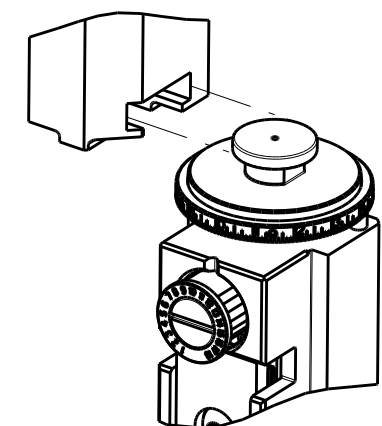


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266171-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266171-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266171-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

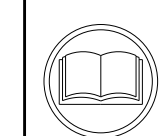


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.61 mm [.142]	○
INSUL	3.89 mm [.153]	○

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: OUTER FERRULE, 180 DEGREE, FAKRA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	∅ 3.10-3.50 mm [.122-.138 IN]
TERMINAL APPLICATION SPECIFICATION	114-32145		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2203259-3	2203259-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2DS-PPFW(TA)	4.13+/-0.03 [.163+/- .001]	3.5
RTK-031	3.47+/-0.05 [.137+/- .002]	10.0
DACAR 302	3.43+/-0.05 [.135+/- .002]	10.5



- △ 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
  - △ 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
  - △ SEE APPLICATION SPECIFICATION 114-32145 FOR RECOMMENDED STRIP LENGTH DIMENSIONS.
  - △ SEE APPLICATION SPECIFICATION 114-32145 FOR SOLDER DIAMETER TO VERIFY BRAID CRIMP HEIGHT.
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	DWN	APVD
		B1		ECR-18-000468	11JAN2018	KH	TE
		C		ECR-18-007829	22MAY2018	MEH	JDG
		C1		ECR-19-000528	11JAN2019	TB	GB
		D		ECR-19-009113	11JUN2019	FJ	TE

-	1	1	1803078-3	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
△	-	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	
-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	224	
-	1	1	1803340-1	PLATE, RETAINING	222	
△	-	1	1752354-6	STANDOFF, HOLD-DOWN	180	
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	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	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1	1-455888-0	SPACER, CRIMPER	82	
-	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	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	53	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1901681-8	HOLDDOWN, TERMINAL	51	
-	1	1	2-1976053-6	LOCATER BLOCK, TERMINAL	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	1803308-1	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	3-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1320928-2	STRIP GUIDE	24	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	16	
-	1	1	1803306-1	PLATE, RETAINING	15	
△	-	1	2119806-1	INSERT, SHEAR	13	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
△	-	1	2119805-1	SHEAR HOLDER, FRONT	10	
△	-	1	1803095-1	FLOATING SHEAR, FRONT	9	
△	1	2	1	3-1633928-9	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4	
△	1	2	1	3-1633996-2	CRIMPER, INSULATION SPECIAL	3
-	1	1	1-455888-8	SPACER, CRIMPER	2	
△	1	2	1	2-1633723-3	CRIMPER, WIRE O	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL				WEIGHT		SCALE	
-				-		1:2	

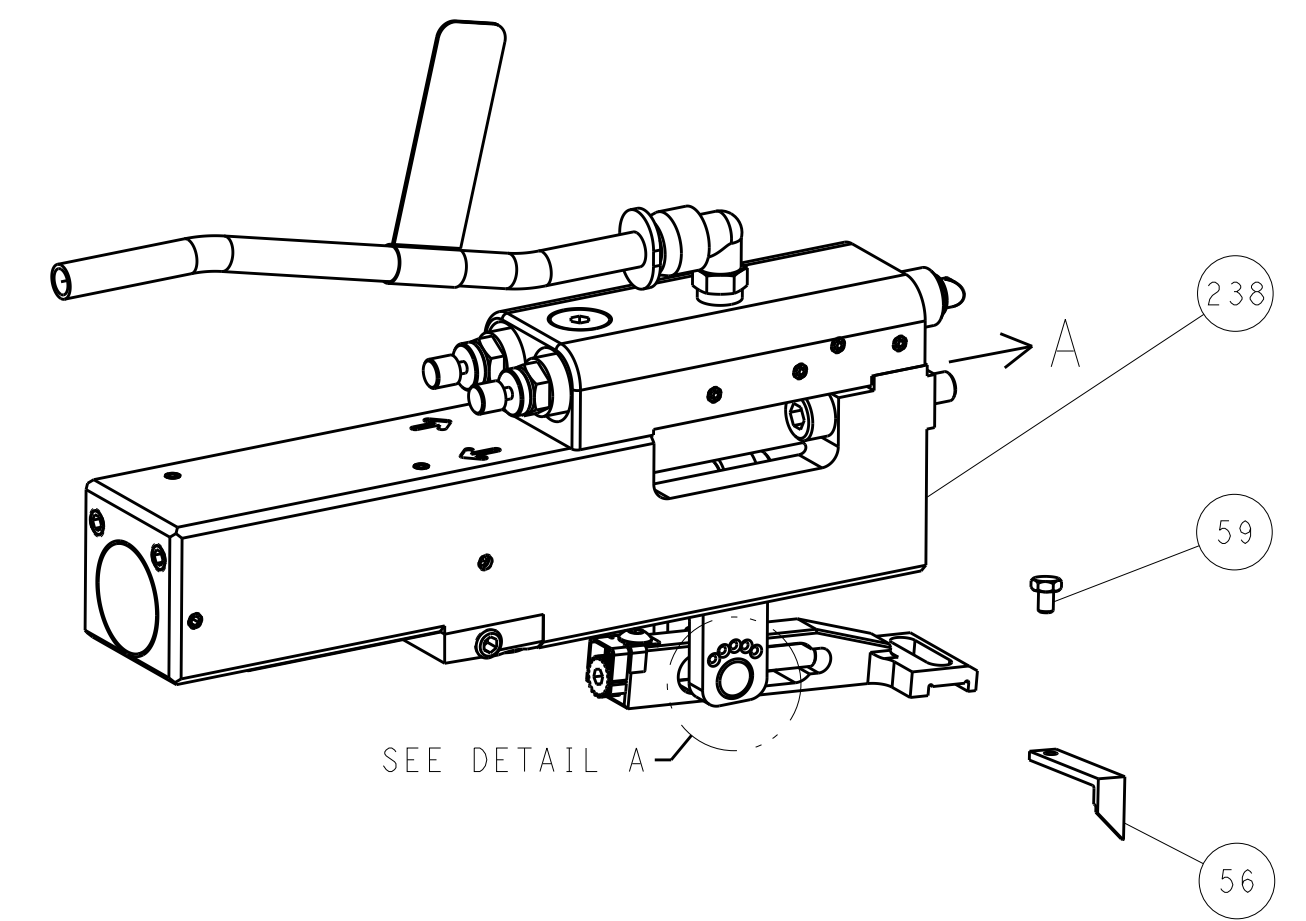
OWN	CHK	APVD	NAME	SIZE	CAGE CODE	DRAWING NO	SHEET	OF	REV
R. O. WILSON	K. J. STAKEM	T. L. ELBIN	Ocean Side Feed Applicator	A1	00779	22NOV2013	1	4	D

Customer Accessible Production Drawing

LOC		DIST		REVISONS			
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1	-	-	-

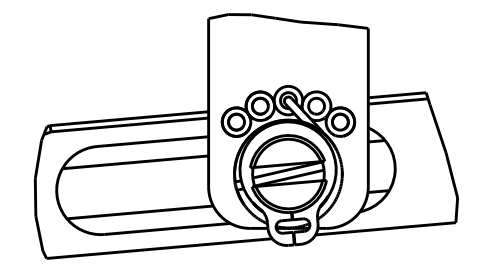
# FEED TYPE

## PNEUMATIC



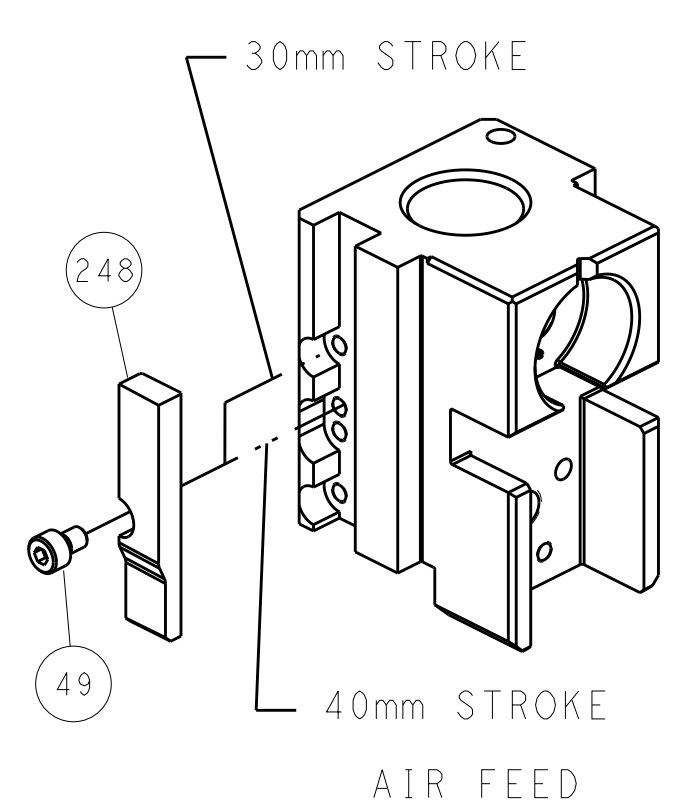
SEE DETAIL A

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

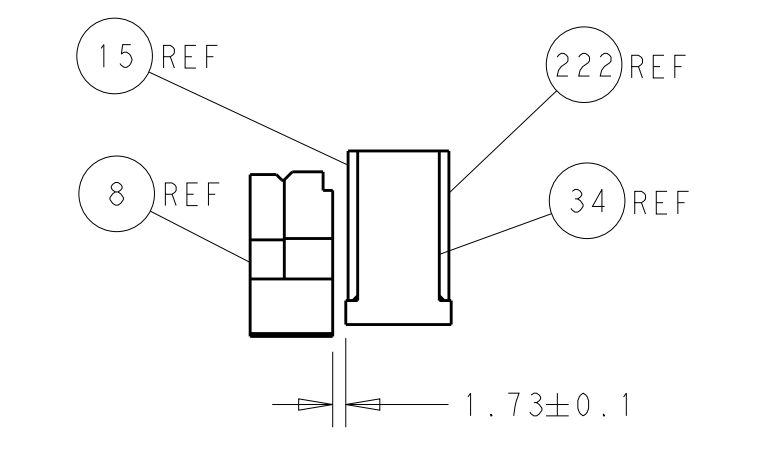
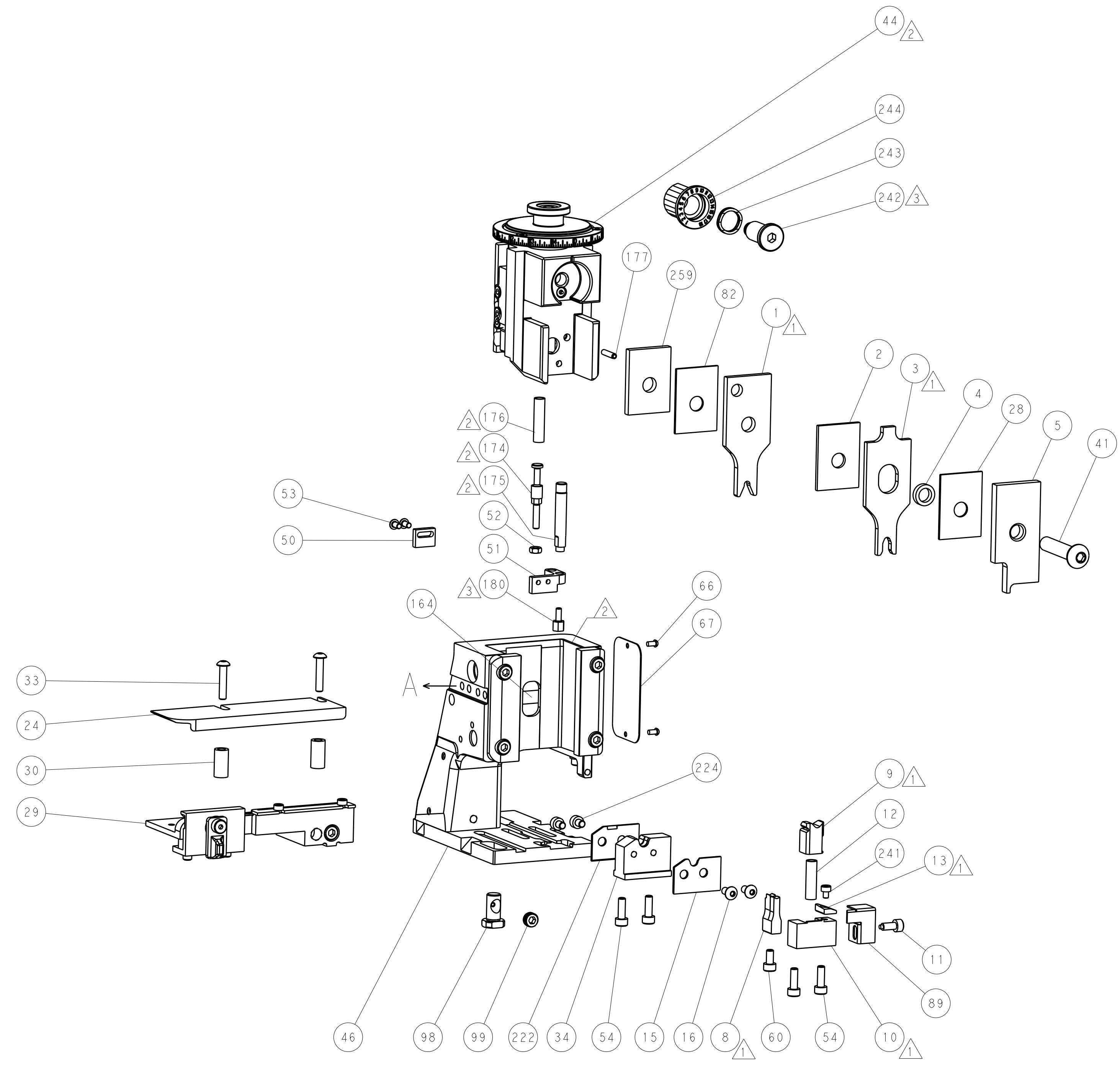


DETAIL A

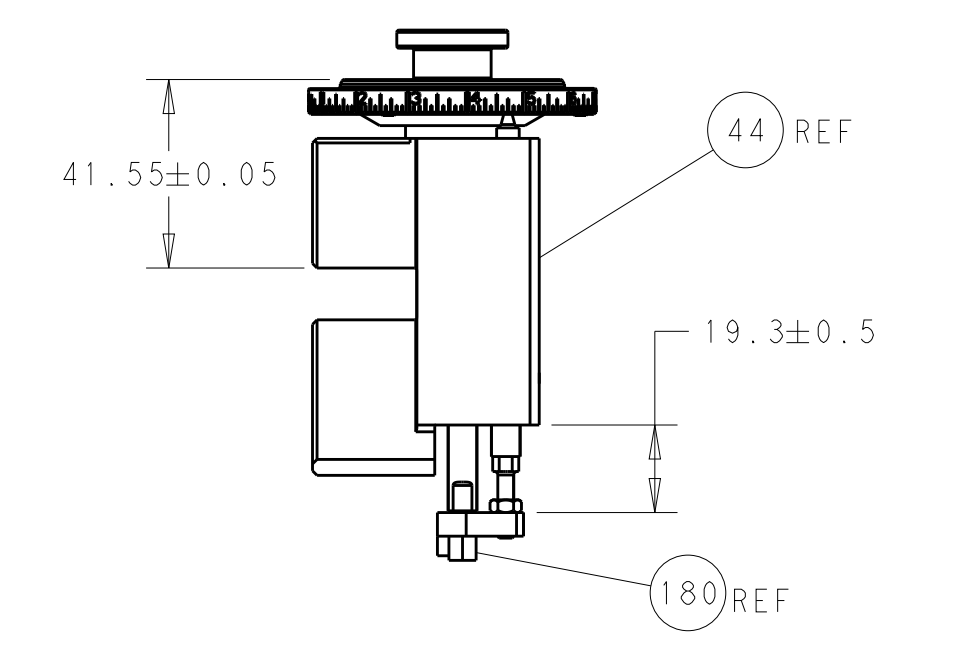
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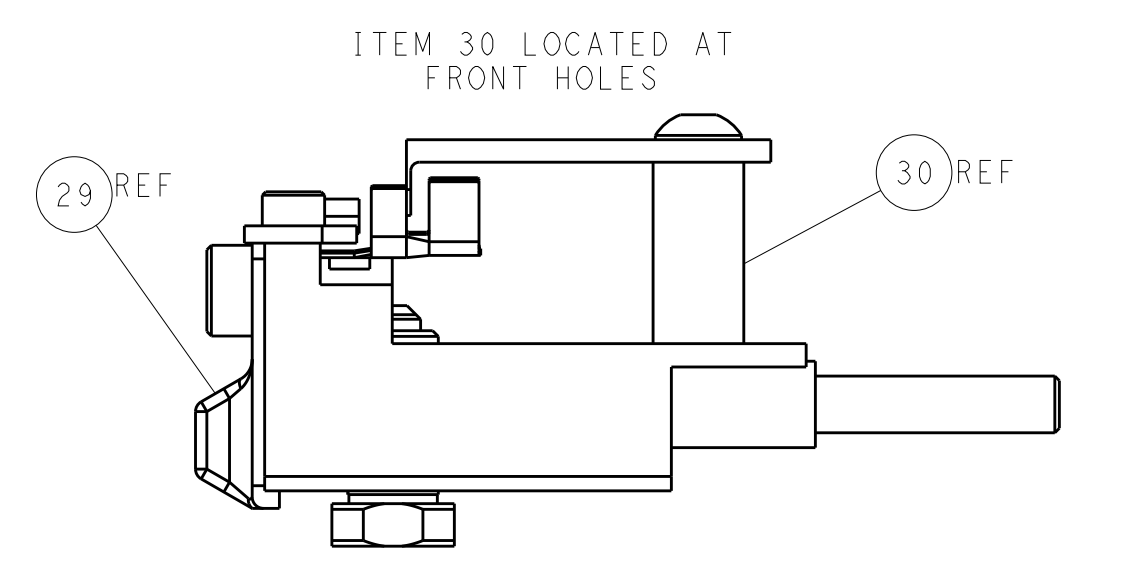
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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:		DWG: R.O. WILSON 22NOV2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: T.L. ELBIN 22NOV2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 2 OF 4		REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266171-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266171-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.61 mm [.142]	Ø
INSUL	3.89 mm [.153]	Ø

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: OUTER FERRULE, 180 DEGREE, FAKRA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6	114-32145	Ø 3.10-3.50 mm [.122-.138 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED 5			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2203259-3	2203259-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2DS-PPFW(TA)	4.13+/-0.03 [.163+/-0.001]	3.5
RTK-031	3.47+/-0.05 [.137+/-0.002]	10.0
DACAR 302	3.43+/-0.05 [.135+/-0.002]	10.5

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 SEE APPLICATION SPECIFICATION 114-32145 FOR RECOMMENDED STRIP LENGTH DIMENSIONS.
- 7 SEE APPLICATION SPECIFICATION 114-32145 FOR SOLDER DIAMETER TO VERIFY BRAID CRIMP HEIGHT.
- 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.

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	DATE	BY	APPV
A	66				

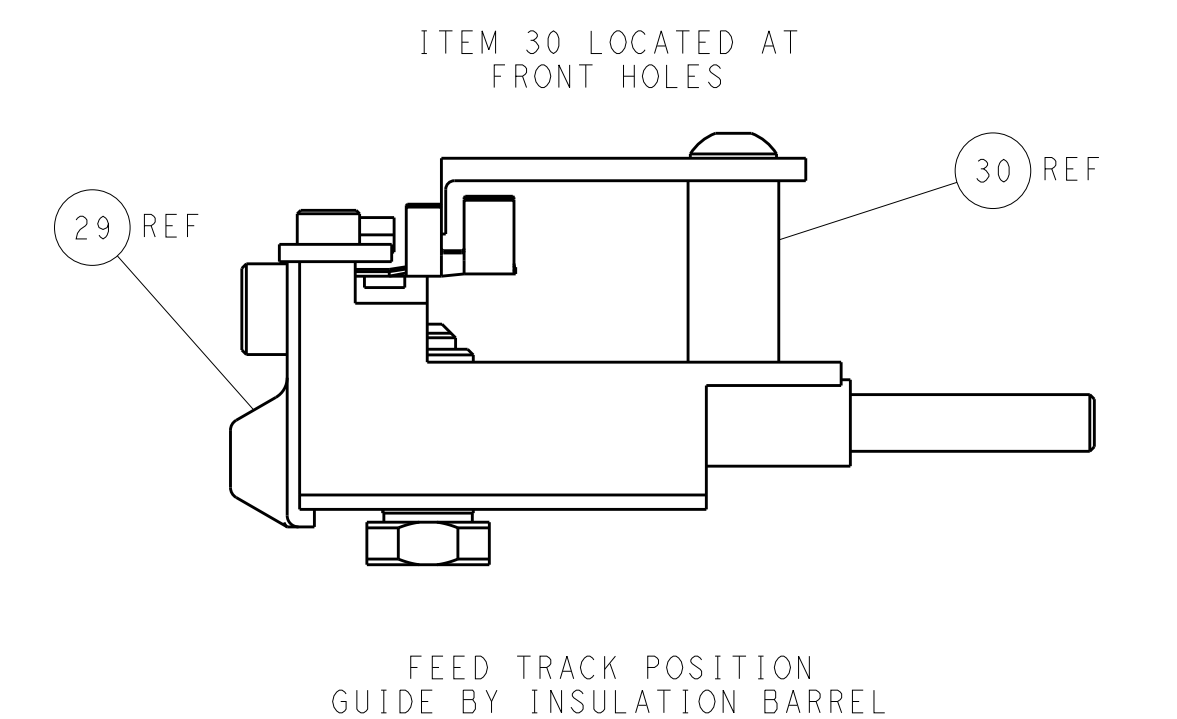
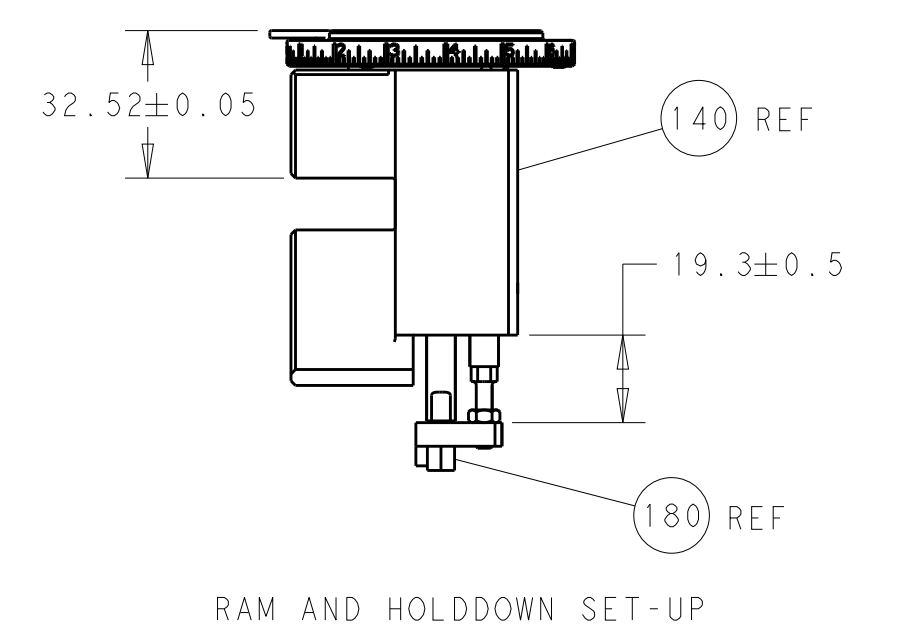
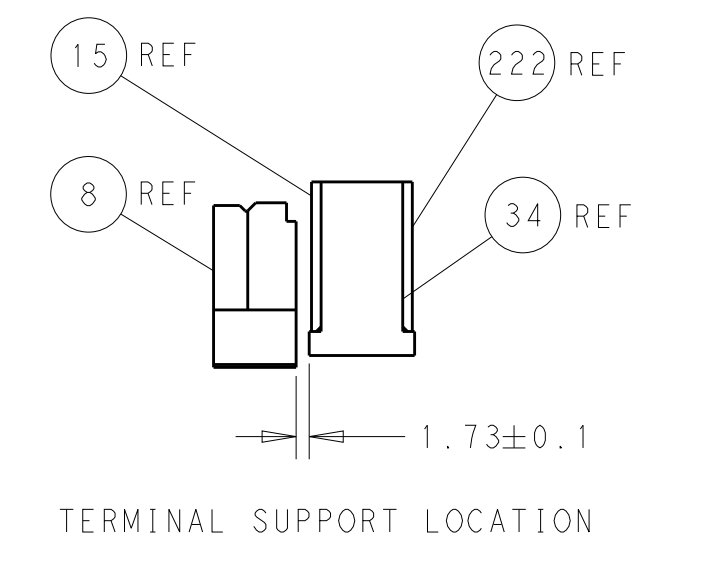
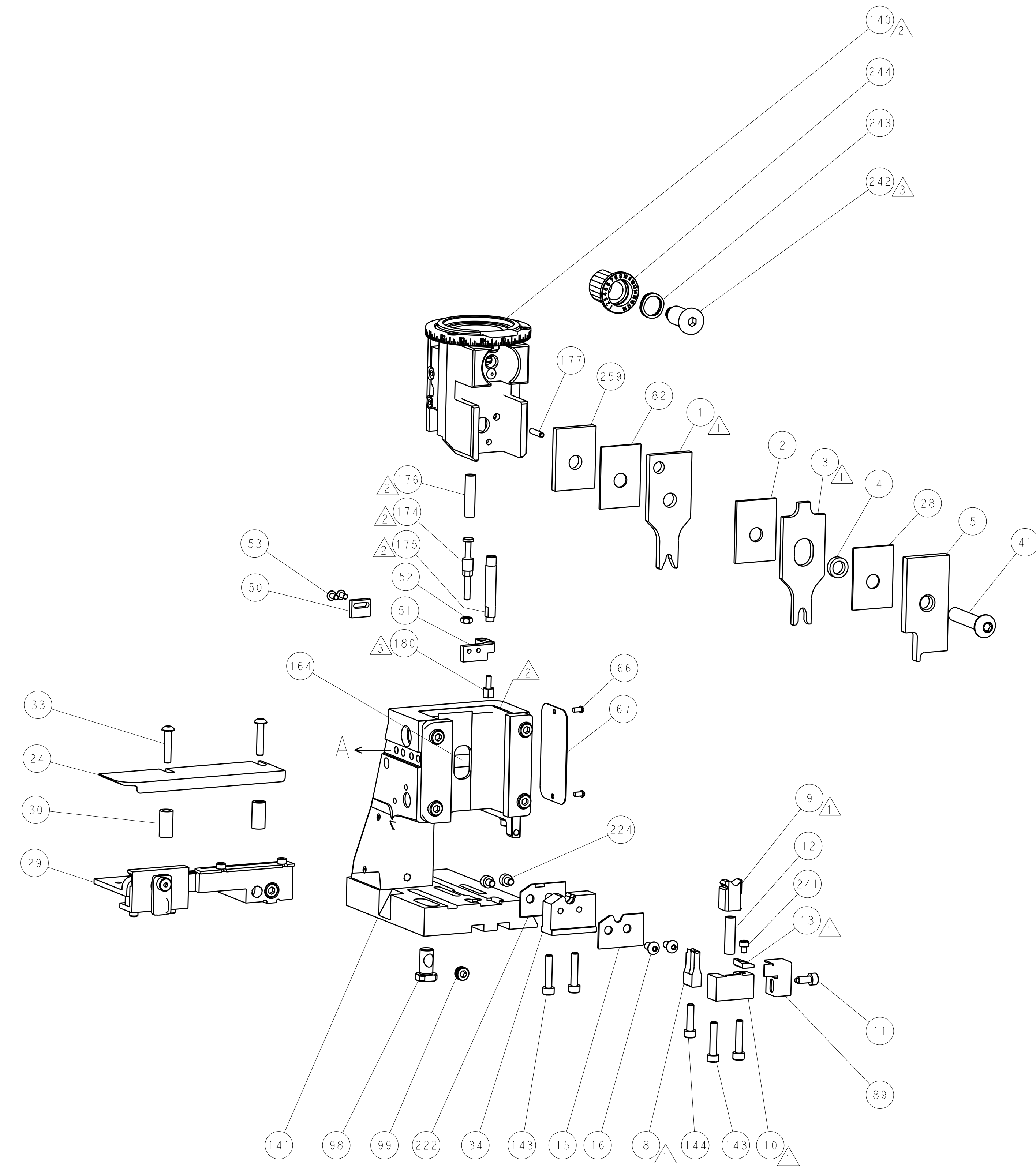
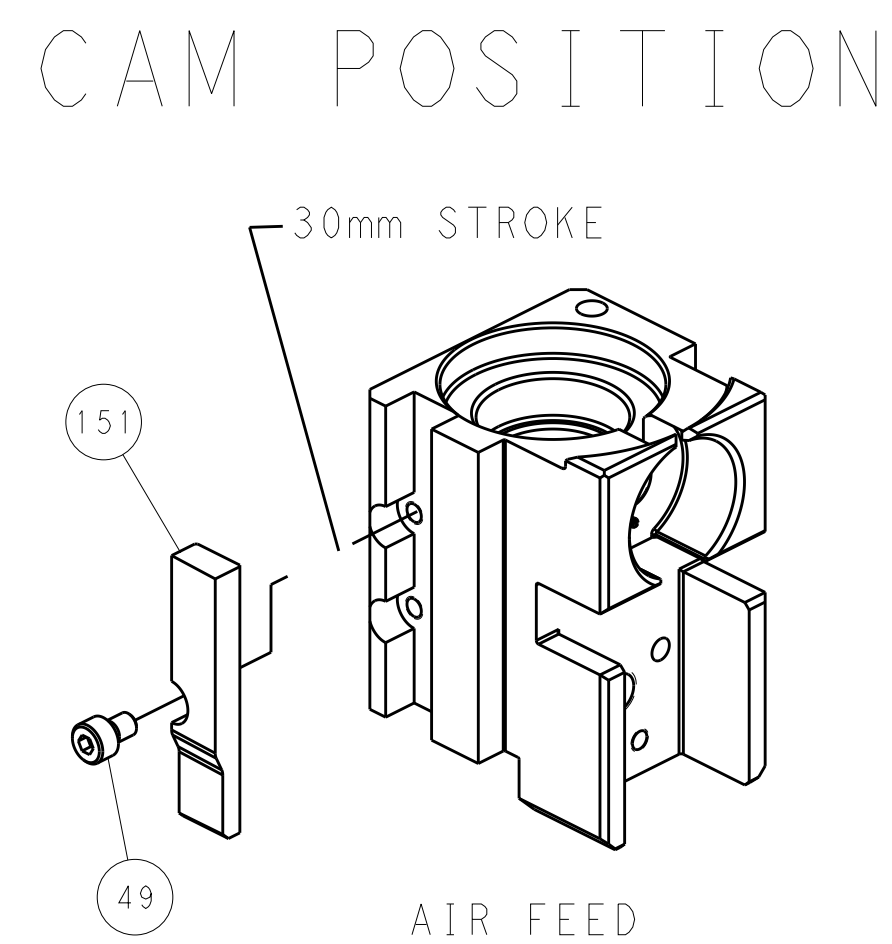
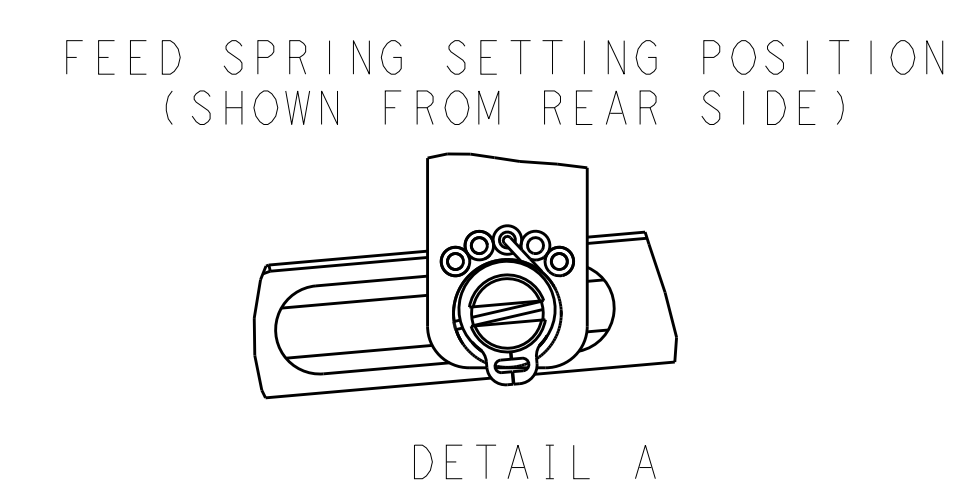
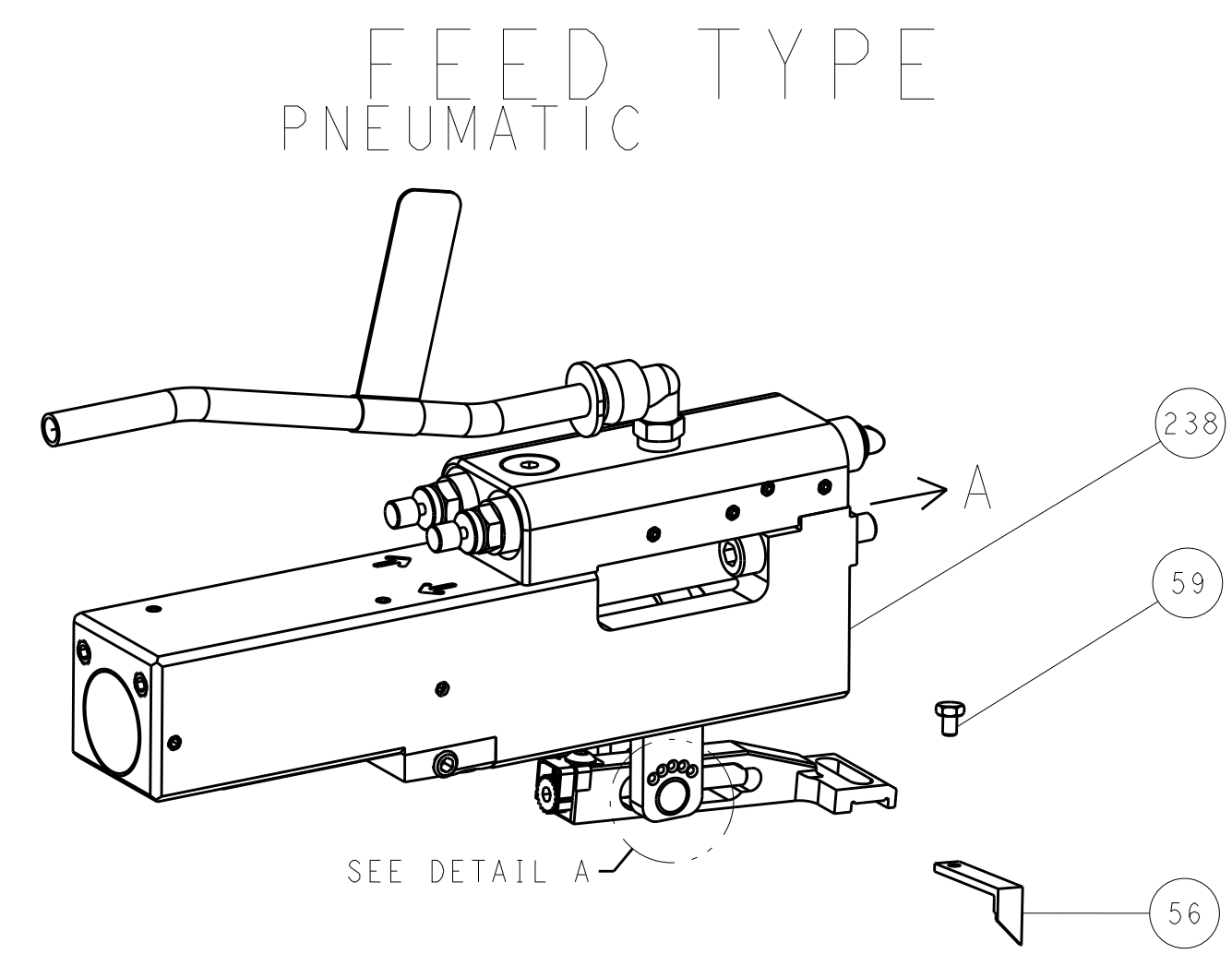
REVISIONS					
REV	DATE	DESCRIPTION	BY	APPV	
		SEE SHEET 1			
-	1	1803078-3	SPACER, PRECISION	259	
-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	2844940-1	AIR FEED MODULE	238	
-	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	224	
-	1	1803340-1	PLATE, RETAINING	222	
3	-	1	1752354-6	STANDOFF,HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN,HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN,HOLDDOWN	174	
-	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	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1-455888-0	SPACER, CRIMPER	82	
-	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	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	53	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1901681-8	HOLDDOWN, TERMINAL	51	
-	1	2-1976053-6	LOCATER BLOCK, TERMINAL	50	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1803308-1	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	3-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1320928-2	STRIP GUIDE	24	
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	16	
-	1	1803306-1	PLATE, RETAINING	15	
1	-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1-356885-4	STOP, SHEAR	11	
1	-	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	3-1633928-9	ANVIL, COMBINATION	8
-	-	-	-	7	
-	-	-	-	6	
-	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	3-238011-8	BLOCK, CRIMPER SPACER	4	
1	1	1	3-1633996-2	CRIMPER, INSULATION SPECIAL	3
-	1	1-455888-8	SPACER, CRIMPER	2	
1	1	1	2-1633723-3	CRIMPER, WIRE O	1

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

OWN	R. O. WILSON	22NOV2013
CHK	K. J. STAKEM	22NOV2013
APPV	T. L. ELBIN	22NOV2013
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266171
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 3 OF 4
REV	D	

LOC	DIST	REV	DATE	BY	APP'D
A	66				

REVISIONS			
NO.	DESCRIPTION	DATE	BY
1	SEE SHEET 1		



**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:		DWG: R.O. WILSON 22NOV2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: T.L. ELBIN 22NOV2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 4 OF 4		REV D	