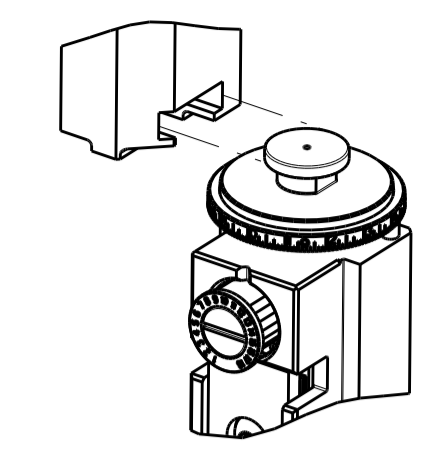


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266708-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266708-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266708-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266708-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266708-7	A	CRIMP TOOLING KIT	-

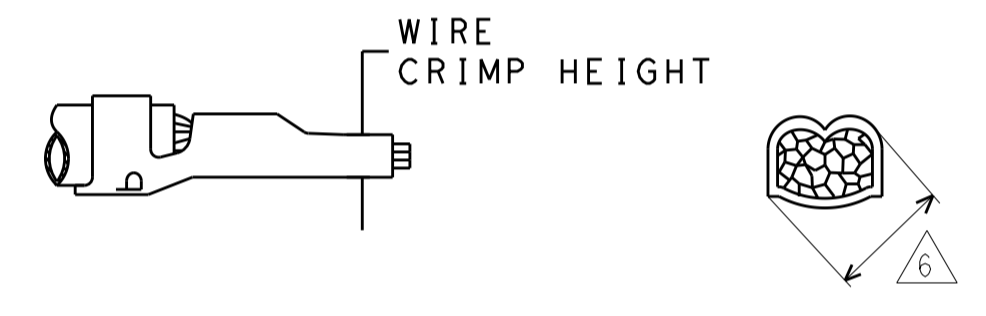
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
STABILIZER	1.93 mm [.076]	F
INSULATION	3.30 mm [.130]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: STRAIN RELIEF TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.97-6.35 mm [.235-.250 IN]		3.05 mm [.120 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	ATS-638934200 Rev B		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949350-1	02-09-2105		



WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.30mm <sup>2</sup>	1.25+/-0.025 [.049+/- .001]	7.8
18 AWG OR 0.80mm <sup>2</sup>	1.25+/-0.025 [.049+/- .001]	7.4

- 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 HEIGHT MEASURING OVER WIRE BARREL CLOSEST TO INSULATION BARREL SHOULD HAVE A DIAGONALLY MEASUREMENT OF

WIRE SIZE	DIAGONAL DIMENSION
16 AWG OR 1.30mm <sup>2</sup>	2.34+/-0.05
18 AWG OR 0.80mm <sup>2</sup>	2.21+/-0.05

**\*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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
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				ECR-18-002194	13FEB2018	JAH	TE
				ECR-19-017703	14NOV2019	FZ	TE

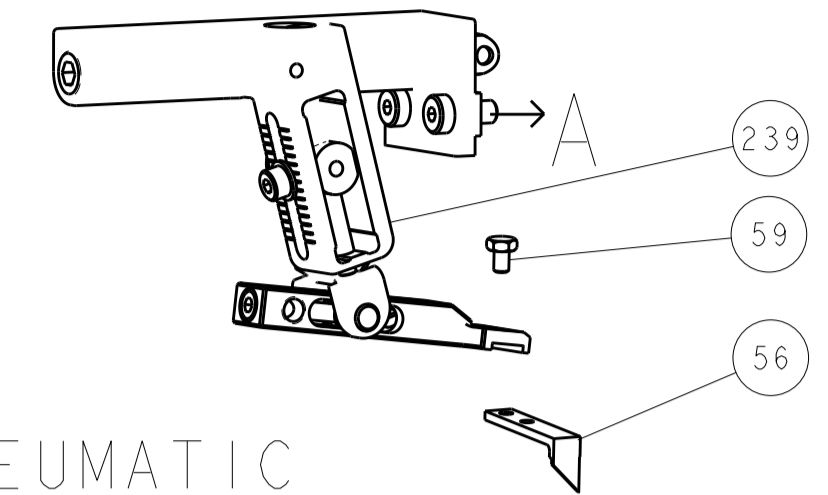
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	1	1	1	1	1-1803188-4	CRIMPER, WIRE	178	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	1338685-1	PAWL, FEED	56	
-	2	2	2	2	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	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	
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	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	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1803180-2	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-1633961-5	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
-	1	2	2	1	4-1633730-4	CRIMPER, WIRE	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH				1:2	1	of	4	C

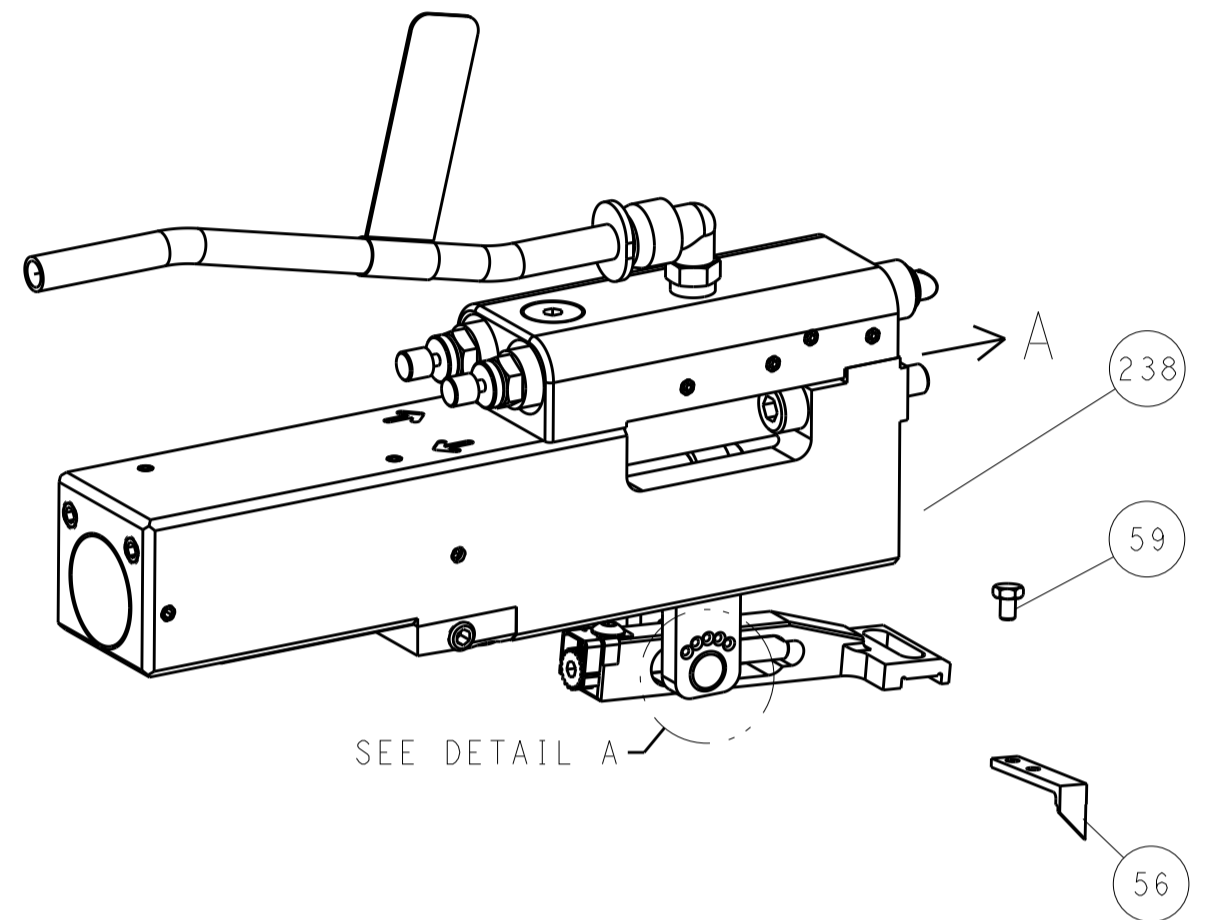
Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APP'D
A	66				

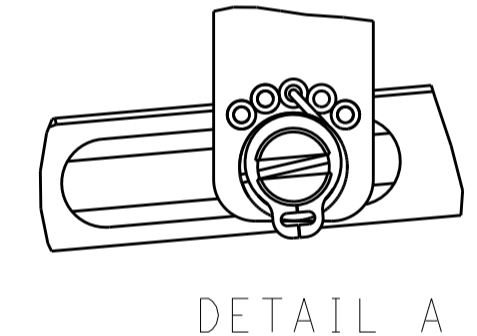
# FEED TYPE MECHANICAL



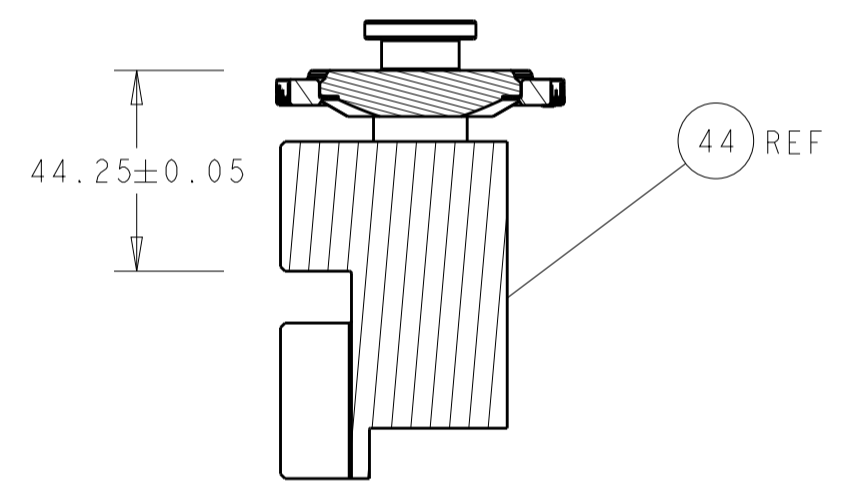
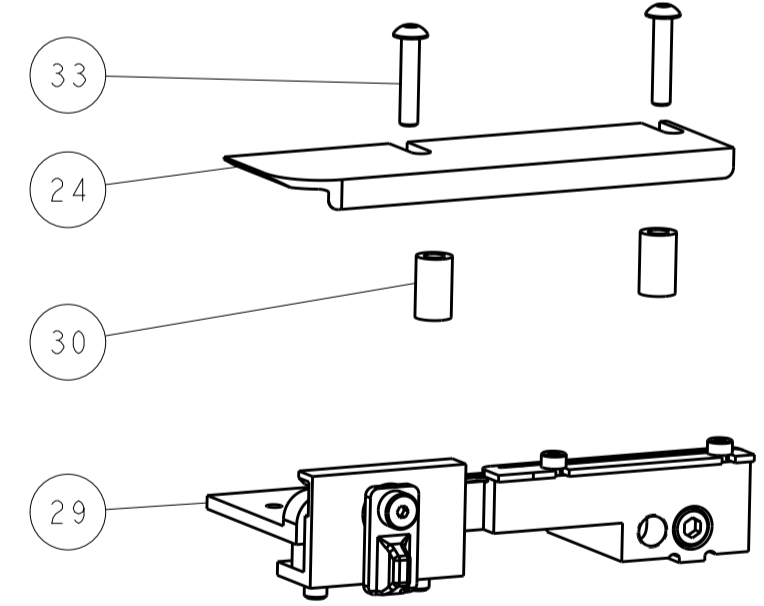
## PNEUMATIC



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

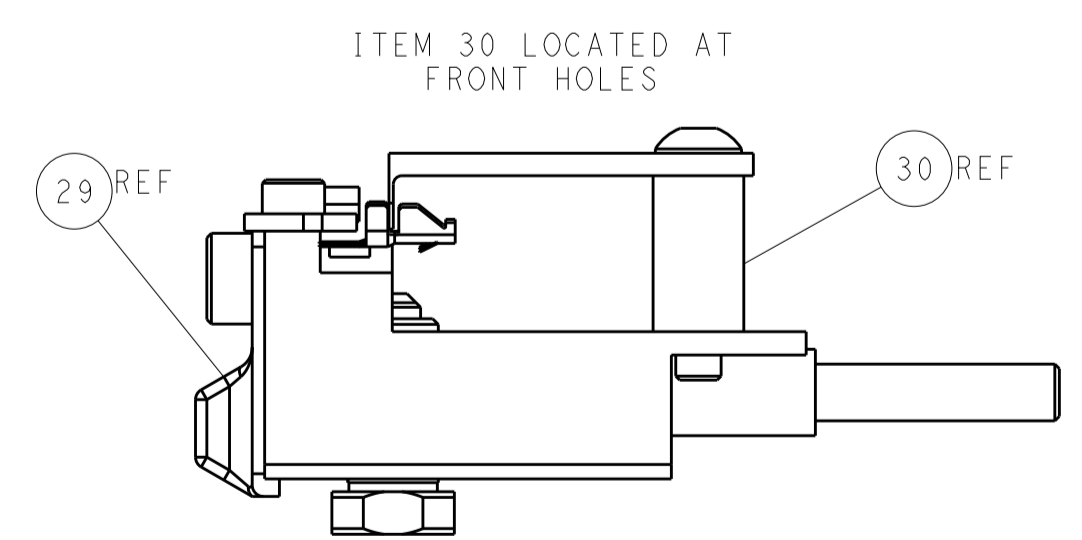
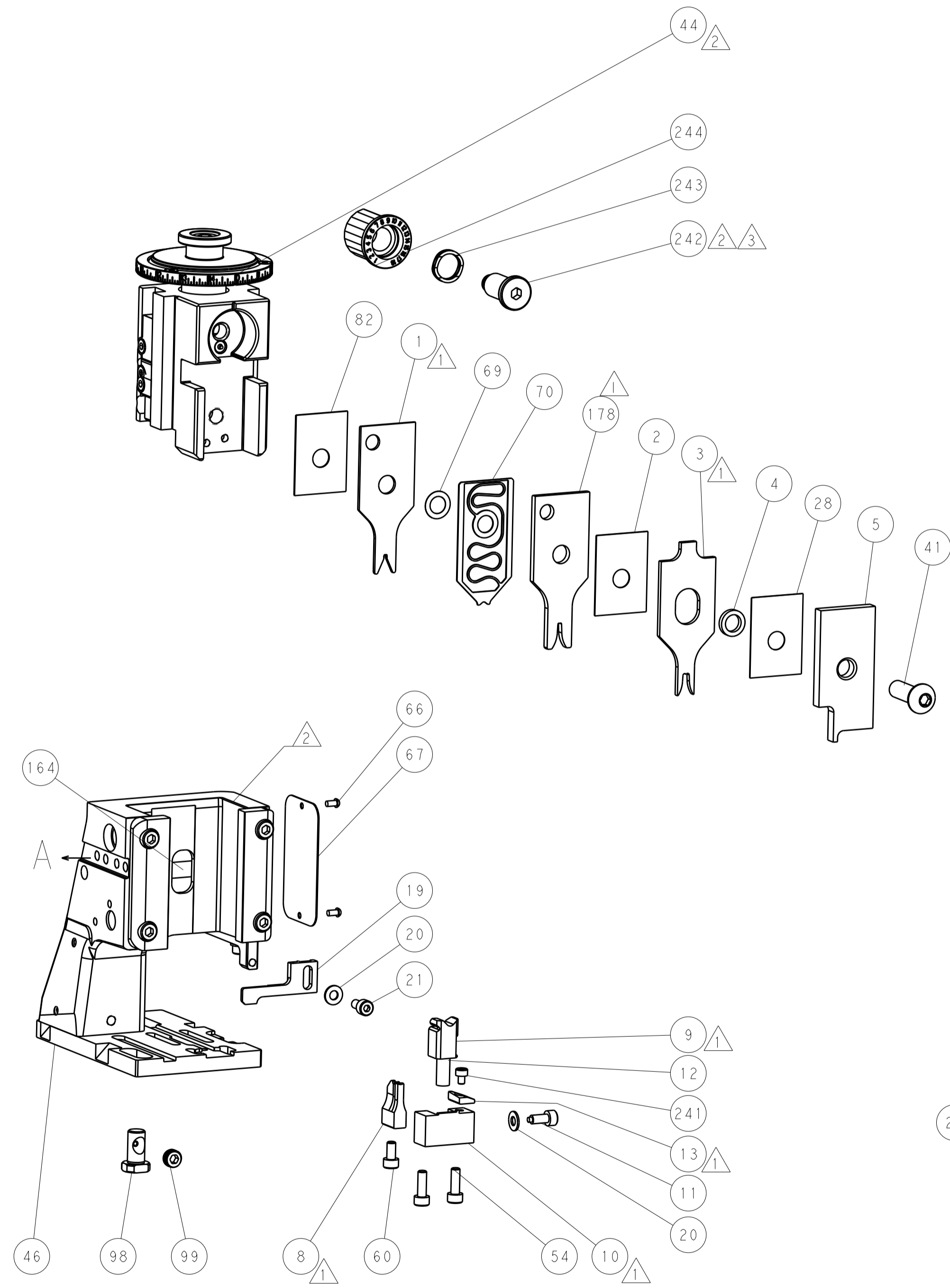
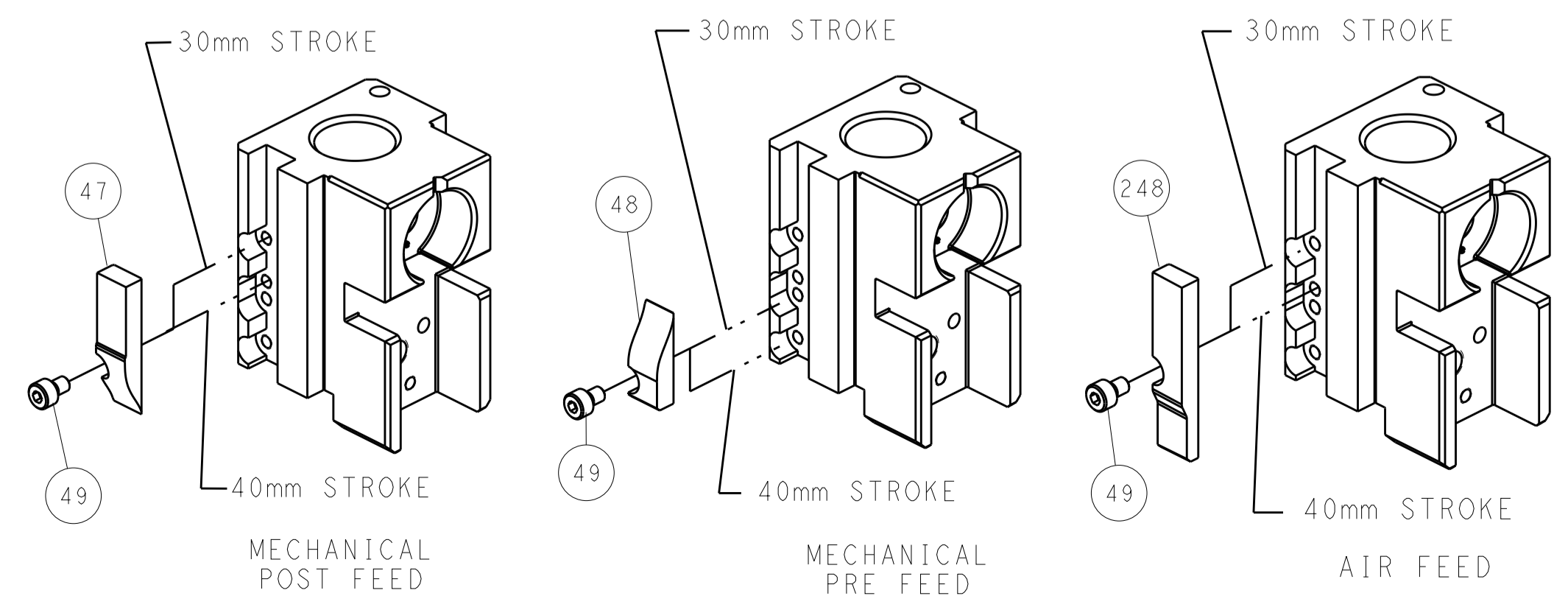


DETAIL A



RAM SET-UP

## CAM POSITIONS



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN R. HUANG 12MAR2015 CHK L. ZHANG 12MAR2015 APVD H. GUO 12MAR2015		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 ©=2266708 RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266708-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266708-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266708-7	A	CRIMP TOOLING KIT	-

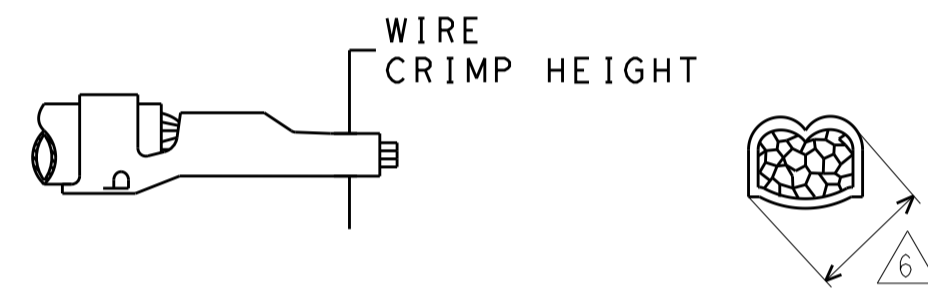
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
STABILIZER	1.93 mm [.076]	F
INSULATION	3.30 mm [.130]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: STRAIN RELIEF TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.97-6.35 mm [.235-.250 IN]		3.05 mm [.120 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	ATS-638934200 Rev B		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949350-1	02-09-2105		



WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.30mm <sup>2</sup>	1.25+/-0.025 [.049+/- .001]	7.8
18 AWG OR 0.80mm <sup>2</sup>	1.25+/-0.025 [.049+/- .001]	7.4



- 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 HEIGHT MEASURING OVER WIRE BARREL CLOSEST TO INSULATION BARREL SHOULD HAVE A DIAGONALLY MEASUREMENT OF

WIRE SIZE	DIAGONAL DIMENSION
16 AWG OR 1.30mm <sup>2</sup>	2.34+/-0.05
18 AWG OR 0.80mm <sup>2</sup>	2.21+/-0.05

**\*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)

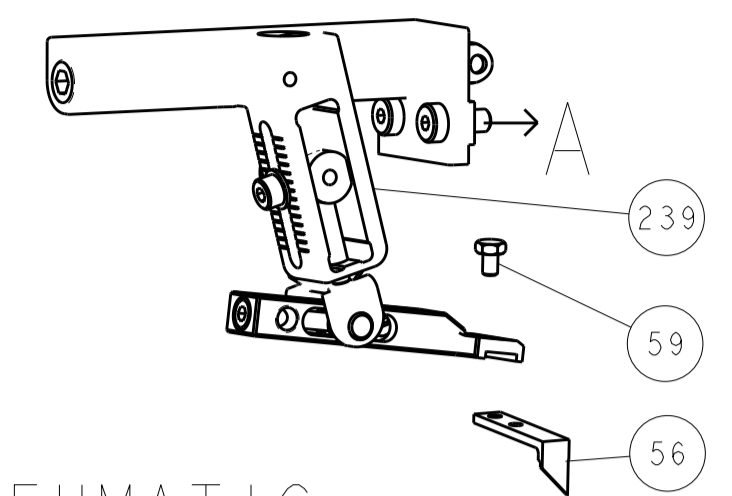
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APP'D
-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-8	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	1	1	1-1803188-4	CRIMPER, WIRE	178
-	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
-	2	2	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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	1338685-1	PAWL, FEED	56
-	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	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	1803180-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	4-1633730-4	CRIMPER, WIRE	1

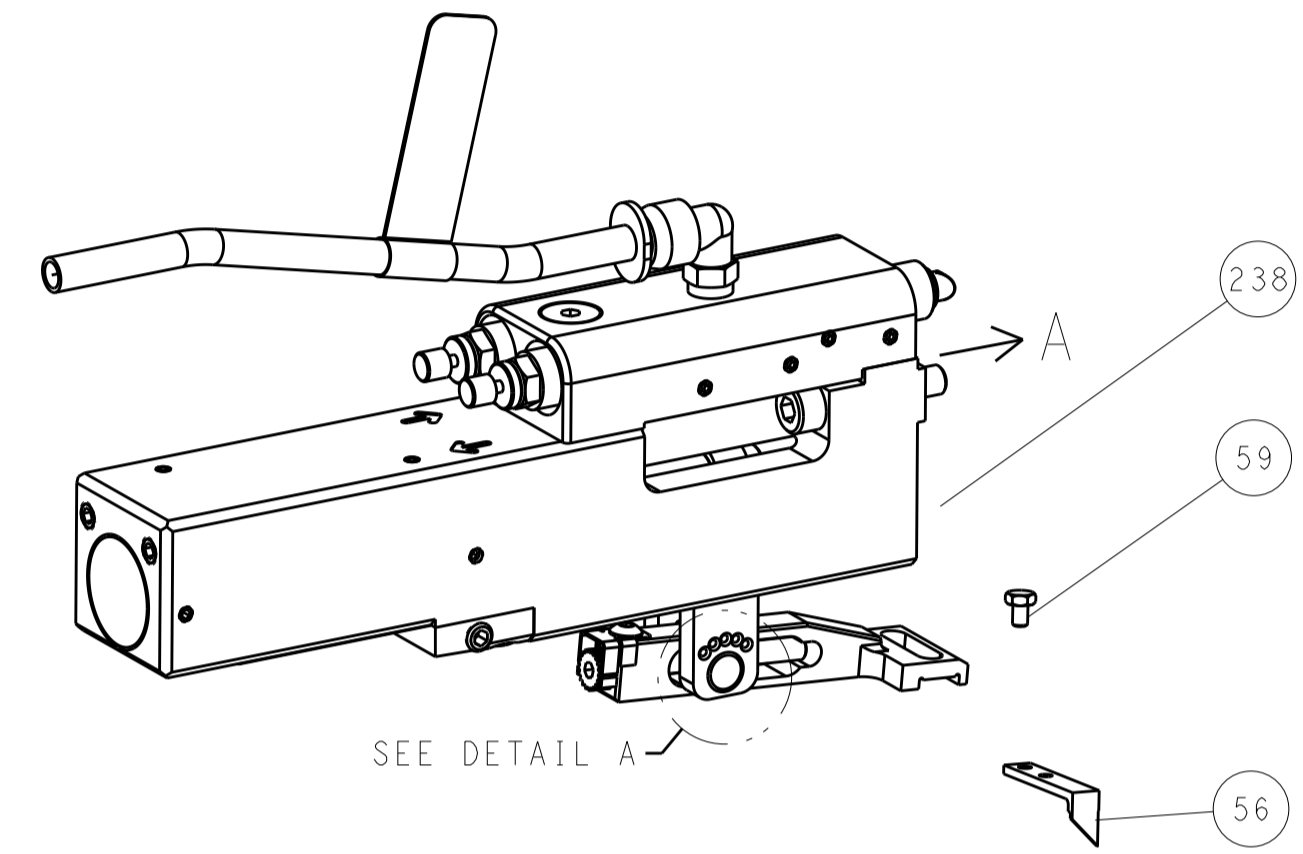
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 12MAR2015		CHK: L. ZHANG 12MAR2015		APVD: H. GUO 12MAR2015		NAME: Ocean Side Feed Applicator	
0 PLC	±	1 PLC	±	2 PLC	±	3 PLC	±	4 PLC	±	ANGLE	±
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2		SHEET: 3 OF 4		REV: C	

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

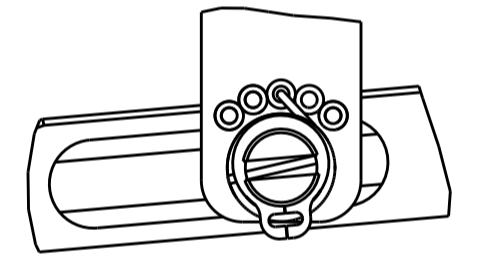
# FEED TYPE MECHANICAL



# PNEUMATIC

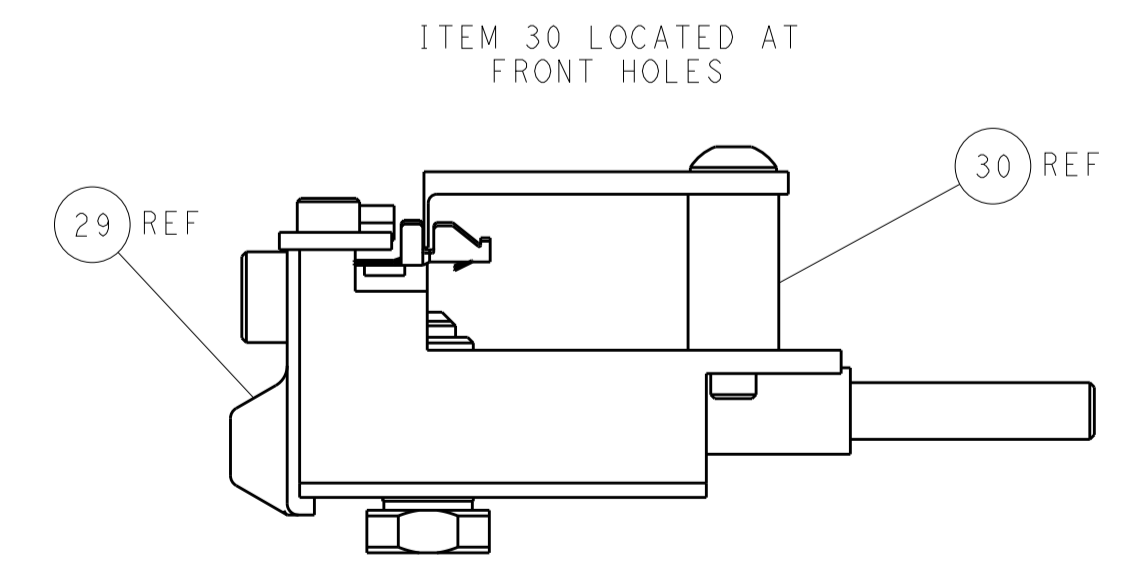
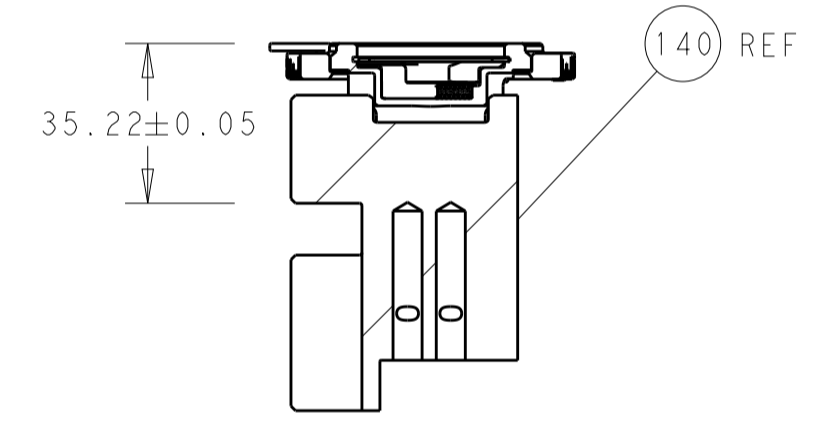
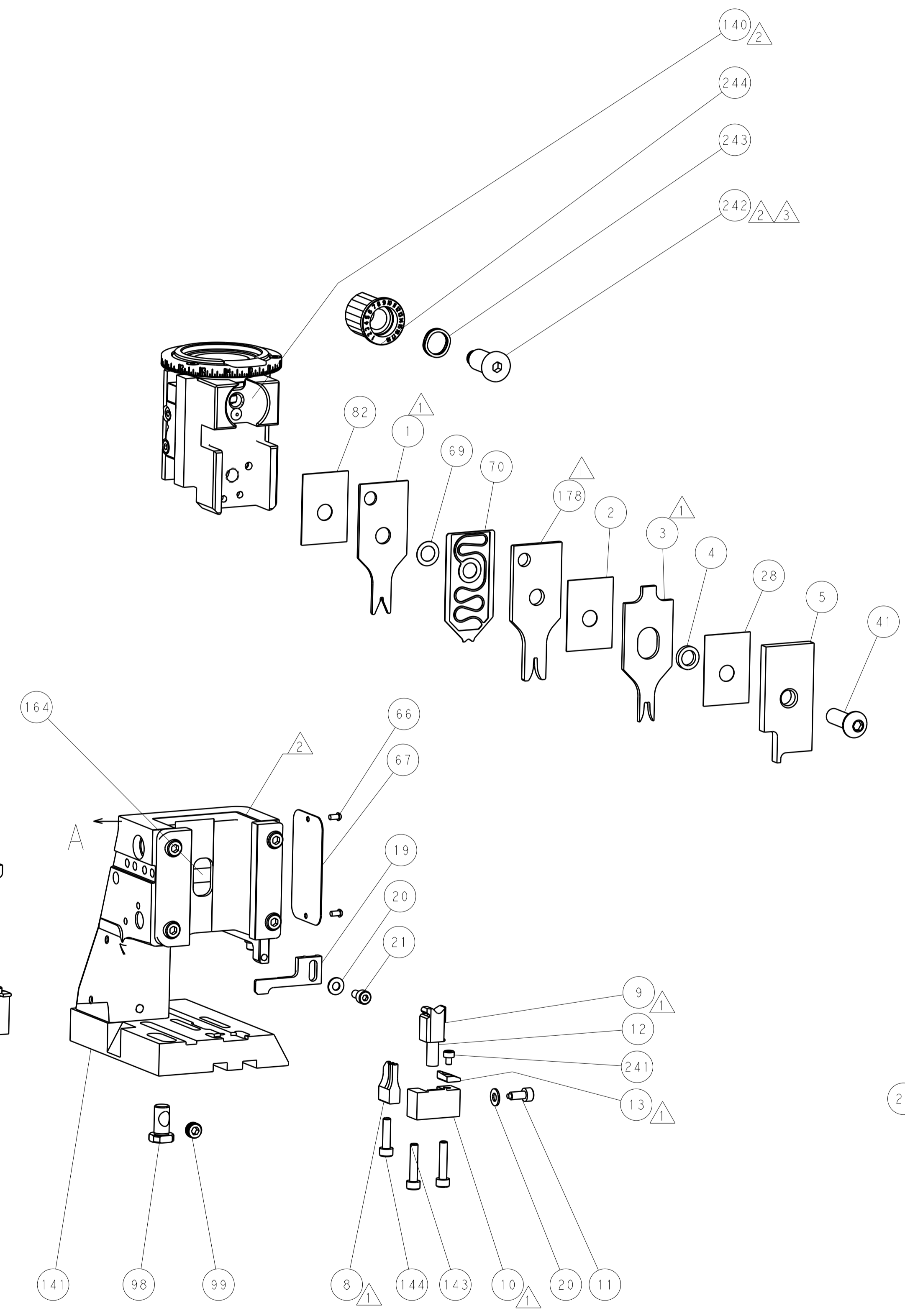
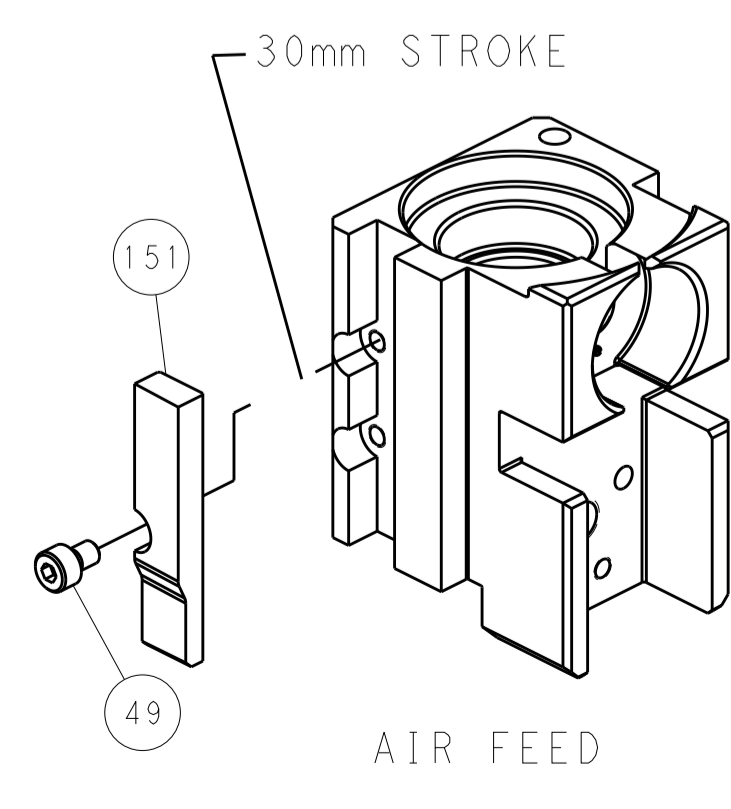
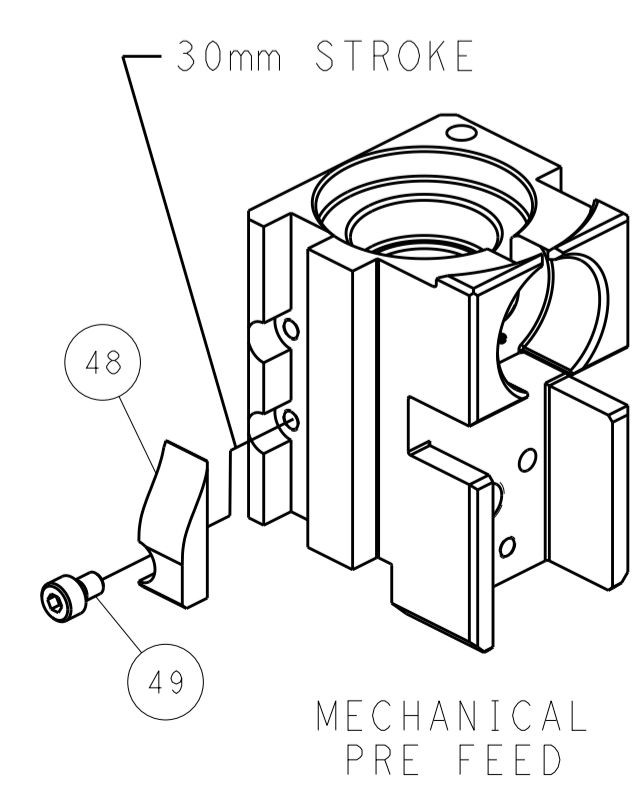
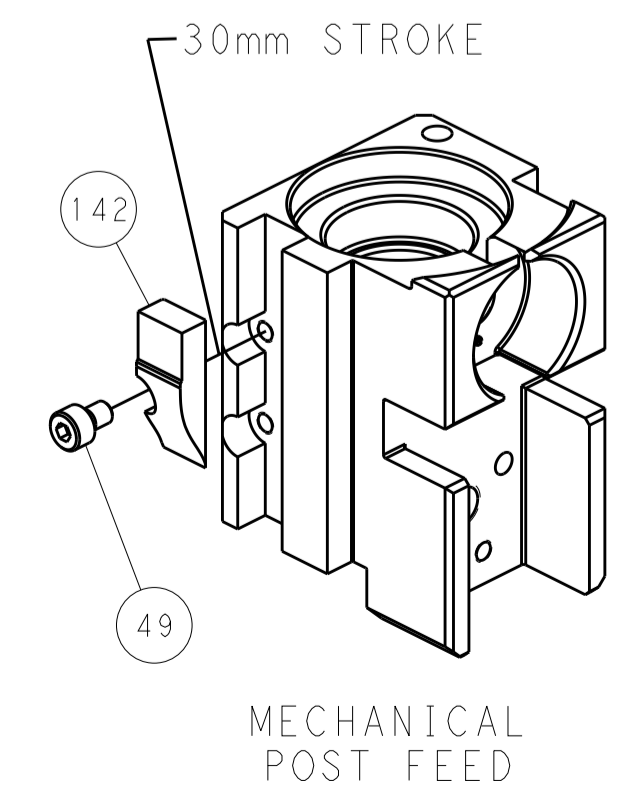


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG 12MAR2015		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK L. ZHANG 12MAR2015	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD H. GUO 12MAR2015	PRODUCT SPEC	SIZE CAGE CODE DRAWING NO	
	2 PLC	±			APPLICATION SPEC	RESTRICTED TO	
	3 PLC	±				A   00779 C=2266708	
	4 PLC	±			WEIGHT	SCALE 1:2 SHEET 4 OF 4 REV C	
	ANGLES	±			MATERIAL	Customer Accessible Production Drawing	
	FINISH						