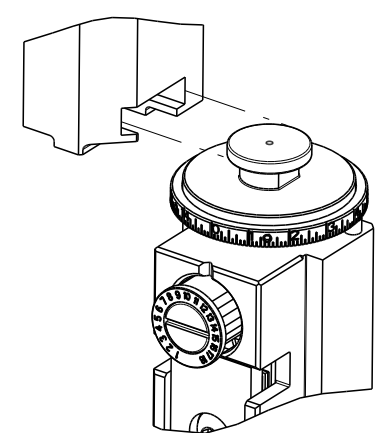


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266822-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266822-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266822-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.42 mm [.174]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: YAZAKI TERMINAL	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.00-5.50 mm [.197-.217 IN]	∅
TERMINAL APPLICATION SPECIFICATION	(A)7114-4140-02 Rev WA1738

TERMINALS APPLIED					SEAL INSULATION DIAMETER RANGE
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL		∅
(A) 1572595-1	(A) 7114-4140-02	1572596-1	7158-3081-50		1.40-2.10 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm ²	1.45+/-0.05 [.057+/-0.002]	6.4
1.00mm ²	1.45+/-0.05 [.057+/-0.002]	6.4
0.80mm ²	1.35+/-0.05 [.053+/-0.002]	7.4
0.50mm ²	1.25+/-0.05 [.049+/-0.002]	8.5

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: YAZAKI TERMINAL	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.00-5.50 mm [.197-.217 IN]	∅
TERMINAL APPLICATION SPECIFICATION	(B)7116-4140-02 Rev WA1809

TERMINALS APPLIED					SEAL INSULATION DIAMETER RANGE
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL		∅
(B) 1572594-1	(B) 7116-4140-02	1572596-1	7158-3081-50		1.40-2.10 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm ²	1.55+/-0.05 [.061+/-0.002]	6.4
1.00mm ²	1.55+/-0.05 [.061+/-0.002]	6.4
0.80mm ²	1.40+/-0.05 [.055+/-0.002]	7.4
0.50mm ²	1.30+/-0.05 [.051+/-0.002]	8.5

- 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.
- 7 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 8 CUT TO LENGTH AT ASSEMBLY.

***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.

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66			RELEASED	21JUL2015	JH	CT
				ECR-18-017771	12NOV2018	TB	CT
				ECR-22-149688	17AUG2022	LG	RK
				ECR-22-152214	12SEP2022	TB	JH

-	1	1	1803078-3	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-1	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	2844940-1	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1-690438-0	FRONT STRIP GUIDE	96	
-	1	1	455888-4	SPACER, CRIMPER	82	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1803096-1	EXTENSION PLATE	78	
-	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	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	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57	
-	1	1	1-1338683-6	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1-1803583-7	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	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-6	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-3	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-4	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	1803013-1	STRIPPER, SIDE FEED	19	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	2119805-7	SHEAR HOLDER, FRONT	10	
-	1	1	318059-9	FLOATING SHEAR, FRONT	9	
-	1	2	1	2-1633922-7	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1-1803080-1	DEPRESSOR, SHEAR	5	
-	1	1	2-238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	1	1803248-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-6	SPACER, CRIMPER	2	
-	1	2	1	3-456407-8	CRIMPER, WIRE PREMIUM	1

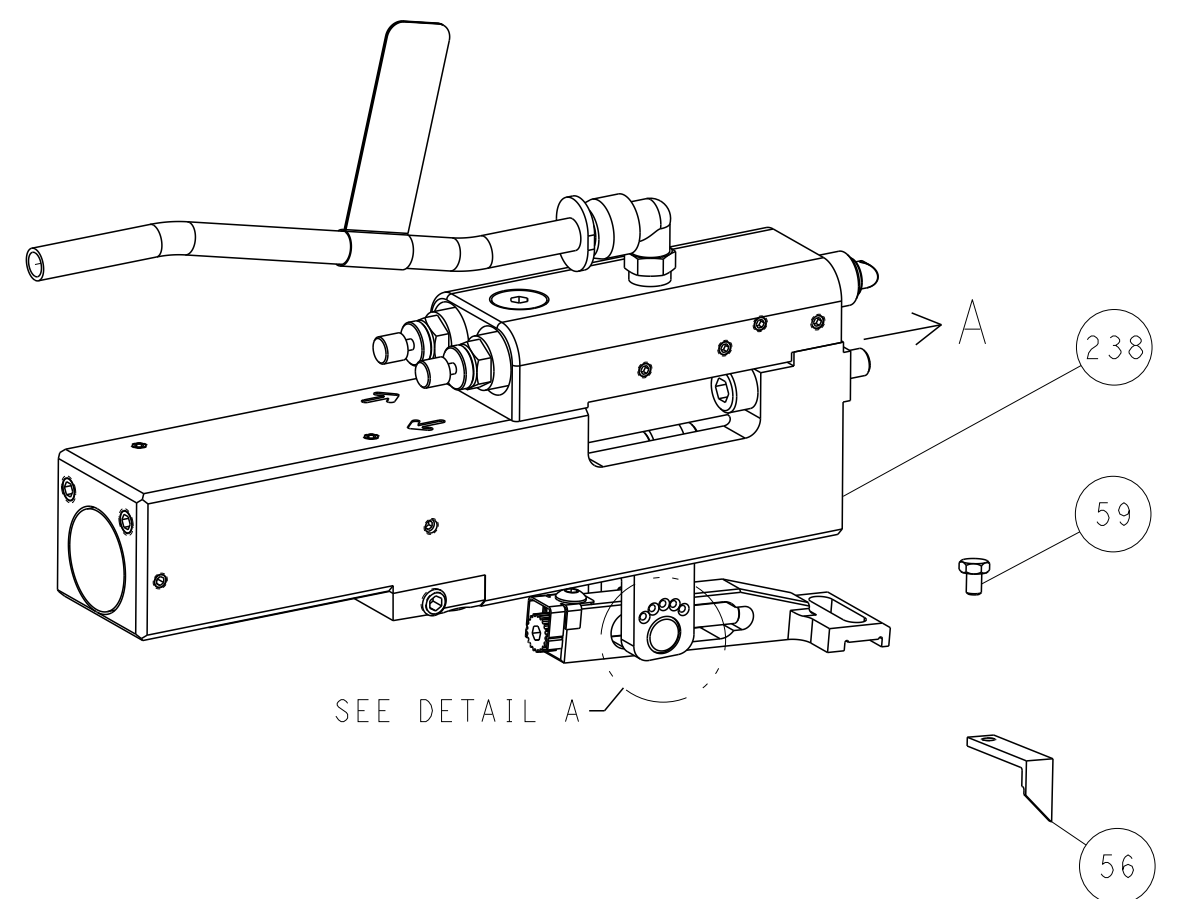
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APPLICATOR DATA		TERMINAL DATA		TERMINAL DATA		TERMINAL DATA		TERMINAL DATA		TERMINAL DATA	

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	SEE SHEET 1	-	-	-

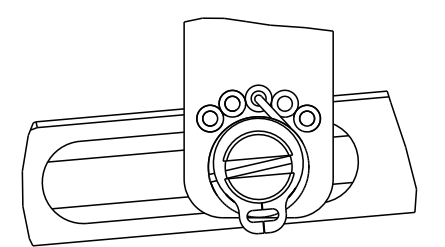
FEED TYPE

PNEUMATIC



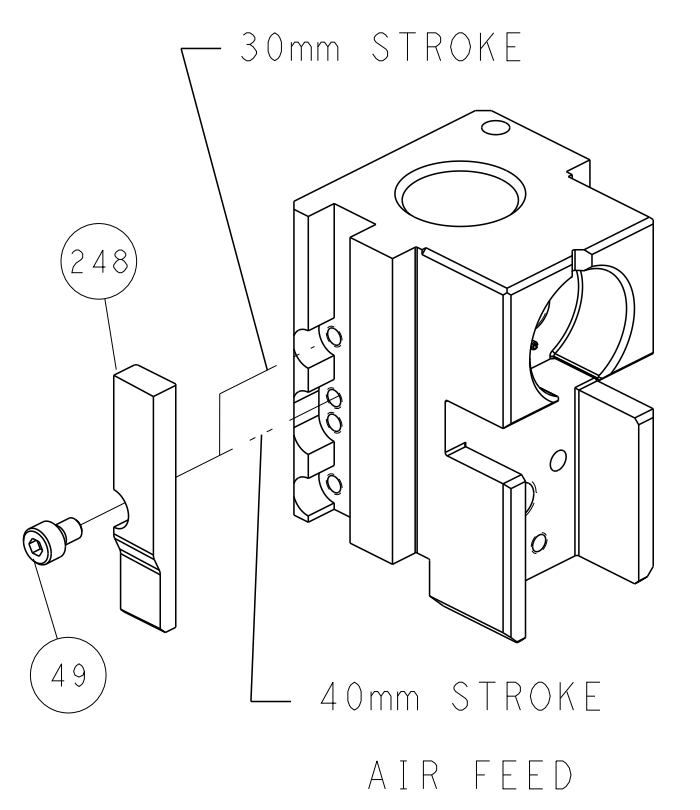
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

