		8			7	6	
	THIS DRAWING IS UNPUBLI		RELEASED FOR PUBL		20	ATLANTIC VERSION	
	P A R T N U M B E R	REVISION	DESCRI	PTION	FEED TYPE	INTERFACE A	ADAPTER
	2266321-1 2266321-2	D	FINE CRIMP HE FINE CRIMP HE		MECHANICAL PNEUMATIC		
	7 - 2266321 - 1	D	MECHANICAL TOOLING	AND CRIMP	MECHANICAL		
	7 - 2266321 - 2	D	PNEUMATIC A TOOLING	G KIT	PNEUMATIC		
	7-2266321-*	-	SEE CRIMP TOOLI	NG KITS BELOW	-		
)							
	APPL	ICATOR	DATA	PART N	O REV WIRE		R INSULATION ANVIL
	CRIMP WIRE 1	SIZE .07 mm [.		7-2266321	I-7 B 22 AWG		CRIMPER ANVIL 4 2-2119582-1 1633916-6 4 2-2119582-1 1633916-6
	STABILIZER 1 INSULATION 2	.07 mm [. 2.79 mm [.		1-2200321	I-8 B 24-26 AWG	9-1033009-4 4-430401-	4 2-2119302-1 1033910-0
	APPLICATOR 408	INSTRUCT - 35042	IONS				
	TERMINAL DAT	A: TE TER	MINAL	TE CRIMP SF	PECIFICATION		
	TERMINAL NAM WIRE STRIP			INAL sulation diame	TER RANGE		
	4.45-5.21 mm [. TERMINAL	175205 IN		.02-2.54 mm [.04		STABILIZER CRIMP HEIGHT	
	APPLICATION SPECIFICATION		-	-	-		WIRE CRIMP HEIGHT
, ,	TERMINALS	APPLIED					
	TE TERMINAL 3-640401-1	TE TI	ERMINAL TE	TERMINAL	TE TERMINAL		1
	WIRE SIZE		P HEIGHT			IMP HEIGHT 4	
	7 22 AWG	0.89+,	/-0.05 [.035+/0	02] 1.02±0.0	05 (0.40±.002)	ERENCE SETTING	
	7 24-26 AWG] 0 . / 4 + /	/-0.05 [.029+/0	02] 1.02±0.0	05 (0.40±.002)	6.5	
							*WARNINC On insta
	1 RECOMME	NDED SPARE	PARTS				SETTING
		O SUPPLIED OF APPLIC		HEET FOR CLEAN	ING, LUBRICATION A	AND	THE CRIN
	APPLY P.	ART NUMBEF	R 2-23419-6 LOCT	TITE TO THREAD	S OF ITEM 242.		PROPER S
}	APPLICAT	FOR WAS QU	ERENCE SETTING V ALIFIED AT THE NNING APPLICATO	FACTORY. ADJU			
	5 TERMINA	L LUBRICAN	NT IS RECOMMENDE	ED.			
		SPECIFIED F, 101-350	OTHERWISE TORQU 00.	E VALUES SHAL	L BE USED PER		
	THE ADDI		RE CRIMPER ITEM		TOR FOR THE 24 OR BE SENT WITH THE	26 AWG WIRE USING ITEM APPLICATOR TO	178.
	8 ITEMS 1		JSED WITH 22 AWG	GONLY. ITEMS	TO BE SHIPPED		
	9 ITEMS 1			AWG ONLY. ITE	MS TO BE SHIPPED		
	WITT AT	TEICATON.					
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AMP 4805 REV 31MAR2000

/ A R N I N G N INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE ETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE ETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO HE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR ROPER 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)

THIS DRAWING IS A CONTROLLED D IT IS SUBJECT TO CHANGE AND T SHOULD BE CONTACT DIMENSIONS: mm

78 - 7

4 PLC MATERIAL

FINISH

EIGH

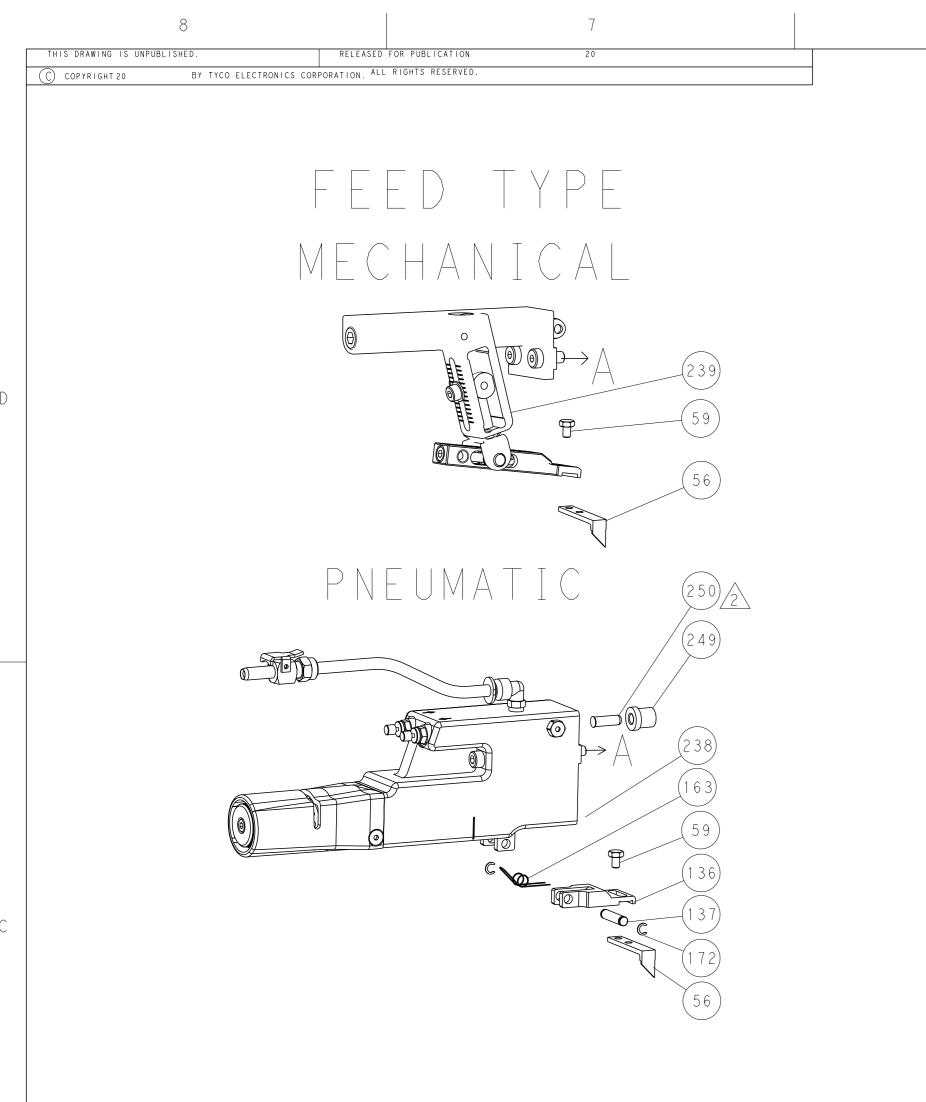
	L						
C	DIST			REVISIONS			
А	66	Р	LTR	DESCRIPTION	DATE	DWN	APVD
	•		А	RELEASED	18JUL2014	GH	ΤE
			В	ECR-16-011438	09AUG2016	КН	LZ
			С	ECR-19-002531	17FEB2019	ТB	СТ
			D	ECR-19-004225	15MAR2019	JAH	GB

