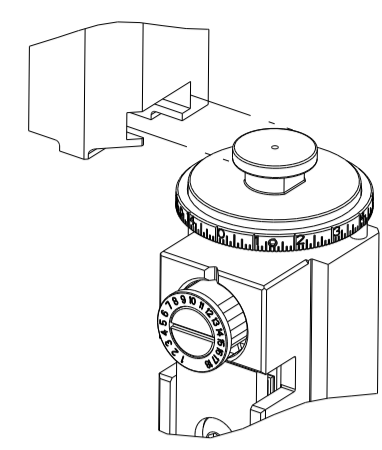


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266610-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266610-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266610-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266610-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266610-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	1.68 mm [.066]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: CAT EAR TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.54-3.18 mm [.100-.125 IN]		Ø1.12-1.57 mm [.044-.062 IN]	
TERMINAL APPLICATION SPECIFICATION ATS-638887100 Rev C			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949166-1	08-50-0031	1949166-6	08-56-0120
1949166-2	08-50-0030	1949166-7	97-00-0450
1949166-3	08-50-0135	1949166-8	08-52-0105
1949166-4	08-55-0110	1949166-9	08-65-0105
1949166-5	08-55-0112	1-1949166-0	97-00-0225

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.35mm2	0.83+/-0.025 [.032+/- .001]	5.4
24 AWG OR 0.20mm2	0.77+/-0.025 [.030+/- .001]	6.0
26 AWG OR 0.12mm2	0.71+/-0.030 [.028+/- .001]	6.6
28 AWG OR 0.08mm2	0.69+/-0.025 [.027+/- .001]	6.9
30 AWG OR 0.05mm2	0.65+/-0.015 [.025+/- .001]	7.4



- 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.
- 6 POSITION, ITEM 56 FEED PAWL, IN THE TRANSITIONAL OPENING BETWEEN THE FRONT OF THE WIRE BARREL AND TERMINAL BODY.
- 7 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 61.

***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)

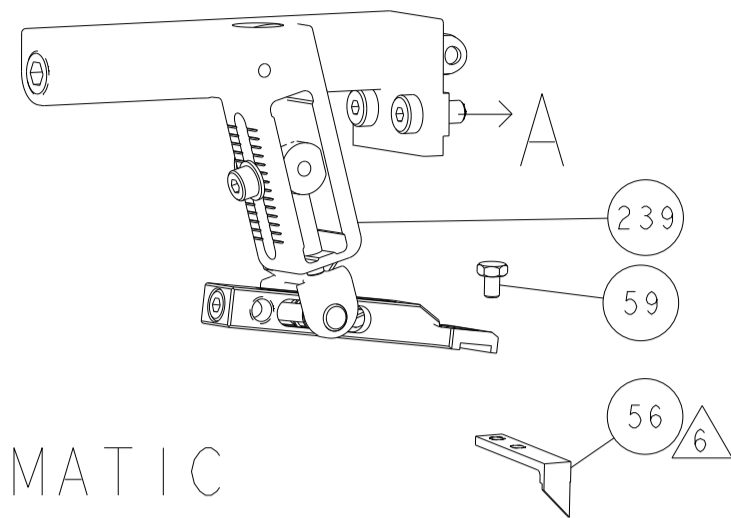
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		C		ECR-20-017153	03DEC2020	FZ	RK
		D		ECR-21-122500	30NOV2021	FJ	RK
		E		ECR-23-162545	03JAN2023	TB	GB
		F		ECR-23-167370	24FEB2023	FZ	GB

-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	279
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1	1-1633782-6	FENCE	267
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	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	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	2217068-1	BRACKET, AIR BLAST	130
-	1	1	1	1	2030758-3	TUBING, POLYURETHANE	129
-	1	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127
-	1	1	1	1	986220-3	CLAMP, CABLE, BLACK	126
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	23238-1	INSERT, COUPLING	101
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	2-690487-8	GUIDE, FRONT STRIP	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	1-455888-3	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	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
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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
-	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	1803583-1	APPLICATOR BASIC ASSEMBLY, SF	46
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	45
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	43
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	36
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	1-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2-2844938-9	PLATE, STRIP GUIDE	29
-	2	2	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	5-690754-0	DRAG, SPECIAL	25
-	1	1	1	1	1-1320928-0	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	4	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119830-8	HOLDER, SLUG BLADE	11
-	1	1	1	1	1633579-6	BLADE, SLUG	10
-	1	1	1	1	1803150-2	PLATE, REAR SHEAR	9
-	1	2	2	1	1633481-8	ANVIL, SPECIAL, COMBINATION	8
-	1	1	1	1	5-240641-9	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	4-240641-9	SPACER	5
-	1	1	1	1	6-238011-0	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	7-1633962-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	8-1633738-9	CRIMPER, WIRE	1
-	77	72	71	-2	-1	PART NO	ITEM NO

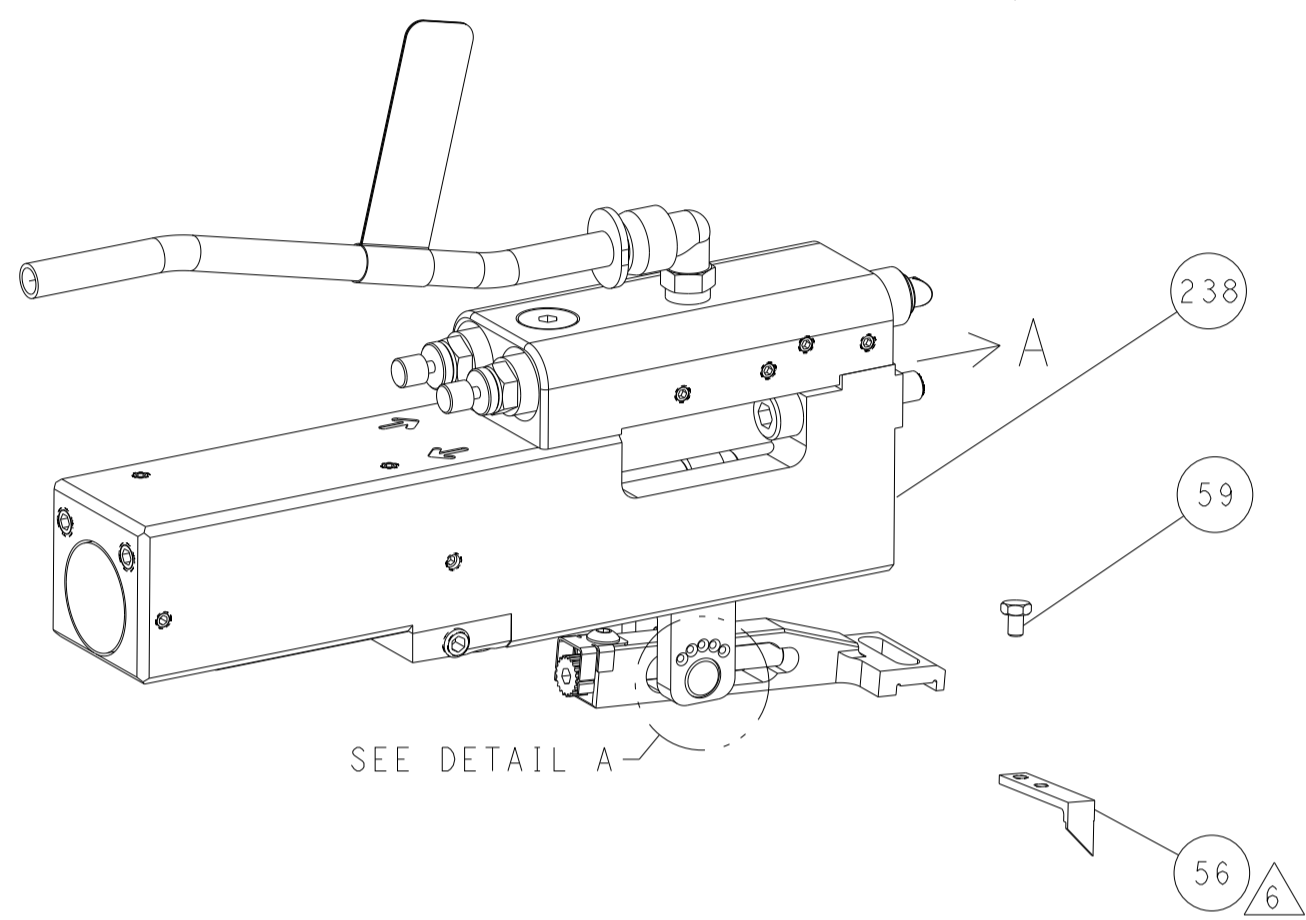
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2266610	1	4	F
Customer Accessible Production Drawing															

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

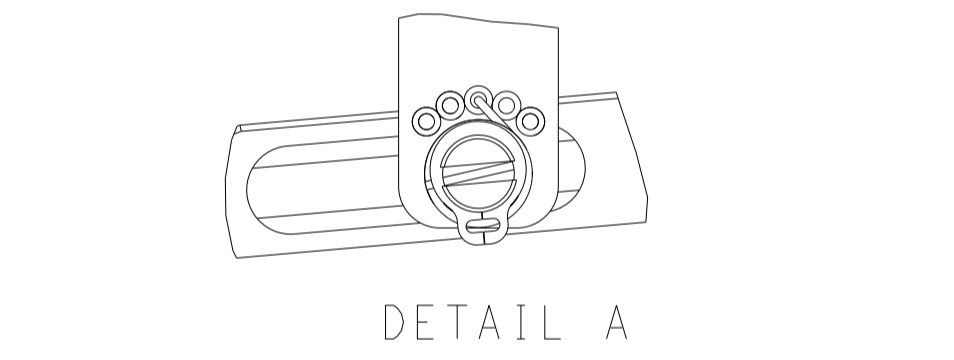
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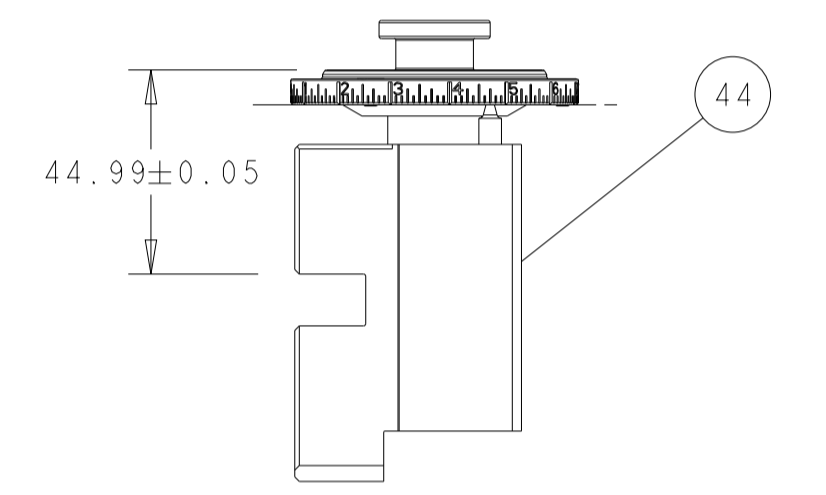
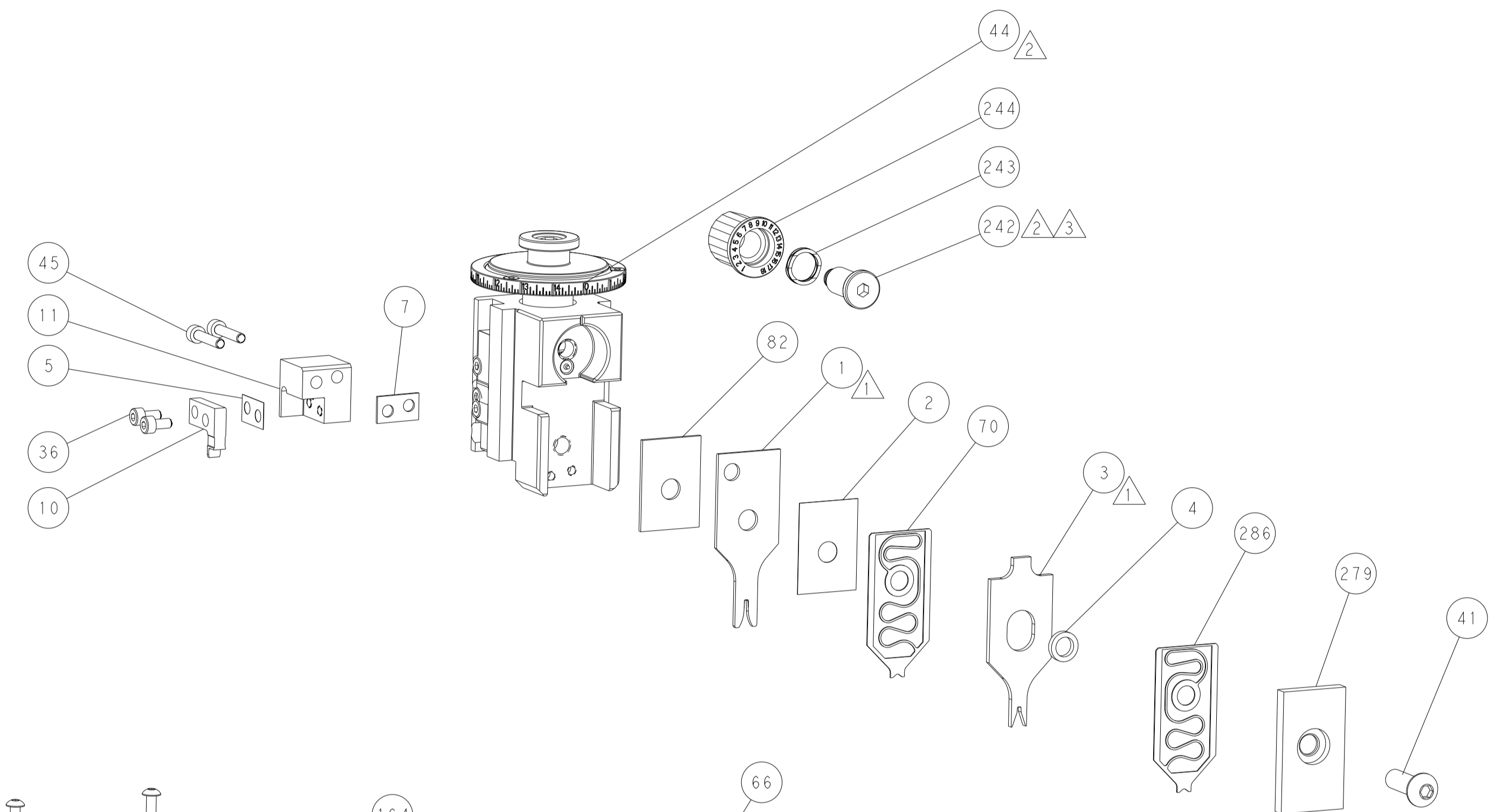
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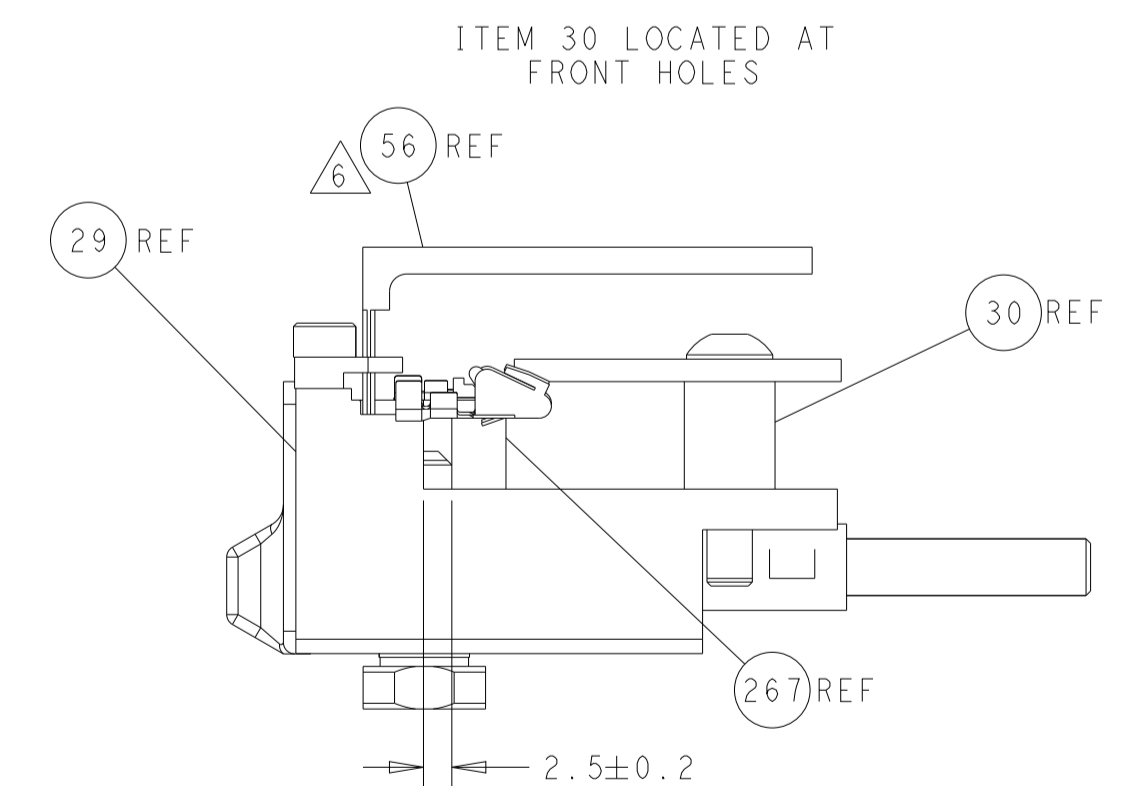
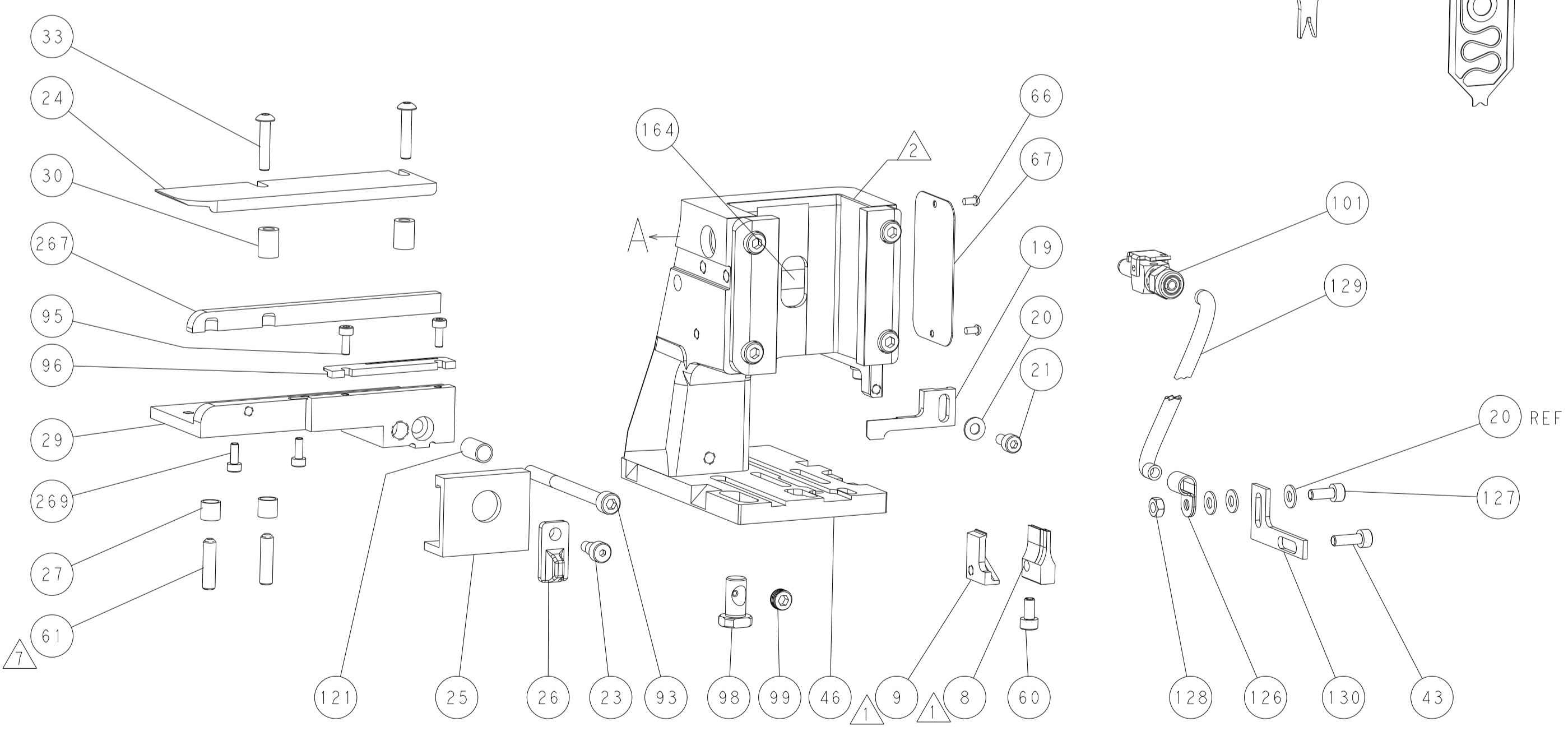
SEE DETAIL A



DETAIL A

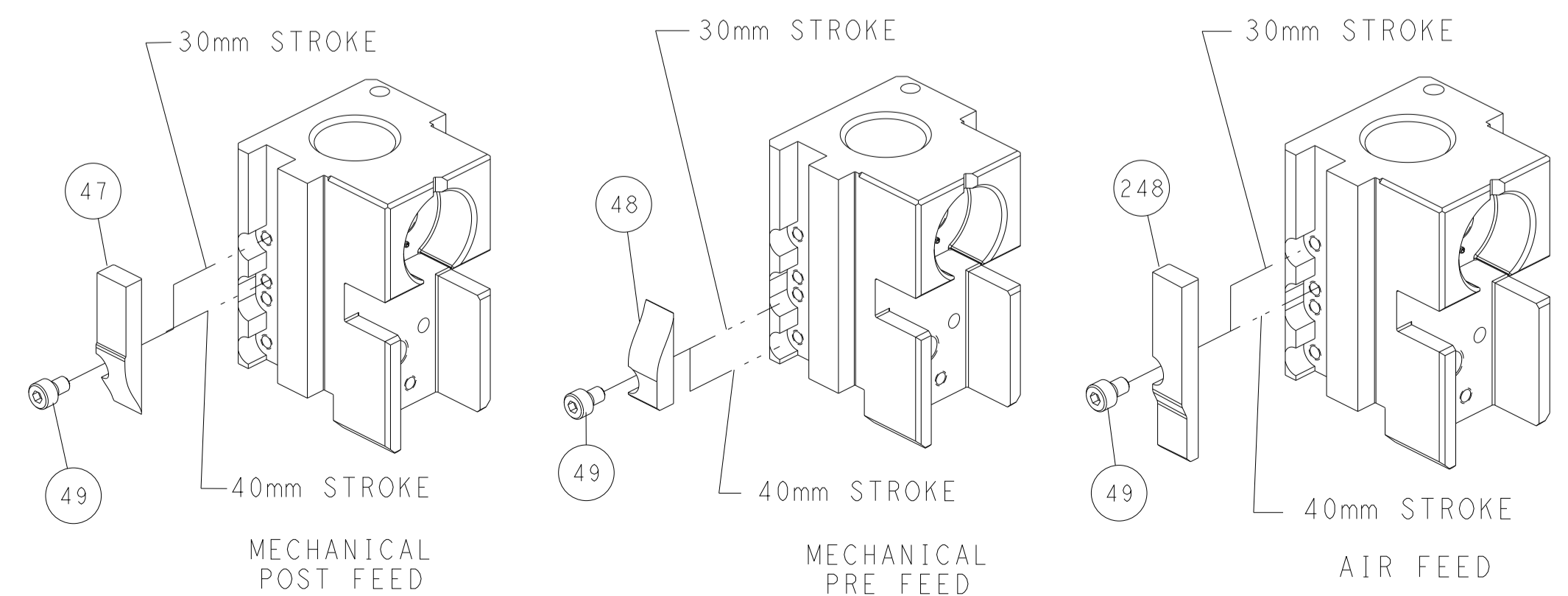


RAM SET-UP



FEED TRACK POSITION GUIDE BY TERMINAL BODY

CAM POSITIONS



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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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME: Ocean Side Feed Applicator APPLICATION SPEC: - PRODUCT SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2266610 RESTRICTED TO: -
MATERIAL: -		SCALE: 1:2 SHEET: 2 OF 4 REV: F	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266610-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266610-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266610-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	1.68 mm [.066]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL TE CRIMP SPECIFICATION

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
2.54-3.18 mm [.100-.125 IN]	Ø1.12-1.57 mm [.044-.062 IN]

TERMINAL APPLICATION SPECIFICATION
ATS-638887100 Rev C

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949166-1	08-50-0031	1949166-6	08-56-0120
1949166-2	08-50-0030	1949166-7	97-00-0450
1949166-3	08-50-0135	1949166-8	08-52-0105
1949166-4	08-55-0110	1949166-9	08-65-0105
1949166-5	08-55-0112	1-1949166-0	97-00-0225

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.35mm ²	0.83 +/- 0.025 [.032 +/- .001]	5.4
24 AWG OR 0.20mm ²	0.77 +/- 0.025 [.030 +/- .001]	6.0
26 AWG OR 0.12mm ²	0.71 +/- 0.030 [.028 +/- .001]	6.6
28 AWG OR 0.08mm ²	0.69 +/- 0.025 [.027 +/- .001]	6.9
30 AWG OR 0.05mm ²	0.65 +/- 0.015 [.025 +/- .001]	7.4

- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- POSITION, ITEM 56 FEED PAWL, IN THE TRANSITIONAL OPENING BETWEEN THE FRONT OF THE WIRE BARREL AND TERMINAL BODY.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 61.

LOC	DIST	REV	DATE	BY	APPD
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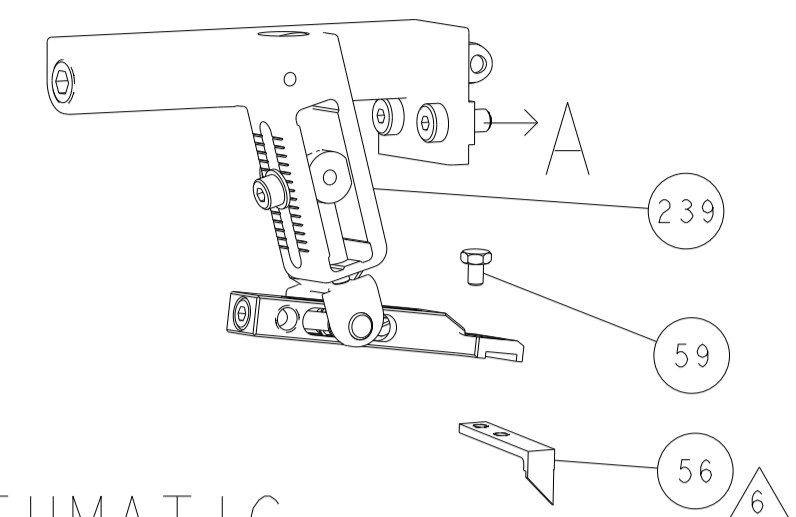
REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	279
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1-1633782-6	FENCE	267
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	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
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1803583-2	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	2217068-1	BRACKET, AIR BLAST	130
-	1	1	2030758-3	TUBING, POLYURETHANE	129
-	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127
-	1	1	986220-3	CLAMP, CABLE, BLACK	126
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	23238-1	INSERT, COUPLING	101
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	2-690487-8	GUIDE, FRONT STRIP	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1-455888-3	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	45
-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	43
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	36
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2-2844938-9	PLATE, STRIP GUIDE	29
-	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	5-690754-0	DRAG, SPECIAL	25
-	1	1	1-1320928-0	STRIP GUIDE	24
-	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
-	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-4	STRIPPER, SIDE FEED	19
-	1	1	2119830-8	HOLDER, SLUG BLADE	11
-	1	1	1633579-6	BLADE, SLUG	10
-	1	1	1803150-2	PLATE, REAR SHEAR	9
-	1	1	1633481-8	ANVIL, SPECIAL, COMBINATION	8
-	1	1	5-240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	4-240641-9	SPACER	5
-	1	1	6-238011-0	BLOCK, CRIMPER SPACER	4
-	1	1	7-1633962-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	8-1633738-9	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)

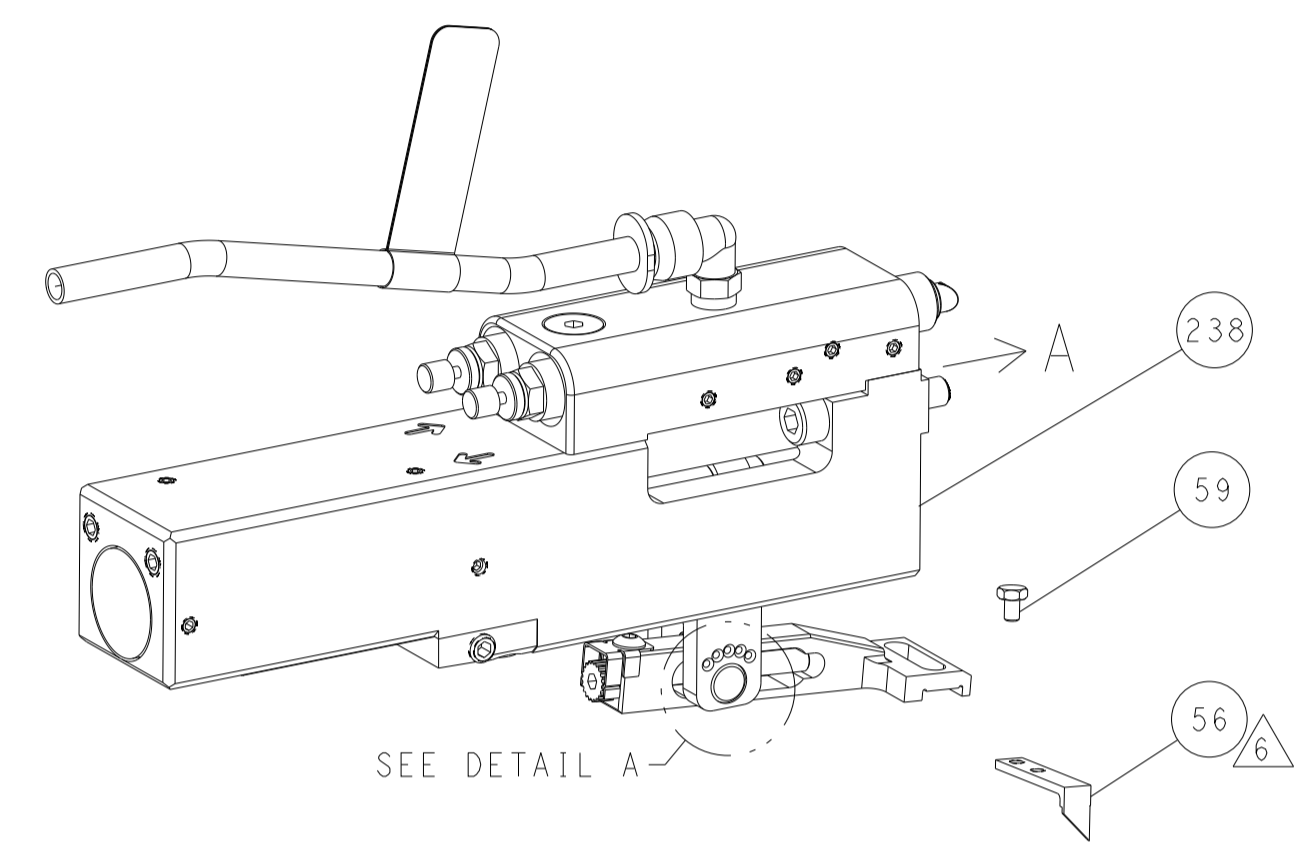
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P	LTN	DESCRIPTION	DATE	OWN	APVD		
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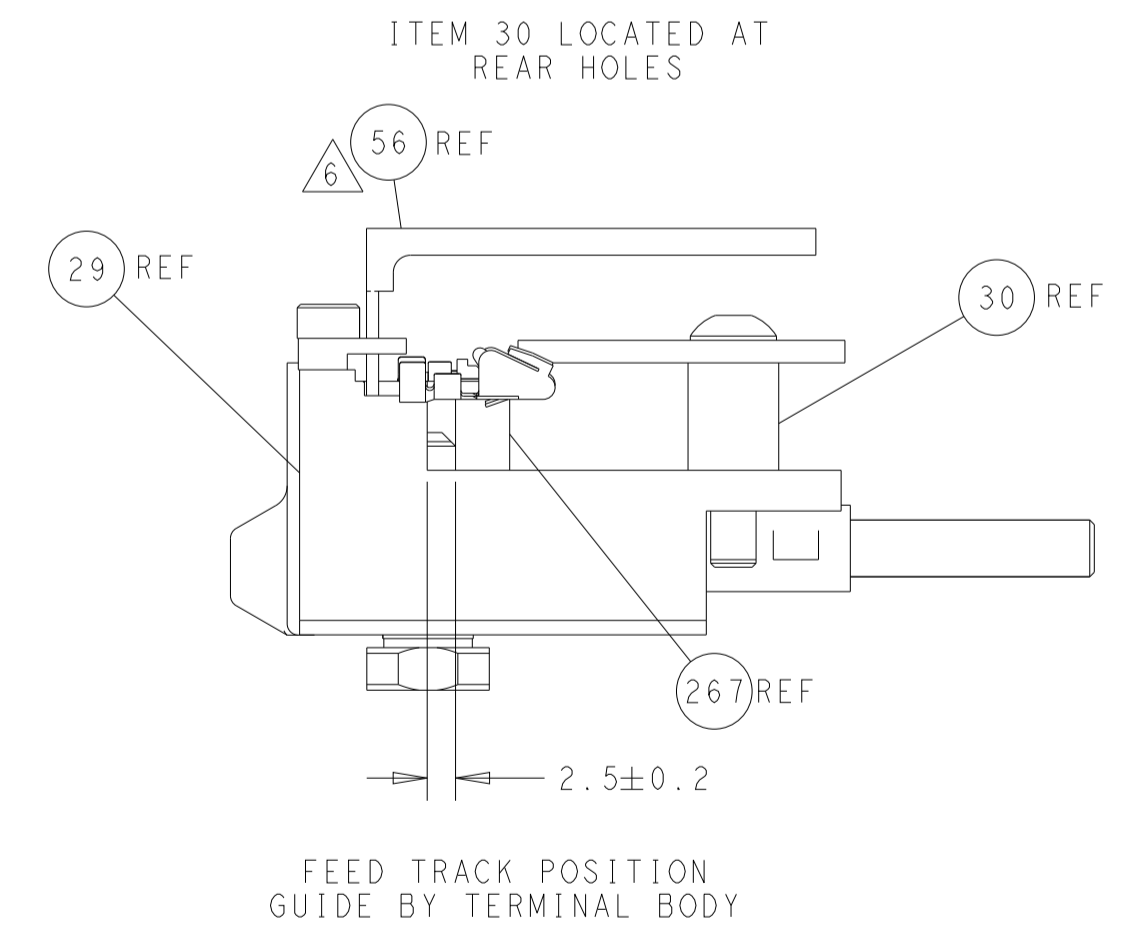
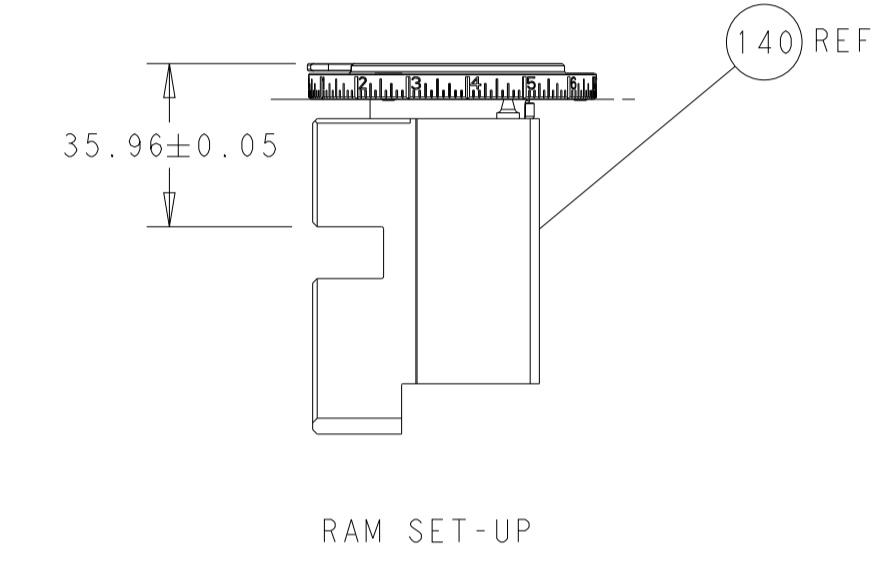
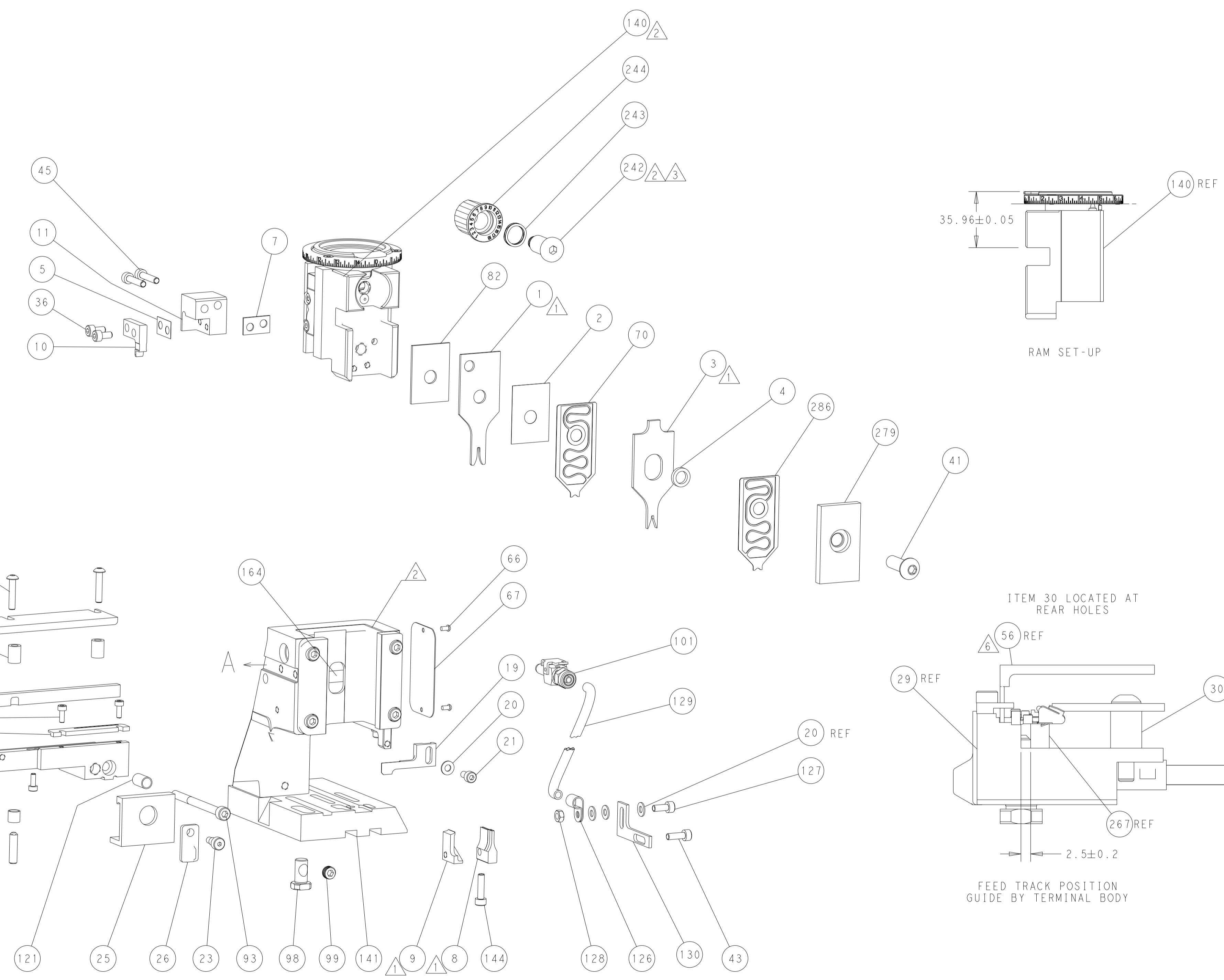
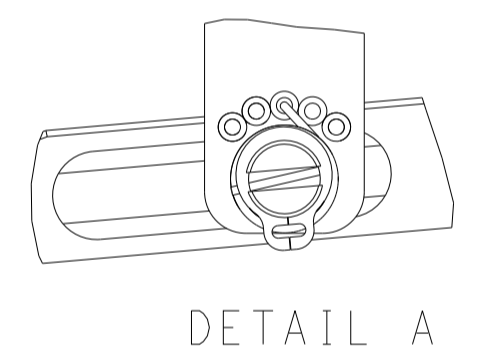
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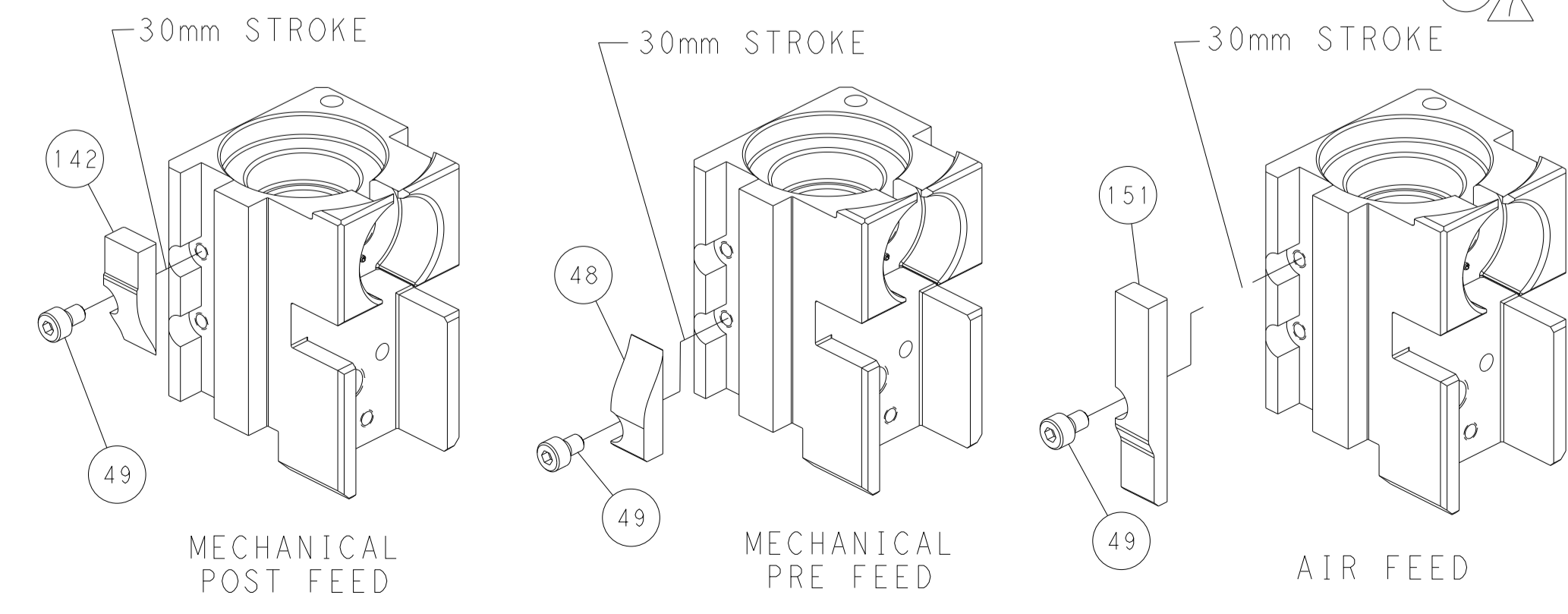
PNEUMATIC



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:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2266610
MATERIAL:		RESTRICTED TO:		SCALE: 1:2 SHEET: 4 OF 4 REV: F