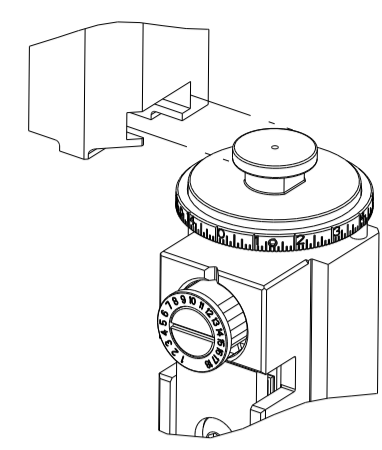


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266423-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266423-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266423-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266423-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266423-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.83 mm [.072]	F
INSUL	3.05 mm [.120]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL, MALE				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE			
3.75-4.51 mm [.148-.178 IN]	Ø			
TERMINAL APPLICATION (A) DELPHI CRIMP INFORMATION SHEET 15482324 PG. 4 OF 11 SPECIFICATION (B) DELPHI CRIMP INFORMATION SHEET 15482327 PG. 2 OF 7				
TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
(A) 2113537-1	(A) 15482324	2113123-1	15339560	1.7 - 1.9 mm
(B) 2113537-2	(B) 15482327	2113123-2	15344938	1.2 - 1.6 mm

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL, MALE				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE			
3.75-4.51 mm [.148-.178 IN]	Ø			
TERMINAL APPLICATION (A) DELPHI CRIMP INFORMATION SHEET 13894085 PG. 1 OF 1 SPECIFICATION				
TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
(A) 2113537-3	(A) 13894085	2113385	15344938	1.2 - 1.6 mm
		2113123-1	15339560	1.7 - 1.9 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.20+/-0.05 [.047+/- .002]	8.7
0.50mm2	1.10+/-0.05 [.043+/- .002]	9.8

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.20+/-0.05 [.047+/- .002]	10.3
0.50mm2	1.05+/-0.05 [.041+/- .002]	11.8

- 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. 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.

**\*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	LTN	DESCRIPTION	DATE	OWN	APVD
A	66			RELEASED	24OCT2014	MR	GB
				ECR-20-003976	17MAR2020	TB	RK
				ECR-22-139711	19MAY2022	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	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	455888-7	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	1	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	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	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	9-1633927-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
-	1	2	2	1	1	8-568176-7	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	ITEM NO	

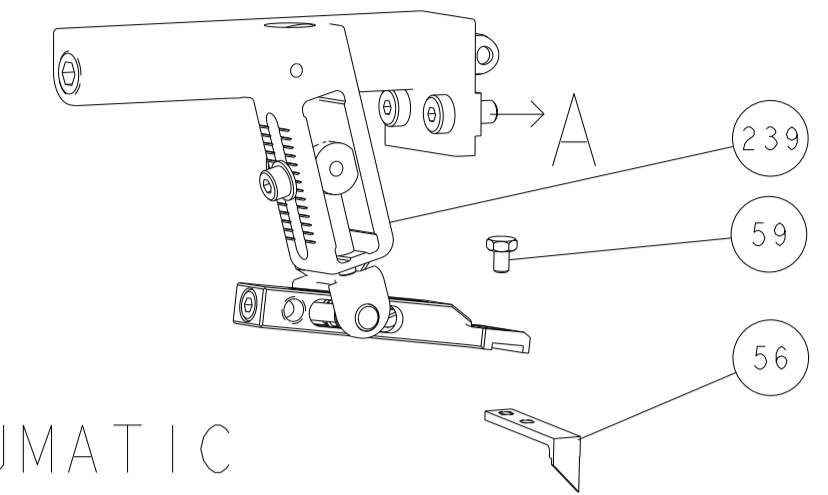
ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
0 PLC	±	0.13	±	04AUG2014	Customer Accessible Production Drawing		
1 PLC	±	0.25	±	04AUG2014	SCALE 1:2 SHEET 1 OF 4 REV B1		
2 PLC	±	0.38	±	04AUG2014			
3 PLC	±	0.51	±	04AUG2014			
4 PLC	±	0.64	±	04AUG2014			
ANGLES	±	0.25	±	04AUG2014			
FINISH	±	0.25	±	04AUG2014			

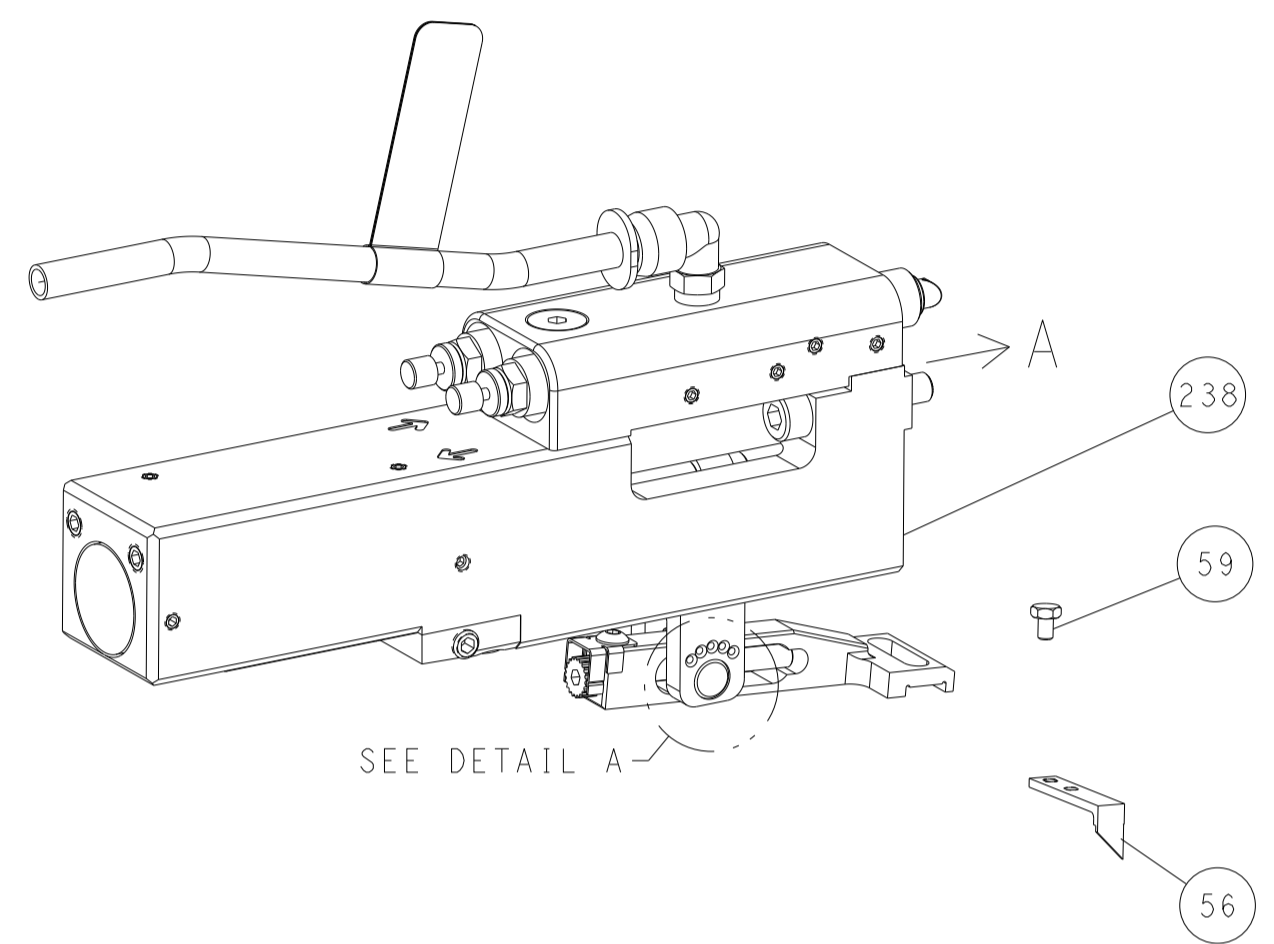
Customer Accessible Production Drawing

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			

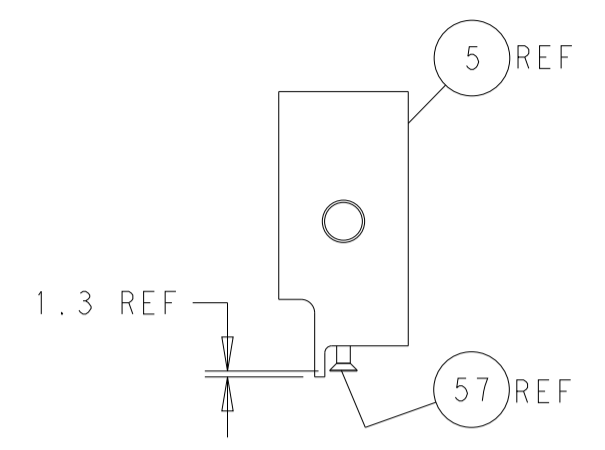
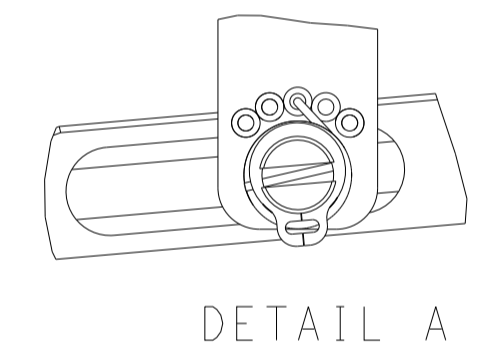
# FEED TYPE MECHANICAL



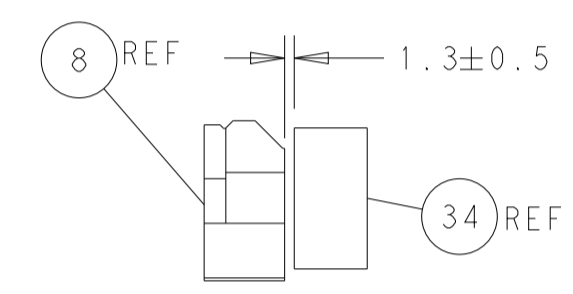
## PNEUMATIC



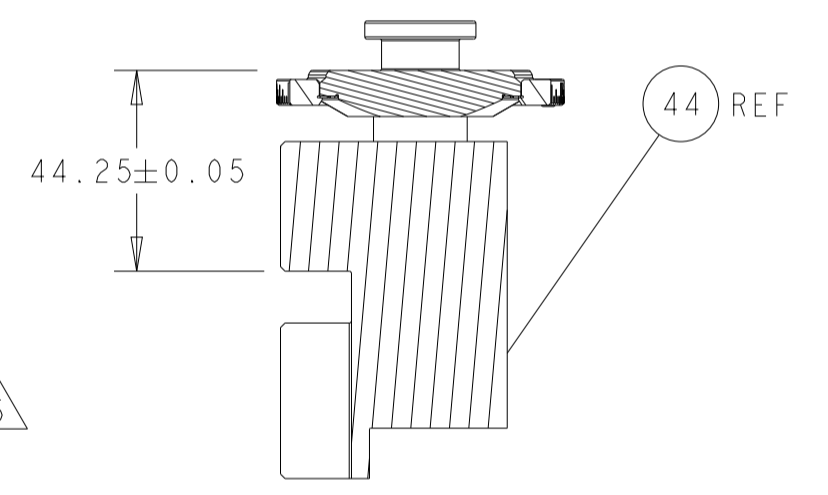
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



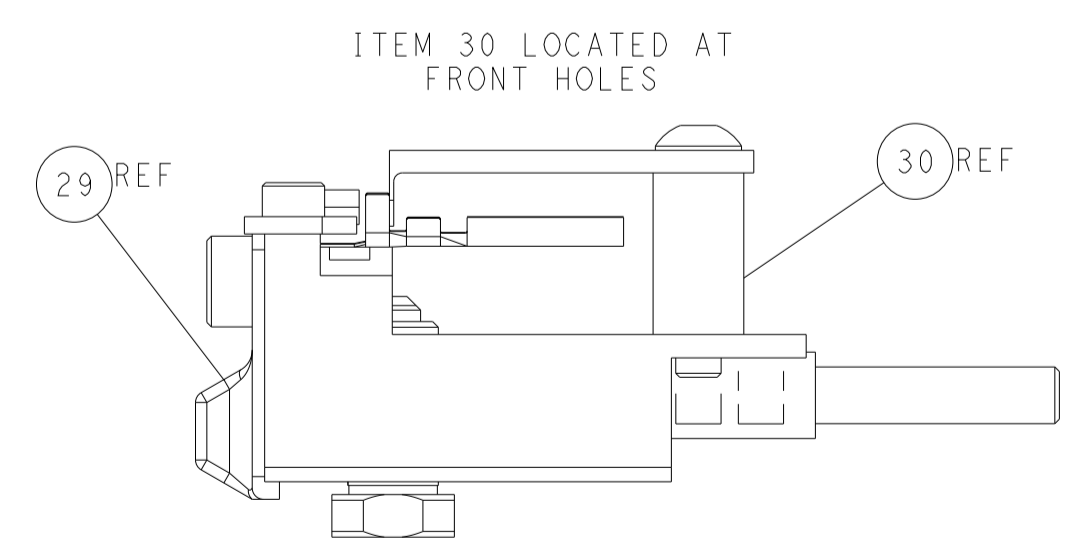
SHEAR DEPRESSOR DETAIL



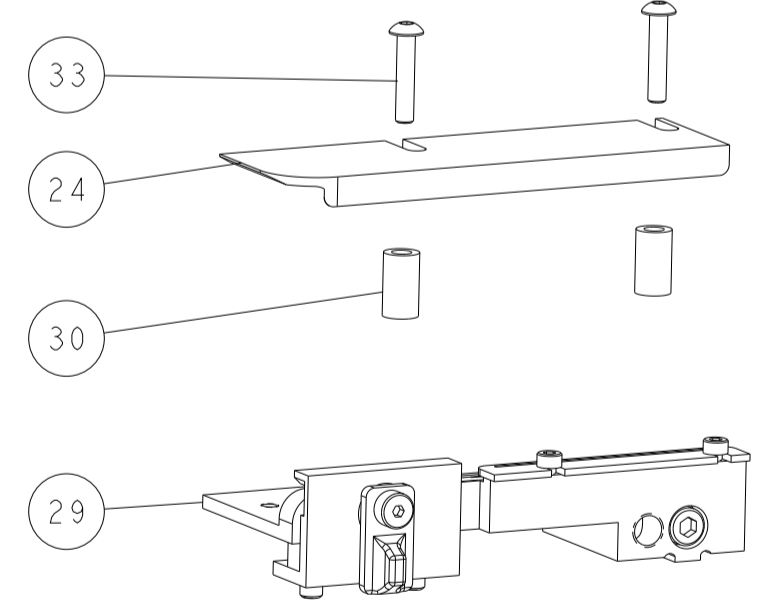
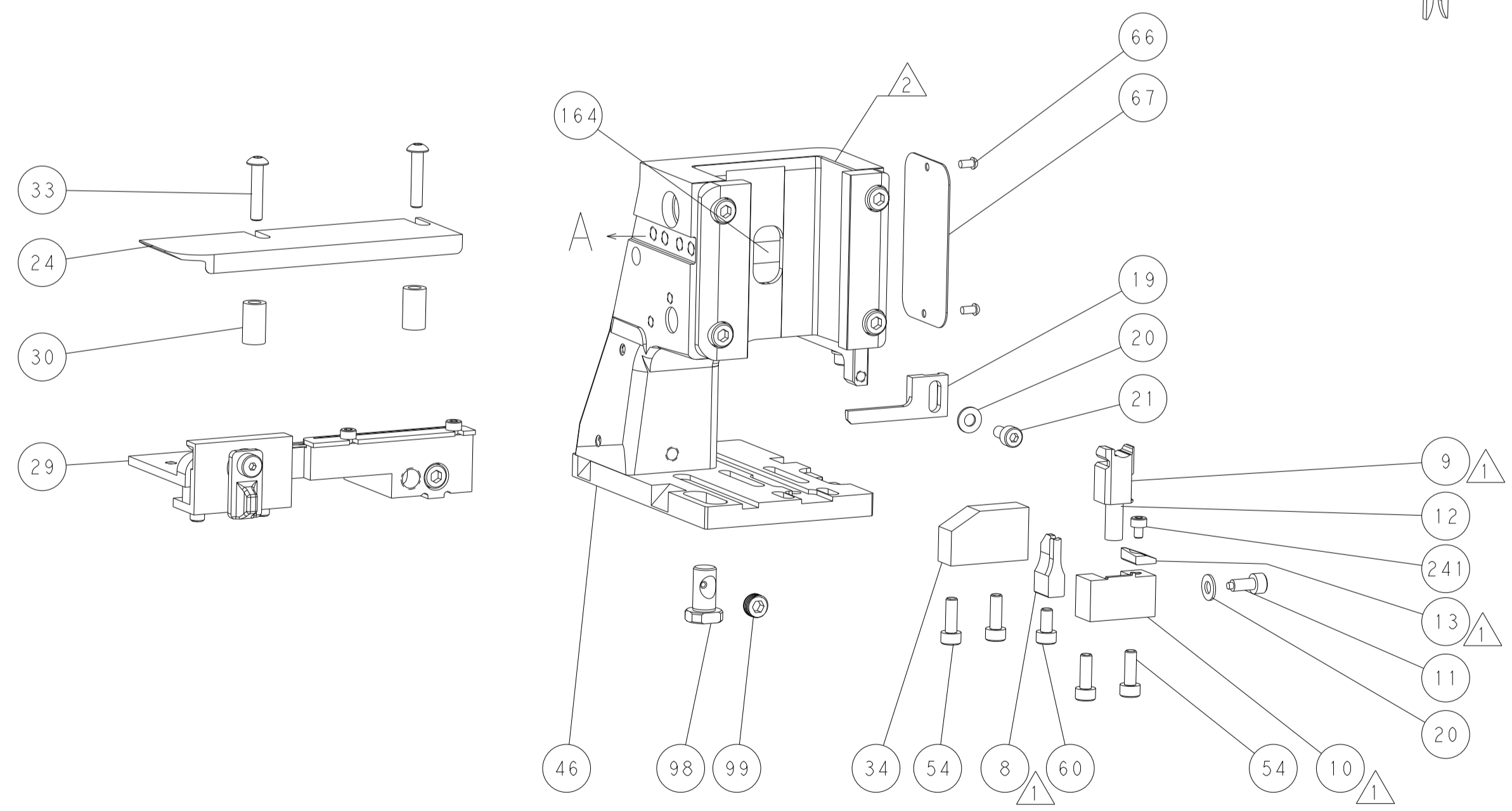
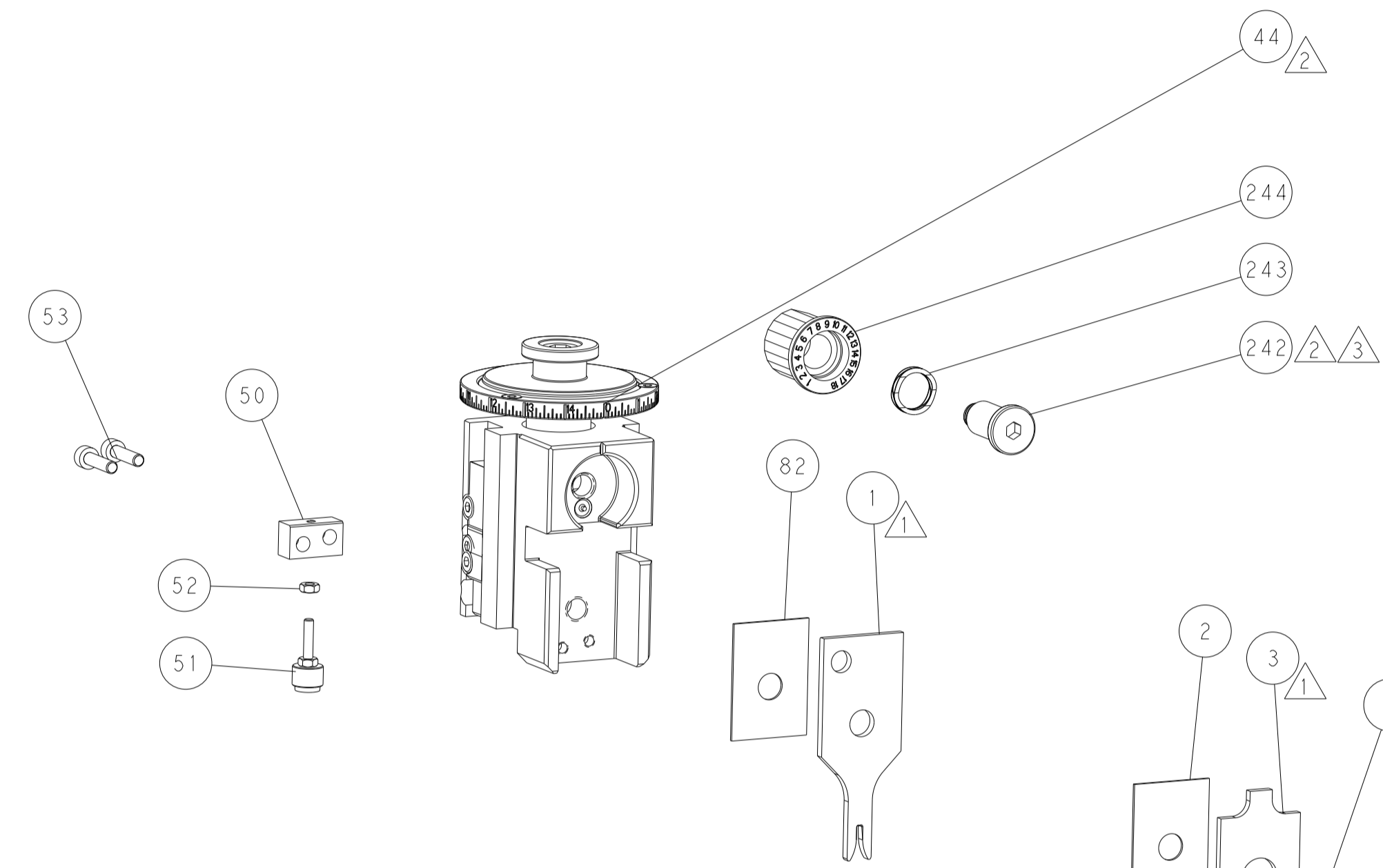
TERMINAL SUPPORT LOCATION



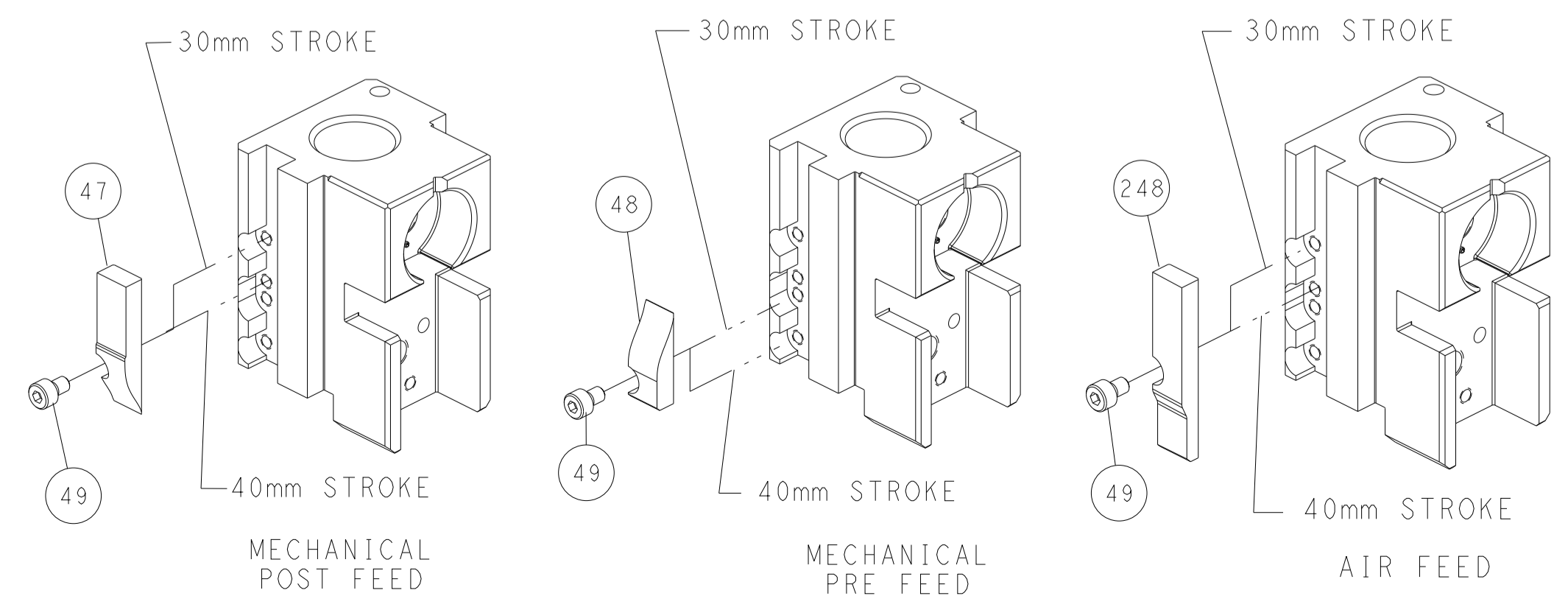
RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL



# CAM POSITIONS

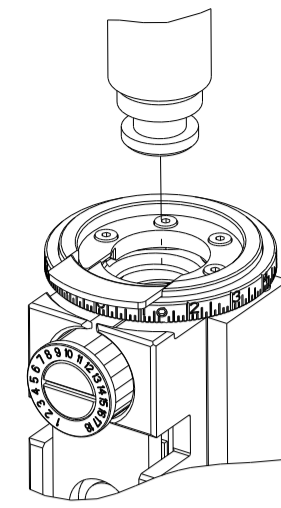


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: STAKEM 04AUG2014 CHK: G. BAILEY 04AUG2014 APVD: T. ELBIN 04AUG2014 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266423 WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: B1		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL: -				Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266423-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266423-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266423-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.83 mm [.072]	F
INSUL	3.05 mm [.120]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL, MALE				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE			
3.75-4.51 mm [.148-.178 IN]	∅			
TERMINAL APPLICATION (A) DELPHI CRIMP INFORMATION SHEET 15482324 PG. 4 OF 11 SPECIFICATION (B) DELPHI CRIMP INFORMATION SHEET 15482327 PG. 2 OF 7				
TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
(A) 2113537-1	(A) 15482324	2113123-1	15339560	1.7 - 1.9 mm
(B) 2113537-2	(B) 15482327	2113123-2	15344938	1.2 - 1.6 mm

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL, MALE				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE			
3.75-4.51 mm [.148-.178 IN]	∅			
TERMINAL APPLICATION (A) DELPHI CRIMP INFORMATION SHEET 13894085 PG. 1 OF 1 SPECIFICATION				
TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
(A) 2113537-3	(A) 13894085	2113385	15344938	1.2 - 1.6 mm
		2113123-1	15339560	1.7 - 1.9 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.20+/-0.05 [.047+/- .002]	8.7
0.50mm2	1.10+/-0.05 [.043+/- .002]	9.8

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.20+/-0.05 [.047+/- .002]	10.3
0.50mm2	1.05+/-0.05 [.041+/- .002]	11.8

- 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 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.
- 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					
		P	LTN	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
3	-	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	455888-7	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
5	-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	9-1633927-9	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	8-568176-7	CRIMPER, WIRE	1

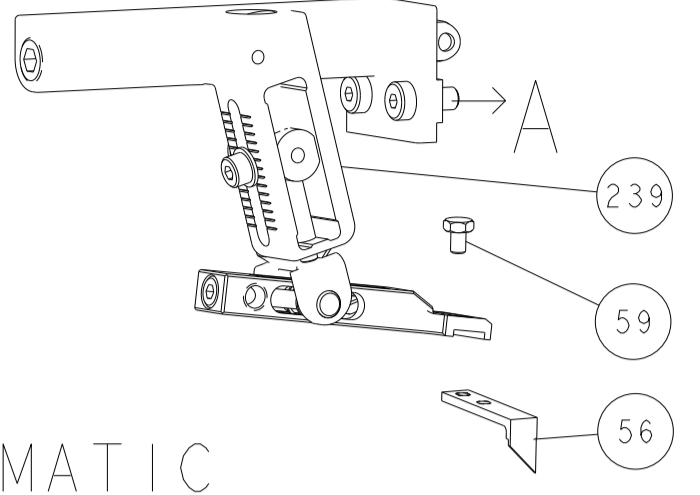
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL				WEIGHT	SCALE	SHEET	REV
Customer Accessible Production Drawing				00779	1:2	3 of 4	B1

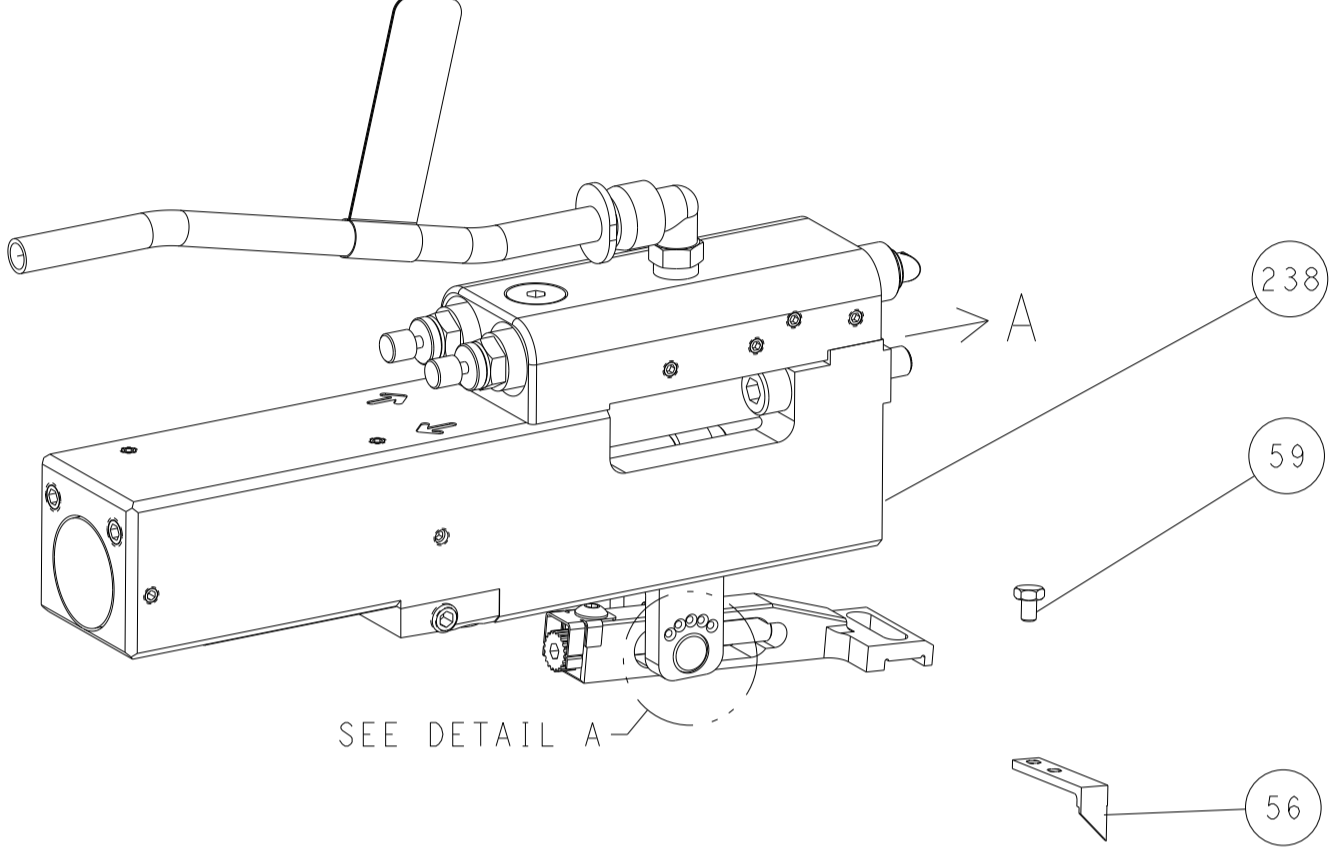
STC TE Connectivity  
Harrisburg, PA 17105-3608  
Ocean Side Feed  
Applicator

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

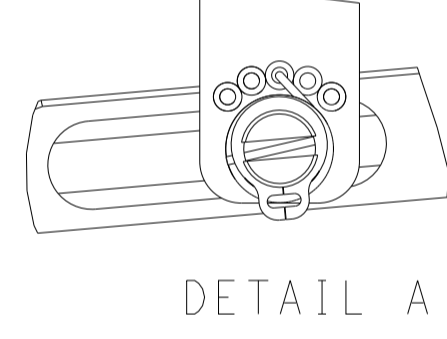
# FEED TYPE MECHANICAL



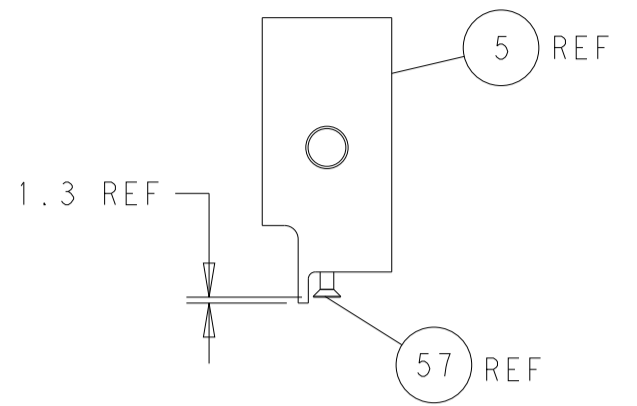
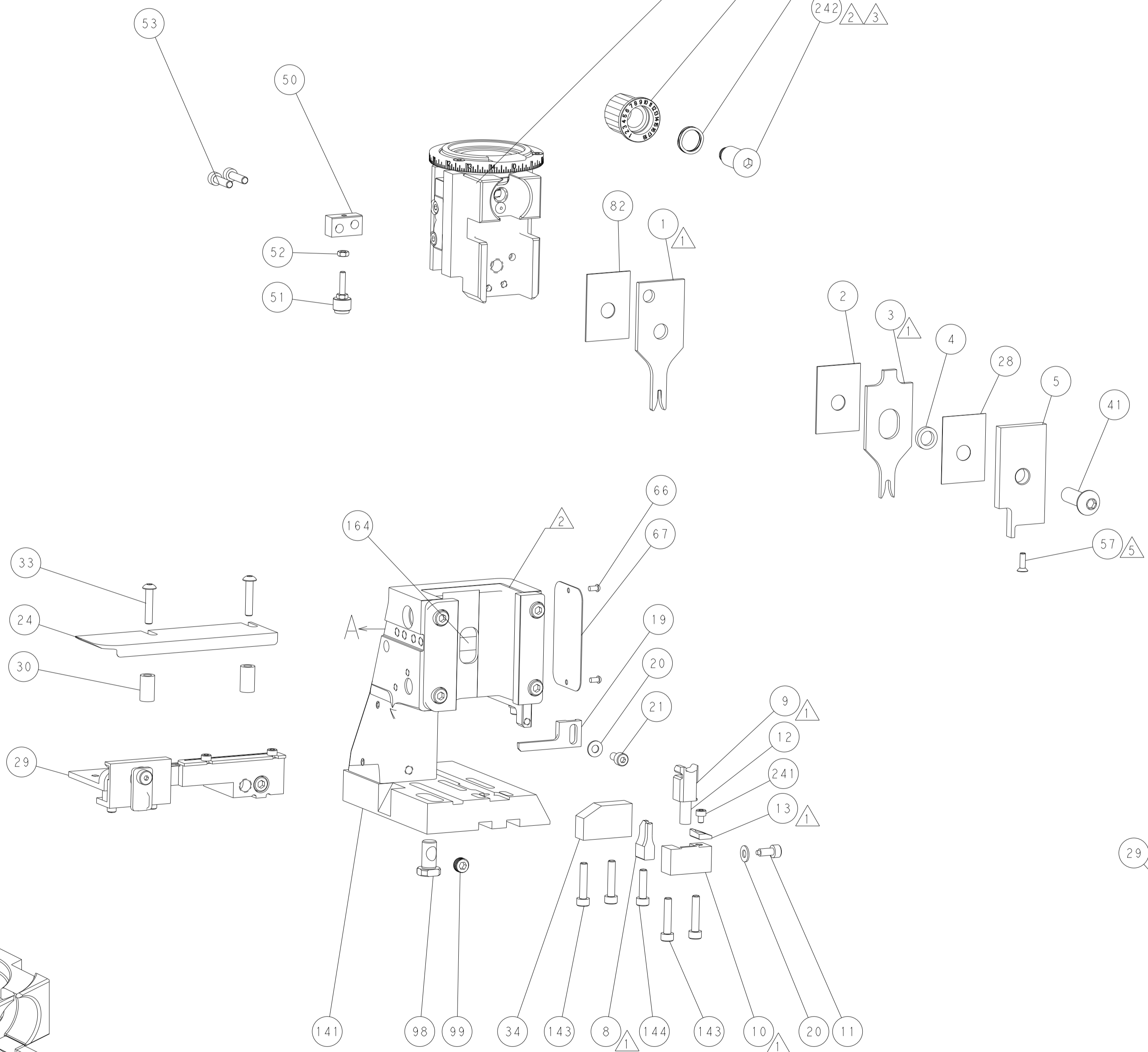
## PNEUMATIC



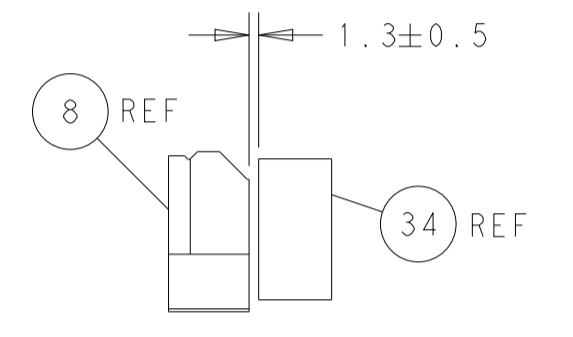
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



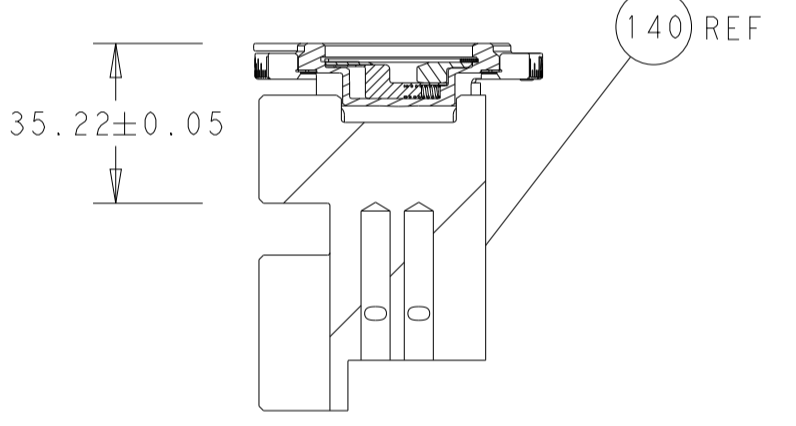
DETAIL A



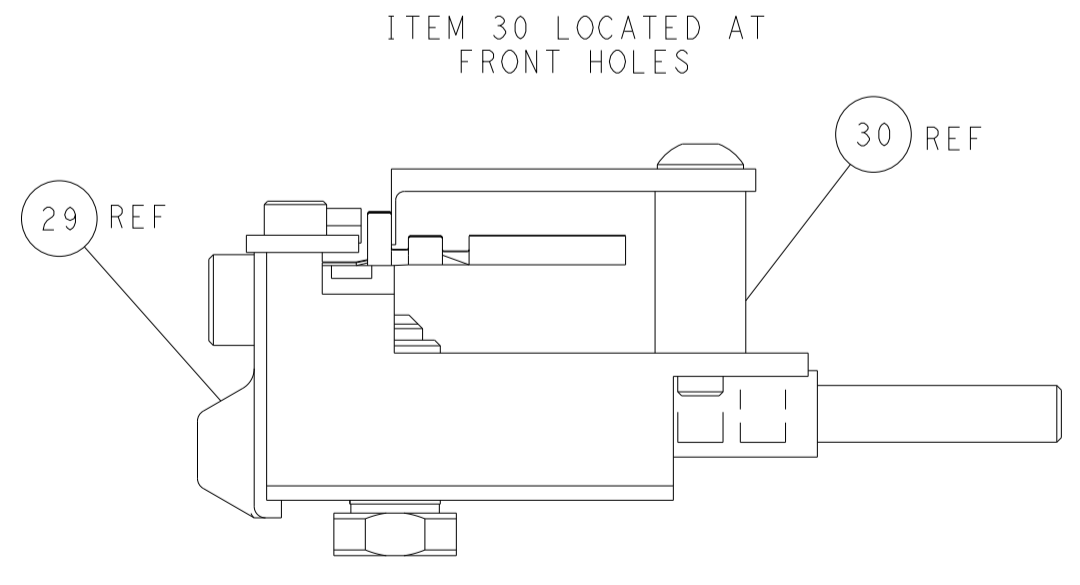
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

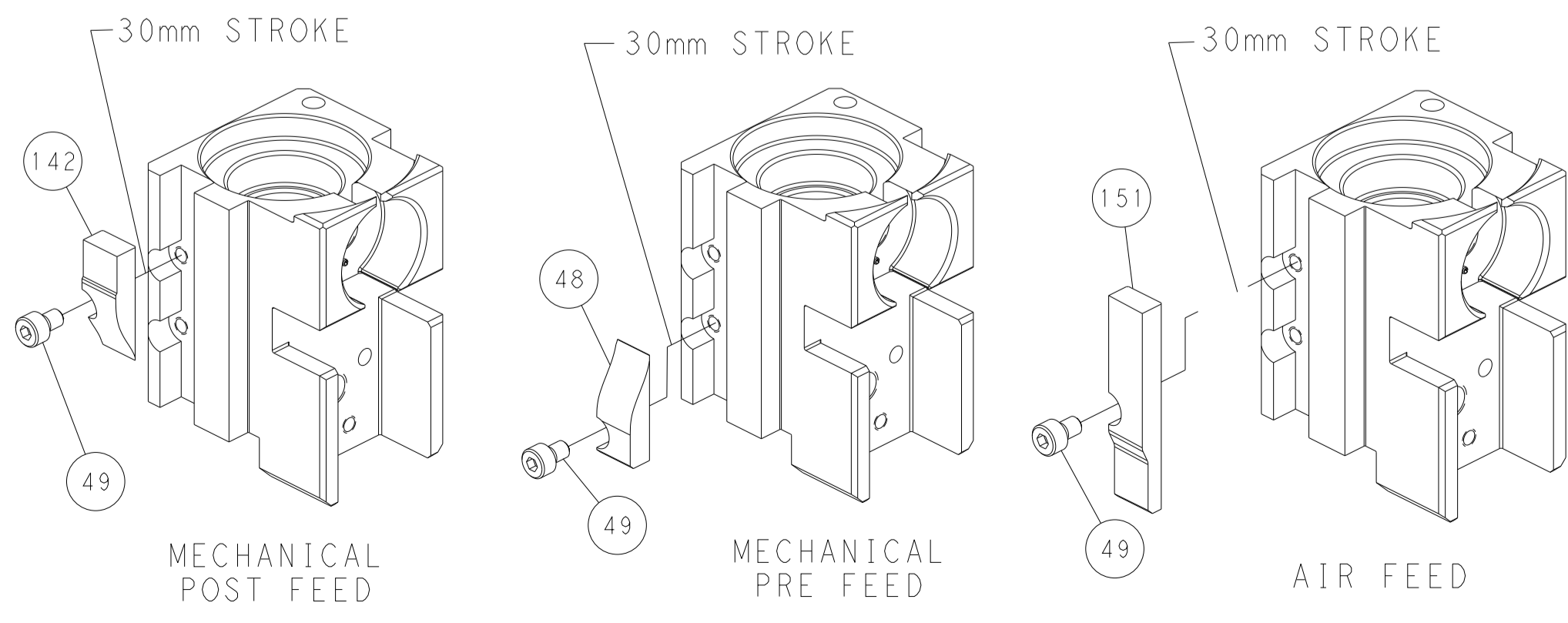


RAM SET-UP



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 UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2000 BY TYCO ELECTRONICS CORPORATION. THIS DRAWING IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: R. STAKEM 04AUG2014 CHK: G. BAILEY 04AUG2014 APVD: T. ELBIN 04AUG2014	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC: - PRODUCT SPEC: - MATERIAL: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266423	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: B1