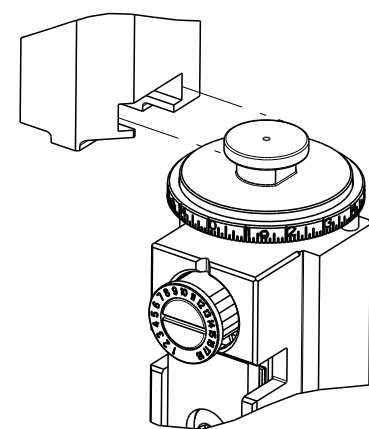


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266094-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266094-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266094-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

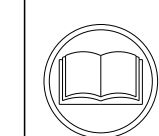


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.94 mm [.155]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
7.00-7.80 mm [.276-.307 IN]	Ø3.00-4.30 mm [.118-.169 IN]		
TERMINAL APPLICATION SPECIFICATION	114-3118		
TERMINALS APPLIED 5			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160831-1	160831-3	160831-9	1-160831-2
160831-2	160831-4	1-160831-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.03+/-0.05 [.080+/- .002]	5.8
(2) 1mm	1.96+/-0.05 [.077+/- .002]	6.5
1.50mm2	1.85+/-0.05 [.073+/- .002]	7.7
1.00mm2	1.67+/-0.05 [.066+/- .002]	10.0



- 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.

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	A		RELEASED	23DEC2013	BH	GB
		A1		REVISED TERMINAL	14JAN2014	KS	TE
		A2		ECR-14-005498	14APR2014	XZ	TE
		B		ECR-20-001831	07FEB2020	TB	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241		
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	1	2844940-2	AIR FEED MODULE	238		
-	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	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	455888-5	SPACER, CRIMPER	82		
-	1	1	22278-8	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	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58		
-	1	1	1338685-1	PAWL, FEED	56		
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54		
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44		
-	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	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30		
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29		
-	1	1	455888-3	SPACER, CRIMPER	28		
-	1	1	1320928-2	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	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	2	1	1333208-2	ANVIL, COMBINATION .120	8	
-	1	1	3-240641-9	SPACER	7		
-	-	-	-	-	6		
-	1	1	1-2119780-4	DEPRESSOR, SHEAR	5		
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4		
1	1	2	1	4-1633962-8	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-8	SPACER, CRIMPER	2		
1	1	2	1	456409-7	CRIMPER, WIRE .120 "F" PREMIUM	1	
-	77	72	-2	PART NO			
-				DESCRIPTION			
-				ITEM NO			

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

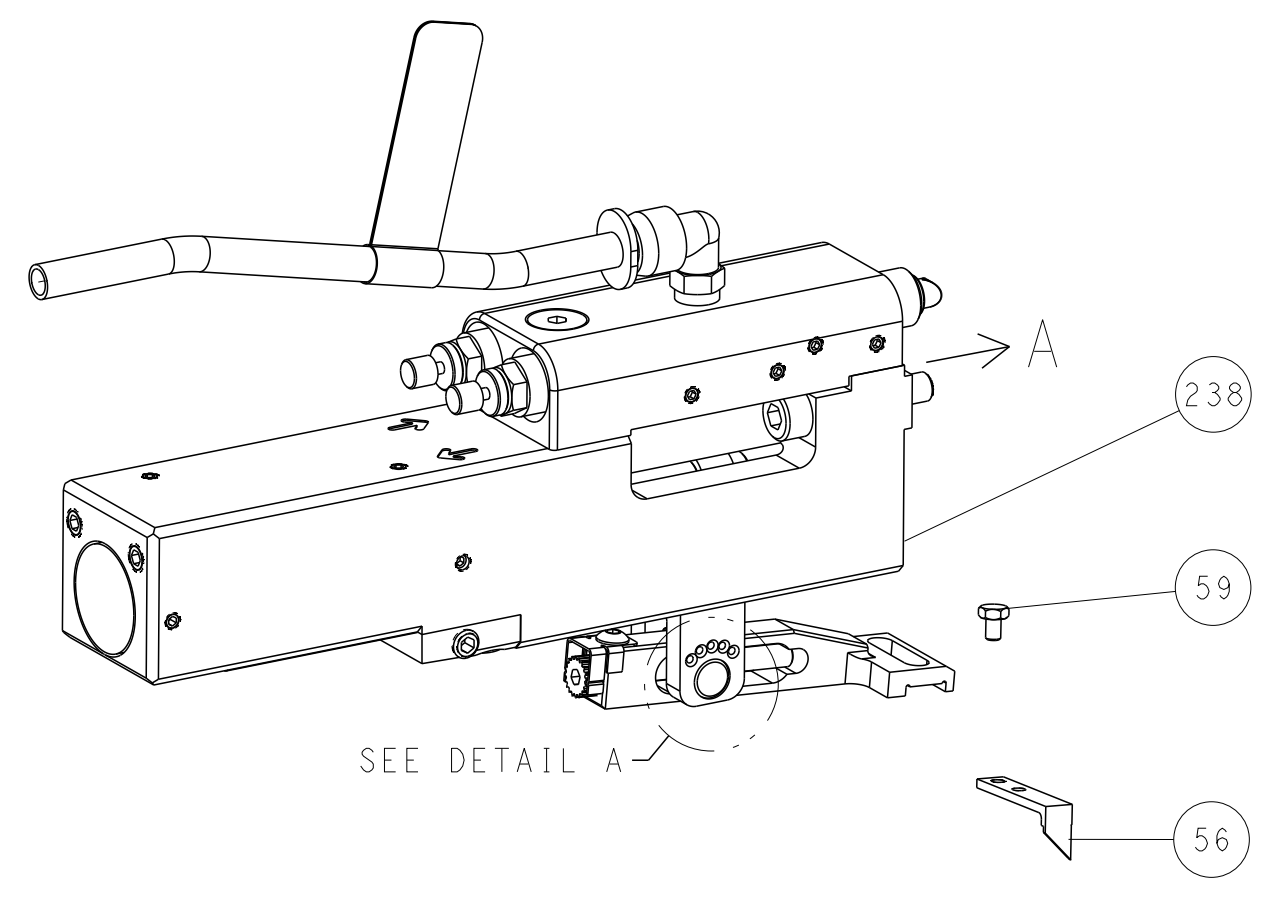
DWN	R. STAKEM	23OCT2013	TE Connectivity
CHK	G. BAILEY	23OCT2013	Harrisburg, PA 17105-3608
APVD	T. ELBIN	23OCT2013	
NAME		Ocean Side Feed Applicator	
SIZE		A1 00779 C=2266094	
CAGE CODE		DRAWING NO	
DRAWING NO		SCALE	
SCALE		SHEET 1 OF 4	
SHEET		REV B	

