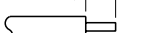


|                                                                      |          |                                  |            |
|----------------------------------------------------------------------|----------|----------------------------------|------------|
| 8                                                                    |          | 7                                |            |
| THIS DRAWING IS UNPUBLISHED.                                         |          | RELEASED FOR PUBLICATION         |            |
| 20                                                                   |          | 20                               |            |
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| PART NUMBER                                                          | REVISION | DESCRIPTION                      | FEED TYPE  |
| 2266496-1                                                            | G        | FINE CRIMP HEIGHT ADJUST         | MECHANICAL |
| 2266496-2                                                            | G        | FINE CRIMP HEIGHT ADJUST         | PNEUMATIC  |
| 7-2266496-1                                                          | G        | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2266496-2                                                          | G        | PNEUMATIC AND CRIMP TOOLING KIT  | PNEUMATIC  |
| 7-2266496-7                                                          | E        | CRIMP TOOLING KIT                | -          |

|                                      |                |      |
|--------------------------------------|----------------|------|
| APPLICATOR DATA                      |                |      |
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.00 mm [.039] | F    |
| INSUL                                | 1.09 mm [.043] | F    |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                |      |

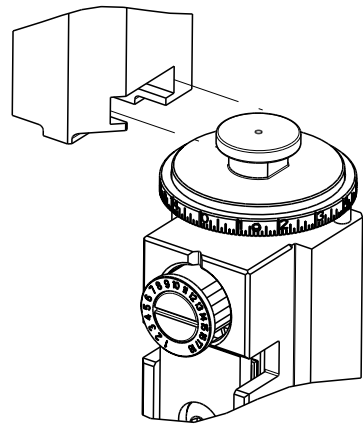
|                                                                                                     |                              |                                                                                   |                                                           |
|-----------------------------------------------------------------------------------------------------|------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: MOLEX TERMINAL                                                                       |                              | MOLEX CRIMP SPECIFICATION                                                         |                                                           |
| TERMINAL NAME: EMIX CONN., 1.5mm PITCH TERMINAL                                                     |                              |                                                                                   |                                                           |
| WIRE STRIP LENGTH<br>1.05-1.54 mm [.041-.061 IN]                                                    |                              |  | INSULATION DIAMETER RANGE<br>Ø0.90-1.15 mm [.035-.045 IN] |
| TERMINAL APPLICATION SPECIFICATION                                                                  | ATS-639014200 Rev D          | -                                                                                 | -                                                         |
| TERMINALS APPLIED  |                              |                                                                                   |                                                           |
| TE TERMINAL<br>1949551-1                                                                            | MOLEX TERMINAL<br>87421-0000 |                                                                                   |                                                           |

|                   |                            |                                   |
|-------------------|----------------------------|-----------------------------------|
| WIRE SIZE         | CRIMP HEIGHT<br>mm [INCH]  | CRIMP HEIGHT<br>REFERENCE SETTING |
| 24 AWG OR 0.20mm2 | 0.58+/- .02 [.023+/- .001] | 6.7                               |
| 26 AWG OR 0.12mm2 | 0.55+/- .03 [.022+/- .001] | 7.2                               |
| 28 AWG OR 0.08mm2 | 0.55+/- .03 [.022+/- .001] | 7.2                               |
| 30 AWG OR 0.05mm2 | 0.55+/- .03 [.022+/- .001] | 7.2                               |



- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

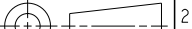
ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



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

|     |      |           |     |               |           |      |
|-----|------|-----------|-----|---------------|-----------|------|
| LOC | DIST | REVISIONS |     |               |           |      |
| A   | 66   | P         | LYR | DESCRIPTION   | DATE      | DWN  |
|     |      |           |     |               |           | APVD |
|     |      | D1        |     | ECR-16-016564 | 22NOV2016 | TB   |
|     |      | E         |     | ECR-17-003482 | 09MAR2017 | TB   |
|     |      | F         |     | ECR-19-003138 | 26FEB2019 | TB   |
|     |      | G         |     | ECR-19-012465 | 07AUG2019 | MEH  |

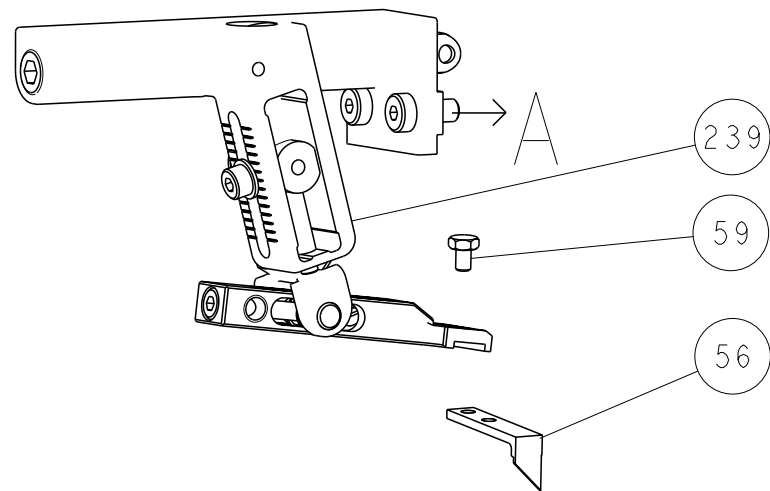
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|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
|   | -   | 1   | -   | 1   | -   | 2119640-1   | PUSH ROD, AIR FEED                  | 250     |
|   | -   | 1   | -   | 1   | -   | 1803259-1   | BUSHING, FLANGED                    | 249     |
|   | -   | 1   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248     |
|   | -   | 1   | 1   | 1   | 1   | 2119082-4   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
|   | -   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| 3 | -   | 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   | -   | 2063440-1   | AIR FEED MODULE                     | 238     |
|   | -   | 2   | 2   | 2   | 2   | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)            | 230     |
| 3 | -   | 1   | 1   | 1   | 1   | 1-1752354-4 | STANDOFF,HOLD-DOWN                  | 180     |
|   | -   | 1   | 1   | 1   | 1   | 1-1633764-7 | HOLD DOWN, TERMINAL                 | 179     |
|   | -   | 1   | 1   | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177     |
|   | -   | 1   | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176     |
|   | -   | 1   | 1   | 1   | 1   | 1752353-2   | GUIDE PIN,HOLDDOWN                  | 175     |
|   | -   | 1   | 1   | 1   | 1   | 1901680-2   | GUIDE PIN,HOLDDOWN                  | 174     |
|   | -   | 2   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172     |
|   | -   | REF | REF | 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     |
| 5 | -   | 1   | 1   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113     |
|   | -   | 1   | 1   | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99      |
|   | -   | 1   | 1   | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98      |
|   | -   | 1   | 1   | 1   | 1   | 1-455888-8  | SPACER, CRIMPER                     | 82      |
|   | -   | 1   | 1   | 1   | 1   | 1803607-1   | DOCUMENTATION PACKAGE               | 71      |
|   | -   | 1   | 1   | 1   | 1   | 2119791-9   | DEPRESSOR, WIRE                     | 70      |
|   | -   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69      |
|   | -   | 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   | 1338685-1   | PAWL, FEED                          | 56      |
|   | -   | 4   | 4   | 4   | 4   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 54      |
|   | -   | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52      |
|   | -   | 1   | 1   | 1   | 1   | 1901681-8   | HOLDDOWN, TERMINAL                  | 51      |
|   | -   | 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   | 1803515-3   | RAM ASSEMBLY, SF ATLANTIC           | 44      |
|   | -   | 1   | 1   | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
|   | -   | 1   | 1   | 1   | 1   | 2-1752356-5 | SUPPORT, TERMINAL                   | 34      |
|   | -   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
|   | -   | 2   | 2   | 2   | 2   | 2-2844962-3 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30      |
|   | -   | 1   | 1   | 1   | 1   | 2844992-1   | ASSEMBLY, STRIP GUIDE               | 29      |
|   | -   | 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   | 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   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
|   | -   | 1   | 1   | 1   | 1   | 1803095-6   | FLOATING SHEAR, FRONT -             | 9       |
| 1 | 1   | 2   | 2   | 1   | 1   | 7-1803249-7 | ANVIL, COMBINATION                  | 8       |
|   | -   | -   | -   | -   | -   | -           | -                                   | 7       |
|   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
|   | -   | 1   | 1   | 1   | 1   | 2119757-1   | DEPRESSOR, SHEAR                    | 5       |
|   | -   | 1   | 1   | 1   | 1   | 238011-6    | BLOCK, CRIMPER SPACER               | 4       |
| 1 | 1   | 2   | 2   | 1   | 1   | 9-1633962-7 | CRIMPER, INSULATION F PREMIUM       | 3       |
|   | -   | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2       |
| 1 | 1   | 2   | 2   | 1   | 1   | 1633609-2   | CRIMPER, WIRE                       | 1       |
|   | -   | -   | -   | -   | -   | -           | -                                   | -       |
|   | -77 | -72 | -71 | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                            |  |  |  |                                        |           |           |                                              |  |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|----------------------------------------|-----------|-----------|----------------------------------------------|--|--|
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|                                                                                                                                                            |  |  |  | CHK                                    | T. ELBIN  | 12MAR2014 |                                              |  |  |
| DIMENSIONS:                                                                                                                                                |  |  |  | APVD                                   | D. STOUGH | 12MAR2014 | NAME                                         |  |  |
| mm                                                                                                                                                         |  |  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |           |           | PRODUCT SPEC                                 |  |  |
|                                                                       |  |  |  | 0 PLC                                  | ±         |           | Ocean Side Feed<br>Applicator<br>-           |  |  |
|                                                                                                                                                            |  |  |  | 1 PLC                                  | ±         |           |                                              |  |  |
|                                                                                                                                                            |  |  |  | 2 PLC                                  | ±         |           |                                              |  |  |
|                                                                                                                                                            |  |  |  | 3 PLC                                  | ±         |           |                                              |  |  |
|                                                                                                                                                            |  |  |  | 4 PLC                                  | ±         |           |                                              |  |  |
| ANGLES                                                                                                                                                     |  |  |  | ±                                      |           |           |                                              |  |  |
| MATERIAL                                                                                                                                                   |  |  |  | FINISH                                 | -         |           | SIZE                                         |  |  |
|                                                                                                                                                            |  |  |  |                                        |           |           | CAGE CODE                                    |  |  |
|                                                                                                                                                            |  |  |  |                                        |           |           | DRAWING NO                                   |  |  |
|                                                                                                                                                            |  |  |  |                                        |           |           | RESTRICTED TO                                |  |  |
|                                                                                                                                                            |  |  |  | WEIGHT                                 | -         |           | A1 00779 ©=2266496                           |  |  |
|                                                                                                                                                            |  |  |  | Customer Accessible Production Drawing |           |           | SCALE 1:2 SHEET 1 OF 4 REV G                 |  |  |

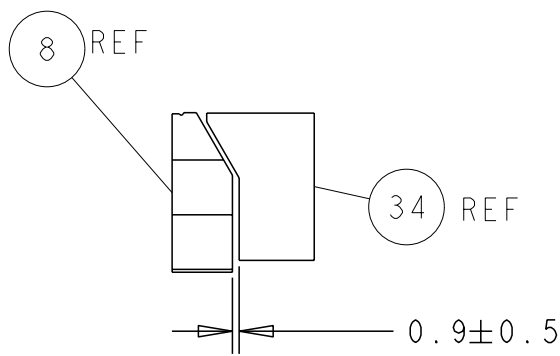
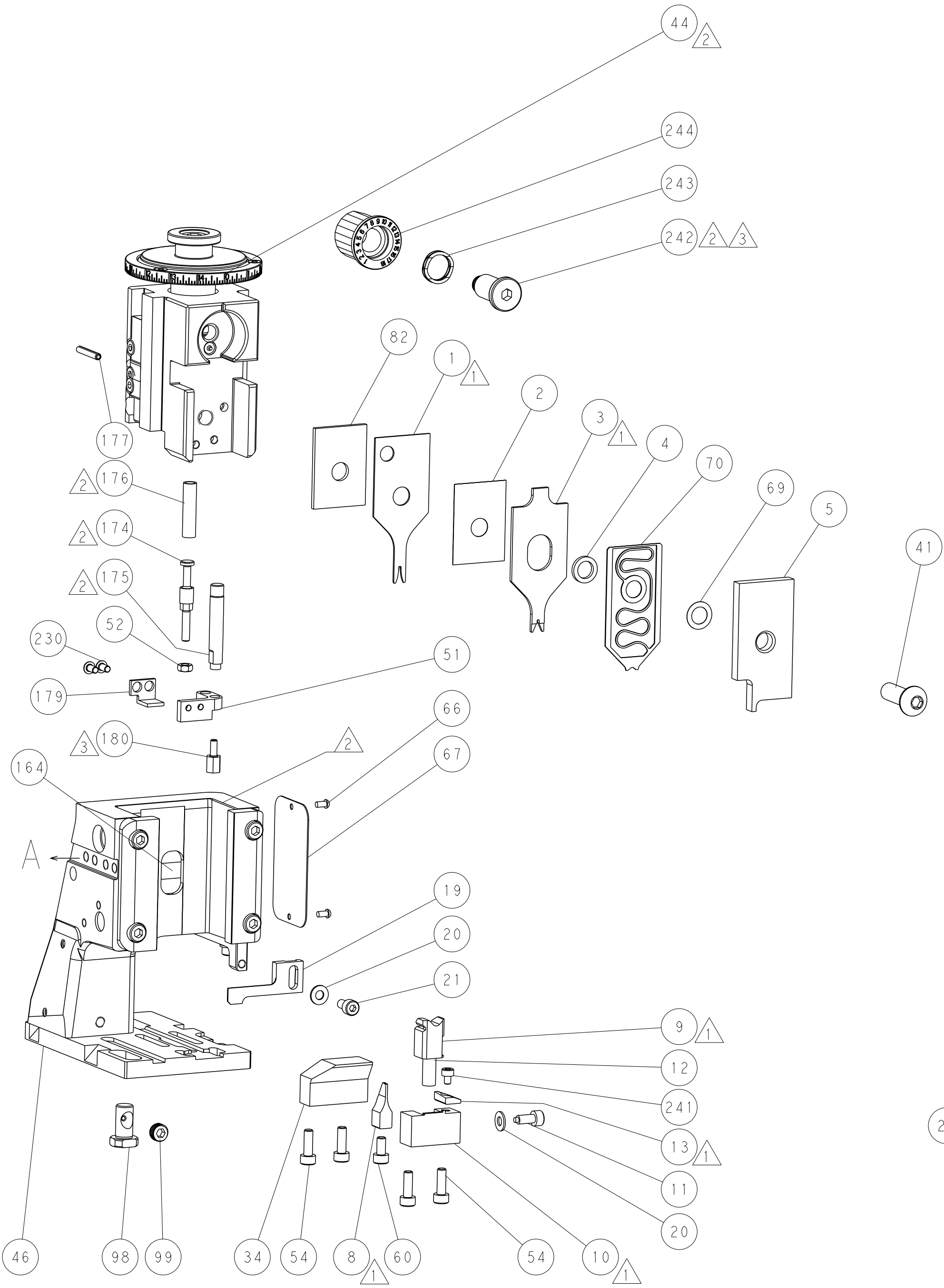
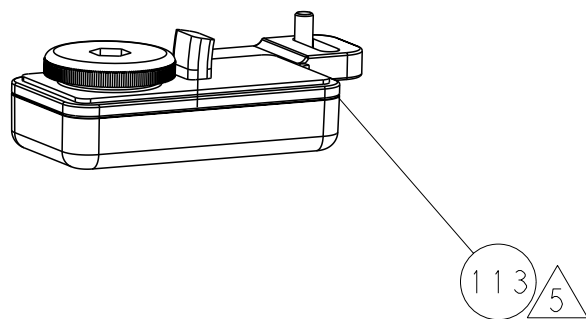
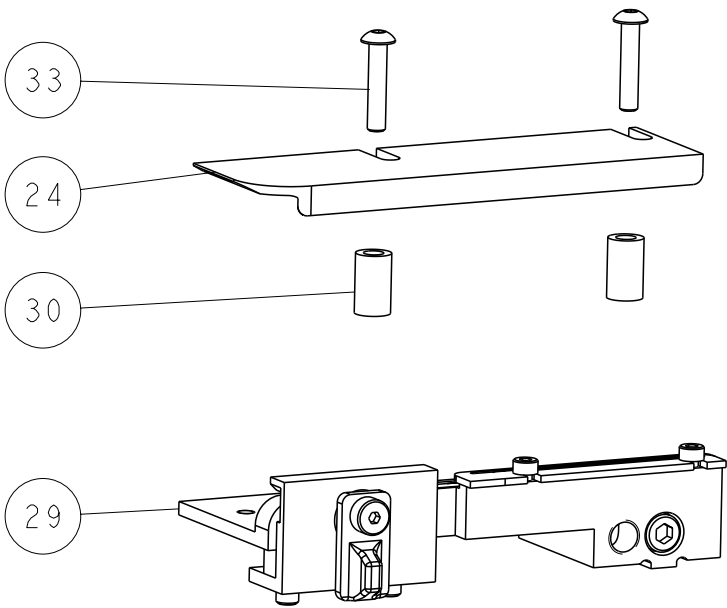
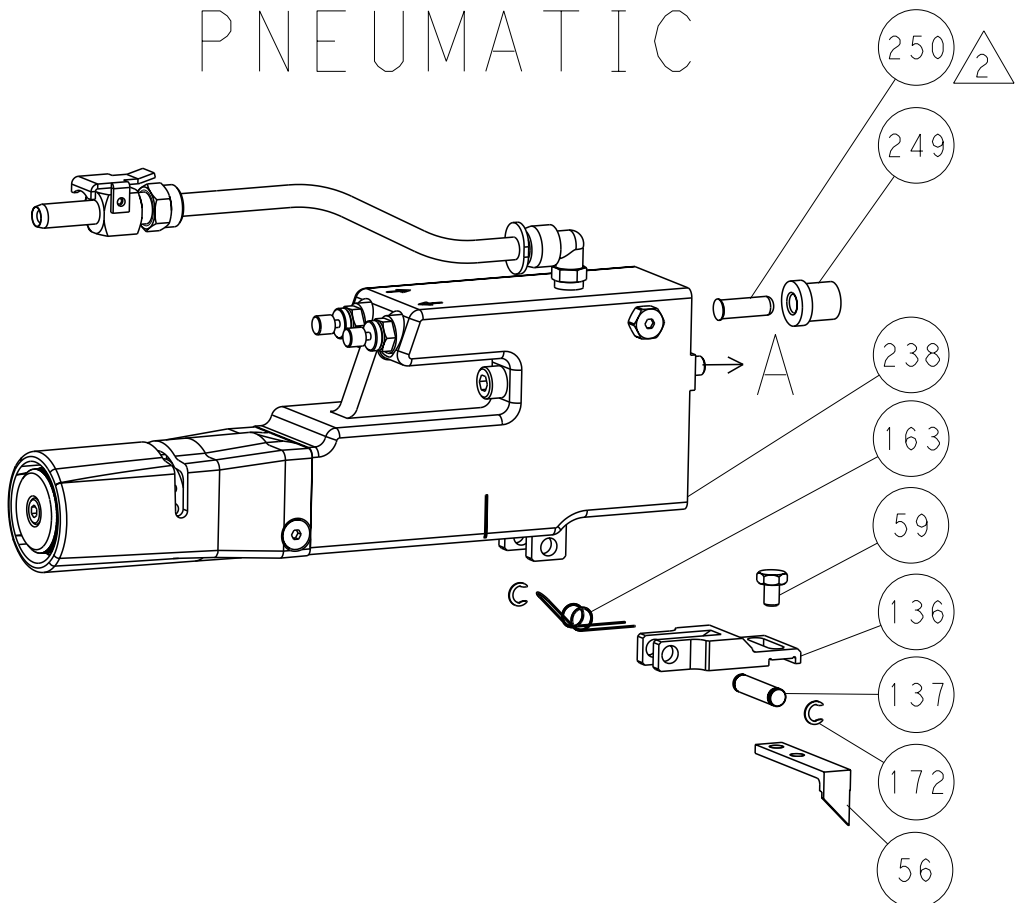


| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
|     |      | P         | LYR | DESCRIPTION | DATE | DWN | APVD |
| A   | 66   |           | -   | SEE SHEET 1 | -    | -   | -    |
|     |      |           |     |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

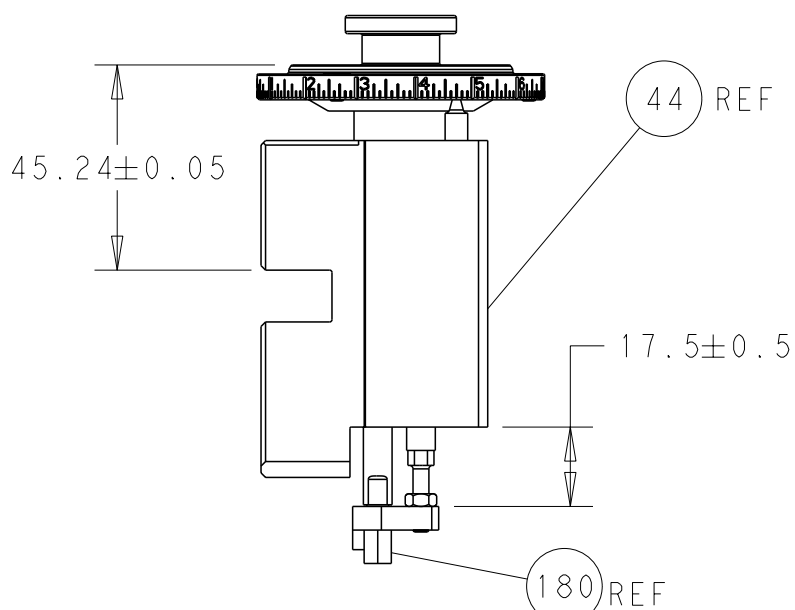
FEED TYPE  
MECHANICAL



PNEUMATIC

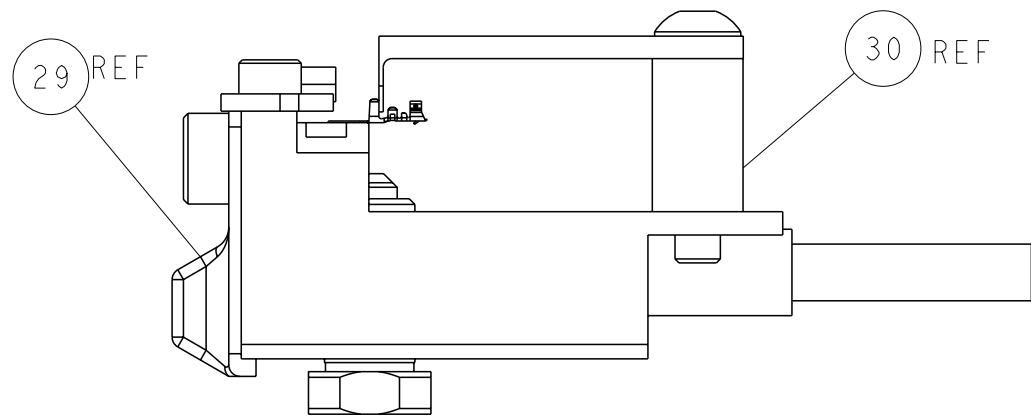


TERMINAL SUPPORT LOCATION



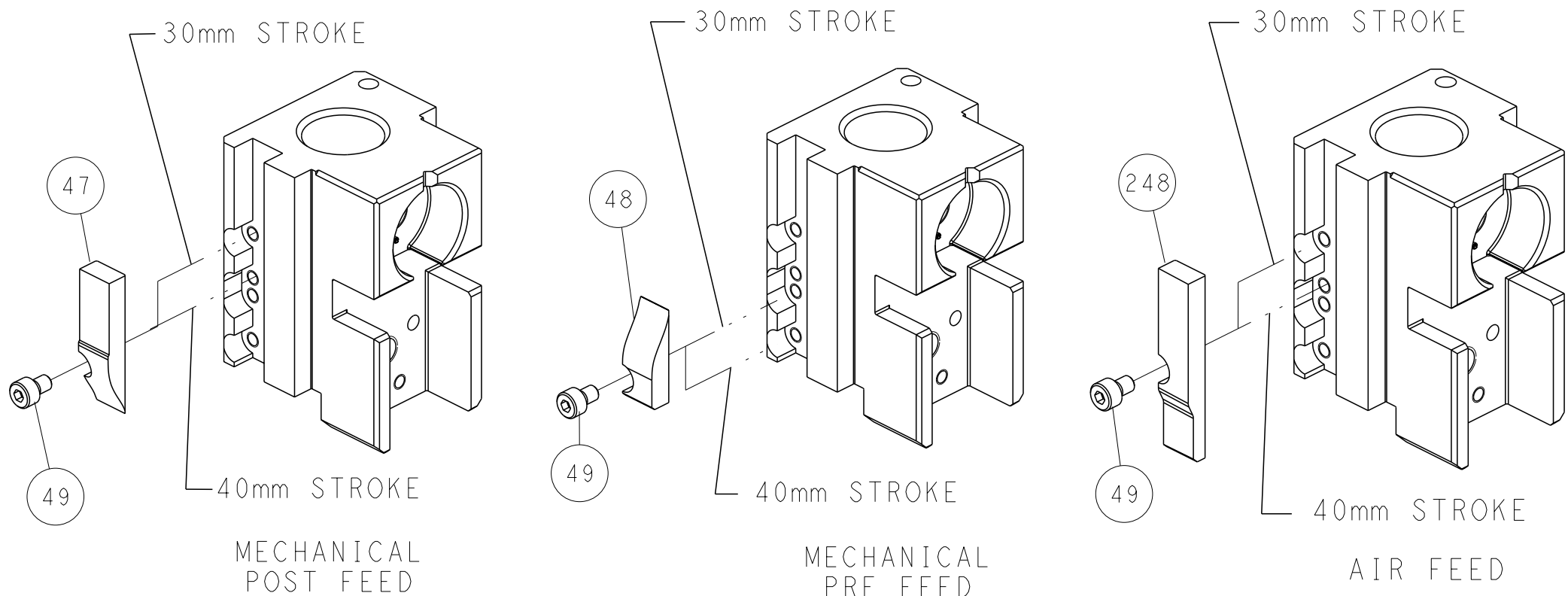
RAM AND HOLDDOWN SET-UP

ITEM 30 LOCATED AT  
FRONT HOLES



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

CAM POSITIONS



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

|             |  |                                           |  |                             |  |                                        |  |
|-------------|--|-------------------------------------------|--|-----------------------------|--|----------------------------------------|--|
| DIMENSIONS: |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED: |  | DWN<br>M. RILEY 12MAR2014   |  | TE Connectivity                        |  |
| mm          |  | 0 PLC ±                                   |  | CHK<br>T. ELBIN 12MAR2014   |  | Harrisburg, PA 17105-3608              |  |
|             |  | 1 PLC ±                                   |  | APVD<br>D. STOUGH 12MAR2014 |  | NAME                                   |  |
|             |  | 2 PLC ±                                   |  | PRODUCT SPEC                |  | Ocean Side Feed                        |  |
|             |  | 3 PLC ±                                   |  | APPLICATION SPEC            |  | Applicator                             |  |
|             |  | 4 PLC ±                                   |  | WEIGHT                      |  | SIZE                                   |  |
|             |  | ANGLES                                    |  | FINISH                      |  | CAGE CODE                              |  |
|             |  |                                           |  |                             |  | DRAWING NO                             |  |
|             |  |                                           |  |                             |  | 00779                                  |  |
|             |  |                                           |  |                             |  | C=2266496                              |  |
|             |  |                                           |  |                             |  | RESTRICTED TO                          |  |
|             |  |                                           |  |                             |  | Customer Accessible Production Drawing |  |
|             |  |                                           |  |                             |  | SCALE                                  |  |
|             |  |                                           |  |                             |  | 1:2                                    |  |
|             |  |                                           |  |                             |  | SHEET                                  |  |
|             |  |                                           |  |                             |  | 2                                      |  |
|             |  |                                           |  |                             |  | OF                                     |  |
|             |  |                                           |  |                             |  | 4                                      |  |
|             |  |                                           |  |                             |  | REV                                    |  |
|             |  |                                           |  |                             |  | G                                      |  |

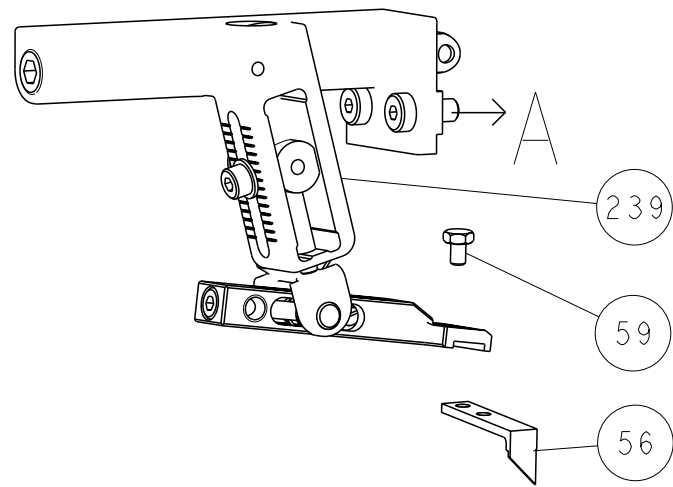




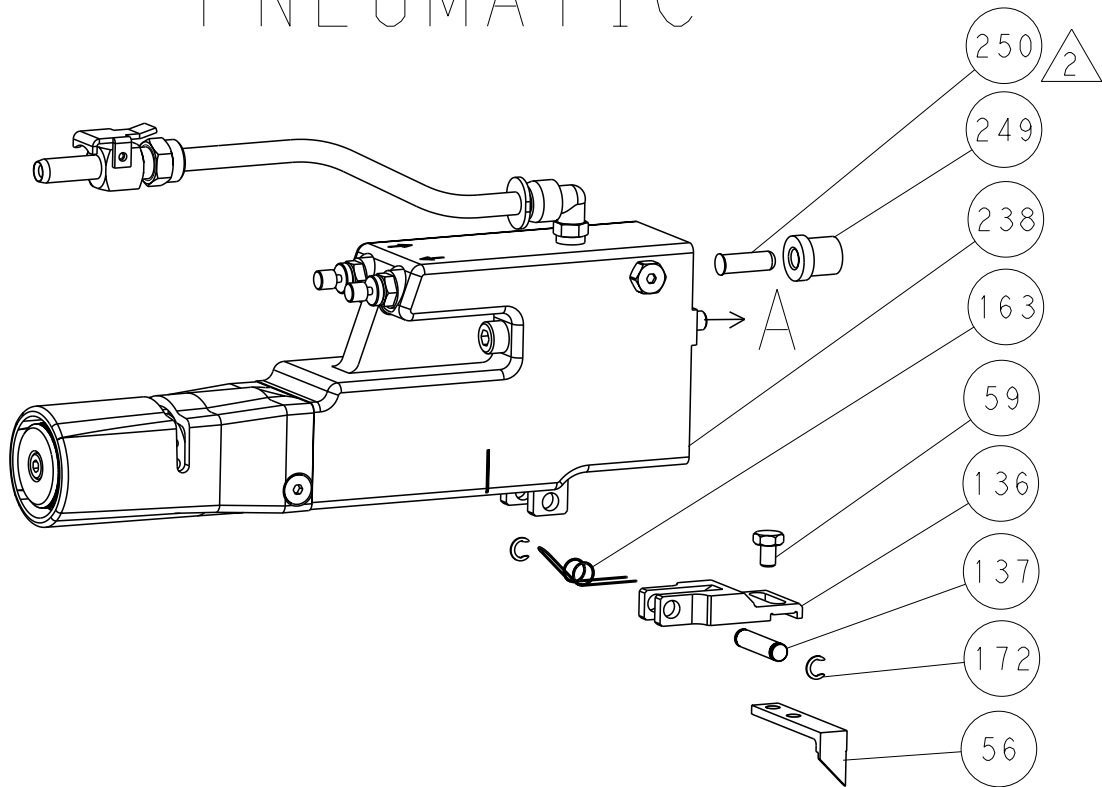


| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
|     |      | P         | LYR | DESCRIPTION | DATE | DWN | APVD |
| A   | 66   |           | -   | SEE SHEET 1 | -    | -   | -    |
|     |      |           |     |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

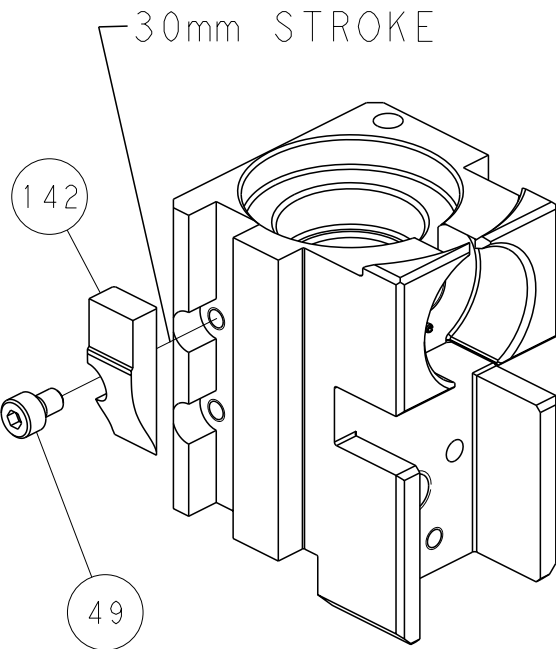
FEED TYPE  
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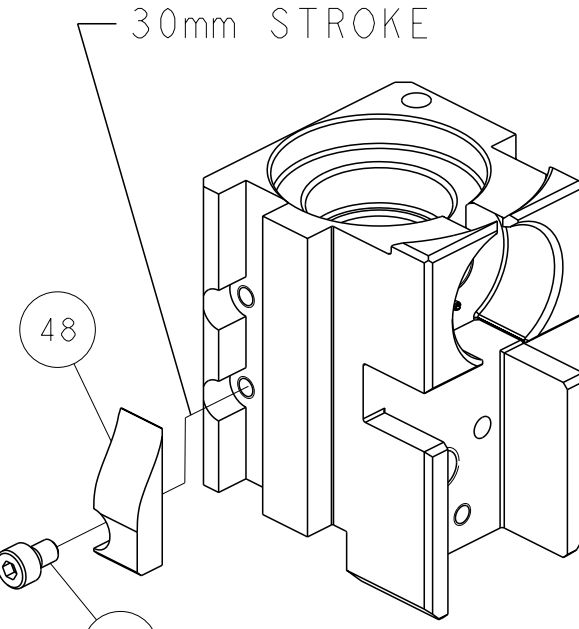
PNEUMATIC



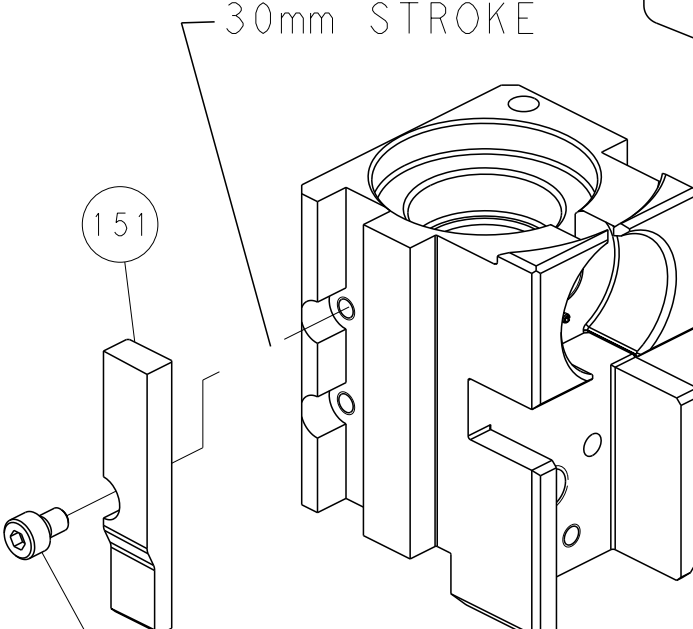
CAM POSITIONS



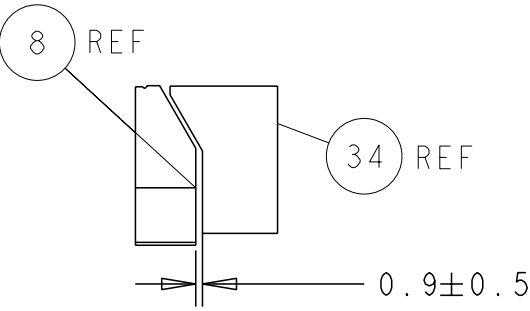
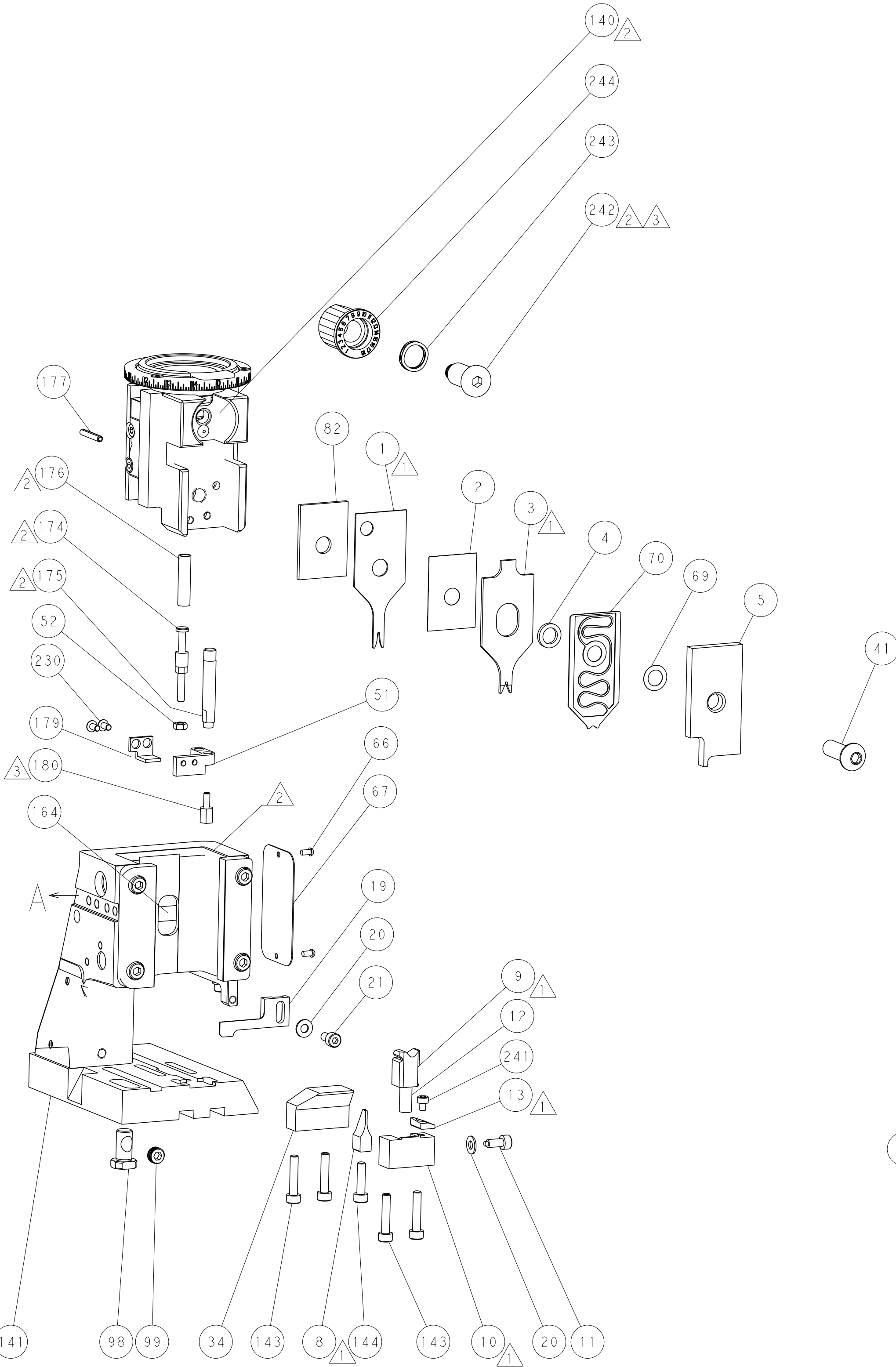
MECHANICAL  
POST FEED



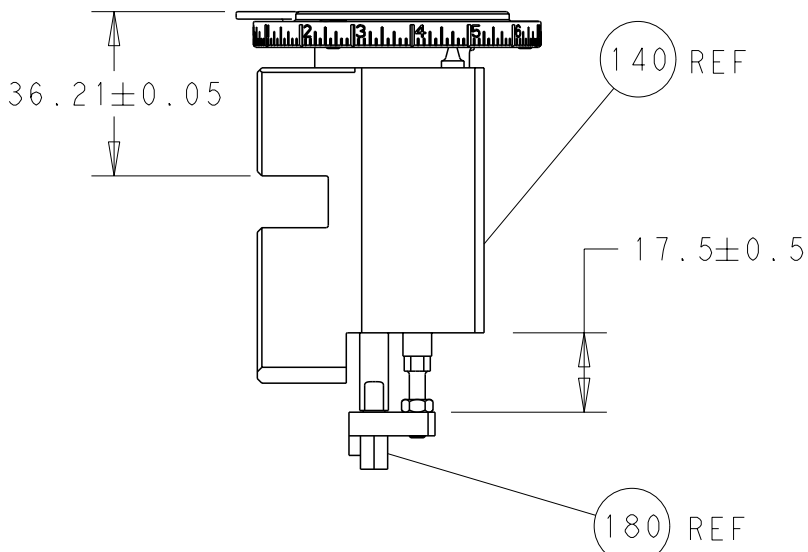
MECHANICAL  
PRE FEED



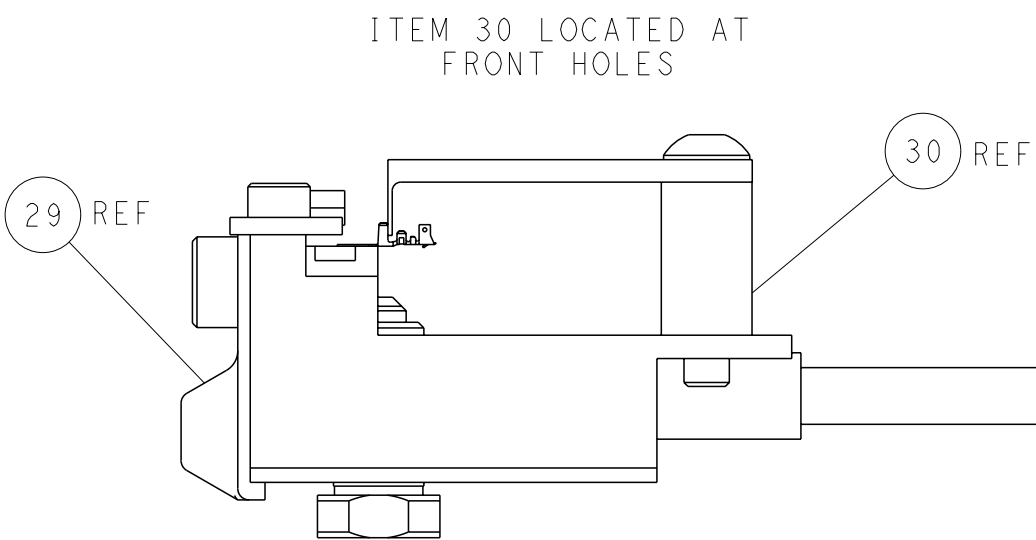
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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)

|                                                                                                                                                                                             |  |  |  |                                |                                                                                                                                    |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--------------------------------|------------------------------------------------------------------------------------------------------------------------------------|--|
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|                                                                                                                                                                                             |  |  |  | CHK<br>T. ELBIN<br>12MAR2014   |                                                                                                                                    |  |
|                                                                                                                                                                                             |  |  |  | APVD<br>D. STOUGH<br>12MAR2014 | NAME<br>Ocean Side Feed<br>Applicator                                                                                              |  |
|                                                                                                                                                                                             |  |  |  | PRODUCT SPEC                   |                                                                                                                                    |  |
|                                                                                                                                                                                             |  |  |  | APPLICATION SPEC               |                                                                                                                                    |  |
|                                                                                                                                                                                             |  |  |  | WEIGHT                         |                                                                                                                                    |  |
|                                                                                                                                                                                             |  |  |  | SCALE<br>1:2                   | SHEET<br>4 of 4                                                                                                                    |  |
|                                                                                                                                                                                             |  |  |  | REV<br>G                       |                                                                                                                                    |  |