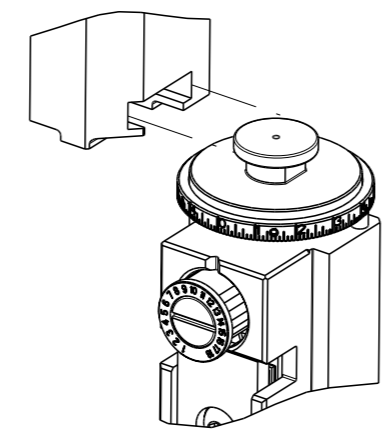


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266419-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266419-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266419-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266419-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266419-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.67 mm [.066]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION			
TERMINAL NAME: KOSTAL MLK 1.2m RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
2.60-3.60 mm [.102-.142 IN]	Ø1.20-1.40 mm [.047-.055 IN]		
TERMINAL APPLICATION SPECIFICATION	DOC00061540 ATTACHMENT 3 PG. 50 OF 57		
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE TERMINAL	KOSTAL TERMINAL
1949957-1	3 21 24 73401 0/3	1949957-2	3 21 25 73401 0/3
1949957-3	3 21 40 73401 0/3	1572680-1	3 21 40 65176 0/3
1572680-2	3 21 24 65176 0/3	1572680-3	3 21 25 65176 0/3
1949380-1	3 21 24 73406 0/3	1949380-2	3 21 25 73406 0/3
1949380-3	3 21 40 73406 0/3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.76+/-0.03 [.030+/-0.001]	6.9

- 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.

***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)

LOC		DIST		REVISIONS			
A		66		REV	DATE	BY	CHK
B		ECR-17-017161		21NOV2017	JAH	TE	
B1		ECR-18-014882		19SEP2018	KH	CT	
C		ECR-19-014046		09SEP2019	FZ	TE	
D		ECR-20-015755		04NOV2020	JWC	GB	

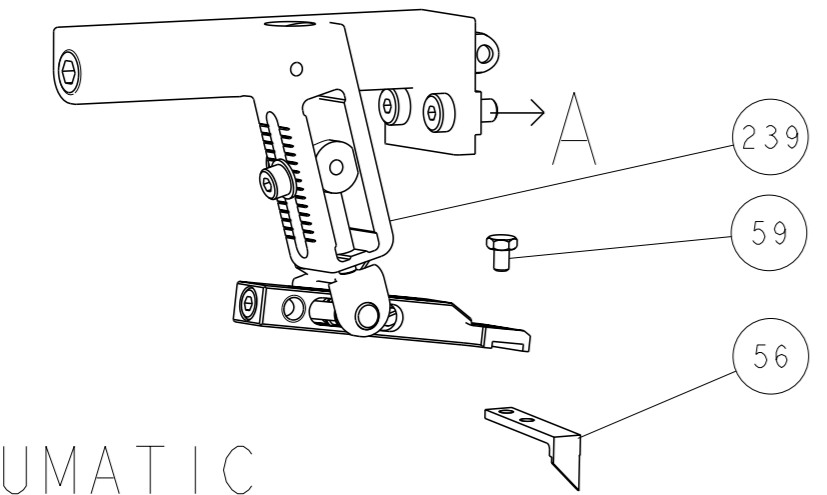
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	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	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-6	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	2119533-1	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1-1803554-5	ANVIL, COMBINATION	8
-	1	1	1	1	240641-1	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	7-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	2	1	2-1633664-7	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	23JULY2014	J. HOU	23JULY2014	Y. YIN	23JULY2014	U. GUO
	ANGLES FINISH										
MATERIAL											

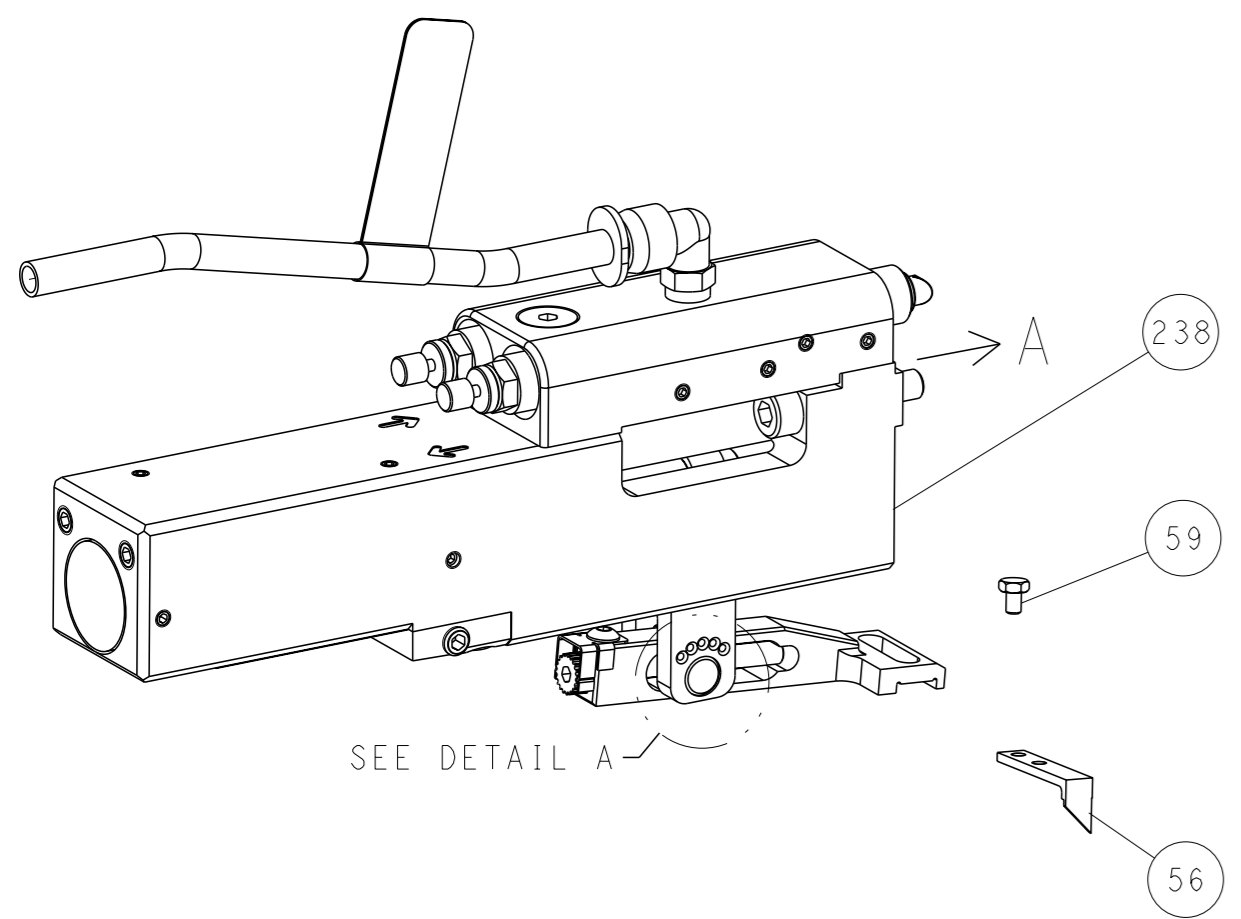
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV D

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-

FEED TYPE MECHANICAL



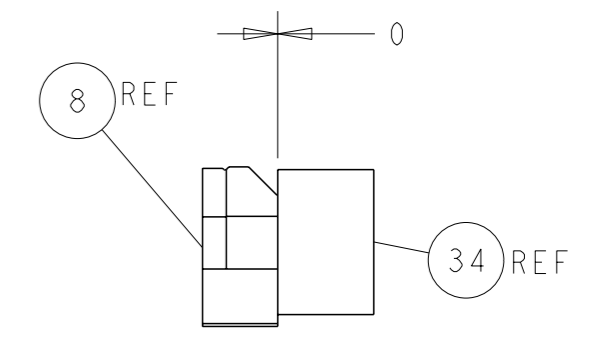
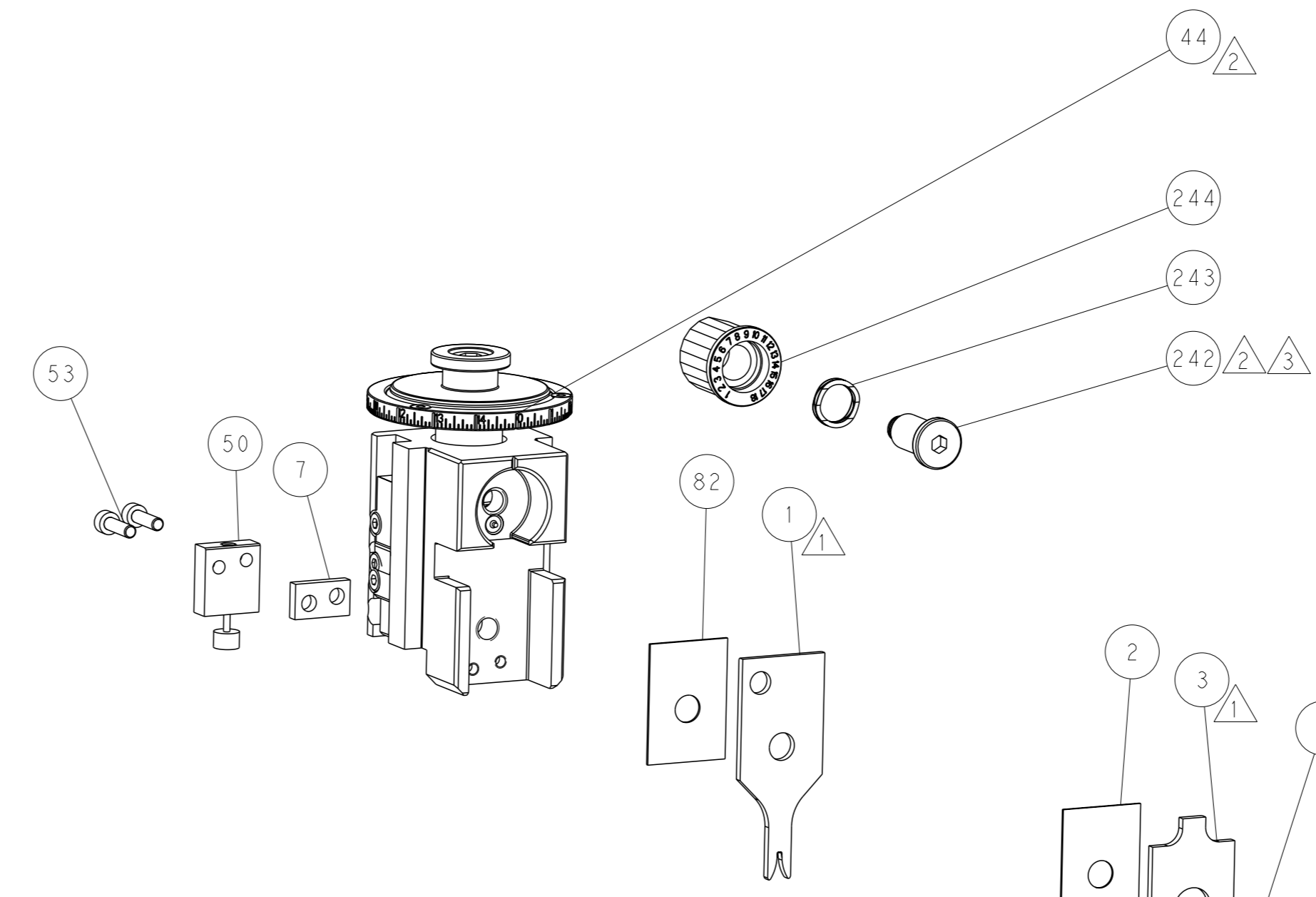
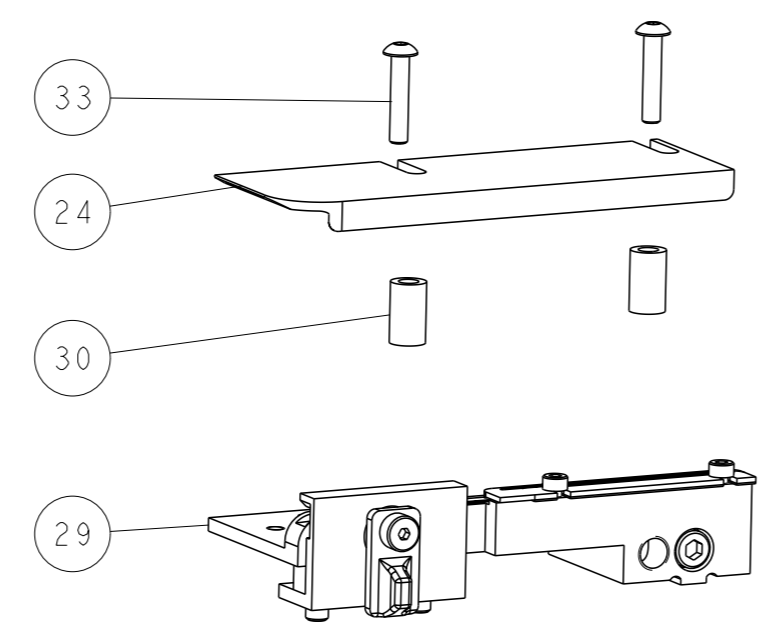
PNEUMATIC



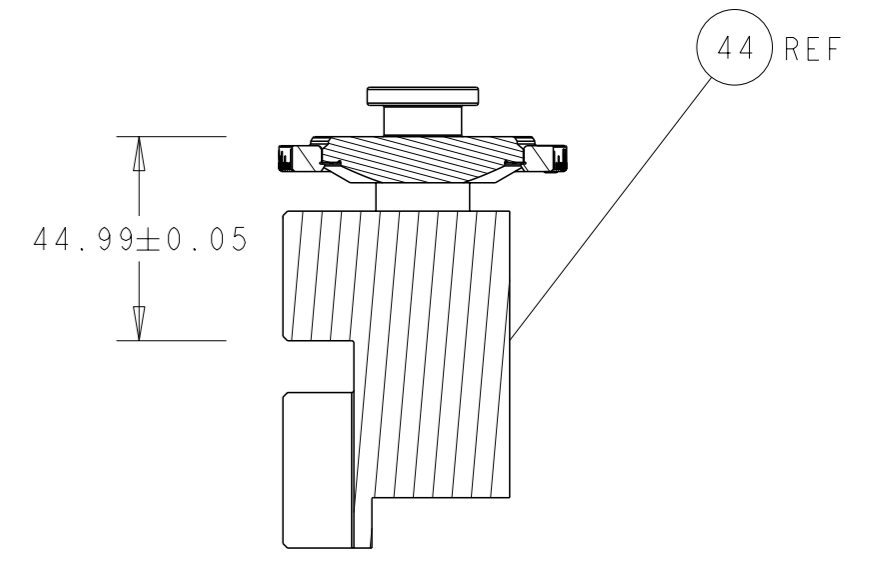
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



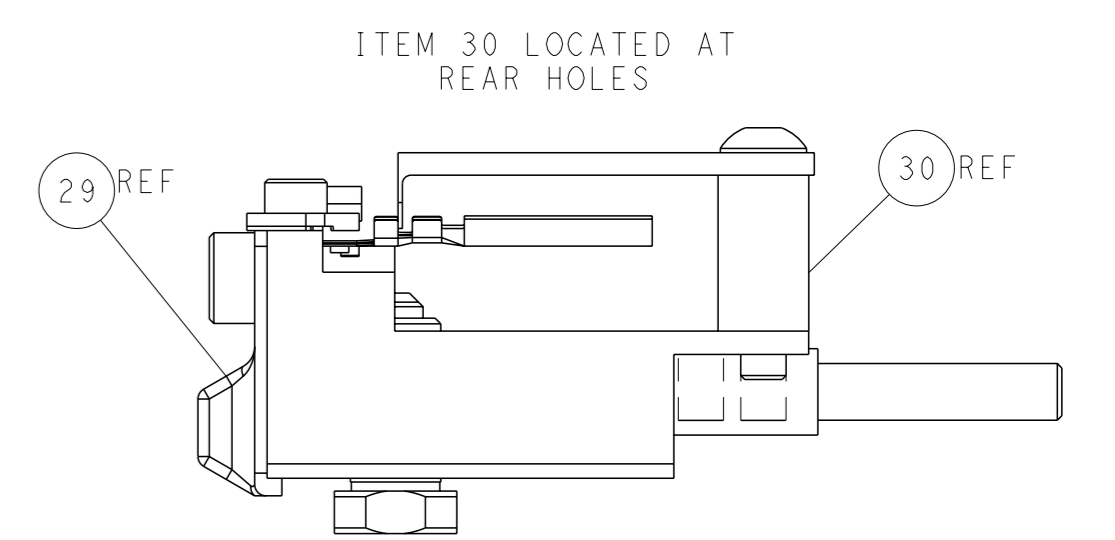
DETAIL A



TERMINAL SUPPORT LOCATION

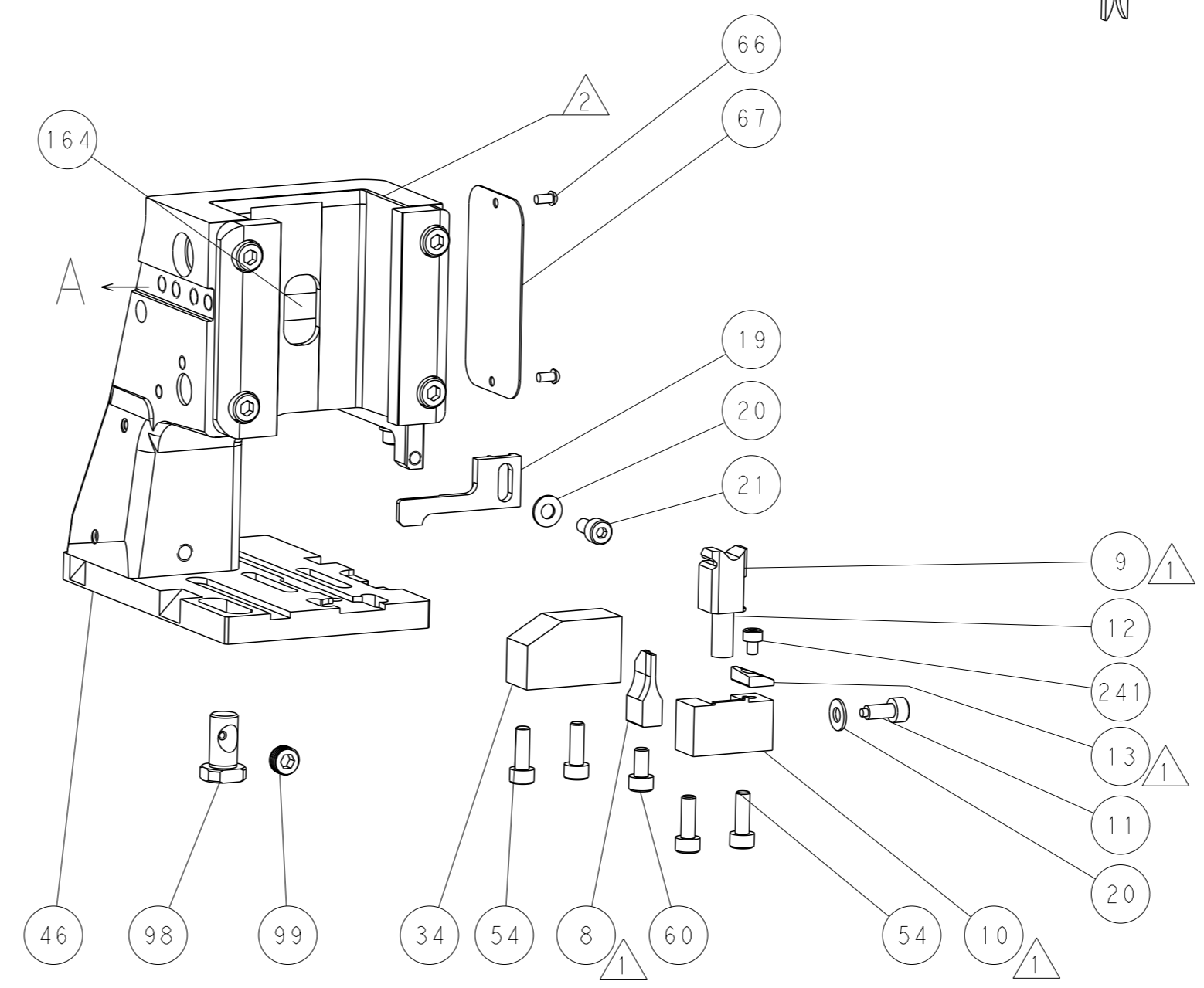
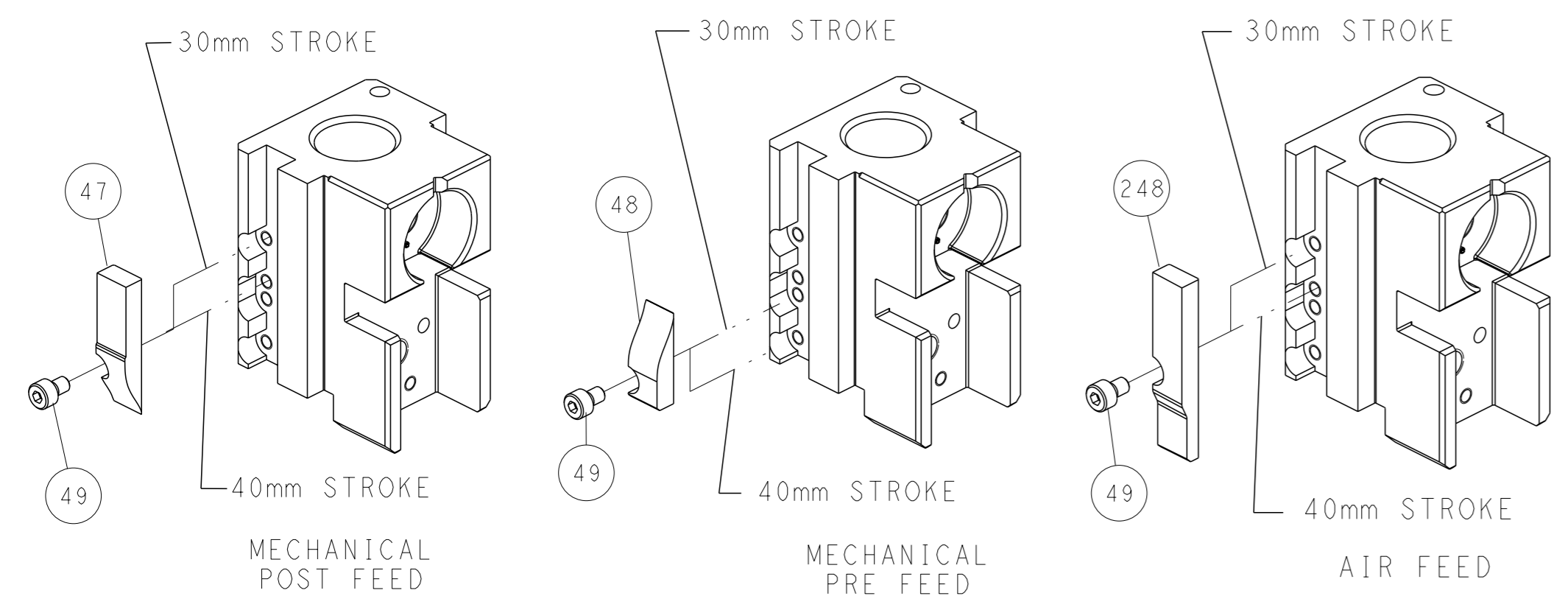


RAM SET-UP



ITEM 30 LOCATED AT REAR HOLES

CAM POSITIONS

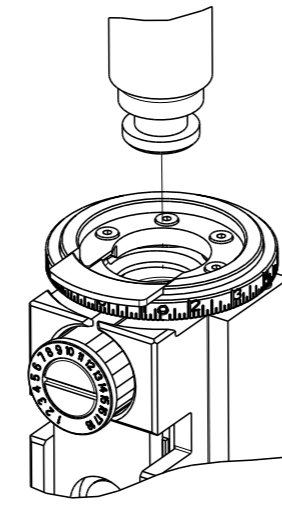


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOW CHK: Y. YIN APVD: H. GUO DATE: 23JULY2014 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	23JULY2014 23JULY2014 23JULY2014 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266419 SCALE: 1:2 SHEET: 2 of 4 REV: D	TE Connectivity Harrisburg, PA 17105-3608
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THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266419-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266419-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266419-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.67 mm [.066]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL	KOSTAL CRIMP SPECIFICATION		
TERMINAL NAME: KOSTAL MLK 1.2m RECEPTACLE			
WIRE STRIP LENGTH 2.60-3.60 mm [.102-.142 IN]	INSULATION DIAMETER RANGE Ø1.20-1.40 mm [.047-.055 IN]		
TERMINAL APPLICATION SPECIFICATION DOC00061540 ATTACHMENT 3 PG. 50 OF 57			
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE TERMINAL	KOSTAL TERMINAL
1949957-1	3 21 24 73401 0/3	1949957-2	3 21 25 73401 0/3
1949957-3	3 21 40 73401 0/3	1572680-1	3 21 40 65176 0/3
1572680-2	3 21 24 65176 0/3	1572680-3	3 21 25 65176 0/3
1949380-1	3 21 24 73406 0/3	1949380-2	3 21 25 73406 0/3
1949380-3	3 21 40 73406 0/3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.76+/-0.03 [.030+/-0.011]	6.9

- 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.

***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)

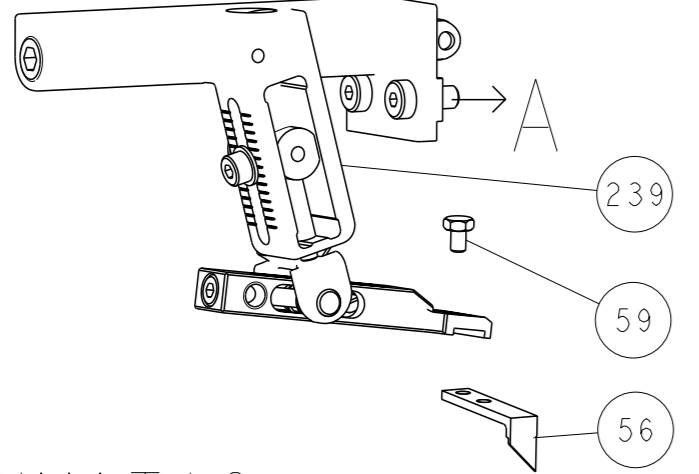
LOC	DIST	REV	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	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
-	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	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-1	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	2-2844962-4	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	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	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	1-1803554-5	ANVIL, COMBINATION	8
-	1	1	240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
1	1	1	7-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	2-1633664-7	CRIMPER, WIRE	1

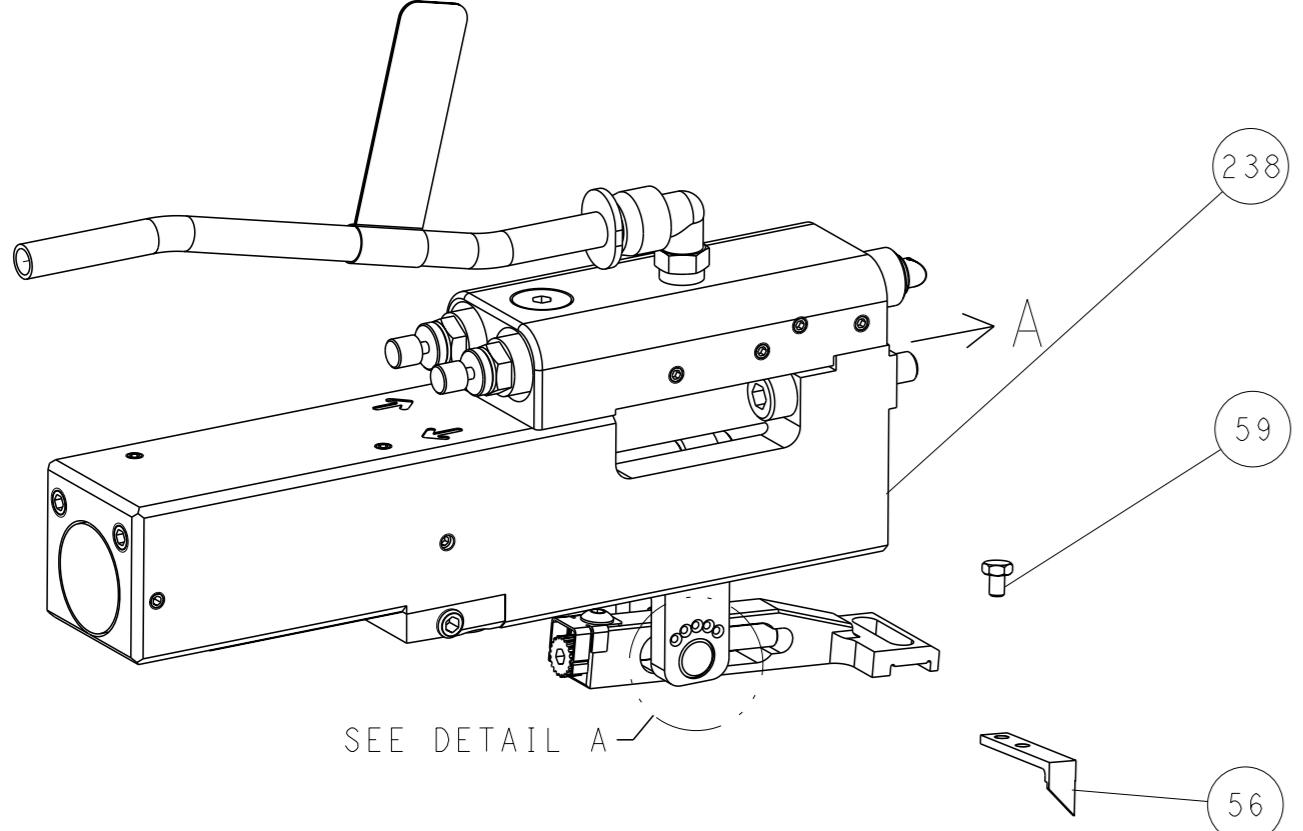
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN J. HOU 23JULY2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD U. GUO 23JULY2014		NAME	
				PRODUCT SPEC		Ocean Side Feed Applicator	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A1 00779 C=2266419	
				RESTRICTED TO		Customer Accessible Production Drawing	
				SCALE		1:2 SHEET 3 OF 4 REV D	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-

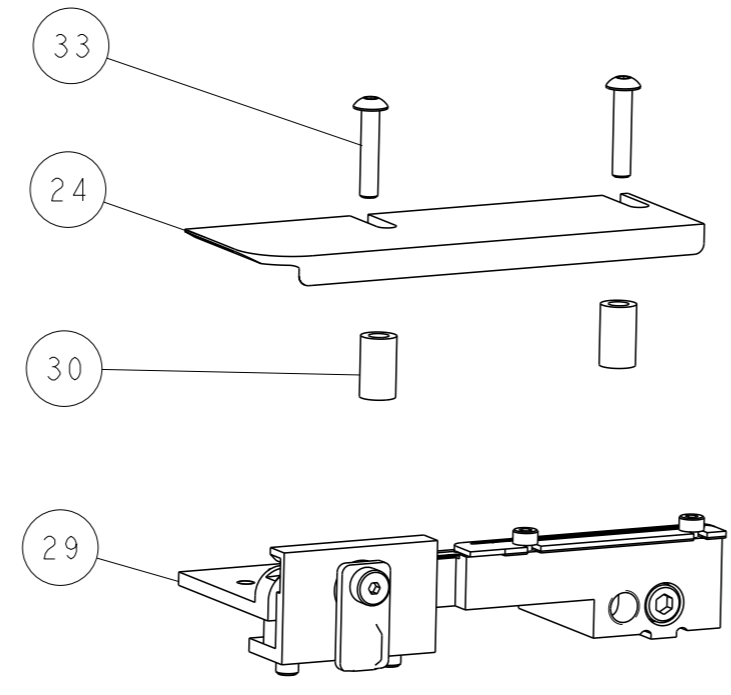
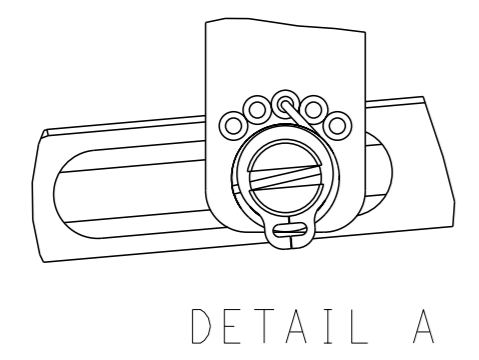
FEED TYPE MECHANICAL



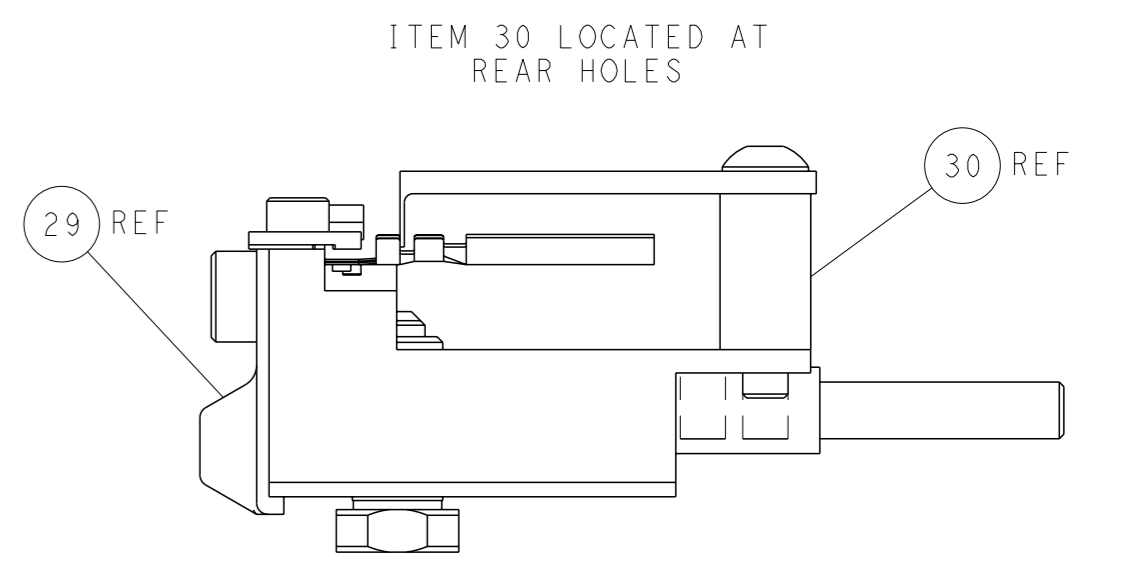
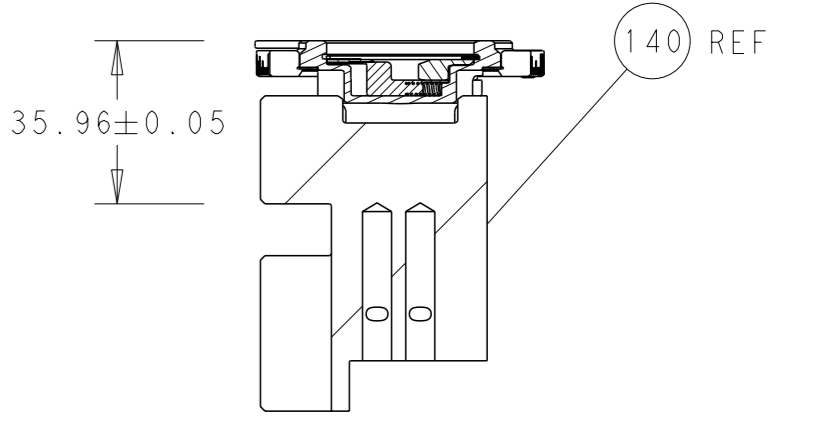
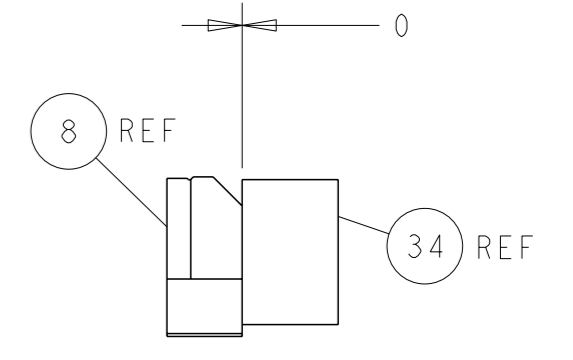
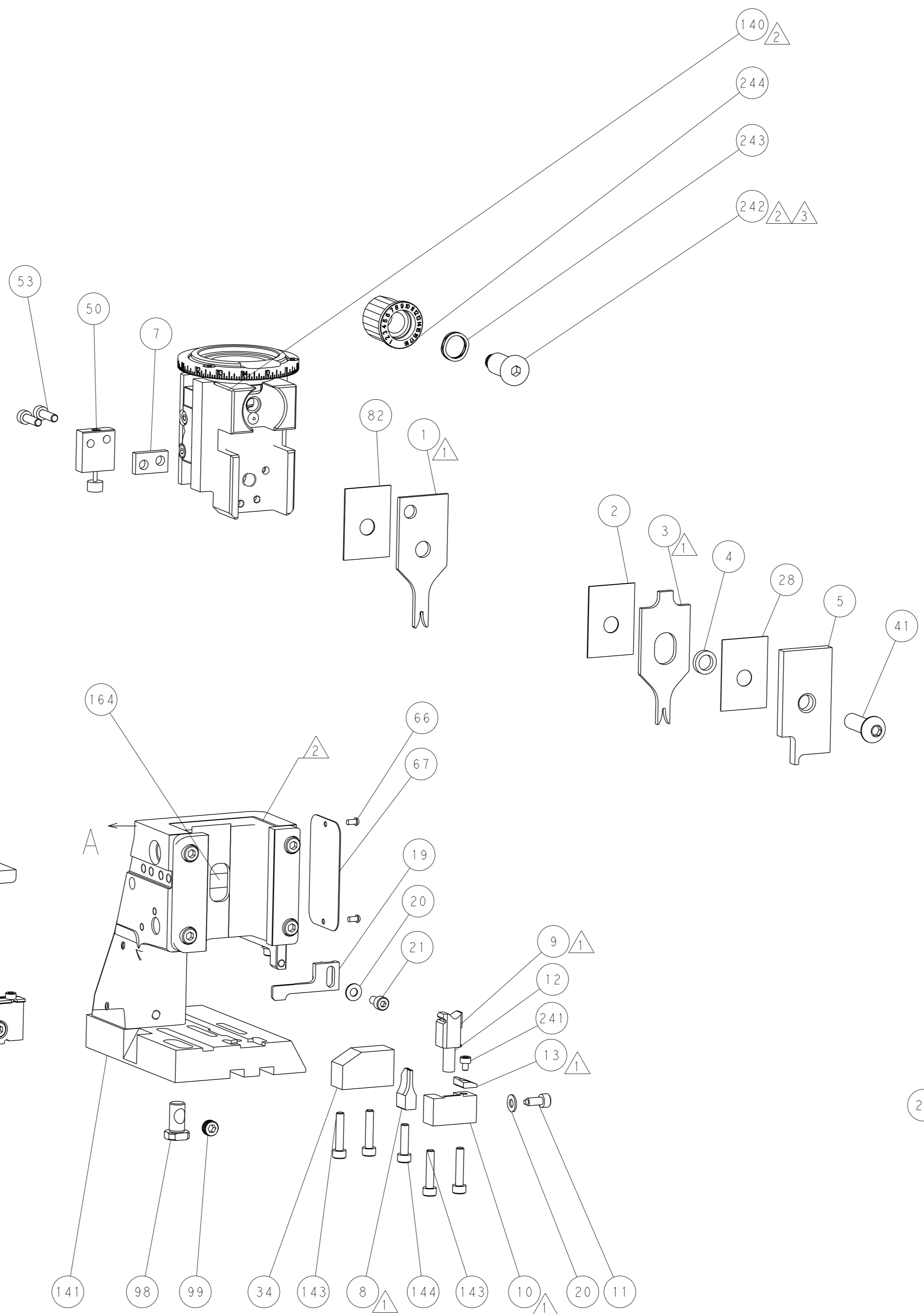
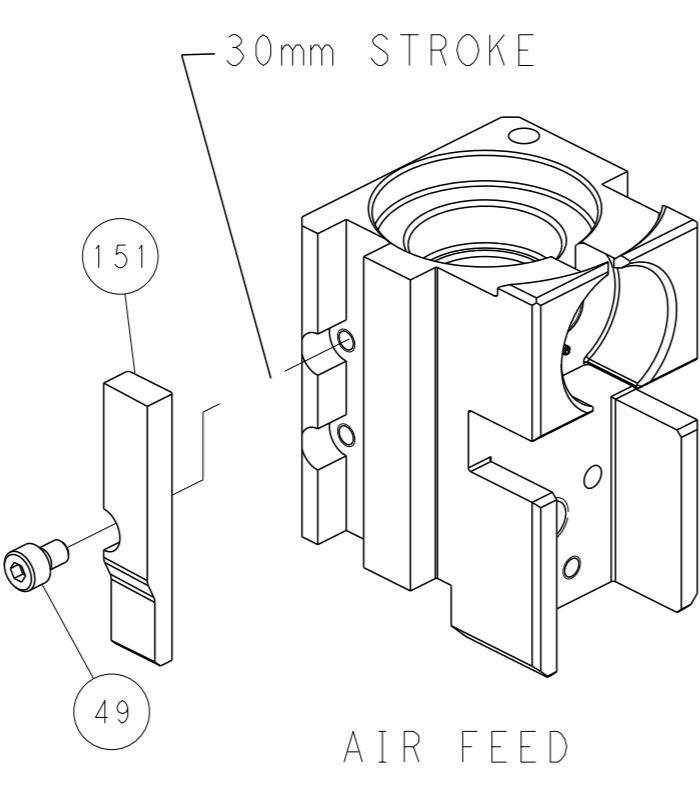
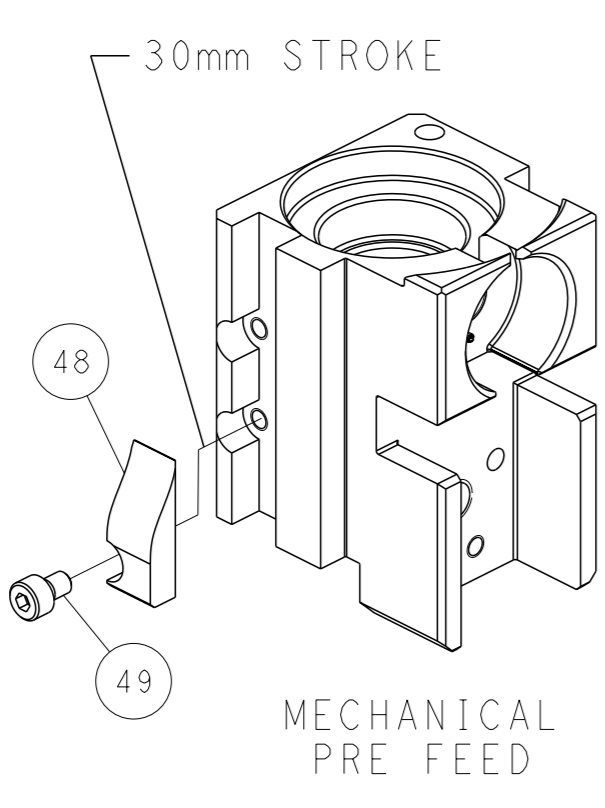
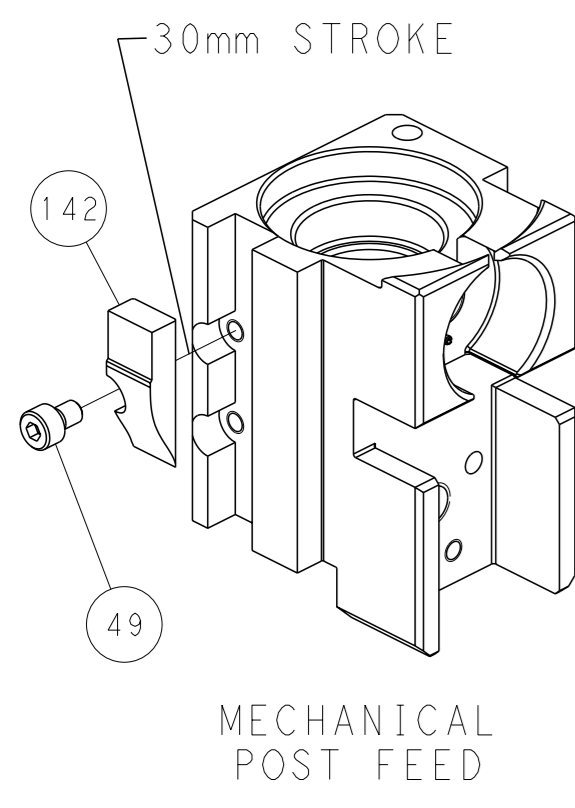
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOW CHK: Y. YIN APVD: H. GUO DATE: 23JULY2014 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266419 SCALE: 1:2 SHEET: 4 of 4 REV: D	TE Connectivity Harrisburg, PA 17105-3608
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[TE Connectivity:](#)

[2266419-2](#)