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

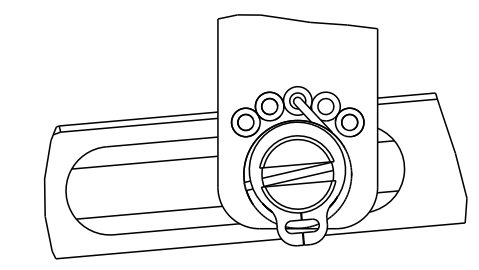
FEED TYPE

PNEUMATIC



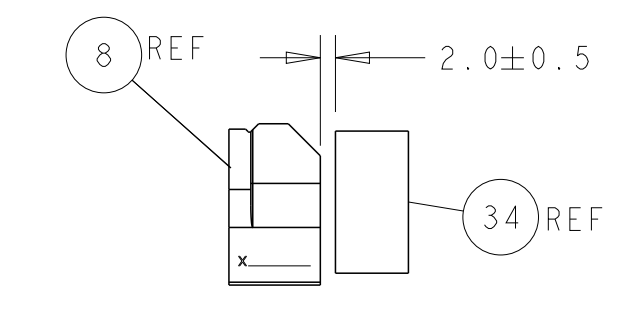
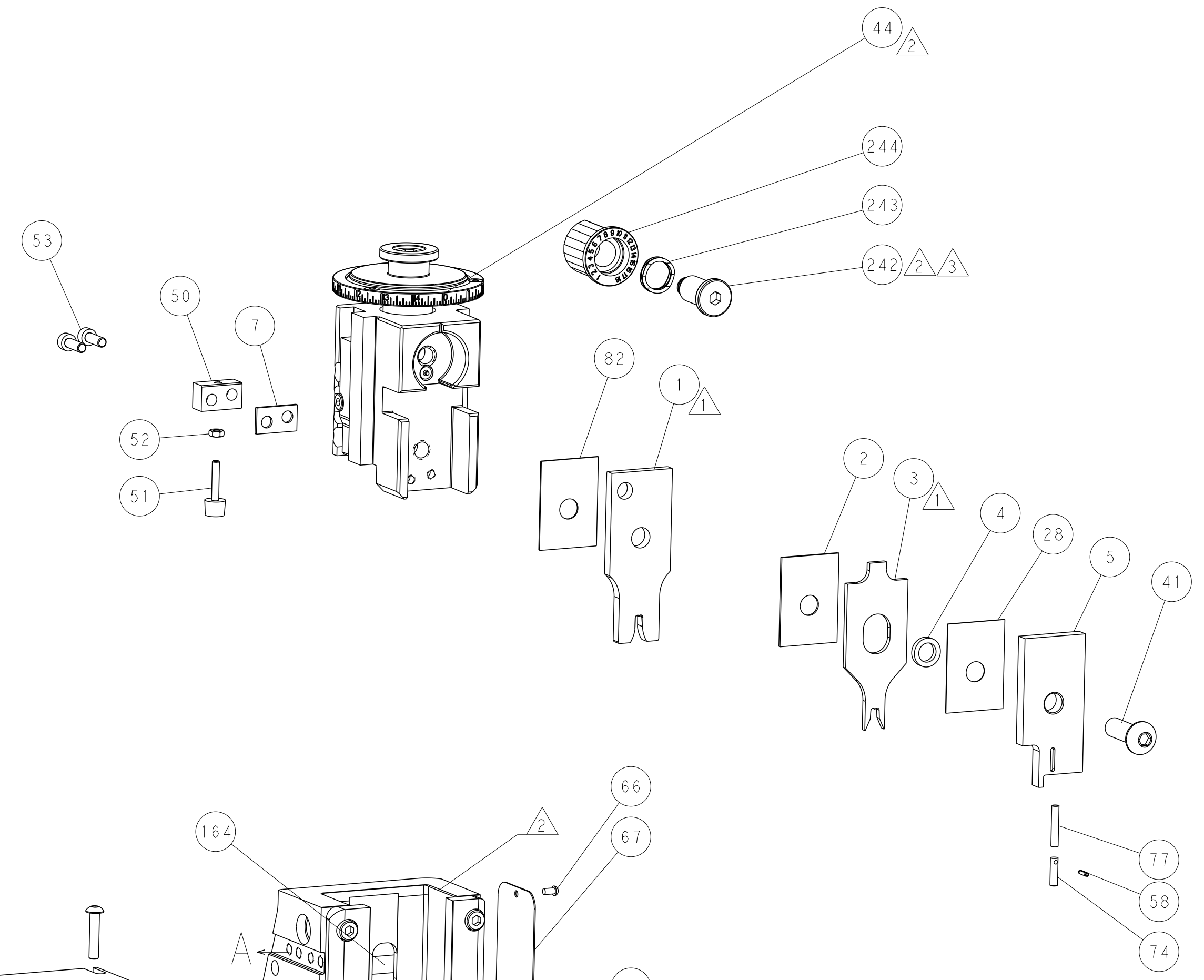
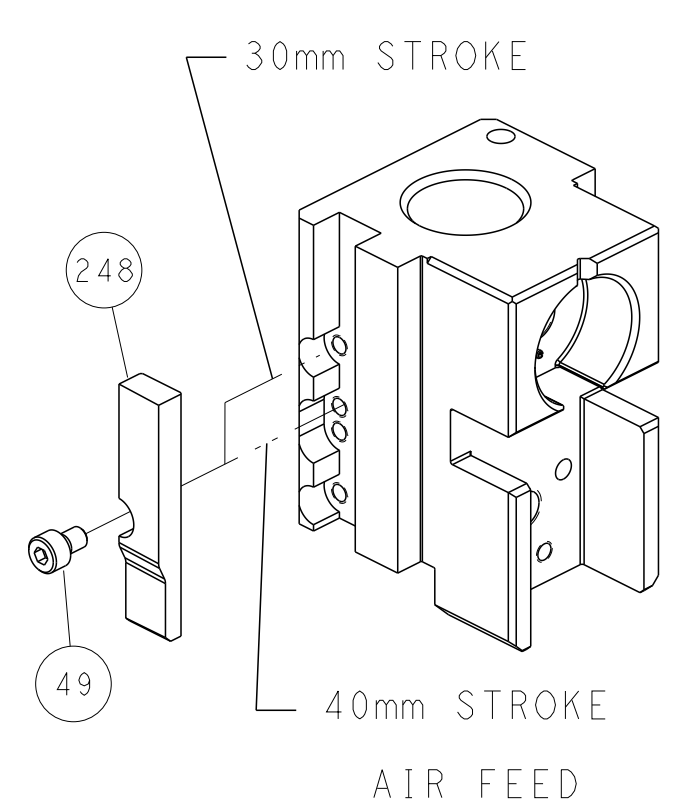
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

