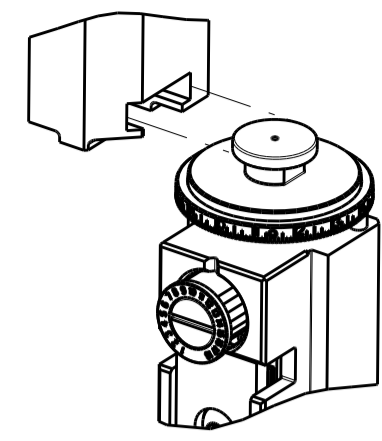


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266098-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266098-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266098-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266098-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266098-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.46 mm [.097]	F
INSUL	4.60 mm [.181]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: DELPHI TERMINAL	
WIRE STRIP LENGTH 4.80-5.56 mm [.189-.219 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.80-2.40 mm [.071-.094 IN]
TERMINAL APPLICATION SPECIFICATION	DELPHI SPEC

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	
2113389-1	12077412	1949807-1	15324982	2.0-2.9 mm
		1949807-2	15324984	2.0-2.4 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.80+/-0.05 [1.071+/-0.002]	8.2
1.00mm2	1.70+/-0.05 [1.067+/-0.002]	9.3

- 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.
- 6 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.

***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)

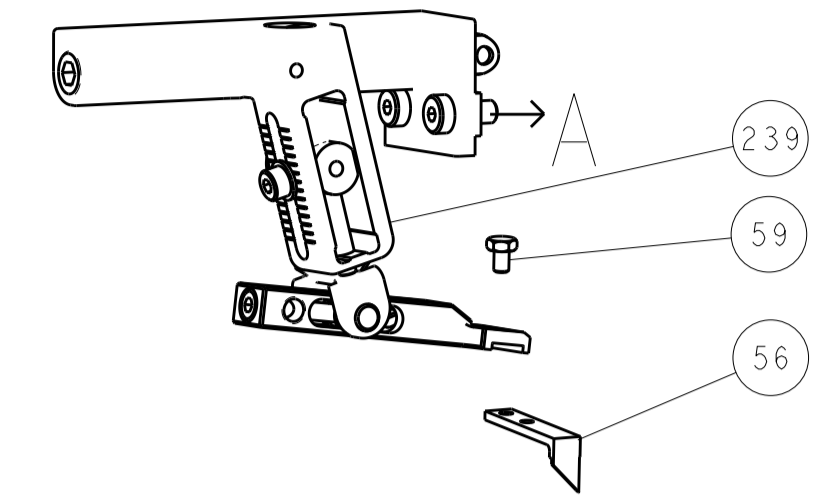
LOC	DIST	REV	DATE	BY	APPV
A	66	A	14JAN2013	XZ	TE
		B	11SEP2019	FZ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	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	-	-	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	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	1803607-3	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	
6	-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	3-2844962-0	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	
-	1	1	1	1	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	1	2	2	1	1	3-1633928-7	ANVIL, COMBINATION	8
-	1	1	1	1	1-240641-9	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119781-0	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	6-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
1	1	2	2	1	1	2-1633609-8	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

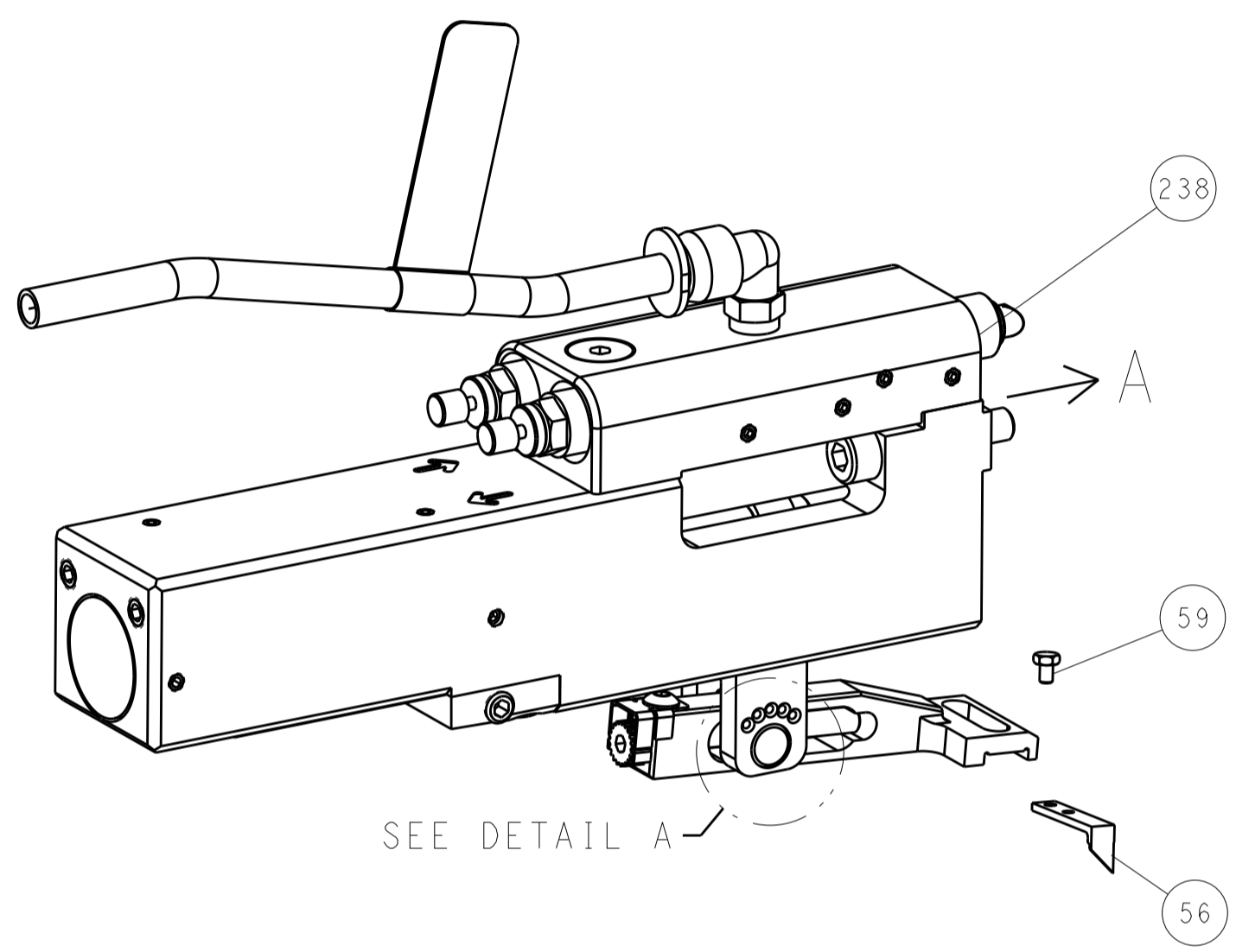
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET 1 OF 4		REV B	

LOC	DIST	REV	DATE	BY	APPV
A	66				

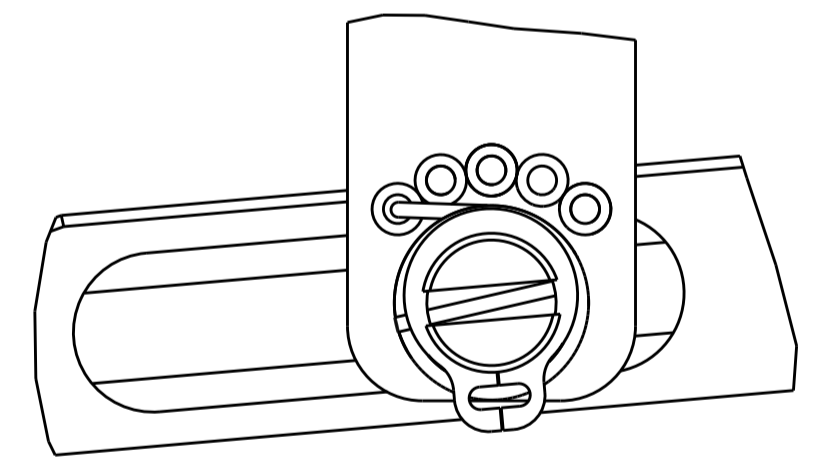
FEED TYPE MECHANICAL



PNEUMATIC

