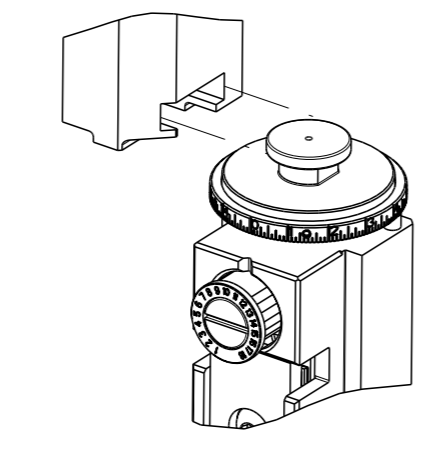


8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT © 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2266077-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2266077-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2266077-7	E	CRIMP TOOLING KIT	-				

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

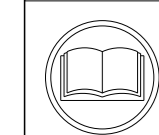


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm [.176]	D
INSUL	5.54 mm [.218]	PIDG

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ULTRA FAST PLUS FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.73-7.54 mm [.265-.297 IN]		Ø 1.52-3.43 mm [.060-.135 IN]	
TERMINAL APPLICATION SPECIFICATION		114-2123	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520405-2	2-521360-2	2-521055-2	2-521361-2
2-520403-2	2-520401-2	2-521361-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
18 AWG	1.78 +/- 0.05 [0.070 +/- .002]	6.1	.12 IN [3.05mm]
20 OR 22	1.65 +/- 0.05 [0.065 +/- .002]	7.5	.12 IN [3.05mm]



- 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.
  - TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.12 IN [3.05mm]) 60/40 SOLID CORE AND MEASURE AT CENTER OF SLUG.
- 
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
7. 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	LY#	DESCRIPTION	DATE	OWN	APVD
		B		ECR-17-003516	10MAR2017	MZ	KZ
		C		ECR-18-017226	01NOV2018	JAH	CT
		D		ECR-19-005619	08APR2019	FJ	TE
		E		ECR-20-008744	18JUN2020	JWC	TE

-	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
-	1	1	356885-4	STOP, SHEAR	237
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93
-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	84
-	6	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	83
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	240641-9	SPACER	81
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	2	2	1-18028-4	WASHER, FLAT, REG M3	68
-	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	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	462427-2	FINGER, FEED	56
-	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1-1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2161336-2	PLATE, REAR STRIP GUIDE	29
-	2	2	22281-9	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	684042-4	GUIDE, STRIP, FRONT	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	2161335-2	SHEAR PLATE, REAR	22
-	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	463460-3	HOLD DOWN, TERMINAL	18
-	1	1	803925-2	GUIDE, CARRIER SCRAP	17
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	1	1	469542-3	REAR FLOATING SHEAR	15
	1	1	2119862-2	SHEAR HOLDER, REAR	14
	1	1	2280441-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	10
	1	1	1-454766-4	ANVIL, INSULATION	9
	1	2	808025-3	ANVIL	8
-	-	-	-	-	7
-	1	1	690468-6	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	5
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
	1	2	1803130-1	CRIMPER, INSULATION FASTON	3
-	-	-	-	-	2
	1	2	808830-2	CRIMPER, SEMI FLAT	1
-77-72-2			PART NO	DESCRIPTION	ITEM NO

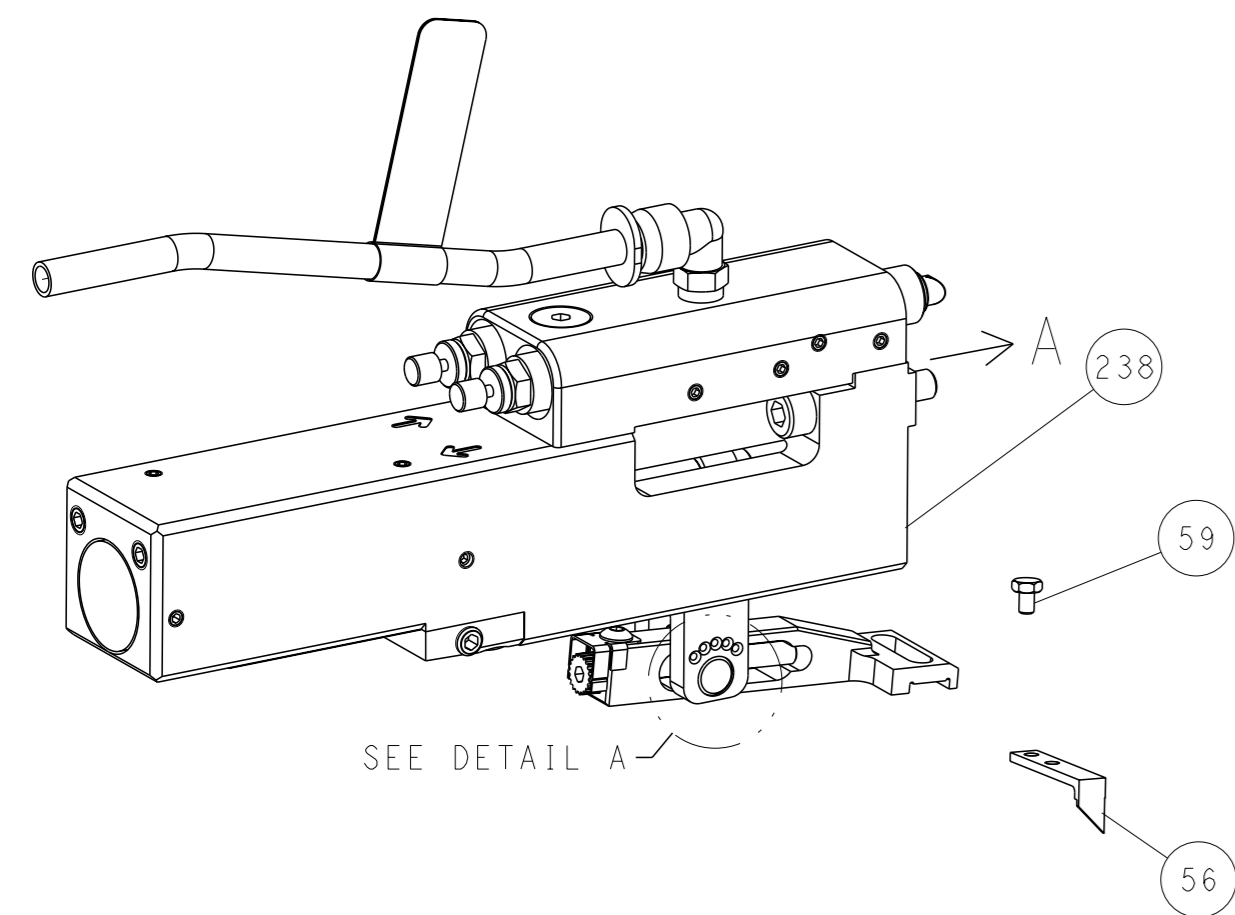
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER ASSUMES RESPONSIBILITY FOR VERIFYING THE DIMENSIONS SHOWN ON THIS DRAWING.</small>		OWN: BOB HIGMAN 18OCT2013 CHK: G. BAILEY 18OCT2013 APVD: M. CLIFFORD 18OCT2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	NAME: Ocean Side Feed Applicator SIZE: A1 CASE CODE: 00779 DRAWING NO: C=2266077 RESTRICTED TO:	
MATERIAL: -		WEIGHT: -	Customer Accessible Production Drawing SCALE: 1:2 SHEET 1 of 4 REV E	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

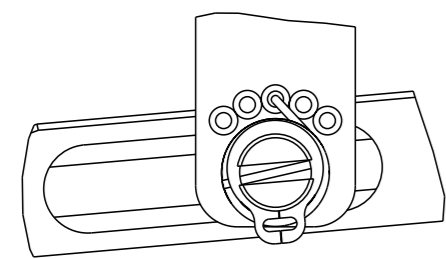
# FEED TYPE

## PNEUMATIC



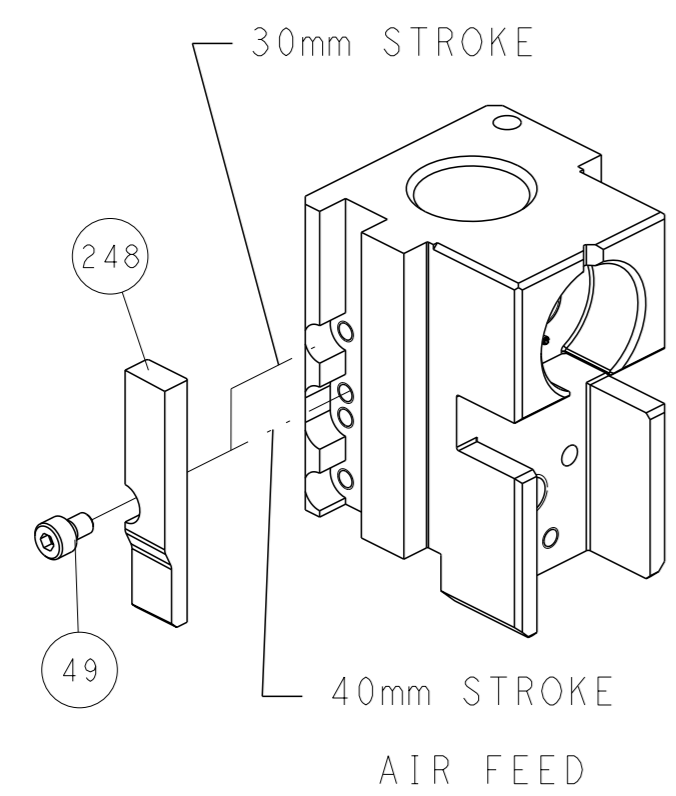
SEE DETAIL A

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

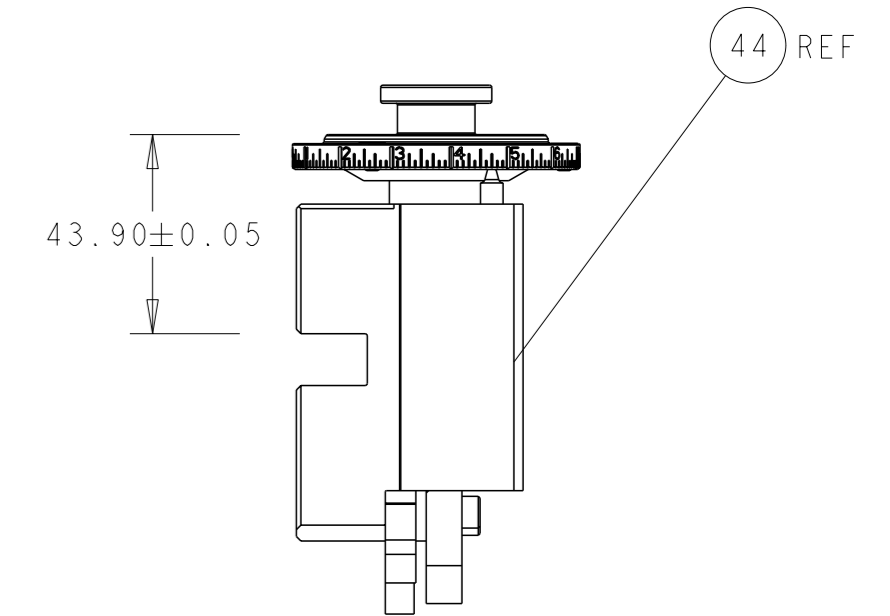
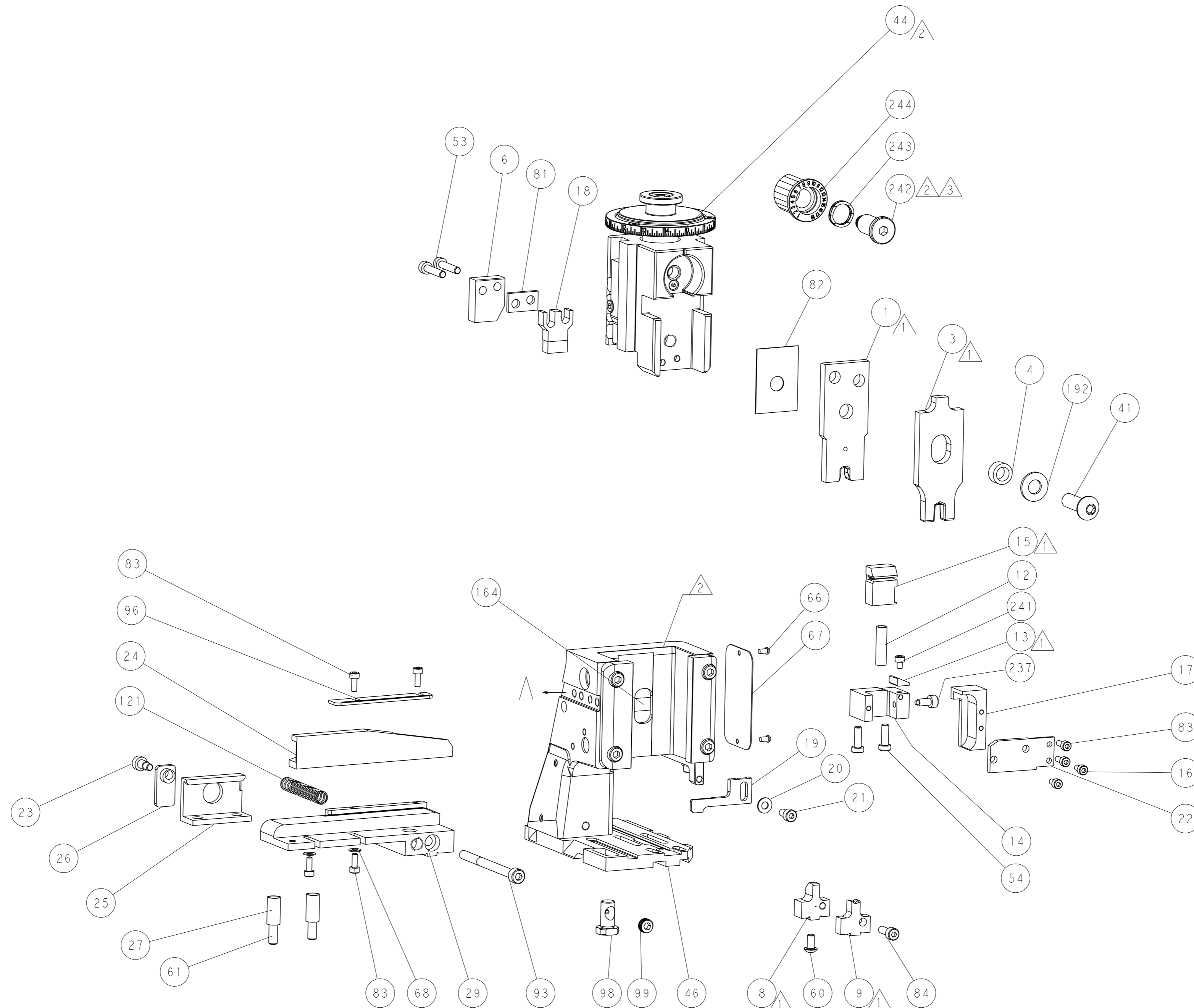


DETAIL A

## CAM POSITION



AIR FEED



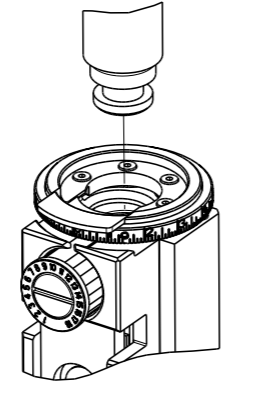
RAM SET-UP

**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 FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND ITS CONTENTS AND EXTENTING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN BOB HIGMAN 18OCT2013 CHK G. BAILEY 18OCT2013 APVD M. CLIFFORD 18OCT2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC	SIZE A1 CAGE CODE 00779 DRAWING NO. C=2266077 RESTRICTED TO
MATERIAL:		WEIGHT:	SCALE 1:2 SHEET 2 of 4 REV E Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266077-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266077-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER

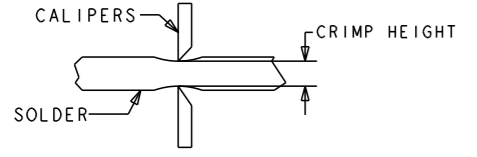


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm (.176)	D
INSUL	5.54 mm (.218)	PIDG
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ULTRA FAST PLUS FULLY INSULATED FASTON			
WIRE STRIP LENGTH 6.73-7.54 mm (.265-.297 IN)		INSULATION DIAMETER RANGE 1.52-3.43 mm (.060-.135 IN)	
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520405-2	2-521360-2	2-521055-2	
2-520403-2	2-520401-2	2-521361-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	SOLDER
18 AWG	1.78 +/- 0.05 [.070 +/- .002]	6.1	6.4
20 OR 22	1.65 +/- 0.05 [.065 +/- .002]	7.5	7.6

- 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.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.12 IN [3.05mm] 60/40 SOLID CORE AND MEASURE AT CENTER OF SLUG.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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	LY#	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-1	AIR FEED MODULE	238
-	1	356885-4	STOP, SHEAR	237
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	2-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1-22281-8	SPRING, COMPRESSION	121
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93
-	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	84
-	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	83
-	1	455888-5	SPACER, CRIMPER	82
-	1	240641-9	SPACER	81
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	2	1-18028-4	WASHER, FLAT, REG M3	68
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	462427-2	FINGER, FEED	56
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	2161336-2	PLATE, REAR STRIP GUIDE	29
-	2	22281-9	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	684042-4	GUIDE, STRIP, FRONT	24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	2161335-2	SHEAR PLATE, REAR	22
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	463460-3	HOLD DOWN, TERMINAL	18
-	1	803925-2	GUIDE, CARRIER SCRAP	17
-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	469542-3	REAR FLOATING SHEAR	15
-	1	2119862-2	SHEAR HOLDER, REAR	14
-	1	2280441-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	10
1	1	1-454766-4	ANVIL, INSULATION	9
1	1	808025-3	ANVIL	8
-	-	-	-	7
-	1	690468-6	DEPRESSOR SHEAR, REAR	6
-	-	-	-	5
-	1	4-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1803130-1	CRIMPER, INSULATION FASTON	3
-	-	-	-	2
1	1	808830-2	CRIMPER, SEMI FLAT	1
-	-	-	-	1
-	-	-	-	1

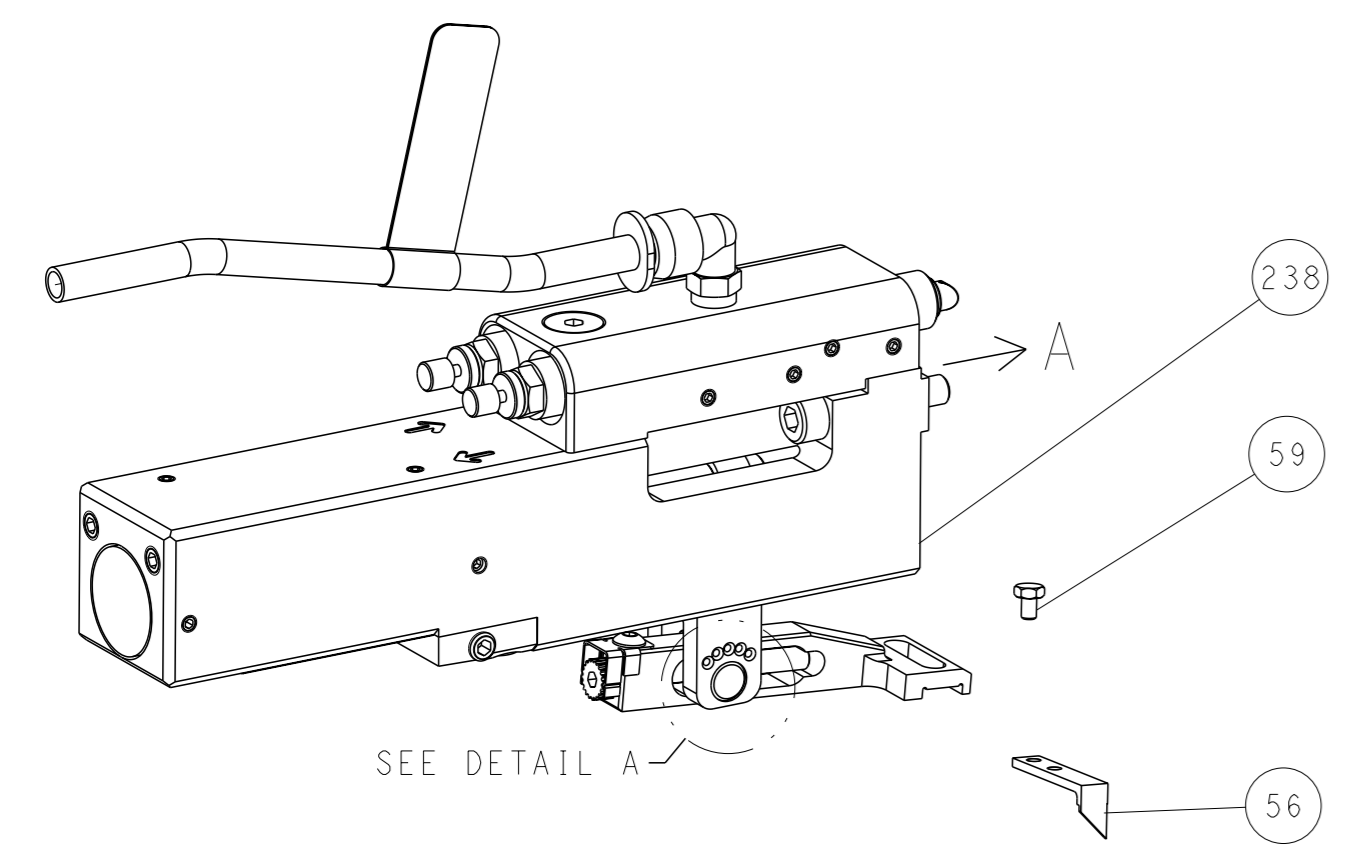
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA		MATERIAL		WEIGHT		SCALE		SHEET		REV	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANVIL	00779	00779	00779	1:2	3	4	E		

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	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

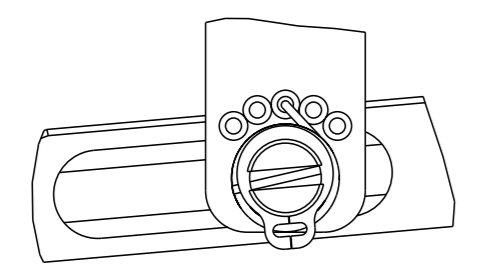
# FEED TYPE

## PNEUMATIC



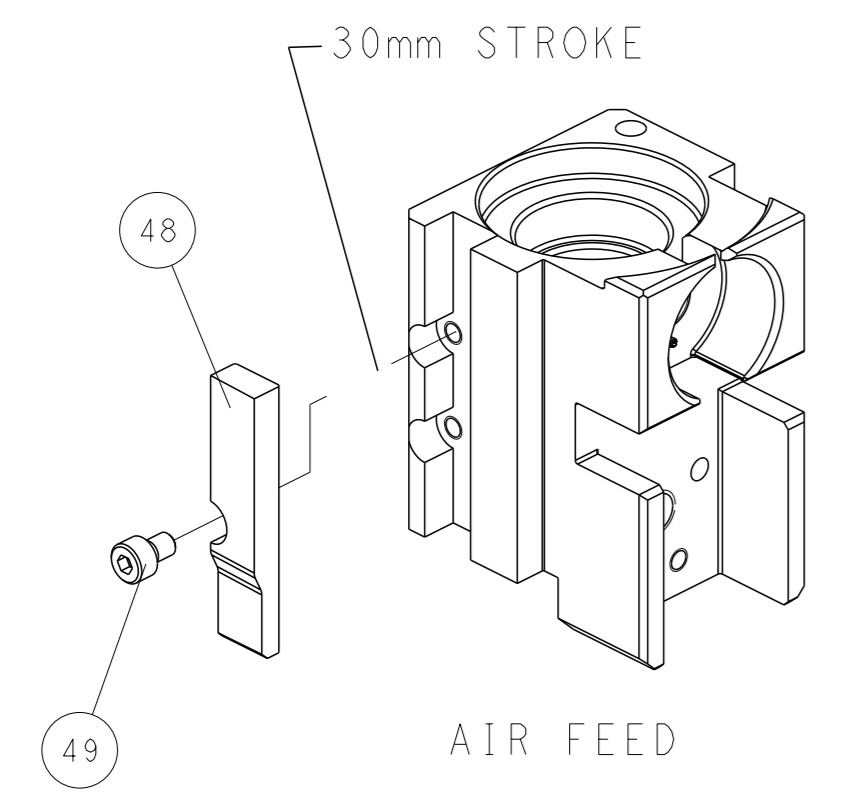
SEE DETAIL A

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

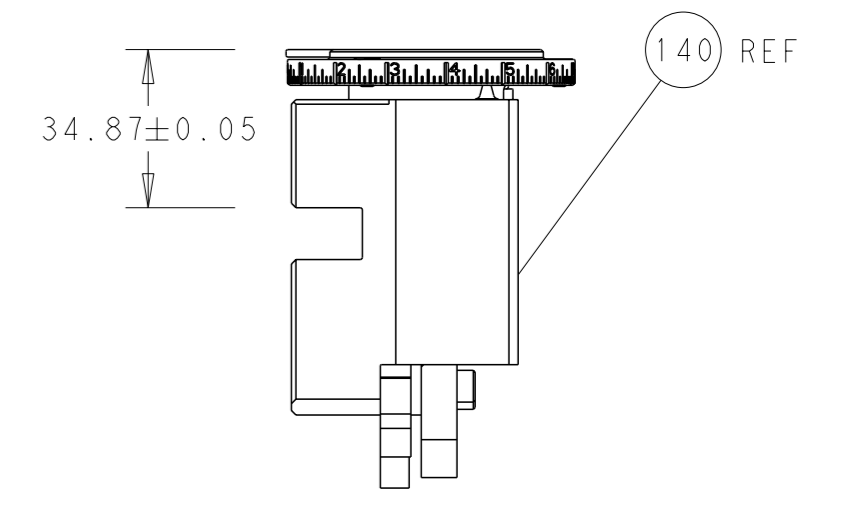
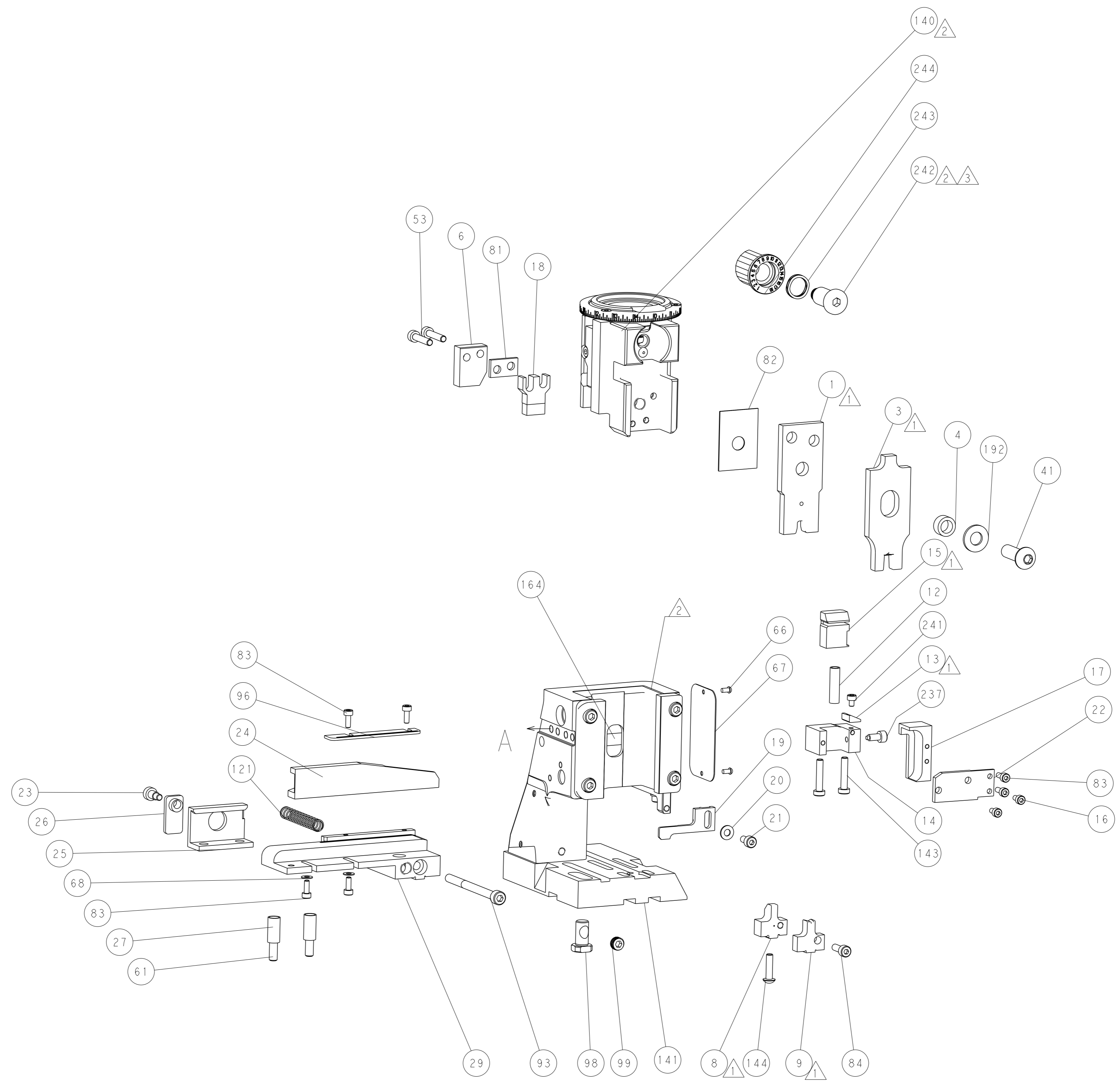


DETAIL A

## CAM POSITION



AIR FEED



RAM SET-UP

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN BOB HIGMAN 18OCT2013 CHK G. BAILEY 18OCT2013 APVD M. CLIFFORD 18OCT2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	RESTRICTED TO SIZE A1 CAGE CODE 00779 DRAWING NO. C=2266077 SHEET 4 OF 4 REV E
MATERIAL:		Customer Accessible Production Drawing	