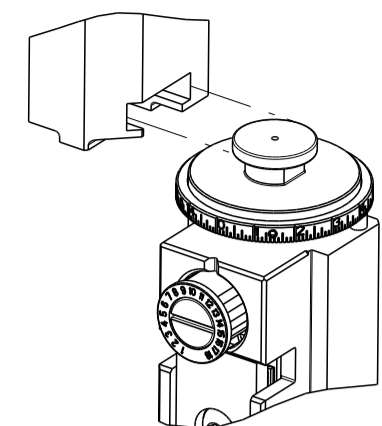


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266456-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266456-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266456-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	7.11 mm [.280]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: MCON 8 CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
7.60-8.20 mm [.299-.323 IN]	Ø4.00-6.50 mm [.157-.256 IN]		
TERMINAL APPLICATION SPECIFICATION	114-94285	-	-
TERMINALS APPLIED $\Delta$ $\nabla$ $\nabla$ $\nabla$			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-2208763-3	5-2208763-3		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: MCON 8 CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
7.60-8.20 mm [.299-.323 IN]	Ø4.00-6.50 mm [.157-.256 IN]		
TERMINAL APPLICATION SPECIFICATION	114-94761	-	-
TERMINALS APPLIED $\Delta$ $\nabla$ $\nabla$ $\nabla$			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-2208763-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm2	3.35 +/- 0.1 [.132 +/- .004]	3.4
6.00mm2	2.80 +/- 0.1 [.110 +/- .004]	9.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.70 +/- 0.05 [.106 +/- .002]	10.5
4.00mm2	2.42 +/- 0.05 [.095 +/- .002]	13.3

**\*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.

- $\Delta$  RECOMMENDED SPARE PARTS
- $\Delta$  REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- $\Delta$  APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- $\Delta$  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.
- $\Delta$  TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- $\Delta$  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- $\Delta$  CUT TO LENGTH AT ASSEMBLY.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		E		ECR-19-011678	24JUL2019	JAH	RK
		F		ECR-21-122035	25NOV2021	FJ	PJ
		F1		ECR-22-136771	22APR2022	FZ	MP
		F2		ECR-22-157205	02NOV2022	TB	GB

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
$\Delta$	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2844940-2	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
$\Delta$	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1	1-455888-8	SPACER, CRIMPER	82	
$\Delta$	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1-2119791-6	DEPRESSOR, WIRE	70	
-	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	1-1338683-1	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1-811242-0	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	5-1752356-0	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	1-455888-0	SPACER, CRIMPER	28	
-	1	1	2-1320928-3	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	1803013-1	STRIPPER, SIDE FEED	19	
$\Delta$	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	4-22280-7	SPRING, COMPRESSION	12	
-	1	1	1-356885-3	STOP, SHEAR	11	
$\Delta$	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
$\Delta$	1	1	454276-5	FLOATING SHEAR, FRONT	9	
$\Delta$	1	2	1	2-1633930-6	ANVIL, COMBINATION	8
-	1	1	3-240641-0	SPACER	7	
-	-	-	-	-	6	
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	1	5-238011-9	BLOCK, CRIMPER SPACER	4	
$\Delta$	1	2	1	4-1633996-2	CRIMPER, INSULATION SPECIAL	3
-	-	-	-	-	2	
$\Delta$	1	2	1	1803610-3	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

OWN	CHK	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
R.O. WILSON	K.J. STAKEM	12AUG2014	T.L. ELBIN	A1	00779	2266456	

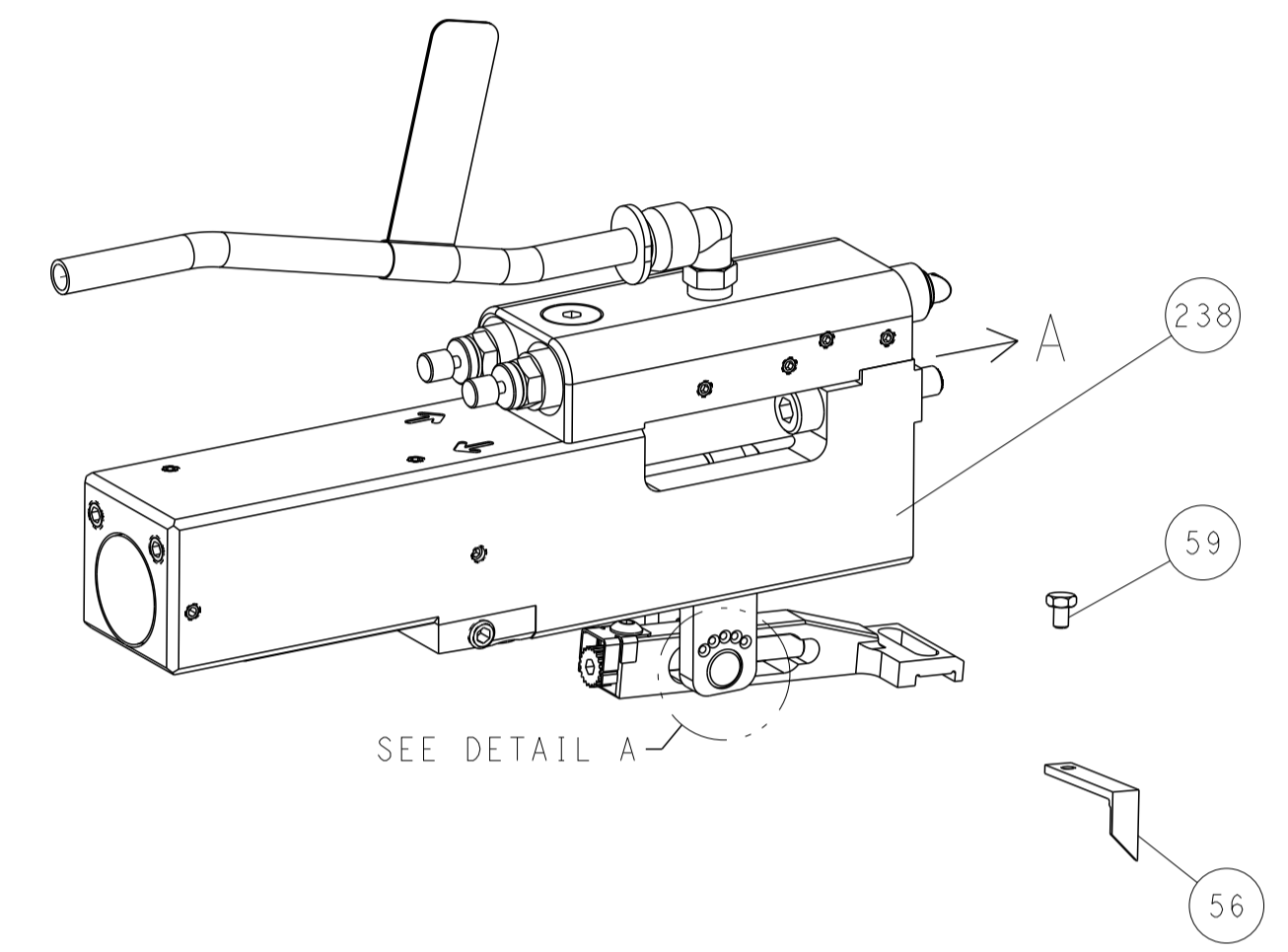
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV F2

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	DMN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

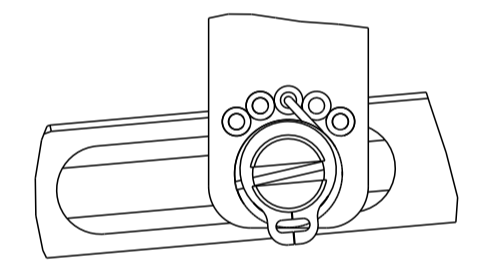
# FEED TYPE

## PNEUMATIC



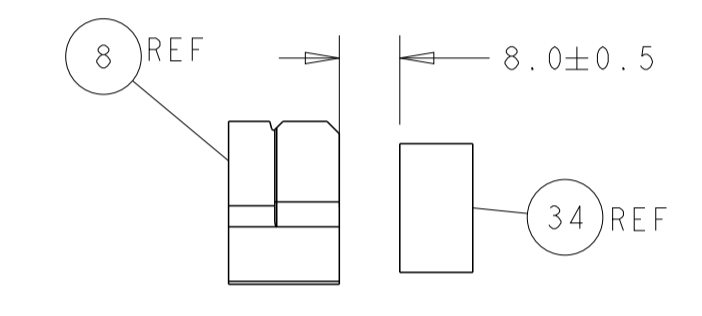
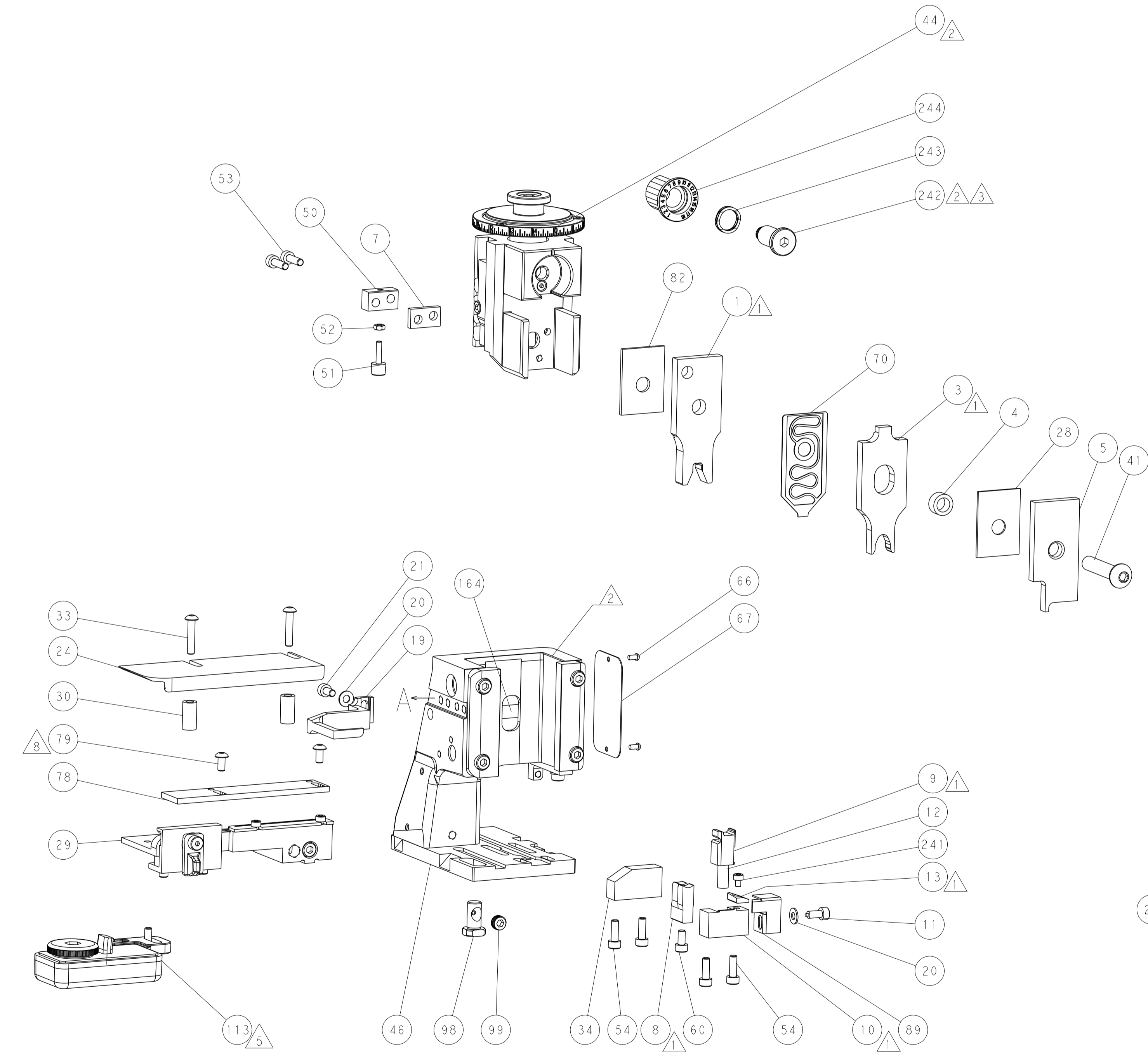
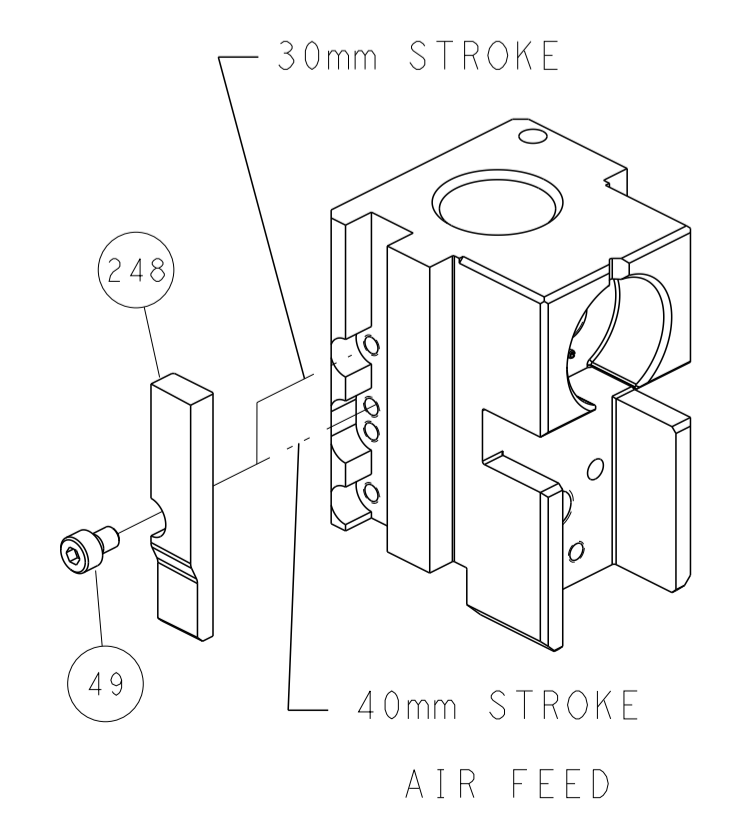
SEE DETAIL A

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

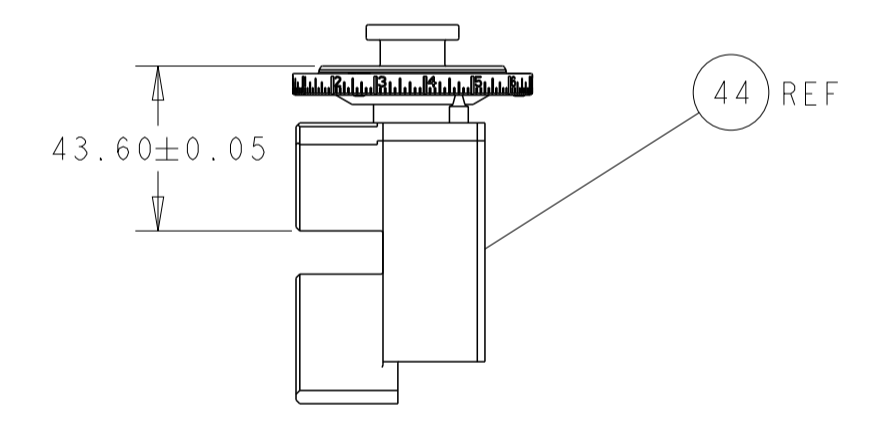


DETAIL A

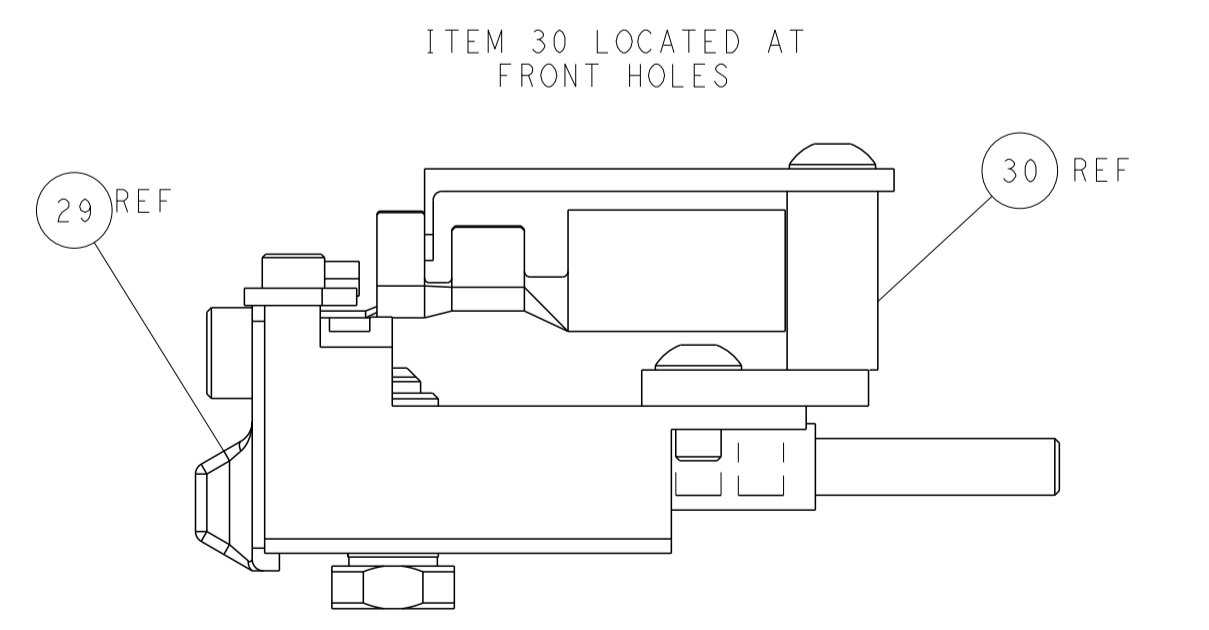
## CAM POSITION



TERMINAL SUPPORT LOCATION



RAM 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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R.O. WILSON 08AUG2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: T.L. ELBIN 13AUG2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 2 OF 4		REV F2	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266456-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266456-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	7.11 mm [.280]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 8 CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.60-8.20 mm [.299-.323 IN]		Ø4.00-6.50 mm [.157-.256 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94285	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-2208763-3	5-2208763-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 8 CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.60-8.20 mm [.299-.323 IN]		Ø4.00-6.50 mm [.157-.256 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94761	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-2208763-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm2	3.35+/-0.1 [.132+/- .004]	3.4
6.00mm2	2.80+/-0.1 [.110+/- .004]	9.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.70+/-0.05 [.106+/- .002]	10.5
4.00mm2	2.42+/-0.05 [.095+/- .002]	13.3

- 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- CUT TO LENGTH AT ASSEMBLY.

**\*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	DWN	APVD
		-		SEE SHEET 1			

-	1	2119082-6	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	2844940-2	AIR FEED MODULE	238	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140	
	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1-455888-8	SPACER, CRIMPER	82	
	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1803096-1	EXTENSION PLATE	78	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1-2119791-6	DEPRESSOR, WIRE	70	
-	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	1-1338683-1	FEED PAWL	56	
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1-811242-0	BUMPER, HOLD DOWN	51	
-	1	690753-2	SPACER, TONKER	50	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	5-1752356-0	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1-455888-0	SPACER, CRIMPER	28	
-	1	2-1320928-3	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	1803013-1	STRIPPER, SIDE FEED	19	
	1	2119806-1	INSERT, SHEAR	13	
-	1	4-22280-7	SPRING, COMPRESSION	12	
-	1	1-356885-3	STOP, SHEAR	11	
	1	2119805-1	SHEAR HOLDER, FRONT	10	
	1	454276-5	FLOATING SHEAR, FRONT	9	
	1	2-1633930-6	ANVIL, COMBINATION	8	
-	1	3-240641-0	SPACER	7	
-	-	-	-	6	
-	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	5-238011-9	BLOCK, CRIMPER SPACER	4	
	1	4-1633996-2	CRIMPER, INSULATION SPECIAL	3	
-	-	-	-	2	
	1	1803610-3	CRIMPER, WIRE	1	
-	-	-	-	0	
-	77	22	PART NO	DESCRIPTION	ITEM NO

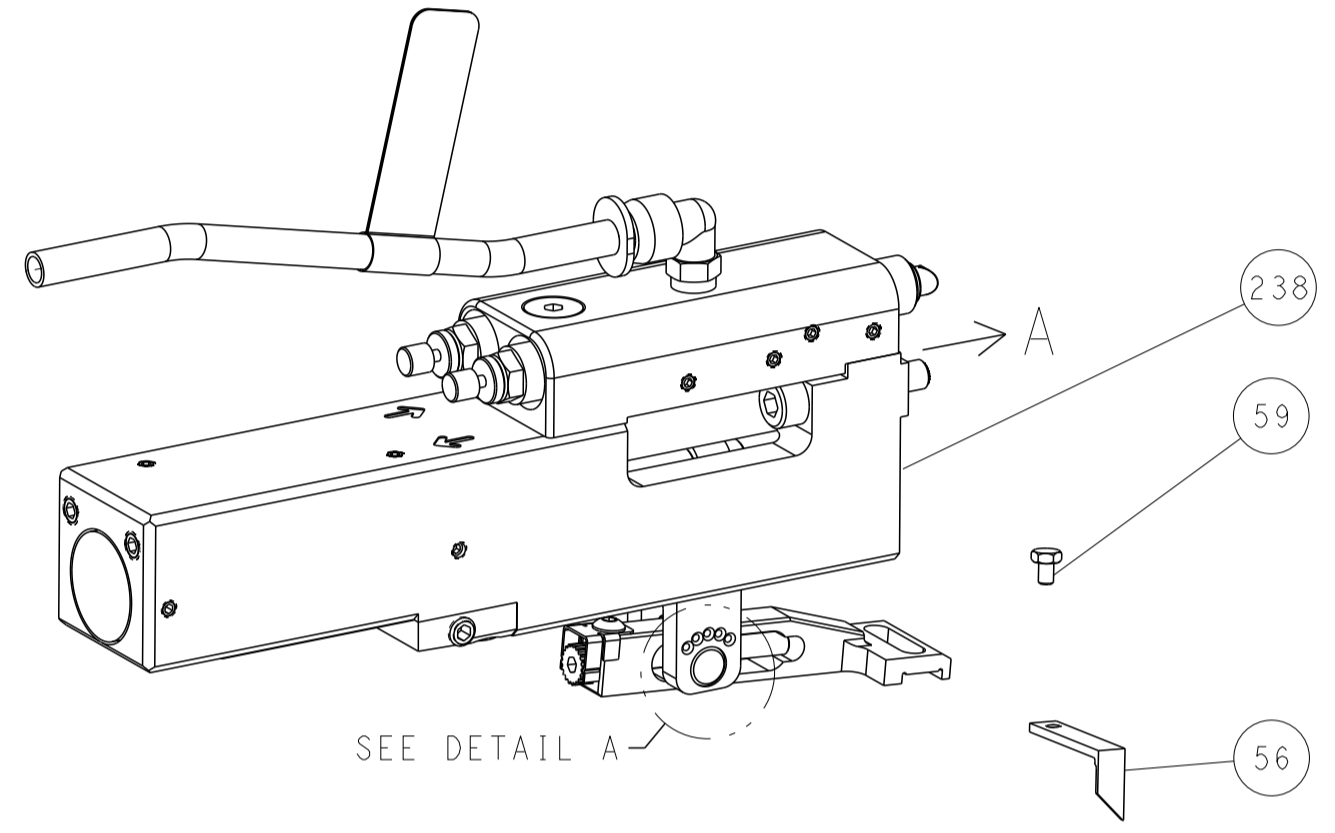
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R.O. WILSON 08AUG2014		CHK: K.J. STARKEM 12AUG2014		APVD: T.L. ELBIN 13AUG2014		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: F2	
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: F2	

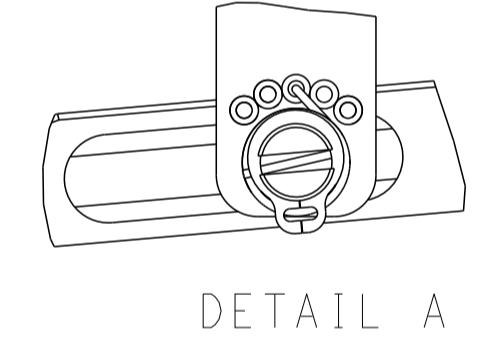
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-

# FEED TYPE

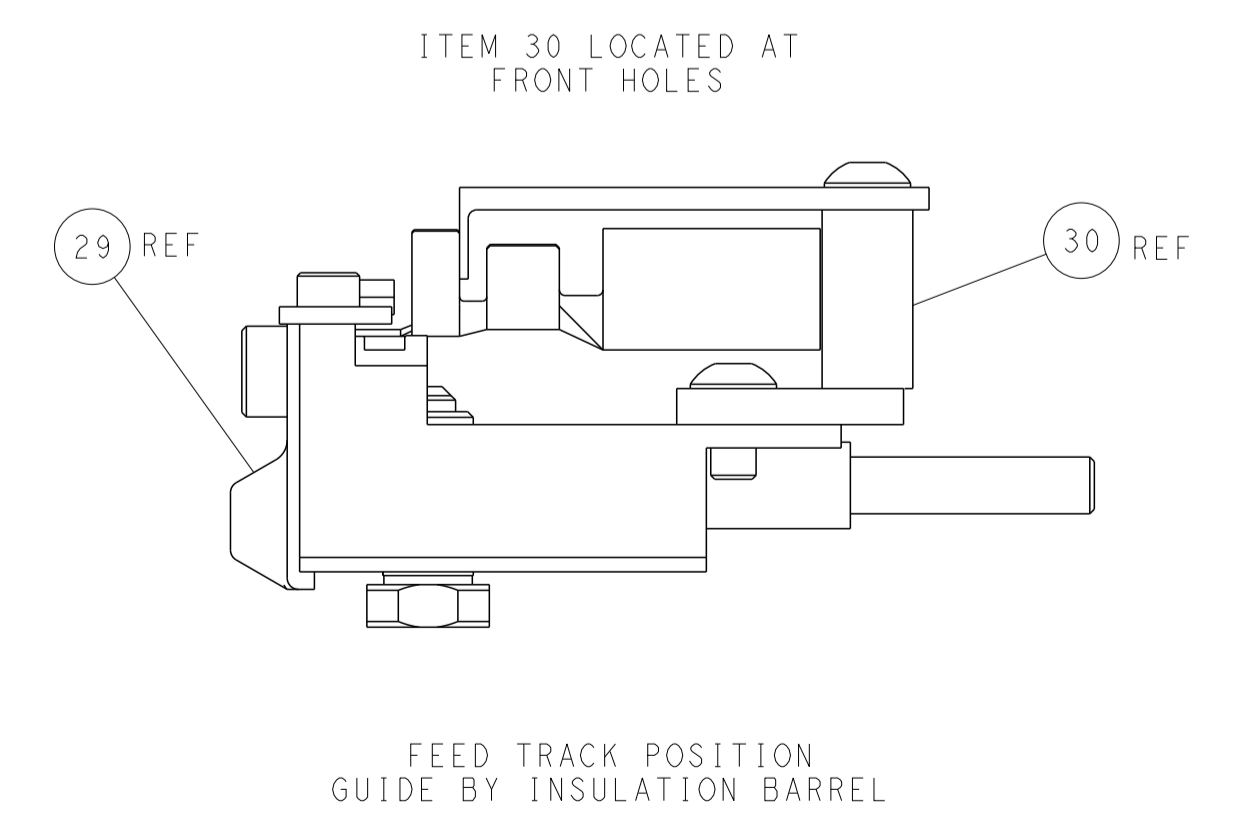
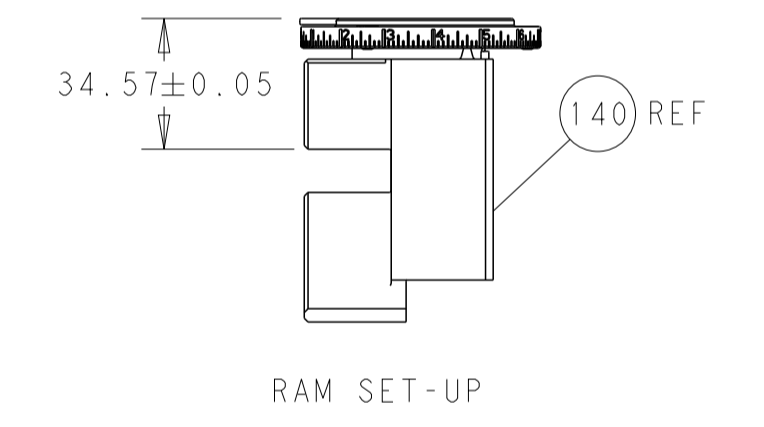
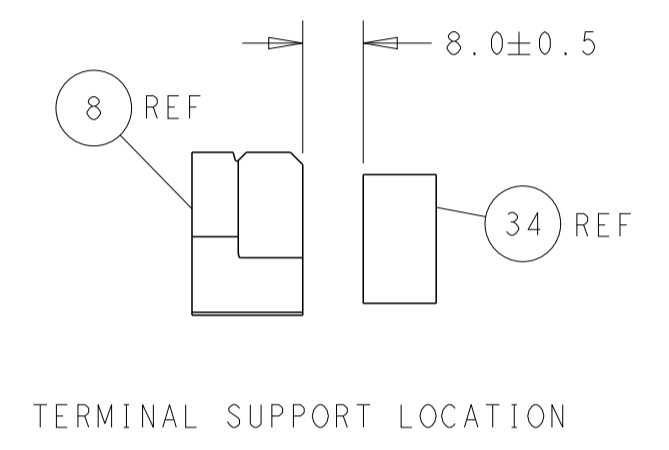
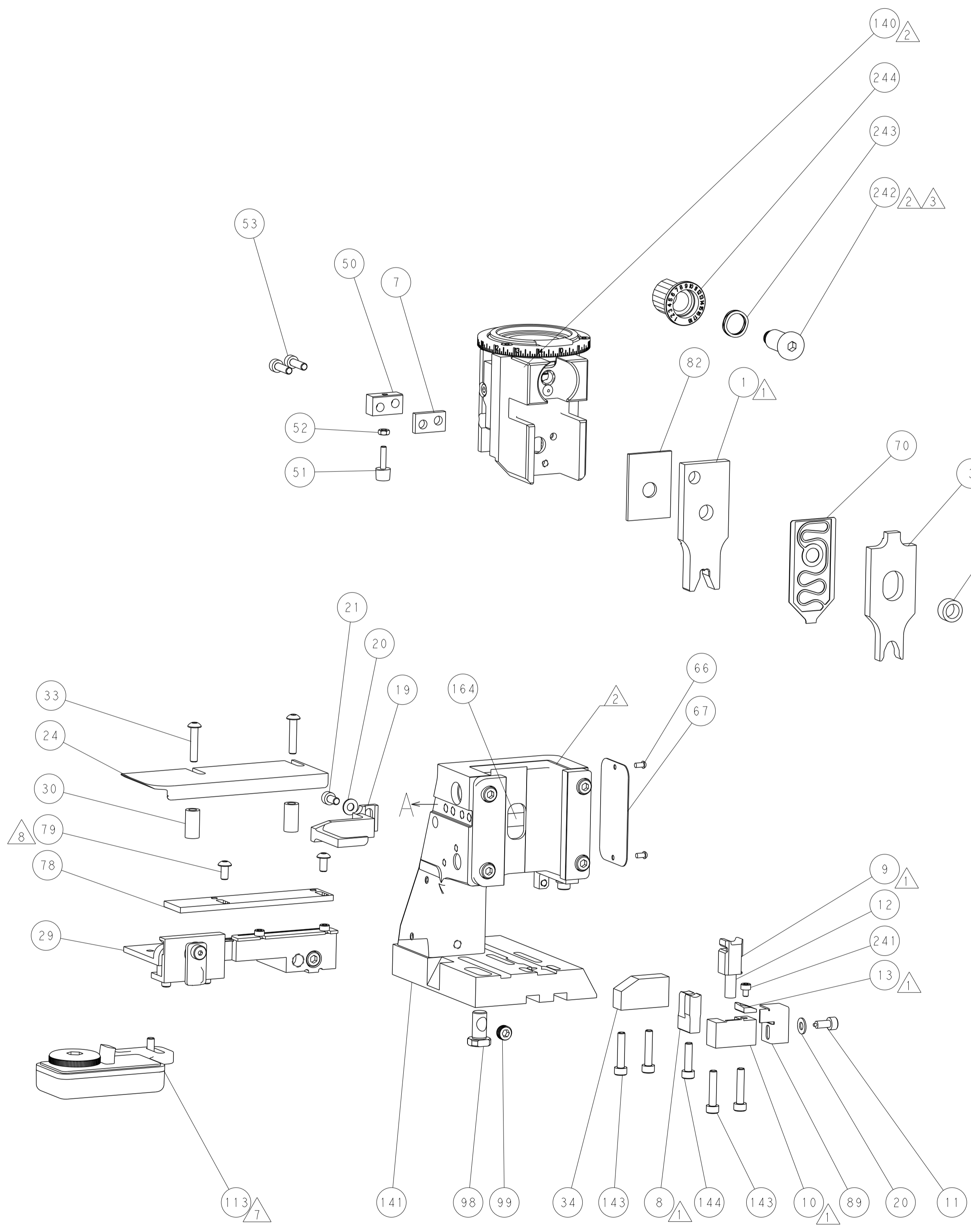
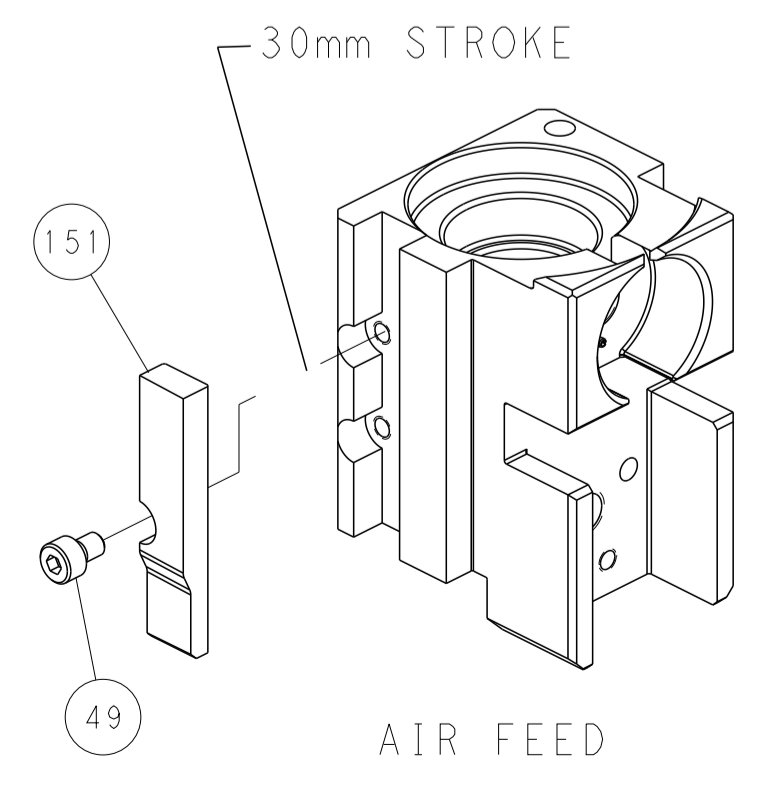
## PNEUMATIC



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



## CAM POSITION



**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 UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R.O. WILSON 08AUG2014 CHK: K.J. STAKEM 12AUG2014 APVD: T.L. ELBIN 13AUG2014	NAME: Ocean Side Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266456	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: F2
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2 SHEET: 4 OF 4 REV: F2	NAME: Ocean Side Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266456 RESTRICTED TO: -	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: F2