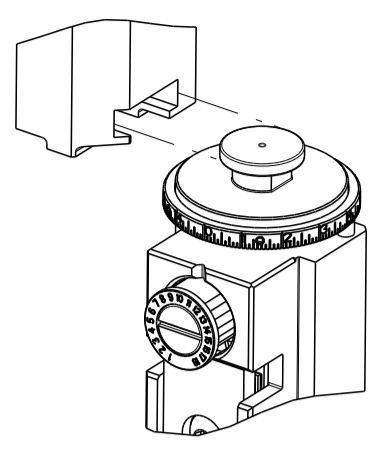


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266617-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266617-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266617-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



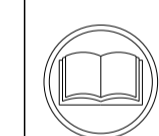
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	6.86 mm [.270]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.30 mm [.224-.248 IN]		∅2.70-3.70 mm [.106-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18072-1		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
963881-1		963245-1		3.4-3.7mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm ²	2.50 +/- 0.05 [.098 +/- .002]	7.6
3.50mm ²	2.39 +/- 0.05 [.094 +/- .002]	9.1
3mm ² OR 12 AWG	2.29 +/- 0.05 [.090 +/- .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.
- 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. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 7. CUT TO LENGTH AT ASSEMBLY.
- 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	OWN	APVD
		A		RELEASED	03FEB2015	BW	TE
		B		ECR-15-008621	08JUN2015	JH	CT
		C		ECR-20-017067	02DEC2020	FZ	TE
		D		ECR-21-000996	25JAN2021	TB	RK

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1633782-2	FENCE	267	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-2	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	2844940-2	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	318563-1	GUARD, FRONT CHIP	89	
-	1	1	455888-4	SPACER, CRIMPER	82	
-	2	2	1-2079383-8	SCR, BHSC, RoHS (M4 X 6)	79	
-	1	1	1803075-1	EXTENSION PLATE	78	
-	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	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57	
-	1	1	1338683-8	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53	
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	690753-2	SPACER, TONKER	50	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1-1803583-7	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	3-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-6	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-3	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-4	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	1803013-1	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	2119805-7	SHEAR HOLDER, FRONT	10	
-	1	1	318059-9	FLOATING SHEAR, FRONT	9	
-	1	2	1	3-1633930-0	ANVIL, COMBINATION	8
-	1	1	5-240641-1	SPACER	7	
-	-	-	-	-	6	
-	1	1	1803080-1	DEPRESSOR, SHEAR	5	
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	1	9-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-7	SPACER, CRIMPER	2	
-	1	2	1	456411-9	CRIMPER, WIRE PREMIUM	1

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

OWN	B. WEAVER	11DEC2014
CHK	T. ELBIN	11DEC2014
APVD	T. ELBIN	11DEC2014

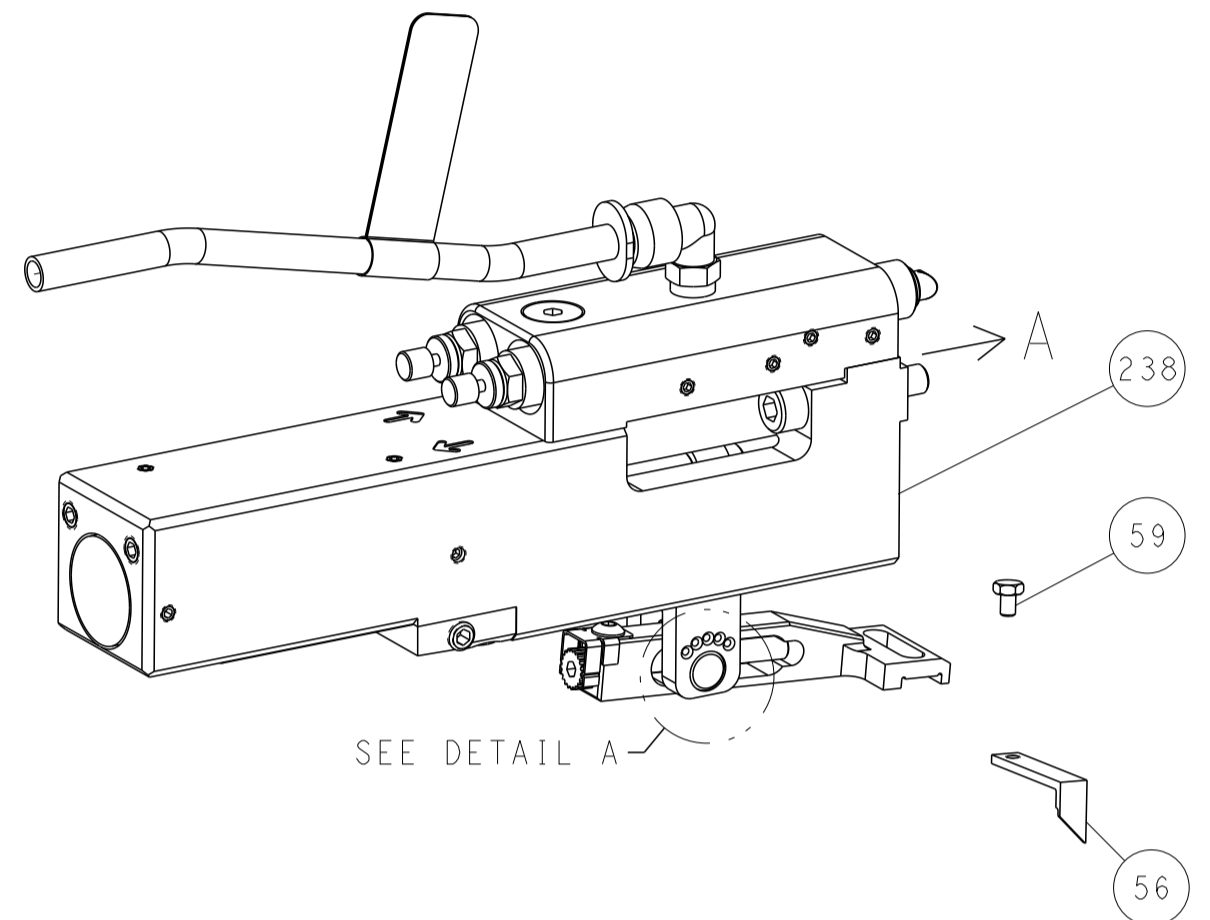
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266617	

Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV D

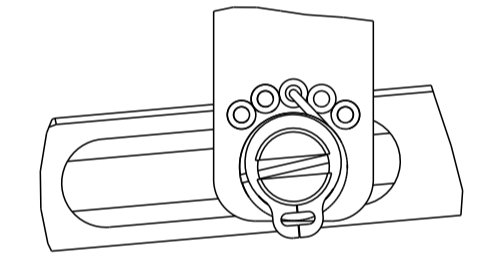
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

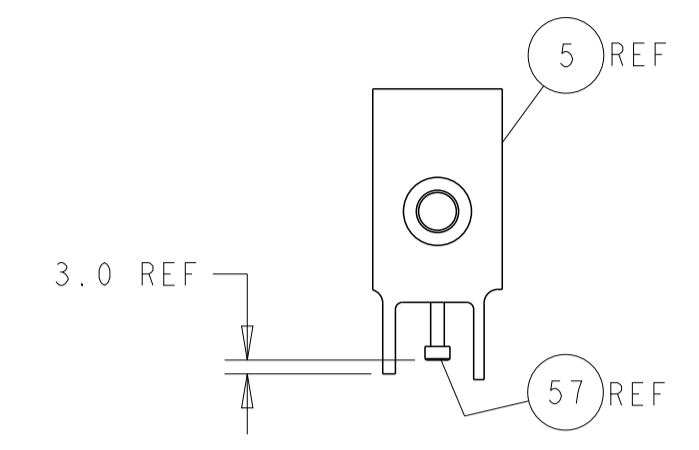
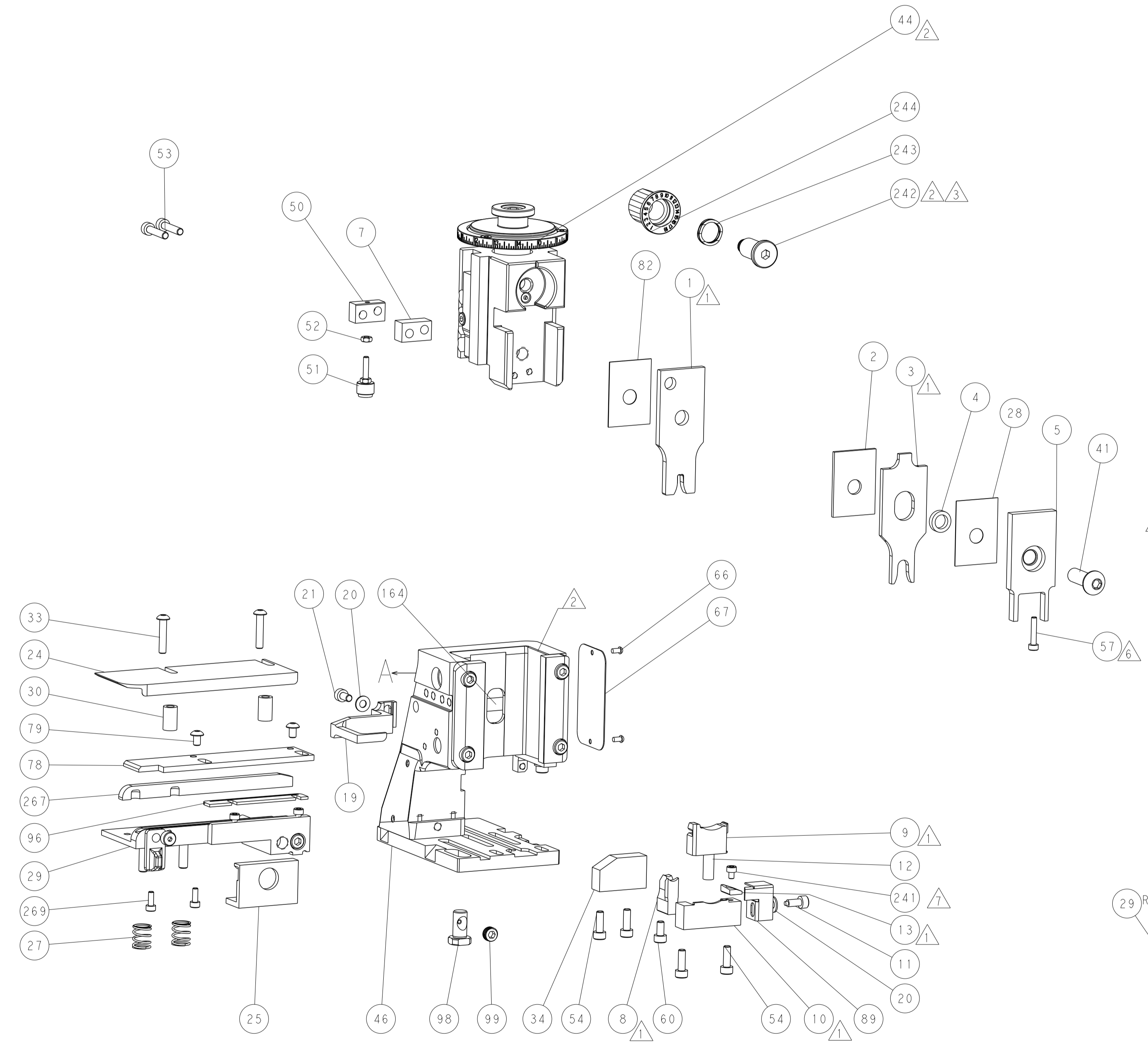
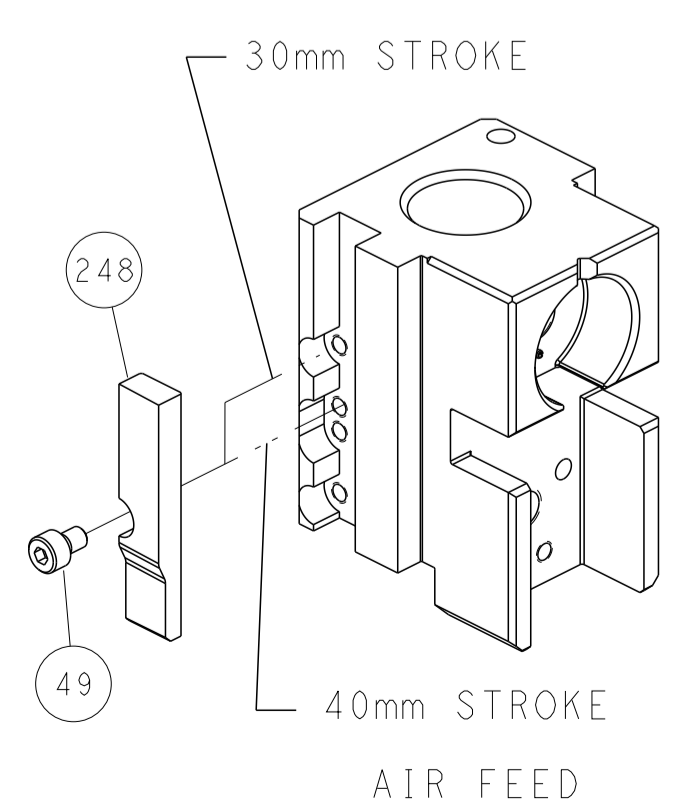
PNEUMATIC



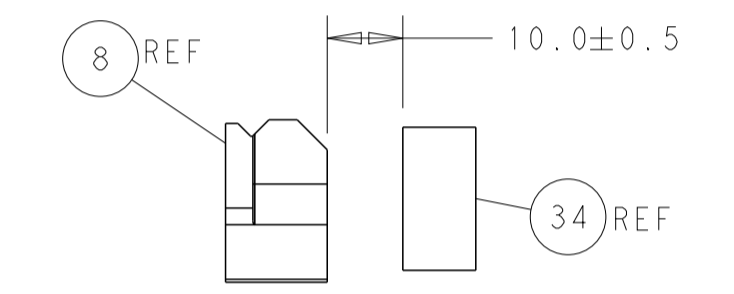
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



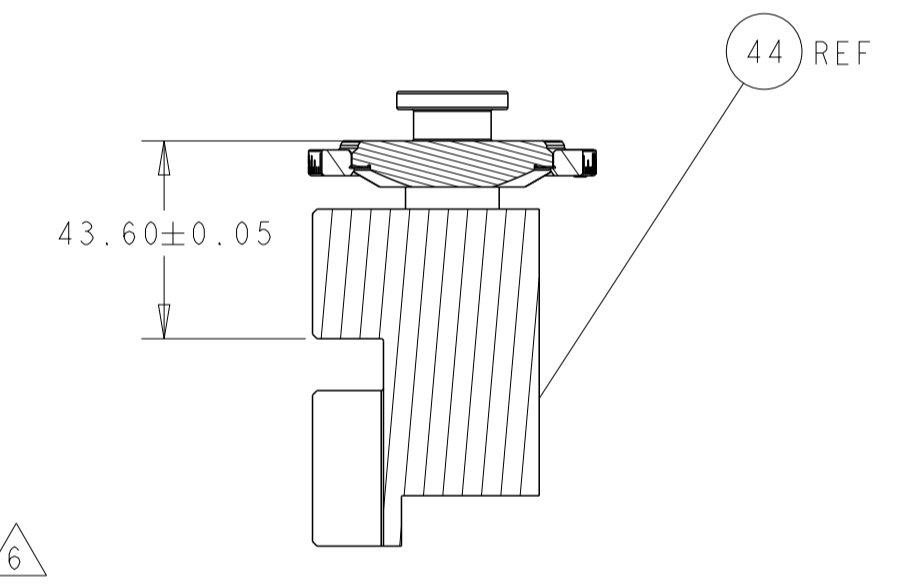
CAM POSITION



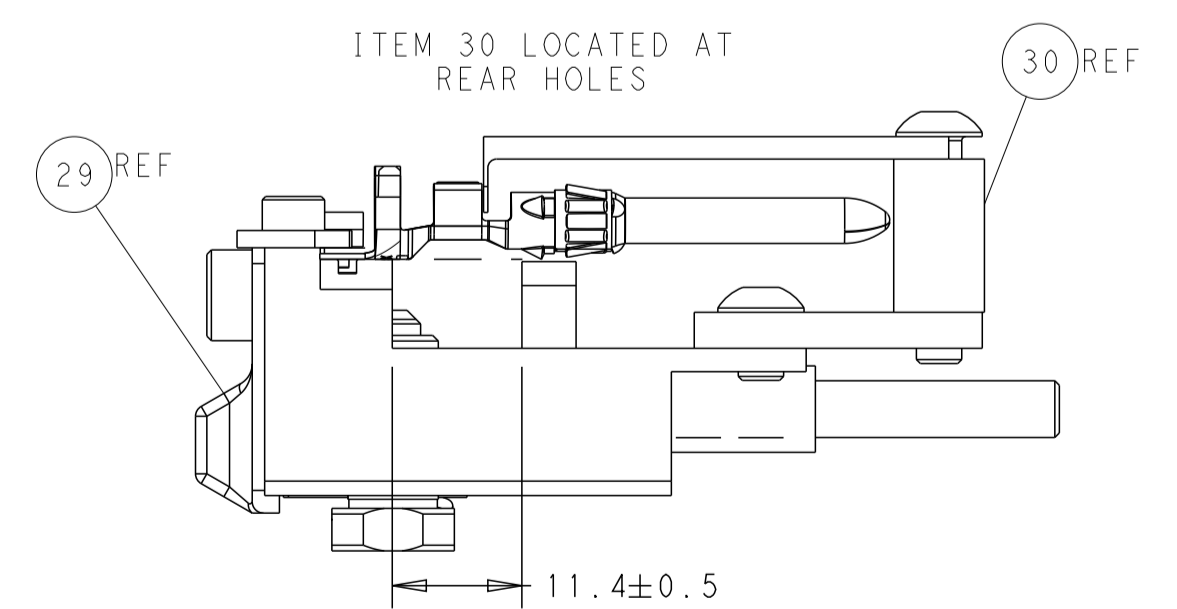
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2014. COPYRIGHT 2014 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER 11DEC2014 CHK: T. ELBIN 11DEC2014 APVD: T. ELBIN 11DEC2014	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-2266617 RESTRICTED TO:
MATERIAL:		SCALE: 1:2 SHEET: 2 OF 4 REV: D	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266617-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266617-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	6.86 mm [.270]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.70-6.30 mm [.224-.248 IN]	Ø2.70-3.70 mm [.106-.146 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18072-1		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
963881-1		963245-1		3.4-3.7mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.50 +/- 0.05 [.098 +/- .002]	7.6
3.50mm2	2.39 +/- 0.05 [.094 +/- .002]	9.1
3mm2 OR 12 AWG	2.29 +/- 0.05 [.090 +/- .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.
 - 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 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
 - 7 CUT TO LENGTH AT ASSEMBLY.
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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

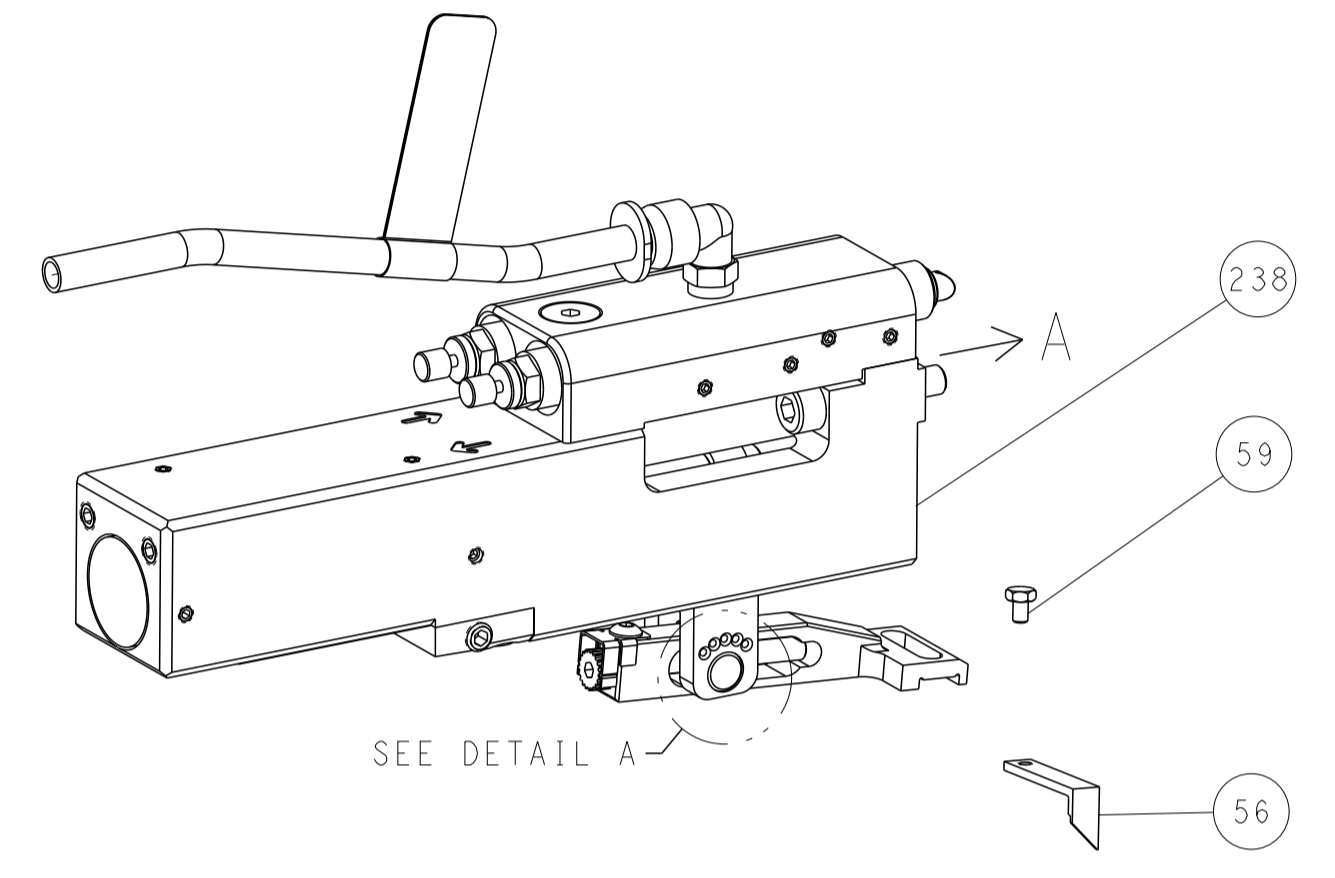
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1633782-2	FENCE	267	
-	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
7	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-2	AIR FEED MODULE	238	
-	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	1-1803583-8	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	1-690438-0	FRONT STRIP GUIDE	96	
-	1	318563-1	GUARD, FRONT CHIP	89	
-	1	455888-4	SPACER, CRIMPER	82	
-	2	1-2079383-8	SCR, BHSC, RoHS (M4 X 6)	79	
-	1	1803075-1	EXTENSION PLATE	78	
-	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	
6	-	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	1	1338683-8	FEED PAWL	56	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53	
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	690753-2	SPACER, TONKER	50	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	3-1752356-3	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-6	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-3	SPACER, CRIMPER	28	
-	2	22283-1	SPRING, COMPRESSION	27	
-	1	240792-1	DRAG, TERMINAL	25	
-	1	1320928-4	STRIP GUIDE	24	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1803013-1	STRIPPER, SIDE FEED	19	
1	-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1-356885-4	STOP, SHEAR	11	
1	-	1	2119805-7	SHEAR HOLDER, FRONT	10
1	-	1	318059-9	FLOATING SHEAR, FRONT	9
1	1	1	3-1633930-0	ANVIL, COMBINATION	8
-	1	1	5-240641-1	SPACER	7
-	-	-	-	6	
-	1	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	9-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-7	SPACER, CRIMPER	2
1	1	1	456411-9	CRIMPER, WIRE PREMIUM	1
-	77	-22	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														

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

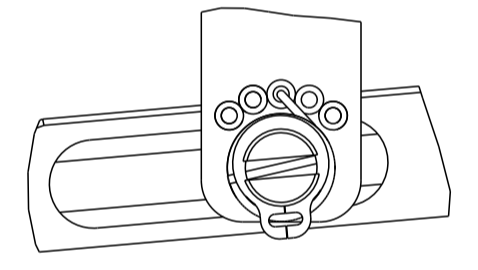
FEED TYPE

PNEUMATIC



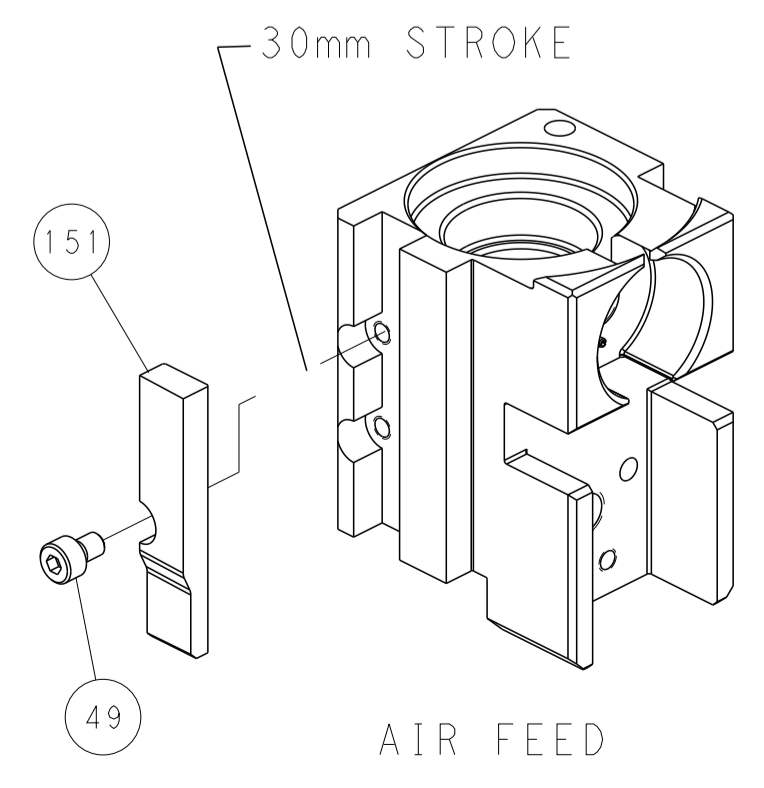
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

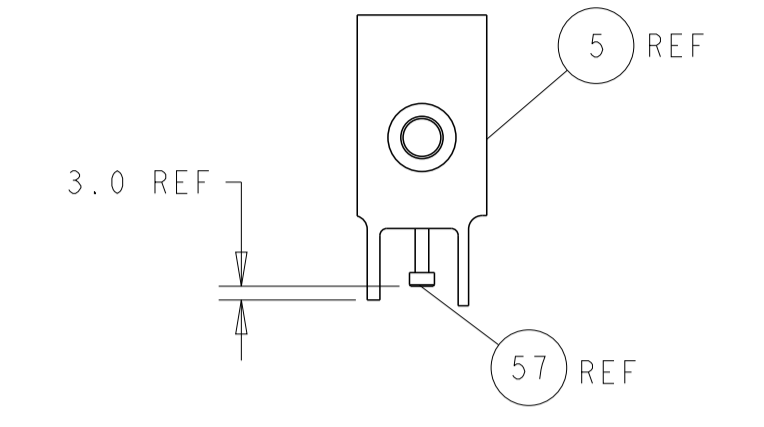
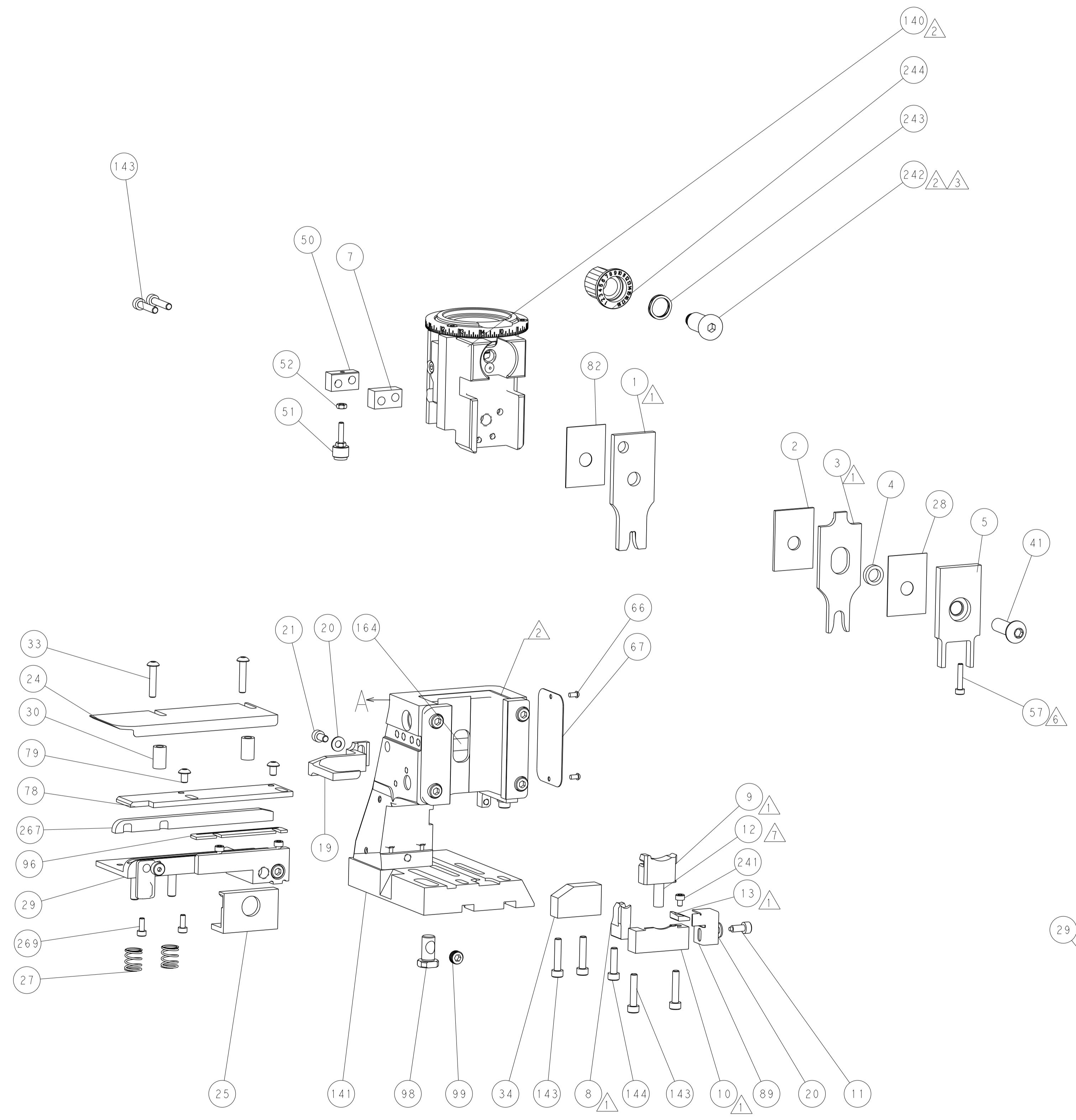


DETAIL A

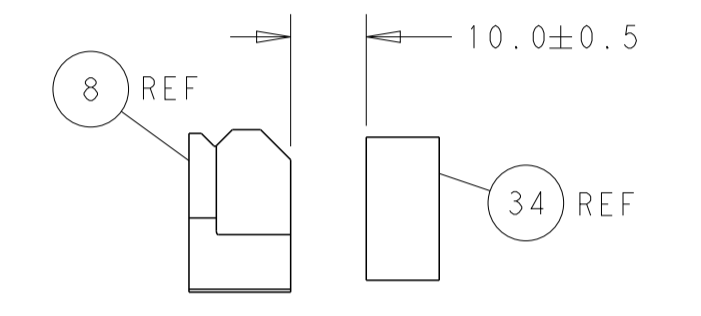
CAM POSITION



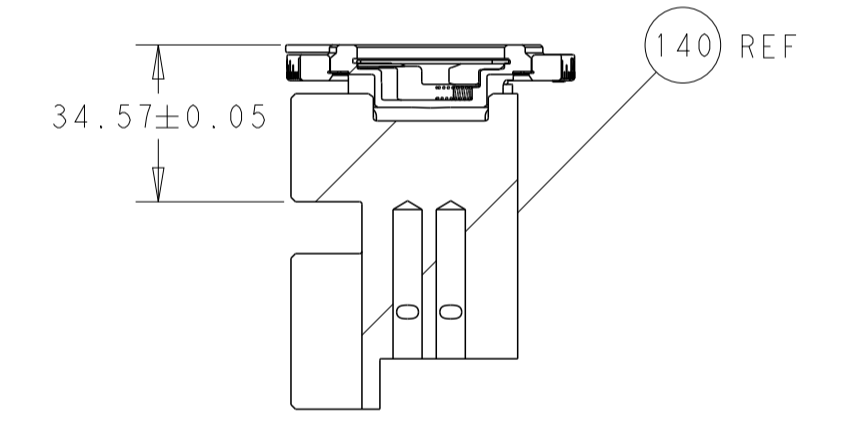
AIR FEED



SHEAR DEPRESSOR DETAIL

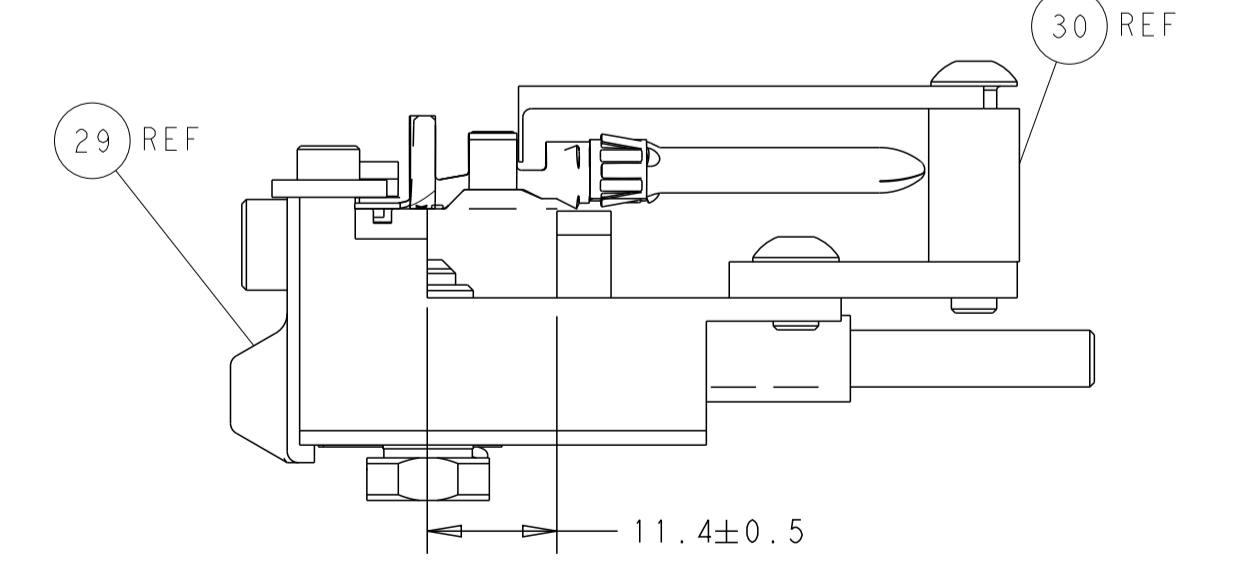


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2014. COPYRIGHT 2014 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER 11DEC2014 CHK: T. ELBIN 11DEC2014 APVD: T. ELBIN 11DEC2014	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ° ±. FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266617	RESTRICTED TO: - SHEET 4 OF 4 REV D