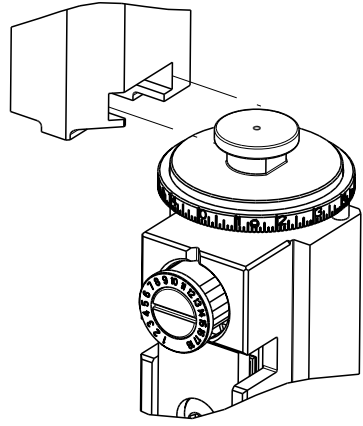
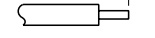


8	7
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20	
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PART NUMBER	REVISION
DESCRIPTION	FEED TYPE
2266772-1	D
2266772-2	D
7-2266772-1	D
7-2266772-2	D
7-2266772-7	A

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.95 mm [.037]	F
INSUL	1.10 mm [.043]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: ZE CONNETOR			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
2.10-2.10 mm [.083-.083 IN]			Ø0.80-1.20 mm [.031-.047 IN]
TERMINAL APPLICATION SPECIFICATION		SZE-002T-P0.3 Rev 4/23/2015	
		-	-
TERMINALS APPLIED 			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2113702-1	SZE-002T-P0.3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.65+/-0.05 [.026+/- .002]	5.7
26 AWG	0.60+/-0.05 [.024+/- .002]	6.2
28 AWG	0.53+/-0.05 [.021+/- .002]	7.1



- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
6. 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)

