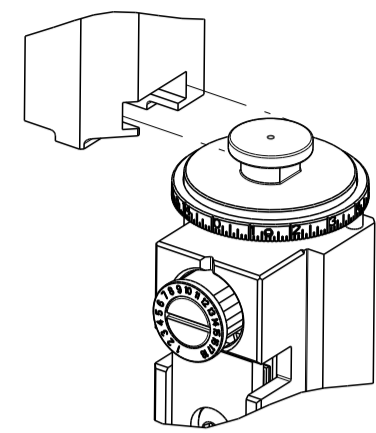


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266514-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266514-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266514-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266514-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266514-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

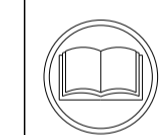


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.20 mm [.047]	F
INSUL	1.30 mm [.051]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: Yazaki TERMINAL Yazaki CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
2.70-3.30 mm [.106-.130 IN]	Ø1.14-1.52 mm [.045-.060 IN]		
TERMINAL APPLICATION SPECIFICATION	YPES-15-1389E Rev 1		
TERMINALS APPLIED			
TE TERMINAL	Yazaki TERMINAL	TE TERMINAL	Yazaki TERMINAL
2113591-1	7196-0070-02		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.92 +/- 0.03 [.036 +/- .001]	8.1
0.35mm2	0.78 +/- 0.03 [.031 +/- .001]	9.1



- 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. 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)

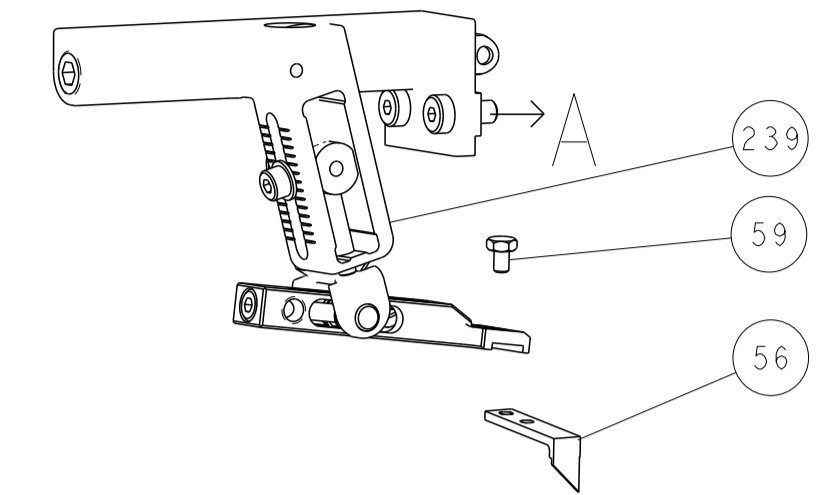
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		E		ECR-16-014984	21OCT2016	MEH	CT
		F		ECR-19-002532	17FEB2019	TB	CT

-	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	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	51	
-	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	2-1752356-5	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	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	2119533-3	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	1-356885-5	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
1	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1	9-1803056-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119757-9	DEPRESSOR, SHEAR	5	
-	1	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	8-1803019-1	CRIMPER, INSULATION O	3
-	-	-	-	-	-	-	2	
1	1	2	2	1	1	5-1752057-4	CRIMPER, WIRE PREMIUM, STEPPED	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

