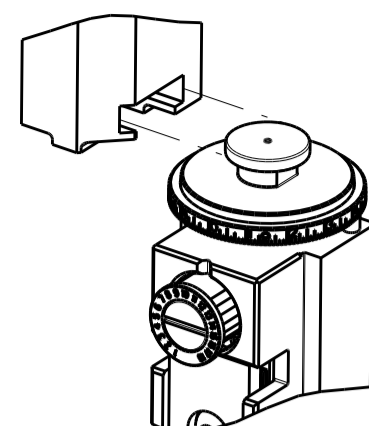


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266480-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266480-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266480-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.25 mm [.167]	F
INSUL	5.08 mm [.200]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: G & H TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: G & H TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
6.20-6.80 mm [.244-.268 IN]	Ø3.40-4.30 mm [.134-.169 IN]		
TERMINAL APPLICATION SPECIFICATION LEAR SPEC Rev - 25612 Rev 2			
TERMINALS APPLIED			
TE TERMINAL	G & H TERMINAL	TE TERMINAL	G & H TERMINAL
1572672-1	25612.306.421		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.90+/-0.10 [.114+/- .004]	5.2
4.00mm2	2.50+/-0.10 [.098+/- .004]	9.0

- 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. 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	LTN	DESCRIPTION	DATE	OWN	APVD
A	66			RELEASED	05DEC2014	JH	GB
				ECR-17-003067	03MAR2017	TB	TE
				ECR-18-014434	11SEP2018	JAH	TE
				ECR-20-012125	27AUG2020	FZ	GB

-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	268
-	1	1	1-1633782-0	FENCE	267
-	1	1	1803078-2	SPACER, PRECISION	259
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-3	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
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1490899-5	GUIDE, FRONT STRIP	96
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	318563-1	GUARD, FRONT CHIP	89
-	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
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	1-1338683-1	FEED PAWL	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	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	1-811242-0	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	50
-	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	4-1752356-5	SUPPORT, TERMINAL	34
-	1	1	2844938-5	PLATE, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	1-356885-3	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	454276-5	FLOATING SHEAR, FRONT	9
-	1	2	1-1803171-5	ANVIL, COMBINATION	8
-	1	1	240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	5-238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	1-1803221-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	7-1633738-8	CRIMPER, WIRE	1

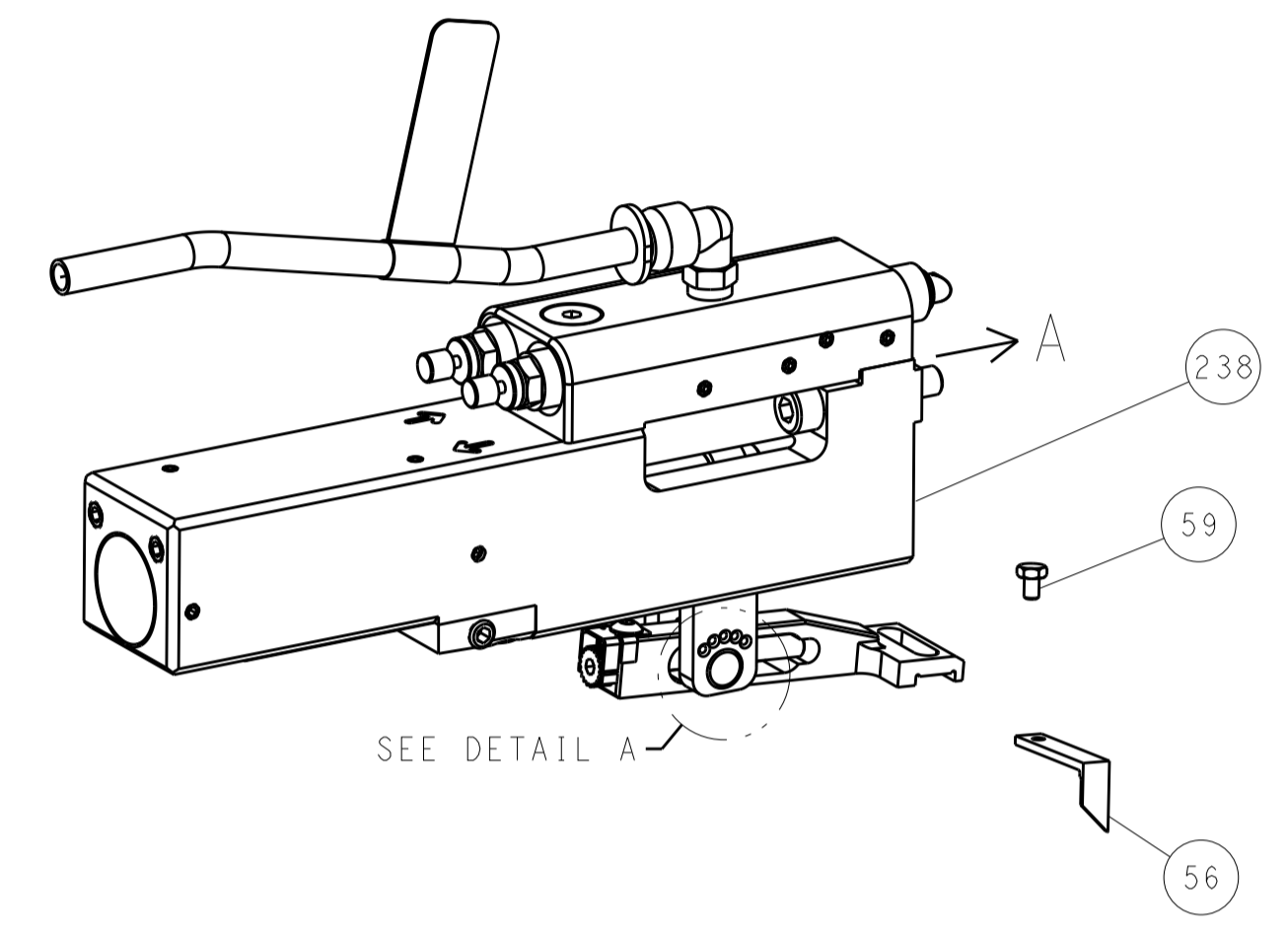
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

OWN	X. ZHAO	25SEP2014	TE Connectivity
CHK	T. ELBIN	25SEP2014	Harrisburg, PA 17105-3608
APVD	J. GUO	25SEP2014	
PRODUCT SPEC	Ocean Side Feed Applicator		
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266480	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV D

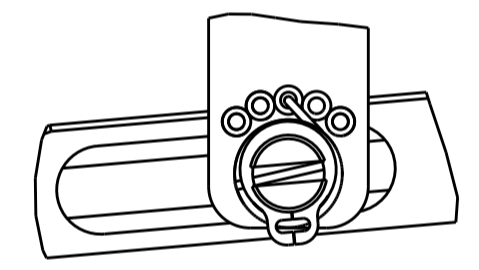
LOC		DIST		REVISIONS			
NO.	REV.	DATE	BY	DESCRIPTION	DATE	BY	APPROV.
A	66			SEE SHEET 1			

FEED TYPE

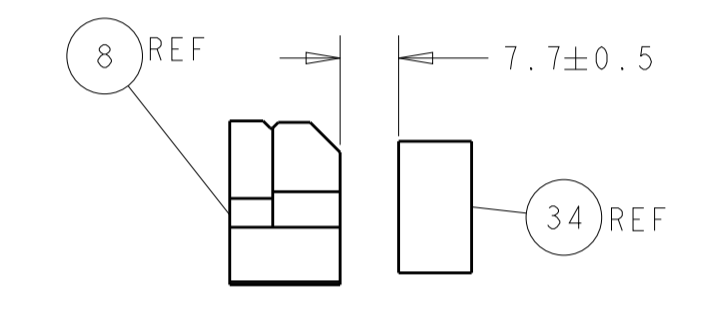
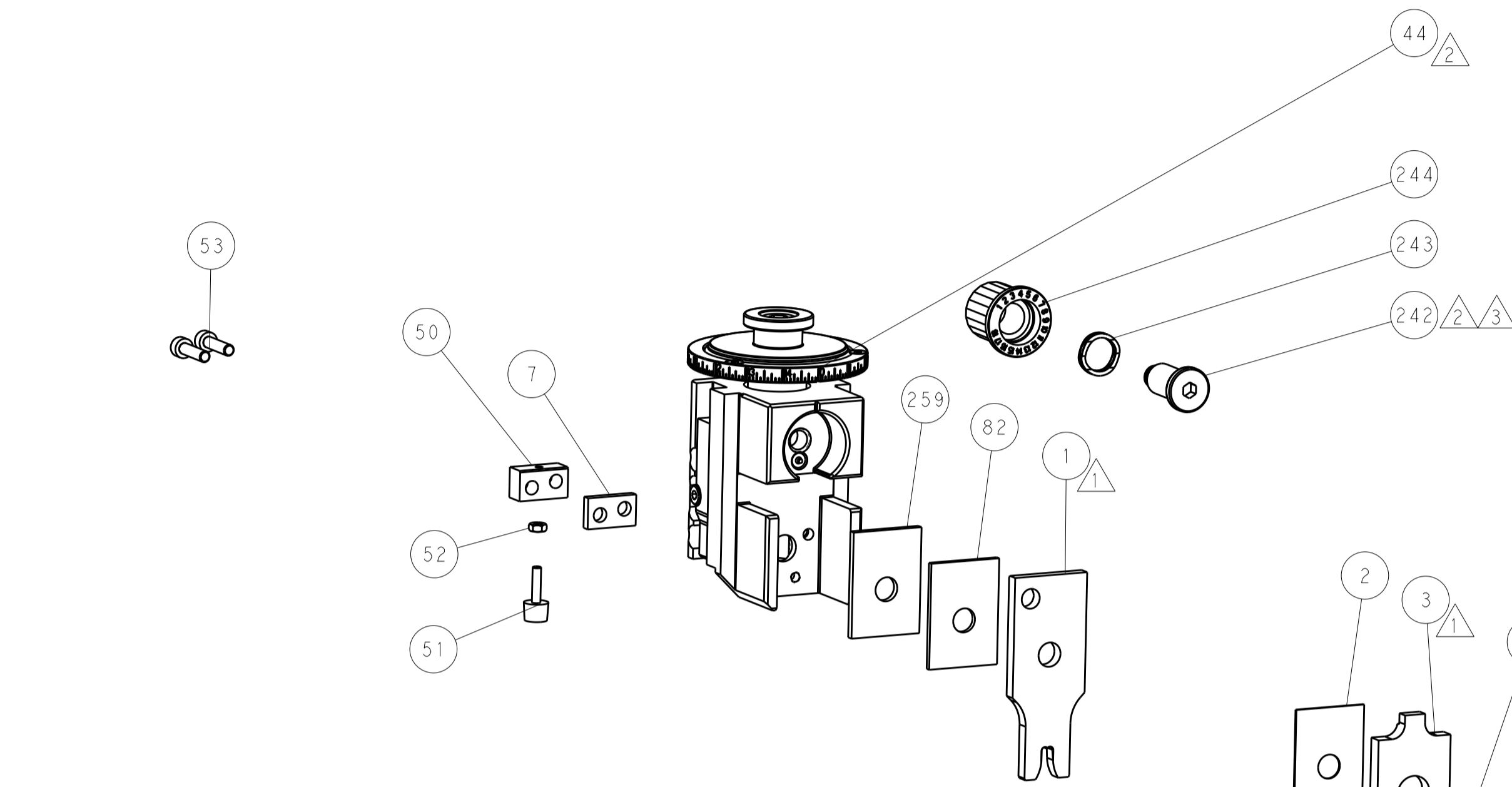
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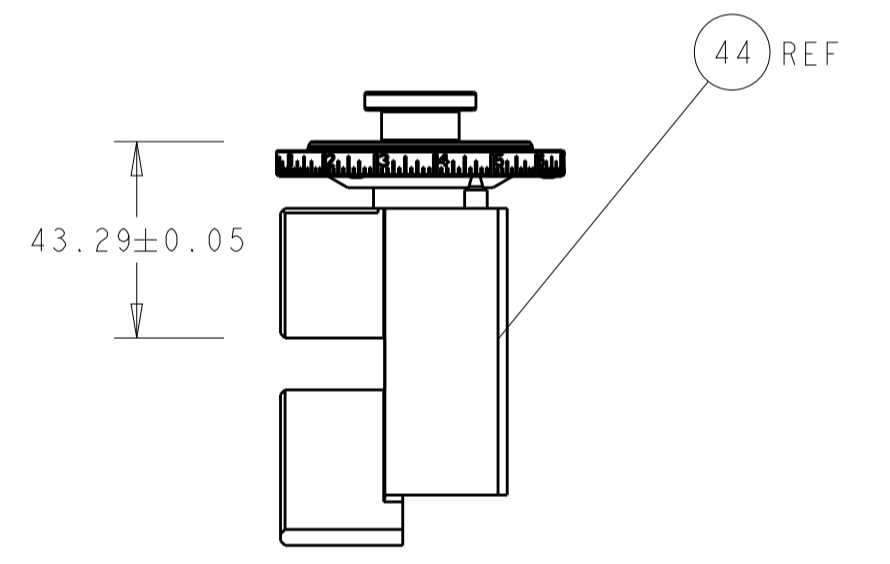
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

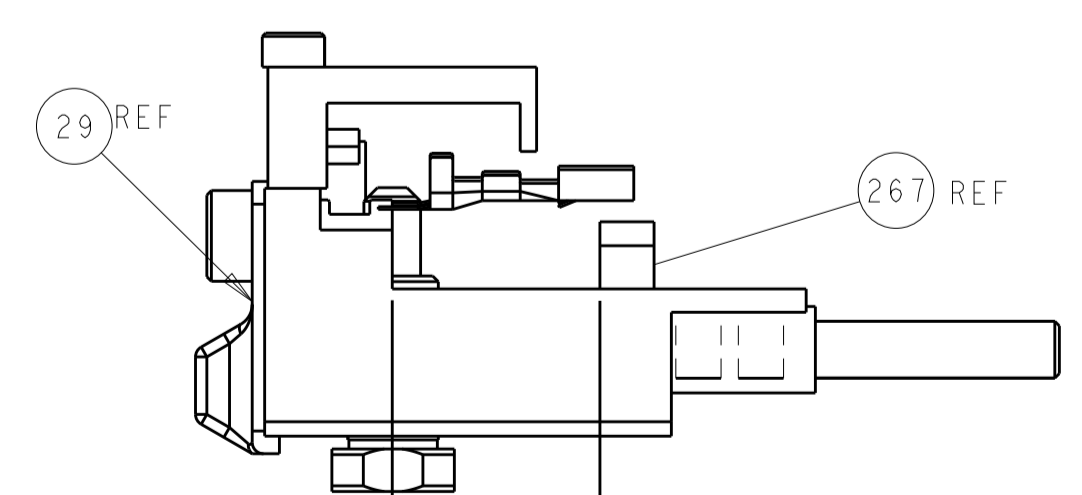
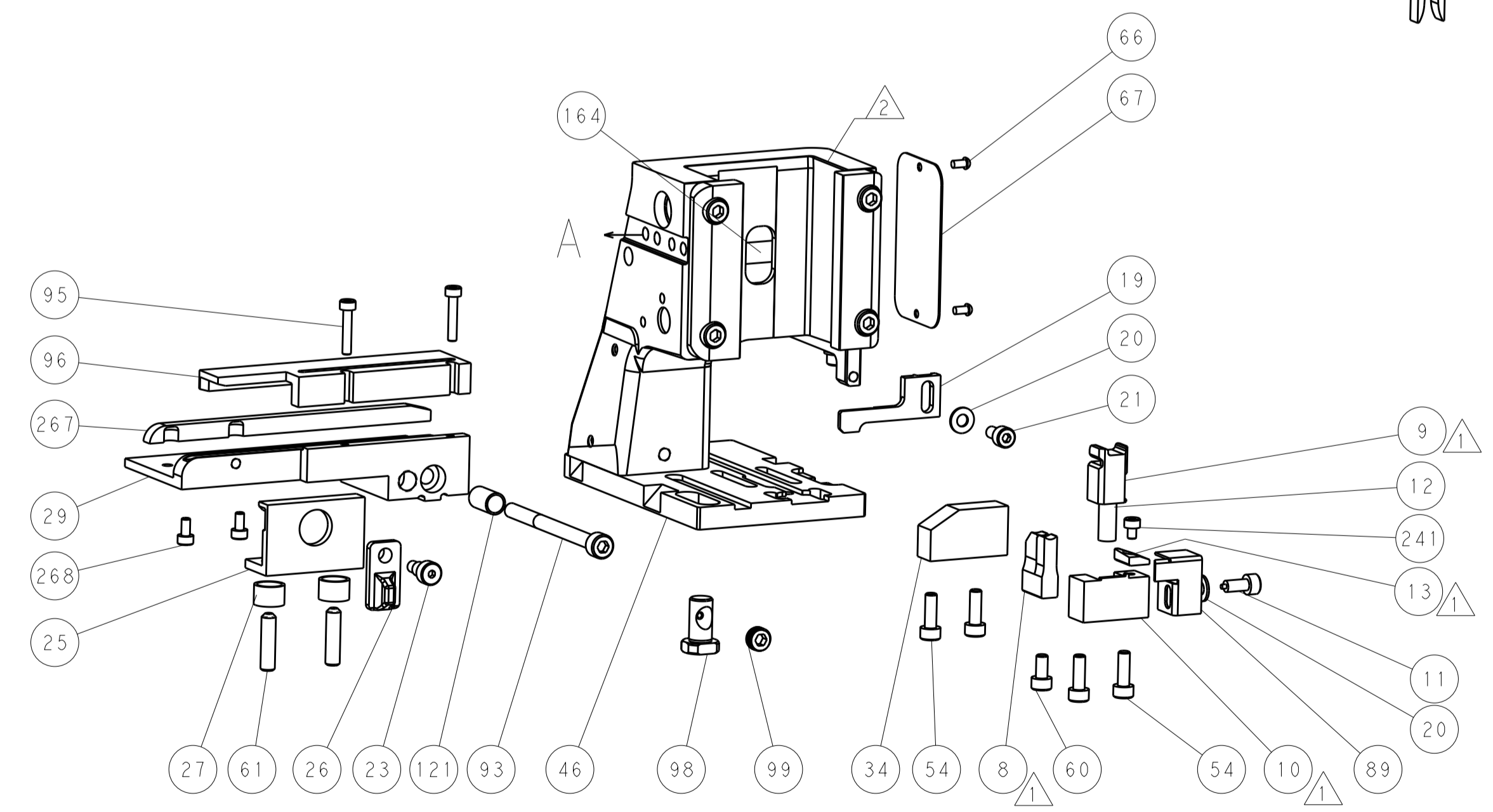
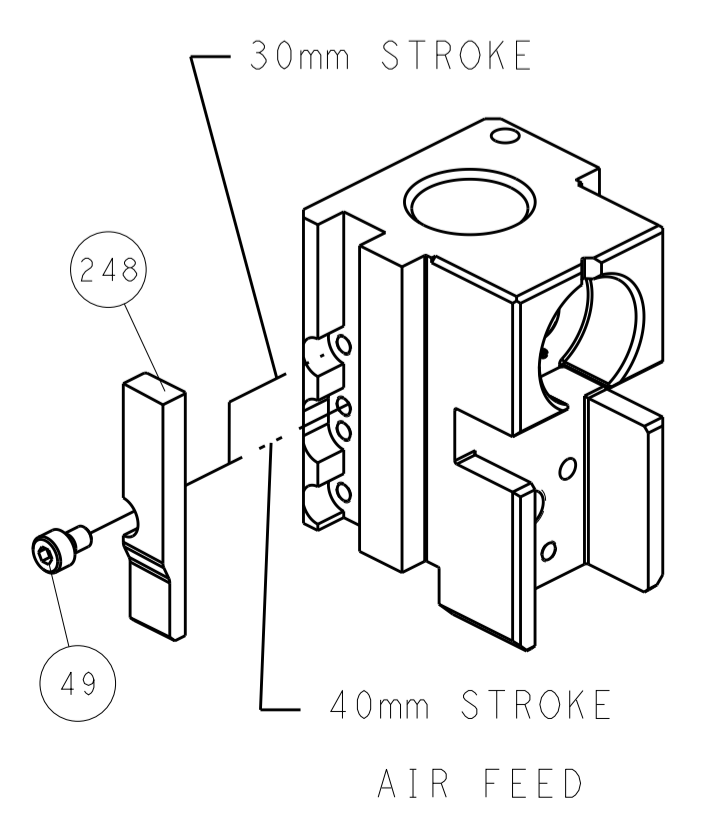


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITION



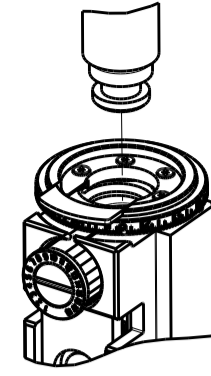
FENCE POSITION GUIDE BY WIRE BARREL

ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X.ZHAO 25SEP2014		TE Connectivity	
mm	0 PLC	±		CHK: T.ELBIN 25SEP2014	NAME: Ocean Side Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APP'D: H.GUO 25SEP2014	SIZE: CAGE CODE: DRAWING NO: 00779		RESTRICTED TO
	2 PLC	±		PRODUCT SPEC:		SCALE: 1:2 SHEET 2 OF 4 REV D	
	3 PLC	±		APPLICATION SPEC:		C=2266480	
	4 PLC	±		WEIGHT:		Customer Accessible Production Drawing	
MATERIAL:	FINISH:						

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266480-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266480-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.25 mm [1.67]	F
INSUL	5.08 mm [2.00]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: G & H TERMINAL LEAR CRIMP SPECIFICATION	
TERMINAL NAME: G & H TERMINAL	
WIRE STRIP LENGTH 6.20-6.80 mm [2.44-.268 IN]	INSULATION DIAMETER RANGE ∅3.40-4.30 mm [1.34-.169 IN]
TERMINAL APPLICATION SPECIFICATION LEAR SPEC Rev - 25612 Rev 2	
TERMINALS APPLIED	
TE TERMINAL	G & H TERMINAL
1572672-1	25612.306.421

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm ²	2.90 +/- 0.10 [1.14 +/- .004]	5.2
4.00mm ²	2.50 +/- 0.10 [1.098 +/- .004]	9.0



*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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REV	DATE	BY	APPV
A	66				

LOC	DIST	REV	DATE	BY	APPV
-	2	1-2168083-1			
-	1	1-1633782-0			
-	1	1803078-2			
-	1	2119082-3			
-	1	2079764-1			
△	1	2119083-1			
-	1	7-18023-7			
-	1	2844940-2			
-	REF	994970-2			
-	1	2119641-2			
-	1	2168083-8			
-	4	2168083-9			
-	1	1-1803583-0			
-	1	1803516-2			
-	1	1-22281-8			
-	1	2844908-1			
-	1	2844907-1			
-	1	1490899-5			
-	2	1-2168083-3			
-	1	2168083-6			
-	1	318563-1			
-	1	1-455888-6			
-	1	1803607-3			
-	1	2119740-1			
-	2	2168078-1			
-	2	2-18032-5			
-	1	5-18022-5			
-	1	1-1338683-1			
-	2	2168083-8			
-	1	5018030-1			
-	1	690753-2			
-	1	18023-9			
-	1	1803602-2			
-	1	4-1752356-5			
-	1	2844938-5			
-	1	455888-3			
-	2	22283-1			
-	1	356835-1			
-	1	240792-1			
-	1	980371-4			
-	1	2168083-2			
-	2	1-18028-2			
-	1	2119533-1			
△	1	2119806-1			
-	1	3-22280-3			
-	1	1-356885-3			
△	1	2119805-1			
△	1	454276-5			
△	1	1-1803171-5			
-	1	240641-5			
-	-	-			
-	1	1-2119757-2			
-	1	5-238011-4			
△	1	6-1803221-2			
-	1	455888-5			
△	1	7-1633738-8			
-77	-22	PART NO			
		DESCRIPTION			
		ITEM NO			

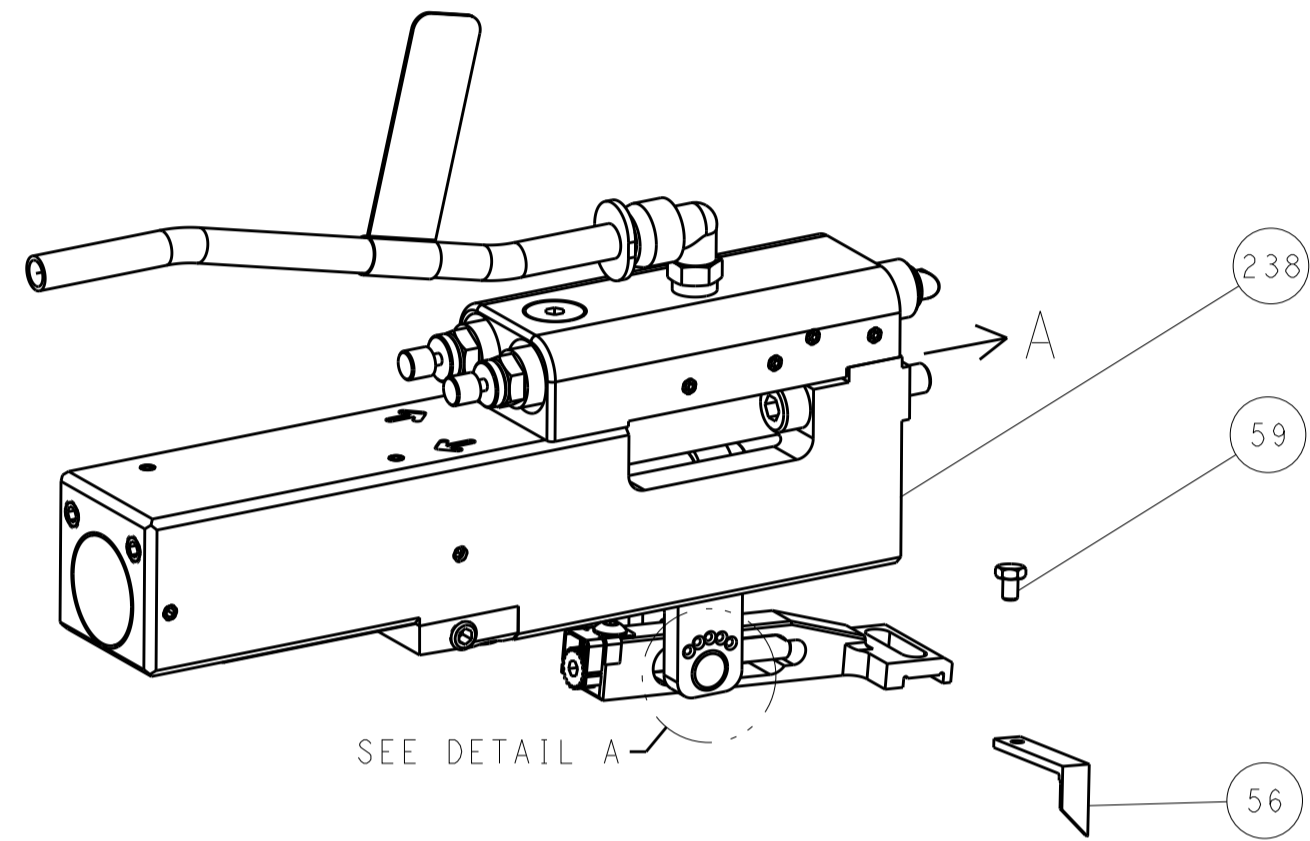
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	25SEP2014	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	CHK	25SEP2014	
		APPV	25SEP2014	
MATERIAL	FINISH	NAME	Ocean Side Feed Applicator	RESTRICTED TO
		SIZE	A1 00779	
		SCALE	1:2	
		SHEET	3 of 4	
		REV	D	

Customer Accessible Production Drawing

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

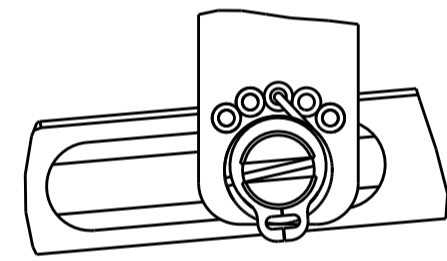
FEED TYPE

PNEUMATIC



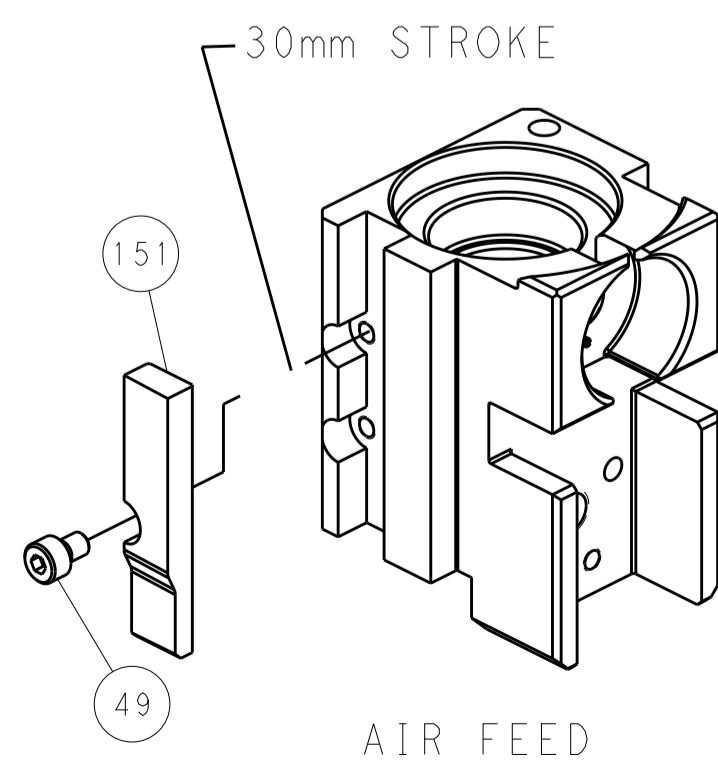
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

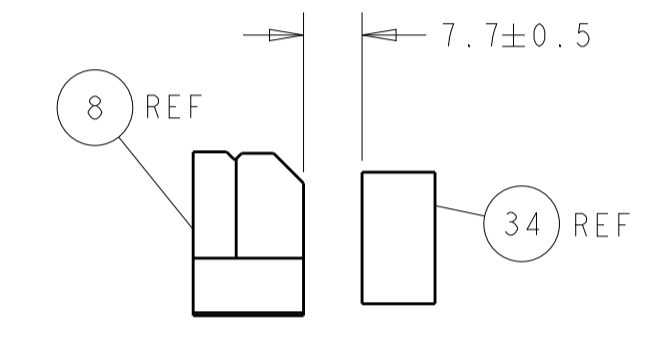
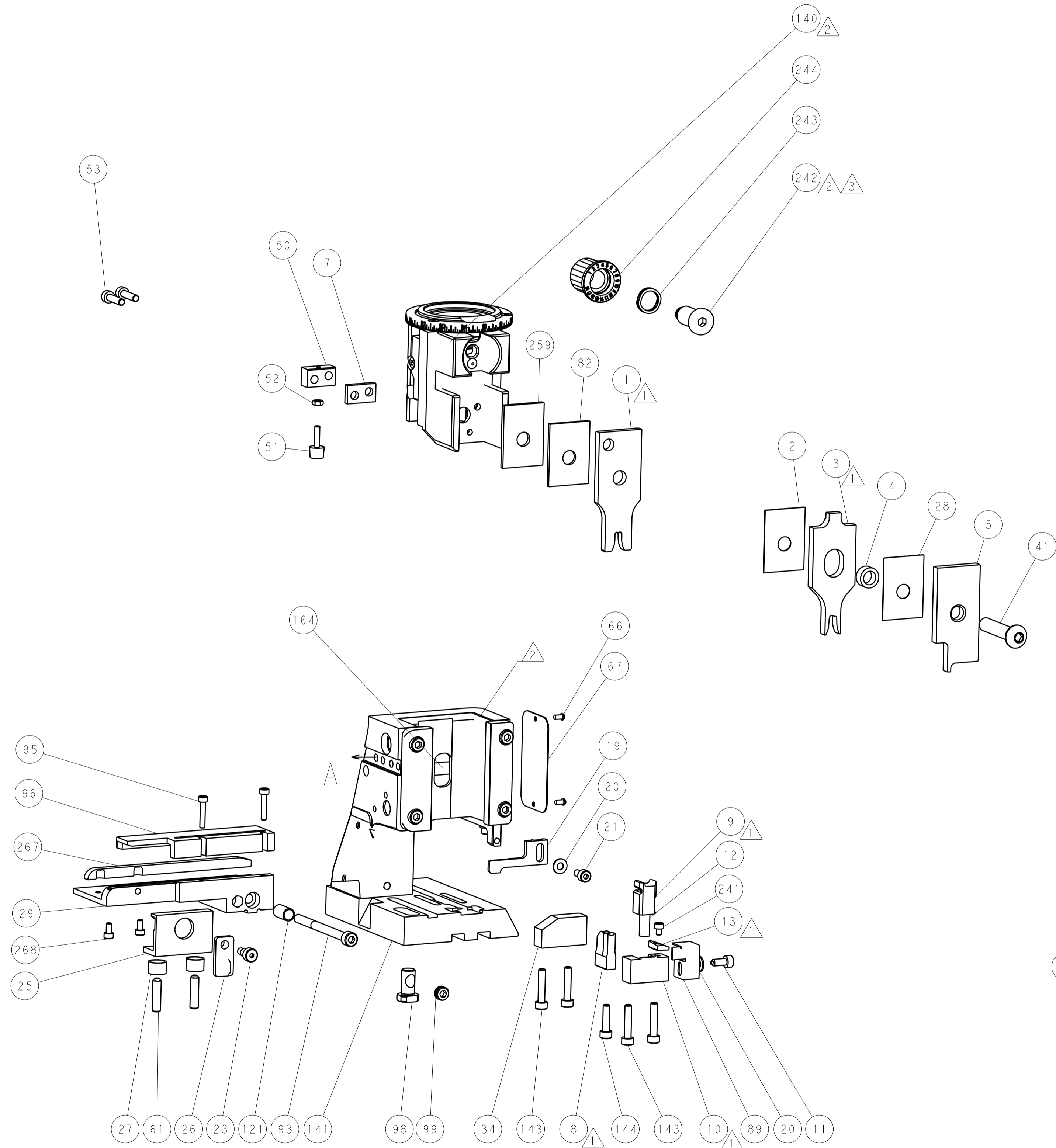


DETAIL A

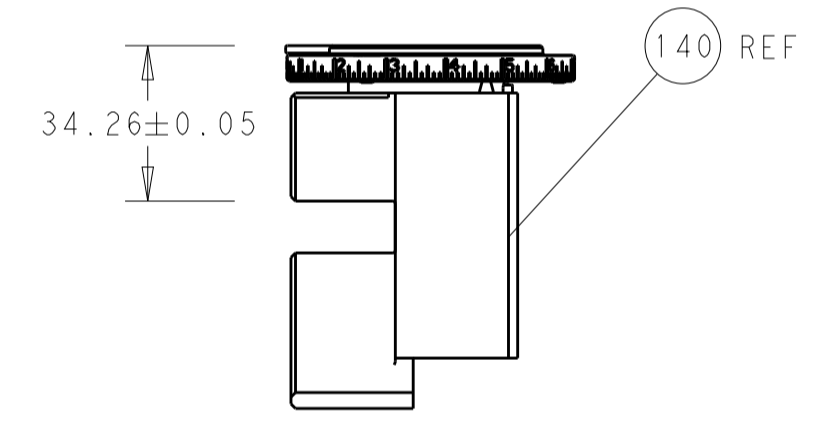
CAM POSITION



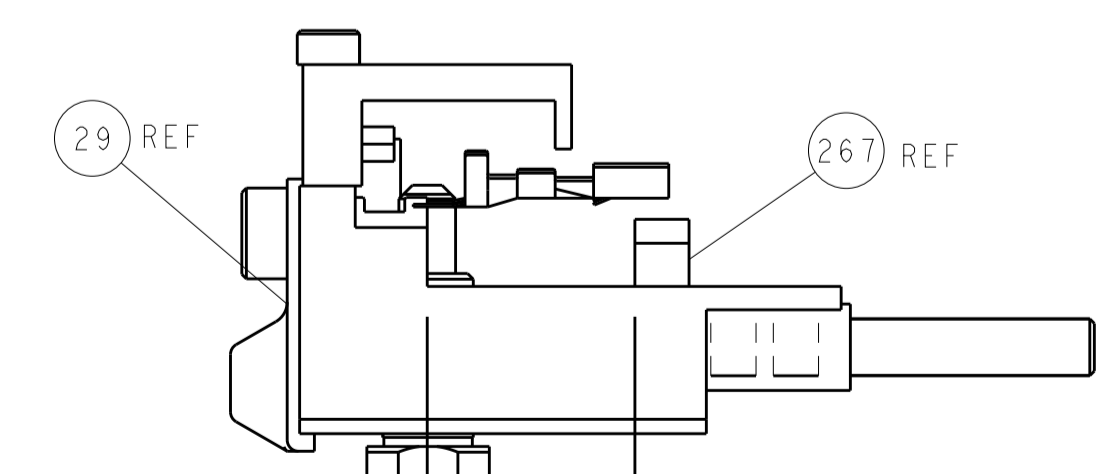
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



FENCE POSITION
GUIDE BY WIRE BARREL

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

LOC	DIST	REV	DATE	BY	CHKD	APVD
A	66					

REVISIONS			
NO.	DESCRIPTION	DATE	BY
1	SEE SHEET 1		

<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCOO ELECTRONICS CORPORATION. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. PERMISSION TO COPY MUST BE OBTAINED FROM TYCOO ELECTRONICS CORPORATION.</small>		DWN: X_ZHAO CHK: T_ELFIN APVD: H_GUO	25SEP2014 25SEP2014 25SEP2014	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266480	RESTRICTED TO: SCALE: 1:2 SHEET: 4 OF 4 REV: D