

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266420-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266420-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266420-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266420-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266420-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.81 mm [.150]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: FCI TERMINAL		VW CRIMP SPECIFICATION		
TERMINAL NAME: 2.8mm FEMALE TERMINAL				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE			
3.90-4.70 mm [.154-.185 IN]	∅ 1.2-2.0mm			
TERMINAL APPLICATION SPECIFICATION	N104427			
TERMINALS APPLIED				
TE TERMINAL	FCI TERMINAL	TE SEAL	FCI SEAL	SEAL INSULATION DIAMETER RANGE
1572981-1	6 001 24 31	2113590-1	60994015	∅ 1.2-2.0mm
1572981-2	6 001 30 31	963294-1		∅ 1.2-2.1mm
1572981-3	6 001 32 32			
1572981-4	6 001 33 32			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30 +/- 0.04 [.051 +/- .002]	8.4
0.75mm2	1.25 +/- 0.04 [.049 +/- .002]	8.8
0.50mm2	1.20 +/- 0.04 [.047 +/- .002]	9.2

- 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 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
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		B		ECR-18-017907	14NOV2018	TB	CT

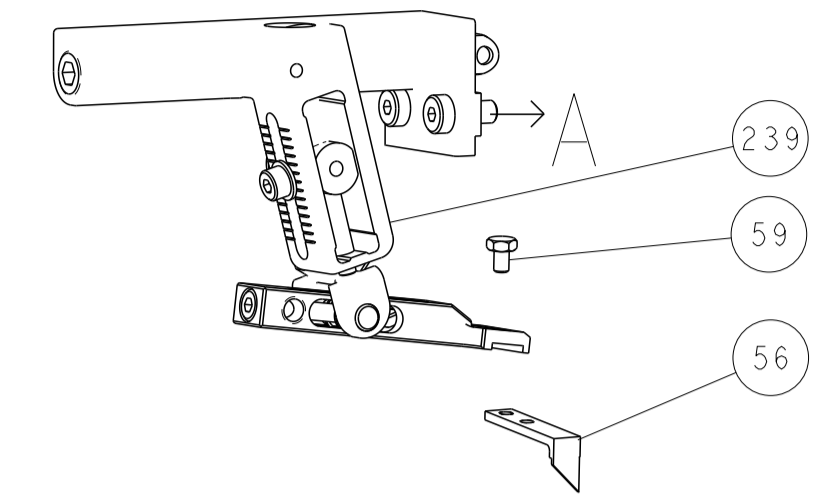
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	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	-	2063440-1	AIR FEED MODULE	238	
-	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	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-8	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	690753-2	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	1-1752356-7	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	240792-1	DRAG, TERMINAL	25	
-	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	2119533-1	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	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	9-1633927-7	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	4-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
-	1	2	2	1	1	7-1633738-3	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

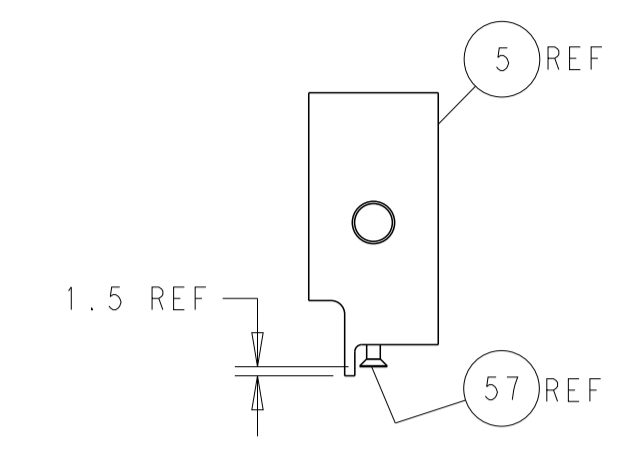
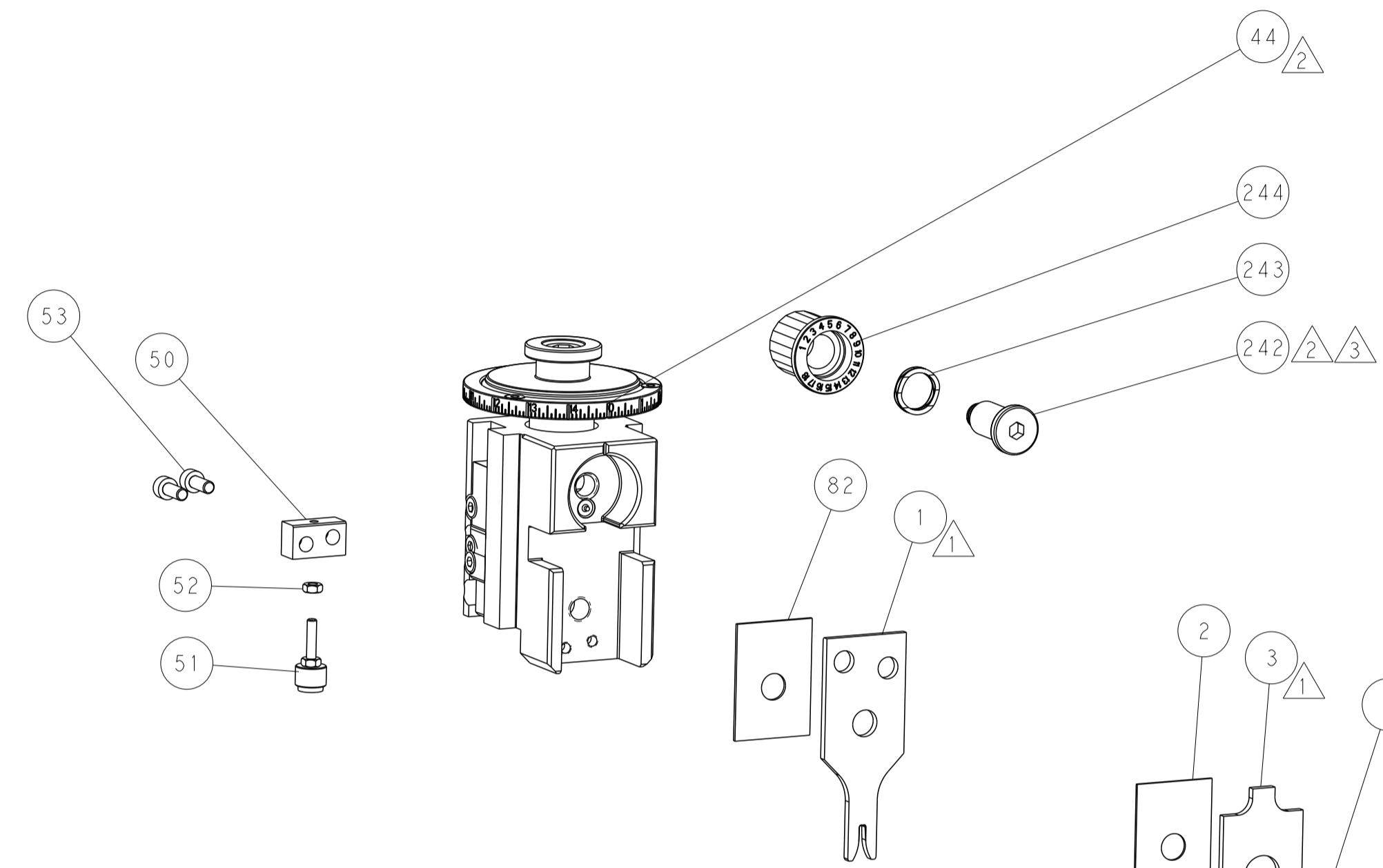
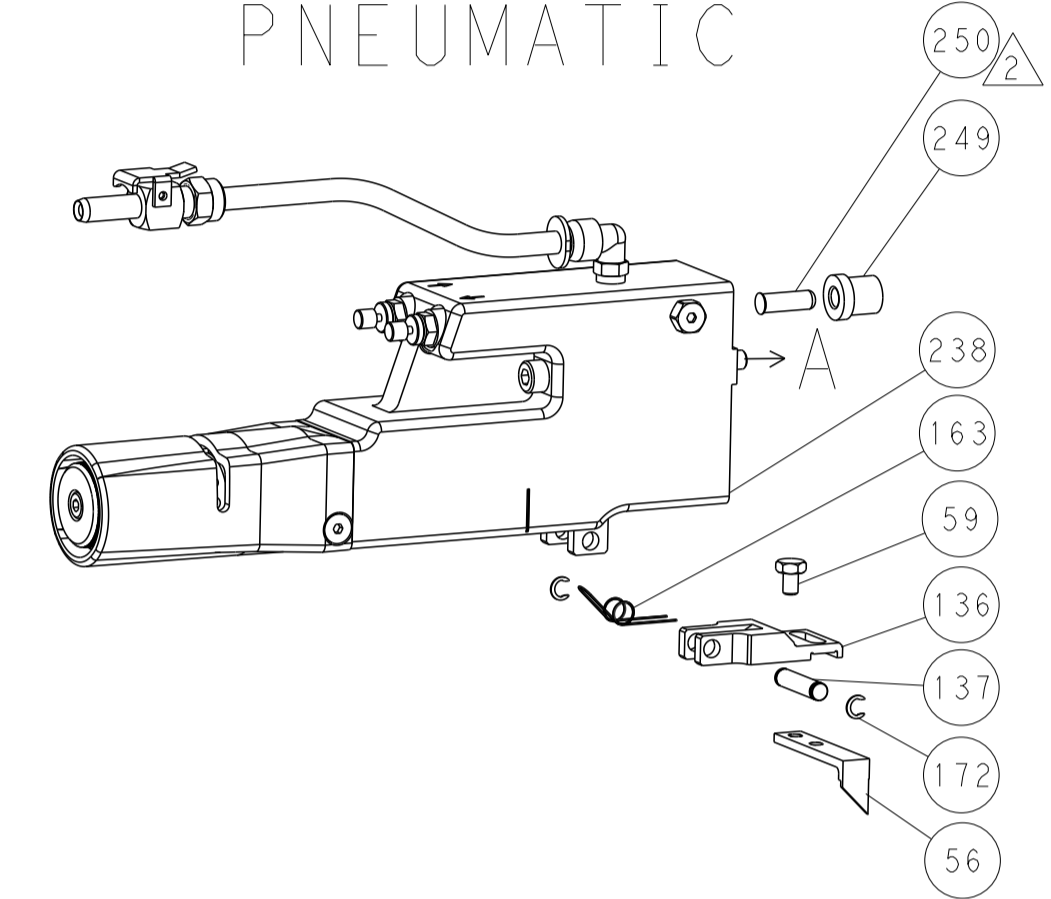
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mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	17JUL2014	
	3 PLC ±	4 PLC ±	ANGLES ±	FINISH		NAME
MATERIAL						Ocean Side Feed Applicator
				APVD	17JUL2014	SIZE
						CAGE CODE
						DRAWING NO
						RESTRICTED TO
						A1 00779 C=2266420
						Customer Accessible Production Drawing
						SCALE 1:2 SHEET 1 of 4 REV B

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

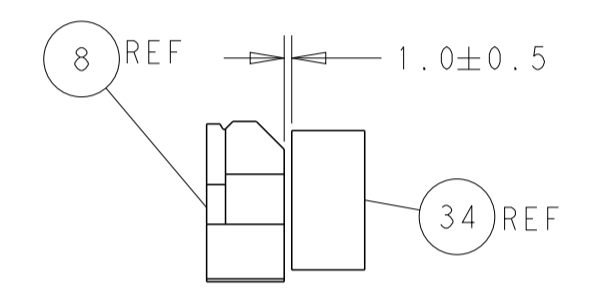
FEED TYPE MECHANICAL



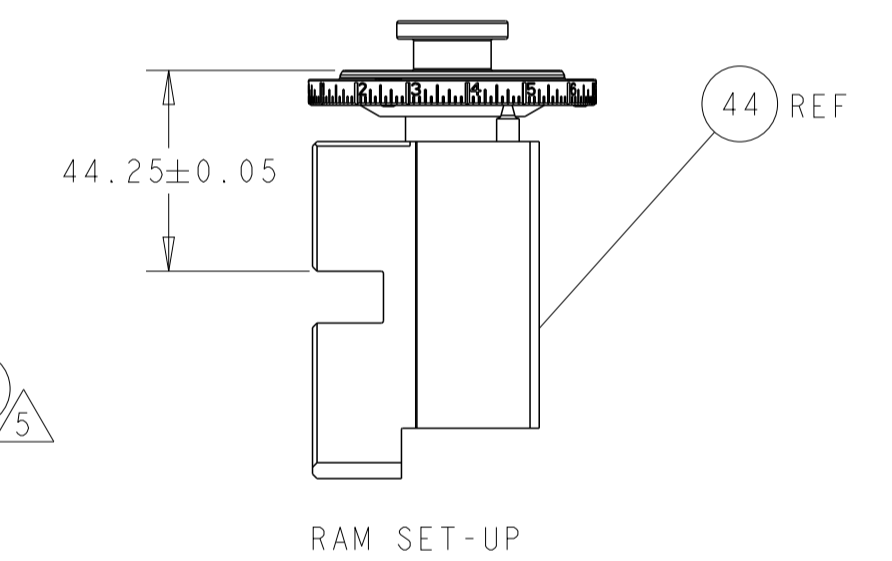
PNEUMATIC



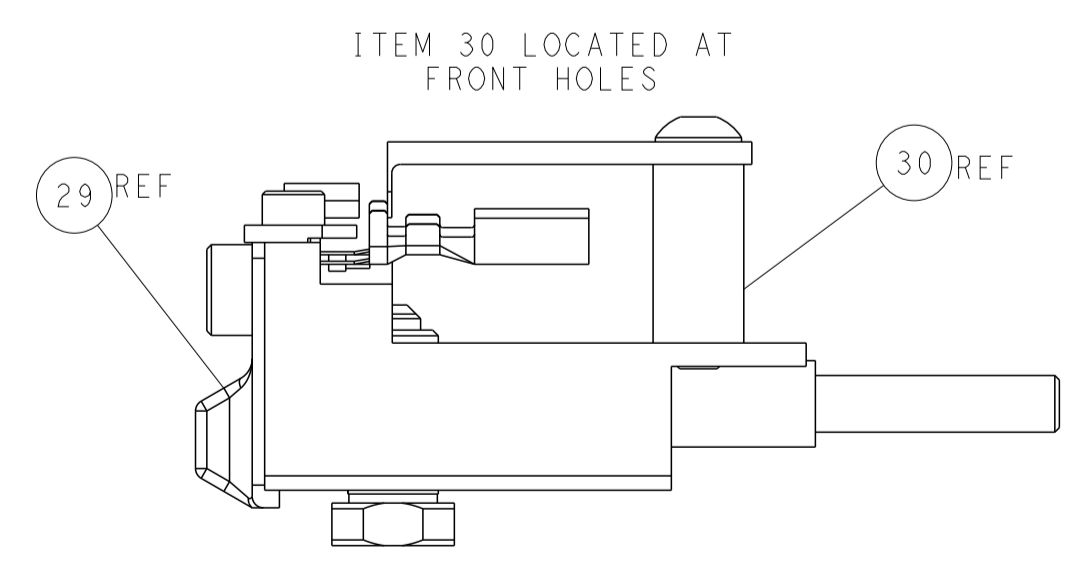
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

