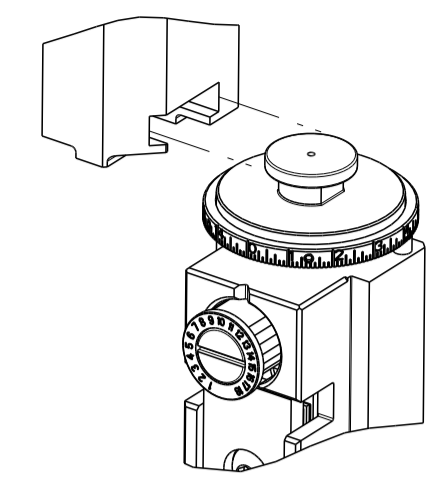


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266977-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266977-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266977-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

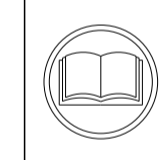


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, STANDARD POWER TIMER OVER MOLD DESIGN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.90-4.50 mm [.154-.177 IN]		2.00-3.80 mm [.079-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-32163		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-2238084-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.93 +/- 0.05 [.076 +/- .002]	5.8
2.00mm2	1.75 +/- 0.05 [.069 +/- .002]	7.8
1.50mm2	1.66 +/- 0.05 [.065 +/- .002]	8.6



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.

***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
		B1		ECR-18-001748	06FEB2018	MZ	CT
		D		ECR-19-004389	19MAR2019	LG	TE
		E		ECR-22-130513	22JUN2022	MEH	GB
		E1		ECR-22-149686	17AUG2022	MEH	TE

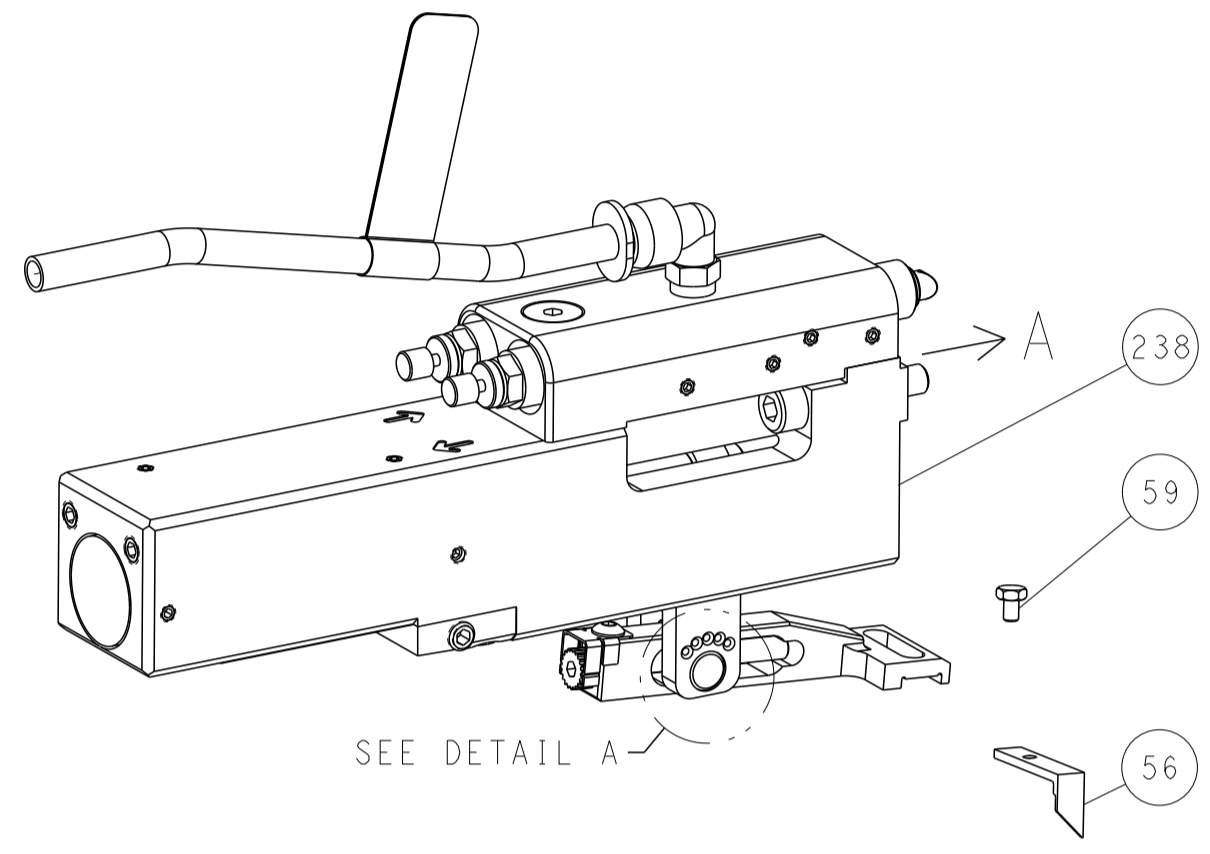
-	1	1	2-1803945-6	TONKER			300
-	1	1	22278-9	SPRING, COMPRESSION			299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0			298
-	1	1	1803944-1	SPACER, TONKER			297
-	1	1	1633601-4	BLADE, SLUG			264
-	1	1	2119641-1	FEED CAM, AIR FEED			248
-	1	1	2844940-1	AIR FEED MODULE			238
-	REF	REF	994970-2	COUNTER, MAGNETIC			164
-	1	1	2217068-1	BRACKET, AIR BLAST			130
-	1	1	2030758-3	TUBING, POLYURETHANE			129
-	1	1	986965-8	NUT, LOCK, HEX, TORQUE (M4)			128
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10			127
-	1	1	986220-3	CLAMP, CABLE, BLACK			126
-	1	1	1-22281-8	SPRING, COMPRESSION			121
-	1	1	1-455888-4	SPACER, CRIMPER			120
-	1	1	23238-1	INSERT, COUPLING			101
-	1	1	2844908-1	SCREW, LOCKING			99
-	1	1	2844907-1	POST, LOCKING			98
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0			94
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65			93
-	1	1	1-455888-6	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	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	1-1338683-3	FEED PAWL			56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14			53
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0			49
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF			46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC			44
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16			43
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)			41
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0			34
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0			33
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)			31
-	2	2	3-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	1	2844938-9	PLATE, STRIP GUIDE			29
-	1	1	2-455888-4	SPACER, CRIMPER			28
-	2	2	22281-6	SPRING, COMPRESSION			27
-	1	1	356835-1	LEVER, DRAG RELEASE			26
-	1	1	690754-9	DRAG, SPECIAL			25
-	1	1	1633653-4	STRIP GUIDE			24
-	1	1	1-189124-6	GUIDE, FRONT STRIP			23
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	4	4	1-18028-2	WASHER, FLAT, REG M4			20
-	1	1	2119533-1	STRIPPER, SIDE FEED			19
-	1	1	4-1803012-4	PLATE, REAR SHEAR			15
-	1	1	1633782-9	FENCE			12
-	-	-	-	-			10
-	-	-	-	-			9
-	-	-	-	-			6
-	-	-	-	-			5
-	-	-	-	-			4
-	-	-	-	-			3
-	-	-	-	-			2
-	1	2	1	456408-3	CRIMPER, WIRE PREMIUM		1
-	77	72	-2	PART NO			
-				DESCRIPTION			ITEM NO

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: BOB HIGMAN 22SEPT2015 CHK: T. ELBIN 22SEPT2015 APVD: T. ELBIN 22SEPT2015 PRODUCT SPEC APPLICATION SPEC SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266977 RESTRICTED TO: - SCALE: 1:2 SHEET: 1 OF 4 REV: E1	
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

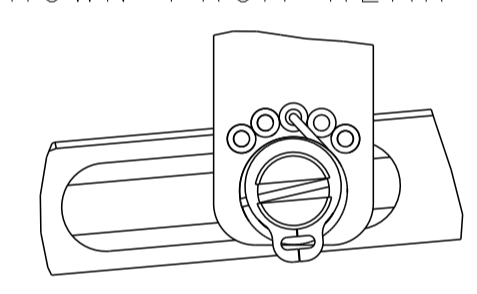
FEED TYPE

PNEUMATIC



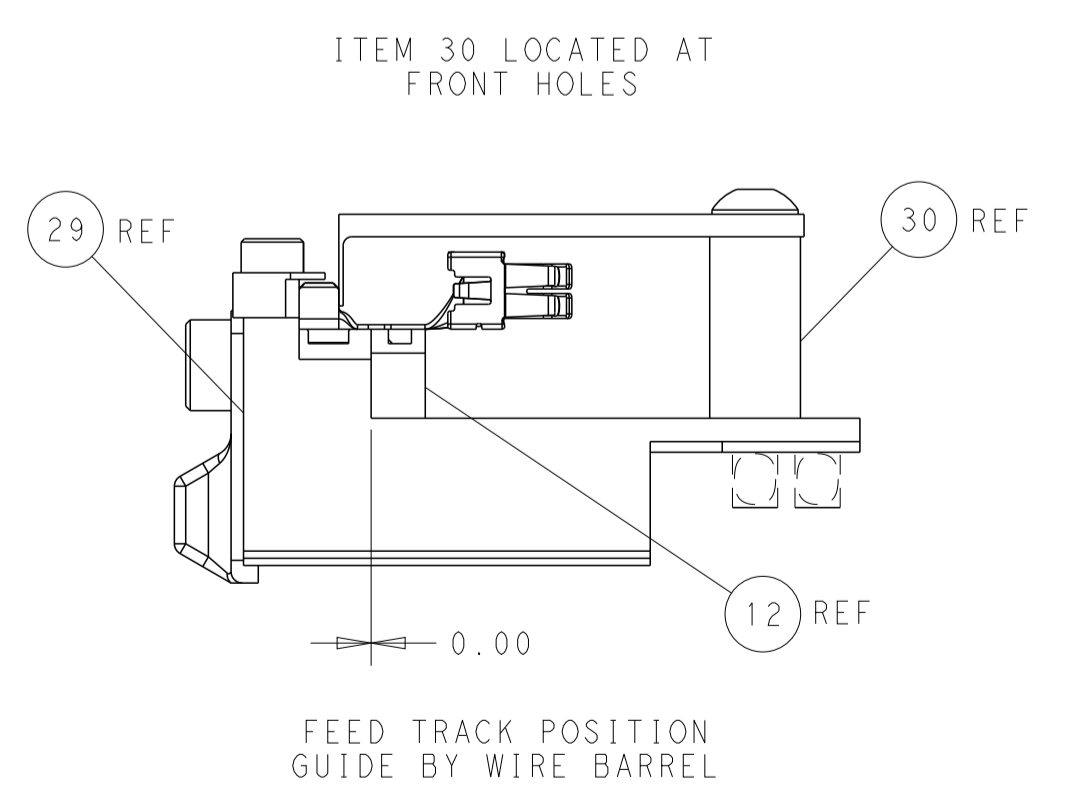
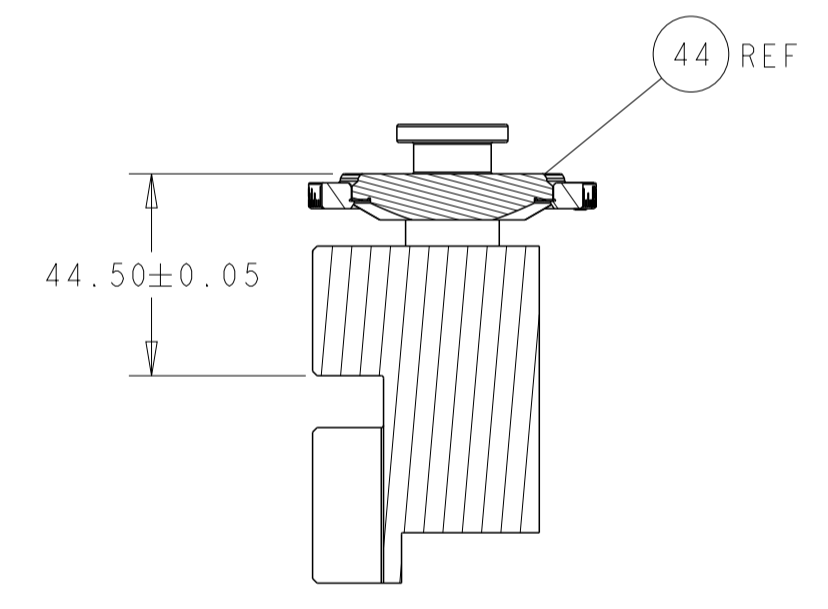
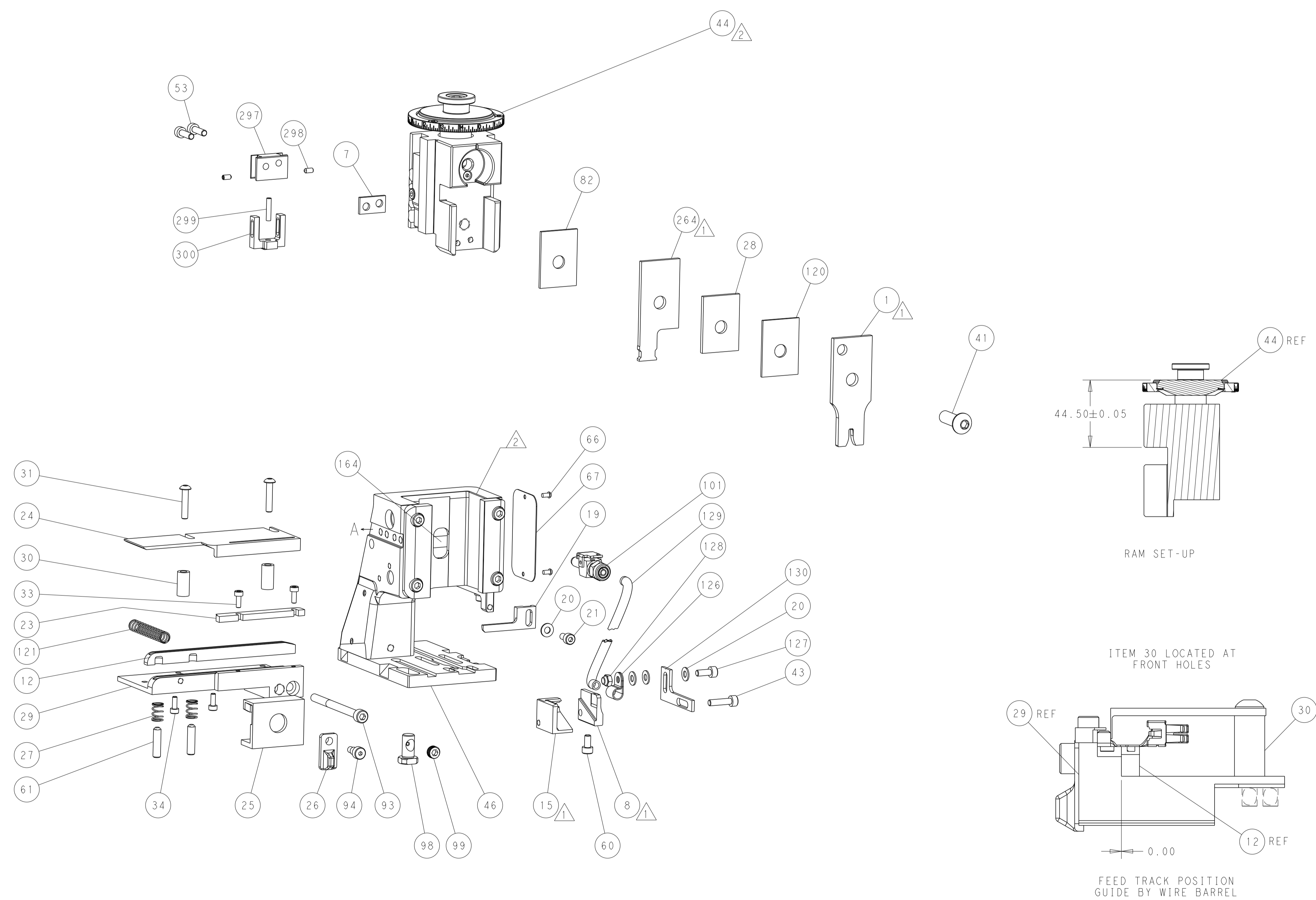
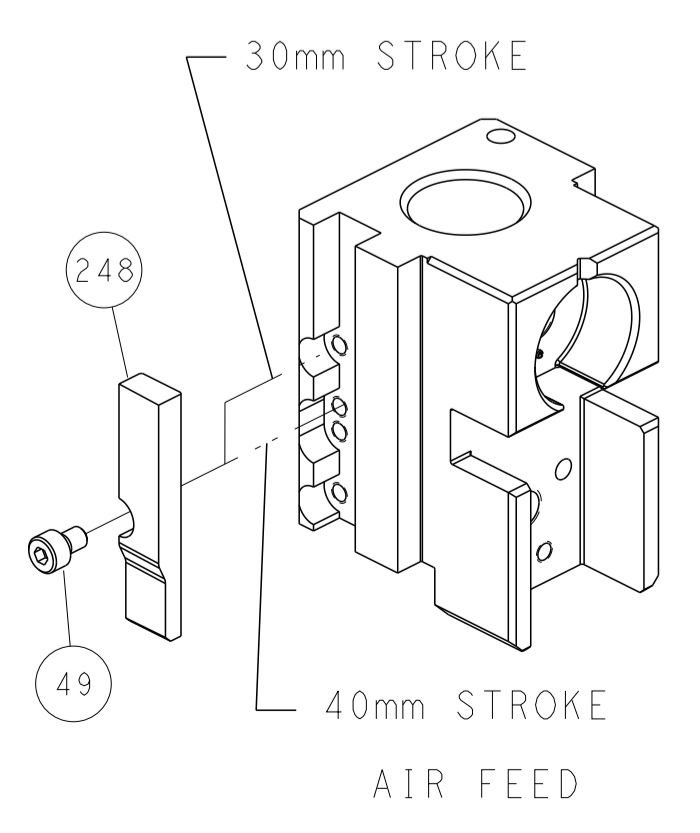
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITION

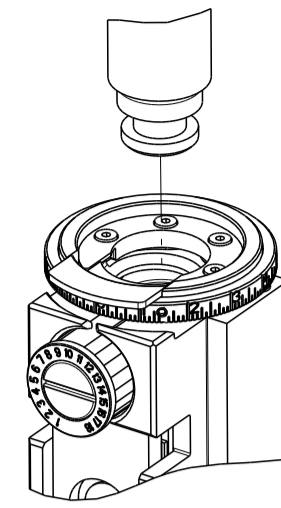


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN BOB HIGMAN 22SEPT2015 CHK T. ELBIN 22SEPT2015 APVD T. ELBIN 22SEPT2015	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 SIZE CAGE CODE DRAWING NO WEIGHT A1 00779 C=2266977	RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV E1
MATERIAL:		Customer Accessible Production Drawing	

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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266977-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266977-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
	2.79 mm [1.110]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA:	TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME:	CONTACT, STANDARD POWER TIMER OVER MOLD DESIGN	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	
3.90-4.50 mm [1.54-.177 IN]	2.00-3.80 mm [1.079-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-32163	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
1-2238084-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.93+/-0.05 [1.076+/-0.002]	5.8
2.00mm2	1.75+/-0.05 [1.069+/-0.002]	7.8
1.50mm2	1.66+/-0.05 [1.065+/-0.002]	8.6



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4. 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)

