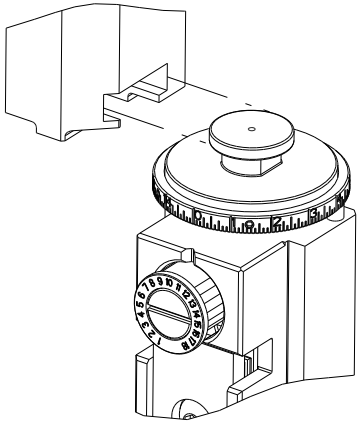


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266334-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266334-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266334-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266334-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266334-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.27 mm [.050]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 2.57-3.34 mm [.101-.131 IN]		INSULATION DIAMETER RANGE Ø1.30-1.50 mm [.051-.059 IN]	
TERMINAL APPLICATION SPECIFICATION	EDC4-166655-02	-	-
TERMINALS APPLIED			
TE TERMINAL 2113482-1	HIROSE TERMINAL GT8E-2022PCF	TE TERMINAL	HIROSE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.92+/-0.03 [.036+/- .001]	7.5
22 AWG	0.83+/-0.03 [.033+/- .001]	8.4



- 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 ITEM 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

*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	LTR	DESCRIPTION	DATE	DWN
		B		ECR-15-017075	23NOV2015	TT
		C		ECR-18-006896	04MAY2018	TB
		D		ECR-18-006978	16MAY2018	TB
		E		ECR-23-166991	21FEB2023	FZ

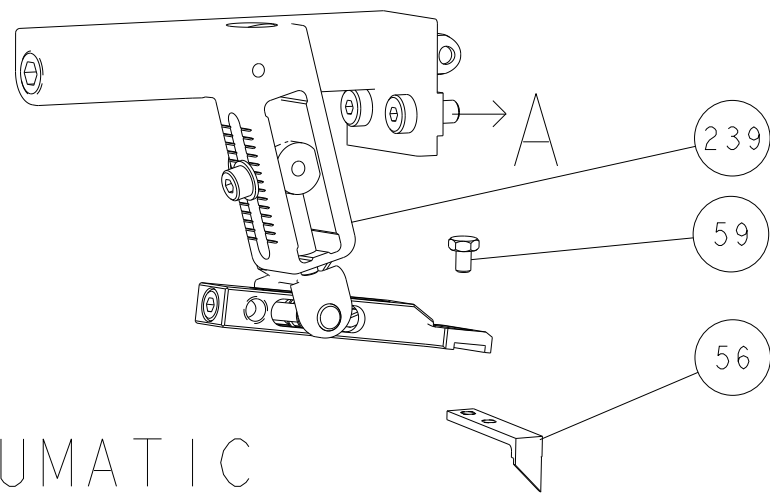
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	235
3	-	1	1	1	1-1752354-7	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	1976053-2	LOCATER BLOCK,TERMINAL	179
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
6	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-9	SPACER, CRIMPER	82
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-4	HOLDDOWN, TERMINAL	51
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
1	-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1803333-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1803326-5	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	2	1	1	1803325-4	CRIMPER, WIRE F	1

THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER.		DWN L. GROSS 11JUN2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN 11JUN2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.001 1 PLC ±.001 2 PLC ±.001 3 PLC ±.001 4 PLC ±.001 ANGLES ±.001		APVD D. STOUGH 11JUN2014	SIZE CAGE CODE DRAWING NO 00779 ©=2266334	
MATERIAL -		WEIGHT -	RESTRICTED TO -	
Customer Accessible Production Drawing		SCALE 1:2	SHEET 1	REV E

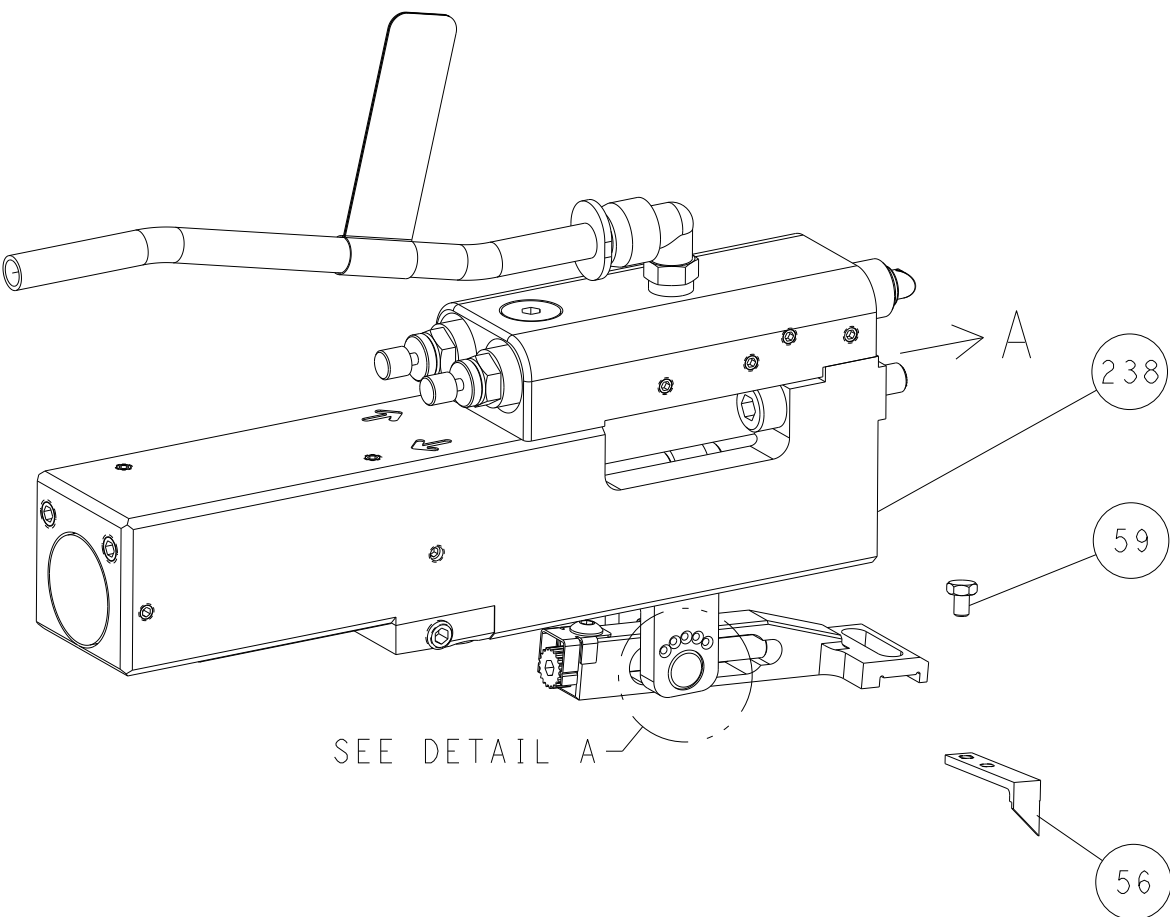
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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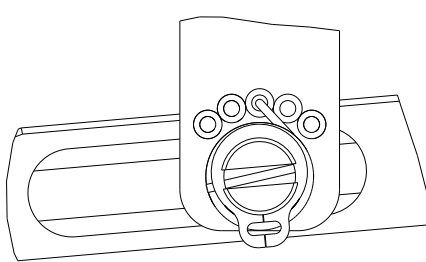
FEED TYPE MECHANICAL



PNEUMATIC

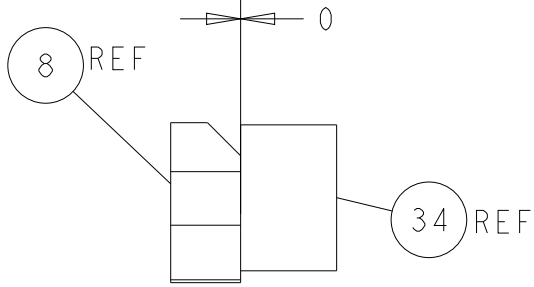
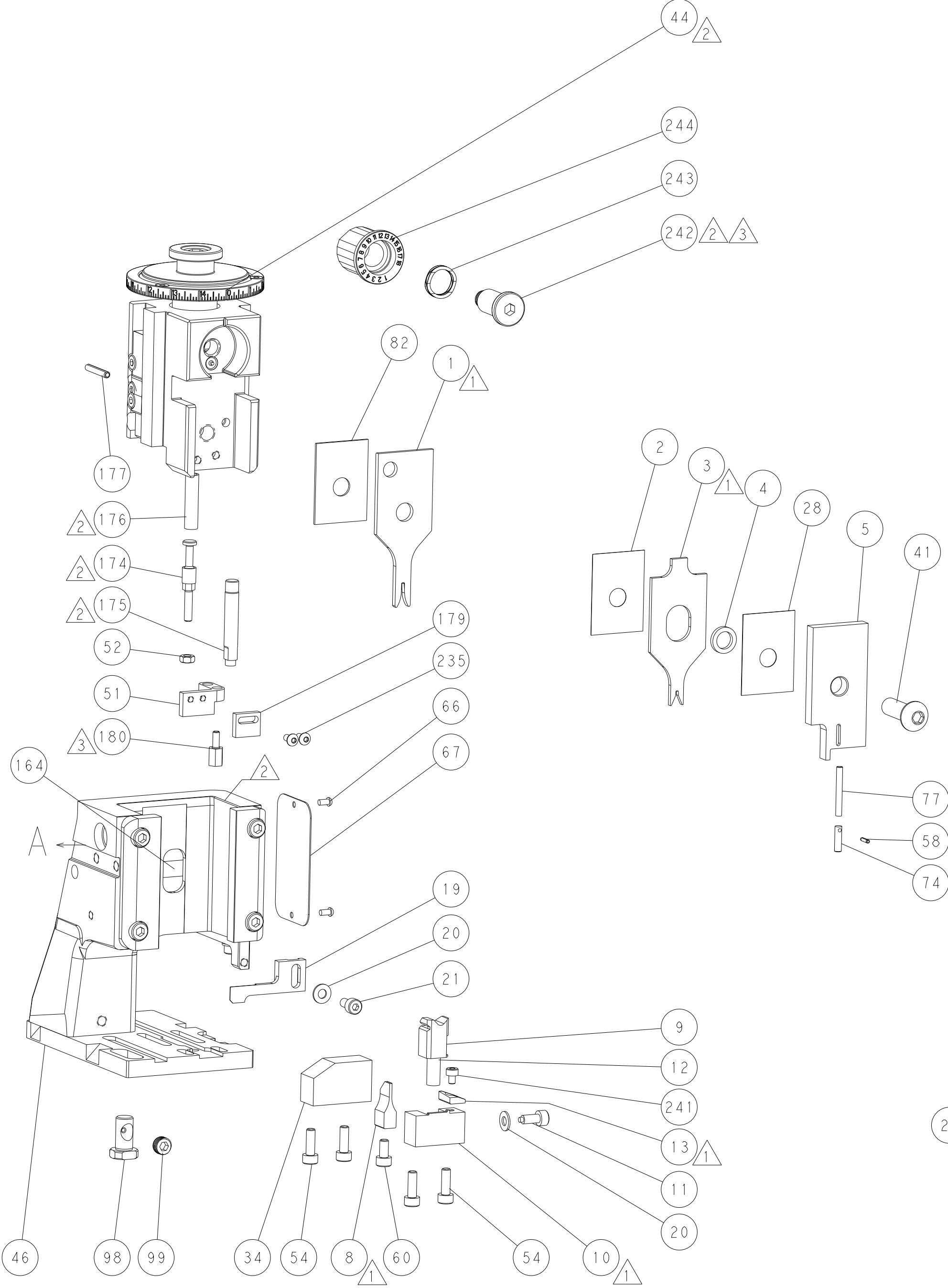
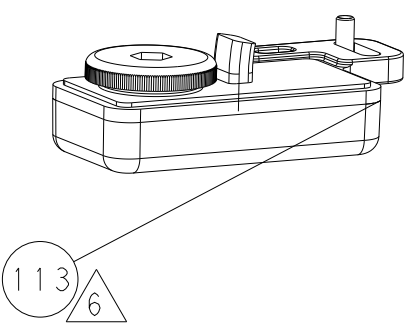
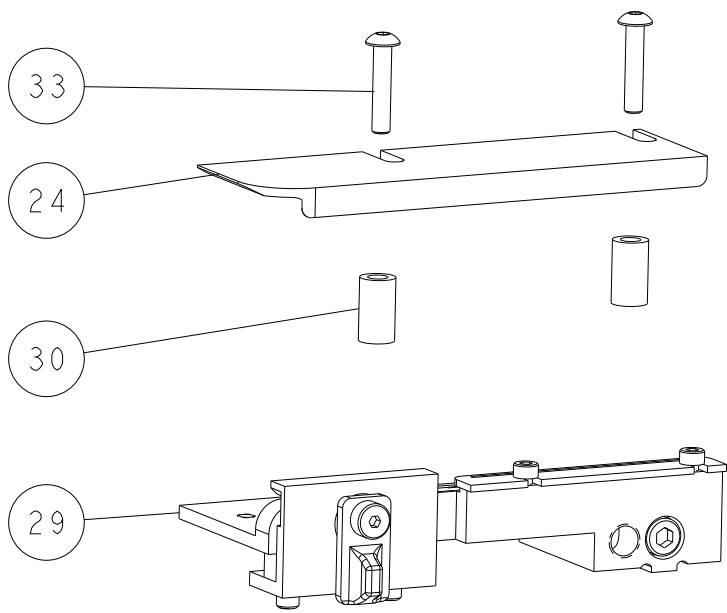
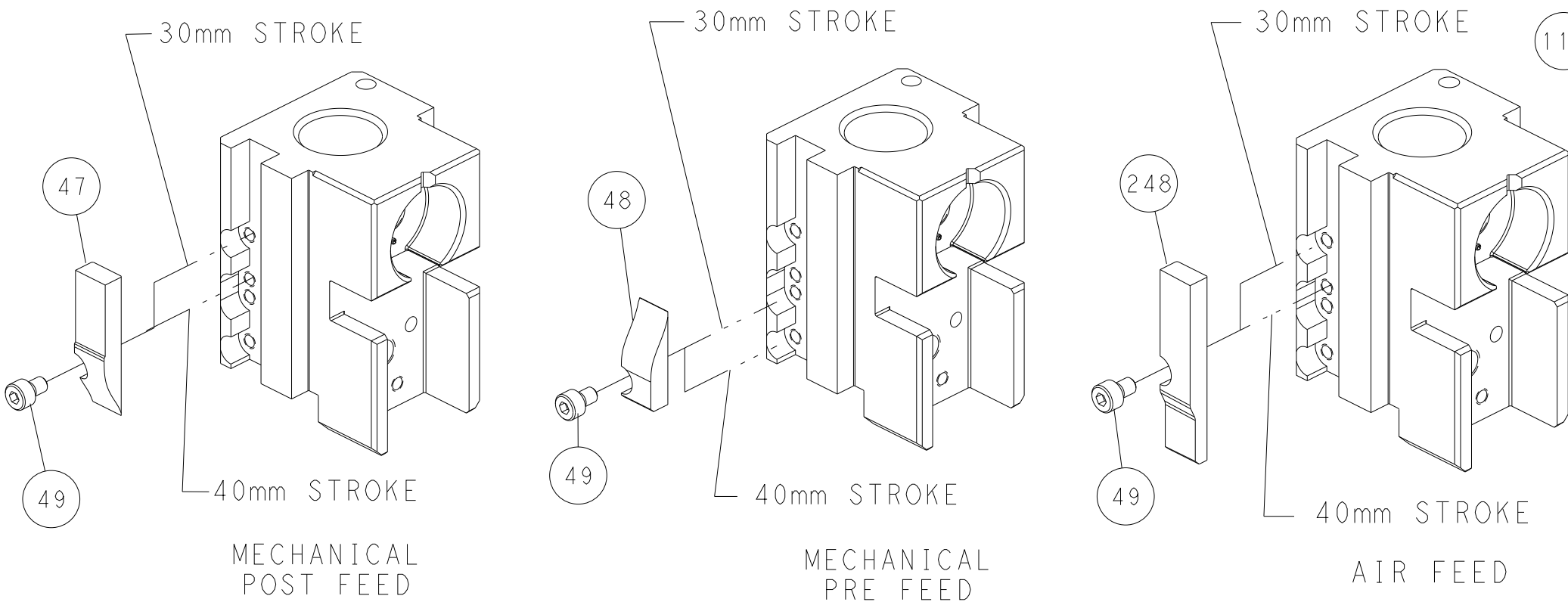


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

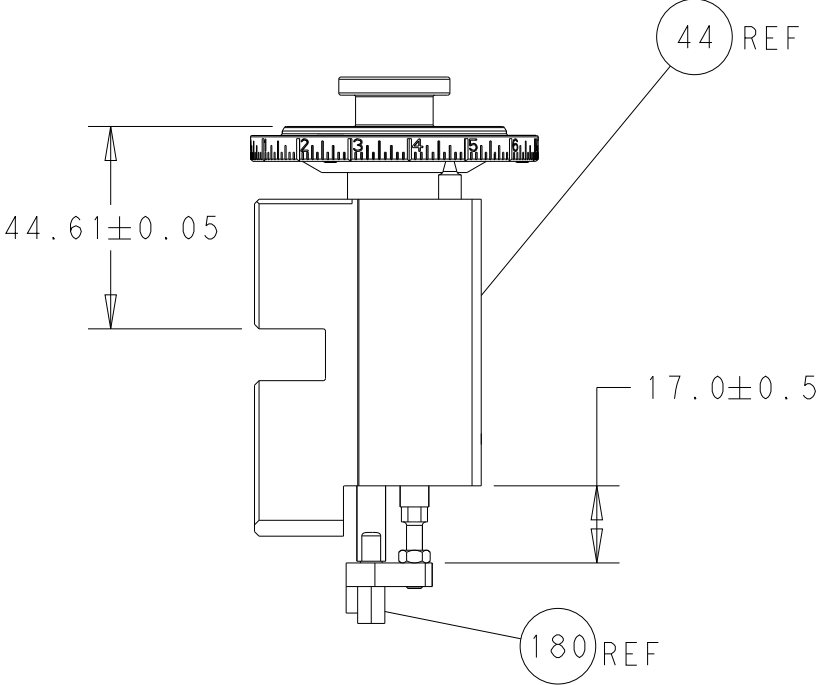


DETAIL A

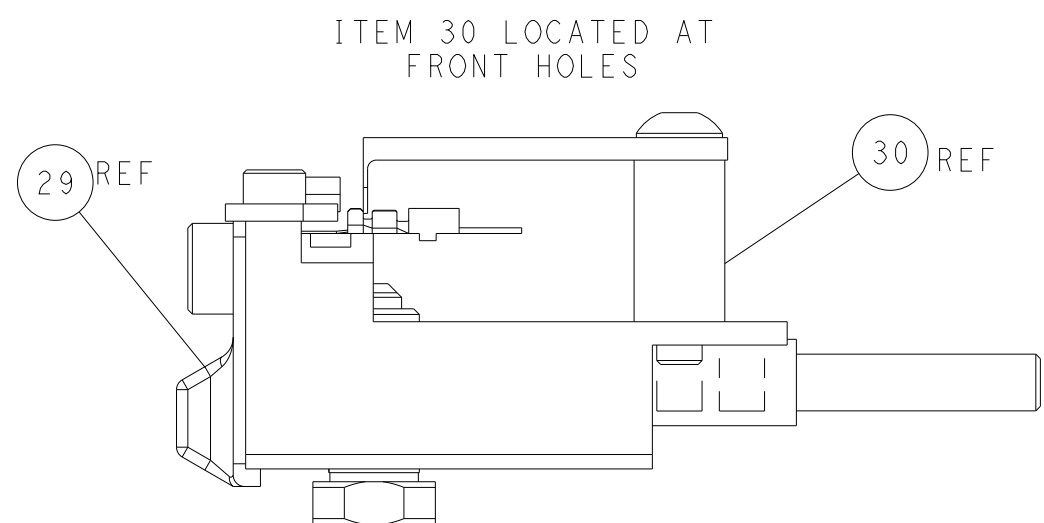
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



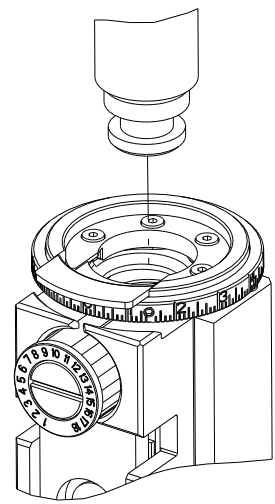
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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		CHK	T. ELBIN	11JUN2014	
		APVD	D. STOUGH	11JUN2014	
		PRODUCT SPEC			
		APPLICATION SPEC			NAME Ocean Side Feed Applicator
		WEIGHT			
		Customer Accessible Production Drawing			
		SCALE 1:2			
		SHEET 2 of 4			REV E

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266334-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266334-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266334-7	B	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.27 mm [.050]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: HIROSE TERMINAL		HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 2.57-3.34 mm [.101-.131 IN]		INSULATION DIAMETER RANGE Ø1.30-1.50 mm [.051-.059 IN]	
TERMINAL APPLICATION 		-	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
2113482-1	GT8E-2022PCF		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
20 AWG			0.92 +/- 0.03 [.036 +/- .001]		7.5
22 AWG			0.83 +/- 0.03 [.033 +/- .001]		8.4



- 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 ITEM 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ⑥ TERMINAL LUBRICANT IS RECOMMENDED.

PACIFIC VERSION

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

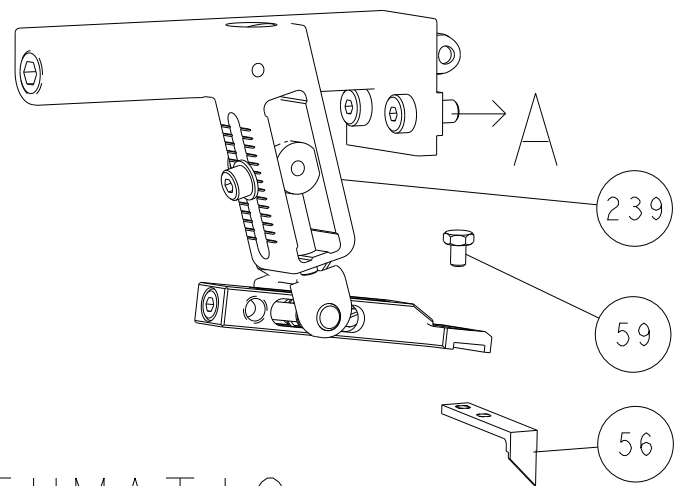
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LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	242
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-1	AIR FEED MODULE	238
	-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	235
3	-	1	1	1-1752354-7	STANDOFF, HOLD-DOWN	180
	-	1	1	1976053-2	LOCATER BLOCK, TERMINAL	179
	-	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	177
	-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
6	-	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	455888-9	SPACER, CRIMPER	82
	-	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	854769-4	HOLDER, INS	74
	-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	1	1	1338685-1	PAWL, FEED	56
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1901681-4	HOLDDOWN, TERMINAL	51
	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1320928-2	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	2119533-4	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1803333-1	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1803326-5	CRIMPER, INSULATION F	3
	-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1803325-4	CRIMPER, WIRE F	1

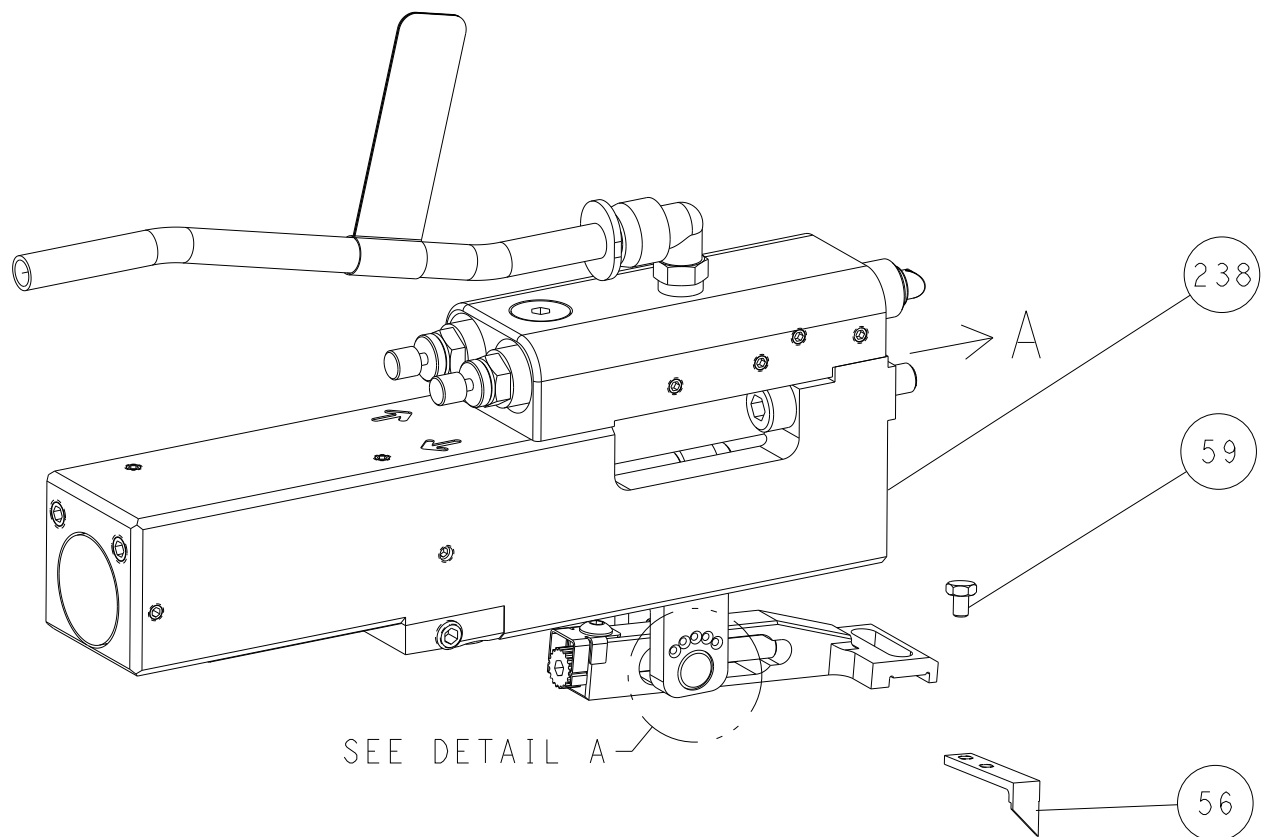
(1) DRAWING IS TO REMAIN UNLESS OTHERWISE SPECIFIED. (2) DIMENSIONS ARE TO REMAIN UNLESS OTHERWISE SPECIFIED. (3) DIMENSIONS ARE TO REMAIN UNLESS OTHERWISE SPECIFIED.		DWN 11JUN2014 GROSS CHG 11JUN2014 ELBIN APD D.STOUGH 11JUN2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES 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 A 00779 C=2266334	
MATERIAL -		WEIGHT -		RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV E	

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

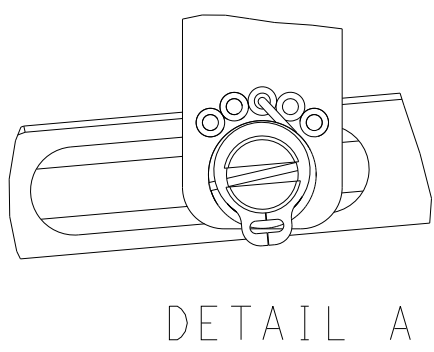
FEED TYPE
MECHANICAL



PNEUMATIC

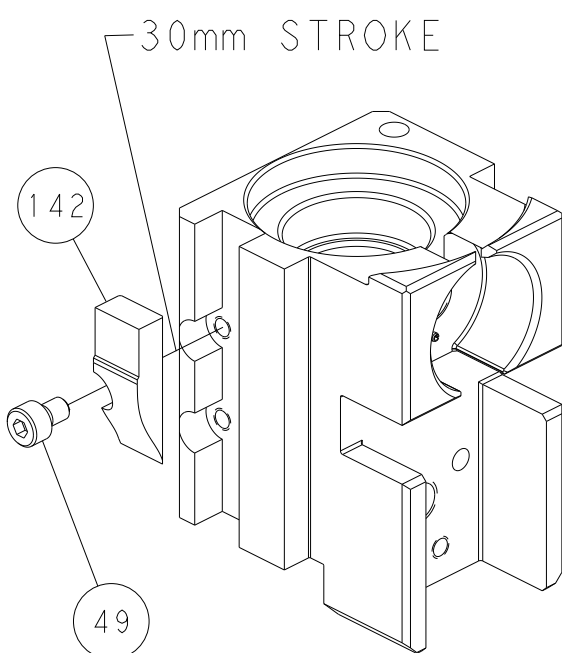


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

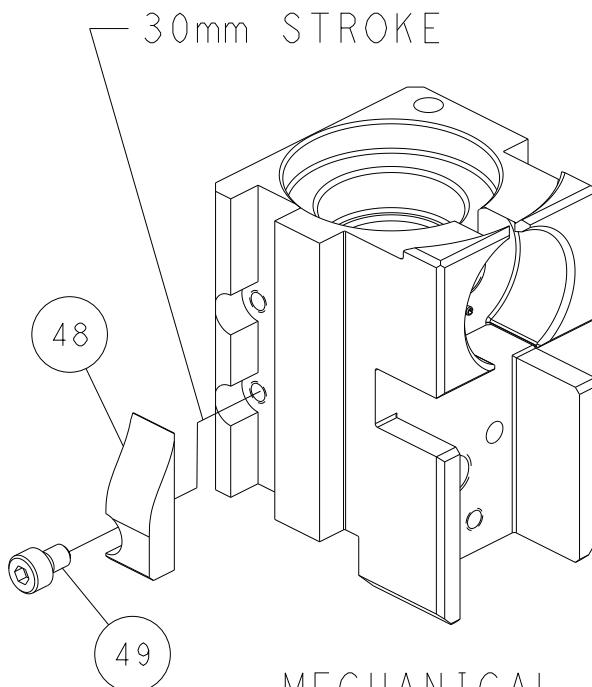


DETAIL A

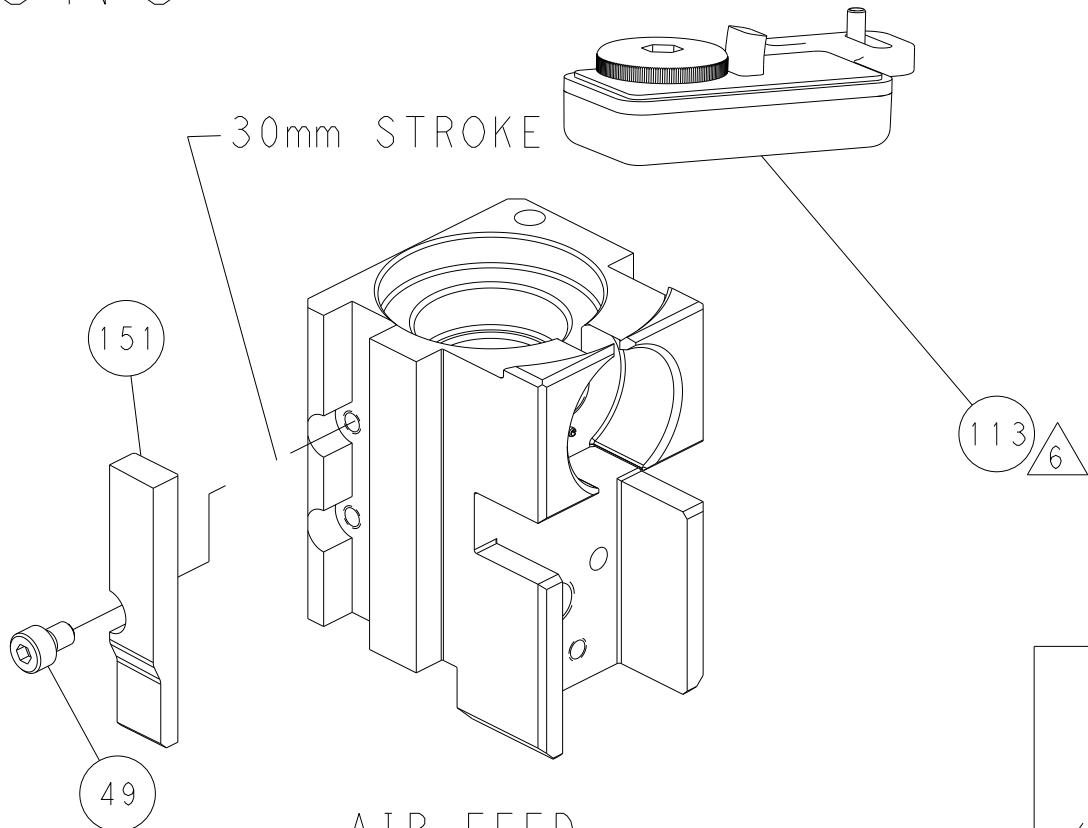
CAM POSITIONS



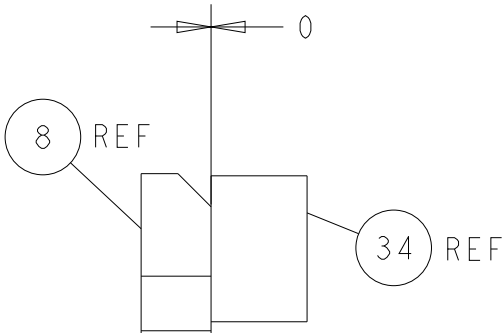
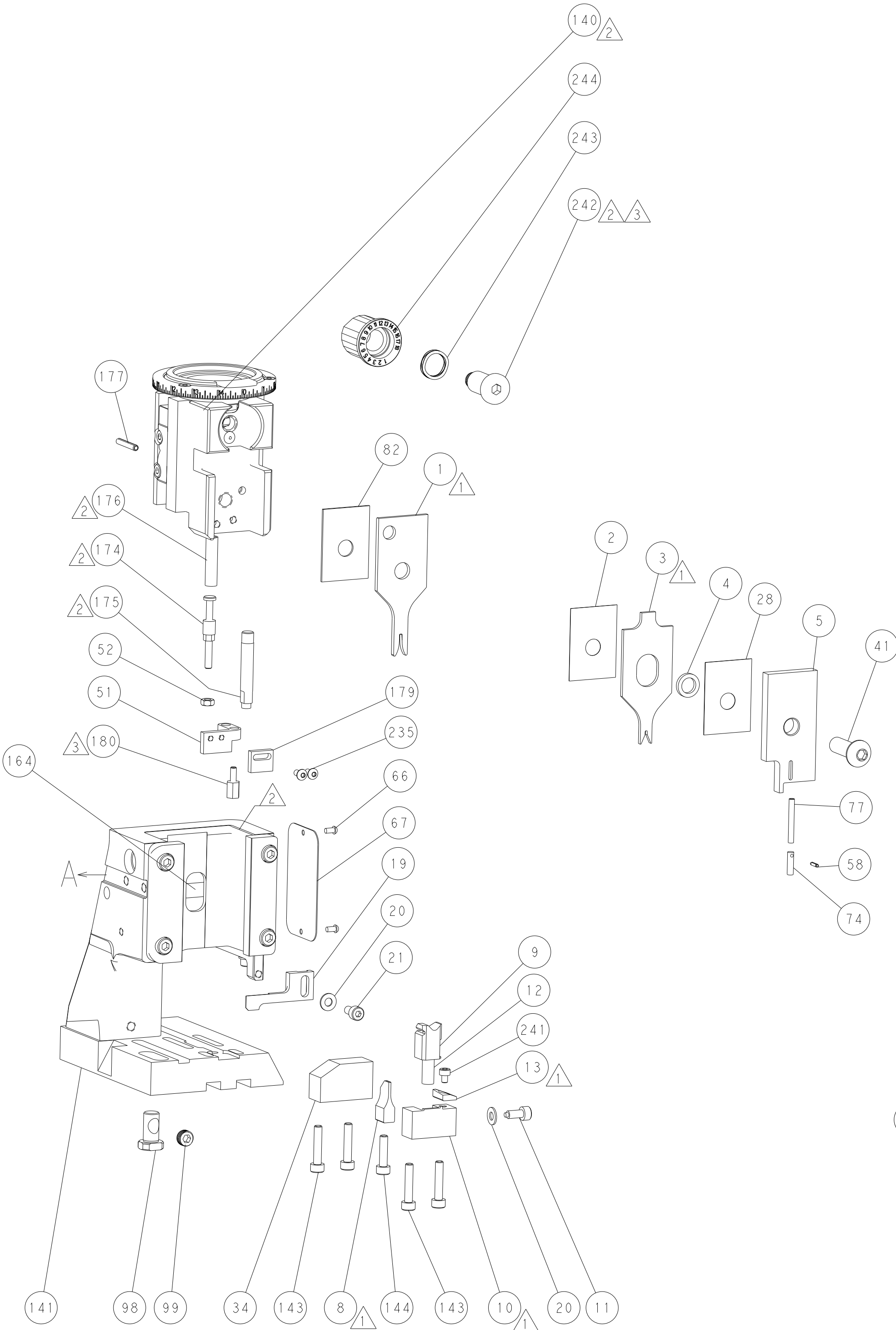
MECHANICAL
POST FEED



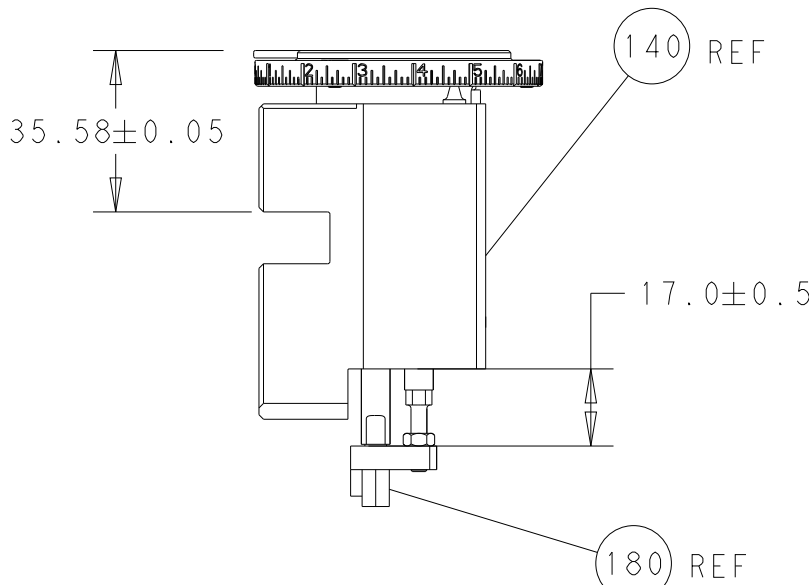
MECHANICAL
PRE FEED



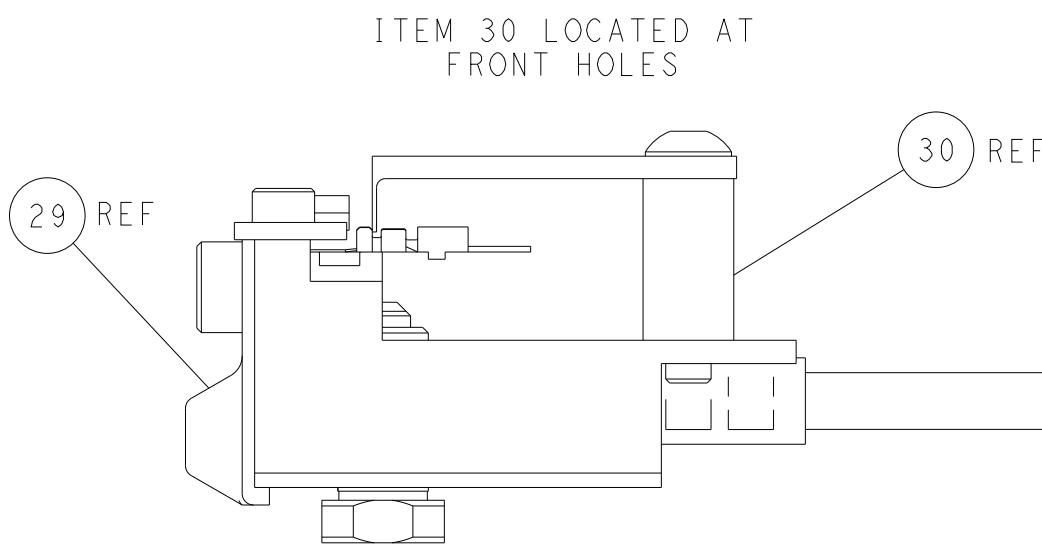
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION 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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		CHK	T. ELBIN	11JUN2014			
		APVD	D. STOUGH	11JUN2014	NAME		
					Ocean Side Feed Applicator		
					-		
					SIZE		
					A1		
					CAGE CODE		
					00779		
					DRAWING NO		
					C=2266334		
					RESTRICTED TO		
					-		
					Customer Accessible Production Drawing		
					SCALE		
					1:2		
					SHEET		
					4 of 4		
					REV		
					E		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION