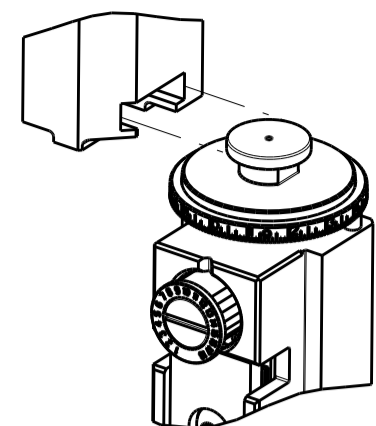


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266447-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266447-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266447-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266447-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266447-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

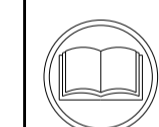


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.90 mm [.075]	F
INSUL	2.45 mm [.096]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TAXI TERM F MIC/P 100W			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.47-5.24 mm [.176-.206 IN]	Ø1.80-2.00 mm [.071-.079 IN]		
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1949214-1	15359002	1949214-2	12176829
1949214-3	12084912		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20 +/- 0.05 [0.047 +/- .002]	6.3
0.75mm2	1.10 +/- 0.05 [0.043 +/- .002]	7.3



- 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.

**\*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	REV	DATE	BY	APPV
		A	RELEASED	30SEP2014	KH UG
		B	ECR-19-006315	22APR2019	FZ TE
		C	ECR-19-012265	05AUG2019	FZ GB

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	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	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1803607-1	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1752356-3	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	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	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	-	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1-1803055-9	ANVIL, COMBINATION	8
-	1	1	1	1	3-240641-1	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	2-1633962-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	2	2	1	7-1633730-2	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

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

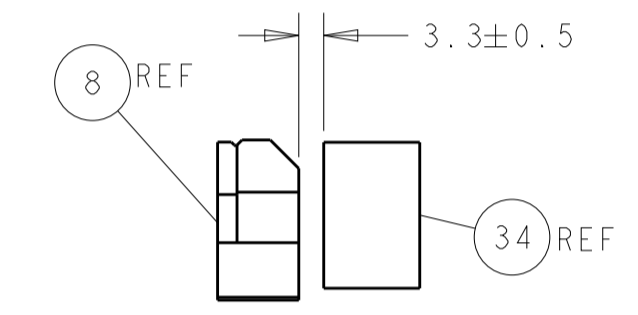
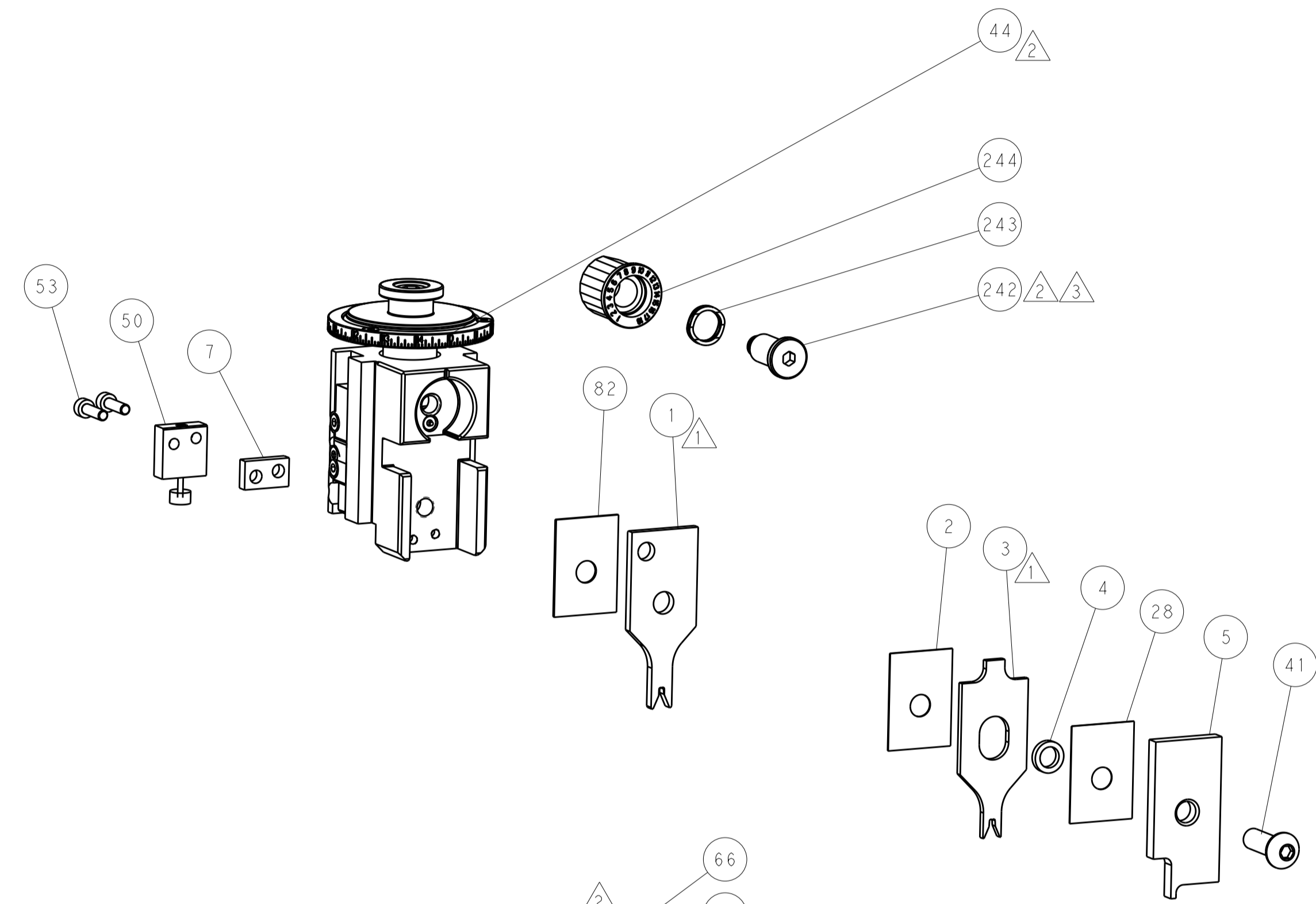
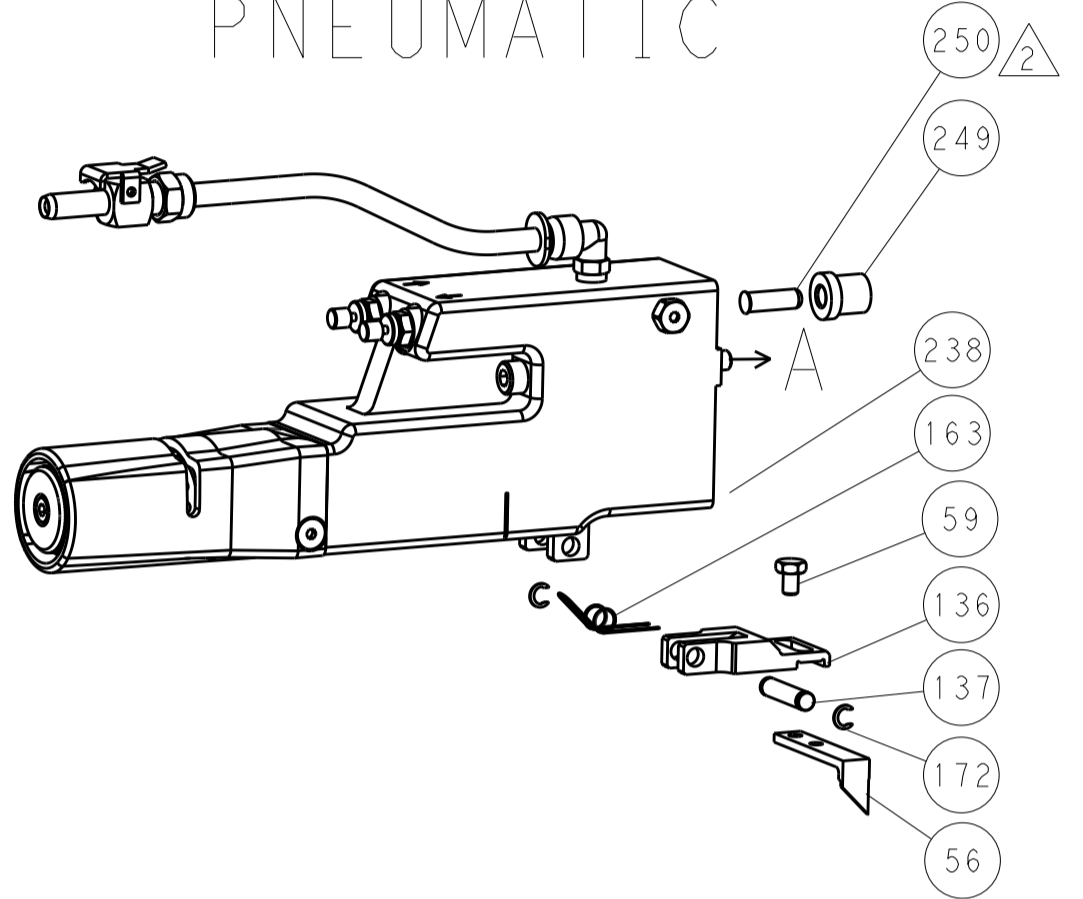
OWN	H. HUANG	25AUG2014	CHK	L. ZHANG	25AUG2014	APVD	H. GUO	25AUG2014
PRODUCT SPEC								
APPLICATION SPEC								
SIZE	CAGE CODE	DRAWING NO					RESTRICTED TO	
A1	00779	2266447					C	
Customer Accessible Production Drawing								
SCALE		1:2	SHEET		1	OF 4		

LOC	DIST	REV	DATE	BY	APPV
A	66				

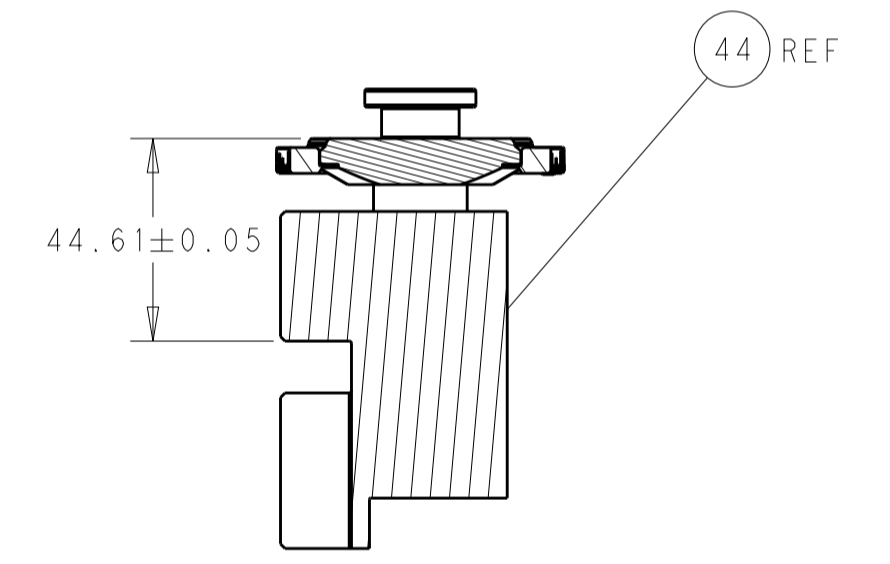
# FEED TYPE MECHANICAL



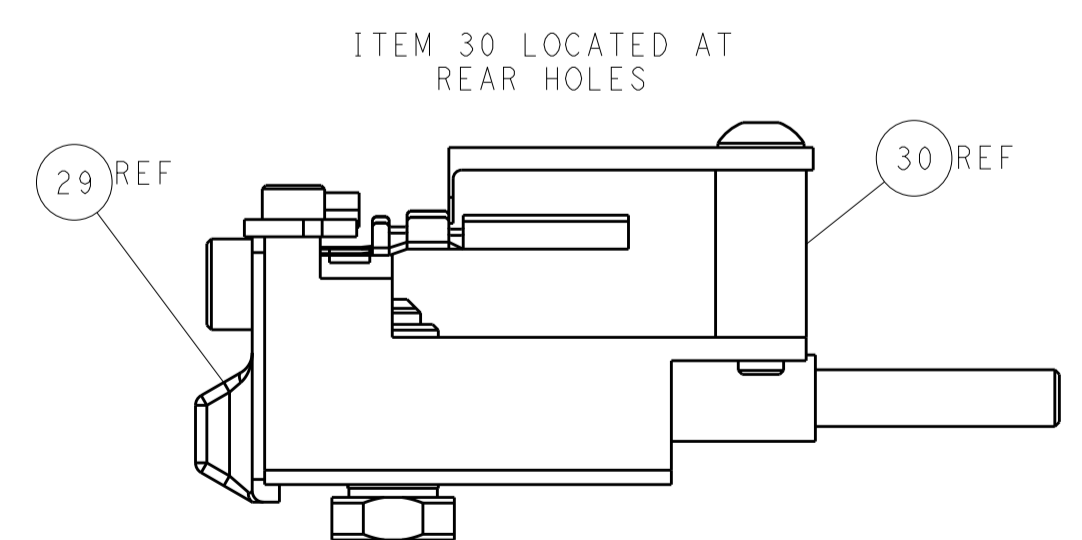
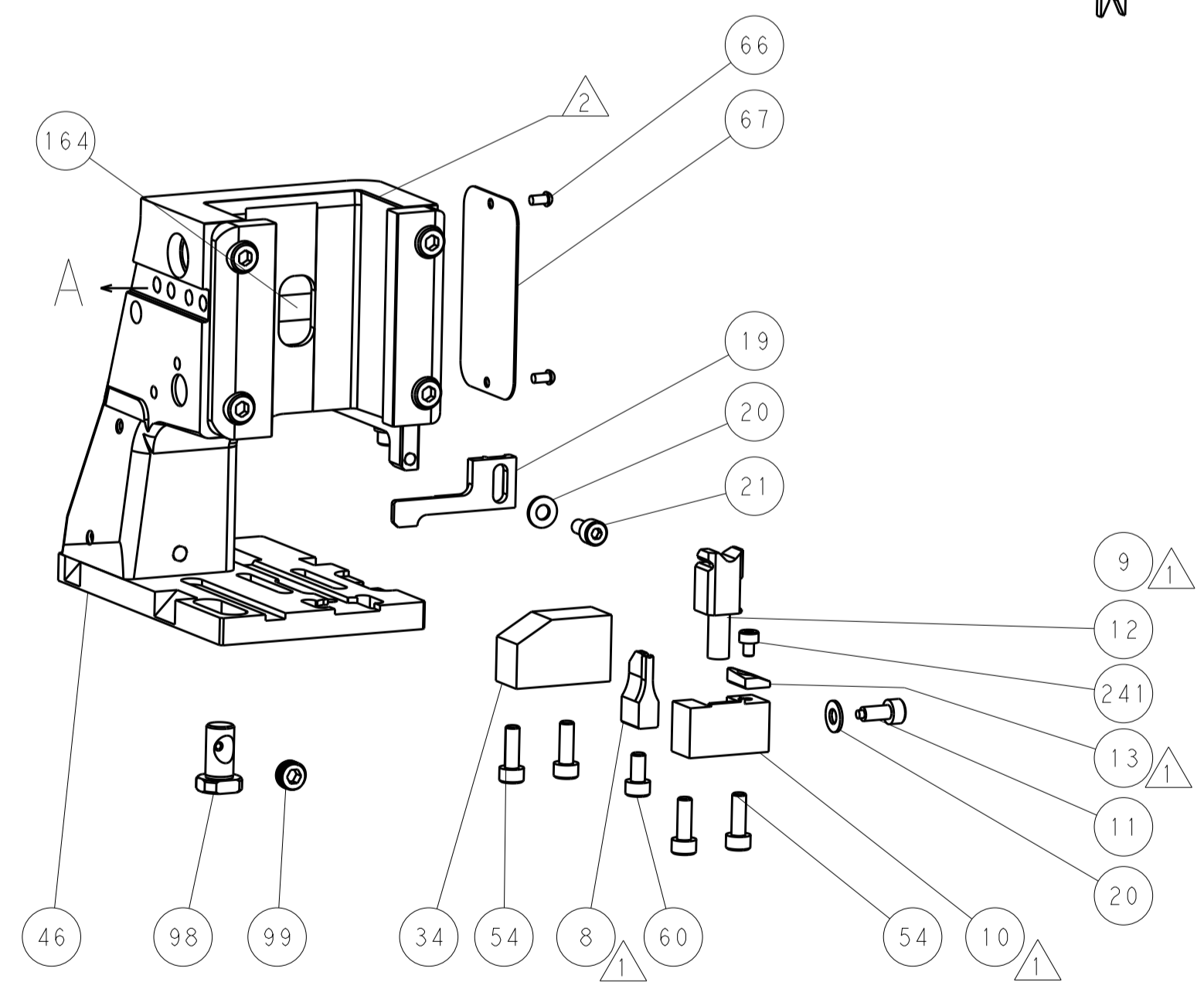
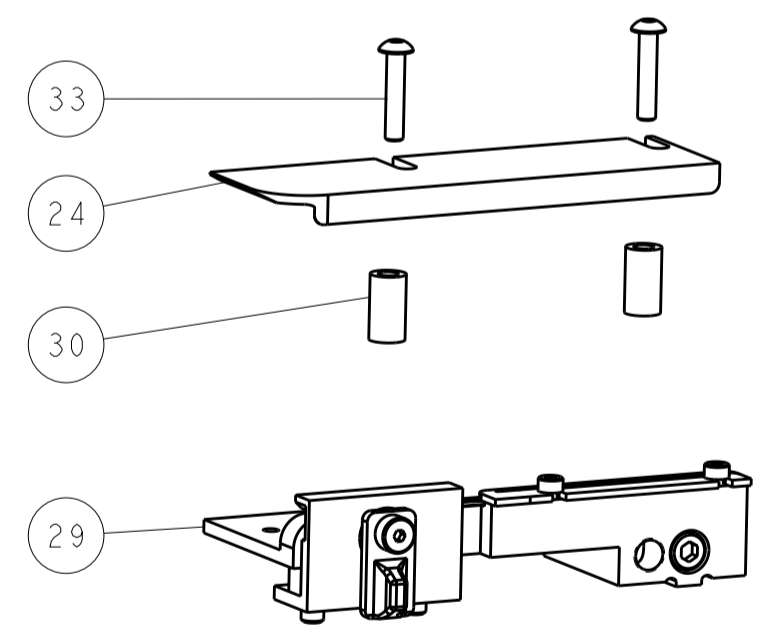
# PNEUMATIC



TERMINAL SUPPORT LOCATION

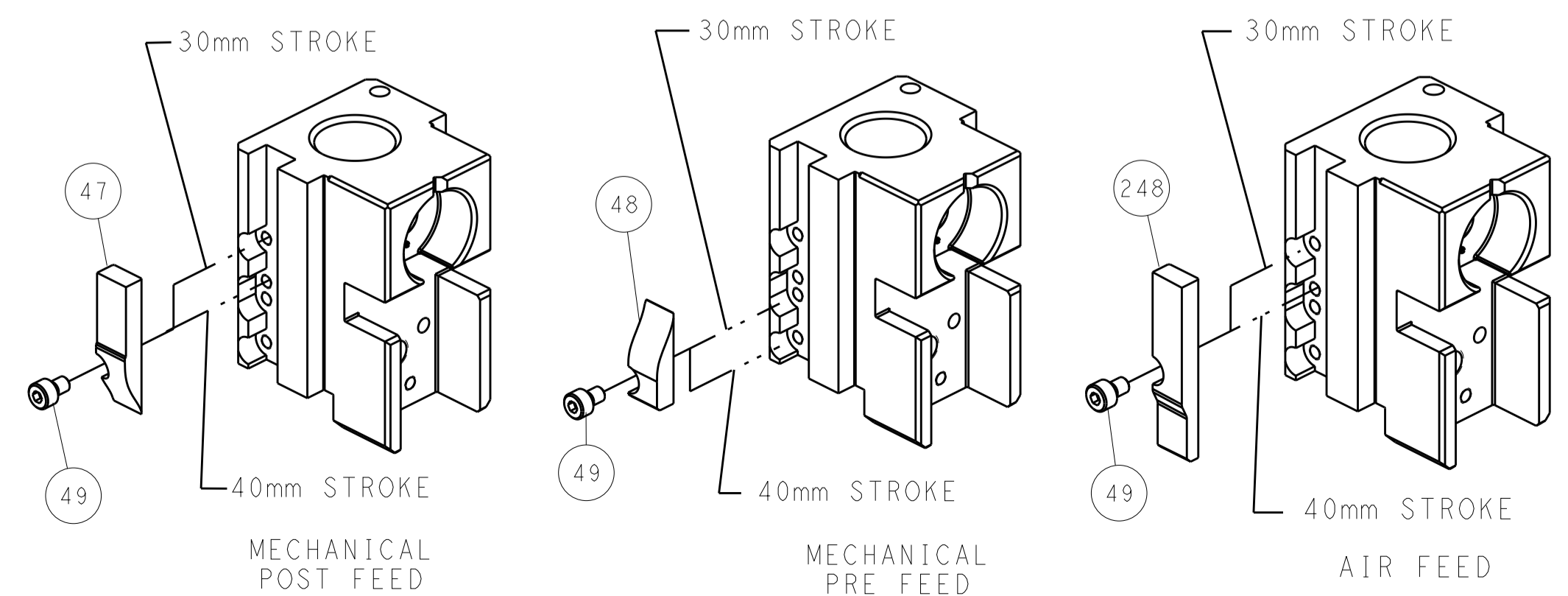


RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN H. HUANG 25AUG2014 CHK L. ZHANG 25AUG2014 APVD H. GUO 25AUG2014 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2266447 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV C	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266447-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266447-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266447-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.90 mm [.075]	F
INSUL	2.45 mm [.096]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TAXI TERM F MIC/P 100W			
WIRE STRIP LENGTH 4.47-5.24 mm [1.76-.206 IN]	INSULATION DIAMETER RANGE Ø1.80-2.00 mm [.071-.079 IN]		
TERMINAL APPLICATION SPECIFICATION CRIMP INFORMATION SHEET Rev PAGE 11 OF 15			
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1949214-1	15359002	1949214-2	12176829
1949214-3	12084912		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20 +/- 0.05 [1.047 +/- .002]	6.3
0.75mm2	1.10 +/- 0.05 [1.043 +/- .002]	7.3

- 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.

**\*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	BY	APPD	DESCRIPTION	DATE	BY	APPD		
-	1	-		2119640-1				PUSH ROD, AIR FEED	250
-	1	-		1803259-1				BUSHING, FLANGED	249
-	1	1		2119082-5				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	-		2063440-1				AIR FEED MODULE	238
-	2	-		21045-3				RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF		994970-2				COUNTER, MAGNETIC	164
-	1	-		240638-1				SPRING, FEED FINGER	163
-	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	-		3-23627-7				PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-		2119799-1				HOLDER, FEED FINGER, AF	136
-	1	1		2844908-1				SCREW, LOCKING	99
-	1	1		2844907-1				POST, LOCKING	98
-	1	1		455888-7				SPACER, CRIMPER	82
-	1	1		1803607-1				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		2-2168083-5				SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1		1803382-6				HOLD DOWN, SPRING LOADED	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		1752356-3				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		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		1803095-6				FLOATING SHEAR, FRONT	9
-	1	1		1-1803055-9				ANVIL, COMBINATION	8
-	1	1		3-240641-1				SPACER	7
-	-	-		-				-	6
-	1	1		2119757-4				DEPRESSOR, SHEAR	5
-	1	1		238011-4				BLOCK, CRIMPER SPACER	4
-	1	1		2-1633962-1				CRIMPER, INSULATION F PREMIUM	3
-	1	1		455888-4				SPACER, CRIMPER	2
-	1	1		7-1633730-2				CRIMPER, WIRE	1

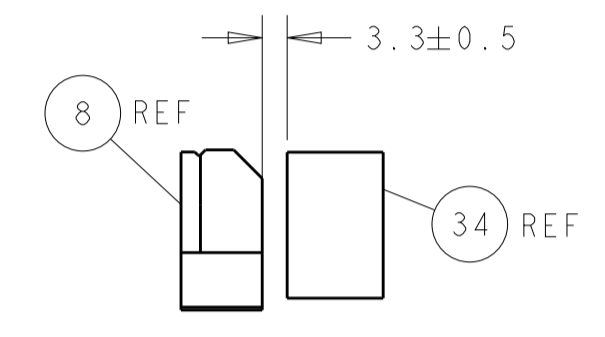
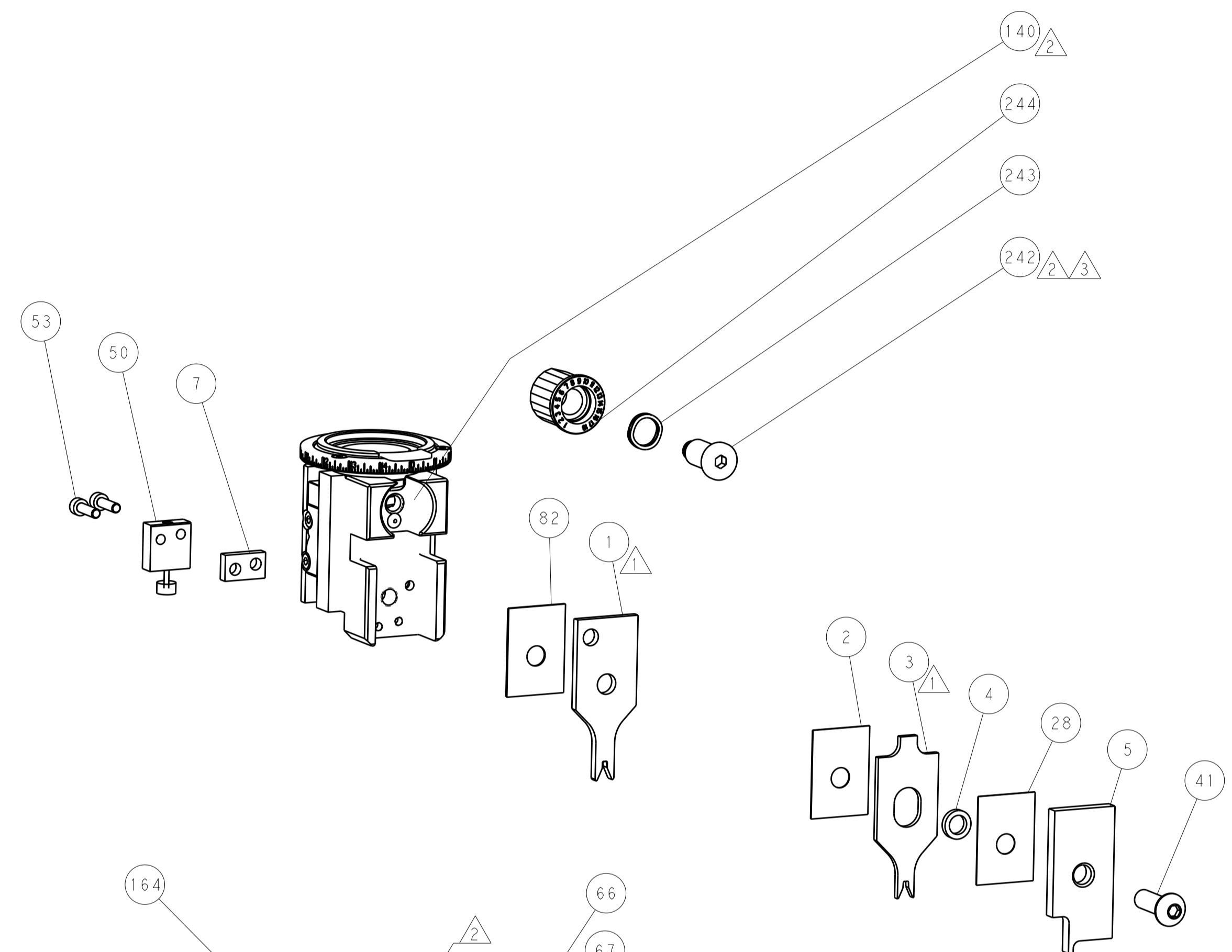
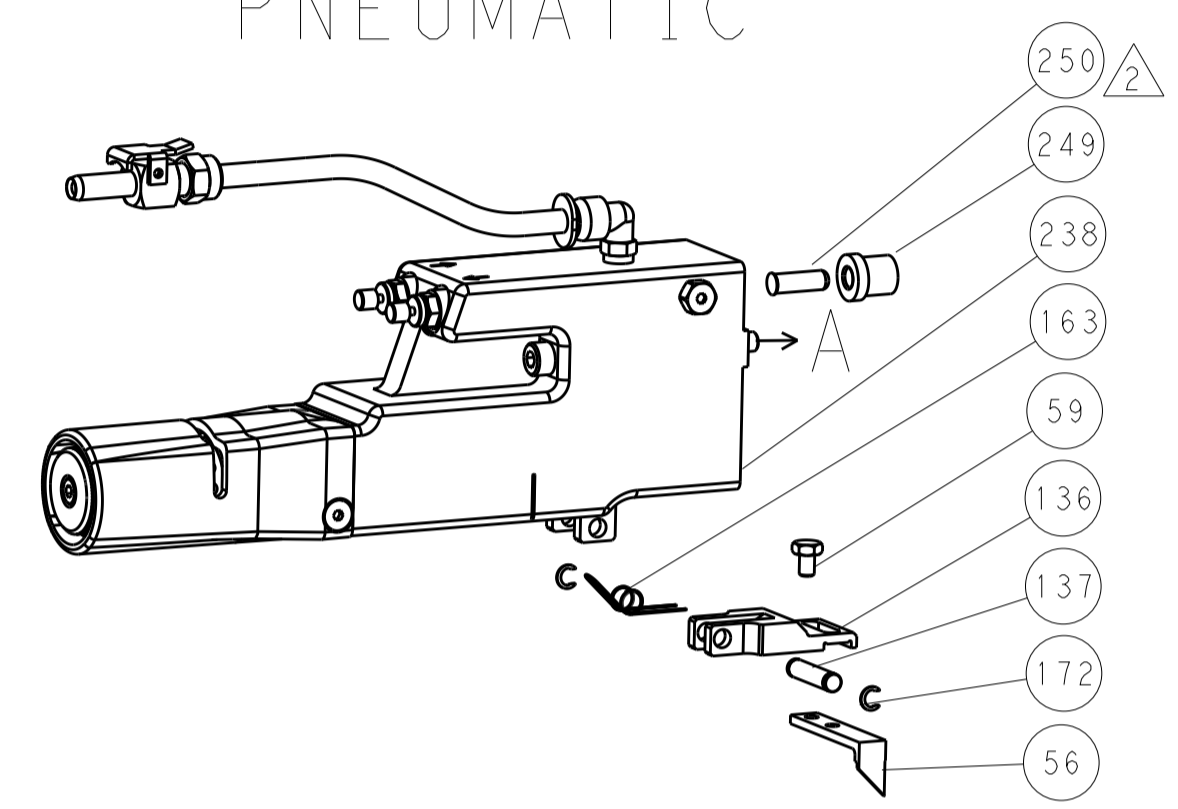
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: 25AUG2014		CHK: 25AUG2014		APVD: 25AUG2014		NAME: CHEN HUANG	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	PRODUCT SPEC		NAME: L. ZHANG	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET 3 OF 4		REV C	

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

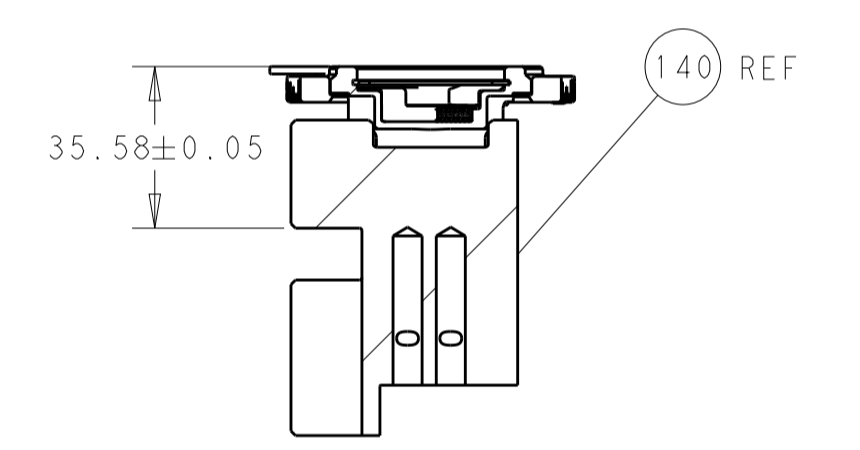
# FEED TYPE MECHANICAL



# PNEUMATIC

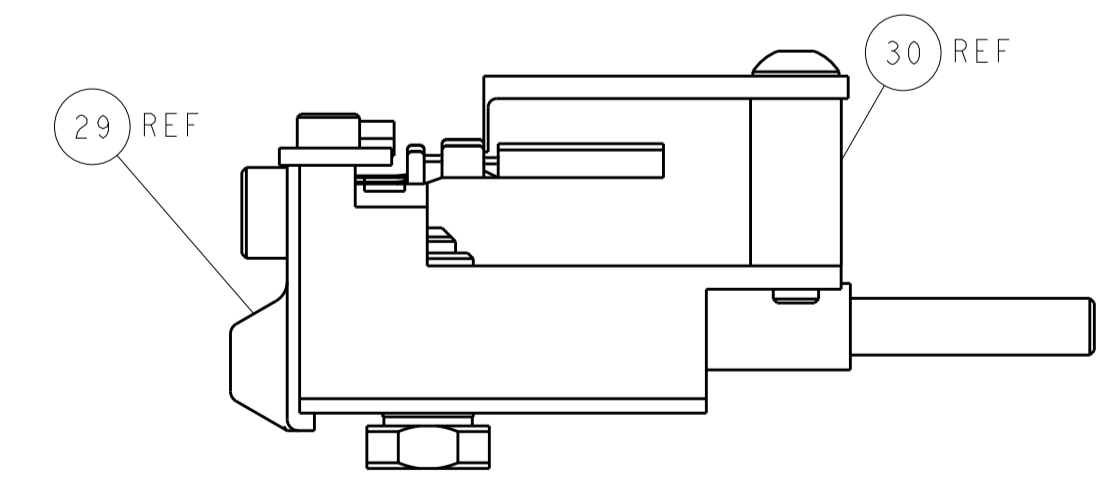


TERMINAL SUPPORT LOCATION



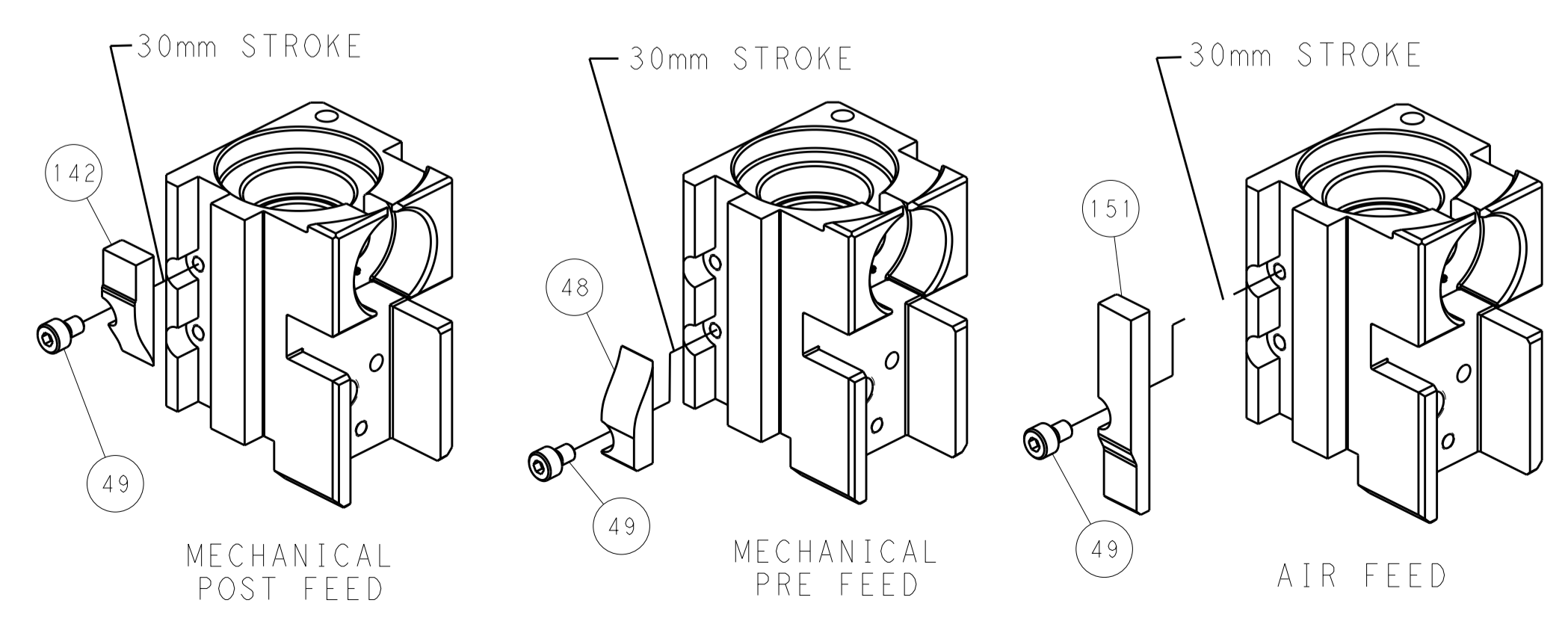
RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

# 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: H. HUANG 25AUG2014		TE Connectivity	
mm	0 PLC	±		CHK: L. ZHANG 25AUG2014	NAME: Ocean Side Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: H. GUO 25AUG2014	SIZE: CAGE CODE: DRAWING NO: 00779		RESTRICTED TO
	2 PLC	±		PRODUCT SPEC		SCALE: 1:2 SHEET 4 OF 4 REV C	
	3 PLC	±		APPLICATION SPEC			
	4 PLC	±		WEIGHT			
	ANGLES	±		MATERIAL			
	FINISH	±		Customer Accessible Production Drawing			