

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266170-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266170-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266170-7	A	CRIMP TOOLING KIT	-

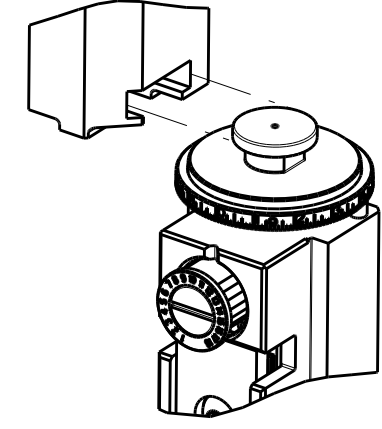
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE 1	2.79 mm [.110]	0
WIRE 2	2.92 mm [.115]	0
INSUL	3.56 mm [.140]	0

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: OUTER FERRULE, 180 DEGREE, FAKRA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	$\varnothing 2.54-3.20$ mm [.100-.126 IN]
TERMINAL APPLICATION SPECIFICATION 114-32145			
TERMINALS APPLIED 5			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2203259-2	2326889-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.5DS - QFB (TA)	2.84 +/- 0.03 [.112 +/- .001]	9.3

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



- 1 RECOMMENDED SPARE PARTS
  - 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
  - 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
  - 6 SEE APPLICATION SPECIFICATION, 114-32145 FOR SOLDER DIAMETER TO VERIFY BRAID CRIMP HEIGHT.
  - 7 ITEM 1 WIRE CRIMP WIDTH 2.79mm [.110 IN].
  - 8 ITEM 178 WIRE CRIMP WIDTH 2.92mm [.115 IN].
  - 9 SEE APPLICATION SPECIFICATION 114-32145 FOR RECOMMENDED STRIP LENGTH DIMENSIONS.
10. 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	REV	DATE	BY	CHK
		C1	ECR-18-017084	29OCT2018	JAH TE
		C2	ECR-18-019989	21DEC2018	TB GB
		D	ECR-19-005659	08APR2019	LG TE
		D1	ECR-19-012142	01AUG2019	FJ RK

-	1	1	1803078-3	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-6	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	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2844940-1	AIR FEED MODULE	238	
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	225	
-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	224	
-	1	1	1803306-1	PLATE, RETAINING	223	
-	1	1	1803340-1	PLATE, RETAINING	222	
3	-	1	1	1752354-6	STANDOFF, HOLD-DOWN	180
-	1	1	2-1976053-6	LOCATER BLOCK, TERMINAL	179	
8 1	-	1	1	1-1633723-9	CRIMPER, WIRE 0	178
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1	1-455888-0	SPACER, CRIMPER	82	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	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	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1901681-8	HOLDDOWN, TERMINAL	51	
-	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	1803308-1	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1320928-2	STRIP GUIDE	24	
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	2	1	1803160-4	ANVIL	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4	
1	1	2	1	3-1633996-1	CRIMPER, INSULATION SPECIAL	3
-	1	1	1-455888-8	SPACER, CRIMPER	2	
1	1	2	1	1-1633723-7	CRIMPER, WIRE 0	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		SCALE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL				FINISH			
WEIGHT				SCALE			
SHEET				REV			

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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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266170-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266170-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE 1	2.79 mm [.110]	○
WIRE 2	2.92 mm [.115]	○
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APPLICATOR INSTRUCTIONS 408-35042		

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TERMINAL APPLICATION SPECIFICATION	114-32145		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2203259-2	2326889-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.5DS - OFB (TA)	2.84 +/- 0.03 [.112 +/- .001]	9.3



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LOC	DIST	REV	DATE	BY	APPD
A	66				

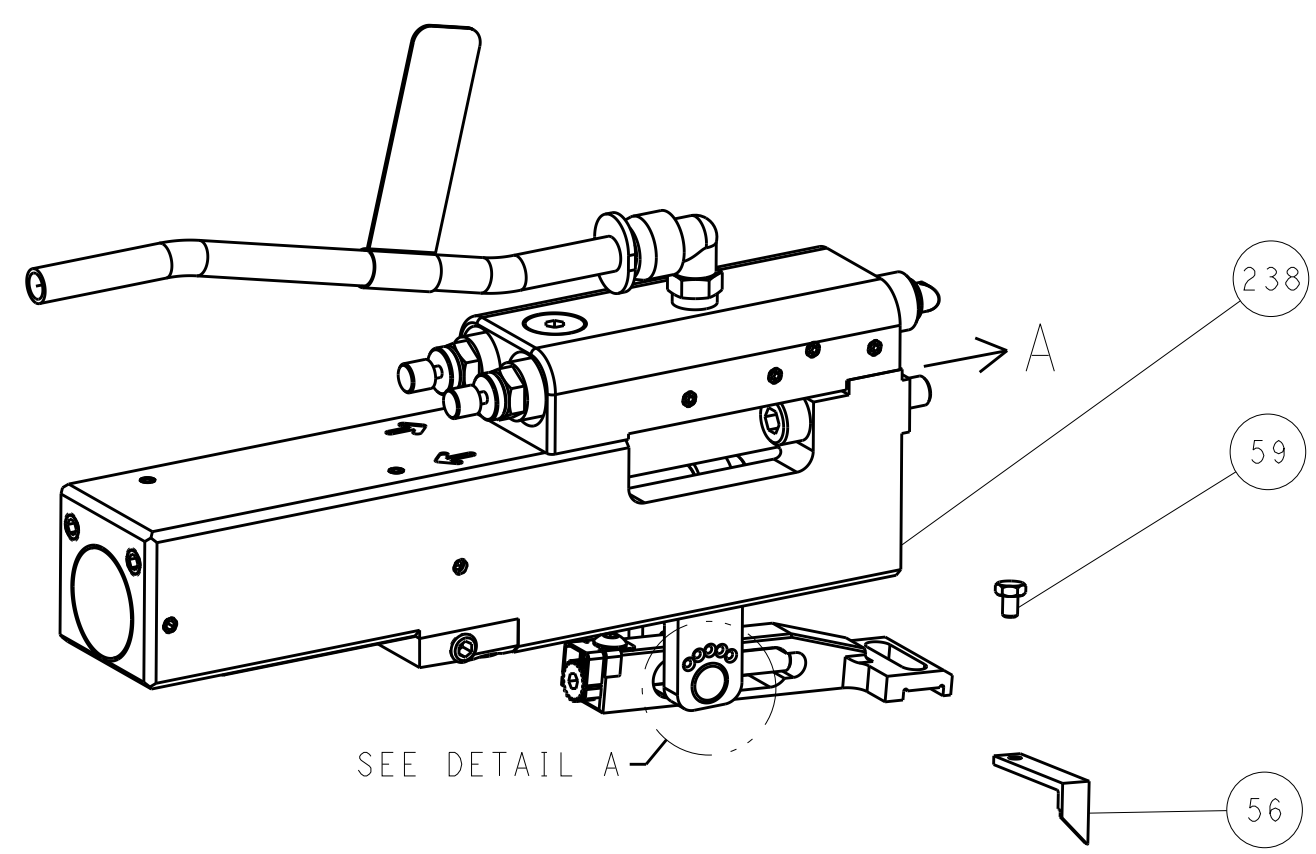
REV	DATE	BY	APPD	DESCRIPTION	QTY
-	1			1803078-3 SPACER, PRECISION	259
-	1			2119082-6 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1			2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1			2119083-1 RETAINER, INSULATION DIAL	242
-	1			7-18023-7 SCR, SKT HD CAP M3 X 4.0	241
-	1			2844940-1 AIR FEED MODULE	238
-	2			1-2079383-0 SCR, BHSC, RoHS (M3 X 6)	230
-	2			2079383-4 SCR, BHSC, RoHS (M4 X 8)	225
-	2			1-2168083-4 SCR, SKT HD CAP, RoHS, M4 X 5	224
-	1			1803306-1 PLATE, RETAINING	223
-	1			1803340-1 PLATE, RETAINING	222
-	1			1752354-6 STANDOFF, HOLD-DOWN	180
-	1			2-1976053-6 LOCATER BLOCK, TERMINAL	179
-	1			1-1633723-9 CRIMPER, WIRE O	178
-	1			6-993111-6 PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1			8-22280-7 SPRING, COMPRESSION	176
-	1			1752353-2 GUIDE PIN, HOLDDOWN	175
-	1			1901680-2 GUIDE PIN, HOLDDOWN	174
-	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			2844908-1 SCREW, LOCKING	99
-	1			2844907-1 POST, LOCKING	98
-	1			318563-1 GUARD, FRONT CHIP	89
-	1			1-455888-0 SPACER, CRIMPER	82
-	1			1803607-3 DOCUMENTATION PACKAGE	71
-	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
-	1			1-5018030-0 NUT, HEX, REG, RoHS, M3.5	52
-	1			1901681-8 HOLDDOWN, TERMINAL	51
-	1			18023-9 SCR, SKT HD CAP M4 X 6.0	49
-	1			1803602-2 SCR, BHSC, RoHS (M8 X 40)	41
-	1			1803308-1 SUPPORT, TERMINAL	34
-	2			2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2			3-2844962-0 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1			2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1			1-455888-0 SPACER, CRIMPER	28
-	1			1320928-2 STRIP GUIDE	24
-	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			1803095-1 FLOATING SHEAR, FRONT	9
-	1			1803160-4 ANVIL	8
-	-			-	7
-	-			-	6
-	1			1-2119757-2 DEPRESSOR, SHEAR	5
-	1			3-238011-8 BLOCK, CRIMPER SPACER	4
-	1			3-1633996-1 CRIMPER, INSULATION SPECIAL	3
-	1			1-455888-8 SPACER, CRIMPER	2
-	1			1-1633723-7 CRIMPER, WIRE O	1

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

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: R.O. WILSON 21NOV2013		CHK: K.J. STAKEM 21NOV2013		APVD: T.L. ELBIN 21NOV2013		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: D1	
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: D1	

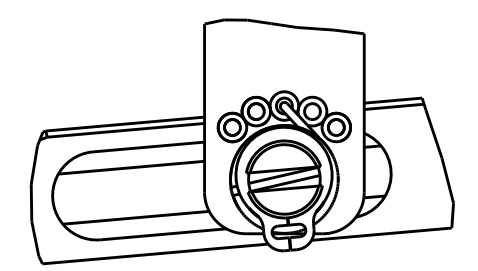
LOC	DIST	REV	DATE	BY	APPV
A	66				
		1			
		2			
		3			

### FEED TYPE PNEUMATIC



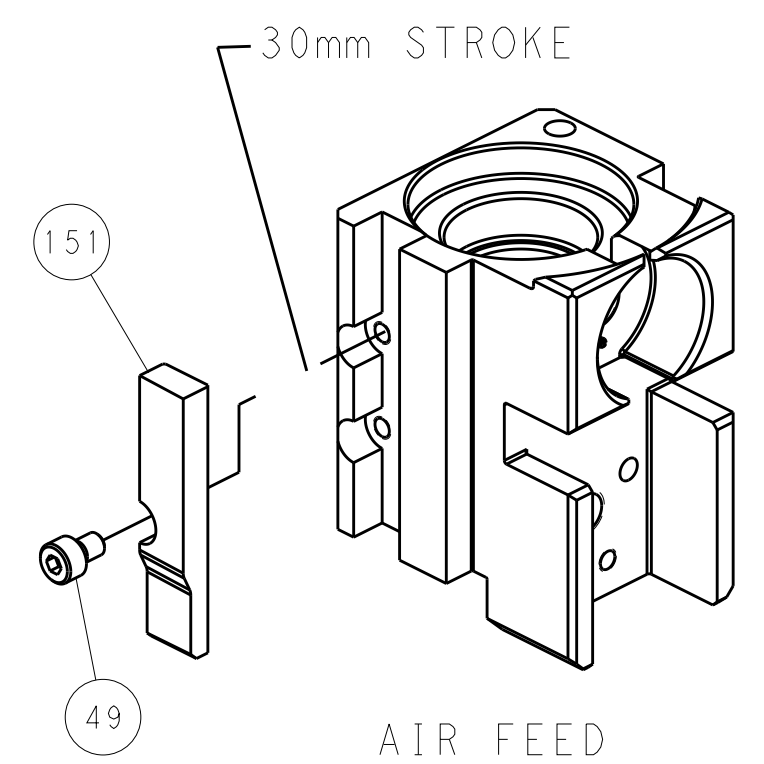
SEE DETAIL A

### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

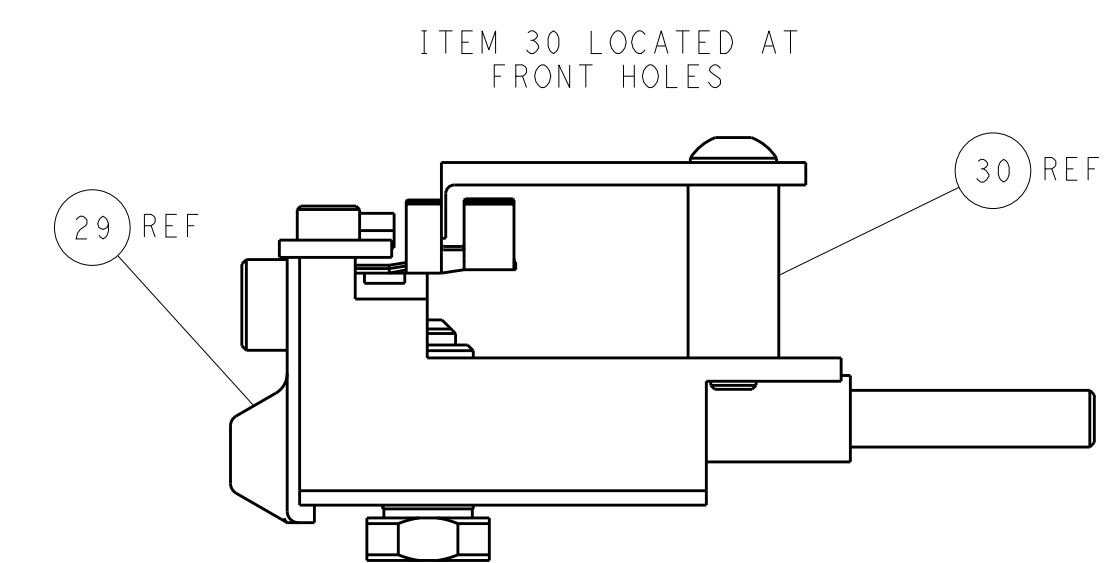
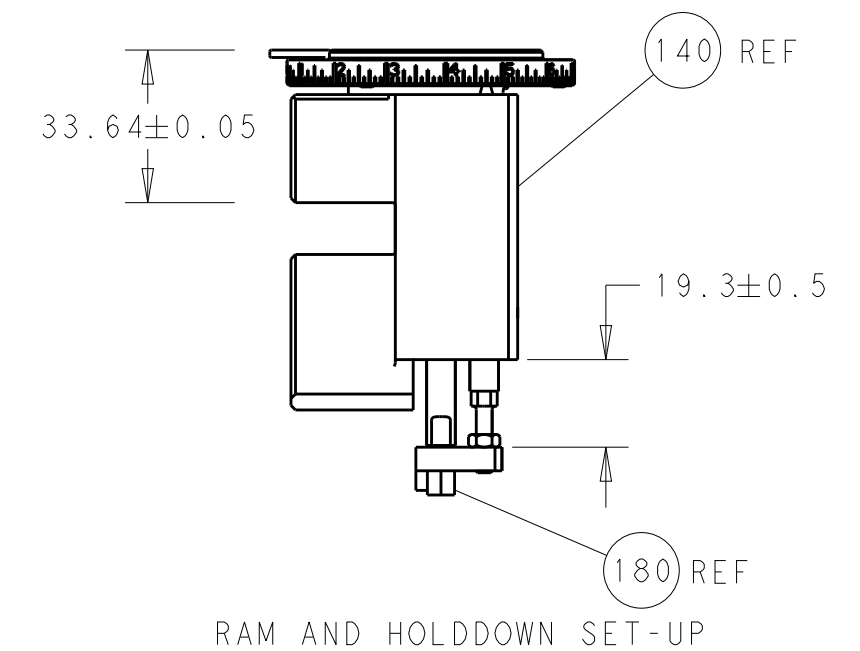
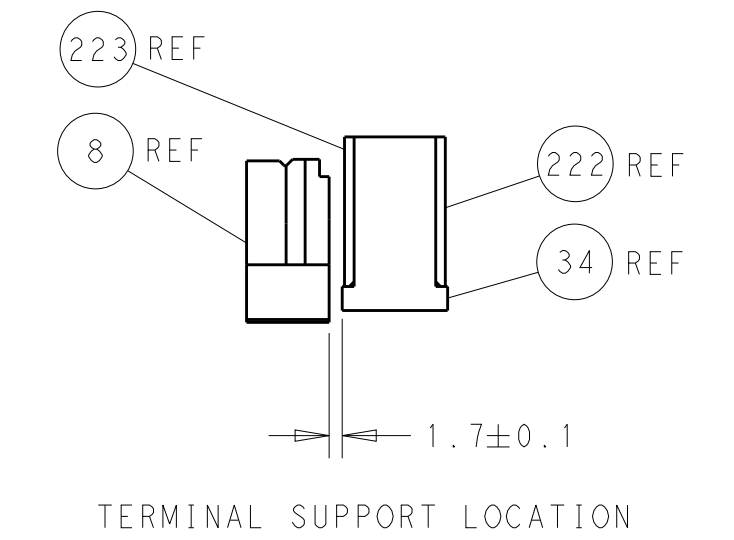
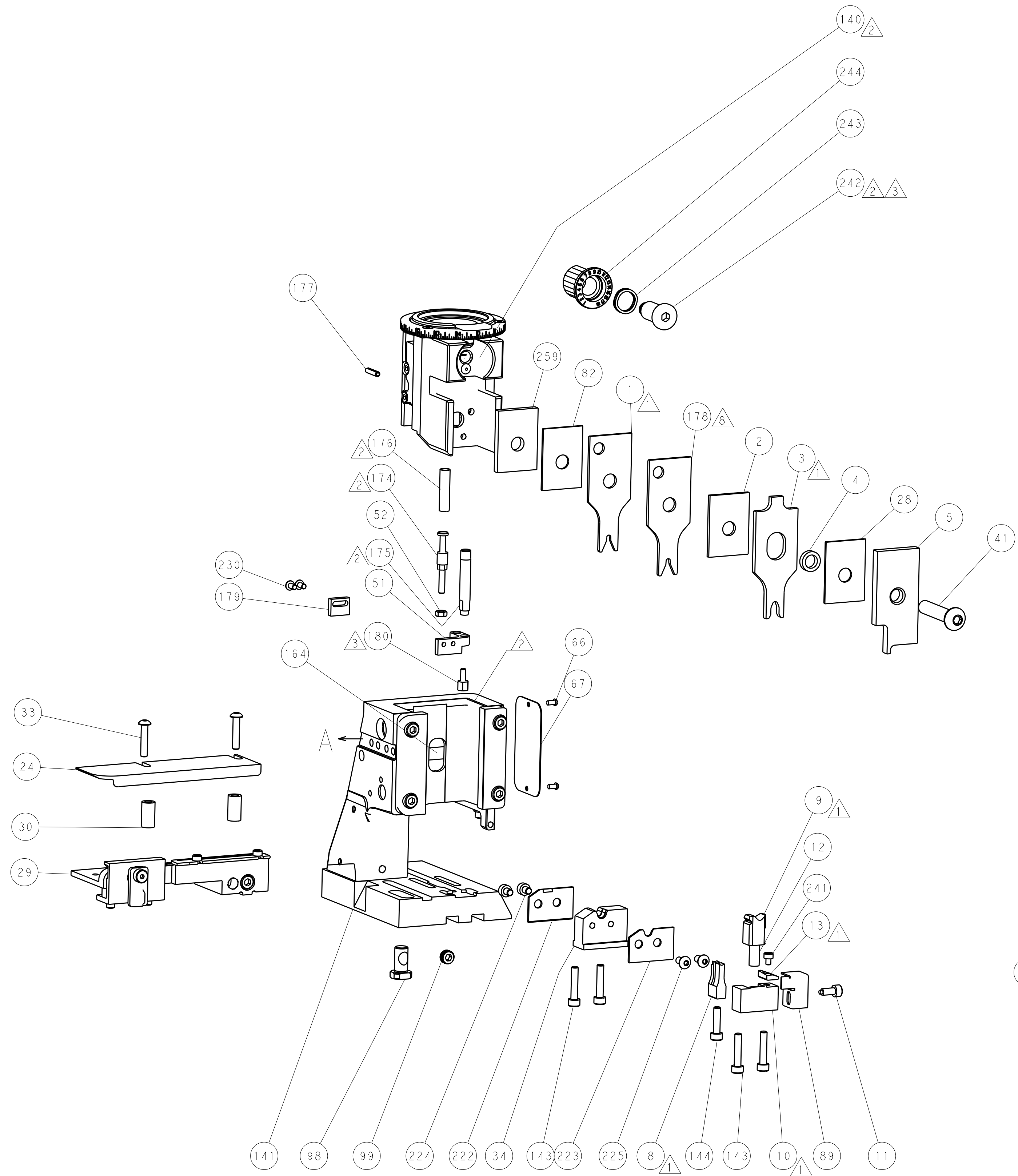


DETAIL A

### CAM POSITION



AIR FEED



**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:		DWN: R. O. WILSON 21NOV2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK: K. J. STAKEM 21NOV2013	NAME: T. L. ELBIN 21NOV2013	Ocean Side Feed Applicator	
MATERIAL:		WEIGHT:		APVD: T. L. ELBIN 21NOV2013	PRODUCT SPEC:	SIZE: A1	CAGE CODE: 00779
				Customer Accessible Production Drawing	SCALE: 1:2	SHEET: 4	OF 4