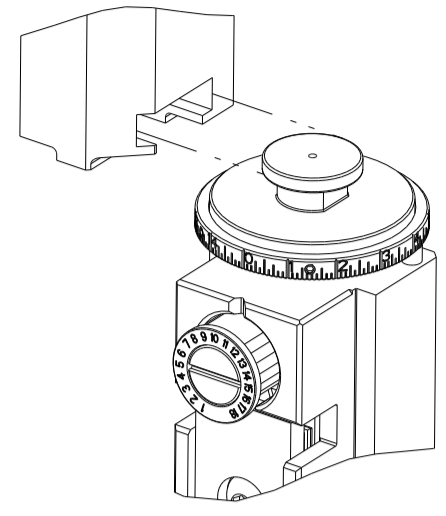


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266048-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266048-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2266048-2	J	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS ⁴
7-2266048-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266048-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266048-7	J	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, 180 DEGREE, FAKRA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.75-3.25 mm [1.08-.128 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	(A)114-32145	-	-
	(B)114-32217	-	-
TERMINALS APPLIED ⁵			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A)1-2203260-4	(A)2203260-8	(A)1-2203270-4	(A)2203270-8
(A)2-2203270-6	(B)2304634-8	(A)4-2203270-5	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ³
GG RTK044	0.92+/- .03 [.038+/- .001]	7.6
RTK-031	0.84+/- .03 [.033+/- .001]	8.5
2DS-PPFW(TA)	0.84+/- .03 [.033+/- .001]	8.5

- ¹ RECOMMENDED SPARE PARTS
 - ² REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - ³ 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.
 - ⁴ THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.
 - ⁵ TERMINAL LUBRICANT RECOMMENDED
6. 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)

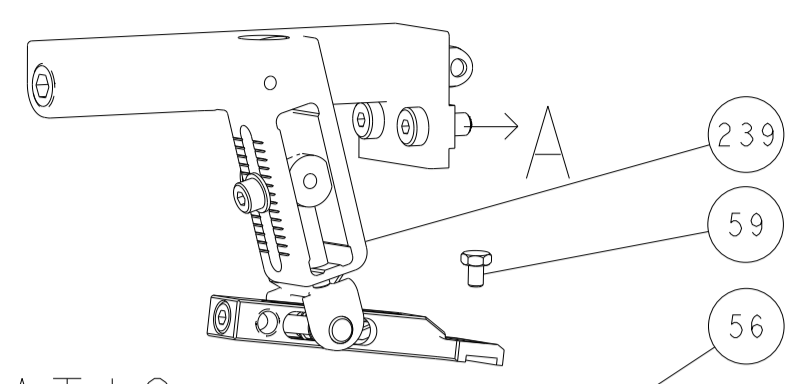
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	H1		ECR-21-004402	14APR2021	JWC	RK
		J		ECR-21-005060	03MAY2021	JWC	RK
		J1		ECR-22-142860	20JUN2022	FZ	TE
		J2		ECR-22-143752	27JUN2022	FZ	JAH

-	1	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	-	-	-	2844950-1	AIR FEED MODULE	290
⁴	-	-	-	-	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	-	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
⁵	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	1	1	1	854769-7	HOLDER, INS	74
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
⁴	-	1	2	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	3-1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
¹	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	5-22279-1	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
¹	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
¹	-	1	1	1	1	1803510-1	FLOATING SHEAR, MINI COAX FRONT	9
¹	1	2	2	1	1	1-1633933-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119780-7	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	-	2
¹	1	2	2	1	1	5-1633588-0	CRIMPER, WIRE	1

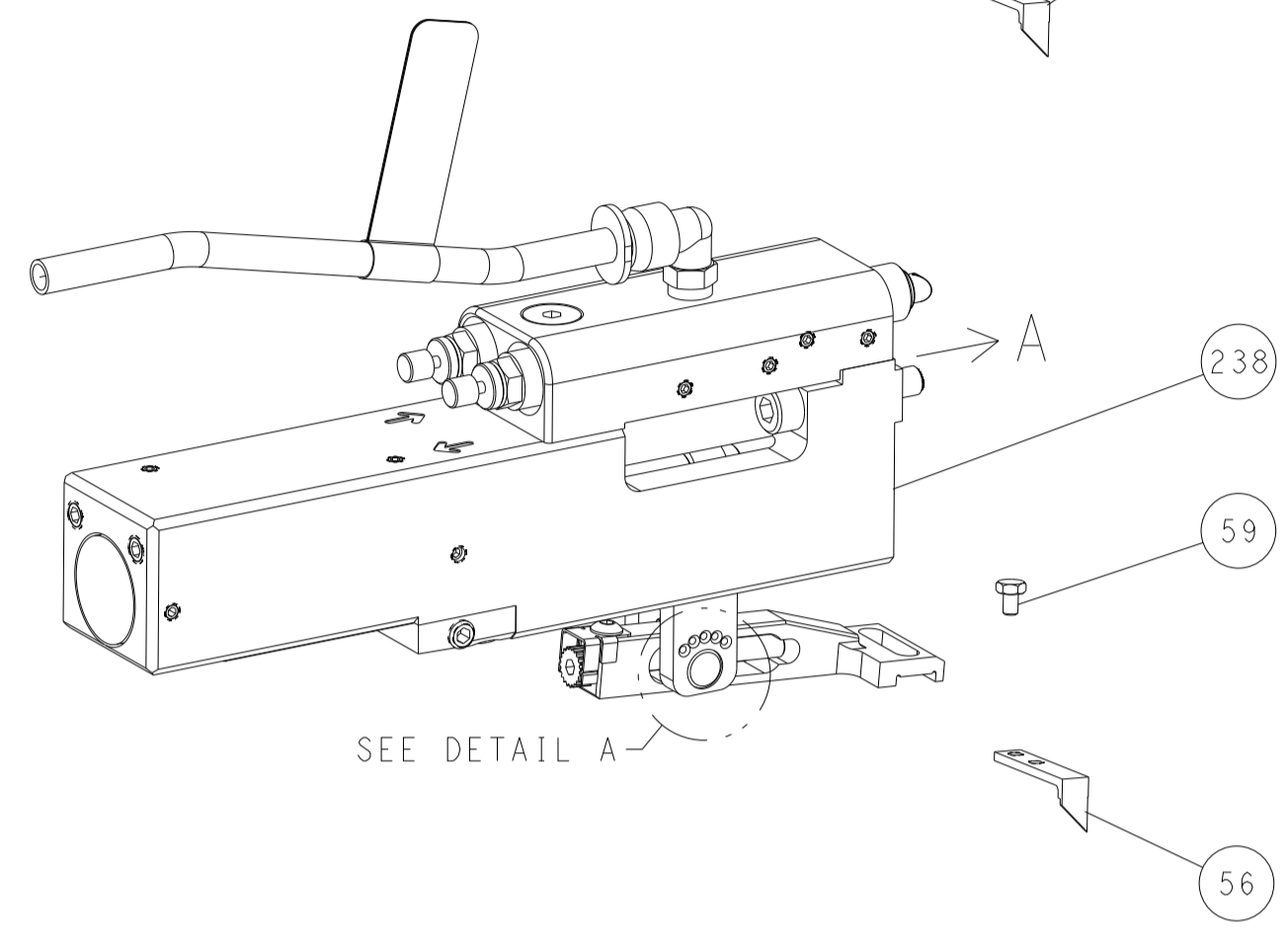
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2266048	1	4	J2

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

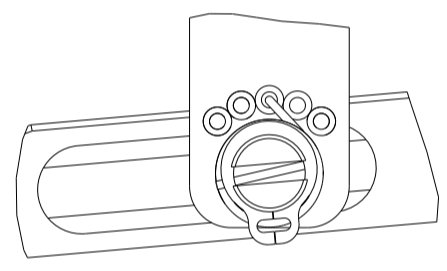
FEED TYPE MECHANICAL



PNEUMATIC

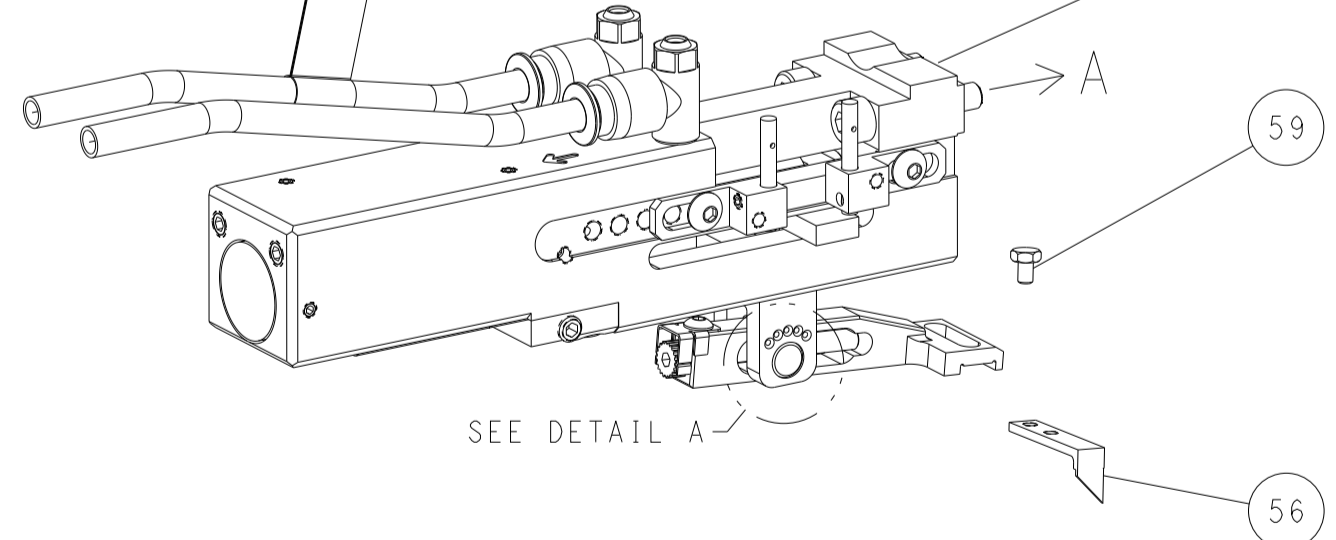


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

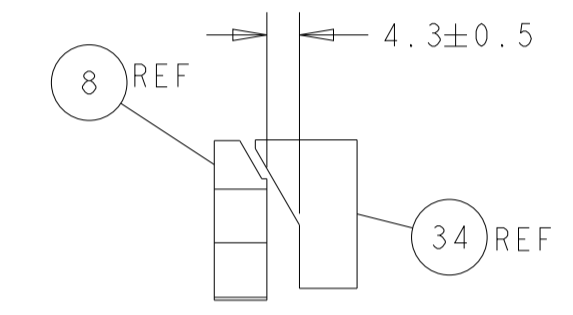
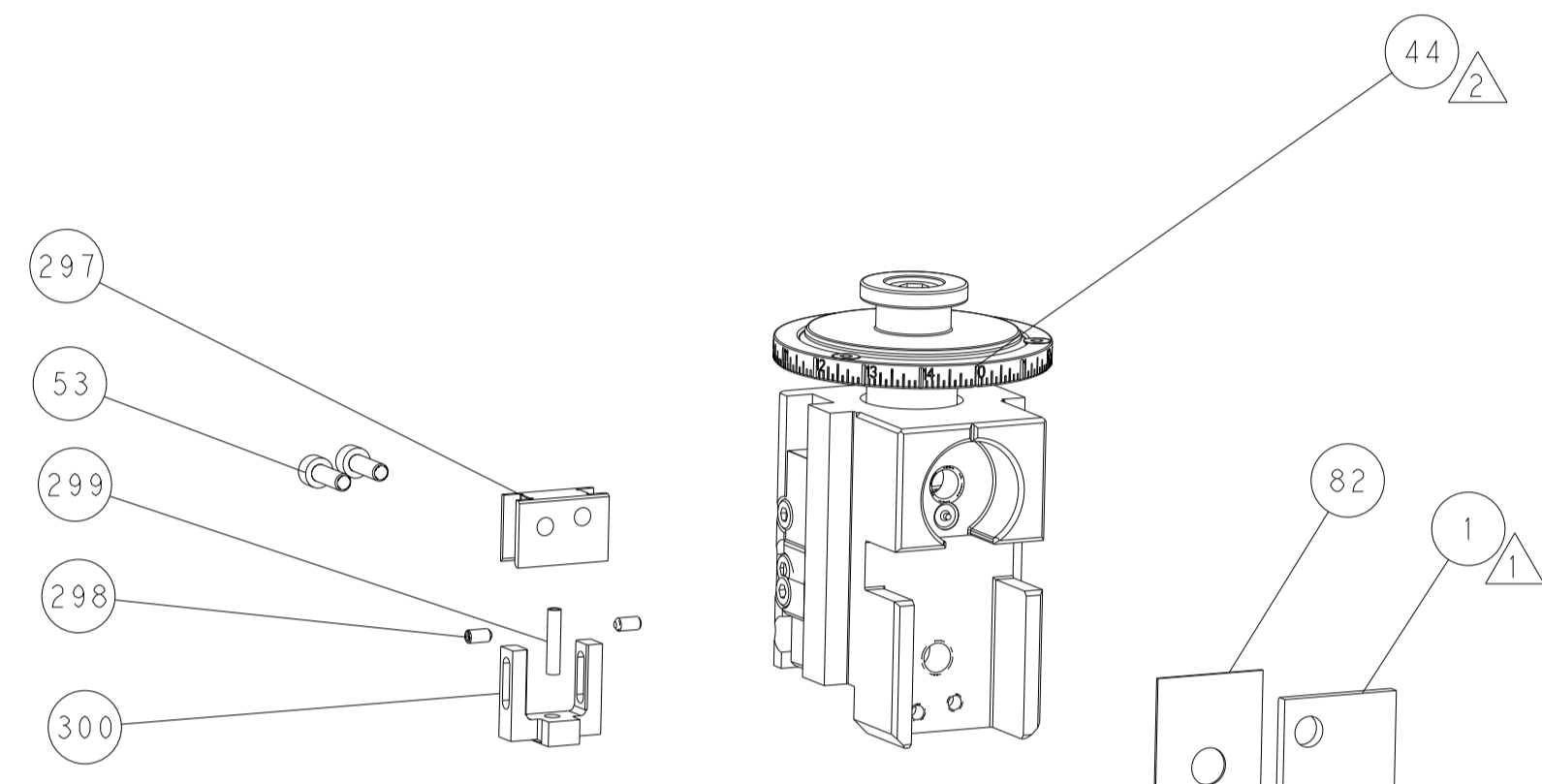
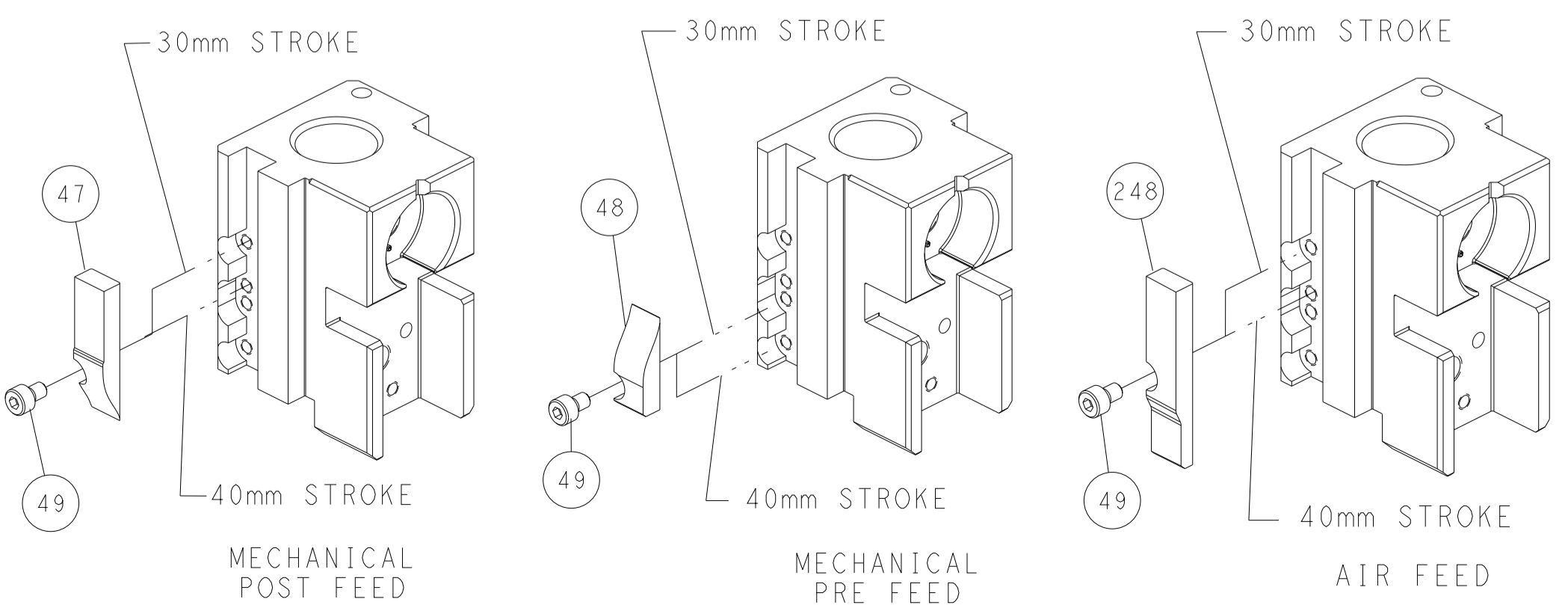


DETAIL A

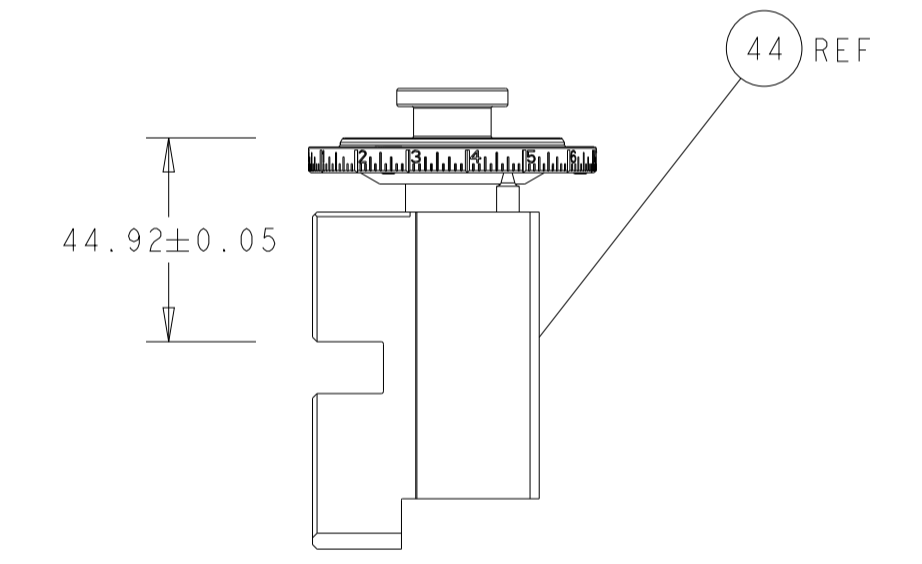
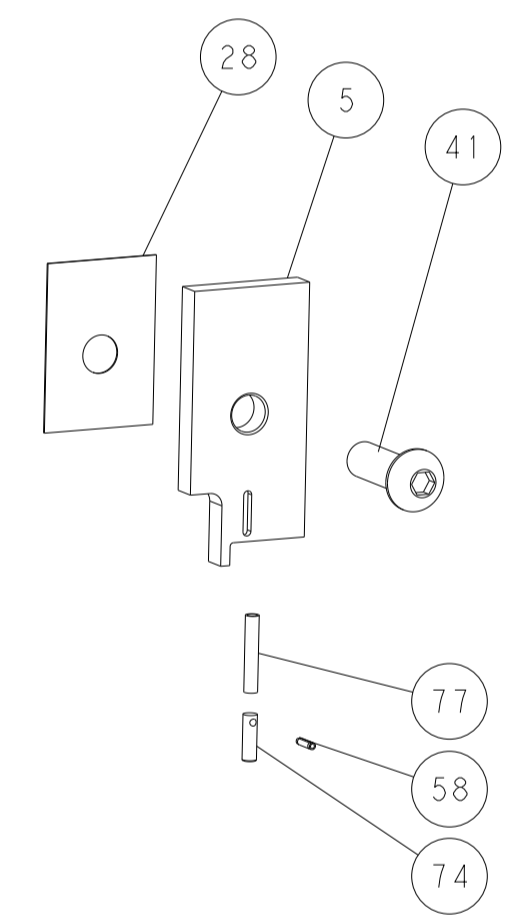
DOUBLE ACTING PNEUMATIC WITH SENSORS



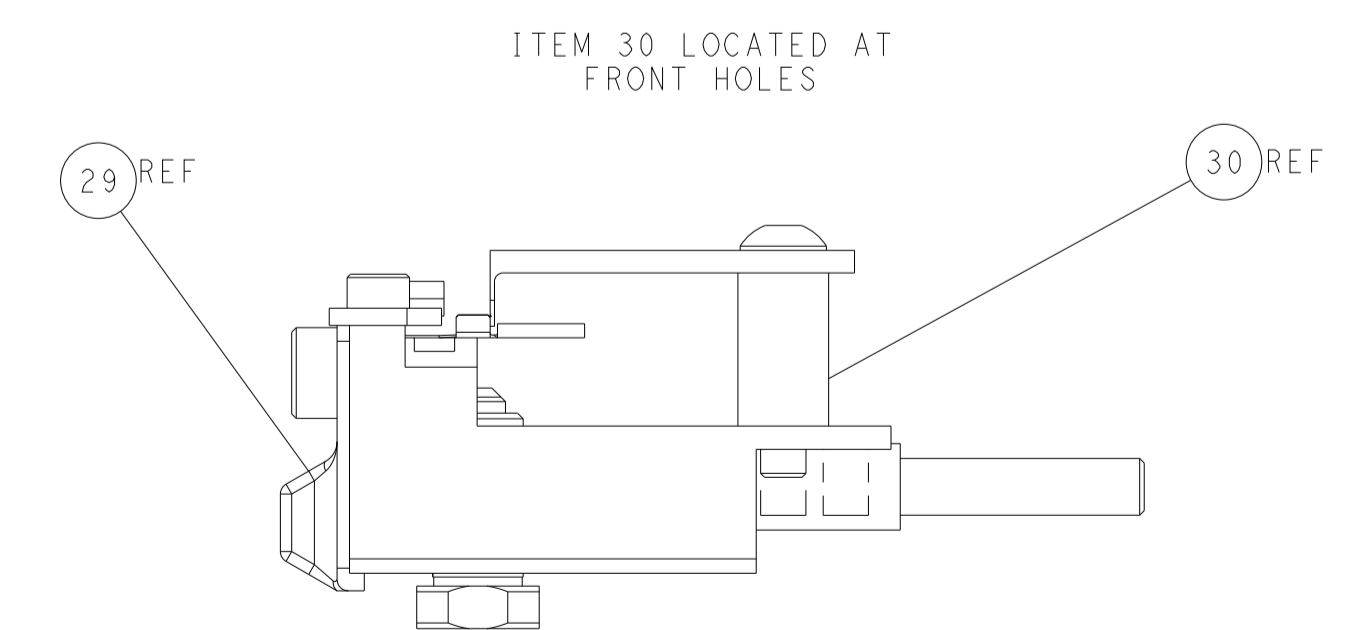
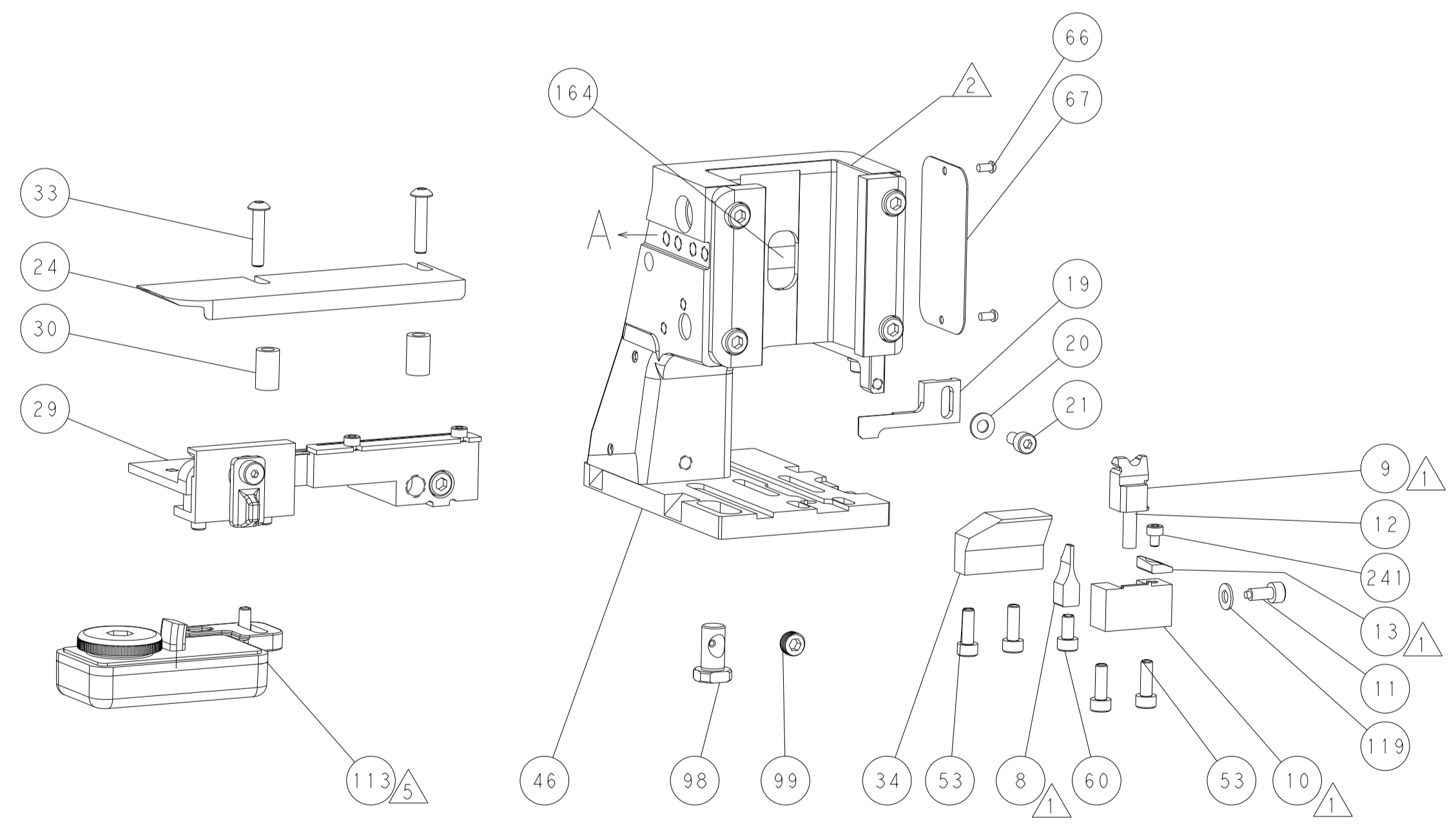
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



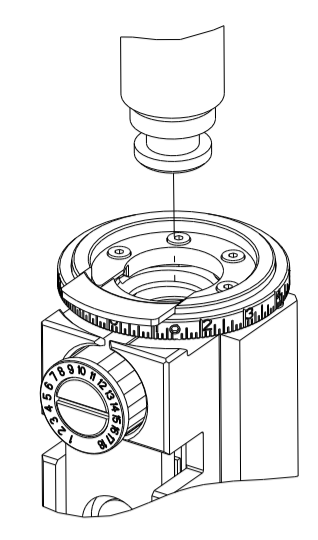
FEED TRACK POSITION GUIDE BY WIRE BARREL

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:		DWG: R.O. WILSON 21OCT2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME: I.L. ELBIN 22OCT2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: K.J. STAKEM 22OCT2013		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2	
				CAGE CODE: A1 00779		SHEET 2 OF 4	
				REV: J2		REV: J2	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266048-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266048-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2266048-2	J	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS ⁴
7-2266048-7	J	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	-	-

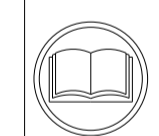
APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, 180 DEGREE, FAKRA			
WIRE STRIP LENGTH 2.75-3.25 mm [.108-.128 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION	(A)114-32145	-	-
	(B)114-32217	-	-

TERMINALS APPLIED ⁵

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A)1-2203260-4	(A)2203260-8	(A)1-2203270-4	(A)2203270-8
(A)2-2203270-6	(B)2304634-8	(A)4-2203270-5	

WIRE SIZE	CRIMP HEIGHT WI_CRIMP_UNITS	CRIMP HEIGHT REFERENCE SETTING
GG RTK044	0.92+/- .03 [.038+/- .001]	7.6
RTK-031	0.84+/- .03 [.033+/- .001]	8.5
2DS-PPFW(TA)	0.84+/- .03 [.033+/- .001]	8.5



- ¹ RECOMMENDED SPARE PARTS
 - ² REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - ³ 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.
 - ⁴ THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
 - ⁵ TERMINAL LUBRICANT RECOMMENDED
6. 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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

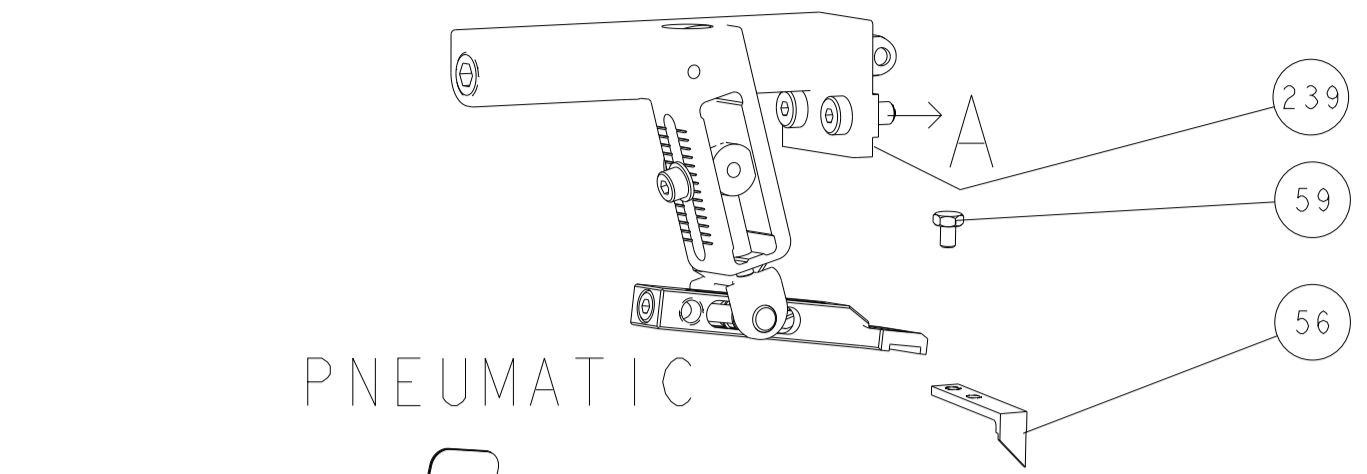
-	1	1	1	1803945-4	TONKER		300
-	1	1	1	22278-9	SPRING, COMPRESSION		299
-	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0		298
-	1	1	1	1803944-1	SPACER, TONKER		297
-	1	-	-	2844950-1	AIR FEED MODULE		290
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	-	1	-	2844940-1	AIR FEED MODULE		238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC		164
⁴	-	-	1	2119641-2	FEED CAM, AIR FEED		151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		143
-	-	-	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
⁵	-	1	1	1-18028-2	WASHER, FLAT, REG M4		119
-	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	455888-5	SPACER, CRIMPER		82
-	1	1	1	22278-8	SPRING, COMPRESSION		77
-	1	1	1	854769-7	HOLDER, INS		74
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE		71
-	1	1	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	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
-	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250		58
-	1	1	1	1338685-1	PAWL, FEED		56
⁴	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		53
-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	-	-	1	2119652-1	FEED CAM, PRE FEED		48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	1	1	1	3-1752356-1	SUPPORT, TERMINAL		34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE		29
-	1	1	1	455888-3	SPACER, CRIMPER		28
-	1	1	1	1320928-2	STRIP GUIDE		24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	2119533-4	STRIPPER, SIDE FEED		19
¹	-	1	1	2119806-1	INSERT, SHEAR		13
-	1	1	1	5-22279-1	SPRING, COMPRESSION		12
-	1	1	1	1-356885-4	STOP, SHEAR		11
¹	-	1	1	2119805-1	SHEAR HOLDER, FRONT		10
¹	-	1	1	1803510-1	FLOATING SHEAR, MINI COAX FRONT		9
¹	1	1	1	1-1633933-3	ANVIL, COMBINATION		8
-	-	-	-	-	-		6
-	1	1	1	2119780-7	DEPRESSOR, SHEAR		5
-	-	-	-	-	-		4
-	-	-	-	-	-		3
-	-	-	-	-	-		2
¹	1	1	1	5-1633588-0	CRIMPER, WIRE		1

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

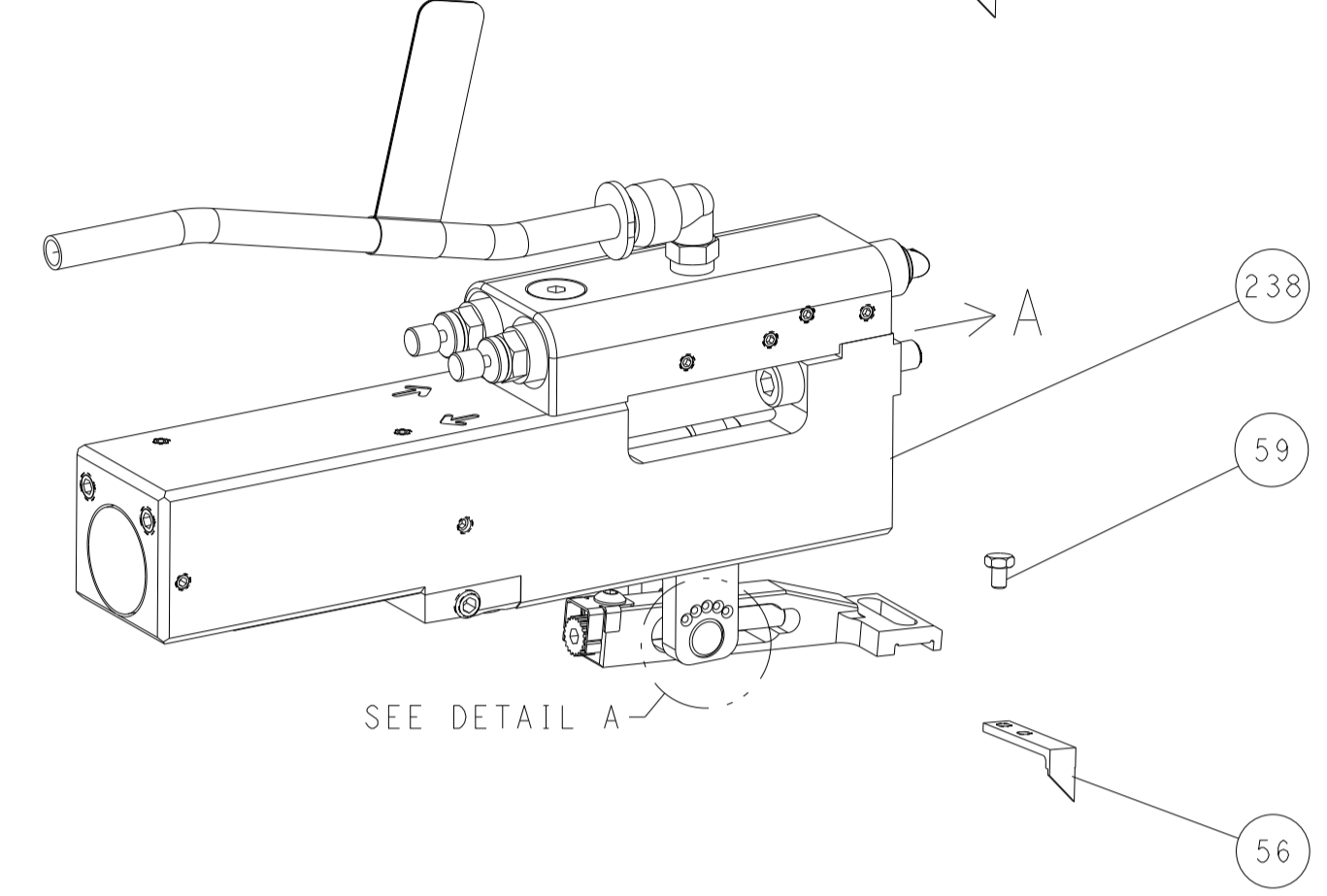
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	TE Connectivity
	ANGLES	FINISH		CHK	APVD	PRODUCT SPEC	Harrisburg, PA 17105-3608
MATERIAL				CHK	APVD	APPLICATION SPEC	Ocean Side Feed Applicator
				CHK	APVD	SIZE	Customer Accessible Production Drawing
				CHK	APVD	CAGE CODE	SCALE 1:2 SHEET 3 OF 4 REV J2
				CHK	APVD	DRAWING NO	
				CHK	APVD	RESTRICTED TO	
				CHK	APVD	WEIGHT	
				CHK	APVD	00779	
				CHK	APVD	©=2266048	

REVOLUTIONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LTM	DESCRIPTION		
		SEE SHEET 1		

FEED TYPE MECHANICAL

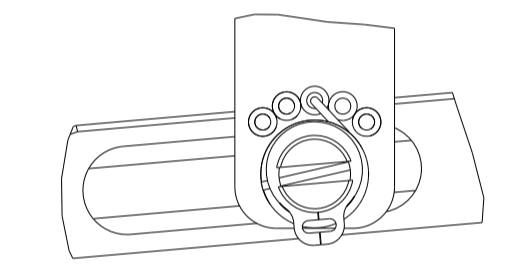


PNEUMATIC

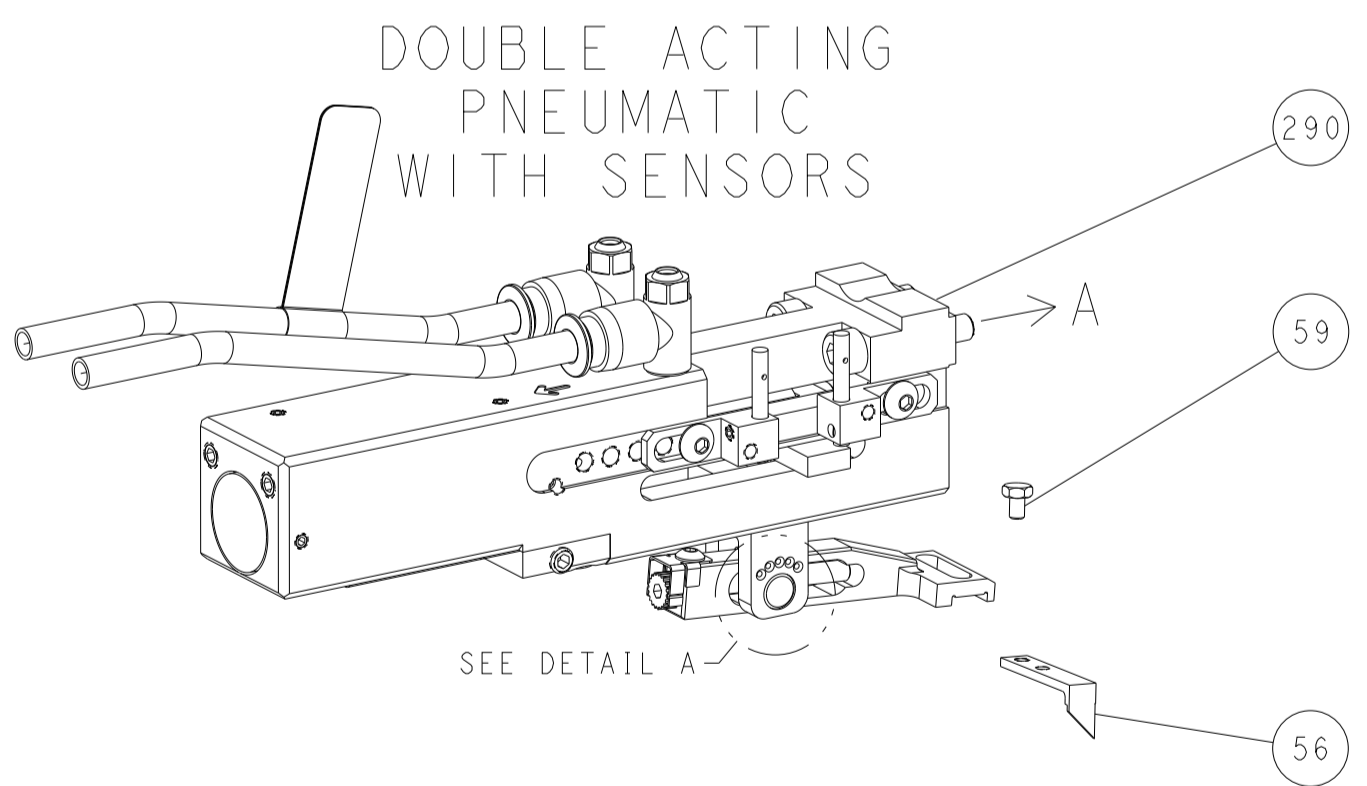


SEE DETAIL A

FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



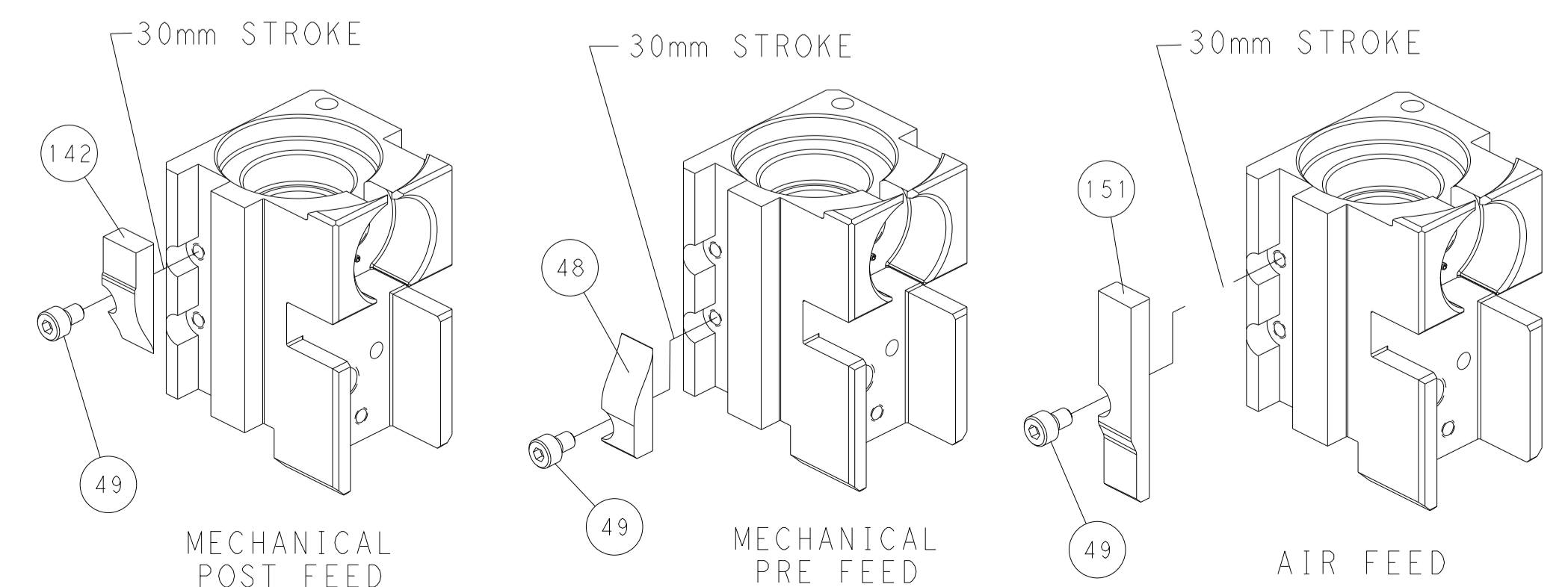
DETAIL A



DOUBLE ACTING
PNEUMATIC
WITH SENSORS

SEE DETAIL A

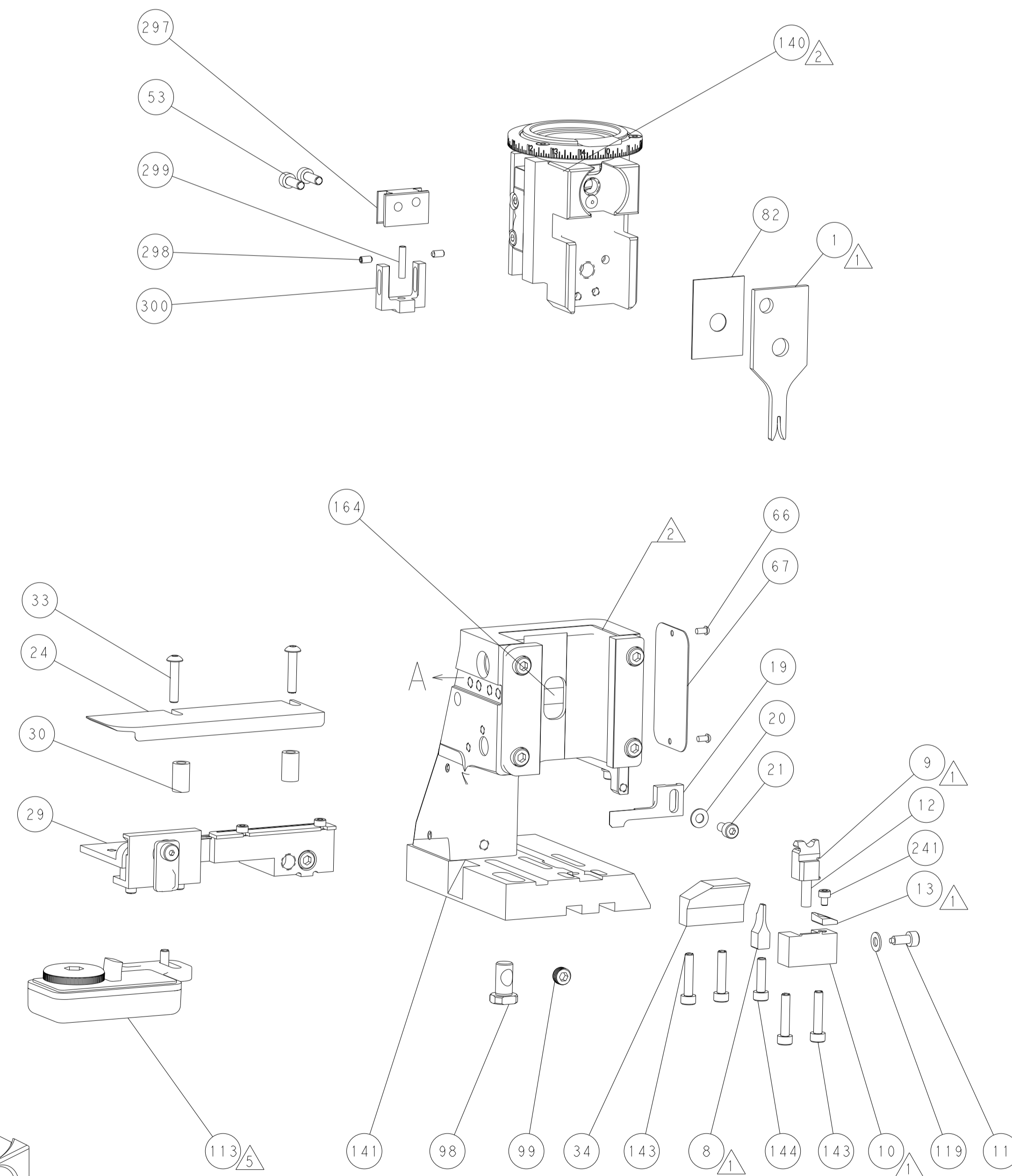
CAM POSITIONS



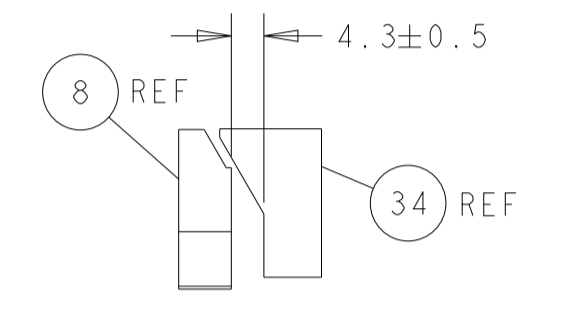
MECHANICAL
POST FEED

MECHANICAL
PRE FEED

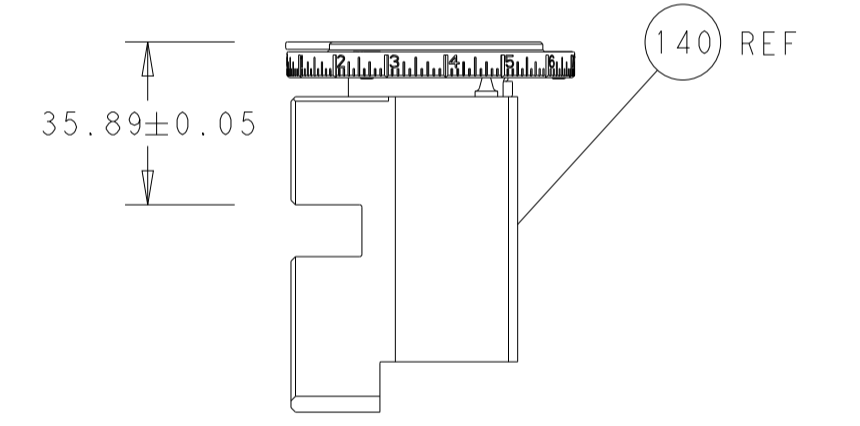
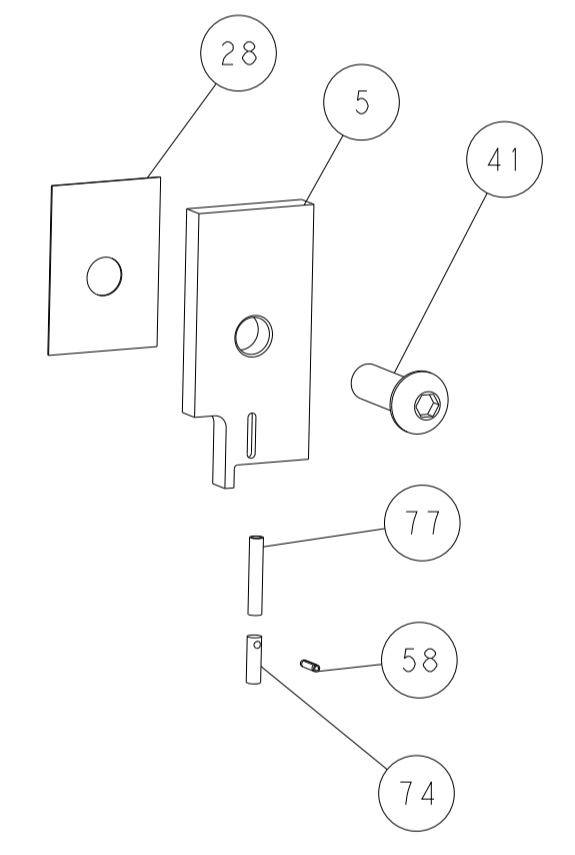
AIR FEED



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

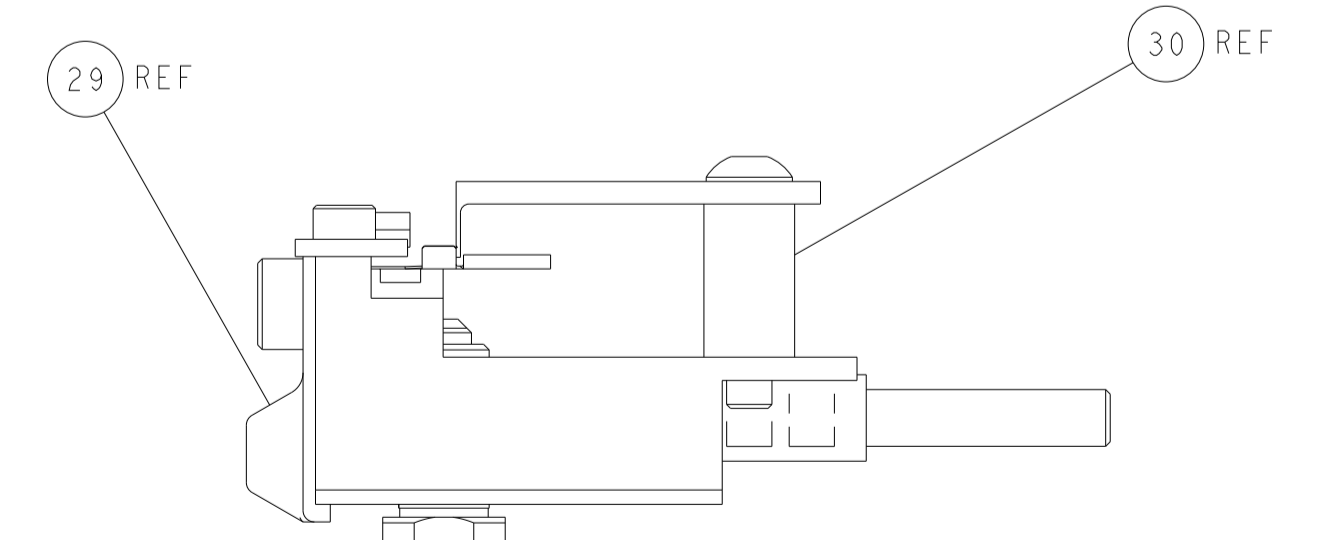


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		NAME PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO WEIGHT	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV J2
MATERIAL:		A 00779 C=2266048	Customer Accessible Production Drawing