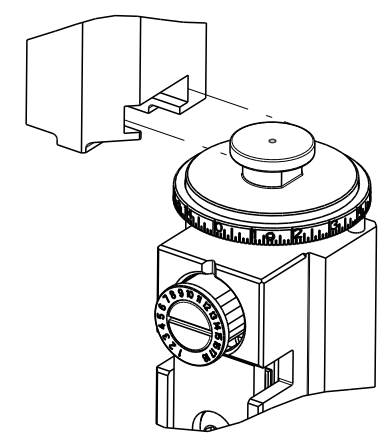


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266943-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266943-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266943-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

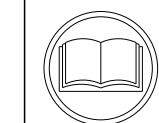


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: LUMBERG TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, CRIMP CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
2.99-3.75 mm [.118-.148 IN]	∅ 1.50 mm MAX [.059 IN MAX]		
TERMINAL APPLICATION SPECIFICATION	TERMINAL		
NONE	-		
TERMINALS APPLIED			
TE TERMINAL	LUMBERG TERMINAL	TE TERMINAL	LUMBERG TERMINAL
1949081-1	3111 01 G		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.25mm ²	0.84 +/- 0.05 [.033 +/- .002]	5.2
24 AWG OR 0.22mm ²	0.81 +/- 0.05 [.032 +/- .002]	5.6
26 AWG OR 0.14mm ²	0.76 +/- 0.05 [.030 +/- .002]	6.2



- 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.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 INSULATION RANGE DOES NOT MATCH LUMBERG SPECIFICATION. WAS REDUCED DUE TO TERMINAL CONFIGURATION.

***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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	1		ORIGINAL	06AUG2015	GH	TE
		A		RELEASED	22SEP2015	GH	GB
		B		ECR-22-161453	15DEC2022	LG	RK

-	1	1	1803945-6	TONKER	300		
-	1	1	22278-9	SPRING, COMPRESSION	299		
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298		
-	1	1	1803944-1	SPACER, TONKER	297		
-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2119082-5	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		
-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239		
-	1	1	2844940-1	AIR FEED MODULE	238		
-	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	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		
-	2	2	2119791-6	DEPRESSOR, WIRE	70		
-	1	1	2119943-1	WASHER, SPACER	69		
-	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	1338685-1	PAWL, FEED	56		
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54		
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53		
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	-	-	2119652-1	FEED CAM, PRE FEED	48		
-	-	-	2119653-1	FEED CAM, POST FEED	47		
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46		
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44		
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41		
-	1	1	2-1752356-4	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	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	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	1803095-6	FLOATING SHEAR, FRONT	9		
-	1	2	1	5-1803057-5	ANVIL, COMBINATION	8	
-	1	1	3-240641-4	SPACER	7		
-	-	-	-	-	6		
-	1	1	2119757-8	DEPRESSOR, SHEAR	5		
-	1	1	1-238011-3	BLOCK, CRIMPER SPACER	4		
-	1	2	1	1633962-9	CRIMPER, INSULATION F PREMIUM	3	
-	-	-	-	-	2		
-	1	2	1	8-1633730-8	CRIMPER, WIRE	1	
-	77-72	-2		PART NO			ITEM NO
-				DESCRIPTION			

