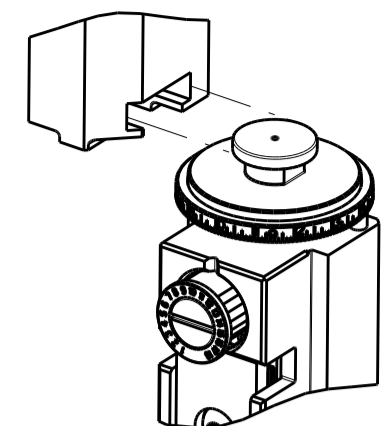


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266820-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266820-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266820-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

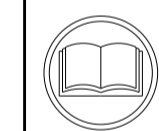


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.40 mm [.173]	○
INSUL	5.31 mm [.209]	○

APPLICATOR INSTRUCTIONS 408-35042

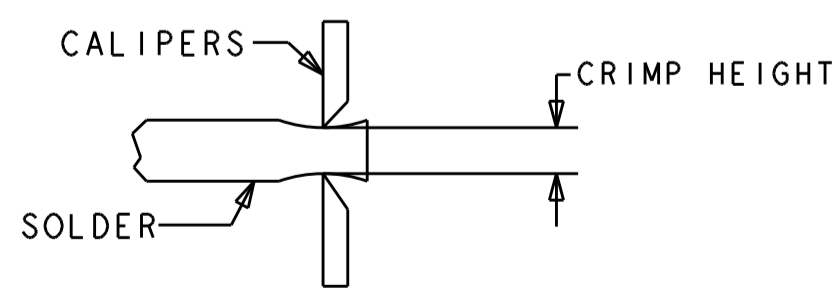
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: OUTER FERRULE, 180 DEGREE, LARGE CABLE FAKRA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	Ø4.00-5.00 mm [.157-.197 IN]
TERMINAL APPLICATION SPECIFICATION	114-32145		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2272409-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-58	4.50+/-0.03 [.177+/-0.001]	5.0
RG-58LL	4.50+/-0.03 [.177+/-0.001]	5.0



- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

△ TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø6.35mm [.250 IN] 50/50 SOLID CORE) AND MEASURE AT END OF SLUG.



△ SEE APPLICATION SPECIFICATION 114-32145 FOR RECOMMENDED STRIP LENGTH DIMENSIONS.

***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	REVISIONS			
A	66	REV	DATE	BY	CHKD
		E1	ECR-17-014468	29SEP2017	MZ KZ
		F	ECR-18-011731	23JUL2018	AW GB
		G	ECR-18-015307	27SEP2018	MZ TE
		H	ECR-19-011147	16JUL2019	MZ YY

-	1	1	1803078-3	SPACER, PRECISION	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	
△	-	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	
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230	
-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	224	
-	1	1	1803340-1	PLATE, RETAINING	222	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
△	-	1	1	1-1752354-6	STANDOFF, HOLD-DOWN	180
-	1	1	2-1976053-6	LOCATER BLOCK, TERMINAL	179	
-	1	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	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	1-455888-1	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	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1901681-8	HOLDDOWN, TERMINAL	51	
-	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	4-18023-0	SCR, SKT HD CAP M8 X 50.0	41	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	36	
-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33	
-	2	2	4-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-5	SPACER, CRIMPER	28	
-	1	1	1803306-1	PLATE, RETAINING	27	
-	1	1	1803308-1	SUPPORT, TERMINAL	25	
-	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	318563-1	GUARD, FRONT CHIP	16	
-	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	2119805-1	SHEAR HOLDER, FRONT	10
△	-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
△	1	2	1	1803249-2	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4	
△	1	2	1	5-1633966-1	CRIMPER, INSULATION O	3
△	-	1	1	1-455888-2	SPACER, CRIMPER	2
△	1	2	1	2-1633723-2	CRIMPER, WIRE O	1
-	77	72	-2	PART NO	ITEM NO	

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

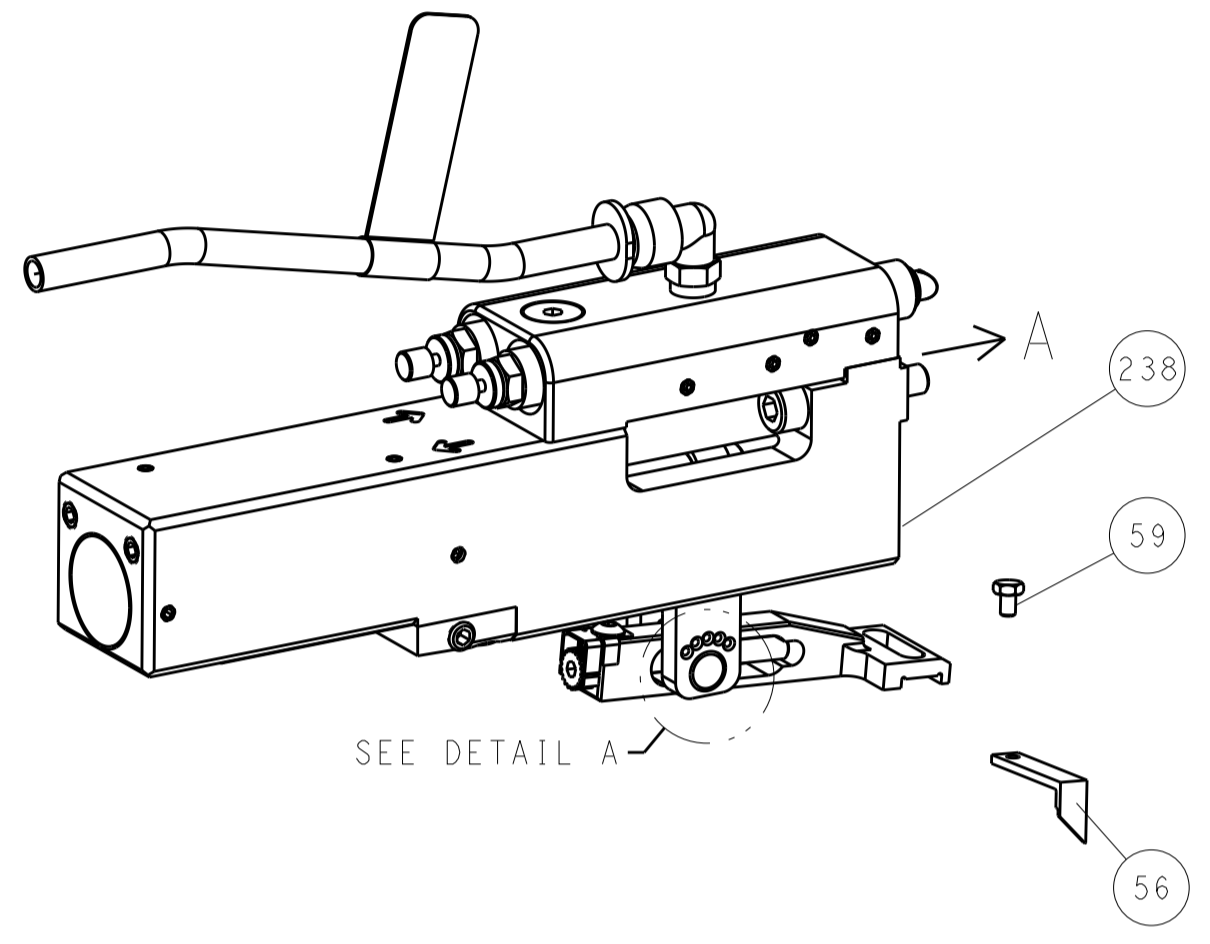
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	

DATE	28JAN2016	CHKD	BOB HIGMAN
DATE	28JAN2016	CHKD	T. ELBIN
DATE	28JAN2016	APVD	T. ELBIN
PRODUCT SPEC		APPLICATION SPEC	
SIZE	A1	CAGE CODE	00779
DRAWING NO	2266820	SCALE	1:2
SHEET	1	OF	4
REV	H		

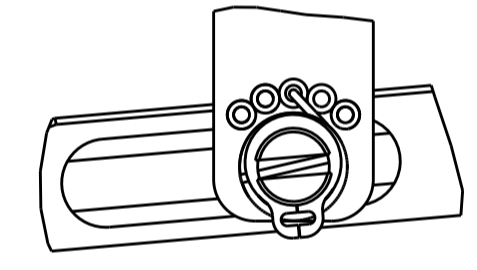
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

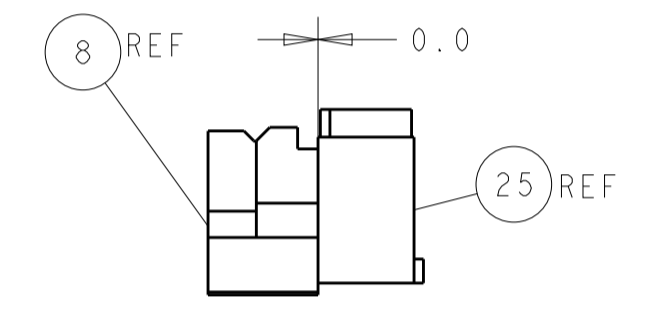
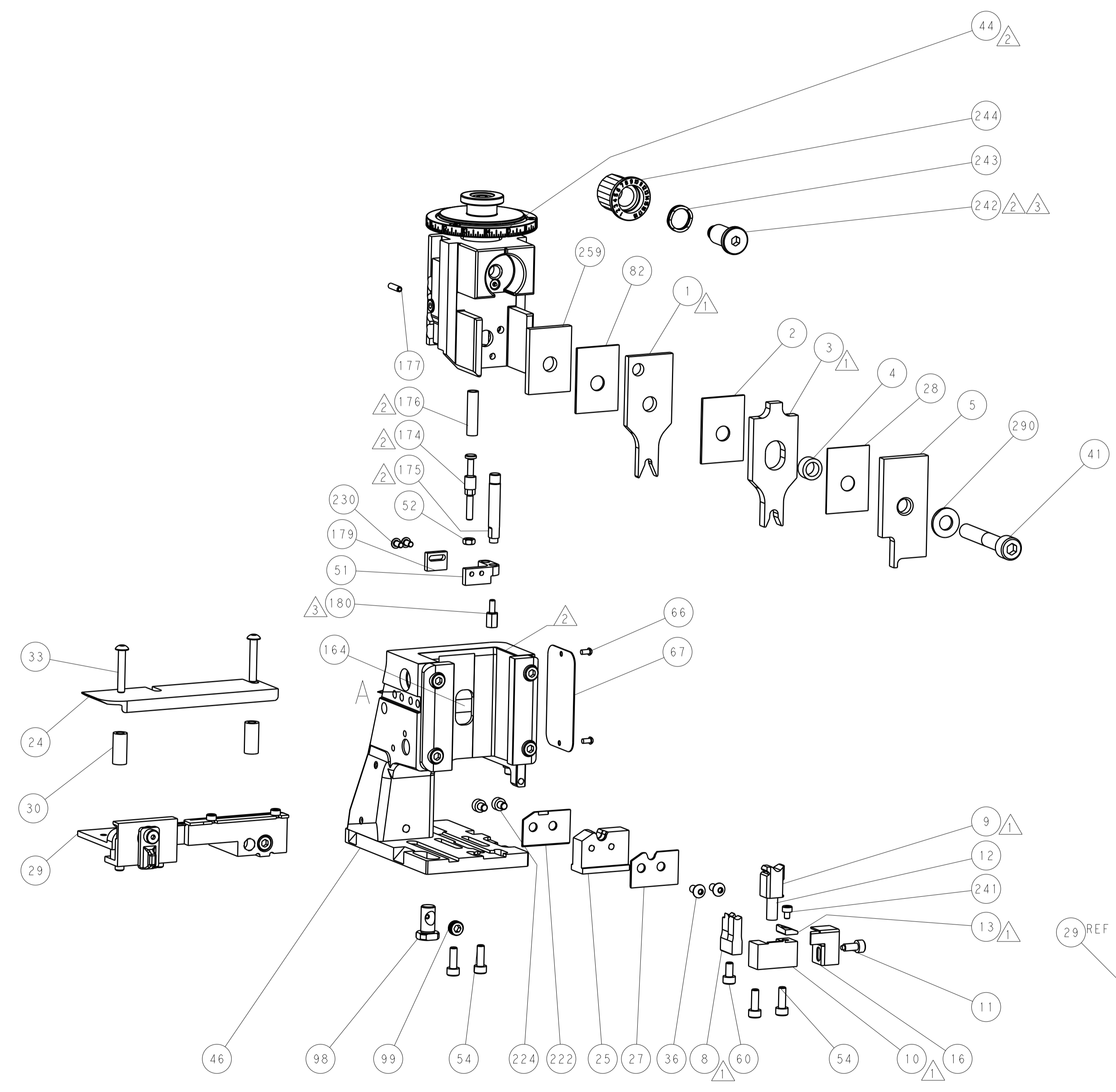
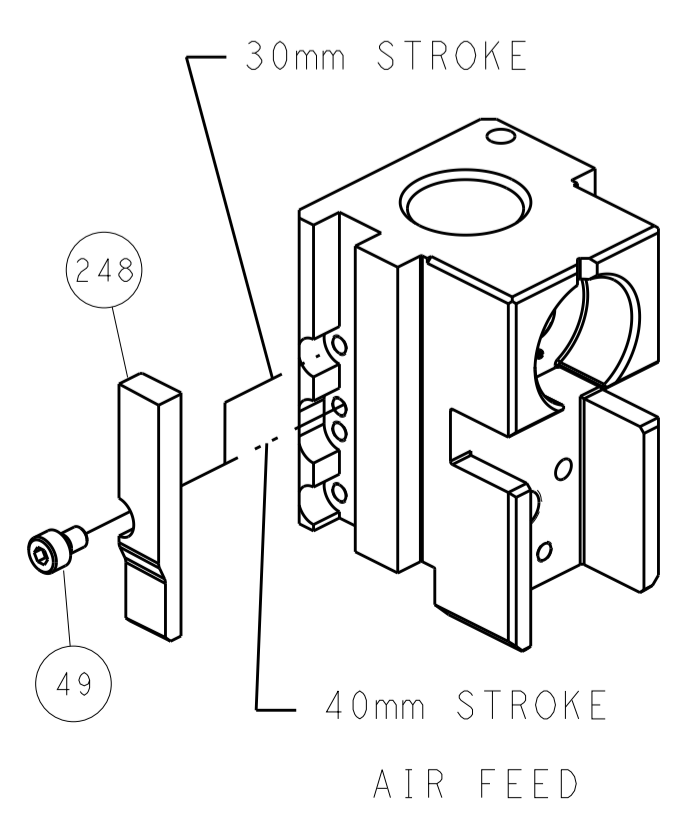


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

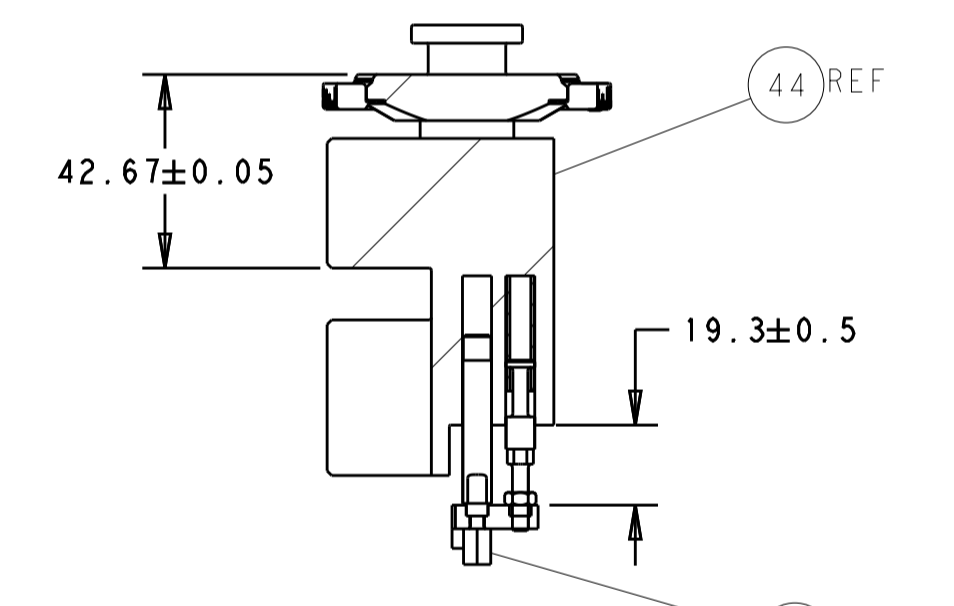


DETAIL A

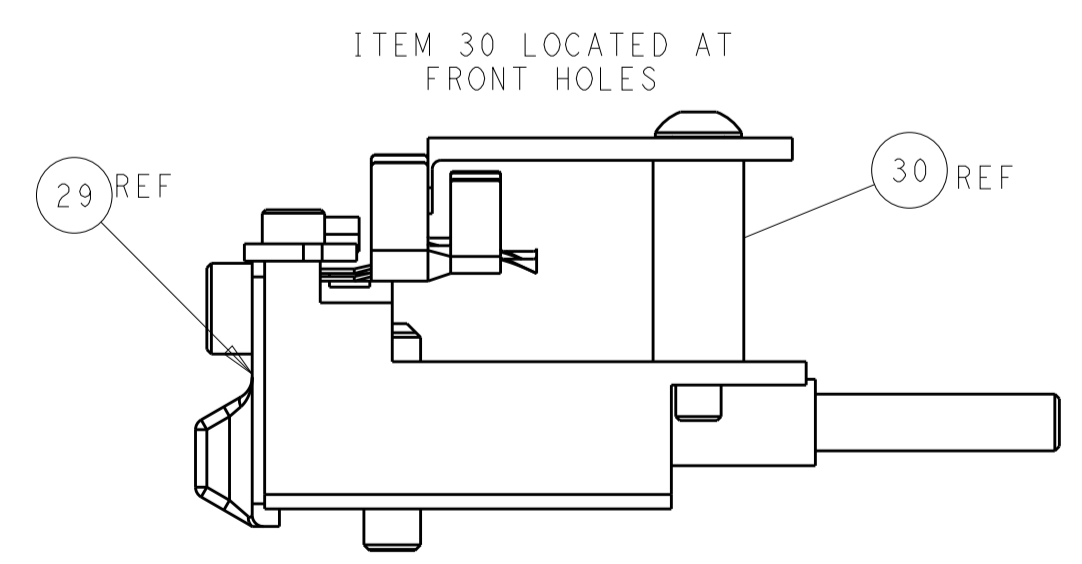
CAM POSITION



TERMINAL SUPPORT LOCATION



HOLDDOWN AND RAM 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:		OWN: BOB HIGMAN 28JAN2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±			CHK: T. ELBIN 28JAN2016	NAME: Ocean Side Feed Applicator		
MATERIAL:	FINISH:			APVD: T. ELBIN 28JAN2016	PRODUCT SPEC:		
				APPLICATION SPEC:		SIZE: A1	CAGE CODE: 00779
				WEIGHT:		SCALE: 1:2	SHEET: 2 OF 4
				Customer Accessible Production Drawing		REV: H	

THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266820-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266820-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



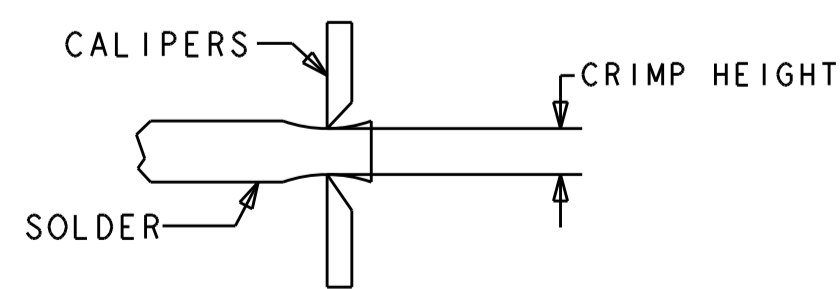
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.40 mm [.173]	0
INSUL	5.31 mm [.209]	0
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: OUTER FERRULE, 180 DEGREE, LARGE CABLE FAKRA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE Ø4.00-5.00 mm [.157-.197 IN]	
TERMINAL APPLICATION SPECIFICATION	114-32145	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2272409-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-58	4.50+/-0.03 [.177+/-0.001]	5.0
RG-58LL	4.50+/-0.03 [.177+/-0.001]	5.0



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø6.35mm [.250 IN] 50/50 SOLID CORE) AND MEASURE AT END OF SLUG.



- 8 SEE APPLICATION SPECIFICATION 114-32145 FOR RECOMMENDED STRIP LENGTH DIMENSIONS.

***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.

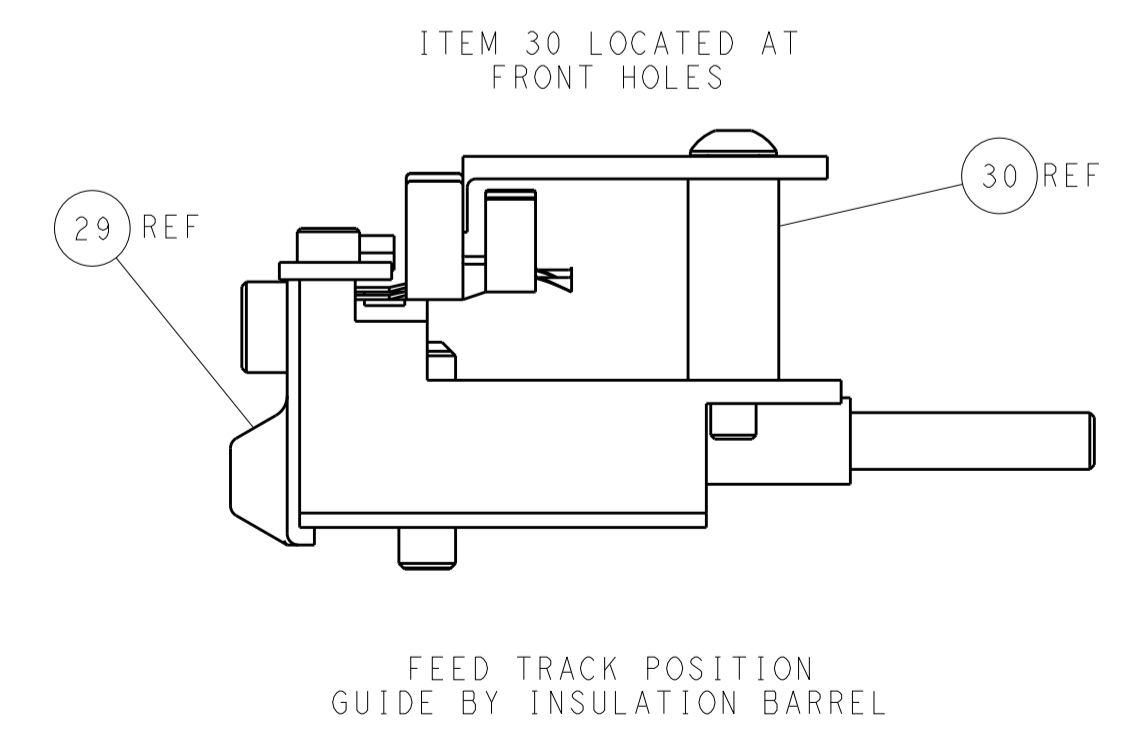
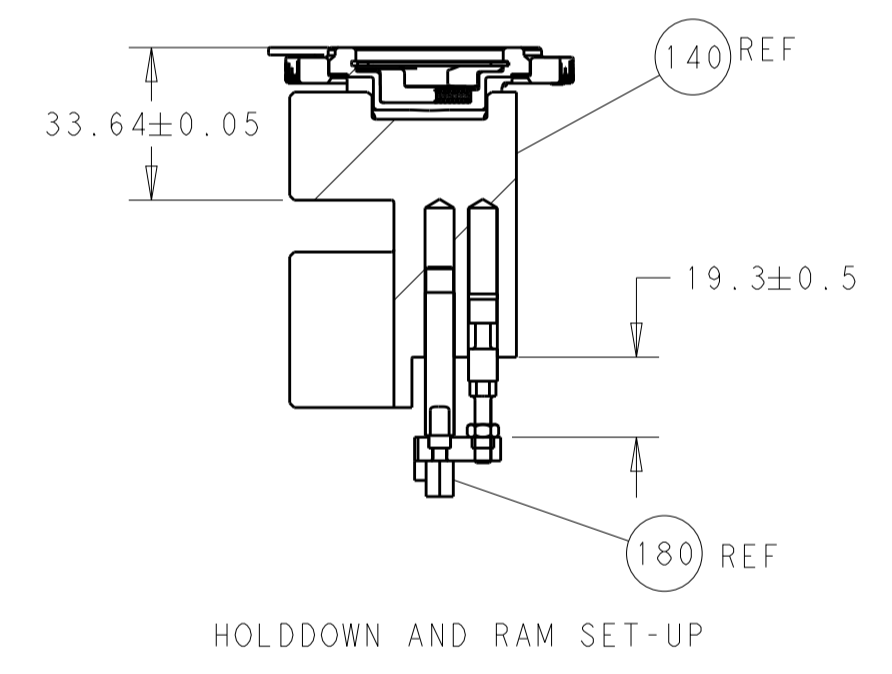
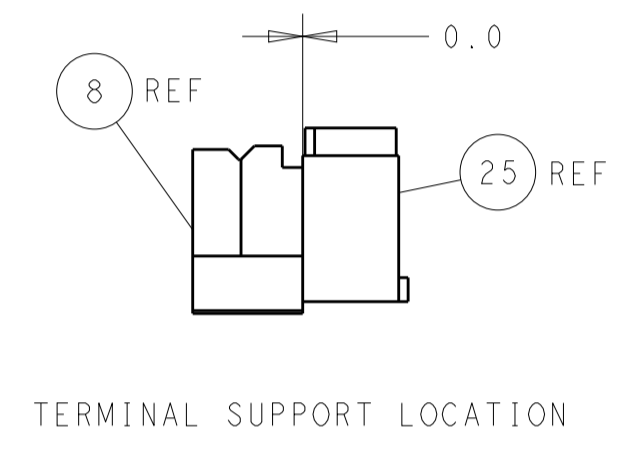
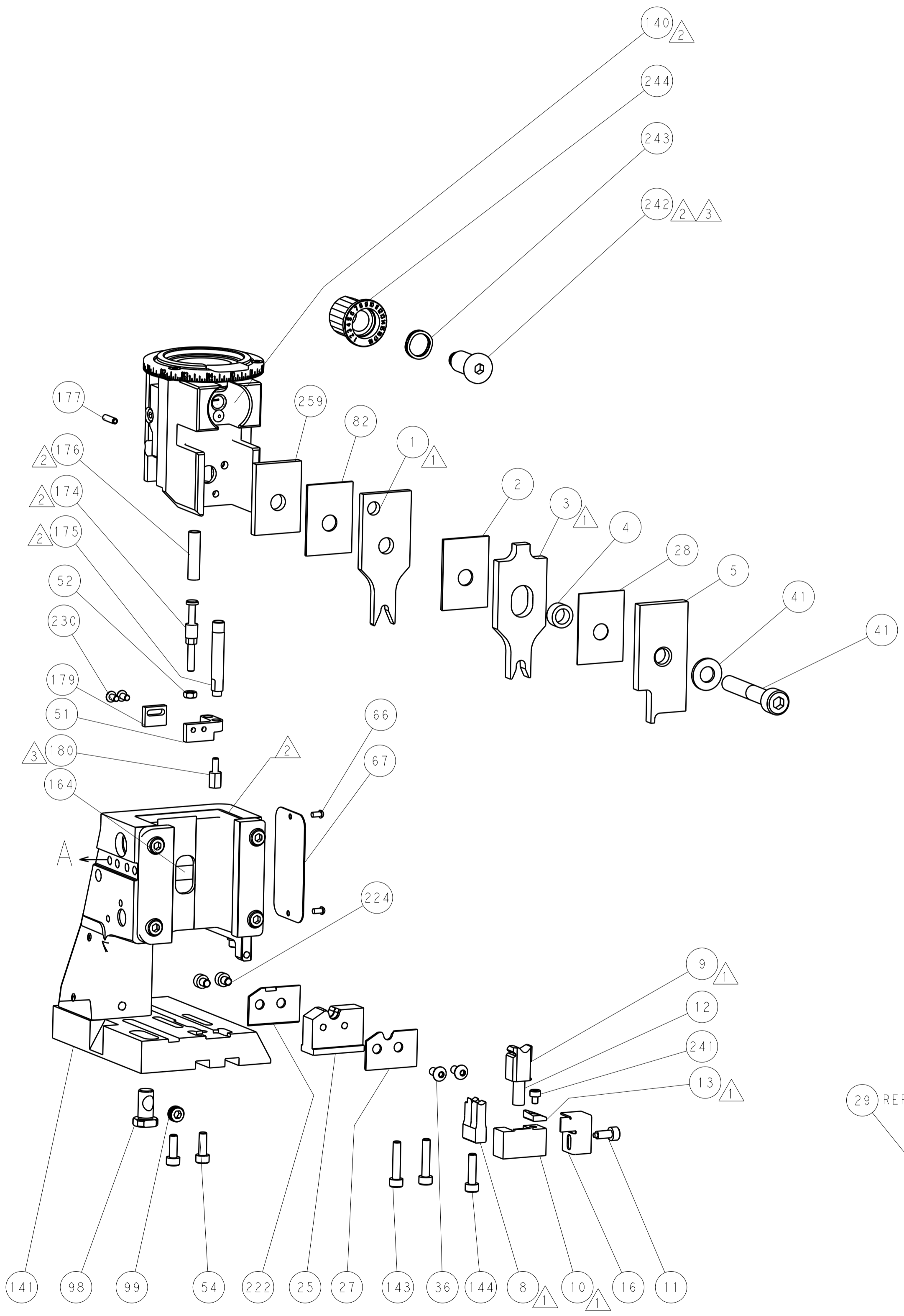
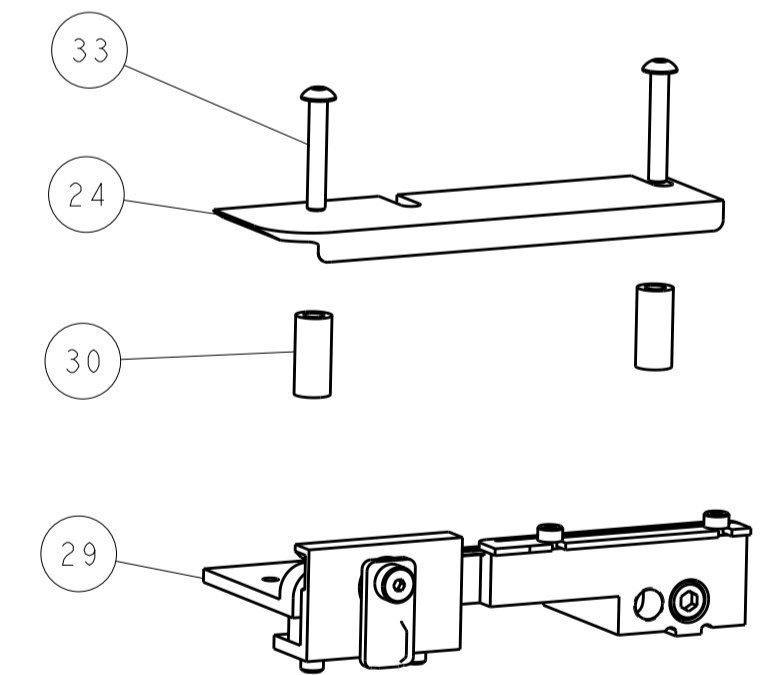
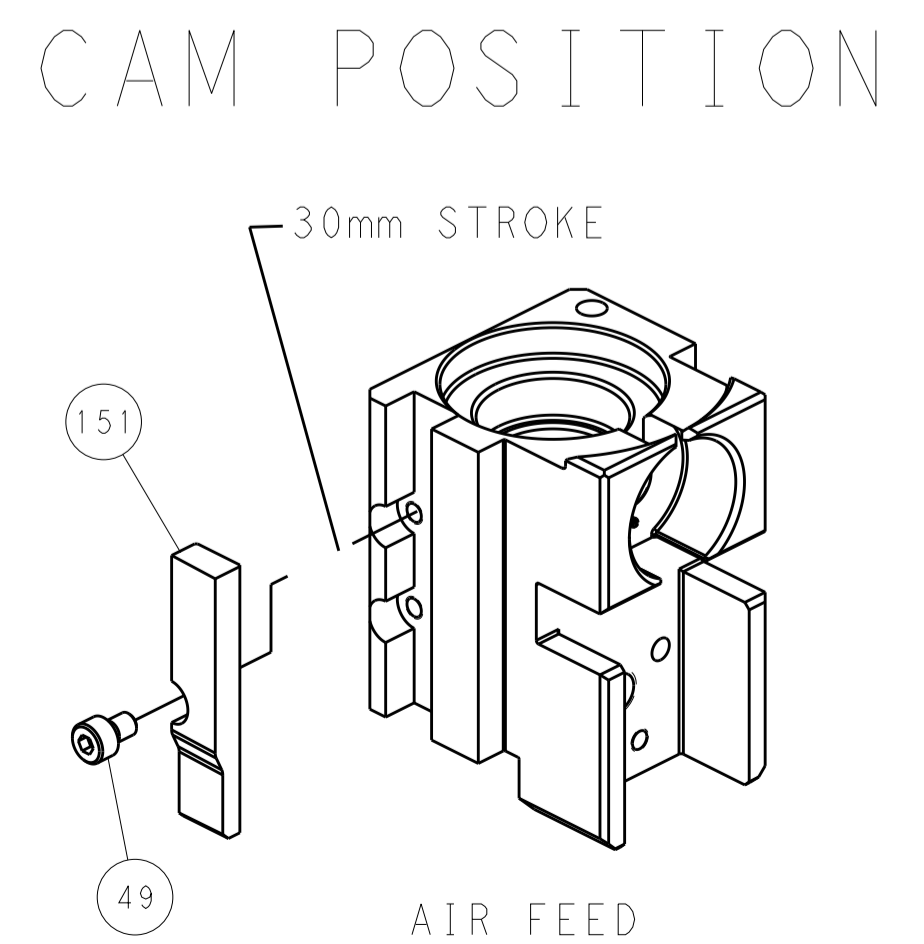
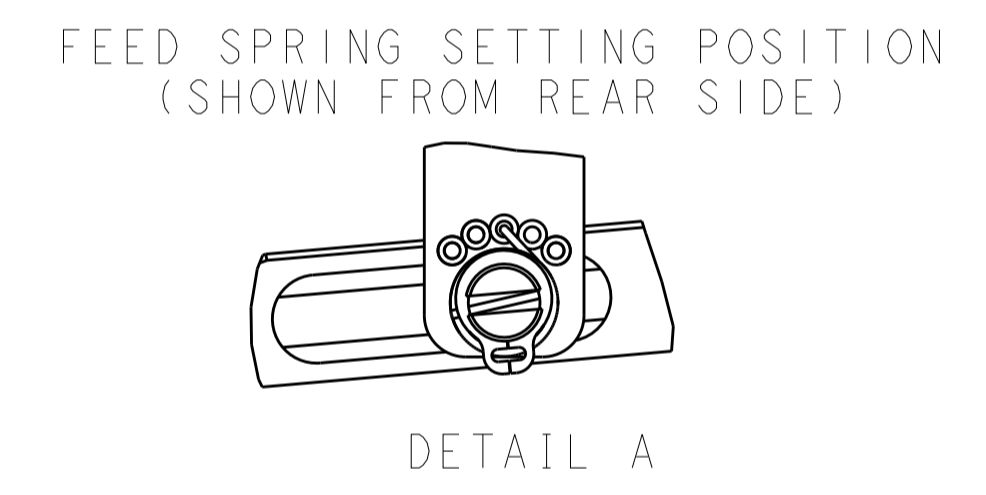
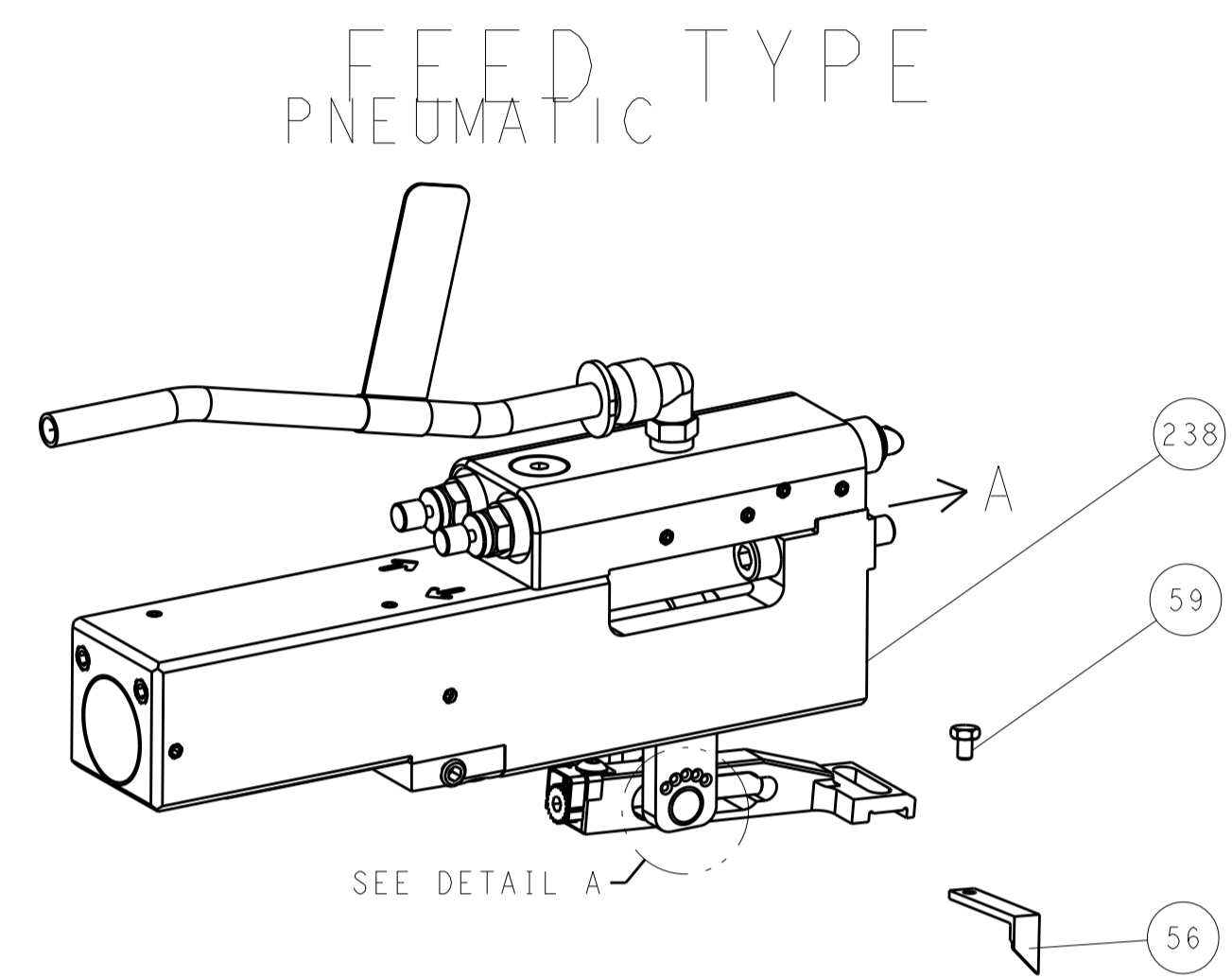
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1803078-3	SPACER, PRECISION	259	
-	1	2119082-3	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	2844940-2	AIR FEED MODULE	238	
-	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230	
-	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	224	
-	1	1803340-1	PLATE, RETAINING	222	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
3	-	1	1-1752354-6	STANDOFF, HOLD-DOWN	180
-	1	2-1976053-6	LOCATER BLOCK, TERMINAL	179	
-	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	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	
-	2	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	1-455888-1	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1901681-8	HOLDDOWN, TERMINAL	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	4-18023-0	SCR, SKT HD CAP M8 X 50.0	41	
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	36	
-	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33	
-	2	4-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-5	SPACER, CRIMPER	28	
-	1	1803306-1	PLATE, RETAINING	27	
-	1	1803308-1	SUPPORT, TERMINAL	25	
-	1	1320928-2	STRIP GUIDE	24	
-	1	318563-1	GUARD, FRONT CHIP	16	
1	-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1-356885-4	STOP, SHEAR	11	
-	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1803095-1	FLOATING SHEAR, FRONT	9	
1	1	1803249-2	ANVIL, COMBINATION	8	
-	-	-	-	7	
-	-	-	-	6	
-	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	4-238011-4	BLOCK, CRIMPER SPACER	4	
1	1	5-1633966-1	CRIMPER, INSULATION 0	3	
-	1	1-455888-2	SPACER, CRIMPER	2	
1	1	2-1633723-2	CRIMPER, WIRE 0	1	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 28JAN2016		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME: Ocean Side Feed Applicator	
MATERIAL:		FINISH:		APVD: T. ELBIN 28JAN2016		SIZE: A1	
WEIGHT:		SCALE: 1:2		CAGE CODE: 00779		DRAWING NO: 2266820	
RESTRICTED TO:		SHEET: 3 OF 4		REV: H		Customer Accessible Production Drawing	

LOC		DIST		REVISIONS					
A		66		P.	LTH	DESCRIPTION	DATE	DWN	APVD
				-	-	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:		DWN BOB HIGMAN 28JAN2016		TE Connectivity	
mm		0 PLC ±		CHK T. ELBIN 28JAN2016		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD T. ELBIN 28JAN2016		NAME	
H		2 PLC ±		PRODUCT SPEC		Ocean Side Feed	
L		3 PLC ±		APPLICATION SPEC		Applicator	
R		4 PLC ±		SIZE		CAGE CODE DRAWING NO	
S		5 PLC ±		WEIGHT		A1 00779 C=2266820	
T		6 PLC ±		MATERIAL		SCALE	
Ø		7 PLC ±		FINISH		1:2 SHEET 4 OF 4 REV H	
H		8 PLC ±		RESTRICTED TO		Customer Accessible Production Drawing	
L		9 PLC ±		Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV H	