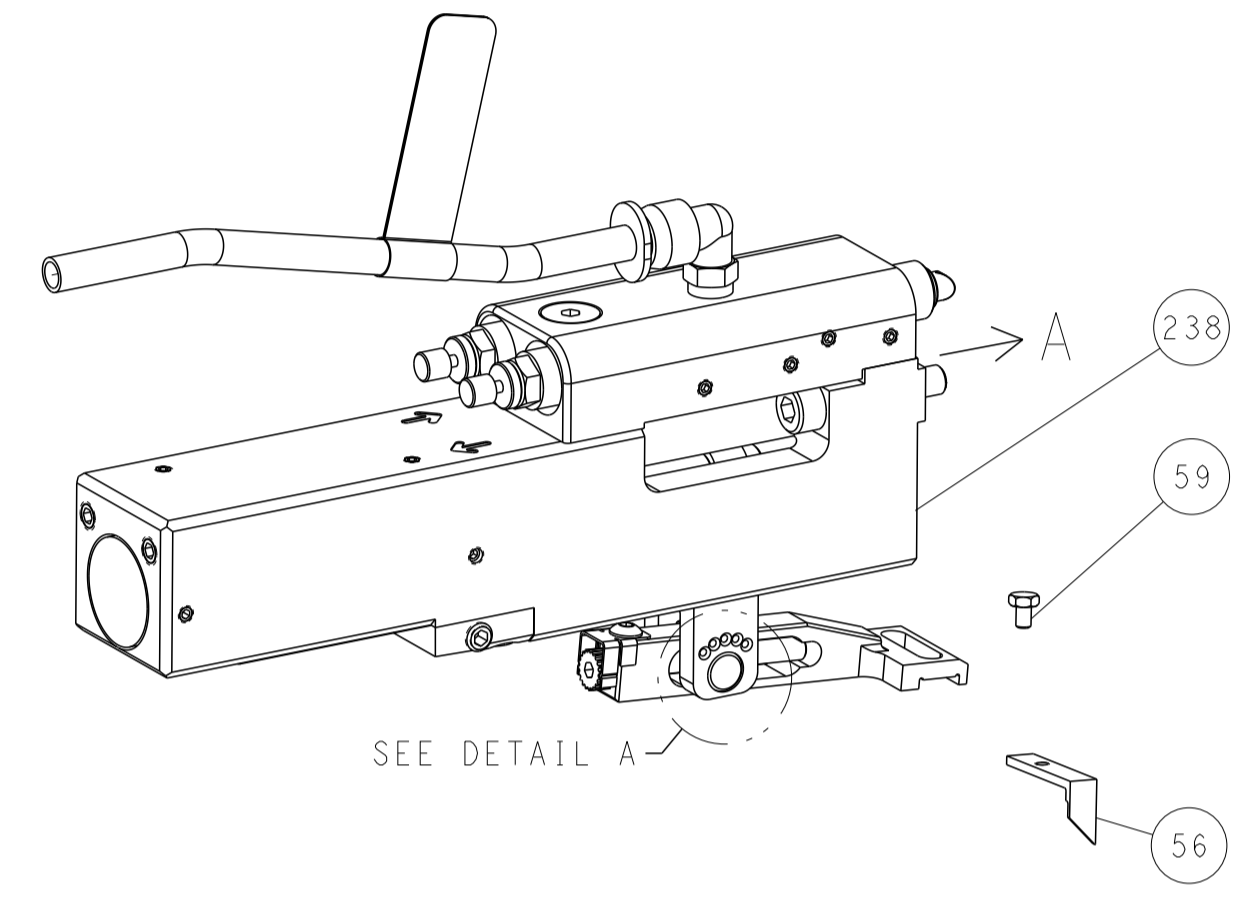
LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
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-	1	2-1803945-6		TONKER			300
-	1	22278-9		SPRING, COMPRESSION			299
-	2	4-18032-3		SCR, SET, FLT PNT, M3 X 6.0			298
-	1	1803944-1		SPACER, TONKER			297
1	1	1633601-4		BLADE, SLUG			264
-	1	2844940-1		AIR 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
-	1	1-1803583-0		APPLICATOR BASIC ASSEMBLY, SF			141
-	1	1803516-1		RAM ASSEMBLY, SF PACIFIC			140
-	1	2217068-1		BRACKET, AIR BLAST			130
-	1	2030758-3		TUBING, POLYURETHANE			129
-	1	986965-8		NUT, LOCK, HEX, TORQUE (M4)			128
-	1	1-2168083-0		SCR, SKT HD CAP, RoHS, M4 X 10			127
-	1	986220-3		CLAMP, CABLE, BLACK			126
-	1	1-22281-8		SPRING, COMPRESSION			121
-	1	1-455888-4		SPACER, CRIMPER			120
-	1	23238-1		INSERT, COUPLING			101
-	1	2844908-1		SCREW, LOCKING			99
-	1	2844907-1		POST, LOCKING			98
-	1	980371-4		SCR, SKT HD SHLDR 5.0 DIA X 6.0			94
-	1	2168083-6		SCR, SKT HD CAP, RoHS, M5 X 65			93
-	1	1-455888-6		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
-	2	2-18032-5		SCR, SET, FLT PNT, M5 X 20.0			61
-	1	5-18022-5		SCR, HEX HD CAP, M4 X 6.0			59
-	1	1-1338683-3		FEED PAWL			56
-	2	2-2168083-5		SCR, SKT HD CAP, RoHS, M4 X 14			53
-	1	18023-9		SCR, SKT HD CAP M4 X 6.0			49
-	1	2168083-8		SCR, SKT HD CAP, RoHS, M4 X 16			43
-	1	1803602-1		SCR, BHSC, RoHS (M8 X 25)			41
-	2	2168083-1		SCR, SKT HD CAP, RoHS, M3 X 8.0			34
-	2	2168083-1		SCR, SKT HD CAP, RoHS, M3 X 8.0			33
-	2	2079383-5		SCR, BHSC, RoHS (M4 X 20)			31
-	2	3-2844962-3		SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	2844938-9		PLATE, STRIP GUIDE			29
-	1	2-455888-4		SPACER, CRIMPER			28
-	2	22281-6		SPRING, COMPRESSION			27
-	1	356835-1		LEVER, DRAG RELEASE			26
-	1	690754-9		DRAG, SPECIAL			25
-	1	1633653-4		STRIP GUIDE			24
-	1	1-189124-6		GUIDE, FRONT STRIP			23
-	1	2168083-2		SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	4	1-18028-2		WASHER, FLAT, REG M4			20
-	1	2119533-1		STRIPPER, SIDE FEED			19
1	1	4-1803012-4		PLATE, REAR SHEAR			15
-	1	1633782-9		FENCE			12
-	-	-		-			10
-	-	-		-			9
1	1	1803097-6		ANVIL, WIRE			8
-	1	1-240641-3		SPACER			7
-	-	-		-			6
-	-	-		-			5
-	-	-		-			4
-	-	-		-			3
-	-	-		-			2
1	1	456408-3		CRIMPER, WIRE PREMIUM			1
-77	-22	PART NO		DESCRIPTION			ITEM NO

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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 CAGE CODE DRAWING NO WEIGHT SCALE 1:2 SHEET 3 OF 4 REV E1	SIZE A1 CAGE CODE 00779 DRAWING NO C=2266977
MATERIAL:		Customer Accessible Production Drawing	

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

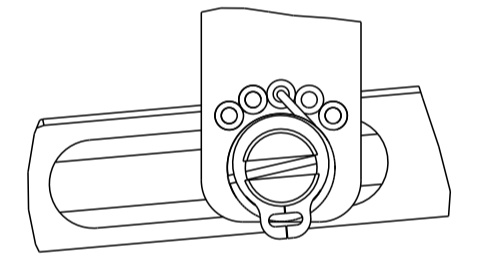
FEED TYPE

PNEUMATIC



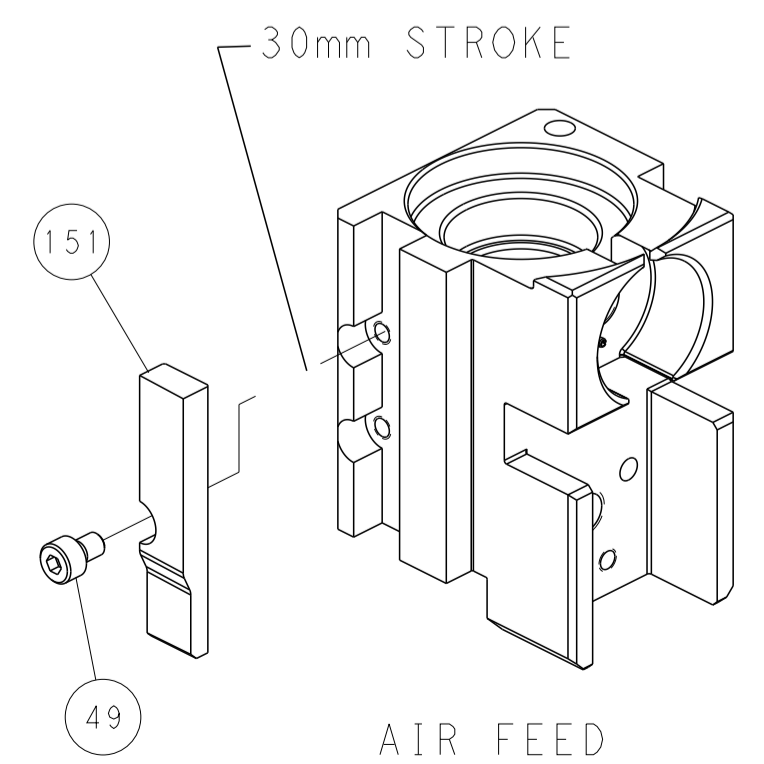
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

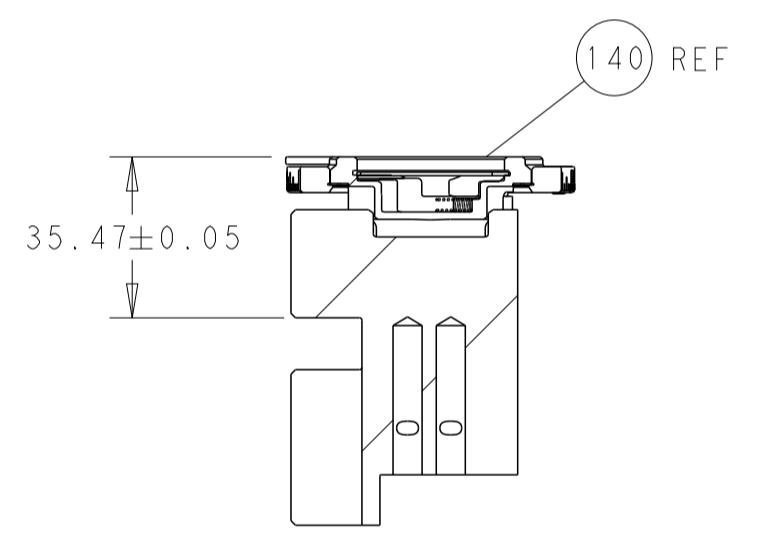
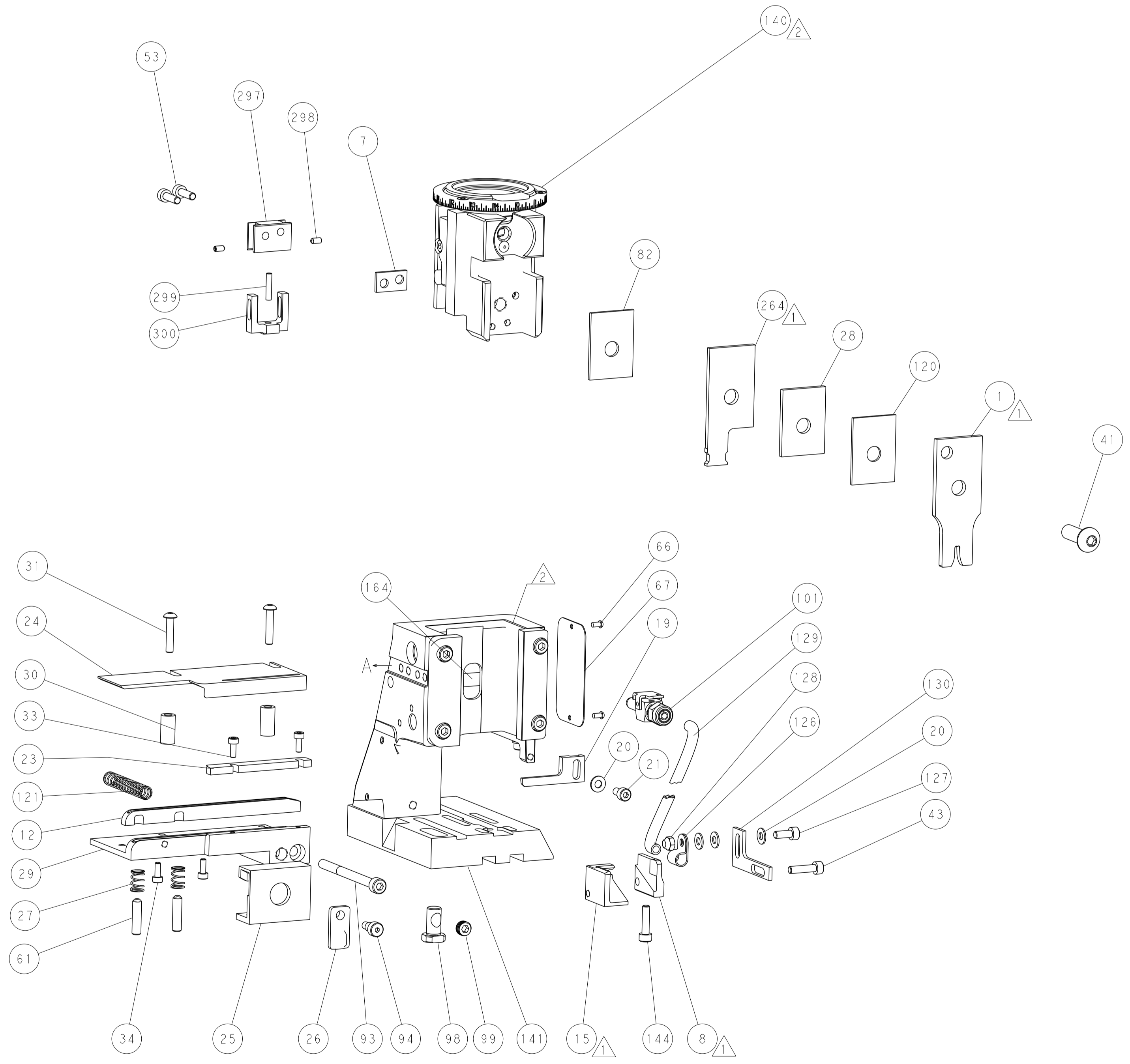


DETAIL A

CAM POSITION

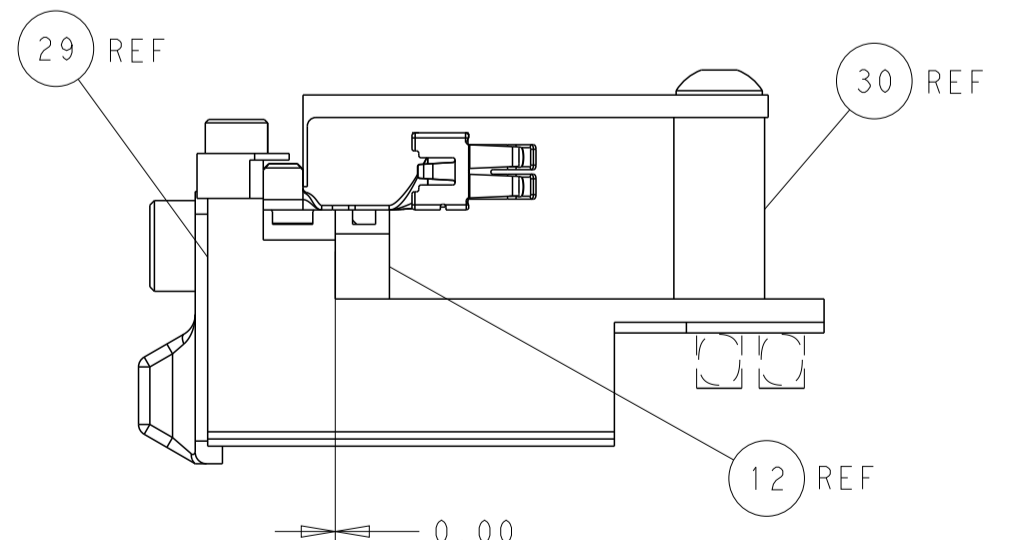


AIR FEED



RAM SET-UP

ITEM 30 LOCATED AT FRONT 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)

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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 SIZE CAGE CODE DRAWING NO. A1 00779 C=2266977 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV E1