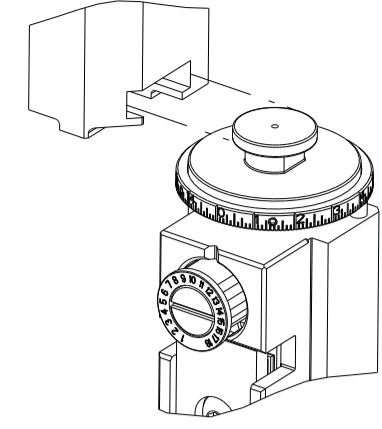


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2266588-1 | C | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2266588-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266588-1 | C | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2266588-2 | C | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2266588-7 | B | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.50 mm [.059] | F |
| INSUL | 1.90 mm [.075] | O |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION | | | |
|---|------------------------------|-------------|-----------------|
| TERMINAL NAME: DELPHI TERMINAL | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 3.10-3.30 mm [.122-.130 IN] | Ø1.10-1.48 mm [.043-.058 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | 15457847 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | DELPHI TERMINAL | TE TERMINAL | DELPHI TERMINAL |
| 2113623-1 | 15457847 | 2113623-2 | 13799599 |
| 2113623-3 | 35250566 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.35mm2 | 1.00 +/- 0.03 [.039 +/- .001] | 7.5 |

- 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 | REV | DATE | BY | CHKD |
| | | A | RELEASED | 03MAR2015 | JH |
| | | B | ECR-15-008832 | 11JUN2015 | YY |
| | | C | ECR-19-011741 | 25JUL2019 | FZ |
| | | C1 | ECR-22-157581 | 07NOV2022 | JAH |

| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----------------------|---|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 1 | 1 | 2119082-5 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | |
| 3 | - | 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 | 455888-6 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 | |
| - | 1 | 1 | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 | |
| - | 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 | 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 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 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 | 1-1752356-7 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2 | 2 | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 | |
| - | 1 | 1 | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 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 | 1803095-3 | FLOATING SHEAR, FRONT | 9 | |
| 1 | 1 | 2 | 2 | 1 | 1 | 4-1803056-2 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 5-238011-5 | BLOCK, CRIMPER SPACER | 4 | |
| 1 | 1 | 2 | 2 | 1 | 1 | 6-1803018-9 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 2 | |
| 1 | 1 | 2 | 2 | 1 | 1 | 8-1633588-0 | CRIMPER, WIRE | 1 |
| - | 77 | -72 | -71 | -2 | -1 | PART NO | ITEM NO | |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN | CHK | DATE |
|-------------|--------|--|--|----------|----------|----------|
| mm | 0 PLC | ± | | J. HOU | J. HOU | 5FEB2015 |
| | 1 PLC | ± | | L. ZHANG | L. ZHANG | 5FEB2015 |
| | 2 PLC | ± | | | | |
| | 3 PLC | ± | | | | |
| | 4 PLC | ± | | | | |
| | ANGLES | ± | | | | |
| | FINISH | ± | | | | |

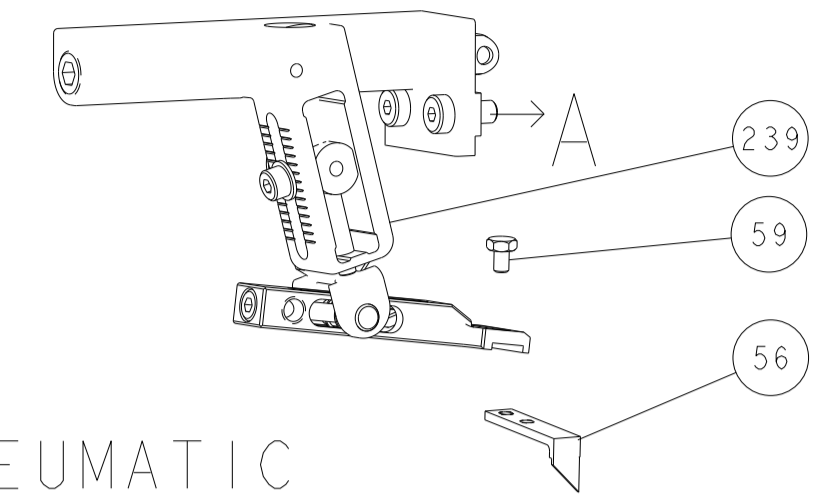
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|----------|--|--------|-------|--------|-----|
| MATERIAL | | WEIGHT | SCALE | SHEET | REV |
| - | | - | 1:2 | 1 OF 4 | C1 |

| | | | |
|--|--|--|--|
| Customer Accessible Production Drawing | | Customer Accessible Production Drawing | |
|--|--|--|--|

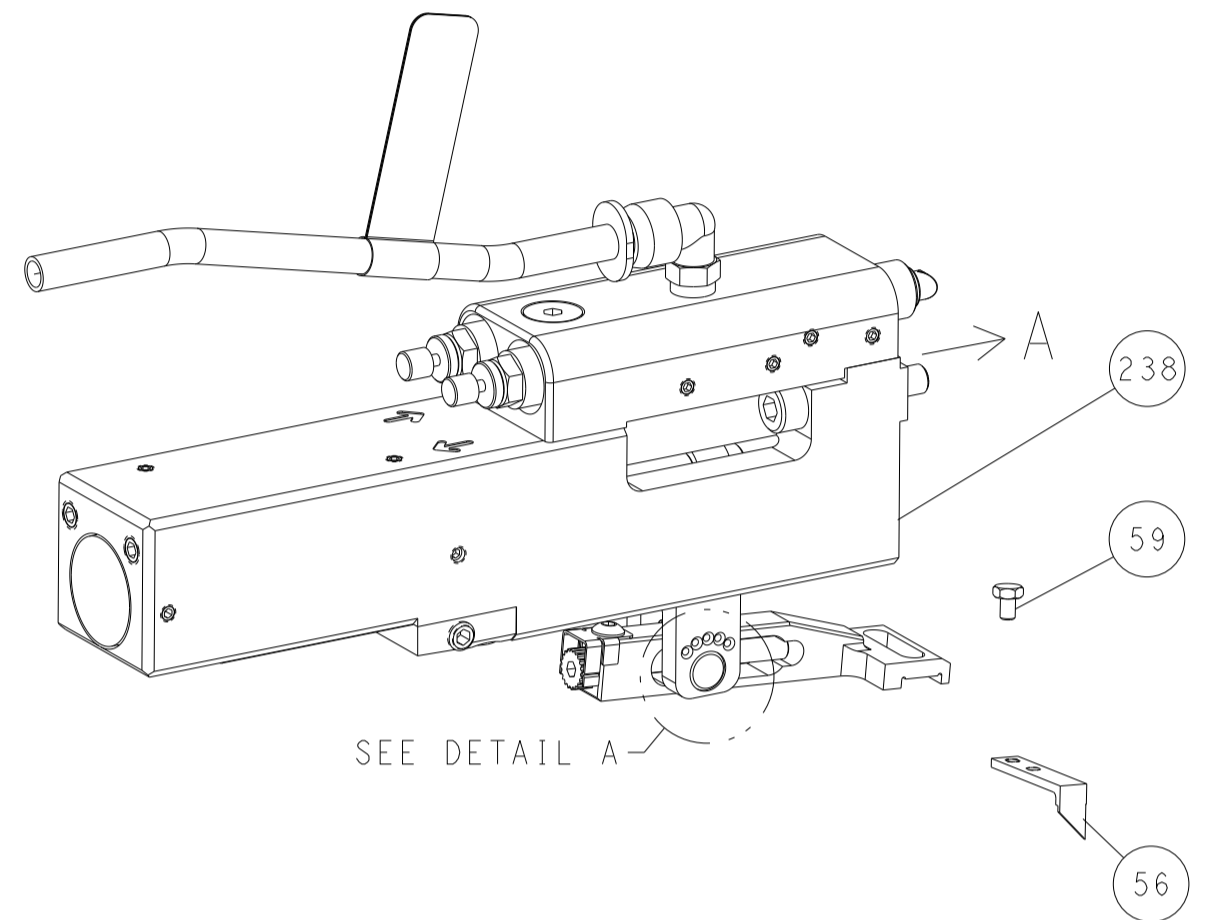
| | | | |
|----------------------------|--|---------------------------|--|
| APPLICATOR NAME | | TE Connectivity | |
| Ocean Side Feed Applicator | | Harrisburg, PA 17105-3608 | |

| LOC | DIST | REVISIONS | | | |
|-----|------|-------------|------|----|------|
| A | 66 | REV | DATE | BY | APPV |
| - | - | SEE SHEET 1 | - | - | - |

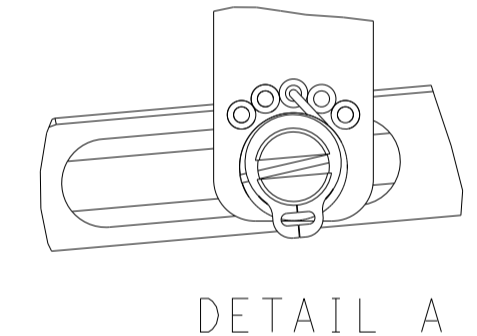
FEED TYPE MECHANICAL



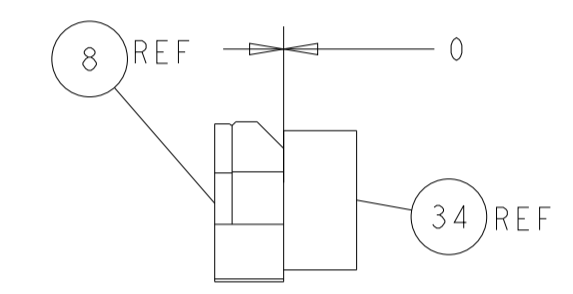
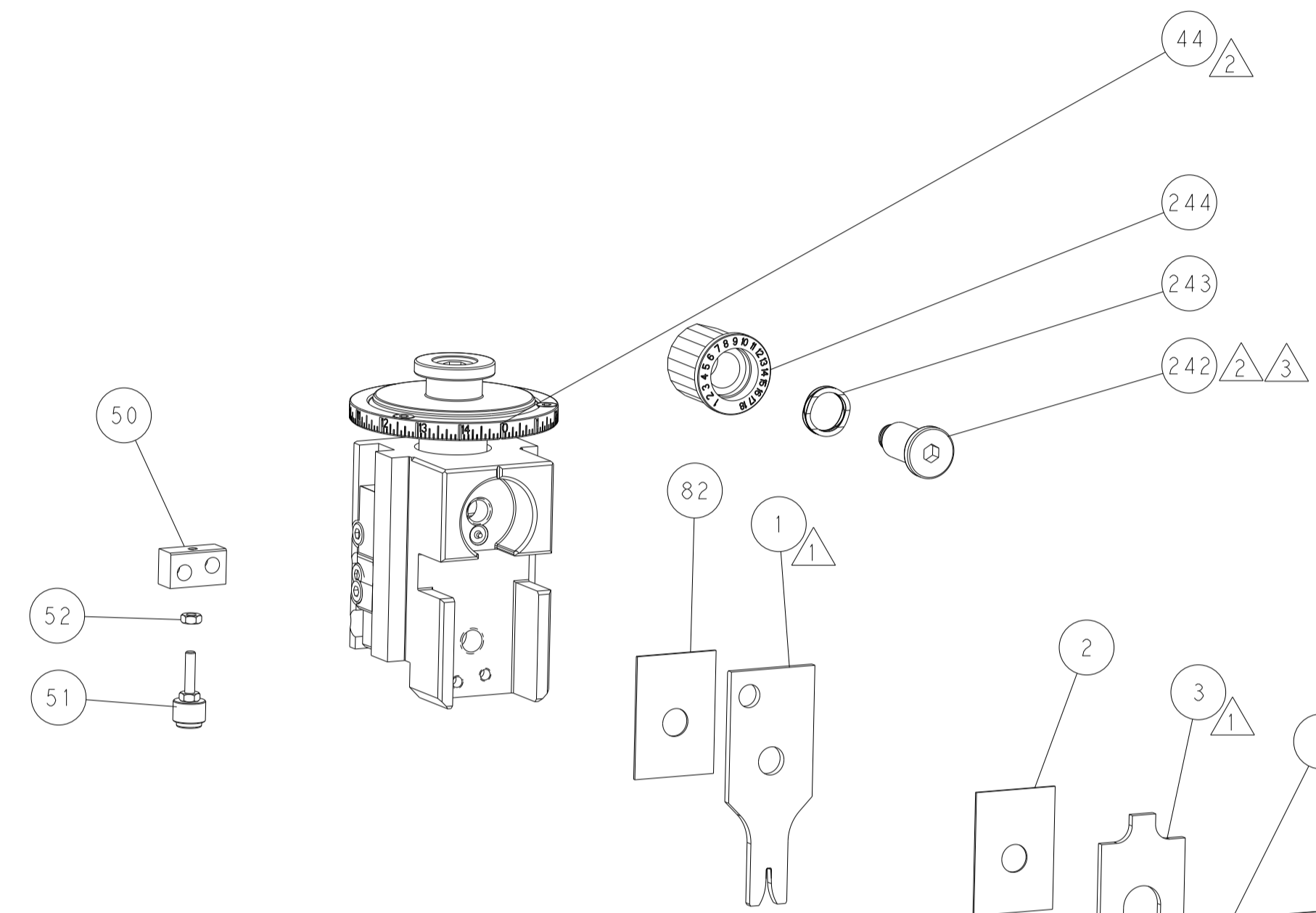
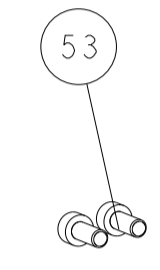
PNEUMATIC



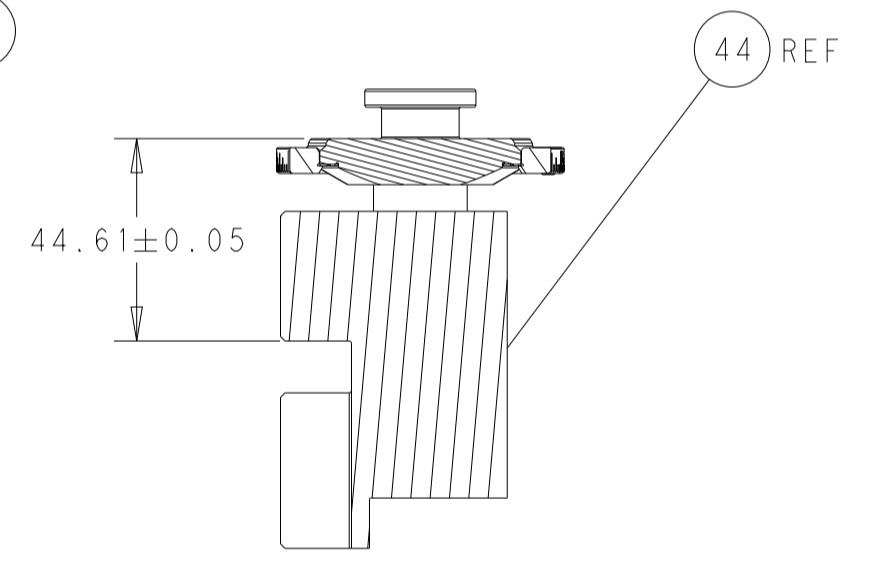
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



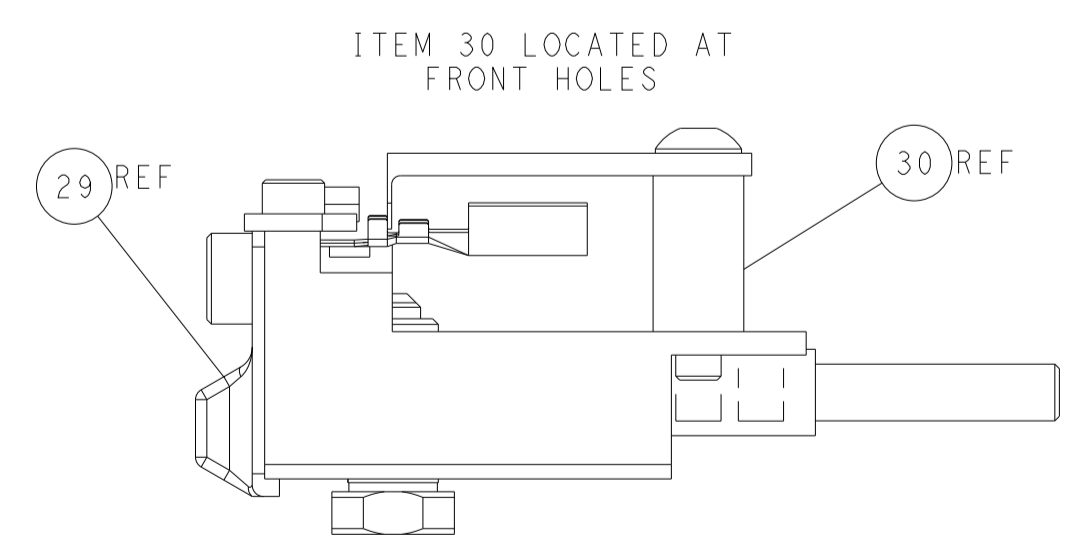
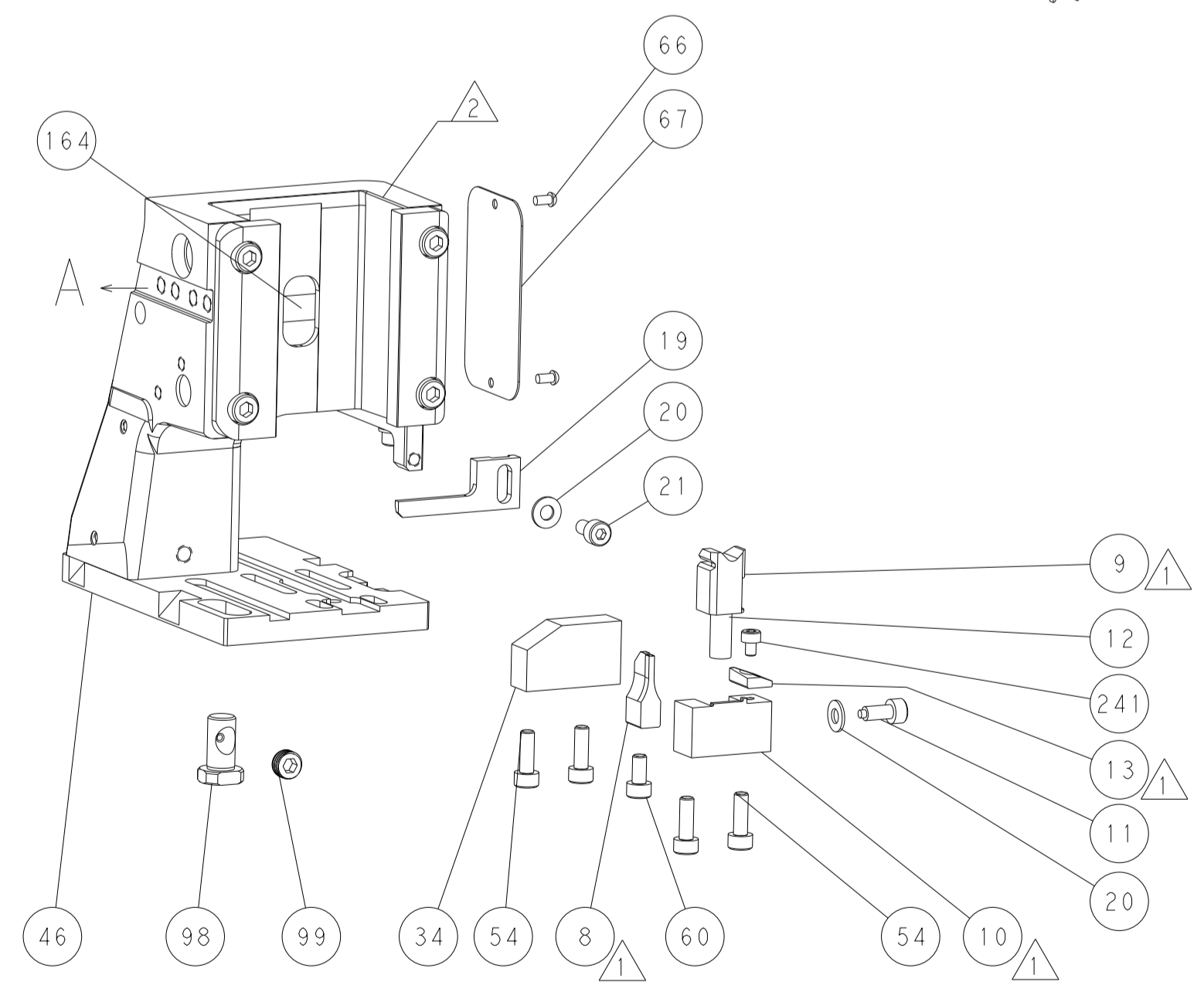
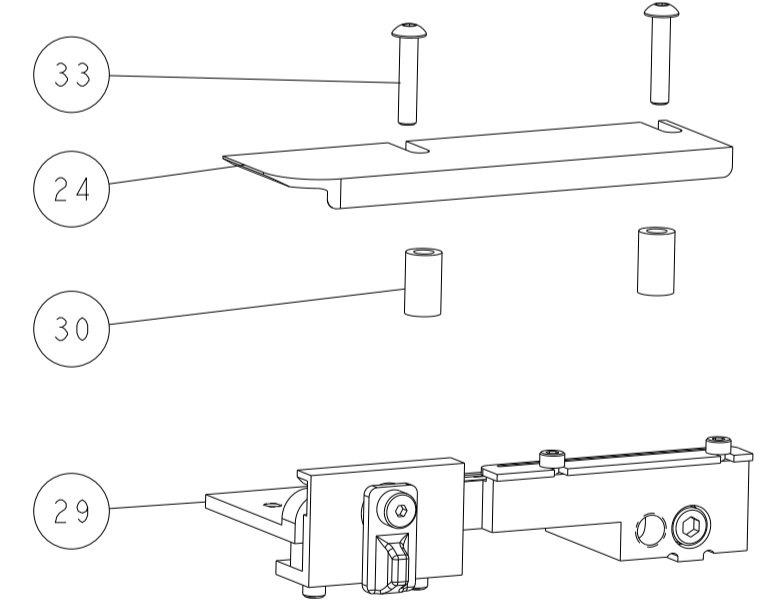
DETAIL A



TERMINAL SUPPORT LOCATION

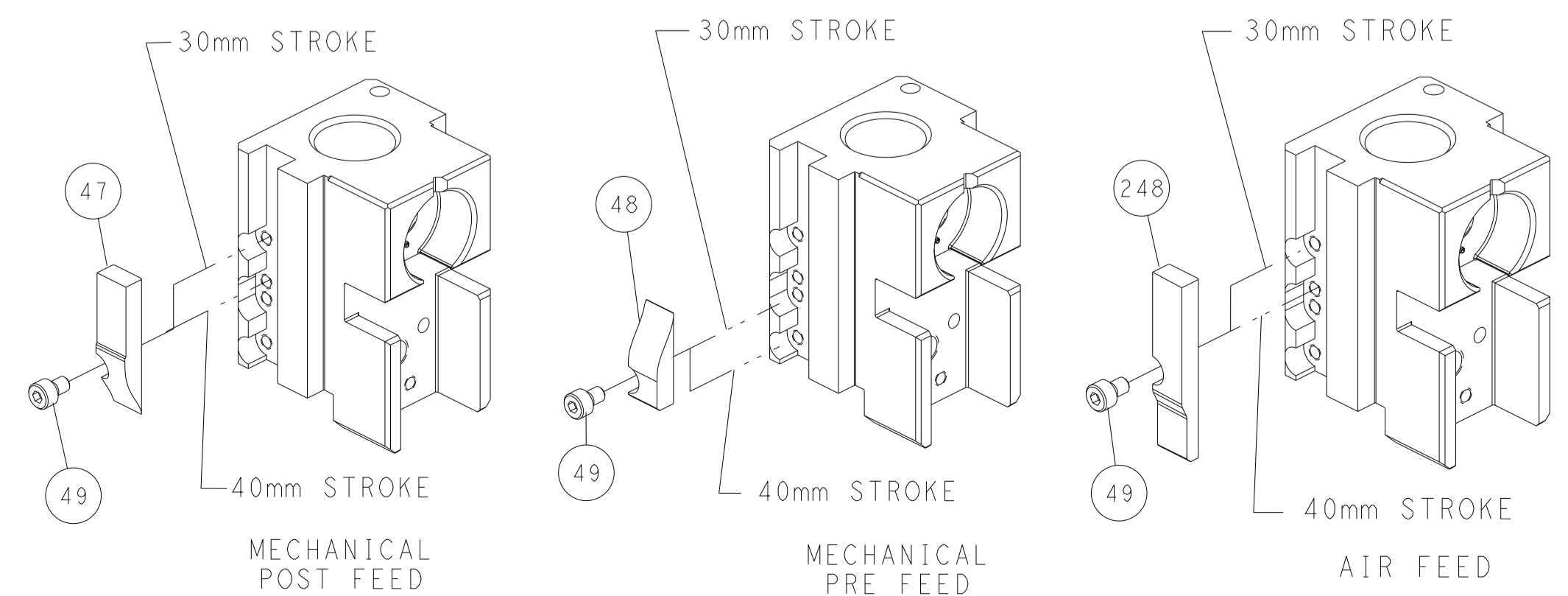


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

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. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN: J. HOU CHK: L. ZHANG APVD: J. GUO | DATE: 5FEB2015 DATE: 5FEB2015 DATE: 5FEB2015 | 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=2266588 | RESTRICTED TO: - SCALE: 1:2 SHEET: 2 OF 4 REV: C1 | CUSTOMER ACCESSIBLE PRODUCTION DRAWING |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2266588-1 | C | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2266588-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266588-7 | B | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.50 mm [.059] | F |
| INSUL | 1.90 mm [.075] | O |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION | | | |
|---|-----------------|---|-----------------|
| TERMINAL NAME: DELPHI TERMINAL | | | |
| WIRE STRIP LENGTH 3.10-3.30 mm [1.22-.130 IN] | | INSULATION DIAMETER RANGE Ø1.10-1.48 mm [.043-.058 IN] | |
| TERMINAL APPLICATION SPECIFICATION 15457847 | - | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | DELPHI TERMINAL | TE TERMINAL | DELPHI TERMINAL |
| 2113623-1 | 15457847 | 2113623-2 | 13799599 |
| 2113623-3 | 35250566 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|----------------------------|--------------------------------|
| 0.35mm ² | 1.00+/-0.03 [.039+/-0.011] | 7.5 |



- 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.

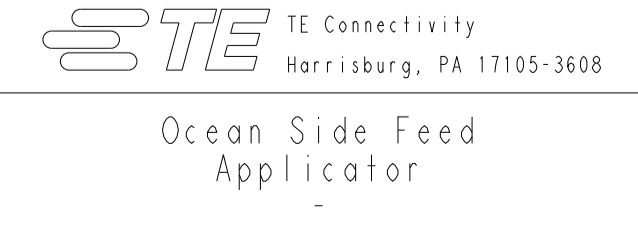
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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 | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| - | - | - | - | SEE SHEET 1 | - | - | - |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | 1 | 2119082-5 | 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 | 455888-6 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | 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 | 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 | 1-1752356-7 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 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 | 1803095-3 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 4-1803056-2 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 5-238011-5 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 6-1803018-9 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 8-1633588-0 | CRIMPER, WIRE | 1 |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: | | SHEET: | | REV: | | | | |
|-------------|---------|--|---------|-----------|---------|---------|--------|---------|---|--|-------|--------|-------|------|----|---|-----|----|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH | - | - | Customer Accessible Production Drawing | SCALE | 1:2 | SHEET | 3 | OF | 4 | REV | C1 |

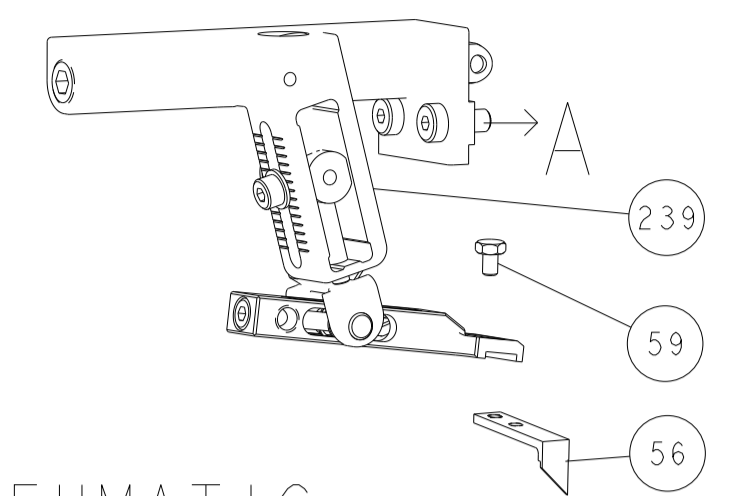


Ocean Side Feed
Applicator

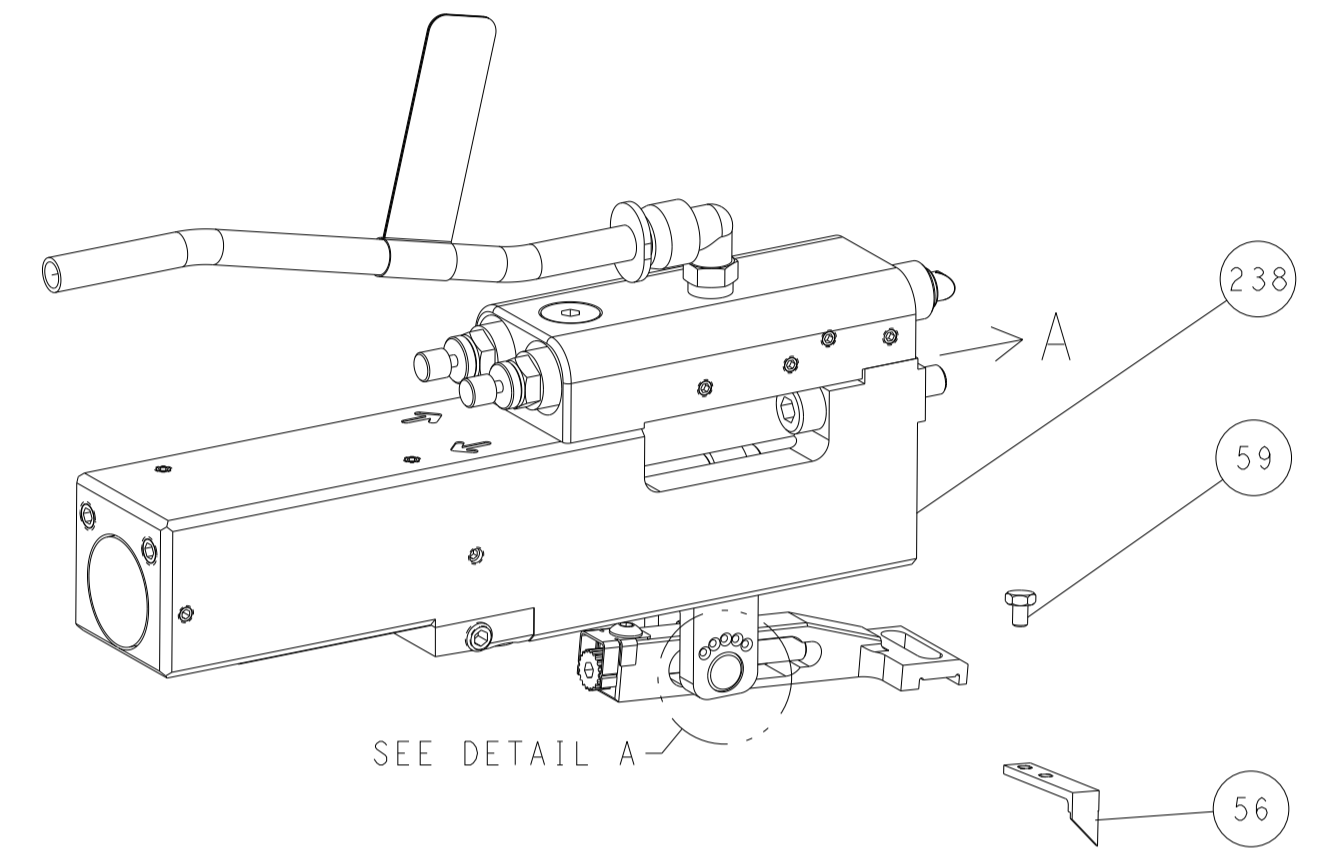
00779 ©=2266588

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

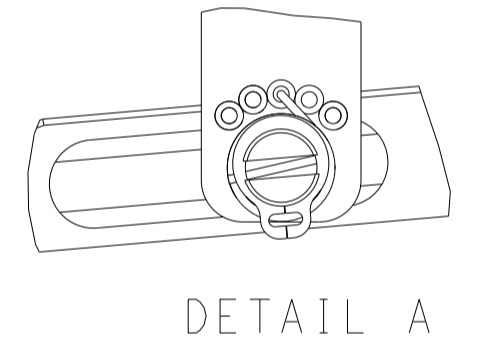
FEED TYPE MECHANICAL



PNEUMATIC

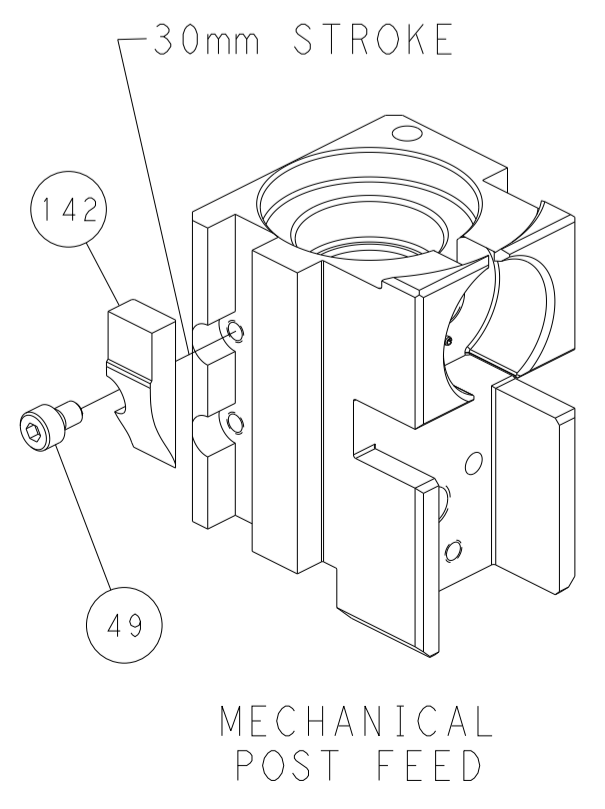


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