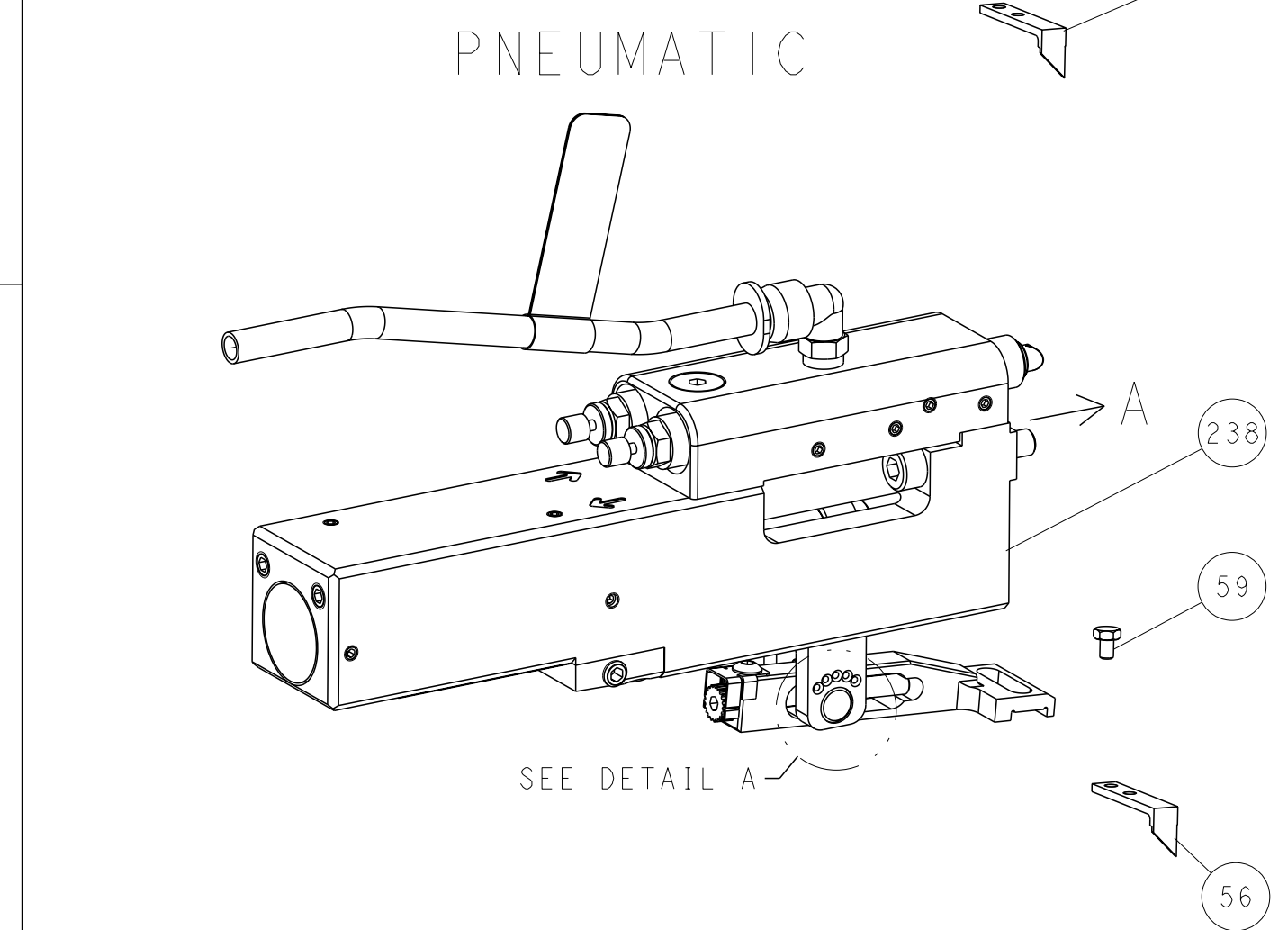
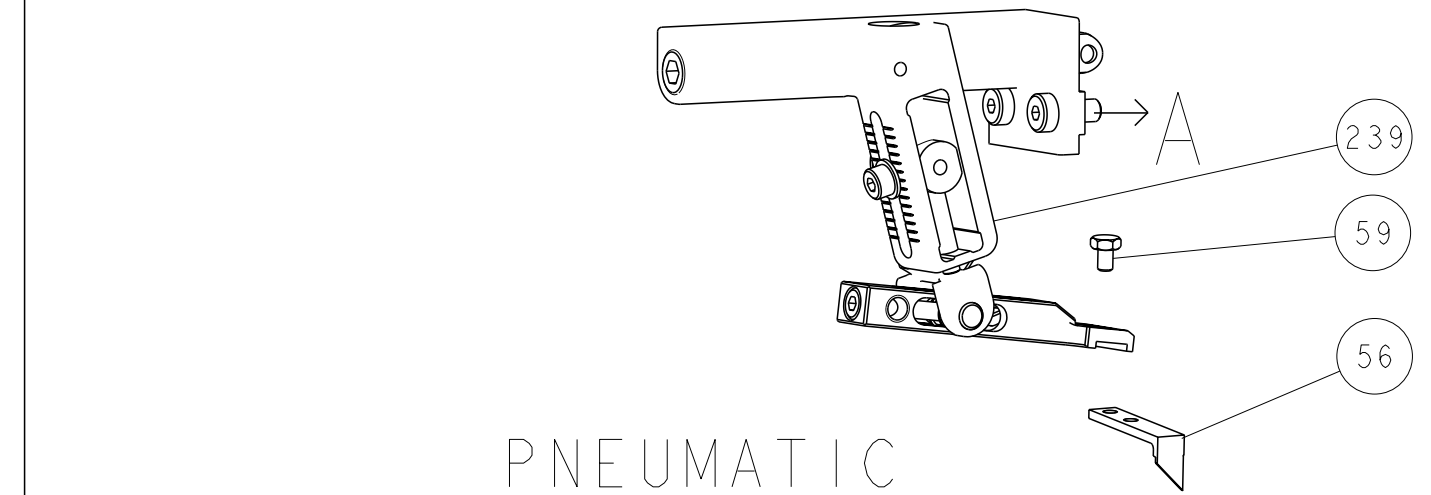
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		C		ECR-17-005268	12APR2017
		D		ECR-19-014138	10SEP2019

	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-5	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	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
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	455888-6	SPACER, CRIMPER	82
	-	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	1338685-1	PAWL, FEED	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	811242-5	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	2-1752356-6	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	2119791-5	DEPRESSOR, WIRE	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	2119533-4	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	1	1803095-3	FLOATING SHEAR, FRONT -	9
1	1	2	2	1	1	8-1803054-2	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-2	DEPRESSOR, SHEAR	5
1	-	1	1	1	1	3-238011-7	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	8-1633962-7	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-6	SPACER, CRIMPER	2
△	1	2	2	1	1	6-1633713-2	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

