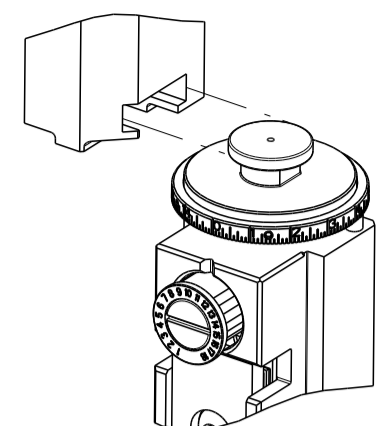


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266403-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266403-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266403-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.35 mm [.250]	F
INSUL	8.51 mm [.335]	OV

APPLICATOR INSTRUCTIONS
408-35043

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: 9.5MM RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
7.50-8.50 mm [.295-.335 IN]	Ø4.60-5.80 mm [.181-.228 IN]		
TERMINAL APPLICATION SPECIFICATION	72-WT10-3209 Rev WA2114		
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1572755-1	7116-3250	2-1203801-3	7116-3250

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
8.00mm2	2.75 +/- 0.05 [.108 +/- .002]	5.9
6.00mm2	2.45 +/- 0.05 [.096 +/- .002]	6.7
5.00mm2	2.40 +/- 0.05 [.094 +/- .002]	9.2

- 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. TERMINAL LUBRICANT IS RECOMMENDED.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	17DEC2014	KH	TE
		B		ECR-19-000060	03JAN2019	JAH	TE
		C		ECR-19-009765	22JUN2019	TB	TE

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1633782-2	FENCE	267	
-	1	1	1803078-2	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2844940-2	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
6	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1-690438-0	FRONT STRIP GUIDE	96	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1-455888-1	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	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	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	1338683-8	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1803583-9	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	1-1752356-8	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	2844992-3	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1-455888-5	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-6	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	
-	1	1	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	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-3	STOP, SHEAR	11	
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
1	-	1	1	454276-5	FLOATING SHEAR, FRONT	9
1	1	2	1	2-1633930-9	ANVIL, COMBINATION	8
-	1	1	1-240641-4	SPACER	7	
-	-	-	-	-	6	
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4	
1	1	2	1	6-2119785-4	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	1	456432-9	CRIMPER, WIRE	1

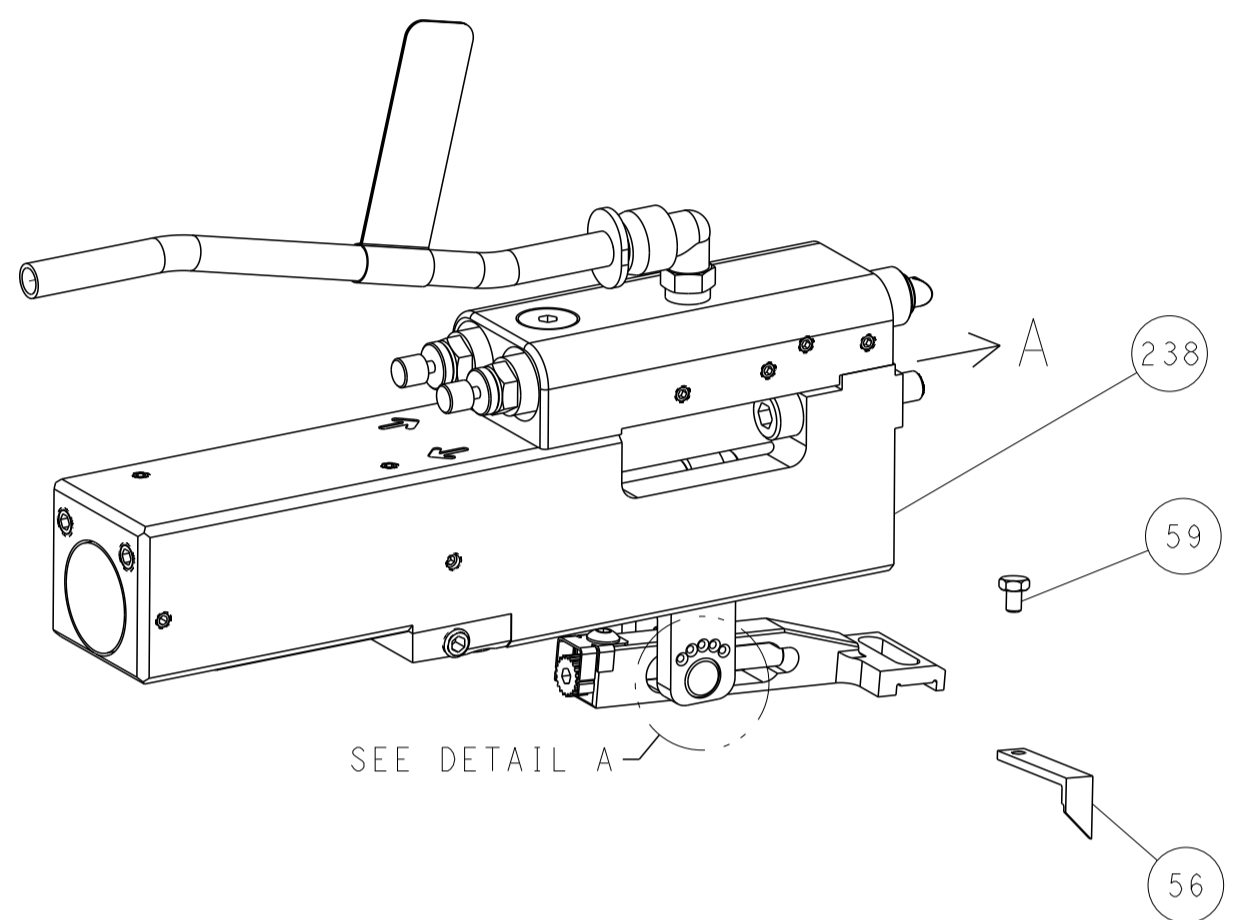
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

ITEM NO	-77-72 -2	PART NO		DESCRIPTION	
OWN	H. HUANG	19NOV2012		TE Connectivity	
CHK	S. XI	19NOV2012		Harrisburg, PA 17105-3608	
APVD	S. XI	19NOV2012			
PRODUCT SPEC					
APPLICATION SPEC					
SIZE	A1	CAGE CODE	00779	DRAWING NO	2266403
RESTRICTED TO					
Customer Accessible Production Drawing		SCALE	1:2	SHEET	1 of 4
				REV	C

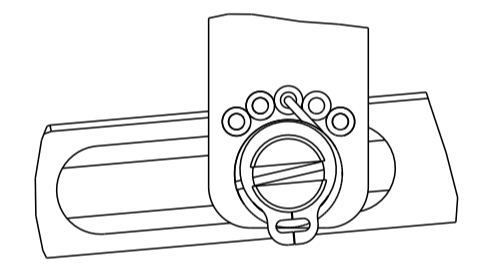
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

FEED TYPE

PNEUMATIC

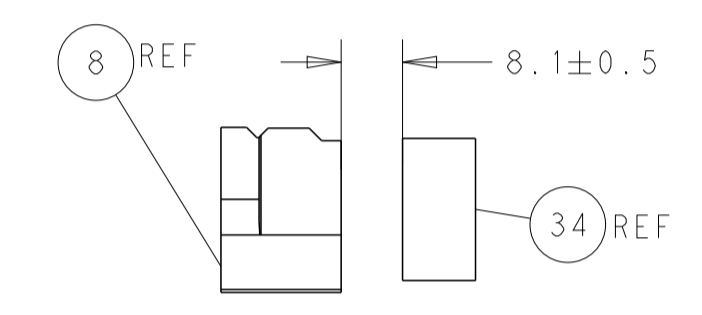
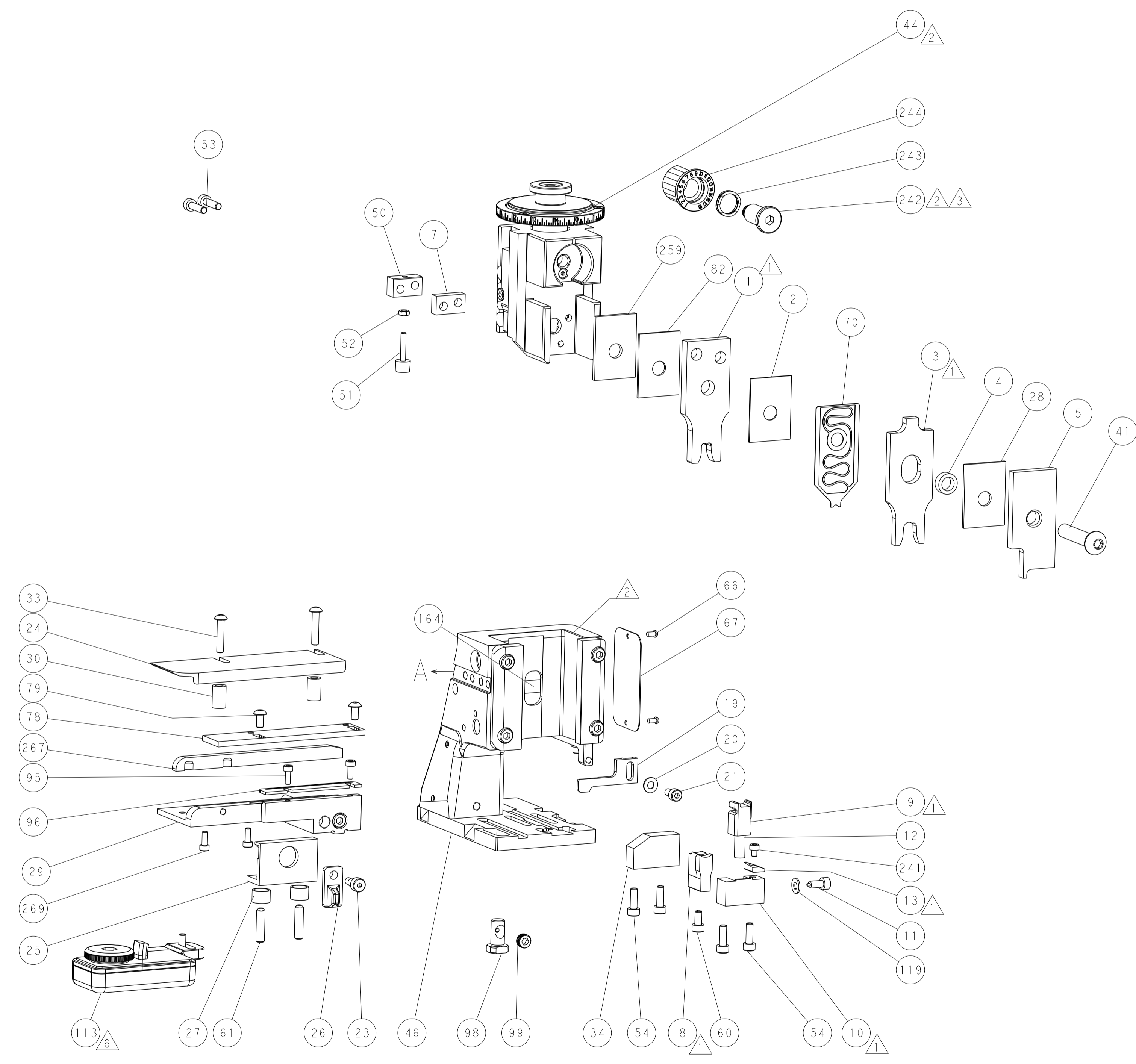
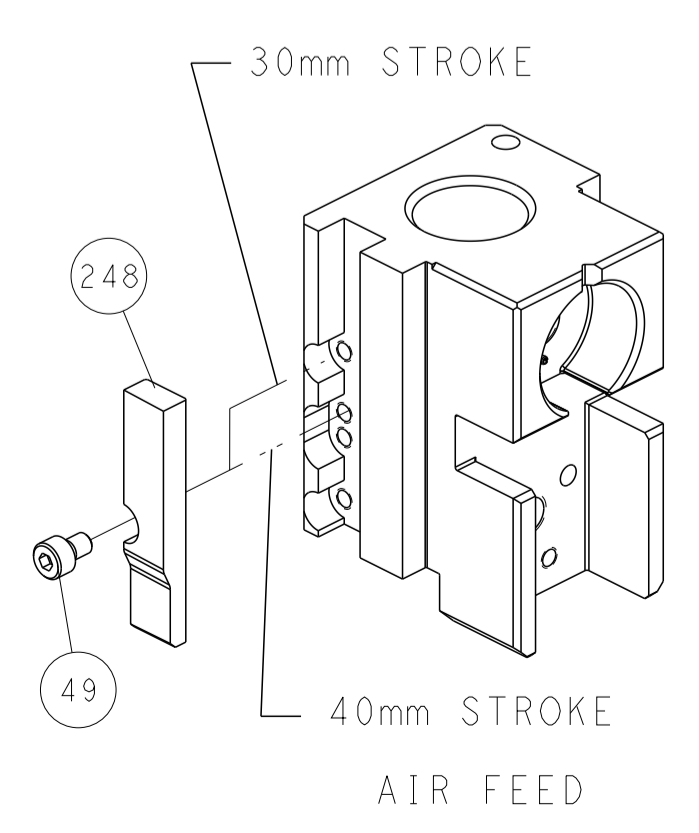


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

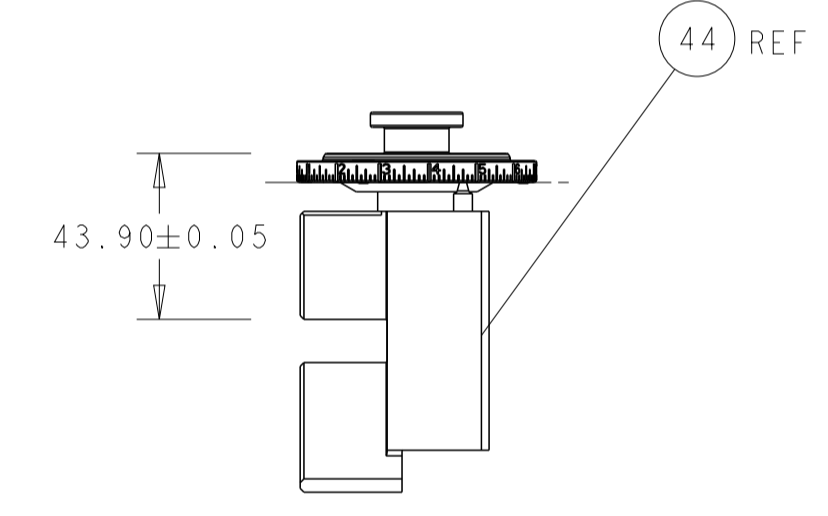


DETAIL A

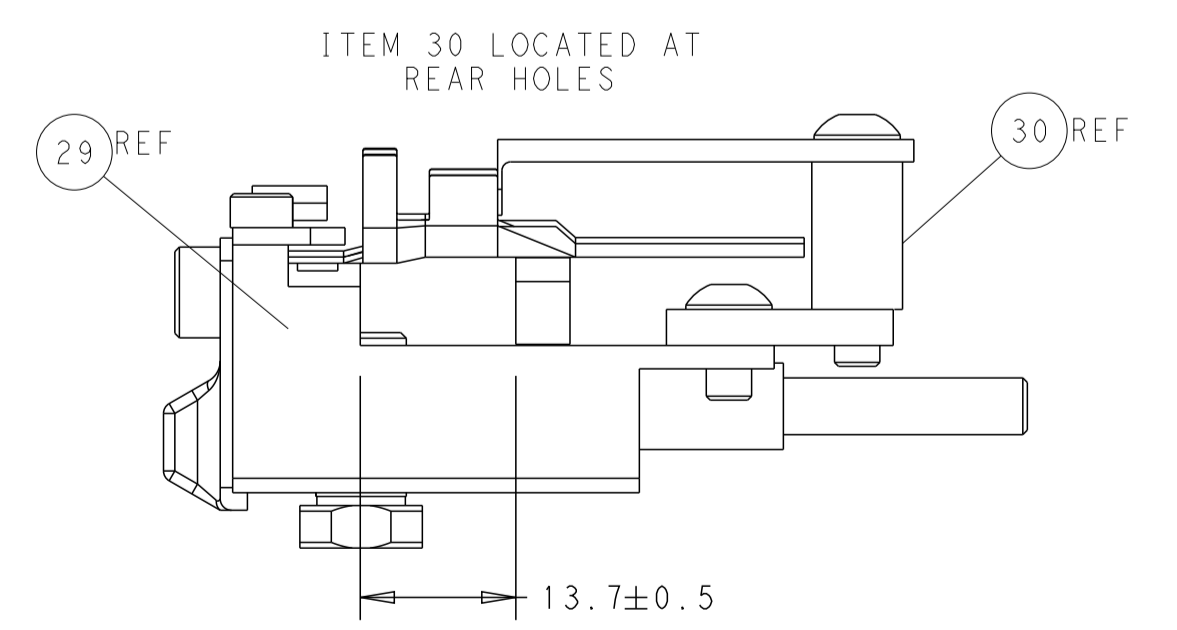
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



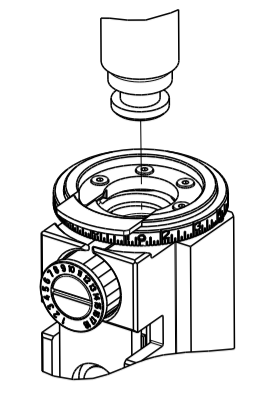
FEED TRACK POSITION GUIDE BY WIRE BARREL

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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. HUANG 19NOV2012 CHK: S. XI 19NOV2012 APVD: S. XI 19NOV2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266403 WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SHEET 2 OF 4 REV C
Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266403-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266403-7	A	CRIMP TOOLING KIT	-

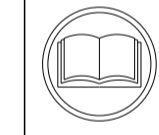
PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.35 mm [.250]	F
INSUL	8.51 mm [.335]	OV
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: 9.5MM RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.50-8.50 mm [.295-.335 IN]		Ø4.60-5.80 mm [.181-.228 IN]	
TERMINAL APPLICATION SPECIFICATION		72-WT10-3209 Rev WA2114	
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1572755-1	7116-3250	2-1203801-3	7116-3250

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
8.00mm2	2.75+/-0.05 [.108+/- .002]	5.9
6.00mm2	2.45+/-0.05 [.096+/- .002]	6.7
5.00mm2	2.40+/-0.05 [.094+/- .002]	9.2



***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.

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REV	DATE	BY	CHK	APPD
A	66					

REVISIONS						
REV	DATE	DESCRIPTION	DATE	BY	CHK	APPD
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0			269
-	1	1633782-2	FENCE			267
-	1	1803078-2	SPACER, PRECISION			259
-	1	2119082-7	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	2844940-2	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	1-18028-2	WASHER, FLAT, REG M4			119
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED			113
-	1	2844908-1	SCREW, LOCKING			99
-	1	2844907-1	POST, LOCKING			98
-	1	1-690438-0	FRONT STRIP GUIDE			96
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0			95
-	1	1-455888-1	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	2119791-5	DEPRESSOR, WIRE			70
-	1	2119740-1	TAG, IDENTIFICATION			67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0			61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0			59
-	1	1338683-8	FEED PAWL			56
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16			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	1-1752356-8	SUPPORT, TERMINAL			34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)			33
-	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	2844992-3	ASSEMBLY, STRIP GUIDE			29
-	1	1-455888-5	SPACER, CRIMPER			28
-	2	22283-1	SPRING, COMPRESSION			27
-	1	356835-1	LEVER, DRAG RELEASE			26
-	1	240792-1	DRAG, TERMINAL			25
-	1	1320928-6	STRIP GUIDE			24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0			23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	1	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	1-356885-3	STOP, SHEAR			11
-	1	2119805-1	SHEAR HOLDER, FRONT			10
-	1	454276-5	FLOATING SHEAR, FRONT			9
-	1	2-1633930-9	ANVIL, COMBINATION			8
-	1	1-240641-4	SPACER			7
-	-	-	-			6
-	1	1-2119757-2	DEPRESSOR, SHEAR			5
-	1	238011-3	BLOCK, CRIMPER SPACER			4
-	1	6-2119785-4	CRIMPER, INSULATION OVERLAP PREMIUM			3
-	1	455888-7	SPACER, CRIMPER			2
-	1	456432-9	CRIMPER, WIRE			1

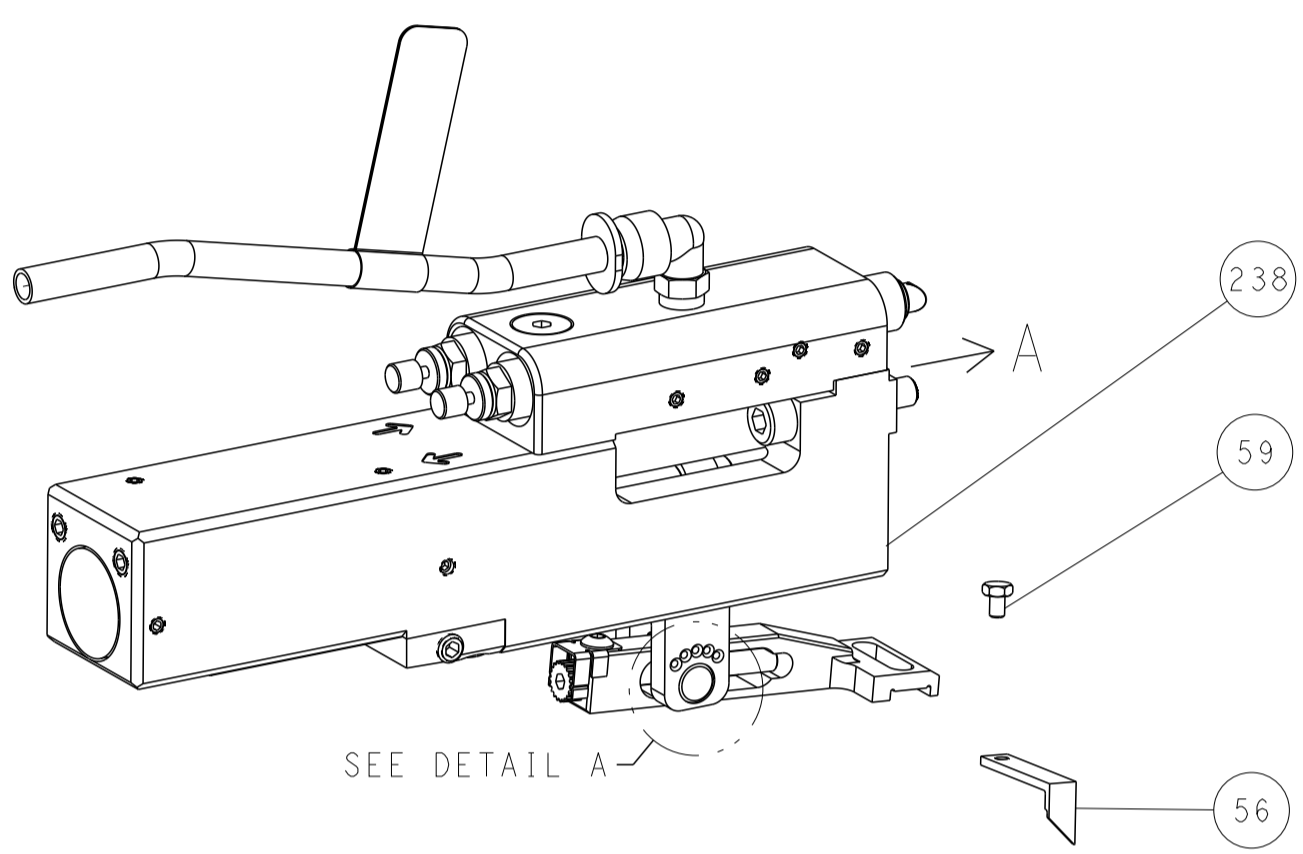
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG H. HUANG 19NOV2012	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH		CHK S. XI 19NOV2012	APPD S. XI 19NOV2012
MATERIAL				NAME Ocean Side Feed Applicator	
				SIZE A1	CAGE CODE 00779
				DRAWING NO C=2266403	RESTRICTED TO
				WEIGHT	SCALE 1:2
				SHEET 3	OF 4
				REV C	

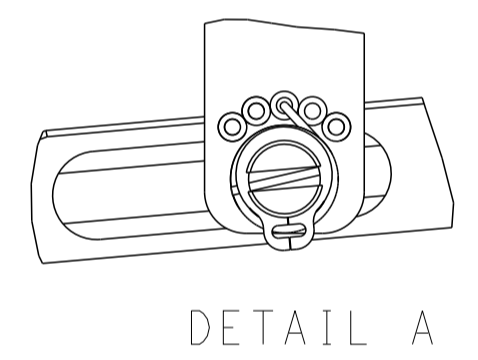
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-

FEED TYPE

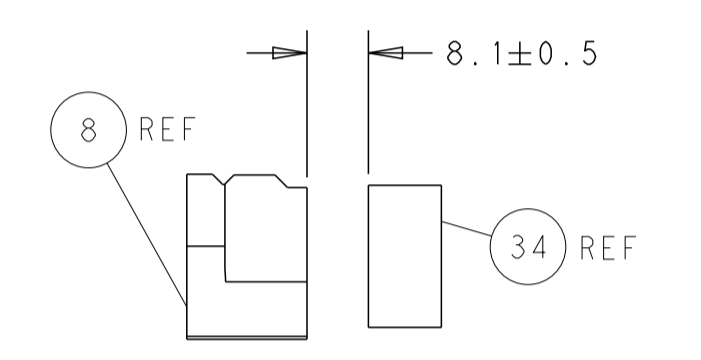
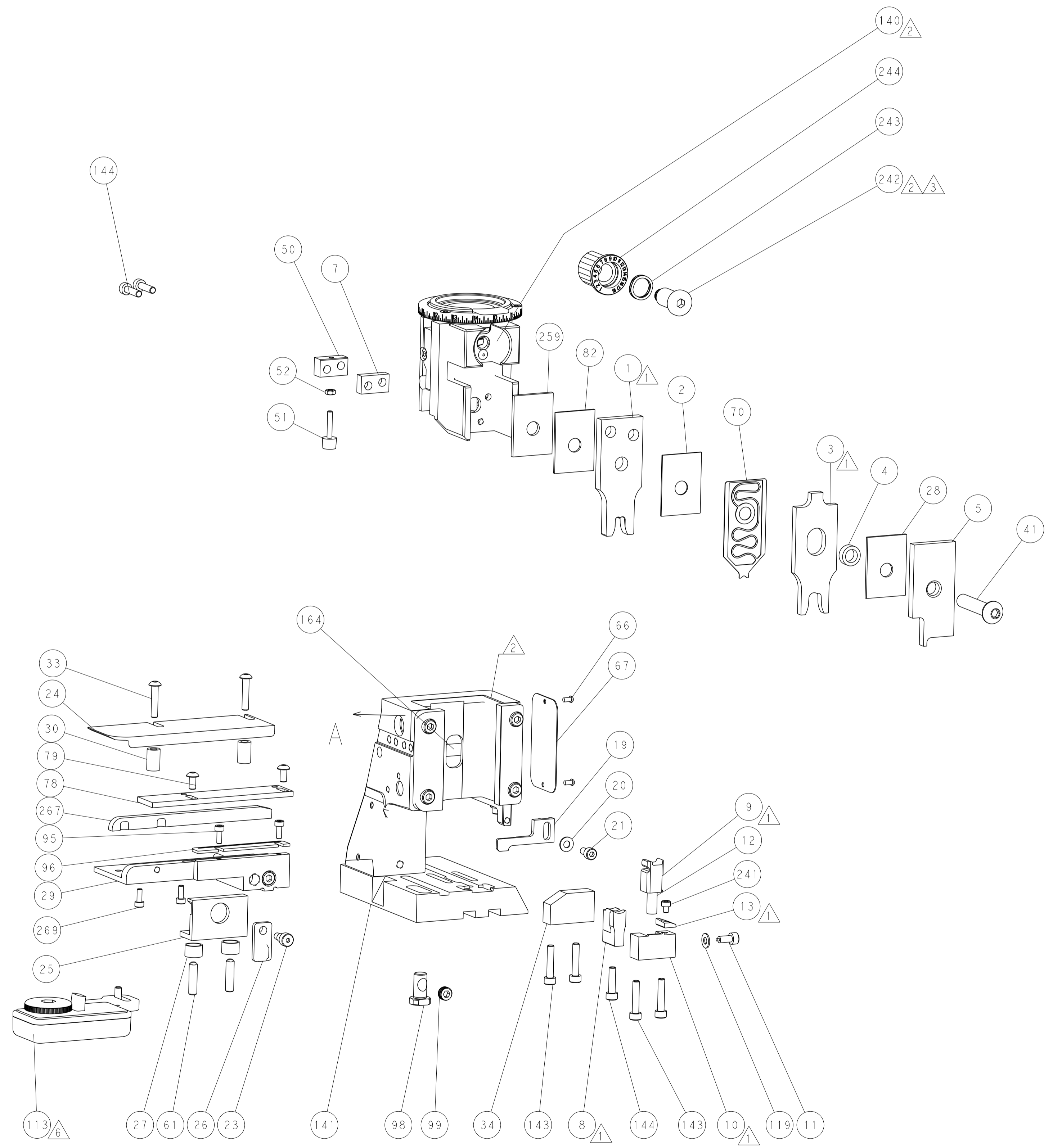
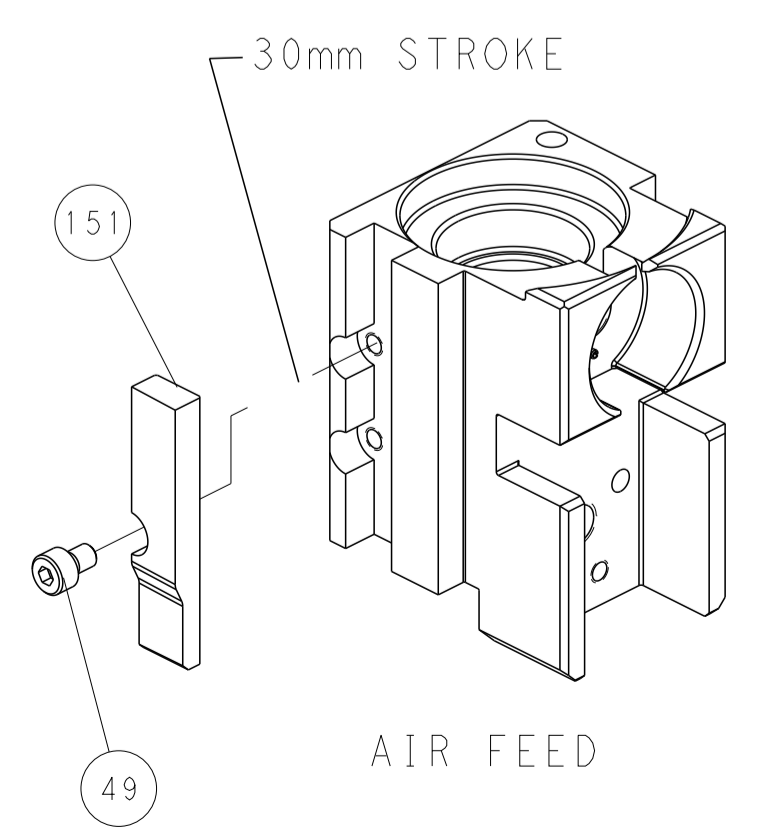
PNEUMATIC



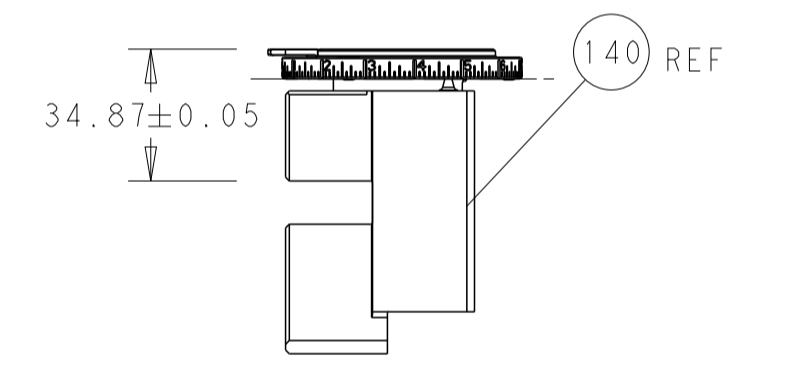
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



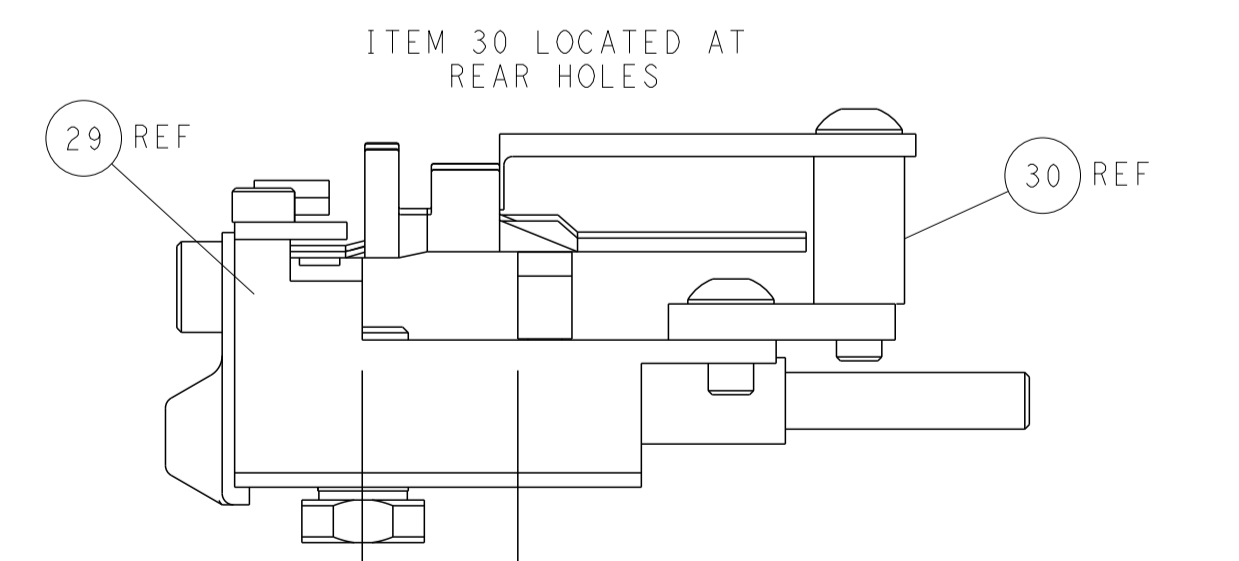
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> <small>IT IS THE BUYER'S RESPONSIBILITY TO CONTACT THE SUPPLIER FOR THE LATEST REVISIONS.</small>		DWN: H. HUANG 19NOV2012 CHK: S. XI 19NOV2012 APVD: S. XI 19NOV2012	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: 2266403	RESTRICTED TO: SCALE: 1:2 SHEET: 4 OF 4 REV: C
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing