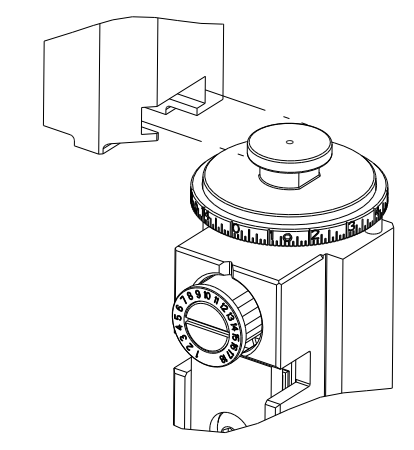


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266704-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266704-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266704-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266704-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266704-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.33 mm [.210]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMPER SPECIFICATION	
TERMINAL NAME: .250 BLADE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.75-5.65 mm [.187-.219 IN]		Ø2.54-3.61 mm [.100-.142 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1025		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
640416-1	640416-2	640416-3	640416-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.49 +/- 0.05 [.098 +/- .002]	5.7
16 AWG	2.31 +/- 0.05 [.091 +/- .002]	7.4
18 AWG	2.21 +/- 0.05 [.087 +/- .002]	9.0

- 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)

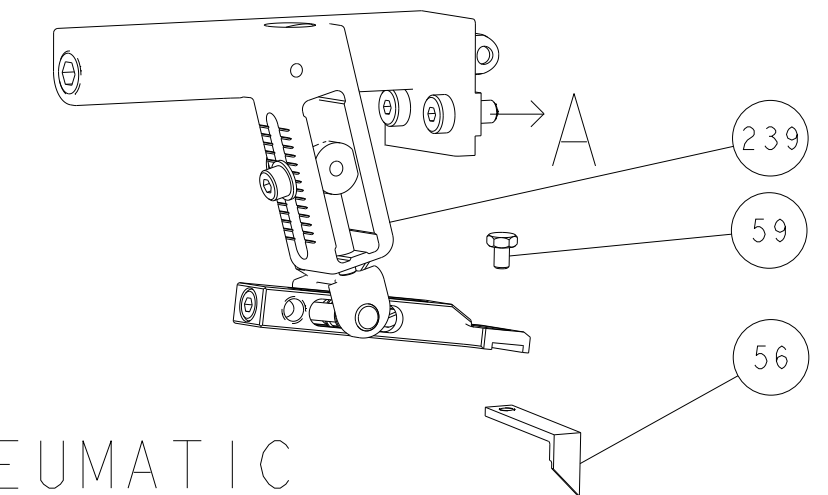
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		B1		ECR-20-000834	16JAN2020	MEH	TE
		C		ECR-22-138904	12MAY2022	FZ	JAH

-	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
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	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	1803607-3	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
-	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	1338683-8	FEED PAWL	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	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-9	SPACER, CRIMPER	28
-	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	2119533-1	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	454276-5	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1633926-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1-1803260-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1-455888-2	SPACER, CRIMPER	2
1	1	2	2	1	1-456411-5	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

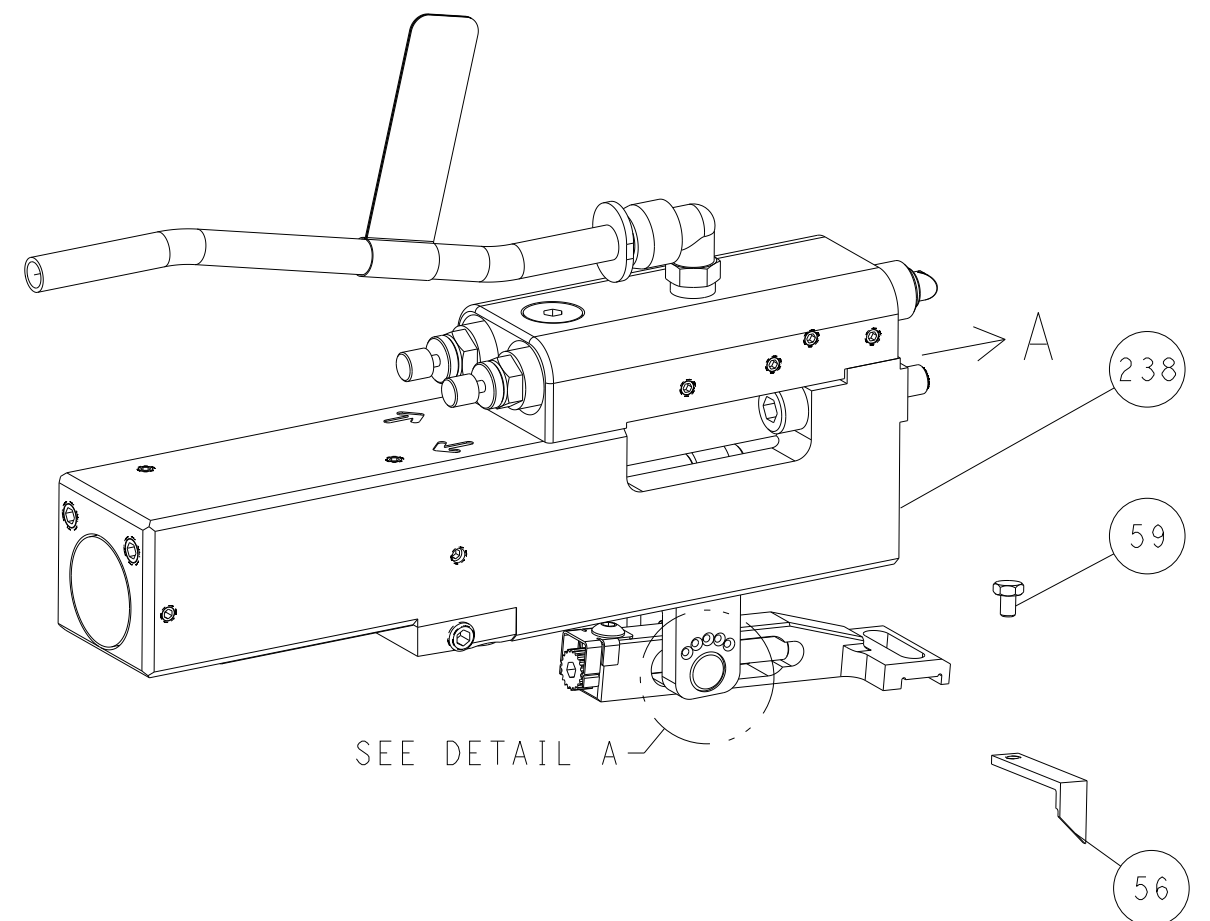
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mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±.0001			
APVD: C. TOPPER 26FEB2015		APVD: C. TOPPER 26FEB2015		APVD: C. TOPPER 26FEB2015		APVD: C. TOPPER 26FEB2015		APVD: C. TOPPER 26FEB2015	
NAME: Ocean Side Feed Applicator		NAME: Ocean Side Feed Applicator		NAME: Ocean Side Feed Applicator		NAME: Ocean Side Feed Applicator		NAME: Ocean Side Feed Applicator	
SIZE: A1		CAGE CODE: 00779		DRAWING NO: 2266704		RESTRICTED TO: -		SCALE: 1:2	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 1 of 4		REV C			

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

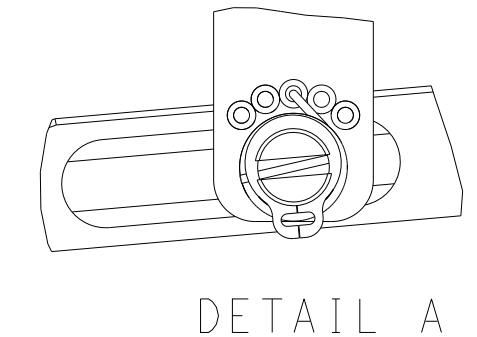
FEED TYPE MECHANICAL



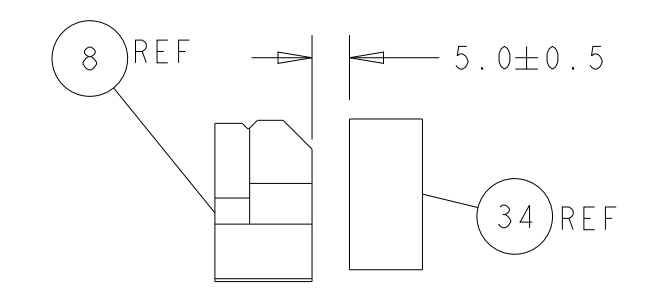
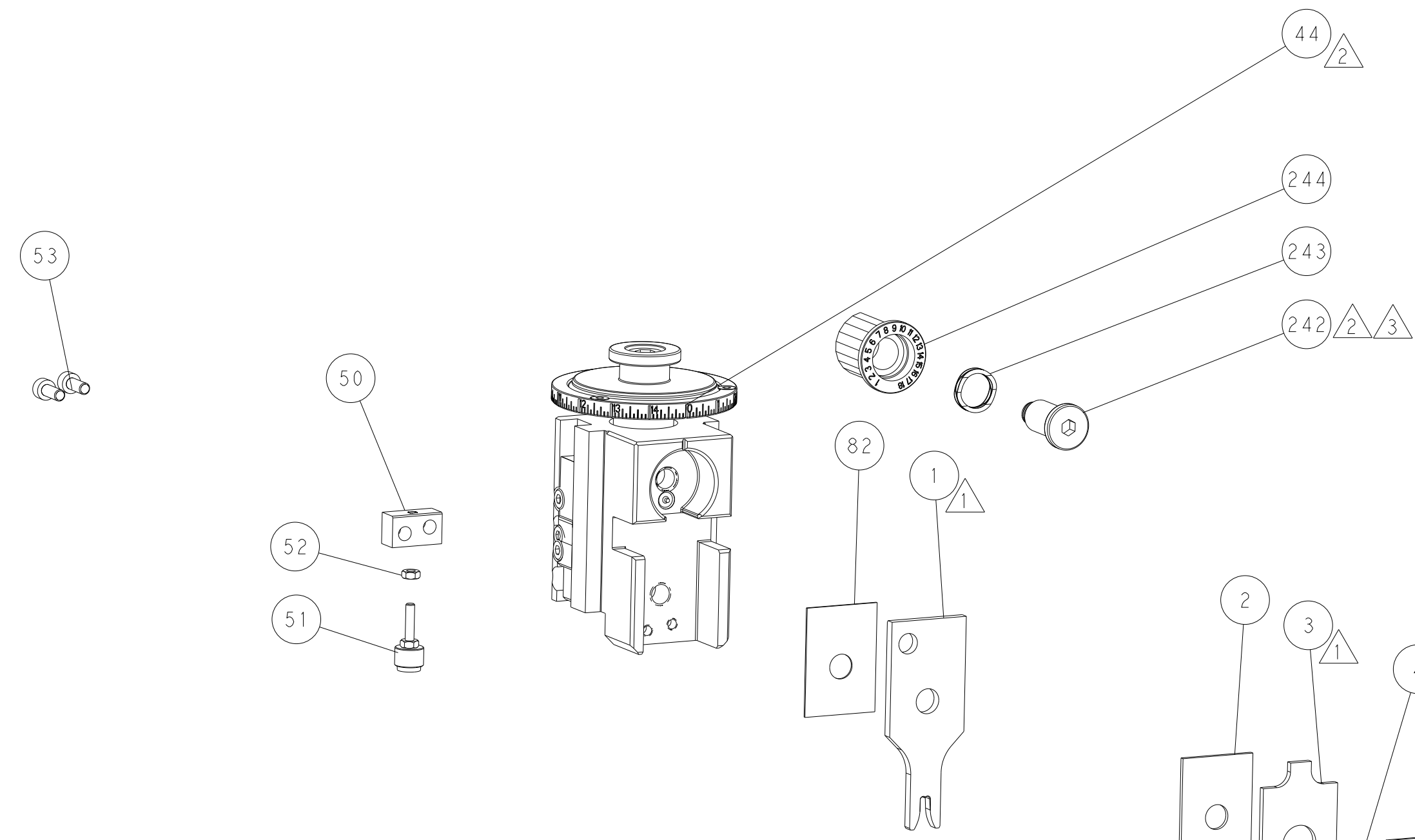
PNEUMATIC



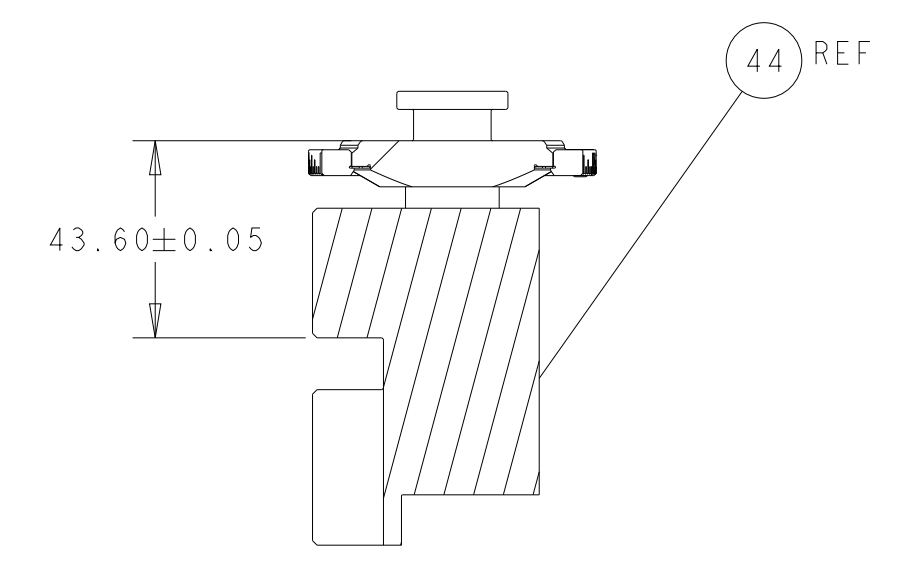
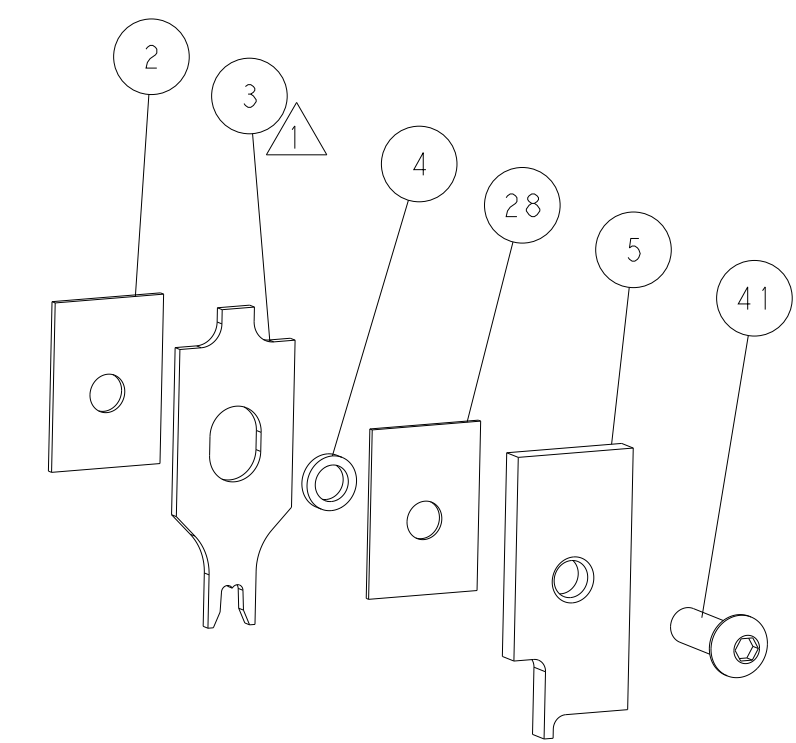
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



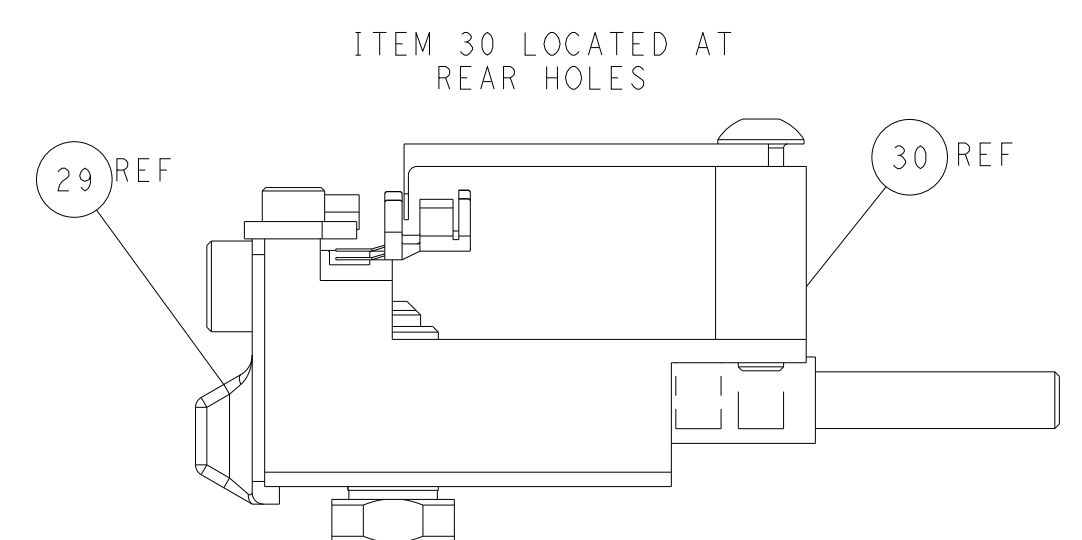
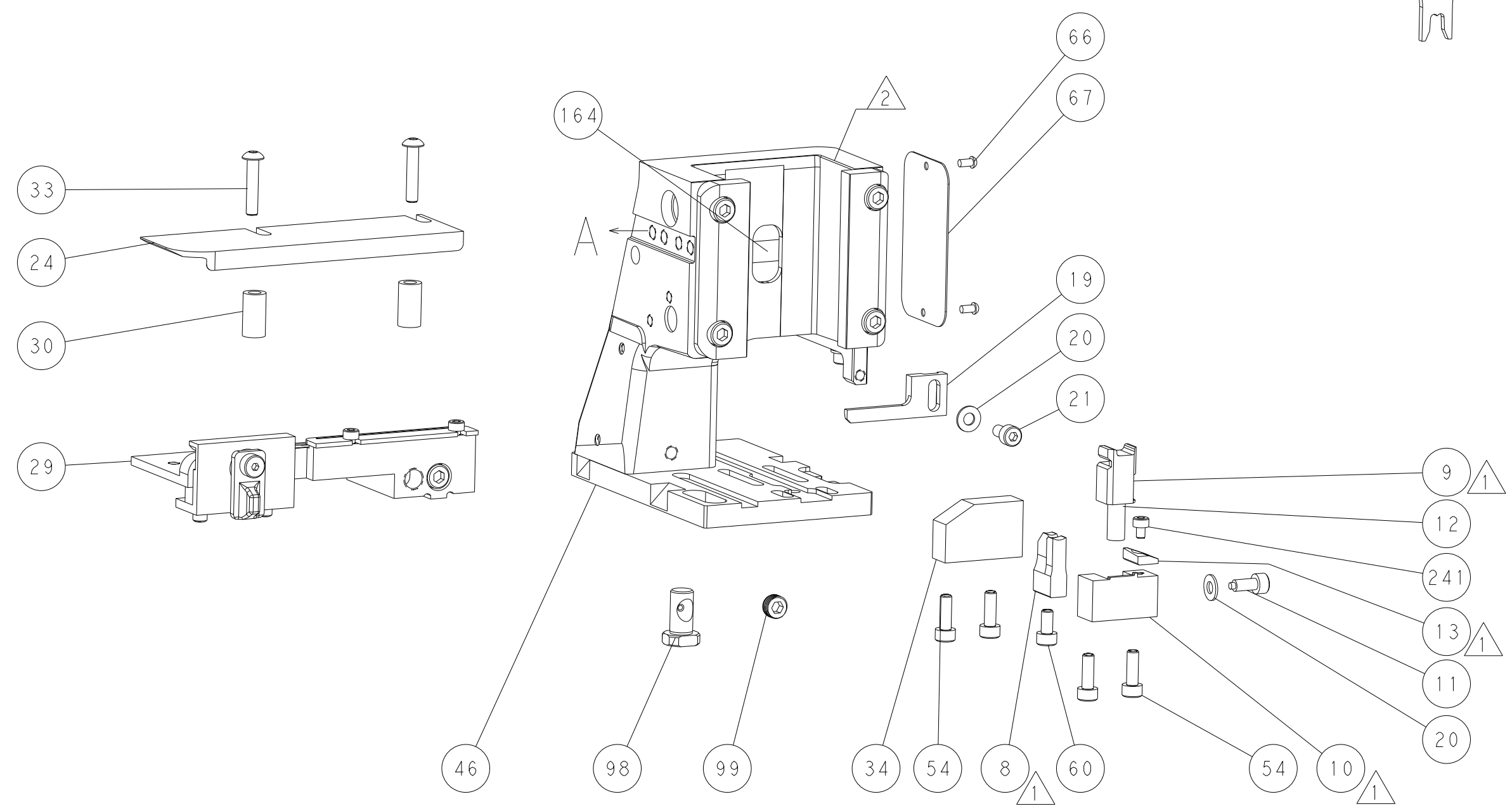
DETAIL A



TERMINAL SUPPORT LOCATION

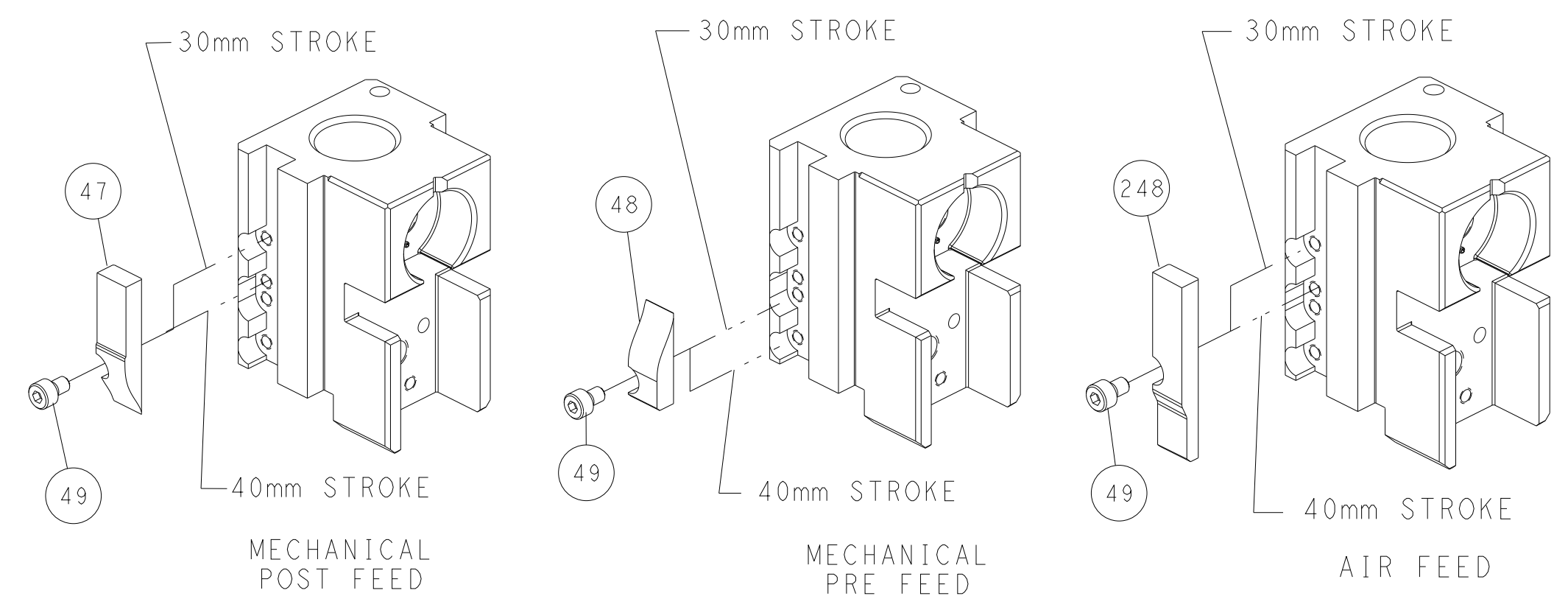


RAM SET-UP



ITEM 30 LOCATED AT REAR HOLES

CAM POSITIONS

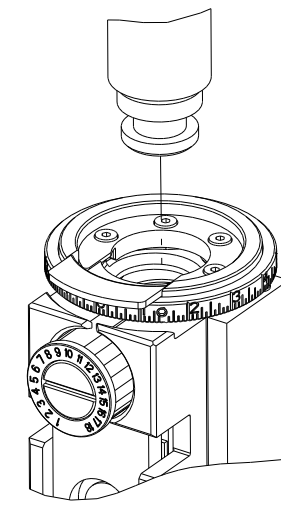


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN B. WEAVER 26FEB2015 CHK C. TOPPER 26FEB2015 APVD C. TOPPER 26FEB2015	NAME Ocean Side Feed Applicator	SIZE CAGE CODE DRAWING NO A1 00779 C=2266704	RESTRICTED TO -
DIMENSIONS: mm 0 PLC ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: ±0.5 ±0.13 ±0.013 ±0.0001	WEIGHT -	SCALE 1:2	SHEET 2 OF 4 REV C	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266704-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266704-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266704-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.33 mm [.210]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMPER SPECIFICATION	
TERMINAL NAME: .250 BLADE			
WIRE STRIP LENGTH 4.75-5.65 mm [1.87-.219 IN]		INSULATION DIAMETER RANGE Ø2.54-3.61 mm [1.00-.142 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1025	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
640416-1	640416-2	640416-3	640416-4

WIRE SIZE	CRIMP HEIGHT ***	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.49+/-0.05 [1.098+/-0.002]	5.7
16 AWG	2.31+/-0.05 [1.091+/-0.002]	7.4
18 AWG	2.21+/-0.05 [1.087+/-0.002]	9.0



- 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.

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	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-8	FEED PAWL	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	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-9	SPACER, CRIMPER	28
-	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	2119533-1	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	1	1633926-8	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	6-1803260-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-2	SPACER, CRIMPER	2
-	1	1	1-456411-5	CRIMPER, WIRE PREMIUM	1

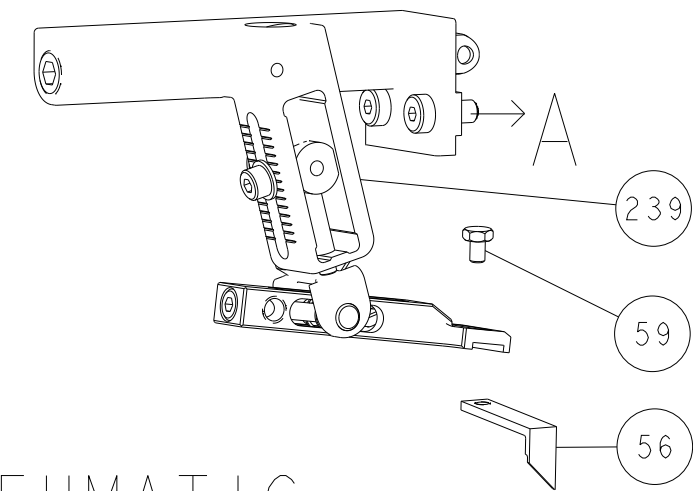
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mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0001	ANGLES ±.0001	FINISH

