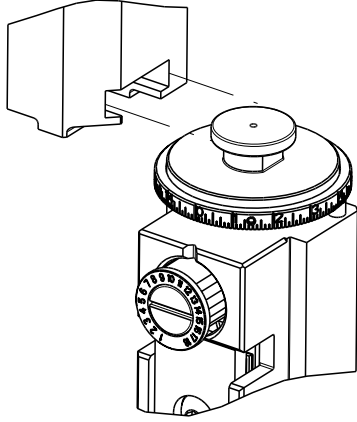
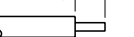


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266077-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266077-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266077-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



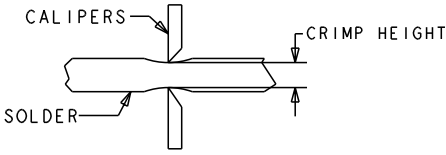
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm [.176]	D
INSUL	5.54 mm [.218]	PIDG
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ULTRA FAST PLUS FULLY INSULATED FASTON			
WIRE STRIP LENGTH 6.73-7.54 mm [.265-.297 IN]			INSULATION DIAMETER RANGE Ø 1.52-3.43 mm [.060-.135 IN]
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520405-2	2-521360-2	2-521055-2	
2-520403-2	2-520401-2	2-521361-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
18 AWG	1.78+/-0.05 [.070+/- .002]	6.1	.12 IN [3.05mm]
20 OR 22	1.65+/-0.05 [.065+/- .002]	7.5	.12 IN [3.05mm]



- 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.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.12 IN [3.05mm] 60/40 SOLID CORE AND MEASURE AT CENTER OF SLUG.



- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		B		ECR-17-003516	10MAR2017	MZ	KZ	
		C		ECR-18-017226	01NOV2018	JAH	CT	
		D		ECR-19-005619	08APR2019	FJ	TE	
		E		ECR-20-008744	18JUN2020	JWC	TE	

	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-9	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
	-	1	1	356885-4	STOP, SHEAR	237
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	84
	-	6	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	83
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	240641-9	SPACER	81
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	2	2	1-18028-4	WASHER, FLAT, REG M3	68
	-	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	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	462427-2	FINGER, FEED	56
	-	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
	-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1-1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	2161336-2	PLATE, REAR STRIP GUIDE	29
	-	2	2	22281-9	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	684042-4	GUIDE, STRIP, FRONT	24
	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	1	2161335-2	SHEAR PLATE, REAR	22
	-	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	463460-3	HOLD DOWN, TERMINAL	18
	-	1	1	803925-2	GUIDE, CARRIER SCRAP	17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
1	-	1	1	469542-3	REAR FLOATING SHEAR	15
	-	1	1	2119862-2	SHEAR HOLDER, REAR	14
1	-	1	1	2280441-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	-	-	-	-	10
1	1	1	1	1-454766-4	ANVIL, INSULATION	9
	1	2	1	808025-3	ANVIL	8
	-	-	-	-	-	7
	-	1	1	690468-6	DEPRESSOR SHEAR, REAR	6
	-	-	-	-	-	5
	-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	1	1803130-1	CRIMPER, INSULATION FASTON	3
	-	-	-	-	-	2
1	1	2	1	808830-2	CRIMPER, SEMI FLAT	1
	-77	-72	-2	PART NO	DESCRIPTION	ITEM NO

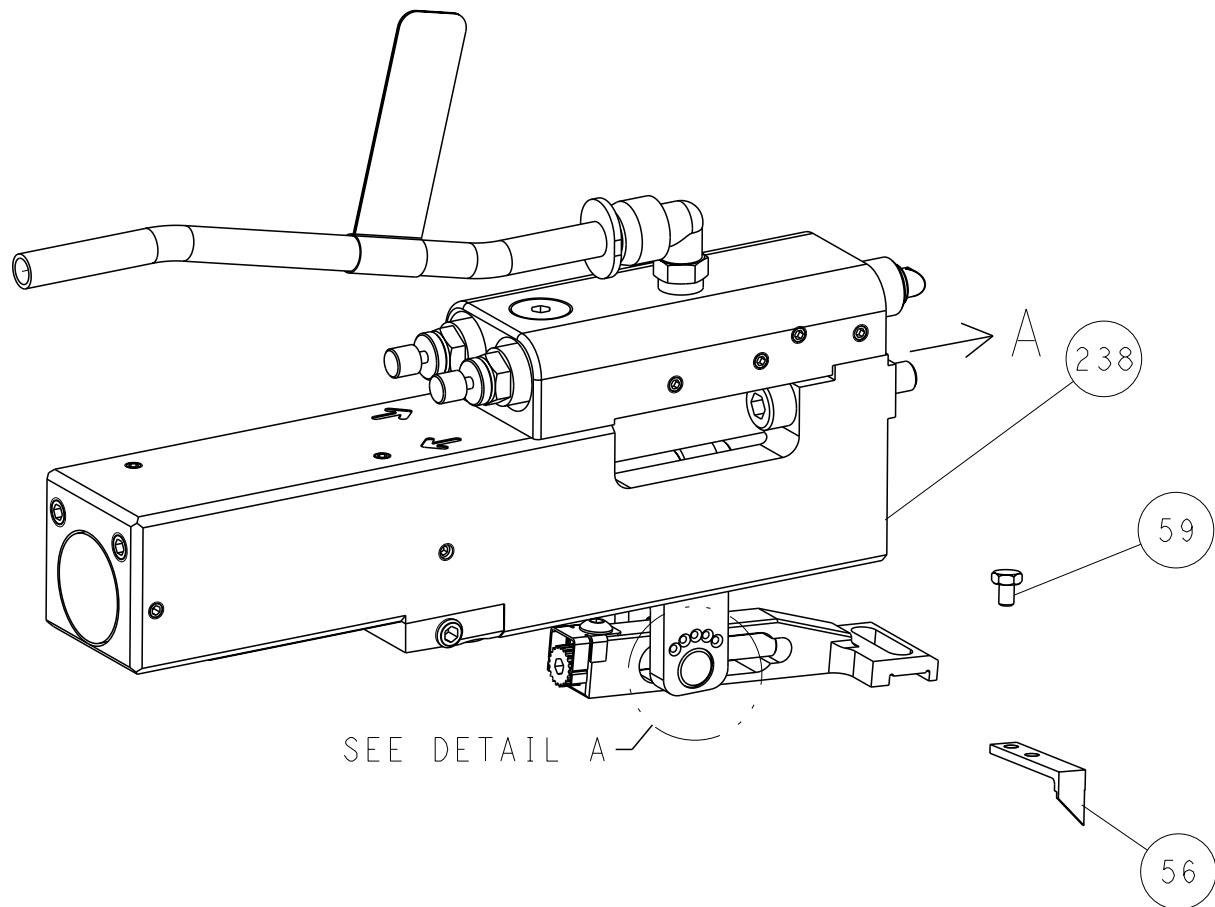
THIS DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRONIC COMPONENTS INDUSTRY. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN BOB HIGMAN 18OCT2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G.BAILEY 18OCT2013	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD W. CLIFFORD 18OCT2013	SIZE 00779	
MATERIAL -		APPLICATION SPEC -		RESTRICTED TO -
FINISH -		WEIGHT -		SCALE 1:2
Customer Accessible Production Drawing		DRAWING NO 00779		SHEET 1 OF 4
		REV E		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

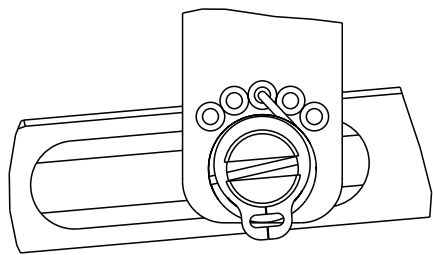
LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
				-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

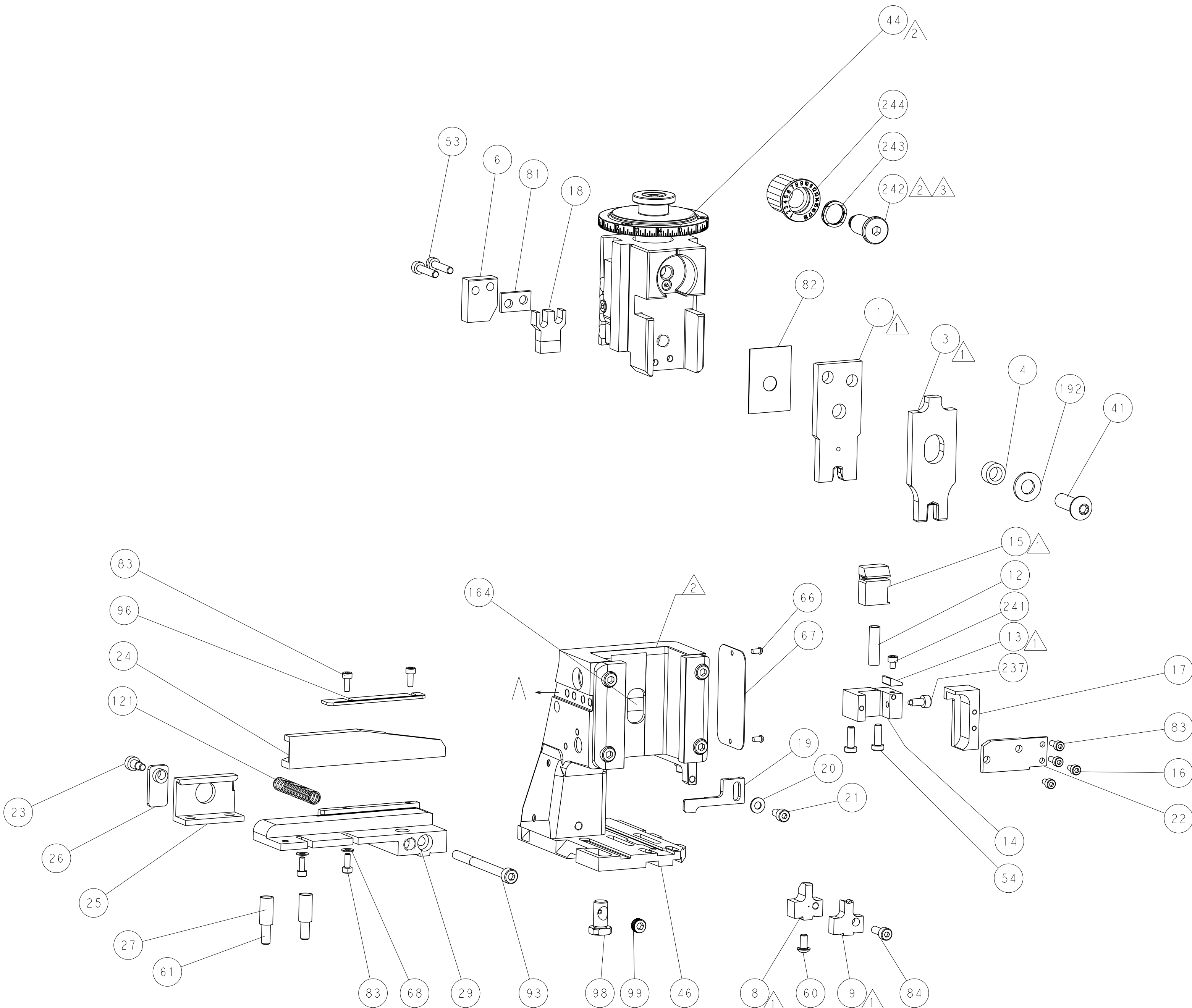
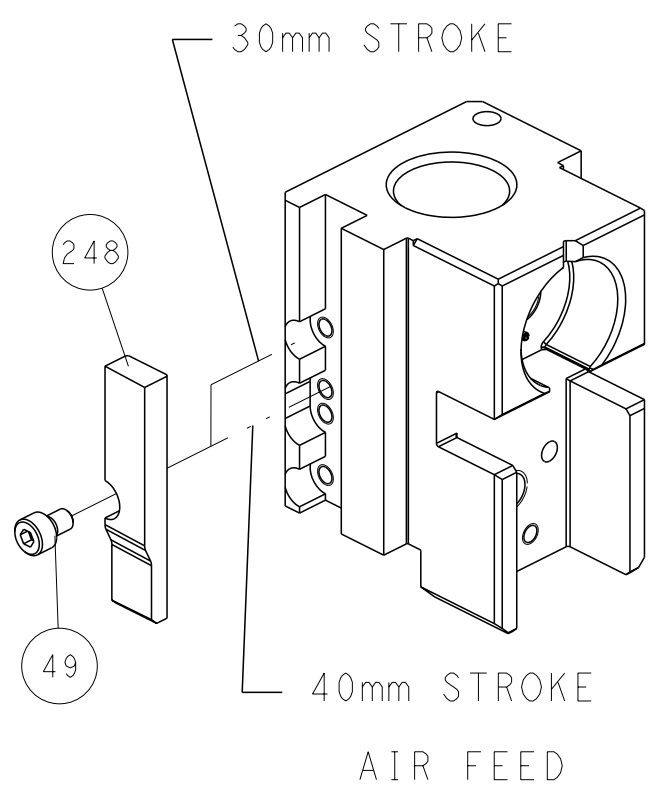


