

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266975-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266975-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266975-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266975-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266975-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.68 mm [.145]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: US208 UNSEALED FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-5.00 mm [.157-.197 IN]	Ø1.80-2.40 mm [.071-.094 IN]		
TERMINAL APPLICATION SPECIFICATION			
US280 UNSEALED TERMINAL Rev 2006/3/2			
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
1572955-1	8100-4444	1572955-3	15483875
1572955-2	8100-4408		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: US208 UNSEALED FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-5.00 mm [.157-.197 IN]	Ø1.80-2.40 mm [.071-.094 IN]		
TERMINAL APPLICATION SPECIFICATION			
-			
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
1572955-1	8100-4444		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.35+/-0.05 [.053+/- .002]	4.6
0.5 X 0.5mm2	1.35+/-0.05 [.053+/- .002]	4.7
0.80mm2	1.30+/-0.05 [.051+/- .002]	5.2
0.35 X 0.35mm2	1.20+/-0.05 [.047+/- .002]	6.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.85mm2	1.32+/-0.05 [.052+/- .002]	5.0

- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN THE TERMINAL MANUFACTURER'S SPECIFICATIONS. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN THE MANUFACTURER'S APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION AND OBTAIN APPROVAL FROM TERMINAL MANUFACTURER FOR THIS CUSTOM REQUIREMENT.

***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)

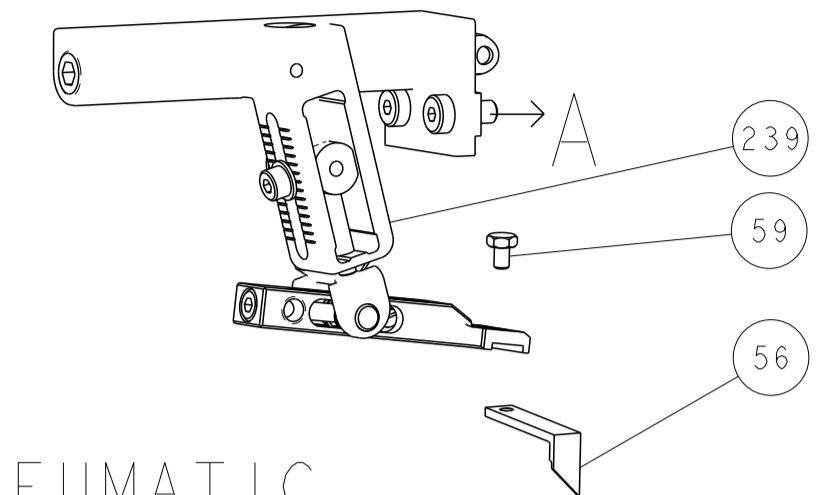
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		B		ECR-18-010251	02JUL2018	KH	TE
		C		ECR-19-009777	06JUL2019	TB	TE

-	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	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	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752356-3	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	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	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	
-	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	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	5-1633920-3	ANVIL, COMBINATION	8
-	1	1	1	1	1	1-240641-4	SPACER	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	4-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-8	SPACER, CRIMPER	2	
-	1	2	2	1	1	456405-8	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

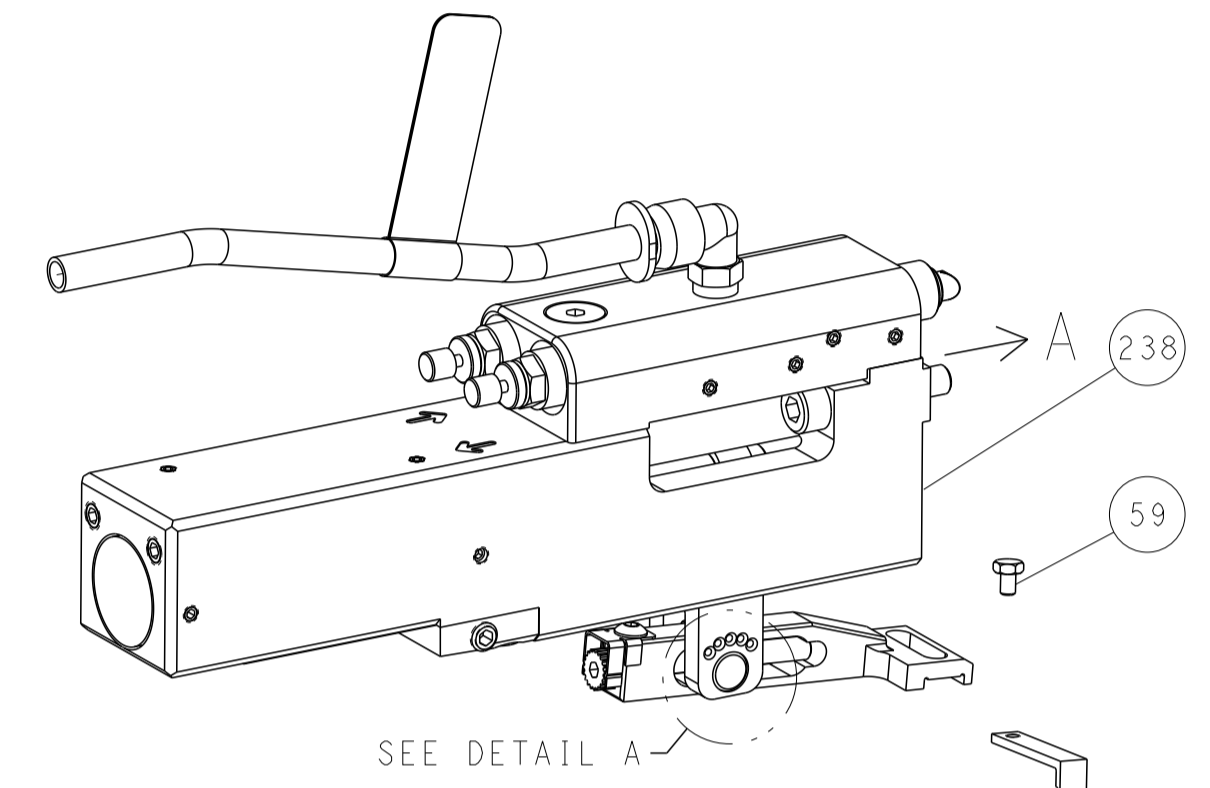
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MATERIAL		FINISH		WEIGHT		SCALE	
-		-		-		1:2	
-		-		-		SHEET 1 OF 4	
-		-		-		REV C	

