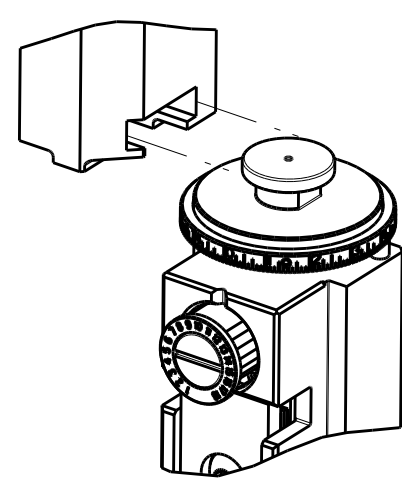


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266089-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266089-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266089-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

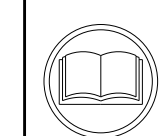


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.84 mm [.230]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL POWER F800			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.75-7.51 mm [.266-.296 1N]		Ø 5.33 mm MAX [.210 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	MTA SPECIFICATION	BO-018.004A	
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
1949296-1	17.07660		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.85 +/- 0.05 [.112 +/- .002]	7.6
4.0+2.5	2.75 +/- 0.05 [.108 +/- .002]	8.5
4.00mm2	2.50 +/- 0.05 [.098 +/- .002]	11.3



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

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	REV	DATE	BY	APP'D
		A	RELEASED	11DEC2013	YY UG
		A1	ECR-14-000388	10JAN2014	XZ GB
		B	ECR-15-003443	10MAR2015	YY TE
		C	ECR-20-002590	26FEB2020	FJ TE

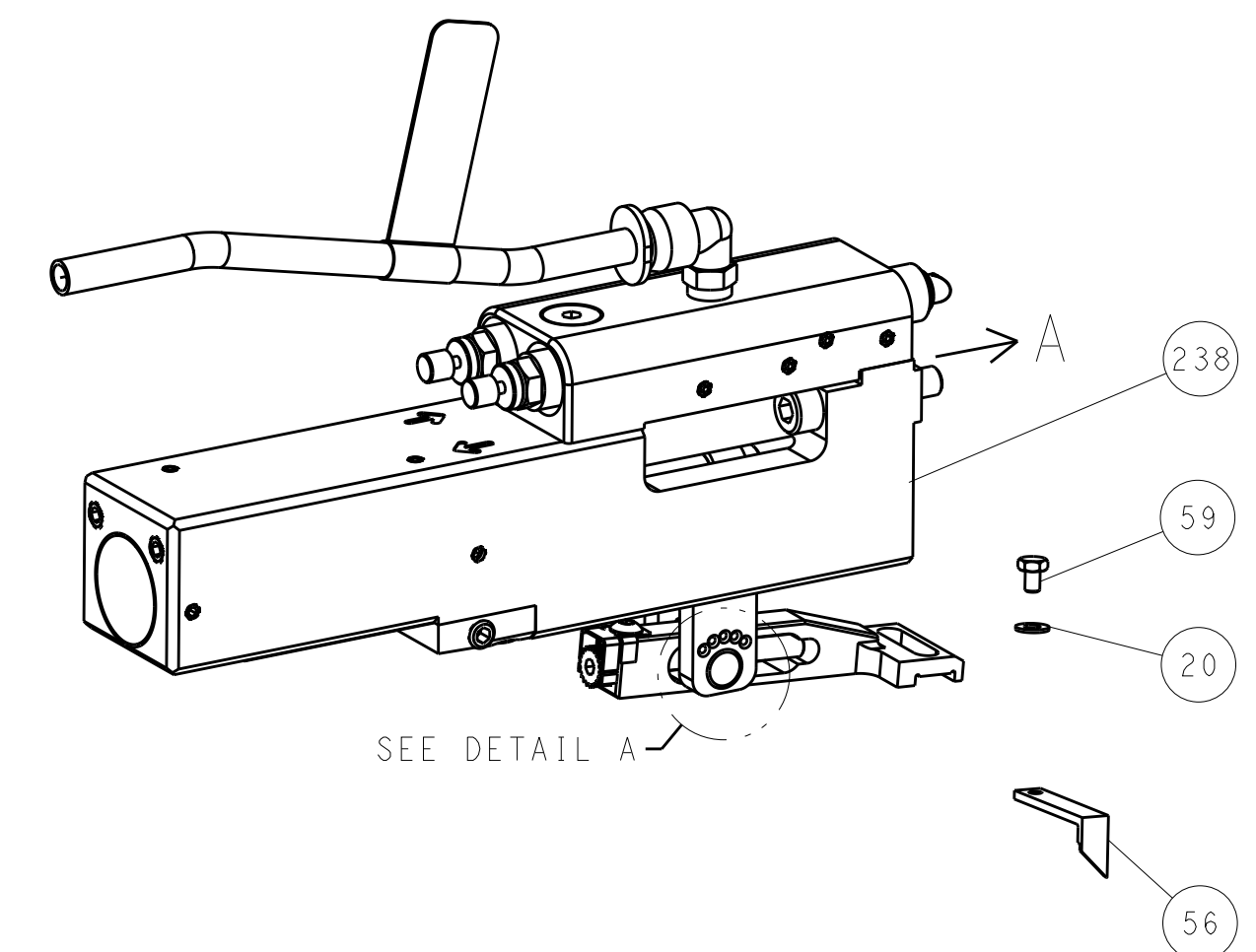
-	1	1	1803078-2	SPACER, PRECISION	259
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	318563-1	GUARD, FRONT CHIP	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1-455888-2	SPACER, CRIMPER	82
-	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1633782-6	FENCE	72
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-6	STRIP GUIDE	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
-	2	2	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	1803095-6	FLOATING SHEAR, FRONT	9
	1	2	1-1803171-6	ANVIL, COMBINATION	8
-	1	1	5-240641-0	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119757-1	DEPRESSOR, SHEAR	5
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
	1	2	1-2119582-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-2	SPACER, CRIMPER	2
	1	2	1-456414-2	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN	
mm	0 PLC ±	1 PLC ±	2 PLC ±	Y. YIN	24OCT2013
	3 PLC ±	4 PLC ±	ANGLES ±	CHK	24OCT2013
	FINISH			G. BAILEY	
MATERIAL		FINISH		APVD	24OCT2013
				NAME	U. GUO
				PRODUCT SPEC	
				APPLICATION SPEC	
				SIZE	A1
				CAGE CODE	00779
				DRAWING NO	2266089
				RESTRICTED TO	
				Customer Accessible Production Drawing	
				SCALE	1:2
				SHEET	1 OF 4
				REV	C

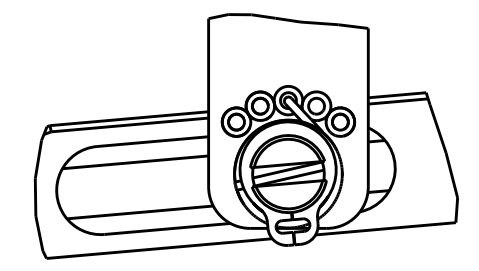
LOC		DIST		REVISIONS			
P	LTN	DESCRIPTION	DATE	DWN	APVD		
A	66	SEE SHEET 1					

FEED TYPE

PNEUMATIC

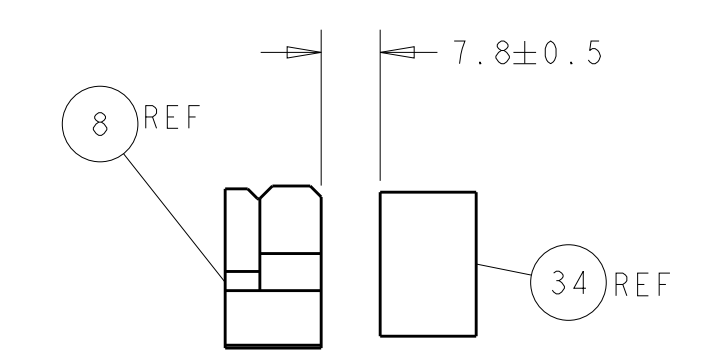
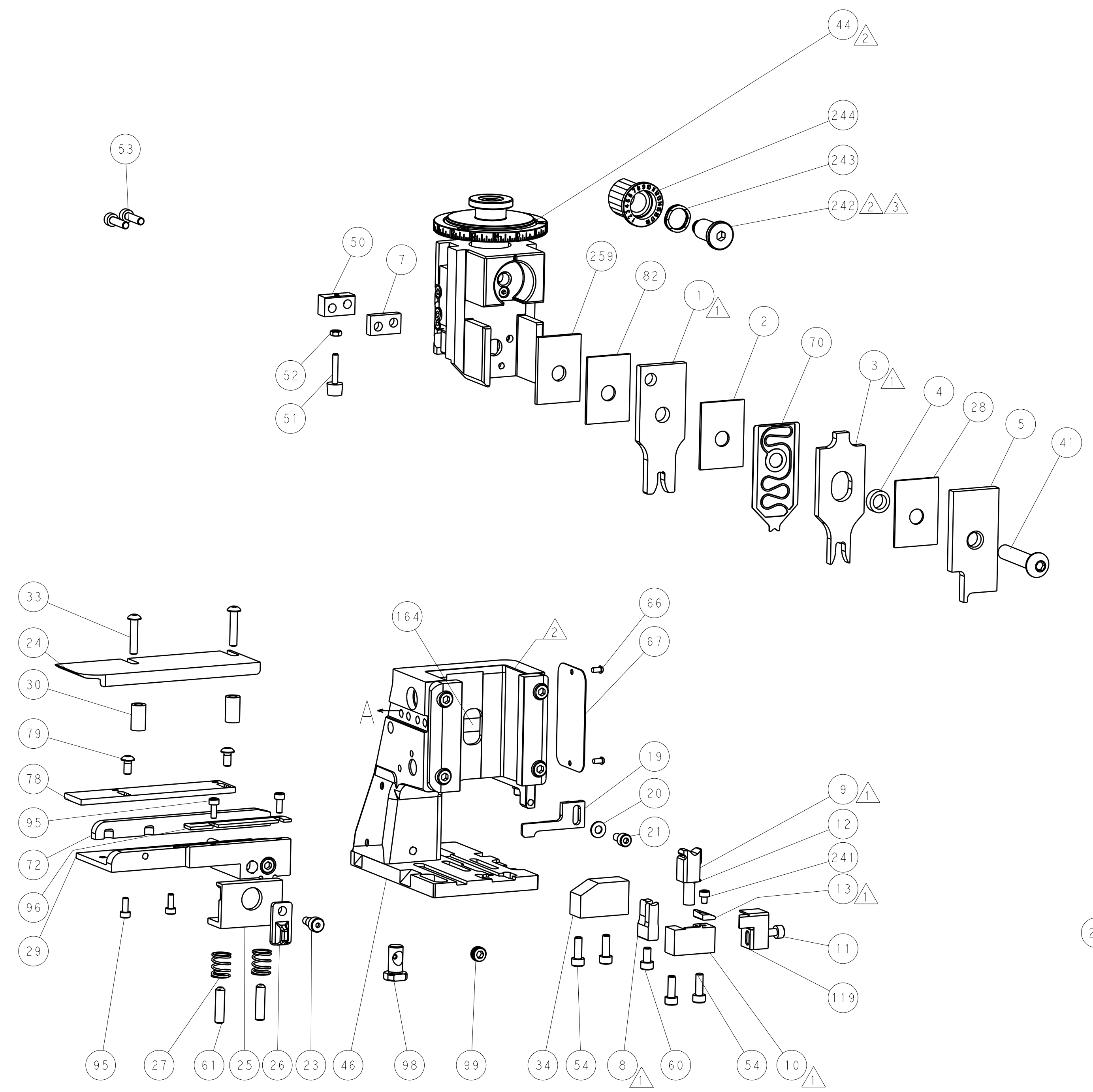
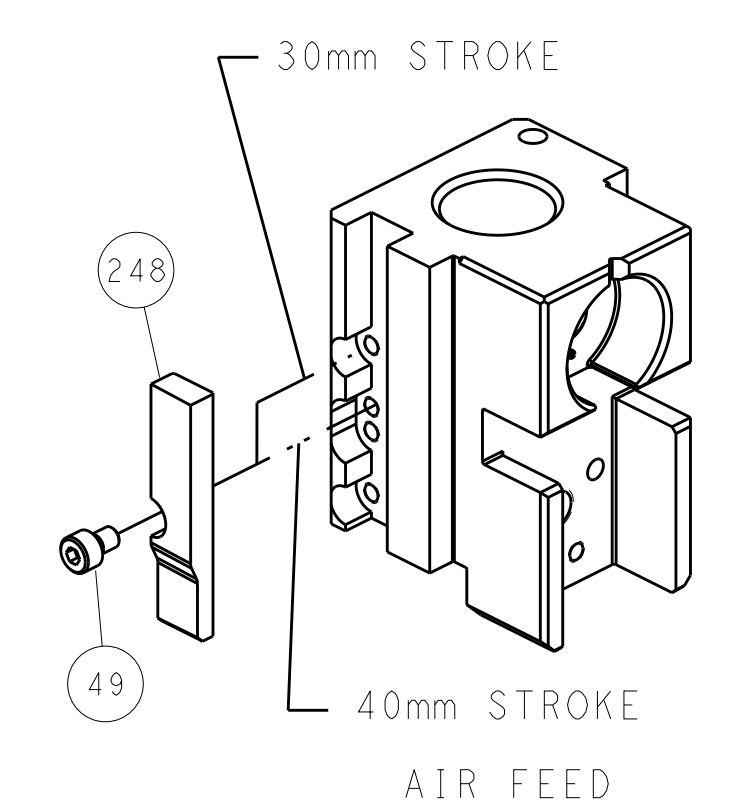


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

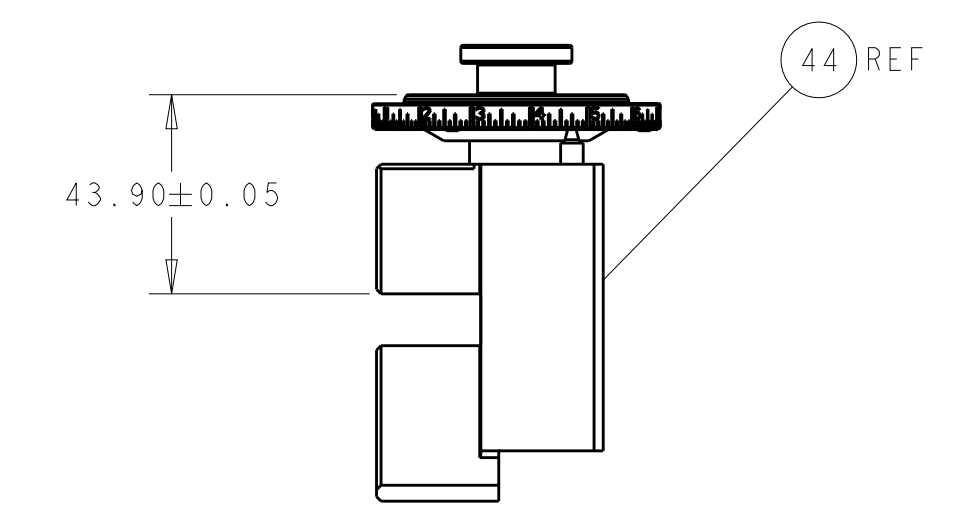


DETAIL A

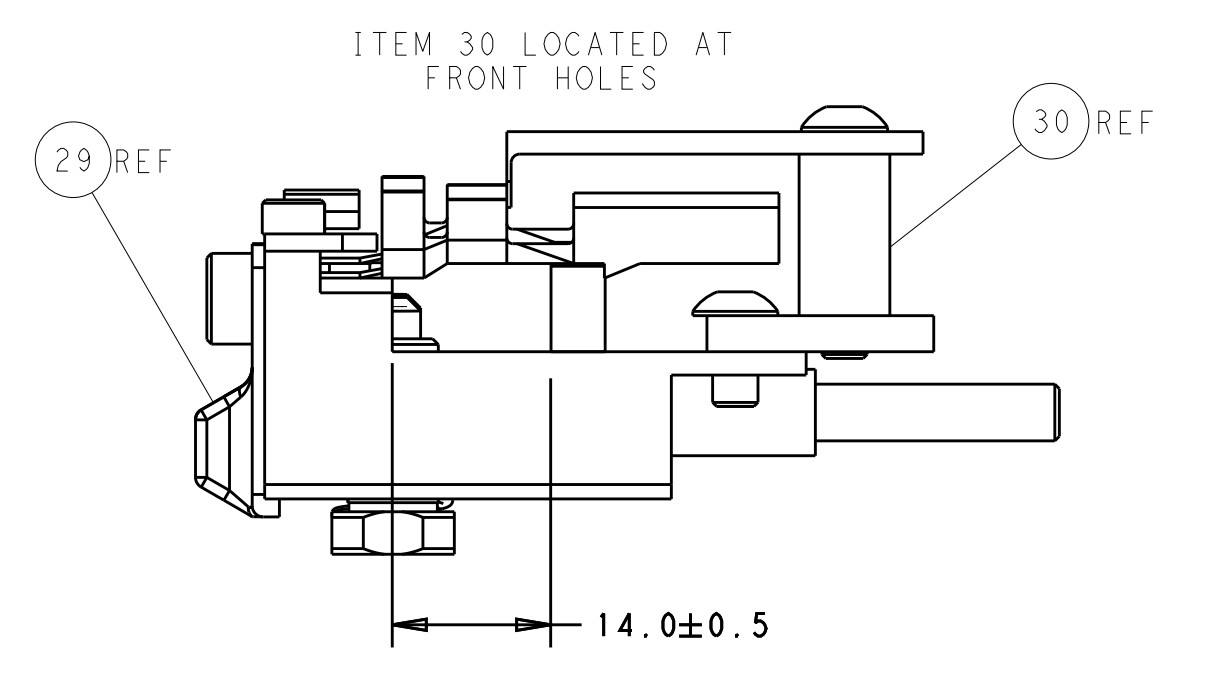
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



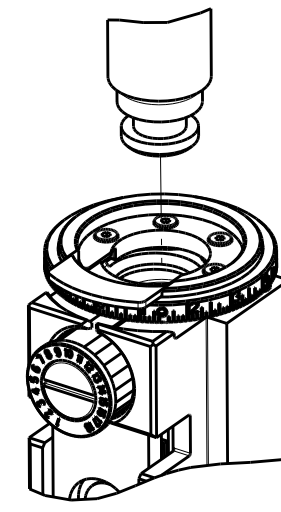
FEED TRACK POSITION GUIDE BY WIRE BARREL

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:		DWN		TE Connectivity	
mm	0 PLC	±		Y. YIN	24OCT2013	Harrisburg, PA 17105-3608	
	1 PLC	±		CHK	G. BAILEY	24OCT2013	
	2 PLC	±		APVD	H. GUO	24OCT2013	
	3 PLC	±		NAME			
	4 PLC	±		Ocean Side Feed			
	ANGLES	±		Applicator			
MATERIAL	FINISH			SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	©=2266089	
Customer Accessible Production Drawing				SCALE	1:2	SHEET	2 OF 4 REV

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266089-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266089-7	B	CRIMP TOOLING KIT	-

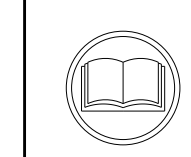
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.84 mm [.230]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL POWER F800			
WIRE STRIP LENGTH 6.75-7.51 mm [.266-.296 IN]		INSULATION DIAMETER RANGE 5.33 mm MAX [.210 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	MTA SPECIFICATION	B0-018.004A	-
TERMINALS APPLIED ⁵			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
1949296-1	17.07660		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.85 +/- 0.05 [.112 +/- .002]	7.6
4.0+2.5	2.75 +/- 0.05 [.108 +/- .002]	8.5
4.00mm2	2.50 +/- 0.05 [.098 +/- .002]	11.3



- 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. 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	REV	DATE	BY	APPD
A	66				

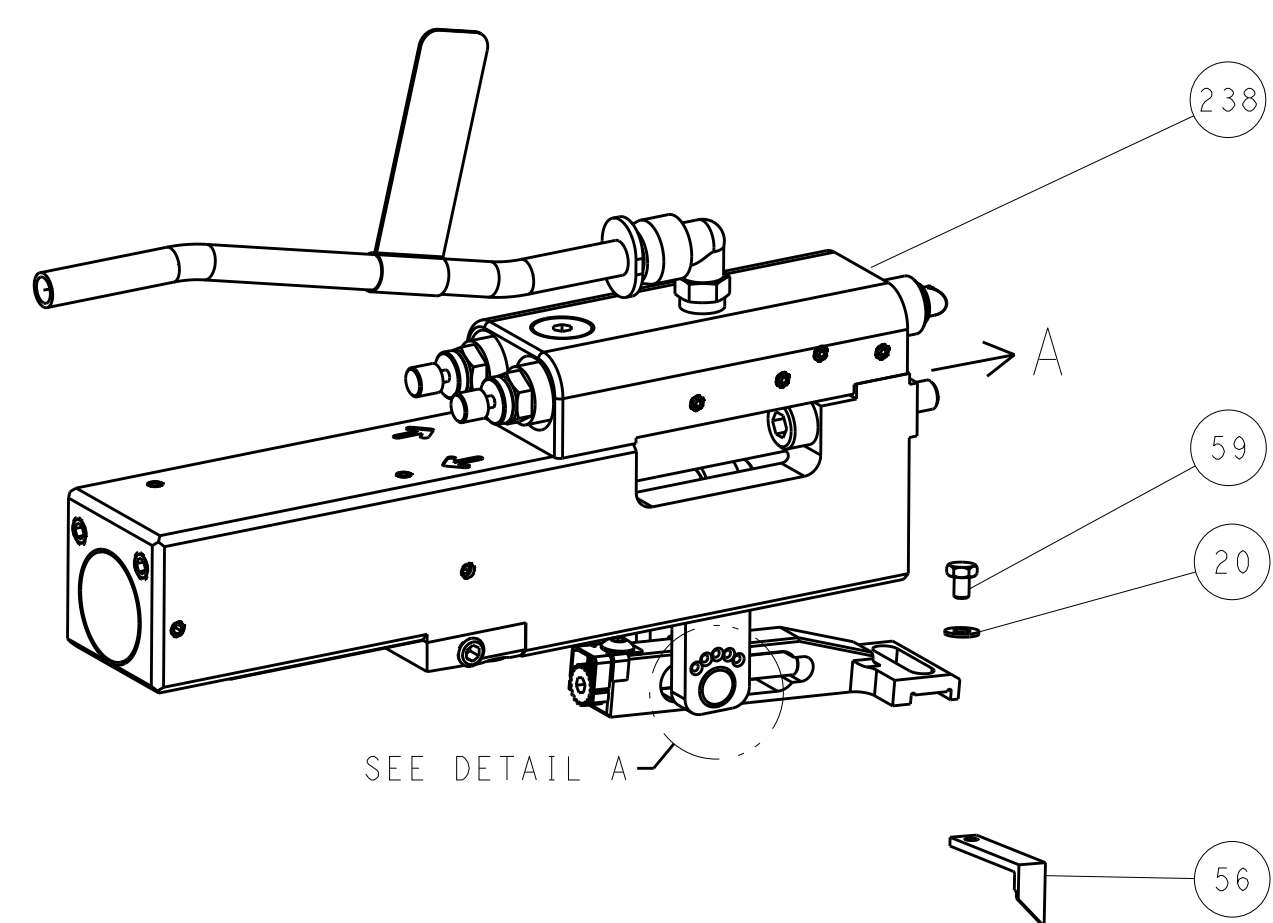
REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPD
-	-	SEE SHEET 1	-	-	-
-	1	1803078-2			259
-	1	2119082-7			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	7-18023-7			241
-	1	2844940-2			238
-	REF	994970-2			164
-	1	2119641-2			151
-	1	2168083-8			144
-	4	2168083-9			143
-	1	1-1803583-0			141
-	1	1803516-2			140
-	1	318563-1			119
-	1	2844908-1			99
-	1	2844907-1			98
-	1	1-690438-0			96
-	4	2168083-1			95
-	1	1-455888-2			82
-	2	18024-6			79
-	1	1803096-1			78
-	1	1633782-6			72
-	1	1803607-3			71
-	1	2119791-5			70
-	1	2119740-1			67
-	2	2168078-1			66
-	2	2-18032-5			61
-	1	5-18022-5			59
-	1	1338683-8			56
-	2	2168083-8			53
-	1	5018030-1			52
-	1	811242-5			51
-	1	690753-2			50
-	1	18023-9			49
-	1	1803602-2			41
-	1	1752356-6			34
-	2	2079383-5			33
-	2	2-2844962-6			30
-	1	2844992-3			29
-	1	1-455888-0			28
-	2	22283-1			27
-	1	356835-1			26
-	1	240792-1			25
-	1	1320928-6			24
-	1	980371-4			23
-	1	2168083-2			21
-	2	1-18028-2			20
-	1	2119533-1			19
-	1	2119806-1			13
-	1	3-22280-3			12
-	1	1-356885-4			11
-	1	2119805-1			10
-	1	1803095-6			9
-	1	3-1803171-6			8
-	1	5-240641-0			7
-	-	-			6
-	1	1-2119757-1			5
-	1	238011-3			4
-	1	8-2119582-5			3
-	1	1-455888-2			2
-	1	1-456414-2			1
-77	-22	PART NO	DESCRIPTION	ITEM NO	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: Y. YIN 24OCT2013		CHK: G. BAILEY 24OCT2013		APVD: H. GUO 24OCT2013		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2266089	RESTRICTED TO: -
MATERIAL:								WEIGHT:		SCALE: 1:2	
Customer Accessible Production Drawing								SHEET 3 OF 4		REV C	

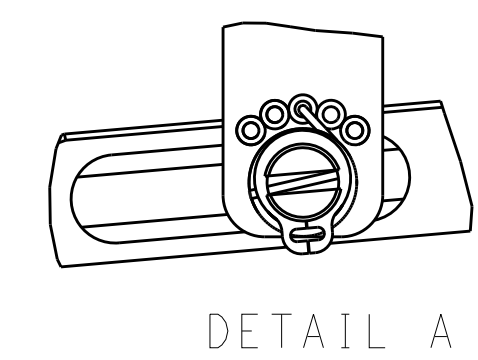
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

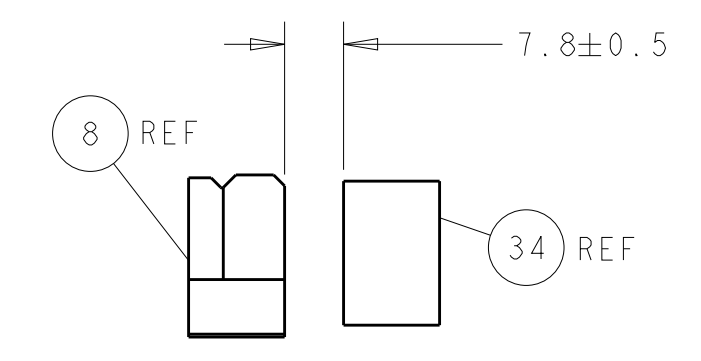
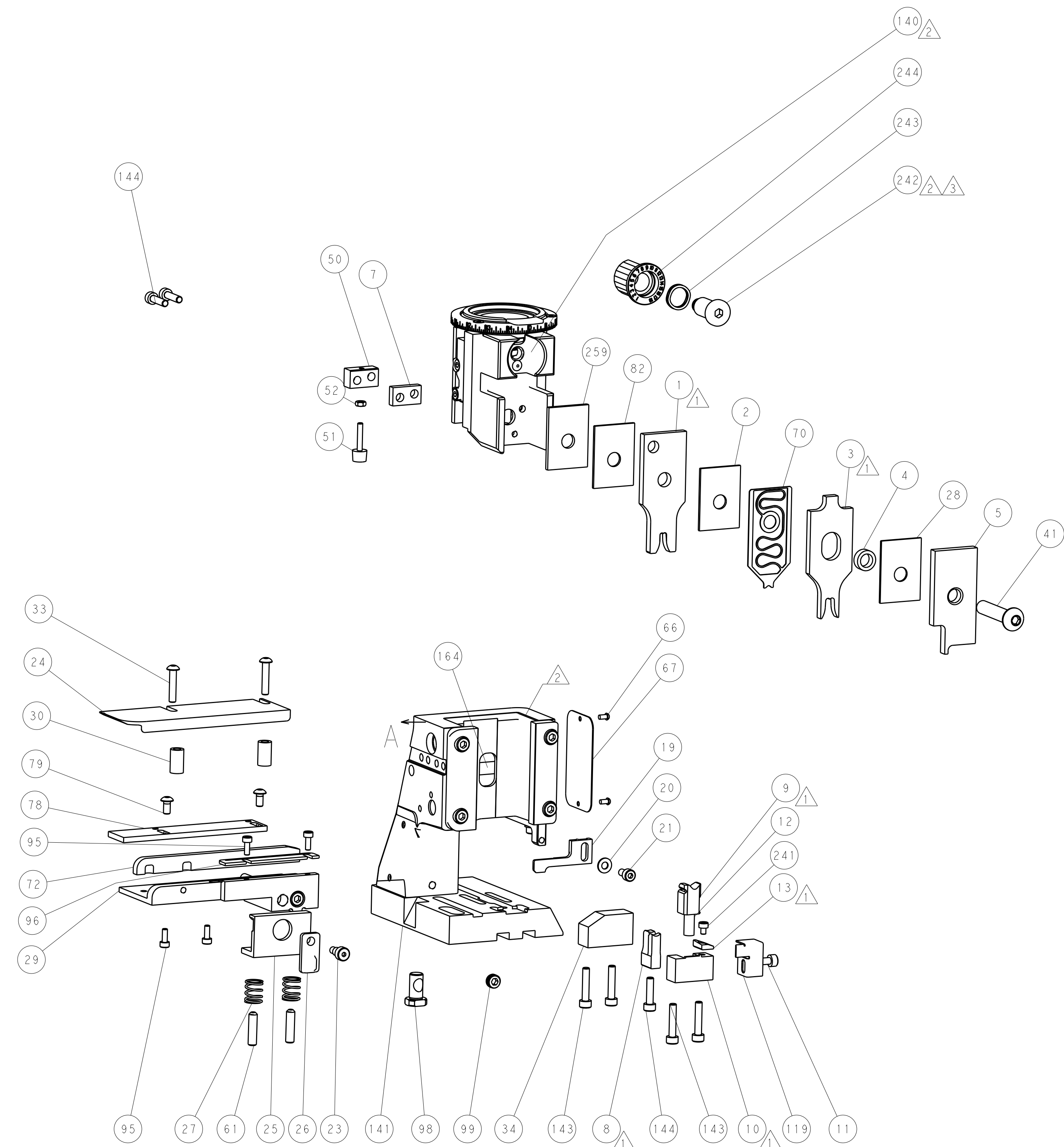
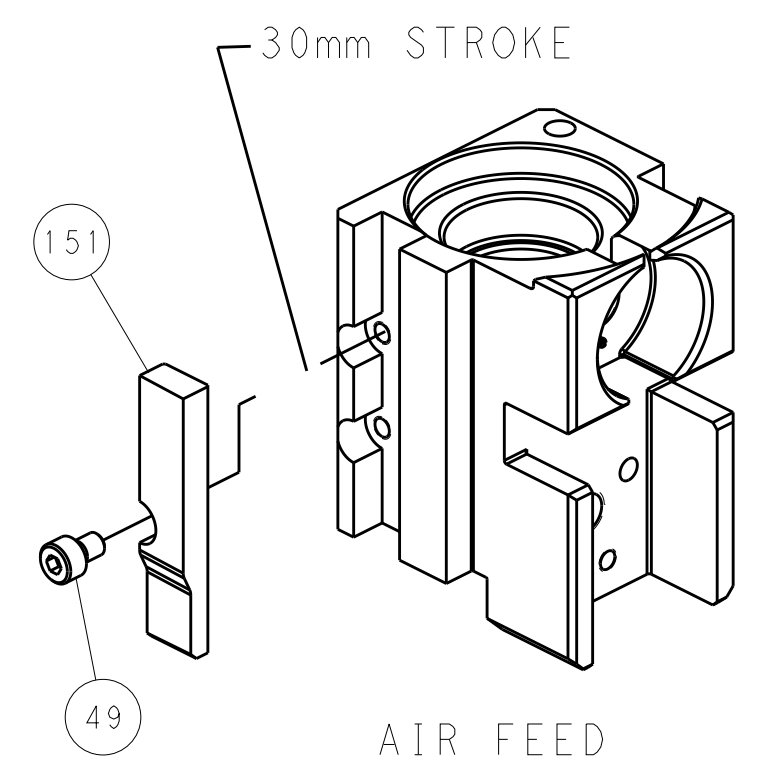
PNEUMATIC



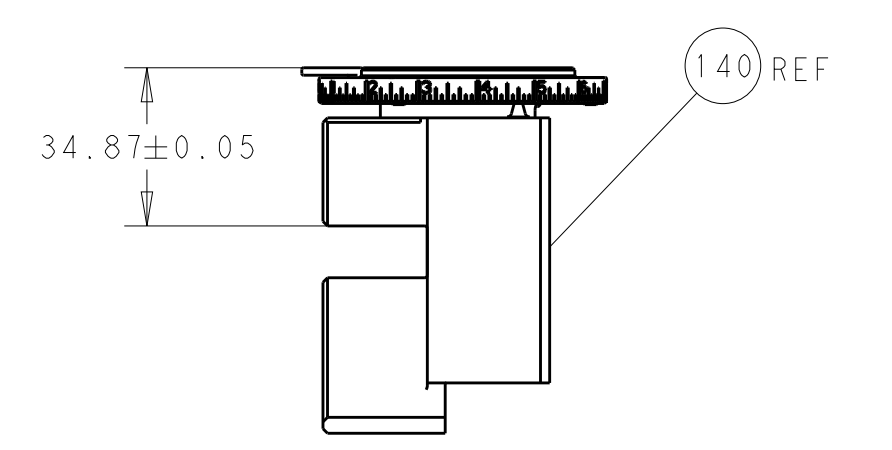
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



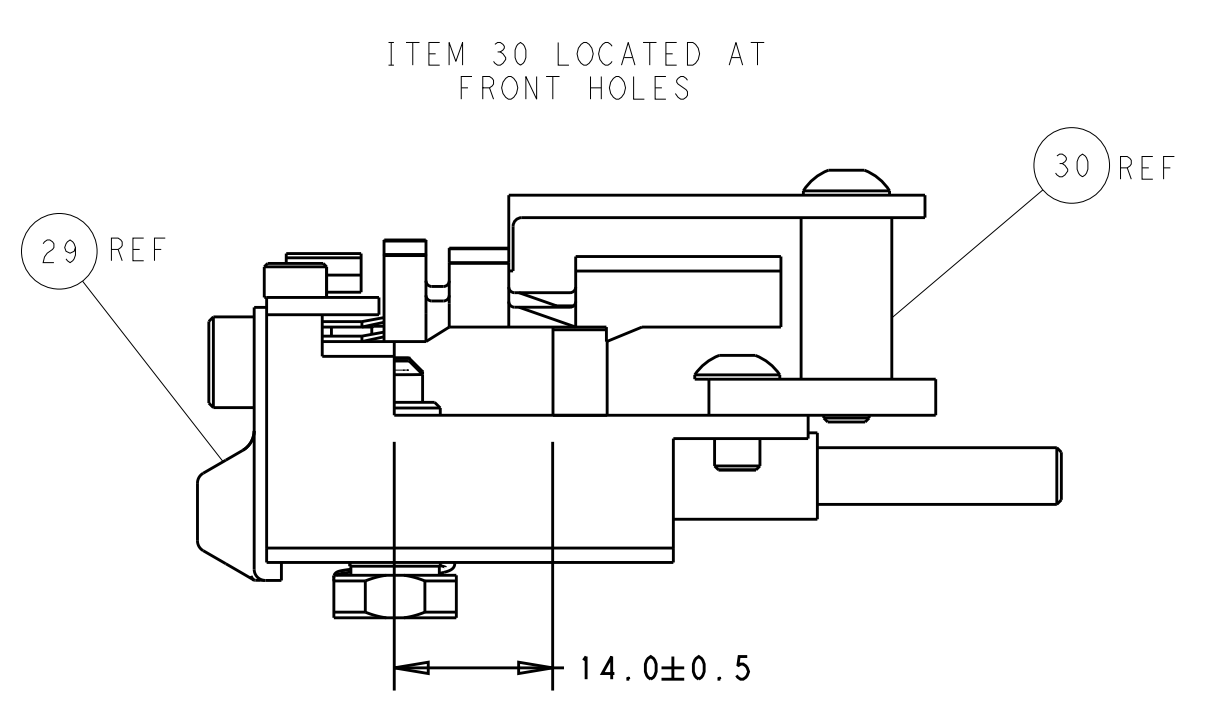
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

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 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH -	CHK G. BAILEY 24OCT2013	APVD H. GUO 24OCT2013
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2	SHEET 4 OF 4