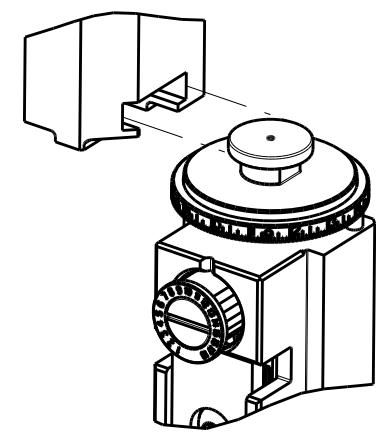


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266342-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266342-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266342-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266342-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266342-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.54 mm [.100]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN, UNIVERSAL MATE-N-LOK			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.96-4.75 mm [.156-.187 IN]	Ø1.02-2.54 mm [.040-.100 IN]		
TERMINAL APPLICATION SPECIFICATION (A)114-1010			

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 61115-1	(C) 61314-1	(B) 350560-1	(A) 350570-7
(C) 61116-1	(C) 61314-2	(B) 350561-1	(A) 350699-1
(C) 61116-2	(C) 61314-3	(B) 350561-2	(A) 350699-2
(C) 61116-3	(C) 61314-4	(B) 350561-3	(A) 350699-3
(C) 61116-4	(C) 61314-5	(B) 350561-5	(A) 350699-5
(C) 61116-5	(C) 61314-6	(B) 350561-7	(A) 350699-7
(C) 61116-6	(C) 61314-7	(B) 350561-8	(A) 350699-8
(C) 61116-7	(C) 61314-8	(A) 350570-1	(A) 350851-1
(C) 61116-8	(C) 61527-2	(A) 350570-2	(A) 350851-2
(C) 61116-9	(C) 170147-1	(A) 350570-3	(A) 350851-7
(C) 1-61116-3	(C) 170147-2	(A) 350570-6	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.22+/-0.05 [.048+/-0.002]	6.1
20 AWG	1.09+/-0.05 [.043+/-0.002]	7.7
22 AWG	1.02+/-0.05 [.040+/-0.002]	8.4
24 AWG	0.96+/-0.05 [.038+/-0.002]	8.8

- 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.
- 6. 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	REVISIONS			
A	66	REV	DATE	BY	APPD
		A1	19JUN2014	RK	GB
		C	04JUN2019	FZ	CT
		D	05JUN2019	TB	CT
		E	10AUG2020	FJ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	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	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	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
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	1752356-3	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	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1338692-1	ANVIL, COMBINATION .070	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2-1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	2	1	1-456404-8	CRIMPER, WIRE PREMIUM	1

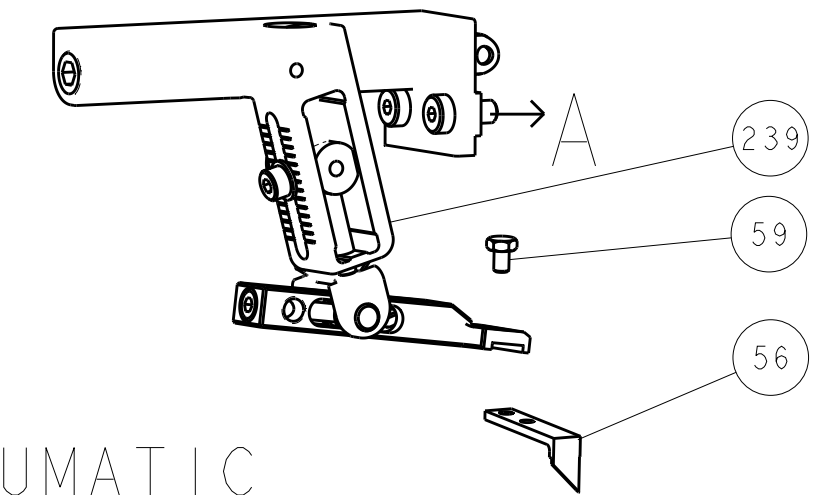
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

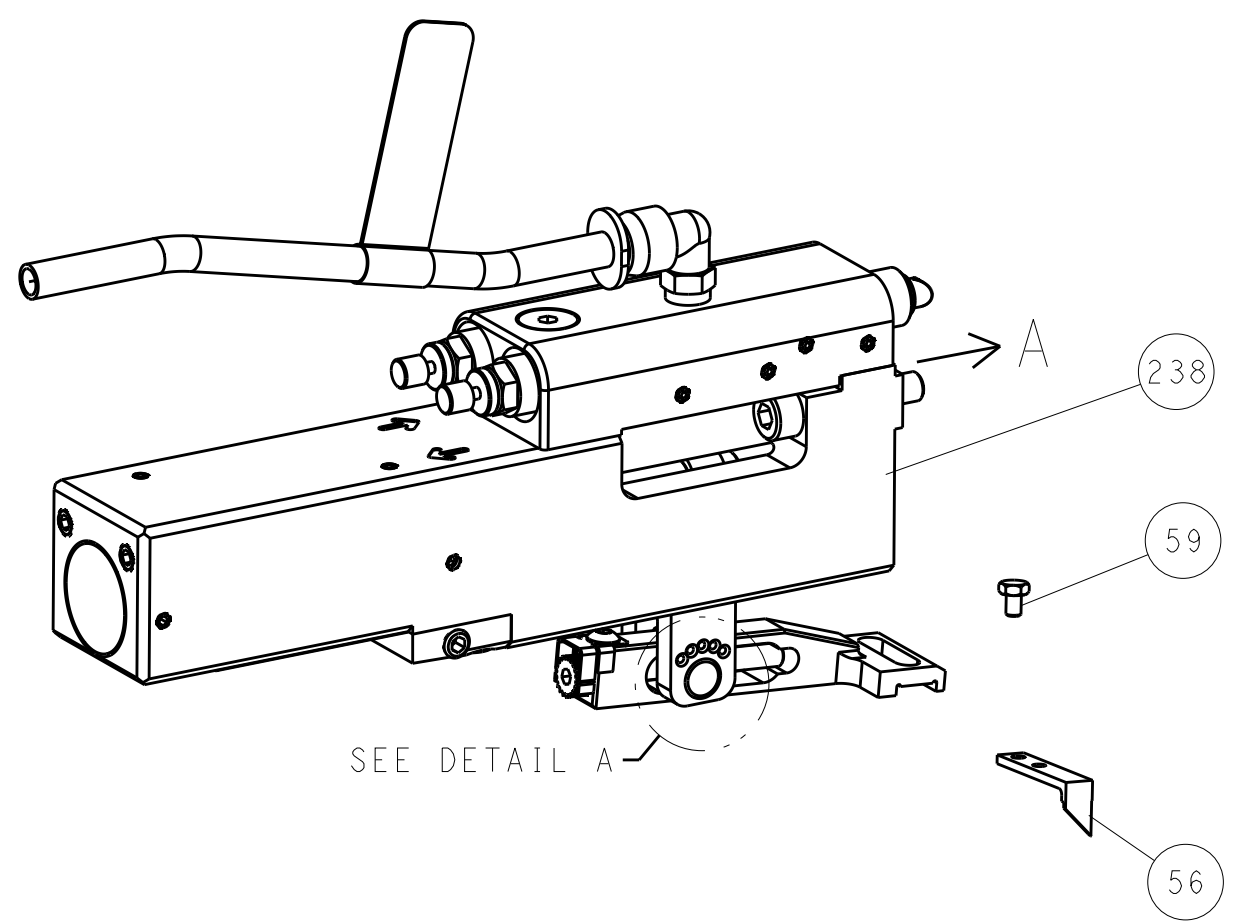
OWN	R. KNEPPER	10-Jun-14
CHK	G. BAILEY	10-Jun-14
APVD	M. CLIFFORD	10-Jun-14
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266342
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	E	

LOC	DIST	REV	DATE	BY	APPV
A	66				

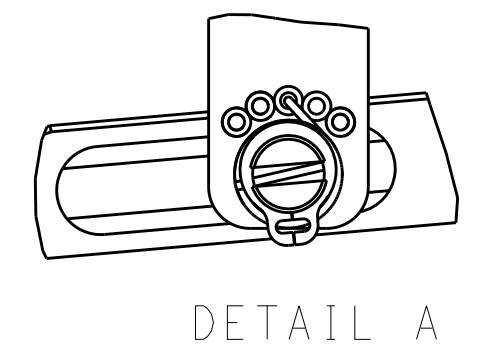
FEED TYPE MECHANICAL



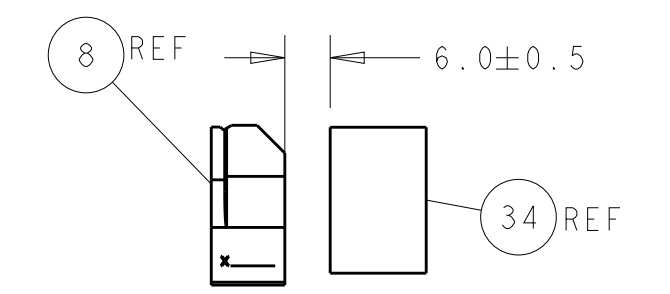
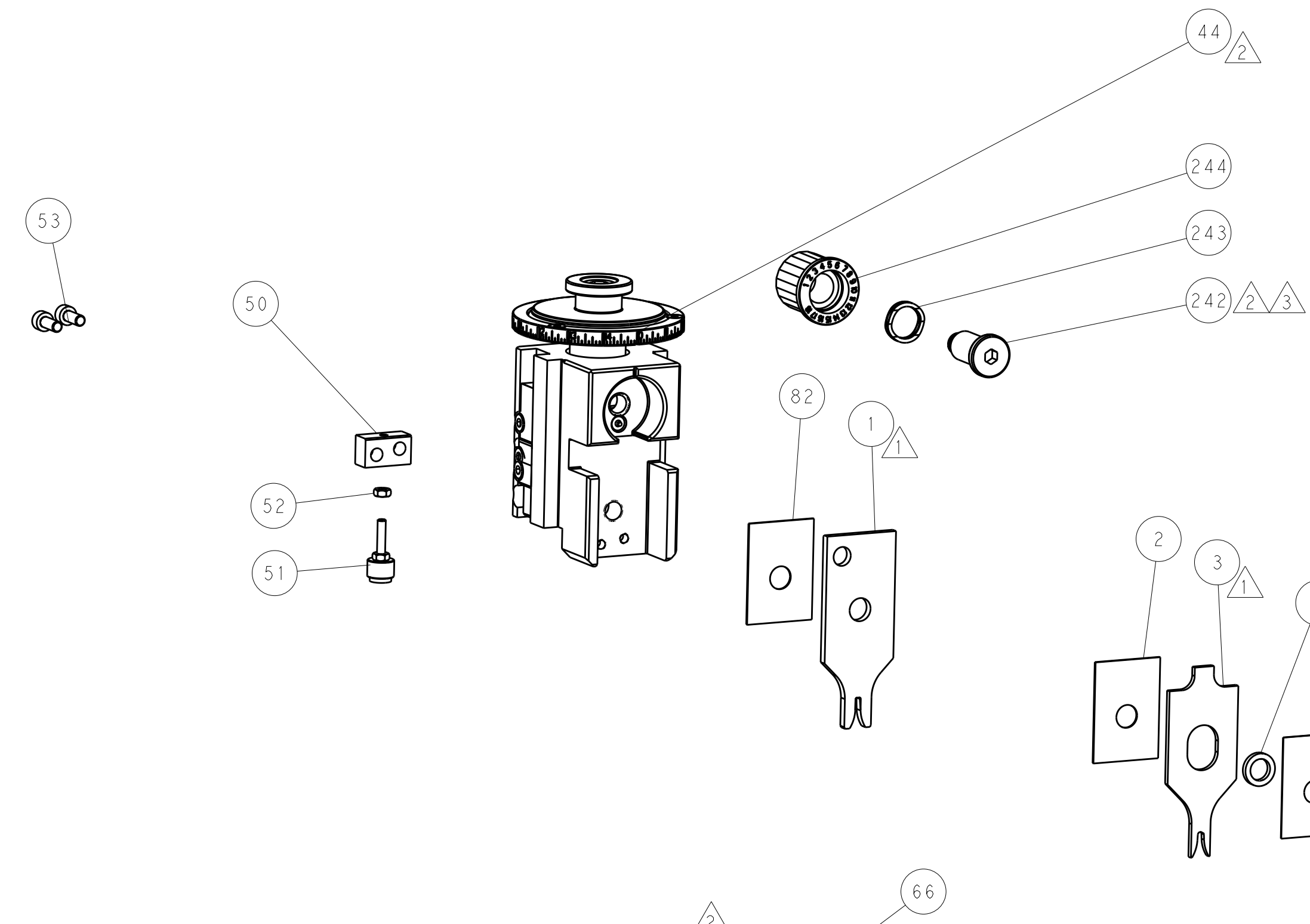
PNEUMATIC



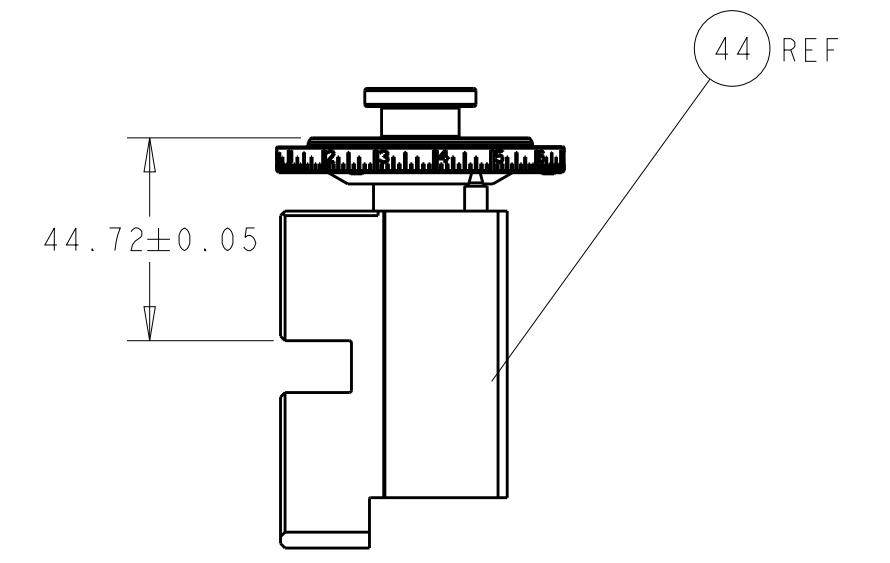
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



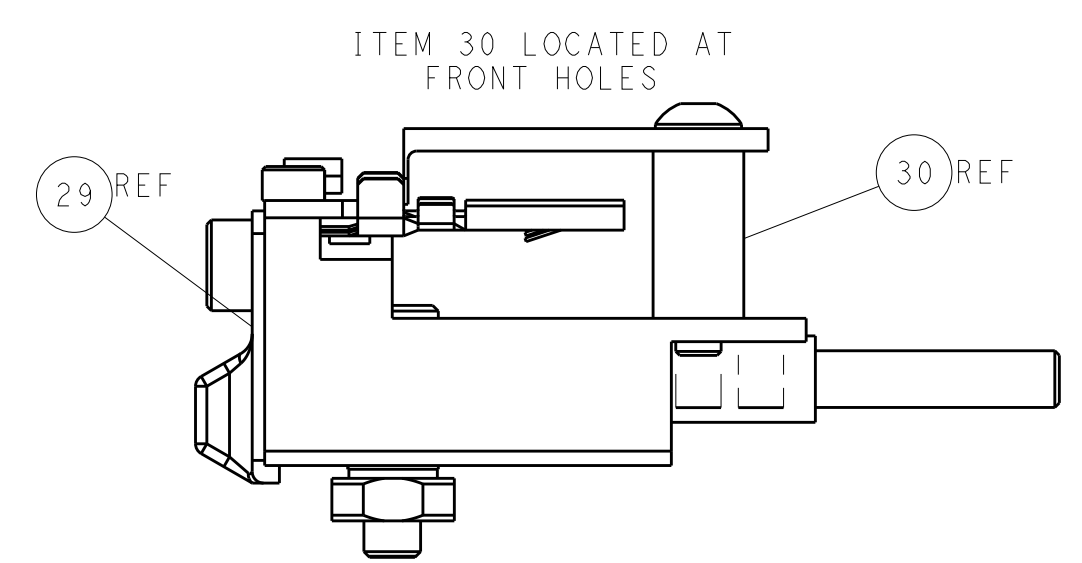
DETAIL A



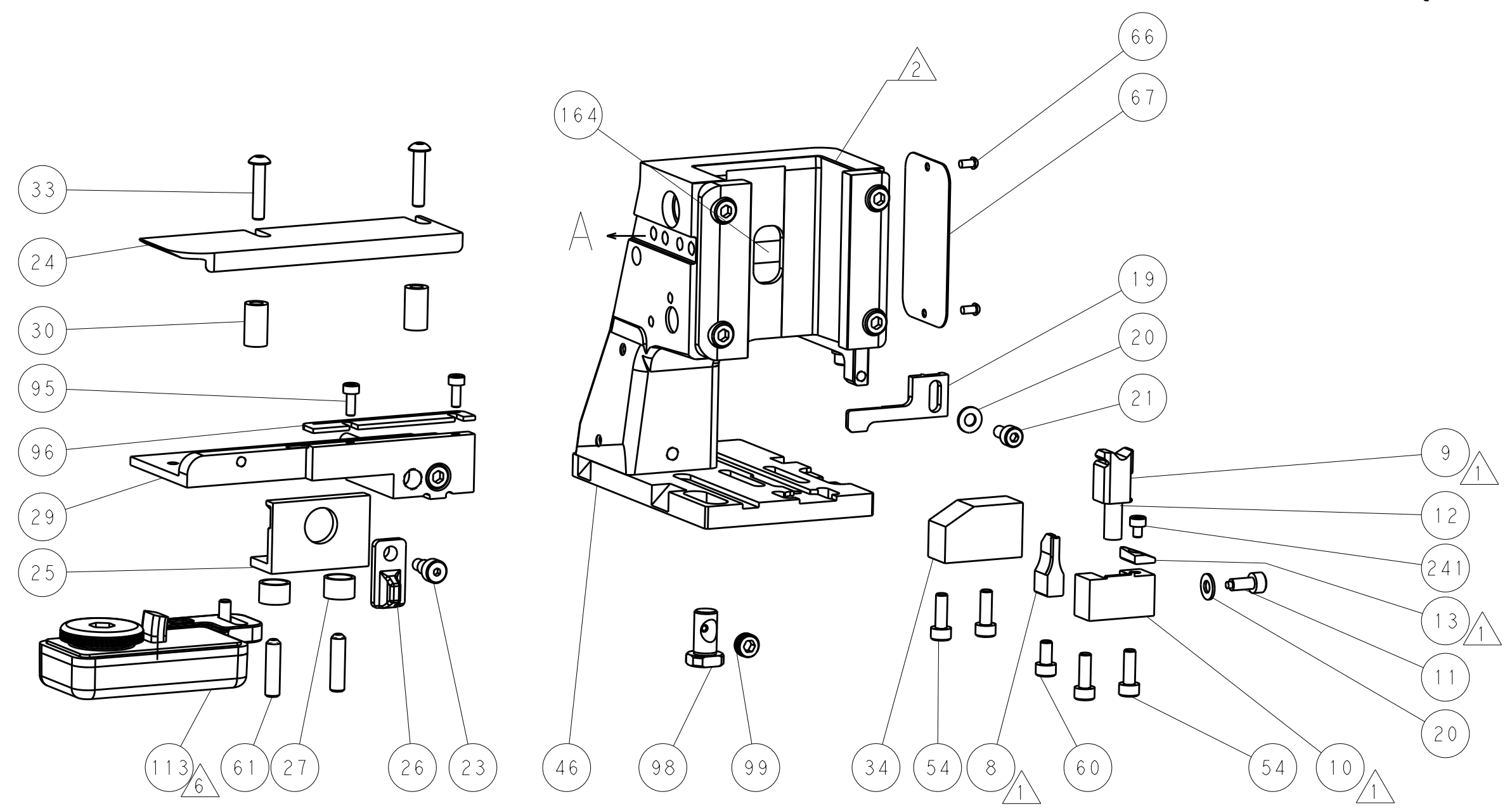
TERMINAL SUPPORT LOCATION



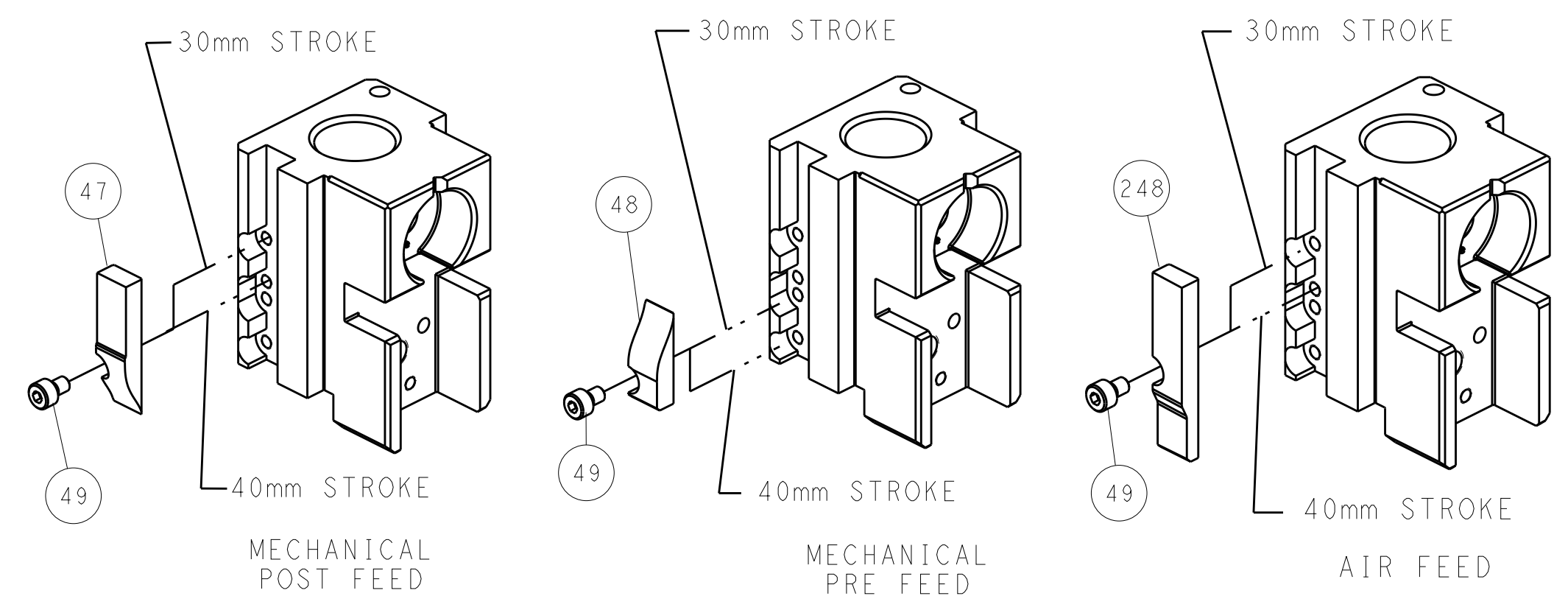
RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL



CAM POSITIONS

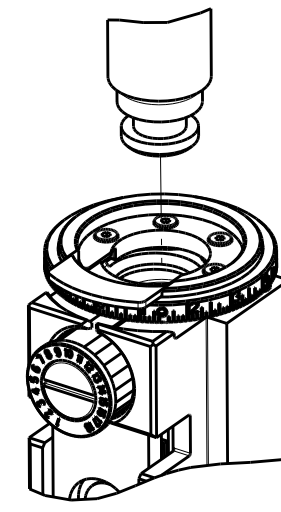


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R. KNEPPER 10-Jun-14		TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 10-Jun-14		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV: M. CLIFFORD 10-Jun-14		NAME: Ocean Side Feed Applicator	
H		2 PLC ±		PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
L		3 PLC ±		APPLICATION SPEC:		RESTRICTED TO:	
R		4 PLC ±		WEIGHT:		A1 00779 ©=2266342	
ANGLES		FINISH:		Customer Accessible Production Drawing		SCALE: 1:2 SHEET 2 OF 4 REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266342-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266342-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266342-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.54 mm [1.00]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN, UNIVERSAL MATE-N-LOK			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.96-4.75 mm [1.56-.187 IN]		Ø1.02-2.54 mm [1.040-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	(C)114-1012 Rev - (B)114-1011 Rev -		
	(A)114-1010		

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 61115-1	(C) 61314-1	(B) 350560-1	(A) 350570-7
(C) 61116-1	(C) 61314-2	(B) 350561-1	(A) 350699-1
(C) 61116-2	(C) 61314-3	(B) 350561-2	(A) 350699-2
(C) 61116-3	(C) 61314-4	(B) 350561-3	(A) 350699-3
(C) 61116-4	(C) 61314-5	(B) 350561-5	(A) 350699-5
(C) 61116-5	(C) 61314-6	(B) 350561-7	(A) 350699-7
(C) 61116-6	(C) 61314-7	(B) 350561-8	(A) 350699-8
(C) 61116-7	(C) 61314-8	(A) 350570-1	(A) 350851-1
(C) 61116-8	(C) 61527-2	(A) 350570-2	(A) 350851-2
(C) 61116-9	(C) 170147-1	(A) 350570-3	(A) 350851-7
(C) 1-61116-3	(C) 170147-2	(A) 350570-6	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.22+/-0.05 [1.048+/-0.002]	6.1
20 AWG	1.09+/-0.05 [1.043+/-0.002]	7.7
22 AWG	1.02+/-0.05 [1.040+/-0.002]	8.4
24 AWG	0.96+/-0.05 [1.038+/-0.002]	8.8

- 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.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
3	-	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		
6	-	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	455888-5	SPACER, CRIMPER	82		
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71		
-	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	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	1752356-3	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	2844992-3	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	240792-5	DRAG, TERMINAL	25		
-	1	1	1320928-2	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		
-	2	2	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	1803095-1	FLOATING SHEAR, FRONT	9		
1	1	1	1338692-1	ANVIL, COMBINATION .070	8		
-	-	-	-	-	7		
-	-	-	-	-	6		
-	1	1	2119757-8	DEPRESSOR, SHEAR	5		
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4		
1	1	1	2-1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3		
-	1	1	455888-5	SPACER, CRIMPER	2		
1	1	1	1-456404-8	CRIMPER, WIRE PREMIUM	1		

*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.

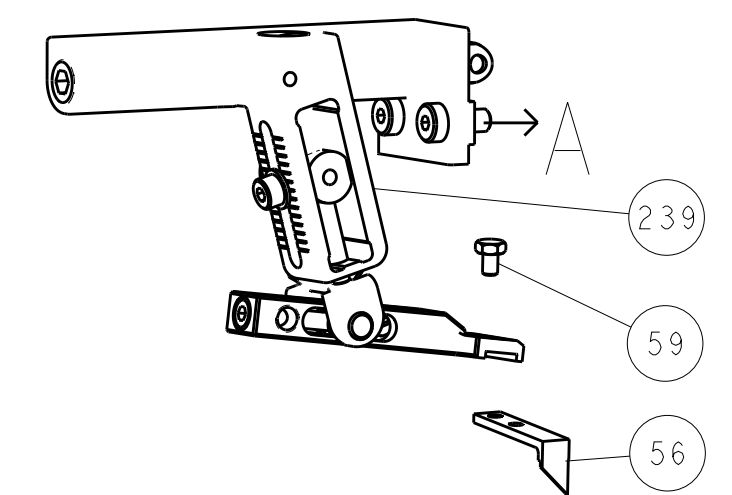
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

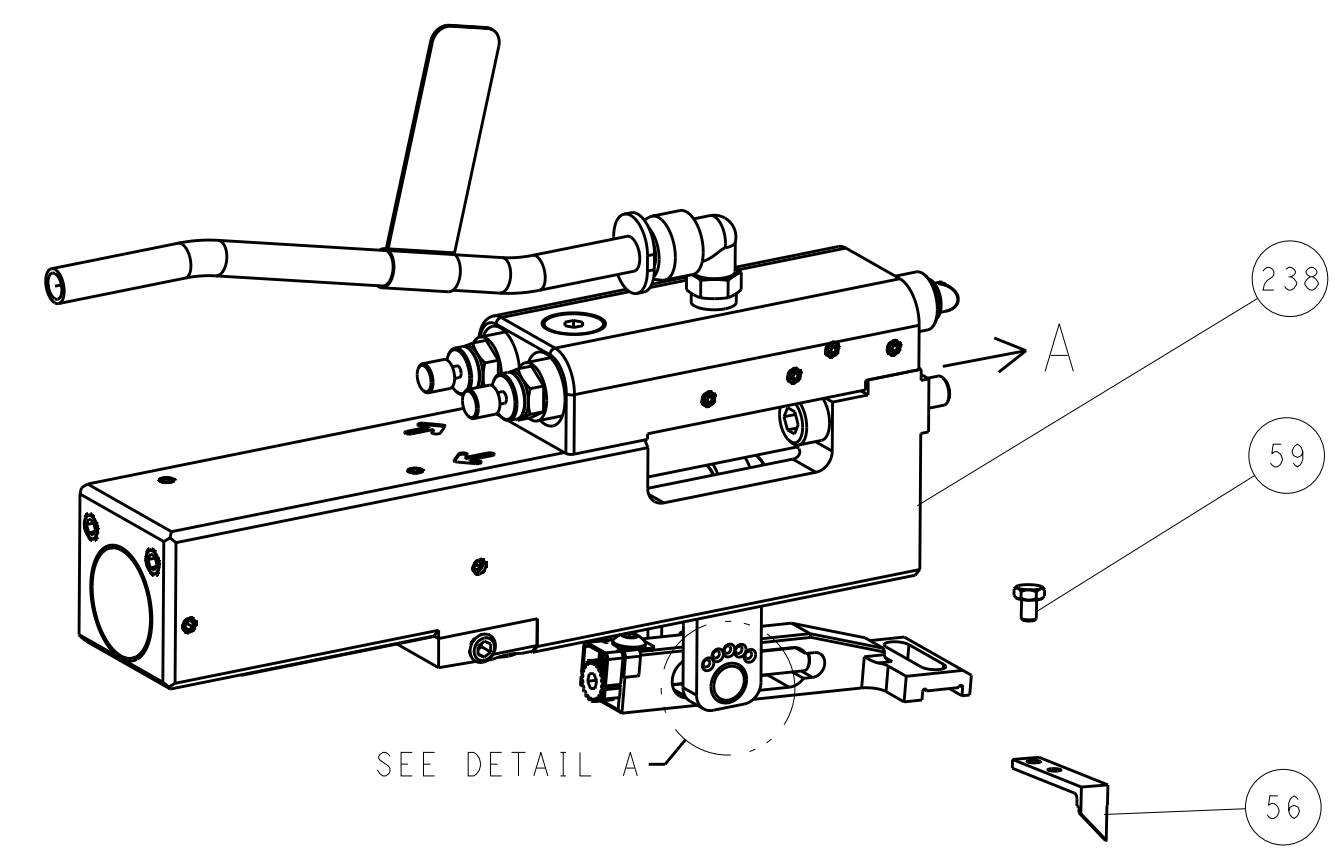
OWN	R. KNEPPER	10-Jun-14	
CHK	G. BAILEY	10-Jun-14	
APVD	M. CLIFFORD	10-Jun-14	
PRODUCT SPEC			
APPLICATION SPEC			
WEIGHT			
SCALE	1:2	SHEET	3 OF 4
REV	E		

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

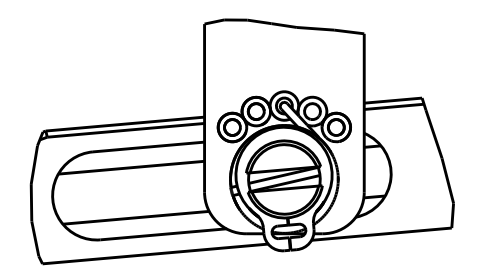
FEED TYPE MECHANICAL



PNEUMATIC

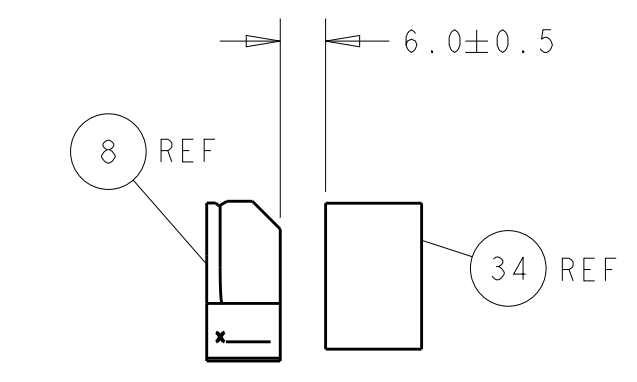
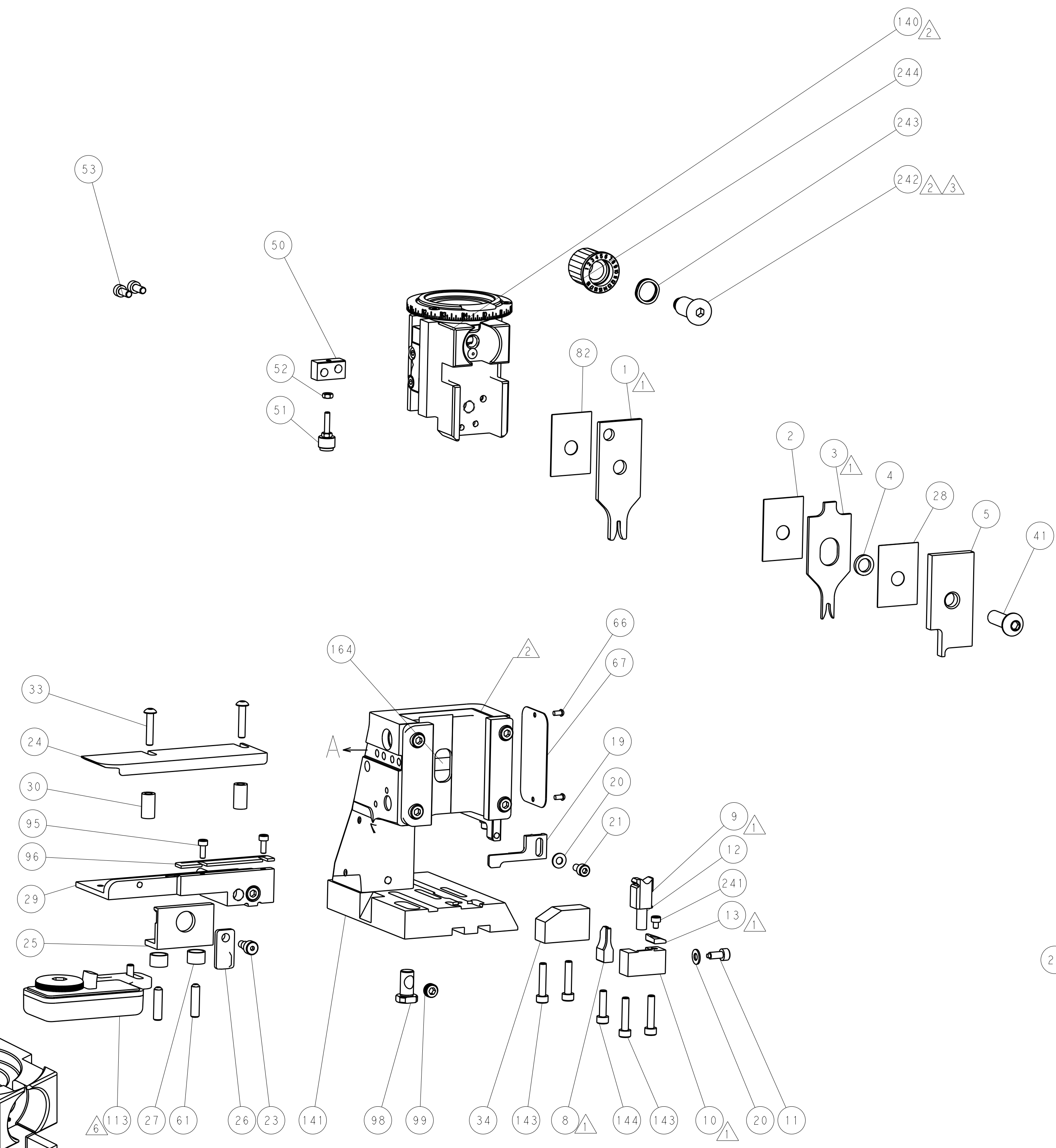
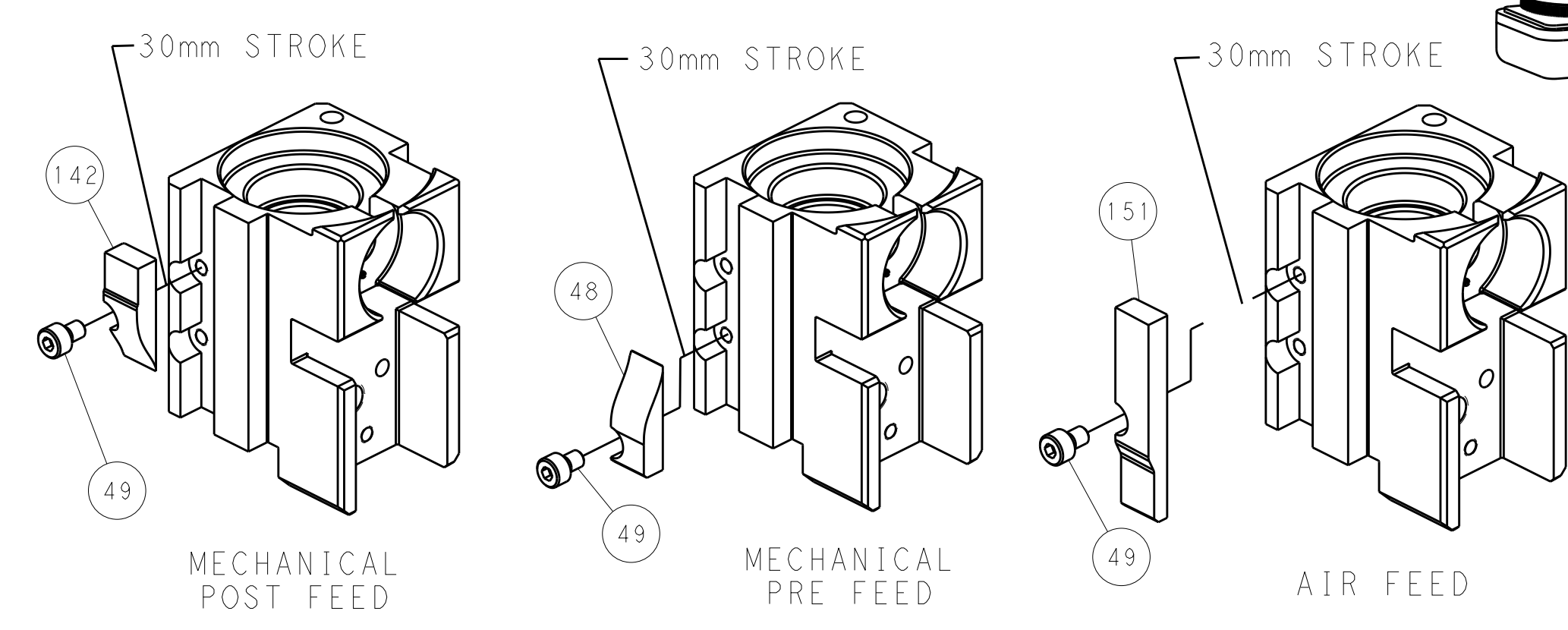


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

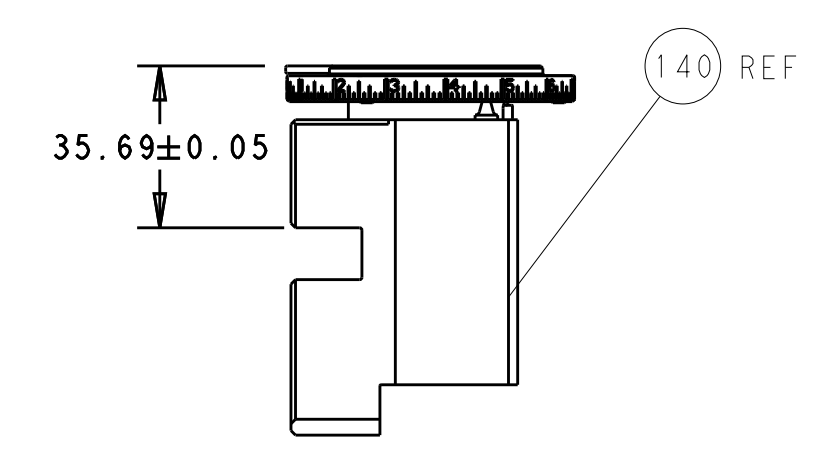


DETAIL A

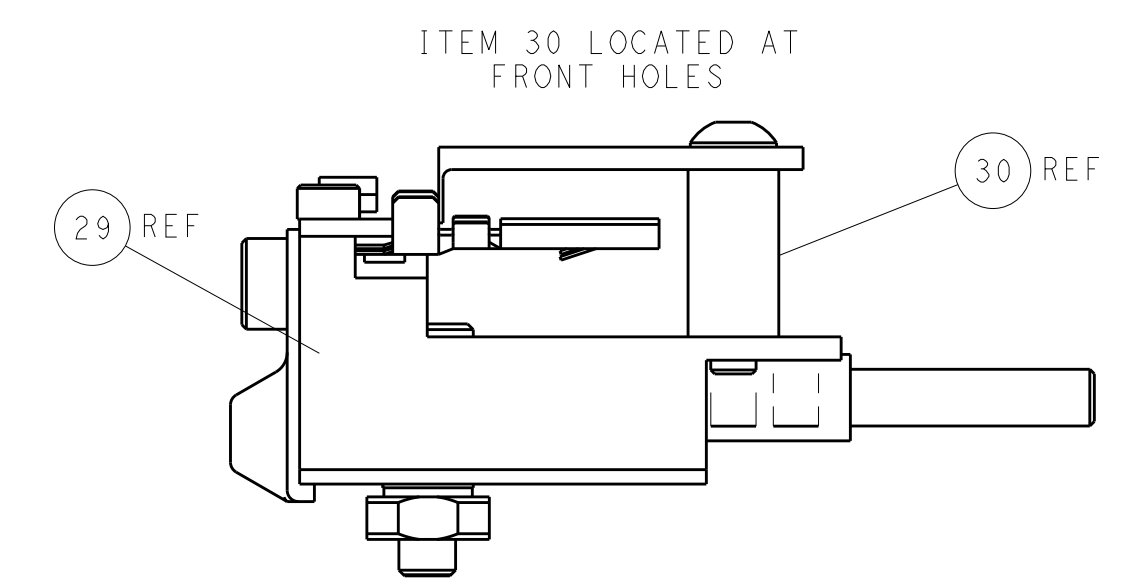
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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:		DWN R. KNEPPER 10-Jun-14		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK G. BAILEY 10-Jun-14		NAME	
MATERIAL				APVD M. CLIFFORD 10-Jun-14		Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		RESTRICTED TO	
				WEIGHT		A1 00779 C=2266342	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV E	