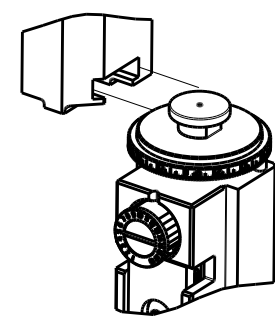


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266571-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266571-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266571-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

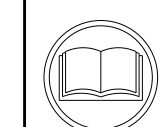


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.52-6.28 mm [.217-.247 IN]		Ø1.52-3.81 mm [.060-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2126		
TERMINALS APPLIED Δ 5 Δ 6			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63316-5	63316-7		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.80 +/- 0.05 [.071 +/- .002]	8.5
16 AWG	1.60 +/- 0.05 [.063 +/- .002]	10.5
18 AWG	1.45 +/- 0.05 [.057 +/- .002]	12.3



- Δ RECOMMENDED SPARE PARTS
 - Δ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - Δ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
 - Δ 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.
 - Δ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - Δ TERMINAL LUBRICANT IS RECOMMENDED.
7. 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	REV	DATE	BY	CHK
		D	18JAN2019	JAH	GB
		E	31OCT2019	FJ	TE
		F	19OCT2019	FZ	TE
		G	17JAN2020	MZ	RK

-	1	1	23238-1	INSERT, COUPLING	278	
-	1	1	2030758-3	TUBING, POLYURETHANE	277	
-	1	1	18030-2	NUT, HEX, REG M4	276	
-	1	1	986220-3	CLAMP, CABLE, BLACK	275	
-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	274	
-	1	1	2217068-1	BRACKET, AIR BLAST	273	
-	1	1	2-1803012-7	PLATE, REAR SHEAR	272	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1633782-8	FENCE	267	
-	1	1	455888-3	SPACER, CRIMPER	259	
-	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	
Δ	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-1	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	143	
-	1	1	455888-3	SPACER, CRIMPER	128	
-	1	1	1-22281-8	SPRING, COMPRESSION	121	
Δ	1	1	455888-3	SPACER, CRIMPER	120	
-	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	4-690712-0	FRONT STRIP GUIDE	96	
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95	
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	3-455888-7	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	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	62	
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	1-1338683-5	FEED PAWL	56	
-	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	1803245-1	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	2844938-1	PLATE, STRIP GUIDE	29	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	6-690754-8	DRAG, SPECIAL	25	
-	1	1	1320928-6	STRIP GUIDE	24	
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	6	6	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1-2119533-1	STRIPPER, SIDE FEED	19	
Δ	1	1	1-853721-7	BLADE, SLUG	10	
Δ	1	1	3-853720-7	BLADE, SLUG	9	
Δ	1	2	1803161-2	ANVIL, COMBINATION	8	
-	-	-	-	-	6	
-	1	1	238009-3	BLOCK, FL CRIMPER SPACER	4	
Δ	1	2	1	4-1633966-2	CRIMPER, INSULATION O	3
-	1	1	455888-3	SPACER, CRIMPER	2	
Δ	1	2	1	6-1803224-2	CRIMPER, WIRE	1

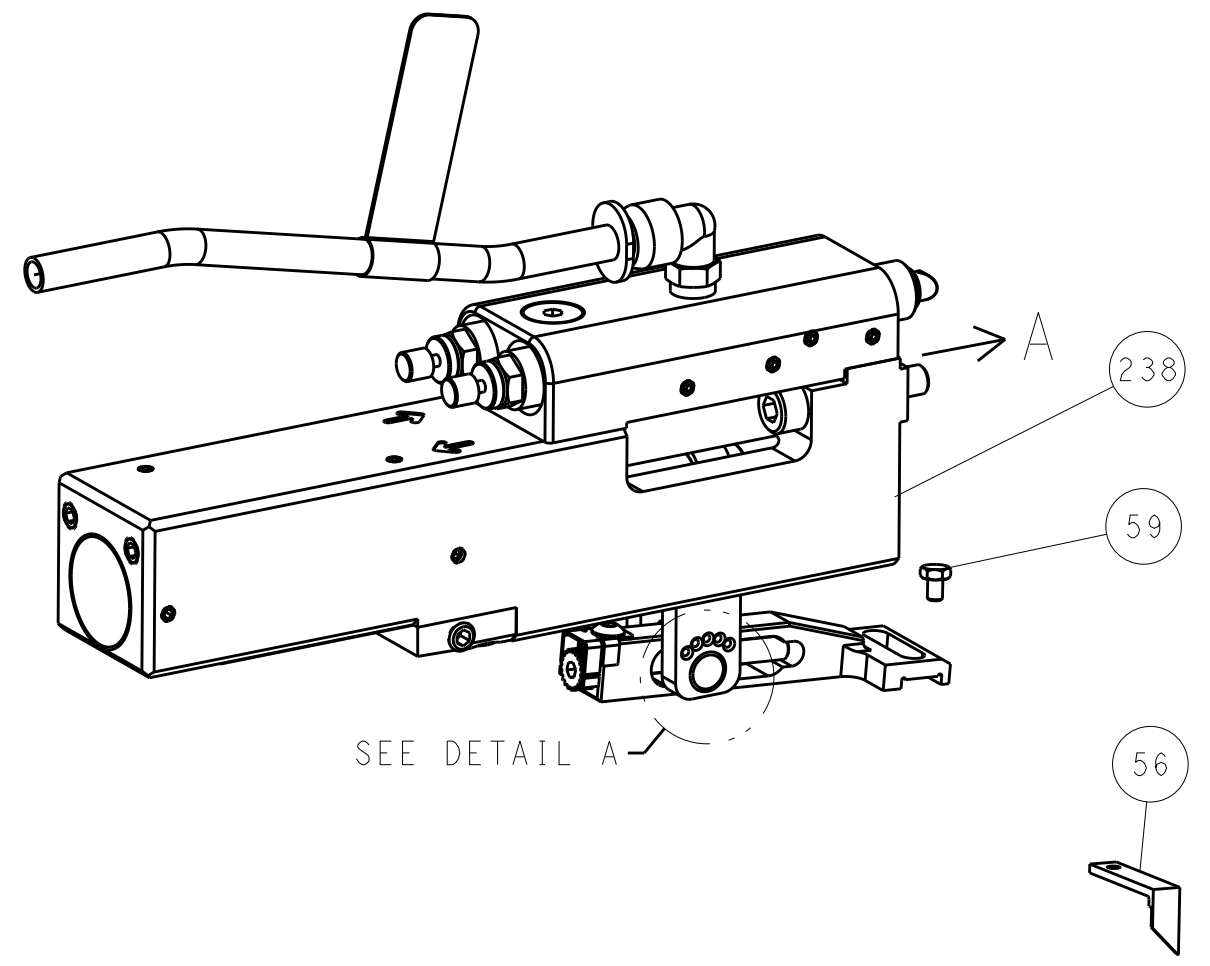
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mm	0 PLC	±					
	1 PLC	±					
	2 PLC	±					
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					

OWN	CHK	APVD	DATE	NAME	DATE
JR. STAKEM	G. BAILEY	T. ELBIN	19NOV2014	TE Connectivity	19NOV2014
G. BAILEY			19NOV2014	Harrisburg, PA 17105-3608	
T. ELBIN			19NOV2014	Ocean Side Feed Applicator	
G. BAILEY			19NOV2014	Customer Accessible Production Drawing	

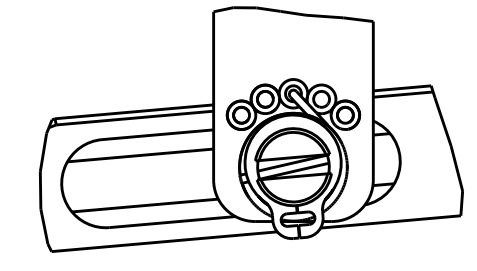
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266571	
SCALE	SHEET	OF	REV
1:2	1	4	G

LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC

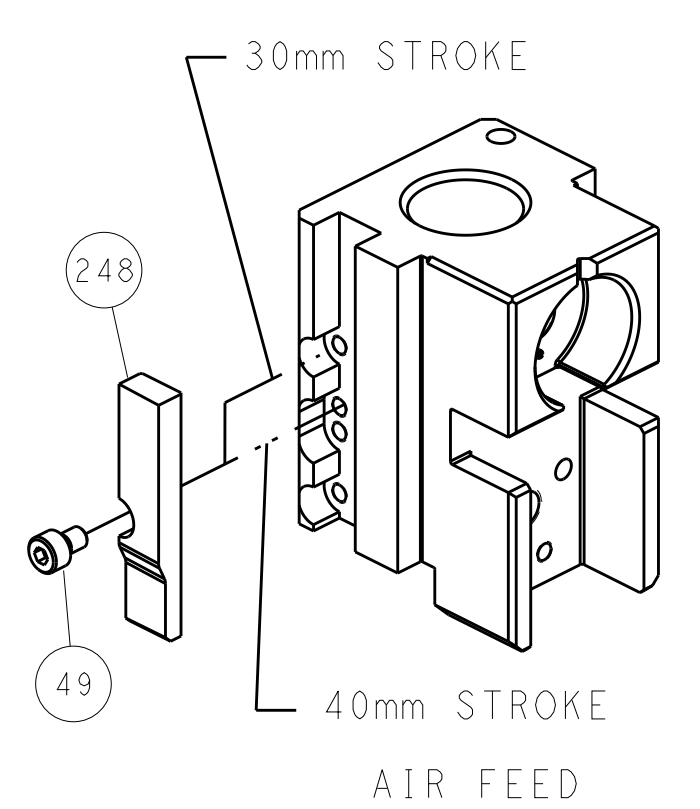


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

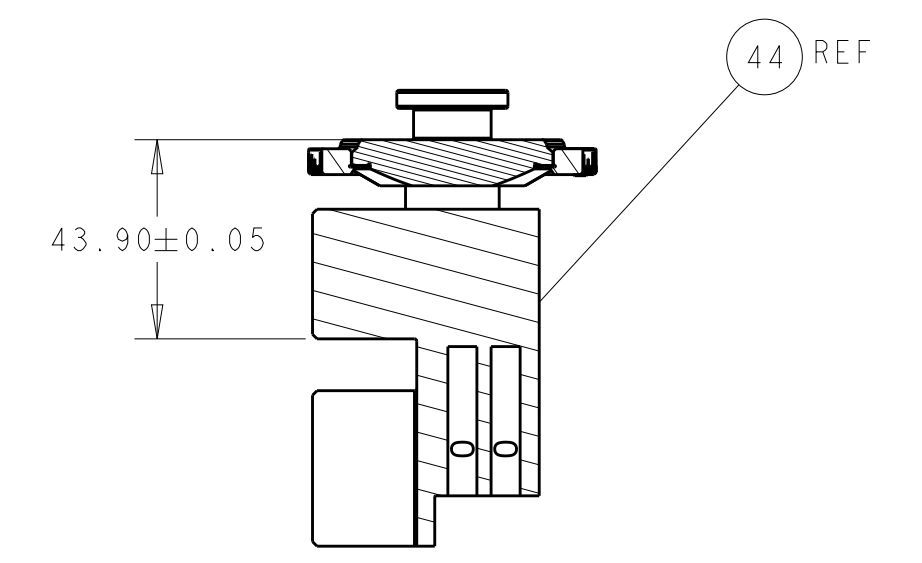
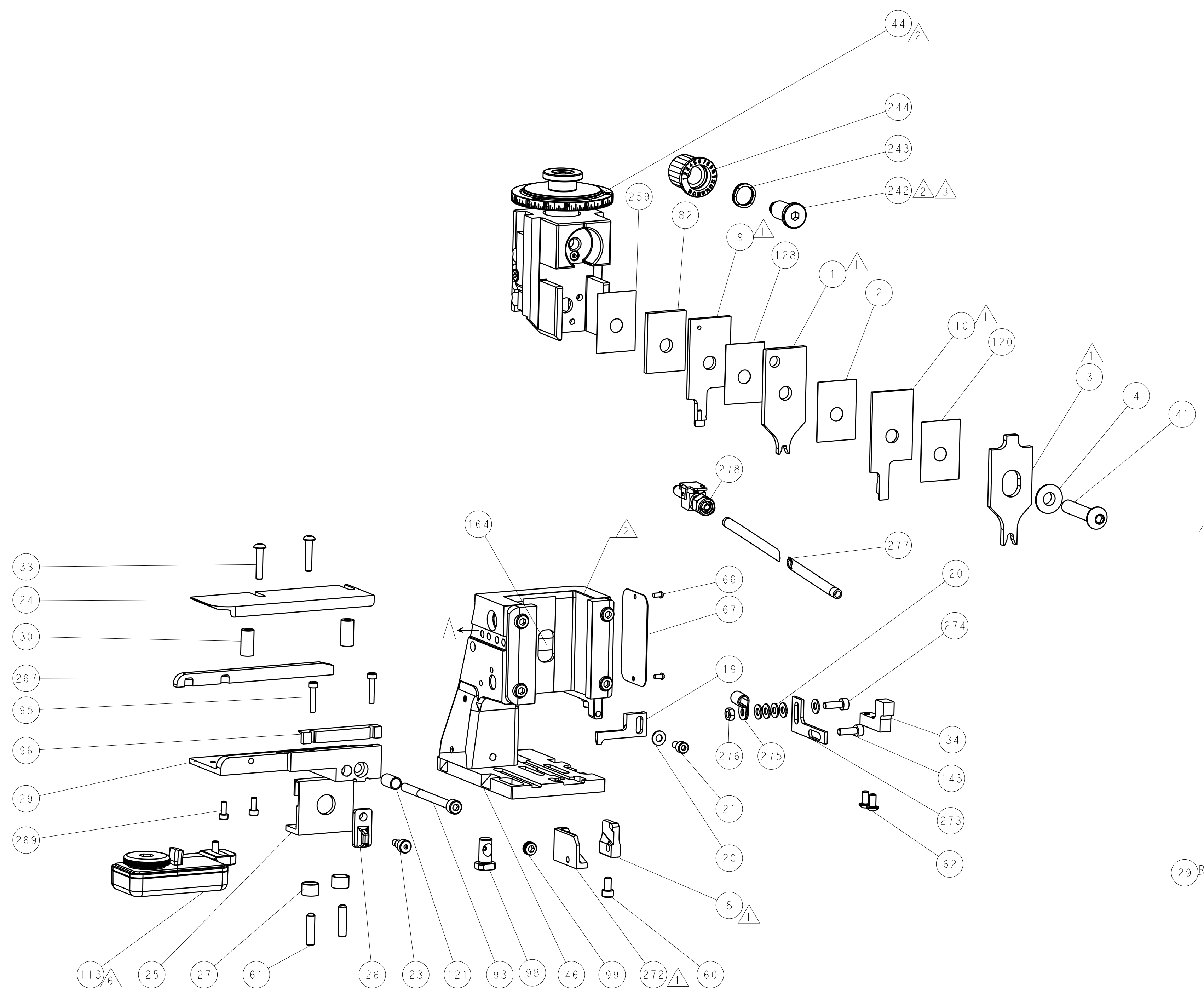


DETAIL A

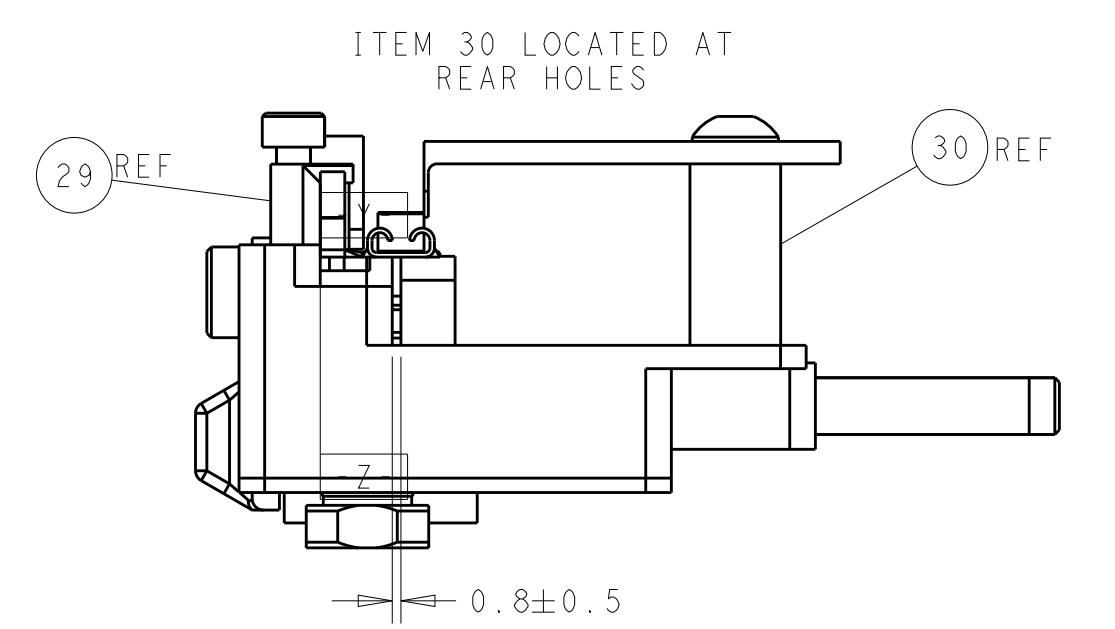
CAM POSITION



AIR FEED



RAM SET-UP



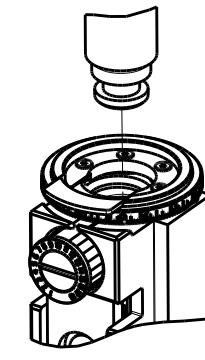
FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

<small>THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS LOANED TO YOUR ORGANIZATION UNDER THE PROVISIONS OF A LICENSE. IT IS TO BE CONTROLLED AND NOT REPRODUCED OR DISSEMINATED OUTSIDE YOUR ORGANIZATION WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: R. STAKEM 19NOV2014 CHK: G. BAILEY 19NOV2014 APVD: T. ELBIN 19NOV2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266571	RESTRICTED TO:
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2 SHEET 2 OF 4 REV G

THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		20	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266571-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266571-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [1.20]	F
INSUL	4.57 mm [1.80]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH 5.52-6.28 mm [1.217-.247 IN]		INSULATION DIAMETER RANGE Ø1.52-3.81 mm [1.060-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2126	-	-
TERMINALS APPLIED Δ 5 Δ 6			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63316-5	63316-7		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.80 +/- 0.05 [1.071 +/- .002]	8.5
16 AWG	1.60 +/- 0.05 [1.063 +/- .002]	10.5
18 AWG	1.45 +/- 0.05 [1.057 +/- .002]	12.3



- Δ 1 RECOMMENDED SPARE PARTS
 - Δ 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - Δ 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
 - Δ 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.
 - Δ 5 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - Δ 6 TERMINAL LUBRICANT IS RECOMMENDED.
7. 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	REV	DATE	BY	APPV
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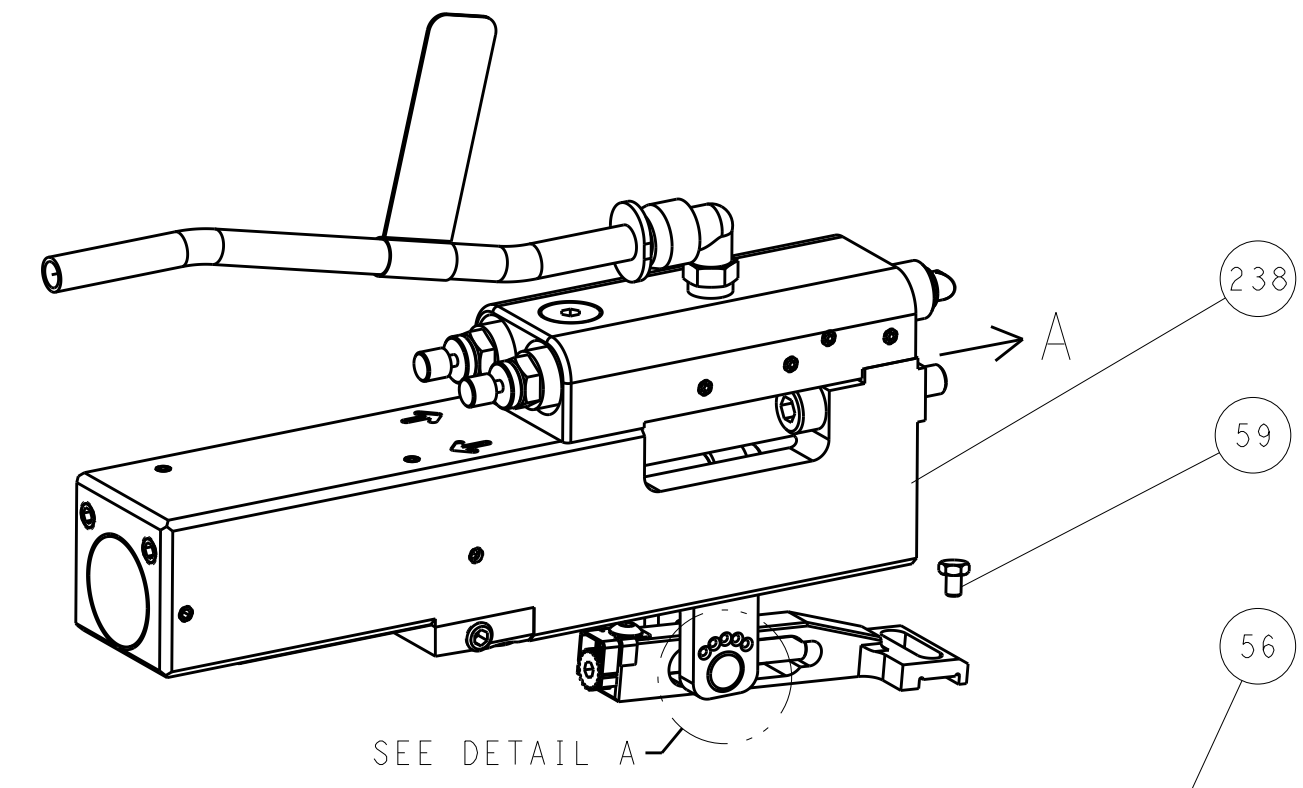
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-	1	23238-1			278
-	1	2030758-3			277
-	1	18030-2			276
-	1	986220-3			275
-	1	2168083-3			274
-	1	2217068-1			273
-	1	2-1803012-7			272
-	2	2168083-1			269
-	1	1633782-8			267
-	1	455888-3			259
-	1	2119082-3			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	2844940-1			238
-	REF	994970-2			164
-	1	2119641-2			151
-	2	2079383-8			145
-	1	2168083-8			144
-	1	2168083-3			143
-	-	2119653-2			142
-	1	1-1803583-0			141
-	1	1803516-2			140
-	1	455888-3			128
-	1	1-22281-8			121
-	1	455888-3			120
-	1	2119955-1			113
-	1	2844908-1			99
-	1	2844907-1			98
-	1	4-690712-0			96
-	2	1-2168083-3			95
-	1	2168083-6			93
-	1	3-455888-7			82
-	1	1803607-3			71
-	1	2119740-1			67
-	2	2168078-1			66
-	2	2-18032-5			61
-	1	5-18022-5			59
-	1	1-1338683-5			56
-	1	18023-9			49
-	1	1803602-2			41
-	1	1803245-1			34
-	2	2079383-5			33
-	2	3-2844962-3			30
-	1	2844938-1			29
-	2	22283-1			27
-	1	356835-1			26
-	1	6-690754-8			25
-	1	1320928-6			24
-	1	980371-4			23
-	1	2168083-2			21
-	6	1-18028-2			20
-	1	1-2119533-1			19
-	1	1-853721-7			10
-	1	3-853720-7			9
-	1	1803161-2			8
-	-	-			6
-	1	238009-3			4
-	1	4-1633966-2			3
-	1	455888-3			2
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PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

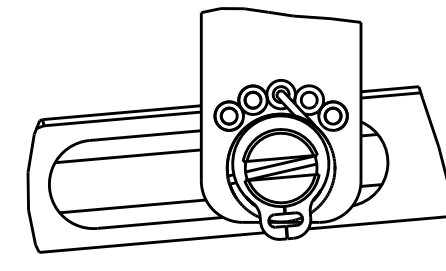
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WEIGHT	SCALE	SHEET	REV
									1:2	3 OF 4	G

LOC	DIST	REV	DATE	BY	APPV
A	66				

FEED TYPE
PNEUMATIC

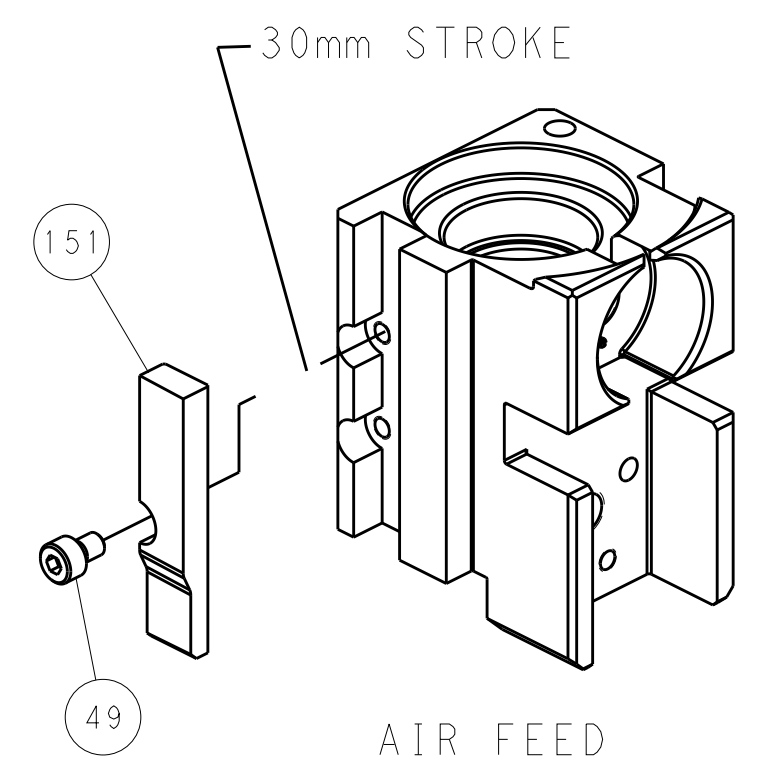


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

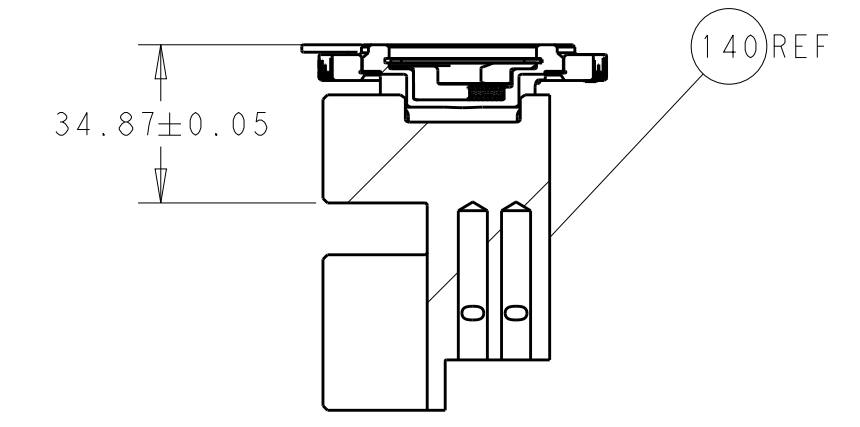
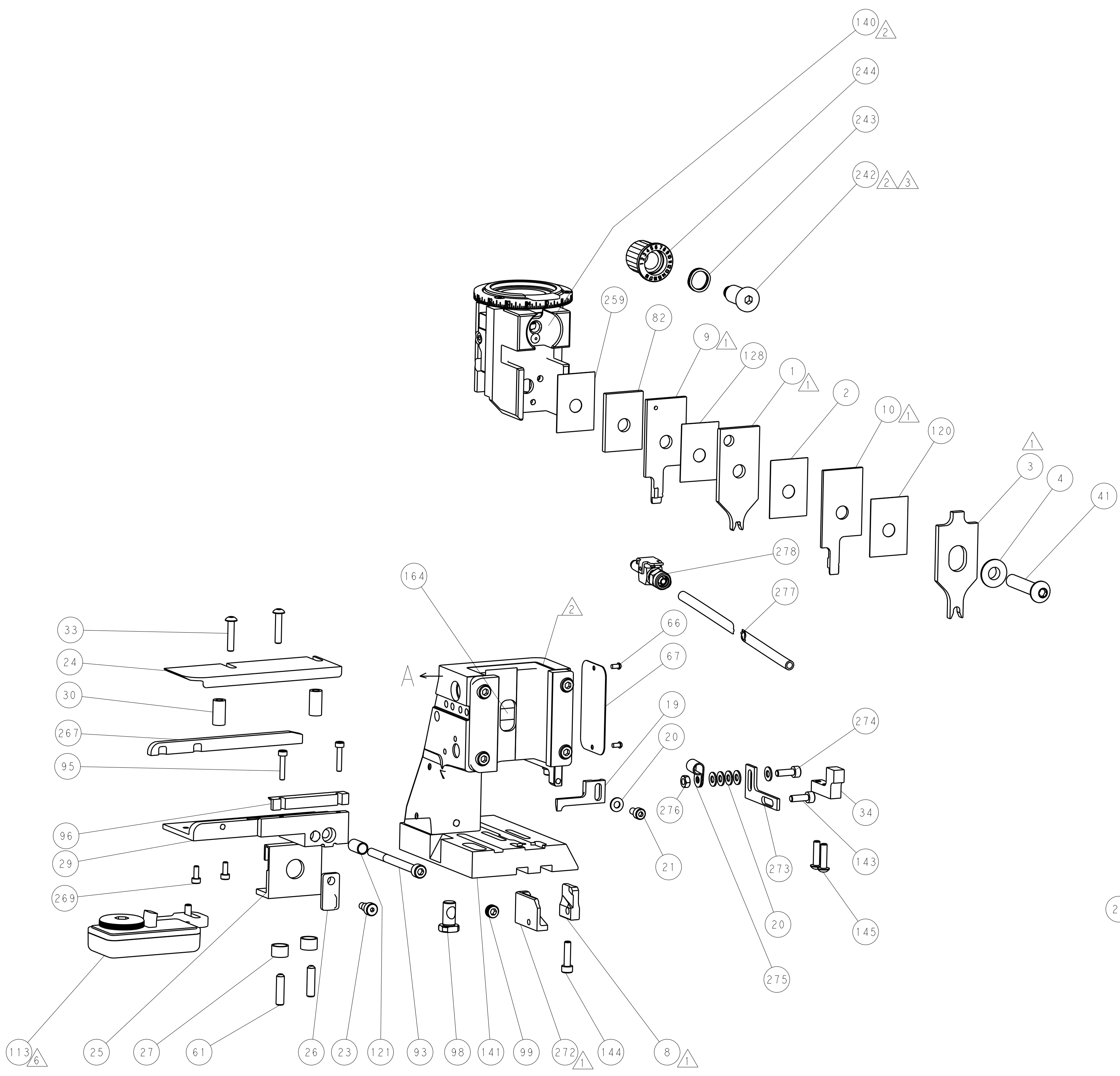


DETAIL A

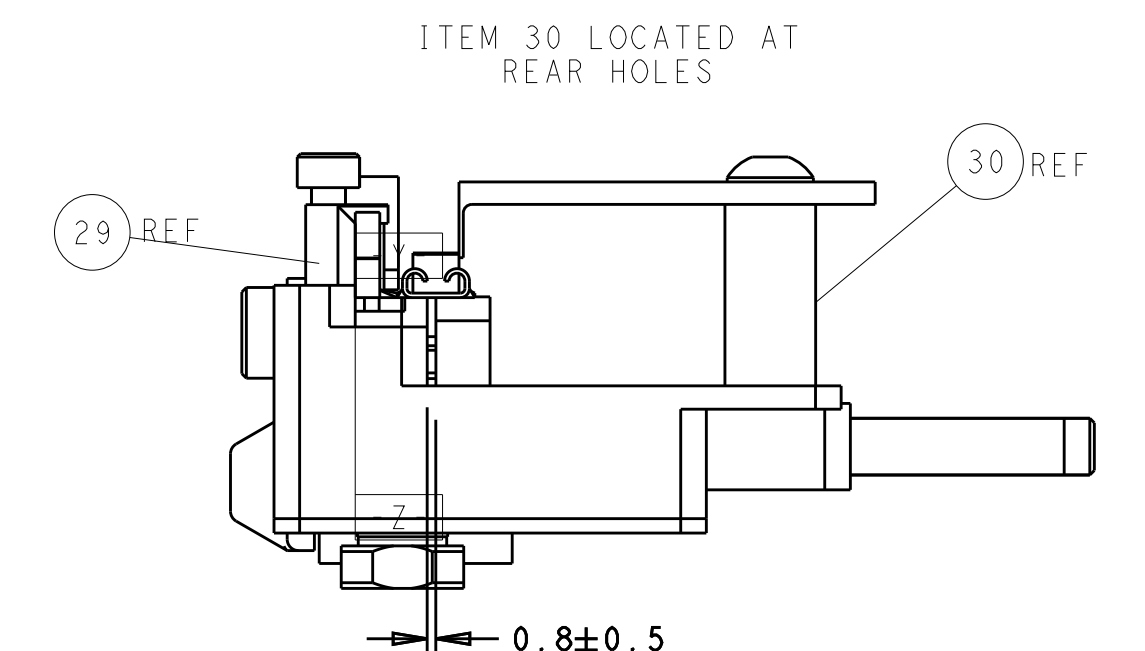
CAM POSITION



AIR FEED



RAM SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN: R. STAKEM 19NOV2014 CHK: G. BAILEY 19NOV2014 APVD: T. ELBIN 19NOV2014		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2266571		RESTRICTED TO: G	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET 4 OF 4 REV G	