

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266165-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266165-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266165-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266165-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266165-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS
408-35042

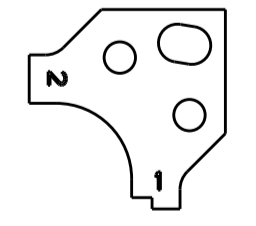
TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: MICRO QUADOCK SYSTEM			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.05-3.35 mm [.120-.132 IN]	Ø1.15-1.60 mm [.045-.063 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18021		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928999-1	5-928999-5	1-928918-1	6-928918-2
928999-5	5-928999-6	1-928918-2	6-928918-3
928999-6	6-928999-5	5-928918-1	
1-928999-5	928918-1	5-928918-2	
5-928999-1	928918-2	6-928918-1	

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: MICRO QUADOCK SYSTEM			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.05-3.35 mm [.120-.132 IN]	Ø1.25-1.70mm [.049-.067 IN]		
TERMINAL APPLICATION SPECIFICATION	114-15077		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1801528-1	1801528-2	1379419-1	1379419-2
5-1379419-1	5-1379419-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	0.83+/-0.03 [.033+/-0.001]	4.6
0.35mm ²	0.74+/-0.03 [.029+/-0.001]	5.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	0.79+/-0.03 [.031+/-0.001]	5.0
0.35mm ²	0.74+/-0.03 [.029+/-0.001]	5.5
0.25mm ²	0.72+/-0.03 [.028+/-0.001]	5.3

- 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 REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm² WIRE.
 - 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 REFER TO SHEET 2.



***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)

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APPV
A	66						
		C1		ECR-17-017223	22NOV2017	JAH	CT
		D		ECR-00-005151	20APR2018	TB	JDG
		D1		ECR-19-007996	20MAY2019	FJ	MP
		E		ECR-19-005769	27JUN2019	FJ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1	1633782-2	FENCE	78
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	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
-	1	1	1	1	2217529-1	TERMINAL HOLD DOWN	18
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1-1338690-2	ANVIL, COMBINATION .055	8
-	1	1	1	1	4-240641-2	SPACER	7
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	2	1	1	1-562108-5	CRIMPER, WIRE, F	1

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

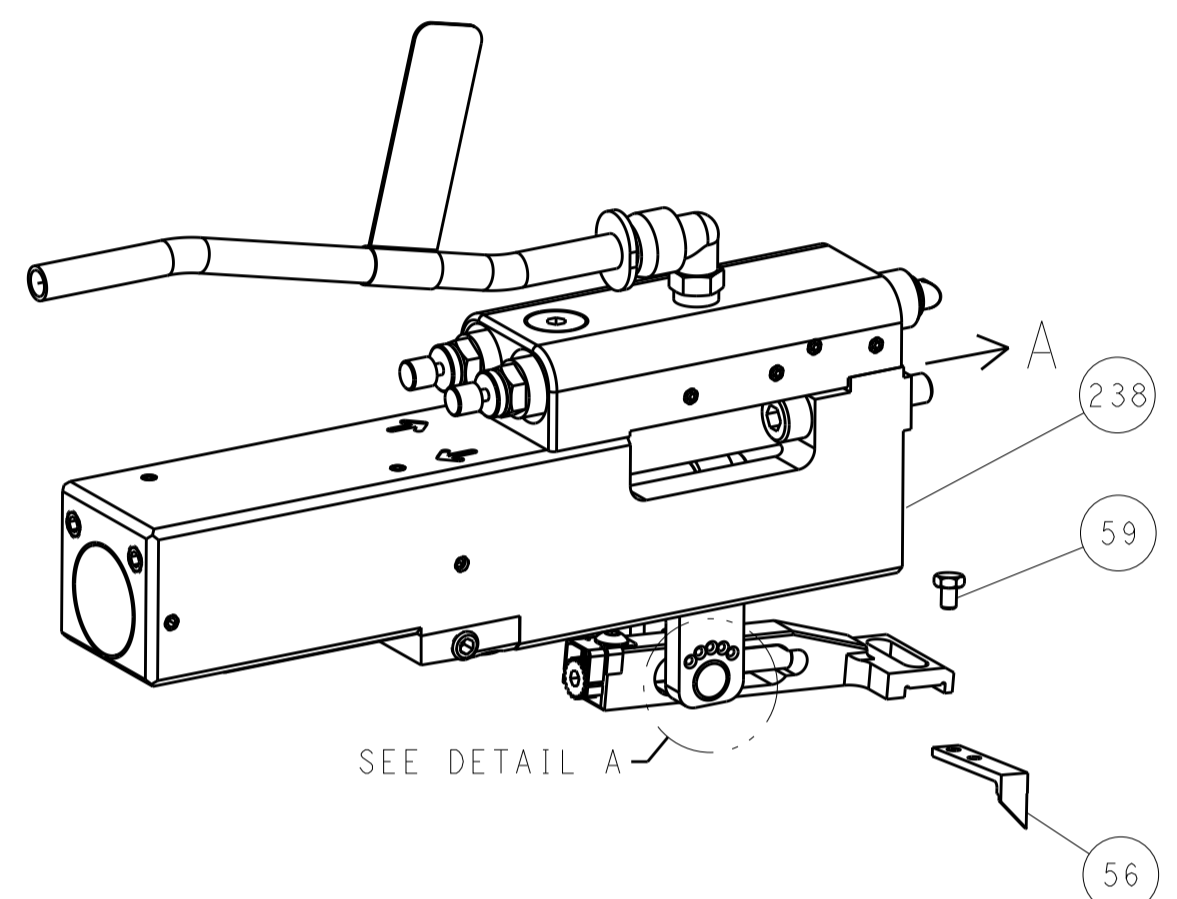
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CHK	G. BAILEY	13JAN2014	
APPV	M. CLIFFORD	13JAN2014	
NAME	Ocean Side Feed Applicator		
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266165	
Customer Accessible Production Drawing		SCALE	5:1 SHEET 1 OF 4 REV E

LOC	DIST	REV	DATE	BY	APPV
A	66				

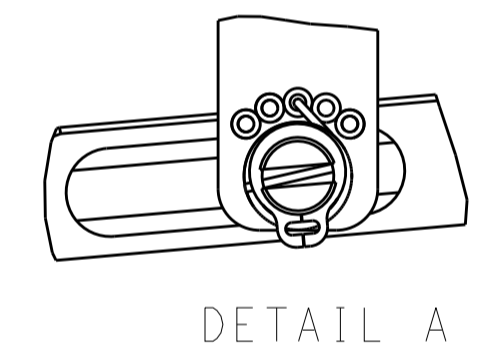
FEED TYPE MECHANICAL



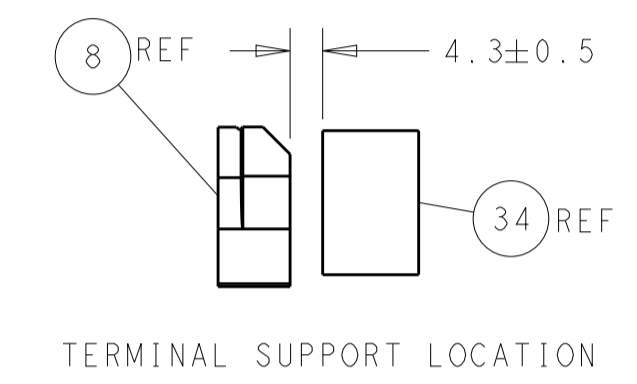
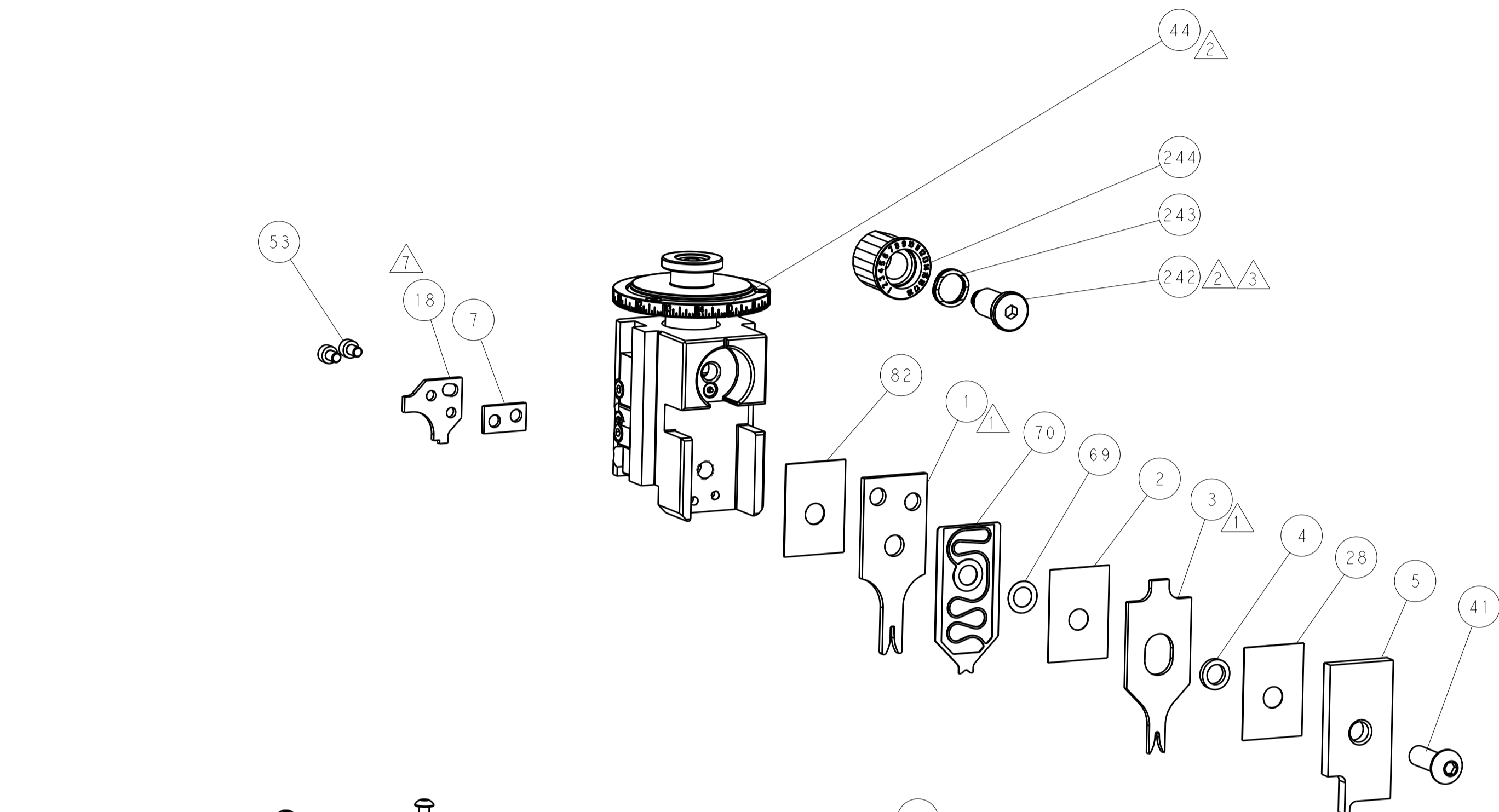
PNEUMATIC



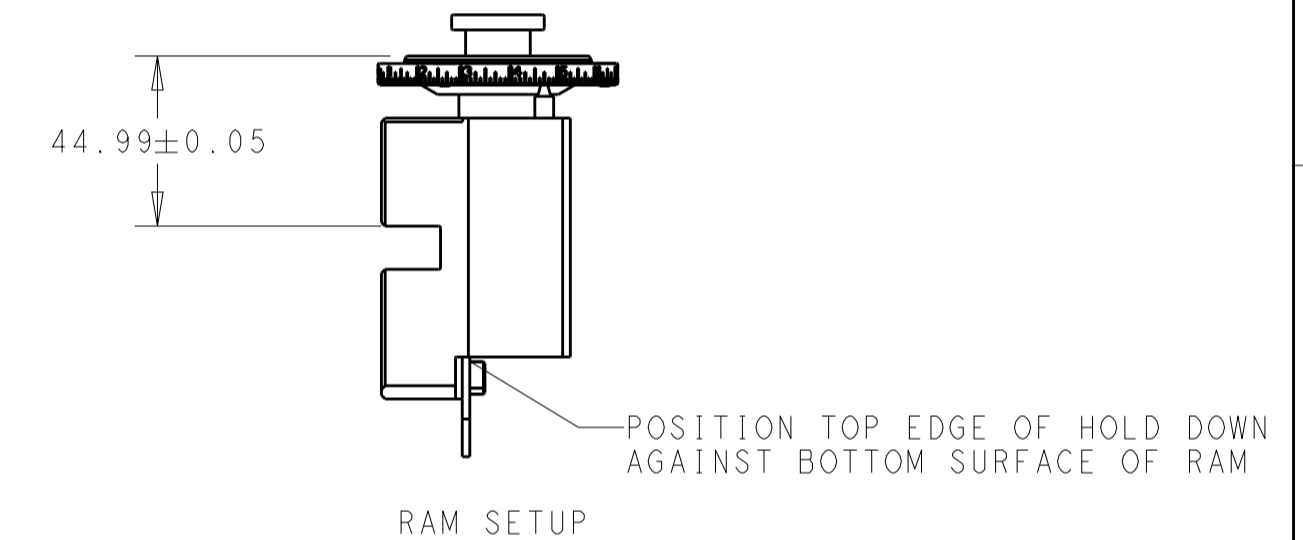
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

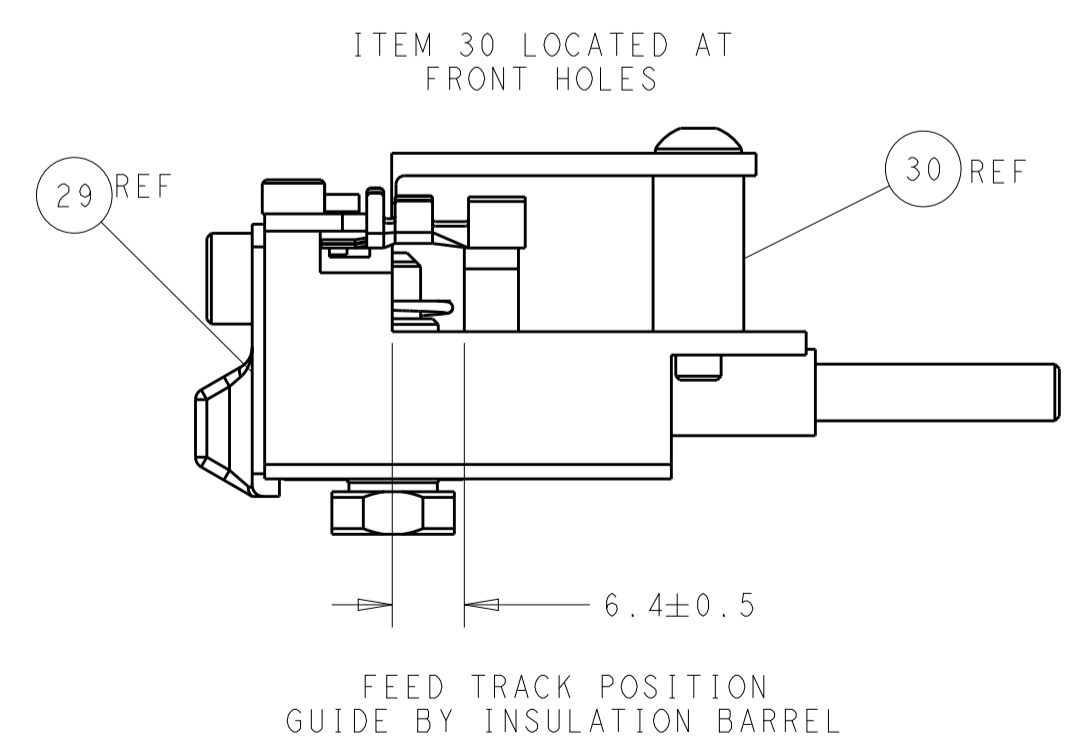


TERMINAL SUPPORT LOCATION



RAM SETUP

CAM POSITIONS



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN BOB HIGMAN 13JAN2014 CHK G. BAILEY 13JAN2014 APVD M. CLIFFORD 13JAN2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 ©=2266165 SCALE 5:1 SHEET 2 OF 4 REV E	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266165-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266165-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266165-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



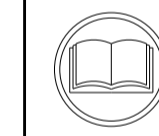
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADOCK SYSTEM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.05-3.35mm [.120-.132 IN]		∅ 1.1-.1.60mm [.043-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18021		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928999-1	5-928999-5	1-928918-1	6-928918-2
928999-5	5-928999-6	1-928918-2	6-928918-3
928999-6	6-928999-5	5-928918-1	
1-928999-5	928918-1	5-928918-2	
5-928999-1	928918-2	6-928918-1	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADOCK SYSTEM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.05-3.35 mm [.120-.132 IN]		∅ 1.25-1.70mm [.049-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	114-15077		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1801528-1	1801528-2	1379419-1	1379419-2

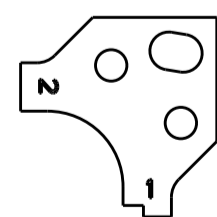
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	0.79+/-0.03 [.031+/- .001]	5.0
0.35mm ²	0.74+/-0.03 [.029+/- .001]	5.5
0.25mm ²	0.72+/-0.03 [.028+/- .001]	5.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	0.83+/-0.03 [.033+/- .001]	4.6
0.35mm ²	0.74+/-0.03 [.029+/- .001]	5.5



- 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.
- REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm² WIRE.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 REFER TO SHEET 4.



***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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-5	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	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	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	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1633782-2	FENCE	78
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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	1338685-1	PAWL, FEED	56
-	2	2	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-2	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	2217529-1	TERMINAL HOLD DOWN	18
-	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	1-1338690-2	ANVIL, COMBINATION .055	8
-	1	1	4-240641-2	SPACER	7
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	1-562108-5	CRIMPER, WIRE, F	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH
MATERIAL		FINISH		WEIGHT		SCALE	
-		-		-		5:1	

OWN	CHK	DATE	NAME	PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
BOB HIGMAN	G. BAILEY	13JAN2014	M. CLIFFORD			A1	00779	2266165	E

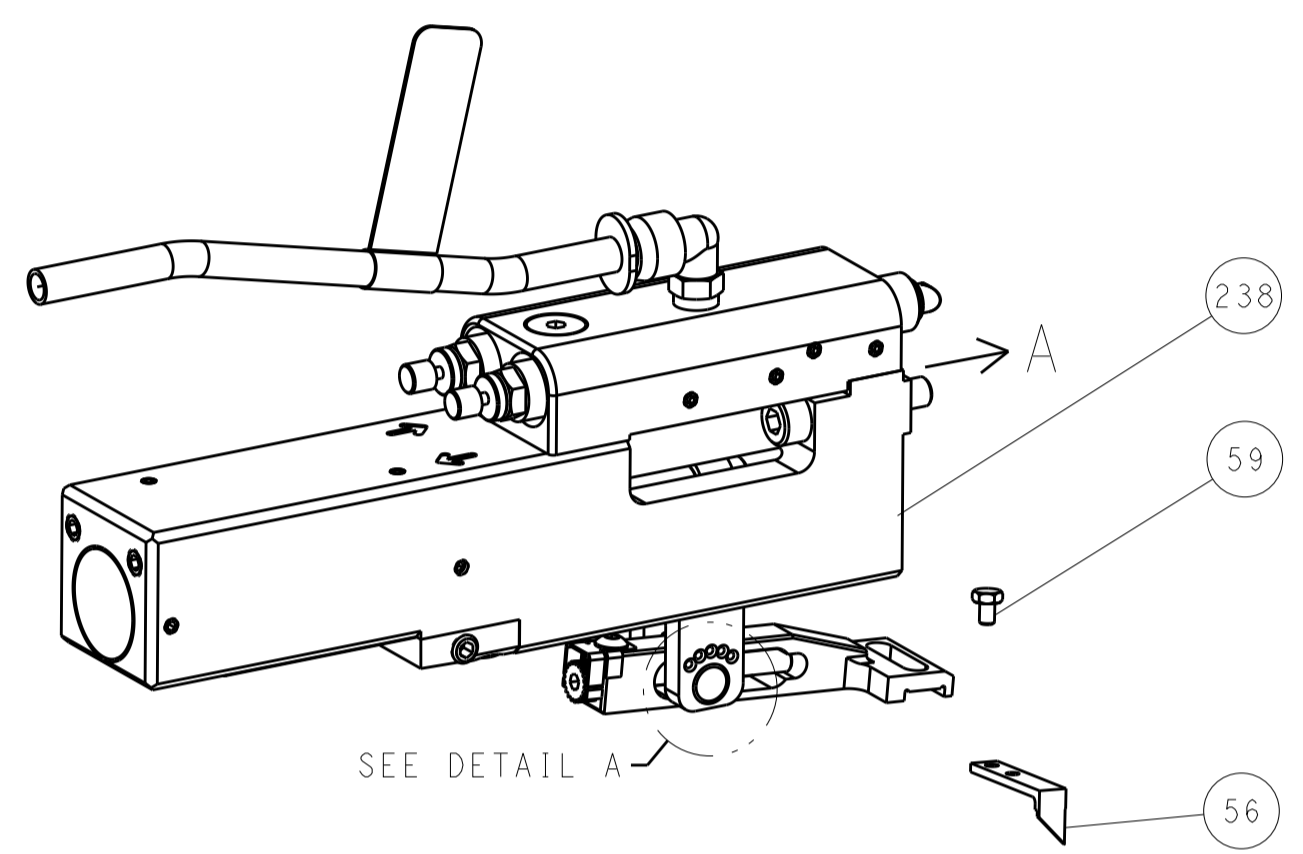
Customer Accessible Production Drawing

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

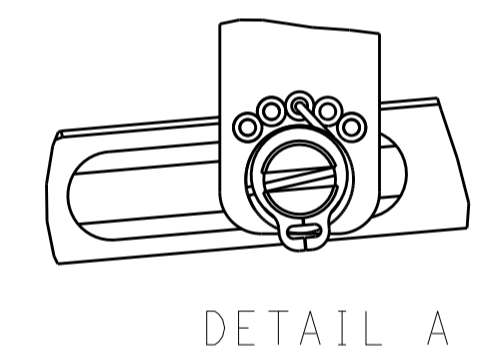
FEED TYPE MECHANICAL



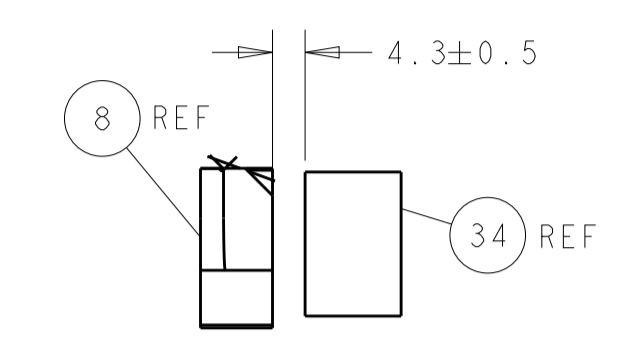
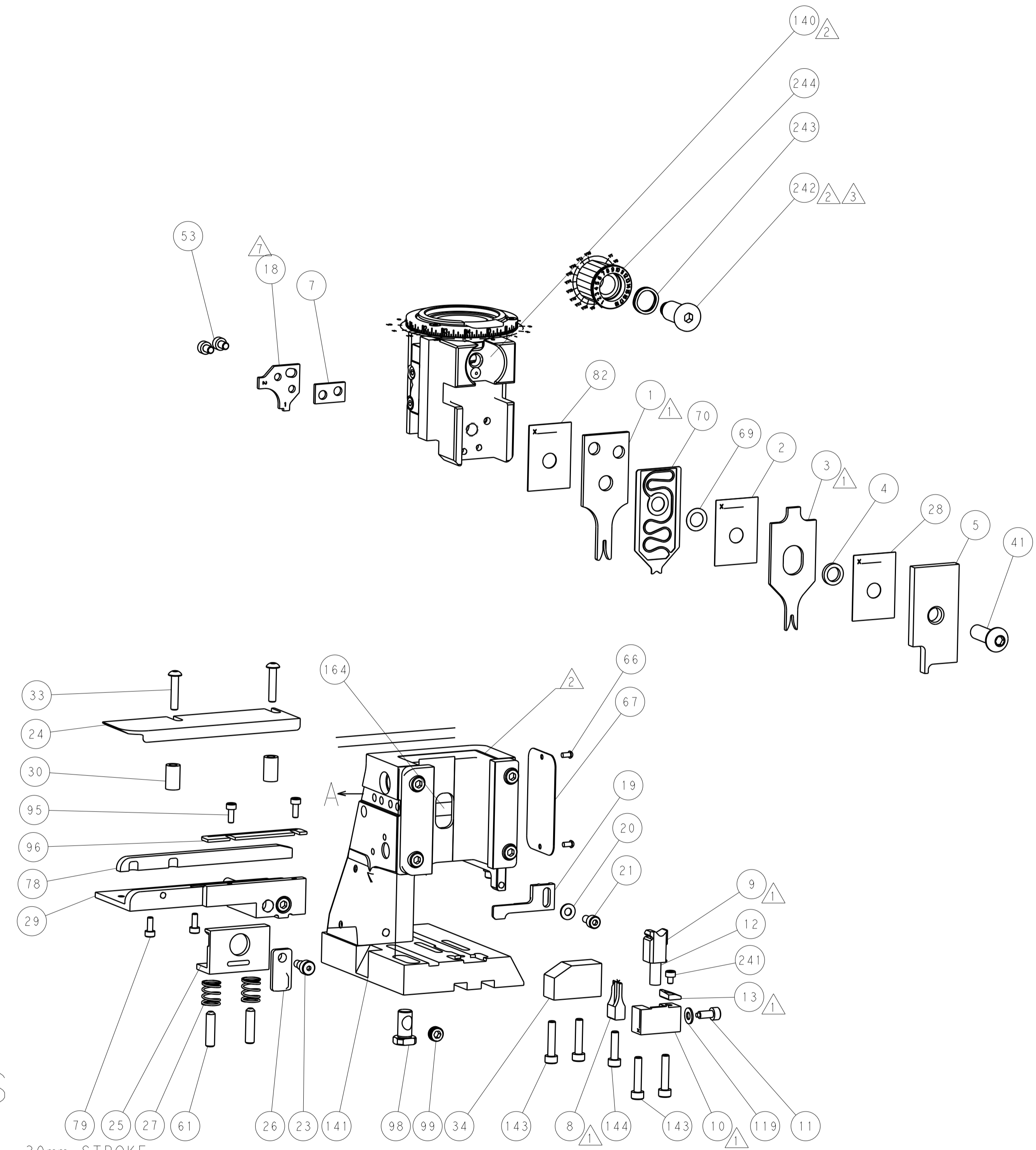
PNEUMATIC



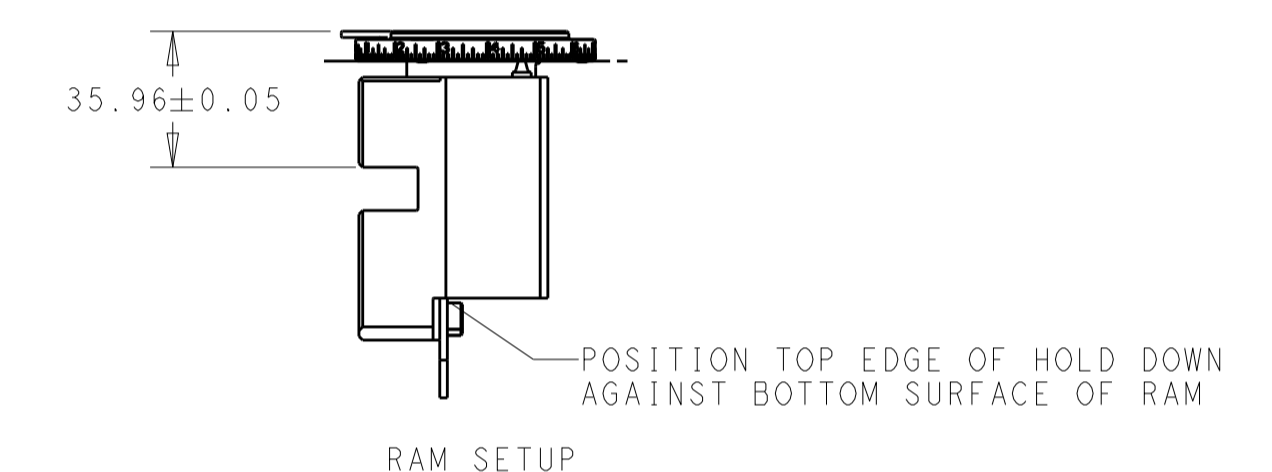
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

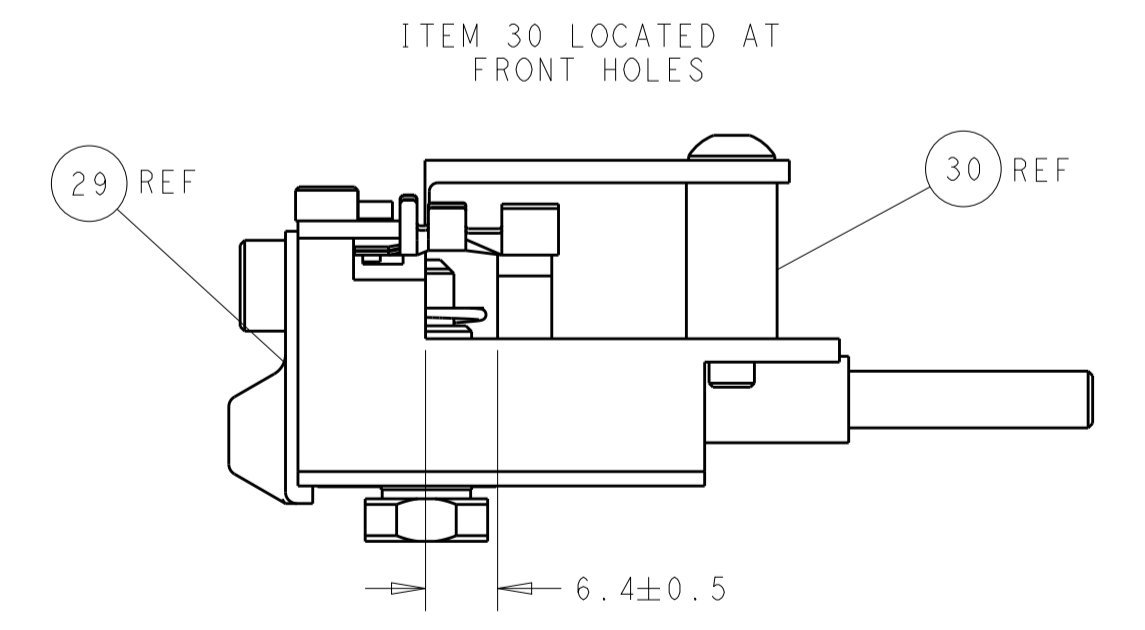
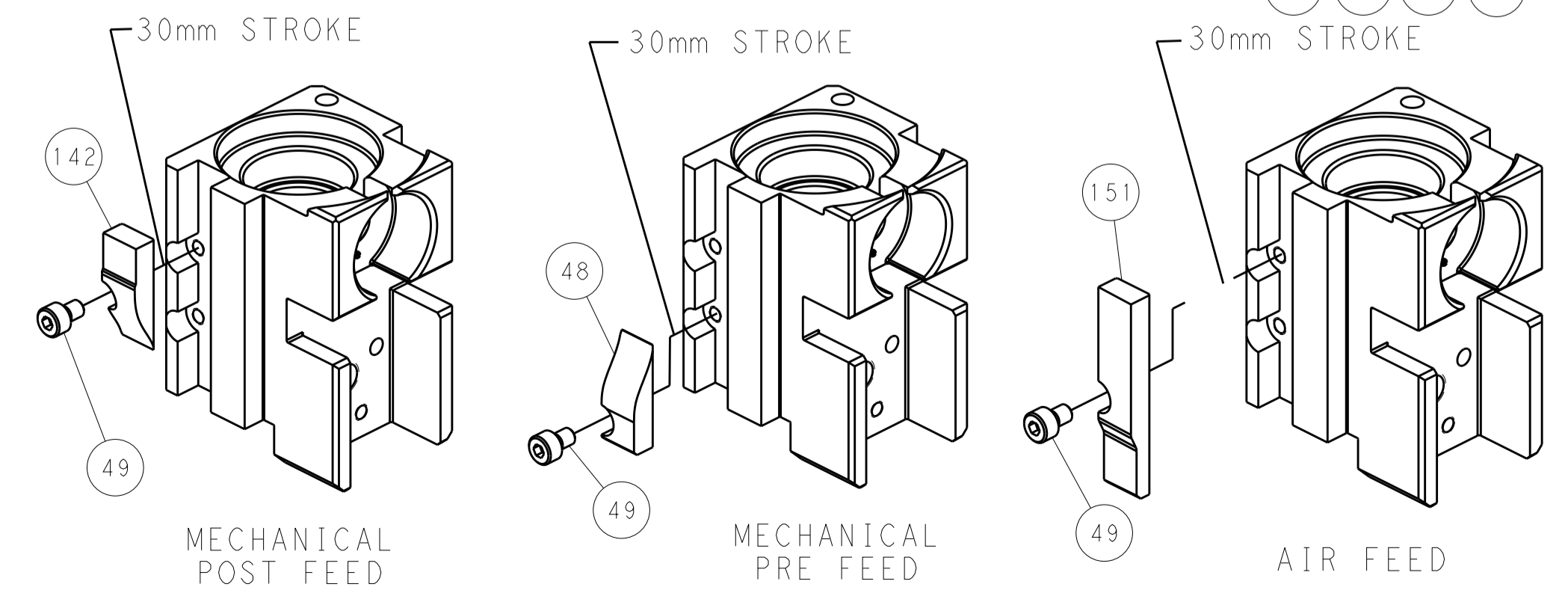


TERMINAL SUPPORT LOCATION



RAM SETUP

CAM POSITIONS



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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:		DWG: BOB HIGMAN 13JAN2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
	ANGLES	FINISH		CHK: G. BAILEY 13JAN2014		NAME: Ocean Side Feed Applicator	
MATERIAL:				APVD: M. CLIFFORD 13JAN2014		PRODUCT SPEC:	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				WEIGHT:		RESTRICTED TO:	
				A1 00779 ©=2266165		SCALE: 5:1 SHEET 4 OF 4 REV E	
Customer Accessible Production Drawing							