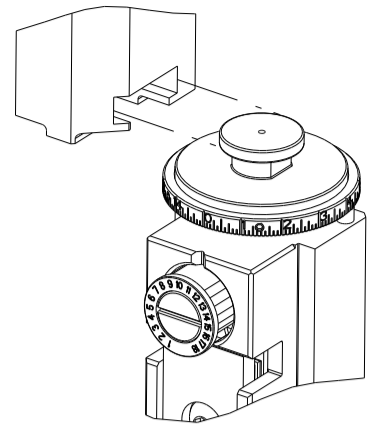


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266645-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266645-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266645-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.01 mm [.158]	F
INSUL	4.91 mm [.193]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 8MM NG1 PLUS/8MM MAXI FUSE PLUS			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
6.60-7.40 mm [.260-.291 IN]		Ø2.80-4.00 mm [.110-.157 IN]	
TERMINAL APPLICATION SPECIFICATION	114-15105		
	114-94591		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544964-1	1544964-2	1801431-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	2.45 +/- 0.05 [.096 +/- .002]	5.8
4.00mm2	2.25 +/- 0.05 [.089 +/- .002]	8.0
3.00mm2	2.15 +/- 0.05 [.085 +/- .002]	9.2
2.50mm2	2.10 +/- 0.05 [.083 +/- .002]	9.4

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	04APR2018	RK	TE
		B		ECR-19-005110	29MAR2019	TB	CT
		C		ECR-19-010597	06JUL2019	TB	TE
		CI		ECR-23-163058	09JAN2023	FZ	GWB

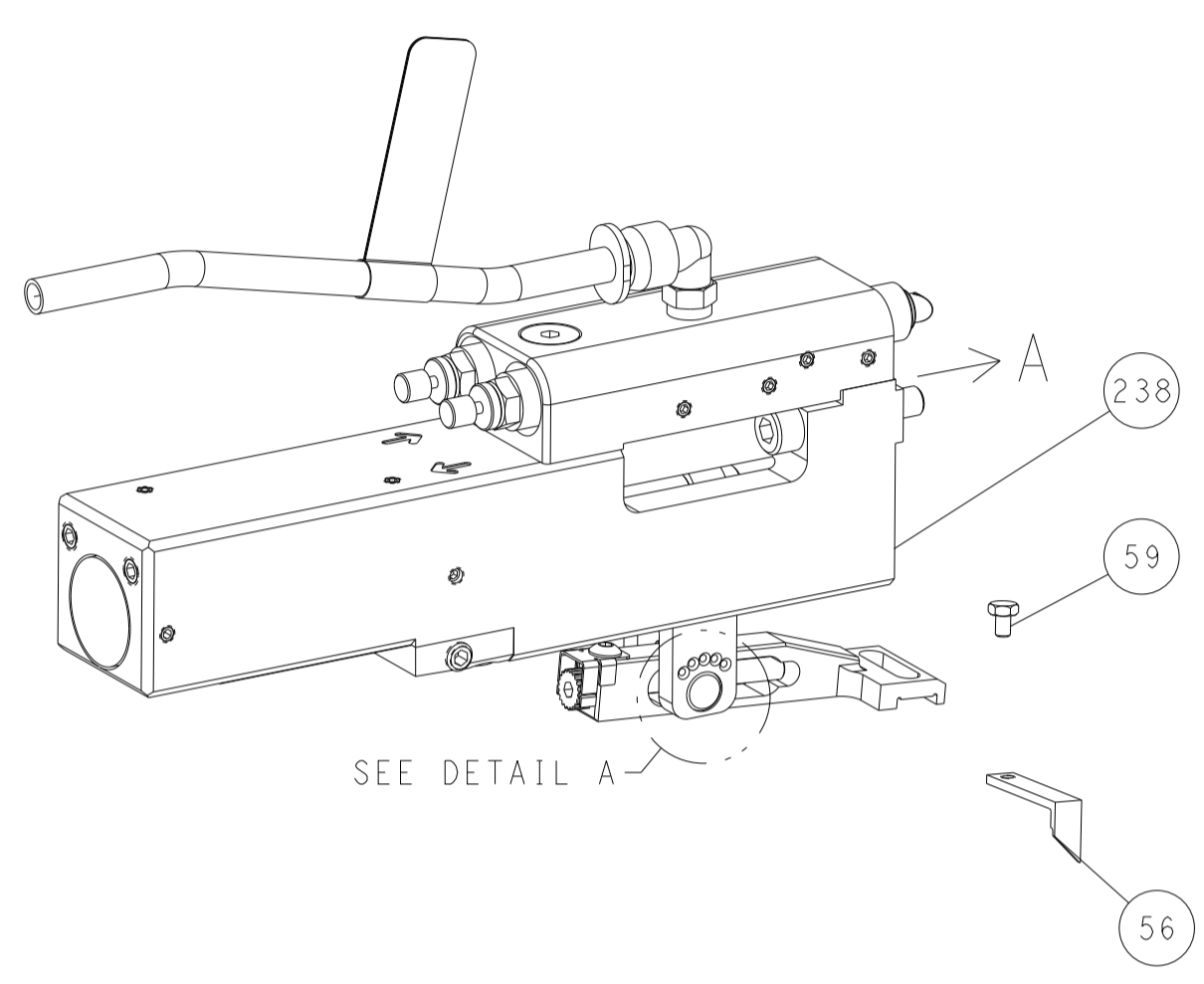
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1633782-4	FENCE	267
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	455888-6	SPACER, CRIMPER	120
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-4	SPACER, CRIMPER	82
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	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	1338683-8	FEED PAWL	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1320928-6	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	1803512-2	ANVIL, COMBINATION	8
-	1	1	1-240641-4	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	1803702-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1-455888-2	SPACER, CRIMPER	2
-	1	2	1-1803212-9	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	
-				DESCRIPTION	ITEM NO

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

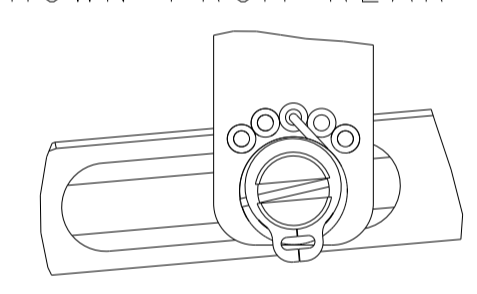
<small>THIS DRAWING IS A CONTROLLED DOCUMENT. ANY REVISIONS TO THIS DRAWING MUST BE APPROVED BY THE ORIGINAL DESIGNER AND THE APPLICATOR. ANY UNAUTHORIZED REVISIONS TO THIS DRAWING SHALL BE CONSIDERED AS UNAUTHORIZED AND THE USER SHALL BE RESPONSIBLE FOR THE LATEST REVISION.</small>		DWN: R. KNEPPER 20-FEB-18 CHK: T. BROOKENS 20-FEB-18 APVD: J. DEGRANGE 20-FEB-18	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266645 RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 1 of 4 REV: C1

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

FEED TYPE PNEUMATIC

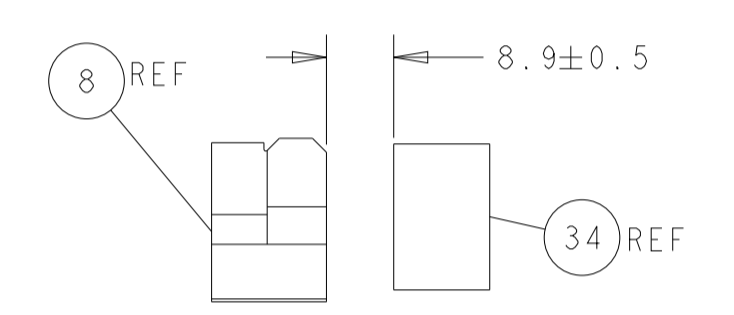
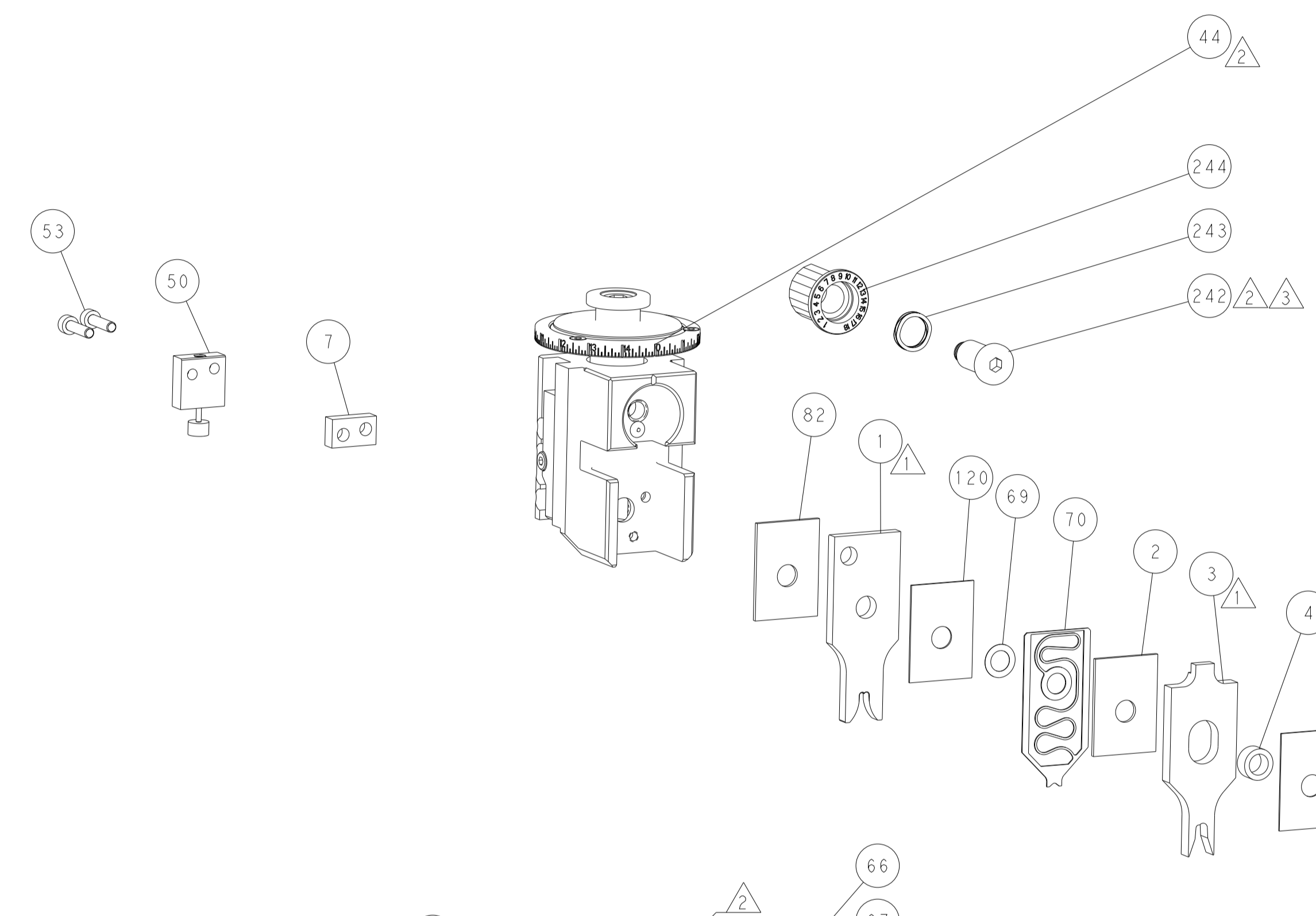
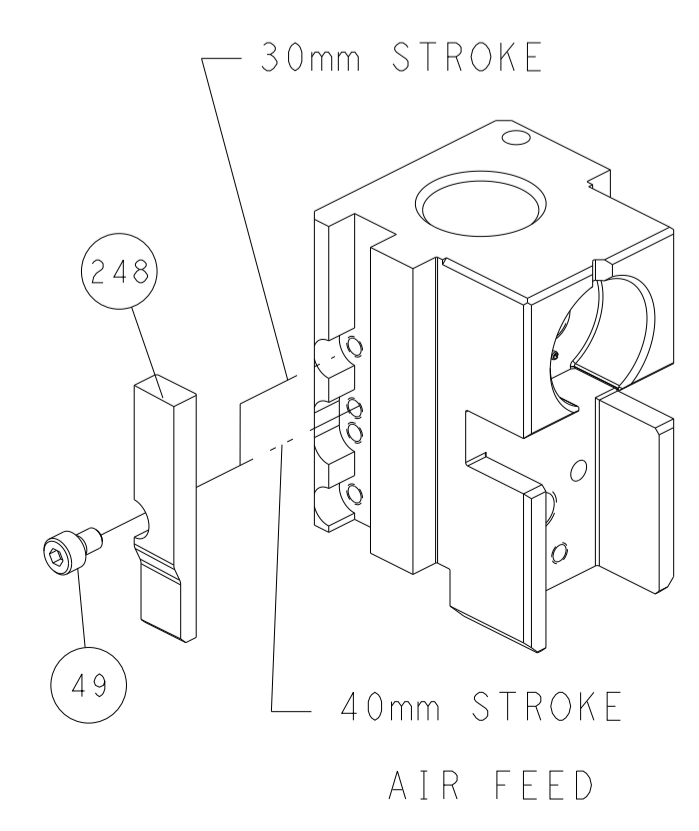


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

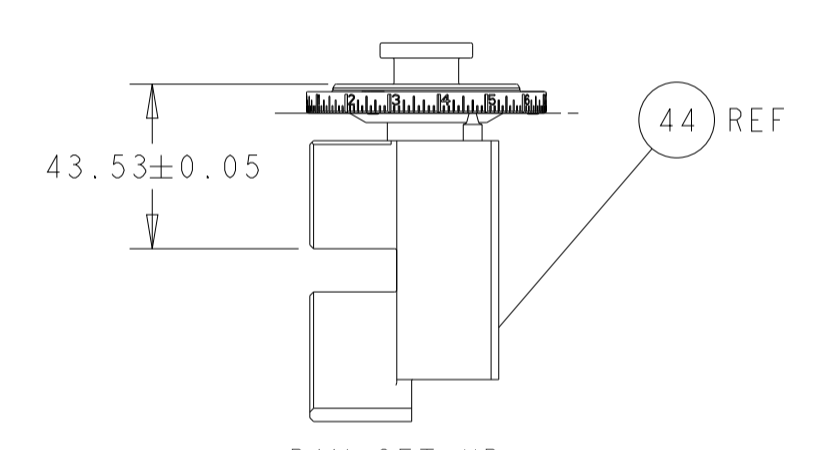


DETAIL A

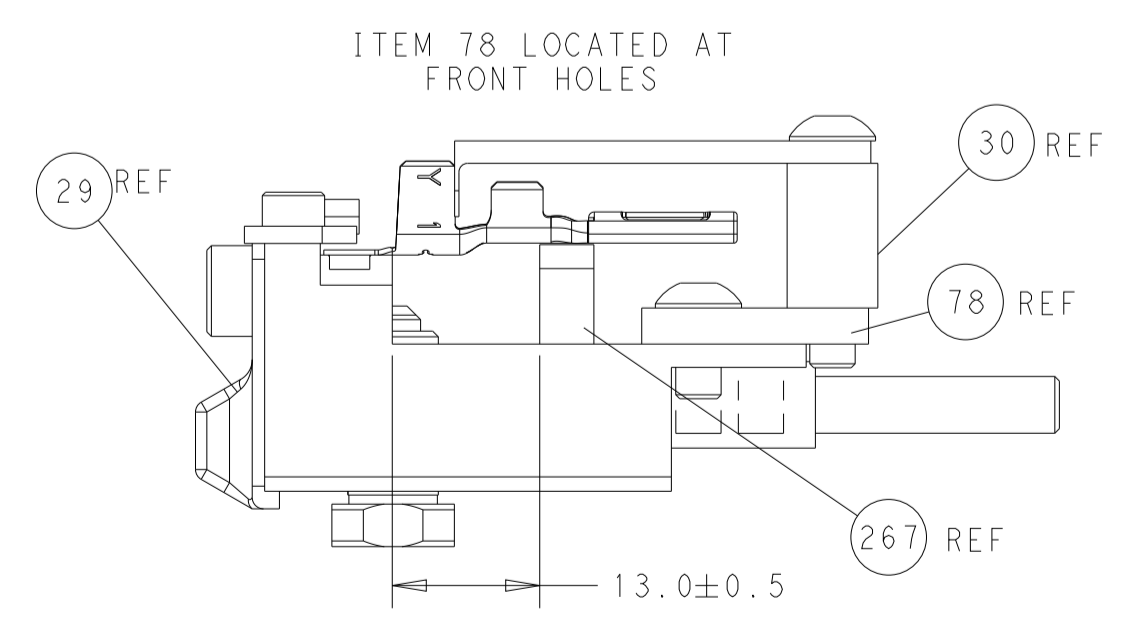
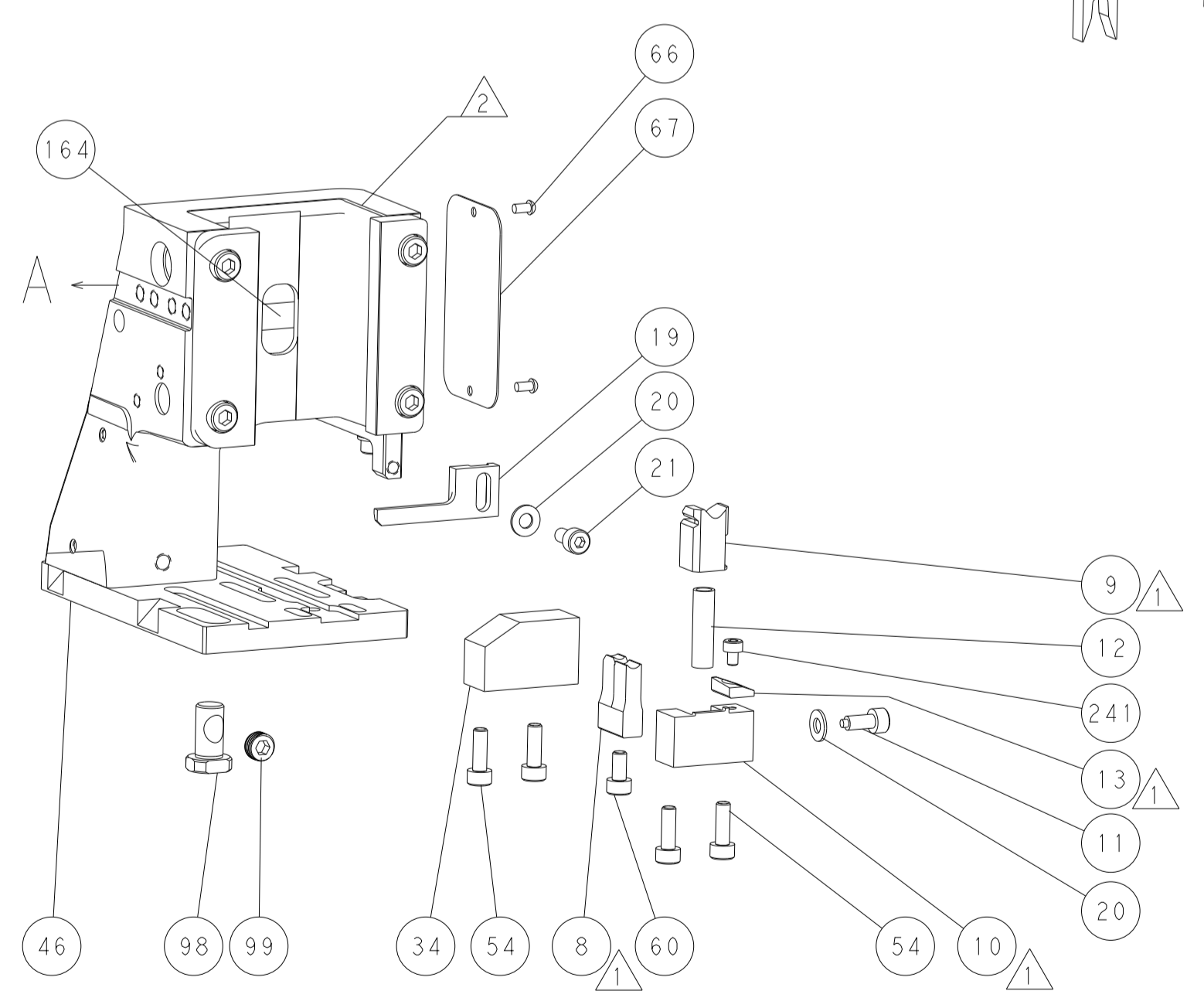
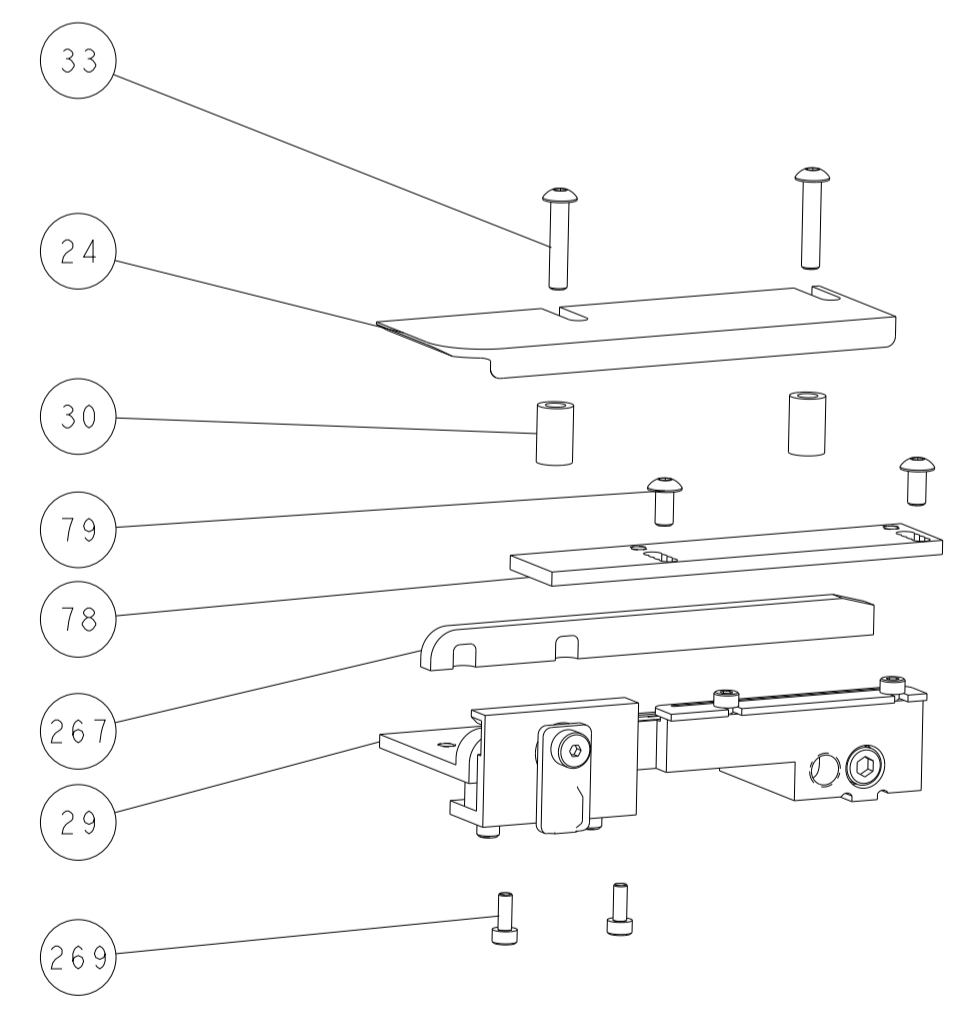
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM 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)

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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: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266645	RESTRICTED TO: SCALE: 1:2 SHEET: 2 OF 4 REV: C1
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2266645-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2266645-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.01 mm [.158]	F
INSUL	4.91 mm [.193]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 8MM NG1 PLUS/8MM MAXI FUSE PLUS			
WIRE STRIP LENGTH 6.60-7.40 mm [1.260-.291 IN]		TERMINAL INSULATION DIAMETER RANGE Ø2.80-4.00 mm [1.110-.157 IN]	
TERMINAL APPLICATION SPECIFICATION	114-15105	-	-
TERMINAL APPLICATION SPECIFICATION	114-94591	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544964-1	1544964-2	1801431-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	2.45+/-0.05 [1.096+/-0.002]	5.8
4.00mm2	2.25+/-0.05 [1.089+/-0.002]	8.0
3.00mm2	2.15+/-0.05 [1.085+/-0.002]	9.2
2.50mm2	2.10+/-0.05 [1.083+/-0.002]	9.4

***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.

- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
 - 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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

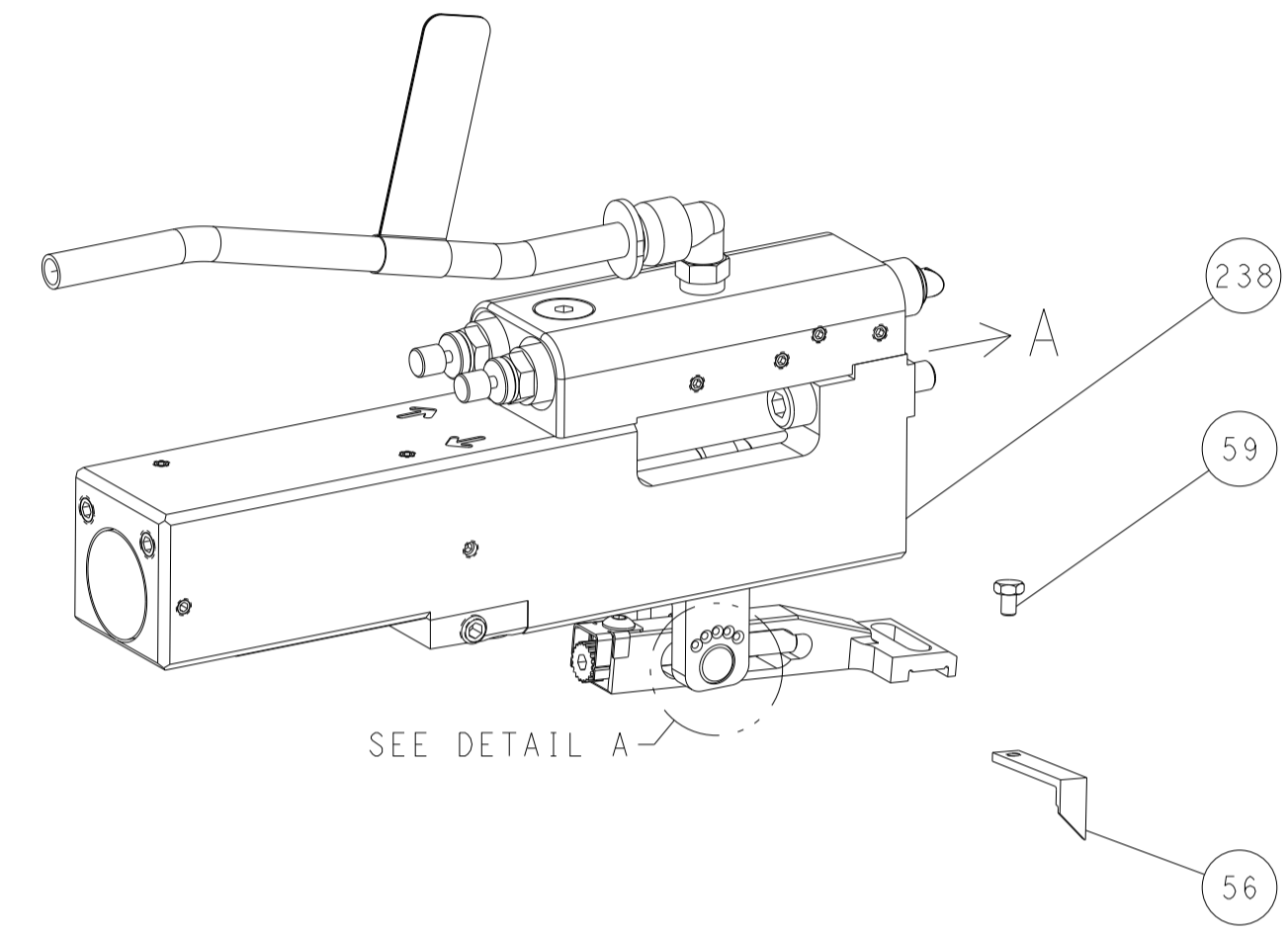
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1633782-4	FENCE	267	
-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	2844940-1	AIR FEED MODULE	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	
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140	
-	1	455888-6	SPACER, CRIMPER	120	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	1-455888-4	SPACER, CRIMPER	82	
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1803096-1	EXTENSION PLATE	78	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	2119791-5	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	1338683-8	FEED PAWL	56	
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	1	1803382-6	HOLD DOWN, SPRING LOADED	50	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1752356-3	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-5	SPACER, CRIMPER	28	
-	1	1320928-6	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	2119533-1	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	1803512-2	ANVIL, COMBINATION	8	
-	1	1-240641-4	SPACER	7	
-	-	-	-	6	
-	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	4-238011-4	BLOCK, CRIMPER SPACER	4	
-	1	1803702-1	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1-455888-2	SPACER, CRIMPER	2	
-	1	1-1803212-9	CRIMPER, WIRE PREMIUM	1	
-	77	-22	PART NO	DESCRIPTION	ITEM NO

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

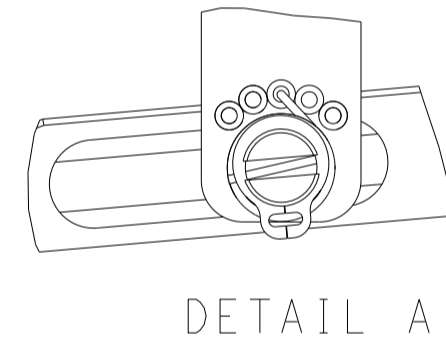
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R. KNEPPER 20-FEB-18		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±		CHK: T. BROOKENS 20-FEB-18		NAME: Ocean Side Feed Applicator	
APVD: J. DEGRANGE 20-FEB-18		1 PLC ±		PRODUCT SPEC		SIZE: A1	
APPLICATION SPEC		2 PLC ±		WEIGHT		CAGE CODE: 00779	
MATERIAL		3 PLC ±		SCALE: 1:2		DRAWING NO: 2266645	
FINISH		4 PLC ±		SHEET: 3 OF 4		REV: C1	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		ANGLES		RESTRICTED TO		Customer Accessible Production Drawing	

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

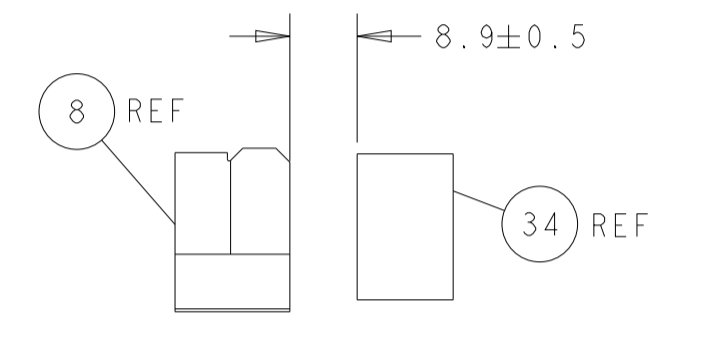
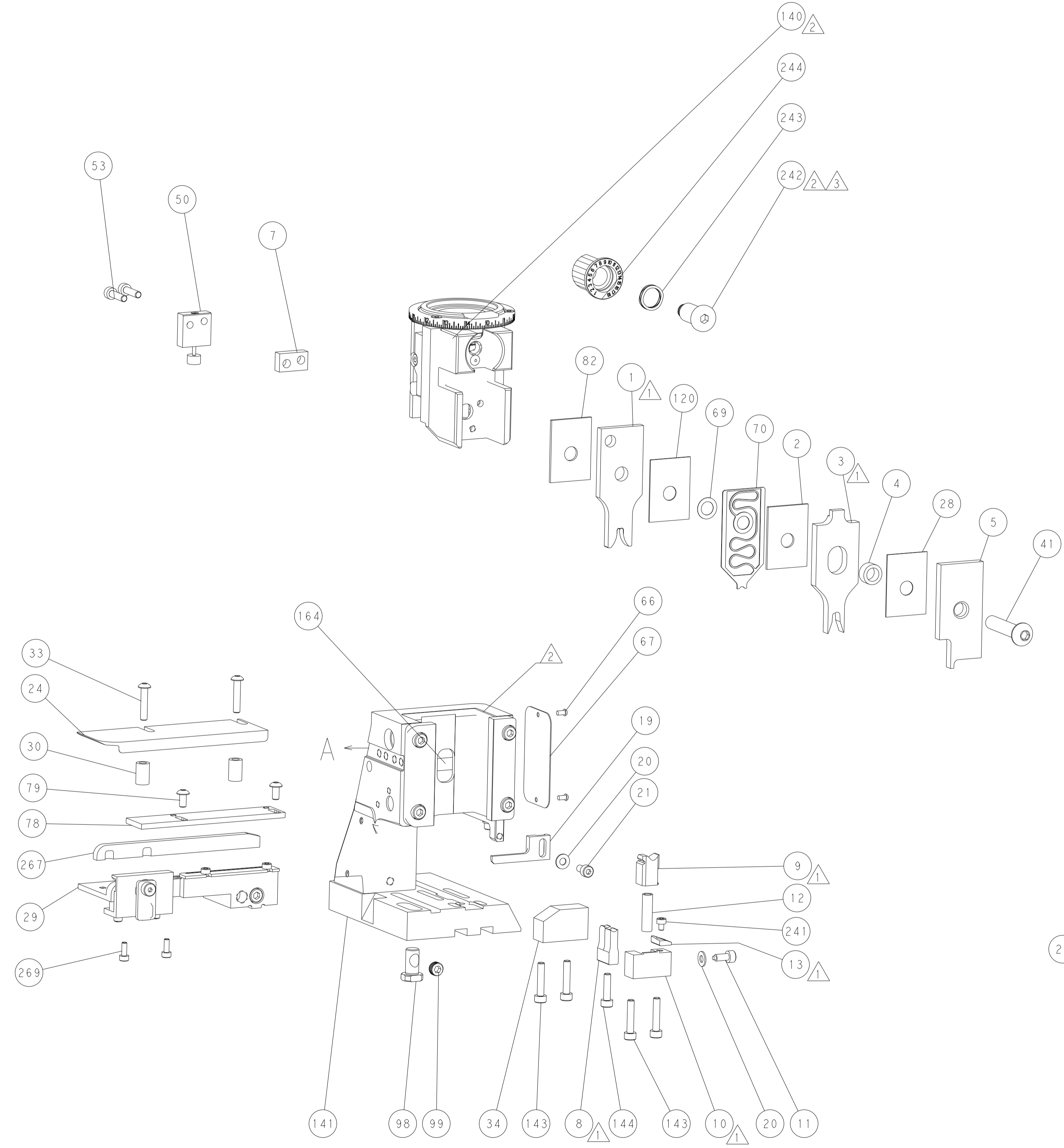
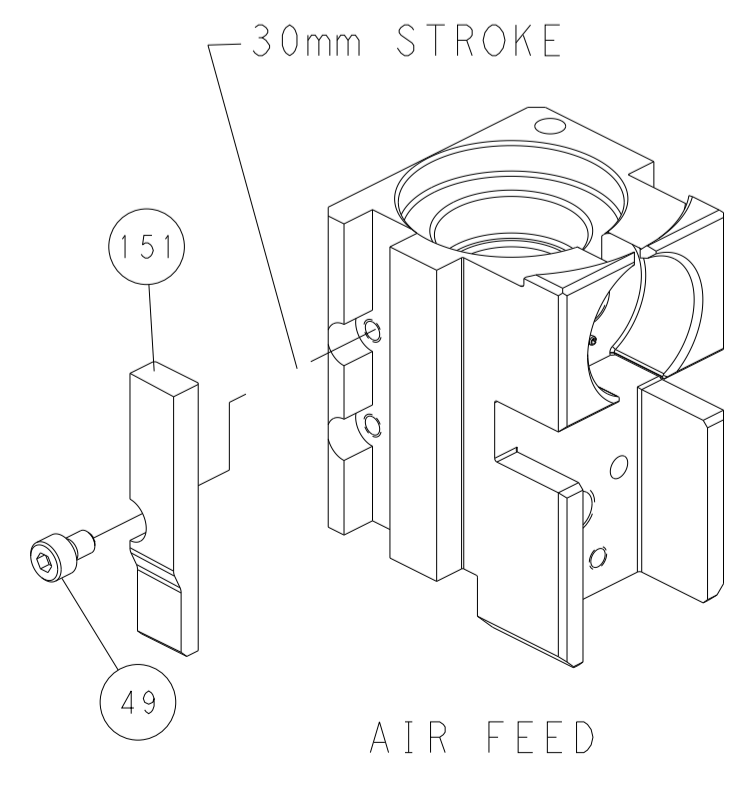
FEED TYPE PNEUMATIC



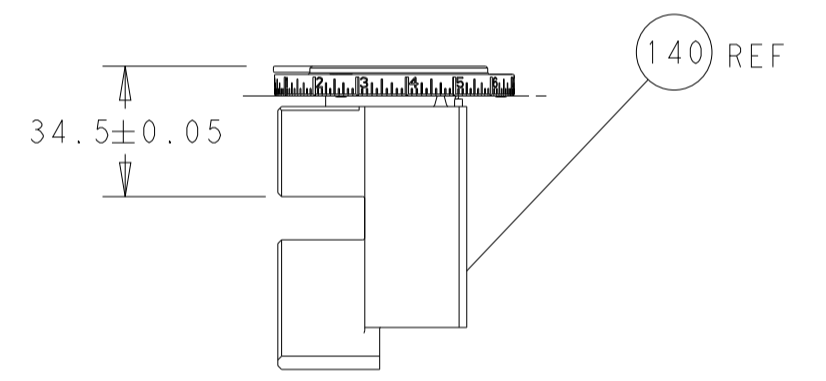
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



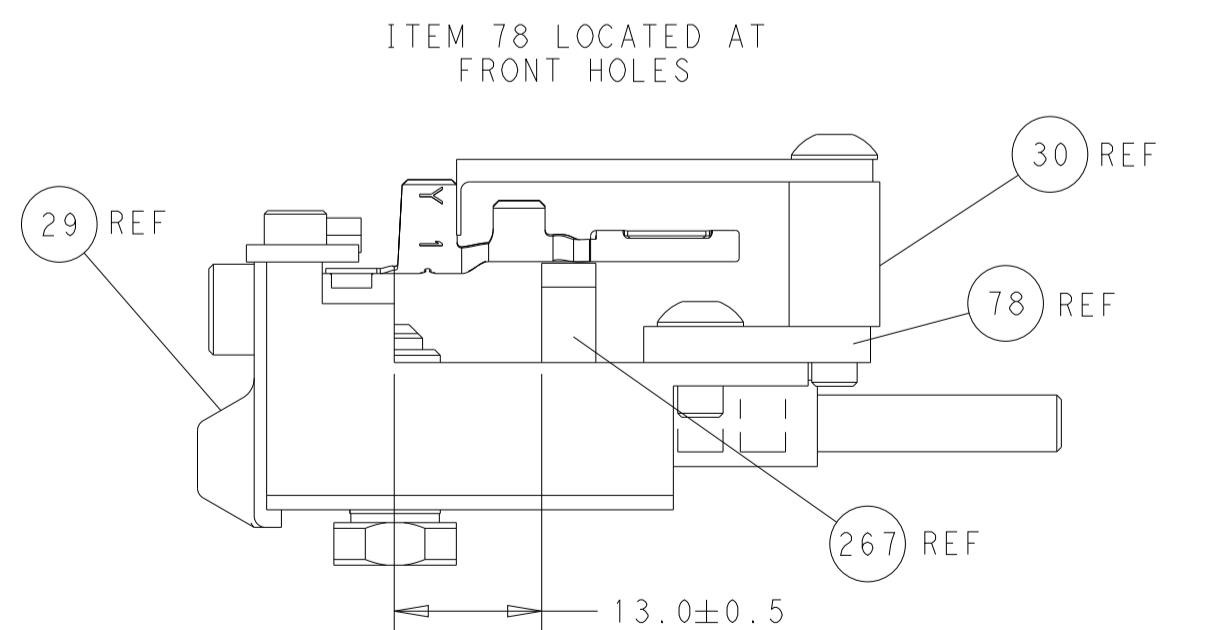
CAM POSITION



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)

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