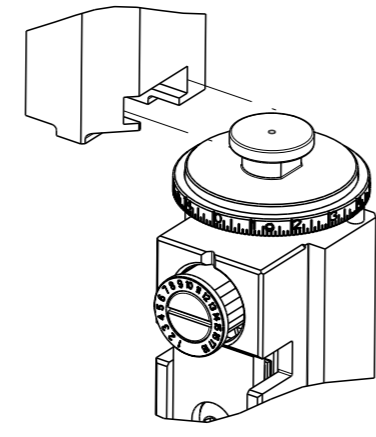


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266776-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266776-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266776-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266776-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266776-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [1.042]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: SOCKET CONTACT, PLUG							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
114-13157				-			
TERMINALS APPLIED							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1438890-8	1438896-4	2203232-4					

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.5DS	0.86+/-0.05 [1.034+/-0.002]	4.6
RG174 LL	0.79+/-0.038 [1.031+/-0.001]	5.9
RG174 or RG316 or DACAR 462	0.74+/-0.038 [1.029+/-0.001]	6.3

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 TERMINAL LUBRICANT RECOMMENDED.
- 5 SEE TERMINAL APPLICATION SPEC 114-13157 FOR WIRE STRIP LENGTH.
- 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.

**FOR LEADMAKER APPLICATIONS**

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

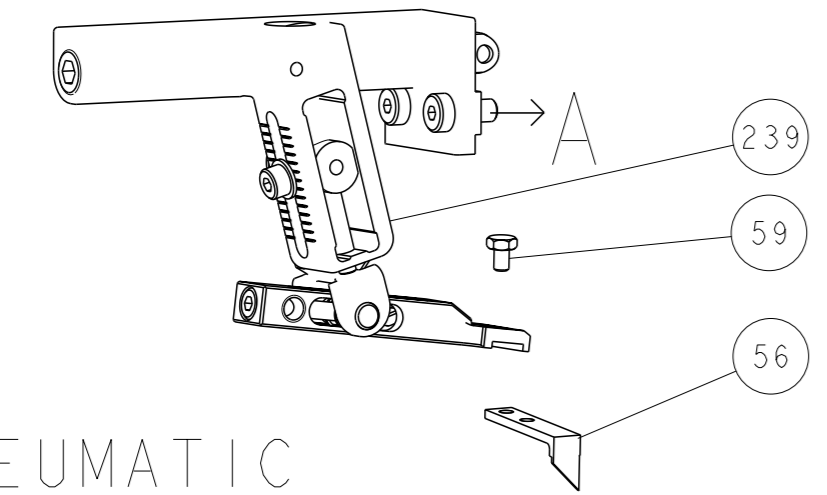
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		C		ECR-18-007764	23MAY2018	MZ	KZ
		D		ECR-19-011339	19JUL2019	FZ	TE
		D1		ECR-20-011338	12AUG2020	JWC	GB

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248					
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239					
-	-	-	1	-	2844940-1	AIR FEED MODULE	238					
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164					
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113					
-	1	1	1	1	2844908-1	SCREW, LOCKING	99					
-	1	1	1	1	2844907-1	POST, LOCKING	98					
-	1	1	1	1	455888-6	SPACER, CRIMPER	82					
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71					
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67					
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66					
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60					
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59					
-	1	1	1	1	1338685-1	PAWL, FEED	56					
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54					
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53					
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52					
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51					
-	1	1	1	1	690753-2	SPACER, TONKER	50					
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49					
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48					
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47					
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46					
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44					
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41					
-	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34					
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33					
-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30					
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29					
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28					
-	1	1	1	1	1320928-2	STRIP GUIDE	24					
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21					
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20					
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19					
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12					
-	1	1	1	1	356885-5	STOP, SHEAR	11					
-	1	1	1	1	1552193-1	HOLDER, SHEAR	10					
-	1	1	1	1	1803251-1	SHEAR, FLOATING	9					
-	1	2	2	1	1	4-1633933-9	ANVIL, COMBINATION	8				
-	-	-	-	-	-	-	7					
-	-	-	-	-	-	-	6					
-	1	1	1	1	1803419-3	DEPRESSOR, SHEAR	5					
-	-	-	-	-	-	-	4					
-	-	-	-	-	-	-	3					
-	-	-	-	-	-	-	2					
-	1	2	2	1	1	3-1333281-8	CRIMPER, WIRE PREMIUM	1				
-	77	-	72	-	71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

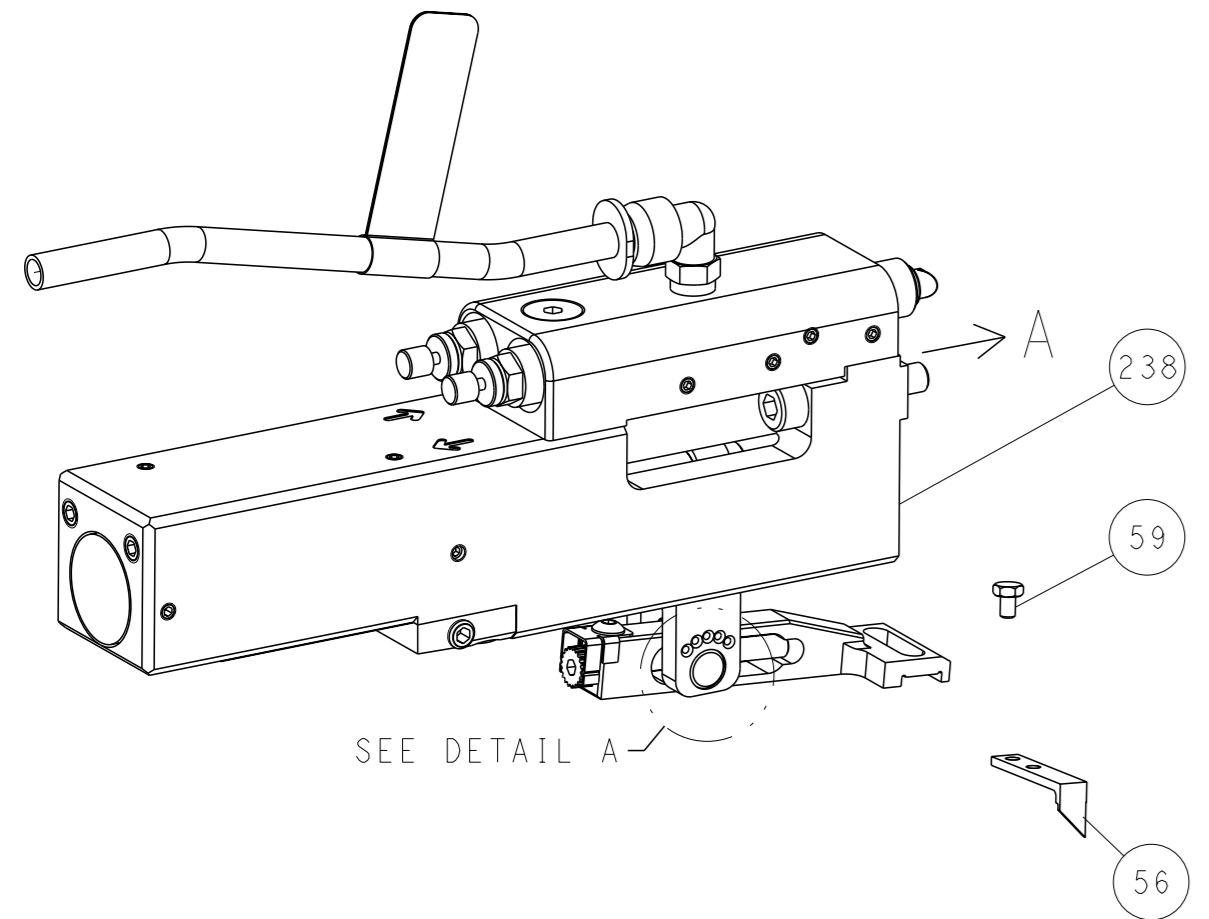
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	B. WEAVER	18MAY2015	TE Connectivity	
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1 PLC		±		APVD	T. ELBIN	18MAY2015	NAME	
2 PLC		±		PRODUCT SPEC		Ocean Side Feed		
3 PLC		±		APPLICATION SPEC		Applicator		
4 PLC		±		MATERIAL		-		
FINISH		-		WEIGHT		-		
-		-		SCALE		1:2		
-		-		SHEET		1 of 4		
-		-		REV		D1		

LOC		DIST		REVISIONS			
A		66		REV	DATE	OWN	APVD
-				1	SEE SHEET 1	-	-

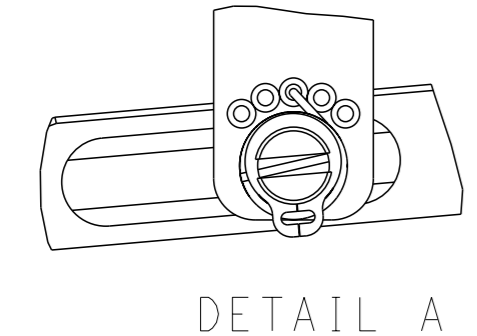
# FEED TYPE MECHANICAL



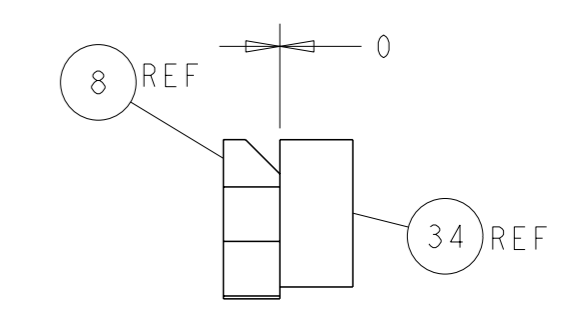
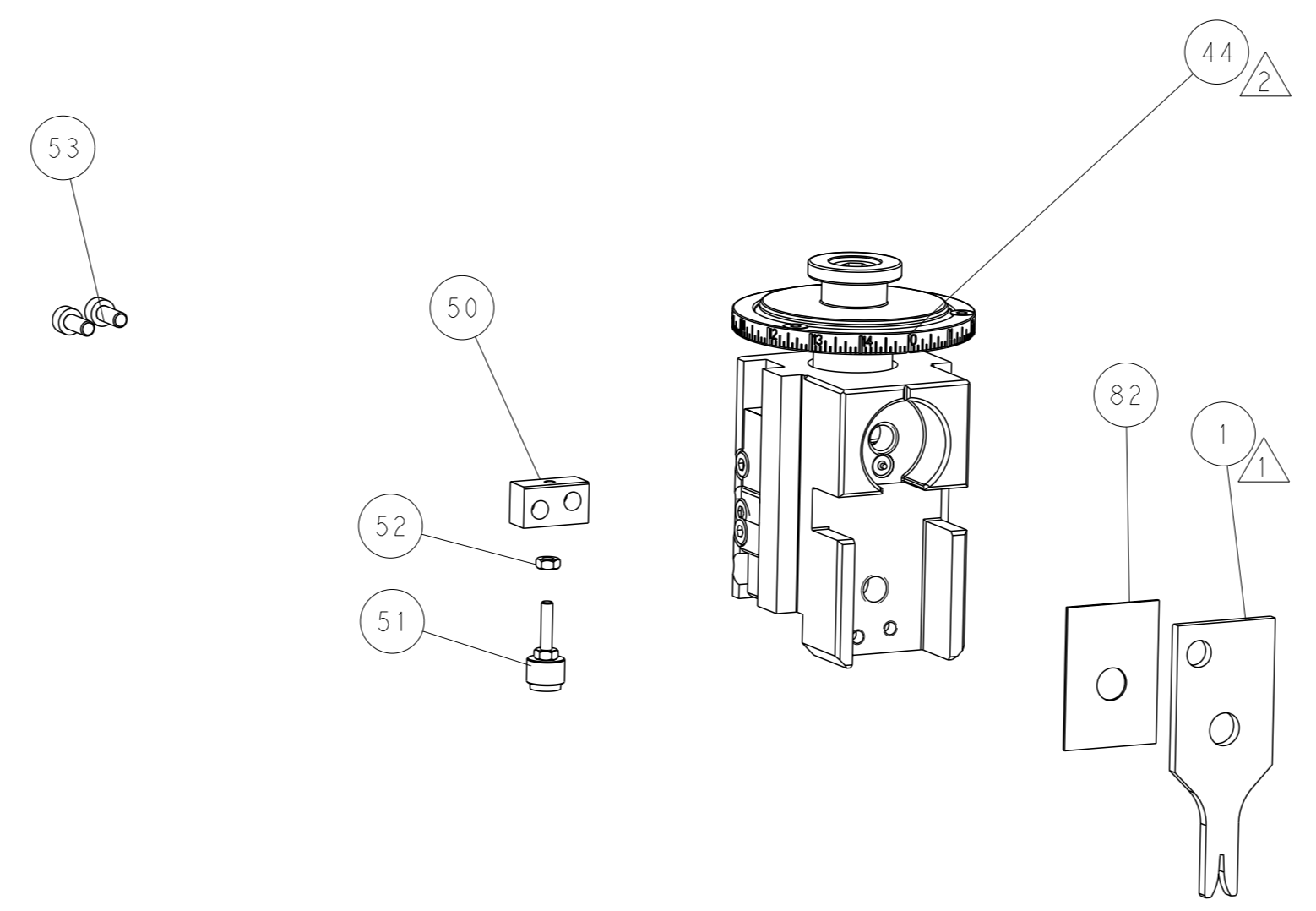
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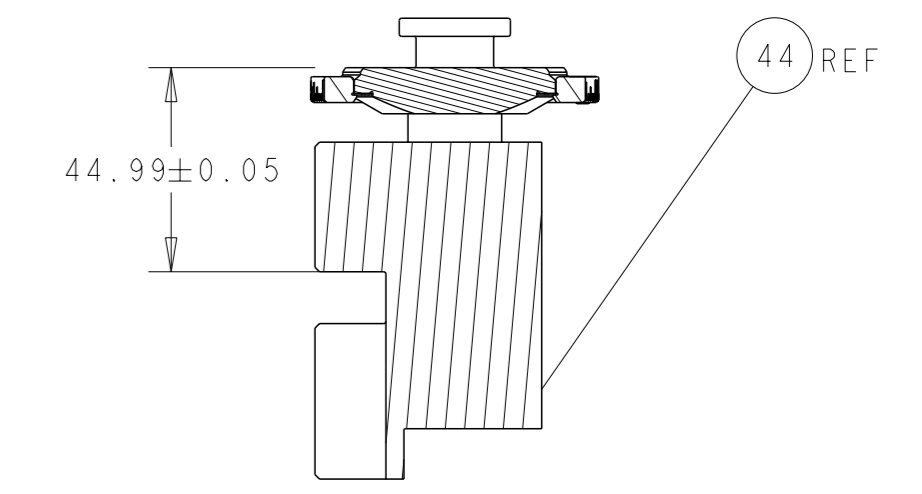
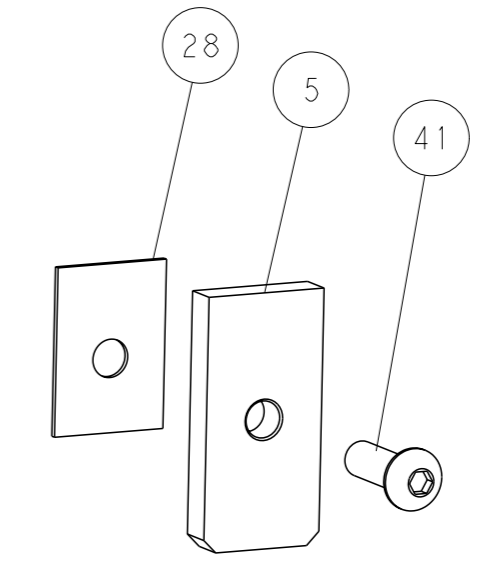
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



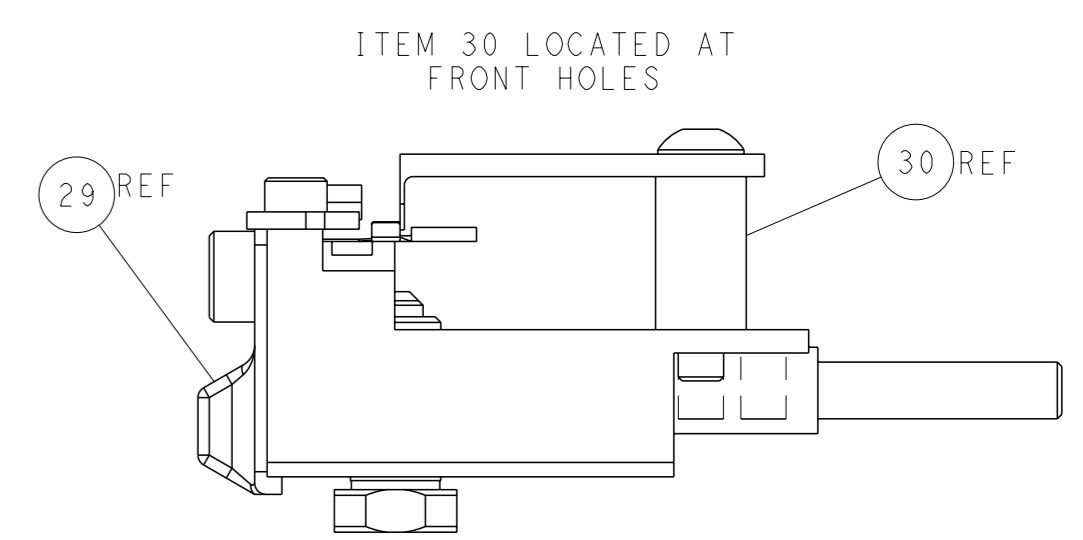
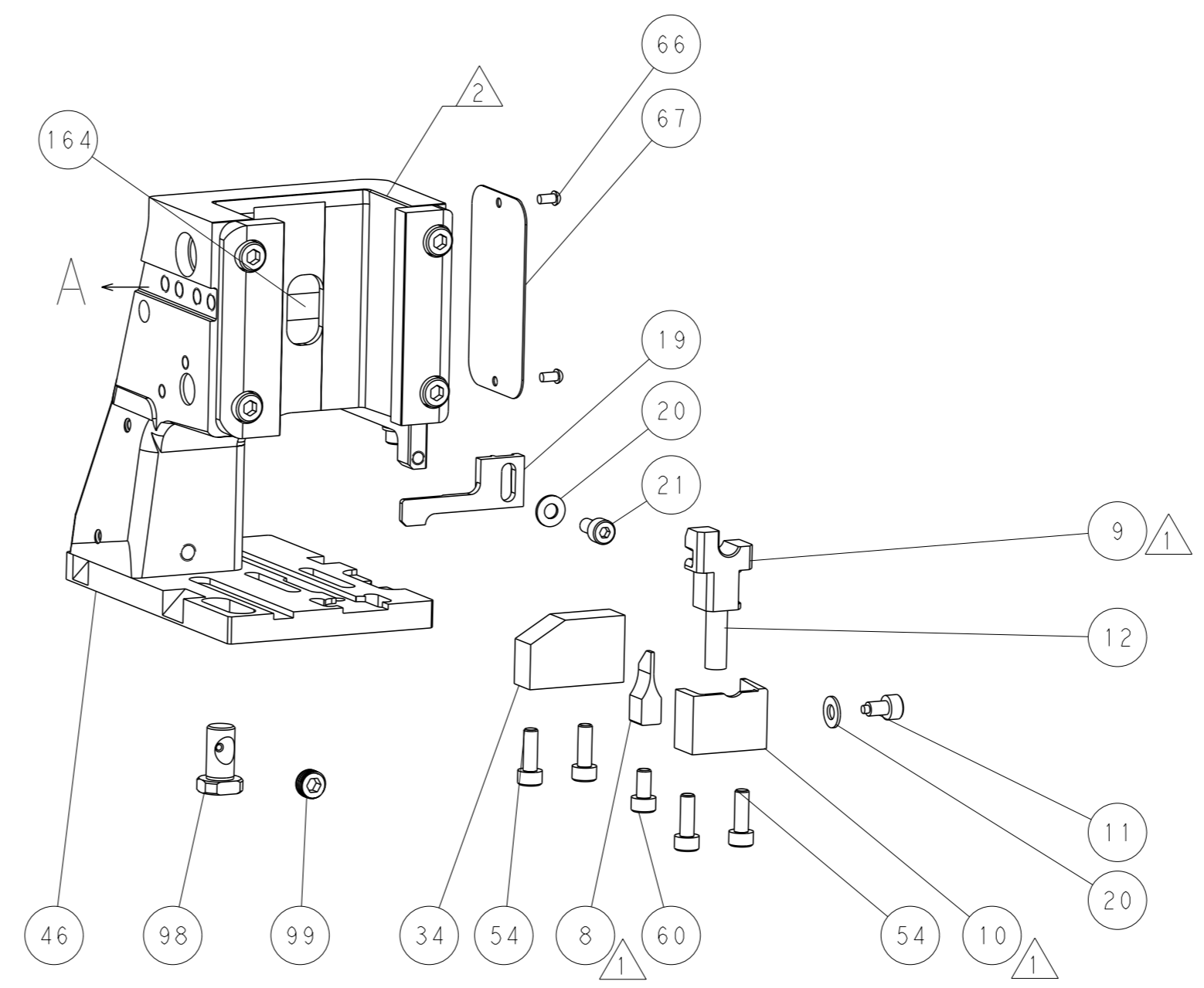
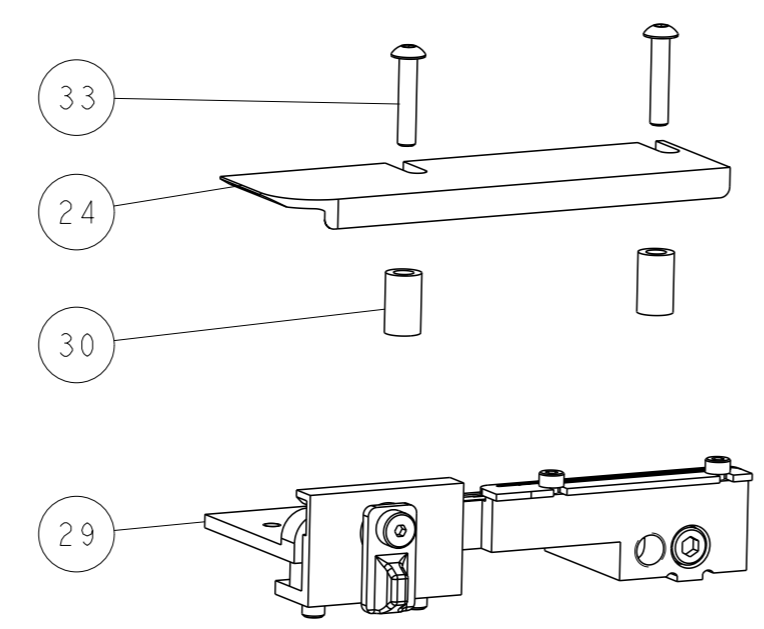
DETAIL A



TERMINAL SUPPORT LOCATION

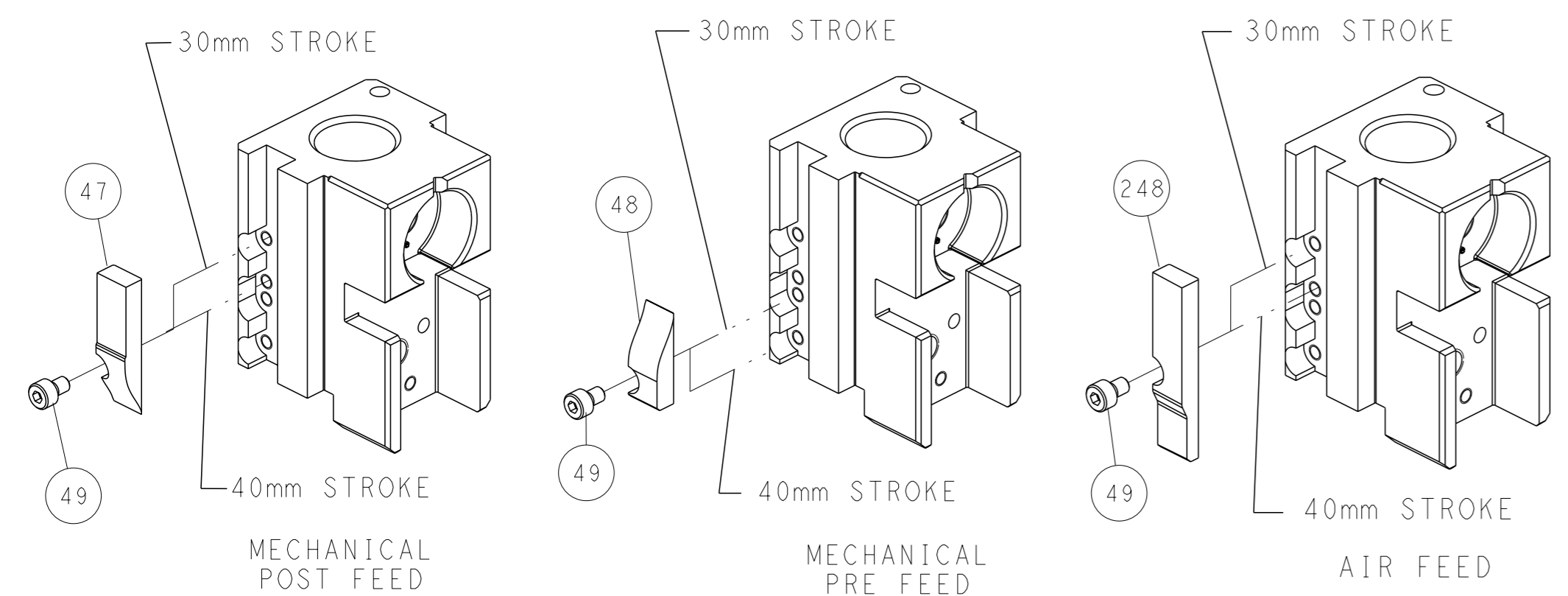


RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

# CAM POSITIONS

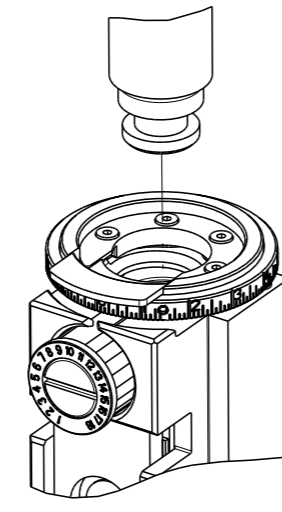


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 18MAY2015 CHK: T. ELBIN 18MAY2015 APVD: T. ELBIN 18MAY2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266776	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: D1
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266776-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266776-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266776-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SOCKET CONTACT, PLUG			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
TERMINAL APPLICATION SPECIFICATION	114-13157	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1438890-8	1438896-4	2203232-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.5DS	0.86+/-0.05 [.034+/- .002]	4.6
RG174 LL	0.79+/-0.038 [.031+/- .001]	5.9
RG174 or RG316	0.74+/-0.038 [.029+/- .001]	6.3
or DACAR 462	0.74+/-0.00 [.029+/- .000]	6.3

- RECOMMENDED SPARE PARTS
  - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
  - 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 RECOMMENDED.
  - SEE TERMINAL APPLICATION SPEC 114-13157 FOR WIRE STRIP LENGTH.
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.

**FOR LEADMAKER APPLICATIONS**

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

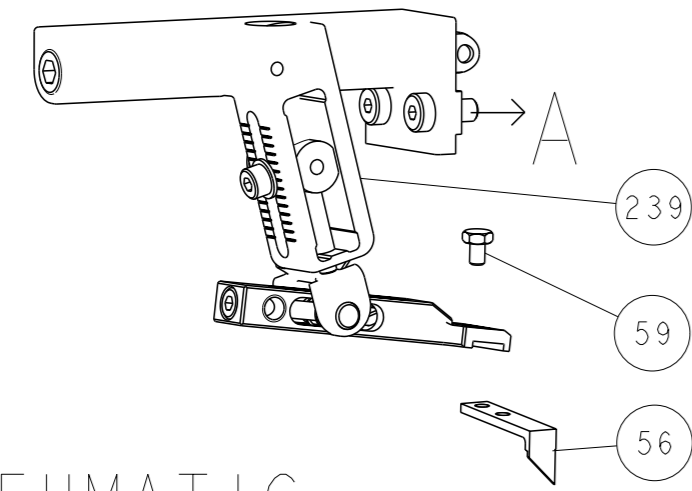
LOC	DIST	REVISIONS					
A	66	#	LYR	DESCRIPTION	DATE	OWN	APVD
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-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD 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	455888-6	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	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	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	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	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	356885-5	STOP, SHEAR	11
-	1	1	1552193-1	HOLDER, SHEAR	10
-	1	1	1803251-1	SHEAR, FLOATING	9
1	1	1	4-1633933-9	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1803419-3	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
1	1	1	3-1333281-8	CRIMPER, WIRE PREMIUM	1

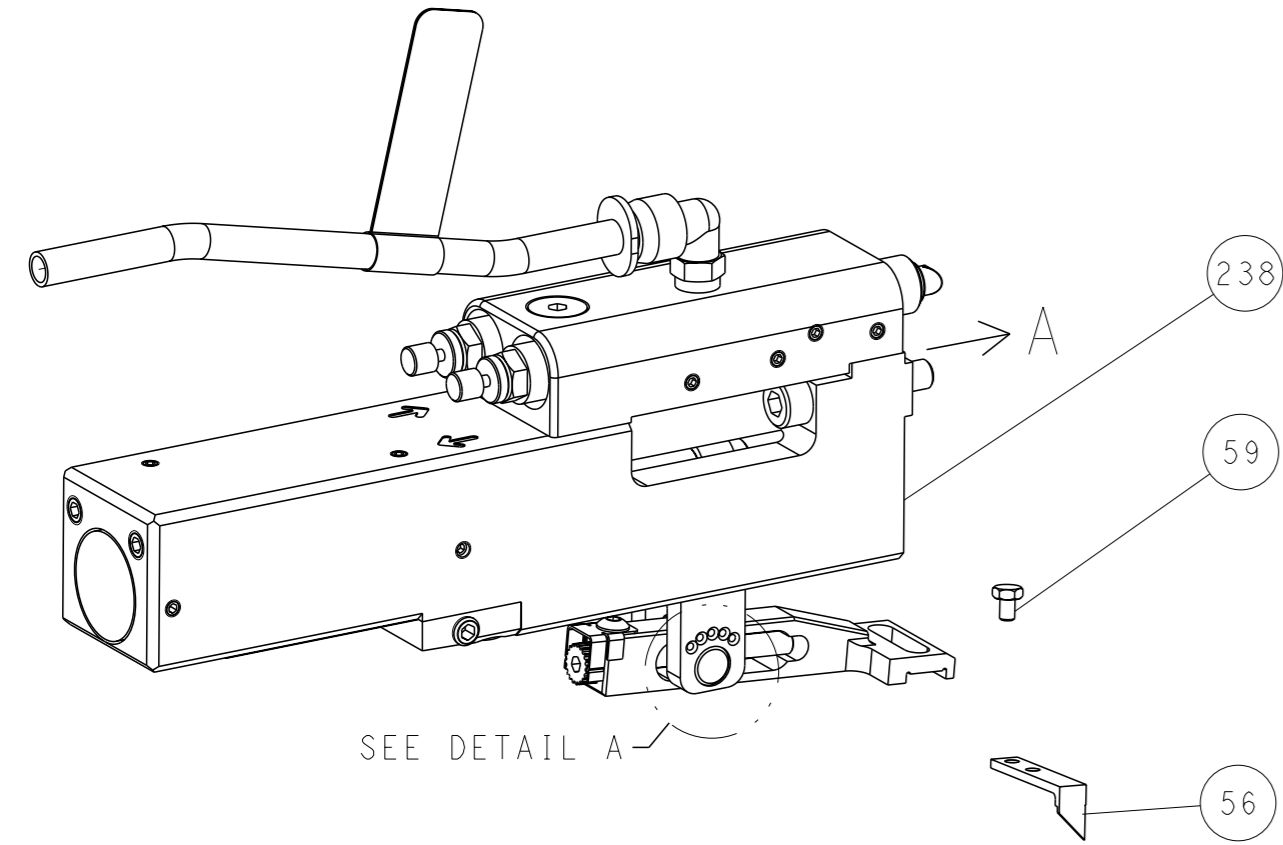
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	DATE	NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	B. WEAVER	18MAY2015	TE Connectivity	
	3 PLC ±	4 PLC ±	ANGLES ±	T. ELBIN	18MAY2015	Harrisburg, PA 17105-3608	
	FINISH ±			T. ELBIN	18MAY2015	Ocean Side Feed Applicator	
MATERIAL						SIZE	RESTRICTED TO
						00779	
						00779	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

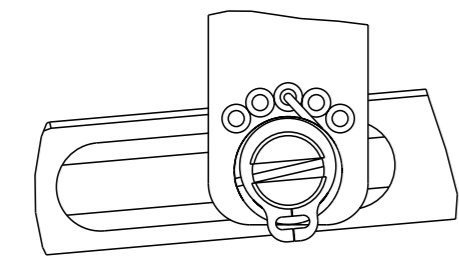
# FEED TYPE MECHANICAL



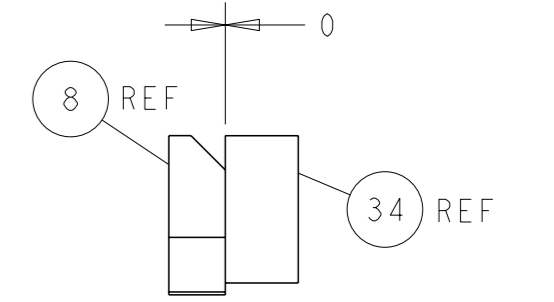
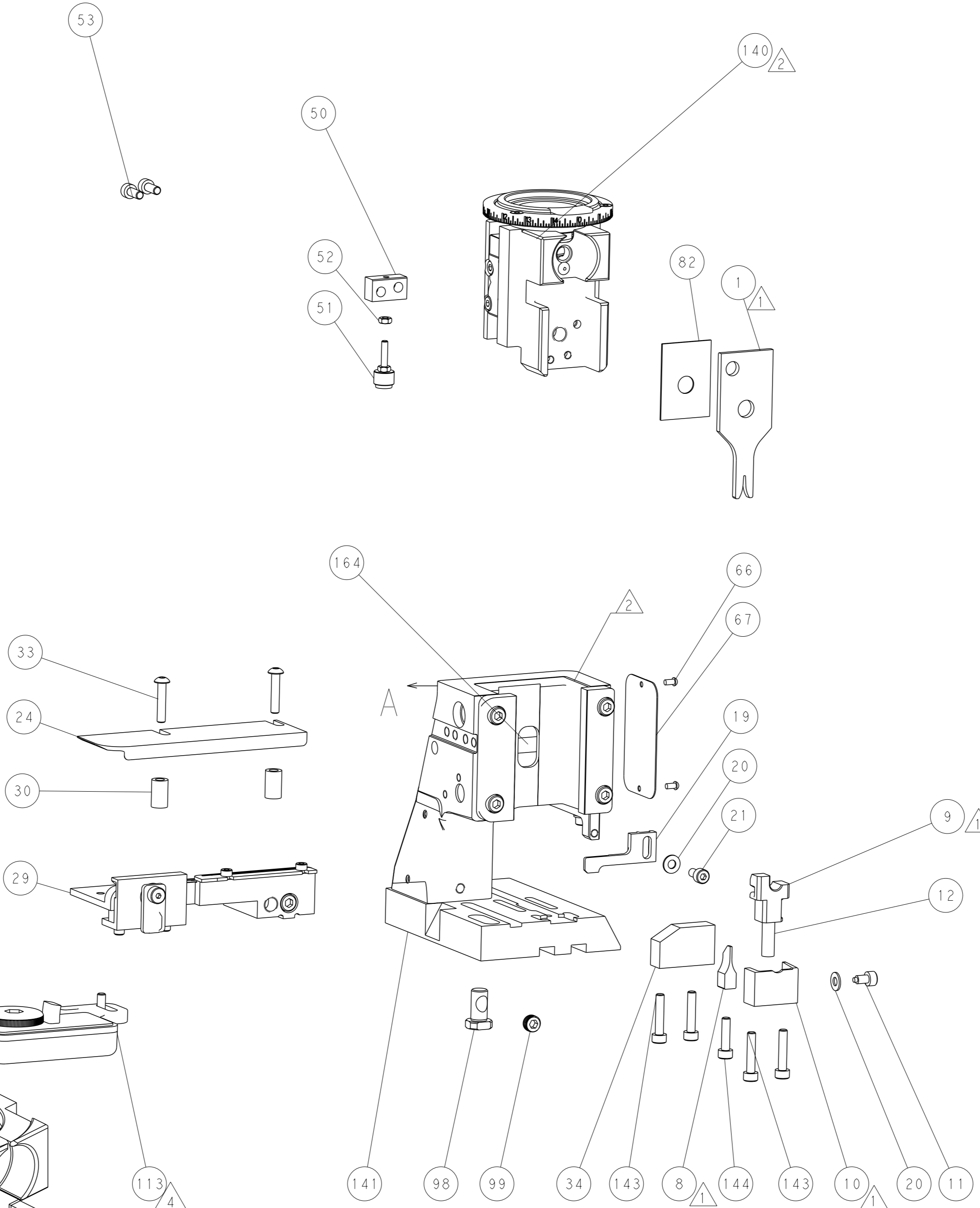
# PNEUMATIC



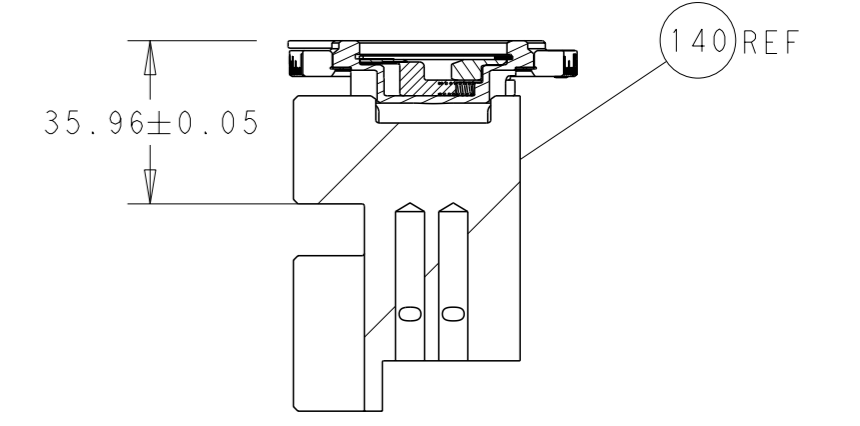
# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



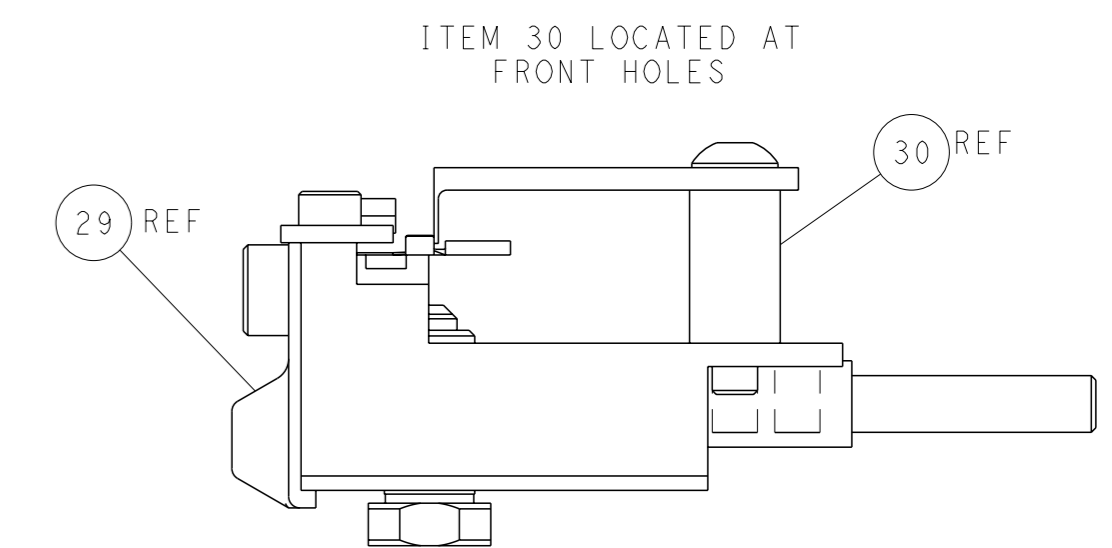
DETAIL A



TERMINAL SUPPORT LOCATION

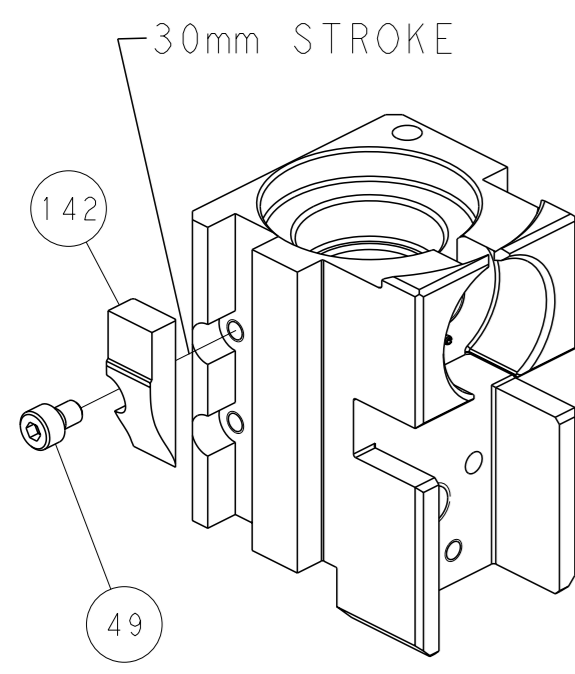


RAM SET-UP

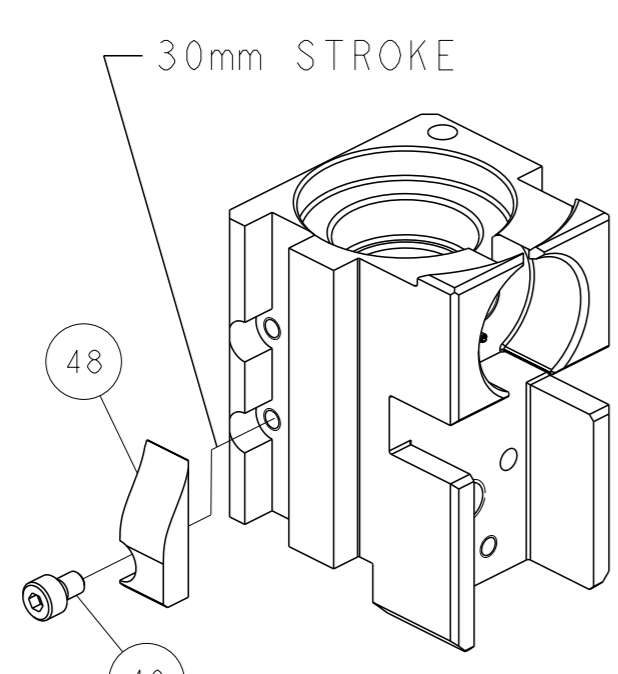


FEED TRACK POSITION  
GUIDE BY WIRE BARREL

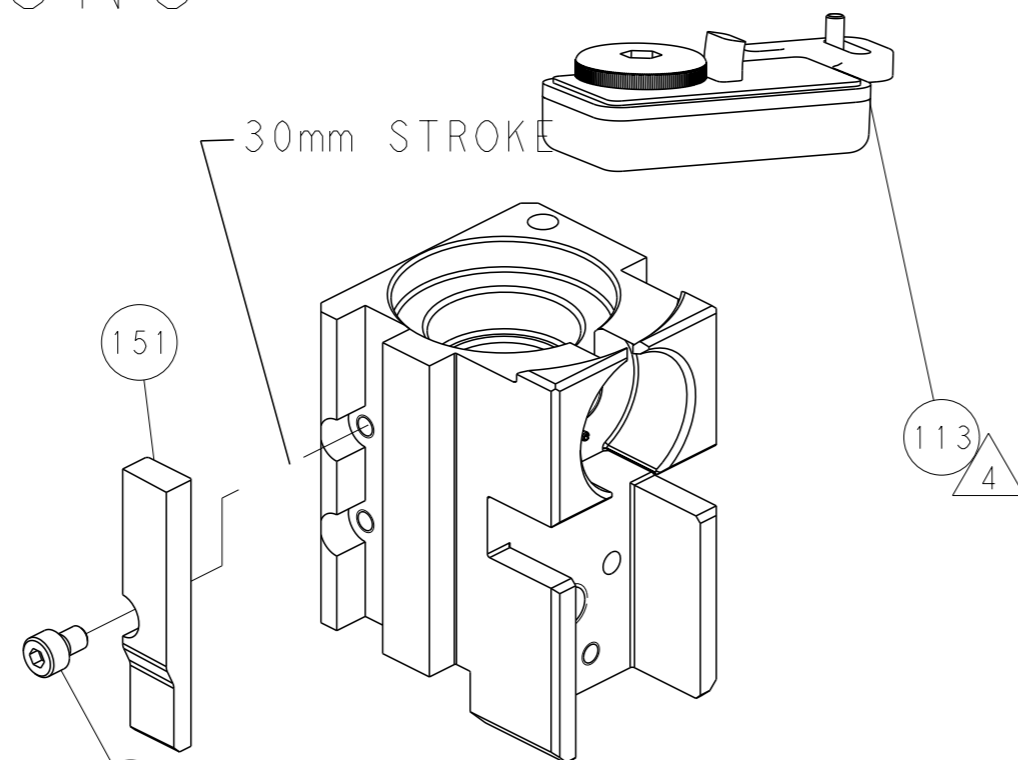
# CAM POSITIONS



MECHANICAL  
POST FEED



MECHANICAL  
PRE FEED



AIR FEED

**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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 18MAY2015 CHK: T. ELBIN 18MAY2015 APVD: T. ELBIN 18MAY2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266776	RESTRICTED TO: - SHEET 4 OF 4 REV D1
MATERIAL: -		Customer Accessible Production Drawing	