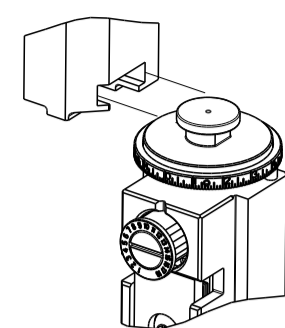


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2266539-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266539-2 | B | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2266539-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|-----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 5.54 mm [.218] | F |
| INSUL | 10.20 mm [.402] | O |

APPLICATOR INSTRUCTIONS 408-35042

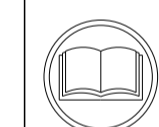
TERMINAL DATA: DELPHI PACKARD TERMINAL DELPHI PACKARD CRIMP SPECIFICATION

| | |
|---|--|
| TERMINAL NAME: TERMINAL | |
| WIRE STRIP LENGTH 6.75-7.51 mm [.266-.296 IN] | INSULATION DIAMETER RANGE 6.00-6.50 mm [.236-.256 IN] |
| TERMINAL APPLICATION SPECIFICATION (A)10730408 PAGE 1 OF 4 Rev 2013-10-30 | (B)15408423 PAGE 1 OF 4 Rev 2013-10-30 |

TERMINALS APPLIED

| TE TERMINAL | DELPHI PACKARD TERMINAL | TE SEAL | DELPHI PACKARD SEAL | CABLE DIAMETER |
|---------------|-------------------------|-----------|---------------------|----------------|
| (A) 2113604-1 | (A) 10730408 | 2113605-1 | 10720983 | 6.00-6.40 mm |
| (B) 2113604-2 | (B) 15408423 | 2113605-2 | 3B0972744A | 6.00-6.40 mm |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 10.00mm2 | 3.50 +/- 0.05 [.138 +/- .002] | 6.8 |



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- THIS APPLICATOR DOES NOT CUT THE CARRIER STRIP.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- 8. 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 | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | 1 | | DEVELOPMENT | 11DEC2015 | JH | UG |
| | | A | | RELEASED | 27JAN2016 | YY | TE |
| | | B | | ECR-23-172692 | 19APR2023 | ROY | TLE |

| | | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----------------------|---|
| - | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269 | |
| - | 1 | 1 | 1633782-7 | FENCE | 267 | |
| - | 1 | 1 | 1803078-1 | SPACER, PRECISION | 259 | |
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 2119082-8 | 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 | 2844940-2 | AIR FEED MODULE | 238 | |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 | |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 | |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 | |
| - | 1 | 1 | 1-690438-0 | FRONT STRIP GUIDE | 96 | |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 | |
| - | 2 | 2 | 1-2079383-8 | SCR, BHSC, RoHS (M4 X 6) | 79 | |
| - | 1 | 1 | 1803096-1 | EXTENSION PLATE | 78 | |
| - | 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 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 60 | |
| - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | |
| - | 1 | 1 | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16 | 57 | |
| - | 1 | 1 | 1-1338683-1 | FEED PAWL | 56 | |
| - | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 | |
| - | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 53 | |
| - | 2 | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 | |
| - | 1 | 1 | 811242-5 | BUMPER, HOLD DOWN | 51 | |
| - | 1 | 1 | 690753-2 | SPACER, TONKER | 50 | |
| - | 1 | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 | |
| - | 1 | 1 | 1-1803583-7 | APPLICATOR BASIC ASSEMBLY, SF | 46 | |
| - | 1 | 1 | 1803515-2 | RAM ASSEMBLY, SF ATLANTIC | 44 | |
| - | 1 | 1 | 1803602-2 | SCR, BHSC, RoHS (M8 X 40) | 41 | |
| - | 1 | 1 | 1-1752356-9 | 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 | 2844992-5 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 1 | 1-455888-6 | SPACER, CRIMPER | 28 | |
| - | 2 | 2 | 22283-1 | SPRING, COMPRESSION | 27 | |
| - | 1 | 1 | 240792-1 | DRAG, TERMINAL | 25 | |
| - | 1 | 1 | 1320928-4 | 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 | 1803013-1 | STRIPPER, SIDE FEED | 19 | |
| - | 1 | 1 | 4-22280-7 | SPRING, COMPRESSION | 12 | |
| - | 1 | 1 | 1-356885-3 | STOP, SHEAR | 11 | |
| - | 1 | 1 | 2119805-3 | SHEAR HOLDER, FRONT | 10 | |
| - | 1 | 1 | 318059-9 | FLOATING SHEAR, FRONT | 9 | |
| - | 1 | 2 | 1 | 5-1633930-5 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 | |
| - | - | - | - | - | 6 | |
| - | 1 | 1 | 1803080-3 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 4-238011-5 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 2 | 1 | 1803317-3 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 2-455888-7 | SPACER, CRIMPER | 2 | |
| - | 1 | 2 | 1 | 6-1803188-0 | CRIMPER, WIRE | 1 |

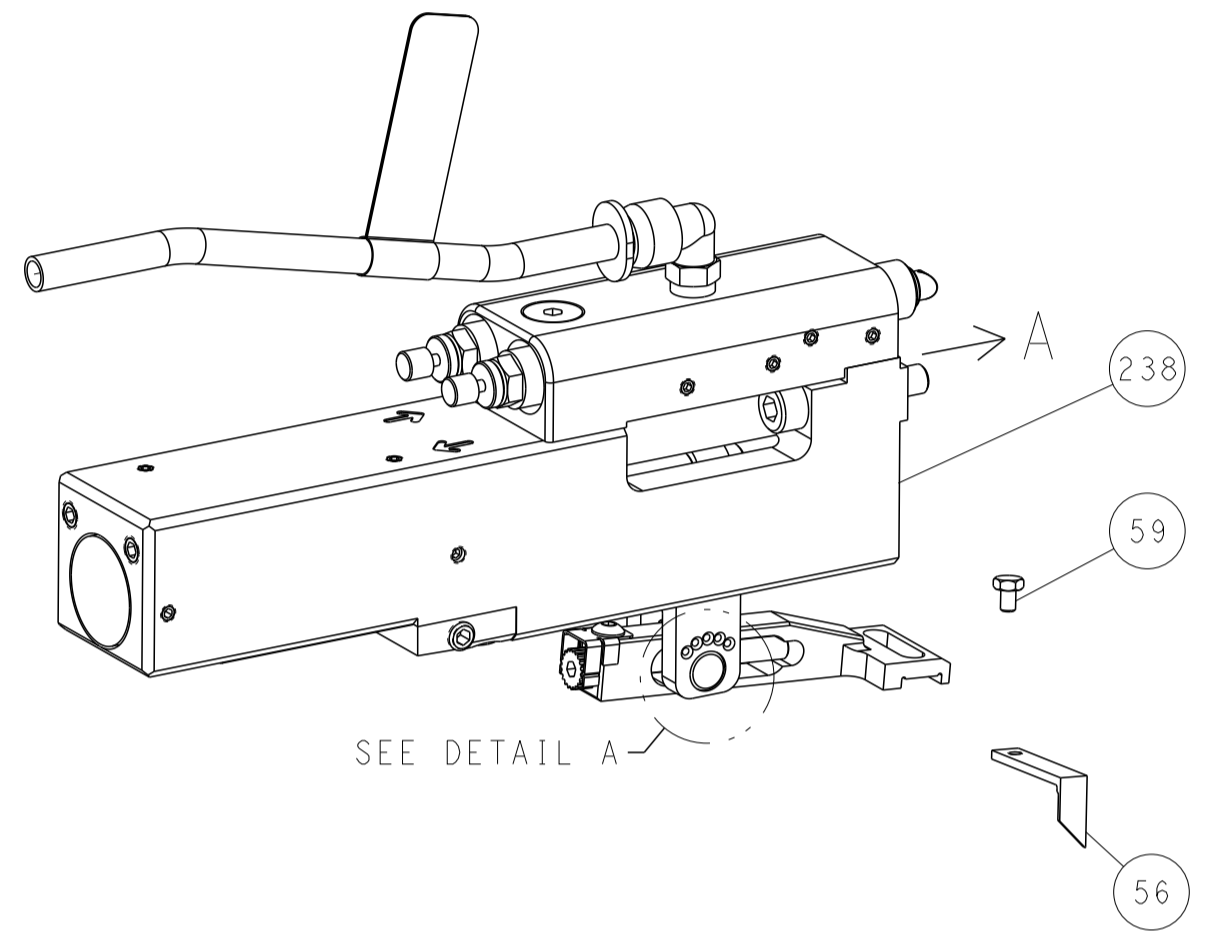
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|-------------|--------|--|--|-----------|--|---------|--|
| mm | 0 PLC | ± | | | | | |
| | 1 PLC | ± | | | | | |
| | 2 PLC | ± | | | | | |
| | 3 PLC | ± | | | | | |
| | 4 PLC | ± | | | | | |
| | ANGLES | ± | | | | | |

| | | |
|--|----------|-----------|
| OWN | J. HOU | 11DEC2015 |
| CHK | L. ZHANG | 11DEC2015 |
| APVD | J. GUO | 11DEC2015 |
| PRODUCT SPEC | | |
| APPLICATION SPEC | | |
| SIZE | A1 | 00779 |
| CAGE CODE | | |
| DRAWING NO | | 2266539 |
| RESTRICTED TO | | |
| WEIGHT | | |
| Customer Accessible Production Drawing | SCALE | 1:2 |
| SHEET | 1 | OF 4 |
| REV | B | |

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

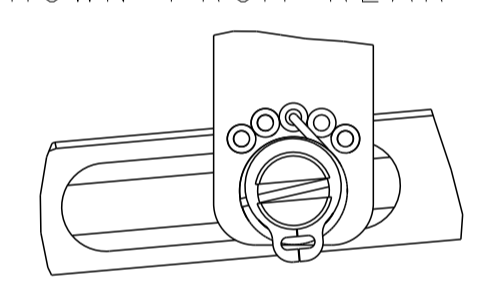
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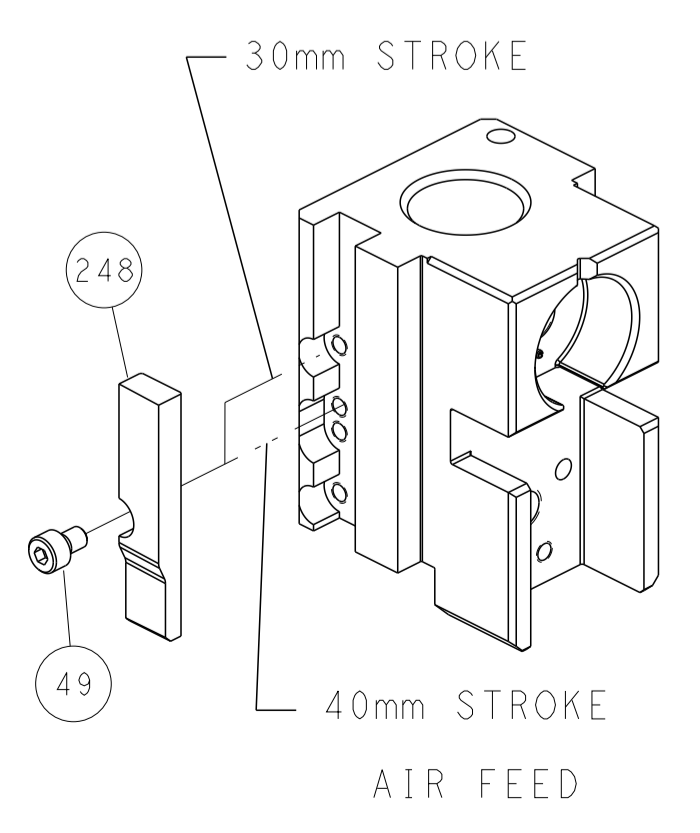
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

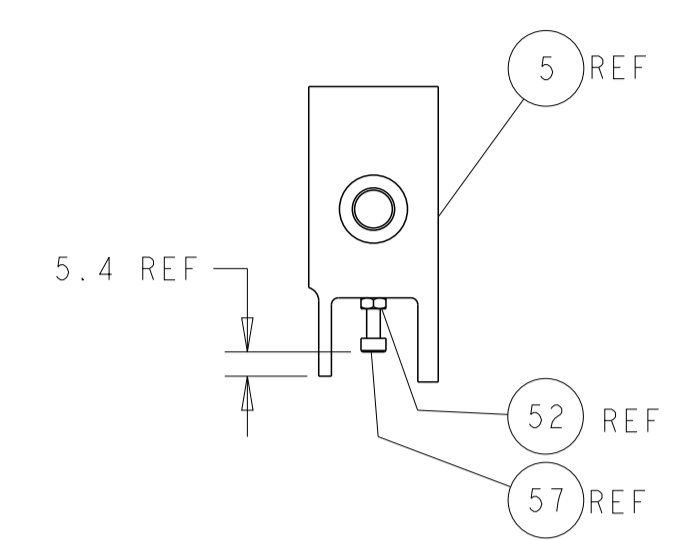
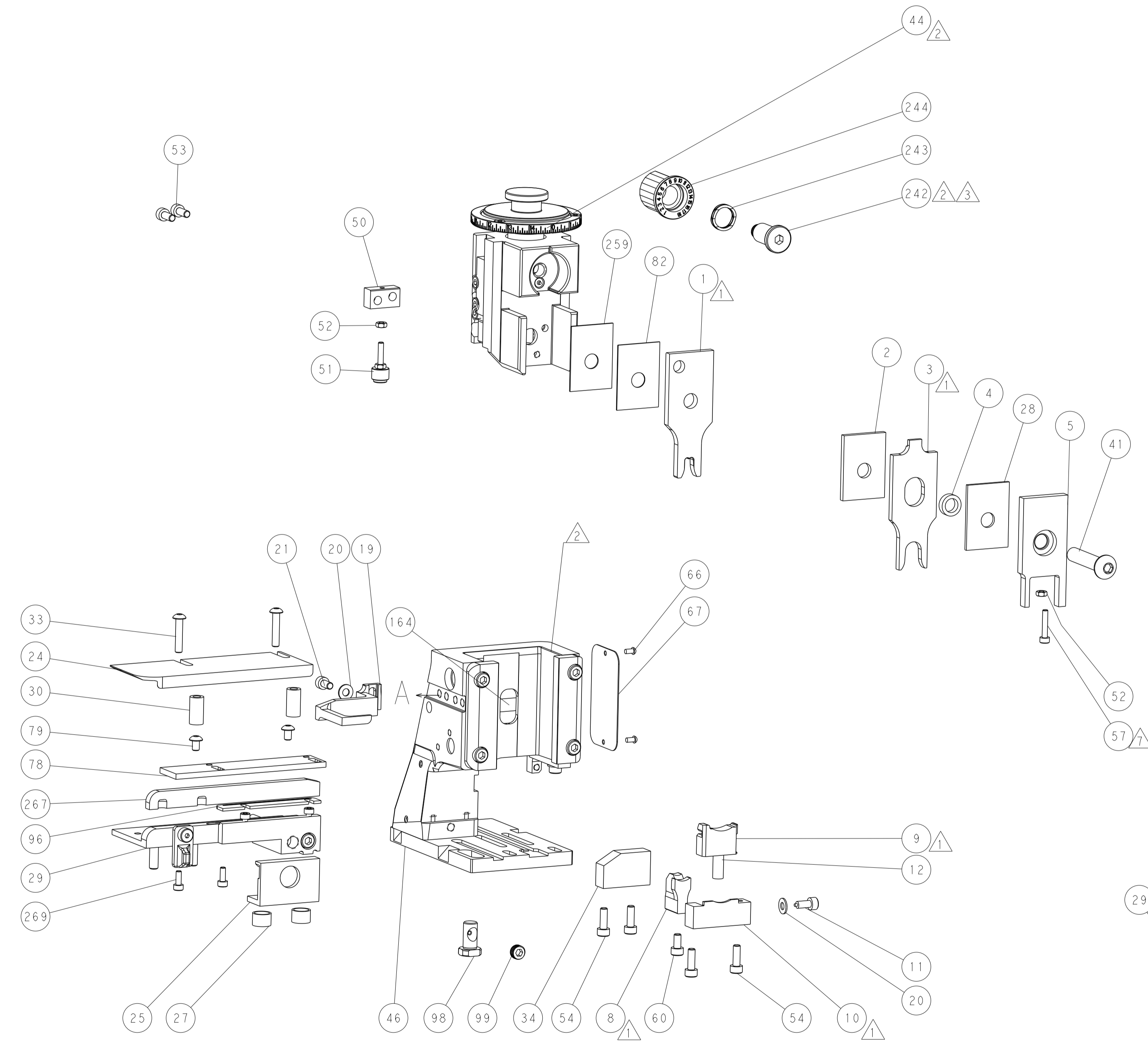


DETAIL A

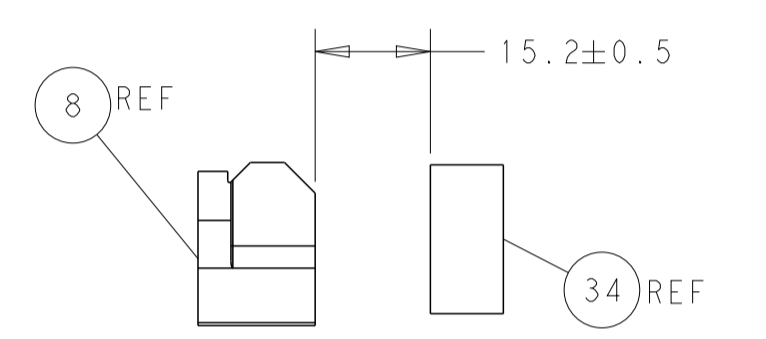
CAM POSITION



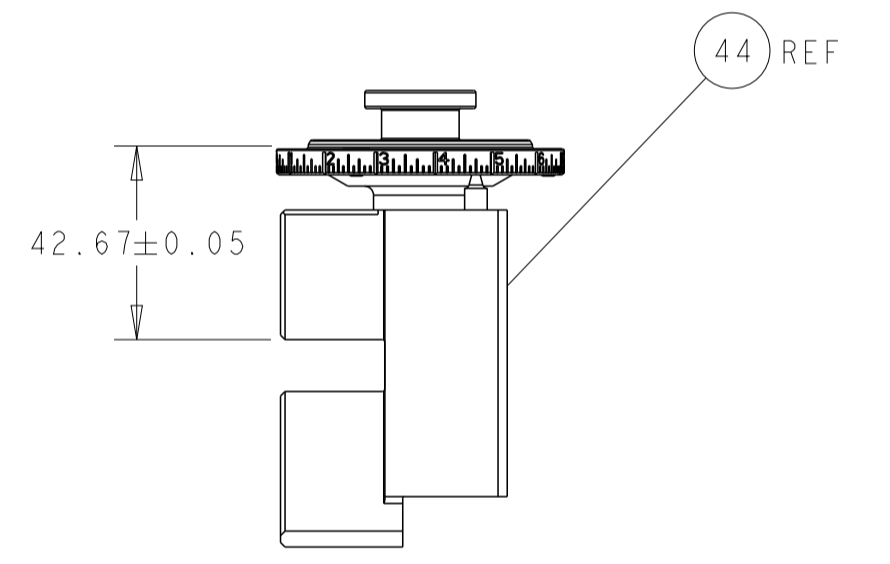
AIR FEED



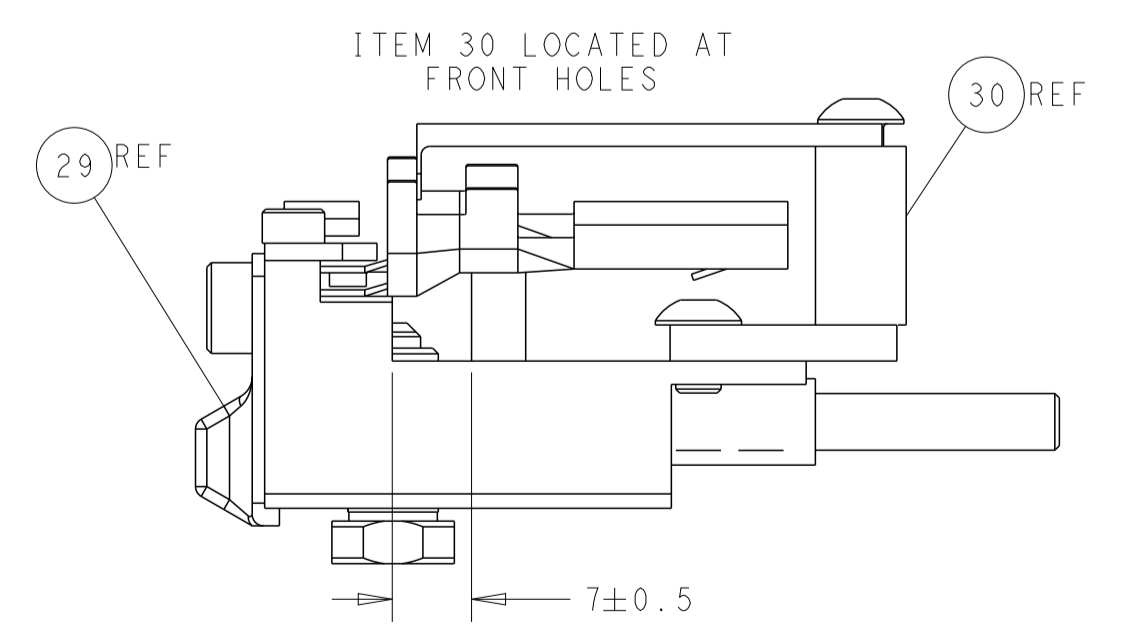
SHEAR DEPRESSOR DETAIL



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)

| | | | |
|---|--|---|--|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. THIS DRAWING IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED IN THE ORDER. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small> | | DWN J. HOU 11DEC2015 CHK L. ZHANG 11DEC2015 APVD H. GUO 11DEC2015 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: - | | NAME Ocean Side Feed Applicator PRODUCT SPEC - APPLICATION SPEC - SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2266539 - | WEIGHT - SCALE 1:2 SHEET 2 OF 4 REV B |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|-----------|
| 2-2266539-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2266539-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|-------------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 5.54 mm [.218] | F |
| INSUL | 10.20 mm [.402] | O |

APPLICATOR INSTRUCTIONS
 408-35042

| TERMINAL DATA: DELPHI PACKARD TERMINAL DELPHI PACKARD CRIMP SPECIFICATION | | | | |
|---|-------------------------------|-----------|---------------------|----------------|
| TERMINAL NAME: TERMINAL | | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | TE SEAL | DELPHI PACKARD SEAL | CABLE DIAMETER |
| 6.75-7.51 mm [.266-.296 IN] | 6.00-6.50 mm [.236-.256 IN] | 2113605-1 | 10720983 | 6.00-6.40 mm |
| TERMINAL APPLICATION SPECIFICATION (A)10730408 PAGE 1 OF 4 Rev 2013-10-30 | | | | |
| TERMINALS APPLIED | | | | |
| TE TERMINAL | DELPHI PACKARD TERMINAL | TE SEAL | DELPHI PACKARD SEAL | CABLE DIAMETER |
| (A) 2113604-1 | (A) 10730408 | 2113605-1 | 10720983 | 6.00-6.40 mm |
| (B) 2113604-2 | (B) 15408423 | 2113605-2 | 3B0972744A | 6.00-6.40 mm |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|----------------------|---------------------------------|--------------------------------|
| 10.00mm ² | 3.50 +/- 0.05 [.138 +/- .002] | 6.8 |



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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. THIS APPLICATOR DOES NOT CUT THE CARRIER STRIP.
7. APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
8. 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)

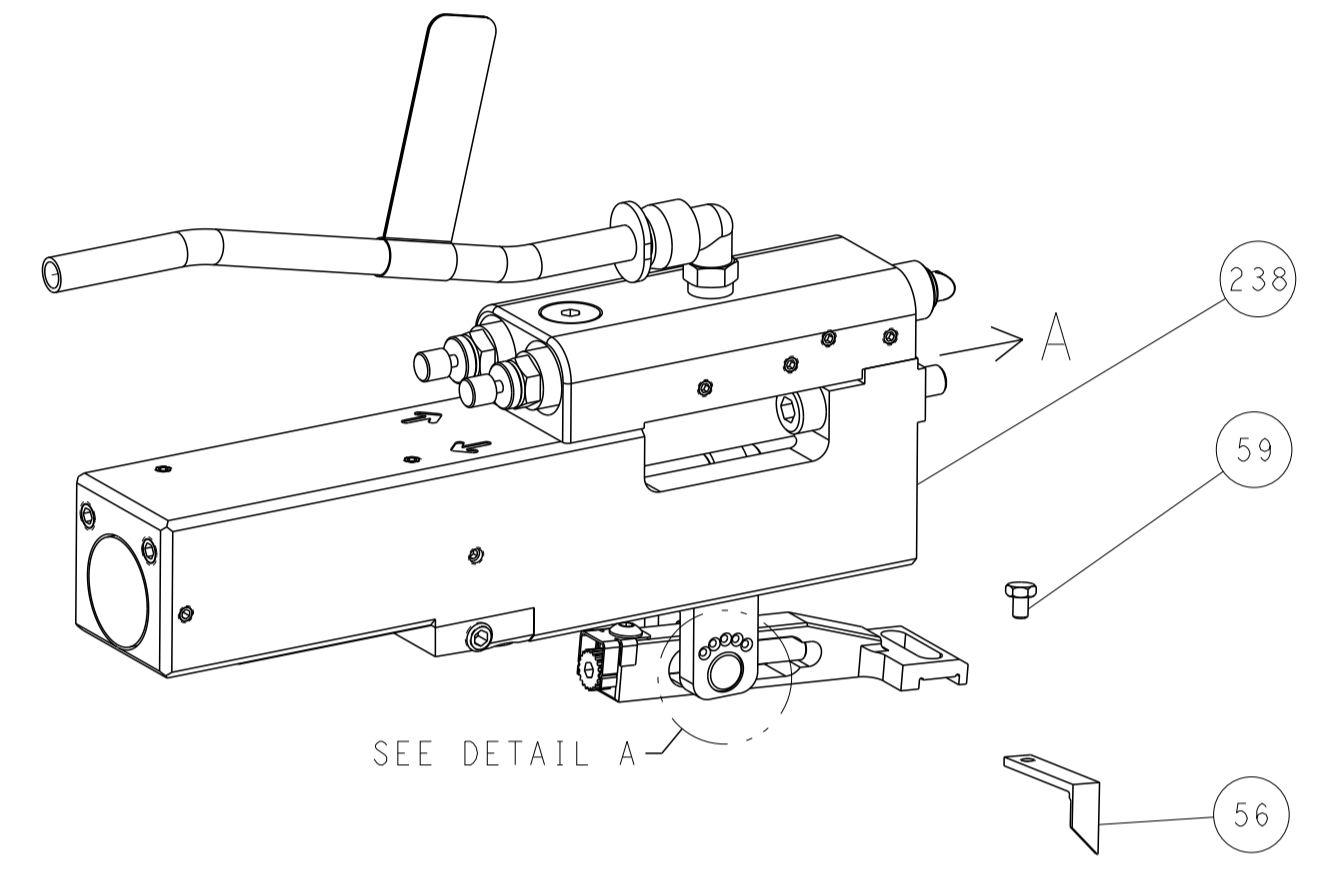
| LOC | DIST | REV | DATE | BY | APPD |
|-----|------|-----|------|----|------|
| A | 66 | | | | |

| REV | DATE | DESCRIPTION | ITEM NO |
|-----|------|---|---------|
| - | 2 | 2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269 |
| - | 1 | 1633782-7 FENCE | 267 |
| - | 1 | 1803078-1 SPACER, PRECISION | 259 |
| - | 1 | 2119082-8 CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| 3 | - | 2119083-1 RETAINER, INSULATION DIAL | 242 |
| - | 1 | 2844940-2 AIR FEED MODULE | 238 |
| - | REF | 994970-2 COUNTER, MAGNETIC | 164 |
| - | 1 | 2119641-2 FEED CAM, AIR FEED | 151 |
| - | 1 | 2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16 | 144 |
| - | 4 | 2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20 | 143 |
| - | 1 | 1-1803583-8 APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1803516-2 RAM ASSEMBLY, SF PACIFIC | 140 |
| - | 1 | 2844908-1 SCREW, LOCKING | 99 |
| - | 1 | 2844907-1 POST, LOCKING | 98 |
| - | 1 | 1-690438-0 FRONT STRIP GUIDE | 96 |
| - | 1 | 455888-5 SPACER, CRIMPER | 82 |
| - | 2 | 1-2079383-8 SCR, BHSC, RoHS (M4 X 6) | 79 |
| - | 1 | 1803096-1 EXTENSION PLATE | 78 |
| - | 1 | 1803607-3 DOCUMENTATION PACKAGE | 71 |
| - | 1 | 2119740-1 TAG, IDENTIFICATION | 67 |
| - | 2 | 2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 5-18022-5 SCR, HEX HD CAP, M4 X 6.0 | 59 |
| 7 | - | 1-2168083-3 SCR, SKT HD CAP, RoHS, M3 X 16 | 57 |
| - | 1 | 1-1338683-1 FEED PAWL | 56 |
| - | 2 | 1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10 | 53 |
| - | 2 | 5018030-1 NUT, HEX, REG, RoHS, M3 | 52 |
| - | 1 | 811242-5 BUMPER, HOLD DOWN | 51 |
| - | 1 | 690753-2 SPACER, TONKER | 50 |
| - | 1 | 18023-9 SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1803602-2 SCR, BHSC, RoHS (M8 X 40) | 41 |
| - | 1 | 1-1752356-9 SUPPORT, TERMINAL | 34 |
| - | 2 | 2079383-5 SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 3-2844962-2 SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 2844992-5 ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1-455888-6 SPACER, CRIMPER | 28 |
| - | 2 | 22283-1 SPRING, COMPRESSION | 27 |
| - | 1 | 240792-1 DRAG, TERMINAL | 25 |
| - | 1 | 1320928-4 STRIP GUIDE | 24 |
| - | 1 | 2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 2 | 1-18028-2 WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1803013-1 STRIPPER, SIDE FEED | 19 |
| - | 1 | 4-22280-7 SPRING, COMPRESSION | 12 |
| - | 1 | 1-356885-3 STOP, SHEAR | 11 |
| 1 | - | 2119805-3 SHEAR HOLDER, FRONT | 10 |
| 1 | - | 318059-9 FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 5-1633930-5 ANVIL, COMBINATION | 8 |
| - | - | - | 7 |
| - | - | - | 6 |
| - | 1 | 1803080-3 DEPRESSOR, SHEAR | 5 |
| - | 1 | 4-238011-5 BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1803317-3 CRIMPER, INSULATION O | 3 |
| - | 1 | 2-455888-7 SPACER, CRIMPER | 2 |
| 1 | 1 | 6-1803188-0 CRIMPER, WIRE | 1 |

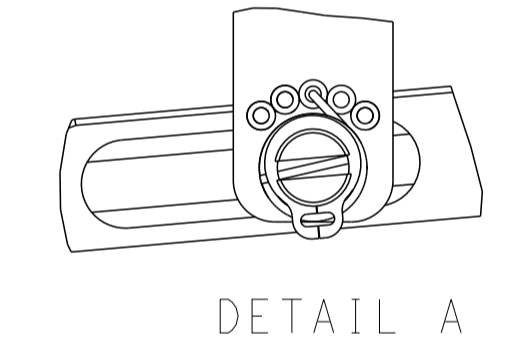
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|-----------------------|--|---|--|---|--|------------------------------------|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | | DWN J. HOU 11DEC2015 CHK L. ZHANG 11DEC2015 APVD U. GUO 11DEC2015 | | NAME Ocean Side Feed Applicator | |
| MATERIAL | | WEIGHT | | SCALE | | SHEET 3 OF 4 | |
| | | | | A1 00779 C=2266539 | | REV B | |

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

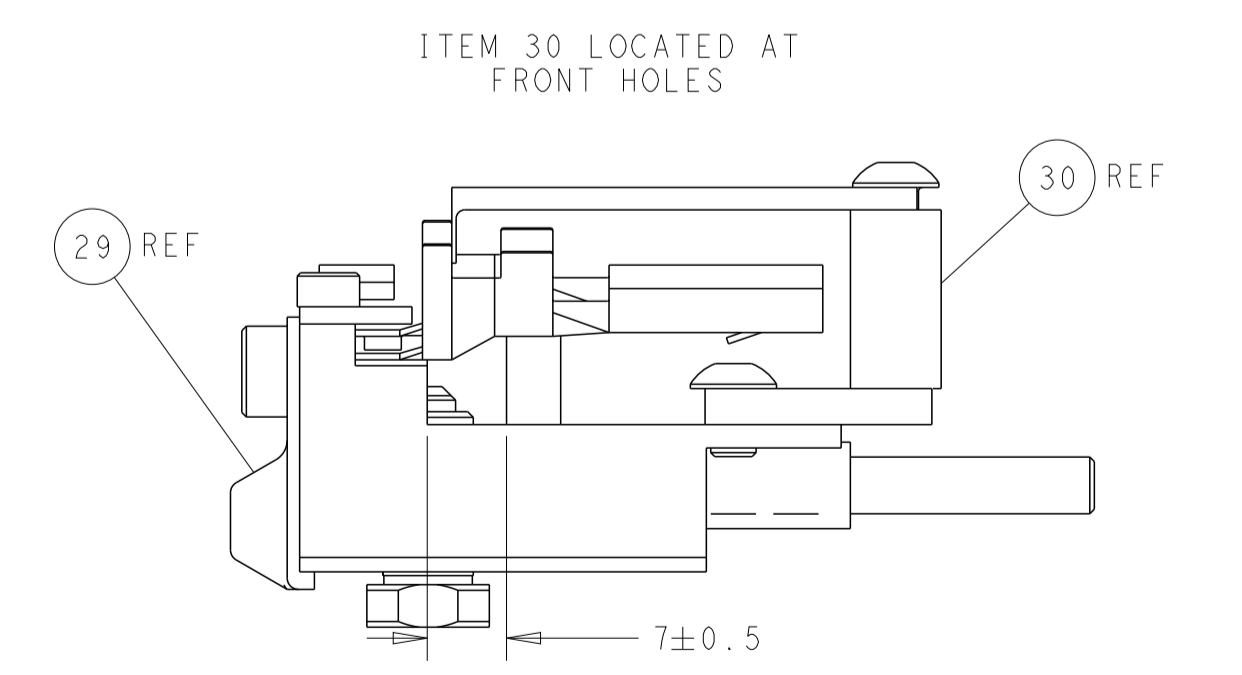
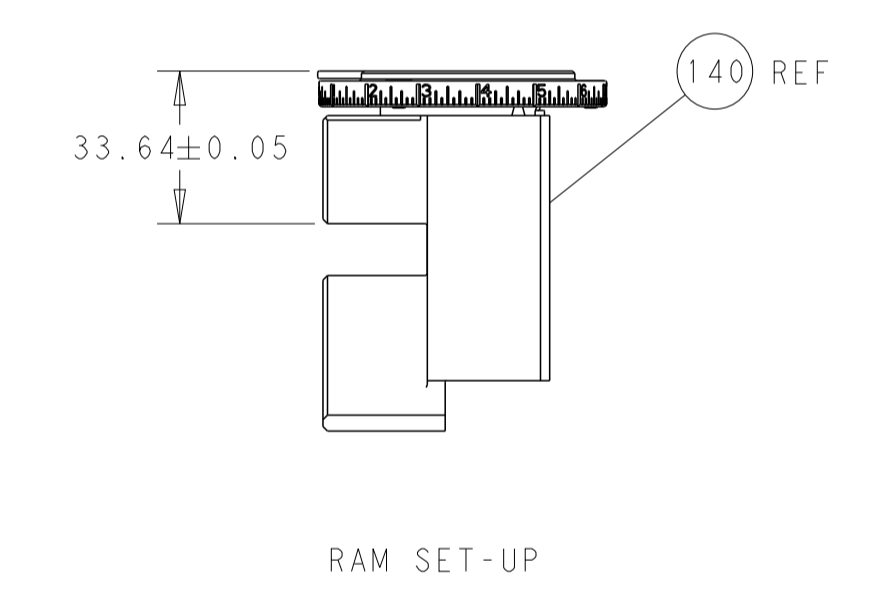
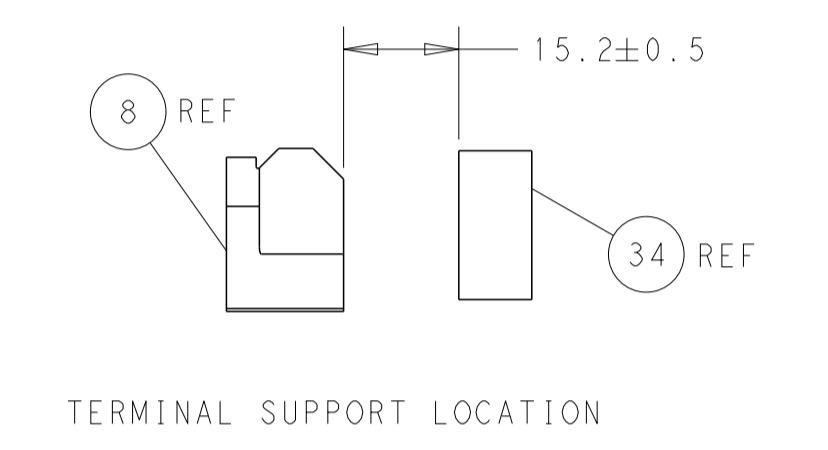
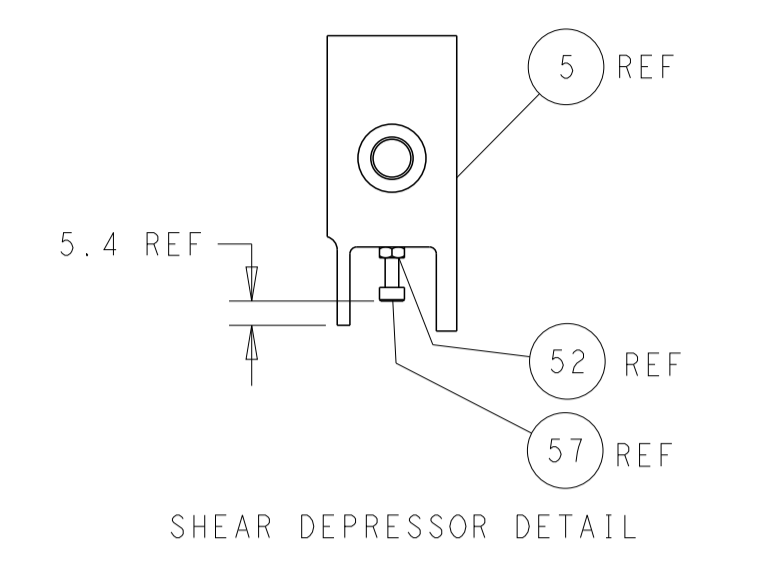
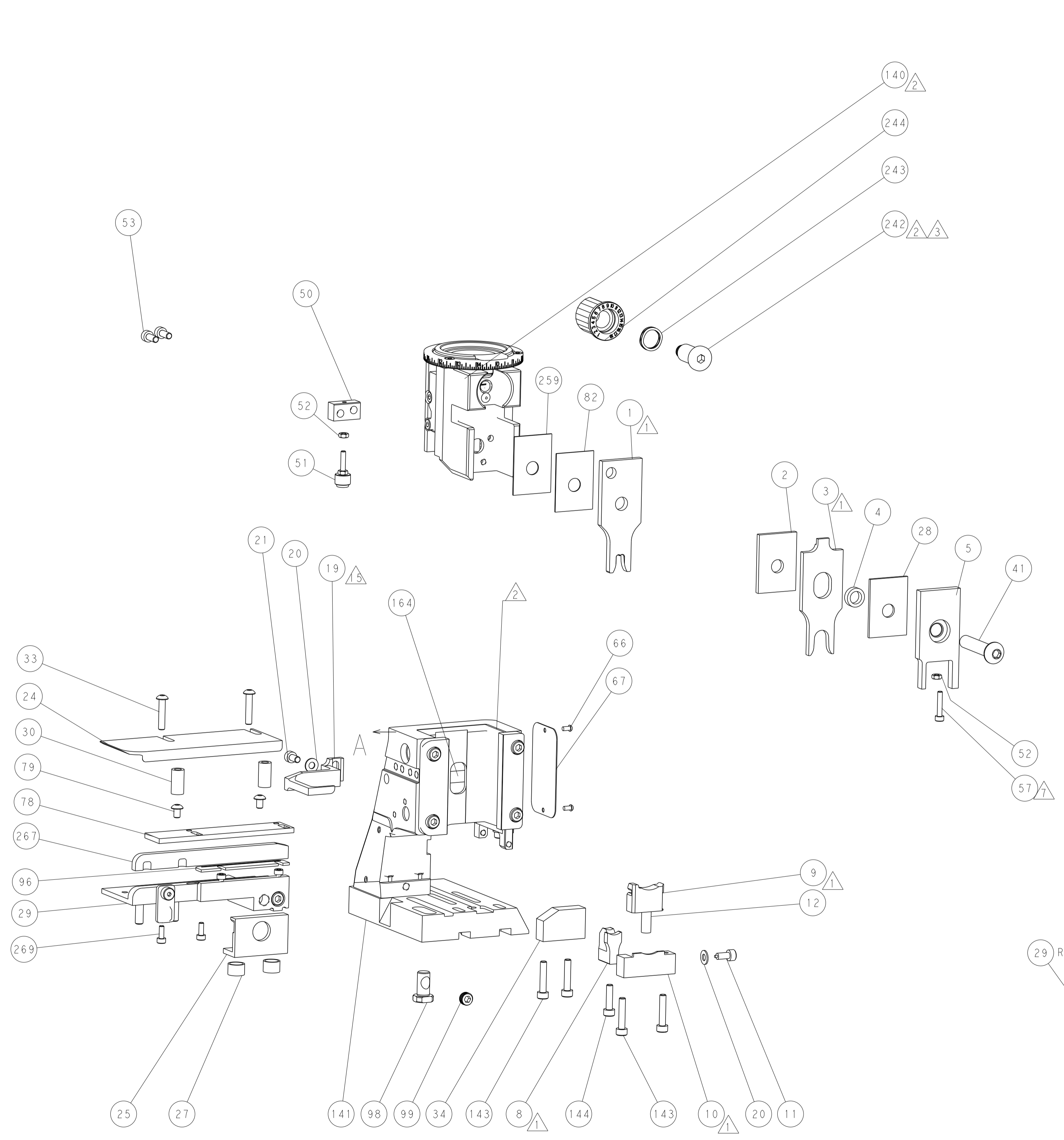
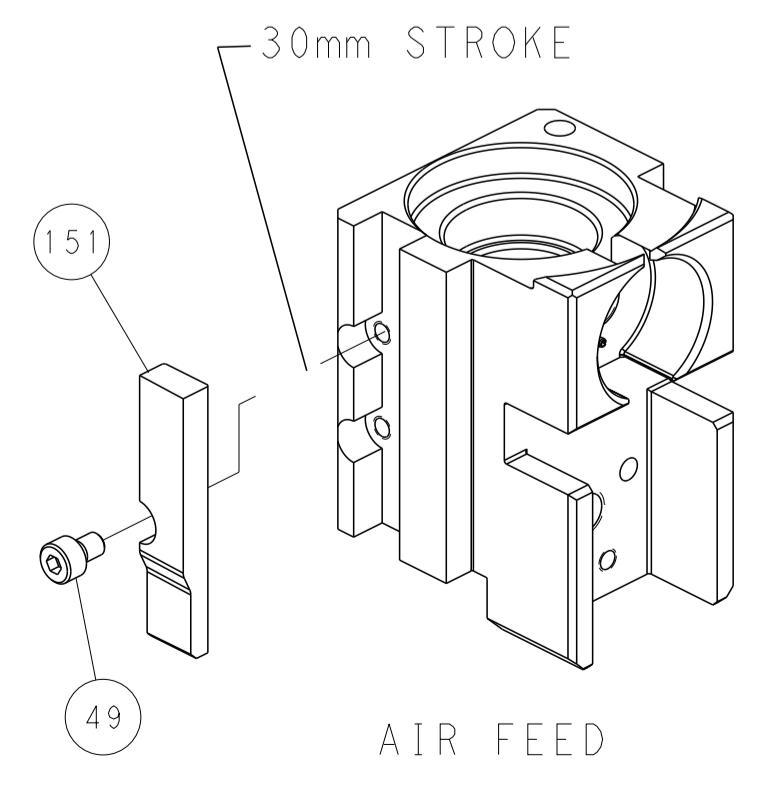
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN: J. HOU 11DEC2015 CHK: L. ZHANG 11DEC2015 APVD: H. GUO 11DEC2015 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: - | PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2 | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266539 SHEET 4 OF 4 REV B | RESTRICTED TO: - |