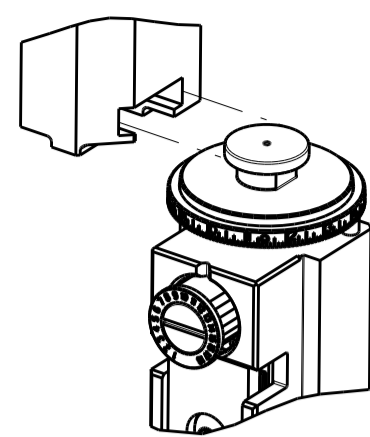


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266355-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266355-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266355-7	C	CRIMP TOOLING KIT	-

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 4.83-5.59 mm [.190-.220 IN]		INSULATION DIAMETER RANGE 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	REV	DATE	BY	APP'D
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		E	05APR2018	AW	CT
		F	28NOV2018	FZ	KZ
		G	03APR2019	MZ	YY

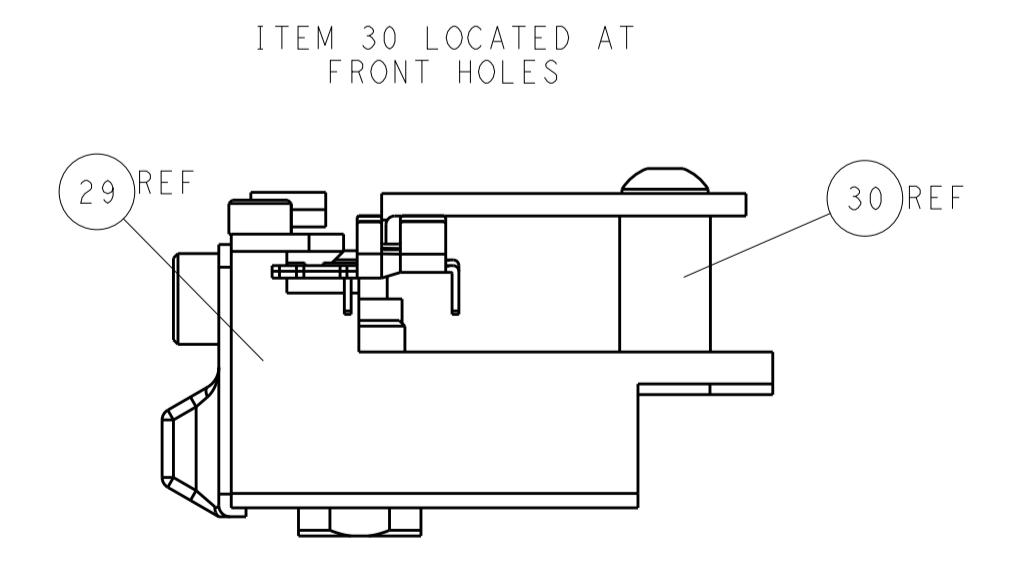
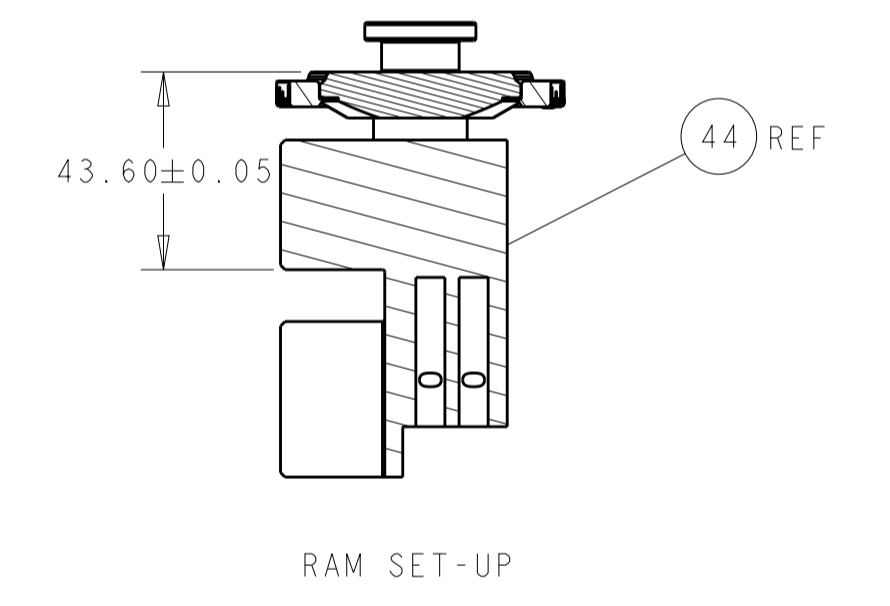
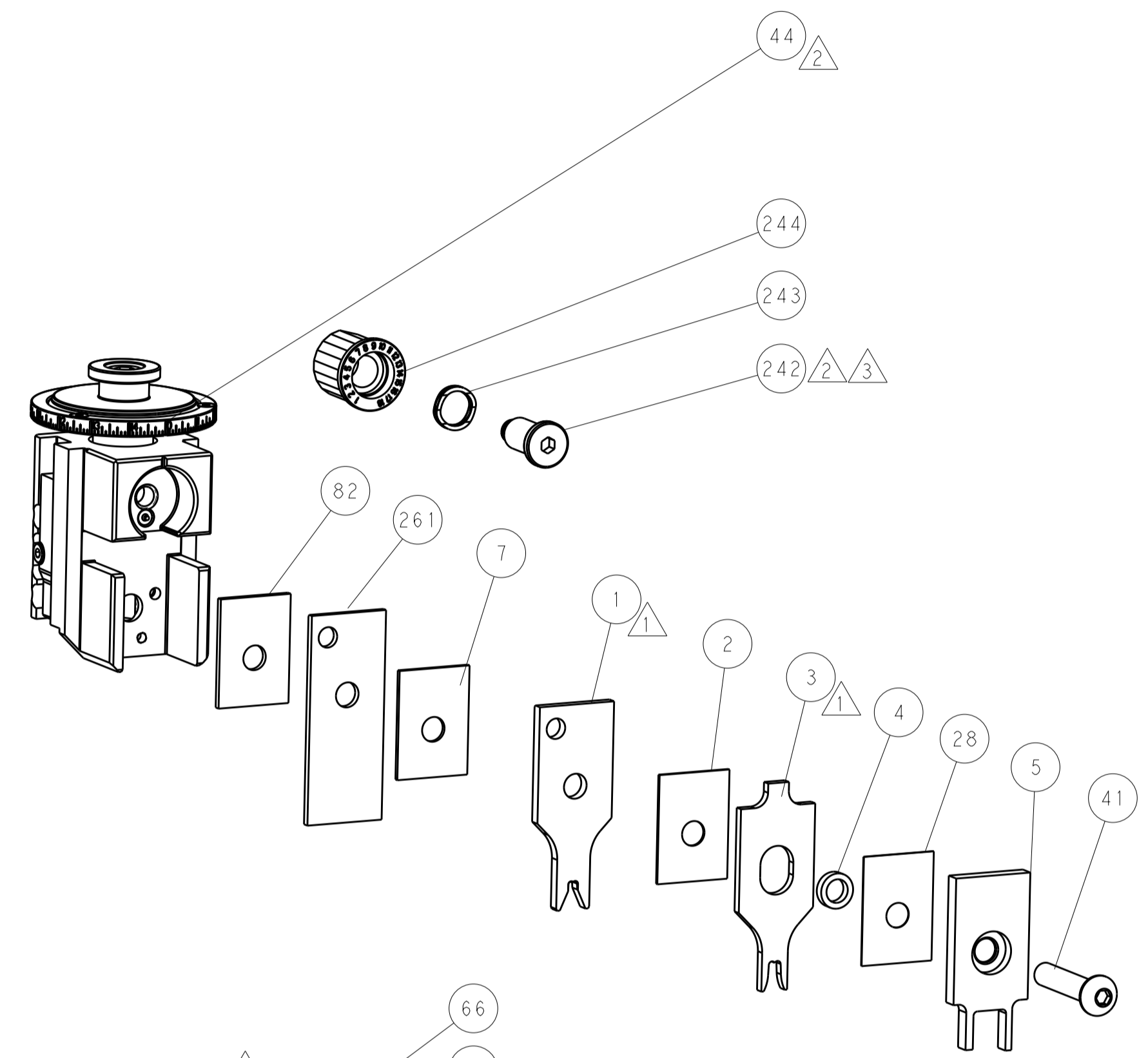
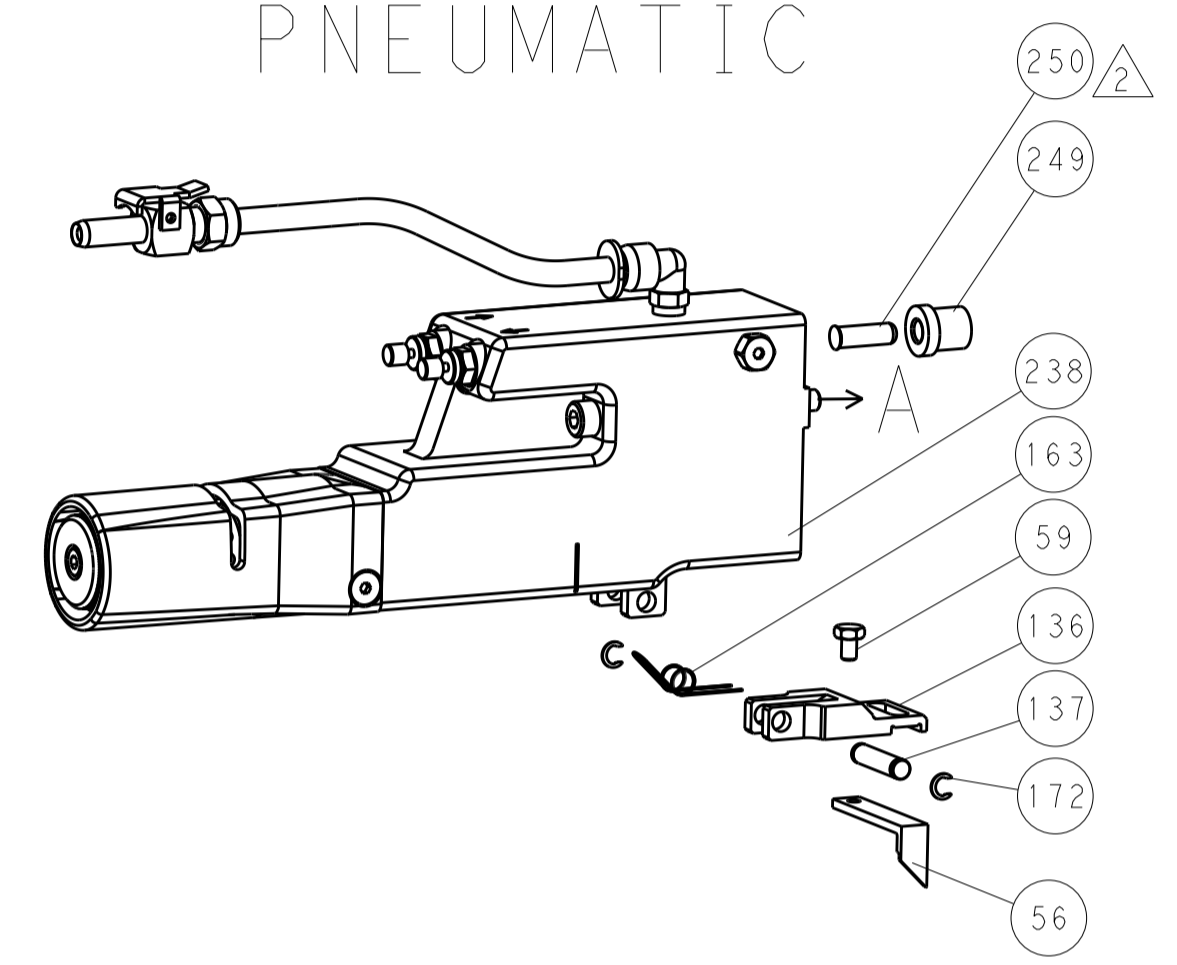
-	1	1	1633377-4	CRIMPER BLANK, WIRE	261
-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2063440-1	AIR FEED MODULE	238
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	240638-1	SPRING, FEED FINGER	163
-	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	124
-	1	1	1-22281-8	SPRING, COMPRESSION	123
9	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	100
6	-	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	1803607-1	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	1	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	1	9-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	2	1	7-1633860-4	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL				WEIGHT		SCALE	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 1 OF 4	

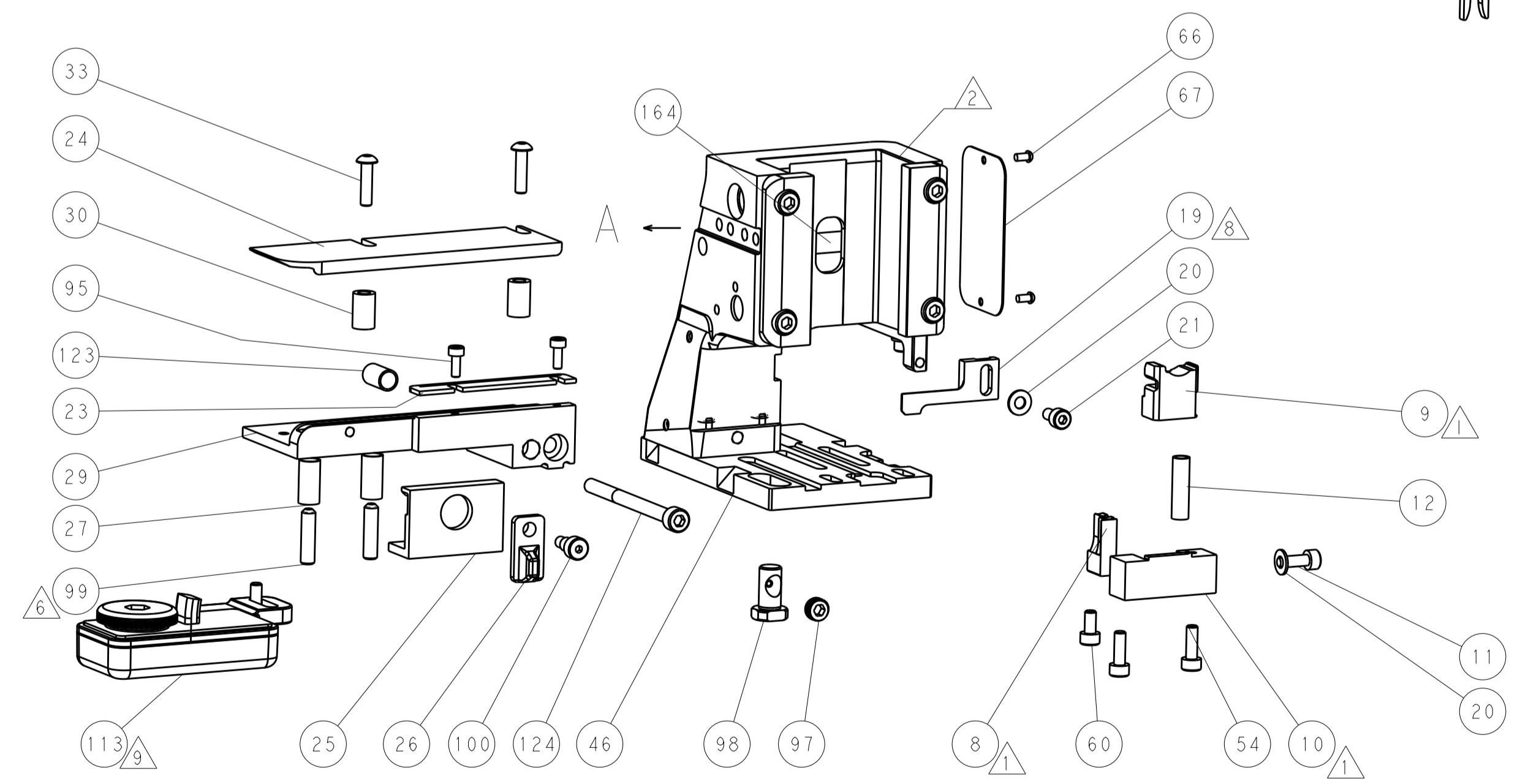
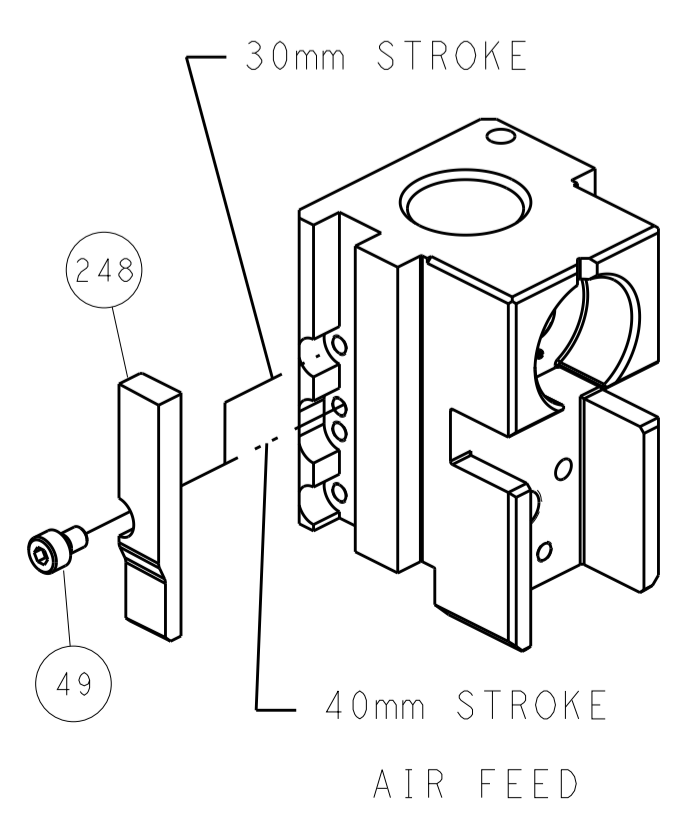
LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC



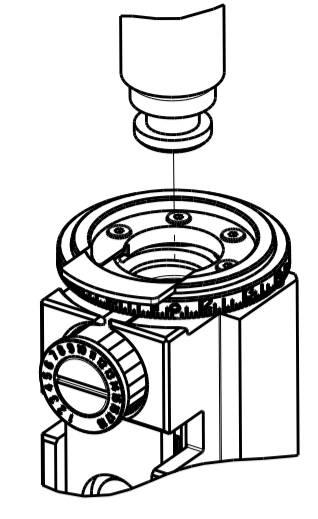
CAM POSITION



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		TE Connectivity	
mm	0 PLC	±		BOB HIGMAN	28 JUN 2014	Harrisburg, PA 17105-3608	
	1 PLC	±		T. ELBIN	28 JUN 2014	NAME	
	2 PLC	±		D. STOUGH	28 JUN 2014	Ocean Side Feed	
	3 PLC	±				Applicator	
	4 PLC	±				-	
	ANGLES	±				SIZE CAGE CODE DRAWING NO	
MATERIAL	FINISH			WEIGHT		RESTRICTED TO	
						A1 00779 ©=2266355	
Customer Accessible Production Drawing				SCALE	1:2	SHEET	2 OF 4 REV G

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



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

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
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



- 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.

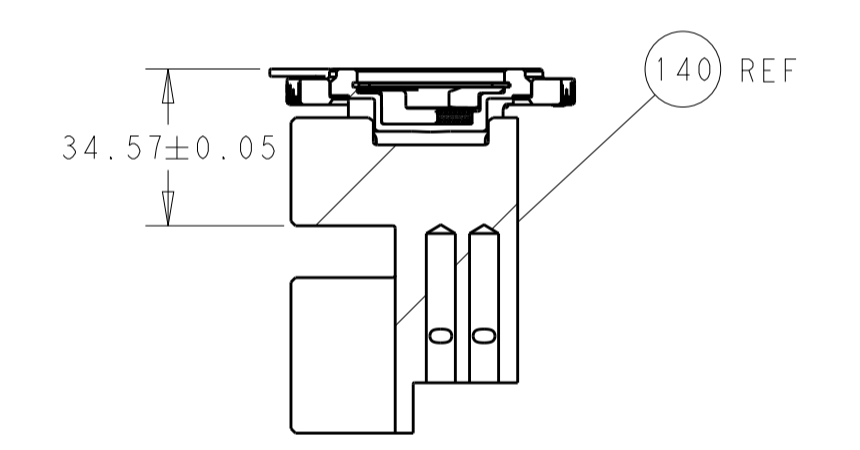
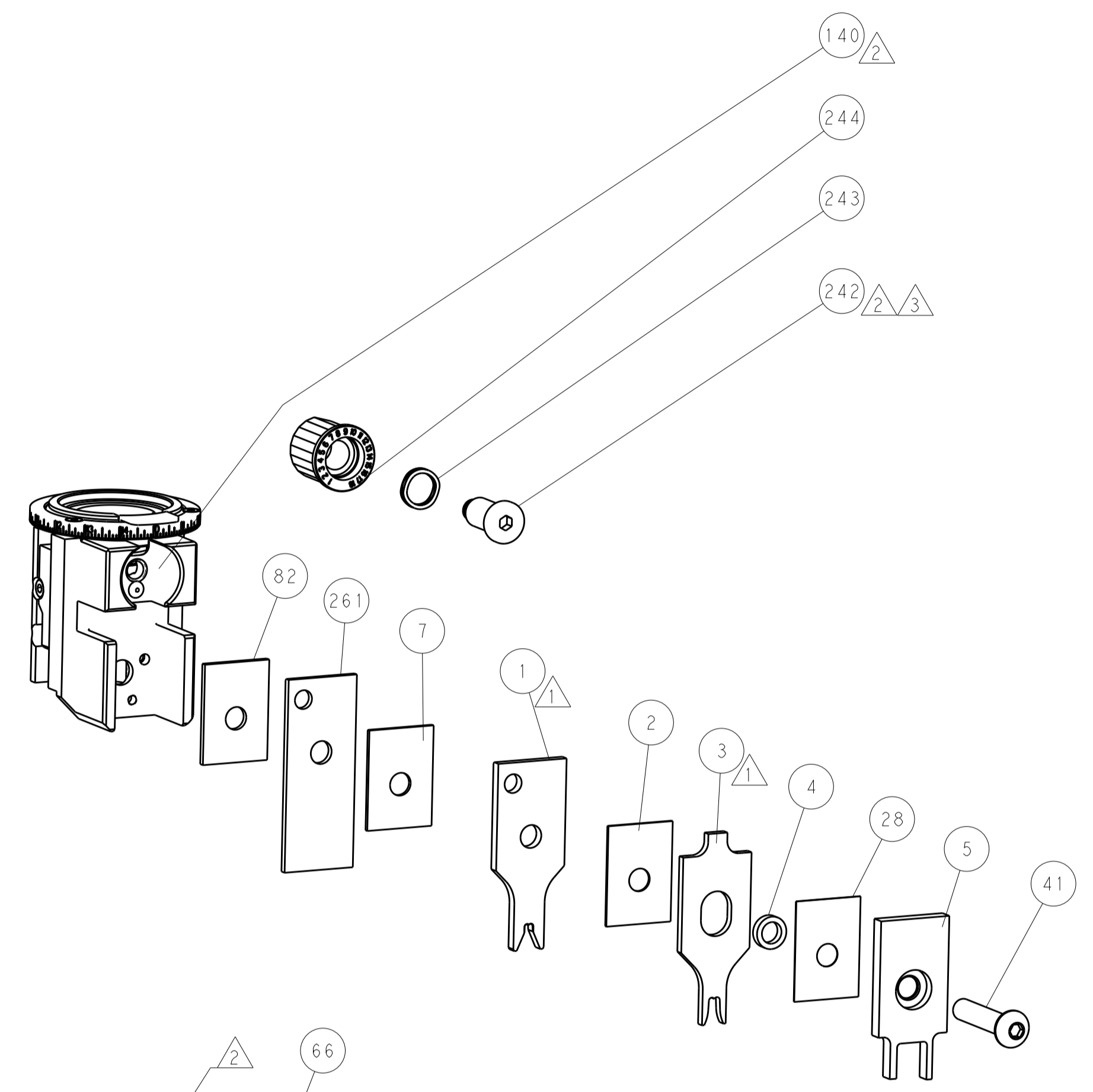
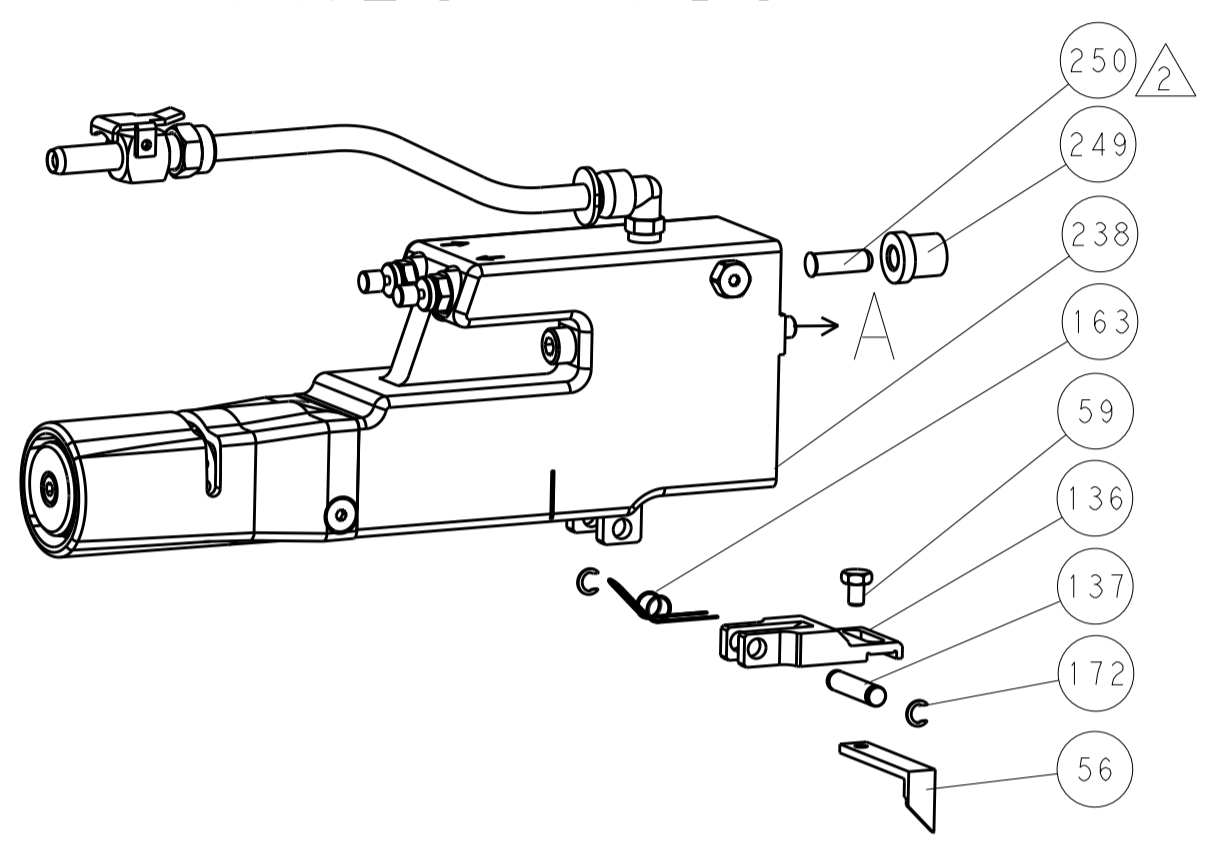
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC		DIST		REVISIONS					
A		66		P	LTN	DESCRIPTION	DATE	OWN	APVD
				-	-	SEE SHEET 1	-	-	-
-	1	1633377-4				CRIMPER BLANK, WIRE			261
-	1	2119640-1				PUSH ROD, AIR FEED			250
-	1	1803259-1				BUSHING, FLANGED			249
-	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	2063440-1				AIR FEED MODULE			238
-	2	21045-3				RING, RETAIN, EXTERN, 3/16 CRESCENT			172
-	REF	994970-2				COUNTER, MAGNETIC			164
-	1	240638-1				SPRING, FEED FINGER			163
-	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	3-23627-7				PIN, RETAIN, GRVD, 3/16 X .854			137
-	1	2119799-1				HOLDER, FEED FINGER, AF			136
-	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	1803607-1				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	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	1	9-2119582-2				CRIMPER, INSULATION F PREMIUM			3
-	1	455888-7				SPACER, CRIMPER			2
1	1	7-1633860-4				CRIMPER, WIRE			1
-	77	-22				PART NO			
						DESCRIPTION			ITEM NO

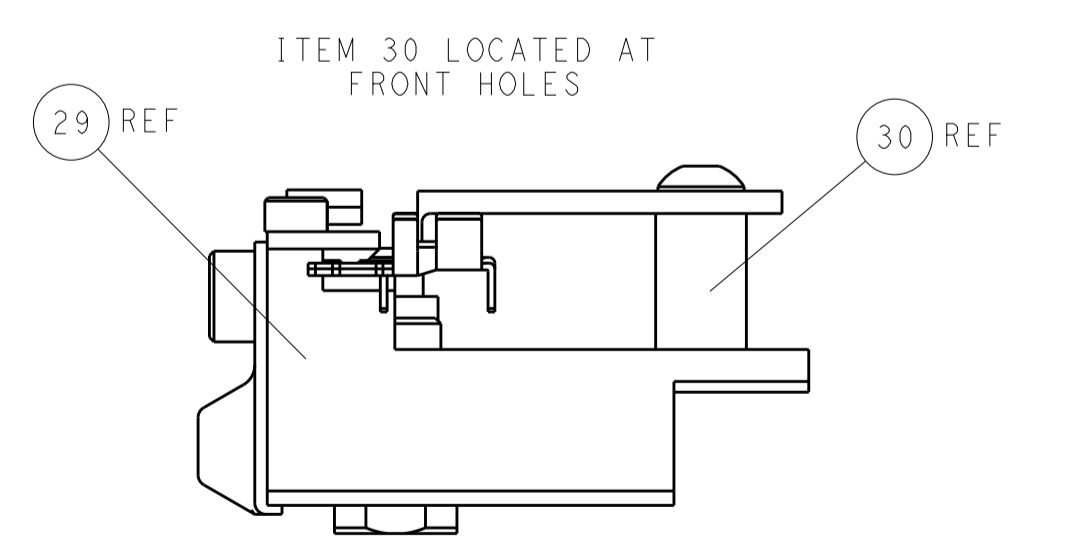
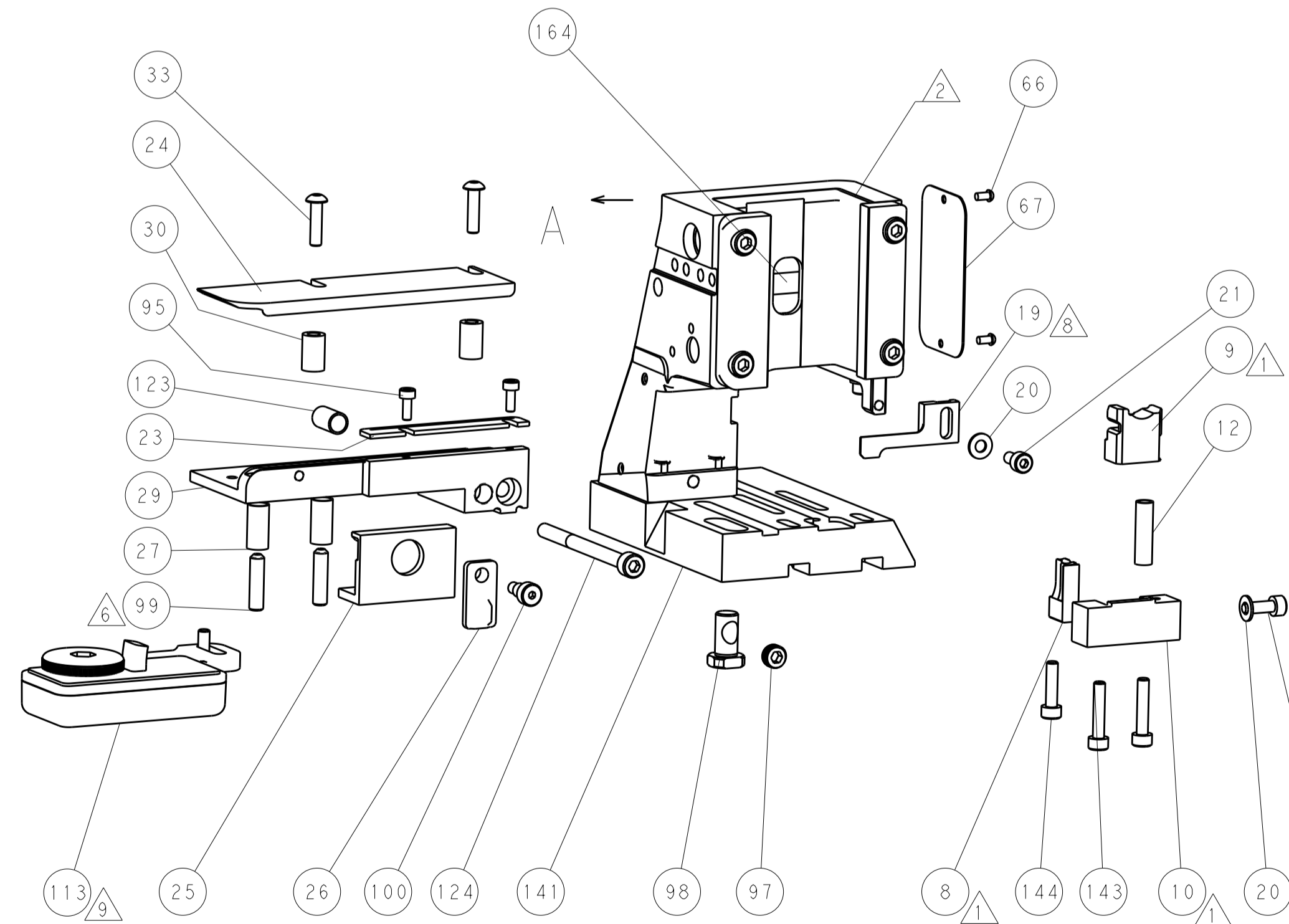
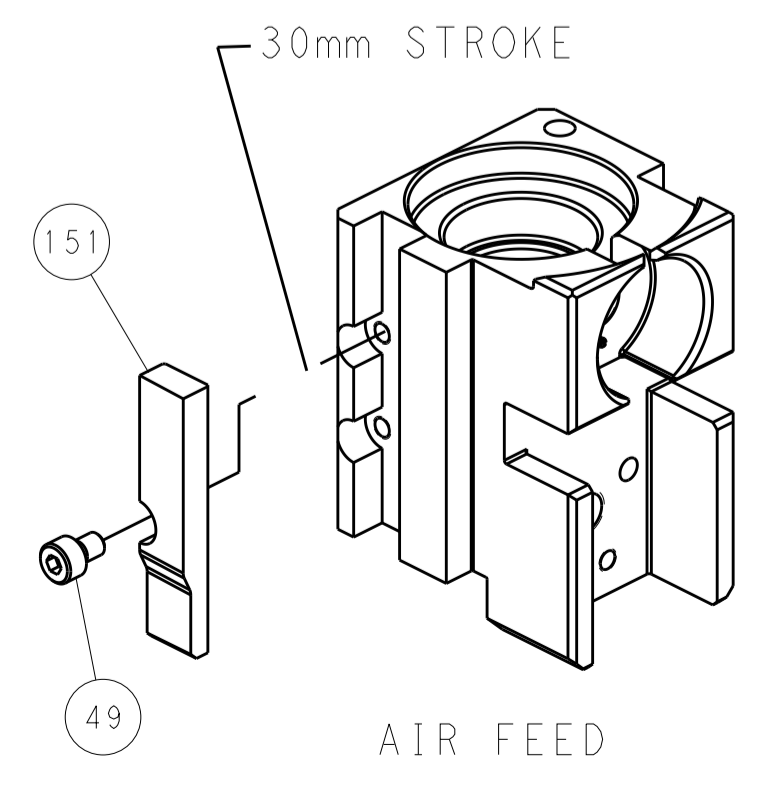
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES °	DWG: BOB HIGMAN 28JUN2014 CHK: T. ELBIN 28JUN2014 APVD: D. STOUGH 28JUN2014 NAME: Ocean Side Feed Applicator SIZE: A CAGE CODE: 00779 DRAWING NO: C=2266355 SCALE: 1:2 SHEET: 3 OF 4 REV: G	DATE: 28 JUN 2014 DRAWN: T. ELBIN APPROVED: D. STOUGH NAME: Ocean Side Feed Applicator SIZE: A CAGE CODE: 00779 DRAWING NO: C=2266355 SCALE: 1:2 SHEET: 3 OF 4 REV: G
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LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC



CAM POSITION



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. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: BOB HIGMAN 28JUN2014 CHK: T. ELBIN 28JUN2014 APVD: D. STOUGH 28JUN2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266355	RESTRICTED TO: G
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:2 SHEET: 4 OF 4 REV: G	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	