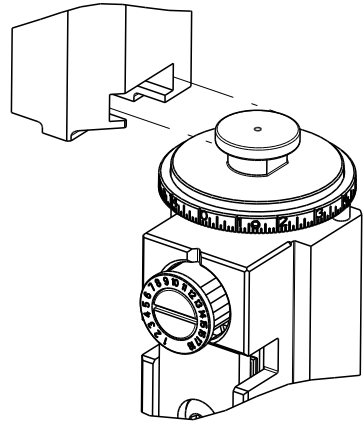


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266323-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266323-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266323-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266323-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266323-7	G	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.58 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA:		TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME:		CONTACT, RECEPACLE, CRIMP SNAP-IN 20-24 AWG	
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.18-3.96 mm [.125-.156 IN]		Ø 0.64-1.52 mm [.025-.060 IN]	
TERMINAL APPLICATION SPECIFICATION		114-25038	-
TERMINALS APPLIED		△9	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
104479-2	104479-4	104479-9	
104479-3	104479-8	1-104479-0	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89+/-0.05 [.035+/- .002]	3.0
22 AWG	0.79+/-0.05 [.031+/- .002]	4.3
24 AWG	0.69+/-0.05 [.027+/- .002]	5.3



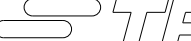
- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- △ CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- △ TERMINAL LUBRICANT IS RECOMMENDED.
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.

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
			E	ECR-18-013790	30AUG2018	MZ
			F	ECR-18-016277	13OCT2018	TB
			G	ECR-19-003478	05MAR2019	FZ
			H	ECR-20-004201	19MAR2020	TB

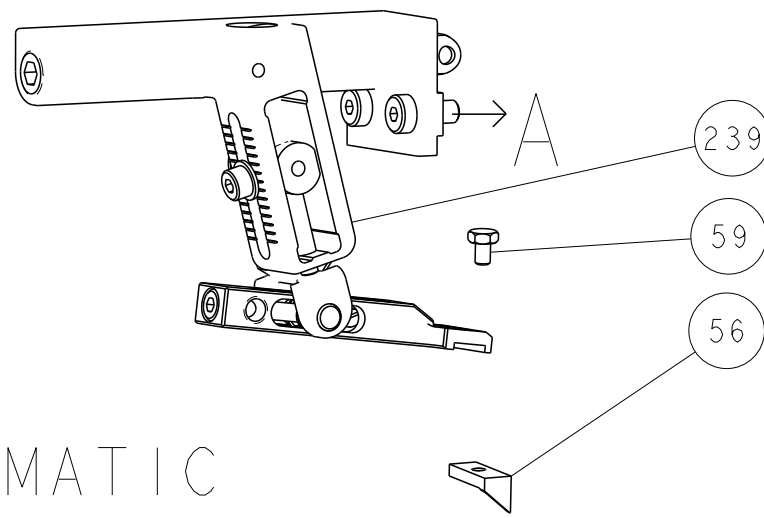
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	2	2	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	1	1	1	1	356885-4	STOP, SHEAR	237
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
5	-	1	1	1	1	2119955-5	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	690438-1	FRONT STRIP GUIDE	96
	-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-5	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
	-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	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	1338683-1	FEED PAWL	56
	-	6	6	6	6	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	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	2280441-1	INSERT, SHEAR	43
	-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	33
	-	1	1	1	1	2305692-9	PLATE, REAR STRIP GUIDE	29
	-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1	1	3-189124-6	GUIDE, FRONT STRIP	24
	-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	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	2119533-3	STRIPPER, SIDE FEED	19
	-	1	1	1	1	3-1463053-0	HOLDER, 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	1-690691-0	PLATE,REAR SHEAR	15
	-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT -	9
1	1	2	2	1	1	3-1333201-6	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	1	1	1	1	1-690468-8	DEPRESSOR SHEAR, REAR	6
	-	1	1	1	1	2119757-2	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1633966-6	CRIMPER, INSULATION O	3
	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	2	2	1	1	2-1803125-5	CRIMPER, WIRE	1

- 77 - 72 - 71 - 2 - 1		PART NO		DESCRIPTION		ITEM NO
THIS IS A CONTROLLED DOCUMENT FOR TFCO ELECTRONICS CORPORATION FOR CONTROLLED DOCUMENTS, SEE THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		OWN	10JUN2014		TE Connectivity	Harrisburg, PA 17105-3608
		CHK	10JUN2014			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		G.BAILEY	10JUN2014	NAME	Ocean Side Feed	Applicator
		APVD	10JUN2014			
mm		D. STOUGH	PRODUCT SPEC	SIZE	CAGE CODE	DRAWING NO
0 PLC ±		APPLICATION SPEC	WEIGHT			
1 PLC ±		FINISH	RESTRICTED TO	SCALE	SHEET	OF
2 PLC ±		Customer Accessible Production Drawing	REV			
3 PLC ±		SCALE	1:2	REV	H	H
4 PLC ±		SHEET	1	OF	4	REV
ANGLES		FINISH	RESTRICTED TO	SCALE	SHEET	OF
FINISH		RESTRICTED TO	SCALE	SHEET	OF	REV
REV		RESTRICTED TO	SCALE	SHEET	OF	REV

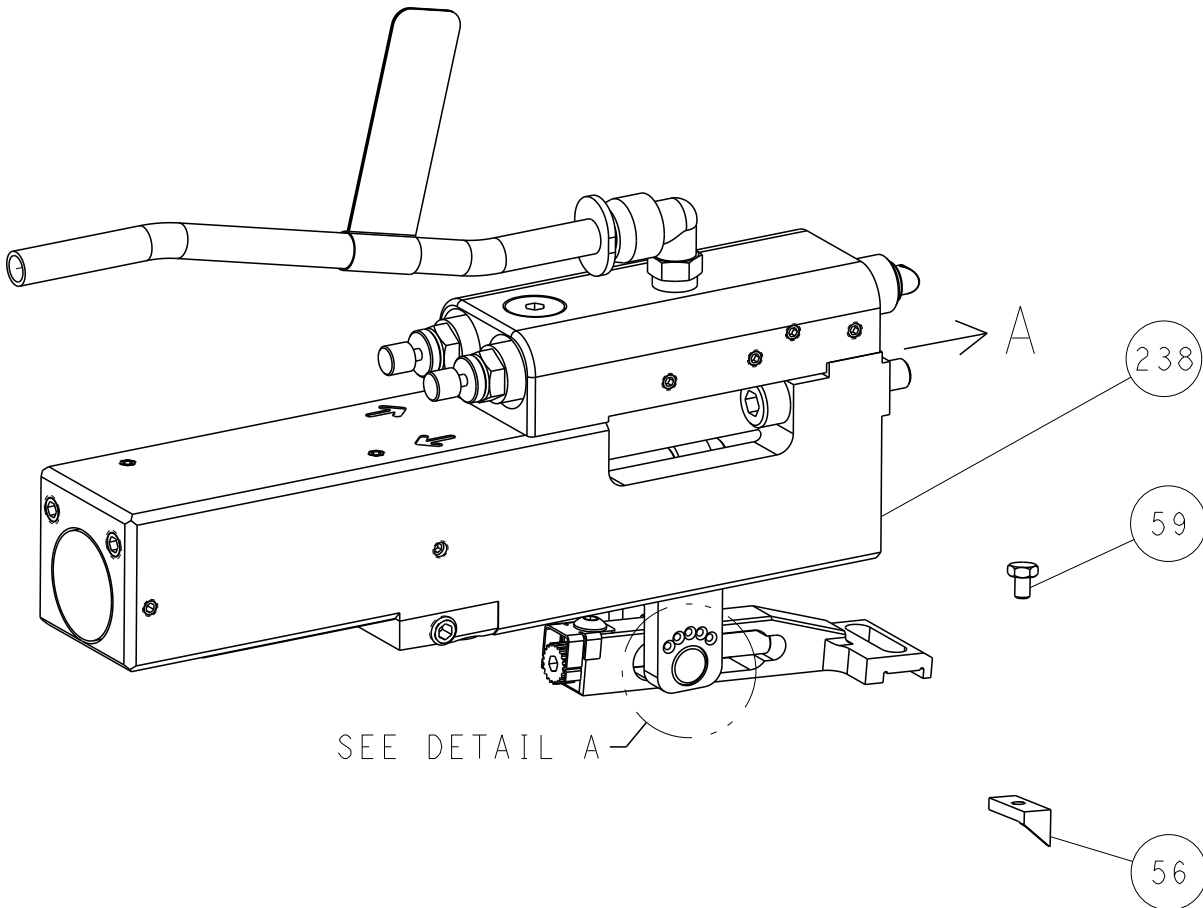
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

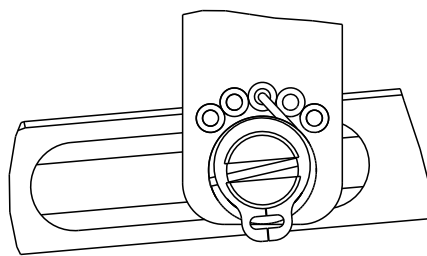
FEED TYPE
MECHANICAL



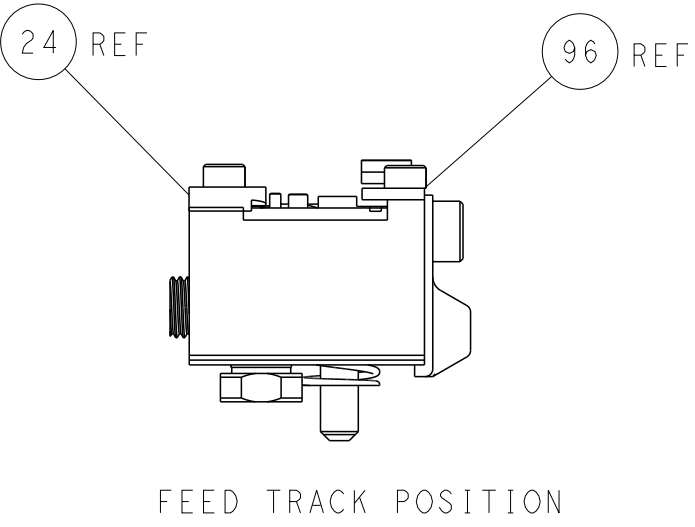
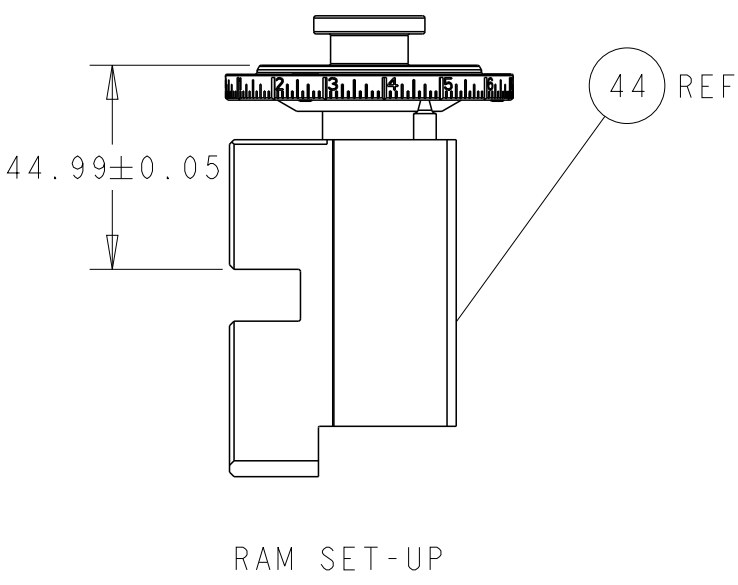
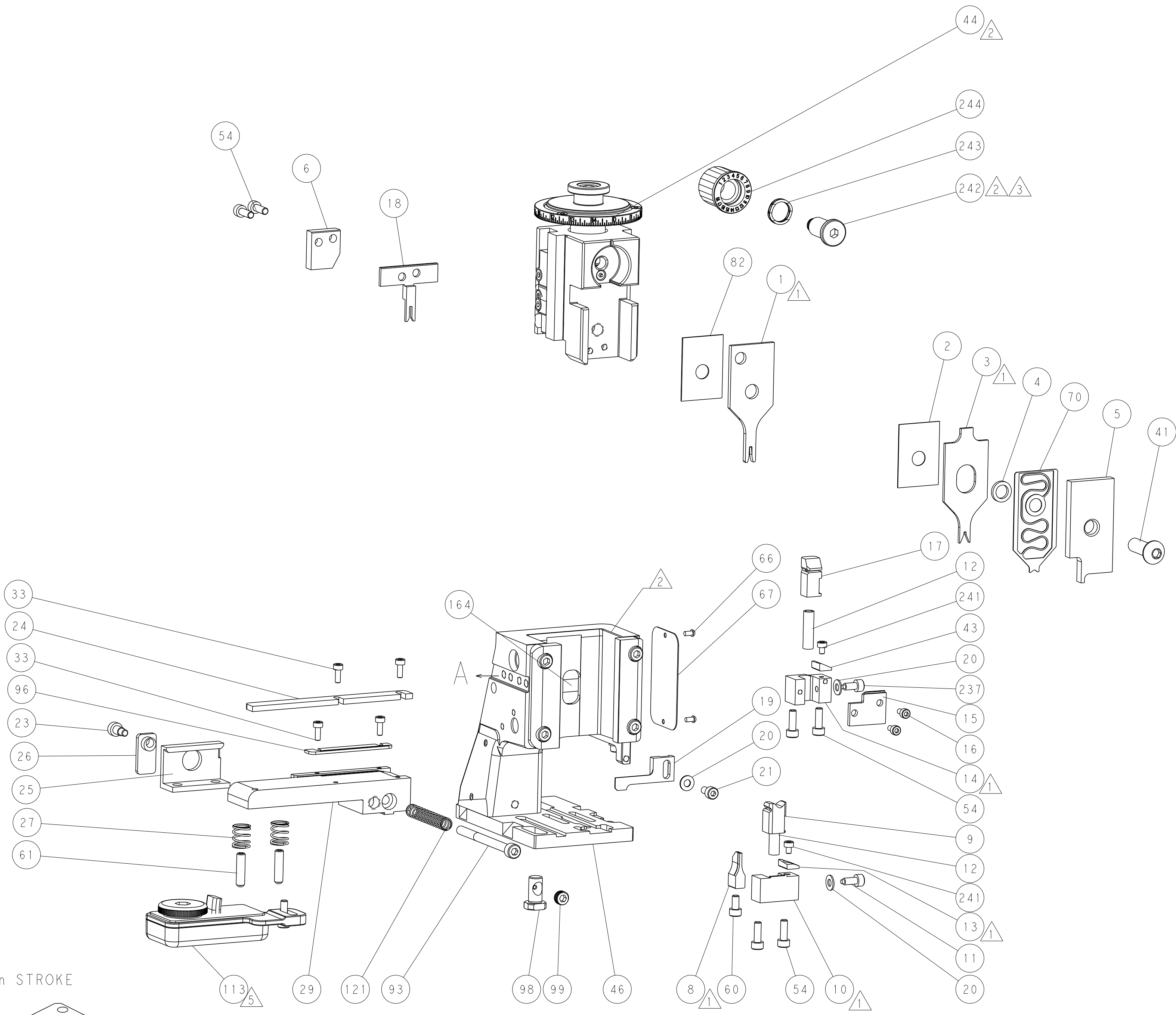
PNEUMATIC



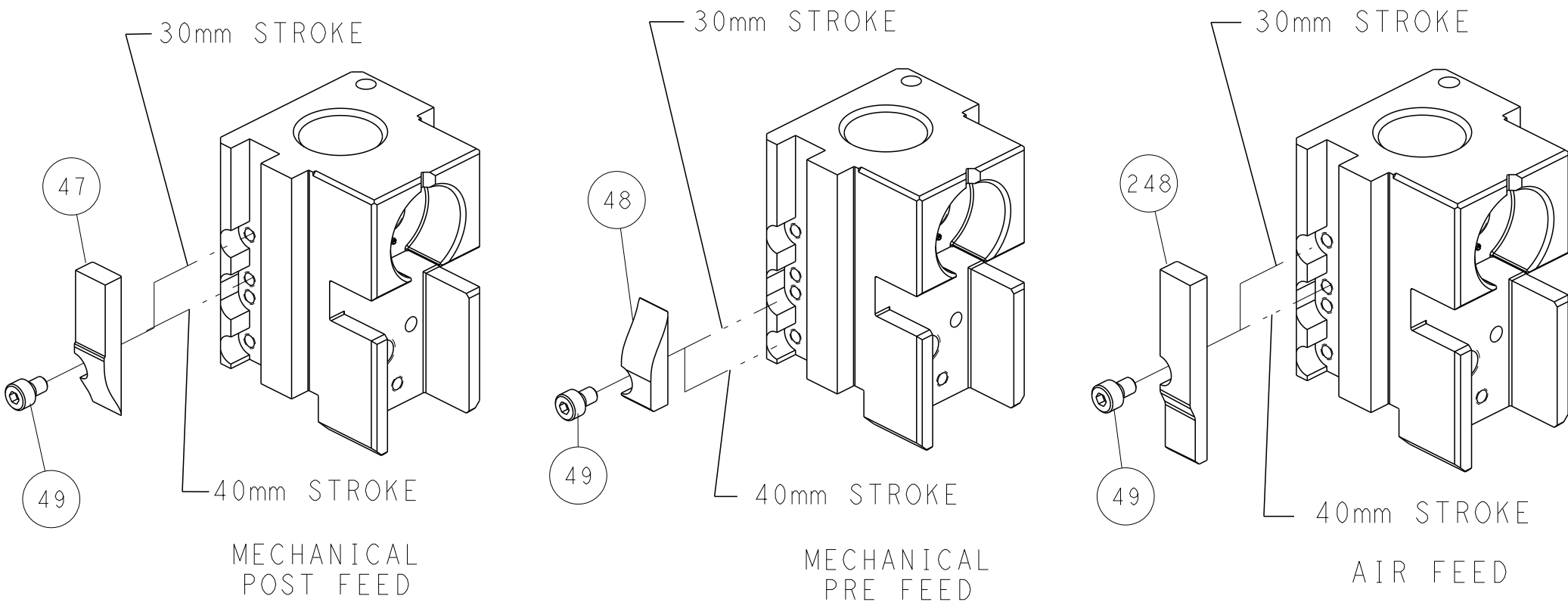
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A



CAM POSITIONS

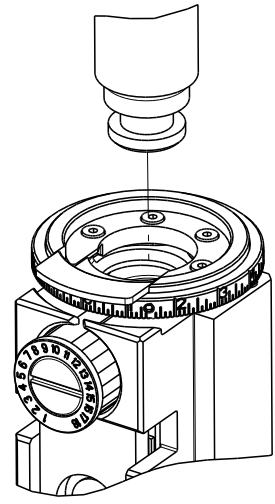


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		DWN: BOB HIGMAN 10JUN2014	TE Connectivity Harrisburg, PA 17105-3608	
CHK: G. BAILEY 10JUN2014		NAME: D. STOUGH 10JUN2014	Ocean Side Feed Applicator	
PRODUCT SPEC		APPLICATION SPEC	SIZE: A1	RESTRICTED TO: -
MATERIAL: -		WEIGHT: -	CAGE CODE: 00779	REV: H
Customer Accessible Production Drawing		SCALE: 1:2	SHEET: 2 of 4	REV: H

