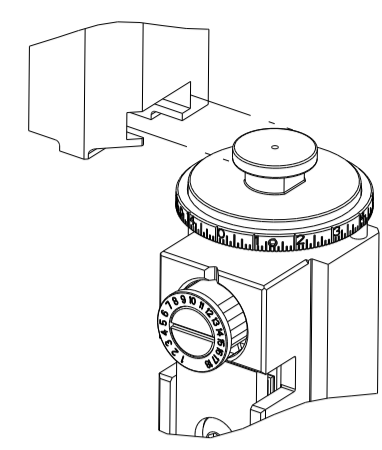


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266170-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2266170-2	E	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2266170-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266170-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



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
9	∅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
RG-174 ANTENNA	2.87+/-0.03 [.113+/- .001]	9.0
1.5DS - OFB (TA)	2.84+/-0.03 [.112+/- .001]	9.3
DAKAR 462	2.75+/-0.03 [.108+/- .001]	10.3
RG-174	2.75+/-0.03 [.108+/- .001]	10.3
RG-174LL	2.75+/-0.03 [.108+/- .001]	10.3
RG-316	2.75+/-0.03 [.108+/- .001]	10.3

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- SEE APPLICATION SPECIFICATION, 114-32145 FOR SOLDER DIAMETER TO VERIFY BRAID CRIMP HEIGHT.
- ITEM 1 WIRE CRIMP WIDTH 2.79mm [.110 IN].
- ITEM 178 WIRE CRIMP WIDTH 2.92mm [.115 IN].
- SEE APPLICATION SPECIFICATION 114-32145 FOR RECOMMENDED STRIP LENGTH DIMENSIONS.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.

***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
		D3		ECR-20-015808	10NOV2020	JWC	GB
		E		ECR-20-018104	28DEC2020	FJ	RK
		E1		ECR-21-006797	09JUL2021	FZ	RK
		E2		ECR-22-146148	14JUL2022	FJ	JAH

-	-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	1803078-3	SPACER, PRECISION	259
-	1	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	-	1	2844940-1	AIR FEED MODULE	238
-	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	225
-	2	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	224
-	1	1	1	1803306-1	PLATE, RETAINING	223
-	1	1	1	1803340-1	PLATE, RETAINING	222
-	1	1	1	1752354-6	STANDOFF, HOLD-DOWN	180
-	1	1	1	2-1976053-6	LOCATER BLOCK, TERMINAL	179
1	1	1	1	1-1633723-9	CRIMPER, WIRE 0	178
-	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	318563-1	GUARD, FRONT CHIP	89
-	1	1	1	1-455888-0	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338683-8	FEED PAWL	56
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1901681-8	HOLDDOWN, TERMINAL	51
-	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	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	1803308-1	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	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	2	1	1803160-4	ANVIL	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
1	1	2	1	1-1633996-1	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1-455888-8	SPACER, CRIMPER	2
1	1	2	1	1-1633723-7	CRIMPER, WIRE 0	1

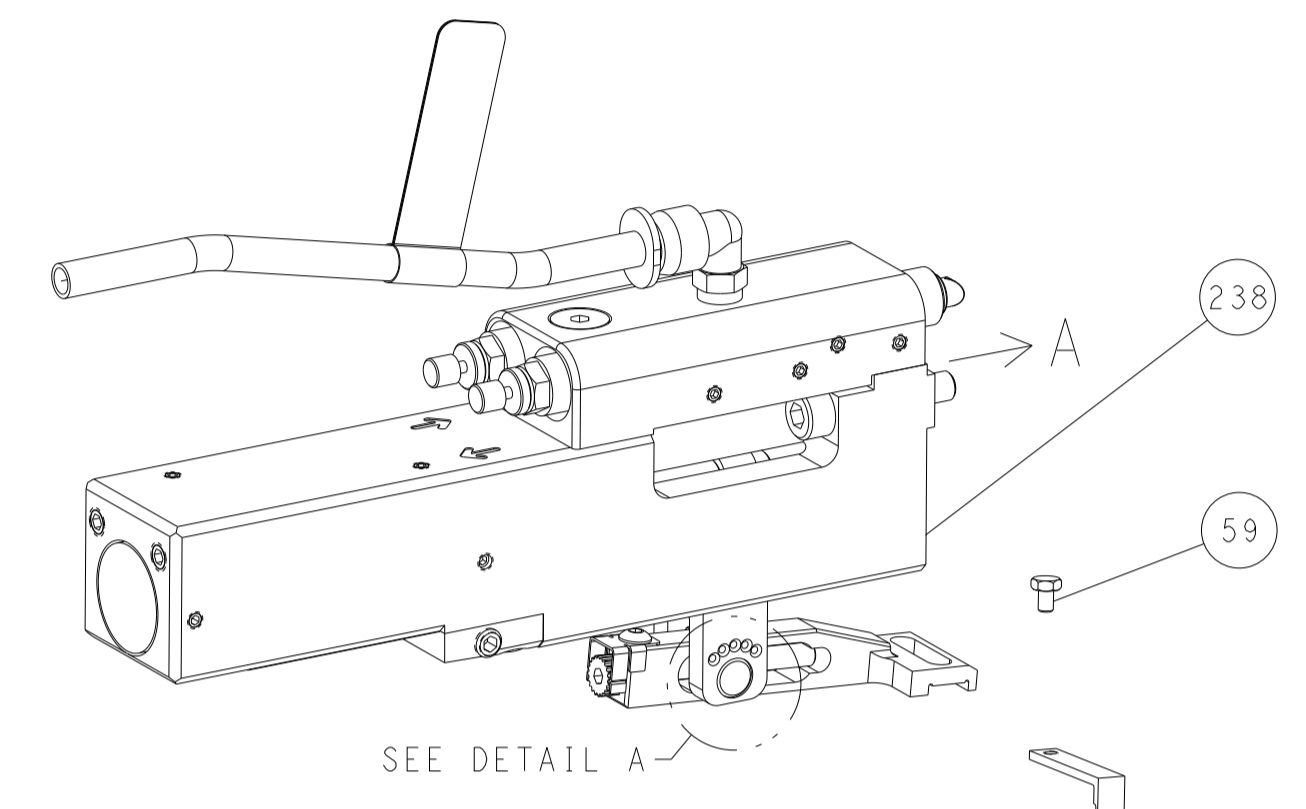
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: R. O. WILSON 21NOV2013		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CHK: K. J. STARKM 21NOV2013		NAME: Ocean Side Feed Applicator	
2 PLC ±		3 PLC ±		APVD: T. L. ELBIN 21NOV2013		SIZE: A1	
4 PLC ±		ANGLES ±		FINISH		CAGE CODE: 00779	
MATERIAL		WEIGHT		DRAWING NO: 2266170		RESTRICTED TO: -	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 1 OF 4	
				REV: E2			

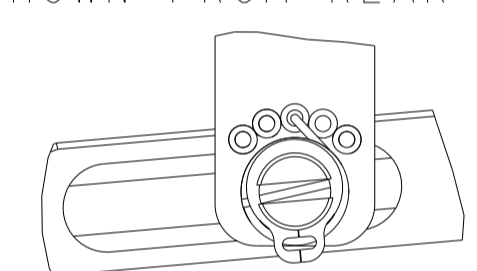
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

FEED TYPE

PNEUMATIC

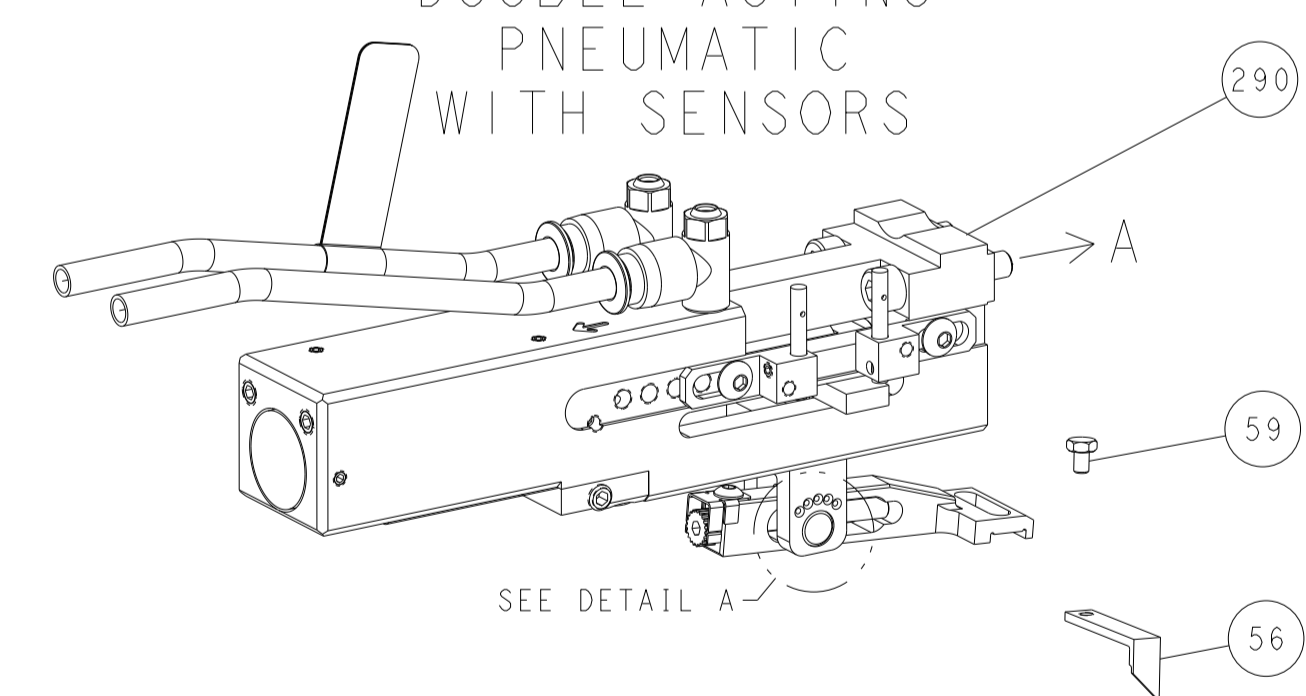


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

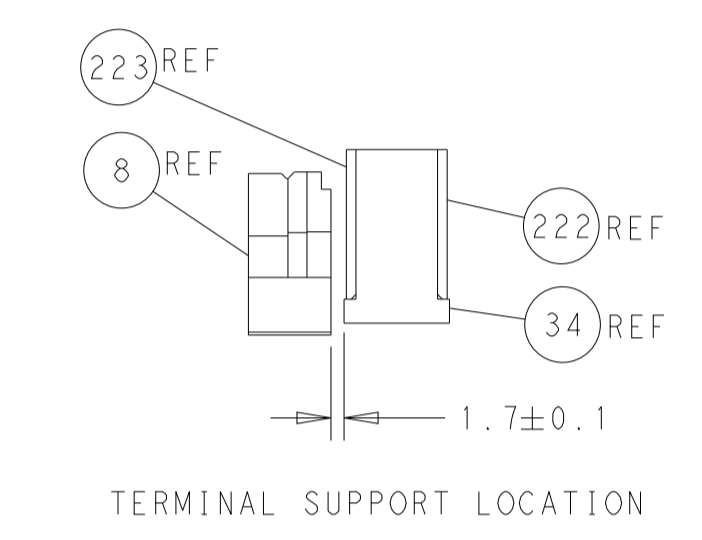
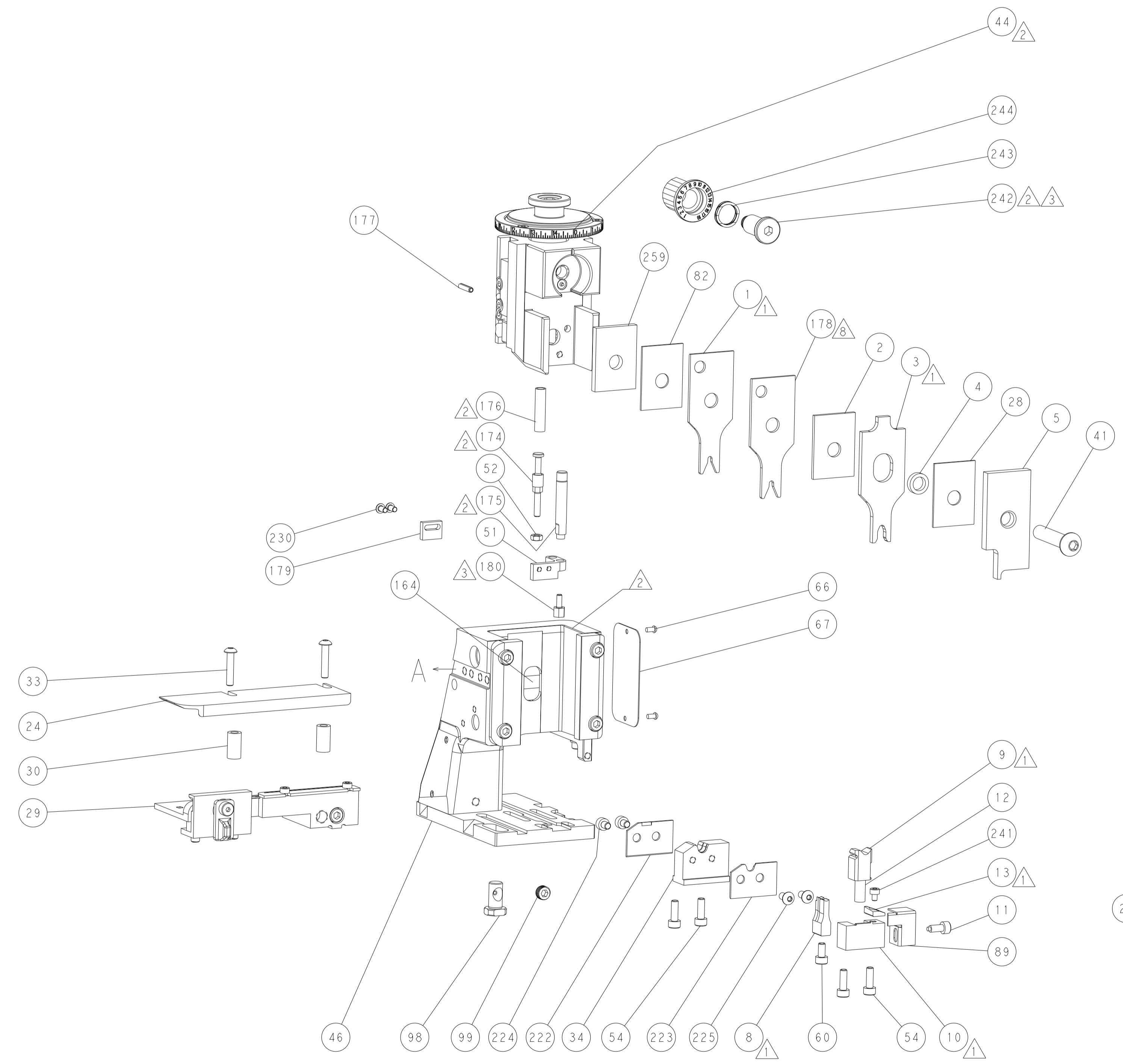
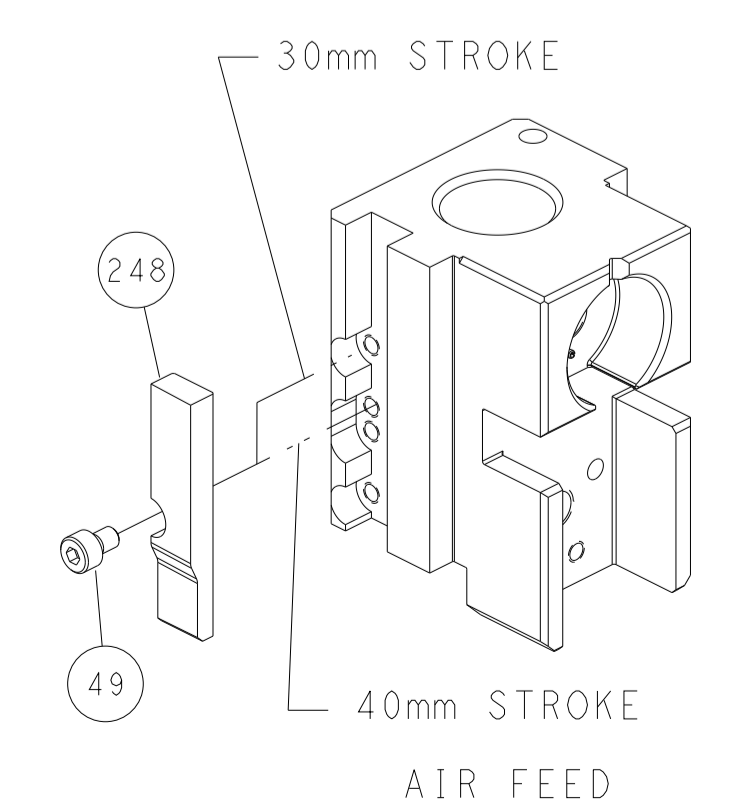


DETAIL A

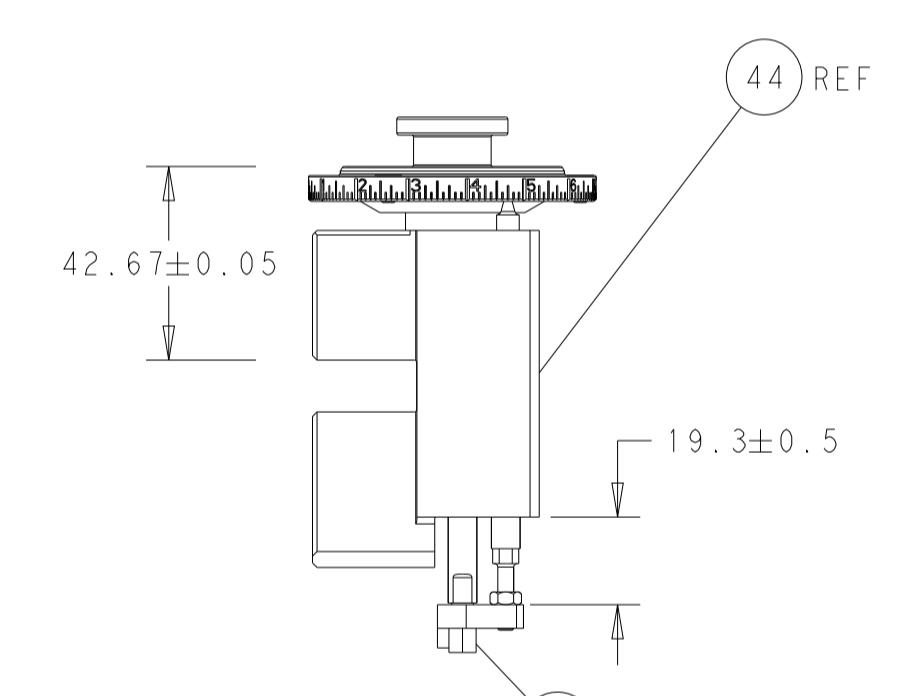
DOUBLE ACTING PNEUMATIC WITH SENSORS



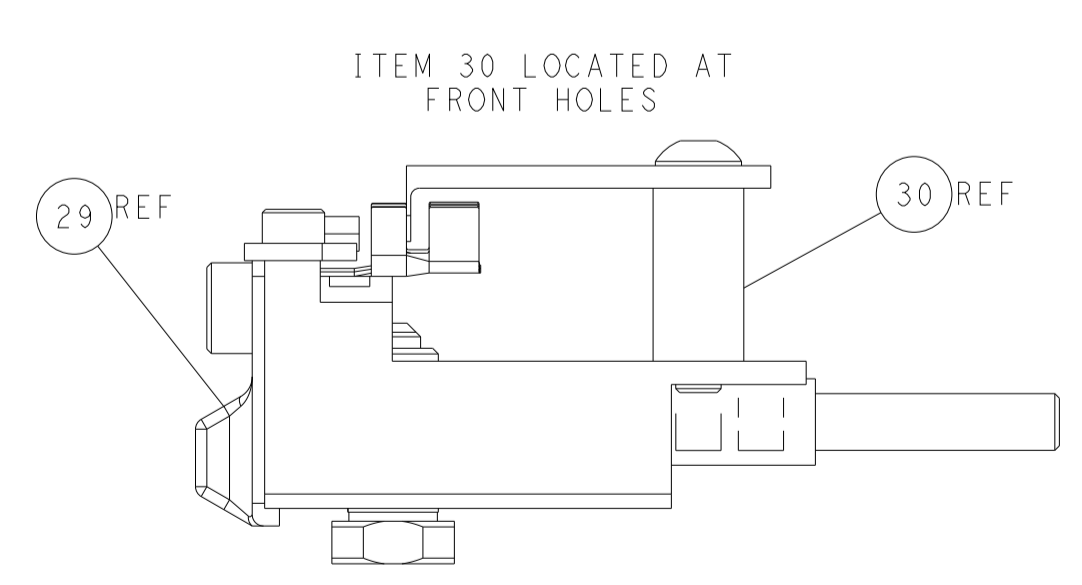
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small> <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small>		DWN R.O. WILSON 21NOV2013 CHK K.J. STAKEM 21NOV2013 APVD T.L. ELBIN 21NOV2013	NAME Ocean Side Feed Applicator SIZE A1 CAGE CODE 00779 DRAWING NO. C-2266170 SCALE 1:2 SHEET 2 OF 4 REV E2	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	MATERIAL:	WEIGHT:	RESTRICTED TO:	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266170-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2266170-2	E	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2266170-7	A	CRIMP TOOLING KIT	-

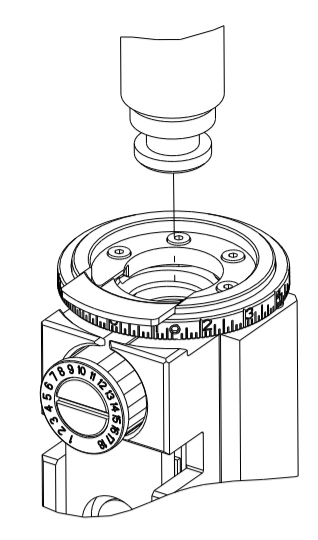
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE 1	2.79 mm [.110]	0
WIRE 2	2.92 mm [.115]	0
INSUL	3.56 mm [.140]	0

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			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2203259-2	2326889-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-174 ANTENNA	2.87 +/- 0.03 [.113 +/- .001]	9.0
1.5DS - QFB (TA)	2.84 +/- 0.03 [.112 +/- .001]	9.3
DAKAR 462	2.75 +/- 0.03 [.108 +/- .001]	10.3
RG-174	2.75 +/- 0.03 [.108 +/- .001]	10.3
RG-174LL	2.75 +/- 0.03 [.108 +/- .001]	10.3
RG-316	2.75 +/- 0.03 [.108 +/- .001]	10.3

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



***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.

- 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.
- 11 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.

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

-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	1803078-3	SPACER, PRECISION	259
-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	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
-	1	1	1752354-6	STANDOFF, HOLD-DOWN	180
-	1	1	2-1976053-6	LOCATER BLOCK, TERMINAL	179
1	-	1	1-1633723-9	CRIMPER, WIRE O	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	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-8	FEED PAWL	56
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-8	HOLDDOWN, TERMINAL	51
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	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	1	3-1633996-1	CRIMPER, INSULATION SPECIAL	3
-	1	1	1-455888-8	SPACER, CRIMPER	2
1	1	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)

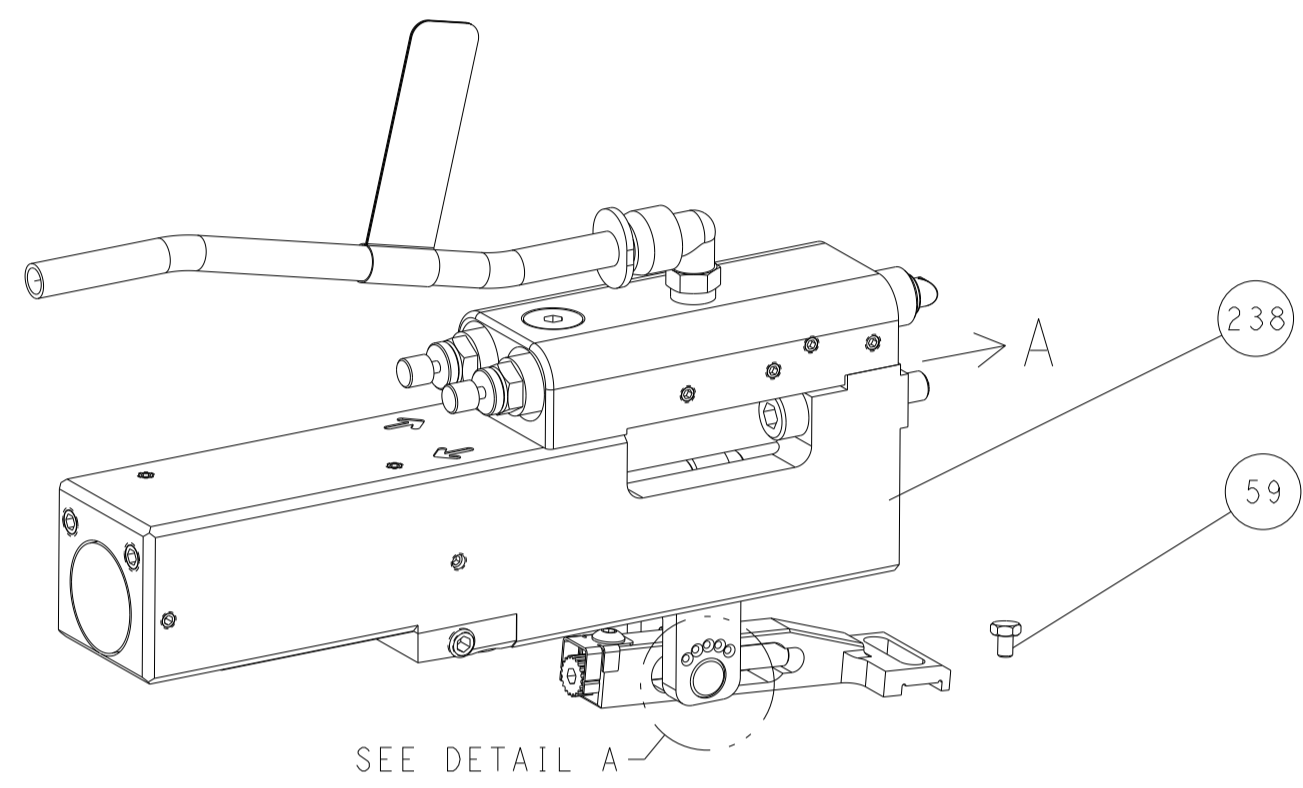
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

DRW	CHK	APVD	DATE	NAME	SCALE	SHEET	OF	REV
R. O. WILSON	K. J. STARKEM	T. L. ELBIN	21NOV2013	Ocean Side Feed Applicator	1:2	3	4	E2

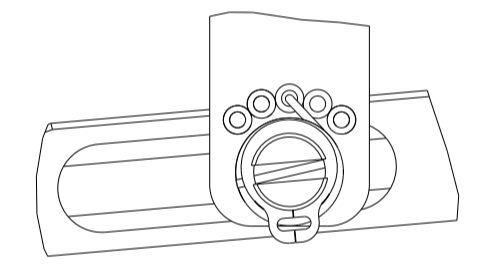
Customer Accessible Production Drawing

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

FEED TYPE PNEUMATIC

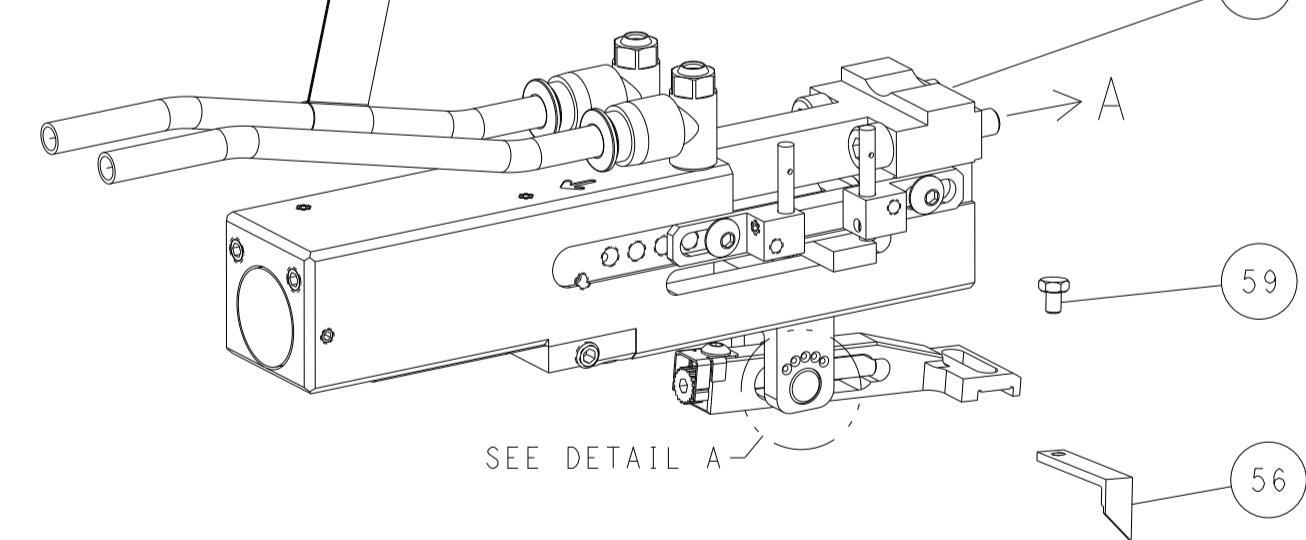


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

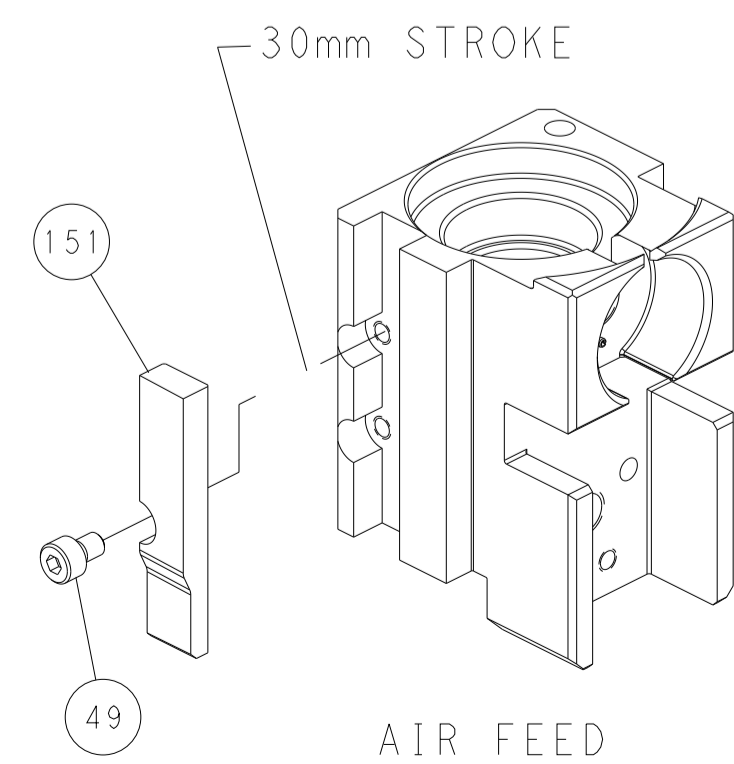


DETAIL A

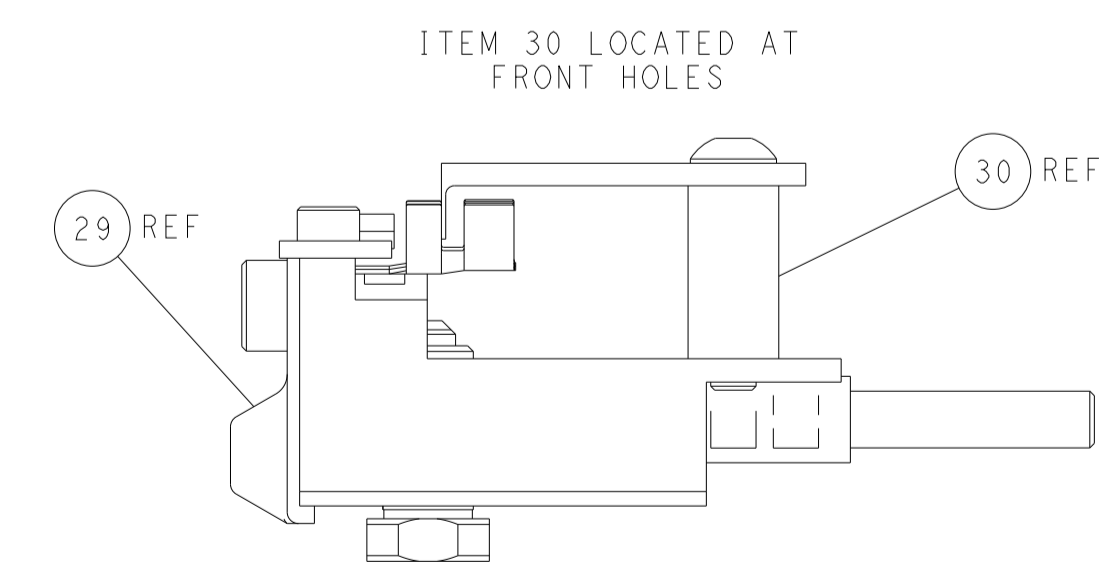
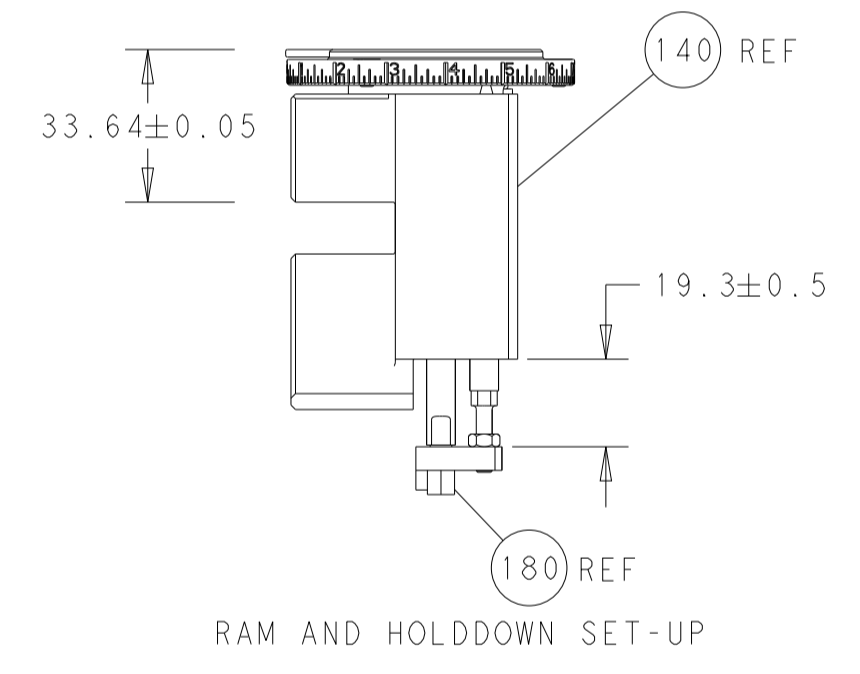
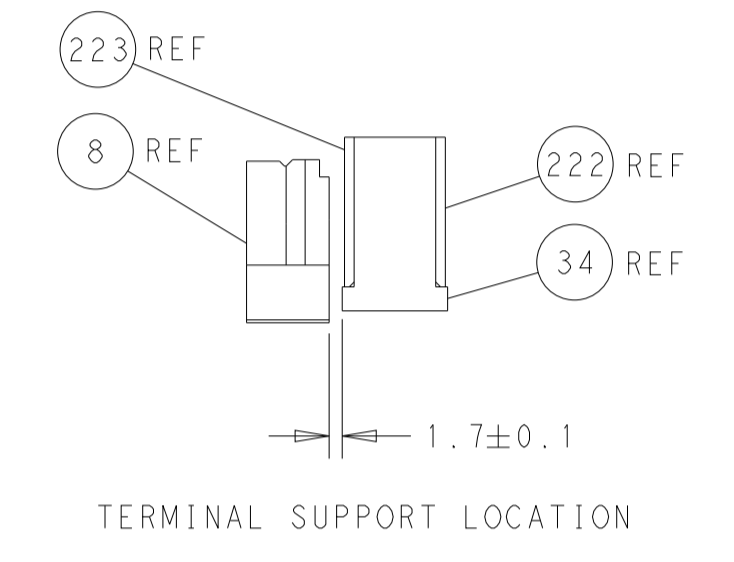
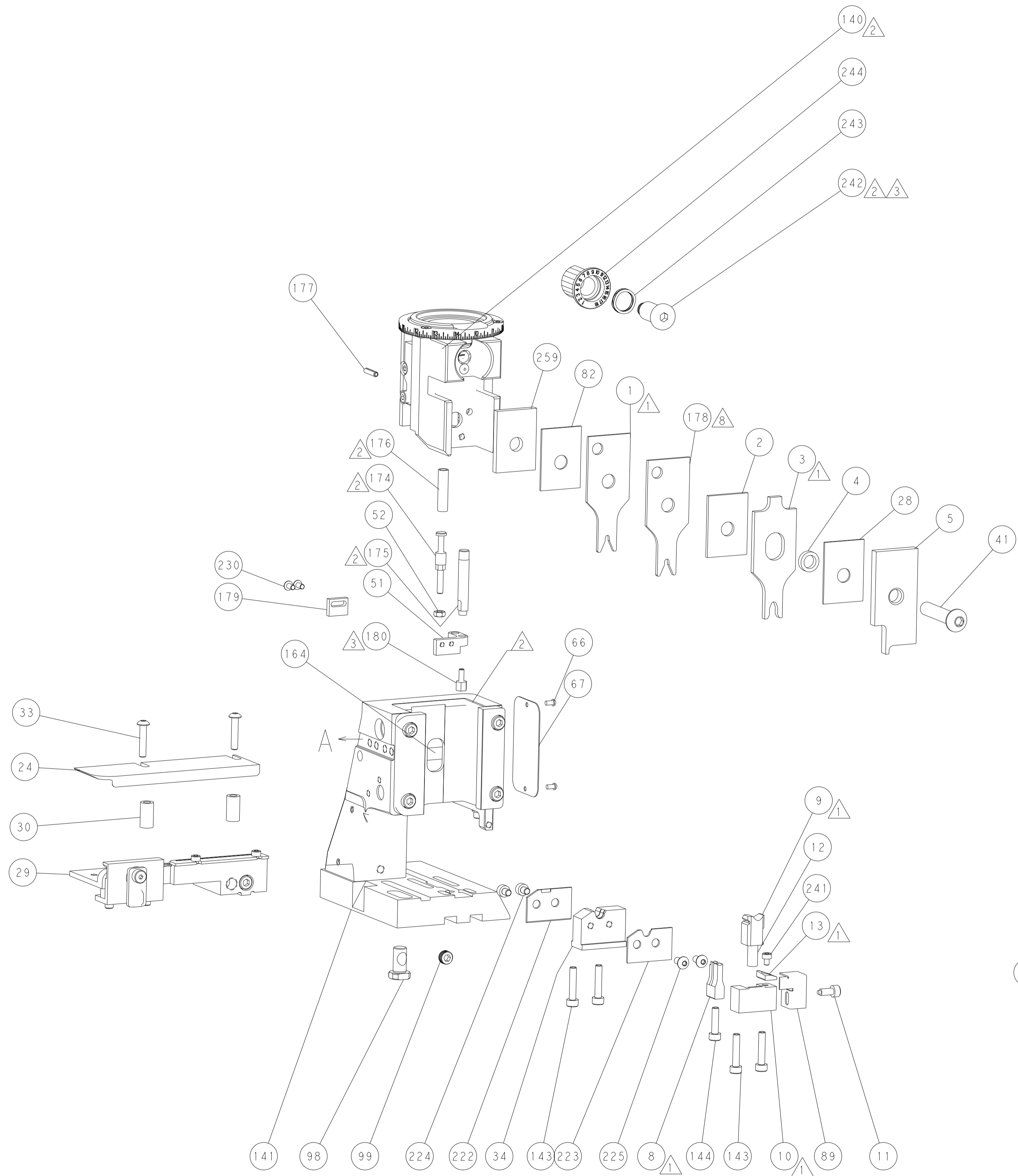
DOUBLE ACTING PNEUMATIC WITH SENSORS



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2266170 WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SHEET 4 OF 4 REV E2