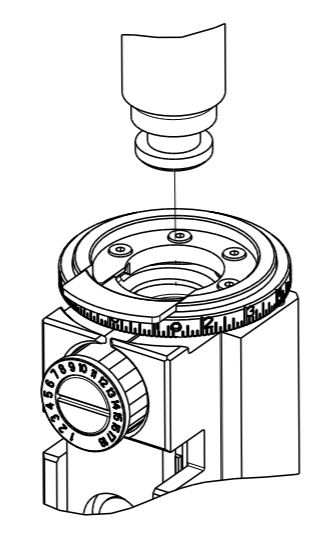






PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266433-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266433-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266433-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER

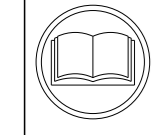


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm (.062)	F
INSUL	4.00 mm (.157)	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
2.53-3.87 mm (.100-.152 IN)	Ø
TERMINAL APPLICATION DELPHI Crimp Information Sheet 15344659 Page 4 of 9	

TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	CABLE DIAMETER
2113544-1	15344659	1949160-1	15327860	Ø1.10-1.70
2113544-2	15493059	1572277-2	15324974	Ø1.20-1.70
2113544-3	15426998			
2113544-4	13679977			
2113544-5	13601165			
2113544-6	13601171			
2113544-7	13601168			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.25 +/- 0.05 [0.049 +/- .002]	4.5
0.35mm2	1.15 +/- 0.05 [0.045 +/- .002]	5.5



- 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.

LOC	DIST	REV	DATE	BY	APPV
A	66				

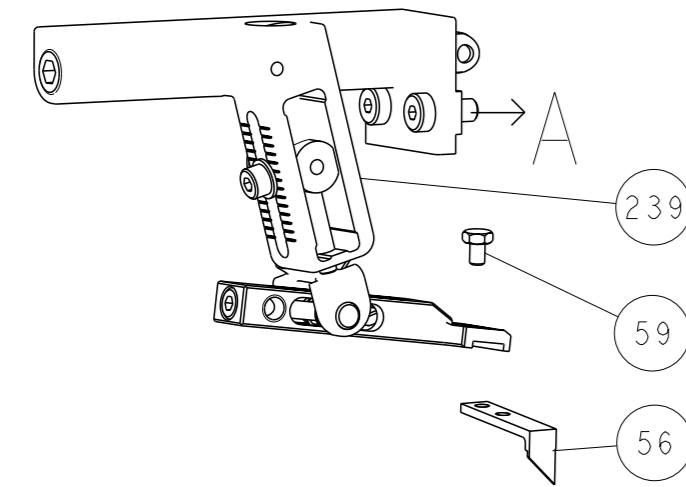
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	-		2119640-1 PUSH ROD, AIR FEED	250
-	1	-		1803259-1 BUSHING, FLANGED	249
-	1	1		2119082-3 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1		2119083-1 RETAINER, INSULATION DIAL	242
-	1	1		7-18023-7 SCR, SKT HD 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
-	2	2		2-18032-5 SCR, SET, FLT PNT, M5 X 20.0	68
-	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		2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0	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		980371-4 SCR, SKT HD SHLDR 5.0 DIA X 6.0	36
-	1	1		1-1752356-7 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0	31
-	2	2		3-2844962-0 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-3 ASSEMBLY, STRIP GUIDE	29
-	1	1		455888-3 SPACER, CRIMPER	28
-	1	1		356835-1 LEVER, DRAG RELEASE	26
-	1	1		240792-5 DRAG, TERMINAL	25
-	1	1		1320928-2 STRIP GUIDE	24
-	1	1		1-690438-0 FRONT STRIP GUIDE	23
-	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
-	2	2		22283-1 SPRING, COMPRESSION	14
-	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		2-1633918-0 ANVIL, COMBINATION	8
-	1	1		240641-8 SPACER	7
-	-	-		-	6
-	1	1		2119781-1 DEPRESSOR, SHEAR	5
-	1	1		238011-4 BLOCK, CRIMPER SPACER	4
-	1	1		6-1633965-9 CRIMPER, INSULATION O PREMIUM	3
-	1	1		455888-9 SPACER, CRIMPER	2
-	1	1		1-456403-3 CRIMPER, WIRE PREMIUM	1

