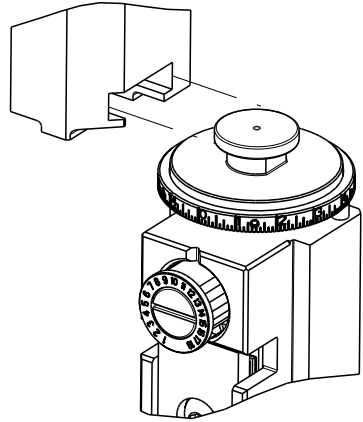


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266911-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266911-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266911-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266911-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266911-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KET TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: .040 III CONNECTOR TERMINAL			
WIRE STRIP LENGTH 4.18-4.94 mm [.164-.194 IN]		INSULATION DIAMETER RANGE Ø1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
2113796-1	ST740771-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.25+/-0.05 [.049+/- .002]	8.7
AVSS(CAVS) 0.5mm ²	1.23+/-0.05 [.048+/- .002]	9.0
22 AWG	1.16+/-0.05 [.046+/- .002]	9.8
AVSS(CAVS) 0.3mm ²	1.14+/-0.05 [.045+/- .002]	10.0



- 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.

TERMINAL DATA: KET TERMINAL CUSTOMER CRIMP SPECIFICATION			
TERMINAL NAME: .040 III CONNECTOR TERMINAL			
WIRE STRIP LENGTH 4.18-4.94 mm [.164-.194 IN]		INSULATION DIAMETER RANGE Ø1.40-1.70 mm [.055 - .067 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
2113796-1	ST740771-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm ²	1.11±0.03 [.044±.001]	10.2

*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)

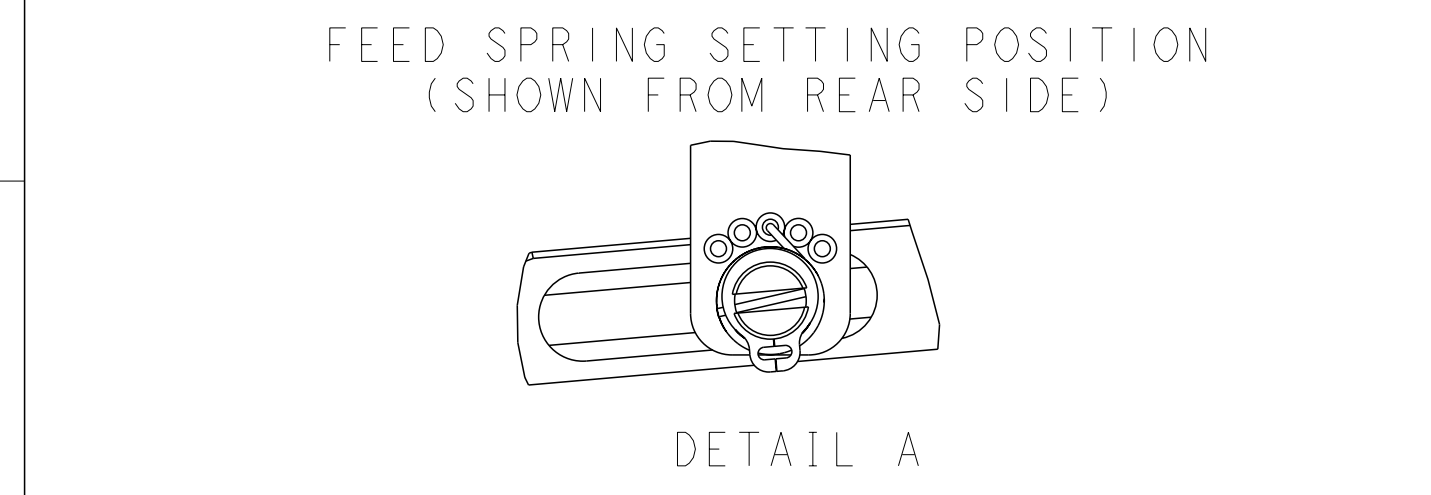
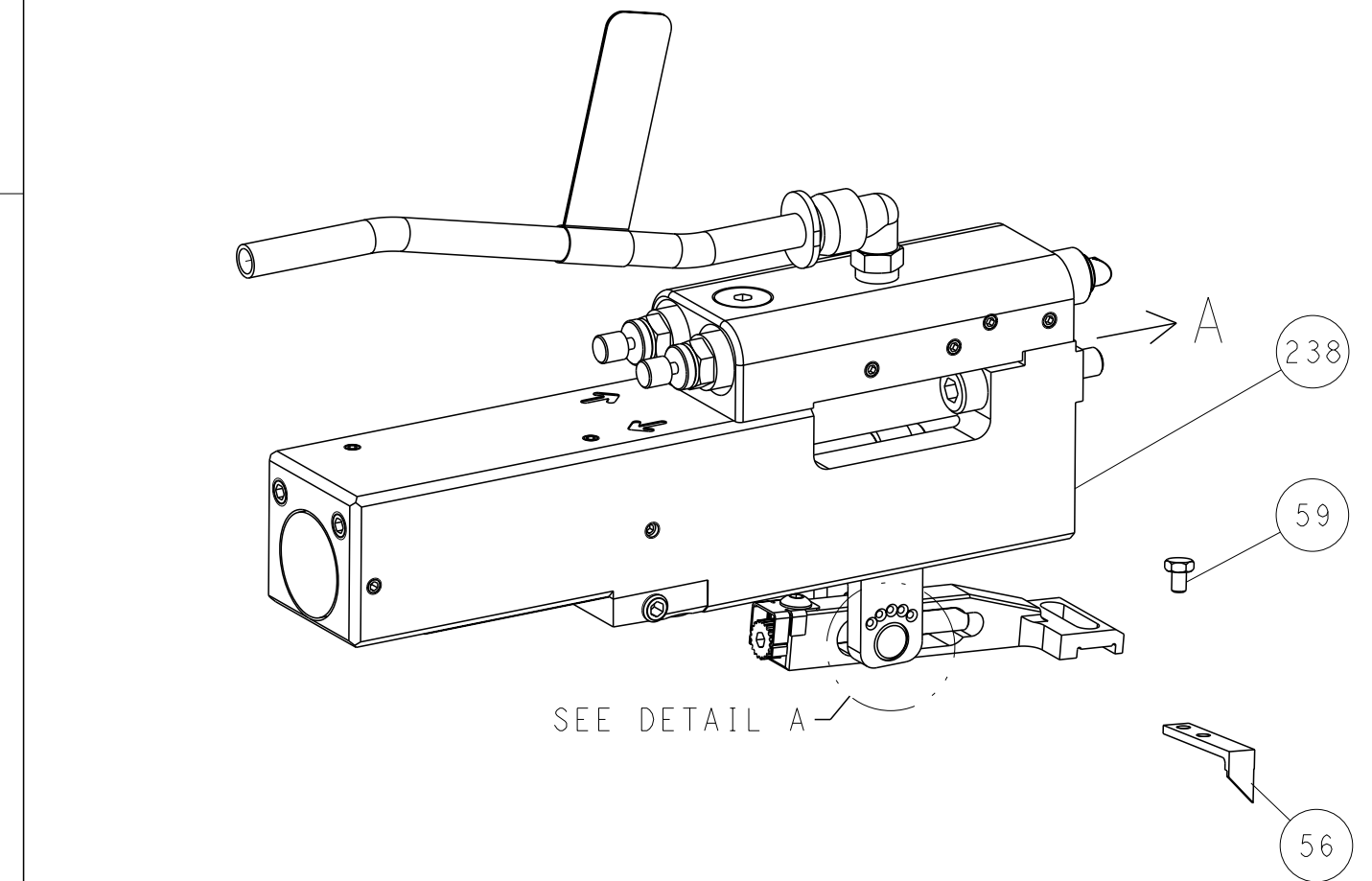
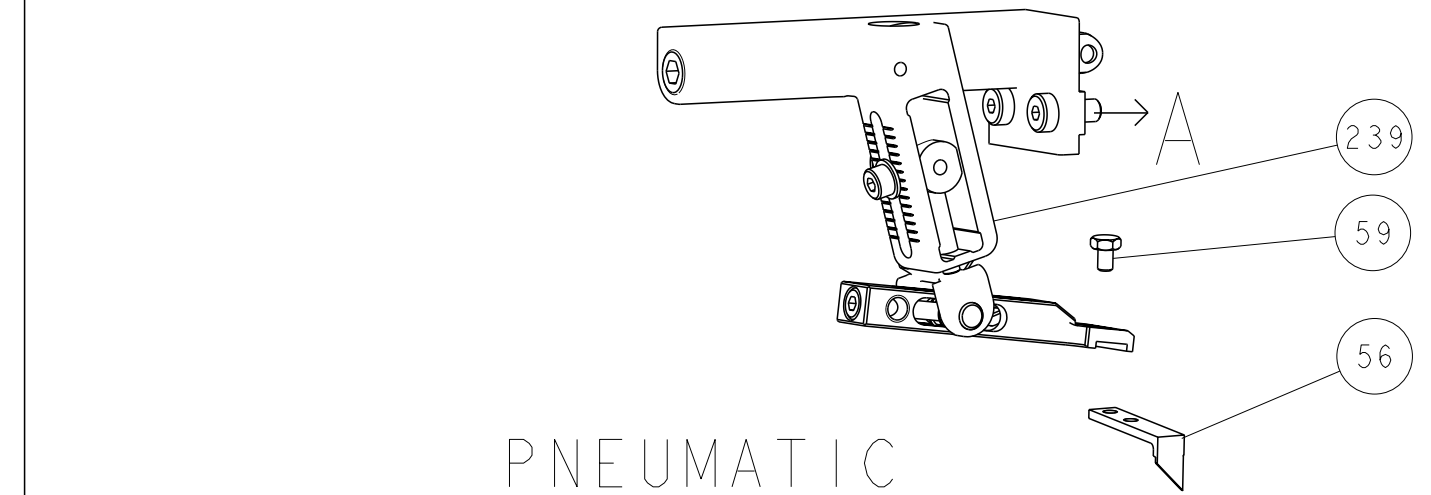
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		B1		ECR-20-012030	25AUG2020	JWC	TE

	-	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	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
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	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	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	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	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	1-356885-4	STOP, SHEAR	11
△	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT -	9
1	1	2	2	1	1	5-1633919-2	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	5-238011-5	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1-1633961-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	2	1	1	1-456404-1	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

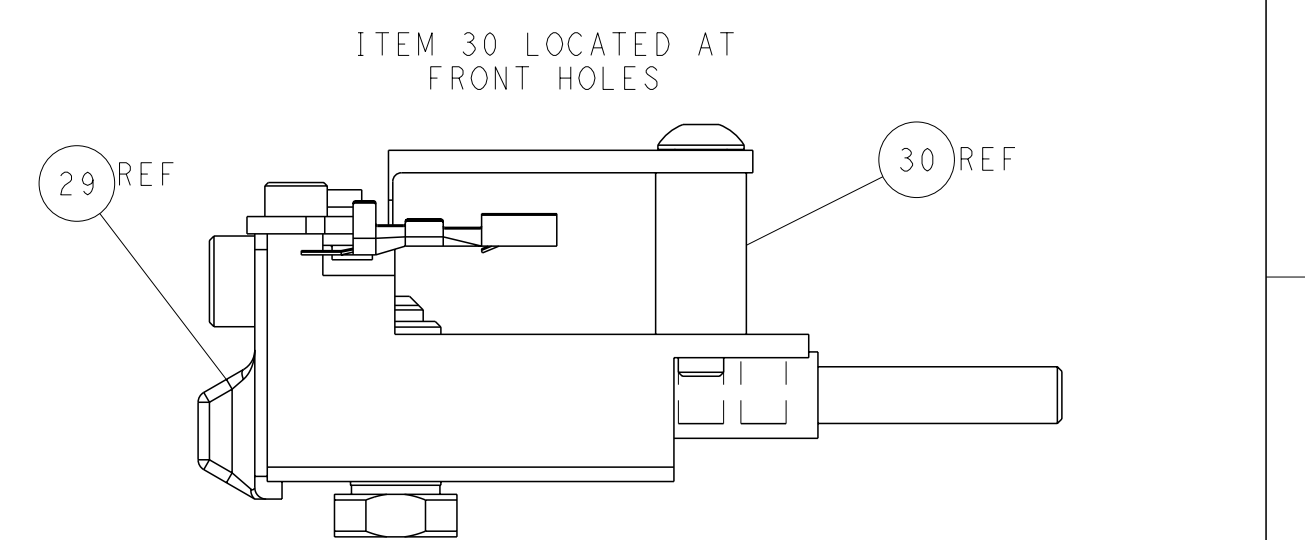
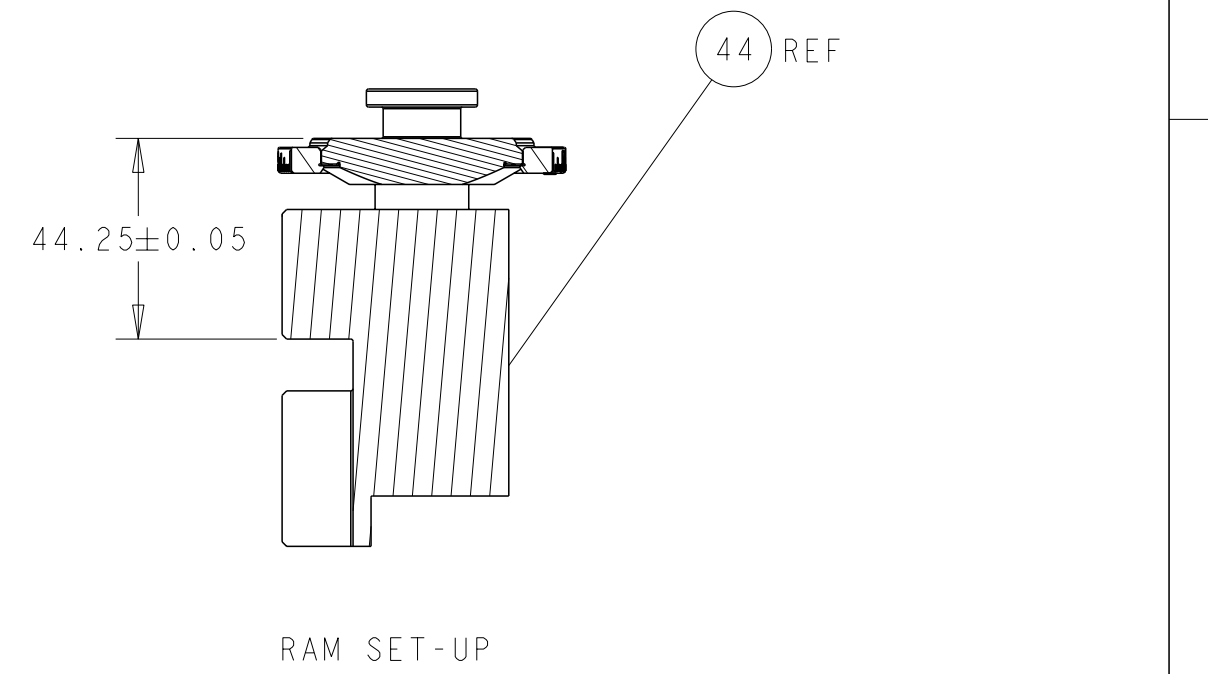
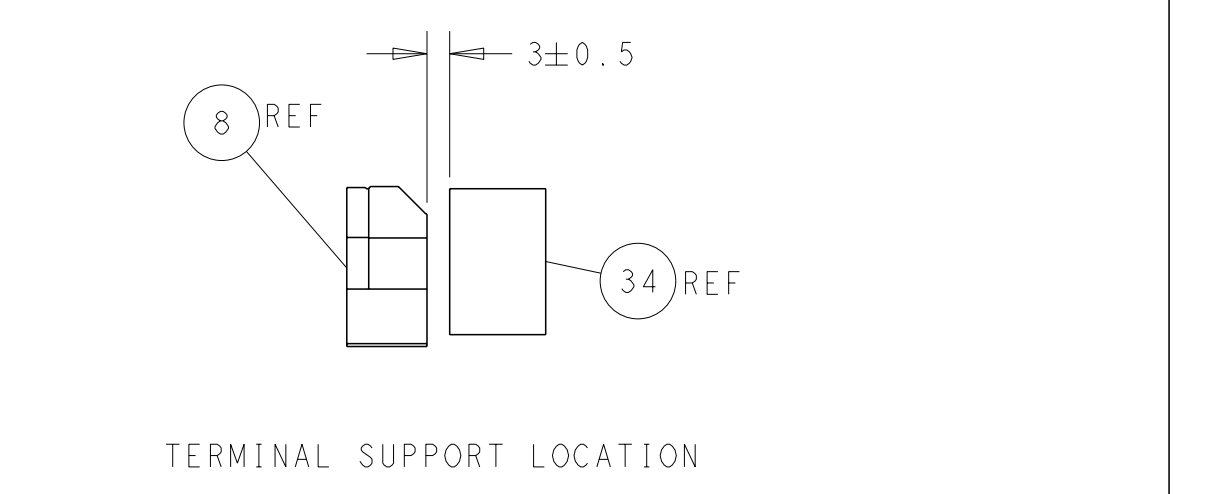
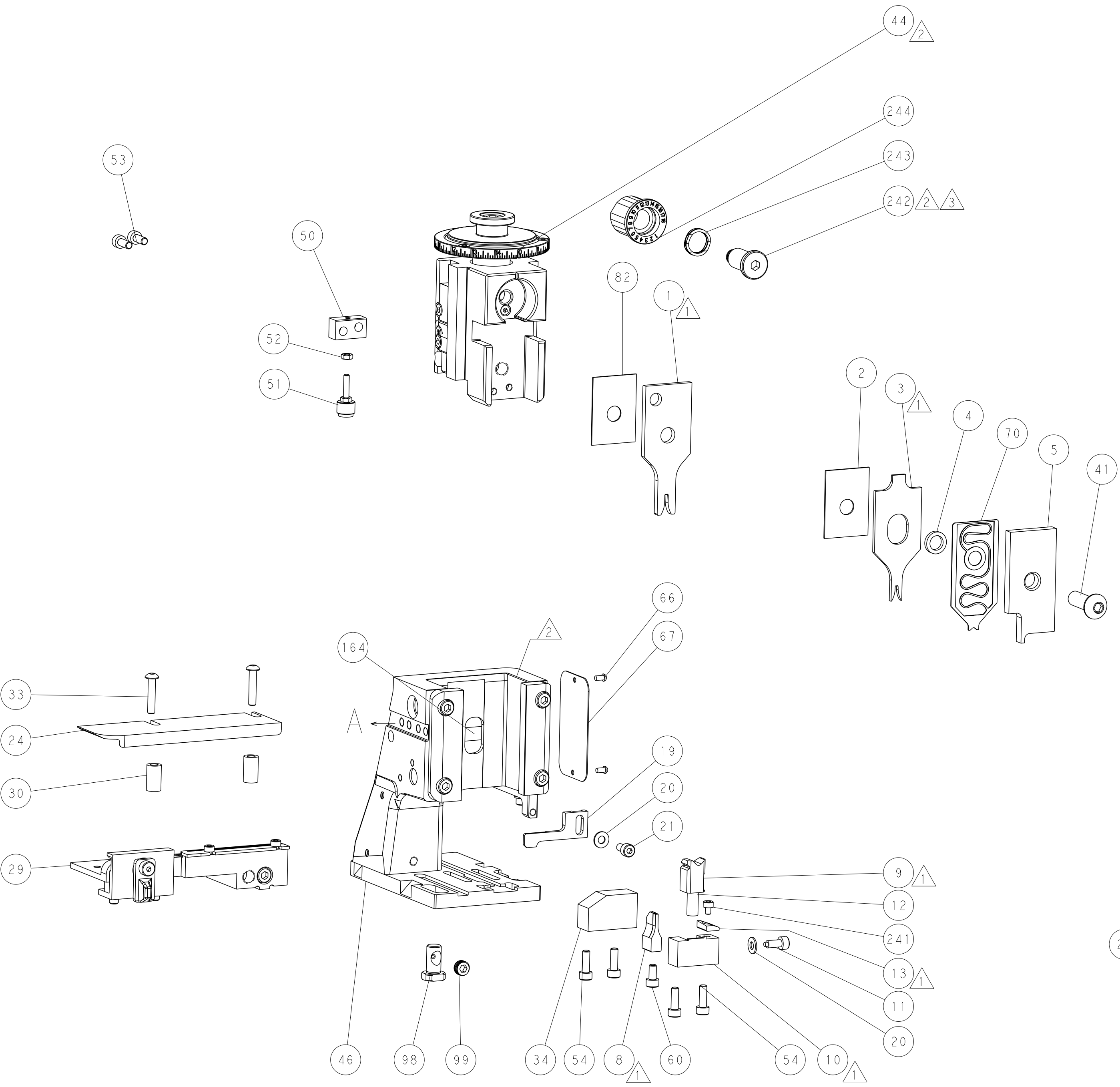
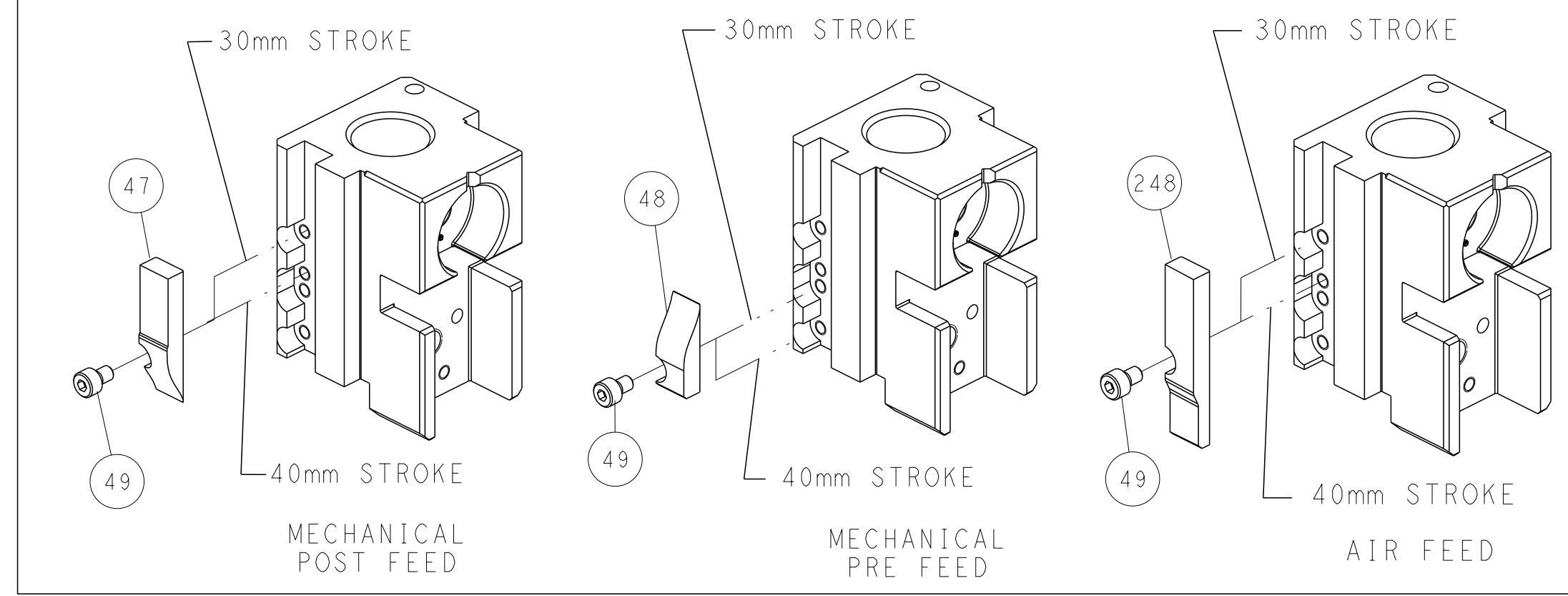
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN B. WEAVER CHK G. BAILEY APVD G. BAILEY	17JUL2015 17JUL2015 17JUL2015	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator			
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		PRODUCT SPEC		SIZE CASE CODE DRAWING NO			
		ANGLES FINISH ±		APPLICATION SPEC		RESTRICTED TO			
MATERIAL		FINISH		WEIGHT		A1 00779 ©=2266911		-	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 1 OF 4 REV B1			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

FEED TYPE MECHANICAL



CAM POSITIONS

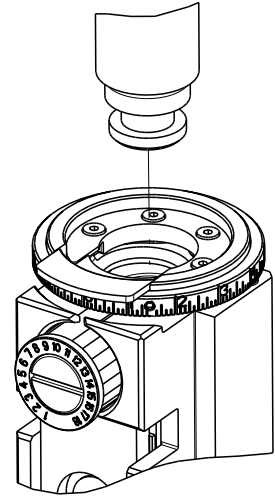


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

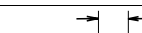
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		1 PLC ±		G. BAILEY		17JUL2015		NAME	
		2 PLC ±		G. BAILEY		17JUL2015		Ocean Side Feed	
		3 PLC ±		G. BAILEY		17JUL2015		Applicator	
		4 PLC ±		G. BAILEY		17JUL2015		SIZE	
		ANGLES ±		G. BAILEY		17JUL2015		CAGE CODE	
		FINISH ±		G. BAILEY		17JUL2015		DRAWING NO	
				G. BAILEY		17JUL2015		RESTRICTED TO	
				G. BAILEY		17JUL2015		A1 00779	
				G. BAILEY		17JUL2015		C=2266911	
				G. BAILEY		17JUL2015		Customer Accessible Production Drawing	
				G. BAILEY		17JUL2015		SCALE	
				G. BAILEY		17JUL2015		1:2	
				G. BAILEY		17JUL2015		SHEET	
				G. BAILEY		17JUL2015		2 of 4	
				G. BAILEY		17JUL2015		REV	
				G. BAILEY		17JUL2015		B1	

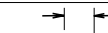
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2015		2015	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266911-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266911-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266911-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KET TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 III CONNECTOR TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.18-4.94 mm [.164-.194 IN]		Ø1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
2113796-1	ST740771-3		

TERMINAL DATA: KET TERMINAL		CUSTOMER CRIMP SPECIFICATION	
TERMINAL NAME: .040 III CONNECTOR TERMINAL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.18-4.94 mm (.164-.194 IN)			Ø 1.40-1.70 mm (.055 - .067 IN)
TERMINAL APPLICATION SPECIFICATION		NONE	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
2113796-1	ST740771-3		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
20 AWG		1.25+/-0.05 [.049+/- .002]		8.7
AVSS(CAVS) 0.5mm ²		1.23+/-0.05 [.048+/- .002]		9.0
22 AWG		1.16+/-0.05 [.046+/- .002]		9.8
AVSS(CAVS) 0.3mm ²		1.14+/-0.05 [.045+/- .002]		10.0

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.35mm ²		1.11±0.03 [.044±.001]		10.2



- 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	DESCRIPTION				DATE	DWN	APVD
		P	LTR					
			-	SEE SHEET 1		-	-	-

-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
-	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
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	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	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	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	1803095-3	FLOATING SHEAR, FRONT -	9
1	1	1	5-1633919-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	5-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	1-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1-456404-1	CRIMPER, WIRE PREMIUM	1

1

1

1

1

1

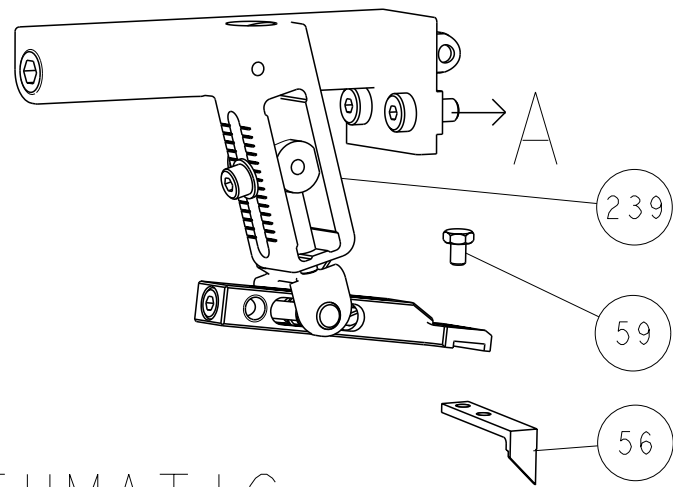
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THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN B. WEAVER 17JUL2015	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 17JUL2015	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD G. BAILEY 17JUL2015	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -		PRODUCT SPEC -	00779 ©=2266911	
		APPLICATION SPEC -	Customer Accessible Production Drawing	
		WEIGHT -	SCALE 1:2	
		FINISH -	SHEET 3 OF 4	
			REV B1	

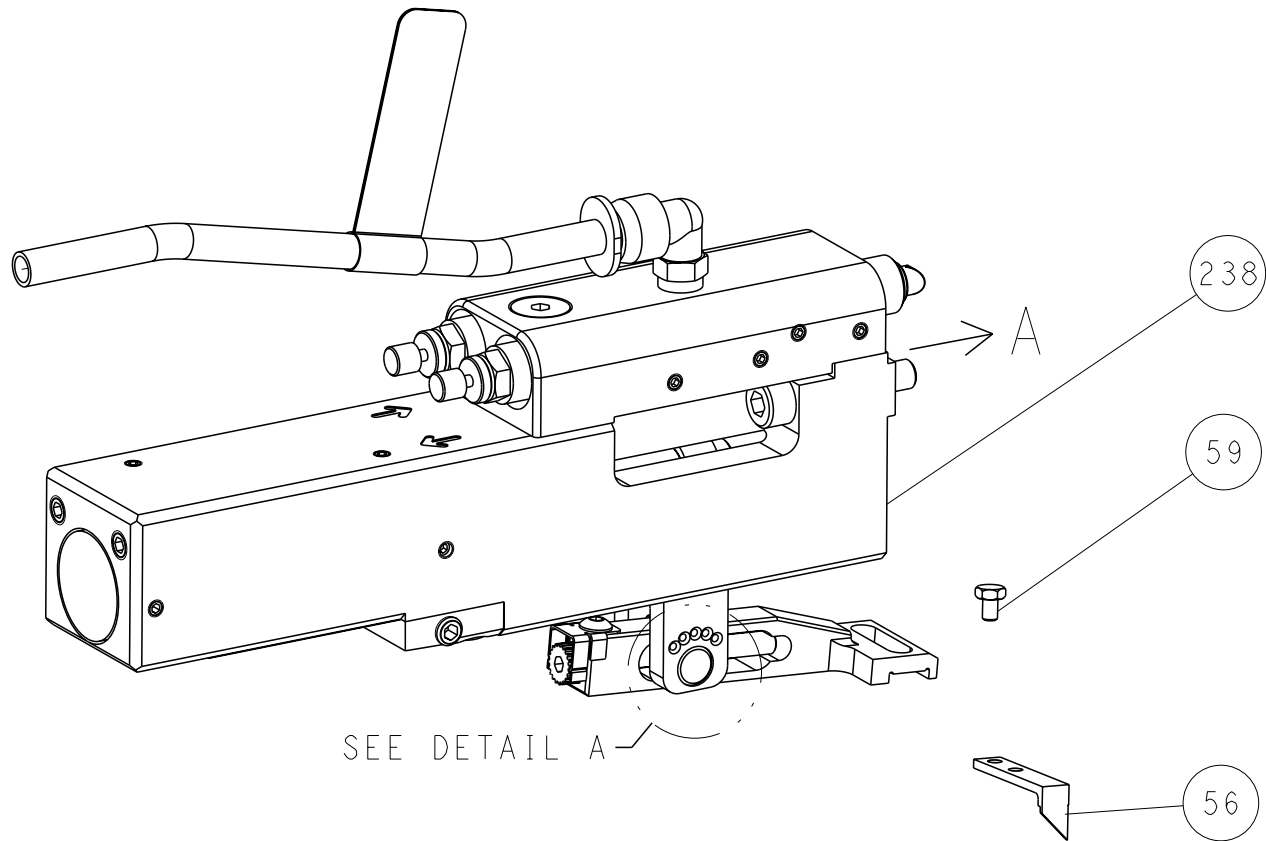
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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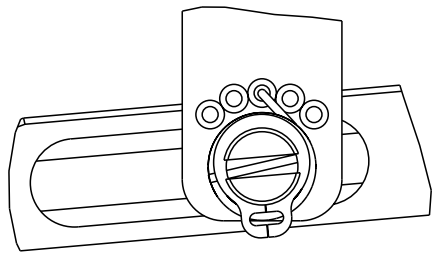
FEED TYPE
MECHANICAL



PNEUMATIC

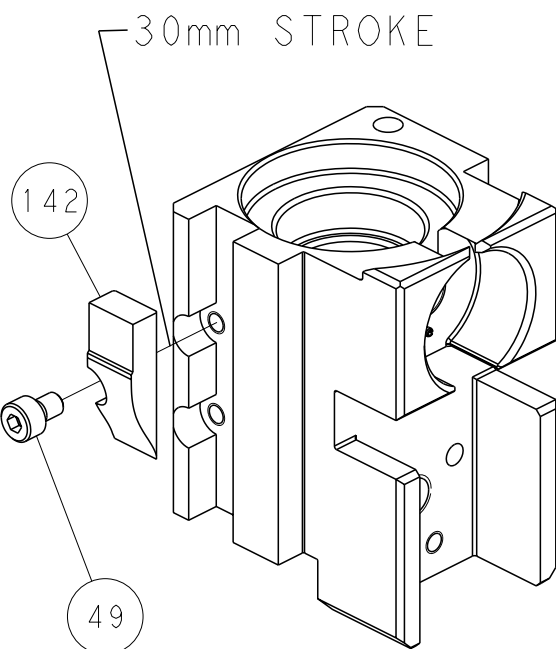


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

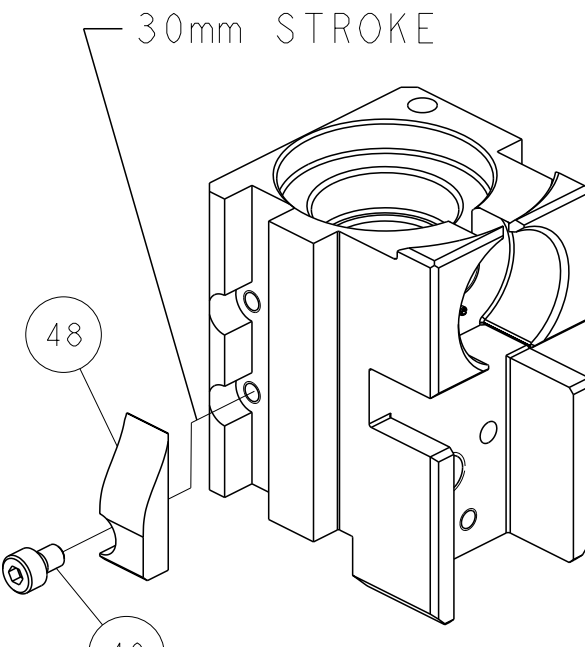


DETAIL A

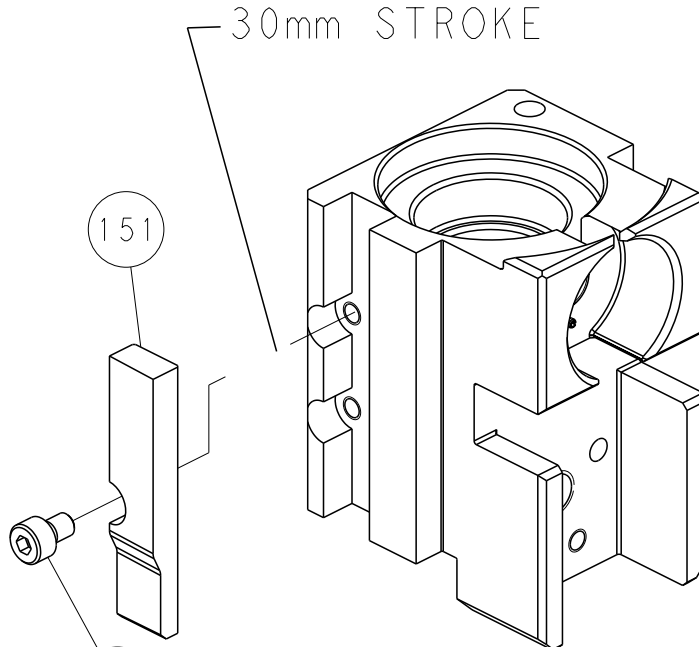
CAM POSITIONS



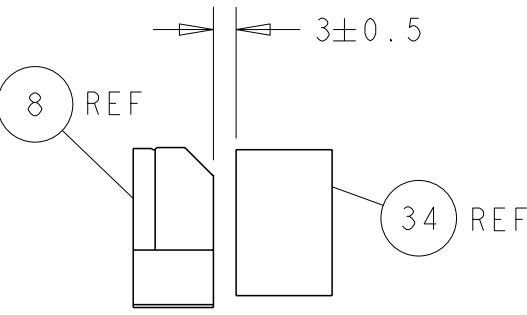
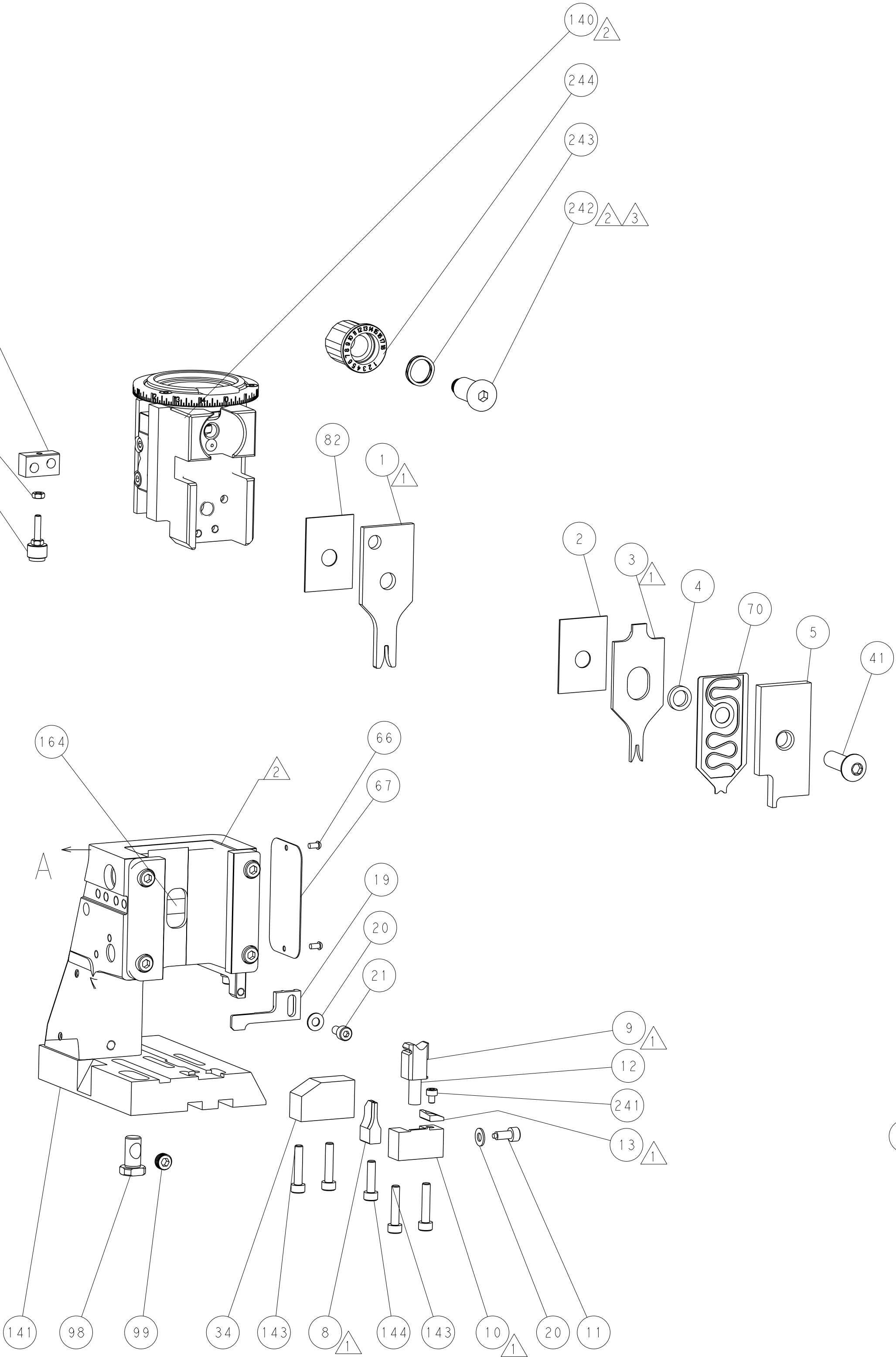
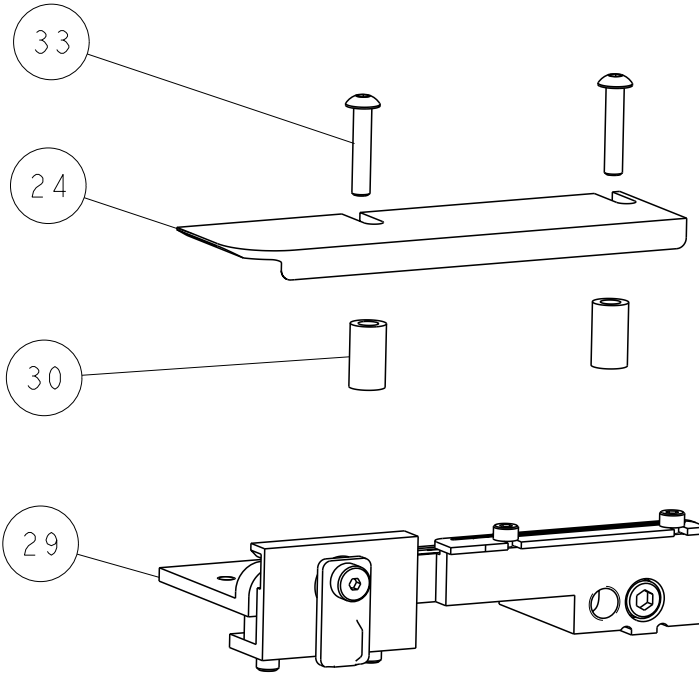
MECHANICAL
POST FEED



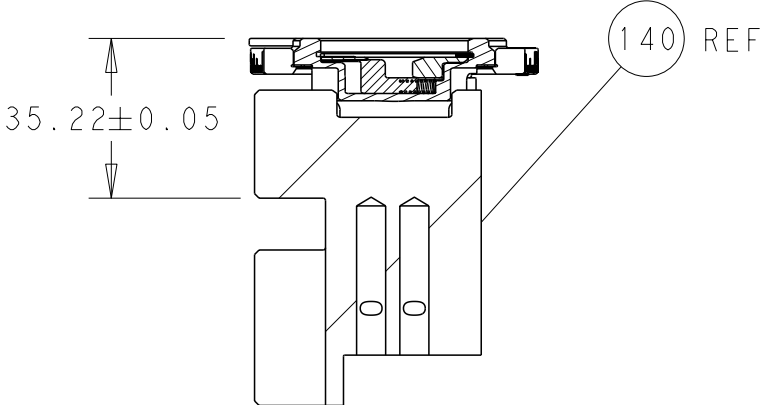
MECHANICAL
PRE FEED



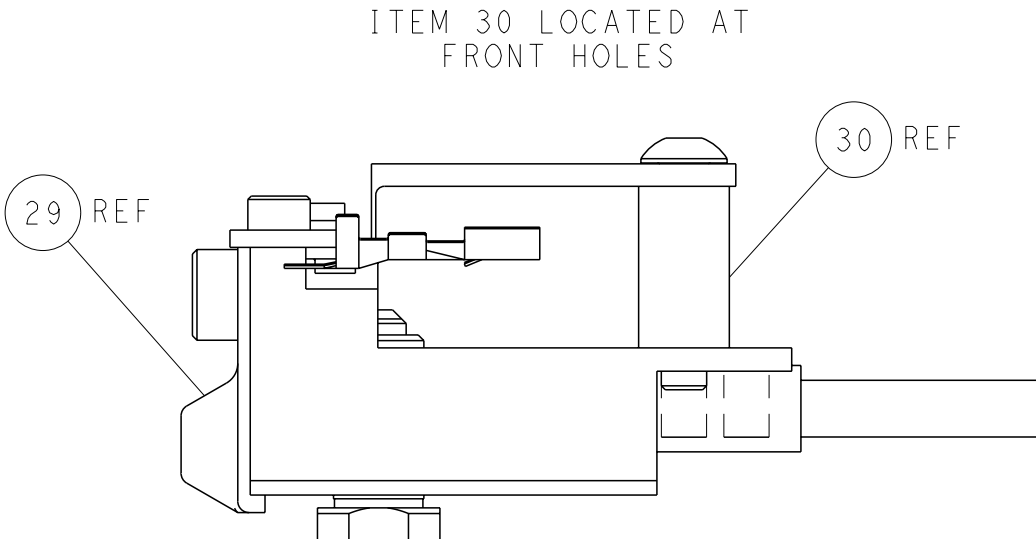
AIR FEED



TERMINAL SUPPORT LOCATION



RAM 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)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN B. WEAVER 17JUL2015		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CMR G. BAILEY 17JUL2015		NAME Ocean Side Feed Applicator	
2 PLC ±		3 PLC ±		APVD G. BAILEY 17JUL2015		SIZE A1	
4 PLC ±		ANGLES ±		PRODUCT SPEC		CAGE CODE 00779	
FINISH		WEIGHT		APPLICATION SPEC		DRAWING NO C=2266911	
MATERIAL		Customer Accessible Production Drawing		SCALE 1:2		RESTRICTED TO -	
				SHEET 4		OF 4	
						REV B1	

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[2266911-2](#)