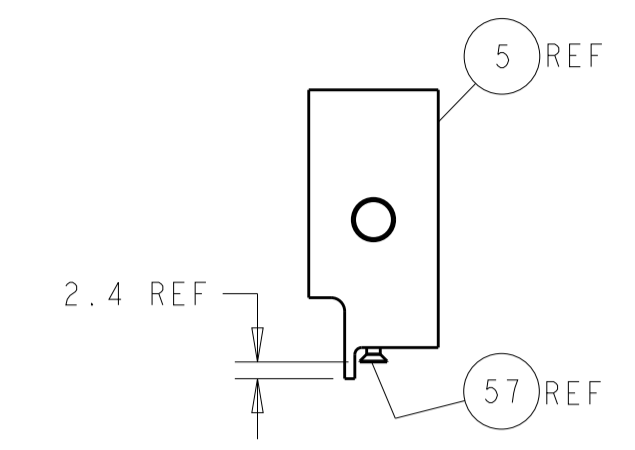
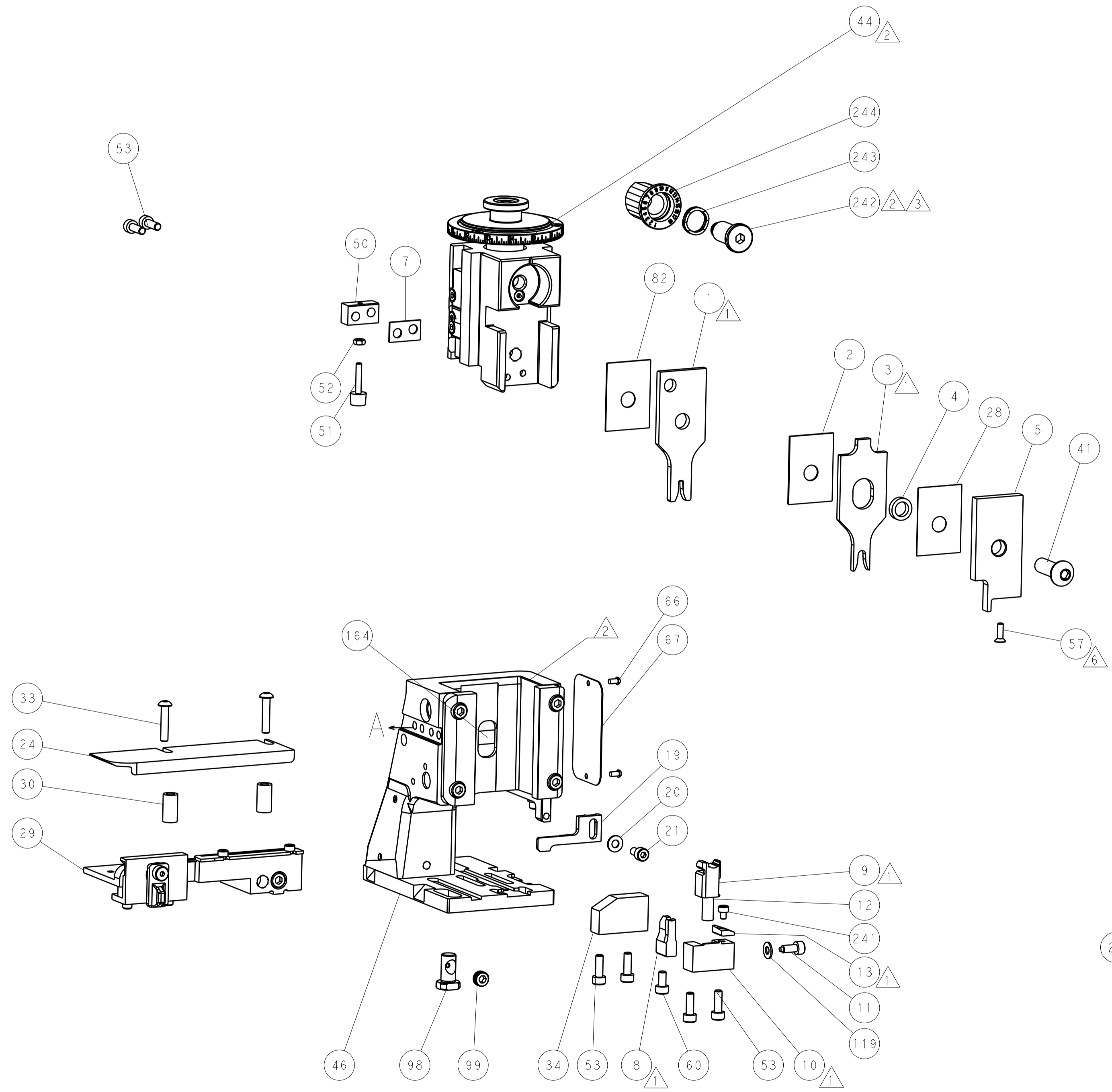
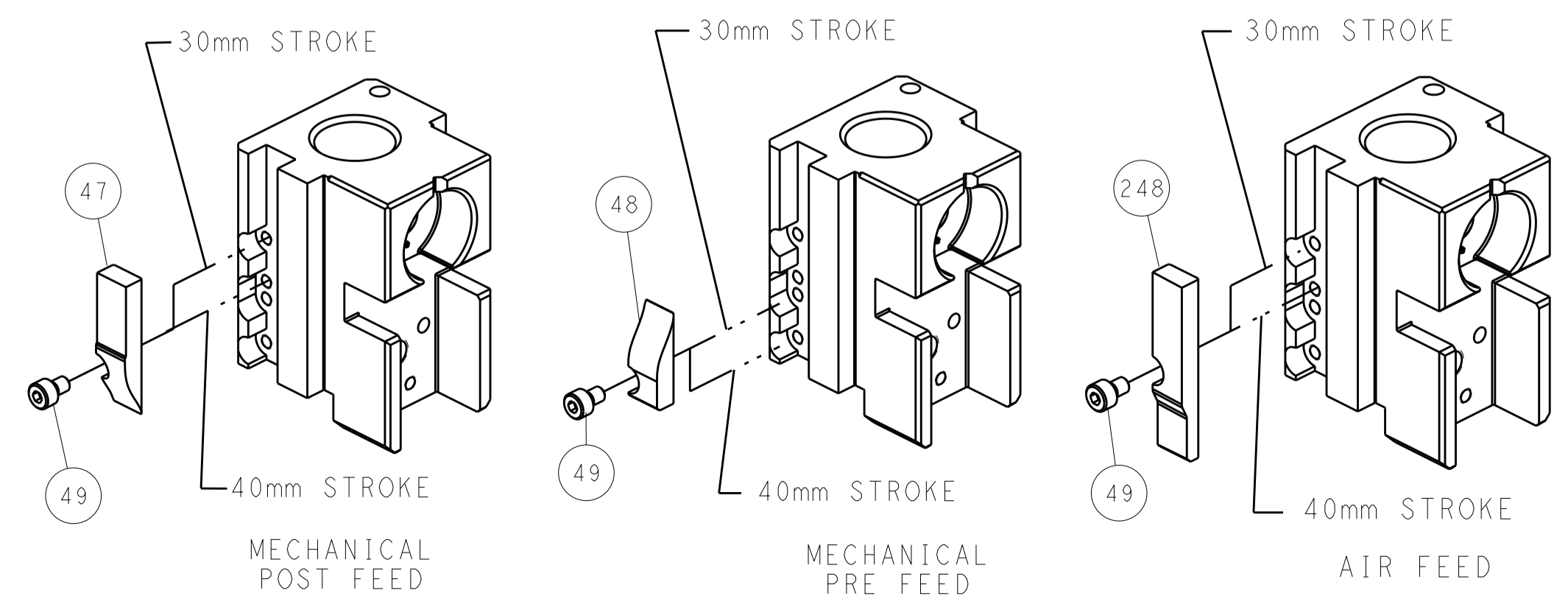


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

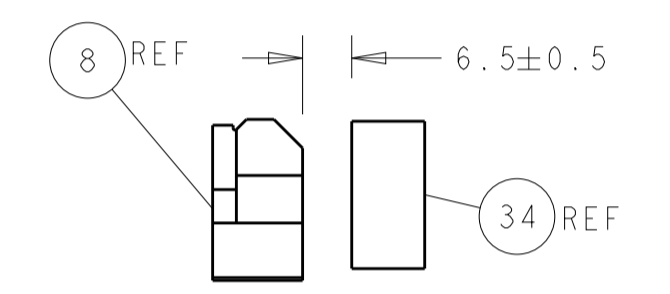


DETAIL A

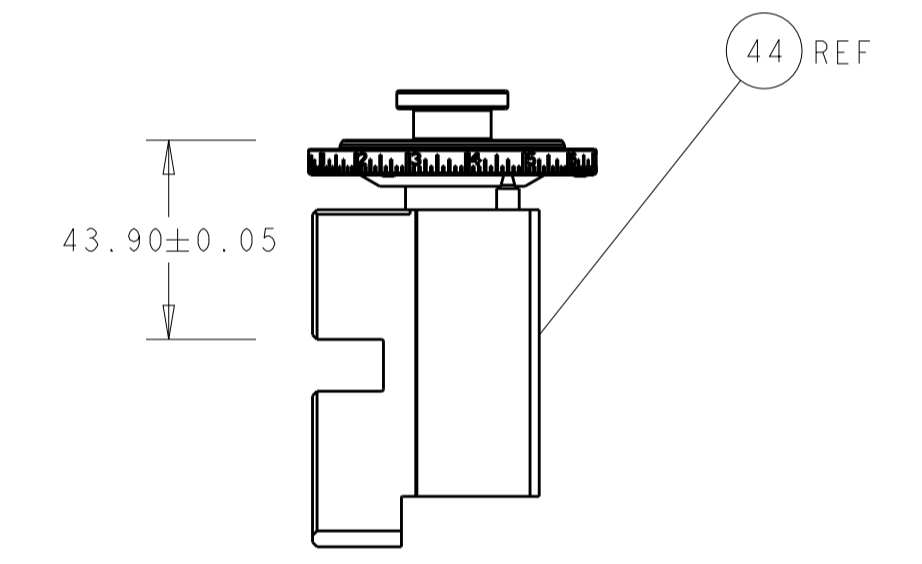
CAM POSITIONS



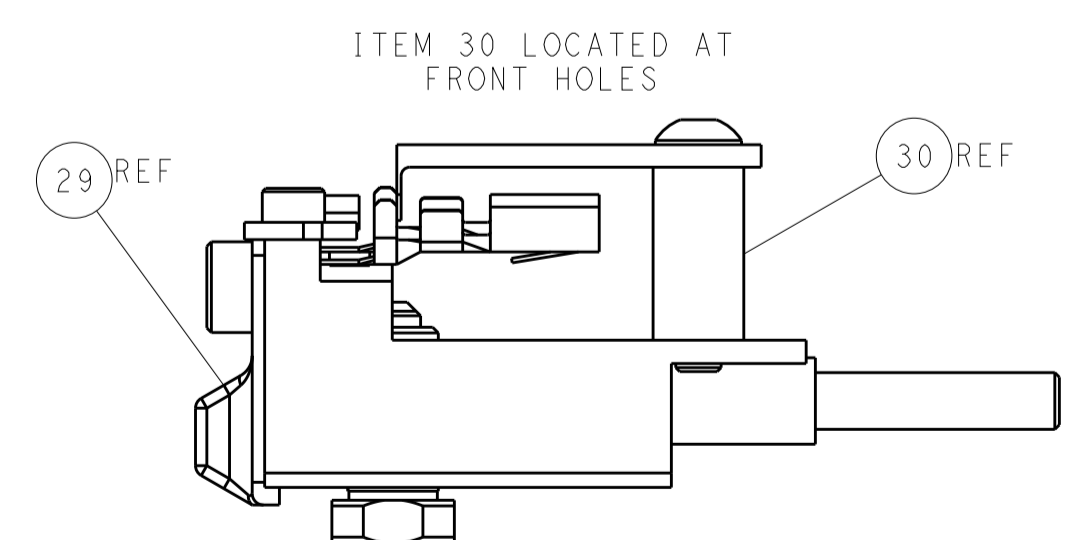
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



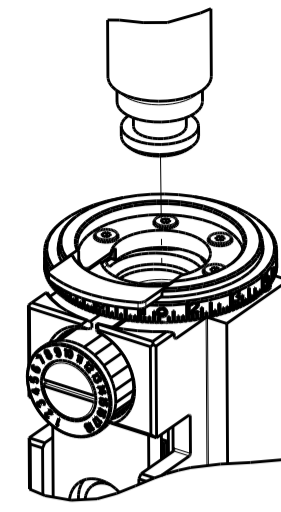
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X_ZHAO 01NOV2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: T_ELFIN 01NOV2013		NAME: Ocean Side Feed Applicator	
				APVD: L_ZHANG 01NOV2013		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2266098	
				WEIGHT:		SCALE: 1:2	
				Customer Accessible Production Drawing		SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266098-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266098-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266098-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.46 mm [.097]	F
INSUL	4.60 mm [.181]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: DELPHI TERMINAL	
WIRE STRIP LENGTH 4.80-5.56 mm [1.89-.219 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.80-2.40 mm [0.071-.094 IN]
TERMINAL APPLICATION SPECIFICATION DELPHI SPEC	-

TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
2113389-1	12077412	1949807-1	15324982	2.0-2.9 mm
		1949807-2	15324984	2.0-2.4 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.80+/-0.05 [0.071+/-0.002]	8.2
1.00mm2	1.70+/-0.05 [0.067+/-0.002]	9.3

- 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.
- 6 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.

***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	2119082-7	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	-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	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
-	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	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	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
-	1	1	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	3-1633928-7	ANVIL, COMBINATION	8
-	1	1	1-240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119781-0	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	6-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	2-1633609-8	CRIMPER, WIRE	1

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

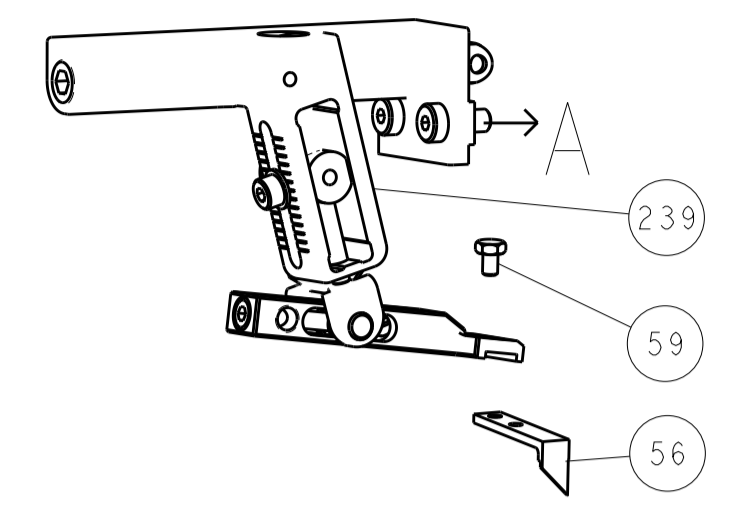
APVD	OWN	CHK	DATE
L. ZHANG	01NOV2013	X. ZHAO	01NOV2013
T. ELBIN	01NOV2013		

NAME	TE Connectivity		
ADDRESS	Harrisburg, PA 17105-3608		
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2266098	B

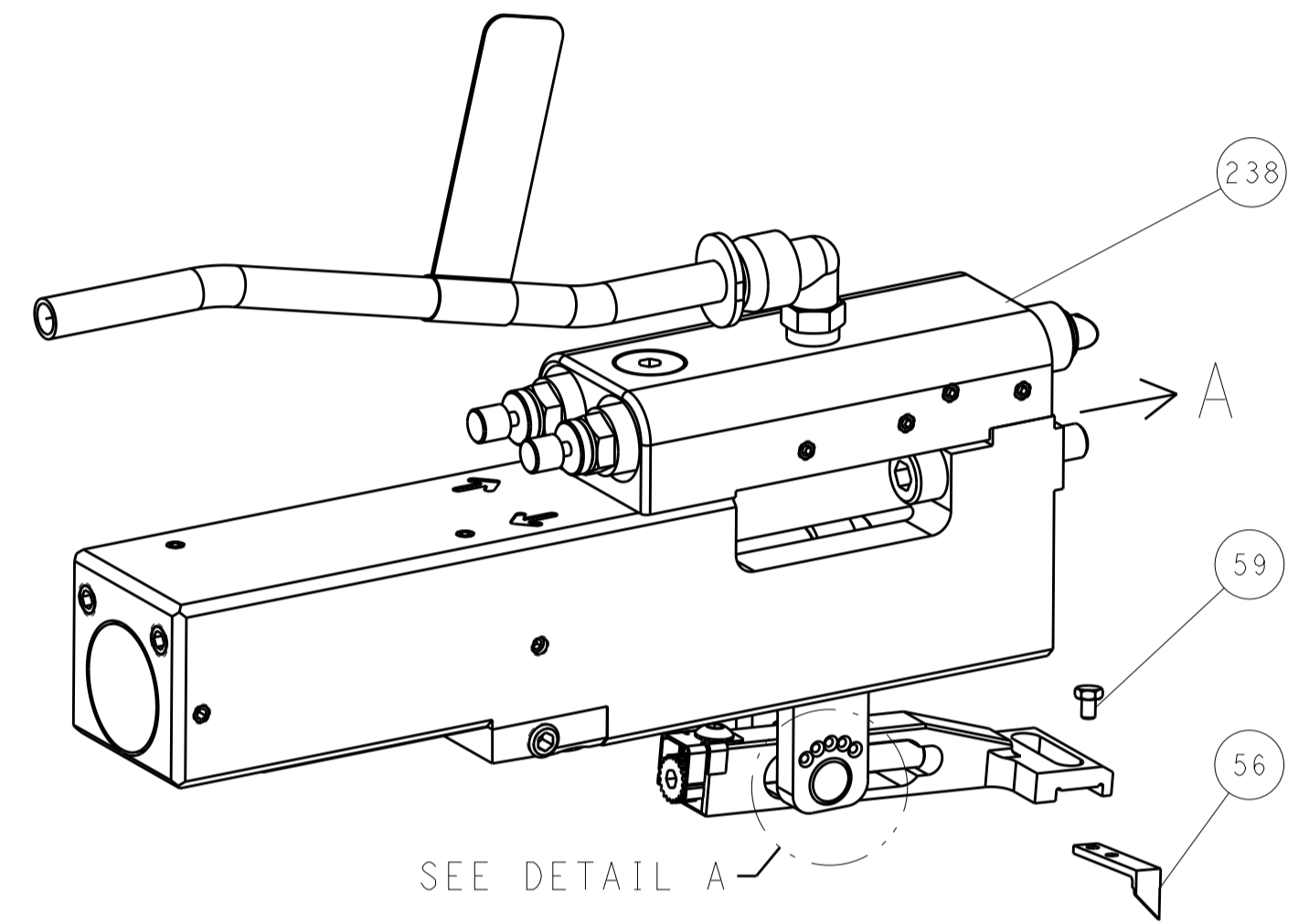
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B

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

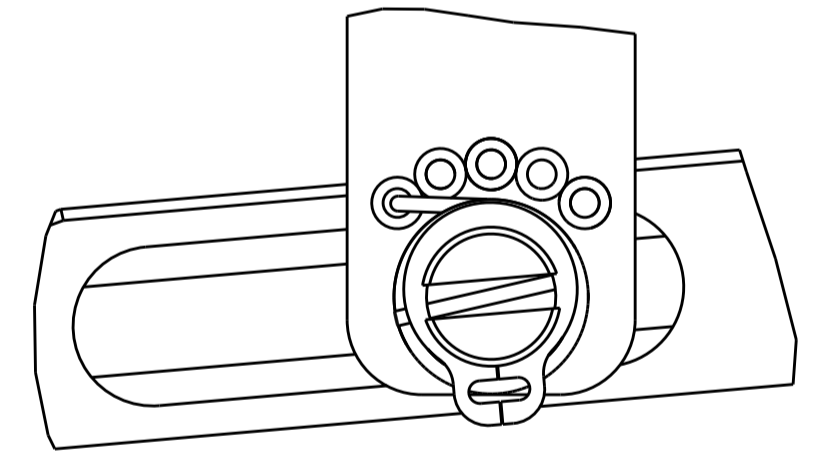
FEED TYPE MECHANICAL



PNEUMATIC

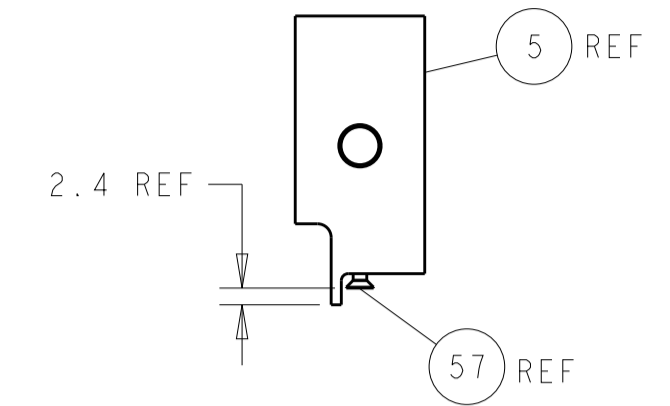
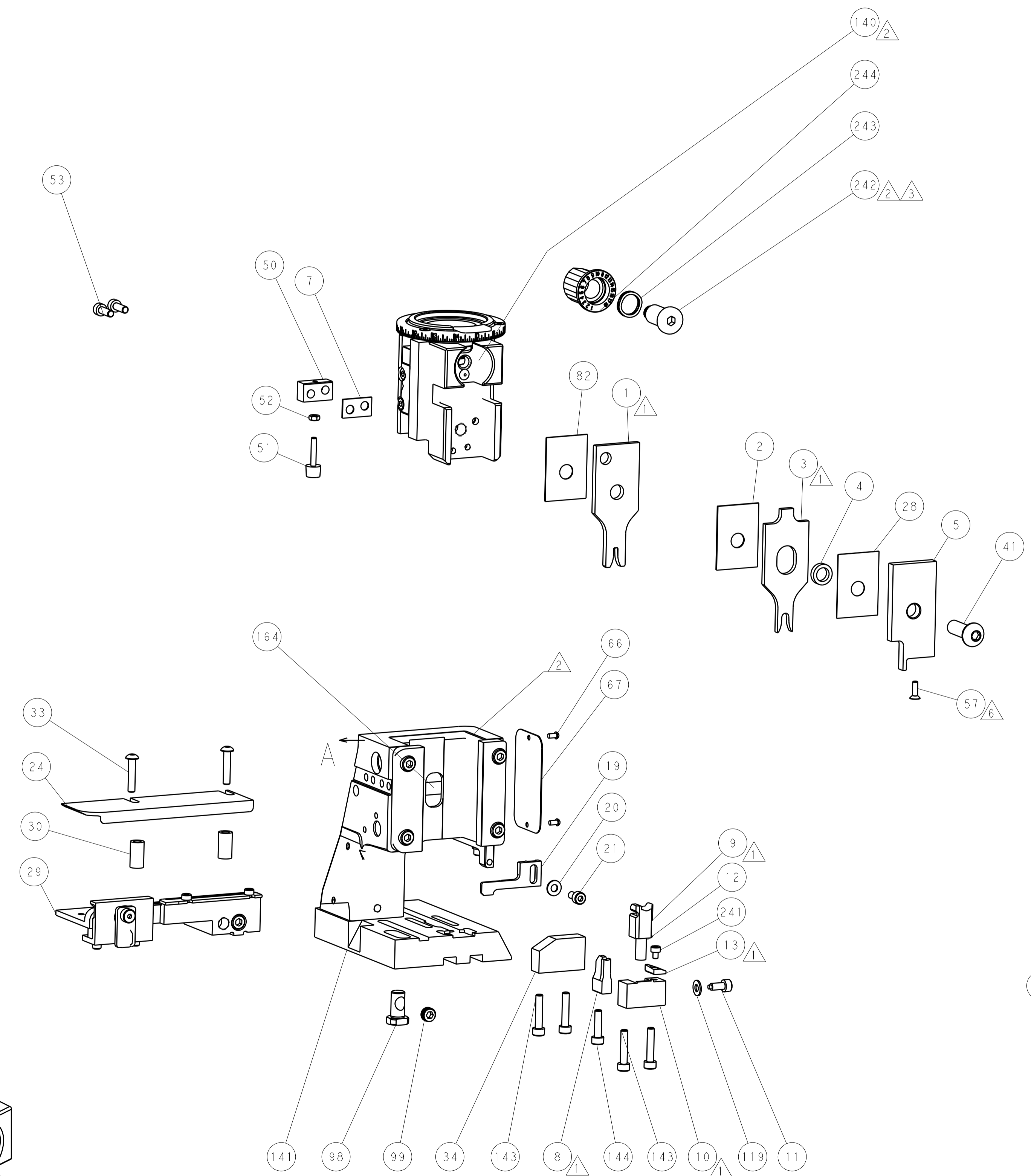
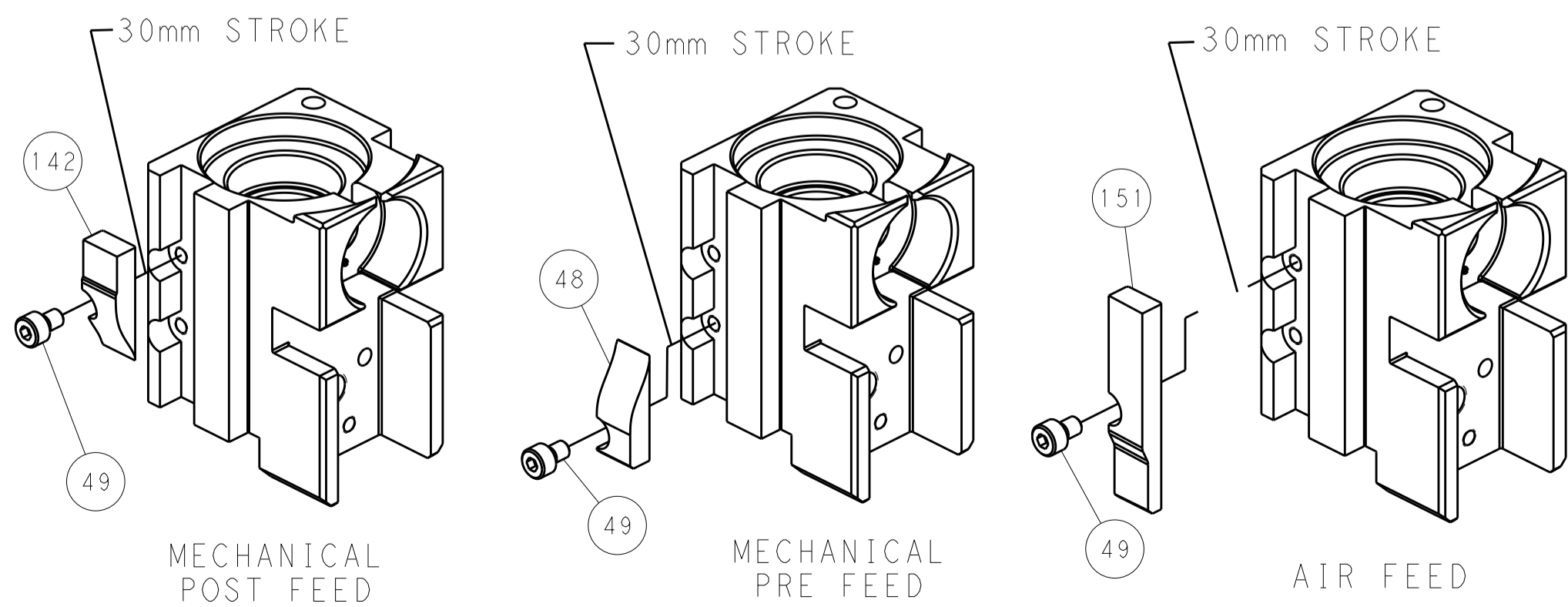


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

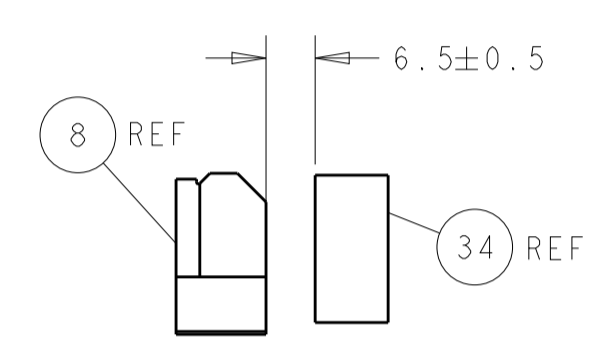


DETAIL A

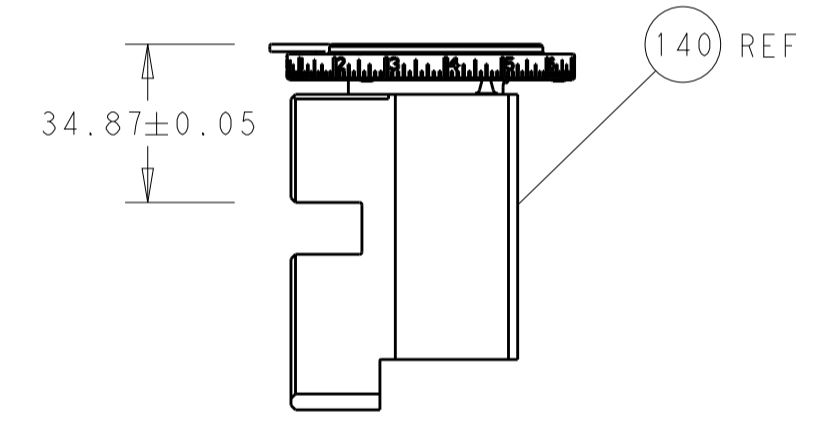
CAM POSITIONS



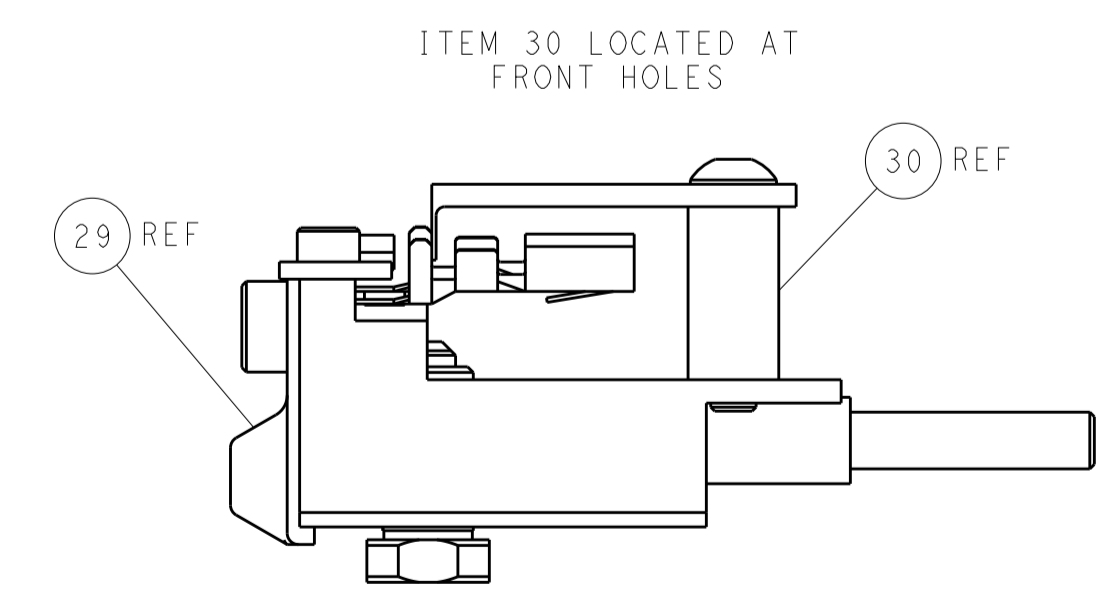
SHEAR DEPRESSOR DETAIL



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)

<small>THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS LOANED TO YOUR COMPANY BY CONTRACT. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON THE COMPLETION OF YOUR PROJECT OR AS OTHERWISE SPECIFIED.</small>		DWN: X_ZHAO 01NOV2013 CHK: T_ELBIN 01NOV2013 APVD: L_ZHANG 01NOV2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266098 SCALE: 1:2 SHEET: 4 OF 4 REV: B
MATERIAL:		WEIGHT:	RESTRICTED TO: