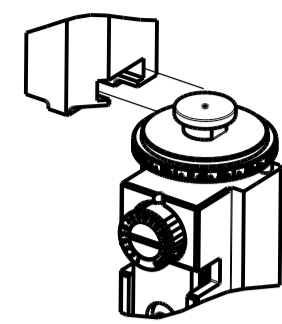


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266096-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266096-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266096-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	4.83 mm [.190]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 6.3 CB CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-5.51 mm [.217-.217 IN]		Ø3.40-4.30 mm [.134-.169 IN]	
TERMINAL APPLICATION SPECIFICATION		114-18944	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2177771-1	2177771-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.45 +/- 0.05 [.096 +/- .002]	8.8
5.00mm2	2.26 +/- 0.05 [.089 +/- .002]	10.7



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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	REV	DATE	BY	APPV
		A	RELEASED	08JAN2014	KS TE
		A1	ECR-16-013945	30SEP2016	MZ JDG
		B	ECR-21-005938	01JUN2021	FJ TE

-	1	1	1803078-3	SPACER, PRECISION	259
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	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	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	22278-9	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	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	1803095-6	FLOATING SHEAR, FRONT	9
1	2	1	6-1633927-4	ANVIL, COMBINATION	8
-	1	1	1-240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119780-4	DEPRESSOR, SHEAR	5
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	2	1	8-2119784-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
1	2	1	456414-3	CRIMPER, WIRE	1
-	77	-72	-2	PART NO	ITEM NO

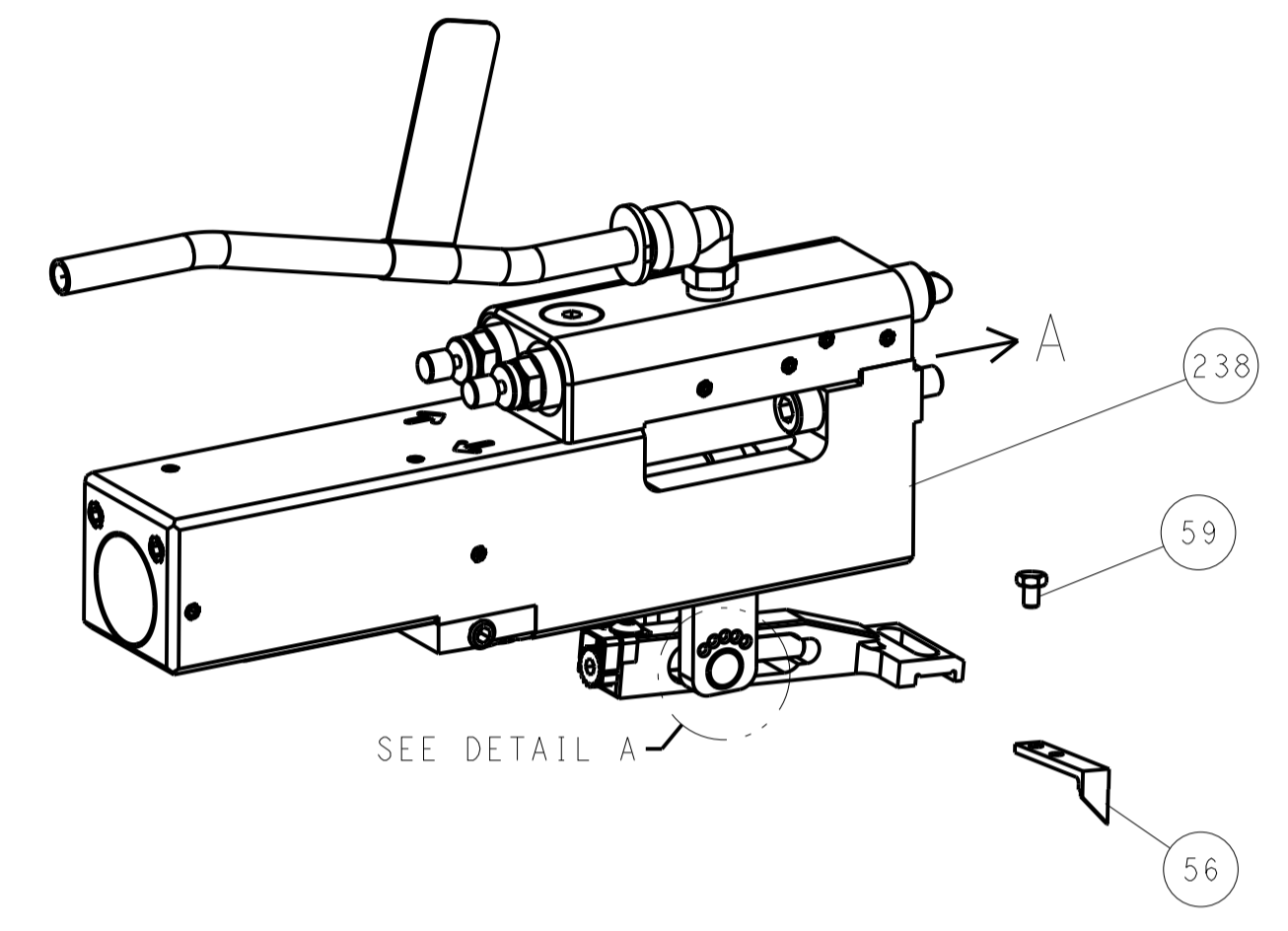
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: 26OCT2013		CHK: STAKEM		APVD: G. BAILEY		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001		APVD: T. ERLIN		26OCT2013		NAME: Ocean Side Feed Applicator		RESTRICTED TO	
MATERIAL:		FINISH:		WEIGHT:		A1 00779		C=2266096		SCALE: 1:2 SHEET 1 OF 4 REV B	
Customer Accessible Production Drawing										Customer Accessible Production Drawing	

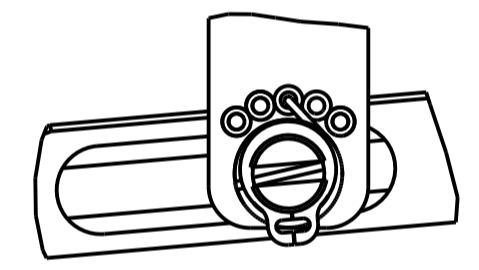
LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

# FEED TYPE

## PNEUMATIC

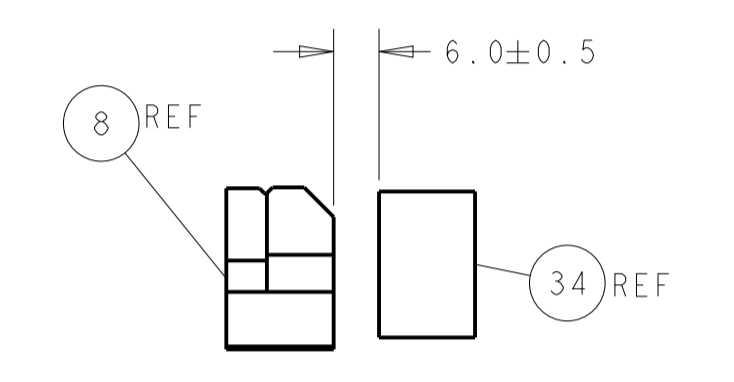
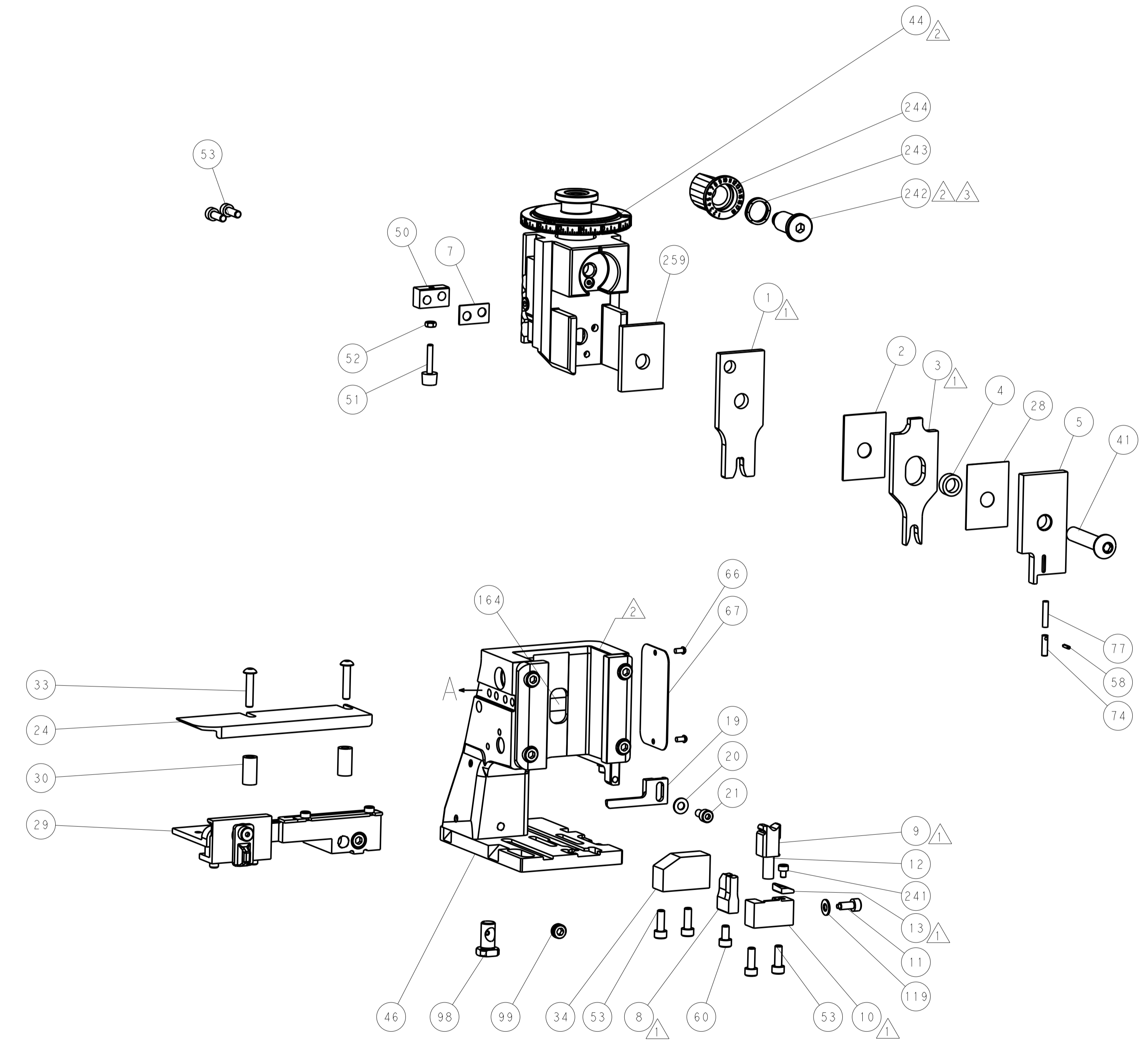
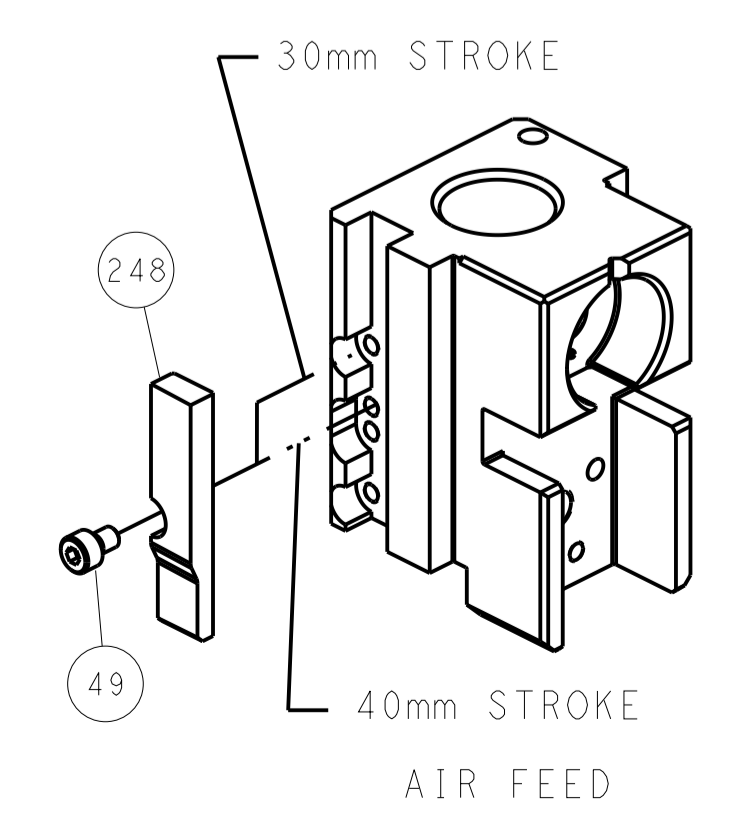


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

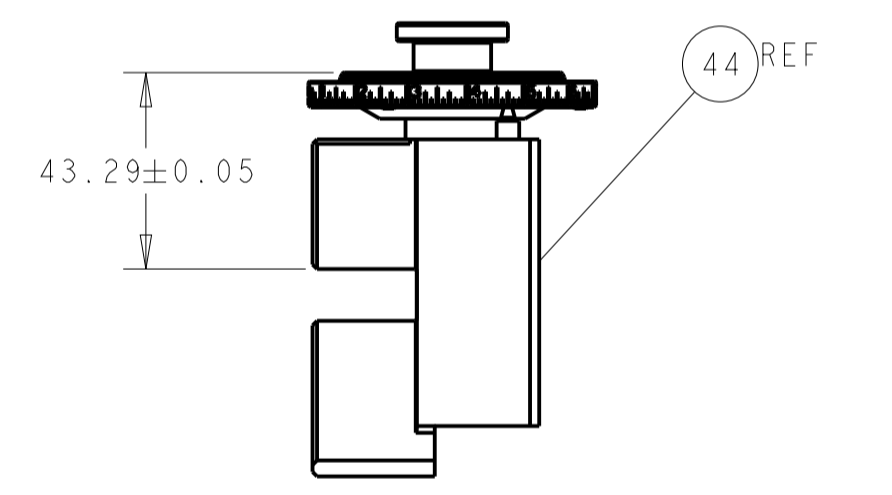


DETAIL A

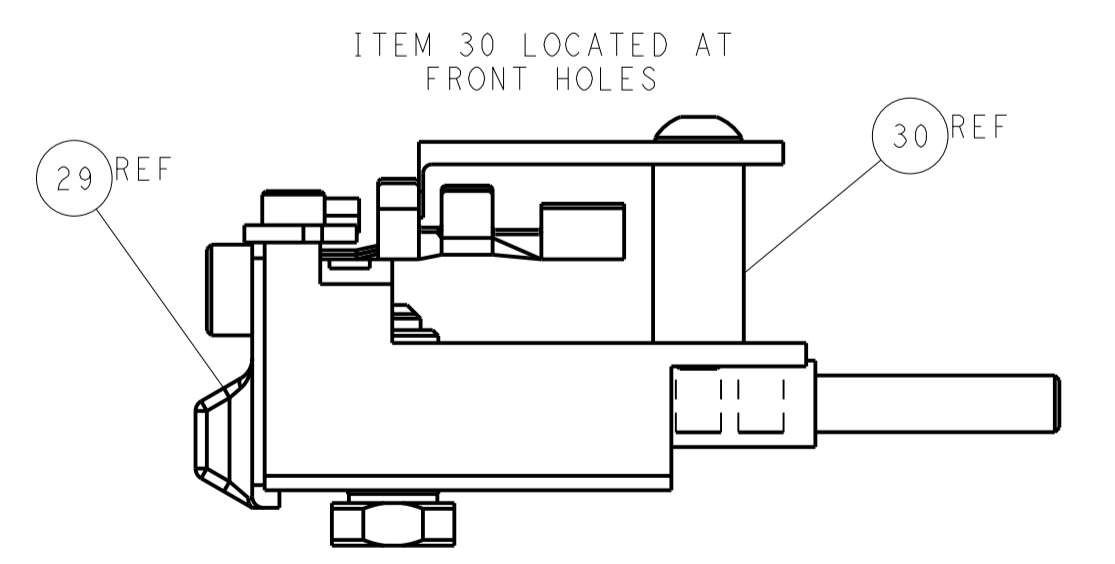
## CAM POSITION



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



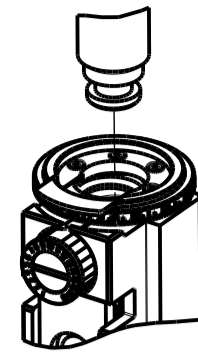
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: STAKEM 26OCT2013 CHK: G. BAILEY 26OCT2013 APVD: T. FIRIN 26OCT2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.0001		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266096	RESTRICTED TO: SCALE: 1:2 SHEET: 2 of 4 REV: B
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266096-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266096-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	4.83 mm [.190]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 6.3 CB CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-5.51 mm [1.217-.217 IN]		Ø3.40-4.30 mm [1.134-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18944	-	-
TERMINALS APPLIED <sup>5</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2177771-1	2177771-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.45 +/- 0.05 [1.096 +/- .002]	8.8
5.00mm2	2.26 +/- 0.05 [1.089 +/- .002]	10.7



- <sup>1</sup> RECOMMENDED SPARE PARTS
  - <sup>2</sup> REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
  - <sup>3</sup> APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
  - <sup>4</sup> 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.
  - <sup>5</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
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.

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

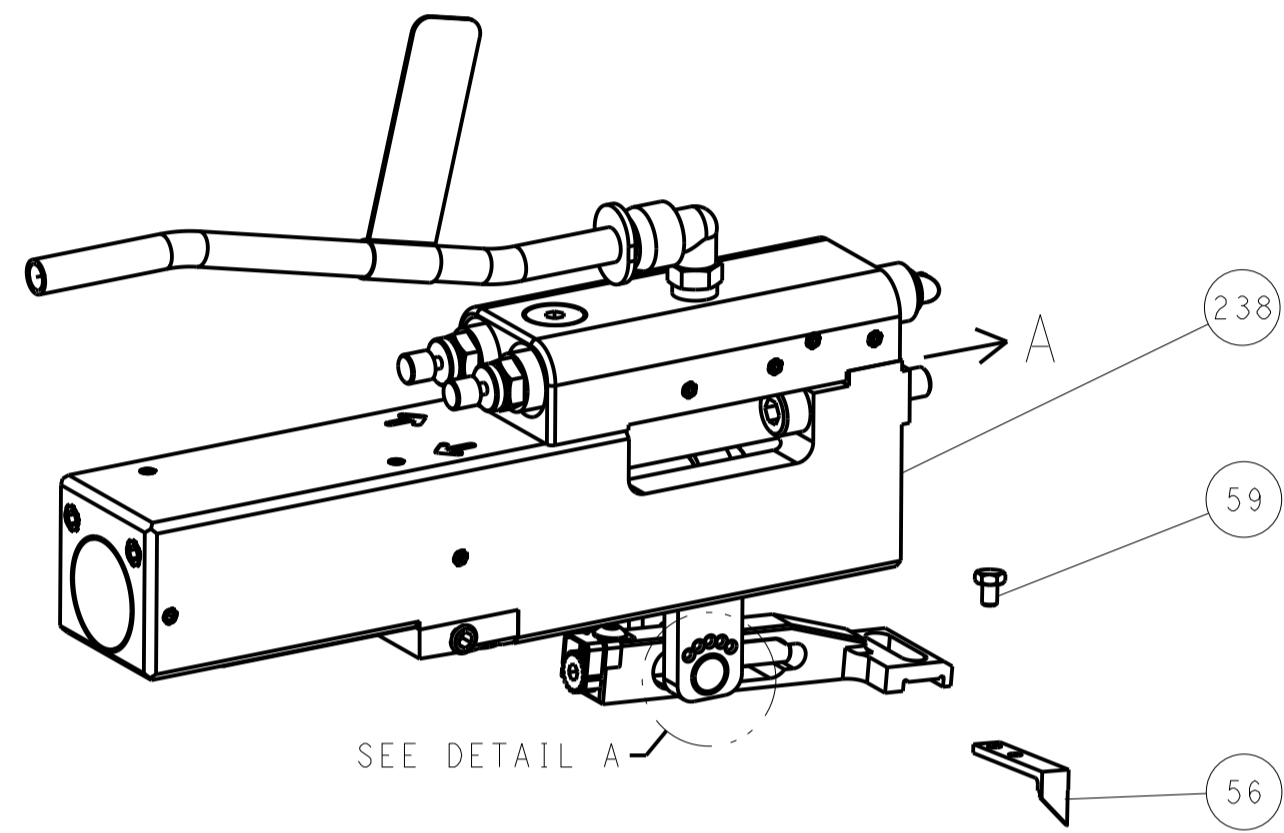
LOC	DIST	REV	DATE	BY	APPV
A	66				

		REVISIONS			
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	1803078-3			259
-	1	2119082-9			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	7-18023-7			241
-	1	2844940-1			238
-	REF	994970-2			164
-	1	2119641-2			151
-	1	2168083-8			144
-	4	2168083-9			143
-	1	1-1803583-0			141
-	1	1803516-2			140
-	1	1-18028-2			119
-	1	2844908-1			99
-	1	2844907-1			98
-	1	22278-9			77
-	1	854769-4			74
-	1	1803607-3			71
-	1	2119740-1			67
-	2	2168078-1			66
-	1	5-18022-5			59
-	1	21028-2			58
-	1	1338685-1			56
-	2	2168083-3			53
-	1	5018030-1			52
-	1	811242-5			51
-	1	690753-2			50
-	1	18023-9			49
-	1	1803602-2			41
-	1	1752356-3			34
-	2	2079383-5			33
-	2	3-2844962-2			30
-	1	2844992-1			29
-	1	455888-3			28
-	1	1320928-2			24
-	1	2168083-2			21
-	1	1-18028-2			20
-	1	2119533-1			19
-	1	2119806-1			13
-	1	3-22280-3			12
-	1	1-356885-4			11
-	1	2119805-1			10
-	1	1803095-6			9
-	1	6-1633927-4			8
-	1	1-240641-9			7
-	-	-			6
-	1	1-2119780-4			5
-	1	238011-3			4
-	1	8-2119784-5			3
-	1	455888-8			2
-	1	456414-3			1
-77	-22	PART NO			ITEM NO

<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF STACOM AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. PERMISSION TO REPRODUCE THIS DRAWING FOR THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: STAKEM 26OCT2013 CHK: G. BAILEY 26OCT2013 APVD: T. ERLIN 26OCT2013	NAME: Ocean Side Feed Applicator SIZE: A   CAGE CODE: 00779   DRAWING NO: 2266096 SCALE: 1:2   SHEET: 3 OF 4   REV: B
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.01	PRODUCT SPEC: APPLICATION SPEC: FINISH:	RESTRICTED TO: Customer Accessible Production Drawing

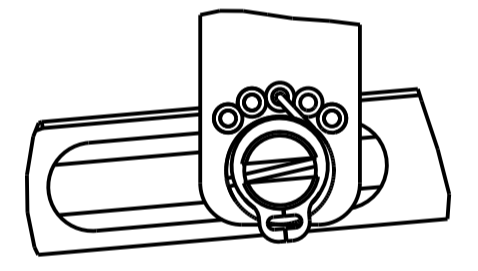
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

### FEED TYPE PNEUMATIC



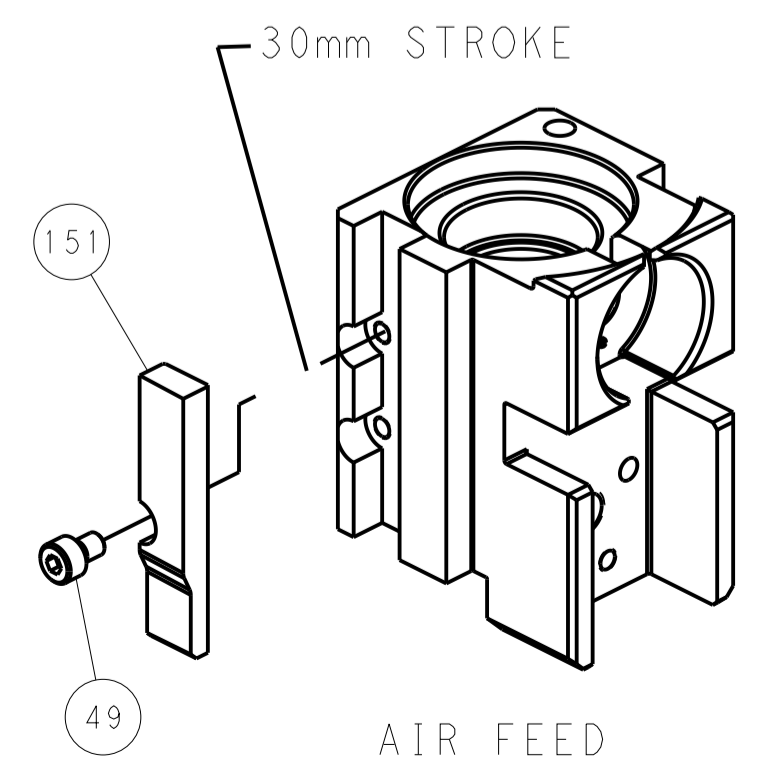
SEE DETAIL A

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

