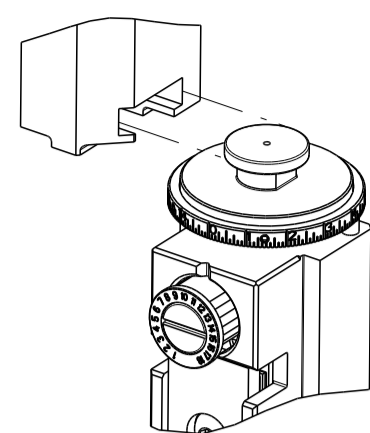


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266355-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266355-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266355-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SOLDER CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.83-5.59 mm [.190-.220 IN]		Ø2.20-3.10 mm [.087-.122 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2088		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928782-1	928782-3		
928782-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.39 +/- 0.05 [.094 +/- .002]	6.7
2.00mm2	2.28 +/- 0.05 [.090 +/- .002]	8.1
1.50mm2	2.17 +/- 0.05 [.085 +/- .002]	9.1
1.00mm2	2.06 +/- 0.05 [.081 +/- .002]	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.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- POSITION ITEM 99 TO A DEPTH OF .50 [12.70mm] FROM BOTTOM OF ITEM 29.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- PLACE ITEM 19 BETWEEN 261 AND 1.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

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					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		E		ECR-18-005121	05APR2018	AW	CT
		F		ECR-18-018634	28NOV2018	FZ	KZ
		G		ECR-19-005371	03APR2019	MZ	YY
		H		ECR-22-129386	11FEB2022	JWC	TE

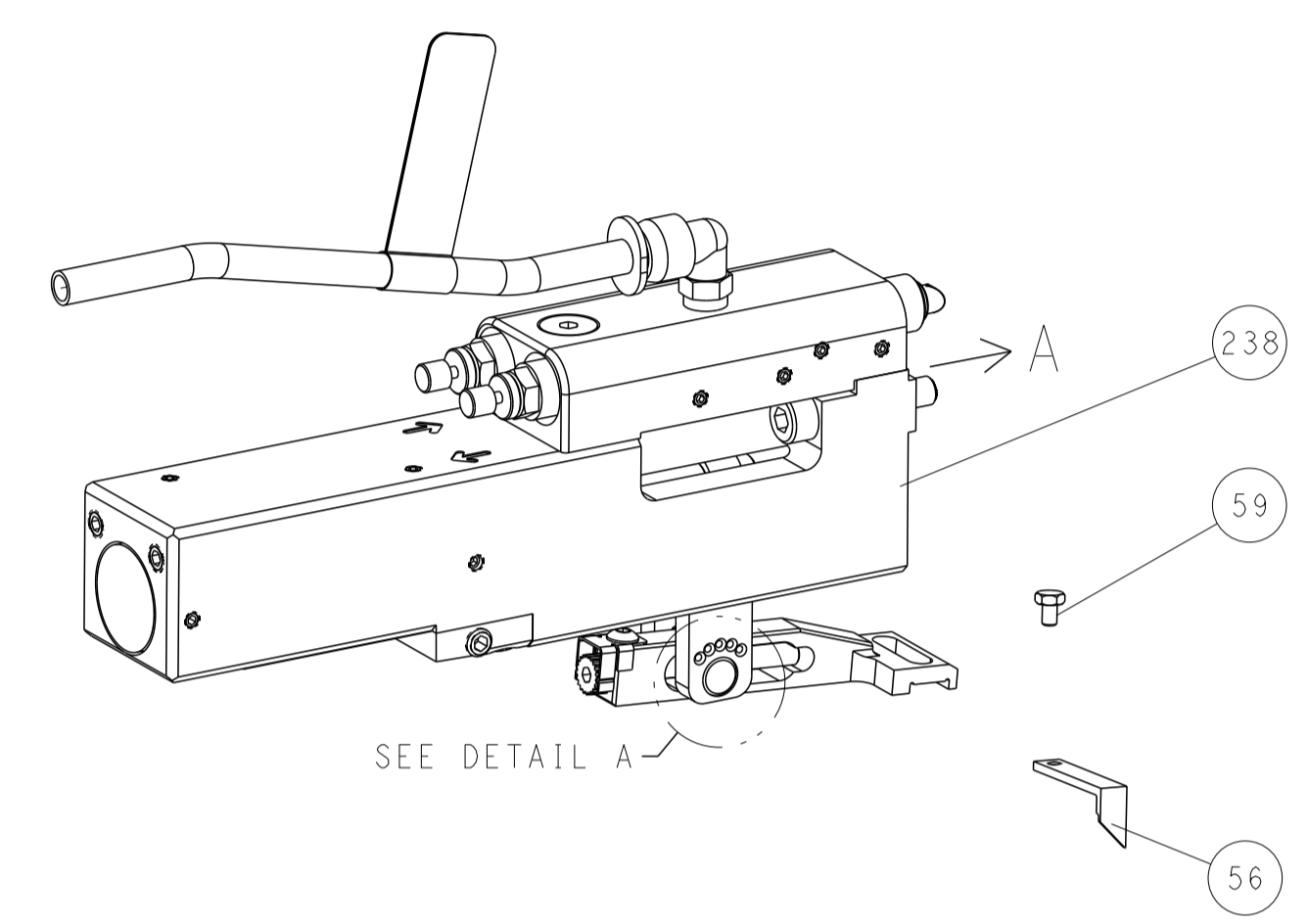
-	1	1	2391931-1	SIZING TOOL	261
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	124
-	1	1	1-22281-8	SPRING, COMPRESSION	123
	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	100
	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	2844908-1	SCREW, LOCKING	97
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1-455888-8	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	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	1338683-8	FEED PAWL	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1-1803583-7	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
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2-2844938-4	PLATE, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	22281-9	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-1	STRIP GUIDE	24
-	1	1	1-690438-0	FRONT STRIP GUIDE	23
-	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	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-7	STOP, SHEAR	11
	1	1	1-2119805-4	SHEAR HOLDER, FRONT	10
	1	1	1633838-1	FLOATING SHEAR, FRONT	9
	1	2	1633840-2	ANVIL, COMBINATION .130	8
-	1	1	1-455888-1	SPACER, CRIMPER	7
-	-	-	-	-	6
-	1	1	1803080-8	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	2	9-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
	1	2	7-1633860-4	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:				
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE	1:2	SHEET	1	OF	4	REV	H

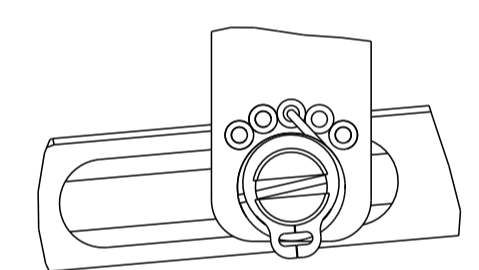
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

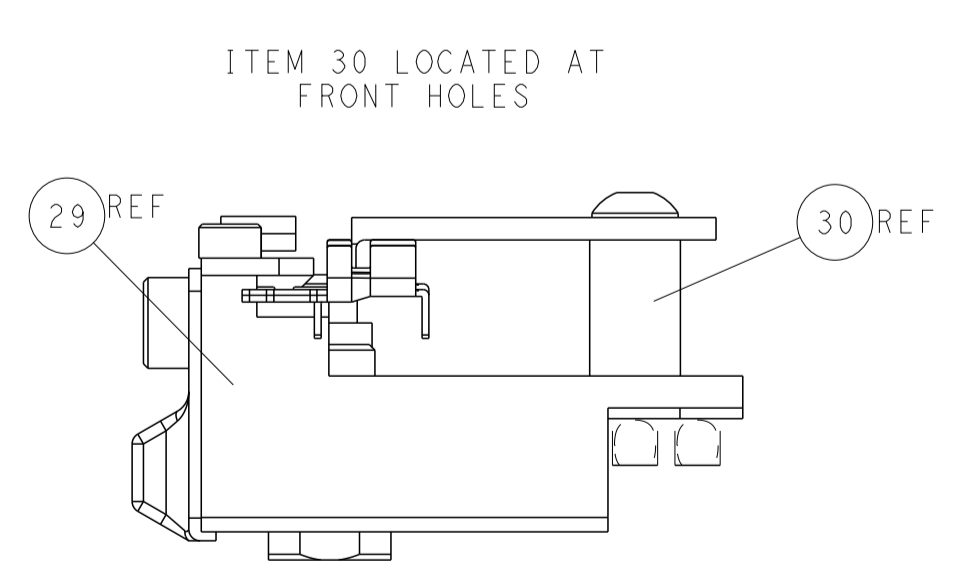
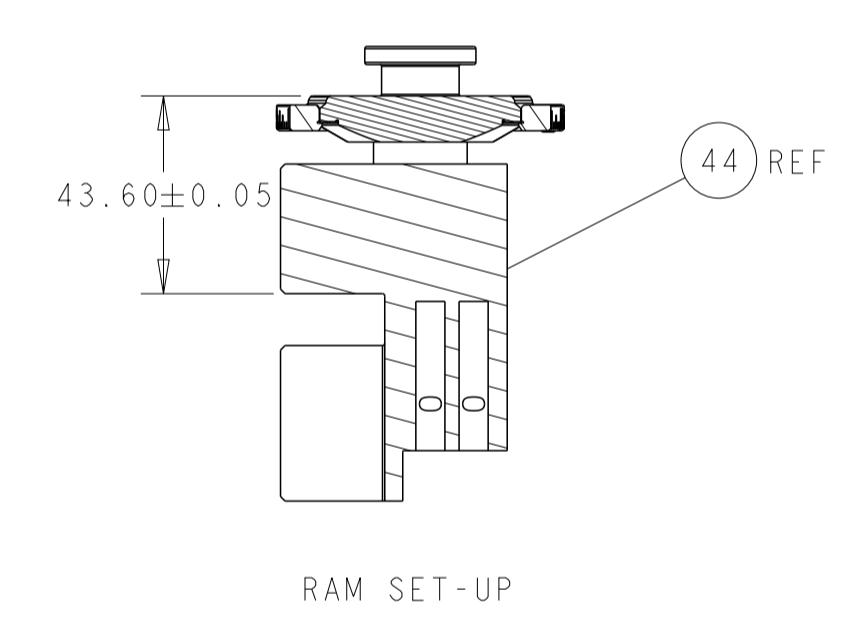
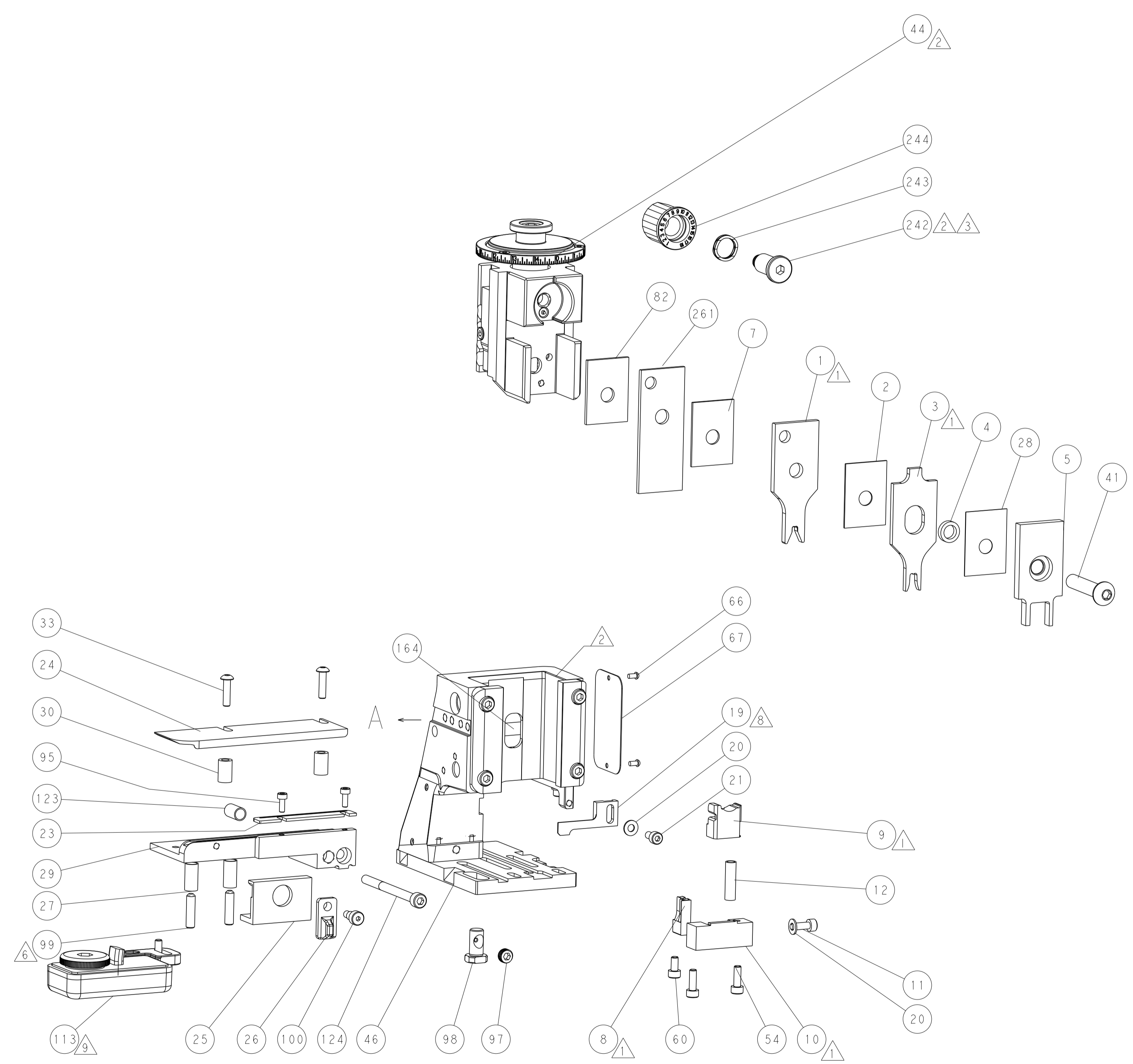
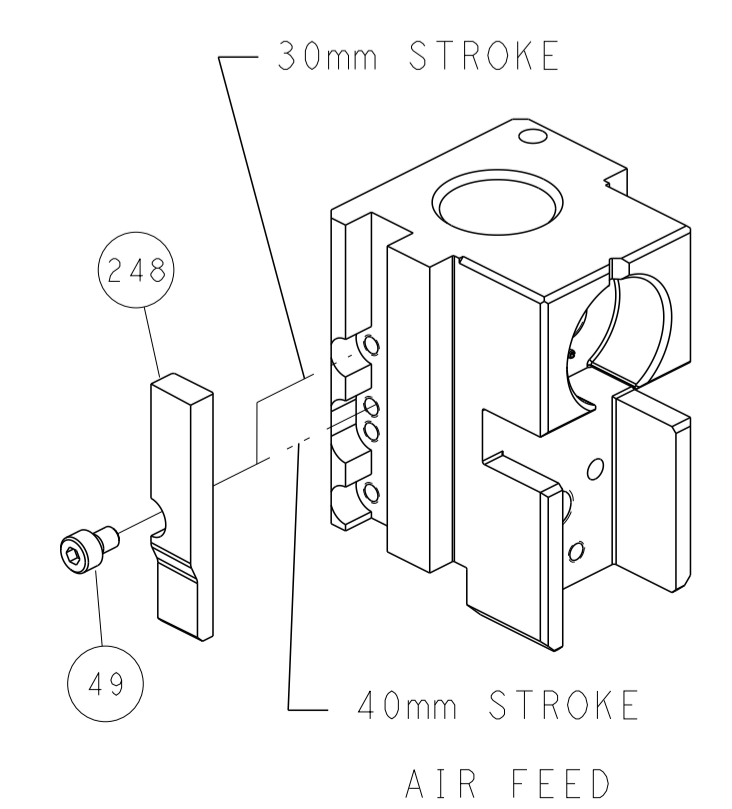


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITION



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:		OWN: BOB HIGMAN 28JUN2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD: D. STOUGH 28JUN2014		NAME: Ocean Side Feed Applicator	
				PRODUCT SPEC:		SIZE: A1	
				APPLICATION SPEC:		CAGE CODE: 00779	
				WEIGHT:		DRAWING NO: C-2266355	
				Customer Accessible Production Drawing		SCALE: 1:2 SHEET 2 OF 4 REV H	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266355-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266355-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SOLDER CONTACT			
WIRE STRIP LENGTH 4.83-5.59 mm [1.90-.220 IN]		INSULATION DIAMETER RANGE Ø2.20-3.10 mm [1.087-.122 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2088			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928782-1	928782-3		
928782-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.39 +/- 0.05 [1.094 +/- .002]	6.7
2.00mm2	2.28 +/- 0.05 [1.090 +/- .002]	8.1
1.50mm2	2.17 +/- 0.05 [1.085 +/- .002]	9.1
1.00mm2	2.06 +/- 0.05 [1.081 +/- .002]	10.1

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 POSITION ITEM 99 TO A DEPTH OF .50 [12.70mm] FROM BOTTOM OF ITEM 29.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 8 PLACE ITEM 19 BETWEEN 261 AND 1.
- 9 TERMINAL LUBRICANT IS RECOMMENDED.

***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)

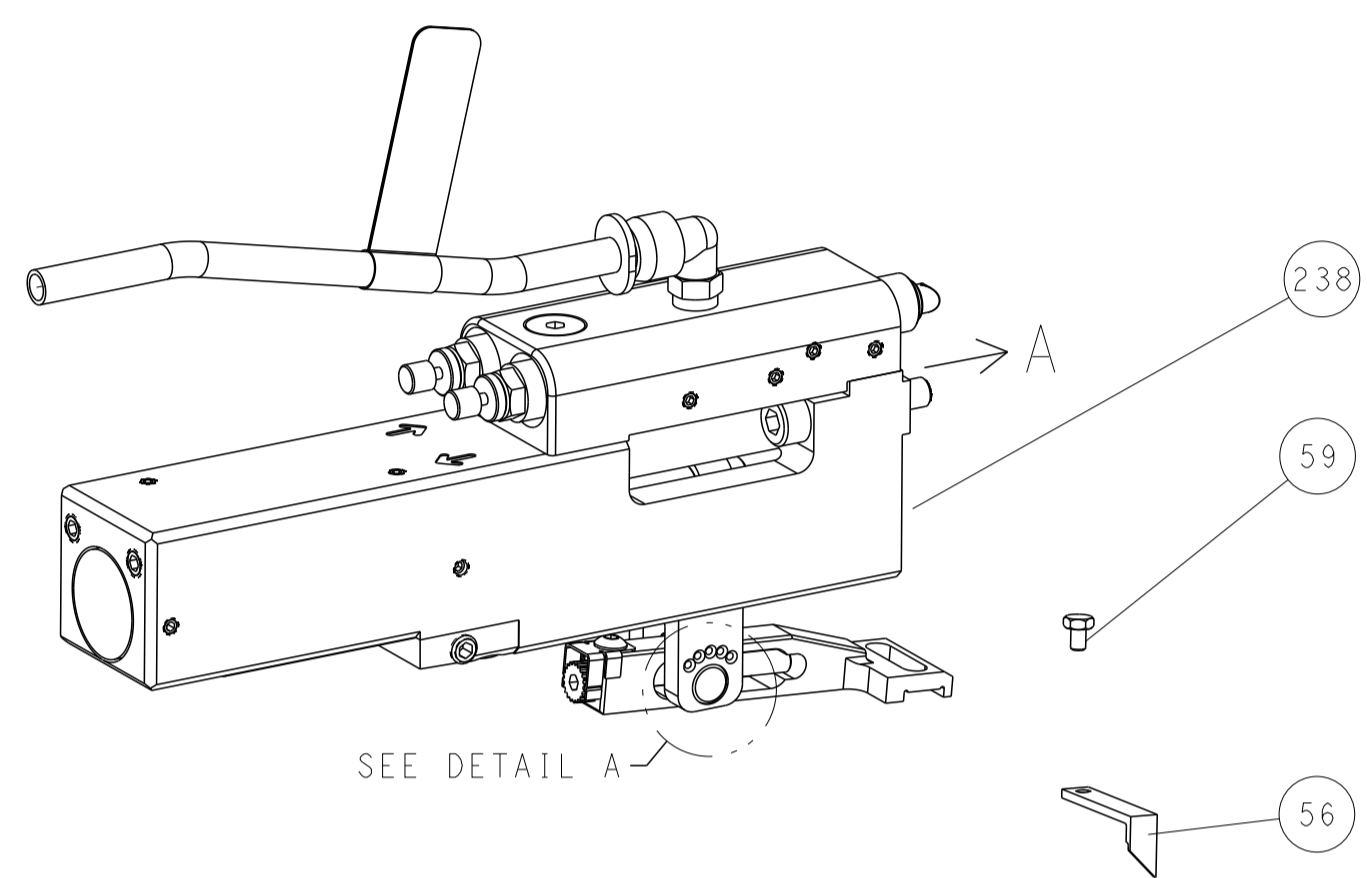
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

-	1	2391931-1	SIZING TOOL	261
-	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-1	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
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-8	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	124
-	1	1-22281-8	SPRING, COMPRESSION	123
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	100
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	99
-	1	2844907-1	POST, LOCKING	98
-	1	2844908-1	SCREW, LOCKING	97
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1-455888-8	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	1338683-8	FEED PAWL	56
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2-2844938-4	PLATE, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	2	22281-9	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-1	STRIP GUIDE	24
-	1	1-690438-0	FRONT STRIP GUIDE	23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-3	STRIPPER, SIDE FEED	19
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-7	STOP, SHEAR	11
-	1	1-2119805-4	SHEAR HOLDER, FRONT	10
-	1	1633838-1	FLOATING SHEAR, FRONT	9
-	1	1633840-2	ANVIL, COMBINATION .130	8
-	1	1-455888-1	SPACER, CRIMPER	7
-	-	-	-	6
-	1	1803080-8	DEPRESSOR, SHEAR	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	9-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-7	SPACER, CRIMPER	2
-	1	7-1633860-4	CRIMPER, WIRE	1
-	77	-22	PART NO	ITEM NO

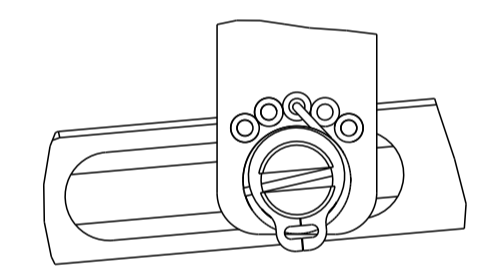
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MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2		SHEET 3 OF 4	

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

FEED TYPE PNEUMATIC

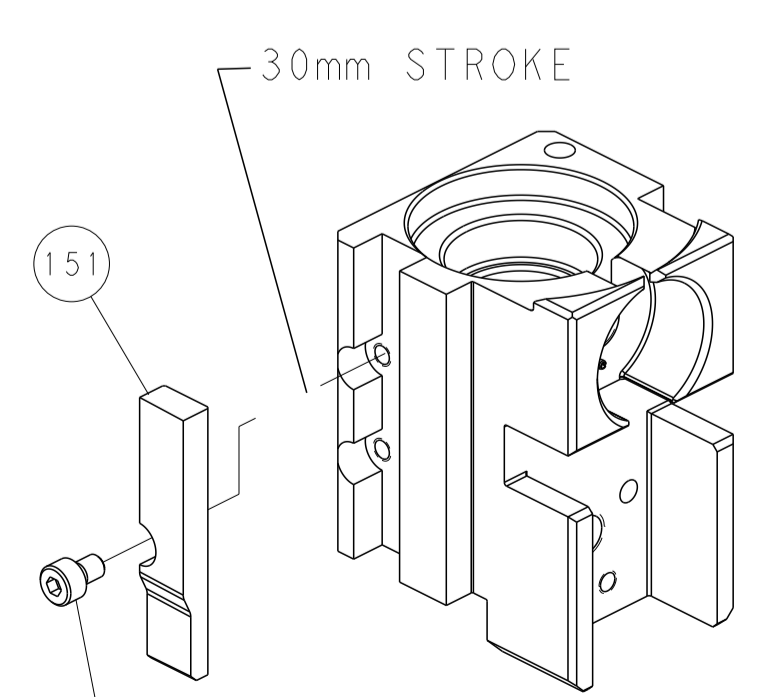


