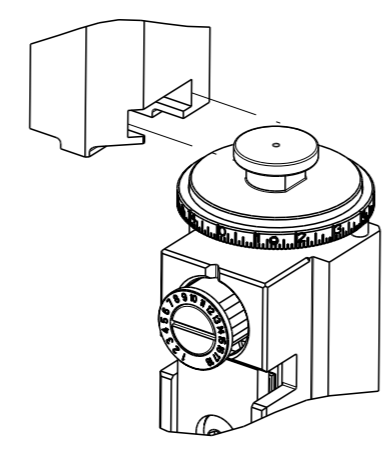


THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20  
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266572-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266572-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266572-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266572-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266572-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266572-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266572-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.54 mm [.061]	F
INSUL	3.40 mm [.134]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: MX150 CABLE SEAL TERMINAL

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
4.70-5.60 mm [.185-.220 IN]	Ø1.50-1.70 mm [.059-.067 IN]

TERMINAL APPLICATION SPECIFICATION: ATS639018200 Rev B

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE SEAL	MOLEX SEAL	SEAL INSULATION DIAMETER RANGE
1949235-1	34081-3005	2113614-1	E-1644-01	1.4-1.7 mm
1949235-2	34083-3003			
1949235-3	34081-5003			
1949235-4	FORD 7C3T-14474-RA			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.10+/-0.05 [.043+/-0.002]	6.8
TXL 22 AWG	1.00+/-0.05 [.039+/-0.002]	7.7

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 7. 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.

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

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66	A	RELEASED	31DEC2014	MR	GB
		B	ECR-19-012035	31JUL2019	FZ	TE
		C	ECR-20-015218	17DEC2020	TB	RR

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
3	-	-	1	1	-	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
1	-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
5	-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	3-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	3-1803056-2	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	2-240641-8	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	2-1633965-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	2	2	1	1	1	1	8-1633738-2	CRIMPER, WIRE	1

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-2	-1		

OWN	H. HUANG	13NOV2014
CHK	L. ZHANG	13NOV2014
APVD	J. GUO	13NOV2014

TE Connectivity  
 Harrisburg, PA 17105-3608

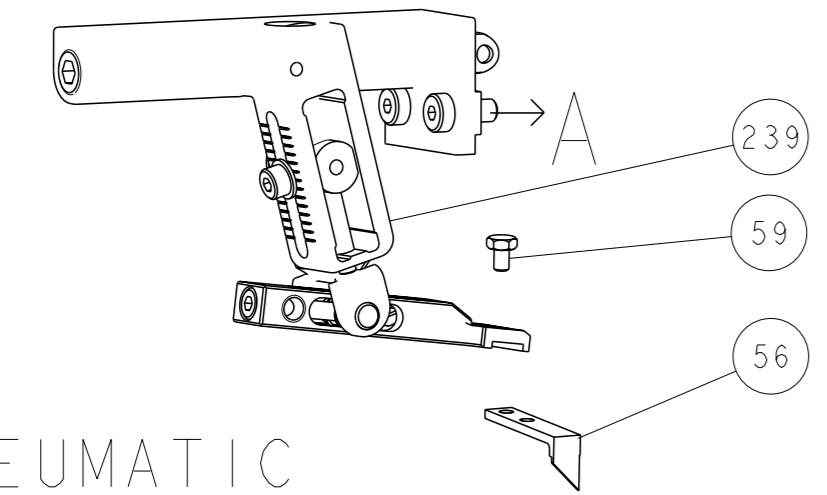
Ocean Side Feed  
 Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266572

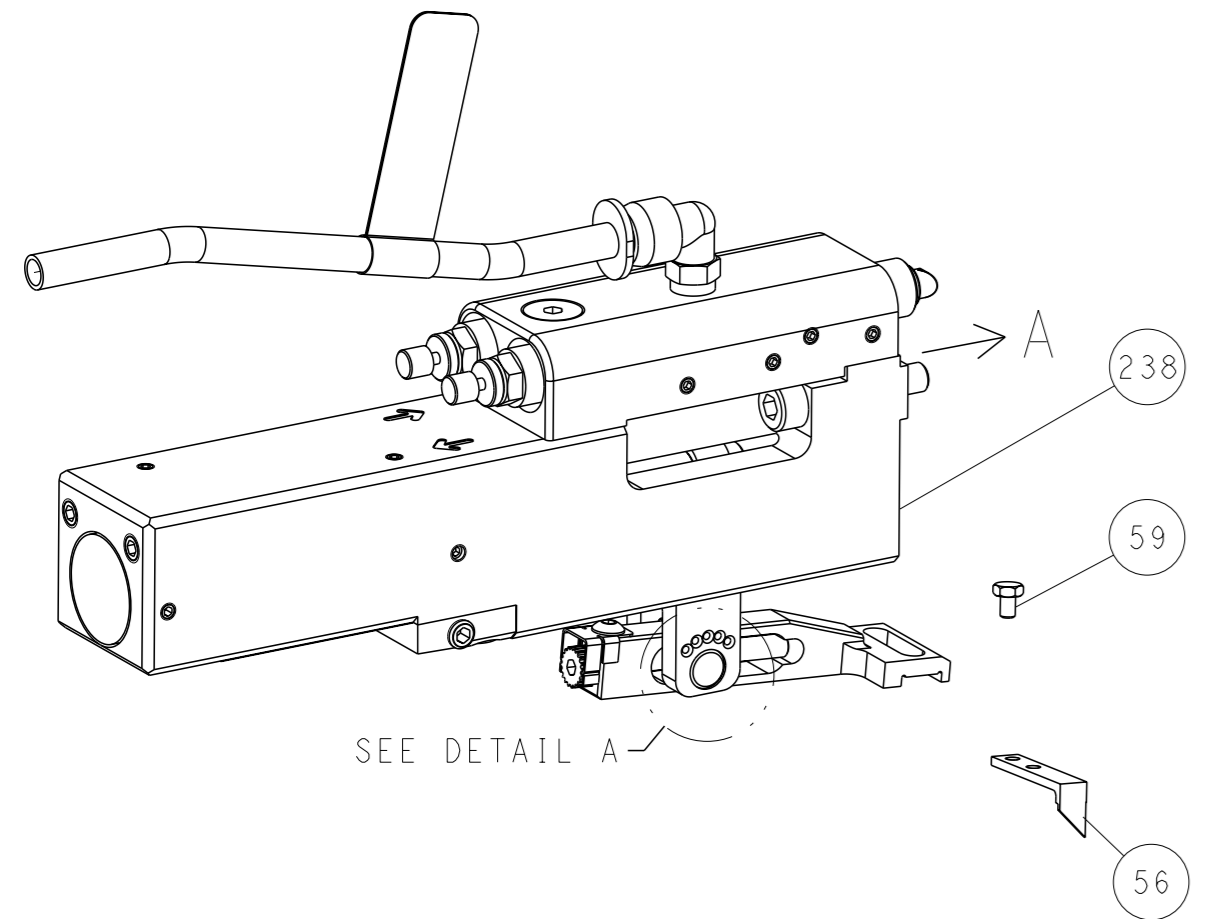
Customer Accessible Production Drawing SCALE: 1:2 SHEET: 1 OF 4 REV: C

