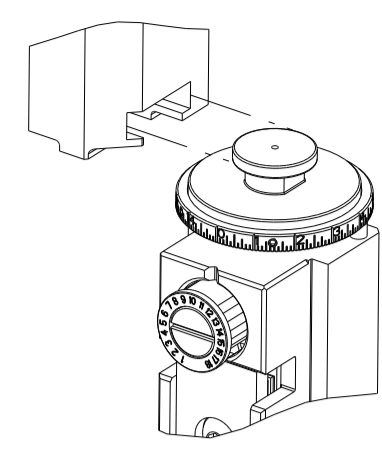


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266526-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266526-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266526-1	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266526-2	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266526-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266526-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266526-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	○
INSUL	2.54 mm [.100]	○

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: ITT CANNON ITT CANNON CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.70-4.30 mm [1.46-.169 IN]	Ø1.17-2.08 mm [1.046-.082 IN]

TERMINAL APPLICATION SPECIFICATION ITT CANNON SPEC Rev -

TERMINALS APPLIED			
TE TERMINAL	ITT CANNON TERMINAL	TE TERMINAL	ITT CANNON TERMINAL
1949558-1	192900-0409	1949561-2	192990-2550
1949558-2	192900-0125	1949561-3	192990-2690
1949558-3	192900-0121	1949215-1	192990-2640
1949558-4	192900-0124	1949215-2	192990-2500
1949558-5	192900-0120	1949215-3	192900-0405
1949558-6	192990-2540	1949560-1	192900-0406
1949558-7	192990-2680	1949560-2	192990-2510
1949561-1	192900-0410	1949560-3	192990-2650

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.15+/-0.03 [1.045+/-0.001]	6.2
22 AWG	1.05+/-0.03 [1.041+/-0.001]	7.3

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 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	OWN	APVD
		B		ECR-15-011154	27JUL2015	MR	JDG
		C		ECR-17-007407	23MAY2017	YY	JDG
		D		ECR-20-015228	09DEC2020	MEH	RK
		D1		ECR-22-129889	17FEB2022	FJ	JAH

-	-	-	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	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	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
-	-	-	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
-	1	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	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	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	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	1-356885-5	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	2-1633918-3	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	6-240641-8	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1	1-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	2	1	1	1	7-459492-9	CRIMPER, WIRE O	1

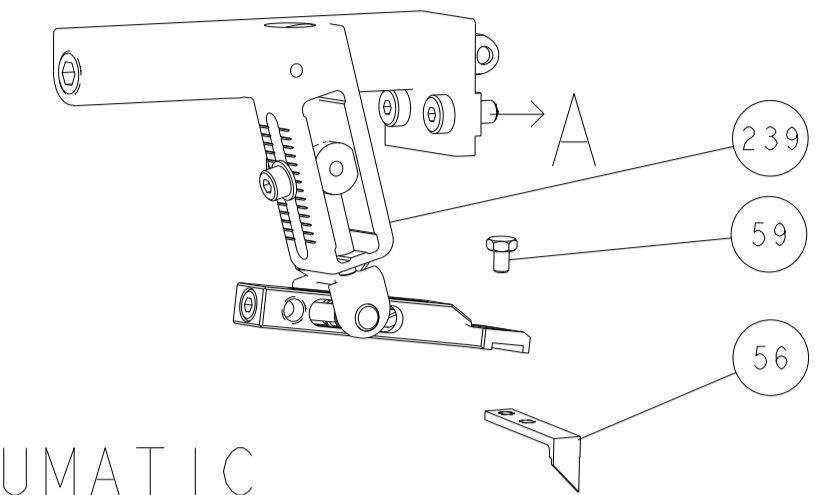
ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN J.HOU 14OCT2014	TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ±		CHK Y.YIN 14OCT2014	
		1 PLC ±		APVD U.GUO 14OCT2014	
		2 PLC ±		PRODUCT SPEC	
		3 PLC ±		APPLICATION SPEC	NAME Ocean Side Feed Applicator
		4 PLC ±		SIZE A1	CAGE CODE 00779
		ANGLES FINISH		DRAWING NO C=2266526	RESTRICTED TO
MATERIAL		FINISH		WEIGHT	SCALE 1:2
				SHEET 1 OF 4	REV D1

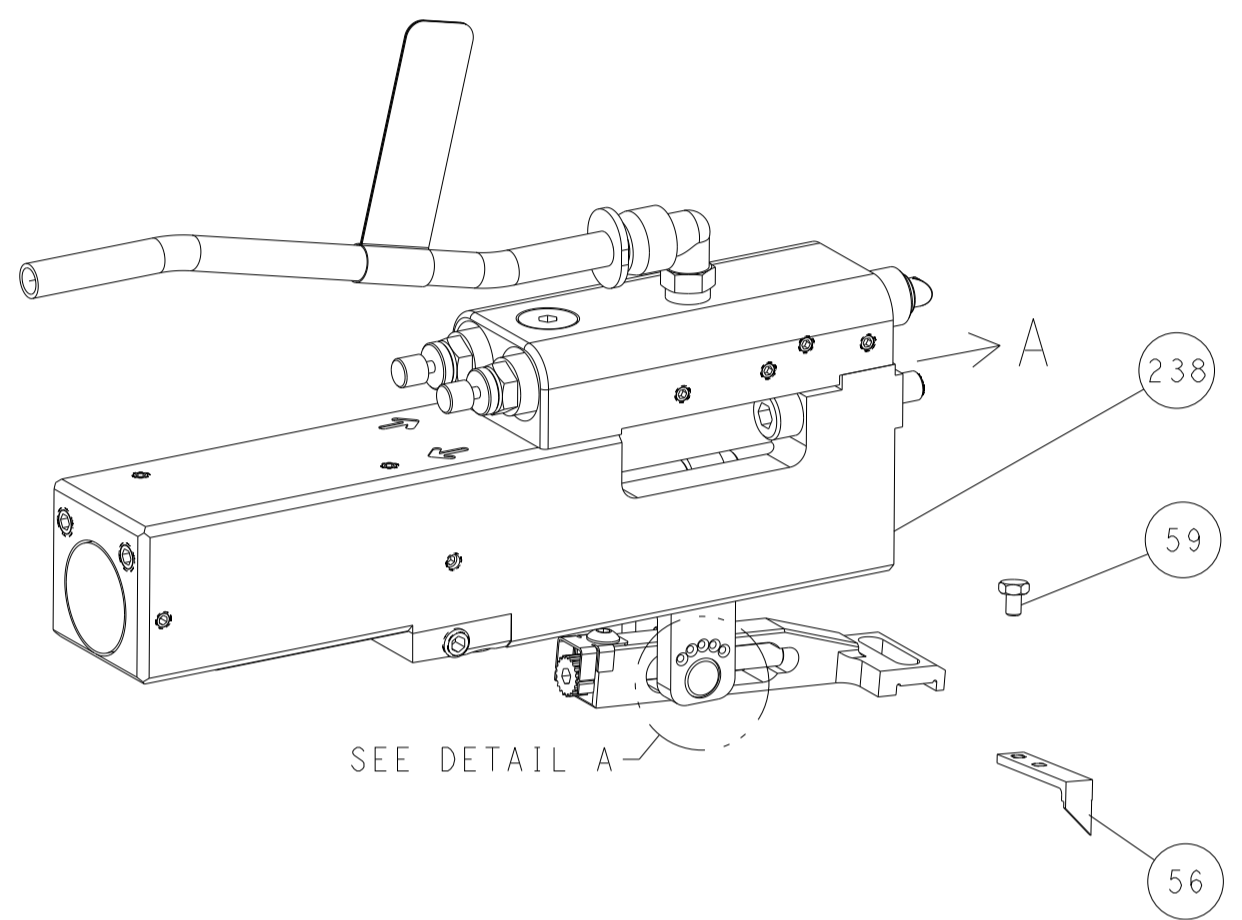
Customer Accessible Production Drawing

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

# FEED TYPE MECHANICAL



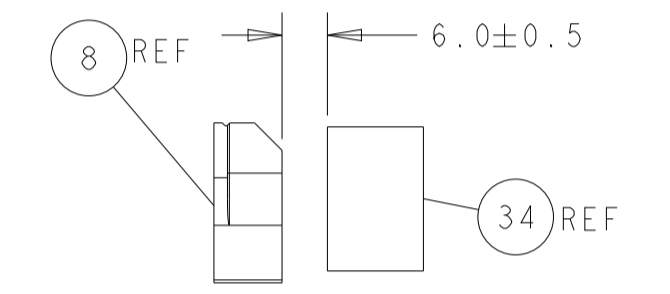
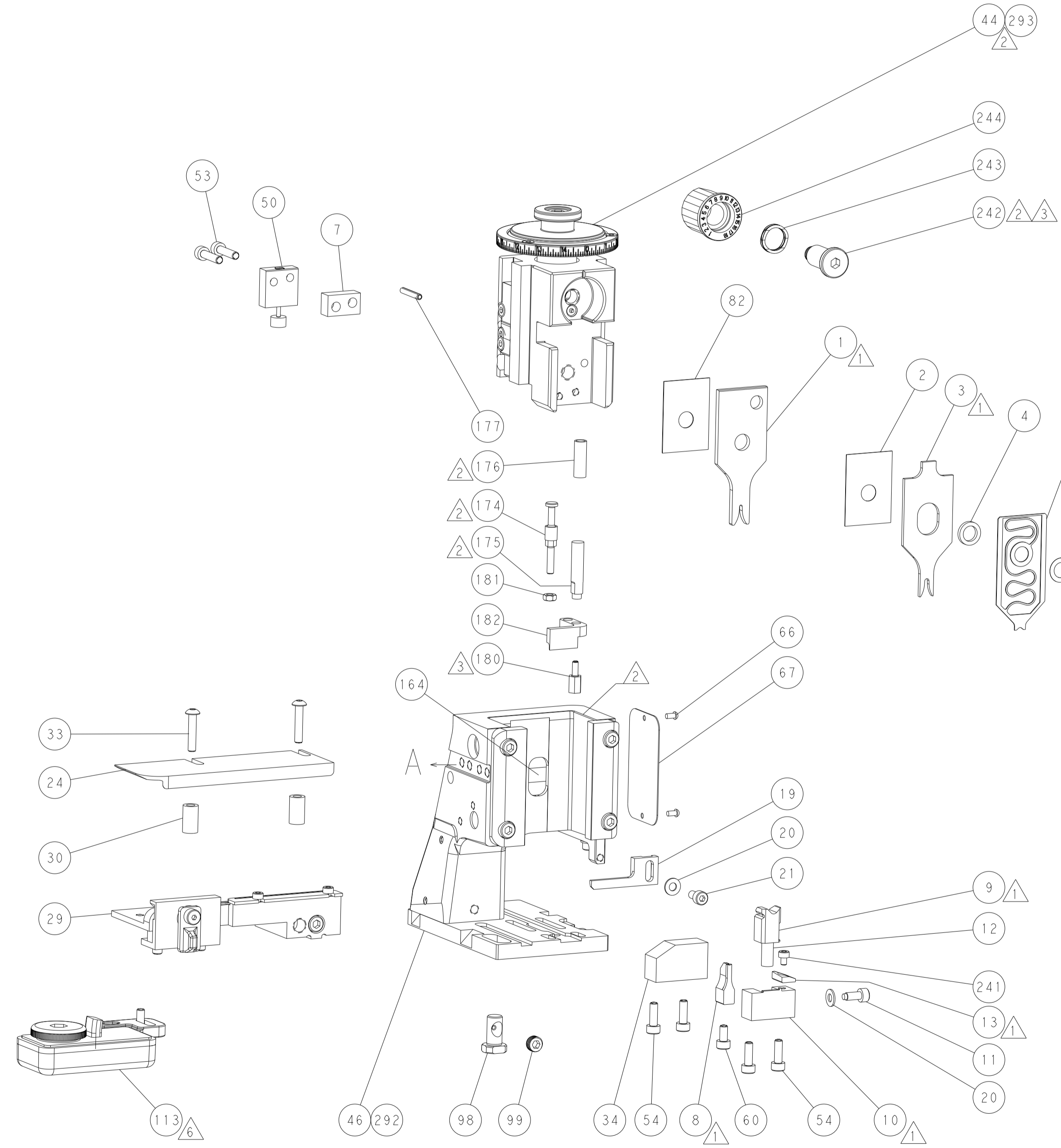
## PNEUMATIC



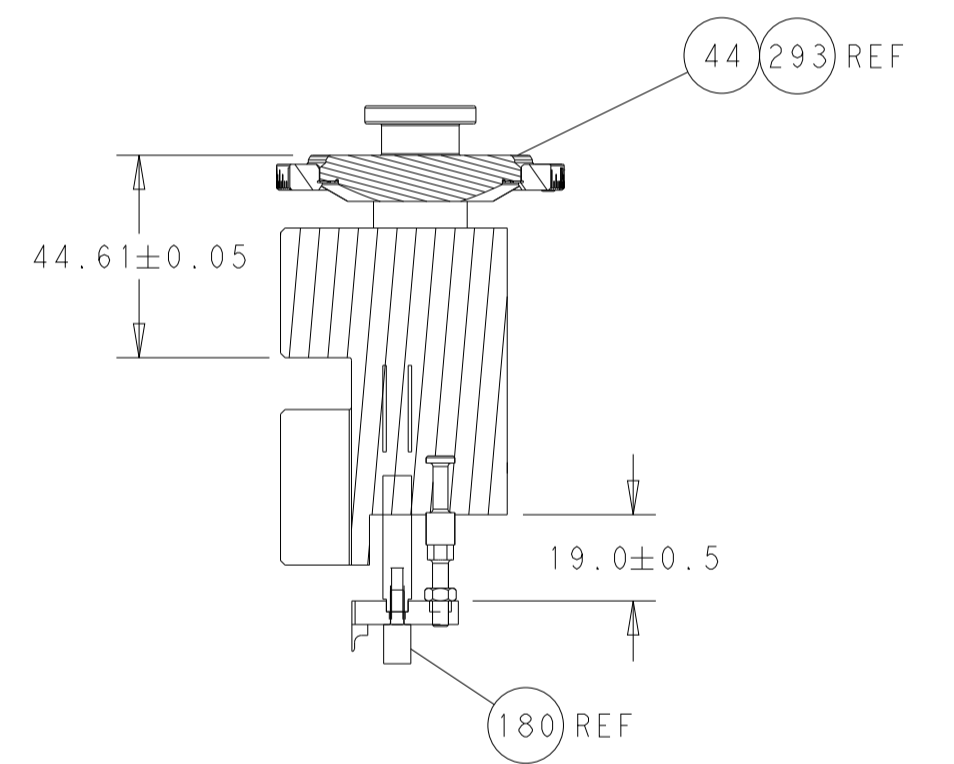
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

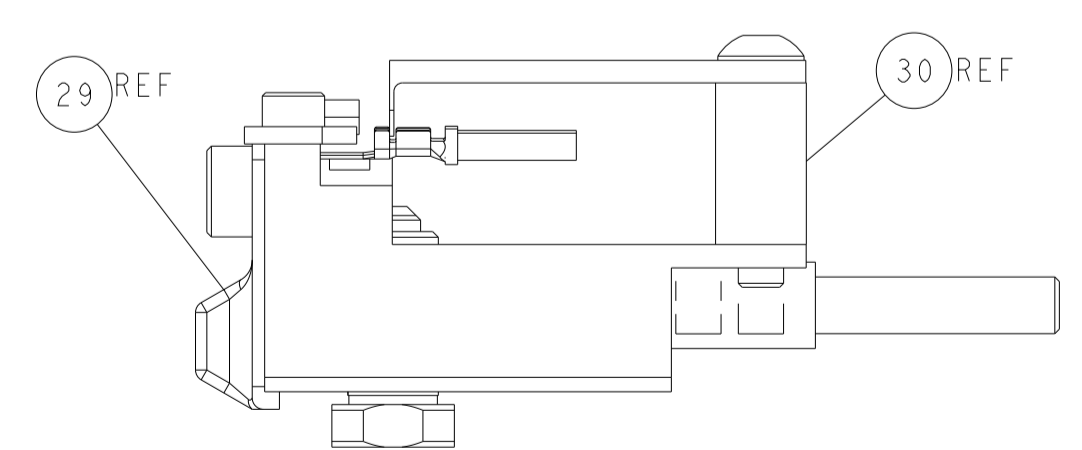


TERMINAL SUPPORT LOCATION



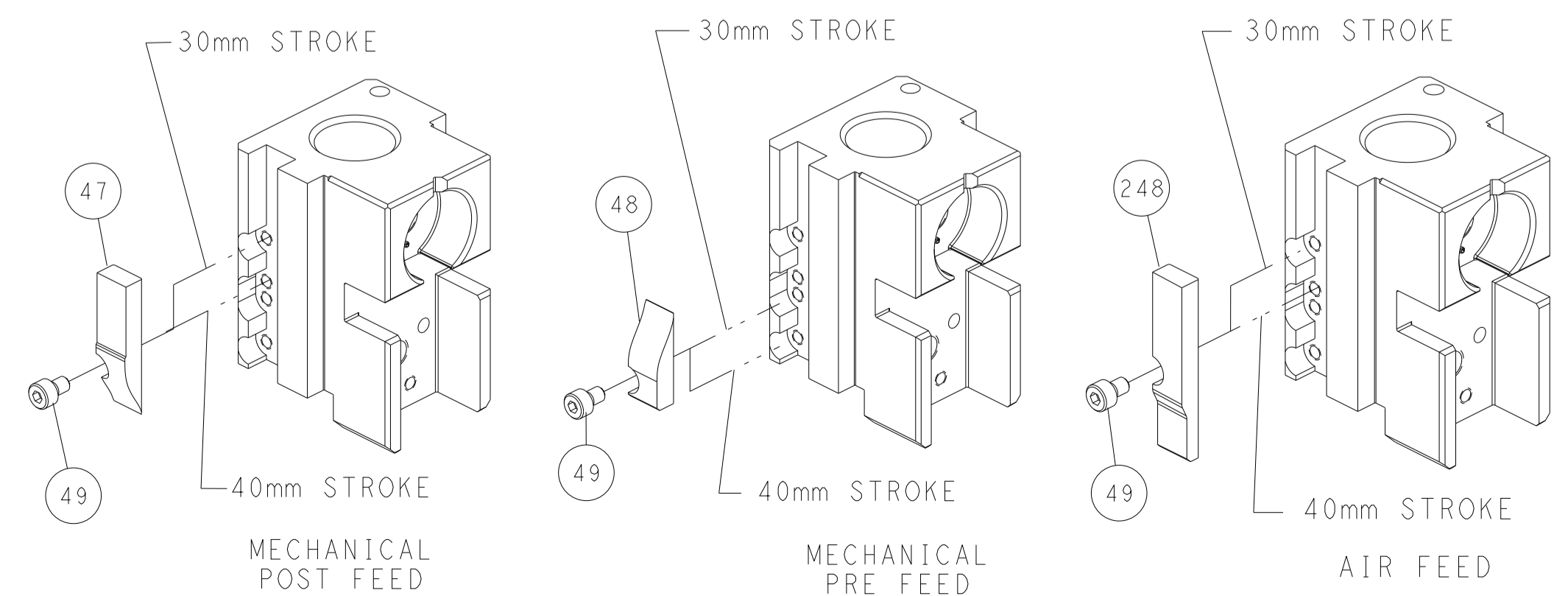
RAM AND HOLD DOWN SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

## 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. ALL RIGHTS RESERVED. © 2000 BY TYCO ELECTRONICS CORPORATION. THIS DRAWING IS CONTROLLED DOCUMENT. FOR THE PROTECTION OF THE PROPRIETARY INFORMATION OF TYCO ELECTRONICS CORPORATION, THIS DRAWING IS CONTROLLED DOCUMENT. FOR THE PROTECTION OF THE PROPRIETARY INFORMATION OF TYCO ELECTRONICS CORPORATION, THIS DRAWING IS CONTROLLED DOCUMENT.</small>		DWN: J. HOU 14OCT2014 CHK: Y. YIN 14OCT2014 APVD: J. GUO 14OCT2014	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 ±	MATERIAL:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266526 SCALE: 1:2 SHEET: 2 OF 4 REV: D1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266526-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266526-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266526-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	0
INSUL	2.54 mm [.100]	0

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: ITT CANNON ITT CANNON CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.70-4.30 mm [.146-.169 IN]	Ø 1.17-2.08 mm [.046-.082 IN]		
TERMINAL APPLICATION SPECIFICATION			
TE TERMINAL	ITT CANNON TERMINAL	TE TERMINAL	ITT CANNON TERMINAL
1949558-1	192900-0409	1949561-2	192990-2550
1949558-2	192900-0125	1949561-3	192990-2690
1949558-3	192900-0121	1949215-1	192990-2640
1949558-4	192900-0124	1949215-2	192990-2500
1949558-5	192900-0120	1949215-3	192900-0405
1949558-6	192990-2540	1949560-1	192900-0406
1949558-7	192990-2680	1949560-2	192990-2510
1949561-1	192900-0410	1949560-3	192990-2650

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.15+/-0.03 [.045+/-0.001]	6.2
22 AWG	1.05+/-0.03 [.041+/-0.001]	7.3

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	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
-	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	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	2119791-5	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1320928-6	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
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	2-1633918-3	ANVIL, COMBINATION	8
-	1	1	6-240641-8	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	7-459492-9	CRIMPER, WIRE O	1

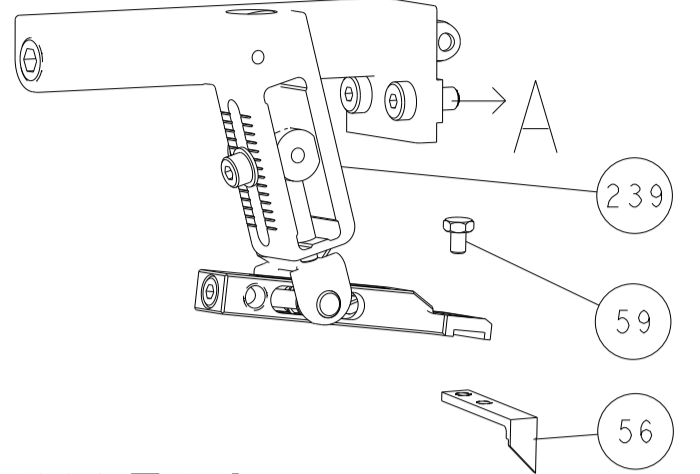
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J.HOU 14OCT2014		CHK: Y.YIN 14OCT2014		APVD: U.GUO 14OCT2014		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: D1	

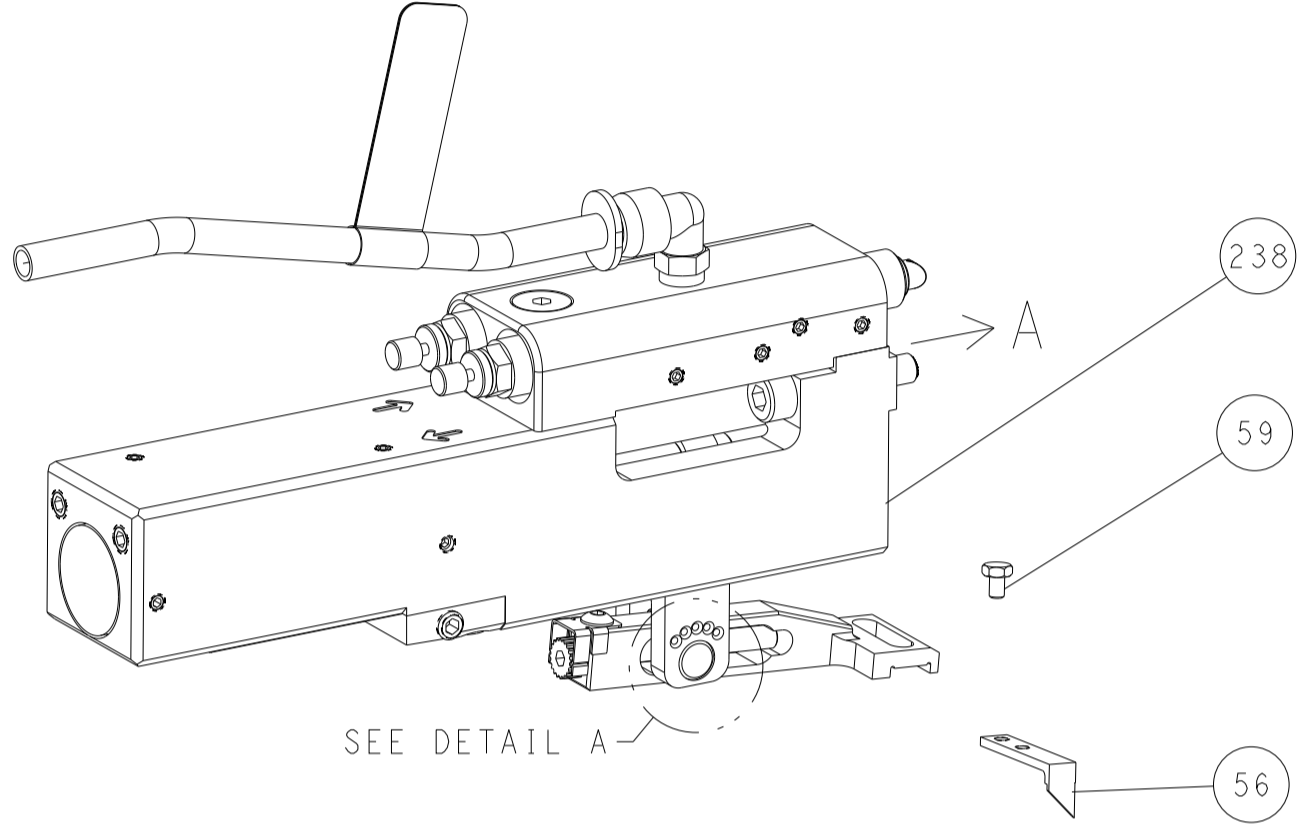
Customer Accessible Production Drawing

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

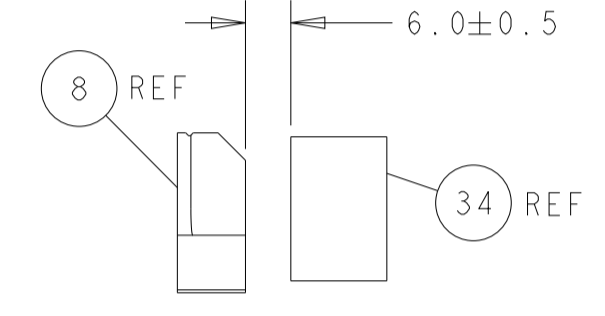
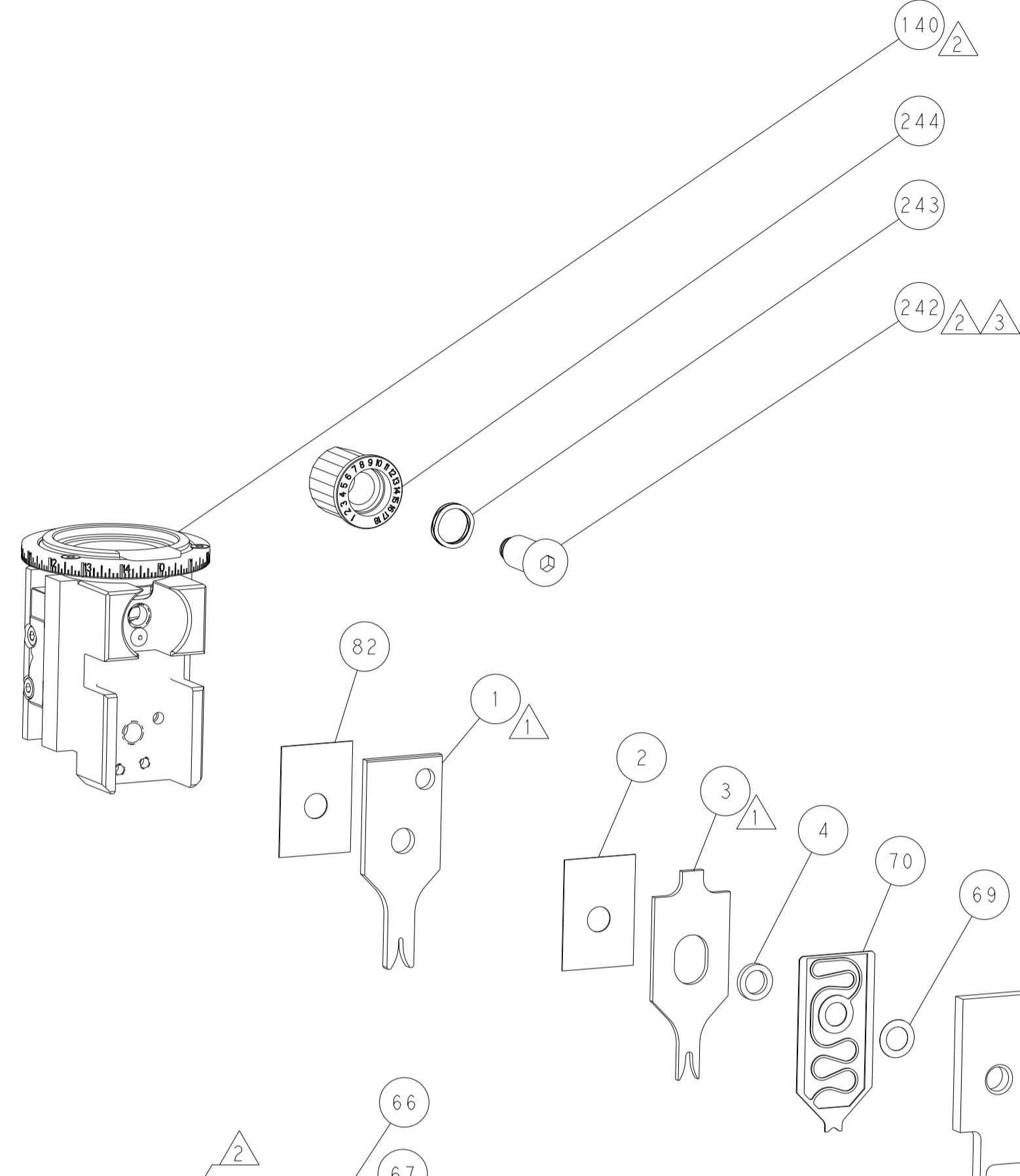
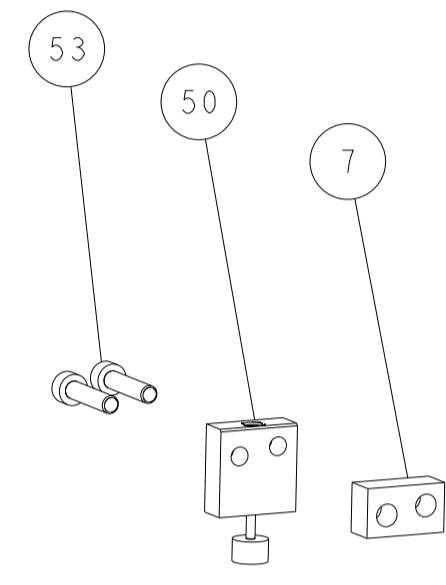
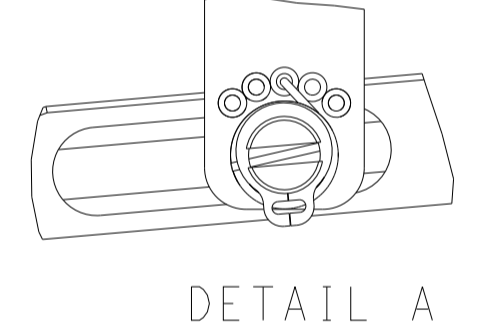
# FEED TYPE MECHANICAL



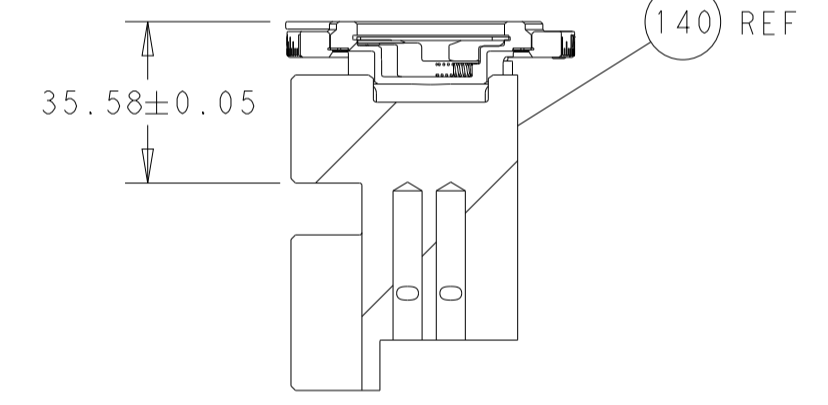
## PNEUMATIC



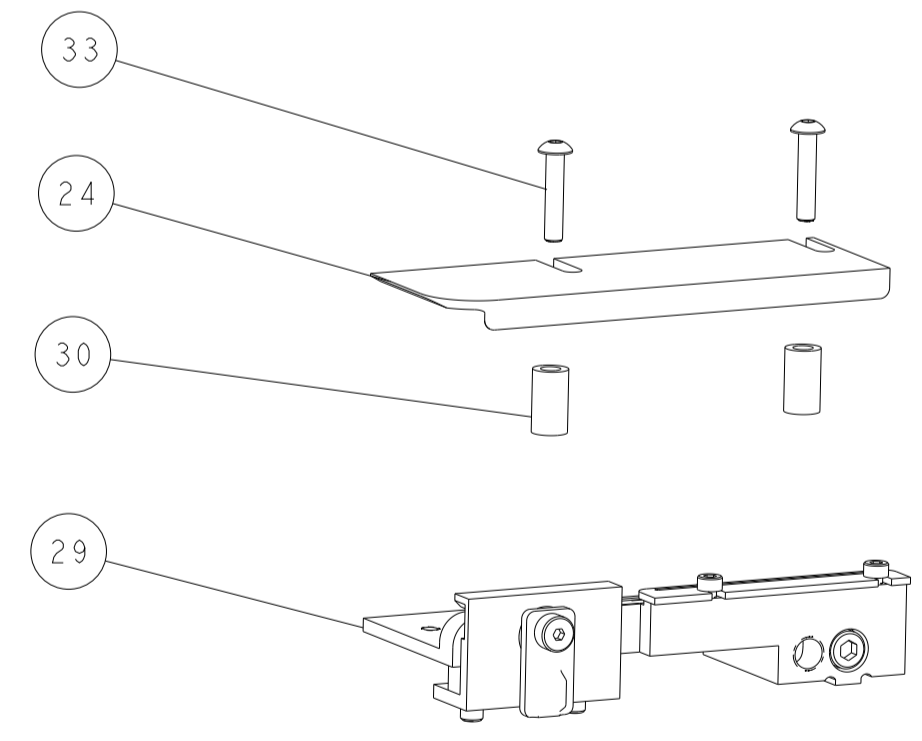
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



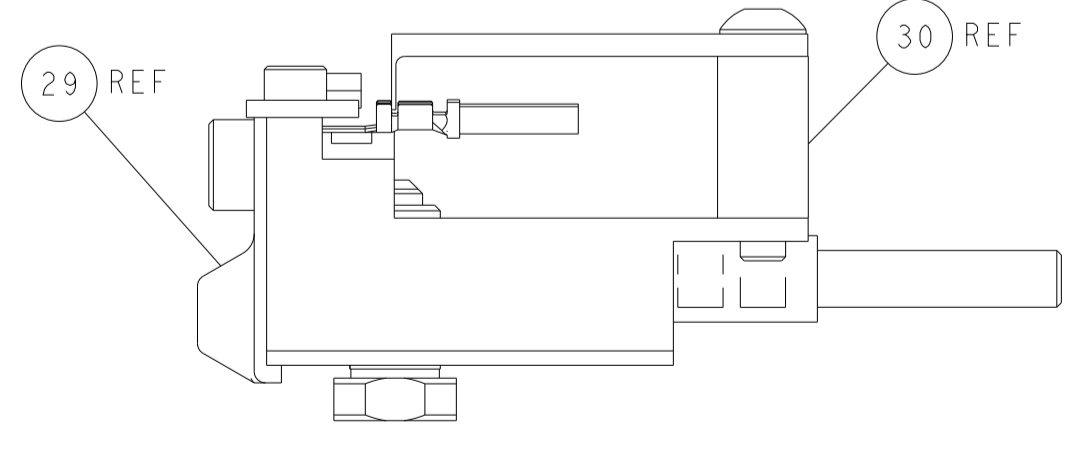
TERMINAL SUPPORT LOCATION



RAM SET-UP

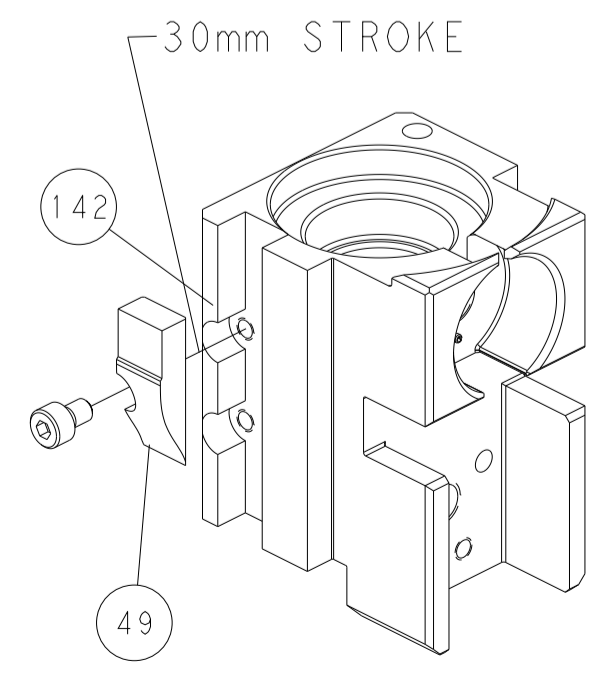


ITEM 30 LOCATED AT REAR HOLES

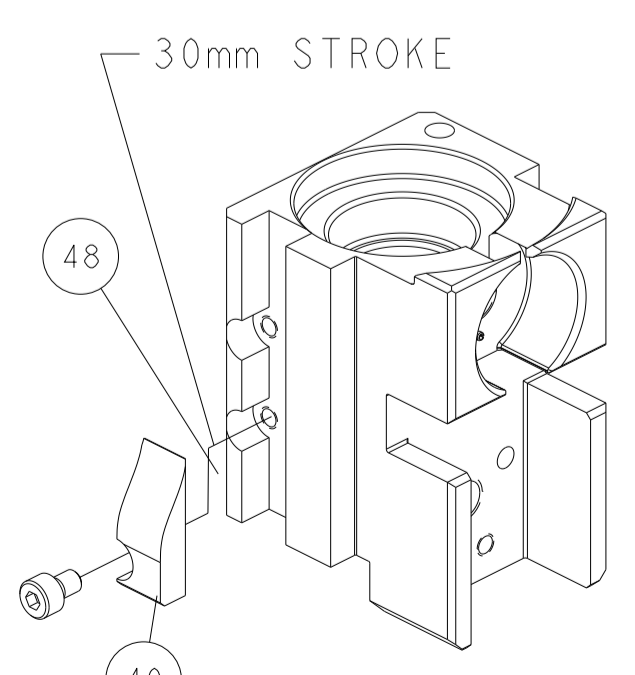


FEED TRACK POSITION GUIDE BY INSULATION BARREL

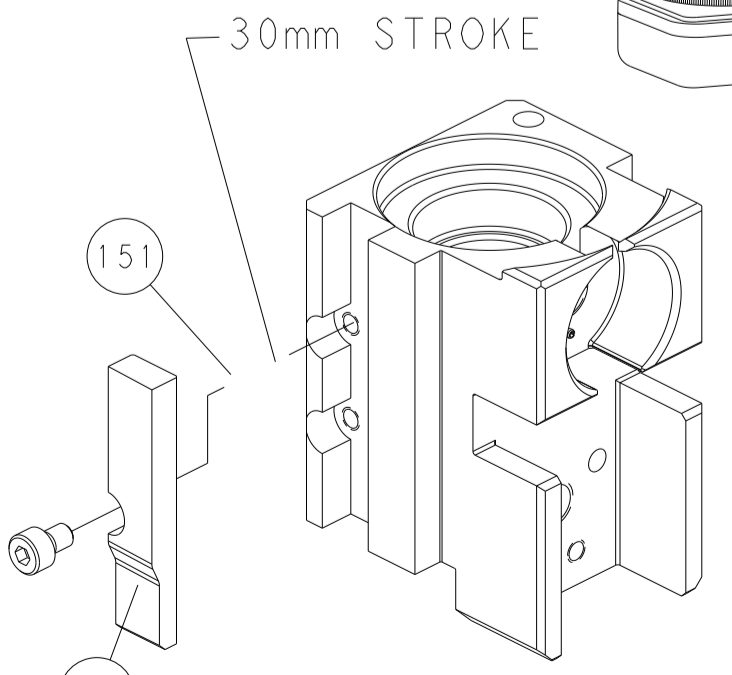
## CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J.HOU 14OCT2014		REV: Y.YIN 14OCT2014		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±	SIZE: A1	CAGE CODE: 00779
MATERIAL:								SCALE: 1:2	SHEET: 4 OF 4