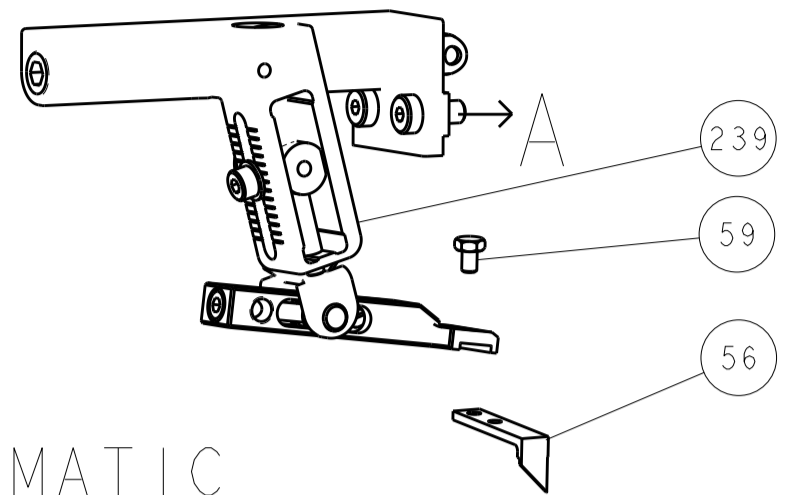
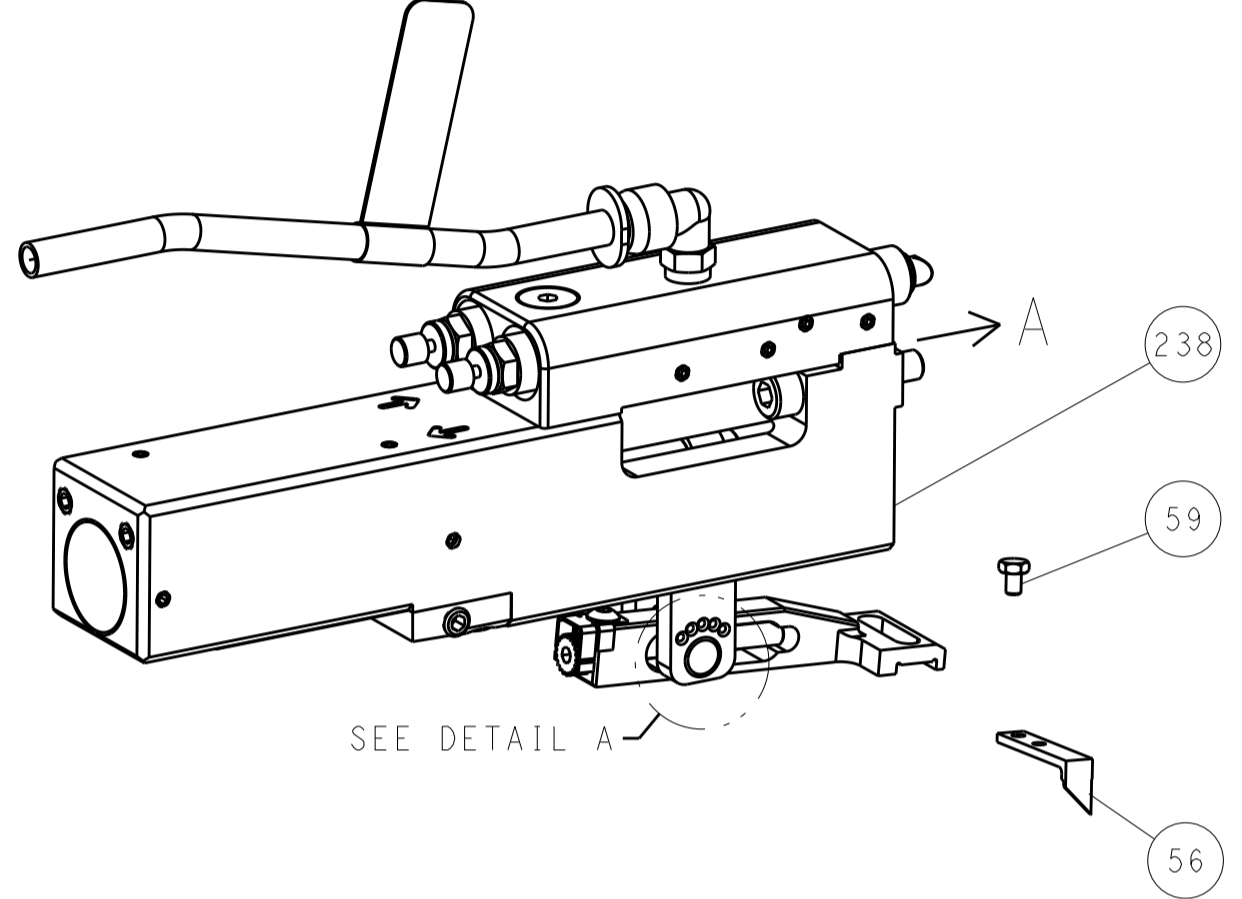


| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| | | P | LTN | DESCRIPTION | DATE | DMN | APVD |
| A | 66 | - | - | SEE SHEET 1 | - | - | - |

FEED TYPE MECHANICAL



PNEUMATIC

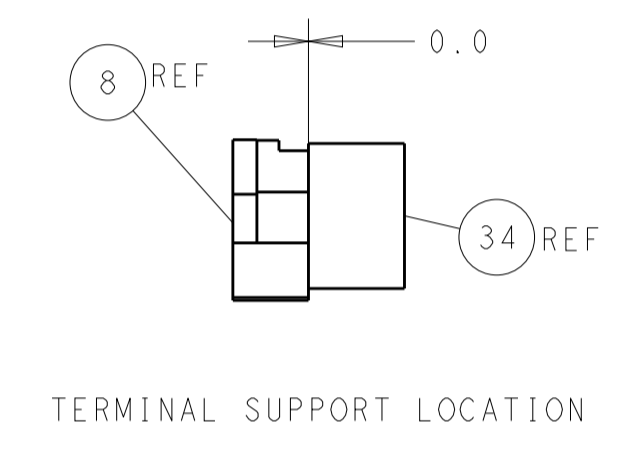
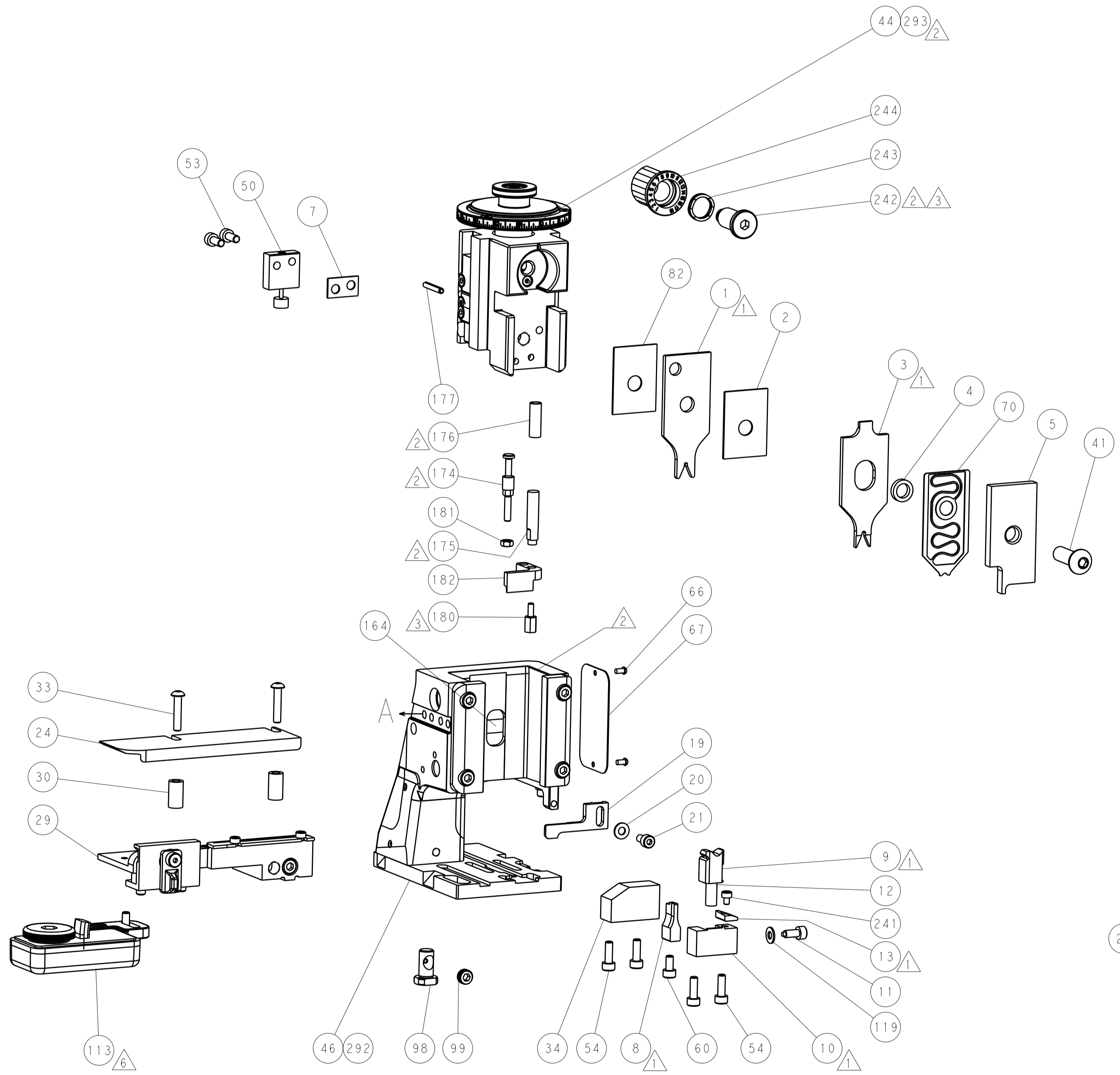


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

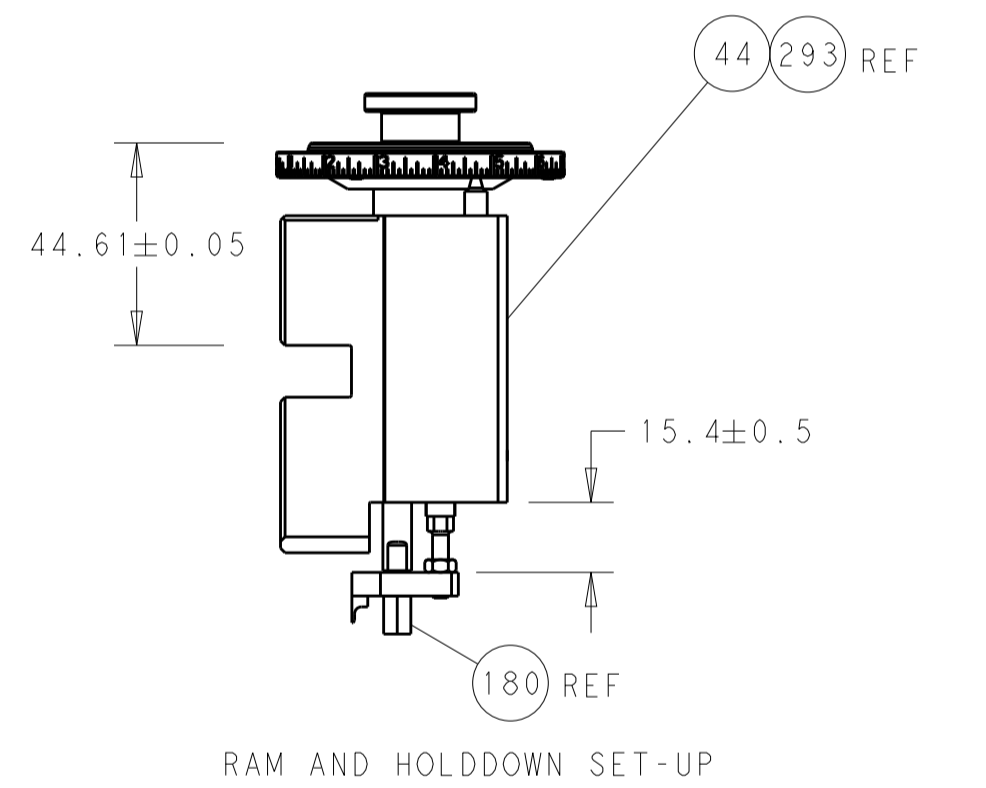


DETAIL A

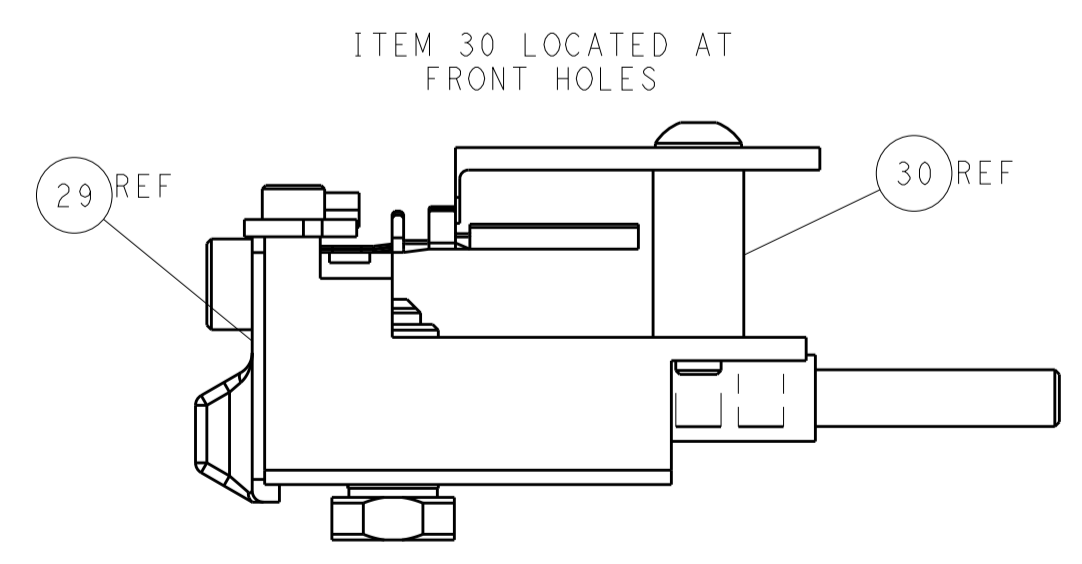
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

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 OTHERWISE SPECIFIED: | | DWN: R. KNEPPER 16-Oct-13 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | FINISH: | WEIGHT: | | NAME: Ocean Side Feed Applicator | | RESTRICTED TO: | |
| CUSTOMER DRAWING | | SCALE: 1:2 | | SHEET 2 OF 4 | | REV G | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------|------------|
| 2-2266117-1 | F | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2266117-2 | F | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266117-7 | C | CRIMP TOOLING KIT | - |
| 7-2266117-8 | C | APPLICATOR CONVERSION KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.75 mm [.069] | F |
| INSUL | 2.29 mm [.090] | O |

APPLICATOR INSTRUCTIONS
408-35042

| APPLICATOR CONVERSION KITS | |
|----------------------------|---------------------------|
| PART NUMBER | INSULATION DIAMETER RANGE |
| 7-2266116-8 | Ø2.74-3.18mm [.109-.125] |
| 7-2266117-8 | Ø2.31-2.72mm [.091-.107] |
| 7-2266118-8 | Ø1.91-2.29mm [.075-.090] |
| 7-2266119-8 | Ø1.60-2.16mm [.063-.085] |
| 7-2266120-8 | Ø1.27-1.57mm [.050-.062] |

| TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION | | | |
|--|------------------------------|-------------|------------------|
| TERMINAL NAME: STAMPED CONTACT CONTACT PIN SIZE 20 | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 3.81-5.08 mm [1.50-.200 IN] | Ø2.31-2.72 mm [.091-.107 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | 114-151003 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | DEUTSCH TERMINAL | TE TERMINAL | DEUTSCH TERMINAL |
| 1572032-1 | 1060-20-0122 | 1572032-2 | 1060-20-0144 |
| 1572032-7 | 1060-20-0177 | | |

| TERMINAL DATA: DEUTSCH TERMINAL TE CRIMP SPECIFICATION | | | |
|--|------------------------------|-------------|------------------|
| TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20 | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 3.81-5.08 mm [1.50-.200 IN] | Ø2.31-2.72 mm [.091-.107 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | 114-151003 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | DEUTSCH TERMINAL | TE TERMINAL | DEUTSCH TERMINAL |
| 286680-1 | 1062-20-0122 | 286680-2 | 1062-20-0144 |
| 286680-9 | 1062-20-0177 | 286680-5 | 1062-20-0322 |
| 286680-6 | 1062-20-0344 | 1-286680-0 | 1062-20-0377 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|------------------------------------|--------------------------------|
| 1.50mm2 | 1.47+0.03/-0.05 [.058+.001/-0.002] | 3.4 |
| 16 AWG | 1.27+0.03/-0.05 [.050+.001/-0.002] | 5.4 |
| 1.00mm2 | 1.27+0.03/-0.05 [.050+.001/-0.002] | 5.4 |
| 18 AWG | 1.24+0.03/-0.05 [.049+.001/-0.002] | 5.7 |
| 0.75mm2 | 1.22+0.03/-0.05 [.048+.001/-0.002] | 5.9 |
| 0.60mm2 | 1.07+0.03/-0.05 [.042+.001/-0.002] | 7.4 |
| 20 AWG | 0.99+0.03/-0.05 [.039+.001/-0.002] | 8.2 |
| 0.50mm2 | 0.97+0.03/-0.05 [.038+.001/-0.002] | 8.4 |
| 22 AWG | 0.94+0.03/-0.05 [.037+.001/-0.002] | 8.7 |
| 0.35mm2 | 0.94+0.03/-0.05 [.037+.001/-0.002] | 8.7 |

- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.
 - SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.
 - TERMINAL LUBRICANT IS RECOMMENDED.
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)

| LOC | DIST | REV | DATE | BY | APPD |
|-----|------|-----|------|----|------|
| A | 66 | - | - | - | - |

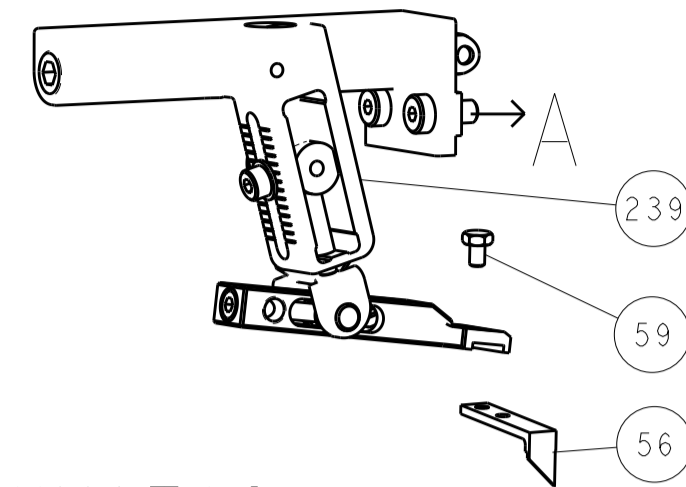
| REV | DATE | BY | APPD | DESCRIPTION | ITEM NO | |
|-----|------|-----|------|-------------|-------------------------------------|-----|
| - | - | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | - | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | - | 1 | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | - | 1 | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | 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 | 455888-7 | SPACER, CRIMPER | 82 |
| 1 | - | - | - | 2266117 | PRINT, APPLICATOR LOG SHEET | 72 |
| - | - | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | - | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | - | 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 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 53 |
| - | - | 1 | 1 | 1803382-6 | HOLD DOWN, SPRING LOADED | 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 | 2-1752356-0 | 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 | 1320928-2 | STRIP GUIDE | 24 |
| - | - | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | - | 1 | 1 | 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 | 1803095-1 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1 | 1-1803293-3 | ANVIL, COMBINATION DEUTSCH STYLE | 8 |
| - | - | 1 | 1 | 2-240641-8 | SPACER | 7 |
| - | - | - | - | - | - | 6 |
| - | - | 1 | 1 | 2119757-3 | DEPRESSOR, SHEAR | 5 |
| - | - | 1 | 1 | 238011-9 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1803019-5 | CRIMPER, INSULATION O | 3 |
| - | - | 1 | 1 | 455888-8 | SPACER, CRIMPER | 2 |
| - | - | 1 | 1 | 1803364-2 | CRIMPER, WIRE PREMIUM | 1 |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | |
|-------------|---------|--|---------|-----------|---------|------------------|--------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH |
| MATERIAL | | FINISH | | WEIGHT | | CUSTOMER DRAWING | |

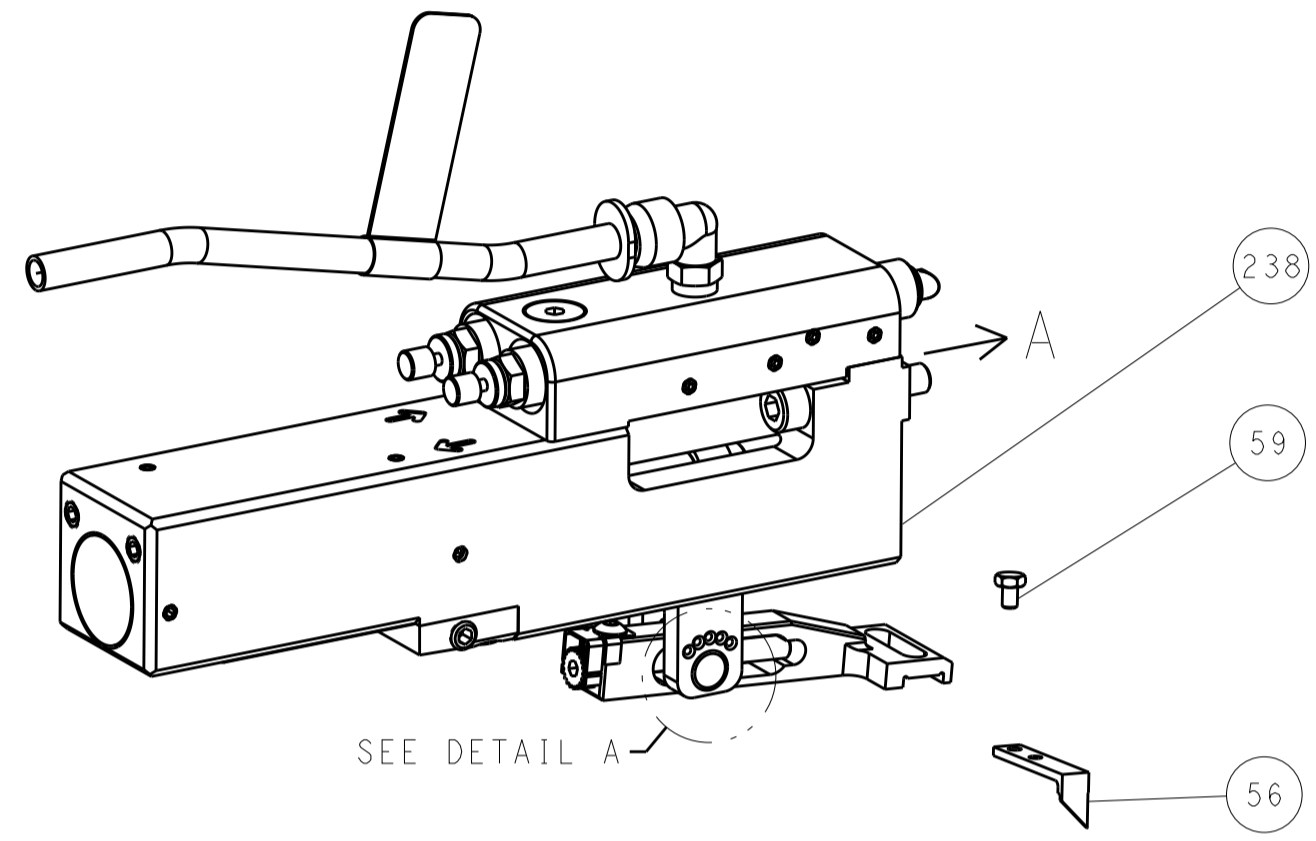
| | | |
|-------|----------------------------|------------|
| OWN | R. KNEPPER | 16-Oct-13 |
| CHK | G. BAILEY | 16-Oct-13 |
| APPD | M. CLIFFORD | 16-Oct-13 |
| NAME | Ocean Side Feed Applicator | |
| SIZE | CAGE CODE | DRAWING NO |
| A1 | 00779 | 2266117 |
| SCALE | SHEET | REV |
| 1:2 | 3 OF 4 | G |

| LOC | | DIST | | REVISONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | - | - | - |

FEED TYPE MECHANICAL



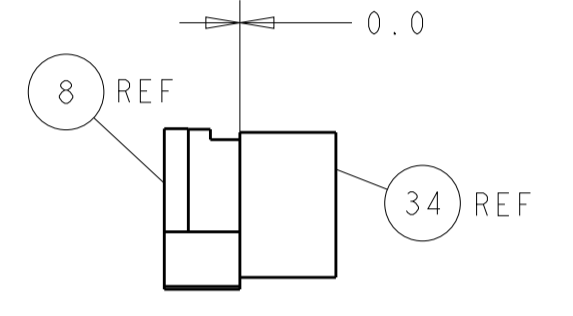
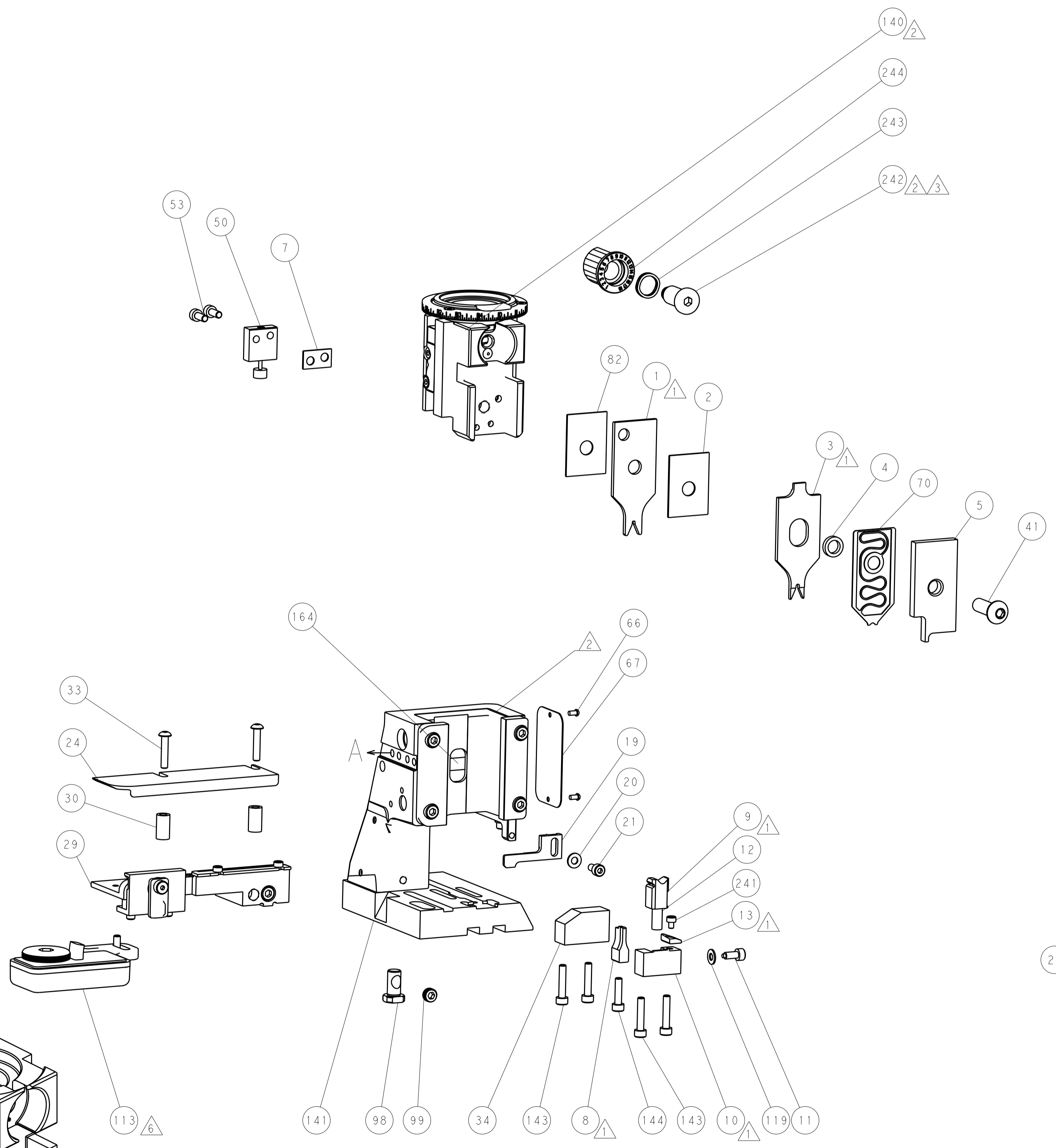
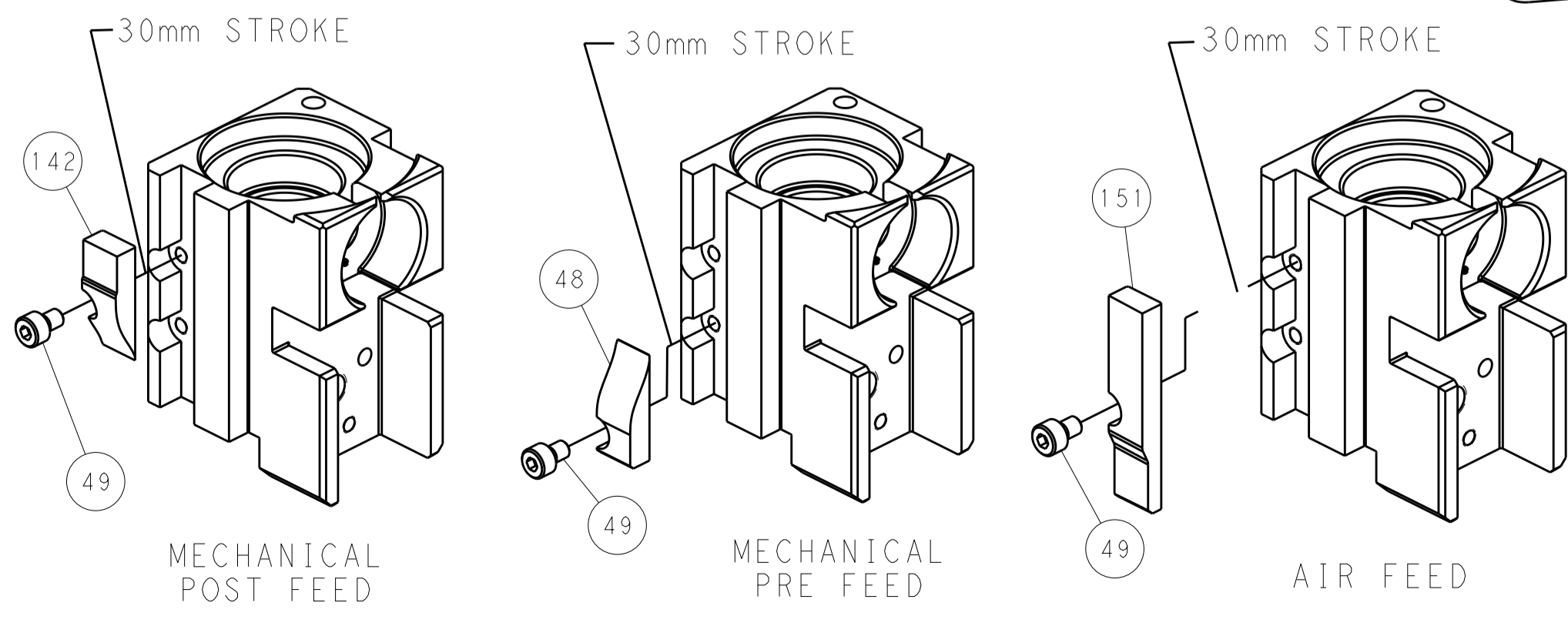
PNEUMATIC



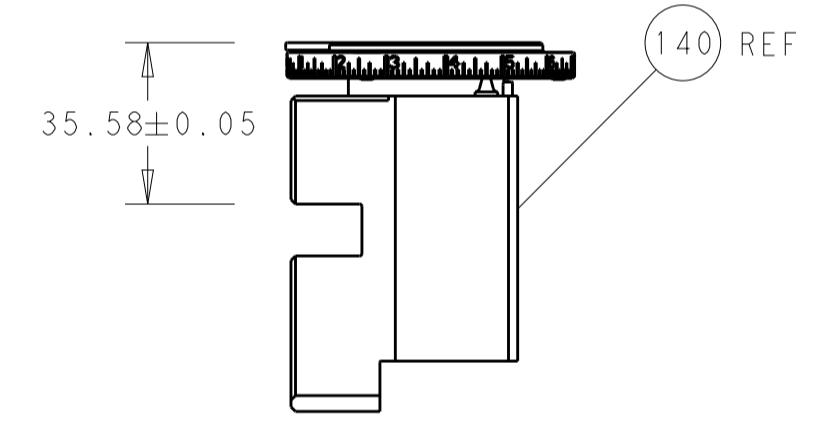
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



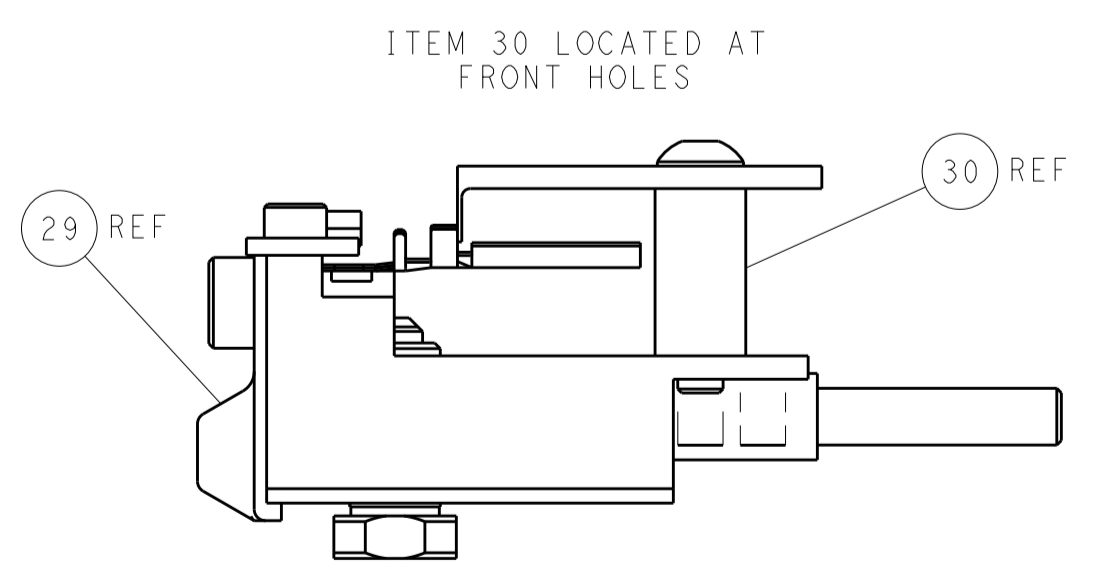
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

| | | | | | | | | | |
|-----------------------|--|---|--|---|--|---|--|---------------|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | | DWN R. KNEPPER 16-Oct-13 CHK G. BAILEY 16-Oct-13 APVD M. CLIFFORD 16-Oct-13 PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER DRAWING | | NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2266117 SCALE 1:2 SHEET 4 OF 4 REV G | | RESTRICTED TO | |
|-----------------------|--|---|--|---|--|---|--|---------------|--|

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[2266117-2](#)