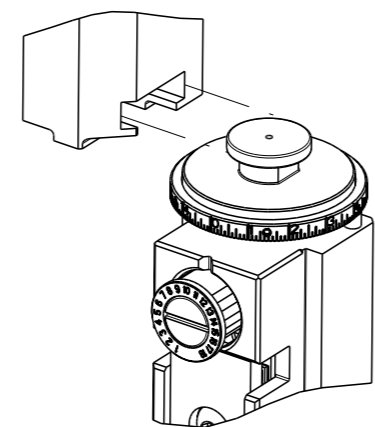


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266821-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266821-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266821-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

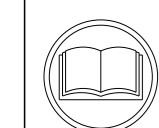


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.22 mm [.206]	○
INSUL	6.38 mm [.251]	○

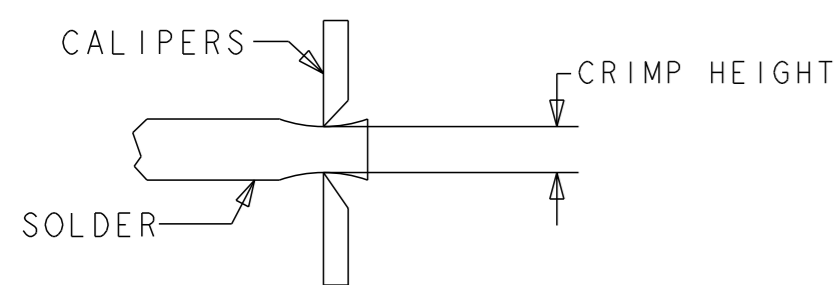
APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA:	TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME:	OUTTER FERRULE, 180 DEGREE, LARGE CABLE, FAKRA	
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE ∅ 5.00-6.00 mm [.197-.236 IN]
TERMINAL APPLICATION SPECIFICATION	114-32145	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
2272409-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-71	5.61 +/- 0.00 [.221 +/- .000]	2.5
RG-62	5.32 +/- 0.00 [.210 +/- .000]	5.9
RG-59	5.32 +/- 0.00 [.210 +/- .000]	5.9



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.250 IN [3.18mm] 50/50 SOLID CORE) AND MEASURE AT END OF SLUG.



SEE APPLICATION SPECIFICATION 114-32145 FOR RECOMMENDED STRIP LENGTH DIMENSIONS.

***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			
		REV	DATE	BY	APPV
A	66	A	RELEASED	29FEB2016	BH
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		B	ECR-18-015384	27SEP2018	FL

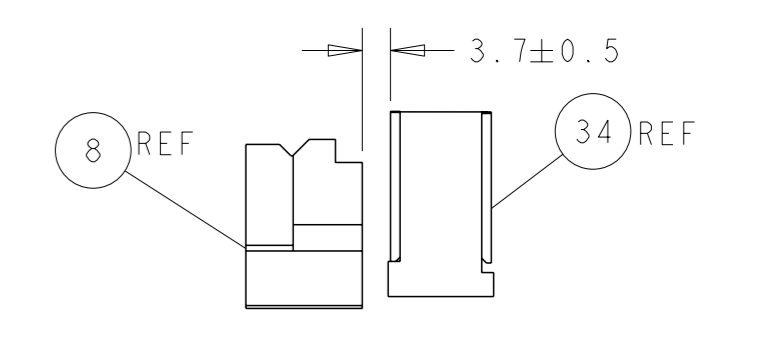
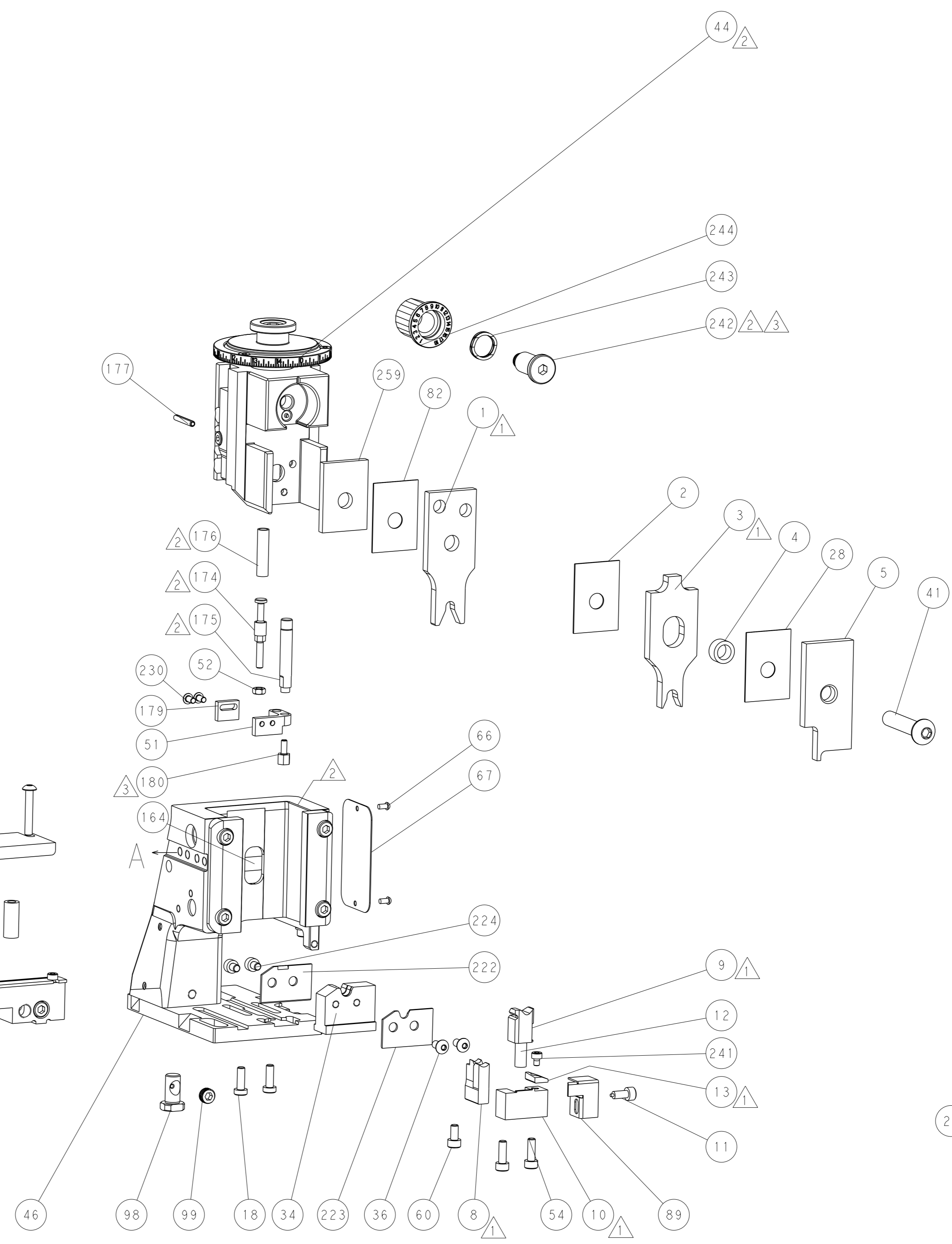
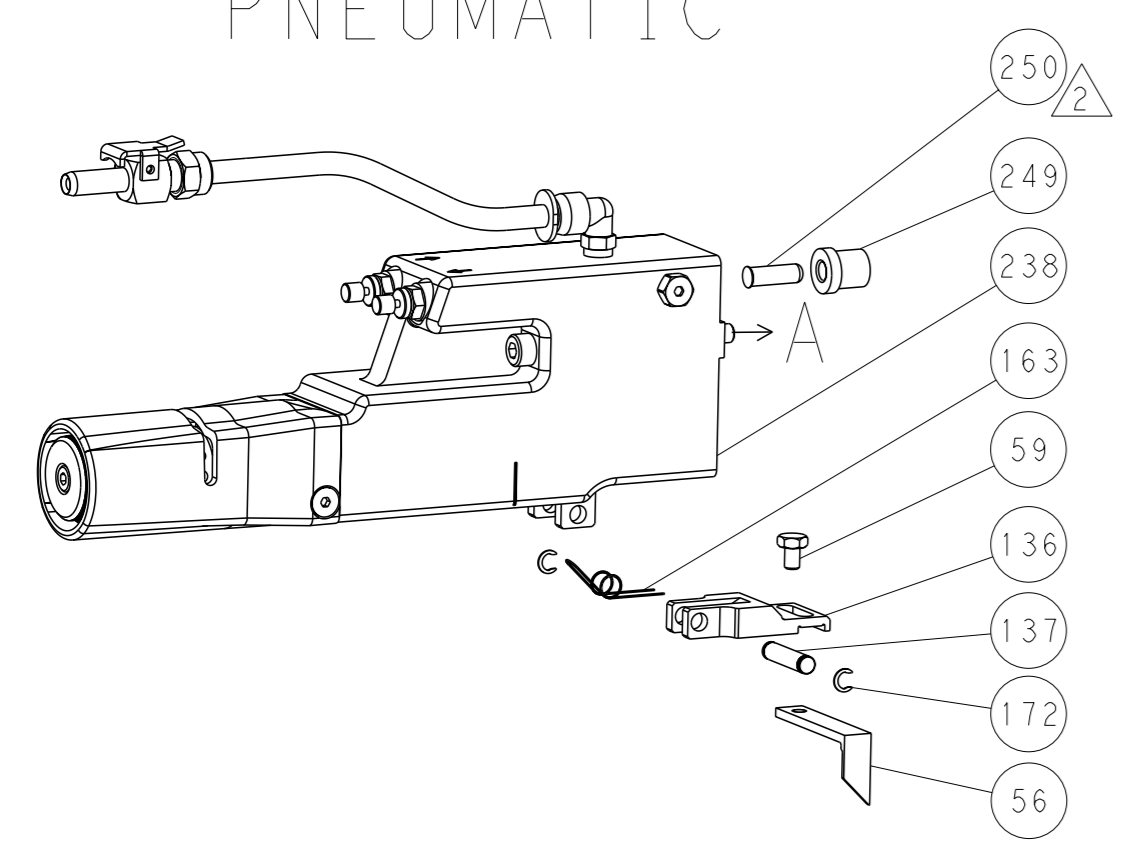
-	1	1	1803078-3	SPACER, PRECISION	259	
-	1	1	2119640-1	PUSH ROD, AIR FEED	250	
-	1	1	1803259-1	BUSHING, FLANGED	249	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2063440-2	AIR FEED MODULE	238	
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230	
-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	224	
-	1	1	1803306-1	PLATE, RETAINING	223	
-	1	1	1803340-1	PLATE, RETAINING	222	
3	-	1	1	1752354-6	STANDOFF, HOLD-DOWN	180
-	1	1	2-1976053-6	LOCATER BLOCK, TERMINAL	179	
-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	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	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	1-1338683-1	FEED PAWL	56	
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1901681-8	HOLDDOWN, TERMINAL	51	
-	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	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	36	
-	1	1	1803308-4	SUPPORT, TERMINAL	34	
-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33	
-	2	2	4-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-5	SPACER, CRIMPER	28	
-	1	1	1320928-2	STRIP GUIDE	24	
-	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	18	
1	-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-3	STOP, SHEAR	11	
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9	
1	2	1	4-1803055-0	ANVIL, COMBINATION	8	
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1-2119757-5	DEPRESSOR, SHEAR	5	
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4	
1	2	1	5-1633966-2	CRIMPER, INSULATION O	3	
-	1	1	455888-6	SPACER, CRIMPER	2	
1	2	1	2-1633723-1	CRIMPER, WIRE O	1	
-	77	-	72	-	2	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APPLICATOR SPEC	RESTRICTED TO
	ANGLES	FINISH		WEIGHT			
MATERIAL							
Customer Accessible Production Drawing				SCALE	1:2	SHEET	1 of 4

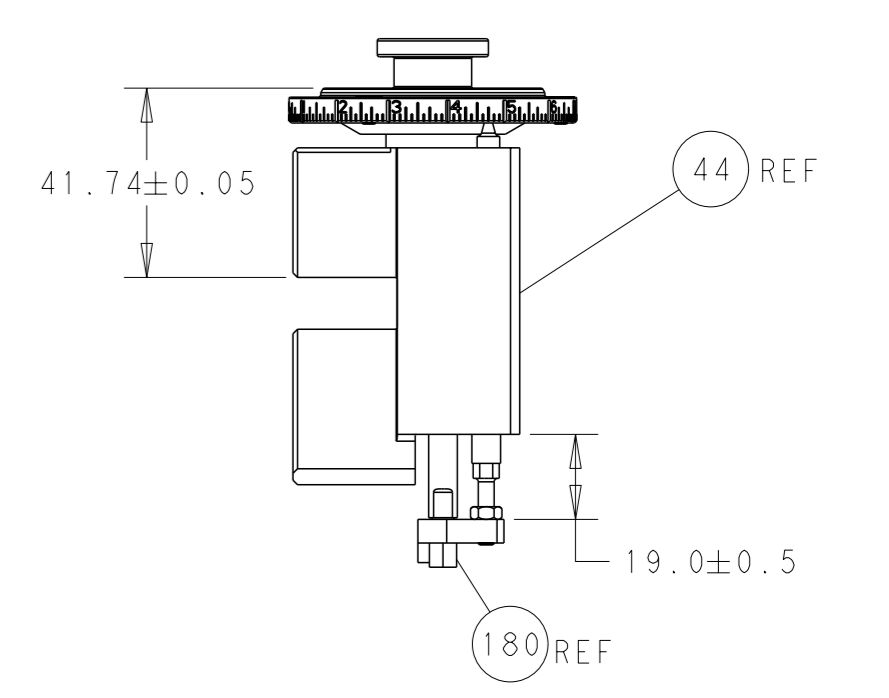
LOC		DIST		REVISIONS			
A		66		REV	DATE	OWN	APVD
-				1	SEE SHEET 1	-	-

FEED TYPE

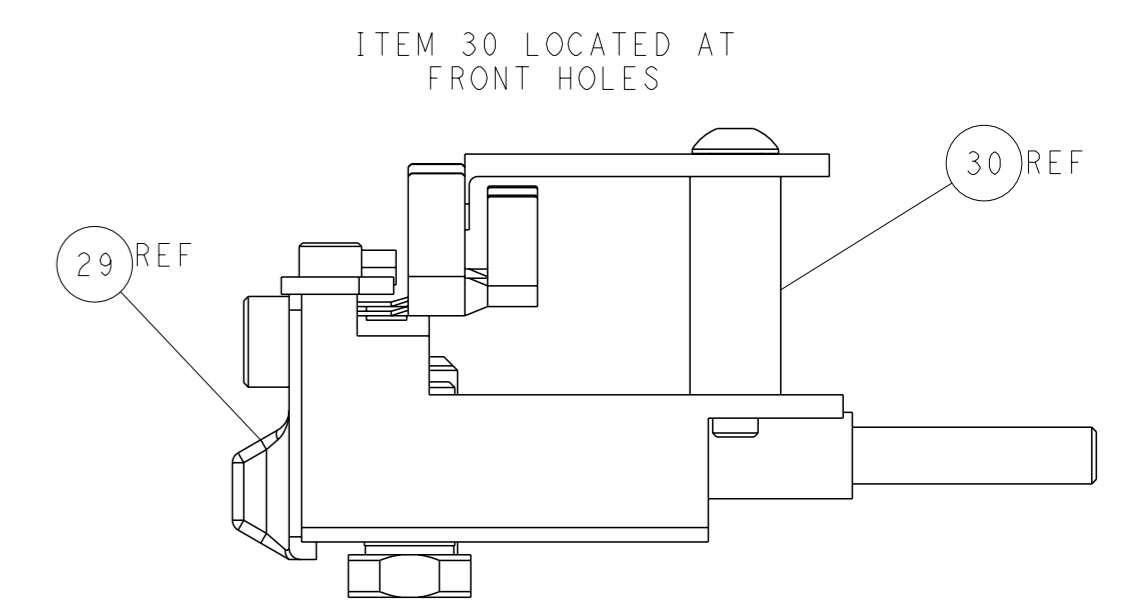
PNEUMATIC



TERMINAL SUPPORT LOCATION

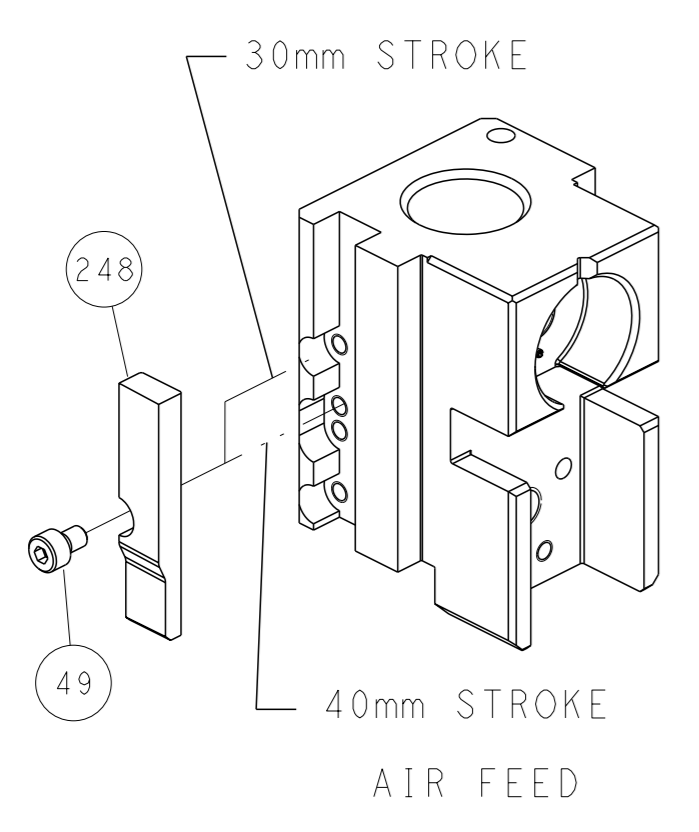


RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITION

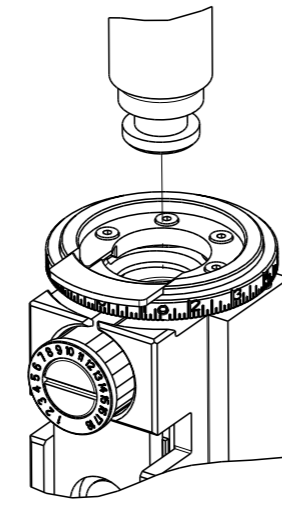


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: BOB HIGMAN 30 JUN 2015 CHK: T. ELBIN 30 JUN 2015 APVD: T. ELBIN 30 JUN 2015	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266821	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: B	Customer Accessible Production Drawing		

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266821-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266821-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



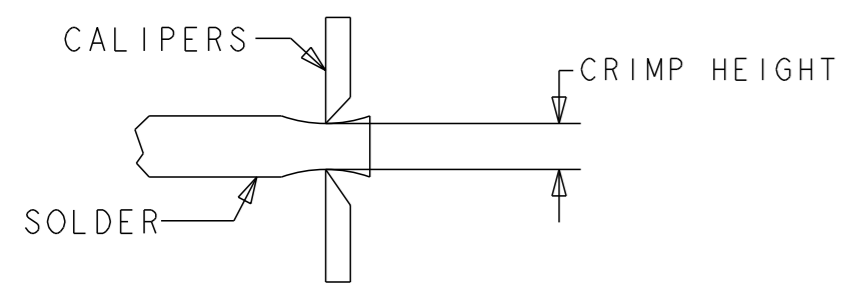
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.22 mm [.206]	0
INSUL	6.38 mm [.251]	0
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA:	TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME:	OUTTER FERRULE, 180 DEGREE, LARGE CABLE, FAKRA	
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE Ø 5.00-6.00 mm [.197-.236 IN]
TERMINAL APPLICATION SPECIFICATION	114-32145	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
2272409-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-71	5.61+/-0.00 [.221+/- .000]	2.5
RG-62	5.32+/-0.00 [.210+/- .000]	5.9
RG-59	5.32+/-0.00 [.210+/- .000]	5.9



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø .250 IN [3.18mm] 50/50 SOLID CORE) AND MEASURE AT END OF SLUG.



8 SEE APPLICATION SPECIFICATION 114-32145 FOR RECOMMENDED STRIP LENGTH DIMENSIONS.

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

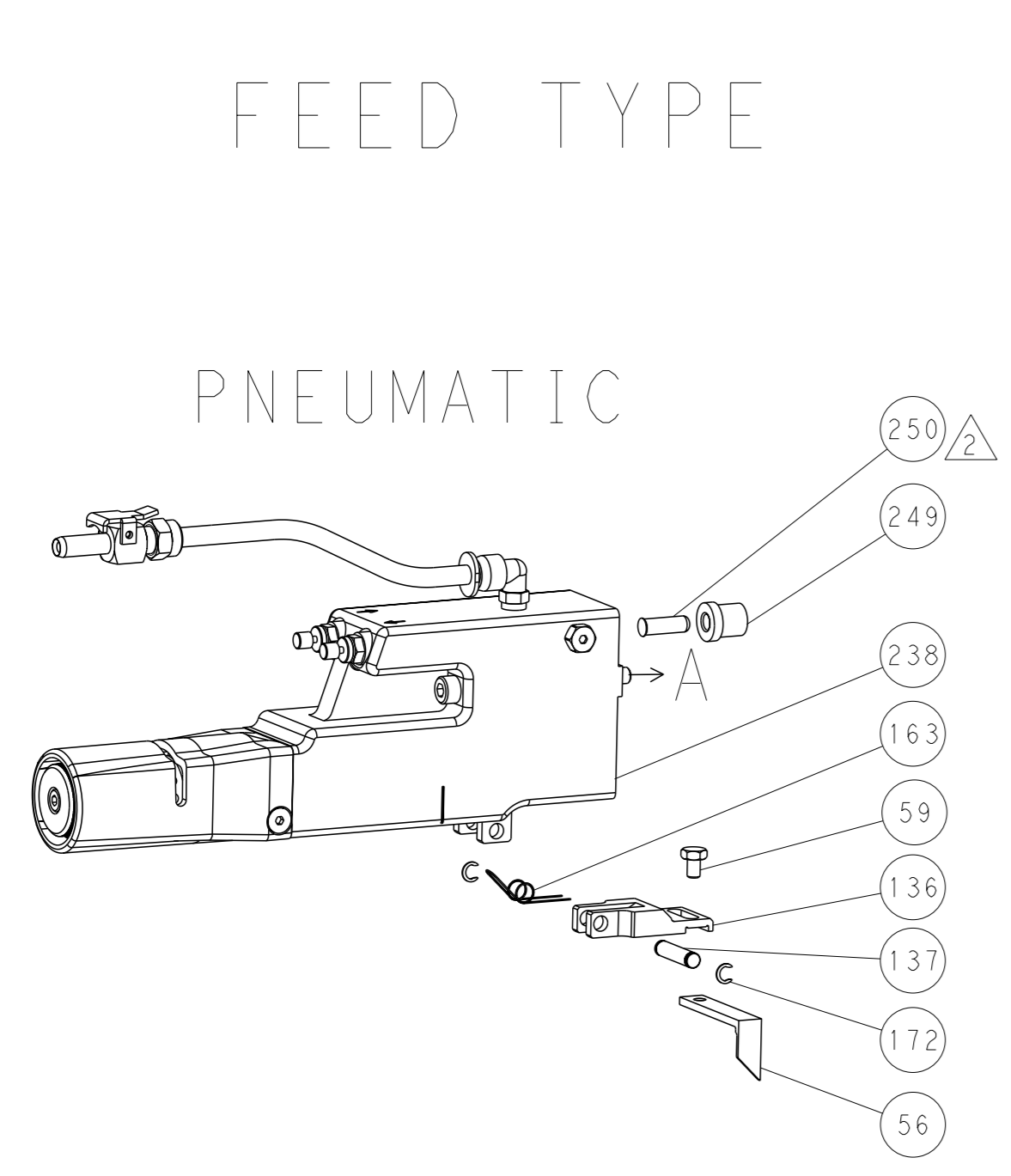
QTY	LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
-	1	1803078-3		SPACER, PRECISION			259
-	1	2119640-1		PUSH ROD, AIR FEED			250
-	1	1803259-1		BUSHING, FLANGED			249
-	1	2119082-3		CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	2079764-1		WASHER, WAVE SPRING, CREST-TO-CREST			243
3	1	2119083-1		RETAINER, INSULATION DIAL			242
-	1	7-18023-7		SCR, SKT HD CAP M3 X 4.0			241
-	1	2063440-2		AIR FEED MODULE			238
-	2	1-2079383-0		SCR, BHSC, RoHS (M3 X 6)			230
-	2	1-2168083-4		SCR, SKT HD CAP, RoHS, M4 X 5			224
-	1	1803306-1		PLATE, RETAINING			223
-	1	1803340-1		PLATE, RETAINING			222
3	1	1752354-6		STANDOFF, HOLD-DOWN			180
-	1	2-1976053-6		LOCATER BLOCK, TERMINAL			179
-	1	993111-1		PIN, SLOTTED SPRING 3.0 X 20.0			177
-	1	8-22280-7		SPRING, COMPRESSION			176
-	1	1752353-2		GUIDE PIN, HOLDDOWN			175
-	1	1901680-2		GUIDE PIN, HOLDDOWN			174
-	2	21045-3		RING, RETAIN, EXTERN, 3/16 CRESCENT			172
-	REF	994970-2		COUNTER, MAGNETIC			164
-	1	240638-1		SPRING, FEED FINGER			163
-	1	2119641-2		FEED CAM, AIR FEED			151
-	1	2168083-8		SCR, SKT HD CAP, RoHS, M4 X 16			144
-	2	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
-	1	3-23627-7		PIN, RETAIN, GRVD, 3/16 X .854			137
-	1	2119799-1		HOLDER, FEED FINGER, AF			136
-	1	2844908-1		SCREW, LOCKING			99
-	1	2844907-1		POST, LOCKING			98
-	1	318563-1		GUARD, FRONT CHIP			89
-	1	455888-5		SPACER, CRIMPER			82
-	1	1803607-1		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	1-1338683-1		FEED PAWL			56
-	1	1-5018030-0		NUT, HEX, REG, RoHS, M3.5			52
-	1	1901681-8		HOLDDOWN, TERMINAL			51
-	1	18023-9		SCR, SKT HD CAP M4 X 6.0			49
-	1	1803602-2		SCR, BHSC, RoHS (M8 X 40)			41
-	2	2079383-4		SCR, BHSC, RoHS (M4 X 8)			36
-	1	1803308-4		SUPPORT, TERMINAL			34
-	2	1-2079383-3		SCR, BHSC, RoHS (M4 X 25)			33
-	2	4-2844962-6		SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	2844992-1		ASSEMBLY, STRIP GUIDE			29
-	1	455888-5		SPACER, CRIMPER			28
-	1	1320928-2		STRIP GUIDE			24
-	2	2168400-1		SHCS, LOW HEAD, RoHS, M4 X 12			18
1	1	2119806-1		INSERT, SHEAR			13
-	1	3-22280-3		SPRING, COMPRESSION			12
-	1	1-356885-3		STOP, SHEAR			11
1	1	2119805-1		SHEAR HOLDER, FRONT			10
1	1	1803095-1		FLOATING SHEAR, FRONT			9
1	1	4-1803055-0		ANVIL, COMBINATION			8
-	-	-		-			7
-	-	-		-			6
-	1	1-2119757-5		DEPRESSOR, SHEAR			5
-	1	4-238011-4		BLOCK, CRIMPER SPACER			4
1	1	5-1633966-2		CRIMPER, INSULATION O			3
-	1	455888-6		SPACER, CRIMPER			2
1	1	2-1633723-1		CRIMPER, WIRE O			1
-77	-22	PART NO		DESCRIPTION			ITEM NO

<small>THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE CUSTOMER IS ADVISED THAT THE DRAWING INFORMATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: BOB HIGMAN 30JUN2015 CHK: T. ELBIN 30JUN2015 APVD: T. ELBIN 30JUN2015	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266821 SCALE: 1:2 SHEET: 3 of 4 REV: B
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	APPLICATION SPEC: - WEIGHT: - RESTRICTED TO: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

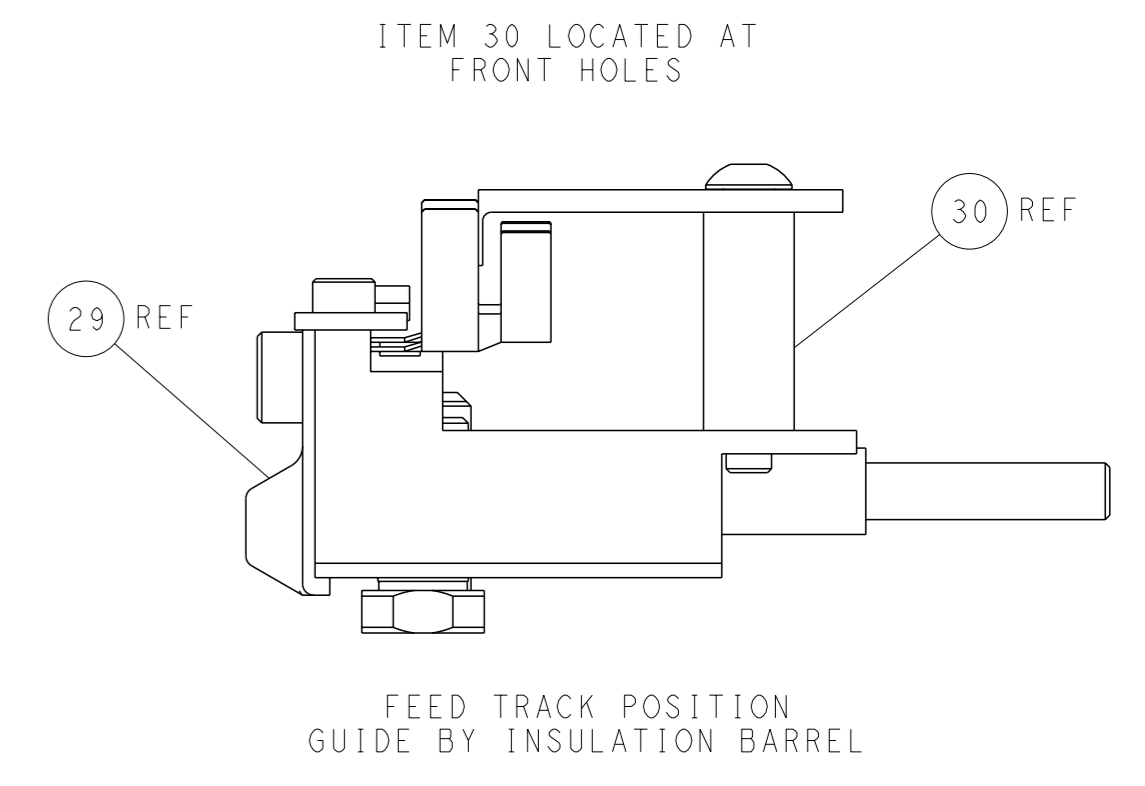
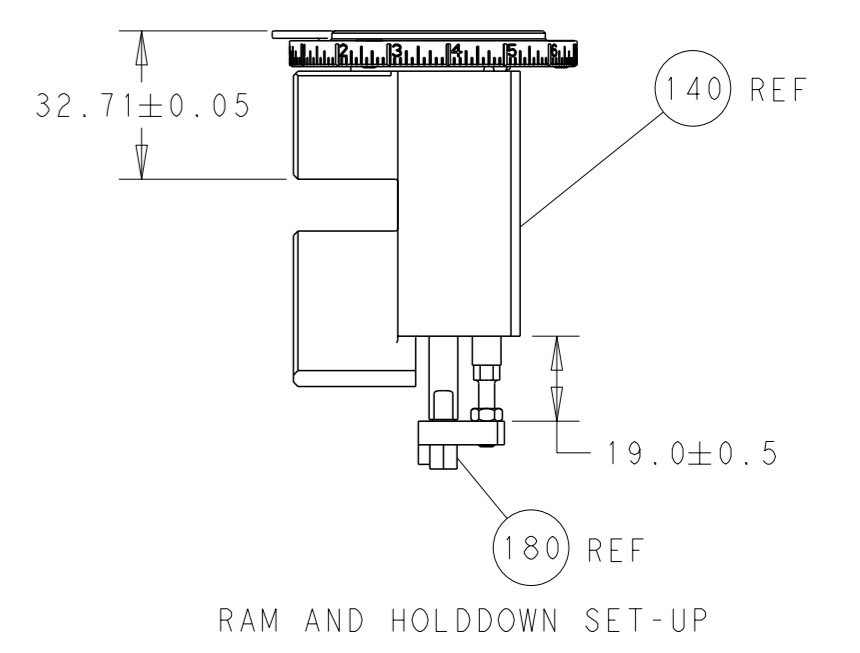
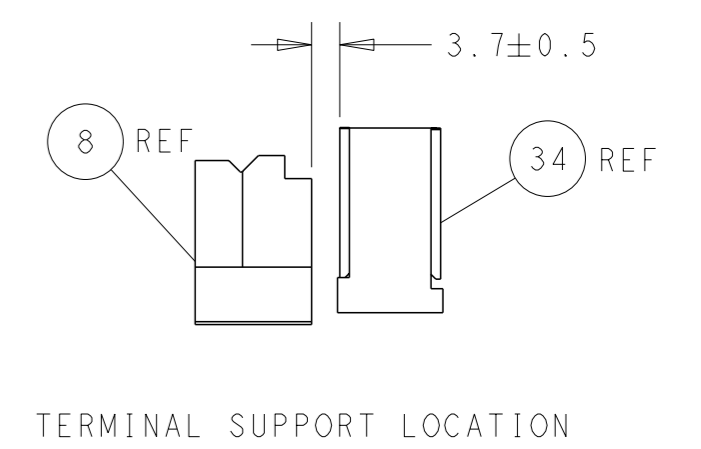
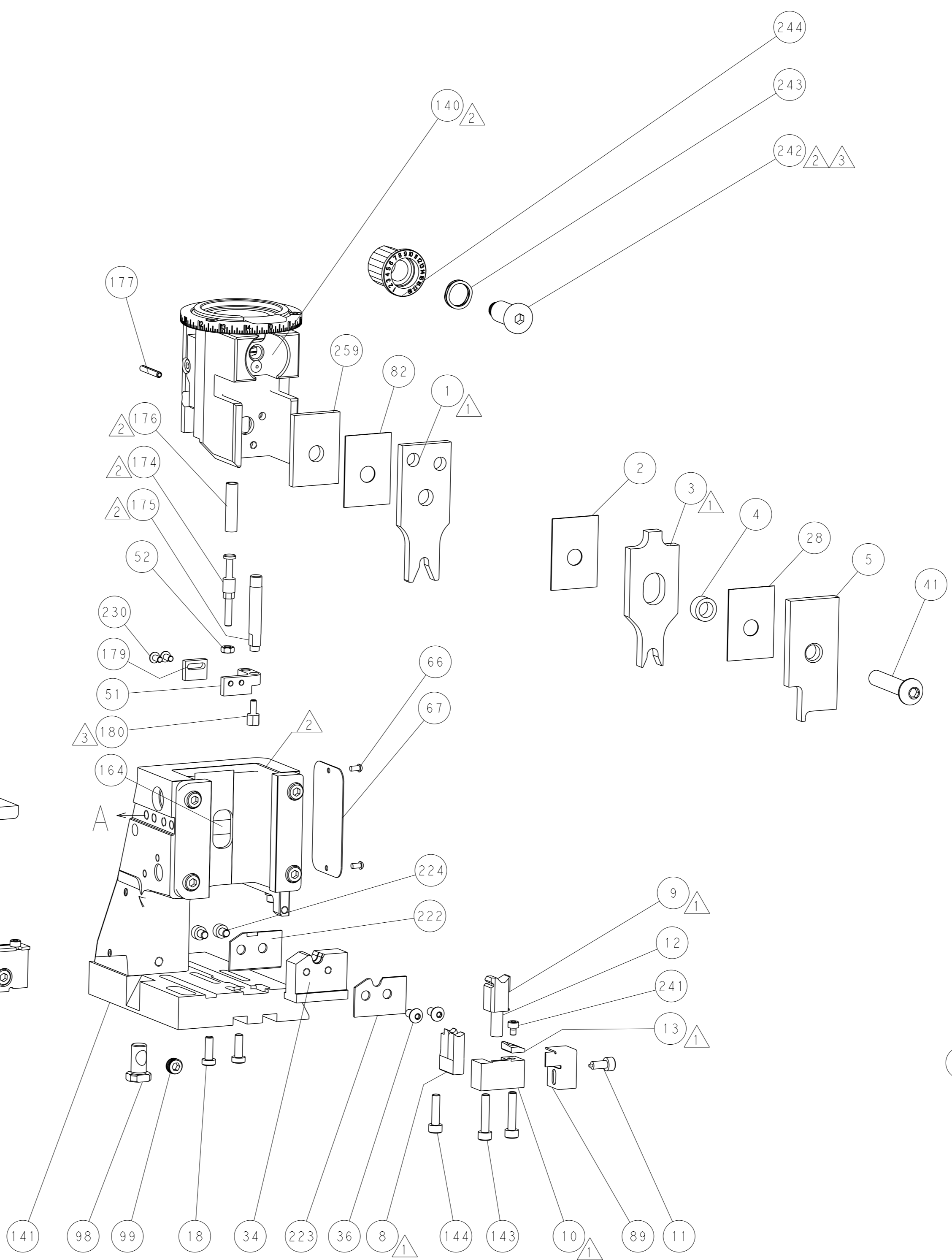
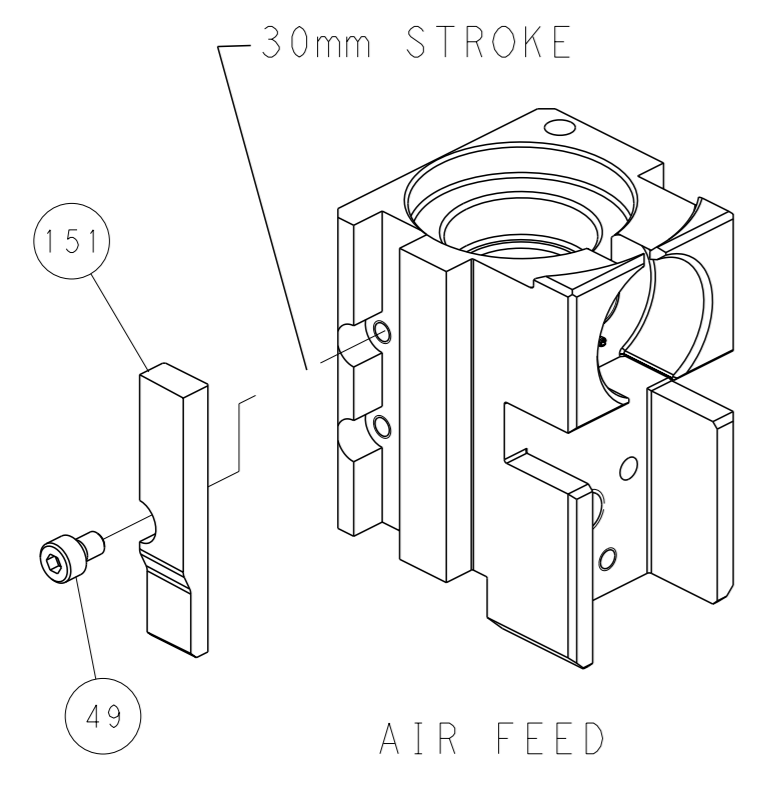
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC



CAM POSITION



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 FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN BOB HIGMAN 30JUN2015 CHK T. ELBIN 30JUN2015 APVD T. ELBIN 30JUN2015	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 APPLICATION SPEC PRODUCT SPEC	SIZE A1 CAGE CODE 00779 DRAWING NO. C=2266821 RESTRICTED TO
MATERIAL:		WEIGHT:	SCALE 1:2 SHEET 4 OF 4 REV B