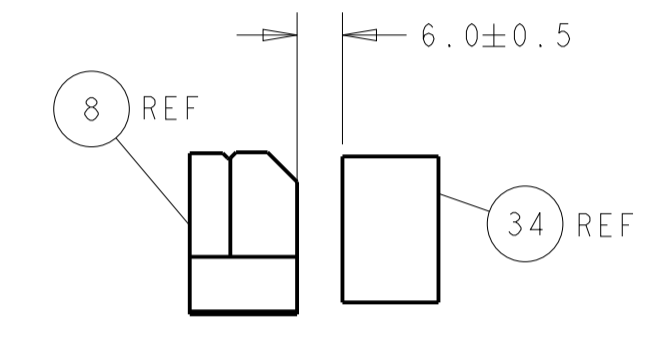
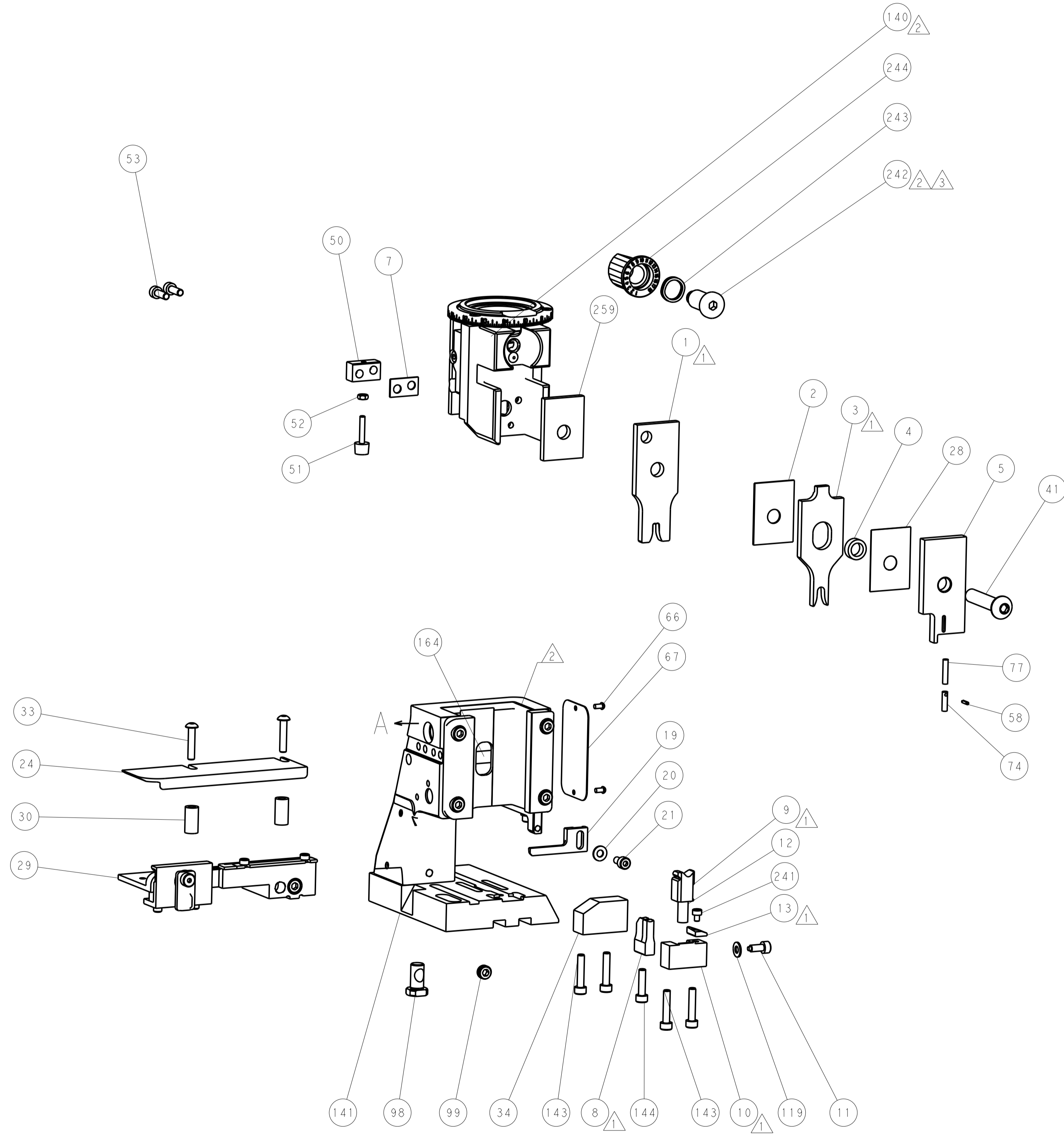


DETAIL A

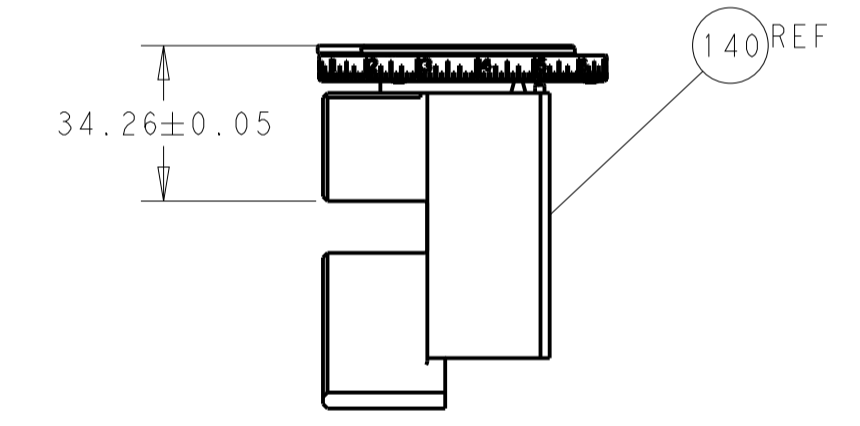
### CAM POSITION



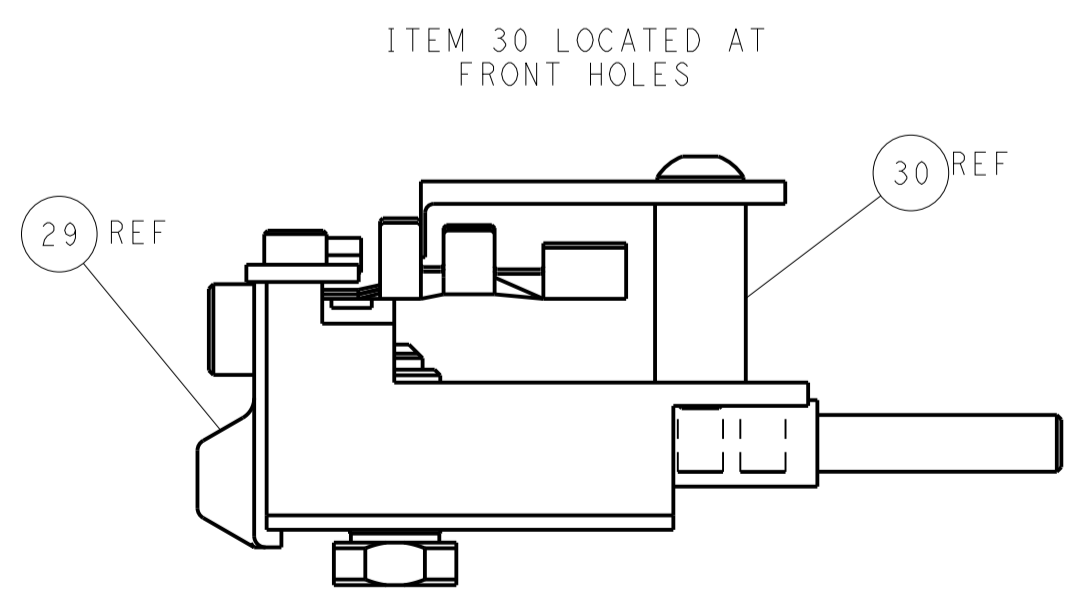
AIR FEED



TERMINAL SUPPORT LOCATION



HOLDDOWN 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: STAKEM 26OCT2013		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	4 PLC ±0.001	APVD: G. BAILEY 26OCT2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME: Ocean Side Feed Applicator	
				APPLICATION SPEC:		SIZE: CAGE CODE DRAWING NO: 00779 C=2266096	
				WEIGHT:		RESTRICTED TO: Customer Accessible Production Drawing	
				SCALE: 1:2		SHEET 4 OF 4 REV B	