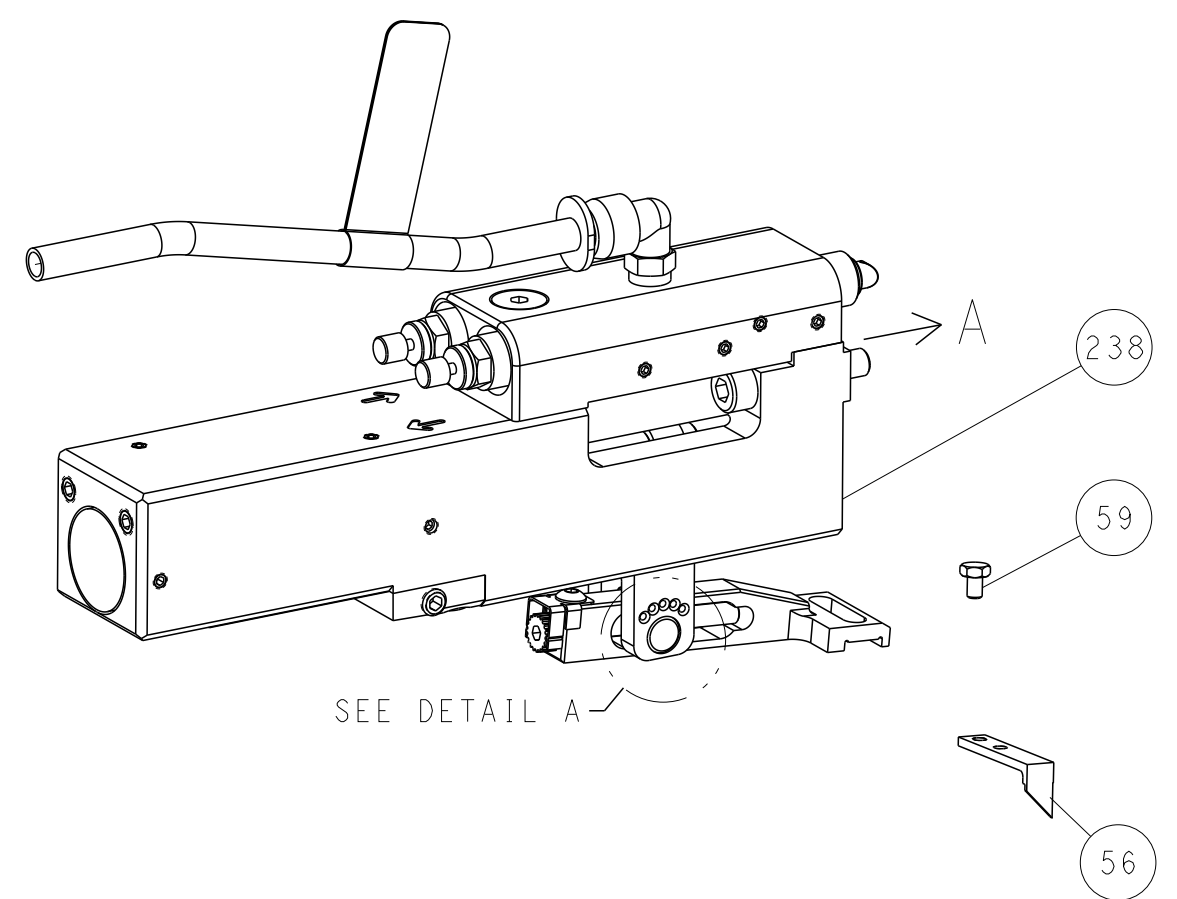
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

OWN	HOFFNER	6AUG2015	TE Connectivity
CHK	T. ELBIN	7AUG2015	Harrisburg, PA 17105-3608
APVD	T. ELBIN	7AUG2015	
NAME	Ocean Side Feed Applicator		
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266943	
Customer Accessible Production Drawing		SCALE	1:2
		SHEET	1 of 4
		REV	B

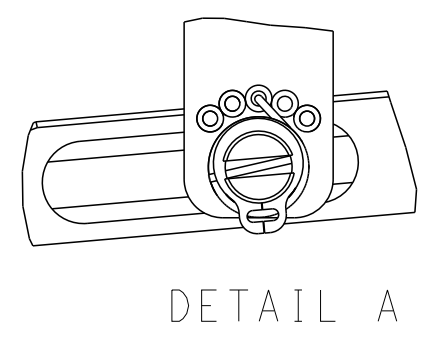
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

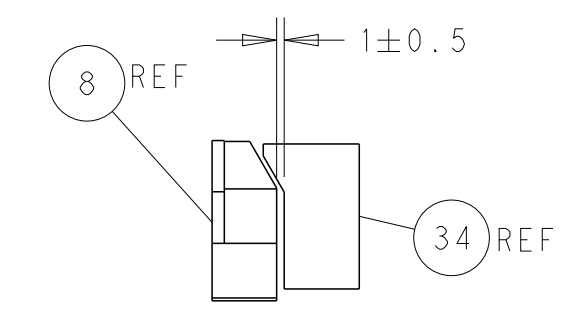
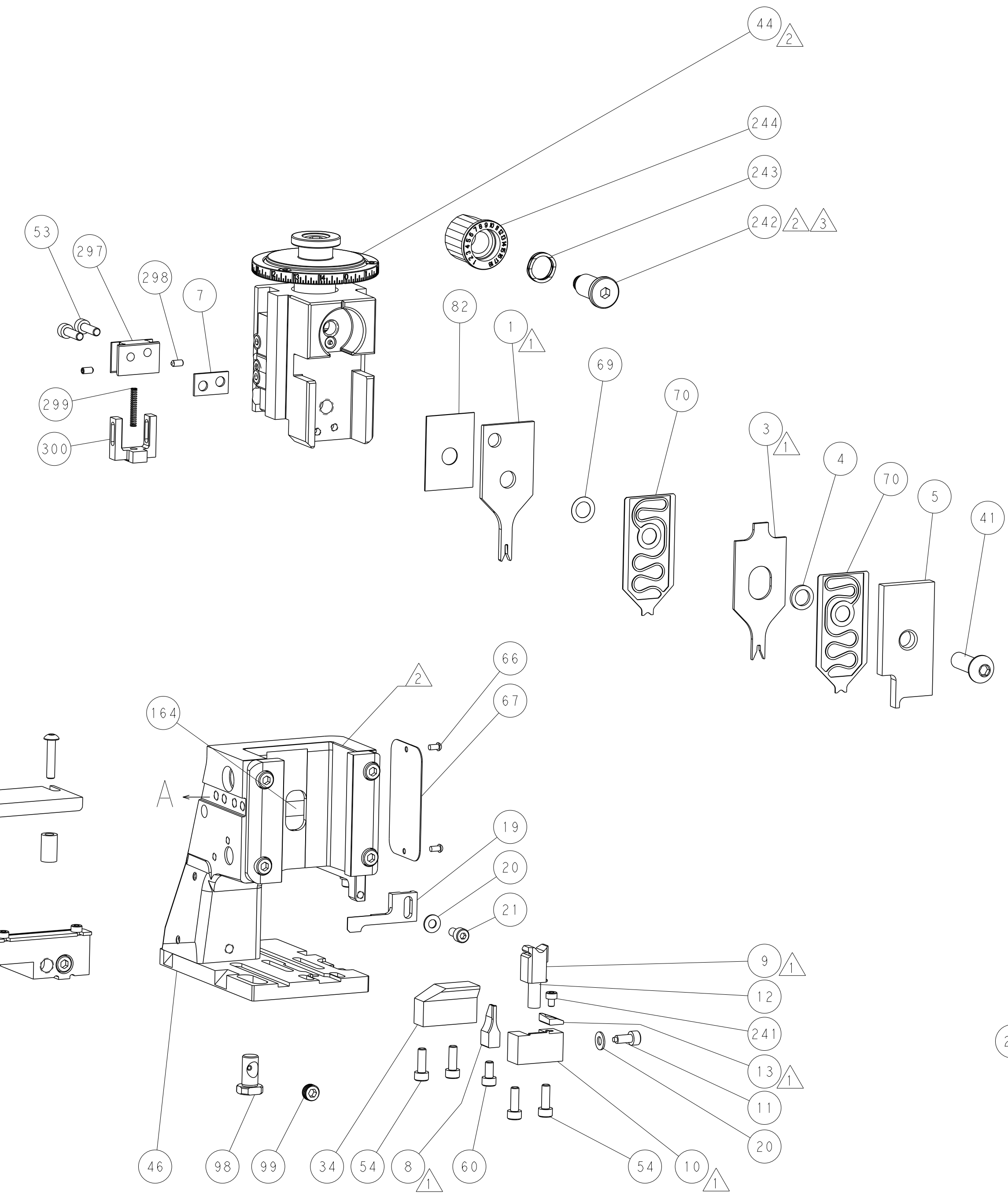
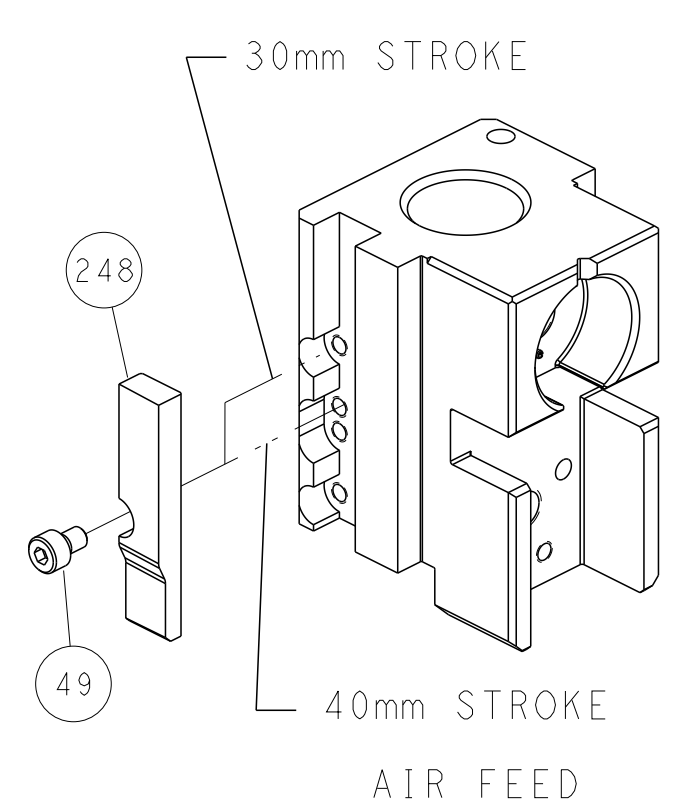
PNEUMATIC



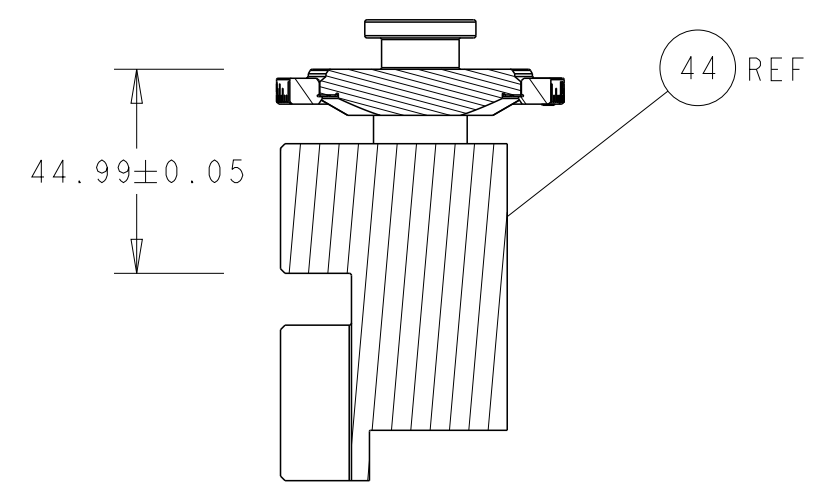
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



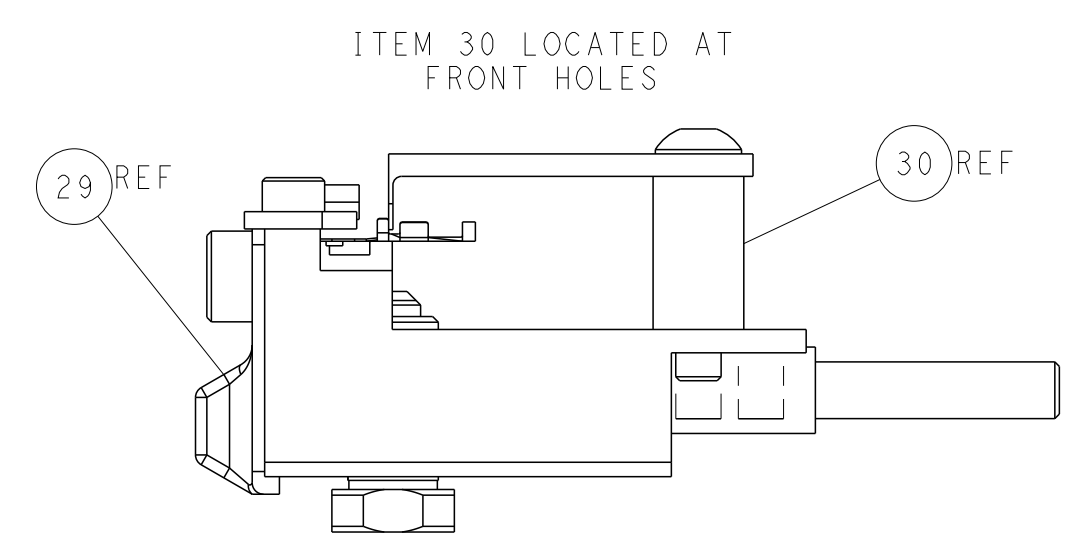
CAM POSITION



TERMINAL SUPPORT LOCATION



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN: HOFFNER 6AUG2015 CHK: T. ELBIN 7AUG2015 APVD: T. ELBIN 7AUG2015 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266943 SHEET 2 OF 4 REV B	
MATERIAL: - FINISH: -				RESTRICTED TO: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266943-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266943-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: LUMBERG TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, CRIMP CONTACT			
WIRE STRIP LENGTH 2.99-3.75 mm [.118-.148 IN]	INSULATION DIAMETER RANGE Ø 1.50 mm MAX [.059 IN MAX]		
TERMINAL APPLICATION SPECIFICATION NONE			
TERMINALS APPLIED			
TE TERMINAL 1949081-1	LUMBERG TERMINAL 3111 01 G	TE TERMINAL	LUMBERG TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.25mm ²	0.84 +/- 0.05 [.033 +/- .002]	5.2
24 AWG OR 0.22mm ²	0.81 +/- 0.05 [.032 +/- .002]	5.6
26 AWG OR 0.14mm ²	0.76 +/- 0.05 [.030 +/- .002]	6.2



- 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.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 INSULATION RANGE DOES NOT MATCH LUMBERG SPECIFICATION. WAS REDUCED DUE TO TERMINAL CONFIGURATION.

***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)

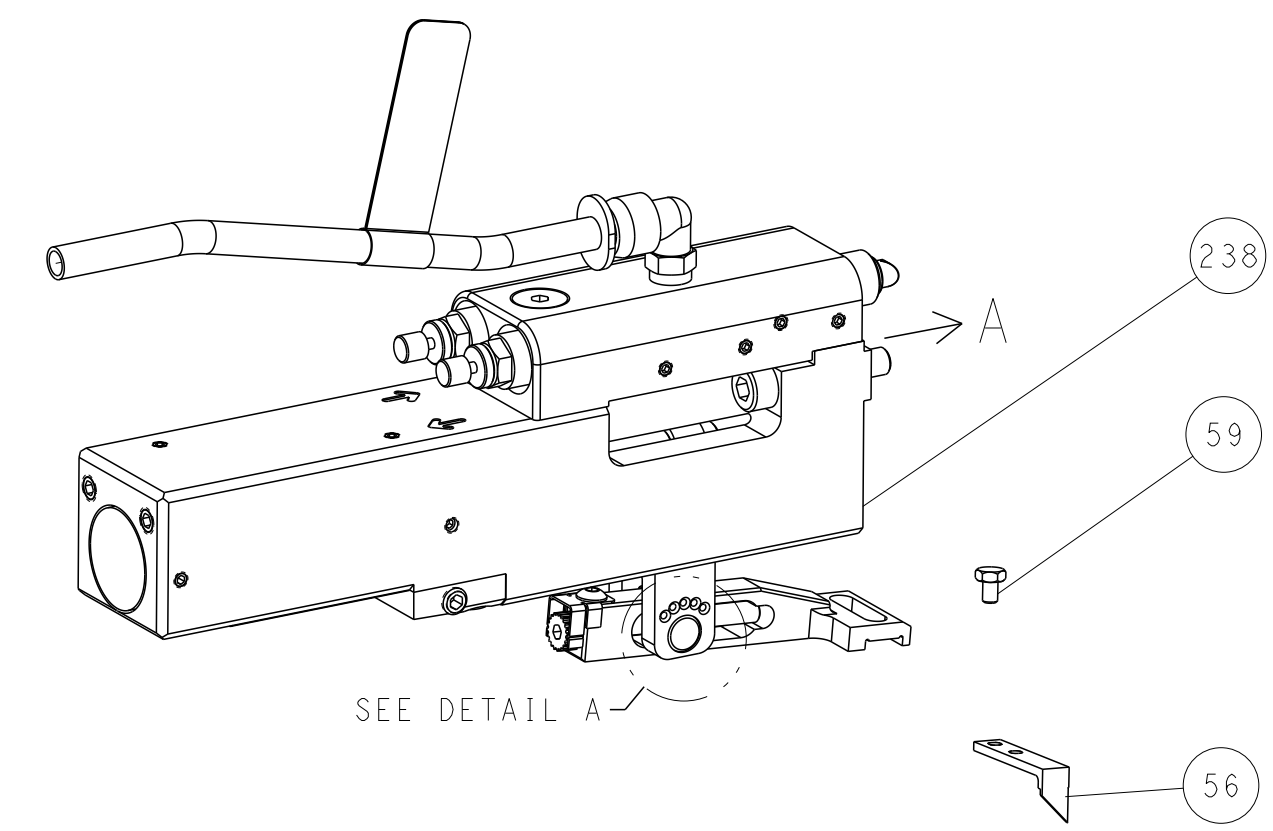
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

-	1	1803945-6	TONKER	300
-	1	22278-9	SPRING, COMPRESSION	299
-	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1803944-1	SPACER, TONKER	297
-	1	2119082-5	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
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	2844940-1	AIR FEED MODULE	238
-	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
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	2119653-2	FEED CAM, POST FEED	142
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	2	2119791-6	DEPRESSOR, WIRE	70
-	1	2119943-1	WASHER, SPACER	69
-	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	1338685-1	PAWL, FEED	56
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	2119652-1	FEED CAM, PRE FEED	48
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	2-1752356-4	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1320928-2	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-4	STRIPPER, SIDE FEED	19
-	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	5-1803057-5	ANVIL, COMBINATION	8
-	1	3-240641-4	SPACER	7
-	-	-	-	6
-	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1-238011-3	BLOCK, CRIMPER SPACER	4
-	1	1633962-9	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	2
-	1	8-1633730-8	CRIMPER, WIRE	1

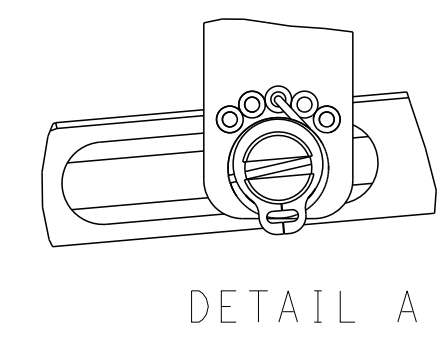
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0 PLC ±		1 PLC ±		CHE: T. ELBIN 7AUG2015		NAME: Ocean Side Feed Applicator	
2 PLC ±		3 PLC ±		APVD: T. ELBIN 7AUG2015		SIZE: A1	
4 PLC ±		ANGLES ±		PRODUCT SPEC		CAGE CODE: 00779	
MATERIAL		FINISH		APPLICATION SPEC		DRAWING NO: 2266943	
				WEIGHT		RESTRICTED TO: Customer Accessible Production Drawing	
				SCALE: 1:2		SHEET 3 OF 4 REV B	

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

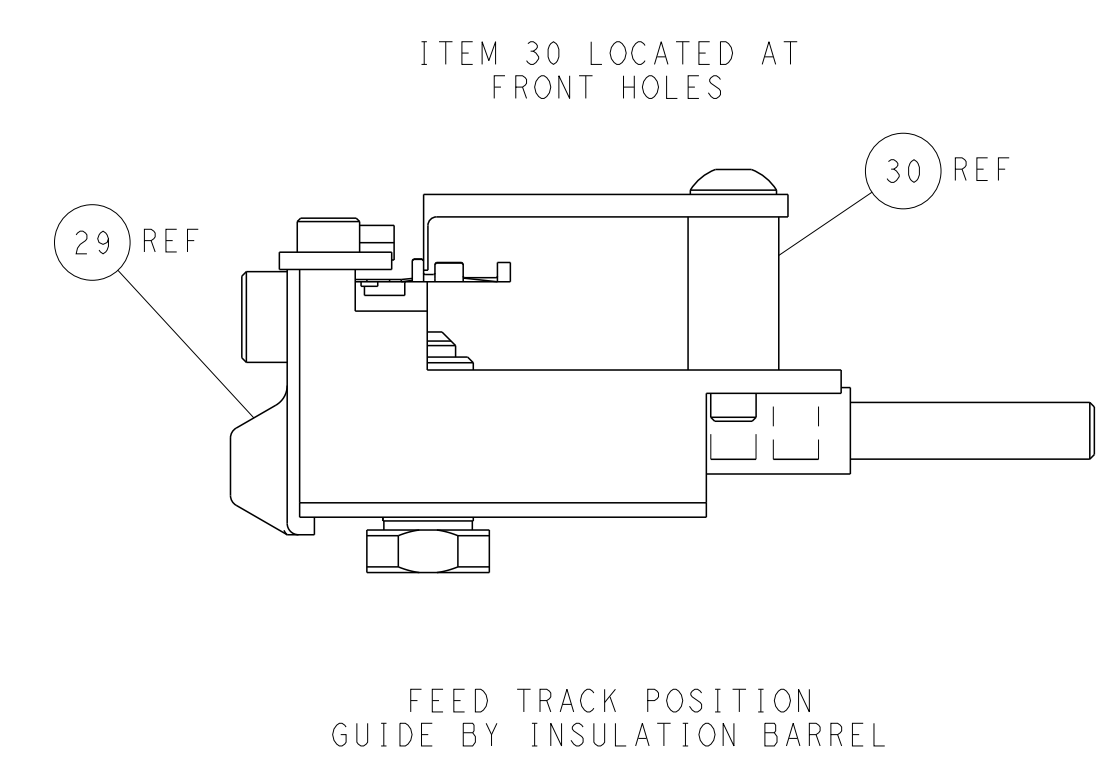
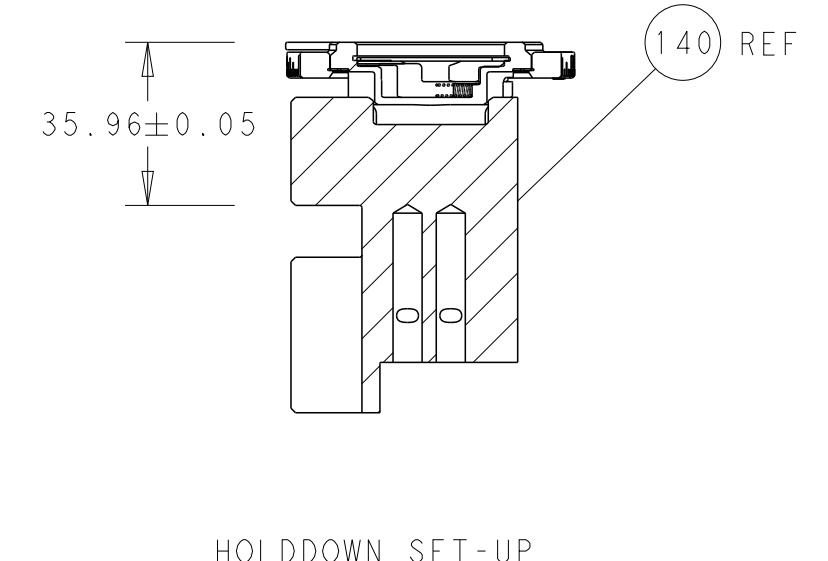
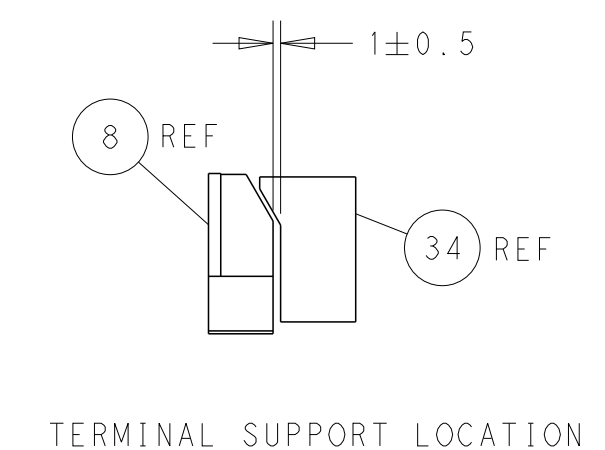
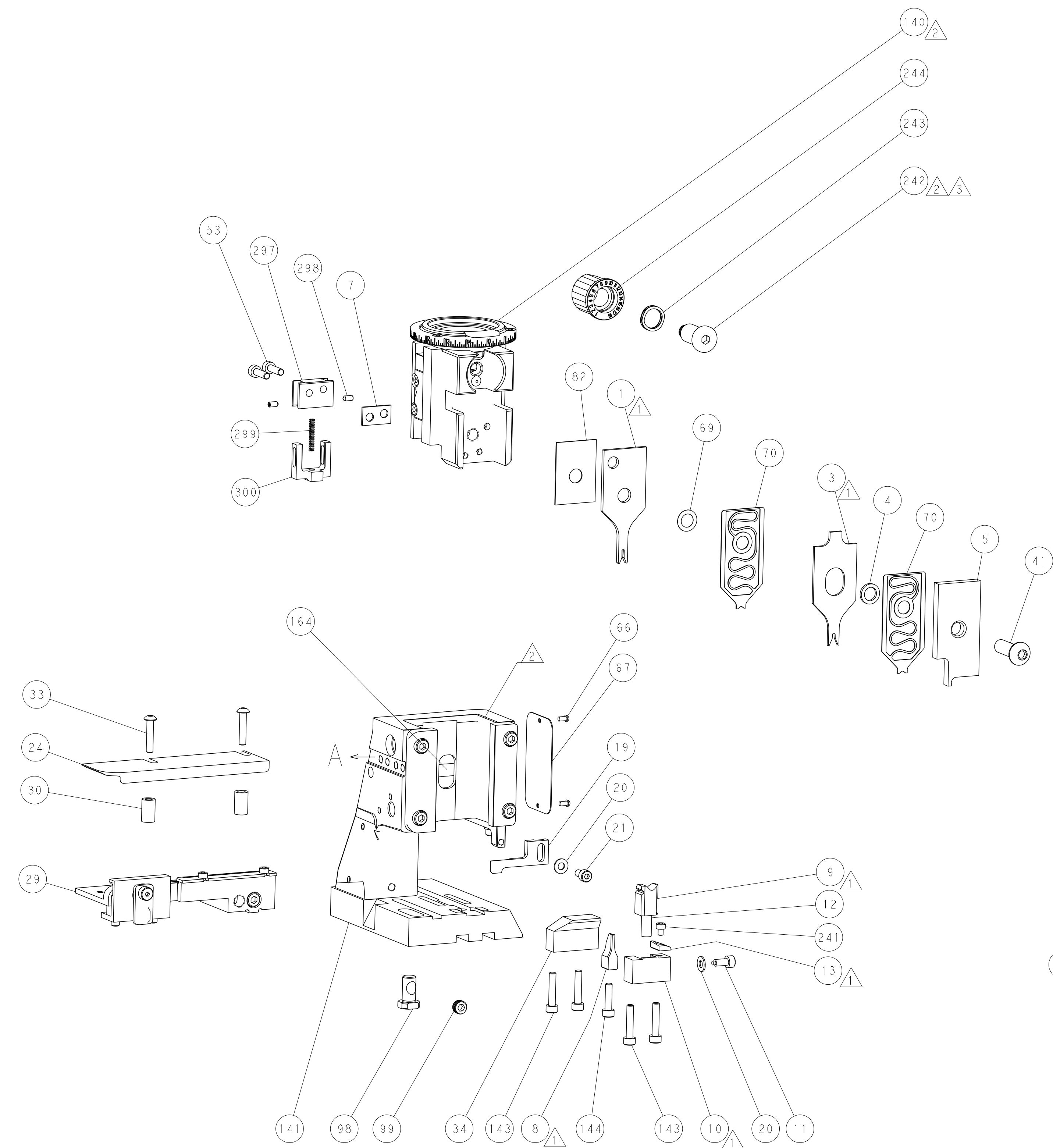
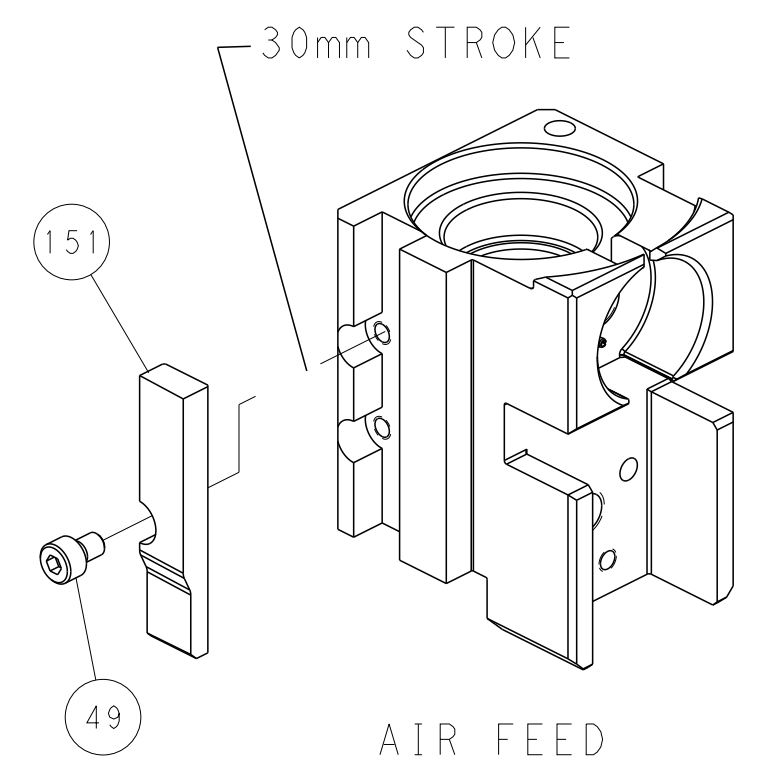
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED BY THE DRAWING. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED.</small>		DWN: HOFFNER 6AUG2015 CHK: T. ELBIN 7AUG2015 APVD: T. ELBIN 7AUG2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266943 SHEET 4 OF 4 REV B