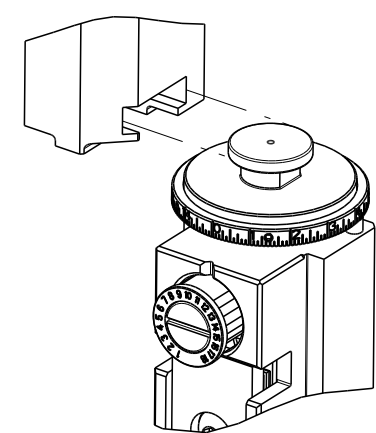


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266253-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266253-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266253-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266253-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266253-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266253-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266253-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



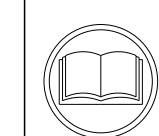
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.19 mm [.165]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI MIC TAB CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.00 mm [.138-.157 IN]		∅	
TERMINAL APPLICATION SPECIFICATION	114-20045	-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
282465-1			281934-2	1.7-2.4
			281934-3	2.5-3.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.98+/-0.05 [.078+/-0.002]	5.0
1.50mm2	1.72+/-0.05 [.068+/-0.002]	8.0



- 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 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6 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)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APPD
		C		ECR-17-003202	05MAR2017	BW	GB
		D		ECR-18-007752	20MAY2018	TB	JDG
		E		ECR-21-118540	25OCT2021	JWC	TE
		F		ECR-21-123657	09DEC2021	TB	TE

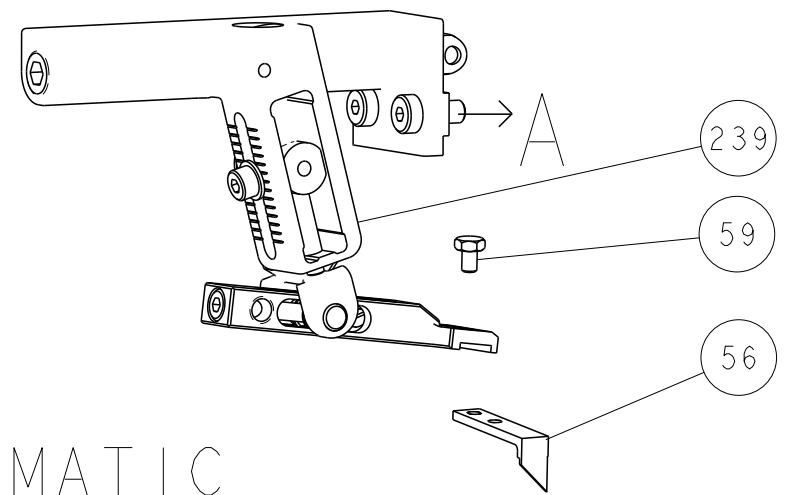
-	1	1	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	1	2119740-1	TAG IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
5	-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	2	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	1	240792-3	DRAG, TERMINAL	25
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	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
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-5	STOP, SHEAR	11
1	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	3-1333205-9	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1-240641-8	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	1	1	1	1	7-1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-2	SPACER, CRIMPER	2
1	1	2	1	1	1	1	1633860-1	CRIMPER, WIRE	1

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-51	-2	-1	

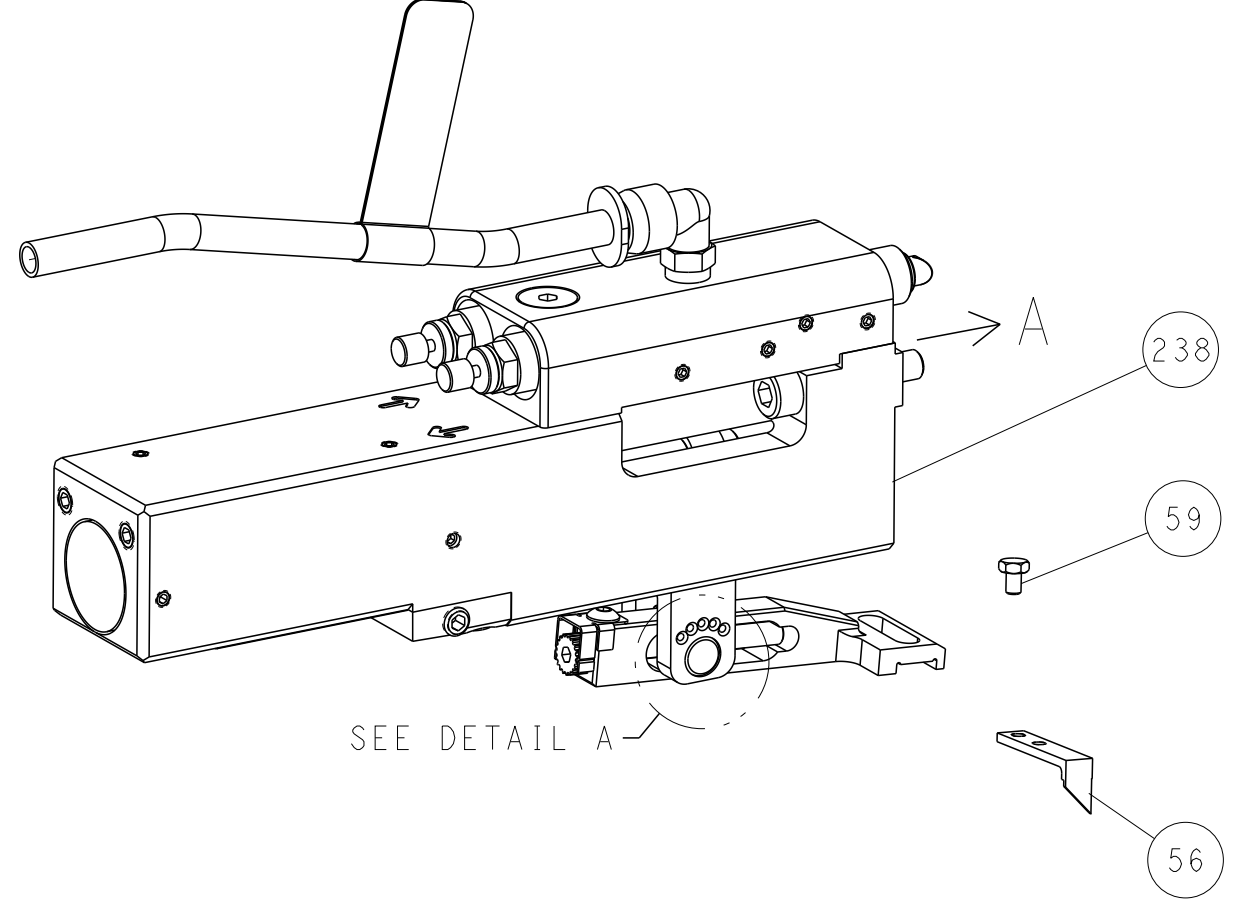
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	OWN: H. HUANG 29APR2014 CHK: L. ZHANG 29APR2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME: Ocean Side Feed Applicator
MATERIAL	WEIGHT	SIZE: A1 00779 C=2266253
Customer Accessible Production Drawing		SCALE: 1:2 SHEET 1 OF 4 REV F

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

# FEED TYPE MECHANICAL



## PNEUMATIC

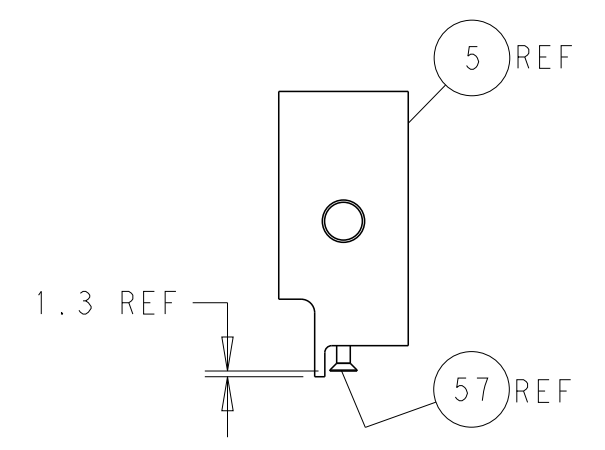
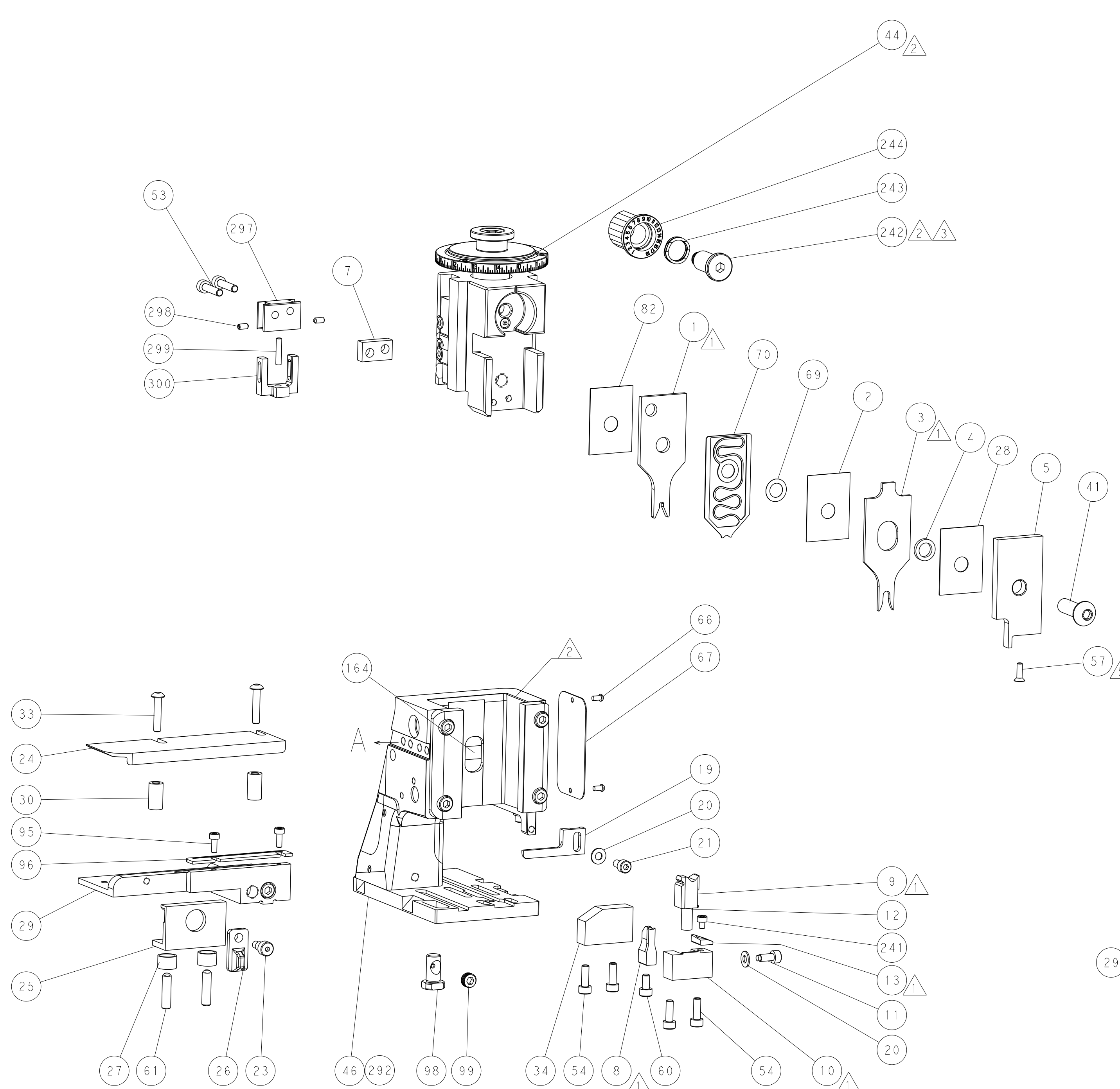
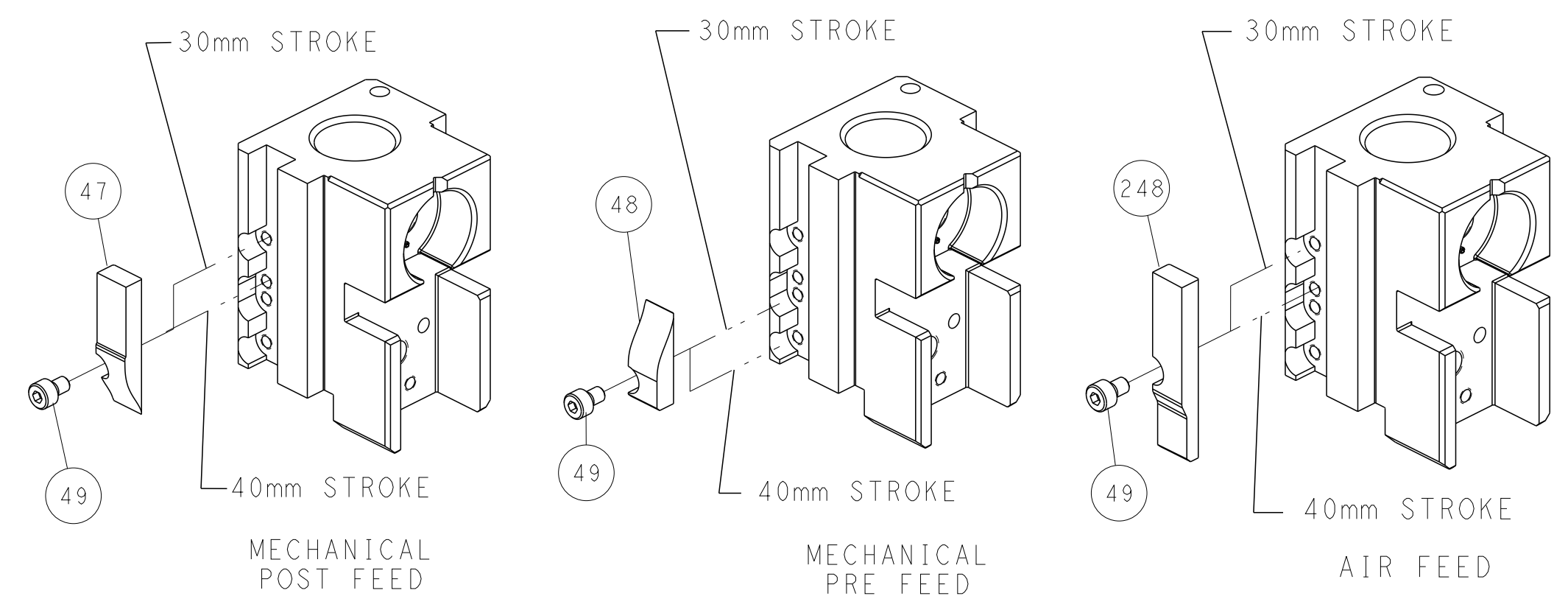


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

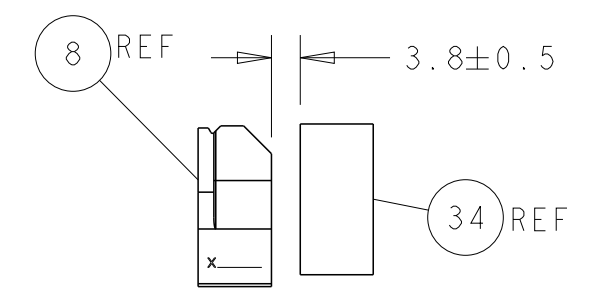


DETAIL A

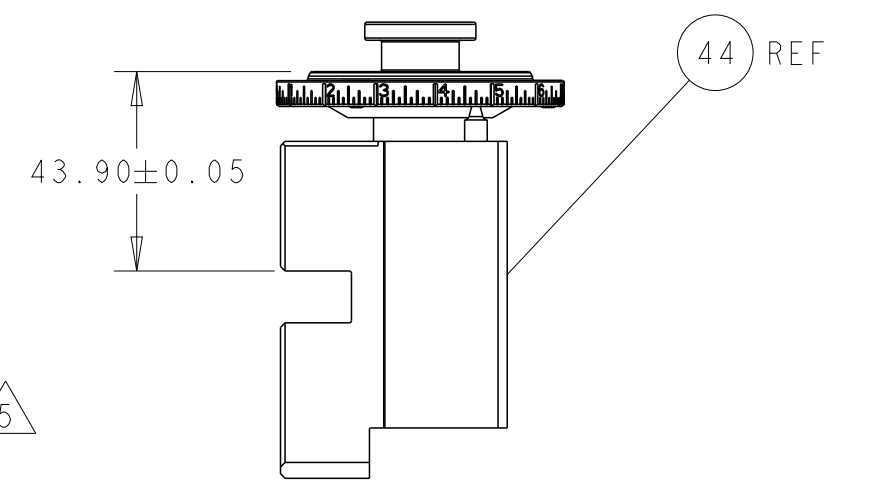
# CAM POSITIONS



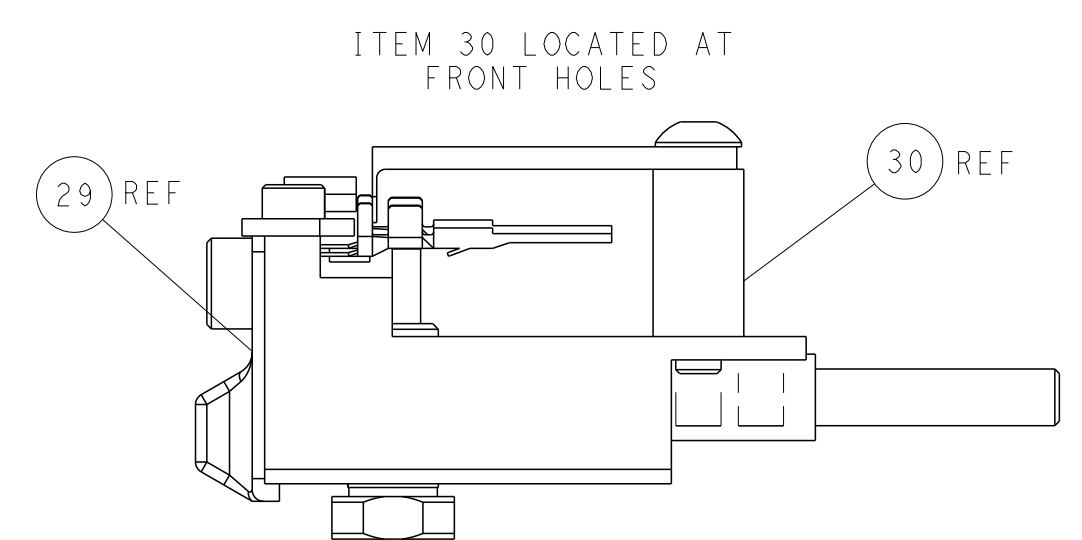
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



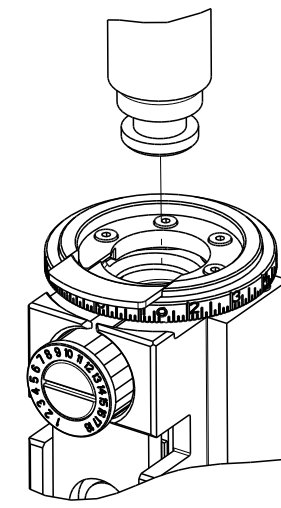
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN R. HUANG 29APR2014 CHK L. ZHANG 29APR2014 APVD J. GUO 29APR2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266253 SCALE 1:2 SHEET 2 OF 4 REV F	
MATERIAL:				TE Connectivity Harrisburg, PA 17105-3608			

8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2266253-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2266253-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2266253-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.19 mm [.165]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI MIC TAB CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.00 mm [.138-.157 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	114-20045	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
282465-1			281934-2
			281934-3
			CABLE DIAMETER
			1.7-2.4
			2.5-3.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.98+/-0.05 [.078+/-0.002]	5.0
1.50mm2	1.72+/-0.05 [.068+/-0.002]	8.0



- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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.

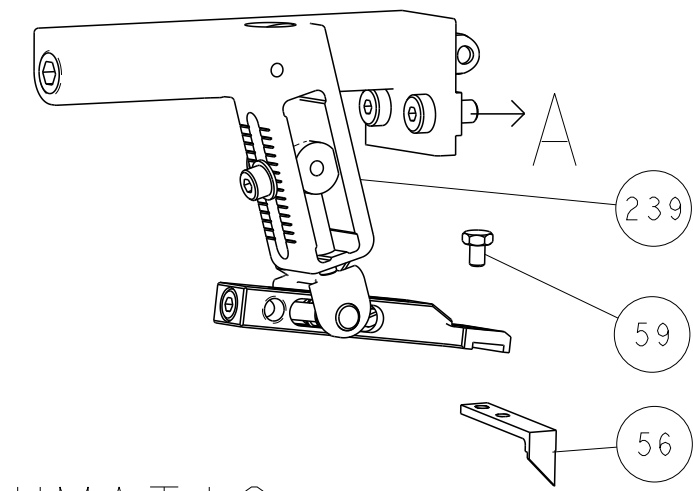
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	1803945-4	TONKER	300
-	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	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	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	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
5	-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	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	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-3	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	3-1333205-9	ANVIL, COMBINATION	8
-	1	1	1-240641-8	SPACER	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	7-1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-2	SPACER, CRIMPER	2
1	1	1	1633860-1	CRIMPER, WIRE	1

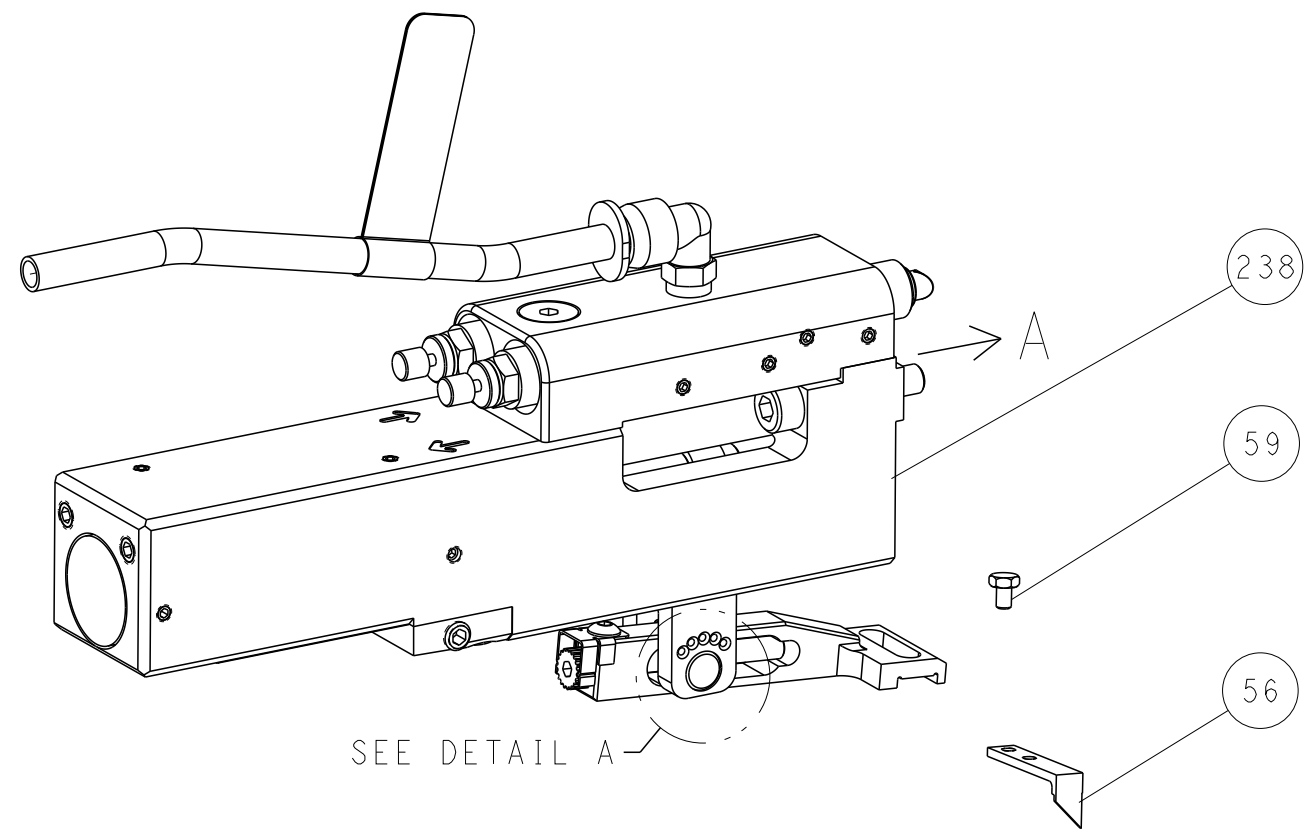
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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DIMENSIONS: mm		CHK: L. ZHANG 29APR2014	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: J. GUO 29APR2014	NAME: Ocean Side Feed Applicator
0 PLC ±		PRODUCT SPEC	SIZE: A1
1 PLC ±		APPLICATION SPEC	CAGE CODE: 00779
2 PLC ±		WEIGHT	DRAWING NO: 2266253
3 PLC ±		SCALE: 1:2	SHEET 3 OF 4
4 PLC ±		RESTRICTED TO	REV F
ANGLES FINISH		Customer Accessible Production Drawing	

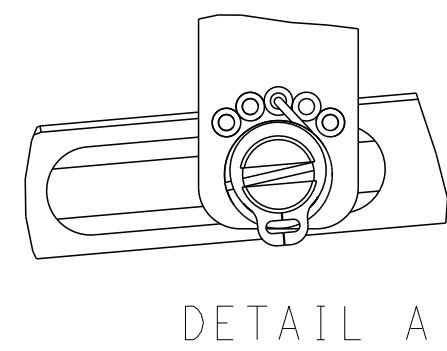
# FEED TYPE MECHANICAL



## PNEUMATIC

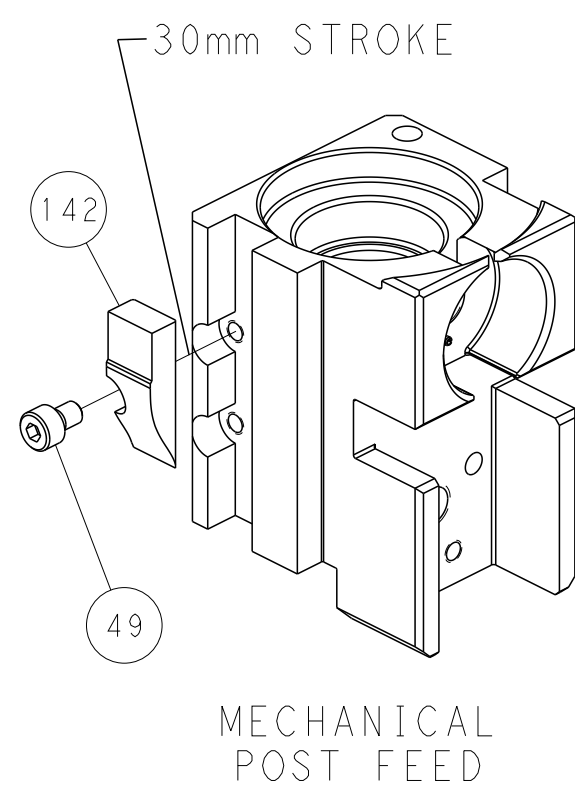


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

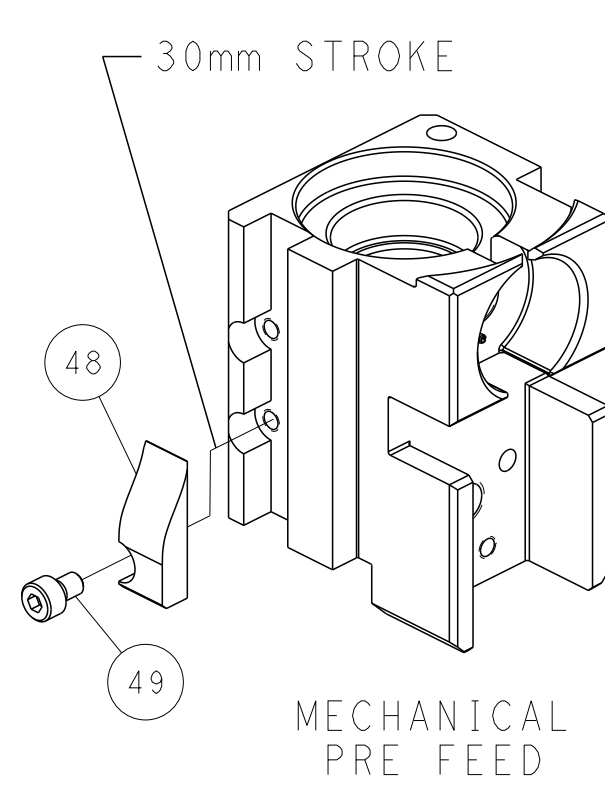


DETAIL A

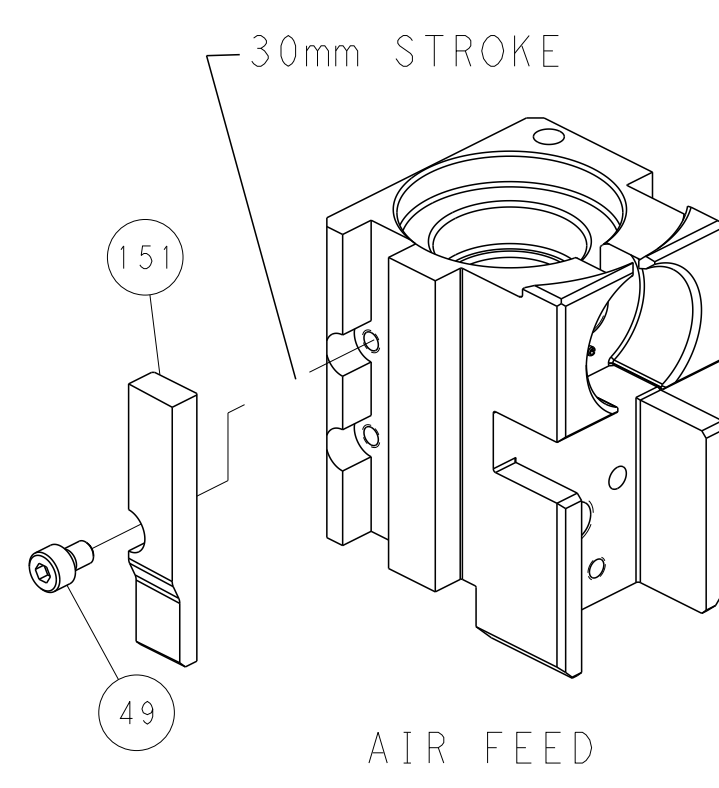
## CAM POSITIONS



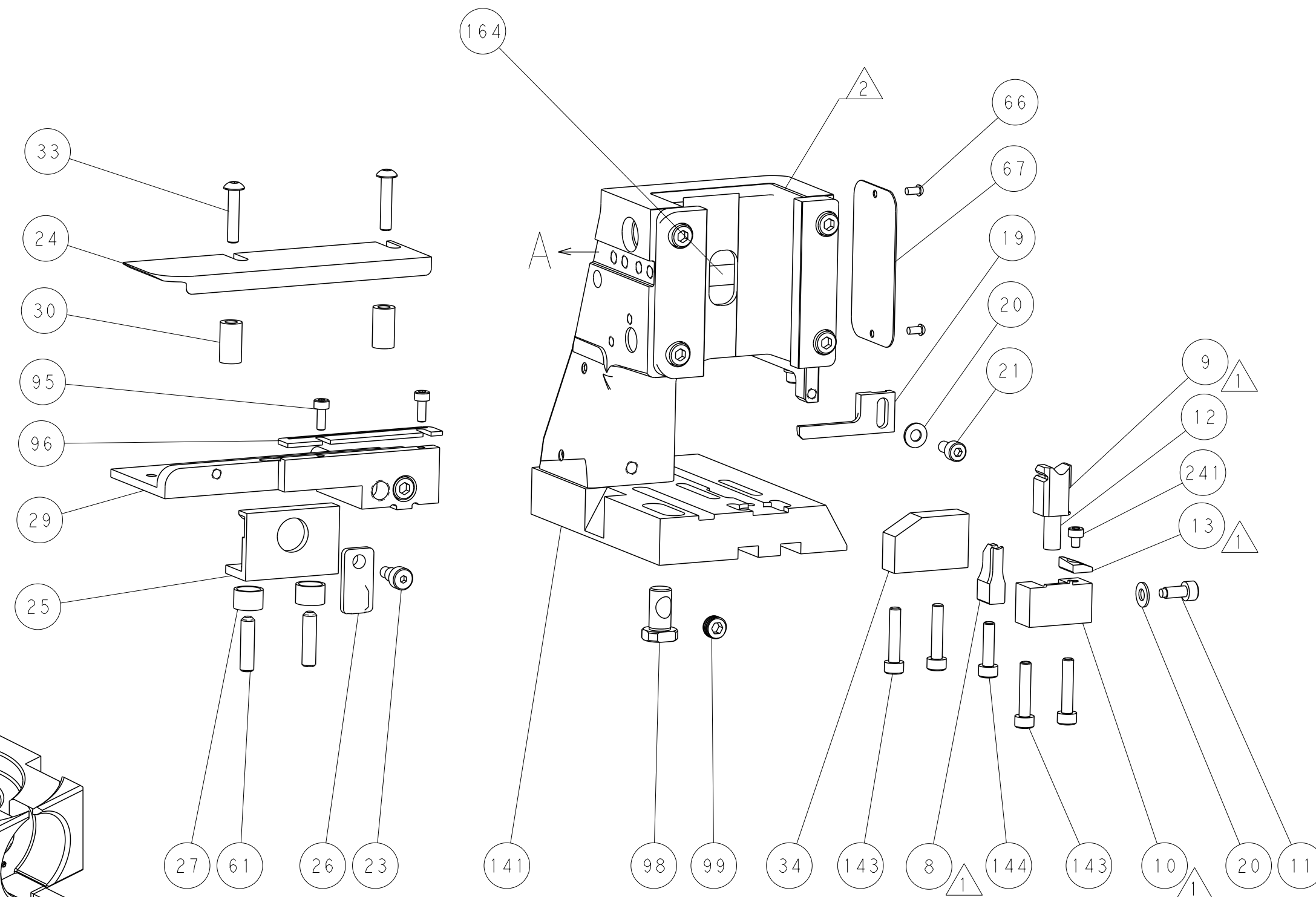
MECHANICAL  
POST FEED



MECHANICAL  
PRE FEED

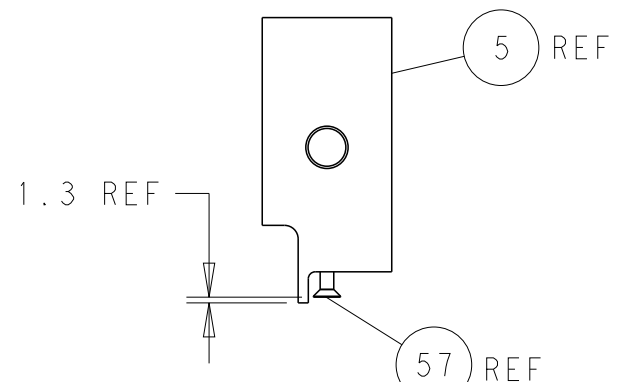


AIR FEED

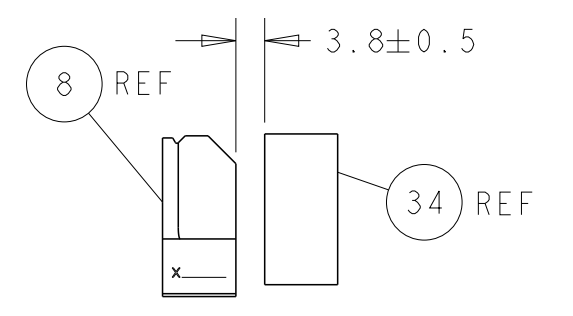


**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

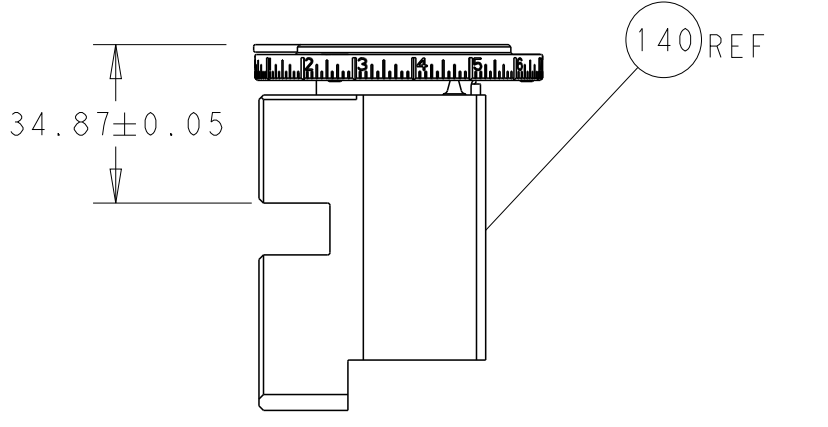
LOC	DIST	REVISIONS					
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-



SHEAR DEPRESSOR DETAIL

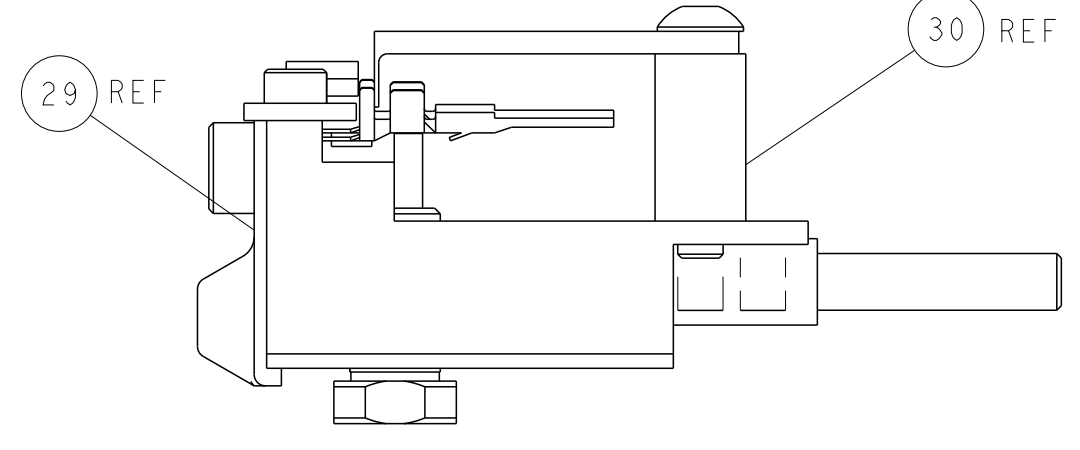


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT  
FRONT HOLES



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN H. HUANG 29APR2014 CHK L. ZHANG 29APR2014 APVD J. GUO 29APR2014	NAME Ocean Side Feed Applicator
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	SIZE A1 CAGE CODE 00779 DRAWING NO C=2266253	RESTRICTED TO F
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 4 OF 4 REV: F

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION