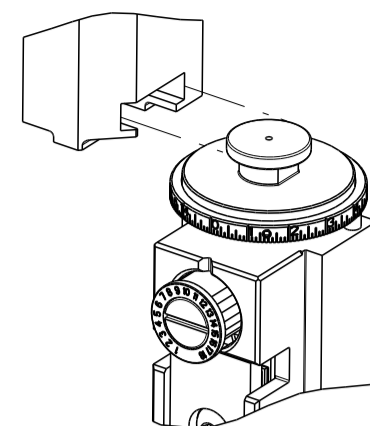


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2266739-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266739-2 | E | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2266739-7 | C | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|-----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 5.33 mm [.210] | F |
| INSUL | 11.18 mm [.440] | O |

APPLICATOR INSTRUCTIONS
408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-----------|---------------------------|---|
| TERMINAL NAME: TAB 9.5mm X 1.2mm | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 9.20-9.60 mm [.362-.378 IN] | | ∅ | |
| TERMINAL APPLICATION SPECIFICATION | 114-94407 | - | - |

| TERMINALS APPLIED | | | | SEAL INSULATION DIAMETER RANGE |
|-------------------|-------------|---------|-----------|--------------------------------|
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL | |
| 2-2287018-1 | | | 2287390-2 | 5.30-6.00 |
| | | | 2287390-5 | 4.60-5.00 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 10.00mm2 | 3.35 +/- 0.10 [.132 +/- .004] | 2.6 |
| 8.00mm2 | 3.05 +/- 0.10 [.120 +/- .004] | 5.8 |

***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.



- △ 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.
- △ 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- △ APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- △ CUT TO LENGTH AT ASSEMBLY.

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | B | | ECR-16-008663 | 15JUN2016 | JH | GB |
| | | C | | ECR-17-009111 | 22JUN2017 | TB | GB |
| | | D | | ECR-17-013780 | 18SEP2017 | TB | GB |
| | | E | | ECR-19-011304 | 18JUL2019 | TB | TE |

| | | | | | | |
|---|-----|-----|-------------|-------------------------------------|--------------------------------|-----|
| - | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269 | |
| - | 1 | 1 | 1633782-7 | FENCE | 267 | |
| - | 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 | |
| 3 | - | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 2844940-2 | AIR FEED MODULE | 238 | |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 | |
| 5 | - | 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 | 455888-7 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 2-240641-4 | SPACER | 81 | |
| 9 | - | 2 | 2 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 79 |
| - | 1 | 1 | 1803096-1 | EXTENSION PLATE | 78 | |
| - | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 | |
| - | 1 | 1 | 1-2119791-1 | DEPRESSOR, WIRE | 70 | |
| - | 1 | 1 | 2119943-1 | WASHER, SPACER | 69 | |
| - | 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 | |
| 8 | - | 1 | 1 | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16 | 57 |
| - | 1 | 1 | 1-1338683-1 | 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 | 1803382-4 | HOLD DOWN, SPRING LOADED | 50 | |
| - | 1 | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 | |
| - | 1 | 1 | 2-1803583-6 | 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 | 1752356-8 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 3-2844962-2 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 | |
| - | 1 | 1 | 2844992-5 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 1 | 3-455888-7 | SPACER, CRIMPER | 28 | |
| - | 2 | 2 | 1-22284-0 | SPRING, COMPRESSION | 27 | |
| - | 1 | 1 | 240792-1 | DRAG, TERMINAL | 25 | |
| - | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 | |
| - | 1 | 1 | 1-690438-0 | FRONT STRIP GUIDE | 23 | |
| - | 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 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 16 | |
| - | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 15 | |
| - | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 | |
| - | 1 | 1 | 1-356885-3 | STOP, SHEAR | 11 | |
| △ | - | 1 | 1 | 2-2119805-0 | SHEAR HOLDER, FRONT | 10 |
| △ | - | 1 | 1 | 1-318059-2 | FLOATING SHEAR, FRONT | 9 |
| △ | 1 | 2 | 1 | 1-1803383-7 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 2-240641-5 | SPACER | 7 | |
| - | - | - | - | - | 6 | |
| - | 1 | 1 | 1-1803080-2 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 4-238011-4 | BLOCK, CRIMPER SPACER | 4 | |
| △ | 1 | 2 | 1 | 5-1633966-7 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 455888-6 | SPACER, CRIMPER | 2 | |
| △ | 1 | 2 | 1 | 1-1633773-3 | CRIMPER, WIRE, STEP | 1 |

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

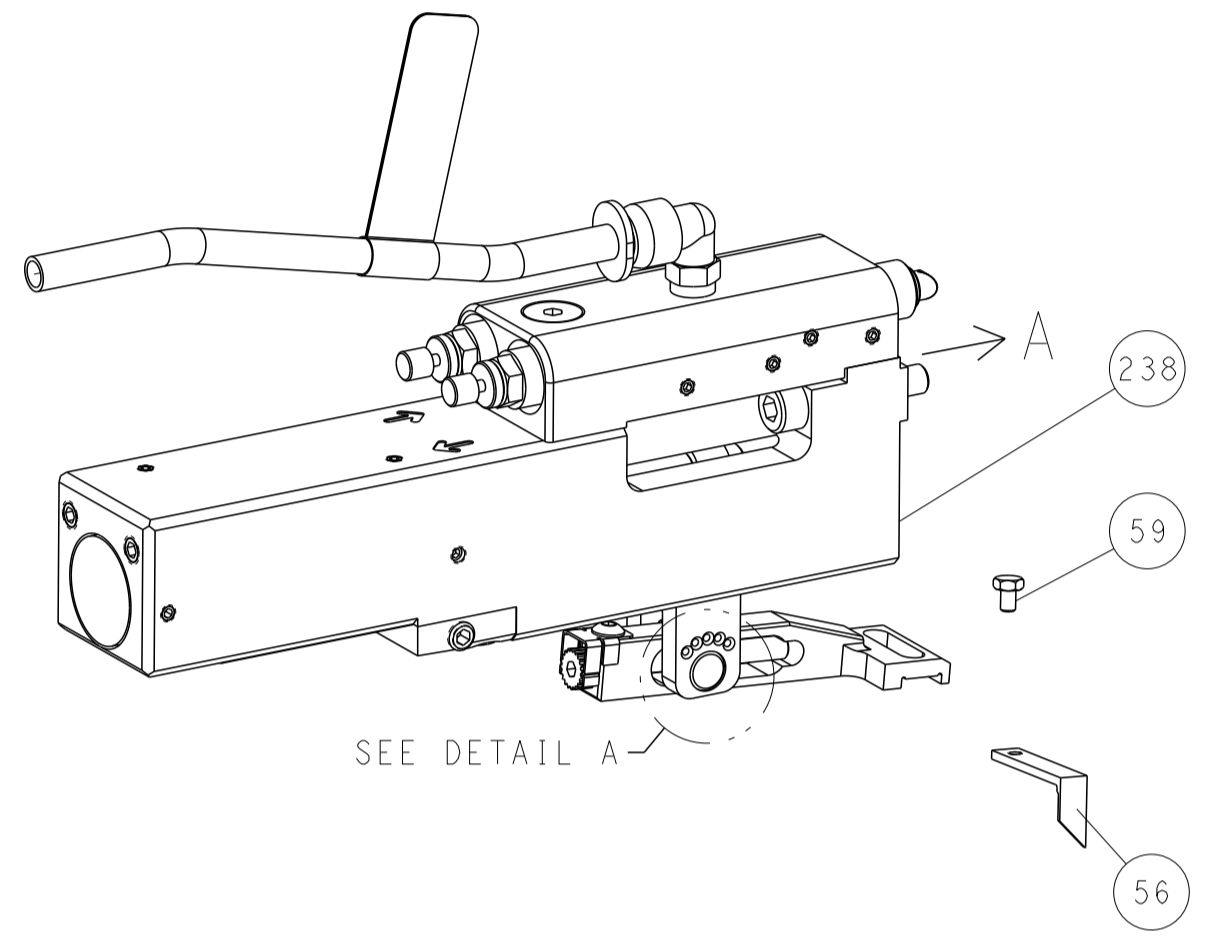
| ITEM NO | PART NO | DESCRIPTION |
|---------|---------|-------------|
| -77-72 | -2 | PART NO |

| | |
|--|----------------------------------|
| OWN: BOB HIGMAN 29APR2015 | TE Connectivity |
| CHK: T. ELBIN 29APR2015 | Harrisburg, PA 17105-3608 |
| APVD: T. ELBIN 29APR2015 | NAME: Ocean Side Feed Applicator |
| PRODUCT SPEC | SIZE: A1 |
| APPLICATION SPEC | CAGE CODE: 00779 |
| WEIGHT | DRAWING NO: 2266739 |
| SCALE: 1:2 | SHEET 1 OF 4 |
| Customer Accessible Production Drawing | REV: E |

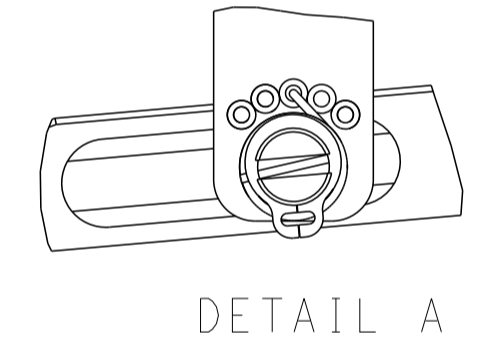
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

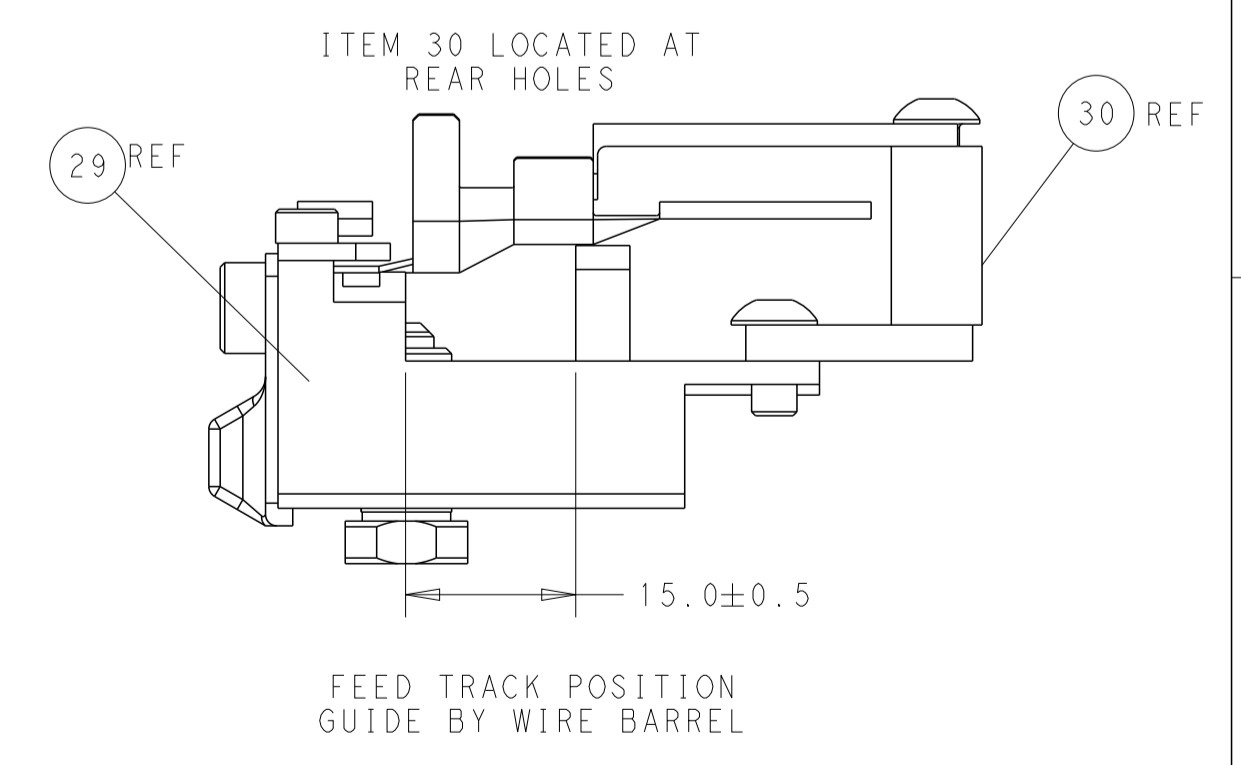
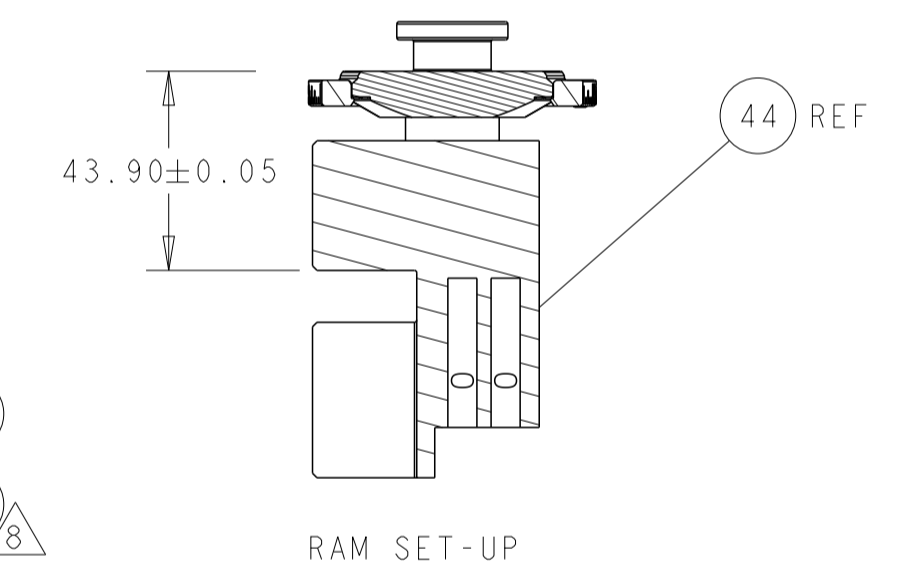
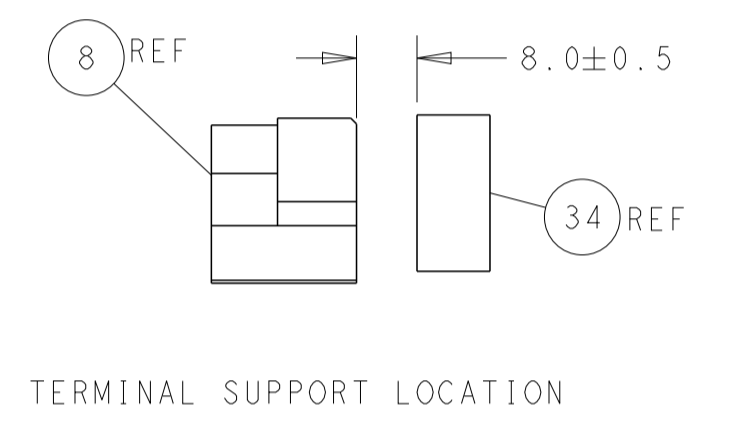
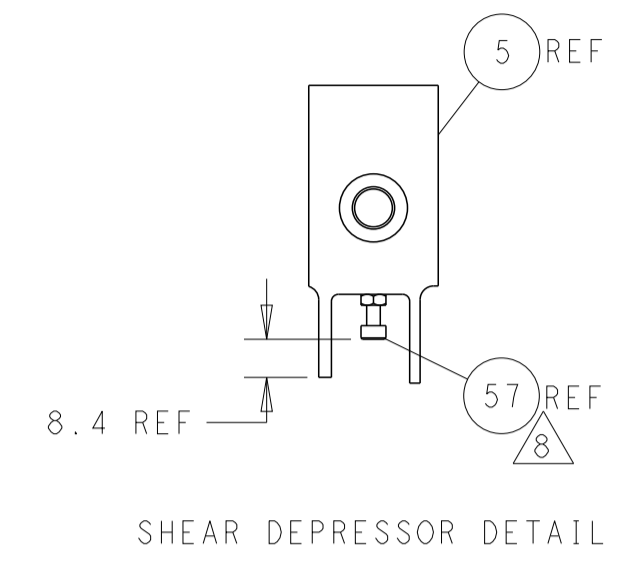
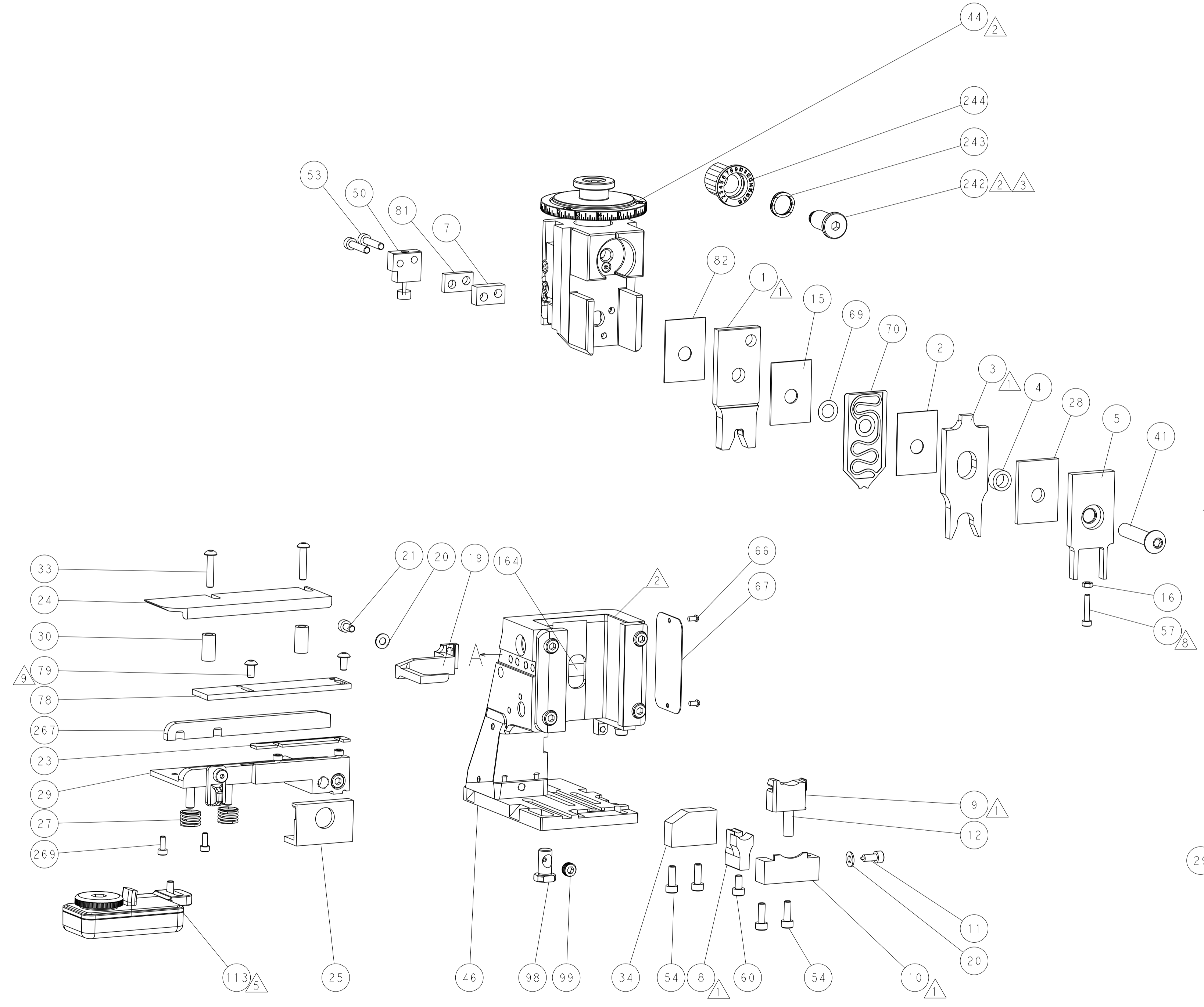
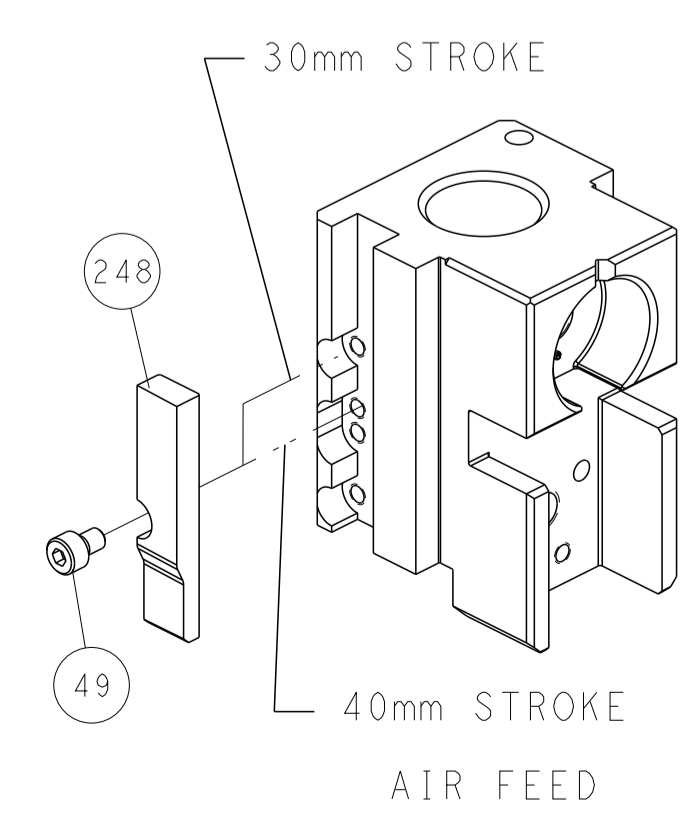
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION

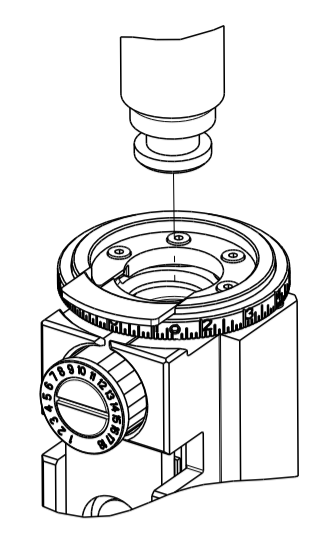


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | | | | |
|-------------|---------|--|--------|--|--|--------------------|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: BOB_HIGMAN 29APR2015 | | TE Connectivity | |
| mm | 0 PLC | ± | | CHK: T.ELBIN 29APR2015 | Harrisburg, PA 17105-3608 | | |
| | 1 PLC | ± | | APVD: T.ELBIN 29APR2015 | NAME: Ocean Side Feed | | |
| | 2 PLC | ± | | PRODUCT SPEC | Applicator | | |
| | 3 PLC | ± | | APPLICATION SPEC | SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO | | |
| | 4 PLC | ± | | ANGLES | A1 00779 C=2266739 | | |
| MATERIAL: | FINISH: | WEIGHT: | SCALE: | Customer Accessible Production Drawing | | SHEET 2 OF 4 REV E | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|-----------|
| 2-2266739-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266739-7 | C | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|-------------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 5.33 mm [.210] | F |
| INSUL | 11.18 mm [.440] | O |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-----------|---------------------------|---|
| TERMINAL NAME: TAB 9.5mm X 1.2mm | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 9.20-9.60 mm [.362-.378 IN] | | Ø | |
| TERMINAL APPLICATION SPECIFICATION | 114-94407 | - | - |

| TERMINALS APPLIED | | | | |
|-------------------|-------------|---------|-----------|--------------------------------|
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL | SEAL INSULATION DIAMETER RANGE |
| 2-2287018-1 | | | 2287390-2 | 5.30-6.00 |
| | | | 2287390-5 | 4.60-5.00 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|------------------------------|--------------------------------|
| 10.00mm2 | 3.35+/-0.10 [.132+/- .004] | 2.6 |
| 8.00mm2 | 3.05+/-0.10 [.120+/- .004] | 5.8 |

***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.

- 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.
- 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 LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- CUT TO LENGTH AT ASSEMBLY.

| 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 | 1633782-7 | FENCE | 267 |
| - | 1 | 2119082-6 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| 3 | - | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 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 | 2-1803583-7 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1803516-2 | RAM ASSEMBLY, SF PACIFIC | 140 |
| 5 | - | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 455888-7 | SPACER, CRIMPER | 82 |
| - | 1 | 2-240641-4 | SPACER | 81 |
| 9 | - | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 79 |
| - | 1 | 1803096-1 | EXTENSION PLATE | 78 |
| - | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1-2119791-1 | DEPRESSOR, WIRE | 70 |
| - | 1 | 2119943-1 | WASHER, SPACER | 69 |
| - | 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 |
| 8 | - | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16 | 57 |
| - | 1 | 1-1338683-1 | FEED PAWL | 56 |
| - | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 53 |
| - | 1 | 1803382-4 | HOLD DOWN, SPRING LOADED | 50 |
| - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1803602-2 | SCR, BHSC, RoHS (M8 X 40) | 41 |
| - | 1 | 1752356-8 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 3-2844962-2 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 2844992-5 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 3-455888-7 | SPACER, CRIMPER | 28 |
| - | 2 | 1-22284-0 | SPRING, COMPRESSION | 27 |
| - | 1 | 240792-1 | DRAG, TERMINAL | 25 |
| - | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 1-690438-0 | FRONT STRIP GUIDE | 23 |
| - | 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 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 16 |
| - | 1 | 1-455888-0 | SPACER, CRIMPER | 15 |
| - | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1-356885-3 | STOP, SHEAR | 11 |
| 1 | - | 2-2119805-0 | SHEAR HOLDER, FRONT | 10 |
| 1 | - | 1-318059-2 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1-1803383-7 | ANVIL, COMBINATION | 8 |
| - | 1 | 2-240641-5 | SPACER | 7 |
| - | - | - | - | 6 |
| - | 1 | 1-1803080-2 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 4-238011-4 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 5-1633966-7 | CRIMPER, INSULATION O | 3 |
| - | 1 | 455888-6 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1-1633773-3 | CRIMPER, WIRE, STEP | 1 |

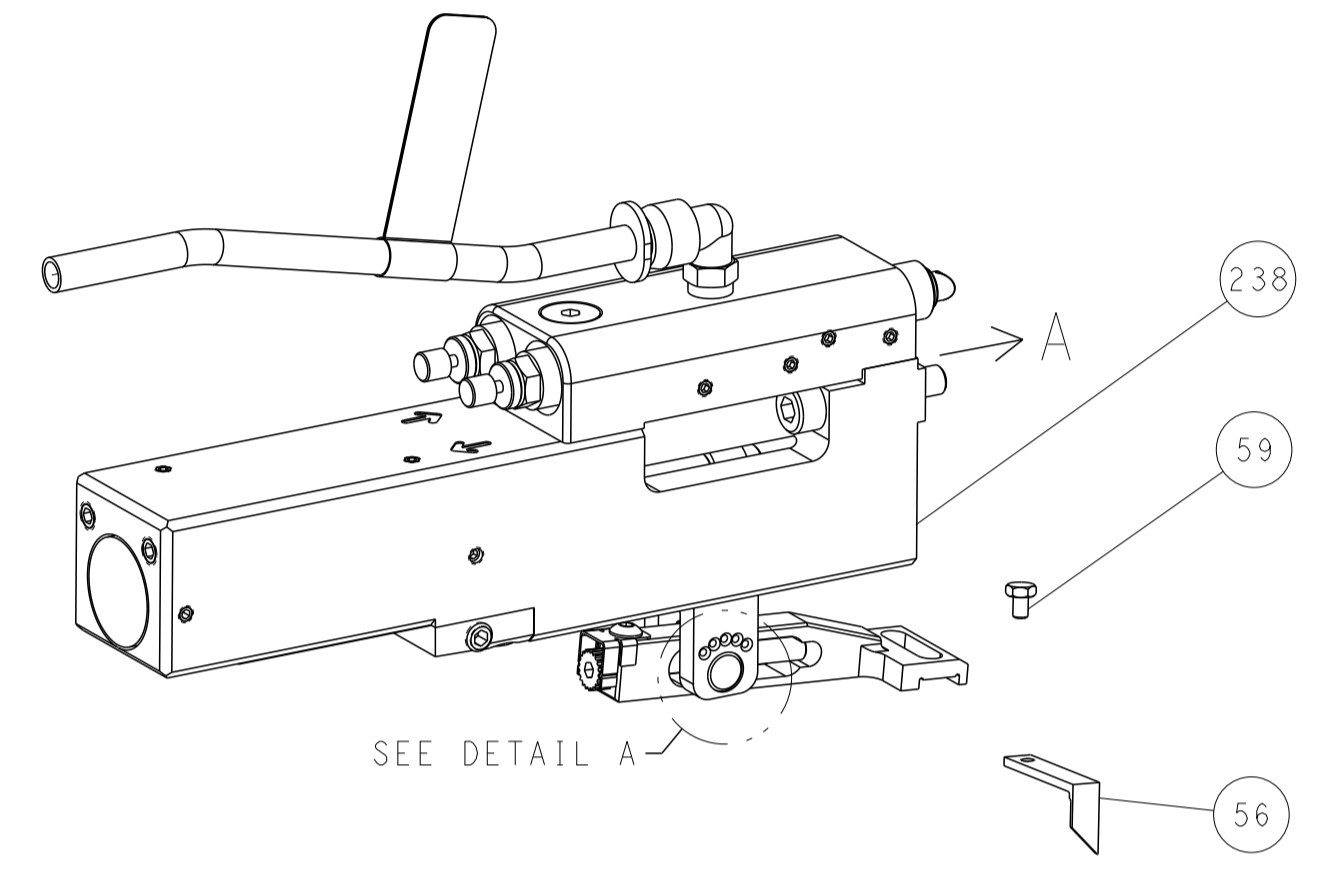
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

| | | | | | | | | | | | |
|----------------|--|--|--|---------------------------|--|-------------------------|--|--------------------------|--|----------------------------------|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: BOB HIGMAN 29APR2015 | | CHK: T. ELBIN 29APR2015 | | APVD: T. ELBIN 29APR2015 | | NAME: Ocean Side Feed Applicator | |
| 0 PLC ± | | 1 PLC ± | | 2 PLC ± | | 3 PLC ± | | 4 PLC ± | | RESTRICTED TO | |
| ANGLES | | FINISH | | WEIGHT | | SCALE | | SHEET | | REV | |
| - | | - | | - | | A 00779 | | 3 | | E | |

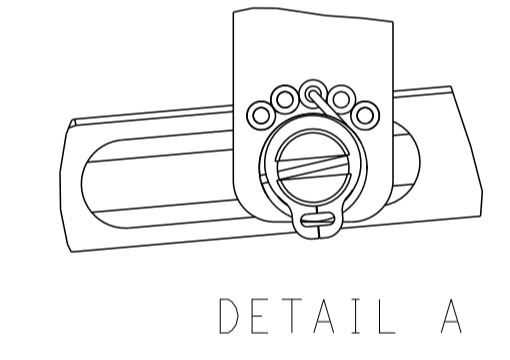
Customer Accessible Production Drawing

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

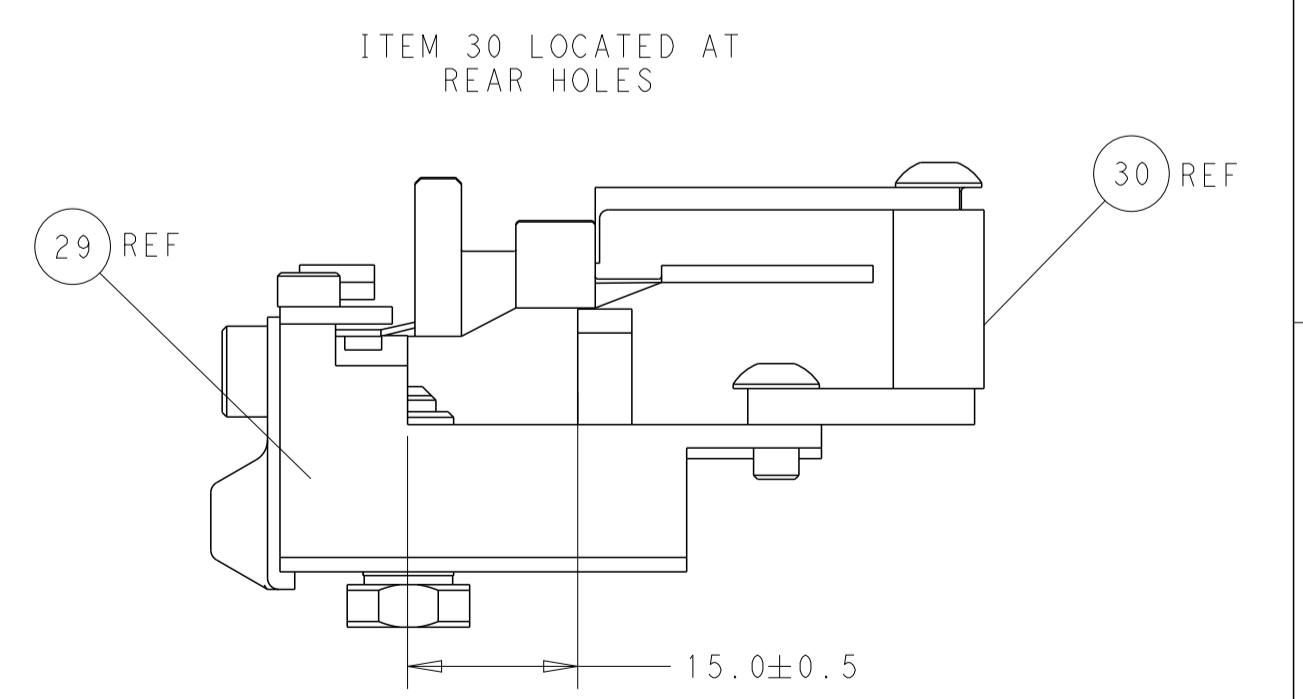
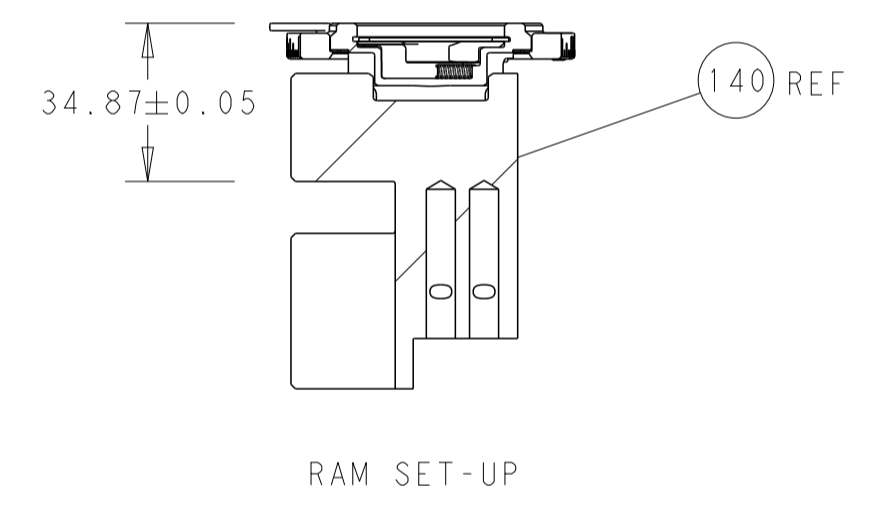
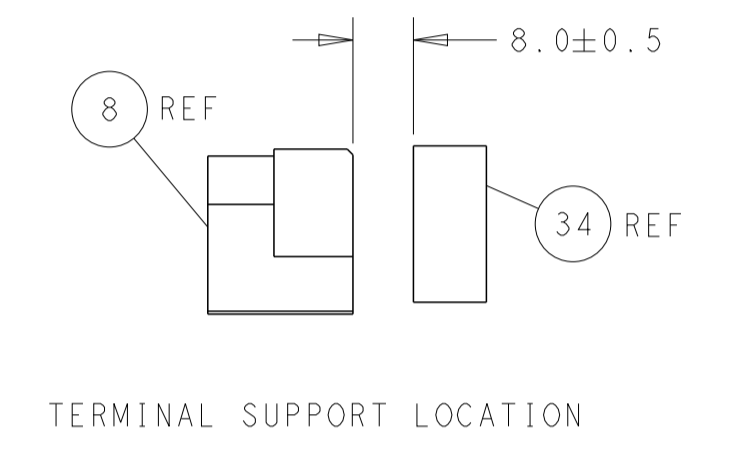
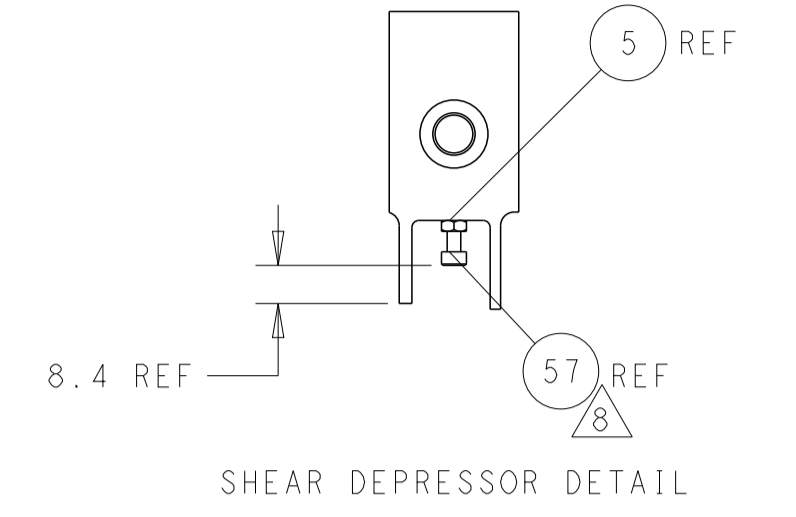
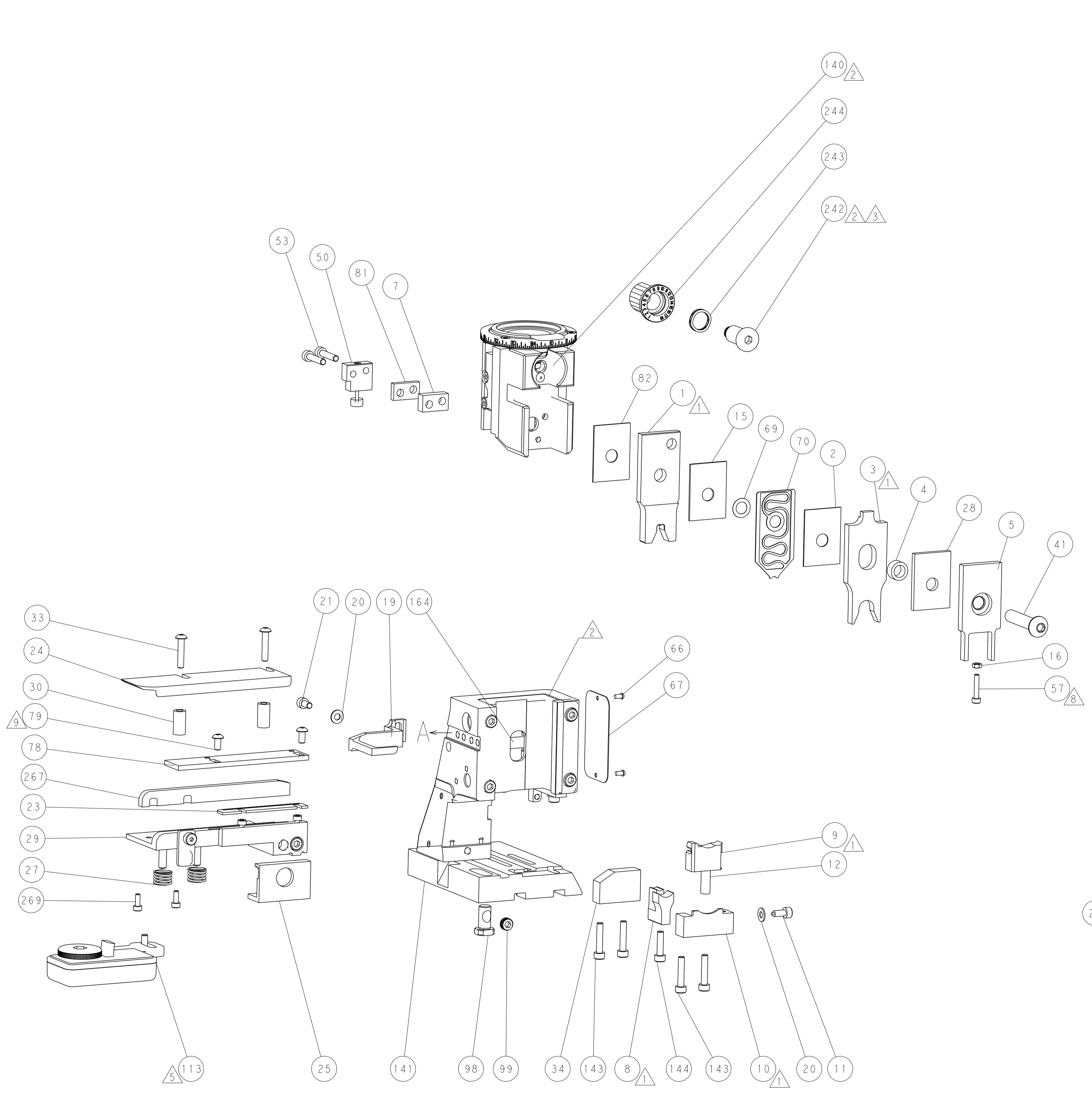
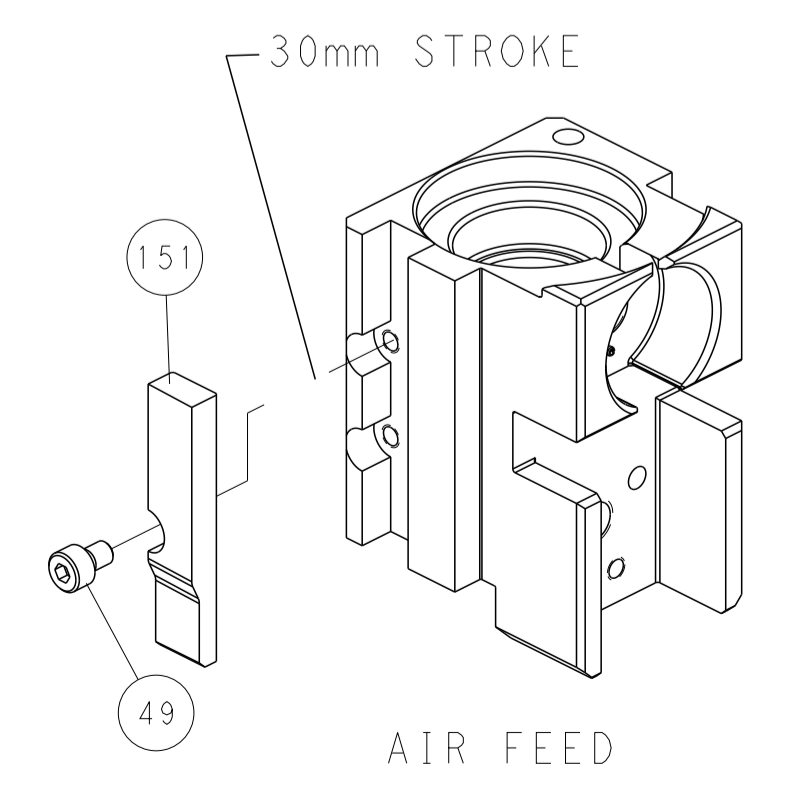
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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 UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN BOB HIGMAN 29APR2015 CHK T. ELBIN 29APR2015 APVD T. ELBIN 29APR2015 | NAME STE TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH - | TOLERANCES UNLESS OTHERWISE SPECIFIED: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH - | PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2266739 | RESTRICTED TO Customer Accessible Production Drawing SCALE 1:2 SHEET 4 OF 4 REV E |