

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266742-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266742-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266742-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266742-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266742-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.35 mm [.132]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: YAZAKI TERMINAL FORD CRIMP SPECIFICATION	
TERMINAL NAME: 1.5 SYST SEALED FEMALE TERMINAL	
WIRE STRIP LENGTH 5.00-5.50 mm [.197-.217 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.80-2.10 mm [.071-.083 IN]
TERMINAL APPLICATION SPECIFICATION 97BG-14474-ADA Rev -	

TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	SEAL INSULATION DIAMETER RANGE
286813-1	7116-4103-02	1572025-1	7158-3030-50	1.2-1.7mm
286813-2	7116-4103-08		OSR SEAL	
		2113681-1	E-1644-00	1.6-2.1mm
		2113614-1	E-1644-01	1.2-1.7mm
		286814-1	7158-3031-90	1.8-2.6mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.30 +/- 0.05 [.051 +/- .002]	5.0
1.00mm2	1.25 +/- 0.05 [.049 +/- .002]	5.5
18 AWG	1.15 +/- 0.05 [.045 +/- .002]	6.7
0.75mm2	1.15 +/- 0.05 [.045 +/- .002]	6.7

**\*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.

- 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. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7. TERMINAL LUBRICANT IS RECOMMENDED.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		C		ECR-18-018712	28NOV2018	JAH	CT
		C1		ECR-19-002568	18FEB2019	FZ	YY
		D		ECR-20-016764	25NOV2020	FZ	TE
		E		ECR-22-152563	14SEP2022	ROY	JAH

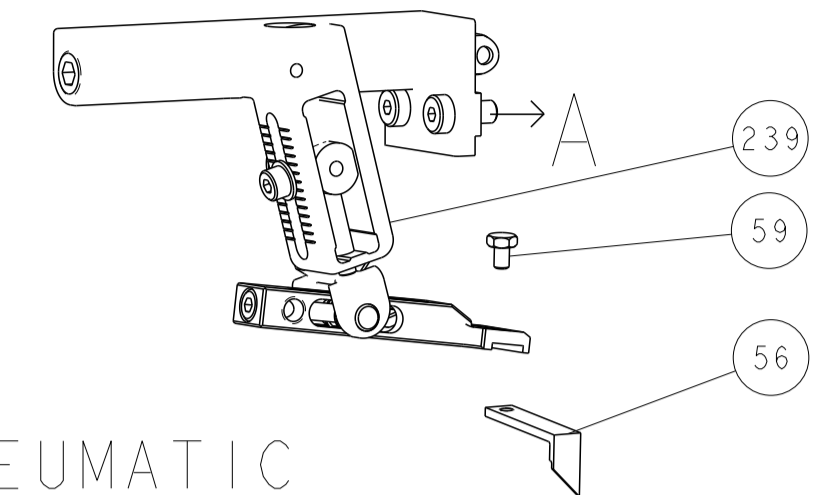
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	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	2-690438-2	FRONT STRIP GUIDE	96	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	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	
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	3-1752356-4	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844938-1	PLATE, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	2	2	2	2	22281-8	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	1320928-2	STRIP GUIDE	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	
-	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	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	3-1803055-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	9-1633965-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
-	1	2	2	1	1	8-1633305-0	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)

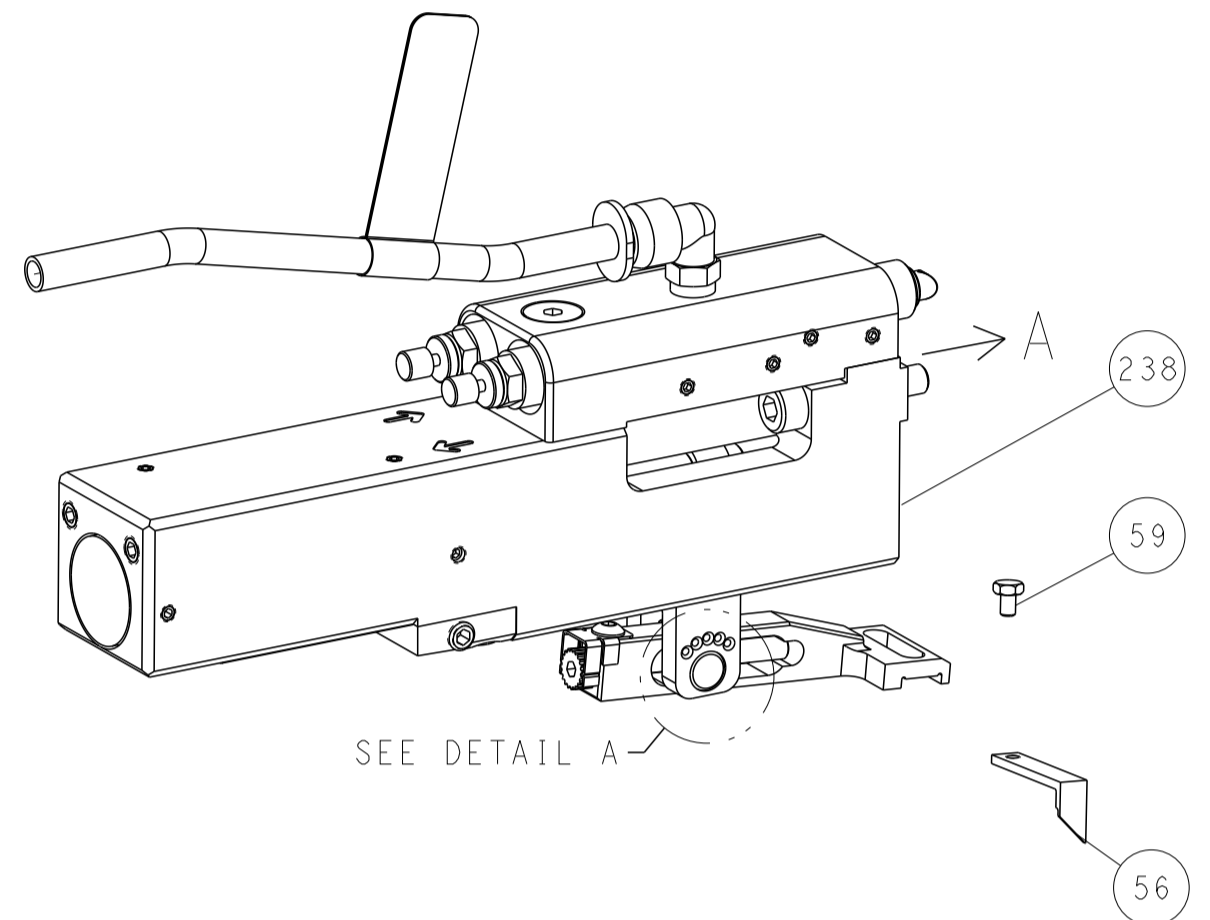
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 01APR2015		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±		CHK: L. ZHANG 01APR2015		NAME: Ocean Side Feed Applicator	
1 PLC ±		2 PLC ±		APVD: J. GUO 01APR2015		SIZE: A1	
3 PLC ±		4 PLC ±		PRODUCT SPEC		CAGE CODE: 00779	
5 PLC ±		ANGLES ±		APPLICATION SPEC		DRAWING NO: C=2266742	
MATERIAL		FINISH		WEIGHT		RESTRICTED TO: -	
				Customer Accessible Production Drawing		SCALE: 1:2 SHEET 1 OF 4 REV E	

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

# FEED TYPE MECHANICAL



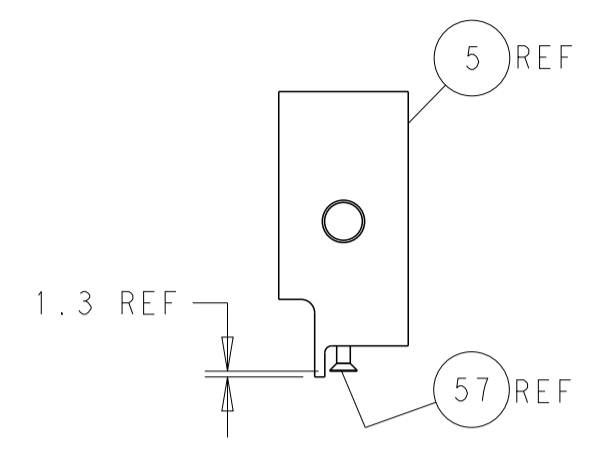
## PNEUMATIC



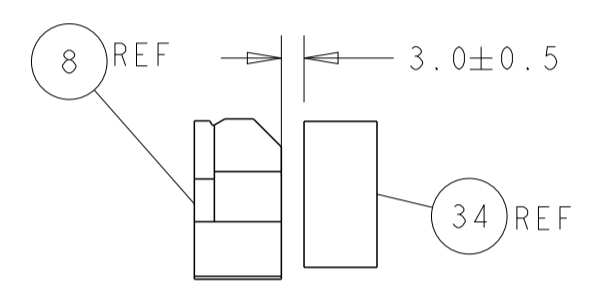
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



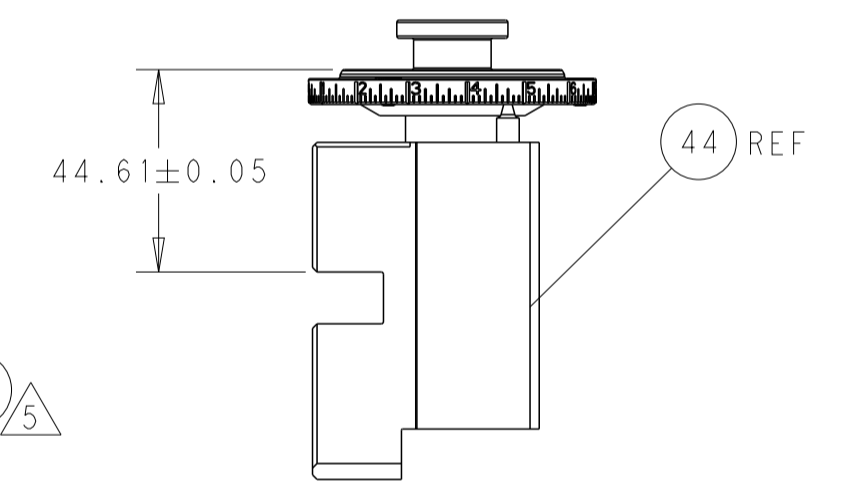
DETAIL A



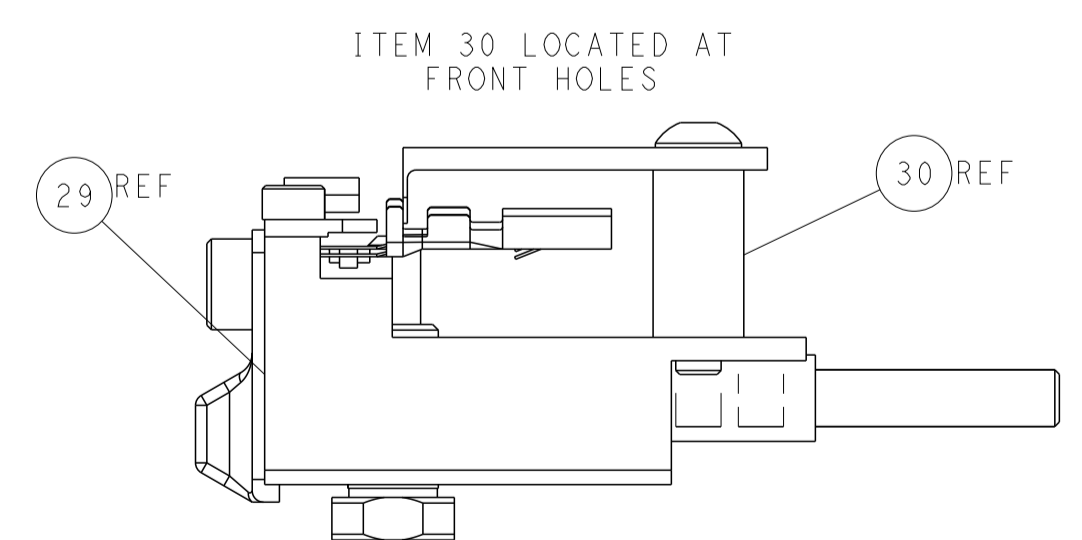
SHEAR DEPRESSOR DETAIL



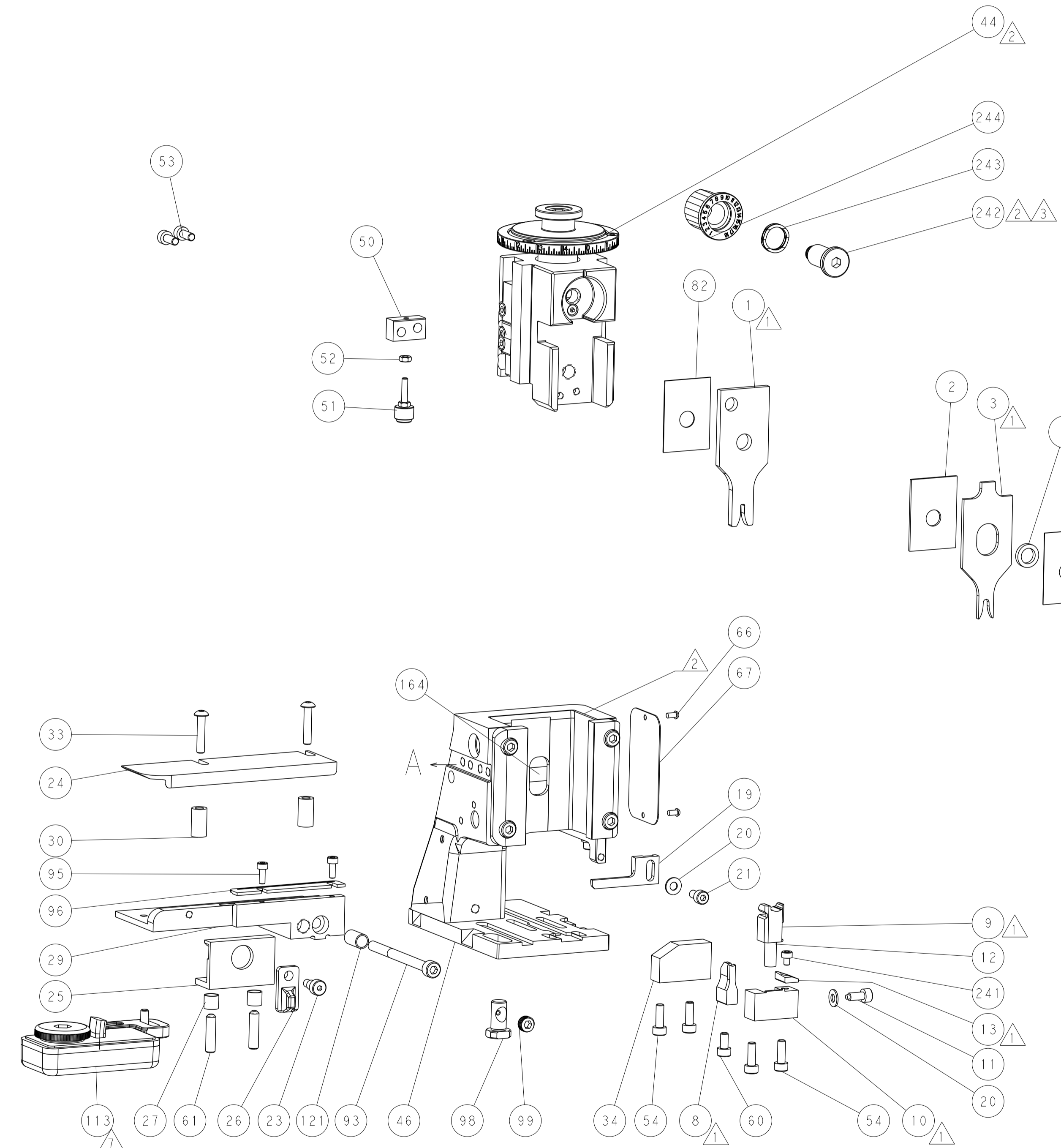
TERMINAL SUPPORT LOCATION



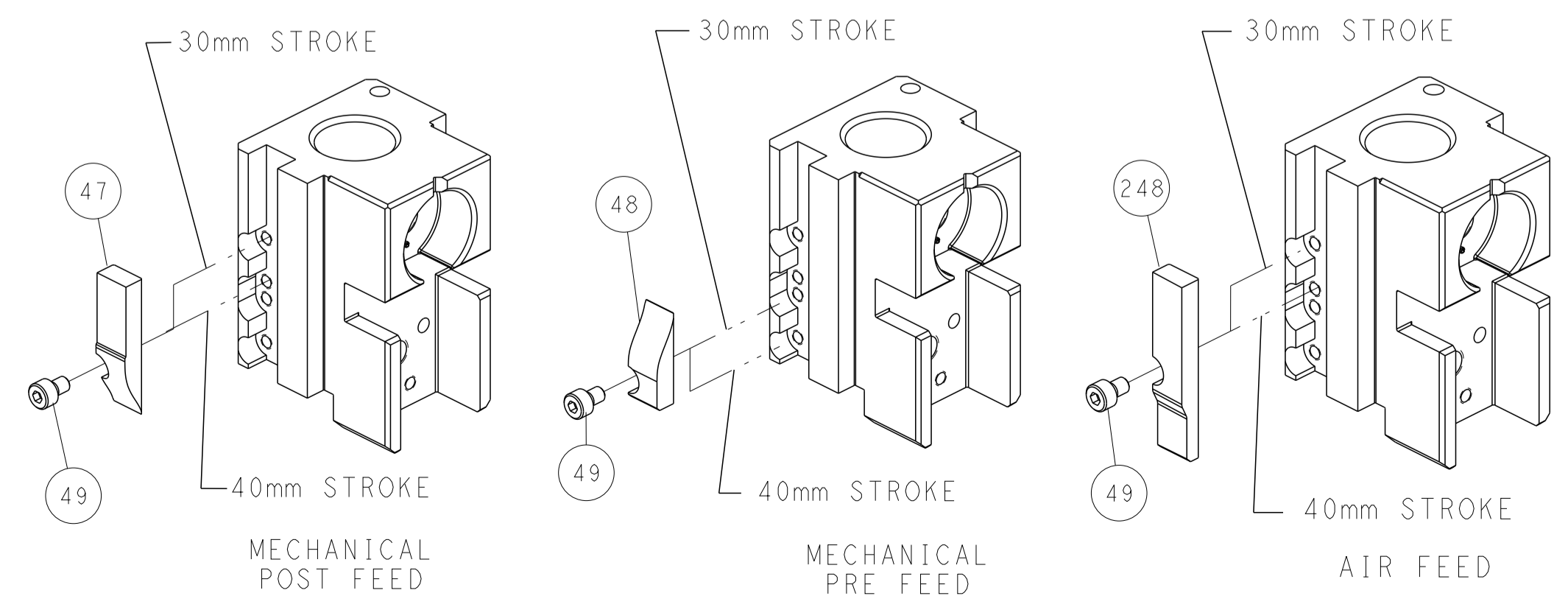
RAM SET-UP



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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: H. HUANG 01APR2015 CHK: L. ZHANG 01APR2015 APVD: J. GUO 01APR2015	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266742 SCALE: 1:2	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: - MATERIAL: -	PRODUCT SPEC: - APPLICATION SPEC: -	RESTRICTED TO: - SHEET 2 OF 4 REV E	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266742-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266742-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266742-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.35 mm [.132]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: YAZAKI TERMINAL FORD CRIMP SPECIFICATION	
TERMINAL NAME: 1.5 SYST SEALED FEMALE TERMINAL	
WIRE STRIP LENGTH 5.00-5.50 mm [1.97-.217 IN]	TERMINAL INSULATION DIAMETER RANGE Ø 1.80-2.10 mm [0.071-.083 IN]
TERMINAL APPLICATION SPECIFICATION 97BG-14474-ADA Rev -	

TERMINALS APPLIED				
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	SEAL INSULATION DIAMETER RANGE
286813-1	7116-4103-02	1572025-1	7158-3030-50	1.2-1.7mm
286813-2	7116-4103-08		OSR SEAL	
		2113681-1	E-1644-00	1.6-2.1mm
		2113614-1	E-1644-01	1.2-1.7mm
		286814-1	7158-3031-90	1.8-2.6mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG 1.00mm2	1.30+/-0.05 [0.051+/-0.002]	5.0
18 AWG 0.75mm2	1.15+/-0.05 [0.045+/-0.002]	6.7

**\*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.

- 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. APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7. TERMINAL LUBRICANT IS RECOMMENDED.

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

-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	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	1-22281-8	SPRING, COMPRESSION	121	
3	-	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	2-690438-2	FRONT STRIP GUIDE	96	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	455888-5	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	
-	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	
5	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338683-8	FEED PAWL	56	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	3-1752356-4	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	2844938-1	PLATE, STRIP GUIDE	29	
-	1	1	455888-3	SPACER, CRIMPER	28	
-	2	2	22281-8	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-2	STRIP GUIDE	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	
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	2119533-1	STRIPPER, SIDE FEED	19	
1	-	1	1	2119806-1	INSERT, SHEAR	13
-	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	3-1803055-4	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5	
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
1	1	1	1	9-1633965-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	1	1	8-1633305-0	CRIMPER, WIRE PREMIUM	1

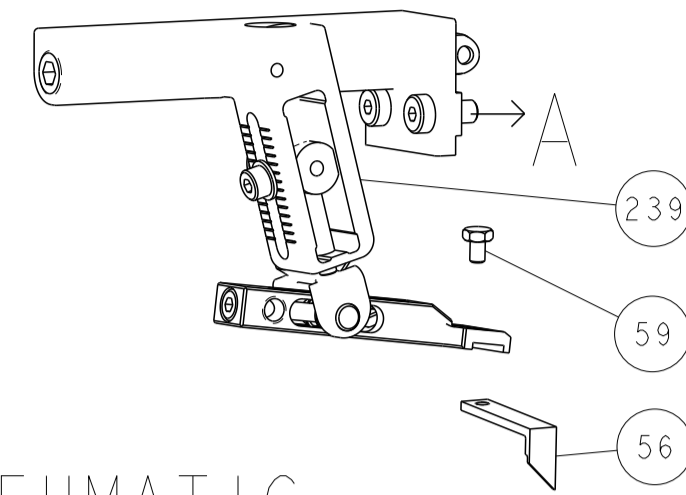
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

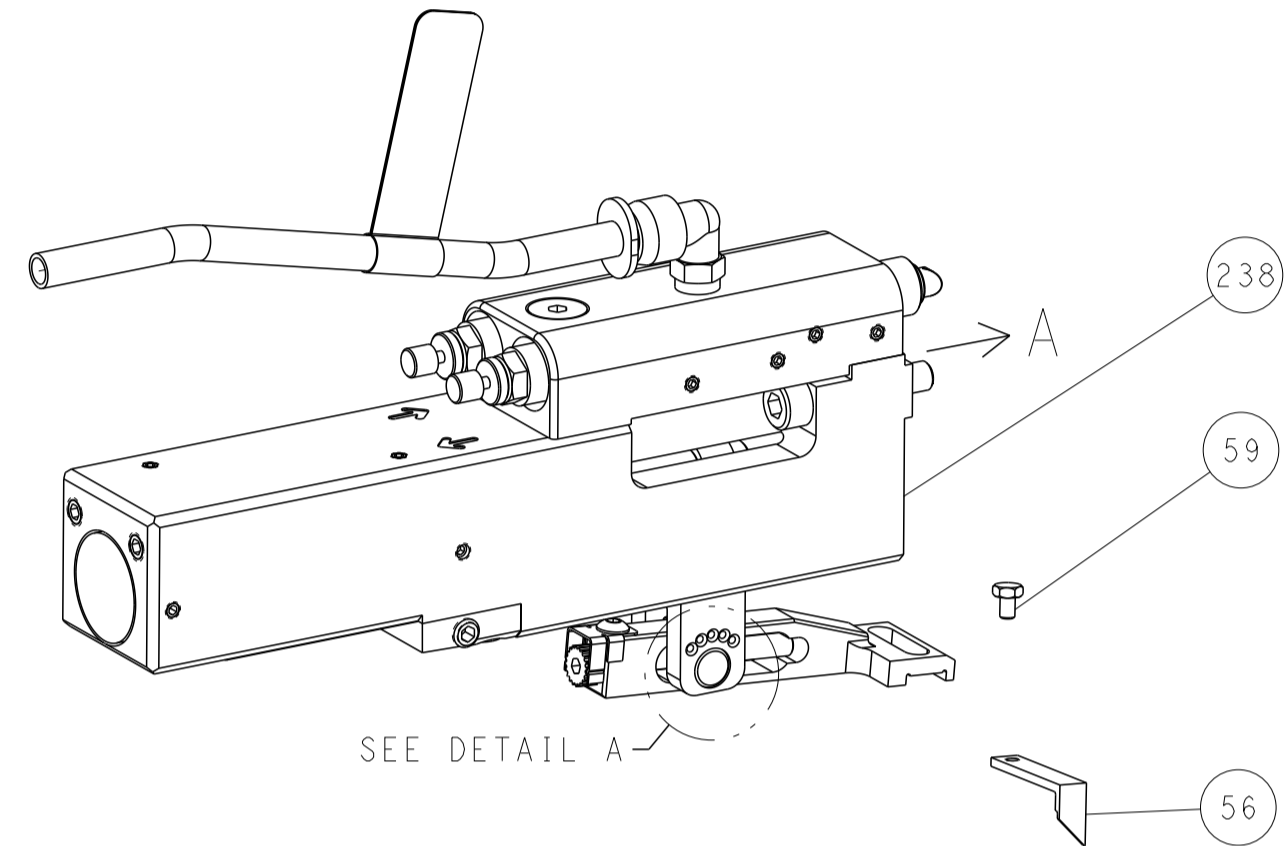
OWN	H. HUANG	01APR2015
CHK	L. ZHANG	01APR2015
APVD	J. GUO	01APR2015
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266742
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 3 OF 4
REV	E	

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

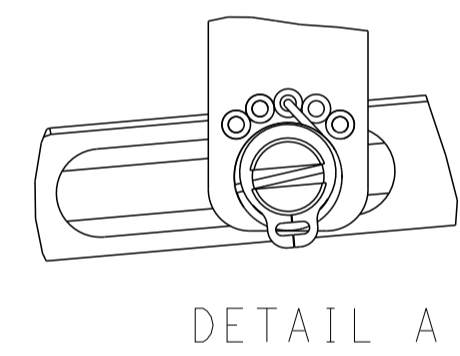
# FEED TYPE MECHANICAL



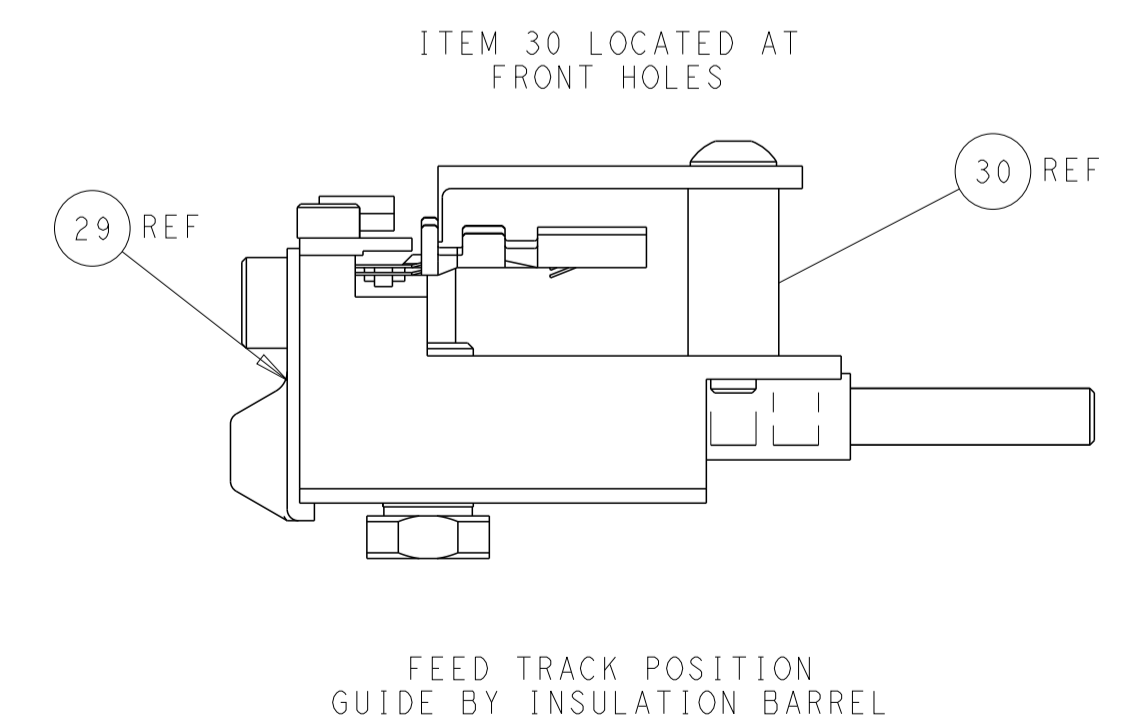
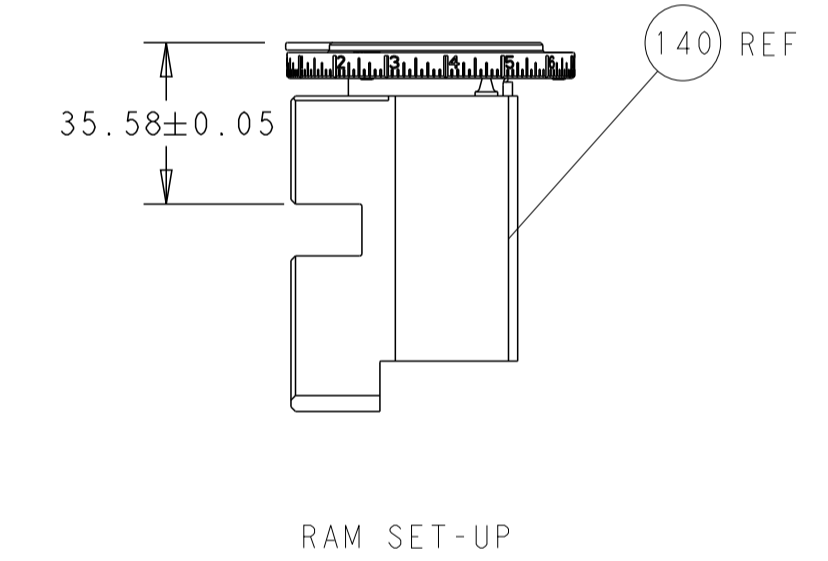
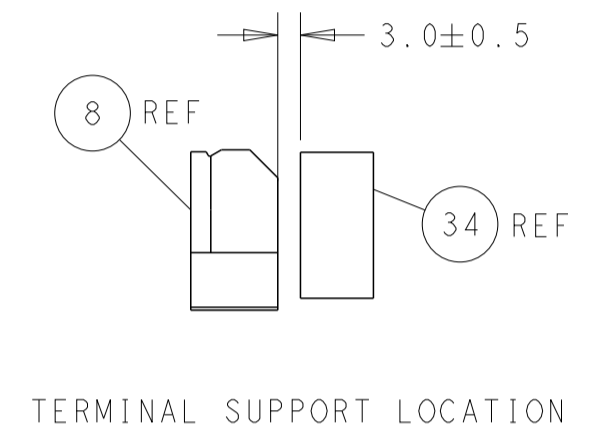
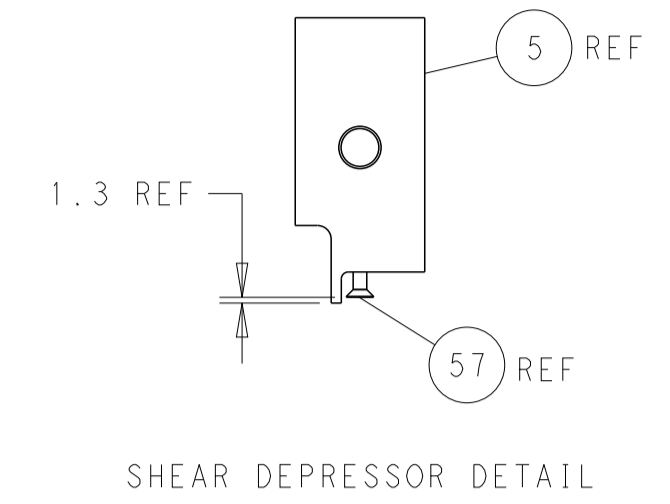
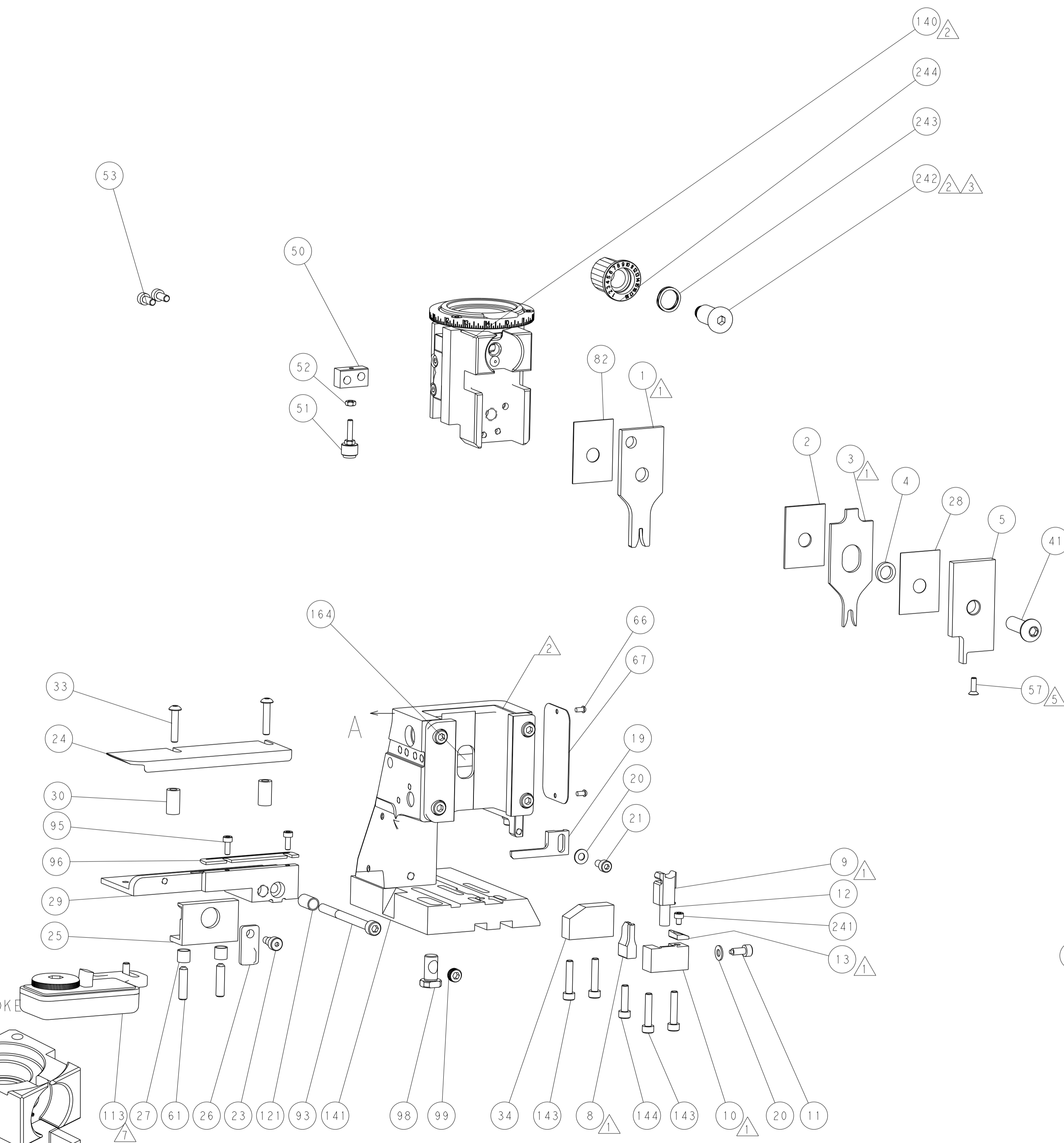
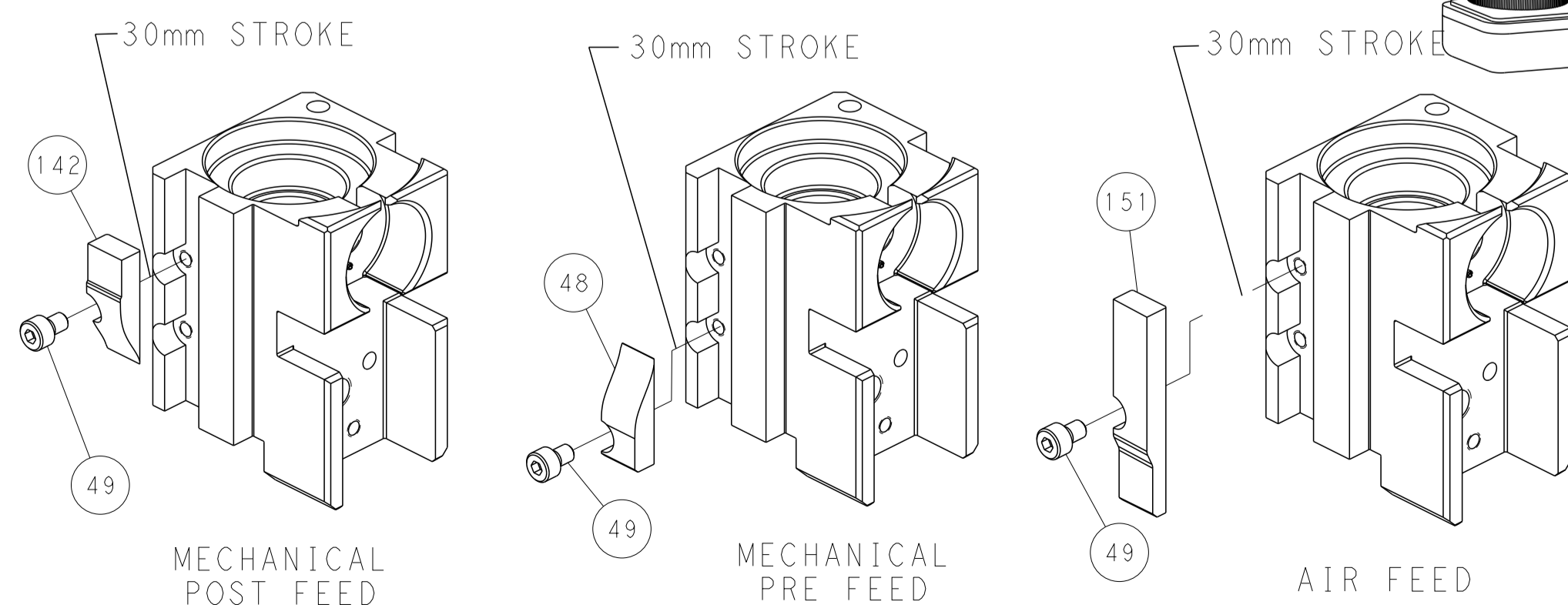
## PNEUMATIC



### 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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2015 BY TYCO ELECTRONICS CORPORATION. THIS DRAWING IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: H. HUANG 01APR2015 CHK: L. ZHANG 01APR2015 APVD: H. GUO 01APR2015	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 APPLICATION SPEC: - PRODUCT SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266742	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: E
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION