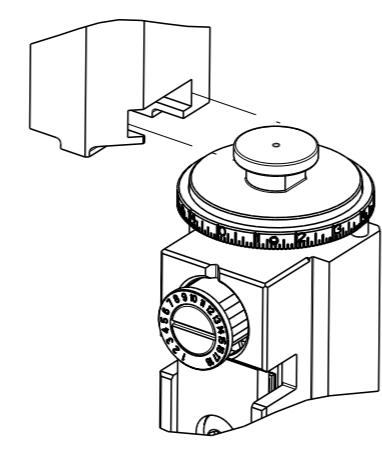


ATLANTIC VERSION TERMINATOR  
 INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266592-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266592-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266592-1	B	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266592-2	B	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266592-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266592-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266592-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.80 mm [.110]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: MLX CRIMP TERMINAL

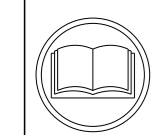
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.96-5.54 mm [.156-.218 IN]	Ø2.08-2.50 mm [.082-.098 IN]

TERMINAL APPLICATION SPECIFICATION  
 ATS-639007500 Rev D

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113626-1	02-08-2003	2113626-7	02-08-2004
2113626-2	02-08-2005	1949255-1	02-08-1001
2113626-3	02-08-2007	1949255-2	02-08-1005
2113626-4	02-08-2009	1949255-3	02-08-1003
2113626-5	02-08-2011	1949255-4	02-08-1007
2113626-6	02-08-2012		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm <sup>2</sup>	1.75+/-0.05 [.069+/-0.002]	3.8
16 AWG OR 1.30mm <sup>2</sup>	1.50+/-0.05 [.059+/-0.002]	6.9
18 AWG OR 0.80mm <sup>2</sup>	1.32+/-0.05 [.052+/-0.002]	9.0
20 AWG OR 0.50mm <sup>2</sup>	1.19+/-0.05 [.047+/-0.002]	10.3



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.

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

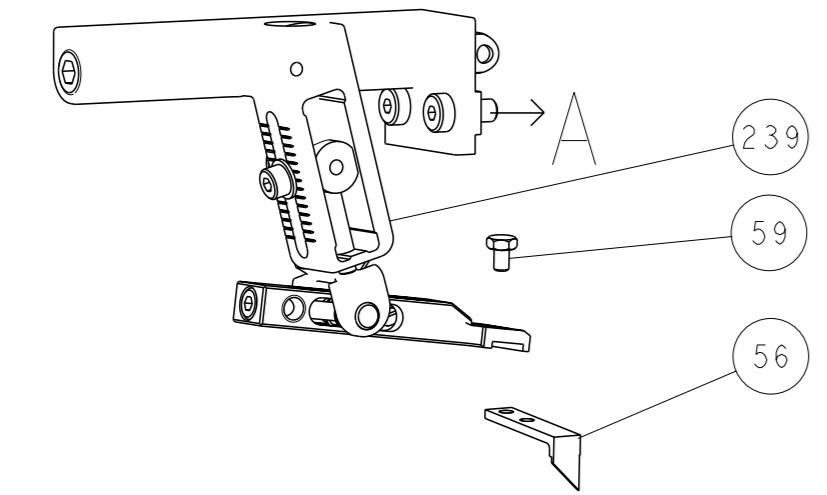
LOC	DIST	REV	DATE	BY	CHK
A	66				

REV	DATE	BY	CHK	DESCRIPTION	ITEM NO	
-	-	-	1 1 - -	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1 1 - -	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1 - 1 -	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1 - 1 -	1803259-1	BUSHING, FLANGED	249
-	1	-	1 - 1 -	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1 1 1 1 1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1 1 1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1 1 1 1 1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	- 1 - 1 -	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	- 1 - 1 -	2063440-1	AIR FEED MODULE	238
-	-	-	1 1 - -	4-1722335-3	STRIPPER, SIDE FEED	182
3	-	-	- 1 1 - -	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	- 1 1 - -	2-1752354-1	STANDOFF, HOLD-DOWN	180
-	-	-	- 1 1 - -	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	- 1 1 - -	5-22280-0	SPRING, COMPRESSION	176
-	-	-	- 1 1 - -	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	- 1 1 - -	1901680-2	GUIDE PIN, HOLDDOWN	174
-	2	-	2 - 2 -	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF REF REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1 - 1 -	240638-1	SPRING, FEED FINGER	163
-	1	-	1 - 1 -	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	1 1 1 1 1	2844908-1	SCREW, LOCKING	99
-	1	1	1 1 1 1 1	2844907-1	POST, LOCKING	98
-	1	1	1 1 1 1 1	455888-5	SPACER, CRIMPER	82
-	1	1	1 1 1 1 1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1 1 1 1 1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1 1 1 1 1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2 2 2 2 2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1 1 1 1 1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1 1 1 1 1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1 1 1 1 1	1338685-1	PAWL, FEED	56
-	4	4	4 4 4 4 4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2 2 2 2 2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1 1 1 1 1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1 1 1 1 1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1 1 1 1 1	690753-2	SPACER, TONKER	50
-	1	2	1 2 1 2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	- 1 - 1 -	2119652-1	FEED CAM, PRE FEED	48
-	-	1	- 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 1 1 1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1 1 1 1 1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2 2 2 2 2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2 2 2 2 2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1 1 1 1 1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1 1 1 1 1	455888-3	SPACER, CRIMPER	28
-	1	1	1 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	1 1 2 2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	- - 1 1	2119533-1	STRIPPER, SIDE FEED	19
1	1	1	1 1 1 1 1	2119806-1	INSERT, SHEAR	13
1	1	1	1 1 1 1 1	3-22280-3	SPRING, COMPRESSION	12
1	1	1	1 1 1 1 1	1-356885-4	STOP, SHEAR	11
1	1	1	1 1 1 1 1	2119805-1	SHEAR HOLDER, FRONT	10
1	1	1	1 1 1 1 1	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1 1 1 1 1	1-1633921-7	ANVIL, COMBINATION	8
-	-	-	- - - -	-	-	7
-	-	-	- - - -	-	-	6
-	1	1	1 1 1 1 1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1 1 1 1 1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1 1 1 1 1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	- - - -	-	-	2
1	2	2	1 1 1 1 1	2-456406-3	CRIMPER, WIRE PREMIUM	1

