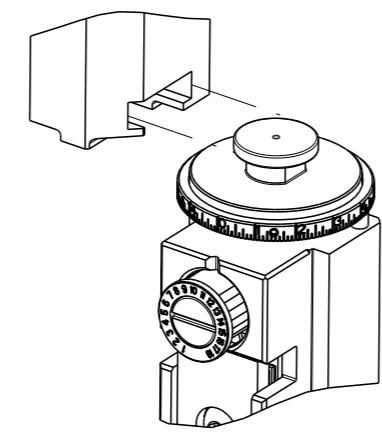


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2266682-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2266682-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266682-1 | B | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2266682-2 | B | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2266682-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|-----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.82 mm [.1111] | F |
| INSUL | 3.89 mm [.153] | F |

APPLICATOR INSTRUCTIONS
408-35042

| TERMINAL DATA: G&H(Lear) TERMINAL LEAR CRIMP SPECIFICATION | | | |
|--|--------------------|------------------------------|--------------------|
| TERMINAL NAME: DFK 4-FLACHKONTAKT 4.8X0.8-2.5 | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.14-4.90 mm [.163-.193 IN] | | Ø1.90-2.90 mm [.075-.114 IN] | |
| TERMINAL APPLICATION SPECIFICATION | LEAR 26526 Rev 8 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | G&H(Lear) TERMINAL | TE TERMINAL | G&H(Lear) TERMINAL |
| 1572630-1 | 26526.330.186 | 1572630-2 | 26526.XXX.XXX |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|------------------------|----------------------------|--------------------------------|
| 2.50mm2 | 1.85+/-0.05 [.073+/- .002] | 7.8 |
| 2.00mm2 | 1.70+/-0.05 [.067+/- .002] | 9.1 |
| 1.5mm2 OR 1.00+0.50mm2 | 1.65+/-0.05 [.065+/- .002] | 9.4 |

- 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.

***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)

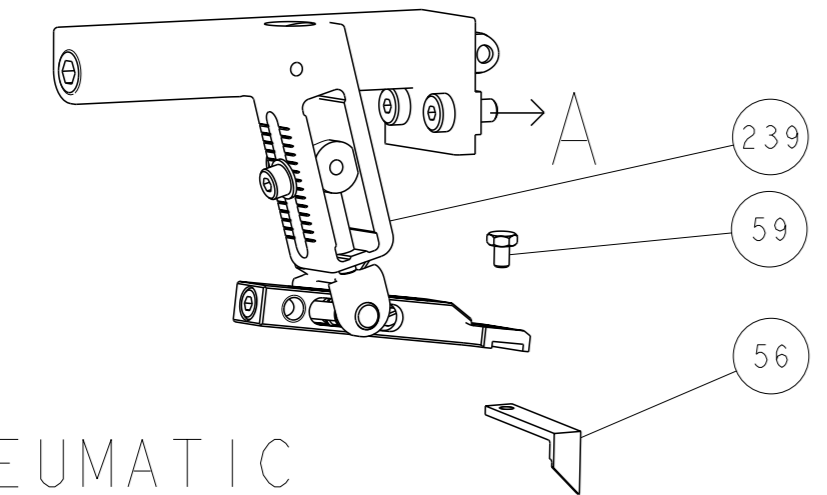
| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|----------------------|-----------|-----|------|
| | | # | LY# | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | 1 | | DEVELOPMENT | 12MAR2015 | JH | UG |
| | | 2 | | CHANGED WIRE CRIMPER | 17MAR2015 | JH | TE |
| | | A | | RELEASED | 15APR2015 | JH | TE |
| | | B | | ECR-21-001725 | 18FEB2021 | JWC | TE |

| | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 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 | 1 | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | 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 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 1 | 1 | 455888-6 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1803607-3 | 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 | 1338683-8 | FEED PAWL | 56 |
| - | 4 | 4 | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 |
| - | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 53 |
| - | 1 | 1 | 1 | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 |
| - | 1 | 1 | 1 | 1 | 811242-5 | BUMPER, HOLD DOWN | 51 |
| - | 1 | 1 | 1 | 1 | 690753-2 | SPACER, TONKER | 50 |
| - | 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 |
| - | 1 | 1 | 1 | 1 | 1-1752356-8 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2 | 2 | 3-2844962-2 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 2844992-2 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 28 |
| - | 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 |
| - | 2 | 2 | 2 | 2 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 1 | 1 | 2119533-1 | 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 | 454276-5 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 2 | 2 | 1 | 1-1803055-3 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 2119757-6 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1-238011-0 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 2 | 2 | 1 | 1-1803187-3 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 1 | 1 | 455888-7 | SPACER, CRIMPER | 2 |
| - | 1 | 2 | 2 | 1 | 1-1803188-1 | CRIMPER, WIRE | 1 |
| - | 77 | 72 | 71 | -2 | -1 | PART NO | ITEM NO |

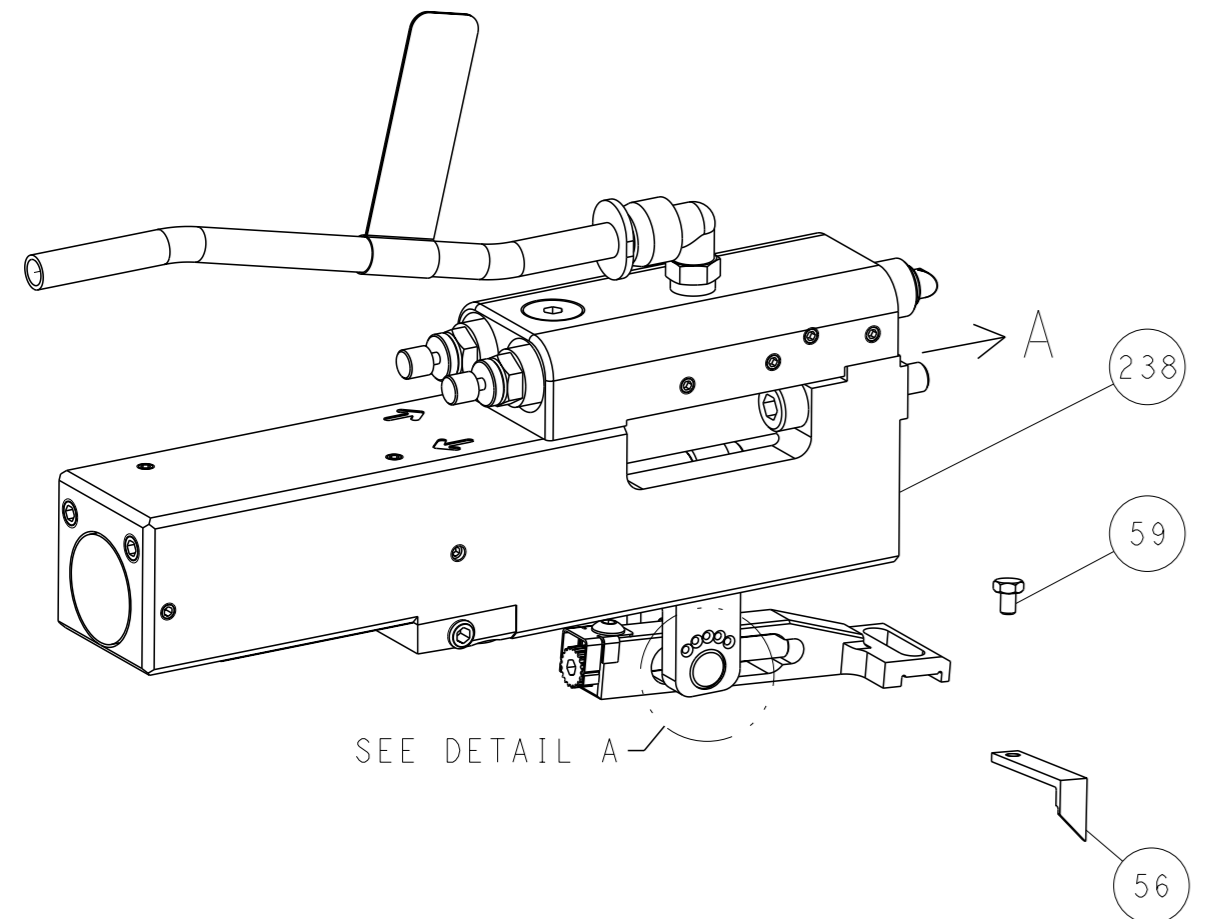
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|--|---------|--|---------|---------|---------|--------|----------|--------|--------|-----------|-----------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | J. HOU | L. ZHANG | J. GUO | U. GUO | 12MAR2015 | 12MAR2015 |
| | ANGLES | FINISH | | | | | | | | | |
| MATERIAL | | WEIGHT | | SCALE | | SHEET | | REV | | B | |
| Customer Accessible Production Drawing | | 00779 | | 1:2 | | 1 | | 4 | | REV | |

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

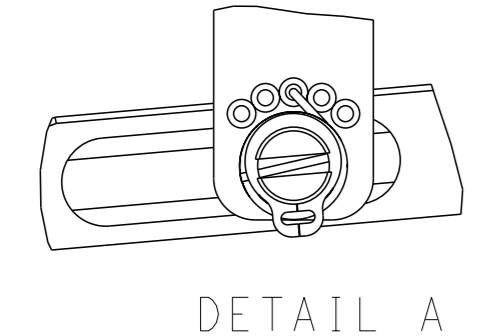
FEED TYPE MECHANICAL



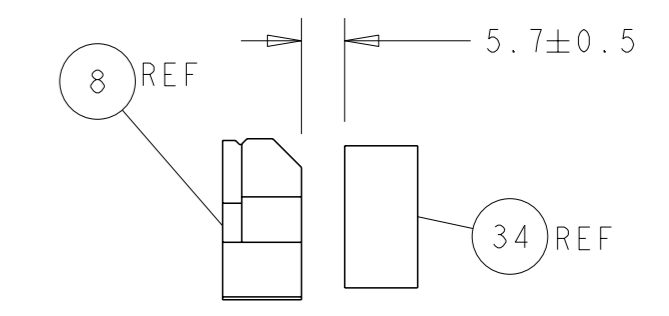
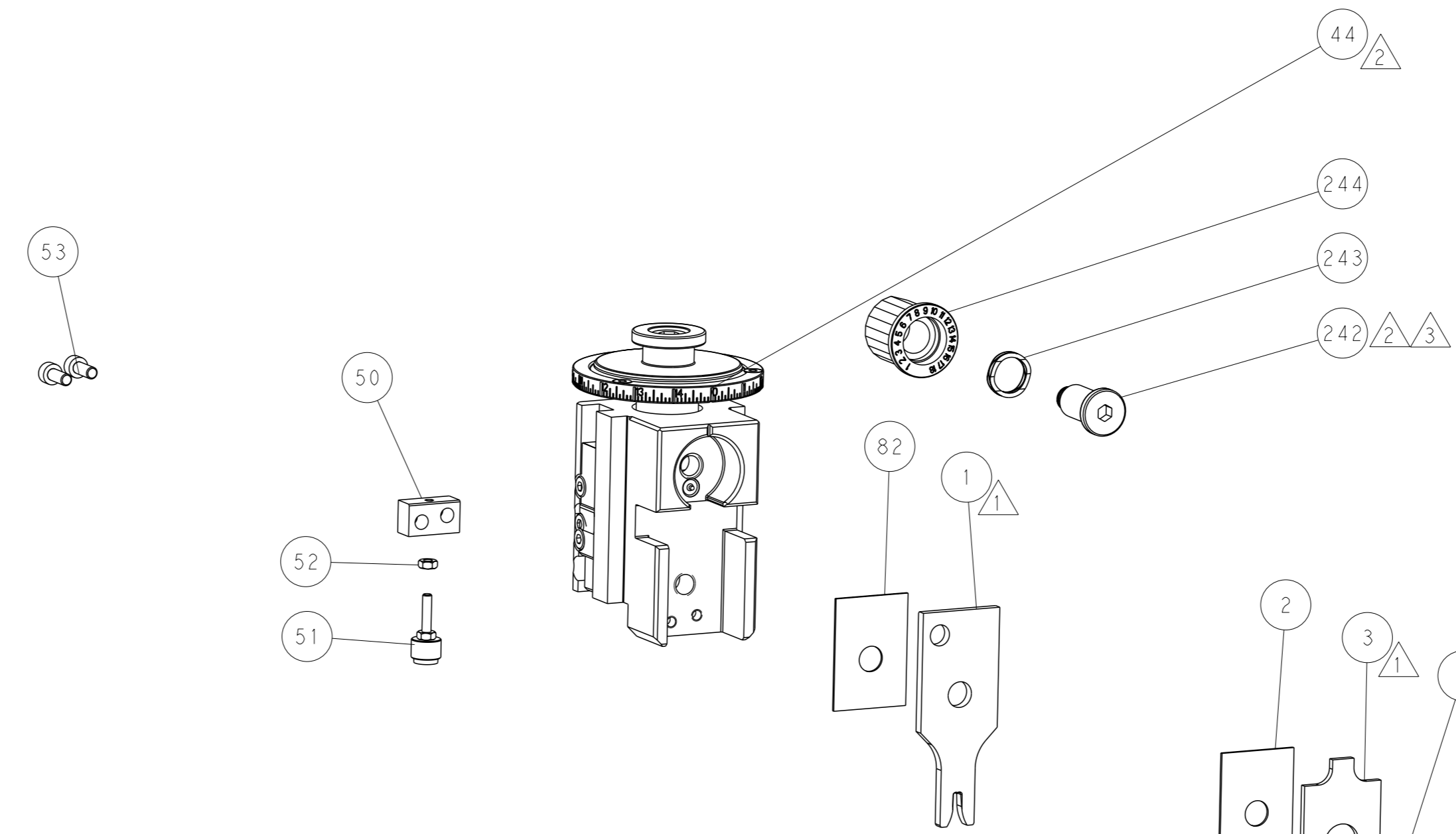
PNEUMATIC



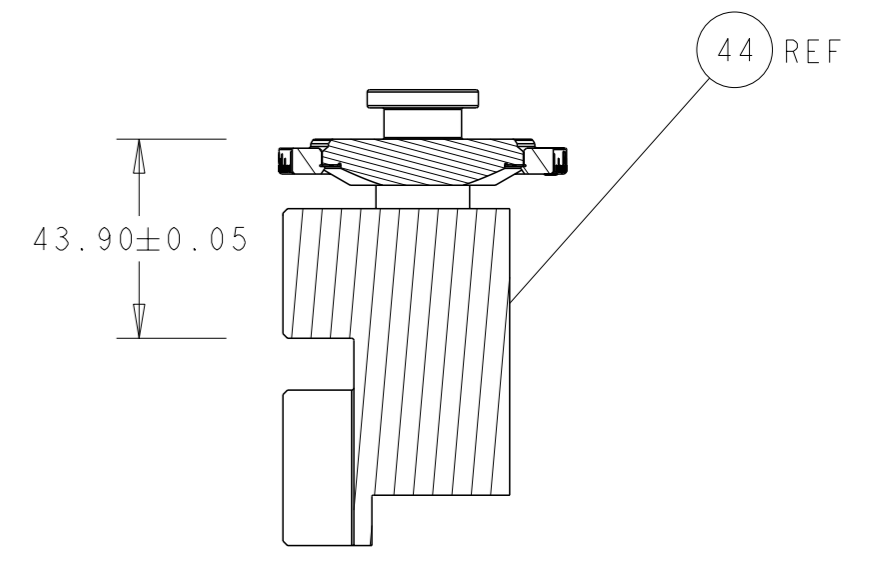
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



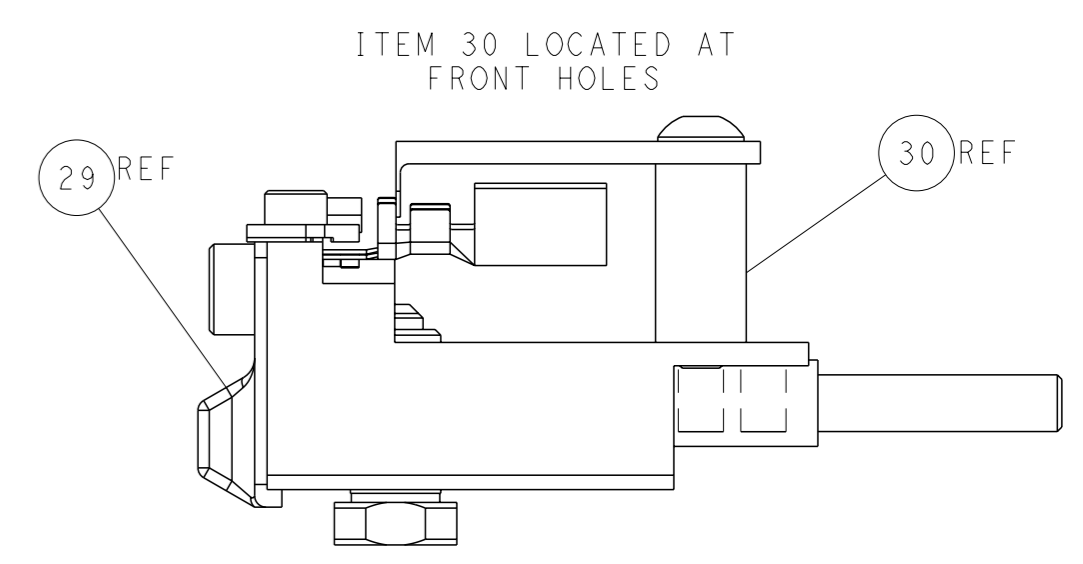
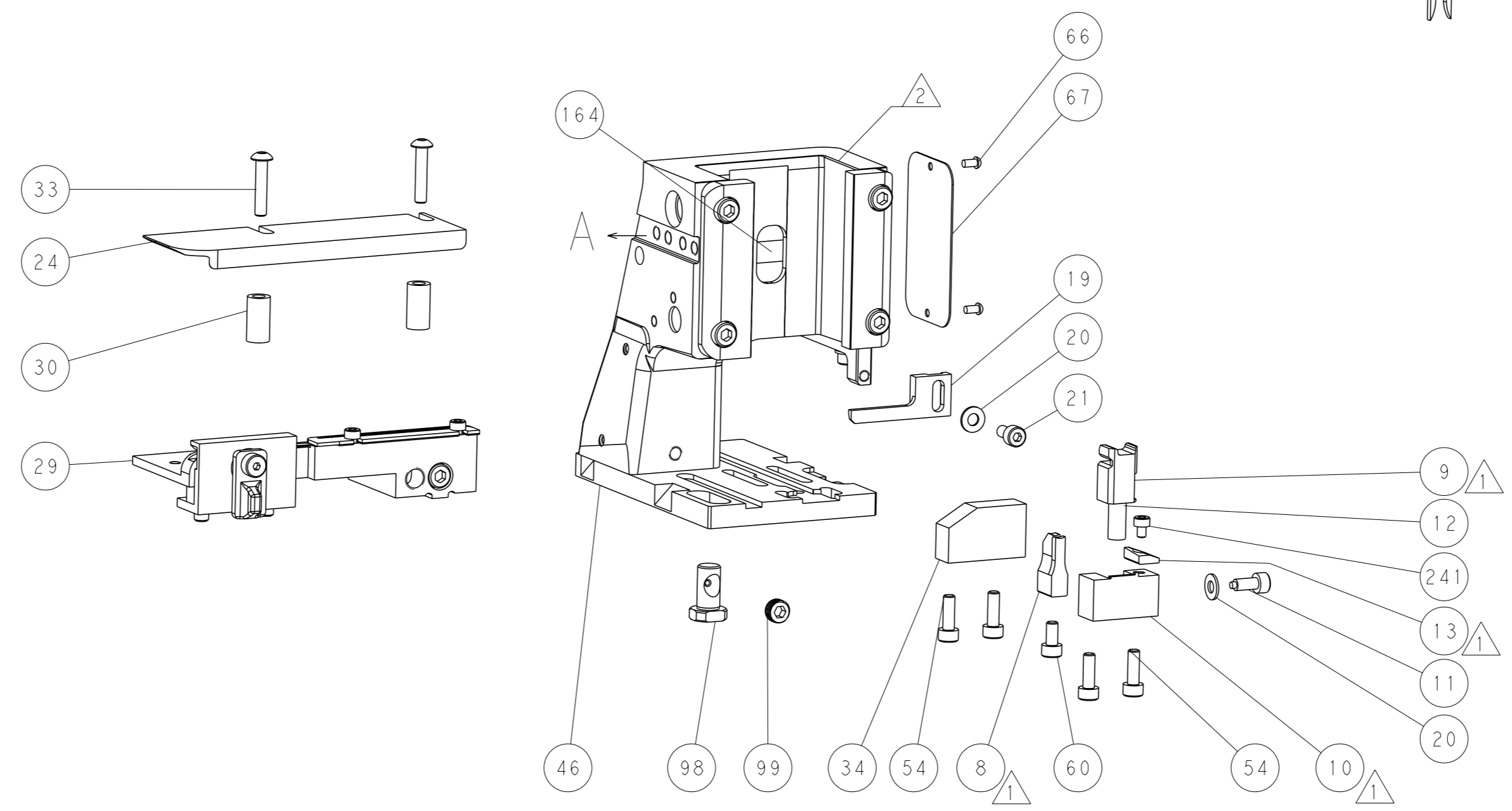
DETAIL A



TERMINAL SUPPORT LOCATION

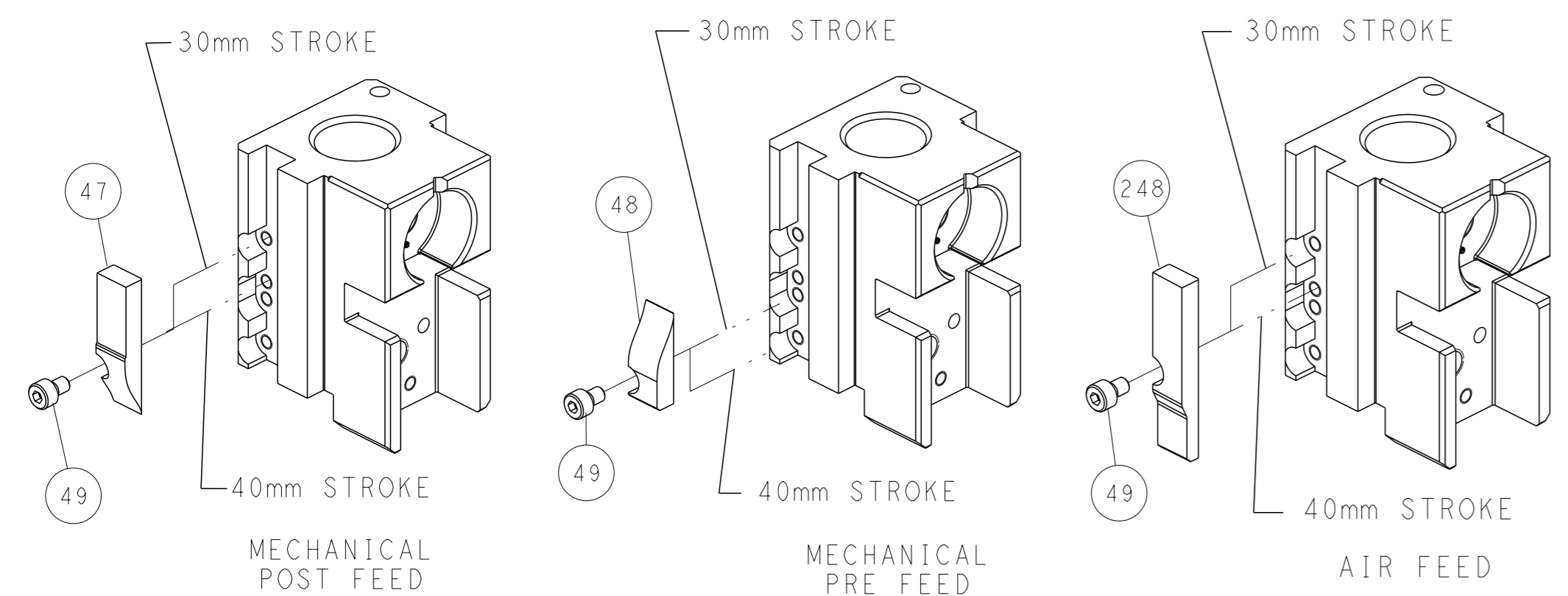


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

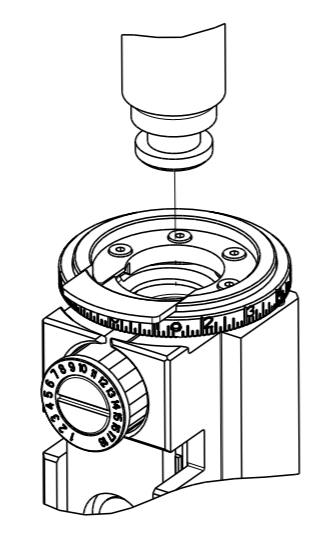


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | | | | |
|-----------------------|--|---|--|---|--|--|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | OWN J. HOU 12MAR2015 CHK L. ZHANG 12MAR2015 APVD H. GUO 12MAR2015 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL | | NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266682 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 of 4 REV B | |
|-----------------------|--|---|--|---|--|--|--|

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2266682-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2266682-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266682-7 | A | CRIMP TOOLING KIT | - |

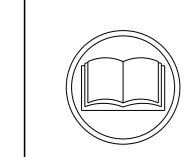
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.82 mm [.111] | F |
| INSUL | 3.89 mm [.153] | F |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| TERMINAL DATA: G&H(Lear) TERMINAL LEAR CRIMP SPECIFICATION | | | |
|--|------------------------------|-------------|--------------------|
| TERMINAL NAME: DFK 4-FLACHKONTAKT 4.8X0.8-2.5 | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 4.14-4.90 mm [.163-.193 IN] | Ø1.90-2.90 mm [.075-.114 IN] | | |
| TERMINAL APPLICATION SPECIFICATION LEAR 26526 Rev 8 | | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | G&H(Lear) TERMINAL | TE TERMINAL | G&H(Lear) TERMINAL |
| 1572630-1 | 26526.330.186 | 1572630-2 | 26526.XXX.XXX |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|------------------------|----------------------------|--------------------------------|
| 2.50mm2 | 1.85+/-0.05 [.073+/- .002] | 7.8 |
| 2.00mm2 | 1.70+/-0.05 [.067+/- .002] | 9.1 |
| 1.5mm2 OR 1.00+0.50mm2 | 1.65+/-0.05 [.065+/- .002] | 9.4 |



- 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.

***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.

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

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| | | # | LY# | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | - | - | SEE SHEET 1 | - | - | - |

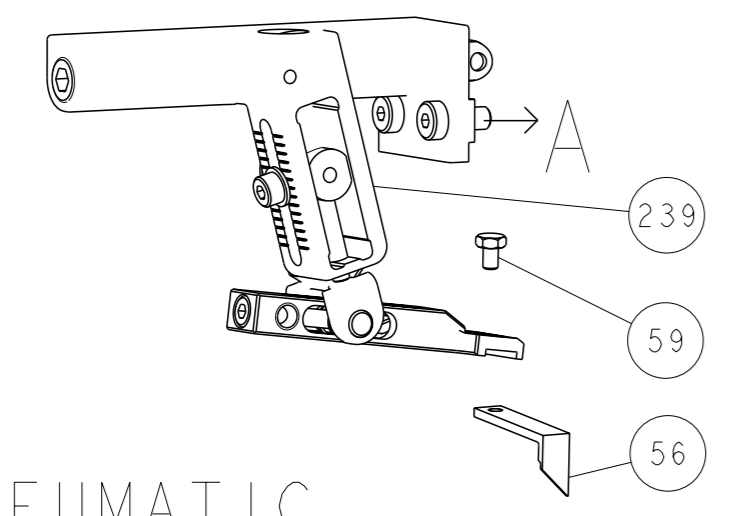
| | | | | | |
|---|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | 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 |
| - | 4 | 4 | 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 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 455888-6 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1803607-3 | 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 | 1338683-8 | FEED PAWL | 56 |
| - | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 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 | 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 |
| - | 1 | 1 | 1-1752356-8 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 3-2844962-2 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 2844992-2 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 455888-3 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1320928-2 | 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 | 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 | 454276-5 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 3-1803055-3 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119757-6 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1-238011-0 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1-1803187-3 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 455888-7 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1-1803188-1 | CRIMPER, WIRE | 1 |
| - | 77 | - | 22 | - | - |
| - | 22 | - | 21 | - | - |
| - | - | - | - | PART NO | ITEM NO |
| - | - | - | - | DESCRIPTION | |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | APPLICATOR DATA | |
|-------------|---------|--|---------|-----------------|---------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± |
| | ANGLES | FINISH | | | |
| MATERIAL | | | WEIGHT | SCALE | RESTRICTED TO |
| | | | | 1:2 | |

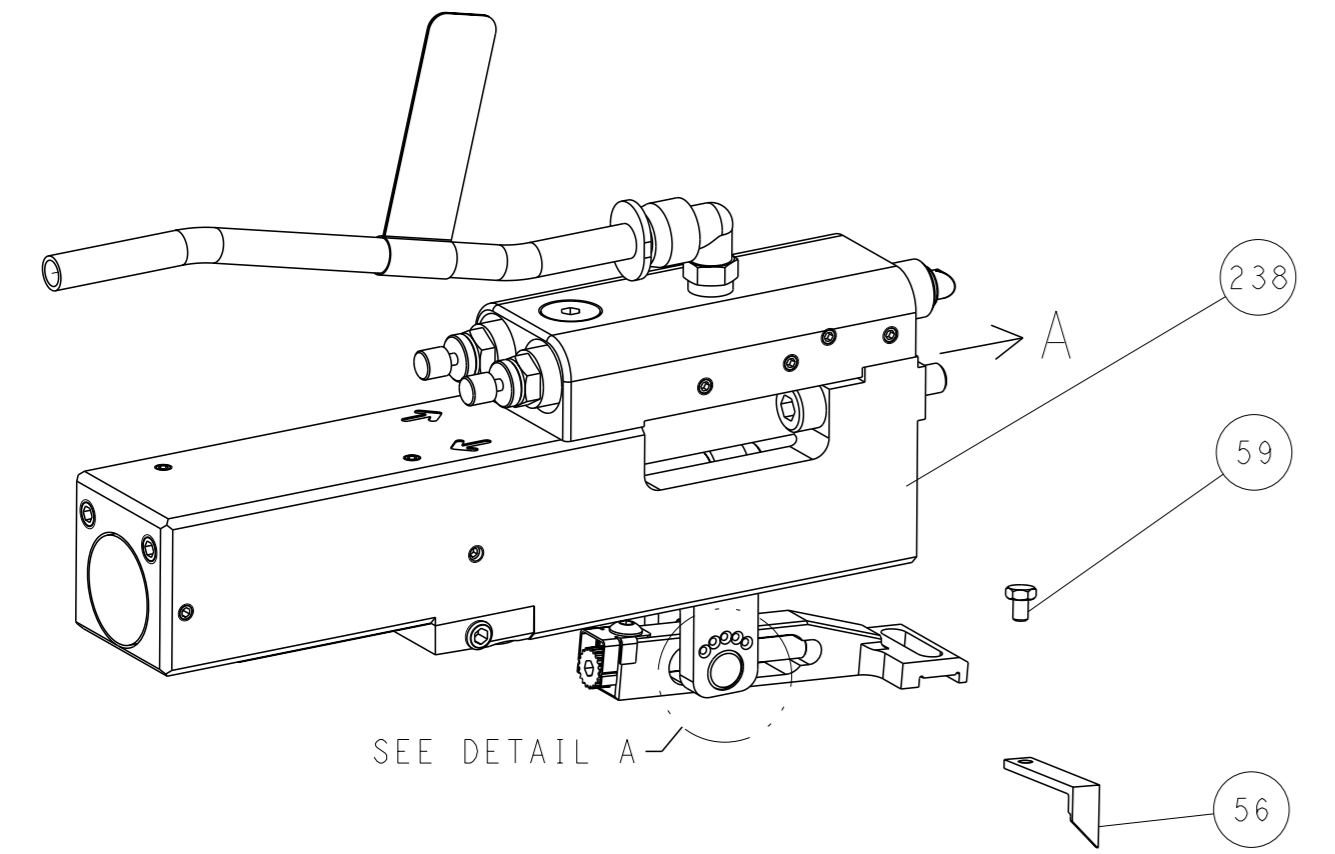
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| OWN | J. HOU | 12MAR2015 | TE Connectivity Harrisburg, PA 17105-3608 | | | |
| CHK | L. ZHANG | 12MAR2015 | | | | |
| APVD | J. GUO | 12MAR2015 | | | | |
| NAME | Ocean Side Feed Applicator | | | | | |
| PRODUCT SPEC | | | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| APPLICATION SPEC | | | A1 | 00779 | 2266682 | |
| Customer Accessible Production Drawing | | | SCALE | 1:2 | SHEET | 3 of 4 |
| | | | REV | B | | |

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

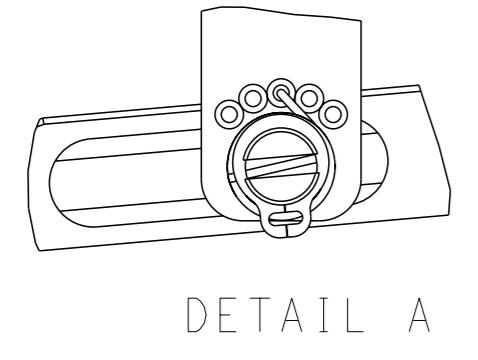
FEED TYPE MECHANICAL



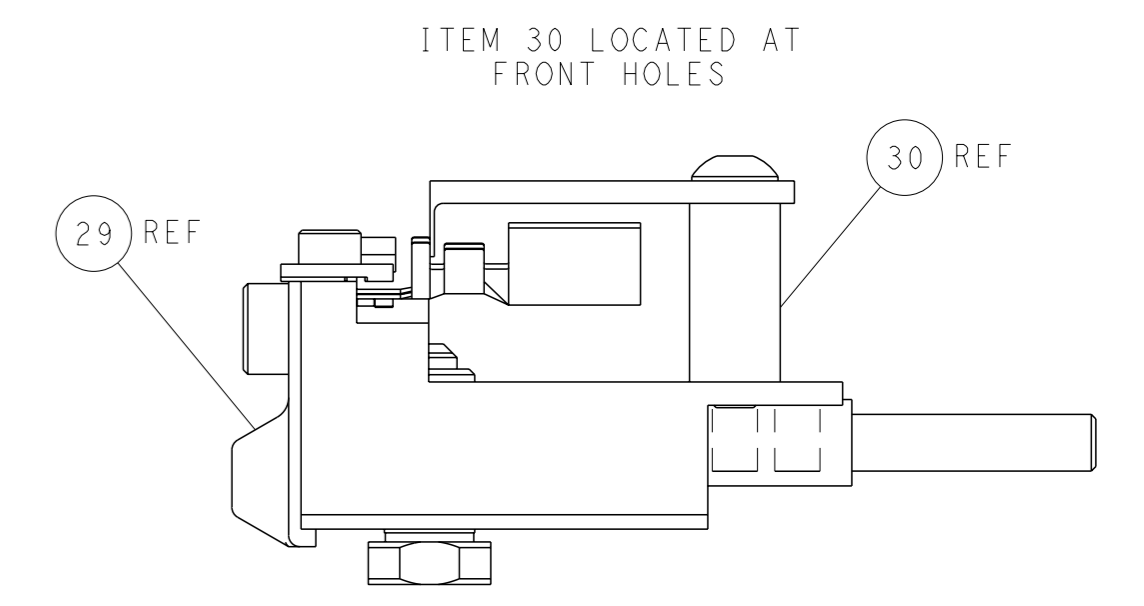
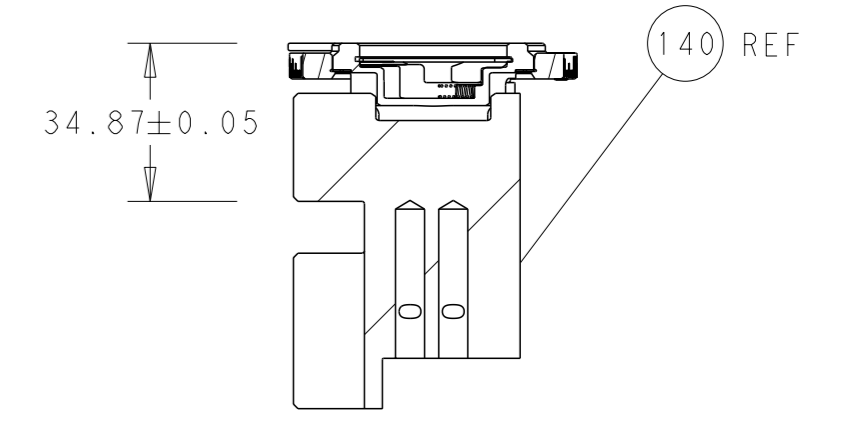
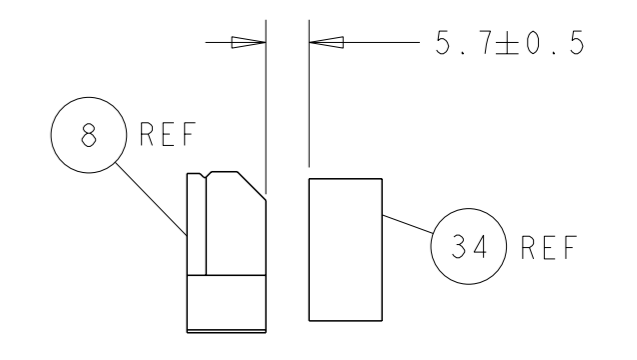
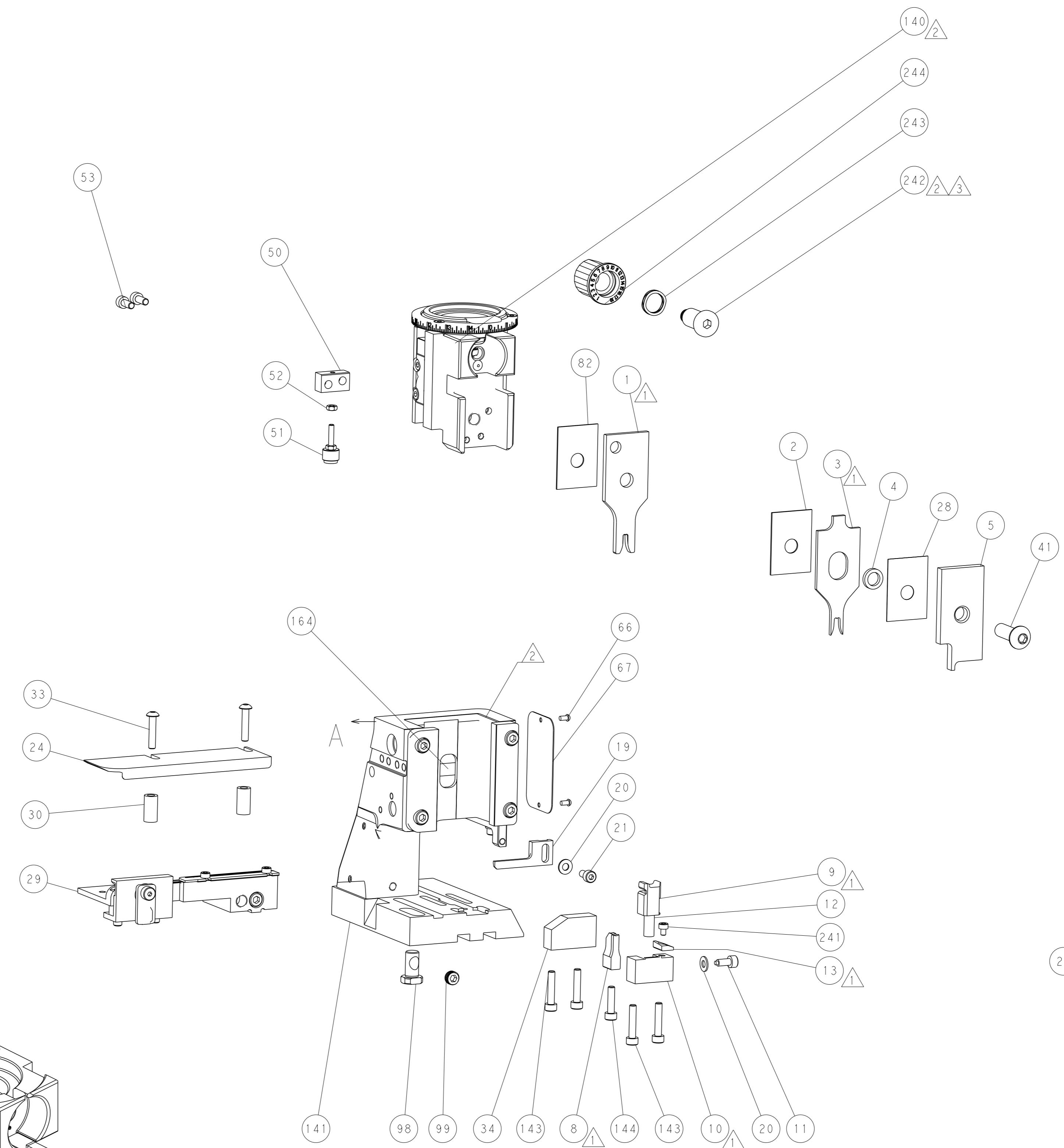
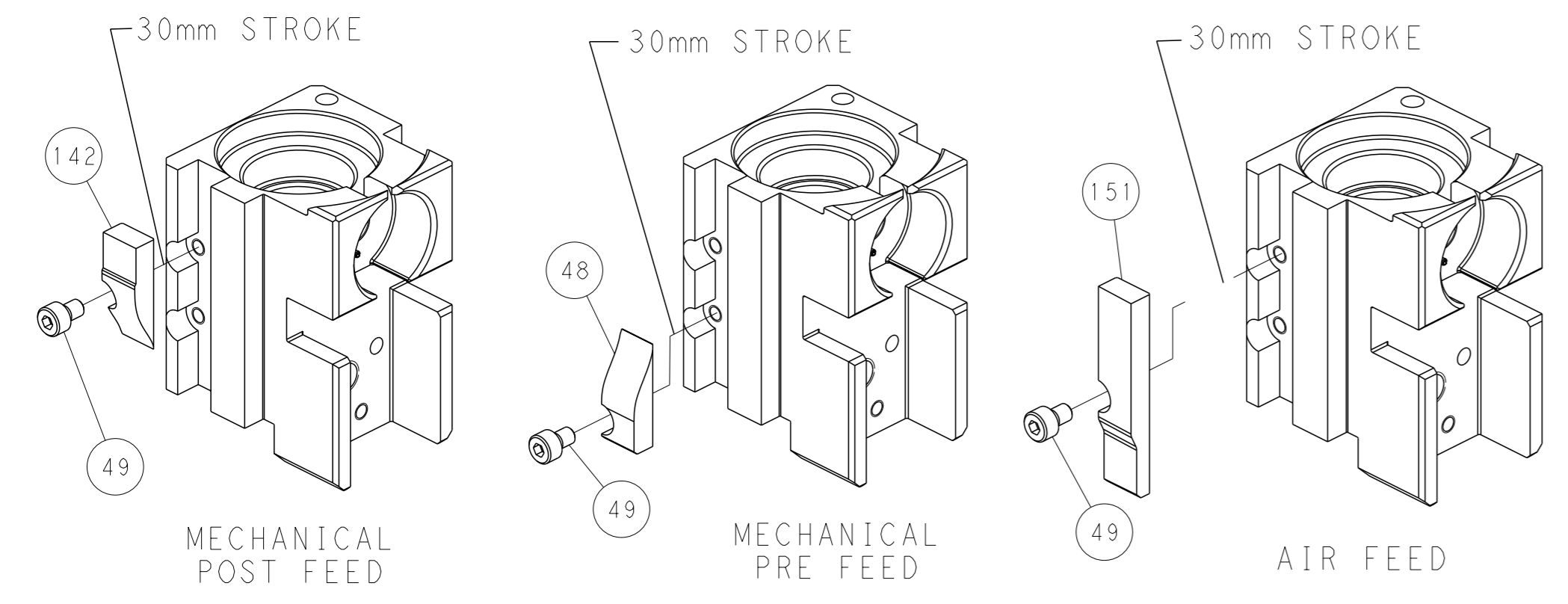
PNEUMATIC



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)

| | | | | |
|--|--------------------------|--|---|---|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: J. HOU 12MAR2015 CHK: L. ZHANG 12MAR2015 APVD: H. GUO 12MAR2015 | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266682 | RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: B |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | WEIGHT: - MATERIAL: - | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION | |