

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266150-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266150-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266150-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266150-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266150-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MODU MOD IV REC, SHORT POINT OF CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.78 mm [.141-.188 IN]		∅ 1.60mm [.063 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-25003		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
167418-1	167418-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	0.89+/-0.05 [.035+/- .002]	6.0
22 AWG OR 0.35mm2	0.79+/-0.05 [.031+/- .002]	7.0
24 AWG	0.69+/-0.05 [.027+/- .002]	8.5

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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	02JAN2014	KH	UG
		A1		ECR-14-013851	17SEP2014	KH	JT
		B		ECR-18-018686	28NOV2018	TB	CT
		C		ECR-23-176289	23MAY2023	TB	TE

-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283	
-	1	1	1	1	2280441-1	INSERT, SHEAR	282	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	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	
-	1	1	1	1	1-356885-4	STOP, SHEAR	237	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-1	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	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	3-240641-0	SPACER	81	
-	1	1	1	1	1803607-3	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	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	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	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	
-	3	3	3	3	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	690518-1	HOLD DOWN, TERMINAL	18	
-	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1	1	1	690691-4	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	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	2-1333201-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	1	1	1	1	690468-2	DEPRESSOR SHEAR, REAR	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2-2119582-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
-	1	2	2	1	1	3-456402-1	CRIMPER, WIRE PREMIUM	1
-	77	72	71	70	-1	PART NO	DESCRIPTION	ITEM NO

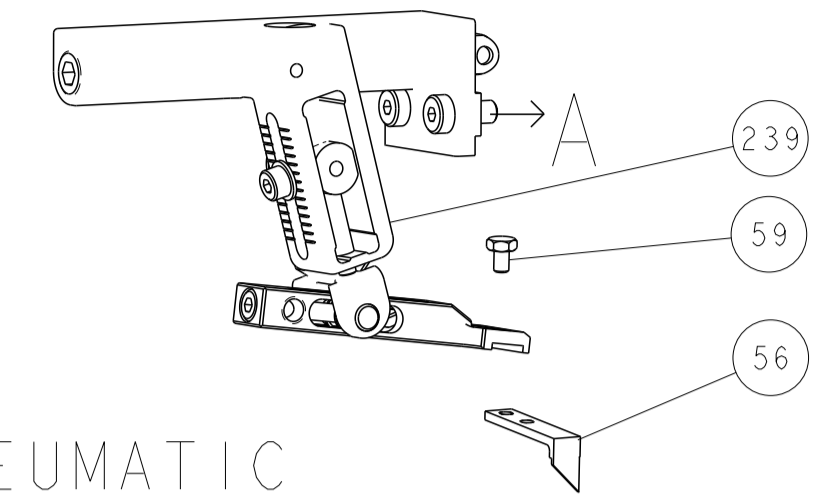
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2266150	1	4	C

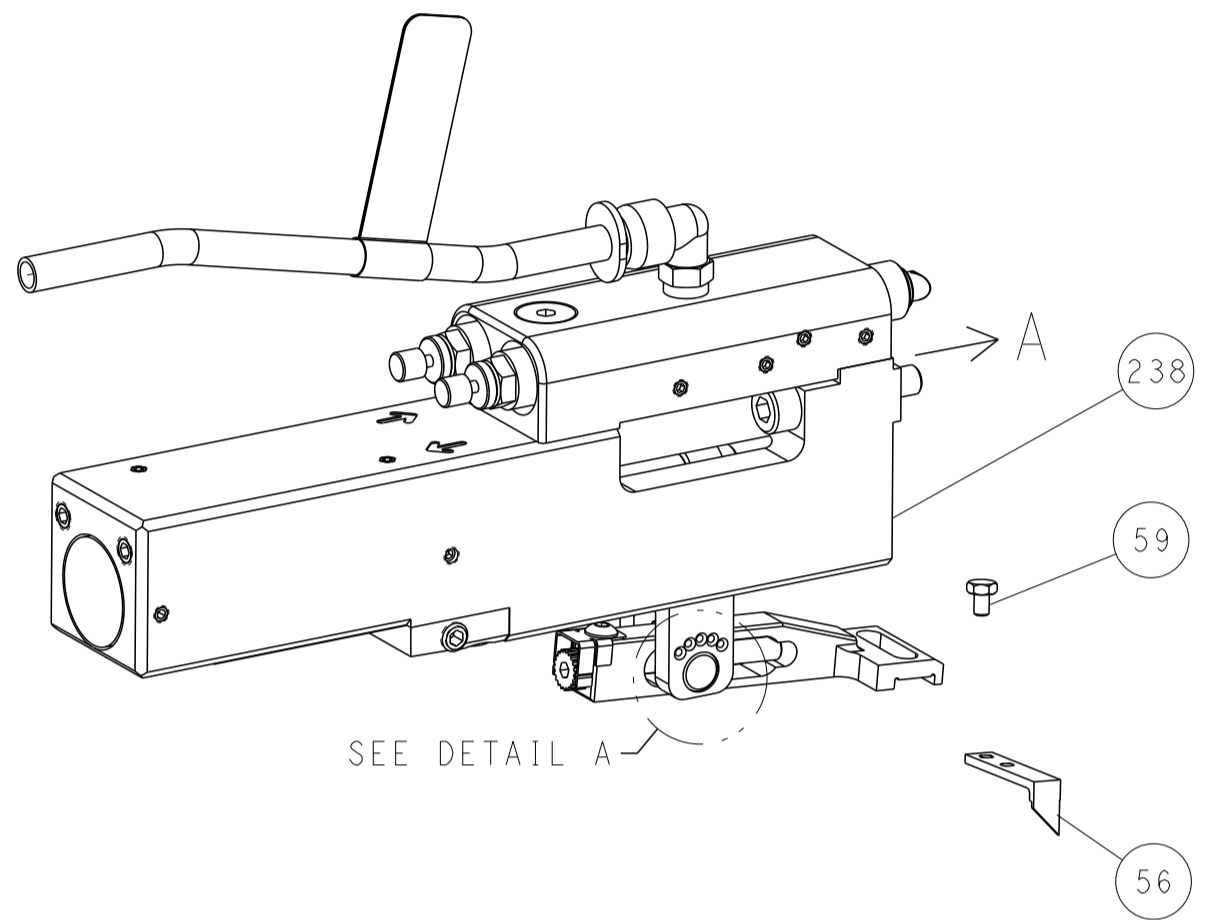
Customer Accessible Production Drawing

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

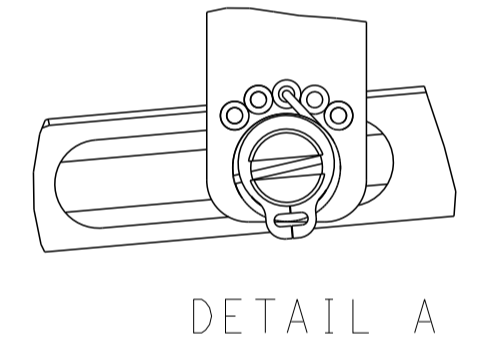
# FEED TYPE MECHANICAL



## PNEUMATIC

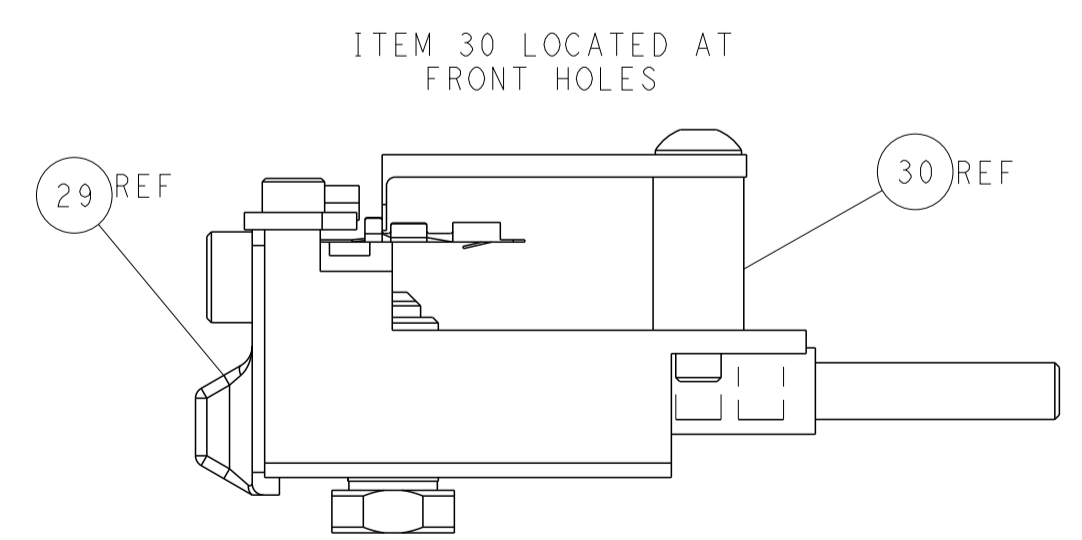
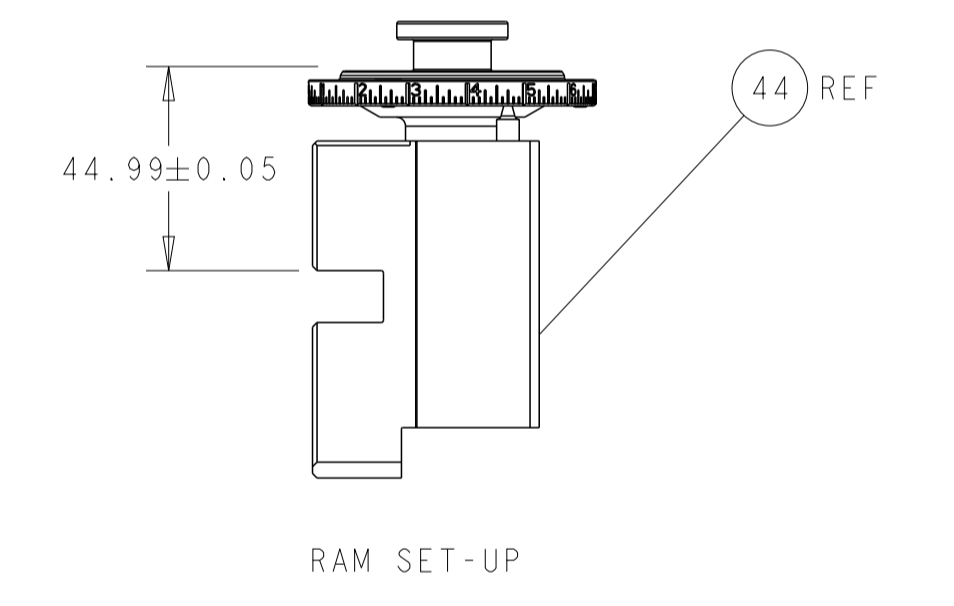
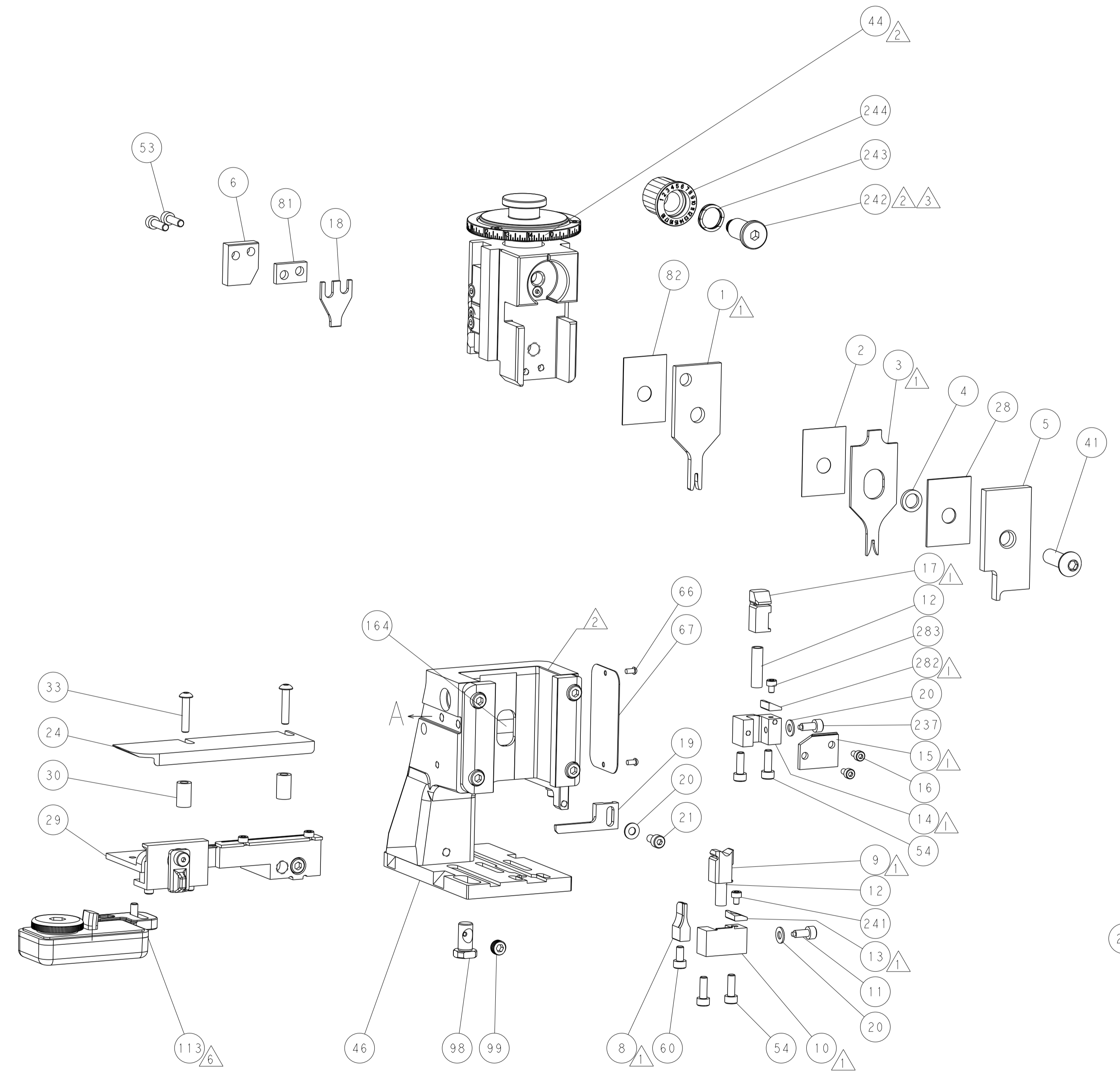
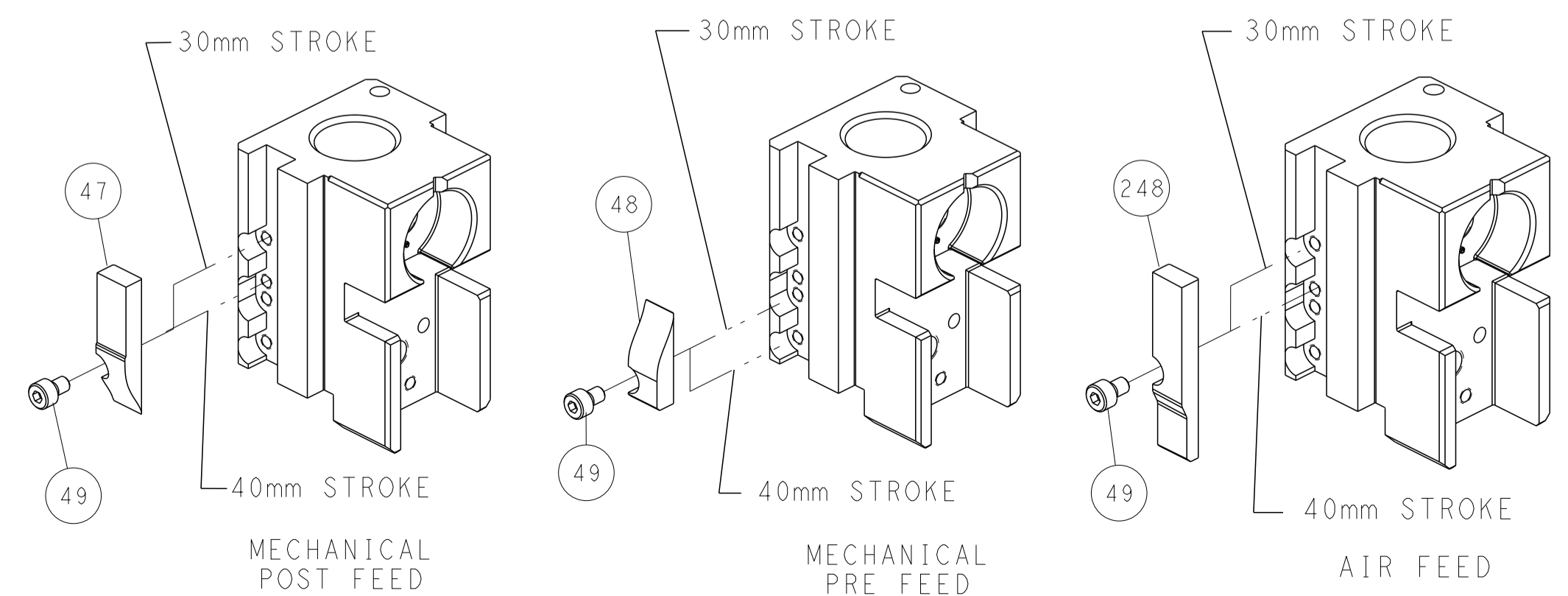


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



DETAIL A

# CAM POSITIONS



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. HUANG 21NOV2013 CHK: L. ZHANG 21NOV2013 APVD: J. GUO 21NOV2013	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266150 RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 2 of 4 REV: C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266150-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266150-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266150-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MODU MOD IV REC, SHORT POINT OF CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.78 mm [1.41-.188 IN]		1.60mm [1.063 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-25003		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
167418-1	167418-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm <sup>2</sup>	0.89+/-0.05 [0.035+/-0.002]	6.0
22 AWG OR 0.35mm <sup>2</sup>	0.79+/-0.05 [0.031+/-0.002]	7.0
24 AWG	0.69+/-0.05 [0.027+/-0.002]	8.5

- RECOMMENDED SPARE PARTS
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**\*WARNING**  
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		283
	-	1	1	2280441-1	INSERT, SHEAR		282
	-	1	1	2119082-9	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	2119580-1	MECHANICAL FEED ASSEMBLY		239
	-	1	-	2844940-1	AIR FEED MODULE		238
	-	1	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	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	3-240641-0	SPACER		81
	-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14		53
	-	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
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
	-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE		30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE		29
	-	1	1	1-455888-0	SPACER, CRIMPER		28
	-	1	1	1320928-2	STRIP GUIDE		24
	-	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	2119533-1	STRIPPER, SIDE FEED		19
	-	1	1	690518-1	HOLD DOWN, TERMINAL		18
	-	1	1	690463-1	FLOATING SHEAR, REAR		17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6		16
	-	1	1	690691-4	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	1803095-1	FLOATING SHEAR, FRONT		9
	1	1	1	2-1333201-6	ANVIL, COMBINATION		8
	-	-	-	-	-		7
	-	1	1	690468-2	DEPRESSOR SHEAR, REAR		6
	-	1	1	2119757-8	DEPRESSOR, SHEAR		5
	-	1	1	238011-7	BLOCK, CRIMPER SPACER		4
	1	1	1	2-2119582-0	CRIMPER, INSULATION F PREMIUM		3
	-	1	1	455888-1	SPACER, CRIMPER		2
	1	1	1	3-456402-1	CRIMPER, WIRE PREMIUM		1

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:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

ITEM NO	DESCRIPTION	REV
-77	-22	-21

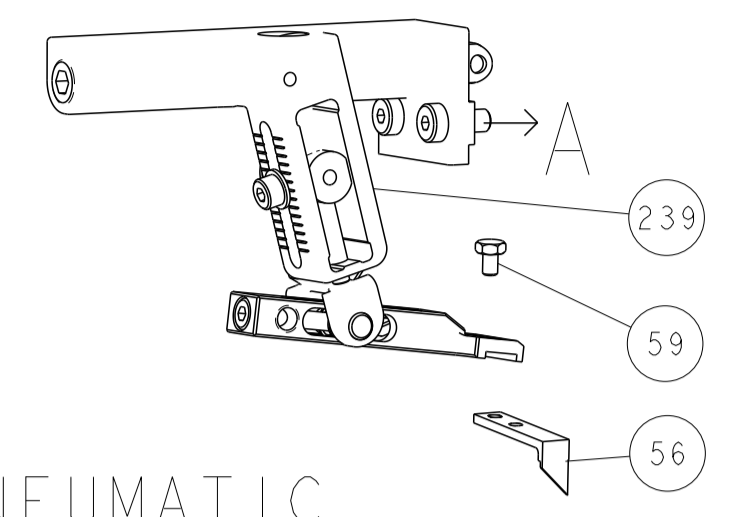
APPROVED	DATE	BY	DATE
H. HUANG	21NOV2013	L. ZHANG	21NOV2013
J. GUO	21NOV2013		

NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Ocean Side Feed Applicator	A1	00779	2266150	

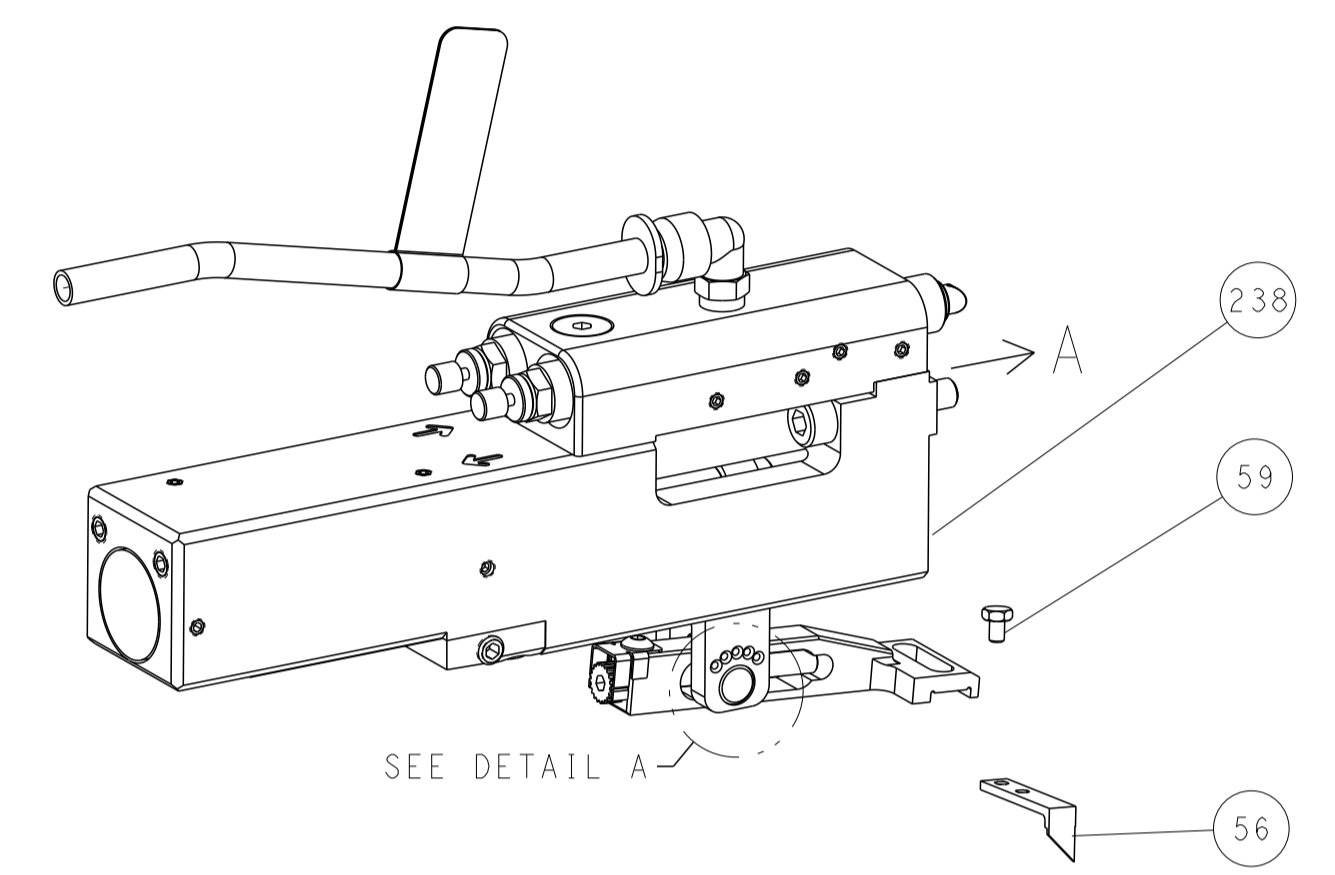
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV C

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

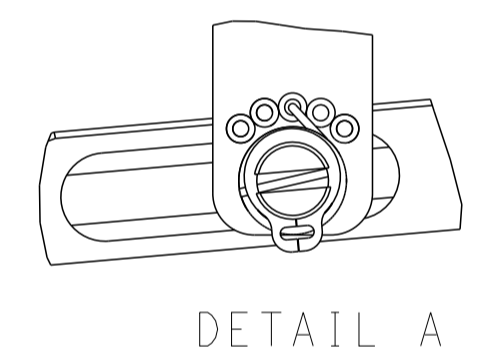
# FEED TYPE MECHANICAL



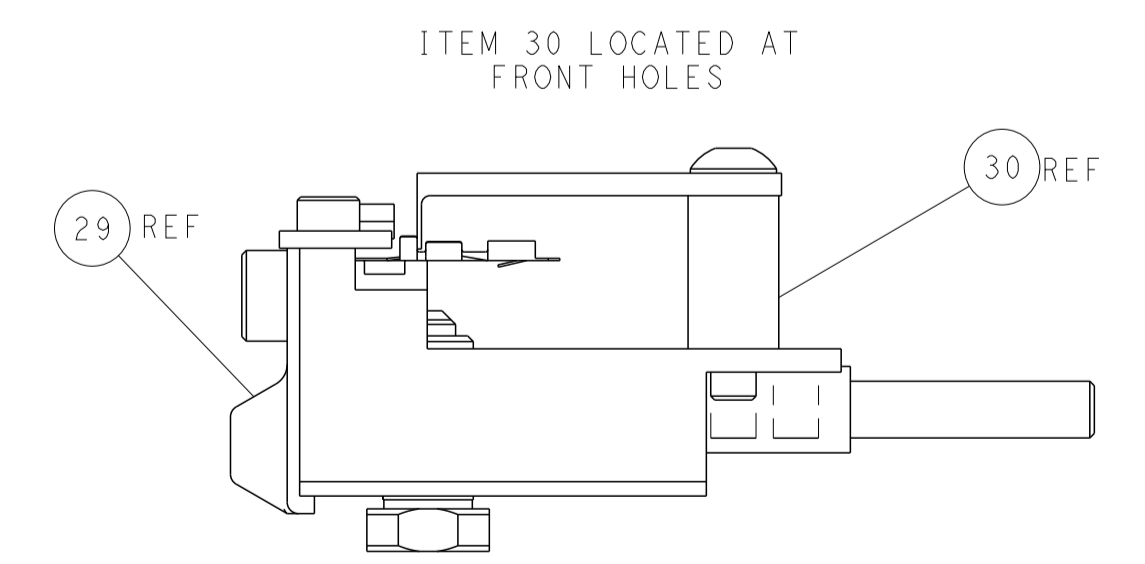
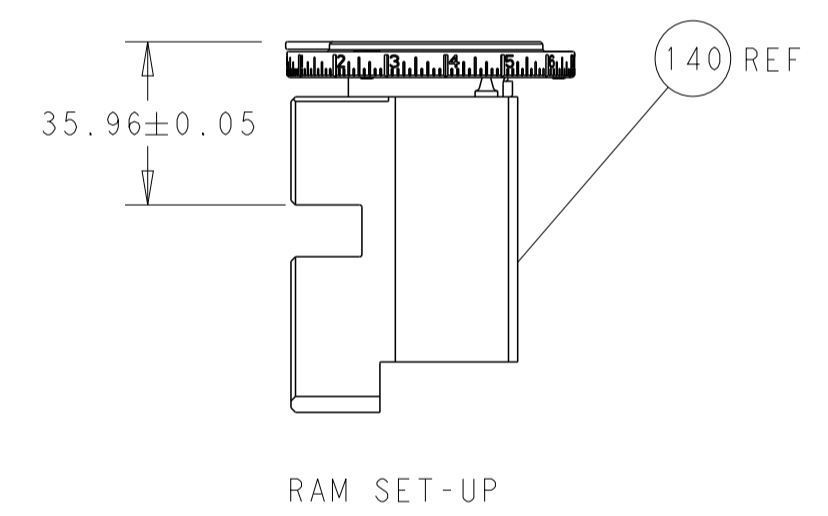
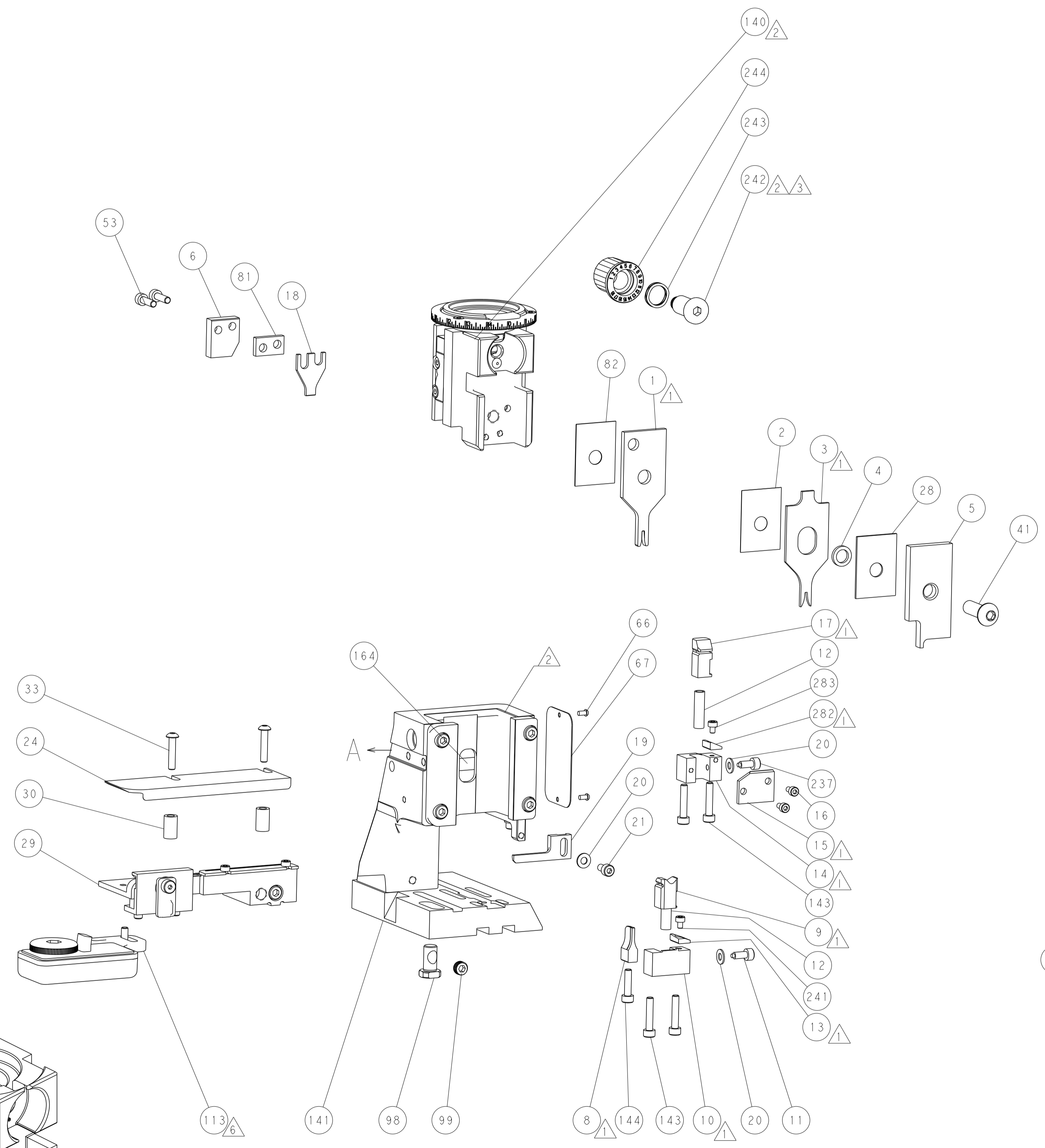
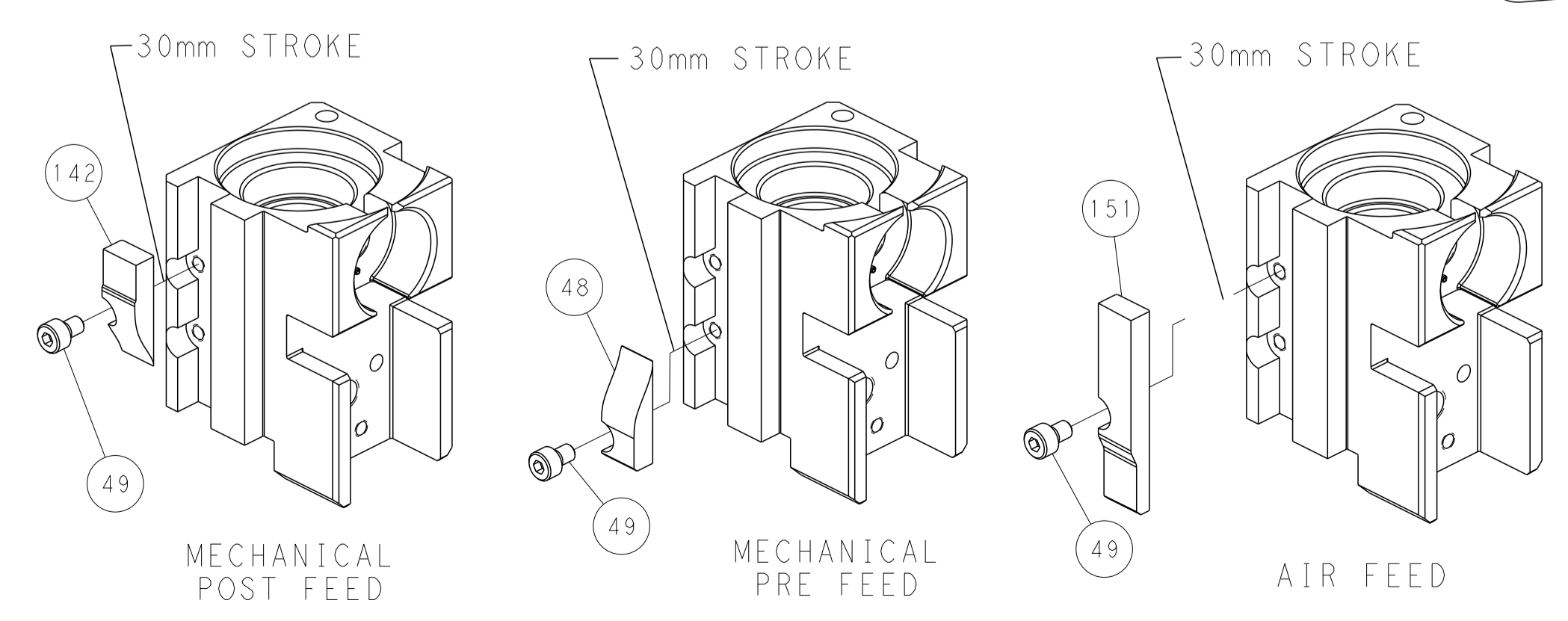
## PNEUMATIC



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



## CAM POSITIONS



**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 ±		NAME: Ocean Side Feed Applier PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266150 WEIGHT:	RESTRICTED TO: SCALE: 1:2 SHEET: 4 OF 4 REV: C
MATERIAL:		Customer Accessible Production Drawing	