

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266093-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266093-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266093-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266093-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266093-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266093-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266093-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.05 mm [.120]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: HARTING TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: HARTING CRIMP TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.51-3.99 mm [.138-.157 IN]	Ø1.30-2.79 mm [.051-.110 IN]		
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	HARTING TERMINAL	TE TERMINAL	HARTING TERMINAL
1572650-1	09 06 000 6422	1949753-1	09 06 000 7472
1572650-2	09 06 000 6472	1949753-2	09 06 000 7482
1572650-3	09 06 000 6482		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.56 +/- 0.05 [.061 +/- .002]	6.2
16 AWG OR 1.20mm2	1.47 +/- 0.05 [.058 +/- .002]	7.1
1.00mm2	1.43 +/- 0.05 [.056 +/- .002]	7.6
0.75mm2	1.39 +/- 0.05 [.055 +/- .002]	7.8

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	23DEC2013	BH	GB
		B		ECR-19-010230	29JUN2019	TB	GB
		B1		ECR-19-010841	10JUL2019	LG	TE
		C		ECR-20-006232	29APR2020	TB	RK

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	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	2119082-9	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
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
3	-	-	1	1	-	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
6	-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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
-	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
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	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	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	1752356-1	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	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	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	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	1-356885-4	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	9-1333204-2	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1-240641-9	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	1	1	1	1	5-1633965-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1

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:		DWN G. STAKEM 28OCT2013	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±	FINISH ±	CHK G. BAILEY 28OCT2013		
MATERIAL			APVD T. ELRLN 28OCT2013		
WEIGHT		SCALE		SHEET 1 OF 4	
Customer Accessible Production Drawing		SCALE 1:2		REV C	

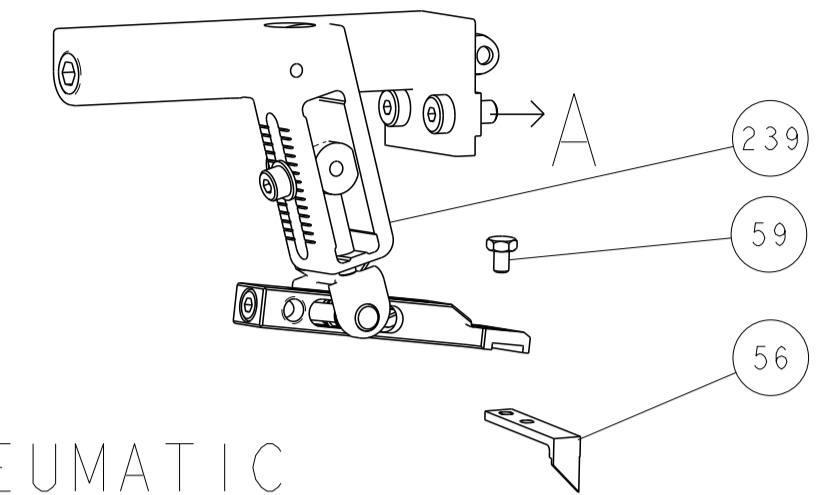
TE Connectivity  
Harrisburg, PA 17105-3608

Ocean Side Feed  
Applicator

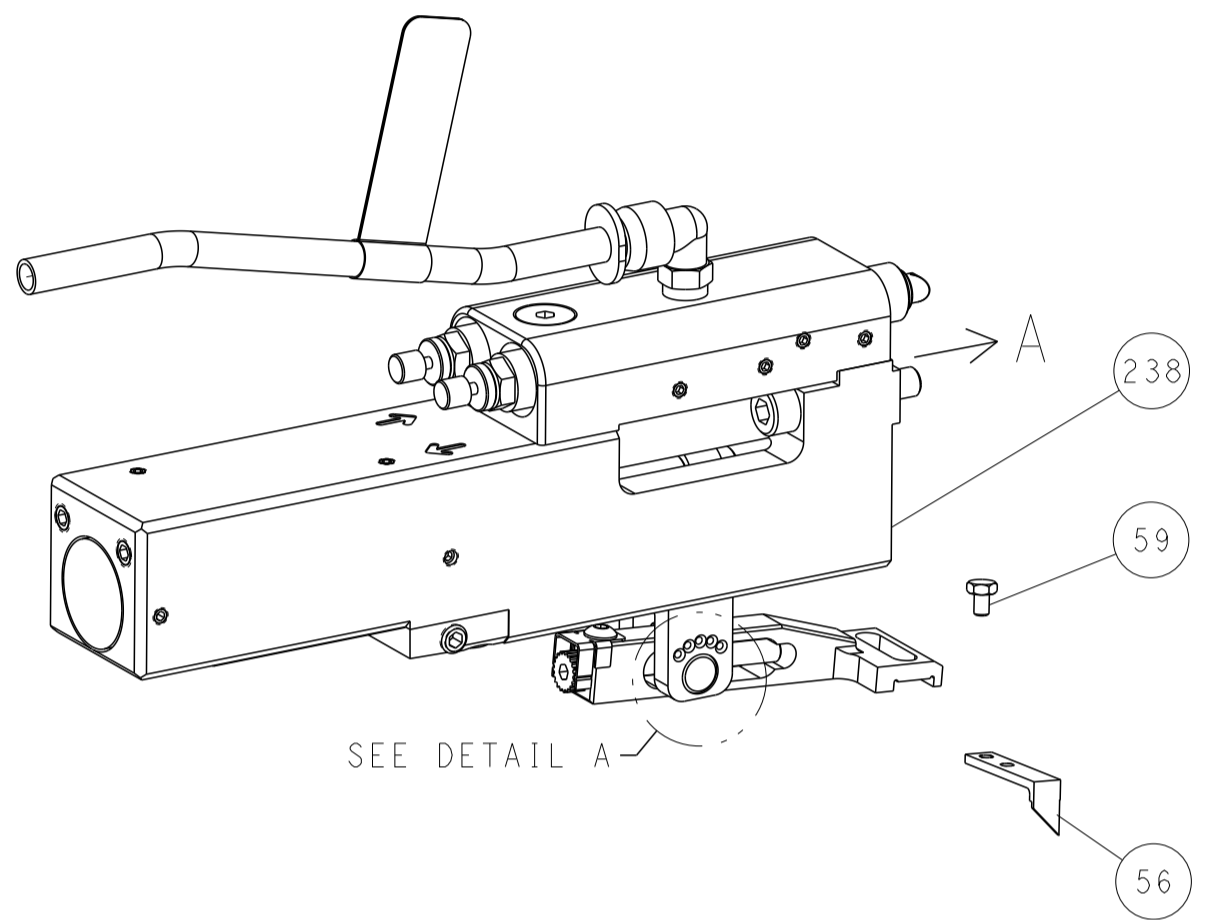
SIZE CAGE CODE DRAWING NO RESTRICTED TO  
A1 00779 C=2266093

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

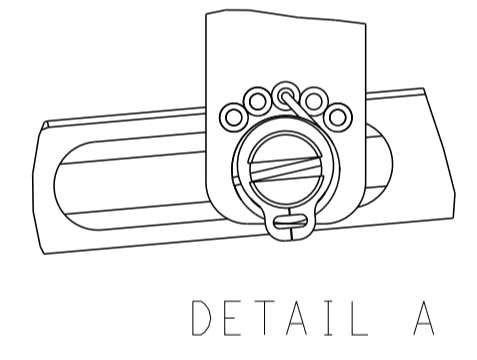
# FEED TYPE MECHANICAL



## PNEUMATIC

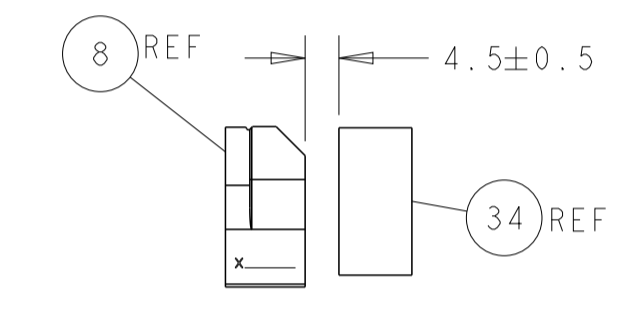
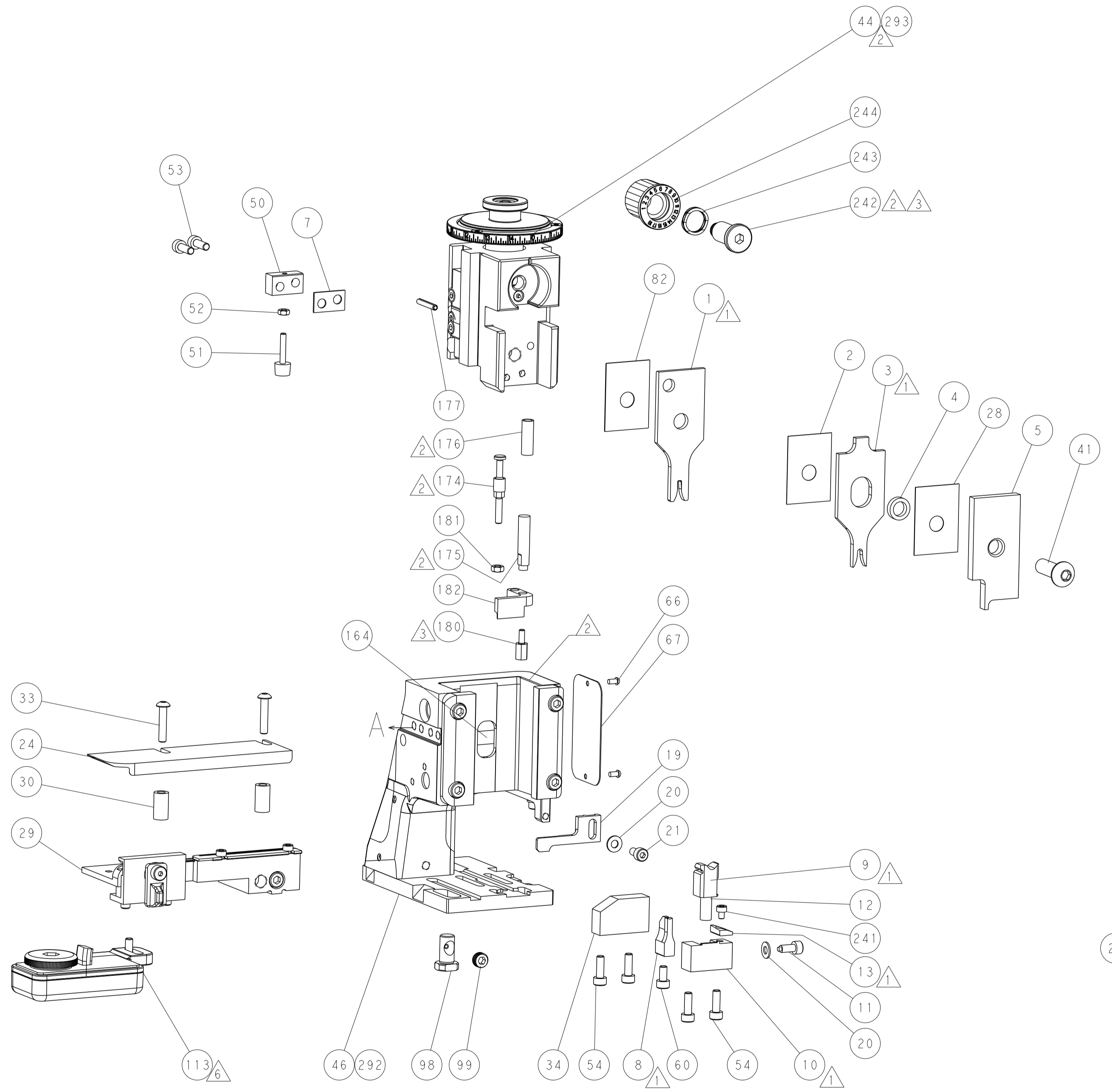
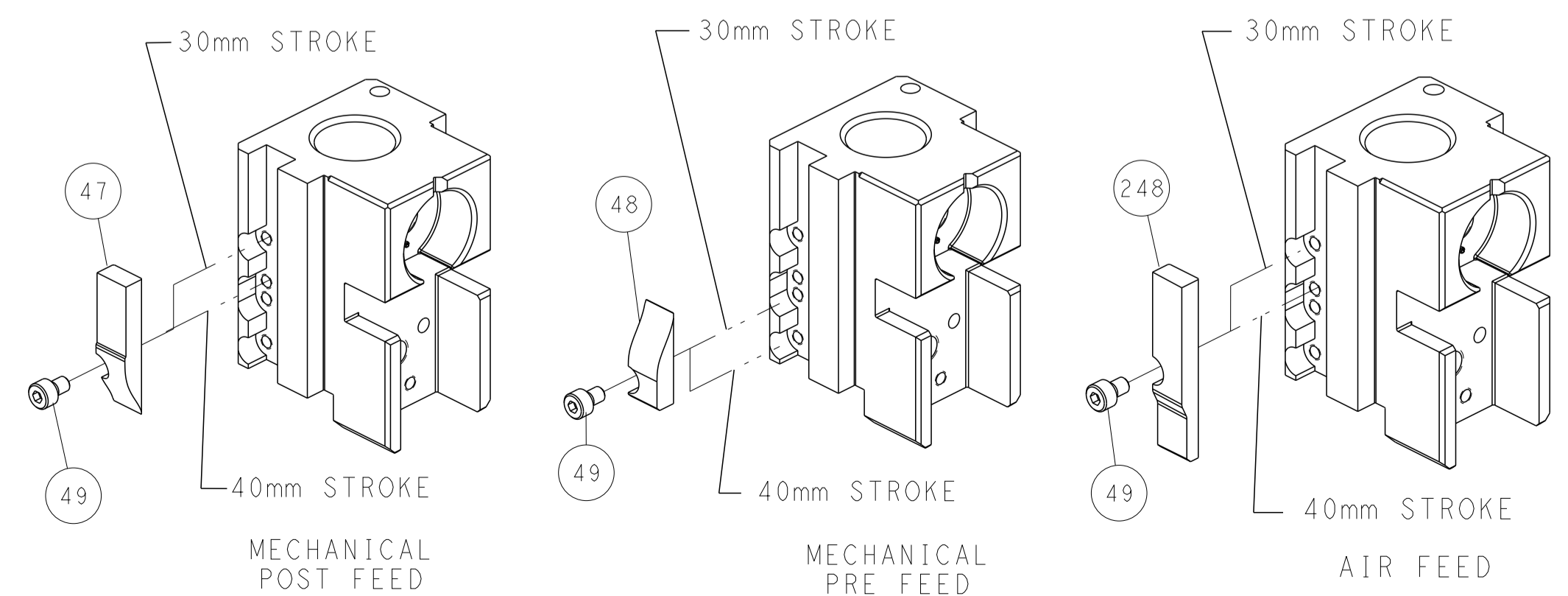


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

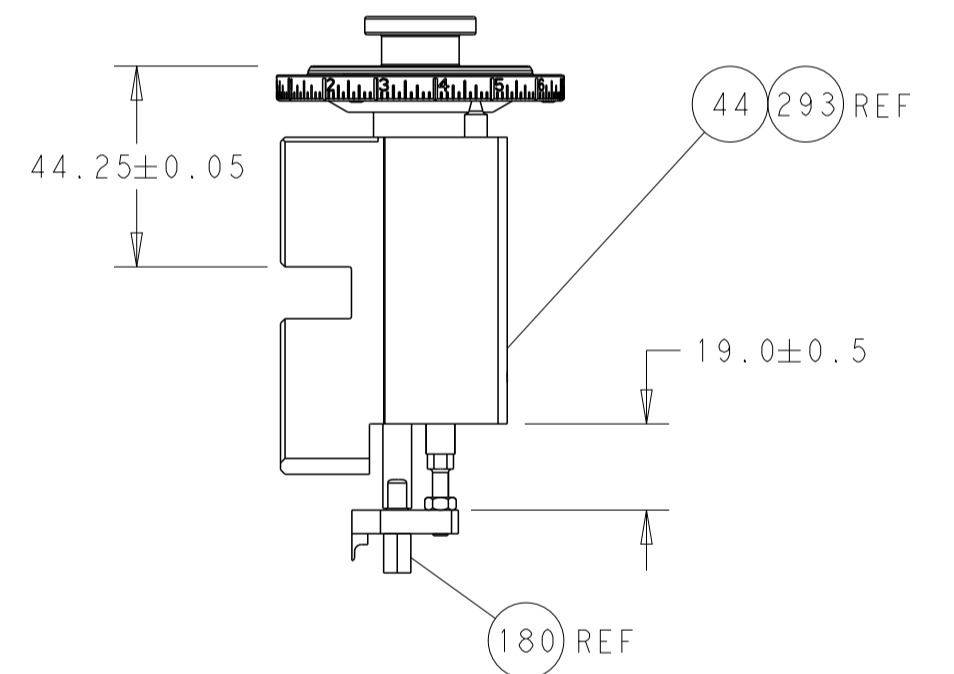


DETAIL A

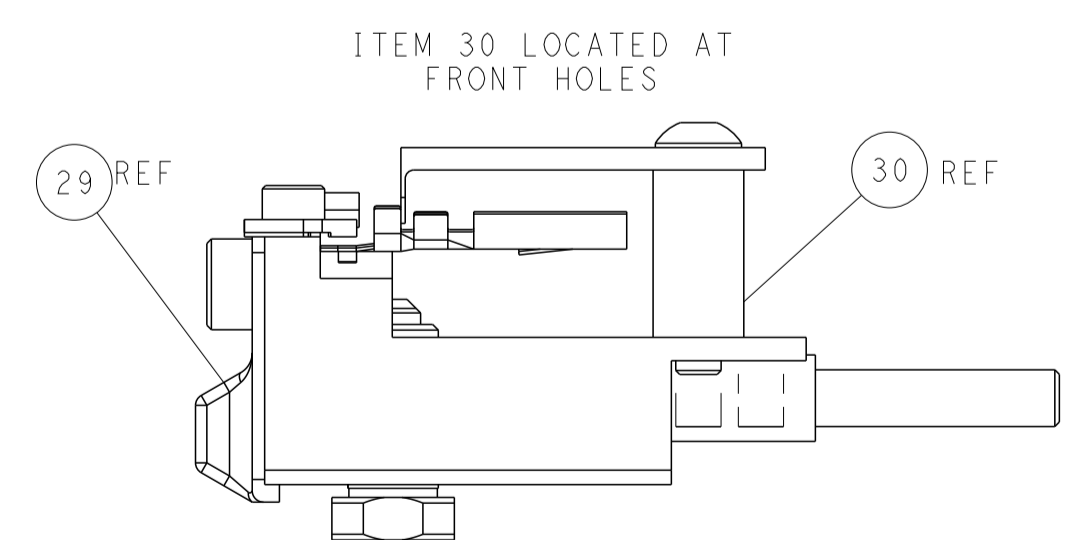
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN STAKEM 28OCT2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
ANGLES	FINISH	MATERIAL		CHK G. BAILEY 28OCT2013		NAME	
				T. ELBIN 28OCT2013		Ocean Side Feed Applicator	
MATERIAL		WEIGHT		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
				A1 00779 C=2266093		Customer Accessible Production Drawing	
		SCALE		SHEET		REV	
		1:2		2 of 4		C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266093-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266093-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266093-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.05 mm [.120]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: HARTING TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: HARTING CRIMP TERMINAL			
WIRE STRIP LENGTH 3.51-3.99 mm [1.38-.157 IN]		INSULATION DIAMETER RANGE Ø1.30-2.79 mm [0.051-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED <sup>6</sup>			
TE TERMINAL	HARTING TERMINAL	TE TERMINAL	HARTING TERMINAL
1572650-1	09 06 000 6422	1949753-1	09 06 000 7472
1572650-2	09 06 000 6472	1949753-2	09 06 000 7482
1572650-3	09 06 000 6482		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.56+/-0.05 [0.061+/-0.002]	6.2
16 AWG OR 1.20mm2	1.47+/-0.05 [0.058+/-0.002]	7.1
1.00mm2	1.43+/-0.05 [0.056+/-0.002]	7.6
0.75mm2	1.39+/-0.05 [0.055+/-0.002]	7.8



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- <sup>3</sup> APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- <sup>4</sup> 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.
- <sup>6</sup> 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	APPD
A	66	-	-	-	-

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPD
-	-	SEE SHEET 1	-	-	-
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
<sup>3</sup>	-	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
<sup>6</sup>	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	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	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1752356-1	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	2844992-2	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
<sup>1</sup>	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
<sup>1</sup>	-	1	2119805-1	SHEAR HOLDER, FRONT	10
<sup>1</sup>	-	1	1803095-6	FLOATING SHEAR, FRONT	9
<sup>1</sup>	1	1	1-1333204-2	ANVIL, COMBINATION	8
-	1	1	1-240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
<sup>1</sup>	1	1	5-1633965-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
<sup>1</sup>	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1

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

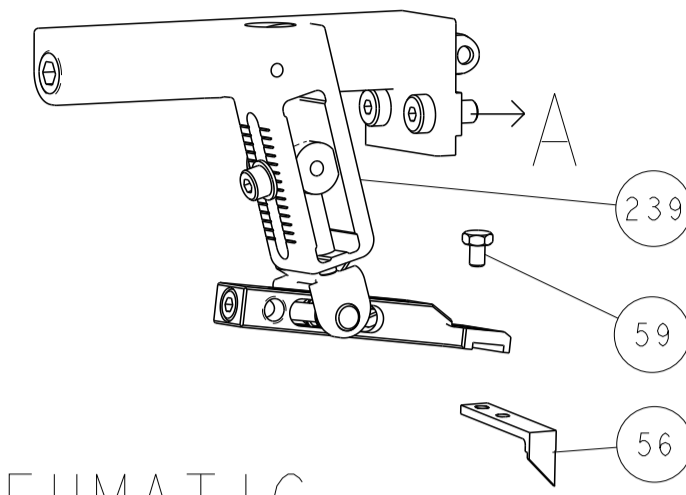
CHK	DATE	DESCRIPTION	ITEM NO
STAKEM	28OCT2013	28OCT2013	
G. BAILEY	28OCT2013		
T. ELBIN	28OCT2013		

NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Ocean Side Feed Applicator	A1	00779	2266093	

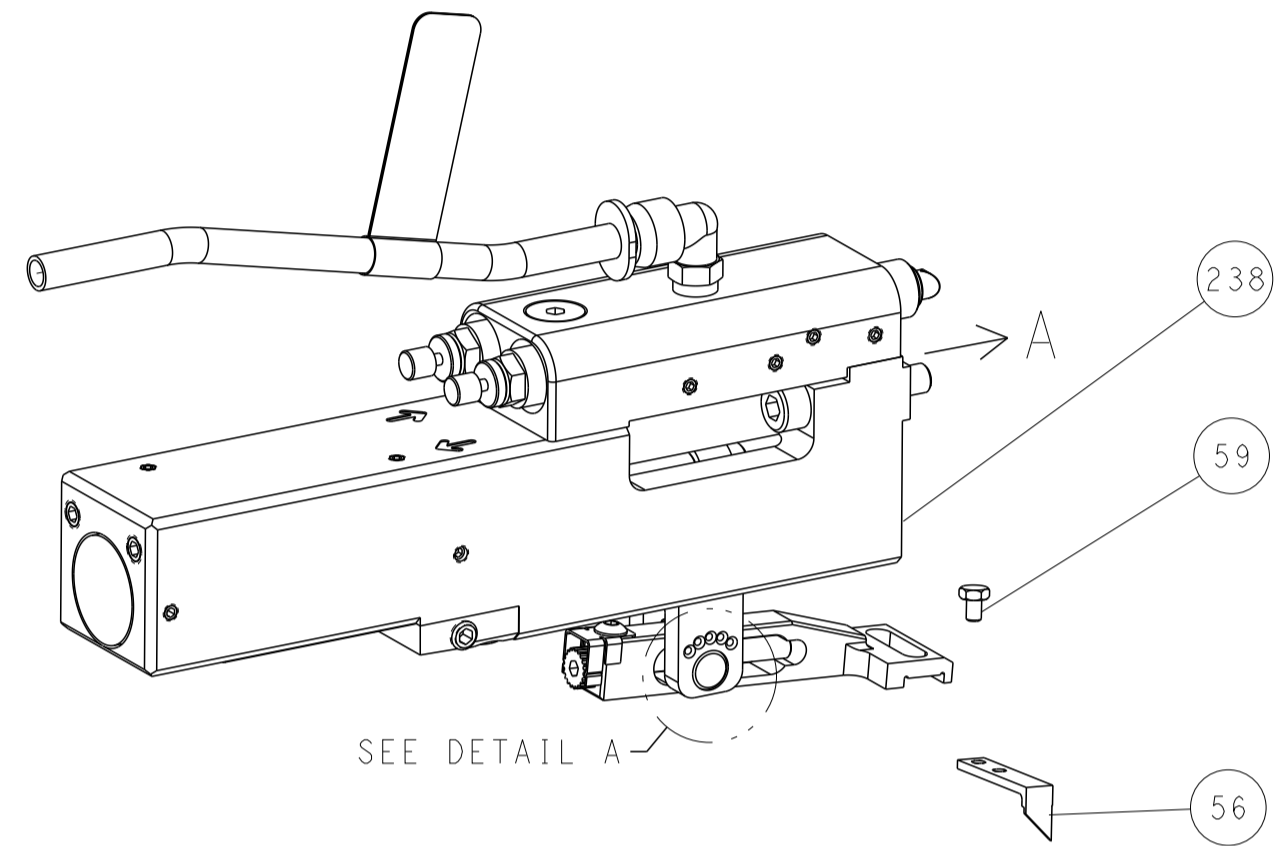
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV C

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

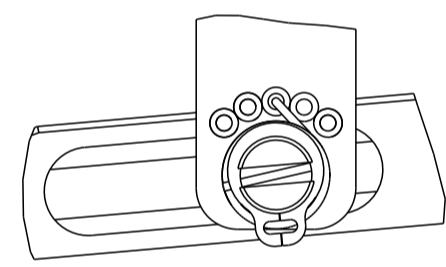
# FEED TYPE MECHANICAL



## PNEUMATIC

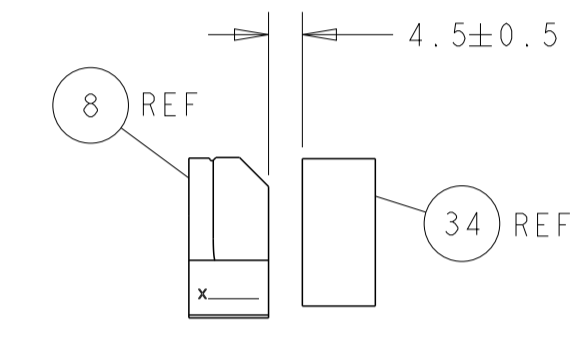
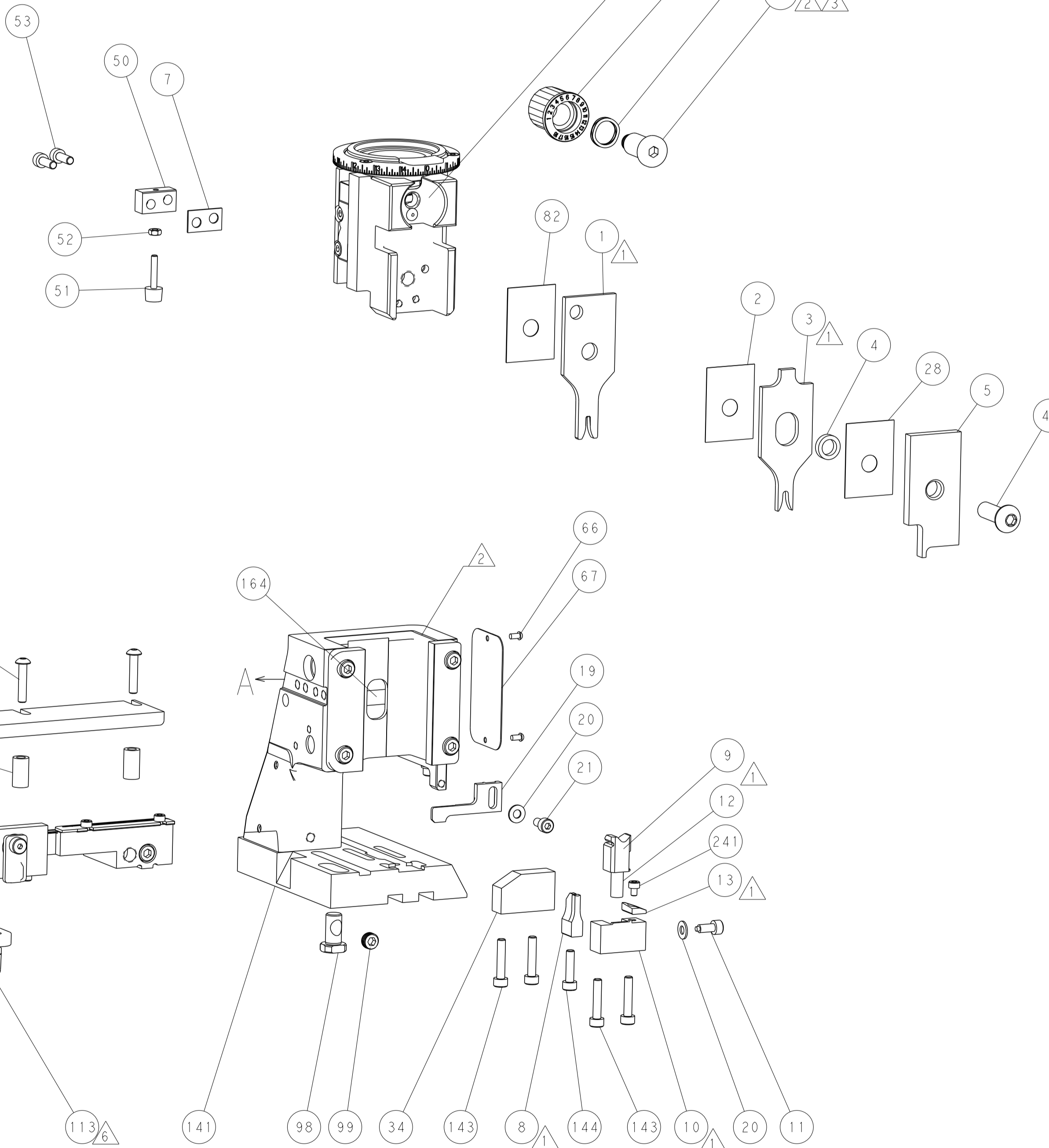
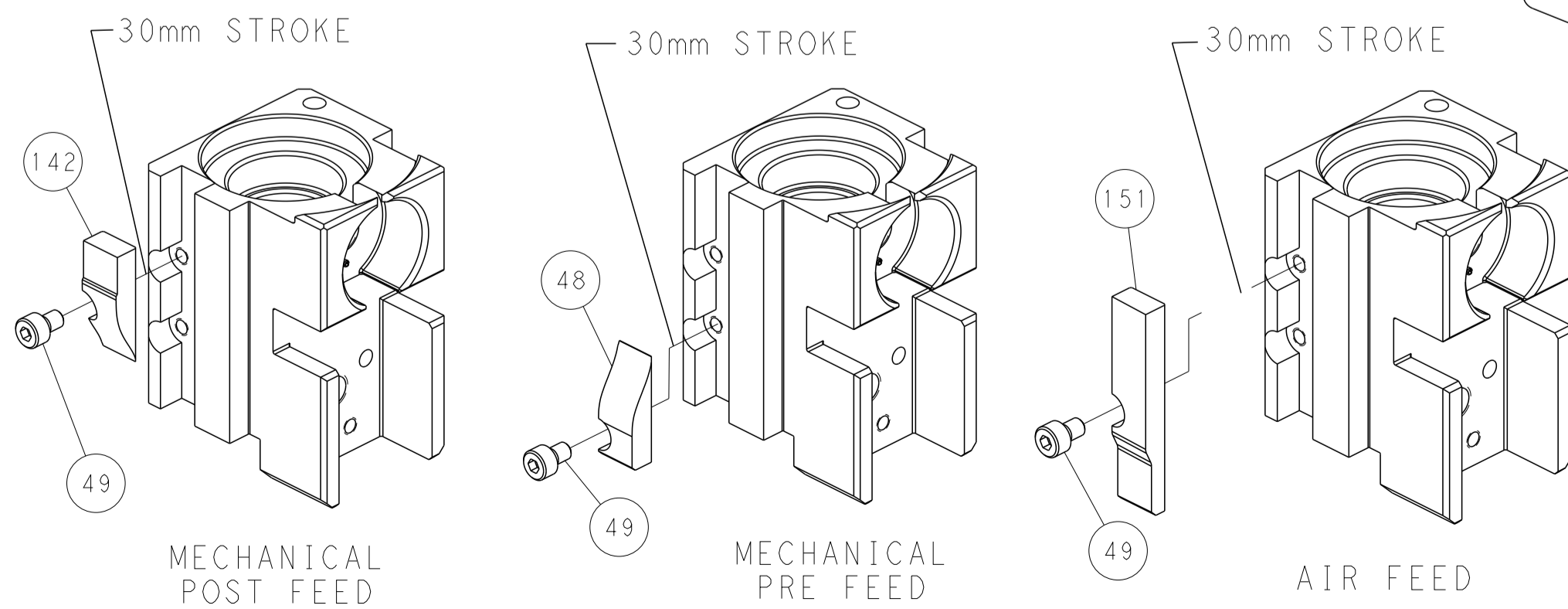


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

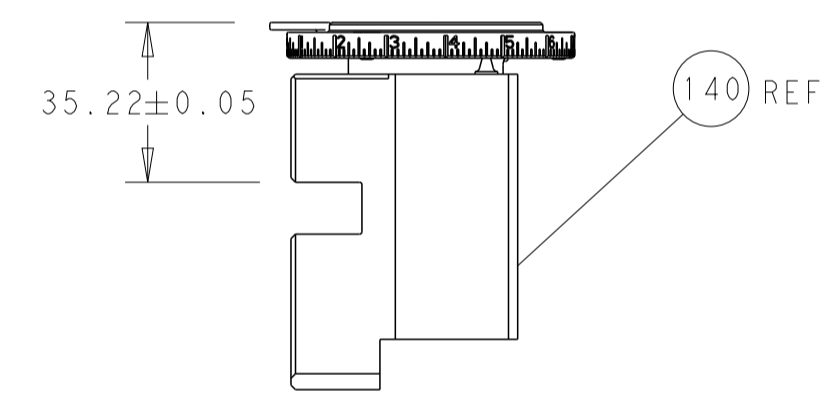


DETAIL A

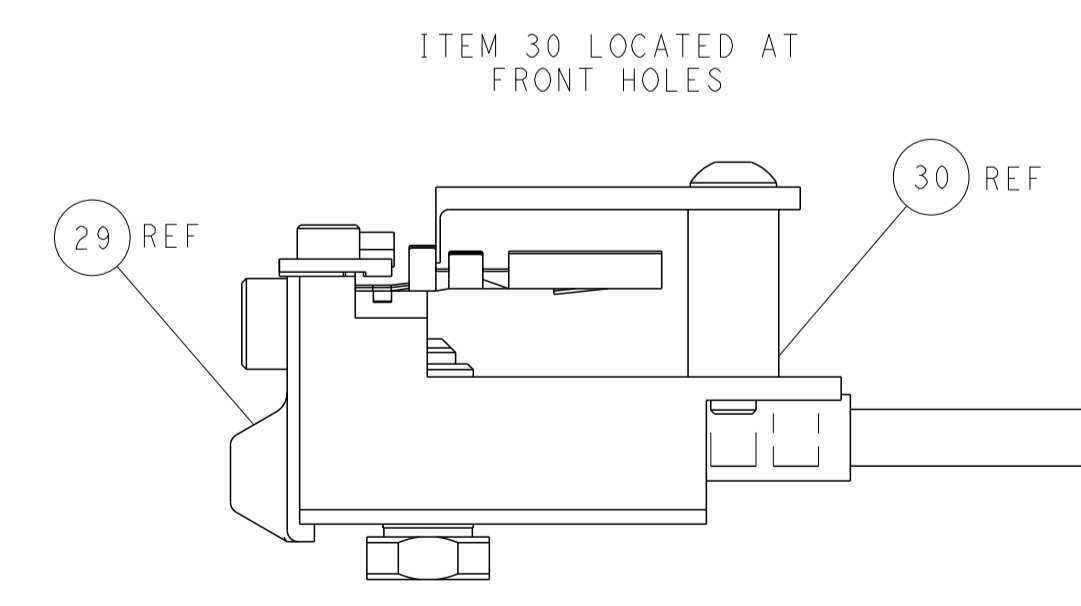
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small> <small>IT IS THE POLICY OF TYCO ELECTRONICS CORPORATION TO CONTINUE TO IMPROVE OUR PRODUCTS AND SERVICE. THEREFORE, THIS DRAWING IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT OBLIGATION TO BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: STAKEM 28OCT2013 CHK: G. BAILEY 28OCT2013 APVD: T. ELBIN 28OCT2013	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266093	RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 4 OF 4 REV: C