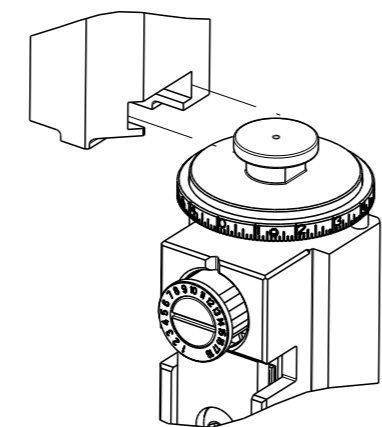


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266531-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266531-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266531-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	3.00 mm [.118]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 6.3mm ISO RELAY			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.30-6.70 mm [.248-.264 IN]		Ø1.20-2.00 mm [.047-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	320100530 Rev -	-	-
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	RNUR TERMINAL
1572603-1	320100530	1572603-2	7703497823

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00R3	1.70+/-0.05 [.067+/-0.002]	4.6
0.50mm2	1.45+/-0.05 [.057+/-0.002]	7.3
0.3503	1.40+/-0.05 [.055+/-0.002]	7.9



- 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

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					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	1		ORIGINAL	17OCT2014	GH	TE
		A		RELEASED	17DEC2014	JH	TE
		A1		ECR-15-000516	13JAN2015	KH	TE
		B		ECR-19-017877	19NOV2019	FJ	TE

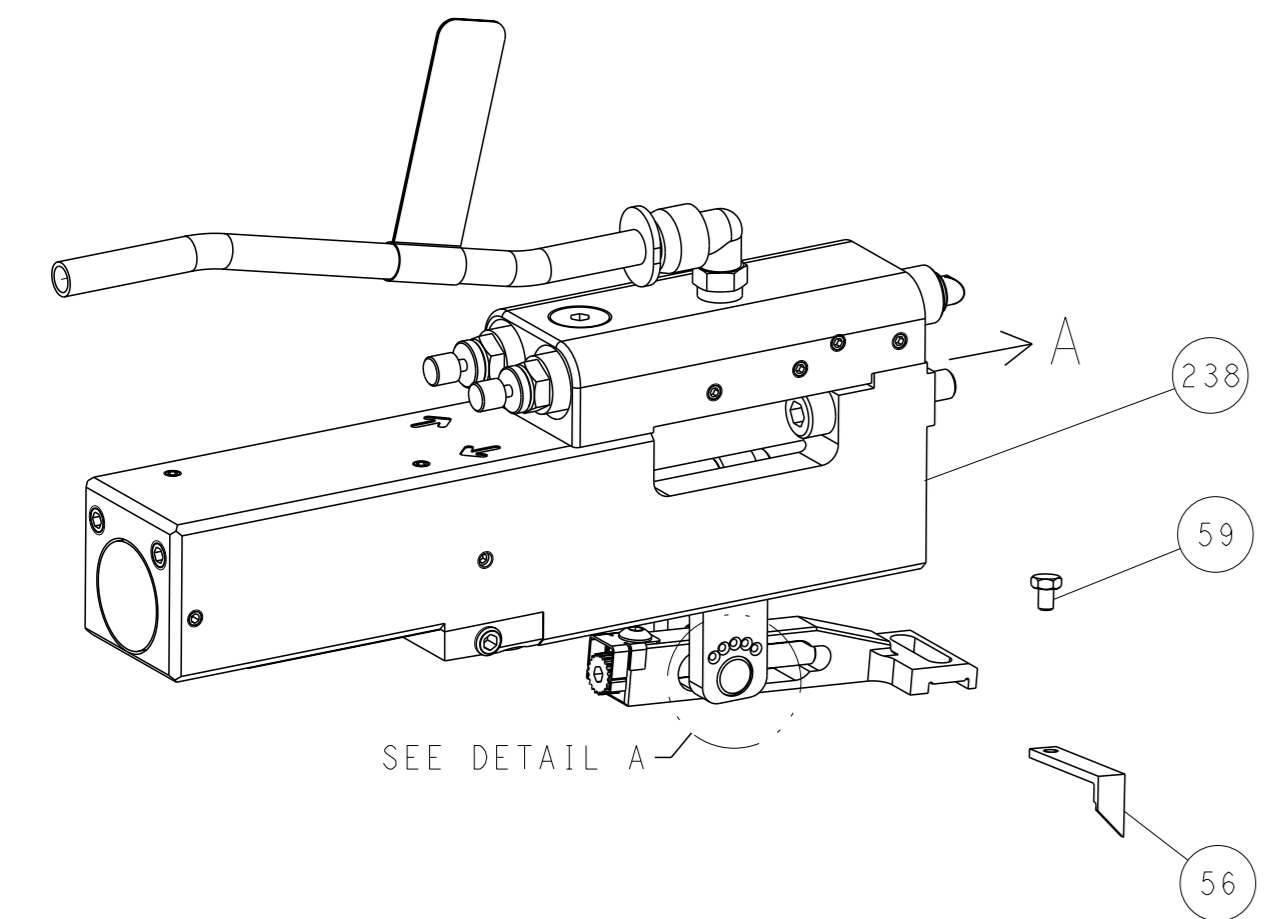
-	1	1	1803078-3	SPACER, PRECISION	259
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-2	AIR FEED MODULE	238
	1	1	2-1752354-1	STANDOFF,HOLD-DOWN	180
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-6	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
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-8	FEED PAWL	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-2	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	1-356885-4	STOP, SHEAR	11
	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	1	1	1803095-6	FLOATING SHEAR, FRONT	9
	1	2	1-1803171-8	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-7	BLOCK, CRIMPER SPACER	4
	1	2	1803209-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
	1	2	7-1633664-6	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001
	ANGLES ±.0001	FINISH			
MATERIAL		WEIGHT		SCALE	1:2
				SHEET	1 OF 4
				REV	B

