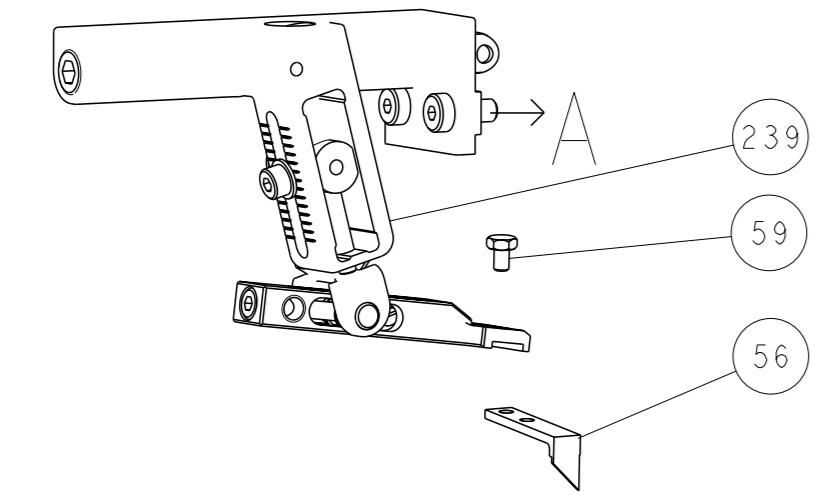


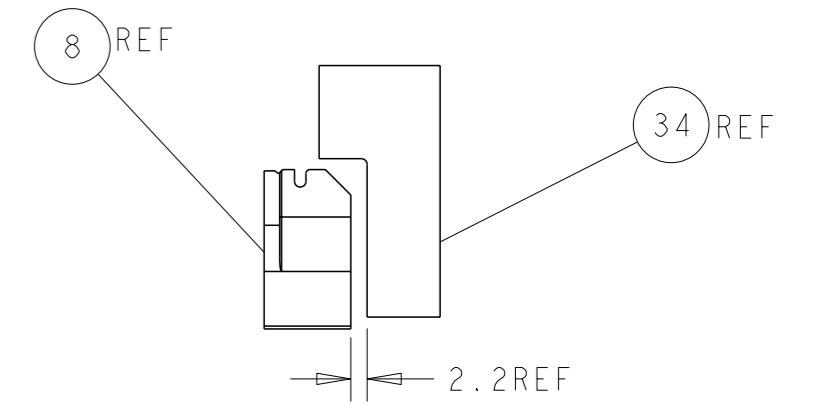
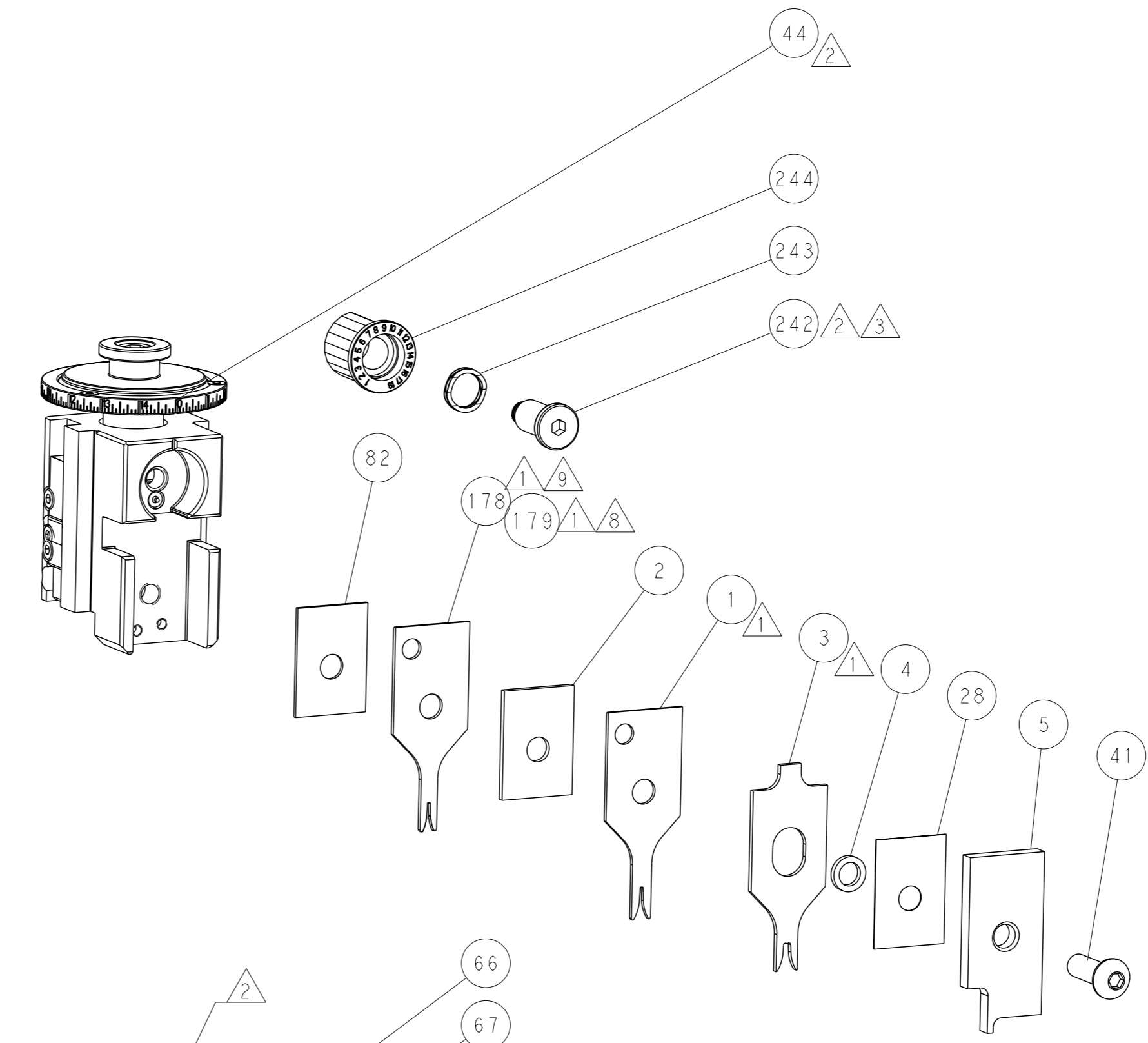
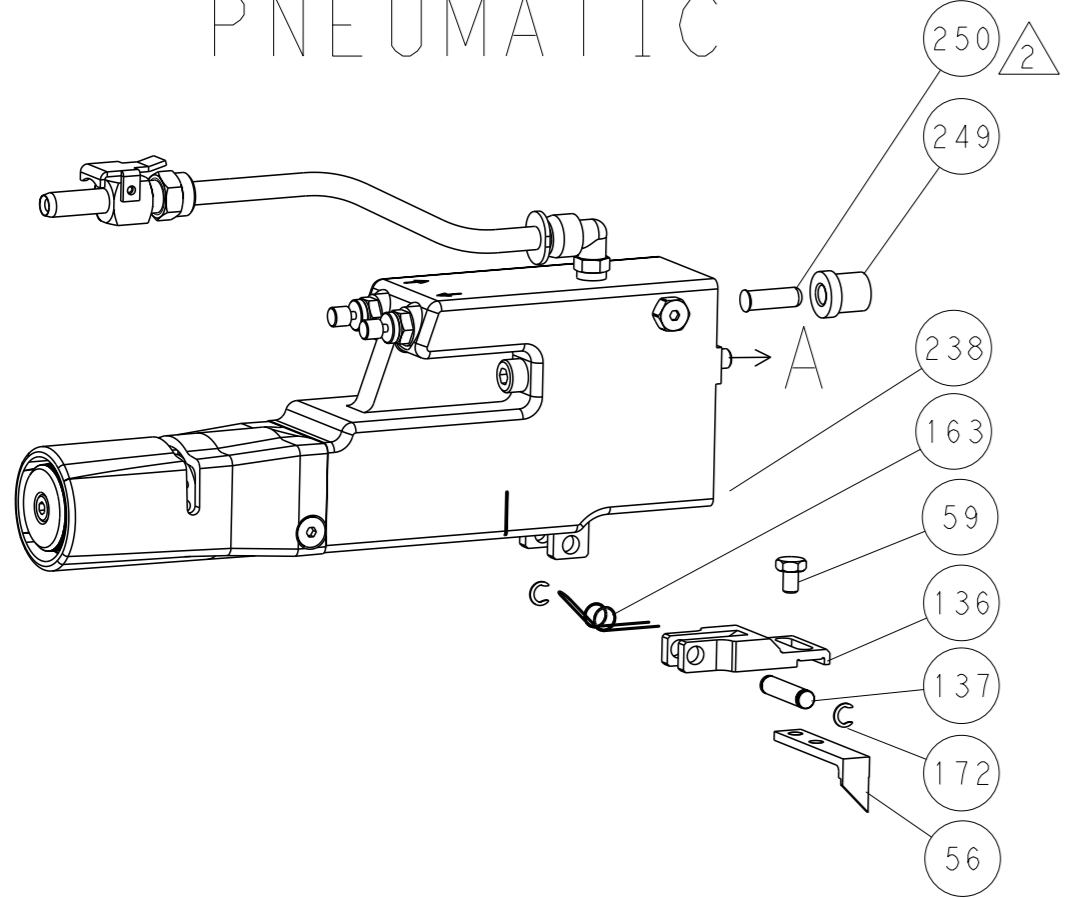


LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

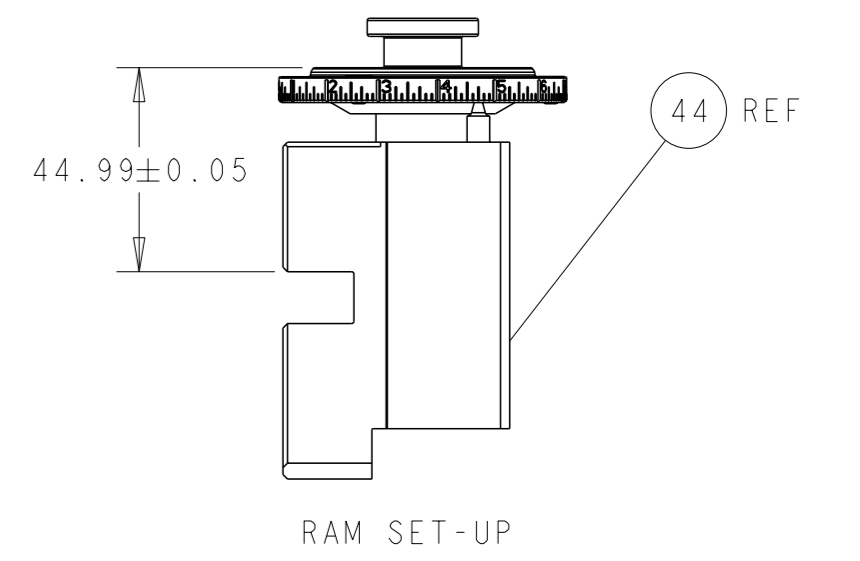
# FEED TYPE MECHANICAL



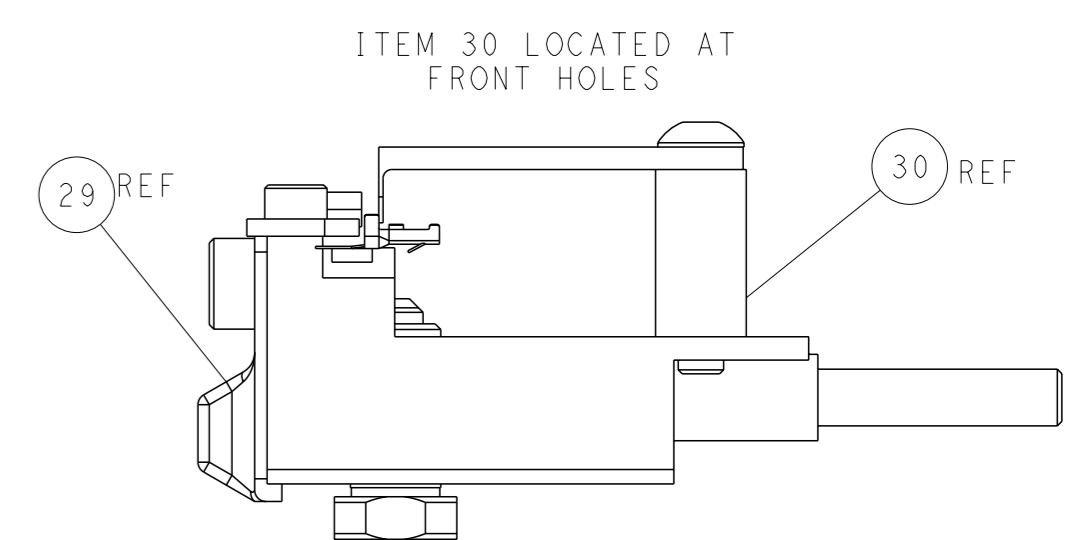
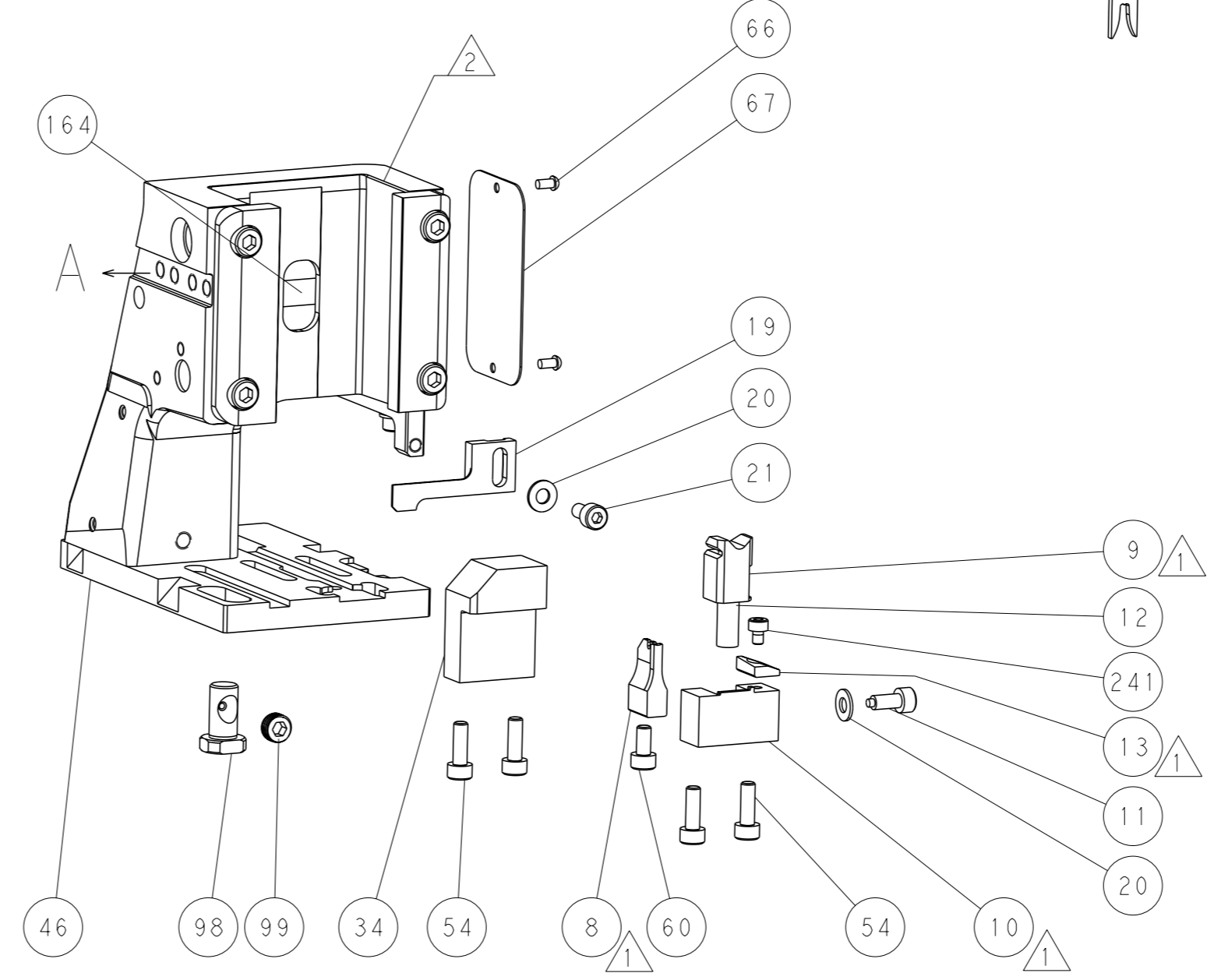
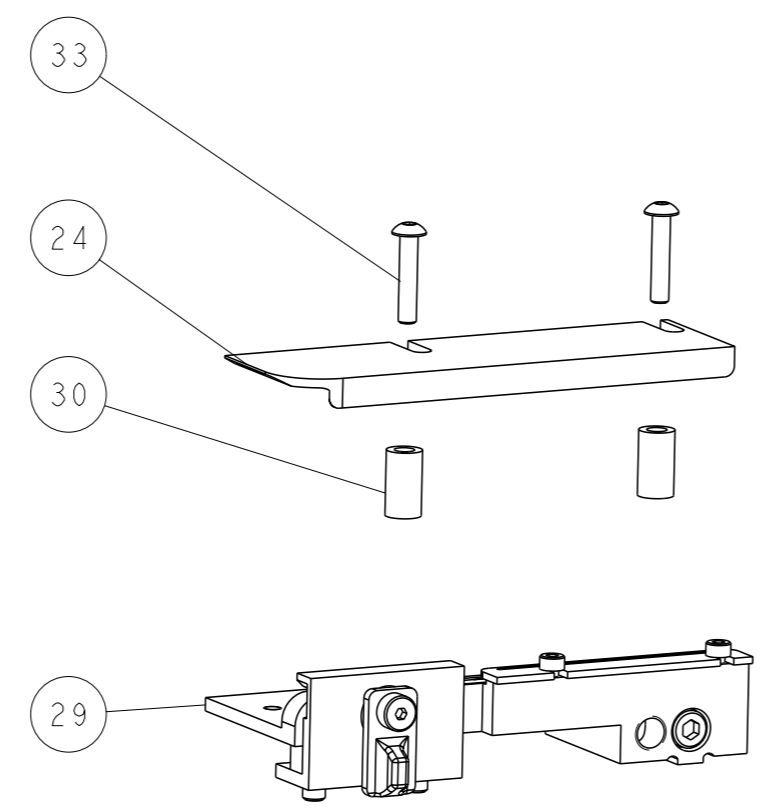
# PNEUMATIC



TERMINAL SUPPORT LOCATION

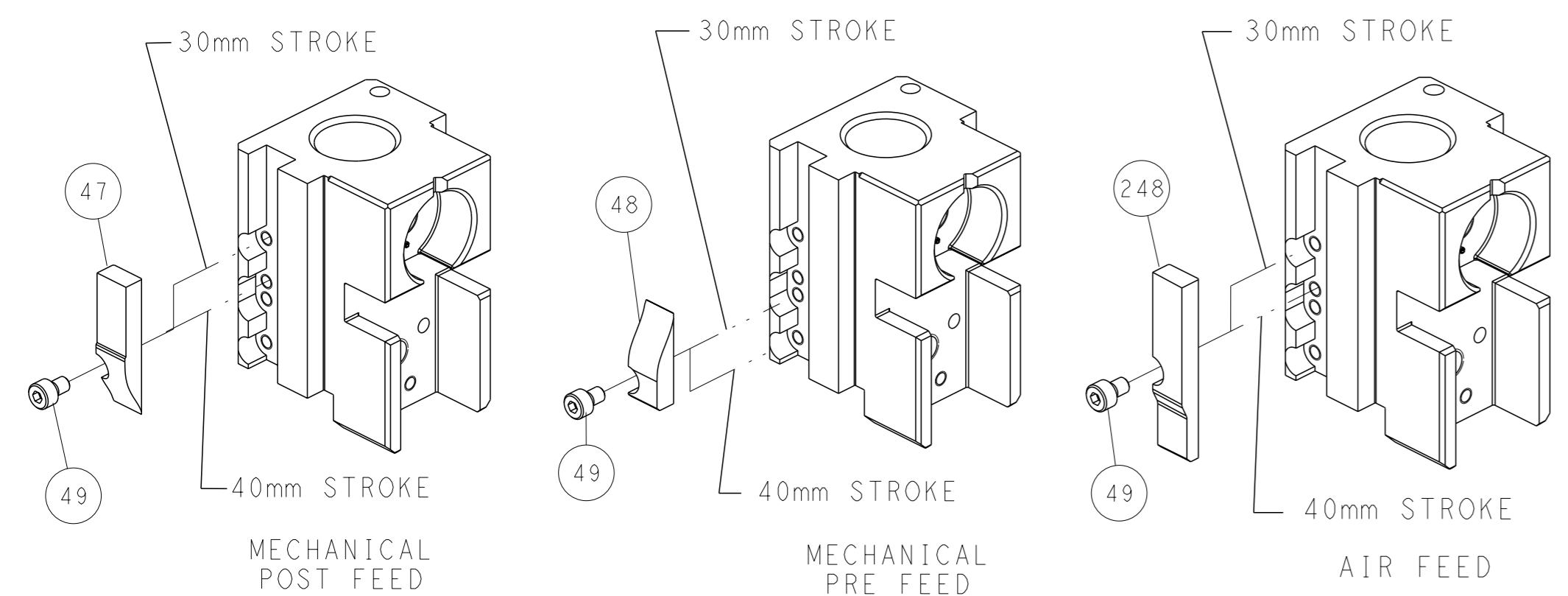


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

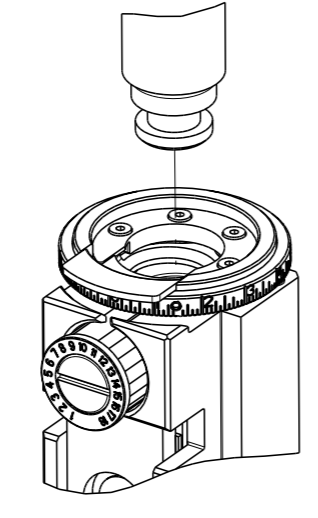


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND RESTRICTION DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: HOFFNER CHK: T. ELBIN APVD: T. ELBIN DATE: 3 JUNE 2014 DATE: 4 JUNE 2014 DATE: 4 JUNE 2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266321 SCALE: 1:2 SHEET: 2 of 4 REV: D
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH	WEIGHT: - MATERIAL: -	RESTRICTED TO: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266321-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266321-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266321-*	-	SEE CRIMP TOOLING KITS BELOW	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER

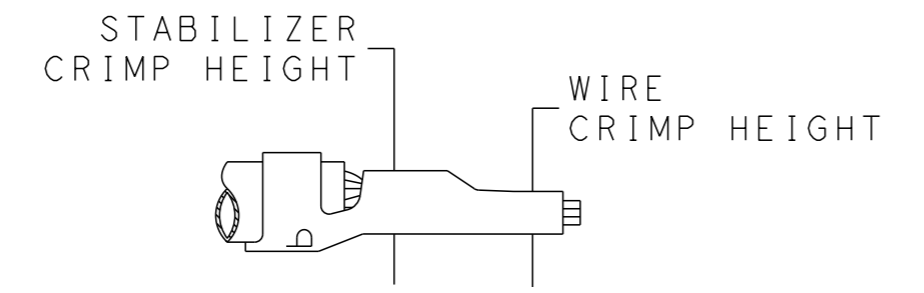


APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	1.07 mm [.042]	F
STABILIZER	1.07 mm [.042]	F
INSULATION	2.79 mm [.110]	F

APPLICATOR INSTRUCTIONS  
 408-35042

PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2266321-7	B	22 AWG	9-1633609-5	4-456401-4	2-2119582-1	1633916-6
7-2266321-8	B	24-26 AWG	9-1633609-4	4-456401-4	2-2119582-1	1633916-6

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.45-5.21 mm [.175-.205 IN]	Ø1.02-2.54 mm [.040-.100 IN]		
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-640401-1			



WIRE SIZE	CRIMP HEIGHT mm [INCH]	STABILIZER CRIMP HEIGHT	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.89+/-0.05 [.035+/- .002]	1.02±0.05 (0.40±.002)	6.7
24-26 AWG	0.74+/-0.05 [.029+/- .002]	1.02±0.05 (0.40±.002)	6.5

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 UNLESS OTHERWISE SPECIFIED SET UP THE APPLICATOR FOR THE 24 OR 26 AWG WIRE USING ITEM 178. THE ADDITIONAL WIRE CRIMPER ITEM 179 NEEDS TO BE SENT WITH THE APPLICATOR TO CRIMP THE 22 AWG WIRE.
- 8 ITEMS 179 TO BE USED WITH 22 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- 9 ITEMS 178 TO BE USED WITH 24-26 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.

**\*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					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

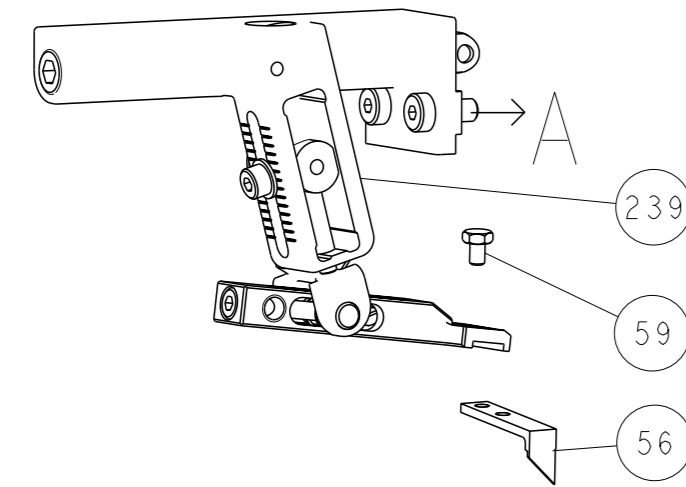
-	-	1	-	2119640-1	PUSH ROD, AIR FEED		250
-	-	1	-	1803259-1	BUSHING, FLANGED		249
-	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	-	1	1	2119083-1	RETAINER, INSULATION DIAL		242
-	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	-	-	1	2063440-1	AIR FEED MODULE		238
-	-	1	1	9-1633609-5	CRIMPER, WIRE		179
1	-	1	1	9-1633609-4	CRIMPER, WIRE		178
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT		172
-	-	-	REF	994970-2	COUNTER, MAGNETIC		164
-	-	-	1	240638-1	SPRING, FEED FINGER		163
-	-	-	1	2119641-2	FEED CAM, AIR FEED		151
-	-	-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		144
-	-	-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		143
-	-	-	-	2119653-2	FEED CAM, POST FEED		142
-	-	-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	-	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC		140
-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854		137
-	-	-	1	2119799-1	HOLDER, FEED FINGER, AF		136
-	-	-	1	2844908-1	SCREW, LOCKING		99
-	-	-	1	2844907-1	POST, LOCKING		98
-	-	-	1	1-455888-0	SPACER, CRIMPER		82
-	-	-	1	1803607-1	DOCUMENTATION PACKAGE		71
-	-	-	1	2119740-1	TAG, IDENTIFICATION		67
-	-	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	-	-	1	1338685-1	PAWL, FEED		56
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	-	-	1	2119652-1	FEED CAM, PRE FEED		48
-	-	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	-	-	1	469465-4	STOP, WIRE		34
-	-	-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	-	-	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	-	-	1	2844992-1	ASSEMBLY, STRIP GUIDE		29
-	-	-	1	455888-3	SPACER, CRIMPER		28
-	-	-	1	1320928-2	STRIP GUIDE		24
-	-	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	-	-	2	1-18028-2	WASHER, FLAT, REG M4		20
-	-	-	1	2119533-3	STRIPPER, SIDE FEED		19
-	-	-	1	2119806-1	INSERT, SHEAR		13
-	-	-	1	3-22280-3	SPRING, COMPRESSION		12
-	-	-	1	1-356885-4	STOP, SHEAR		11
-	-	-	1	2119805-1	SHEAR HOLDER, FRONT		10
-	-	-	1	1803095-1	FLOATING SHEAR, FRONT		9
-	-	-	1	1633916-6	ANVIL, COMBINATION		8
-	-	-	-	-	-		7
-	-	-	-	-	-		6
-	-	-	1	2119757-4	DEPRESSOR, SHEAR		5
-	-	-	1	2-238011-2	BLOCK, CRIMPER SPACER		4
-	-	-	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM		3
-	-	-	1	1-455888-8	SPACER, CRIMPER		2
-	-	-	1	4-456401-4	CRIMPER, WIRE .042 F PREMIUM		1

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

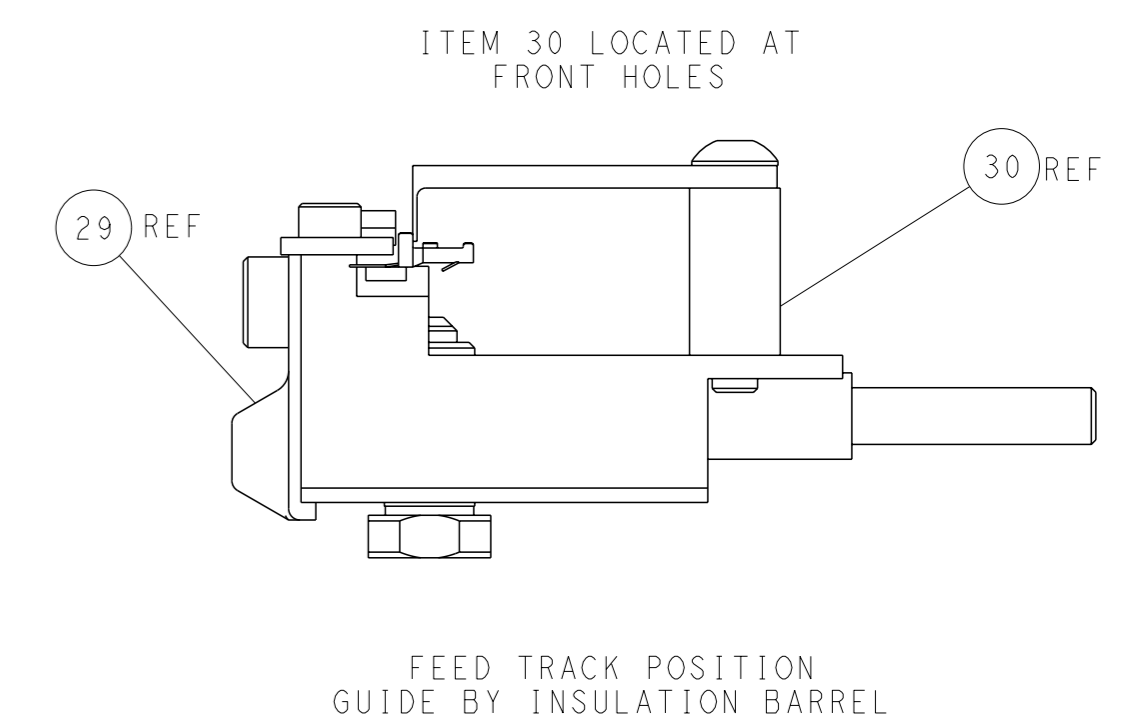
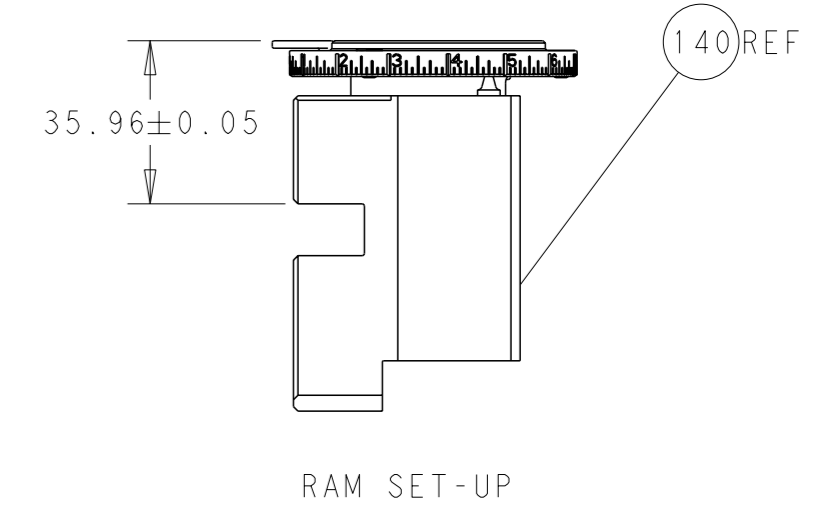
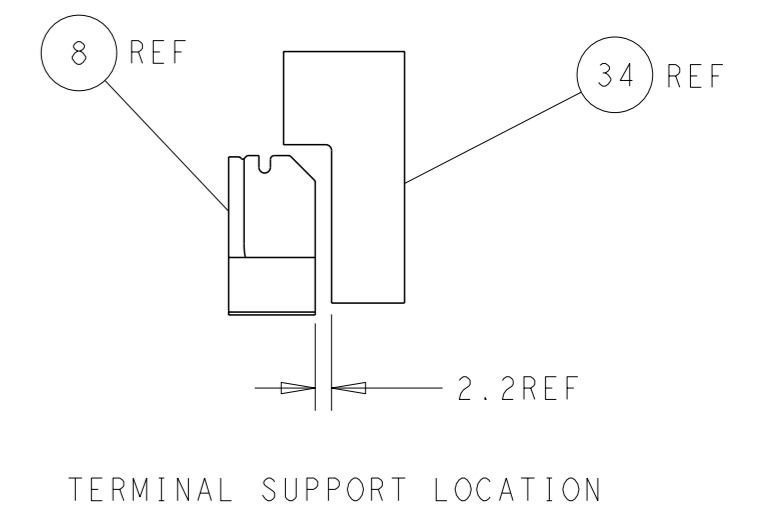
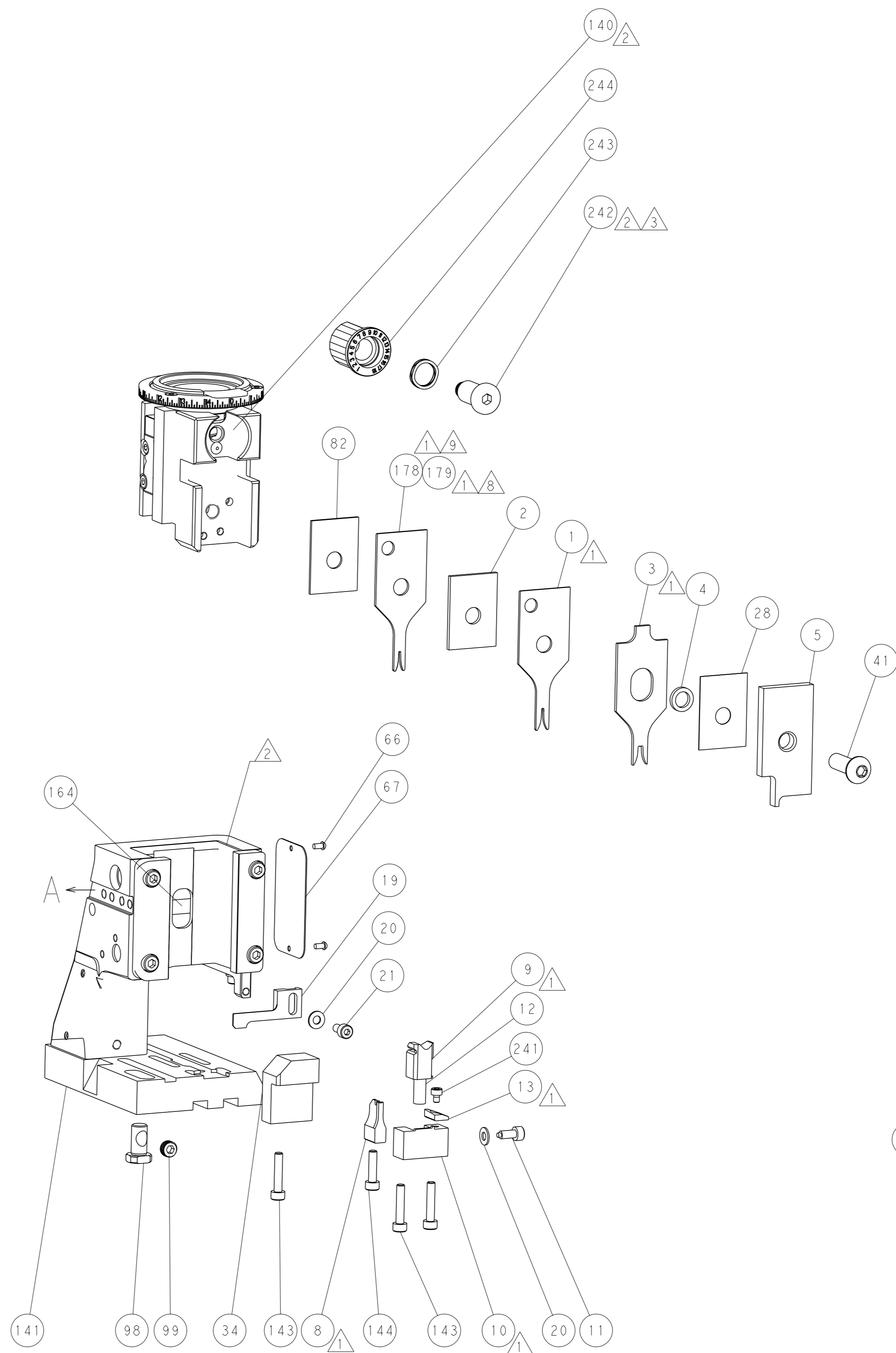
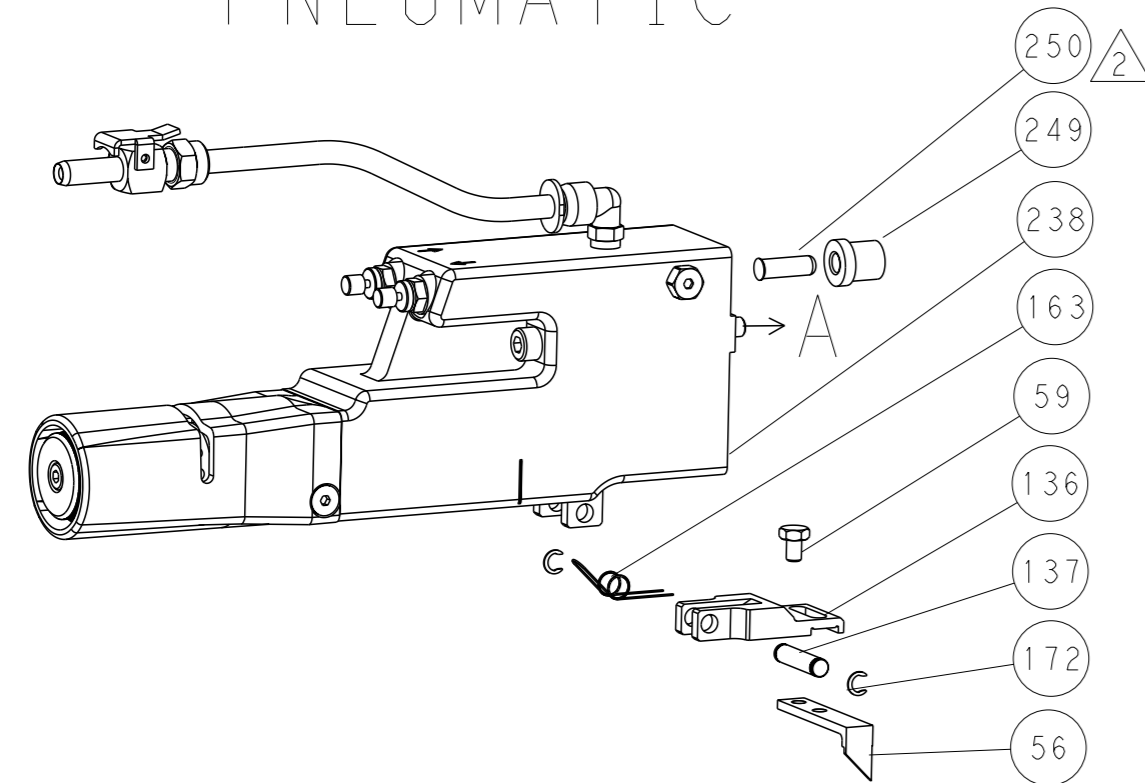
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: HOFFNER 3 JUNE 2014 CHK: T. ELBIN 4 JUNE 2014 APVD: T. ELBIN 4 JUNE 2014		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266321		RESTRICTED TO: - SCALE: 1:2 SHEET: 3 of 4 REV: D	
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LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

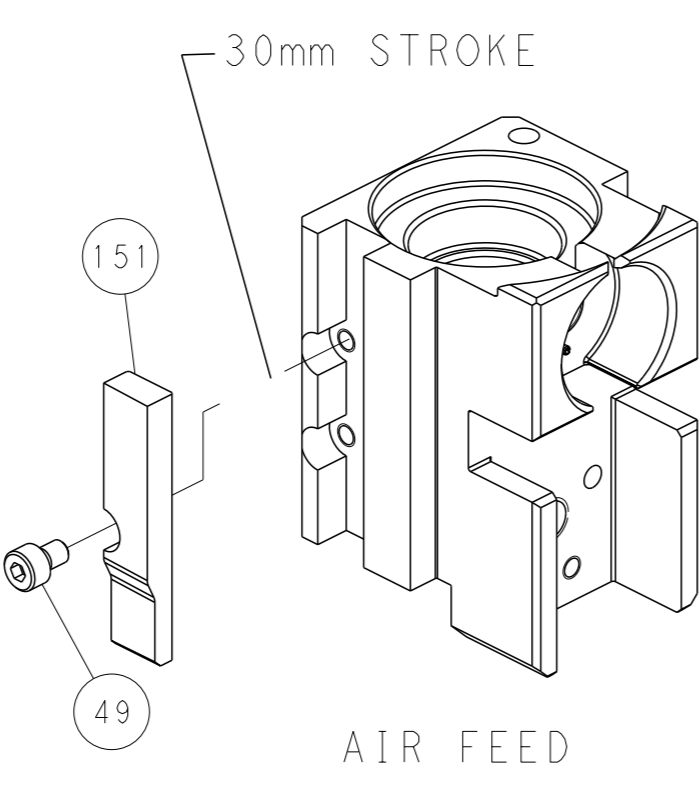
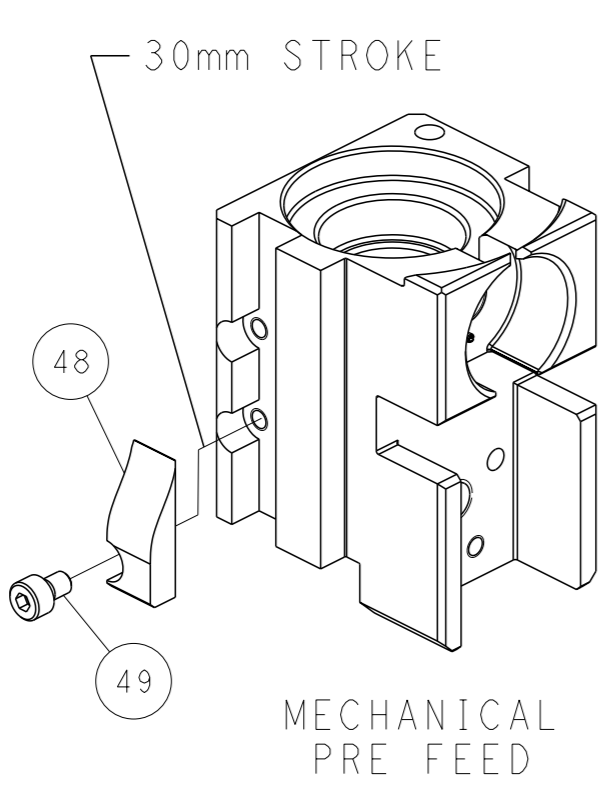
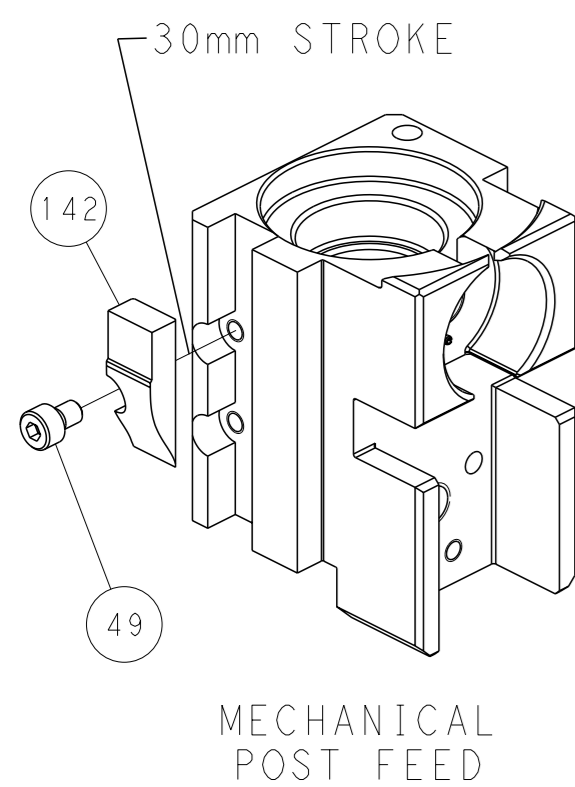
# FEED TYPE MECHANICAL



# PNEUMATIC



# CAM POSITIONS



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±*		WEIGHT: - Customer Accessible Production Drawing	RESTRICTED TO: -	