

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266545-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266545-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266545-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266545-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266545-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.59 mm [.220]	F
INSUL	6.86 mm [.270]	F

APPLICATOR INSTRUCTIONS
408-35043

TERMINAL DATA: DELPHI TERMINAL		DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.46-7.22 mm [.254-.284 IN]		3.20-4.30 mm [.126-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	12103517 Rev -		
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1557699-1	12103517		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	3.35 +/- 0.05 [.132 +/- .002]	5.5
3.00mm2	3.05 +/- 0.05 [.120 +/- .002]	8.0

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 CUT TO LENGTH AT ASSEMBLY.

***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)

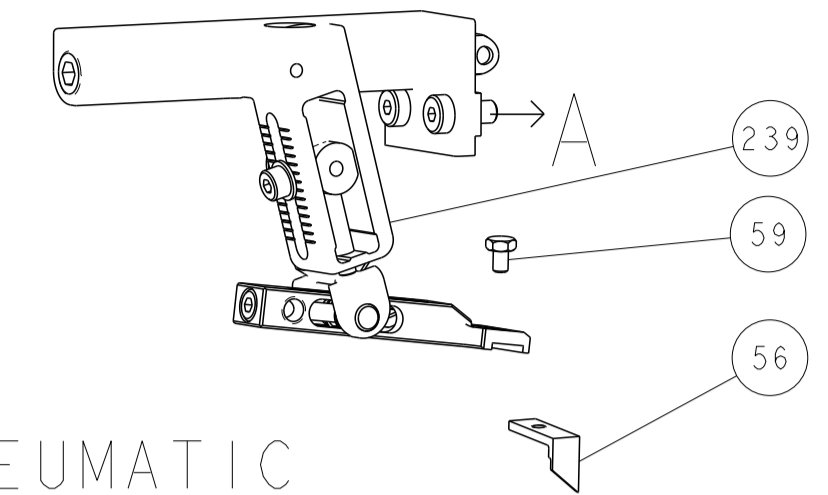
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		C		ECR-22-135827	12APR2022	JWC	RR

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	1	1	1	1	2063687-5	PLATE, REAR SHEAR	233	
-	1	1	1	1	2161951-4	BLADE, SLUG	232	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	690487-9	GUIDE, FRONT STRIP	96	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93	
-	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	
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	1338683-9	FEED PAWL	56	
-	1	1	1	1	1-811242-0	BUMPER, HOLD DOWN	51	
-	1	1	1	1	3-18031-6	SCR, SET, CUP POINT M2.5 X 3.0	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	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	45	
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	43	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	36	
-	2	2	2	2	2-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 25	30	
-	1	1	1	1	1-2305692-1	PLATE, REAR STRIP GUIDE	29	
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-7	DRAG, TERMINAL	25	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	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	1-2119533-0	STRIPPER, SIDE FEED	19	
-	1	1	1	1	1-189124-2	GUIDE, FRONT STRIP	12	
-	1	1	1	1	1803011-6	HOLDER, SLUG BLADE	11	
-	-	-	-	-	-	-	10	
-	-	-	-	-	-	-	9	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	-	-	-	-	-	-	5	
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4	
-	1	2	2	1	1	9-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	2	2	1	1	456413-6	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

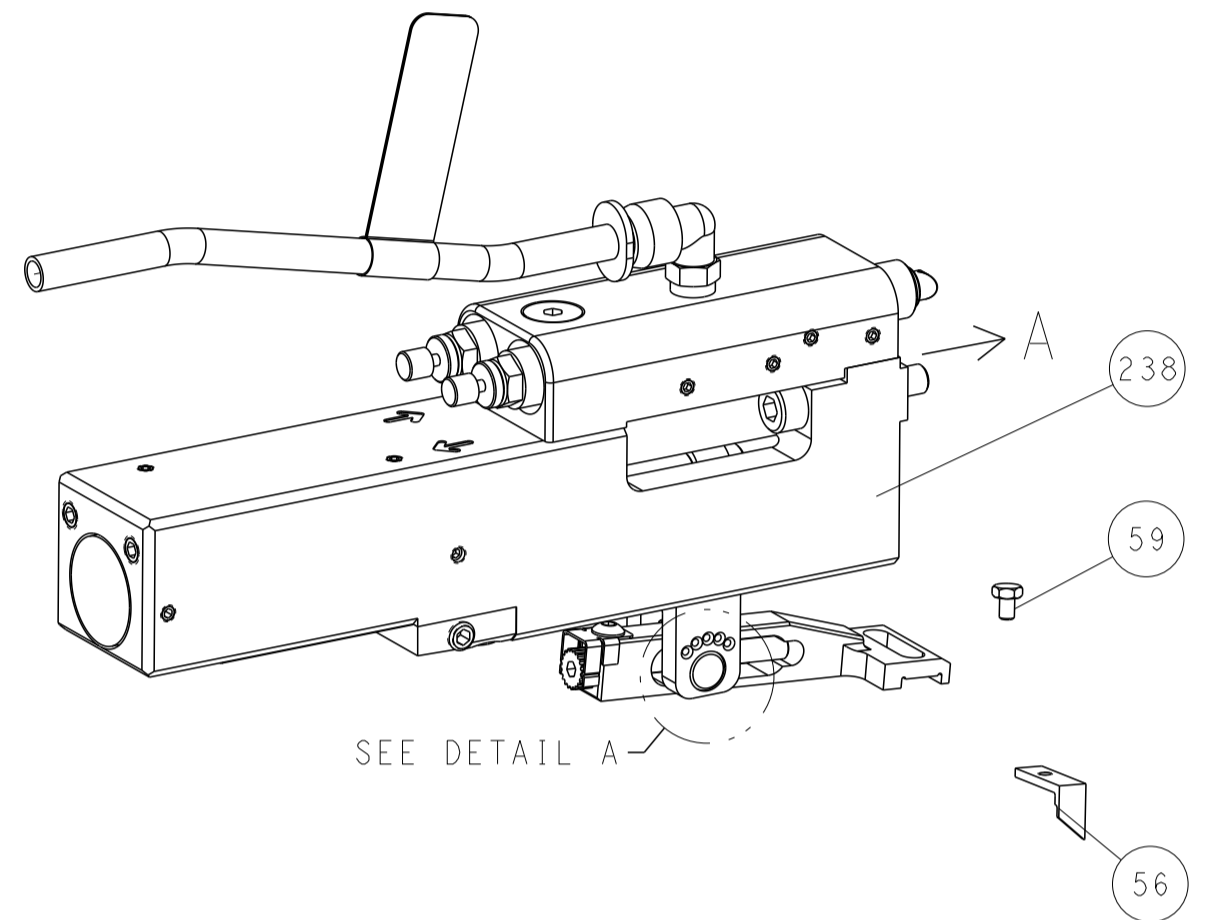
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION</small> <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION</small>		DWN: STAKEM 28JAN2014 CHK: T. ELBIN 28JAN2014 APVD: T. ELBIN 28JAN2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266545 RESTRICTED TO: -
MATERIAL: -		WEIGHT: -	Customer Accessible Production Drawing SCALE: 1:2 SHEET: 1 OF 4 REV: C

LOC	DIST	REVISIONS					
A	66	P	LYN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

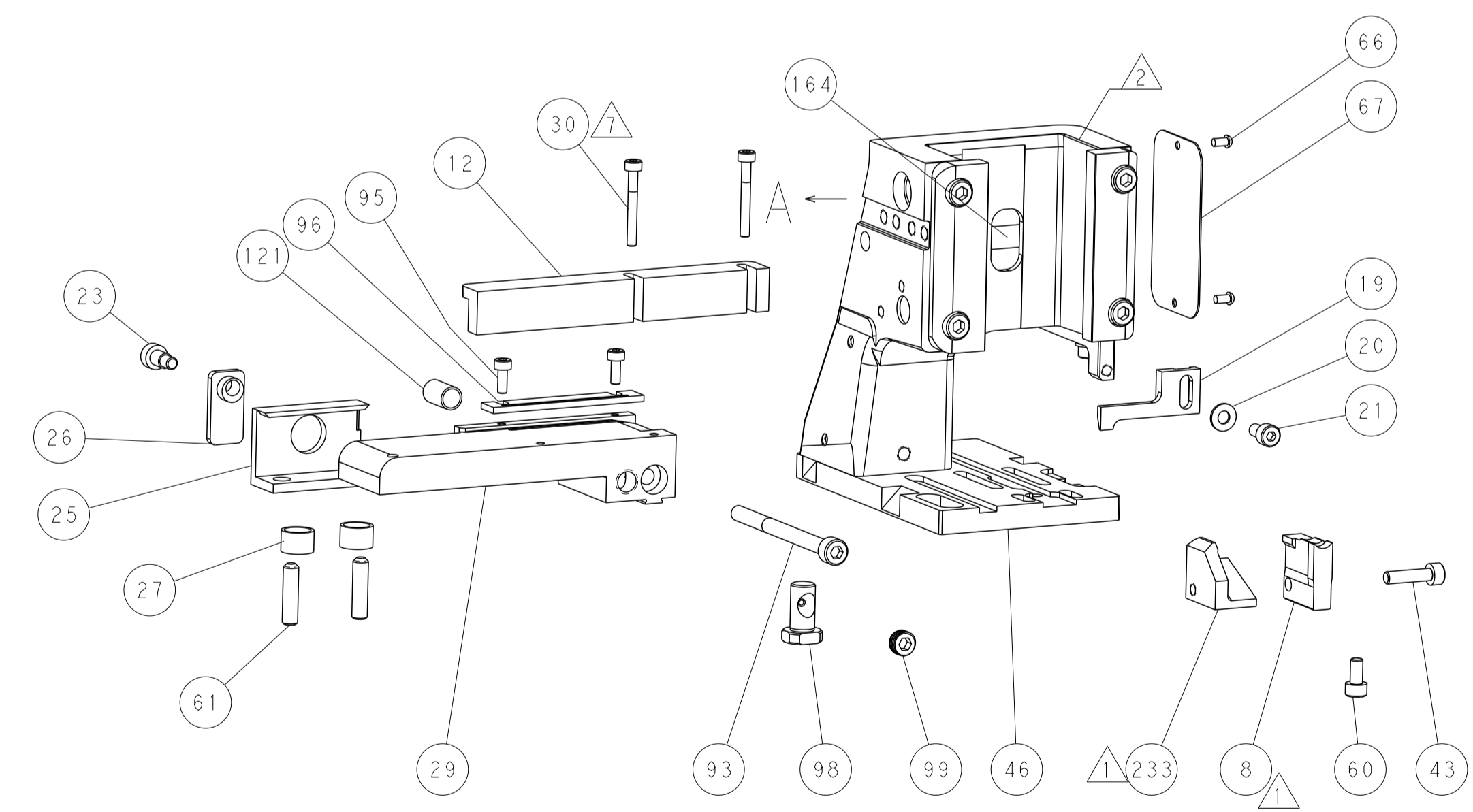
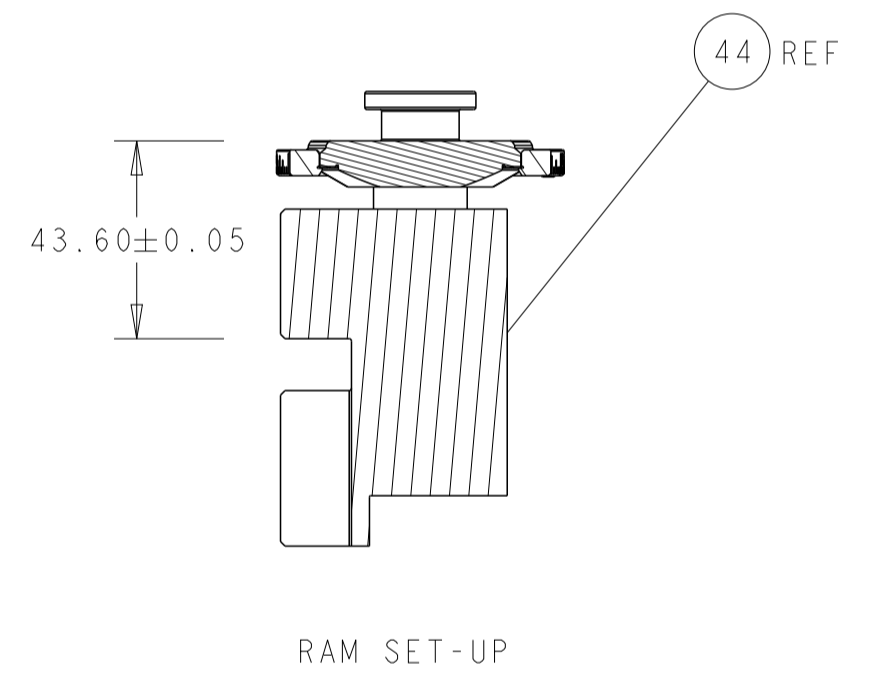
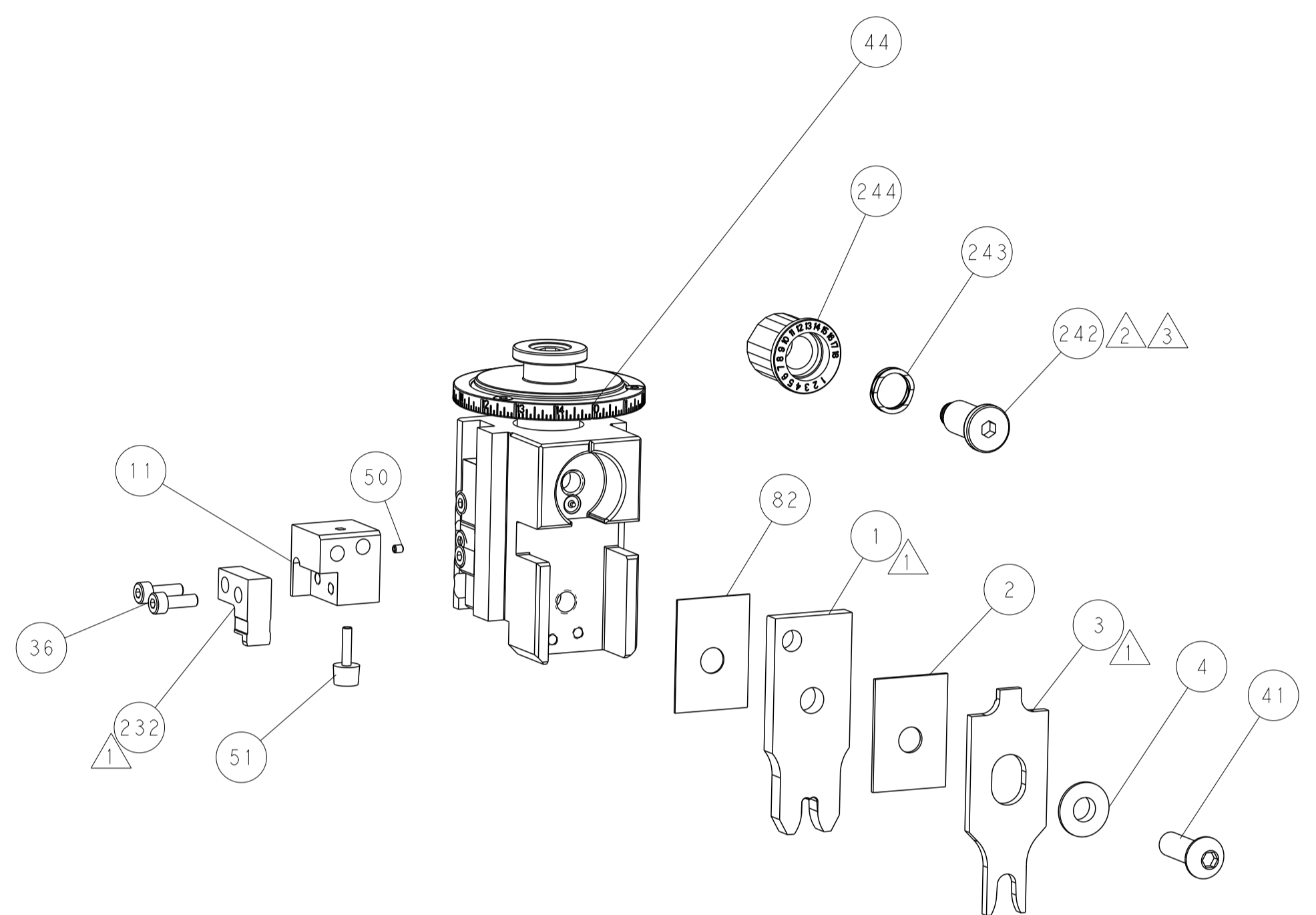
FEED TYPE MECHANICAL



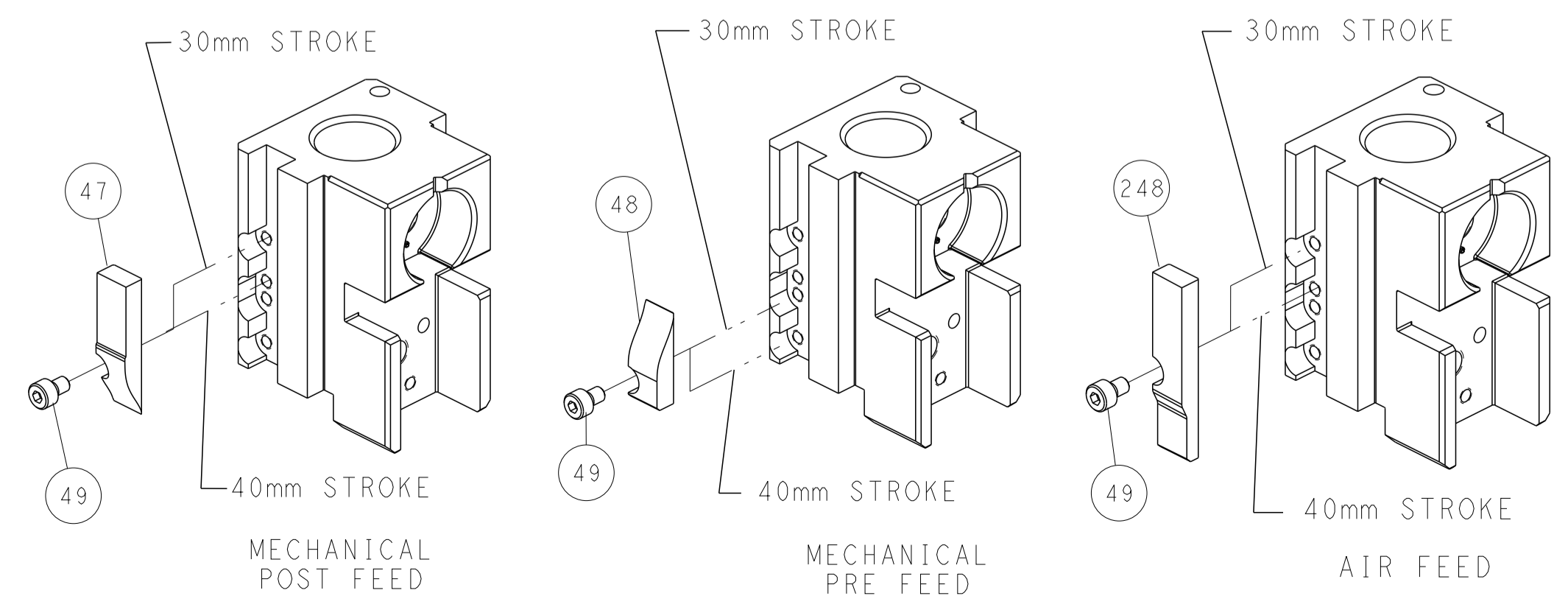
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



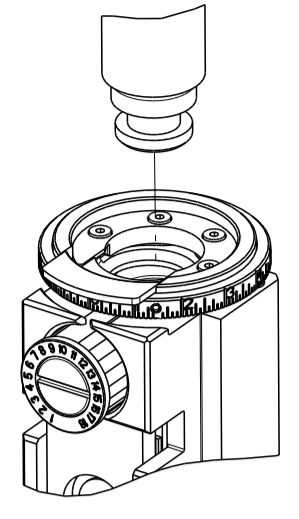
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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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=2266545	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: C
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8 7 6 5 4 3 2 1
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2-2266545-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266545-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.59 mm [.220]	F
INSUL	6.86 mm [.270]	F
APPLICATOR INSTRUCTIONS		
408-35043		

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 6.46-7.22 mm [.254-.284 IN]	INSULATION DIAMETER RANGE 3.20-4.30 mm [.126-.169 IN]		
TERMINAL APPLICATION SPECIFICATION 12103517 Rev -			
TERMINALS APPLIED			
TE TERMINAL 1557699-1	DELPHI TERMINAL 12103517	TE TERMINAL	DELPHI TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	3.35 +/- 0.05 [.132 +/- .002]	5.5
3.00mm2	3.05 +/- 0.05 [.120 +/- .002]	8.0



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
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PACIFIC VERSION
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 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

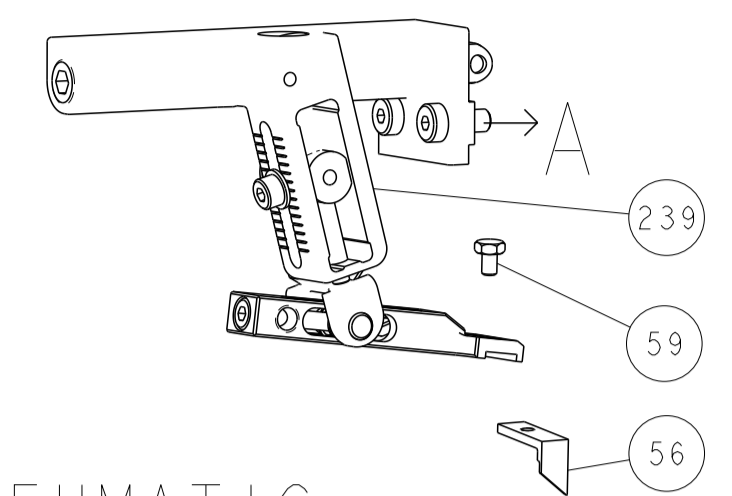
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-4	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
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-	1	1	2063687-5	PLATE, REAR SHEAR	233
-	1	1	2161951-4	BLADE, SLUG	232
-	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
-	-	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	690487-9	GUIDE, FRONT STRIP	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	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
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-9	FEED PAWL	56
-	1	1	1-811242-0	BUMPER, HOLD DOWN	51
-	1	1	3-18031-6	SCR, SET, CUP POINT M2.5 X 3.0	50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	45
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	43
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	36
-	2	2	2-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 25	30
-	1	1	1-2305692-1	PLATE, REAR STRIP GUIDE	29
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-7	DRAG, TERMINAL	25
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	1-2119533-0	STRIPPER, SIDE FEED	19
-	1	1	1-189124-2	GUIDE, FRONT STRIP	12
-	1	1	1803011-6	HOLDER, SLUG BLADE	11
-	-	-	-	-	10
-	-	-	-	-	9
-	-	-	-	-	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	456413-6	CRIMPER, WIRE PREMIUM	1
-	77	-22	-21	PART NO	
-	-	-	-	DESCRIPTION	ITEM NO

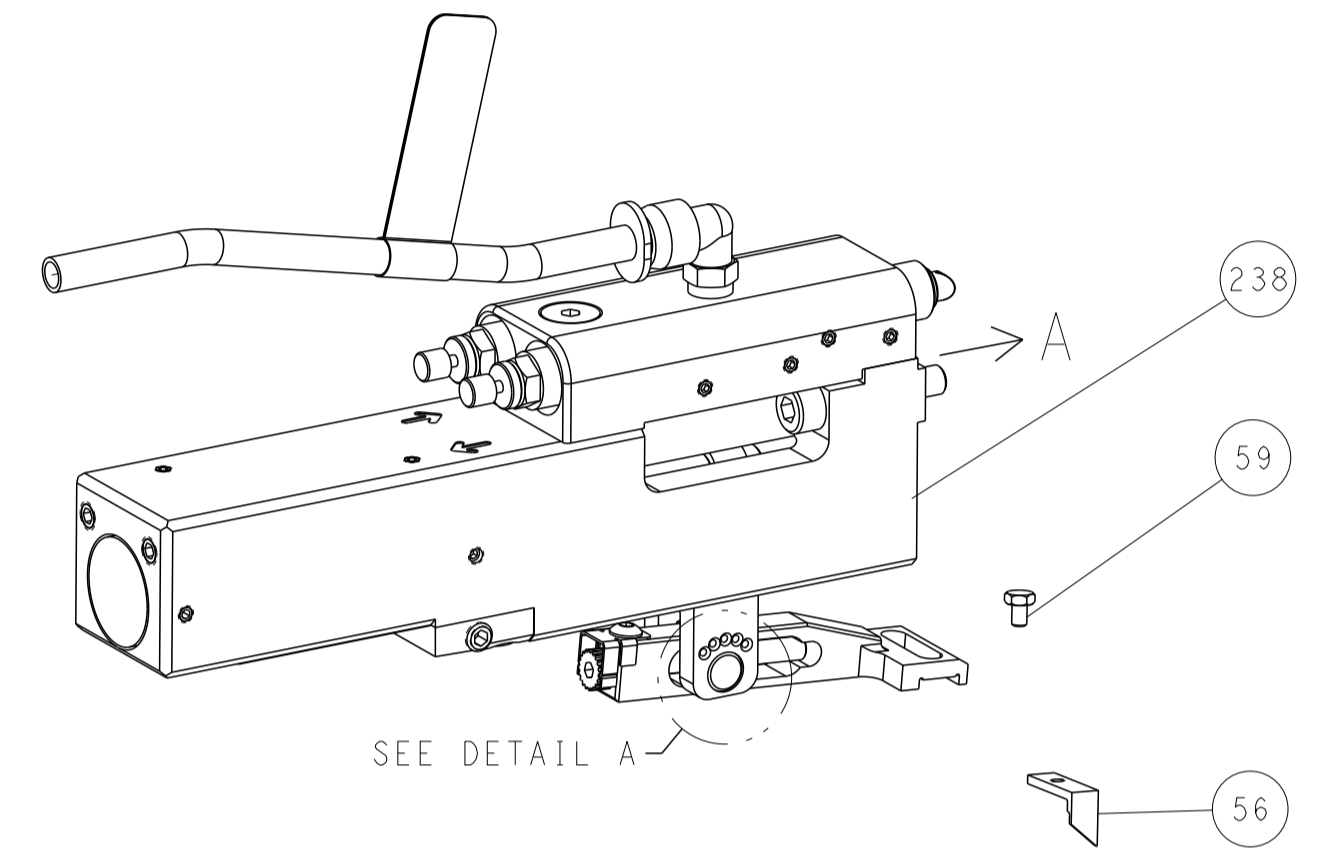
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ANGLES		FINISH		APVD	
				T. STAKEM 28JAN2014	
				I. ELBIN 28JAN2014	
				APVD I. ELBIN 28JAN2014	
				NAME	
				OCEAN SIDE FEED APPLICATOR	
				SIZE	
				A 00779	
				SCALE	
				1:2	
				SHEET	
				3 OF 4	
				REV	
				C	

LOC	DIST	REVISIONS					
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		-		SEE SHEET 1			

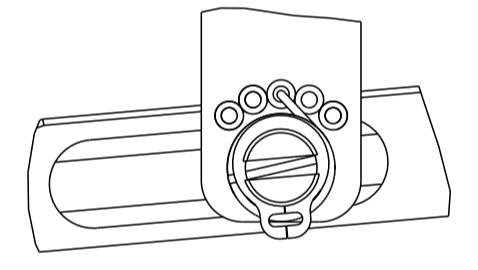
FEED TYPE MECHANICAL



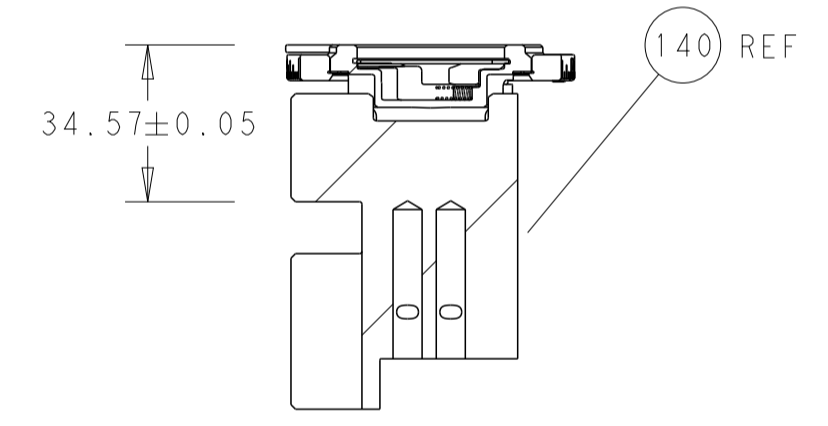
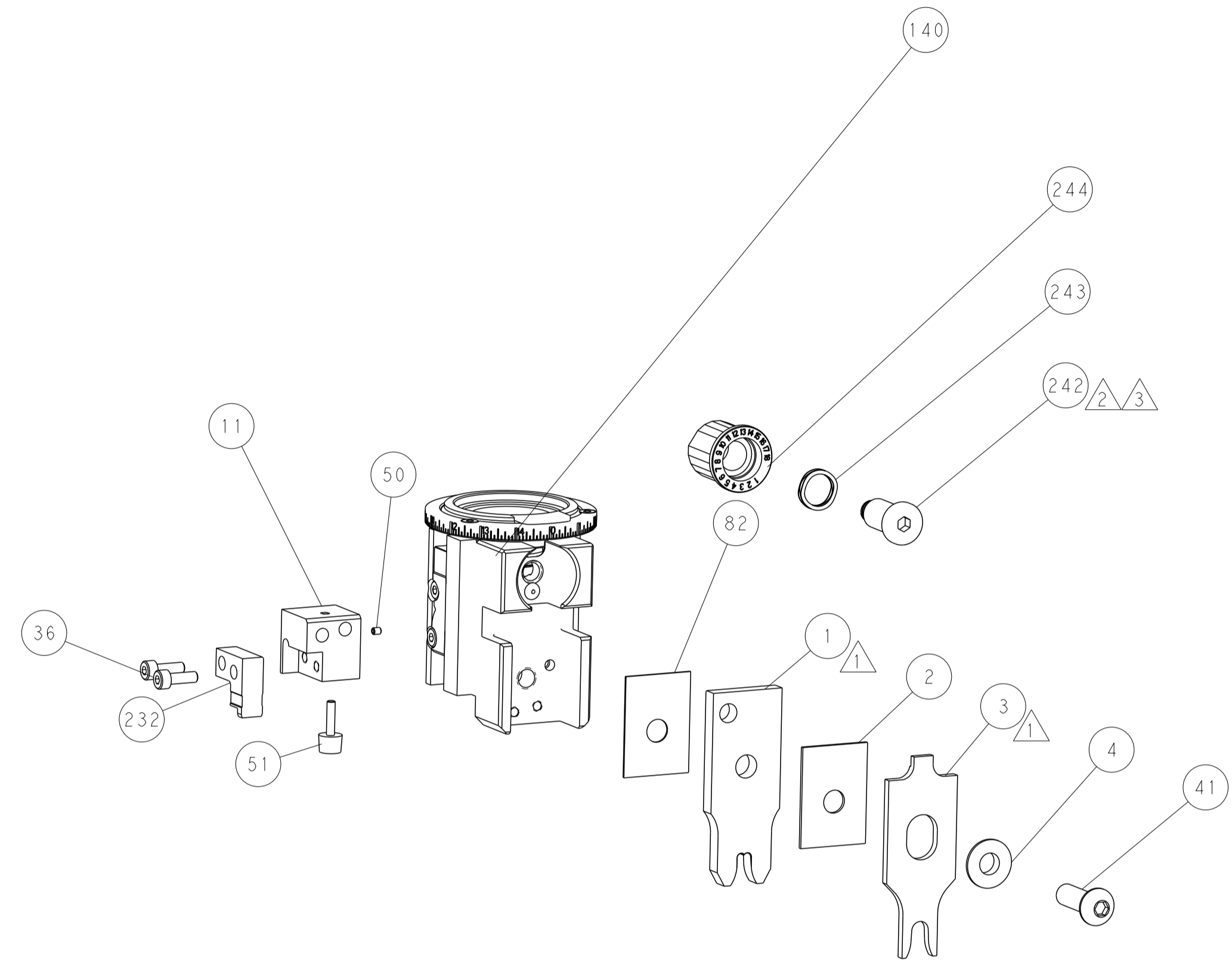
PNEUMATIC



FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

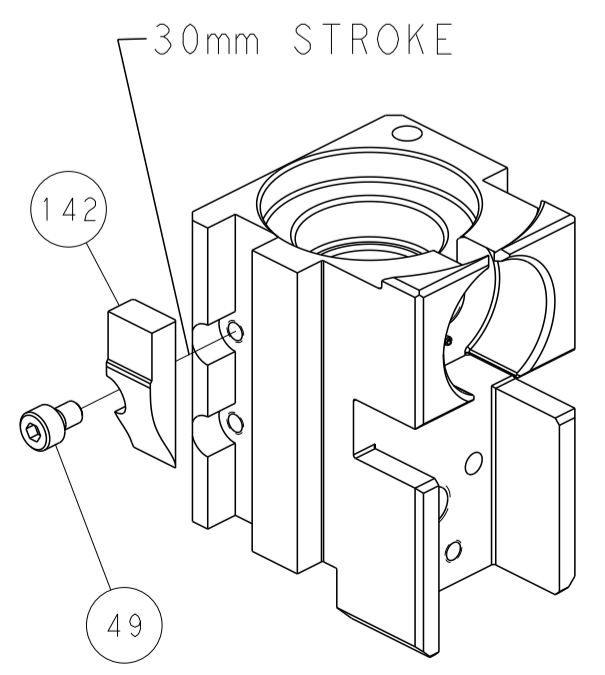


DETAIL A

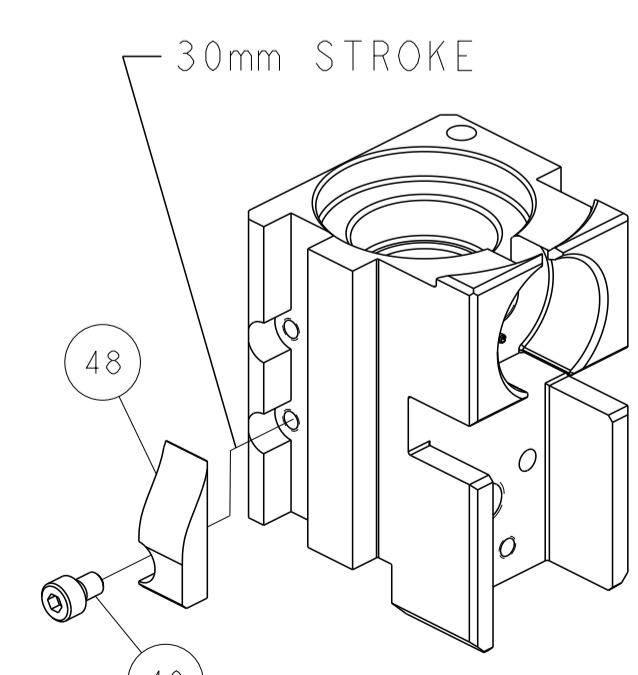


RAM SET-UP

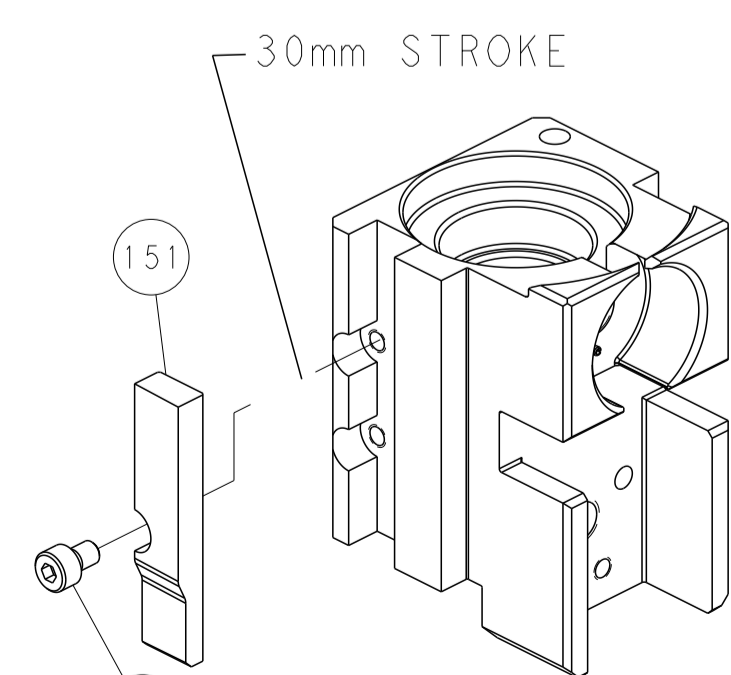
CAM POSITIONS



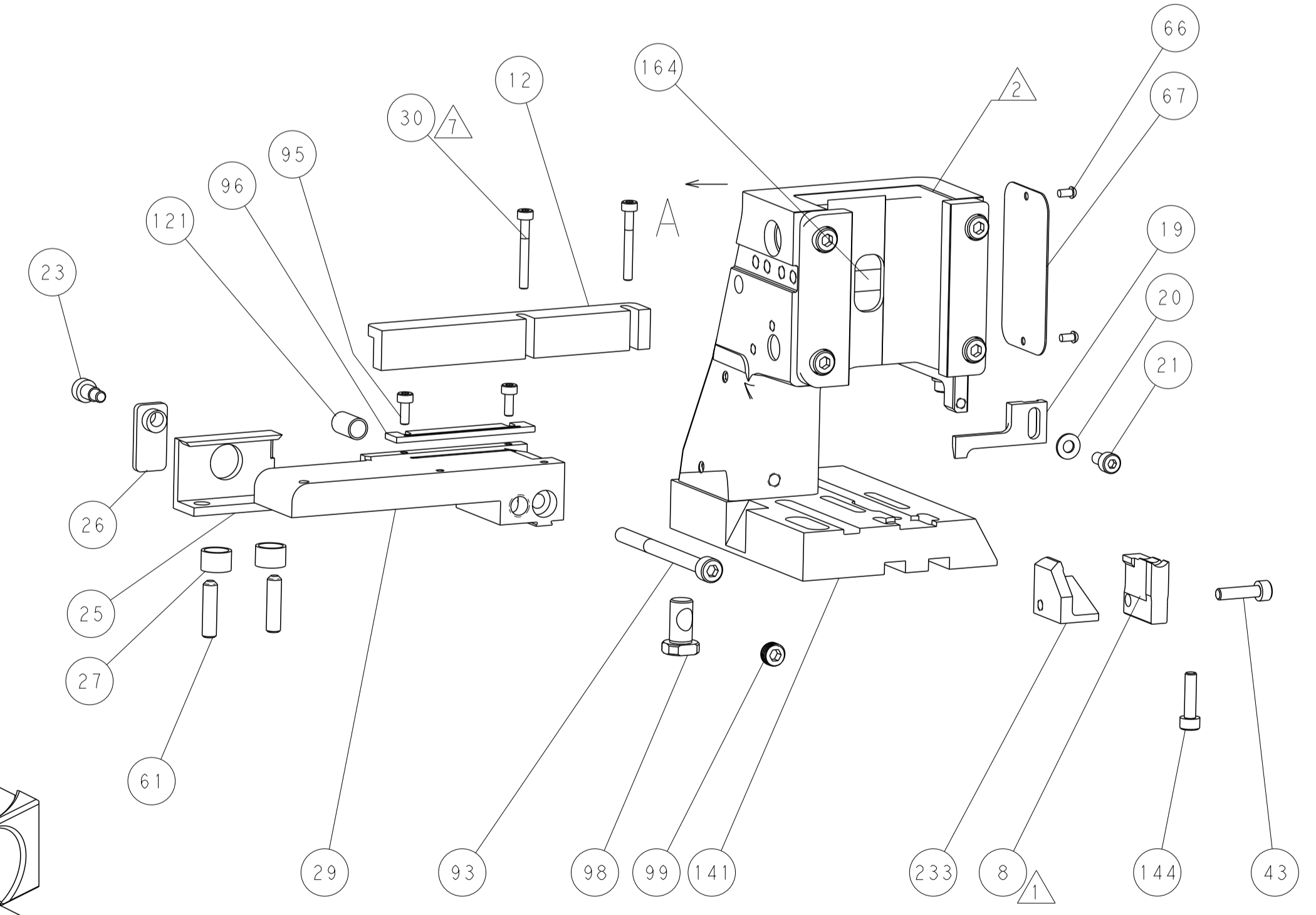
MECHANICAL
POST FEED



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 TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		TE Connectivity Harrisburg, PA 17105-3608 Customer Accessible Production Drawing		