ITEM NO	DESCRIPTION	DATE	BY	CHK	APPV
-77	-22	-21	WEAVER	26FEB2015	TOPPER
			TOPPER	26FEB2015	TOPPER
			TOPPER	26FEB2015	TOPPER

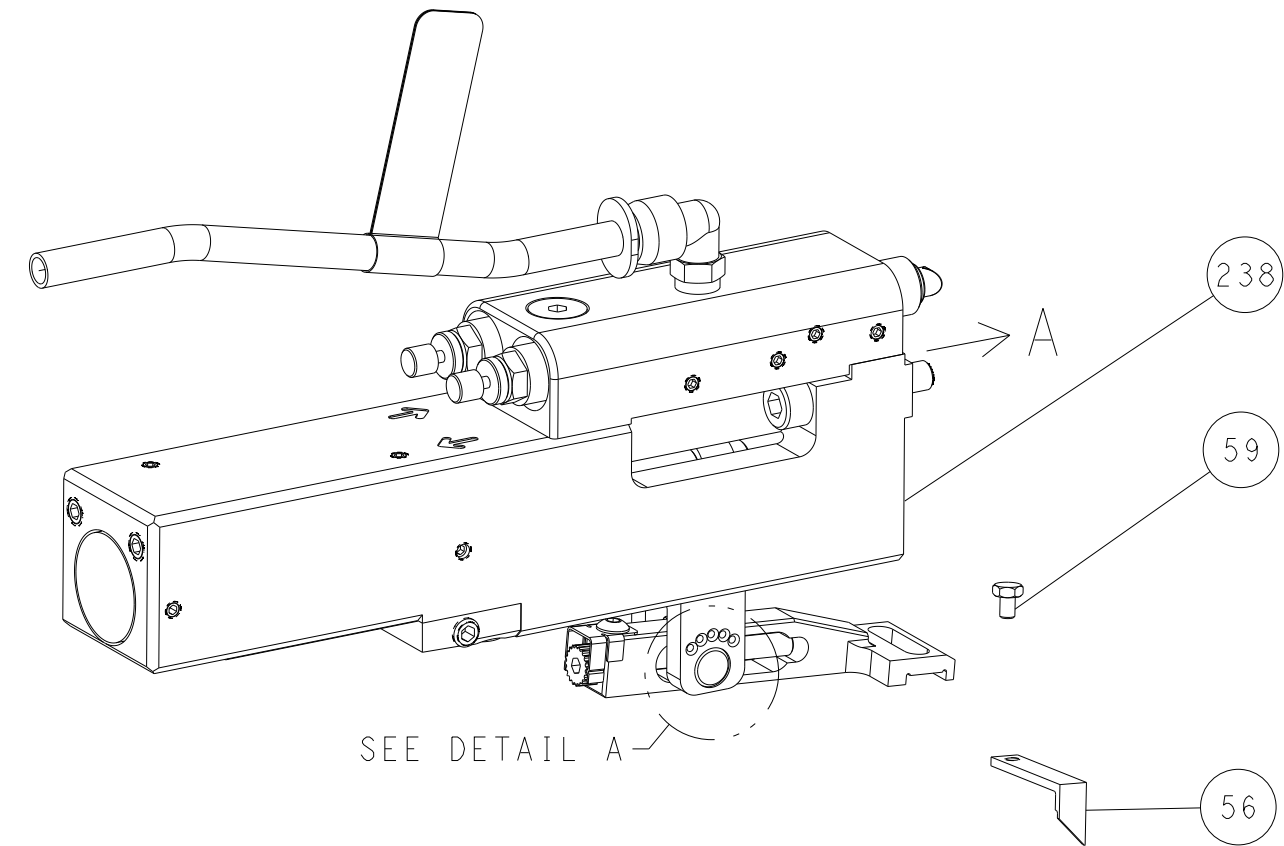
NAME	TE Connectivity
ADDRESS	Harrisburg, PA 17105-3608
PRODUCT SPEC	Ocean Side Feed Applicator
APPLICATION SPEC	
SIZE	A1
CAGE CODE	00779
DRAWING NO	2266704
SCALE	1:2
SHEET	3 OF 4
REV	C

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

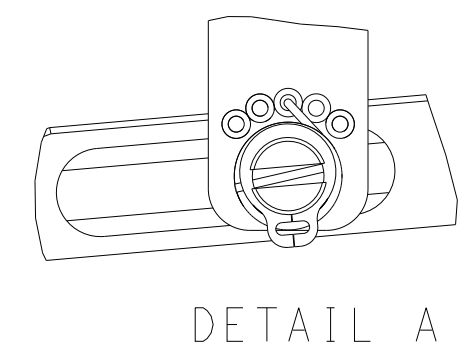
FEED TYPE MECHANICAL



PNEUMATIC

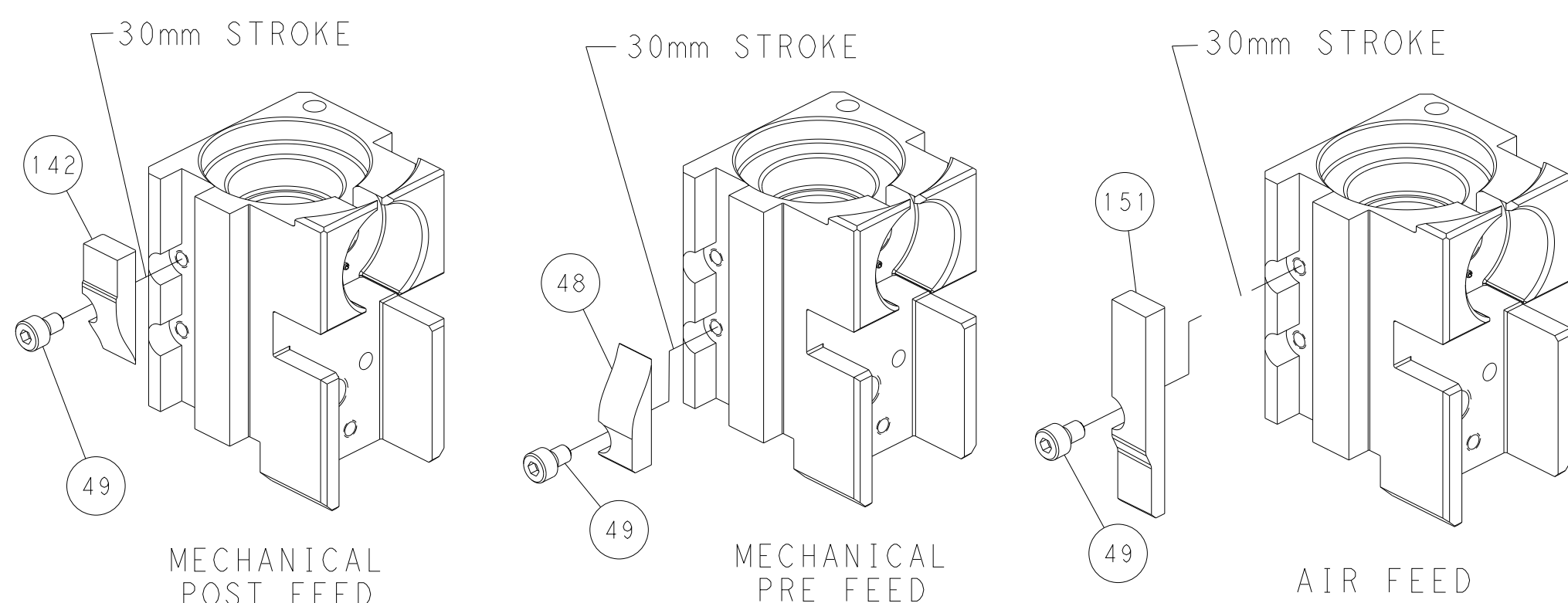


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

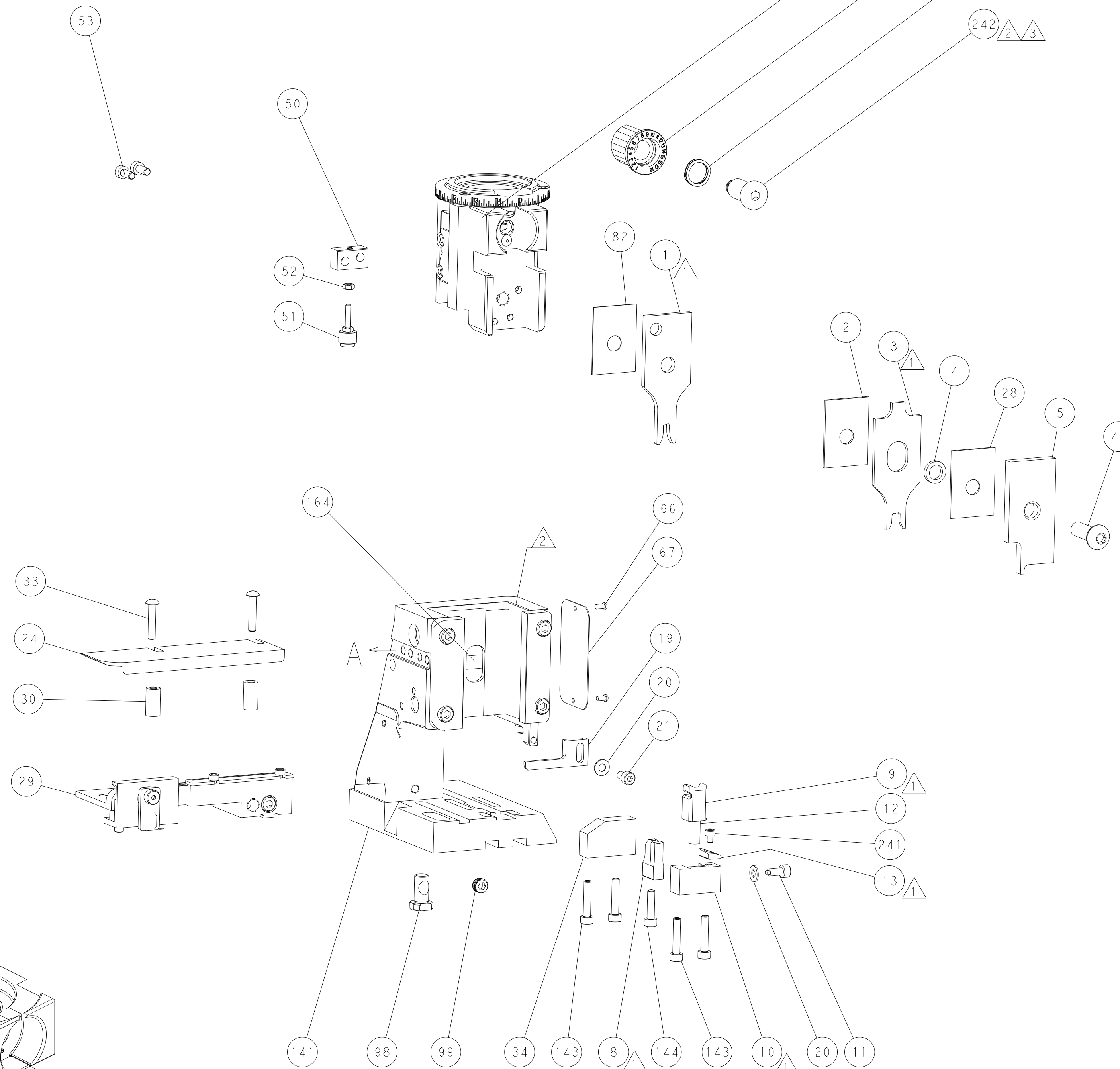
CAM POSITIONS



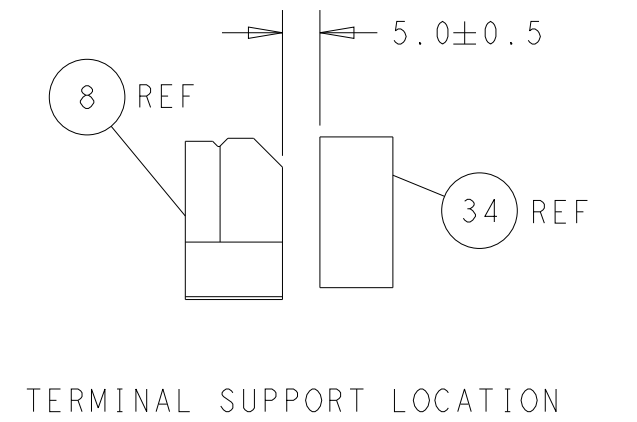
MECHANICAL POST FEED

MECHANICAL PRE FEED

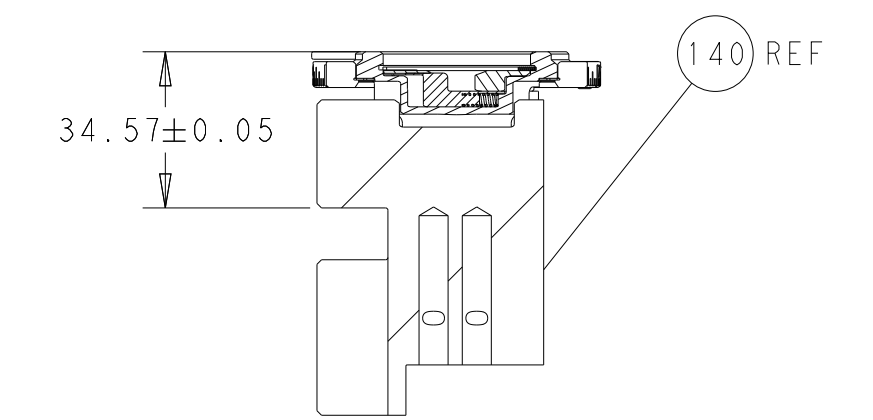
AIR FEED



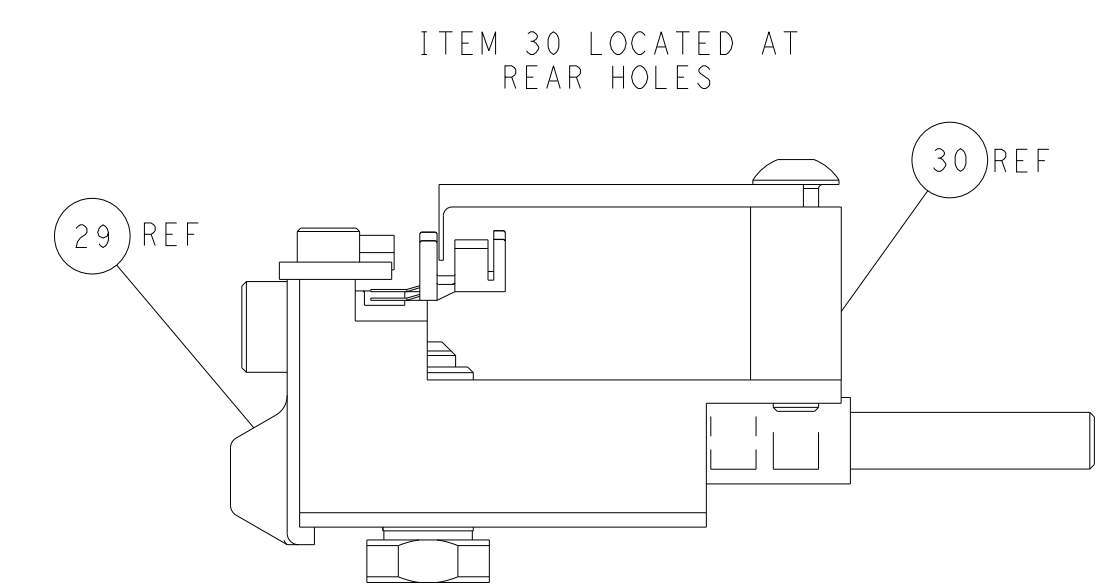
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.5 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES FINISH ±.	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO A1 00779 C=2266704 SHEET 4 OF 4 REV C