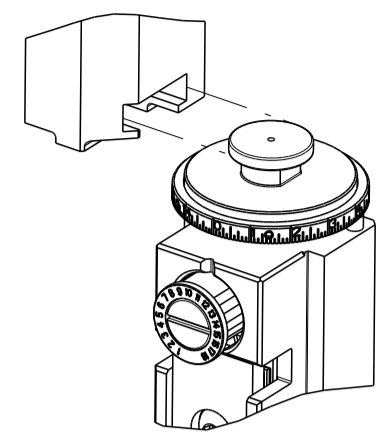


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266257-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266257-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266257-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



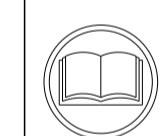
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [ .210 ]	F
INSUL	12.50 mm [ .492 ]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MECON 8 CONTACT			
WIRE STRIP LENGTH	8.30-8.90 mm [ .327-.350 IN ]	SEAL COLLAR DIA RANGE	10 mm [ .394 IN ]
TERMINAL APPLICATION SPECIFICATION	114-94761		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	LEAR SEAL	
1-2208766-3			13214 627 619	4.0-4.5mm
			13213 627 642	3.4-3.8mm

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.70 +/- 0.05 [ .106 +/- .002 ]	12.5
4.00mm2	2.42 +/- 0.05 [ .095 +/- .002 ]	15.3



- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- CUT TO LENGTH AT ASSEMBLY.
- FOR BEST RESULTS, WIRE MUST BE PLACED INTO WIRE BARREL PRIOR TO CRIMPING.

**\*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	APVD
		E		ECR-19-002571	18FEB2019	FJ	CT
		F		ECR-22-136653	21APR2022	FZ	JH
		G		ECR-22-146922	21JUL2022	FZ	TE
		G1		ECR-22-155430	13OCT2022	FZ	MP

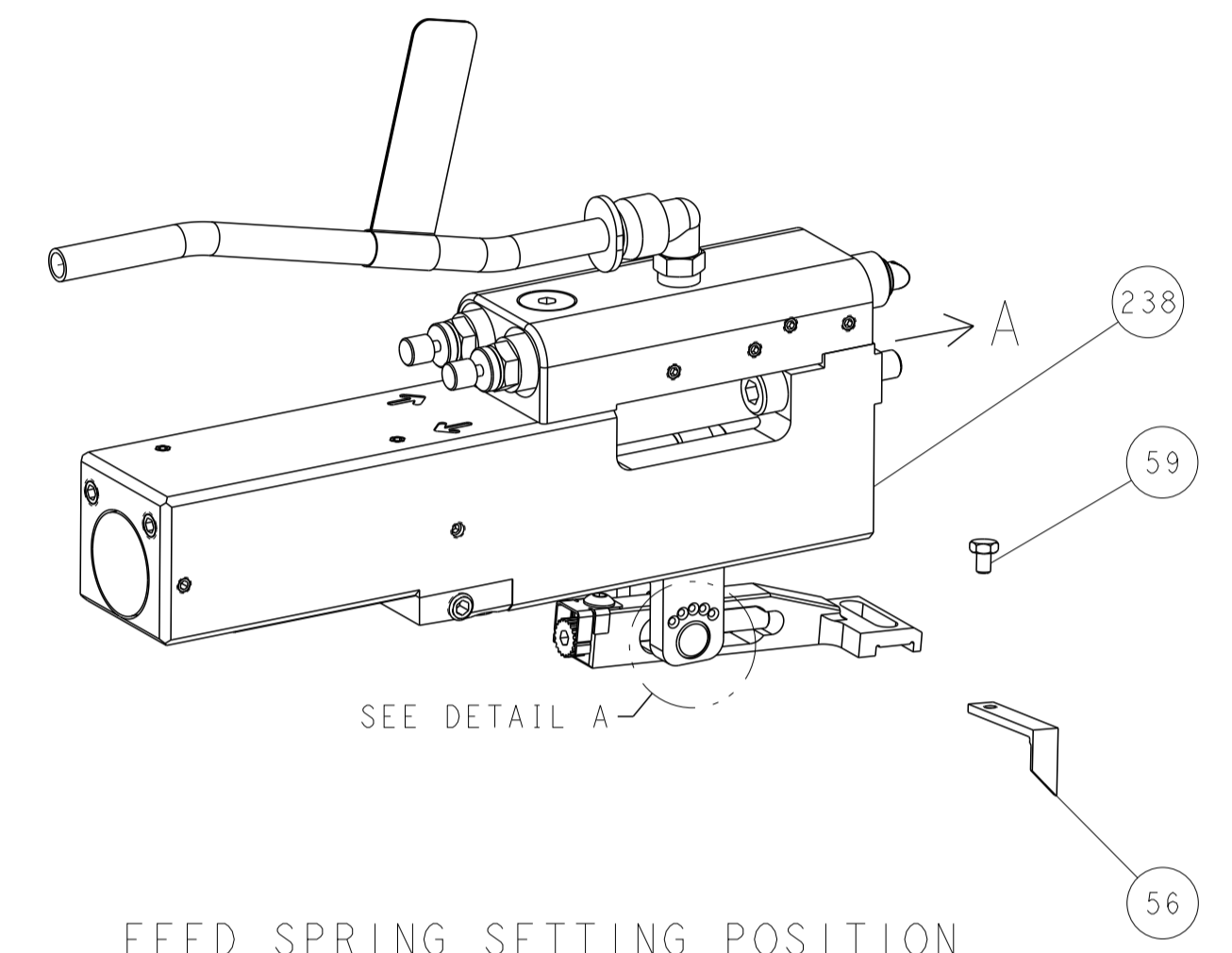
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1633782-4	FENCE	267	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2844940-2	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	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	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	2-455888-4	SPACER, CRIMPER	82	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-7	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	811242-6	BUMPER, HOLD DOWN	57	
-	1	1	1-1338683-1	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1-811242-0	BUMPER, HOLD DOWN	51	
-	1	1	690753-2	SPACER, TONKER	50	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	2-1803583-6	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1752356-7	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844938-9	PLATE, STRIP GUIDE	29	
-	1	1	2-455888-8	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	1320928-6	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	1803013-1	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	2-2119805-0	SHEAR HOLDER, FRONT	10	
-	1	1	1-318059-2	FLOATING SHEAR, FRONT	9	
-	1	2	1	2-1633930-3	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1-1803080-2	DEPRESSOR, SHEAR	5	
-	1	1	2-238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	1	3-1633996-8	CRIMPER, INSULATION SPECIAL	3
-	1	1	455888-8	SPACER, CRIMPER	2	
-	1	2	1	1-1803179-2	CRIMPER, WIRE PREMIUM	1

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

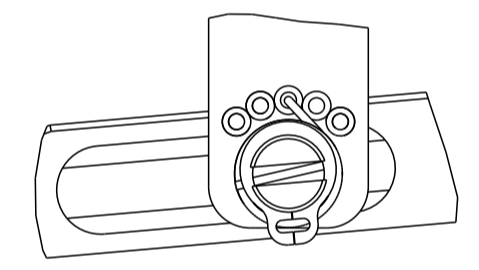
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

# FEED TYPE

## PNEUMATIC

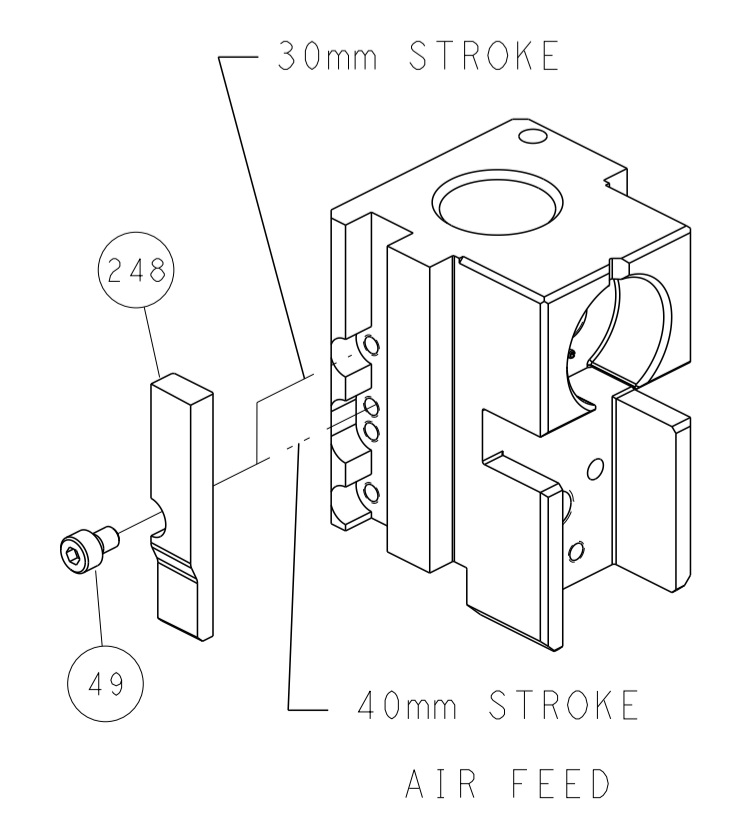


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

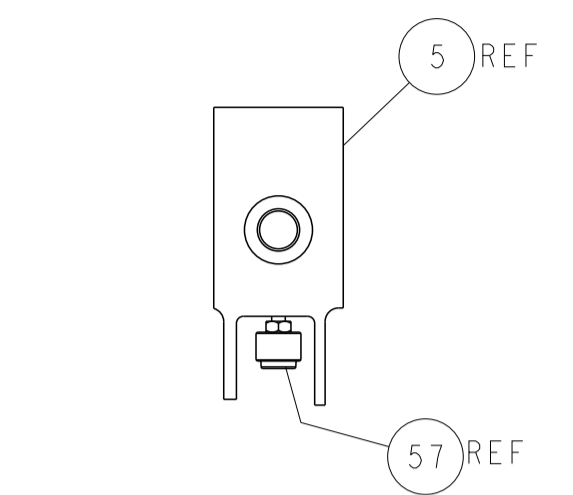
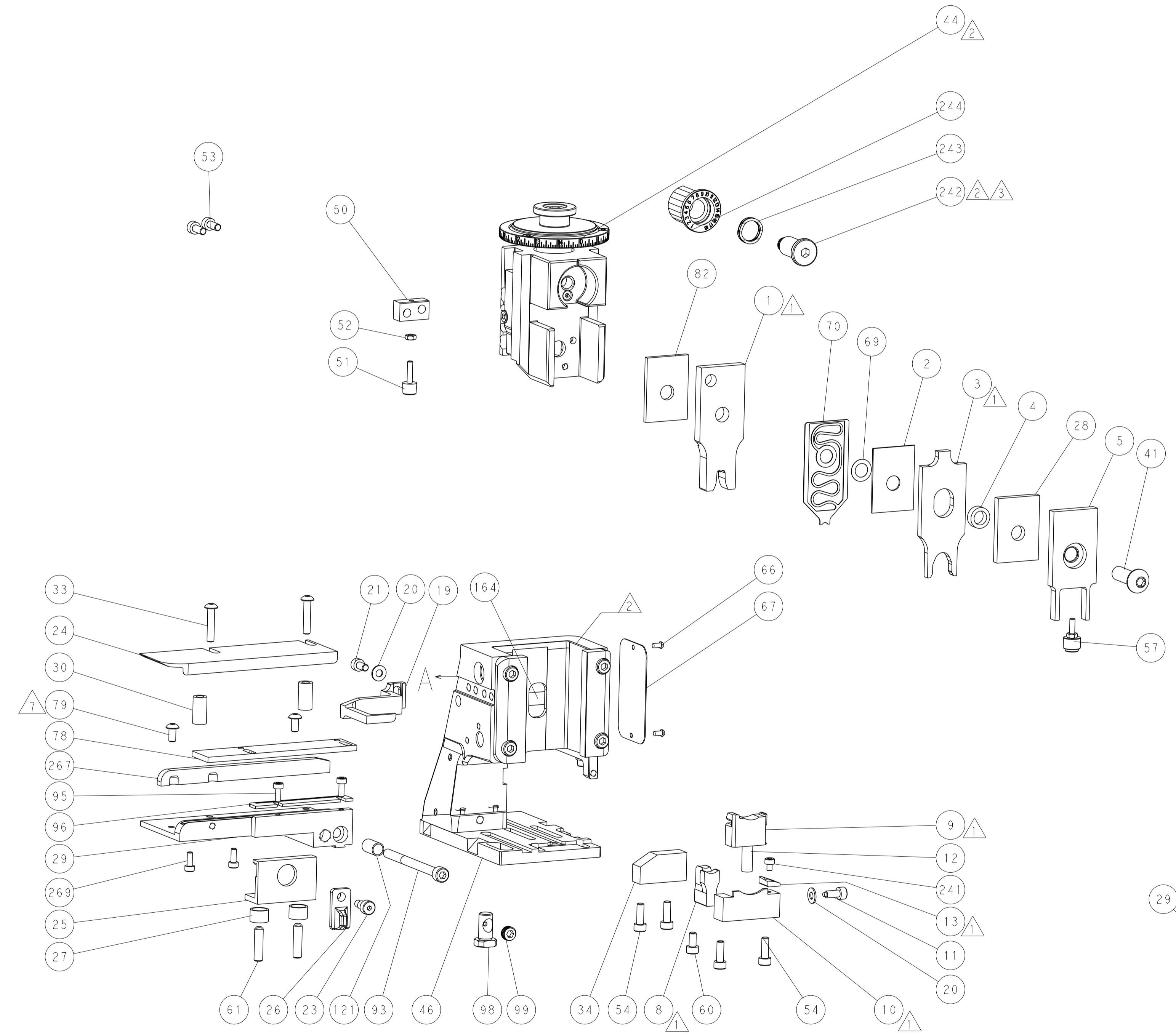


DETAIL A

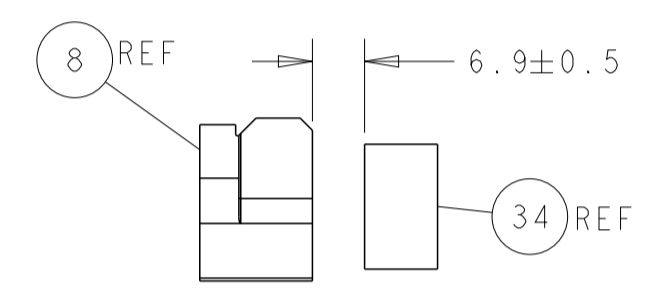
## CAM POSITION



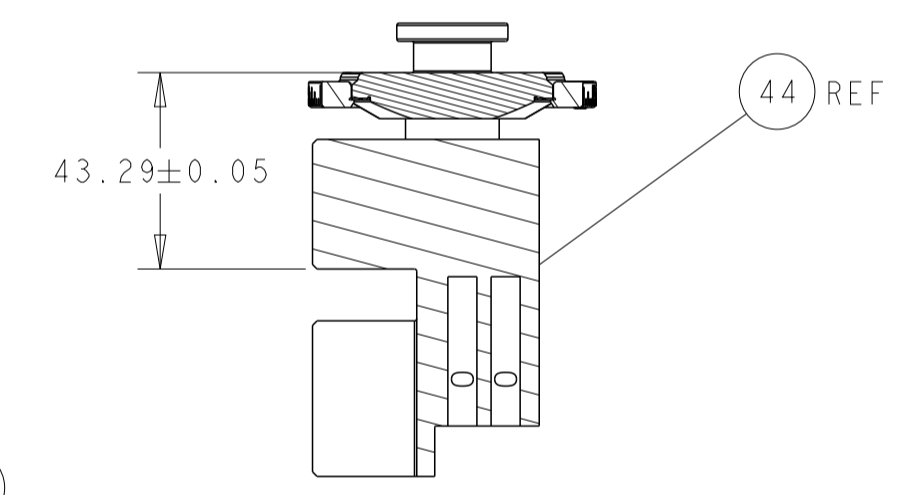
AIR FEED



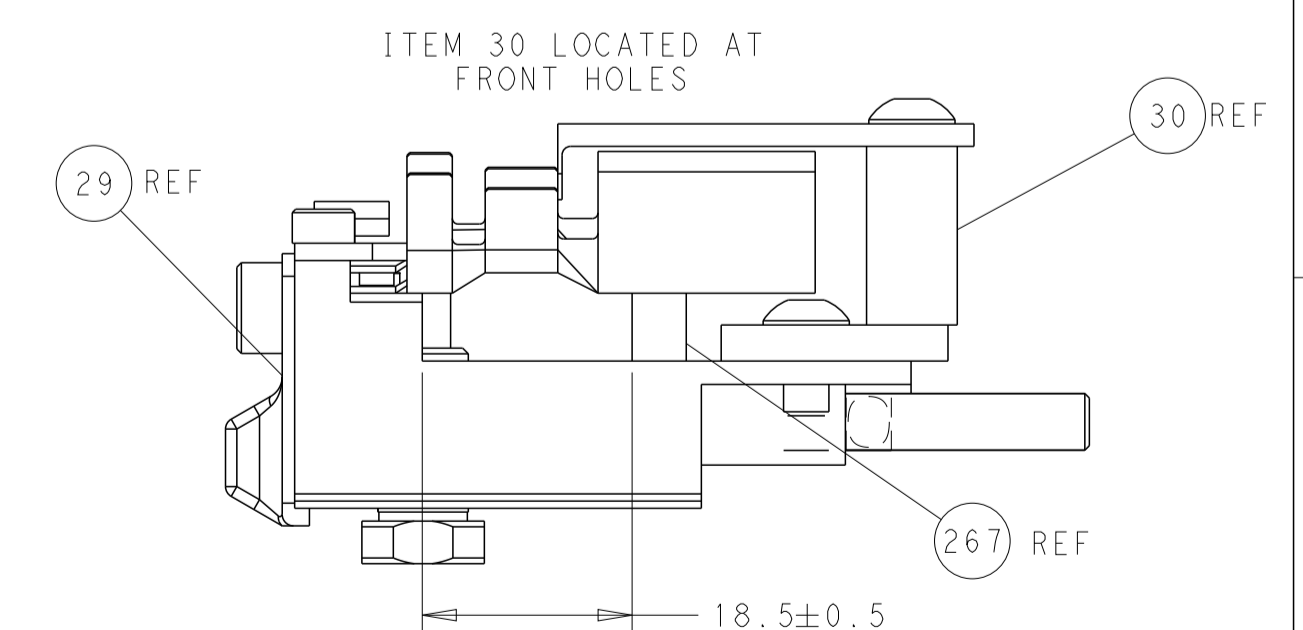
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN R.O. WILSON 19MAY2014 CHK K.J. STAKEM 22MAY2014 APVD T.L. ELBIN 22MAY2014	NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266257 SCALE 1:2 SHEET 2 OF 4 REV G1
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL FINISH	WEIGHT Customer Accessible Production Drawing	TE Connectivity Harrisburg, PA 17105-3608

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266257-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266257-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [ .210 ]	F
INSUL	12.50 mm [ .492 ]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MECON 8 CONTACT			
WIRE STRIP LENGTH 8.30-8.90 mm [ .327-.350 IN ]		SEAL COLLAR DIA RANGE 10 mm [ .394 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-94761	-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	LEAR SEAL	SEAL INSULATION DIAMETER RANGE
1-2208766-3			13214 627 619	4.0-4.5mm
			13213 627 642	3.4-3.8mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.70 +/- 0.05 [ .106 +/- .002 ]	12.5
4.00mm2	2.42 +/- 0.05 [ .095 +/- .002 ]	15.3



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 CUT TO LENGTH AT ASSEMBLY.
- 8. FOR BEST RESULTS, WIRE MUST BE PLACED INTO WIRE BARREL PRIOR TO CRIMPING.

**\*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	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

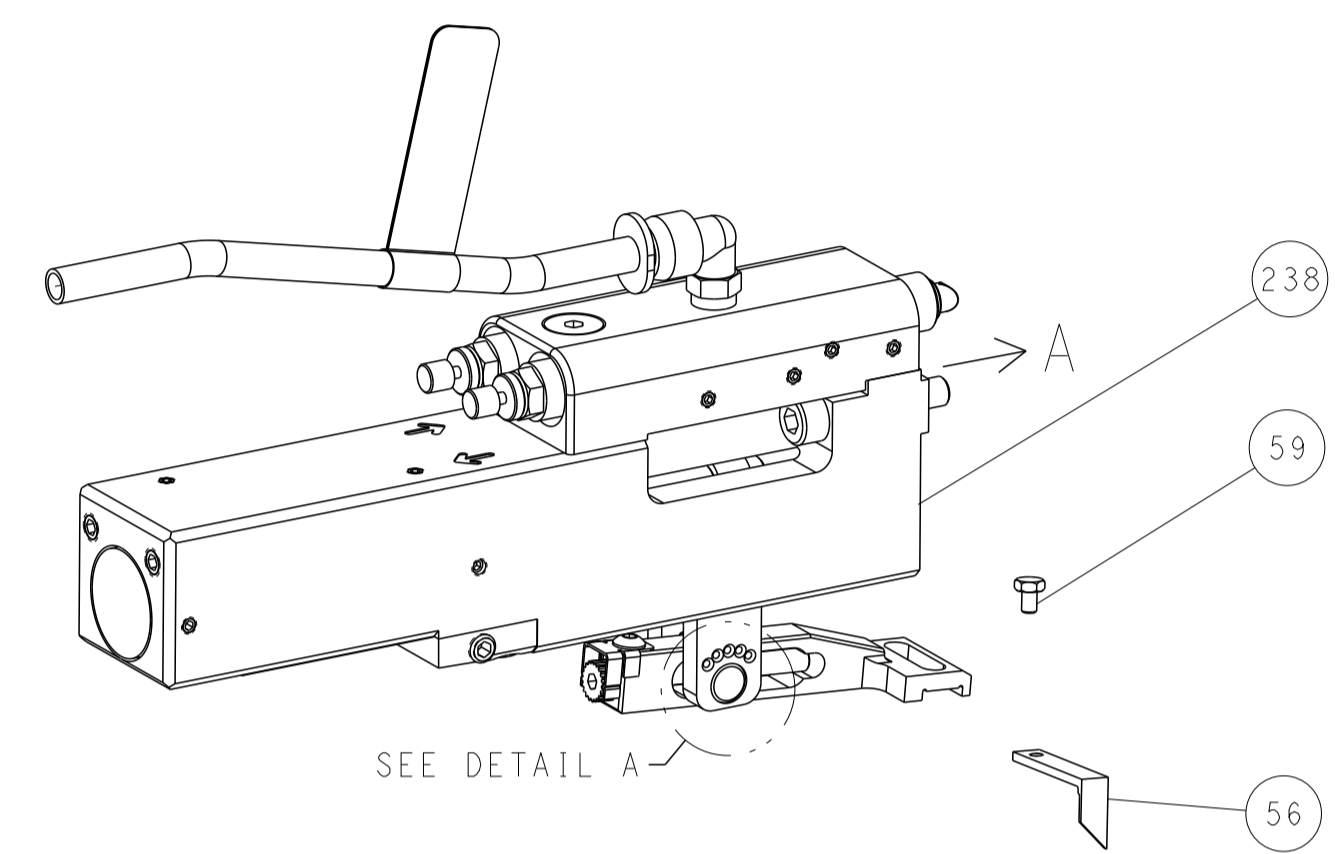
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1633782-4	FENCE	267
-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-2	AIR FEED MODULE	238
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-8	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	1-22281-8	SPRING, COMPRESSION	121
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	2-455888-4	SPACER, CRIMPER	82
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1803096-1	EXTENSION PLATE	78
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119791-7	DEPRESSOR, WIRE	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	811242-6	BUMPER, HOLD DOWN	57
-	1	1-1338683-1	FEED PAWL	56
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1-811242-0	BUMPER, HOLD DOWN	51
-	1	690753-2	SPACER, TONKER	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1752356-7	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844938-9	PLATE, STRIP GUIDE	29
-	1	2-455888-8	SPACER, CRIMPER	28
-	2	22283-1	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-6	STRIP GUIDE	24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1803013-1	STRIPPER, SIDE FEED	19
1	-	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
1	-	2-2119805-0	SHEAR HOLDER, FRONT	10
1	-	1-318059-2	FLOATING SHEAR, FRONT	9
1	1	2-1633930-3	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	1-1803080-2	DEPRESSOR, SHEAR	5
-	1	2-238011-7	BLOCK, CRIMPER SPACER	4
1	1	3-1633996-8	CRIMPER, INSULATION SPECIAL	3
-	1	455888-8	SPACER, CRIMPER	2
1	1	1-1803179-2	CRIMPER, WIRE PREMIUM	1

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BY: R.O. WILSON		CHK: K.J. STARKEM	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC ±		1 PLC ±	
2 PLC ±		3 PLC ±	
4 PLC ±		ANGLES ±	
FINISH		MATERIAL	
APVD: I.L. ELBIN		NAME: Ocean Side Feed Applicator	
PRODUCT SPEC		APPLICATION SPEC	
SIZE: A1		CAGE CODE: 00779	
DRAWING NO: 2266257		SCALE: 1:2	
SHEET: 3		OF: 4	
REV: G1		Customer Accessible Production Drawing	

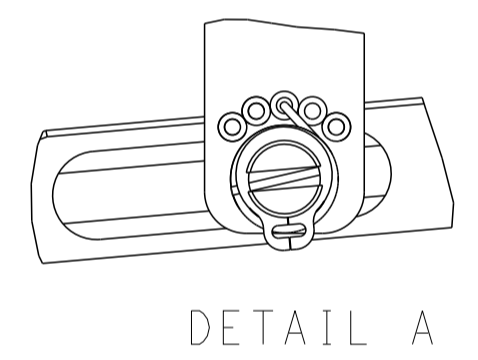
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

### FEED TYPE

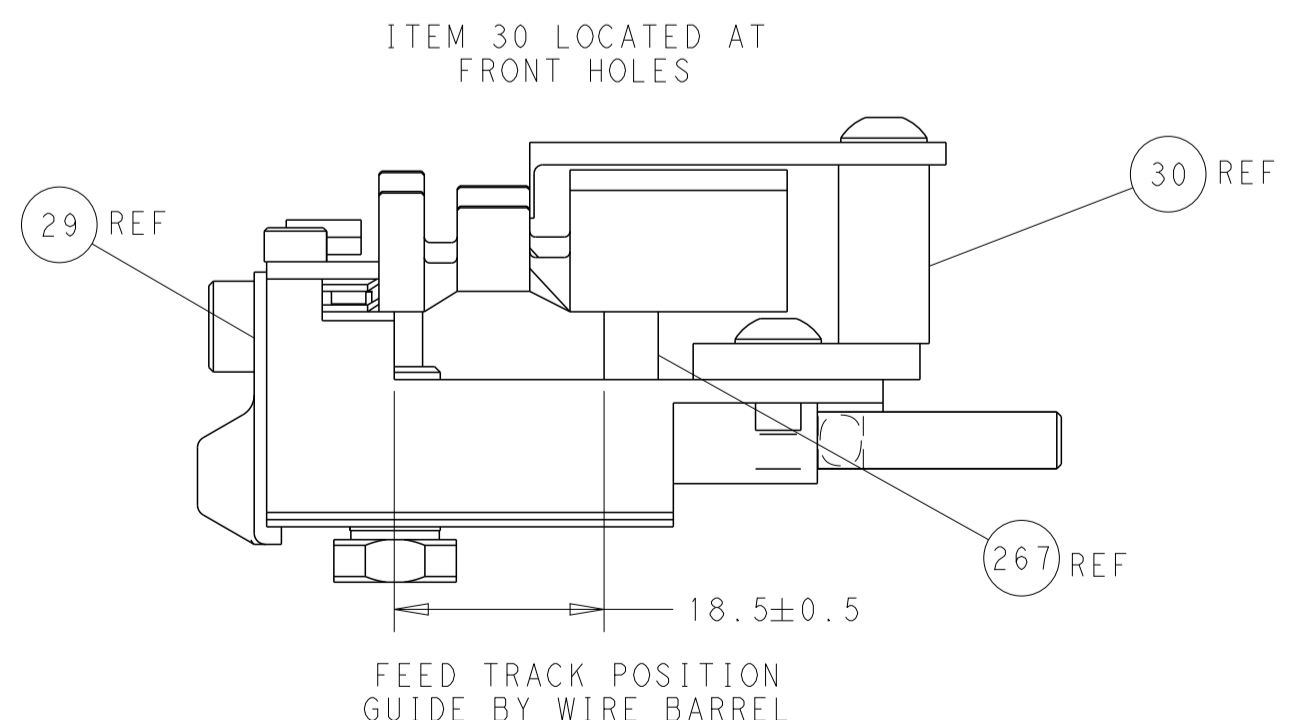
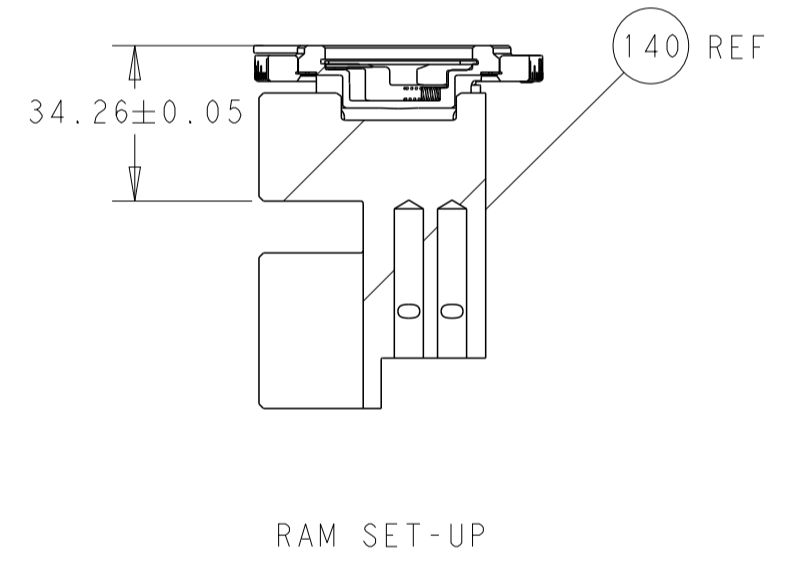
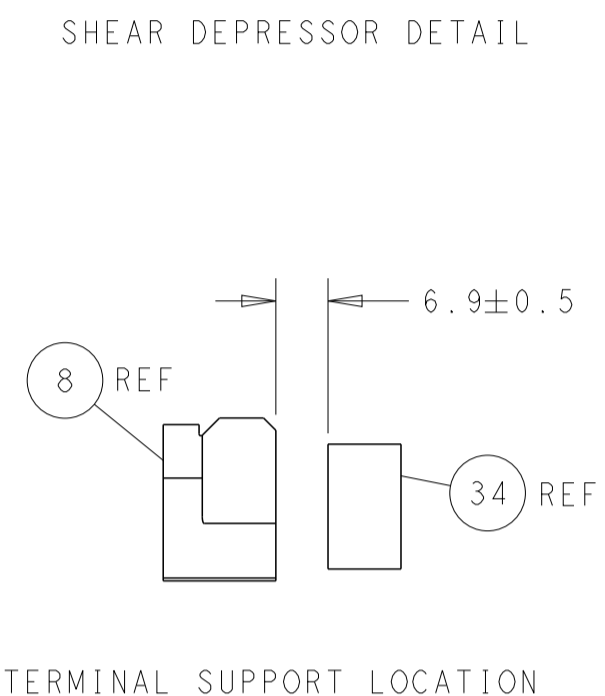
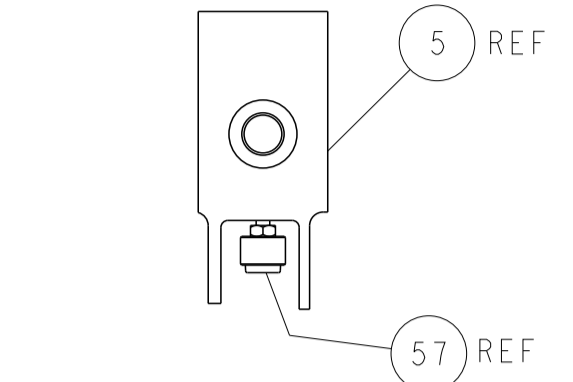
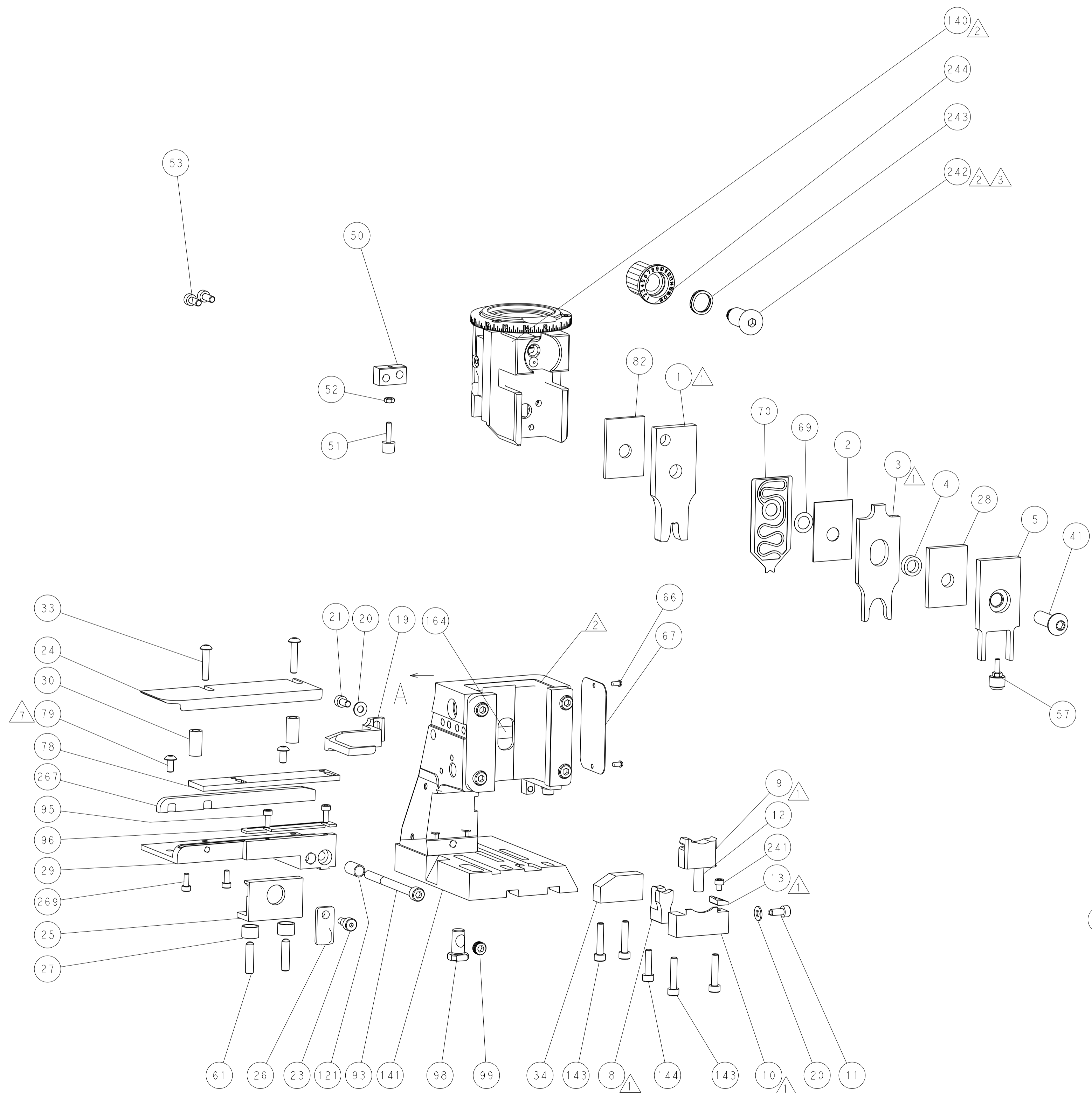
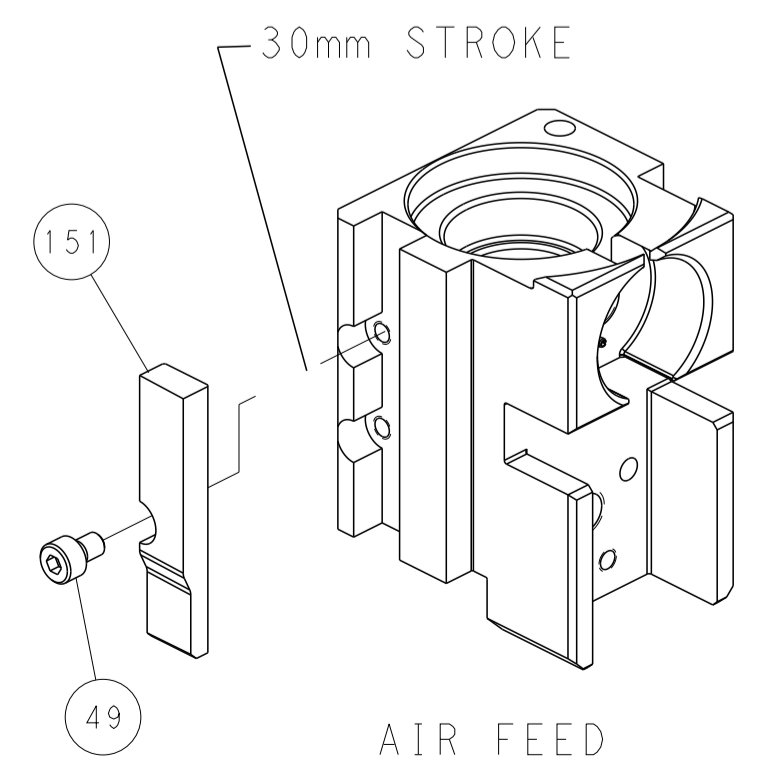
#### PNEUMATIC



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



### CAM POSITION



**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 TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266257 SCALE: 1:2 SHEET: 4 OF: 4 REV: G1	RESTRICTED TO:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	