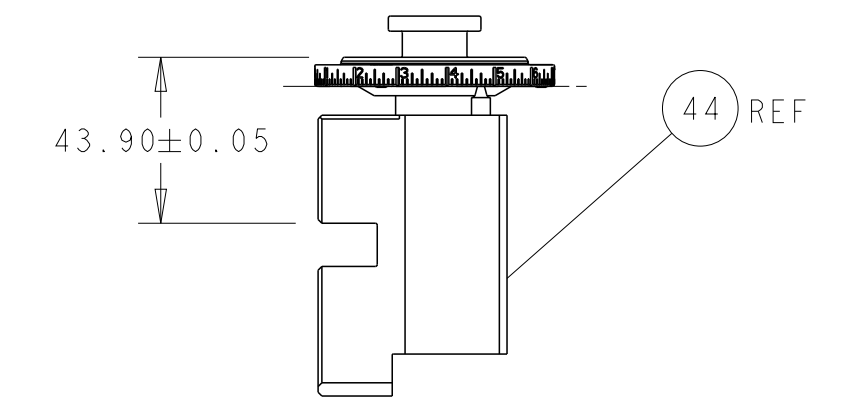


DETAIL A

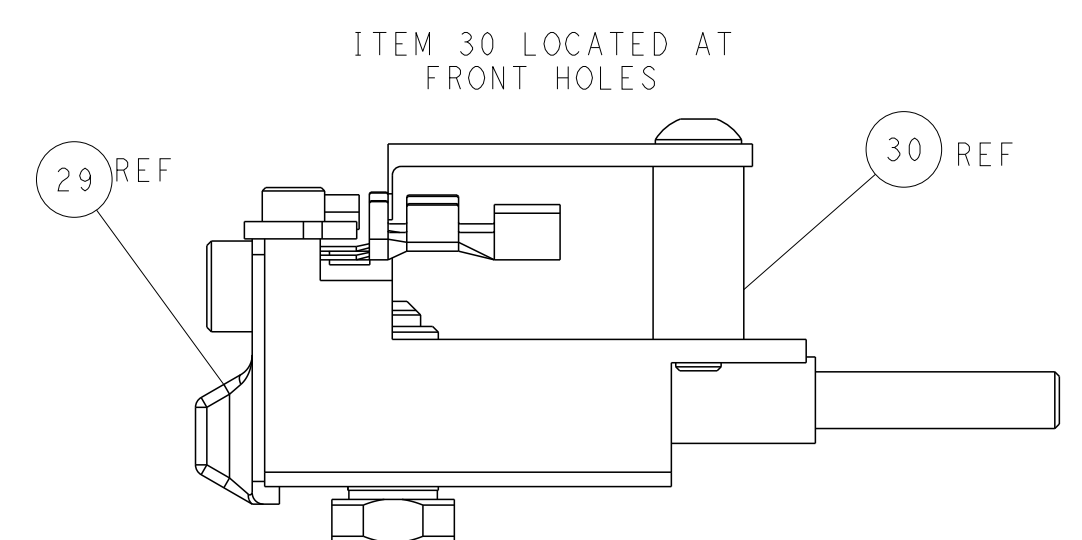
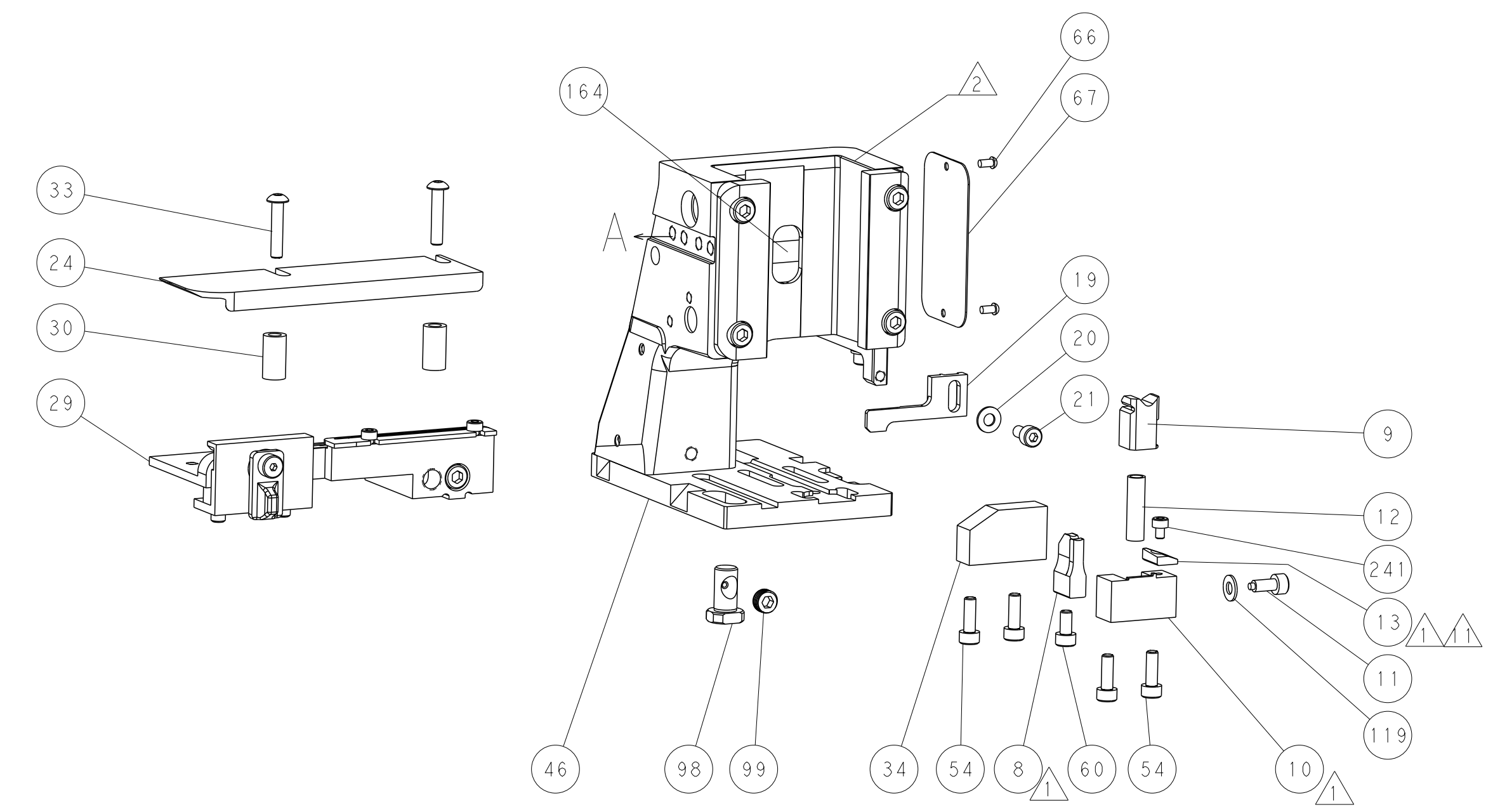
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



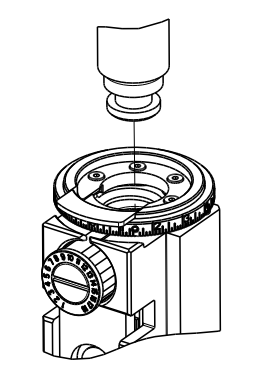
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: R. STAKEM 23OCT2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: G. BAILEY 23OCT2013		NAME: Ocean Side Feed Applicator	
				APVD: T. ELBIN 23OCT2013		RESTRICTED TO:	
				PRODUCT SPEC:		SIZE: A1	
				APPLICATION SPEC:		CAGE CODE: 00779	
				WEIGHT:		DRAWING NO: 2266094	
				SCALE: 1:2		SHEET 2 OF 4	
				Customer Accessible Production Drawing		REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266094-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266094-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

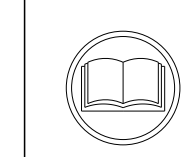


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.94 mm [.155]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH 7.00-7.80 mm [.276-.307 IN]		INSULATION DIAMETER RANGE Ø3.00-4.30 mm [.118-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160831-1	160831-3	160831-9	1-160831-2
160831-2	160831-4	1-160831-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.03+/-0.05 [.080+/- .002]	5.8
(2) 1mm	1.96+/-0.05 [.077+/- .002]	6.5
1.50mm2	1.85+/-0.05 [.073+/- .002]	7.7
1.00mm2	1.67+/-0.05 [.066+/- .002]	10.0



- 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.

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

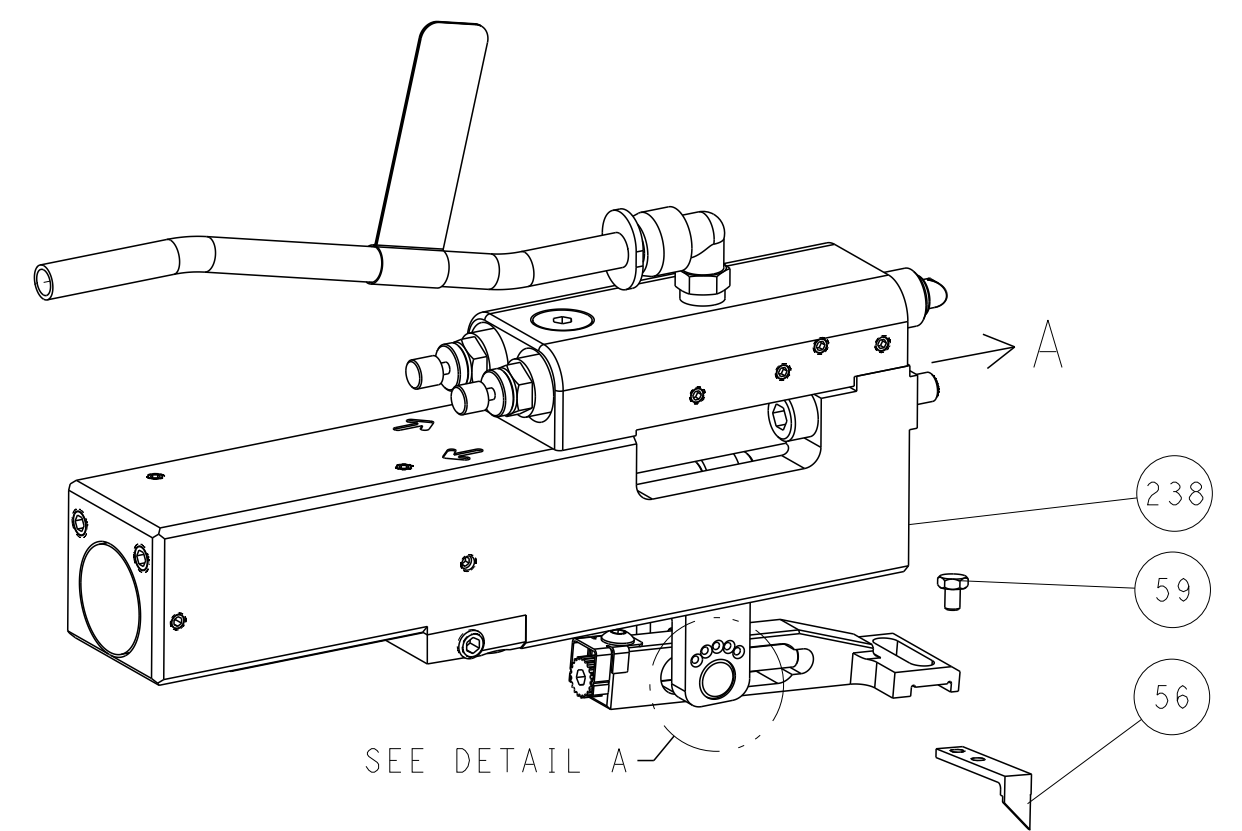
-	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	2844940-2	AIR FEED MODULE	238	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	151	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143	
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	455888-5	SPACER, CRIMPER	82	
-	1	22278-8	SPRING, COMPRESSION	77	
-	1	854769-4	HOLDER, INS	74	
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	1	1338685-1	PAWL, FEED	56	
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53	
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	690753-2	SPACER, TONKER	50	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1-1752356-8	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-3	SPACER, CRIMPER	28	
-	1	1320928-2	STRIP GUIDE	24	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	2119806-1	INSERT, SHEAR	13	
-	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1-356885-4	STOP, SHEAR	11	
-	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	1333208-2	ANVIL, COMBINATION .120	8	
-	1	3-240641-9	SPACER	7	
-	-	-	-	6	
-	1	1-2119780-4	DEPRESSOR, SHEAR	5	
-	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
-	1	4-1633962-8	CRIMPER, INSULATION F PREMIUM	3	
-	1	455888-8	SPACER, CRIMPER	2	
-	1	456409-7	CRIMPER, WIRE .120 "F" PREMIUM	1	
-	77	22	PART NO	DESCRIPTION	ITEM NO

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:		DWN: STAKEM 23OCT2013		CHK: G. BAILEY 23OCT2013		APVD: T. ELBIN 23OCT2013		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: C=2266094	RESTRICTED TO: -
MATERIAL: -								WEIGHT: -	SCALE: 1:2		SHEET: 3 OF 4
Customer Accessible Production Drawing								SCALE: 1:2		REV: B	

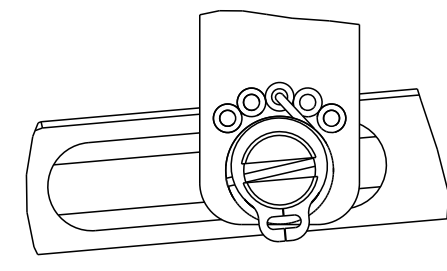
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC



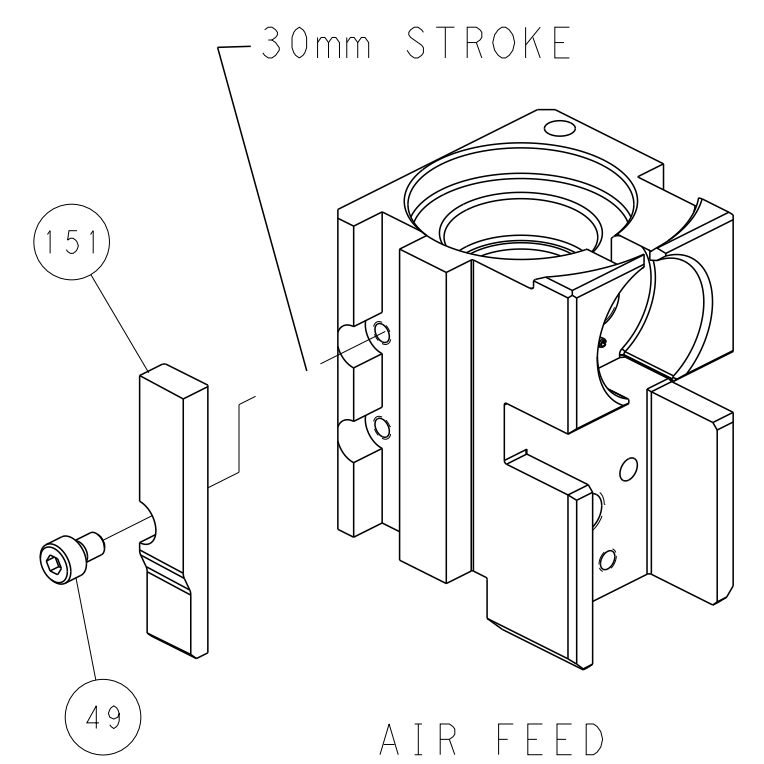
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

