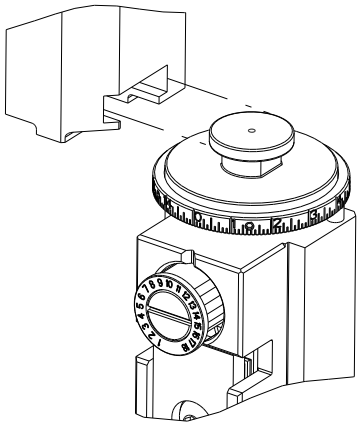





8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266046-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266046-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2266046-2	K	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2266046-1	K	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266046-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266046-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, 180 DEGREE, FAKRA			
WIRE STRIP LENGTH 2.86-3.36 mm [.113-.132 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION	(A)114-32145	-	-
	(B)114-32217	-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 2203260-4	(A) 1-2203260-2	(A) 2203270-4	(A) 1-2203270-2
(A) 2-2203270-3	(B) 2304634-4	(A) 4-2326900-3	(A) 2326890-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.5 DS-OFB	0.73+/-0.03 [.029+/- .001]	9.4
RG-174	0.72+/-0.03 [.028+/- .001]	9.2
RG-316	0.72+/-0.03 [.028+/- .001]	9.2
DACAR 363	0.71+/-0.03 [.028+/- .001]	9.3
RG-174 LL	0.69+/-0.03 [.027+/- .001]	9.5
1.5 DS-GEC	0.67+/-0.03 [.026+/- .001]	9.7
1.5 DS-GXC-SP	0.64+/-0.03 [.025+/- .001]	10



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- 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.
- 7 ADD SPACER FOR TERMINAL 2203270.
REMOVE SPACER FOR TERMINAL 2203260.

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
		J		ECR-21-121485			19NOV2021	FJ	RK
		J1		ECR-22-141999			10JUN2022	FZ	JAH
		K		ECR-22-160744			08DEC2022	LG	GB
		K1		ECR-23-179522			27JUN2023	FZ	MP

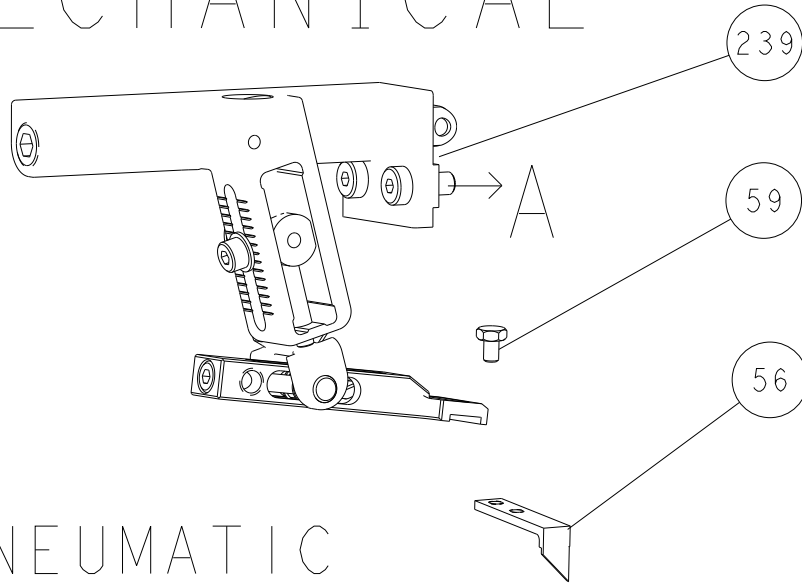
-	1	1	1	1	1	2-1803945-9	TONKER	300
-	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
3	-	1	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-3	DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	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	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
3	-	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	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	6-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	5-22279-1	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803418-2	FLOATING SHEAR, MINI COAX FRONT	9
1	1	2	2	1	1	9-1633933-8	ANVIL, COMBINATION	8
7	-	1	1	1	1	1-240641-9	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	-	2
1	1	2	2	1	1	3-1803224-7	CRIMPER, WIRE	1

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHALL BE RESPONSIBLE FOR THE LATEST EDITION.		DWN R.O.WILSON CHK K.J.STAKEM APVD T.L.ELBIN	11OCT2013 17OCT2013 18OCT2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH		± ± ± ± ± ±		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -		WEIGHT -		A1 00779 ©=2266046	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 OF 4	
				REV K1	

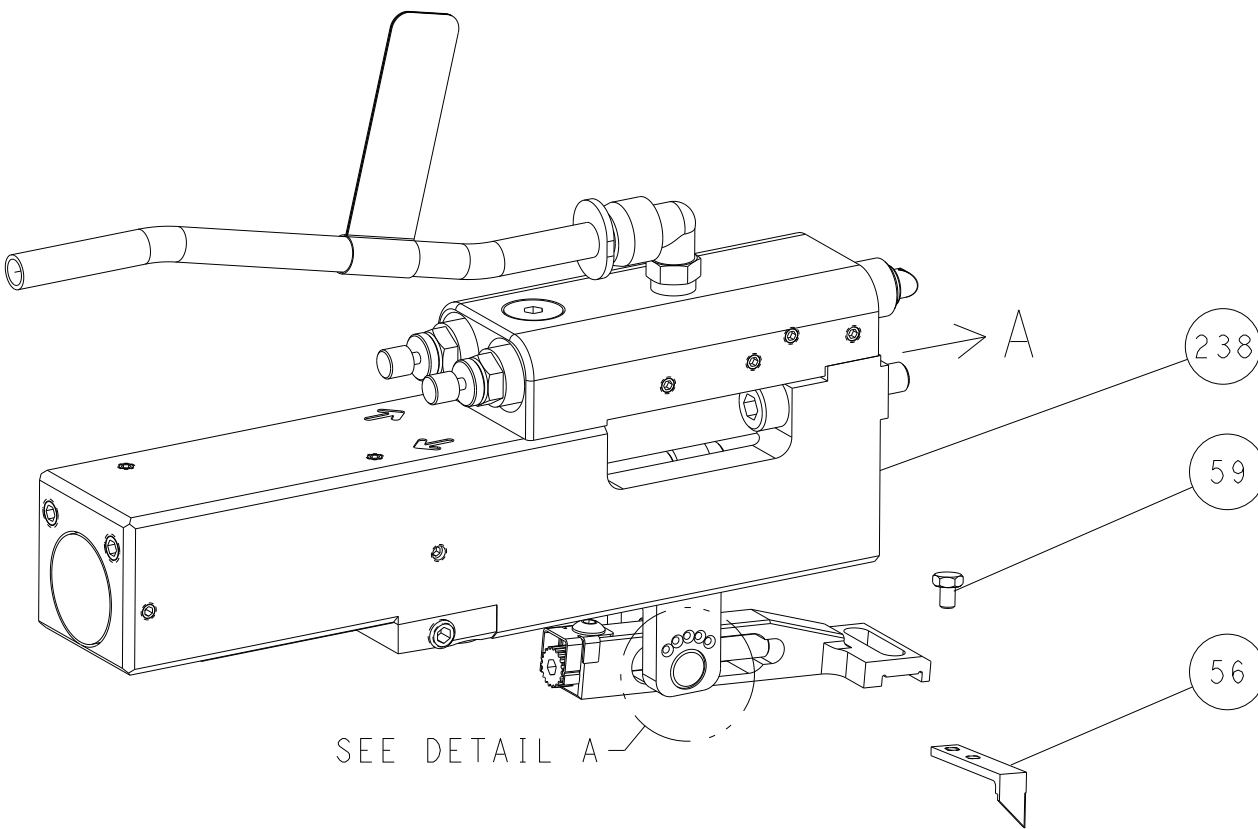
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

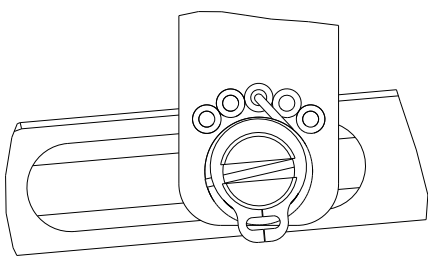
FEED TYPE MECHANICAL



PNEUMATIC

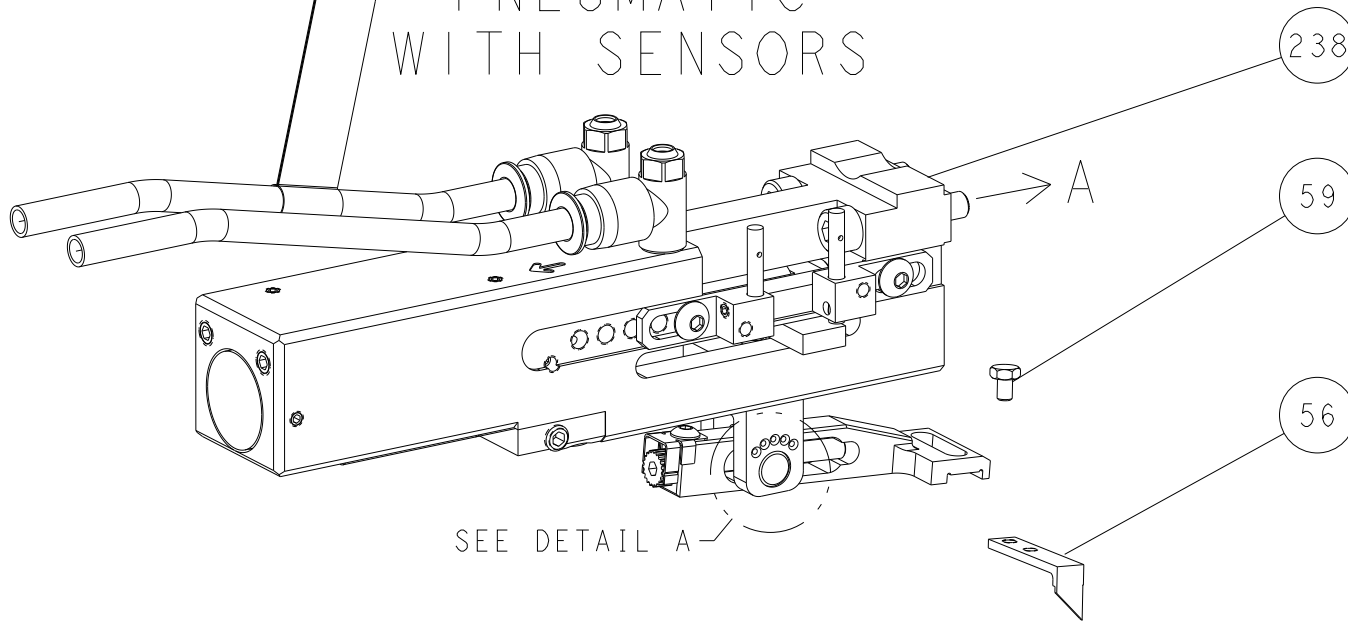


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