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
2-2266323-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266323-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266323-7	G	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.58 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA:		TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME:		CONTACT, RECEPACLE, CRIMP SNAP-IN 20-24 AWG	
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.18-3.96 mm [.125-.156 IN]		Ø 0.64-1.52 mm [.025-.060 IN]	
TERMINAL APPLICATION SPECIFICATION		114-25038	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
104479-2	104479-4	104479-9	
104479-3	104479-8	1-104479-0	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89+/-0.05 [.035+/- .002]	3.0
22 AWG	0.79+/-0.05 [.031+/- .002]	4.3
24 AWG	0.69+/-0.05 [.027+/- .002]	5.3



- 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 LUBRICANT IS RECOMMENDED.
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.

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				
		P	LTR	DESCRIPTION	DATE	DWN
A	66	-	-	SEE SHEET 1	-	-

-	1	1	2119082-5	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	-	2844940-1	AIR FEED MODULE	238
-	1	1	356885-4	STOP, SHEAR	237
-	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2119955-5	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	690438-1	FRONT STRIP GUIDE	96
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-1	FEED PAWL	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	2280441-1	INSERT, SHEAR	43
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	33
-	1	1	2305692-9	PLATE, REAR STRIP GUIDE	29
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	3-189124-6	GUIDE, FRONT STRIP	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	3-1463053-0	HOLDER, 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	1-690691-0	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
-	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	1-1333201-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	1	1	1-690468-8	DEPRESSOR SHEAR, REAR	6
-	1	1	2119757-2	DEPRESSOR, SHEAR	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1633966-6	CRIMPER, INSULATION O	3
-	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	2-1803125-5	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
THIS DRAWING IS A CONTROLLED DOCUMENT AND THE IDENTIFICATION INFORMATION IT IS SUBJECT TO COMPANY'S DOCUMENT CONTROL AND IDENTIFICATION ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.			DWN BOB HIGMAN CHK G.BAILEY APVD D. STOUGH	10JUN2014 10JUN2014 10JUN2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS:			NAME		
mm			Ocean Side Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED:			SIZE		
0 PLC ±.005			CAGE CODE		
1 PLC ±.005			DRAWING NO		
2 PLC ±.005			RESTRICTED TO		
3 PLC ±.005			100779		
4 PLC ±.005			©=2266323		
ANGLES			Customer Accessible Production Drawing		
FINISH			SCALE		
-			1:2		
-			SHEET 3 OF 4		
-			REV H		

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

D

C

B

A

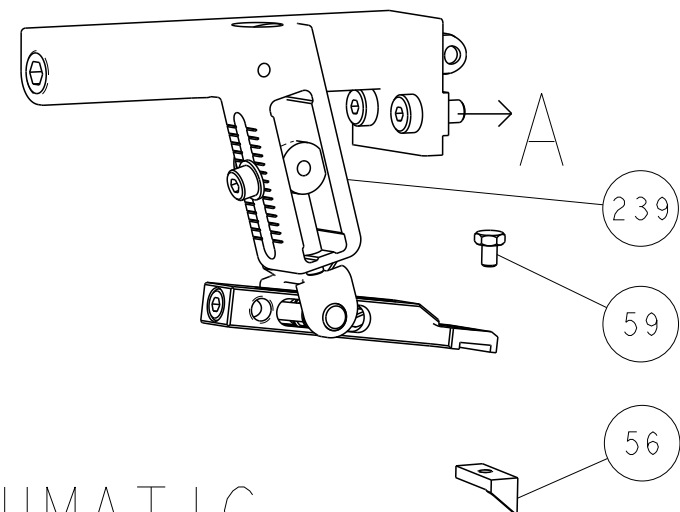
D

C

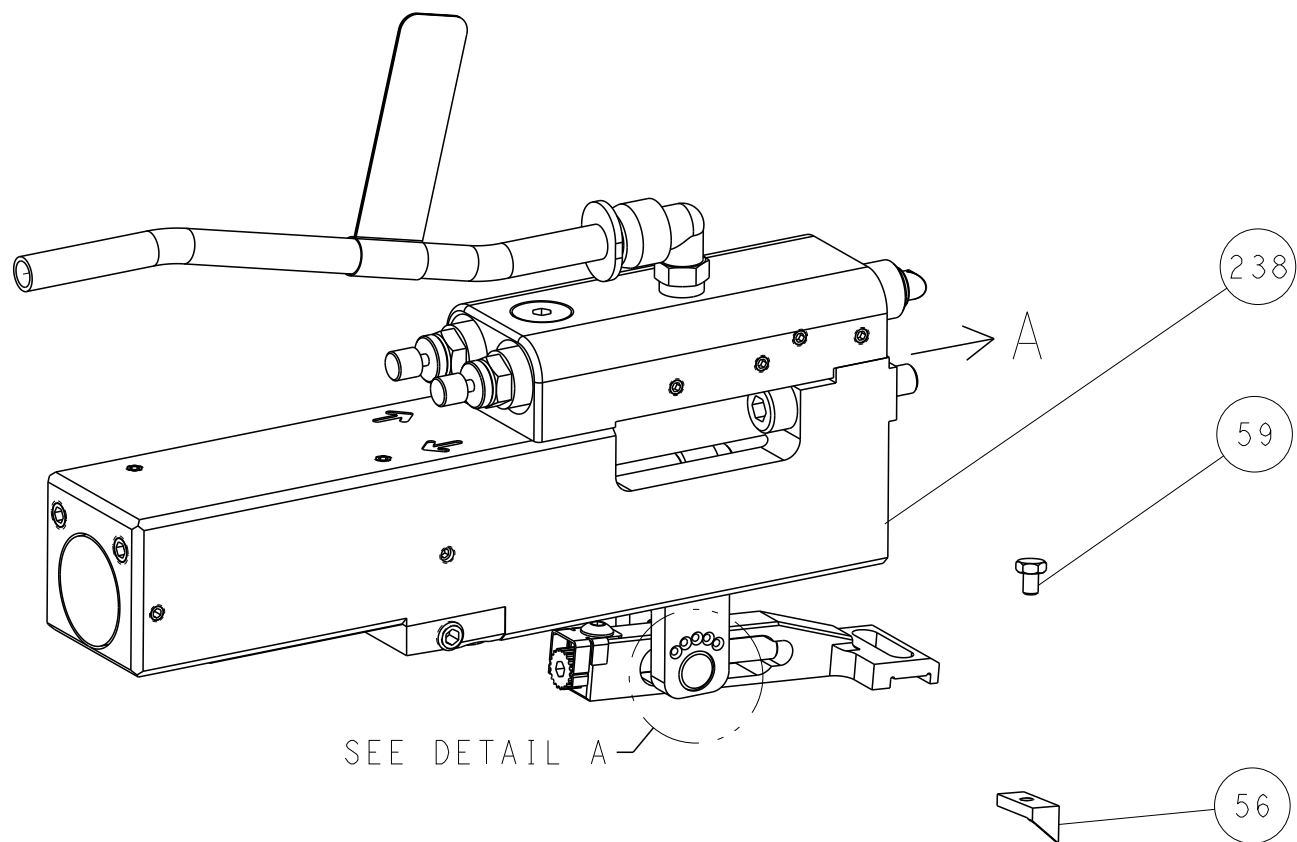
B

A

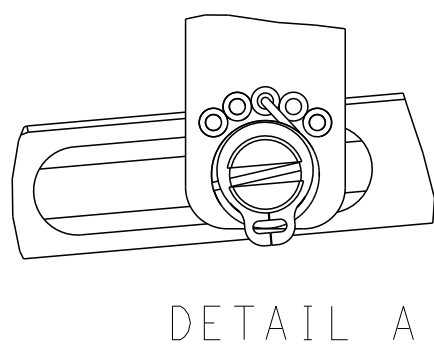
FEED TYPE MECHANICAL



PNEUMATIC

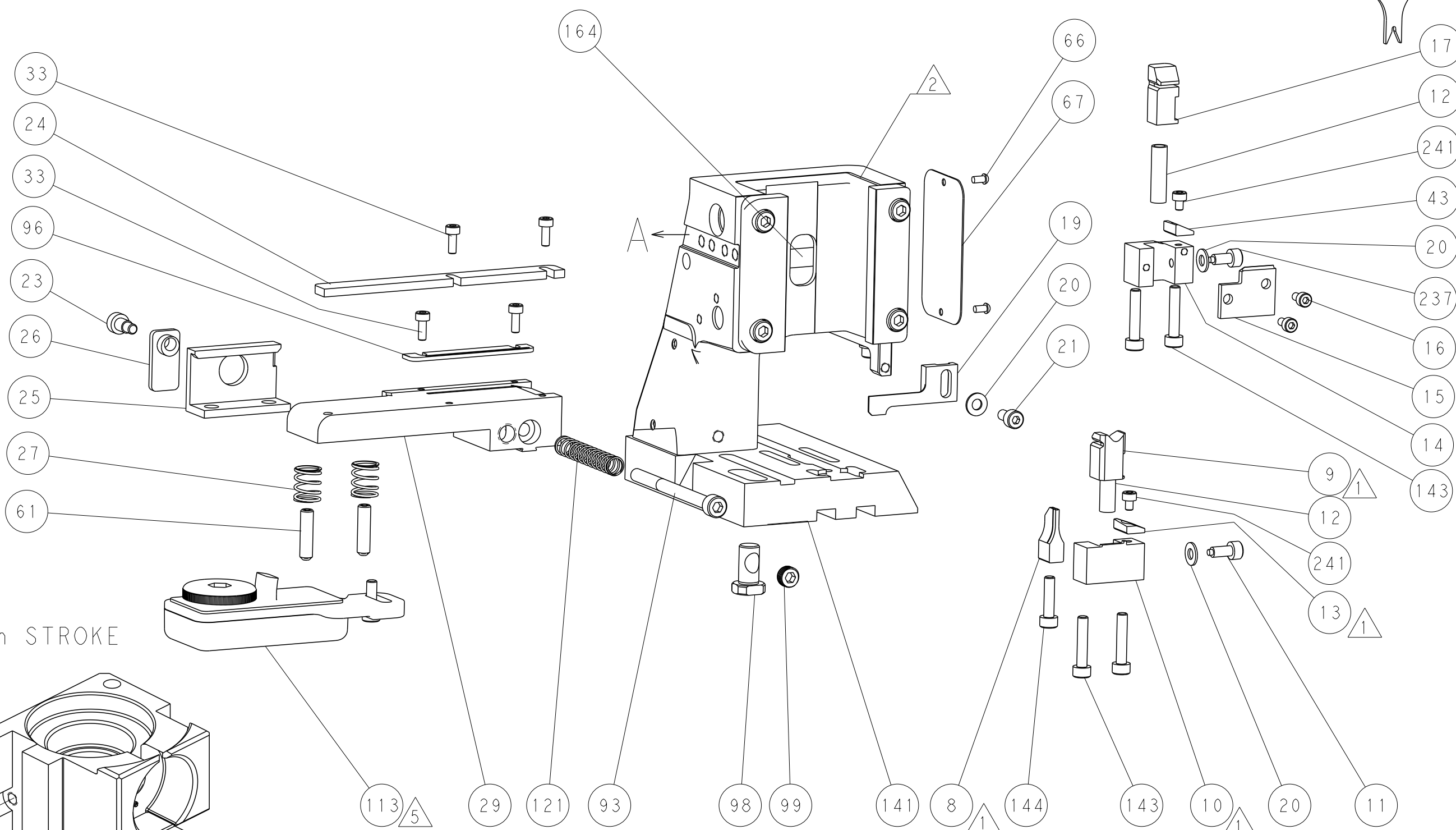
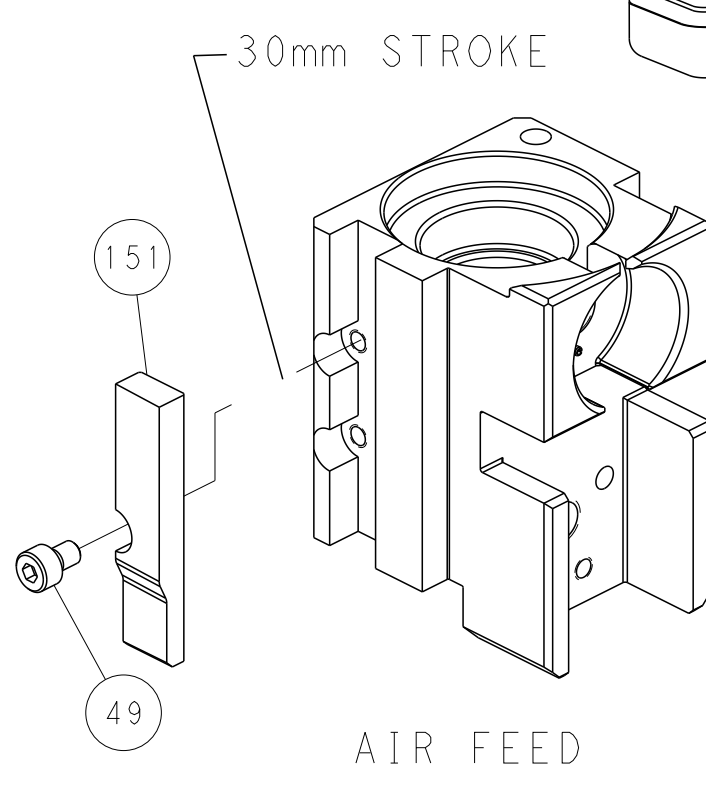
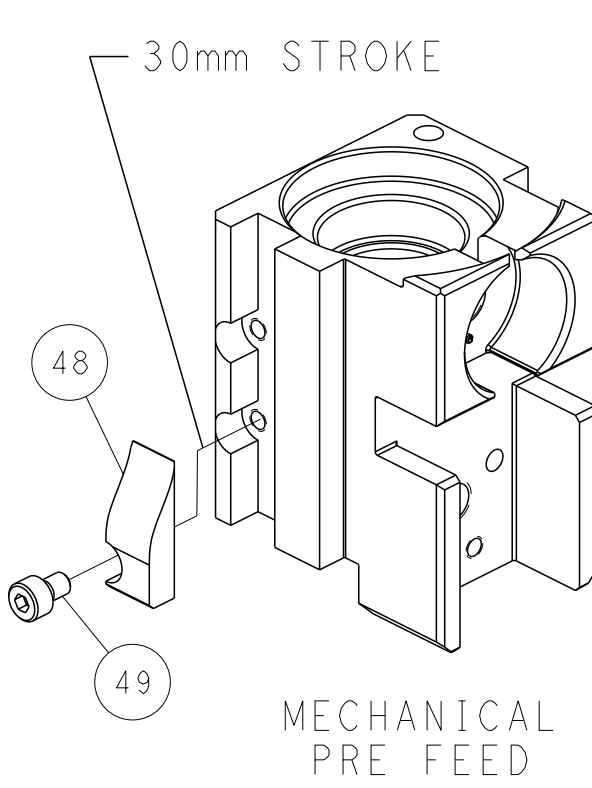
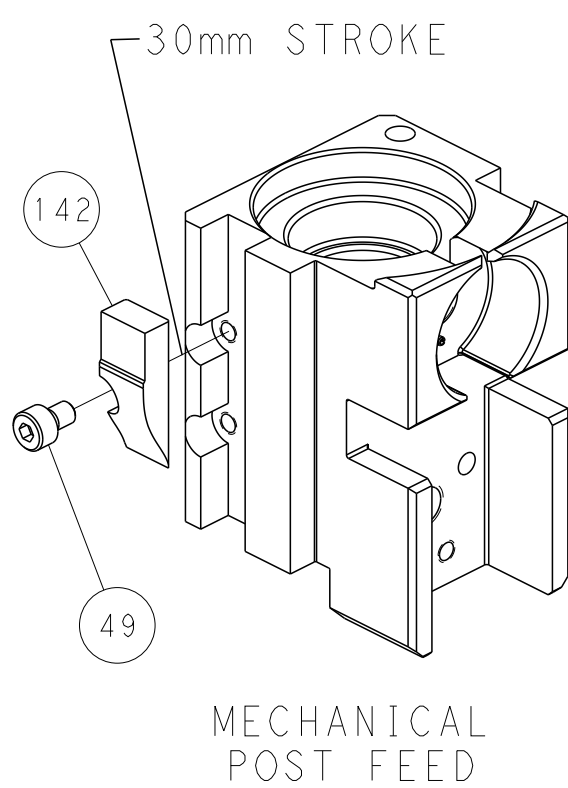


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

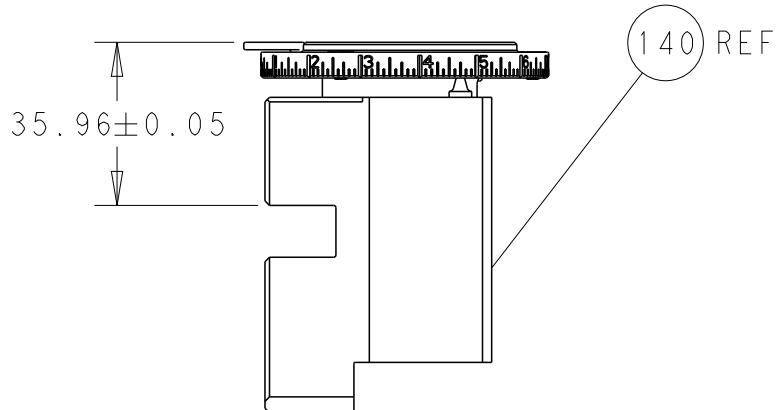


DETAIL A

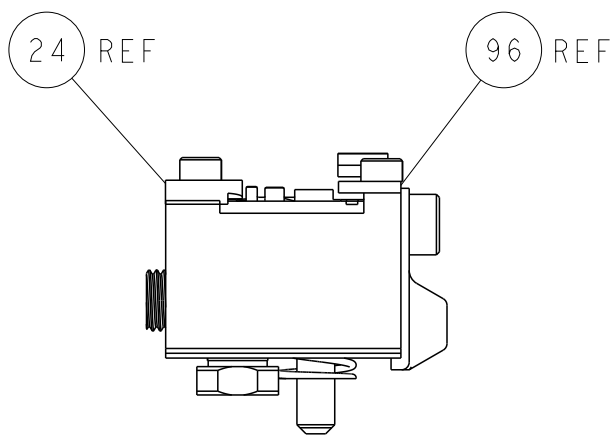
CAM POSITIONS



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



RAM SET-UP



FEED TRACK POSITION

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		DWN: BOB HIGMAN 10JUN2014		 TE Connectivity Harrisburg, PA 17105-3608				
		CHK: G. BAILEY 10JUN2014						
DIMENSIONS: mm		APVD: D. STOUGH 10JUN2014		NAME				
		PRODUCT SPEC		Ocean Side Feed Applicator				
		APPLICATION SPEC						
		SIZE				CAGE CODE	DRAWING NO	RESTRICTED TO
		WEIGHT						
MATERIAL		A 00779		C=2266323				
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV H				