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITION

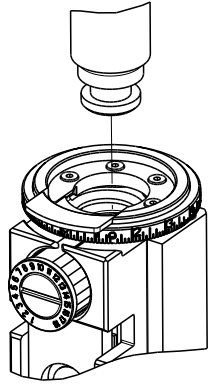


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1:1: DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION		DWN BOB HIGMAN 18OCT2013	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G.BAILEY 18OCT2013		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD M.CLIFFORD 18OCT2013	NAME Ocean Side Feed Applicator	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
		APPLICATION SPEC -	CAGE CODE 00779	
		WEIGHT -	DRAWING NO C=2266077	
		Customer Accessible Production Drawing	SCALE 1:2	SHEET 2 of 4
			REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266077-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266077-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm [.176]	D
INSUL	5.54 mm [.218]	PIDG
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ULTRA FAST PLUS FULLY INSULATED FASTON			
WIRE STRIP LENGTH 6.73-7.54 mm [.265-.297 IN]			INSULATION DIAMETER RANGE Ø 1.52-3.43 mm [.060-.135 IN]
TERMINAL APPLICATION SPECIFICATION	 114-2123	-	-
TERMINALS APPLIED 		-	-
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520405-2	2-521360-2	2-521055-2	
2-520403-2	2-520401-2	2-521361-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
18 AWG	1.78+/-0.05 [.070+/- .002]	6.1	6.4
20 OR 22	1.65+/-0.05 [.065+/- .002]	7.5	7.6



- 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 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.12 IN [3.05mm] 60/40 SOLID CORE AND MEASURE AT CENTER OF SLUG.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
7. 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.

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				
		#	LYR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

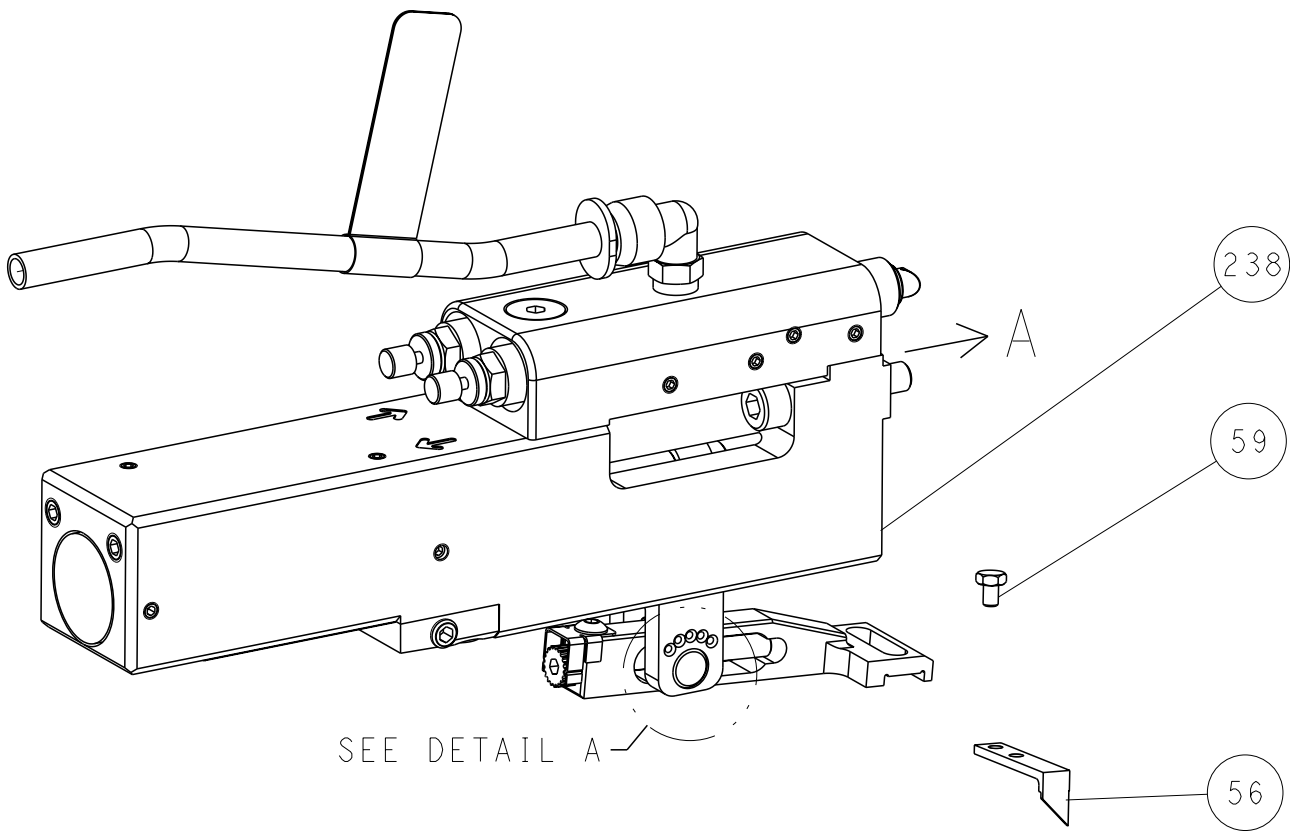
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-1	AIR FEED MODULE	238
-	1	356885-4	STOP, SHEAR	237
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	2-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1-22281-8	SPRING, COMPRESSION	121
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	84
-	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	83
-	1	455888-5	SPACER, CRIMPER	82
-	1	240641-9	SPACER	81
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	2	1-18028-4	WASHER, FLAT, REG M3	68
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	462427-2	FINGER, FEED	56
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	2161336-2	PLATE, REAR STRIP GUIDE	29
-	2	22281-9	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	684042-4	GUIDE, STRIP, FRONT	24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	2161335-2	SHEAR PLATE, REAR	22
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	463460-3	HOLD DOWN, TERMINAL	18
-	1	803925-2	GUIDE, CARRIER SCRAP	17
-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	469542-3	REAR FLOATING SHEAR	15
-	1	2119862-2	SHEAR HOLDER, REAR	14
-	1	2280441-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	10
1	1	1-454766-4	ANVIL, INSULATION	9
1	1	808025-3	ANVIL	8
-	-	-	-	7
-	1	690468-6	DEPRESSOR SHEAR, REAR	6
-	-	-	-	5
-	1	4-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1803130-1	CRIMPER, INSULATION FASTON	3
-	-	-	-	2
1	1	808830-2	CRIMPER, SEMI FLAT	1
-77	-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC COMPONENTS INDUSTRY. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN BOB HIGMAN 18OCT2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G.BAILEY 18OCT2013	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD W. CLIFFORD 18OCT2013	PRODUCT SPEC	
MATERIAL -		FINISH -	APPLICATION SPEC	
		WEIGHT -	SIZE A1	
		Customer Accessible Production Drawing		SCALE 1:2
		00779 ©=2266077		SHEET 3
		REV E		OF 4

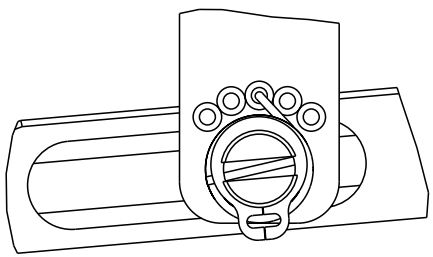
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

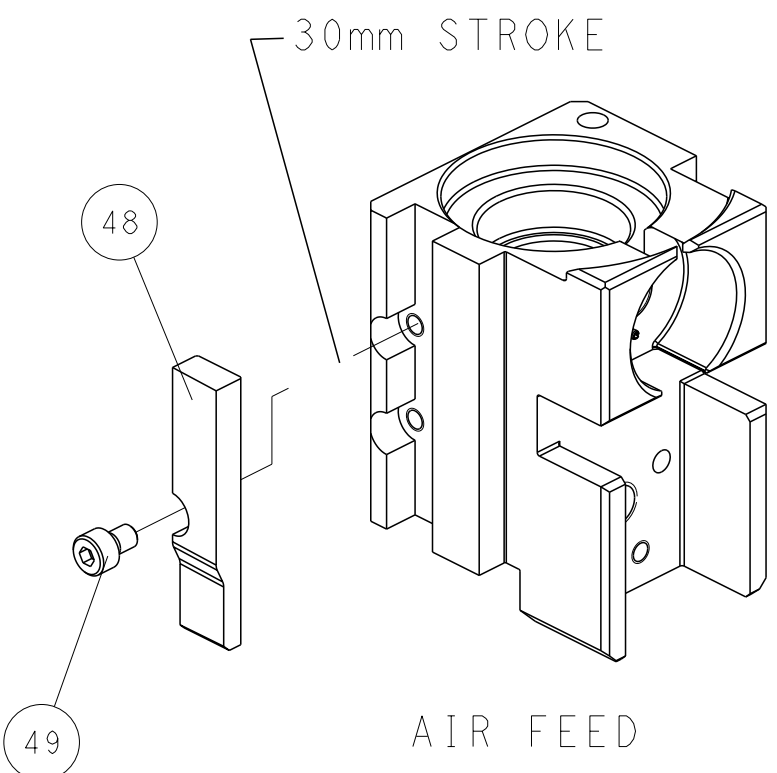


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

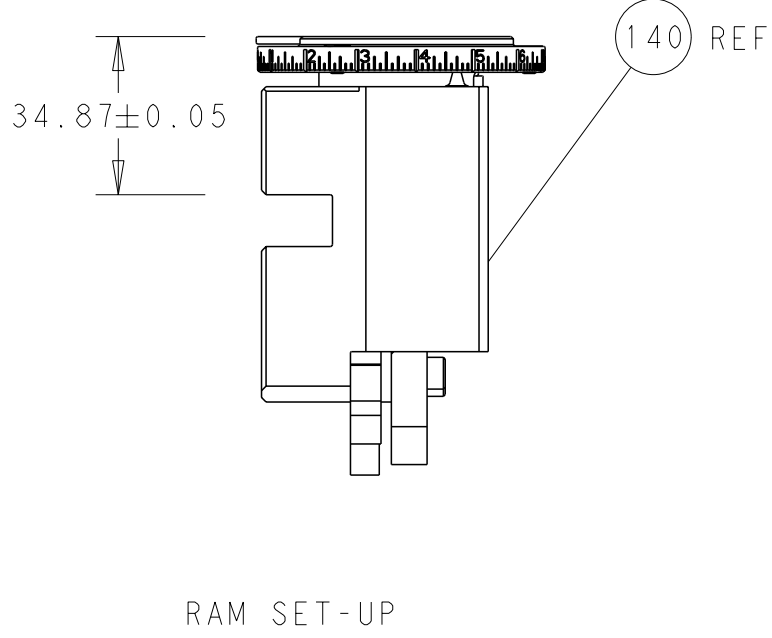
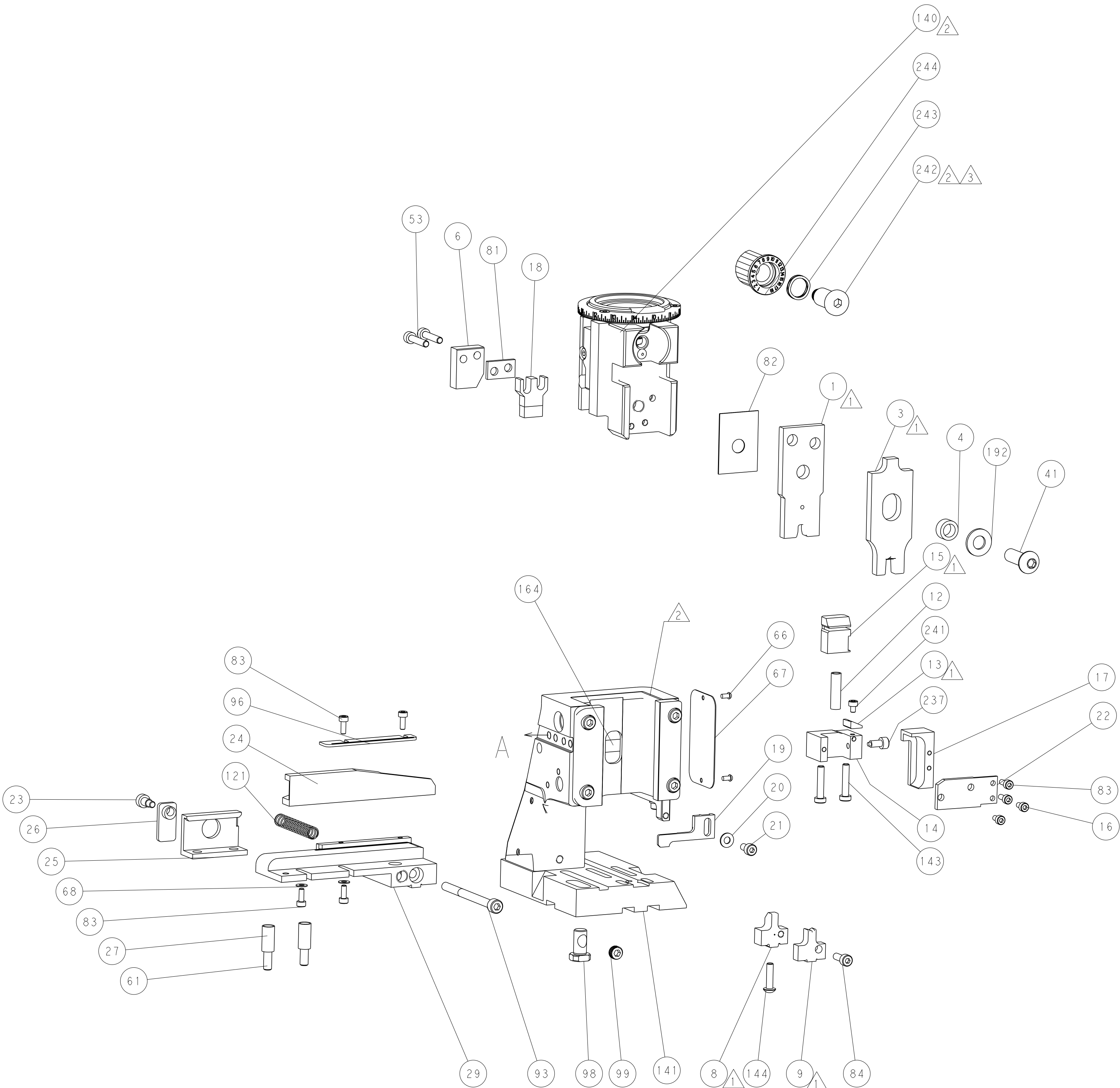


DETAIL A

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)

1411 DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN BOB HIGMAN 18OCT2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G.BAILEY 18OCT2013		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD M.CLIFFORD 18OCT2013	NAME Ocean Side Feed Applicator	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
FINISH -		APPLICATION SPEC -	CAGE CODE 00779	
		WEIGHT -	DRAWING NO C=2266077	
		Customer Accessible Production Drawing		RESTRICTED TO -
		SCALE 1:2		REV E
		SHEET 4		OF 4