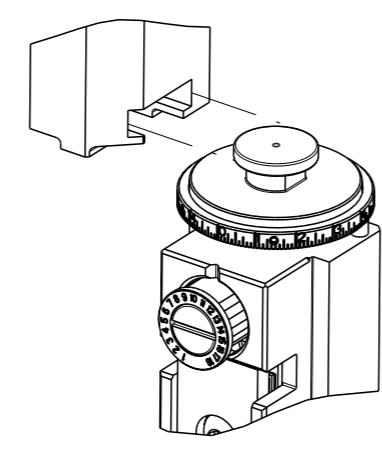


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266027-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266027-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266027-1	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266027-2	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266027-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266027-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266027-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.81 mm [.150]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: APTIV/DELPHI TERMINAL FCI/DELPHI CRIMP SPECIFICATION

TERMINAL NAME: CONTACT DCS 2-2.8

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
3.90-4.70 mm [.154-.185 IN]	∅1.40-2.10 mm [.055-.083 IN]

TERMINAL APPLICATION SPECIFICATION 90841100, PG 1 OF 4 Rev K

TERMINAL DATA: APTIV/DELPHI TERMINAL FCI/DELPHI CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.90-4.70 mm [.154-.185 IN]	∅1.40-2.10 mm [.055-.083 IN]

TERMINAL APPLICATION SPECIFICATION 90841100, PG 1 OF 4 Rev K

TERMINALS APPLIED

TE TERMINAL	APTIV/DELPHI TERMINAL	TE SEAL	APTIV/DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
2113373-1	60012931	2113175-1	60994023	∅2.05-3.0mm
2113373-2	60014031	2113590-1	60994015	∅1.4-2.1mm
2113373-3	60014032	2113590-2	10779162	∅1.2-2.1mm
2113373-4	60012131	828904-1		
2113373-5	60012134			
2113373-6	60012934			
2113373-7	60014234			
2113373-8	F028600			

TERMINALS APPLIED

TE TERMINAL	APTIV/DELPHI TERMINAL	TE SEAL	APTIV/DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
2113174-1	60110731	2113175-1	60994023	∅2.05-3.0mm
2113174-2	60110734	2113590-1	60994015	∅1.4-2.1mm
2113174-3	60110732	2113590-2	10779162	∅1.2-2.1mm
2113174-4	33505427	828904-1		
2113174-5	10756352			
2113174-6	33500682			
2113174-7	60110531			
2113174-8	60110534			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.25+/-0.04 [.049+/-0.002]	5.8
18 AWG OR 0.75mm2	1.20+/-0.04 [.047+/-0.002]	6.5
20 AWG OR 0.50mm2	1.17+/-0.04 [.046+/-0.002]	6.8

***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 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL LUBRICANT IS RECCOMENDED.

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		RELEASED	03OCT2013	BH	TE
		B	ECR-19-011425	19JUL2019	TB	TE
		C	ECR-20-018038	22DEC2020	FJ	RR
		D	ECR-21-003265	16MAR2021	JWC	TE

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	2-1752354-0	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
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-4	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-6	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	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-5	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1	1-1633920-9	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	6-240641-7	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1	4-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	2	1	1	1	2-456405-8	CRIMPER, WIRE PREMIUM	1

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-2	-1		

OWN	Y. YIN	11SEP2013
CHK	G. BAILEY	11SEP2013
APVD	J. GUO	11SEP2013

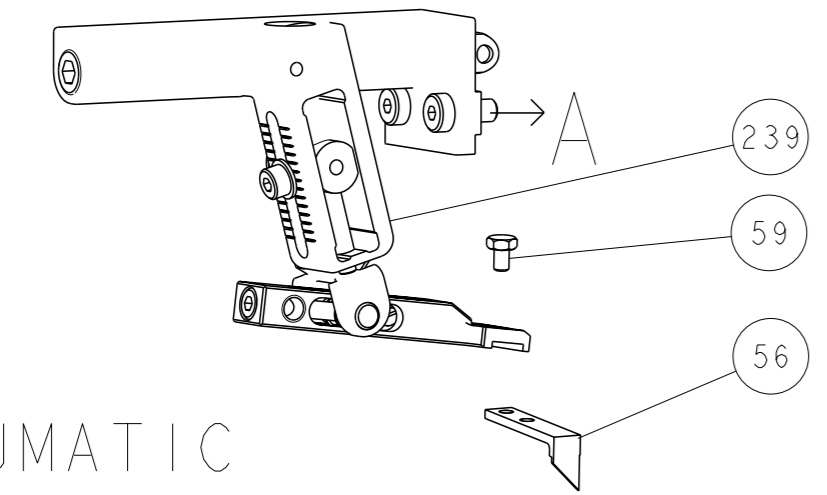
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mm	0 PLC ±
	1 PLC ±
	2 PLC ±
	3 PLC ±
	4 PLC ±
	ANGLES ±
MATERIAL:	FINISH

NAME	Ocean Side Feed Applicator
SIZE	A1
CAGE CODE	00779
DRAWING NO	2266027
RESTRICTED TO	
Customer Accessible Production Drawing	SCALE 1:2 SHEET 1 of 4 REV D

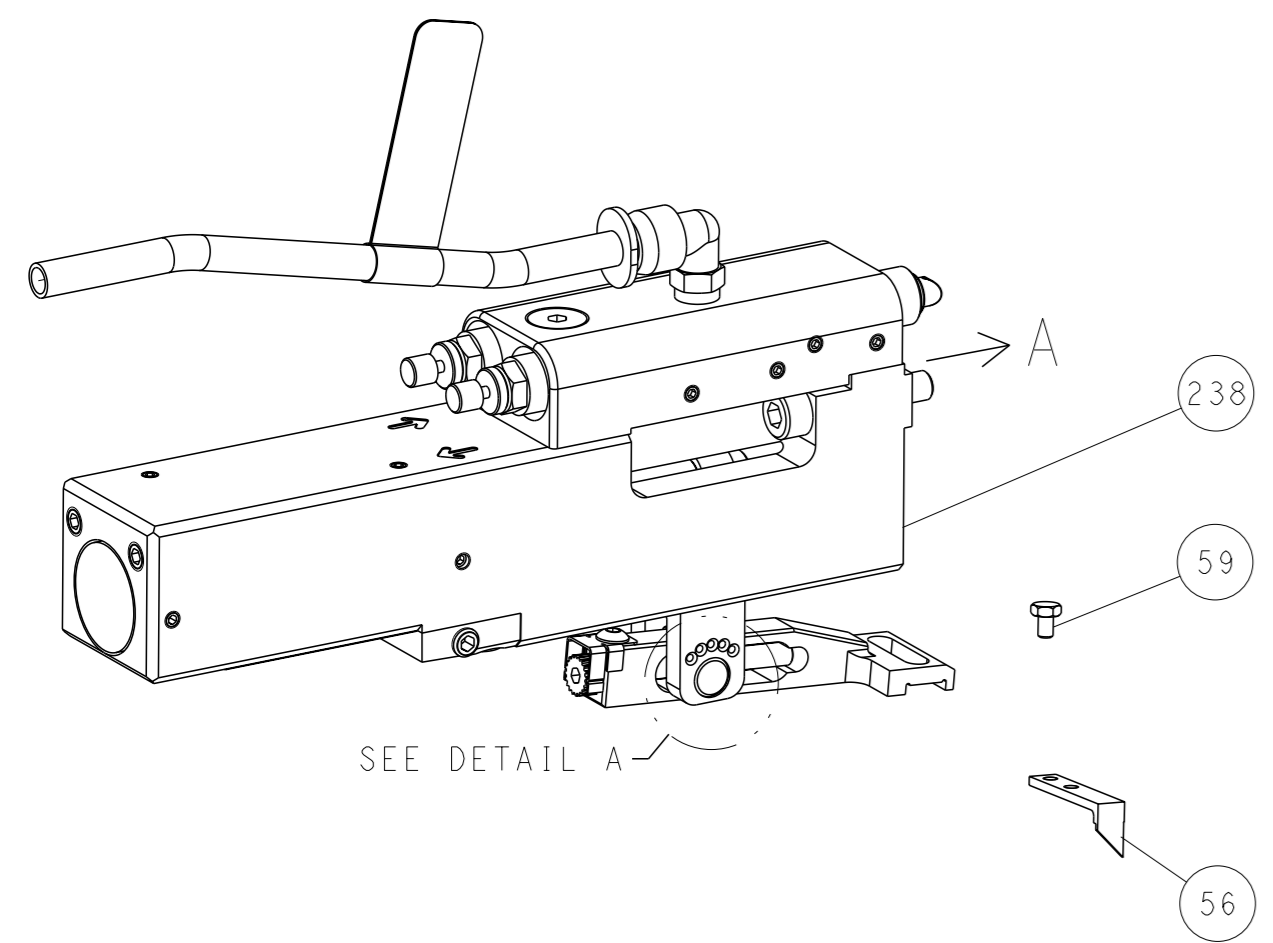
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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

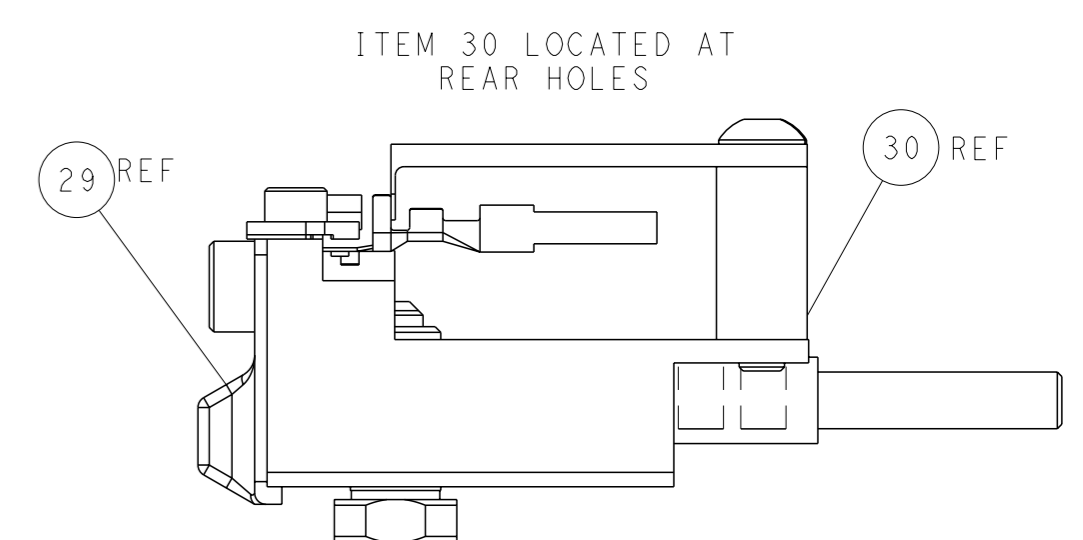
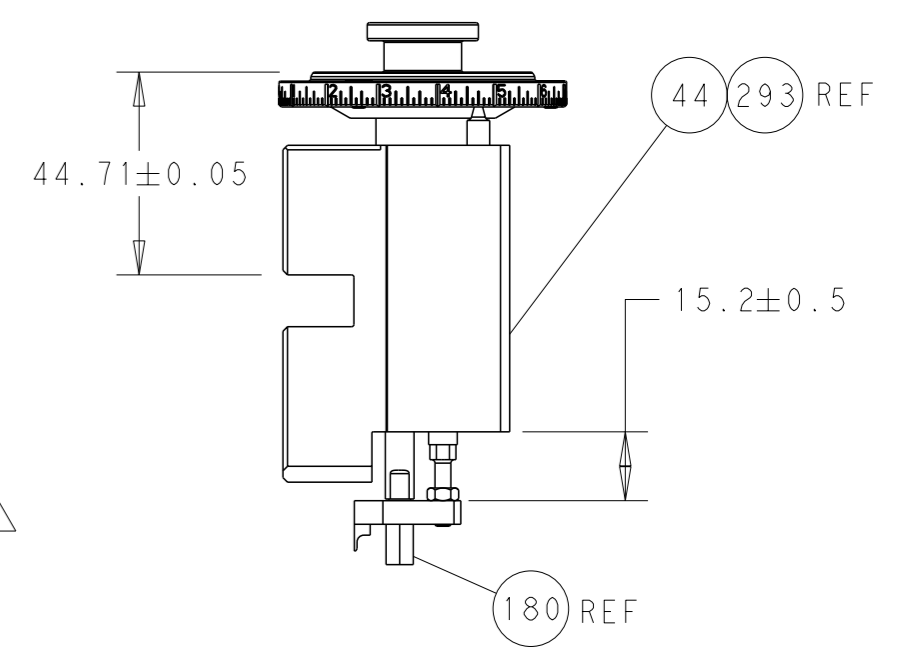
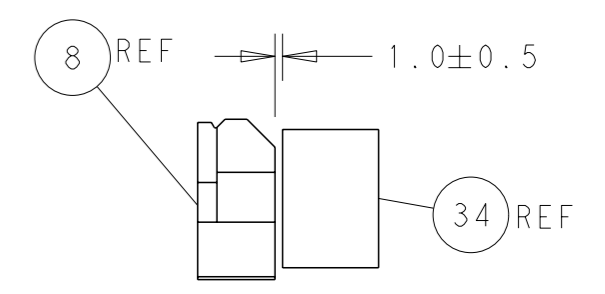
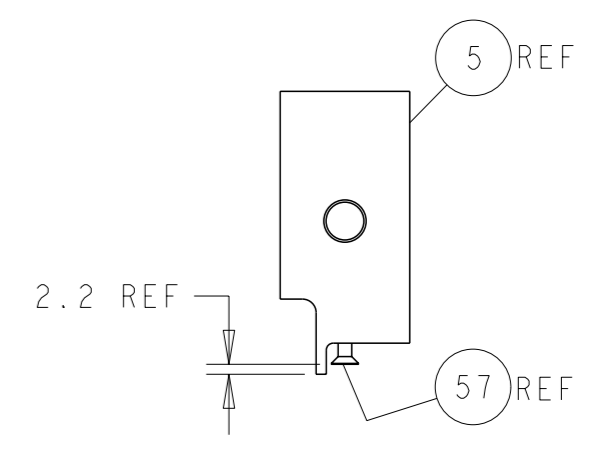
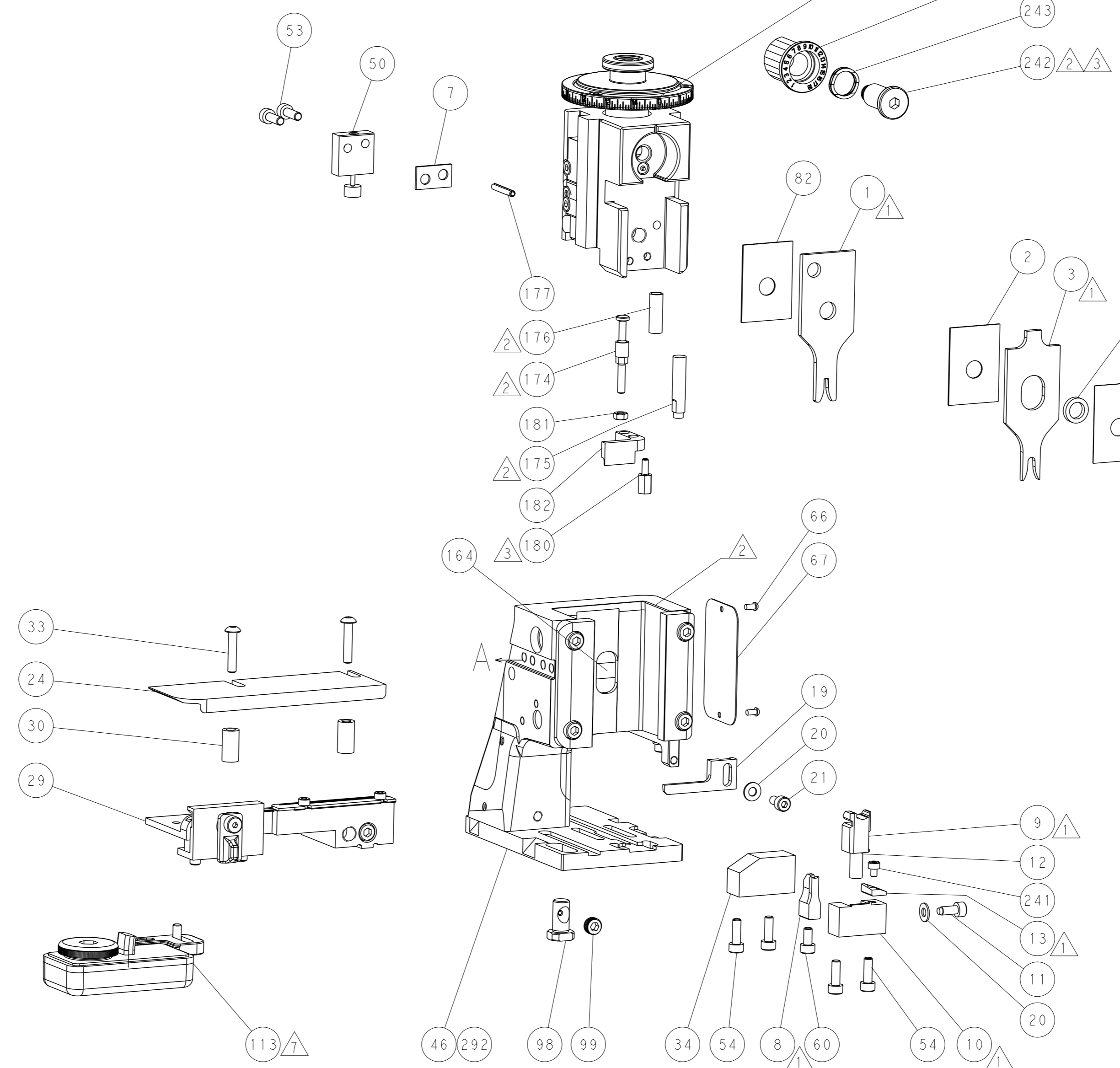
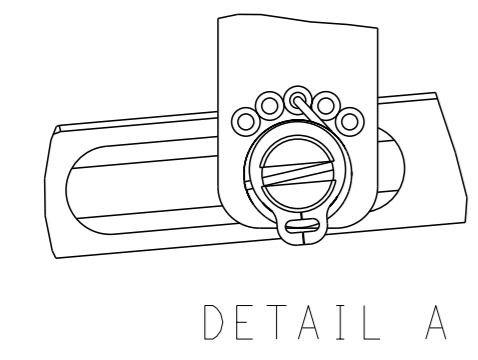
FEED TYPE MECHANICAL



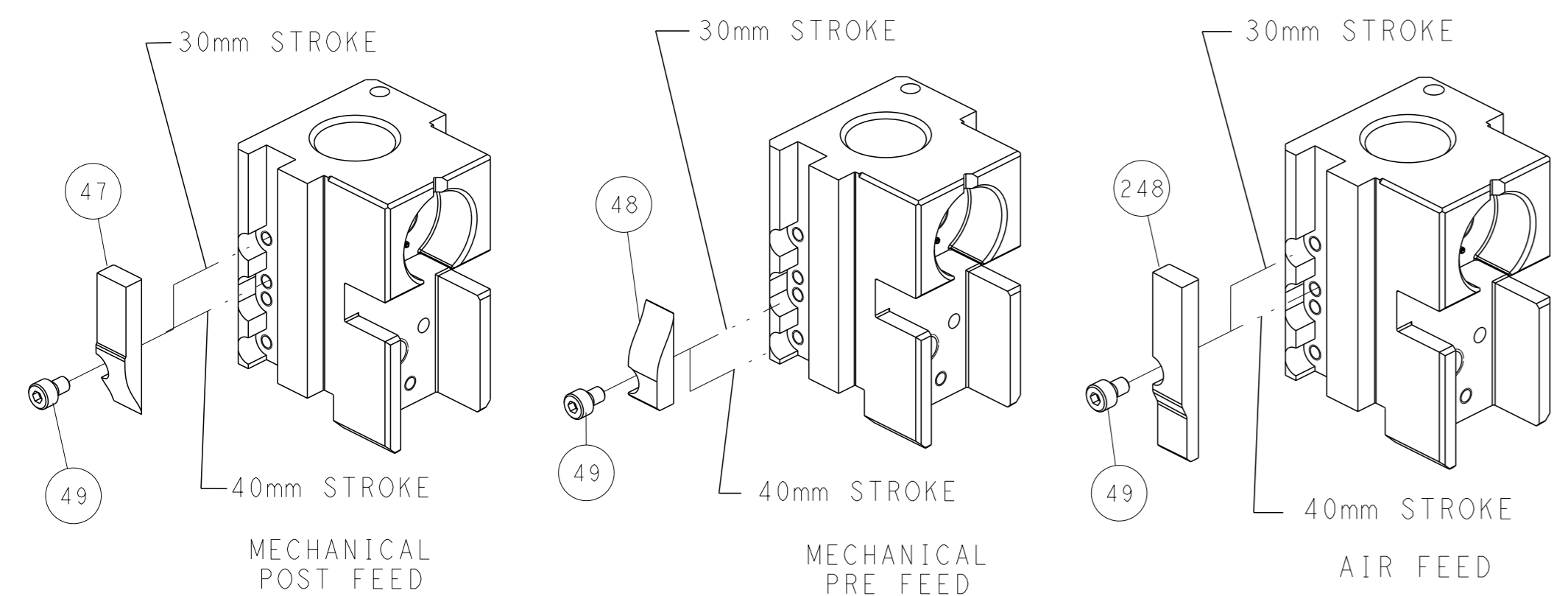
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS

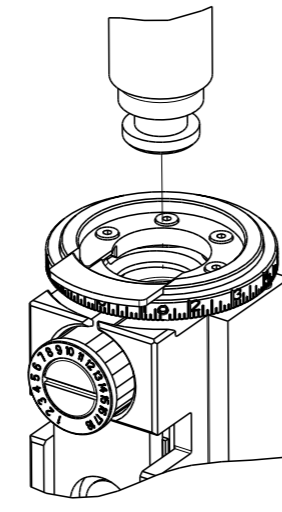


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: Y. YIN 11SEP2013 CHK: G. BAILEY 11SEP2013 APVD: J. GUO 11SEP2013	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266027	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:	SCALE: 1:2 SHEET: 2 of 4 REV: D	RESTRICTED TO:

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266027-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266027-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266027-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.81 mm [.150]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: APTIV/DELPHI TERMINAL FCI/DELPHI CRIMP SPECIFICATION

TERMINAL NAME: CONTACT DCS 2-2.8	
WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]
TERMINAL APPLICATION SPECIFICATION 90841100, PG 1 OF 4 Rev K	

TERMINALS APPLIED

TE TERMINAL	APTIV/DELPHI TERMINAL	TE SEAL	APTIV/DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
2113373-1	60012931	2113175-1	60994023	2.05-3.0
2113373-2	60014031	2113590-1	60994015	1.4-2.1
2113373-3	60014032	2113590-2	10779162	1.2-2.1
2113373-4	60012131	828904-1		
2113373-5	60012134			
2113373-6	60012934			
2113373-7	60014234			
2113373-8	F028600			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.25 +/- 0.04 [1.049 +/- .002]	5.8
18 AWG OR 0.75mm2	1.20 +/- 0.04 [1.047 +/- .002]	6.5
20 AWG OR 0.50mm2	1.17 +/- 0.04 [1.046 +/- .002]	6.8

TERMINAL DATA: APTIV/DELPHI TERMINAL FCI/DELPHI CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]	INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]
TERMINAL APPLICATION SPECIFICATION 90841100, PG 1 OF 4 Rev K	

TERMINALS APPLIED

TE TERMINAL	APTIV/DELPHI TERMINAL	TE SEAL	APTIV/DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
2113174-1	60110731	2113175-1	60994023	Ø2.05-3.0mm
2113174-2	60110734	2113590-1	60994015	Ø1.4-2.1mm
2113174-3	60110732	2113590-2	10779162	Ø1.2-2.1mm
2113174-4	33505427	828904-1		
2113174-5	10756352			
2113174-6	33500682			
2113174-7	60110531			
2113174-8	60110534			

***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			
P	LYN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1			

-	1	1	2119082-7	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1752356-4	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	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-6	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	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1-1633920-9	ANVIL, COMBINATION	8
-	1	1	6-240641-7	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	4-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	2-456405-8	CRIMPER, WIRE PREMIUM	1

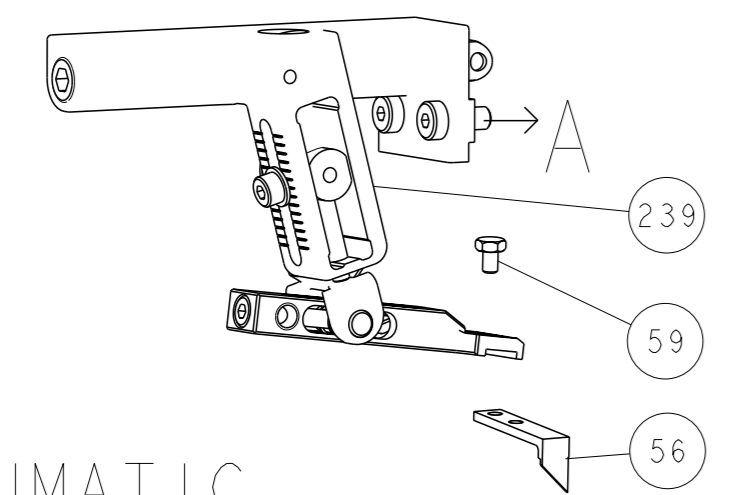
- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- △ CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- △ APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ TERMINAL LUBRICANT IS RECCOMENDED.

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

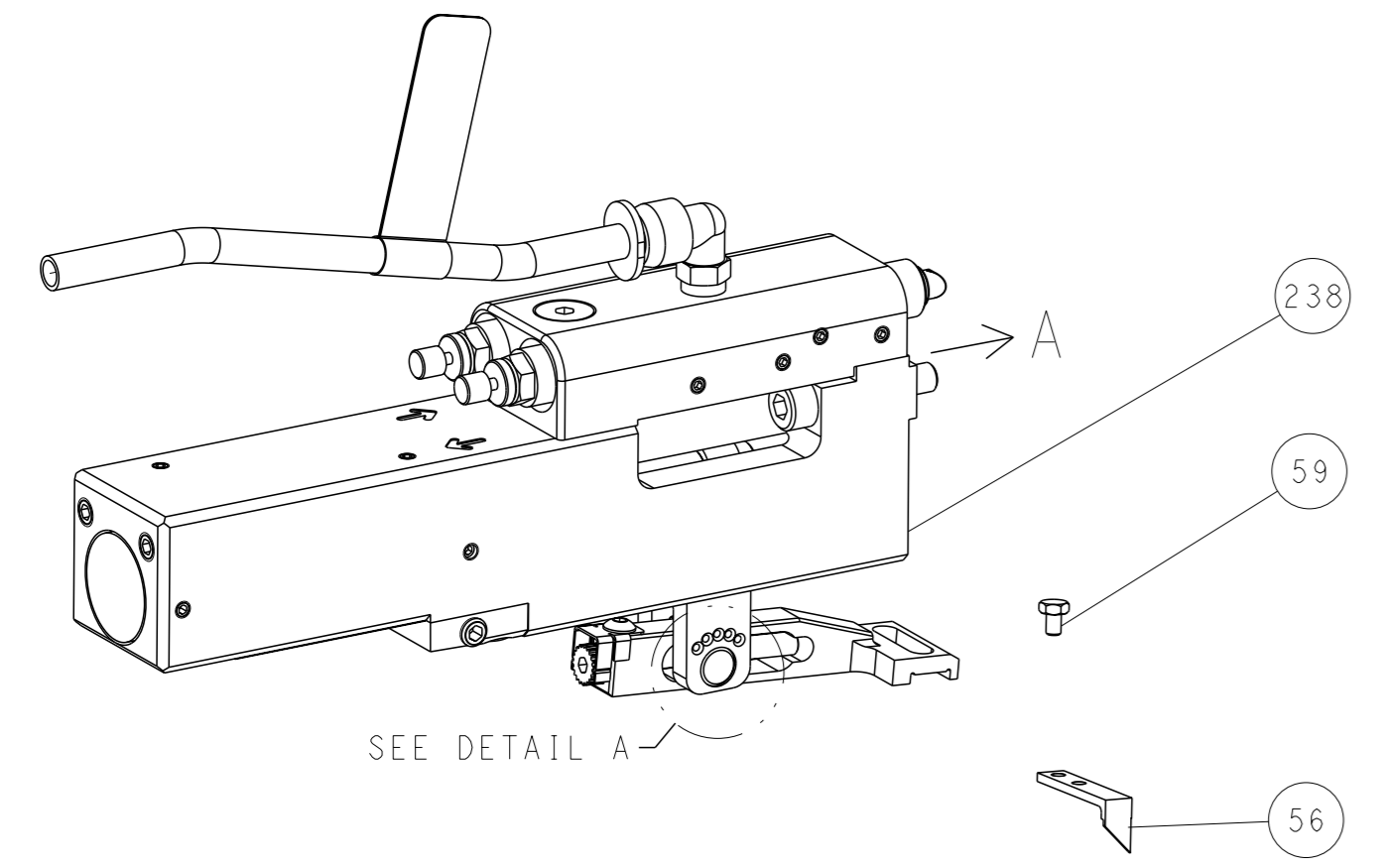
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN Y. YIN 11SEP2013	STE TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	CHK G. BAILEY 11SEP2013	
MATERIAL:		FINISH:		APVD U. GUO 11SEP2013	NAME Ocean Side Feed Applicator
WEIGHT:		SCALE:		SIZE CAGE CODE DRAWING NO	RESTRICTED TO
Customer Accessible Production Drawing		SCALE 1:2		00779 C=2266027	3 OF 4

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

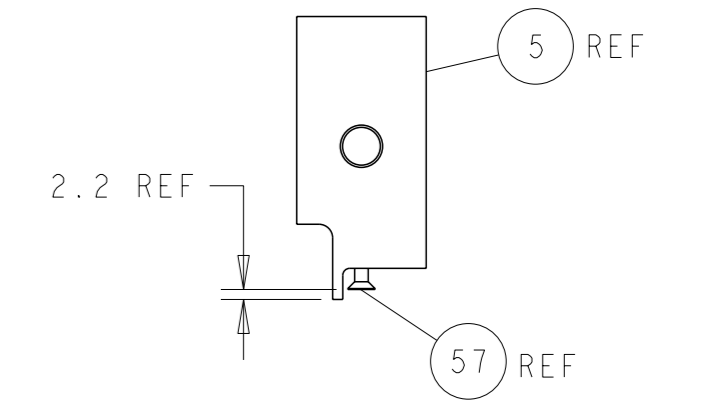
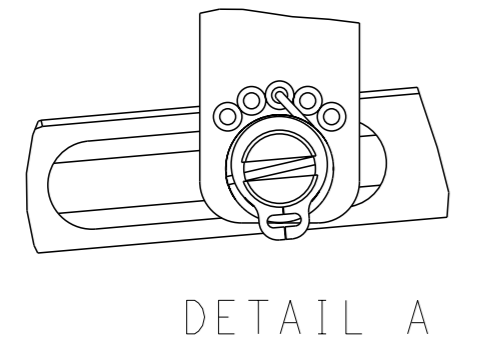
FEED TYPE MECHANICAL



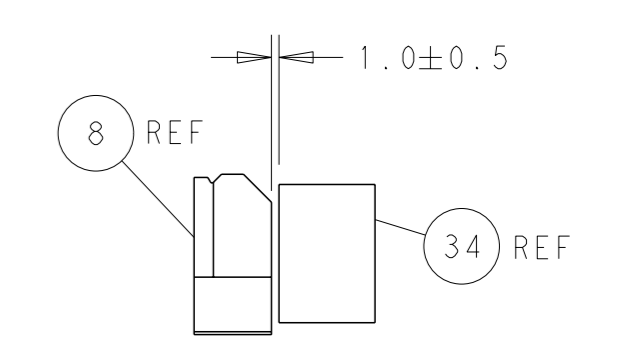
PNEUMATIC



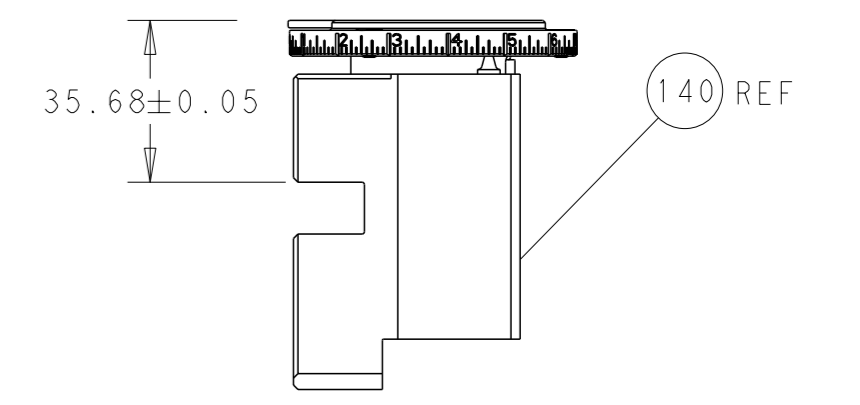
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



SHEAR DEPRESSOR DETAIL

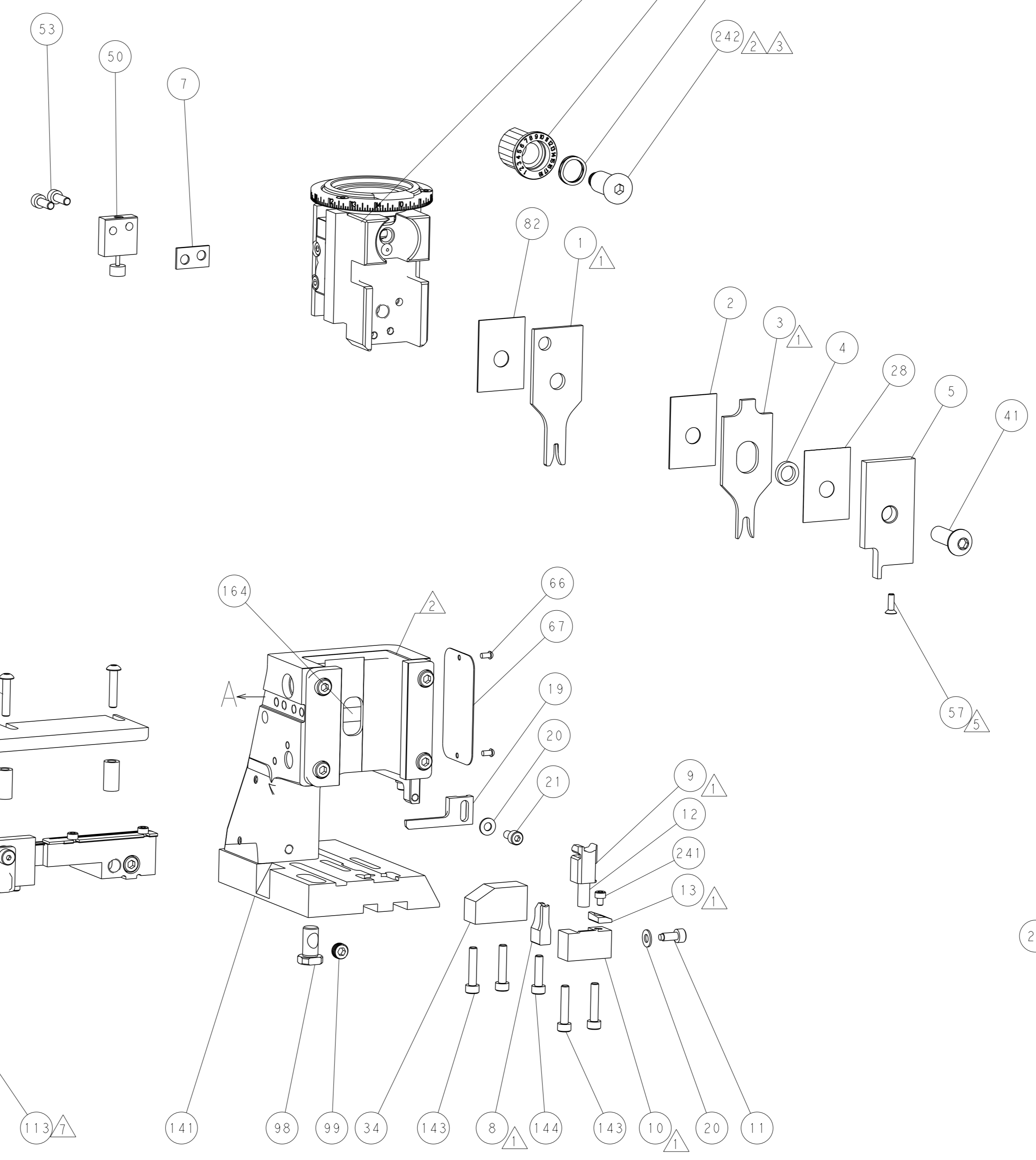
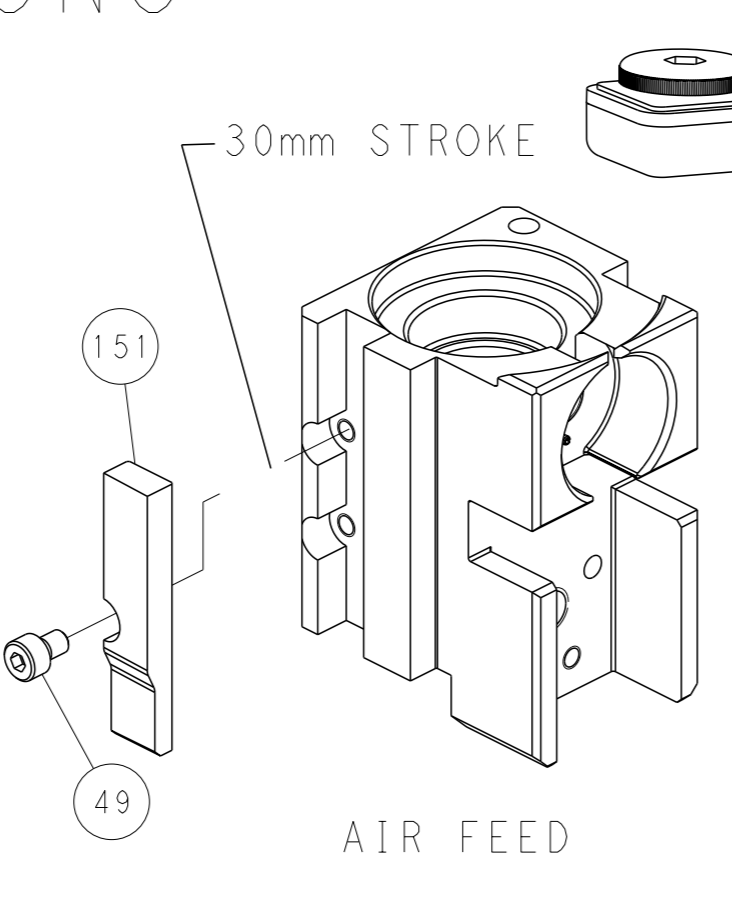
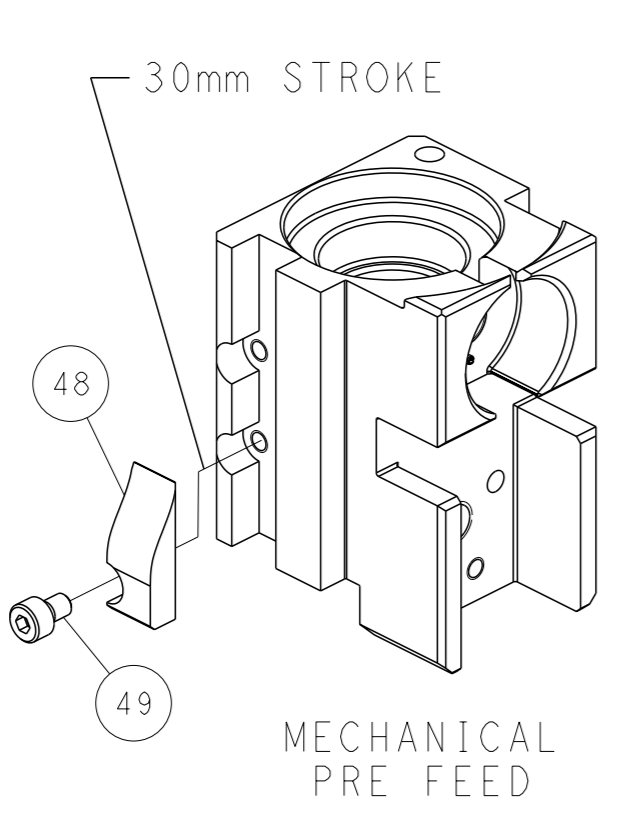
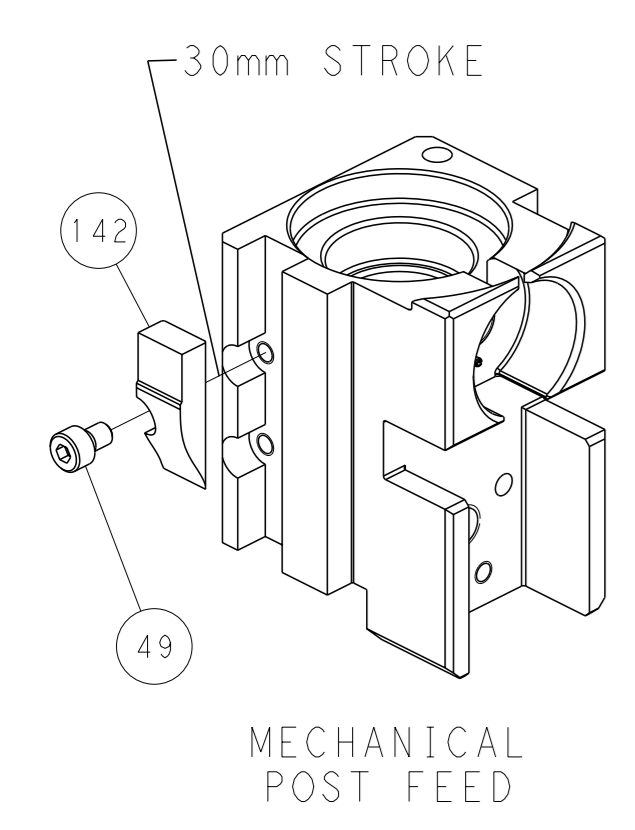


TERMINAL SUPPORT LOCATION

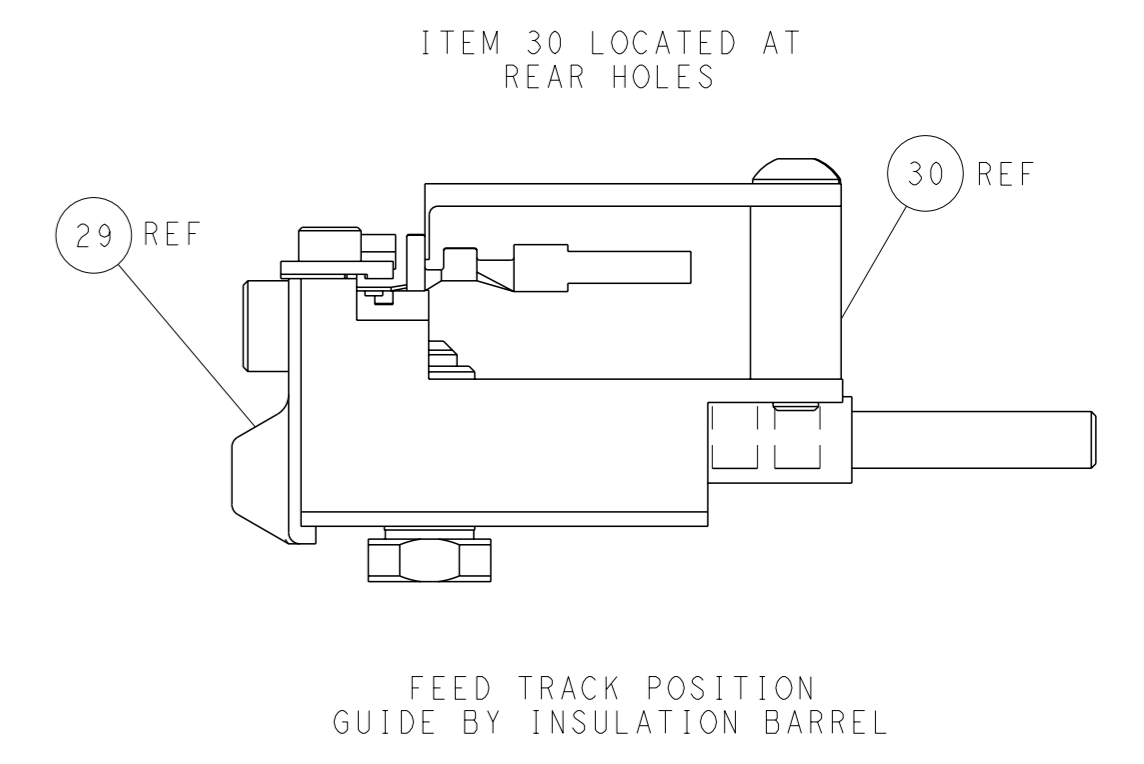


RAM SET-UP

CAM POSITIONS



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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: Y. YIN 11SEP2013 CHK: G. BAILEY 11SEP2013 APVD: H. GUO 11SEP2013 PRODUCT SPEC APPLICATION SPEC WEIGHT: - Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266027 SCALE: 1:2 SHEET: 4 of 4 REV: D		RESTRICTED TO: -	
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