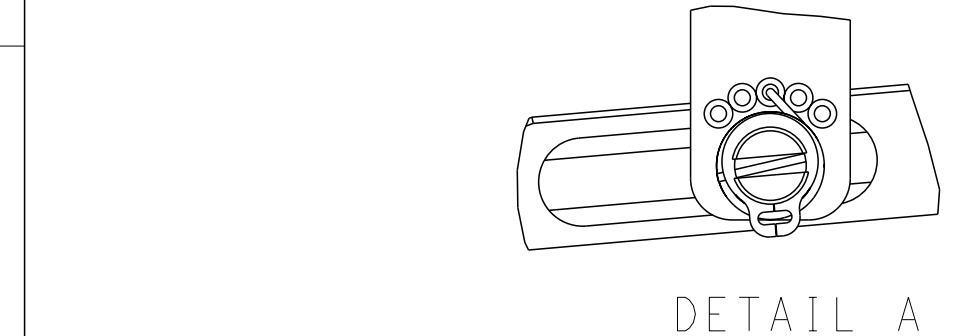
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN	30APR2015	TE Connectivity Harrisburg, PA 17105-3608	
				CHK	30APR2015		
				APVD	30APR2015		
				U	GUO		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME	
mm		0 PLC ±		APPLICATION SPEC		Ocean Side Feed Applicator	
1 PLC ±		2 PLC ±		APPLY		SIZE	
3 PLC ±		4 PLC ±		FINISH		CAGE CODE	
MATERIAL		FINISH		WEIGHT		DRAWING NO	
-		-		-		00779	
						Customer Accessible Production Drawing	
						SCALE	
						1:2	
						SHEET	
						1 of 4	
						REV	
						D	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

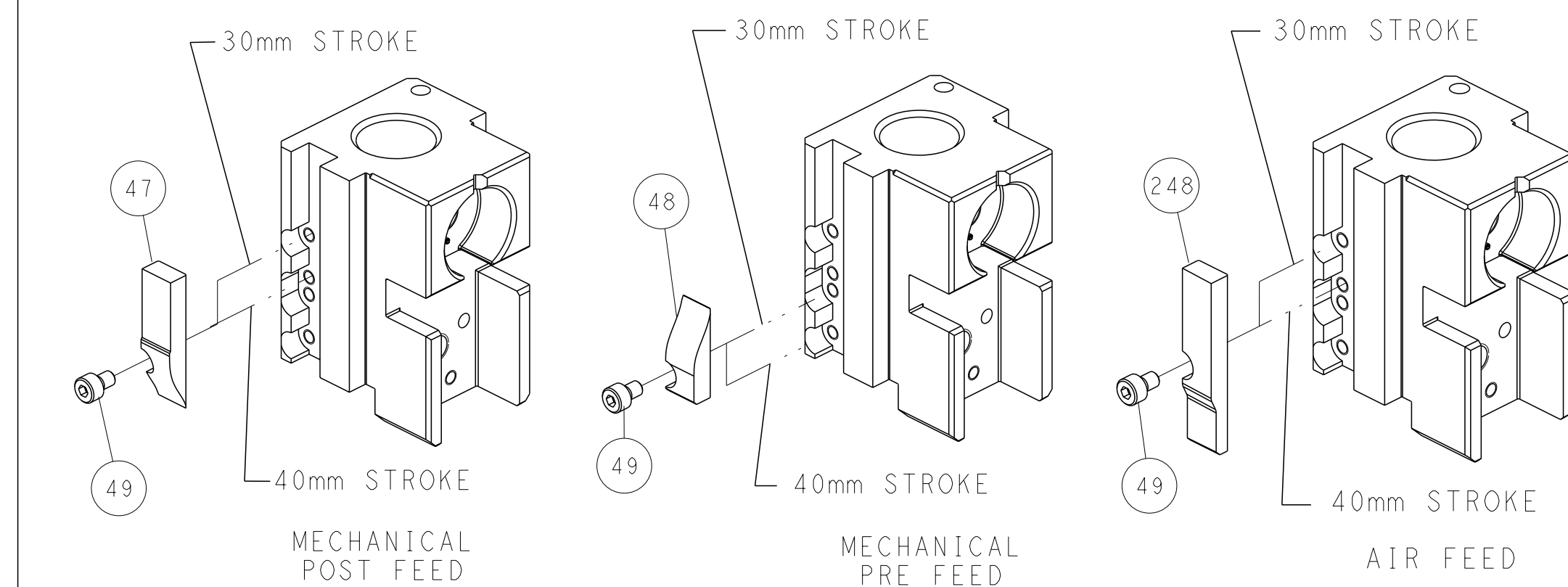
FEED TYPE MECHANICAL



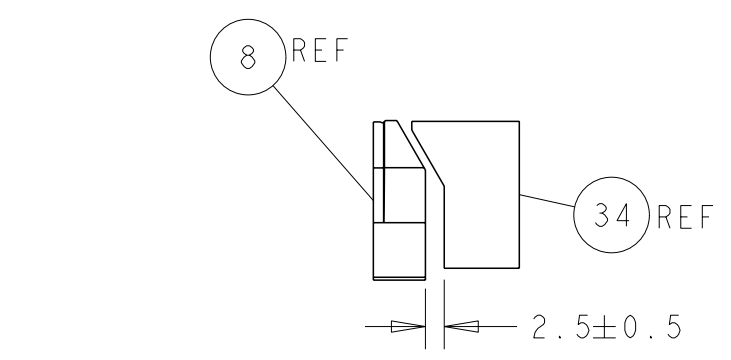
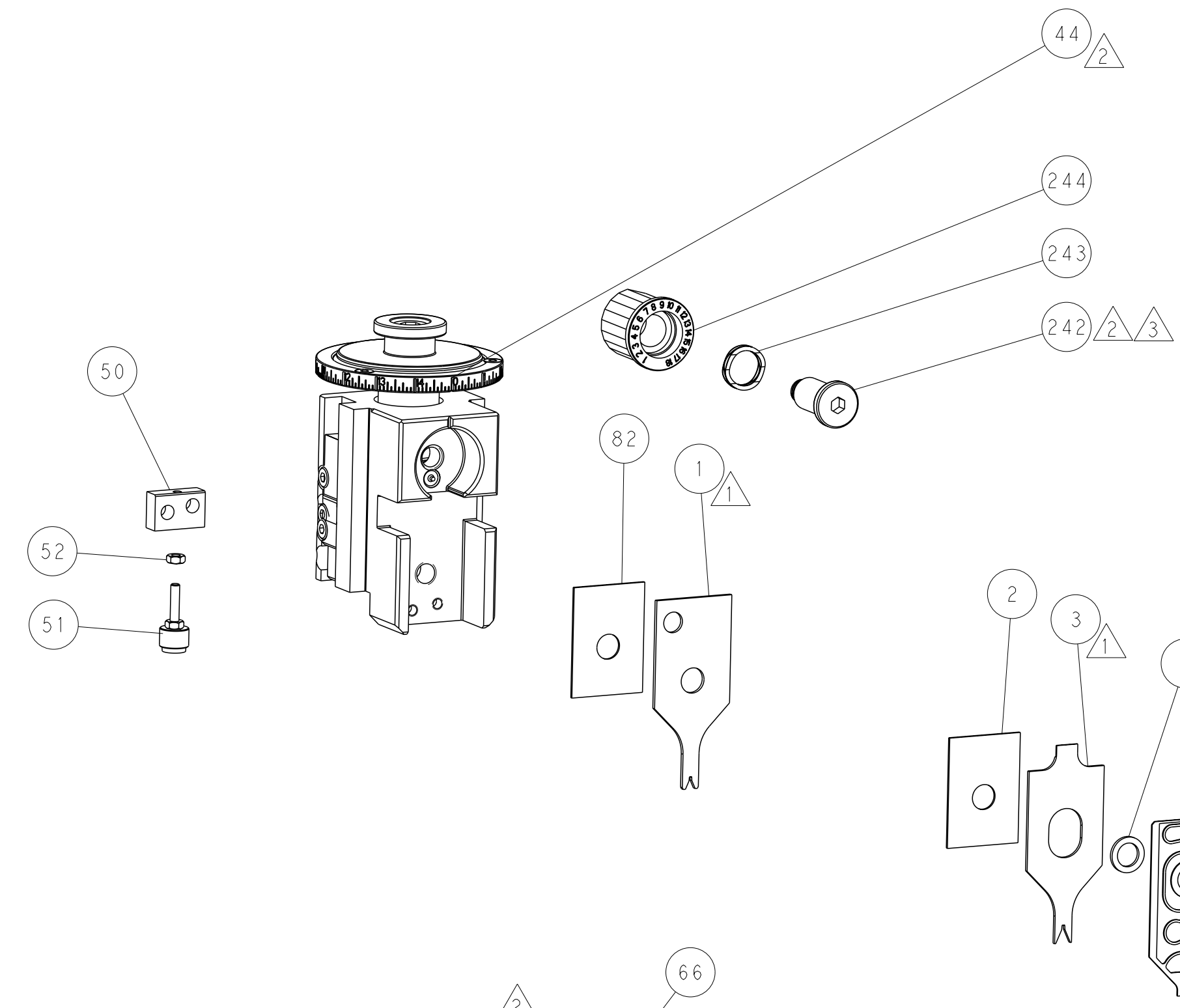
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



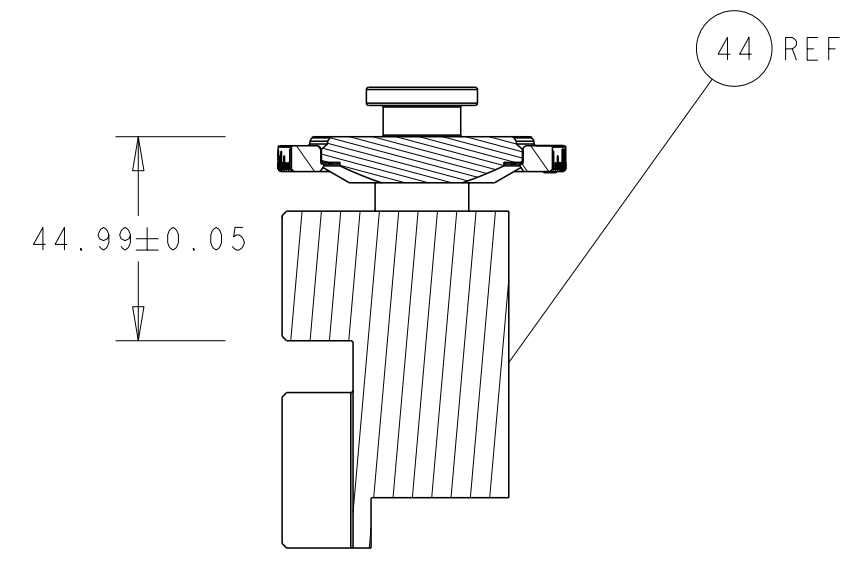
CAM POSITIONS



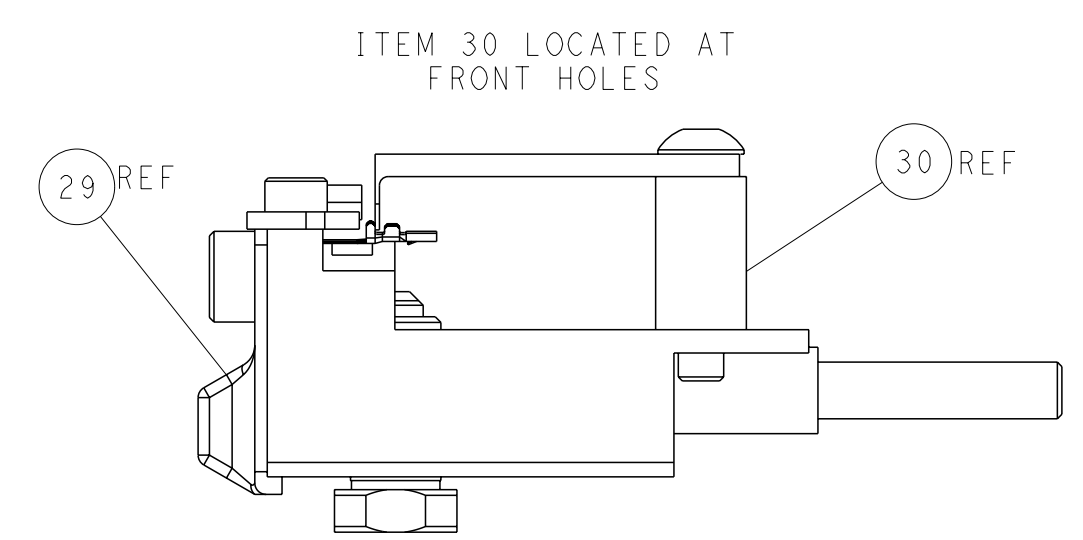
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



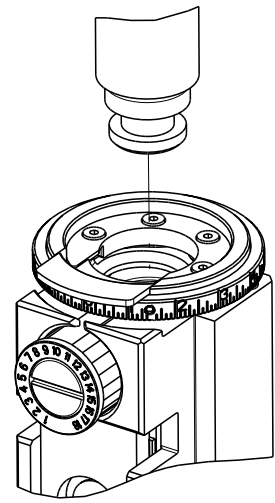
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION. CHANGES SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN K. HUANG 30APR2015	CHK L. ZHANG 30APR2015	APVD J. GUO 30APR2015	NAME Ocean Side Feed Applicator	SIZE A1	CAGE CODE 00779	DRAWING NO. C=2266772	RESTRICTED TO -
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		WEIGHT	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±	
ANGLES		FINISH		MATERIAL		SCALE		SHEET	
-		-		-		1:2		2 of 4	
Customer Accessible Production Drawing		REV		D					

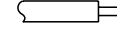
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2266772-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2266772-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2266772-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.95 mm [.037]	F
INSUL	1.10 mm [.043]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: ZE CONNETOR			
WIRE STRIP LENGTH 2.10-2.10 mm [.083-.083 IN]			INSULATION DIAMETER RANGE Ø0.80-1.20 mm [.031-.047 IN]
TERMINAL APPLICATION SPECIFICATION		SIZE-002T-P0.3 Rev 4/23/2015	
		-	-
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2113702-1	SZE-002T-P0.3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.65+/-0.05 [.026+/-0.002]	5.7
26 AWG	0.60+/-0.05 [.024+/-0.002]	6.2
28 AWG	0.53+/-0.05 [.021+/-0.002]	7.1



- 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 LUBRICANT IS RECOMMENDED.

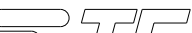
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***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)

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

-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
5	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	SPACER, CRIMPER	82
-	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	1338685-1	PAWL, FEED	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	811242-5	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	2-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	2119791-5	DEPRESSOR, WIRE	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	2119533-4	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	1803095-3	FLOATING SHEAR, FRONT -	9
1	1	1	8-1803054-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-2	DEPRESSOR, SHEAR	5
-	1	1	3-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	8-1633962-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	6-1633713-2	CRIMPER, WIRE PREMIUM	1

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO THE EXTENT OF THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG 30APR2015		 TE Connectivity Harrisburg, PA 17105-3608	
				CHK L. ZHANG 30APR2015			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD U. GUO 30APR2015		NAME	
		0 PLC ±		PRODUCT SPEC		Ocean Side Feed Applicator -	
		1 PLC ±		-			
		2 PLC ±		APPLICATION SPEC			
3 PLC ±		4 PLC ±		-		SIZE	
4 PLC ±		ANGLES		-		CAGE CODE	
FINISH		-		WEIGHT		DRAWING NO	
-		-		-		A1 00779 C=2266772	
-		-		-		RESTRICTED TO	
-		-		-		-	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 3 of 4	
				REV D			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