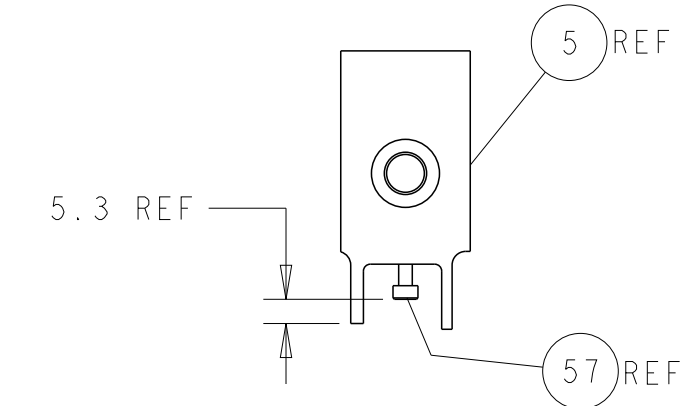
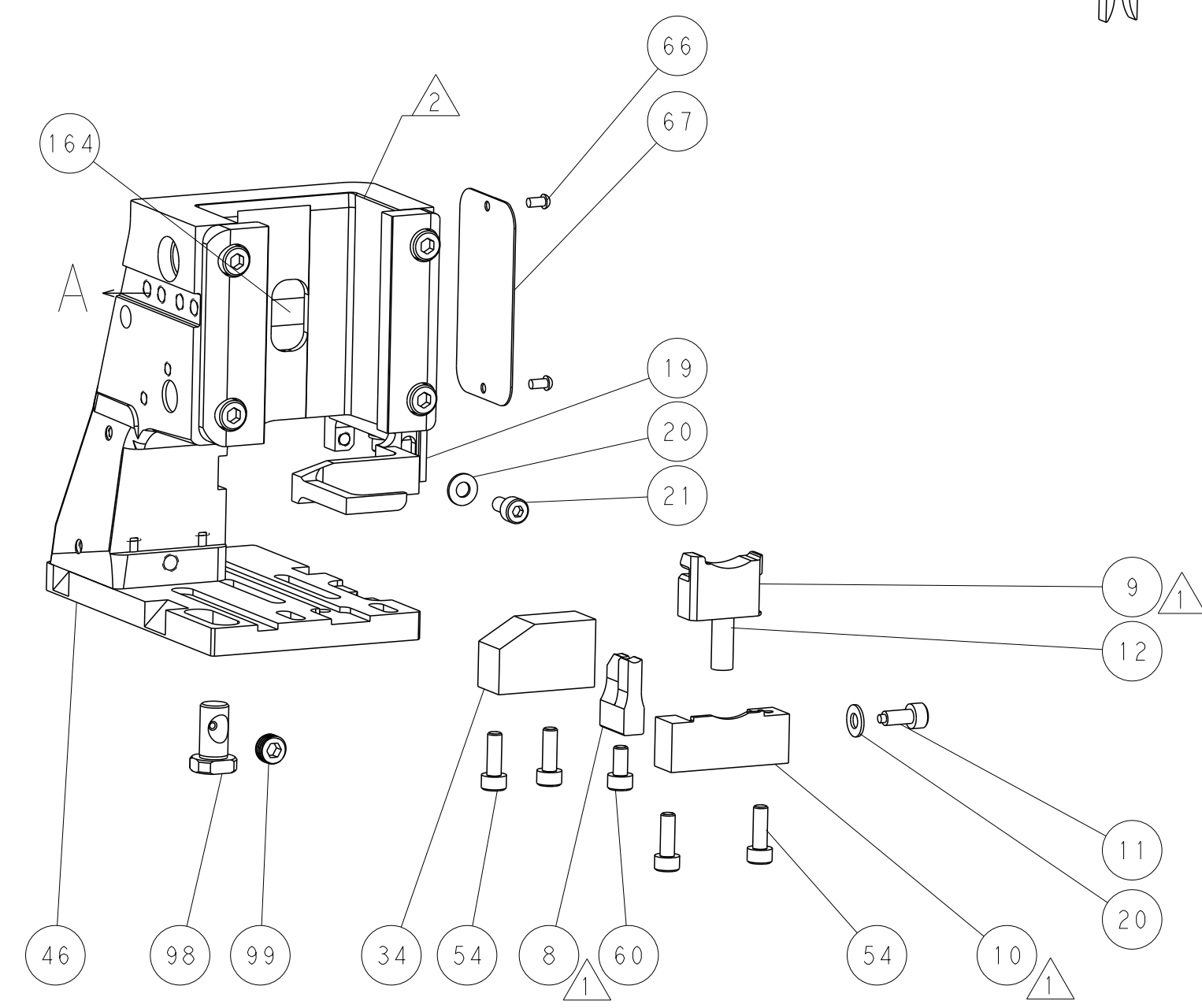
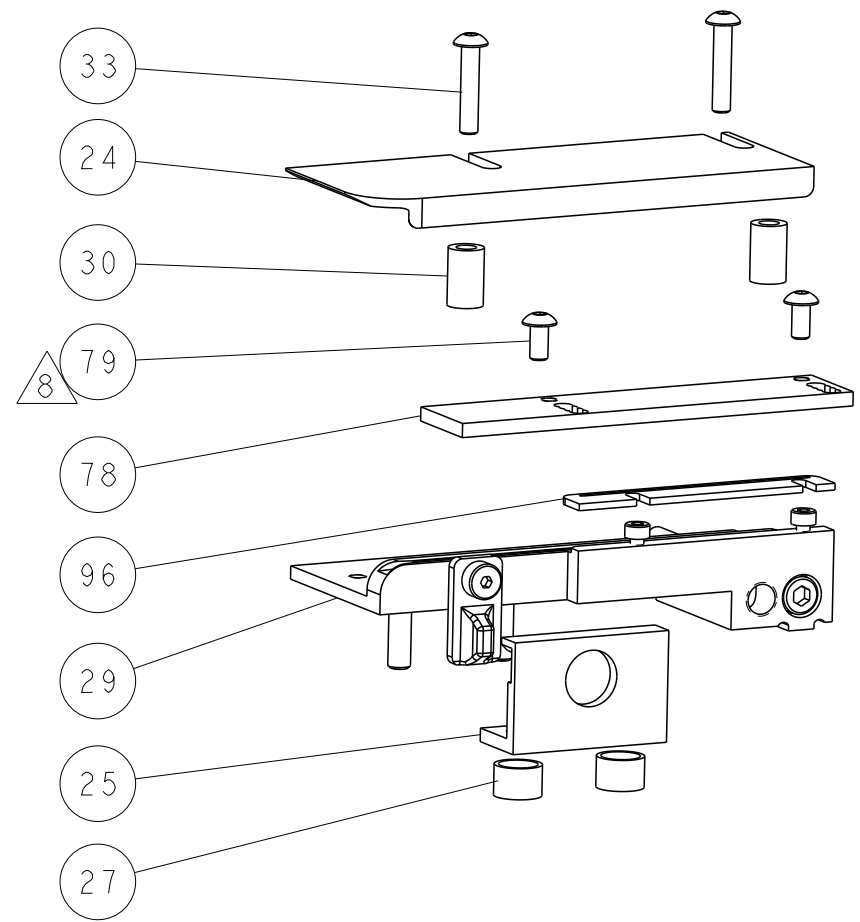


DETAIL A

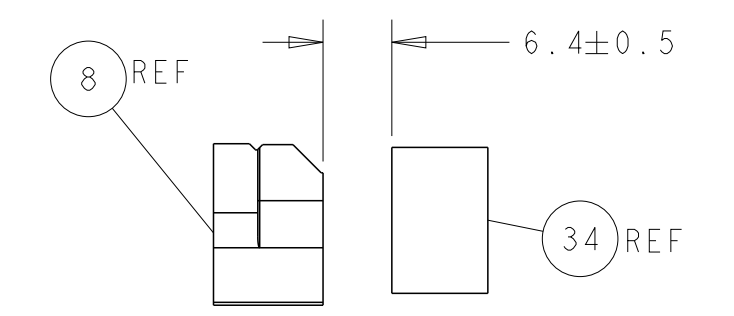
CAM POSITION



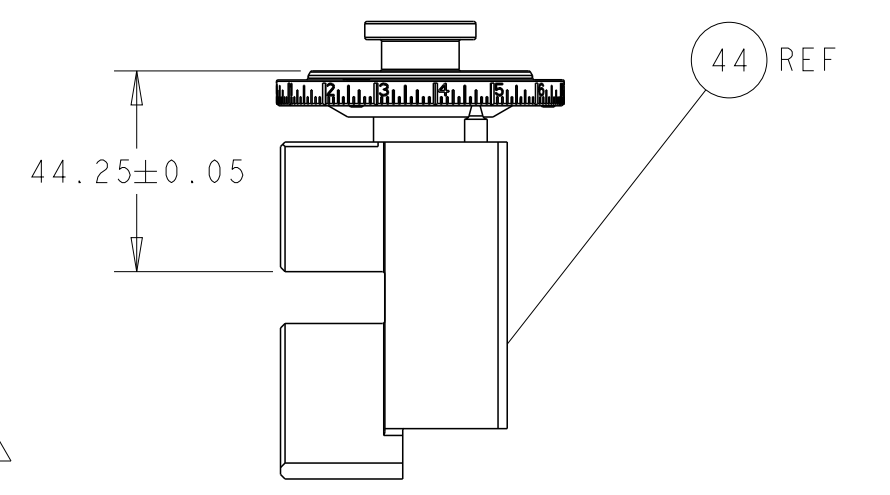
AIR FEED



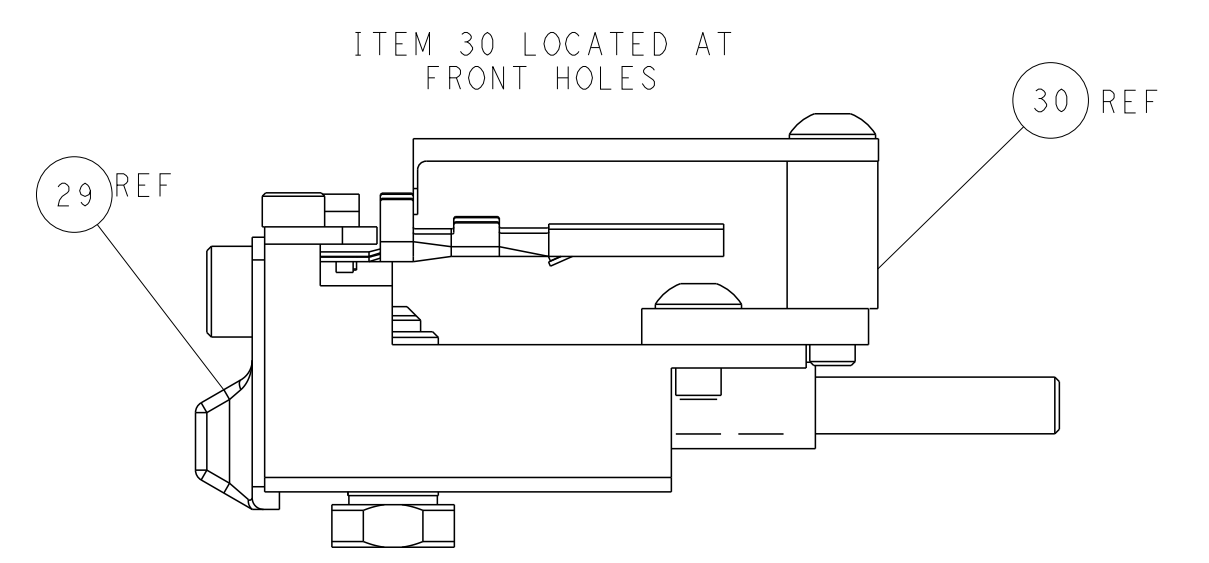
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



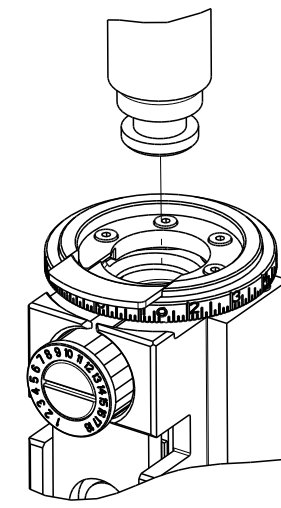
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	19JUN2015	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	19JUN2015	
	3 PLC ±	4 PLC ±	5 PLC ±	APVD	19JUN2015	NAME
	6 PLC ±	ANGLES ±	FINISH ±	U. GUO	19JUN2015	Product Spec
MATERIAL						APPLICATION SPEC
						SIZE
						CAGE CODE
						DRAWING NO
						RESTRICTED TO
						WEIGHT
						Customer Accessible Production Drawing
						SCALE
						1:2
						SHEET
						2
						OF 4
						REV
						D

8	7	6	5	4	3	2	1
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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2266822-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2266822-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [1.00]	F
INSUL	4.42 mm [1.74]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: YAZAKI TERMINAL	
WIRE STRIP LENGTH 5.00-5.50 mm [1.97-.217 IN]	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION (A)7114-4140-02 Rev WA1738	-

TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	SEAL INSULATION DIAMETER RANGE
(A) 1572595-1	(A) 7114-4140-02	1572596-1	7158-3081-50	Ø 1.40-2.10 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.45+/-0.05 [1.057+/-0.002]	6.4
1.00mm2	1.45+/-0.05 [1.057+/-0.002]	6.4
0.80mm2	1.35+/-0.05 [1.053+/-0.002]	7.4
0.50mm2	1.25+/-0.05 [1.049+/-0.002]	8.5

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: YAZAKI TERMINAL	
WIRE STRIP LENGTH 5.00-5.50 mm [1.97-.217 IN]	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION (B)7116-4140-02 Rev WA1809	-

TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	SEAL INSULATION DIAMETER RANGE
(B) 1572594-1	(B) 7116-4140-02	1572596-1	7158-3081-50	Ø 1.40-2.10 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.55+/-0.05 [1.061+/-0.002]	6.4
1.00mm2	1.55+/-0.05 [1.061+/-0.002]	6.4
0.80mm2	1.40+/-0.05 [1.055+/-0.002]	7.4
0.50mm2	1.30+/-0.05 [1.051+/-0.002]	8.5



- △ 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.
- △ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- △ CUT TO LENGTH AT ASSEMBLY.

***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.

LOC	DIST	REV	DATE	BY	APPD
A	66				

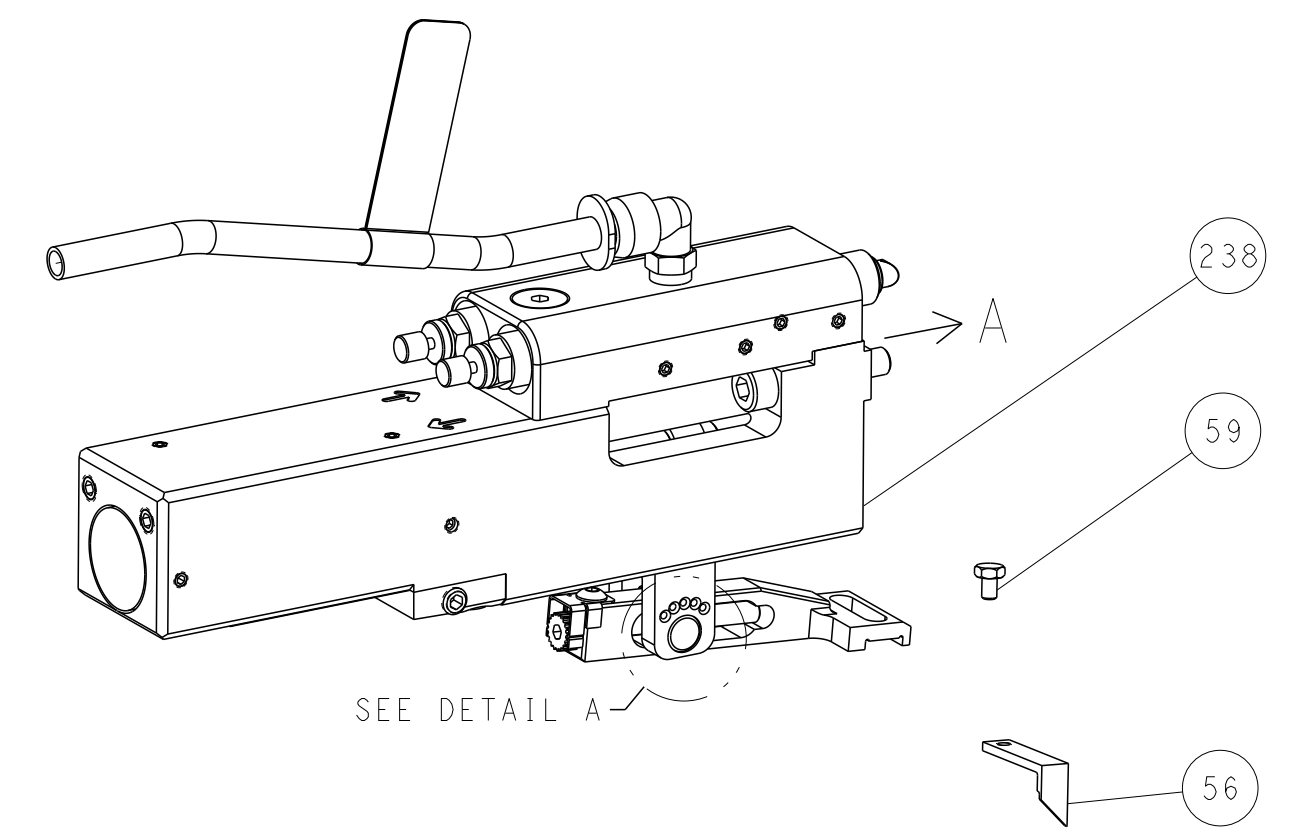
REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-	1			1803078-3 SPACER, PRECISION	259
-	1			2119082-1 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1			2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
△	1			2119083-1 RETAINER, INSULATION DIAL	242
-	1			2844940-1 AIR FEED MODULE	238
-	REF			994970-2 COUNTER, MAGNETIC	164
-	1			2119641-2 FEED CAM, AIR FEED	151
-	1			2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4			2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1			1-1803583-8 APPLICATOR BASIC ASSEMBLY, SF	141
-	1			1803516-2 RAM ASSEMBLY, SF PACIFIC	140
-	1			2844908-1 SCREW, LOCKING	99
-	1			2844907-1 POST, LOCKING	98
-	1			1-690438-0 FRONT STRIP GUIDE	96
-	1			455888-4 SPACER, CRIMPER	82
△	2			2079383-4 SCR, BHSC, RoHS (M4 X 8)	79
-	1			1803096-1 EXTENSION PLATE	78
-	1			1803607-3 DOCUMENTATION PACKAGE	71
-	1			2119740-1 TAG IDENTIFICATION	67
-	2			2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1			5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
△	1			1-2168083-3 SCR, SKT HD CAP, RoHS, M3 X 16	57
-	1			1-1338683-6 FEED PAWL	56
-	2			1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1			5018030-1 NUT, HEX, REG, RoHS, M3	52
-	1			811242-5 BUMPER, HOLD DOWN	51
-	1			690753-2 SPACER, TONKER	50
-	1			18023-9 SCR, SKT HD CAP M4 X 6.0	49
-	1			1803602-2 SCR, BHSC, RoHS (M8 X 40)	41
-	1			1752356-3 SUPPORT, TERMINAL	34
-	2			2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2			2-2844962-1 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1			2844992-6 ASSEMBLY, STRIP GUIDE	29
-	1			455888-3 SPACER, CRIMPER	28
-	2			22283-1 SPRING, COMPRESSION	27
-	1			240792-1 DRAG, TERMINAL	25
-	1			1320928-4 STRIP GUIDE	24
-	1			2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2			1-18028-2 WASHER, FLAT, REG M4	20
-	1			1803013-1 STRIPPER, SIDE FEED	19
-	1			3-22280-3 SPRING, COMPRESSION	12
-	1			1-356885-4 STOP, SHEAR	11
△	1			2119805-7 SHEAR HOLDER, FRONT	10
△	1			318059-9 FLOATING SHEAR, FRONT	9
△	1			2-1633922-7 ANVIL, COMBINATION	8
-	-			-	7
-	-			-	6
-	1			1-1803080-1 DEPRESSOR, SHEAR	5
-	1			2-238011-7 BLOCK, CRIMPER SPACER	4
△	1			1803248-3 CRIMPER, INSULATION O PREMIUM	3
-	1			1-455888-6 SPACER, CRIMPER	2
△	1			3-456407-8 CRIMPER, WIRE PREMIUM	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:		DWG: J. HOU 19JUN2015		CHK: L. ZHANG 19JUN2015		APVD: J. GUO 19JUN2015		NAME: Ocean Side Feed Applicator	
0 PLC	±	1 PLC	±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
2 PLC	±	3 PLC	±	WEIGHT	A1	00779	SCALE				
4 PLC	±	ANGLES	±	FINISH	C=2266822		SHEET				
MATERIAL					Customer Accessible Production Drawing		1:2	SHEET 3 OF 4		REV D	

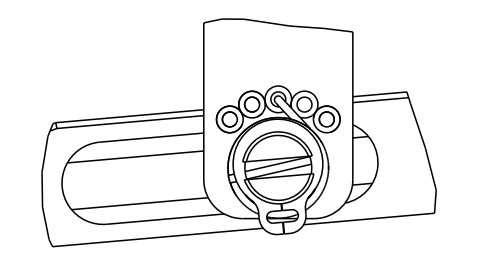
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC



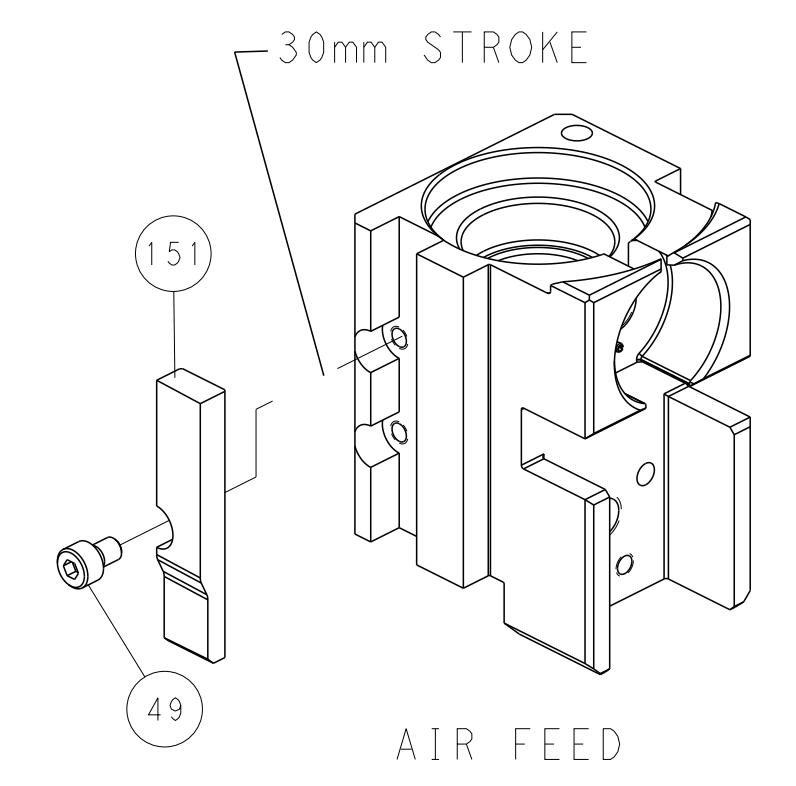
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

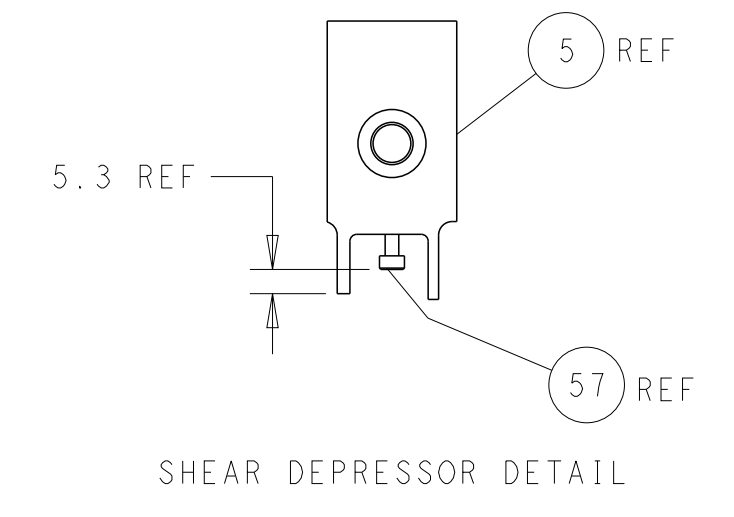
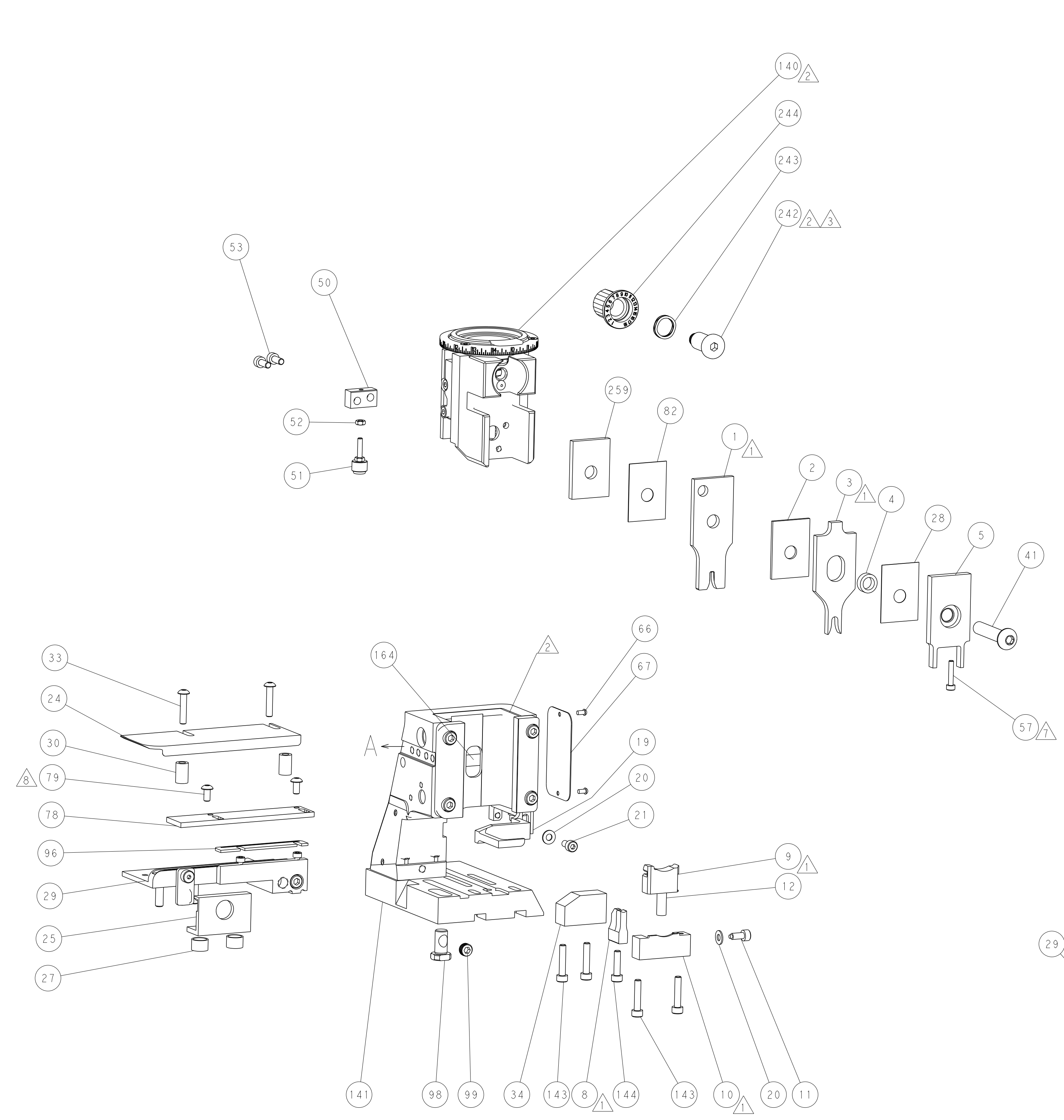


DETAIL A

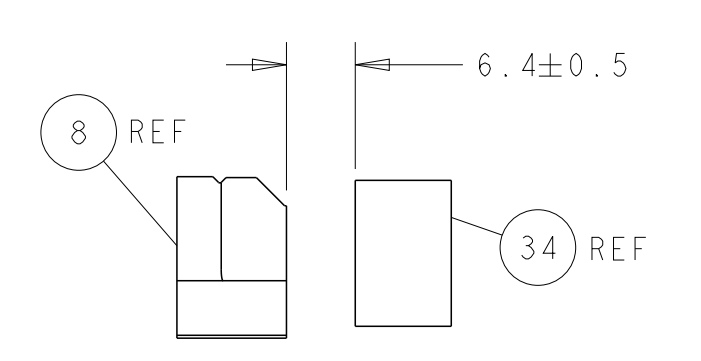
CAM POSITION



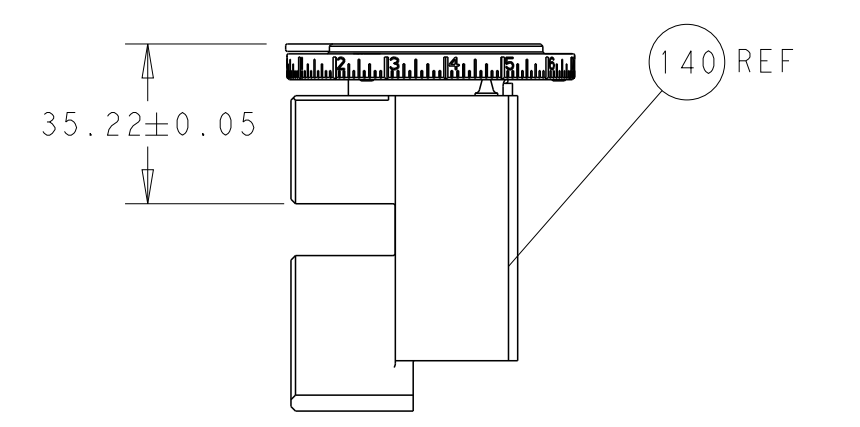
AIR FEED



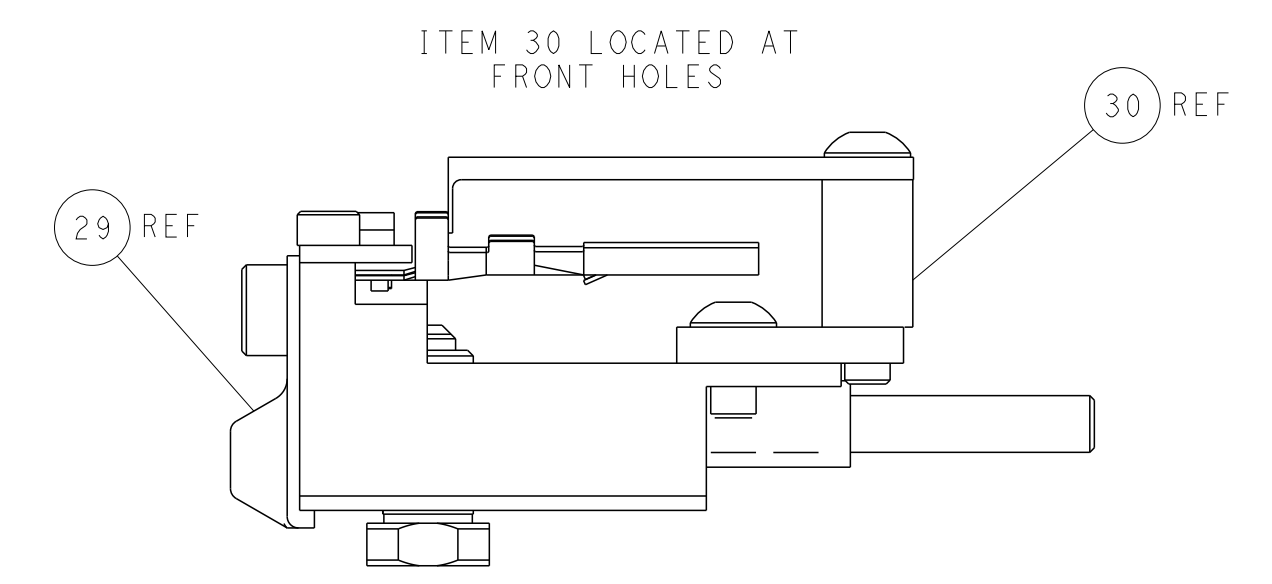
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small> <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small>		DWG: J. HOU 19JUN2015 CHK: L. ZHANG 19JUN2015 APVD: H. GUO 19JUN2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266822 WEIGHT: SCALE: 1:2 SHEET: 4 OF 4 REV: D	RESTRICTED TO:
MATERIAL:		Customer Accessible Production Drawing	