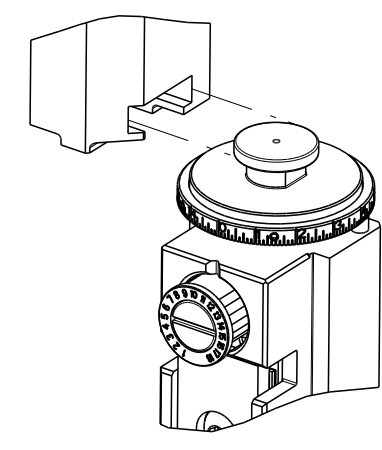


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266774-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266774-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266774-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FLAG FASTON REC.			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.50-6.50 mm [.217-.256 IN]	∅2.00-3.30 mm [.079-.130 IN]		
TERMINAL APPLICATION SPECIFICATION	114-20088		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
280050-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm ²	1.30+/-0.03 [.051+/- .001]	8.9

- 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 LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ONLY FOR GERMAN SALES MARKET

***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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		3		PRELIMINARY BUILD	19FEB2016	RK	GB
		A		RELEASED	06MAY2016	JH	GB
		A1		ECR-18-011692	25JUL2018	YY	GB
		B		ECR-21-110536	18AUG2021	JWC	TE

-	2	2	2079383-1	SCR, BHSC, RoHS (M3 X 8)	269	
-	1	1	1-1633782-3	FENCE	267	
-	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	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-1	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	143	
-	1	1	2217068-1	BRACKET, AIR BLAST	130	
-	1	1	2030758-3	TUBING, POLYURETHANE	129	
-	1	1	986965-8	NUT, LOCK, HEX, TORQUE (M4)	128	
-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	127	
-	1	1	986220-3	CLAMP, CABLE, BLACK	126	
-	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	1	1-455888-0	SPACER, CRIMPER	120	
5	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	23238-1	INSERT, COUPLING	101	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	3-690712-4	FRONT STRIP GUIDE	96	
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95	
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	455888-3	SPACER, CRIMPER	82	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-9	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	
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	1338685-3	PAWL, FEED	56	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	1-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2-2844938-9	PLATE, STRIP GUIDE	29	
-	2	2	22281-6	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	690792-3	DRAG, STOCK	25	
-	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	4	4	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	2119533-6	STRIPPER, SIDE FEED	19	
1	-	1	1	3-853720-0	BLADE, SLUG	15
1	-	1	1	2-853721-1	BLADE, SLUG	10
1	-	1	1	2-1803012-8	PLATE, REAR SHEAR	9
1	2	1	1	1803010-5	ANVIL, SPEICAL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	-	-	-	-	5	
-	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
1	2	1	1	6-1803016-3	CRIMPER, INSULATION F	3
-	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	1	1	8-456406-2	CRIMPER, WIRE PREMIUM	1

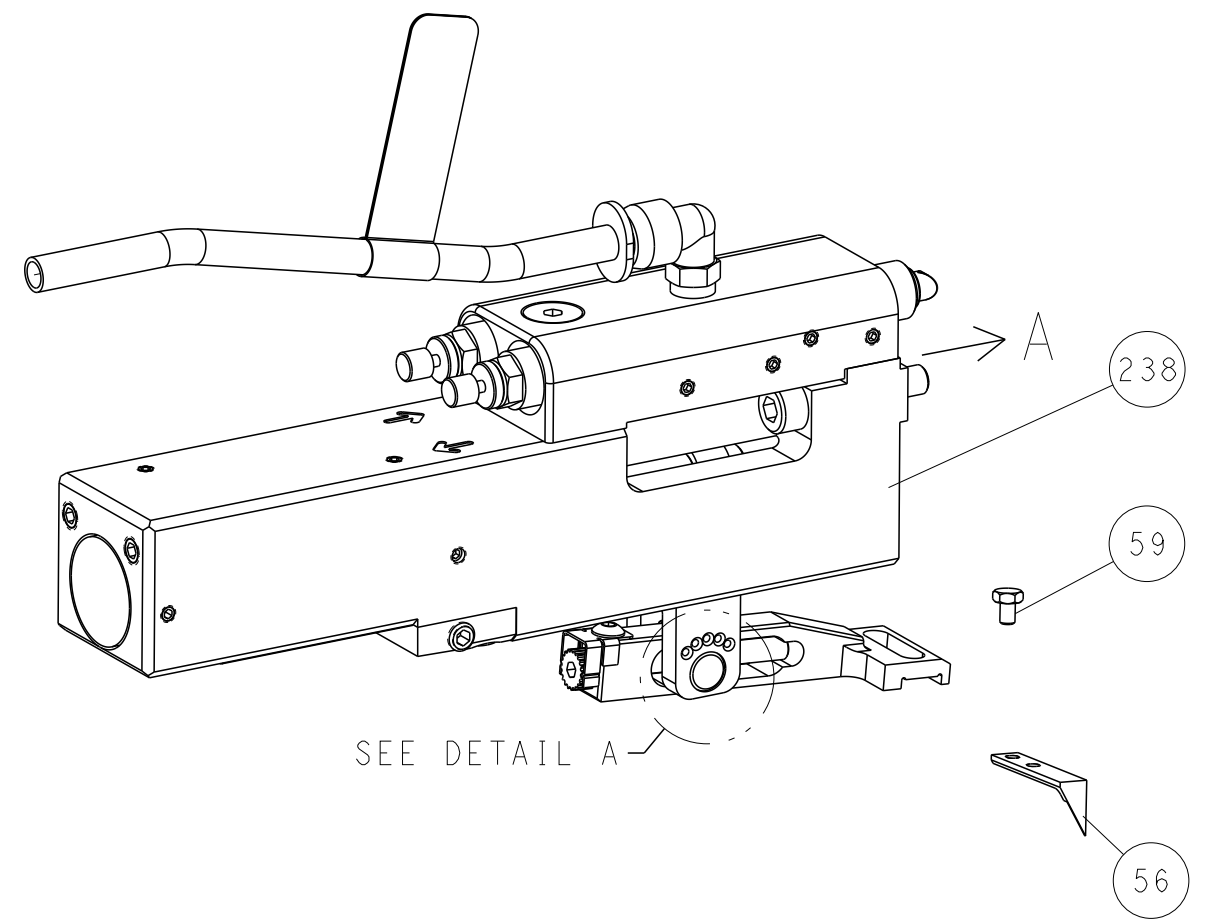
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

OWN	J. HOU	8MAY2015	CHK	L. ZHANG	8MAY2015	APVD	H. GUO	8MAY2015
PRODUCT SPEC			APPLICATION SPEC			WEIGHT		
SIZE			CAGE CODE			DRAWING NO		
A1			00779			C=2266774		
Customer Accessible Production Drawing			SCALE			SHEET 1 of 4		
			1:2			REV B		

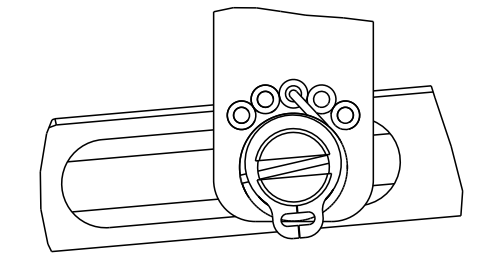
LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

FEED TYPE

PNEUMATIC

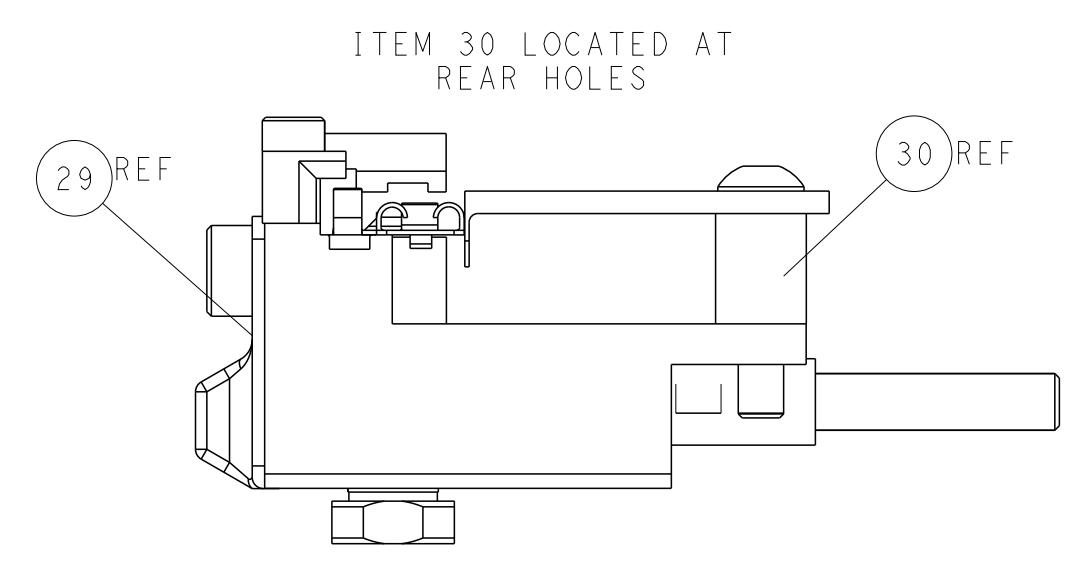
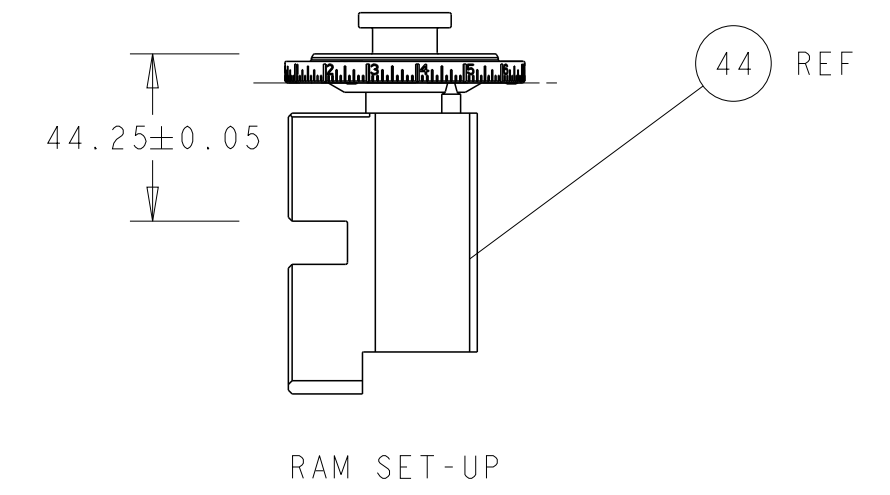
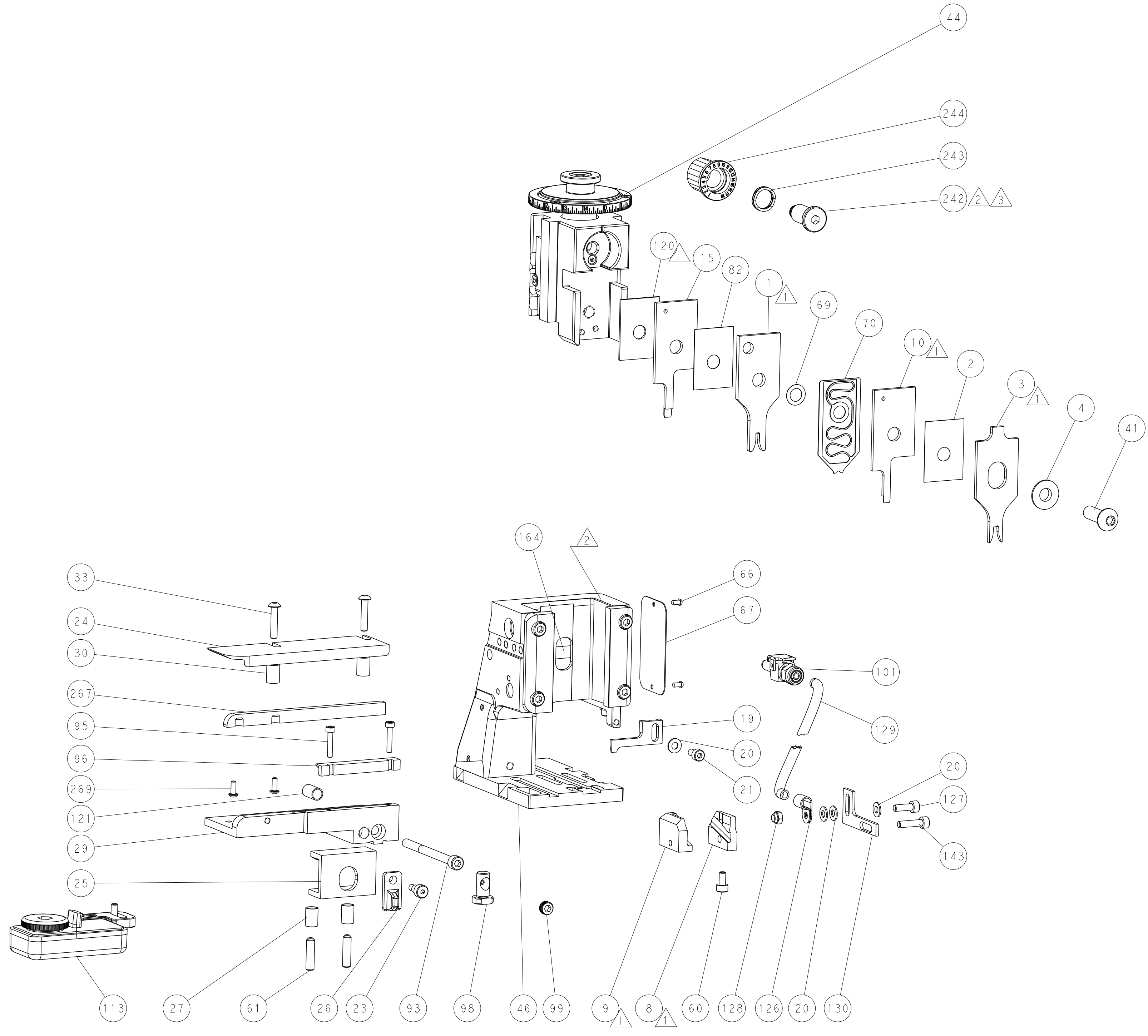
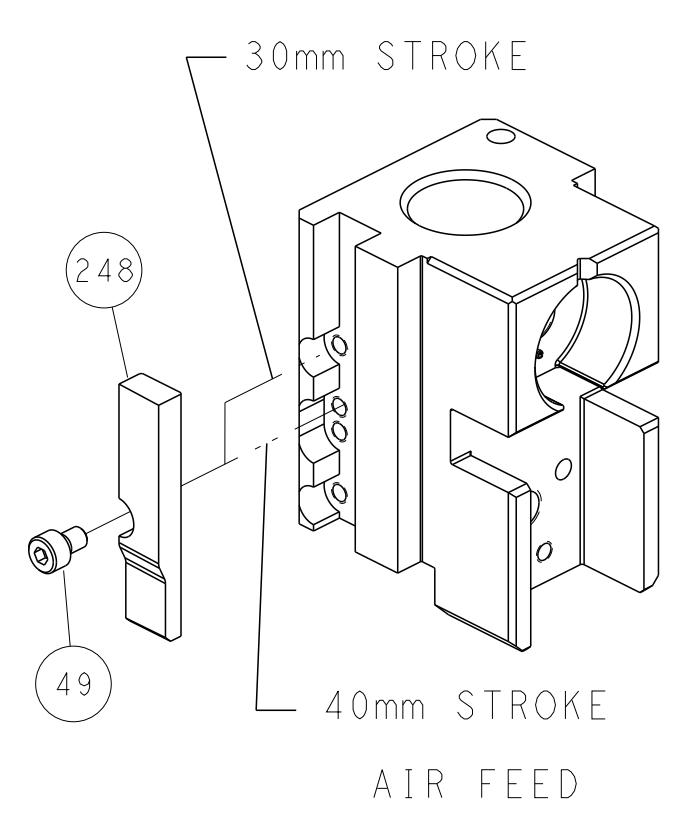


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITION

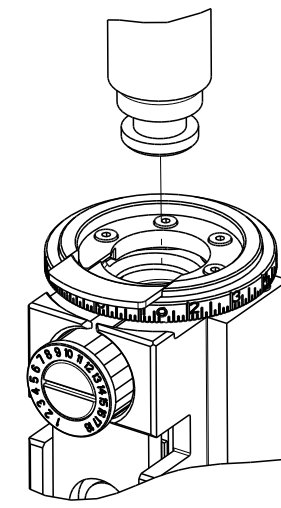


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J. HOU 8MAY2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
	ANGLES ±	FINISH		CHK: L. ZHANG 8MAY2015		NAME: Ocean Side Feed Applicator	
MATERIAL:				APVD: H. GUO 8MAY2015		RESTRICTED TO:	
				PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
				APPLICATION SPEC		A1 00779 ©=2266774	
				WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV B	
Customer Accessible Production Drawing				SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION			

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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266774-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266774-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [1.40]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FLAG FASTON REC.			
WIRE STRIP LENGTH 5.50-6.50 mm [1.217-.256 IN]		INSULATION DIAMETER RANGE Ø2.00-3.30 mm [1.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20088	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
280050-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	1.30+/-0.03 [1.051+/-0.01]	8.9

- 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 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.

ONLY FOR GERMAN SALES MARKET

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

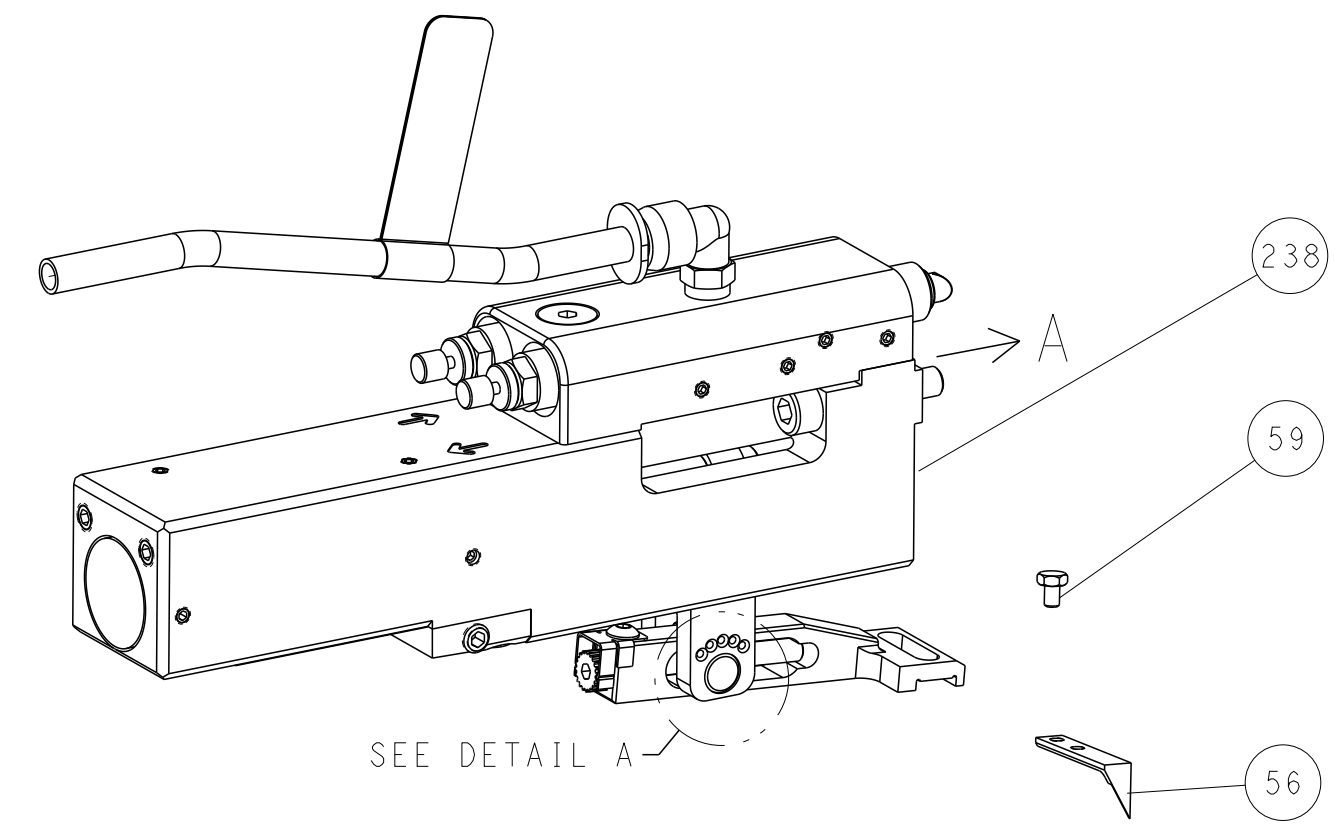
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

-	2	2079383-1	SCR, BHSC, RoHS (M3 X 8)	269
-	1	1-1633782-3	FENCE	267
-	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	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
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	143
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	2217068-1	BRACKET, AIR BLAST	130
-	1	2030758-3	TUBING, POLYURETHANE	129
-	1	986965-8	NUT, LOCK, HEX, TORQUE (M4)	128
-	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	127
-	1	986220-3	CLAMP, CABLE, BLACK	126
-	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1-455888-0	SPACER, CRIMPER	120
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	23238-1	INSERT, COUPLING	101
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	3-690712-4	FRONT STRIP GUIDE	96
-	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	455888-3	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119791-9	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
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1338685-3	PAWL, FEED	56
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	1-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2-2844938-9	PLATE, STRIP GUIDE	29
-	2	22281-6	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	690792-3	DRAG, STOCK	25
-	1	1320928-2	STRIP GUIDE	24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-6	STRIPPER, SIDE FEED	19
-	1	3-853720-0	BLADE, SLUG	15
-	1	2-853721-1	BLADE, SLUG	10
-	1	2-1803012-8	PLATE, REAR SHEAR	9
-	1	1803010-5	ANVIL, SPECIAL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	-	-	-	5
-	1	238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	1-6-1803016-3	CRIMPER, INSULATION F	3
-	1	455888-1	SPACER, CRIMPER	2
-	1	8-456406-2	CRIMPER, WIRE PREMIUM	1

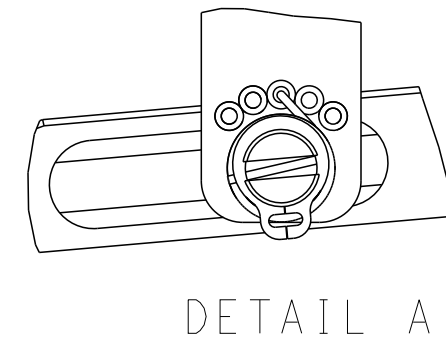
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J. HOU BMAY2015		CHK: L. ZHANG BMAY2015		APVD: J. GUO BMAY2015		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2266774	RESTRICTED TO: B
MATERIAL:								WEIGHT:		SCALE: 1:2	
Customer Accessible Production Drawing								SHEET 3 OF 4		REV B	

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

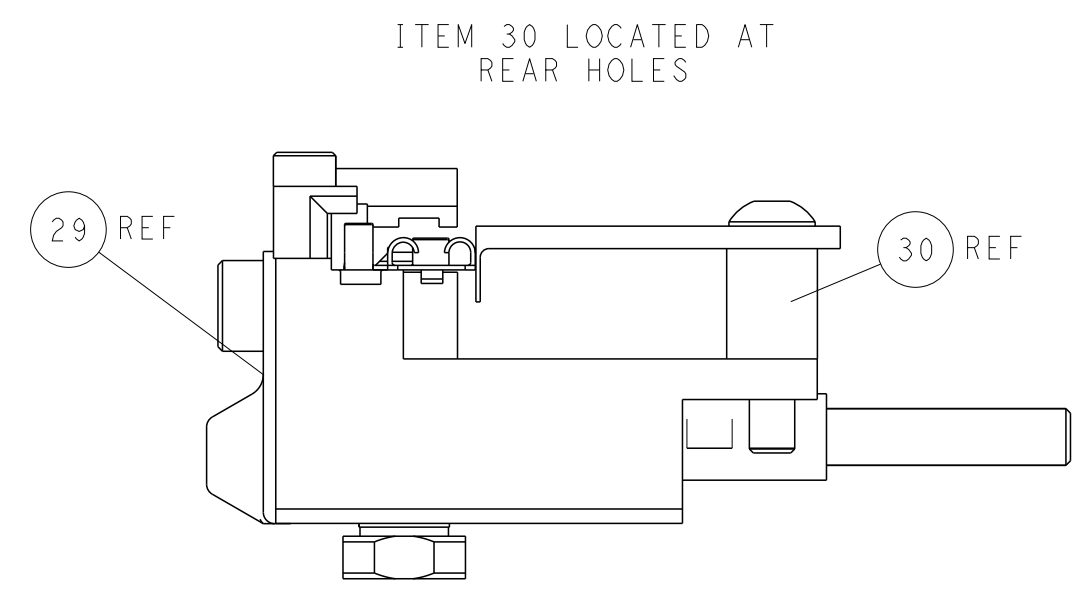
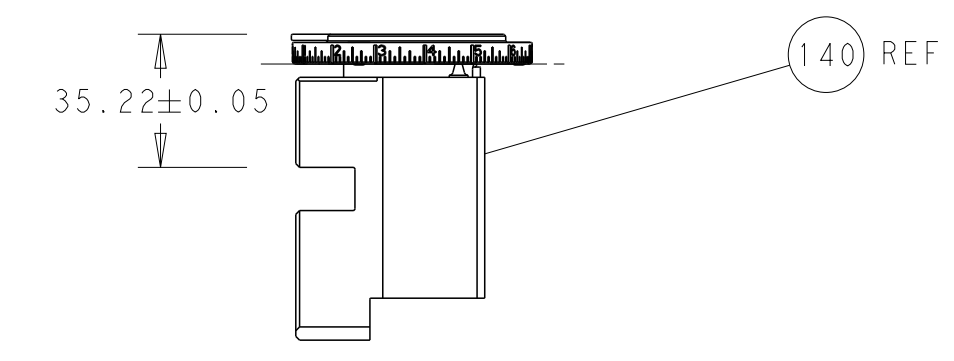
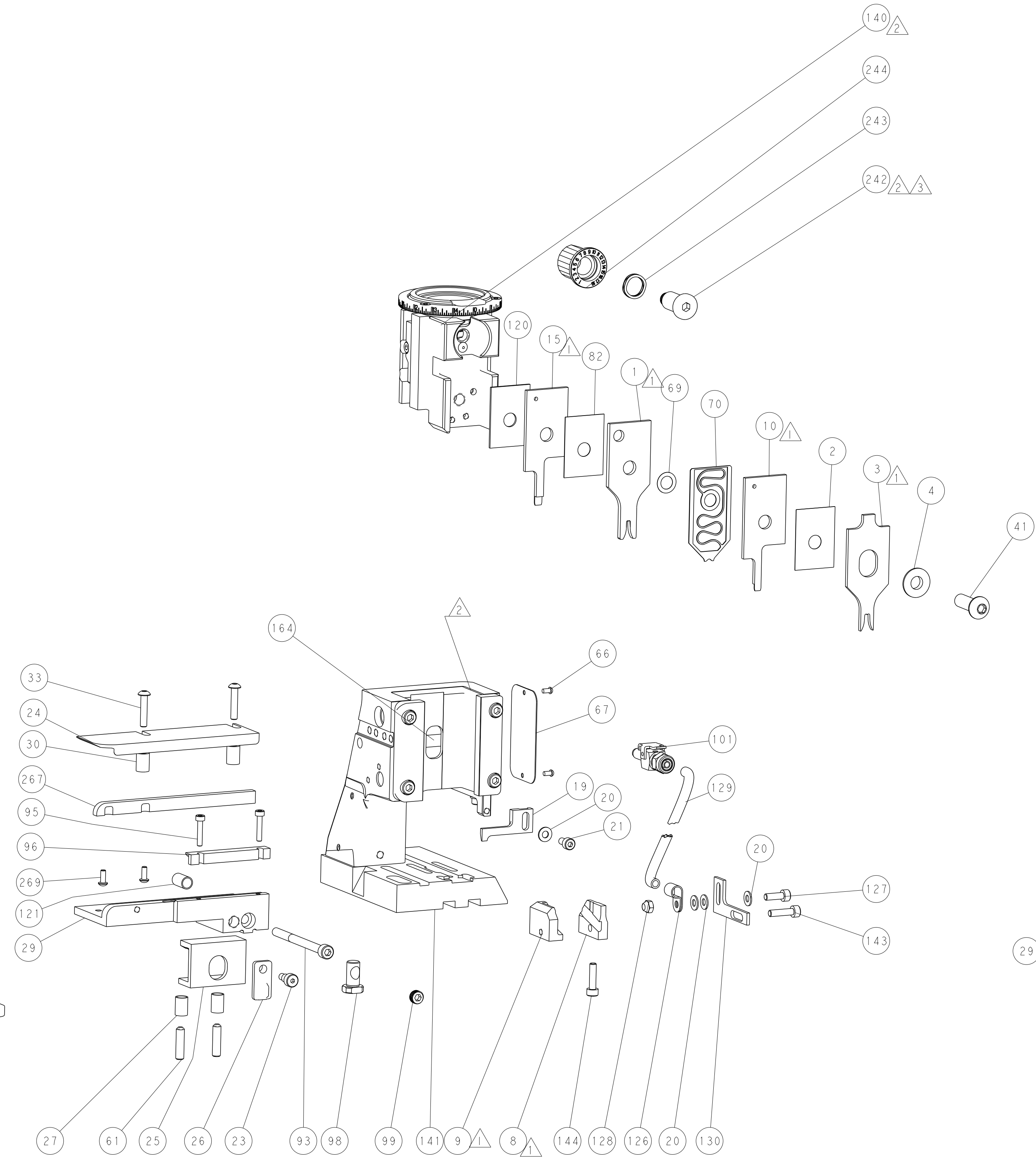
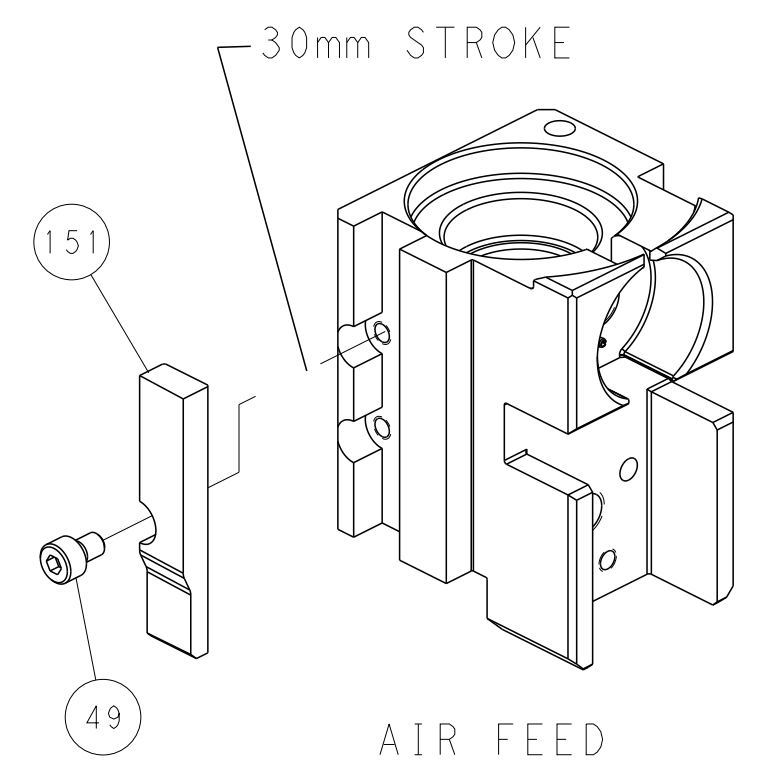
FEED TYPE PNEUMATIC



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2266774	RESTRICTED TO: - SHEET 4 OF 4 REV B	CUSTOMER ACCESSIBLE PRODUCTION DRAWING