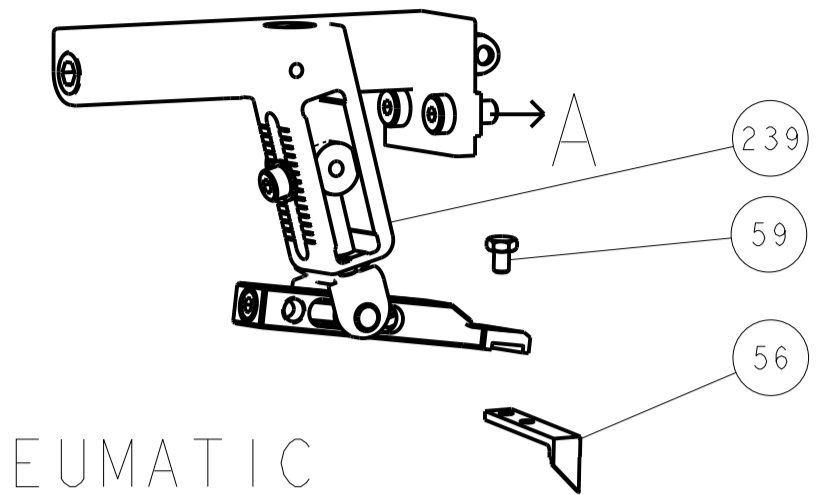
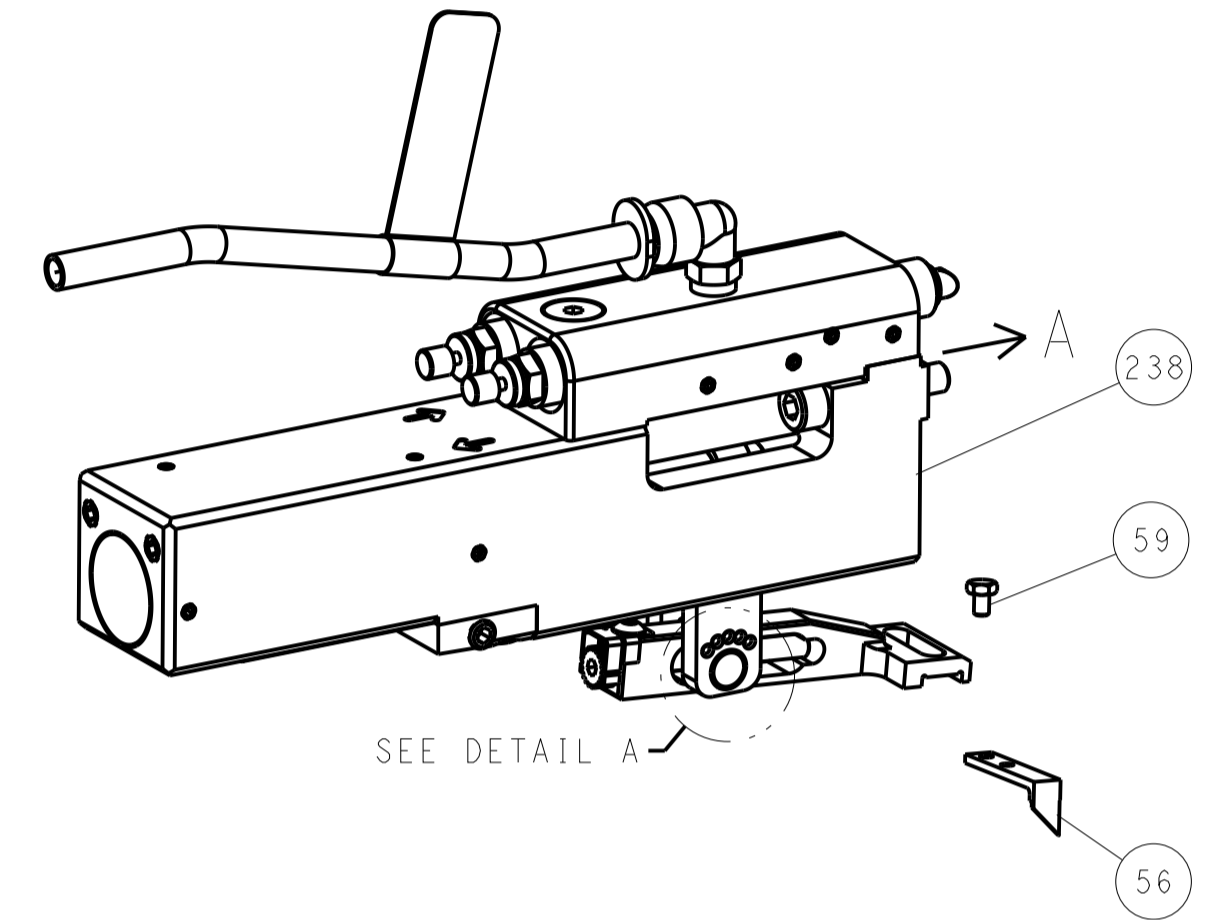


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

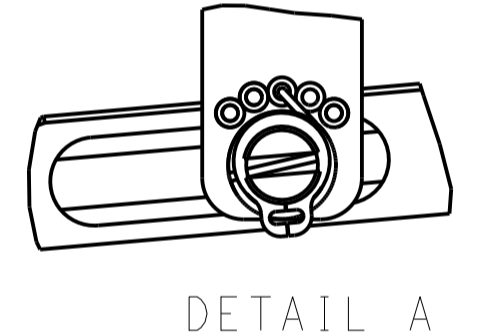
FEED TYPE MECHANICAL



PNEUMATIC

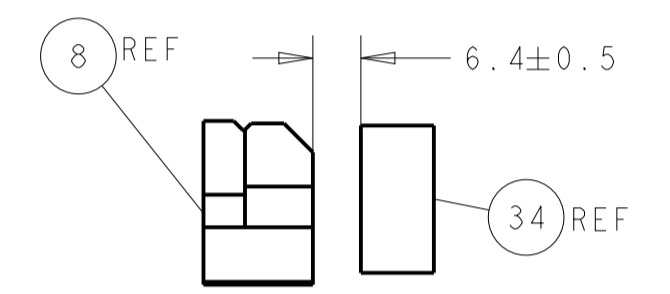
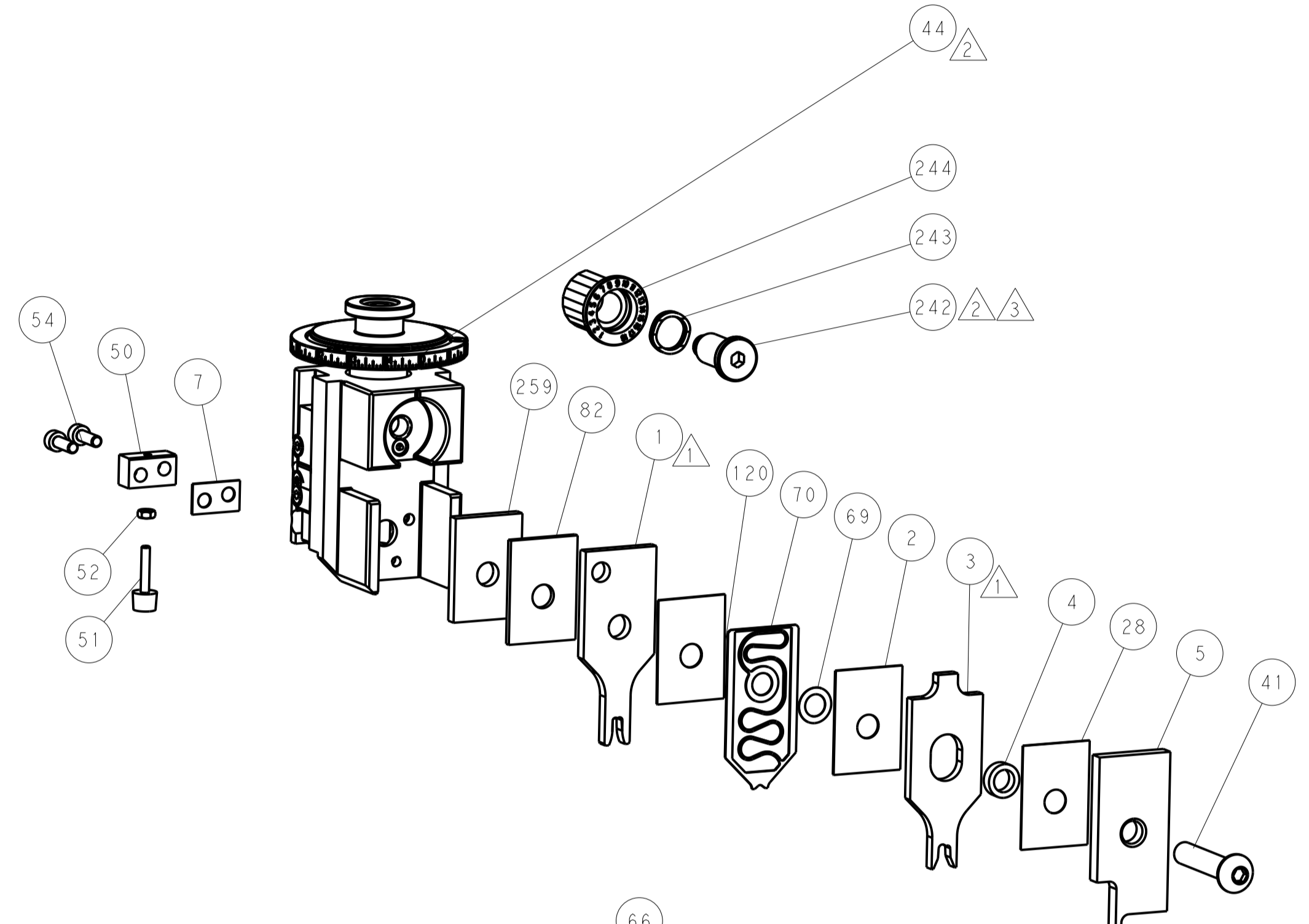
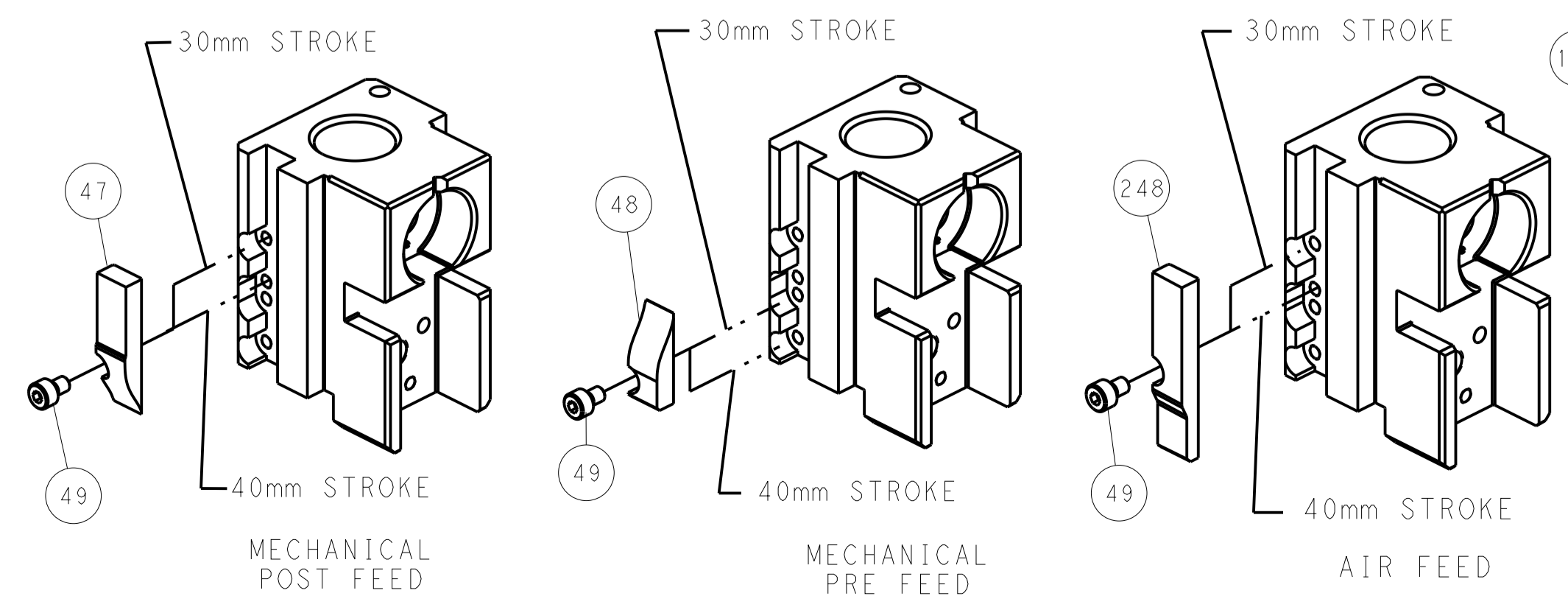


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

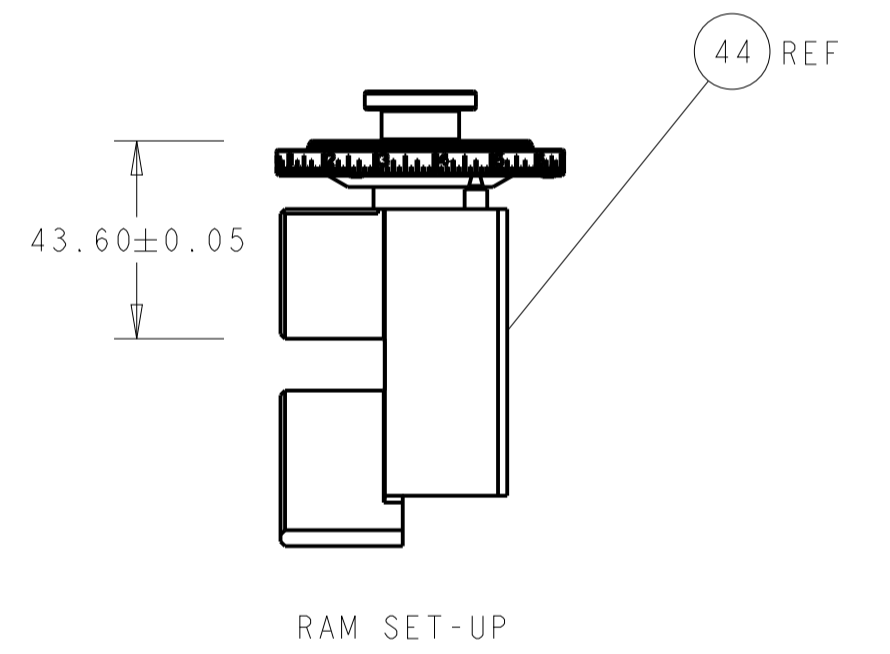


DETAIL A

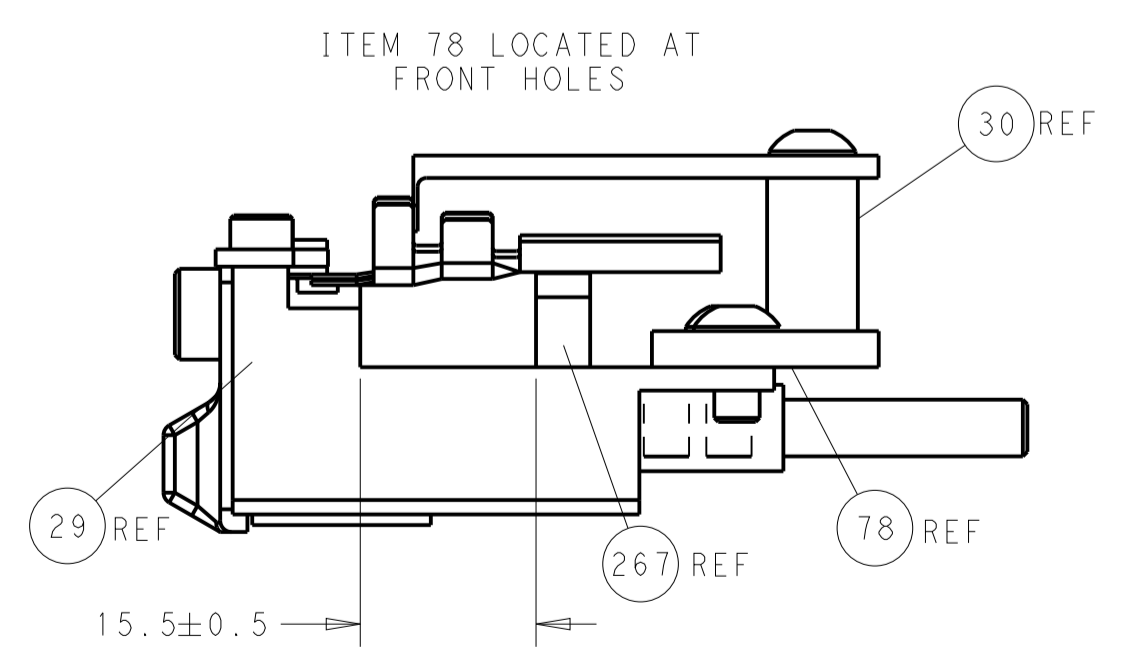
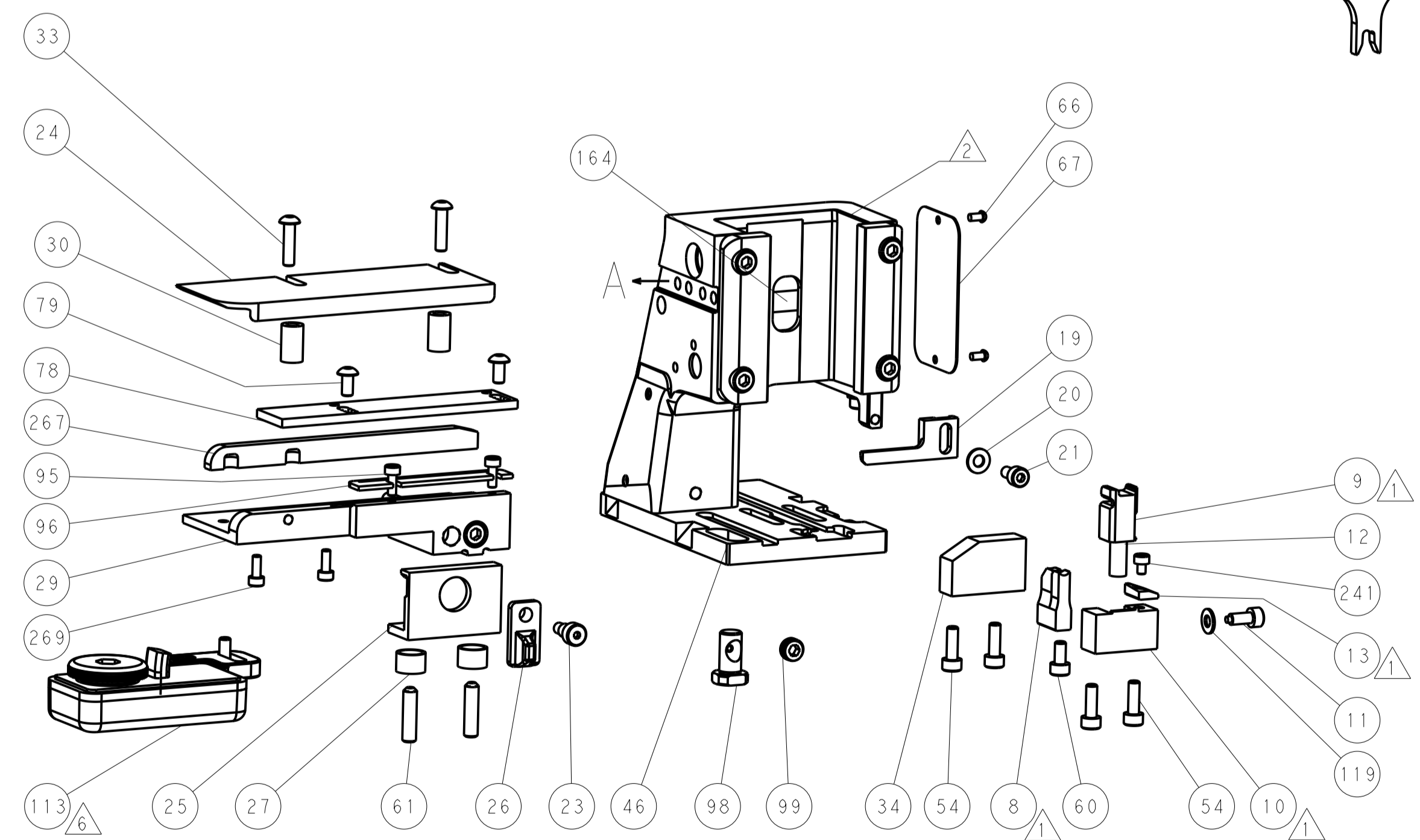
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



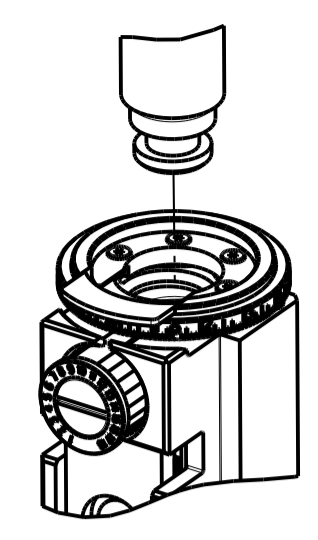
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 X ZHAO 20NOV2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME	Harrisburg, PA 17105-3608
	ANGLES					Customer Accessible Production Drawing	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2	
				APVD T. ELBIN 20NOV2013		SHEET 2 OF 4	
				APVD L. ZHANG 20NOV2013		REV E	
				SIZE: A1		RESTRICTED TO	
				CAGE CODE: 00779		DRAWING NO: 2266158	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266158-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266158-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266158-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [1.40]	F
INSUL	4.70 mm [1.85]	OV

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: LANGUETTE 6.3mm			
WIRE STRIP LENGTH 3.56-3.99 mm [1.40-.157 IN]		INSULATION DIAMETER RANGE Ø2.80-4.40 mm [1.10-.173 IN]	
TERMINAL APPLICATION SPECIFICATION	2252 C 001	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544218-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.65+/-0.05 [1.04+/-0.02]	4.0
5.00mm2	2.50+/-0.05 [1.098+/-0.02]	6.3
4.00mm2	2.35+/-0.05 [1.093+/-0.02]	7.5
3.00mm2	2.25+/-0.05 [1.089+/-0.02]	8.6

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

***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	REV	DATE	BY	APPV
A	66				

REVISIONS					
REV	DATE	BY	DESCRIPTION	DATE	APPV
-	-	-	SEE SHEET 1	-	-
-	2	2	2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1633782-3 FENCE	267	
-	1	1	1803078-3 SPACER, PRECISION	259	
-	1	1	2119082-7 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	1803516-2 RAM ASSEMBLY, SF PACIFIC	140	
-	1	1	455888-5 SPACER, CRIMPER	120	
-	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	1-690438-0 FRONT STRIP GUIDE	96	
-	2	2	2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1-455888-8 SPACER, CRIMPER	82	
-	2	2	2079383-4 SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1803096-1 EXTENSION PLATE	78	
-	1	1	1803607-3 DOCUMENTATION PACKAGE	71	
-	1	1	2119791-9 DEPRESSOR, WIRE	70	
-	1	1	2119943-1 WASHER, SPACER	69	
-	1	1	2119740-1 TAG IDENTIFICATION	67	
-	2	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2	2-18032-5 SCR, SET, FLT PNT, M5 X 20.0	61	
-	1	1	5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1338685-1 PAWL, FEED	56	
-	2	2	2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1803602-2 SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1752356-1 SUPPORT, TERMINAL	34	
-	2	2	2079383-8 SCR, BHSC, RoHS (M4 X 16)	33	
-	2	2	2-2844962-3 SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-3 ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-3 SPACER, CRIMPER	28	
-	2	2	22283-1 SPRING, COMPRESSION	27	
-	1	1	356835-1 LEVER, DRAG RELEASE	26	
-	1	1	240792-1 DRAG, TERMINAL	25	
-	1	1	1320928-4 STRIP GUIDE	24	
-	1	1	980371-4 SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	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	454276-5 FLOATING SHEAR, FRONT	9	
-	1	1	1633926-5 ANVIL, COMBINATION	8	
-	1	1	1-240641-7 SPACER	7	
-	-	-	-	6	
-	1	1	1-2119757-0 DEPRESSOR, SHEAR	5	
-	1	1	238011-1 BLOCK, CRIMPER SPACER	4	
-	1	1	6-1633964-9 CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	455888-5 SPACER, CRIMPER	2	
-	1	1	3-456411-1 CRIMPER, WIRE PREMIUM	1	
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

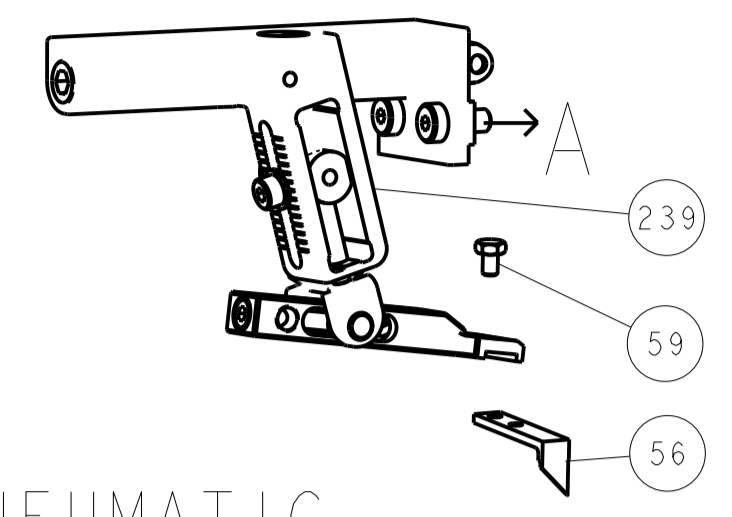
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: X. ZHAO 20NOV2013		CHK: T. ELBIN 20NOV2013		APVD: J. ZHANG 20NOV2013		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: E	
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: E	

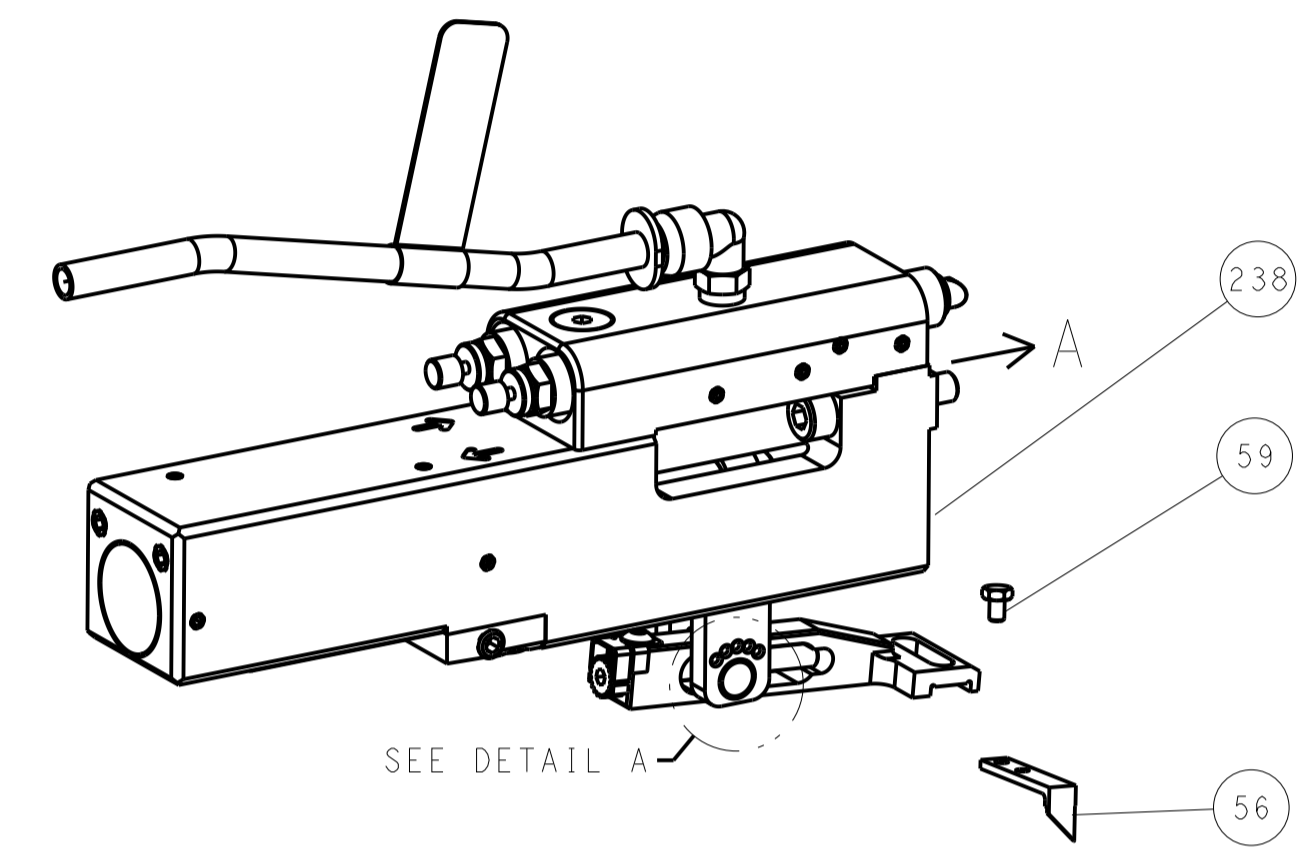
Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DATE	BY	APPV
- SEE SHEET 1			-	-	-

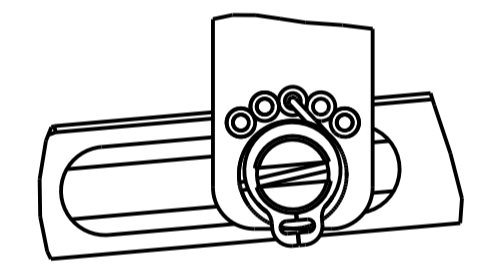
FEED TYPE MECHANICAL



PNEUMATIC

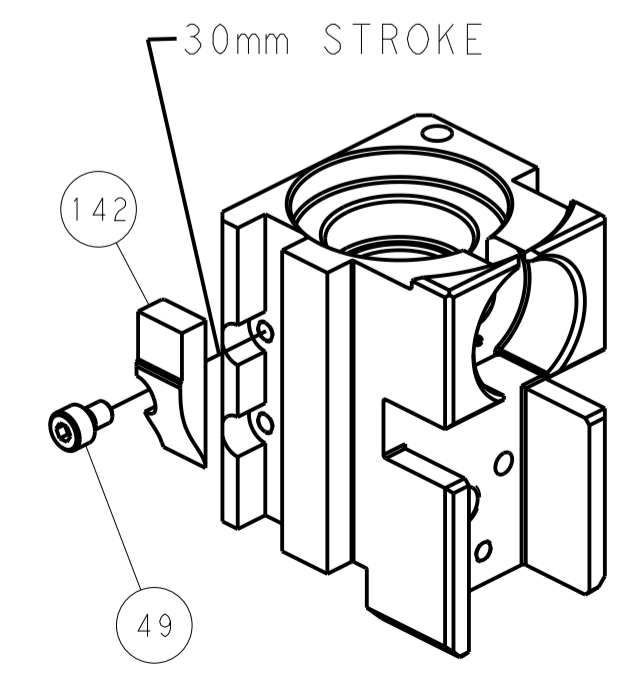


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

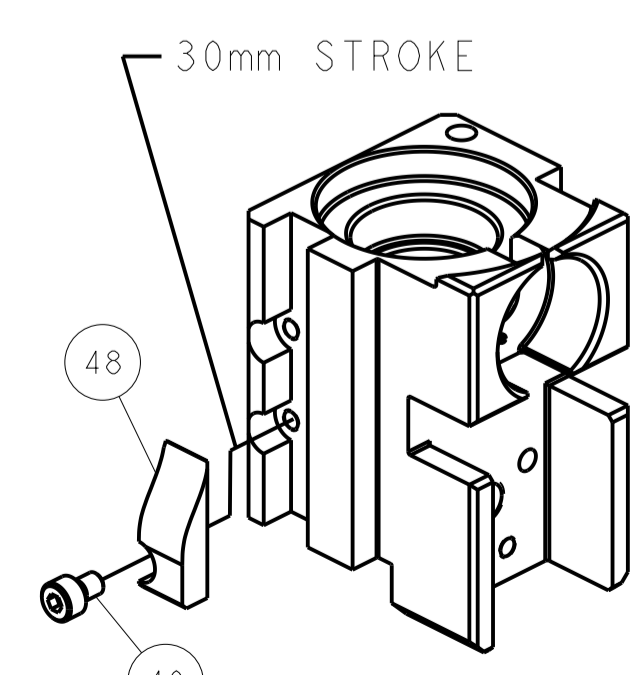


DETAIL A

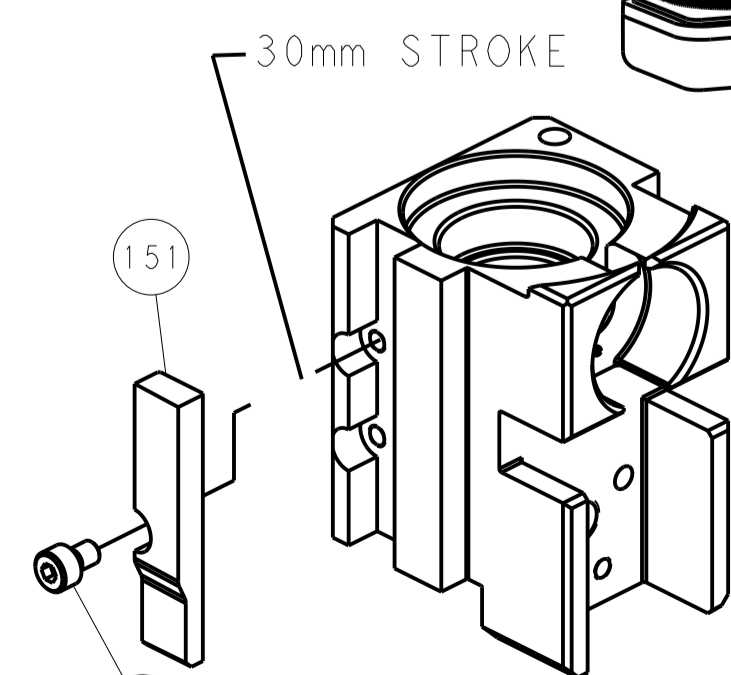
CAM POSITIONS



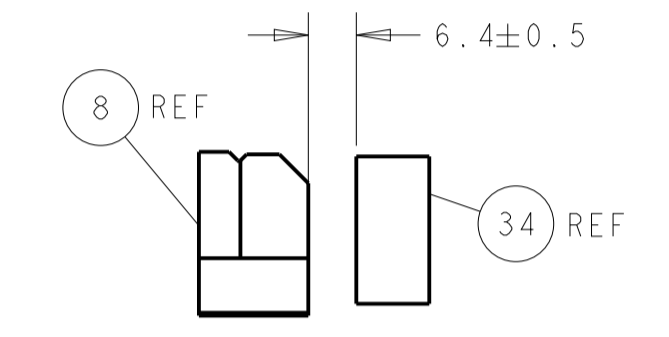
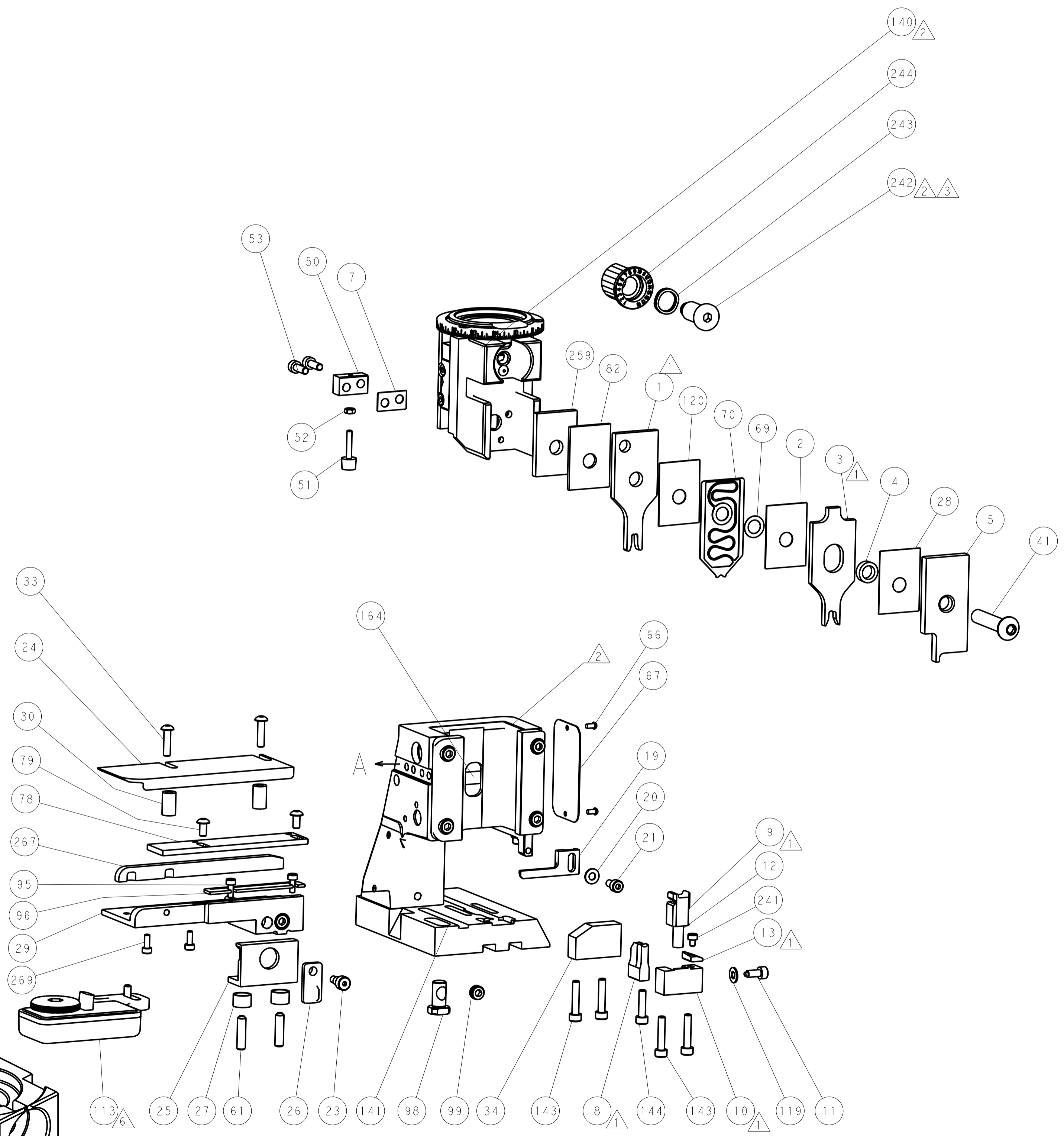
MECHANICAL
POST FEED



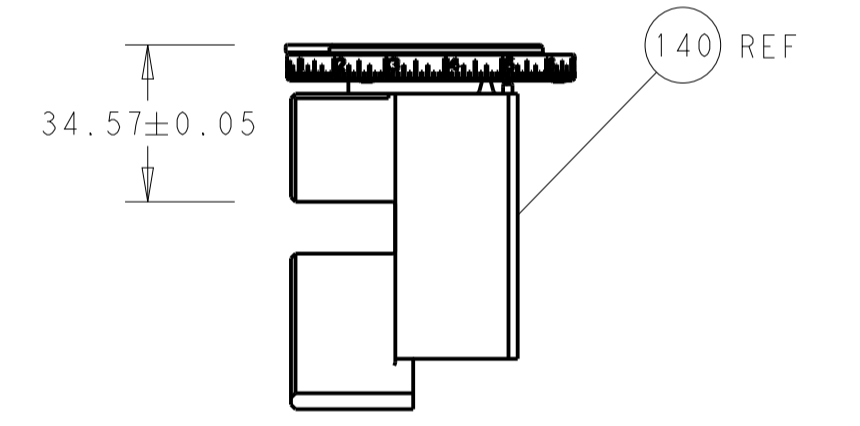
MECHANICAL
PRE FEED



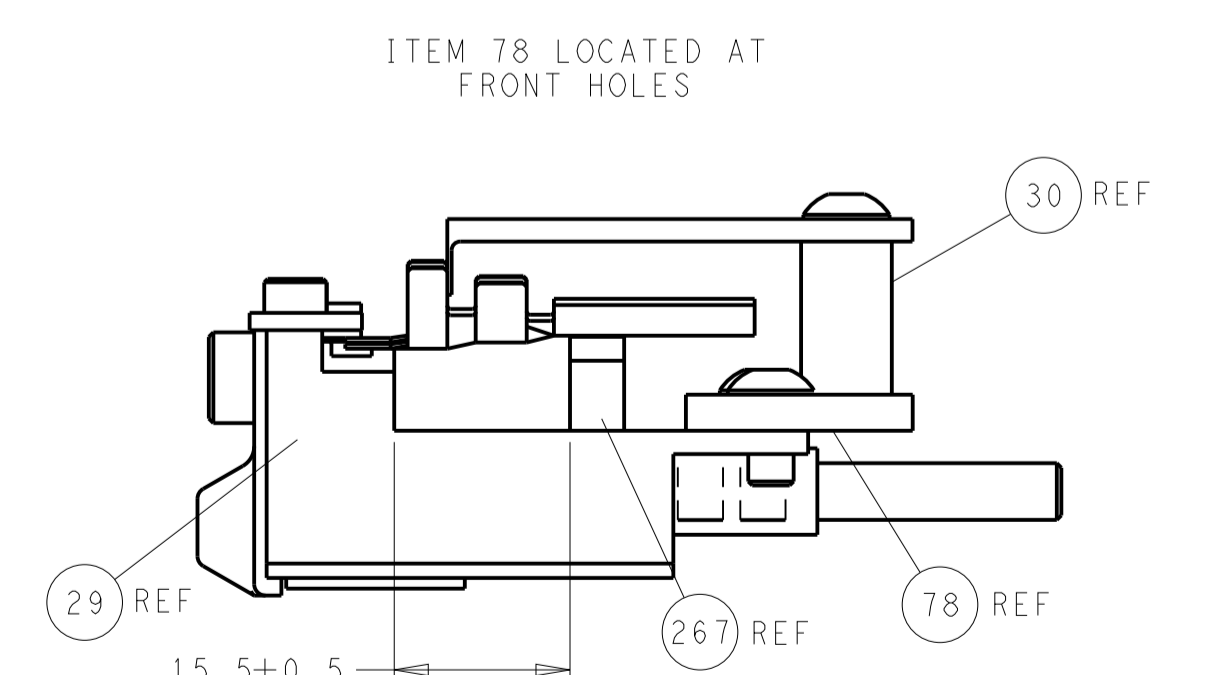
AIR FEED



TERMINAL SUPPORT LOCATION



RAM 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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X_ZHAO 20NOV2013		TE Connectivity	
mm	0 PLC	±		CHK: T_ELBIN 20NOV2013	Harrisburg, PA 17105-3608		
	1 PLC	±		APPV: L_ZHANG 20NOV2013	NAME: Ocean Side Feed Applicator		
	2 PLC	±		PRODUCT SPEC			
	3 PLC	±		APPLICATION SPEC			
	4 PLC	±		MATERIAL			
	ANGLES	±		WEIGHT			
FINISH				SIZE: CAGE CODE: DRAWING NO:		RESTRICTED TO:	
				A 00779 C=2266158		Customer Accessible Production Drawing	
				SCALE: 1:2		SHEET 4 OF 4 REV E	

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[TE Connectivity:](#)

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