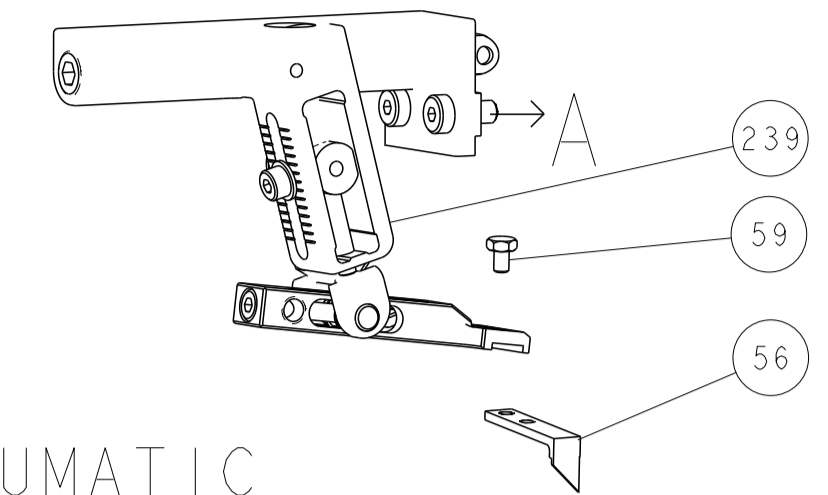
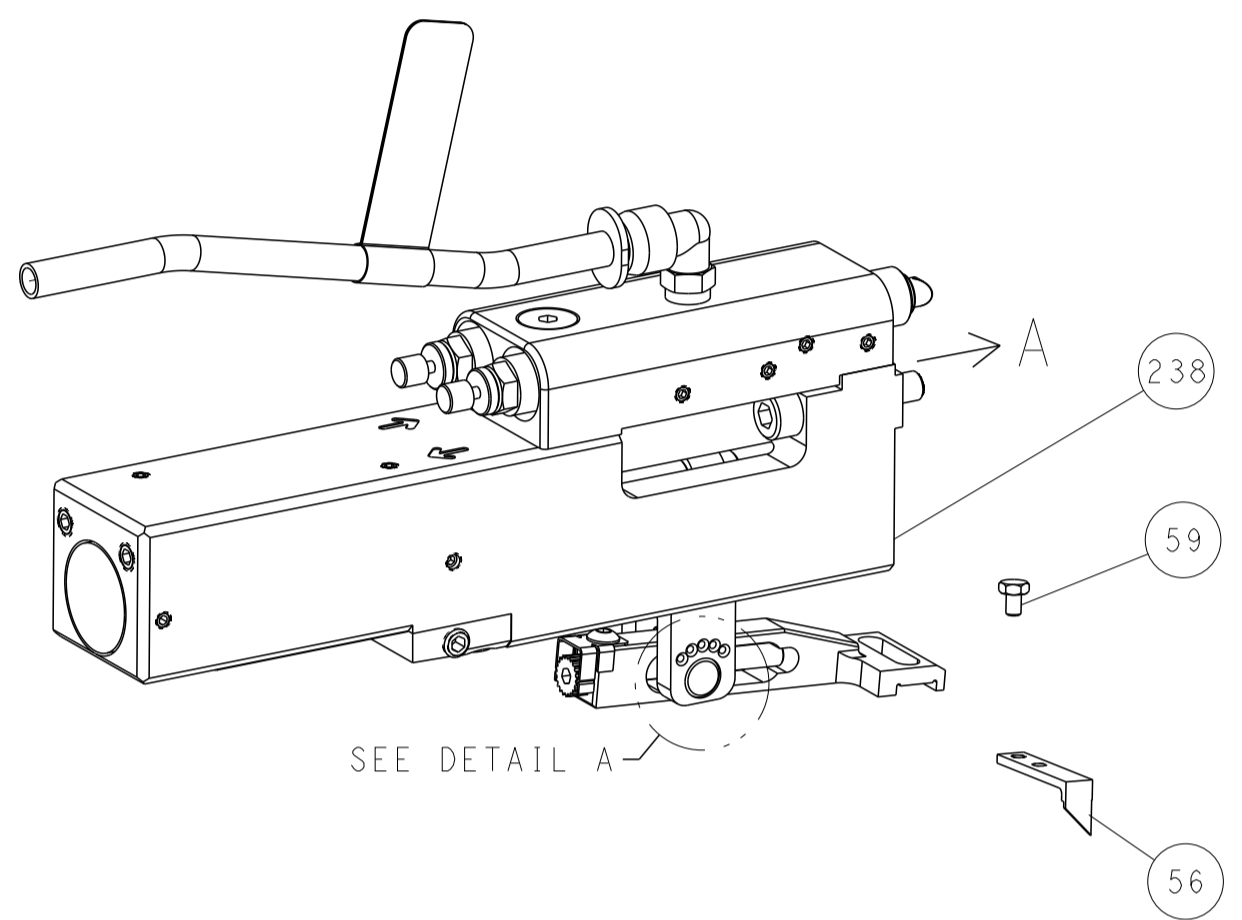


| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| A | 66 | P | LYN | DESCRIPTION | DATE | DWN | APVD |
| | | - | - | SEE SHEET 1 | - | - | - |