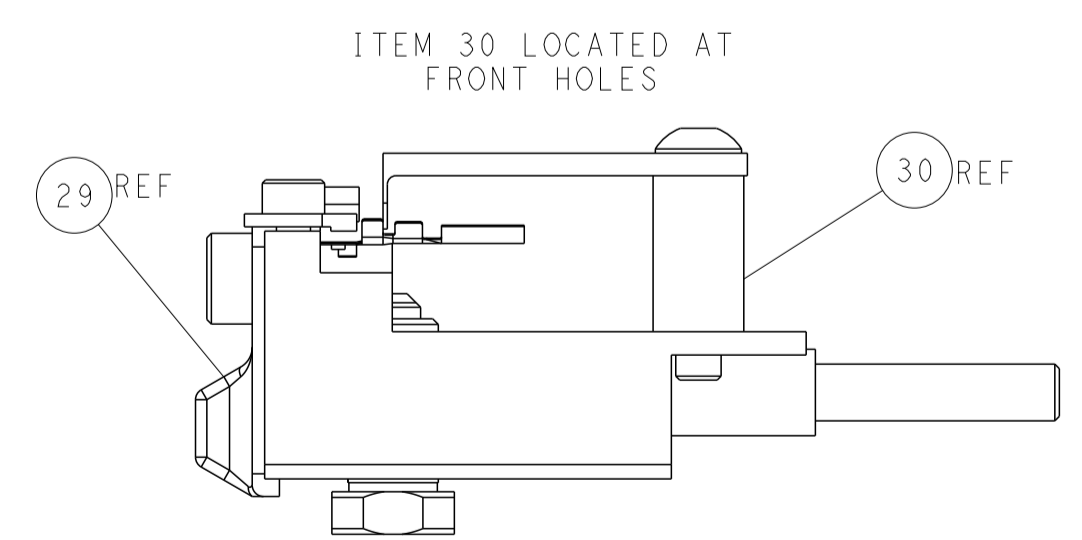
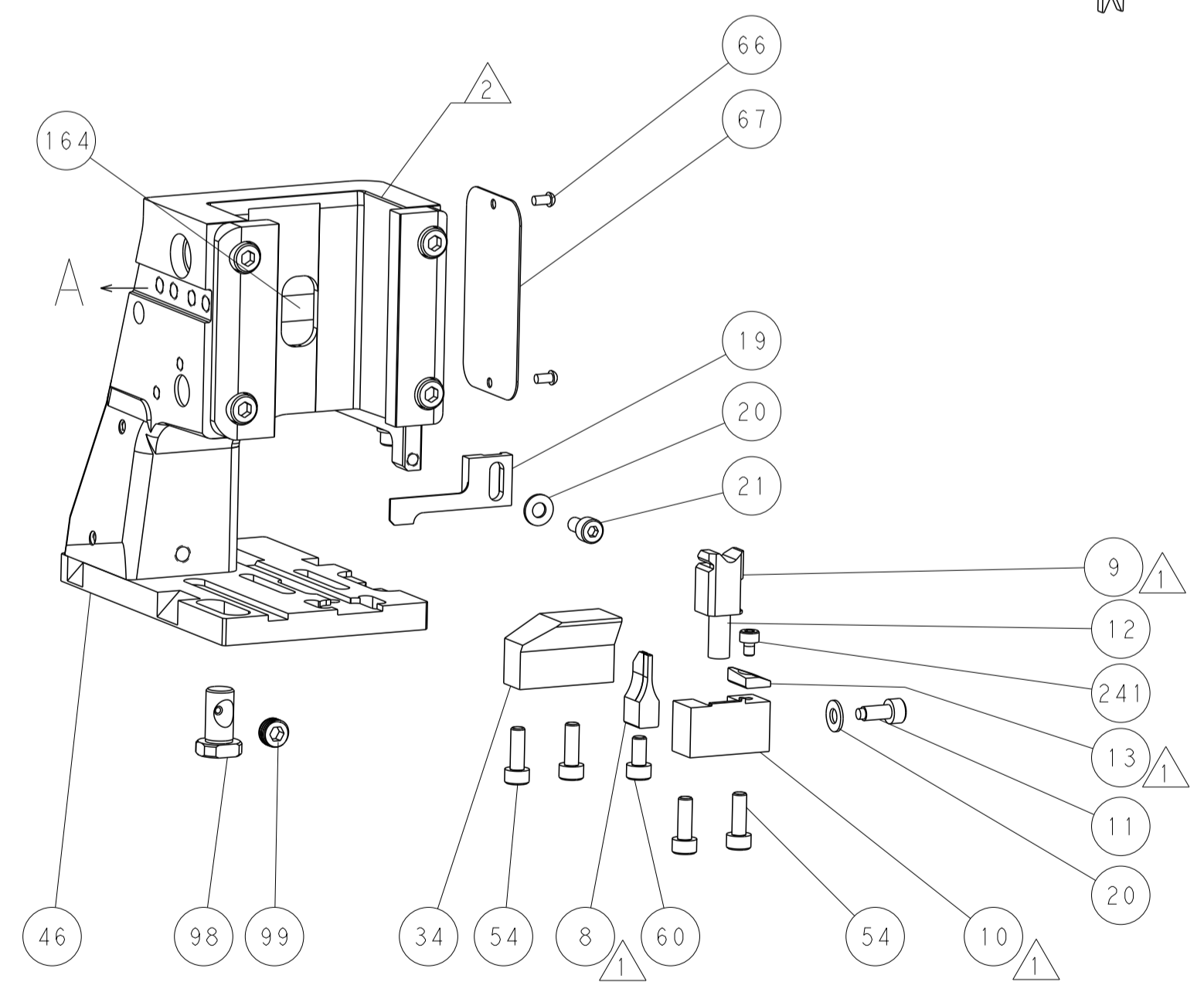
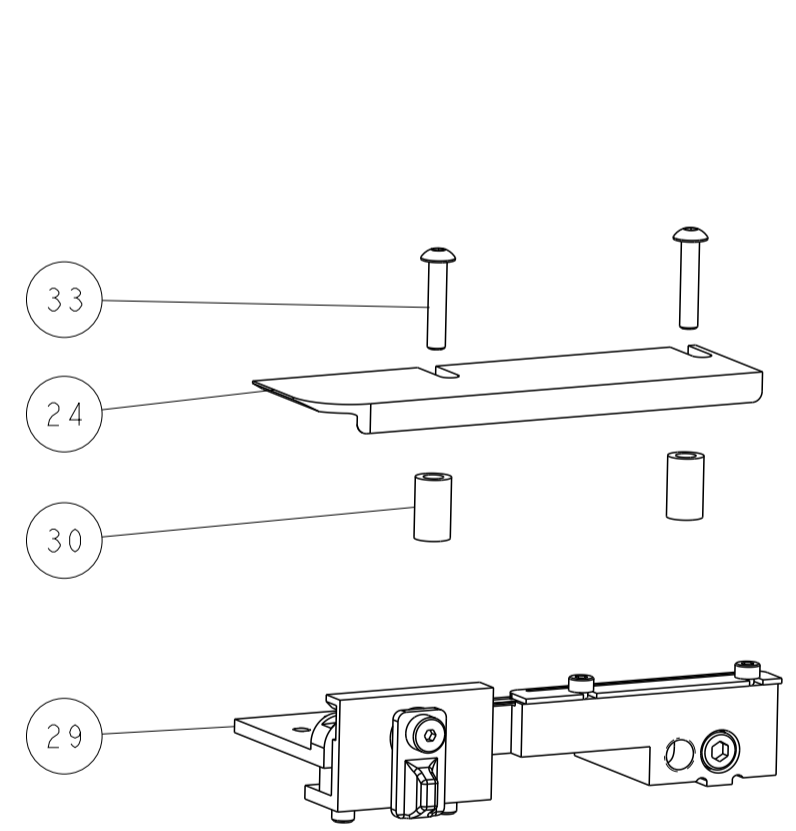
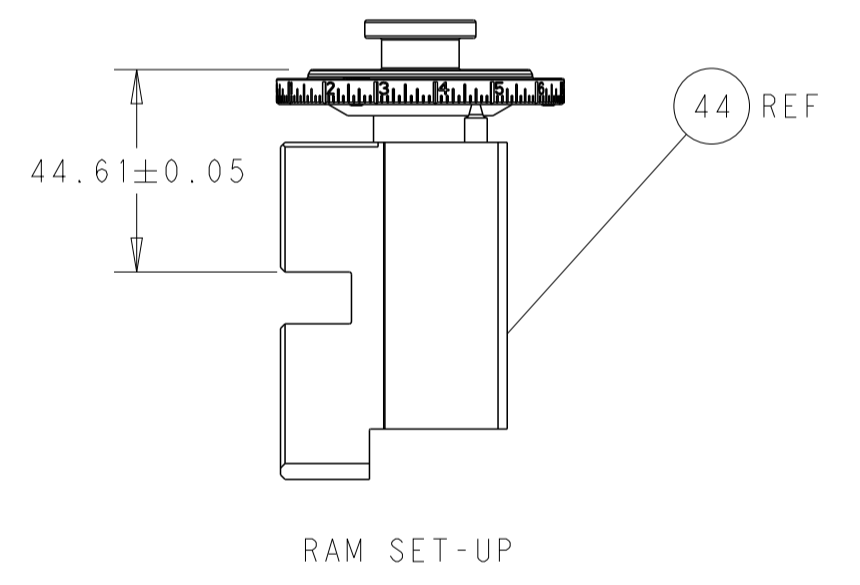
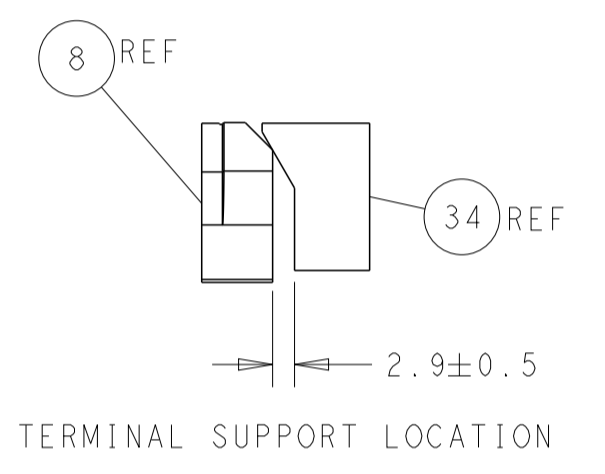
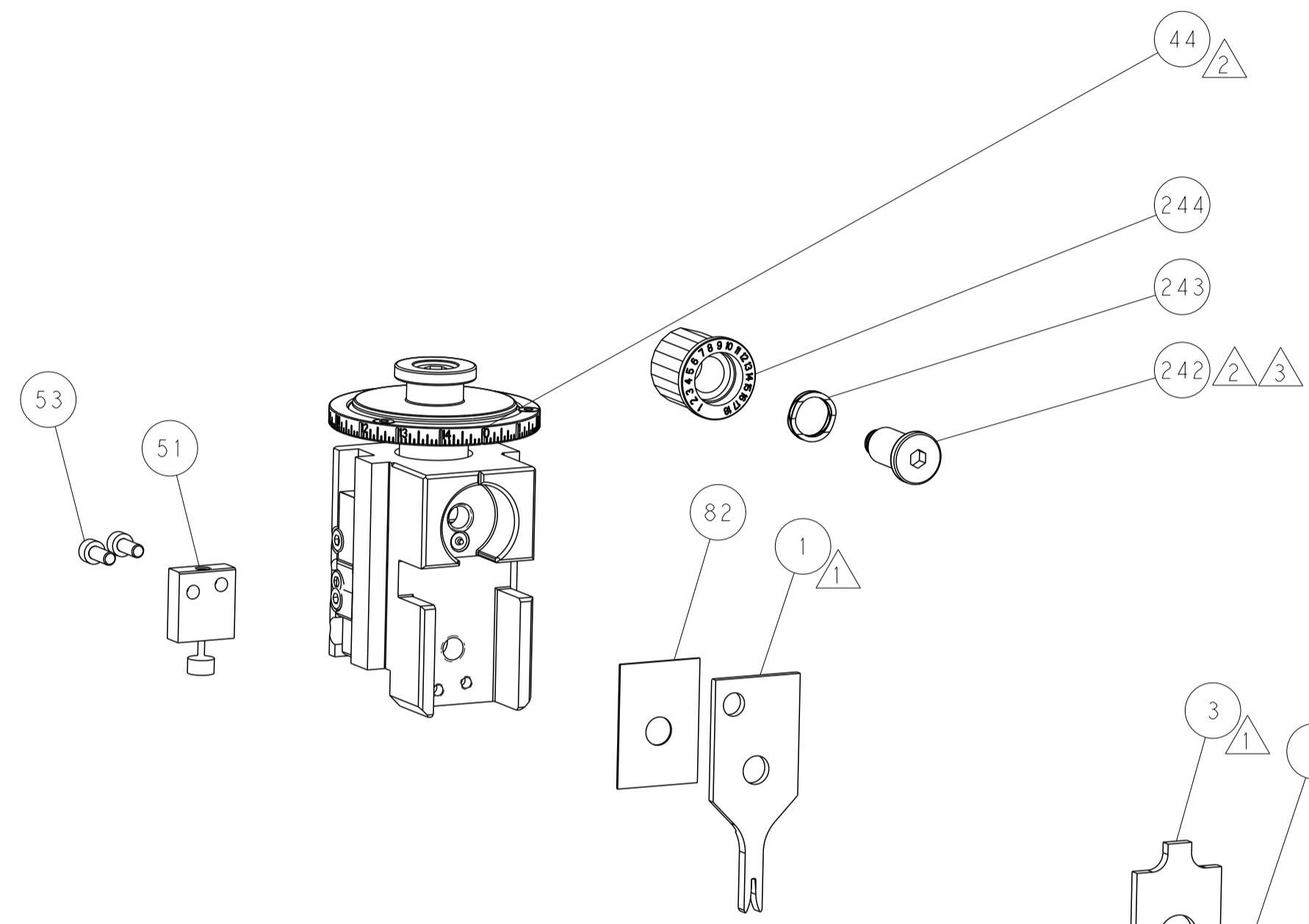
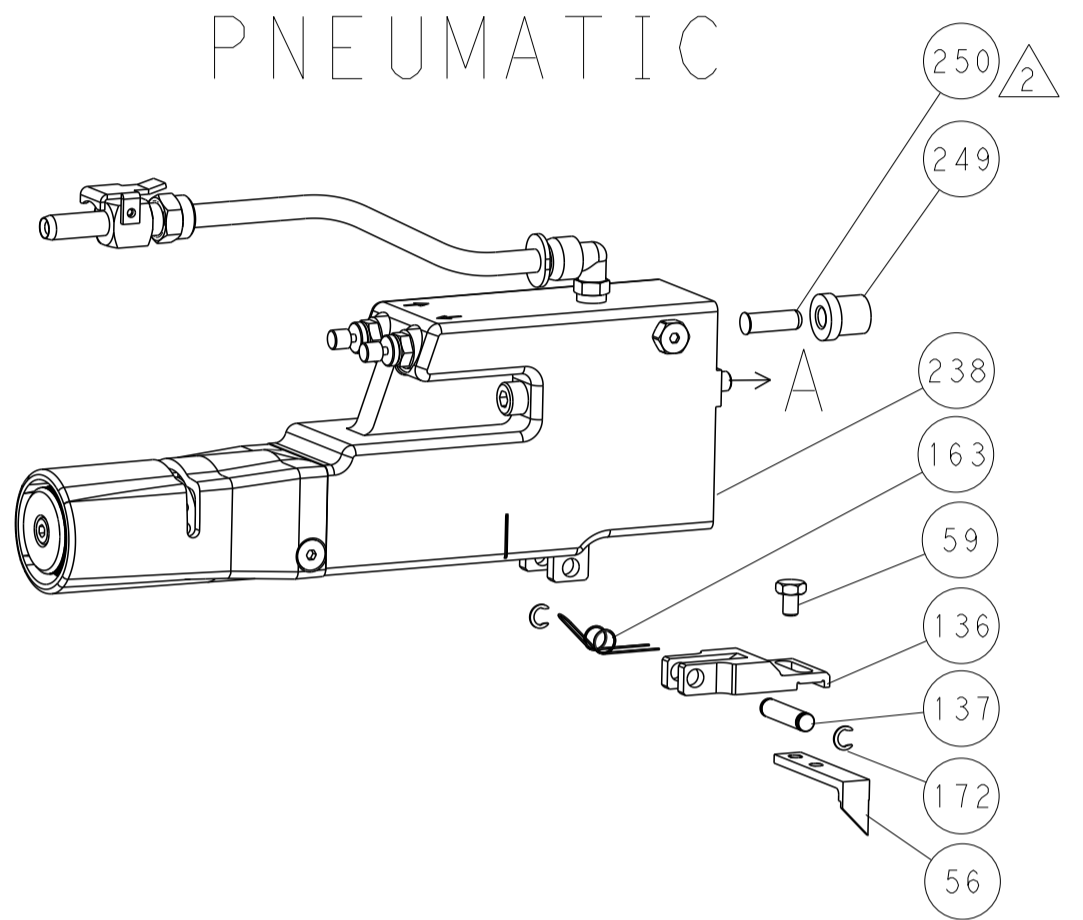
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH		
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	
OWN J.HOU 17OCT2014		CHK Y.YIN 17OCT2014		APVD U.GUO 17OCT2014		NAME		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 OF 4		REV F			