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

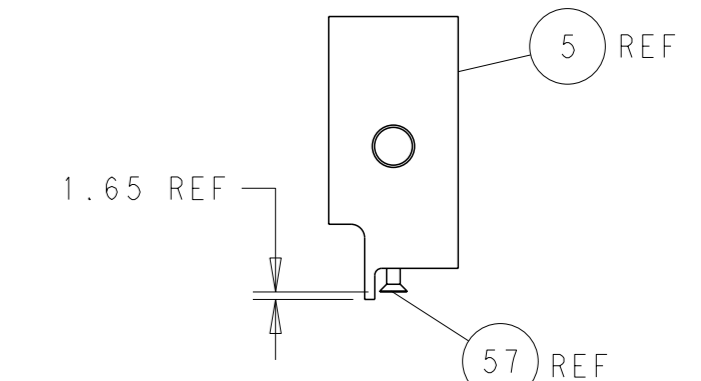
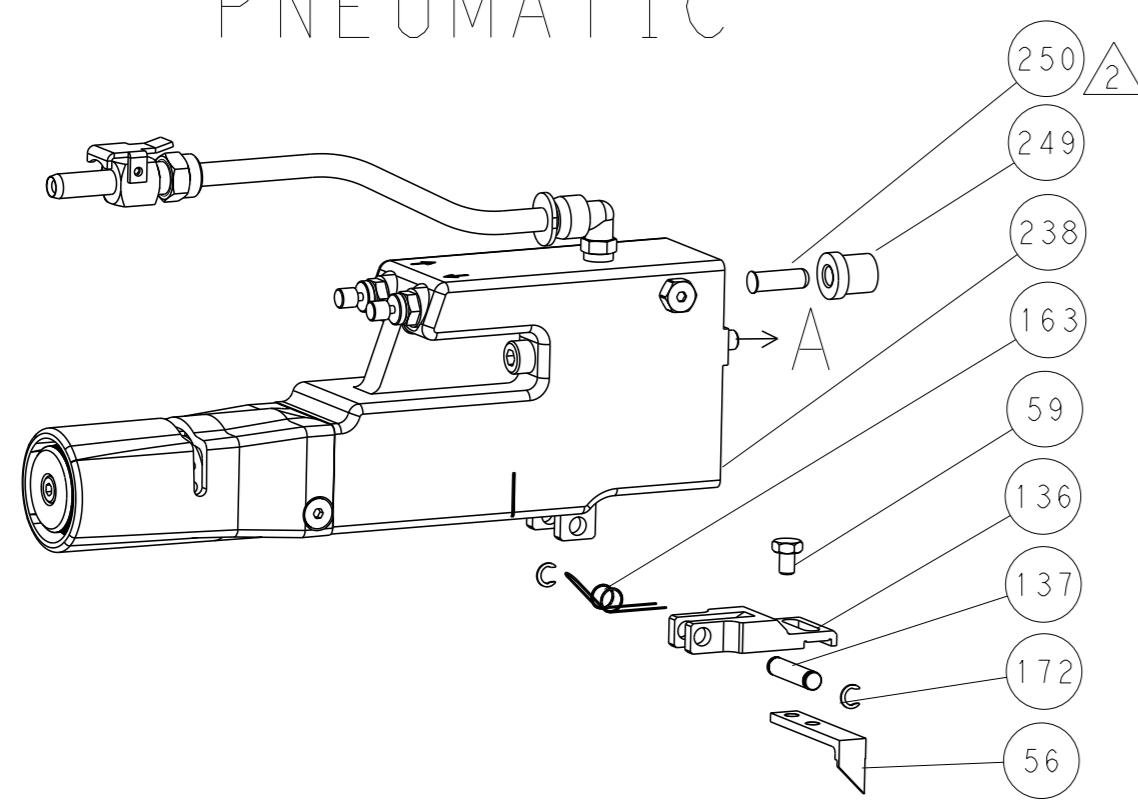
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL					
Customer Accessible Production Drawing		SCALE	1:2	SHEET	3 of 4

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

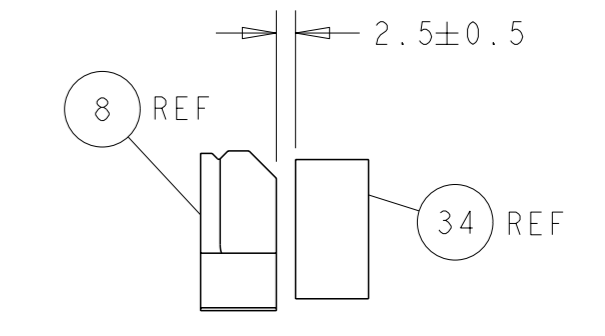
# FEED TYPE MECHANICAL



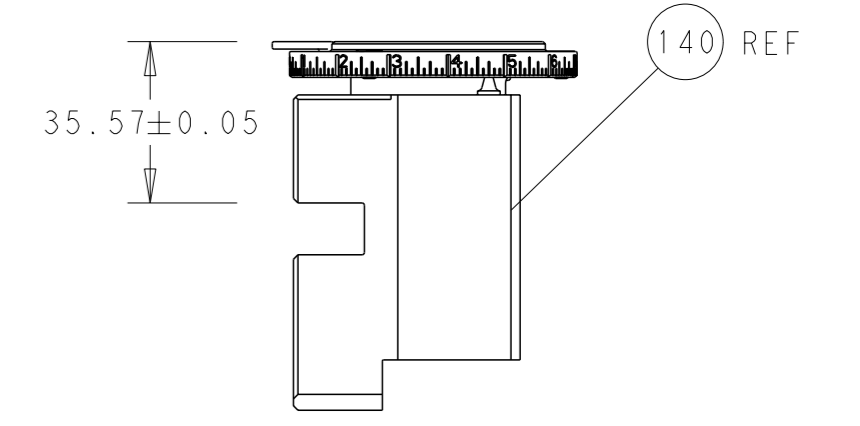
# PNEUMATIC



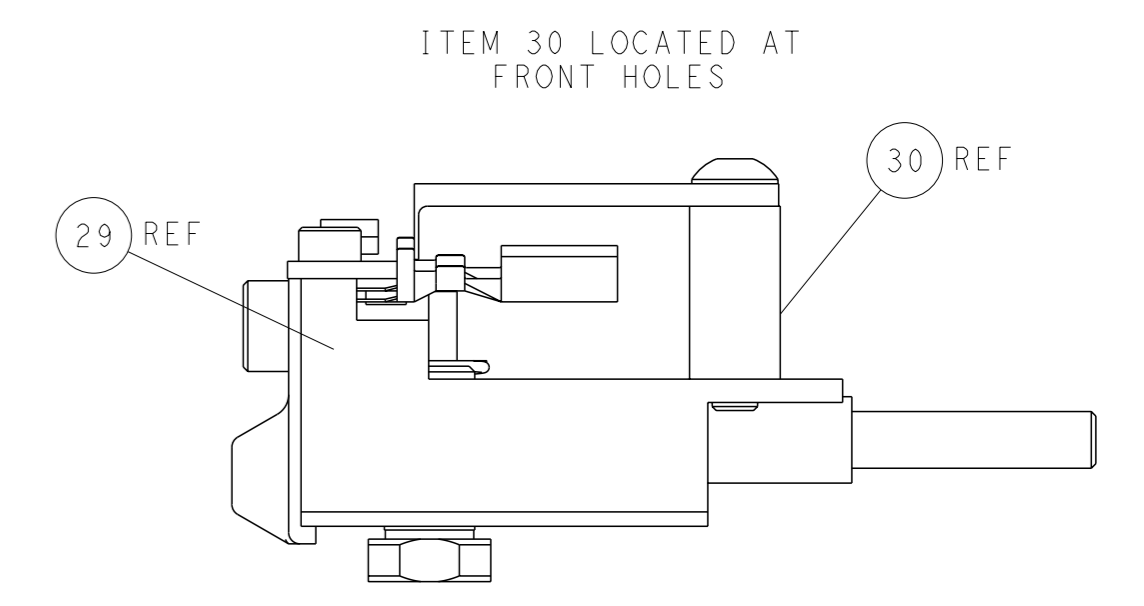
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

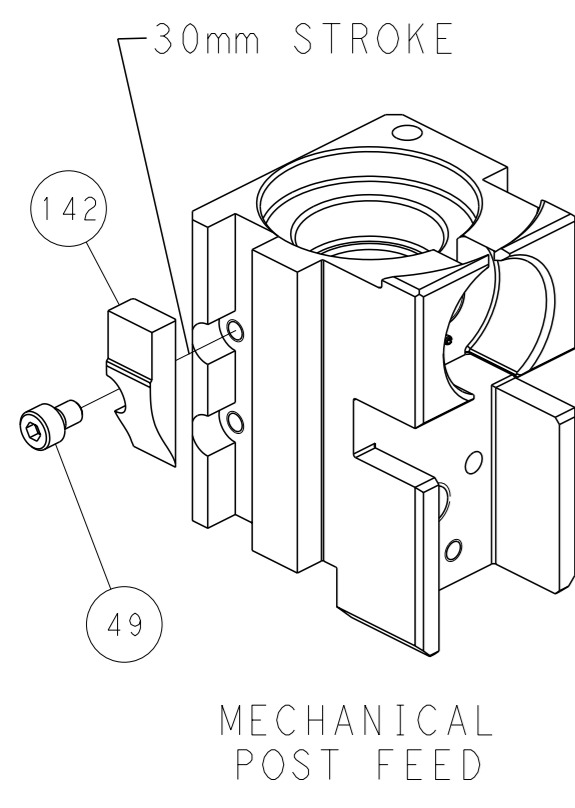


RAM SET-UP

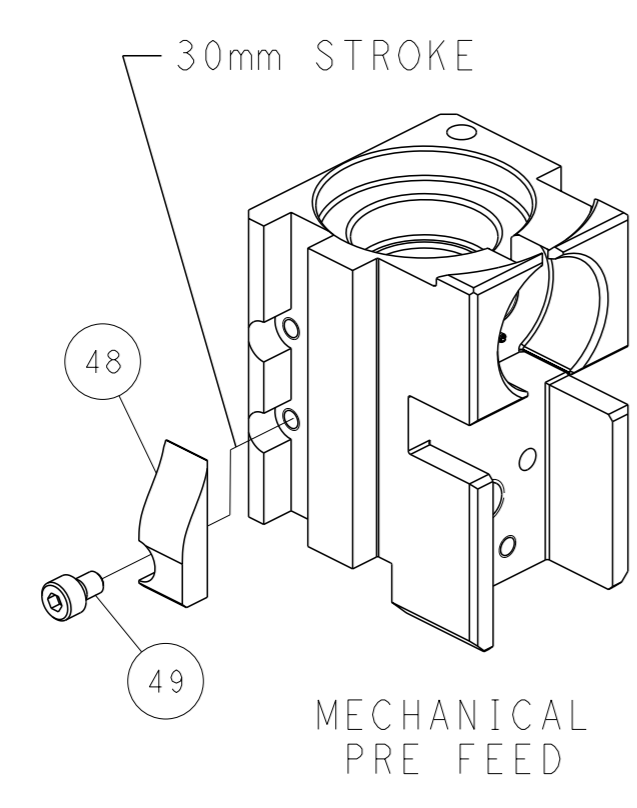


FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

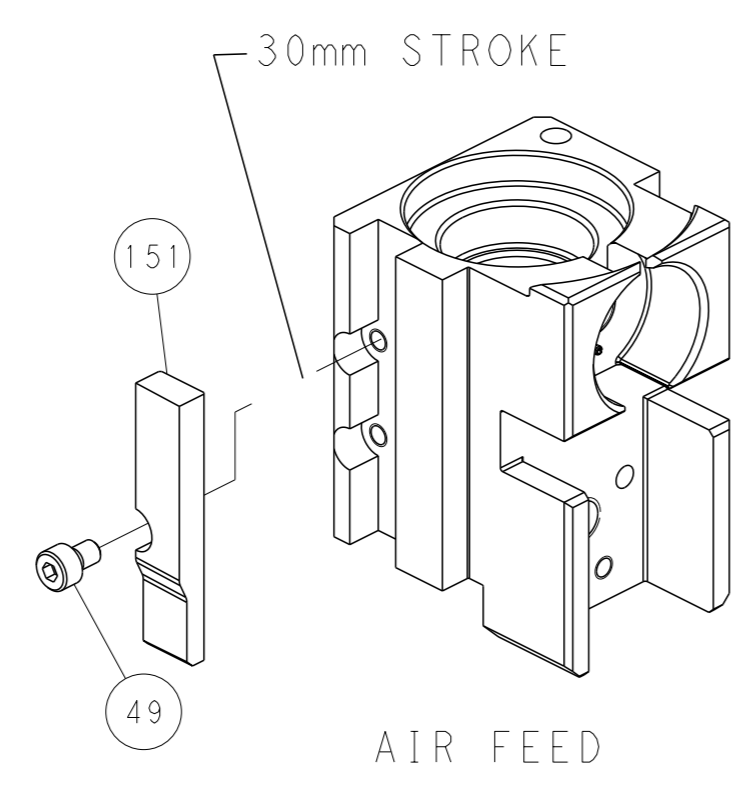
# CAM POSITIONS



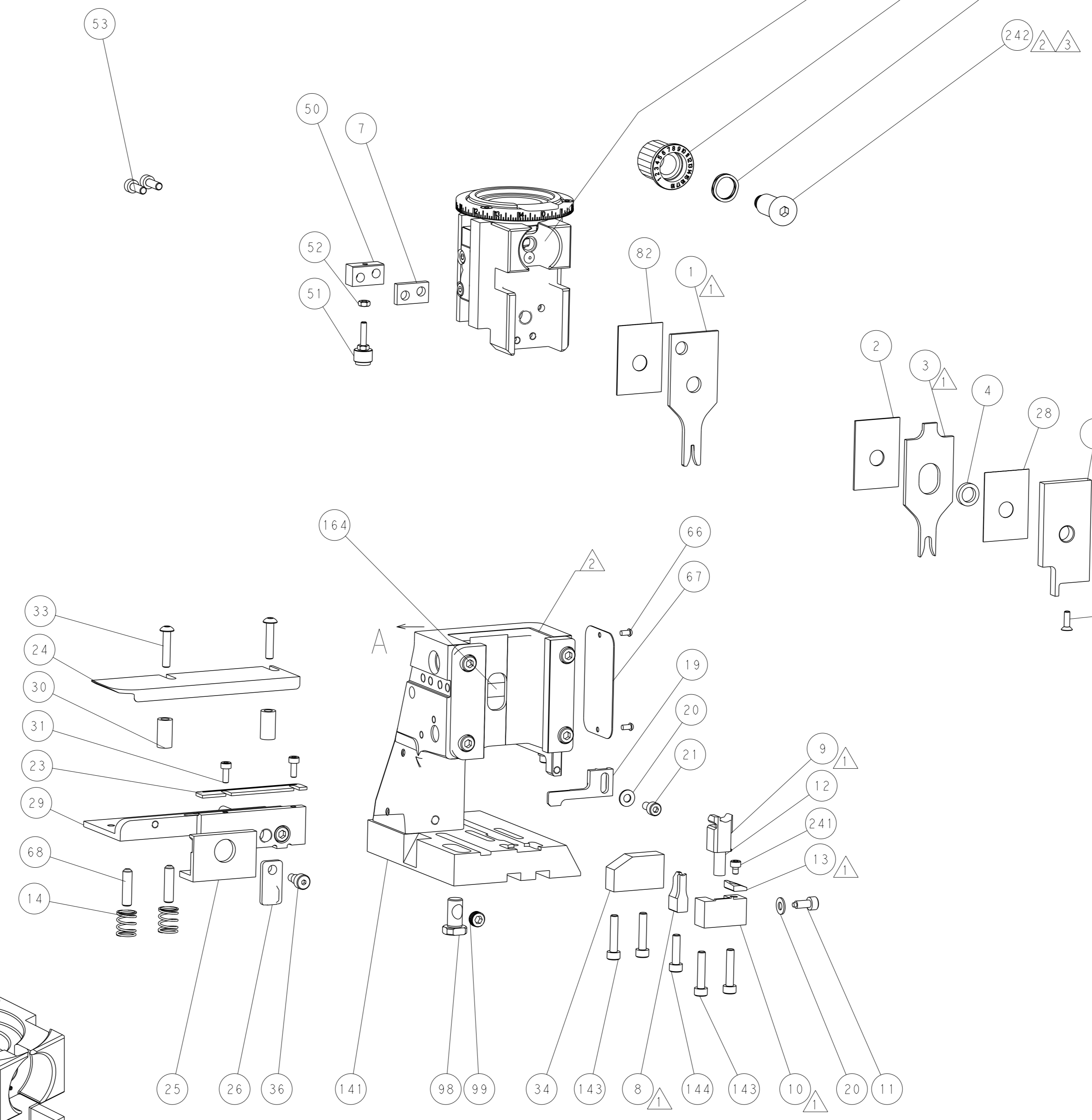
MECHANICAL  
POST FEED



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)

<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>		OWN: HOFFNER 30 JULY 2014 CHK: T. ELBIN 31 JULY 2014 APVD: T. ELBIN 31 JULY 2014	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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266433	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: B	CUSTOMER ACCESSIBLE PRODUCTION DRAWING