

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266777-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266777-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266777-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266777-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266777-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

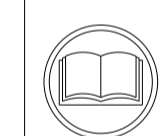


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [1.062]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SOCKET CONTACT, PLUG, SMB			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
114-13157	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1438896-2	2203232-2	1438890-7	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-58 LL or RG-58	0.86 +/- 0.05 [1.034 +/- .002]	4.0



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 SEE TERMINAL APPLICATION SPEC 114-13157 FOR WIRE STRIP LENGTH.
- 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 LUBRICANT IS RECOMMENDED.
- 6. 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.

FOR LEADMAKER APPLICATIONS

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	LTN	DESCRIPTION	DATE	DWN	APVD
		C		ECR-18-012869	13AUG2018	TB	TE
		D		ECR-19-000232	07JAN2019	JAH	TE
		E		ECR-19-011553	23JUL2019	MZ	YY
		F		ECR-22-127053	19JAN2022	FJ	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248					
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239					
-	-	-	1	-	2844940-1	AIR FEED MODULE	238					
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164					
5	-	1	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	455888-5	SPACER, CRIMPER	82					
-	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	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	7-1752356-2	SUPPORT, TERMINAL	34					
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33					
-	2	2	2	2	2-2844962-4	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	3-22280-3	SPRING, COMPRESSION	12					
-	1	1	1	1	356885-5	STOP, SHEAR	11					
1	-	1	1	1	1803747-1	HOLDER, SHEAR	10					
1	-	1	1	1	1803251-1	SHEAR, FLOATING	9					
1	1	2	2	1	1	4-1633933-5	ANVIL, COMBINATION	8				
-	-	-	-	-	-	-	7					
-	-	-	-	-	-	-	6					
-	1	1	1	1	1803419-5	DEPRESSOR, SHEAR	5					
-	-	-	-	-	-	-	4					
-	-	-	-	-	-	-	3					
-	-	-	-	-	-	-	2					
1	1	2	2	1	1	4-456403-6	CRIMPER, WIRE PREMIUM	1				
-	77	-	72	-	71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

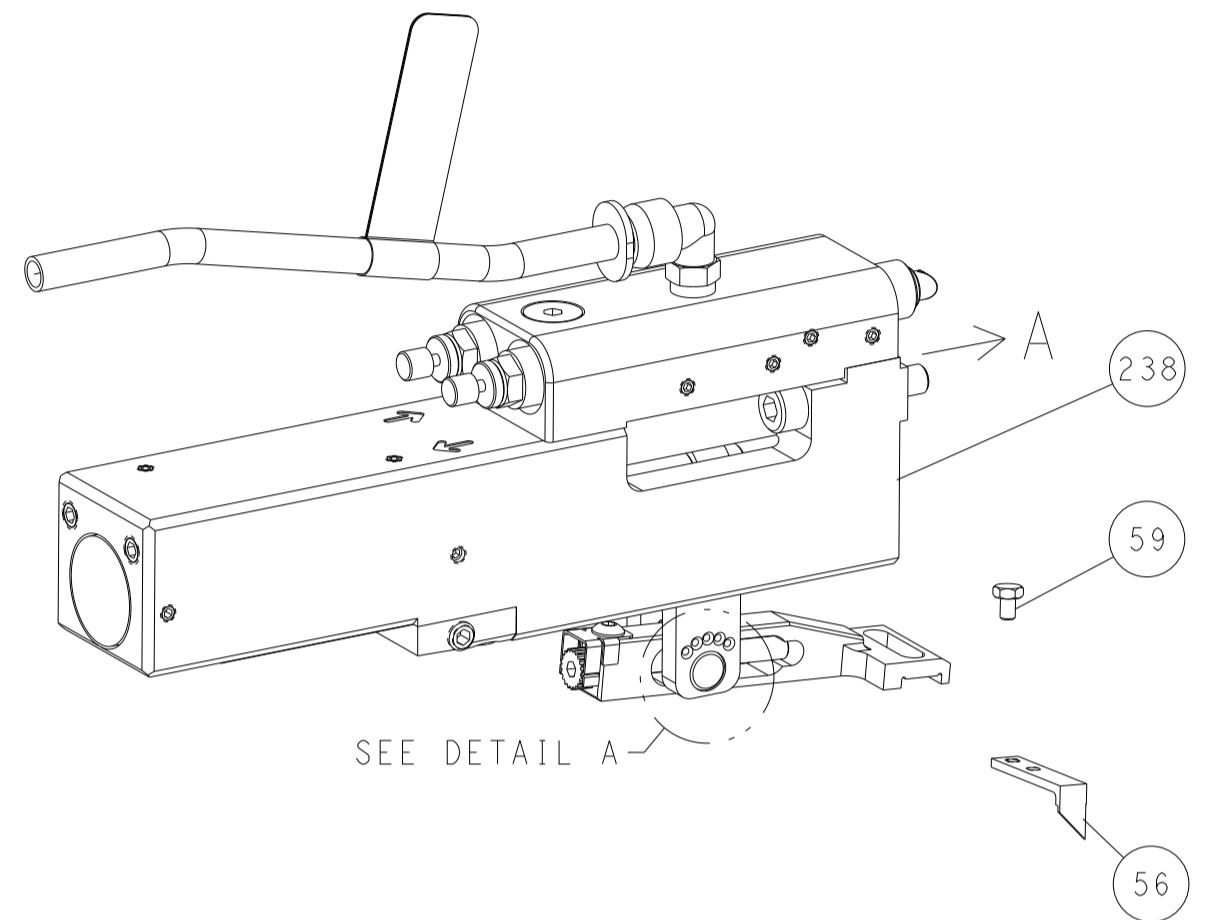
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mm	0 PLC	±													
	1 PLC	±													
	2 PLC	±													
	3 PLC	±													
	4 PLC	±													
	ANGLES	±													

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

FEED TYPE MECHANICAL



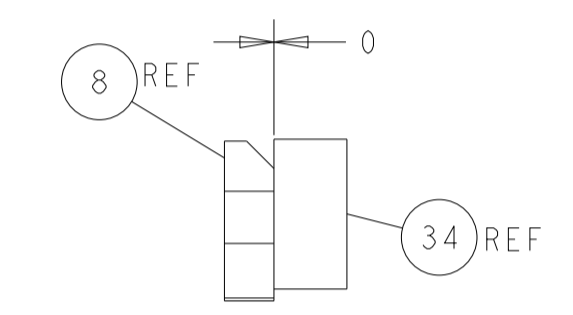
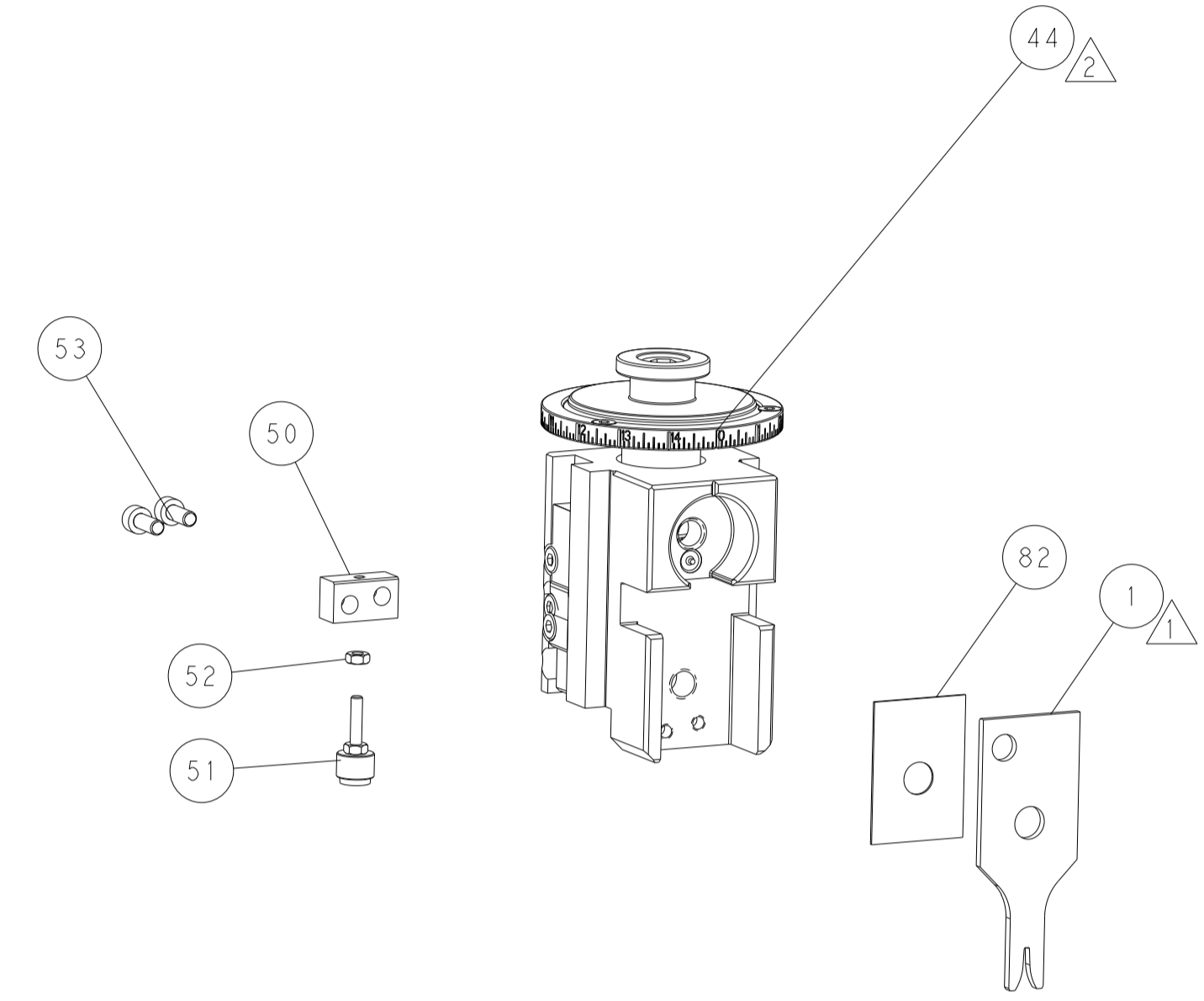
PNEUMATIC



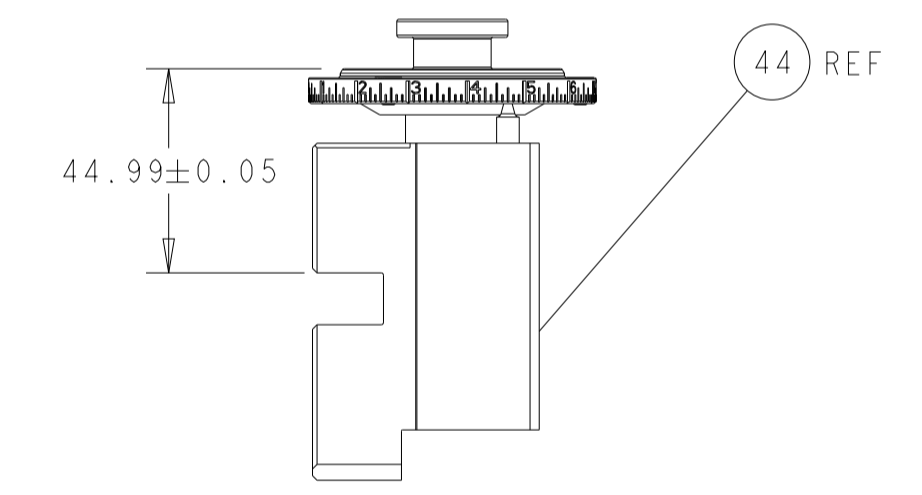
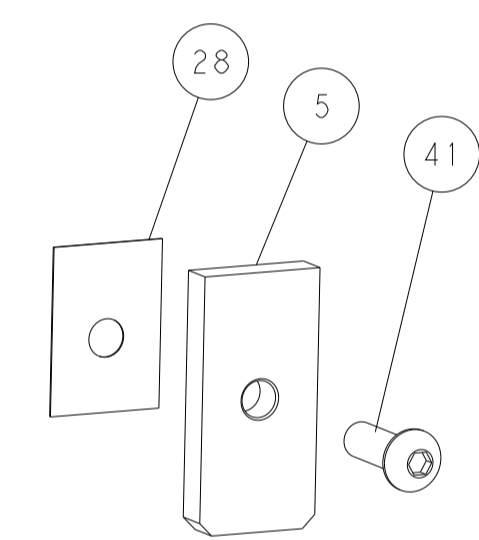
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



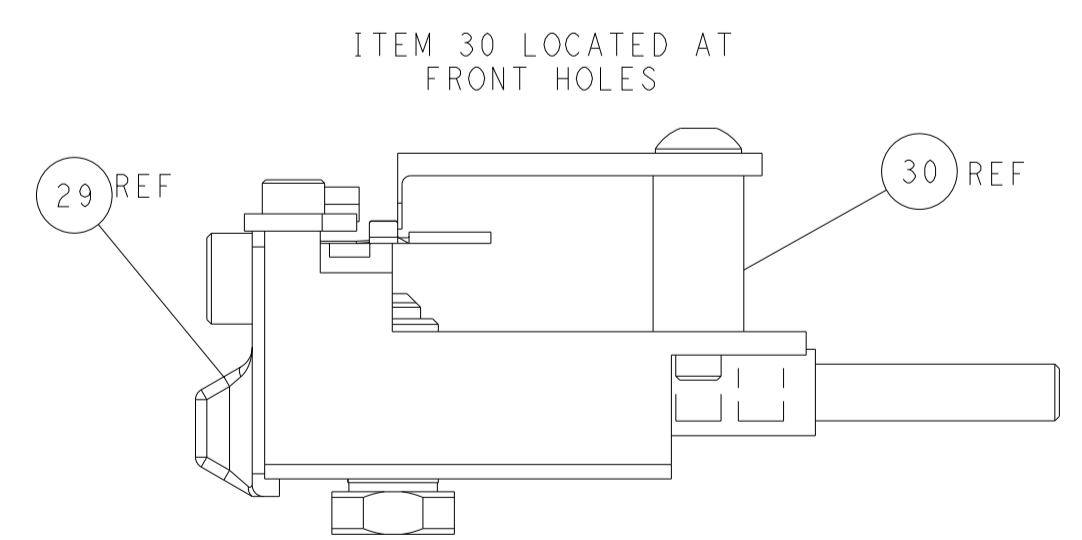
DETAIL A



TERMINAL SUPPORT LOCATION

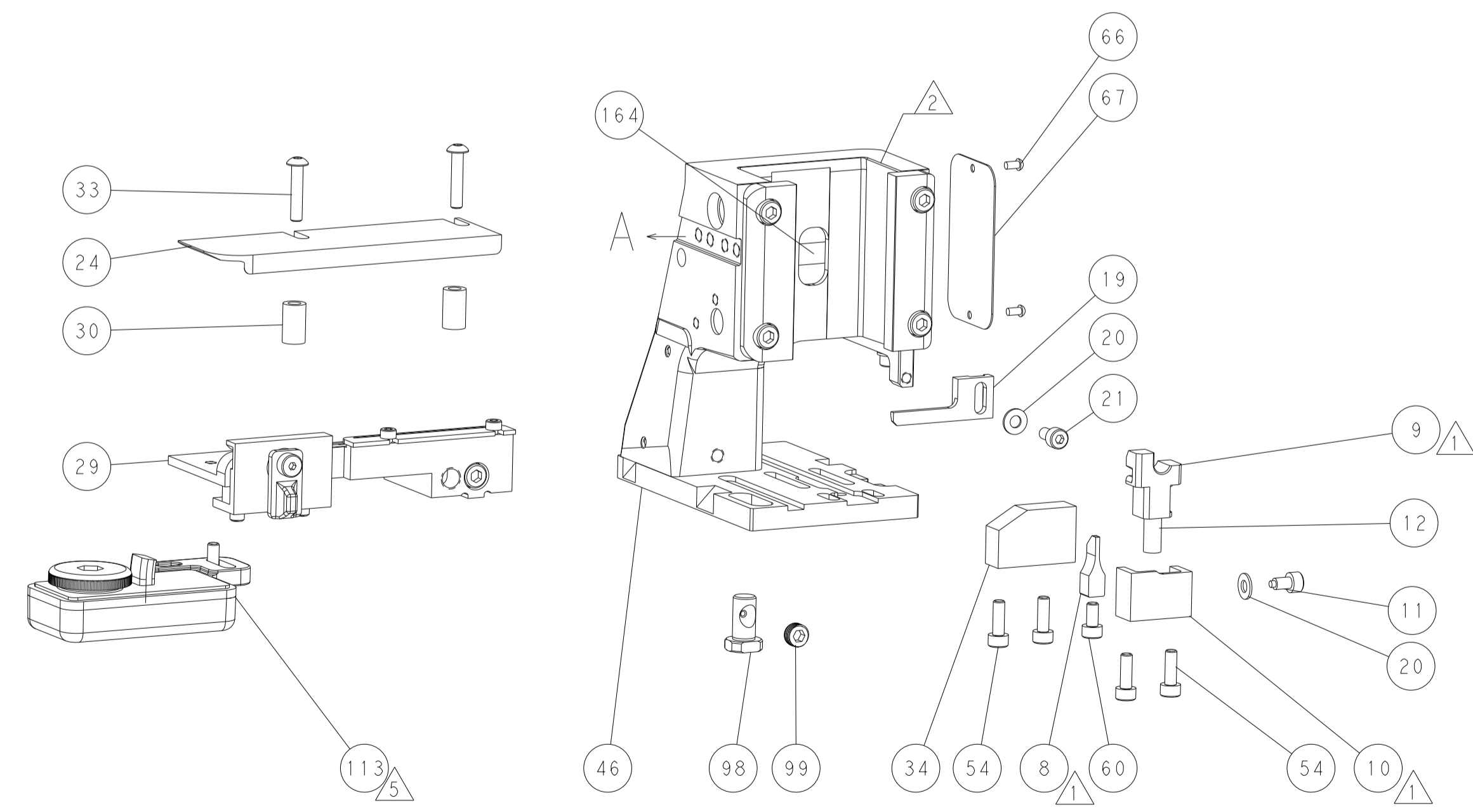
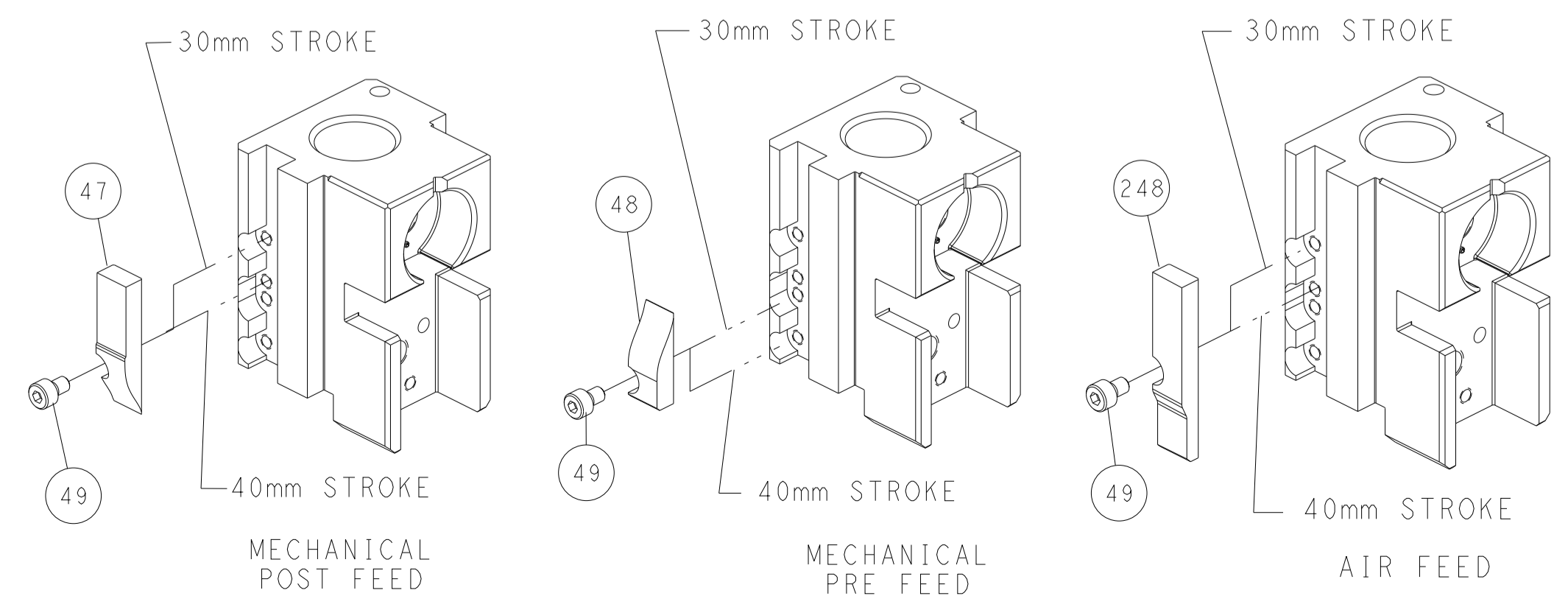


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

CAM POSITIONS



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 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN B. WEAVER 14MAY2015 CHK G. BAILEY 14MAY2015 APVD G. BAILEY 14MAY2015	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 APPLICATION SPEC: - PRODUCT SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266777 SCALE: 1:2 SHEET: 2 OF 4 REV: F
MATERIAL: -		Customer Accessible Production Drawing	

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COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266777-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266777-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266777-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SOCKET CONTACT, PLUG, SMB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
TERMINAL APPLICATION SPECIFICATION	114-13157	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1438896-2	2203232-2	1438890-7	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-58 LL or RG-58	0.86 +/- 0.05 [.034 +/- .002]	4.0

- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - SEE TERMINAL APPLICATION SPEC 114-13157 FOR WIRE STRIP LENGTH.
 - 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 LUBRICANT IS RECOMMENDED.
6. 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.

FOR LEADMAKER APPLICATIONS

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

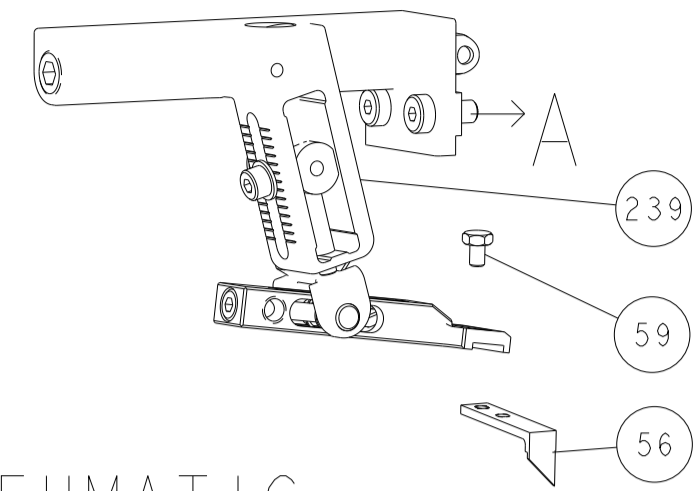
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	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	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	7-1752356-2	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	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	3-22280-3	SPRING, COMPRESSION	12
-	1	1	356885-5	STOP, SHEAR	11
-	1	1	1803747-1	HOLDER, SHEAR	10
-	1	1	1803251-1	SHEAR, FLOATING	9
-	1	1	4-1633933-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1803419-5	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
-	1	1	4-456403-6	CRIMPER, WIRE PREMIUM	1

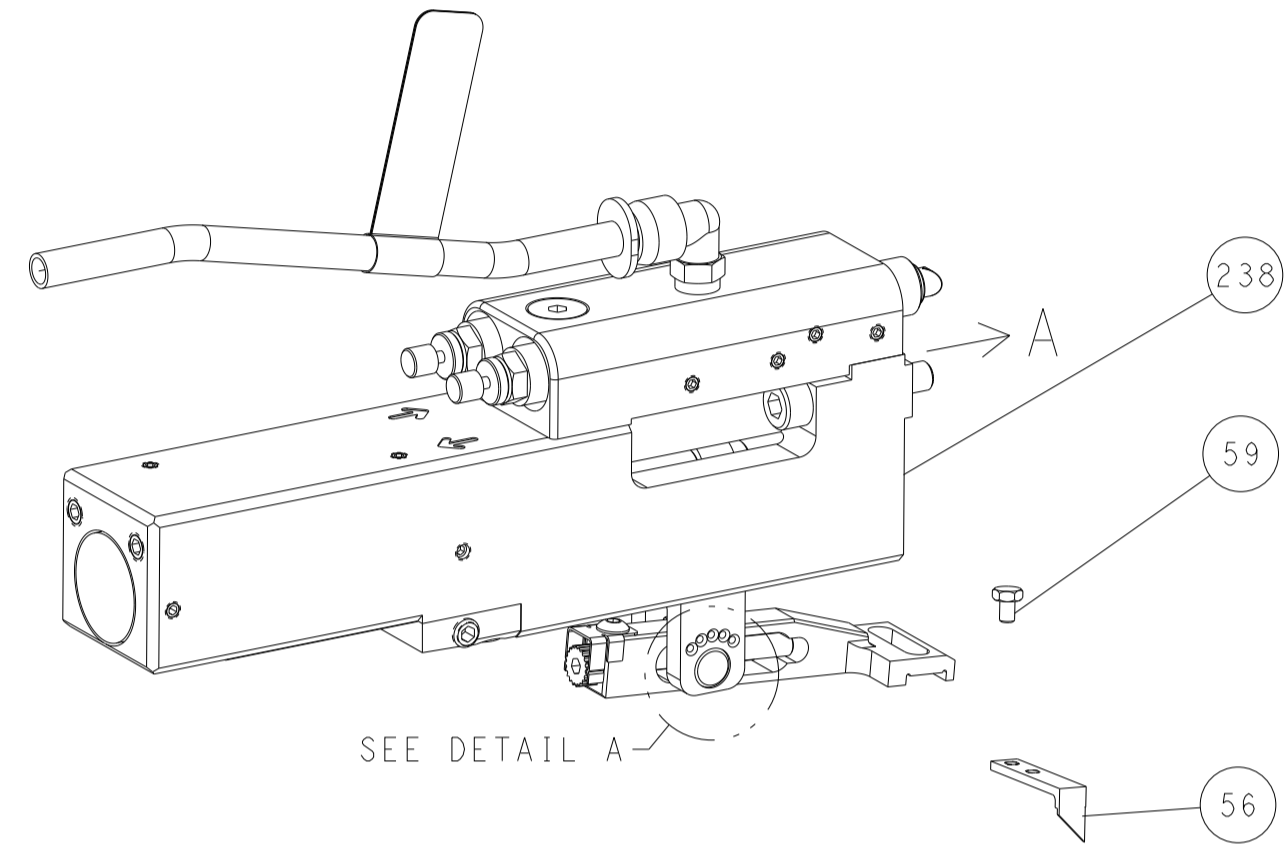
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2		SHEET 3 OF 4		REV F	

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

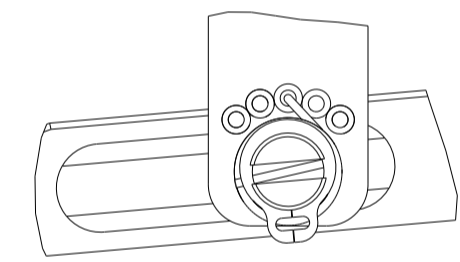
FEED TYPE MECHANICAL



PNEUMATIC

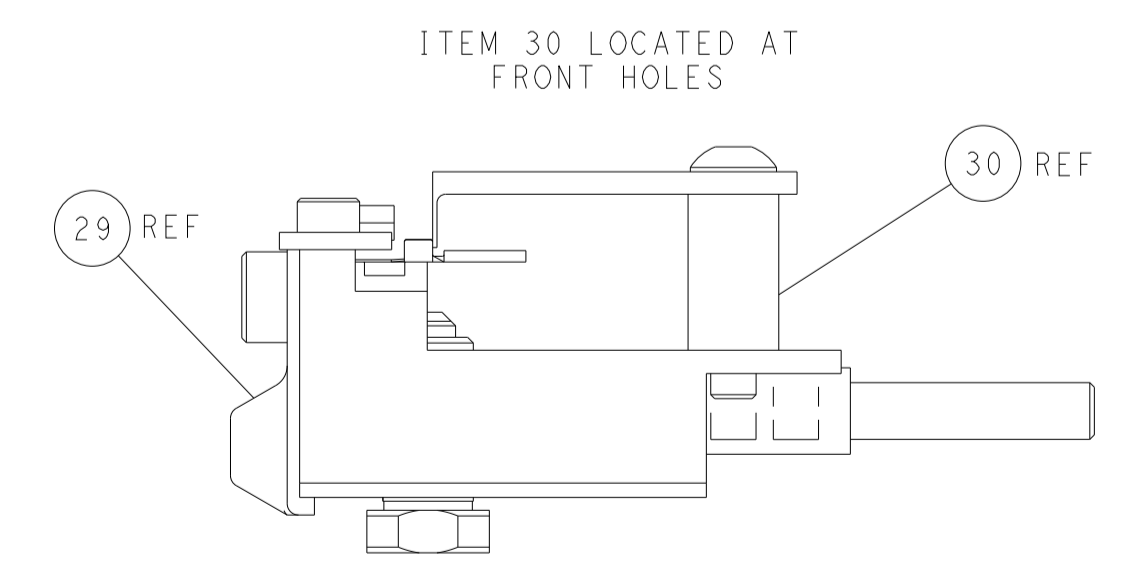
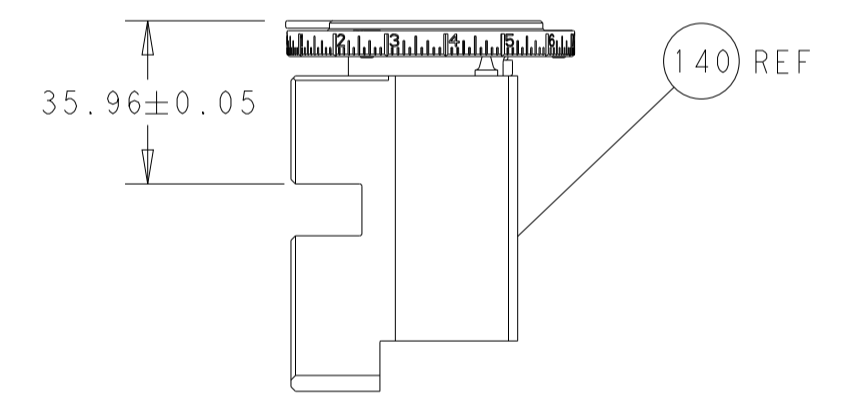
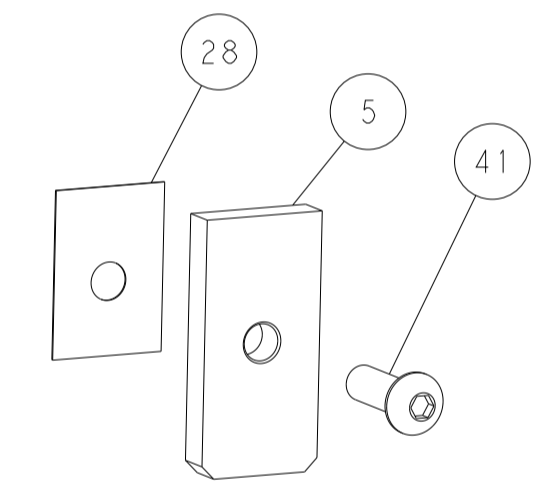
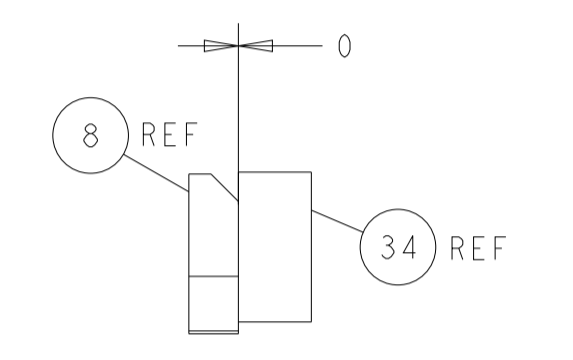
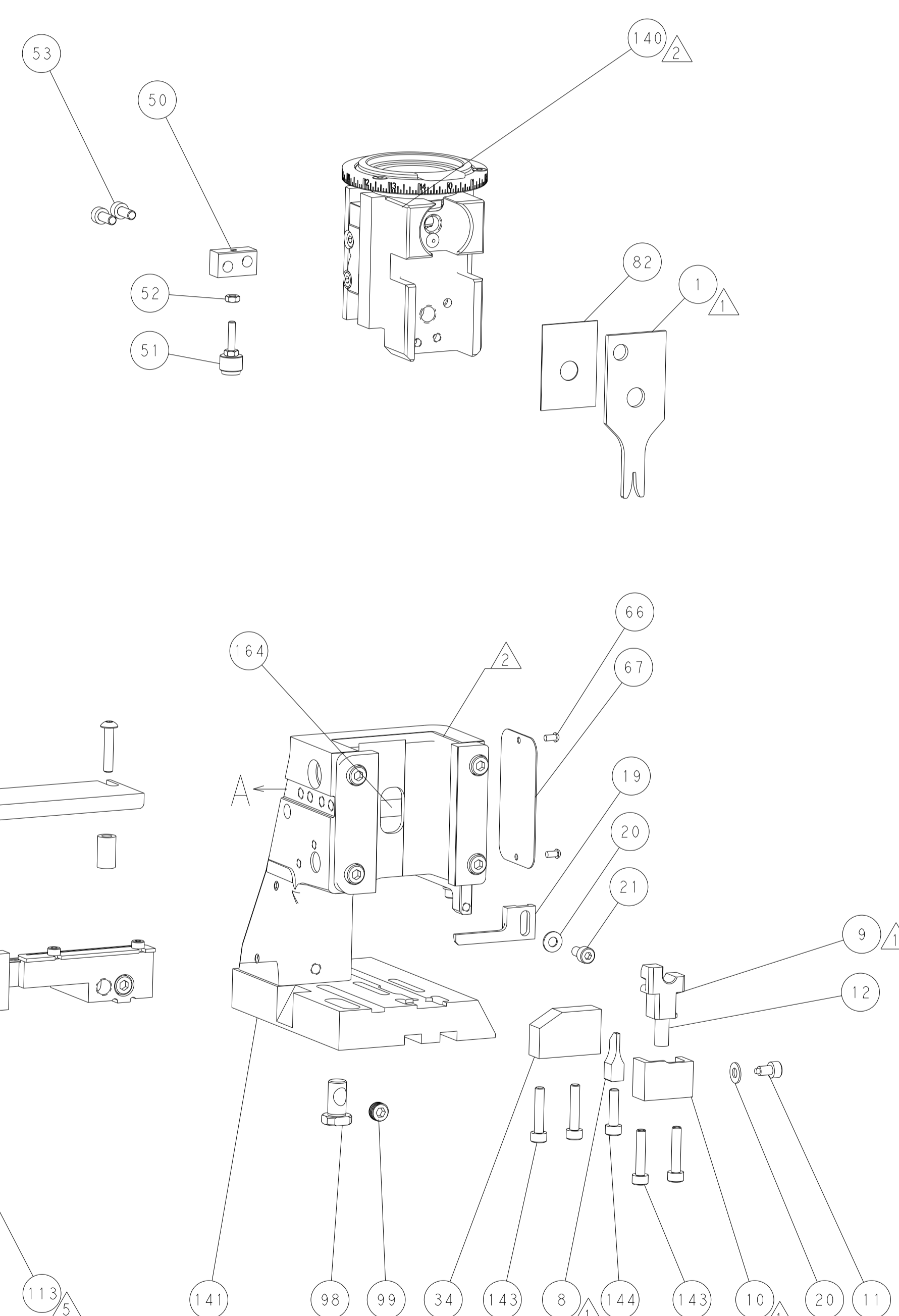
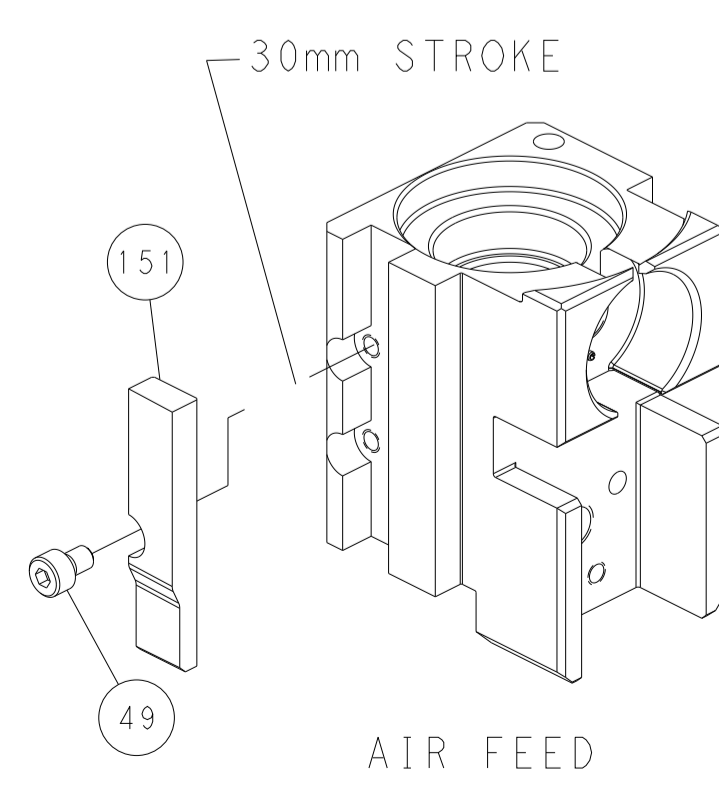
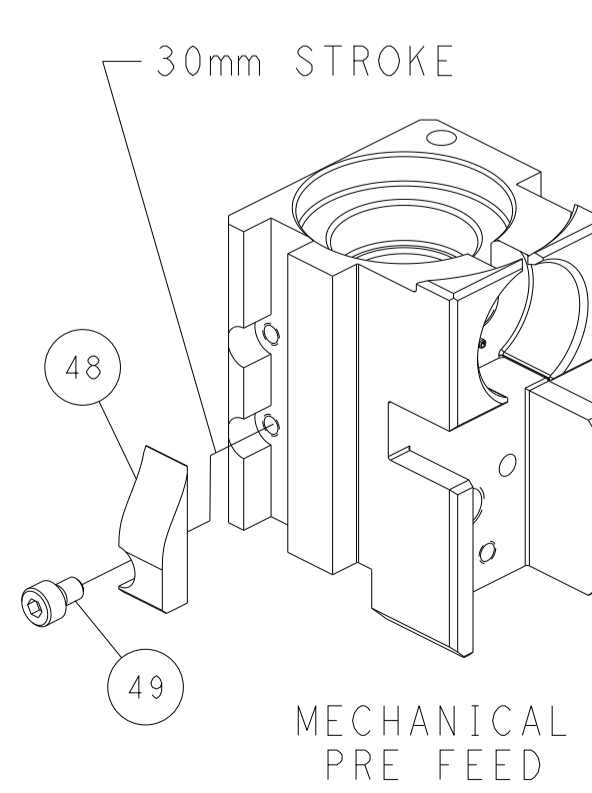
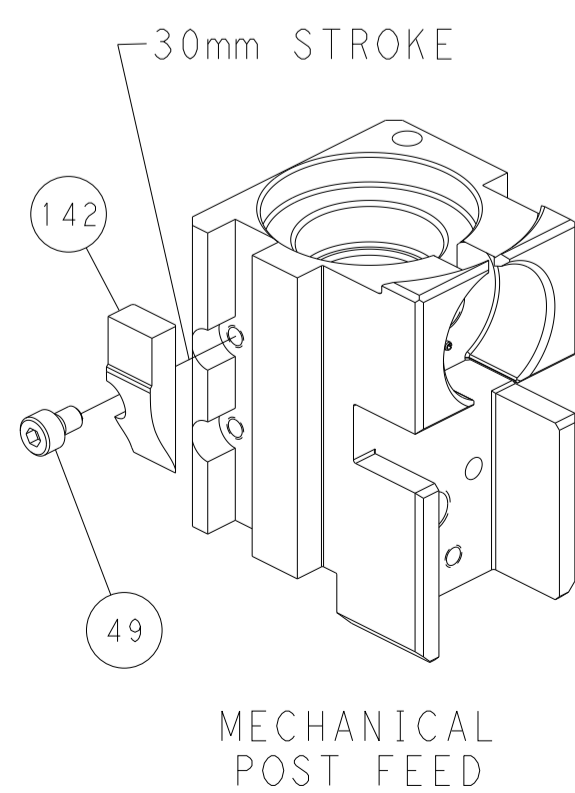


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS



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	APPLICATION SPEC -	WEIGHT -	SCALE 1:2 SHEET 4 OF 4 REV F	CUSTOMER ACCESSIBLE PRODUCTION DRAWING