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

# FEED TYPE MECHANICAL



## PNEUMATIC

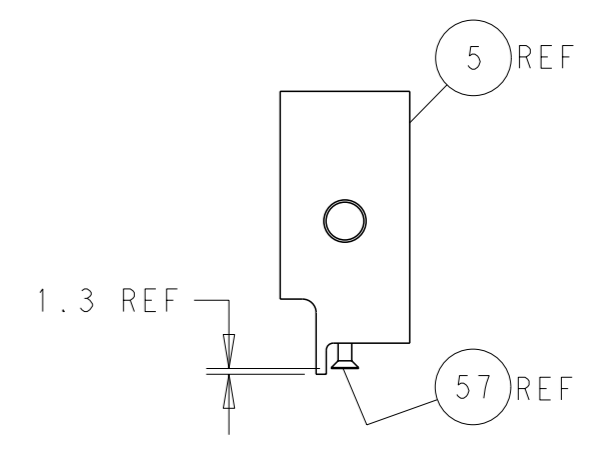
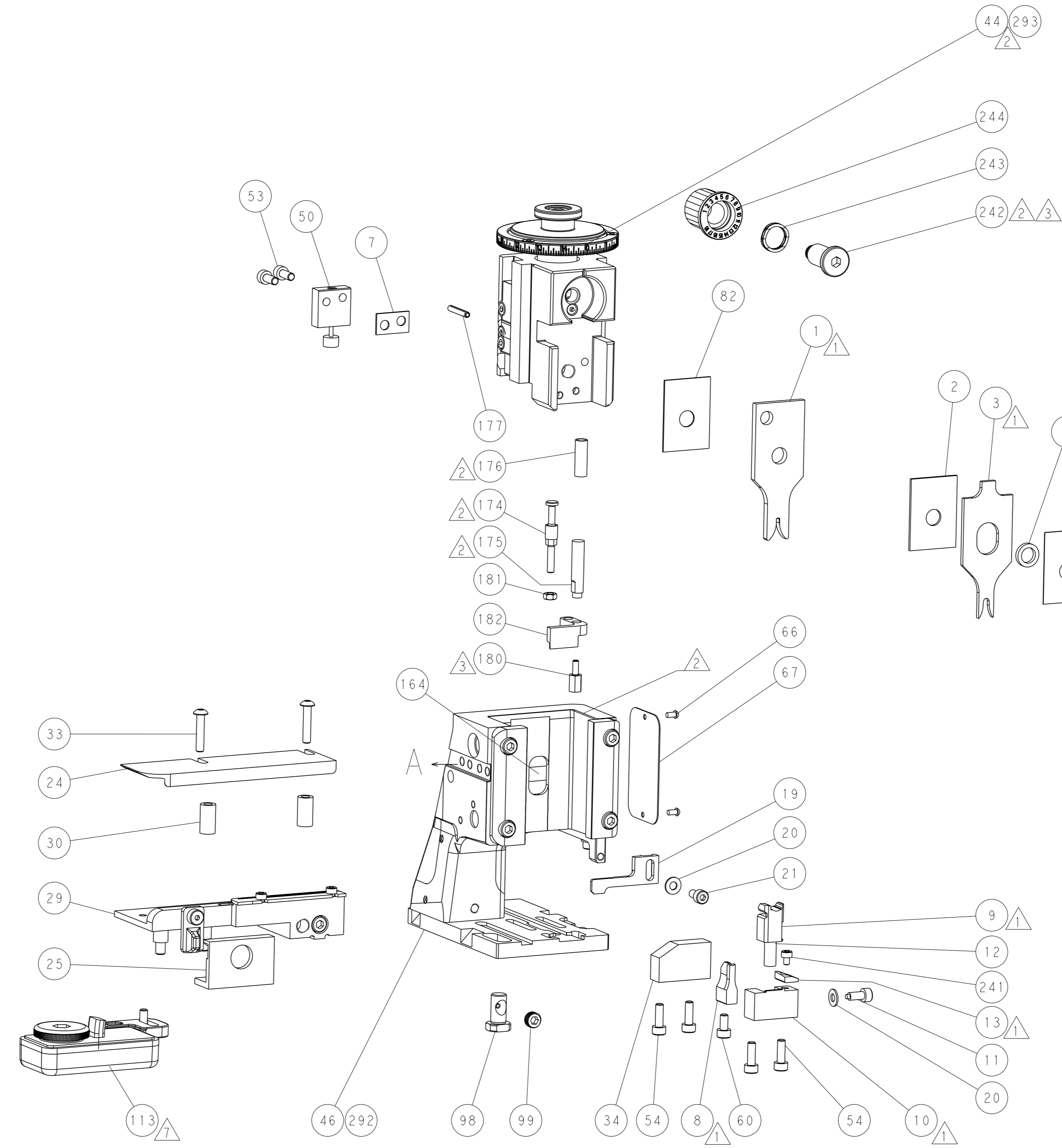
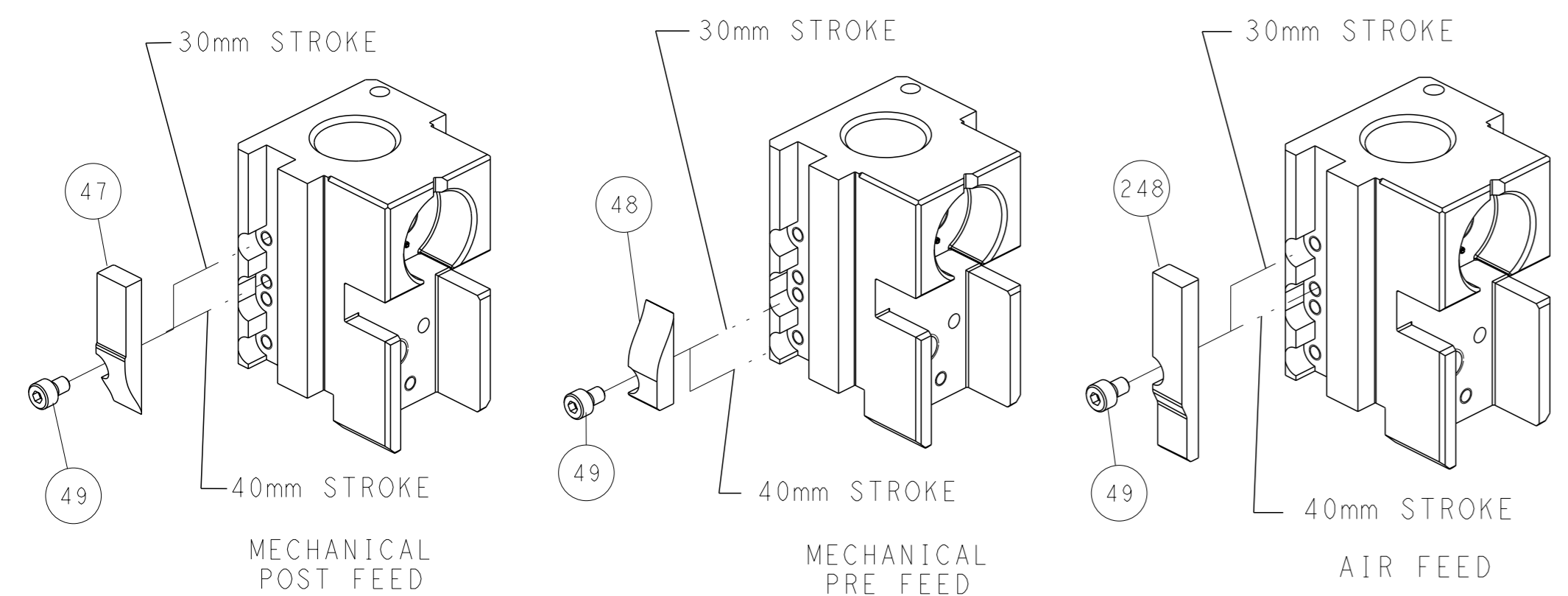


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

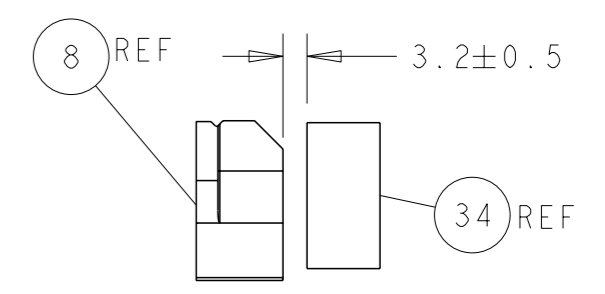


DETAIL A

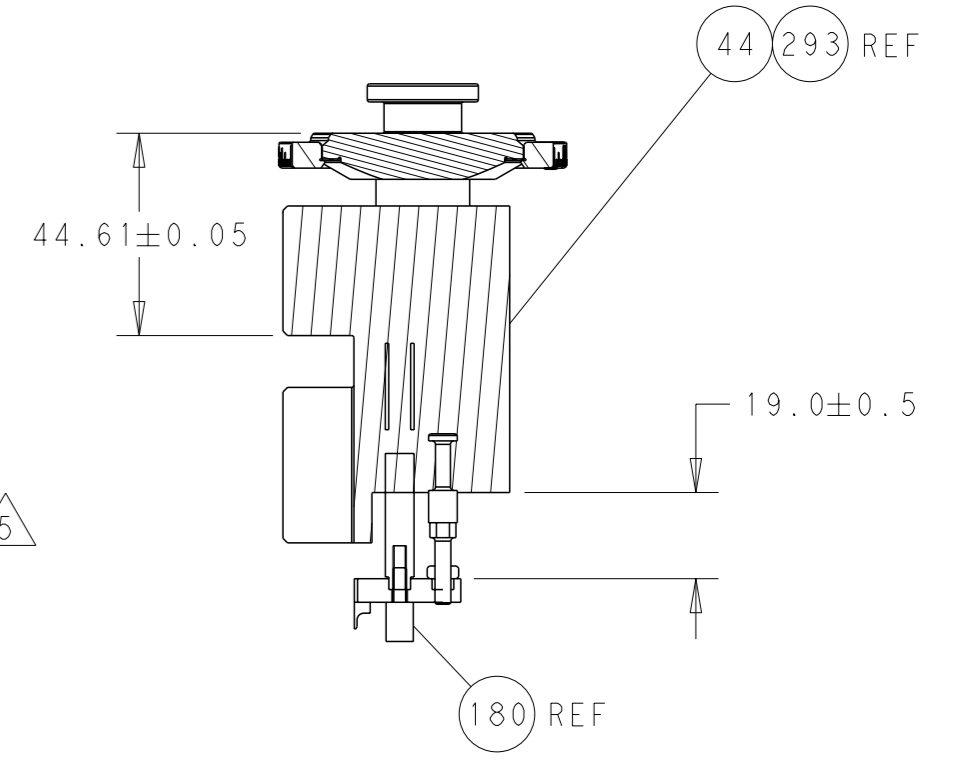
# CAM POSITIONS



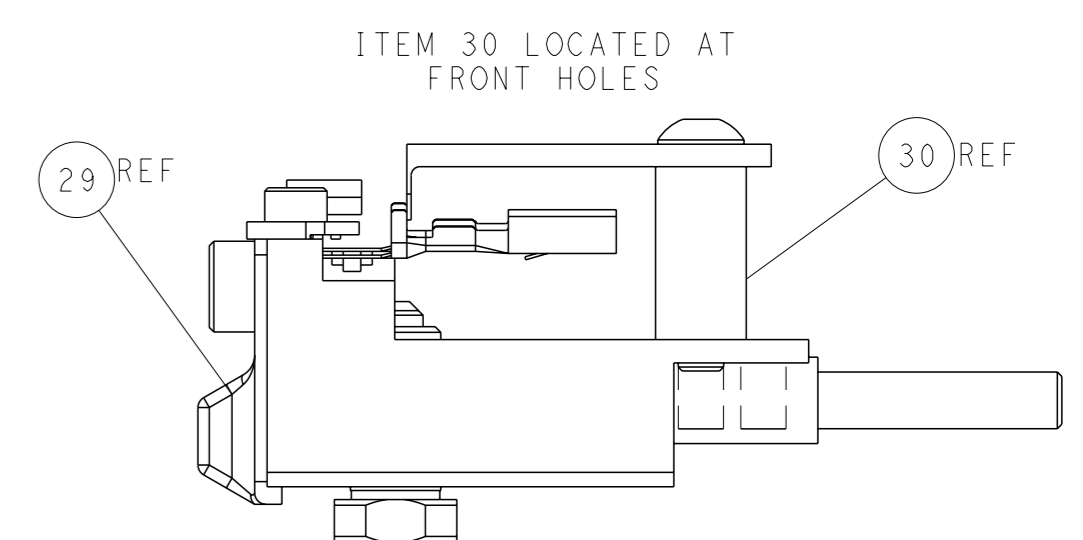
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



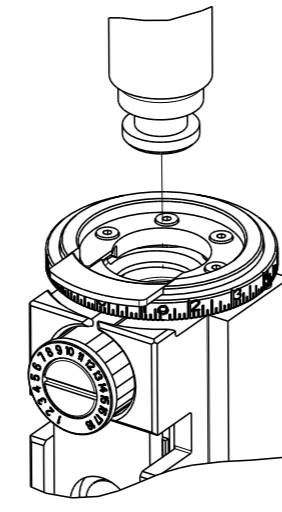
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN H. HUANG 13NOV2014 CHK L. ZHANG 13NOV2014 APVD U. GUO 13NOV2014 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2266572 RESTRICTED TO	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2		SHEET 2 OF 4 REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266572-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266572-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266572-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.54 mm [.061]	F
INSUL	3.40 mm [.134]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: MX150 CABLE SEAL TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.70-5.60 mm [.185-.220 IN]		Ø1.50-1.70 mm [.059-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS639018200 Rev B		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	MOLEX TERMINAL	TE SEAL	MOLEX SEAL	
1949235-1	34081-3005	2113614-1	E-1644-01	1.4-1.7 mm
1949235-2	34083-3003			
1949235-3	34081-5003			
1949235-4	FORD 7C3T-14474-RA			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.10+/-0.05 [.043+/-0.002]	6.8
TXL 22 AWG	1.00+/-0.05 [.039+/-0.002]	7.7

- 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 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7. 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.

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

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

-	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	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	1	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
1	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	1	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	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	1	1338685-1	PAWL, FEED	56
-	2	2	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	3-1752356-4	SUPPORT, TERMINAL	34
-	2	2	1	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	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	3-1803056-2	ANVIL, COMBINATION	8
-	1	1	1	2-240641-8	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-1633965-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	1	1	8-1633738-2	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	ANGLES	FINISH					
MATERIAL		WEIGHT		SCALE		SHEET	
				1:2		3 of 4	

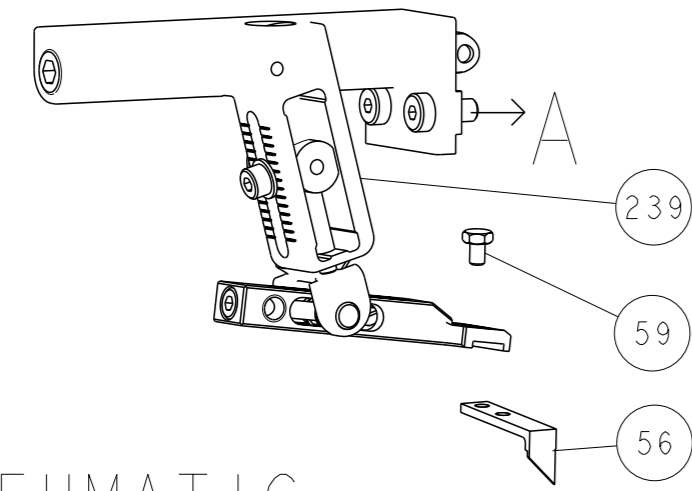


Ocean Side Feed  
Applicator

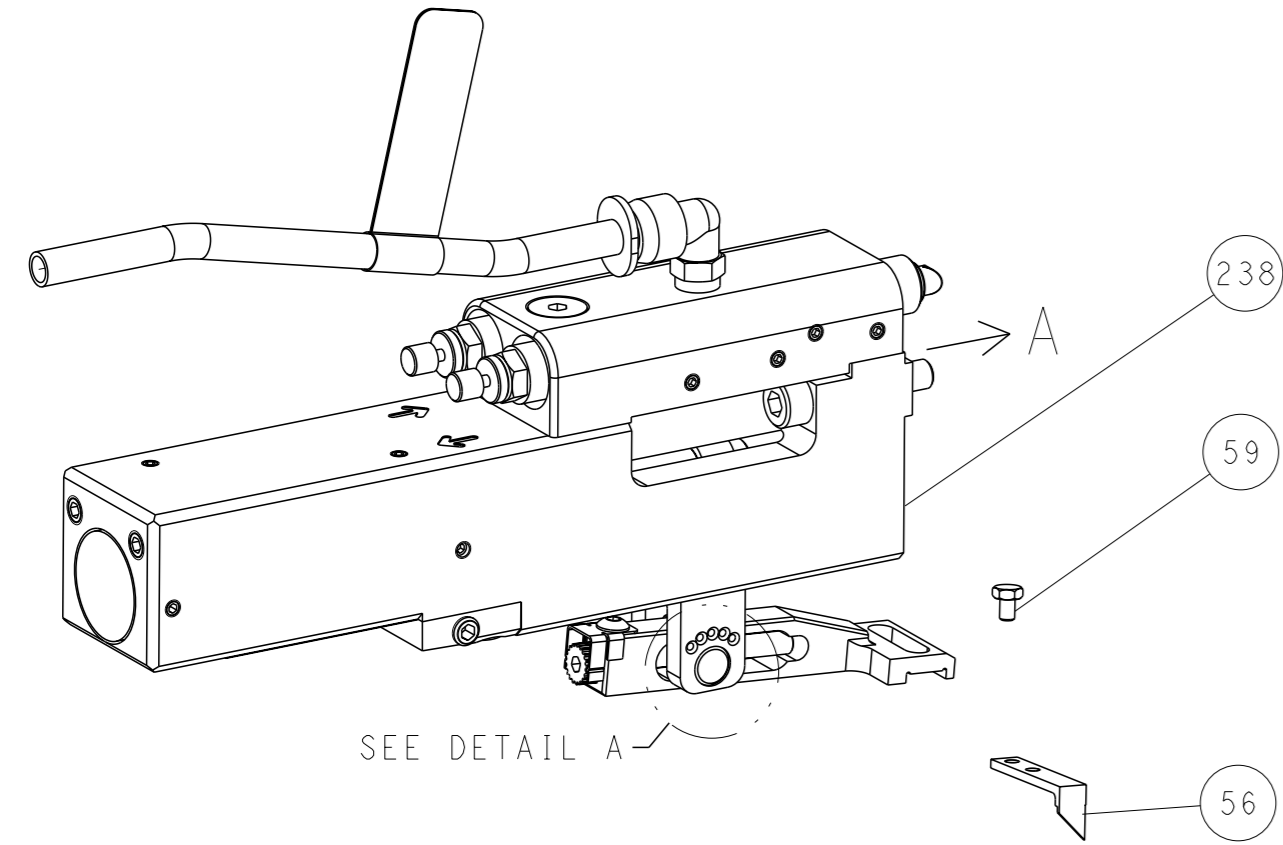
Customer Accessible Production Drawing

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

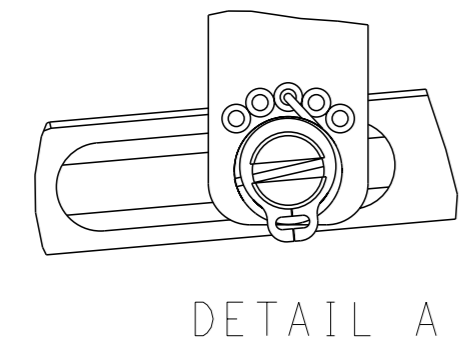
# FEED TYPE MECHANICAL



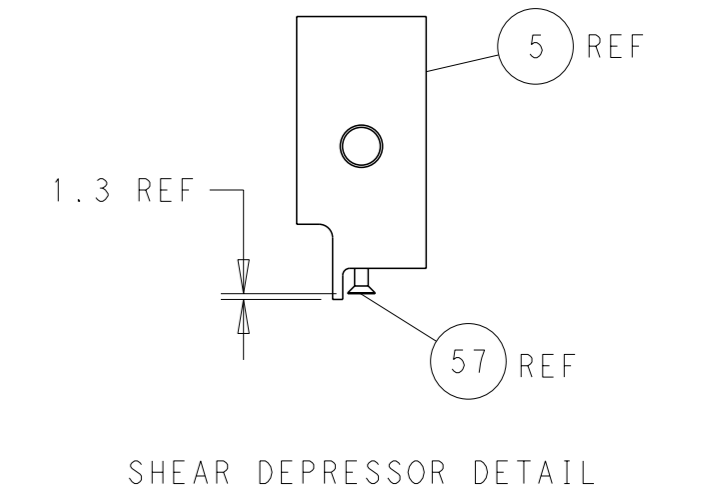
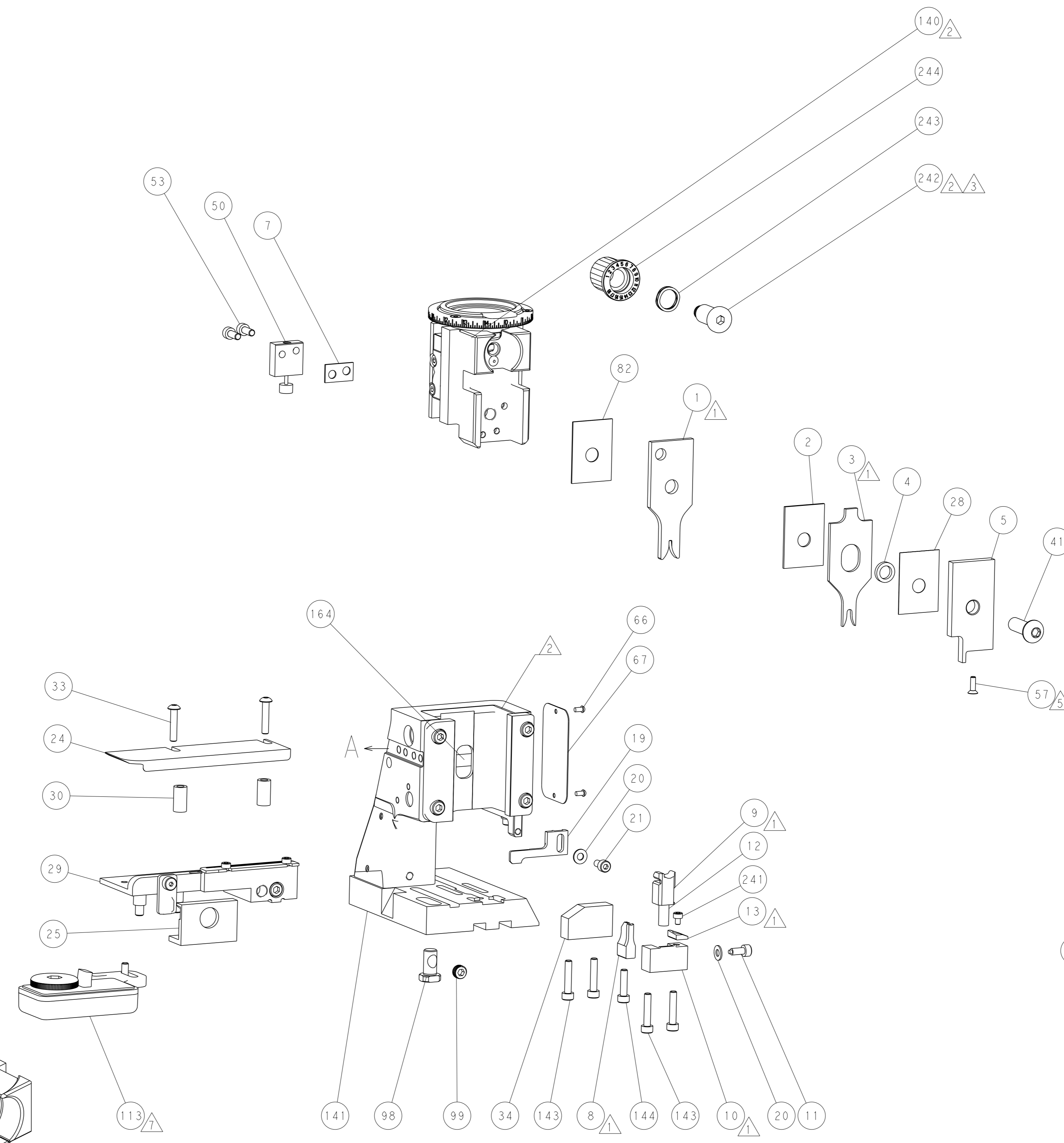
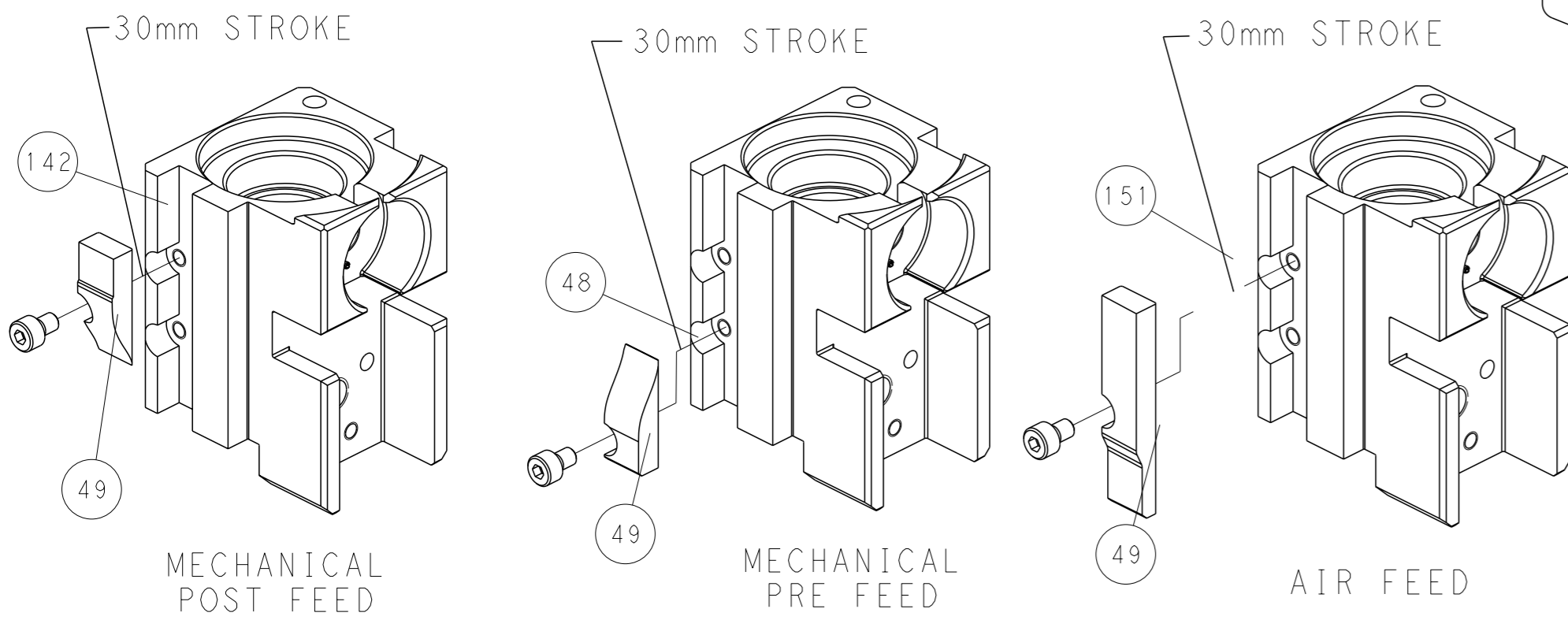
## PNEUMATIC



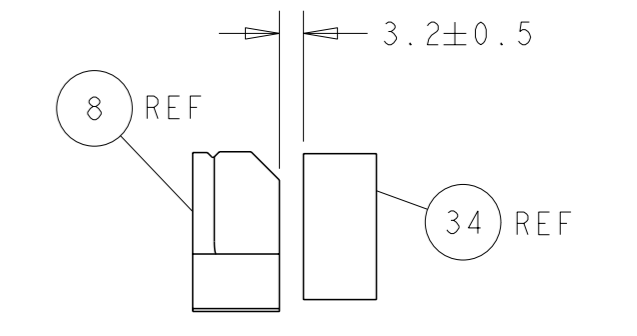
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



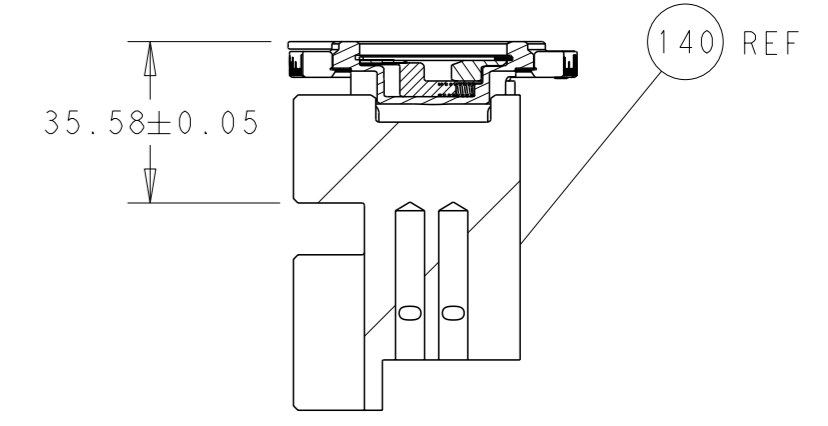
## CAM POSITIONS



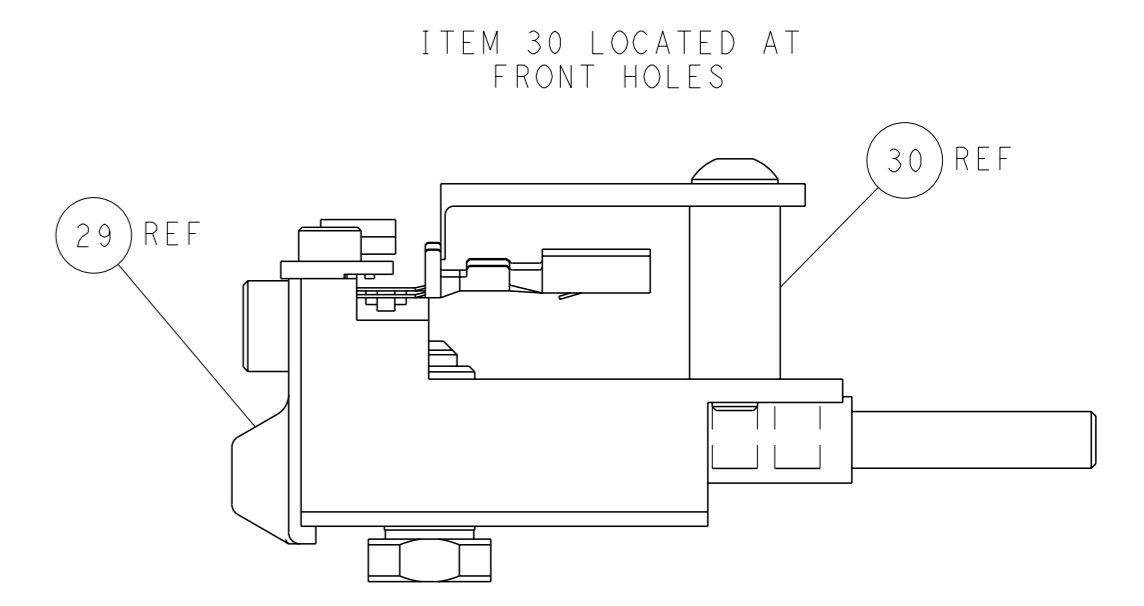
SHEAR DEPRESSOR DETAIL



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)

<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>		DWN: H. HUANG 13NOV2014 CHK: L. ZHANG 13NOV2014 APVD: J. GUO 13NOV2014	TE Connectivity Harrisburg, PA 17105-3608
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: - MATERIAL: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266572 SCALE: 1:2 SHEET: 4 of 4 REV: C
AMP 4805 REV 31MAR2000		Customer Accessible Production Drawing	