FLOATING SHEAR, FRONT	9
1	1	1	2-1633922-1	ANVIL, COMBINATION	8
	-	1	3-240641-1	SPACER	7
	-	-	-	-	6
	-	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	6-1633964-4	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	455888-5	SPACER, CRIMPER	2
1	1	1	3-456407-3	CRIMPER, WIRE PREMIUM	1
	-77	-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC INDUSTRY. IT IS SUBJECT TO CHANGE AND TO BE USED IN ACCORDANCE WITH THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	J. HOW	30JULY2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:				CHK	Y. YIN	30JULY2014	NAME	
mm				APVD	U. GUO	30JULY2014	PRODUCT SPEC	
				APPLICATION SPEC				
MATERIAL				WEIGHT				
-				-				
Customer Accessible Production Drawing				SCALE				
-				1:2				
-				SHEET				
-				3				
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-				4				
-				REV				
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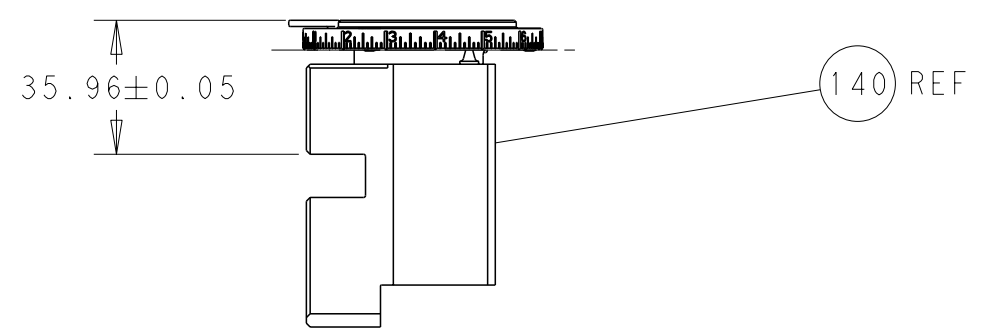
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE
PNEUMATIC

