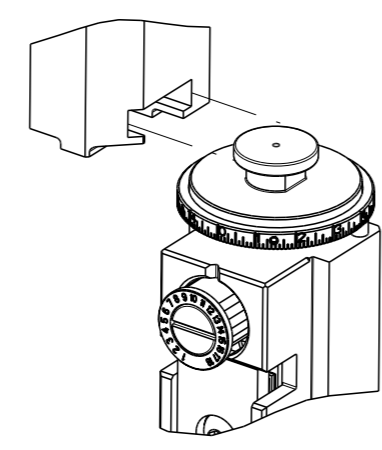


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266123-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266123-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266123-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266123-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266123-7	B	CRIMP TOOLING KIT	-
7-2266123-8	B	APPLICATOR CONVERSION KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.88 mm [.074]	F
INSUL	2.03 mm [.080]	O

APPLICATOR INSTRUCTIONS 408-35042

APPLICATOR CONVERSION KITS

PART NUMBER	INSULATION DIAMETER RANGE
7-2266121-8	∅2.74-3.18mm [.108-.125]
7-2266122-8	∅2.31-2.72mm [.091-.107]
7-2266123-8	∅1.91-2.29mm [.075-.090]

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION

TERMINAL NAME: STAMPED CONTACT PIN SIZE 20

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.81-5.09 mm [.150-.200 IN]	∅1.91-2.29 mm [.075-.090 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
2113369-1	1060-20-0622	2113369-2	1060-20-0644
2113369-3	1060-20-0677		

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION

TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.81-5.09 mm [.150-.200 IN]	∅1.91-2.29 mm [.075-.090 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
2113370-1	1062-20-0622	2113370-2	1062-20-0644
2113370-3	1062-20-0677		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.68+0.03/-0.05 [.066+.001/-0.002]	8.4
14 AWG	1.65+0.03/-0.05 [.065+.001/-0.002]	8.6
1.50mm2	1.60+0.03/-0.05 [.063+.001/-0.002]	8.9
16 AWG	1.55+0.03/-0.05 [.061+.001/-0.002]	9.3
1.00mm2	1.55+0.03/-0.05 [.061+.001/-0.002]	9.3

- 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. SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.
- 6. 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.

LOC	DIST	REV	DATE	BY	APPV
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		B2	25MAY2017	YY	KZ
		C	28FEB2020	FJ	TE

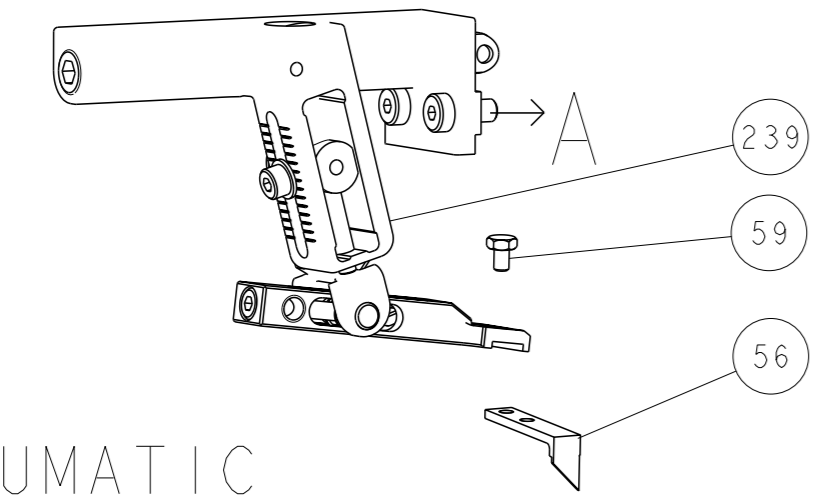
-	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	286
-	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 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	1-18028-2	WASHER, FLAT, REG M4	119
-	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	-	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	2266123	PRINT, APPLICATOR LOG SHEET	72
-	-	1	1	1	1	1803607-3	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	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	2-1752356-0	SUPPORT, TERMINAL	34
-	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	-	1	1	1	1	2844992-1	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
-	-	1	1	1	1	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	1	2	2	1	1	1-1803293-9	ANVIL, COMBINATION DEUTSCH STYLE	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1803019-6	CRIMPER, INSULATION O	3
-	-	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	-	1	2	2	1	4-1333281-8	CRIMPER, WIRE PREMIUM	1

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

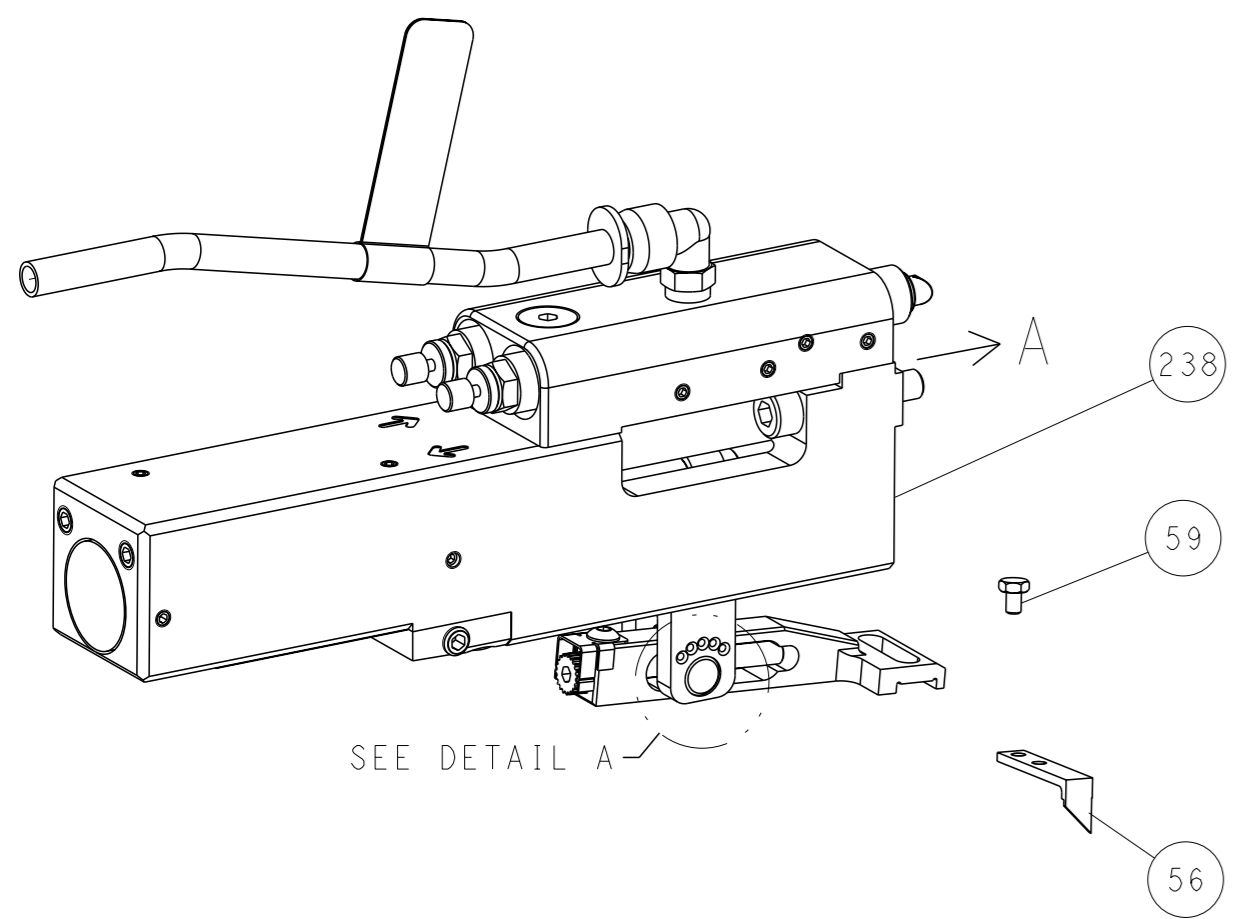
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LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

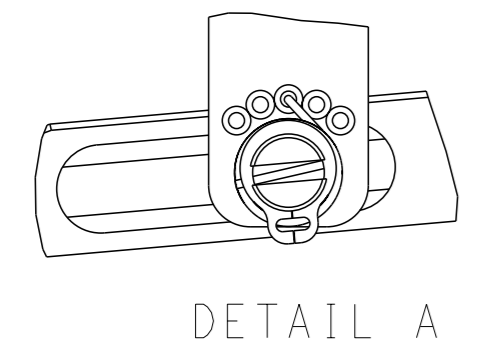
# FEED TYPE MECHANICAL



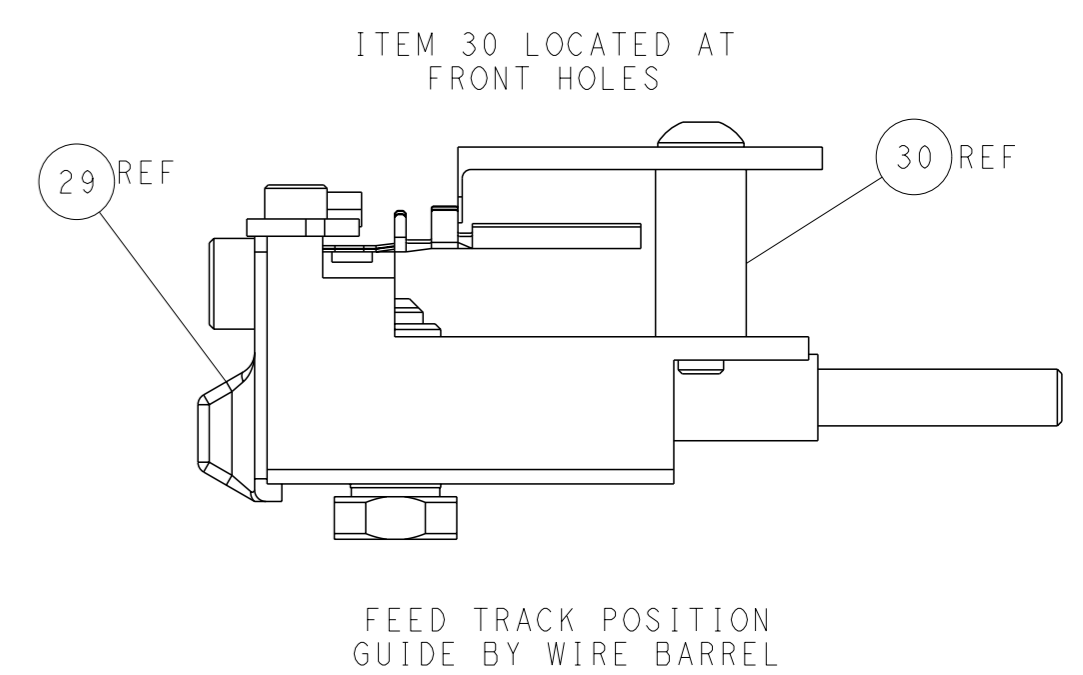
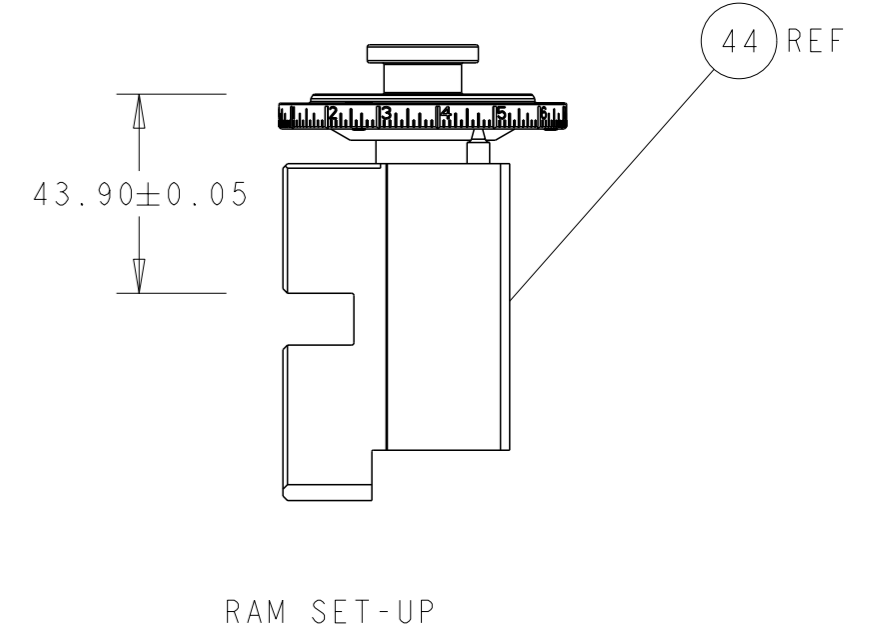
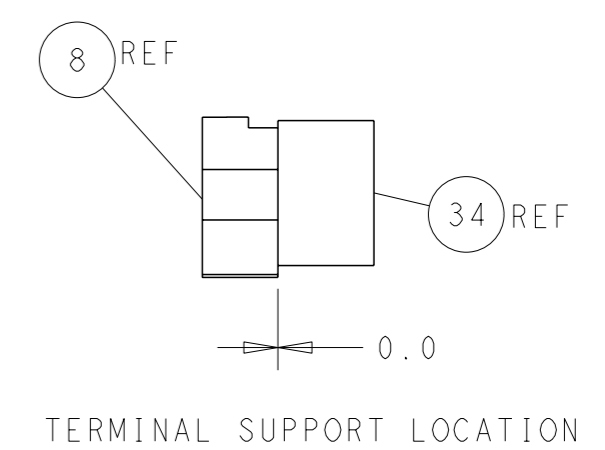
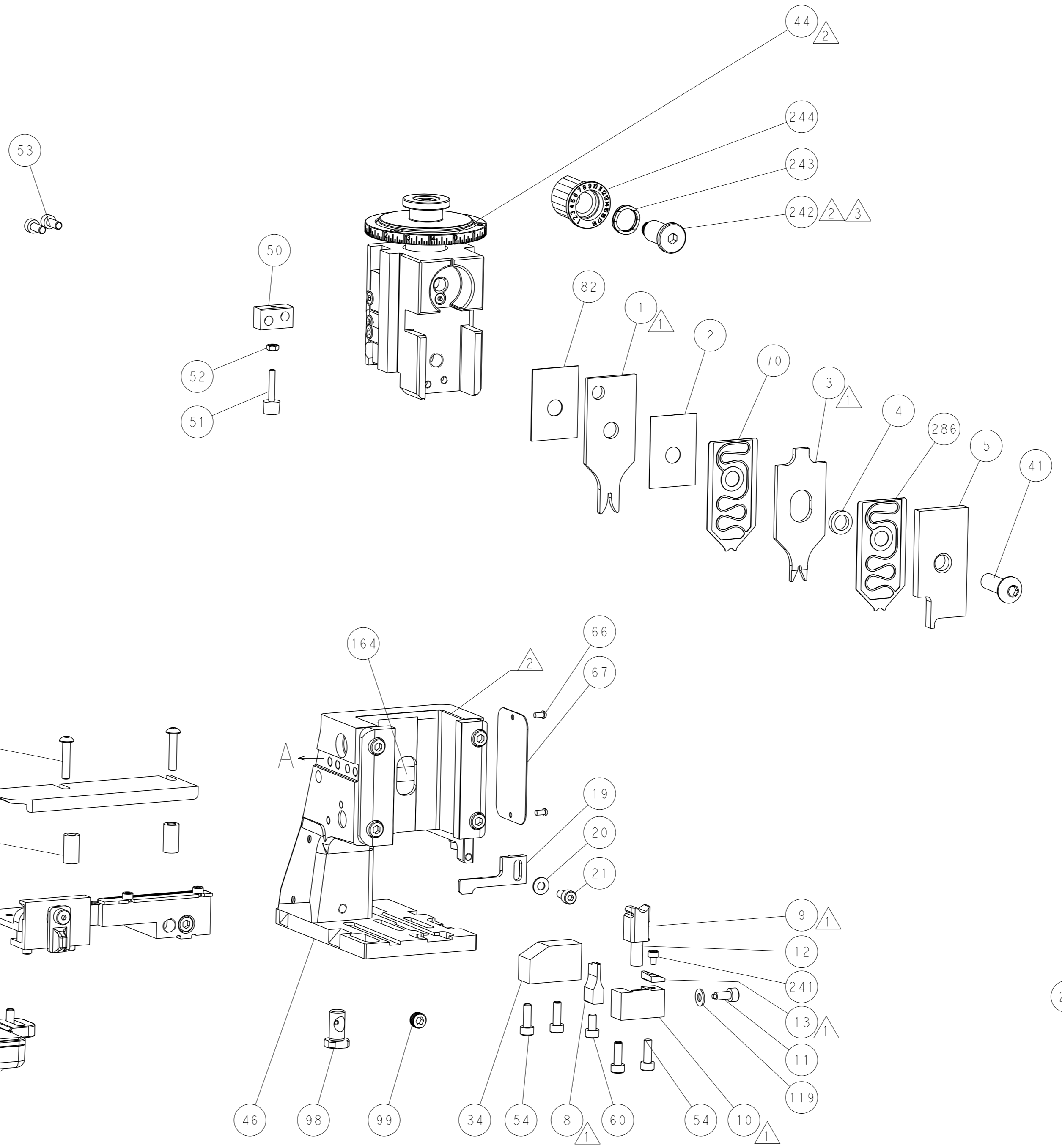
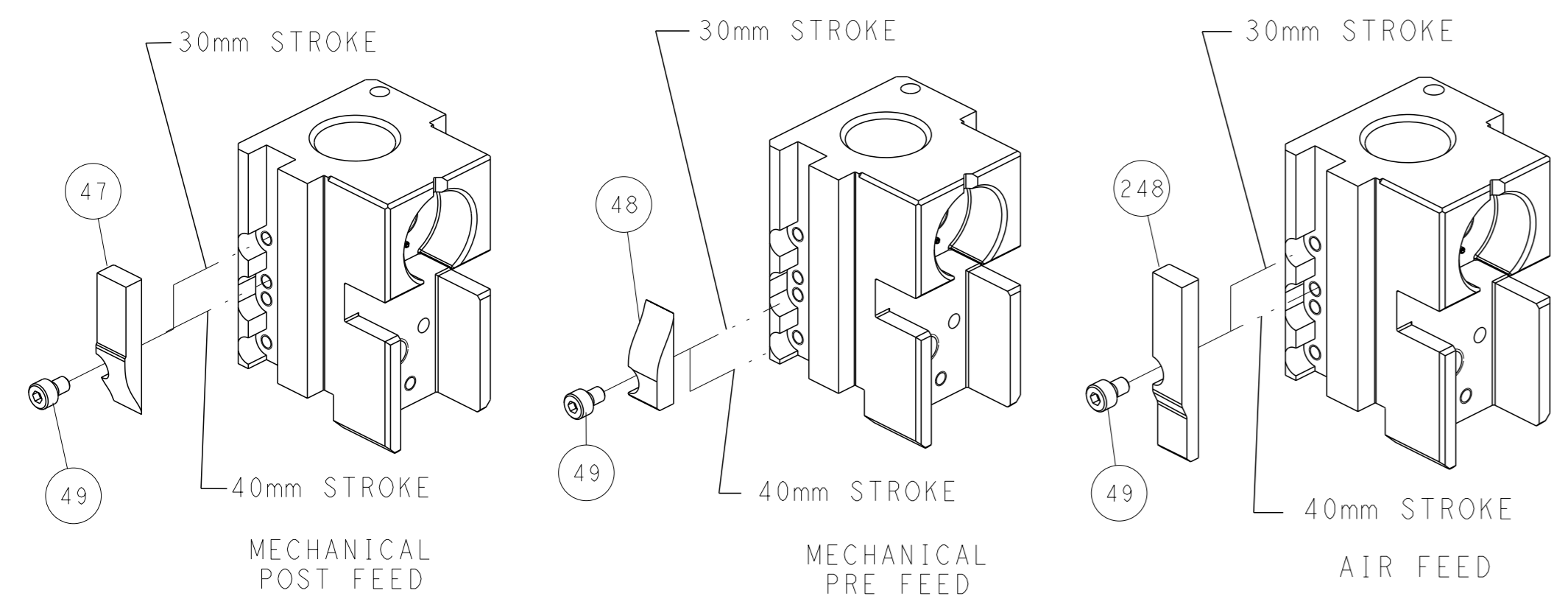
## PNEUMATIC



## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



# CAM POSITIONS

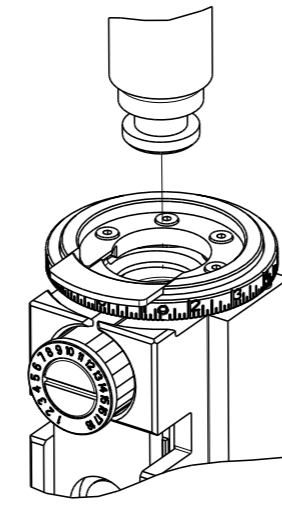


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. KNEPPER CHK: G. BAILEY APVD: M. CLIFFORD DATE: 30-Jan-14 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266123 SHEET: 2 of 4 REV: C	TE Connectivity Harrisburg, PA 17105-3608
--	--	--	--	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266123-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266123-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266123-7	B	CRIMP TOOLING KIT	-
7-2266123-8	B	APPLICATOR CONVERSION KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.88 mm [.074]	F
INSUL	2.03 mm [.080]	O

APPLICATOR INSTRUCTIONS  
408-35042

APPLICATOR CONVERSION KITS	
PART NUMBER	INSULATION DIAMETER RANGE
7-2266121-8	Ø2.74-3.18mm [.108-.125]
7-2266122-8	Ø2.31-2.72mm [.091-.107]
7-2266123-8	Ø1.91-2.29mm [.075-.090]

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT PIN SIZE 20			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TERMINAL APPLICATION SPECIFICATION	
3.81-5.09 mm [.150-.200 IN]	Ø1.91-2.29 mm [.075-.090 IN]	114-151003	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
2113369-1	1060-20-0622	2113369-2	1060-20-0644
2113369-3	1060-20-0677		

TERMINAL DATA: DEUTSCH TERMINAL DEUTSCH CRIMP SPECIFICATION			
TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TERMINAL APPLICATION SPECIFICATION	
3.81-5.09 mm [.150-.200 IN]	Ø1.91-2.29 mm [.075-.090 IN]	114-151003	-
TERMINALS APPLIED			
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL	DEUTSCH TERMINAL
2113370-1	1062-20-0622	2113370-2	1062-20-0644
2113370-3	1062-20-0677		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.68+0.03/-0.05 [.066+.001/-0.002]	8.4
14 AWG	1.65+0.03/-0.05 [.065+.001/-0.002]	8.6
1.50mm2	1.60+0.03/-0.05 [.063+.001/-0.002]	8.9
16 AWG	1.55+0.03/-0.05 [.061+.001/-0.002]	9.3
1.00mm2	1.55+0.03/-0.05 [.061+.001/-0.002]	9.3



- △ 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.
- △ 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	APPV
A	66				

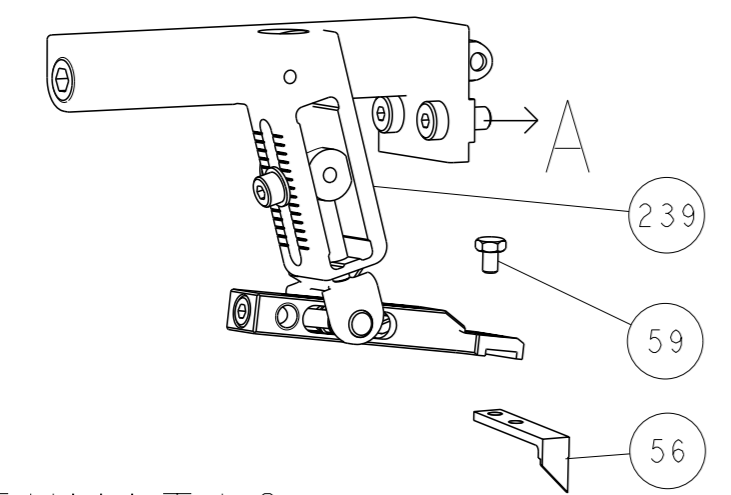
QTY	REF	DESCRIPTION	DATE	OWN	APPV
-	-	1 1	2119791-9	DEPRESSOR, WIRE	286
-	-	1 1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	-	1 1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1 1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	- 1	2119580-1	MECHANICAL 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	455888-6	SPACER, CRIMPER	82
-	-	1 1	2266123	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	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	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	1803095-6	FLOATING SHEAR, FRONT	9
△	1	1 1 1	1-1803293-9	ANVIL, COMBINATION DEUTSCH STYLE	8
-	-	- -	-	-	7
-	-	- -	-	-	6
-	-	1 1	2119757-8	DEPRESSOR, SHEAR	5
-	-	1 1	238011-9	BLOCK, CRIMPER SPACER	4
△	1	1 1 1	1803019-6	CRIMPER, INSULATION O	3
-	-	1 1	455888-3	SPACER, CRIMPER	2
△	-	1 1 1	4-1333281-8	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL		WEIGHT			

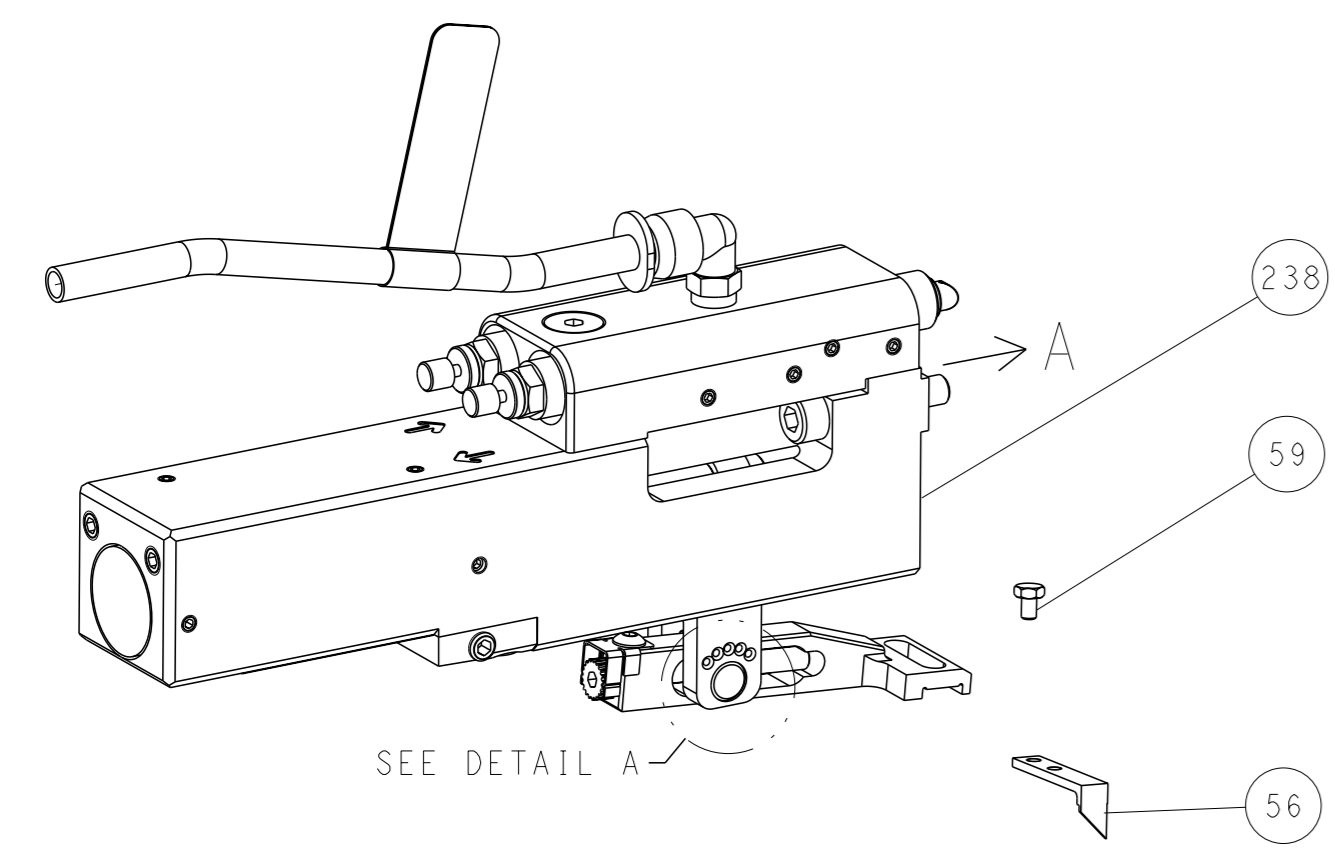
OWN	R. KNEPPER	30-Jan-14
CHK	G. BAILEY	30-Jan-14
APPV	M. CLIFFORD	30-Jan-14
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266123
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 3 of 4

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

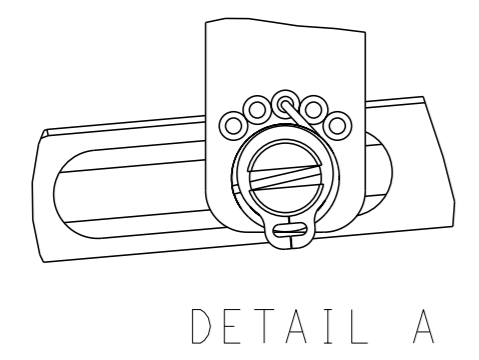
# FEED TYPE MECHANICAL



## PNEUMATIC

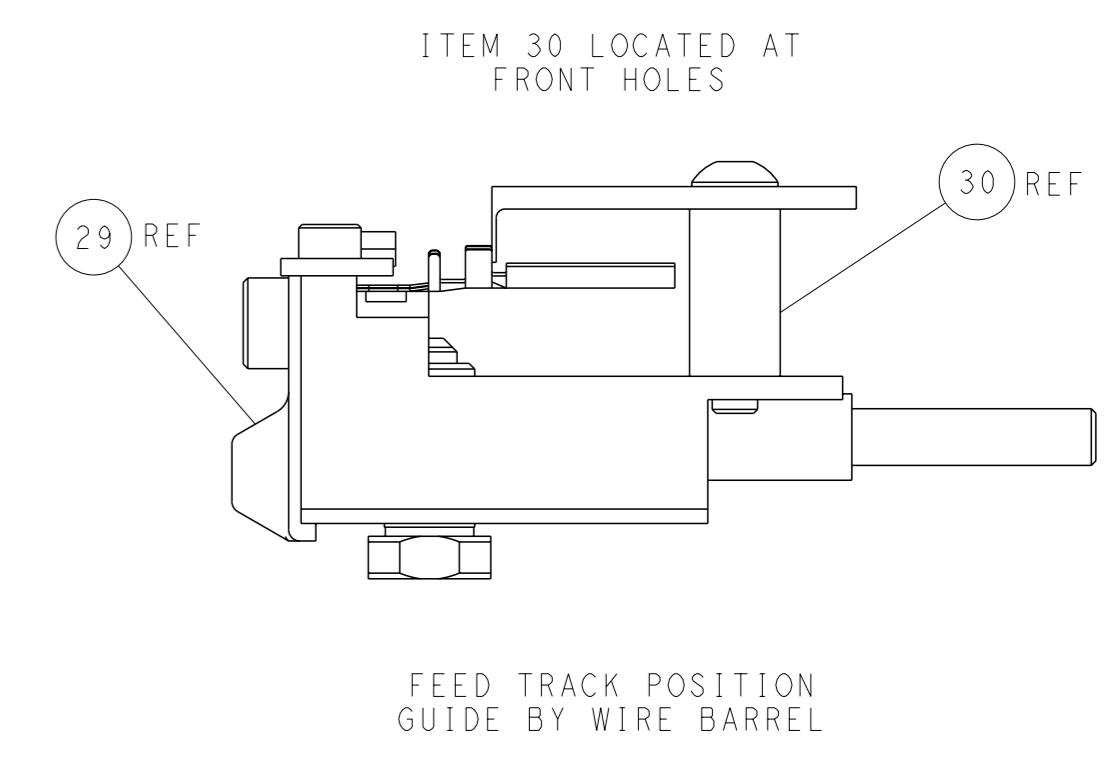
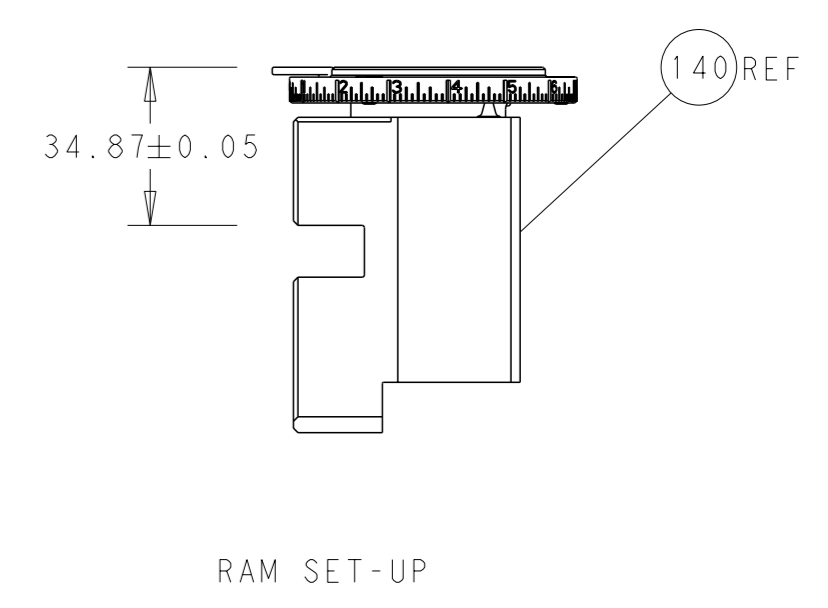
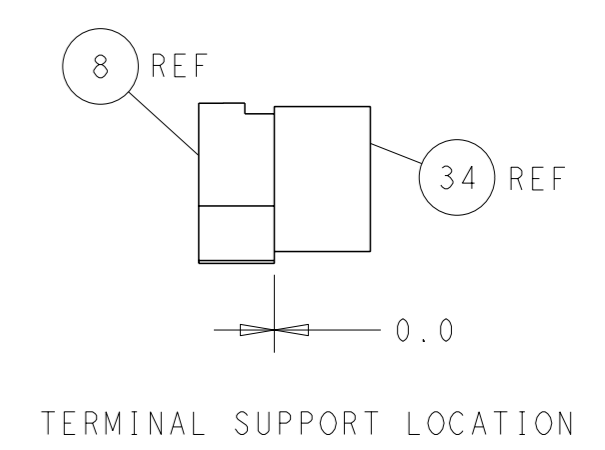
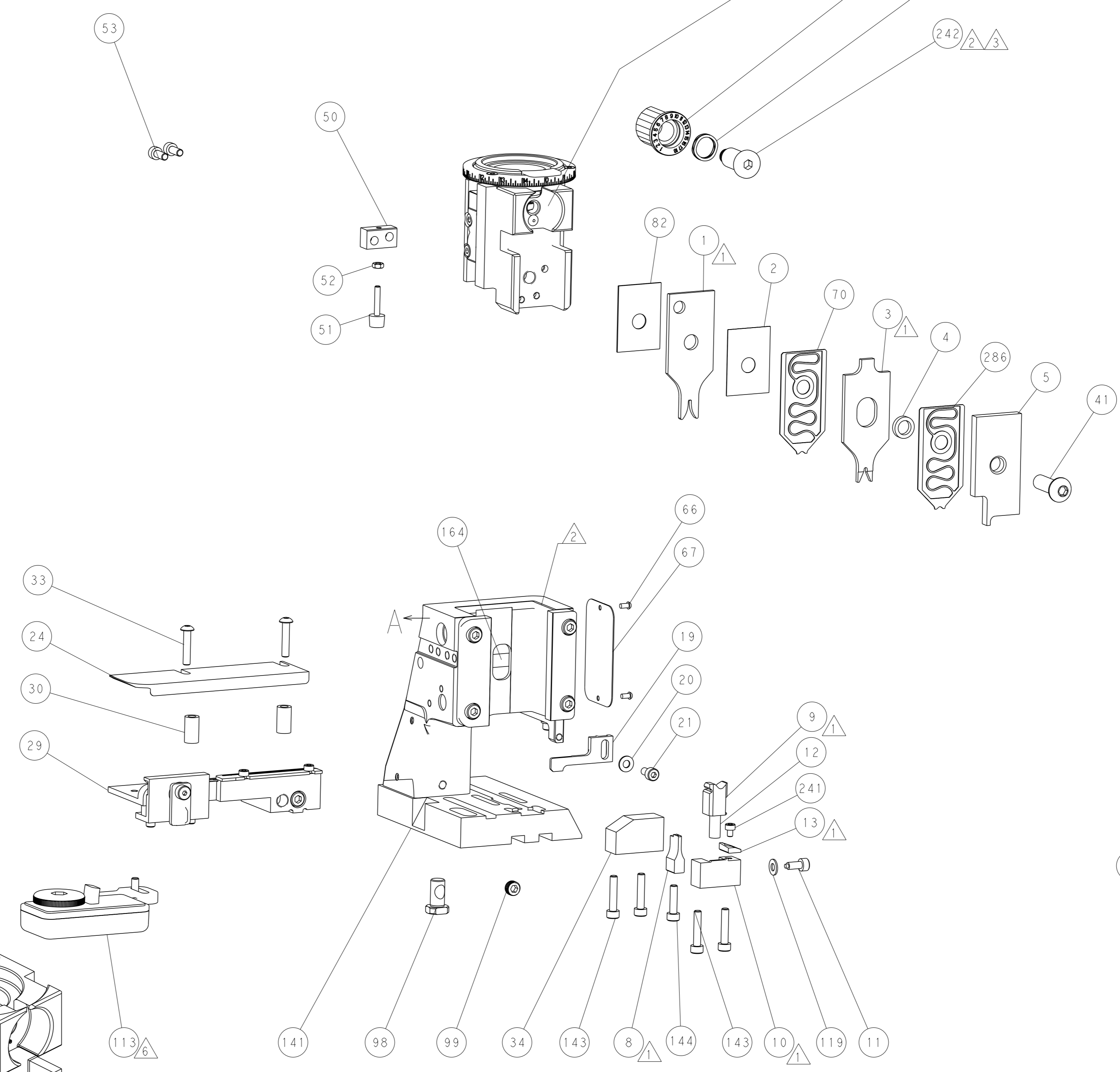
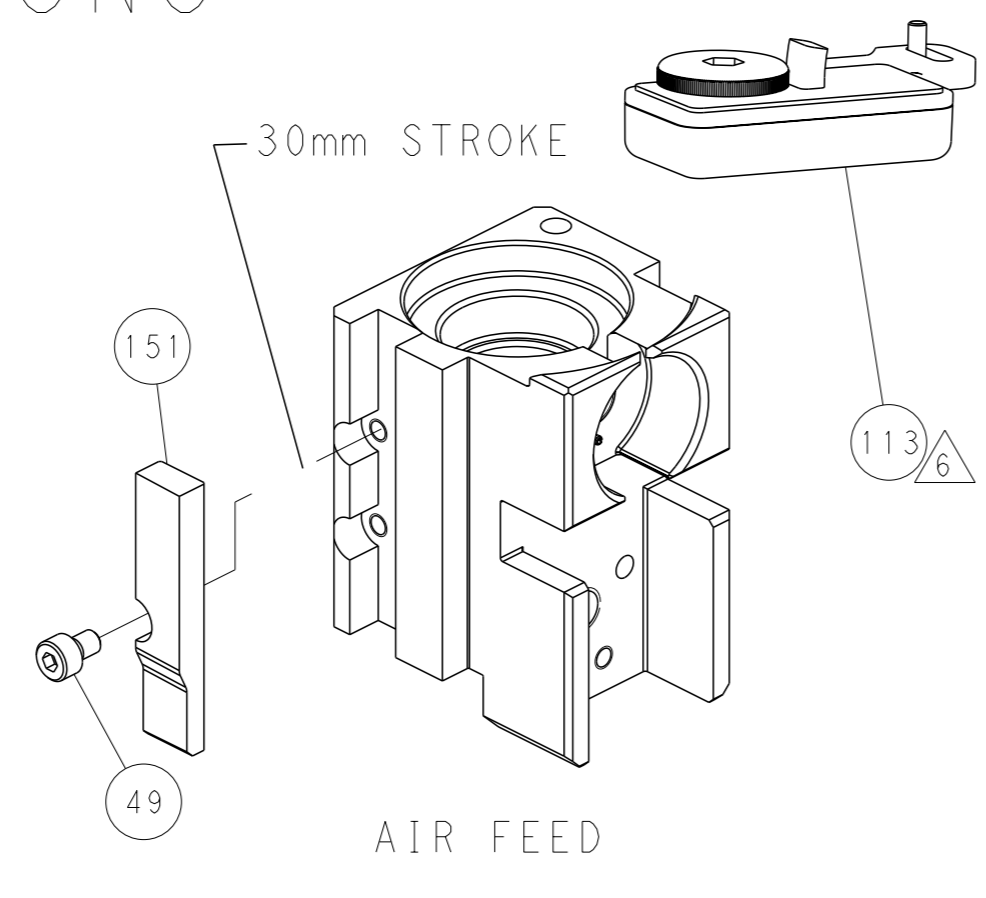
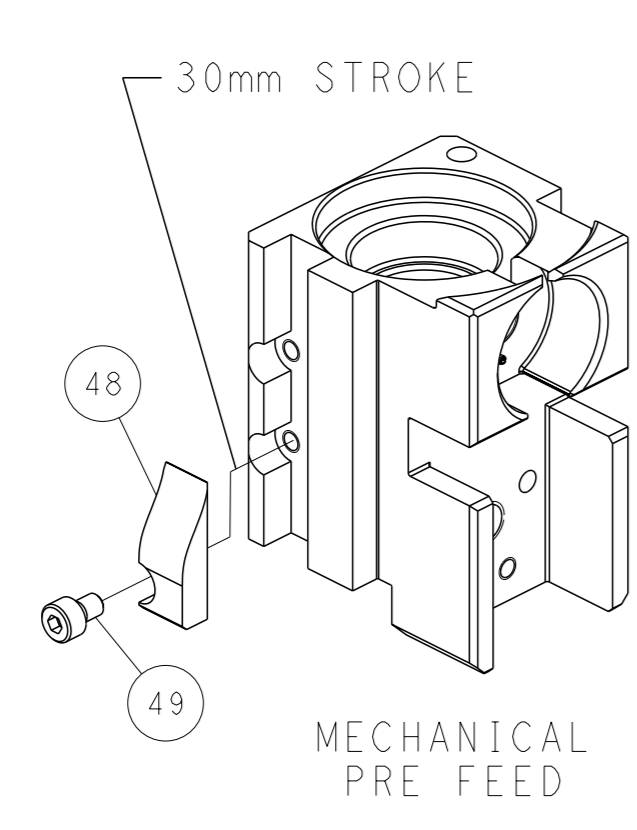
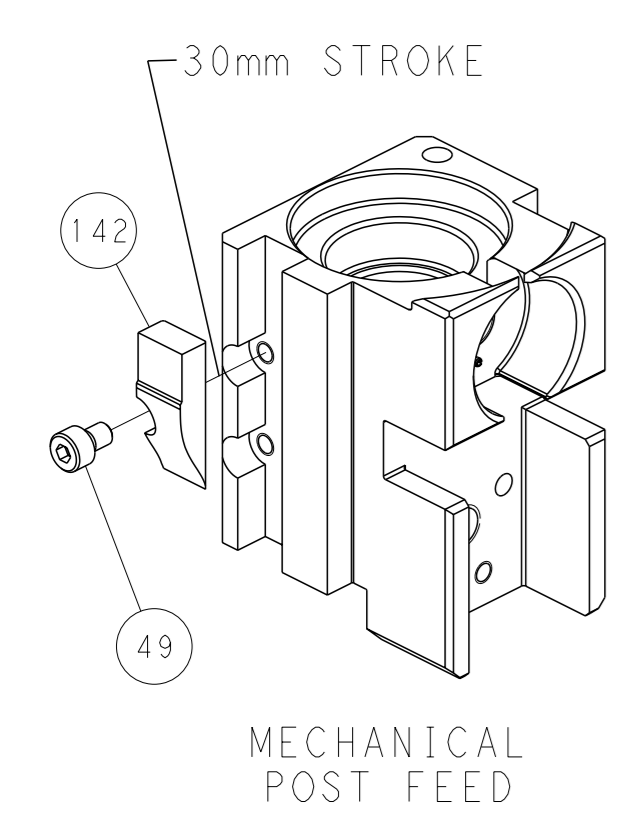


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

# 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 USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. KNEPPER CHK: G. BAILEY APVD: M. CLIFFORD	DATE: 30-Jan-14 DATE: 30-Jan-14 DATE: 30-Jan-14	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266123	RESTRICTED TO: - SHEET: 4 of 4 REV: C	CUSTOMER ACCESSIBLE PRODUCTION DRAWING