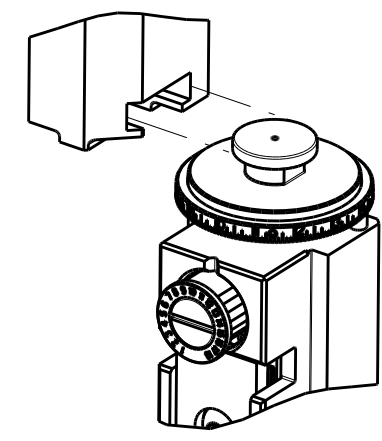


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266508-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266508-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266508-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266508-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266508-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.05 mm [.120]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, .093 DIAMETER, P.C. CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.17-3.94 mm [.125-.155 IN]		Ø1.52-2.79 mm [.060-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1008		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61291-1	61291-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.29+/-0.05 [.051+/-0.002]	8.1
20 AWG	1.17+/-0.05 [.046+/-0.002]	9.4
22 AWG	1.09+/-0.05 [.043+/-0.002]	10.0

- 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. 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	REV	DATE	BY	CHKD
		A	RELEASED	31OCT2014	MR TE
		B	ECR-19-009227	12JUN2019	FZ TB

-	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	
-	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	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-7	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	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	1320928-2	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	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	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	3-1633919-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2	
-	1	2	2	1	1	3-456404-5	CRIMPER, WIRE PREMIUM	1

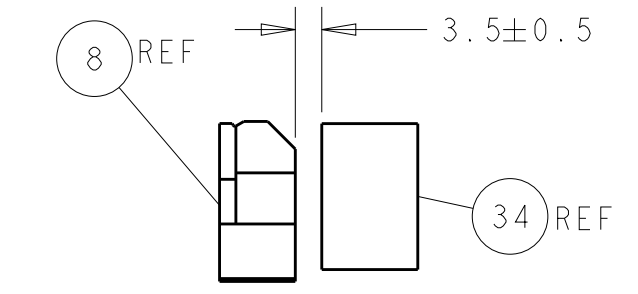
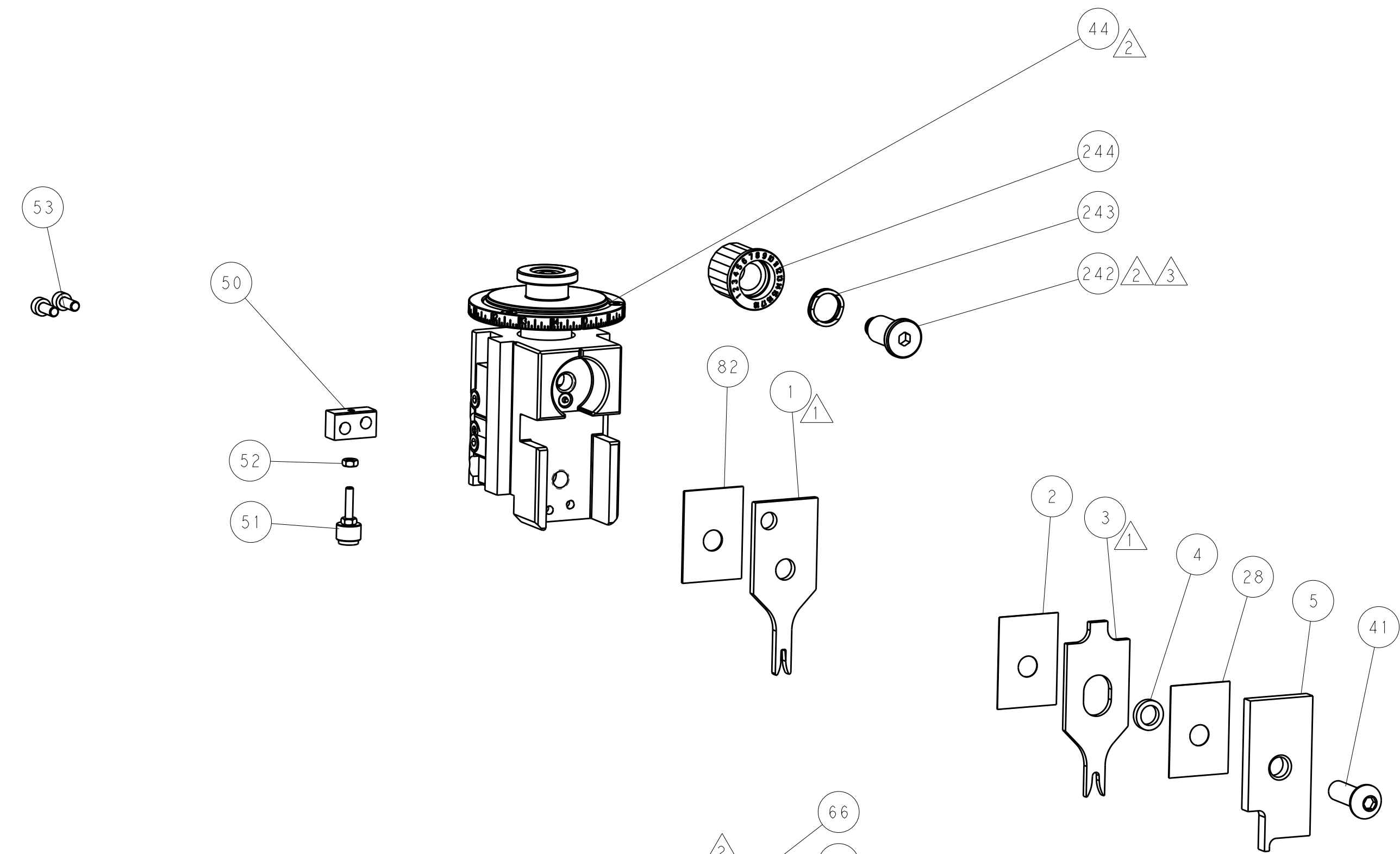
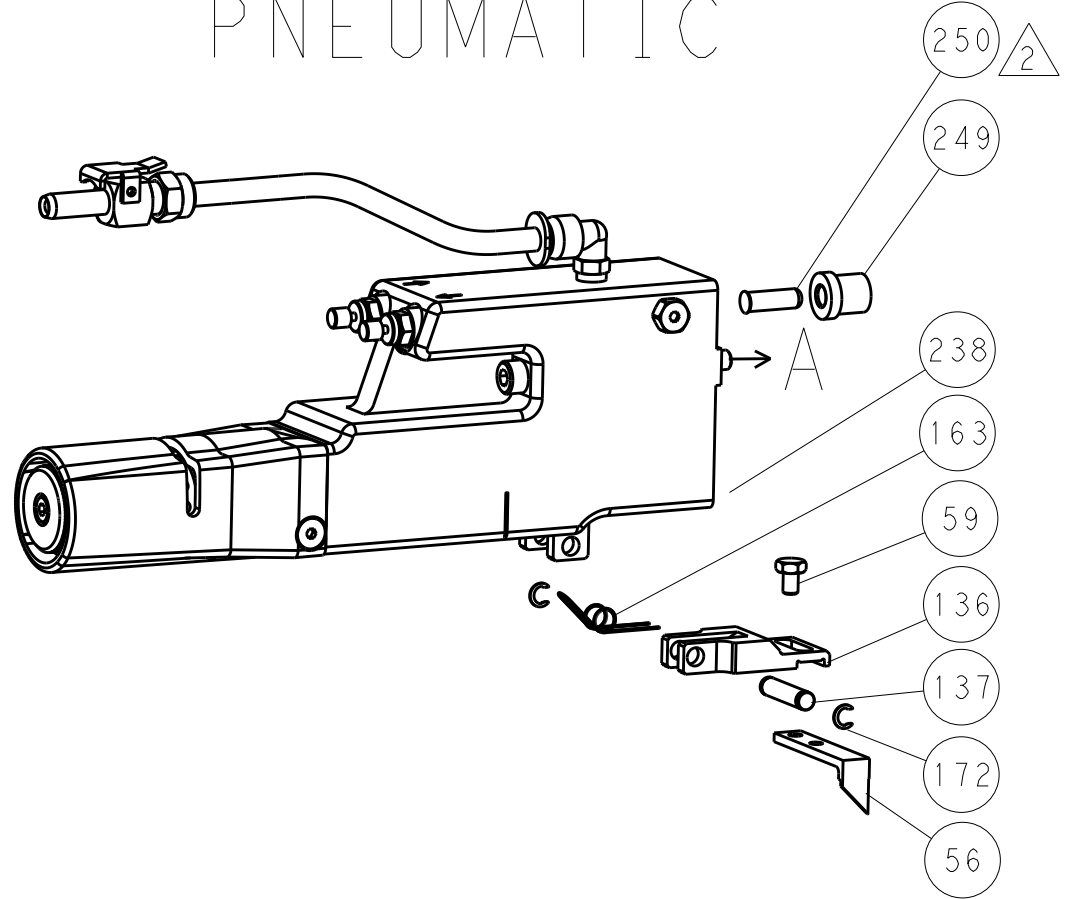
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE 1:2 SHEET 1 OF 4 REV B

LOC	DIST	REV	DATE	BY	APPV
A	66				

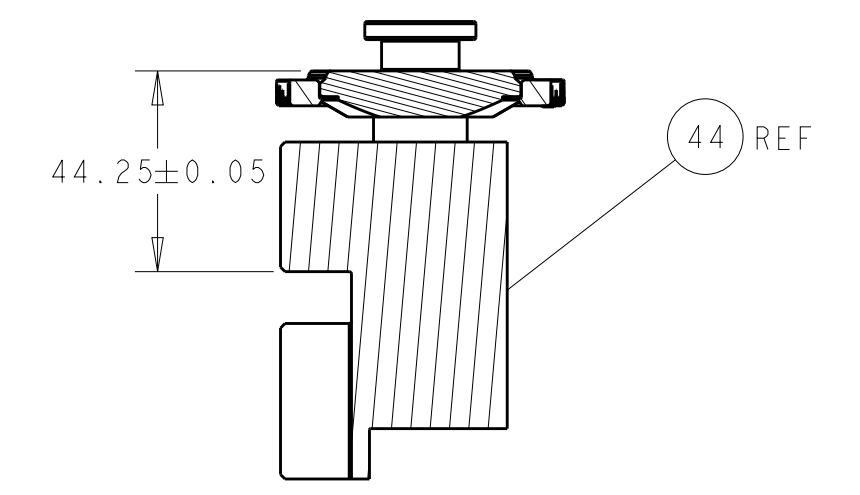
# FEED TYPE MECHANICAL



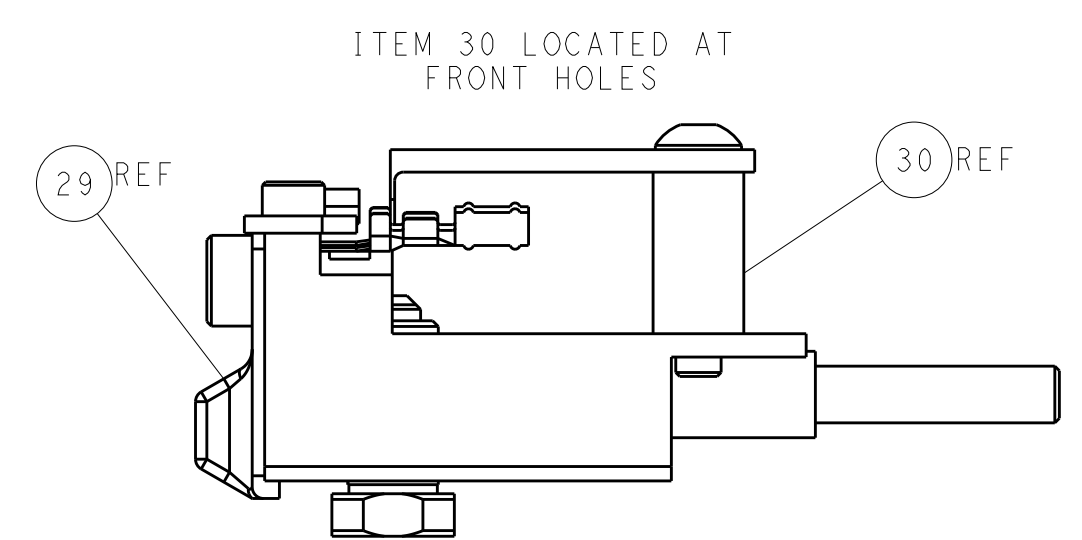
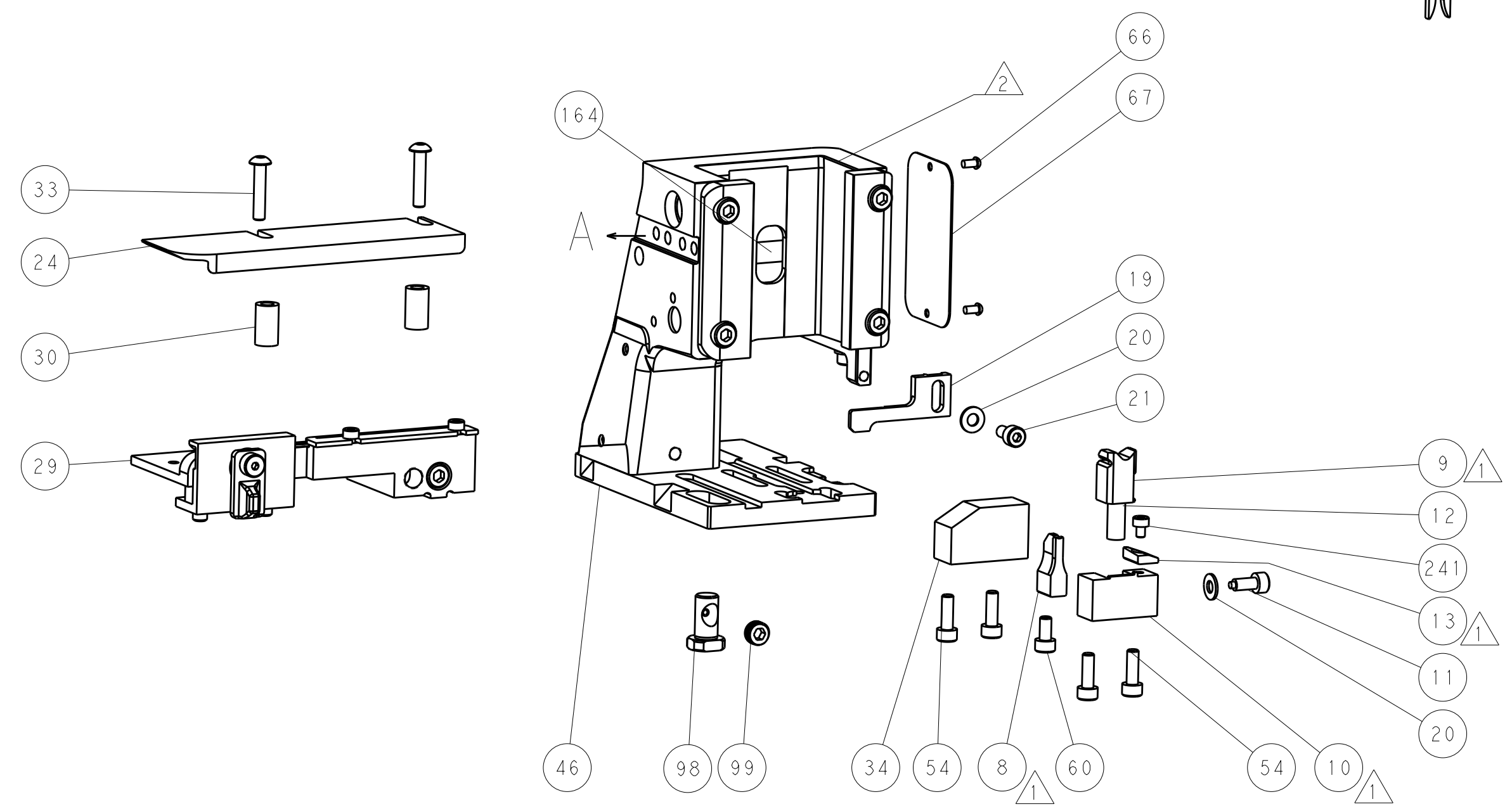
# PNEUMATIC



TERMINAL SUPPORT LOCATION

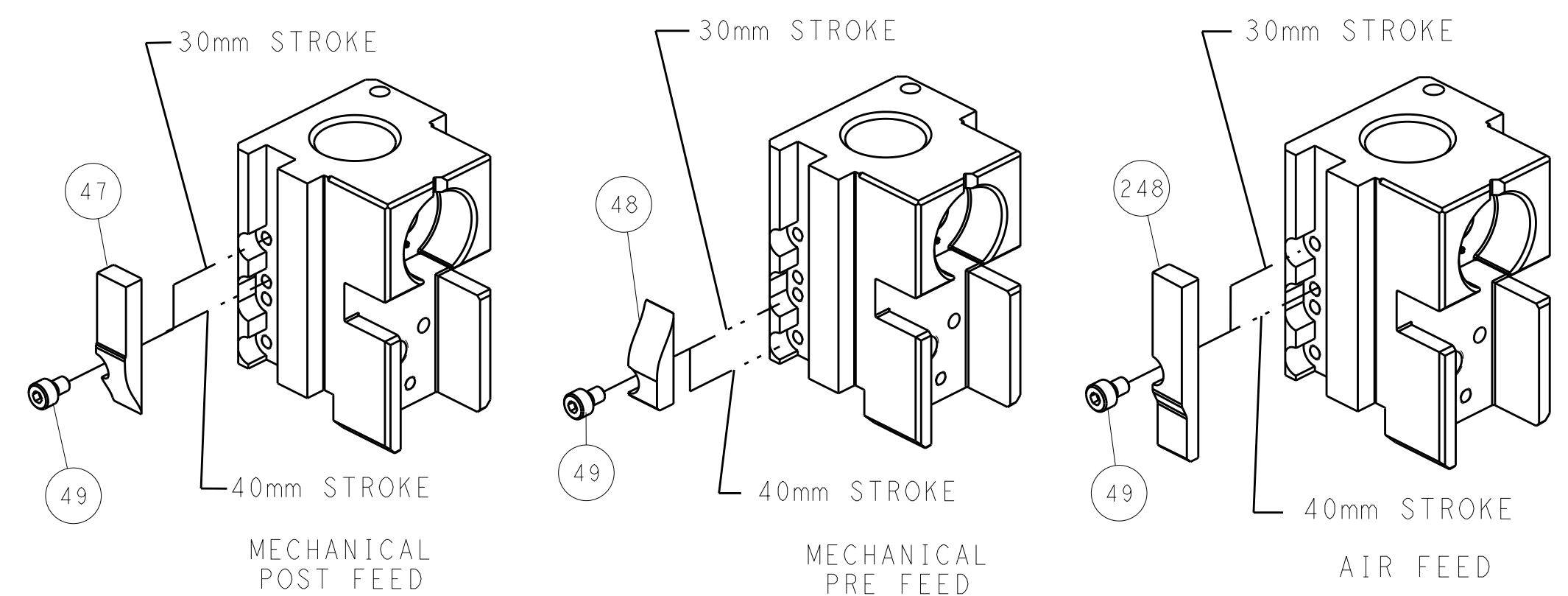


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

# 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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN L. HUANG 16SEP2014 CHK L. ZHANG 16SEP2014 APVD H. GUO 16SEP2014 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2266508 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV B	
MATERIAL:		FINISH:		WEIGHT:	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266508-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266508-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266508-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.05 mm [.120]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, .093 DIAMETER, P.C. CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.17-3.94 mm [.125-.155 IN]		∅1.52-2.79 mm [.060-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1008		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61291-1	61291-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.29+/-0.05 [.051+/-0.002]	8.1
20 AWG	1.17+/-0.05 [.046+/-0.002]	9.4
22 AWG	1.09+/-0.05 [.043+/-0.002]	10.0

- 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. 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	REV	DATE	BY	APPD
A	66				

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPD
-	-	SEE SHEET 1	-	-	-
-	1	2119640-1			250
-	1	1803259-1			249
-	1	2119082-4			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	7-18023-7			241
-	-	2119580-1			239
-	1	2063440-1			238
-	2	21045-3			172
-	REF	994970-2			164
-	1	240638-1			163
-	1	2119641-2			151
-	1	2168083-8			144
-	4	2168083-9			143
-	-	2119653-2			142
-	1	1-1803583-0			141
-	1	1803516-1			140
-	1	3-23627-7			137
-	1	2119799-1			136
-	1	2844908-1			99
-	1	2844907-1			98
-	1	455888-7			82
-	1	1803607-1			71
-	1	2119740-1			67
-	2	2168078-1			66
-	1	5-18022-5			59
-	1	1338685-1			56
-	2	1-2168083-0			53
-	1	5018030-1			52
-	1	811242-5			51
-	1	690753-2			50
-	1	18023-9			49
-	-	2119652-1			48
-	1	1803602-1			41
-	1	1752356-3			34
-	2	2079383-5			33
-	2	2-2844962-6			30
-	1	2844992-1			29
-	1	455888-3			28
-	1	1320928-2			24
-	1	2168083-2			21
-	2	1-18028-2			20
-	1	2119533-1			19
-	1	2119806-1			13
-	1	3-22280-3			12
-	1	1-356885-4			11
-	1	2119805-1			10
-	1	1803095-6			9
-	1	3-1633919-6			8
-	-	-			7
-	-	-			6
-	1	2119757-8			5
-	1	238011-4			4
-	1	1633965-2			3
-	1	455888-2			2
-	1	3-456404-5			1

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

DATE	16SEP2014	CHK	H. HUANG
DATE	16SEP2014	CHK	L. ZHANG
DATE	16SEP2014	APPD	J. GUO

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266508	

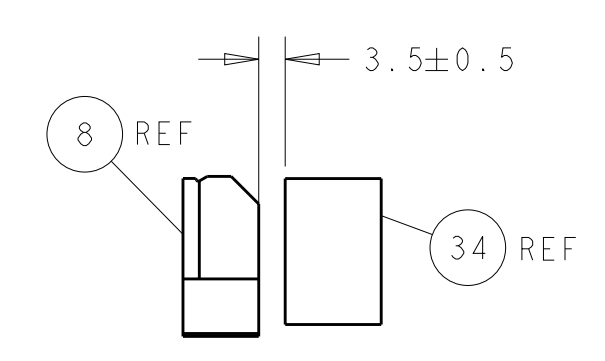
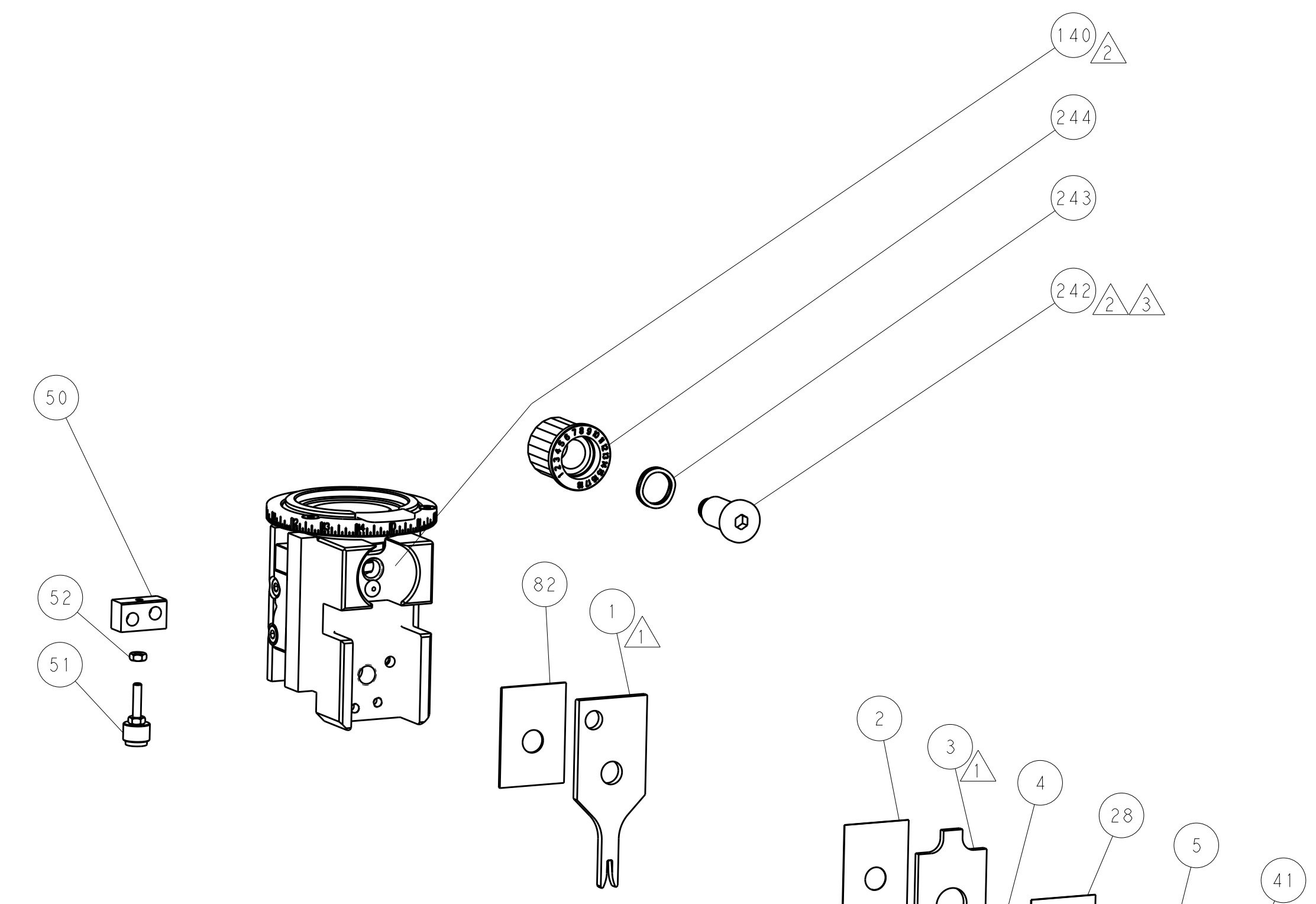
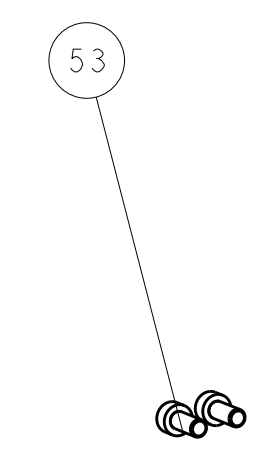
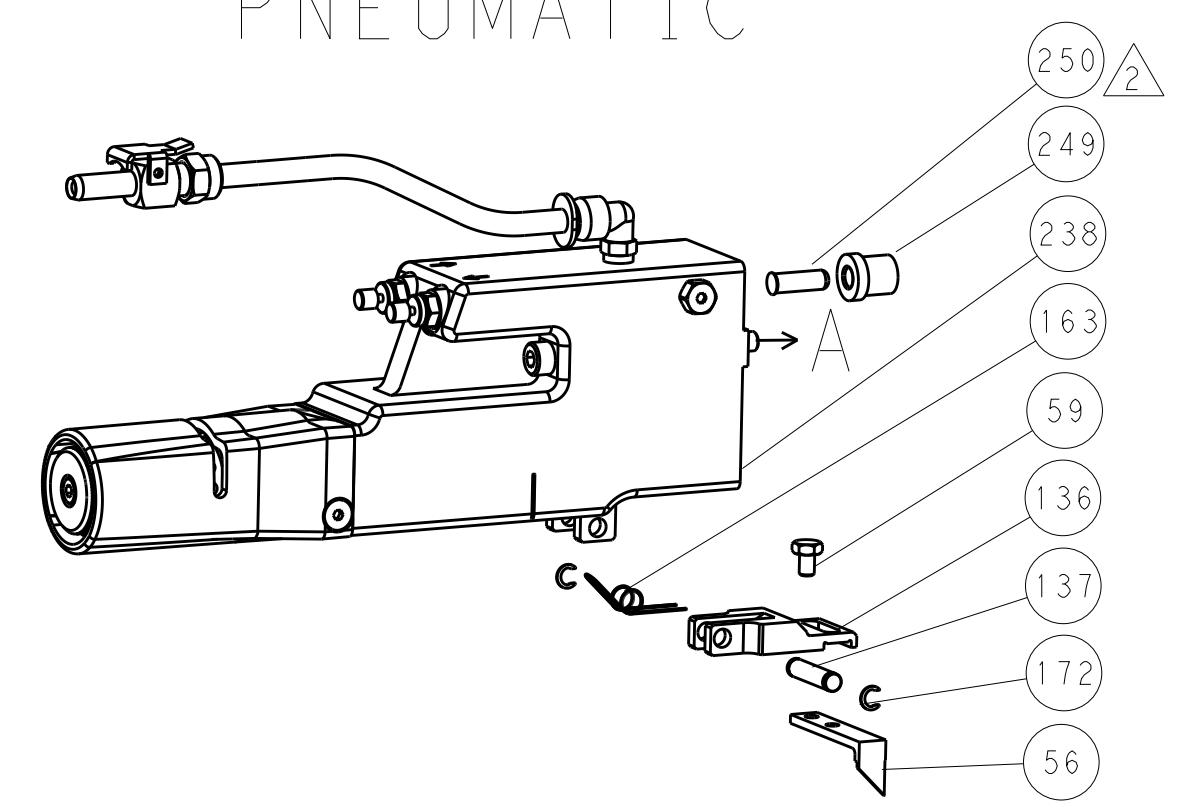
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B

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

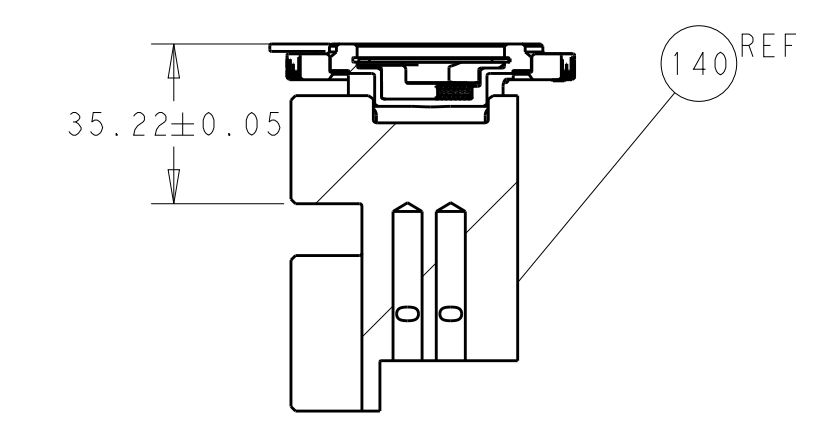
# FEED TYPE MECHANICAL



# PNEUMATIC

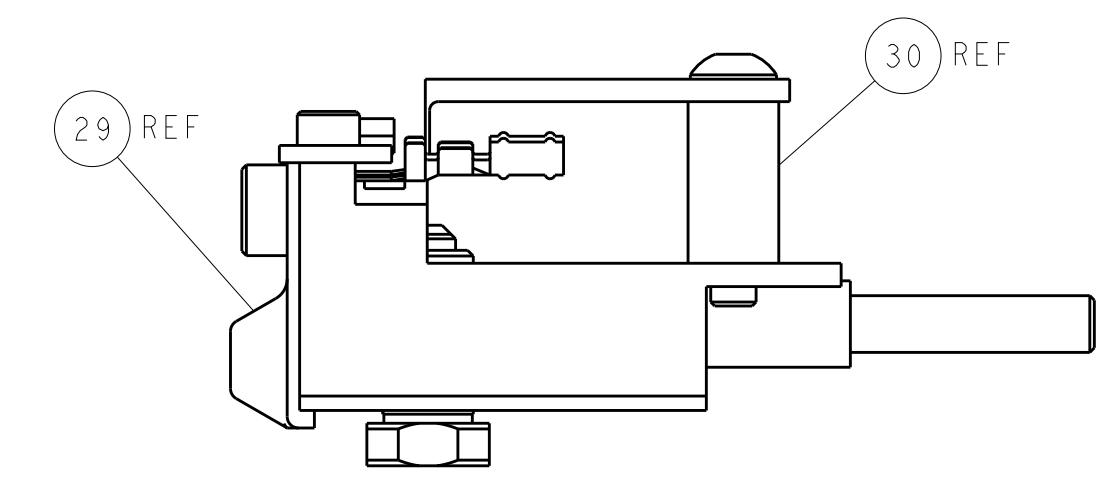


TERMINAL SUPPORT LOCATION



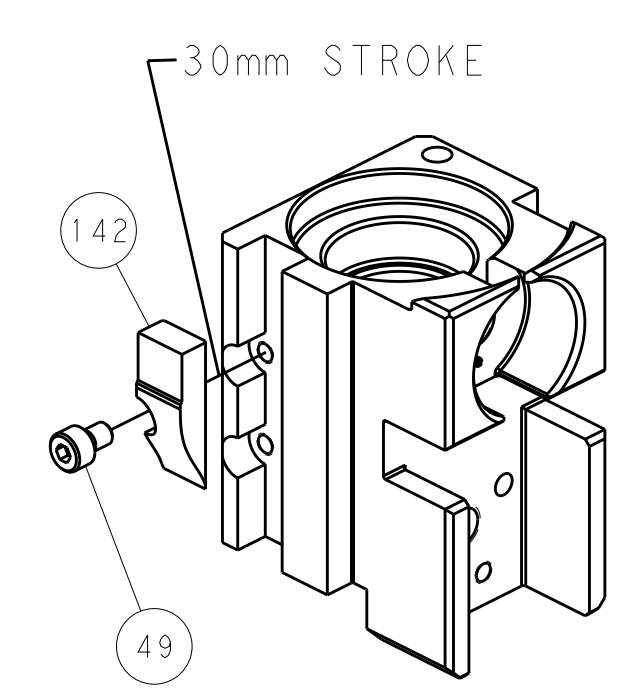
RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES

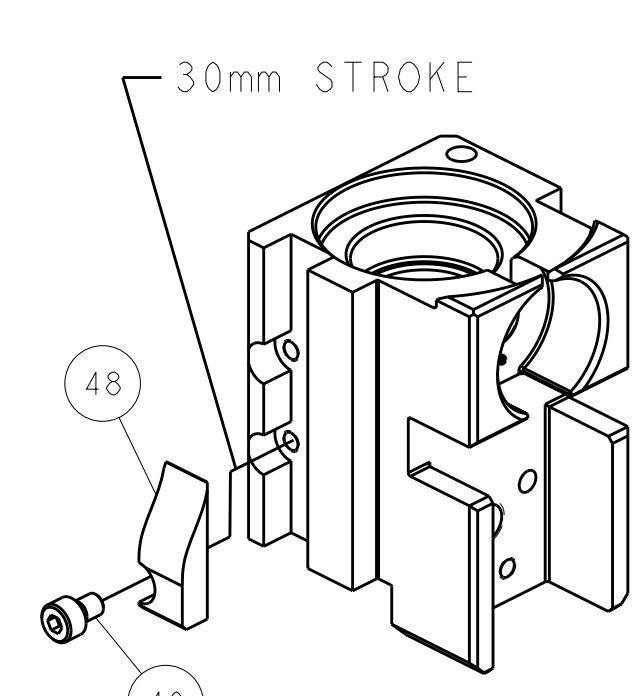


FEED TRACK POSITION GUIDE BY INSULATION BARREL

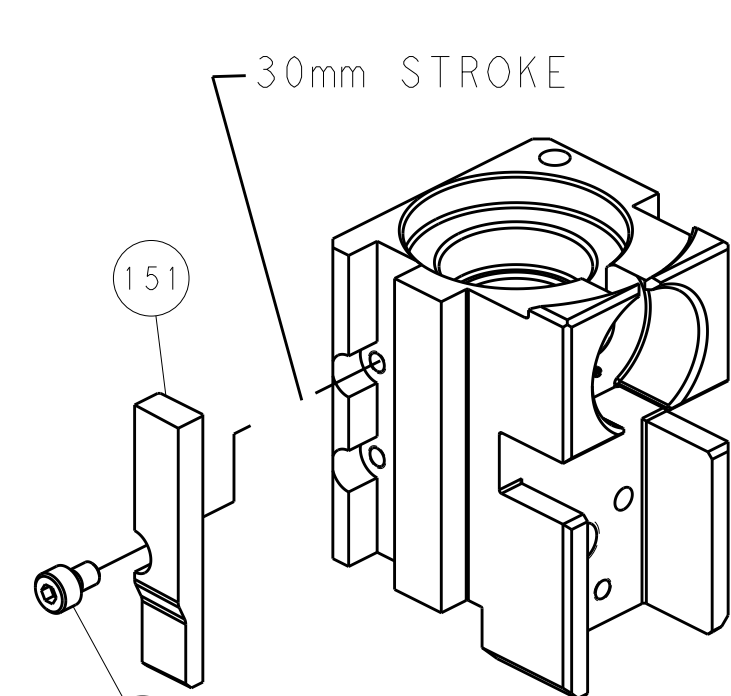
# CAM POSITIONS



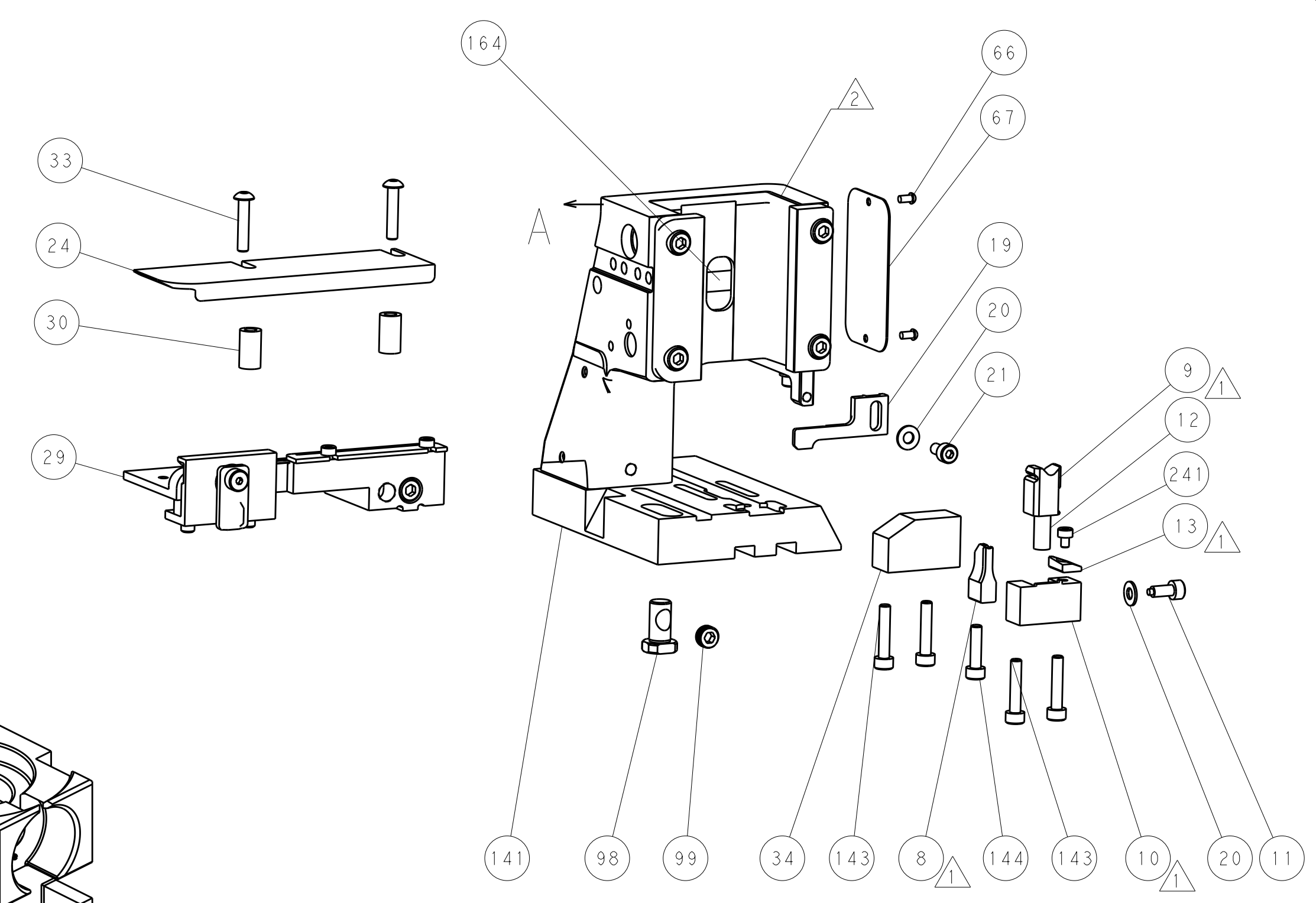
MECHANICAL POST FEED



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG 16SEP2014		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK L. ZHANG 16SEP2014	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD H. GUO 16SEP2014	PRODUCT SPEC	-	
	2 PLC	±			APPLICATION SPEC	-	
	3 PLC	±			SIZE	CAGE CODE	DRAWING NO
	4 PLC	±			A1	00779	©=2266508
	ANGLES	±			WEIGHT	-	
MATERIAL	FINISH	-			Customer Accessible Production Drawing	SCALE	1:2 SHEET 4 OF 4 REV B

# Mouser Electronics

Authorized Distributor

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[2266508-1](#)