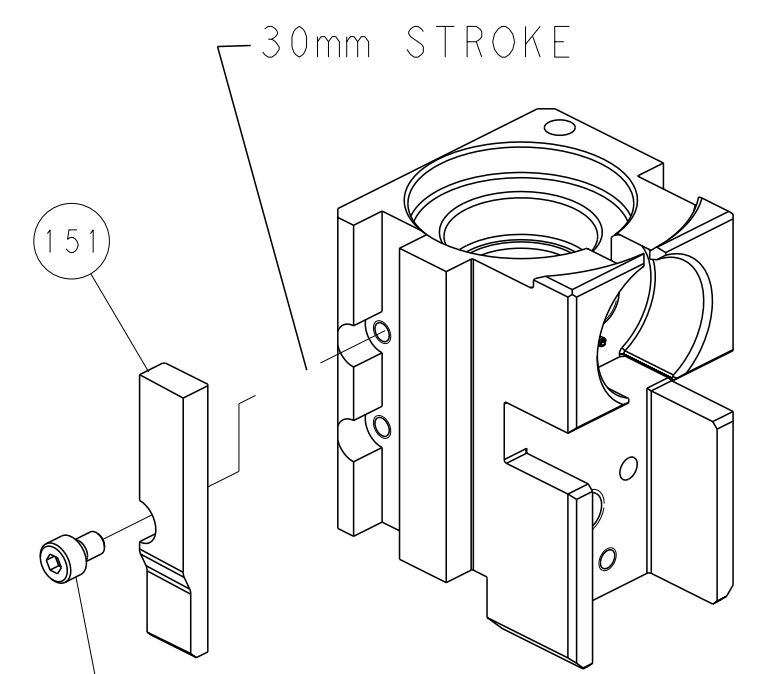


TERMINAL SUPPORT LOCATION

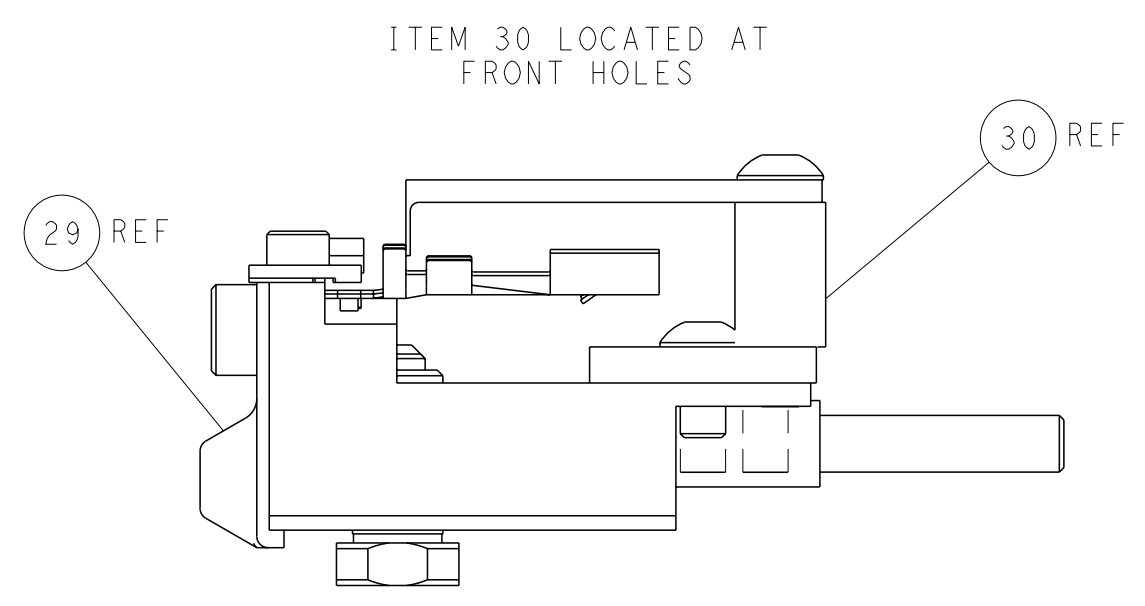
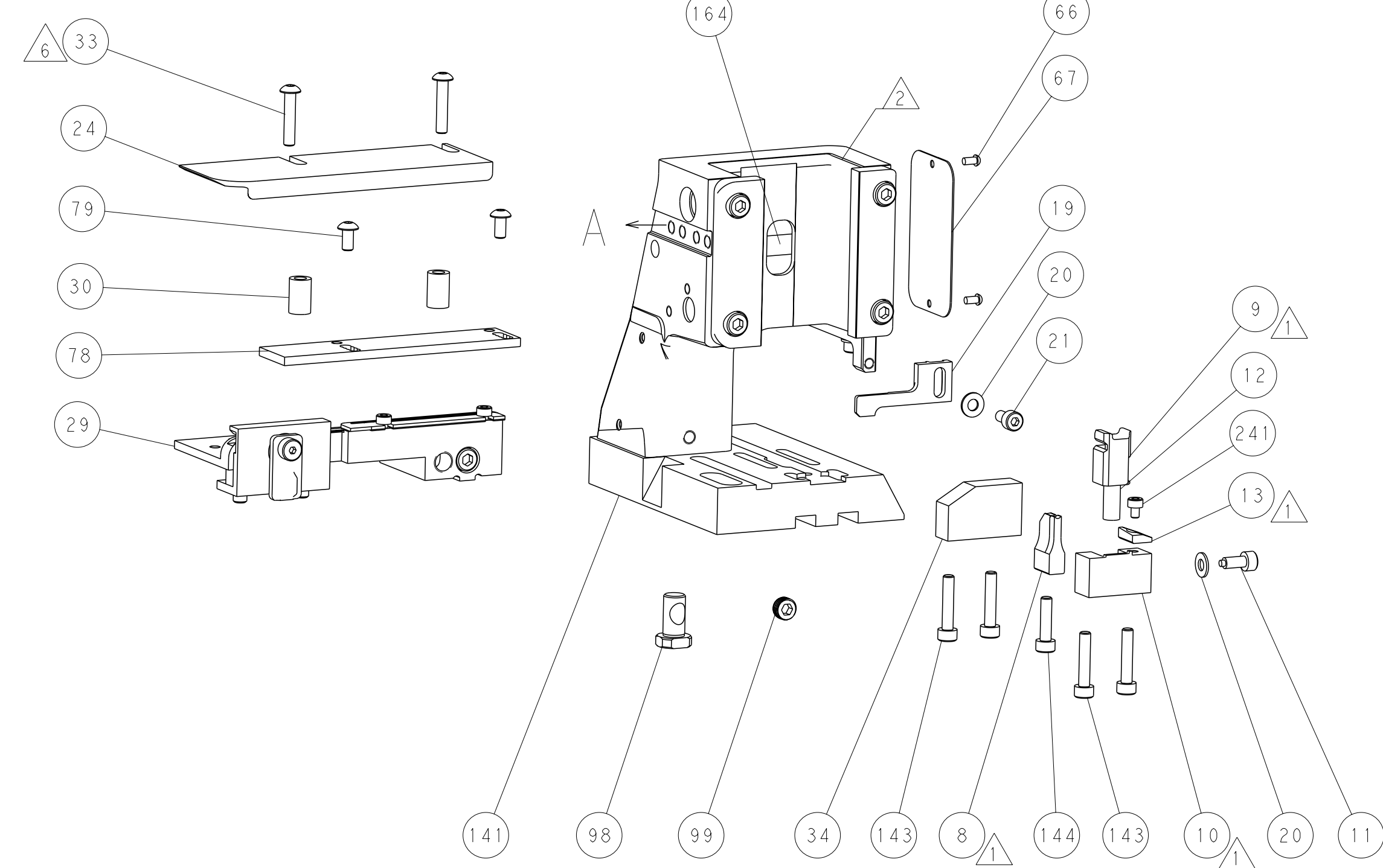


HOLDOWN SET-UP

CAM POSITION



AIR FEED



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 CANCELLATION WITHOUT NOTICE. ANY REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN J. HOW 30JULY2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK Y. YIN 30JULY2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD U. GUO 30JULY2014	SIZE A1	
MATERIAL -		PRODUCT SPEC -	CAGE CODE DRAWING NO 00779 C=2266451	
		APPLICATION SPEC -	RESTRICTED TO -	
		WEIGHT -	Customer Accessible Production Drawing	
		SCALE 1:2	SHEET 4 OF 4 REV D	