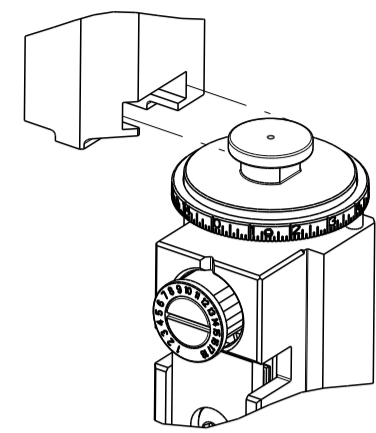


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266323-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266323-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266323-1	K	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266323-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266323-7	G	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

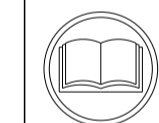


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.58 mm [.062]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, RECEPTACLE, CRIMP SNAP-IN 20-24 AWG			
WIRE STRIP LENGTH 3.18-3.96 mm [.125-.156 IN]		INSULATION DIAMETER RANGE Ø 0.64-1.52 mm [.025-.060 IN]	
TERMINAL APPLICATION SPECIFICATION	114-25038	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
104479-2	104479-4	104479-9	
104479-3	104479-8	1-104479-0	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89+/-0.05 [.035+/- .002]	3.0
22 AWG	0.79+/-0.05 [.031+/- .002]	4.3
24 AWG	0.69+/-0.05 [.027+/- .002]	5.3



- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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
		G		ECR-19-003478	05MAR2019	FZ	YY
		H		ECR-20-004201	19MAR2020	TB	GB
		J		ECR-22-149857	18AUG2022	ROY	TLE
		K		ECR-23-168507	07MAR2023	JWC	JH

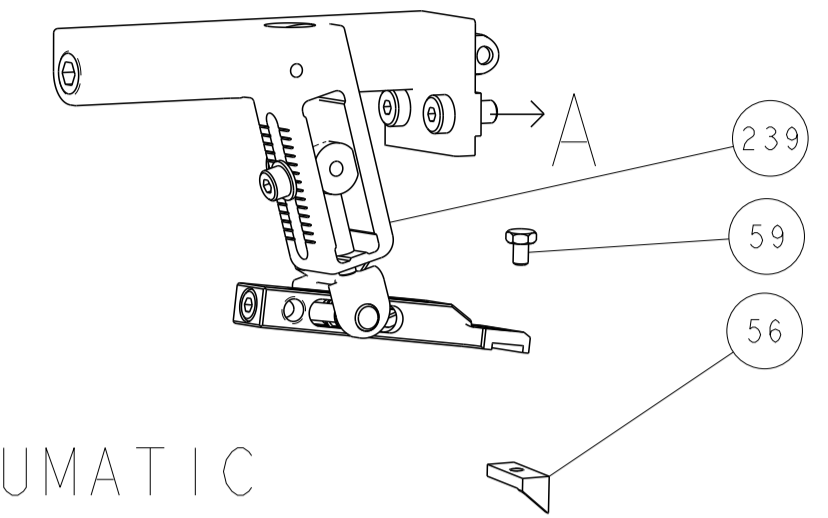
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-5	CAM, SWAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	2	2	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	1	1	1	1	356885-4	STOP, SHEAR	237	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121	
5	-	1	1	1	2119955-5	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	690438-1	FRONT STRIP GUIDE	96	
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-5	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	
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	1338683-1	FEED PAWL	56	
-	6	6	6	6	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	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	2280441-1	INSERT, SHEAR	43	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	33	
-	1	1	1	1	2305692-9	PLATE, REAR STRIP GUIDE	29	
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1	1	3-189124-6	GUIDE, FRONT STRIP	24	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	3	3	3	3	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-3	STRIPPER, SIDE FEED	19	
-	1	1	1	1	3-1463053-0	HOLDER, TERMINAL	18	
-	1	1	1	1	2-690463-3	FLOATING SHEAR, REAR	17	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1	1	1	1-690691-0	PLATE, REAR SHEAR	15	
-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14	
1	-	1	1	1	2119806-1	INSERT, SHEAR	13	
-	2	2	2	2	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	1	2	2	1	1	3-1333201-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	1	1	1	1	690468-7	DEPRESSOR SHEAR, REAR	6	
-	1	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	1633966-6	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
1	1	2	2	1	1	2-1803125-5	CRIMPER, WIRE	1

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

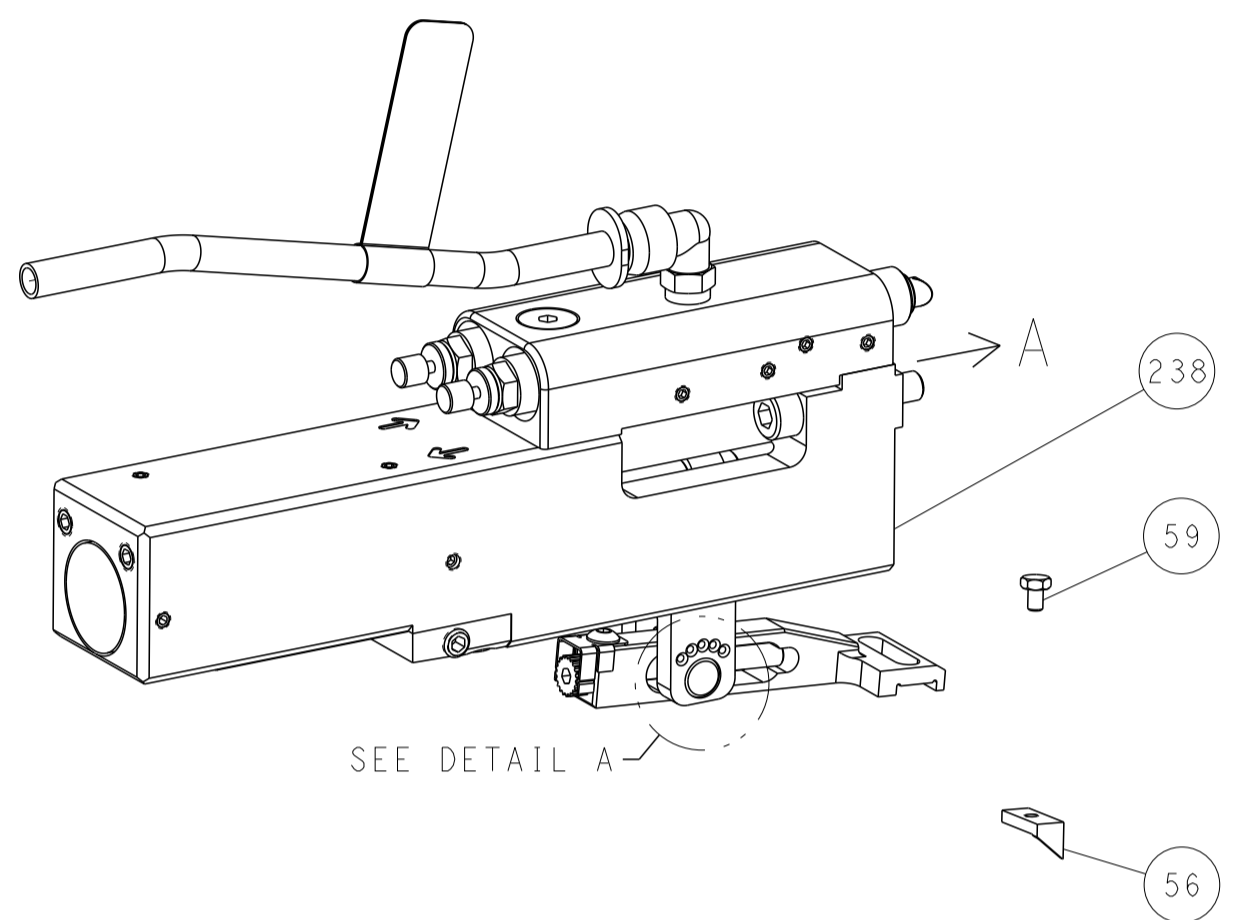
THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF STE CONNECTIVITY CORPORATION. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. PERMISSION TO REPRODUCE THIS DRAWING FOR THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.	CHG <b>BOB HIGMAN</b> 10JUN2014 <b>G. BAILEY</b> 10JUN2014 APVD <b>D. STOUGH</b> 10JUN2014 PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO <b>A1</b> 00779 C=2266323 RESTRICTED TO Customer Accessible Production Drawing	<b>STE</b> TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator
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LOC	DIST	REVISIONS					
A	66	P	LTH	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

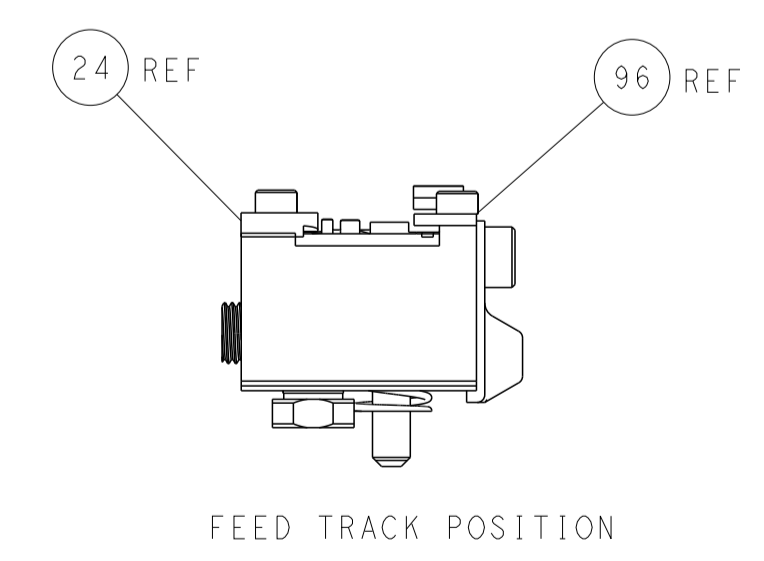
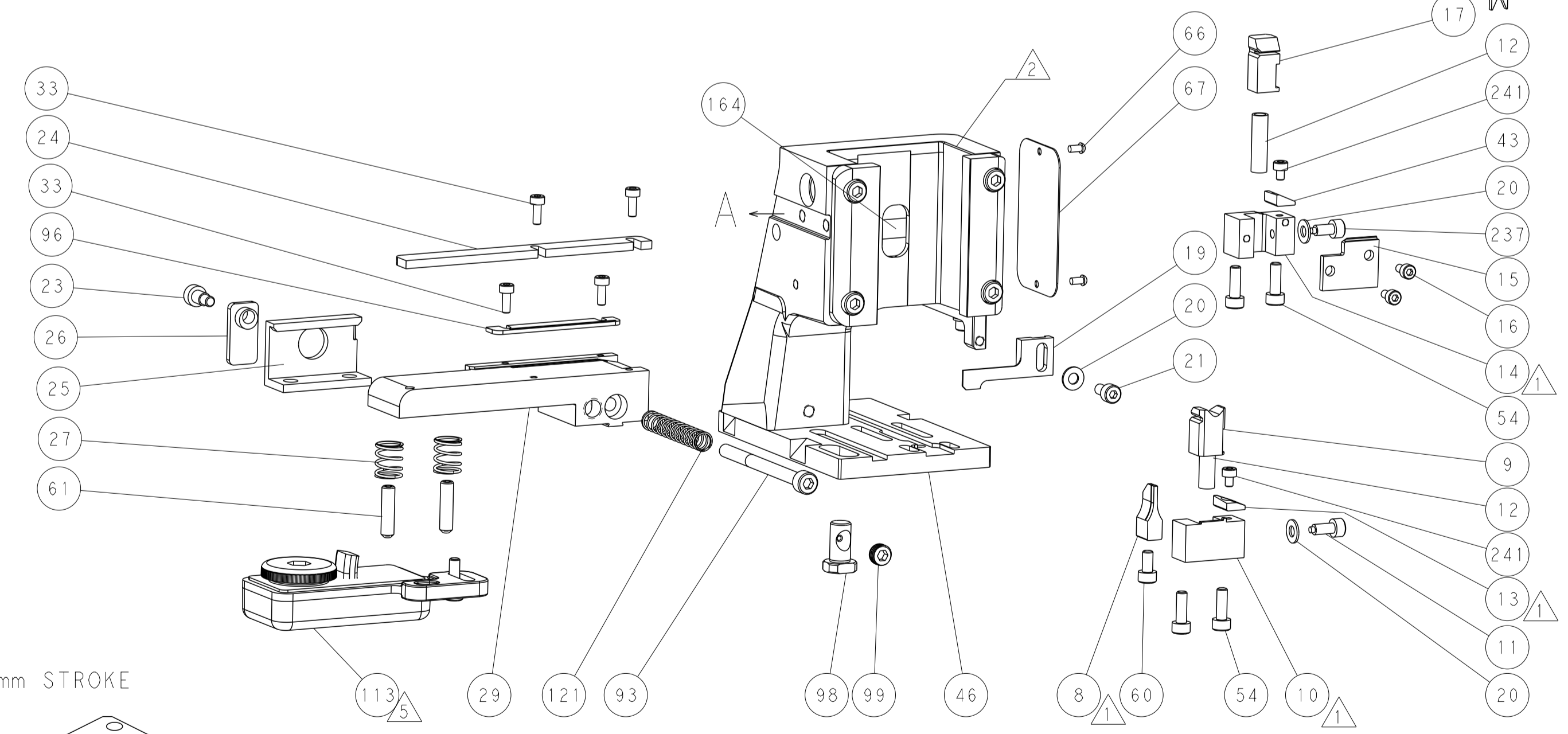
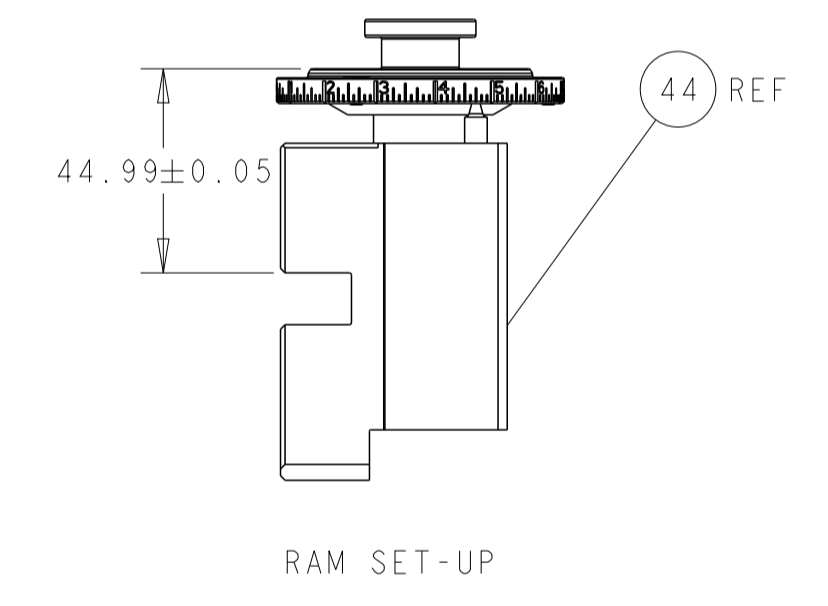
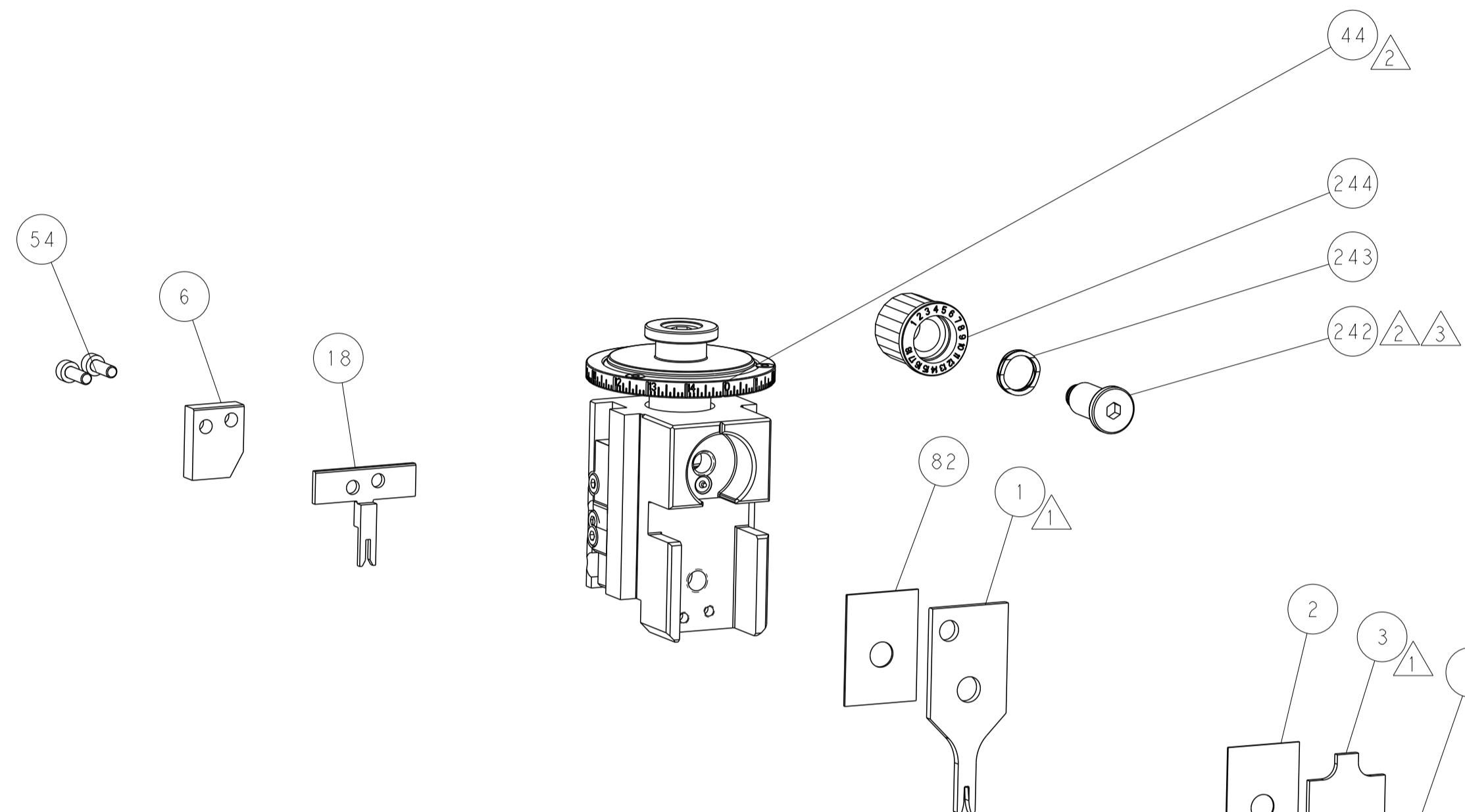
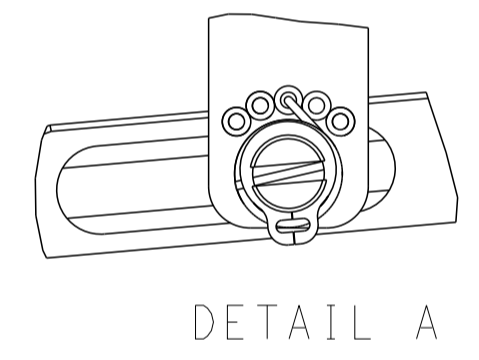
# FEED TYPE MECHANICAL



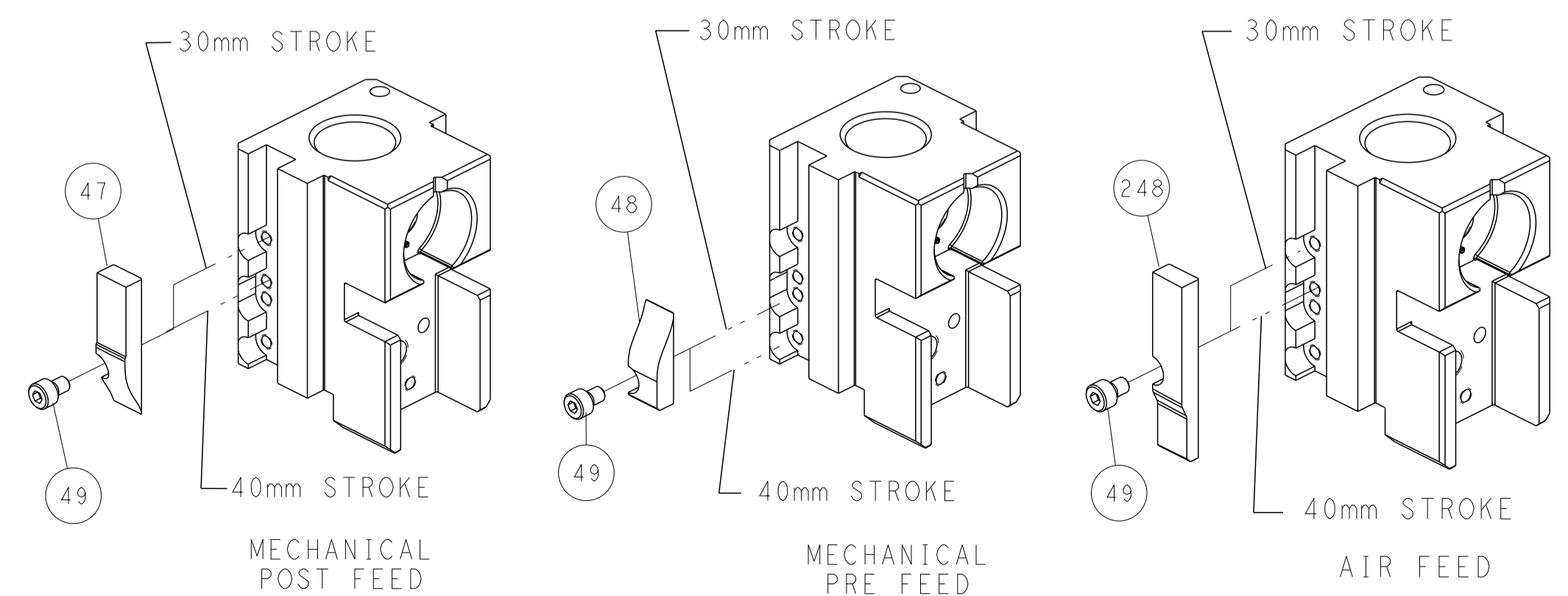
## PNEUMATIC



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



## CAM POSITIONS

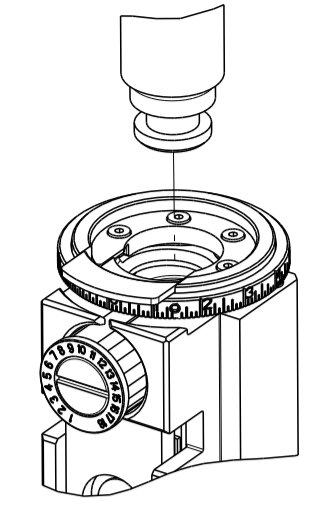


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: BOB HIGMAN 10JUN2014 CHK: G. BAILEY 10JUN2014 APVD: D. STOUGH 10JUN2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266323	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: K	RESTRICTED TO: -	Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266323-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266323-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266323-7	G	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.58 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA:		TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: CONTACT, RECEPTACLE, CRIMP SNAP-IN 20-24 AWG			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.18-3.96 mm [1.25-.156 IN]		Ø 0.64-1.52 mm [1.025-.060 IN]	
TERMINAL APPLICATION SPECIFICATION		114-25038	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
104479-2	104479-4	104479-9	
104479-3	104479-8	1-104479-0	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89+/-0.05 [1.035+/-0.002]	3.0
22 AWG	0.79+/-0.05 [1.031+/-0.002]	4.3
24 AWG	0.69+/-0.05 [1.027+/-0.002]	5.3

- 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.
- 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.

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

-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	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
-	1	1	356885-4	STOP, SHEAR	237
-	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2119955-5	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	690438-1	FRONT STRIP GUIDE	96
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-1	FEED PAWL	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	2280441-1	INSERT, SHEAR	43
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	33
-	1	1	2305692-9	PLATE, REAR STRIP GUIDE	29
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	3-189124-6	GUIDE, FRONT STRIP	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
-	3	3	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	3-1463053-0	HOLDER, TERMINAL	18
-	1	1	2-690463-3	FLOATING SHEAR, REAR	17
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1-690691-0	PLATE, REAR SHEAR	15
-	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	3-1333201-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	1	1	690468-7	DEPRESSOR SHEAR, REAR	6
-	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1633966-6	CRIMPER, INSULATION O	3
-	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	2-1803125-5	CRIMPER, WIRE	1

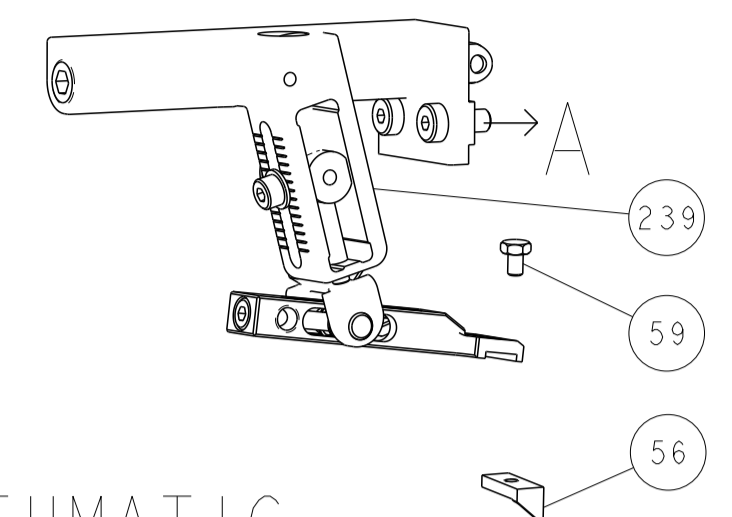
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

APVD	BOB HIGMAN	10JUN2014	OWN	TE Connectivity
CHK	G. BAILEY	10JUN2014	NAME	Harrisburg, PA 17105-3608
APVD	D. STOUGH	10JUN2014	PRODUCT SPEC	Ocean Side Feed Applicator
APVD			APPLICATION SPEC	
SIZE	A1	00779	CAGE CODE	2266323
SCALE	1:2	SHEET	3	OF 4
REV	K			

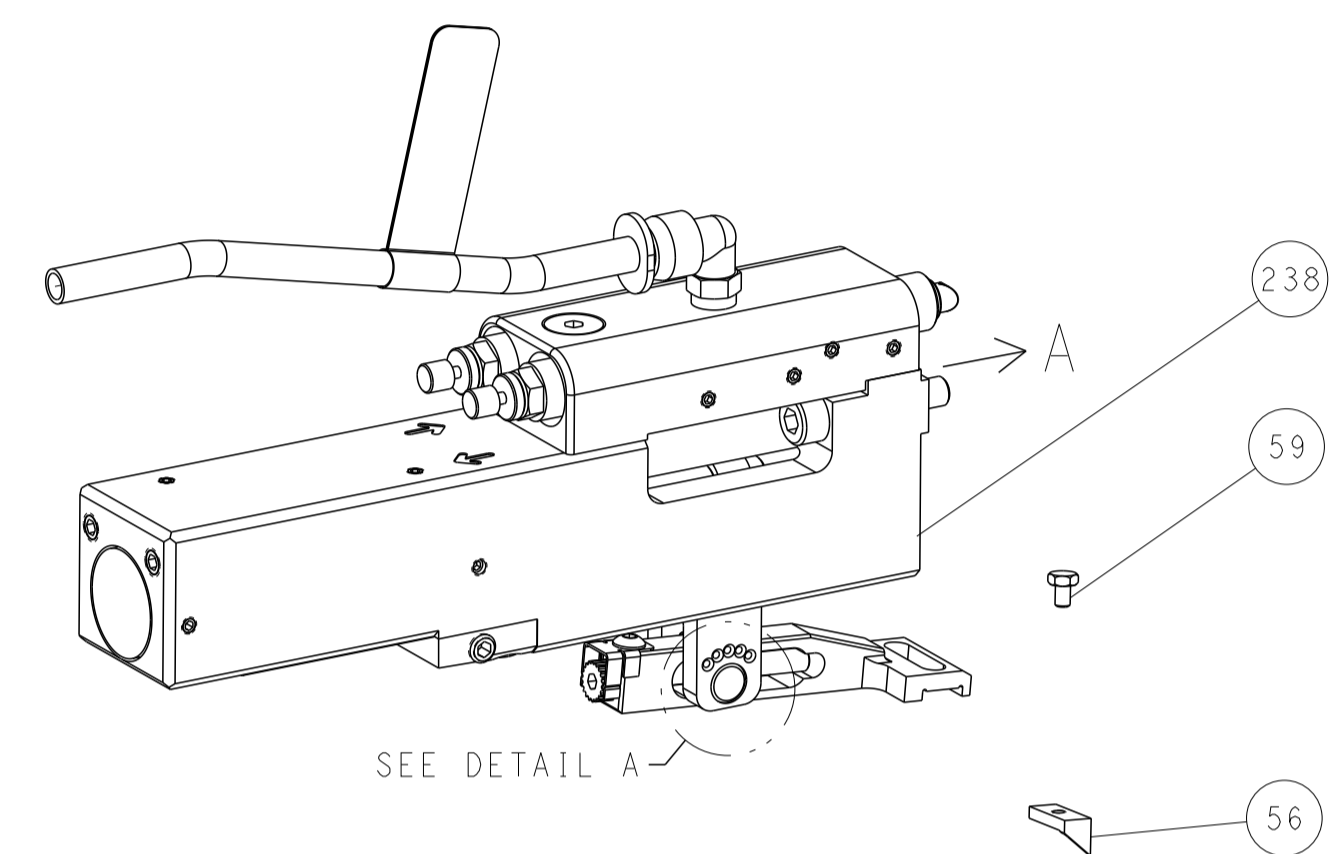
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

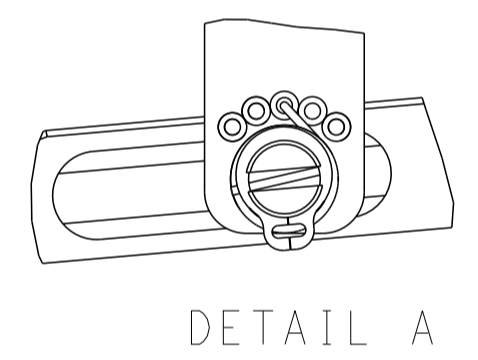
# FEED TYPE MECHANICAL



## PNEUMATIC

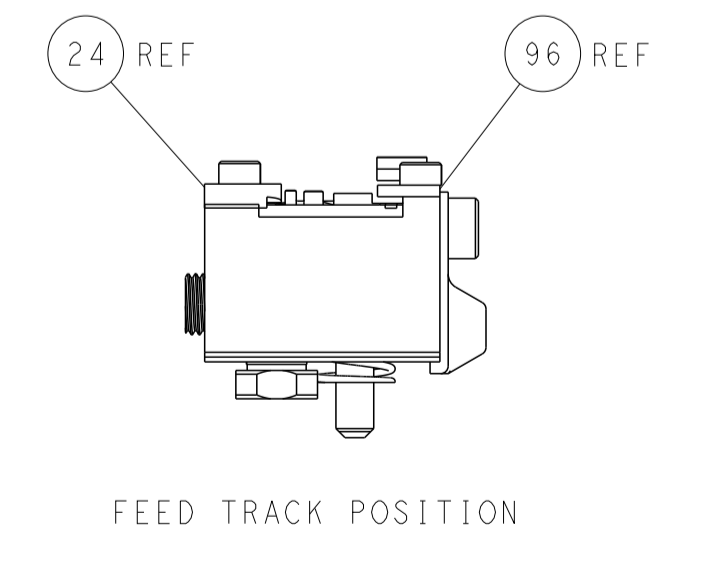
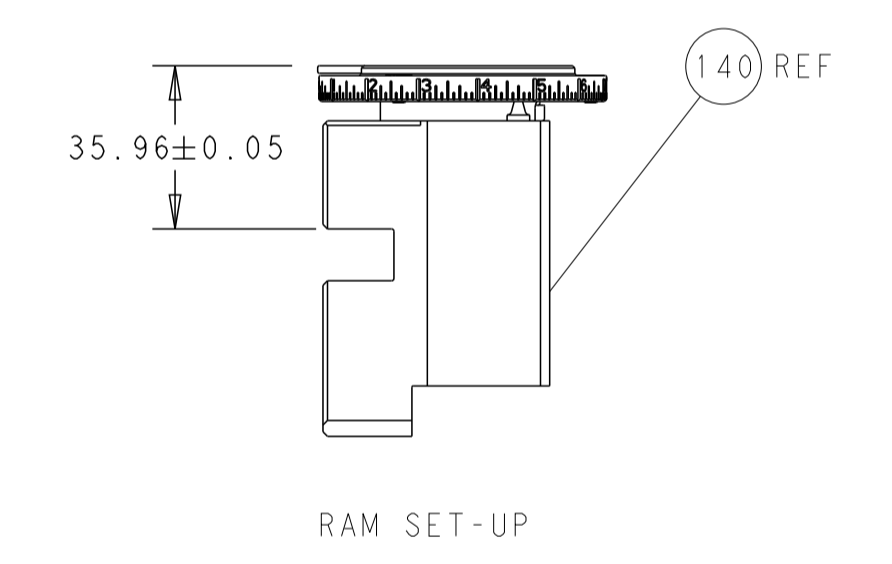
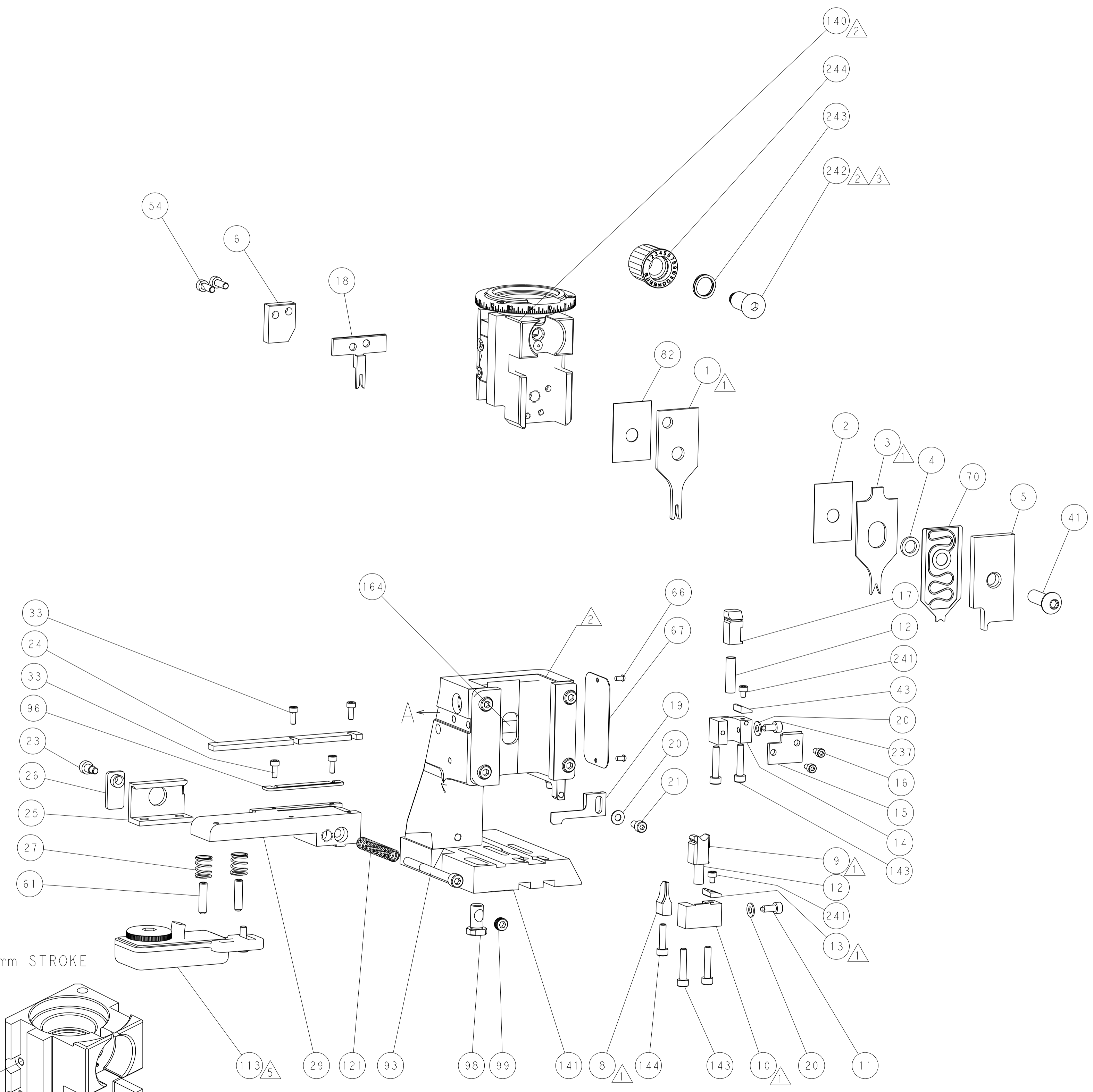
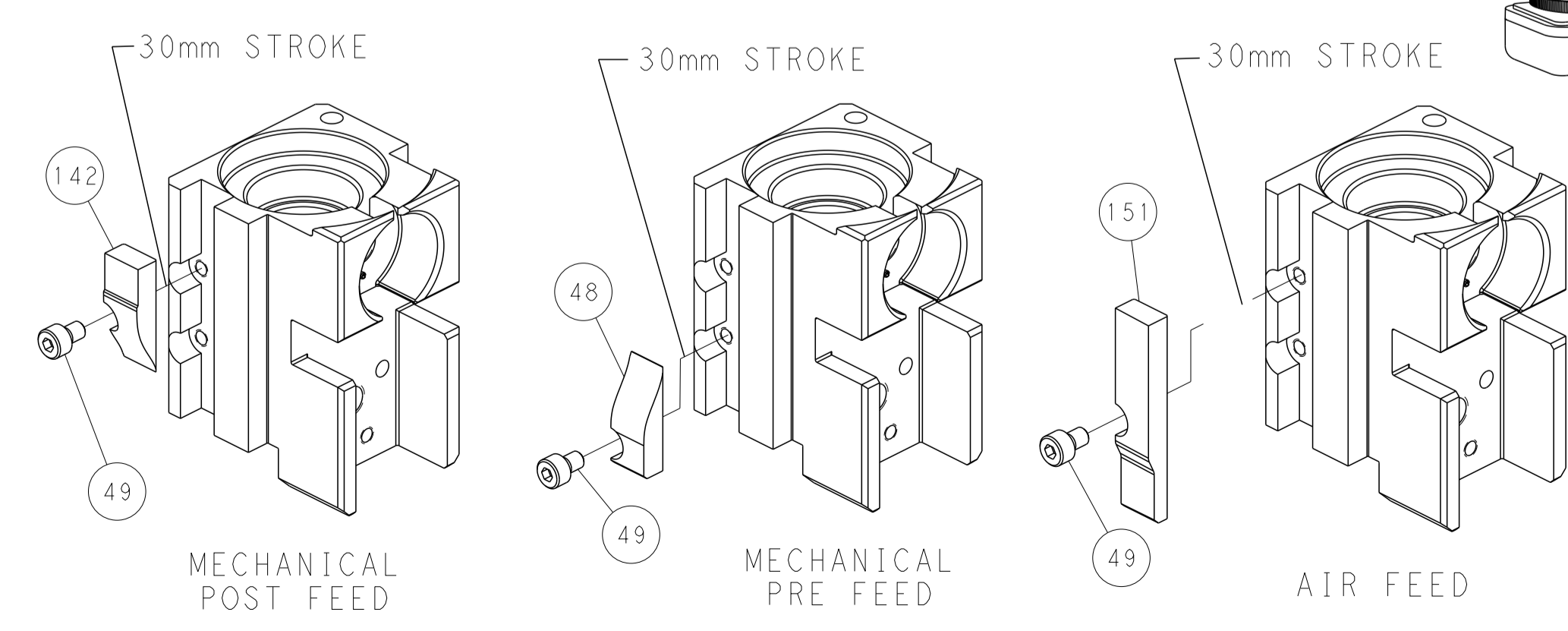


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

## CAM POSITIONS



**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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN BOB HIGMAN 10JUN2014 CHK G. BAILEY 10JUN2014 APVD D. STOUGH 10JUN2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applier SIZE CAGE CODE DRAWING NO A1 00779 C=2266323 SCALE 1:2 SHEET 4 OF 4 REV K		RESTRICTED TO -	
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