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

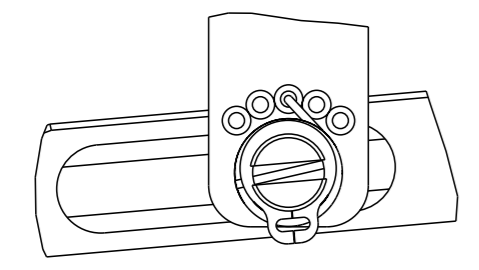
FEED TYPE

PNEUMATIC



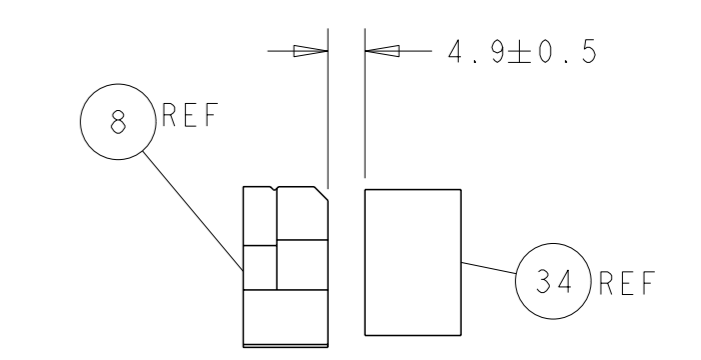
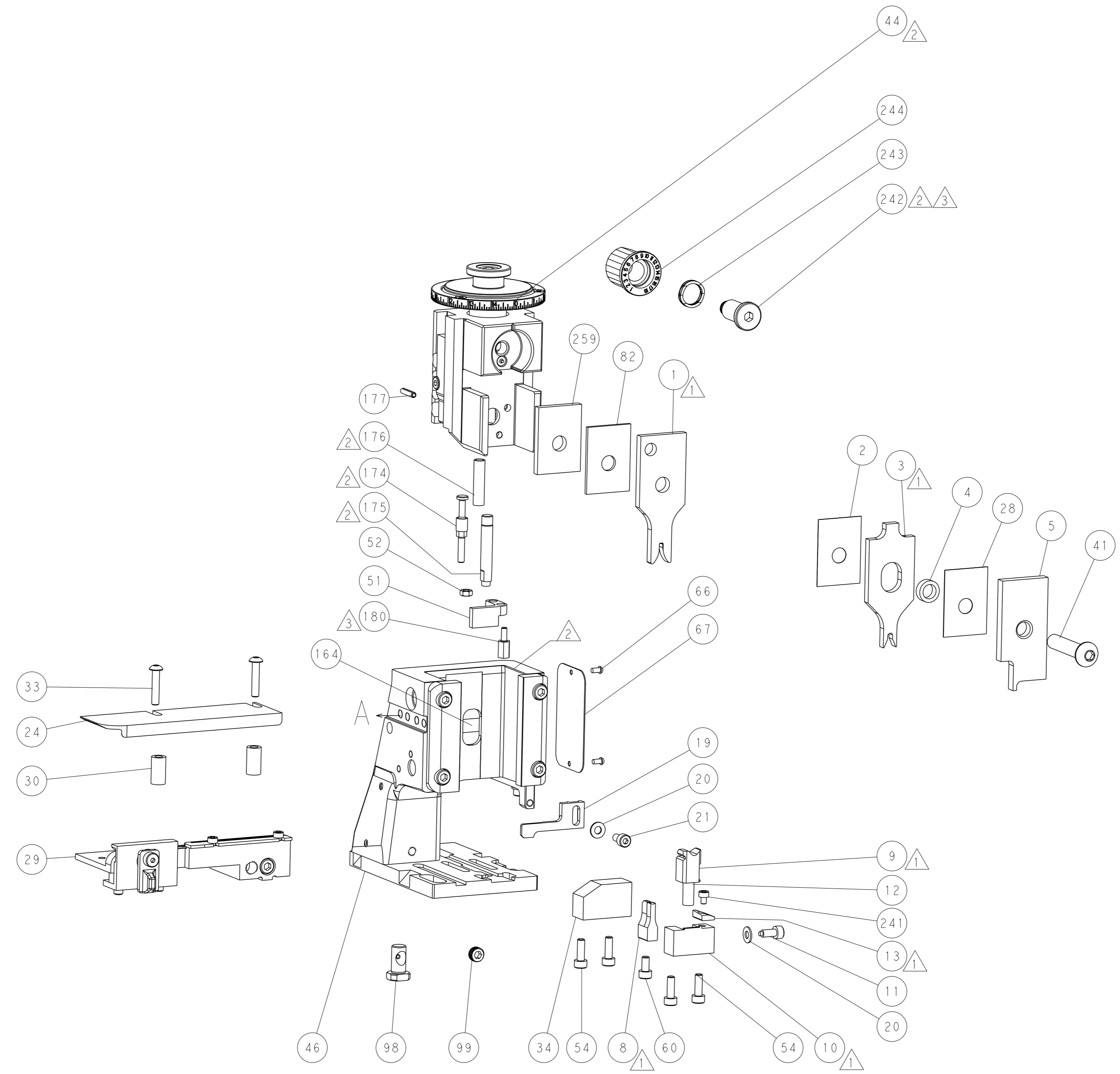
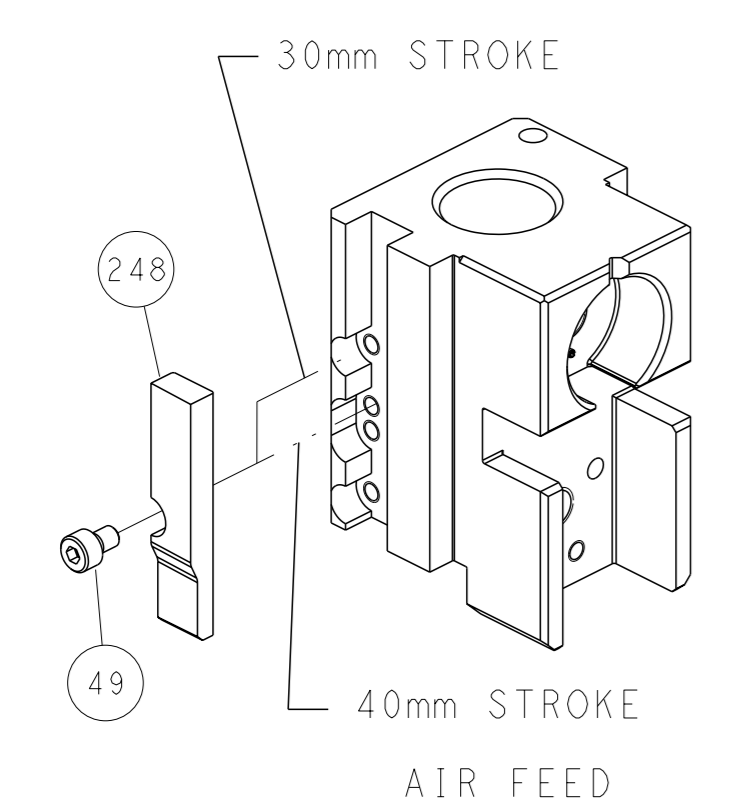
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

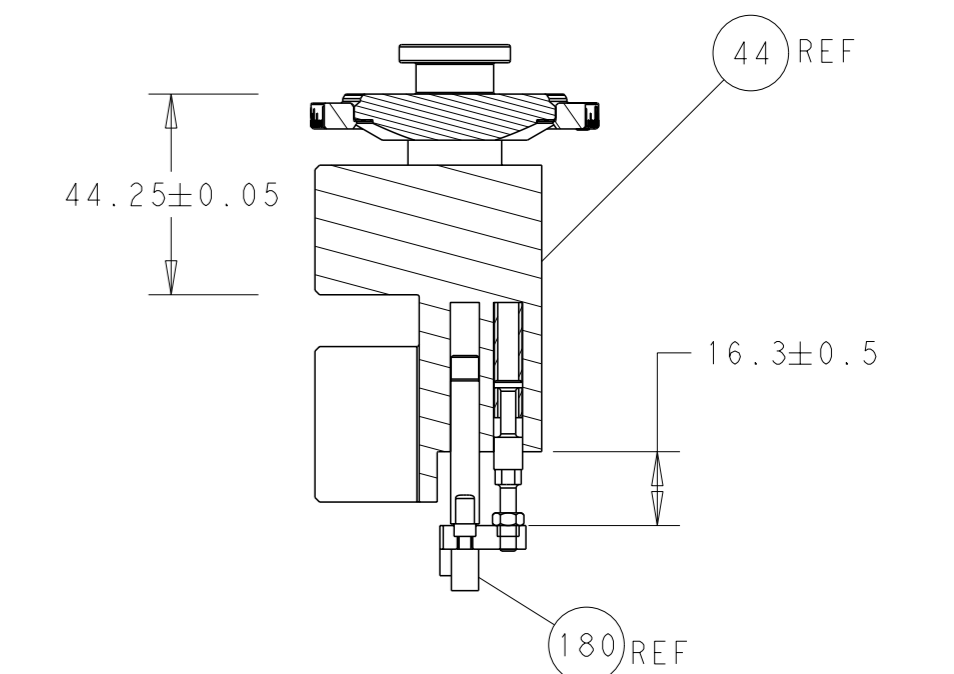


DETAIL A

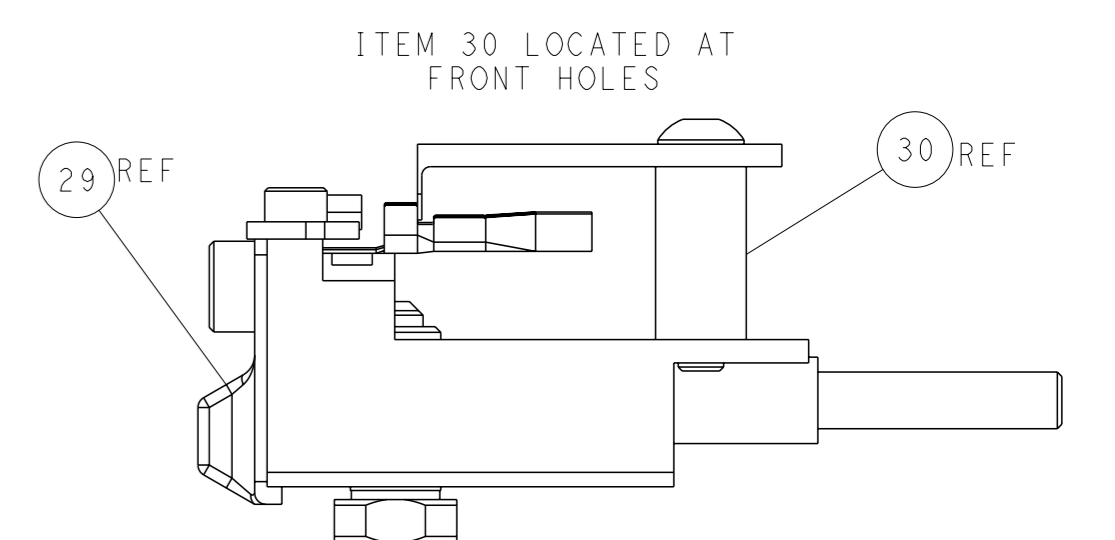
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



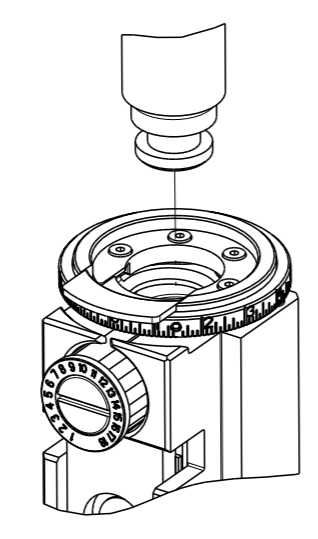
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: HOFFNER 16OCT2014 CHK: T. ELBIN 17OCT2014 APVD: T. ELBIN 17OCT2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH ±.	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266531	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:2 SHEET: 2 of 4 REV: B	RESTRICTED TO:
Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266531-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266531-7	A	CRIMP TOOLING KIT	-

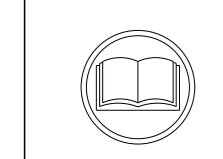
PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	3.00 mm [.118]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 6.3mm ISO RELAY			
WIRE STRIP LENGTH 6.30-6.70 mm [.248-.264 IN]		INSULATION DIAMETER RANGE Ø1.20-2.00 mm [.047-.079 IN]	
TERMINAL APPLICATION SPECIFICATION 320100530 Rev -			
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	RNUR TERMINAL
1572603-1	320100530	1572603-2	7703497823

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00R3	1.70+/-0.05 [.067+/-0.002]	4.6
0.50mm2	1.45+/-0.05 [.057+/-0.002]	7.3
0.35D3	1.40+/-0.05 [.055+/-0.002]	7.9



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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)

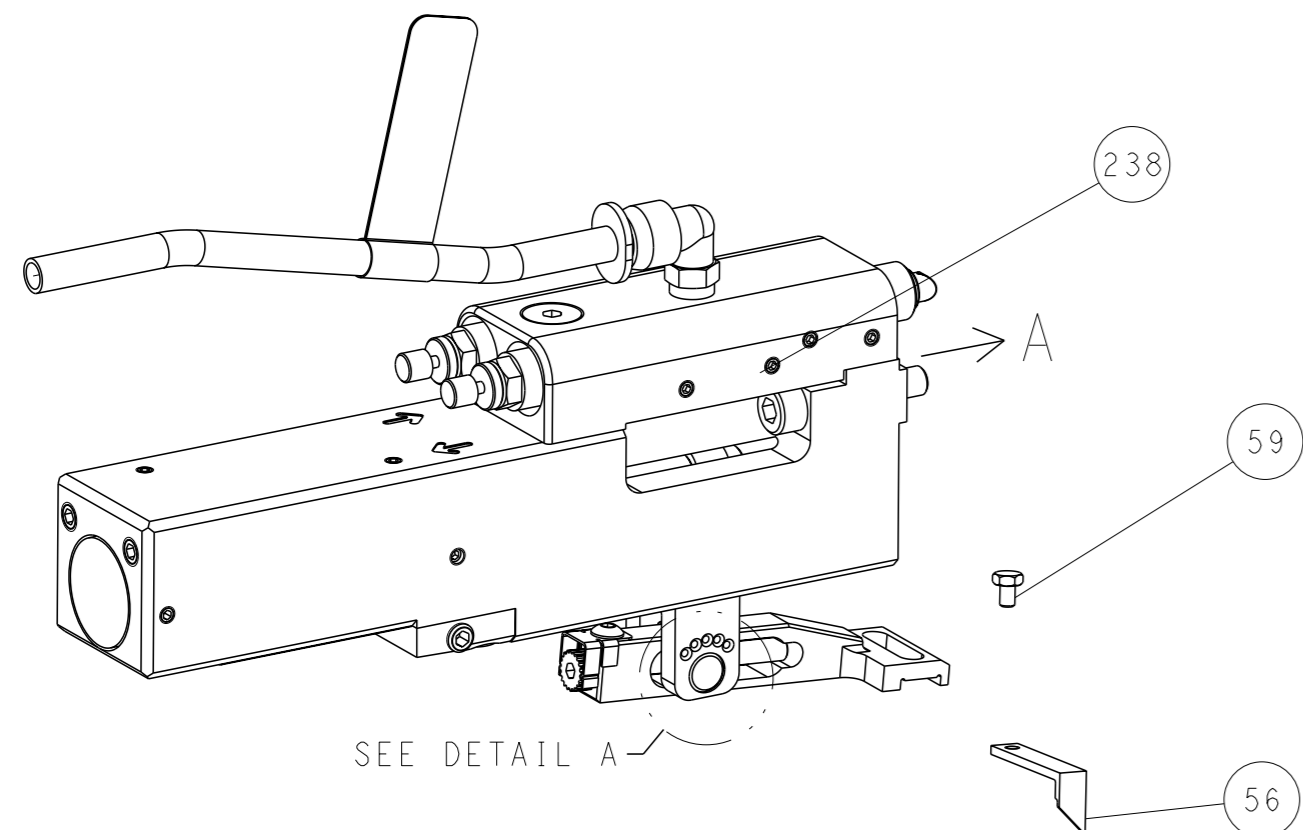
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1803078-3	SPACER, PRECISION	259
-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-2	AIR FEED MODULE	238
-	1	2-1752354-1	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-455888-6	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1338683-8	FEED PAWL	56
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	1	1320928-2	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1-1803171-8	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	2-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1803209-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	455888-1	SPACER, CRIMPER	2
-	1	7-1633664-6	CRIMPER, WIRE	1
-	77	-22	PART NO	ITEM NO

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±.		OWN: HOFFNER 18OCT2014 CHK: T. ELBIN 17OCT2014 APVD: T. ELBIN 17OCT2014 PRODUCT SPEC APPLICATION SPEC		NAME: STE TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator	
MATERIAL:		WEIGHT:		SIZE: A1 00779		CAGE CODE: C=2266531	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 3 of 4 REV B	

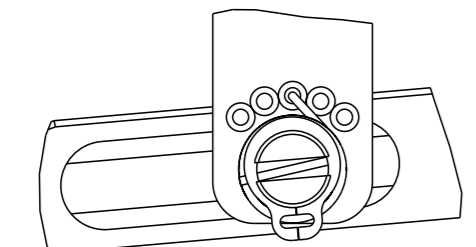
LOC	DIST	REVISIONS			
		REV	DATE	OWN	APVD
A	66	1	SEE SHEET 1	-	-

FEED TYPE PNEUMATIC



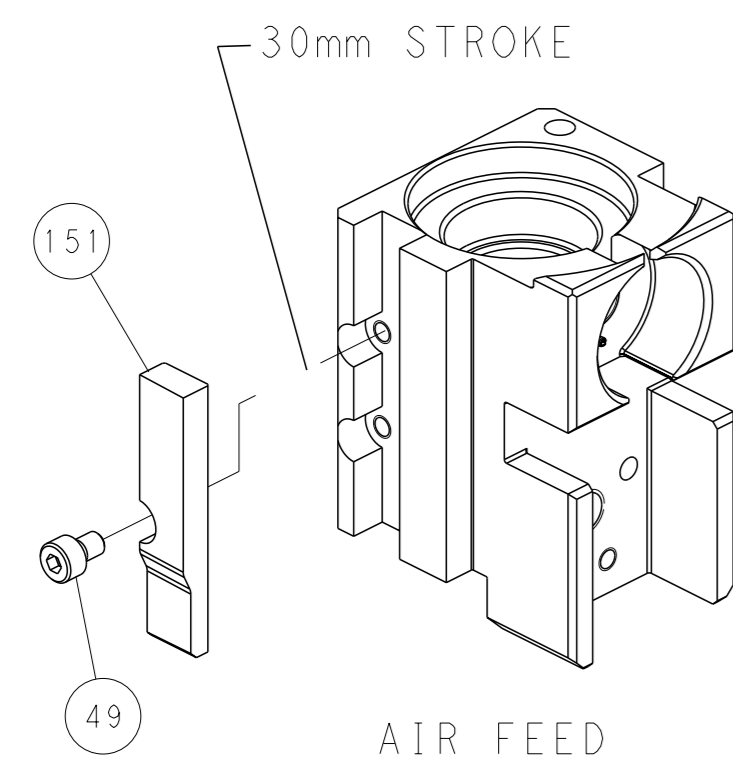
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

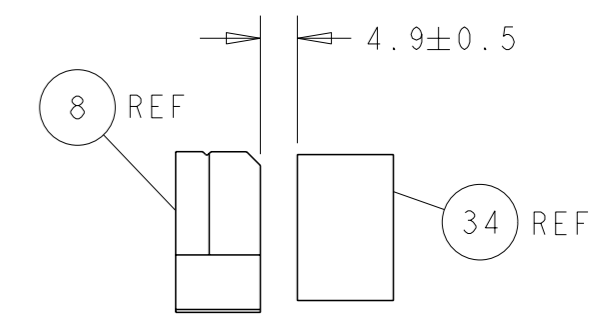
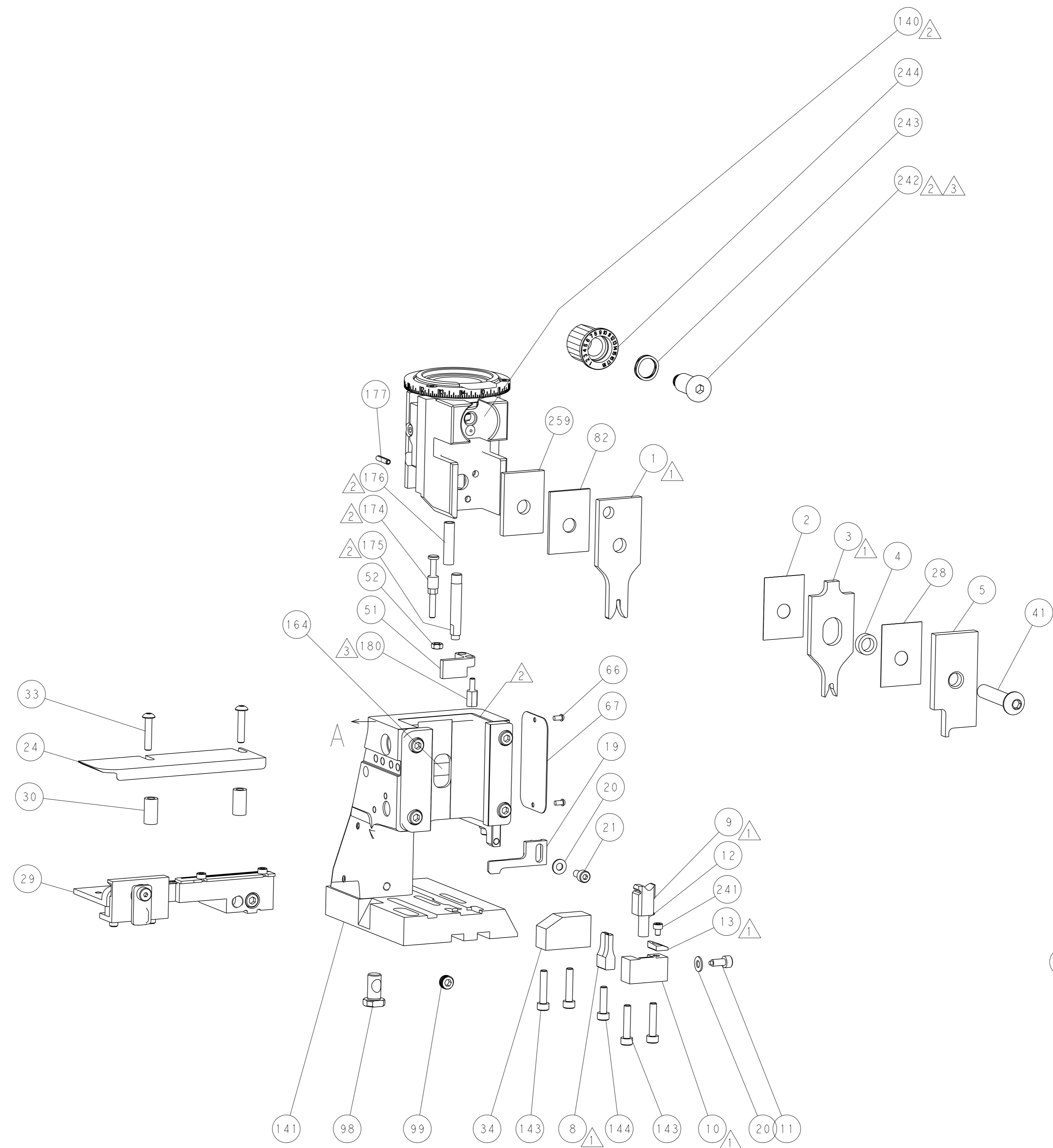


DETAIL A

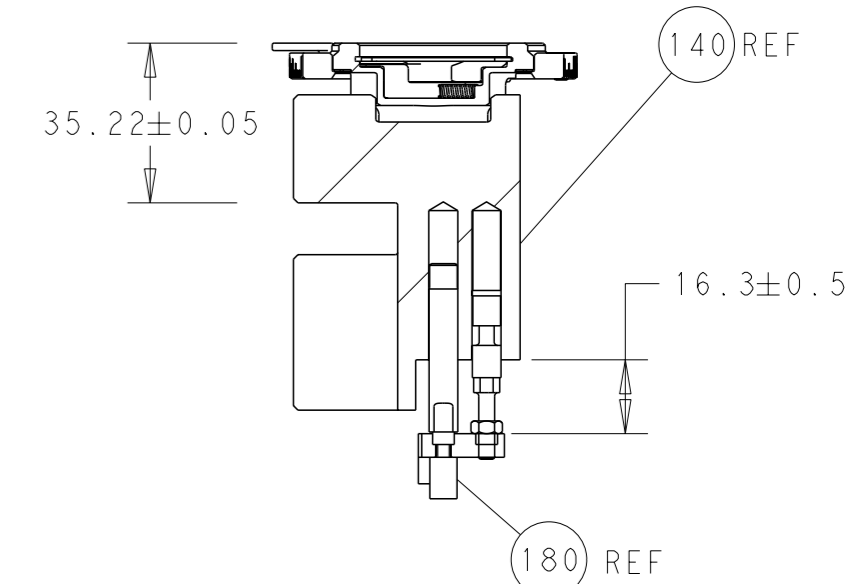
CAM POSITION



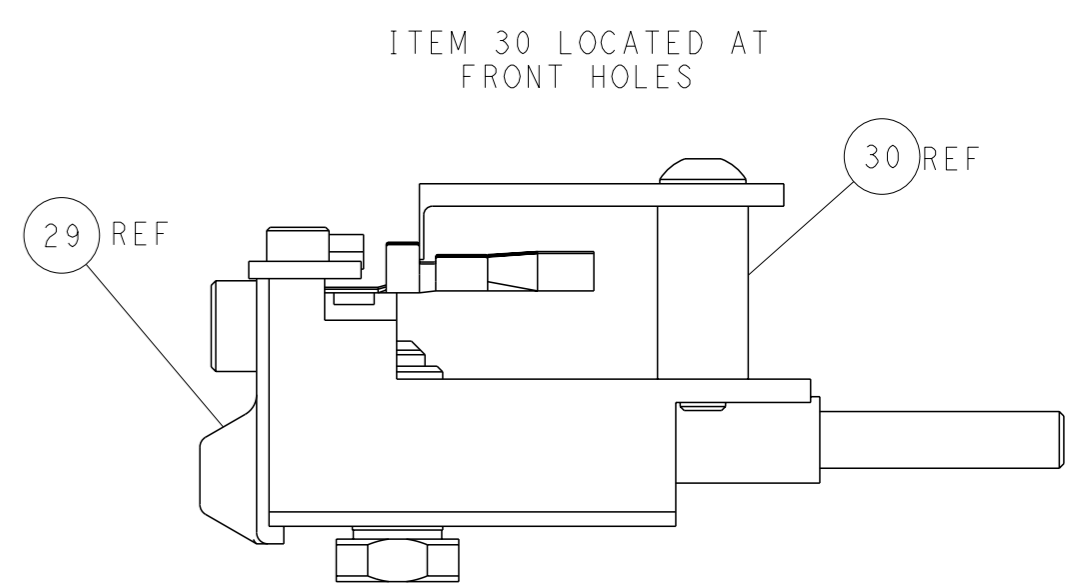
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: HOFFNER 16OCT2014 CHK: TELBIN 17OCT2014 APVD: TELBIN 17OCT2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH *		NAME: Ocean Side Feed Applicator APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266531 SHEET 4 OF 4 REV B
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	