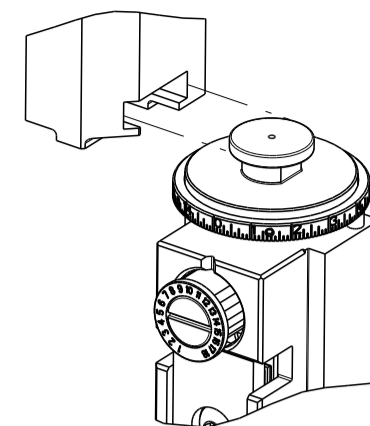


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266315-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266315-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266315-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.59 mm [.220]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING & SPADE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.98-5.36 mm [.196-.211 IN]		∅2.03-2.92 mm [.080-.115 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61867-2	61863-2	61857-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.41+/-0.05 [.095+/-0.002]	8.9
1.50 mm <sup>2</sup>	2.26+/-0.05 [.089+/-0.002]	10.5
16 AWG	2.24+/-0.05 [.088+/-0.002]	10.7
1.0 mm <sup>2</sup>	2.17+/-0.05 [.085+/-0.002]	11.4
18 AWG	2.13+/-0.05 [.084+/-0.002]	11.7



- 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 FEED FOR TERMINAL 61867 & 61863 IS 23.11 [.910 IN]. FEED FOR TERMINAL 61857 IS 17.98 [.708 IN]. FEED ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.
  - 7 TERMINAL LUBRICANT IS RECOMMENDED.
8. 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	LTN	DESCRIPTION	DATE	OWN	APVD
		E		ECR-19-009764	22JUN2019	TB	TE
		F		ECR-20-004335	25MAR2020	JWC	RK
		G		ECR-23-178259	12JUN2023	JWC	GB
		G1		ECR-23-183866	10AUG2023	JWC	TE

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1633782-4	FENCE	267	
-	1	1	1803078-4	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2844940-2	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
7	-	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	1-455888-0	SPACER, CRIMPER	82	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1803096-1	EXTENSION PLATE	78	
-	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	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	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	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	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1803583-9	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	
-	1	1	1752356-1	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-5	SPACER, CRIMPER	28	
-	1	1	1320928-4	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	
7	-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
7	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
7	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
7	1	2	1	1633137-7	ANVIL, COMBINATION .140	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5	
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
7	1	2	1	4-1803016-1	CRIMPER, INSULATION F	3
7	-	1	1	1-455888-0	SPACER, CRIMPER	2
7	1	2	1	2-456411-2	CRIMPER, WIRE PREMIUM	1

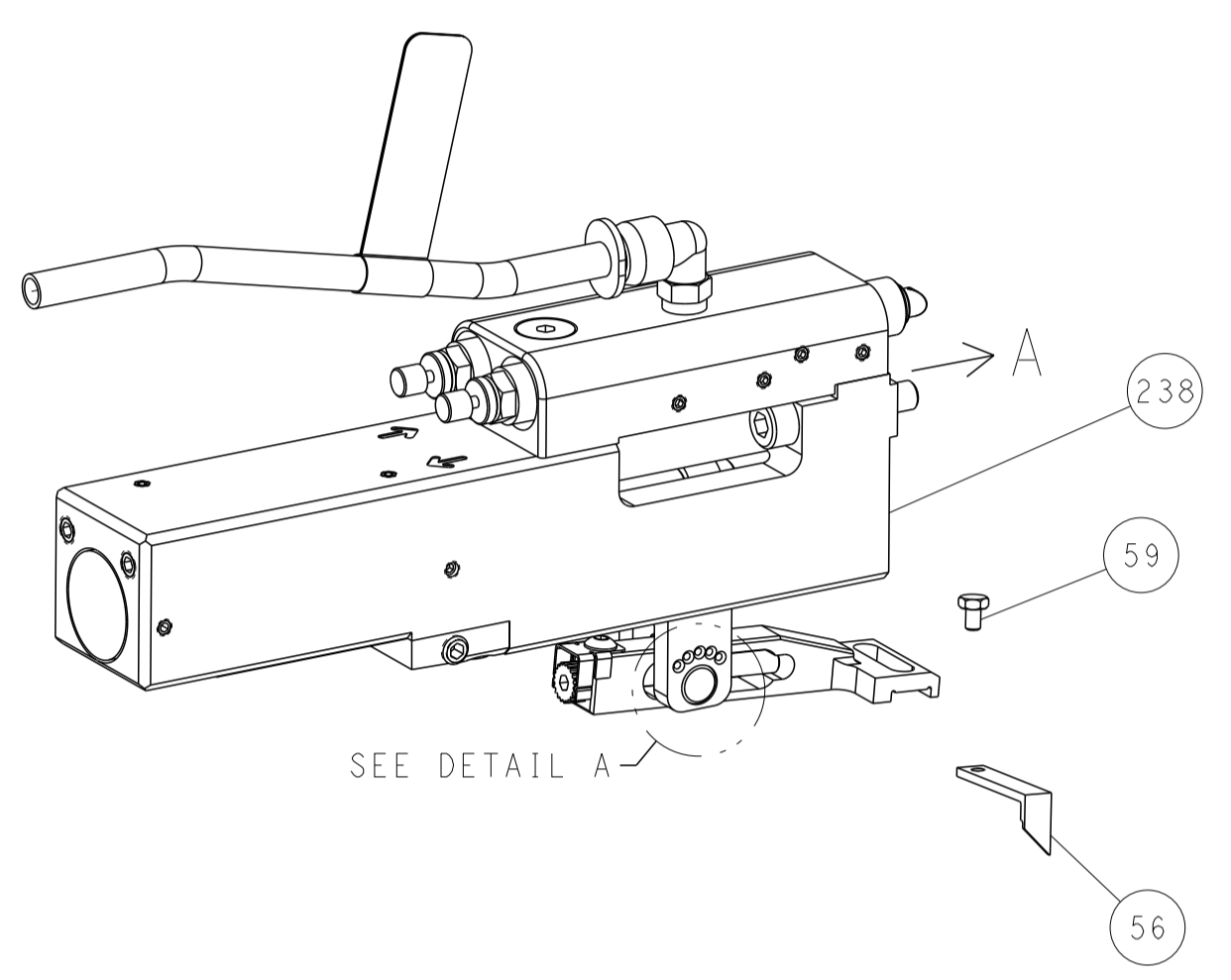
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

OWN	H. HUANG	03JUN2014	CHK	L. ZHANG	03JUN2014	APVD	J. GUO	03JUN2014	
PRODUCT SPEC	-								
APPLICATION SPEC	-								
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO			-			
A1	00779	2266315	-			-			
Customer Accessible Production Drawing		SCALE	1:2	SHEET	1	OF	4	REV	G1

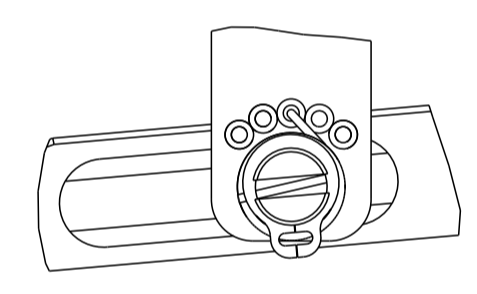
LOC	DIST	REV	DATE	BY	APPD
A	66				

# FEED TYPE

## PNEUMATIC

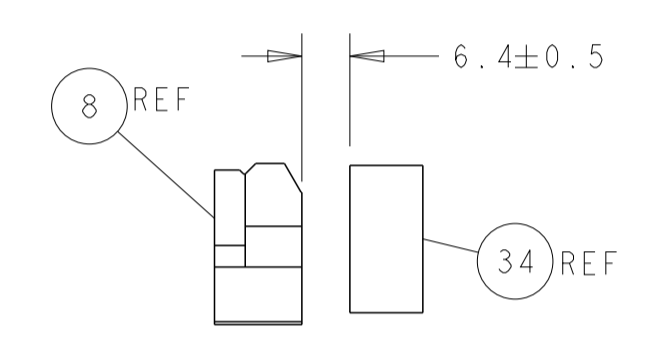
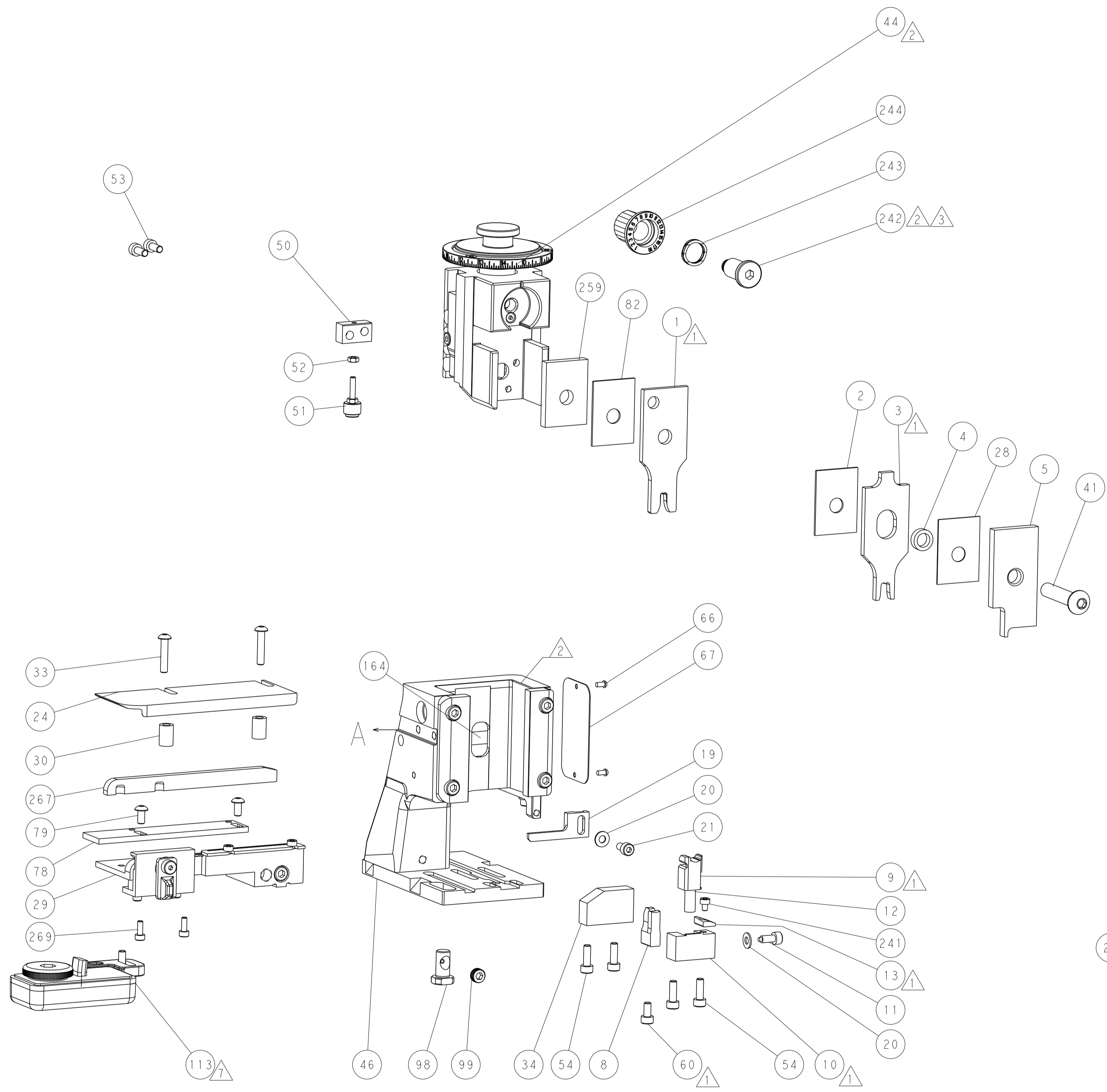
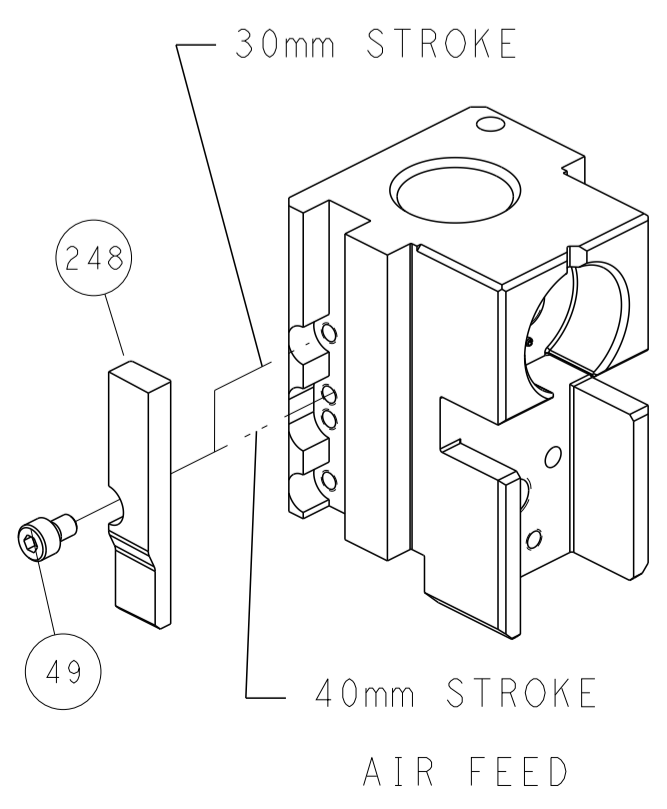


SEE DETAIL A  
 FEED SPRING SETTING POSITION  
 (SHOWN FROM REAR SIDE)

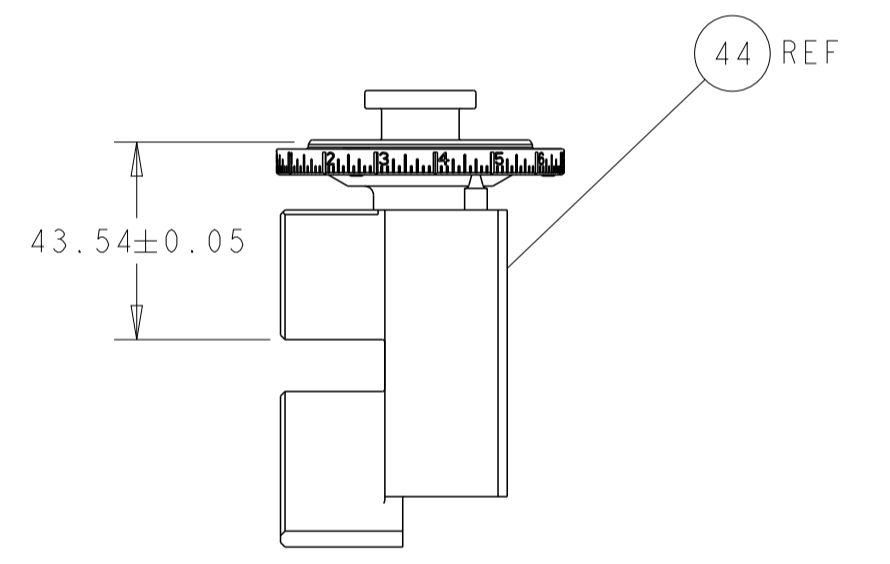


DETAIL A

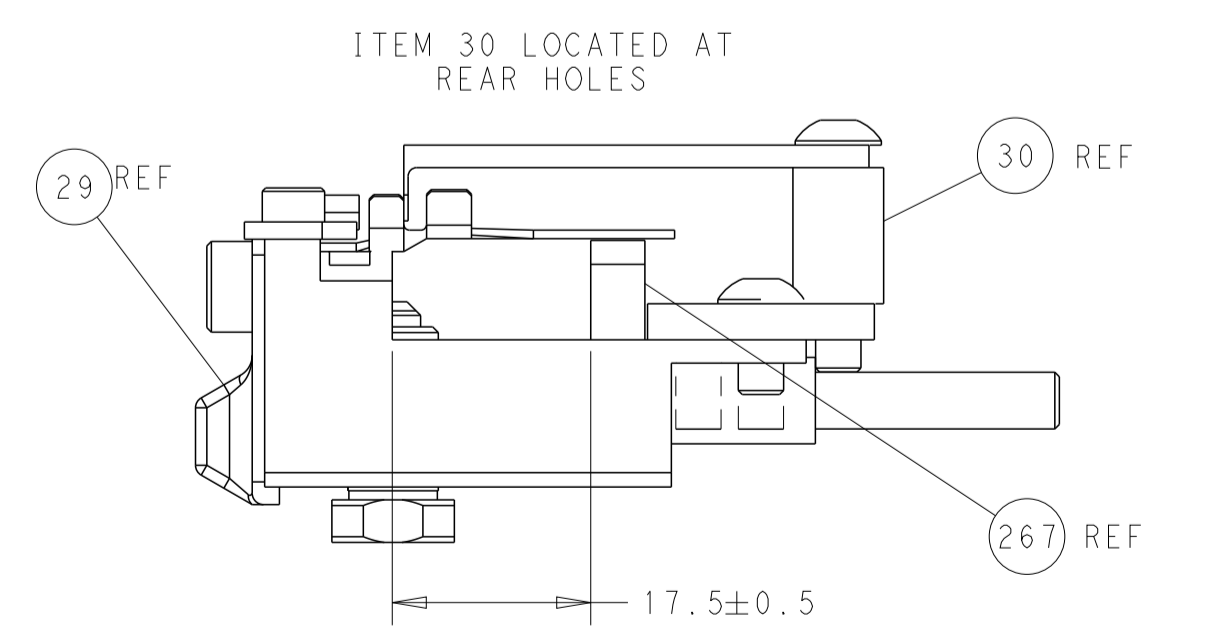
## CAM POSITION



TERMINAL SUPPORT LOCATION



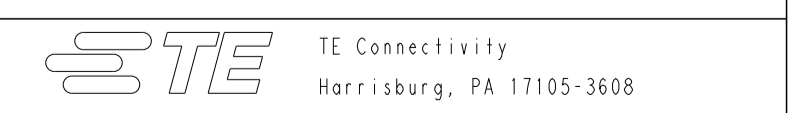
RAM SET-UP



FEED TRACK POSITION  
 GUIDE BY INSULATION BARREL

**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:		REVISIONS	
mm	0 PLC	±		DATE	BY
	1 PLC	±		03JUN2014	H. HUANG
	2 PLC	±		03JUN2014	L. ZHANG
	3 PLC	±			
	4 PLC	±			
	ANGLES	±			
	FINISH	±			
MATERIAL:		FINISH:		WEIGHT:	APVD:
					U. GUO
				Customer Accessible Production Drawing	



NAME: Ocean Side Feed Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266315

SCALE: 1:2 SHEET 2 OF 4 REV: G1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266315-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266315-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.59 mm [.220]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RING & SPADE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.98-5.36 mm [1.96-.211 IN]	∅2.03-2.92 mm [.080-.115 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINAL	TERMINAL	TERMINAL	TERMINAL
61867-2	61863-2	61857-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.41+/-0.05 [0.095+/-0.002]	8.9
1.50 mm <sup>2</sup>	2.26+/-0.05 [0.089+/-0.002]	10.5
16 AWG	2.24+/-0.05 [0.088+/-0.002]	10.7
1.0 mm <sup>2</sup>	2.17+/-0.05 [0.085+/-0.002]	11.4
18 AWG	2.13+/-0.05 [0.084+/-0.002]	11.7

\*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.

- 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 FEED FOR TERMINAL 61867 & 61863 IS 23.11 [.910 IN]. FEED FOR TERMINAL 61857 IS 17.98 [.708 IN]. FEED ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.
  - 7 TERMINAL LUBRICANT IS RECOMMENDED.
8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REV	DATE	BY	APPD
A	66	-			

REV	DATE	DESCRIPTION	DATE	BY	APPD
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		269
-	1	1633782-4	FENCE		267
-	1	1803078-4	SPACER, PRECISION		259
-	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
3	-	2119083-1	RETAINER, INSULATION DIAL		242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	1	2844940-2	AIR FEED MODULE		238
-	REF	994970-2	COUNTER, MAGNETIC		164
-	1	2119641-2	FEED CAM, AIR FEED		151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		143
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC		140
7	-	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	2844908-1	SCREW, LOCKING		99
-	1	2844907-1	POST, LOCKING		98
-	1	1-455888-0	SPACER, CRIMPER		82
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)		79
-	1	1803096-1	EXTENSION PLATE		78
-	1	1803607-3	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
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3		52
-	1	811242-5	BUMPER, HOLD DOWN		51
-	1	690753-2	SPACER, TONKER		50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)		41
-	1	1752356-1	SUPPORT, TERMINAL		34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	2844992-1	ASSEMBLY, STRIP GUIDE		29
-	1	455888-5	SPACER, CRIMPER		28
-	1	1320928-4	STRIP GUIDE		24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	2	1-18028-2	WASHER, FLAT, REG M4		20
-	1	2119533-1	STRIPPER, SIDE FEED		19
1	-	2119806-1	INSERT, SHEAR		13
-	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1-356885-4	STOP, SHEAR		11
1	-	2119805-1	SHEAR HOLDER, FRONT		10
1	-	318707-1	FLOATING SHEAR, FRONT		9
1	1	1633137-7	ANVIL, COMBINATION .140		8
-	-	-	-		7
-	-	-	-		6
-	1	1-2119757-0	DEPRESSOR, SHEAR		5
-	1	4-238011-5	BLOCK, CRIMPER SPACER		4
1	1	4-1803016-1	CRIMPER, INSULATION F		3
-	1	1-455888-0	SPACER, CRIMPER		2
1	1	2-456411-2	CRIMPER, WIRE PREMIUM		1

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

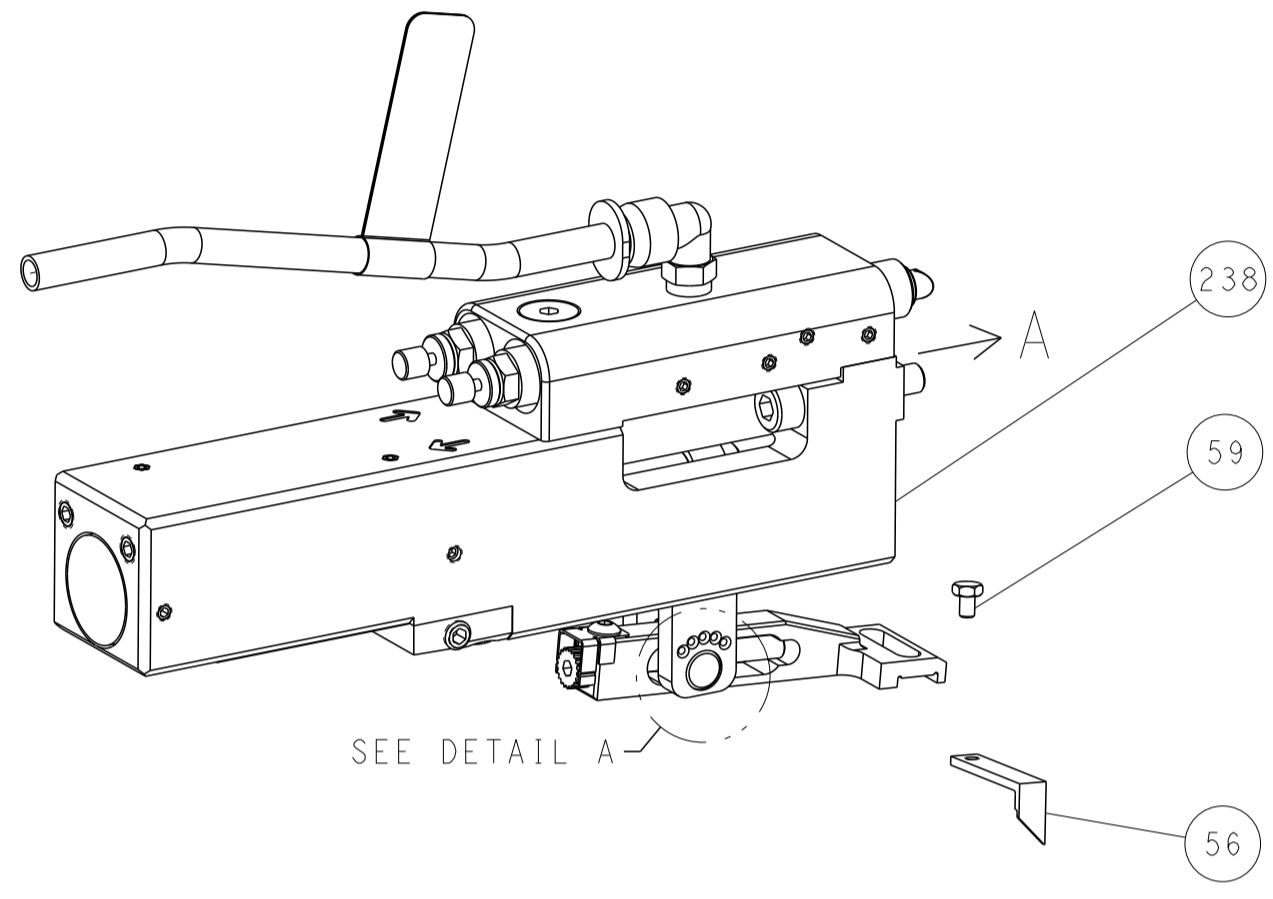
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 03JUN2014		CHK: L. ZHANG 03JUN2014		APVD: J. GUO 03JUN2014		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		CAGE CODE		DRAWING NO		RESTRICTED TO	
						00779		2266315		SCALE: 1:2 SHEET 3 OF 4 REV: G1	

Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APPD
A	66				

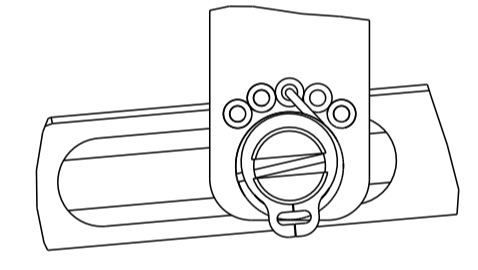
# FEED TYPE

## PNEUMATIC



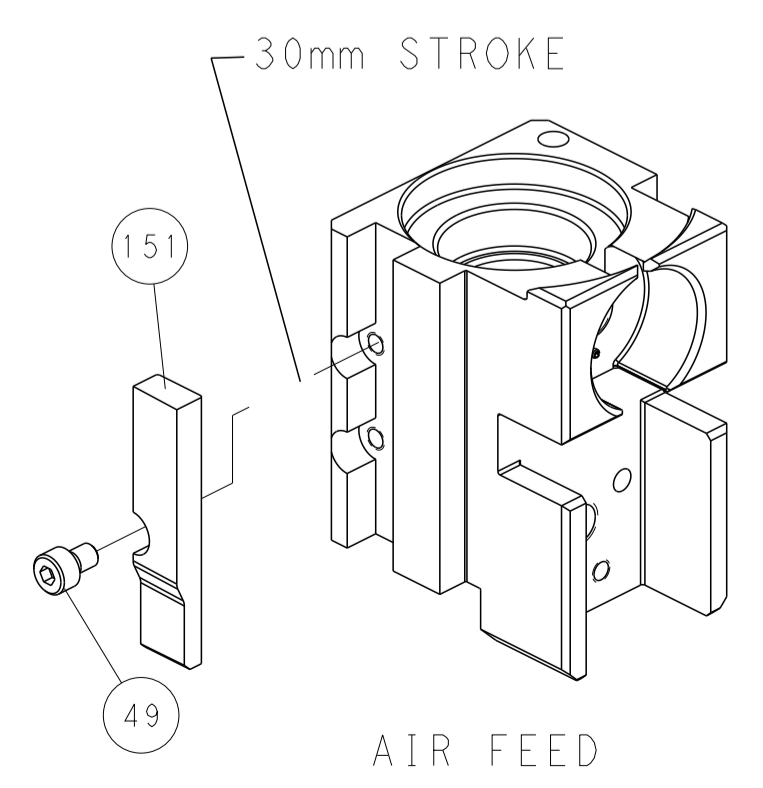
SEE DETAIL A

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

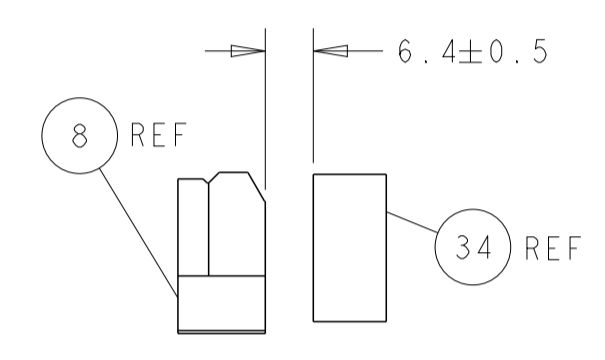
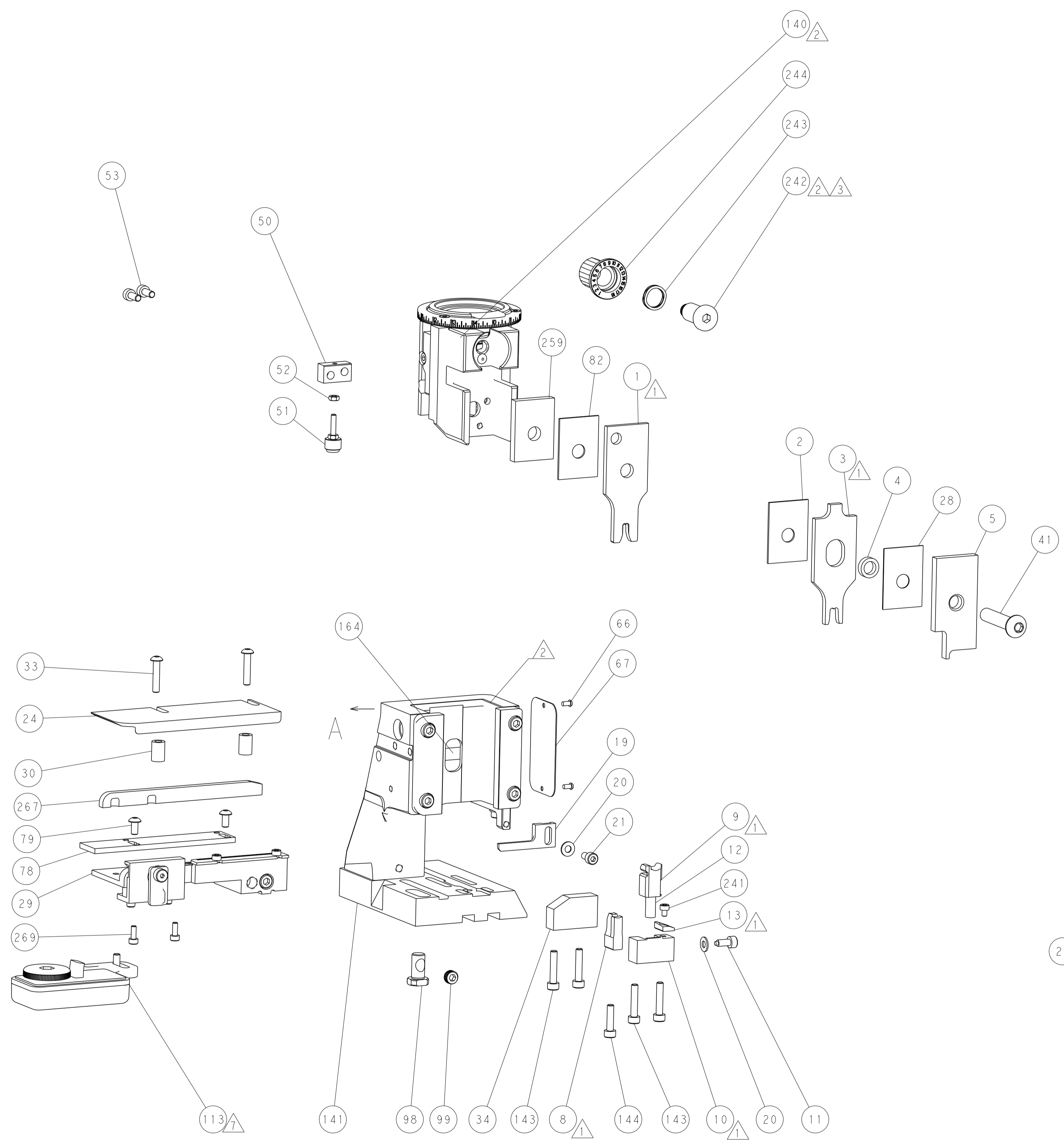


DETAIL A

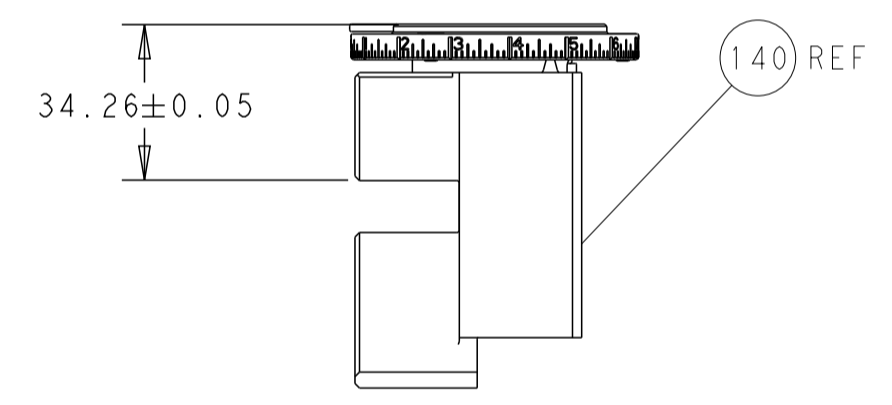
## CAM POSITION



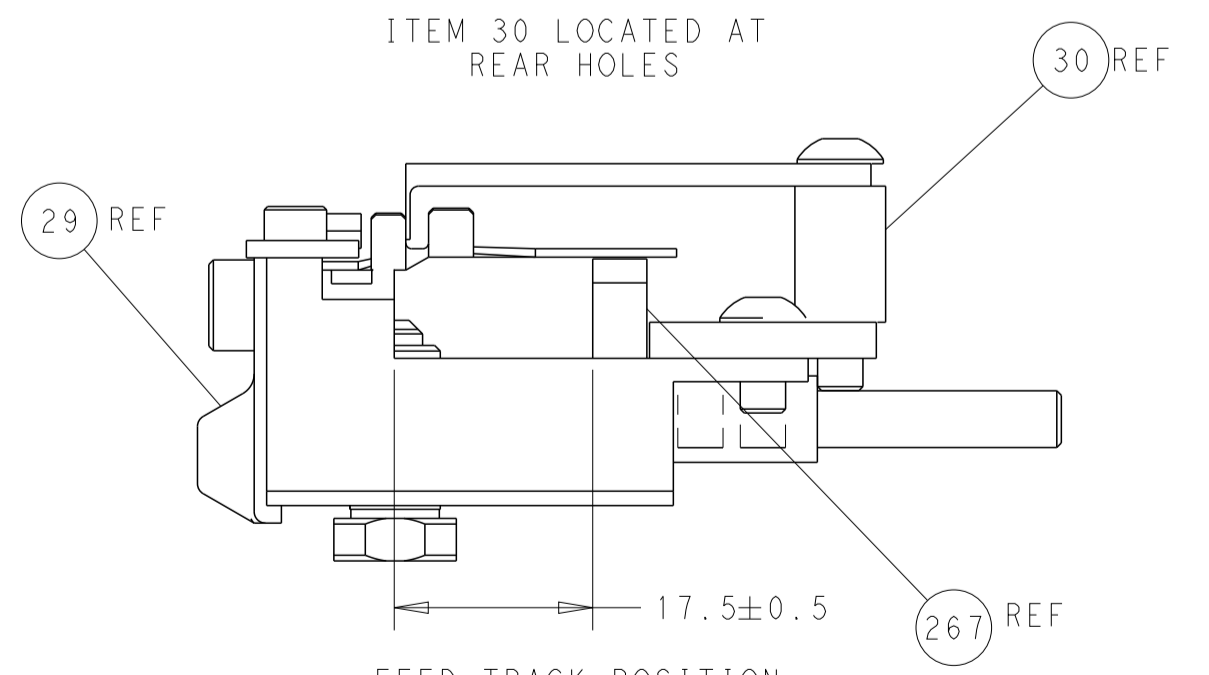
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED.</small>		DWN: H. HUANG 03JUN2014 CHK: L. ZHANG 03JUN2014 APVD: J. GUO 03JUN2014	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	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266315 SHEET 4 OF 4	RESTRICTED TO: - REV: G1