

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2266545-1 | C | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2266545-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266545-1 | C | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2266545-2 | C | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2266545-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 5.59 mm [.220] | F |
| INSUL | 6.86 mm [.270] | F |

APPLICATOR INSTRUCTIONS
408-35043

| TERMINAL DATA: DELPHI TERMINAL | | DELPHI CRIMP SPECIFICATION | |
|------------------------------------|-----------------|-----------------------------|-----------------|
| TERMINAL NAME: RING TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 6.46-7.22 mm [.254-.284 IN] | | 3.20-4.30 mm [.126-.169 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 12103517 Rev - | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | DELPHI TERMINAL | TE TERMINAL | DELPHI TERMINAL |
| 1557699-1 | 12103517 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 5.00mm2 | 3.35 +/- 0.05 [.132 +/- .002] | 5.5 |
| 3.00mm2 | 3.05 +/- 0.05 [.120 +/- .002] | 8.0 |

- 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 CUT TO LENGTH AT ASSEMBLY.

***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 | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | B | | ECR-15-005029 | 08APR2015 | MR | TE |
| | | C | | ECR-22-135827 | 12APR2022 | JWC | RR |

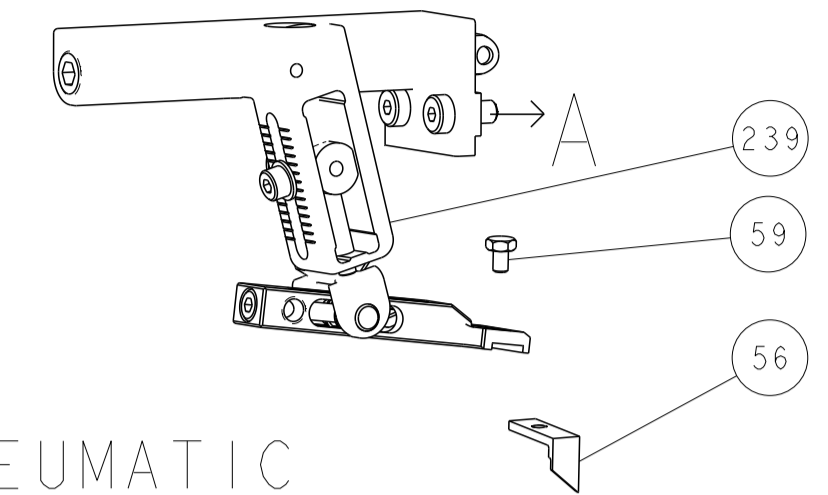
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|---|-----|-----|-----|-----|-------------|-------------------------------------|-------------------------------|---------|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 1 | 1 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | 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 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 | |
| - | 1 | - | 1 | - | 2844940-1 | AIR FEED MODULE | 238 | |
| - | 1 | 1 | 1 | 1 | 2063687-5 | PLATE, REAR SHEAR | 233 | |
| - | 1 | 1 | 1 | 1 | 2161951-4 | BLADE, SLUG | 232 | |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 | |
| - | 1 | 1 | 1 | 1 | 1-22281-8 | SPRING, COMPRESSION | 121 | |
| - | 1 | 1 | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 | |
| - | 1 | 1 | 1 | 1 | 2844907-1 | POST, LOCKING | 98 | |
| - | 1 | 1 | 1 | 1 | 690487-9 | GUIDE, FRONT STRIP | 96 | |
| - | 2 | 2 | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 95 | |
| - | 1 | 1 | 1 | 1 | 2168083-6 | SCR, SKT HD CAP, RoHS, M5 X 6.5 | 93 | |
| - | 1 | 1 | 1 | 1 | 455888-5 | 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 | |
| - | 2 | 2 | 2 | 2 | 2-18032-5 | SCR, SET, FLT PNT, M5 X 20.0 | 61 | |
| - | 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 | 1338683-9 | FEED PAWL | 56 | |
| - | 1 | 1 | 1 | 1 | 1-811242-0 | BUMPER, HOLD DOWN | 51 | |
| - | 1 | 1 | 1 | 1 | 3-18031-6 | SCR, SET, CUP POINT M2.5 X 3.0 | 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 | |
| - | 2 | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 45 | |
| - | 1 | 1 | 1 | 1 | 1803515-1 | RAM ASSEMBLY, SF ATLANTIC | 44 | |
| - | 1 | 1 | 1 | 1 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 43 | |
| - | 1 | 1 | 1 | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 | |
| - | 2 | 2 | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 36 | |
| - | 2 | 2 | 2 | 2 | 2-2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 25 | 30 | |
| - | 1 | 1 | 1 | 1 | 1-2305692-1 | PLATE, REAR STRIP GUIDE | 29 | |
| - | 2 | 2 | 2 | 2 | 22283-1 | SPRING, COMPRESSION | 27 | |
| - | 1 | 1 | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 | |
| - | 1 | 1 | 1 | 1 | 240792-7 | DRAG, TERMINAL | 25 | |
| - | 1 | 1 | 1 | 1 | 980371-4 | SCR, SKT HD SHLDR 5.0 DIA X 6.0 | 23 | |
| - | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 | |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 | |
| - | 1 | 1 | 1 | 1 | 1-2119533-0 | STRIPPER, SIDE FEED | 19 | |
| - | 1 | 1 | 1 | 1 | 1-189124-2 | GUIDE, FRONT STRIP | 12 | |
| - | 1 | 1 | 1 | 1 | 1803011-6 | HOLDER, SLUG BLADE | 11 | |
| - | - | - | - | - | - | - | 10 | |
| - | - | - | - | - | - | - | 9 | |
| - | - | - | - | - | - | - | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | - | - | - | - | - | - | 5 | |
| - | 1 | 1 | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 | |
| - | 1 | 2 | 2 | 1 | 1 | 9-2119784-9 | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 2 |
| - | 1 | 2 | 2 | 1 | 1 | 456413-6 | CRIMPER, WIRE PREMIUM | 1 |
| - | 77 | -72 | -71 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

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

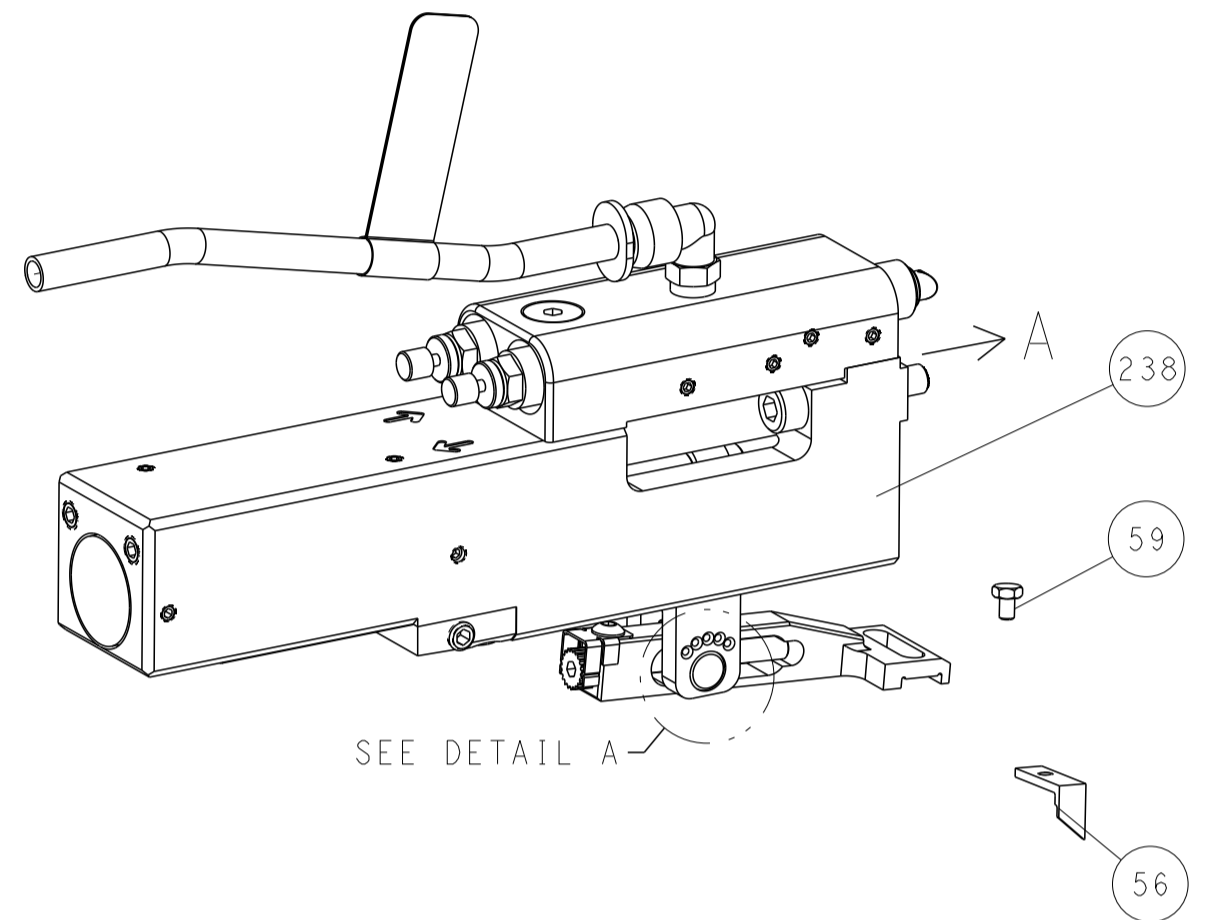
| | | | |
|--|-----------|------------|--|
| OWN | H. STAKEM | 28JAN2014 | TE Connectivity Harrisburg, PA 17105-3608 |
| CHK | T. ELBIN | 28JAN2014 | |
| APVD | T. ELBIN | 28JAN2014 | NAME |
| PRODUCT SPEC | | | Ocean Side Feed Applicator |
| APPLICATION SPEC | | | |
| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| A1 | 00779 | 2266545 | |
| Customer Accessible Production Drawing | | | SCALE 1:2 SHEET 1 OF 4 REV C |

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| A | 66 | P | LYN | DESCRIPTION | DATE | DWN | APVD |
| | | - | | SEE SHEET 1 | - | - | - |

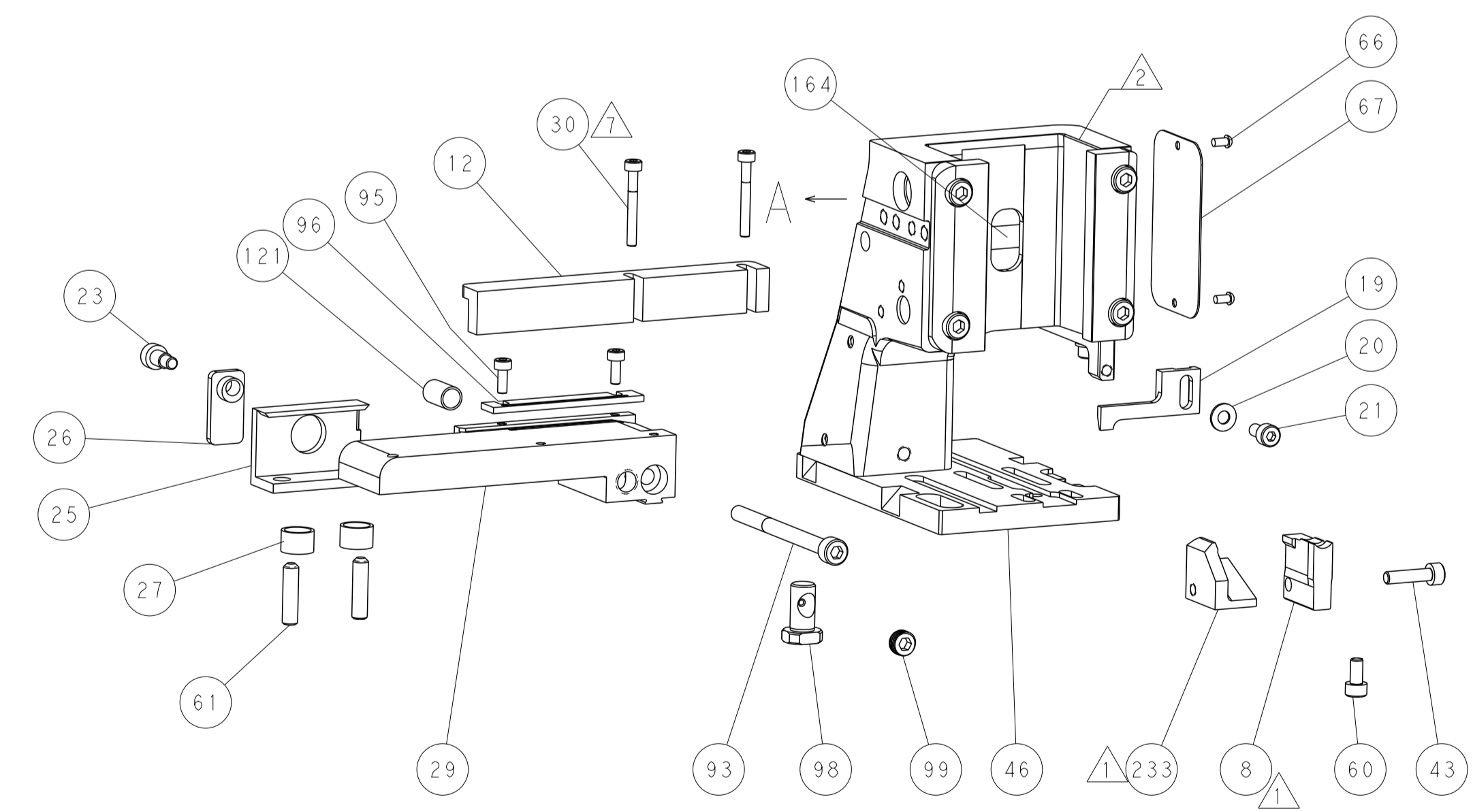
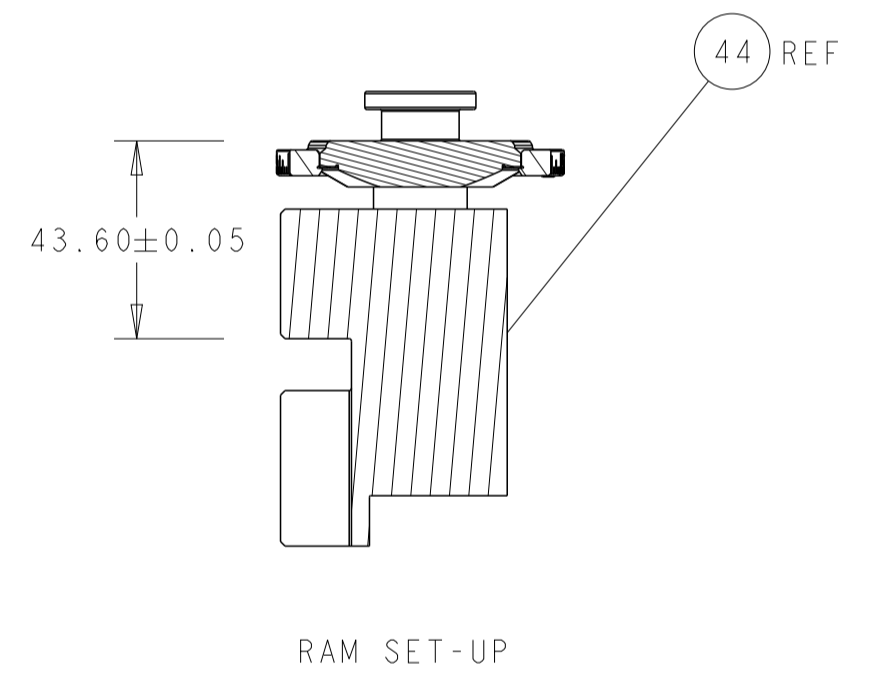
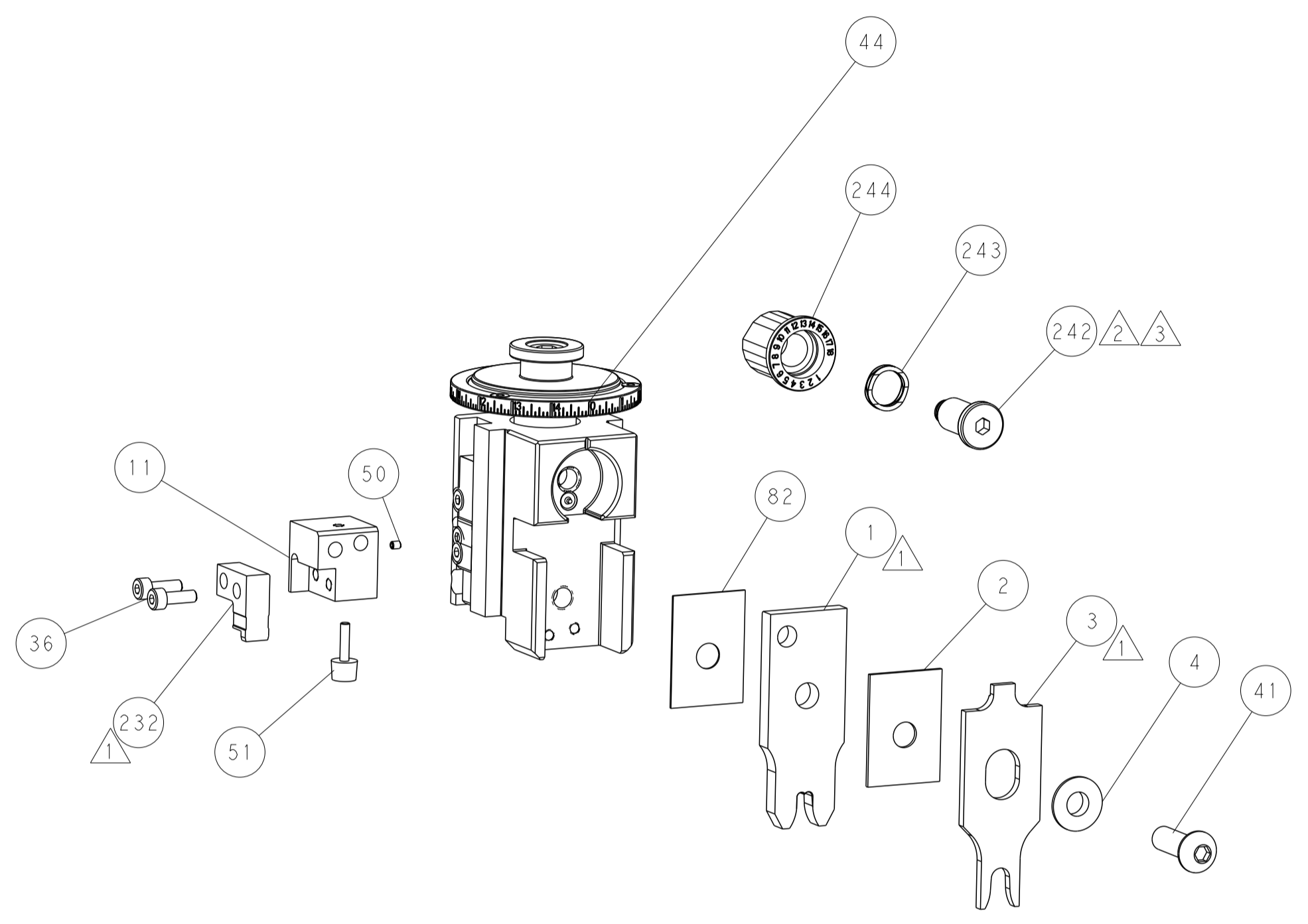
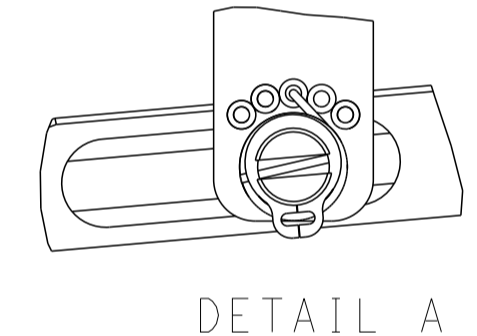
FEED TYPE MECHANICAL



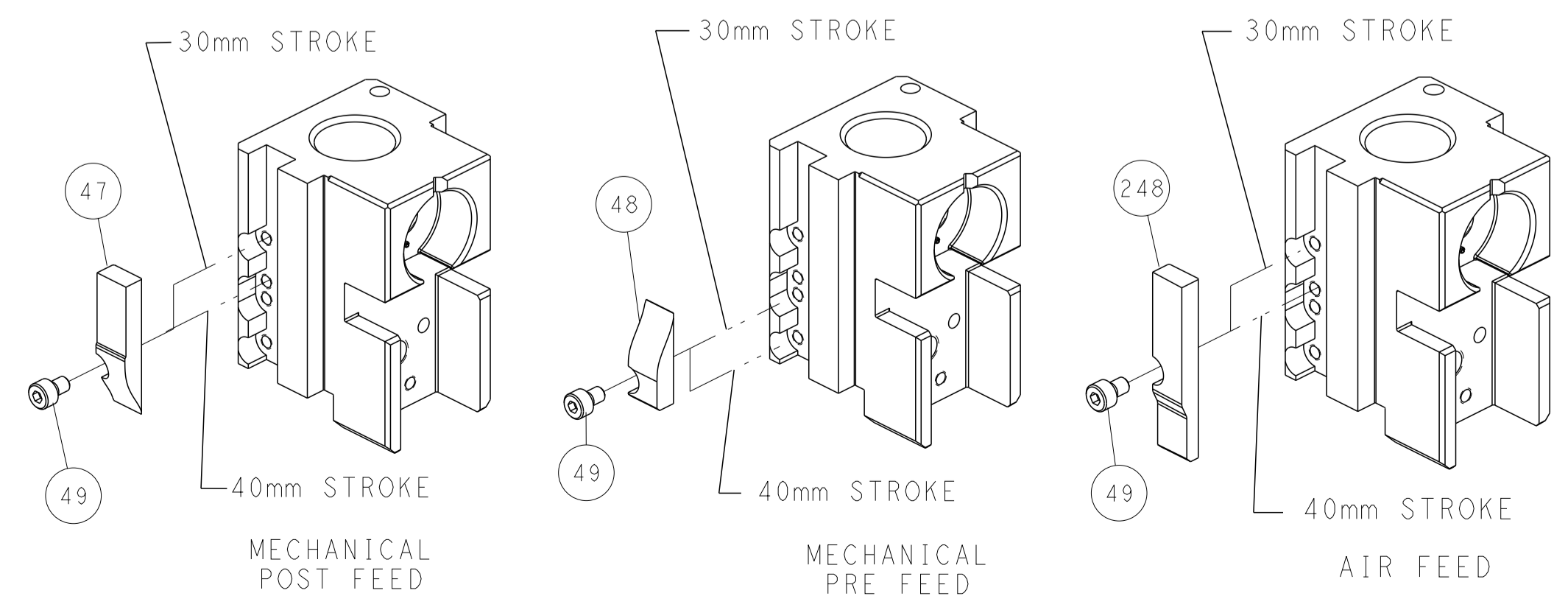
PNEUMATIC



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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN: K. STAKEM 28JAN2014 CHK: T. ELBIN 28JAN2014 APVD: T. ELBIN 28JAN2014 | 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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266545 | RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: C |
| MATERIAL: - | | WEIGHT: - Customer Accessible Production Drawing | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION |

