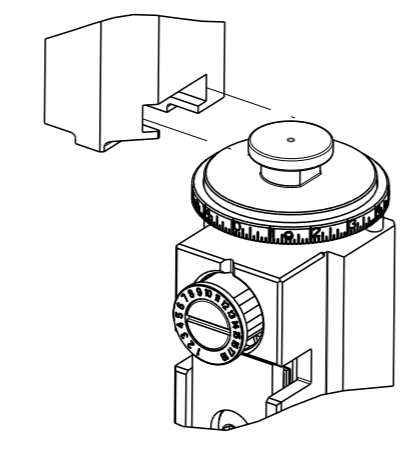


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266147-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266147-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266147-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266147-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266147-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



LOC	DIST	REVISIONS					
A	66	#	LY#	DESCRIPTION	DATE	OWN	APVD
		2		REVISED	07NOV2013	GH	TE
		A		RELEASED	09JAN2014	GH	TE
		A1		ECR-14-018202	05DEC2014	JH	TE
		B		ECR-18-015289	26SEP2018	JAH	CT

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.110]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
8.00-8.00 mm [3.15-.315 IN]	Ø

TERMINAL APPLICATION SPECIFICATION 25768 Rev 13

TERMINALS APPLIED

TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949691-1	25768.213.178	1949691-6	25768.160.009
1949691-2	25768.213.111	1949691-7	25768.123.179
1949691-3	25768.213.179	1949691-8	25768.123.178
1949691-4	25768.411.131	1949691-9	25768.123.009
1949691-5	25768.201.178		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.5+ 1.5	1.80+/-0.05 [1.071+/-0.002]	5.8
(2) 0.5 + 1.0	1.80+/-0.05 [1.071+/-0.002]	5.9
(4) 0.50	1.80+/-0.05 [1.071+/-0.002]	6.1
(3) 0.75	1.80+/-0.05 [1.071+/-0.002]	6.1
(2) 0.75	1.70+/-0.05 [1.067+/-0.002]	6.8
(3) 0.50	1.70+/-0.05 [1.067+/-0.002]	6.9
0.50 + 1.00	1.65+/-0.05 [1.065+/-0.002]	7.5
0.50 + (2) 0.35	1.55+/-0.05 [1.061+/-0.002]	8.8

***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.

- 1 RECOMMENDED SPARE PARTS
 - 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - 3 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.
 - 4 POSITION STRIPPER IN FRONT OF SHEAR DEPRESSOR.
 - 5 TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

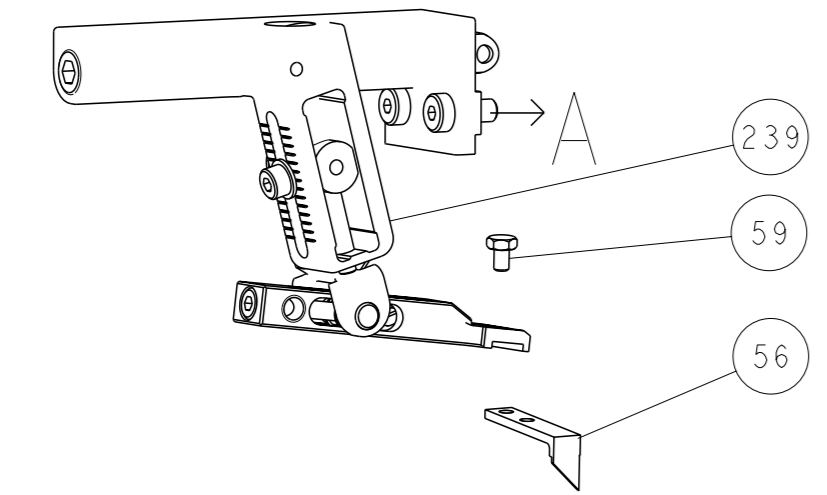
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
5	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	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	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	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	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1	1	240792-1	DRAG, TERMINAL	25	
-	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	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-2	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	318707-1	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1	2-1633933-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
1	1	2	2	1	1	6-456408-3	CRIMPER, WIRE PREMIUM	1

DIMENSIONS: 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN HOFFNER 04NOV2013 CHK T. ELBIN 05NOV2013 APVD T. ELBIN 05NOV2013	TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:
WEIGHT:		SCALE: 1:2		SHEET 1 OF 4		REV B

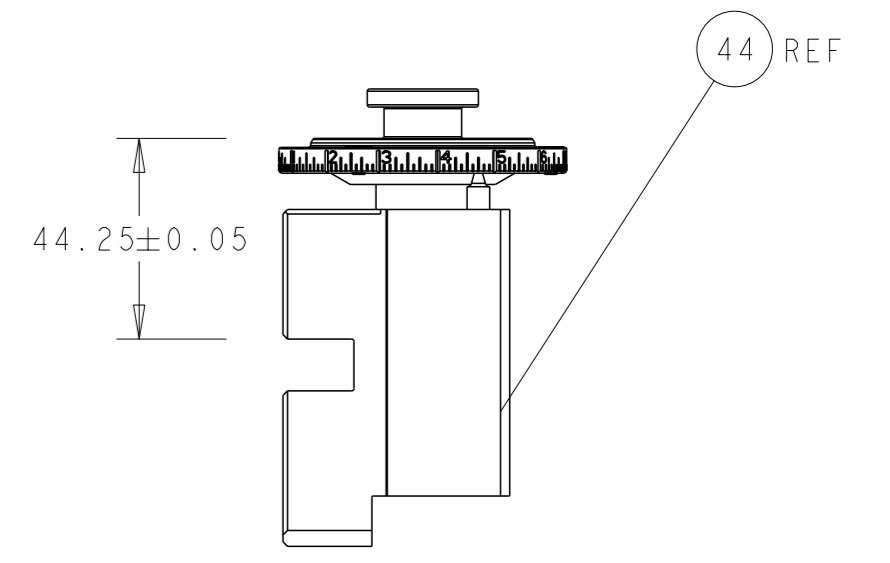
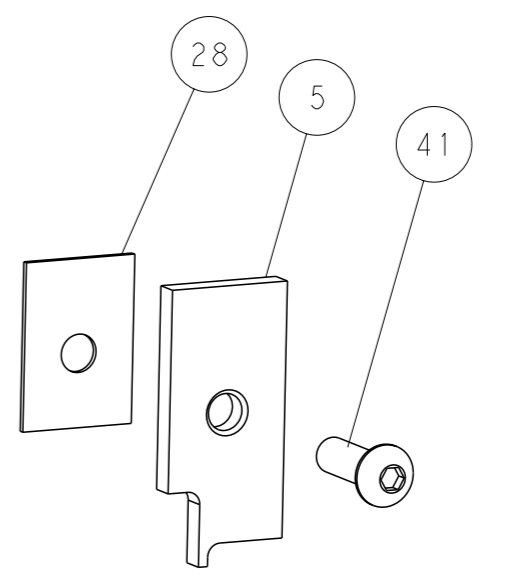
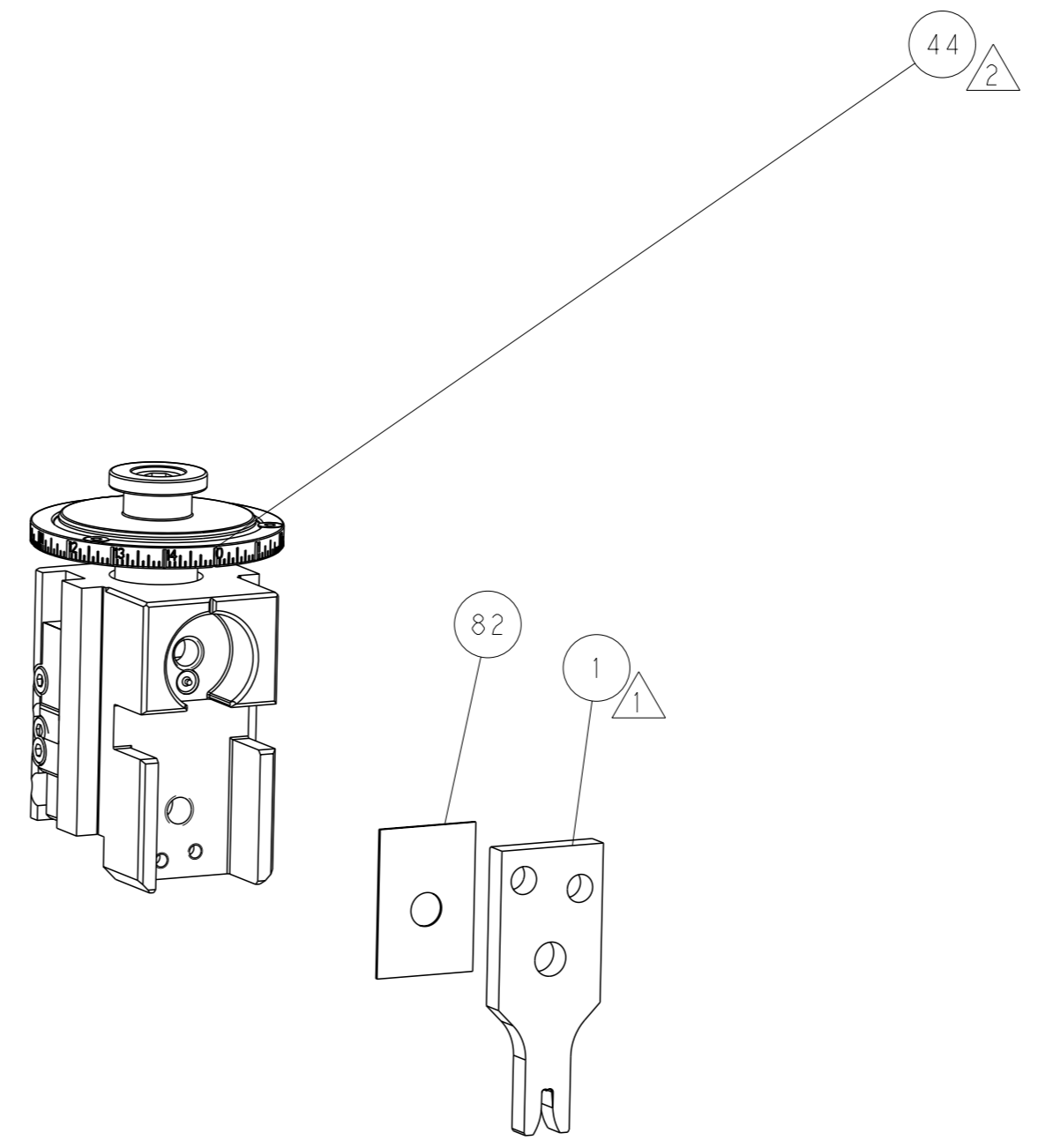
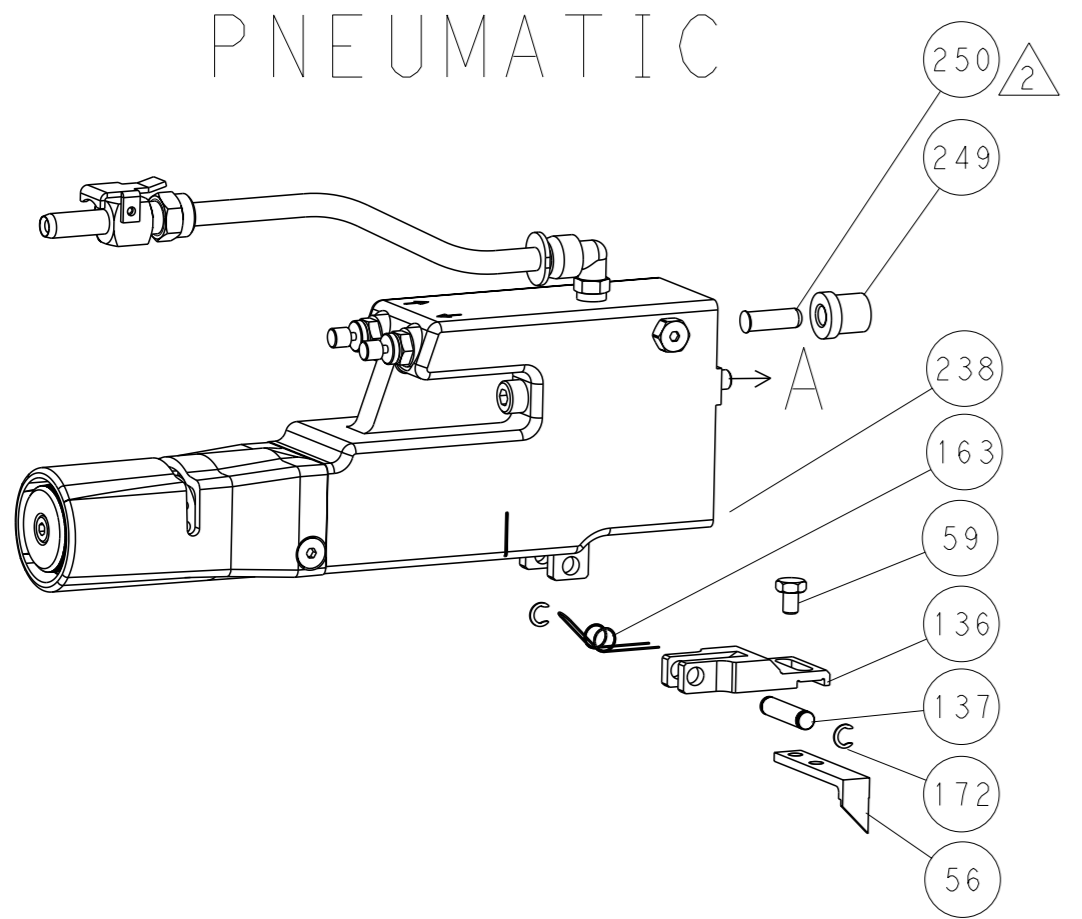
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL

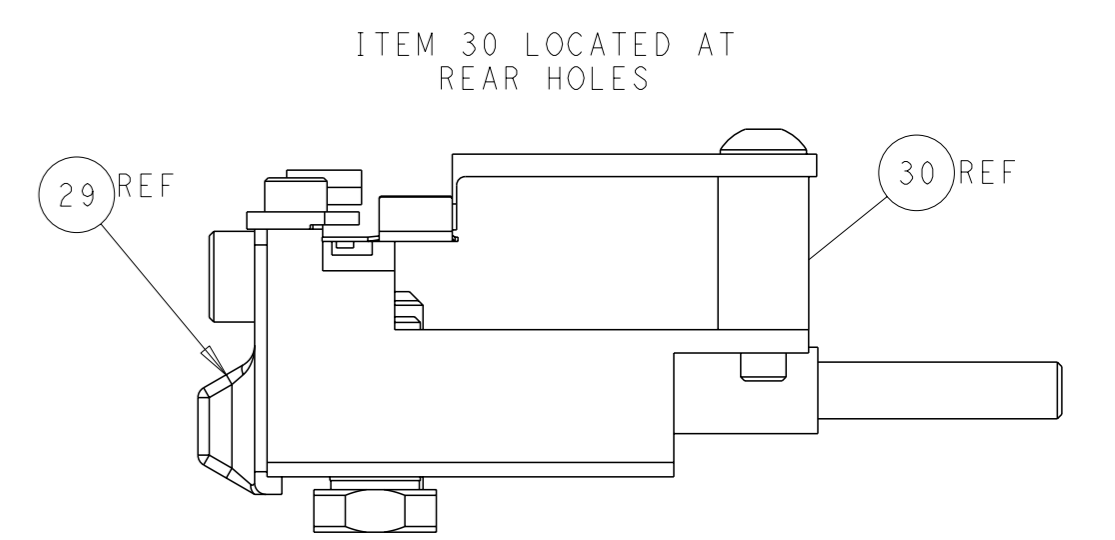
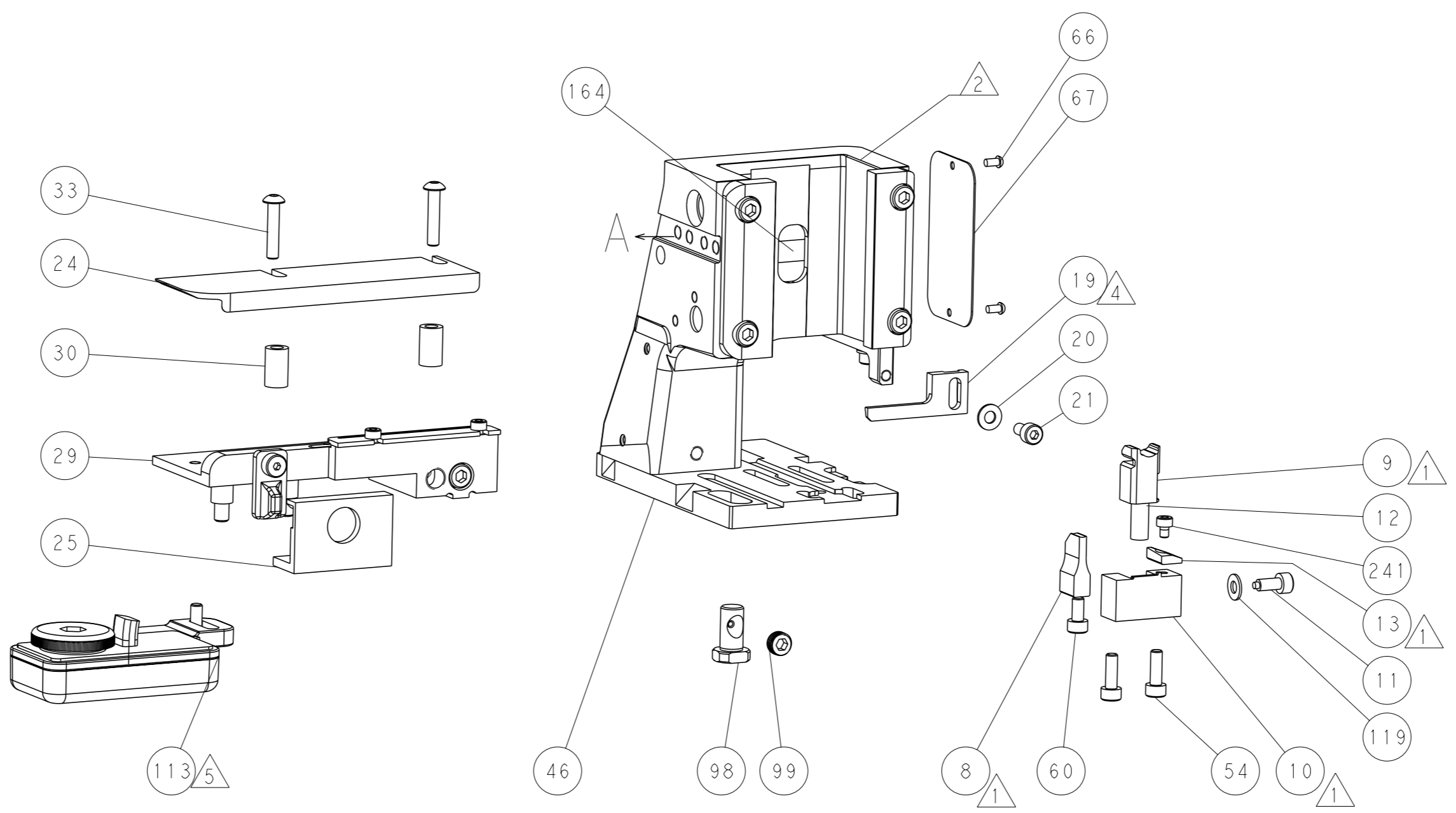
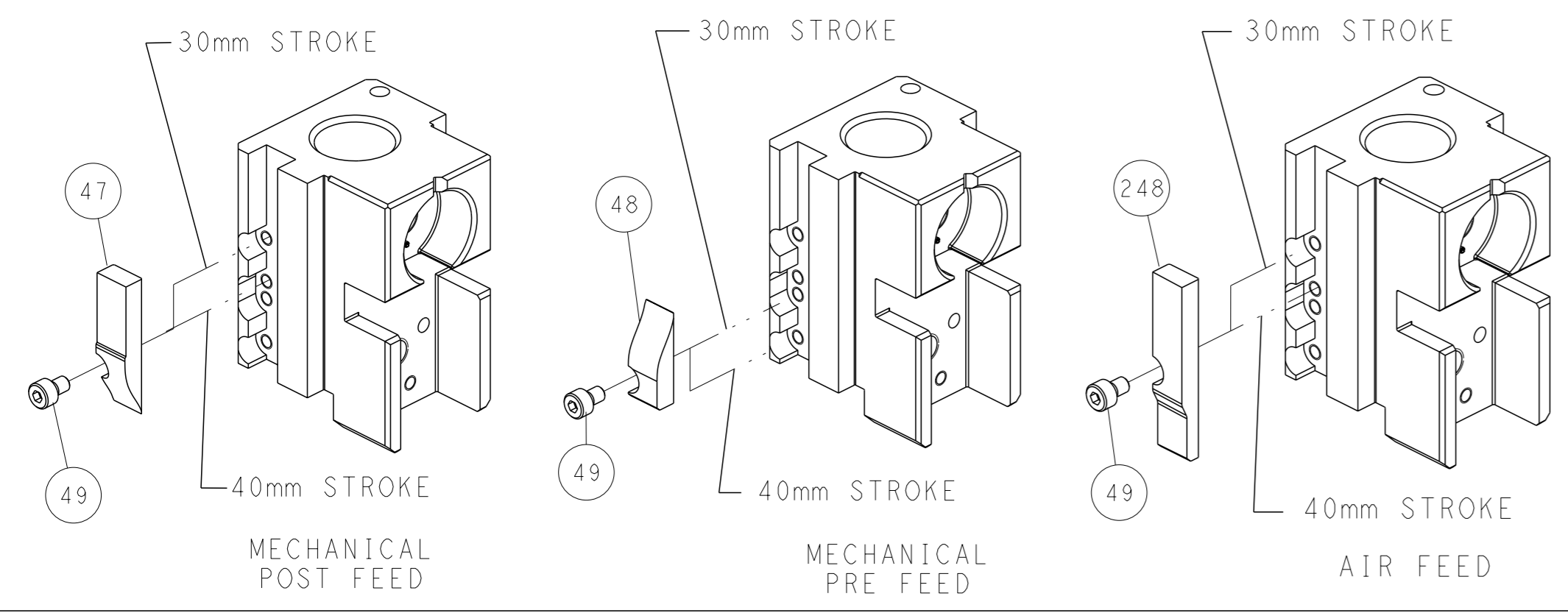


PNEUMATIC



RAM SET-UP

CAM POSITIONS



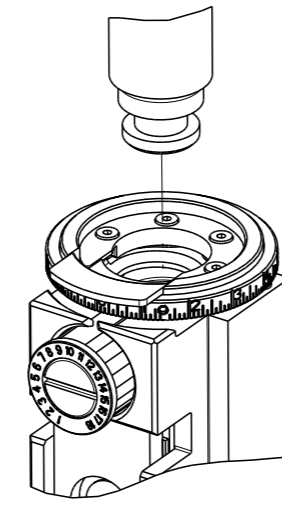
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND RESTRICTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: HOFFNER 04NOV2013 CHK: TELBIN 05NOV2013 APVD: TELBIN 05NOV2013	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266147	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: B
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266147-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266147-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266147-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 8.00-8.00 mm [.315-.315 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION 25768 Rev 13			
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949691-1	25768.213.178	1949691-6	25768.160.009
1949691-2	25768.213.111	1949691-7	25768.123.179
1949691-3	25768.213.179	1949691-8	25768.123.178
1949691-4	25768.411.131	1949691-9	25768.123.009
1949691-5	25768.201.178		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
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(4) 0.50	1.80 +/- 0.05 [.071 +/- .002]	6.1
(3) 0.75	1.80 +/- 0.05 [.071 +/- .002]	6.1
(2) 0.75	1.70 +/- 0.05 [.067 +/- .002]	6.8
(3) 0.50	1.70 +/- 0.05 [.067 +/- .002]	6.9
0.50 + 1.00	1.65 +/- 0.05 [.065 +/- .002]	7.5
0.50 + (2) 0.35	1.55 +/- 0.05 [.061 +/- .002]	8.8

- 1 RECOMMENDED SPARE PARTS
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- 3 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.
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- 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	DESCRIPTION	DATE	OWN	APVD
A	66	-	SEE SHEET 1	-	-	-

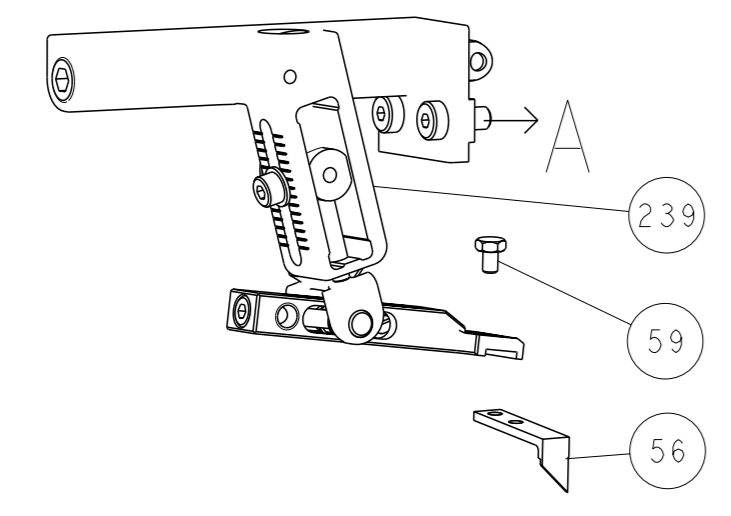
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	2	2	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
5	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-1	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
-	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
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-2	STRIPPER, SIDE FEED	19
1	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	2-1633933-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
1	1	1	6-456408-3	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)

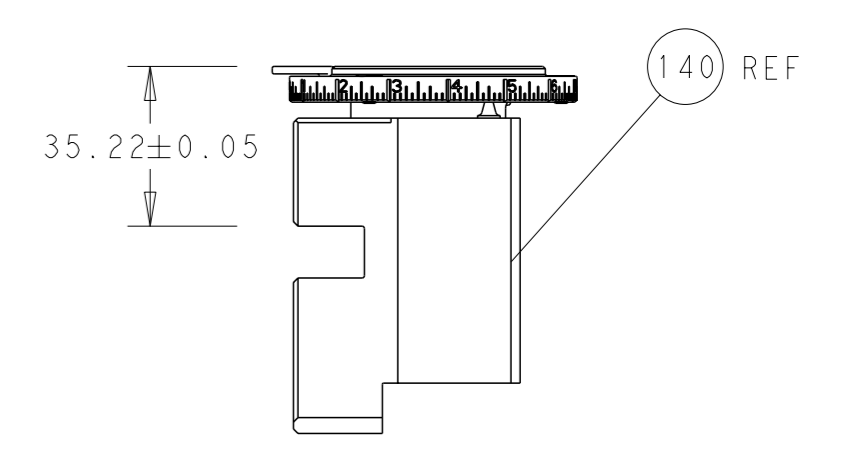
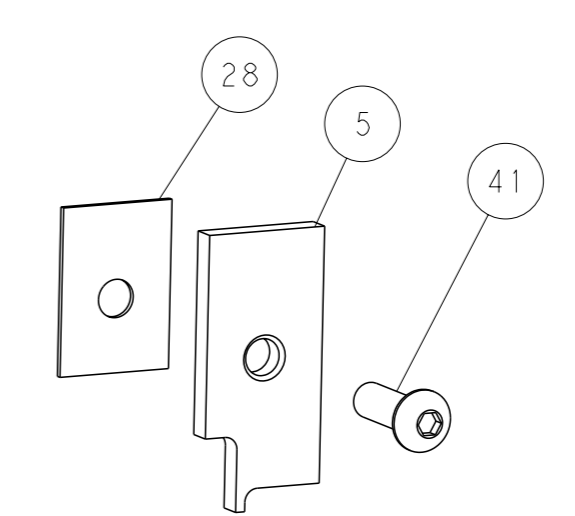
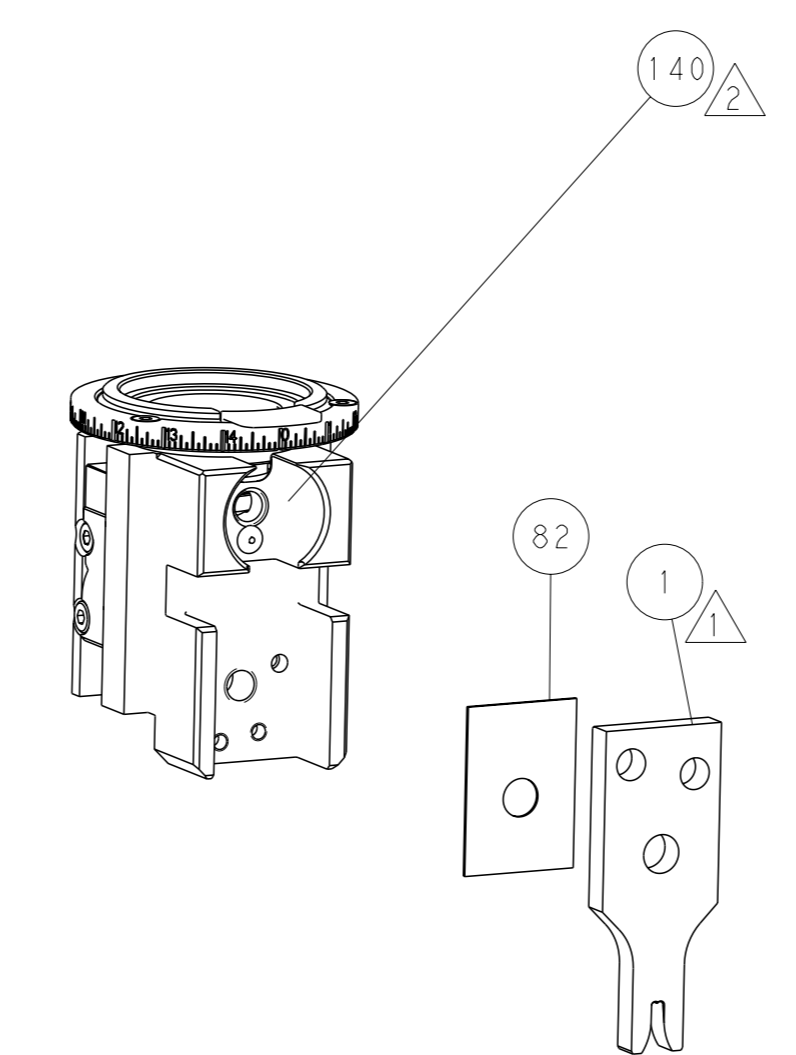
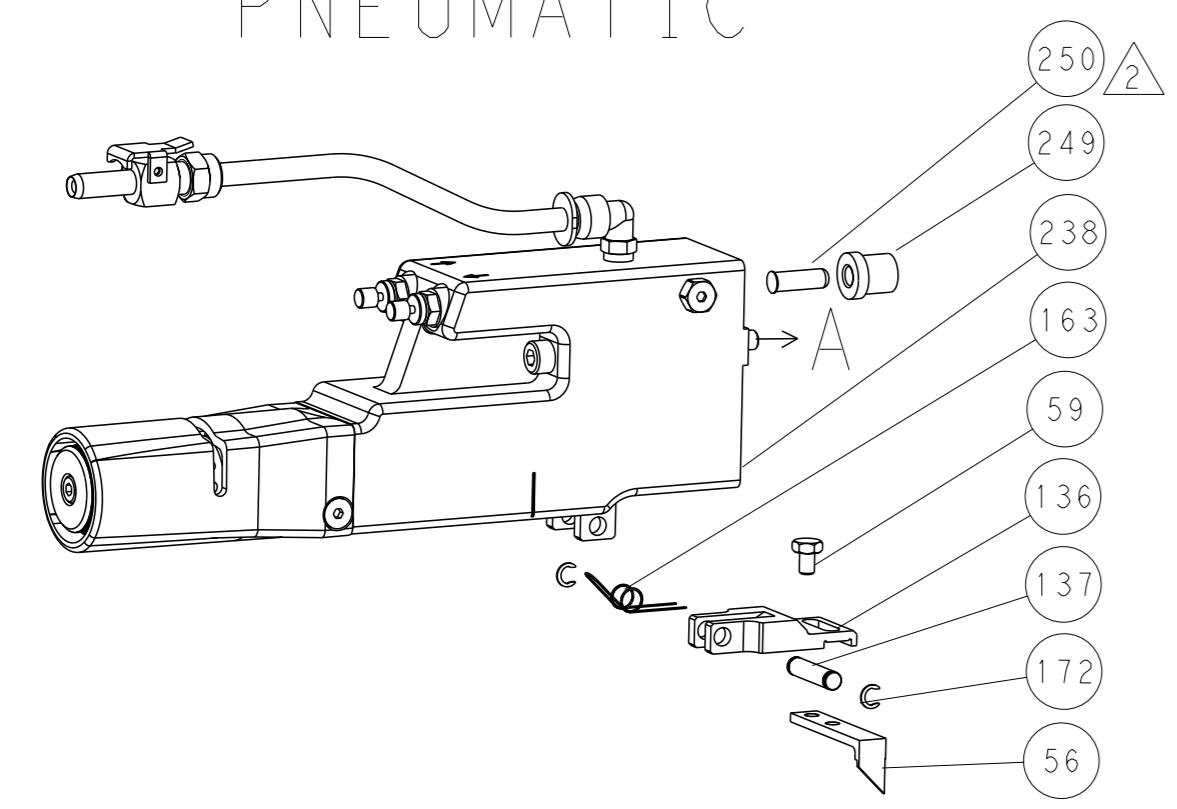
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0 PLC ±		1 PLC ±		CHE: T. ELBIN 05NOV2013	
2 PLC ±		3 PLC ±		APVD: T. ELBIN 05NOV2013	NAME: Ocean Side Feed Applicator
4 PLC ±		ANGLES FINISH		APPLICATION SPEC	
MATERIAL		WEIGHT		SIZE: A1	CAGE CODE: 00779
				DRAWING NO: 2266147	RESTRICTED TO: -
Customer Accessible Production Drawing				SCALE: 1:2	SHEET: 3 of 4

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

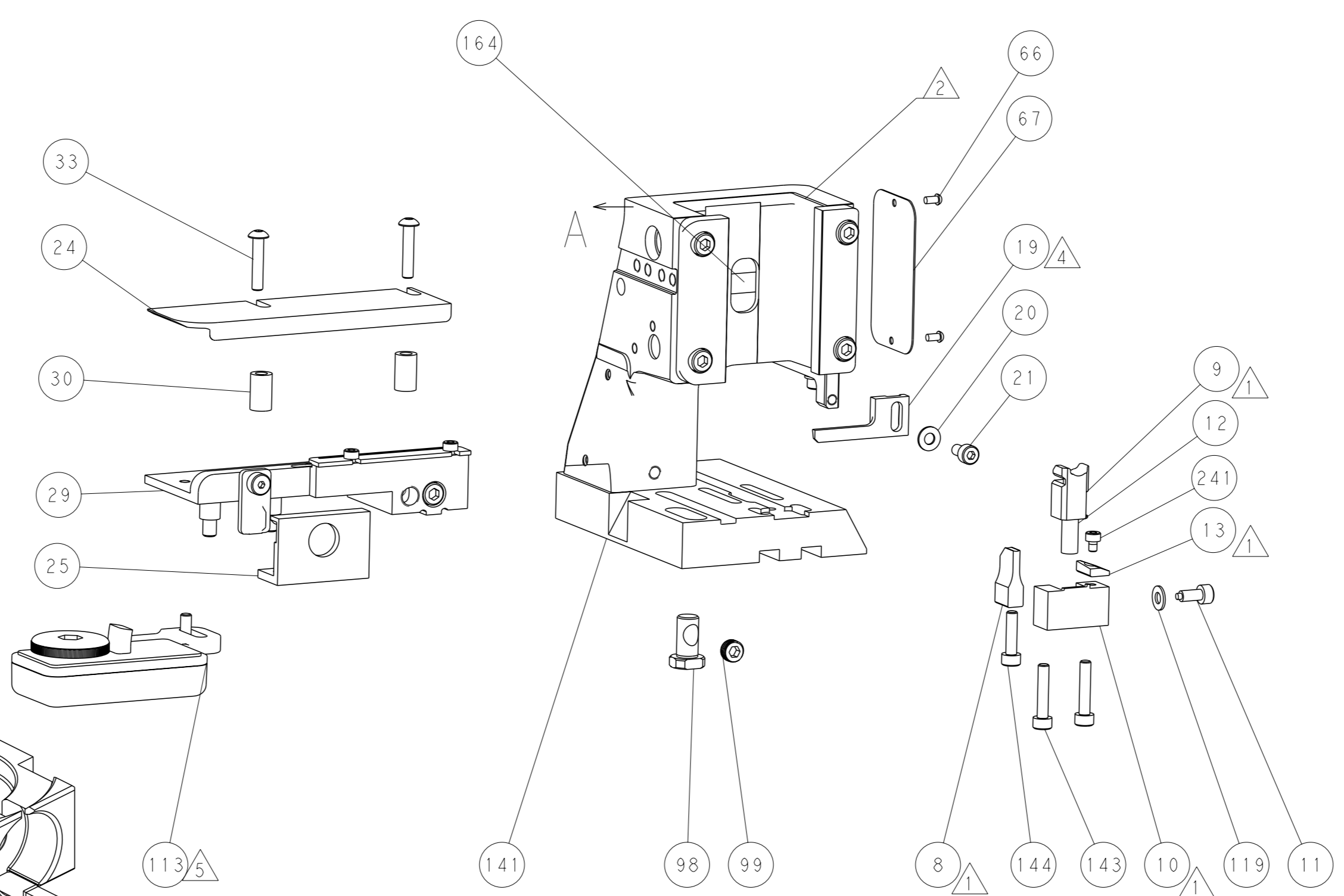
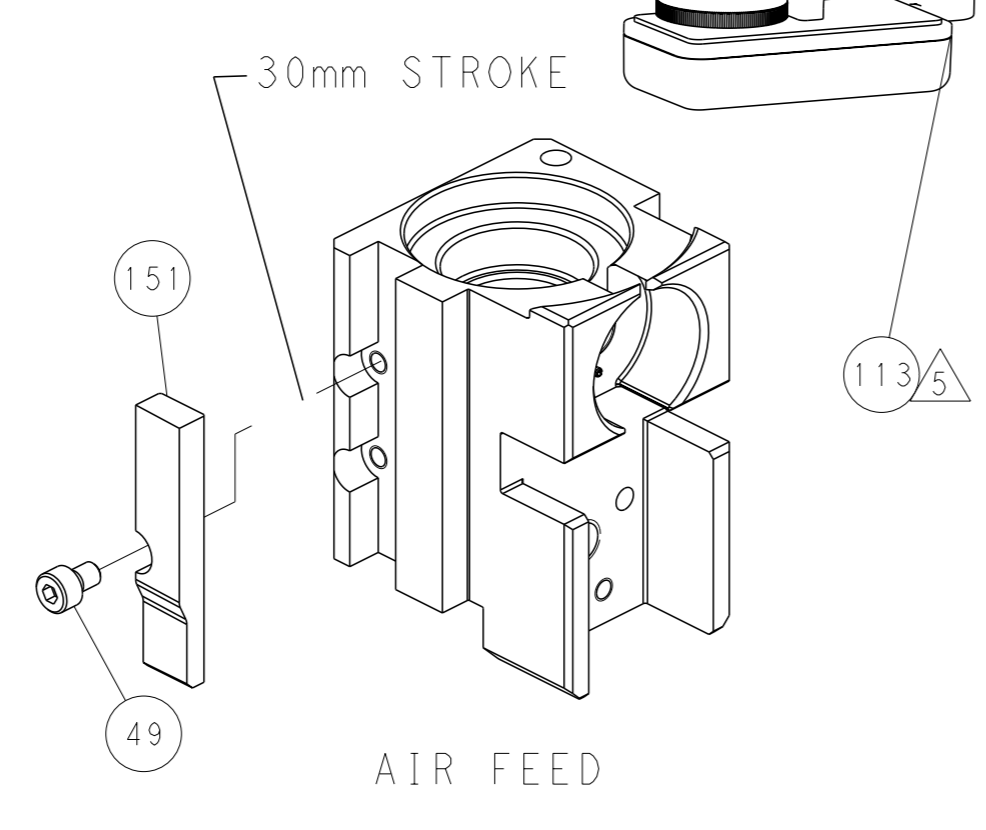
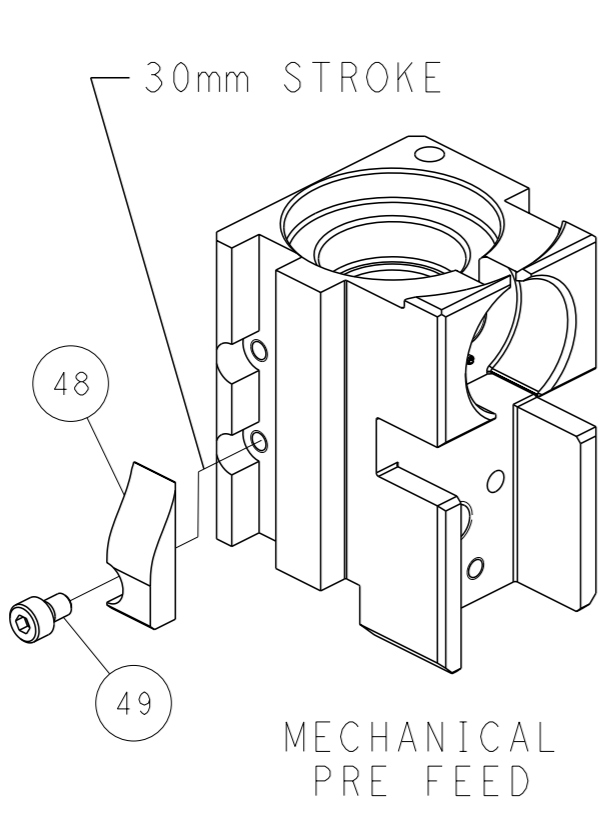
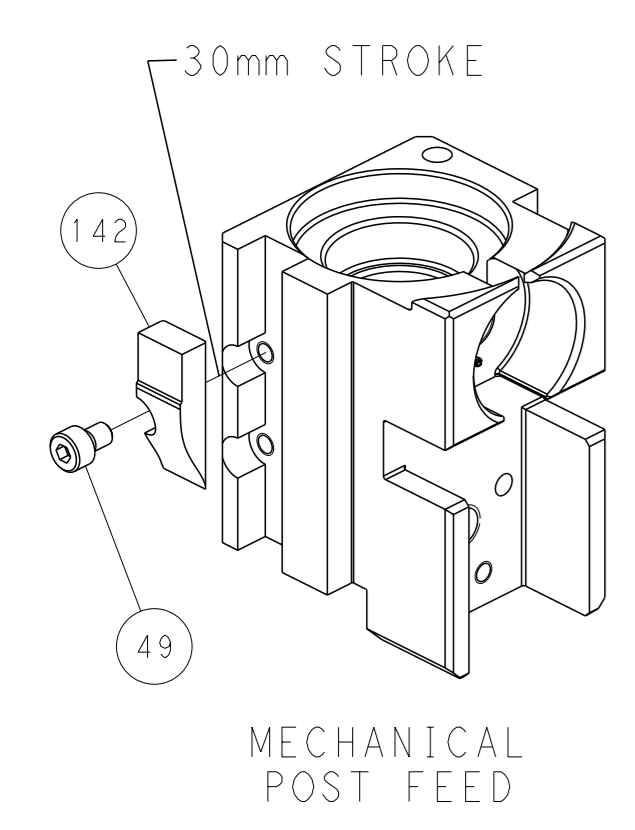
FEED TYPE MECHANICAL



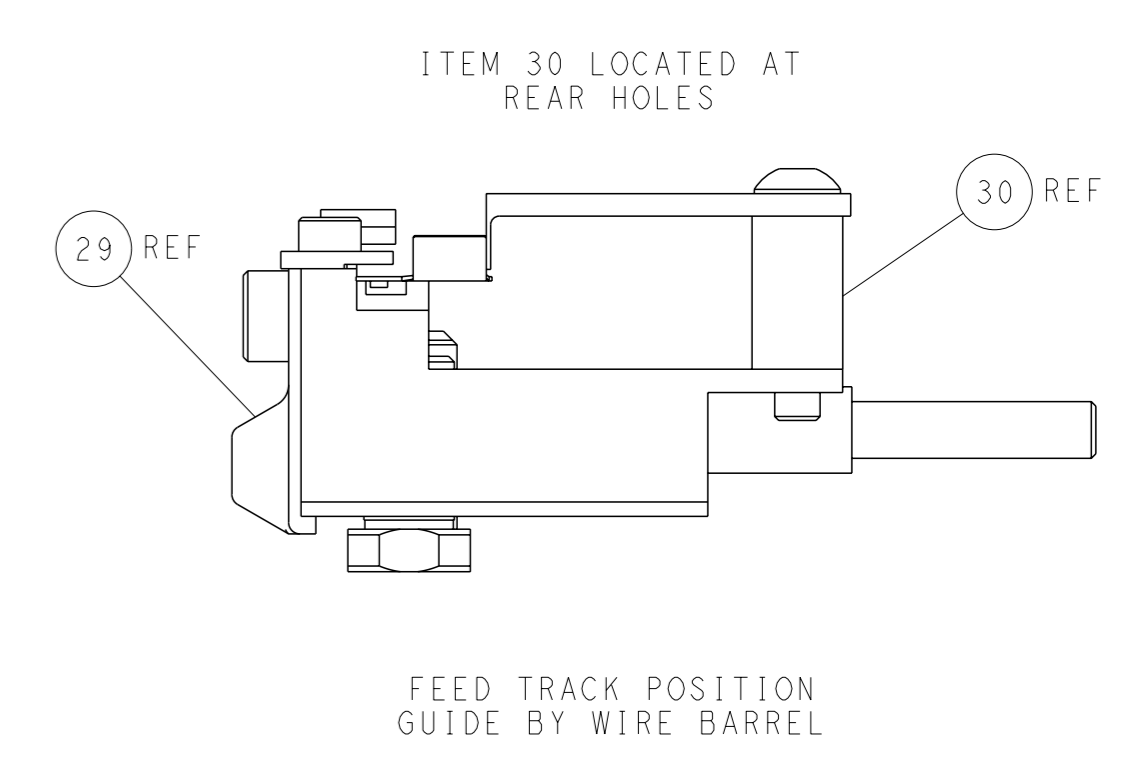
PNEUMATIC



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 ±	NAME: Ocean Side Feed Applicator APPLICATION SPEC: - PRODUCT SPEC: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266147	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: B
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION