

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266345-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266345-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266345-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266345-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266345-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.58 mm [.062]	F
APPLICATOR INSTRUCTIONS 408-35042		

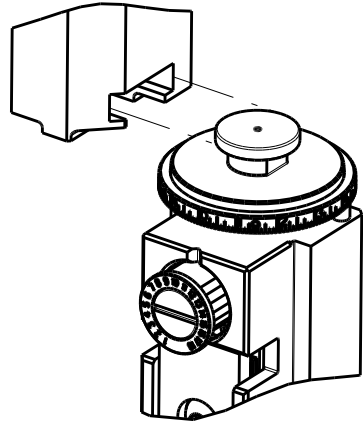
TERMINAL DATA: NICMATIC TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: MALE CONTACT			
WIRE STRIP LENGTH 2.60-3.40 mm [.102-.134 IN]		INSULATION DIAMETER RANGE Ø0.95-1.27 mm [.038-.050 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	NICMATIC TERMINAL	TE TERMINAL	NICMATIC TERMINAL
2113485-1	14671-1X		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.79+/-0.05 [.031+/- .002]	4.7
24 AWG	0.72+/-0.05 [.028+/- .002]	5.3
26 AWG	0.66+/-0.05 [.026+/- .002]	6.0
28 AWG	0.63+/-0.05 [.025+/- .002]	6.3



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

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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

*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.

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	01AUG2014	KH	UG
		B		ECR-18-018142	20NOV2018	FZ	KZ

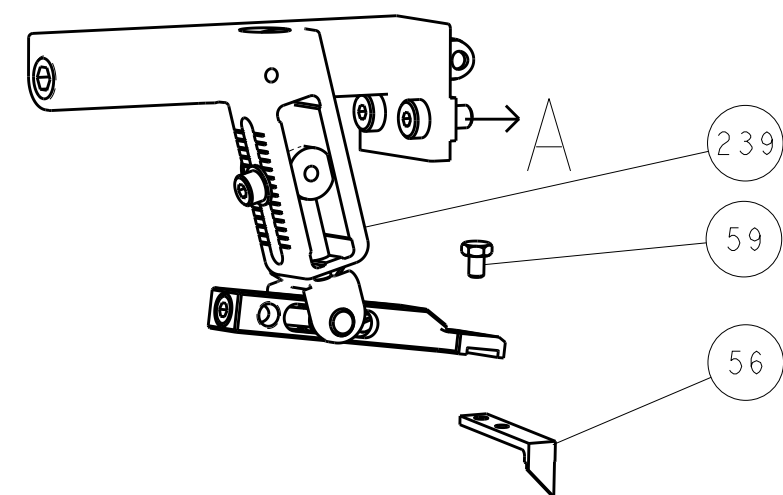
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	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	1803607-1	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
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	50
-	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	1803515-1	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	2-2844962-3	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	2119533-1	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	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1633861-1	SHEAR, FLOATING	9
1	2	2	1	1	6-1633932-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119780-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	5-238011-6	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1803017-1	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	2	2	1	1	4-1633860-1	CRIMPER, WIRE	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THE DRAWING IS A CONTROLLED DOCUMENT FOR FRED ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION IT SHOULD BE CONTROLLED FOR THE LATEST EDITION.				DWN R. HUANG CHK L. ZHANG APVD J. GUO		17JUN2014 17JUN2014 17JUN2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC APPLICATION SPEC		SIZE		CAGE CODE	
MATERIAL		FINISH		WEIGHT		DRAWING NO		RESTRICTED TO	
-		-		-		A 00779 C=2266345		-	
Customer Accessible Production Drawing						SCALE 1:2		SHEET 1 OF 4 REV B	

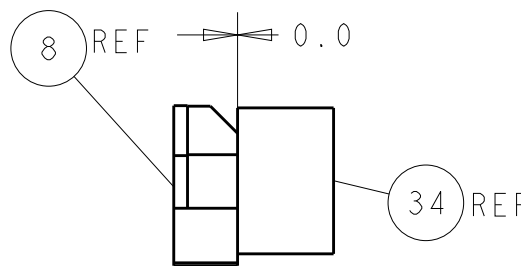
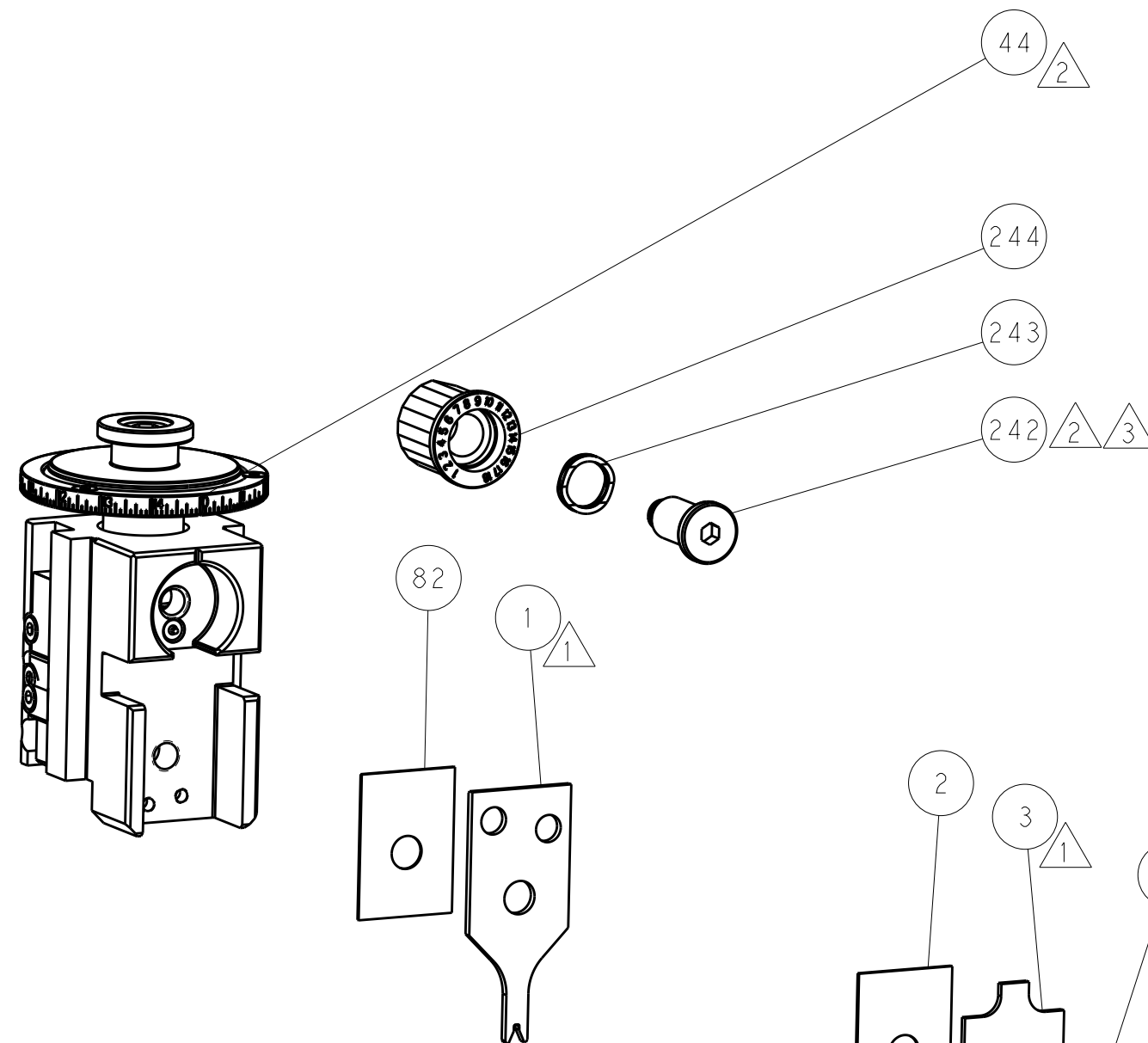
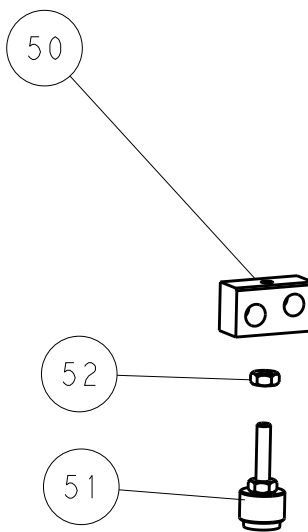
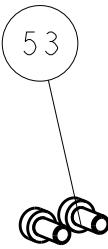
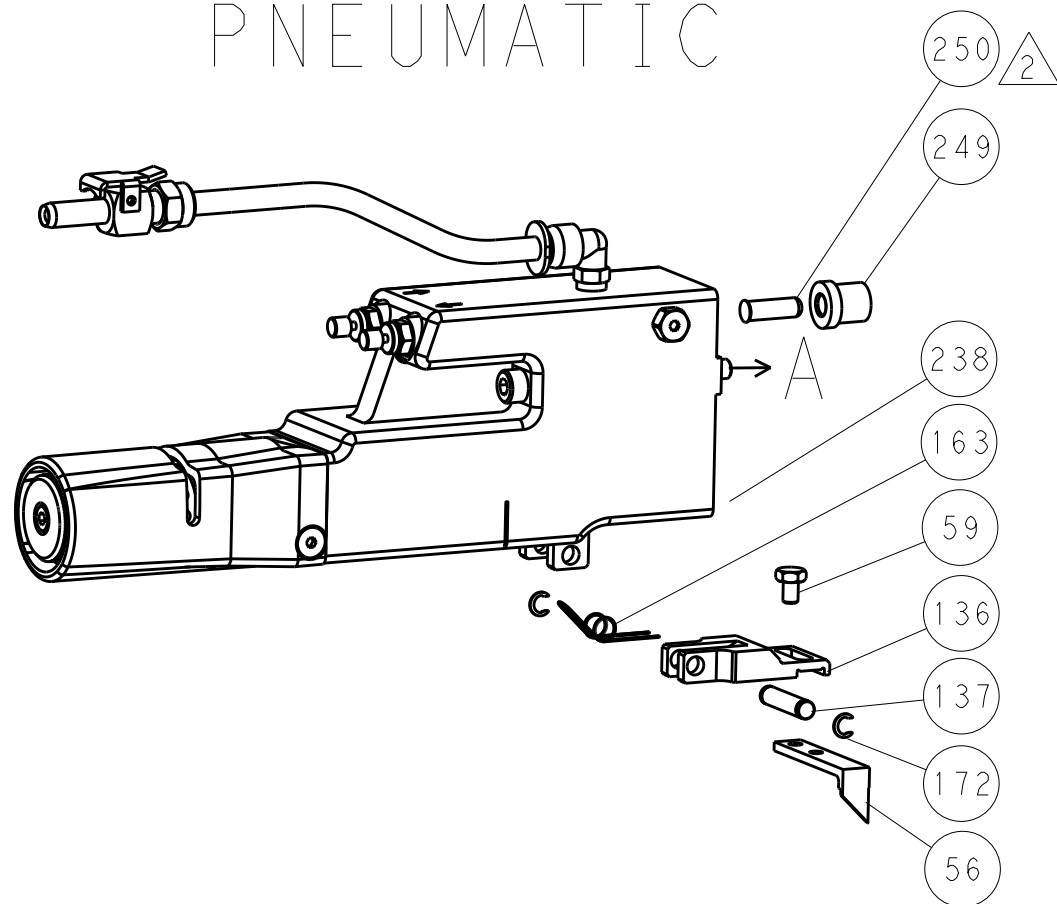
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

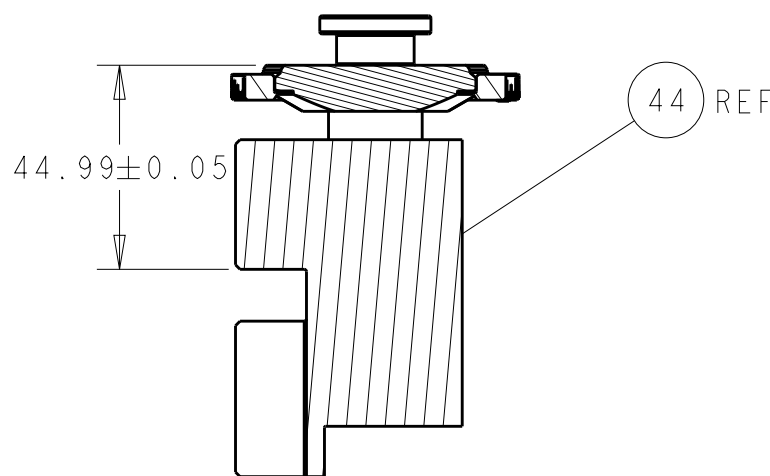
FEED TYPE
MECHANICAL



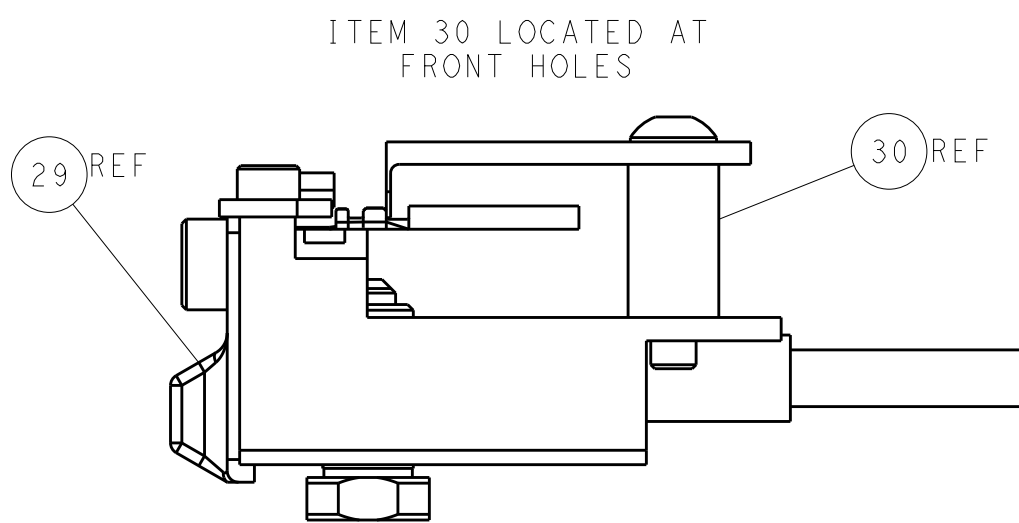
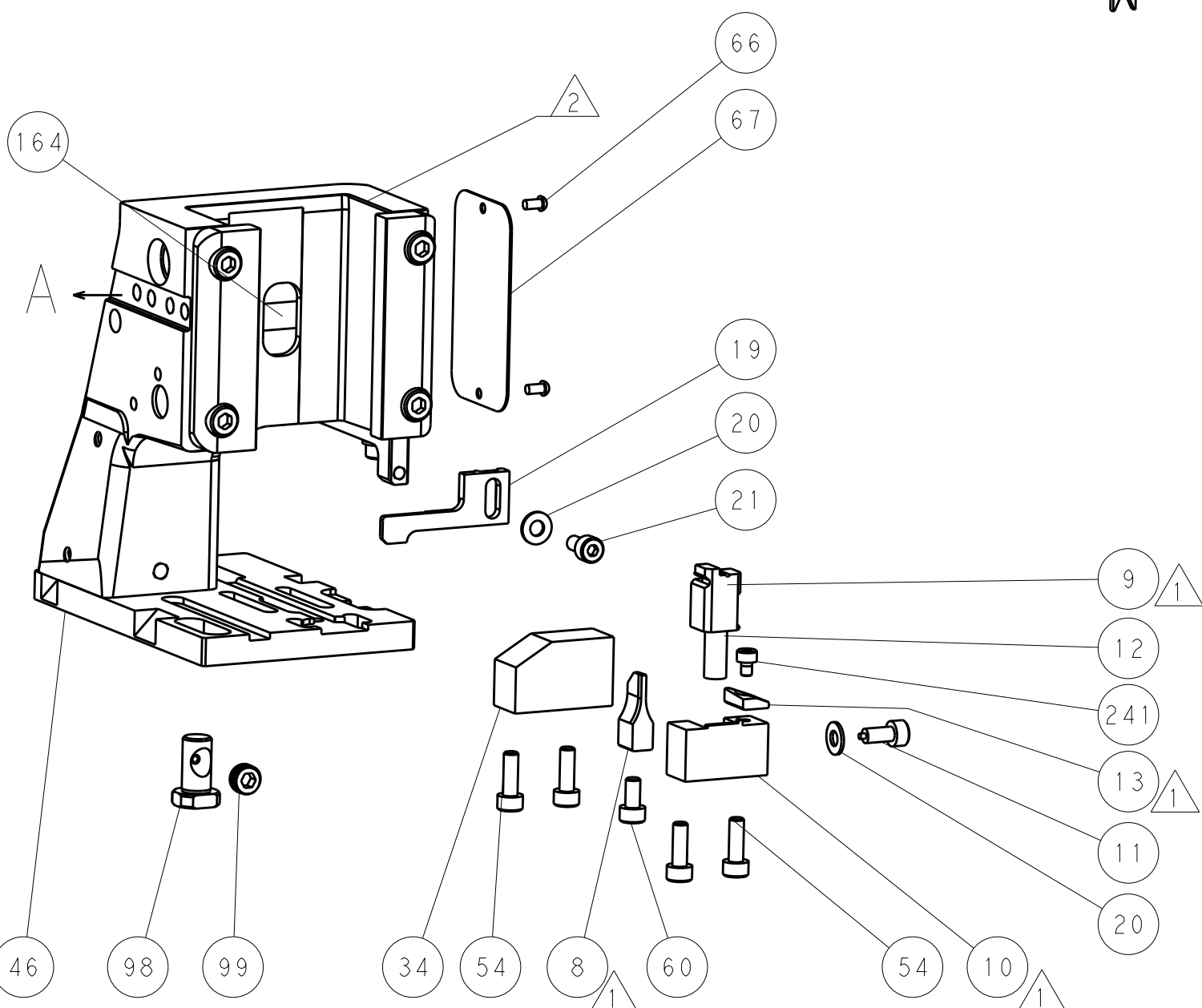
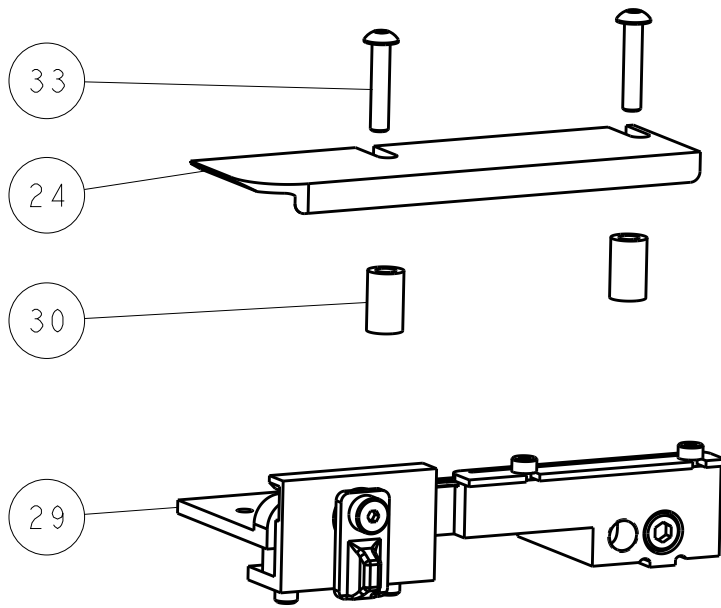
PNEUMATIC



TERMINAL SUPPORT LOCATION

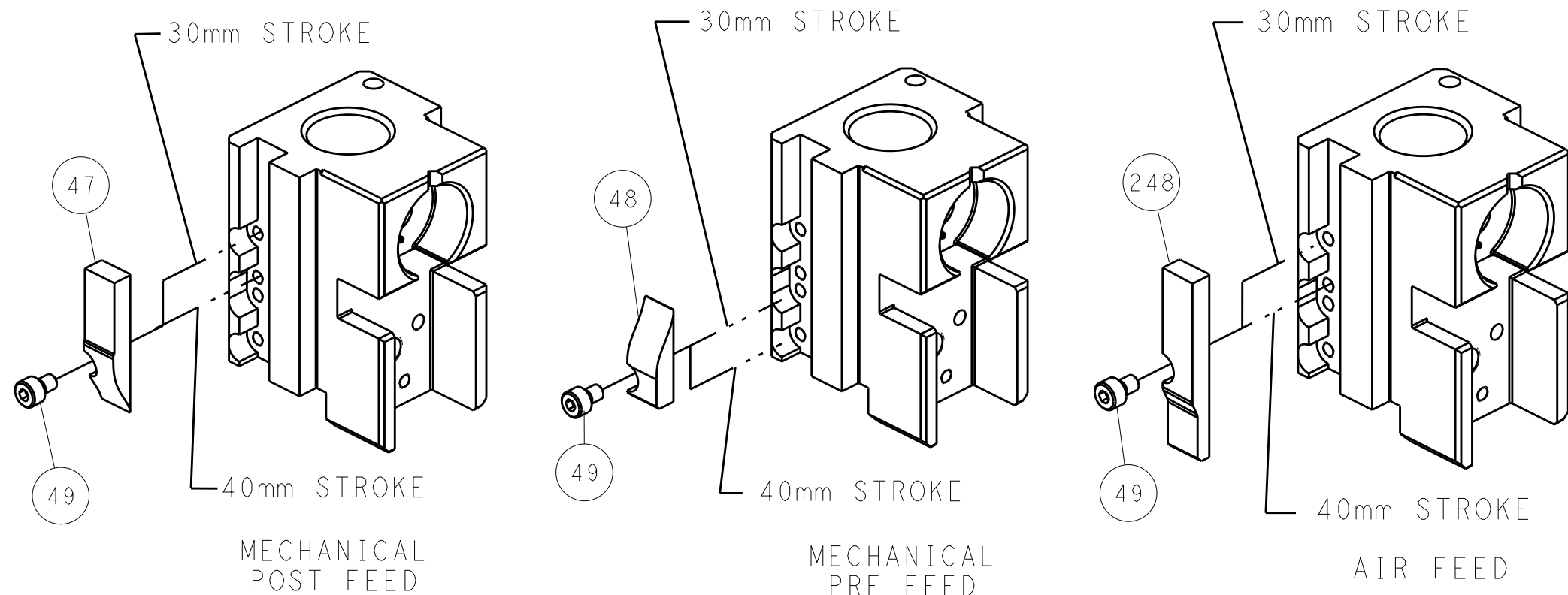


RAM SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

CAM POSITIONS



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:		DWN		CHK		APVD		NAME		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
mm		0 PLC ±.1		17JUN2014		17JUN2014		17JUN2014		Ocean Side Feed		A1		00779		C=2266345		-	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE		1:2		SHEET		2		OF 4		REV	
																		B	

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266345-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266345-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266345-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.58 mm [.062]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: NICMATIC TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: MALE CONTACT			
WIRE STRIP LENGTH 2.60-3.40 mm [.102-.134 IN]		INSULATION DIAMETER RANGE Ø0.95-1.27 mm [.038-.050 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	NICMATIC TERMINAL	TE TERMINAL	NICMATIC TERMINAL
2113485-1	14671-1X		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.79+/-0.05 [.031+/-0.002]	4.7
24 AWG	0.72+/-0.05 [.028+/-0.002]	5.3
26 AWG	0.66+/-0.05 [.026+/-0.002]	6.0
28 AWG	0.63+/-0.05 [.025+/-0.002]	6.3



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

*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)

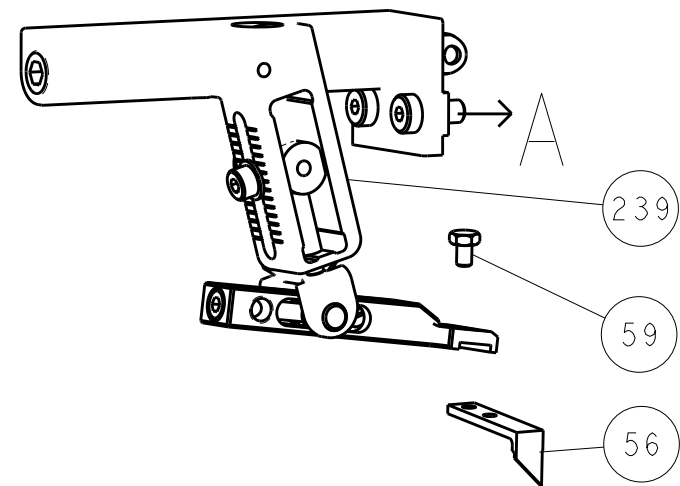
2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2063440-1	AIR FEED MODULE	238
	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	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
	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	854769-4	HOLDER, INS	74
	-	1	1	1803607-1	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
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	690753-2	SPACER, TONKER	50
	-	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	2-2844962-3	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	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
1	-	1	1	1-356885-3	STOP, SHEAR	11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1633861-1	SHEAR, FLOATING	9
	1	1	1	6-1633932-4	ANVIL, COMBINATION	8
1	-	-	-	-	-	7
	-	-	-	-	-	6
1	-	1	1	2119780-5	DEPRESSOR, SHEAR	5
	-	1	1	5-238011-6	BLOCK, CRIMPER SPACER	4
1	1	1	1	1803017-1	CRIMPER, INSULATION F	3
	-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1	4-1633860-1	CRIMPER, WIRE	1

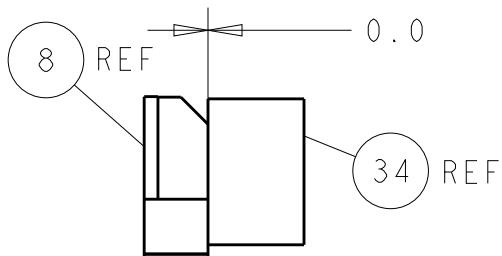
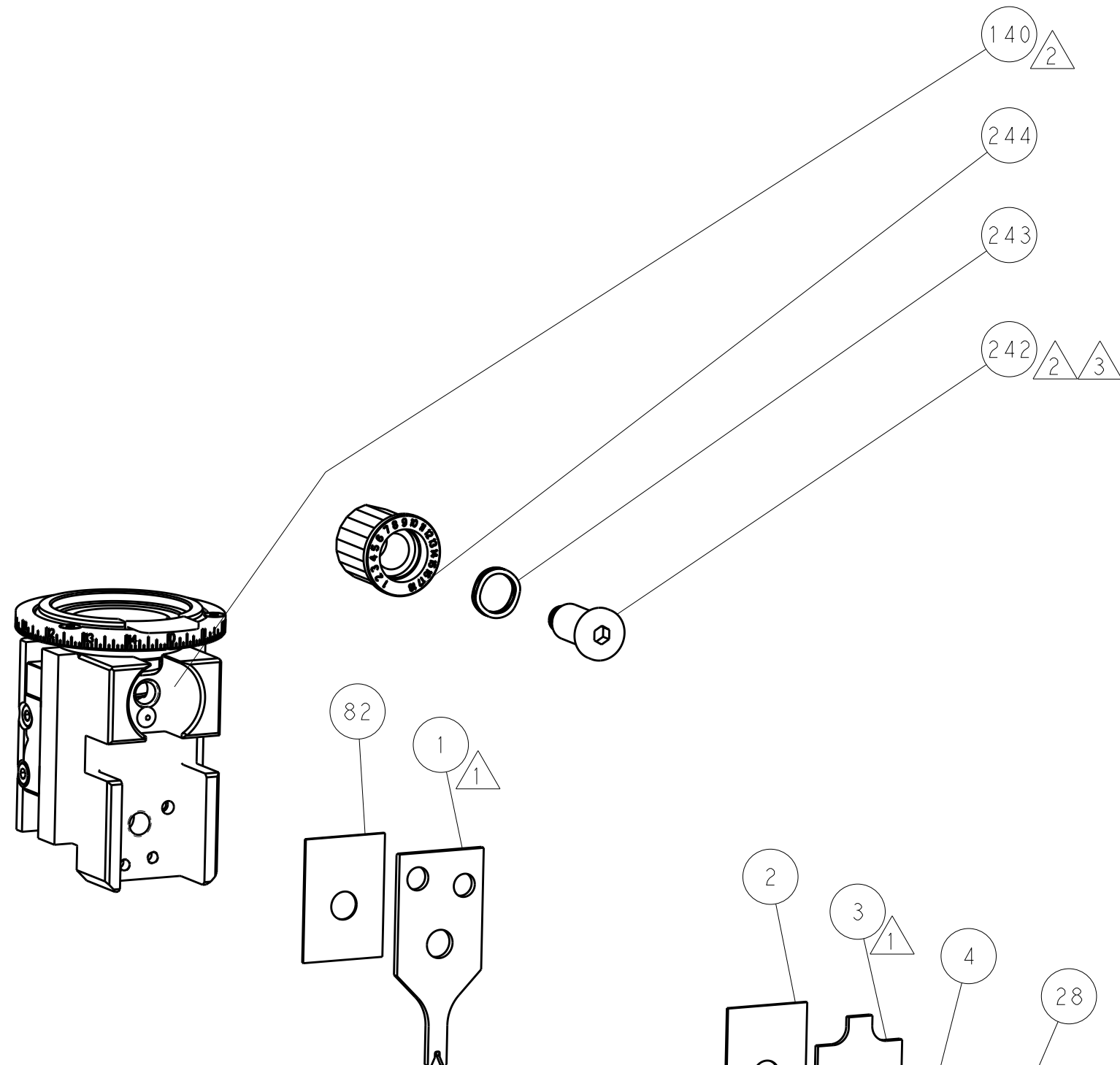
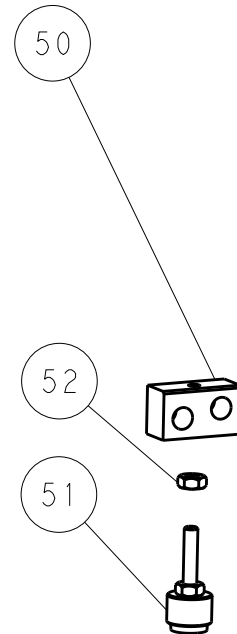
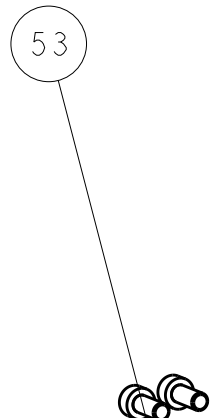
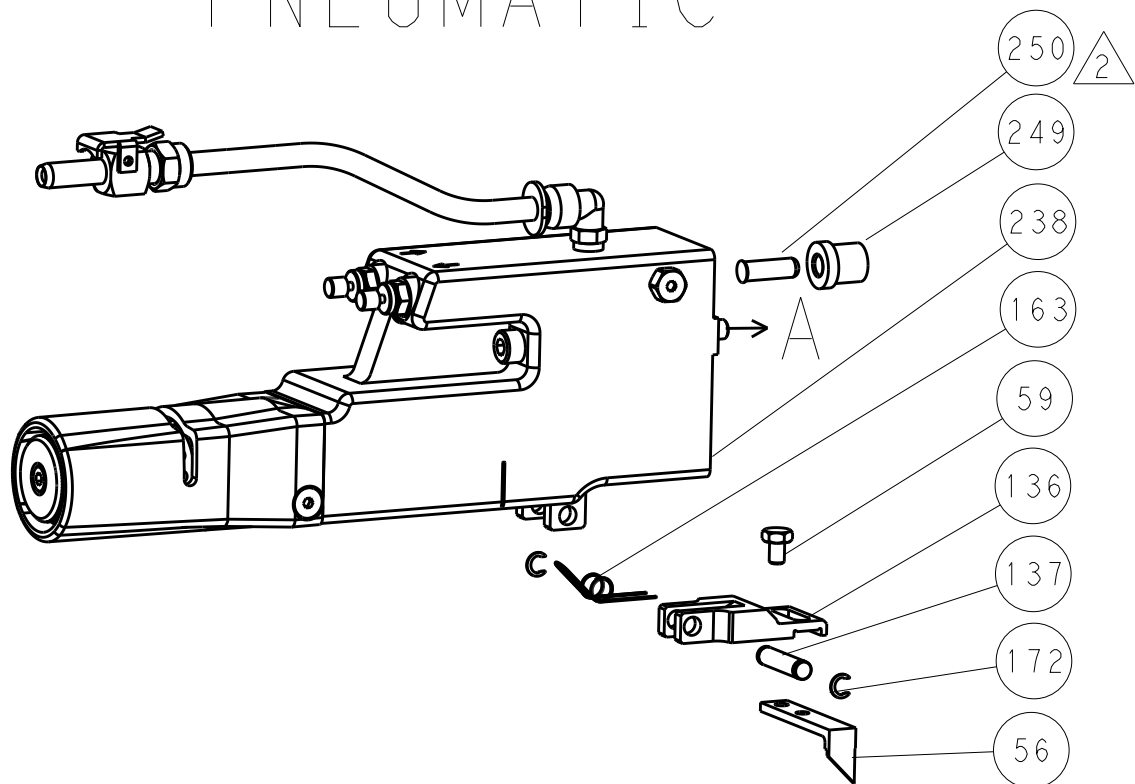
-77-22-21			PART NO		DESCRIPTION			ITEM NO			
OWNED BY: LEO ELECTRONIC INCORPORATION DATE: 17JUN2014 FOR THE LATEST REVISION			DWN K. HUANG	17JUN2014	 TE Connectivity Harrisburg, PA 17105-3608			NAME			
			CHK L. ZHANG	17JUN2014							
			APVD U. GUO	17JUN2014							
TOLERANCES UNLESS OTHERWISE SPECIFIED:			PRODUCT SPEC		Ocean Side Fed Applicator -				RESTRICTED TO		
			-								
			APPLICATION SPEC								
			-								
			-								
0 PLC ±					SIZE				CASE CODE	DRAWING NO	REV
1 PLC ±					A1				00779	C=2266345	
2 PLC ±											
3 PLC ±											
4 PLC ±											
ANGLES ±											
FINISH -			WEIGHT -								

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

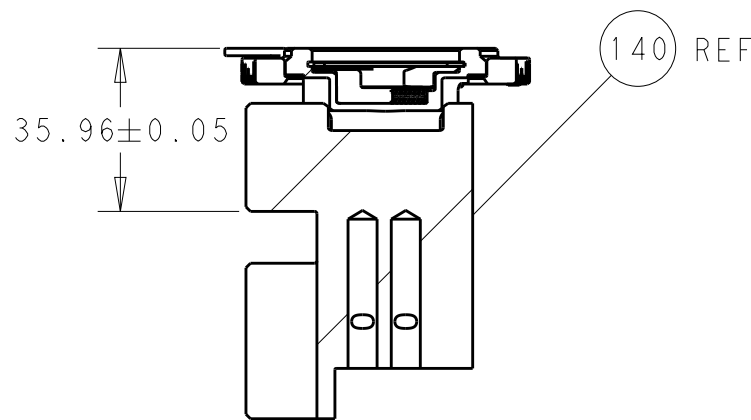
FEED TYPE MECHANICAL



PNEUMATIC

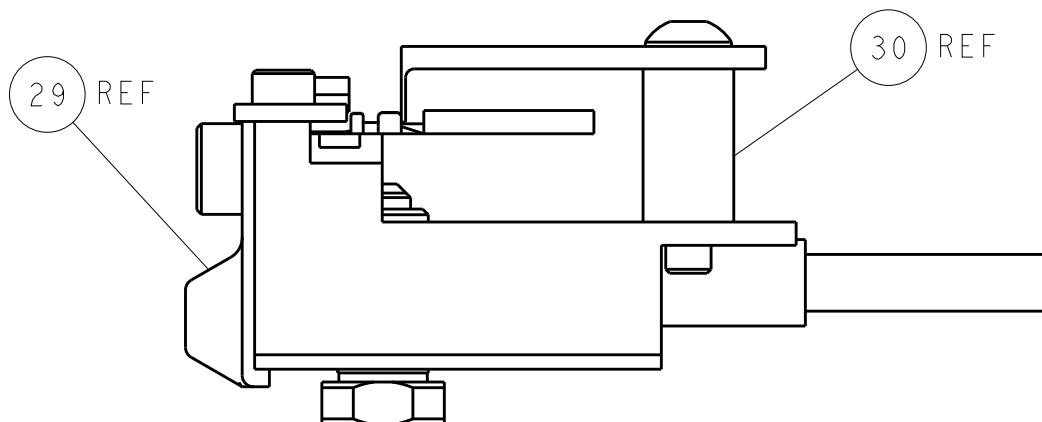


TERMINAL SUPPORT LOCATION



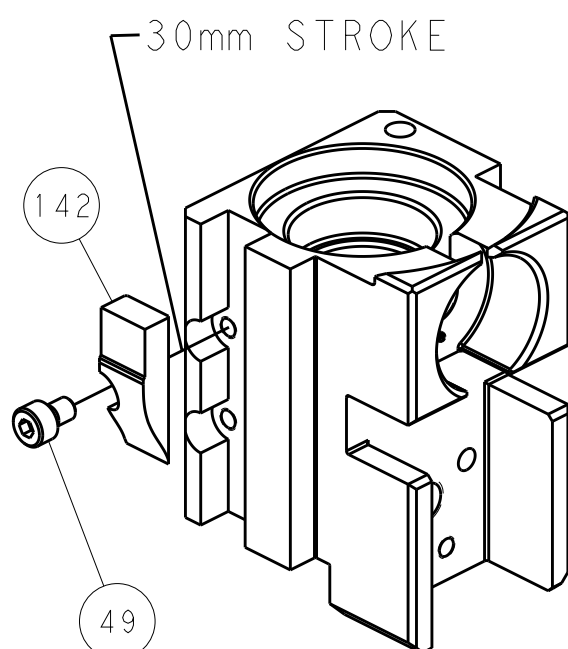
RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES

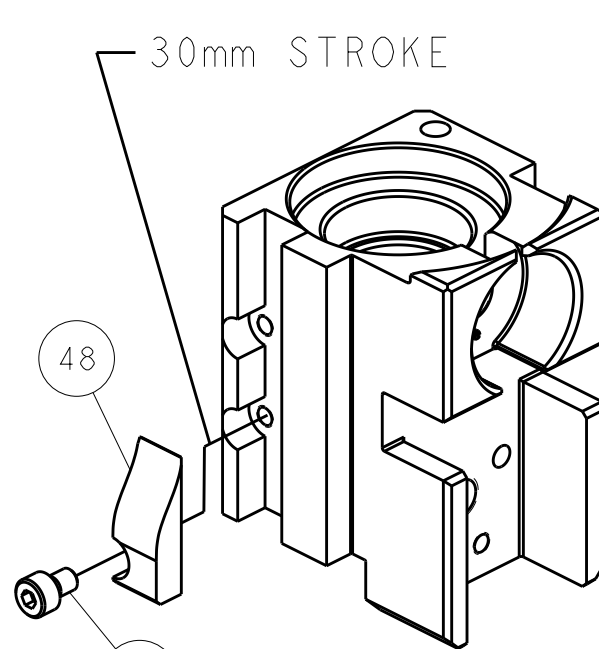


FEED TRACK POSITION
GUIDE BY WIRE BARREL

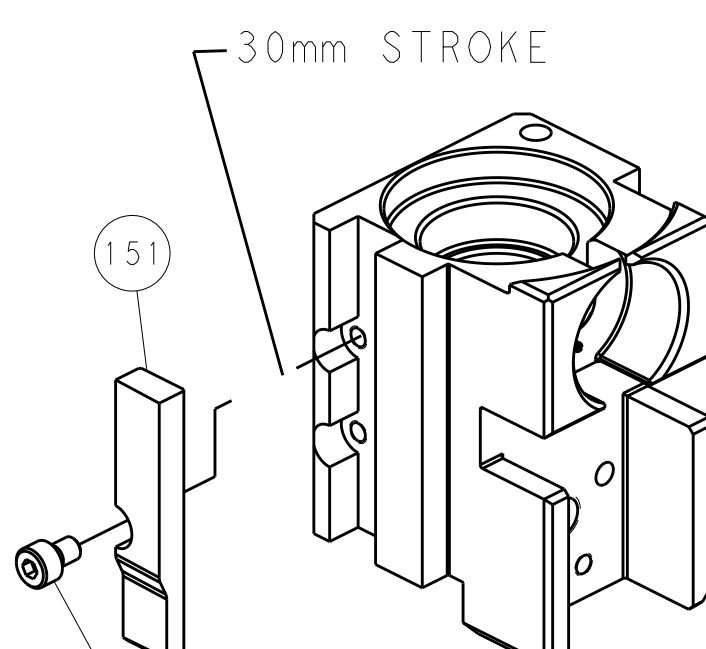
CAM POSITIONS



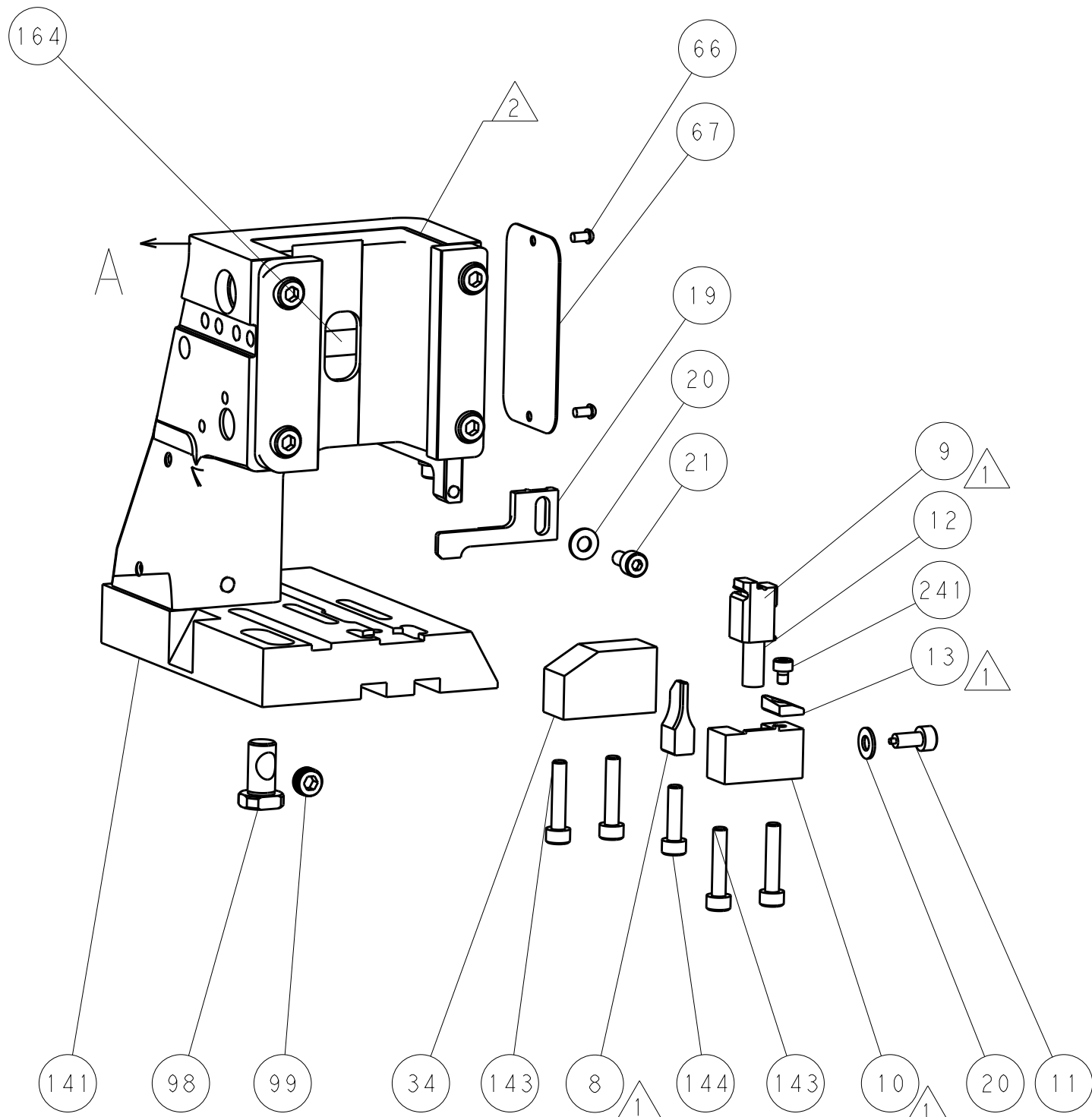
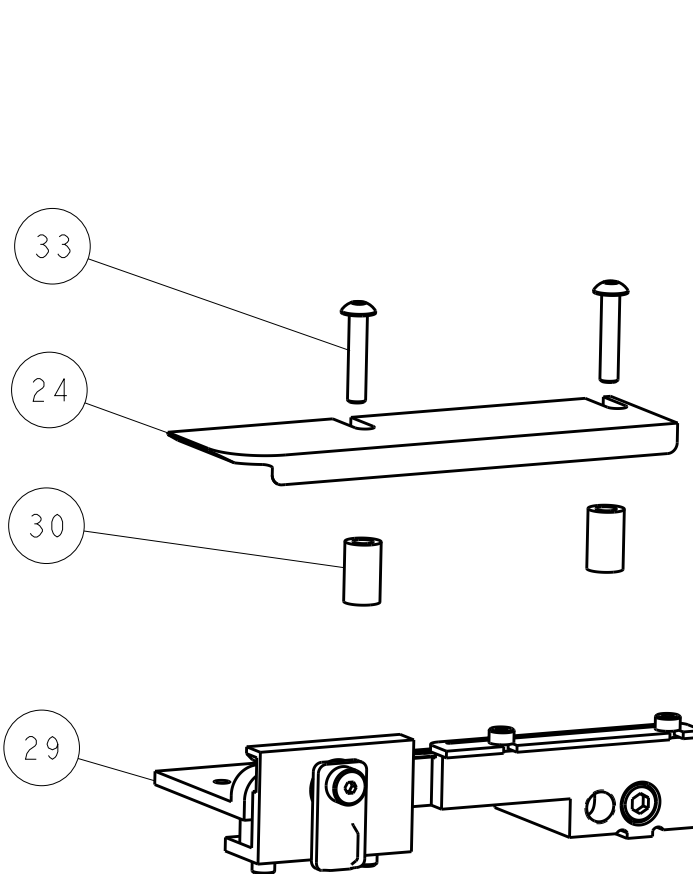
MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED



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

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS. 2. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS.		DWN K. HUANG 17JUN2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 17JUN2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J. GUO 17JUN2014	SIZE A1	
0 PLC ±.0005 1 PLC ±.0005 2 PLC ±.0005 3 PLC ±.0005 4 PLC ±.0005 ANGLES ±.0005 FINISH		PRODUCT SPEC APPLICATION SPEC WEIGHT	CAGE CODE 00779	
MATERIAL		Customer Accessible Production Drawing	SCALE 1:2	
			SHEET 4	
			OF 4	
			REV B	

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2266345-1](#)