

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266282-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266282-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266282-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266282-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266282-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.68 mm [.145]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, CRIMP QC.250,F			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.81-5.60 mm [.189-.220 IN]		Ø2.45-3.10 mm [.096-.122 IN]	
TERMINAL APPLICATION SPECIFICATION	12015870 Rev -		
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	SIEMENS TERMINAL
1949086-1	12015870	1-1393310-9	26A13488
286676-1	12015865		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.70+/-0.05 [.067+/- .002]	5.6
1.00mm2	1.55+/-0.05 [.061+/- .002]	6.4

- 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. REFER TO DELPHI CRIMP SPECIFICATION 12015870 SHEET 90F36 FOR CRIMP SPECIFICATION.
- 6. TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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)

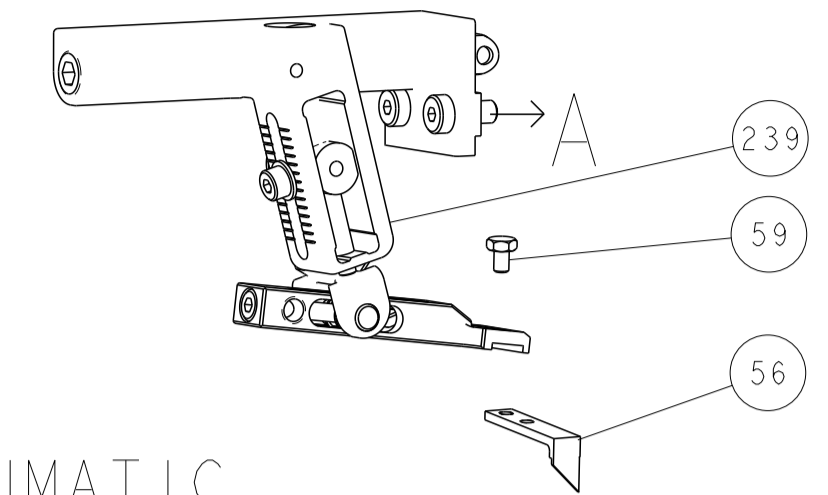
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		B		ECR-18-014744	18SEP2018	MS	TE
		C		ECR-22-137745	02MAY2022	LG	TE

-	1	1	1	1	1803078-4	SPACER, PRECISION	259	
-	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	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1	1	1	455888-8	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	
-	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	690753-6	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1	1	2-1752356-0	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	1803095-1	FLOATING SHEAR, FRONT	9	
1	2	2	1	1	1633924-4	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	3-1803016-3	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-9	SPACER, CRIMPER	2	
-	1	2	2	1	1	4-568176-3	CRIMPER, WIRE	1
-	77	72	71	-2	-1	PART NO	ITEM NO	

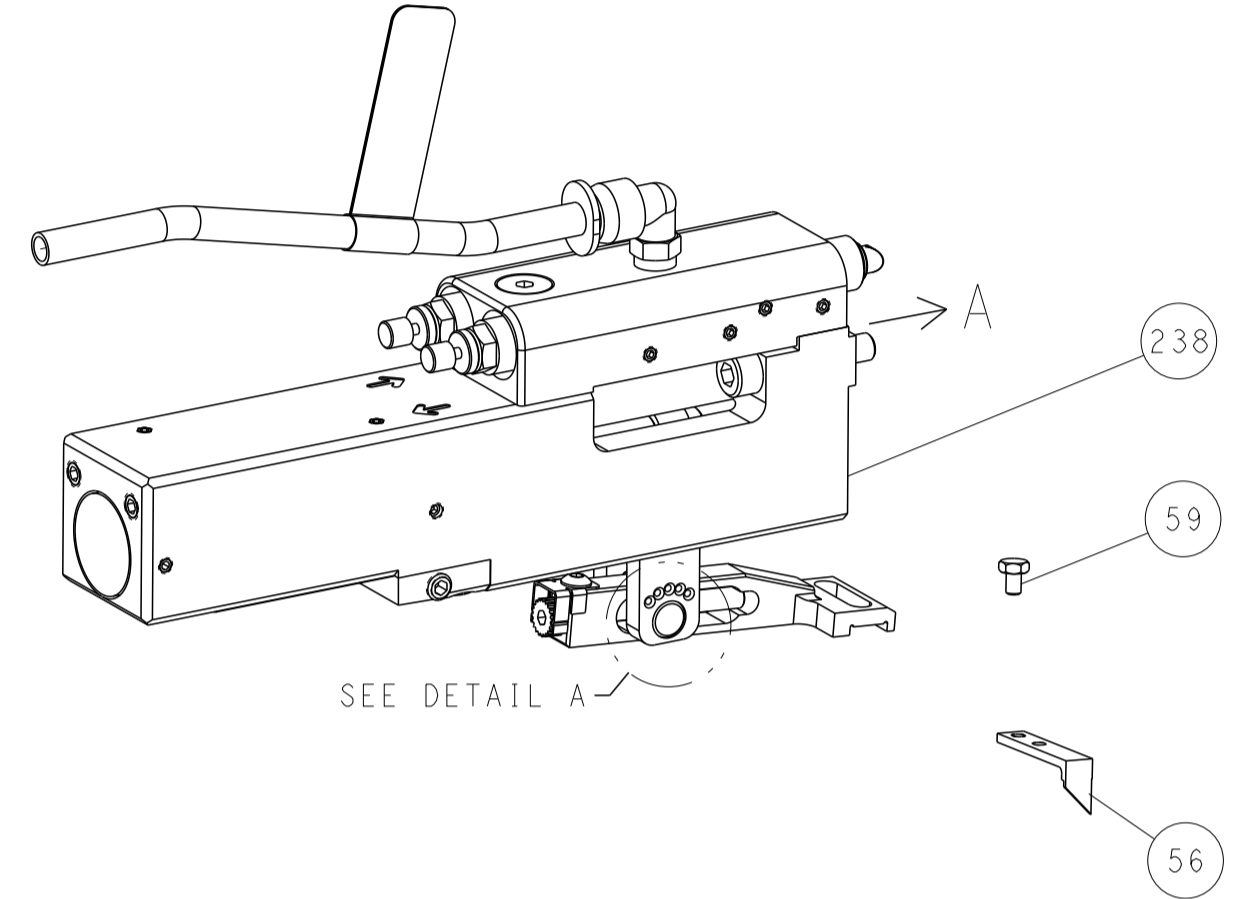
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	3 PLC ±	4 PLC ±	ANGLES ±	APVD	DATE	NAME Ocean Side Feed Applicator	
	FINISH						
MATERIAL		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	2266282	
Customer Accessible Production Drawing				SCALE	1:2	SHEET	1 OF 4

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

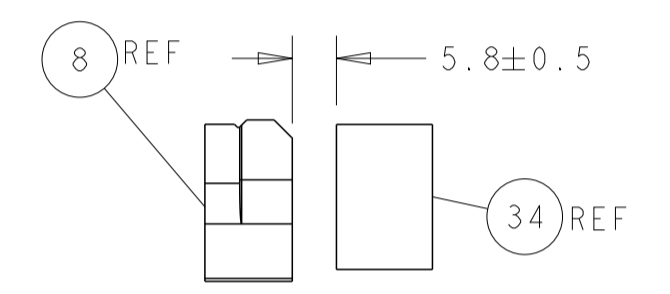
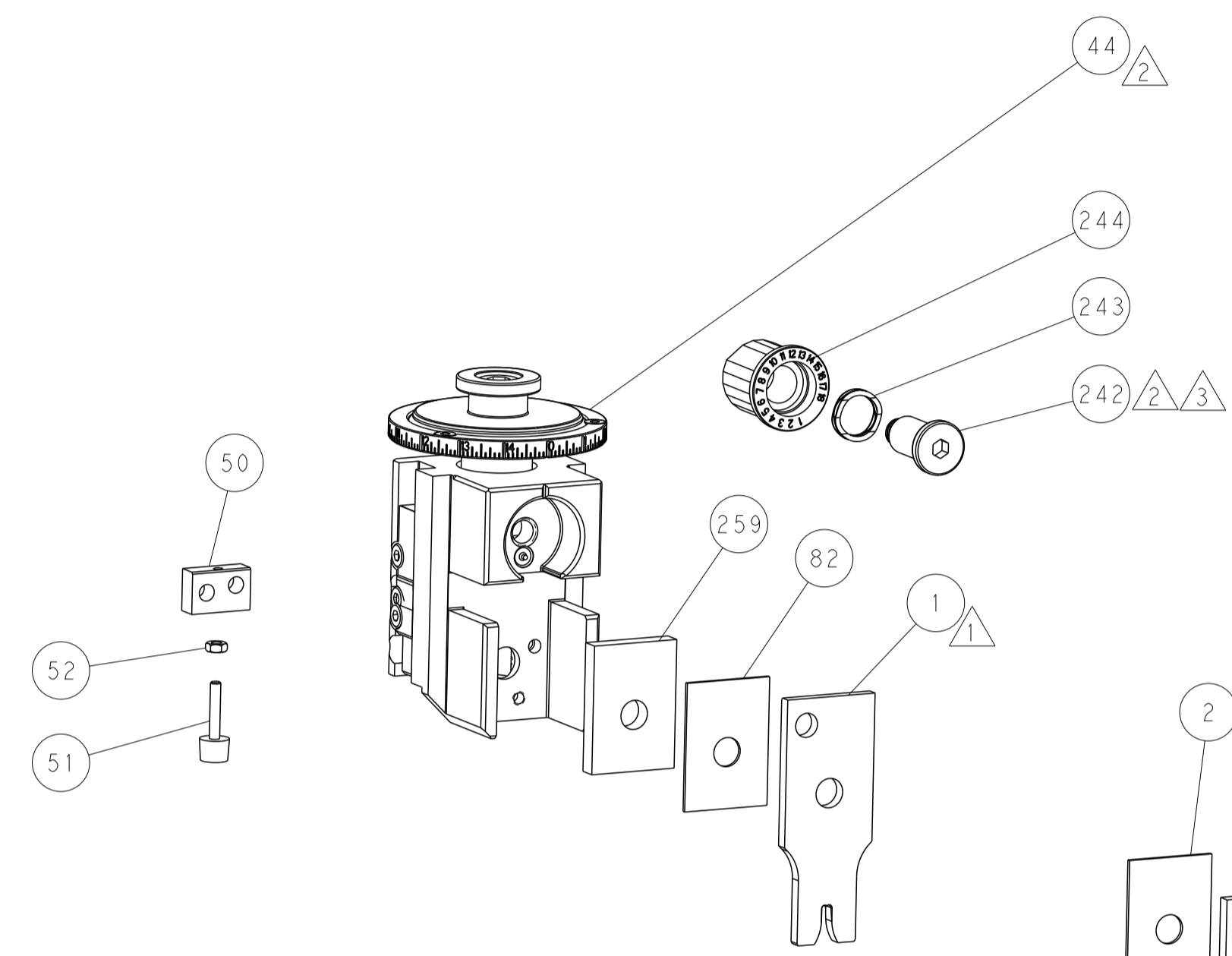
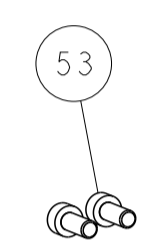
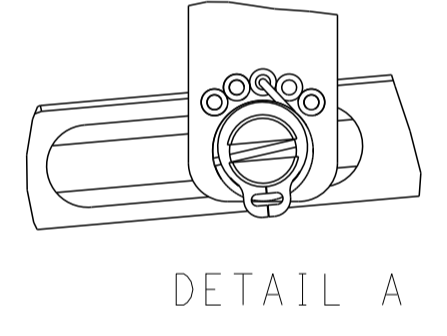
FEED TYPE MECHANICAL



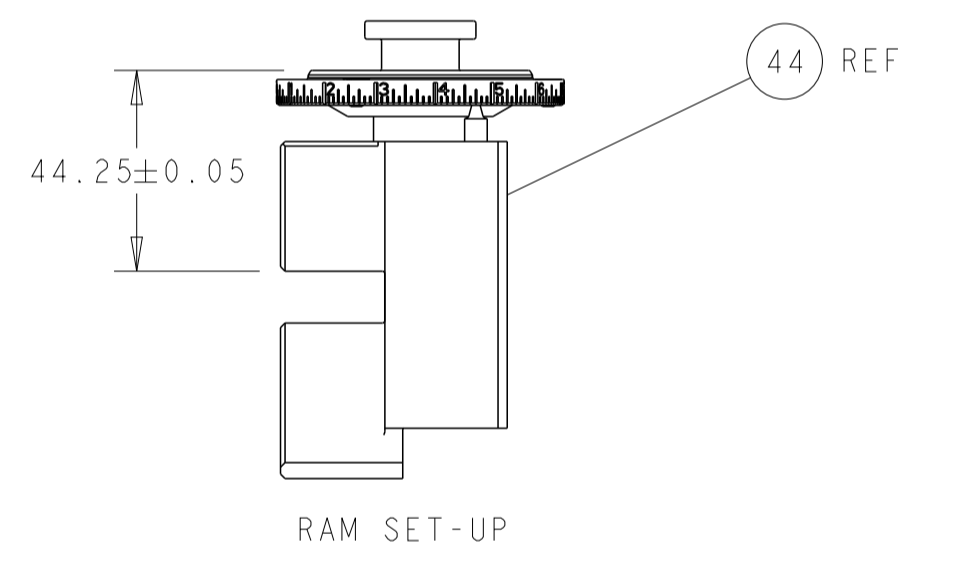
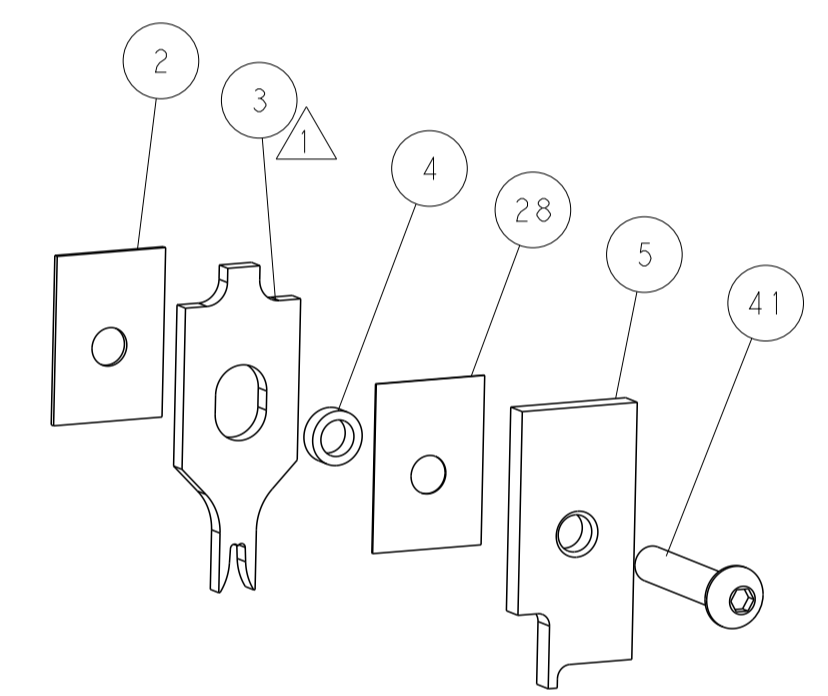
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

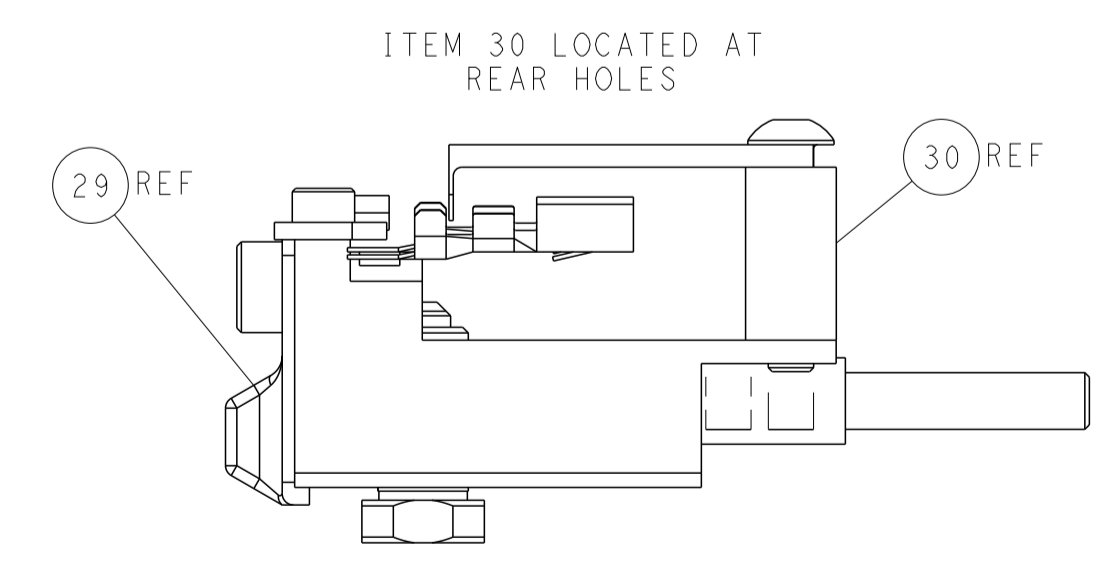
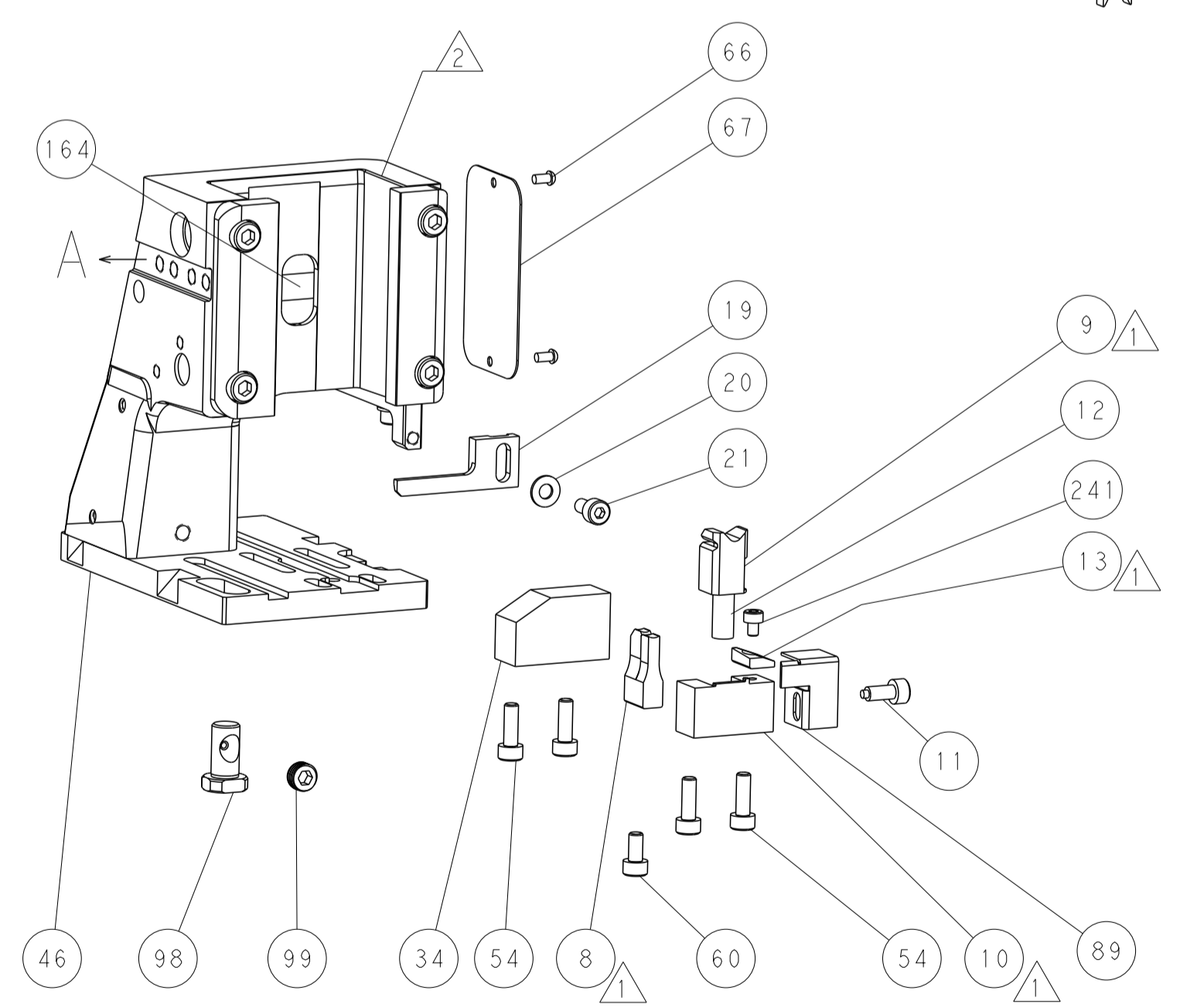
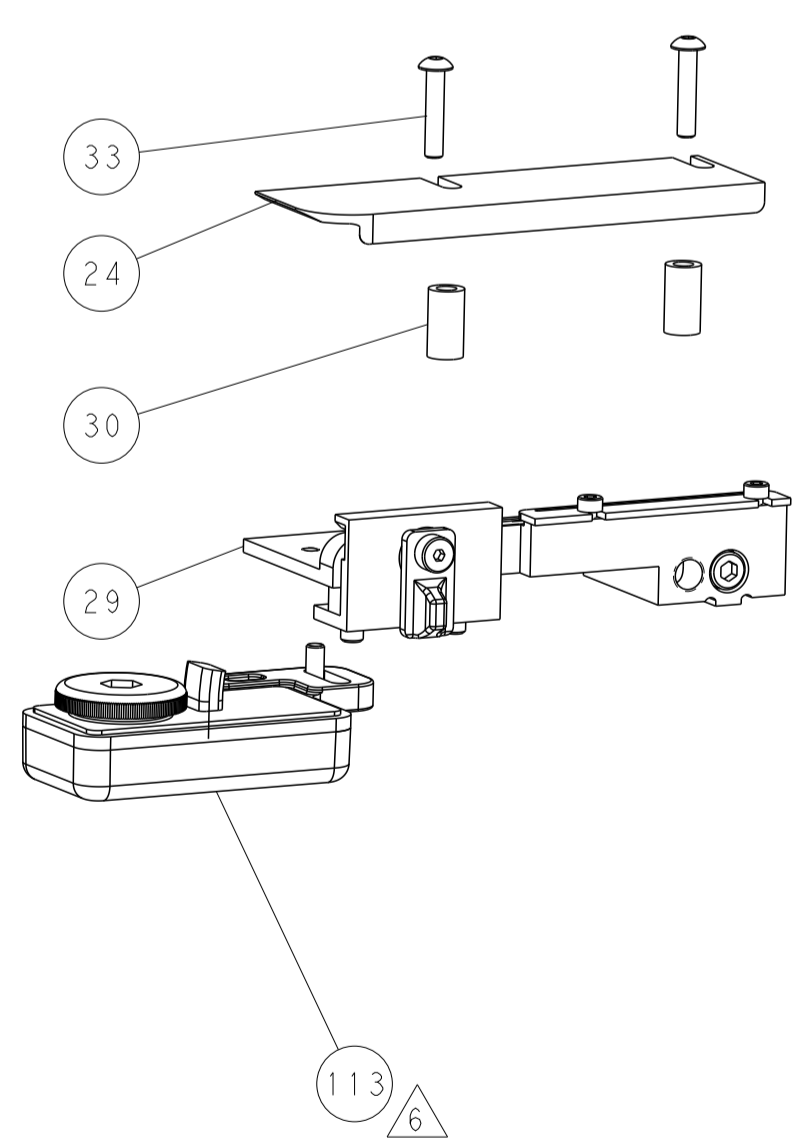
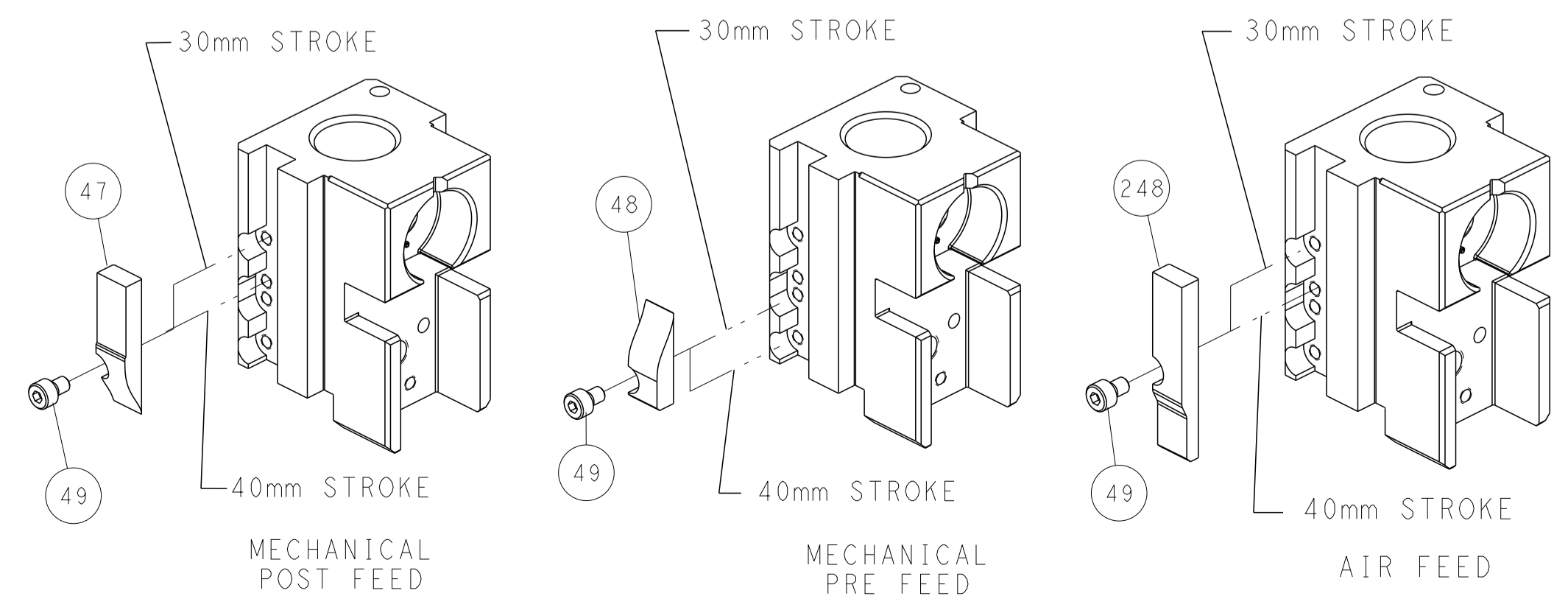


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITIONS



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:		DWN: STAKEM 07MAY2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: G. BAILEY 07MAY2014		NAME: Ocean Side Feed Applicator	
				APVD: T. ELBIN 07MAY2014		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
				PRODUCT SPEC:		A1 00779 ©=2266282	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266282-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266282-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266282-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.68 mm [.145]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, CRIMP QC.250,F			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.81-5.60 mm [1.89-.220 IN]		∅2.45-3.10 mm [1.096-.122 IN]	
TERMINAL APPLICATION SPECIFICATION		12015870 Rev -	
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1949086-1	12015870	1-1393310-9	26A1348B
286676-1	12015865		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.70+/-0.05 [1.067+/-0.002]	5.6
1.00mm2	1.55+/-0.05 [1.061+/-0.002]	6.4

- RECOMMENDED SPARE PARTS
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 - 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.
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***WARNING**
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PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

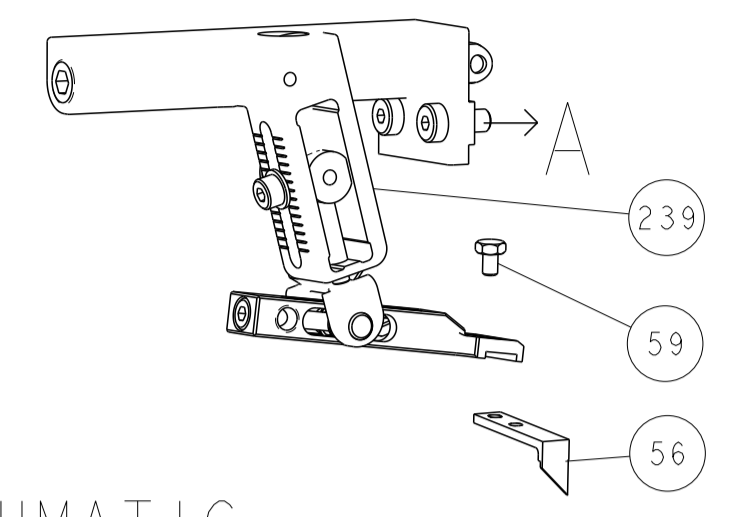
LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

REV	DATE	BY	CHK	APPV	DESCRIPTION	ITEM NO
-	1	1			1803078-4 SPACER, PRECISION	259
-	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	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			1803516-2 RAM ASSEMBLY, SF PACIFIC	140
-	1	1			2119955-1 ASSY, LUBRICATOR, SIDE FEED	113
-	1	1			2844908-1 SCREW, LOCKING	99
-	1	1			2844907-1 POST, LOCKING	98
-	1	1			318563-1 GUARD, FRONT CHIP	89
-	1	1			455888-8 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			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			690753-6 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			1803602-2 SCR, BHSC, RoHS (M8 X 40)	41
-	1	1			2-1752356-0 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			1803095-1 FLOATING SHEAR, FRONT	9
-	1	1			1633924-4 ANVIL, COMBINATION	8
-	-	-			-	6
-	1	1			2119757-8 DEPRESSOR, SHEAR	5
-	1	1			4-238011-2 BLOCK, CRIMPER SPACER	4
-	1	1			3-1803016-3 CRIMPER, INSULATION F	3
-	1	1			455888-9 SPACER, CRIMPER	2
-	1	1			4-568176-3 CRIMPER, WIRE	1

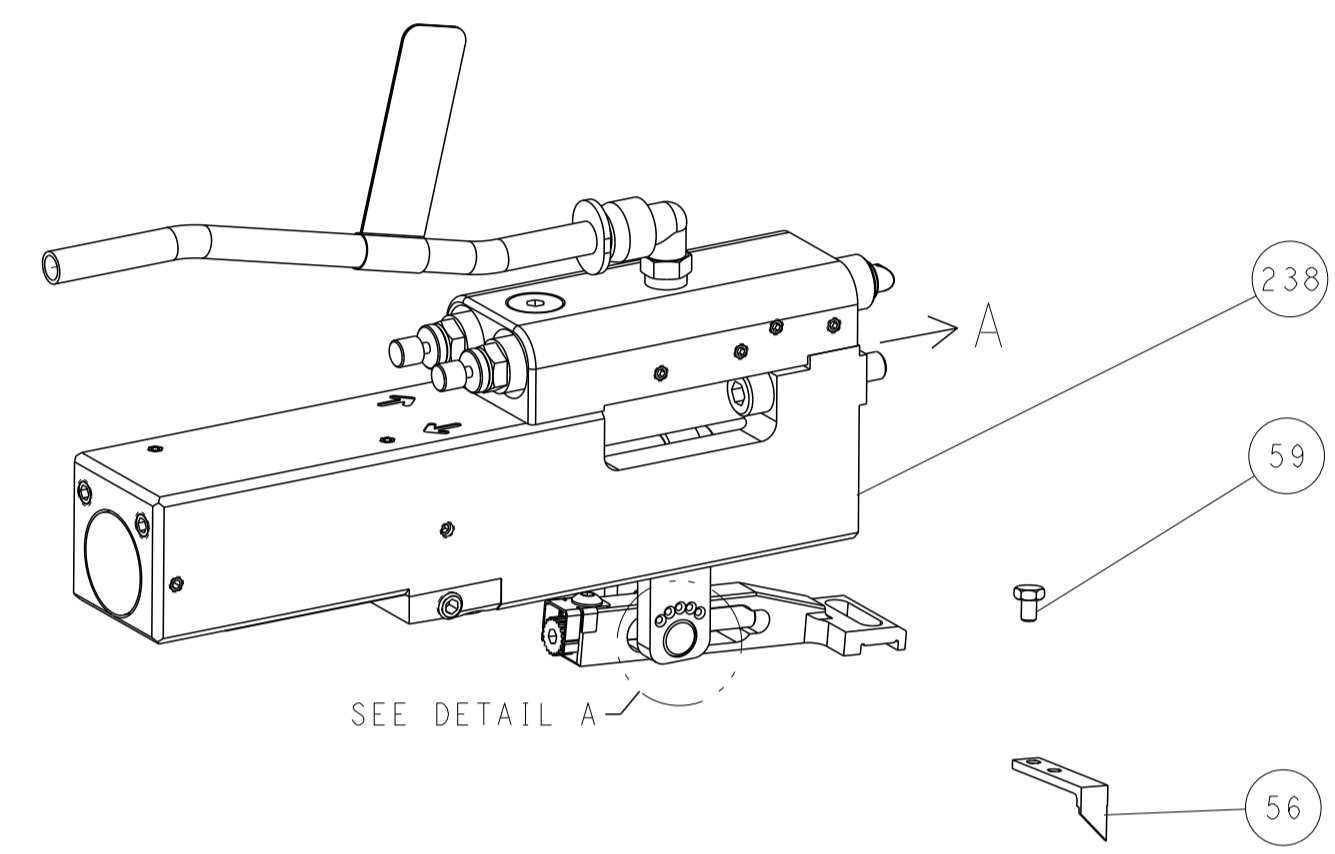
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mm		0 PLC ±		CHK: G. BAILEY 07MAY2014		Harrisburg, PA 17105-3608	
		1 PLC ±		APPV: T. ELBIN 07MAY2014		NAME: Ocean Side Feed Applicator	
		2 PLC ±		PRODUCT SPEC		SIZE: A1	
		3 PLC ±		APPLICATION SPEC		CAGE CODE: 00779	
		4 PLC ±		WEIGHT		DRAWING NO: C=2266282	
		ANGLES		MATERIAL		SCALE: 1:2	
		FINISH		RESTRICTED TO		SHEET 3 OF 4	
				Customer Accessible Production Drawing		REV C	

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

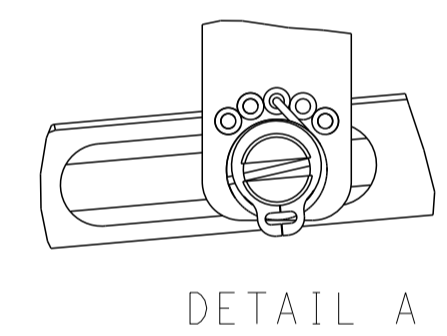
FEED TYPE MECHANICAL



PNEUMATIC

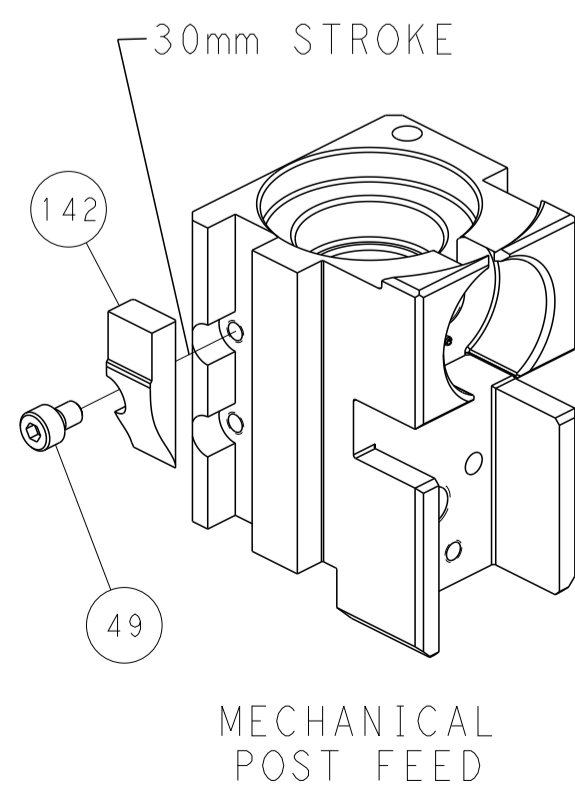


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

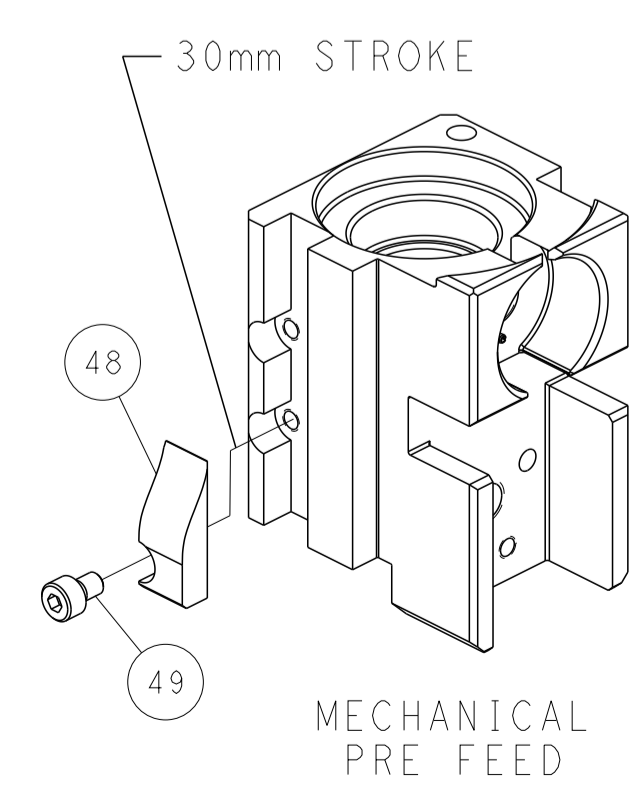


DETAIL A

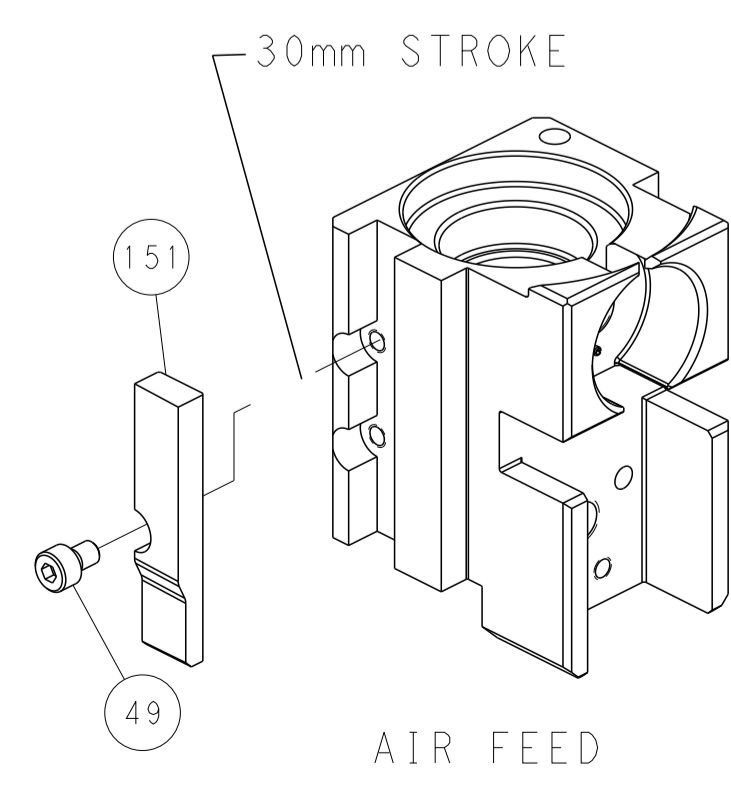
CAM POSITIONS



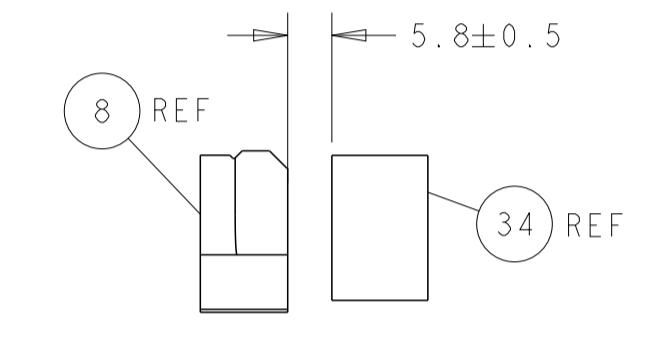
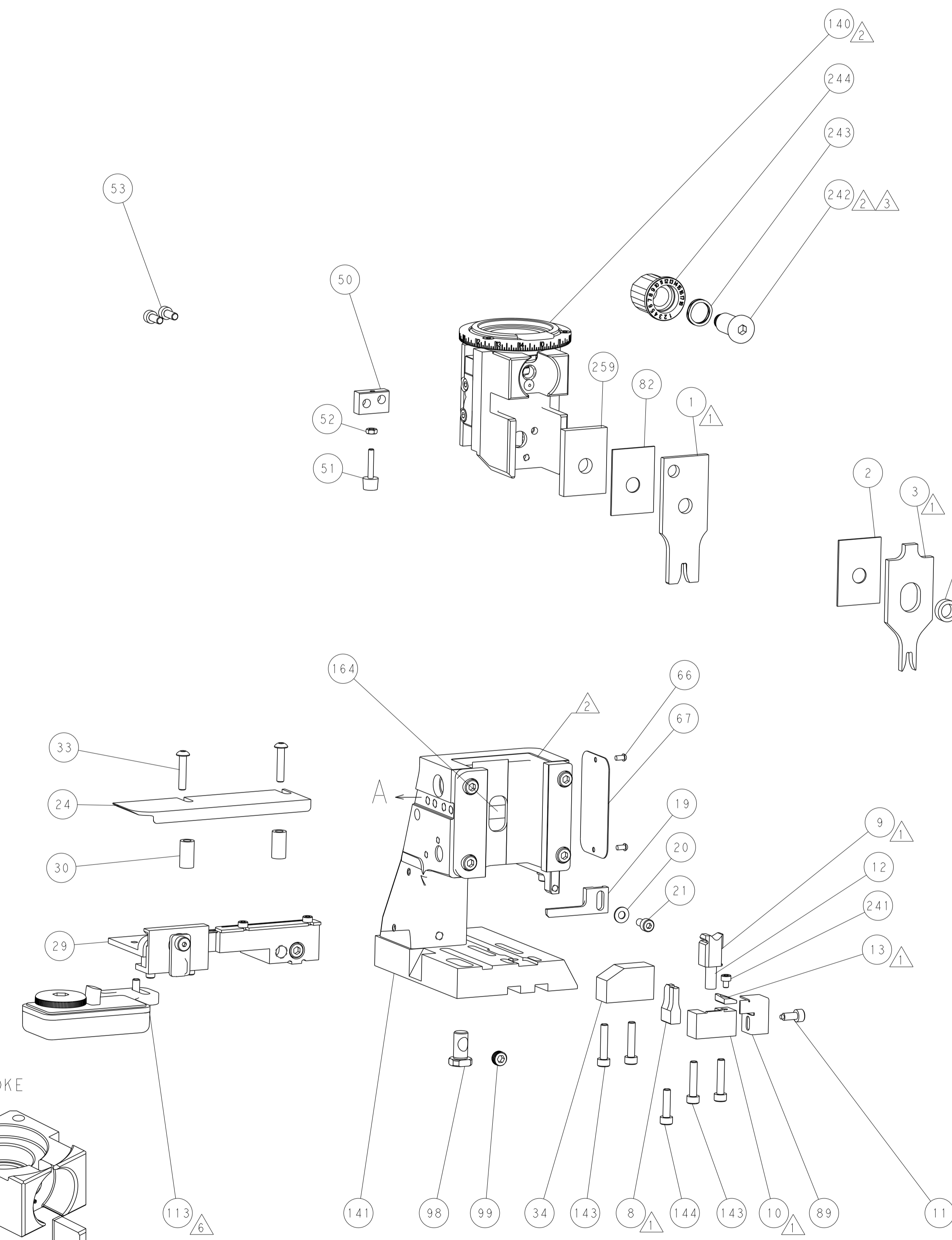
MECHANICAL POST FEED



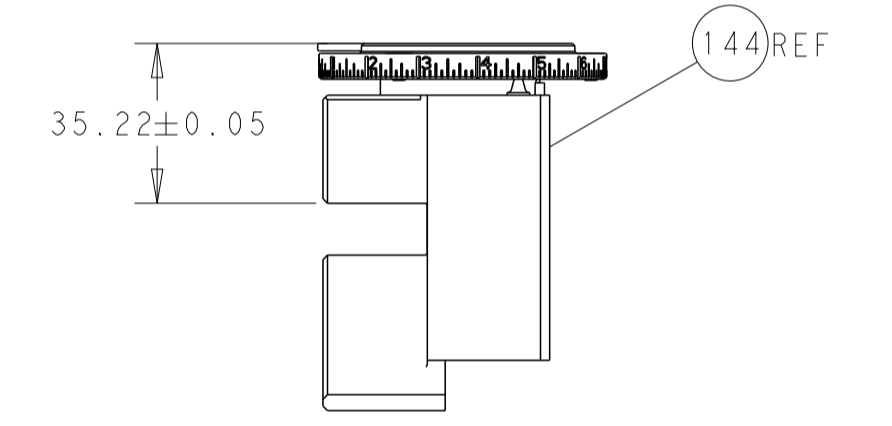
MECHANICAL PRE FEED



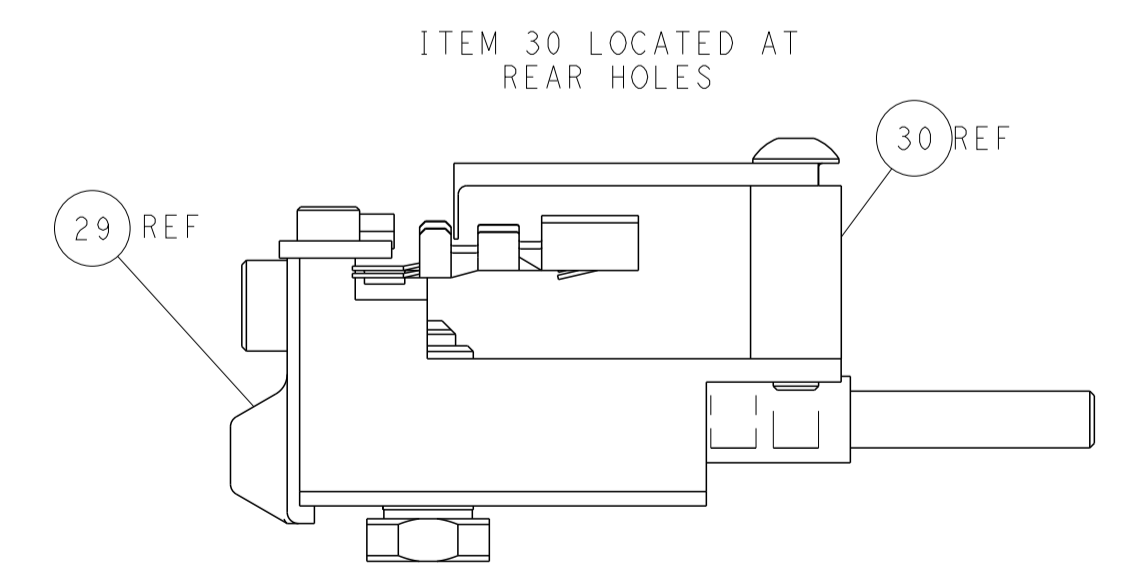
AIR FEED



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>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED BY THE DRAWING. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON REQUEST.</small>		DWN: R. STAKEM 07MAY2014 CHK: G. BAILEY 07MAY2014 APVD: T. ELBIN 07MAY2014	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC: APPLICATION SPEC: WEIGHT: A1 00779 SCALE: 1:2	RESTRICTED TO: SIZE: CAGE CODE DRAWING NO: 2266282 SHEET 4 OF 4 REV C
MATERIAL:		Customer Accessible Production Drawing	