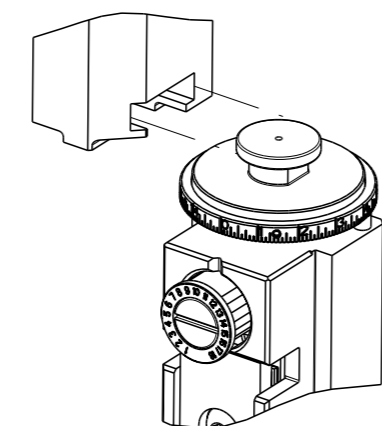


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266670-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266670-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266670-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.21mm [.205 IN]	D
INSUL	6.17mm [.243 IN]	PIDG

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ULTRA FAST PLUS FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.73-7.54 mm [.265-.297 IN]		∅ 2.29-4.06 mm [.090-.160 IN]	
TERMINAL APPLICATION SPECIFICATION		114-2123	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-520402-2	3-520404-2	3-520406-2	3-521057-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
14AWG	1.90+/-0.05 [.075+/- .002]	6.9	4.75mm [.187 IN]
16AWG OR (2)18AWG	1.78+/-0.05 [.070+/- .002]	8.2	4.75mm [.187 IN]



- 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.
 - TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.190 IN [4.83mm] 60/40 SOLID CORE AND MEASURE AT CENTER OF SLUG.
-
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - ITEM 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
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.

LOC		DIST		REVISIONS					
A		66		P	LY#	DESCRIPTION	DATE	OWN	APVD
		B				ECR-17-017295	24NOV2017	YY	CT
		C				ECR-18-017658	09NOV2018	JAH	CT
		D				ECR-19-005748	08APR2019	LG	TE
		E				ECR-20-008744	18JUN2020	JWC	TE

	-	1	1	189728-1	BRACKET, SPACER	255
	-	1	1	568681-1	SPACER, BASE PLATE	253
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	1	2844940-1	AIR FEED MODULE	238
	-	1	1	356885-4	STOP, SHEAR	237
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93
	-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	84
	-	6	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	83
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	240641-9	SPACER	81
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	2	2	1-18028-4	WASHER, FLAT, REG M3	68
	-	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	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	462427-2	FINGER, FEED	56
	-	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
	-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1-1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	2161336-2	PLATE, REAR STRIP GUIDE	29
	-	2	2	22281-9	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	684042-4	GUIDE, STRIP, FRONT	24
	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	1	2161335-2	SHEAR PLATE, REAR	22
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	463460-3	HOLD DOWN, TERMINAL	18
	-	1	1	803925-2	GUIDE, CARRIER SCRAP	17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	-	1	1	469542-3	REAR FLOATING SHEAR	15
	-	1	1	2119862-2	SHEAR HOLDER, REAR	14
	-	1	1	2280441-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	-	-	-	-	10
	1	1	1	1-454766-3	ANVIL, INSULATION	9
	1	2	1	808025-4	ANVIL	8
	-	1	1	690468-6	DEPRESSOR SHEAR, REAR	6
	-	-	-	-	-	5
	-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
	1	2	1	1803130-3	CRIMPER, INSULATION FASTON	3
	-	-	-	-	-	2
	1	2	1	808830-1	CRIMPER, SEMI FLAT	1
	-	77	72	-2	PART NO	ITEM NO
					DESCRIPTION	

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

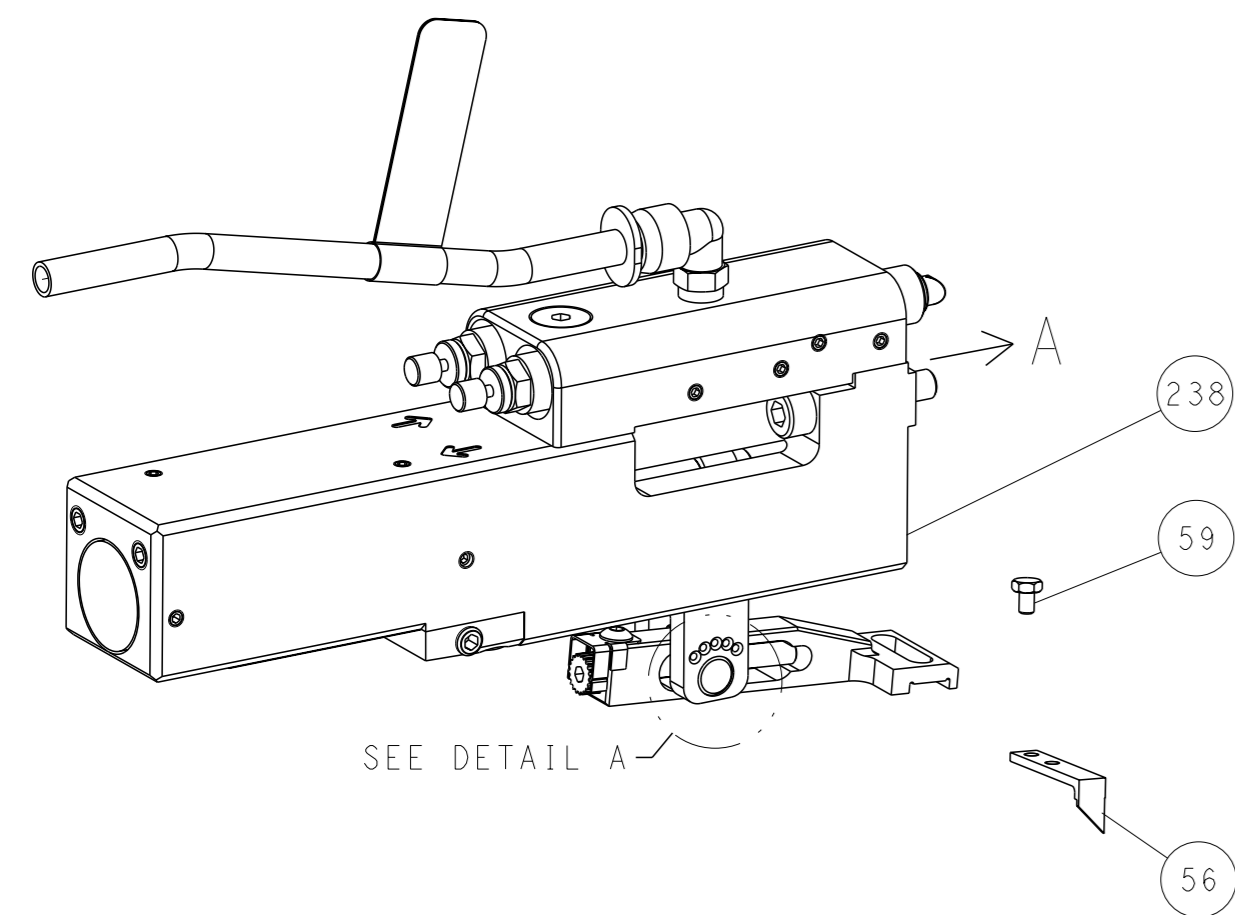
THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER ASSUMES ALL RESPONSIBILITIES FOR PROPER USE. CONTACT THE DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN: H. STAKEM	DATE: 03MARCH2015		TE Connectivity
mm	0 PLC ±	CHK: G. BAILEY	DATE: 03MARCH2015		Harrisburg, PA 17105-3608
	1 PLC ±	APVD: T. ELBIN	DATE: 03MARCH2015		NAME: Ocean Side Feed
	2 PLC ±	PRODUCT SPEC	APPLICATION SPEC		Applicator
MATERIAL:	ANGLES FINISH	WEIGHT	SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2266670
			RESTRICTED TO:	SCALE: 1:2	SHEET 1 OF 4
			Customer Accessible Production Drawing		

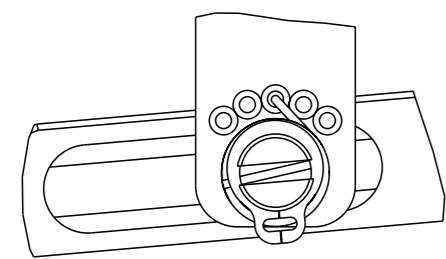
LOC	DIST	REVISIONS			
		REV	DATE	BY	APPV
A	66	-	-	-	-
		SEE SHEET 1			

FEED TYPE

PNEUMATIC

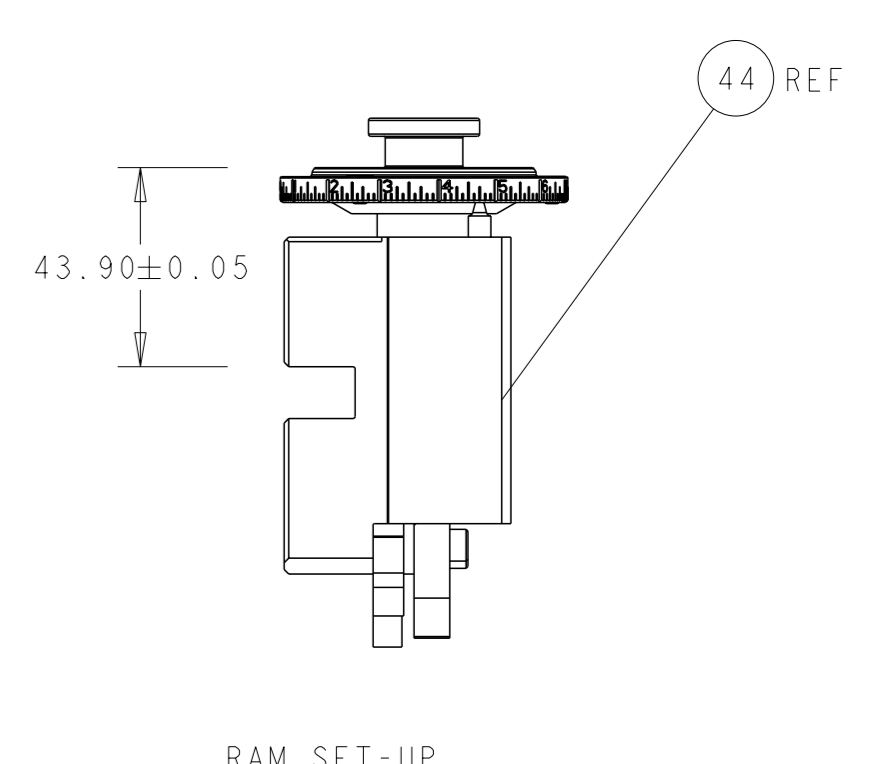
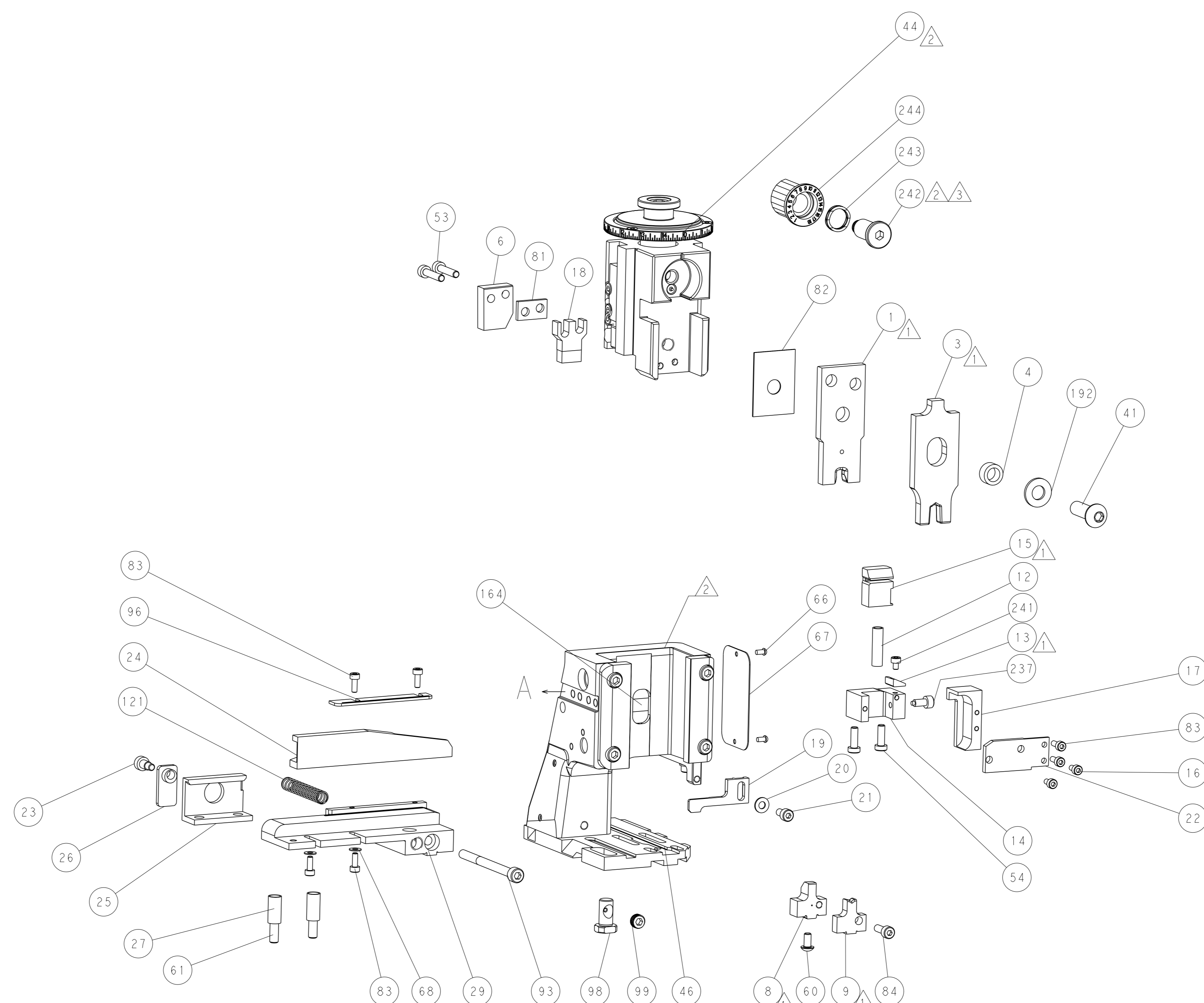
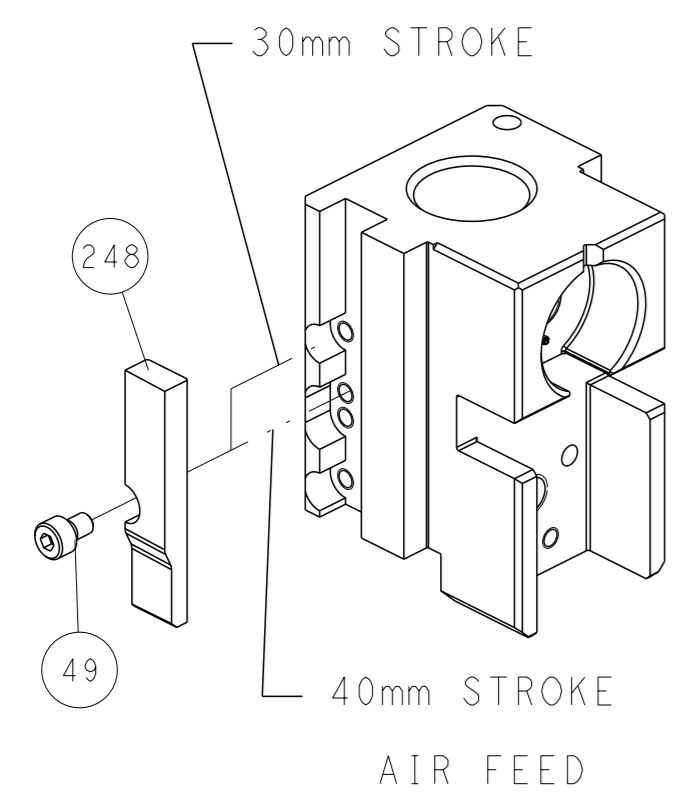


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITION



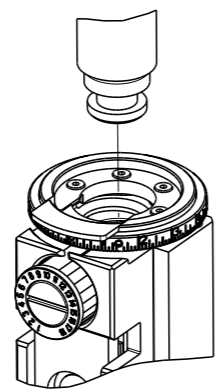
RAM SET-UP

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 FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: K. STAKEM CHK: G. BAILEY APVD: T. ELBIN	DATE: 03MARCH2015 DATE: 03MARCH2015 DATE: 03MARCH2015	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 PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266670 SCALE: 1:2 SHEET: 2 of 4 REV: E	RESTRICTED TO:
MATERIAL:		Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266670-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266670-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.21mm [.205 IN]	D
INSUL	6.17mm [.243 IN]	PIDG
APPLICATOR INSTRUCTIONS 408-35042		

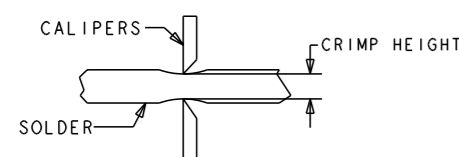
TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: ULTRA FAST PLUS FULLY INSULATED FASTON	
WIRE STRIP LENGTH 6.73-7.54 mm [.265-.297 IN]	INSULATION DIAMETER RANGE 2.29-4.06 mm [.090-.160 IN]
TERMINAL APPLICATION SPECIFICATION 114-2123	
TERMINALS APPLIED	
TE TERMINAL 3-520402-2	TE TERMINAL 3-520404-2
TE TERMINAL 3-520406-2	TE TERMINAL 3-521057-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	SOLDER
14AWG	1.90 +/- 0.05 [.075 +/- .002]	6.9	4.75mm [.187 IN]
16AWG OR (2)18AWG	1.78 +/- 0.05 [.070 +/- .002]	8.2	4.75mm [.187 IN]



- 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. TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.190 IN [4.83mm] 60/40 SOLID CORE AND MEASURE AT CENTER OF SLUG.
- 6. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7. ITEM 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- 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.

LOC	DIST	REVISIONS			
		REV	BY	DATE	APPV
A	66	-	-	-	-

REV	BY	DATE	APPV	DESCRIPTION	ITEM NO
-	1	189728-1		BRACKET, SPACER	255
-	1	568681-1		SPACER, BASE PLATE	253
-	1	2119082-9		CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1		WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1		RETAINER, INSULATION DIAL	242
-	1	7-18023-7		SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-1		AIR FEED MODULE	238
-	1	356885-4		STOP, SHEAR	237
-	1	1-18028-0		WASHER, FLAT, REG M8	192
-	REF	994970-2		COUNTER, MAGNETIC	164
-	1	2119641-2		FEED CAM, AIR FEED	151
-	1	2079383-8		SCR, BHSC, RoHS (M4 X 16)	144
-	2	2168400-5		SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	2-1803583-0		APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1		RAM ASSEMBLY, SF PACIFIC	140
-	1	1-22281-8		SPRING, COMPRESSION	121
-	1	2844908-1		SCREW, LOCKING	99
-	1	2844907-1		POST, LOCKING	98
-	1	1-690438-0		FRONT STRIP GUIDE	96
-	1	2168083-6		SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	2168083-3		SCR, SKT HD CAP, RoHS, M4 X 12.0	84
-	6	2168083-1		SCR, SKT HD CAP, RoHS, M3 X 8.0	83
-	1	455888-5		SPACER, CRIMPER	82
-	1	240641-9		SPACER	81
-	1	1803607-3		DOCUMENTATION PACKAGE	71
-	2	1-18028-4		WASHER, FLAT, REG M3	68
-	1	2119740-1		TAG, IDENTIFICATION	67
-	2	2168078-1		SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2-18032-5		SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5		SCR, HEX HD CAP, M4 X 6.0	59
-	1	462427-2		FINGER, FEED	56
-	2	2168083-9		SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	18023-9		SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1		SCR, BHSC, RoHS (M8 X 25)	41
-	1	2161336-2		PLATE, REAR STRIP GUIDE	29
-	2	22281-9		SPRING, COMPRESSION	27
-	1	356835-1		LEVER, DRAG RELEASE	26
-	1	240792-1		DRAG, TERMINAL	25
-	1	684042-4		GUIDE, STRIP, FRONT	24
-	1	980371-4		SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	2161335-2		SHEAR PLATE, REAR	22
-	1	2168083-2		SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1-18028-2		WASHER, FLAT, REG M4	20
-	1	2119533-1		STRIPPER, SIDE FEED	19
-	1	463460-3		HOLD DOWN, TERMINAL	18
-	1	803925-2		GUIDE, CARRIER SCRAP	17
-	2	1-2168083-1		SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	469542-3		REAR FLOATING SHEAR	15
-	1	2119862-2		SHEAR HOLDER, REAR	14
-	1	2280441-1		INSERT, SHEAR	13
-	1	3-22280-3		SPRING, COMPRESSION	12
-	-	-		-	10
-	1	1-454766-3		ANVIL, INSULATION	9
-	1	808025-4		ANVIL	8
-	1	690468-6		DEPRESSOR SHEAR, REAR	6
-	-	-		-	5
-	1	4-238011-4		BLOCK, CRIMPER SPACER	4
-	1	1803130-3		CRIMPER, INSULATION FASTON	3
-	-	-		-	2
-	1	808830-1		CRIMPER, SEMI FLAT	1
-	-	-		-	1

THE DRAWING IS UNPUBLISHED DOCUMENT FOR THE PRODUCT AND THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE AND THE USER SHALL CONTACT THE SUPPLIER FOR THE LATEST REVISION.

OWNER: STAKEEM	DATE: 03MARCH2015
CHK: G.BAILEY	DATE: 03MARCH2015
APPV: T.ELBIN	DATE: 03MARCH2015
PRODUCT SPEC	
APPLICATION SPEC	
MATERIAL	
FINISH	

Customer Accessible Production Drawing

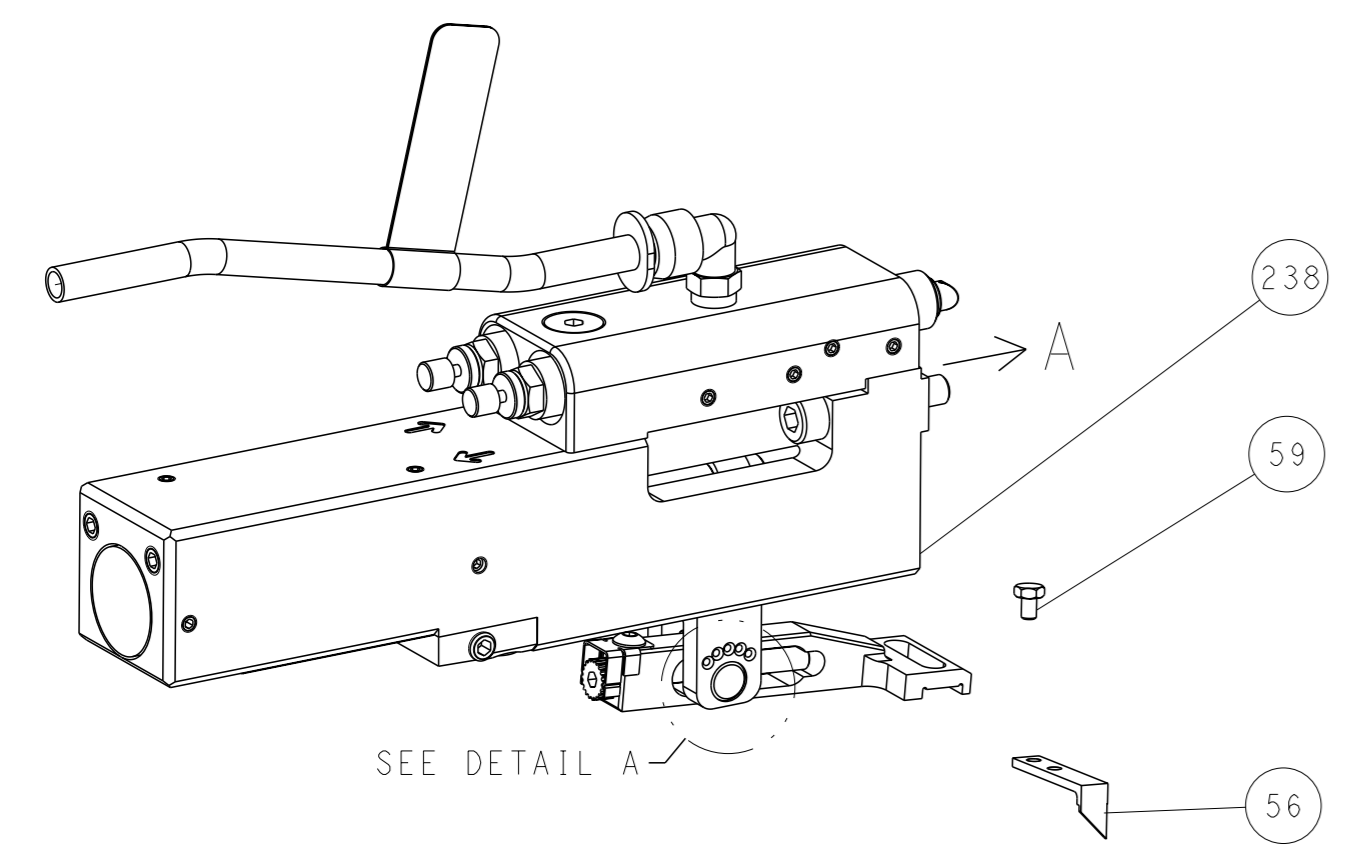
SCALE: 1:2 SHEET 3 OF 4 REV E

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			
		REV	DATE	OWN	APVD
A	66	1	SEE SHEET 1	-	-

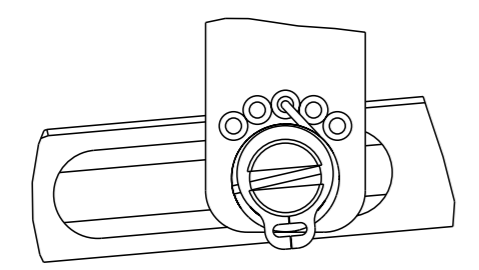
FEED TYPE

PNEUMATIC



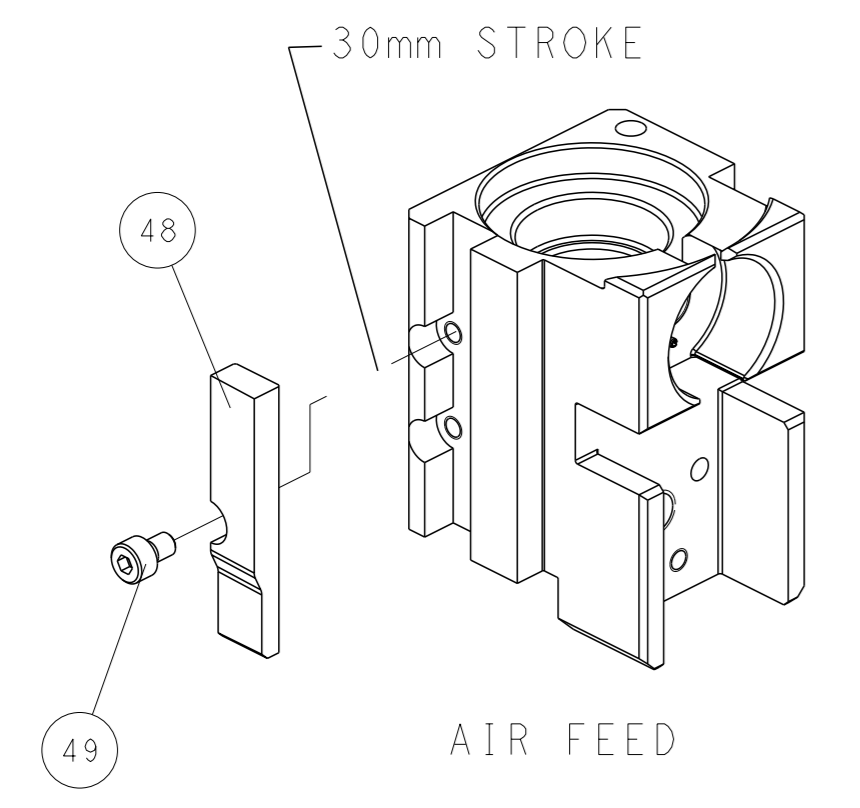
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

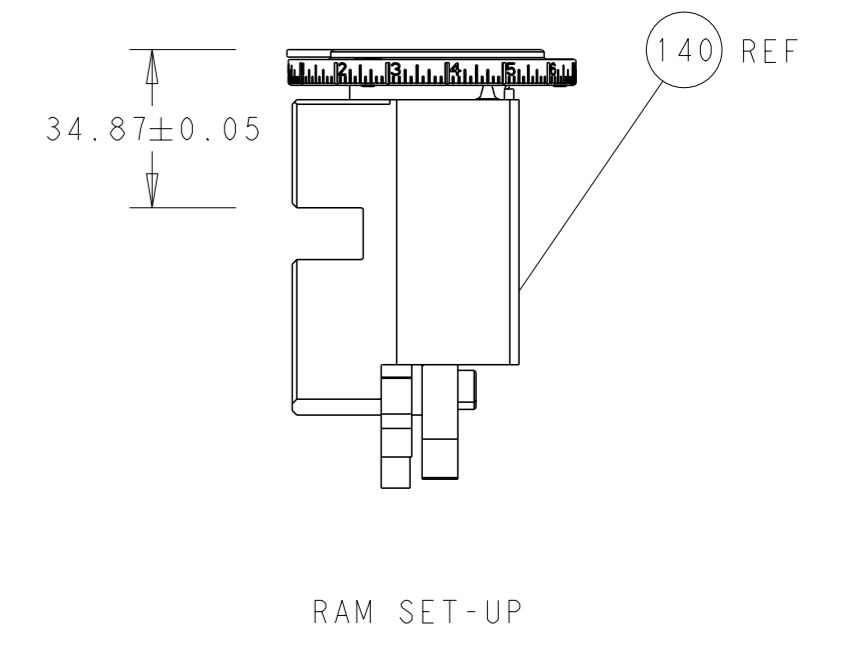
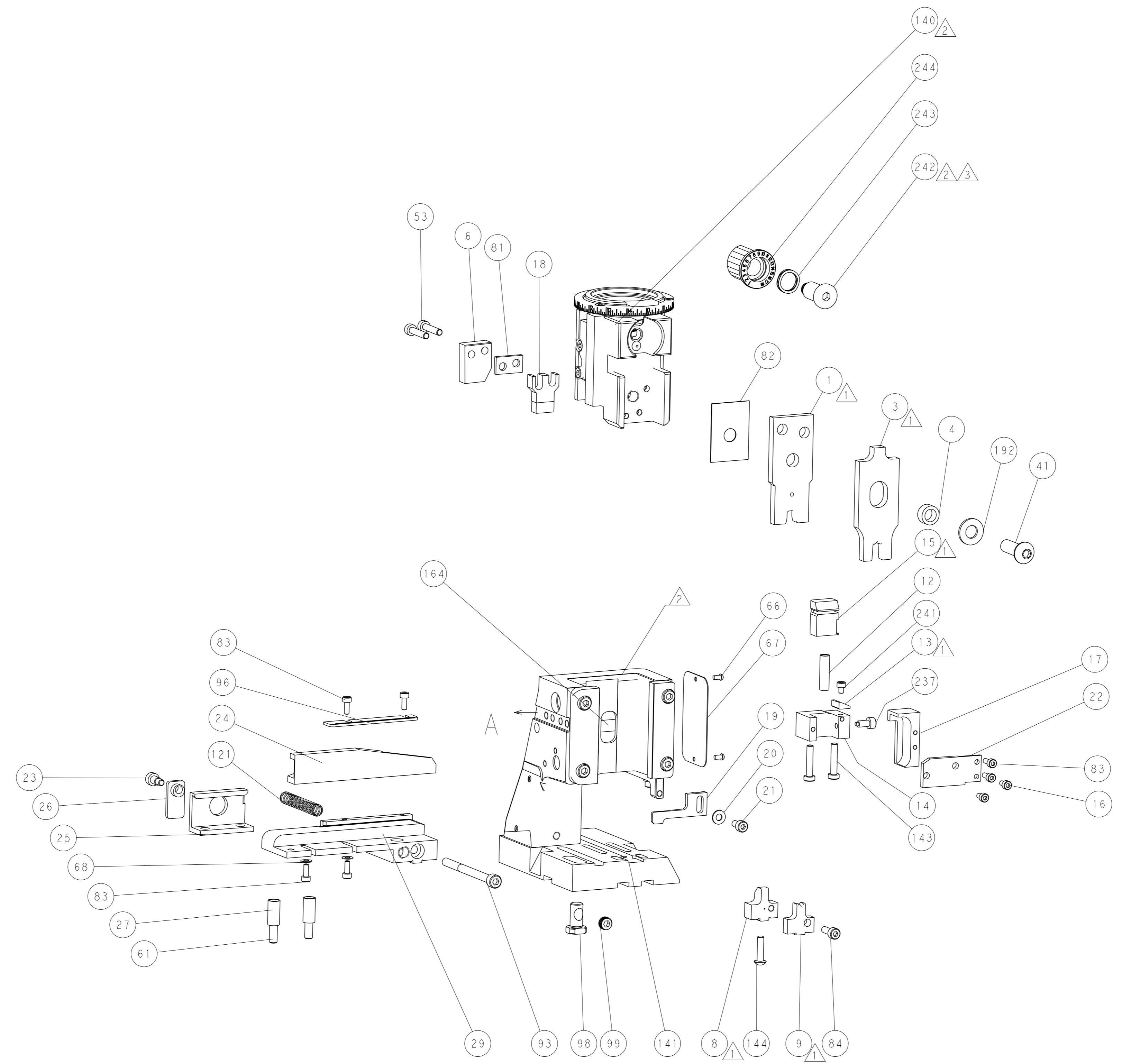


DETAIL A

CAM POSITION



AIR FEED



RAM SET-UP

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 FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: K. STAKEM CHK: G. BAILEY APVD: T. ELBIN	DATE: 03MARCH2015 NAME: Ocean Side Feed Applicator
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266670	RESTRICTED TO: - SHEET: 4 of 4 REV: E
MATERIAL: -		Customer Accessible Production Drawing	