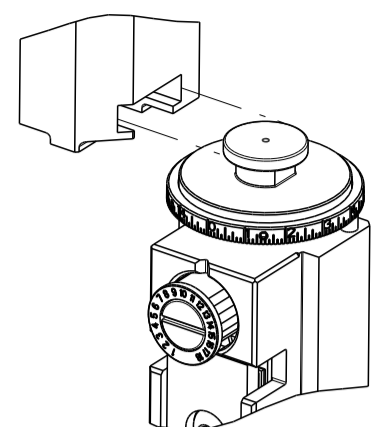


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266976-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266976-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266976-7	A	CRIMP TOOLING KIT	-

SUPERSEDED BY 4151077-2
 SUPERSEDED BY 7-4151077-2

ATLANTIC VERSION TERMINATOR
 INTERFACE ADAPTER

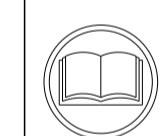


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [1.00]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, SPT OVER MOLD DESIGN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.90-4.50 mm [1.54-.177 IN]		∅ -	
TERMINAL APPLICATION SPECIFICATION		114-32163	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238083-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.35mm2	1.52 +/- 0.05 [1.060 +/- .002]	6.7
1.25mm2	1.49 +/- 0.05 [1.059 +/- .002]	7.0
1.00mm2	1.35 +/- 0.05 [1.053 +/- .002]	8.5
0.75mm2	1.35 +/- 0.05 [1.053 +/- .002]	8.4



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 51
- TERMINAL LUBRICANT IS RECOMMEND.

***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	P	LTN	DESCRIPTION	DATE	OWN	APVD
		C		ECR-18-014509	10OCT2018	MS	CT
		D		ECR-19-009367	14JUN2019	FJ	TE
		E		ECR-21-003119	11MAR2021	JWC	RK
		E1		ECR-22-127828	26JAN2022	LG	GB

-	1	1	1633601-3	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	1-455888-3	SPACER, CRIMPER	120	
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	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	1-455888-9	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	1	1	811242-6	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	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	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	22283-1	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	3-189124-7	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	3-1803012-3	PLATE, REAR SHEAR	15	
-	1	1	1-2119928-8	FENCE	12	
-	-	-	-	-	10	
-	-	-	-	-	9	
-	-	-	-	-	8	
-	-	-	-	-	7	
-	-	-	-	-	6	
-	-	-	-	-	5	
-	-	-	-	-	4	
-	-	-	-	-	3	
-	-	-	-	-	2	
-	1	2	1	456407-5	CRIMPER, WIRE PREMIUM	1

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	FINISH

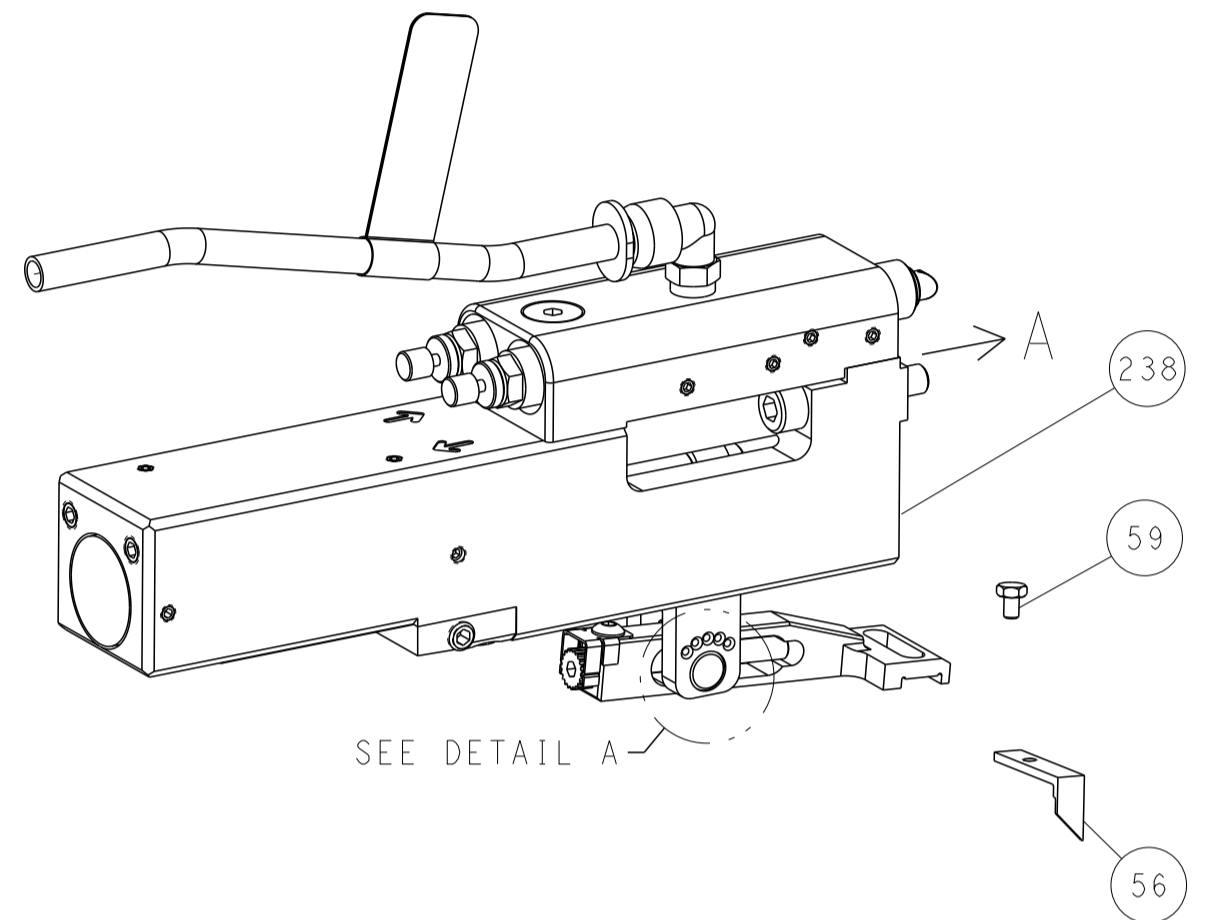
ITEM NO	DESCRIPTION	QTY
-77-72 -2	PART NO	
	DESCRIPTION	

OWN: BOB HIGMAN	22SEPT2015	TE Connectivity Harrisburg, PA 17105-3608	
CHK: T. ELBIN	22SEPT2015		
APVD: T. ELBIN	22SEPT2015		
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266976	
Customer Accessible Production Drawing			SCALE: 1:2 SHEET 1 OF 4 REV: E1

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

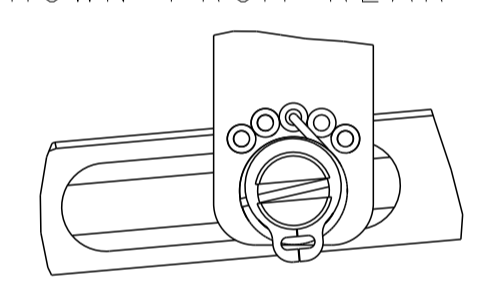
FEED TYPE

PNEUMATIC



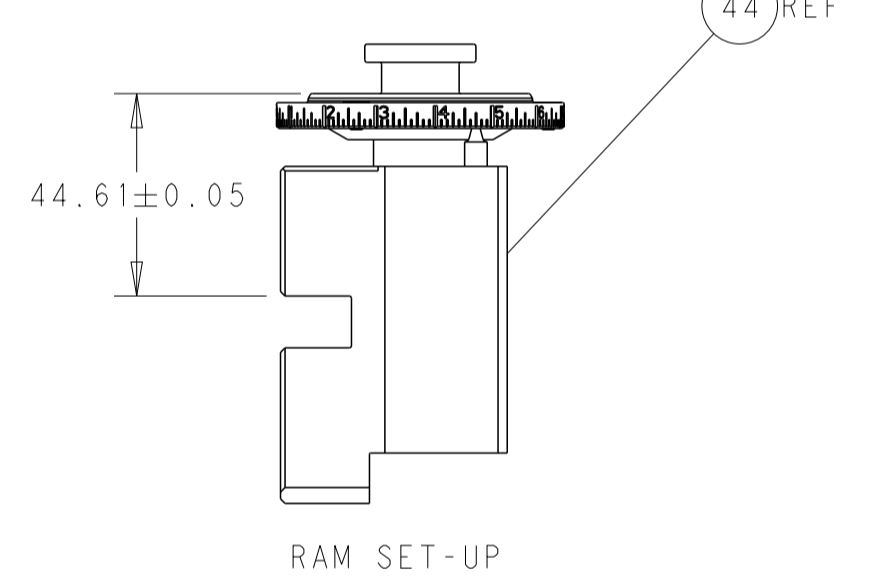
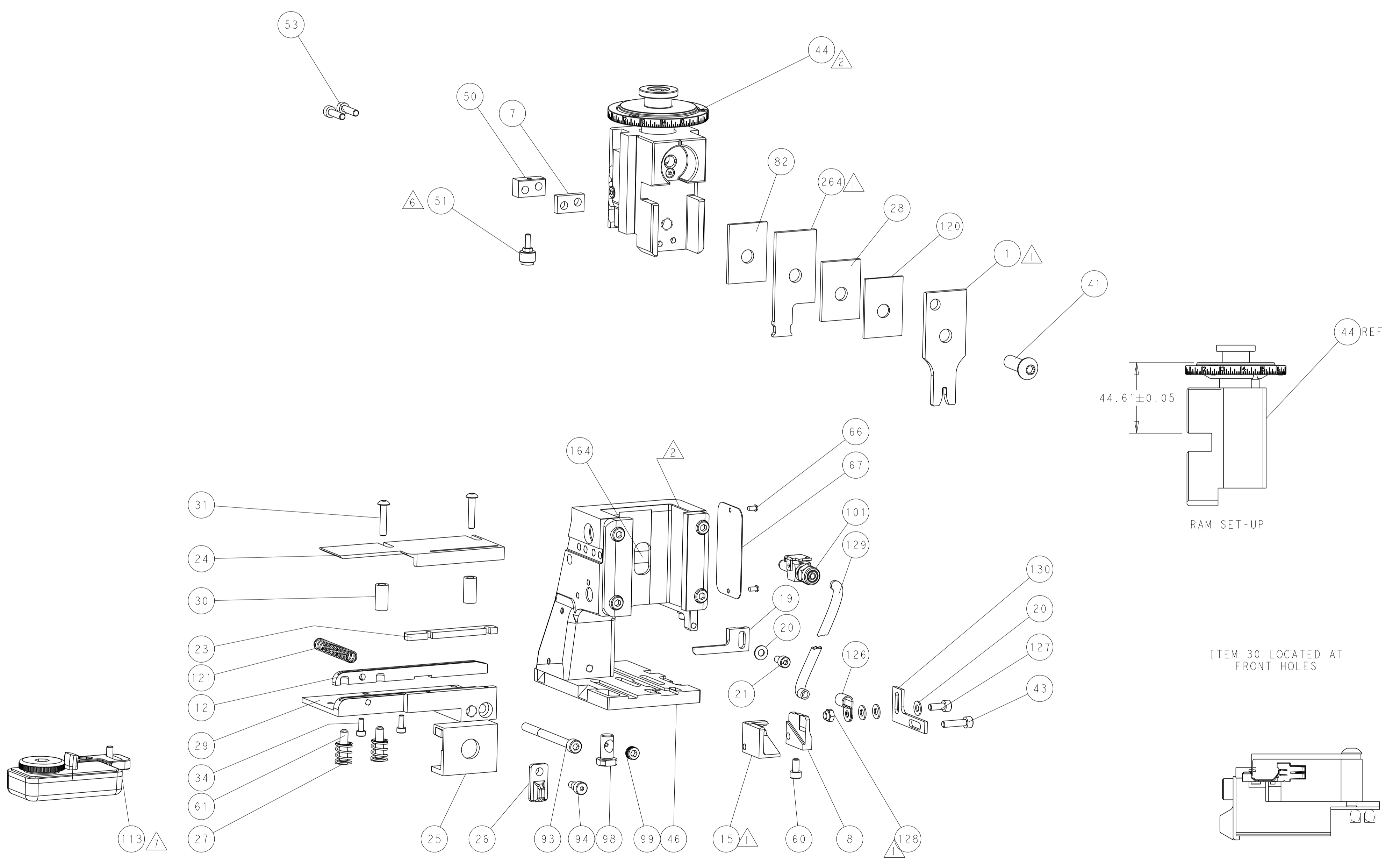
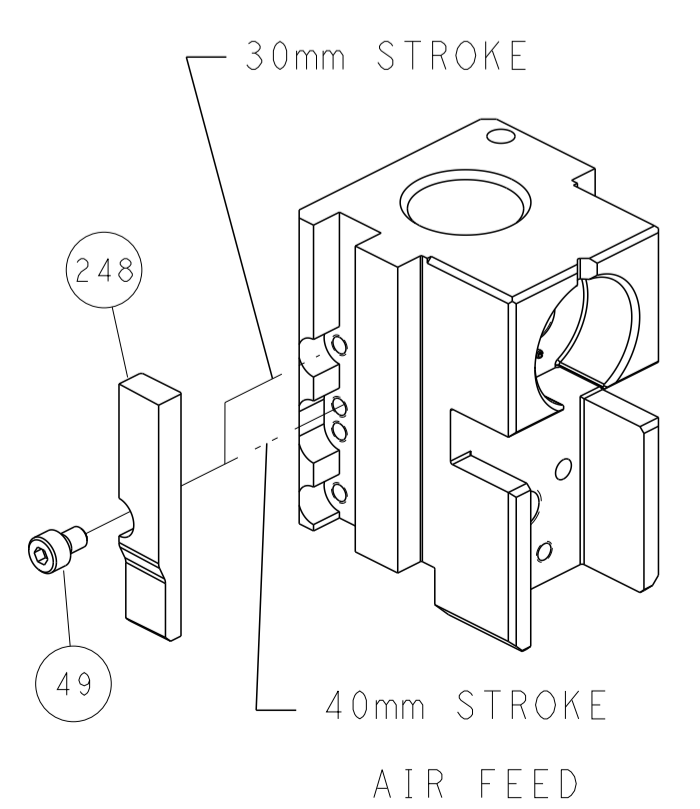
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

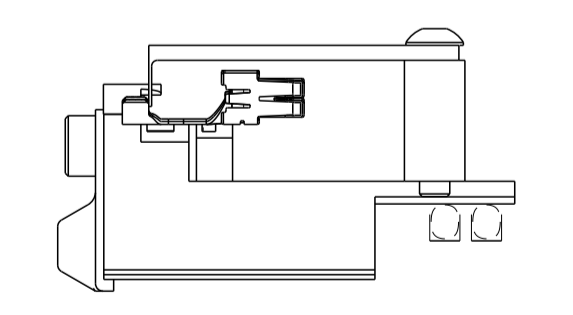


DETAIL A

CAM POSITION



ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION
GUIDE BY WIRE

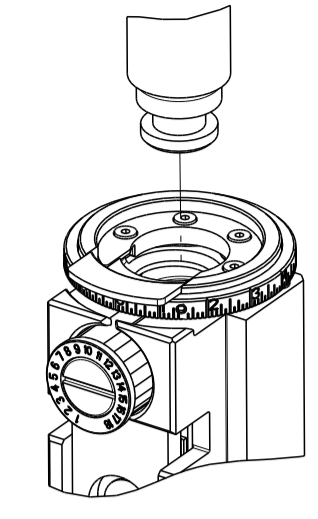
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<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. A1 00779 C=2266976 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV E1

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266976-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266976-7	A	CRIMP TOOLING KIT	-

SUPERSEDED BY 2-4151077-2

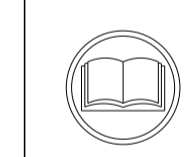
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, SPT OVER MOLD DESIGN			
WIRE STRIP LENGTH 3.90-4.50 mm [1.54-.177 IN]		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION	114-32163	-	-
TERMINALS APPLIED Δ Δ Δ			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238083-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING Δ
1.35mm2	1.52 +/- 0.05 [0.060 +/- .002]	6.7
1.25mm2	1.49 +/- 0.05 [0.059 +/- .002]	7.0
1.00mm2	1.35 +/- 0.05 [0.053 +/- .002]	8.5
0.75mm2	1.35 +/- 0.05 [0.053 +/- .002]	8.4



- Δ 1 RECOMMENDED SPARE PARTS
- Δ 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- Δ 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.
- Δ 4 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- Δ 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 51
- Δ 7 TERMINAL LUBRICANT IS RECOMMEND.

***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)

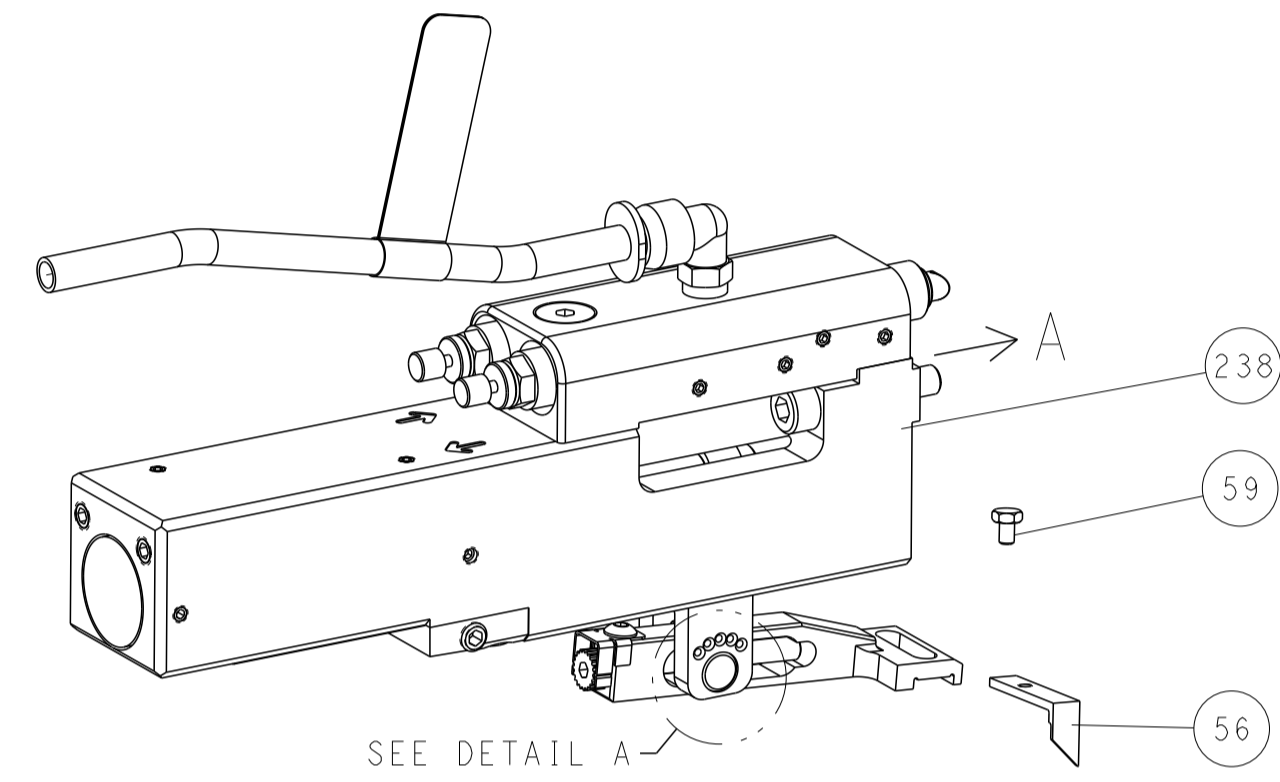
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

Δ 1	-	1	1633601-3	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	1-455888-3	SPACER, CRIMPER	120
Δ 7	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	-	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	1-455888-9	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	-	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
Δ 6	-	1	811242-6	BUMPER, HOLD DOWN	51
-	1	-	690753-2	SPACER, TONKER	50
-	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	-	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	-	22283-1	SPRING, COMPRESSION	27
-	1	-	356835-1	LEVER, DRAG RELEASE	26
-	1	-	690754-9	DRAG, SPECIAL	25
-	1	-	1633653-4	STRIP GUIDE -	24
-	1	-	3-189124-7	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
Δ 1	-	1	3-1803012-3	PLATE, REAR SHEAR	15
-	1	-	1-2119928-8	FENCE	12
-	-	-	-	-	10
-	-	-	-	-	9
Δ 1	1	1	1803097-2	ANVIL, WIRE	8
-	1	-	240641-4	SPACER	7
-	-	-	-	-	6
-	-	-	-	-	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
Δ 1	1	1	456407-5	CRIMPER, WIRE PREMIUM	1
-77	-22	PART NO		DESCRIPTION	ITEM NO

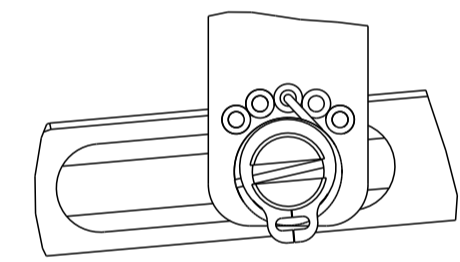
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 22SEPT2015 CHK: T. ELBIN 22SEPT2015 APVD: T. ELBIN 22SEPT2015	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		± ± ± ± ± ± ±		NAME: Ocean Side Feed Applicator	
MATERIAL: -		WEIGHT: -		SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266976	
				Customer Accessible Production Drawing SCALE: 1:2 SHEET 3 OF 4 REV: E1	

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

FEED TYPE PNEUMATIC

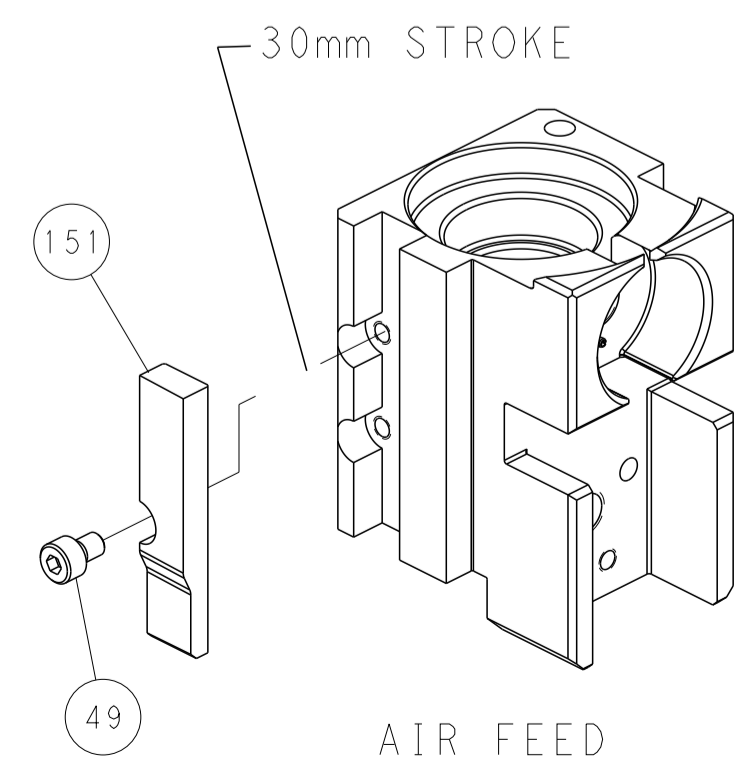


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

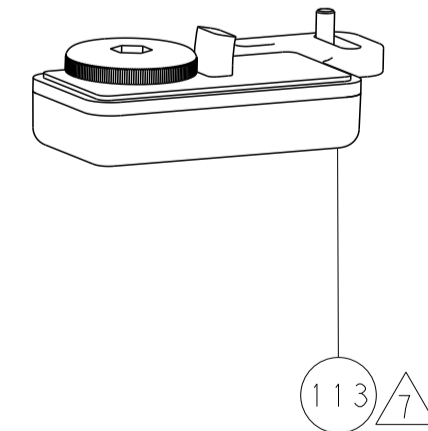


DETAIL A

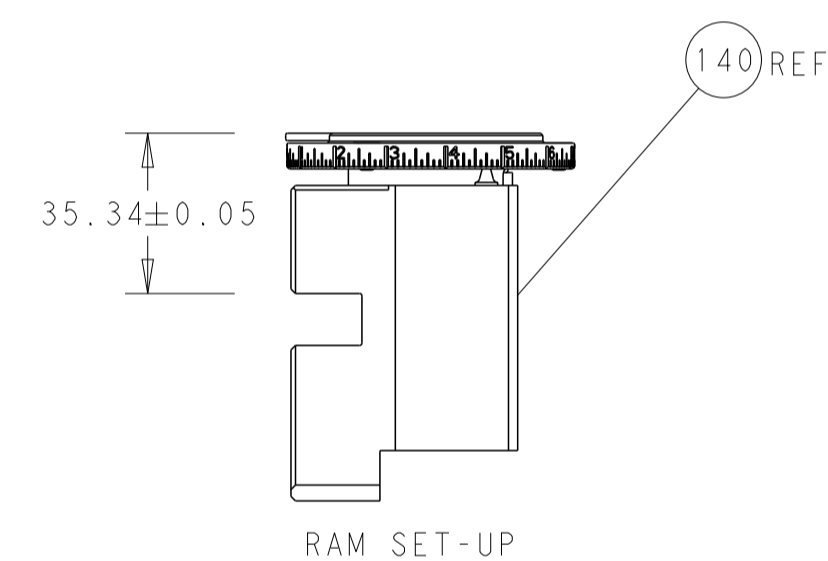
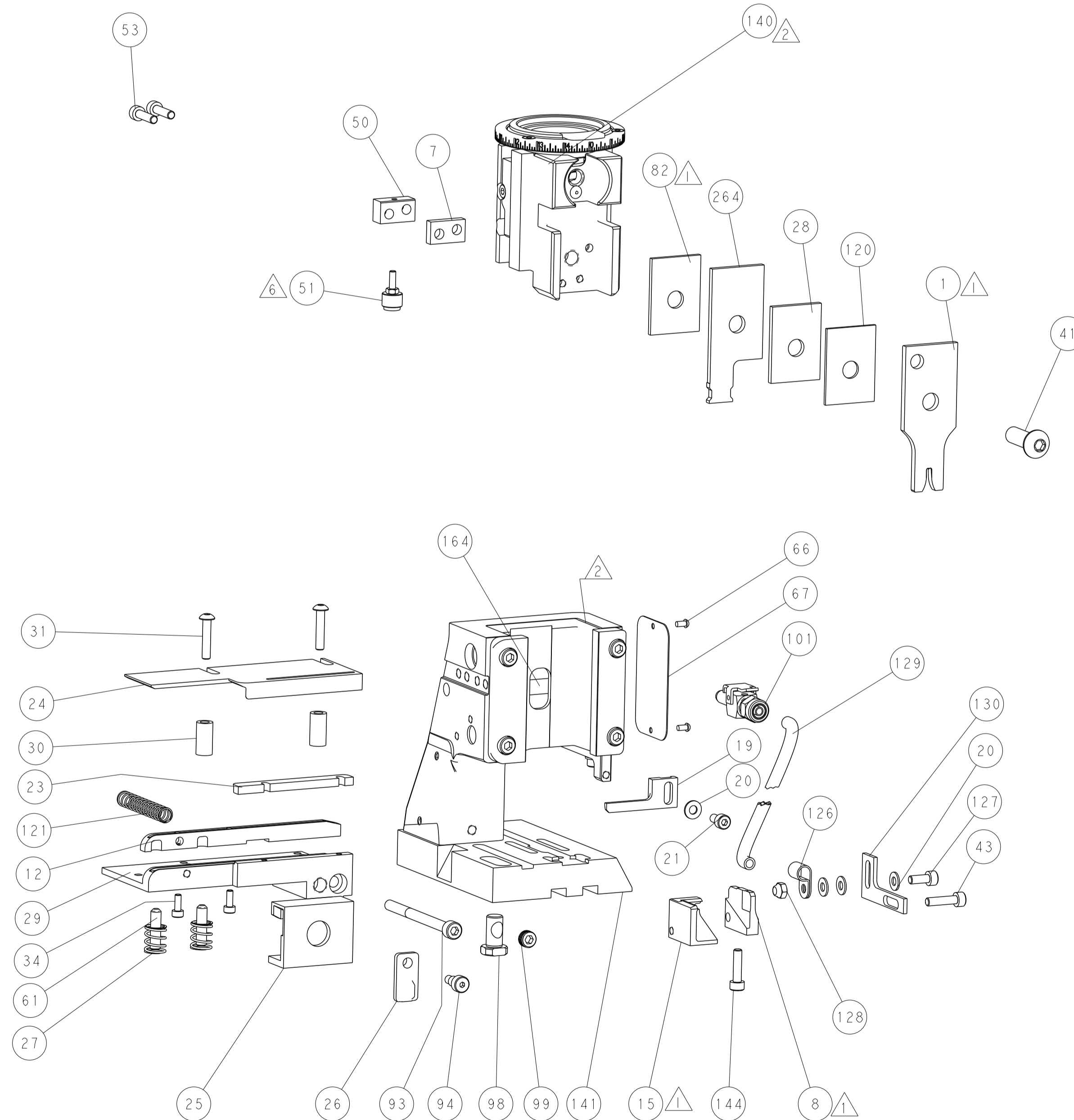
CAM POSITION



AIR FEED

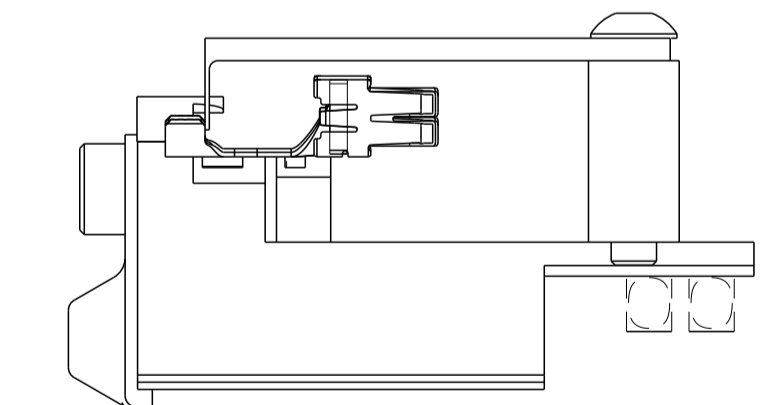


113



RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY WIRE

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	MATERIAL:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608