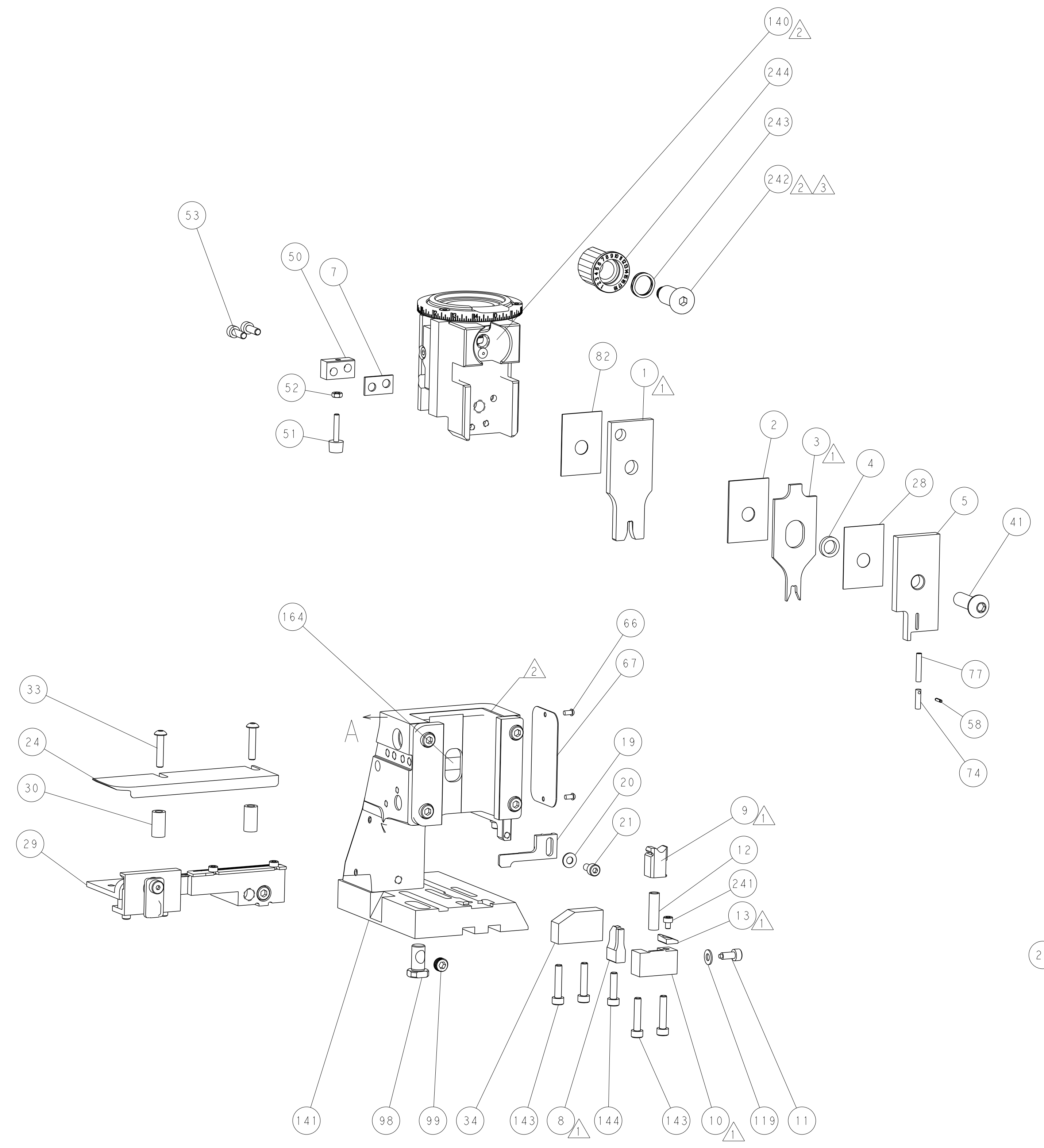


DETAIL A

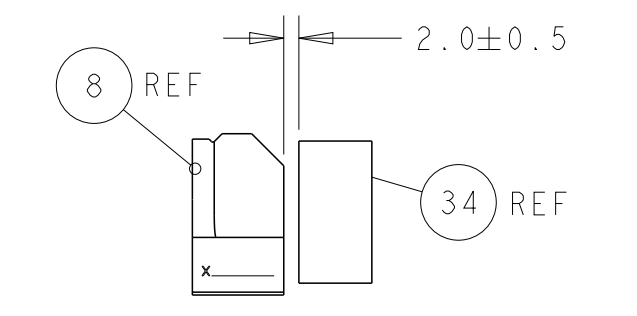
CAM POSITION



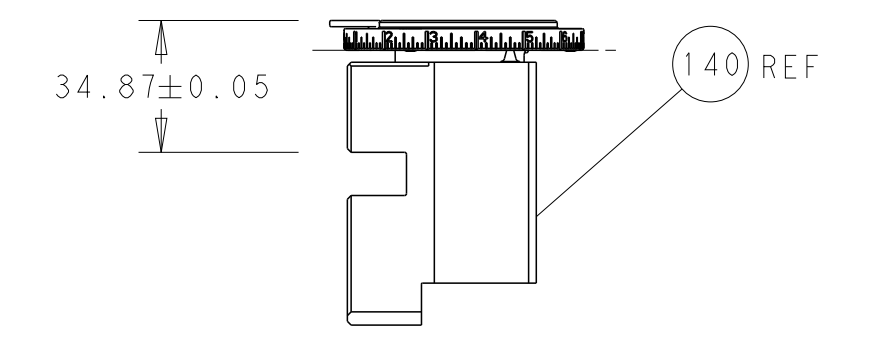
AIR FEED



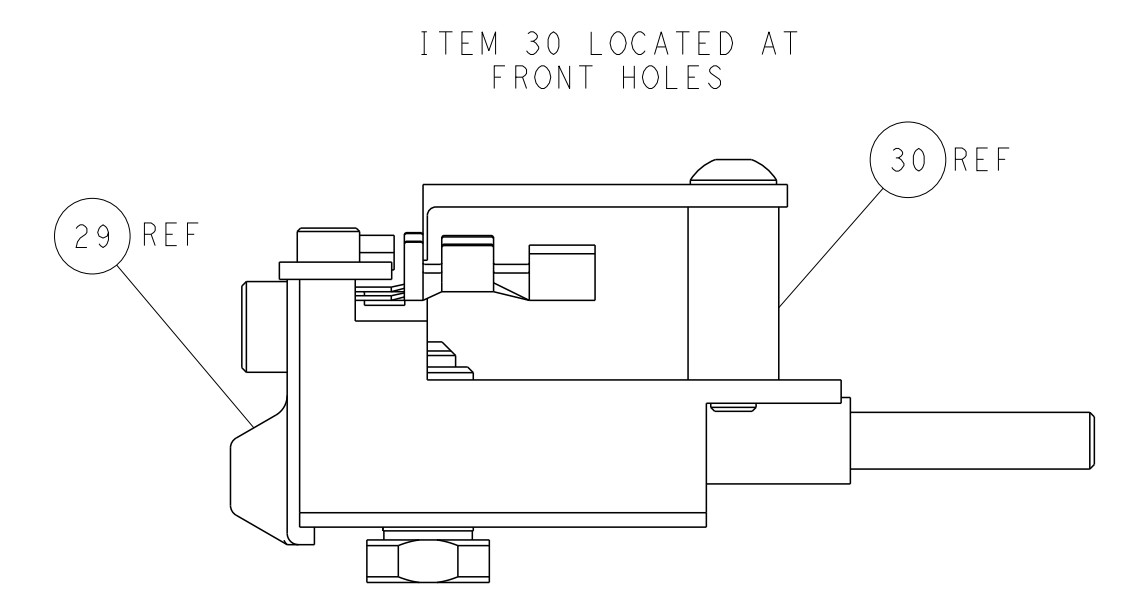
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. STAKEM 23OCT2013 CHK: G. BAILEY 23OCT2013 APVD: T. ELBIN 23OCT2013	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266094	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: -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: - SCALE: 1:2	SHEET 4 OF 4 REV B	RESTRICTED TO: -