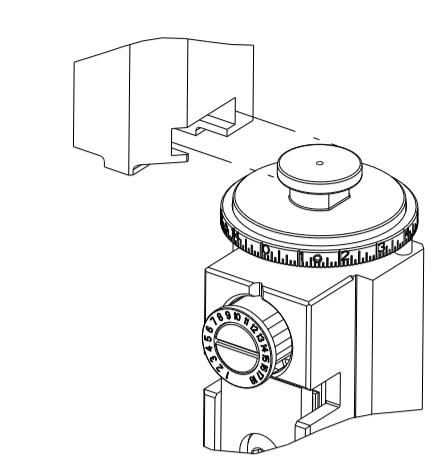


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266492-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266492-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266492-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266492-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266492-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.60 mm [.063]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.17-3.56 mm [.125-.140 IN]		Ø1.01-1.52 mm [.040-.060 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-639003400 Rev B		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572271-1	16-02-0105	1572271-3	16-02-0077
1572271-2	16-02-0078		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.82 +/- 0.025 [.032 +/- .001]	4.8
26 AWG	0.77 +/- 0.025 [.030 +/- .001]	5.3
28 AWG	0.74 +/- 0.025 [.029 +/- .001]	5.8
30 AWG	0.69 +/- 0.025 [.027 +/- .001]	6.2

- 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. TERMINAL LUBRICANT IS RECOMMENDED.
- 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)

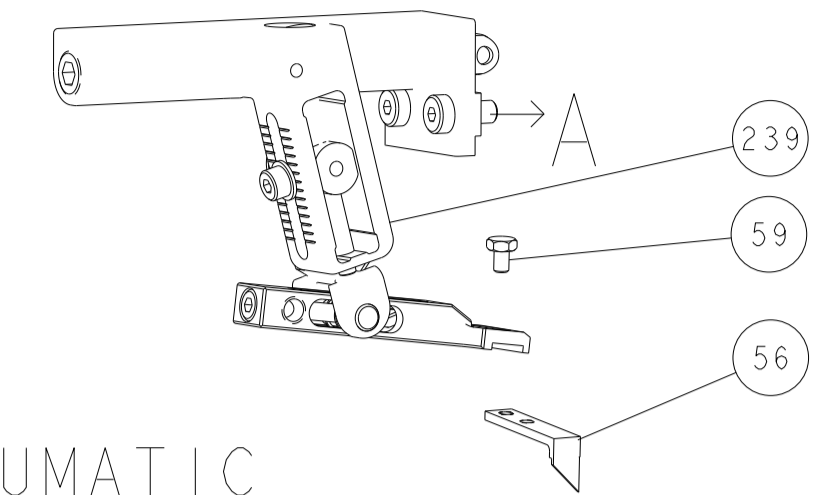
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		A		RELEASED	05JULY2017	TB	CT
		B		ECR-18-016378	16OCT2018	MS	TE
		C		ECR-22-129028	09FEB2022	FZ	RK

1	-	1	1	1	1	2280441-1	INSERT, SHEAR	282
	-	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
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	2	2	2	2	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	356885-4	STOP, SHEAR	237
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	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	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	240641-8	SPACER	81
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	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	1338685-1	PAWL, FEED	56
	-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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
	-	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	455888-5	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	690463-1	FLOATING SHEAR, REAR	17
	-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	-	1	1	1	1	1-690464-2	SHEAR PLATE, REAR	15
	-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	2	2	2	2	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	3-1803250-1	ANVIL, COMBINATION	8
	-	1	1	1	1	240641-7	SPACER	7
	-	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
	-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	8-1633962-9	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	2	1	1	4-1803224-6	CRIMPER, WIRE	1

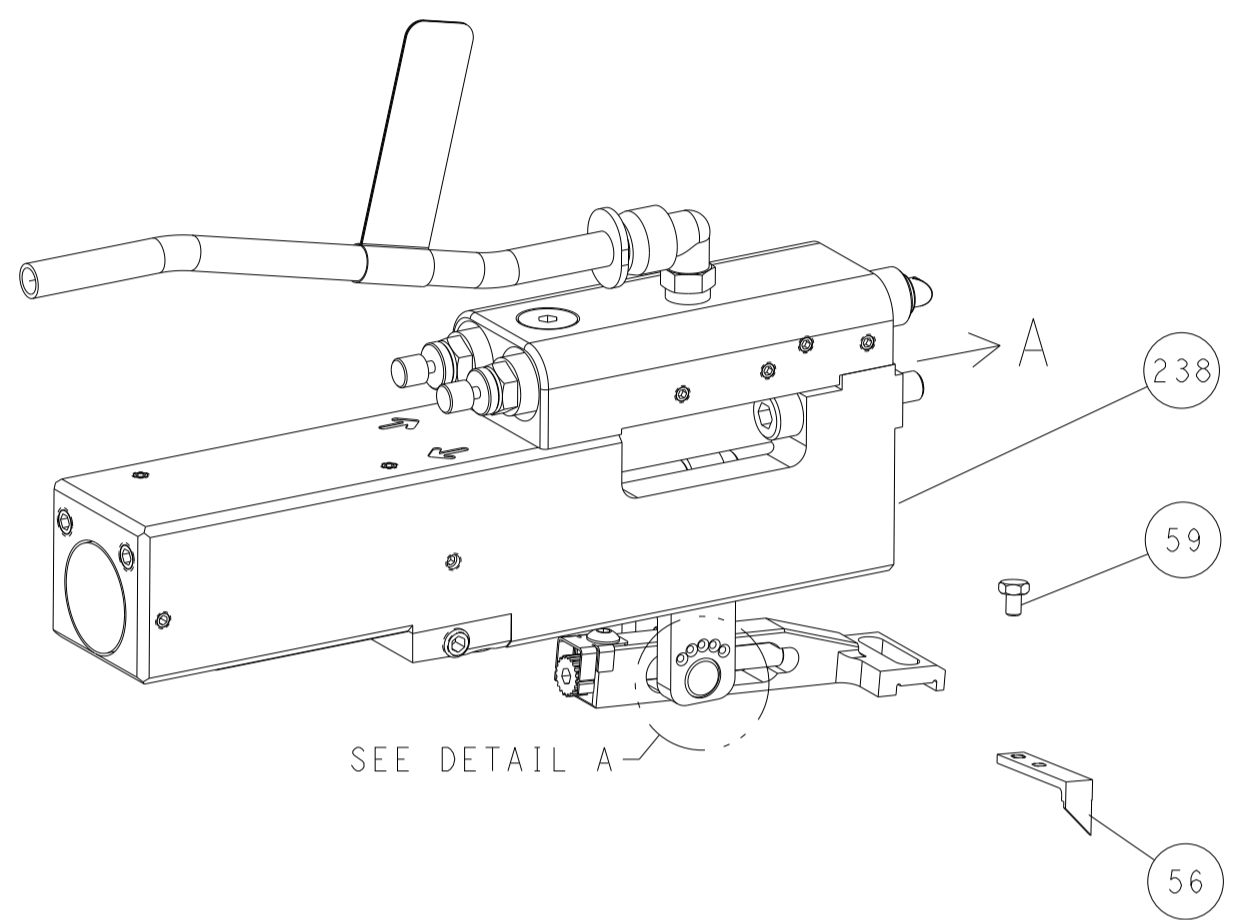
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	C=2266492	1	4	C

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

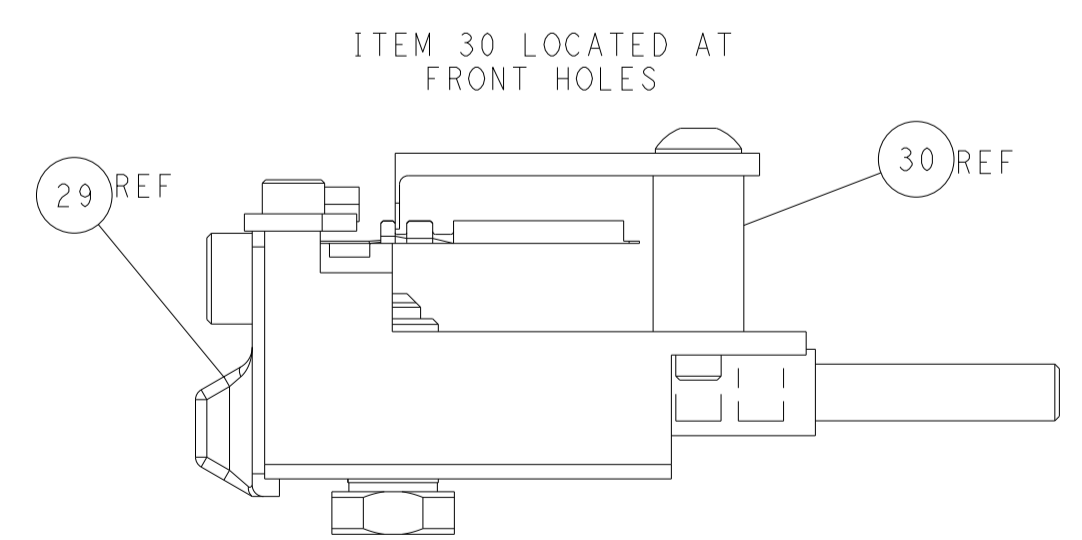
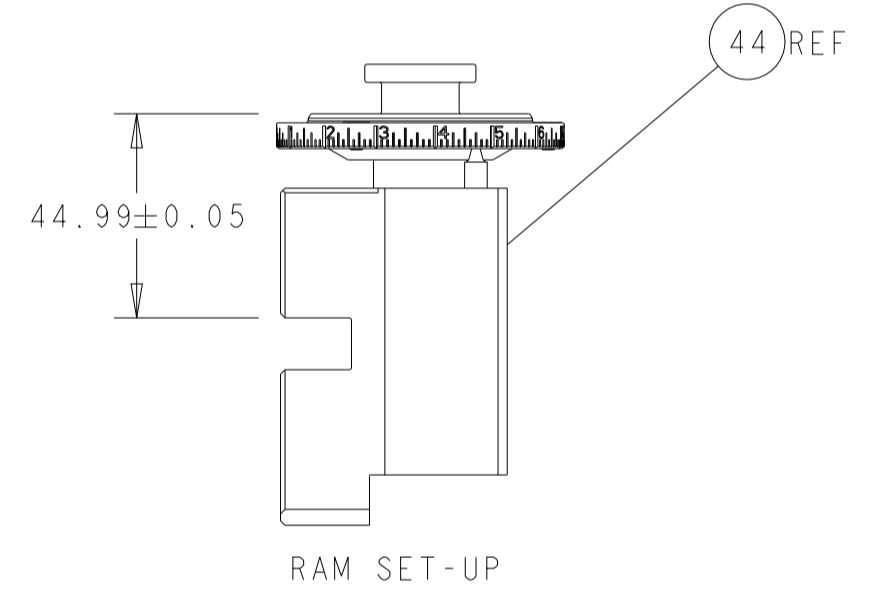
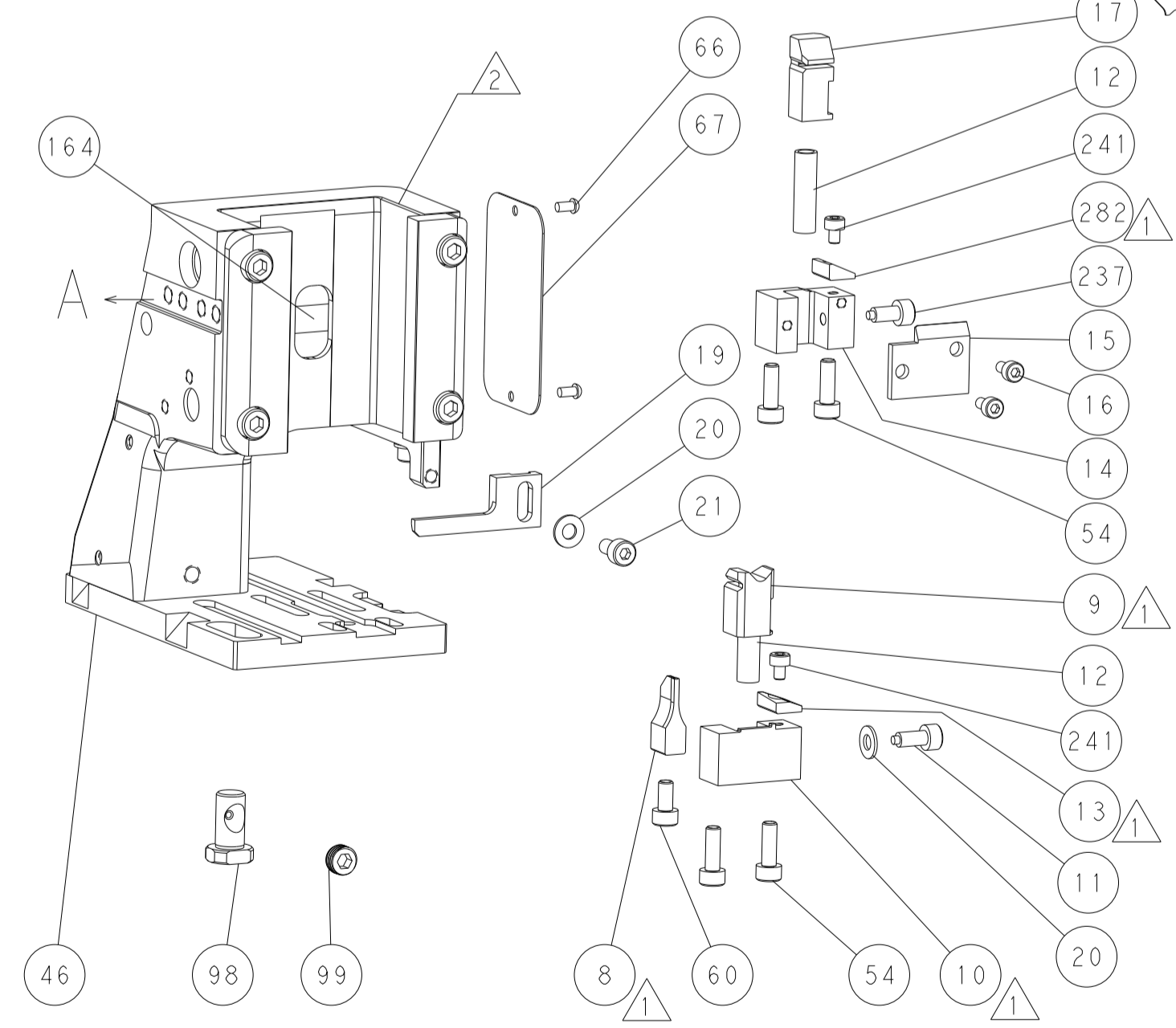
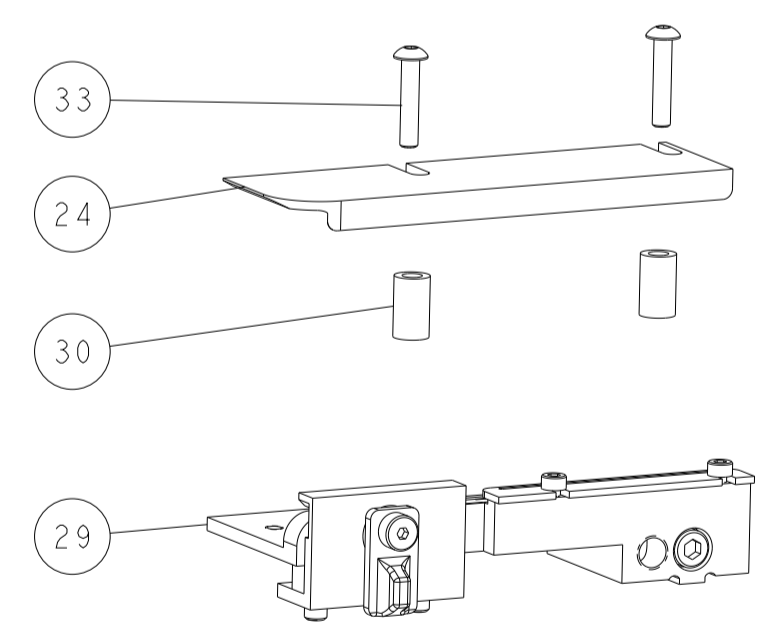
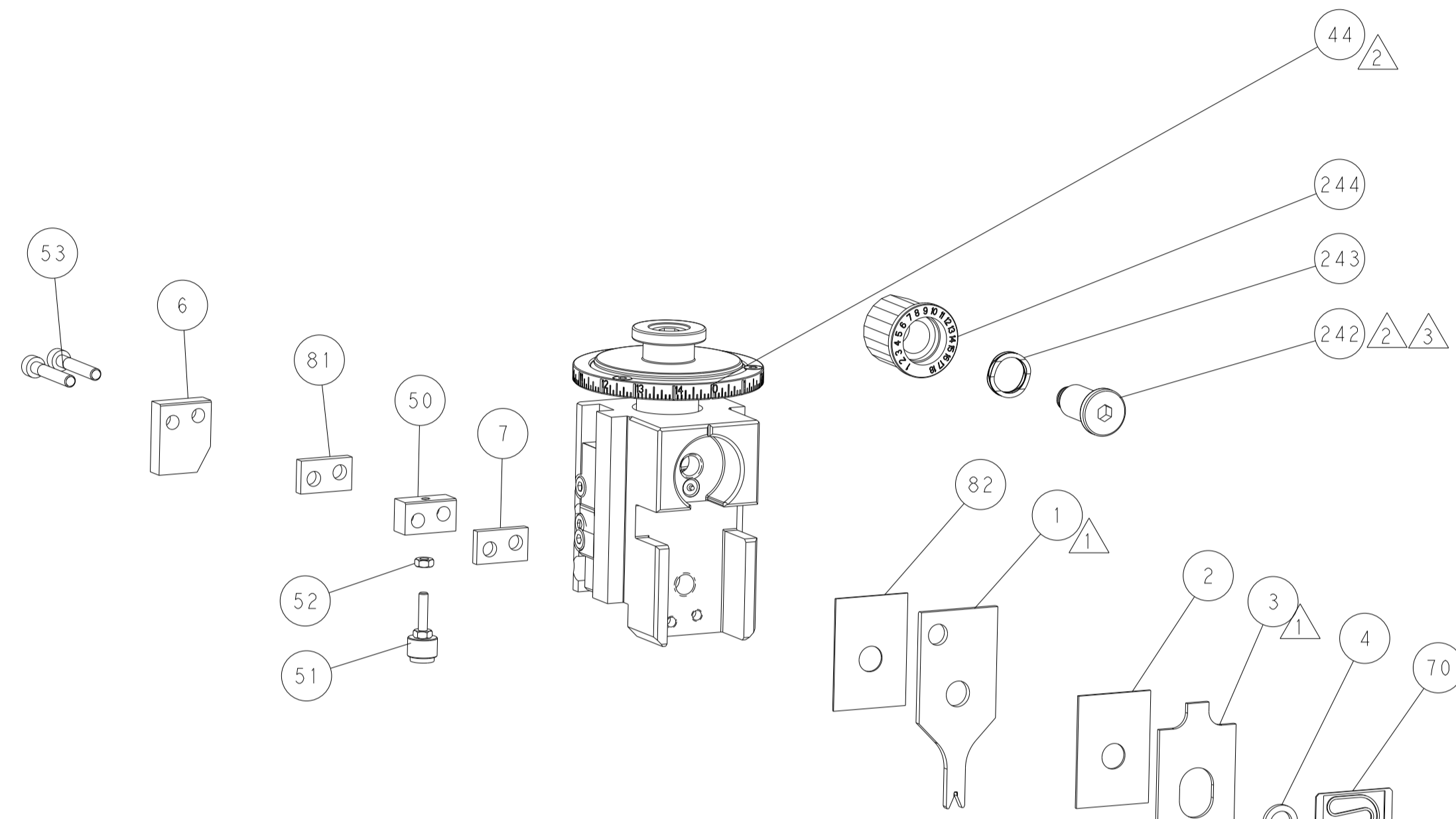
# FEED TYPE MECHANICAL



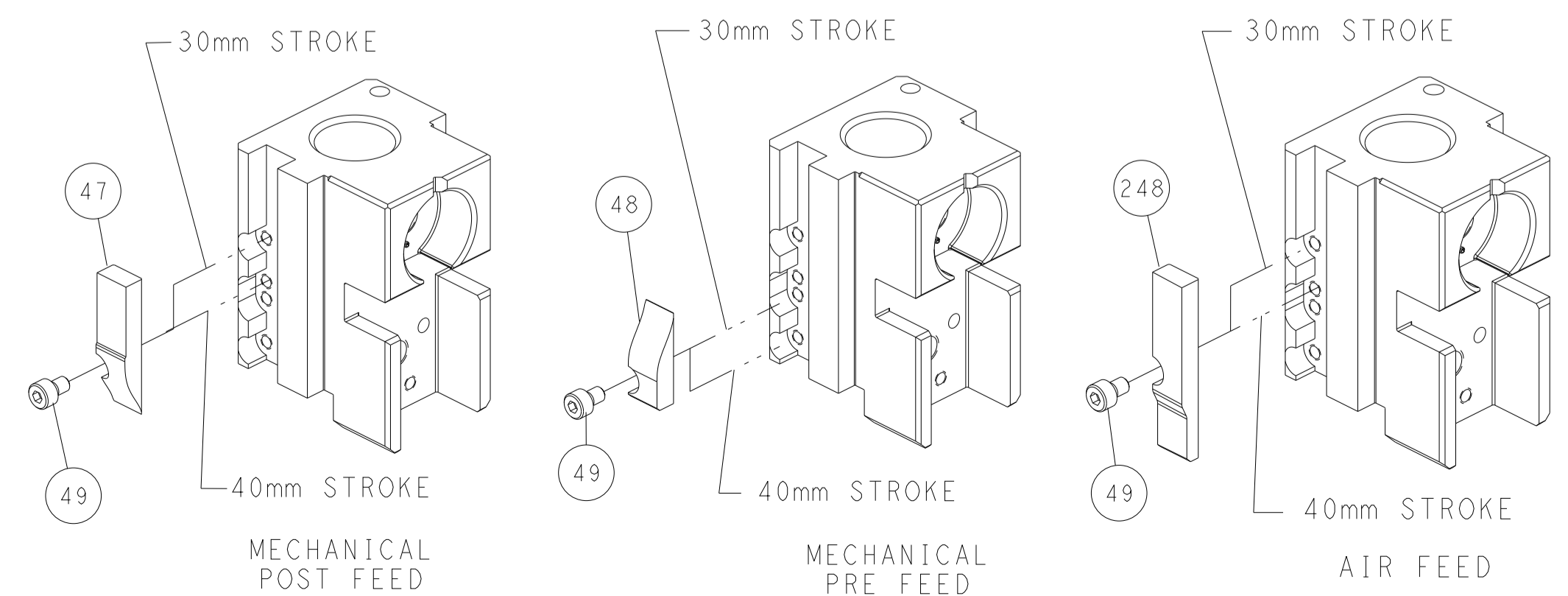
## PNEUMATIC



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



## 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. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: H. HUANG 22SEP2014 CHK: L. ZHANG 22SEP2014 APVD: J. GUO 22SEP2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266492	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: - SCALE: 1:2 SHEET: 2 of 4 REV: C	Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266492-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266492-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266492-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.60 mm [.063]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.17-3.56 mm [.125-.140 IN]	Ø1.01-1.52 mm [.040-.060 IN]		
TERMINAL APPLICATION SPECIFICATION ATS-639003400 Rev B			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572271-1	16-02-0105	1572271-3	16-02-0077
1572271-2	16-02-0078		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.82 +/- 0.025 [.032 +/- .001]	4.8
26 AWG	0.77 +/- 0.025 [.030 +/- .001]	5.3
28 AWG	0.74 +/- 0.025 [.029 +/- .001]	5.8
30 AWG	0.69 +/- 0.025 [.027 +/- .001]	6.2

**\*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.

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
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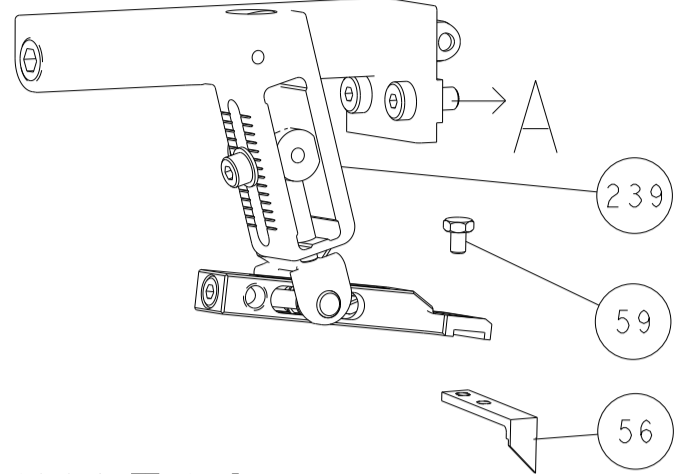
△	-	1	1	2280441-1	INSERT, SHEAR		282
	-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT		244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
△	-	1	1	2119083-1	RETAINER, INSULATION DIAL		242
	-	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY		239
	-	1	-	2844940-1	AIR FEED MODULE		238
	-	1	1	356885-4	STOP, SHEAR		237
	-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
	-	1	1	2844908-1	SCREW, LOCKING		99
	-	1	1	2844907-1	POST, LOCKING		98
	-	1	1	455888-5	SPACER, CRIMPER		82
	-	1	1	240641-8	SPACER		81
	-	1	1	1803607-3	DOCUMENTATION PACKAGE		71
	-	1	1	2119791-9	DEPRESSOR, WIRE		70
	-	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	1338685-1	PAWL, FEED		56
	-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25		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
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
	-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE		30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE		29
	-	1	1	455888-5	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	690463-1	FLOATING SHEAR, REAR		17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6		16
	-	1	1	1-690464-2	SHEAR PLATE, REAR		15
	-	1	1	2119862-1	SHEAR HOLDER, REAR		14
△	-	1	1	2119806-1	INSERT, SHEAR		13
	-	2	2	3-22280-3	SPRING, COMPRESSION		12
	-	1	1	1-356885-4	STOP, SHEAR		11
△	-	1	1	2119805-1	SHEAR HOLDER, FRONT		10
△	-	1	1	1803095-3	FLOATING SHEAR, FRONT		9
△	1	1	1	3-1803250-1	ANVIL, COMBINATION		8
	-	1	1	240641-7	SPACER		7
	-	1	1	690468-1	DEPRESSOR SHEAR, REAR		6
	-	1	1	2119757-1	DEPRESSOR, SHEAR		5
	-	1	1	2-238011-5	BLOCK, CRIMPER SPACER		4
△	1	1	1	8-1633962-9	CRIMPER, INSULATION F PREMIUM		3
	-	1	1	455888-7	SPACER, CRIMPER		2
△	1	1	1	4-1803224-6	CRIMPER, WIRE		1

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

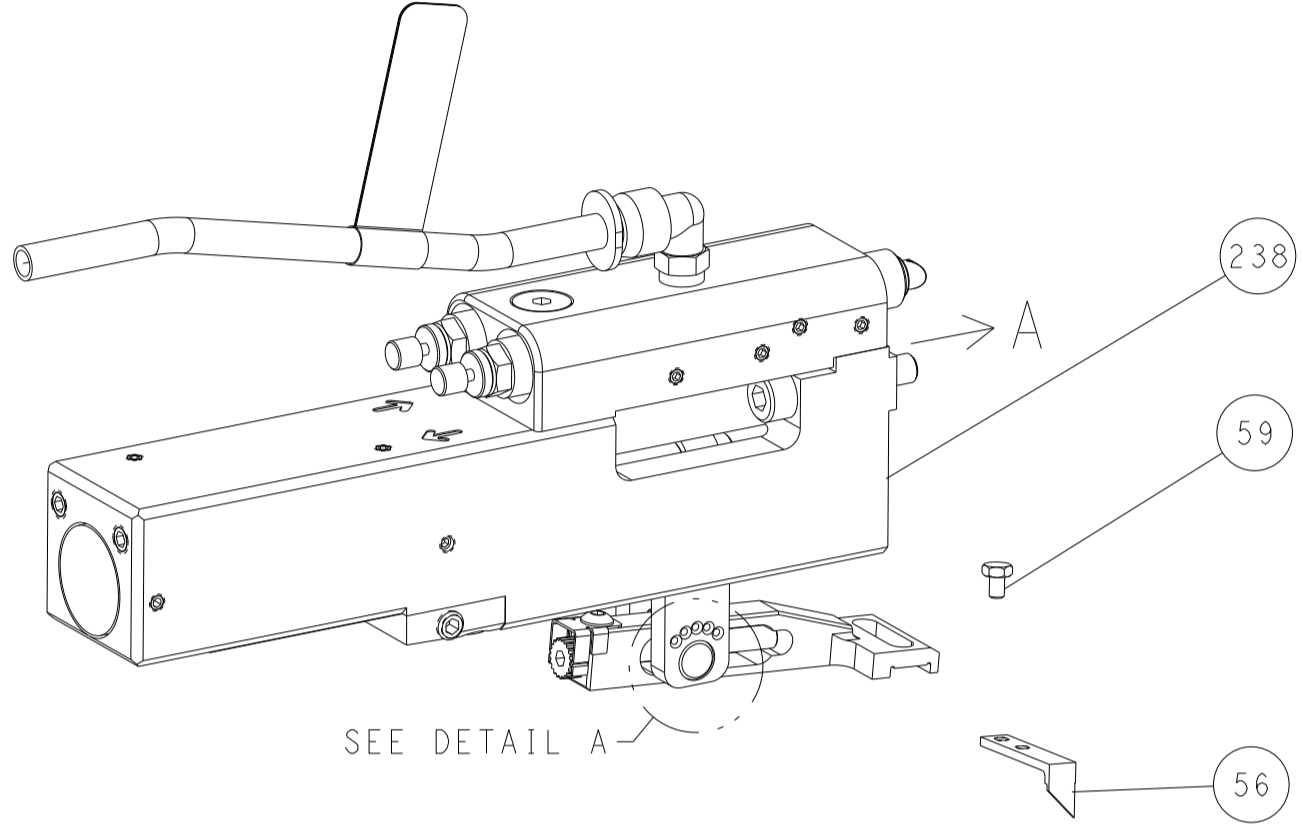
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: H. HUANG 22SEP2014 CHK: L. ZHANG 22SEP2014 APVD: J. GUO 22SEP2014 PRODUCT SPEC APPLICATION SPEC WEIGHT: - MATERIAL: -		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266492 RESTRICTED TO: - SCALE: 1:2 SHEET: 3 OF 4 REV: C	
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1		-	-

# FEED TYPE MECHANICAL



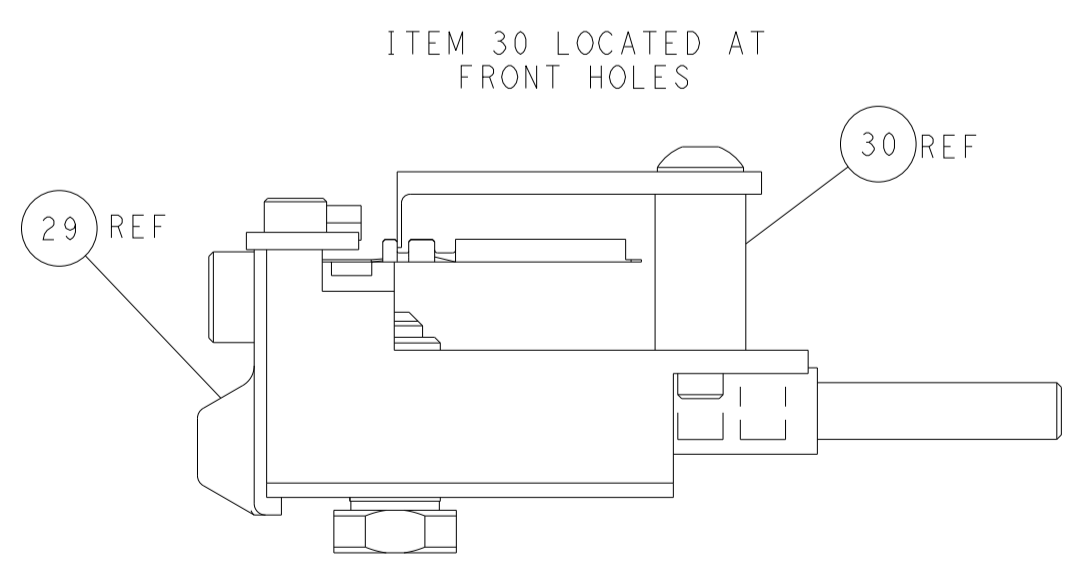
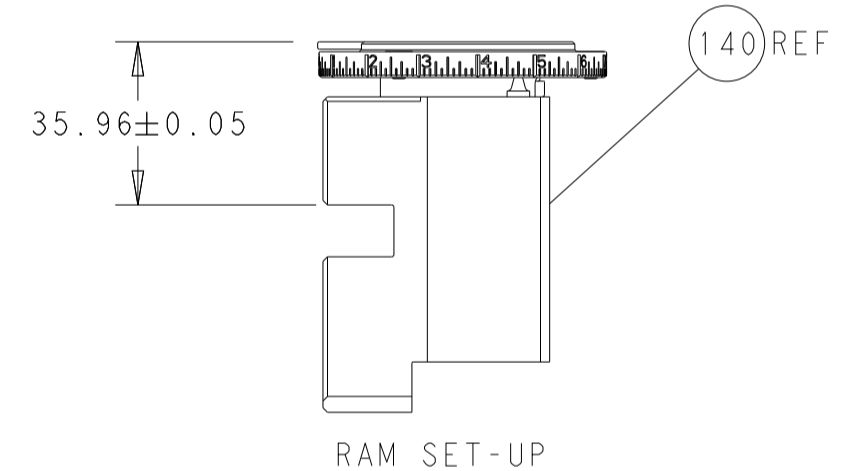
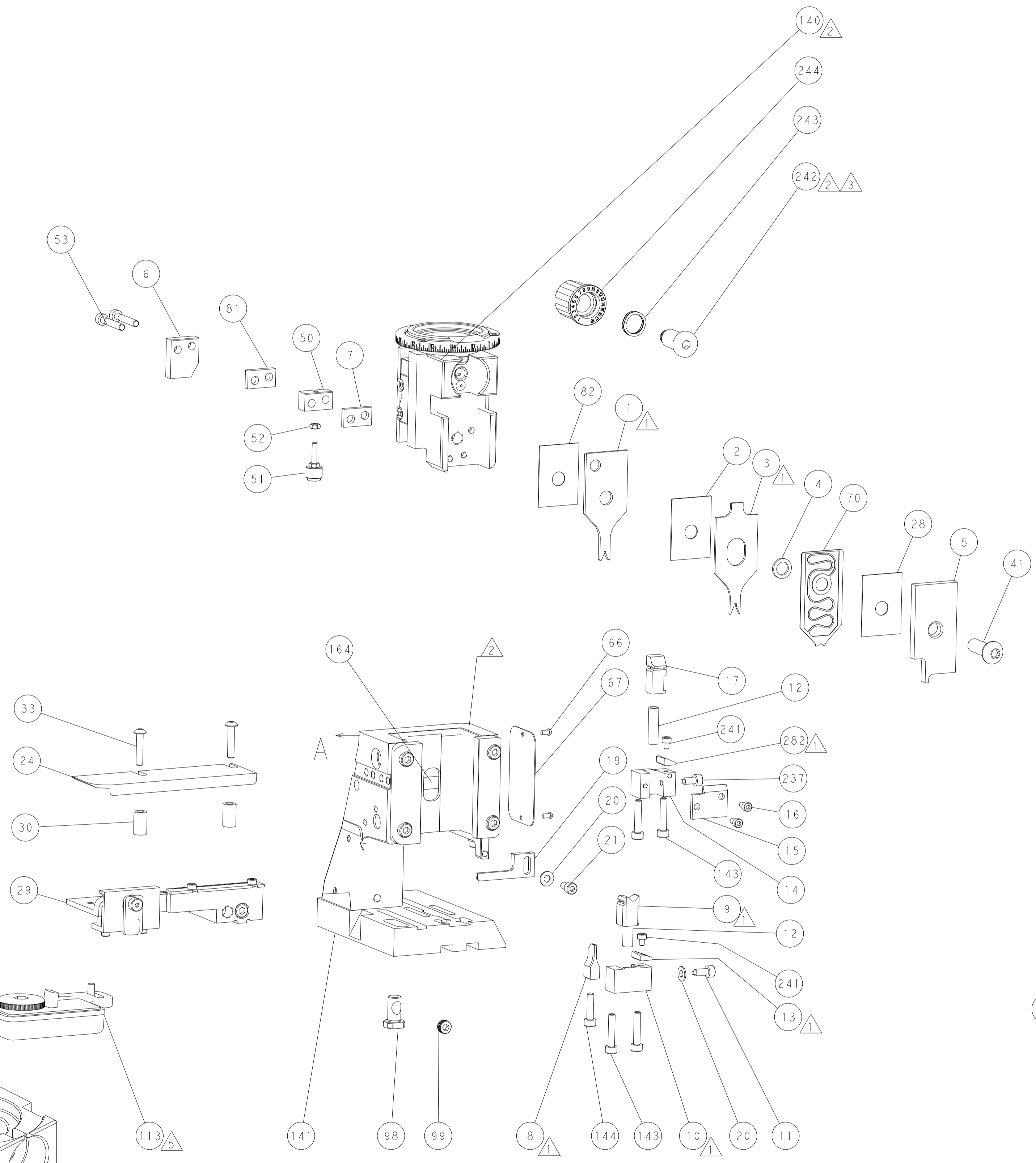
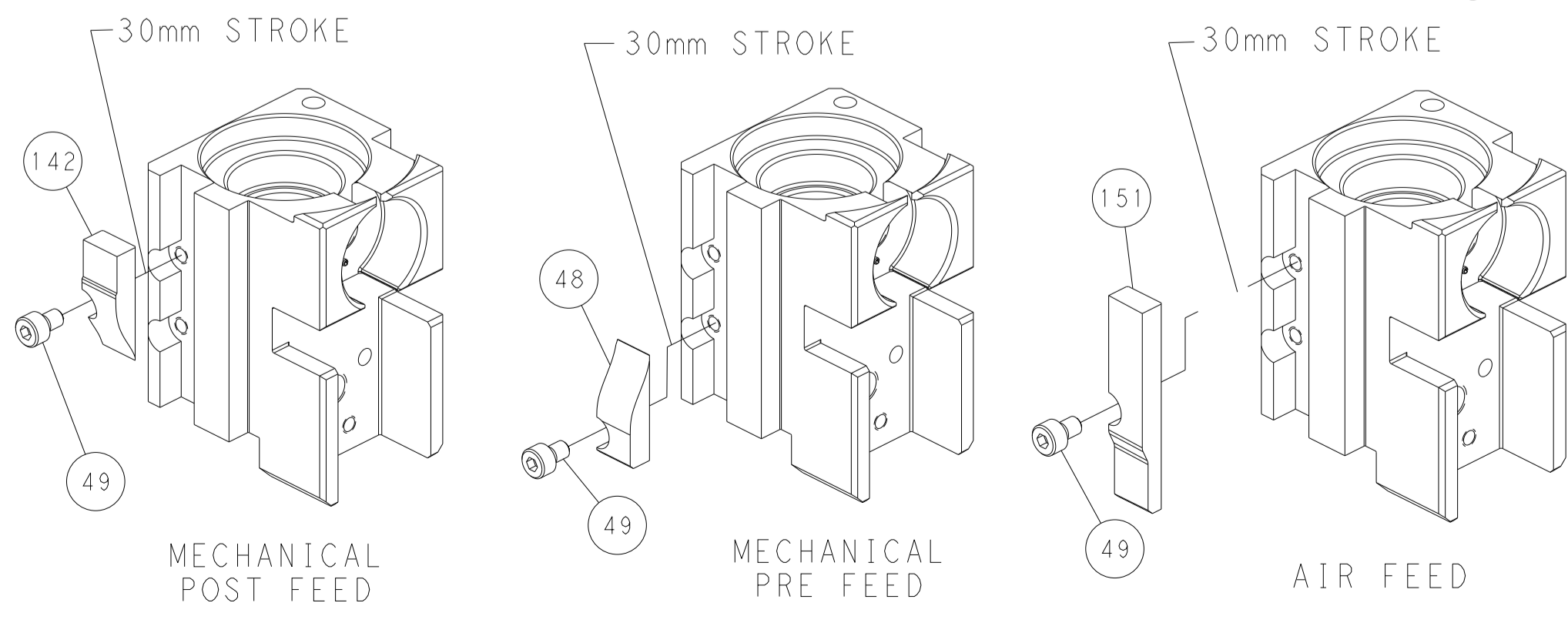
## PNEUMATIC



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



## CAM POSITIONS



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2266492	RESTRICTED TO: C SHEET 4 OF 4 REV C