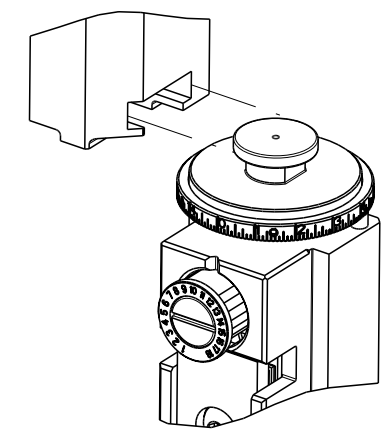


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266737-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266737-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266737-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266737-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266737-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



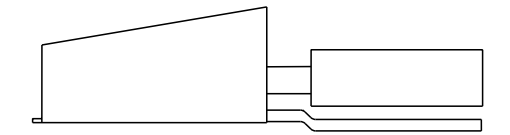
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [1.070]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINIATURE AMPLIFIER SPLICE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.35-5.11 mm [1.71-.201 IN]		Ø3.05-3.18 mm [1.20-.125 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-2004		
	(B)114-2006		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 153212-3	(A) 153212-4	(B) 160631-6	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1200-1855 CMA	1.30+/-0.05 [1.051+/-0.002]	7.5
800-1200 CMA	1.22+/-0.05 [1.048+/-0.002]	8.3
255-800 CMA	1.17+/-0.02 [1.046+/-0.001]	8.8

- 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.
- RECOMMENDED WIRE FOR SET-UP AT THE FACTORY.  
1200-1855 CMA - 181/2 MAG WIRE  
800-1200 CMA - 20 MAG WIRE  
255-800 CMA - 23 MAG WIRE
- THE LONGITUDINAL CRIMP FORM DOES NOT MEET 114-2004 OR 114-2006. ACTUAL CRIMP IS BELOW.



- TERMINAL LUBRICANT IS RECOMMENDED.
- 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	CHK
		B	14AUG2017	JH	CT
		C	30JAN2020	JAH	RR

-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283	
-	1	1	1	1	2280441-1	INSERT, SHEAR	282	
-	1	1	1	1	1803078-2	SPACER, PRECISION	259	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	1	1	1	1	1-356885-0	STOP, SHEAR	237	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	1	455888-7	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	
-	2	2	2	2	18023-4	SCR, SKT HD CAP M3 X 10.0	65	
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	1338683-9	FEED PAWL	56	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53	
-	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	1-2305692-2	PLATE, REAR STRIP GUIDE	29	
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1	1	4-690487-1	GUIDE, FRONT STRIP	24	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	690463-6	FLOATING SHEAR, REAR	17	
-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	-	-	-	-	-	-	10	
-	-	-	-	-	-	-	9	
-	1	2	2	1	1	4-1633933-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	1	1	1	1	2-690468-1	DEPRESSOR SHEAR, REAR	6	
-	-	-	-	-	-	-	5	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	1803232-2	CRIMPER, WIRE F	1

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

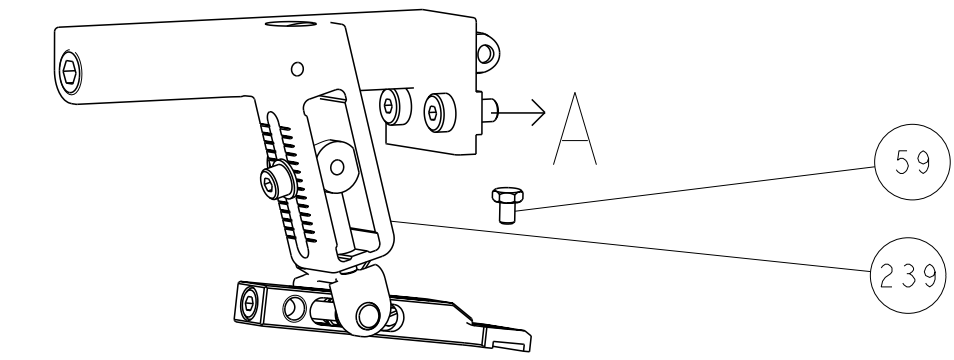
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

DATE	BY	CHK	APVD	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
APRIL 2015	HOFFNER			TE Connectivity	A1	00779	2266737	
APRIL 2015	ELBIN			Harrisburg, PA 17105-3608				
APRIL 2014	ELBIN			Ocean Side Feed				
				Applicator				