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

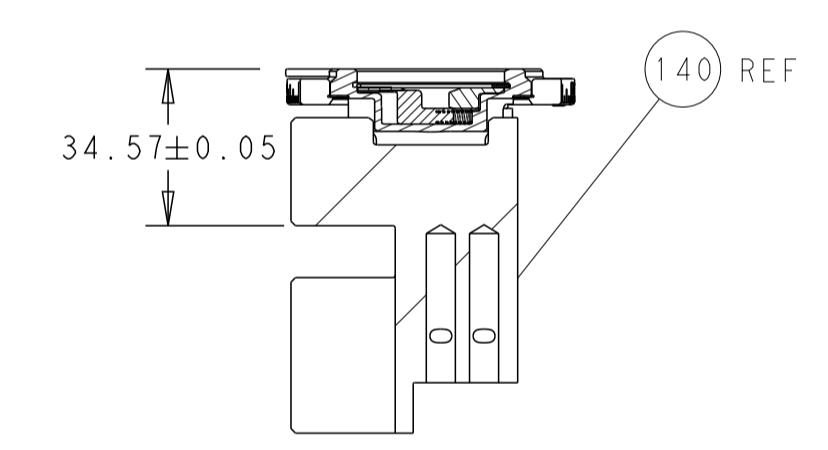
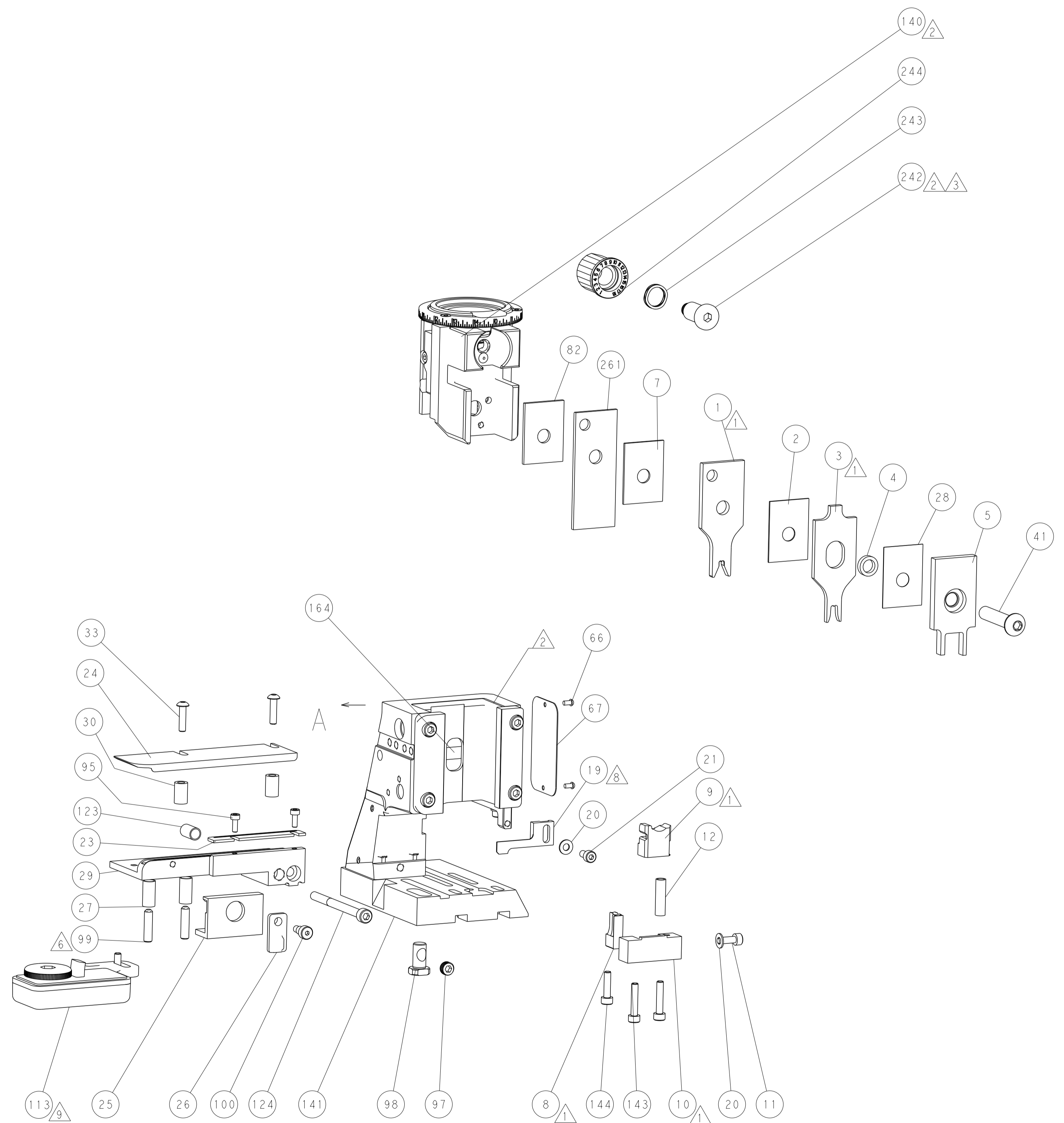


DETAIL A

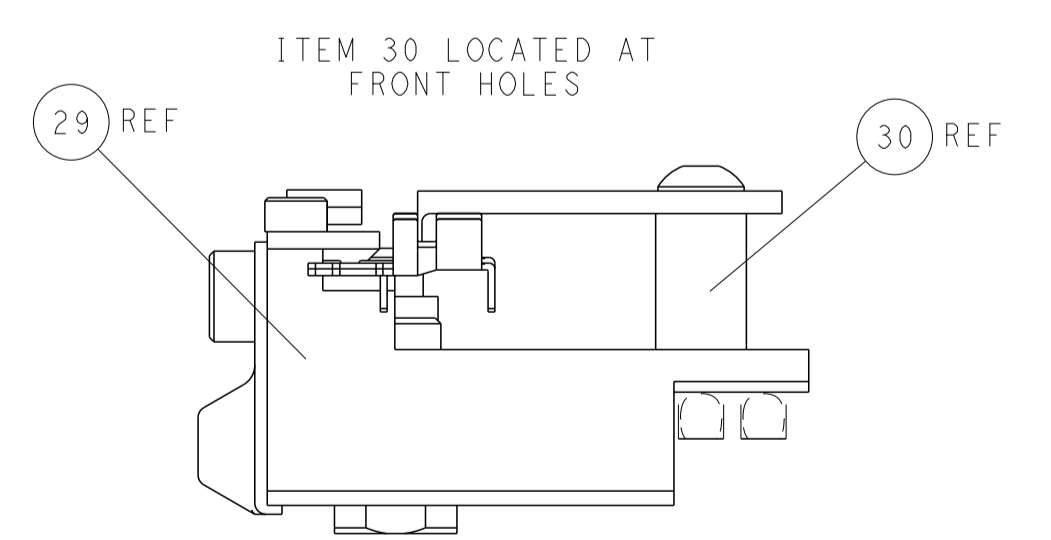
CAM POSITION



AIR FEED



RAM SET-UP



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN BOB HIGMAN 28JUN2014 CHK T. ELBIN 28JUN2014 APVD D. STOUGH 28JUN2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH -		NAME Ocean Side Feed Applicator PRODUCT SPEC - APPLICATION SPEC - SIZE CAGE CODE DRAWING NO. A1 00779 C-2266355 WEIGHT - SCALE 1:2 SHEET 4 OF 4 REV H	RESTRICTED TO - Customer Accessible Production Drawing