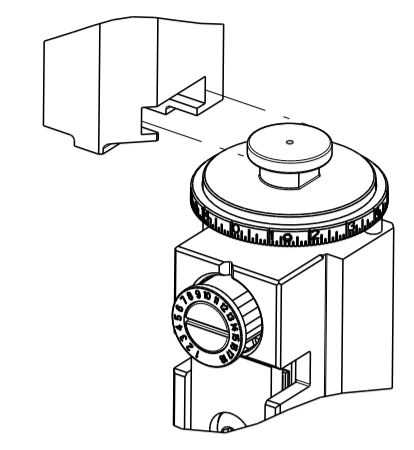


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266835-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266835-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266835-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266835-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266835-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.94 mm [.037]	F
INSUL	0.98 mm [.039]	F

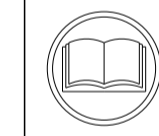
APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: CLIK-MATE WIRE TO BOARD TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.50-1.90 mm [.059-.075 IN]	Ø0.80-1.20 mm [.031-.047 IN]		
TERMINAL APPLICATION SPECIFICATION	ATS-639025000 Rev C		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113725-1	502579-0000	2819168-1	502579-0000

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: CLIK-MATE WIRE TO BOARD TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.50-1.90 mm [.059-.075 IN]	Ø0.80-1.20 mm [.031-.047 IN]		
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113725-1	502579-0000	2819168-1	502579-0000

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG or 0.20mm ²	0.625+/-0.025 [.0246+/- .001]	5.5
26 AWG	0.615+/-0.025 [.0242+/- .001]	5.8
28 AWG or 0.08mm ²	0.585+/-0.025 [.0230+/- .001]	6.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.22mm ²	0.64+/-0.025 [.025+/- .001]	5.4



- 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 THE CUSTOMER ACKNOWLEDGES THAT THE TERMINAL MANUFACTURER'S CRIMP SPECIFICATIONS ARE UNKNOWN. IN ADDITION THE CUSTOMER ACKNOWLEDGES THAT TE CONNECTIVITY HAS CALCULATED CRIMP SPECIFICATIONS FOR THIS PRODUCT THAT MAY NOT MATCH THE TERMINAL MANUFACTURER'S SPECIFICATIONS. TE CONNECTIVITY USES ACCEPTED PRACTICES TO DESIGN TERMINATION TOOLING FOR NON-TE CONNECTIVITY PRODUCTS. HOWEVER, **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE TOOLING WILL RELIABLY APPLY NON-TE CONNECTIVITY PRODUCTS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. THE CUSTOMER ASSUMES ALL RESPONSIBILITY AND LIABILITY FOR THE PERFORMANCE OF TERMINATED ASSEMBLIES USING SUCH TOOLING.** THE CUSTOMER EXPRESSLY INDEMNIFIES TE CONNECTIVITY AND SHALL HOLD TE CONNECTIVITY HARMLESS FROM ALL CLAIMS, DEMANDS, LOSSES, EXPENSES AND LIABILITIES RESULTING FROM THE USE OF THIS TOOLING ON NON-TE CONNECTIVITY PRODUCTS.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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)

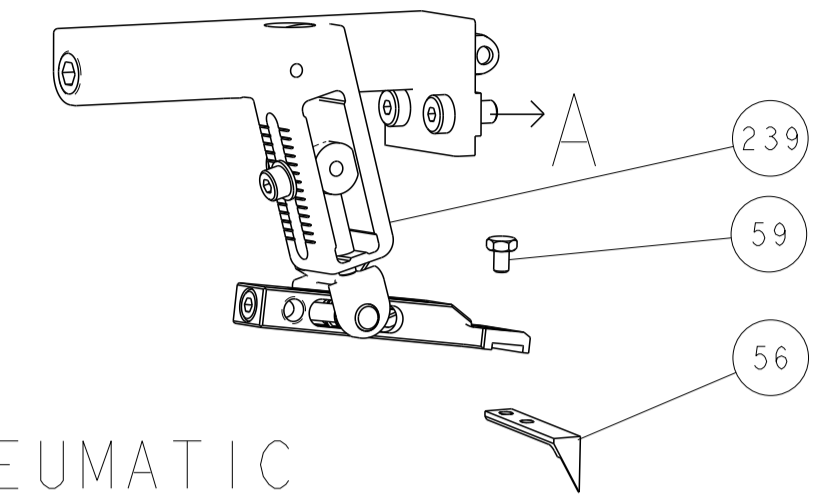
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		D		ECR-18-008966	11JUN2018	MZ	TE
		E		ECR-20-007954	03JUN2020	TB	GB
		E1		ECR-20-013488	22SEP2020	JWC	GB
		F		ECR-21-006871	14JUL2021	JWC	TE

-	1	1	1	1	1-1633764-7	HOLD DOWN, TERMINAL	262
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	261
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	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	1-1752354-1	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	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	1-455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2-2119791-1	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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	1338685-3	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-8	HOLDDOWN, TERMINAL	51
-	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-4	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	1803095-6	FLOATING SHEAR, FRONT	9
1	2	2	1	1	6-1803318-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-3	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-6	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2-1803260-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2
1	2	2	1	1	1-1803482-1	CRIMPER, WIRE	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

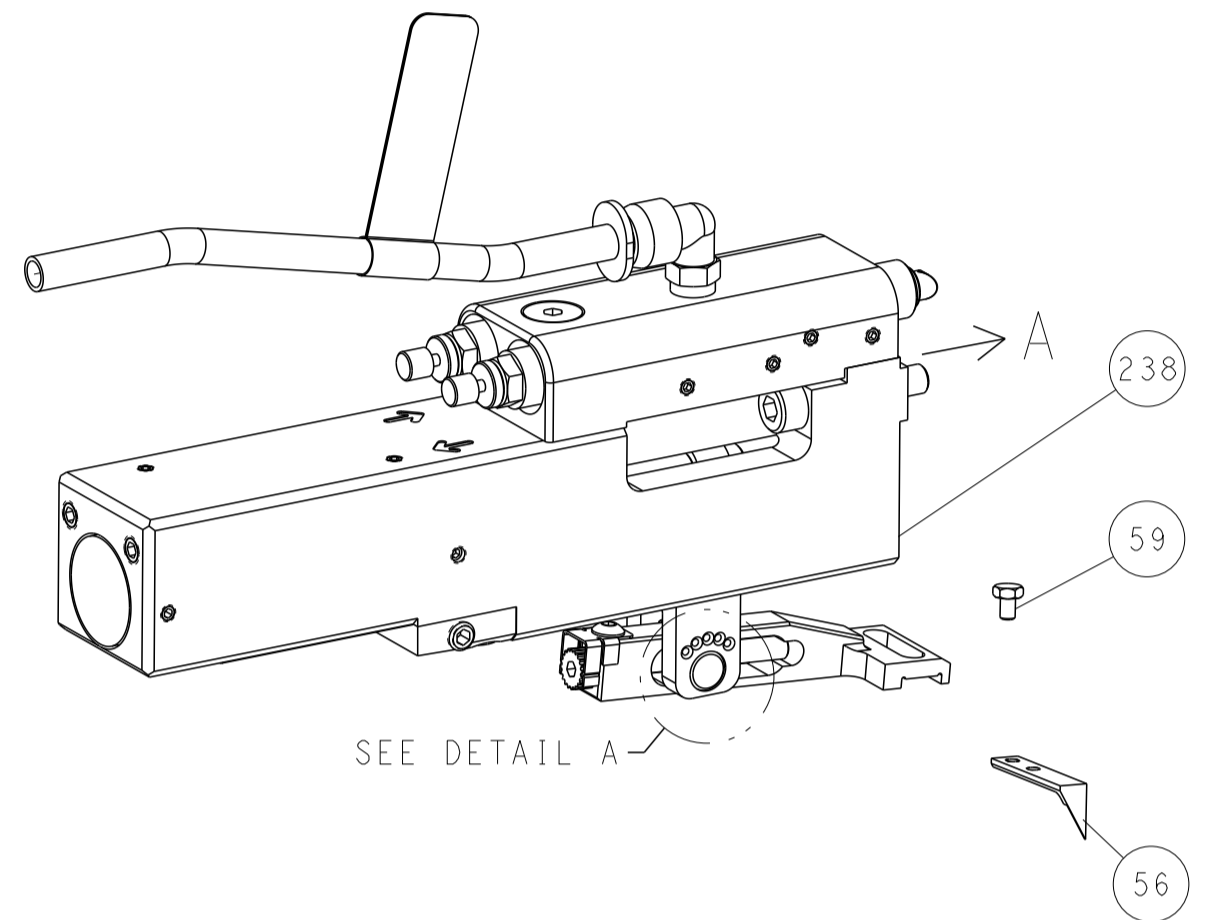
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE	TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	B. WEAVER	T. ELBIN	09JUL2015	Harrisburg, PA 17105-3608	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	T. ELBIN	09JUL2015	NAME	
	FINISH						Ocean Side Feed Applicator	
MATERIAL				WEIGHT			SIZE	CAGE CODE
							A1	00779
							DRAWING NO	SCALE
							©=2266835	1:2
							SHEET	REV
							1	F

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

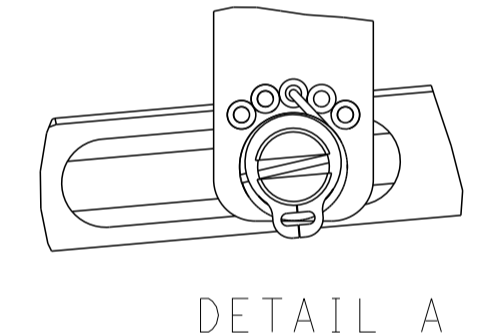
FEED TYPE MECHANICAL



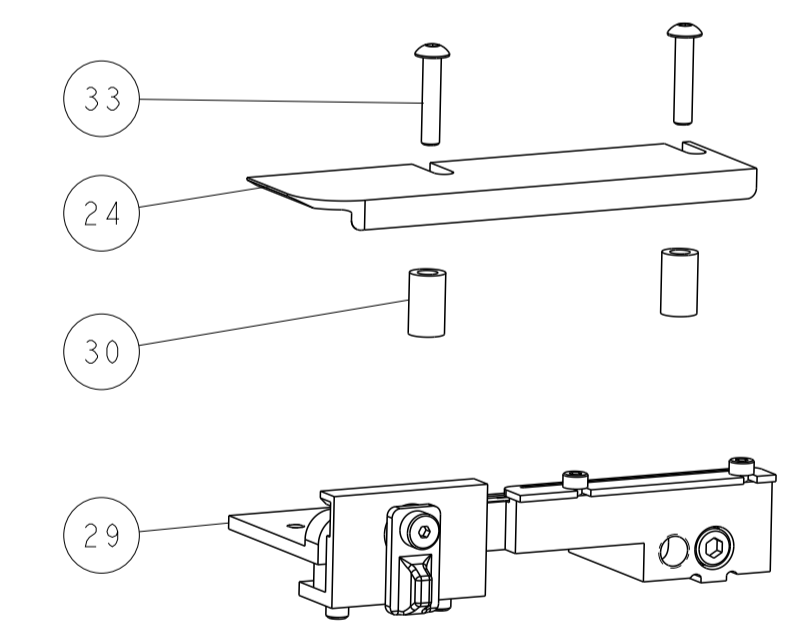
PNEUMATIC



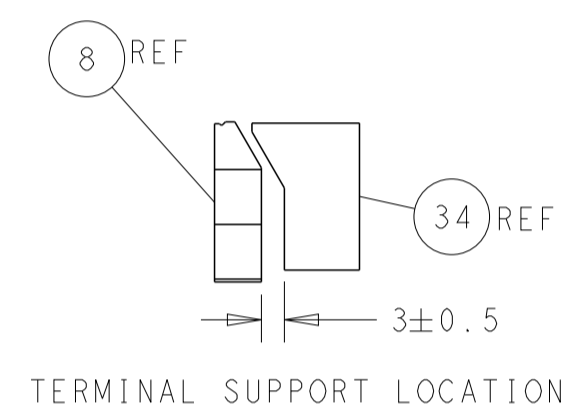
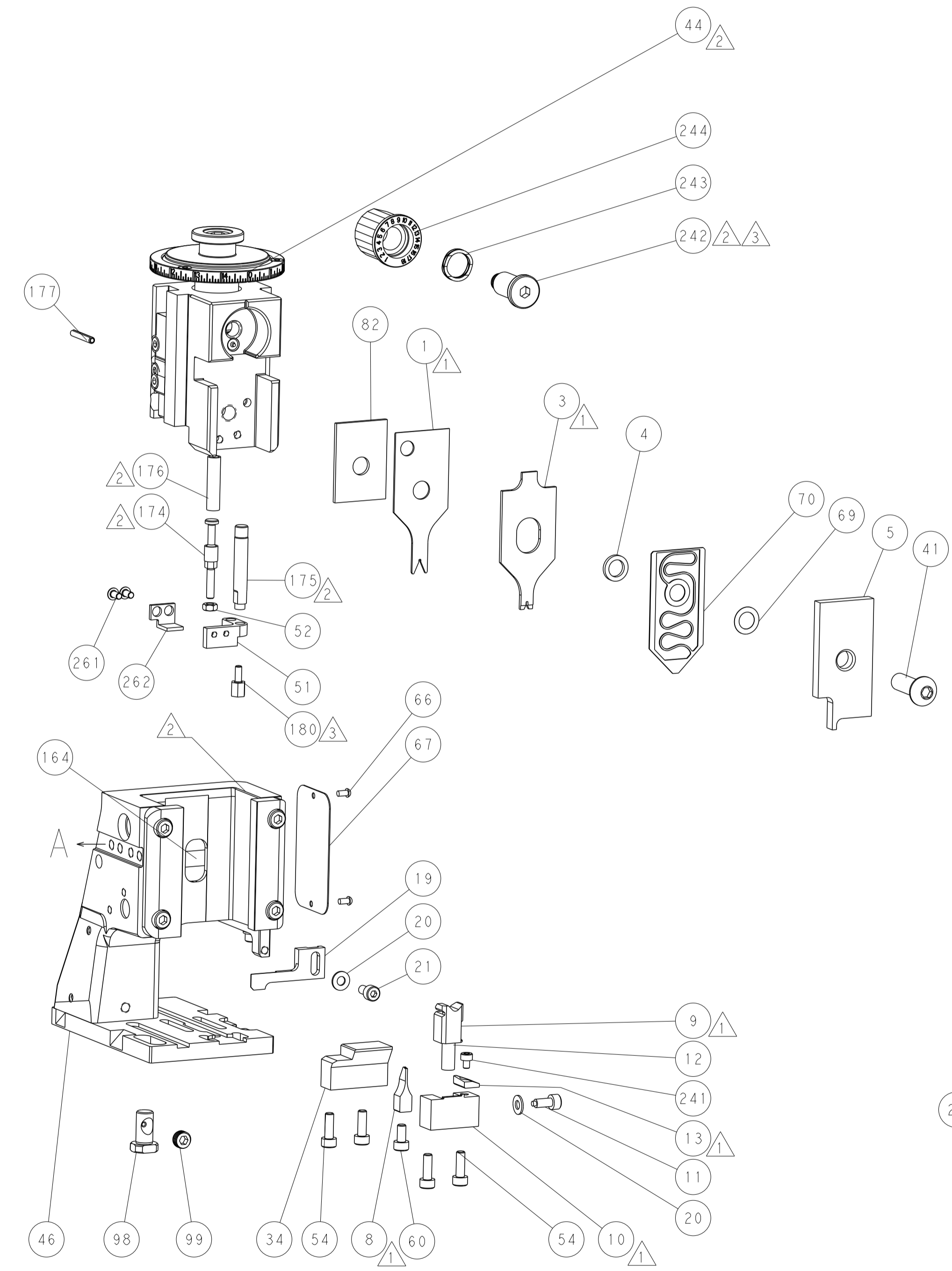
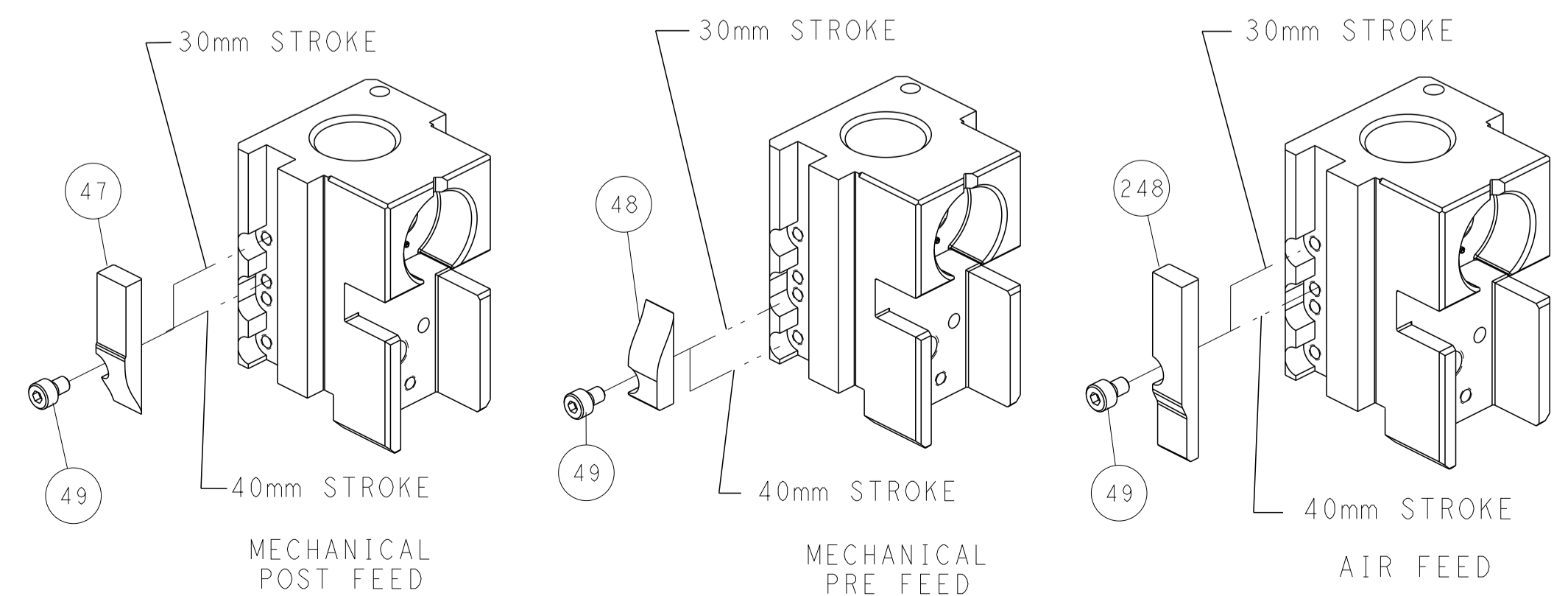
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



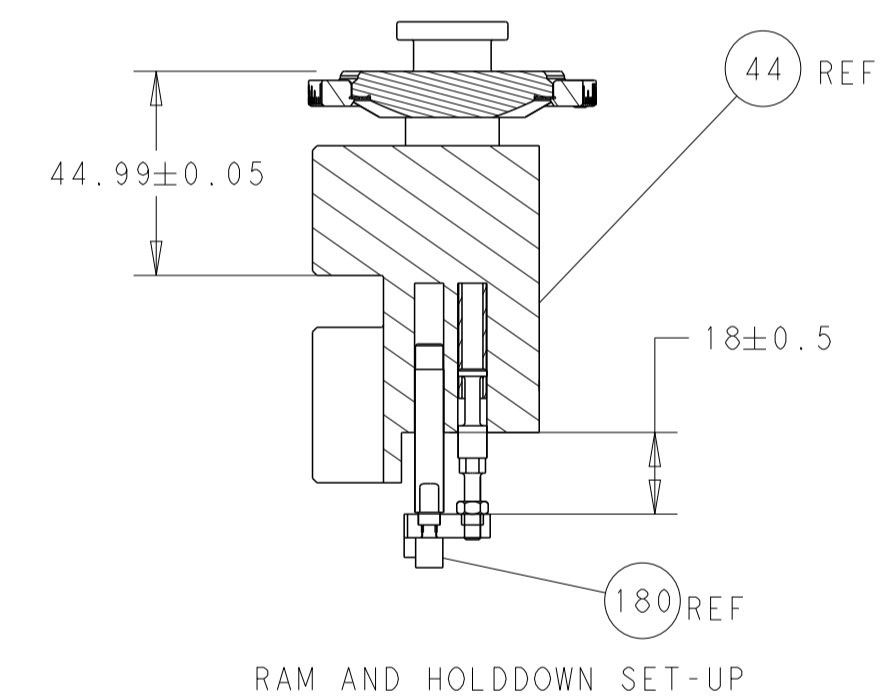
DETAIL A



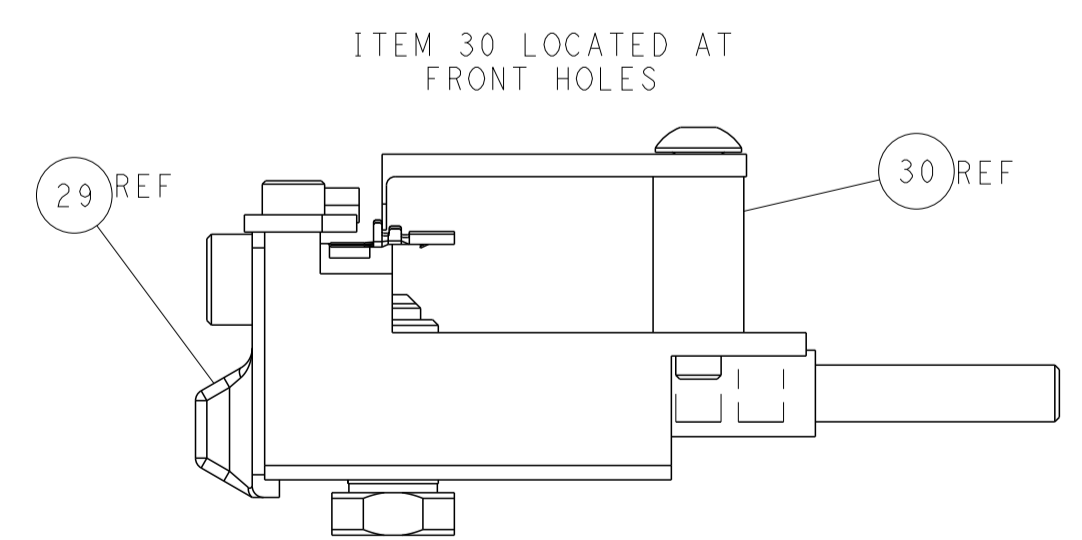
CAM POSITIONS



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		DWN B. WEAVER 09JUL2015 CHK T. ELBIN 09JUL2015 APVD T. ELBIN 09JUL2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2266835 SCALE 1:2 SHEET 2 OF 4 REV F	
MATERIAL:				TE Connectivity Harrisburg, PA 17105-3608			

