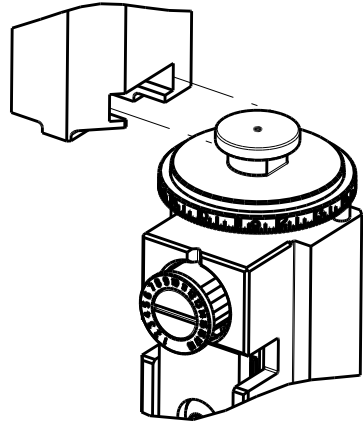


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266233-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266233-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266233-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266233-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266233-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.81 mm [.032]	F
INSUL	0.97 mm [.038]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: SAMTEC TERMINAL SAMTEC CRIMP SPECIFICATION			
TERMINAL NAME: .050" C.L. DISCRETE WIRE CONTACT			
WIRE STRIP LENGTH 2.28-2.54 mm [.090-.100 IN]		INSULATION DIAMETER RANGE Ø0.74-0.97 mm [.029-.038 IN]	
TERMINAL APPLICATION SPECIFICATION	STS-A-006 Rev E	-	-
TERMINALS APPLIED 5			
TE TERMINAL	SAMTEC TERMINAL	TE TERMINAL	SAMTEC TERMINAL
2113440-1	CC03R-2830-01-H		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG	0.46+/-0.025 [.018+/- .001]	8.6
30 AWG	0.41+/-0.025 [.016+/- .001]	9.3



- 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 LUBRICANT IS RECOMMENDED.
- 6 GRIND AT ASSEMBLY.

7. 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	P	LTR	DESCRIPTION	DATE	DWN	APVD	
			B	ECR-16-007051	16MAY2016	KH	TE	
			C	ECR-16-014722	18OCT2016	KH	JDG	
			D	ECR-17-000276	09JAN2017	TB	TE	
			F	ECR-19-008847	05JUN2019	MZ	TE	

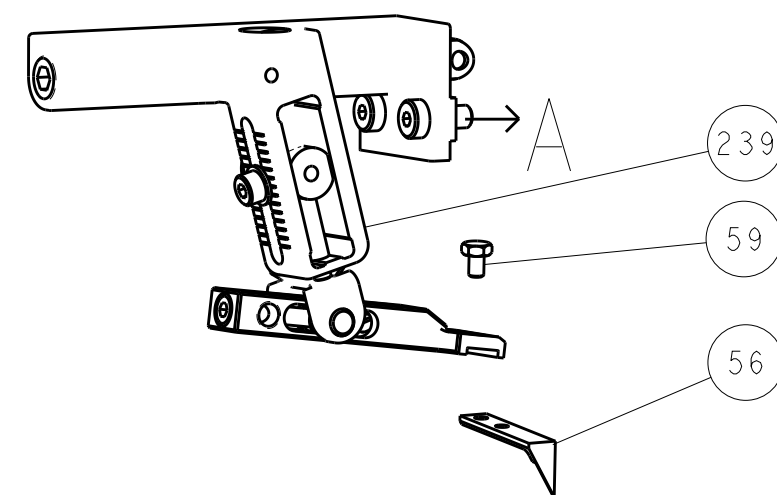
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	356885-4	STOP, SHEAR	237
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	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	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	3-240641-7	SPACER	81
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	1338685-3	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	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
-	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	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2280441-1	INSERT, SHEAR	23
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	3-690518-3	HOLD DOWN, TERMINAL	18
-	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	1	1424599-2	PLATE, REAR SHEAR	15
-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	2	2	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT -	9
1	2	2	1	1	7-1633927-7	ANVIL, COMBINATION	8
-	1	1	1	1	1-240641-3	SPACER	7
-	1	1	1	1	1-690468-8	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-3	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1803167-4	CRIMPER, INSULATION F SPECIAL	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	1803191-3	CRIMPER, WIRE	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST EDITION. TOLERANCES UNLESS OTHERWISE SPECIFIED:				DWN HOFFNER 03MAR2014	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS:				CHK T.ELBIN 04MAR2014	NAME		
mm				APVD T.ELBIN 04MAR2014	Ocean Side Feed Applicator		
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				PRODUCT SPEC - APPLICATION SPEC -	SIZE 00779		
MATERIAL				WEIGHT	Customer Accessible Production Drawing		
-				-	SCALE 1:2		
					SHEET 1 OF 4		
					REV F		

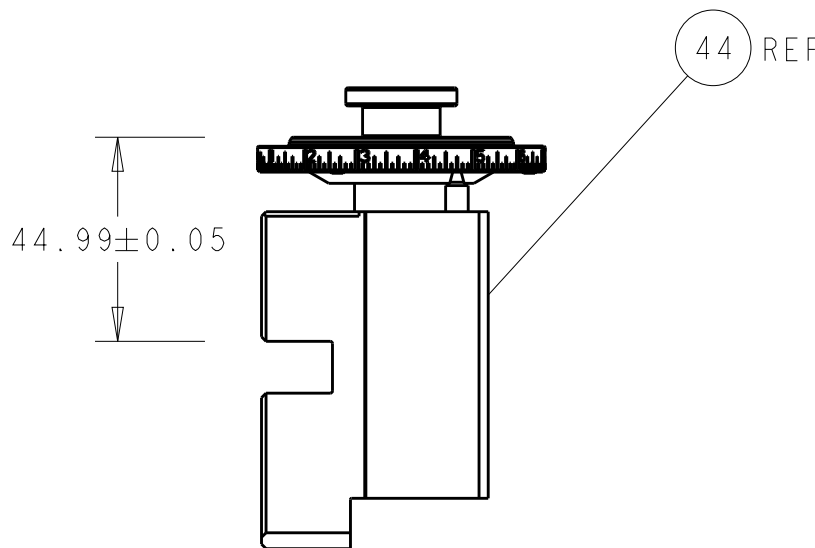
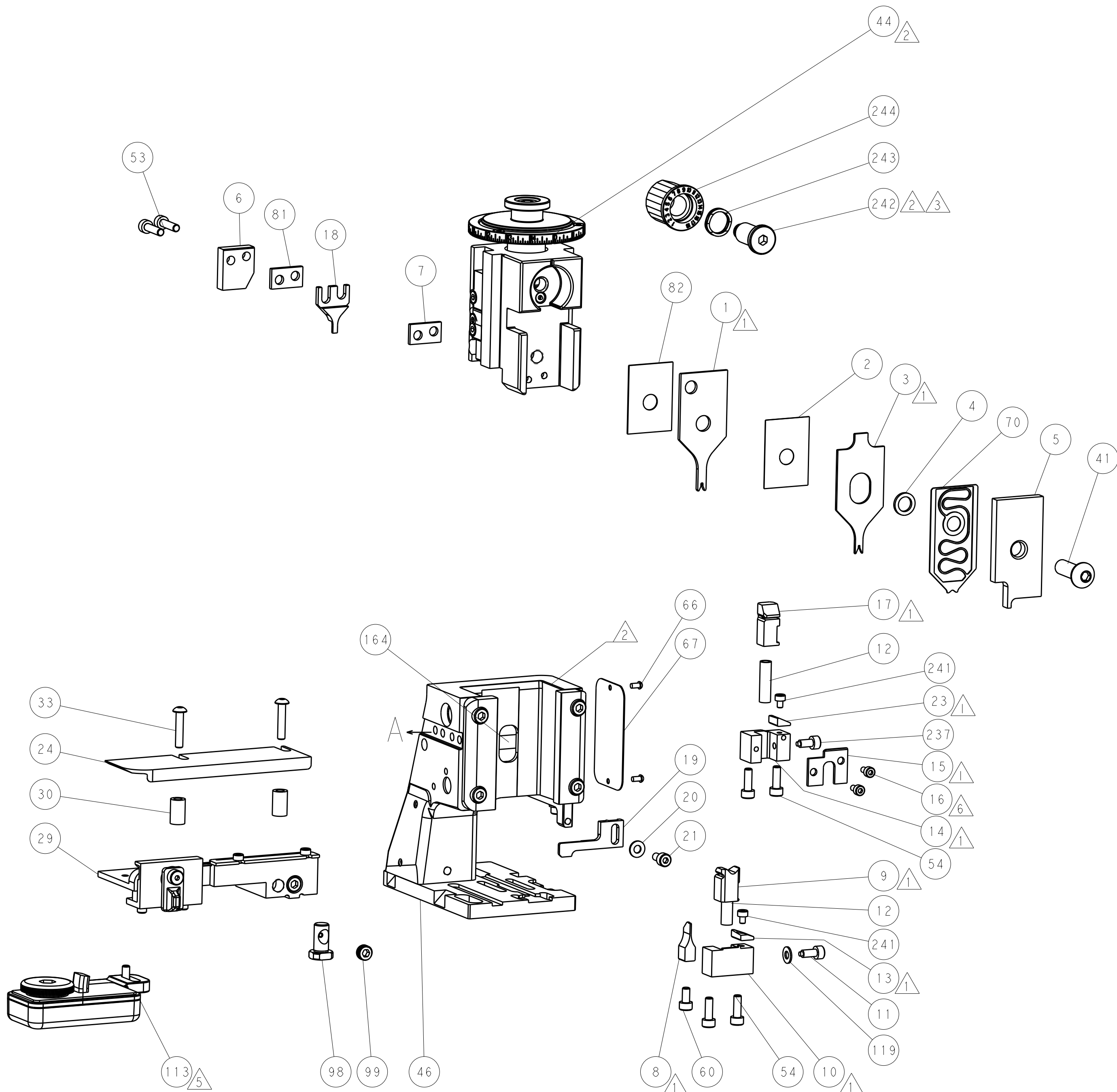