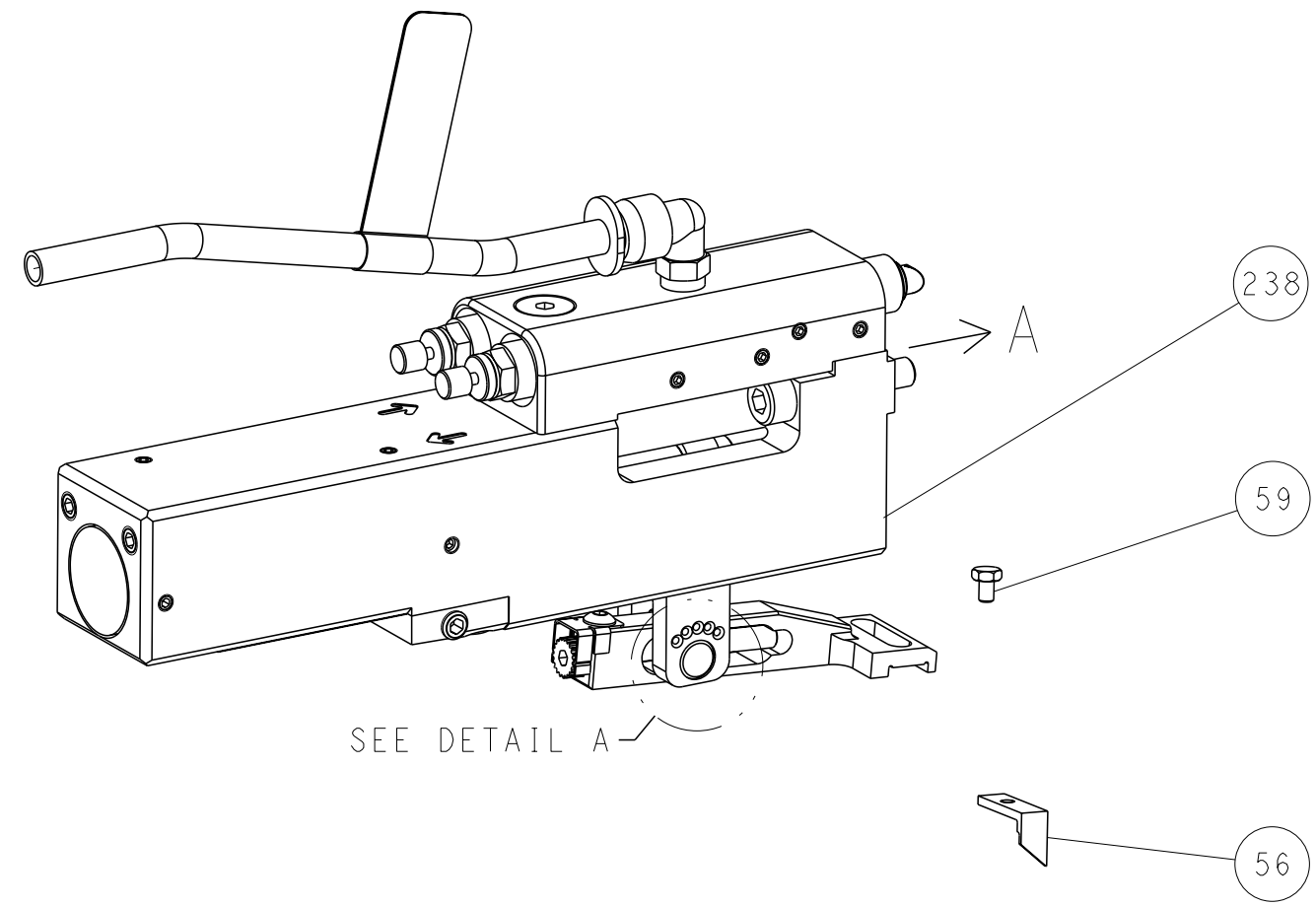
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV C

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

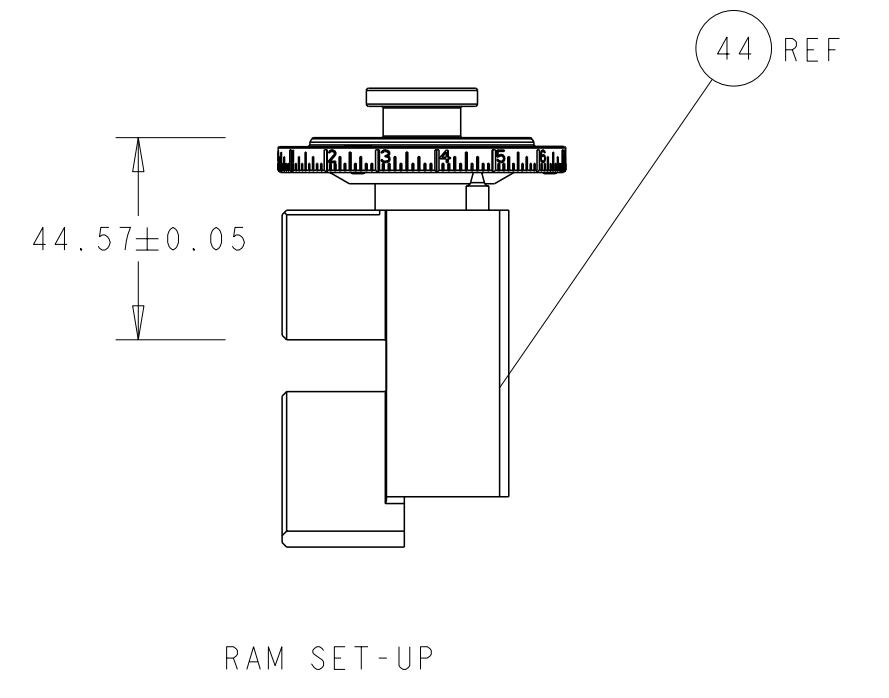
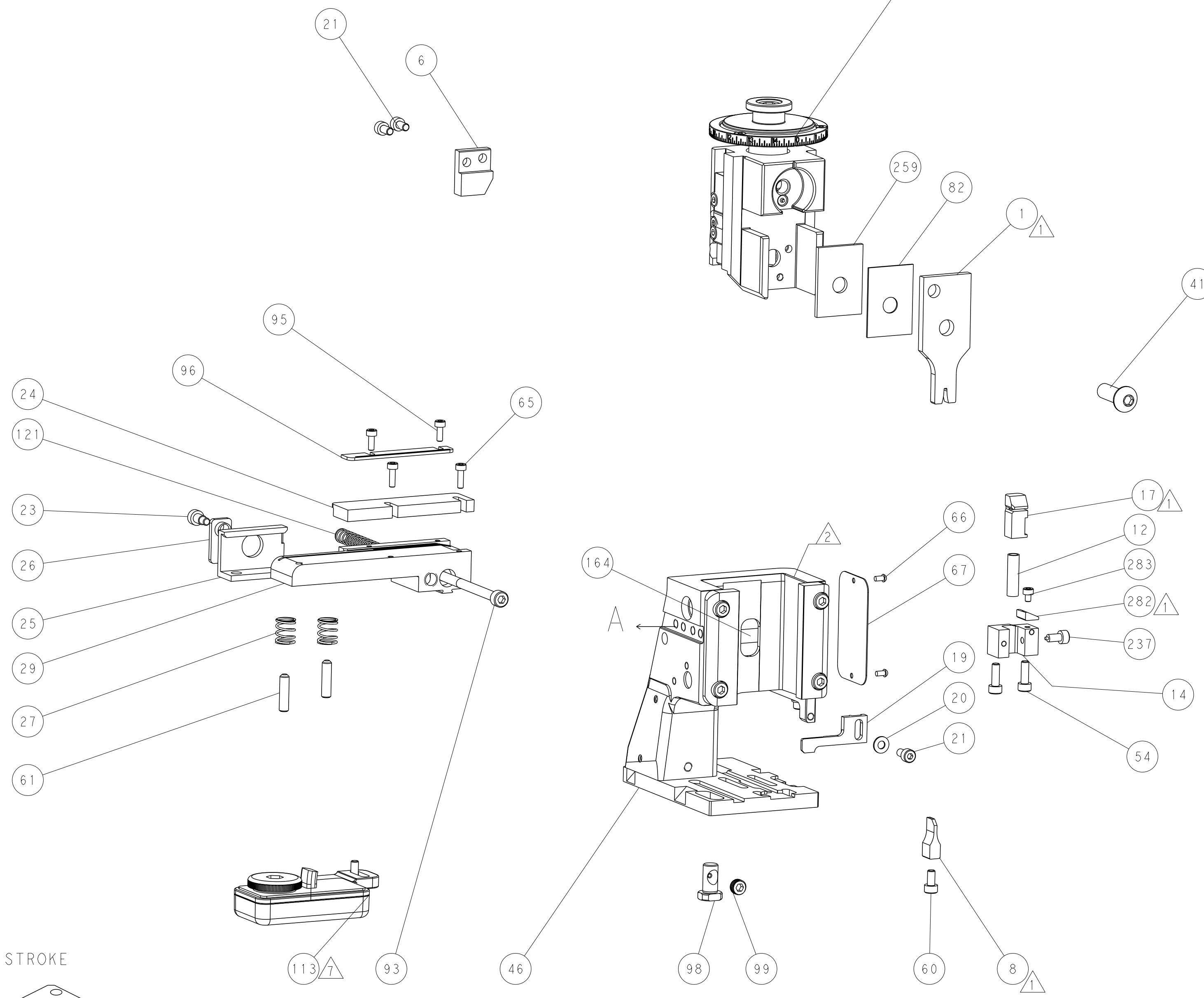
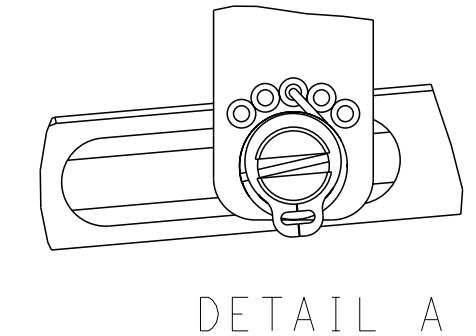
# FEED TYPE MECHANICAL



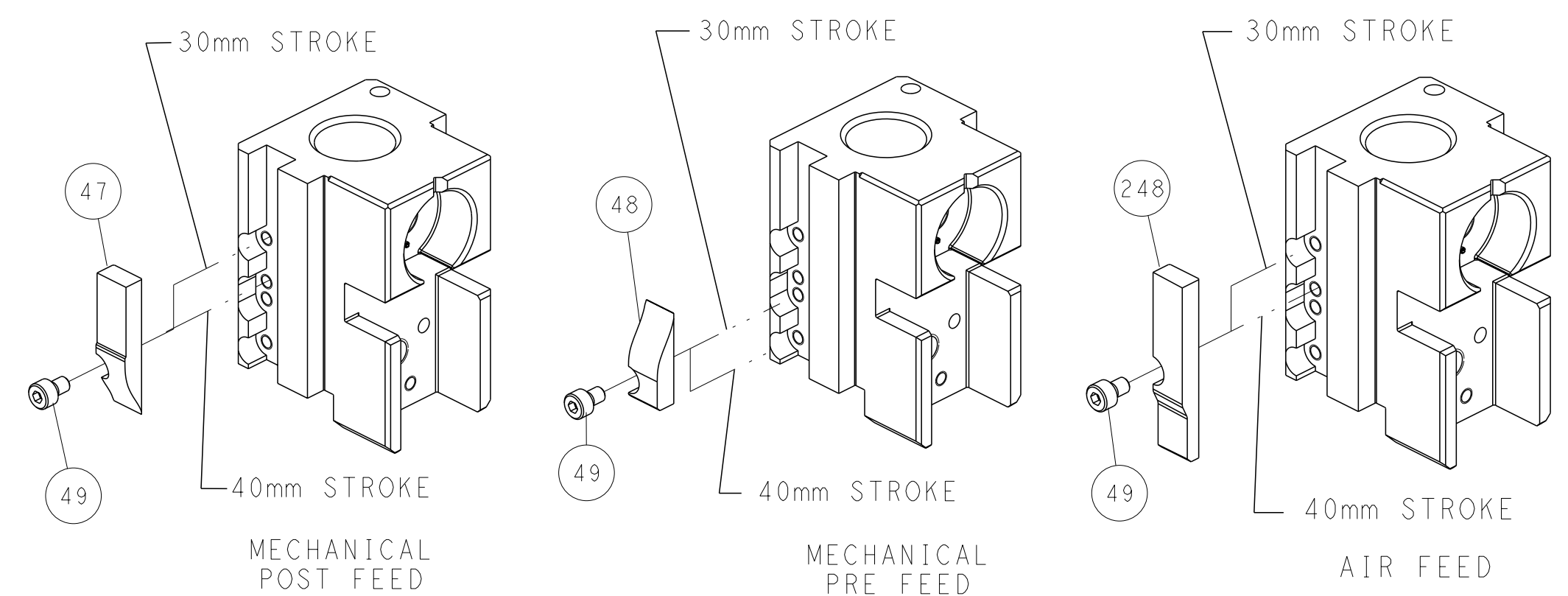
## PNEUMATIC



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



# CAM POSITIONS



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

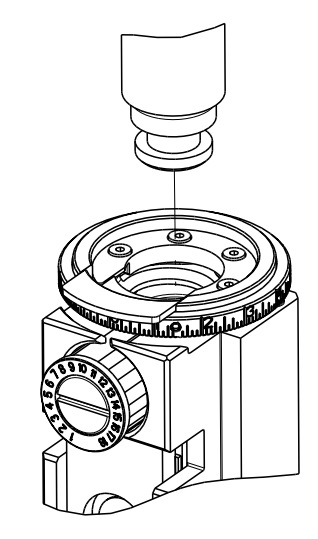
FEED TRACK POSITION GUIDE BY WIRE BARREL

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: HOFFNER CDR: TELBIN APVD: TELBIN PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	DATE: 7 APRIL 2015 DATE: 8 APRIL 2015 DATE: 8 APRIL 2014 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266737 SCALE: 1:2 SHEET: 2 of 4 REV: C	TE Connectivity Harrisburg, PA 17105-3608
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BY TFCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	20
COPYRIGHT 20	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266737-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266737-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266737-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINIATURE AMPLIVER SPLICE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.35-5.11 mm [.171-.201 IN]		∅3.05-3.18 mm [.120-.125 IN]	
TERMINAL APPLICATION SPECIFICATION	△(A)114-2004		
	△(B)114-2006		
TERMINALS APPLIED △			
TE TERMINAL (A) 153212-3	TE TERMINAL (A) 153212-4	TE TERMINAL (B) 160631-6	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1200-1855 CMA	1.30 +/- 0.05 [.051 +/- .002]	7.5
800-1200 CMA	1.22 +/- 0.05 [.048 +/- .002]	8.3
255-800 CMA	1.17 +/- 0.02 [.046 +/- .001]	8.8

- △ 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.
  - △ RECOMMENDED WIRE FOR SET-UP AT THE FACTORY.  
1200-1855 CMA - 181/2 MAG WIRE  
800-1200 CMA - 20 MAG WIRE  
255-800 CMA - 23 MAG WIRE
  - △ THE LONGITUDINAL CRIMP FORM DOES NOT MEET 114-2004 OR 114-2006. ACTUAL CRIMP IS BELOW.
- 
- △ TERMINAL LUBRICANT IS RECOMMENDED.
  - 8. 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
-	-	SEE SHEET 1	-	-	-

-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283
-	1	1	2280441-1	INSERT, SHEAR	282
-	1	1	1803078-2	SPACER, PRECISION	259
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	1	1	1-356885-0	STOP, SHEAR	237
-	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
-	2	2	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	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93
-	1	1	455888-7	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
-	2	2	18023-4	SCR, SKT HD CAP M3 X 10.0	65
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-9	FEED PAWL	56
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	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	1-2305692-2	PLATE, REAR STRIP GUIDE	29
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	4-690487-1	GUIDE, FRONT STRIP	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	690463-6	FLOATING SHEAR, REAR	17
-	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	10
-	-	-	-	-	9
1	1	1	4-1633933-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	1	1	2-690468-1	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
1	1	1	1803232-2	CRIMPER, WIRE F	1

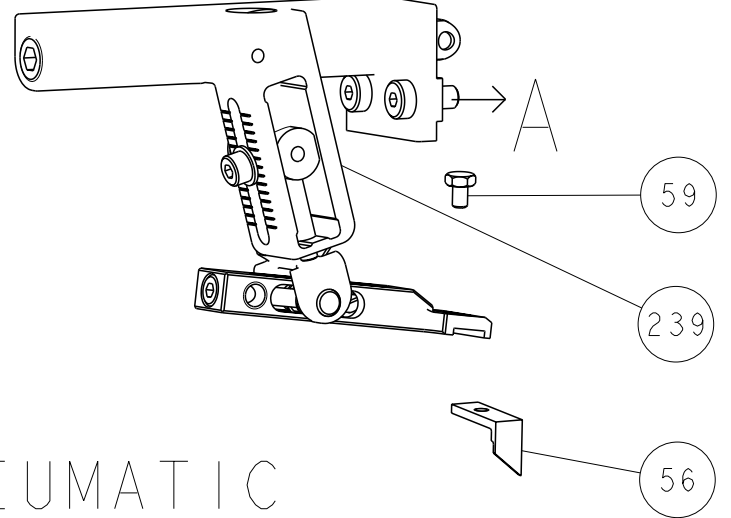
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

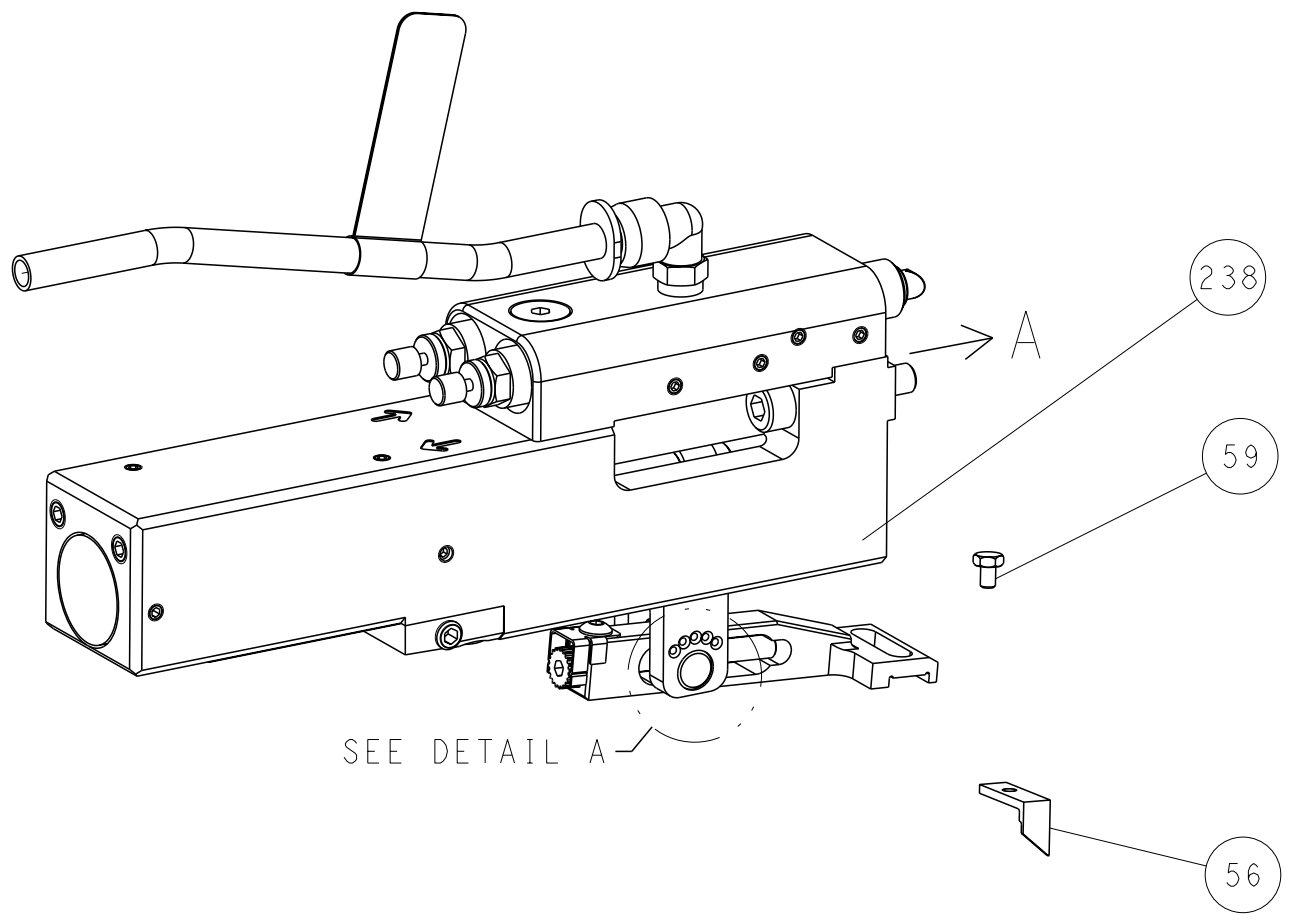
OWN	HOFFNER	APRIL2015
CHK	T. ELBIN	APRIL2015
APPV	T. ELBIN	APRIL2014
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266737
Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV C

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

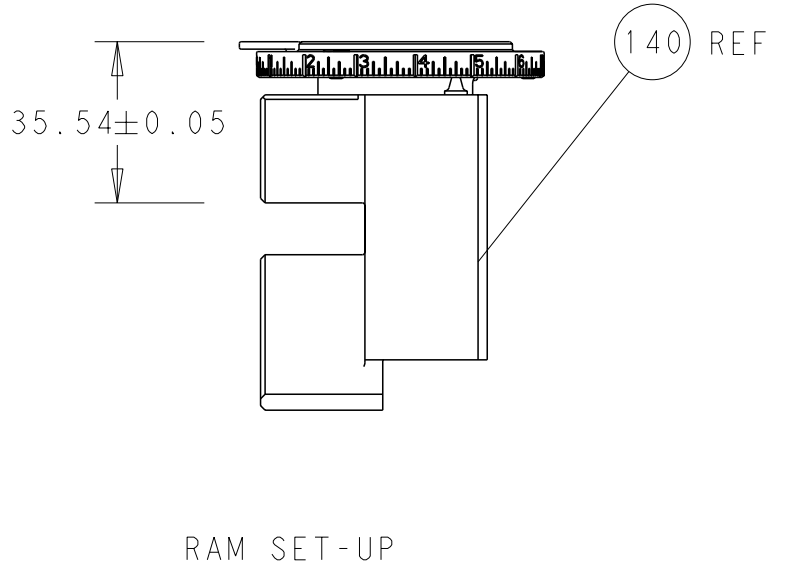
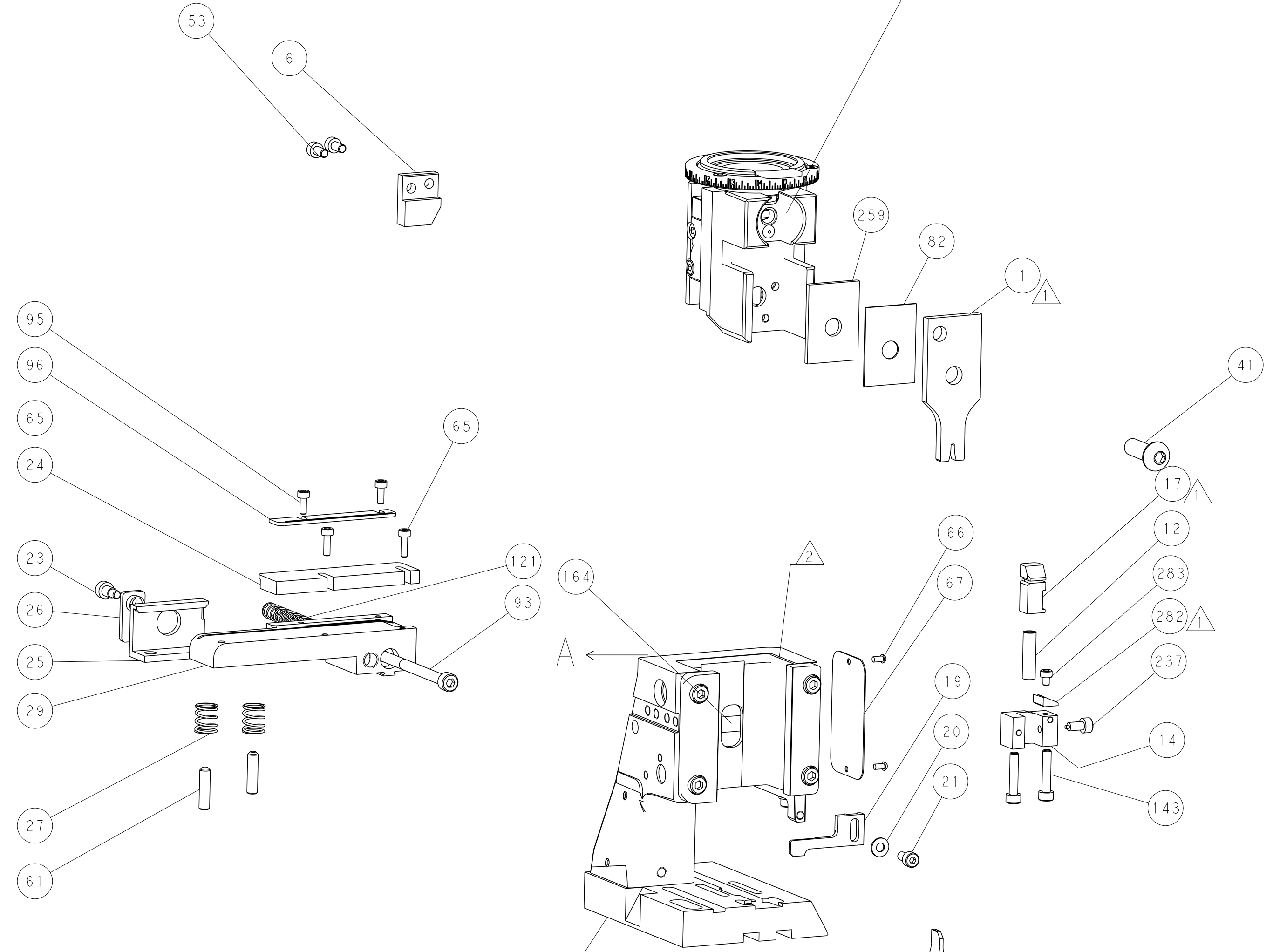
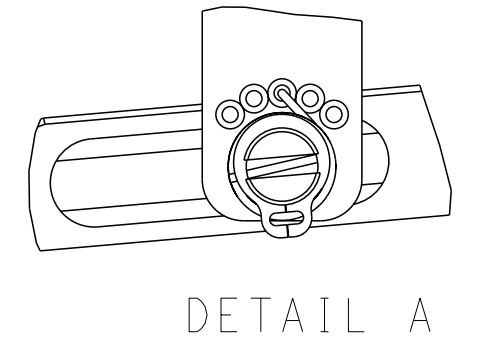
# FEED TYPE MECHANICAL



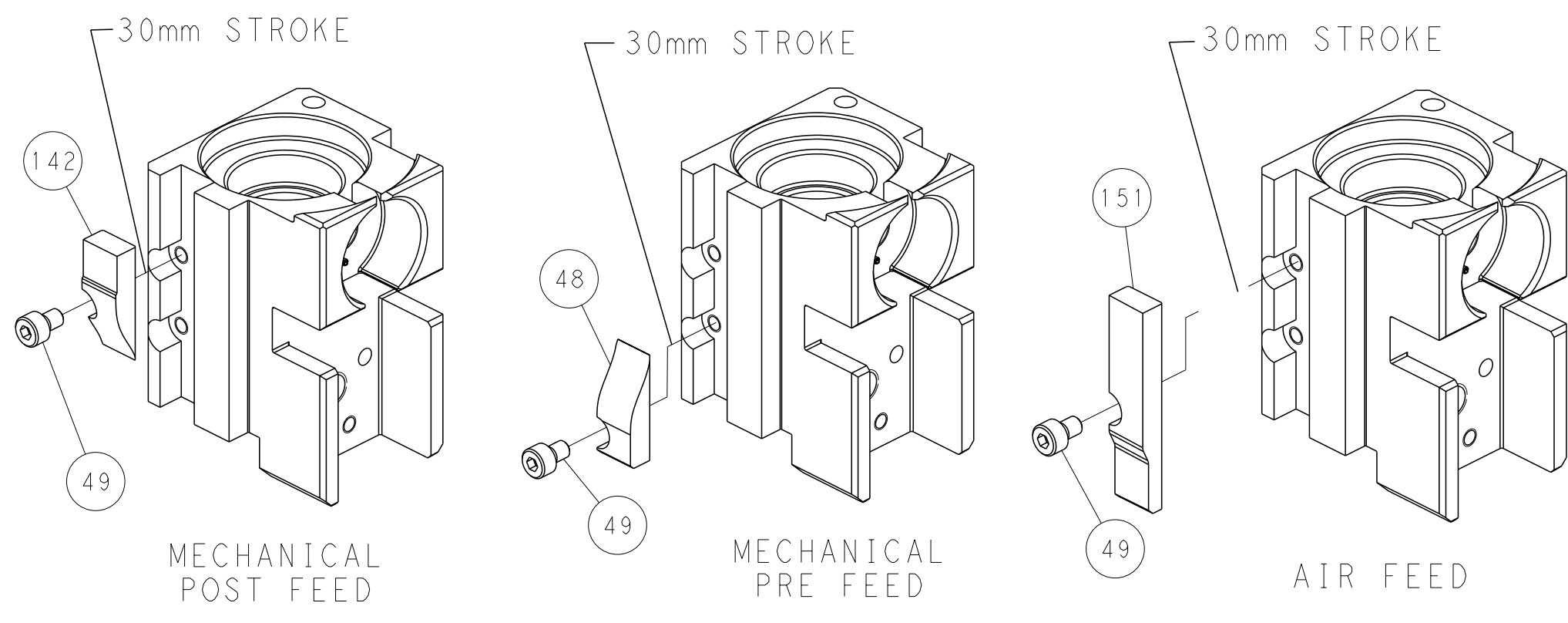
# PNEUMATIC



FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



# CAM POSITIONS



**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>		OWN: HOFFNER 7APRIL2015 CHK: T.ELBIN 8APRIL2015 APVD: T.ELBIN 8APRIL2014 PRODUCT SPEC: APPLICATION SPEC: MATERIAL: FINISH:	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266737 SCALE: 1:2 SHEET: 4 of 4 REV: C	RESTRICTED TO:
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