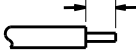


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266308-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266308-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266308-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266308-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266308-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE TERMINAL	
TERMINAL NAME: CONTACT,MOD IV CRIMP SNAP-IN			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.58-4.78 mm [.141-.188 IN]			Ø0.00-1.75 mm [.000-.069 IN]
TERMINAL APPLICATION 		114-25003	
SPECIFICATION		 	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
87523-2	141702-4	102680-1	167300-6
87523-4	141702-6	87309-2	167300-8
87523-5	141702-9	87309-3	1-167300-6
1-87523-5	1-141702-2	87309-8	166309-1
1-87523-8	1-141702-4	87309-9	166309-2
2-87523-3	2-141702-2	1-87309-2	166309-3
6-87523-8	2-141702-4	1-87195-7	166309-4
141600-2	141097-5	2-87195-0	166309-5
141600-6	141097-6	2-87195-3	167301-4
141600-8	141097-7	2-87195-4	1-167301-6
141760-3	141097-8	86492-2	2-167301-2
85969-2	85969-6	86492-4	2-167301-4

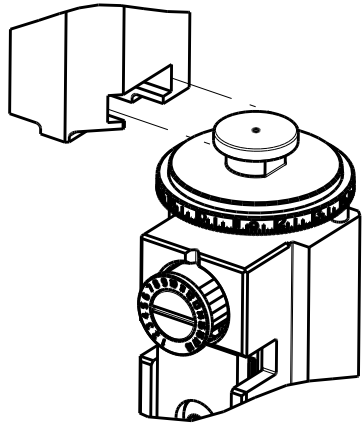
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.97+/-0.11 [.038+/- .004]	3.8
22 AWG	0.85+/-0.06 [.034+/- .002]	5.2
24 AWG	0.77+/-0.095 [.030+/- .004]	6.2
26 AWG	0.72+/-0.095 [.028+/- .004]	6.9



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 CRIMP DATA QUOTED IS SPECIFIC TO GERMAN MARKET.
- 7 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 TERMINATOR
INTERFACE ADAPTER



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	
		A		RELEASED	11JUL2014	GH	TE	
		B		ECR-17-015584	23OCT2017	KH	JDG	
		C		ECR-18-020110	28DEC2018	MEH	GB	
		D		ECR-19-004354	19MAR2019	FL	CT	

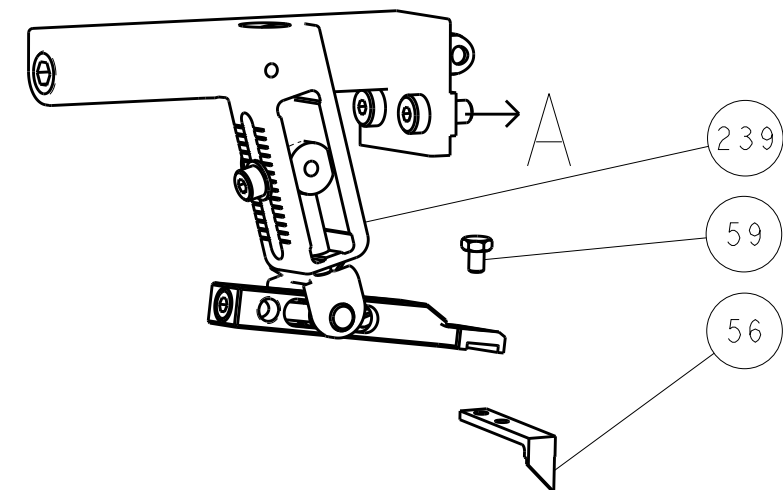
3	-	1	1	1	1	2280441-1	INSERT, SHEAR	282
	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	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
	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
7	-	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	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	4-240641-1	SPACER	81
	-	1	1	1	1	22278-7	SPRING, COMPRESSION	77
	-	1	1	1	1	854769-4	HOLDER, INS	74
	-	1	1	1	1	1803607-1	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	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	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	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	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-3	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
	-	3	3	3	3	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	1	690518-1	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	1	1-690691-3	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
	-	2	2	2	2	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
	1	2	2	1	1	7-1333225-4	ANVIL, COMBINATION	8
	-	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
	-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	1633966-6	CRIMPER, INSULATION O	3
1	-	1	1	1	1	455888-3	SPACER, CRIMPER	2
	1	2	2	1	1	7-568176-0	CRIMPER, WIRE	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm				CHK G. BAILEY 22MAY2014	NAME Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD T. ELBIN 22MAY2014	PRODUCT SPEC			
MATERIAL					APPLICATION SPEC			
					FINISH			
					WEIGHT			
					Customer Accessible Production Drawing			
					SCALE 1:2			
					SHEET 1 OF 4			
					REV D			

