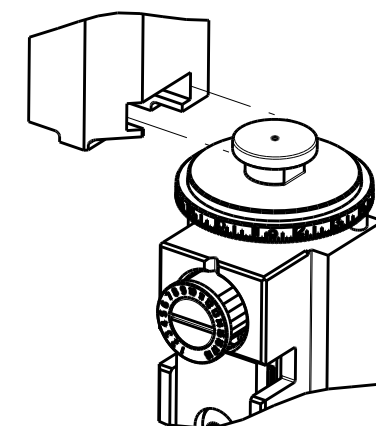


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266701-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266701-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266701-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266701-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266701-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

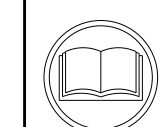


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, LOW PROFILE E1 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.50-3.50 mm [.098-.138 IN]		Ø1.10-1.90 mm [.043-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5051		
TERMINALS APPLIED <sup>6</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170354-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.32mm2	0.91+/-0.05 [.036+/- .002]	7.4
24 AWG OR 0.20mm2	0.84+/-0.05 [.033+/- .002]	8.1
26 AWG OR 0.13mm2	0.79+/-0.05 [.031+/- .002]	8.6



<sup>1</sup> RECOMMENDED SPARE PARTS

<sup>2</sup> REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

<sup>3</sup> APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

<sup>4</sup> 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

<sup>6</sup> TERMINAL LUBRICANT IS RECOMMENDED.

**\*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	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	13APR2015	BW	TE
		B		ECR-17-009547	04JUL2017	MZ	KZ
		C		ECR-19-008272	24MAY2019	FZ	CT
		D		ECR-19-015628	09OCT2019	MZ	YY

-	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	284	
-	1	1	1	1	18023-2	SCR, SKT HD CAP M3 X 6.0	283	
-	1	1	1	1	2280441-1	INSERT, SHEAR	282	
-	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	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
<sup>3</sup>	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	356885-4	STOP, SHEAR	237	
-	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	1-22281-8	SPRING, COMPRESSION	121	
<sup>6</sup>	-	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	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	240641-9	SPACER	81	
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	1338683-2	FEED PAWL	56	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53	
-	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	4-690487-0	GUIDE, FRONT STRIP	30	
-	1	1	1	1	1-2305692-2	PLATE, REAR STRIP GUIDE	29	
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	28	
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-5	DRAG, TERMINAL	25	
-	1	1	1	1	690438-2	FRONT STRIP GUIDE	24	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
<sup>1</sup>	-	1	1	1	690463-1	FLOATING SHEAR, REAR	17	
-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	-	-	-	-	-	-	10	
-	-	-	-	-	-	-	9	
<sup>1</sup>	1	2	2	1	1	1333228-6	ANVIL	8
-	-	-	-	-	-	-	7	
-	1	1	1	1	1	1-690468-8	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	-	-	5	
-	1	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
<sup>1</sup>	1	2	2	1	1	2-1803017-2	CRIMPER, INSULATION F	3
-	1	1	1	1	1	455888-2	SPACER, CRIMPER	2
<sup>1</sup>	1	2	2	1	1	4-1633730-4	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

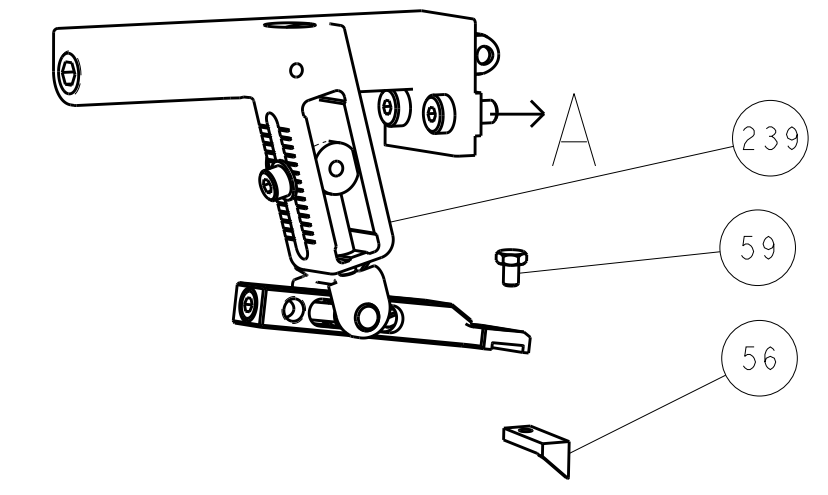
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
mm	0 PLC ±	1 PLC ±	2 PLC ±
	3 PLC ±	4 PLC ±	ANGLES ±
	FINISH		

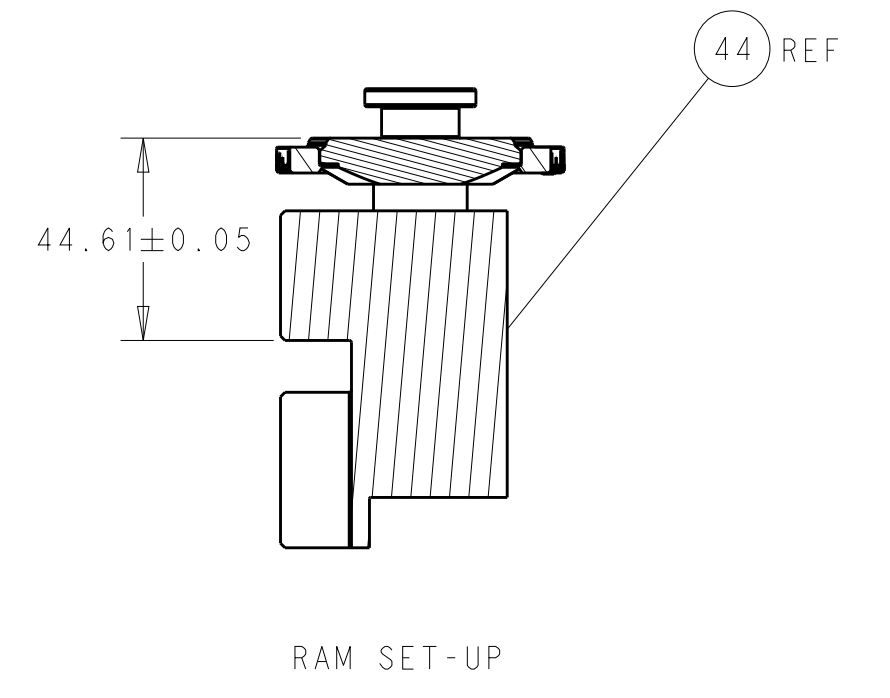
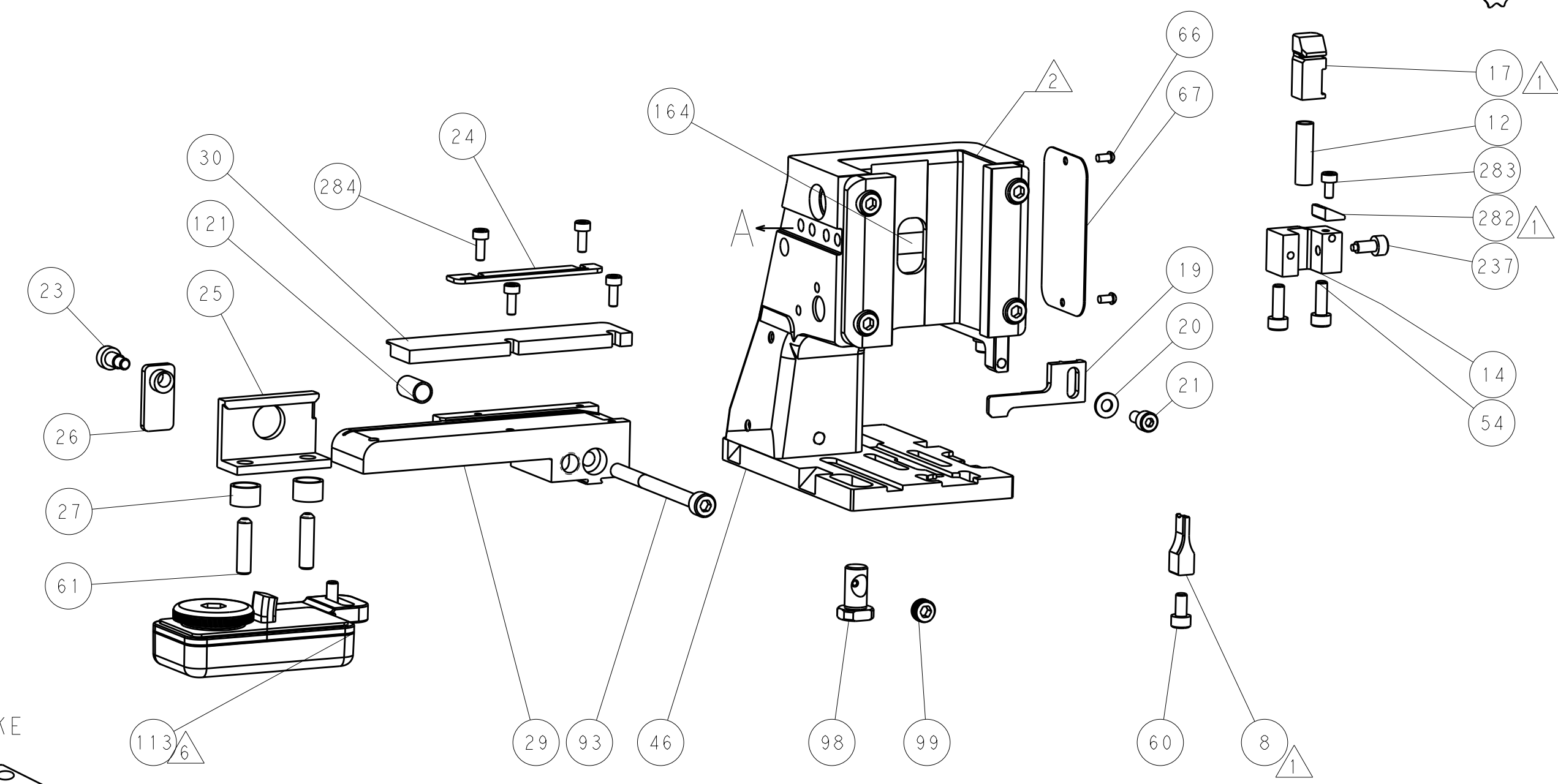
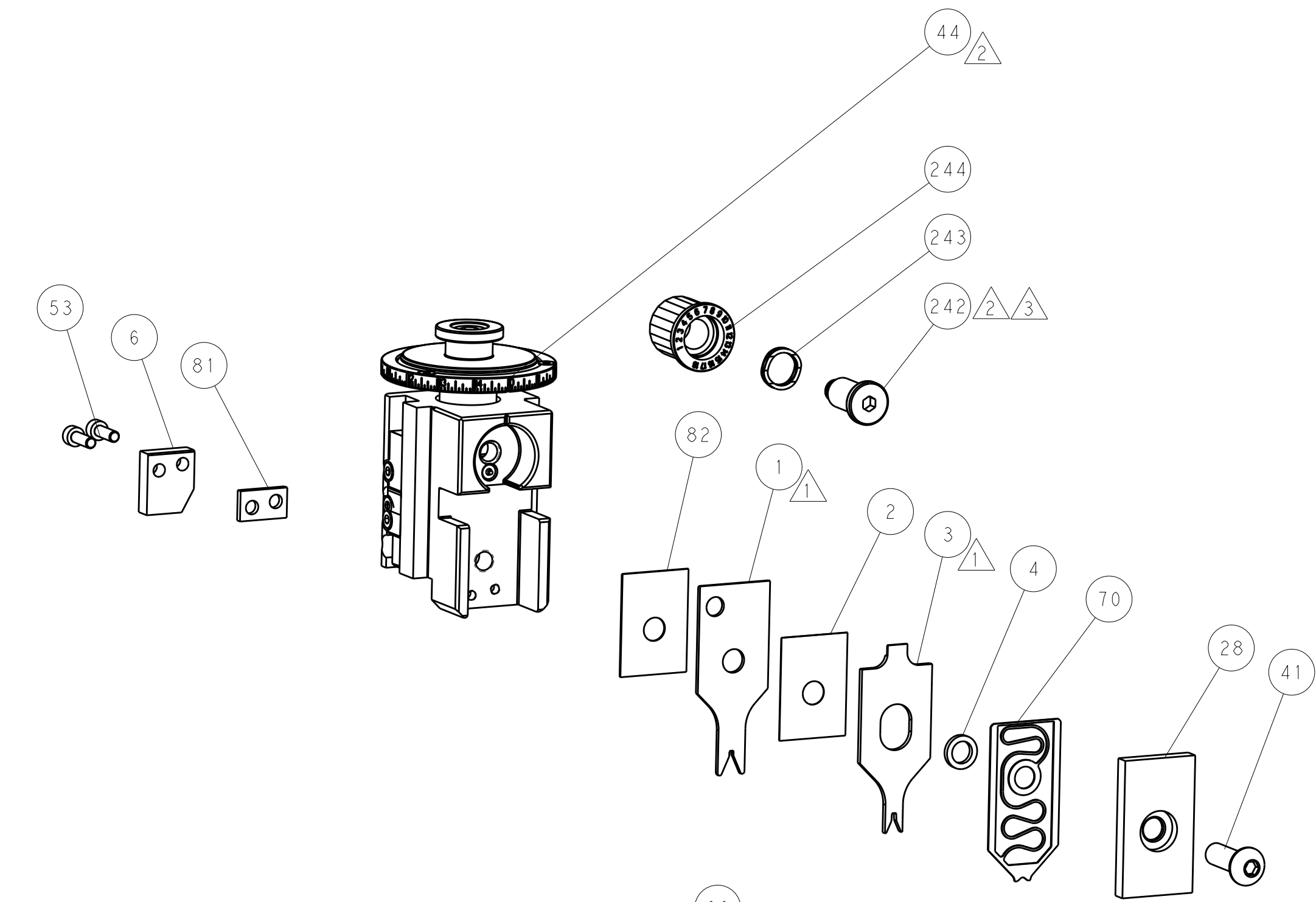
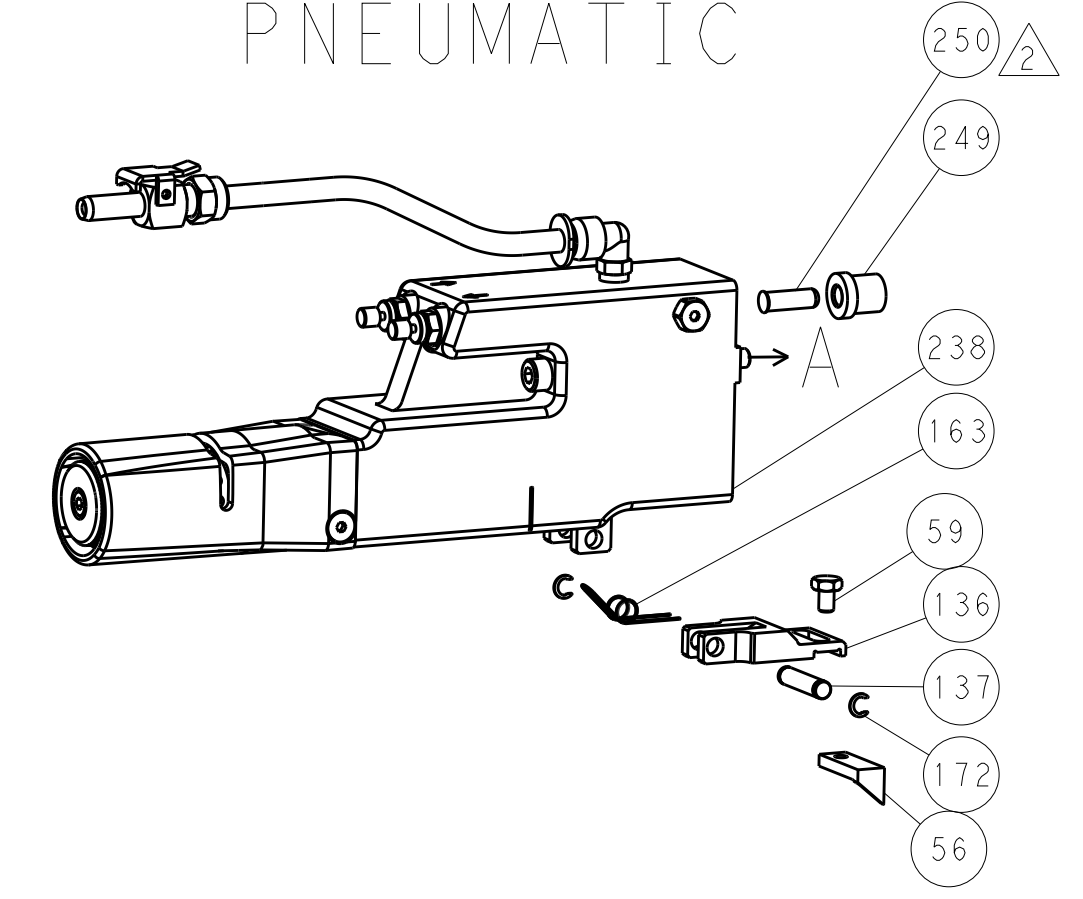
OWN	B. WEAVER	25FEB2015
CHK	T. ELBIN	25FEB2015
APVD	T. ELBIN	25FEB2015
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	C=2266701
Customer Accessible Production Drawing		SCALE 1:2 SHEET 1 OF 4 REV D

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DATE	BY	APPV
- SEE SHEET 1			-	-	-

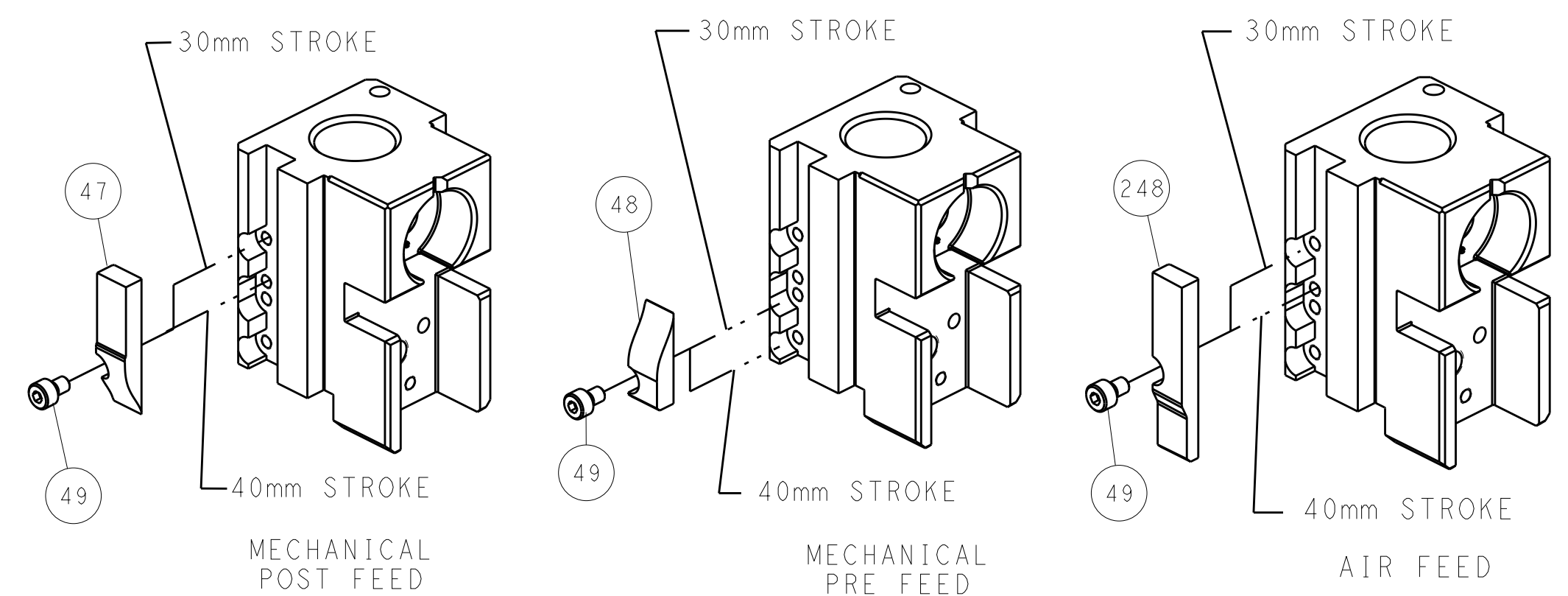
# FEED TYPE MECHANICAL



# PNEUMATIC



# CAM POSITIONS



**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: B. WEAVER 25FEB2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: T. ELBIN 25FEB2015		NAME: Ocean Side Feed Applicator	
-		-		APVD: T. ELBIN 25FEB2015		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
-		-		PRODUCT SPEC:		A1 00779 ©=2266701	
-		-		APPLICATION SPEC:		Customer Accessible Production Drawing	
-		-		WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266701-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266701-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266701-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, LOW PROFILE E1 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.50-3.50 mm [.098-.138 IN]		∅1.10-1.90 mm [.043-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5051		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170354-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.32mm <sup>2</sup>	0.91+/-0.05 [.036+/-0.002]	7.4
24 AWG OR 0.20mm <sup>2</sup>	0.84+/-0.05 [.033+/-0.002]	8.1
26 AWG OR 0.13mm <sup>2</sup>	0.79+/-0.05 [.031+/-0.002]	8.4



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

6 TERMINAL LUBRICANT IS RECOMMENDED.

**\*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.

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	-	-	-

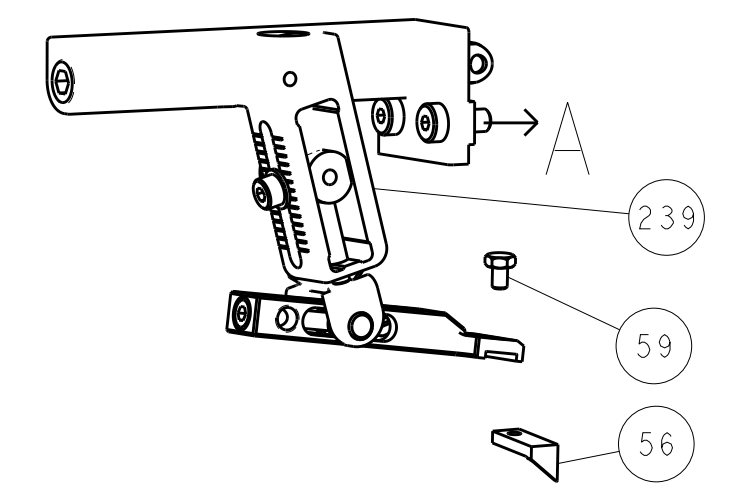
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	284
-	1	1	18023-2	SCR, SKT HD CAP M3 X 6.0	283
-	1	1	2280441-1	INSERT, SHEAR	282
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-4	CAM, SWAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	356885-4	STOP, SHEAR	237
-	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
-	2	2	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	240641-9	SPACER	81
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-2	FEED PAWL	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	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	4-690487-0	GUIDE, FRONT STRIP	30
-	1	1	1-2305692-2	PLATE, REAR STRIP GUIDE	29
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	690438-2	FRONT 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
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	690463-1	FLOATING SHEAR, REAR	17
-	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	10
-	-	-	-	-	9
-	1	1	1333228-6	ANVIL	8
-	-	-	-	-	7
-	1	1	1-690468-8	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	2-1803017-2	CRIMPER, INSULATION F	3
-	1	1	455888-2	SPACER, CRIMPER	2
-	1	1	4-1633730-4	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

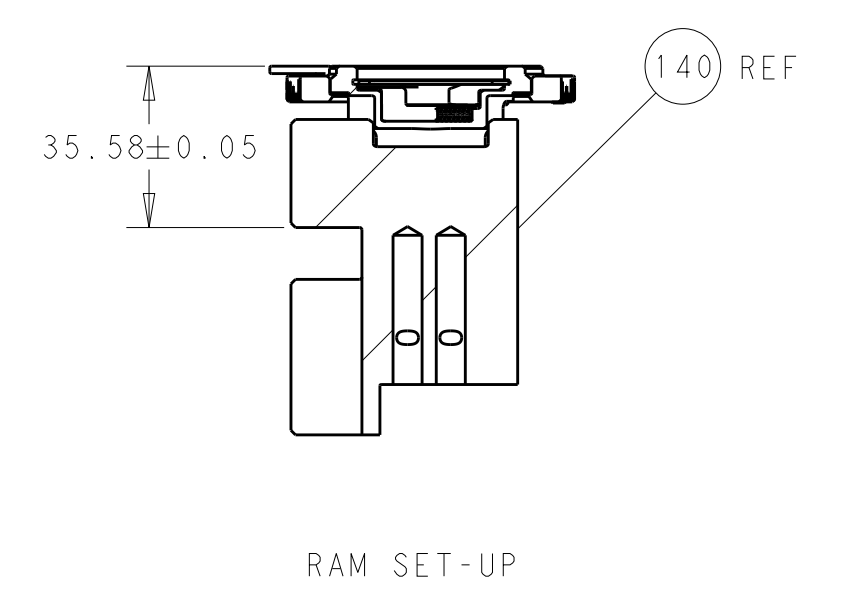
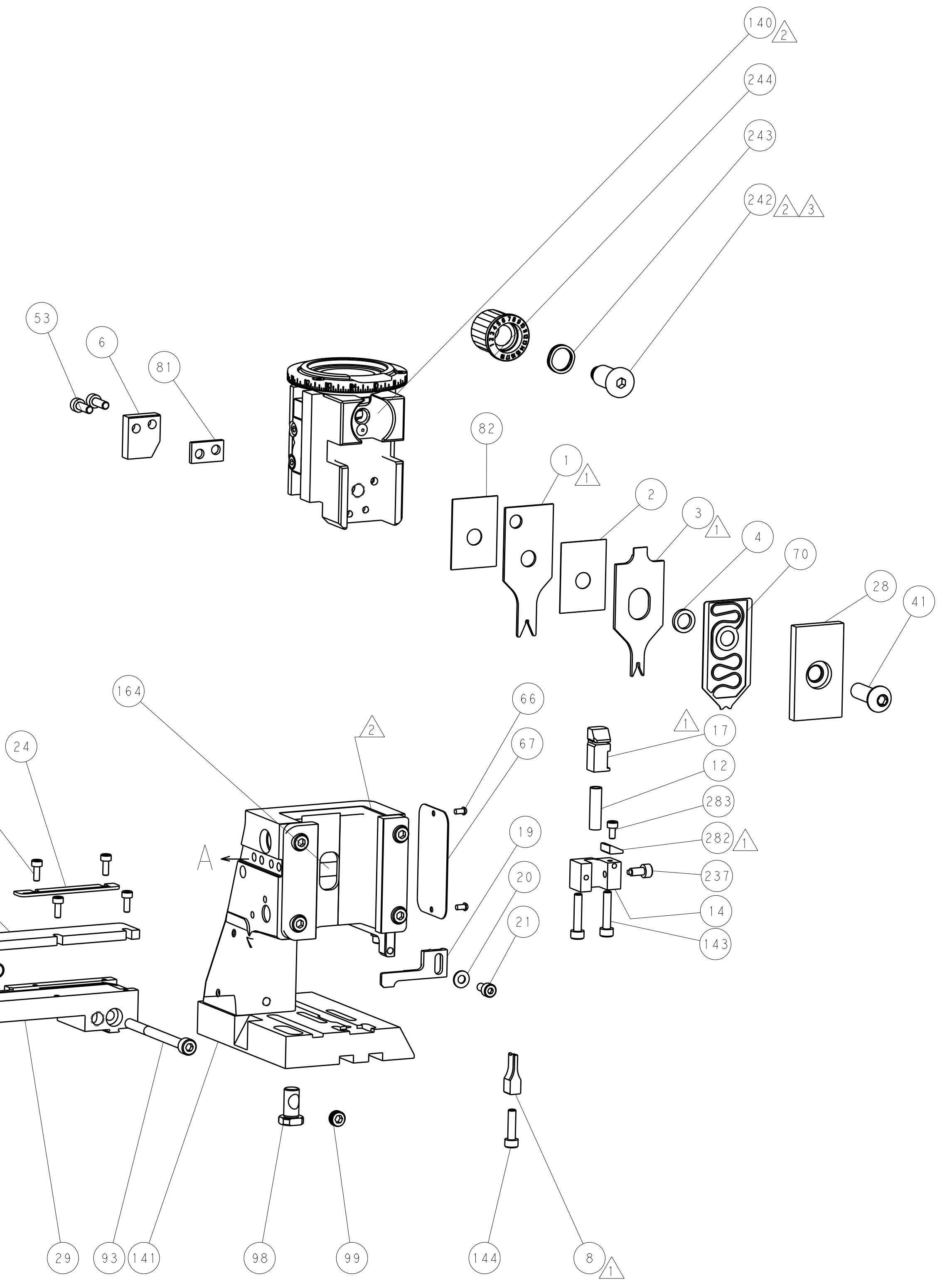
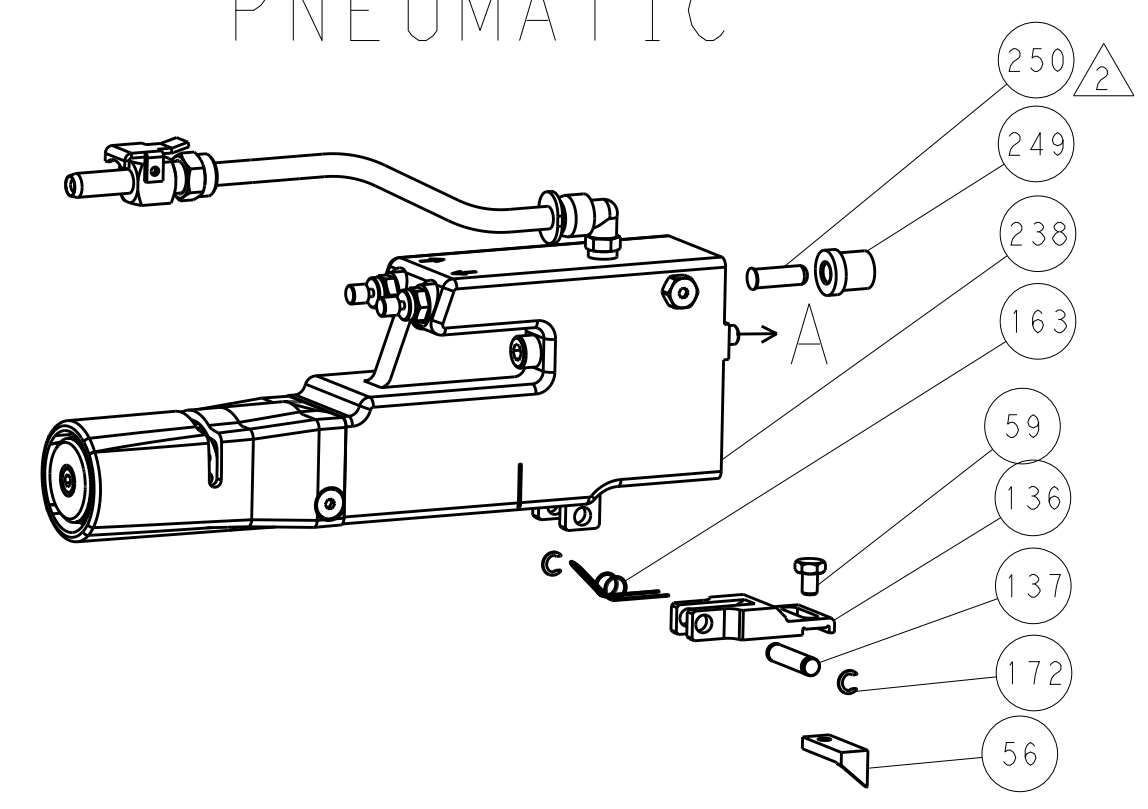
OWNER: B. WEAVER 25FEB2015	DATE: 25FEB2015	NAME: TE Connectivity	ADDRESS: Harrisburg, PA 17105-3608
CHK: T. ELBIN	DATE: 25FEB2015	NAME: Ocean Side Feed	ADDRESS: -
APVD: T. ELBIN 25FEB2015	DATE: 25FEB2015	NAME: -	ADDRESS: -
PRODUCT SPEC: -	APPLICATION SPEC: -	SIZE: A1	CAGE CODE: 00779
WEIGHT: -	SCALE: 1:2	SHEET: 3	OF: 4
Customer Accessible Production Drawing		REV: D	REV: -

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

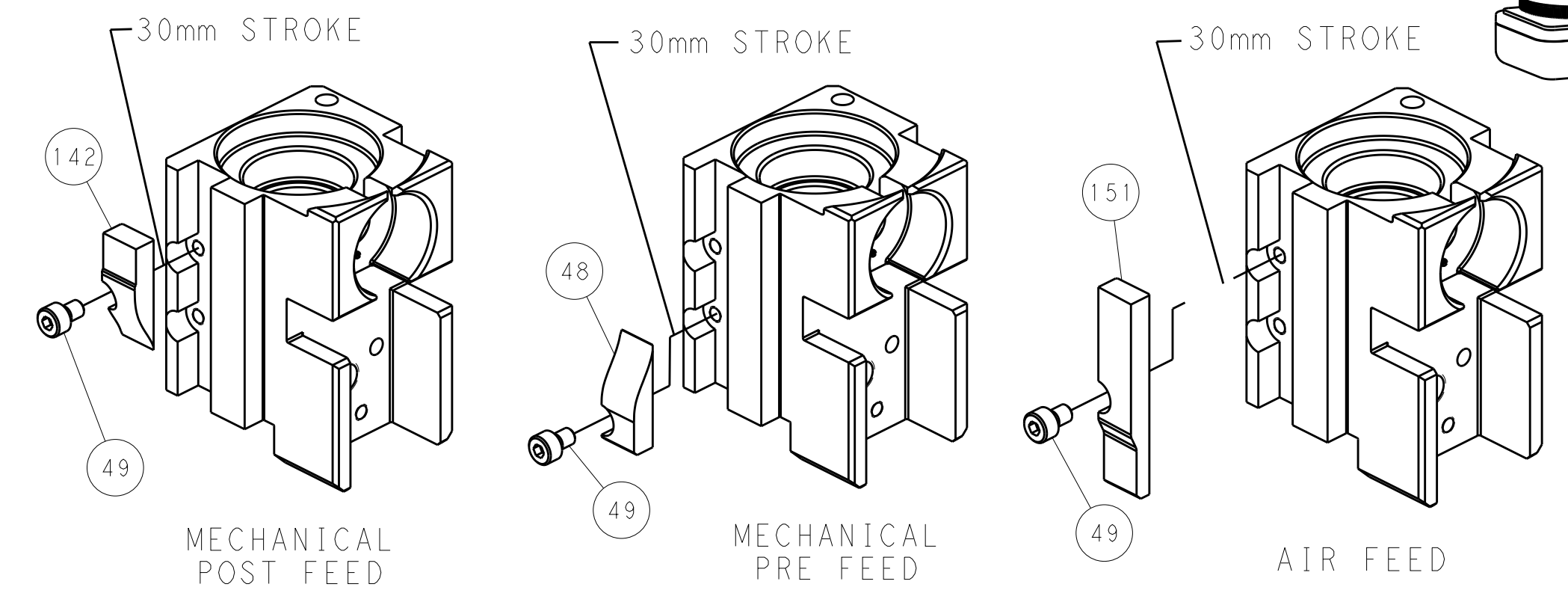
# FEED TYPE MECHANICAL



# 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 UNPUBLISHED. RELEASED FOR PUBLICATION 2015. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS TO BE USED ONLY FOR THE PURPOSES AND APPLICATIONS SPECIFIED HEREIN. ANY OTHER USE IS STRICTLY PROHIBITED. CONTACT TYCO ELECTRONICS CORPORATION FOR FURTHER INFORMATION.</small>		DWN: B. WEAVER 25FEB2015 CHK: T. ELBIN 25FEB2015 APVD: T. ELBIN 25FEB2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO: A   00779   C=2266701
MATERIAL: FINISH:		Customer Accessible Production Drawing	SCALE: 1:2 SHEET 4 OF 4 REV D