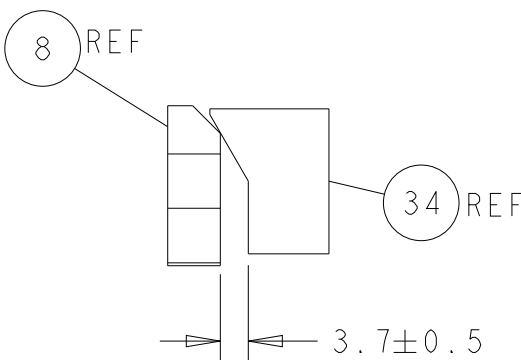
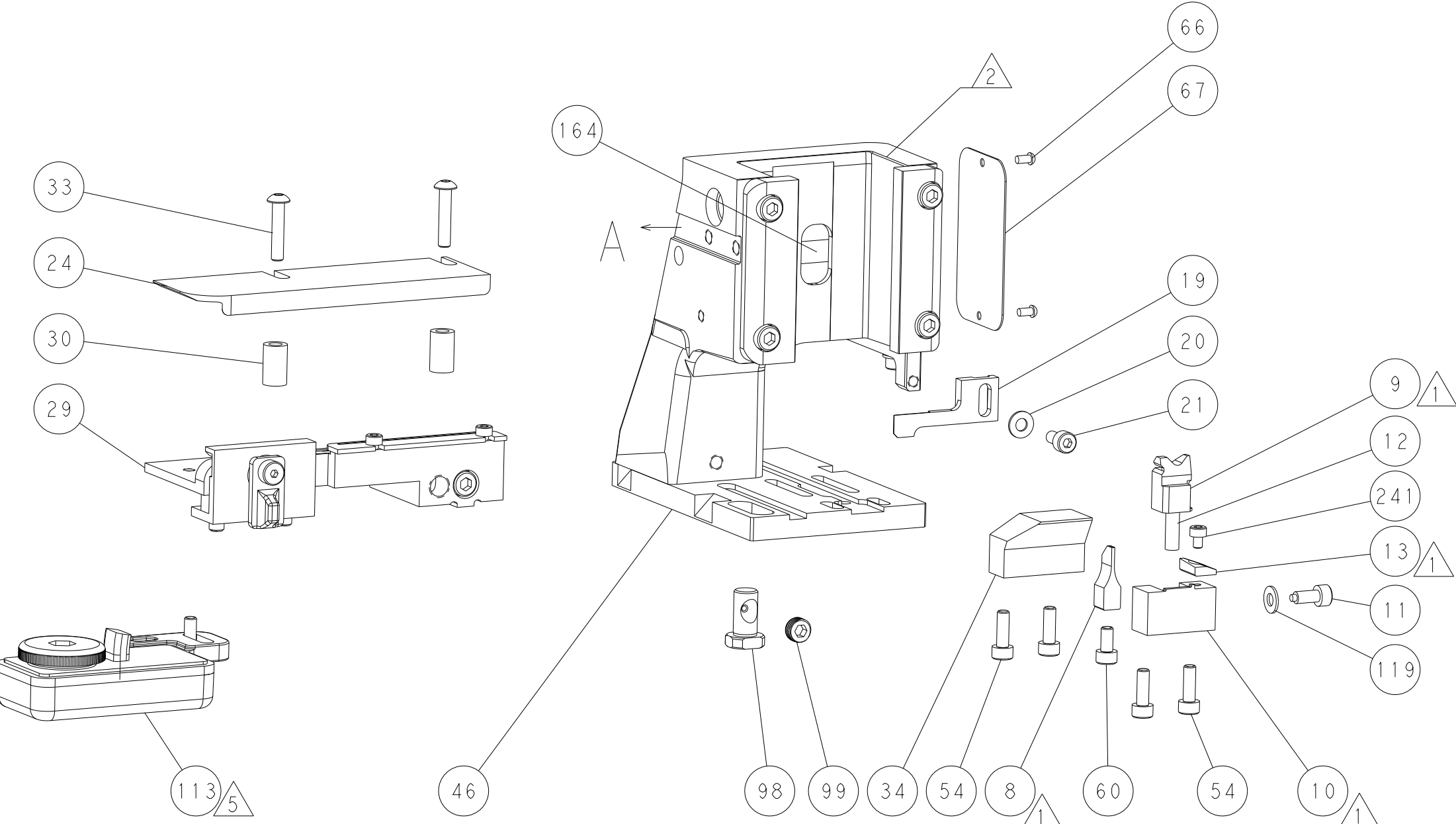
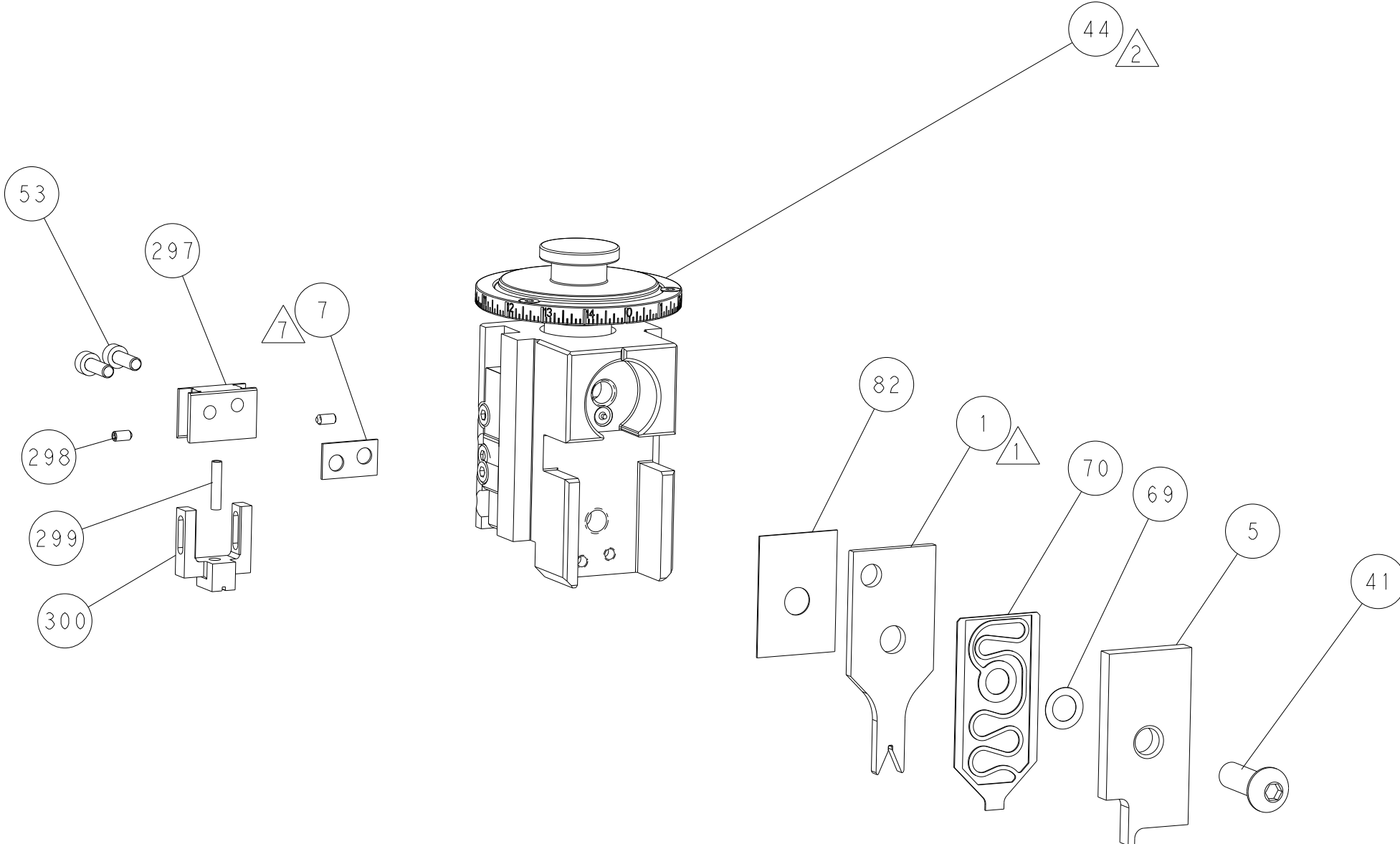
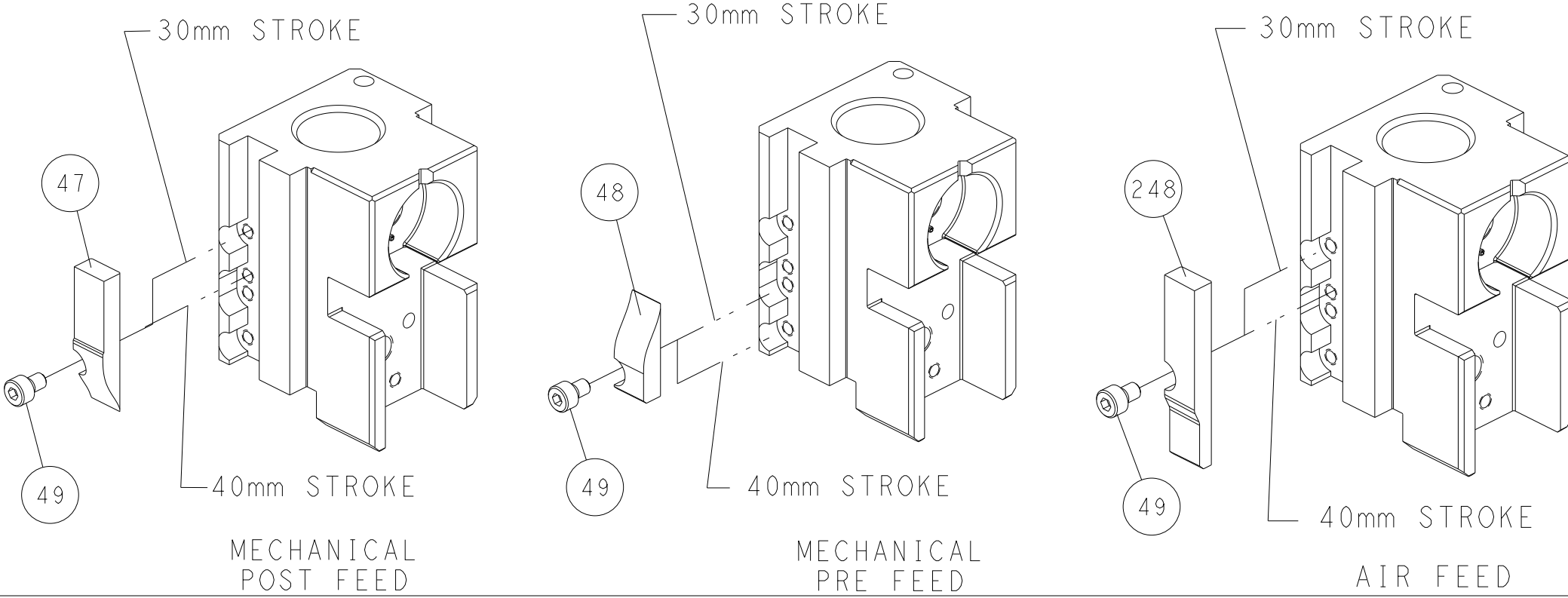


DETAIL A

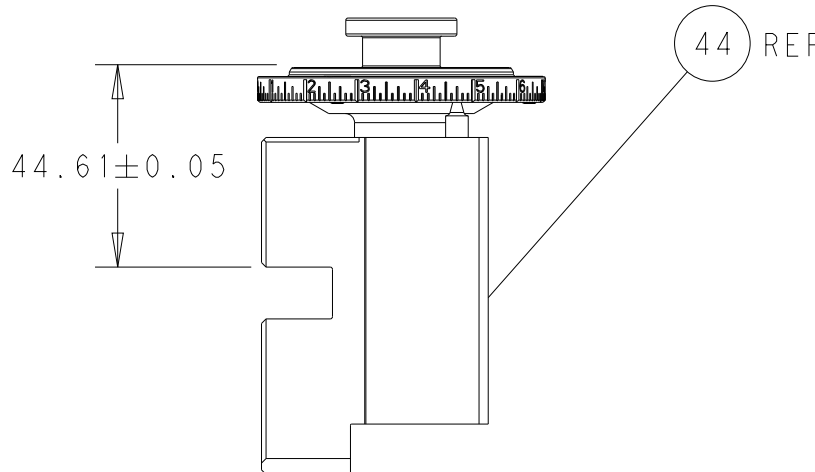
DOUBLE ACTING PNEUMATIC WITH SENSORS



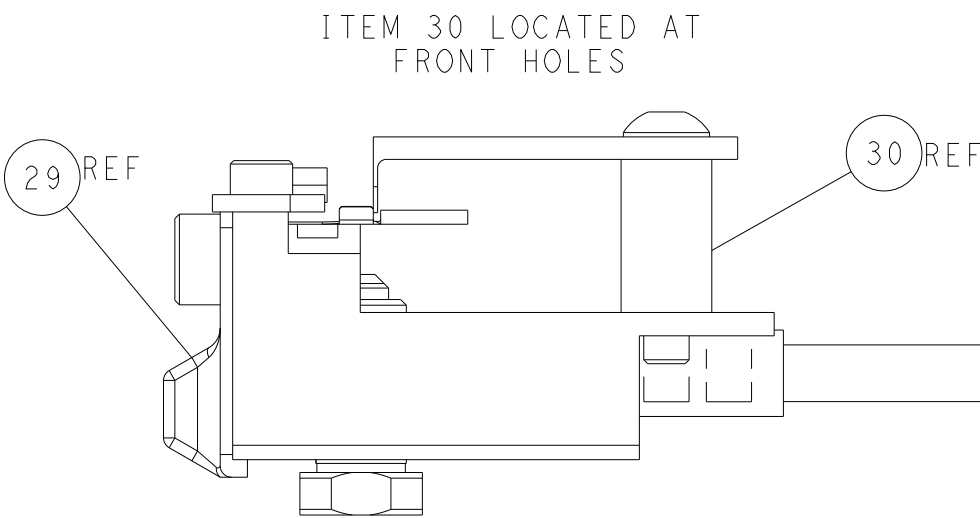
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



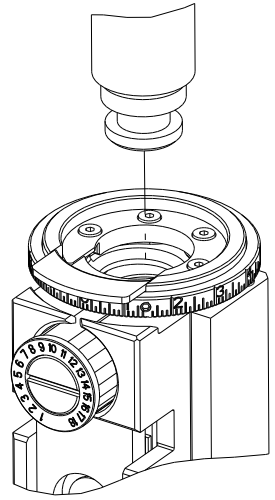
FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

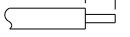


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DIMENSIONS:				PRODUCT SPEC		SIZE	
mm				APPLICATION SPEC		CAGE CODE	
TOLERANCES UNLESS OTHERWISE SPECIFIED:				WEIGHT		DRAWING NO	
0 PLC ±				Customer Accessible Production Drawing		RESTRICTED TO	
1 PLC ±				SCALE		SHEET	
2 PLC ±				1:2		2 of 4	
3 PLC ±				REV		K1	
4 PLC ±							
ANGLES FINISH							
MATERIAL							

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266046-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266046-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2266046-2	K	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2266046-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, 180 DEGREE, FAKRA			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
2.86-3.36 mm [.113-.132 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	(A)114-32145	-	-
	(B)114-32217	-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 2203260-4	(A) 1-2203260-2	(A) 2203270-4	(A) 1-2203270-2
(A) 2-2203270-3	(B) 2304634-4	(A) 4-2326900-3	(A) 2326890-4

WIRE SIZE	CRIMP HEIGHT WI _ CRIMP_UNITS	CRIMP HEIGHT REFERENCE SETTING
1.5 DS-OFB	0.73+/-0.03 [.029+/- .001]	9.4
RG-174	0.72+/-0.03 [.028+/- .001]	9.2
RG-316	0.72+/-0.03 [.028+/- .001]	9.2
DACAR 363	0.71+/-0.03 [.028+/- .001]	9.3
RG-174 LL	0.69+/-0.03 [.027+/- .001]	9.5
1.5 DS-GEC	0.67+/-0.03 [.026+/- .001]	9.7
1.5 DS-GXC-SP	0.64+/-0.03 [.025+/- .001]	10





- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.
- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ADD SPACER FOR TERMINAL 2203270.
REMOVE SPACER FOR TERMINAL 2203260.

*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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

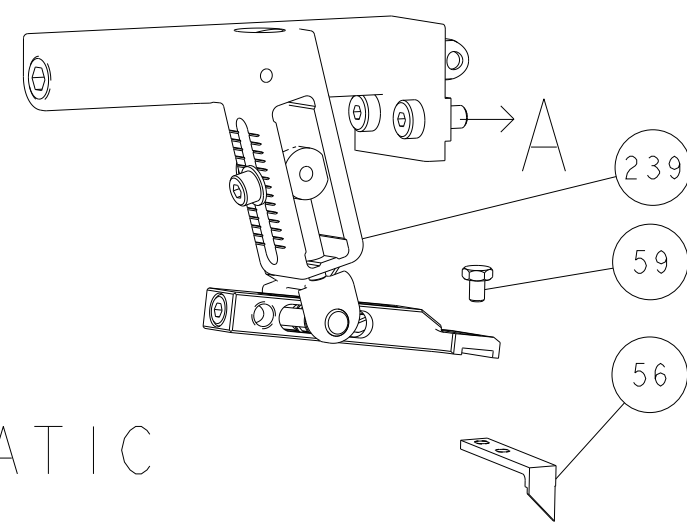
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	-	1	1	1	22278-9	SPRING, COMPRESSION	299
	-	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
	-	1	1	1	1803944-1	SPACER, TONKER	297
	-	1	-	-	2844950-1	AIR FEED MODULE	290
	-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
3	-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
5	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	2119791-3	DEPRESSOR, WIRE	70
	-	1	1	1	2119943-1	WASHER, SPACER	69
	-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
3	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	6-1752356-7	SUPPORT, TERMINAL	34
	-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
1	-	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
	-	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	5-22279-1	SPRING, COMPRESSION	12
	-	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1803418-2	FLOATING SHEAR, MINI COAX FRONT	9
1	1	1	1	1	9-1633933-8	ANVIL, COMBINATION	8
7	-	1	1	1	1-240641-9	SPACER	7
	-	-	-	-	-	-	6
	-	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
	-	-	-	-	-	-	4
	-	-	-	-	-	-	3
	-	-	-	-	-	-	2
1	1	1	1	1	3-1803224-7	CRIMPER, WIRE	1
	-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR PRO ELECTRONICS CORPORATION IT IS HEREBY REQUESTED THAT YOU CONTACT THE DRAWING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN R. O. WILSON 11OCT2013 CHK K. J. STAKEM 17OCT2013 APVD T. L. ELBIN 18OCT2013		 TE Connectively Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator	
mm				PRODUCT SPEC		-	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APPLICATION SPEC		-	
MATERIAL		-		WEIGHT		-	
				A1 00779 C=2266046		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 3 OF 4 REV K1	

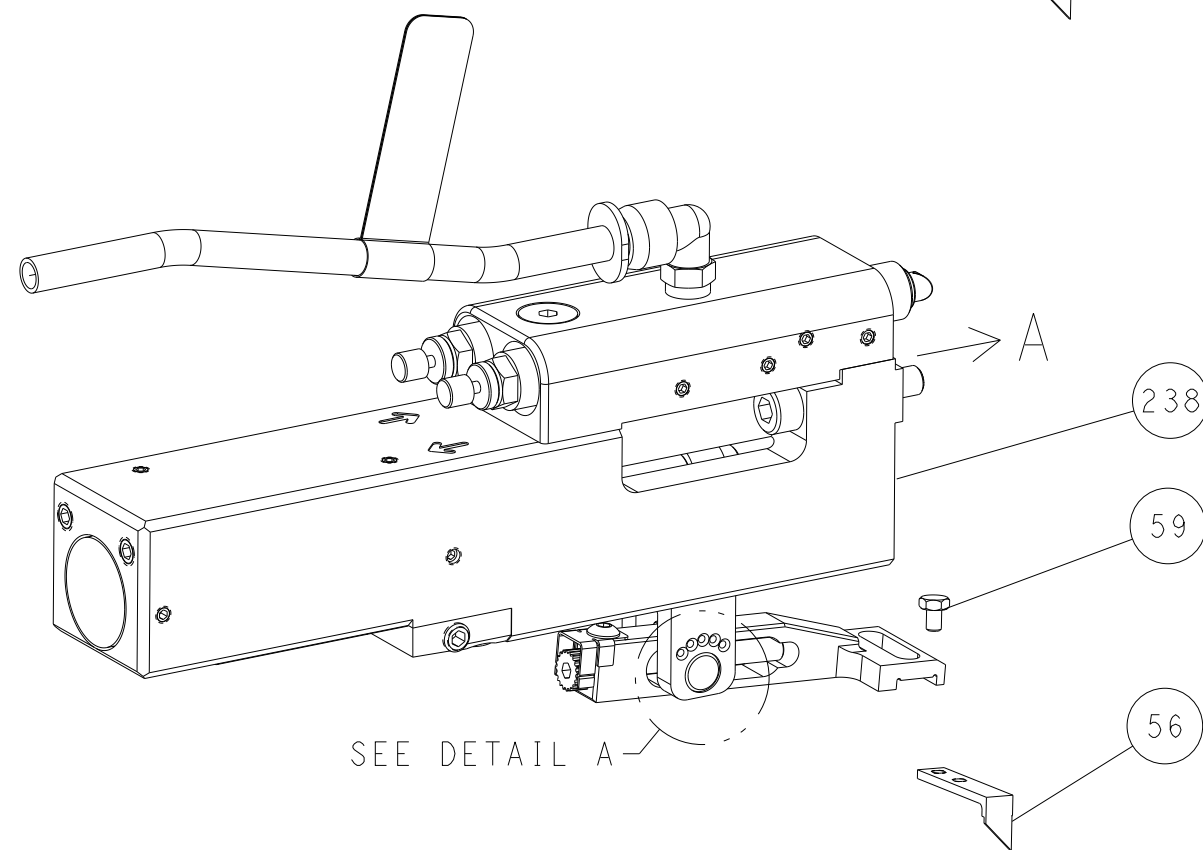
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

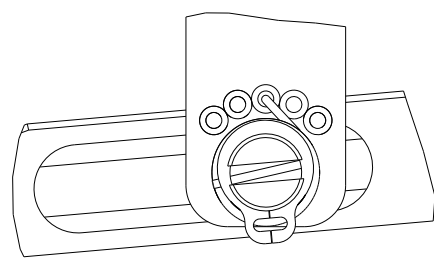
FEED TYPE MECHANICAL



PNEUMATIC

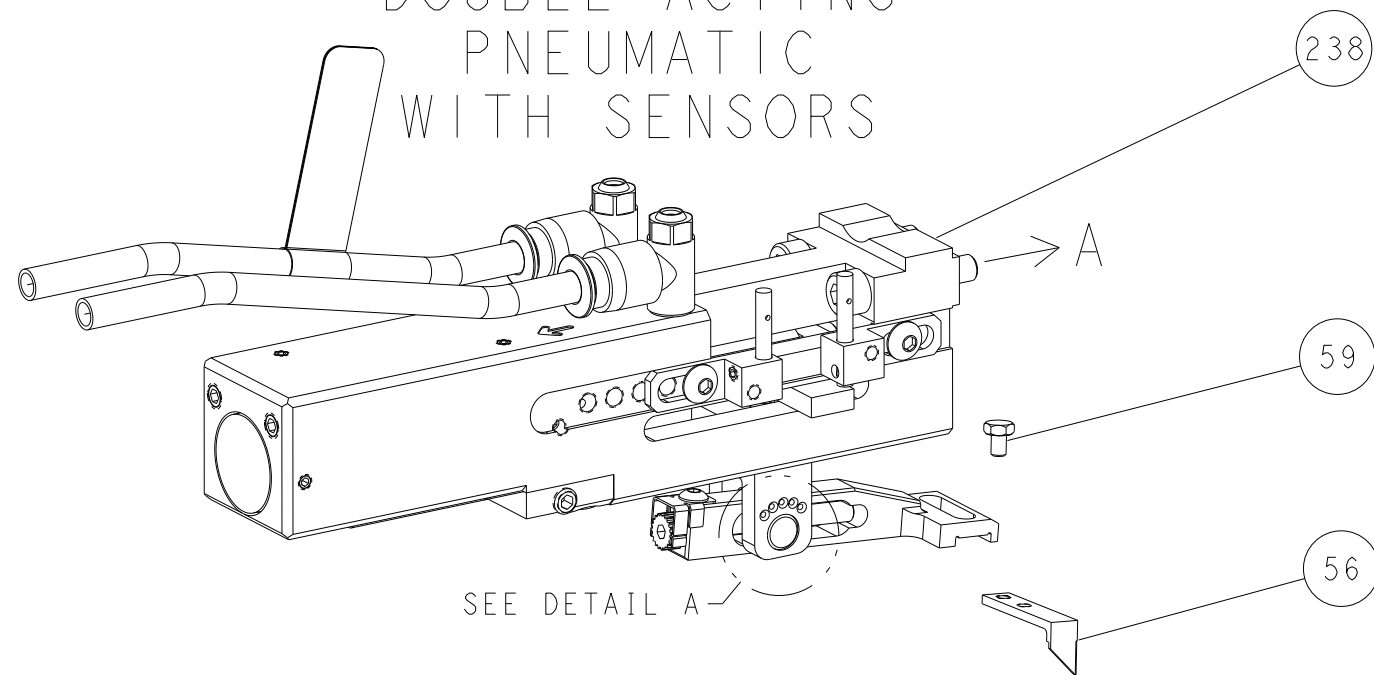


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



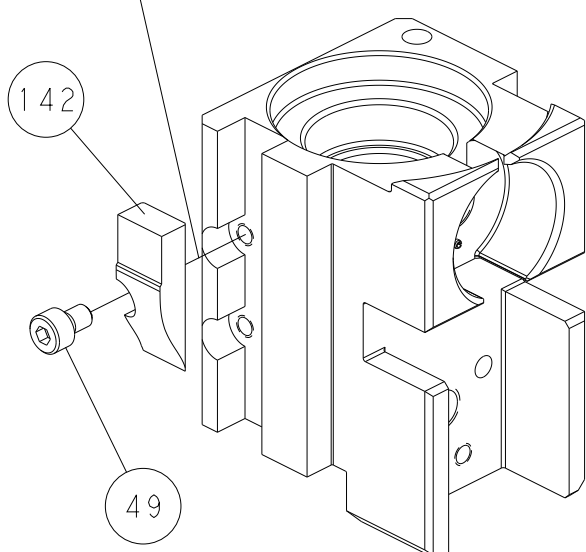
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS



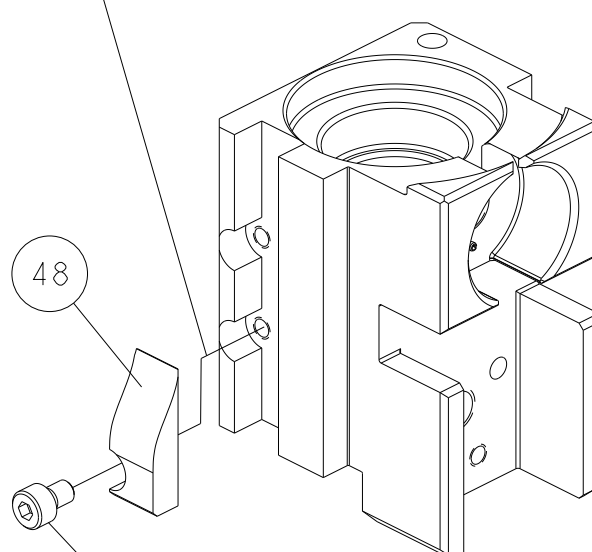
CAM POSITIONS

30mm STROKE



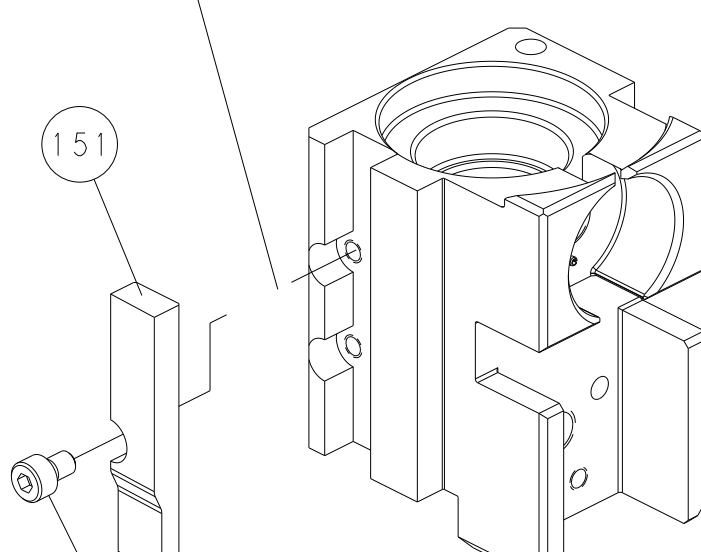
MECHANICAL POST FEED

30mm STROKE

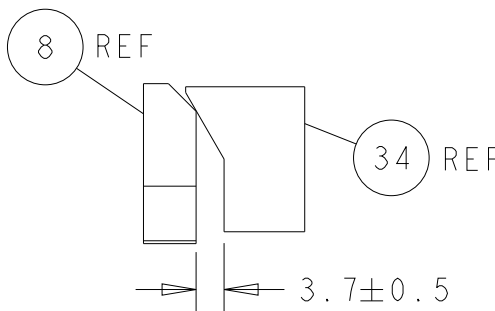
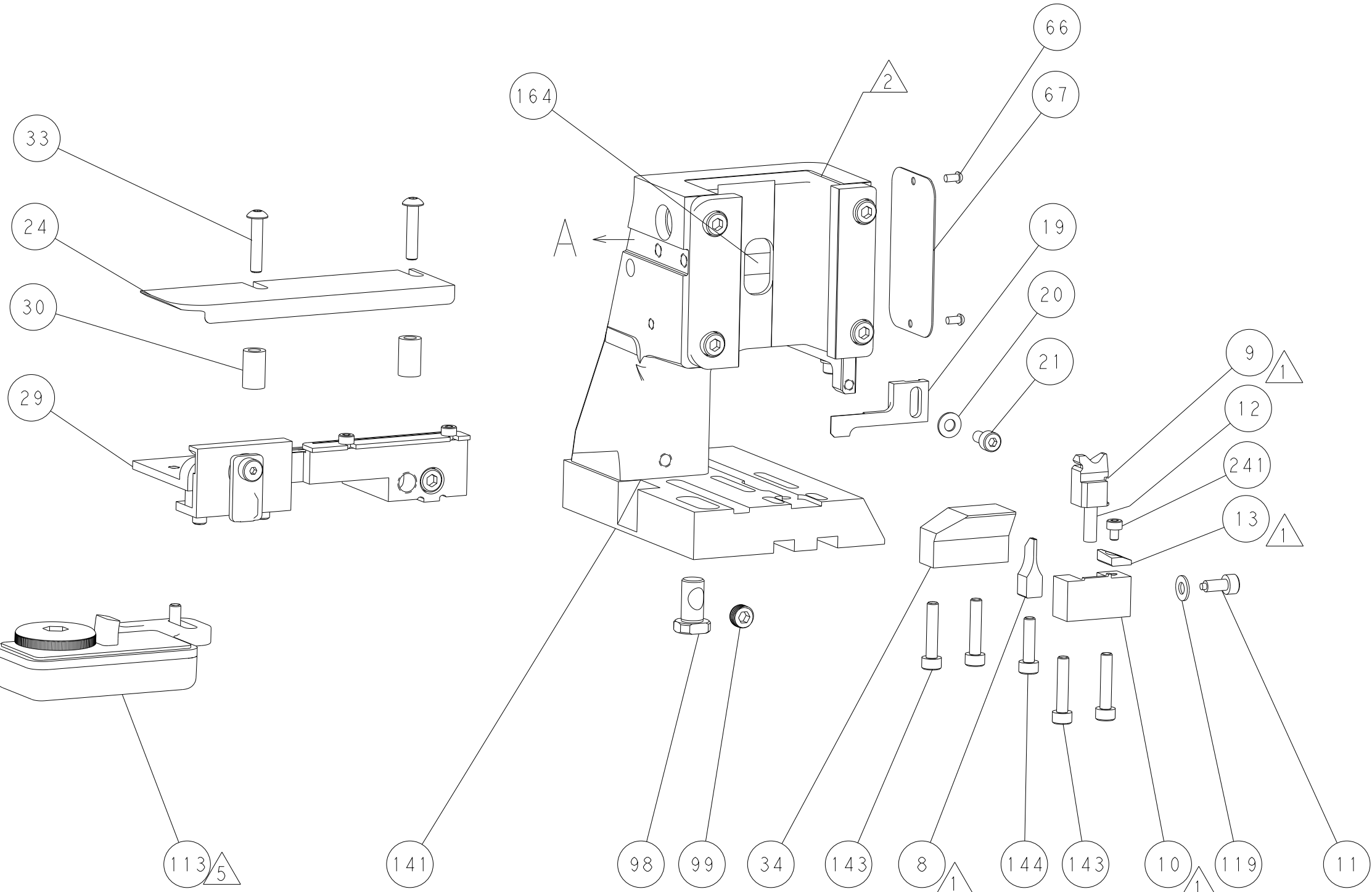
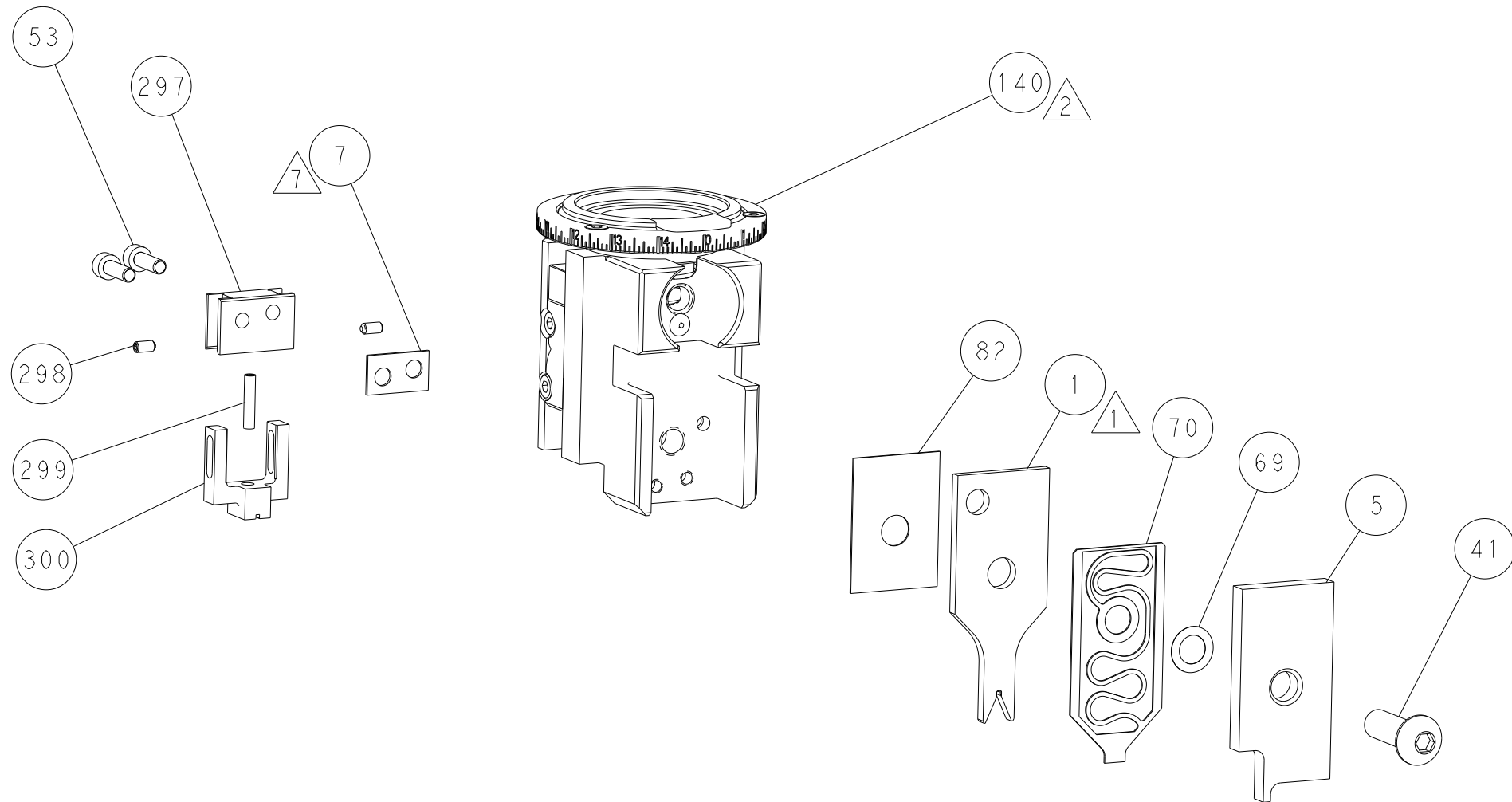


MECHANICAL PRE FEED

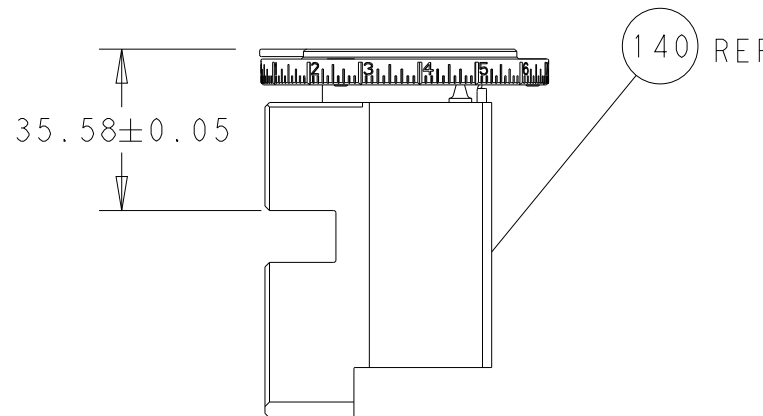
30mm STROKE



AIR FEED

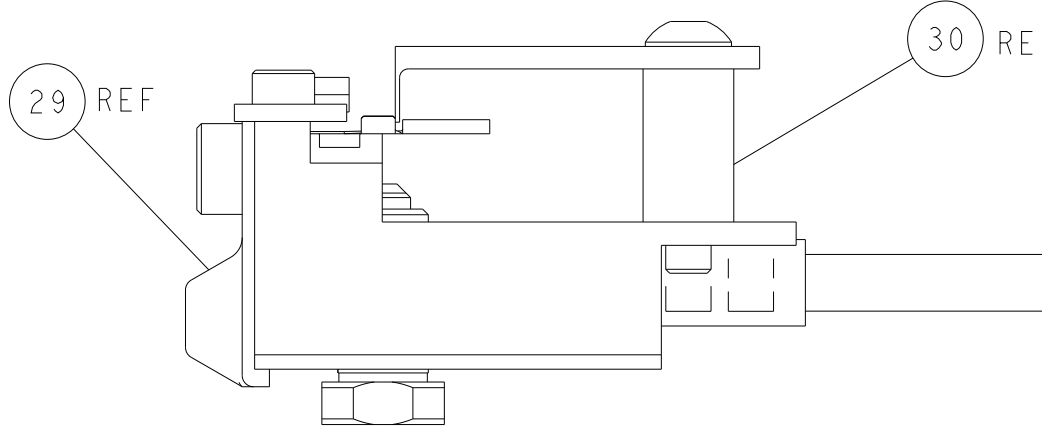


TERMINAL SUPPORT LOCATION




RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

TIT: DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CONTROLLED DOCUMENT AND INSPECTION ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST VERSION				DWN R.O. WILSON CHK K.J. STAKEM APVD T.L. ELBIN		11OCT2013 17OCT2013 18OCT2013		TE Connectivity Harrisburg, PA 17105-3608					
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC APPLICATION SPEC		NAME Ocean Side Feed Applicator		SIZE CAGE CODE DRAWING NO					
		-		WEIGHT -		A1		00779		C=2266046		RESTRICTED TO -	
MATERIAL -		-		Customer Accessible Production Drawing		SCALE 1:2		SHEET 4		OF 4		REV K	