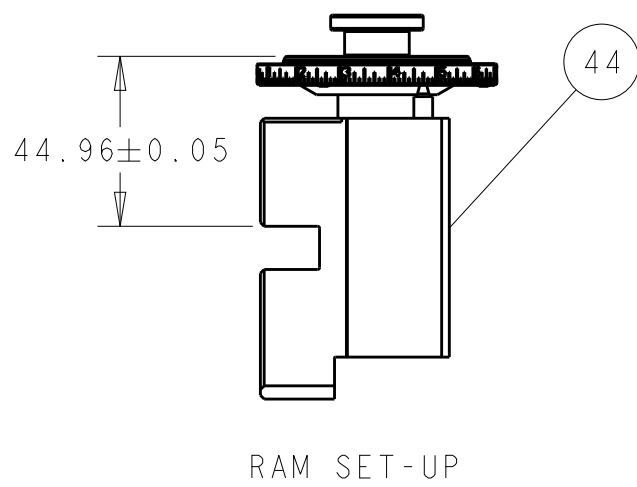
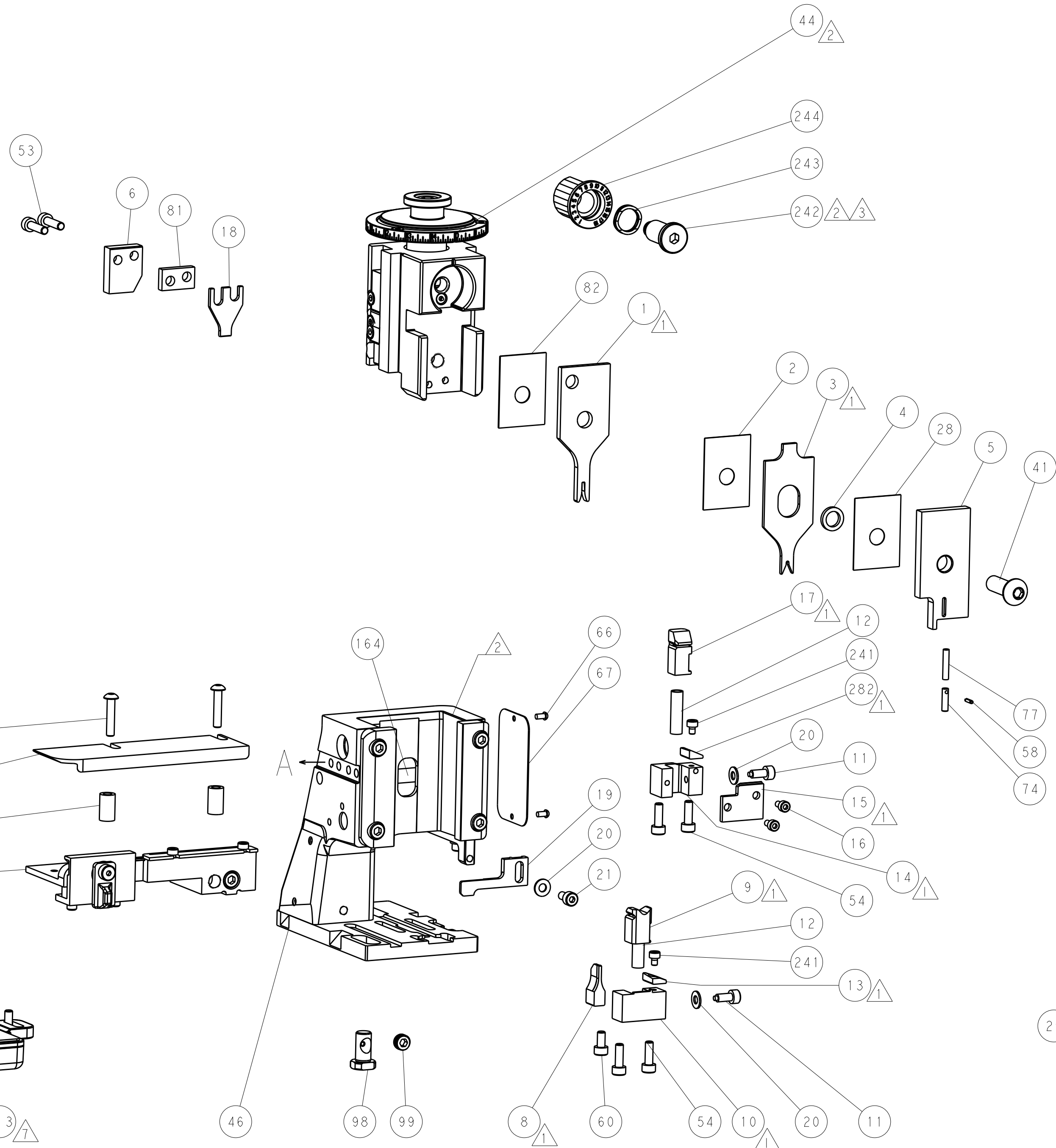
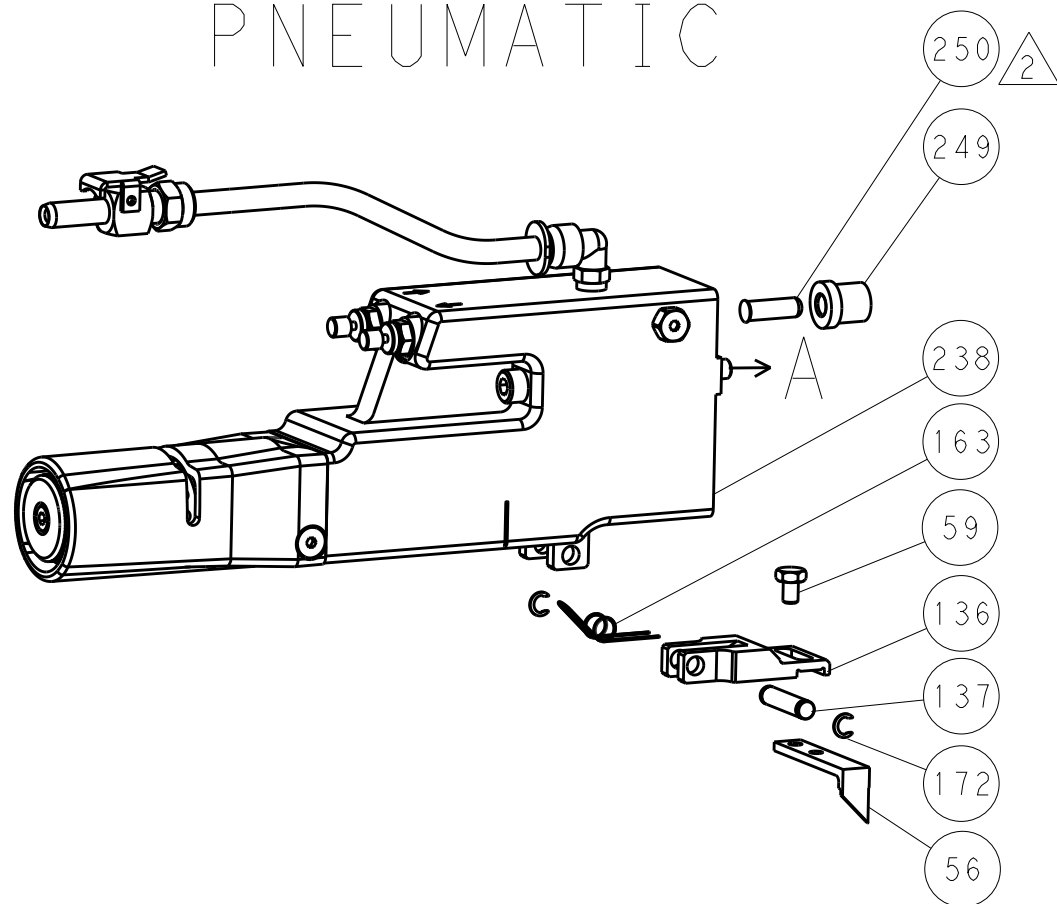
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

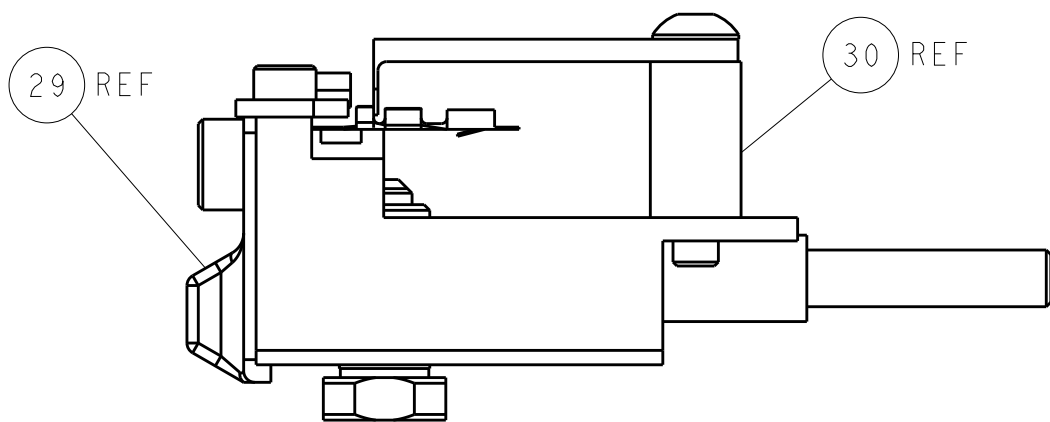
FEED TYPE
MECHANICAL



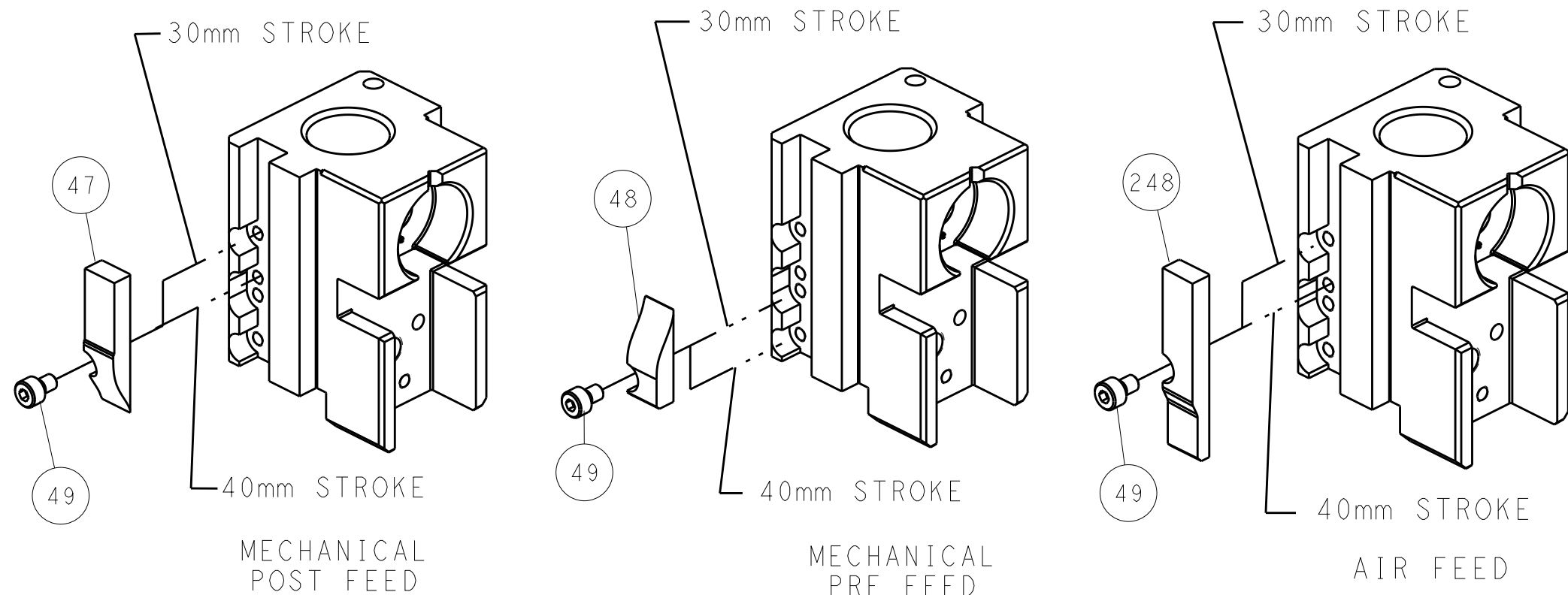
PNEUMATIC



ITEM 30 LOCATED AT
FRONT HOLES



CAM POSITIONS



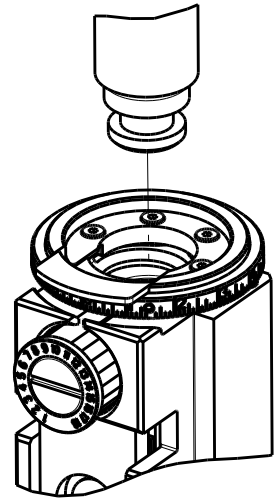
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.				OWN: K. STAKEM 21MAY2014 CHK: G. BAILEY 22MAY2014 APVD: T. ELBIN 22MAY2014				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME: Ocean Side Feed Applicator			
mm				0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±				SIZE: CAGE CODE: DRAWING NO: 00779 C=2266308			
MATERIAL: -				FINISH: -				RESTRICTED TO: -			
Customer Accessible Production Drawing				SCALE: 1:2				SHEET 2 OF 4 REV D			

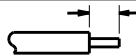
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266308-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266308-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266308-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE TERMINAL	
TERMINAL NAME: CONTACT,MOD IV CRIMP SNAP-IN			
WIRE STRIP LENGTH 3.58-4.78 mm [.141-.188 IN]			INSULATION DIAMETER RANGE Ø0.00-1.75 mm [.000-.069 IN]
TERMINAL APPLICATION SPECIFICATION	114-25003		-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
87523-2	141702-4	102680-1	167300-6
87523-4	141702-6	87309-2	167300-8
87523-5	141702-9	87309-3	1-167300-6
1-87523-5	1-141702-2	87309-8	166309-1
1-87523-8	1-141702-4	87309-9	166309-2
2-87523-3	2-141702-2	1-87309-2	166309-3
6-87523-8	2-141702-4	1-87195-7	166309-4
141600-2	141097-5	2-87195-0	166309-5
141600-6	141097-6	2-87195-3	167301-4
141600-8	141097-7	2-87195-4	1-167301-6
141760-3	141097-8	86492-2	2-167301-2
85969-2	85969-6	86492-4	2-167301-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.97+/-0.11 [.038+/- .004]	3.8
22 AWG	0.85+/-0.06 [.034+/- .002]	5.2
24 AWG	0.77+/-0.095 [.030+/- .004]	6.2
26 AWG	0.72+/-0.095 [.028+/- .004]	6.9



- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- CRIMP DATA QUOTED IS SPECIFIC TO GERMAN MARKET.
- 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	LTR	DESCRIPTION	DATE
		-		SEE SHEET 1	-

-	1	1	2280441-1	INSERT, SHEAR	282
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	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
-	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	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	455888-5	SPACER, CRIMPER	82
-	1	1	4-240641-1	SPACER	81
-	1	1	22278-7	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	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	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
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	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
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	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
-	3	3	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	690518-1	HOLD DOWN, TERMINAL	18
-	1	1	690463-1	FLOATING SHEAR, REAR	17
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1-690691-3	PLATE,REAR SHEAR	15
-	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	3-22280-3	SPRING, COMPRESSION	12
-	2	2	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	7-1333225-4	ANVIL, COMBINATION	8
-	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
-	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1633966-6	CRIMPER, INSULATION O	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	7-568176-0	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
OWN			21MAY2014	 TE Connectivity Harrisburg, PA 17105-3608	
CHK			22MAY2014		
G. BAILEY					
APVD			22MAY2014		
T. ELBIN				NAME	
DIMENSIONS:				Ocean Side Feed Applicator	
mm				-	
0 PLC			±	SIZE	
1 PLC			±	CASE CODE	
2 PLC			±	DRAWING NO	
3 PLC			±	RESTRICTED TO	
4 PLC			±	-	
ANGLES			±	-	
FINISH			±	-	
MATERIAL			-	-	
Customer Accessible Production Drawing			SCALE	1:2	SHEET 3 OF 4
			REV	D	

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

D

C

B

A

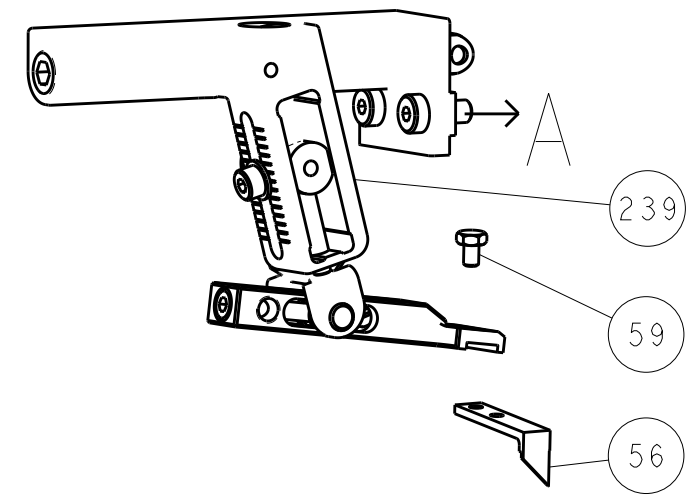
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C

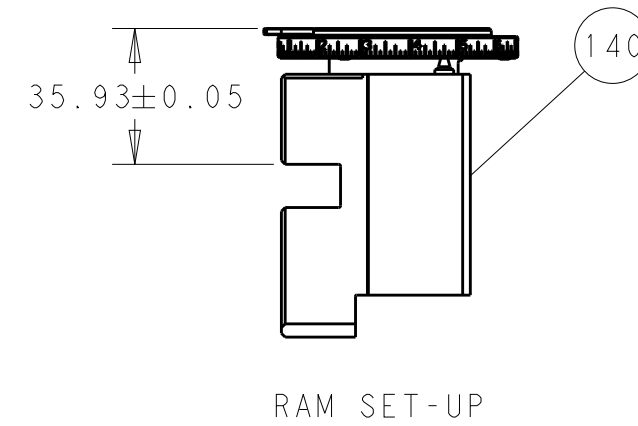
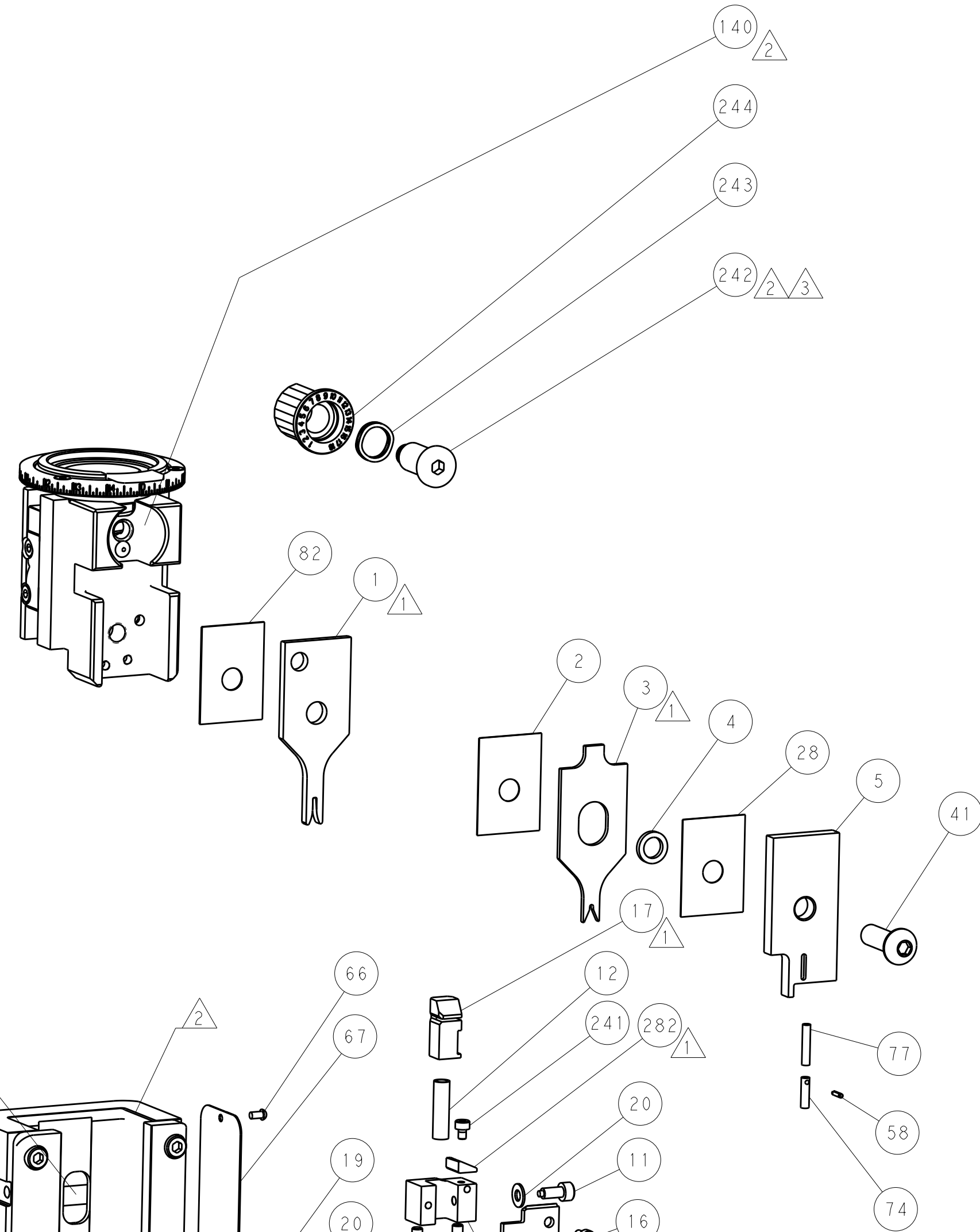
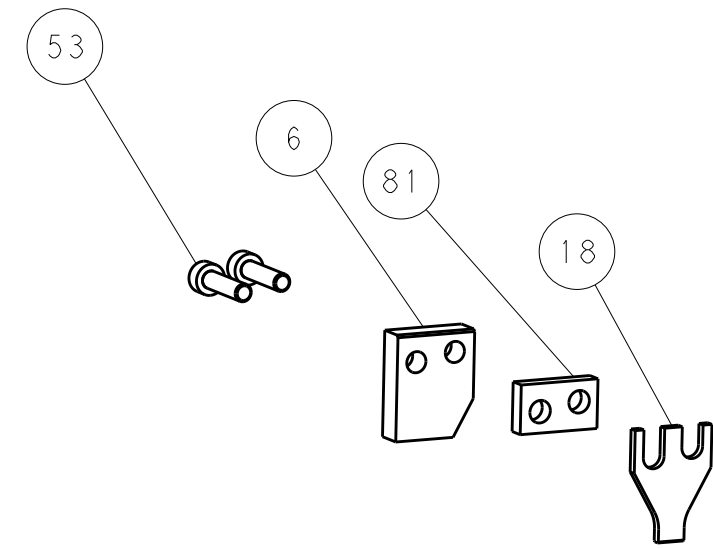
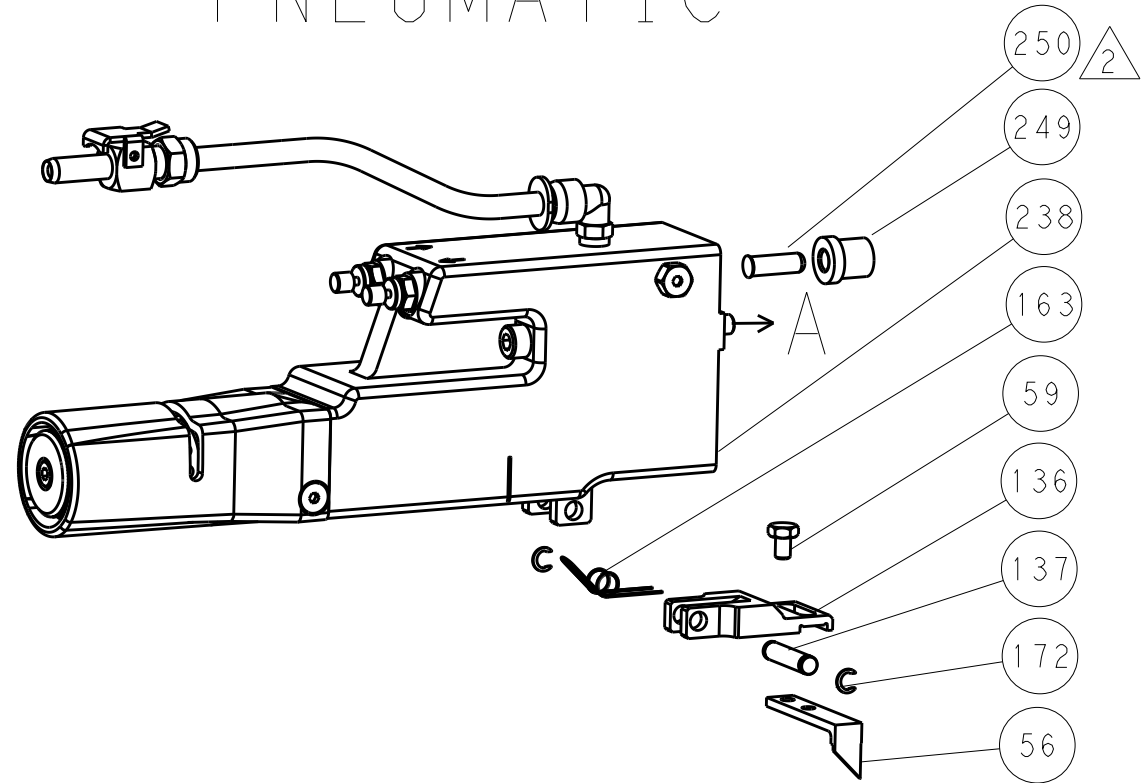
B

A

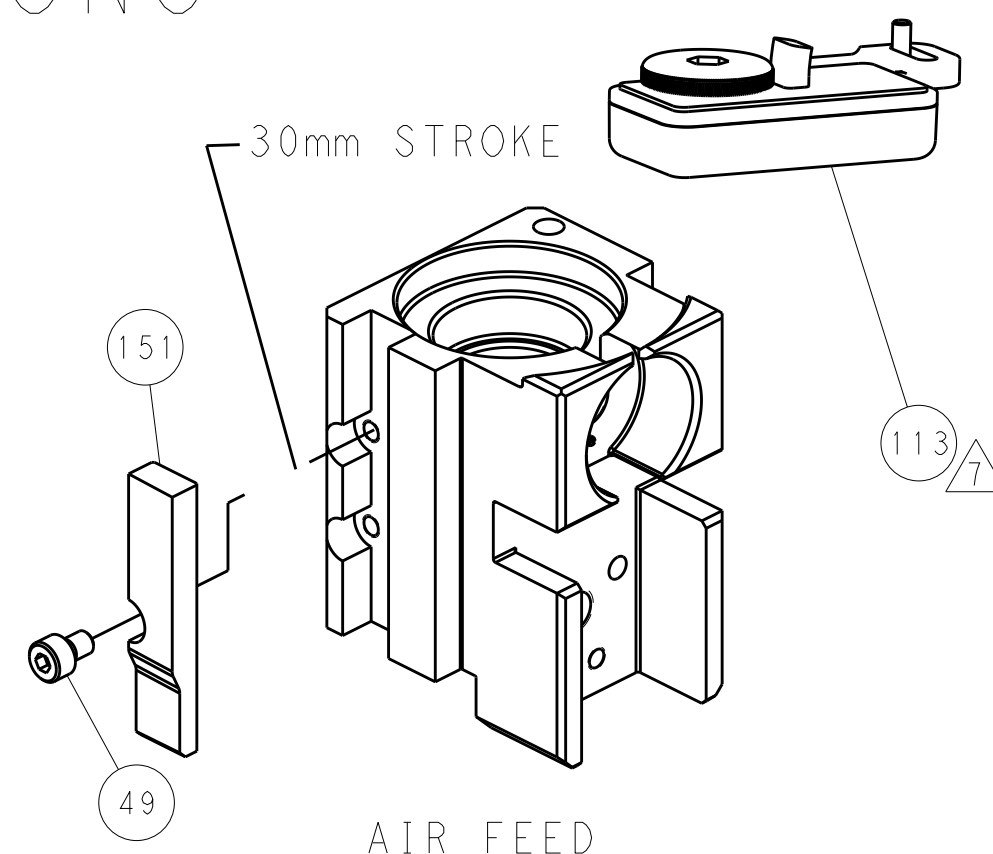
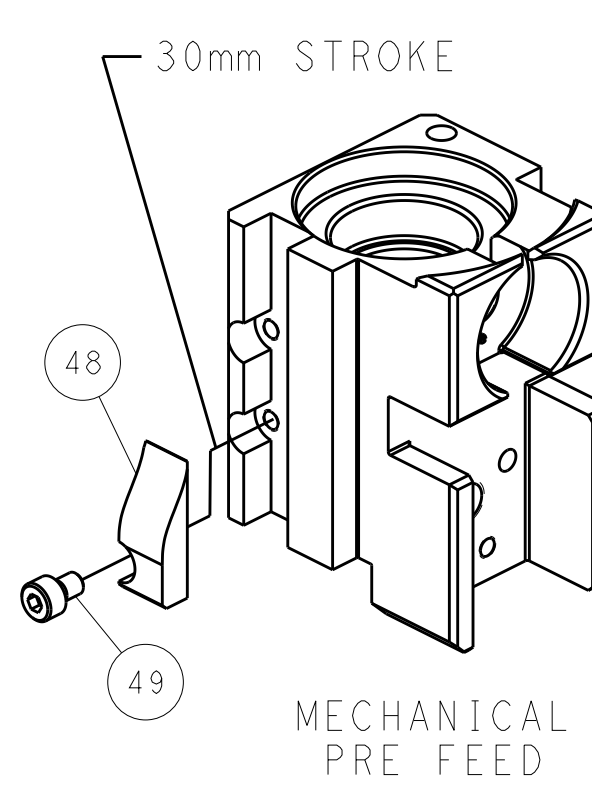
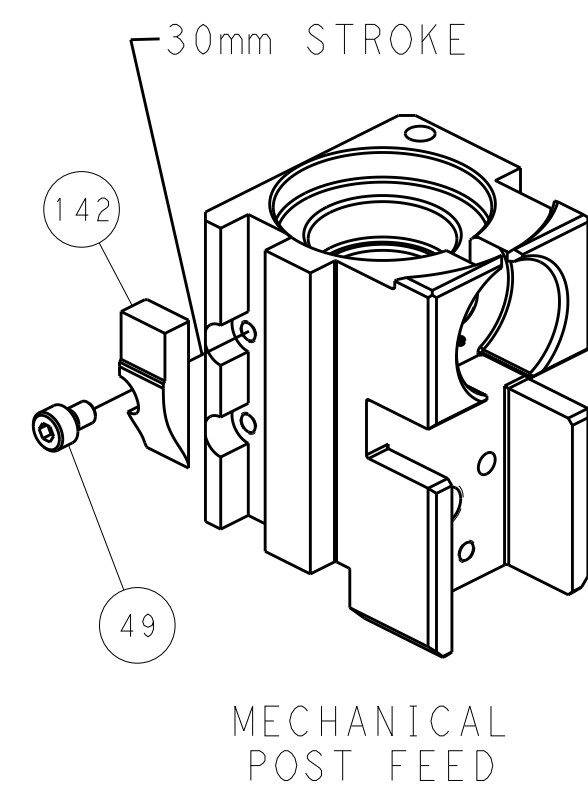
FEED TYPE MECHANICAL



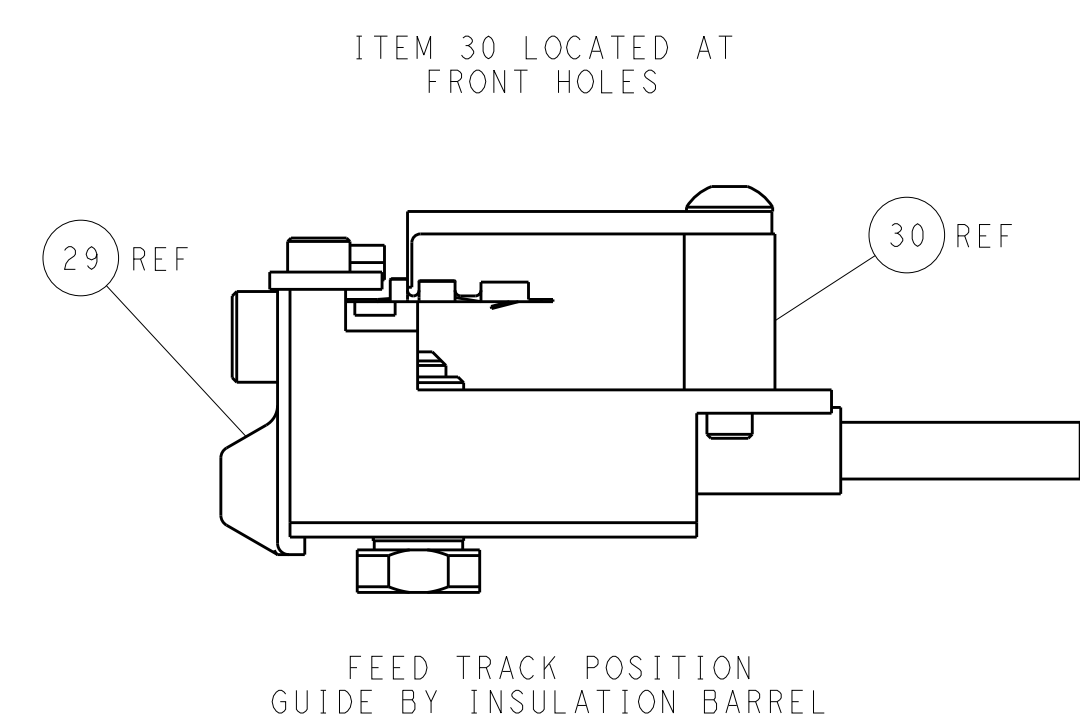
PNEUMATIC



CAM POSITIONS



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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CHK G. BAILEY 22MAY2014		NAME T. ELBIN 22MAY2014	Ocean Side Feed Applicator	
DIMENSIONS: mm		PRODUCT SPEC	SIZE A1	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0005 1 PLC ±.0005 2 PLC ±.0005 3 PLC ±.0005 4 PLC ±.0005 ANGLES ±.0005 FINISH		APPLICATION SPEC	CAGE CODE 00779	
MATERIAL -		WEIGHT -	Customer Accessible Production Drawing	
		SCALE 1:2	SHEET 4 OF 4	
		REV D		