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

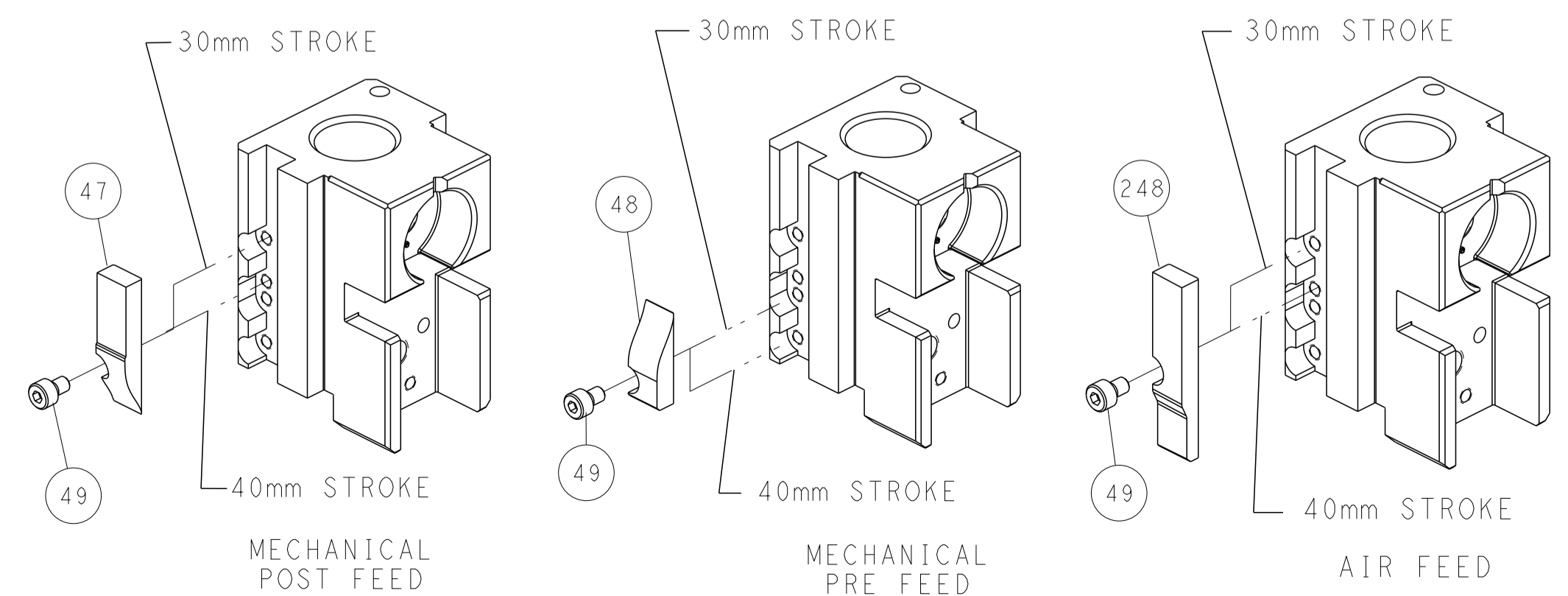
FEED TYPE MECHANICAL



PNEUMATIC



CAM POSITIONS



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:		DWG: J.HOU 17OCT2014		TE Connectivity	
mm		0 PLC ±		CHK: Y.YIN 17OCT2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: J.GUO 17OCT2014		NAME: Ocean Side Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
D		3 PLC ±		APPLICATION SPEC		RESTRICTED TO:	
R		4 PLC ±		WEIGHT		A1 00779 ©=2266514	
FINISH		FINISH		SCALE: 1:2		SHEET 2 OF 4 REV F	
MATERIAL:				Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266514-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266514-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266514-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.20 mm [.047]	F
INSUL	1.30 mm [.051]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: Yazaki TERMINAL Yazaki CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH 2.70-3.30 mm [1.06-.130 IN]	INSULATION DIAMETER RANGE Ø1.14-1.52 mm [.045-.060 IN]
--	---

TERMINAL APPLICATION SPECIFICATION YPES-15-1389E Rev 1

TERMINALS APPLIED

TE TERMINAL	Yazaki TERMINAL	TE TERMINAL	Yazaki TERMINAL
2113591-1	7196-0070-02		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.92 +/- 0.03 [.036 +/- .001]	8.1
0.35mm2	0.78 +/- 0.03 [.031 +/- .001]	9.1



- 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.
- 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	REV	DATE	BY	APPV
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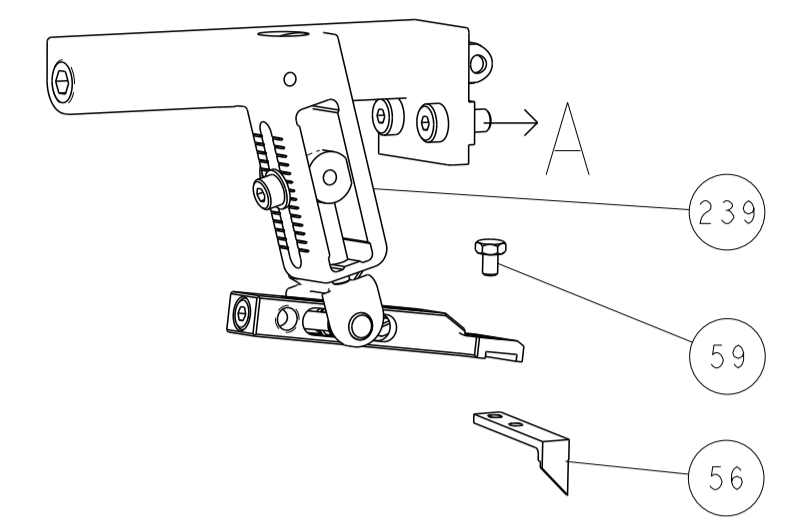
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	-		2119640-1 PUSH ROD, AIR FEED	250
-	1	-		1803259-1 BUSHING, FLANGED	249
-	1	1		2119082-5 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1		2119083-1 RETAINER, INSULATION DIAL	242
-	1	1		7-18023-7 SCR, SKT HD CAP M3 X 4.0	241
-	-	1		2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1	-		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		455888-5 SPACER, CRIMPER	82
-	1	1		1803607-1 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		1803382-1 HOLD DOWN, SPRING LOADED	51
-	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		2-1752356-5 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		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		2119533-3 STRIPPER, SIDE FEED	19
-	1	1		2119806-1 INSERT, SHEAR	13
-	1	1		3-22280-3 SPRING, COMPRESSION	12
-	1	1		1-356885-5 STOP, SHEAR	11
-	1	1		2119805-1 SHEAR HOLDER, FRONT	10
-	1	1		1803095-6 FLOATING SHEAR, FRONT	9
-	1	1		9-1803056-6 ANVIL, COMBINATION	8
-	-	-		-	7
-	-	-		-	6
-	1	1		1-2119757-9 DEPRESSOR, SHEAR	5
-	1	1		3-238011-8 BLOCK, CRIMPER SPACER	4
-	1	1		8-1803019-1 CRIMPER, INSULATION O	3
-	-	-		-	2
-	1	1		5-1752057-4 CRIMPER, WIRE PREMIUM, STEPPED	1

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

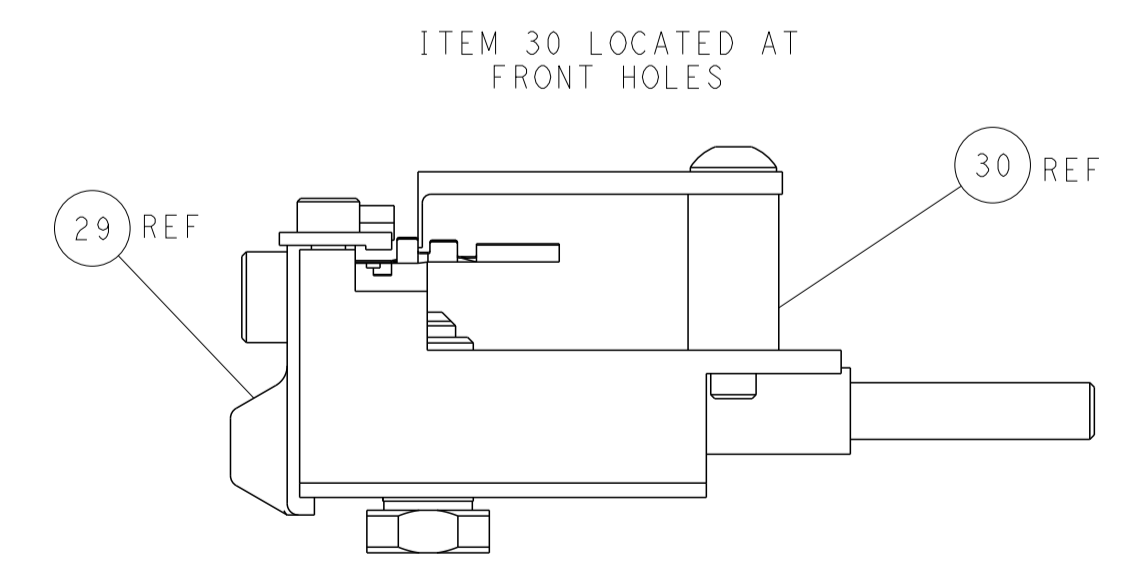
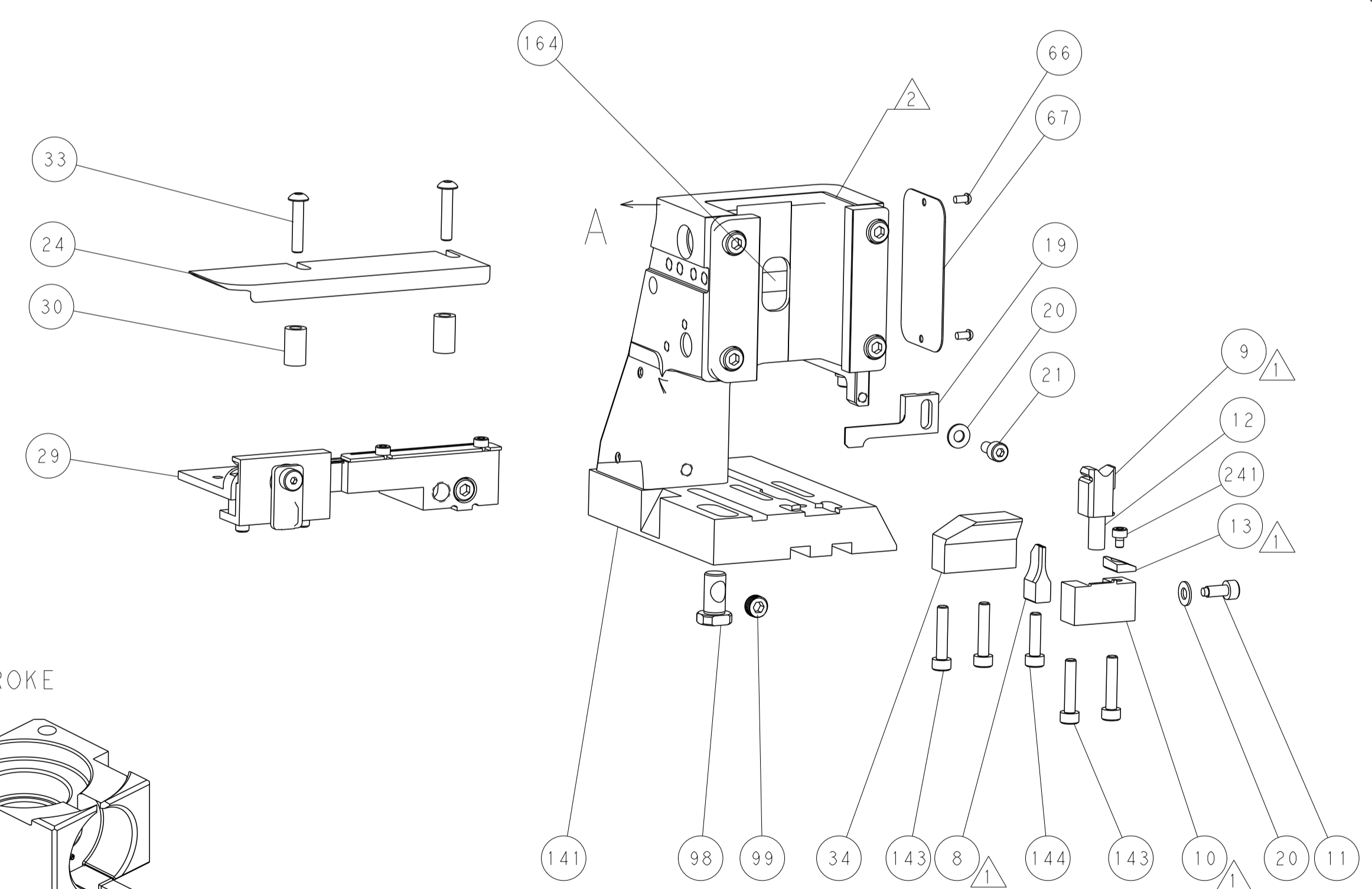
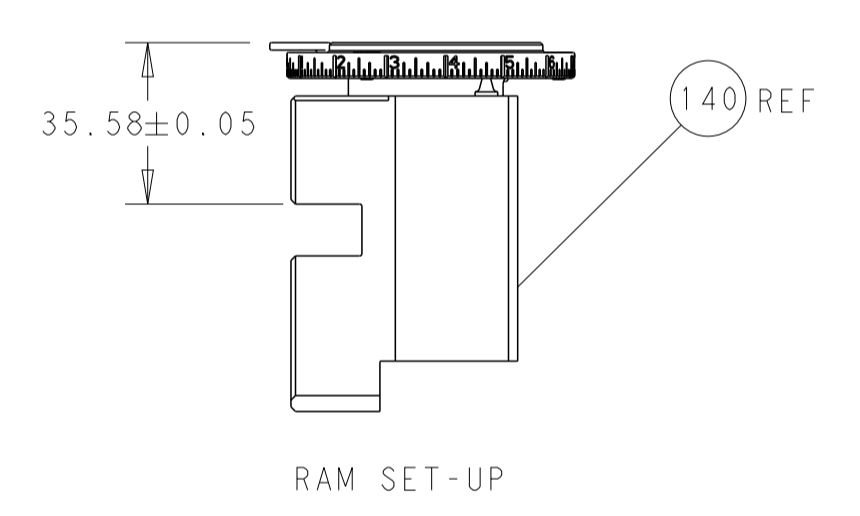
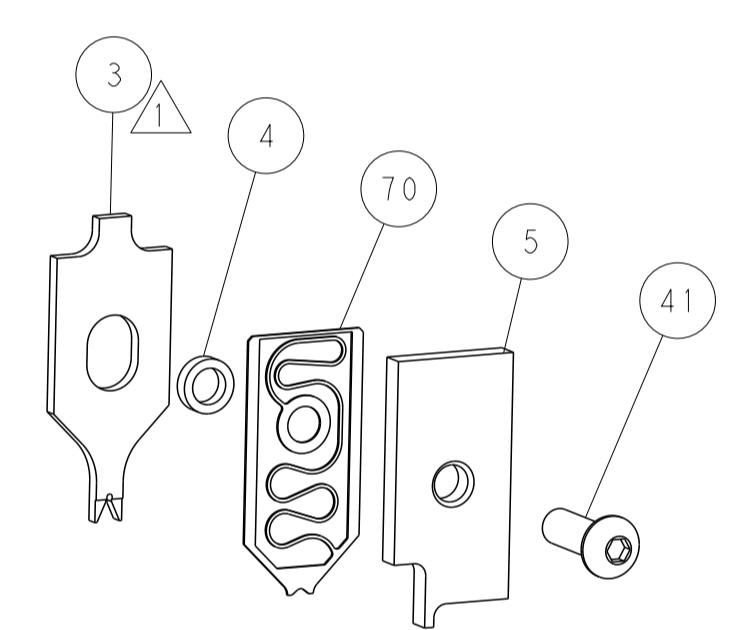
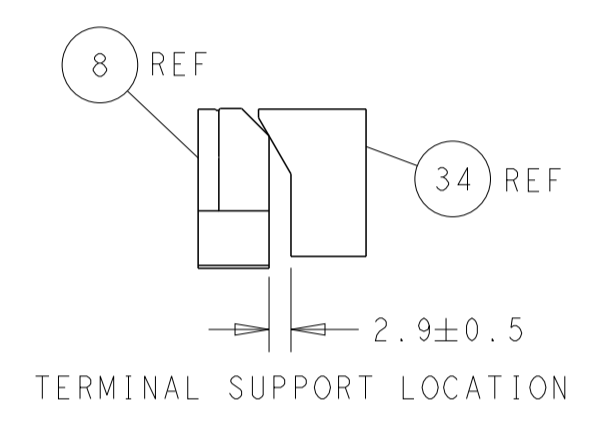
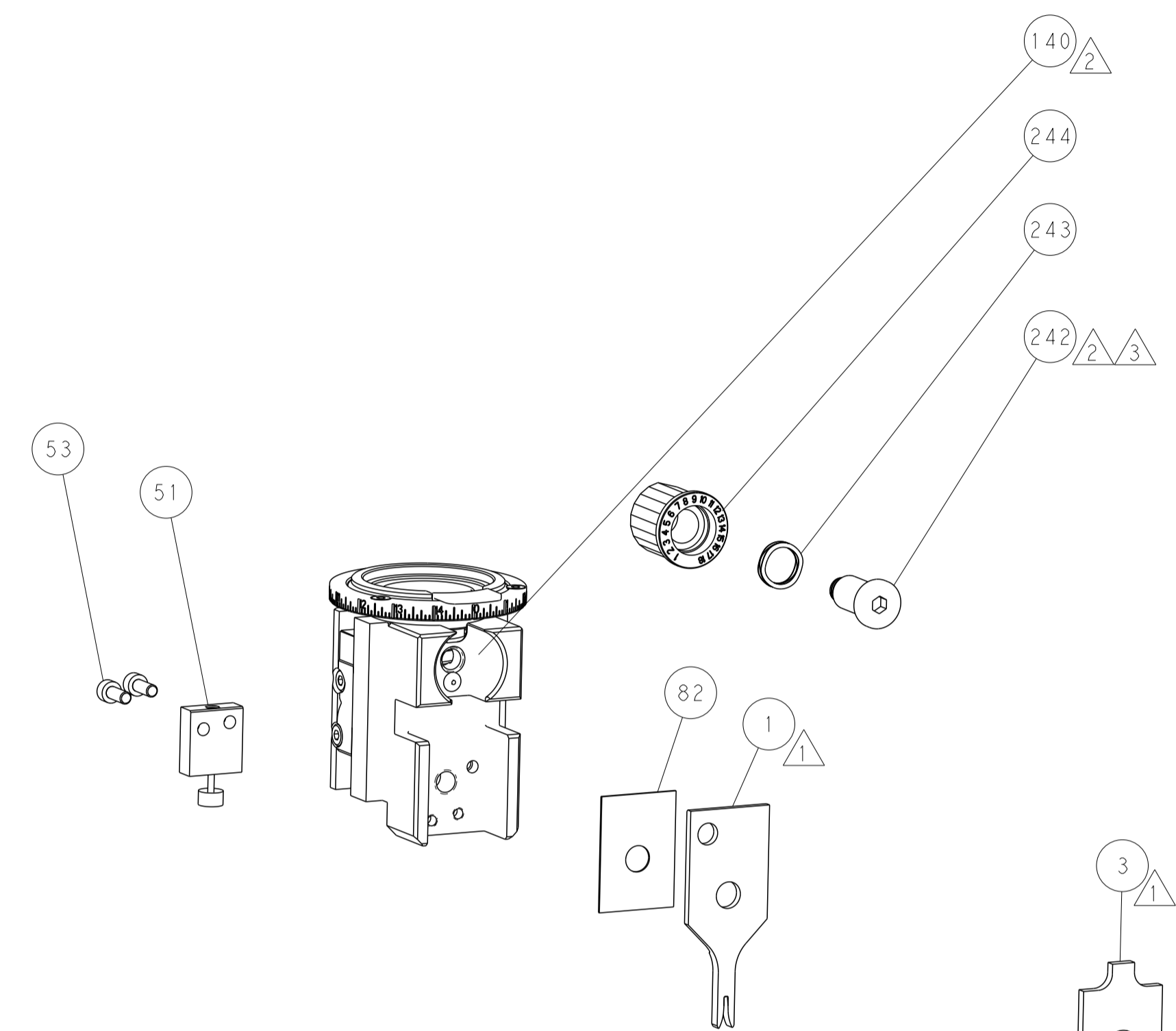
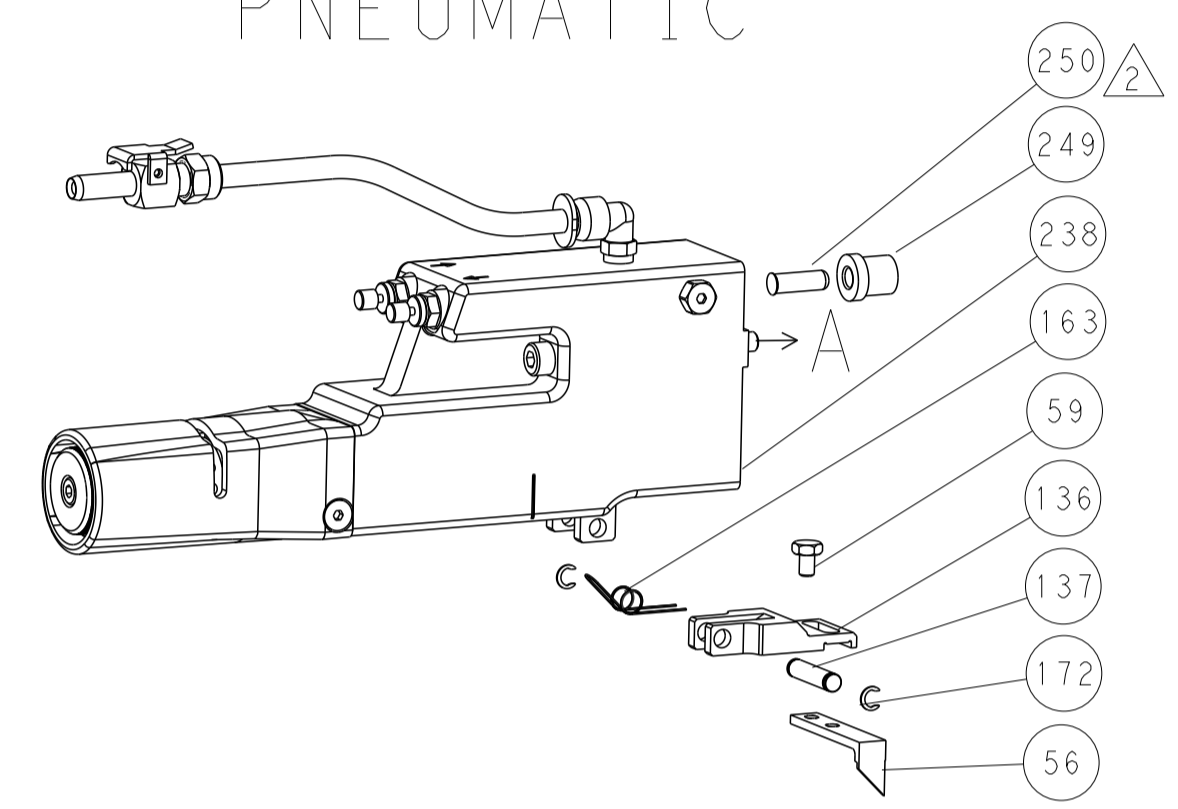
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG J.HOU 11OCT2014 CHK Y.YIN 11OCT2014 APVD J.GUO 11OCT2014 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 3 OF 4 REV F		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2266514 RESTRICTED TO Customer Accessible Production Drawing	
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LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

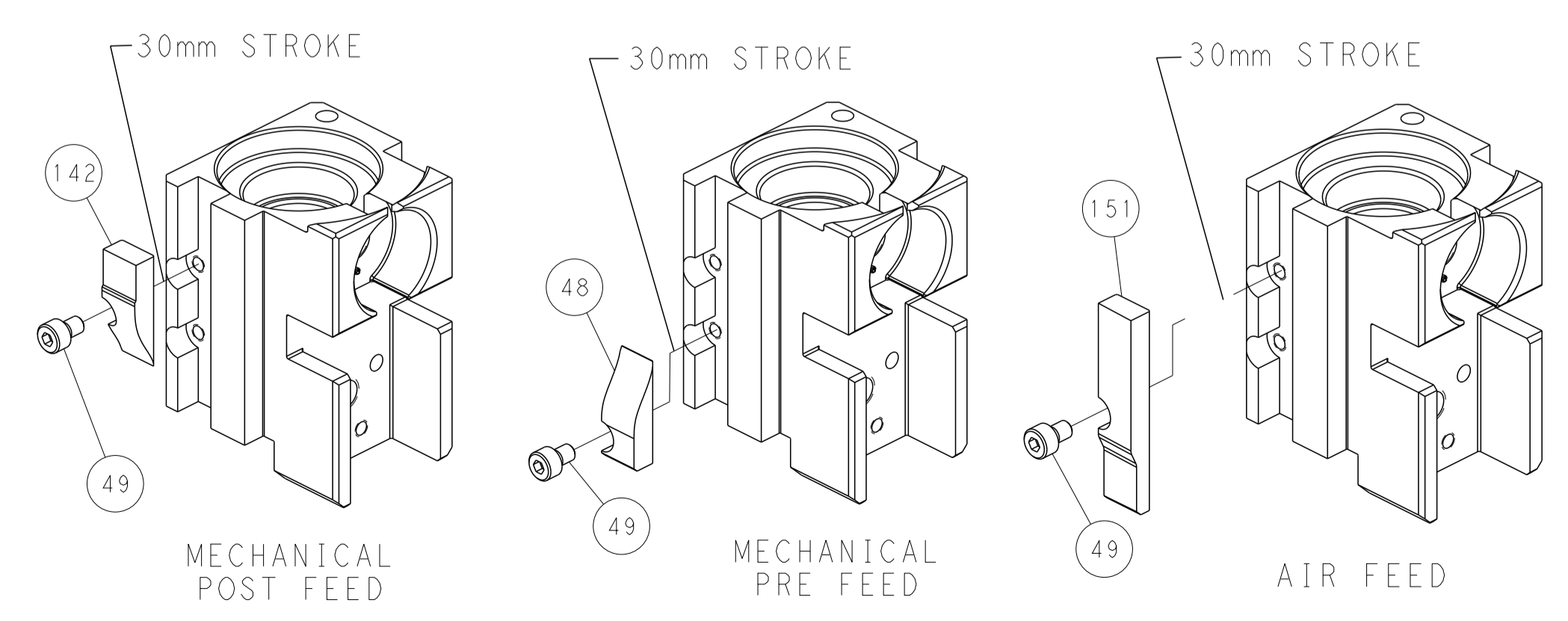
FEED TYPE MECHANICAL



PNEUMATIC



CAM POSITIONS



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: J.HOU 17OCT2014		REV: Y.YIN 17OCT2014		NAME: Ocean Side Feed Applicator	
mm	0 PLC	±		PRODUCT SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
	1 PLC	±		APPLICATION SPEC	A1	00779	2266514		
	2 PLC	±		WEIGHT	Customer Accessible Production Drawing		SCALE	1:2	SHEET 4 OF 4
	3 PLC	±							REV F
	4 PLC	±							
	ANGLES	±							
	FINISH								