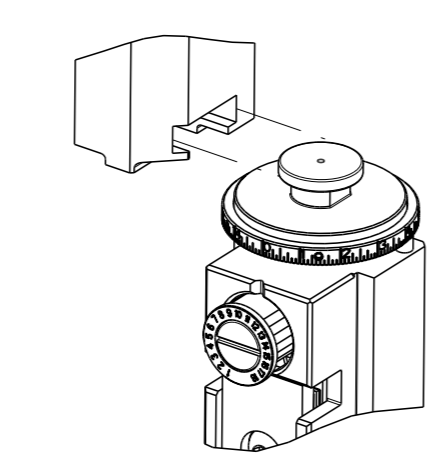


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266321-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266321-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266321-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266321-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266321-*	-	SEE CRIMP TOOLING KITS BELOW	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

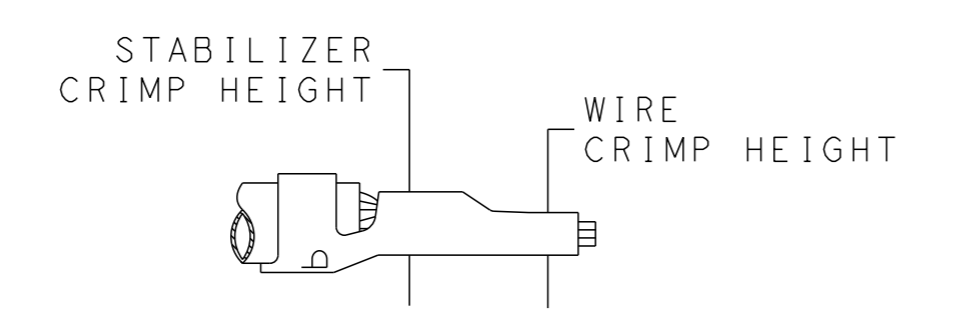


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
STABILIZER	1.07 mm [.042]	F
INSULATION	2.79 mm [1.10]	F

APPLICATOR INSTRUCTIONS
408-35042

PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2266321-7	B	22 AWG	9-1633609-5	4-456401-4	2-2119582-1	1633916-6
7-2266321-8	B	24-26 AWG	9-1633609-4	4-456401-4	2-2119582-1	1633916-6

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.45-5.21 mm [1.75-.205 IN]		Ø1.02-2.54 mm [0.040-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-640401-1			



WIRE SIZE	CRIMP HEIGHT mm [INCH]	STABILIZER CRIMP HEIGHT	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.89+/-0.05 [0.035+/-0.002]	1.02±0.05 (0.40±.002)	6.7
24-26 AWG	0.74+/-0.05 [0.029+/-0.002]	1.02±0.05 (0.40±.002)	6.5

- 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.
- UNLESS OTHERWISE SPECIFIED SET UP THE APPLICATOR FOR THE 24 OR 26 AWG WIRE USING ITEM 178. THE ADDITIONAL WIRE CRIMPER ITEM 179 NEEDS TO BE SENT WITH THE APPLICATOR TO CRIMP THE 22 AWG WIRE.
- ITEMS 179 TO BE USED WITH 22 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- ITEMS 178 TO BE USED WITH 24-26 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.

***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			
		REV	DATE	BY	APPV
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		C	17FEB2019	TB	CT
		D	15MAR2019	JAH	GB

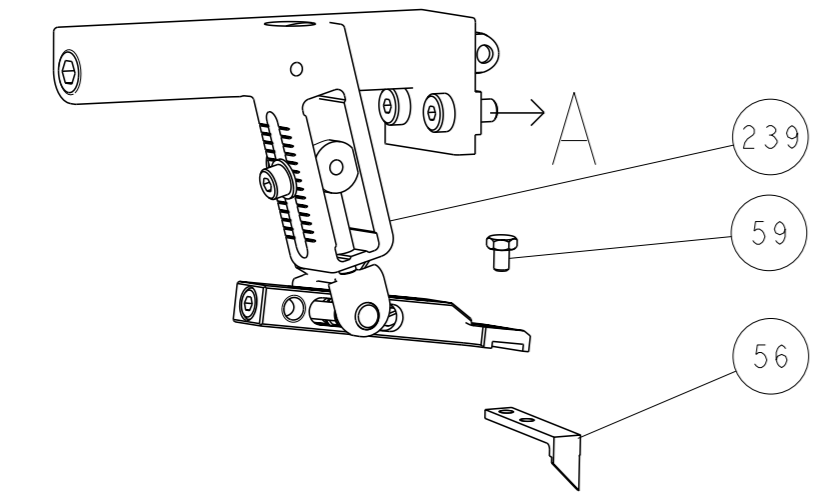
-	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	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	-	2063440-1	AIR FEED MODULE	238
-	1	2	2	1	1	9-1633609-5	CRIMPER, WIRE	179
-	1	2	2	1	1	9-1633609-4	CRIMPER, WIRE	178
-	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	-	1	1	1	1	2844907-1	POST, LOCKING	98
-	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	82
-	-	1	1	1	1	1803607-1	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
-	-	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	469465-4	STOP, WIRE	34
-	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	2	2	2	2	2-2844962-8	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	2119533-3	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1633916-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	-	1	1	1	1	1-455888-8	SPACER, CRIMPER	2
1	1	2	2	1	1	4-456401-4	CRIMPER, WIRE .042 F PREMIUM	1

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

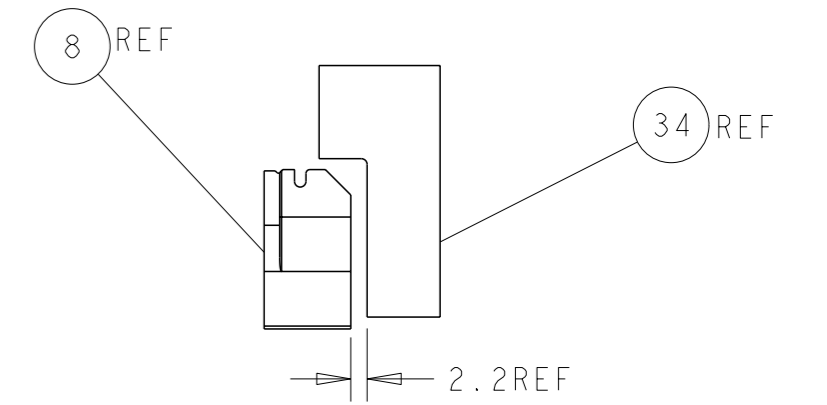
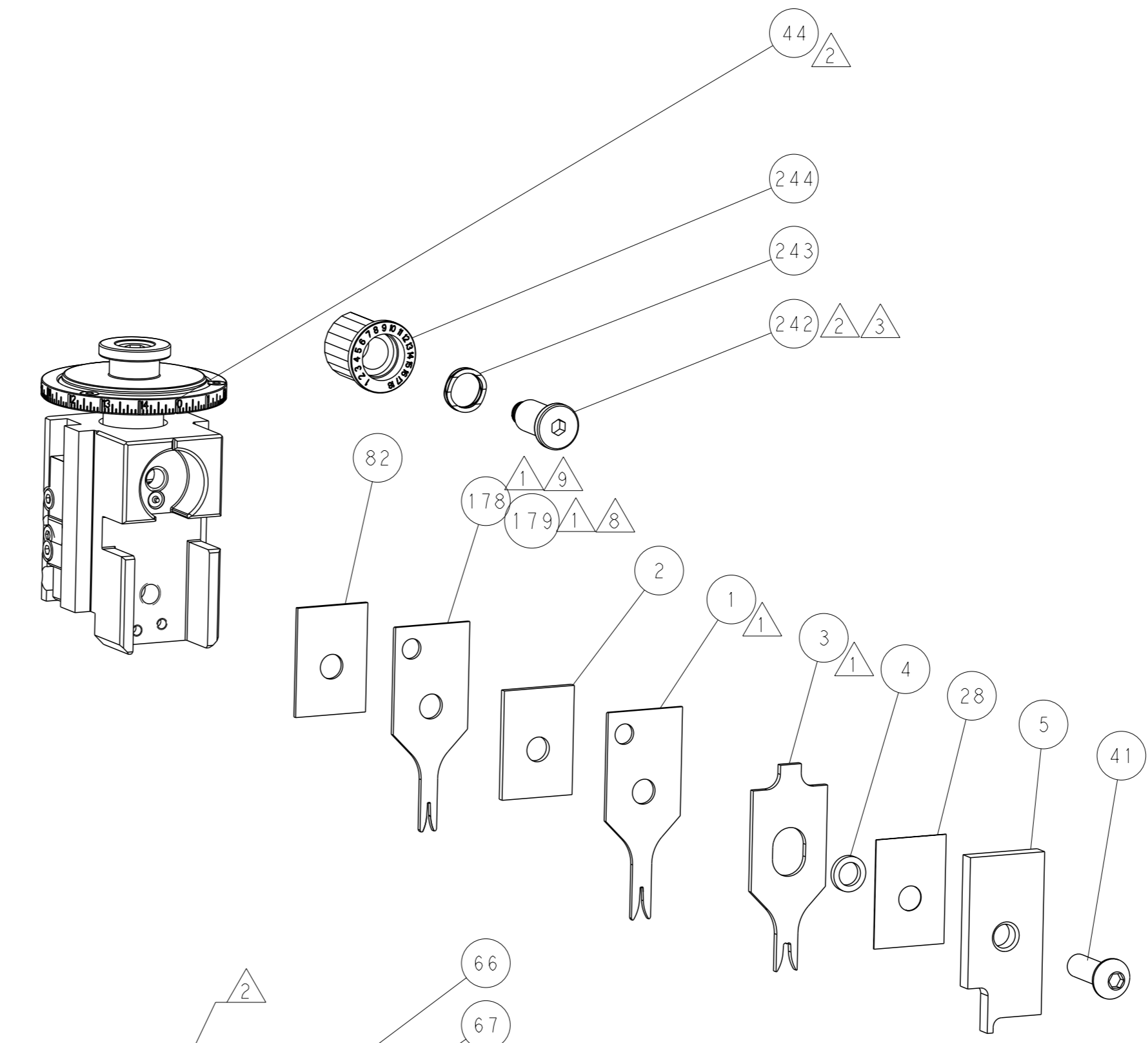
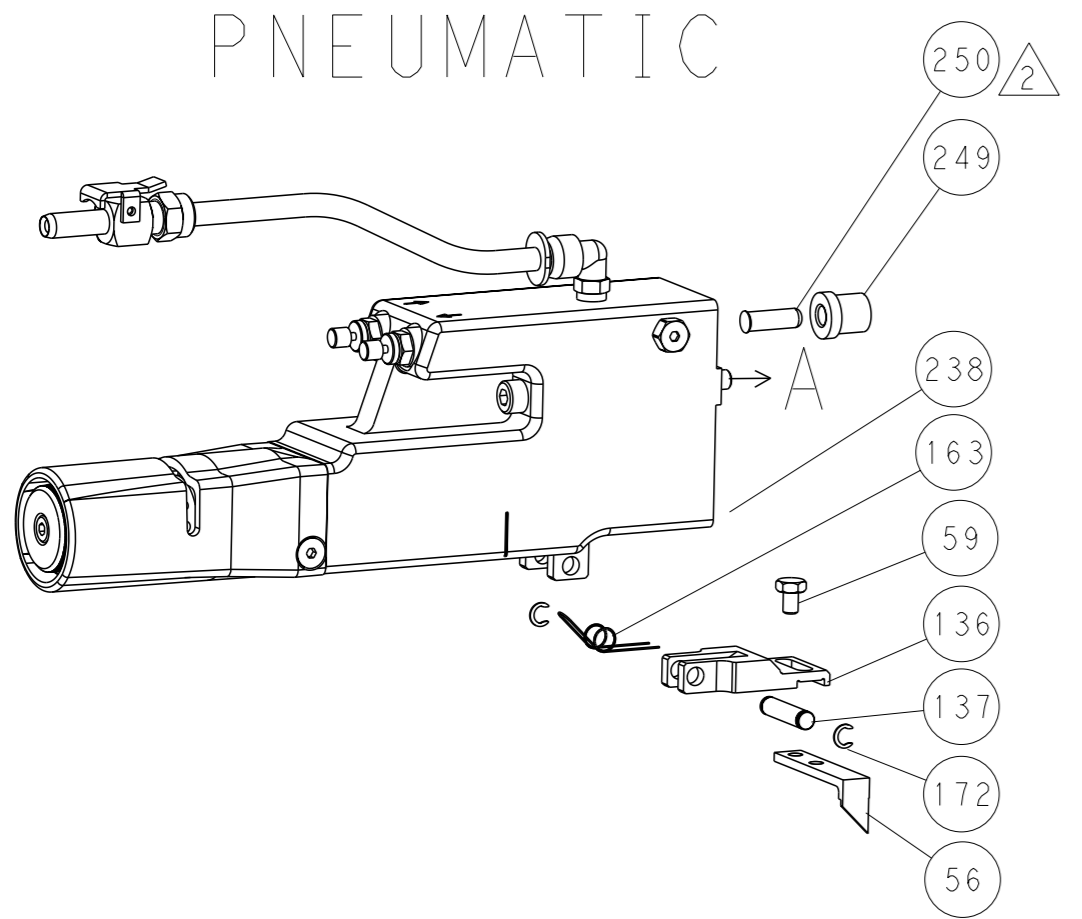
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	3 PLC ±	4 PLC ±	ANGLES ±	CHK T. ELBIN	4 JUNE 2014	NAME	
				APVD T. ELBIN	4 JUNE 2014	Ocean Side Feed Applicator	
MATERIAL				PRODUCT SPEC		SIZE	CAGE CODE DRAWING NO
				APPLICATION SPEC		A1	00779 C=2266321
				WEIGHT		RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE 1:2 SHEET 1 OF 4 REV D

LOC	DIST	REVISIONS			
		REV	DATE	OWN	APVD
A	66	1	SEE SHEET 1	-	-

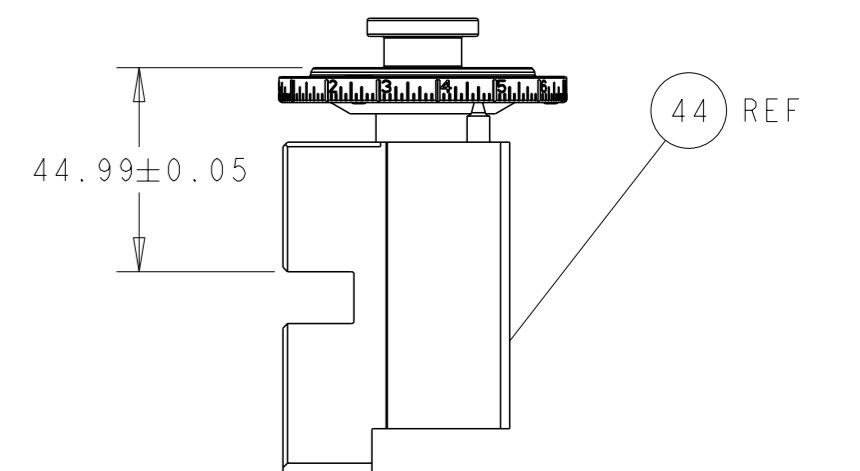
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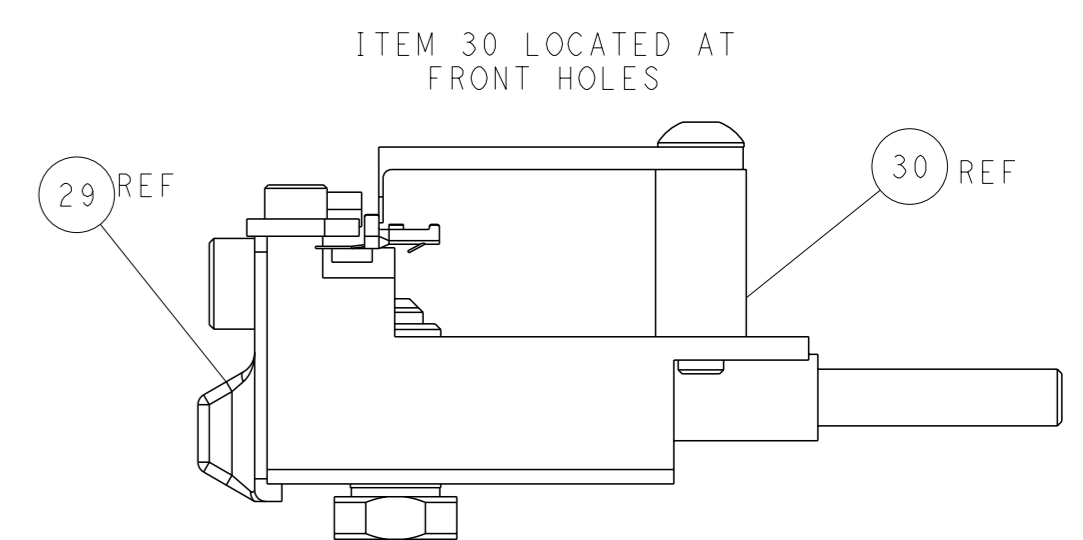
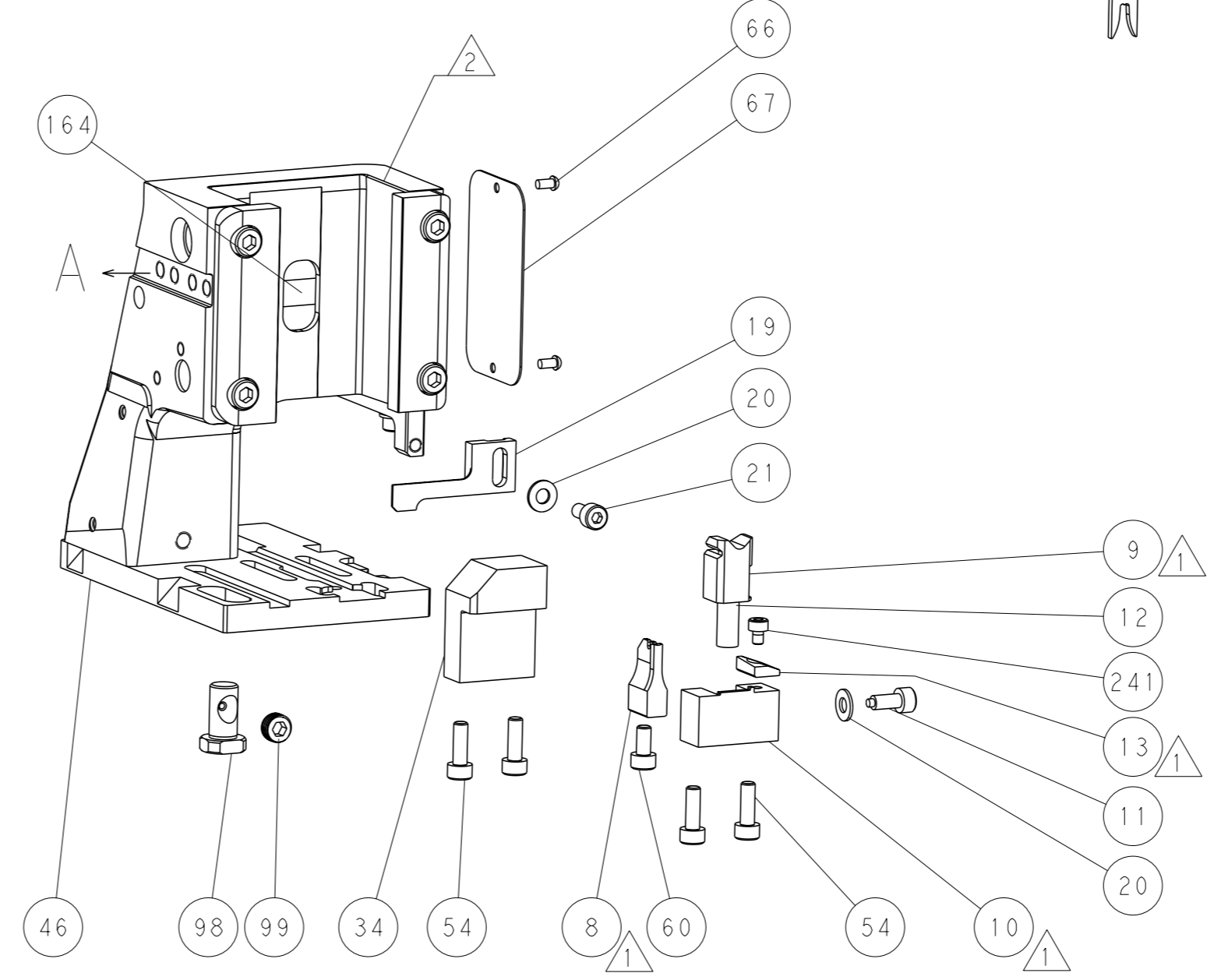
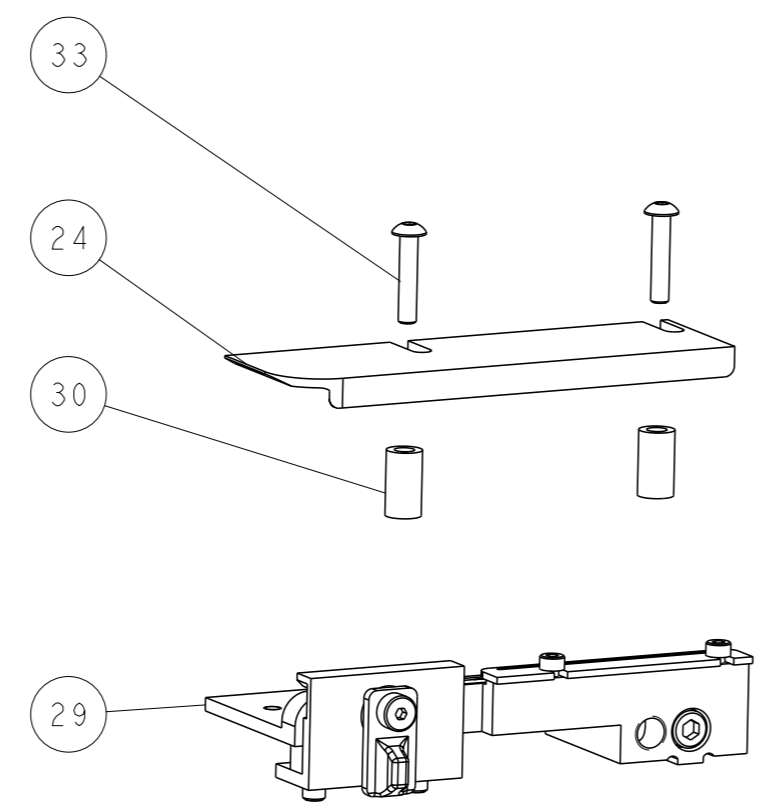
PNEUMATIC



TERMINAL SUPPORT LOCATION

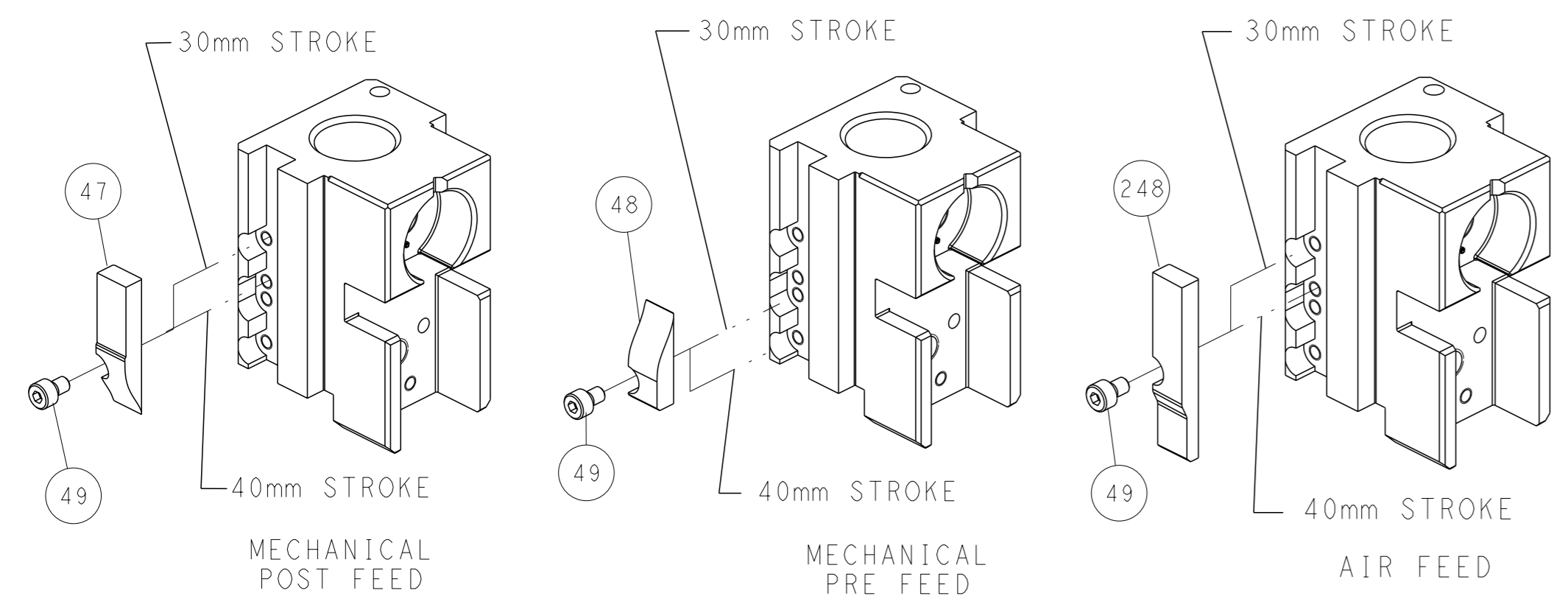


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

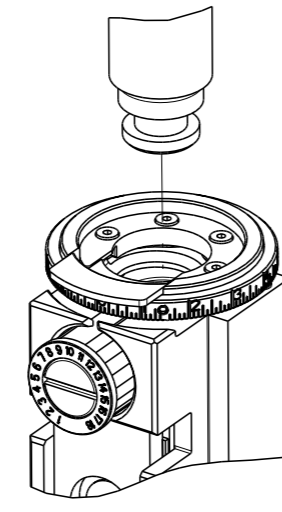


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: HOFFNER CHK: T. ELBIN APVD: T. ELBIN PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	DATE: 3 JUNE 2014 DATE: 4 JUNE 2014 DATE: 4 JUNE 2014 SCALE: 1:2 SHEET: 2 of 4 REV: D	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266321 RESTRICTED TO: -
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266321-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266321-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266321-*	-	SEE CRIMP TOOLING KITS BELOW	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

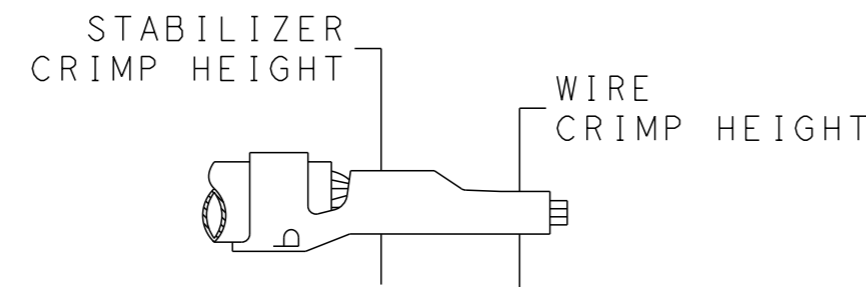


APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	1.07 mm [.042]	F
STABILIZER	1.07 mm [.042]	F
INSULATION	2.79 mm [.110]	F

APPLICATOR INSTRUCTIONS
408-35042

PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2266321-7	B	22 AWG	9-1633609-5	4-456401-4	2-2119582-1	1633916-6
7-2266321-8	B	24-26 AWG	9-1633609-4	4-456401-4	2-2119582-1	1633916-6

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.45-5.21 mm [1.75-.205 IN]		Ø1.02-2.54 mm [.040-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-640401-1			



WIRE SIZE	CRIMP HEIGHT mm [INCH]	STABILIZER CRIMP HEIGHT	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.89+/-0.05 [.035+/-0.002]	1.02±0.05 (0.40±.002)	6.7
24-26 AWG	0.74+/-0.05 [.029+/-0.002]	1.02±0.05 (0.40±.002)	6.5

- 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.
- 7 UNLESS OTHERWISE SPECIFIED SET UP THE APPLICATOR FOR THE 24 OR 26 AWG WIRE USING ITEM 178. THE ADDITIONAL WIRE CRIMPER ITEM 179 NEEDS TO BE SENT WITH THE APPLICATOR TO CRIMP THE 22 AWG WIRE.
- 8 ITEMS 179 TO BE USED WITH 22 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- 9 ITEMS 178 TO BE USED WITH 24-26 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.

***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	REV	DATE	BY	APPV
A	66				

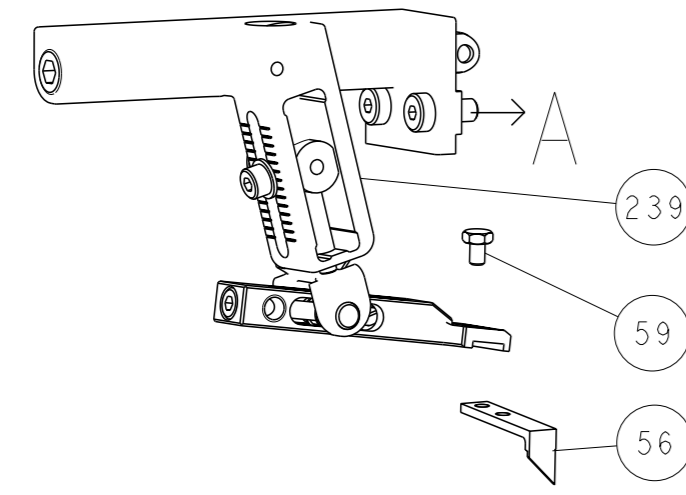
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	1	-	1803259-1	BUSHING, FLANGED	249
-	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	1	9-1633609-5	CRIMPER, WIRE	179
1	-	1	1	9-1633609-4	CRIMPER, WIRE	178
-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	1	1	2844908-1	SCREW, LOCKING	99
-	-	1	1	2844907-1	POST, LOCKING	98
-	-	1	1	1-455888-0	SPACER, CRIMPER	82
-	-	1	1	1803607-1	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
-	-	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	469465-4	STOP, WIRE	34
-	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	2	2	2-2844962-8	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	2119533-3	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	1803095-1	FLOATING SHEAR, FRONT	9
-	-	1	1	1633916-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	-	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	-	1	1	1-455888-8	SPACER, CRIMPER	2
-	-	1	1	4-456401-4	CRIMPER, WIRE .042 F PREMIUM	1

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

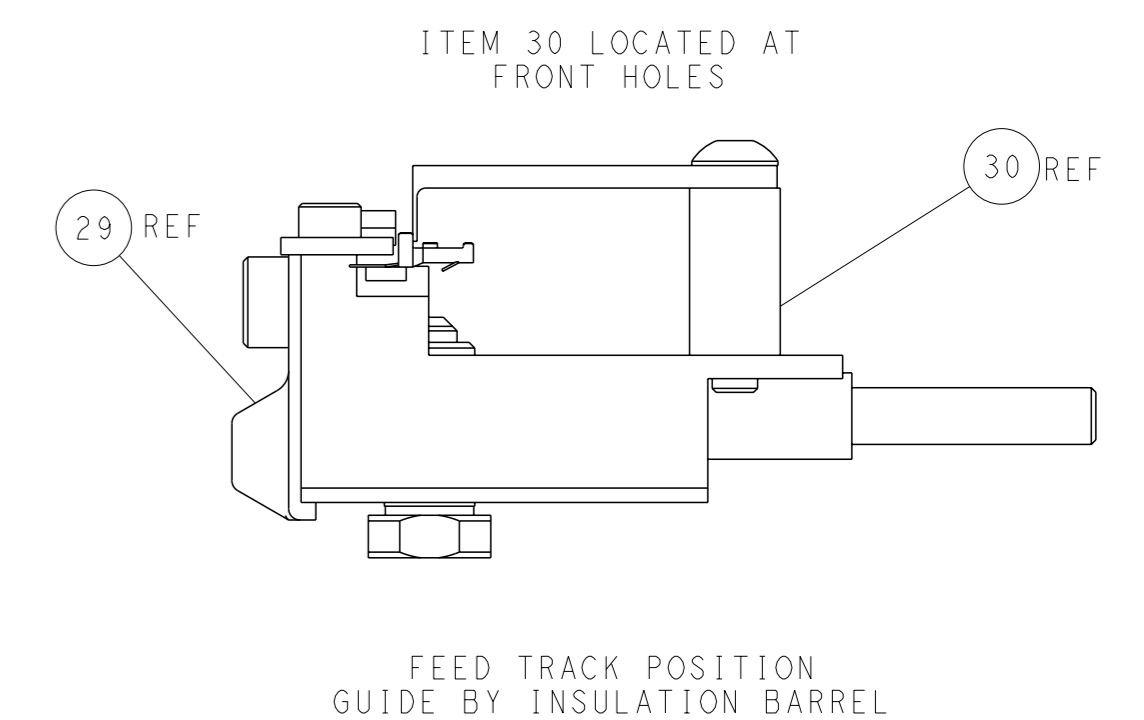
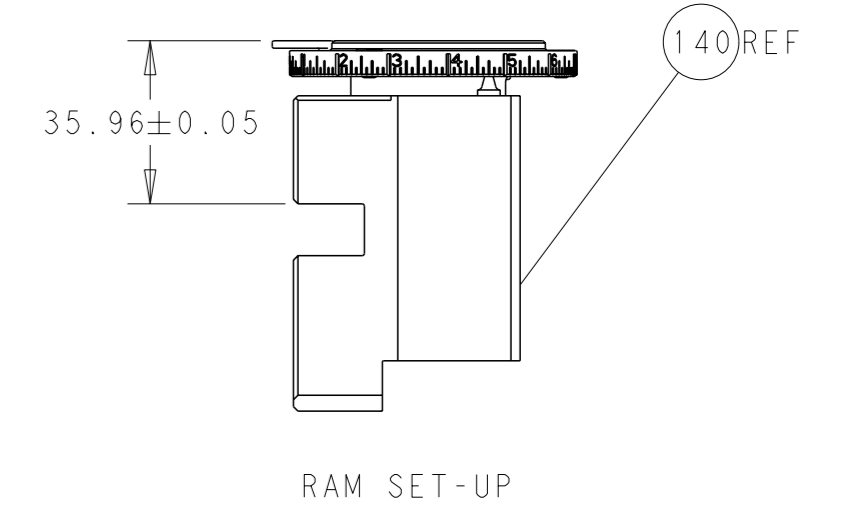
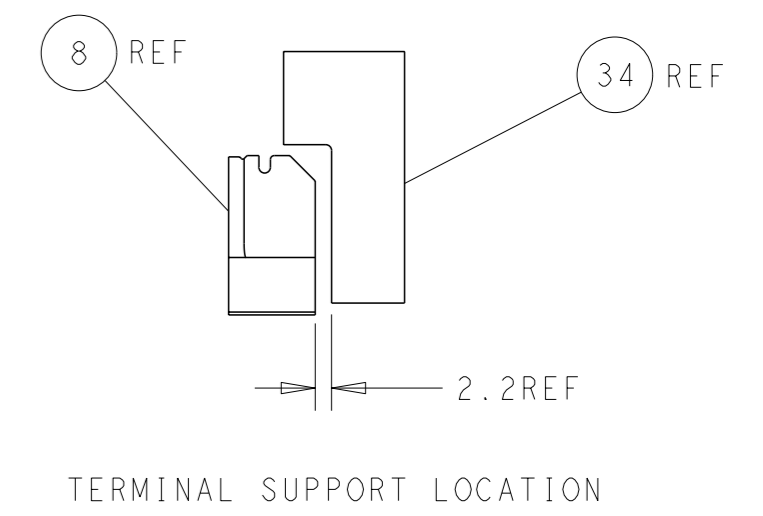
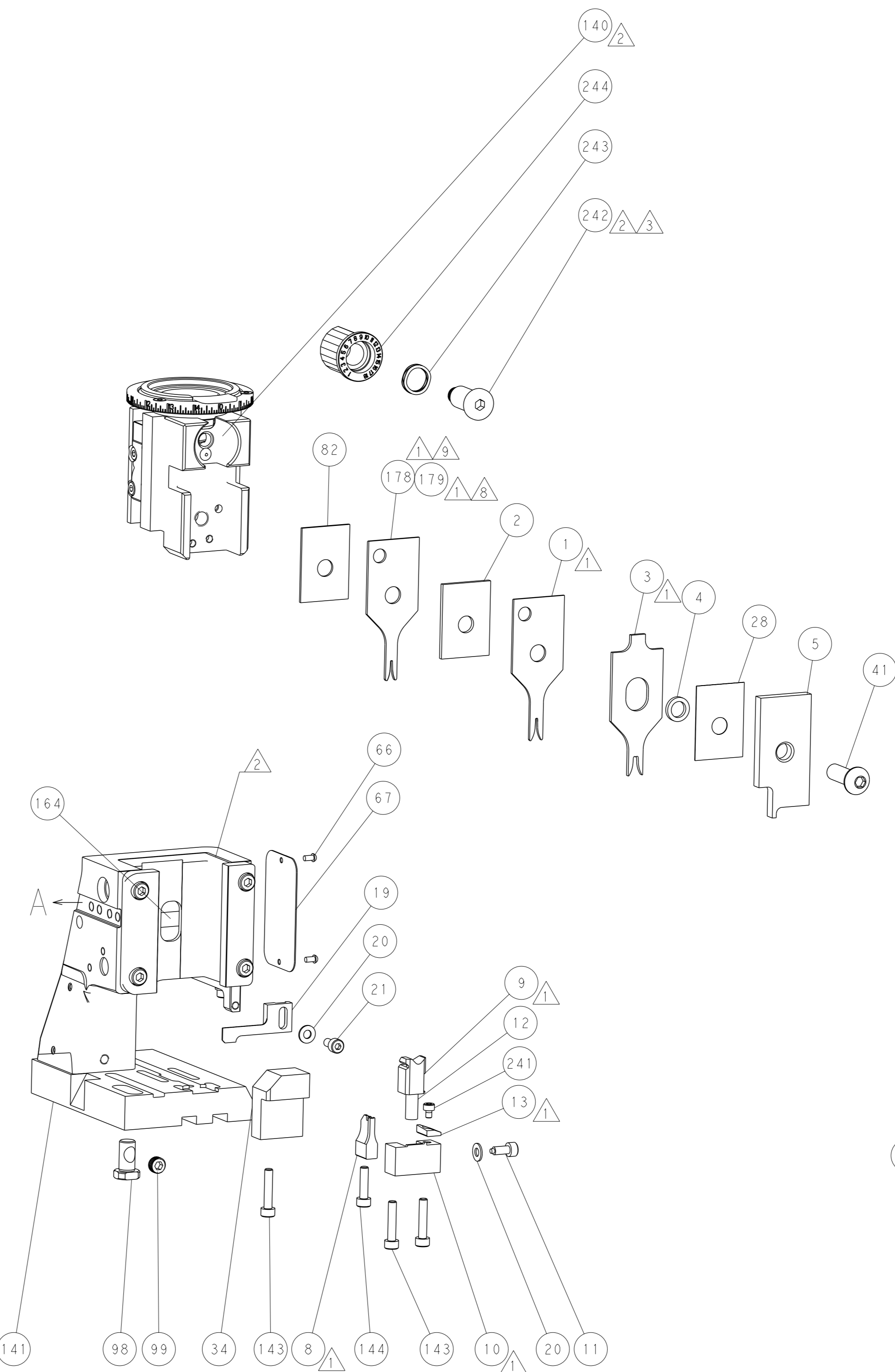
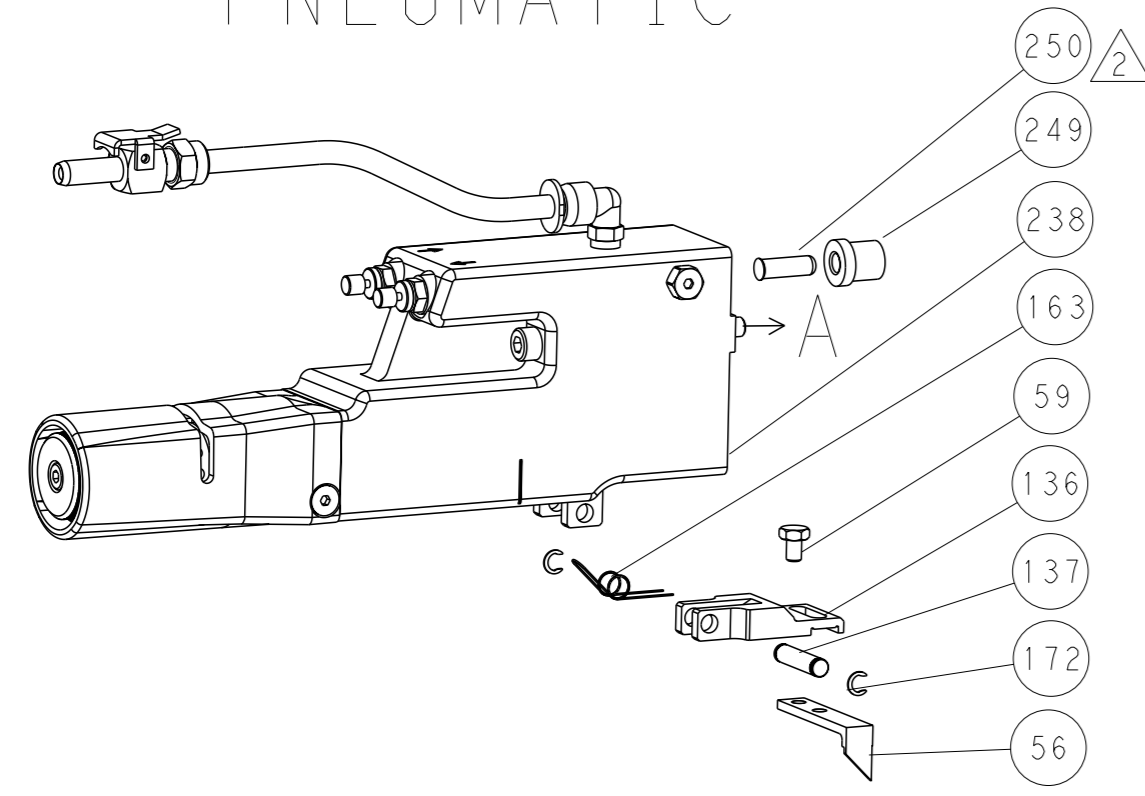
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	DATE	NAME
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	HOFFNER	3 JUNE 2014	TE Connectivity
		CHK	4 JUNE 2014	Harrisburg, PA 17105-3608
		APPV	4 JUNE 2014	Ocean Side Feed Applicator
MATERIAL	FINISH	WEIGHT	SCALE	RESTRICTED TO
			1:2	Customer Accessible Production Drawing

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

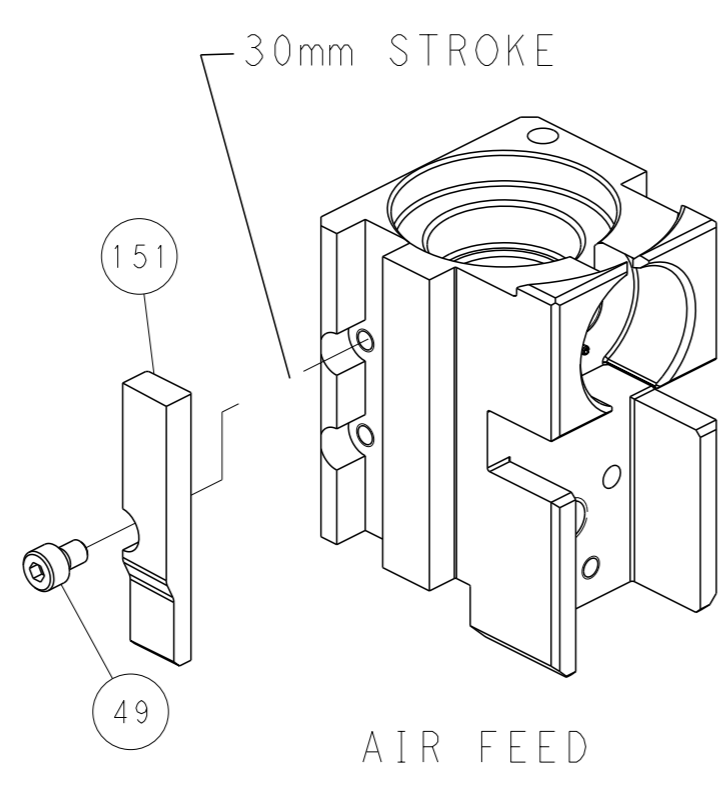
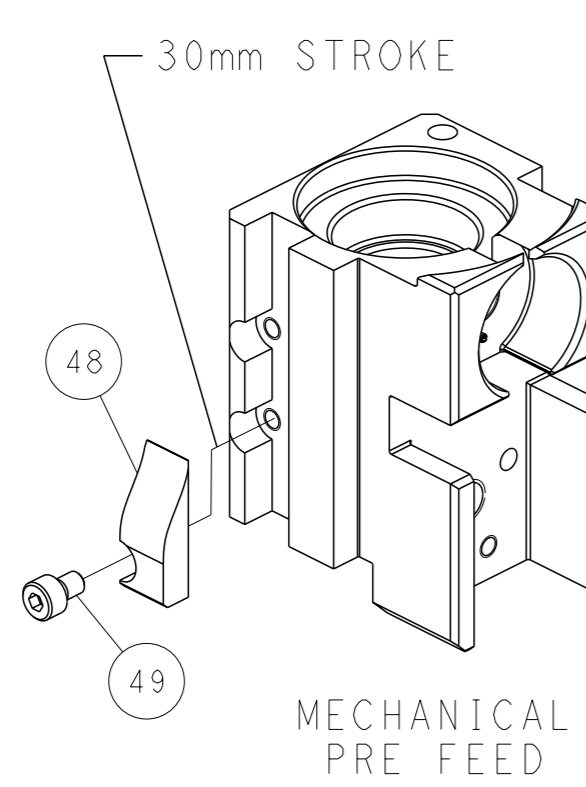
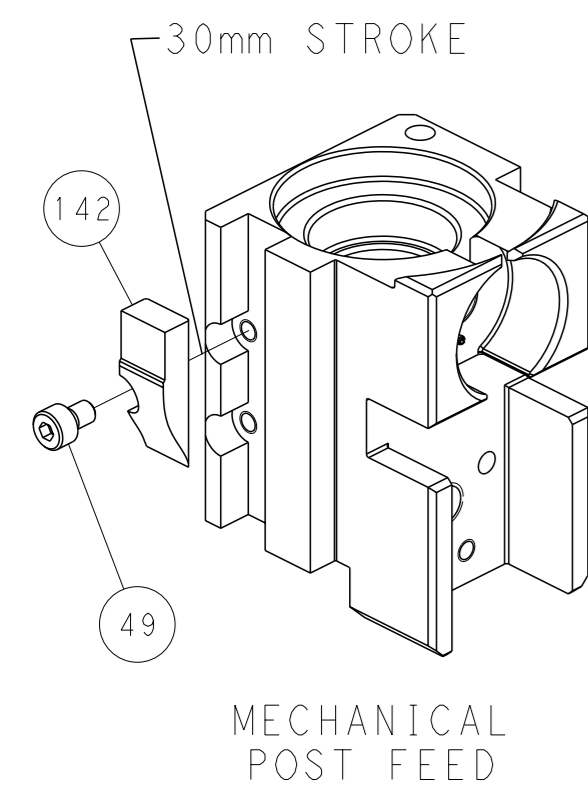
FEED TYPE MECHANICAL



PNEUMATIC



CAM POSITIONS



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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: HOFFNER CHK: T. ELBIN APVD: T. ELBIN PRODUCT SPEC: - APPLICATION SPEC: - MATERIAL: - FINISH: -	DATE: 3 JUNE 2014 DATE: 4 JUNE 2014 DATE: 4 JUNE 2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266321 SCALE: 1:2 SHEET: 4 of 4 REV: D	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION		

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