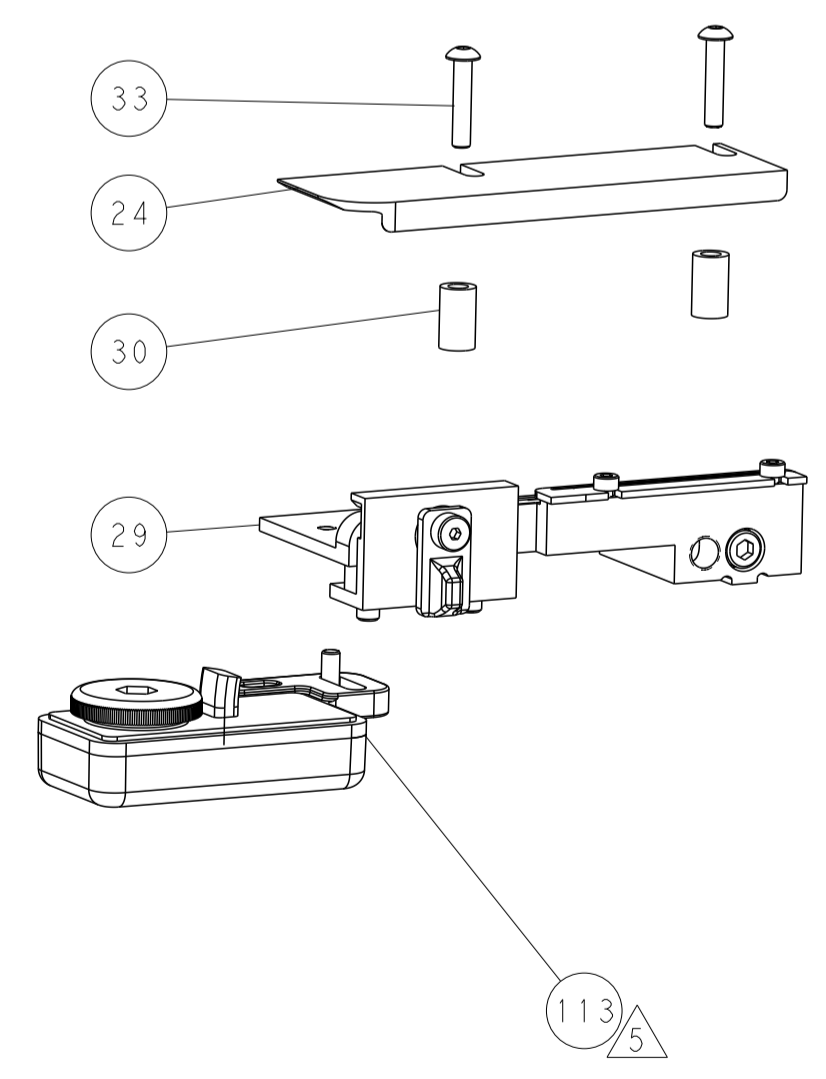
FEED TYPE MECHANICAL



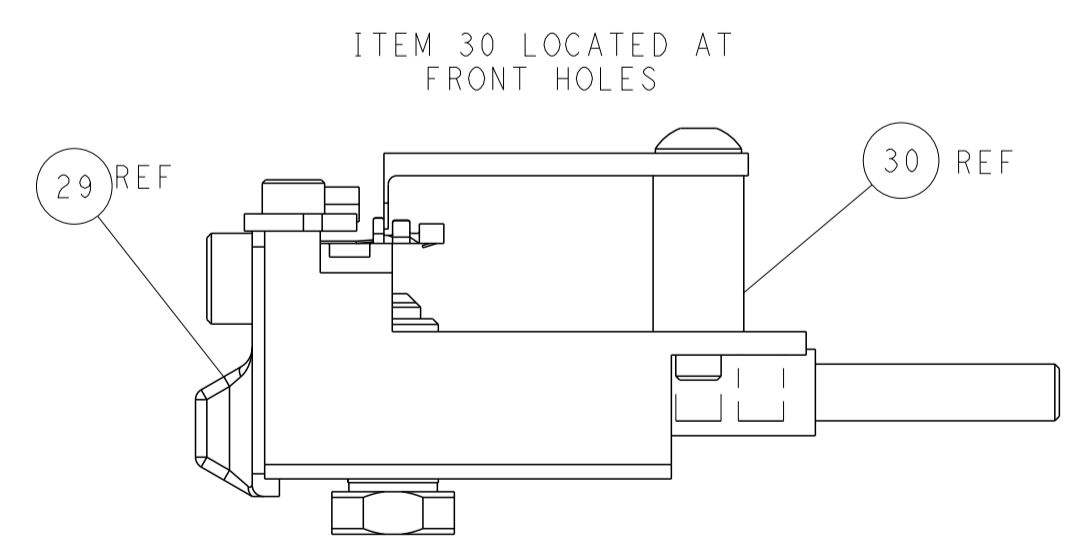
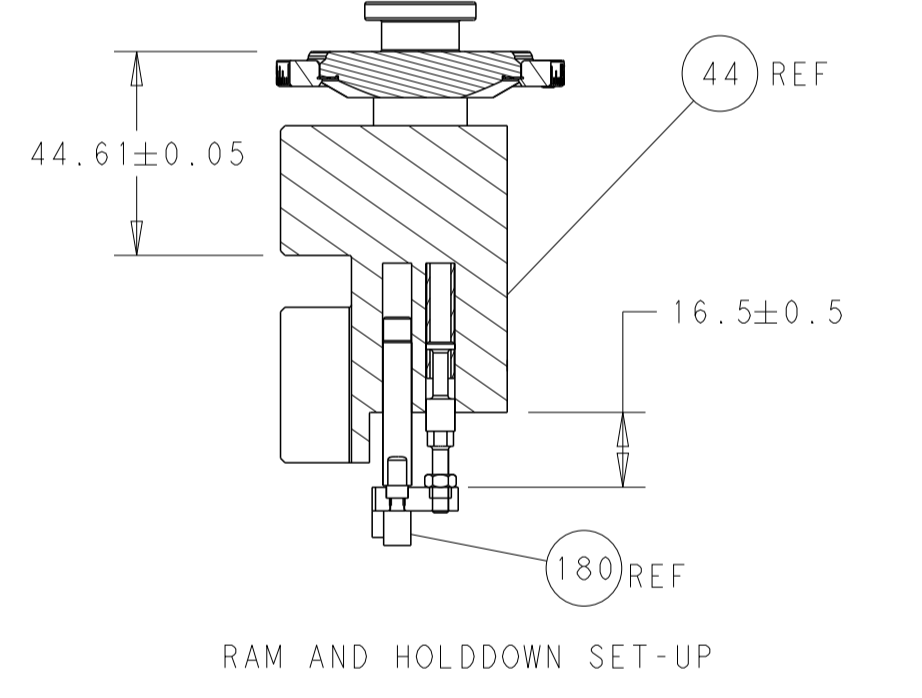
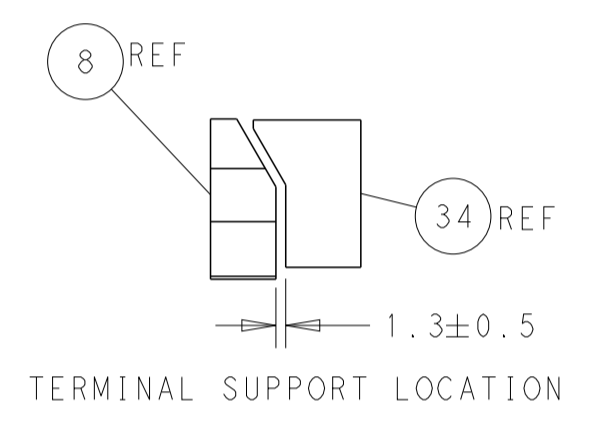
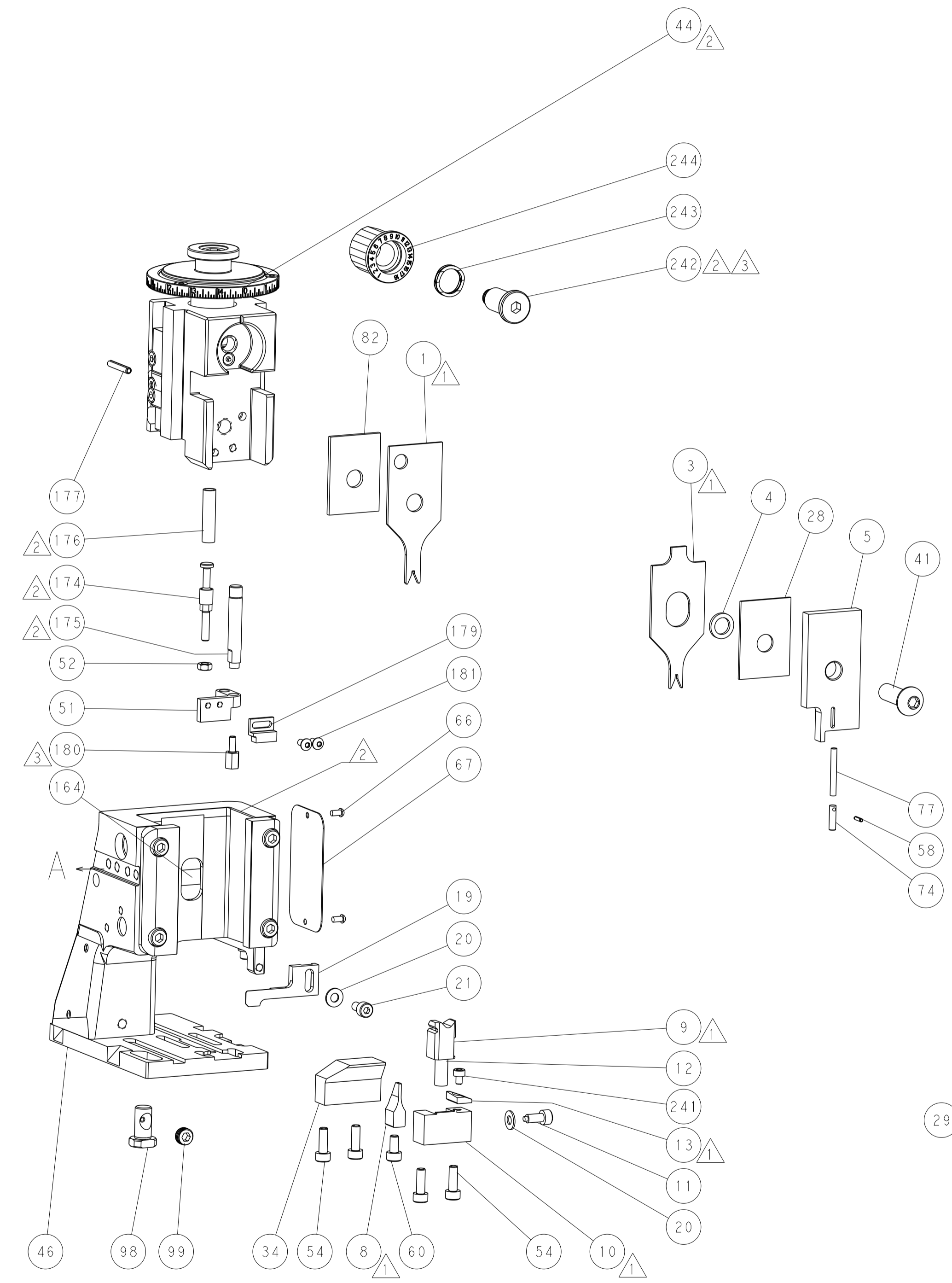
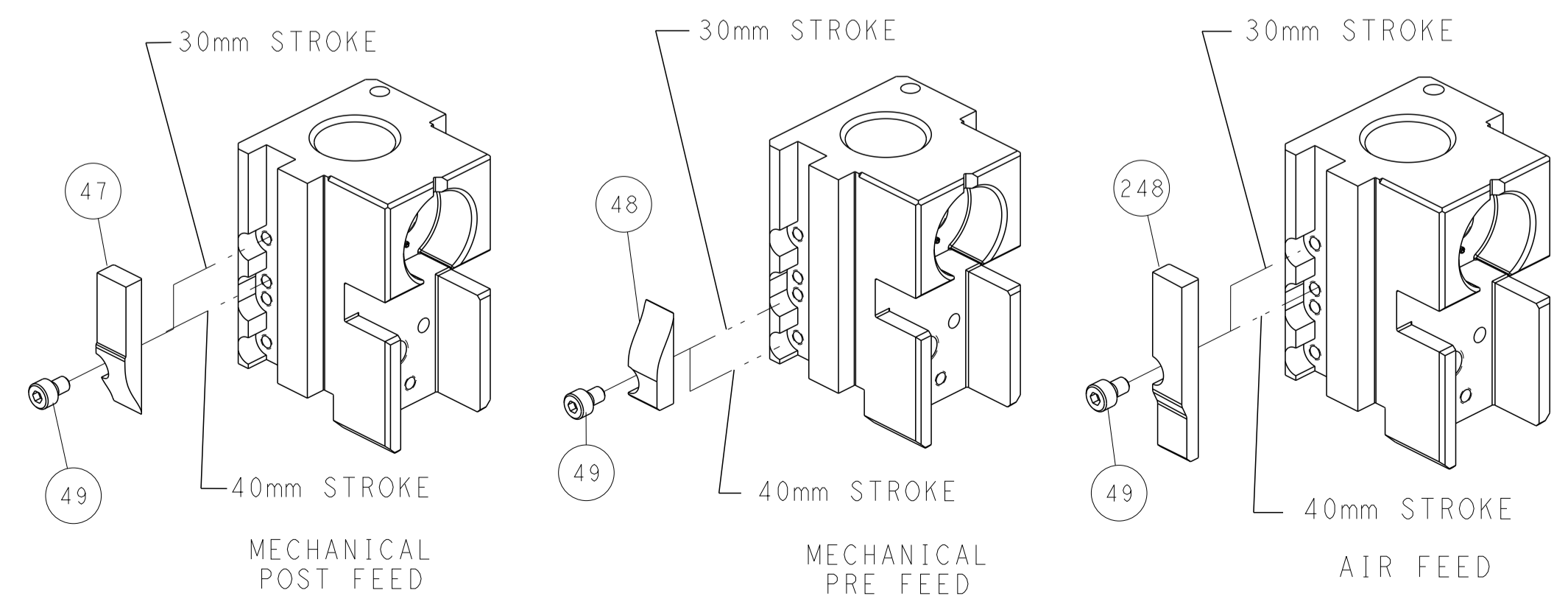
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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THIS DRAWING IS UNPUBLISHED.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: L. GROSS 13JUN2014 CHK: T. ELBIN 13JUN2014 APVD: D. STOUGH 13JUN2014 | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2266350 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH | APPLICATION SPEC: - PRODUCT SPEC: - WEIGHT: - SCALE: 1:2 | SHEET 2 OF 4 REV D | RESTRICTED TO: - |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2266350-1 | D | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2266350-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266350-7 | C | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.27 mm [.050] | F |
| INSUL | 1.37 mm [.054] | F |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION | |
|---|------------------------------|
| TERMINAL NAME: SMALL TERMINAL GT8 SERIES | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE |
| 2.00-2.50 mm [.079-.098 IN] | ∅1.30-1.50 mm [.051-.059 IN] |
| TERMINAL APPLICATION SPECIFICATION | EDC4-166427-04 Rev 1 |
| TERMINALS APPLIED | |
| TE TERMINAL | HIROSE TERMINAL |
| 2113250-1 | GT8E-2022SCF |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 20 AWG | 0.92 +/- 0.03 [.036 +/- .001] | 9.1 |
| 22 AWG | 0.83 +/- 0.03 [.033 +/- .001] | 10.1 |

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.

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

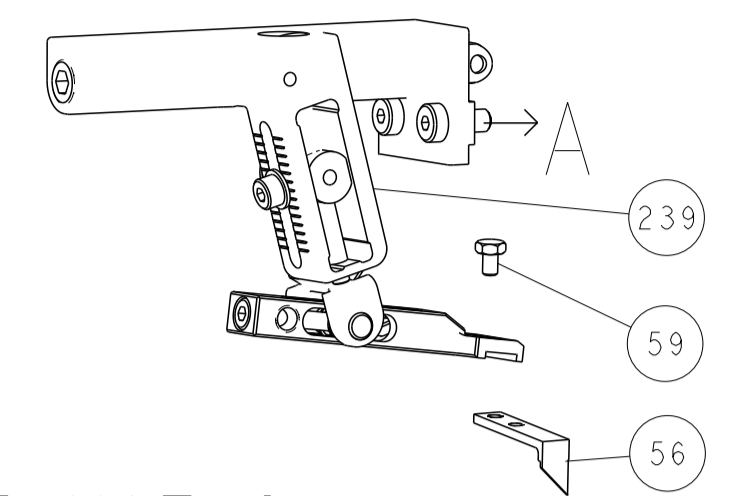
| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | 1 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 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 |
| - | 2 | 2 | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6) | 181 |
| - | 1 | 1 | 1-1752354-5 | STANDOFF, HOLD-DOWN | 180 |
| - | 1 | 1 | 1-1976053-0 | LOCATER BLOCK, TERMINAL | 179 |
| - | 1 | 1 | 993111-1 | PIN, SLOTTED SPRING 3.0 X 20.0 | 177 |
| - | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 |
| - | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 |
| - | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 |
| - | 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 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 1-455888-8 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 5-547505-2 | 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 | 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 |
| - | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | 1 | 1 | 1901681-4 | HOLDDOWN, TERMINAL | 51 |
| - | 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 | 2-1752356-5 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1320928-2 | 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 | 2119533-4 | 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 | 1 | 1803333-3 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119780-9 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 2-238011-5 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 2-1803326-1 | CRIMPER, INSULATION F | 3 |
| - | - | - | - | - | 2 |
| - | 1 | 1 | 1803324-2 | CRIMPER, WIRE | 1 |

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

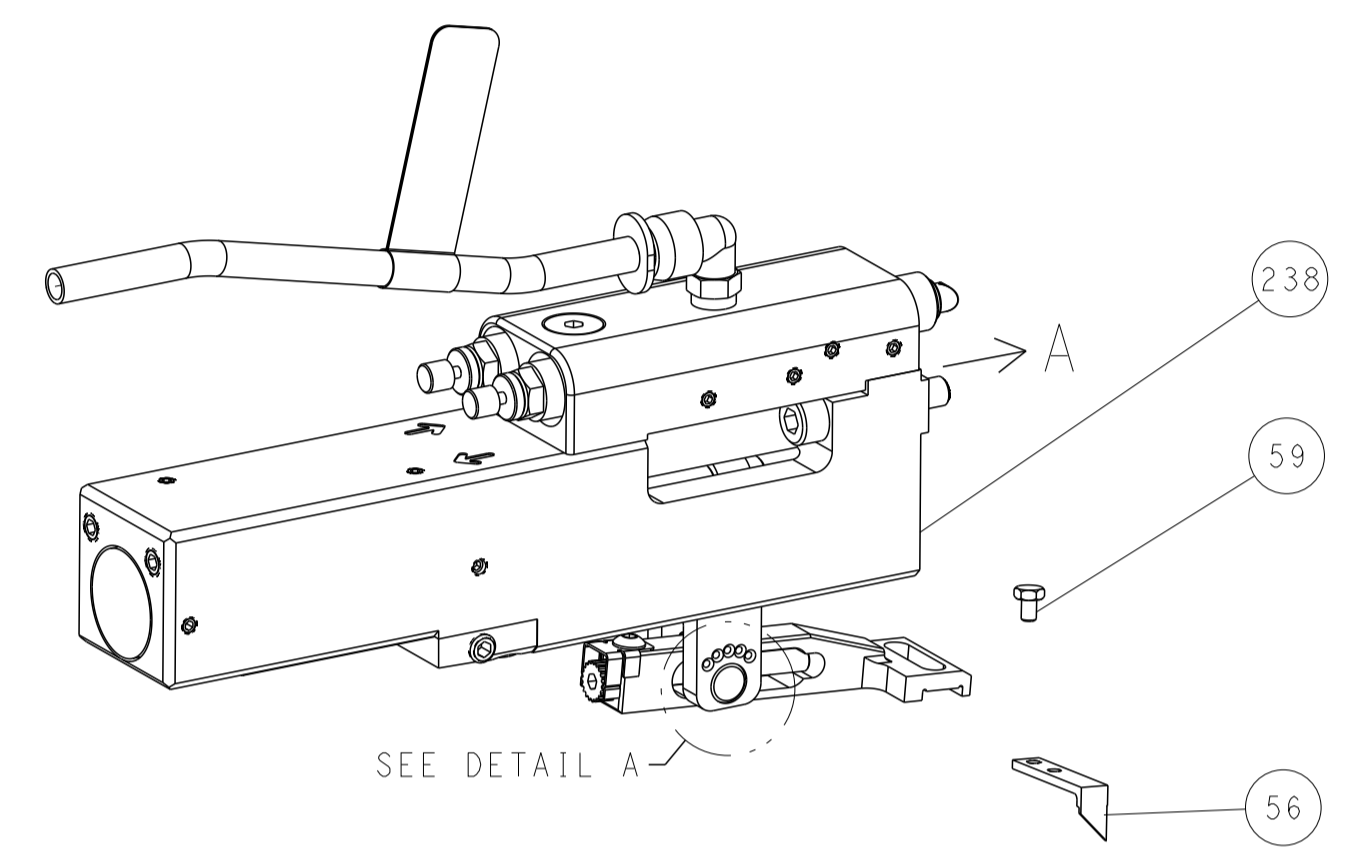
| ITEM NO | DESCRIPTION |
|---------|-------------------------------------|
| 1 | CRIMPER, WIRE |
| 2 | - |
| 3 | CRIMPER, INSULATION F |
| 4 | BLOCK, CRIMPER SPACER |
| 5 | DEPRESSOR, SHEAR |
| 6 | - |
| 7 | - |
| 8 | ANVIL, COMBINATION |
| 9 | FLOATING SHEAR, FRONT |
| 10 | SHEAR HOLDER, FRONT |
| 11 | STOP, SHEAR |
| 12 | SPRING, COMPRESSION |
| 13 | INSERT, SHEAR |
| 19 | STRIPPER, SIDE FEED |
| 20 | WASHER, FLAT, REG M4 |
| 21 | SCR, SKT HD CAP, RoHS, M4 X 8.0 |
| 24 | STRIP GUIDE |
| 28 | SPACER, CRIMPER |
| 29 | ASSEMBLY, STRIP GUIDE |
| 30 | SPACER, CYLINDRICAL, STRIP GUIDE |
| 33 | SCR, BHSC, RoHS (M4 X 20) |
| 34 | SUPPORT, TERMINAL |
| 41 | SCR, BHSC, RoHS (M8 X 25) |
| 48 | FEED CAM, PRE FEED |
| 49 | SCR, SKT HD CAP M4 X 6.0 |
| 51 | HOLDDOWN, TERMINAL |
| 52 | NUT, HEX, REG, RoHS, M3.5 |
| 56 | PAWL, FEED |
| 58 | PIN, SLOTTED SPRING .062 X .250 |
| 59 | SCR, HEX HD CAP, M4 X 6.0 |
| 66 | SCREW, DRIVE, RH, RoHS, 2 x .188 |
| 67 | TAG, IDENTIFICATION |
| 71 | DOCUMENTATION PACKAGE |
| 74 | HOLDER, INS |
| 77 | SPRING, COMPRESSION |
| 82 | SPACER, CRIMPER |
| 98 | POST, LOCKING |
| 99 | SCREW, LOCKING |
| 113 | ASSY, LUBRICATOR, SIDE FEED |
| 140 | RAM ASSEMBLY, SF PACIFIC |
| 141 | APPLICATOR BASIC ASSEMBLY, SF |
| 142 | FEED CAM, POST FEED |
| 143 | SCR, SKT HD CAP, RoHS, M4 X 20 |
| 144 | SCR, SKT HD CAP, RoHS, M4 X 16 |
| 151 | FEED CAM, AIR FEED |
| 164 | COUNTER, MAGNETIC |
| 174 | GUIDE PIN, HOLDDOWN |
| 175 | GUIDE PIN, HOLDDOWN |
| 176 | SPRING, COMPRESSION |
| 177 | PIN, SLOTTED SPRING 3.0 X 20.0 |
| 179 | LOCATER BLOCK, TERMINAL |
| 180 | STANDOFF, HOLD-DOWN |
| 181 | SCR, BHSC, RoHS (M3 X 6) |
| 238 | AIR FEED MODULE |
| 239 | MECHANICAL FEED ASSEMBLY |
| 241 | SCR, SKT HD CAP M3 X 4.0 |
| 242 | RETAINER, INSULATION DIAL |
| 243 | WASHER, WAVE SPRING, CREST-TO-CREST |
| 244 | CAM, SNAIL, INSULATION ADJUSTMENT |

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

FEED TYPE MECHANICAL



PNEUMATIC

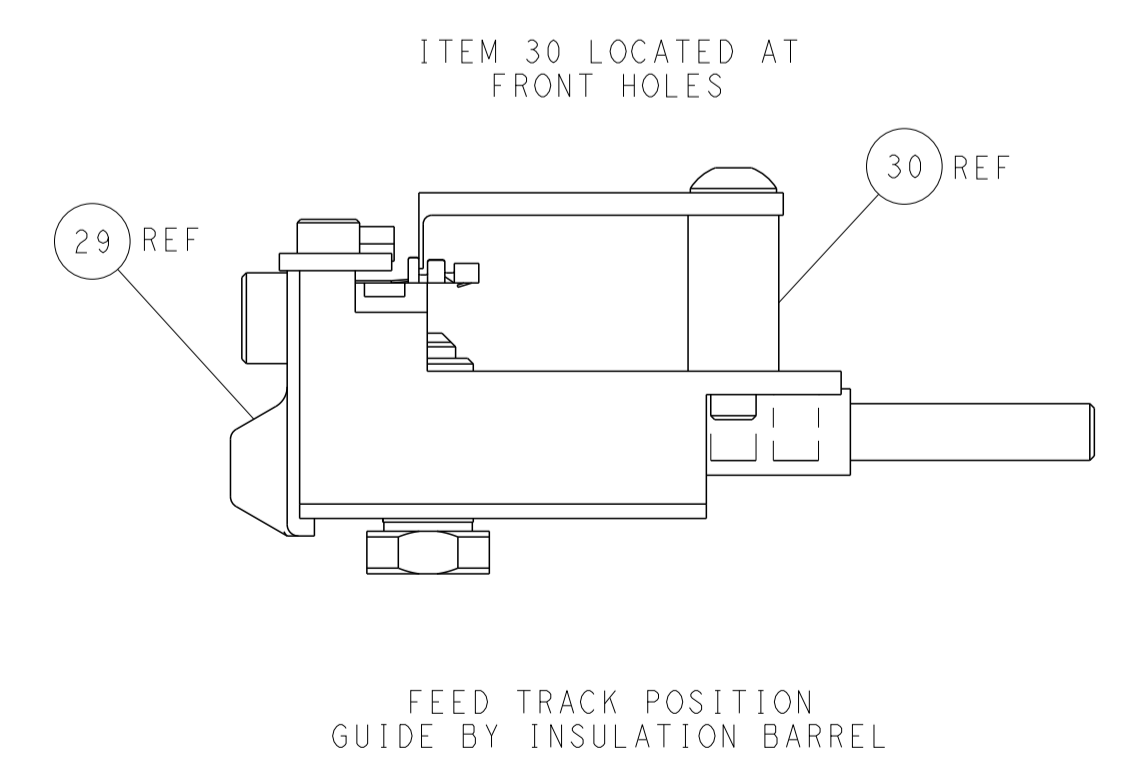
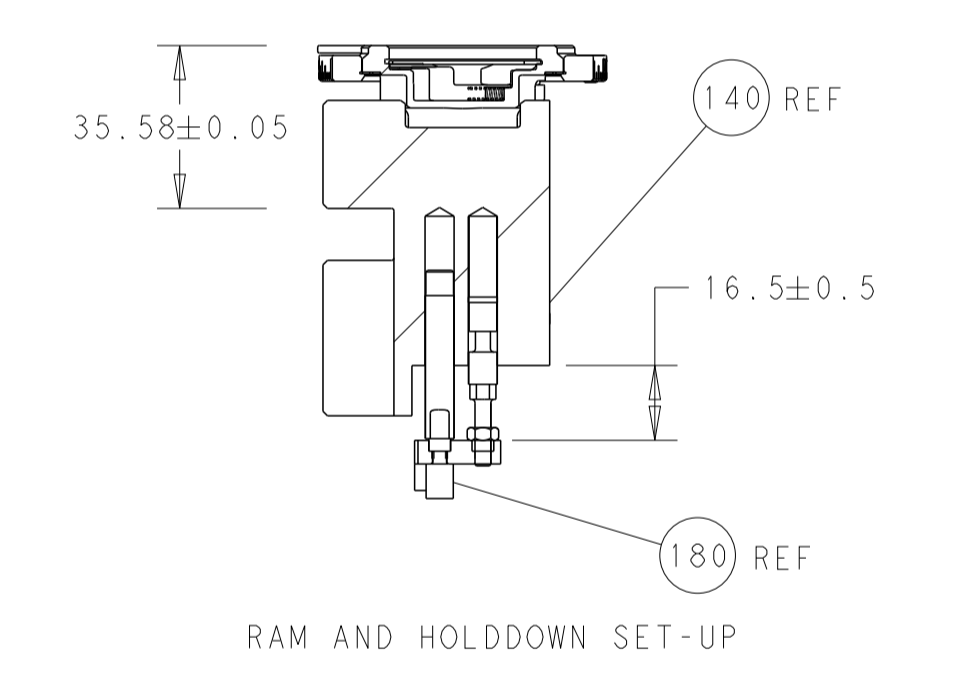
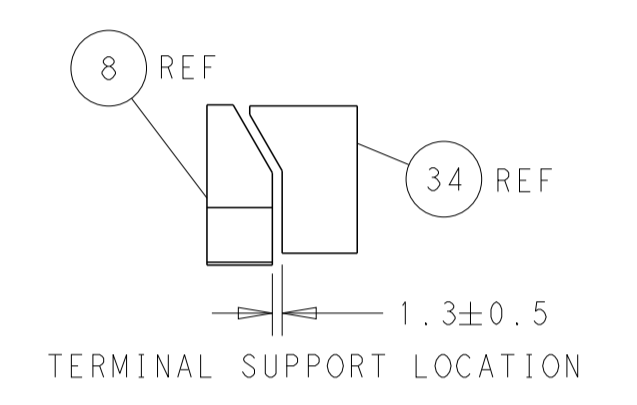
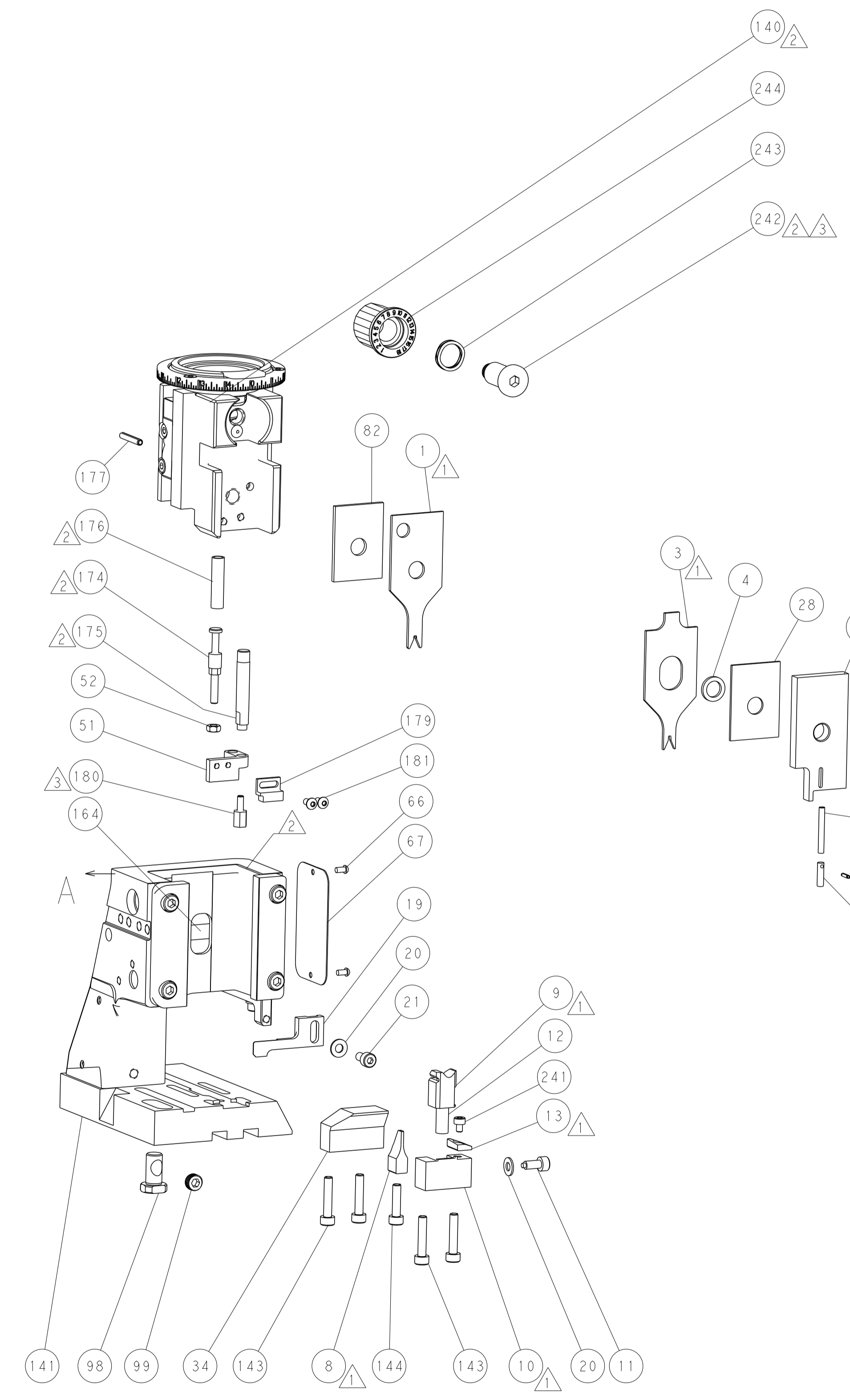
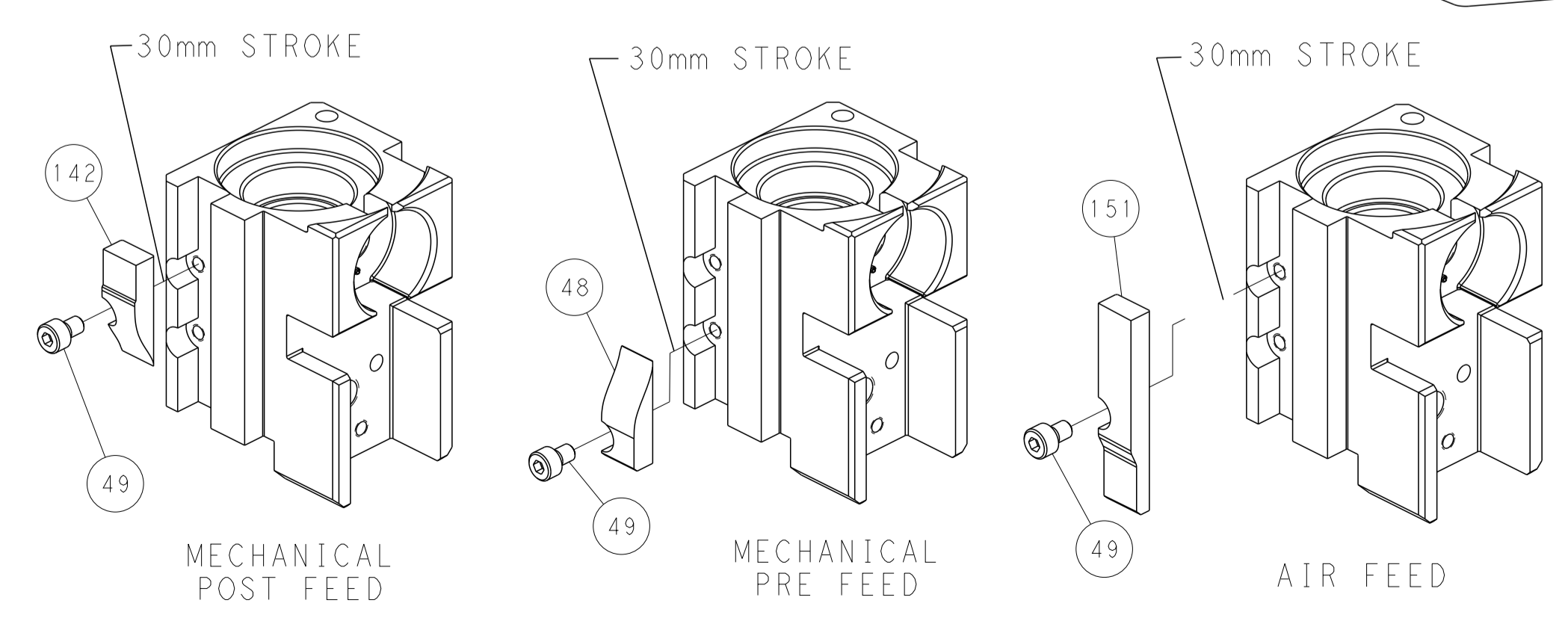


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS



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

| | | | |
|--|---|--|--|
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| DIMENSIONS: mm | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | SIZE A1 CAGE CODE 00779 DRAWING NO C-2266350 | RESTRICTED TO Customer Accessible Production Drawing SCALE 1:2 SHEET 4 OF 4 REV D |