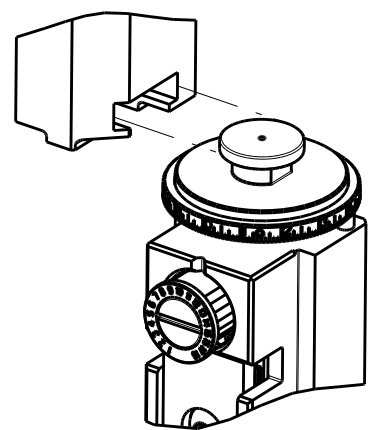


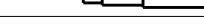
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
2266820-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	
7-2266820-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC	
7-2266820-7	B	CRIMP TOOLING KIT	-	



ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

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

APPLICATOR INSTRUCTIONS
 408-35042
 

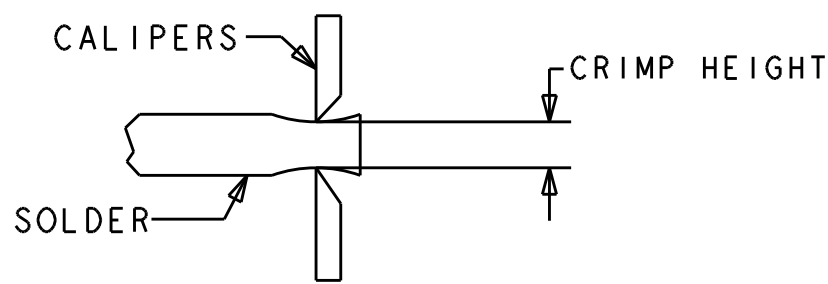
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: OUTER FERRULE, 180 DEGREE, LARGE CABLE FAKRA			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE 	
 114-32145		Ø 4.00-5.00 mm [.157-.197 IN]	
TERMINAL APPLICATION SPECIFICATION 	-	-	-
TERMINALS APPLIED 			
TE TERMINAL 2272409-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
RG-58			4.50+/-0.03 [.177+/- .001]		5.0
RG-58LL			4.50+/-0.03 [.177+/- .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 ($\phi 6.35\text{mm}$ [.250 IN] 50/50 SOLID CORE) AND MEASURE AT END OF SLUG.

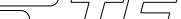


- SEE APPLICATION SPECIFICATION 114-32145
FOR RECOMMENDED STRIP LENGTH DIMENSIONS.

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	DNW	APVD	
			E1	ECR-17-014468	29SEP2017	MZ	K Z	
			F	ECR-18-011731	23JUL2018	AW	GB	
			G	ECR-18-015307	27SEP2018	ME	TE	
			H	ECR-19-011147	16 JUL2019	MZ	Y Y	

-	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	199
-	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	DESCRIPTION	ITEM NO

THIS DRAWING IS A COMPUTER GENERATED DRAWING. THE DIMENSIONS AND TOLERANCES SPECIFIED SHOULD BE CHECKED BY THE USER BEFORE USE.		DWN 28JAN2016 CDR BOB HIGMAN CHG 28JAN2016 J. ELBIN J. ELBIN 28JAN2016		 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 -	
		WEIGHT -		SIZE CAGE CODE DRAWING NO A 1 00779 C=2266820	
MATERIAL -		RESTRICTED TO -		SCALE 1:2 SHEET 1 OF 4 REV H	
Customer Accessible Product Drawing					

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: OUTER FERRULE, 180 DEGREE, LARGE CABLE FAKRA			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE Ø 4.00-5.00 mm [1.57-.197 IN]	
TERMINAL APPLICATION SPECIFICATION 	114-32145	-	-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2272409-1			



6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

-
- A diagram showing a cross-section of a crimped wire joint. A wire is inserted into a crimp sleeve. The sleeve is being compressed by a pair of calipers. The wire is coated with solder. The crimp height is indicated by a vertical arrow pointing to the top of the crimped section.

- ```
*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.
```

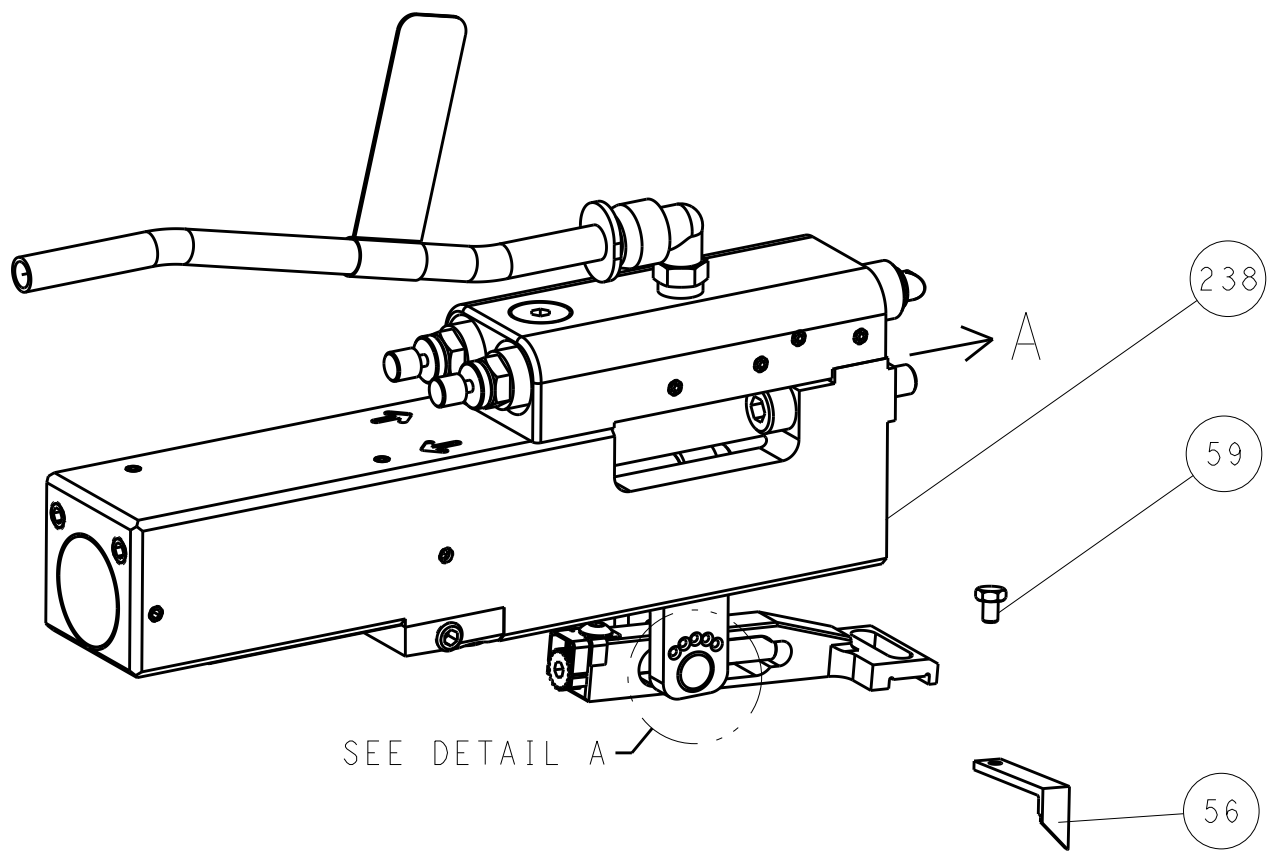
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

|     |     |     |             |                                     |         |
|-----|-----|-----|-------------|-------------------------------------|---------|
|     | -   | 1   | 183078-3    | SPACER, PRECISION                   | 259     |
|     | -   | 1   | 2119082-3   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
|     | -   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| △   | -   | 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     |
| △   | -   | 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   | 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 O               | 3       |
|     | -   | 1   | 1-455888-2  | SPACER, CRIMPER                     | 2       |
| △   | 1   | 1   | 2-1633723-2 | CRIMPER, WIRE O                     | 1       |
| -77 | -22 |     | PART NO     | DESCRIPTION                         | ITEM NO |

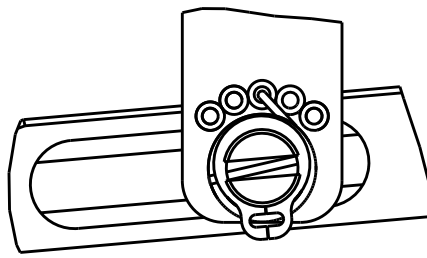
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE  
PNEUMATIC

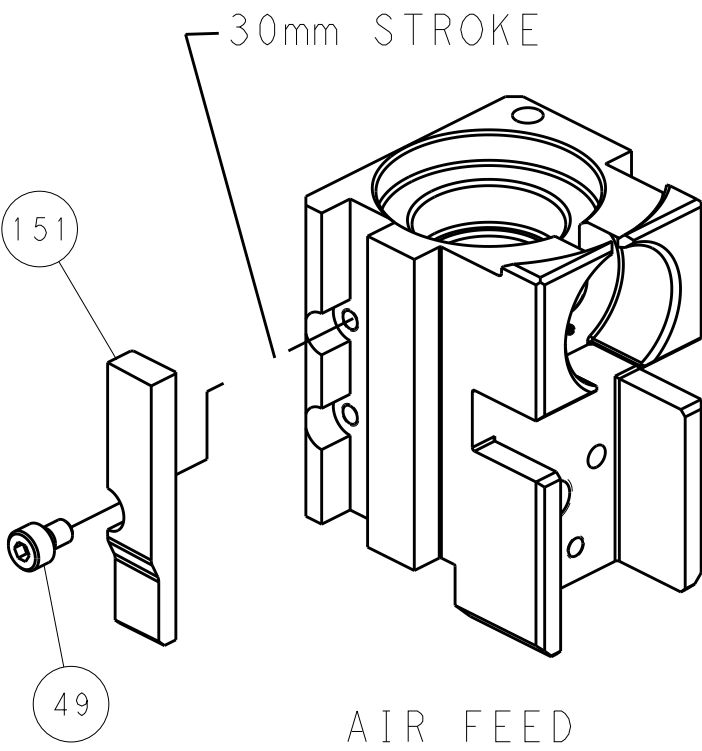


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

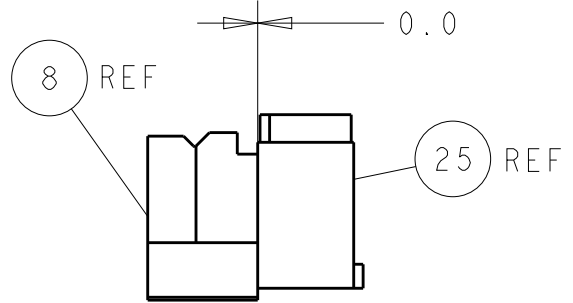
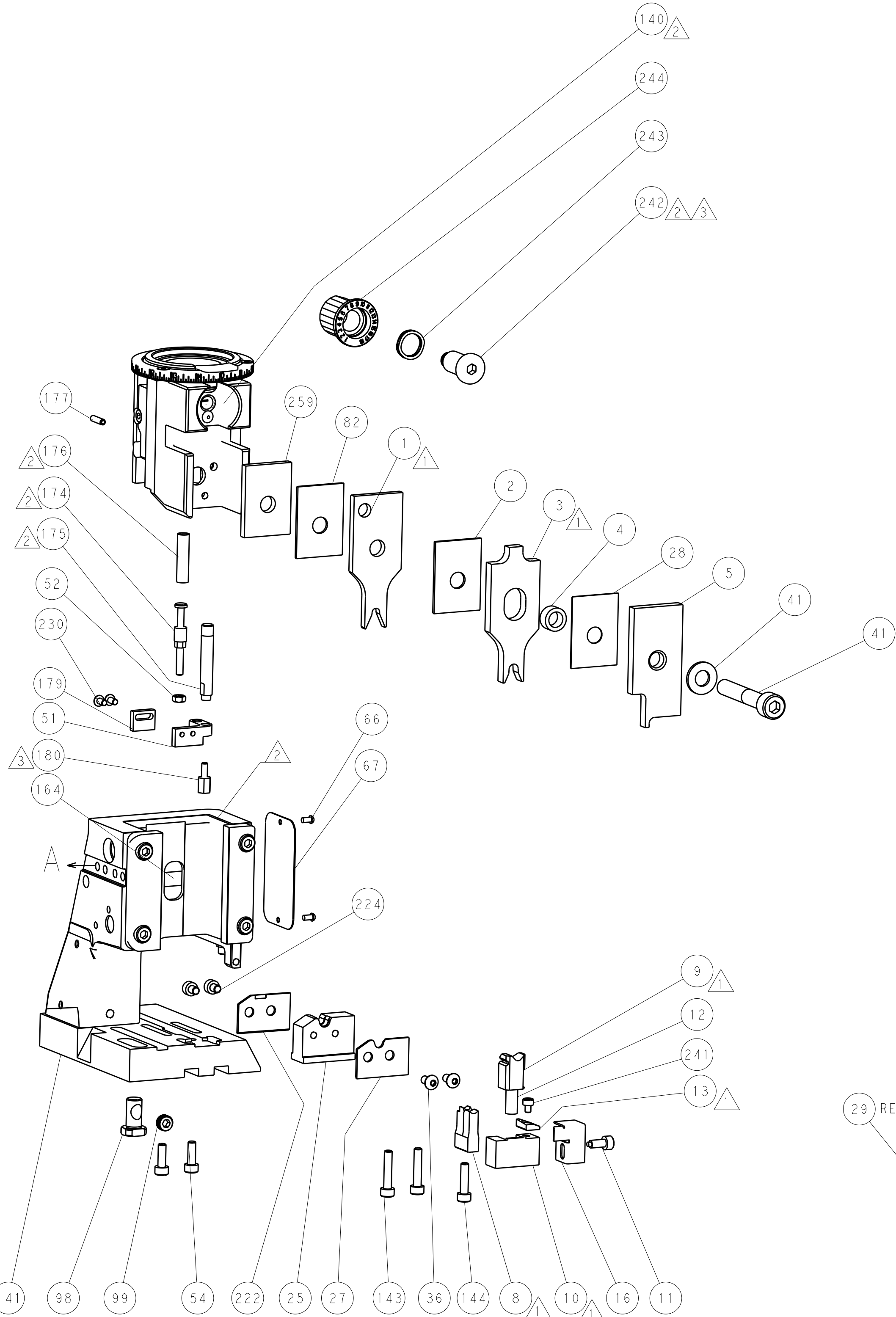


DETAIL A

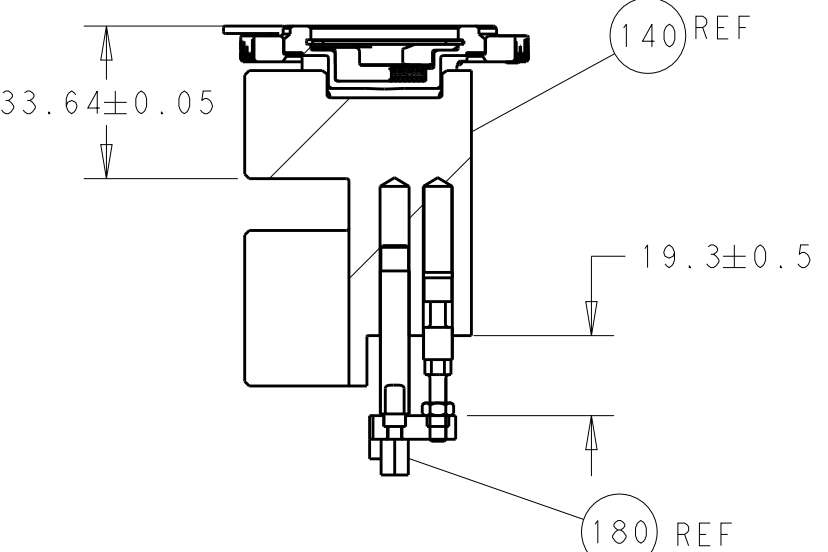
CAM POSITION



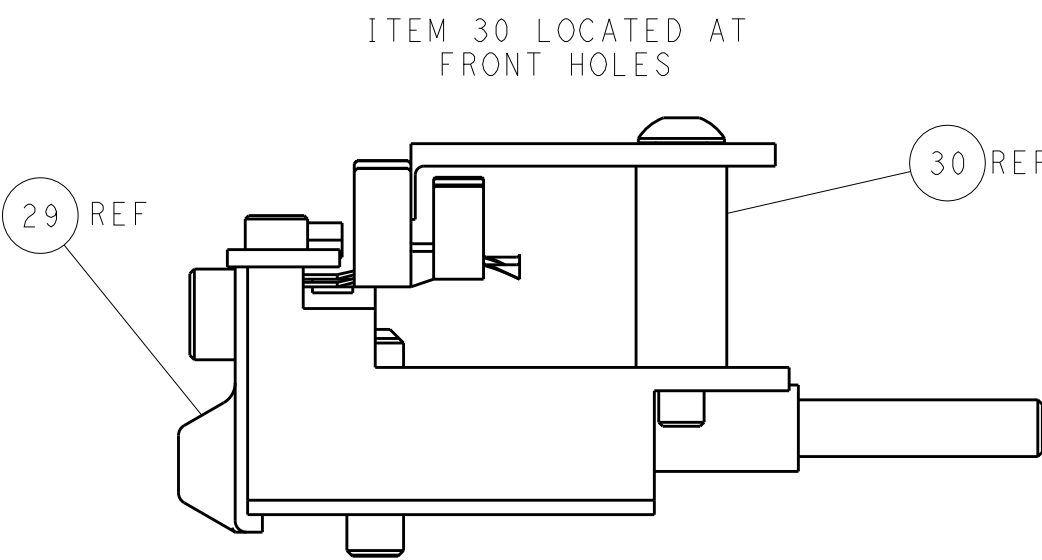
AIR FEED



TERMINAL SUPPORT LOCATION

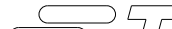


HOLDDOWN AND RAM SET-UP



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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| DIMENSIONS:                                                                                                                                      |  |  |  |  |  |  |  |  |  | CHKD             |  | T. ELBIN   |  | 28JAN2016 |  |                                                                                                                                    |  |           |  |            |  |
| mm                                                                                                                                               |  |  |  |  |  |  |  |  |  | APVD             |  | T. ELBIN   |  | 28JAN2016 |  |                                                                                                                                    |  |           |  |            |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                                                                           |  |  |  |  |  |  |  |  |  | PRODUCT SPEC     |  |            |  |           |  |                                                                                                                                    |  |           |  |            |  |
|                                                             |  |  |  |  |  |  |  |  |  | APPLICATION SPEC |  |            |  | NAME      |  | Ocean Side Feed<br>Applicator                                                                                                      |  |           |  |            |  |
| MATERIAL                                                                                                                                         |  |  |  |  |  |  |  |  |  | WEIGHT           |  | SIZE       |  |           |  |                                                                                                                                    |  | CAGE CODE |  | DRAWING NO |  |
| -                                                                                                                                                |  |  |  |  |  |  |  |  |  | -                |  | A          |  | 00779     |  | C=2266820                                                                                                                          |  | -         |  |            |  |
| Customer Accessible Production Drawing                                                                                                           |  |  |  |  |  |  |  |  |  | SCALE            |  | 1:2        |  | SHEET     |  | 4 OF 4                                                                                                                             |  | REV       |  | H          |  |

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