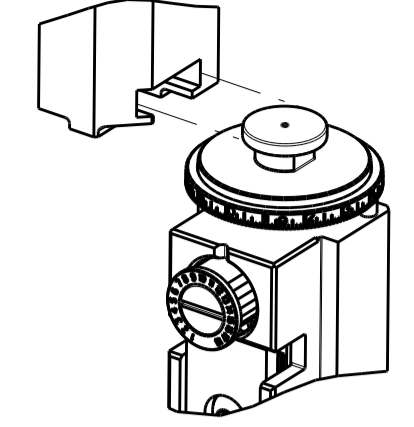


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266811-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266811-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266811-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266811-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266811-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

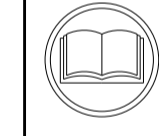


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.00 mm [.118]	F
INSUL	4.32 mm [.170]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION			
TERMINAL NAME: METRI-PECK 280 SERIES TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.68-5.44 mm [.184-.214 IN]	Ø2.03-2.85 mm [.080-.112 IN]		
TERMINAL APPLICATION SPECIFICATION 12129409 PAGE 3 OF 16 REV 7-29-14			
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL
1572754-1	12129409	1949807-1	15324982
		1572716-3	15324980

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.65+/-0.05 [1.065+/-0.002]	5.8
1.00mm2	1.50+/-0.05 [1.059+/-0.002]	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. 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)

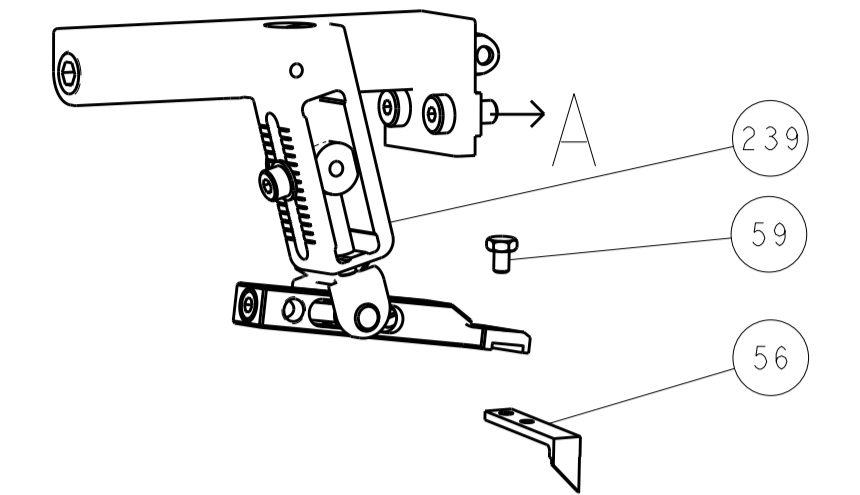
LOC	DIST	REVISIONS			
		REV	DATE	BY	APPV
A	66	1	05JUN2015	GH	TE
		A	13JUL2015	GH	TE
		A1	23JUL2015	GH	TE
		B	16MAY2018	FL	JD

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-2	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	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-1	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
5	-	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	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-2	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	4-1803171-8	ANVIL, COMBINATION	8
-	1	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2-1633965-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	2	2	1	1	1633609-3	CRIMPER, WIRE	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

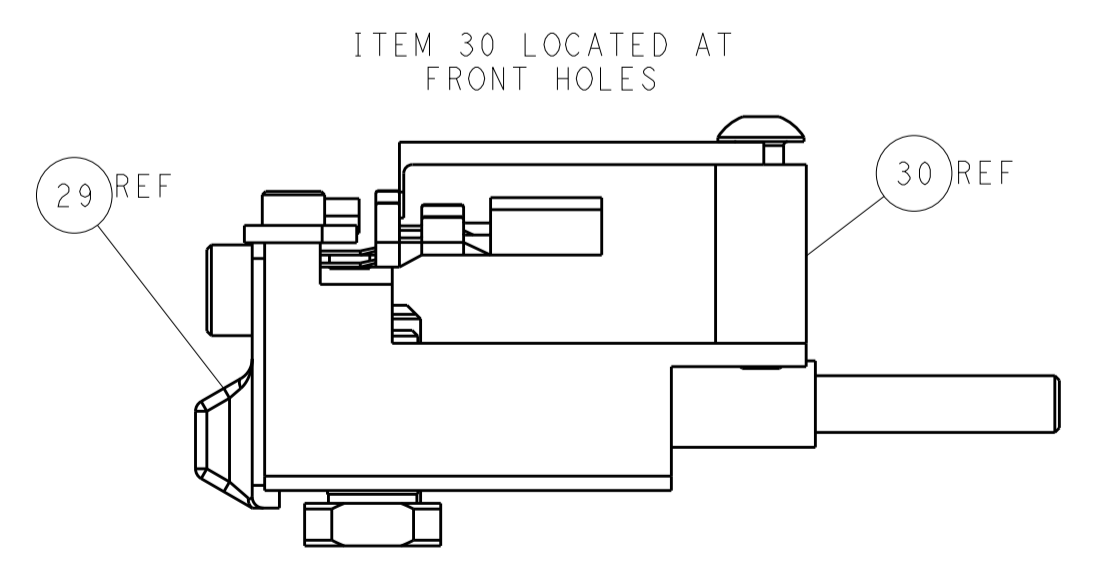
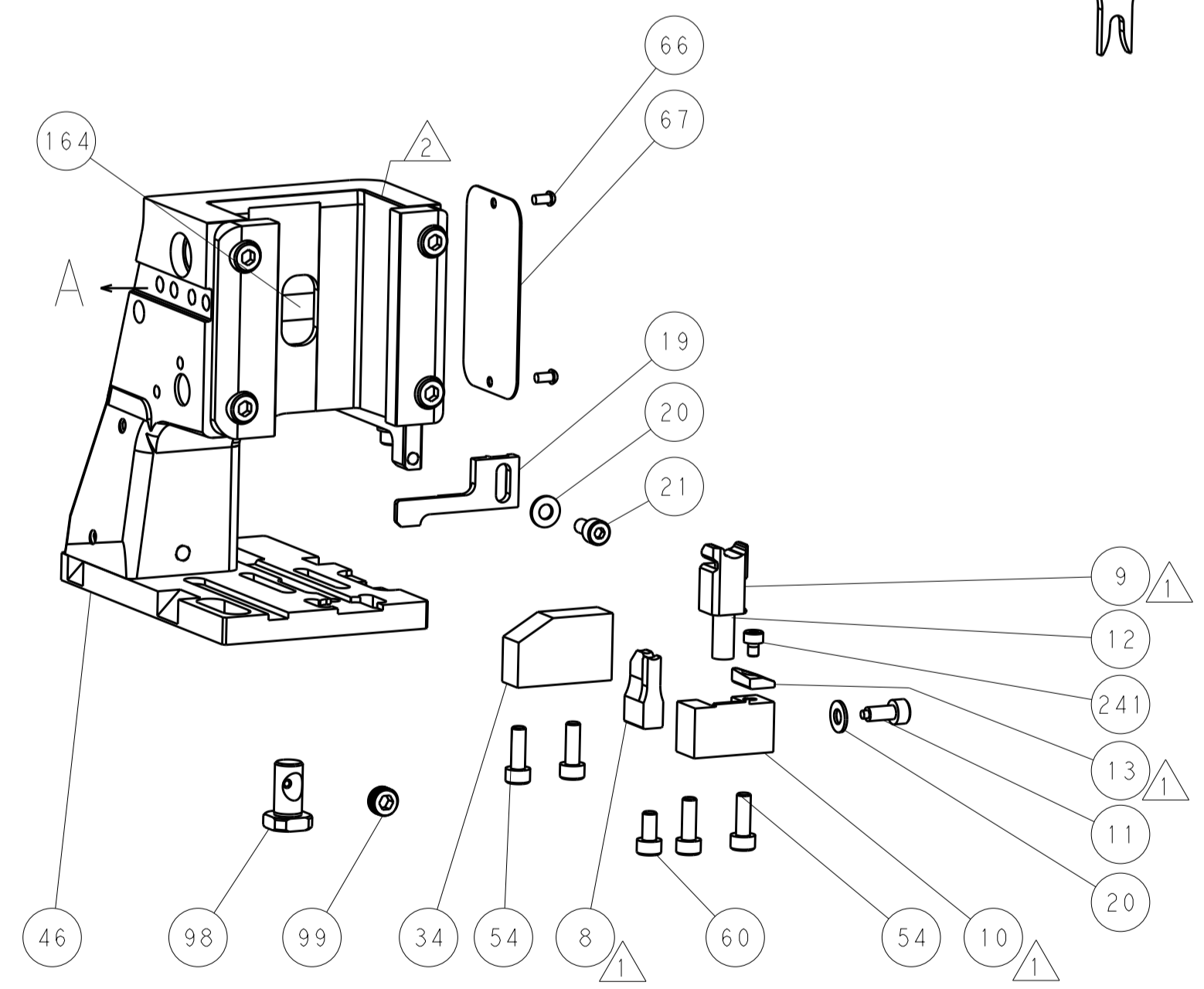
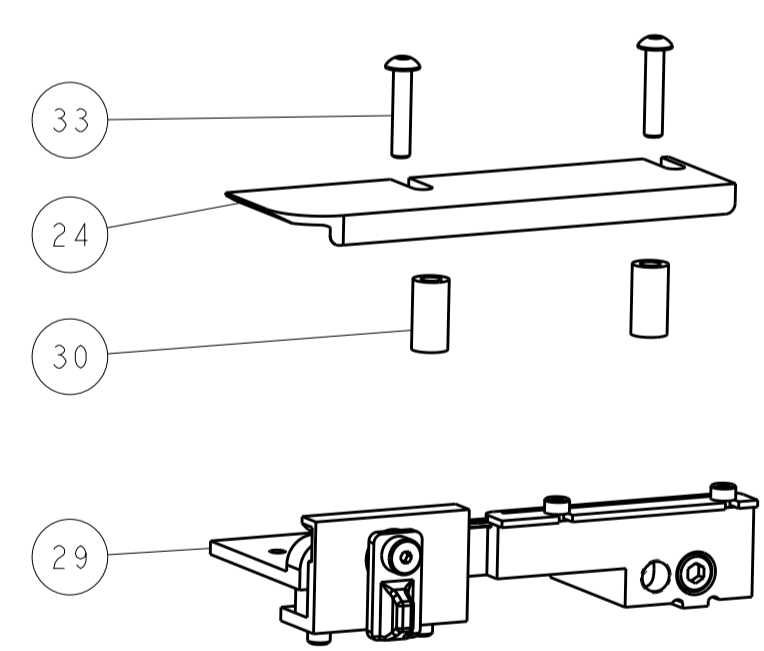
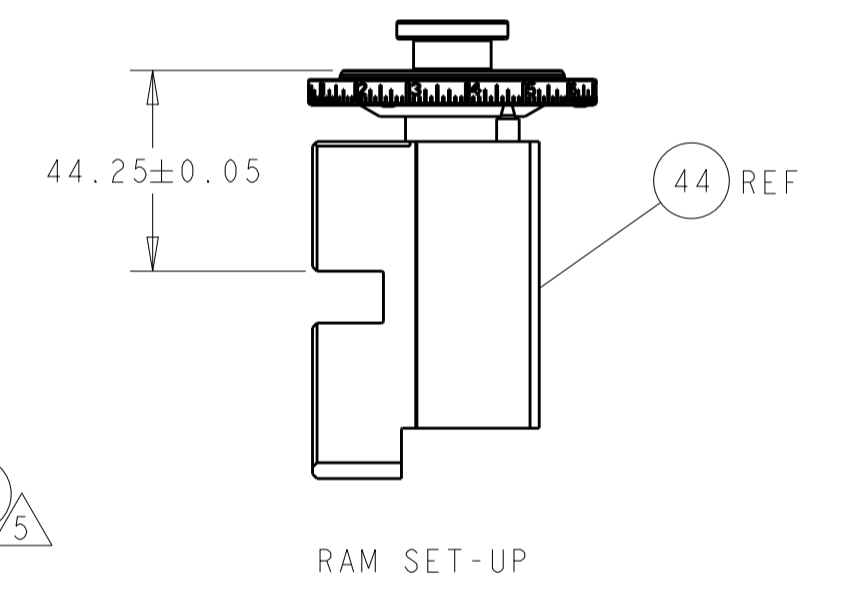
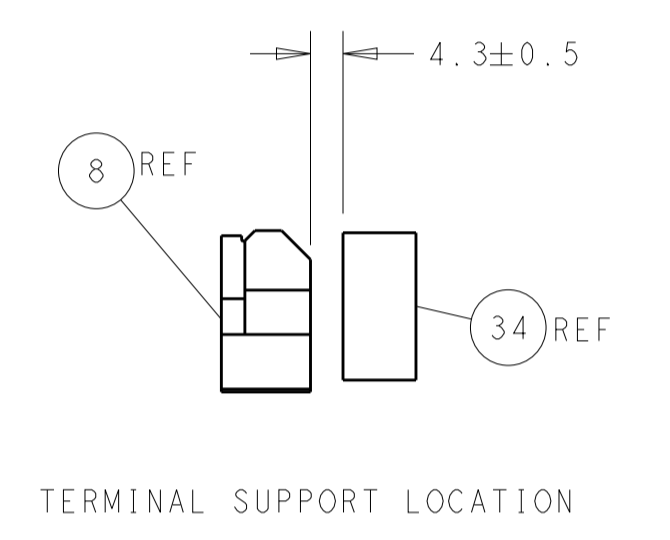
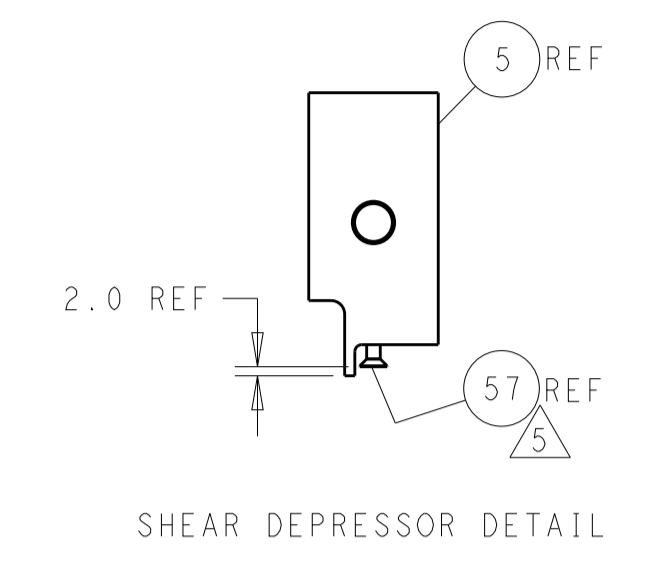
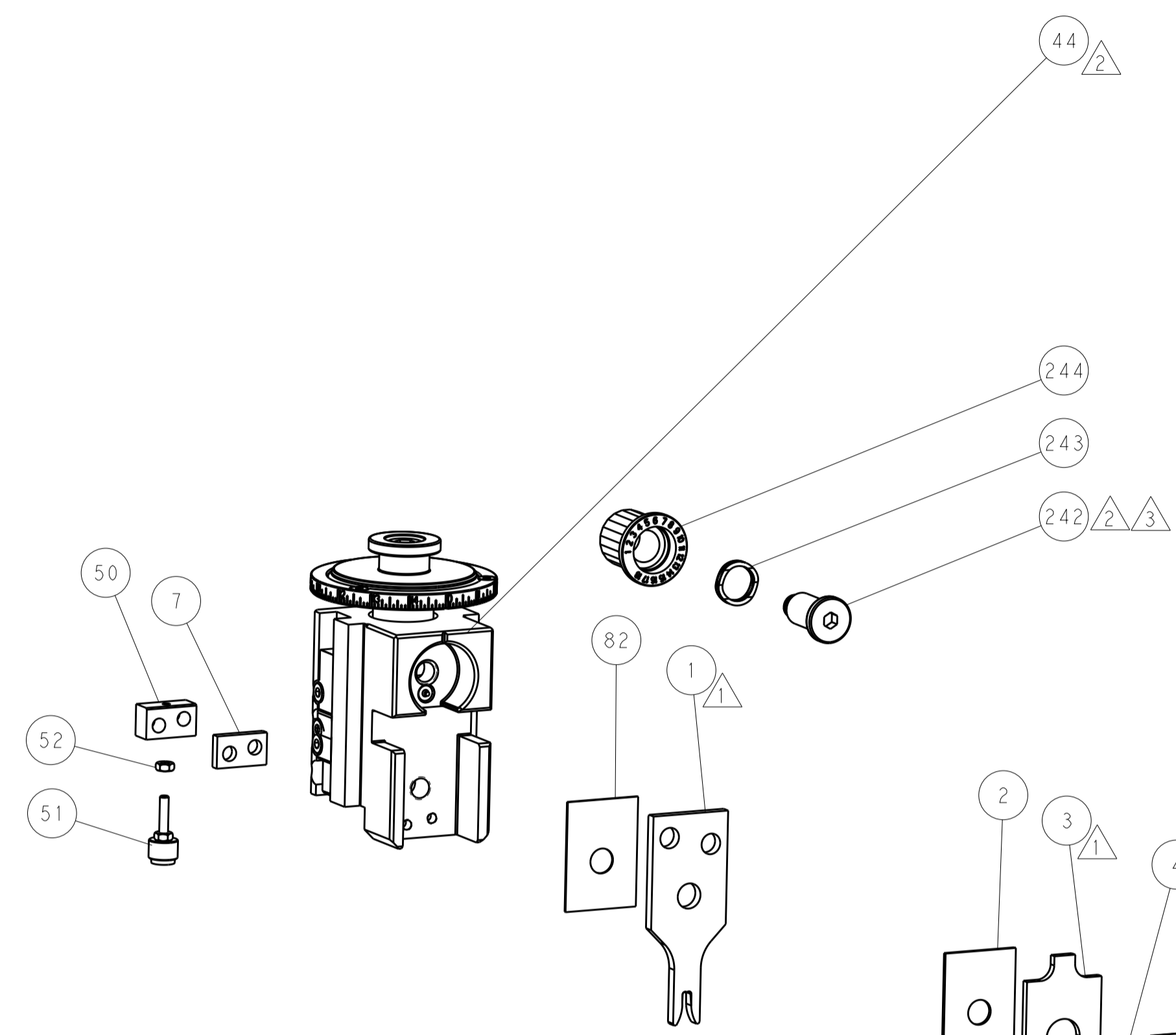
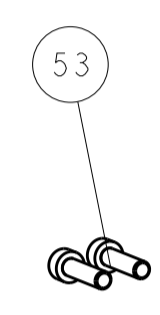
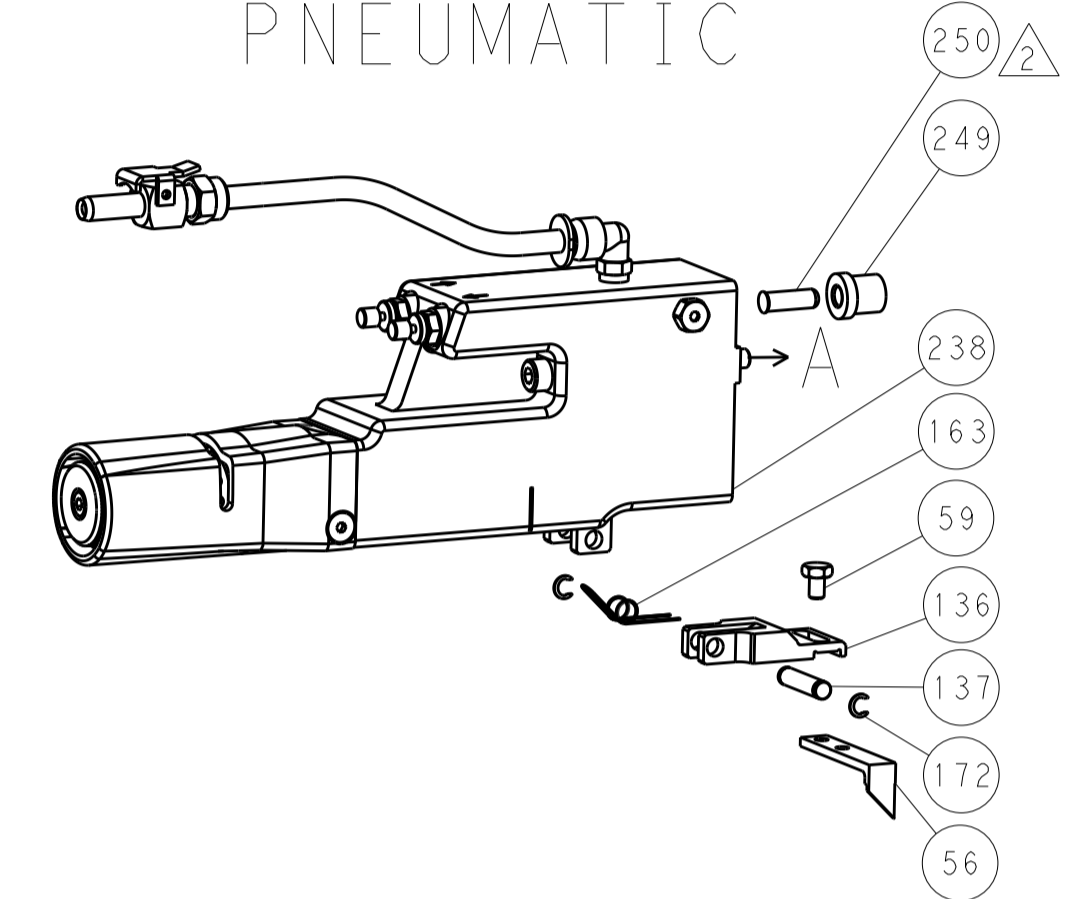
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: HOFFNER 5JUNE2015 CHK: T.ELBIN 8JUNE2015 APVD: T.ELBIN 8JUNE2015		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266811	
APPLICATION SPEC:				RESTRICTED TO:			
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE: 1:2 SHEET 1 OF 4 REV B			

LOC	DIST	REV	DATE	BY	APPV
A	66				

# FEED TYPE MECHANICAL



# PNEUMATIC



# CAM POSITIONS

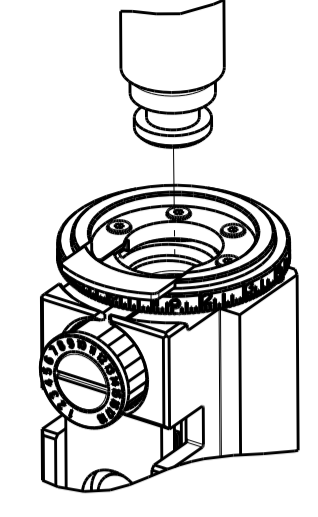


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN: HOFFNER 5JUNE2015 CHK: T.ELBIN 8JUNE2015 APPV: T.ELBIN 8JUNE2015		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266811	
MATERIAL:		WEIGHT:		RESTRICTED TO:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2		SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266811-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266811-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266811-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.00 mm [.118]	F
INSUL	4.32 mm [.170]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION  
 TERMINAL NAME: METRI-PECK 280 SERIES TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.68-5.44 mm [.184-.214 IN]	∅2.03-2.85 mm [.080-.112 IN]

TERMINAL APPLICATION SPECIFICATION 12129409 PAGE 3 OF 16 REV 7-29-14

TERMINALS APPLIED

TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL
1572754-1	12129409	1949807-1	15324982
		1572716-3	15324980

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm <sup>2</sup>	1.65+/-0.05 [.065+/-0.002]	5.8
1.00mm <sup>2</sup>	1.50+/-0.05 [.059+/-0.002]	7.5

- 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.

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

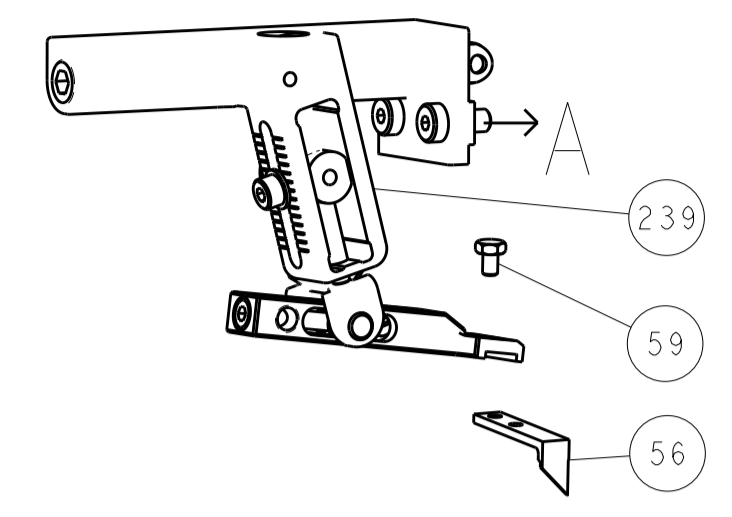
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	-		2119640-1 PUSH ROD, AIR FEED	250
-	1	-		1803259-1 BUSHING, FLANGED	249
-	1	1		2119082-2 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	1		7-18023-7 SCR, SKT HD CAP M3 X 4.0	241
-	-	1		2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1	-		2063440-1 AIR FEED MODULE	238
-	2	-		21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF		994970-2 COUNTER, MAGNETIC	164
-	1	-		240638-1 SPRING, FEED FINGER	163
-	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	-		3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-		2119799-1 HOLDER, FEED FINGER, AF	136
-	1	1		2844908-1 SCREW, LOCKING	99
-	1	1		2844907-1 POST, LOCKING	98
-	1	1		455888-5 SPACER, CRIMPER	82
-	1	1		1803607-1 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
-	1	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		1752356-1 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		3-2844962-2 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		4-1803171-8 ANVIL, COMBINATION	8
-	1	1		240641-5 SPACER	7
-	-	-		-	6
-	1	1		2119781-1 DEPRESSOR, SHEAR	5
-	1	1		238011-9 BLOCK, CRIMPER SPACER	4
-	1	1		2-1633965-0 CRIMPER, INSULATION O PREMIUM	3
-	1	1		455888-9 SPACER, CRIMPER	2
-	1	1		1633609-3 CRIMPER, WIRE	1
-	77	-22	-21	PART NO	
-	-	-	-	DESCRIPTION	
-	-	-	-	ITEM NO	

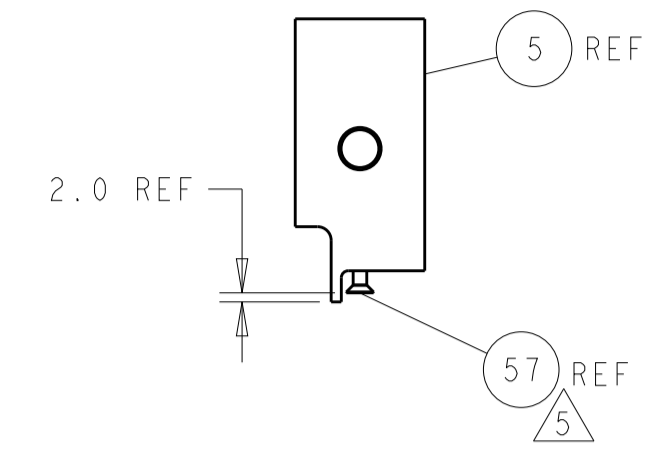
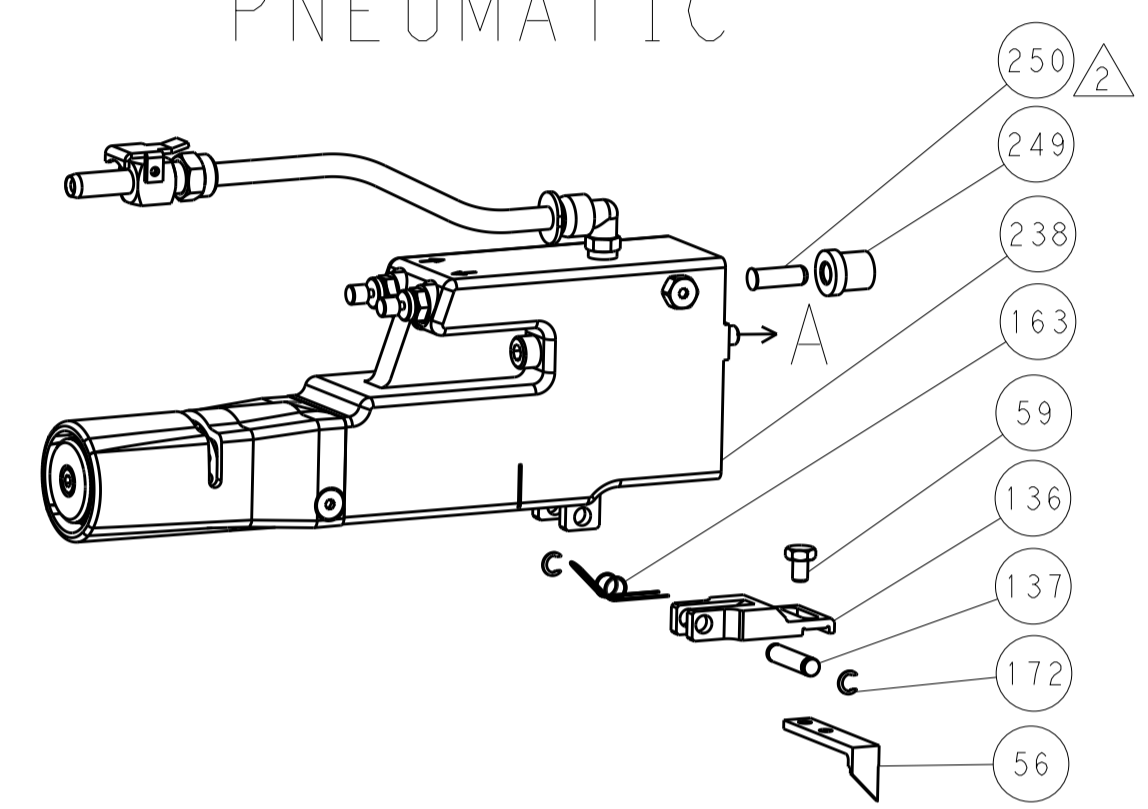
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: HOFFNER 5 JUNE 2015 CHK: T. ELBIN 8 JUNE 2015 APPV: T. ELBIN 8 JUNE 2015		NAME: TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		PRODUCT SPEC:		APPLICATION SPEC:	
WEIGHT:		SCALE:		SIZE:		CAGE CODE:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 3 OF 4		REV B		DRAWING NO: 00779 C=2266811	

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

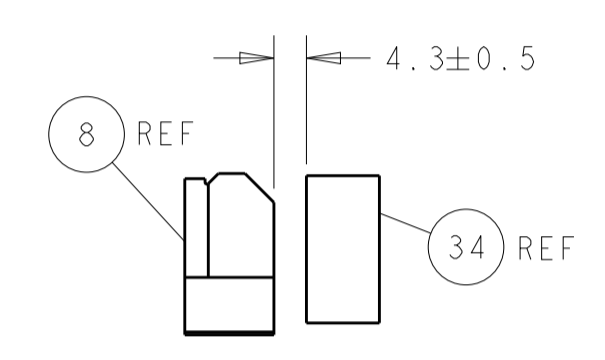
# FEED TYPE MECHANICAL



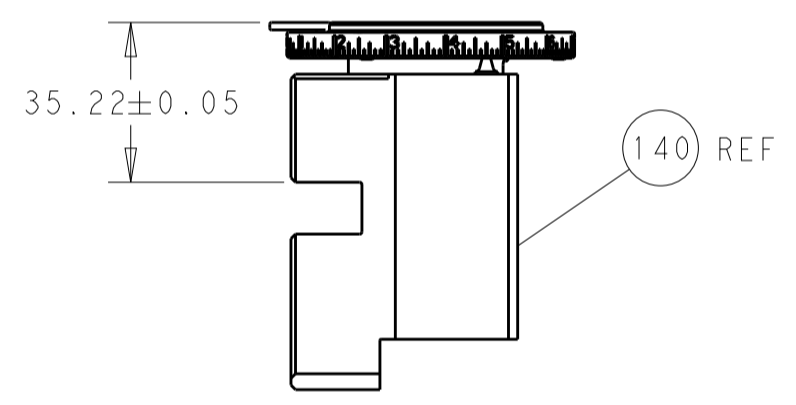
# PNEUMATIC



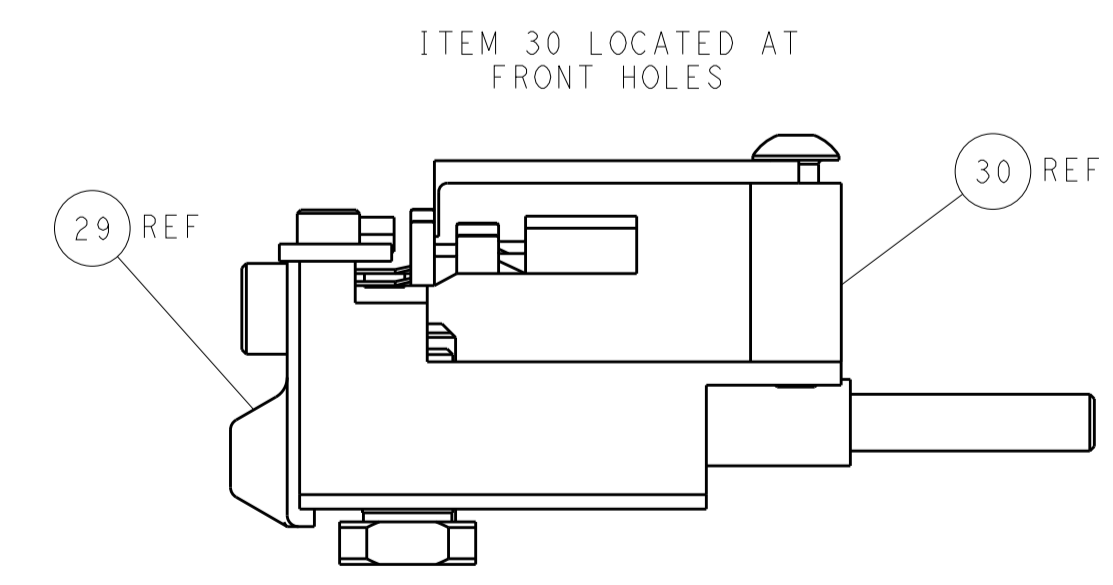
SHEAR DEPRESSOR DETAIL



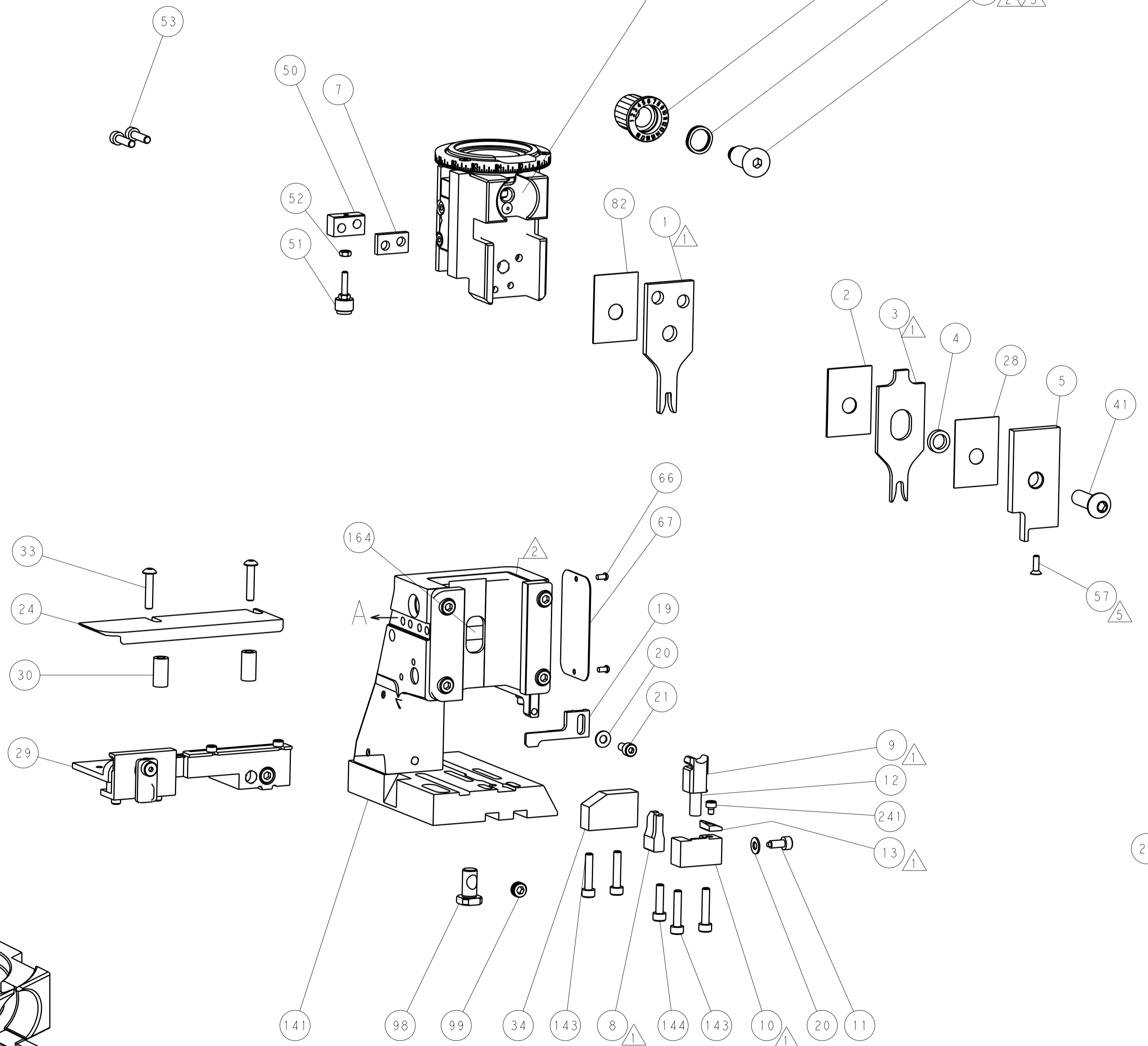
TERMINAL SUPPORT LOCATION



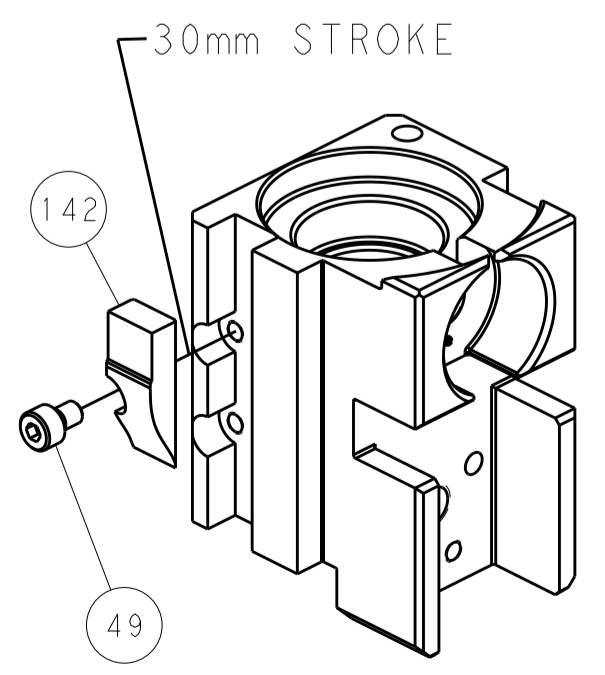
RAM SET-UP



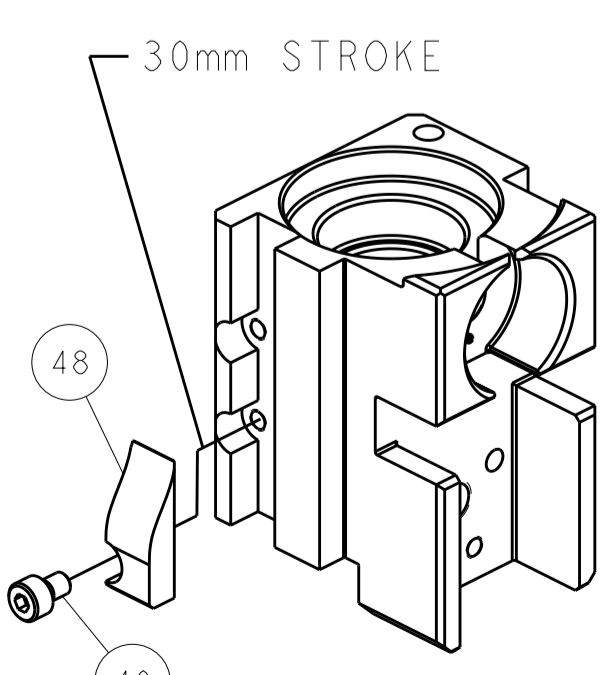
FEED TRACK POSITION GUIDE BY INSULATION BARREL



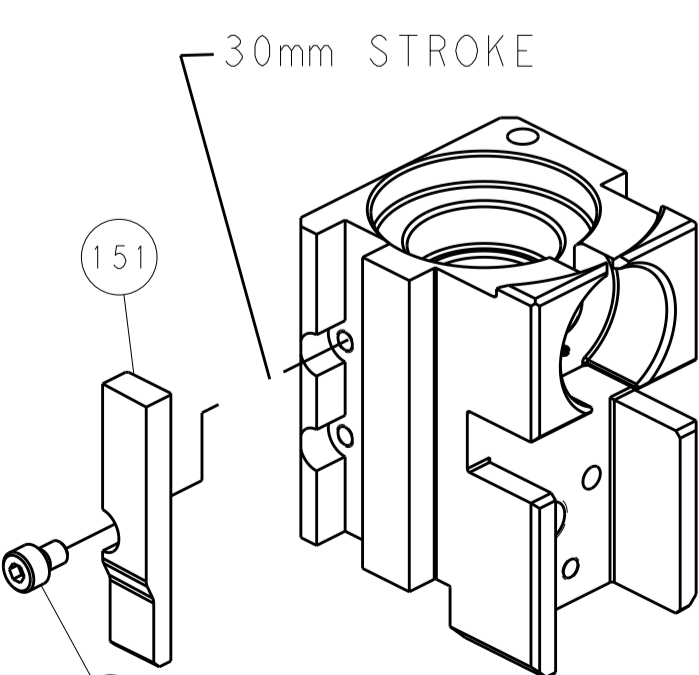
# CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: HOFFNER 5JUNE2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: T. ELBIN 8JUNE2015		NAME: Ocean Side Feed Applicator	
				PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				APPLICATION SPEC:		RESTRICTED TO:	
				WEIGHT:		A   00779   C=2266811	
				Customer Accessible Production Drawing		SCALE: 1:2 SHEET 4 OF 4 REV B	