	1	-	1	_	2119640-1	PUSH ROD, AIR FEED	250	
ſ	1		1	_	1803259-1	BUSHING, FLANGED	249	
t	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
t	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
\vdash	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	-		AIR FEED MODULE	238	
╞	2	2	1	1			179	
╞	2		1	1		CRIMPER, WIRE		
╞	_	2				CRIMPER, WIRE	178	С
	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT		
	RFF	RFF	REF	REF		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	
ſ	1	1	1	1	1 - 455888 - 0	SPACER, CRIMPER	82	
t	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	
\vdash	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
\vdash	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
╞	1	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	В
ſ	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	D
t	2	2	2	2	2 - 2844962 - 8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
t	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
t	1	1	1	1	455888-3	SPACER, CRIMPER	28	
╞	1	1	1	1	1 3 2 0 9 2 8 - 2	STRIP GUIDE	24	
	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
╞	2	2	2	2			20	
-	1		1	1	1-18028-2	WASHER, FLAT, REG M4		
╞	1		1	1	2119533-3	STRIPPER, SIDE FEED	19	
-					2119806-1	INSERT, SHEAR	13	
	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
	1	1	1	1		STOP, SHEAR		
	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9	
	2	2	1	1	1633916-6	ANVIL, COMBINATION	8	
	-	-	_	-	-	-	7	
t	-		-	-	-	-	6	
t	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
╞	1	. 1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
╞	2	2	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3	
\vdash	1	1	1	1	1-455888-8	SPACER, CRIMPER	2	
$\left \right $	2	2	1	1	4 - 456401 - 4		<u> </u>	
\vdash					4-400401-4	CRIMPER, WIRE .042 F PREMIUM		
-	- 72	-71	- 2	- 1	PART NO	DESCRIPTION	ITEM NO	А
	MENT FOR	TYCO ELEC	TRONICS CORF ERING ORGANI	ORATION ZATION	DWN 3JUNE2014	TE Connectivity		
Ð	FUR THE I	AILST REV	ISTON.		HOFFNER CHK 4JUNE2014			
	01	TOLERAN	CES UNLE SPECIF	SS IED:	T.ELBIN Apvd 4JUNE2014	NAME		
	0 PLC		E-		T.ELBIN PRODUCT SPEC	_ Ocean Side Feed		
7	1 PLC	2 =	E E		-	Applicator		
1	3 PLC 4 PLC	2 =	E		APPLICATION SPEC	SIZE CAGE CODE DRAWING NO REST	RICTED TO	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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RESTRICTED TO -Customer Accessible Production Drawing SCALE 1:2 SHEET 1 4 REV D

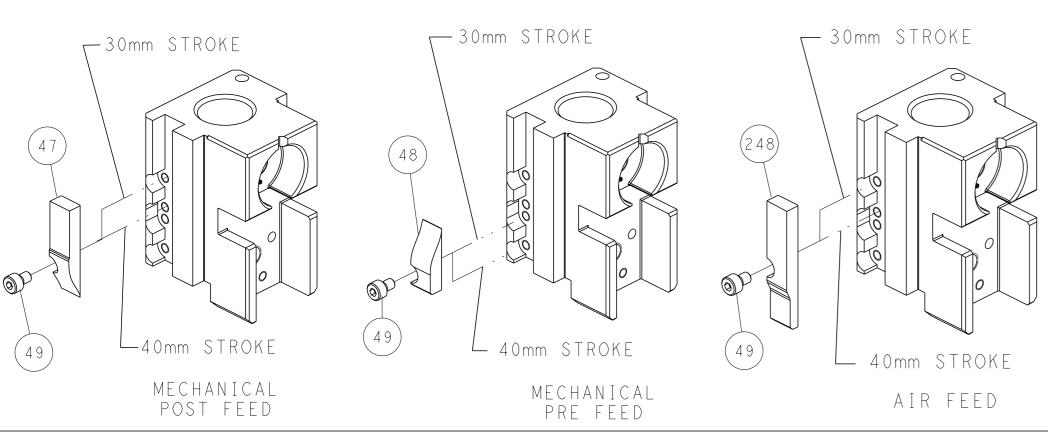


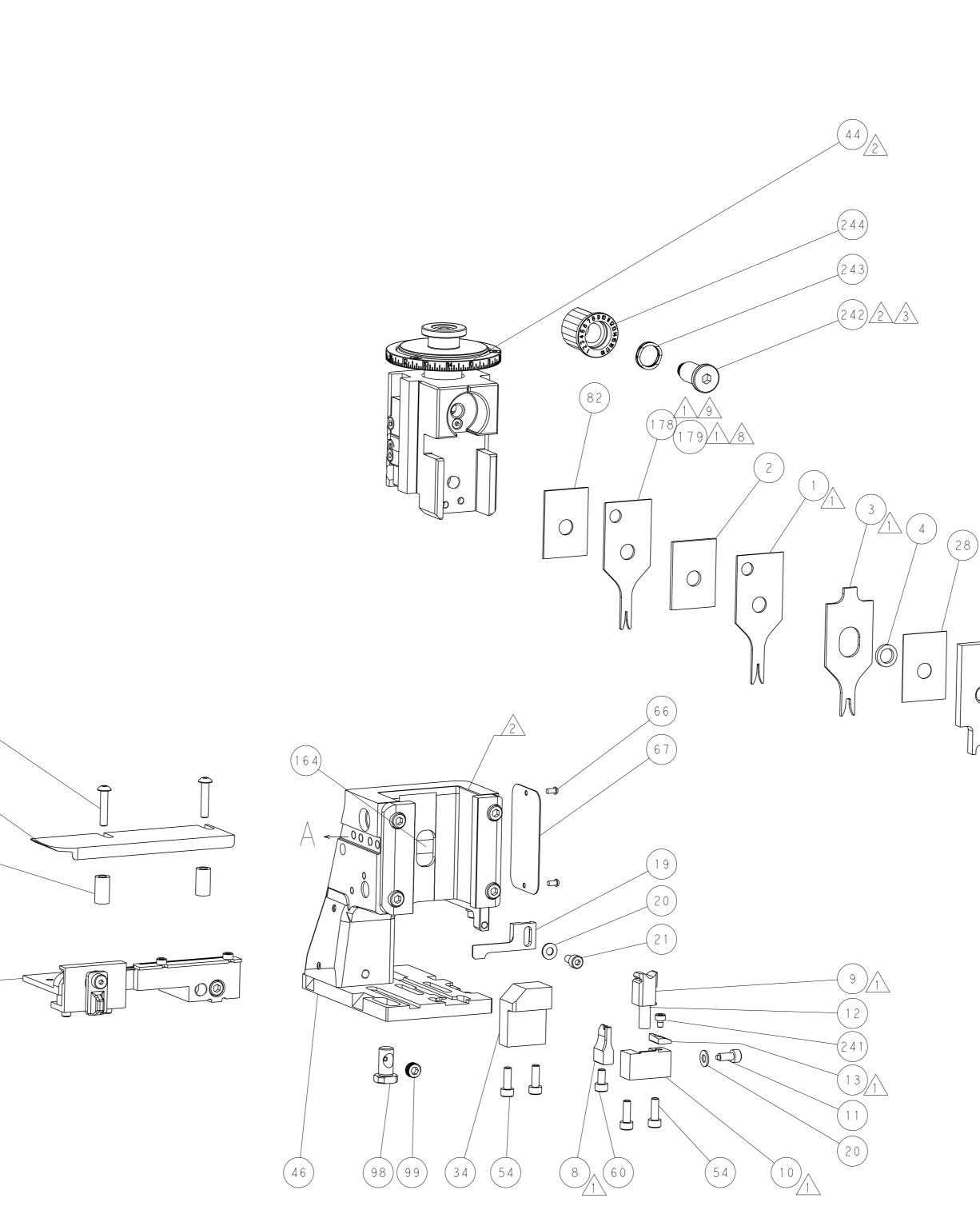


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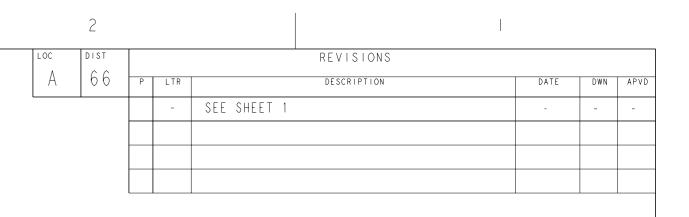
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DIMENSIONS: ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4) mm \bigcirc MATERIAL

3











(34)REF TERMINAL SUPPORT LOCATION (44) REF 44.99±0.05 \bigcirc RAM SET-UP ITEM 30 LOCATED AT FRONT HOLES (30) REF FEED TRACK POSITION GUIDE BY INSULATION BARREL

& \REF

						-				
OCUN HE (ED F	MENT FOR TYCO CONTROLLING EN FOR THE LATEST	ELECTRONIC GINEERING REVISION.	S CORPORATION ORGANIZATION	DWN HOFFNER	3 J U N E 2 O 1 4				TE Connectivity	
				СНК	4 JUNE 2 0 1 4				Harrisburg, PA 17105-3	608
	TOL E OTHERN	RANCES VISE SPE	UNLESS ECIFIED:	T.ELBIN APVD	4 JUNE 2 0 1 4	NAME			5.4	
				T.ELBIN		-			Side Feed	
	0 PLC I PLC	±- ±		PRODUCT SPEC				Арр	plicator	
-	2 PLC 3 PLC	± ± ±		- APPLICATION	SPEC	-			-	
	4 PLC ANGLES	±	_	-		SIZE	CAGE CODE	DRAWING NO		RESTRICTED TO
	FINISH	-		WEIGHT	-	A I	00779	C=226	66321	-
		-		Customer	Accessible P	roduc [.]	tion Draw	ing	SCALE 1:2 SHEET 2	of 4 Rev D
				She	ETS 3 & 4	. ARE	E NOT F	REQUIRE	ED FOR ATLANTIC	C VERSION

THIS DRAWING IS A CONTROLLED DOC IT IS SUBJECT TO CHANGE AND THE SHOULD BE CONTACTED

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THIS DRAWING IS UNPUBLIS			ASED FOR PUBLIC		20				
C COPYRIGHT 20	BY TYCO ELECTRO	NICS CORPORATION	ALL RIGHTS RE	ESERVED.					T C C L L L L L C C L L L L L C C L L L L L C C L L L L L L L L L L
P A R T N U M B E R	REVISION		DESCRIF	PTION	FE	ED TYPE		IC VERSION NTERFACE A	TERMINATOR ADAPTER 1
2-2266321-1	D	FINE CR	RIMP HE	IGHT ADJUST	MEC	HANICAL	_		
2 - 2 2 6 6 3 2 1 - 2	D	FINE CR	RIMP HE	IGHT ADJUST	PN	EUMATIC			\$
7-2266321-*	-	SEE CRIM	P TOOLI	NG KITS BELOW	/	-			
APP	LICATOR	DATA		PART NO) Rev	WIRE	WIRE	STABILIZER	
CRIMP	SIZ	E	TYPE			SIZE	CRIMPER	CRIMPER	CRIMPER
WIRE	1.07 mm [.042]	F	7-2266321		22 AWG	9-1633609-5	4 - 4 5 6 4 0 1 - 4	2-2119582-1
STABILIZER	1.07 mm [.042]	F	7-2266321	-8 B	24-26 AWG	9 - 1 6 3 3 6 0 9 - 4	4 - 4 5 6 4 0 1 - 4	2-2119582-1
INSULATION	2.79 mm [.110]	F						
APPLICATOR 408	R INSTRUC 3-35042	TIONS							
TERMINAL DATA	A: TE TFR	MINAL		TE CRIMP S	PFCIFIC	CATION			
			TEDM						
TERMINAL NAME		AMP - IN	1						
WIRE STRIP			I N S	SULATION DIAM	ETER RA	NGE	· · · · · ·		
4.45-5.21 mm [.1	75205 [N]		Ø1.	02-2.54 mm [.0	40100 I	N]	STABI CRIMP H		

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TE TERMINAL

TERMINALS APPLIED TE TERMINAL TE TERMINAL

114-1016

-

TERMINAL APPLICATION

SPECIFICATION

3 - 6 4 0 4 0 1 - 1

STABILIZER		
CRIMP HEIGHT	WIRE	
		ΗĿ

WIRE SIZE 🛞 🕇 🗐	CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT 4 REFERENCE SETTING
7 22 AWG	0.89+/-0.05 [.035+/002]	1.02 ± 0.05 (0.40±.002)	6.7
7 24-26 AWG	0.74+/-0.05 [.029+/002]	$(1.02\pm0.05)(0.40\pm.002)$	6.5

-

-

TE TERMINAL

AMP 4805 REV 31MAR2000

1 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.

A 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.

1 TERMINAL LUBRICANT IS RECOMMENDED.

6. 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.

/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.

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

3

THIS DRAWING IS A CONTROLLED DO IT IS SUBJECT TO CHANGE AND TH SHOULD BE CONTACTE DIMENSIONS: mm MATERIAL

*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.

IEIGHT

ANVIL 1633916-6 1633916-6

	_			2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	1	_	2063440-1	AIR FEED MODULE	238
-	1	1	1	9-1633609-5	CRIMPER, WIRE	• 179
1	_	1	1	9 - 1 6 3 3 6 0 9 - 4	CRIMPER, WIRE	178
-	_	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	
-	_	REF				
-		KEF	REF		COUNTER, MAGNETIC	164
-	-]	-	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	· 1 4 1
_			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			
-	-	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	1 3 3 8 6 8 5 - 1	PAWL, FEED	56
			2			
-	-	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 - 1 8 0 2 8 - 2	WASHER, FLAT, REG M4	20
_	_	1	1	2119533-3	STRIPPER, SIDE FEED	19
		1	1			13
-	-			2119806-1	INSERT, SHEAR	_
-	-	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	1	1633916-6	ANVIL, COMBINATION	. 8
	1	1		1033310 0	ANVIL, COMDINATION	. 7
-	-	-	-	-	-	
-	-	-	-	-	-	6
-	-	1	1	2119757-4	DEPRESSOR, SHEAR	. 5
-	-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	· 4
-	1	1	1	2 - 2119582 - 1	CRIMPER, INSULATION F PREMIUM	3
_	_	1	1	1-455888-8	SPACER, CRIMPER	· 2
	-	4	4			· 1
-	1	1		4 - 4 5 6 4 0 1 - 4	CRIMPER, WIRE .042 F PREMIUM	
				PART NO	DESCRIPTION	I T E M N O
OCUMENT FOI THE CONTROLI TED FOR THF	TYCO ELECT ING ENGINEE	RONICS CORP RING ORGANI SION.	ORATION ZATION	DWN 3JUNE2014 HOFFNER	TE Connectivity	
	. LOT NEVI			снк 4JUNE2014		
	TOLERAN	CES UNLE SPECIFI	SS FD·	<u>T.ELBIN</u> Apvd 4JUNE2014		
			L	T.ELBIN PRODUCT SPEC	_ Ocean Side Feed	
O PL	C d	E-		NUDUCI SEEC	Applicator	
2 PL 3 PL		E E	F	- APPLICATION SPEC		
4 PL	C d	- - 		-	SIZE CAGE CODE DRAWING NO RE	STRICTED TO
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	-		Ε	Customer Accessible f	Production Drawing SCALE 1:2 SHEET 3 OF 4	REV

2119640-1

1803259-1

2119082-8

2079764-1

2119083-1

7 - 1 8 0 2 3 - 7

2119580-1

1

1 1 1

1 1 1

REVISIONS A 66 DESCRIPTION DATE DWN APV SEE SHEET 1

PUSH ROD, AIR FEED

CAM, SNAIL, INSULATION ADJUSTMENT

RETAINER, INSULATION DIAL

SCR, SKT HD CAP M3 X 4.0

MECHANICAL FEED ASSEMBLY

WASHER, WAVE SPRING, CREST-TO-CREST

BUSHING, FLANGED

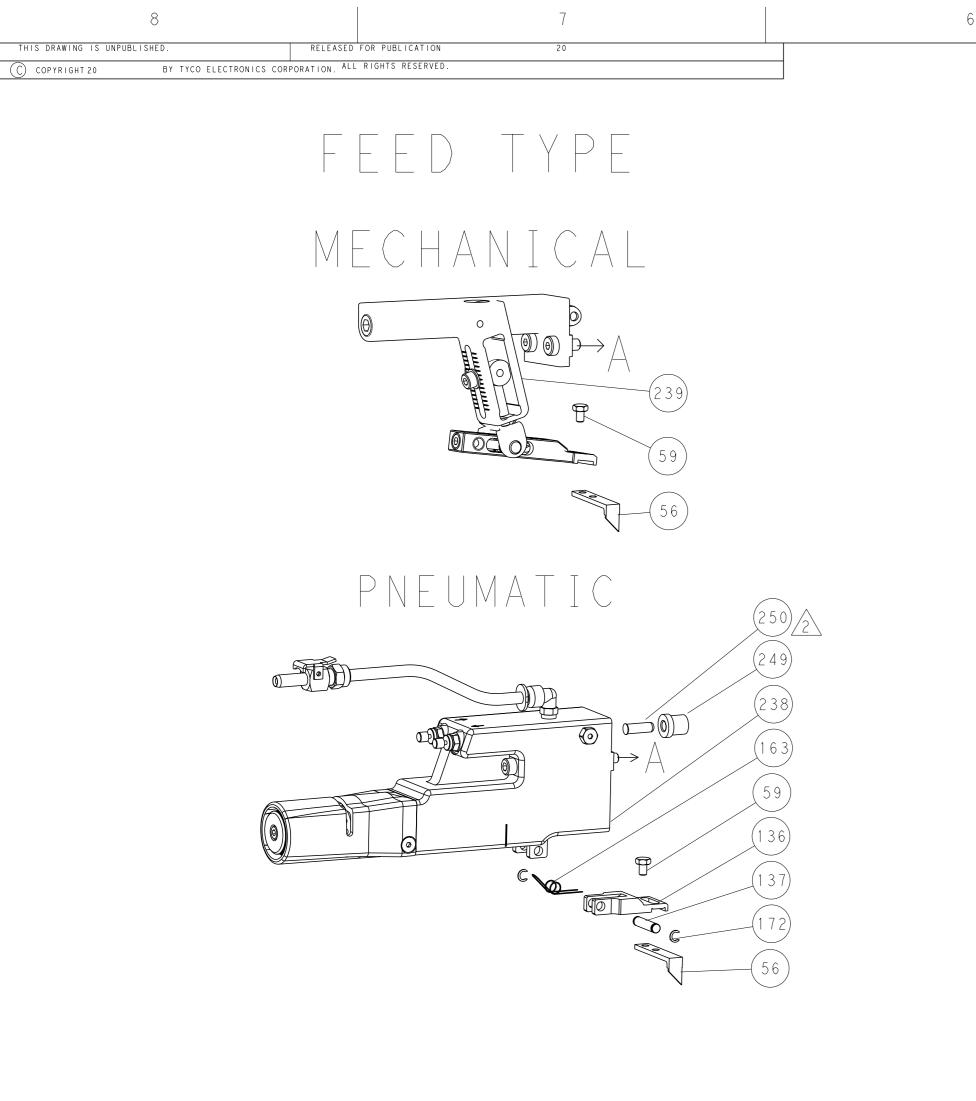
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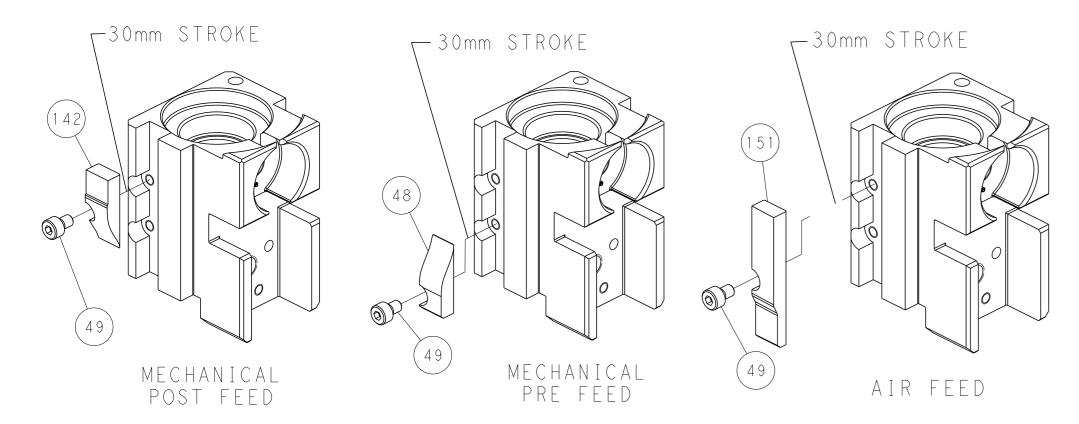




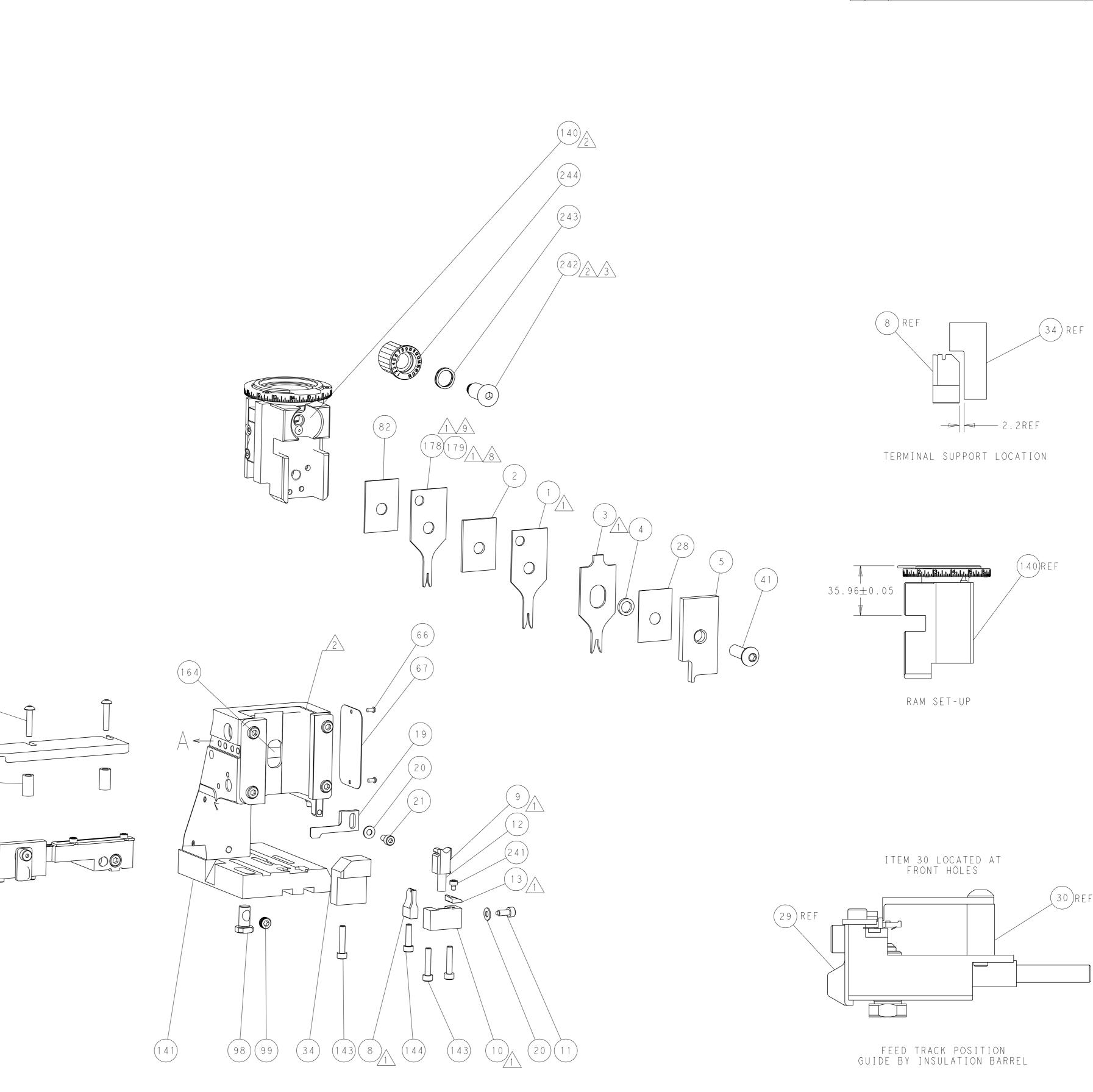
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CAM POSITIONS



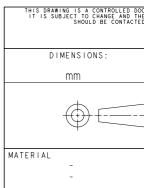
AMP 4805 REV 31MAR2000

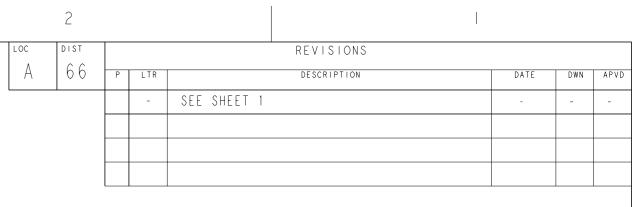


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PACIFIC VERSION Shown on sheets 3 of 4 & 4 of 4 (Atlantic version shown on sheets 1 of 4 & 2 of 4)











DOCUMENT FOR TYCO ELECTRONICS CORPORATION THE CONTROLLING ENGINEERING ORGANIZATION TED FOR THE LATEST REVISION.	DWN HOFFNER	3 J U N E 2 O 1 4				TE Connect	i v i t y		
	снк T.ELBIN	4 JUNE 2 0 1 4	——————————————————————————————————————						3
TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD T.ELBIN	4 JUNE 2 0 1 4	NAME		Ocear	n Side F	eed		
0 PLC ±- I PLC ±	PRODUCT SPEC					plicato			
$\begin{array}{c c} 2 & PLC & \pm \\ 3 & PLC & \pm \\ 4 & PLC & \pm \end{array}$	- APPLICATION S	PEC				-			
ANGLES ±-	-		SIZE	CAGE CODE	DRAWING NO				RESTRICTED TO
FINISH -	WEIGHT	-	AI	00779	C=22	66321			-
-	Customer /	Accessible Pr	oduct	tion Draw	ing	scale 1:2	SHEET	4 ^{OF}	4 REV D
	SH	FFTS 1 &	2 A F	RE NOT	REQUI	RED FOR	PACI	FIC	VERSION

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