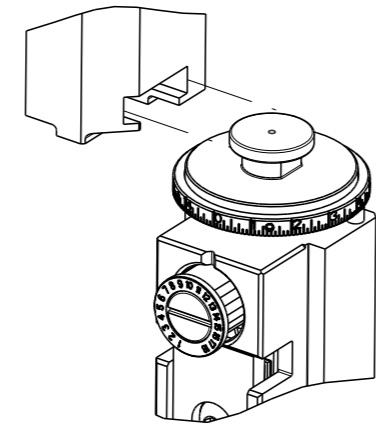


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266652-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266652-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266652-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266652-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266652-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

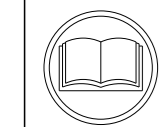


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	2.80 mm [.110]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: 3.96mm PITCH SPOX CRIMP TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		∅1.30-3.00 mm [.051-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-639005300 Rev A		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
286982-1	08-70-1031	286982-3	39-00-0409
286982-2	39-00-0021	286982-4	39-00-0416

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.80mm ²	1.15+/-0.05 [.045+/-0.002]	6.2
20 AWG OR 0.50mm ²	1.12+/-0.05 [.044+/-0.002]	6.5
22 AWG OR 0.35mm ²	1.01+/-0.05 [.040+/-0.002]	7.6
24 AWG OR 0.30mm ²	0.95+/-0.05 [.037+/-0.002]	8.2



- 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. 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.

LOC	DIST	REVISIONS					
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A	66	A		RELEASED	13FEB2015	KH	TE
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		C		ECR-19-011319	18JUL2019	FJ	TE

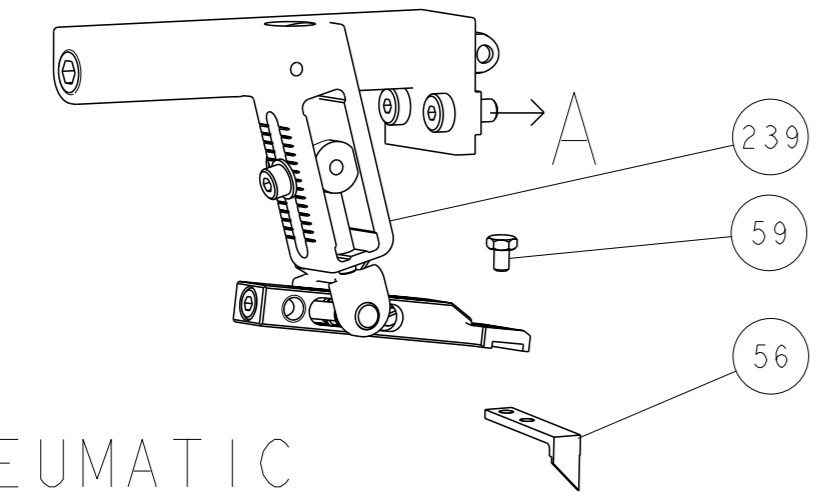
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-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL 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	455888-6	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	1	811242-6	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	1-1752356-9	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	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	2-1803171-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	6-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
-	1	2	2	1	1	2-1633738-0	CRIMPER, WIRE	1
-	77	72	71	-2	-1	PART NO	ITEM NO	

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

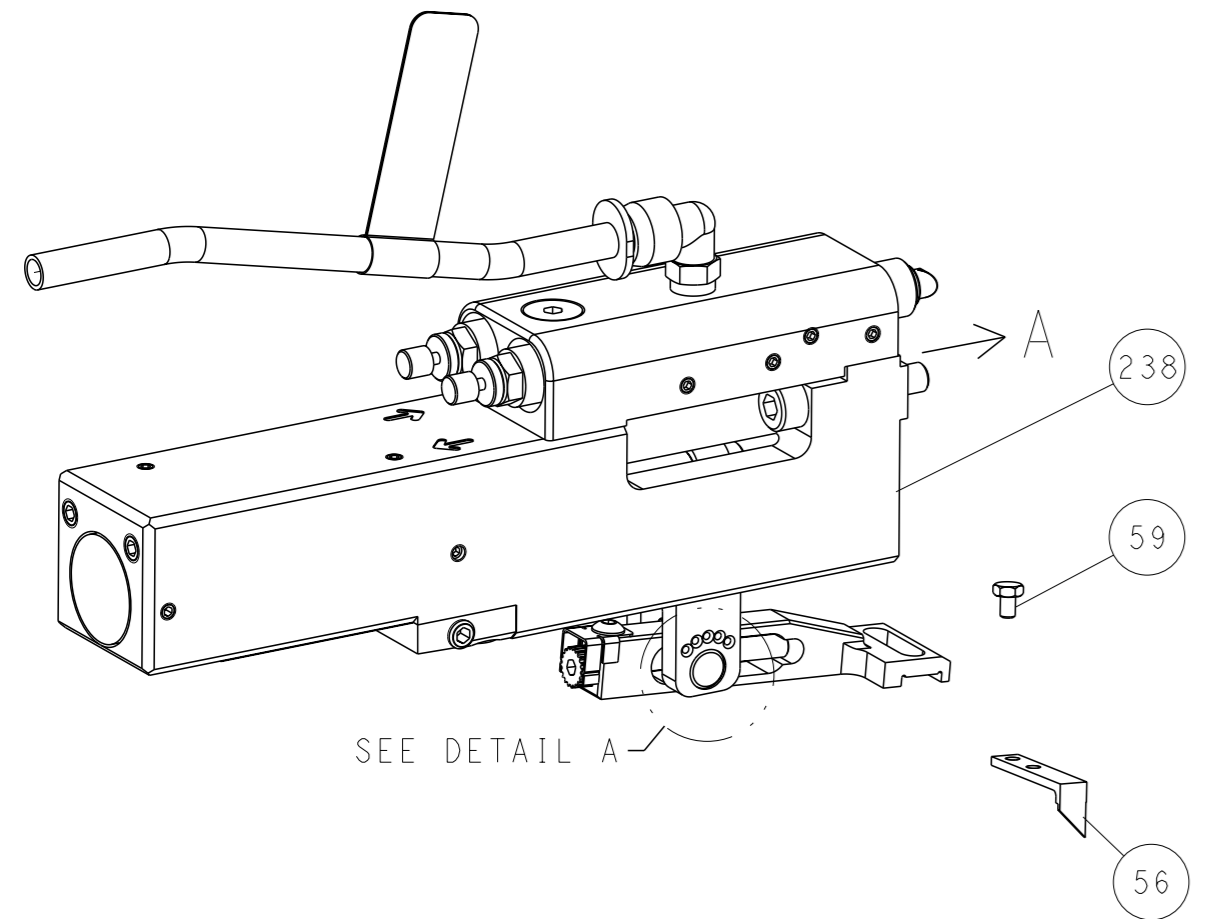
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	ANGLES	FINISH					
MATERIAL				WEIGHT		SCALE	RESTRICTED TO
						1:2	Customer Accessible Production Drawing

LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL



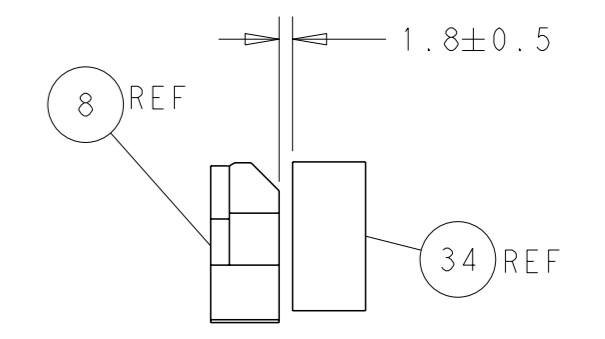
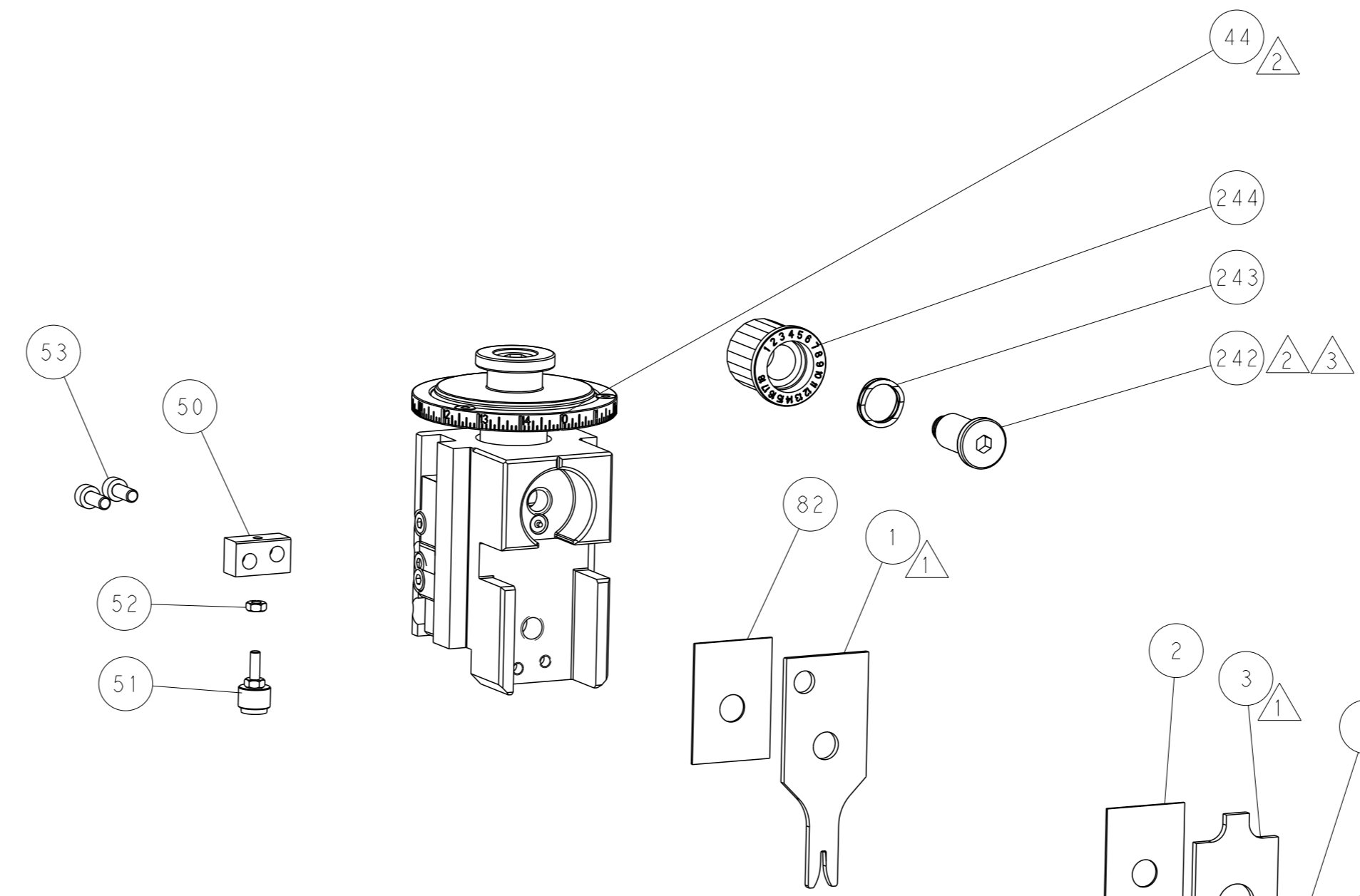
PNEUMATIC



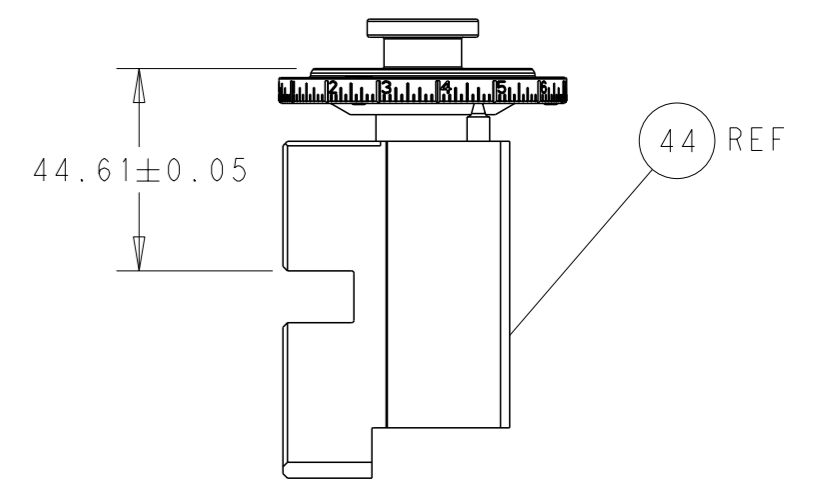
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



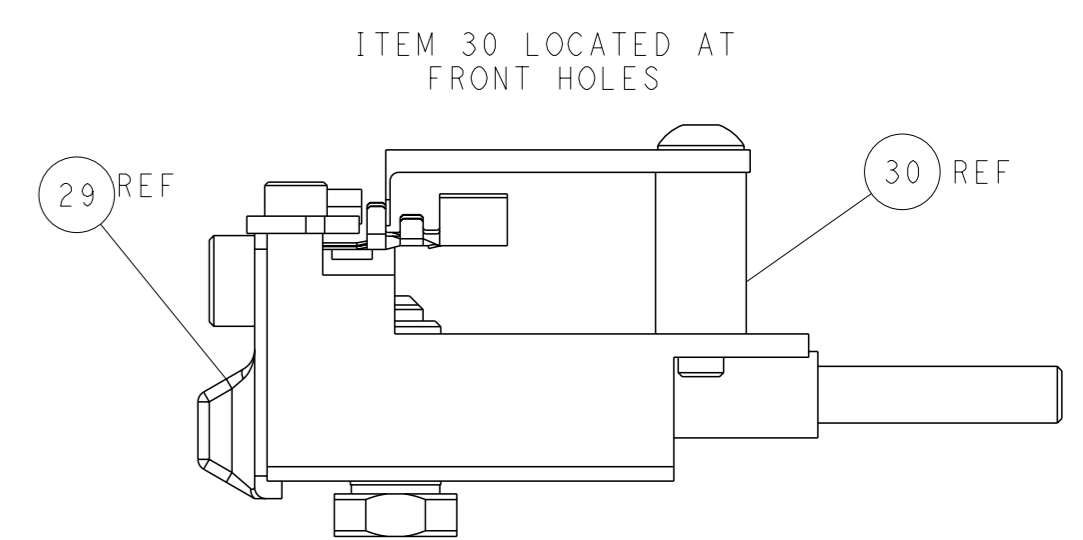
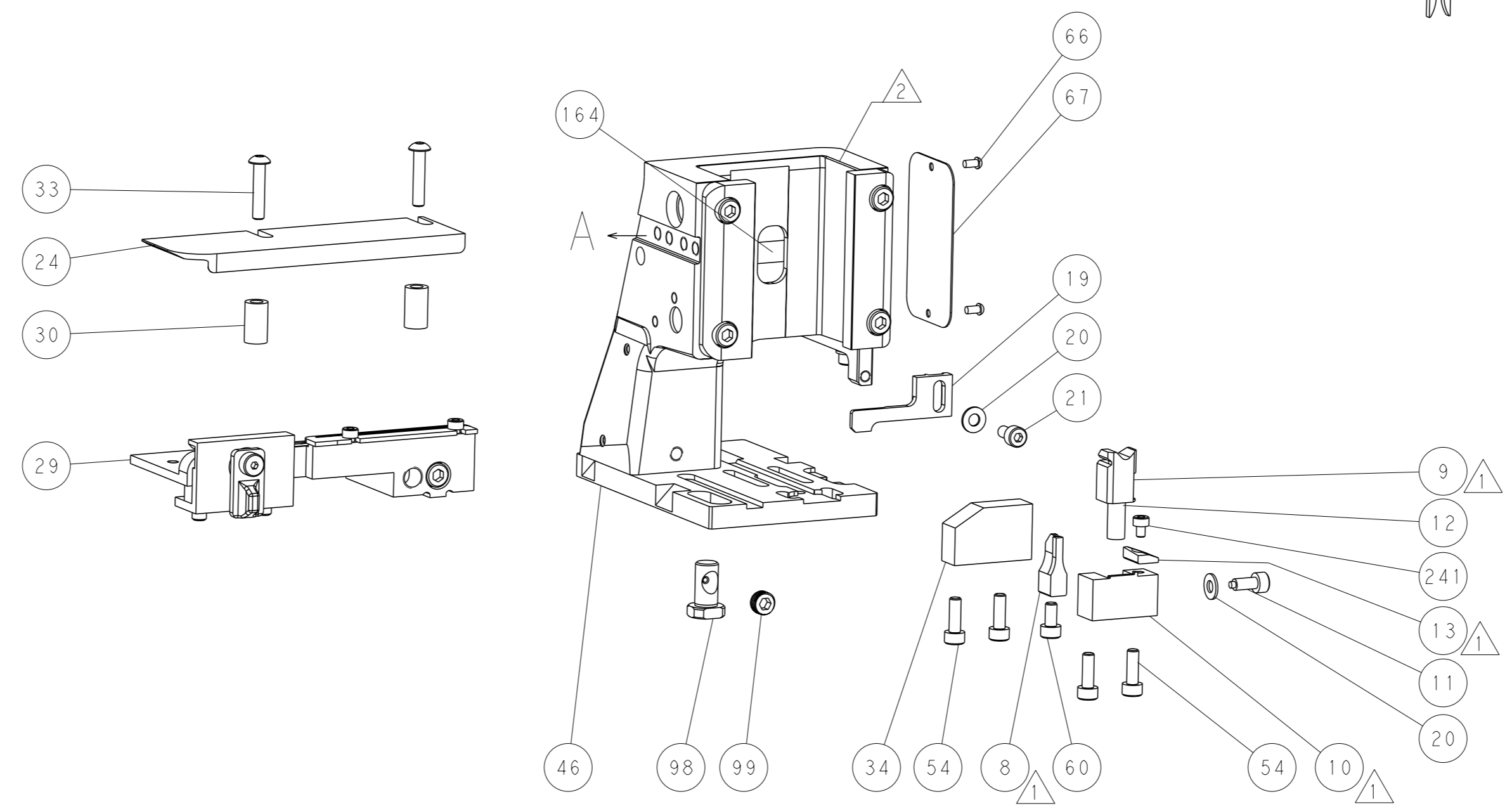
DETAIL A



TERMINAL SUPPORT LOCATION

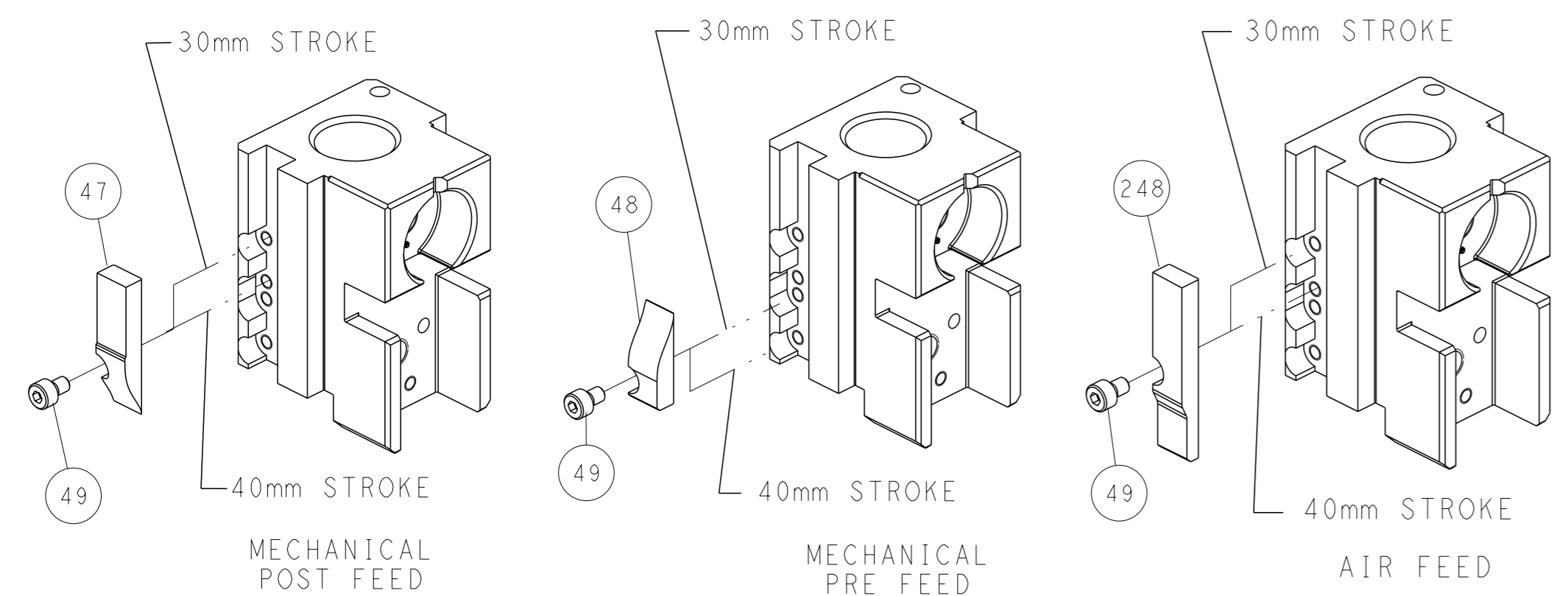


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

CAM POSITIONS

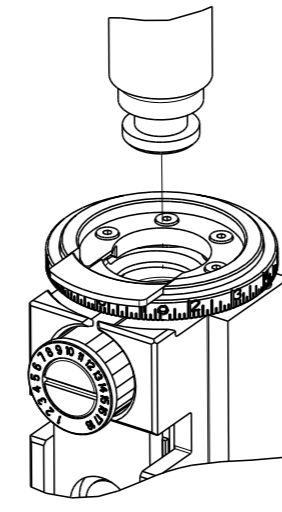


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: H. HUANG 08JAN2015 CHK: L. ZHANG 08JAN2015 APVD: J. GUO 08JAN2015	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266652	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	MATERIAL:	WEIGHT:	FINISH:	RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:2	SHEET 2 of 4	REV C

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION					
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.					
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2266652-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2266652-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2266652-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	2.80 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 3.96mm PITCH SPOX CRIMP TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		Ø1.30-3.00 mm [.051-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-639005300 Rev A		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
286982-1	08-70-1031	286982-3	39-00-0409
286982-2	39-00-0021	286982-4	39-00-0416

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.80mm2	1.15+/-0.05 [.045+/-0.002]	6.2
20 AWG OR 0.50mm2	1.12+/-0.05 [.044+/-0.002]	6.5
22 AWG OR 0.35mm2	1.01+/-0.05 [.040+/-0.002]	7.6
24 AWG OR 0.30mm2	0.95+/-0.05 [.037+/-0.002]	8.2

- 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.

***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	LYR	DESCRIPTION	DATE	OWN	APVD
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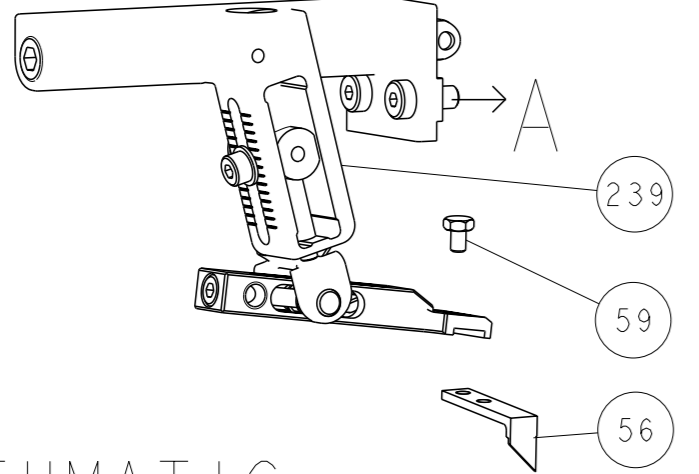
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	994970-2	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	455888-6	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	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1338685-1	PAWL, FEED	56	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	811242-6	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	
-	1	1	1-1752356-9	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2-2844962-6	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	2119806-1	INSERT, SHEAR	13	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
	-	1	2119805-1	SHEAR HOLDER, FRONT	10	
	-	1	1803095-1	FLOATING SHEAR, FRONT	9	
	1	1	1	2-1803171-9	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
	1	1	1	6-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-6	SPACER, CRIMPER	2
	1	1	1	2-1633738-0	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)

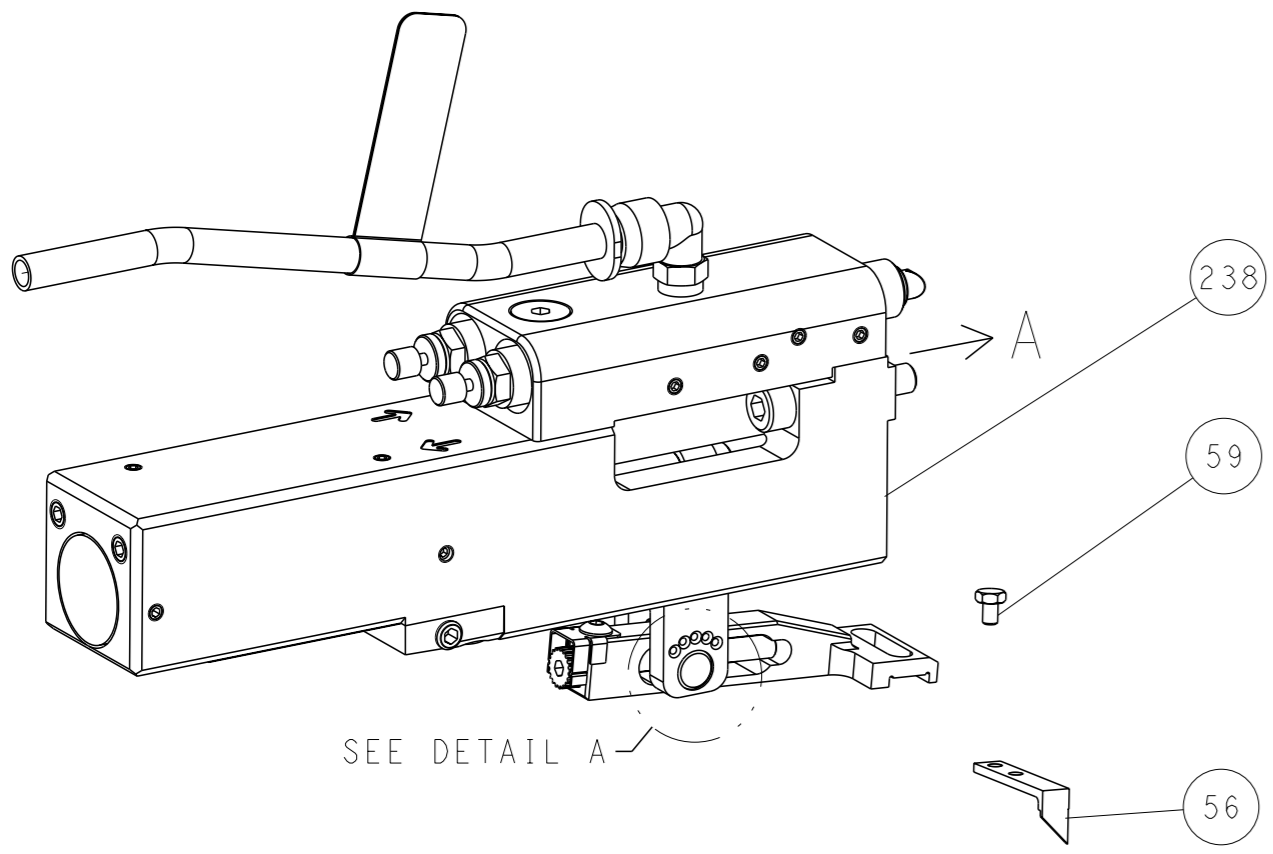
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLE FINISH	WEIGHT	SCALE	SHEET	OF	REV
								1:2	3	4	C
Customer Accessible Production Drawing											

LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

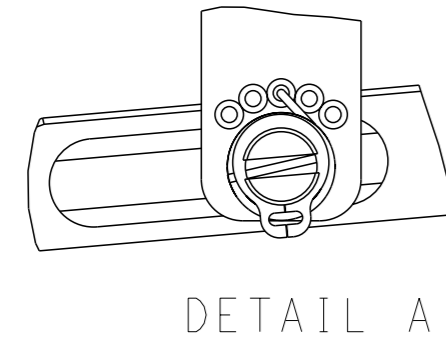
FEED TYPE MECHANICAL



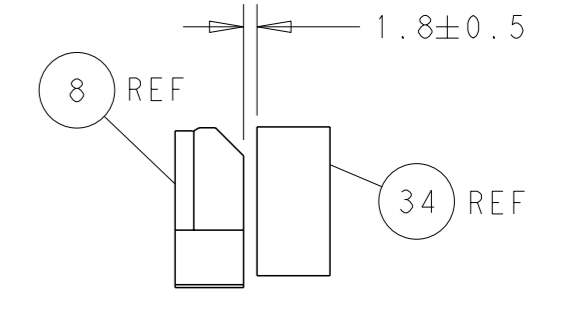
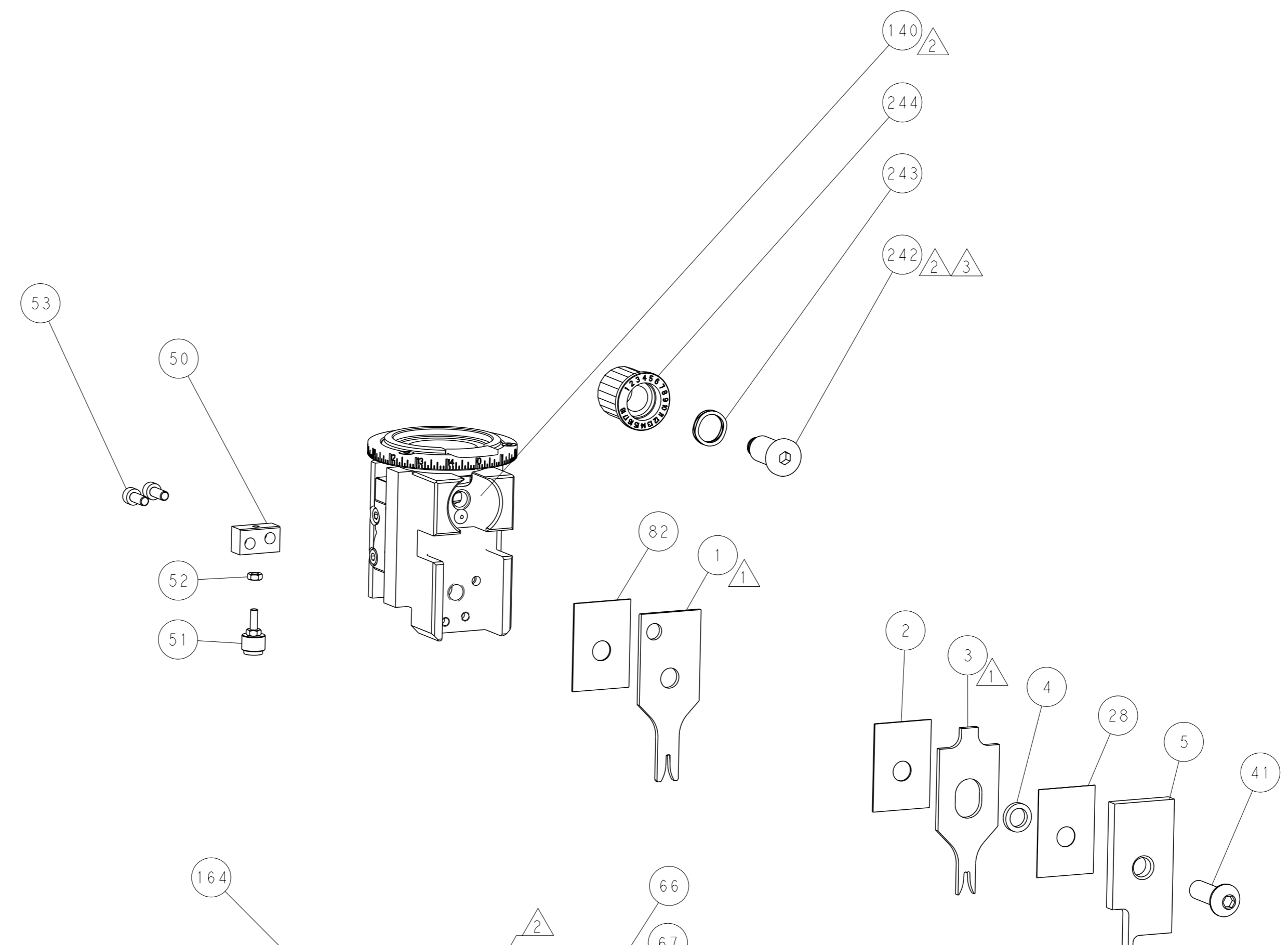
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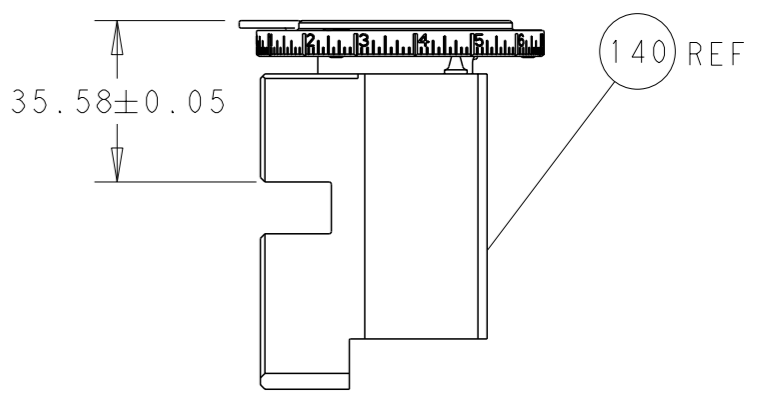
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



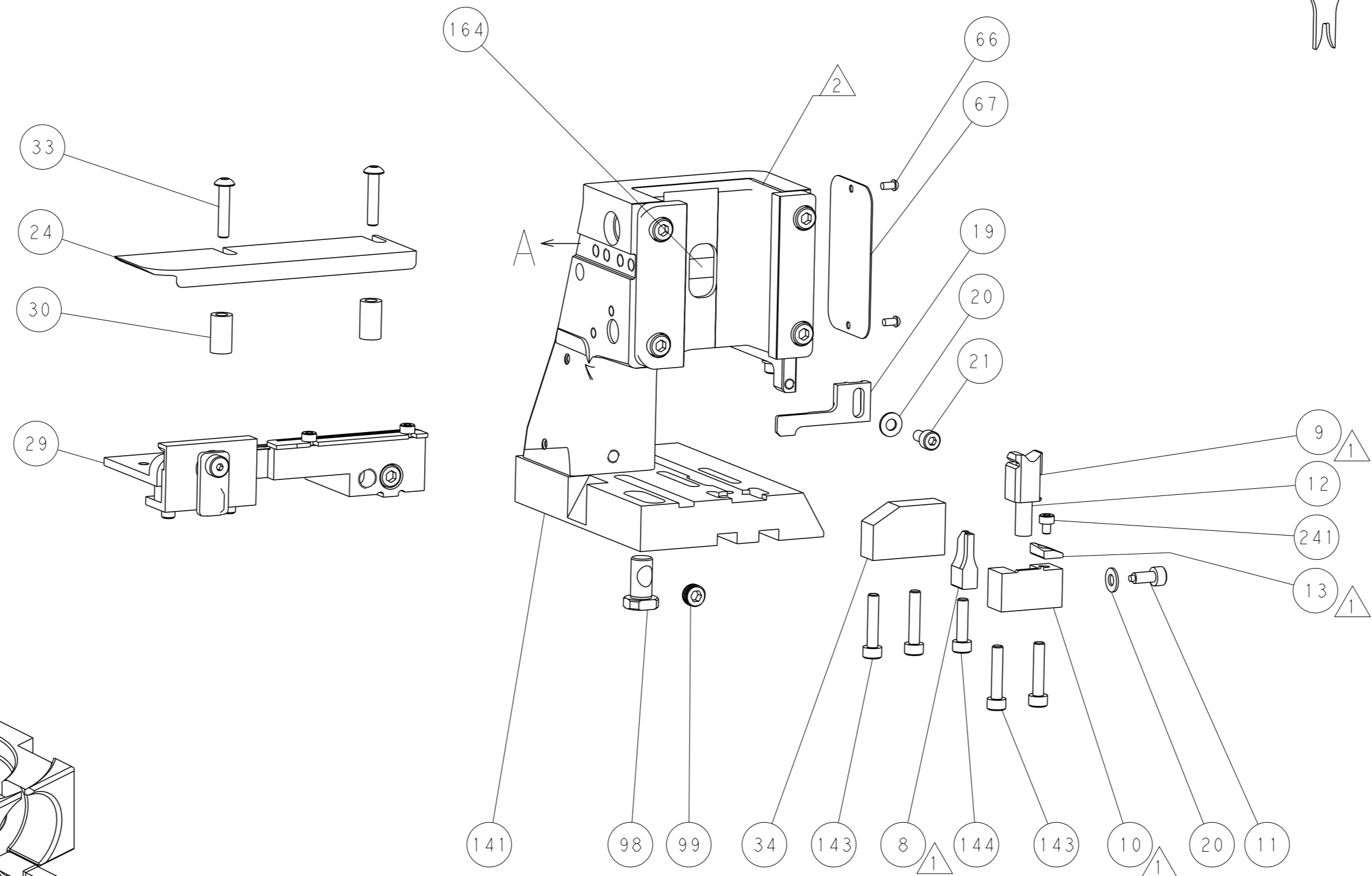
DETAIL A



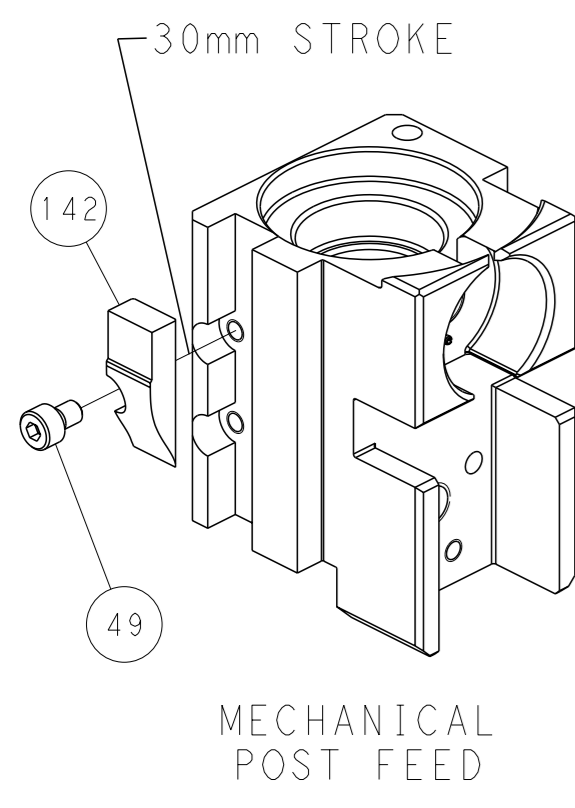
TERMINAL SUPPORT LOCATION



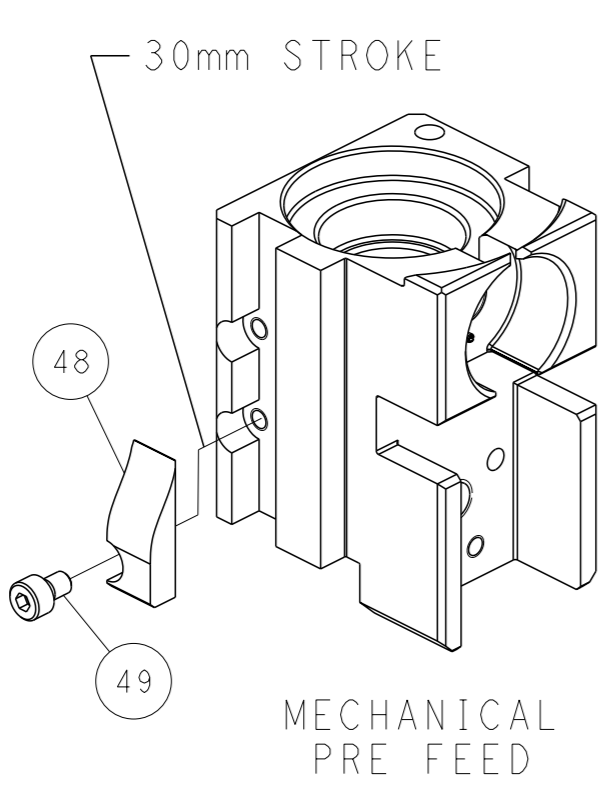
RAM SET-UP



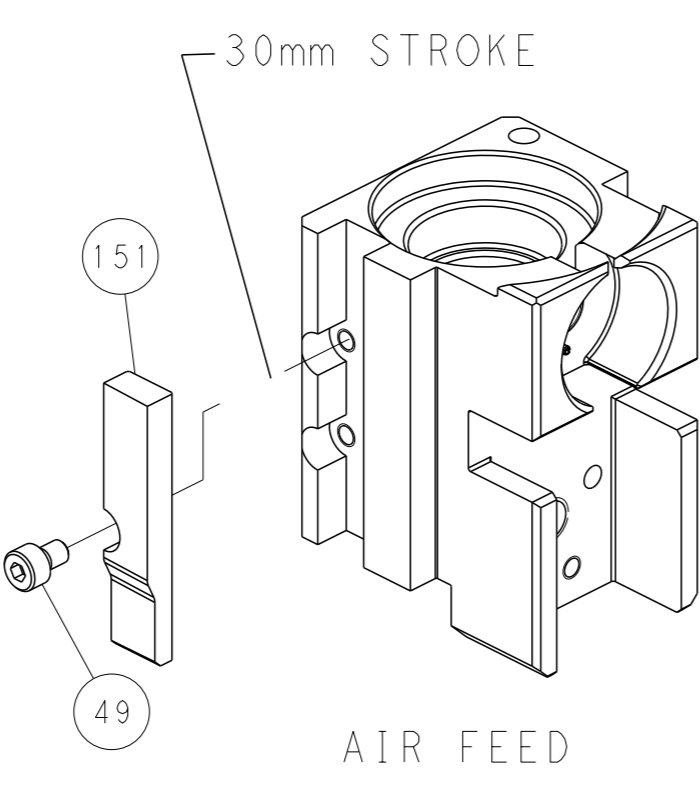
CAM POSITIONS



MECHANICAL POST FEED

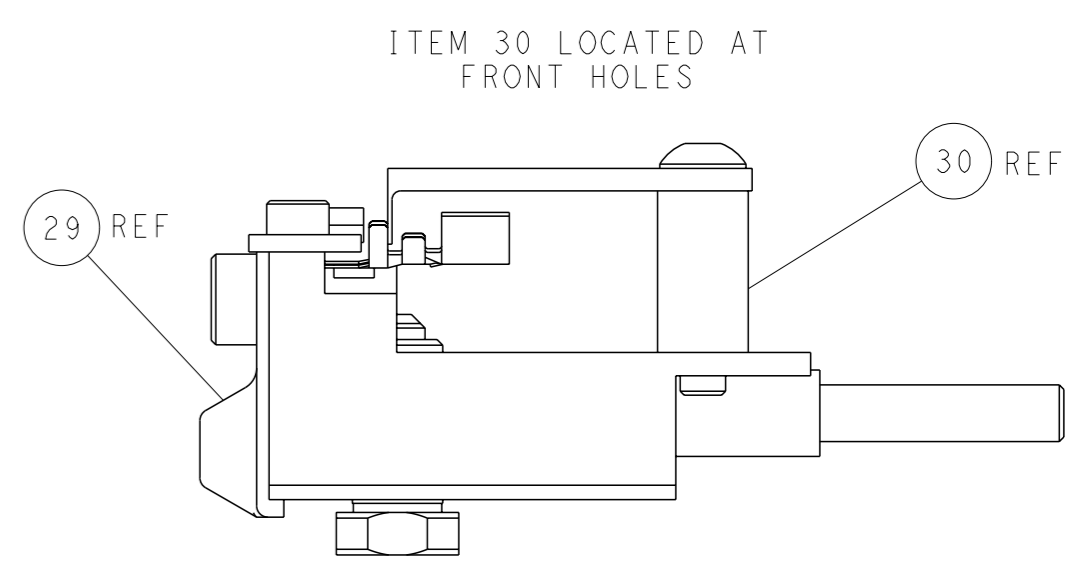


MECHANICAL PRE FEED



AIR FEED

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



FEED TRACK POSITION GUIDE BY INSULATION BARREL

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: H. HUANG 08JAN2015 CHK: L. ZHANG 08JAN2015 APVD: H. GUO 08JAN2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
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=2266652	RESTRICTED TO: - SHEET 4 OF 4 REV C