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

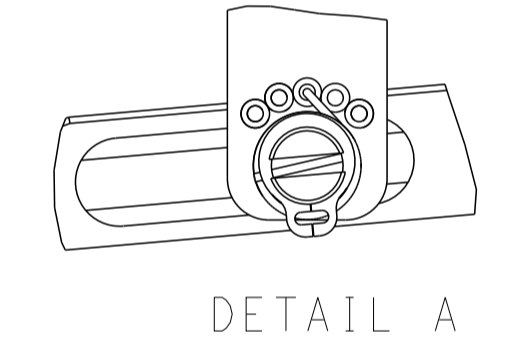
FEED TYPE MECHANICAL



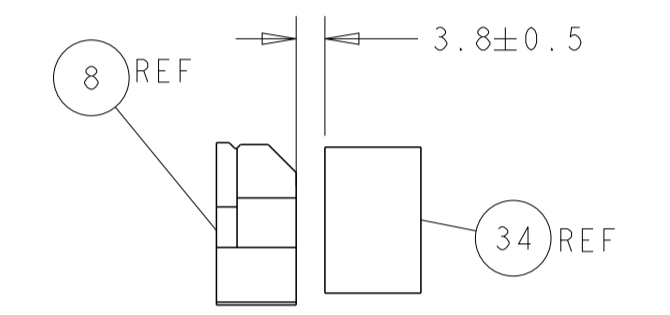
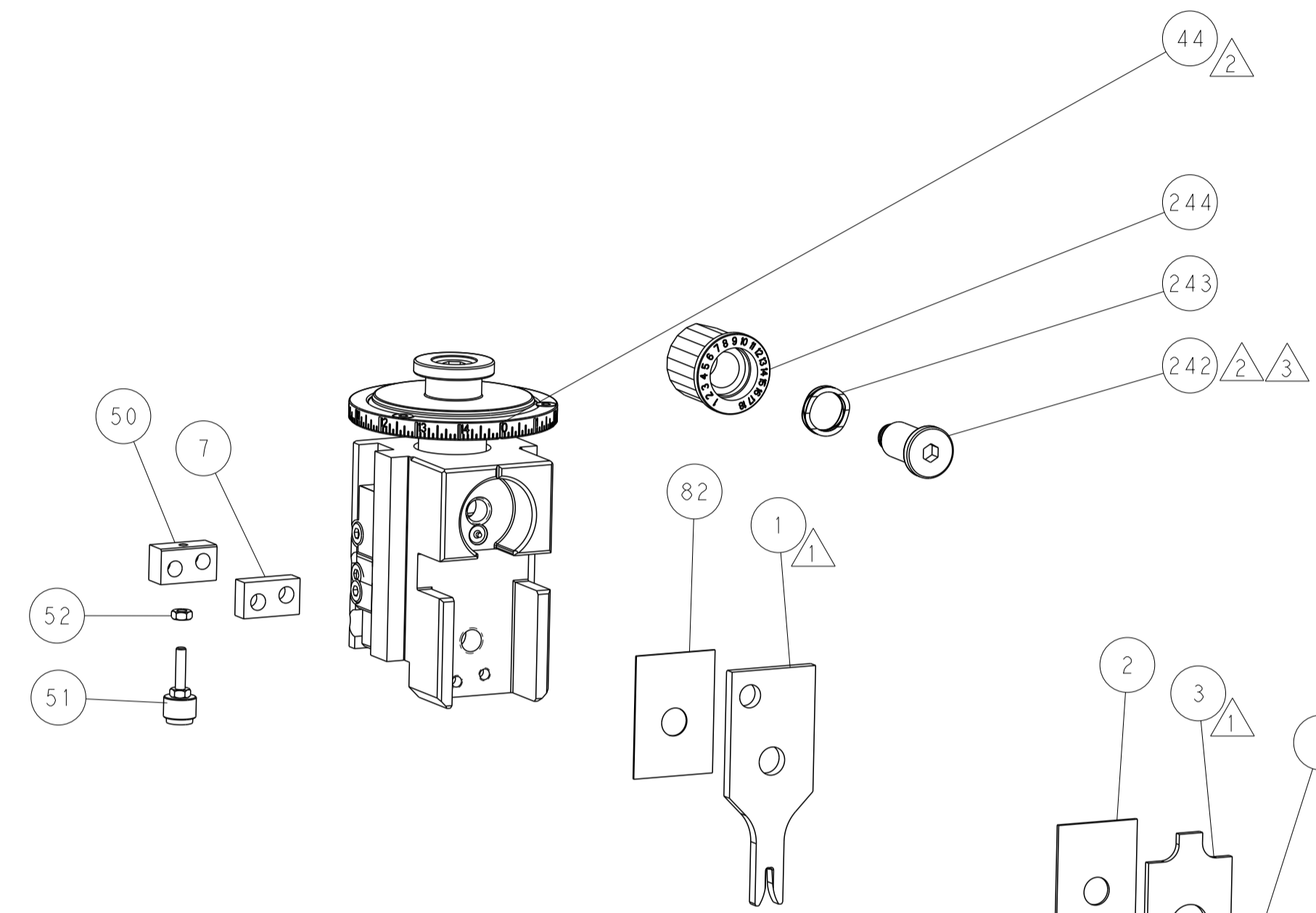
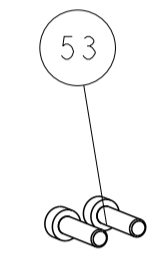
PNEUMATIC



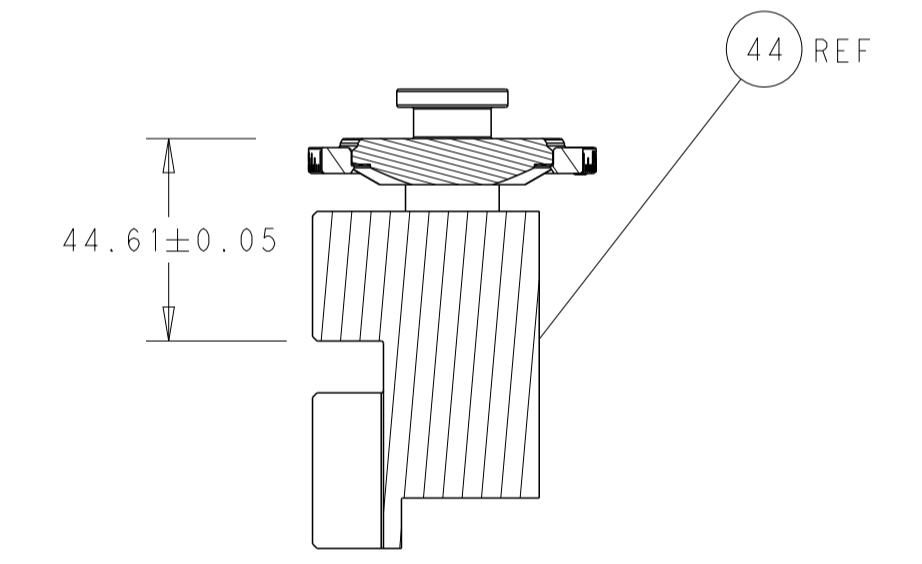
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



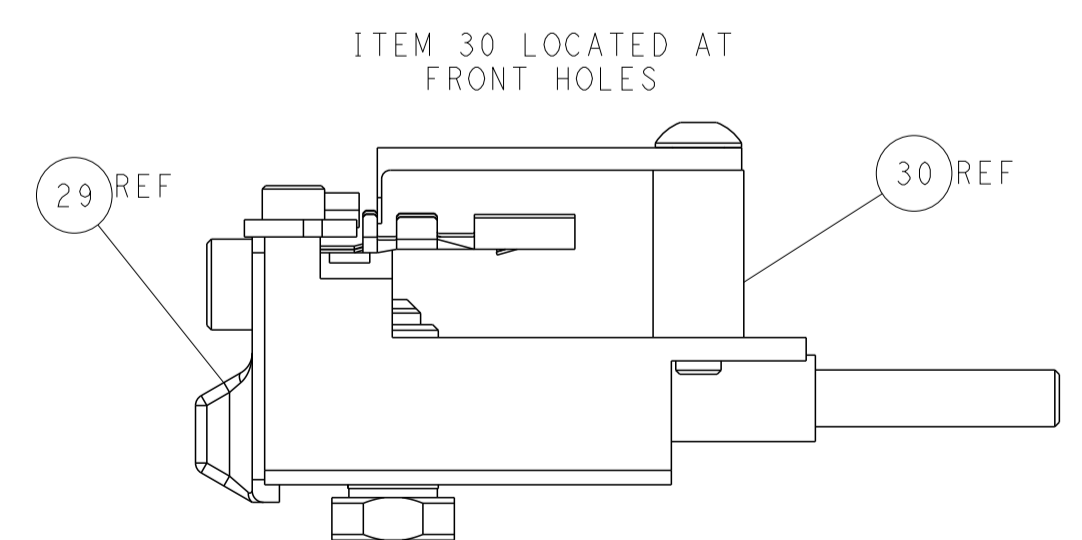
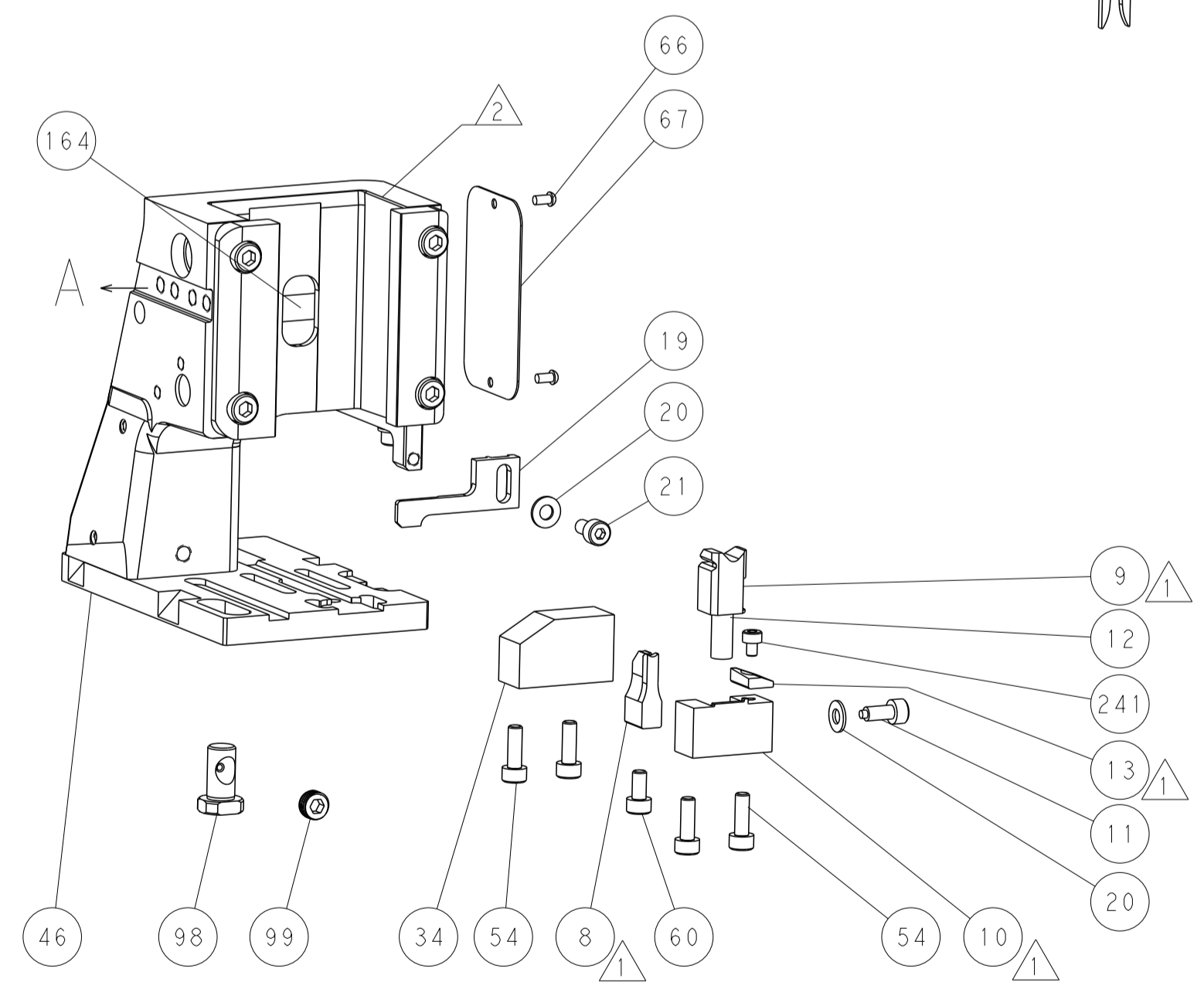
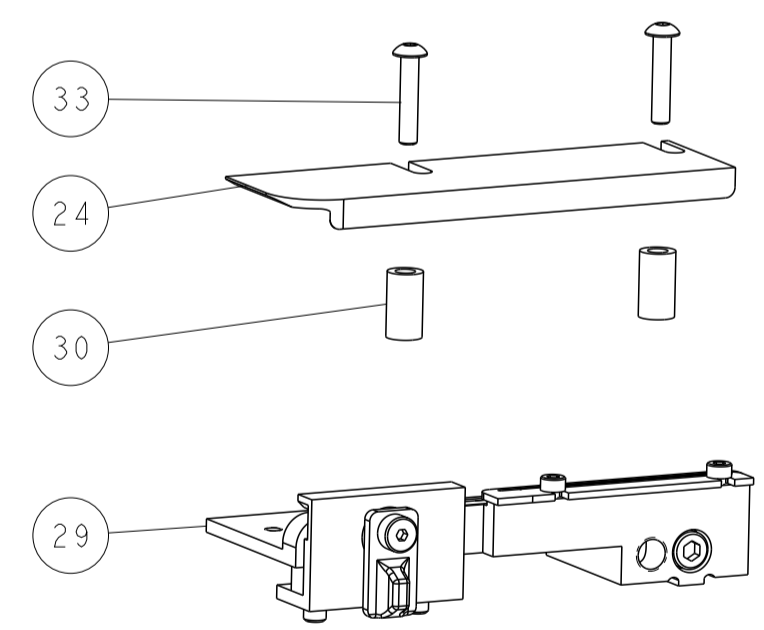
DETAIL A



TERMINAL SUPPORT LOCATION

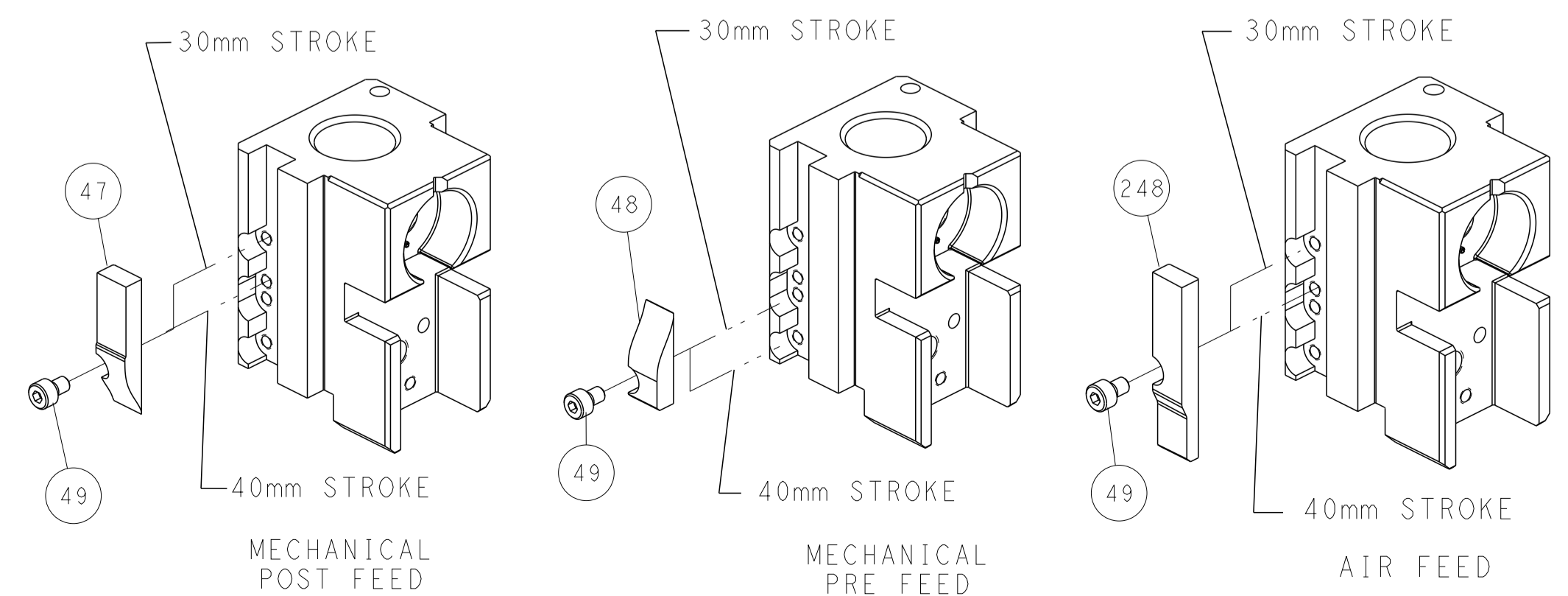


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

CAM POSITIONS



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 X.ZHAO 02SEP2015 CHK L.ZHANG 02SEP2015 APVD J.GUO 02SEP2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2266975 SCALE 1:2 SHEET 2 OF 4 REV C		TE Connectivity Harrisburg, PA 17105-3608	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266975-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266975-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266975-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.68 mm [.145]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: US208 UNSEALED FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-5.00 mm [1.57-.197 IN]	Ø1.80-2.40 mm [0.071-.094 IN]		
TERMINAL APPLICATION SPECIFICATION			
US280 UNSEALED TERMINAL Rev 2006/3/2			
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
1572955-1	8100-4444	1572955-3	15483875
1572955-2	8100-4408		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: US208 UNSEALED FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-5.00 mm [1.57-.197 IN]	Ø1.80-2.40 mm [0.071-.094 IN]		
TERMINAL APPLICATION SPECIFICATION			
-			
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
1572955-1	8100-4444		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.35+/-0.05 [0.053+/-0.002]	4.6
0.5 X 0.5mm ²	1.35+/-0.05 [0.053+/-0.002]	4.7
0.80mm ²	1.30+/-0.05 [0.051+/-0.002]	5.2
0.35 X 0.35mm ²	1.20+/-0.05 [0.047+/-0.002]	6.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.85mm ²	1.32+/-0.05 [0.052+/-0.002]	5.0



- △ 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.

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*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	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	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	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	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	1338683-8	FEED PAWL	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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
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-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	5-1633920-3	ANVIL, COMBINATION	8
-	1	1	1-240641-4	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	4-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
-	1	1	456405-8	CRIMPER, WIRE PREMIUM	1

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	3	4	C	

Customer Accessible Production Drawing

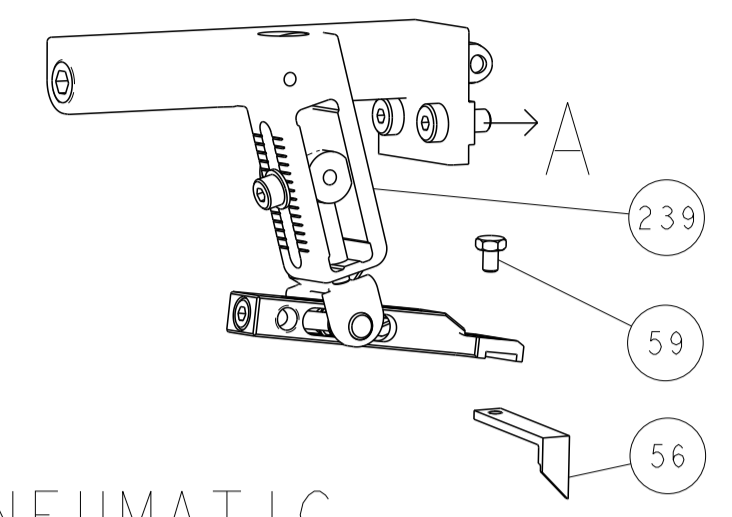
SCALE: 1:2 SHEET 3 OF 4 REV C

Customer Accessible Production Drawing

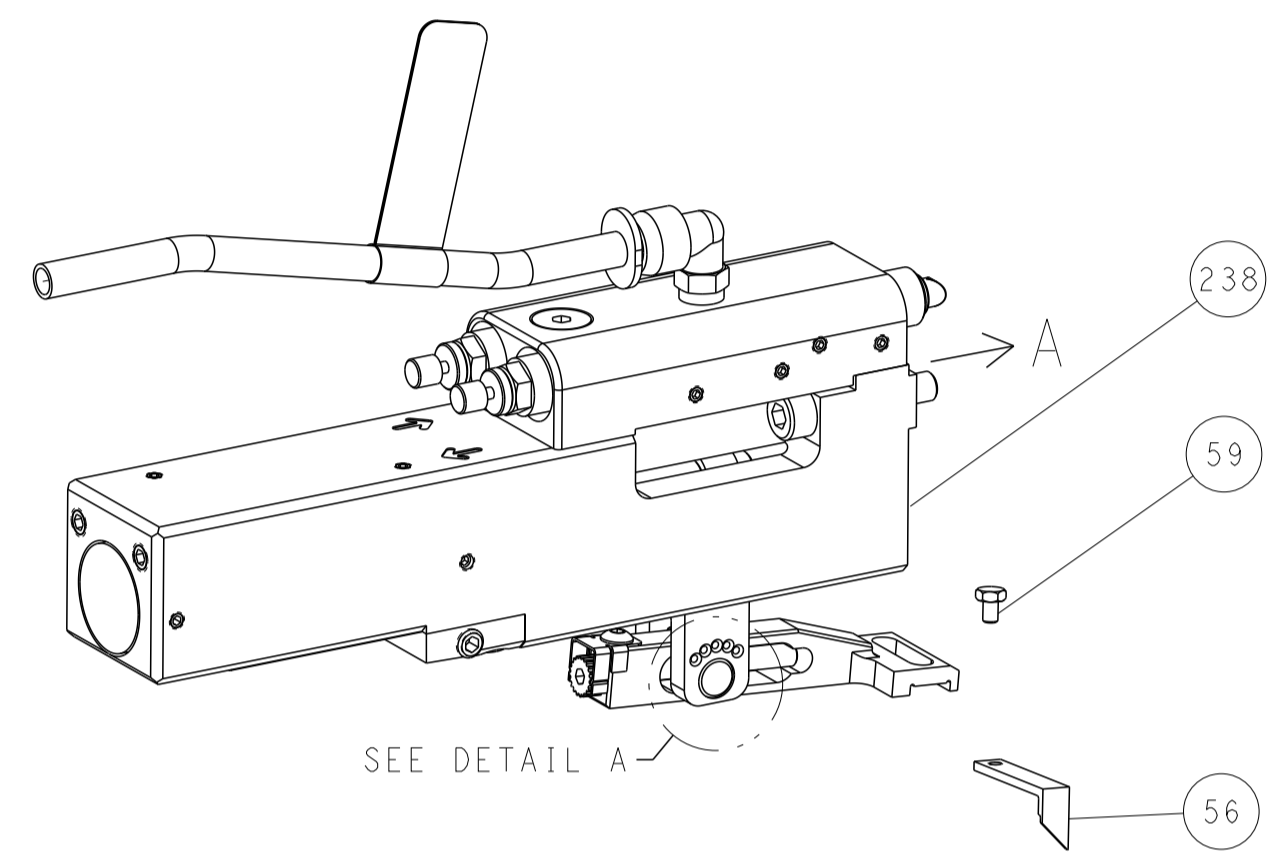
SCALE: 1:2 SHEET 3 OF 4 REV C

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

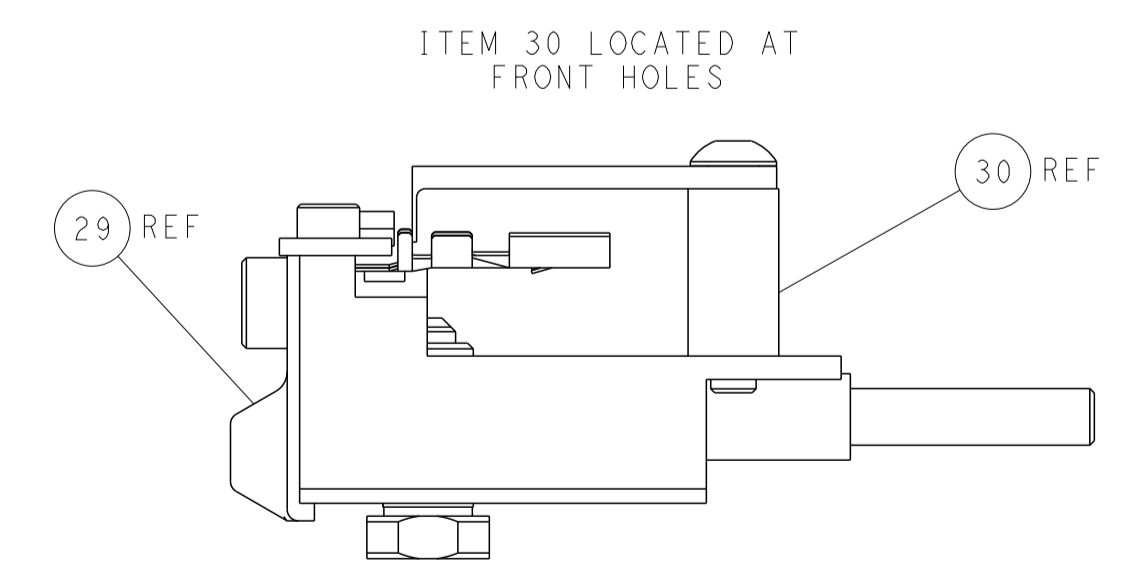
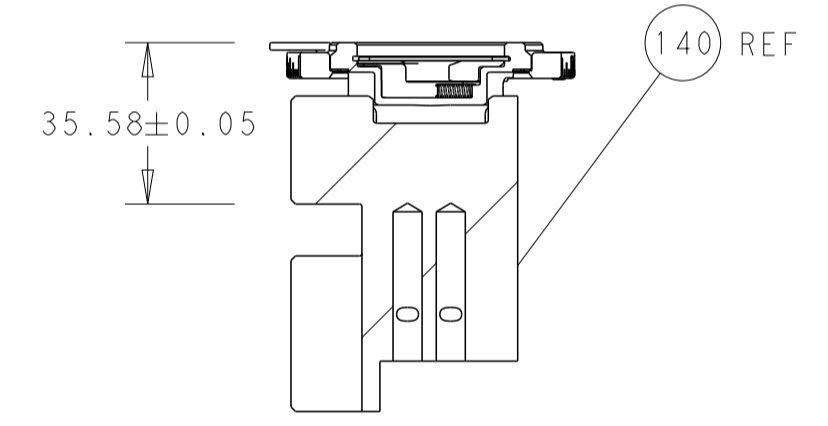
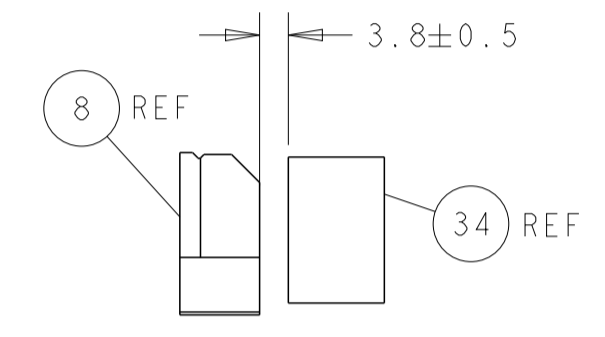
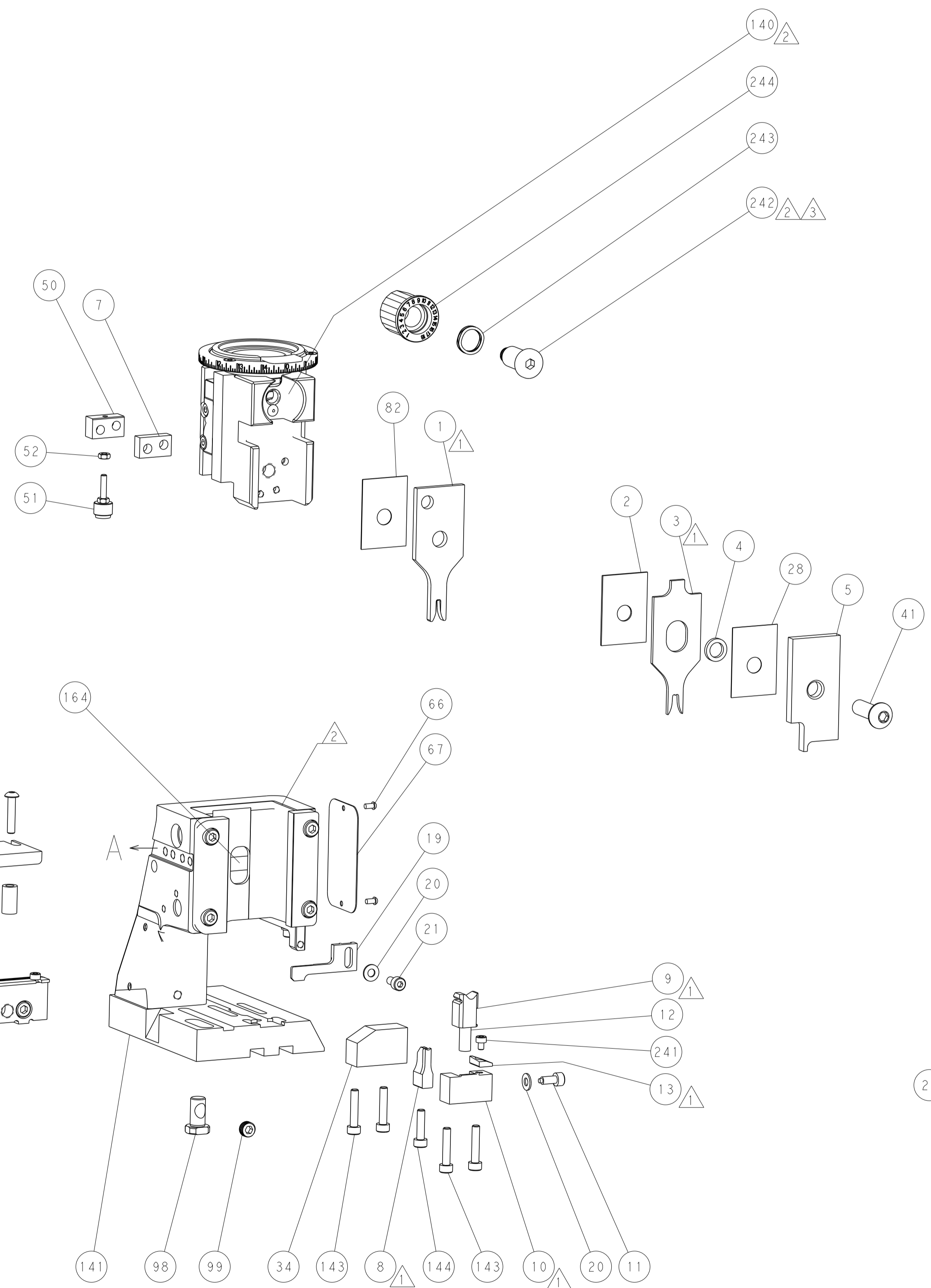
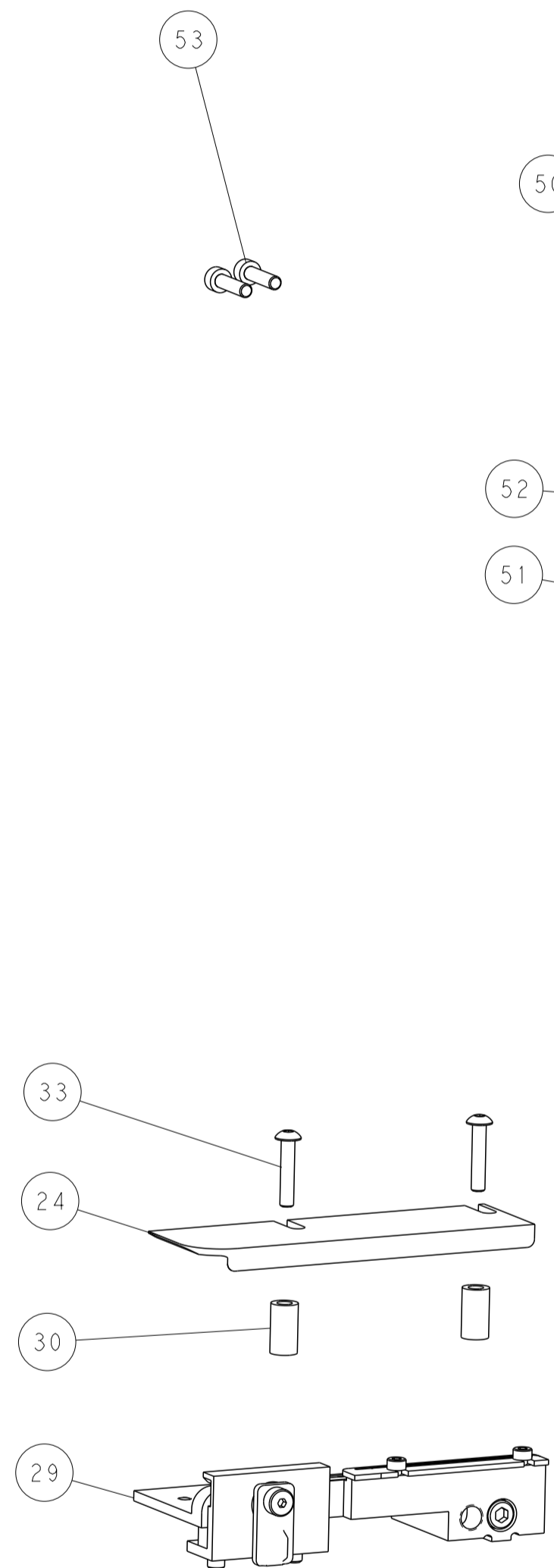
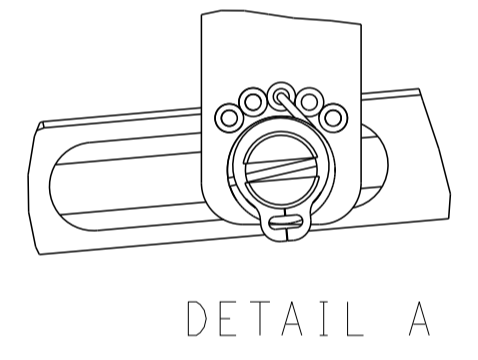
FEED TYPE MECHANICAL



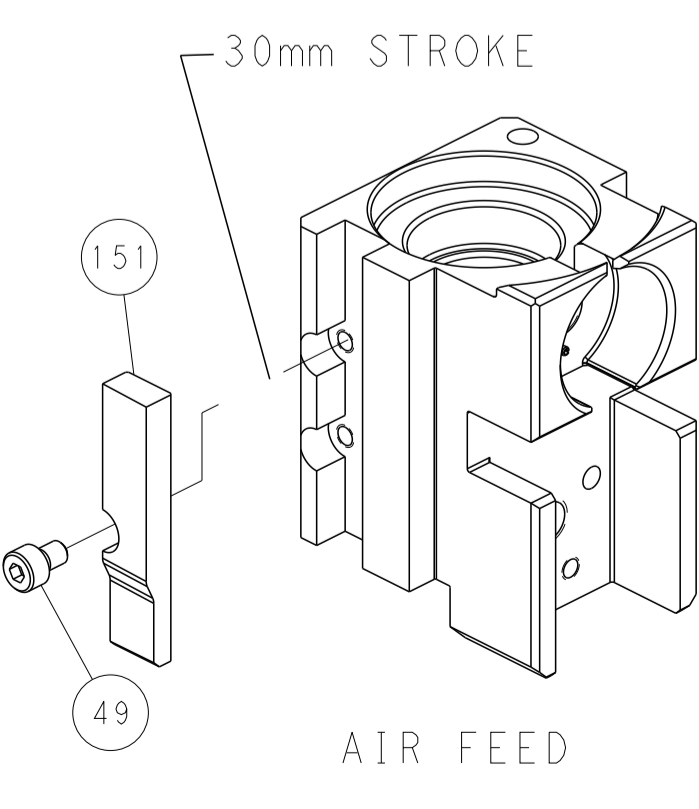
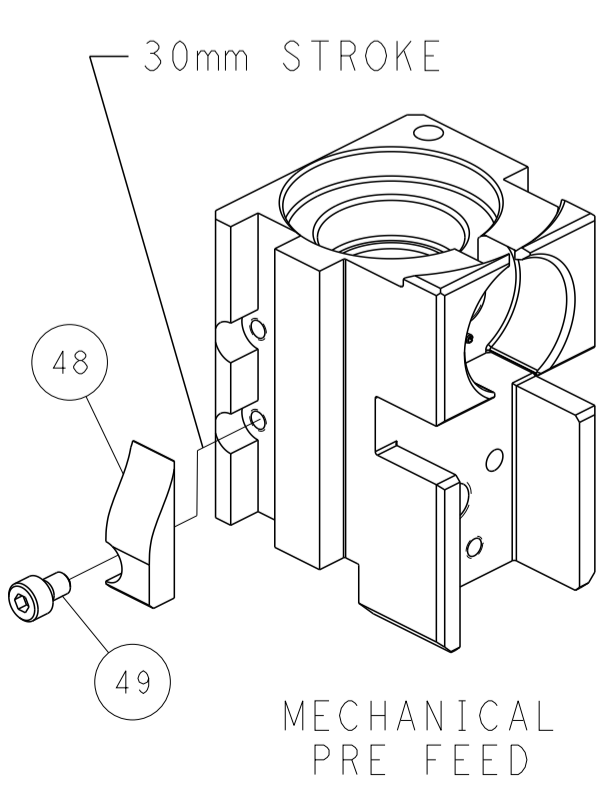
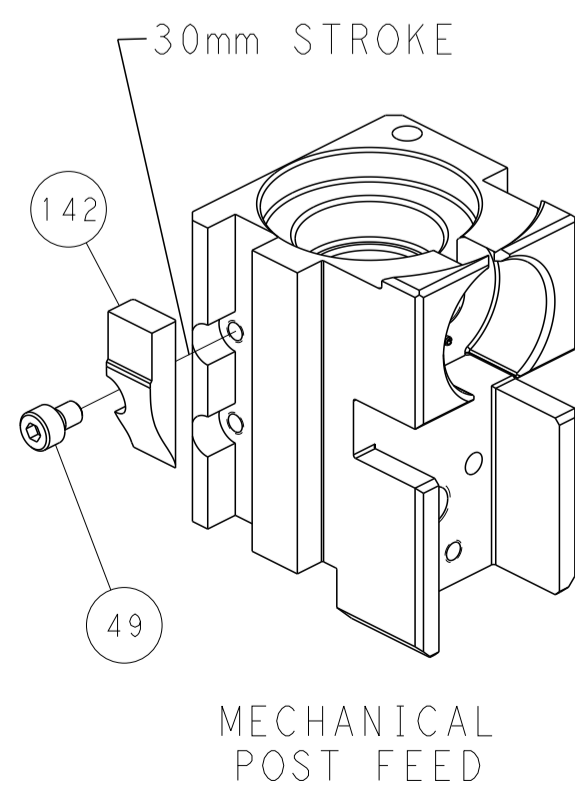
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X.ZHAO 02SEP2015		CHK: L.ZHANG 02SEP2015		APVD: H.GUO 02SEP2015		NAME: Ocean Side Feed Applicator	
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	STE TE Connectivity Harrisburg, PA 17105-3608			
	1 PLC	±		SCALE	1:2	00779	4	4	Customer Accessible Production Drawing		
	2 PLC	±		MATERIAL		FINISH		Customer Accessible Production Drawing			
	3 PLC	±		MATERIAL		FINISH		Customer Accessible Production Drawing			
	4 PLC	±		MATERIAL		FINISH		Customer Accessible Production Drawing			
	ANGLES	±		MATERIAL		FINISH		Customer Accessible Production Drawing			
				MATERIAL		FINISH		Customer Accessible Production Drawing			