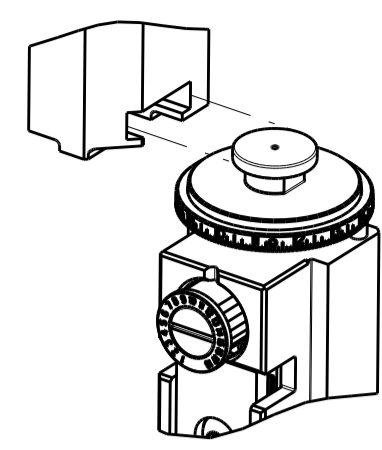


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266311-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266311-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266311-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266311-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266311-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.90 mm [.114]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.98-5.74 mm [.196-.226 IN]	Ø1.20-2.25 mm [.047-.089 IN]
TERMINAL APPLICATION SPECIFICATION	DELPHI SPEC

TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
1949044-1	15326267	1949045-1	15305351	1.7-2.1 mm
		1832359-1	15366060	1.9-2.3 mm
		1949130-4	15344324	1.2-2.1 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30 +/- 0.05 [.051 +/- .002]	5.8
0.80mm2	1.25 +/- 0.05 [.049 +/- .002]	6.2
0.75mm2	1.25 +/- 0.05 [.049 +/- .002]	6.2

- 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 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.

**\*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)

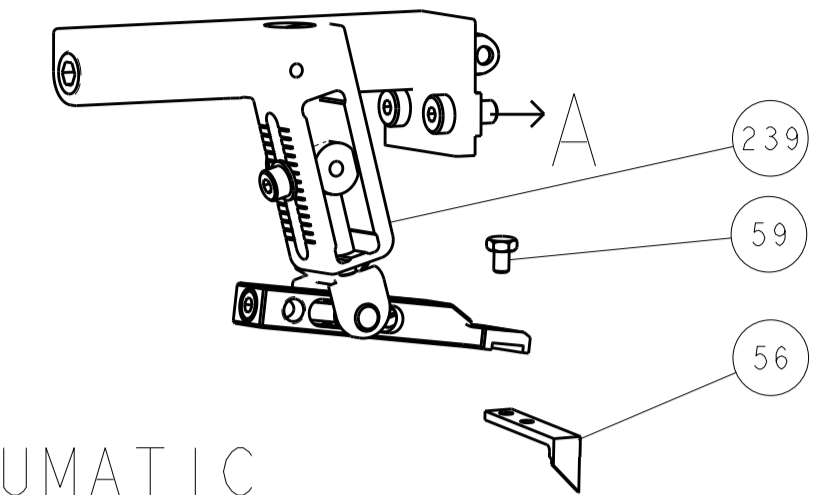
LOC	DIST	REV	DATE	BY	CHKD	APP'D
A	66	1	10JUN2014	Y. YIN	G. BAILEY	J. GUO

REV	DATE	BY	CHKD	APP'D	DESCRIPTION	ITEM NO
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	FEED CAM, AIR FEED	248
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	CAM, SNAIL, INSULATION ADJUSTMENT	244
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	WASHER, WAVE SPRING, CREST-TO-CREST	243
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	RETAINER, INSULATION DIAL	242
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCR, SKT HD CAP M3 X 4.0	241
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	MECHANICAL FEED ASSEMBLY	239
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	AIR FEED MODULE	238
REF	REF	REF	REF	REF	COUNTER, MAGNETIC	164
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCREW, LOCKING	99
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	POST, LOCKING	98
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SPACER, CRIMPER	82
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	DOCUMENTATION PACKAGE	71
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	TAG, IDENTIFICATION	67
2	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCREW, DRIVE, RH, RoHS, 2 x .188	66
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCR, HEX HD CAP, M4 X 6.0	59
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCR, FLT SKT HD CAP M3 X 10.0	57
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	PAWL, FEED	56
4	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
2	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCR, SKT HD CAP, RoHS, M4 X 10	53
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	NUT, HEX, REG, RoHS, M3	52
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	BUMPER, HOLD DOWN	51
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SPACER, TONKER	50
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCR, SKT HD CAP M4 X 6.0	49
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	FEED CAM, PRE FEED	48
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	FEED CAM, POST FEED	47
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	APPLICATOR BASIC ASSEMBLY, SF	46
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	RAM ASSEMBLY, SF ATLANTIC	44
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCR, BHSC, RoHS (M8 X 25)	41
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SUPPORT, TERMINAL	34
2	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCR, BHSC, RoHS (M4 X 20)	33
2	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SPACER, CYLINDRICAL, STRIP GUIDE	30
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	ASSEMBLY, STRIP GUIDE	29
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SPACER, CRIMPER	28
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	STRIP GUIDE	24
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
2	10JUN2014	Y. YIN	G. BAILEY	J. GUO	WASHER, FLAT, REG M4	20
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	STRIPPER, SIDE FEED	19
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	INSERT, SHEAR	13
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SPRING, COMPRESSION	12
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	STOP, SHEAR	11
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SHEAR HOLDER, FRONT	10
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	FLOATING SHEAR, FRONT	9
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	DEPRESSOR, SHEAR	5
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	BLOCK, CRIMPER SPACER	4
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	CRIMPER, INSULATION O PREMIUM	3
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	SPACER, CRIMPER	2
1	10JUN2014	Y. YIN	G. BAILEY	J. GUO	CRIMPER, WIRE PREMIUM	1

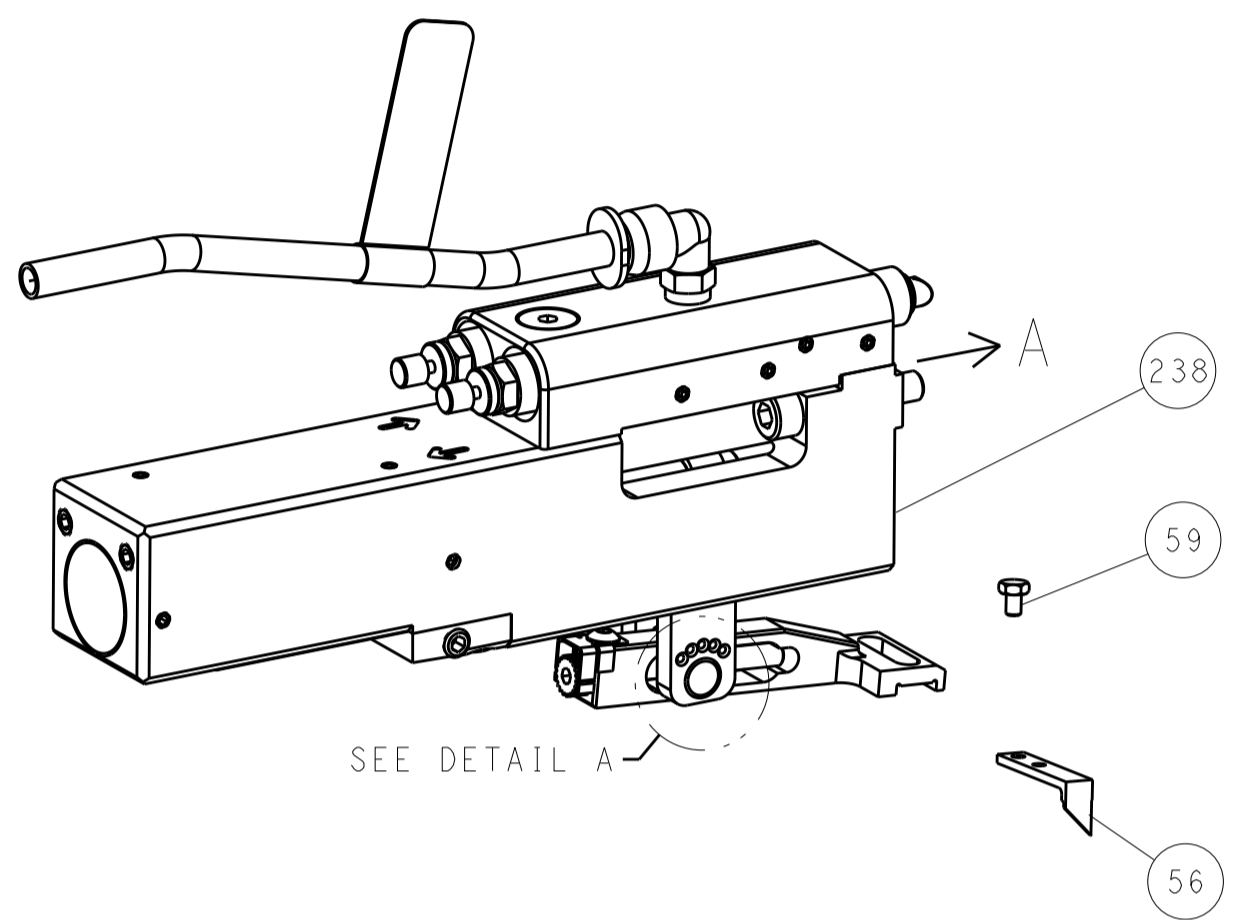
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	Customer Accessible Production Drawing	SCALE	1:2	SHEET 1 OF 4

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

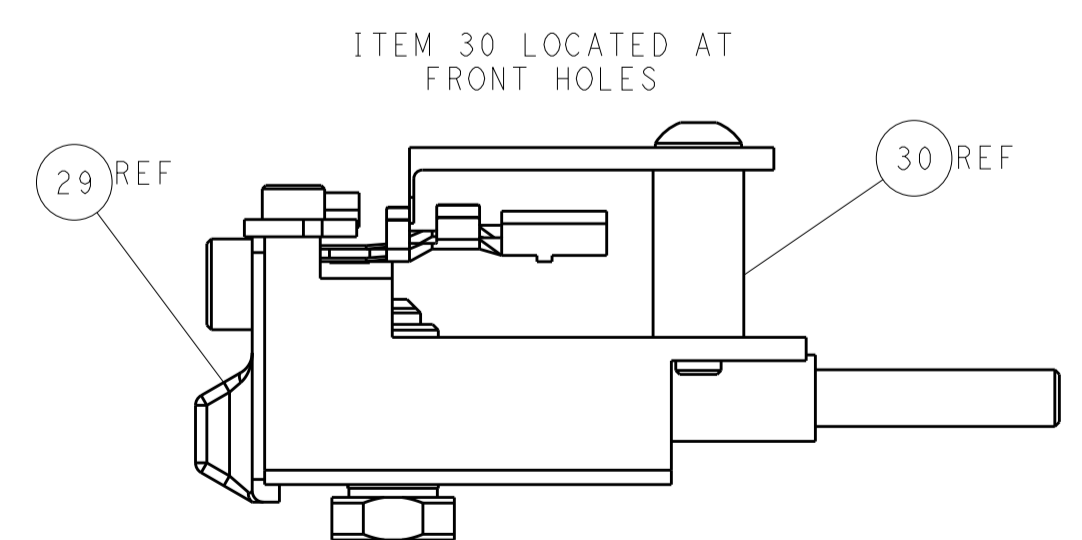
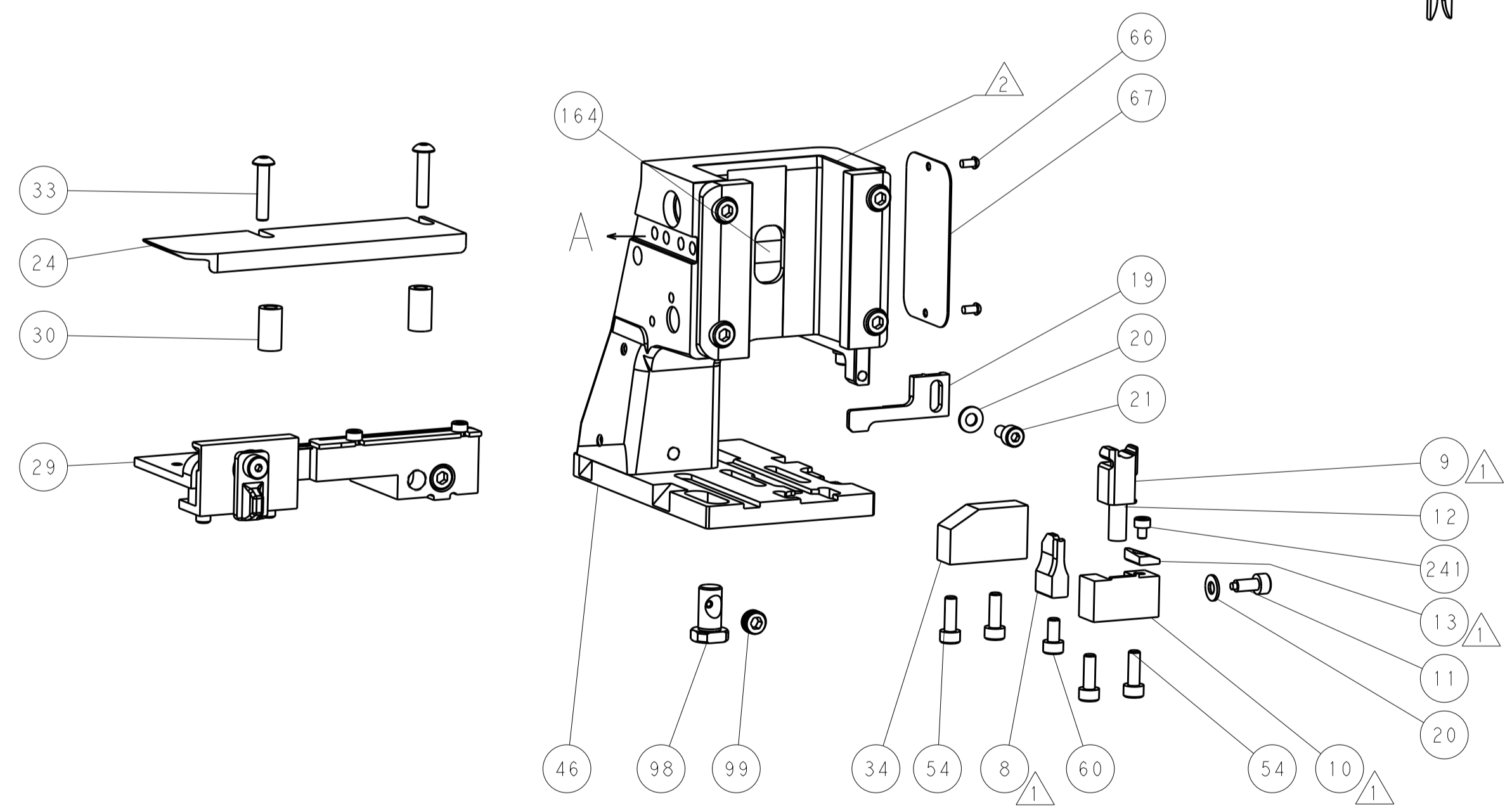
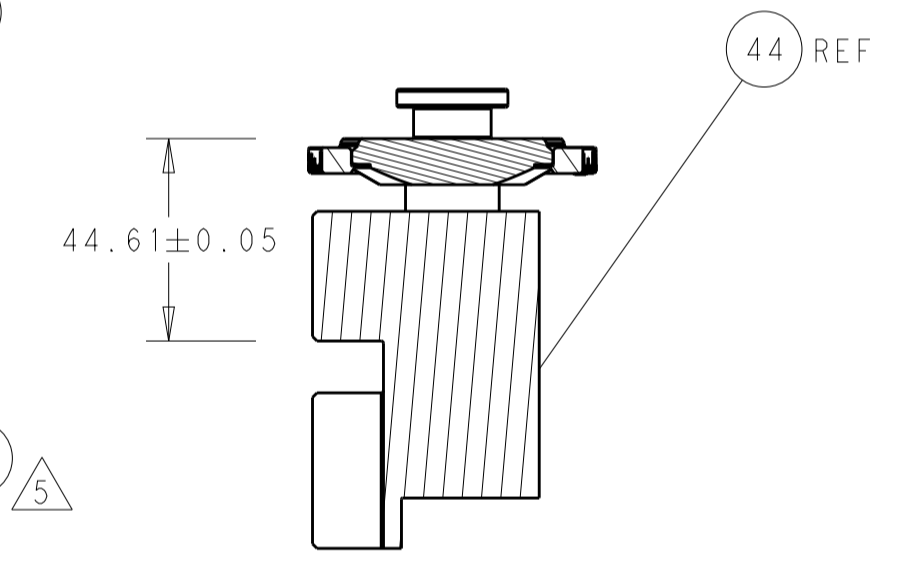
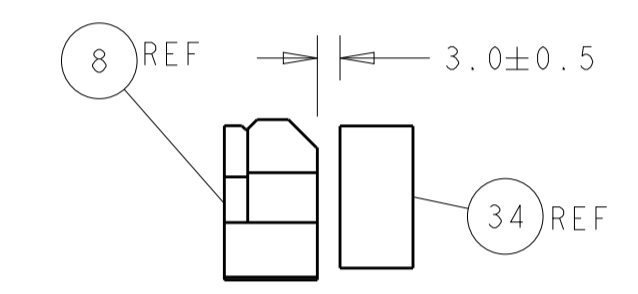
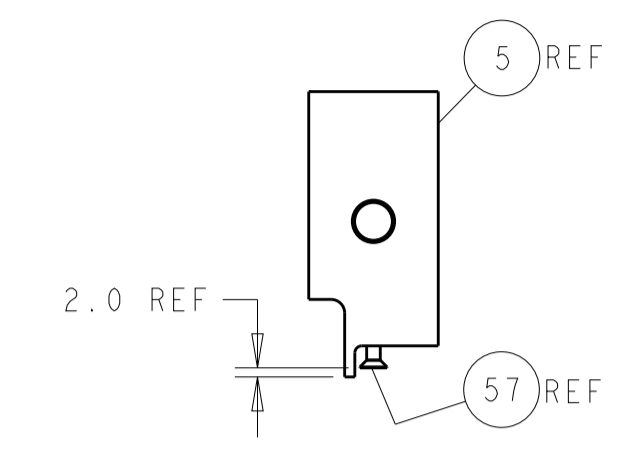
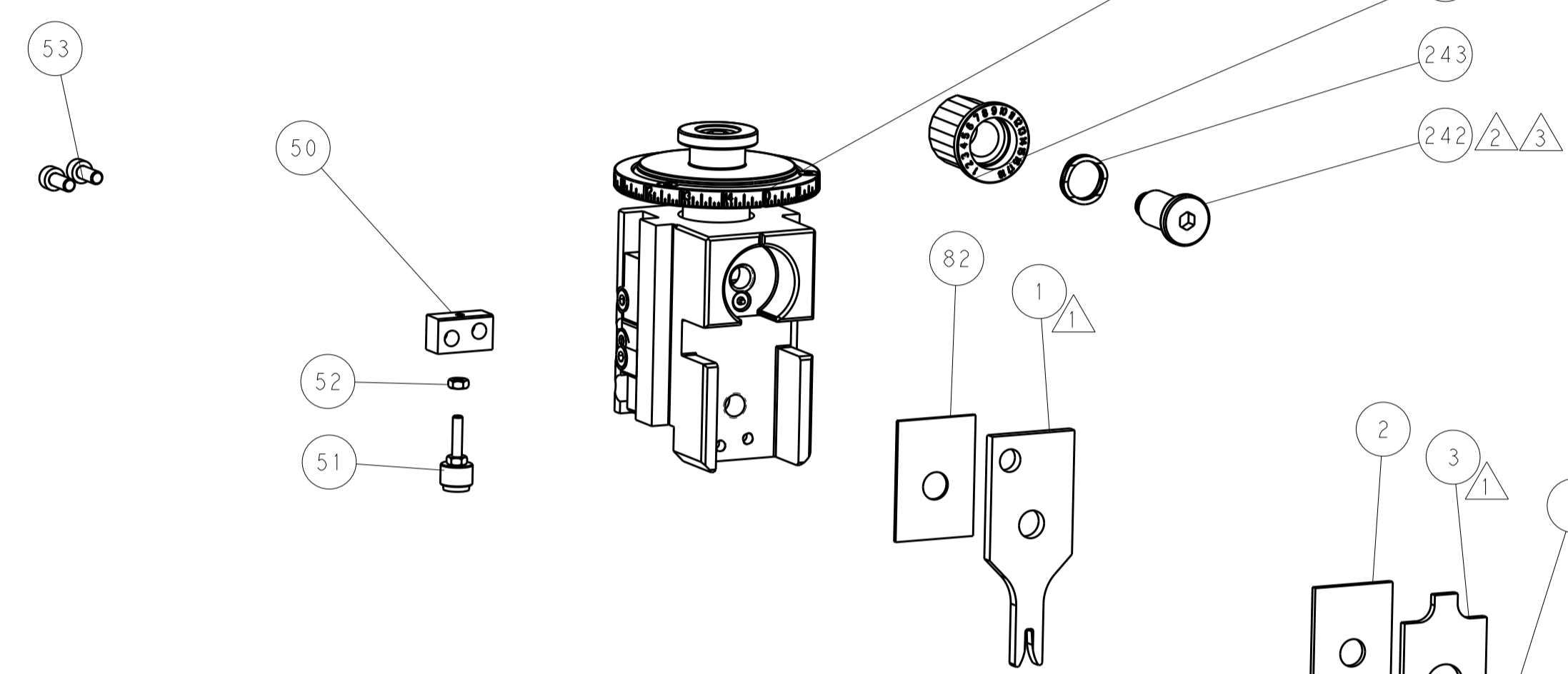
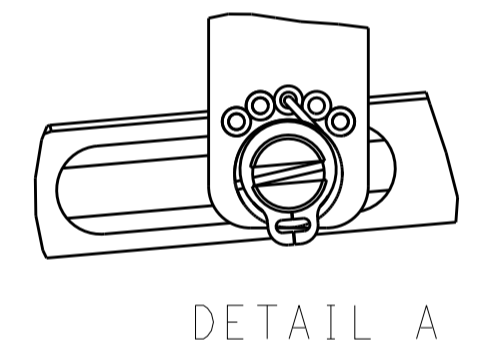
# FEED TYPE MECHANICAL



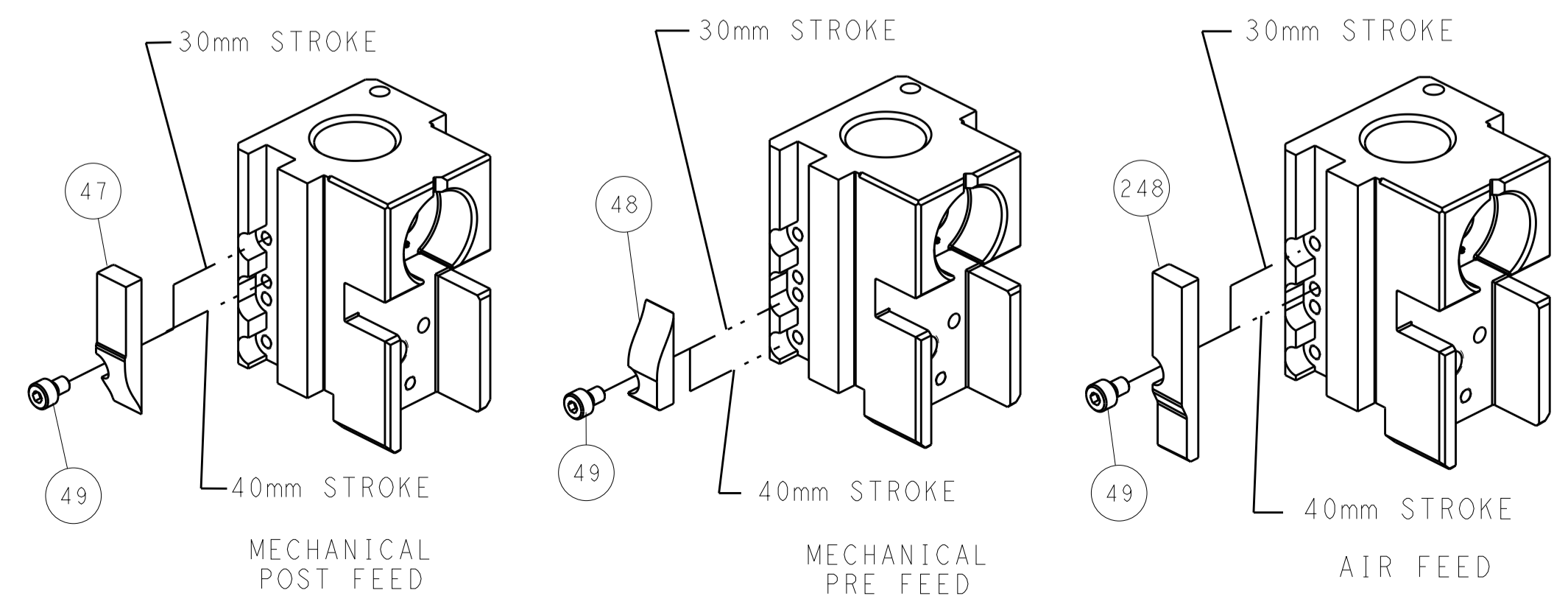
## PNEUMATIC



## 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>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS LOANED TO YOUR COMPANY BY THE TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER AND FOR THE PERIOD OF TIME SPECIFIED BY THE TYCO ELECTRONICS CORPORATION. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION AT THE END OF THE LOAN PERIOD. IT IS NOT TO BE REPRODUCED, COPIED, OR DISTRIBUTED TO ANY OTHER PERSON OR ORGANIZATION WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN T. YIN 10JUN2014 CHK G. BAILEY 10JUN2014 APVD H. GUO 10JUN2014	NAME Ocean Side Feed Applicator
DIMENSIONS: mm 0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ± ± ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO. A1 00779 ©=2266311 SHEET 2 OF 4 REV B

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266311-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266311-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266311-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



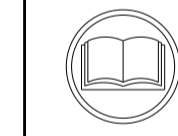
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.90 mm [.114]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.98-5.74 mm [1.96-.226 IN]	∅1.20-2.25 mm [.047-.089 IN]
TERMINAL APPLICATION SPECIFICATION	DELPHI SPEC

TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
1949044-1	15326267	1949045-1	15305351	1.7-2.1 mm
		1832359-1	15366060	1.9-2.3 mm
		1949130-4	15344324	1.2-2.1 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30+/-0.05 [1.051+/-0.002]	5.8
0.80mm2	1.25+/-0.05 [1.049+/-0.002]	6.2
0.75mm2	1.25+/-0.05 [1.049+/-0.002]	6.2



- 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.

**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	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	455888-8	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	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	1-1752356-8	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	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	2-1633920-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1-2119784-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-6	SPACER, CRIMPER	2
1	1	1	456405-8	CRIMPER, WIRE PREMIUM	1

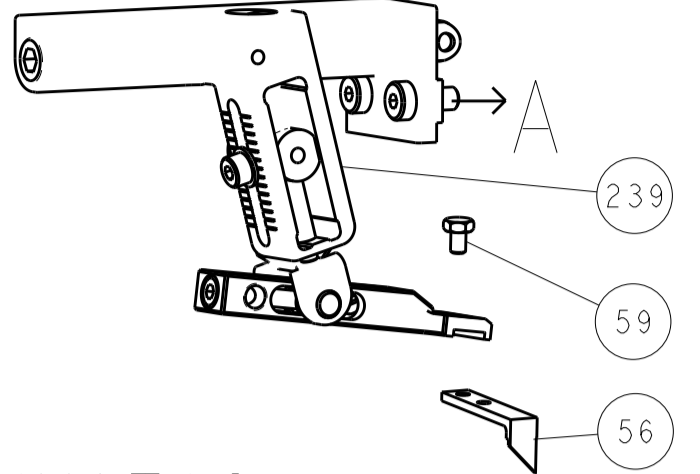
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

DATE	BY	CHK	APPD	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
10JUN2014	Y. YIN	G. BAILEY	H. GUO	TE Connectivity Harrisburg, PA 17105-3608	A1	00779	2266311	

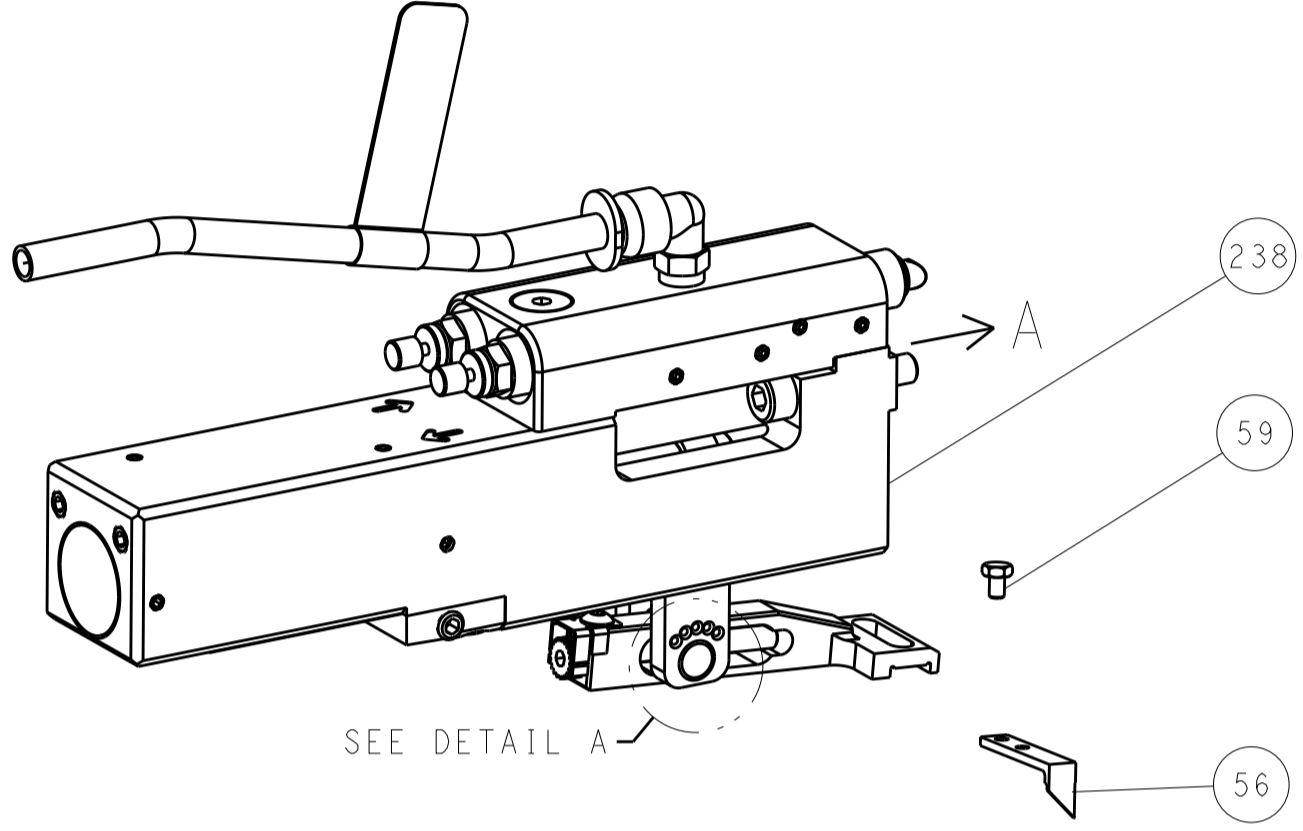
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B

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

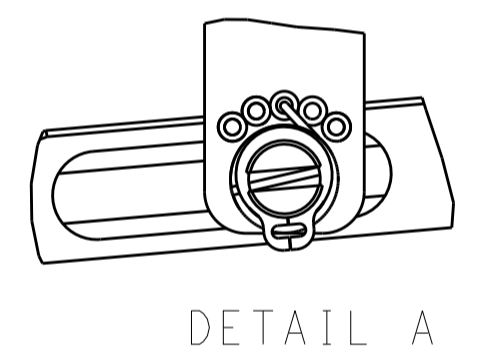
# FEED TYPE MECHANICAL



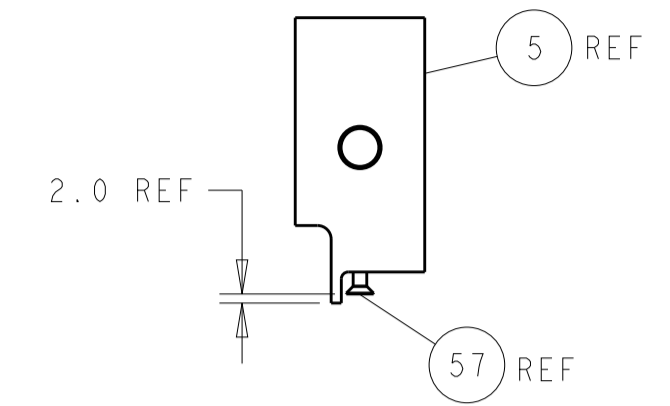
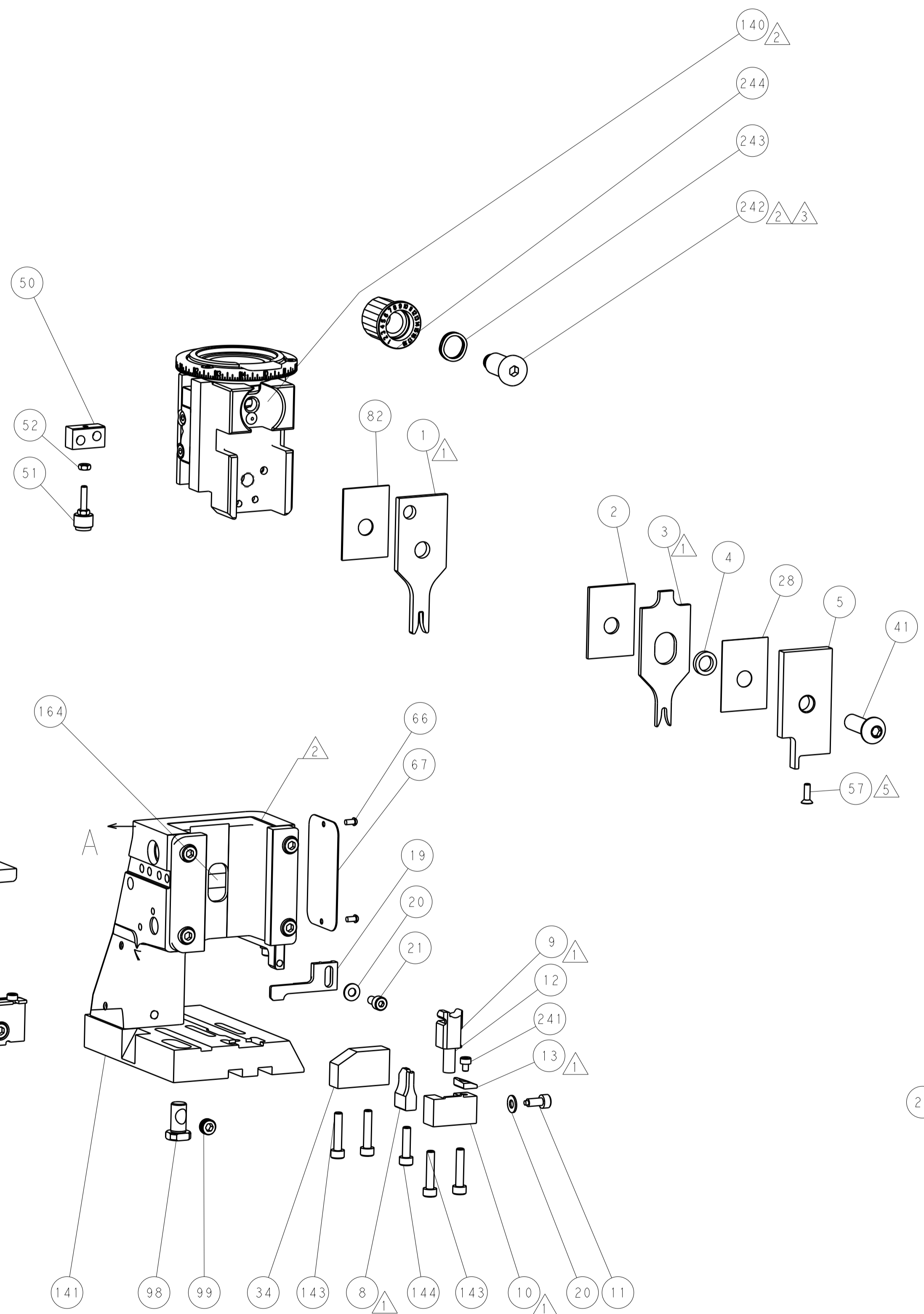
## PNEUMATIC



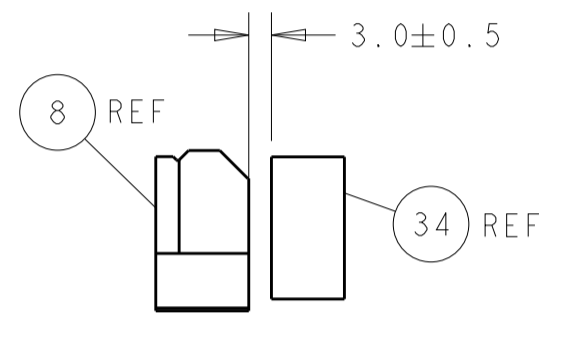
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



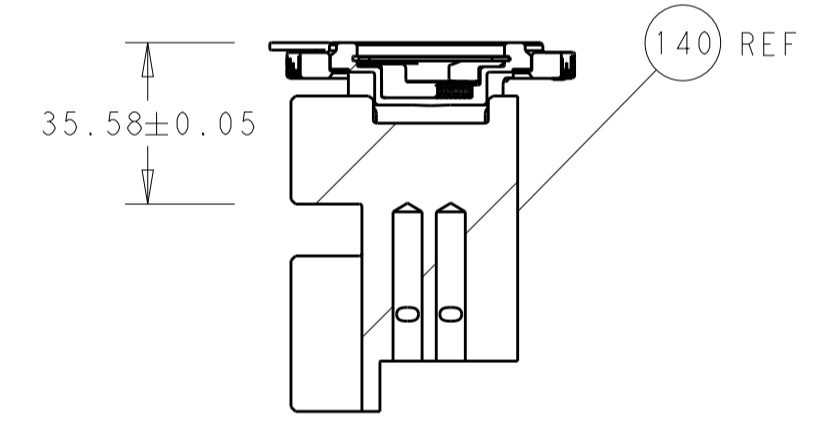
# CAM POSITIONS



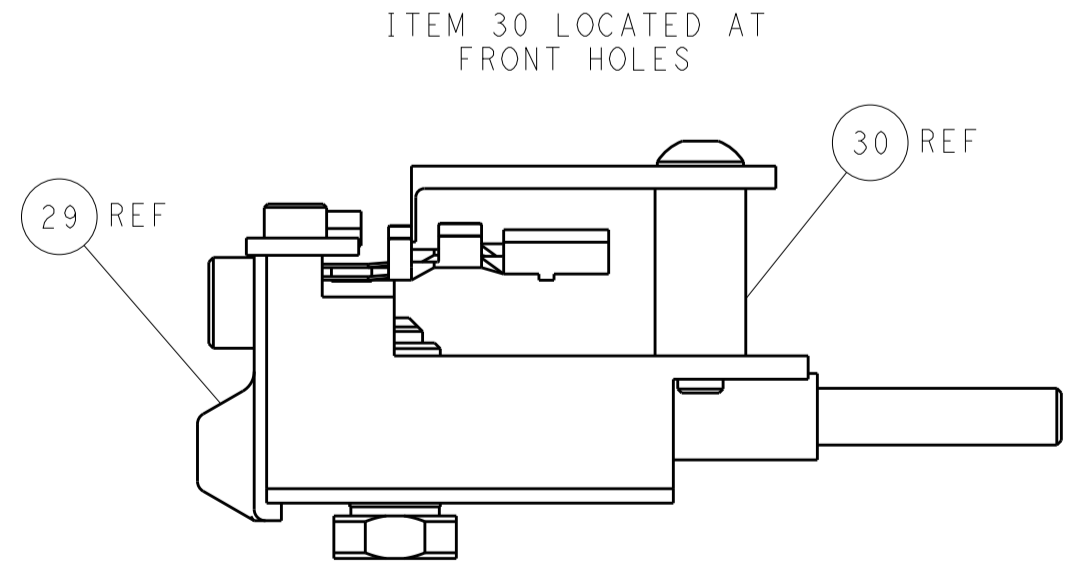
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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:		DWG: Y. YIN 10JUN2014		CHK: G. BAILEY 10JUN2014		APVD: H. GUO 10JUN2014		NAME: Ocean Side Feed Applicator		
mm	0 PLC	±		PRODUCT SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
	1 PLC	±		APPLICATION SPEC	A1	00779	2266311					
	2 PLC	±		WEIGHT	Customer Accessible Production Drawing		SCALE	1:2	SHEET	4	OF	4
	3 PLC	±		ANGLES					REV	B		
	4 PLC	±										