

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266503-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266503-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266503-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266503-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266503-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: DIA 2.5mm CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.90-5.60 mm [.193-.220 IN]	Ø1.90-3.00 mm [.075-.118 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18020		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
929964-1	929971-1	929971-8	
1-929964-0	929971-7		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE TODAY			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.35-5.11 mm [.171-.201 IN]	Ø3.05-3.18 mm [.120-.125 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18040		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
929987-1	-	-	-
929987-4	-	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.97+/-0.03 [.078+/- .001]	4.0
2.00mm2	1.82+/-0.03 [.072+/- .001]	5.5
1.00mm2 + 1.00mm2	1.82+/-0.03 [.072+/- .001]	5.5
1.50mm2	1.67+/-0.03 [.066+/- .001]	7.2
0.50mm2 + 1.00mm2	1.67+/-0.03 [.066+/- .001]	7.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.97+/-0.03 [.078+/- .001]	4.0
2.00mm2	1.82+/-0.03 [.072+/- .001]	5.5
1.00mm2 + 1.00mm2	1.82+/-0.03 [.072+/- .001]	5.5
1.50mm2	1.67+/-0.03 [.066+/- .001]	7.2
0.50mm2 + 1.00mm2	1.67+/-0.03 [.066+/- .001]	7.2
1.25mm2	1.60+/-0.03 [.063+/- .001]	8.0

- 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	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-16-016619	23NOV2016	TB	TE
		C		ECR-18-003488	07MAR2018	FL	TE
		D		ECR-21-121710	22NOV2021	JWC	TE
		D1		ECR-22-150952	30AUG2022	JWC	JH

-	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	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	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	3-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-0	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	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	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1-1333206-2	ANVIL, COMBINATION .100	8	
-	1	1	1	1	5-240641-0	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-1803018-1	CRIMPER, INSULATION O	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	456407-6	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:				
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	D1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266503-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266503-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266503-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS
408-35042

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TERMINAL APPLICATION SPECIFICATION	114-18020	-	-
	(B)114-18040	-	-
TERMINALS APPLIED			
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	-	-	-
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1.00mm2 + 1.00mm2	1.82+/-0.03 [.072+/-0.001]	5.5
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- 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)

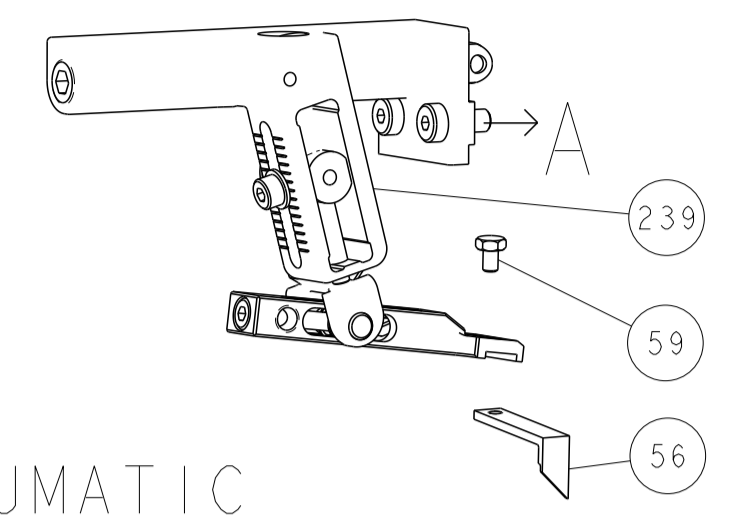
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	2119740-1	TAG IDENTIFICATION	67
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-	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
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-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
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-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1-1333206-2	ANVIL, COMBINATION .100	8
-	1	1	5-240641-0	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	3-1803018-1	CRIMPER, INSULATION O	3
-	-	-	-	-	2
1	1	1	456407-6	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

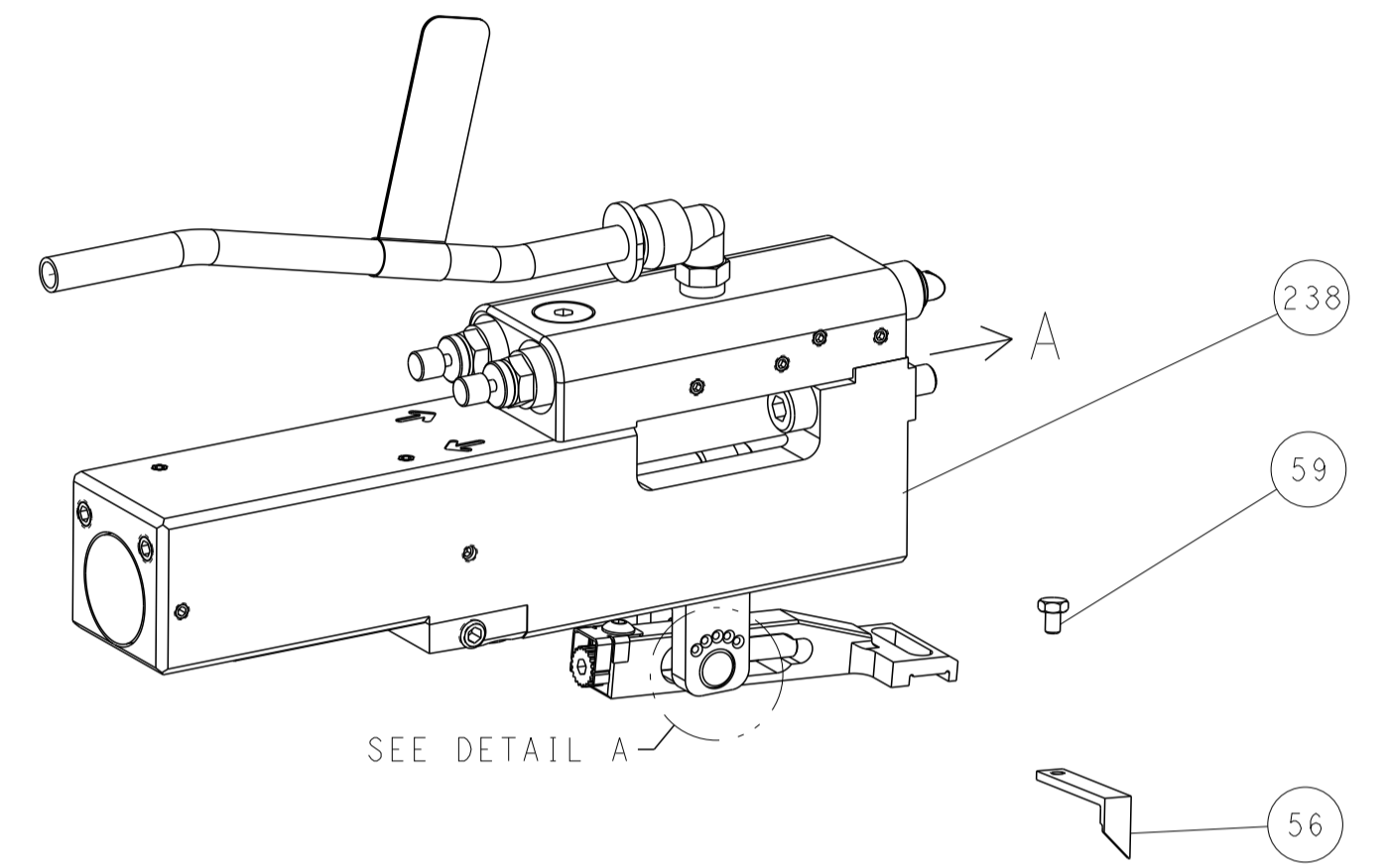
<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED IN THE ORDER. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. PERMISSION TO REPRODUCE THIS DRAWING IN WHOLE OR IN PART IS GRANTED BY TYCO ELECTRONICS CORPORATION TO THE USER OF THIS DRAWING FOR THE USER'S INTERNAL USE ONLY. ALL RIGHTS RESERVED.</small>		DWN R.O. WILSON CHK K.J. STAKEM APVD T.L. ELBIN	03OCT2014 08OCT2014 08OCT2014 08OCT2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		NAME Ocean Side Feed Applicator
MATERIAL:		WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266503	RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:2	SHEET: 3 OF 4	REV: D1

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

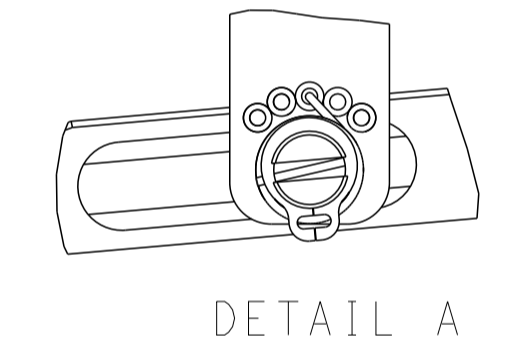
FEED TYPE MECHANICAL



PNEUMATIC

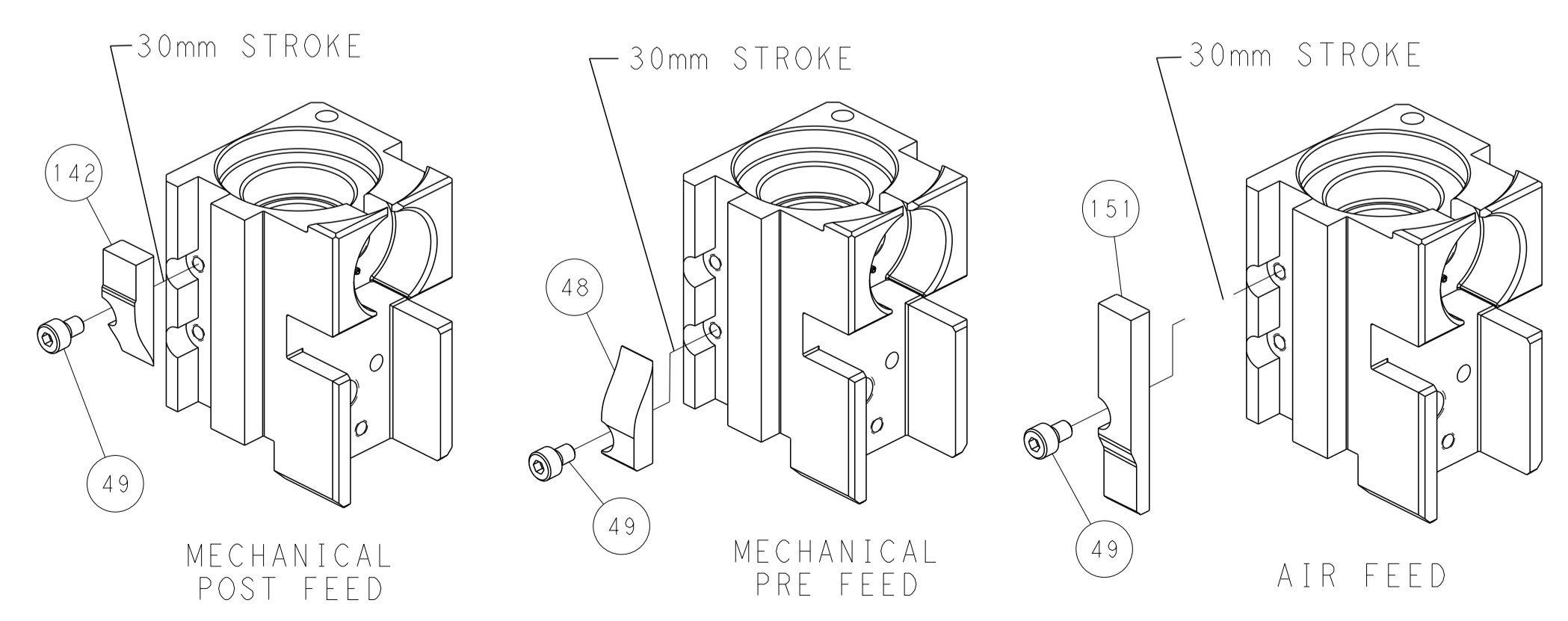


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

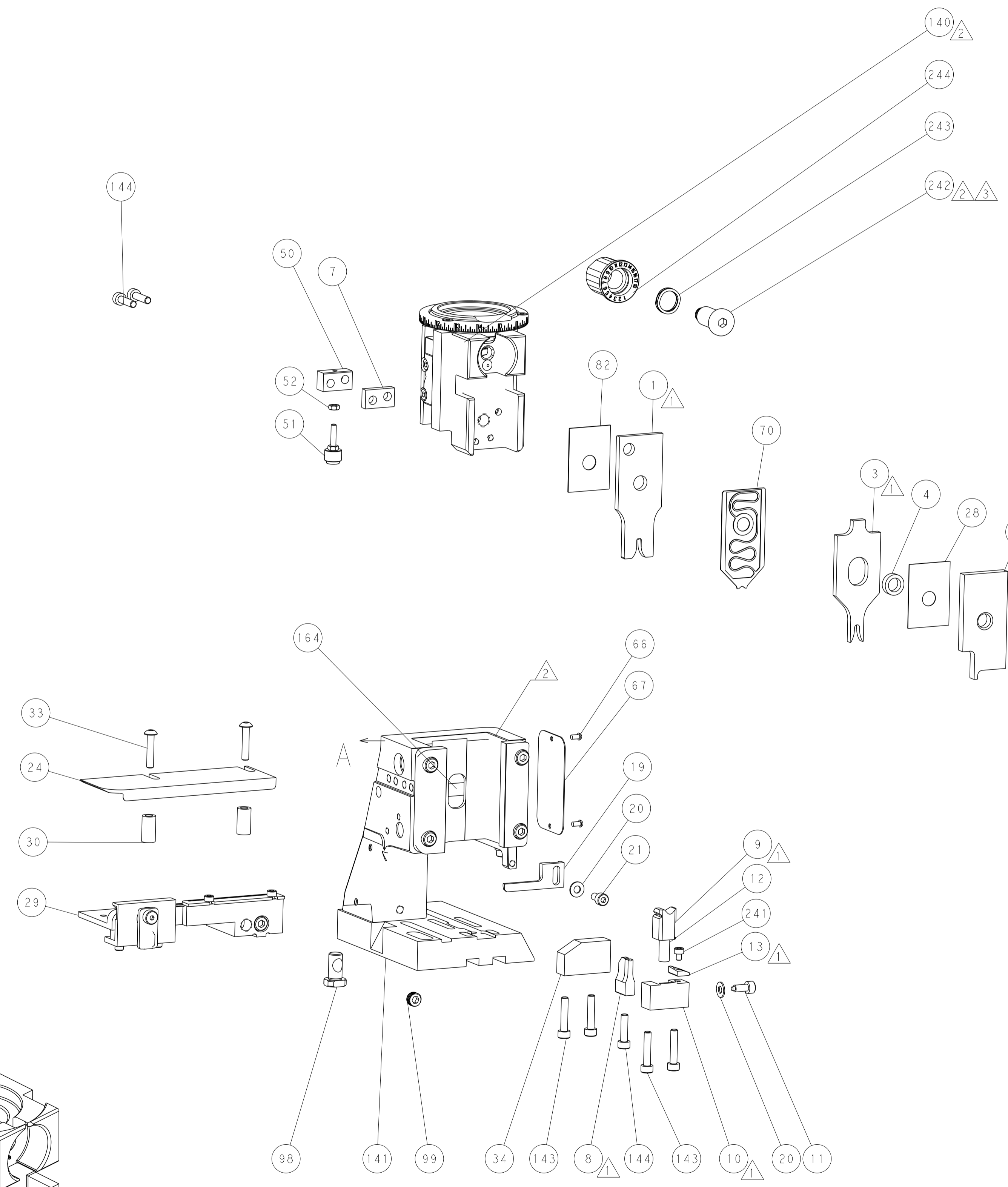
CAM POSITIONS



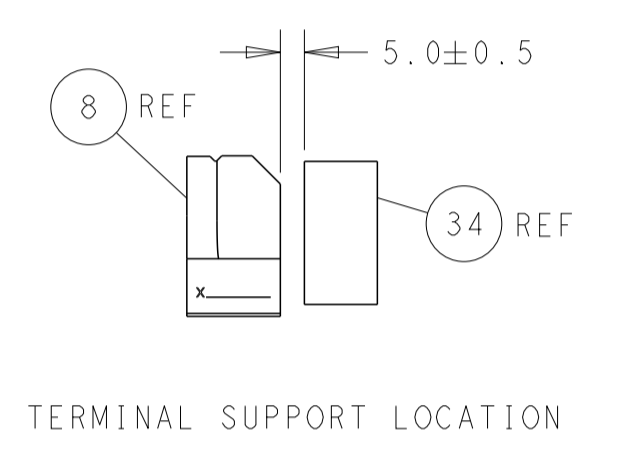
MECHANICAL POST FEED

MECHANICAL PRE FEED

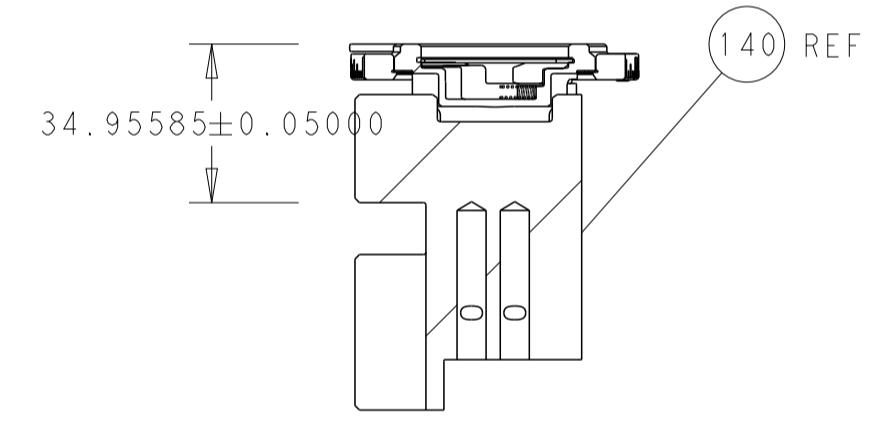
AIR FEED



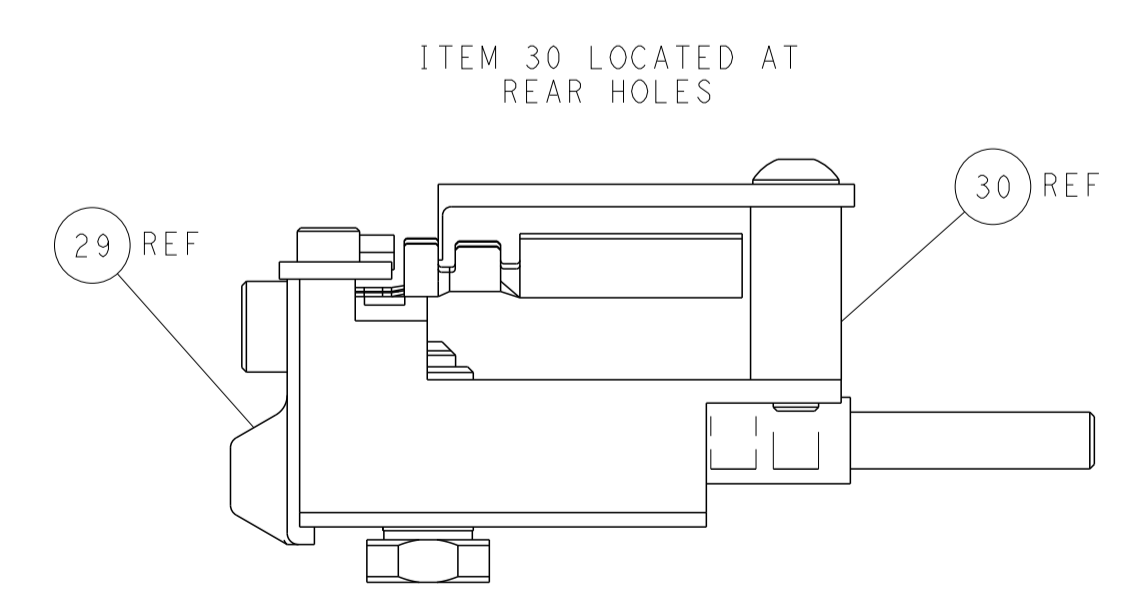
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN R.O. WILSON 03OCT2014 CHK K.J. STAKEM 08OCT2014 APVD T.L. ELBIN 08OCT2014 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2266503 RESTRICTED TO SHEET 4 OF 4 REV D1	
MATERIAL:				Customer Accessible Production Drawing			