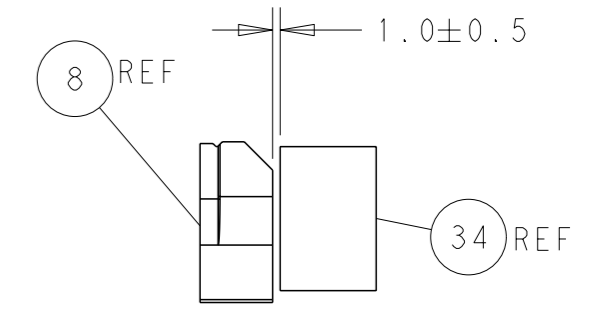
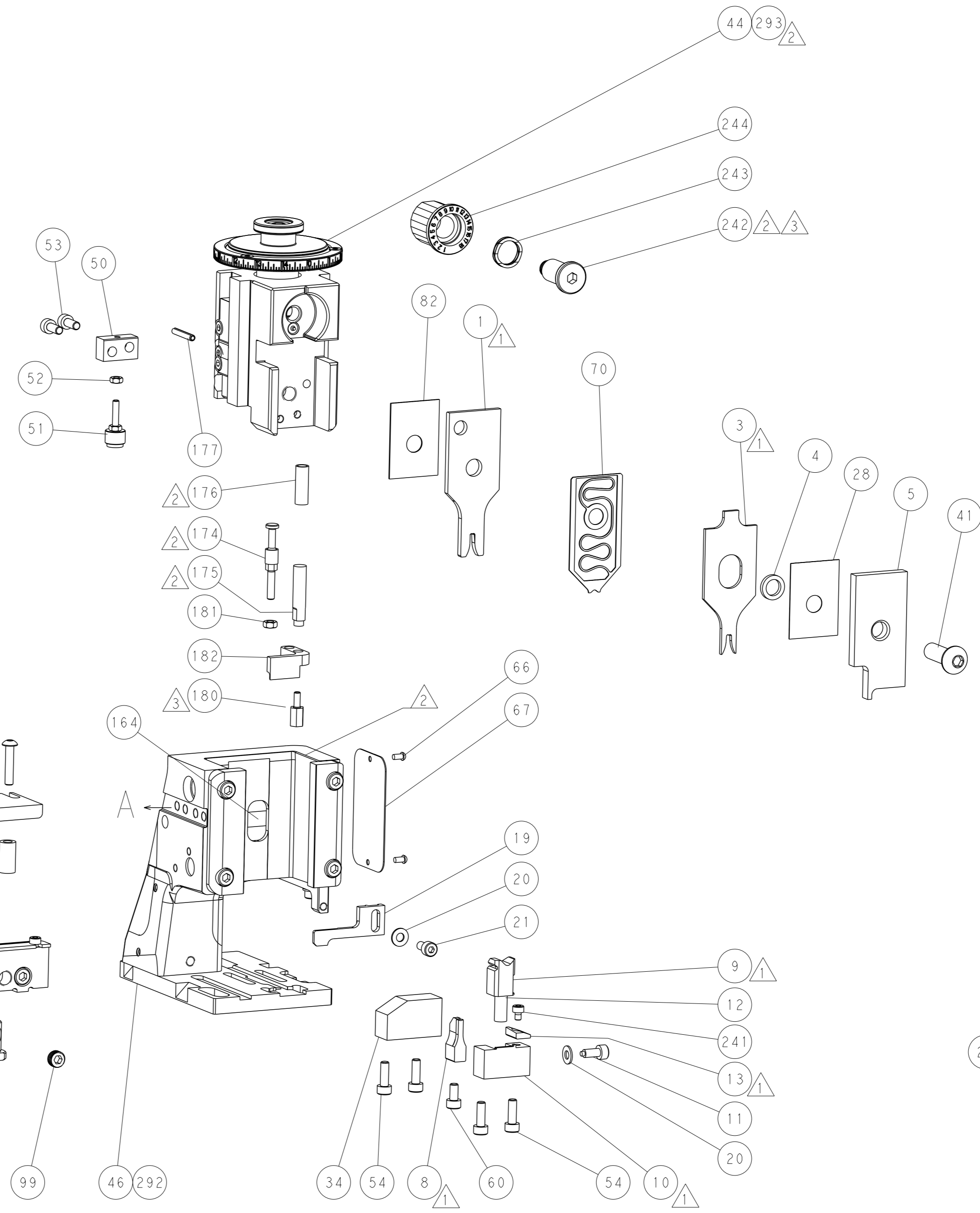
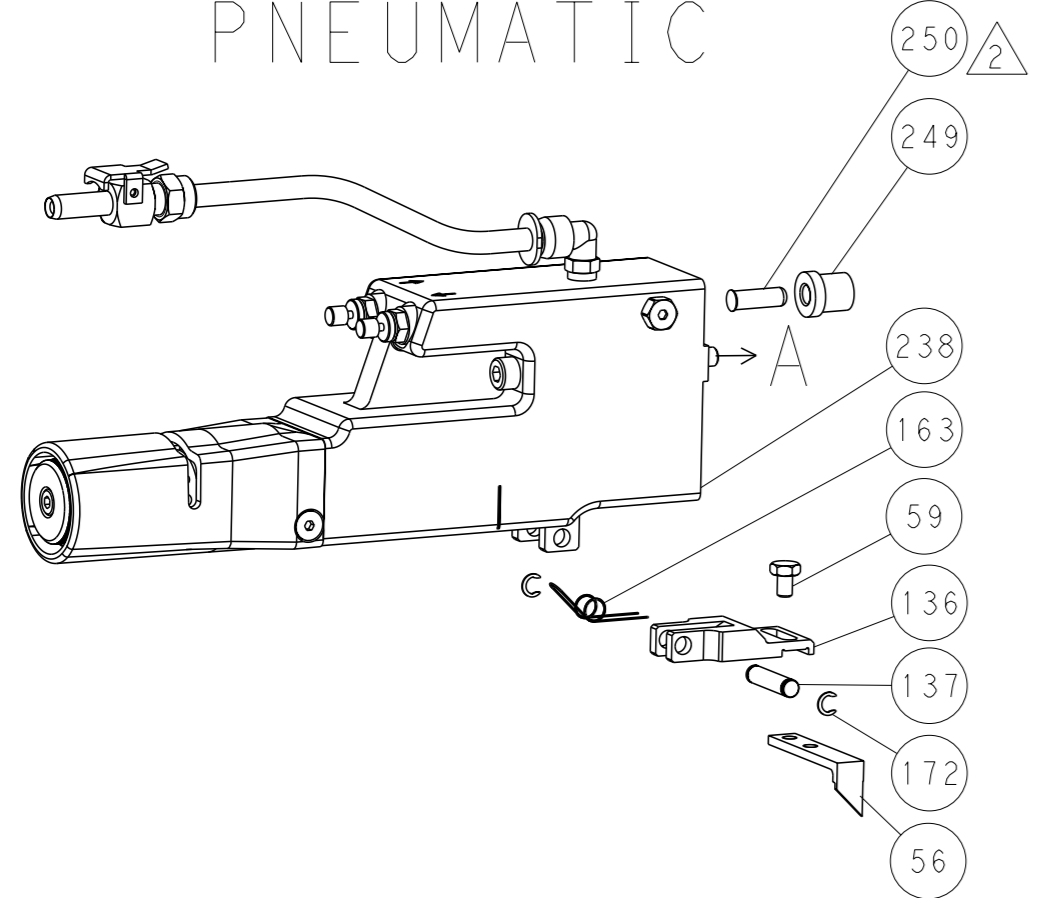
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	CHK	APVD	DATE	DESCRIPTION	ITEM NO
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	H. HUANG	L. ZHANG	U. GUO	01DEC2014	TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		NAME:		SIZE		CAGE CODE	DRAWING NO
		Ocean Side Feed Applicator		A1		00779	2266592
		Customer Accessible Production Drawing		SCALE		SHEET	REV
				1:2		1	B

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

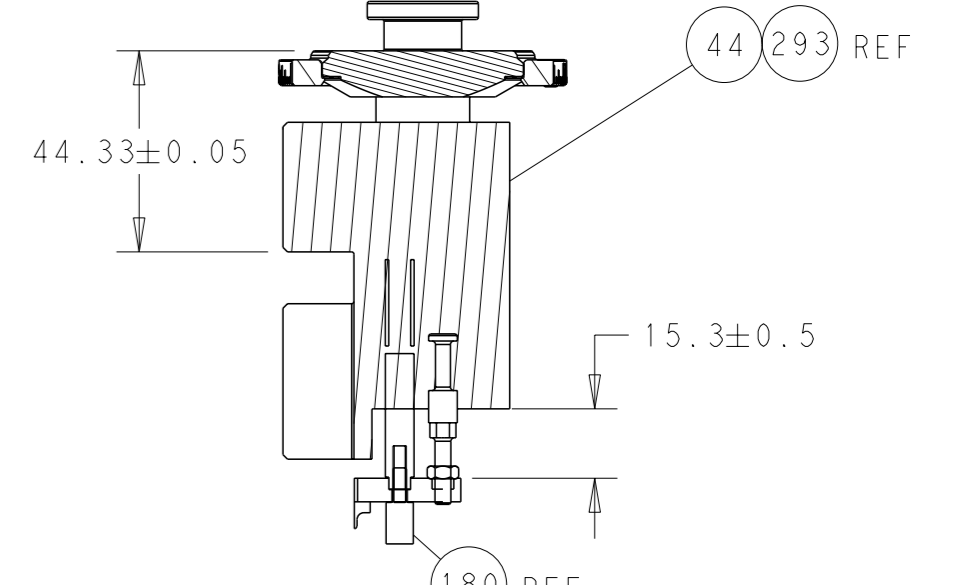
# FEED TYPE MECHANICAL



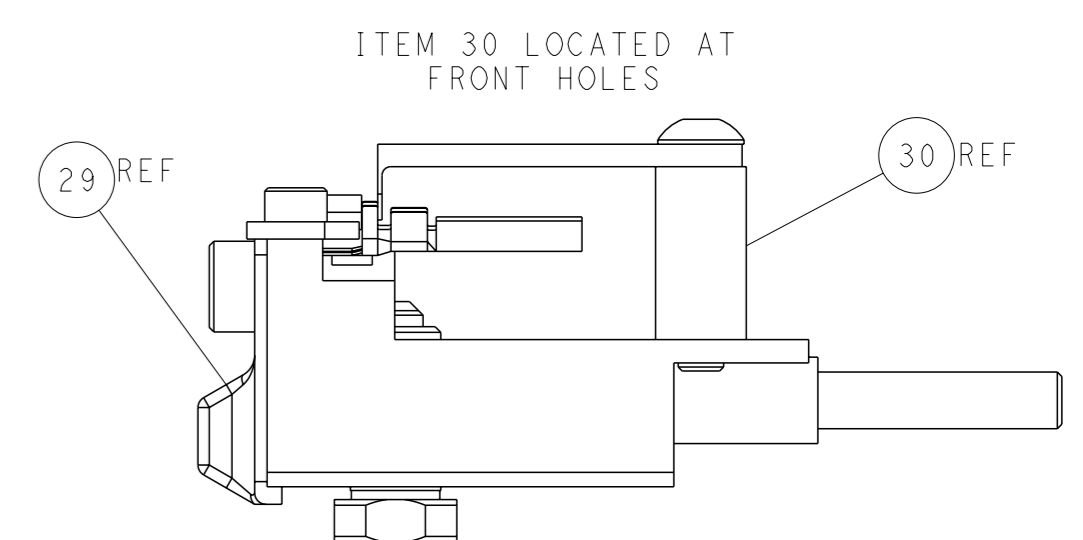
# PNEUMATIC



TERMINAL SUPPORT LOCATION

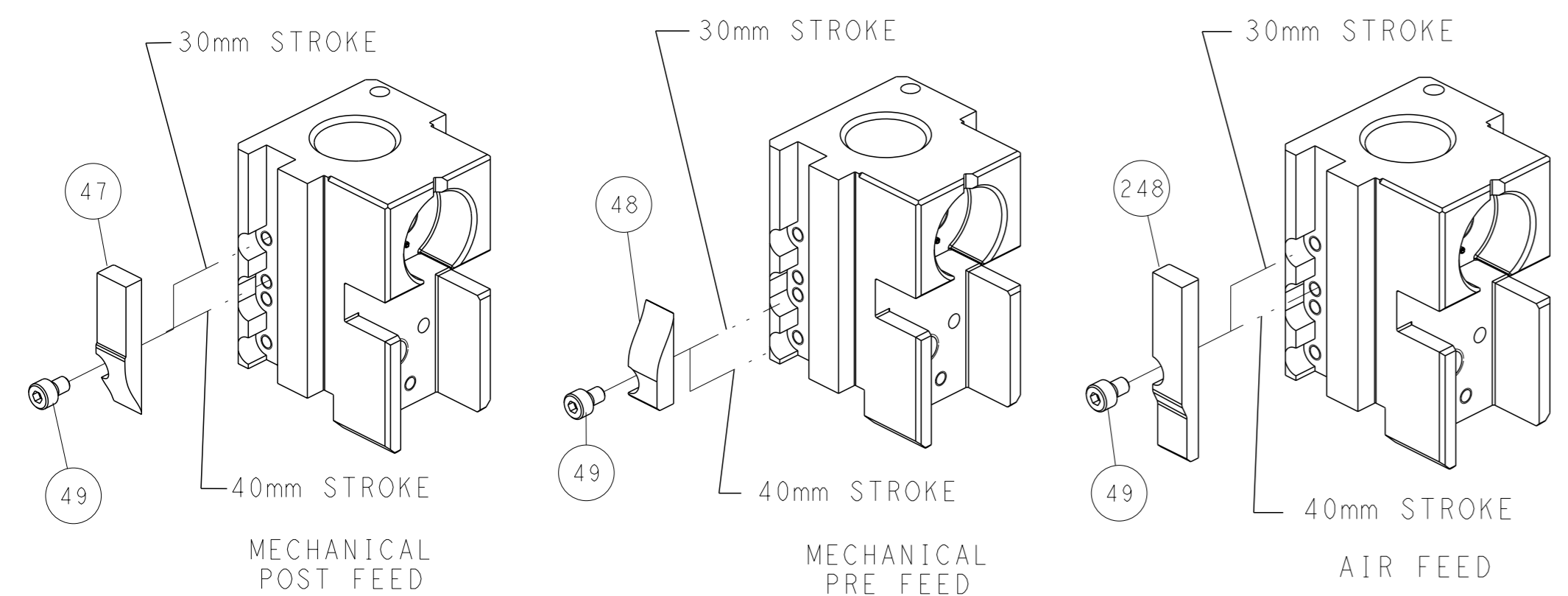


RAM & HOLD DOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

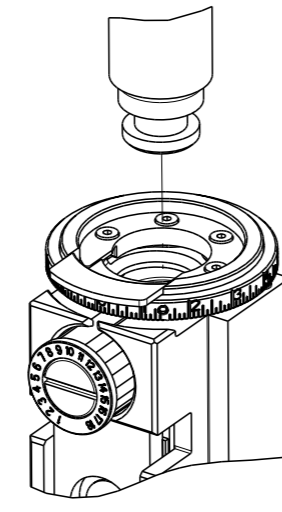


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: H. HUANG 01DEC2014 CHK: L. ZHANG 01DEC2014 APVD: J. GUO 01DEC2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266592	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	MATERIAL:	WEIGHT:	RESTRICTED TO:	SCALE: 1:2 SHEET 2 of 4 REV B

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266592-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266592-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266592-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.80 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: MLX CRIMP TERMINAL	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.96-5.54 mm [.156-.218 IN]	∅2.08-2.50 mm [.082-.098 IN]
TERMINAL APPLICATION SPECIFICATION ATS-639007500 Rev D	

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113626-1	02-08-2003	2113626-7	02-08-2004
2113626-2	02-08-2005	1949255-1	02-08-1001
2113626-3	02-08-2007	1949255-2	02-08-1005
2113626-4	02-08-2009	1949255-3	02-08-1003
2113626-5	02-08-2011	1949255-4	02-08-1007
2113626-6	02-08-2012		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.75+/-0.05 [.069+/-0.002]	3.8
16 AWG OR 1.30mm2	1.50+/-0.05 [.059+/-0.002]	6.9
18 AWG OR 0.80mm2	1.32+/-0.05 [.052+/-0.002]	9.0
20 AWG OR 0.50mm2	1.19+/-0.05 [.047+/-0.002]	10.3

- 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)

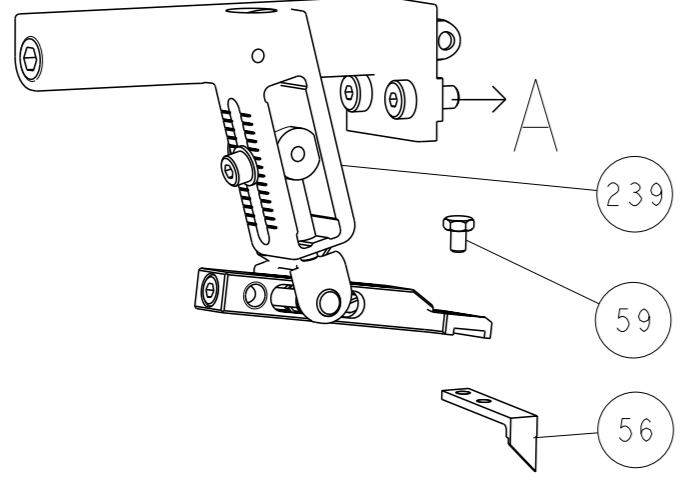
LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	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	-	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
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	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	2119791-9	DEPRESSOR, WIRE	70
-	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
-	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1-1633921-7	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
-	1	1	2-456406-3	CRIMPER, WIRE PREMIUM	1

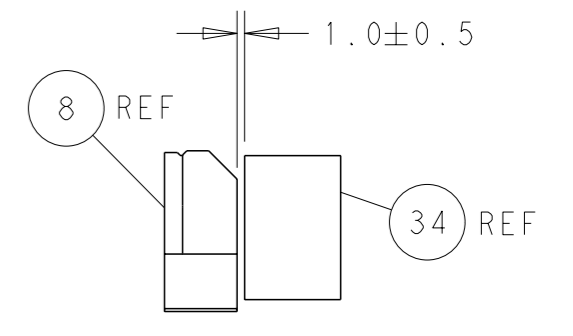
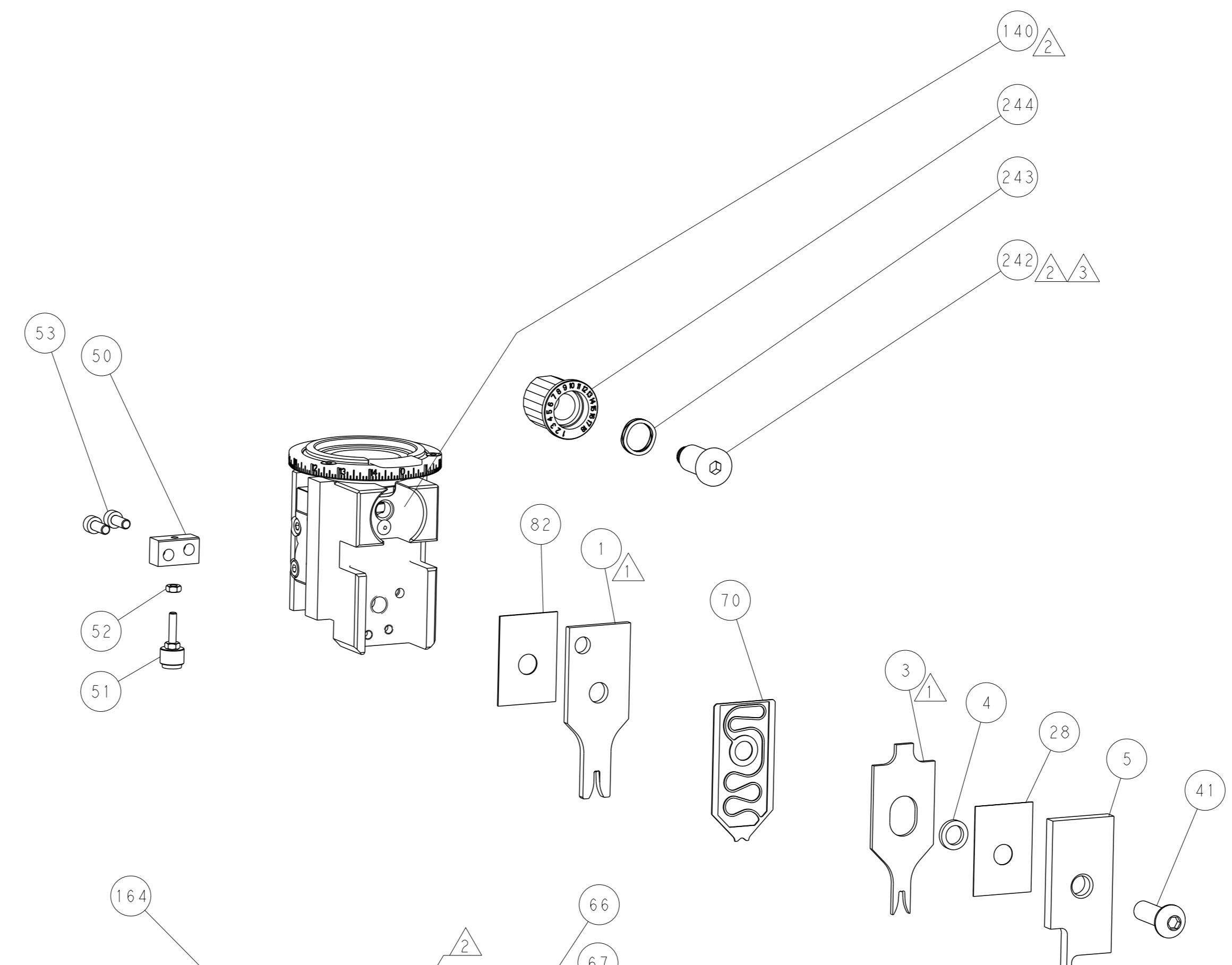
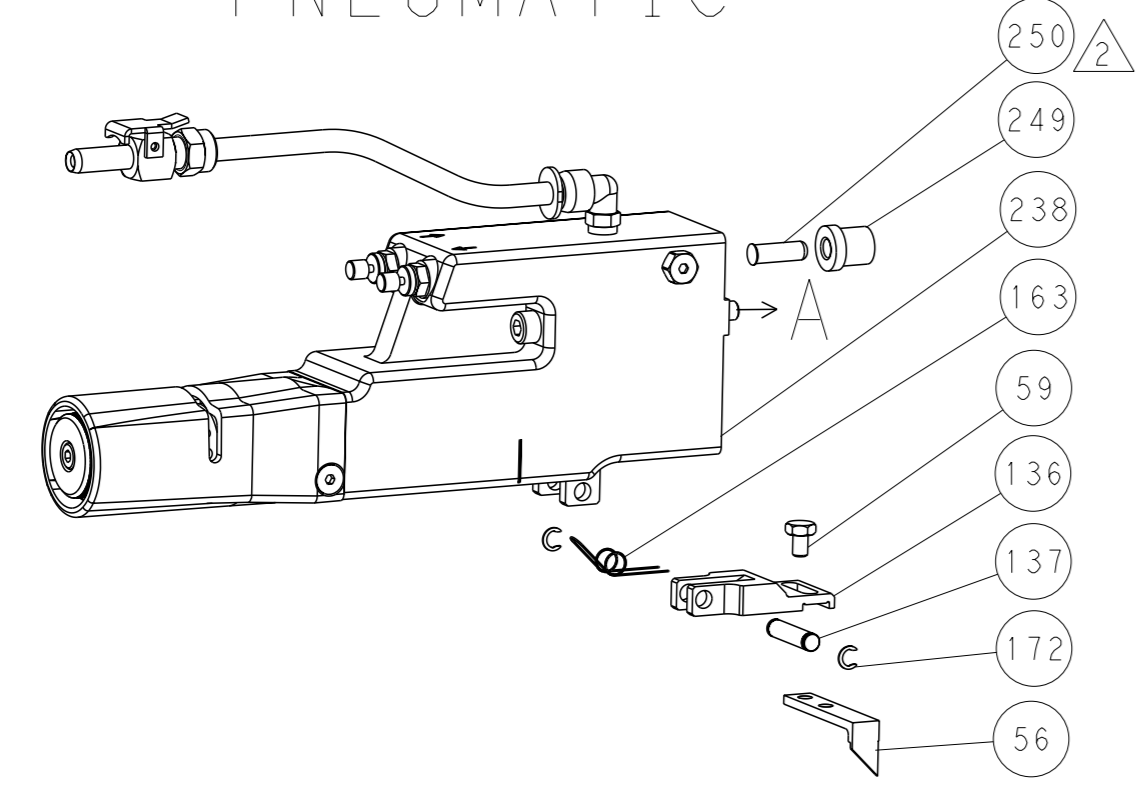
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
ANGLES	FINISH				
MATERIAL	FINISH				
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
A1	00779	2266592			
Customer Accessible Production Drawing			SCALE	SHEET	REV
			1:2	3 of 4	B

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

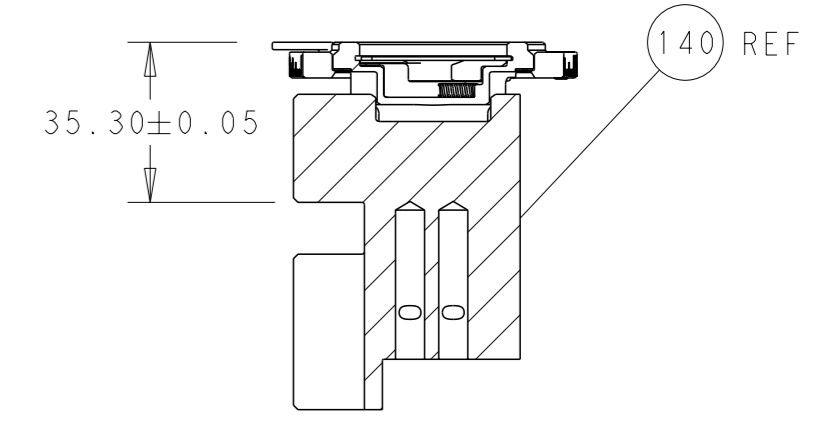
# FEED TYPE MECHANICAL



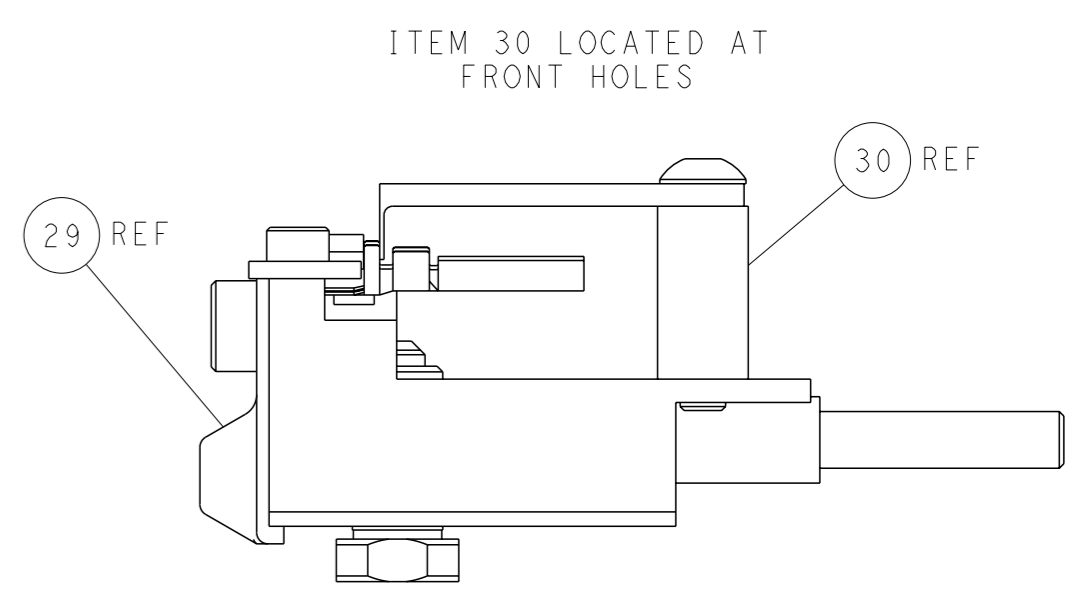
# PNEUMATIC



TERMINAL SUPPORT LOCATION

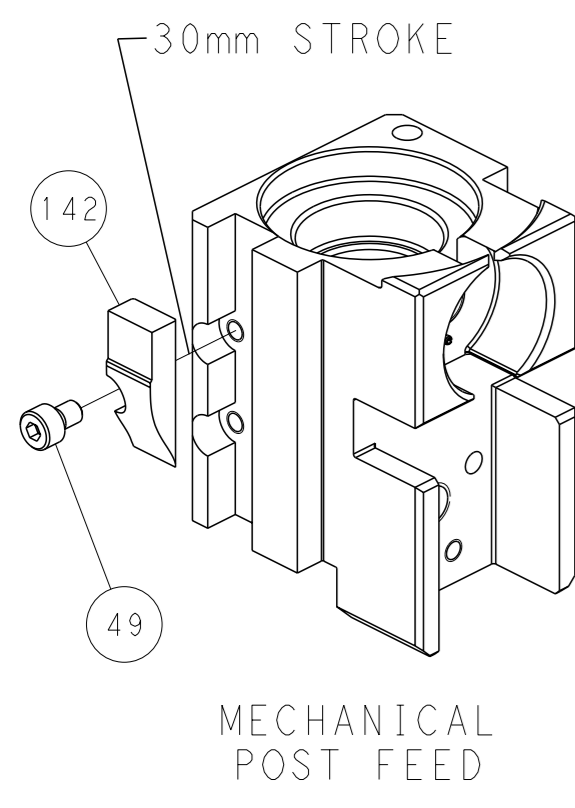


RAM SET-UP

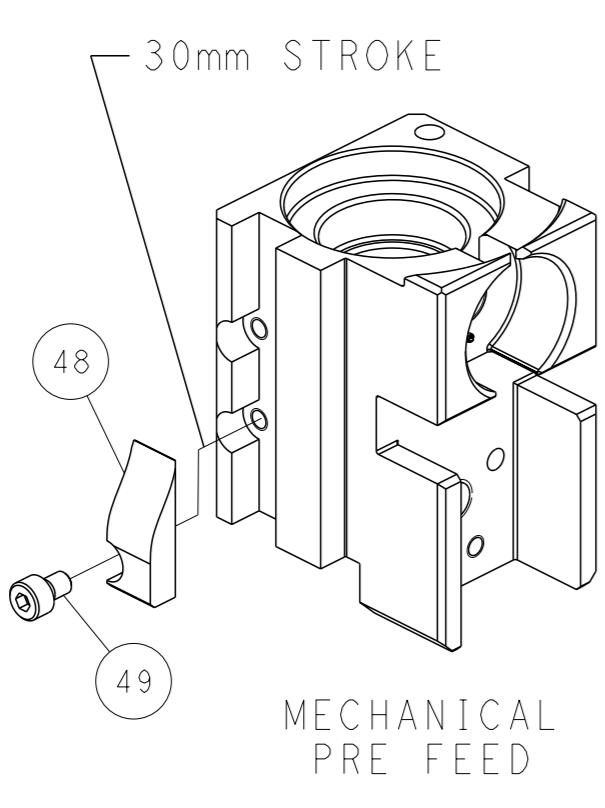


FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

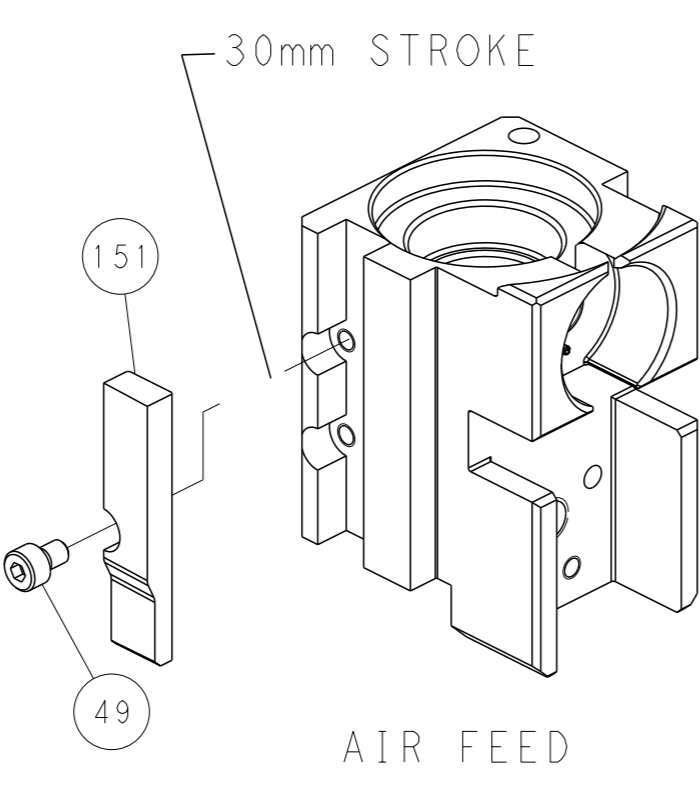
# CAM POSITIONS



MECHANICAL  
POST FEED



MECHANICAL  
PRE FEED



AIR FEED

**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>		DWN: H. HUANG 01DEC2014 CHK: L. ZHANG 01DEC2014 APVD: H. GUO 01DEC2014	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266592	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: -	PRODUCT SPEC: - APPLICATION SPEC: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION