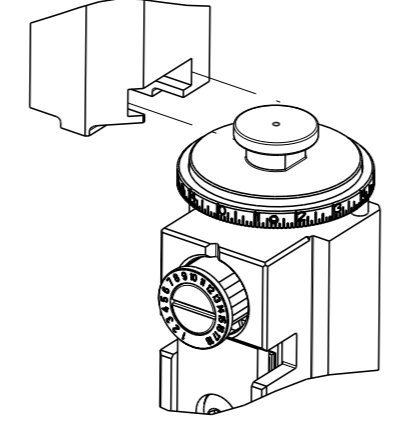


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266479-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266479-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266479-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.25 mm [.128]	F
INSUL	4.20 mm [.165]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H TERMINAL G&H CRIMP SPECIFICATION			
TERMINAL NAME: RING FORM			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.70-6.30 mm [.224-.248 IN]	3.56mm MAX [.140 IN MAX]		
TERMINAL APPLICATION SPECIFICATION	G&H SPEC		
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1949643-1	25223.123.009	1949643-4	25223.213.011
1949643-2	25223.123.011		
1949643-3	25223.212.179		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.25+/-0.05 [.089+/- .002]	5.4
0.5+1.5mm OR 1.0+1.0mm	2.15+/-0.05 [.085+/- .002]	6.5
1.50mm2	2.10+/-0.05 [.083+/- .002]	6.7

- 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.

***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.

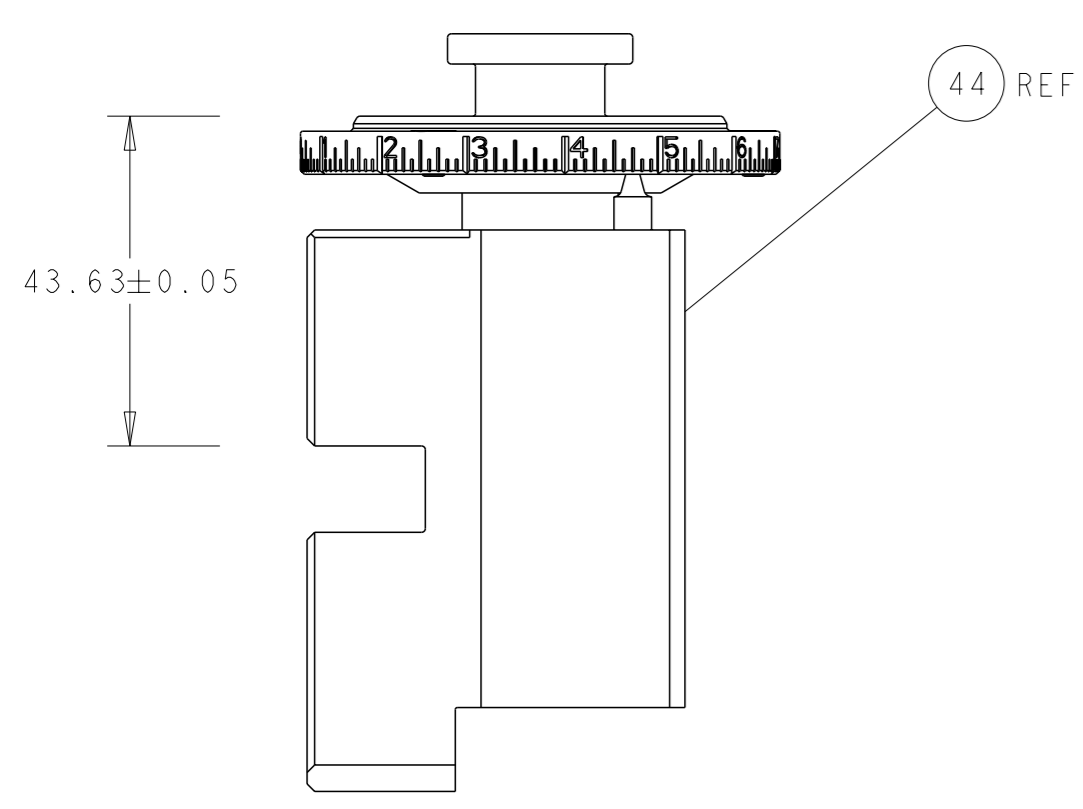
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		P	LYR	DESCRIPTION	DATE	OWN	APVD
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		A		RELEASED	04DEC2014	YY	UG
		B		ECR-20-010747	29JUL2020	JAH	GB

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-5	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	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	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
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	2063961-1	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1-2119655-1	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1-1752371-4	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	2-1901696-2	STRIP GUIDE, REAR	19
-	1	1	2-1901695-2	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1-240641-0	SPACER	16
-	1	1	1-240644-7	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-3	PLATE, FRONT SHEAR	9
1	2	1	5-1803000-7	ANVIL, COMBINATION, END FEED	8
1	1	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	7-240641-4	SPACER	5
-	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	2	1	1803187-2	CRIMPER, INSULATION F	3
-	1	1	1-455888-7	SPACER, CRIMPER	2
1	2	1	7-1633664-1	CRIMPER, WIRE	1
-	-	-	-	-	1

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

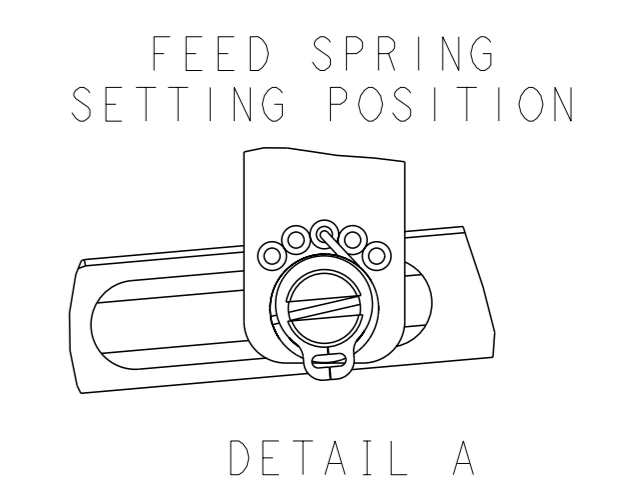
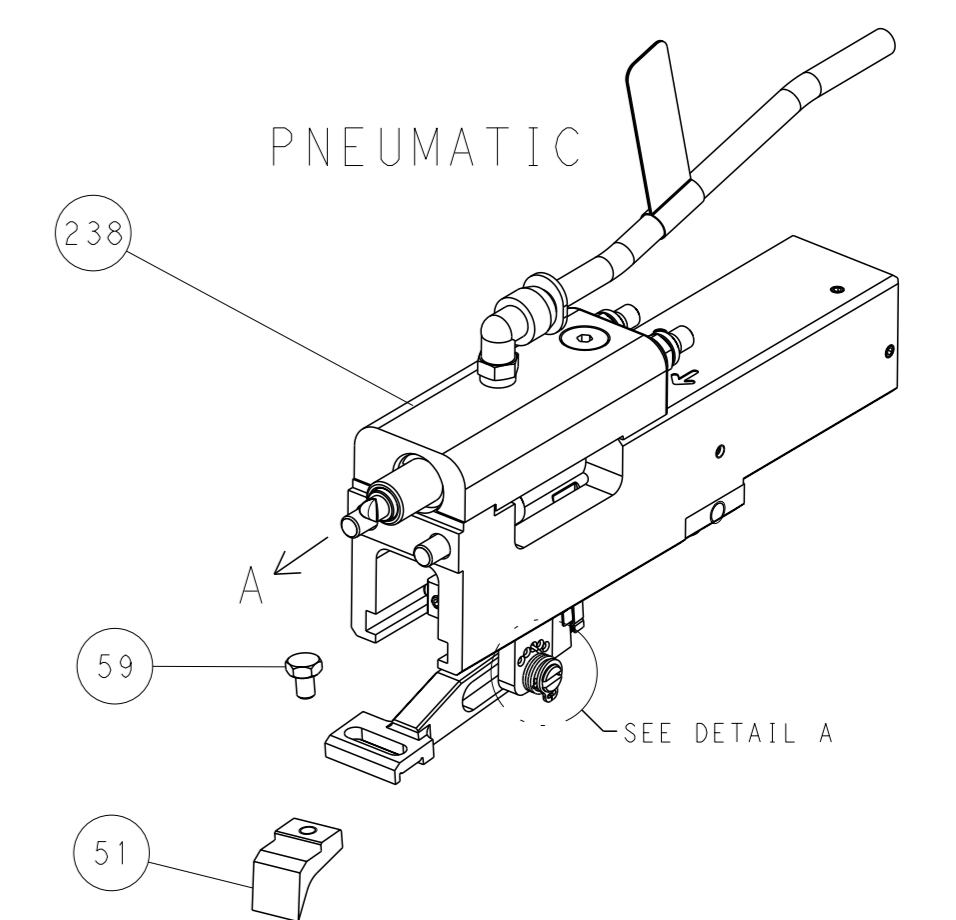
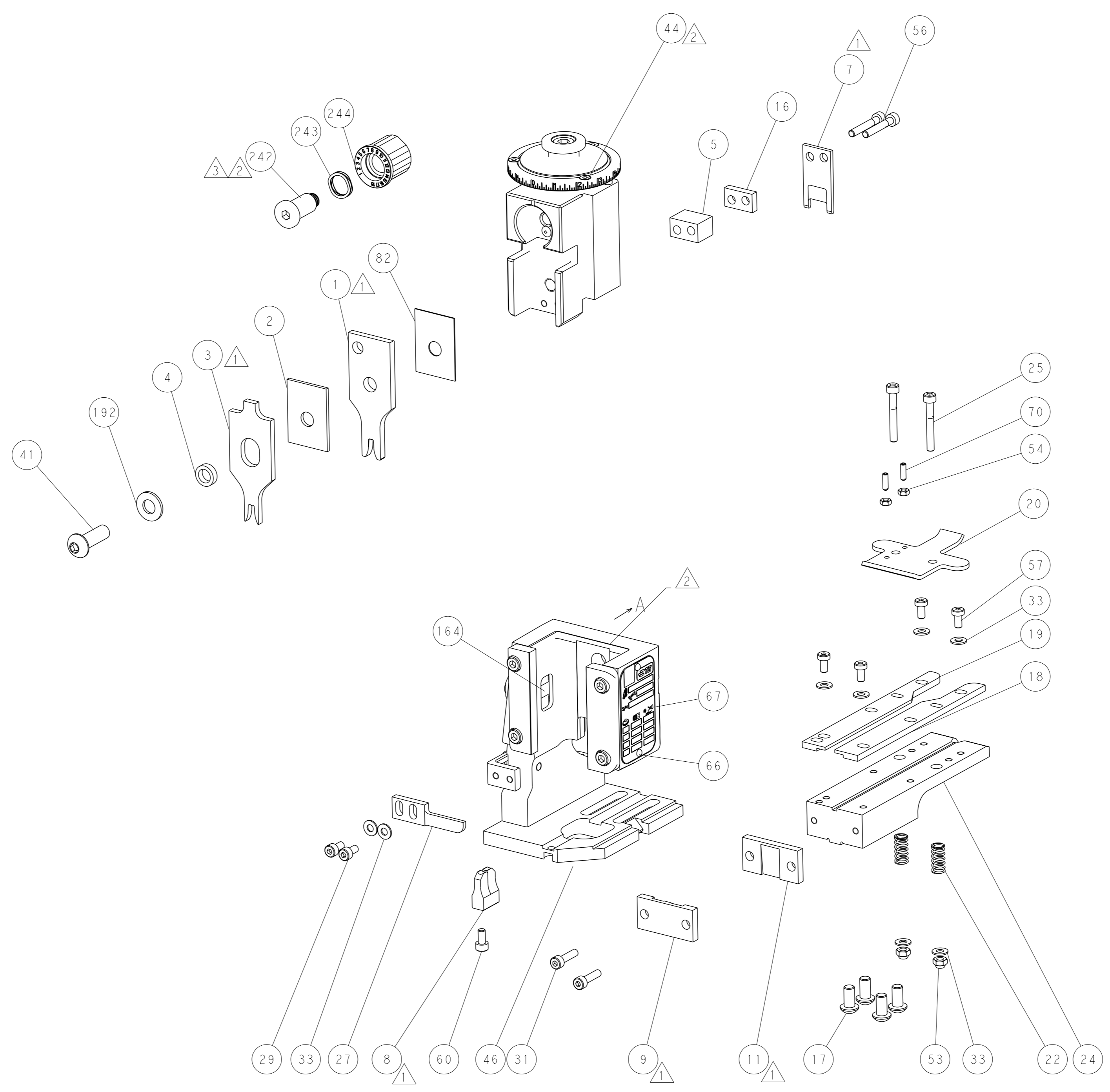
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		DWN Y. YIN 23SEP2014 CHK G. BAILEY 23SEP2014 APVD U. GUO 23SEP2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2266479 SCALE 1:1 SHEET 1 OF 4 REV B	
MATERIAL:		RESTRICTED TO:		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

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

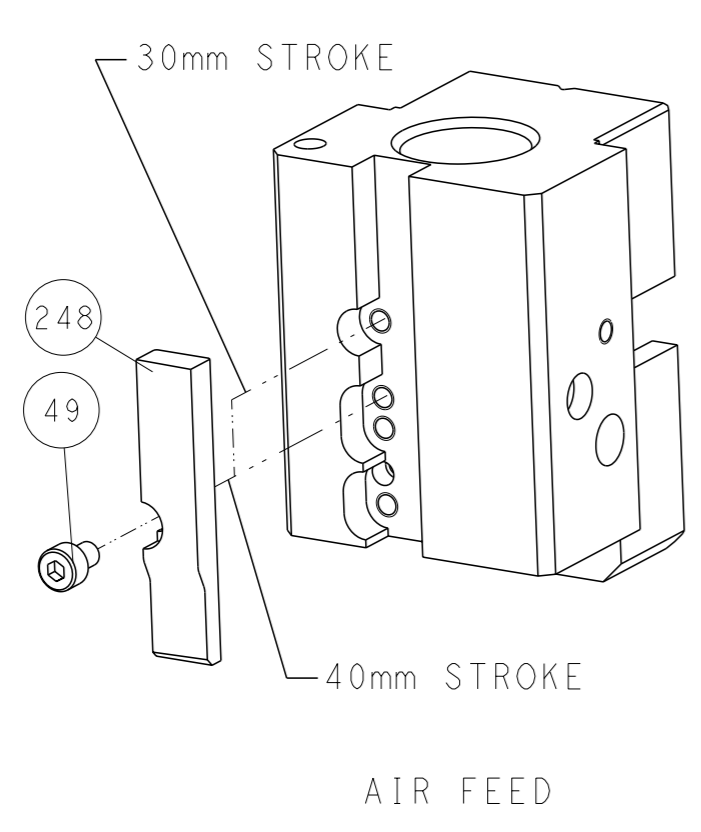


RAM SET-UP

FEED TYPE



CAM POSITIONS

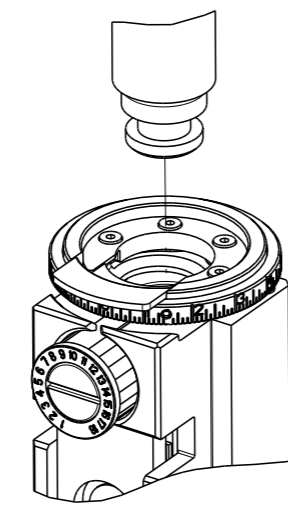


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN Y. YIN 23SEP2014 CHK G. BAILEY 23SEP2014 APVD U. GUO 23SEP2014	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 End Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2266479 WEIGHT - Customer Accessible Production Drawing	RESTRICTED TO - SCALE 1:1 SHEET 2 OF 4 REV B

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266479-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266479-7	A	CRIMP TOOLING KIT	-

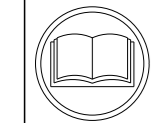
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.25 mm [.128]	F
INSUL	4.20 mm [.165]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G&H TERMINAL		G&H CRIMP SPECIFICATION	
TERMINAL NAME: RING FORM			
WIRE STRIP LENGTH 5.70-6.30 mm [.224-.248 IN]		INSULATION DIAMETER RANGE 3.56mm MAX [.140 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	G&H SPEC	-	-
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE TERMINAL	G&H TERMINAL
1949643-1	25223.123.009	1949643-4	25223.213.011
1949643-2	25223.123.011		
1949643-3	25223.212.179		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.25+/-0.05 [.089+/- .002]	5.4
0.5+1.5mm OR 1.0+1.0mm	2.15+/-0.05 [.085+/- .002]	6.5
1.50mm2	2.10+/-0.05 [.083+/- .002]	6.7



- 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.

***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.

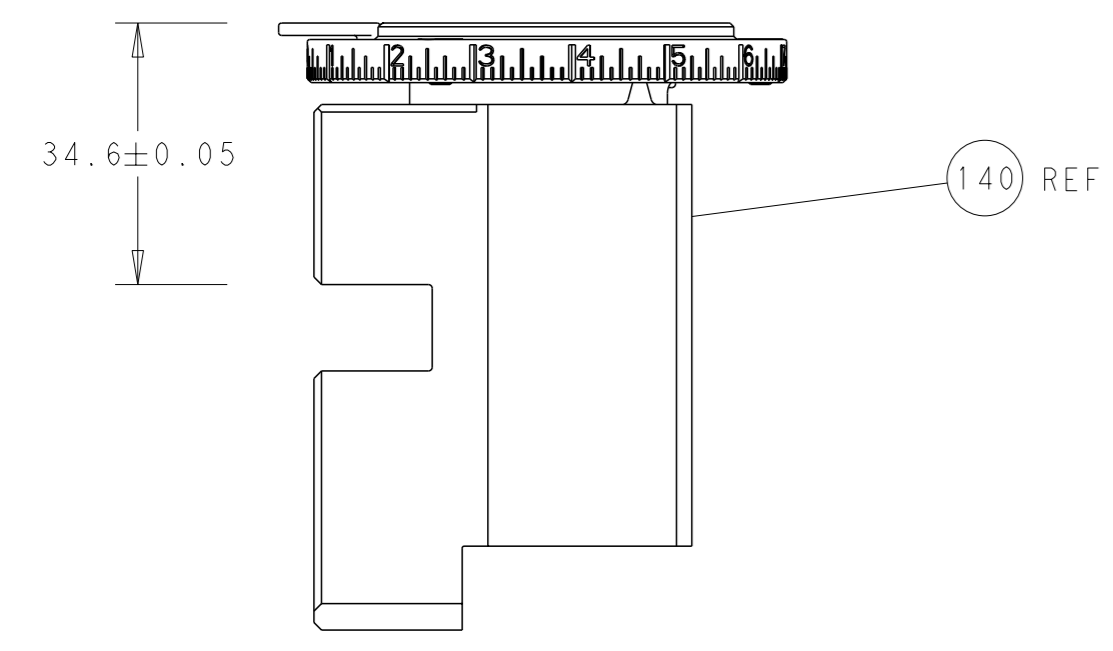
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	1-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	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
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2063961-1	FEED FINGER	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1-1752371-4	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	2-1901696-2	STRIP GUIDE, REAR	19
-	1	2-1901695-2	STRIP GUIDE, FRONT	18
-	1	1-240641-0	SPACER	16
-	1	1-240644-7	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-3	PLATE, FRONT SHEAR	9
-	1	5-1803000-7	ANVIL, COMBINATION, END FEED	8
-	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	6
-	1	7-240641-4	SPACER	5
-	1	3-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1803187-2	CRIMPER, INSULATION F	3
-	1	1-455888-7	SPACER, CRIMPER	2
-	1	7-1633664-1	CRIMPER, WIRE	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

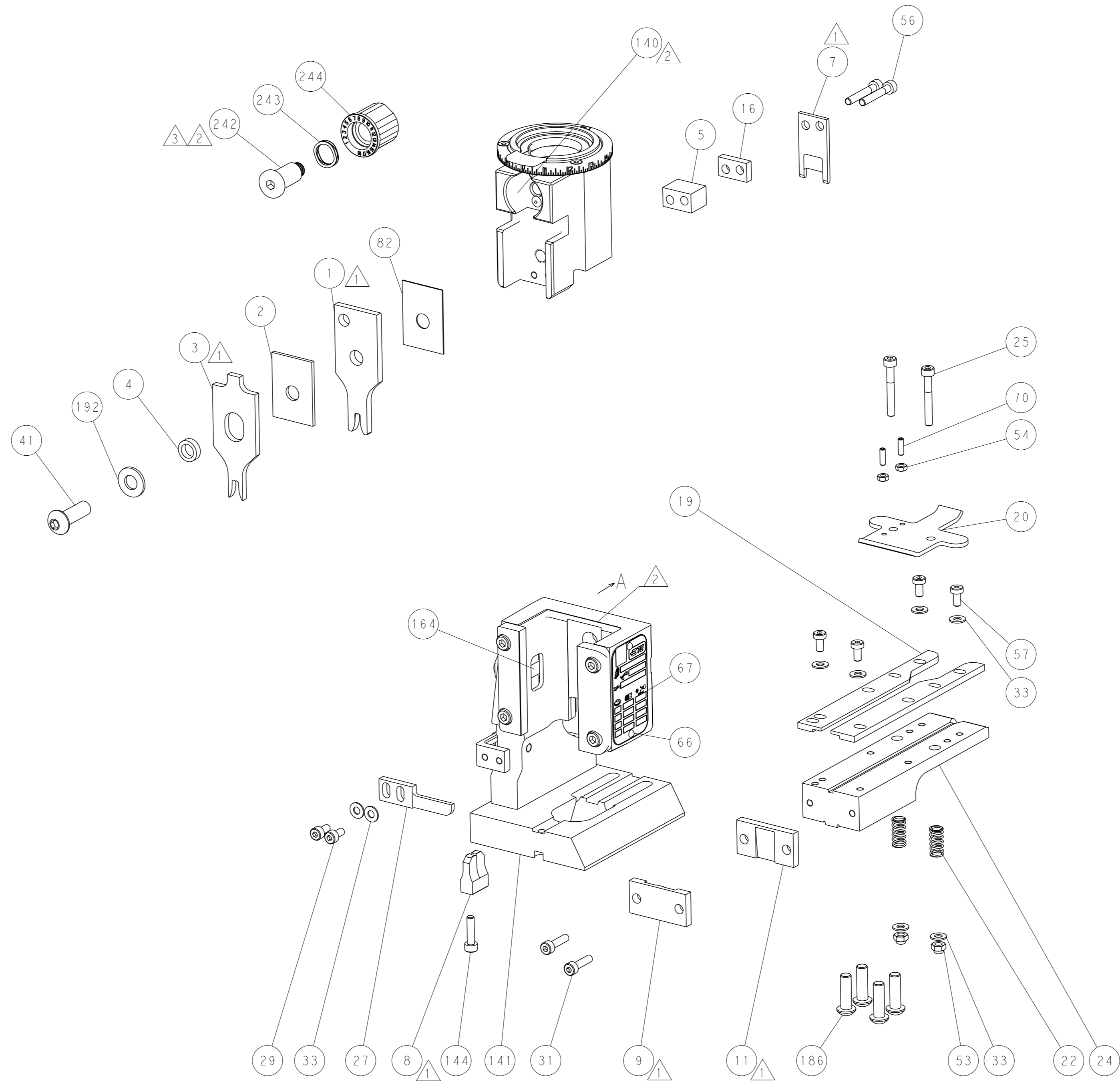
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN Y. YIN 23SEP2014	STE TE Connectivity Harrisburg, PA 17105-3608
0 PLC ±		1 PLC ±		CHK G. BAILEY 23SEP2014	
2 PLC ±		3 PLC ±		APVD U. GUO 23SEP2014	NAME Ocean End Feed Applicator
4 PLC ±		ANGLES FINISH		PRODUCT SPEC	
MATERIAL		WEIGHT		APPLICATION SPEC	SIZE CAGE CODE DRAWING NO RESTRICTED TO
				SCALE 1:1 SHEET 3 OF 4 REV B	00779 ©=2266479

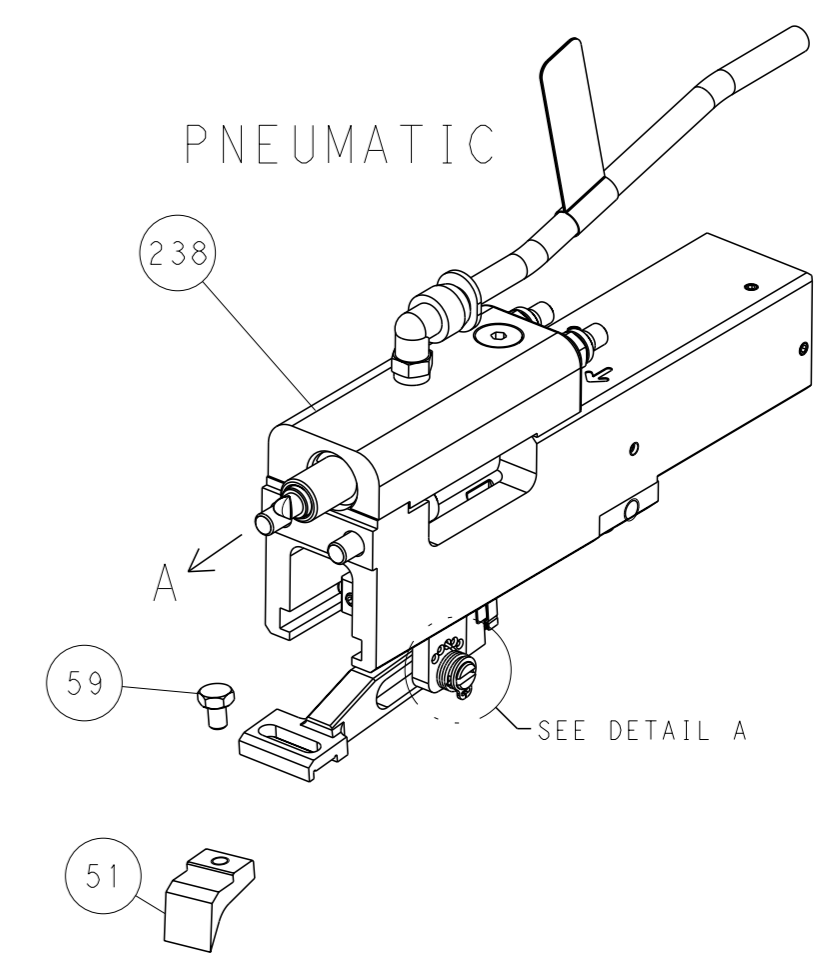
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-



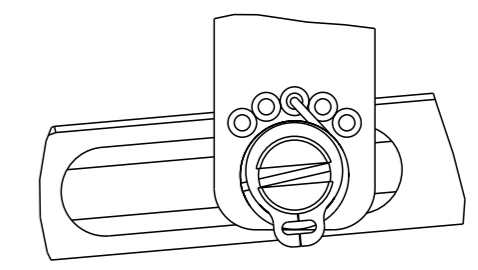
RAM SET-UP



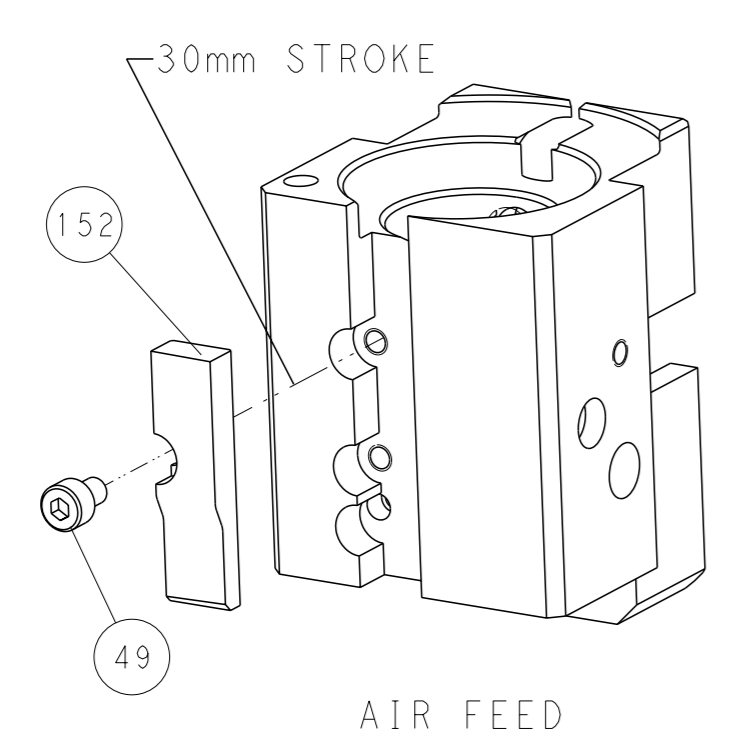
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITIONS



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 A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN Y. YIN 23SEP2014 CHK G. BAILEY 23SEP2014 APVD U. GUO 23SEP2014	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 End Feed Applicator PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266479 Customer Accessible Production Drawing SHEET 4 OF 4 REV B