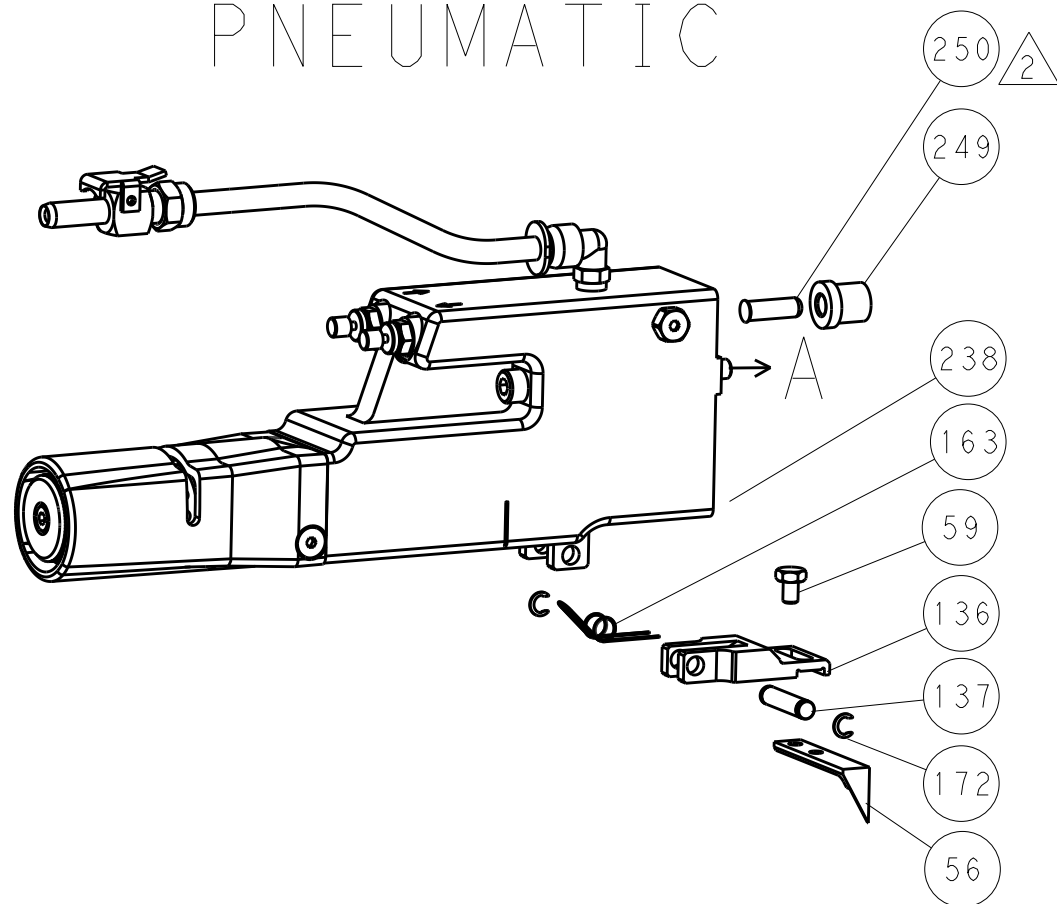
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

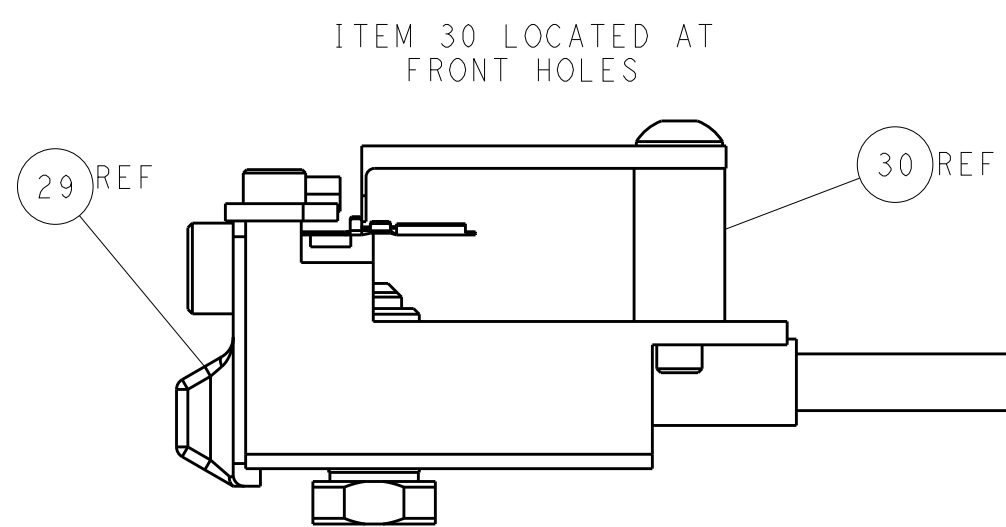
FEED TYPE
MECHANICAL



PNEUMATIC

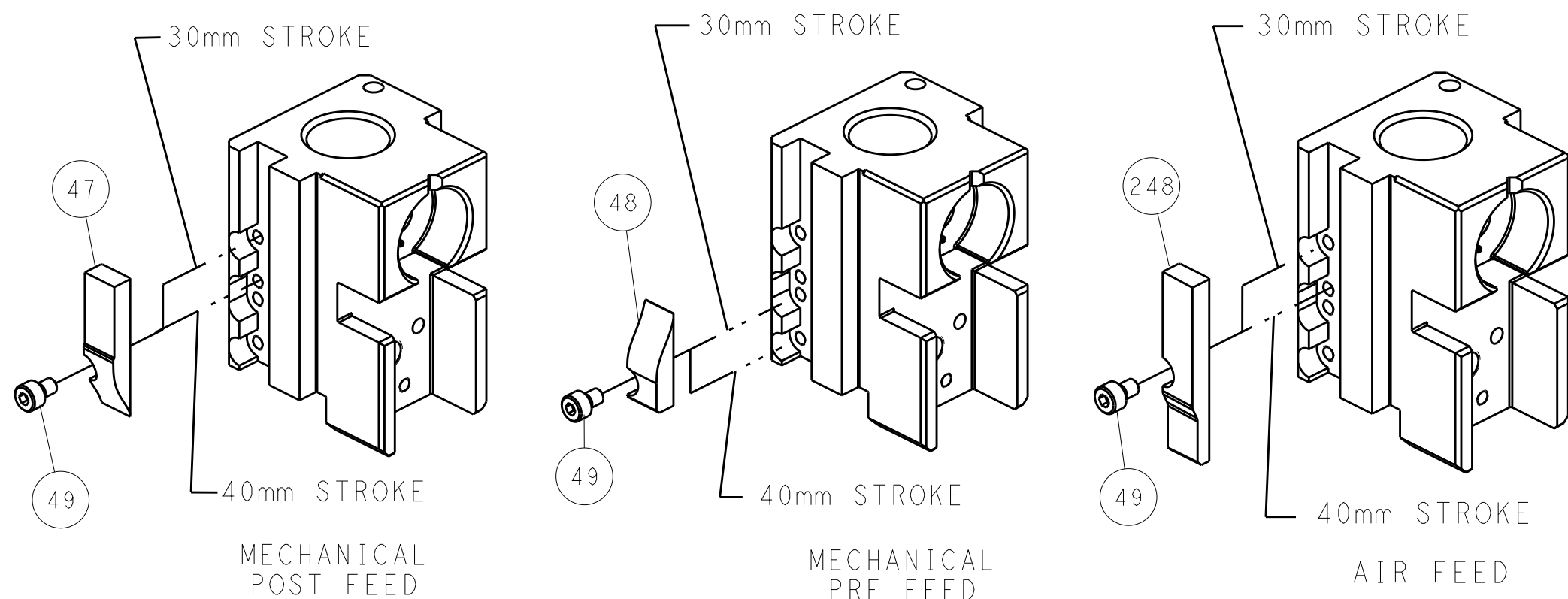


RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

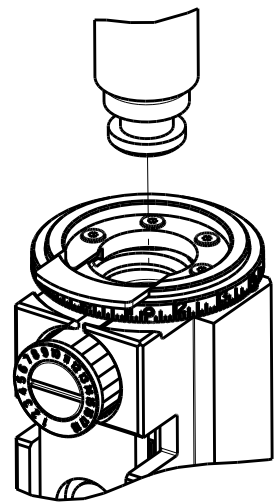
CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: HOFFNER 03MAR2014		CHK: TELBIN 04MAR2014		APVD: TELBIN 04MAR2014		NAME: Ocean Side Feed Applicator	
mm		0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±	
MATERIAL:		FINISH:		WEIGHT:		Customer Accessible Production Drawing		SCALE: 1:2		SHEET 2 of 4	
										REV F	

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
(C) COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266233-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266233-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266233-7	D	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.81 mm [.032]	F
INSUL	0.97 mm [.038]	F

APPLICATOR INSTRUCTIONS
408-35042



TERMINAL DATA: SAMTEC TERMINAL		SAMTEC CRIMP SPECIFICATION	
TERMINAL NAME: .050" C.L. DISCRETE WIRE CONTACT			
WIRE STRIP LENGTH 2.28-2.54 mm [.090-.100 IN]		INSULATION DIAMETER RANGE Ø0.74-0.97 mm [.029-.038 IN]	
TERMINAL APPLICATION SPECIFICATION		STS-A-006 Rev E	
TERMINALS APPLIED			
TE TERMINAL 2113440-1	SAMTEC TERMINAL CC03R-2830-01-H	TE TERMINAL	SAMTEC TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
28 AWG		0.46 +/- 0.025 [.018 +/- .001]		8.6
30 AWG		0.41 +/- 0.025 [.016 +/- .001]		9.3



- 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 LUBRICANT IS RECOMMENDED.
- ⑥ GRIND AT ASSEMBLY.

7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

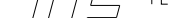
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING
FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER
THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING.
REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

05 REV 31MAR2000

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

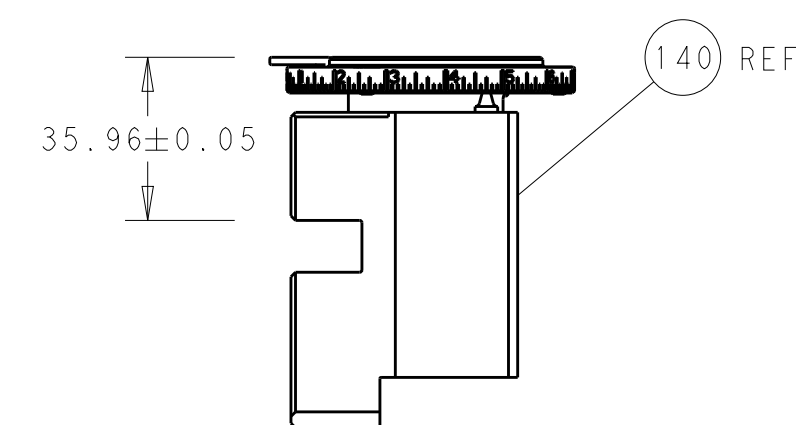
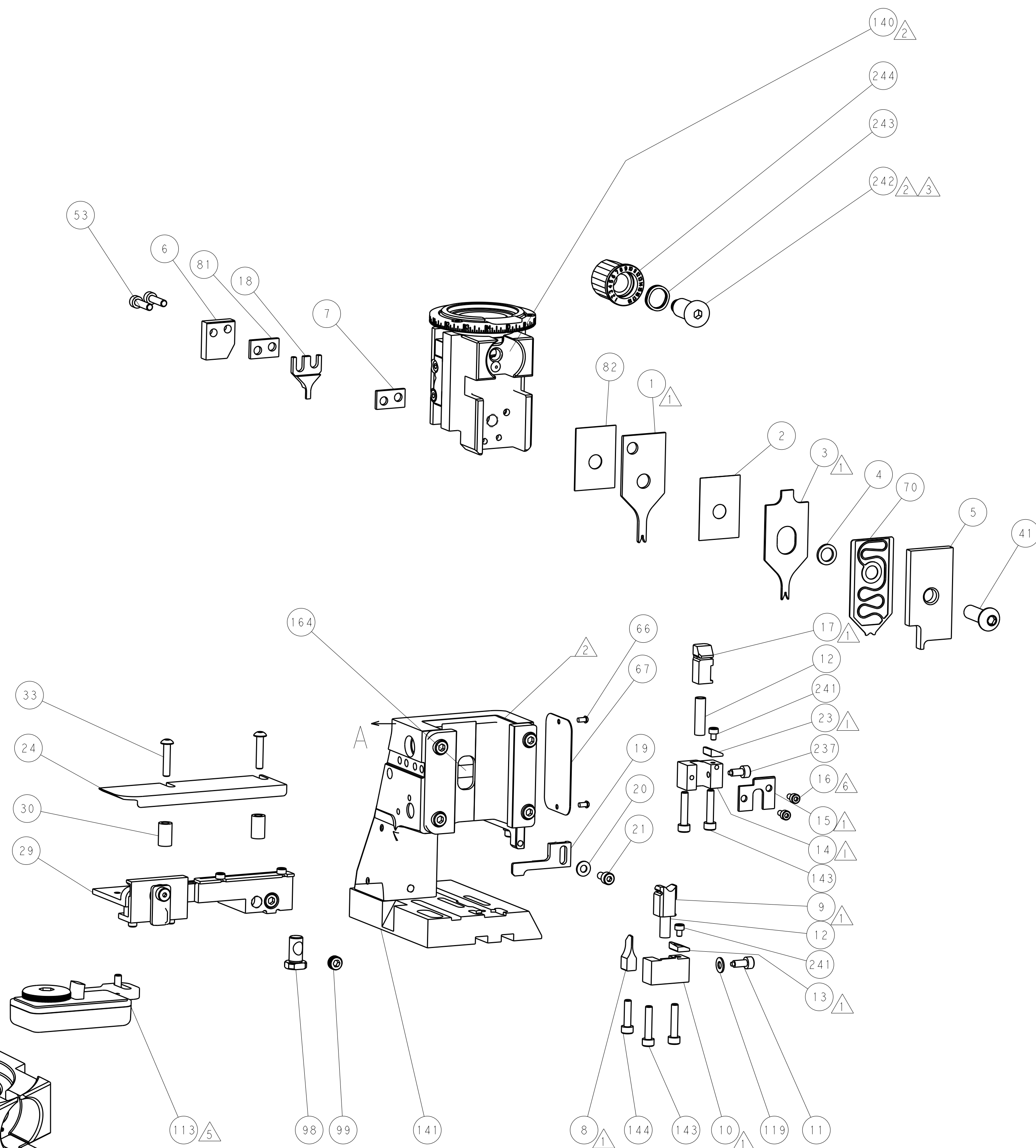
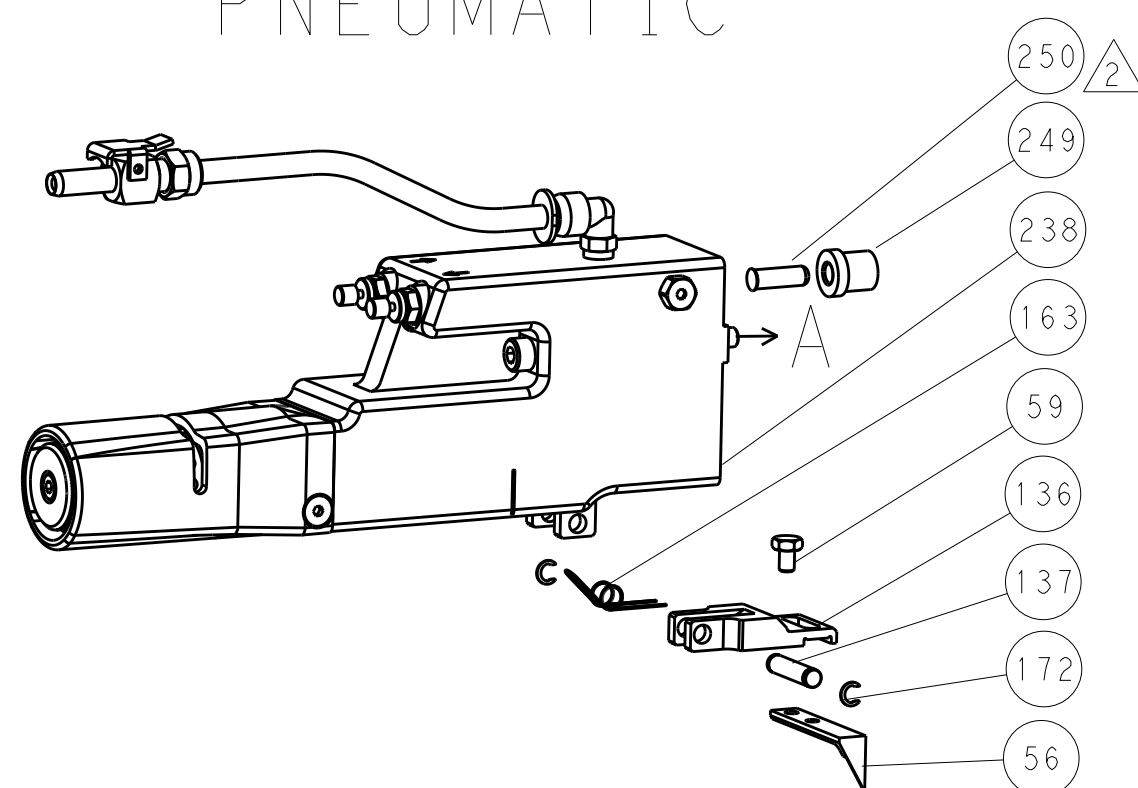
PACIFIC VERSION
(Atlantic version shown on sheets 1 of 4 & 2 of 4)
Shown on sheets 3 of 4 & 4 of 4

[illegible]

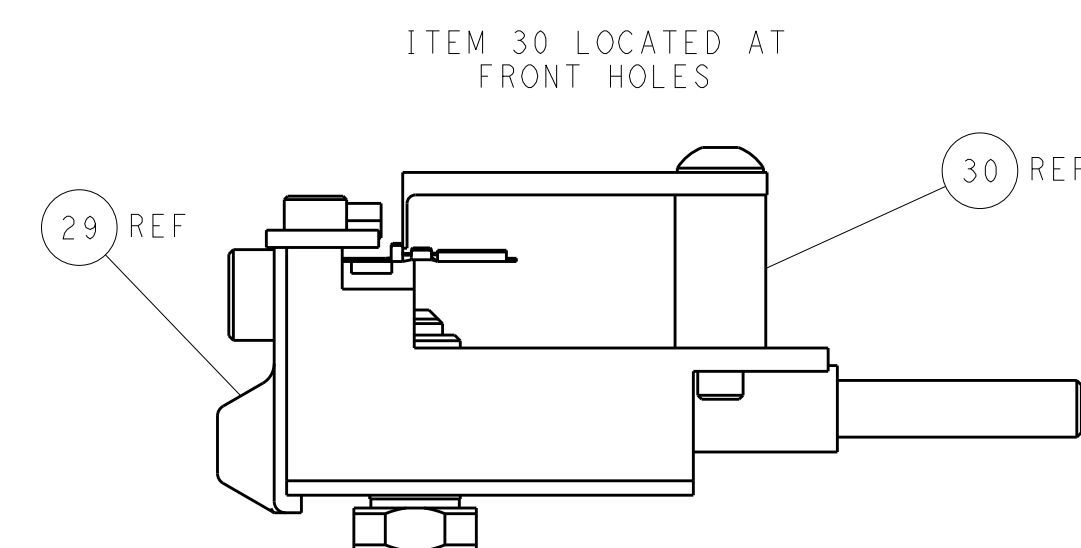
THIS DRAWING IS THE PROPERTY OF STE CONNECTIVITY CORPORATION IT IS TO BE USED FOR THE MANUFACTURE OF THE PRODUCT SPECIFIED HEREON IT IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN CONSENT OF STE CONNECTIVITY CORPORATION		DWG. NO. 03MAR2014 CHKD BY ELBIN 04MAR2014 APPROVED BY T. FLIN 04MAR2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1°		NAME Ocean Side Feed Applicator -	
MATERIAL -		FINISH -		SIZE CAGE CODE DRAWING NO A 00779 C-2266233	
WEIGHT -		RESTRICTED TO -		SCALE 1:2 SHEET 3 OF 4 REV F	
Customer Accessible Product Drawing					

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

PNEUMATIC

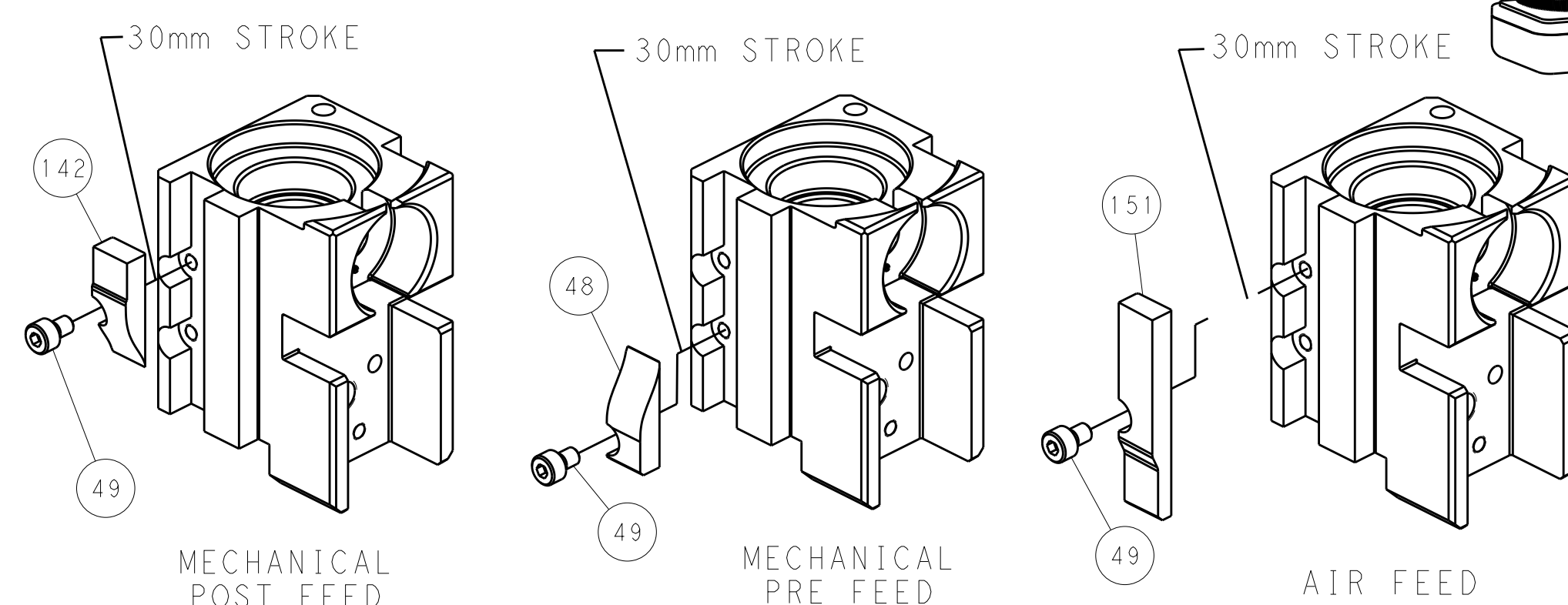


RAM SET-UP

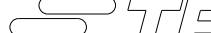
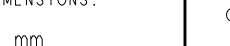


FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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

FILE OPENING IS A CONTROLLED DOCUMENT FOR ETCO-ESTERRECHES CORPORATION IT IS SUBJECT TO THE ETCO-ESTERRECHES CORPORATION'S CONTROL. ANY ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 03MAR2014 CHK HOFFNER TELBIN 04MAR2014 TELBIN 04MAR2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1 CASE CODE 00779 DRAWING NO C-2266233	
MATERIAL -		FINISH -		RESTRICTED TO -	
		WEIGHT -		SCALE 1:2 SHEET 4 OF 4 REV F	
Customer Accessible Production Drawing					