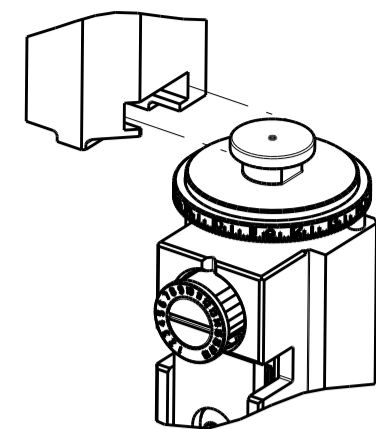


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266760-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266760-2	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266760-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266760-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.60 mm [.142]	F
INSUL	5.00 mm [.197]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION
 TERMINAL NAME: MINIFIT SENIOR

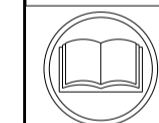
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
7.50-8.50 mm [.295-.335 IN]	Ø4.40-5.30 mm [.173-.209 IN]

TERMINAL APPLICATION SPECIFICATION
 ATSS-638911100 Rev E

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572230-1	42817-0011	1572230-8	42817-1114
1572230-2	42817-0012	1572230-9	42817-1014
1572230-3	42817-0010	286535-1	42815-0011
1572230-4	42817-0110	286535-2	42815-0012
1572230-5	42817-0112	286535-3	42815-0010
1572230-6	42817-0019	286535-4	42815-0019
1572230-7	42817-0111	286535-5	42815-0114

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.74+/-0.05 [.108+/-0.002]	7.3
12 AWG	2.44+/-0.05 [.096+/-0.002]	10.3



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.

***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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		D		ECR-18-019535	14DEC2018	KH	CT
		E		ECR-19-006111	16APR2019	FJ	TE
		F		ECR-19-012535	08AUG2019	FJ	TE
		G		ECR-19-012919	16AUG2019	FZ	TE

-	-	1	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1633782-3	FENCE	267
-	1	1	1	1803078-2	SPACER, PRECISION	259
-	1	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	1	2844940-1	AIR FEED MODULE	238
-	-	1	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	1	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	1	-	4-1752354-3	STANDOFF, HOLD-DOWN	180
-	-	1	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	1	-	5-22280-0	SPRING, COMPRESSION	176
-	-	1	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	1	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1-455888-6	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-6	DEPRESSOR, WIRE	70
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338683-8	FEED PAWL	56
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-6	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
-	1	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	-	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	2	2	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1	1320928-6	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	1	1803252-6	ANVIL, COMBINATION	8
-	1	1	1	2-240641-8	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	1-2119757-5	DEPRESSOR, SHEAR	5
-	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
-	1	2	1	8-1803016-0	CRIMPER, INSULATION F	3
-	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	1	9-1633738-3	CRIMPER, WIRE	1

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:		DRAWING NO		SCALE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH
MATERIAL				WEIGHT		RESTRICTED TO	

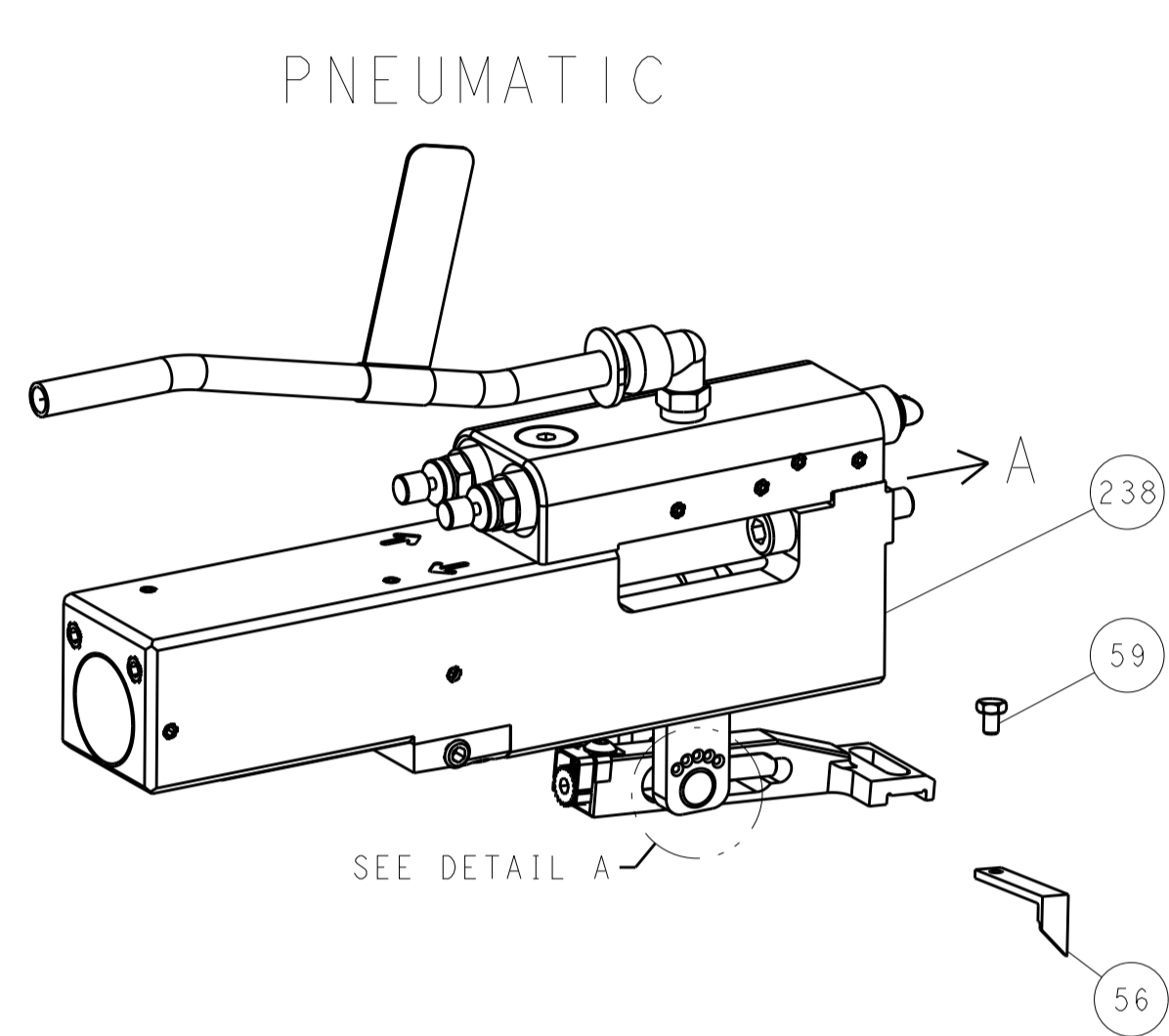
Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APPD
A	66				

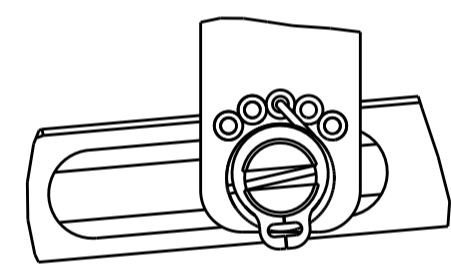
REVISIONS			
REV	DATE	DESCRIPTION	BY
-	-	SEE SHEET 1	-

FEED TYPE

PNEUMATIC

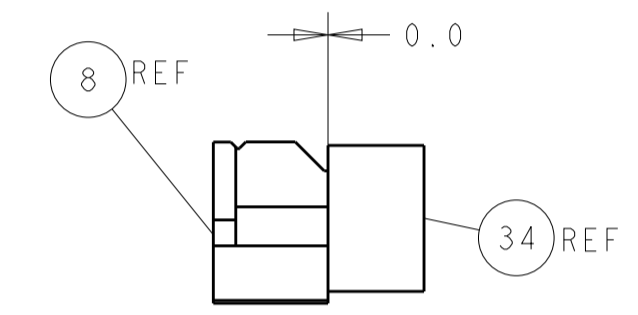
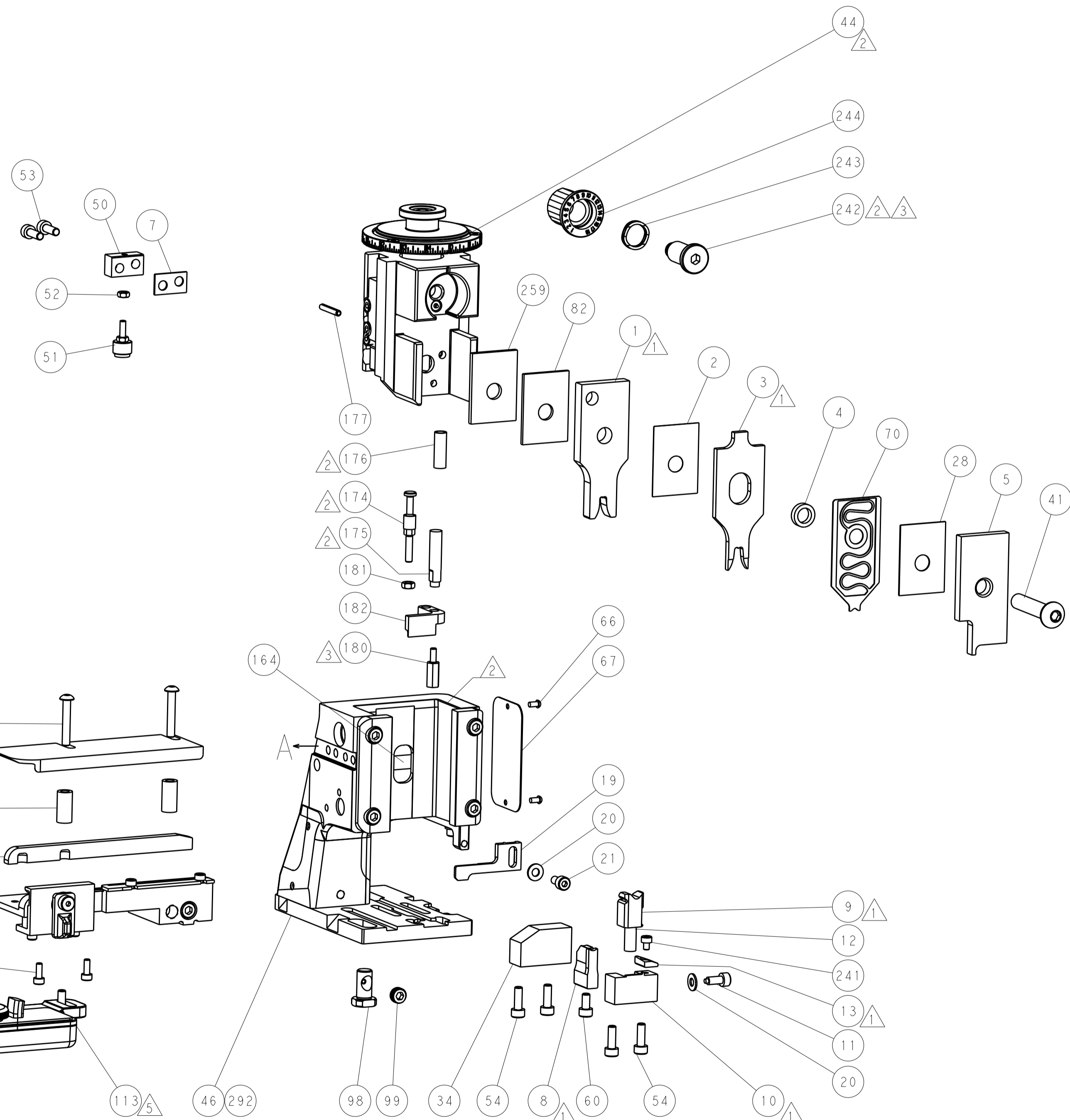
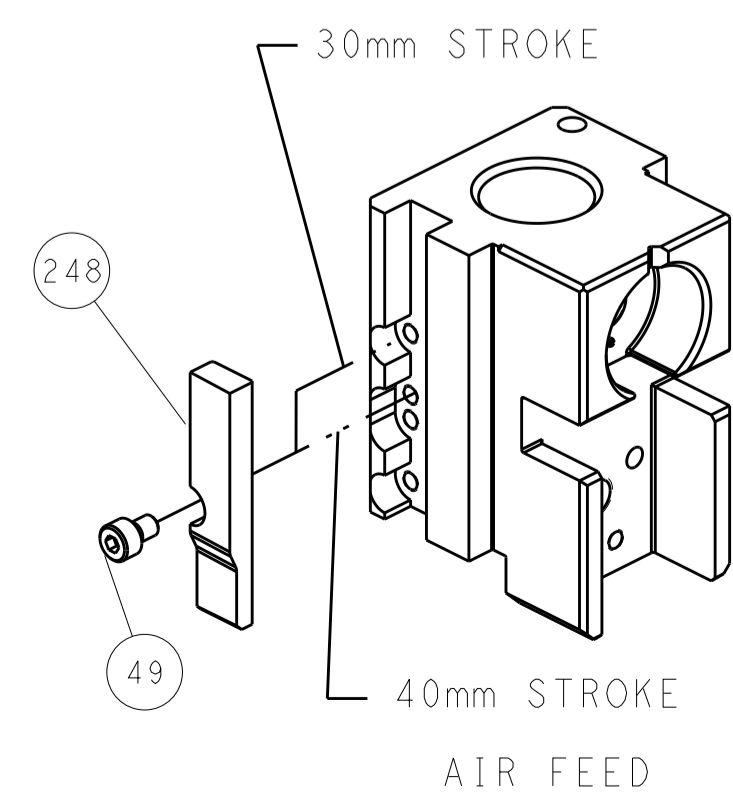


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

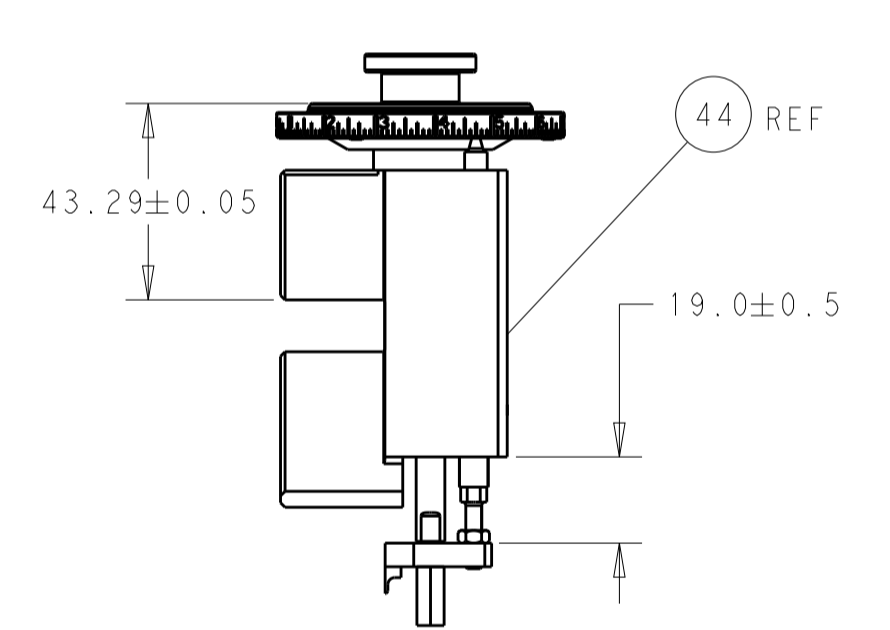


DETAIL A

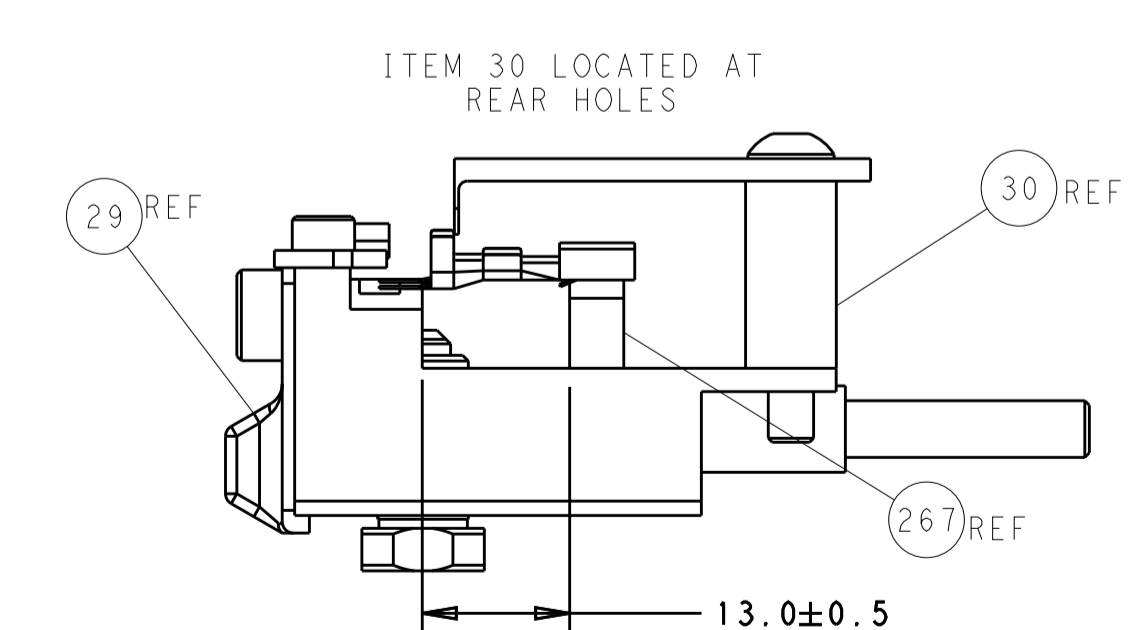
CAM POSITIONS



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWG: B. WEAVER 29JUL2015 CHK: G. BAILEY 29JUL2015 APVD: G. BAILEY 29JUL2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2266760 SCALE: 1:2 SHEET: 2 OF 4 REV: G	
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THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	2015	
COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266760-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266760-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.60 mm [.142]	F
INSUL	5.00 mm [.197]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: MINIFIT SENIOR			
WIRE STRIP LENGTH 7.50-8.50 mm [.295-.335 IN]		INSULATION DIAMETER RANGE Ø4.40-5.30 mm [.173-.209 IN]	
TERMINAL APPLICATION SPECIFICATION ATS-638911100 Rev E			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572230-1	42817-0011	1572230-8	42817-1114
1572230-2	42817-0012	1572230-9	42817-1014
1572230-3	42817-0010	286535-1	42815-0011
1572230-4	42817-0110	286535-2	42815-0012
1572230-5	42817-0112	286535-3	42815-0010
1572230-6	42817-0019	286535-4	42815-0019
1572230-7	42817-0111	286535-5	42815-0114

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.74 +/- 0.05 [.108 +/- .002]	7.3
12 AWG	2.44 +/- 0.05 [.096 +/- .002]	10.3

- 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.

***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	DESCRIPTION	DATE	BY	APPD
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1633782-3	FENCE	267	
-	1	1803078-2	SPACER, PRECISION	259	
-	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	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	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140	
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	1-455888-6	SPACER, CRIMPER	82	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	2119791-6	DEPRESSOR, WIRE	70	
-	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	1338683-8	FEED PAWL	56	
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53	
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	811242-6	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	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33	
-	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-5	SPACER, CRIMPER	28	
-	1	1320928-6	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	2119533-1	STRIPPER, SIDE FEED	19	
-	1	2119806-1	INSERT, SHEAR	13	
-	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1-356885-4	STOP, SHEAR	11	
-	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	1803252-6	ANVIL, COMBINATION	8	
-	1	2-240641-8	SPACER	7	
-	-	-	-	6	
-	1	1-2119757-5	DEPRESSOR, SHEAR	5	
-	1	3-238011-8	BLOCK, CRIMPER SPACER	4	
-	1	8-1803016-0	CRIMPER, INSULATION F	3	
-	1	455888-1	SPACER, CRIMPER	2	
-	1	9-1633738-3	CRIMPER, WIRE	1	

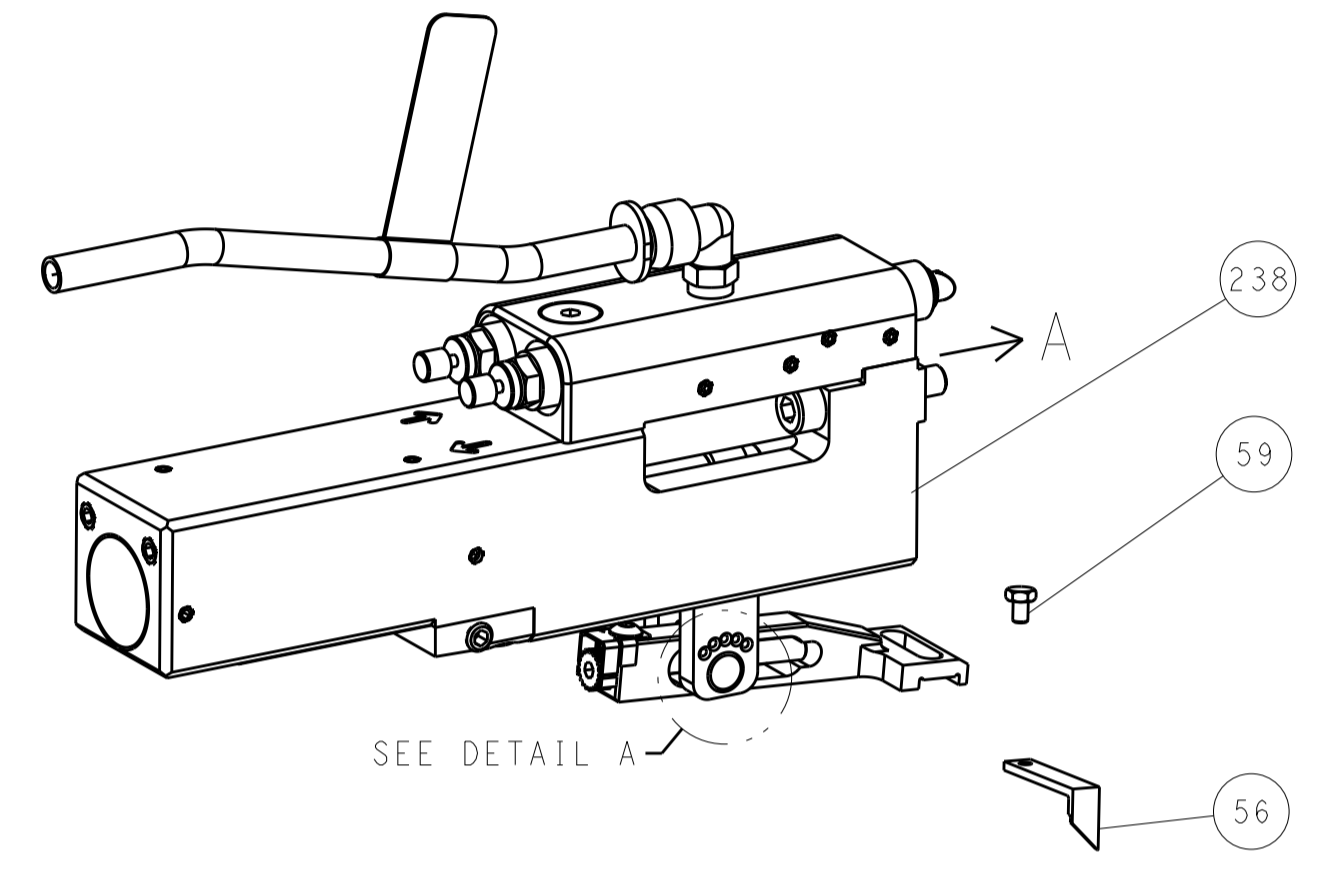
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: B. WEAVER 29 JUL 2015		CHK: G. BAILEY 29 JUL 2015		APVD: G. BAILEY 29 JUL 2015		NAME: Ocean Side Feed Applicator	
0 PLC	±	1 PLC	±	2 PLC	±	3 PLC	±	4 PLC	±	ANGLES	±
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET 3 OF 4		REV G	

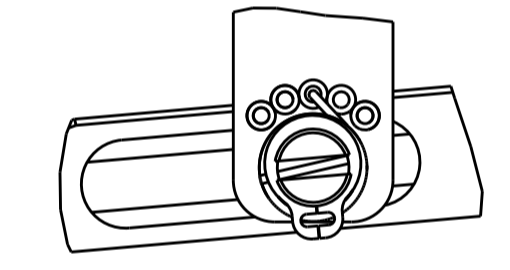
LOC	DIST	REV	DATE	BY	APPD
A	66				

FEED TYPE

PNEUMATIC

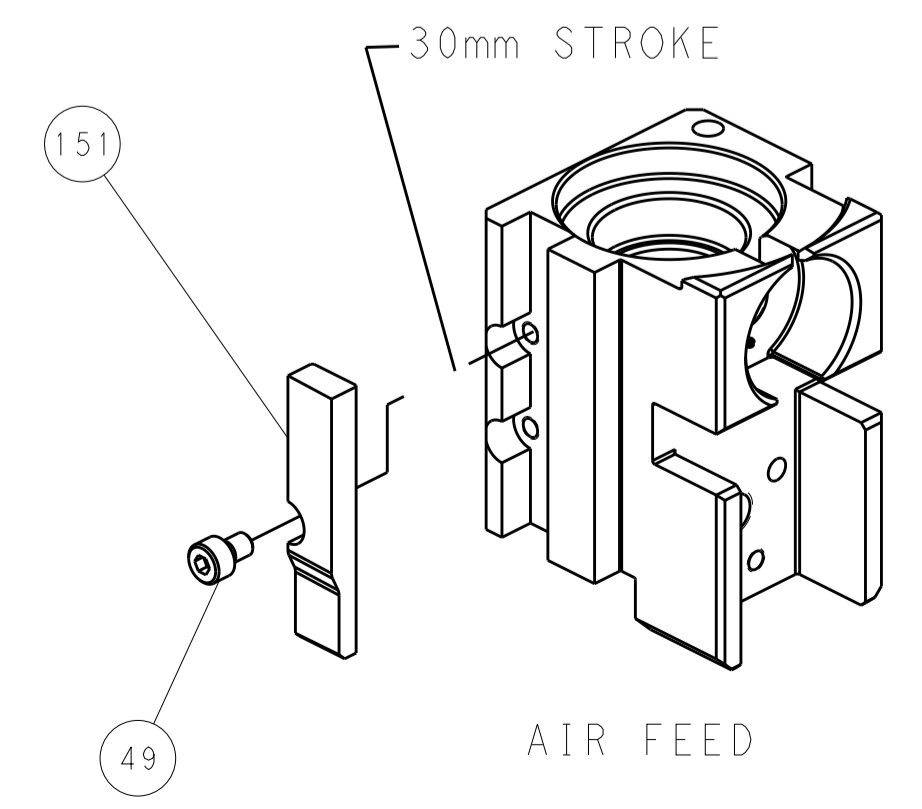


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

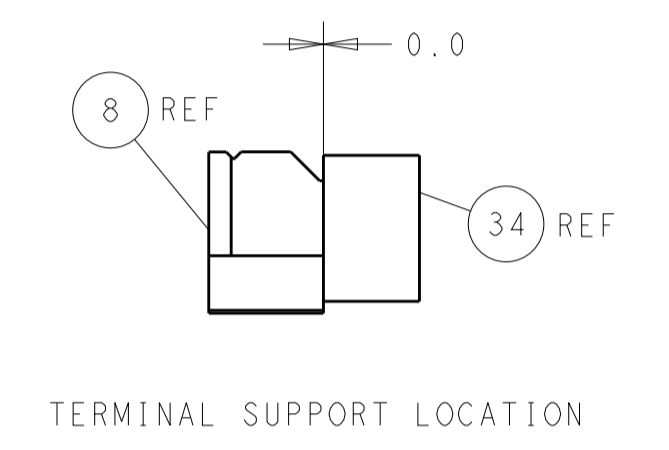
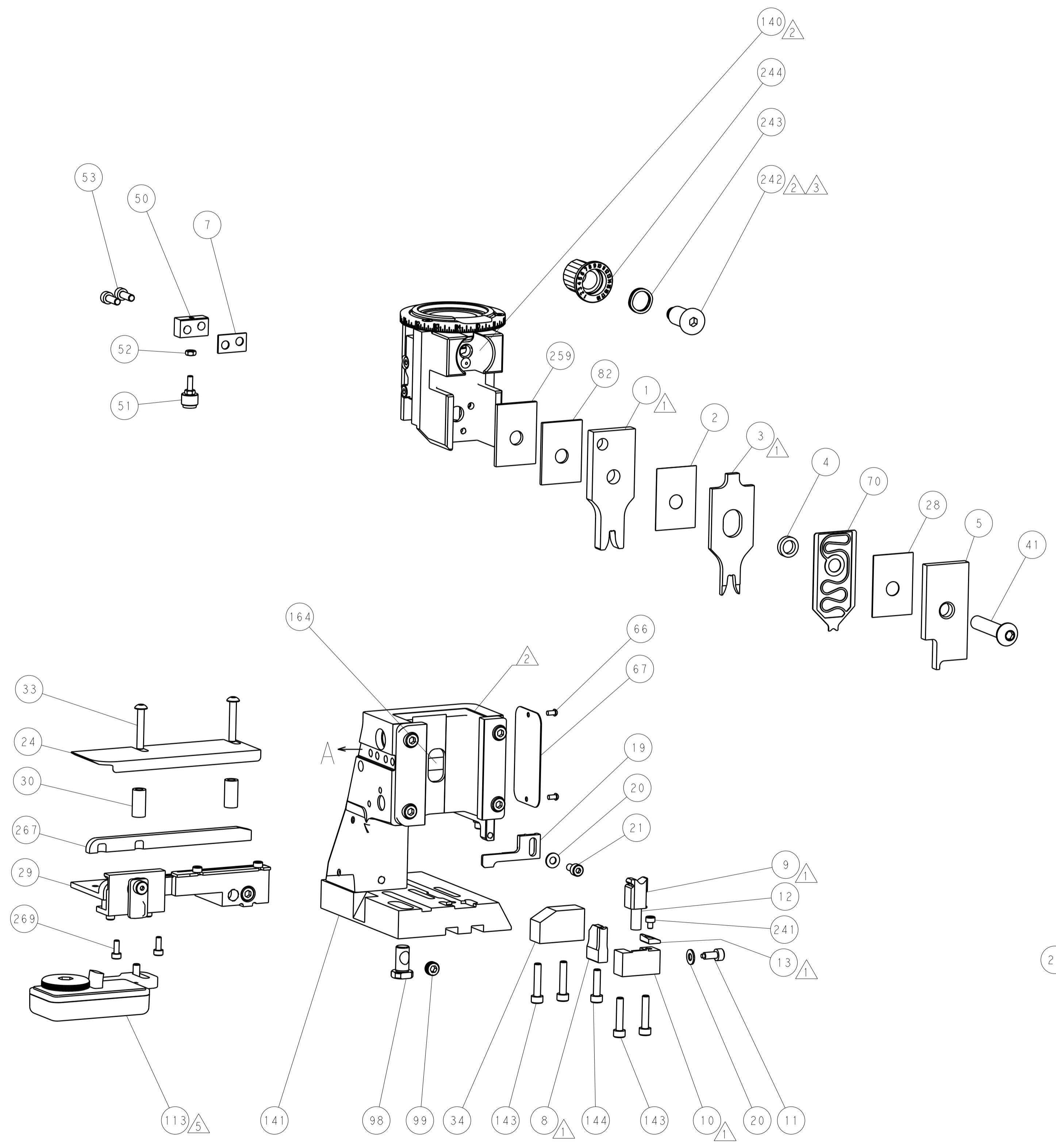


DETAIL A

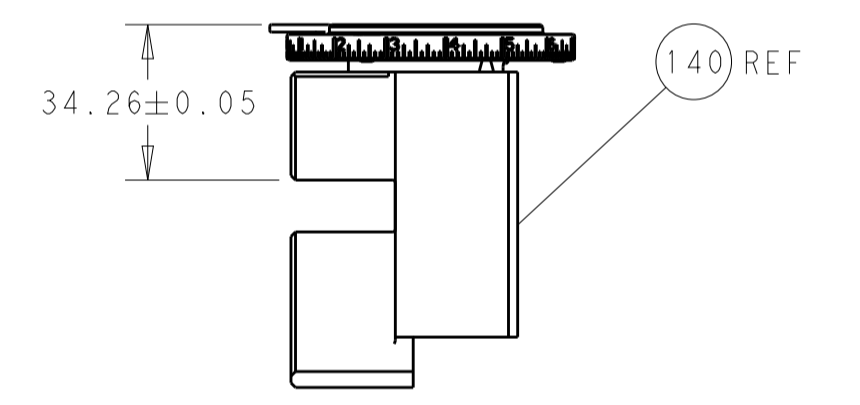
CAM POSITIONS



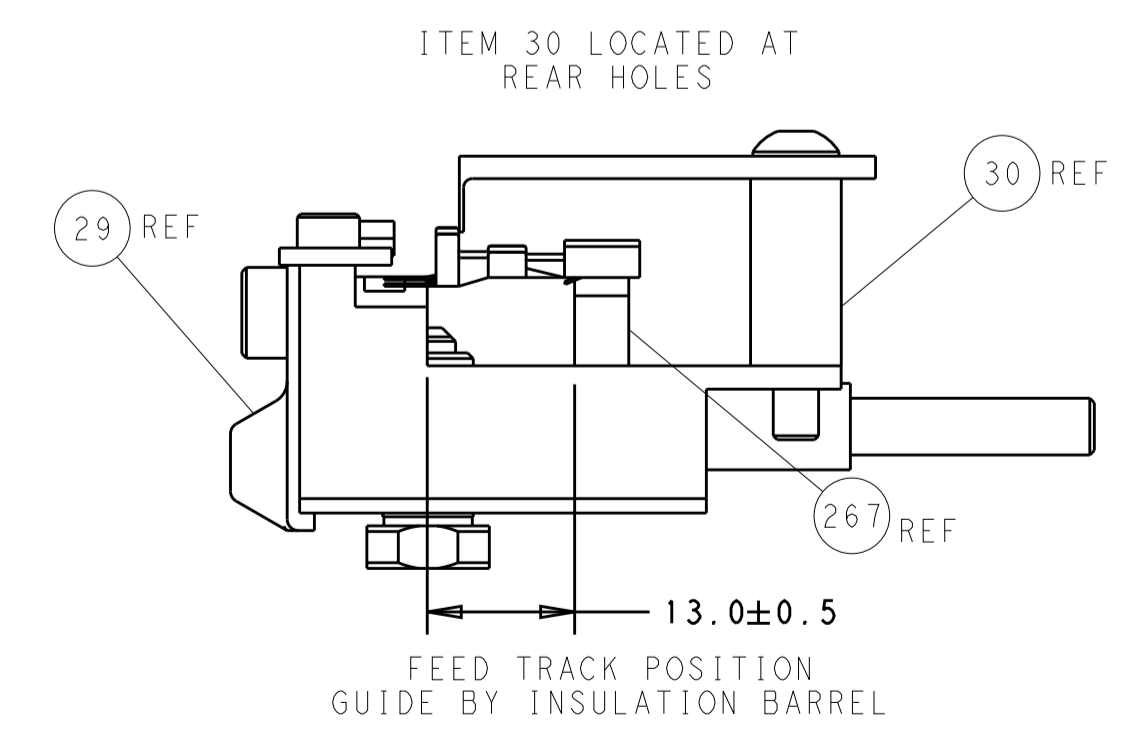
AIR FEED



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN B. WEAVER 29JUL2015 CHK G. BAILEY 29JUL2015 APVD G. BAILEY 29JUL2015		NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266760	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 4 OF 4 REV G	