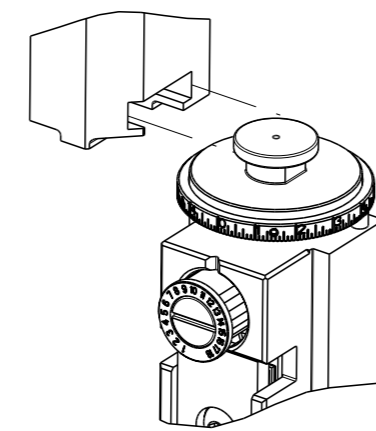


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266789-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266789-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266789-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266789-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266789-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

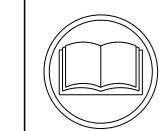


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.68 mm [.145]	F
INSUL	5.08 mm [.200]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.41-5.18 mm [.174-.204 IN]	∅3.45-3.81 mm [.136-.150 IN]		
TERMINAL APPLICATION SPECIFICATION	02989877 PAGE 3 OF 9 Rev 10-29-13		
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1949831-1	2989877	1572323-3	2962544
1572323-2	2962574	1572323-1	2965143

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	2.00+/-0.05 [.079+/- .002]	7.0



- 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. 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					
A	66	#	LY#	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	10JUL2015	BW	GB
		B		ECR-19-014227	11SEP2019	FJ	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	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	1	1	1	1	1-356885-1	STOP, SHEAR	237	
-	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	1803258-1	FRONT STRIP GUIDE	96	
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	2	2	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	85	
-	1	1	1	1	455888-7	SPACER, CRIMPER	82	
-	1	1	1	1	4-240641-7	SPACER	81	
-	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	1338683-1	FEED PAWL	56	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, M4 X 12.0	54	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53	
-	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	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	33	
-	1	1	1	1	2305692-8	PLATE, REAR STRIP GUIDE	29	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-3	DRAG, TERMINAL	25	
-	1	1	1	1	2-189124-3	GUIDE, FRONT STRIP	24	
-	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	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	1673257-5	SHEAR, FLOATING	17	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1	1	1	1673256-4	PLATE, REAR SHEAR	15	
-	1	1	1	1	1673255-2	HOLDER, REAR SHEAR	14	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	-	-	-	-	-	-	10	
-	-	-	-	-	-	-	9	
-	1	2	2	1	1	8-1803054-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	1	1	1	1	2-690468-8	DEPRESSOR SHEAR, REAR	6	
-	-	-	-	-	-	-	5	
-	1	1	1	1	2-238009-1	BLOCK, FL CRIMPER SPACER	4	
-	1	2	2	1	1	1803246-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-8	SPACER, CRIMPER	2	
-	1	2	2	1	1	4-568176-2	CRIMPER, WIRE	1

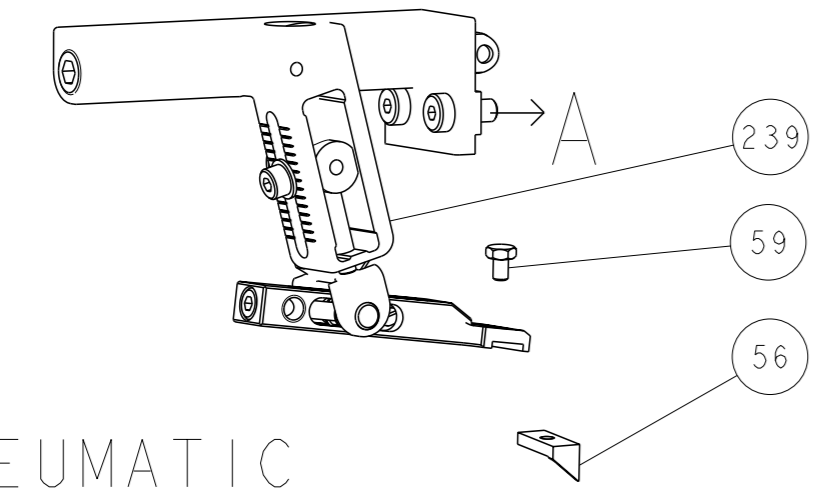
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001
	ANGLES ±0.001	FINISH			

OWN	B. WEAVER	13MAY2015
CHK	G. BAILEY	13MAY2015
APVD	G. BAILEY	13MAY2015
PRODUCT SPEC		
APPLICATION SPEC		
WEIGHT		
SCALE	1:2	SHEET 1 OF 4
REV	B	

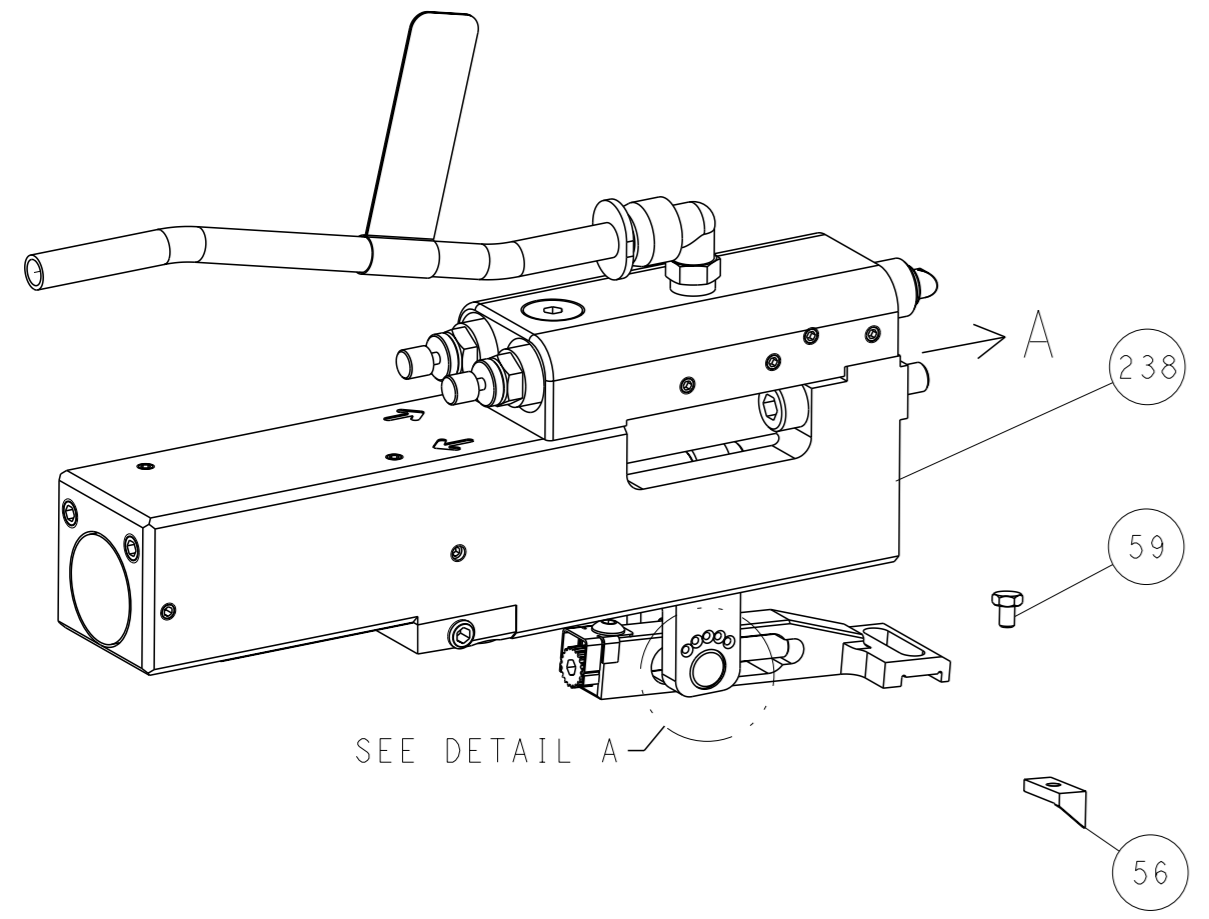
Customer Accessible Production Drawing

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

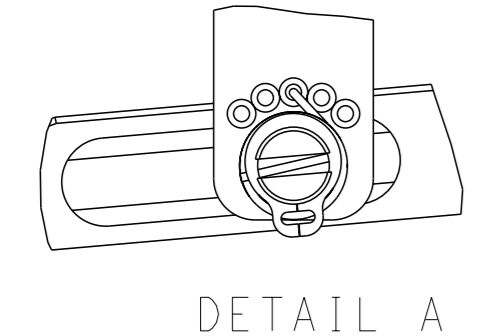
FEED TYPE MECHANICAL



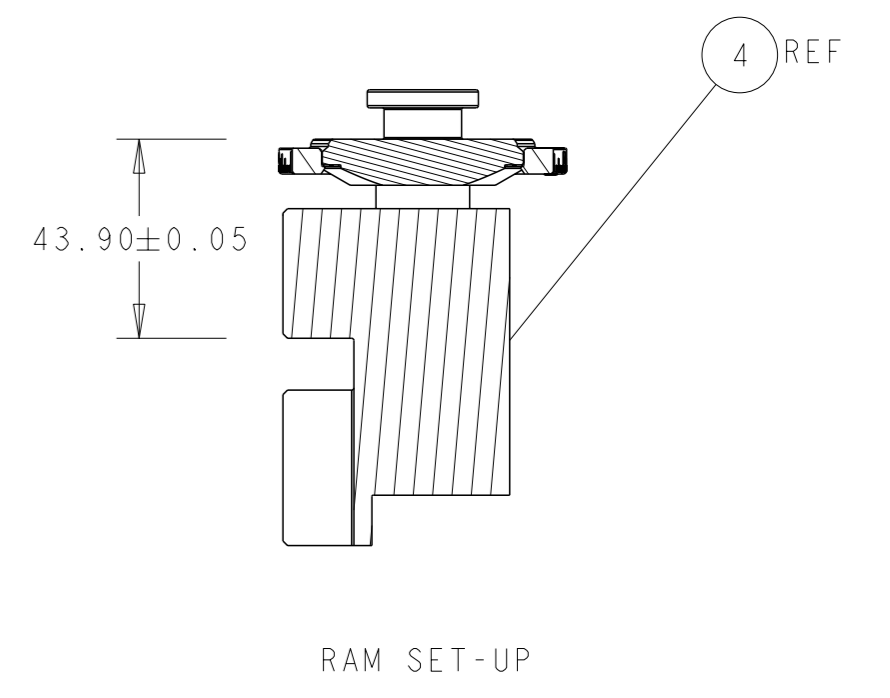
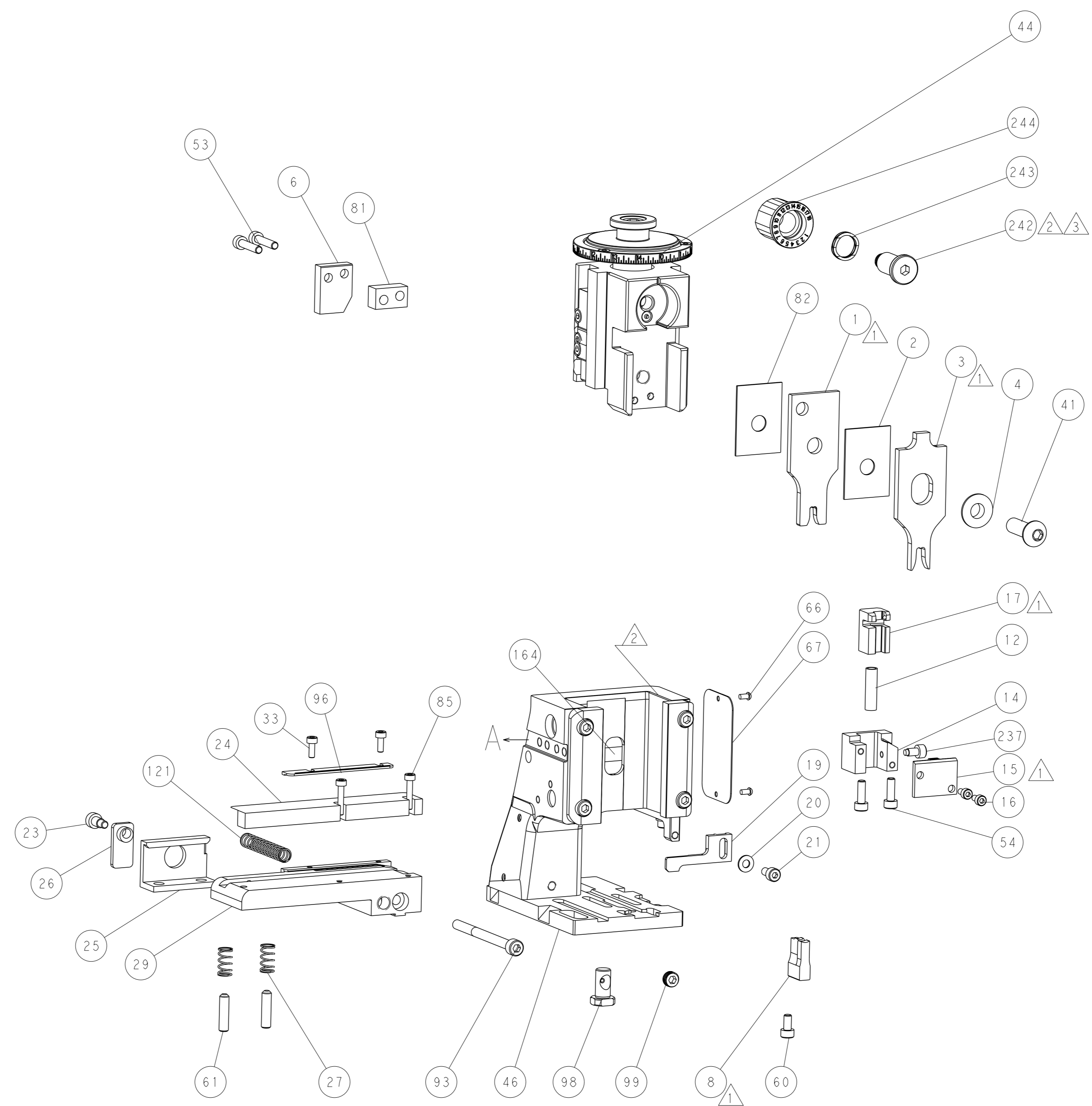
PNEUMATIC



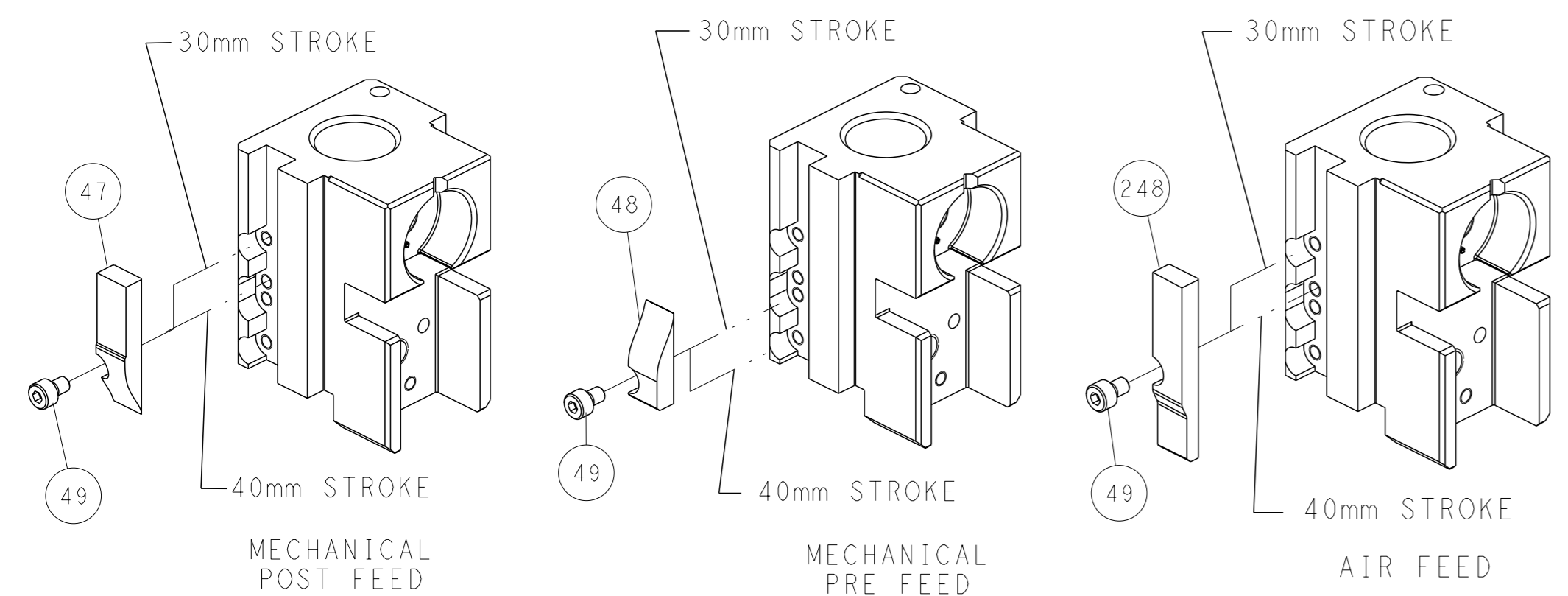
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A



CAM POSITIONS



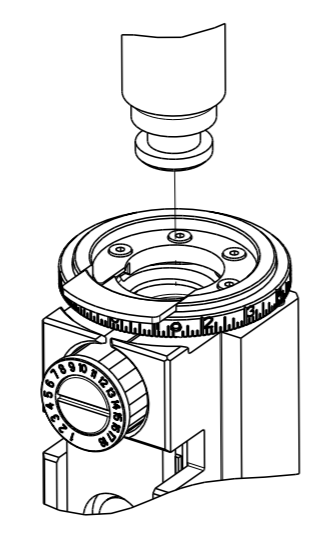
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: B. WEAVER CHK: G. BAILEY APVD: G. BAILEY	DATE: 13MAY2015 DATE: 13MAY2015 DATE: 13MAY2015	NAME: Ocean Side Feed Applicator
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1	MATERIAL: . FINISH: .	WEIGHT: . SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266789	RESTRICTED TO: . SHEET 2 of 4 REV B

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 COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266789-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266789-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266789-7	A	CRIMP TOOLING KIT	-

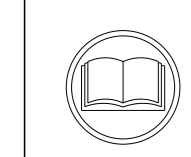
PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.68 mm (.145)	F
INSUL	5.08 mm (.200)	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.41-5.18 mm (.174-.204 IN)	3.45-3.81 mm (.136-.150 IN)		
TERMINAL APPLICATION SPECIFICATION 02989877 PAGE 3 OF 9 Rev 10-29-13			
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1949831-1	2989877	1572323-3	2962544
1572323-2	2962574	1572323-1	2965143

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	2.00 +/- 0.05 [.079 +/- .002]	7.0



- 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	-	-	-

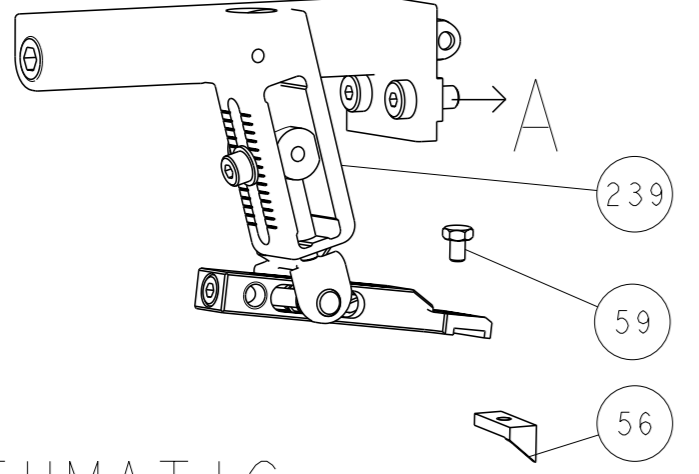
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	1	1	1-356885-1	STOP, SHEAR	237
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	2	2	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1803258-1	FRONT STRIP GUIDE	96
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	85
-	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	4-240641-7	SPACER	81
-	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
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-1	FEED PAWL	56
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	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
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	33
-	1	1	2305692-8	PLATE, REAR STRIP GUIDE	29
-	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-3	DRAG, TERMINAL	25
-	1	1	2-189124-3	GUIDE, FRONT STRIP	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1673257-5	SHEAR, FLOATING	17
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1673256-4	PLATE, REAR SHEAR	15
-	1	1	1673255-2	HOLDER, REAR SHEAR	14
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	10
-	-	-	-	-	9
-	1	1	1-8-1803054-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	1	1	2-690468-8	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	5
-	1	1	2-238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1803246-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
-	1	1	4-568176-2	CRIMPER, WIRE	1
-	77	22	21	PART NO	ITEM NO

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

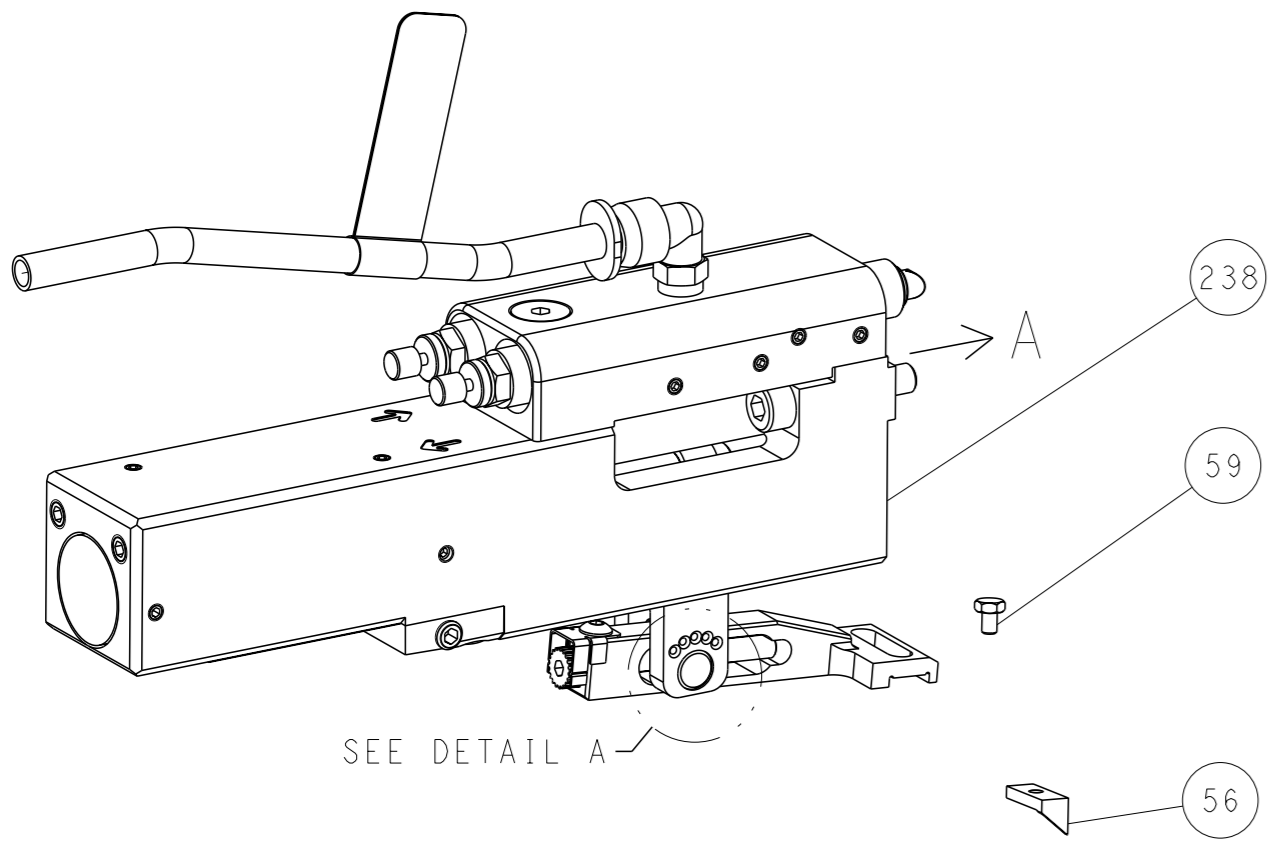
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		NAME	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	FINISH	APVD
MATERIAL				WEIGHT		SCALE	
-				-		1:2	
-				-		SHEET 3 OF 4	
-				-		REV B	

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

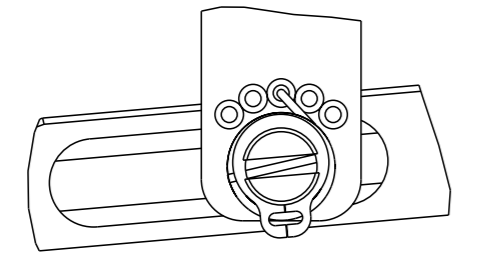
FEED TYPE MECHANICAL



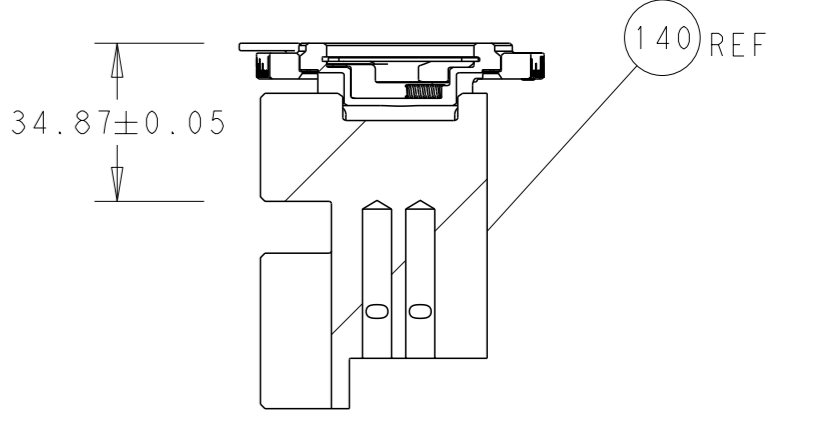
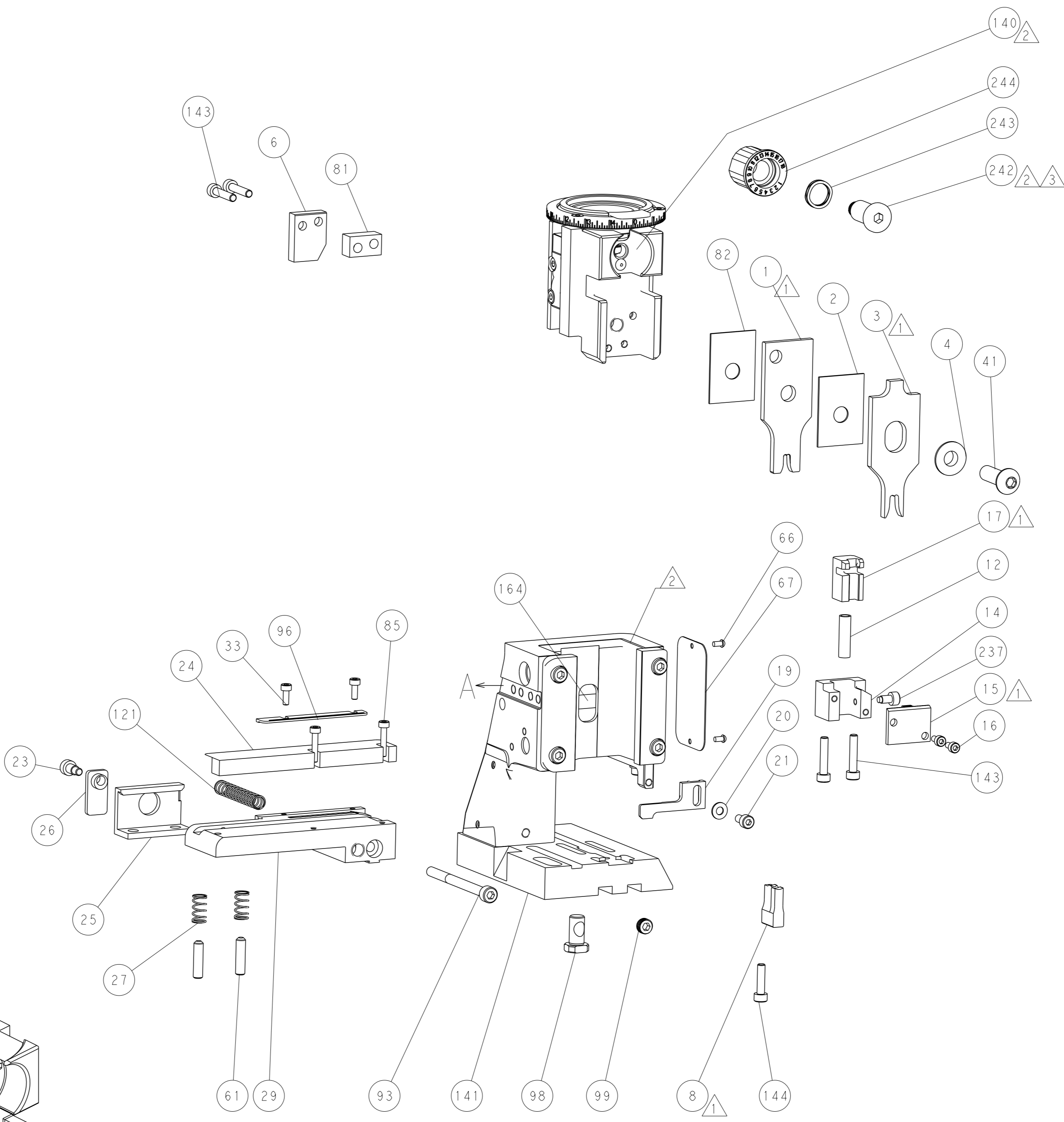
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

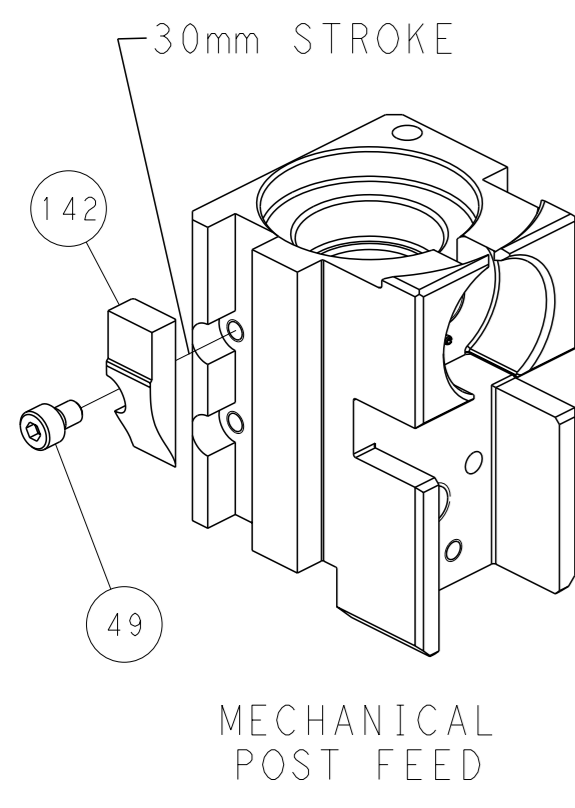


DETAIL A

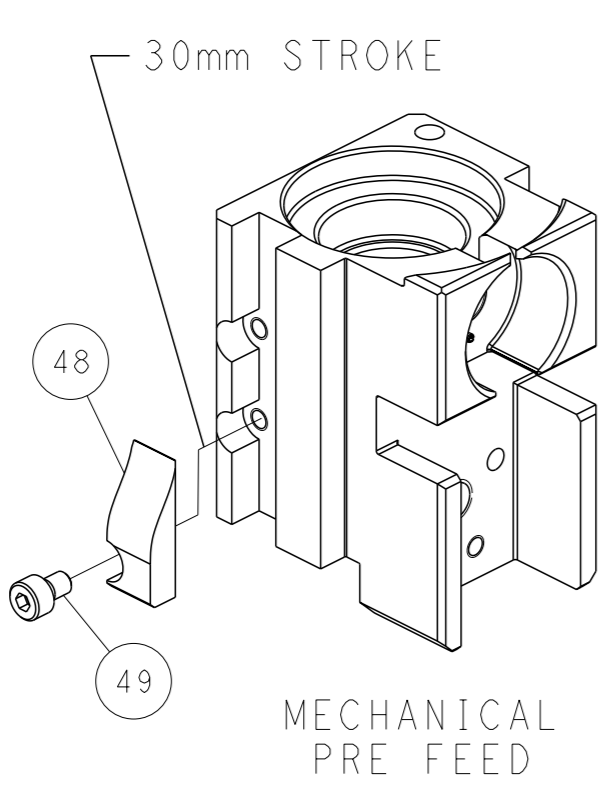


RAM SET-UP

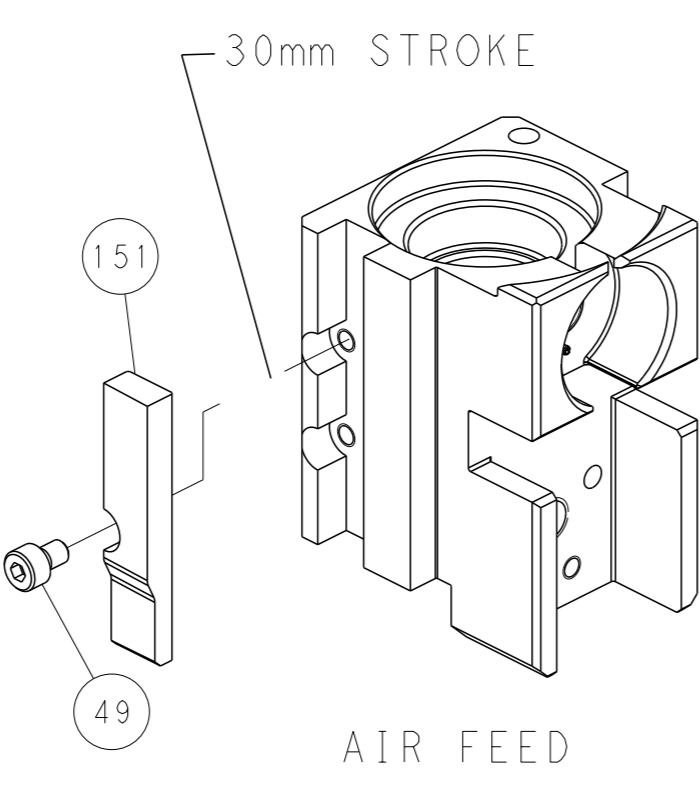
CAM POSITIONS



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 CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: B. WEAVER 13MAY2015 CHK: G. BAILEY 13MAY2015 APVD: G. BAILEY 13MAY2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH *	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266789	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: B