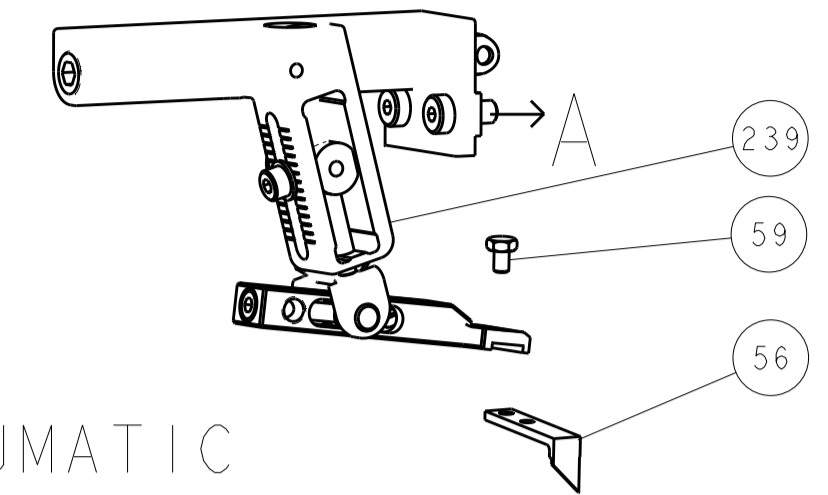
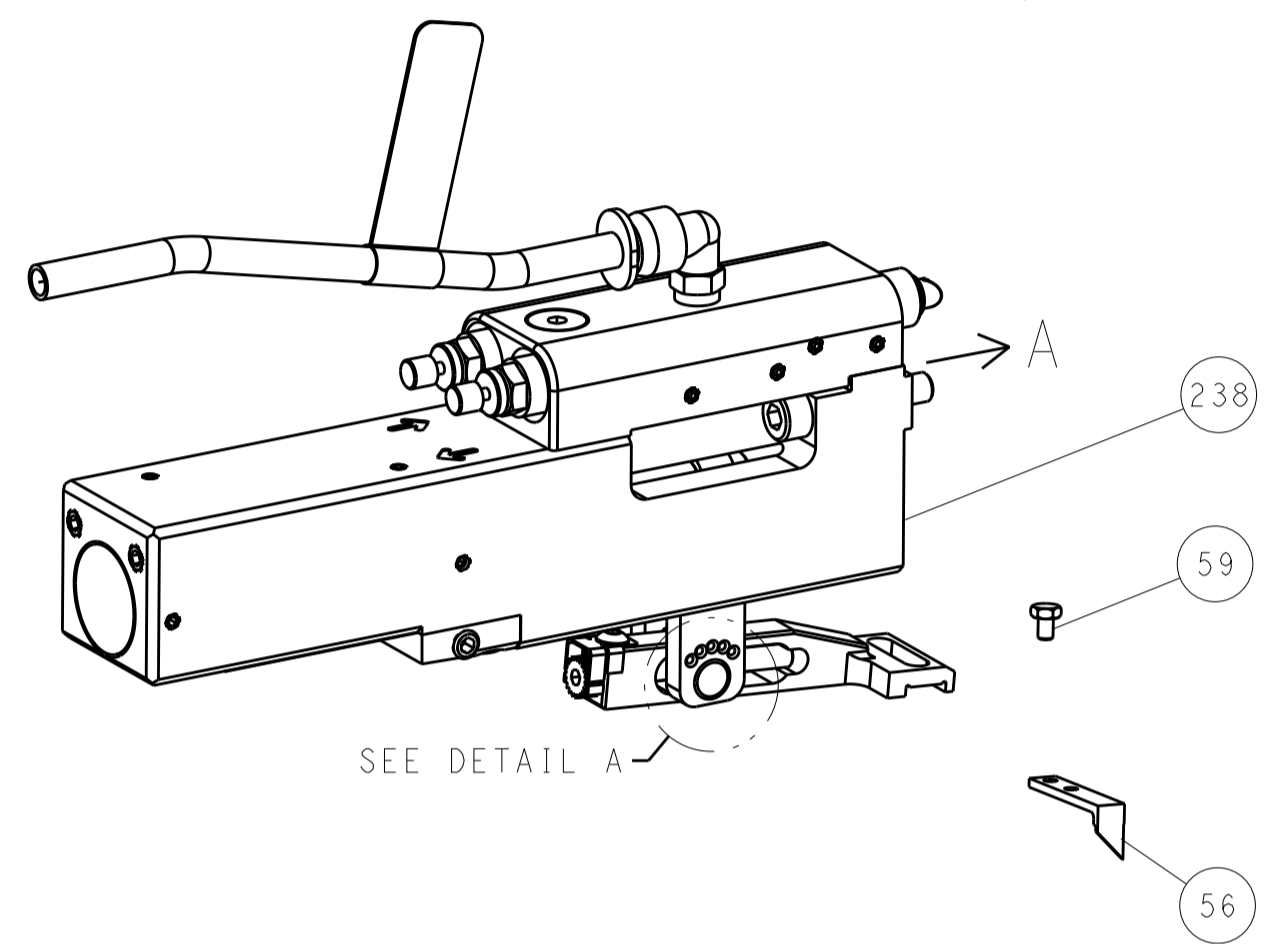


| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | DWN | APVD |
| | | - | | SEE SHEET 1 | | | |

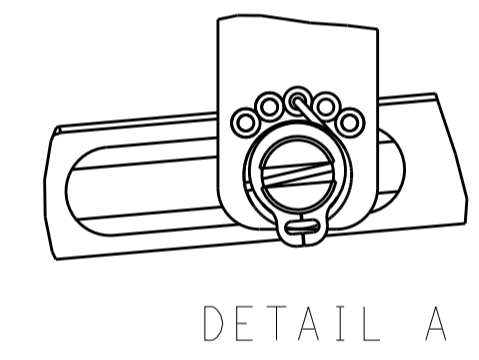
FEED TYPE MECHANICAL



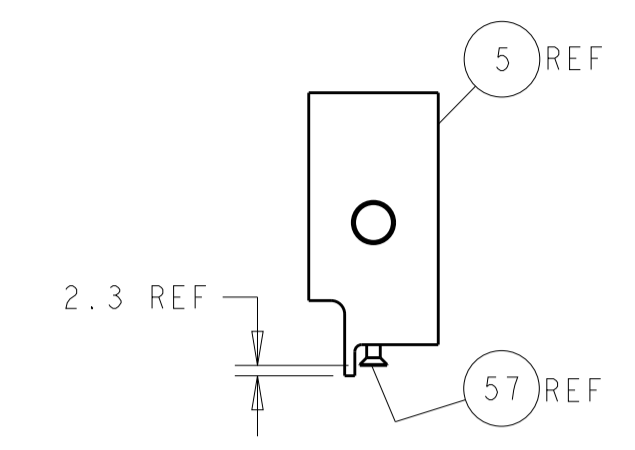
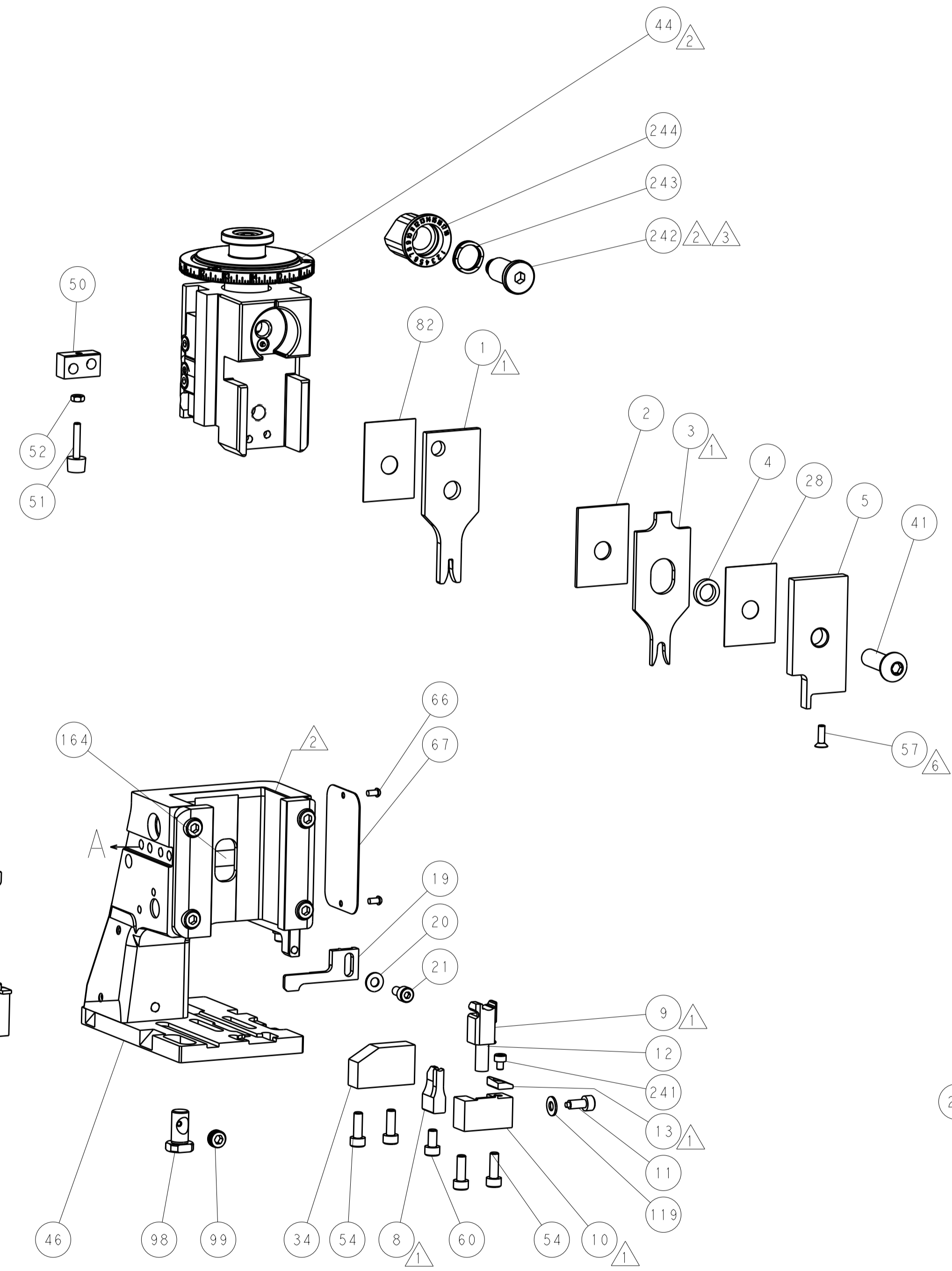
PNEUMATIC



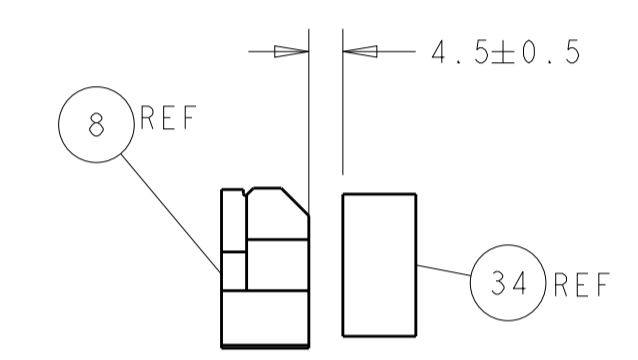
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



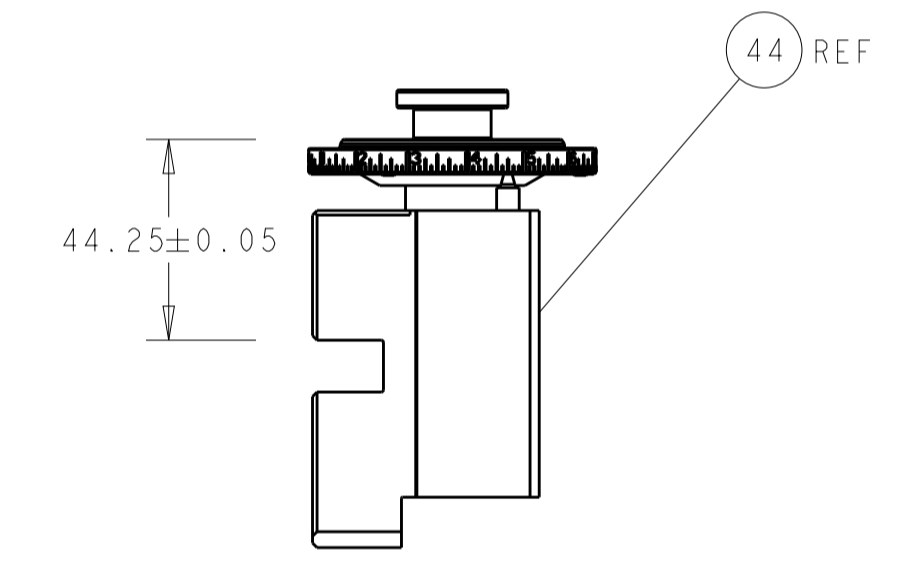
DETAIL A



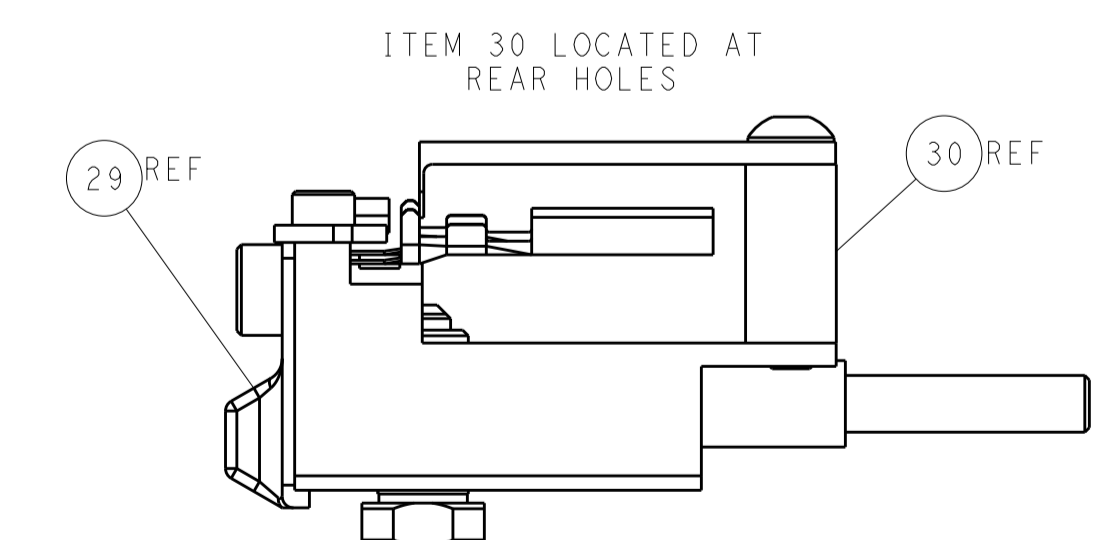
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

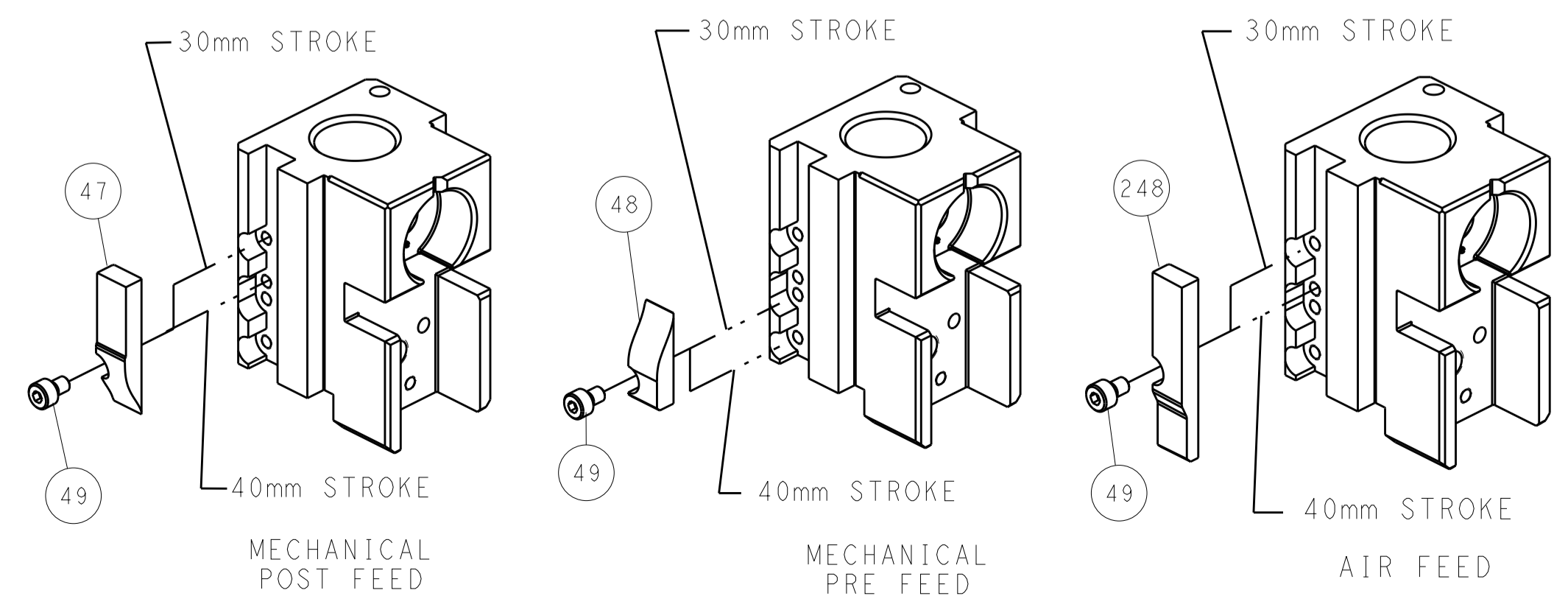


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

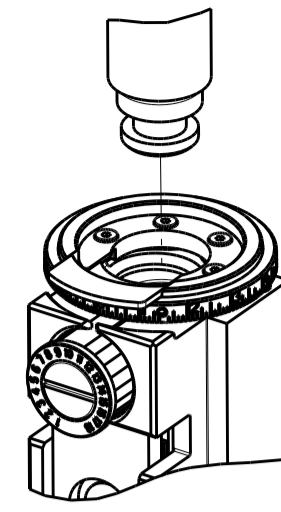


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | | | | |
|-------------|---------|--|---------|--|---------|---|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN: Y. YIN 11DEC2013 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | CHK: G. BAILEY 11DEC2013 | | NAME: Ocean Side Feed Applicator | |
| | | | | APVD: H. GUO 11DEC2013 | | SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2266178 | |
| | | | | WEIGHT: | | RESTRICTED TO: | |
| | | | | Customer Accessible Production Drawing | | SCALE: 1:2 SHEET 2 OF 4 REV B | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2266178-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2266178-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266178-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.78 mm [.070] | F |
| INSUL | 3.94 mm [.155] | O |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-----------|-----------------------------|---|
| TERMINAL NAME: 2.8mm MCP-E TAB CONTACT | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.20-4.80 mm [.165-.189 IN] | | ∅ 3.40 mm MAX [.134 IN MAX] | |
| TERMINAL APPLICATION SPECIFICATION | 114-61033 | - | - |

| TERMINALS APPLIED | | | | |
|-------------------|-------------|----------|---------|--------------------------------|
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL | SEAL INSULATION DIAMETER RANGE |
| 936613-1 | | 368932-1 | | 1.2-2.1 mm |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 0.85mm2 | 1.32+/-0.04 [.052+/-0.0016] | 8.9 |
| 0.50mm2 | 1.15+/-0.03 [.045+/-0.0012] | 10.8 |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|-----------|-----------------------------|---|
| TERMINAL NAME: AMP MCP 2.8K SEALED RECEPT CONTACT | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 0.17-0.19 mm [.007-.007 IN] | | ∅ 3.40 mm MAX [.134 IN MAX] | |
| TERMINAL APPLICATION SPECIFICATION | 114-61033 | - | - |

| TERMINALS APPLIED | | | | |
|-------------------|-------------|----------|---------|--------------------------------|
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL | SEAL INSULATION DIAMETER RANGE |
| 936607-1 | | 368932-1 | | 1.2-2.1 mm |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 0.85mm2 | 1.31+/-0.03 [.052+/-0.0012] | 8.2 |
| 0.50mm2 | 1.18+/-0.03 [.046+/-0.0012] | 9.5 |

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

***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 | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| | | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | - | - | SEE SHEET 1 | - | - | - |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 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 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | 1 | - | 2844940-1 | AIR FEED MODULE | 238 |
| - | 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 |
| - | 4 | 4 | 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 | 1803516-1 | RAM ASSEMBLY, SF PACIFIC | 140 |
| - | 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 | 455888-4 | 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 |
| - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 985575-3 | SCR, FLT SKT HD CAP M3 X 10.0 | 57 |
| - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 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 | 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 | 1-1752356-8 | 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 | 1320928-6 | 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 | 318707-1 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1-1633919-9 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119781-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 238011-4 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 2-2119784-9 | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1 | 1-455888-4 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1-456404-1 | CRIMPER, WIRE PREMIUM | 1 |

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

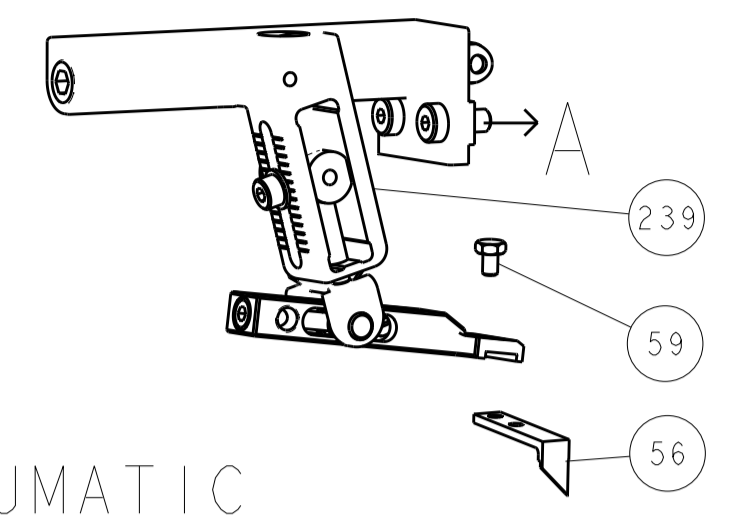
| ITEM NO | DESCRIPTION | DATE | BY | CHKD | APVD |
|-----------|-------------|-----------|--------|-----------|--------|
| -77-22-21 | PART NO | 11DEC2013 | Y. YIN | G. BAILEY | H. GUO |

| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|------|-----------|------------|---------------|
| A1 | 00779 | 2266178 | - |

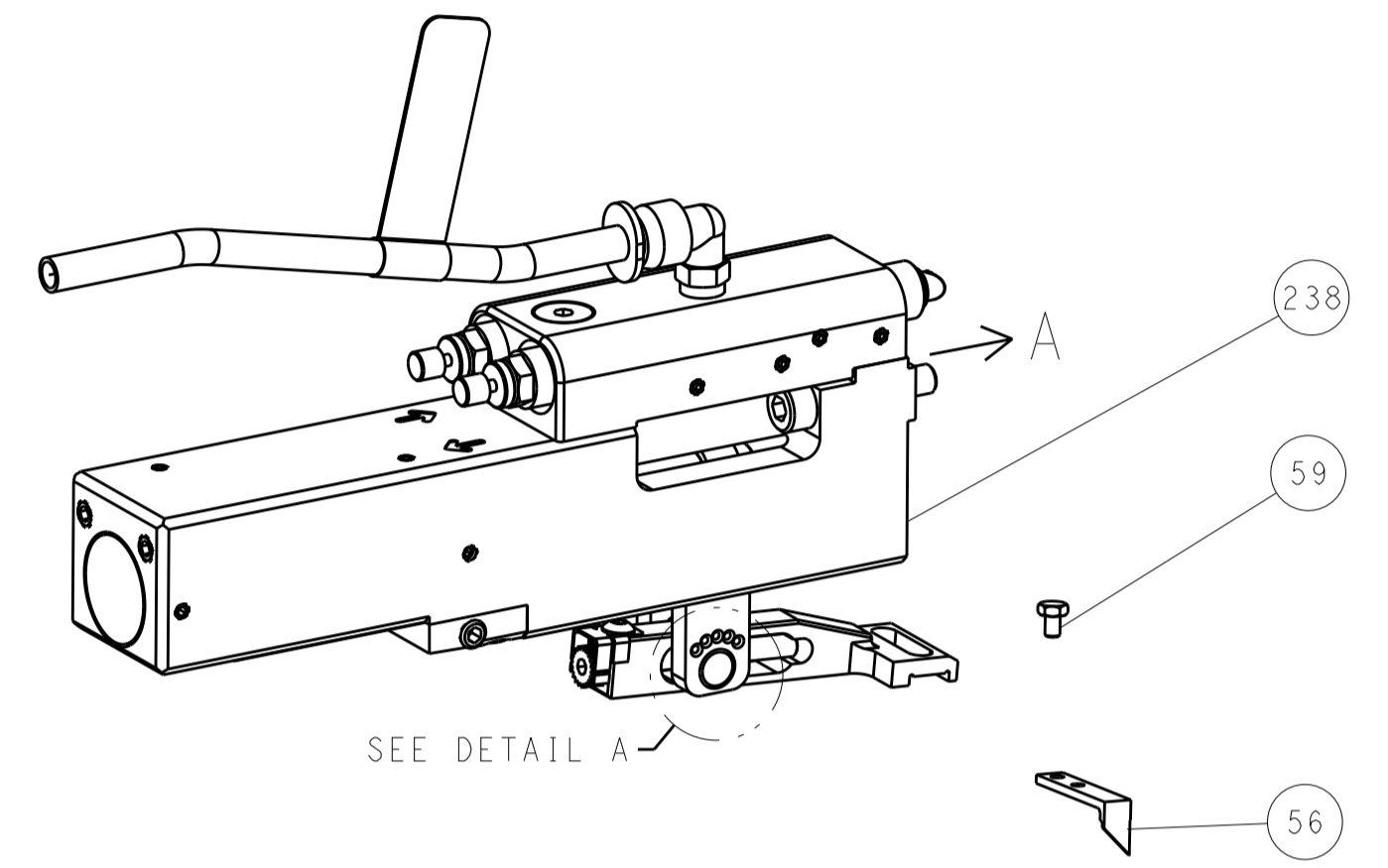
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B

| LOC | | DIST | | REVISIONS | | | |
|-----|--|------|--|-------------|------|----|------|
| A | | 66 | | REV | DATE | BY | APPV |
| - | | | | SEE SHEET 1 | - | - | - |

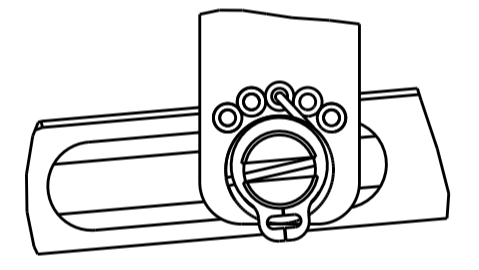
FEED TYPE MECHANICAL



PNEUMATIC

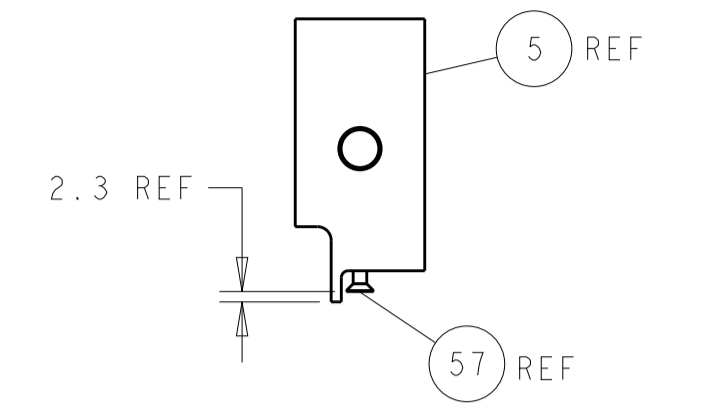
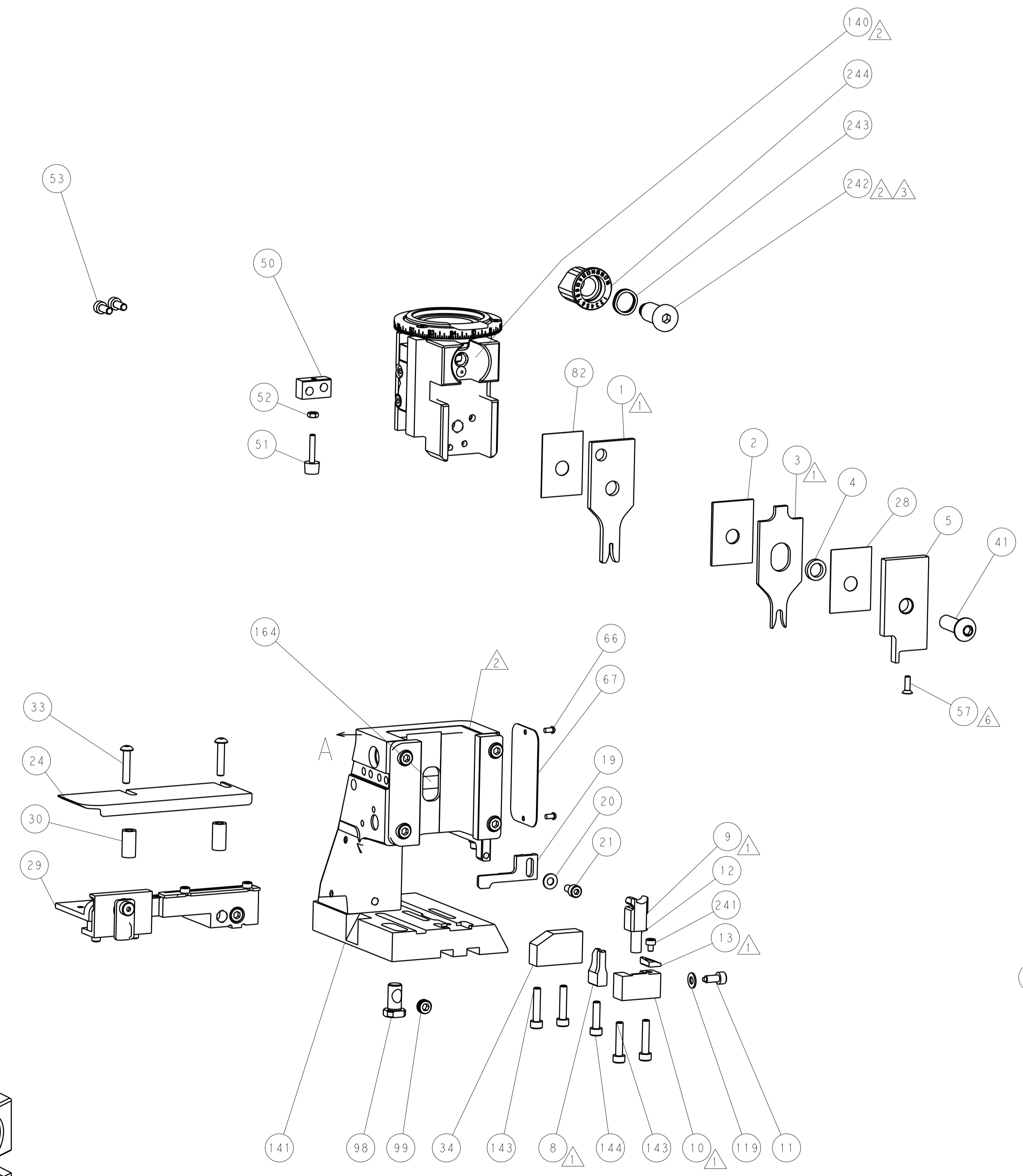
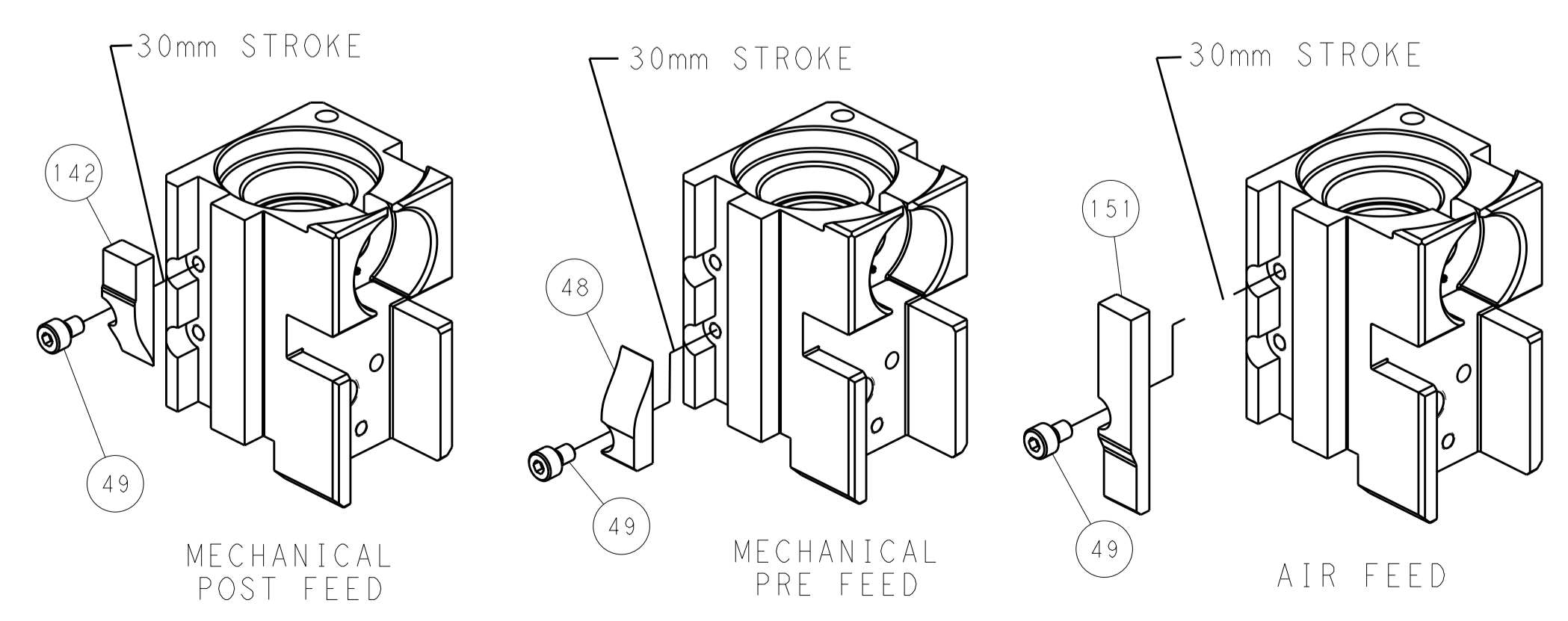


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

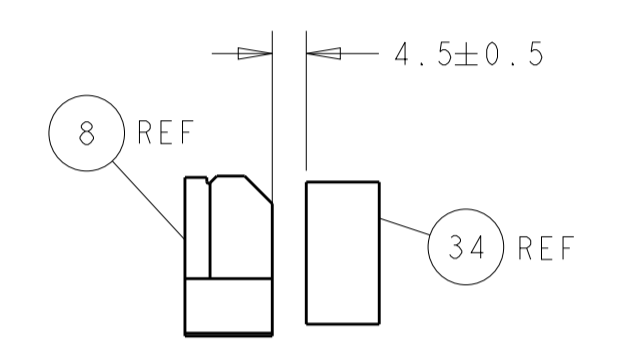


DETAIL A

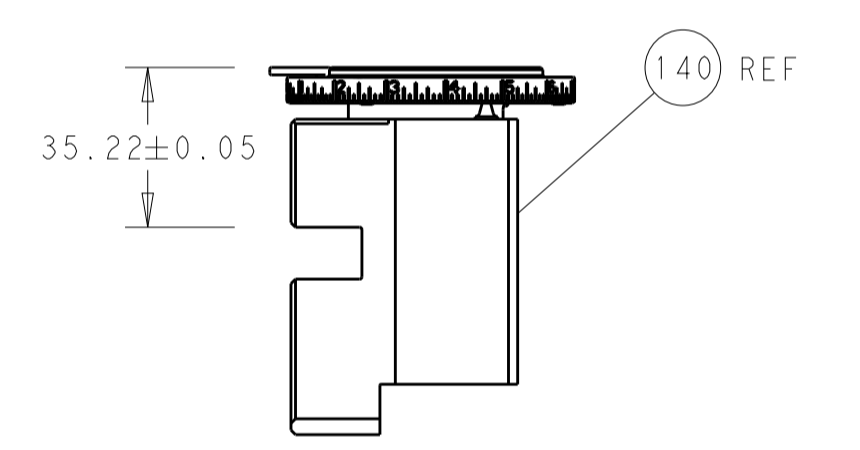
CAM POSITIONS



SHEAR DEPRESSOR DETAIL

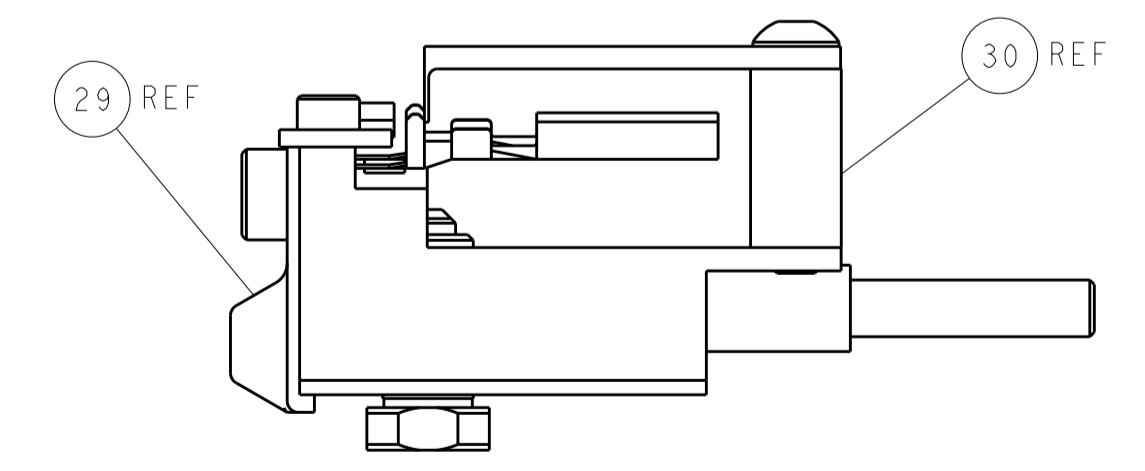


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
REAR HOLES



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: | | DWG: Y. YIN 11DEC2013 | | CHK: G. BAILEY 11DEC2013 | | APVD: H. GUO 11DEC2013 | | NAME: Ocean Side Feed Applicator | |
| mm | 0 PLC | ± | | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO | STE TE Connectivity Harrisburg, PA 17105-3608 | | | |
| | 1 PLC | ± | | SCALE | 1:2 | SHEET 4 OF 4 | REV B | Customer Accessible Production Drawing | | | |
| | 2 PLC | ± | | Customer Accessible Production Drawing | | | | | | | |
| | 3 PLC | ± | | Customer Accessible Production Drawing | | | | | | | |
| | 4 PLC | ± | | Customer Accessible Production Drawing | | | | | | | |
| | ANGLES | ± | | Customer Accessible Production Drawing | | | | | | | |
| MATERIAL | FINISH | | | WEIGHT | | A 00779 ©=2266178 | | Customer Accessible Production Drawing | | | |