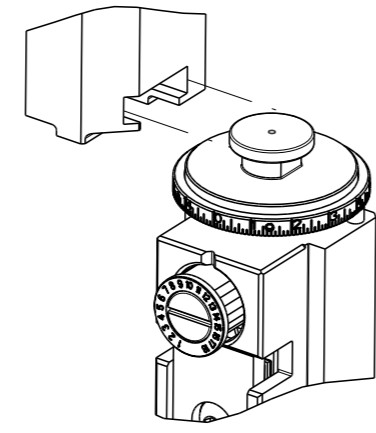


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2266240-1 | F | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2266240-2 | F | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266240-1 | F | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2266240-2 | F | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2266240-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

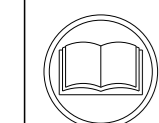


| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.16 mm [.046] | F |
| INSUL | 1.22 mm [.048] | F |

APPLICATOR INSTRUCTIONS
408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|-------------|------------------------------|-------------|
| TERMINAL NAME: REC. CONTACT MICRO MOTOR CONNECTOR | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 1.60-2.00 mm [.063-.079 IN] | | Ø1.00-1.20 mm [.039-.047 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-5335 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1674335-1 | 1674335-2 | 1674335-3 | 1674335-4 |
| 2174065-2 | 2174065-4 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------------------|-------------------------------|--------------------------------|
| 22 AWG OR 0.33mm ² | 0.82 +/- 0.03 [.032 +/- .001] | 4.0 |
| 24 AWG OR 0.20mm ² | 0.75 +/- 0.03 [.030 +/- .001] | 4.8 |
| 26 AWG OR 0.13mm ² | 0.69 +/- 0.03 [.027 +/- .001] | 5.4 |



- 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.

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

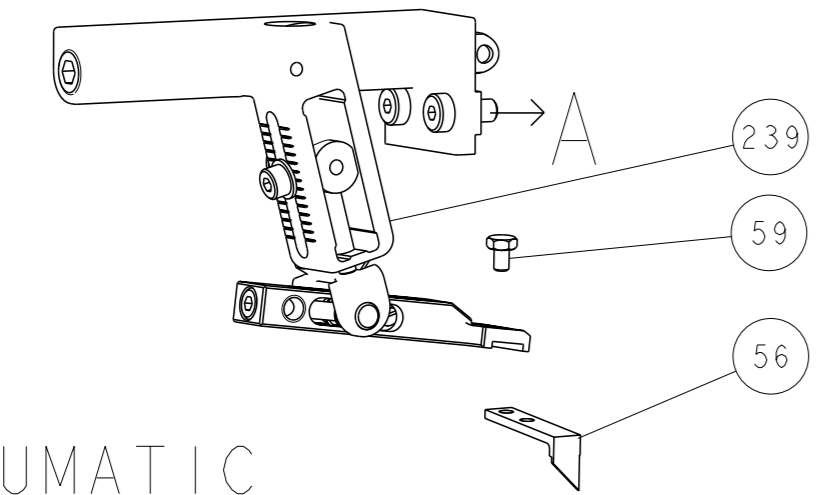
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| | | REV | DATE | BY | CHKD |
| A | 66 | D | 15MAY2018 | FZ | KZ |
| | | E | 22JAN2019 | FJ | YY |
| | | E1 | 20SEP2019 | FZ | RR |
| | | F | 10AUG2021 | FJ | RR |

| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-------------------------------|---------|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 1 | 1 | 2119082-5 | 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 | - | 2844940-1 | AIR FEED MODULE | 238 | |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 | |
| - | 1 | 1 | 1 | 1 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 | |
| - | 1 | 1 | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 | |
| - | 1 | 1 | 1 | 1 | 2844907-1 | POST, LOCKING | 98 | |
| - | 1 | 1 | 1 | 1 | 1-455888-4 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 5-547505-2 | SPRING, COMPRESSION | 77 | |
| - | 1 | 1 | 1 | 1 | 854769-4 | HOLDER, INS | 74 | |
| - | 1 | 1 | 1 | 1 | 1803607-3 | 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 | 21028-2 | PIN, SLOTTED SPRING .062 X .250 | 58 | |
| - | 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 | 3-1752356-9 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2 | 2 | 2-2844962-4 | 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 | 1-356885-5 | 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 | 8-1633927-0 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 2119780-3 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 1-238011-0 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 2 | 2 | 1 | 1 | 6-1633962-1 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | - | - | - | - | - | - | 2 | |
| - | 1 | 2 | 2 | 1 | 1 | 5-1633713-2 | CRIMPER, WIRE PREMIUM | 1 |
| - | 77 | 72 | 71 | 72 | -1 | PART NO | DESCRIPTION | ITEM NO |

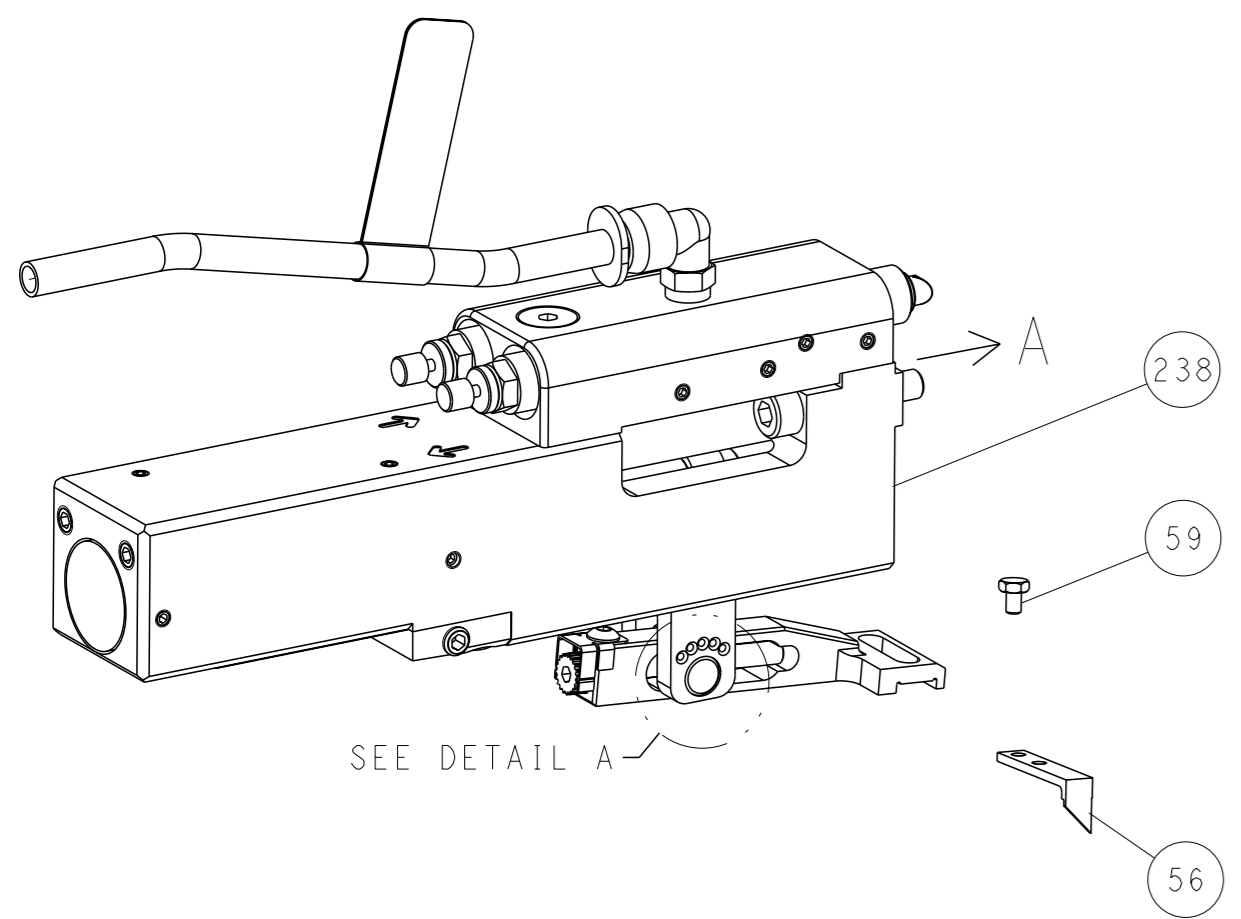
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|-------------|---------|--|---------|---------|---------|--------|---------------------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | APVD | TE Connectivity |
| | ANGLES | FINISH | | | | | Harrisburg, PA 17105-3608 |
| MATERIAL | | | | WEIGHT | SCALE | SHEET | REV |
| | | | | | 1:2 | 1 OF 4 | F |

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

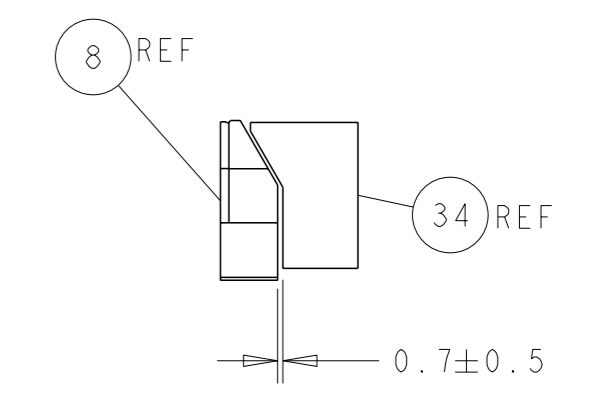
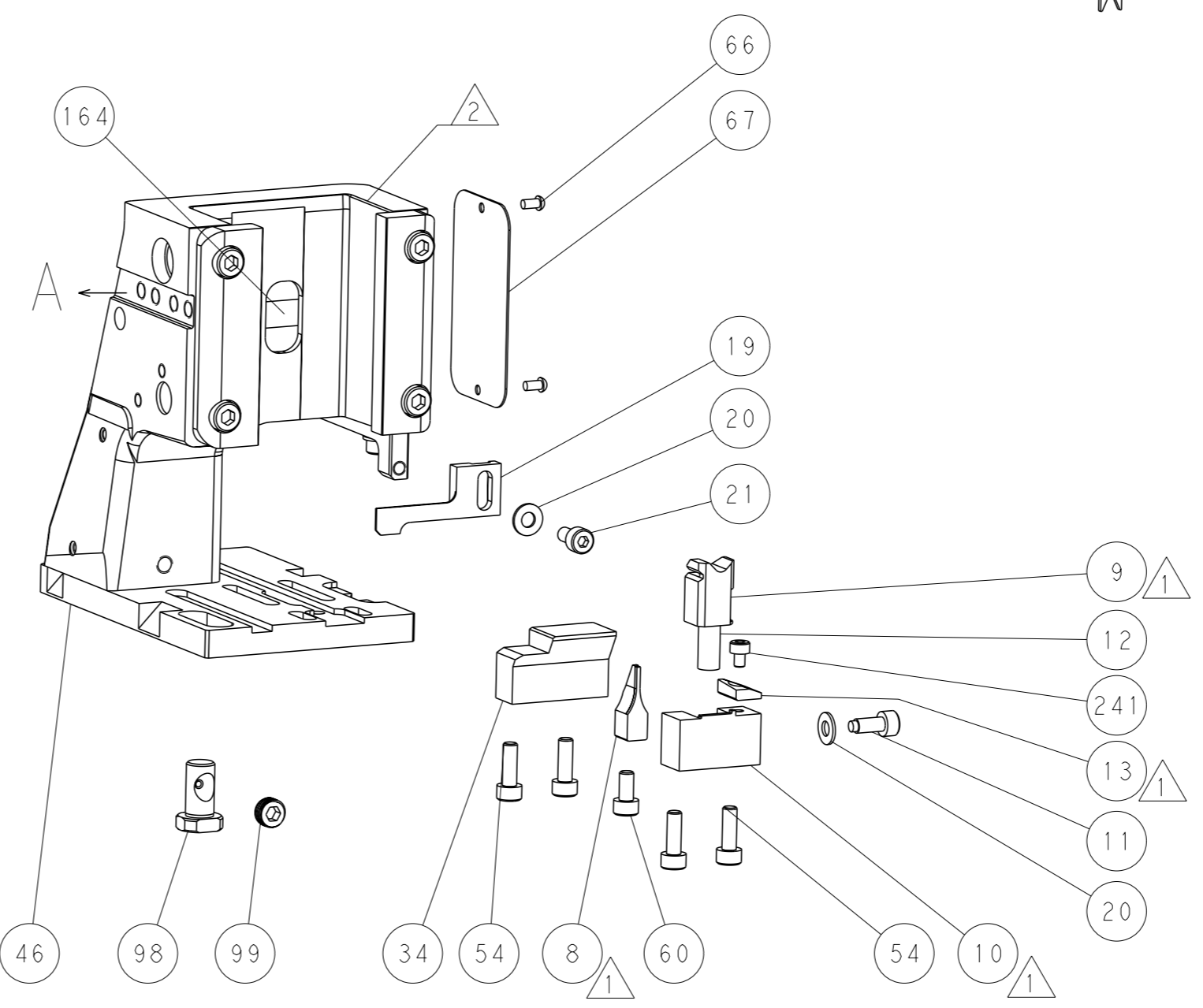
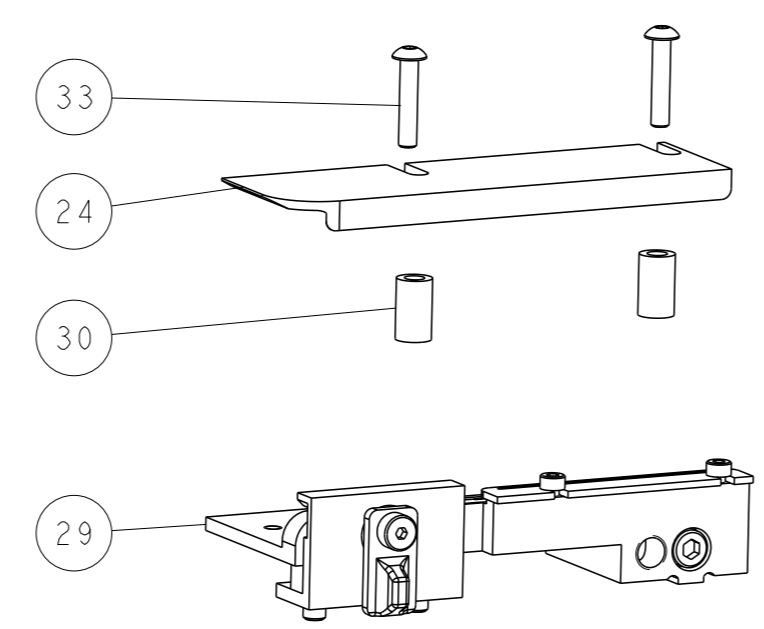
FEED TYPE MECHANICAL



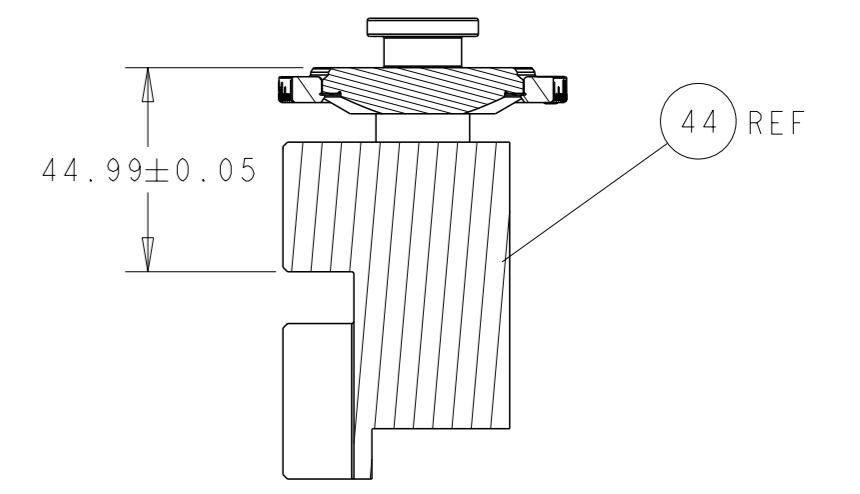
PNEUMATIC



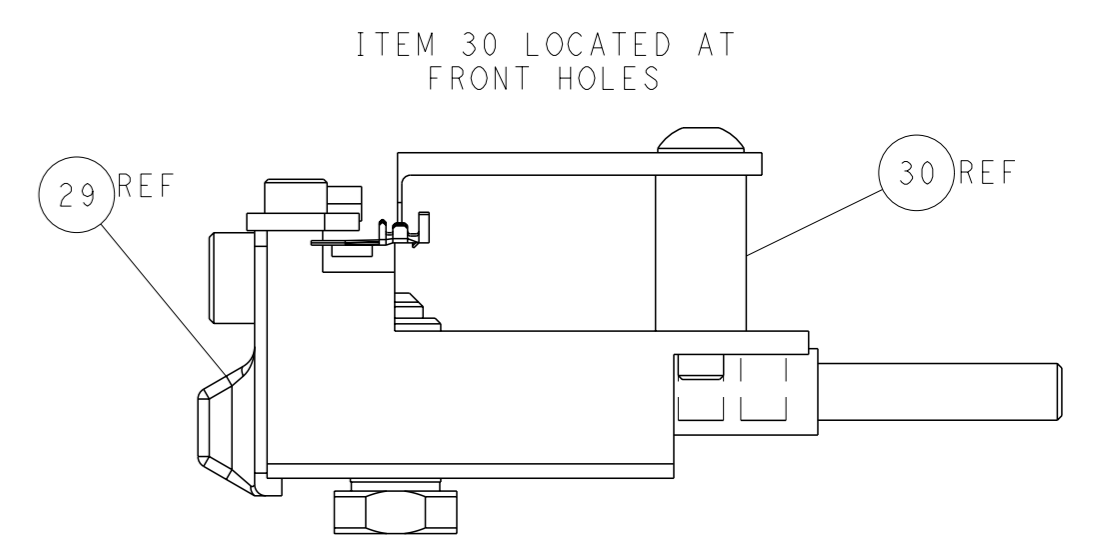
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

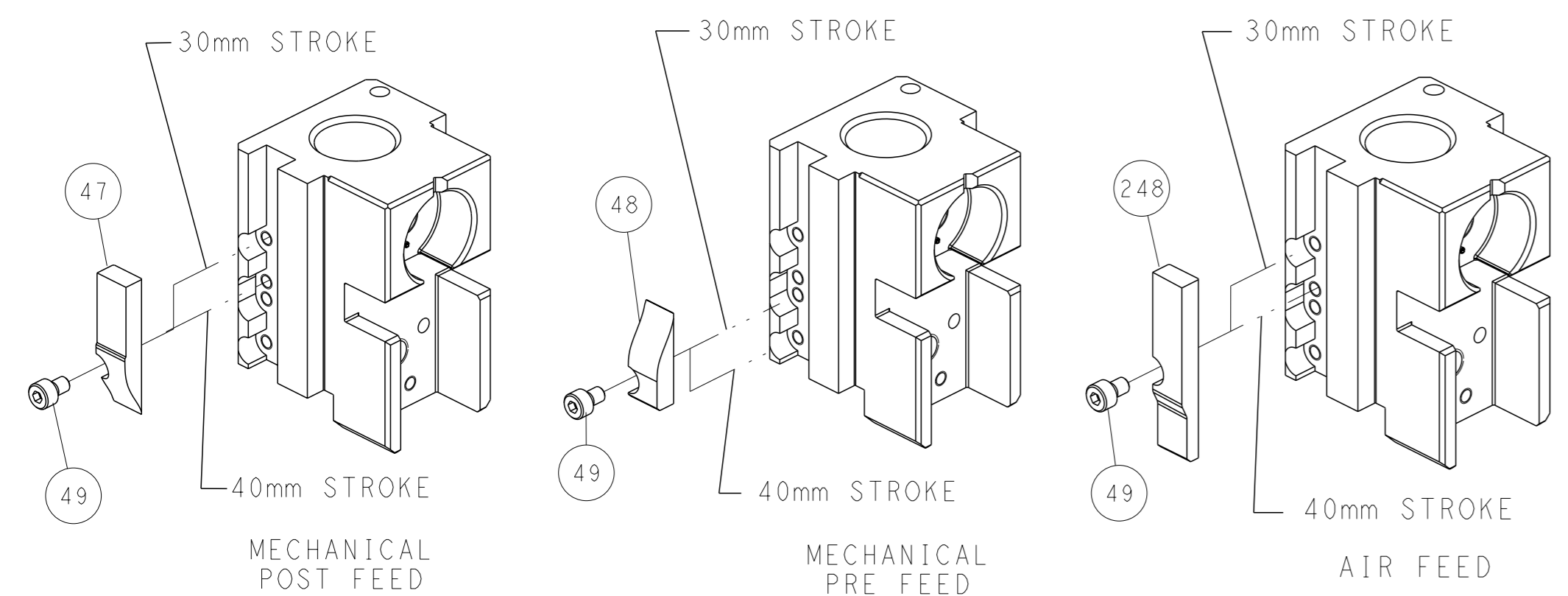


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

CAM POSITIONS

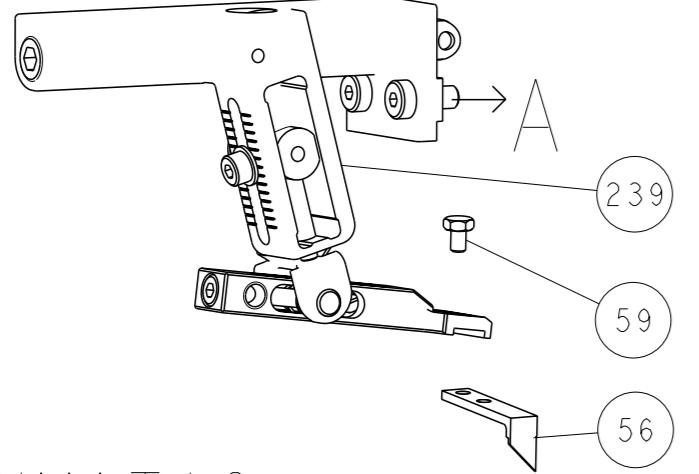


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

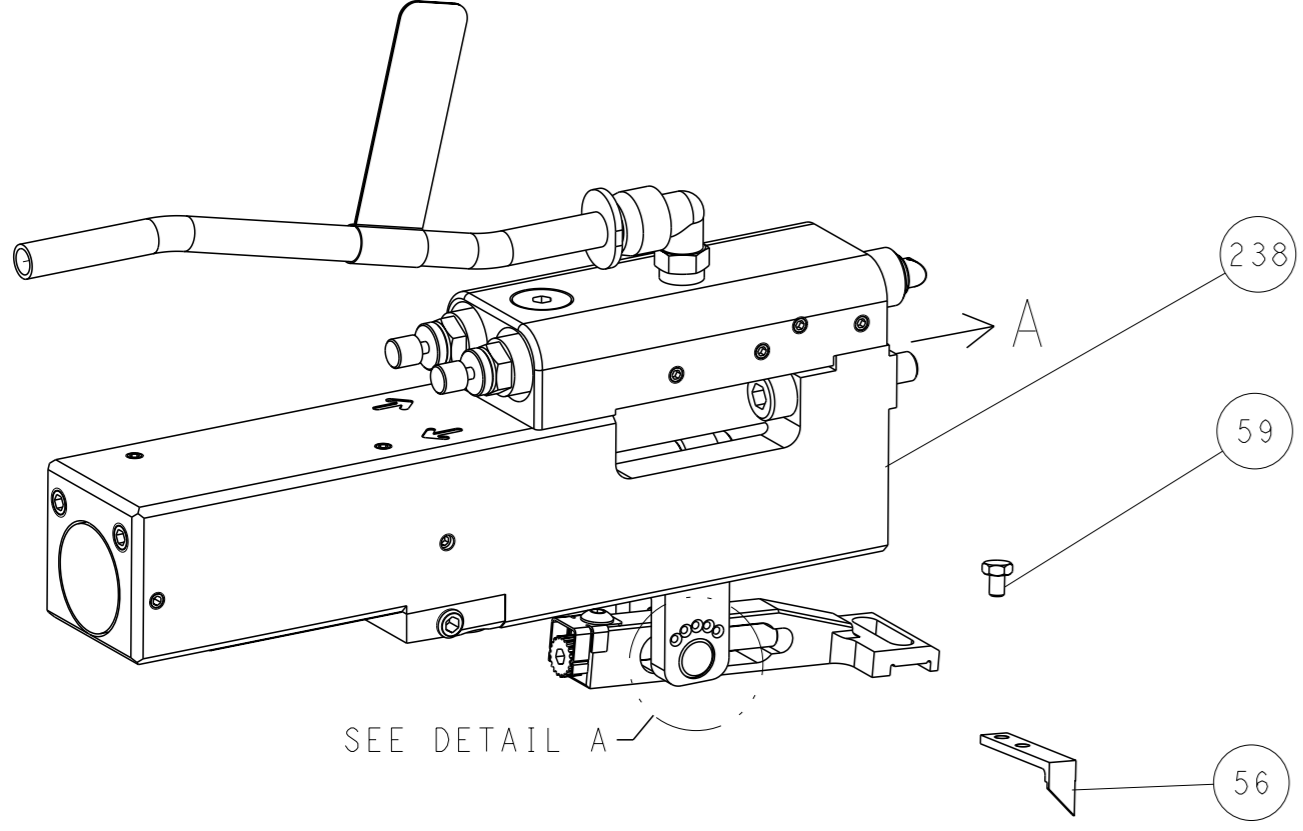
| | | | | |
|---|--|---|--|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: X. ZHAO CHK: L. ZHANG APVD: J. ELBIN PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: - | Z1MAR2014 Z1MAR2014 Z1MAR2014 - - - - - | TE Connectivity Harrisburg, PA 17105-3608 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266240 SCALE: 1:2 SHEET: 2 of 4 REV: F |
|---|--|---|--|--|

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

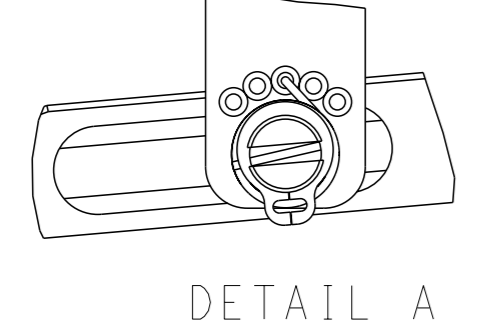
FEED TYPE MECHANICAL



PNEUMATIC

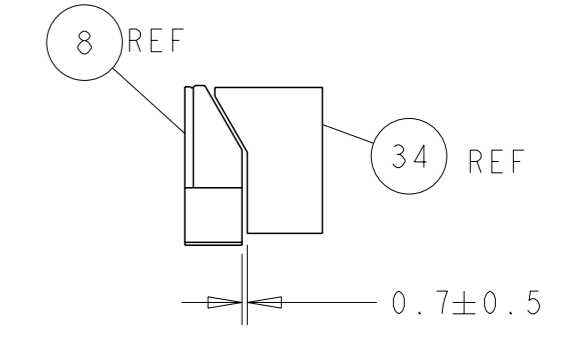
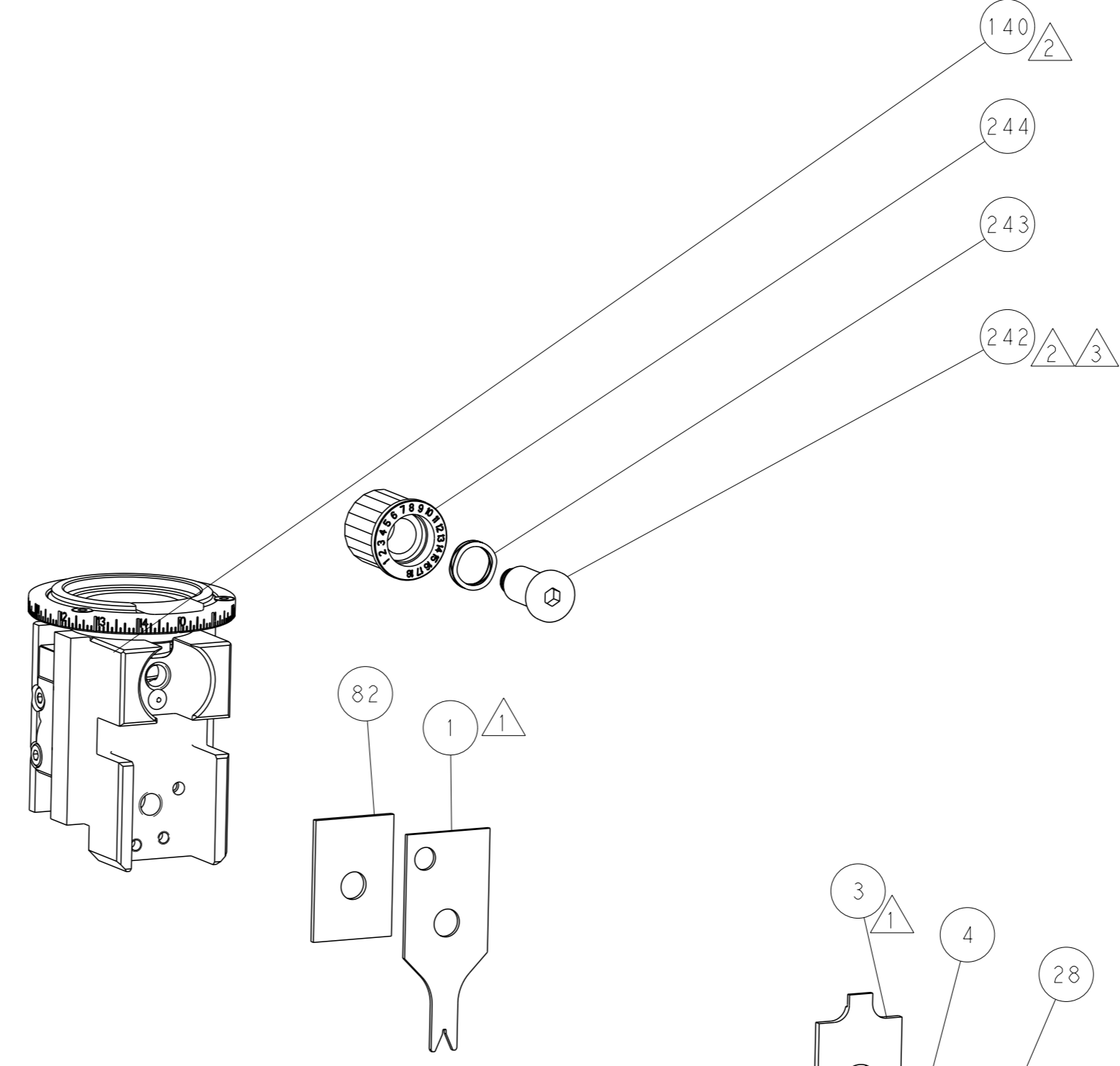
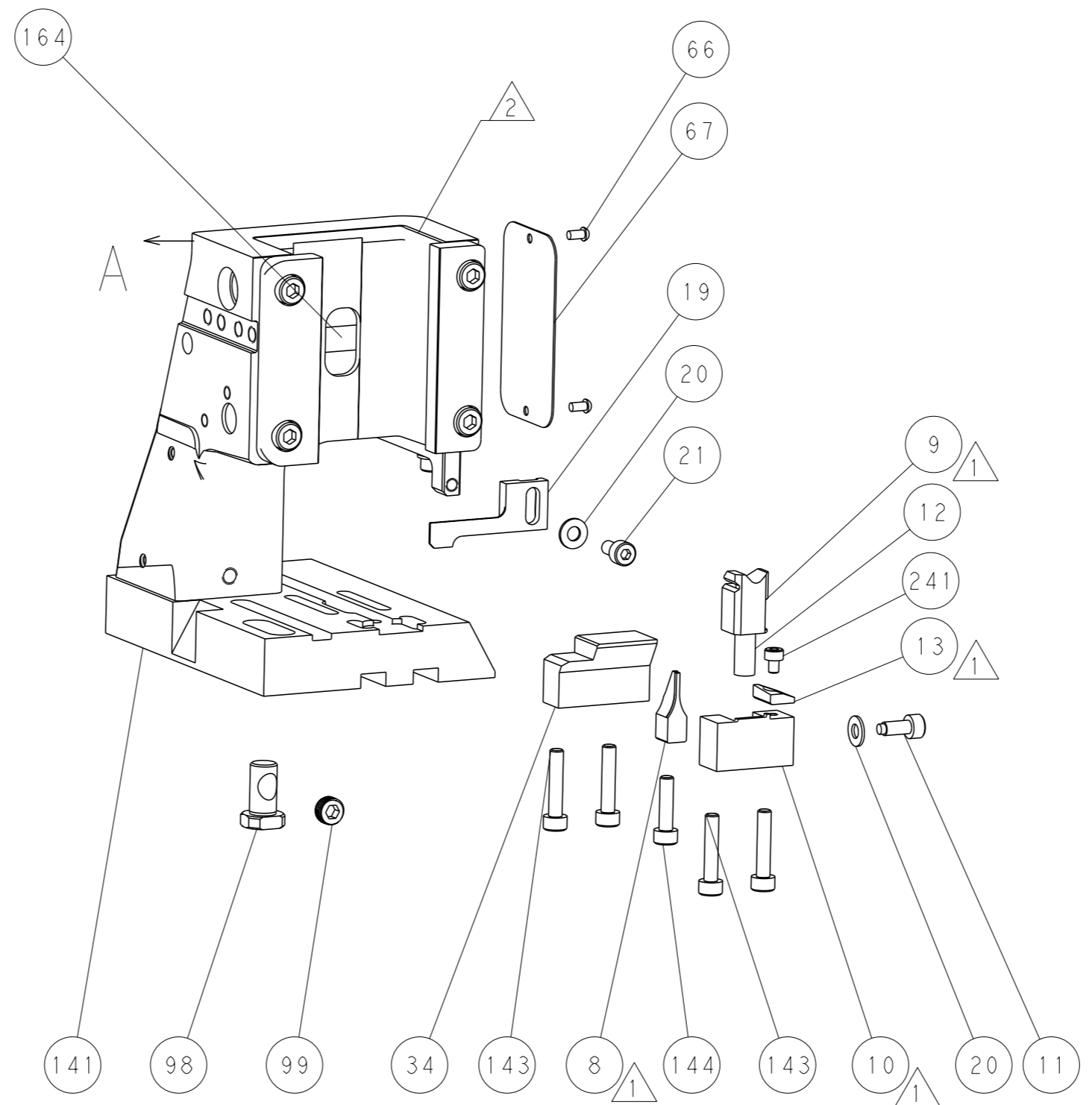
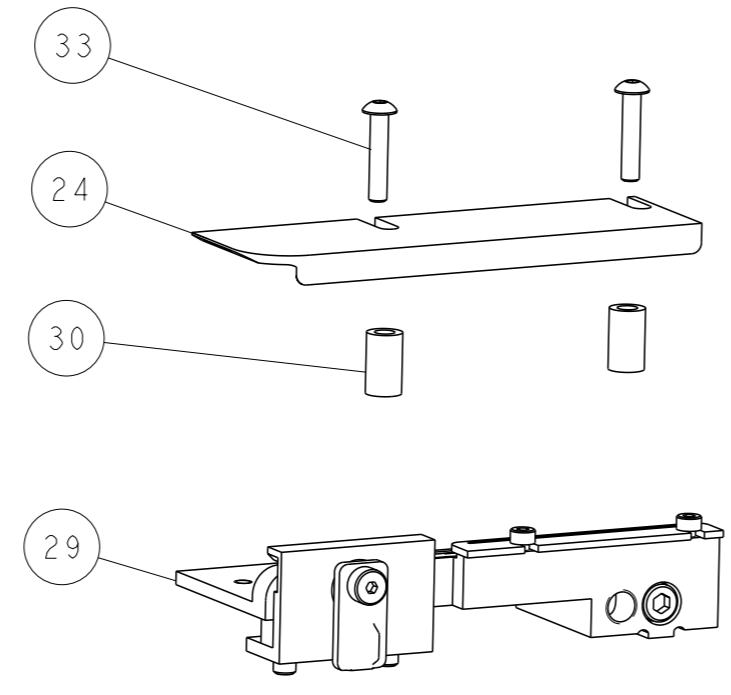
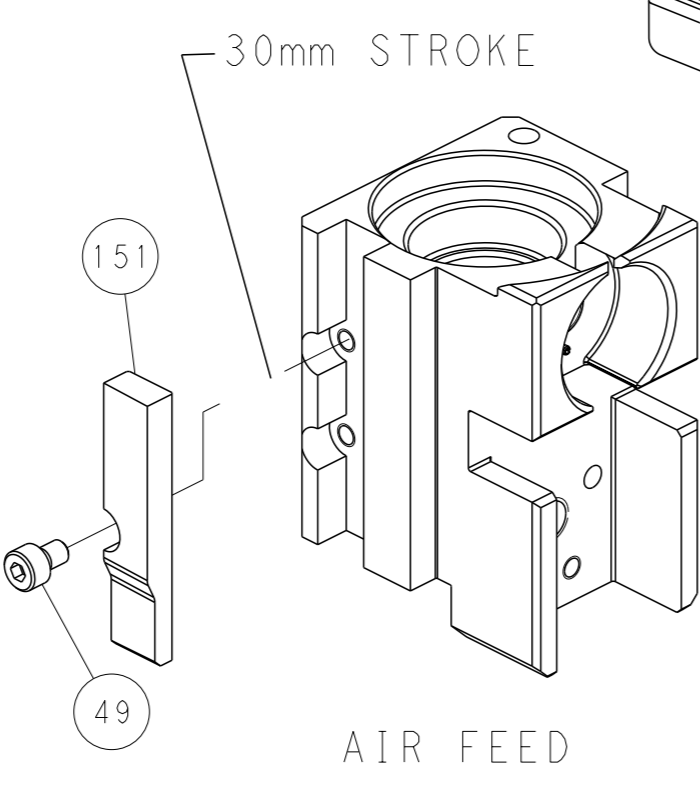
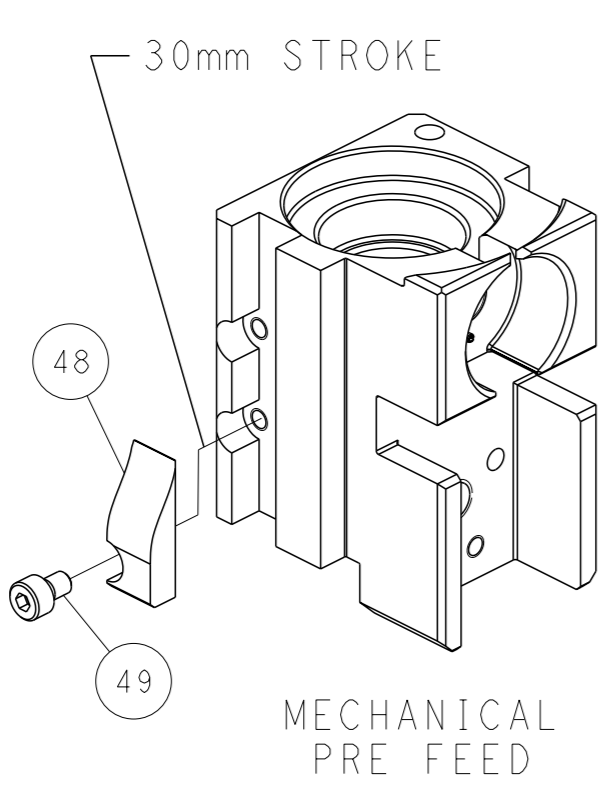
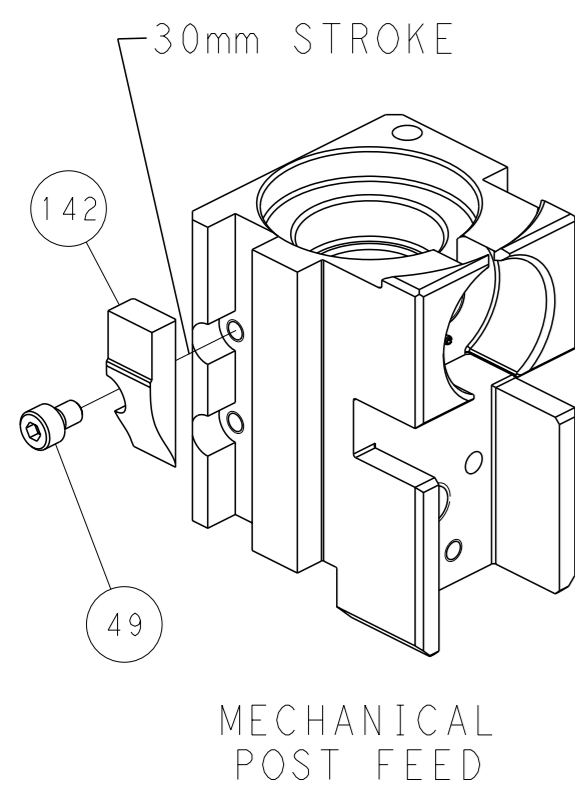


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

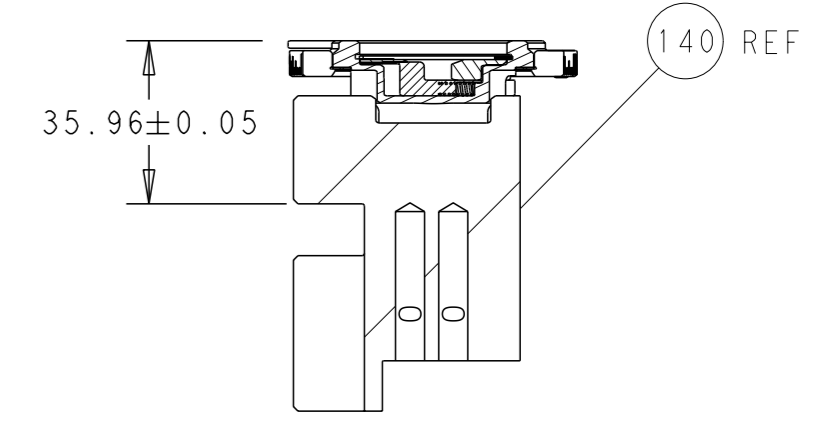


DETAIL A

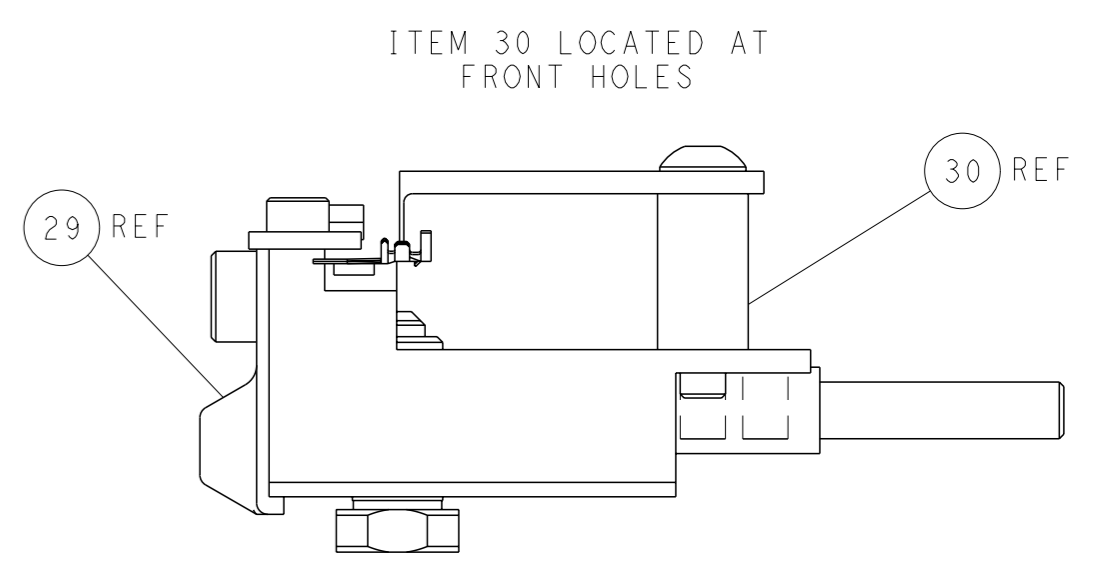
CAM POSITIONS



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)

| | | | | | |
|---|--------------------------|---|-------------------------------------|---|---|
| <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: X. ZHAO CHK: L. ZHANG APVD: J. ELBIN | Z1MAR2014 Z1MAR2014 Z1MAR2014 | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266240 | RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: F |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | WEIGHT: - MATERIAL: - | APPLICATION SPEC: - PRODUCT SPEC: - | DATE: - DATE: - DATE: - | DATE: - DATE: - DATE: - | DATE: - DATE: - DATE: - |