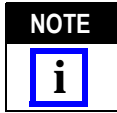


1. INTRODUCTION

The following information is used to determine the proper tool, mandrel, and clip for the post and the wire being used. After post size, wire size and insulation diameter range have been established, select the desired tool and mandrel. Then, select the proper clip for the post, wire, and tool mandrel combination. The clips and mandrel are color-coded to visually check component compatibility (i.e., red clip - red mandrel, orange clip - orange mandrel, etc.).



For wire, clip, and tooling combinations other than those listed, contact TE Connectivity, P.O. Box 3608, Harrisburg, PA 17105-3608. All dimensions on this document are in metric units [with U.S. customary units in brackets].

TE Post Size [.031 x .062-in.] System

PNEUMATIC TOOL 69522†						
WIRE SIZE SOLID OR STRANDED (7 STR)*	INSULATION DIA RANGE	MANDREL NUMBER	CLIP NUMBER (2800 PER REEL)			MANDREL AND CLIP COLOR CODE
			TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
22	0.99-1.24 [.039-.049]	69659-7	4-330495-2	4-330495-9	6-330495-8	Orange
	1.14-1.50 [.045-.059]	69659-1				
	1.40-1.65 [.055-.065]	1-69659-0				
24	0.84-1.24 [.033-.049]	69659-8	2-330495-1	2-330495-2	6-330495-4	Red
	1.14-1.50 [.045-.059]	69659				
	1.40-1.65 [.055-.065]	1-69659-1				
26	0.71-1.24 [.028-.039]	1-69659-5	1-330495-3	1-330495-8	8-330495-4	Brown
	0.84-1.24 [.033-.049]	69659-9				
	1.14-1.50 [.045-.059]	69659-3				
28	0.61-1.24 [.024-.039]	1-69659-8	3-330495-5	9-330495-6	8-330495-8	Black
	0.84-1.24 [.033-.049]	69659-2				

†Tool now obsolete (replaced by tool 59865-2 and 59865-7) but listed parts may still be purchased.

PNEUMATIC TOOL 265575-1♦♦ AND 265580-1††♦♦						
WIRE SIZE SOLID OR STRANDED (7 STR)*	INSULATION DIA RANGE	MANDREL NUMBER	CLIP NUMBER (2800 PER REEL)			MANDREL AND CLIP COLOR CODE
			TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
22	0.99-1.24 [.039-.049]	265070-1	4-330495-2	4-330495-9	6-330495-8	Orange
	1.14-1.50 [.045-.059]	265070-2				
	1.40-1.65 [.055-.065]	265070-3				
24	0.84-1.24 [.033-.049]	265070-4	2-330495-1	2-330495-2	6-330495-4	Red
	1.14-1.50 [.045-.059]	265070-5				
	1.40-1.65 [.055-.065]	265070-6				
26	0.71-1.24 [.028-.049]	265070-7	1-330495-3	1-330495-8	8-330495-4	Brown
	1.14-1.50 [.045-.059]	265070-8				
28	0.61-1.24 [.024-.039]	265070-9	3-330495-5	9-330495-6	8-330495-8	Black
	0.84-1.24 [.033-.049]	1-265070-0				

††Used with semi-automatic machine. ♦♦Tool now obsolete (replaced by tool 59928-2 and 59928-7) but listed parts may still be purchased.

*TE recommends wire type E, EE, or ET for [.031 x .062-in.], type ET only for [.022 x .036-in.], conforming to MIL-W-16878: insulation should be extruded style.

TE Post Size [.031 x .062-in.] System (Cont'd)

PNEUMATIC TOOL 59865-2♦♦, 59865-7, 59928-2♦♦, 59928-7, AND 58117-1

WIRE SIZE SOLID OR STRANDED (7 STR)*	INSULATION DIA RANGE	MANDREL NUMBER	CLIP NUMBER (2800 PER REEL)			MANDREL AND CLIP COLOR CODE
			TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
22	0.91-1.65 [.036-.065]	311078-1	4-330495-2	4-330495-9	6-330495-8	Orange
24	0.86-1.65 [.034-.065]	311078-2	2-330495-1	2-330495-2	6-330495-4	Red
26	0.76-1.40 [.030-.055]	311078-3	1-330495-3	1-330495-8	8-330495-4	Brown
28	0.56-0.91 [.022-.036]	311078-4	3-330495-5	9-330495-6	8-330495-8	Black

♦♦Tool 59865-2 and 59928-2 may be used only with wire sizes 24-28.

MANUAL SERVICE TOOL 69526-2

WIRE SIZE SOLID OR STRANDED (7 STR)*	INSULATION DIA RANGE	MANDREL NUMBER	CLIP NUMBER (1000 PER REEL)			MANDREL AND CLIP COLOR CODE
			TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
22	0.99-1.14 [.039-.045]	69551-8	6-330495-1	6-330495-2	6-330495-7	Orange
	1.14-1.65 [.045-.065]	1-69411-4				
24	0.84-1.14 [.033-.045]	69551-9	5-330495-3	1-330495-9	6-330495-3	Red
	1.14-1.65 [.045-.065]	1-69411-3				
26	0.71-1.14 [.028-.045]	69551-6	5-330495-5	9-330495-8	8-330495-6	Brown
	1.14-1.40 [.045-.055]	1-69411-9				
28	0.61-1.14 [.024-.045]	69551-5	5-330495-9	330495-3	9-330495-0	Black

MANUAL SERVICE TOOL 69525-1†

WIRE SIZE SOLID OR STRANDED (7 STR)*	INSULATION DIA RANGE	MANDREL NUMBER	CLIP NUMBER (40 STRIPS, 25 EACH)			MANDREL AND CLIP COLOR CODE
			TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
22	0.99-1.14 [.039-.045]	69551-8	4-330495-4	5-330495-1	6-330495-9	Orange
	1.14-1.65 [.045-.065]	1-69411-4				
24	0.84-1.14 [.033-.045]	69551-9	2-330495-4	4-330495-8	6-330495-4	Red
	1.14-1.65 [.045-.065]	1-69411-3				
26	0.71-1.14 [.028-.045]	69551-6	1-330495-5	9-330495-9	8-330495-5	Brown
	1.14-1.40 [.045-.055]	1-69411-9				
28	0.61-1.14 [.024-.045]	69551-5	3-330495-7	330495-1	8-330495-9	Black

†Tool now obsolete, but clips may still be purchased along with listed mandrels: tool may be converted to tool 69526-2 by ordering clip reel holder 265336-1 and loading tool 241477-3

AUTOMATIC WIRING - .031 X .062 IN.

WIRE SIZE SOLID OR STRANDED (7 STR)*	MANDREL NUMBER FOR M-TACT* MACHINE TERMINATING UNIT 266266-[]	CLIP NUMBER (100,000 PER REEL)			MANDREL AND CLIP COLOR CODE
		TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
24	265840-6	2-330495-6	4-330495-7	6-330495-6	Red
26	265840-7	1-330495-7	330495-2	8-330495-7	Brown
28	265840-8	3-330495-9	9-330495-7	9-330495-1	Black

††For additional tooling information, refer to TE publication, 409-2685 (M-TACT Machine).

TE Post Size [.022 x .036-in.] System

MANUAL SERVICE TOOL 69535 AND PNEUMATIC TOOL 265161-2†

WIRE SIZE SOLID OR STRANDED (7 STR)•	INSULATION DIA RANGE	MANDREL INSERT NUMBER	CLIP NUMBER (2500 PER REEL)			MANDREL AND CLIP COLOR CODE
			TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
28	0.46-0.74 [.018-.029]	69545-1	3-67042-4	67042-2	67042-1	Black
30		69545-3				White
32		69545-2				Gray

†Pneumatic tool 265161-2 now obsolete; replaced by tool 59865-1.

PNEUMATIC TOOL 59865-1, 59928-1, 58118-1, AND 58119-1

WIRE SIZE SOLID OR STRANDED (7 STR)•	INSULATION DIA RANGE	MANDREL INSERT NUMBER	CLIP NUMBER (2500 PER REEL)			MANDREL COLOR CODE
			TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
28	0.46-0.74 [.018-.029]	59998-1	3-67042-4	67042-2	67042-1	Black
30		59998-2				White
32		59998-3				Gray

PNEUMATIC TOOL 265560-1♦♦ and -2♦♦ (USED WITH SEMI-AUTOMATIC MACHINE) AND -3‡ (MANUAL TOOL)

WIRE SIZE SOLID OR STRANDED (7 STR)•	INSULATION DIA RANGE	MANDREL INSERT NUMBER	CLIP NUMBER (2500 PER REEL)			MANDREL COLOR CODE
			TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
28	0.46-0.74 [.018-.029]	69545-8	3-67042-4	67042-2	67042-1	Black
30		69545-9				White
32		1-69545-2				Gray

♦♦Now obsolete (replaced by 59928-1). ‡Now obsolete (replaced by 59865-1). Listed parts may still be purchased.

MANUAL SERVICE TOOL 69535-1

WIRE SIZE SOLID OR STRANDED (7 STR)•	INSULATION DIA RANGE	MANDREL INSERT NUMBER	CLIP NUMBER (1000 PER REEL)			MANDREL COLOR CODE
			TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
28	0.46-0.74 [.018-.029]	69545-1	3-67042-6	1-67042-6	1-67042-7	Black
30		69545-3				White
32		69545-2				Gray

†Tool now obsolete, but clips may still be purchased along with listed mandrels: tool may be converted to tool 69535 by ordering clip reel holder 265836-1 and loading tool 241477-3

AUTOMATIC WIRING - [.022 X .036-IN.]

WIRE SIZE SOLID OR STRANDED (7 STR)•	MANDREL NUMBER†† FOR M-TACT MACHINE TERMINATING UNIT 265945-6	CLIP NUMBER (100,000 PER REEL)			MANDREL COLOR CODE
		TIN PLATED	GOLD PLATED	TIN-NICKEL PLATED	
28	265841-1	3-67042-5	67042-7	67042-6	Black
30	265841-2				White

††For additional tooling information, refer to TE publication, 409-2738-1 and 409-2685 (for M-TACT Machine).

TE Post Size [.031 x .093-in.] System

PNEUMATIC TOOL 69585-1

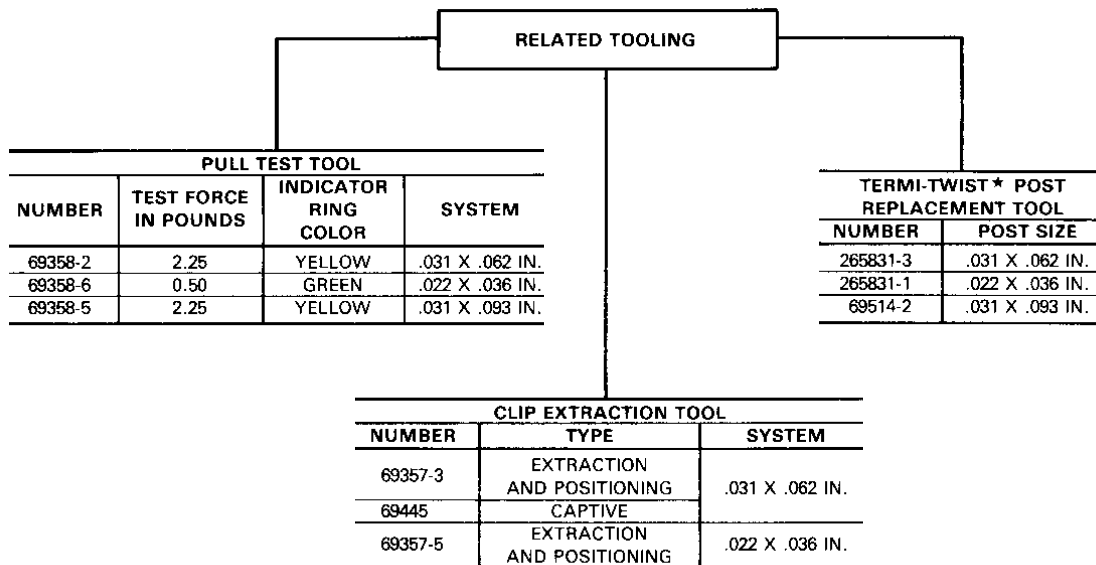
WIRE SIZE SOLID OR STRANDED (7 STR)	INSULATION DIA RANGE	MANDREL NUMBER	CLIP NUMBER (1000 PER REEL)		MANDREL AND CLIP COLOR CODE
			UNPLATED	ELECTRO-TIN PLATED	
20	1.42-1.65 [.056-.065]	69542-6	2-330854-3	2-330854-6	Yellow
	1.68-1.90 [.066-.075]	69542			
	1.93-2.16 [.076-.085]	69542-1			
24	1.42-1.65 [.056-.065]	69542-8	3-330854-2	2-330854-9	Red
	1.68-1.90 [.066-.075]	69542-5			
	1.93-2.16 [.076-.085]	69542-3			

PNEUMATIC TOOL 59865-3 AND 59928-3

WIRE SIZE SOLID OR STRANDED (7 STR)	INSULATION DIA RANGE	MANDREL NUMBER	CLIP NUMBER (1000 PER REEL)		MANDREL AND CLIP COLOR CODE
			UNPLATED	ELECTRO-TIN PLATED	
20	0.91-1.65 [.036-.065]	311079-1	2-330854-3	2-330854-6	Yellow
24	0.86-1.65 [.034-.065]	311079-2	3-330854-2	2-330854-9	Red

STRIP FED MANUAL SERVICE TOOL 69702

WIRE SIZE SOLID OR STRANDED (7 STR)	INSULATION DIA RANGE	MANDREL NUMBER	CLIP NUMBER (40 STRIPS, 25 EACH)	MANDREL AND CLIP COLOR CODE
			ELECTRO-TIN PLATED	
20	1.17-1.65 [.046-.065]	69561	2-330854-4	Yellow
	1.68-2.16 [.066-.085]	69561-1		
24	1.40-1.65 [.055-.065]	69561-4	4-330854-1	Red



2. REVISION SUMMARY

- New logo