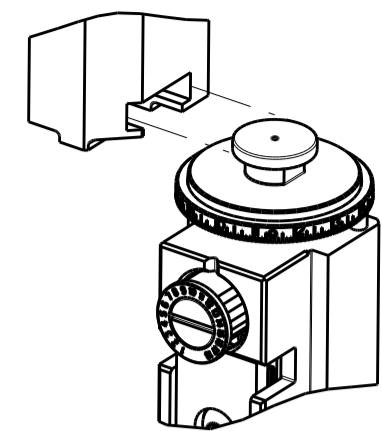


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266311-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266311-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266311-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266311-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266311-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.90 mm [.114]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH 4.98-5.74 mm [.196-.226 IN]	INSULATION DIAMETER RANGE Ø1.20-2.25 mm [.047-.089 IN]
TERMINAL APPLICATION SPECIFICATION	DELPHI SPEC

TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
1949044-1	15326267	1949045-1	15305351	1.7-2.1 mm
		1832359-1	15366060	1.9-2.3 mm
		1949130-4	15344324	1.2-2.1 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30 +/- 0.05 [.051 +/- .002]	5.8
0.80mm2	1.25 +/- 0.05 [.049 +/- .002]	6.2
0.75mm2	1.25 +/- 0.05 [.049 +/- .002]	6.2

- 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 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.
- 6. 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)

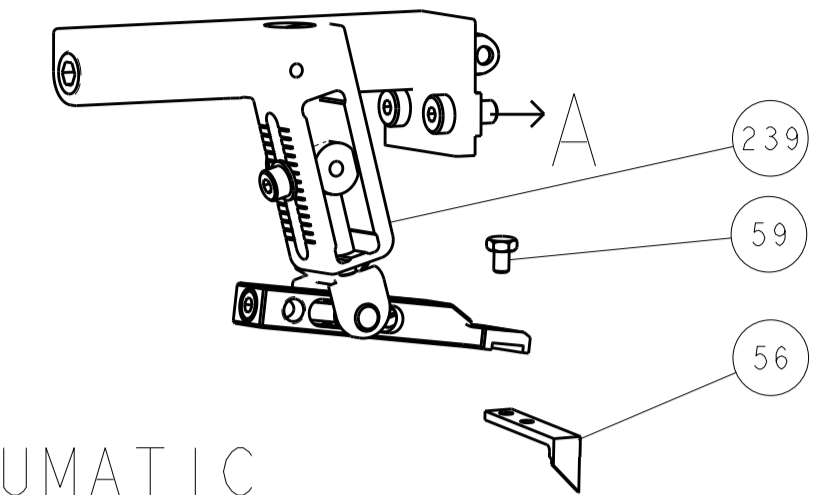
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A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
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		A1		ECR-16-017768	15DEC2016	RS	LZ
		B		ECR-19-012037	31JUL2019	FZ	TE

-	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	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	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	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	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	690753-2	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	1-1752356-8	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-8	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	
-	2	2	2	2	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	2	2	1	1	2-1633920-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1-2119784-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	2	
-	1	2	2	1	1	456405-8	CRIMPER, WIRE PREMIUM	1

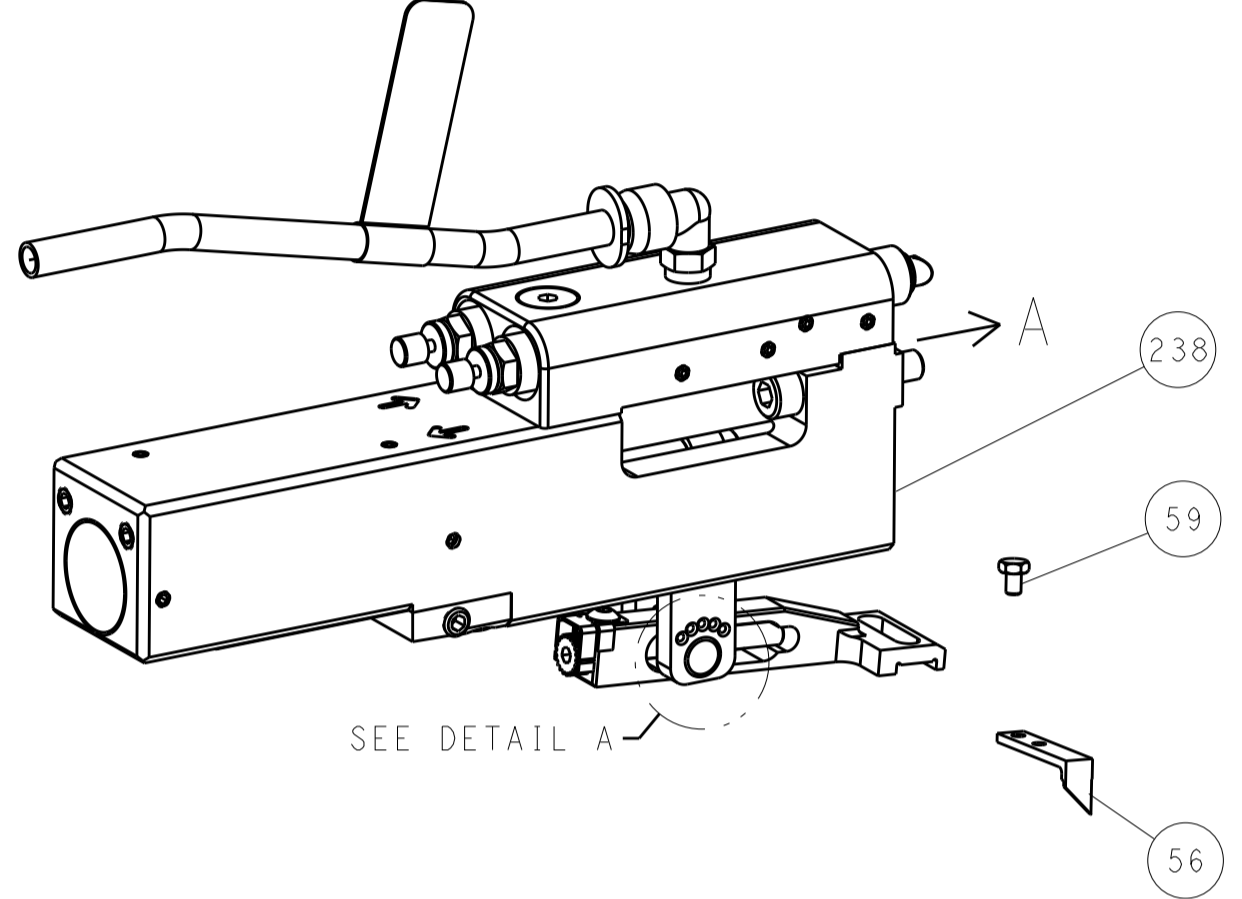
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC ±	1 PLC ±	2 PLC ±	Y. YIN	10JUN2014	CHK	G. BAILEY
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	10JUN2014		
MATERIAL	FINISH	WEIGHT		TE Connectivity Harrisburg, PA 17105-3608 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266311 Customer Accessible Production Drawing SCALE: 1:2 SHEET 1 OF 4 REV B			

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

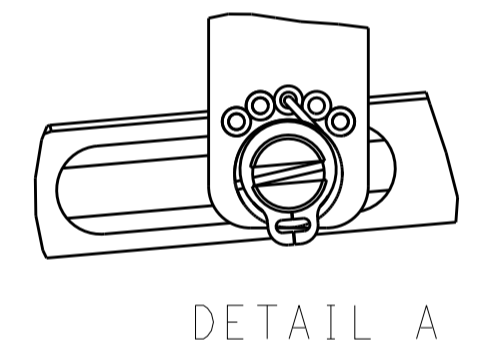
FEED TYPE MECHANICAL



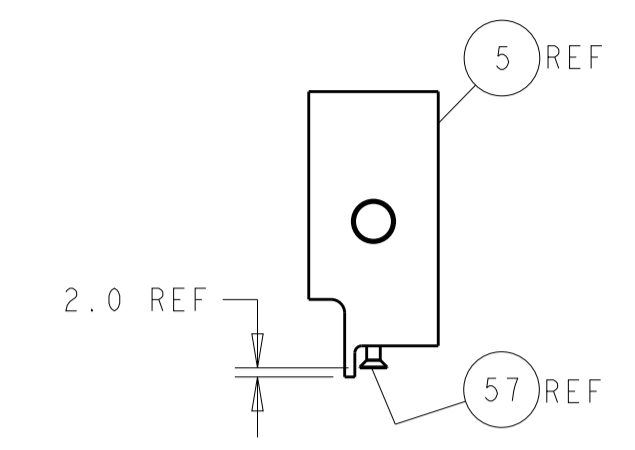
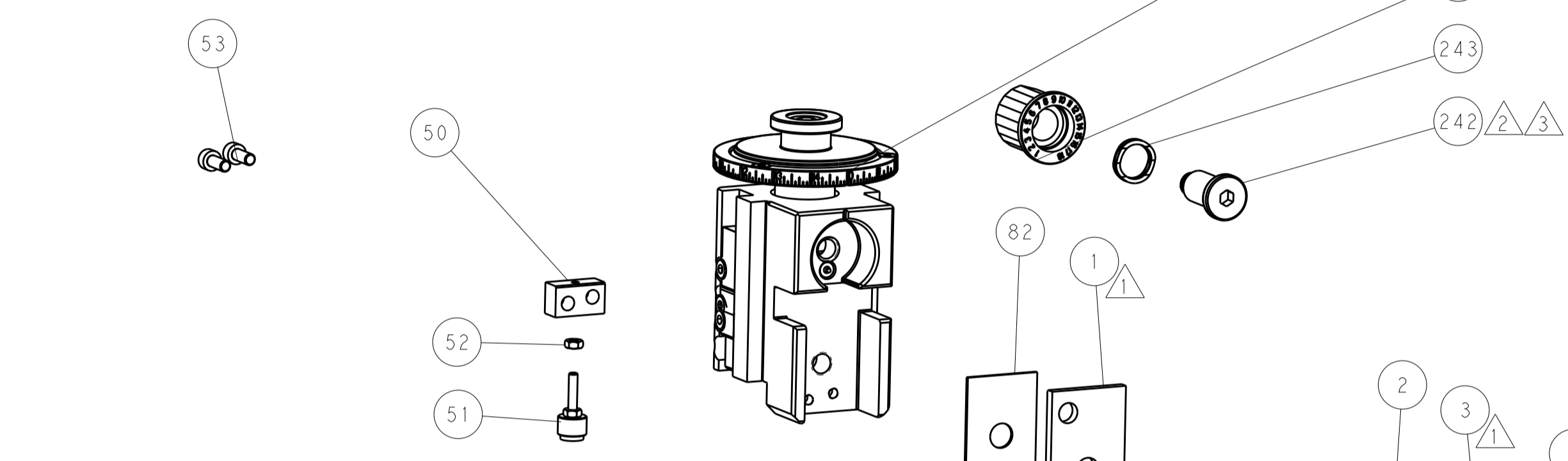
PNEUMATIC



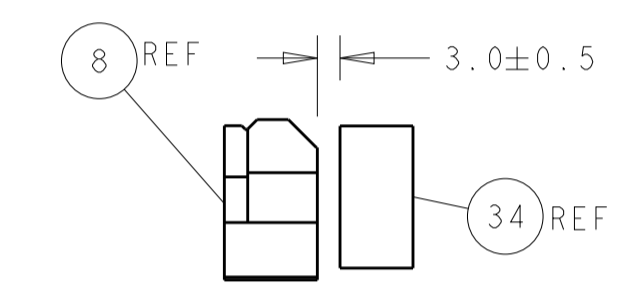
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



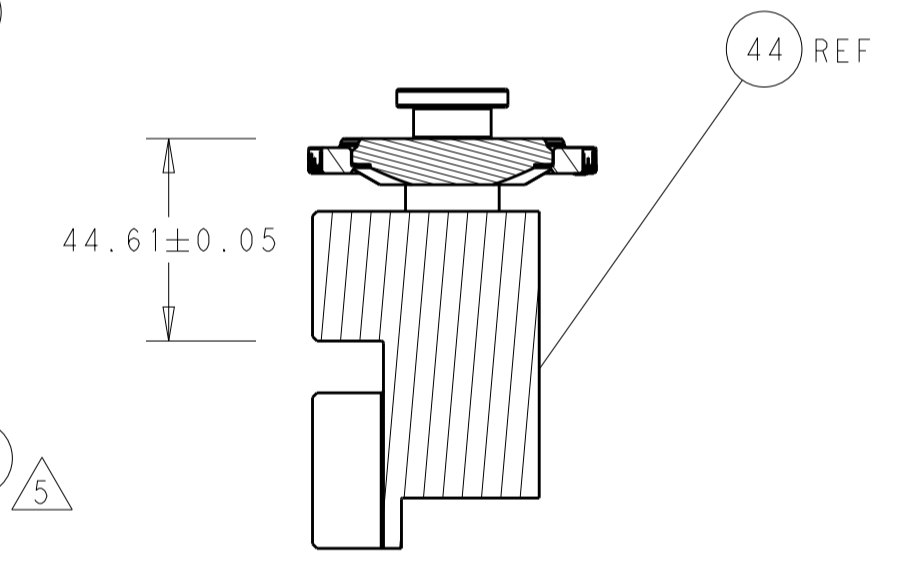
DETAIL A



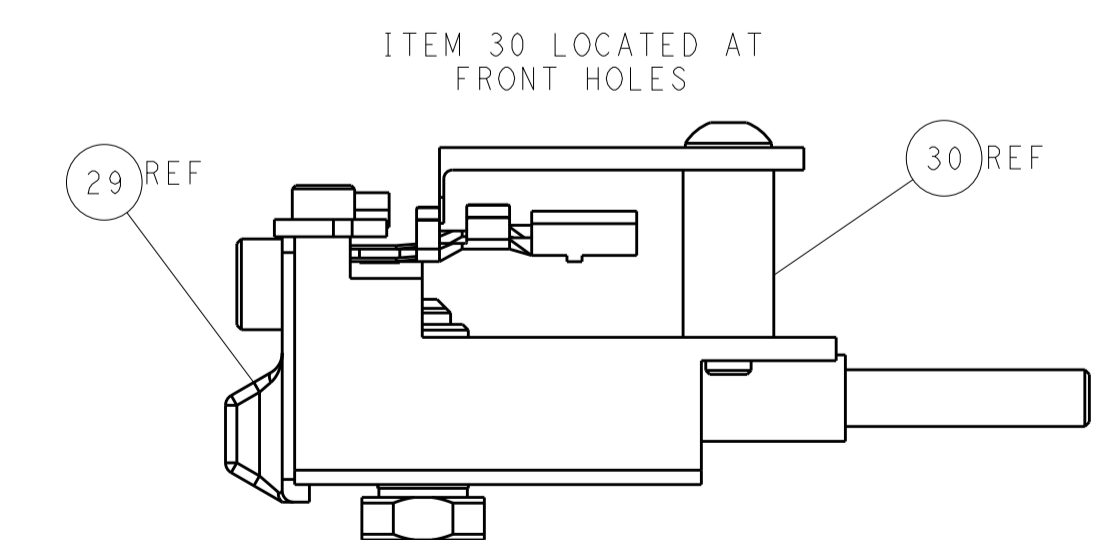
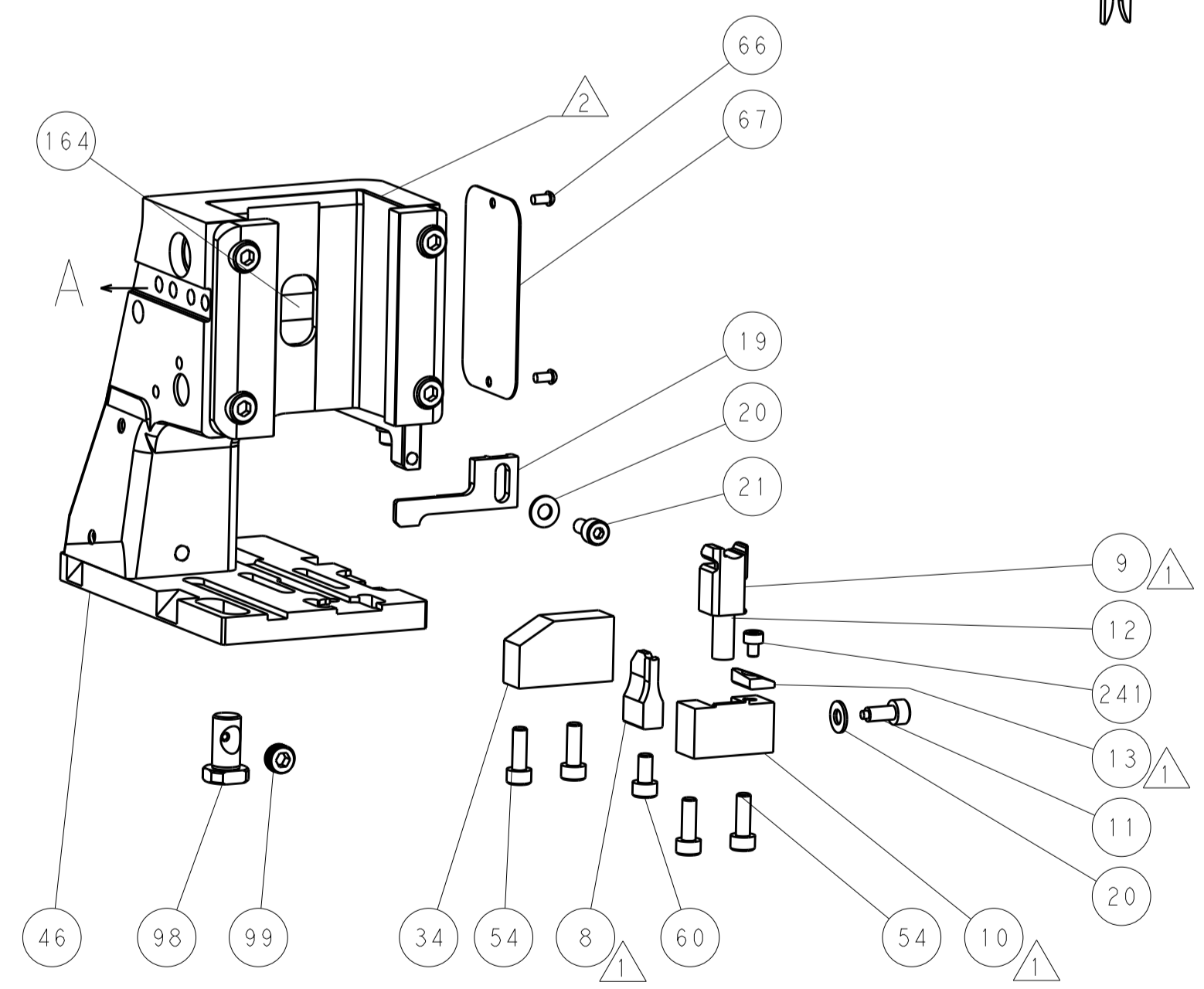
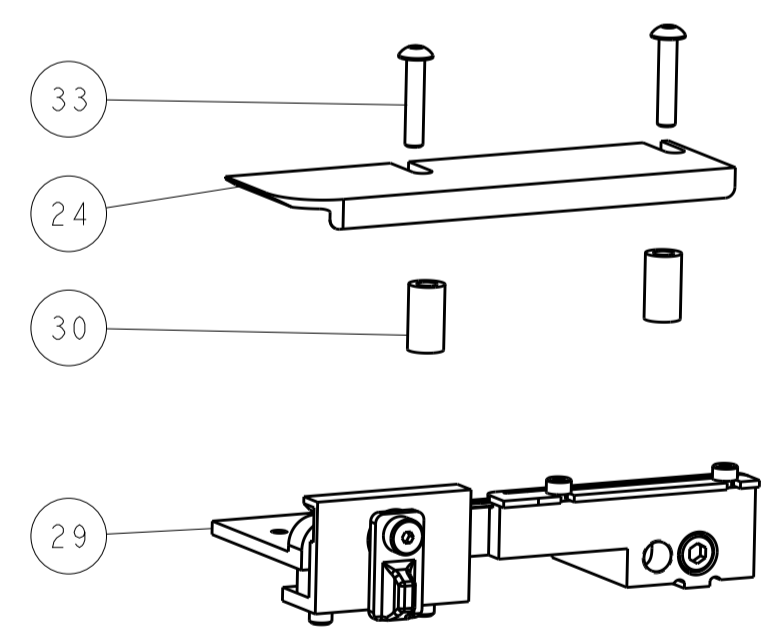
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

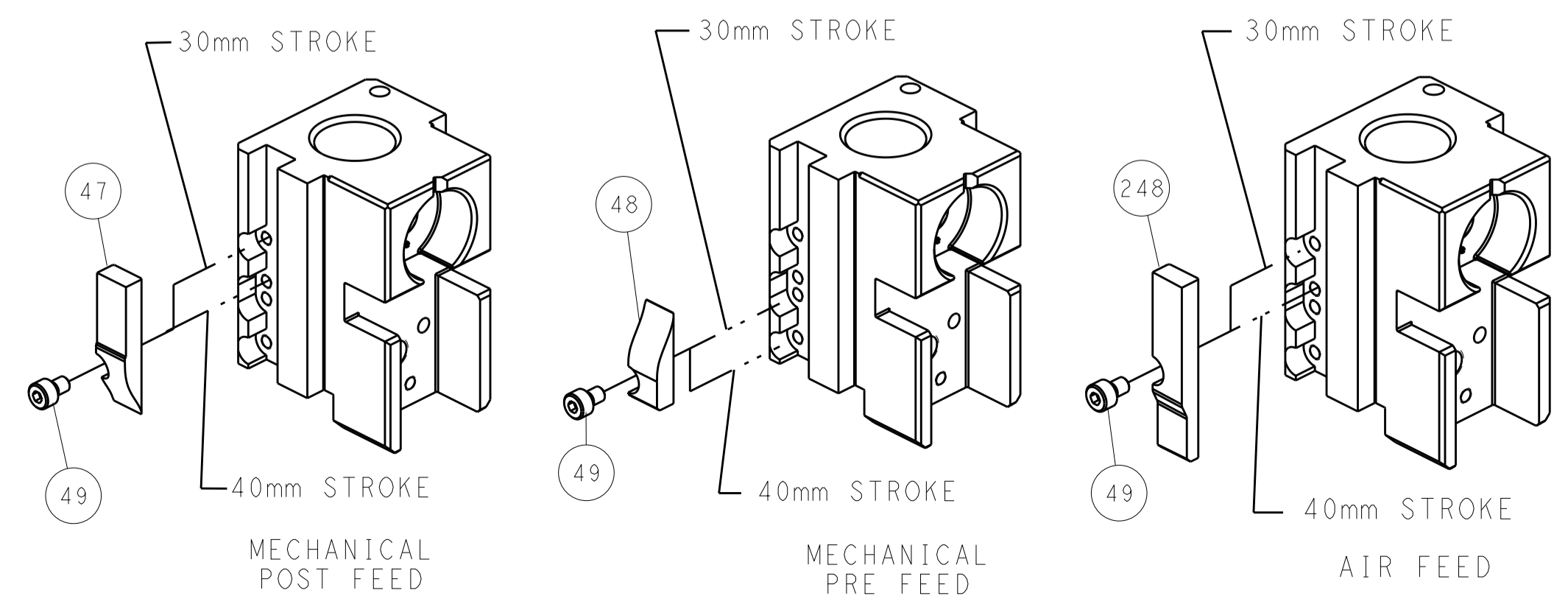


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES
 FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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

<small>THE INFORMATION CONTAINED HEREON 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. NO REPRODUCTION OR DISTRIBUTION OF THIS INFORMATION IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN Y. YIN 10JUN2014 CHK G. BAILEY 10JUN2014 APVD H. GUO 10JUN2014	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	RESTRICTED TO SIZE CAGE CODE DRAWING NO A1 00779 ©=2266311
MATERIAL FINISH		WEIGHT Customer Accessible Production Drawing	SCALE 1:2 SHEET 2 OF 4 REV B

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266311-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266311-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266311-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.90 mm [.114]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.98-5.74 mm [1.96-.226 IN]	∅1.20-2.25 mm [0.047-.089 IN]

TERMINAL APPLICATION SPECIFICATION	DELPHI SPEC

TERMINALS APPLIED

TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
1949044-1	15326267	1949045-1	15305351	1.7-2.1 mm
		1832359-1	15366060	1.9-2.3 mm
		1949130-4	15344324	1.2-2.1 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30+/-0.05 [0.051+/-0.002]	5.8
0.80mm2	1.25+/-0.05 [0.049+/-0.002]	6.2
0.75mm2	1.25+/-0.05 [0.049+/-0.002]	6.2



- 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 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.
- 6 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	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1 1	2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1 1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243		
3	-	1 1 2119083-1 RETAINER, INSULATION DIAL	242		
-	1 1	7-18023-7 SCR, SKT HD CAP M3 X 4.0	241		
-	-	1 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 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	2844908-1 SCREW, LOCKING	99		
-	1 1	2844907-1 POST, LOCKING	98		
-	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		
5	-	1 1 985575-3 SCR, FLT SKT HD CAP M3 X 10.0	57		
-	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	690753-2 SPACER, TONKER	50		
-	1 2	18023-9 SCR, SKT HD CAP M4 X 6.0	49		
-	-	1 1 2119652-1 FEED CAM, PRE FEED	48		
-	1 1	1803602-1 SCR, BHSC, RoHS (M8 X 25)	41		
-	1 1	1-1752356-8 SUPPORT, TERMINAL	34		
-	2 2	2079383-5 SCR, BHSC, RoHS (M4 X 20)	33		
-	2 2	2-2844962-8 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		
-	2 2	1-18028-2 WASHER, FLAT, REG M4	20		
-	1 1	2119533-1 STRIPPER, SIDE FEED	19		
1	-	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 1 1	2-1633920-5 ANVIL, COMBINATION	8		
-	-	-	7		
-	-	-	6		
-	1 1	2-2119781-4 DEPRESSOR, SHEAR	5		
-	1 1	238011-4 BLOCK, CRIMPER SPACER	4		
1	1 1 1	1-2119784-5 CRIMPER, INSULATION O PREMIUM	3		
-	1 1	1-455888-6 SPACER, CRIMPER	2		
1	1 1 1	456405-8 CRIMPER, WIRE PREMIUM	1		

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

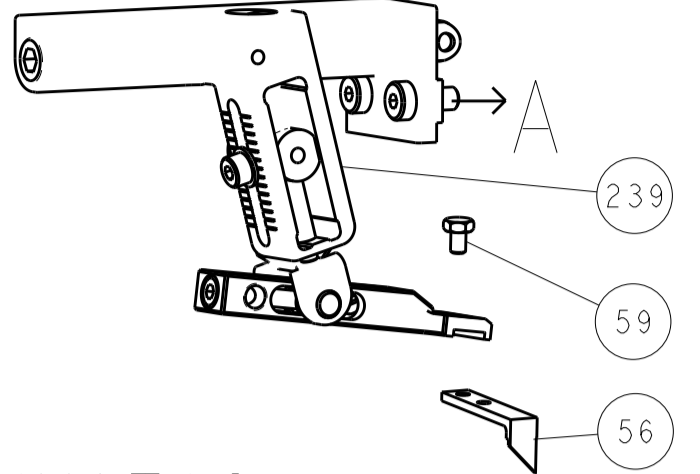
DATE	10JUN2014	CHK	J. YIN
DATE	10JUN2014	CHK	G. BAILEY
DATE	10JUN2014	APPV	H. GUO

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C=2266311	

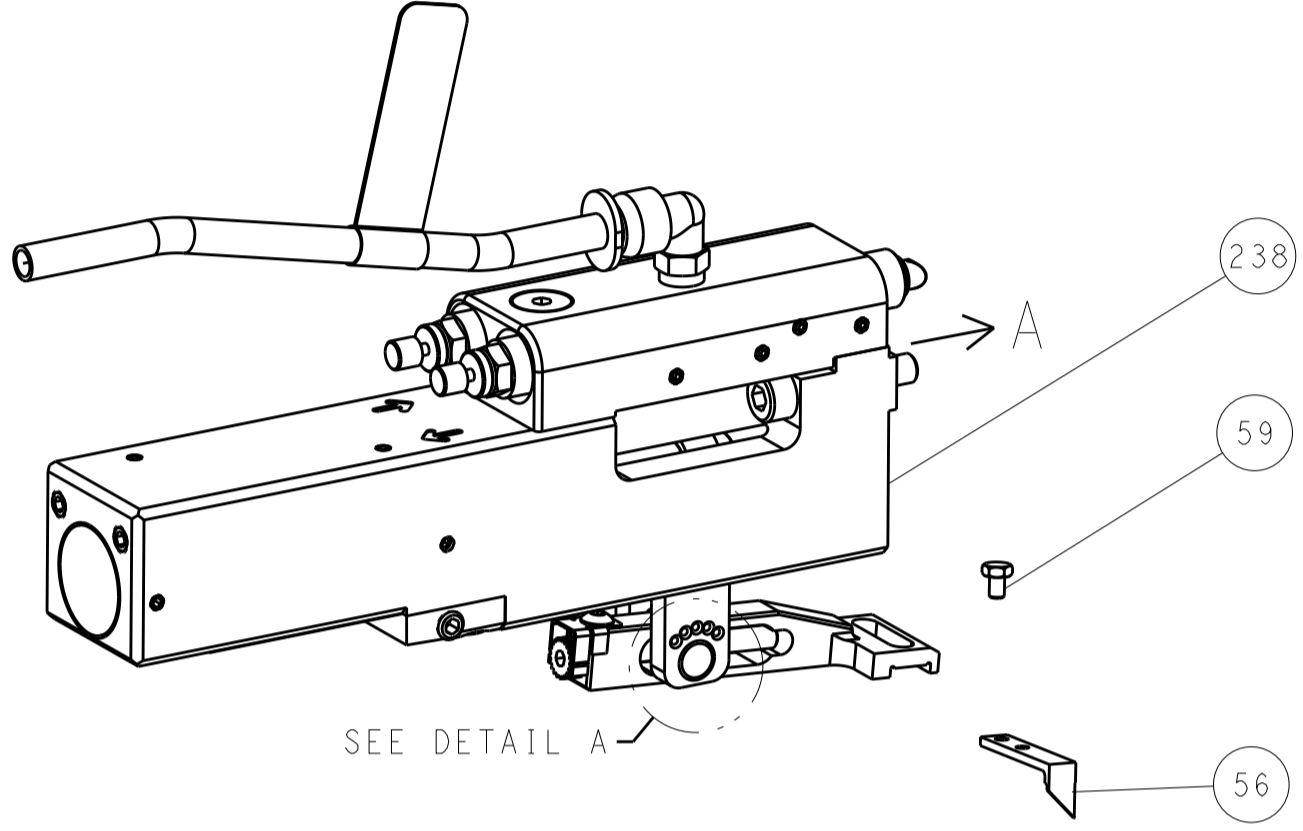
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B

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

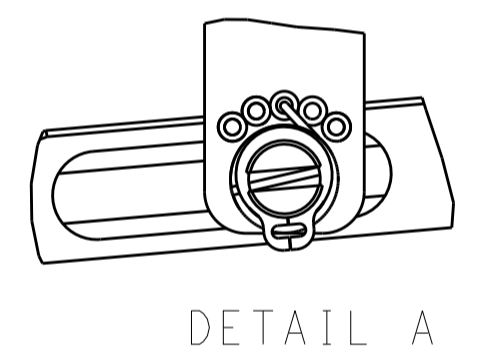
FEED TYPE MECHANICAL



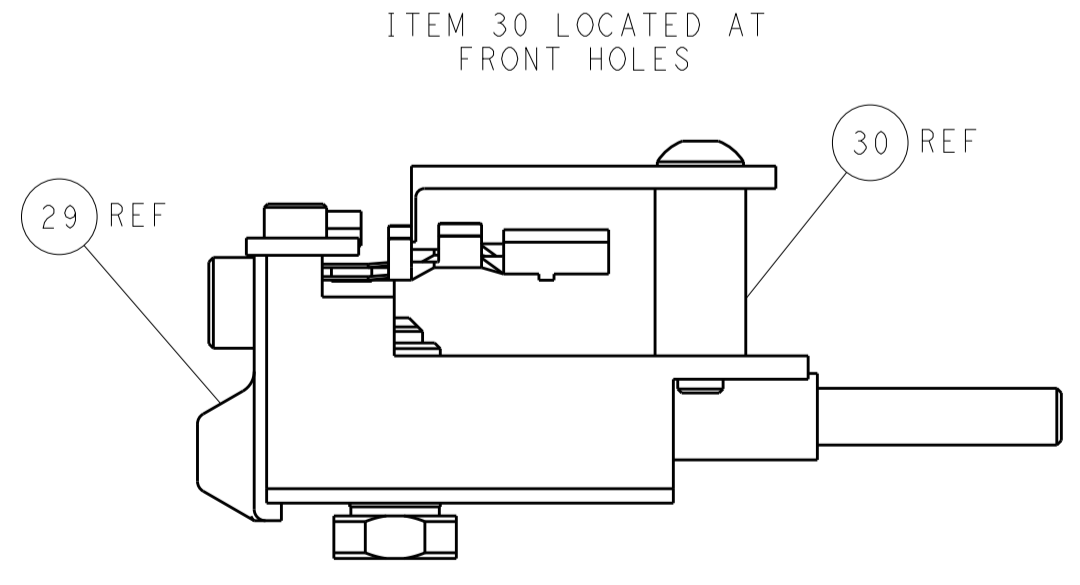
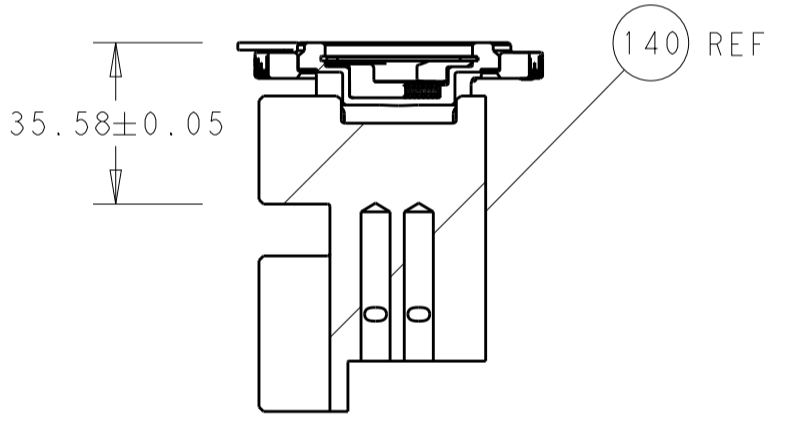
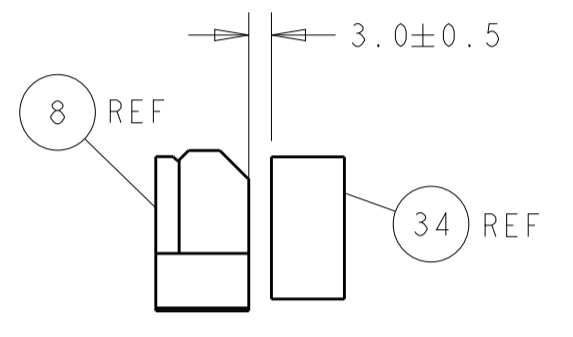
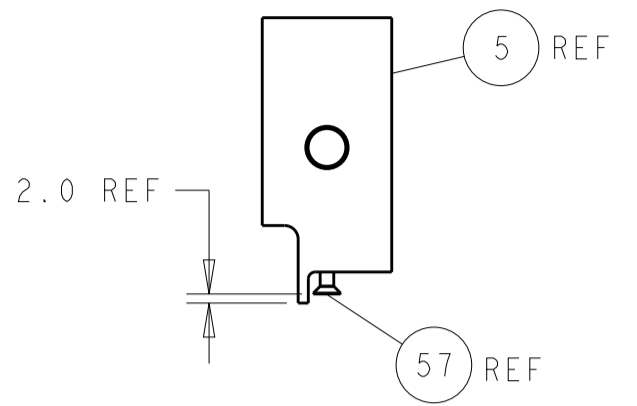
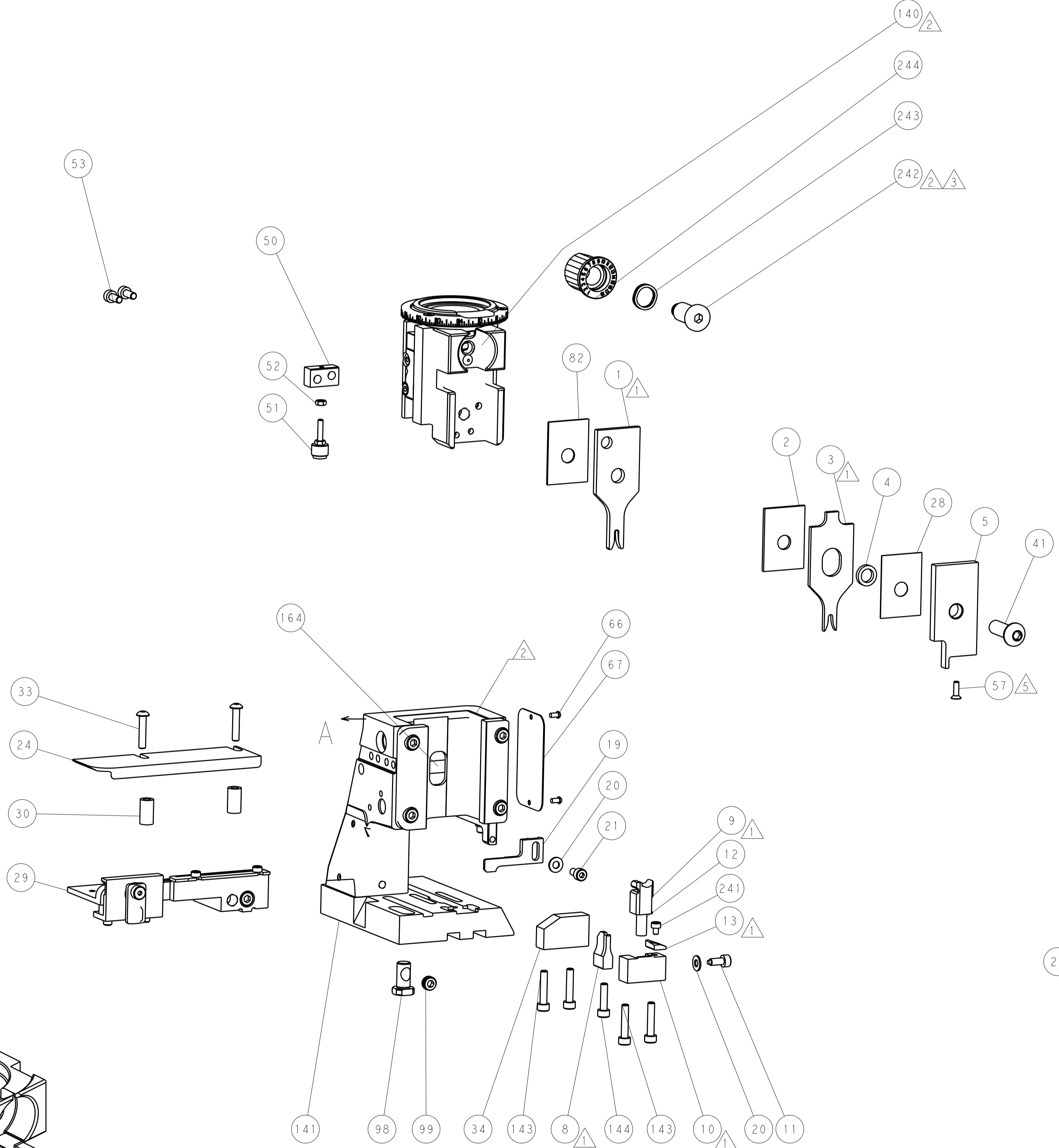
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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:		DWG: Y. YIN 10JUN2014		CHK: G. BAILEY 10JUN2014		APVD: H. GUO 10JUN2014		NAME: Ocean Side Feed Applicator	
mm	0 PLC	±		PRODUCT SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	STE TE Connectivity Harrisburg, PA 17105-3608		
	1 PLC	±		APPLICATION SPEC	A1	00779	2266311		Customer Accessible Production Drawing		
	2 PLC	±		SCALE	1:2	SHEET	4	OF	4	REV	B
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									
MATERIAL	FINISH										

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[2266311-1](#)