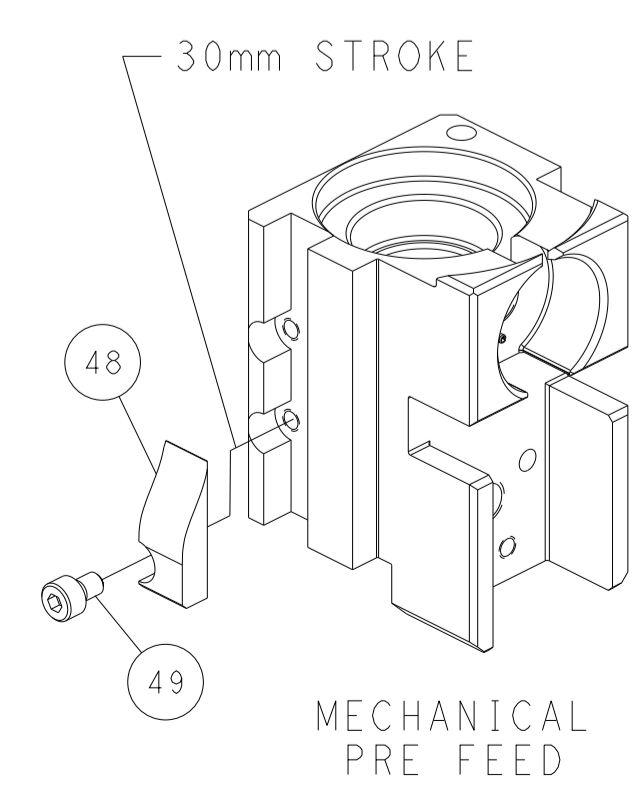


DETAIL A

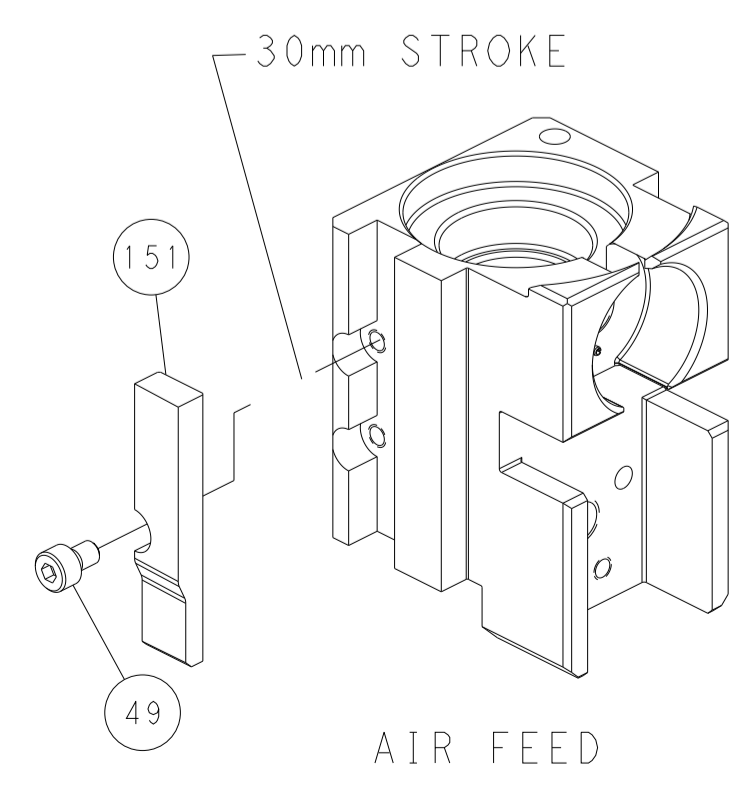
CAM POSITIONS



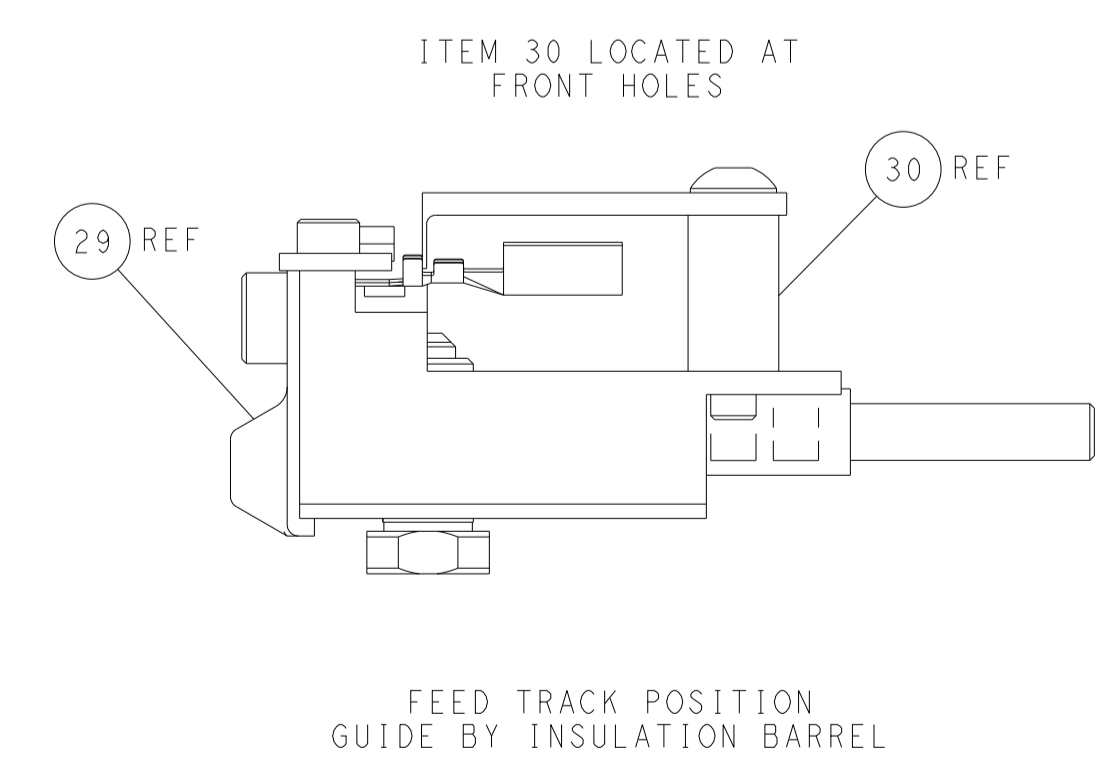
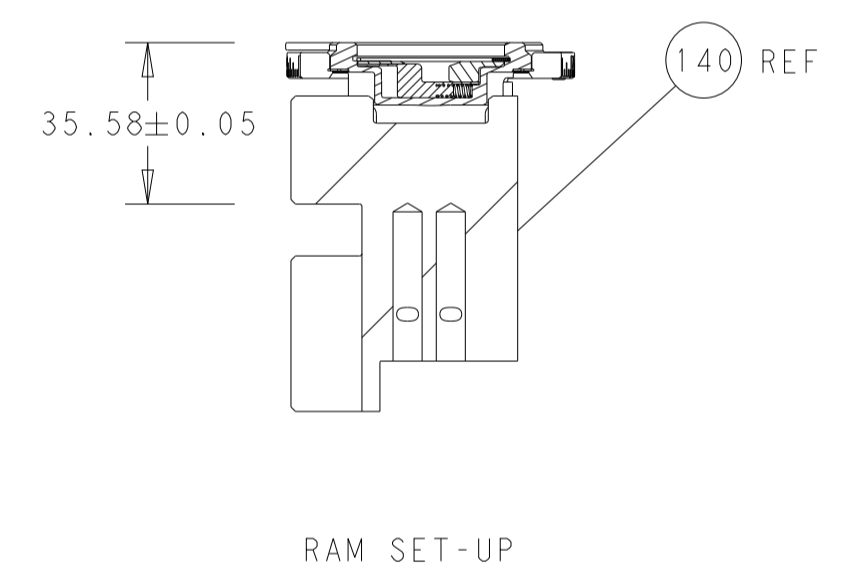
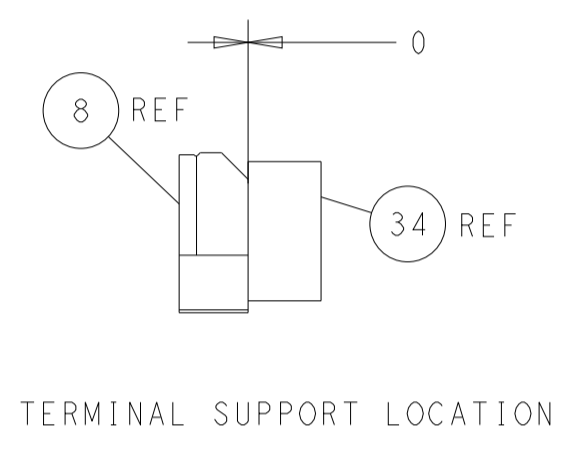
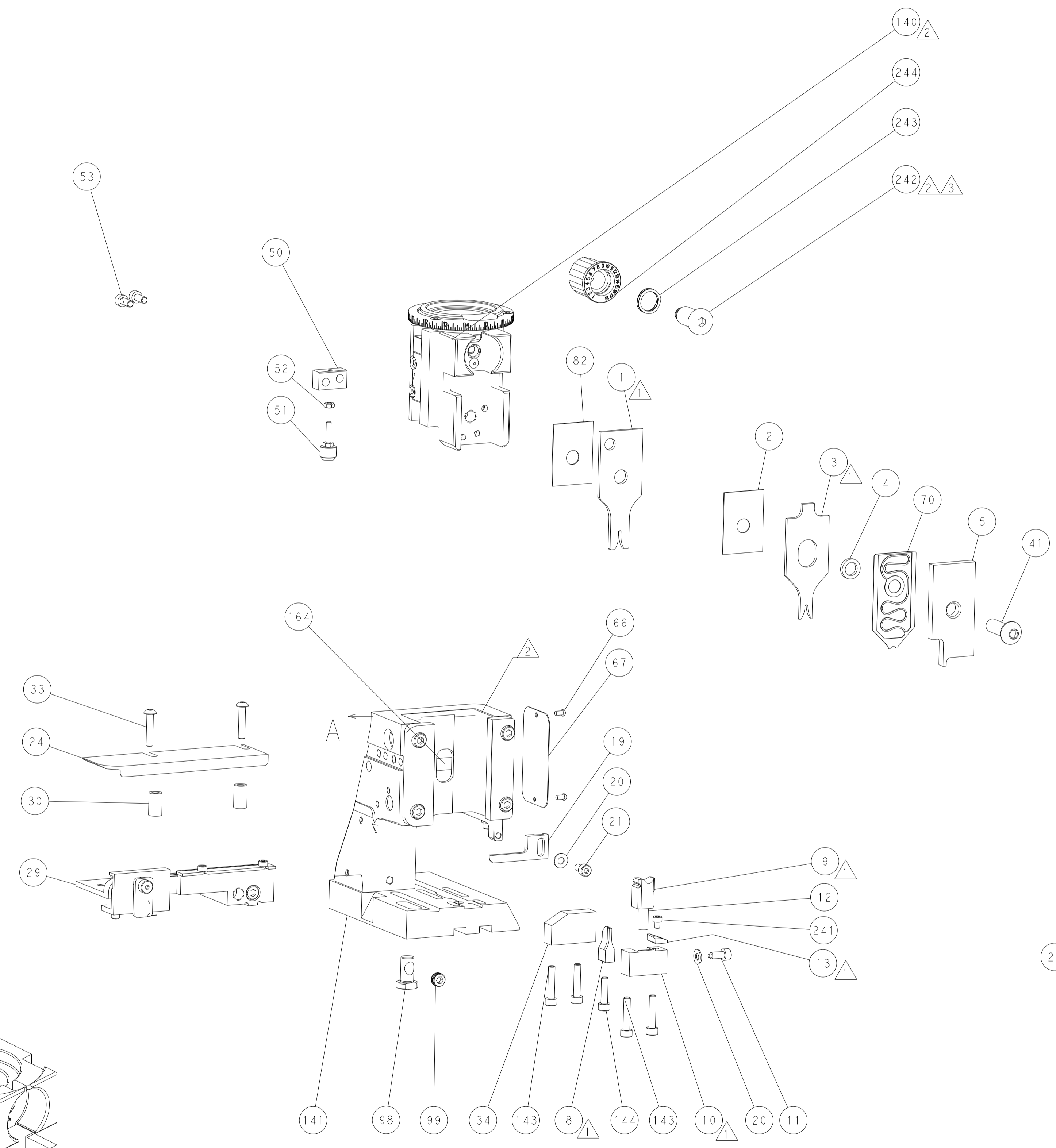
MECHANICAL
POST FEED



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)

| | | | |
|--|--|---|--|
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| DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - | TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ± ± | NAME Ocean Side Feed Applier APPLICATION SPEC - SIZE CAGE CODE DRAWING NO. A1 00779 C-2266588 WEIGHT - | RESTRICTED TO - SCALE 1:2 SHEET 4 OF 4 REV C1 Customer Accessible Production Drawing |