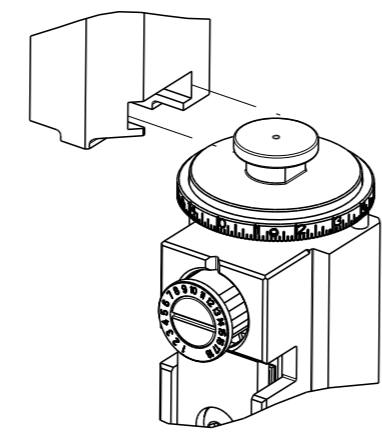


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266308-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266308-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266308-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266308-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266308-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.57 mm [.062]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE TERMINAL	
TERMINAL NAME: CONTACT, MOD IV CRIMP SNAP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.78 mm [.141-.188 IN]		∅ 1.75 mm [.069 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-25003		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
85969-6	141760-1	141600-1	87309-8
85969-2	1-141097-1	141600-5	87309-9
85969-7	166309-1	171275-1	1-87309-2
85969-8	166309-2	171275-2	87523-2
85969-9	166309-3	171275-4	87523-4
102680-1	166309-4	171275-5	87523-5
102680-2	166309-5	1-87195-7	1-87523-5
86492-2	167301-4	1-87195-9	1-87523-8
86492-4	1-167301-6	2-87195-0	2-87523-3
86492-6	2-167301-2	2-87195-3	6-87523-8
86492-9	2-167301-4	2-87195-4	167300-6
1-86492-0	167300-8	1-167300-6	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.97+/-0.11 [.038+/-0.004]	3.8
22 AWG	0.85+/-0.06 [.034+/-0.002]	5.2
24 AWG	0.77+/-0.095 [.030+/-0.004]	6.2
26 AWG	0.72+/-0.095 [.028+/-0.004]	6.9

- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 CRIMP DATA QUOTED IS SPECIFIC TO GERMAN MARKET.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

**\*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)

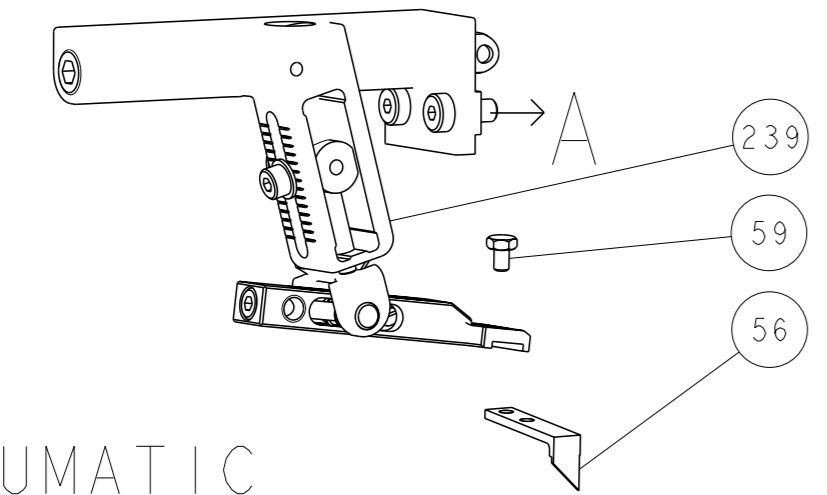
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		D	19MAR2019	FL	CT
		E	31DEC2020	FZ	TE
		E1	01MAR2022	FZ	TE
		F	25OCT2022	FZ	JAH

-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	286	
-	1	1	1	1	2280441-1	INSERT, SHEAR	282	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	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	
-	2	2	2	2	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	4-240641-1	SPACER	81	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	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	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	
-	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	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	3	3	3	3	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	690518-1	HOLD DOWN, TERMINAL	18	
-	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1	1	1	1-690691-3	PLATE, REAR SHEAR	15	
-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14	
-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	2	2	2	2	3-22280-3	SPRING, COMPRESSION	12	
-	2	2	2	2	1-356885-4	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	7-1333225-4	ANVIL, COMBINATION	8
-	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1633966-6	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
-	1	2	2	1	1	7-568176-0	CRIMPER, WIRE	1

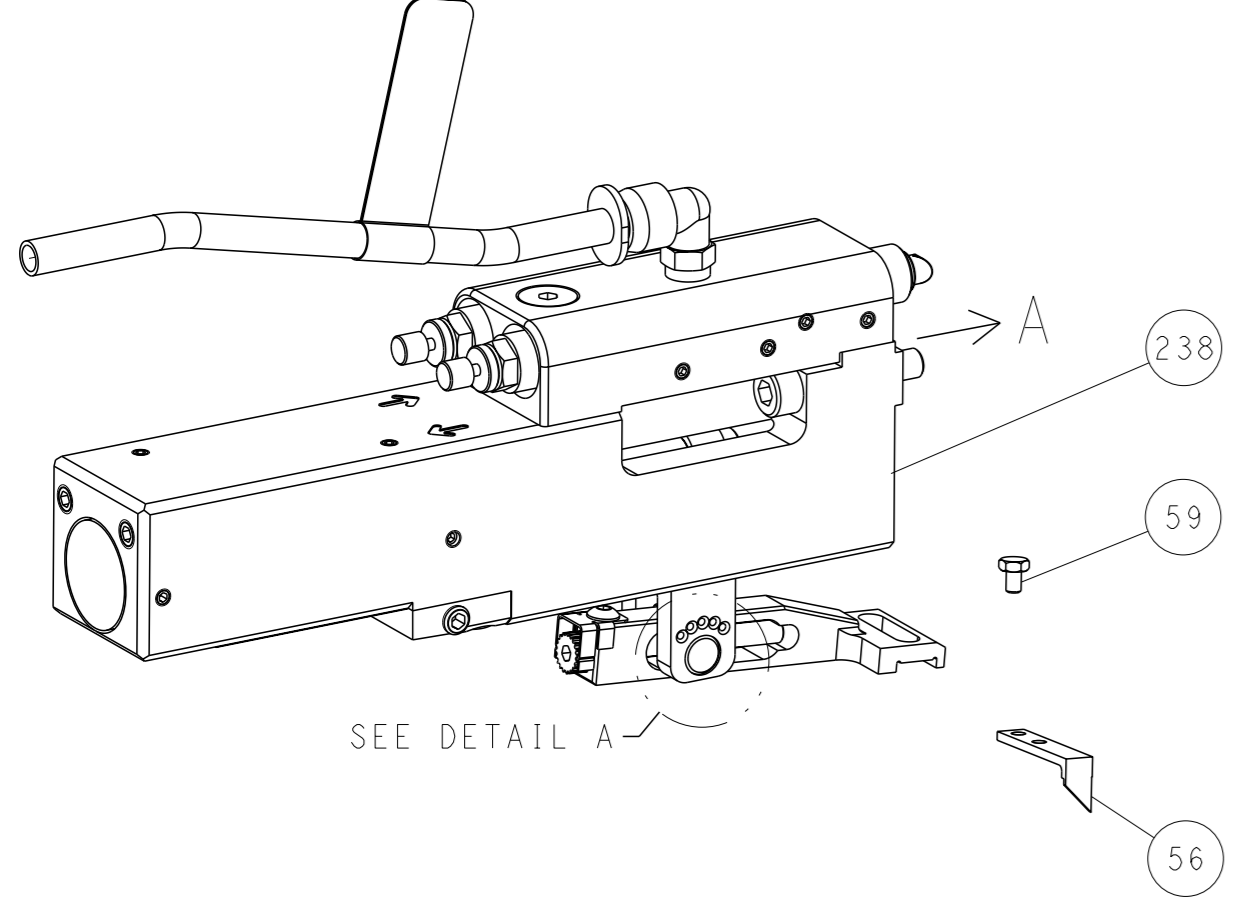
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE
mm	0 PLC ±	1 PLC ±	2 PLC ±	STAKEM	G. BAILEY	21MAY2014
	3 PLC ±	4 PLC ±	FINISH	APVD	T. ELBIN	22MAY2014
MATERIAL				NAME	Ocean Side Feed Applicator	
				SIZE	CAGE CODE	DRAWING NO
				A1	00779	2266308
				RESTRICTED TO		
				Customer Accessible Production Drawing	SCALE	1:2
				SHEET	1	OF 4
				REV		

REV ISIONS		DATE	OWN	APVD
P	LYR			
- SEE SHEET 1				

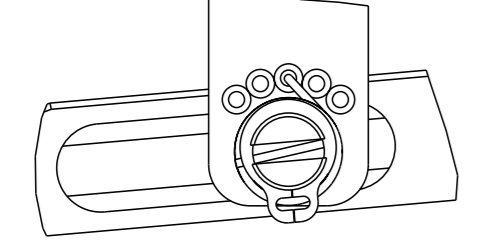
# FEED TYPE MECHANICAL



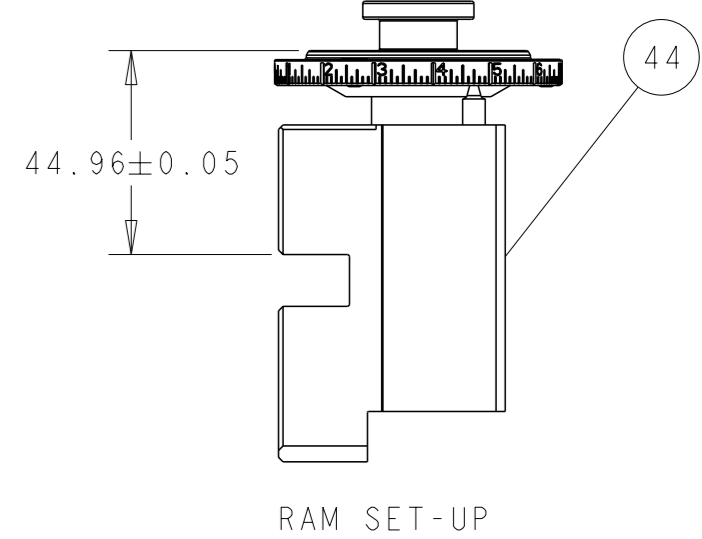
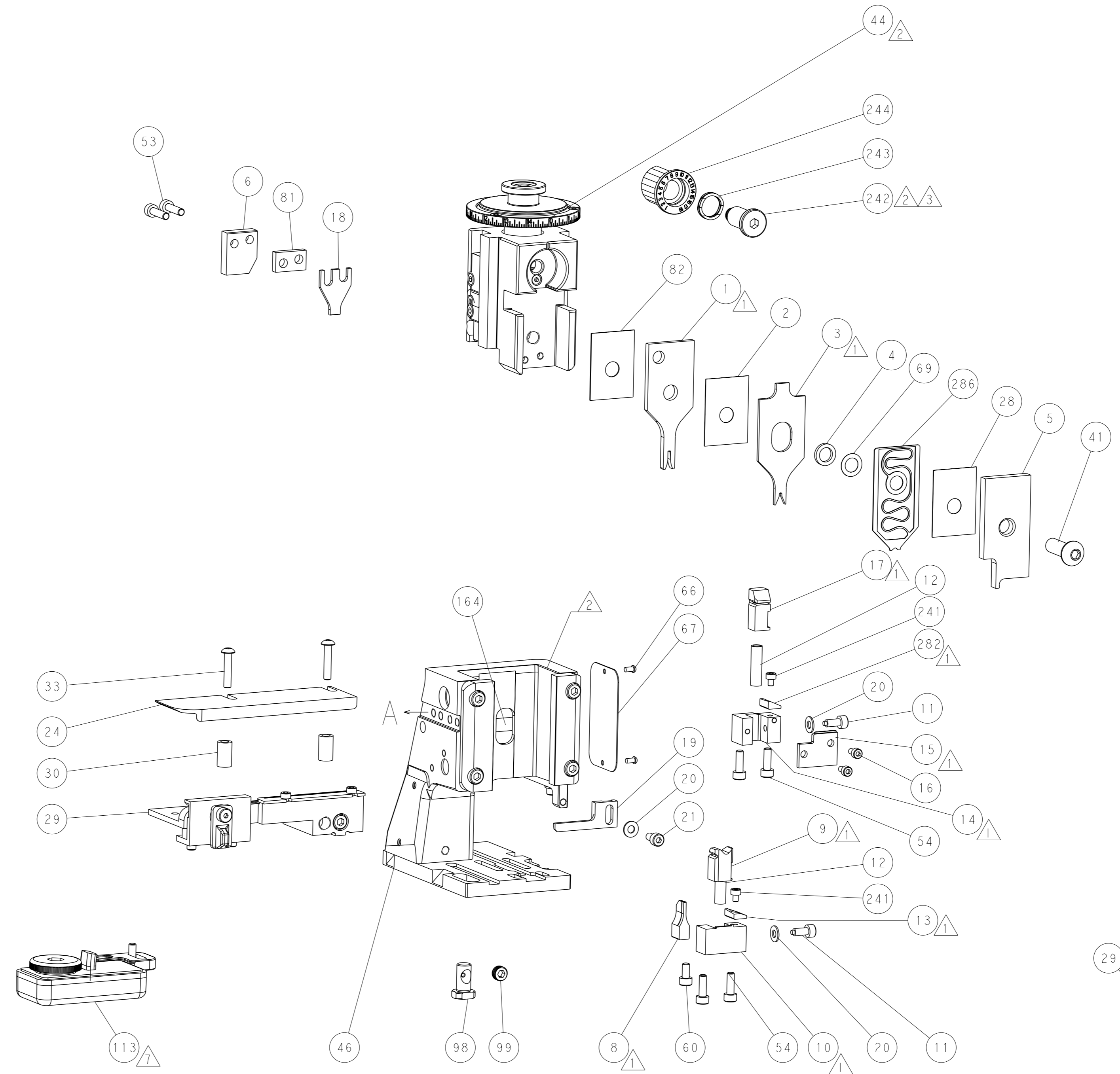
# PNEUMATIC



# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

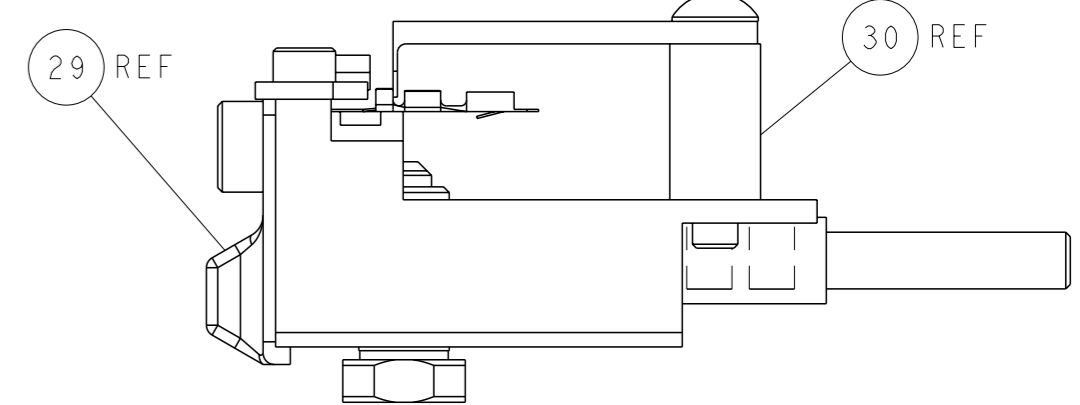


DETAIL A



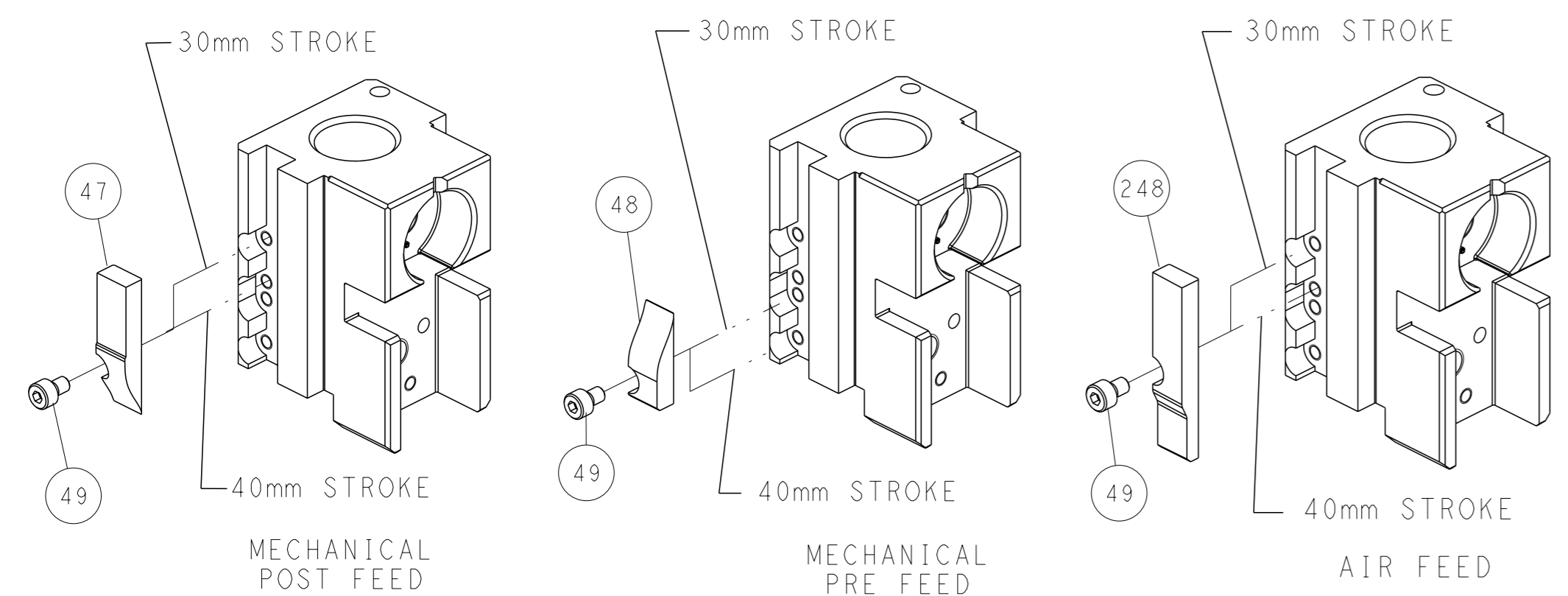
RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

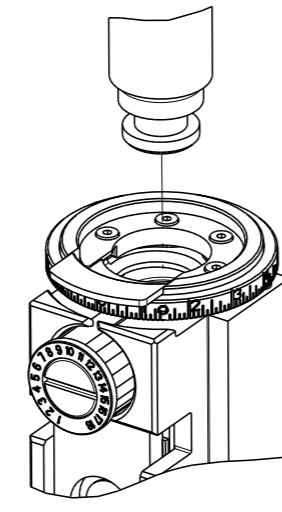


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	DATE	NAME	TE Connectivity
mm	0 PLC	±		R. STAKEM	21MAY2014		Harrisburg, PA 17105-3608
	1 PLC	±		G. BAILEY	22MAY2014		
	2 PLC	±					
	3 PLC	±					
	4 PLC	±					
	ANGLES	±	*				
MATERIAL							
Customer Accessible Production Drawing				SCALE	1:2	SHEET	2 of 4
				REV	F		

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266308-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266308-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266308-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE TERMINAL
TERMINAL NAME: CONTACT, MOD IV CRIMP SNAP-IN		
WIRE STRIP LENGTH 3.58-4.78 mm [.141-.188 IN]	INSULATION DIAMETER RANGE Ø 1.75 mm [.069 IN] MAX	
TERMINAL APPLICATION SPECIFICATION 114-25003		
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
85969-6	141760-1	141600-1
85969-2	1-141097-1	141600-5
85969-7	166309-1	171275-1
85969-8	166309-2	171275-2
85969-9	166309-3	171275-4
102680-1	166309-4	171275-5
102680-2	166309-5	1-87195-7
86492-2	167301-4	1-87195-9
86492-4	1-167301-6	2-87195-0
86492-6	2-167301-2	2-87195-3
86492-9	2-167301-4	2-87195-4
1-86492-0	167300-8	1-167300-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.97+/-0.11 [.038+/- .004]	3.8
22 AWG	0.85+/-0.06 [.034+/- .002]	5.2
24 AWG	0.77+/-0.095 [.030+/- .004]	6.2
26 AWG	0.72+/-0.095 [.028+/- .004]	6.9

- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 CRIMP DATA QUOTED IS SPECIFIC TO GERMAN MARKET.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

**\*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)

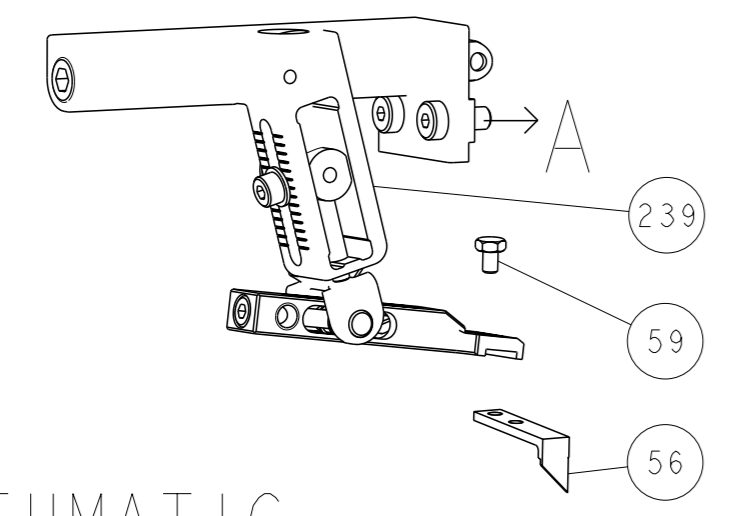
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	ITEM NO		
-	1	1	2119791-9	DEPRESSOR, WIRE	286
-	1	1	2280441-1	INSERT, SHEAR	282
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	4-240641-1	SPACER	81
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	3	3	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	690518-1	HOLD DOWN, TERMINAL	18
-	1	1	690463-1	FLOATING SHEAR, REAR	17
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1-690691-3	PLATE, REAR SHEAR	15
-	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	3-22280-3	SPRING, COMPRESSION	12
-	2	2	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	7-1333225-4	ANVIL, COMBINATION	8
-	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1633966-6	CRIMPER, INSULATION O	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	7-568176-0	CRIMPER, WIRE	1

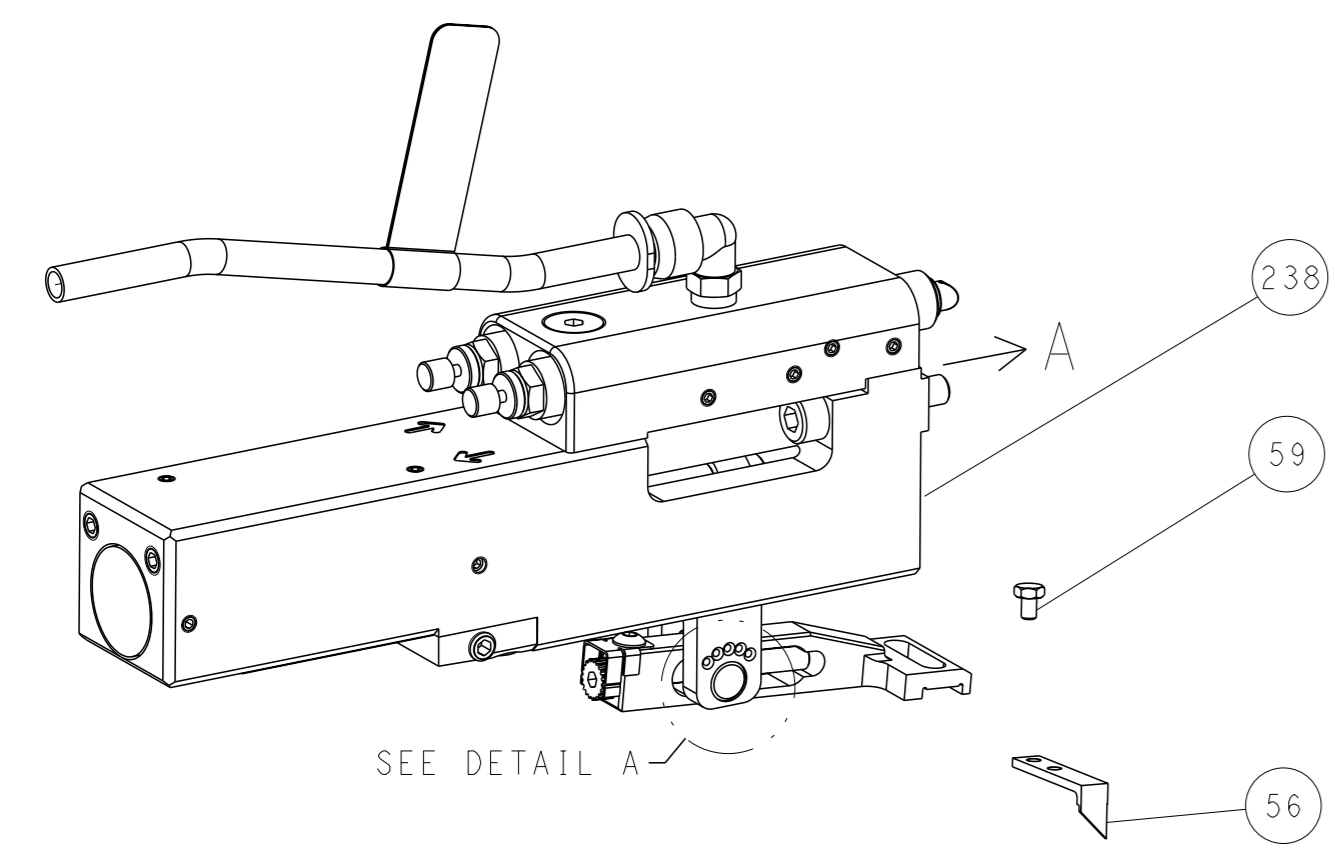
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: STAKEM 21MAY2014	NAME: Ocean Side Feed Applicator
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
ANGLES	FINISH				APVD: ELBIN 22MAY2014
MATERIAL:	WEIGHT:	SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2266308	RESTRICTED TO:
Customer Accessible Production Drawing			SCALE: 1:2	SHEET: 3 of 4	REV: F

REVISONS		DATE	OWN	APVD
P	LYH			
SEE SHEET 1				

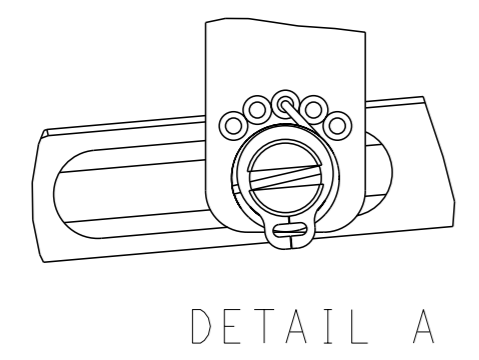
# FEED TYPE MECHANICAL



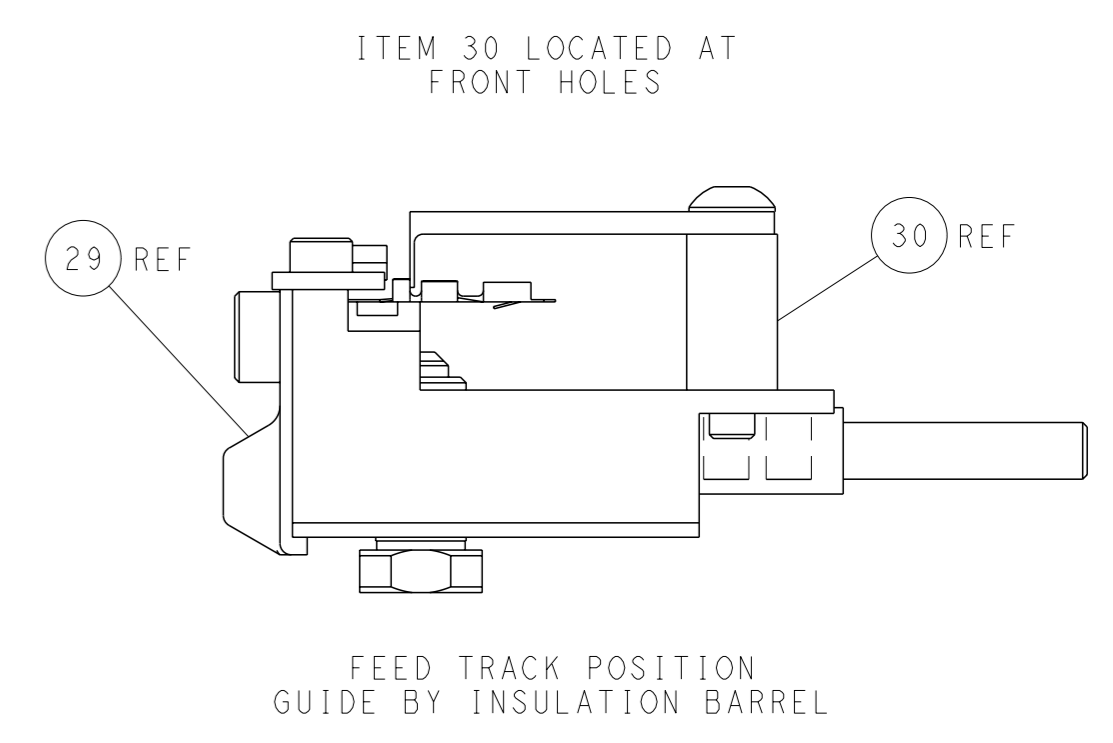
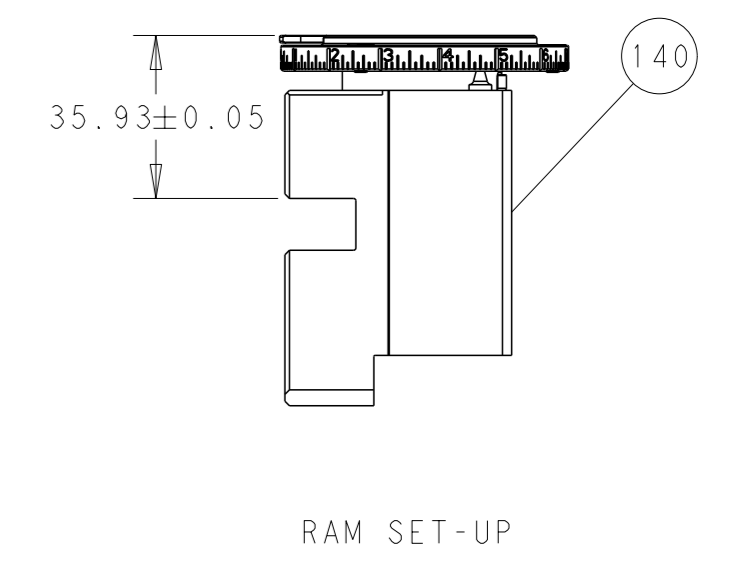
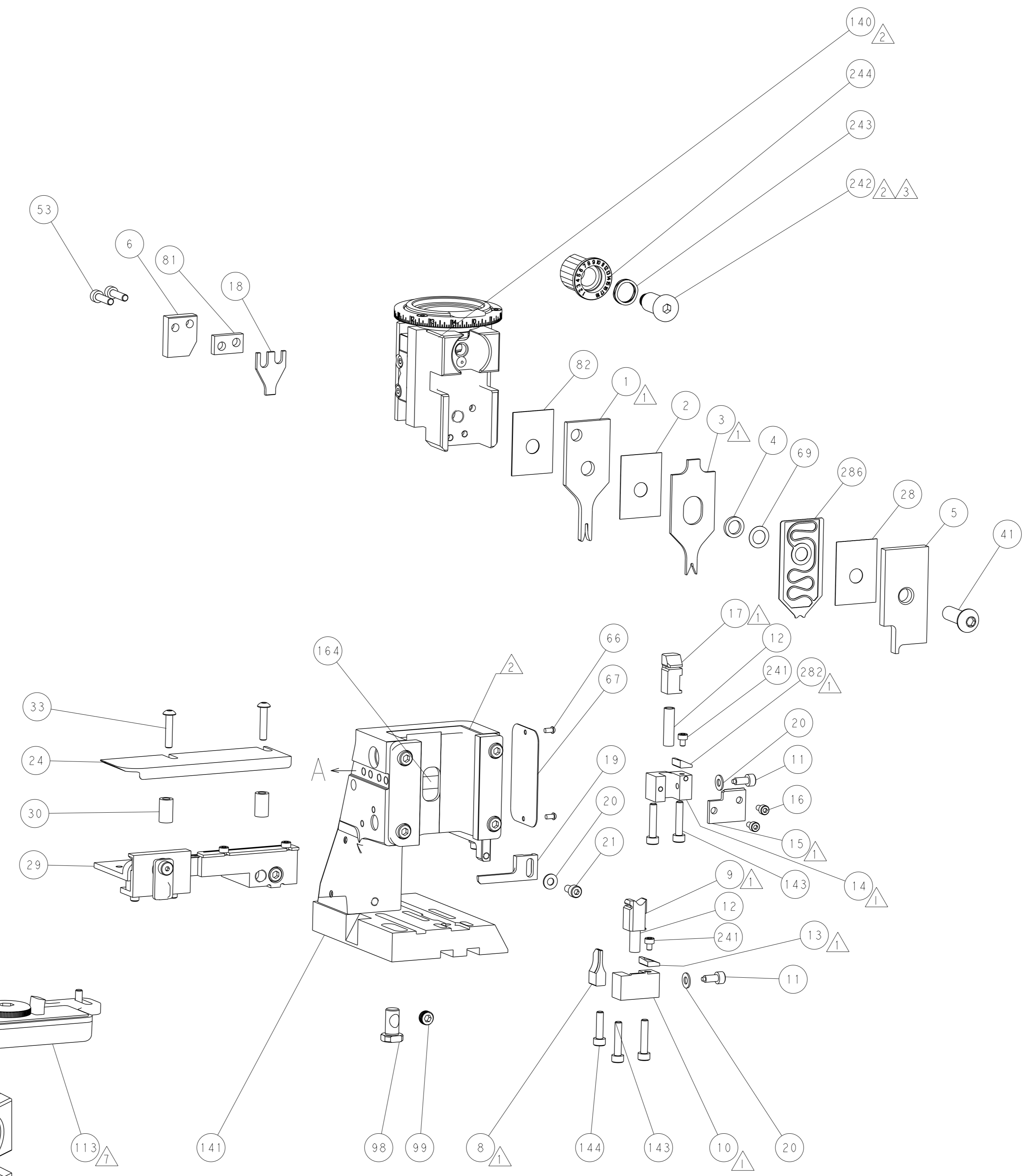
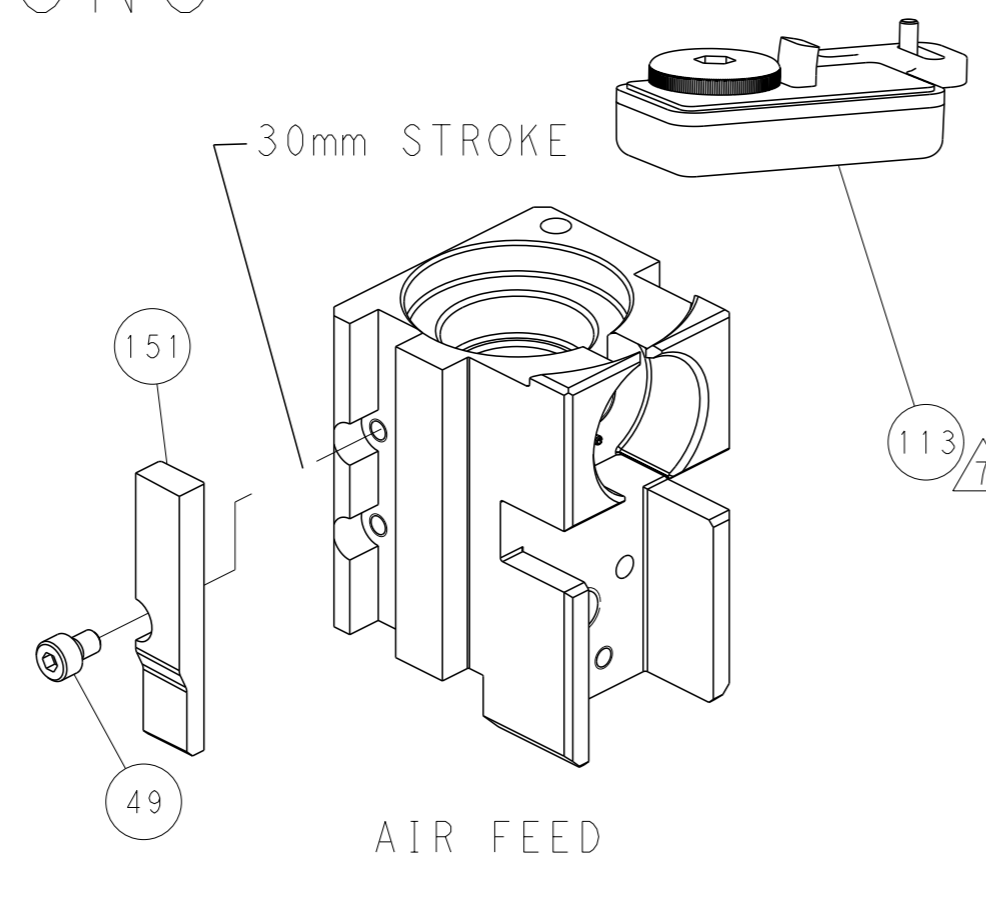
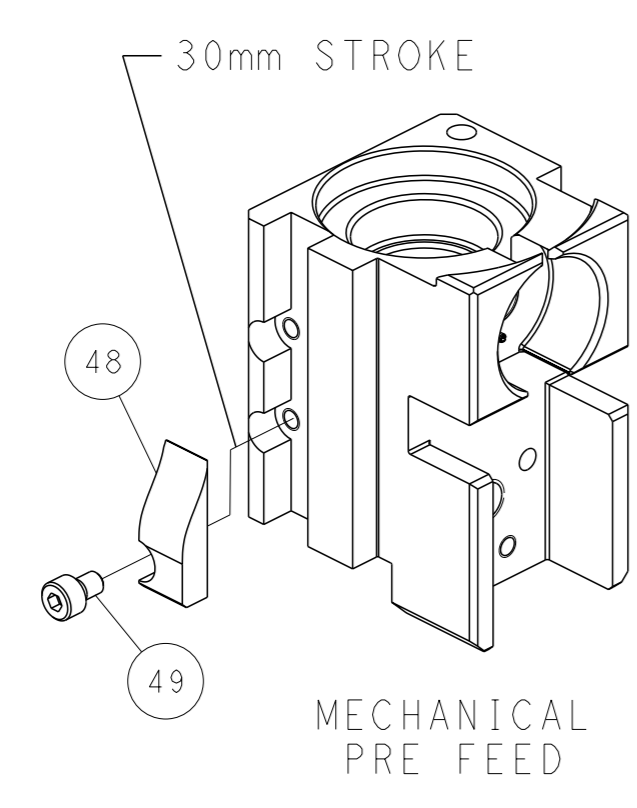
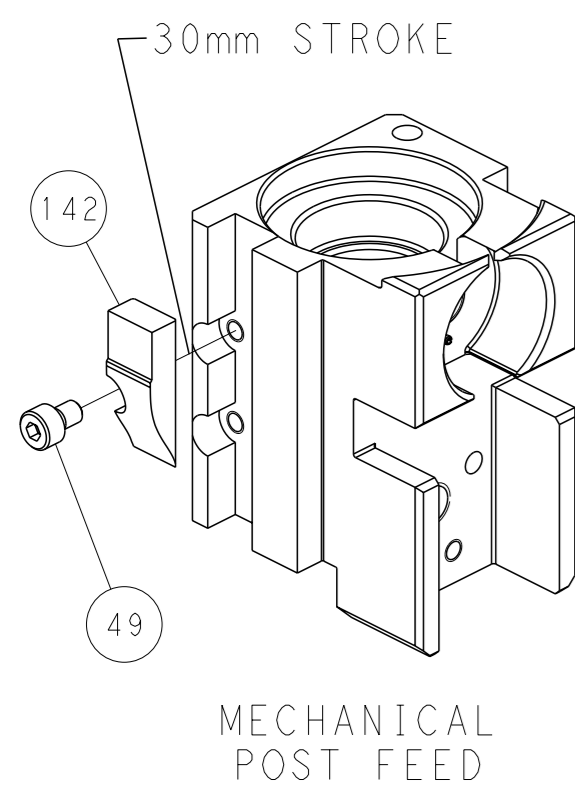
## PNEUMATIC



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



## CAM POSITIONS



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ±		OWN: H. STAKEM 21MAY2014 CHK: G. BAILEY 22MAY2014 APVD: T. ELBIN 22MAY2014 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -		NAME: Ocean Side Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266308 SCALE: 1:2 SHEET: 4 of 4 REV: F	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				RESTRICTED TO: -			