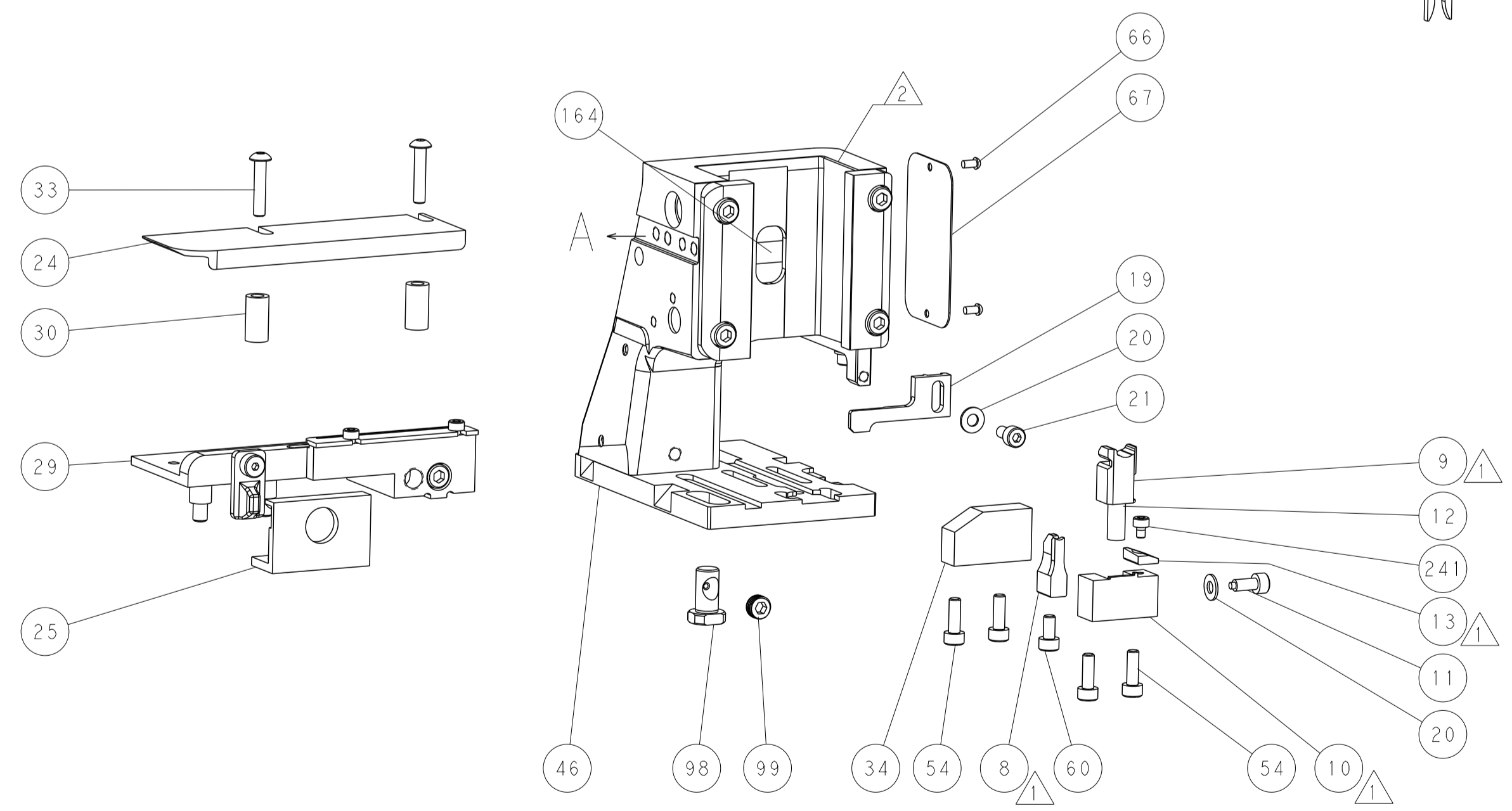
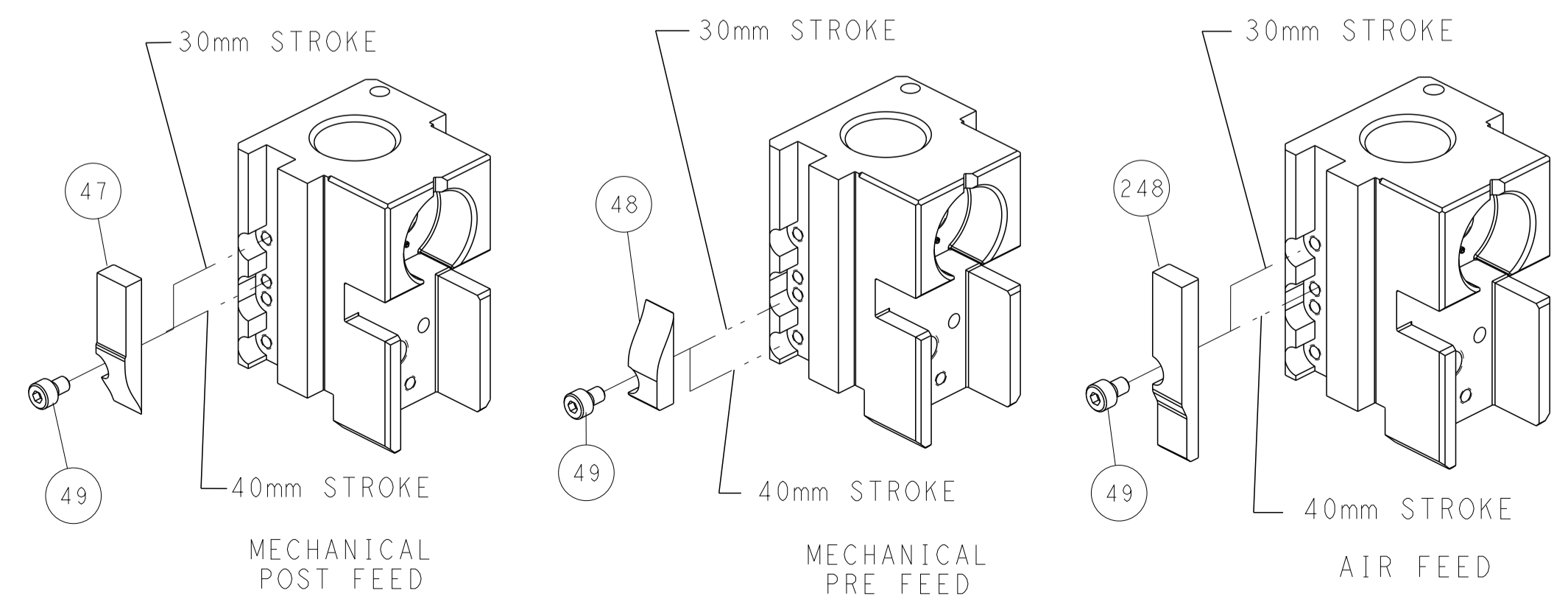


RAM SET-UP



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266420 SHEET 2 OF 4 REV B
MATERIAL: - FINISH: -		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266420-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266420-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266420-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.81 mm [.150]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: FCI TERMINAL VW CRIMP SPECIFICATION				
TERMINAL NAME: 2.8mm FEMALE TERMINAL				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TE SEAL	FCI SEAL	SEAL INSULATION DIAMETER RANGE
3.90-4.70 mm [1.54-.185 IN]	∅			
TERMINAL APPLICATION SPECIFICATION	N104427			
TERMINALS APPLIED				
TE TERMINAL	FCI TERMINAL	TE SEAL	FCI SEAL	SEAL INSULATION DIAMETER RANGE
1572981-1	6 001 24 31	2113590-1	60994015	∅1.2-2.0mm
1572981-2	6 001 30 31	963294-1		∅1.2-2.1mm
1572981-3	6 001 32 32			
1572981-4	6 001 33 32			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30+/-0.04 [0.051+/-0.002]	8.4
0.75mm2	1.25+/-0.04 [0.049+/-0.002]	8.8
0.50mm2	1.20+/-0.04 [0.047+/-0.002]	9.2

- 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.
- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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)

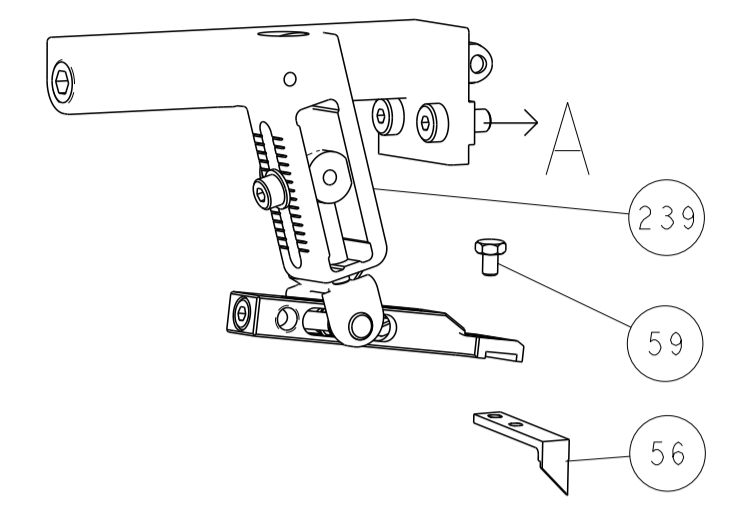
LOC	DIST	REV	DATE	BY	APPD
A	66	-	-	-	-

REV	DATE	BY	APPD	DESCRIPTION	ITEM NO	
-	1	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	-	1803259-1	BUSHING, FLANGED	249
-	1	1	-	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	-	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	-	2063440-1	AIR FEED MODULE	238
-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	-	994970-2	COUNTER, MAGNETIC	164
-	1	-	-	240638-1	SPRING, FEED FINGER	163
-	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	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	-	2844908-1	SCREW, LOCKING	99
-	1	1	-	2844907-1	POST, LOCKING	98
-	1	1	-	455888-8	SPACER, CRIMPER	82
-	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	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
5	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	-	1338685-1	PAWL, FEED	56
-	2	2	-	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	-	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	-	811242-5	BUMPER, HOLD DOWN	51
-	1	1	-	690753-2	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	-	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	-	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	-	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	-	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	-	455888-3	SPACER, CRIMPER	28
-	1	1	-	240792-1	DRAG, TERMINAL	25
-	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	-	2119533-1	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	9-1633927-7	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	-	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	-	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	-	4-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	-	455888-6	SPACER, CRIMPER	2
1	1	1	-	7-1633738-3	CRIMPER, WIRE	1

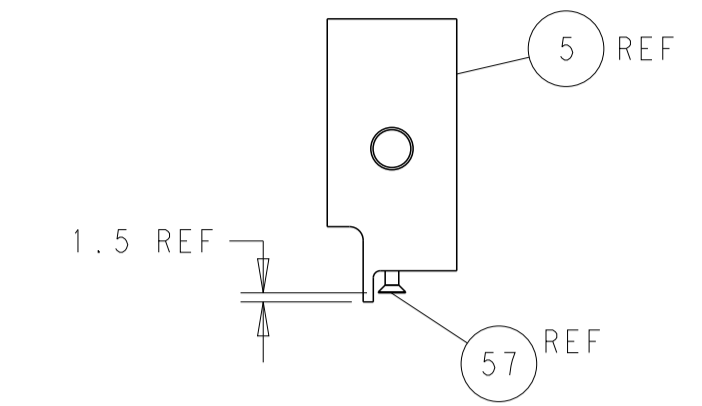
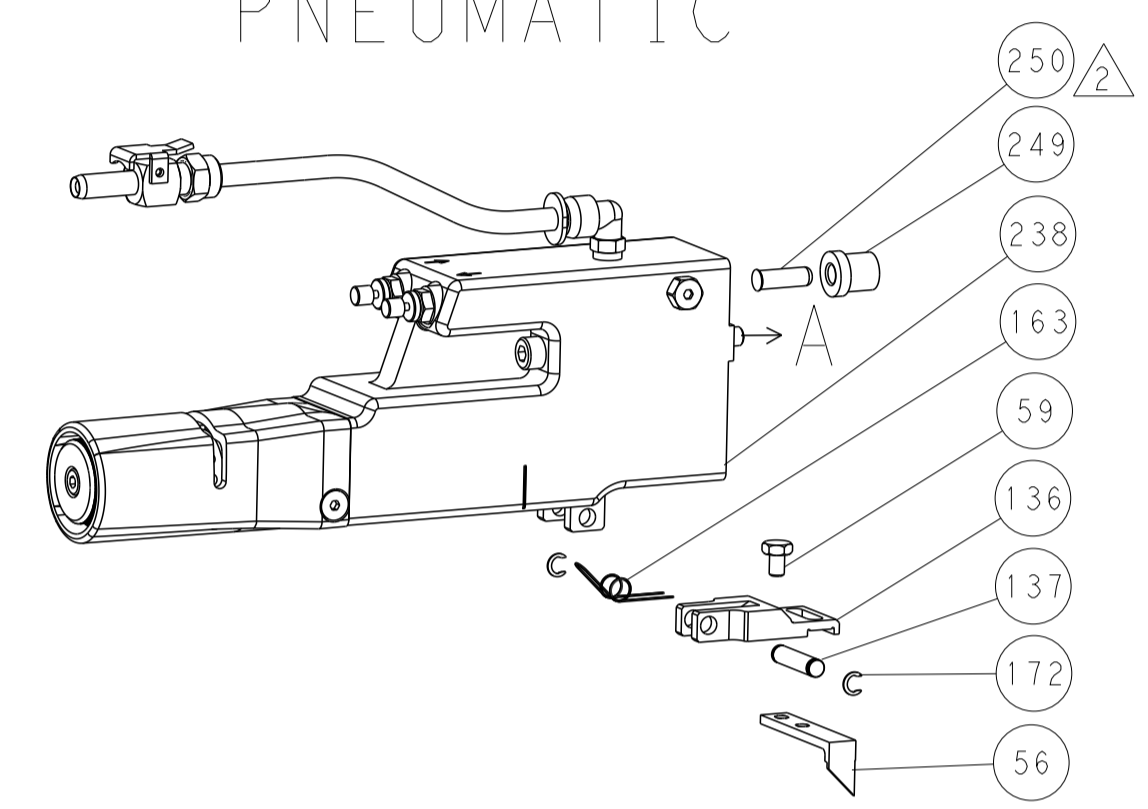
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	3	4	B	

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

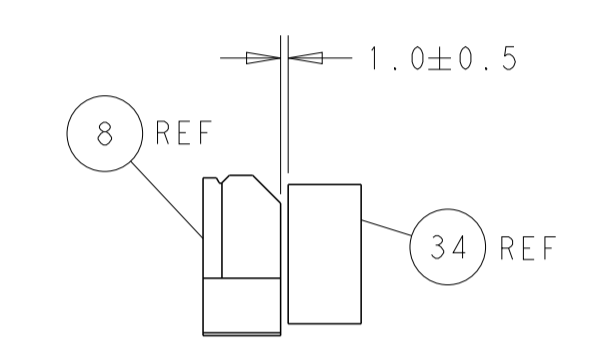
FEED TYPE MECHANICAL



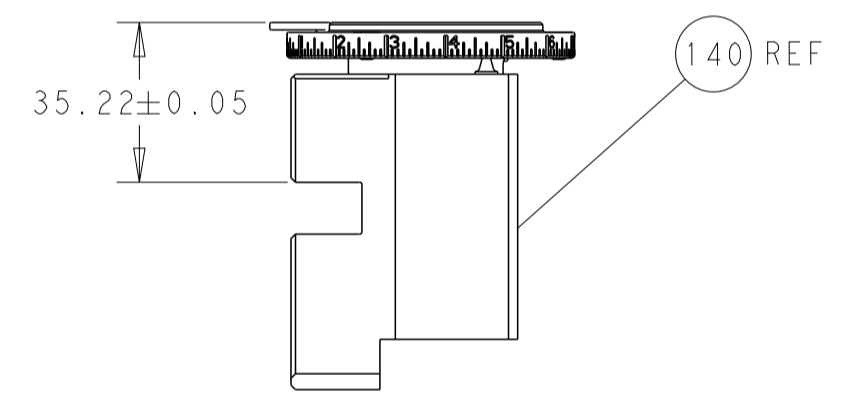
PNEUMATIC



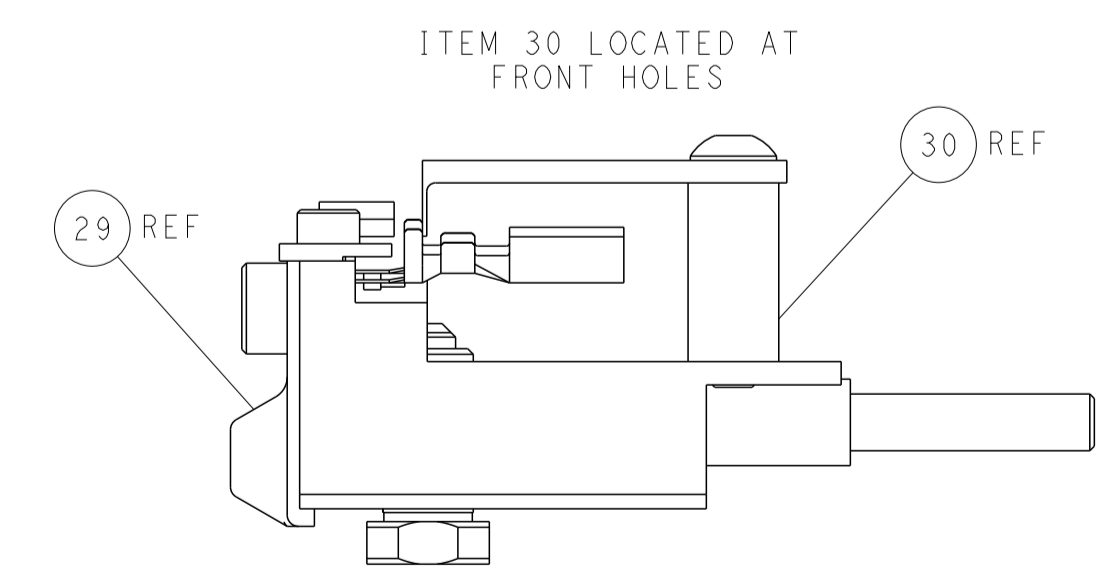
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

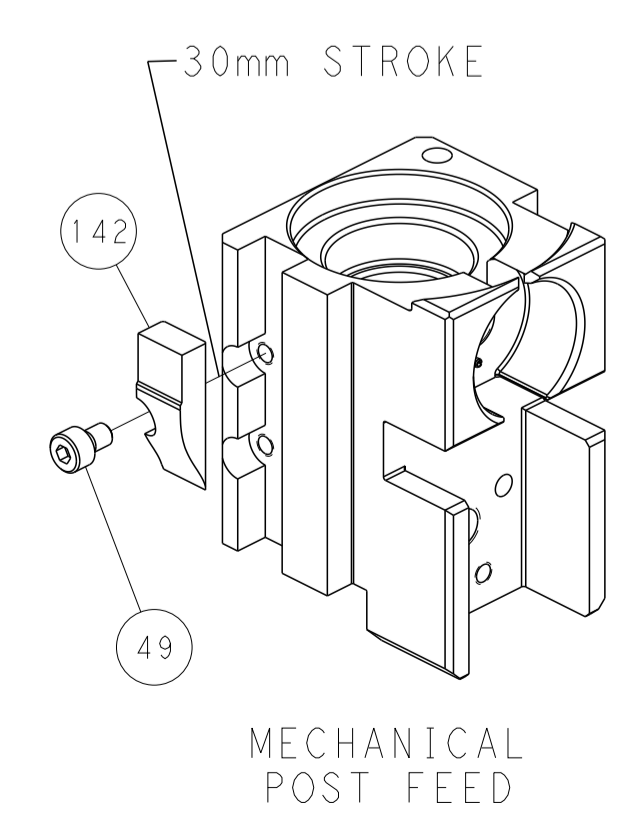


RAM SET-UP

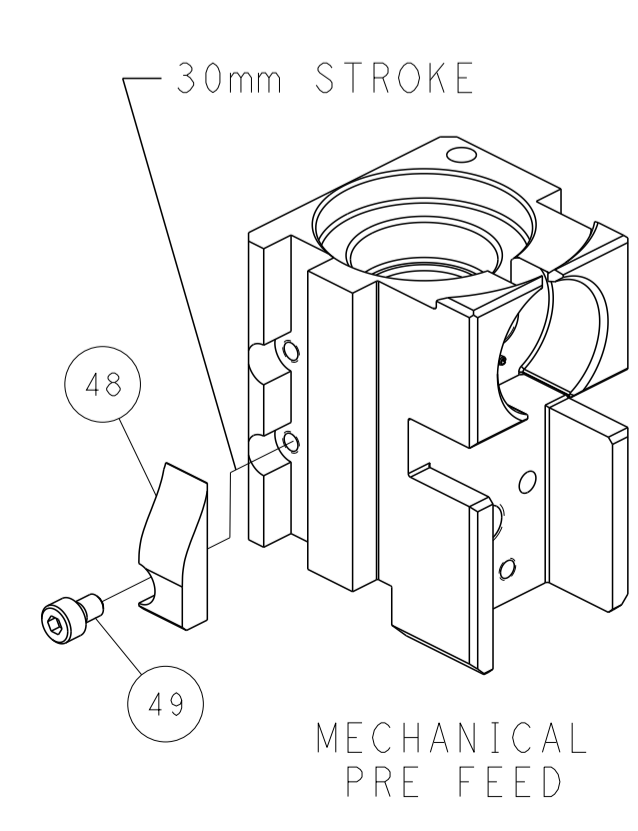


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

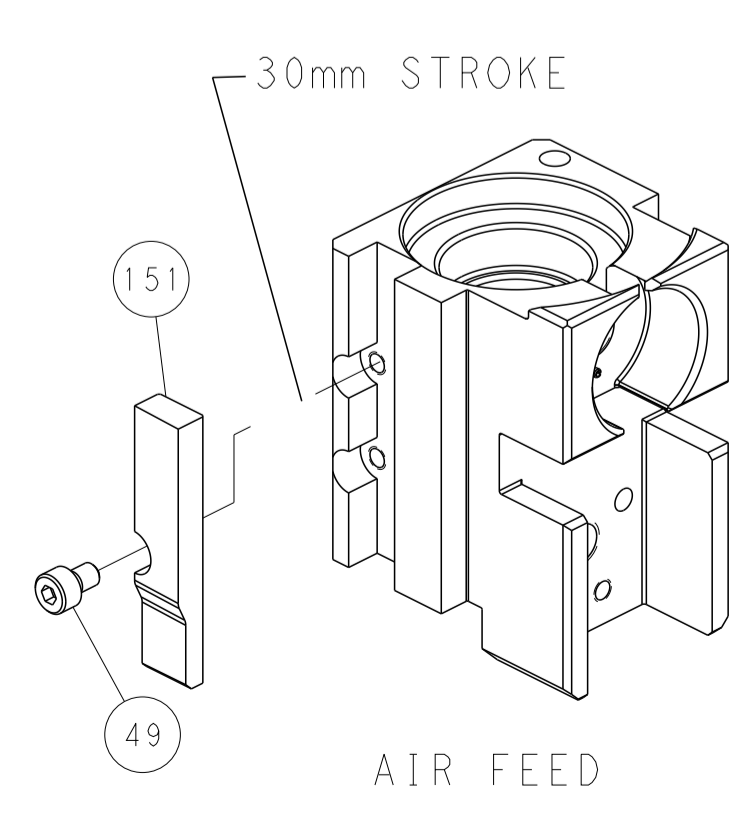
CAM POSITIONS



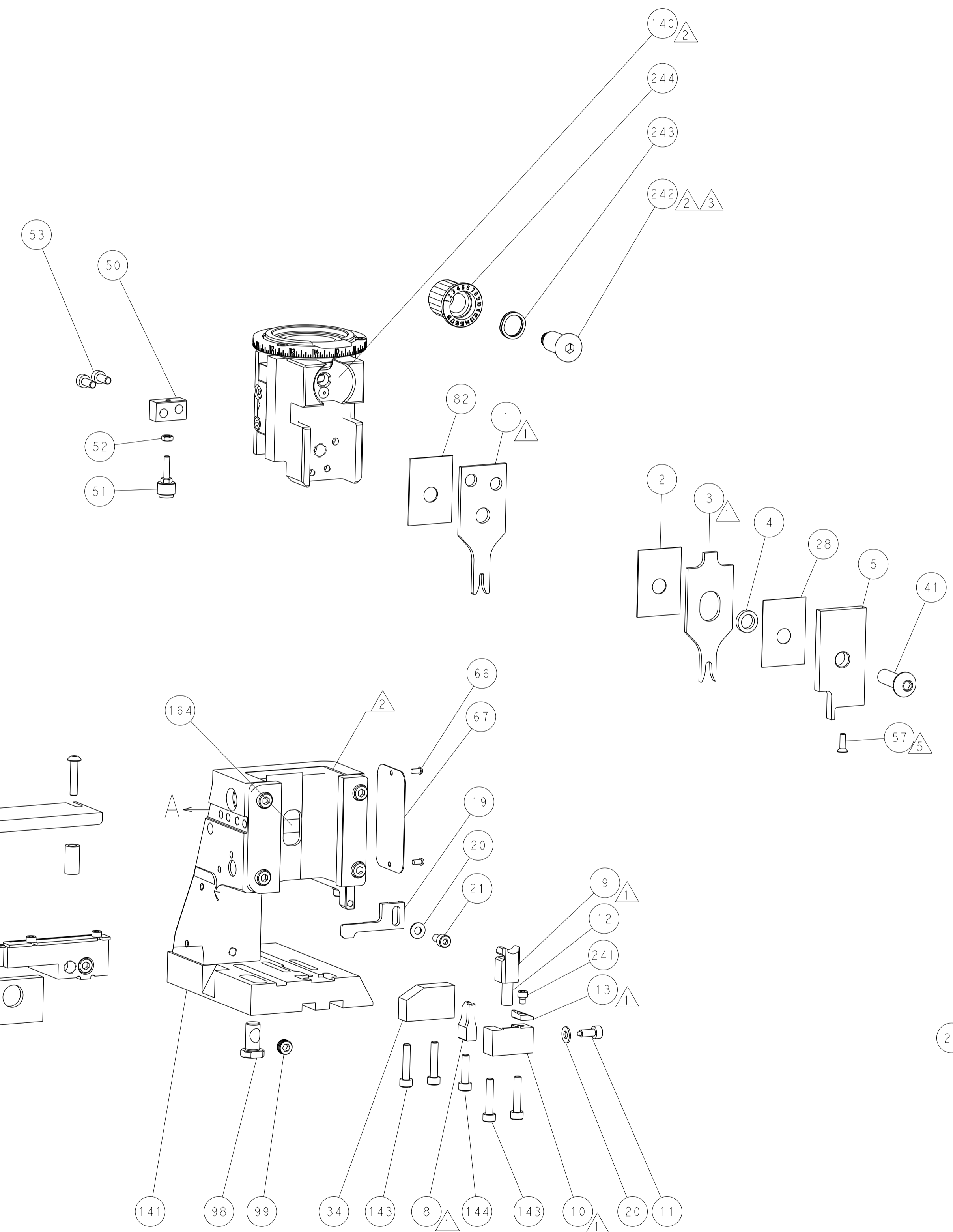
MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED



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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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266420	RESTRICTED TO: - SHEET 4 OF 4 REV B

Mouser Electronics

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