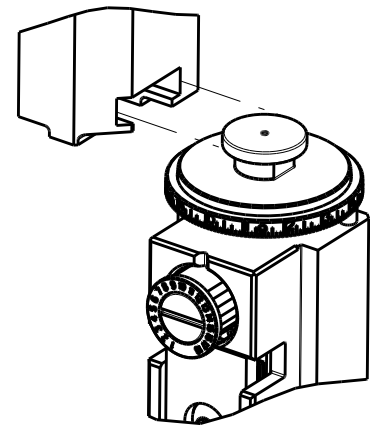


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PART NUMBER	REVISION	DESCRIPTION		FEED TYPE	
2266254-1	B	FINE CRIMP HEIGHT ADJUST		MECHANICAL	
2266254-2	B	FINE CRIMP HEIGHT ADJUST		PNEUMATIC	
7-2266254-1	B	MECHANICAL AND CRIMP TOOLING KIT		MECHANICAL	
7-2266254-2	B	PNEUMATIC AND CRIMP TOOLING KIT		PNEUMATIC	
7-2266254-7	A	CRIMP TOOLING KIT		-	



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.54 mm [.100]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DIA 2.5MM CONTACT-PIN			
WIRE STRIP LENGTH 3.90-4.60 mm [1.54-.181 IN]		INSULATION DIAMETER RANGE Ø1.40-2.10 mm [0.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION (B)114-18040		- -	
TERMINAL APPLICATION SPECIFICATION (A)114-18020		- -	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 929986-1	(A) 929970-1	(A) 929970-8	(A) 929963-8
(B) 929986-4	(A) 929970-7	(A) 929963-1	(A) 1-929963-0

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
1.00mm2		1.45+/- 0.05 [.057+/- .002]		7.6
0.75mm2		1.36+/- 0.05 [.054+/- .002]		8.8
0.50mm2		1.27+/- 0.05 [.050+/- .002]		9.7



 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.

 TERMINAL LUBRICANT IS RECOMMENDED.

6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

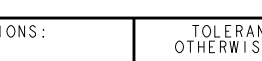
*WARNING

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
(Pacific version shown on sheets 3 of 4 & 4 of 4)

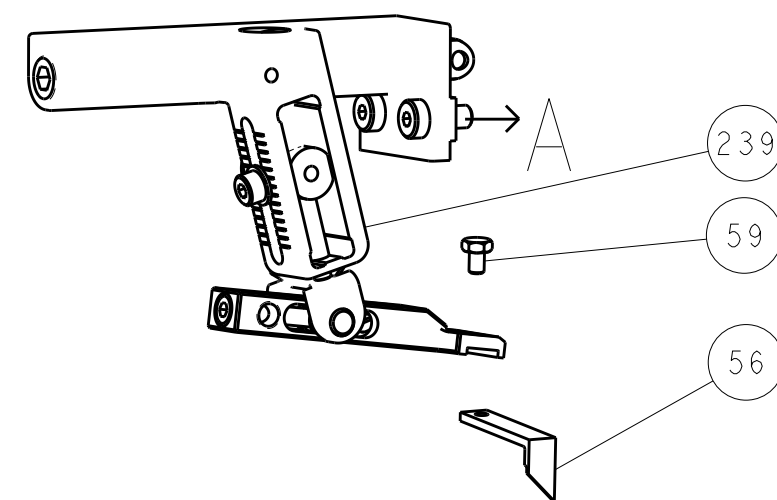
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD	
			A	RELEASED	19MAR2015	MR	TE	
			B	ECR-18-018346	22NOV2018	FZ	KZ	

	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	2063440-1	AIR FEED MODULE	238
	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
5	-	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	1803607-1	DOCUMENTATION PACKAGE	71
	-	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	1338683-8	FEED PAWL	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	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	690753-2	SPACER, TONKER	50
	-	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	1-1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
	-	2	2	2	2	2-2844962-6	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	1320928-6	STRIP GUIDE	24
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	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	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
	1	2	2	1	1	1-1333204-8	ANVIL, COMBINATION	8
	-	1	1	1	1	2-240641-5	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1633965-3	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	2	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

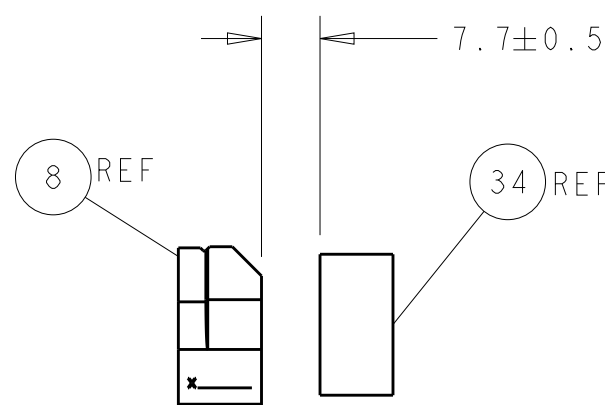
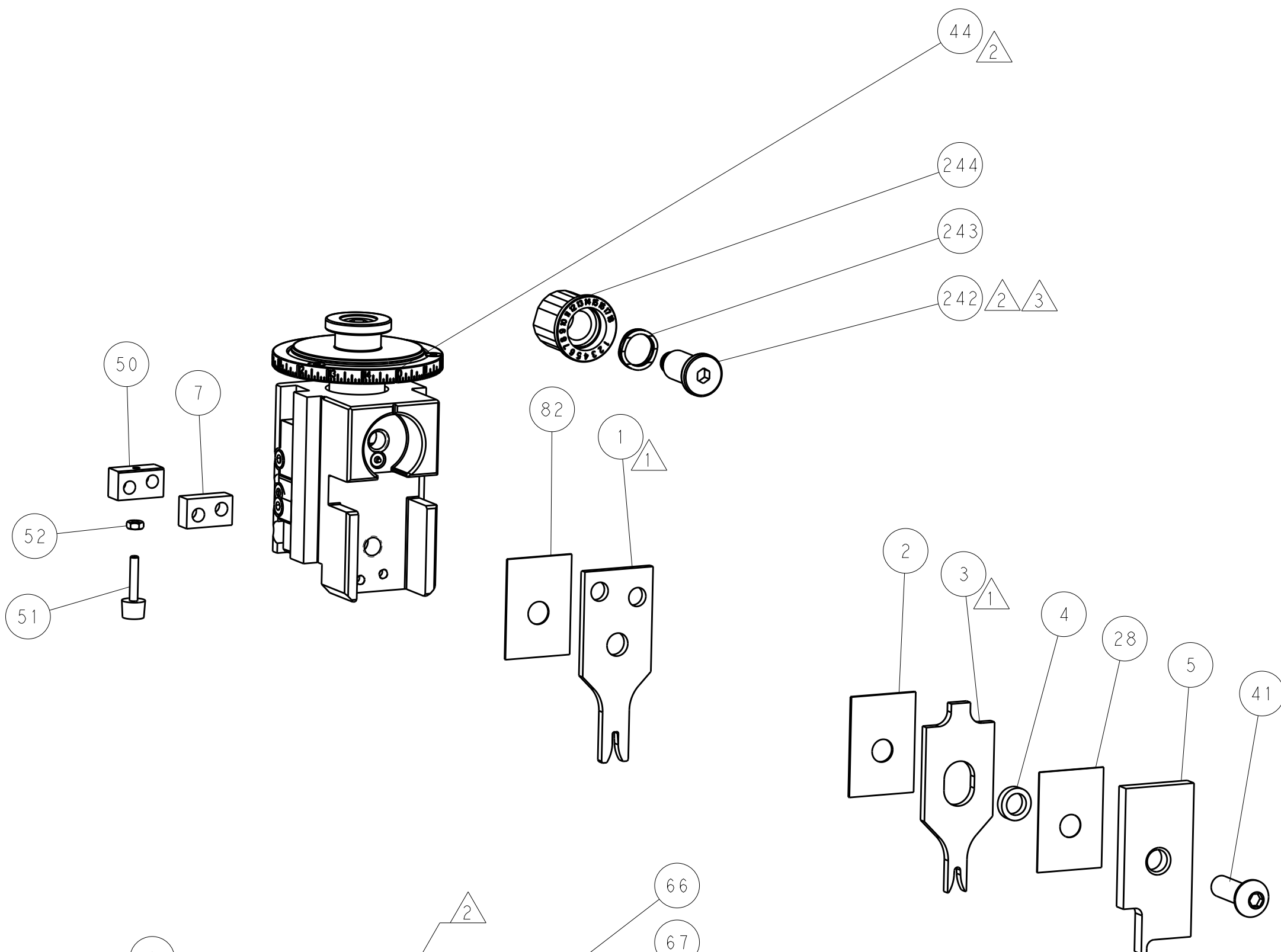
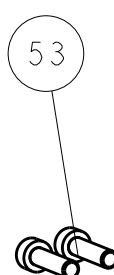
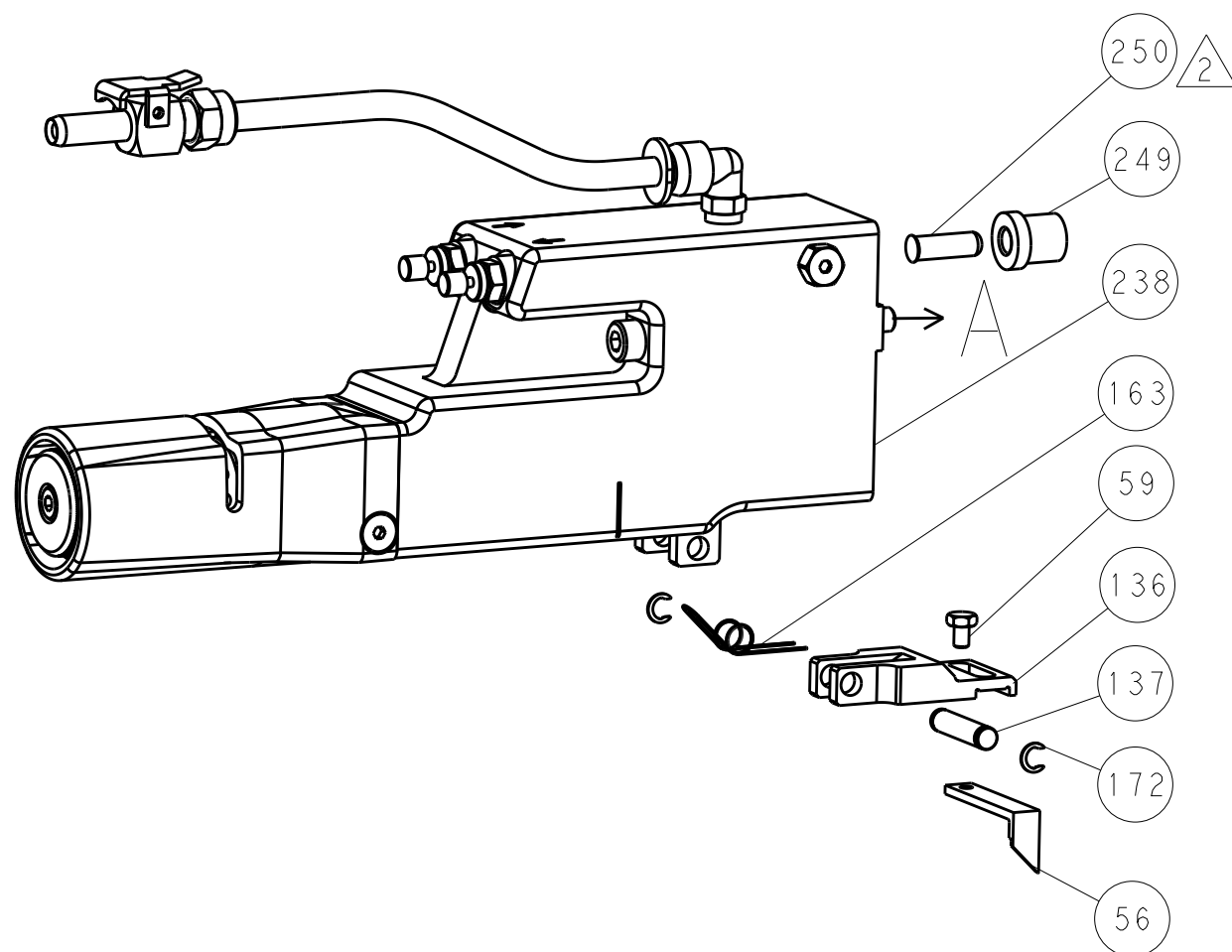
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						CHG ZHANG		SAPR2014			
DIMENSIONS:						TOLERANCES UNLESS OTHERWISE SPECIFIED:					
mm						FRACTIONS					
 Ø PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±°						PRODUCT SPEC		NAME		Ocean Side Feed Applicator	
						-		-			
						APPLICATION SPEC		SIZE CASE CODE DRAWING NO			
						-		A 00779 C=2266254			
						RESTRICTED TO		-			
MATERIAL						FINISH		WEIGHT		SCALE	
-						-		-		1:2 SHEET 1 OF 4 REV B	
Customer Accessible Product Drawing											

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

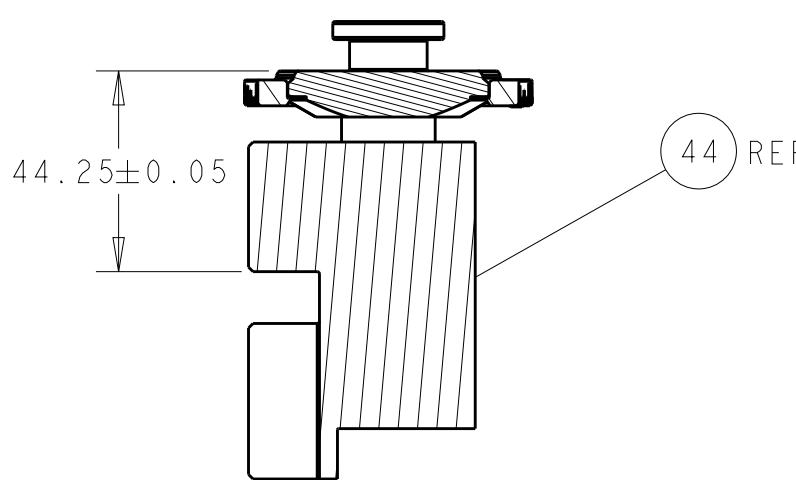
FEED TYPE
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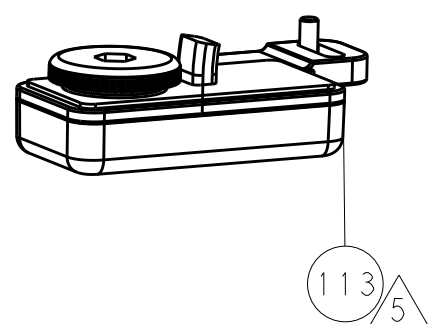
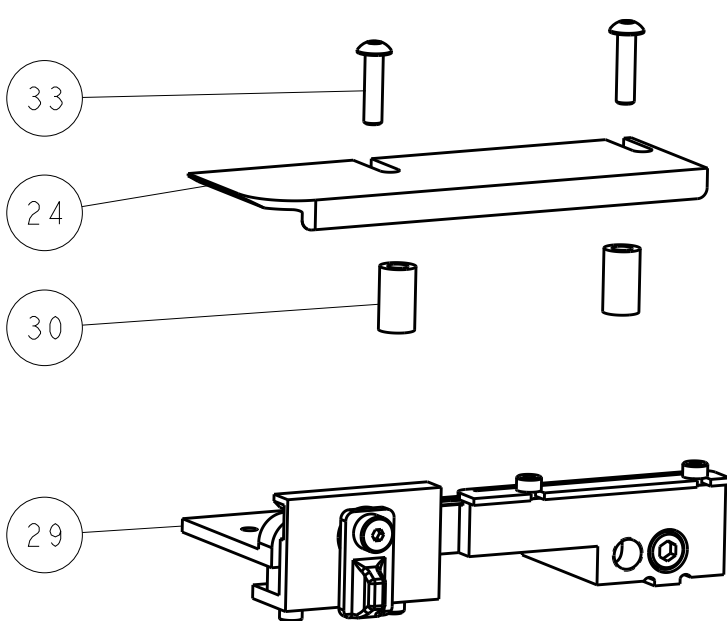
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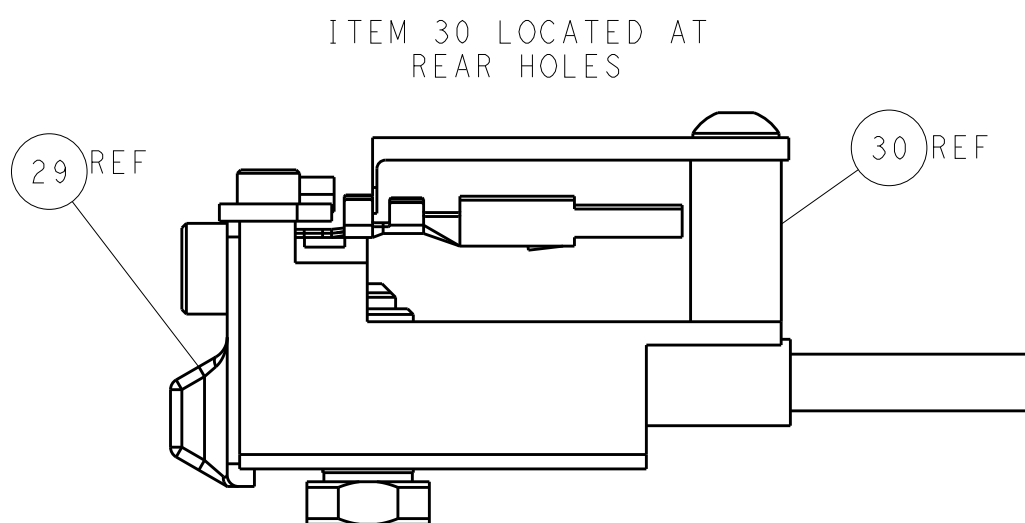
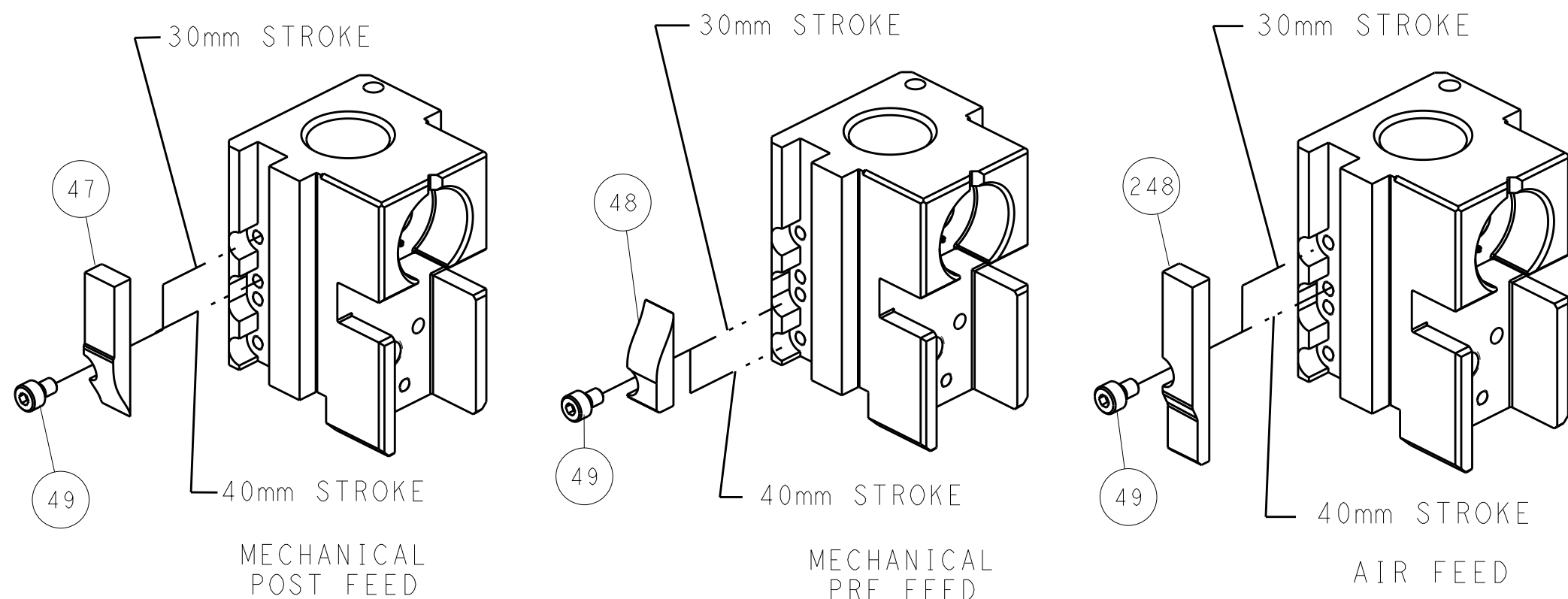
TERMINAL SUPPORT LOCATION



RAM SET-UP



CAM POSITIONS



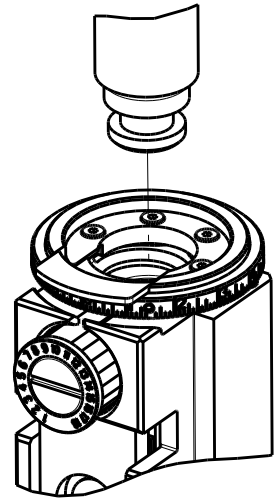
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

1ST PUBLISHED BY: 1. COMPANY: TYCO ELECTRONICS CORPORATION 2. IS SUBJECT TO CHANGE: 1. COMPANY: TYCO ELECTRONICS CORPORATION 2. IS SUBJECT TO CHANGE: 1. COMPANY: TYCO ELECTRONICS CORPORATION 3. IS SUBJECT TO CHANGE: 1. COMPANY: TYCO ELECTRONICS CORPORATION 4. IS SUBJECT TO CHANGE: 1. COMPANY: TYCO ELECTRONICS CORPORATION		DWN J. HOU 3APR2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		CHK L. ZHANG 3APR2014	NAME Ocean Side Feed Applicator
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD J. GUO 3APR2014	RESTRICTED TO -
MATERIAL -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	SIZE A1
Customer Accessible Production Drawing		SCALE 1:2	SHEET 2 of 4
		REV B	

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266254-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266254-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266254-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.54 mm [.100]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: DIA 2.5MM CONTACT-PIN			
WIRE STRIP LENGTH 3.90-4.60 mm [.154-.181 IN]		INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	(B)114-18040	-	-
	(A)114-18020	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 929986-1	(A) 929970-1	(A) 929970-8	(A) 929963-8
(B) 929986-4	(A) 929970-7	(A) 929963-1	(A) 1-929963-0

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.45+/-0.05 [.057+/-0.002]		7.6
0.75mm2		1.36+/-0.05 [.054+/-0.002]		8.8
0.50mm2		1.27+/-0.05 [.050+/-0.002]		9.7



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
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.

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	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

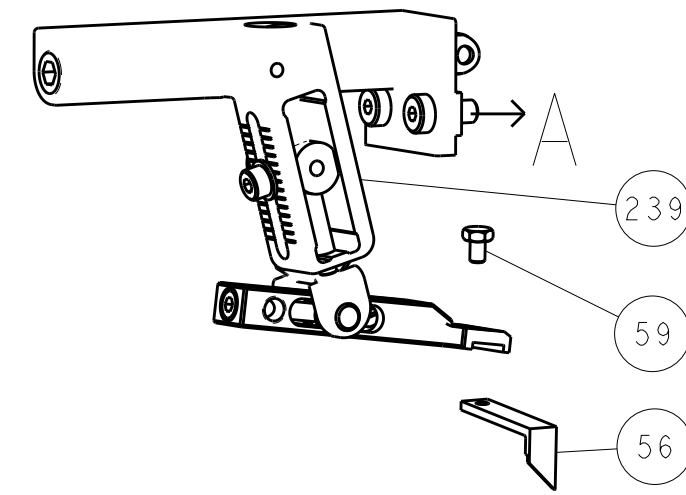
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	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	1803607-1	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
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	50
-	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	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-6	STRIP GUIDE	24
-	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	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1	1-1333204-8	ANVIL, COMBINATION	8
-	1	1	2-240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS.				DWN J. HOU 3APR2014	TE Connectivity Harrisburg, PA 17105-3608	
CHK L. ZHANG 3APR2014				NAME	Ocean Side Feed Applicator	
APVD J. GUO 3APR2014				PRODUCT SPEC	-	
APPLICATION SPEC				SIZE	CAGE CODE	DRAWING NO
MATERIAL				WEIGHT	00779	2266254
FINISH				Customer Accessible Production Drawing	SCALE	1:2
				SHEET	3	OF 4
				REV	B	

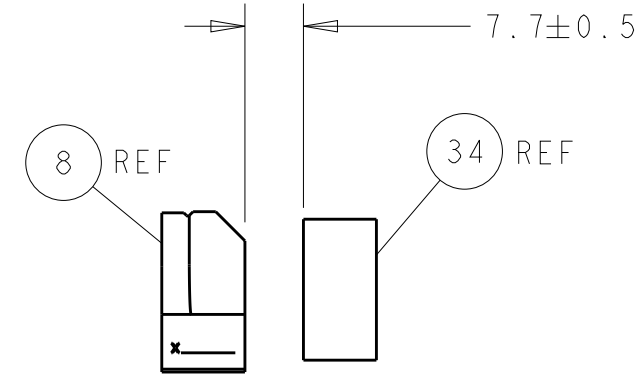
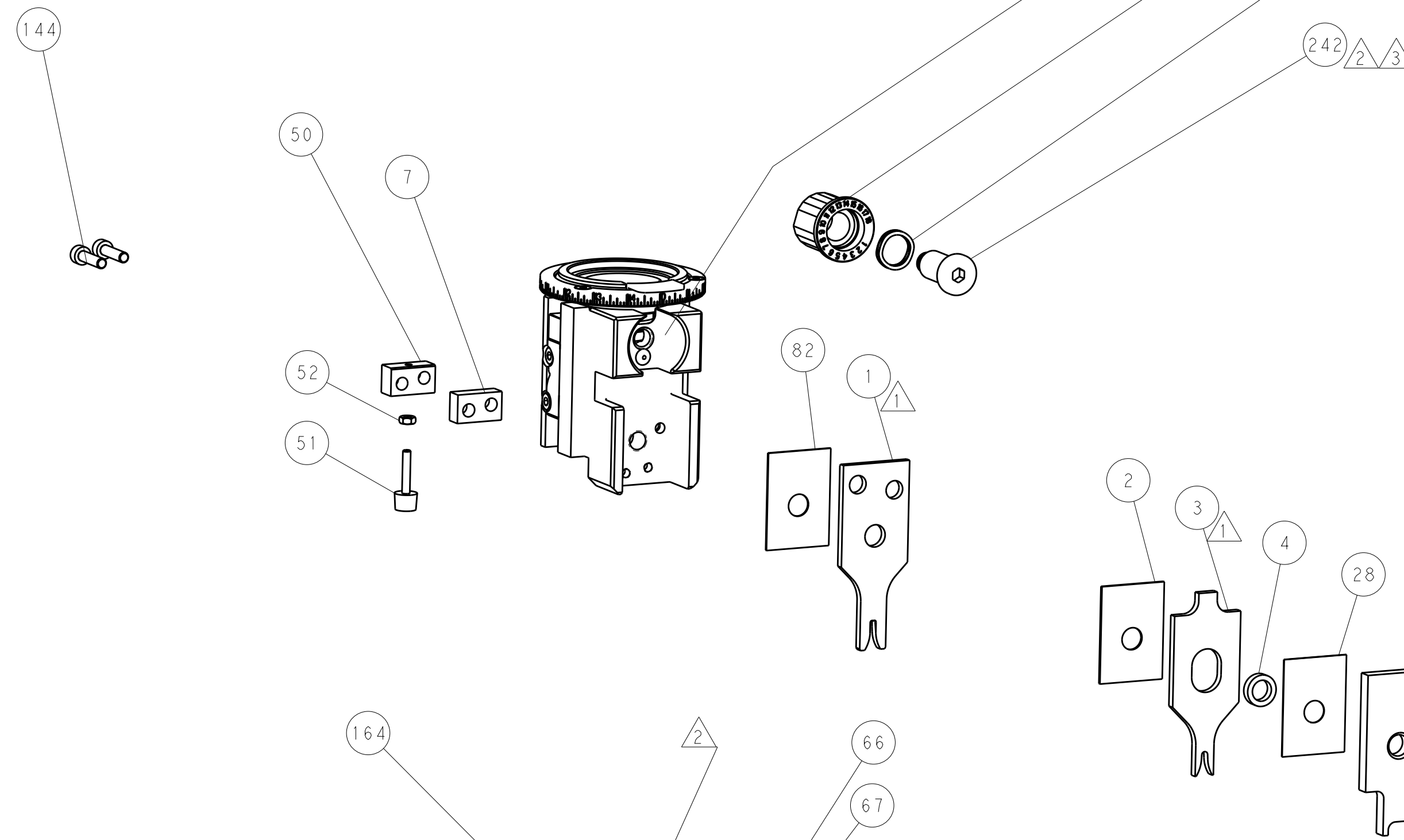
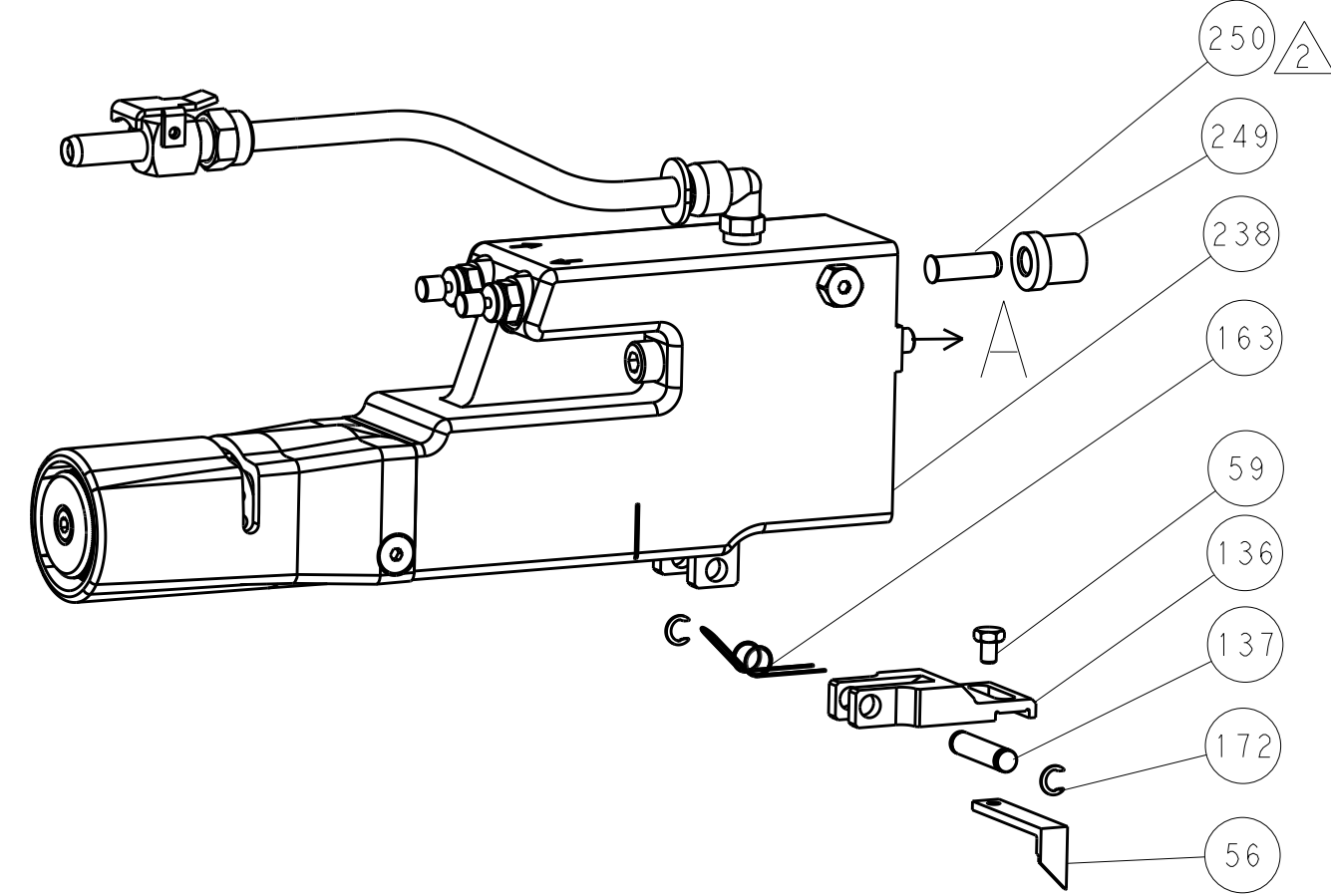
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

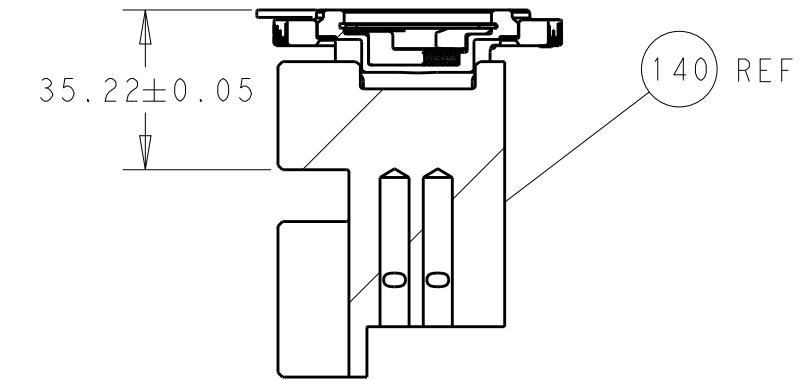
FEED TYPE
MECHANICAL



PNEUMATIC

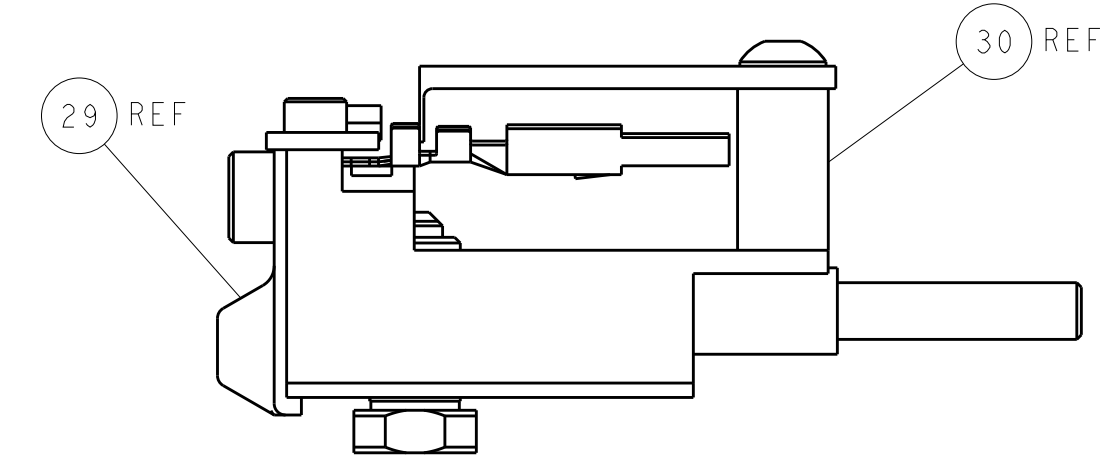


TERMINAL SUPPORT LOCATION



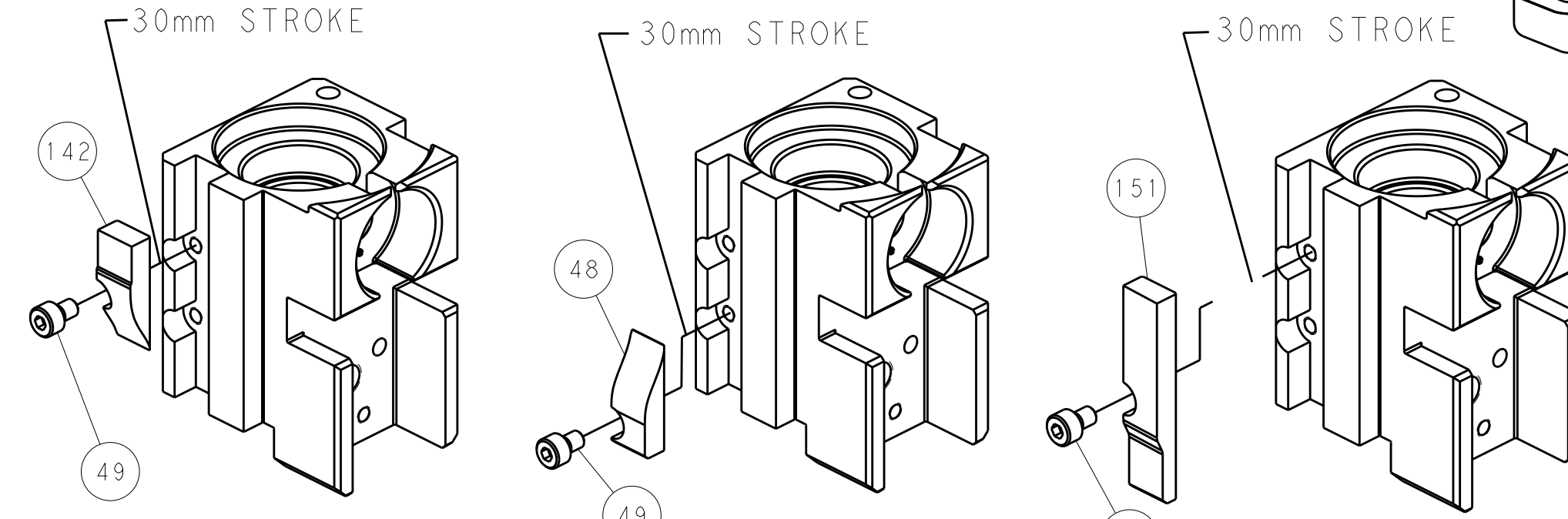
RAM SET-UP

ITEM 30 LOCATED AT
REAR HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HOU 3APR2014		CHK L. ZHANG 3APR2014		APVD H. GUO 3APR2014		NAME Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		ANGLES ±	
FINISH		MATERIAL		WEIGHT		Customer Accessible Production Drawing		SCALE 1:2		SHEET 4 OF 4	
REV B		REV		REV		REV		REV		REV	

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Authorized Distributor

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[TE Connectivity:](#)

[2266254-1](#)