

Atlantic Version Terminator Interface Adapter table with columns: Part Number, Revision, Description, Feed Type, Convert To, Part Numbers Required.

Applicator Data table with columns: Crimp, Size, Type. Includes applicator instructions 408-10389.

Terminal Data: Delphi Terminal Delphi Packard Crimp Specification table with columns: Terminal Name, Wire Strip Length, Insulation Diameter Range.

Terminals Applied table with columns: TE Terminal, Delphi Terminal, TE Seal, Delphi Seal, Cable Diameter.

Wire Size table with columns: Wire Size, Crimp Height, Crimp Height Reference Setting.

- 1 RECOMMENDED SPARE PARTS
2 GREASE BEARING SURFACES LIGHTLY
3 LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER: MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266700-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266700-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266700-5 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266700-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
9 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.
10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.30.
13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
14 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.
15 CUT TO LENGTH AT ASSEMBLY.

\*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

Table with columns: Part No, Description, Item No. Includes items 2119957-2 and 8-21084-0.

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

SET UP GAUGE 2119599-1, REVISIONS table with columns: Description, Date, Dwn, Appv.

Main parts list table with columns: Description, Date, Dwn, Appv. Includes parts like PUSH ROD, AIR FEED, BUSHING, LCH5-12, MISUMI, FEED CAM, AIR FEED, DETENT PIN, SPRING, COMPRESSION, RAM, AMP STYLE, SIDE FEED, NON-ADJ., CAM, SNAIL, INSULATION ADJUSTMENT, WASHER, WAVE SPRING, CREST-TO-CREST, RETAINER, INSULATION DIAL, SCR, SKT HD CAP M3 X 4.0, SHCS, LOW HEAD, RoHS, M5 X 16, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, TAG, IDENTIFICATION, SPACER, FEEDER, RING, RETAIN, EXTERN, 3/16 CRESCENT, MAGNET, RARE EARTH HIGH ENERGY, COUNTER, MAGNETIC, SPRING, FEED FINGER, PIN, RETAIN, GRVD, 3/16 X .854, HOLDER, FEED FINGER, AF, MEMORY CHIP, PROGRAMMED, SERVO FEED LATCH ASM, FEED FINGER ASSEMBLY, SF, SPACER, CRIMPER, DOCUMENTATION PACKAGE, TAG, IDENTIFICATION, SCREW, DRIVE, RH, RoHS, 2 x .188, LIMITER, ADJUSTMENT BOLT, SCR, SET, SOC, CONE POINT, M3 x 4.0, SCR, BHSC, RoHS (M4 X 8), SCR, HEX HD CAP, M4 X 6.0, SCR, FLT SKT HD CAP M3 X 10.0, PAWL, FEED, SHCS, LOW HEAD, RoHS, M4 X 12, SCR, SKT HD CAP, RoHS, M4 X 16, NUT, HEX, REG, RoHS, M3, BUMPER, HOLD DOWN, SPACER, TONKER, SCR, SKT HD CAP M4 X 6.0, FEED CAM, PRE FEED, FEED CAM, POST FEED, APPLICATOR BASIC ASSEMBLY, SF, RAM, AMP STYLE, SIDE FEED, SCR, BHSC, RoHS (M8 X 25), DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, PRECISION, FA HEAD, ATLANTIC STYLE, BOLT, ADJUSTMENT, SUPPORT, TERMINAL, SCR, BHSC, RoHS (M4 X 20), HEX HEAD, FLANGED, M5 x 8mm LONG, SPACER, STRIP GUIDE, ASSEMBLY, STRIP GUIDE, SPACER, CRIMPER, STRIP GUIDE, SCR, SKT HD CAP, RoHS, M4 X 8.0, WASHER, FLAT, REG M4, STRIPPER, SIDE FEED, INSERT, SHEAR, SPRING, COMPRESSION, STOP, SHEAR, SHEAR HOLDER, FRONT, FLOATING SHEAR, FRONT, ANVIL, COMBINATION .080, SPACER, DEPRESSOR, SHEAR, BLOCK, CRIMPER SPACER, CRIMPER, INSULATION O PREMIUM, SPACER, CRIMPER, CRIMPER, WIRE PREMIUM.

Product information block including dimensions, tolerances, material, weight, and manufacturer information for STE Ocean Side Feed Applicator.

LOC	DIST	REV	DATE	BY	APPV
A	66				

# FEED TYPE MECHANICAL



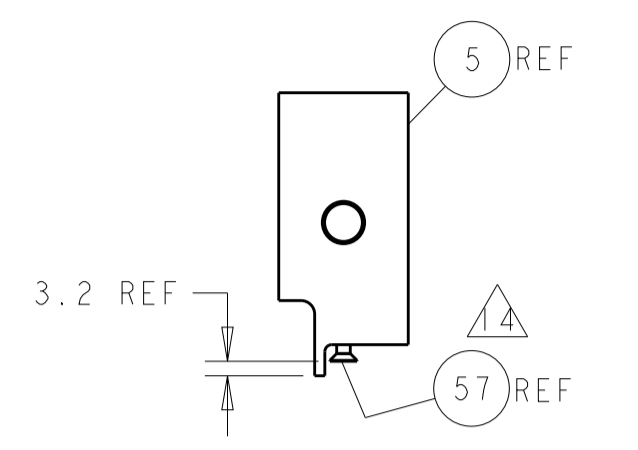
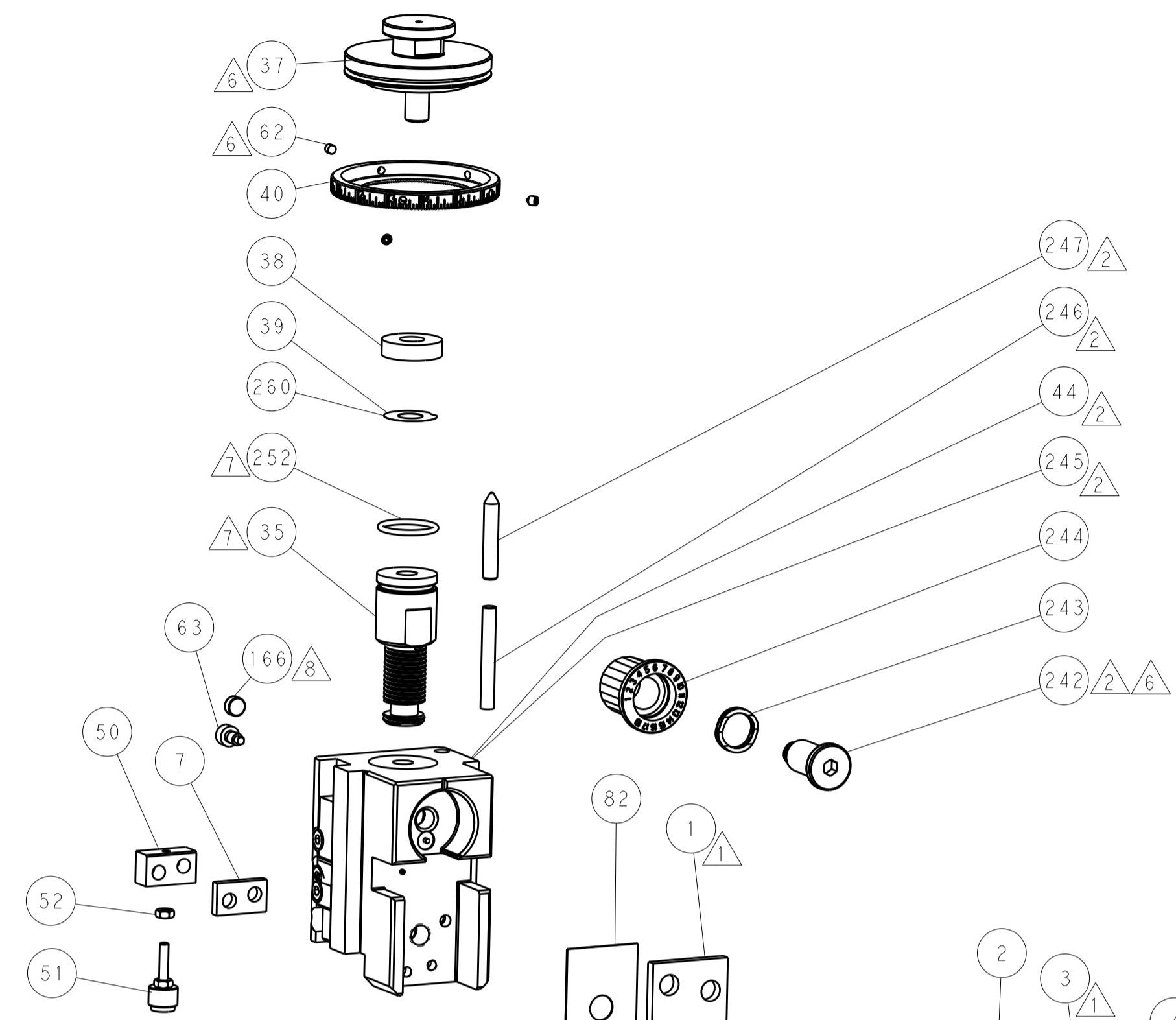
# PNEUMATIC



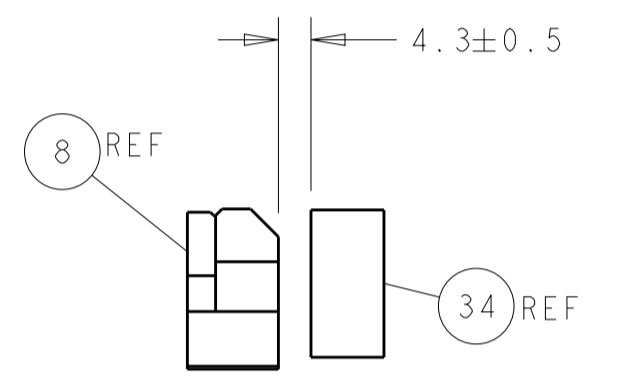
# SERVO LATCH PLATE



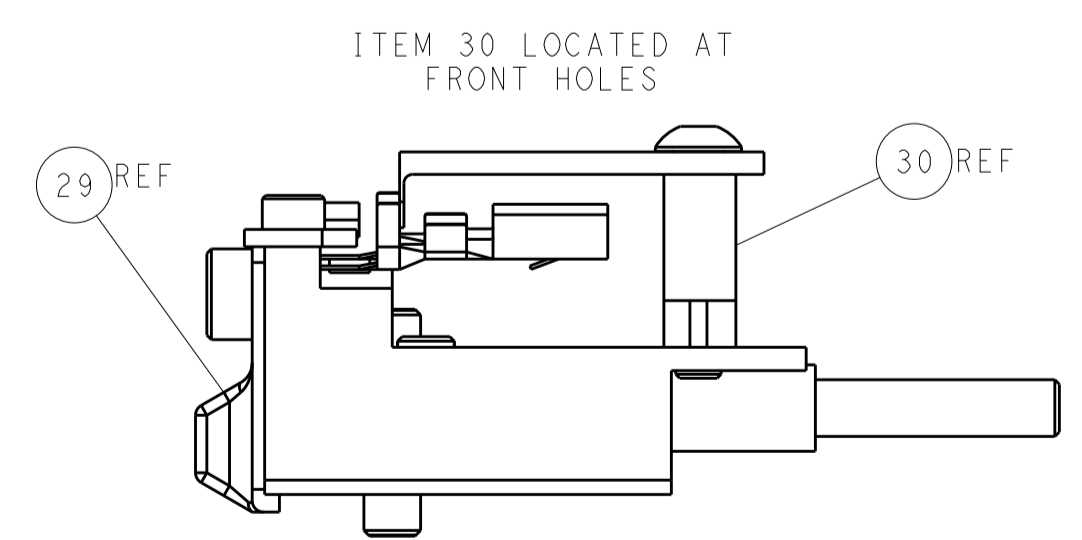
# CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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:		DWG: HOFFNER 2MAR2015		TE Connectivity	
mm	0 PLC	±		CHK: T. ELBIN 3MAR2015	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APPV: T. ELBIN 3MAR2015	PRODUCT SPEC	SIZE	CAGE CODE DRAWING NO
	2 PLC	±			APPLICATION SPEC	A1	00779 ©=2266700
	3 PLC	±			WEIGHT	SCALE	1:2 SHEET 2 OF 4 REV A1
	4 PLC	±					
	ANGLES	±					
MATERIAL	FINISH						

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266700-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266700-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266700-4	-	-	-
	2-2266700-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266700-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266700-4	-	-	-
	2-2266700-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2266700-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266700-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.03 mm [.080]	F	
INSUL 4.32 mm [.170]	O	
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION				
TERMINAL NAME: TERM F M/P 280 SEALED TANGLESS				
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE		
4.72-5.50 mm [.186-.217 IN]		∅	∆	
TERMINAL APPLICATION SPECIFICATION 12110847 PAGE 1 6 7 9 OF 22 Rev - -				
TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	CABLE DIAMETER
1572394-1	12110847	1949092-1	15324985	∅1.60-2.15
		1949807-1	15324982	∅2.03-2.85
		1572716-3	15324980	∅2.81-3.49

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.50+/-0.05 [.059+/-0.002]	7.7
0.80mm2	1.40+/-0.05 [.055+/-0.002]	8.9

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- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266700-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266700-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266700-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 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.
- CUT TO LENGTH AT ASSEMBLY.

**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

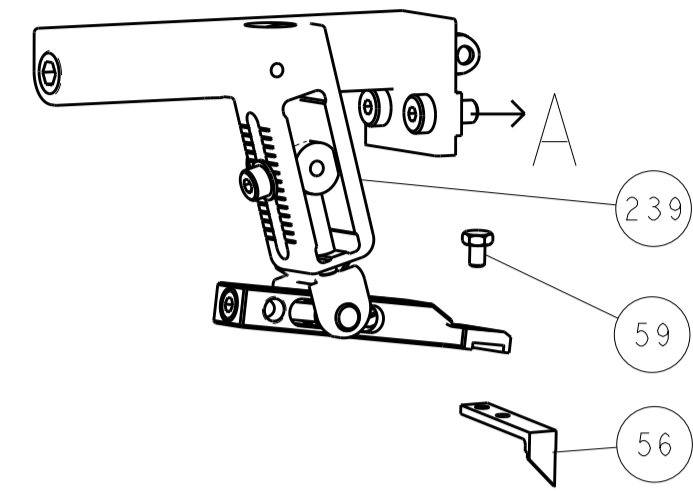
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2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-2	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
-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA, MAT.	152
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	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	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	7-1633131-4	ANVIL, COMBINATION .080	8
-	1	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	4-1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2
-	1	1	1	1	5-456405-3	CRIMPER, WIRE PREMIUM	1

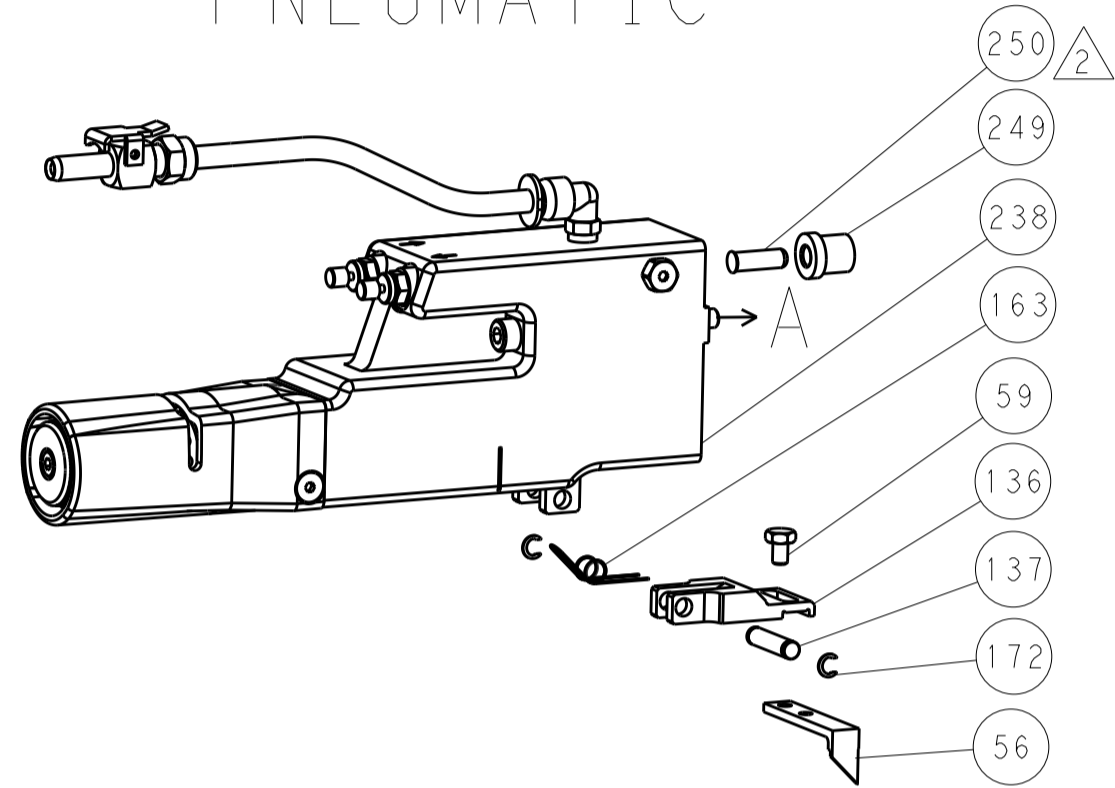
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL		WEIGHT		SCALE	

OWN: HOFFNER 2MAR2015	NAME: Ocean Side Feed Applicator
CHK: T. ELBIN 3MAR2015	SIZE: A1
APVD: T. ELBIN 3MAR2015	CAGE CODE: 00779
PRODUCT SPEC	DRAWING NO: 2266700
APPLICATION SPEC	SCALE: 1:2
RESTRICTED TO	SHEET 3 OF 4
Customer Accessible Production Drawing	REV: A1

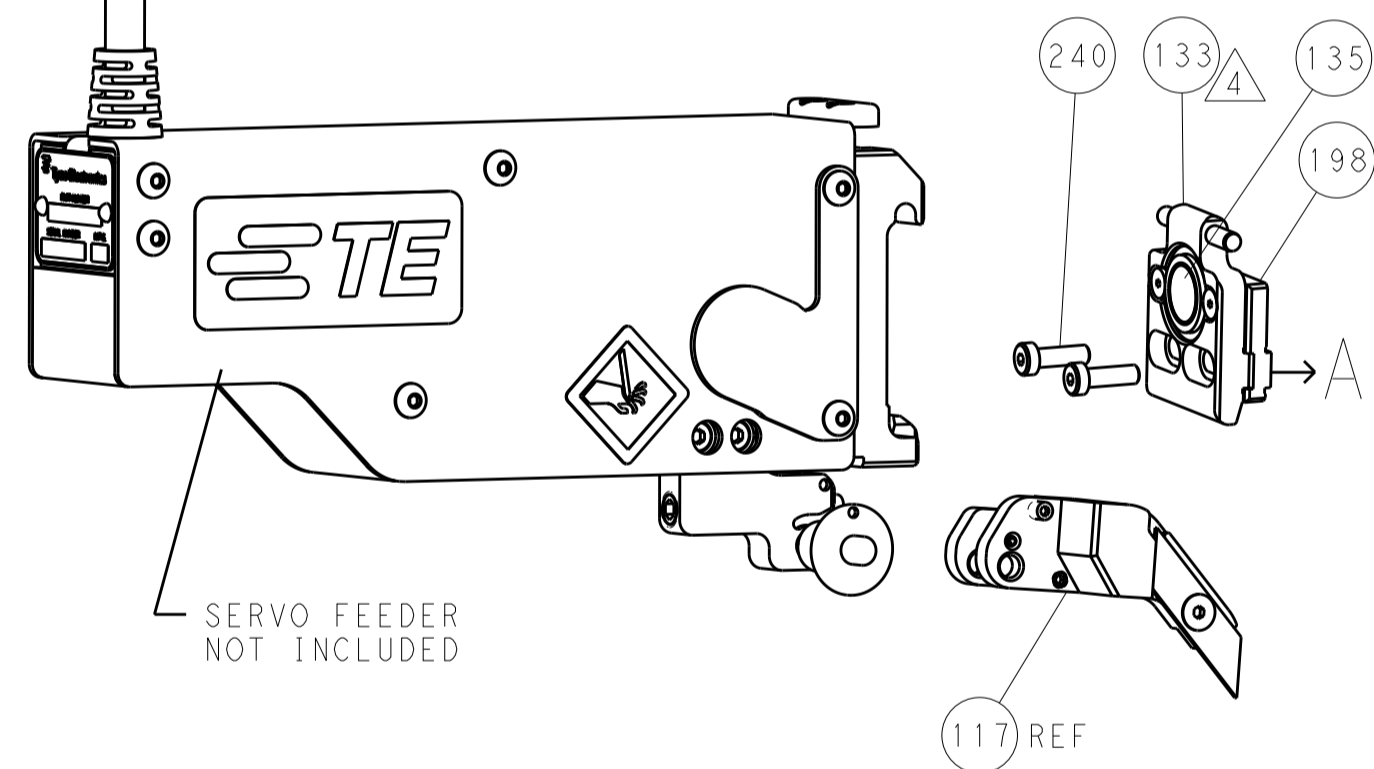
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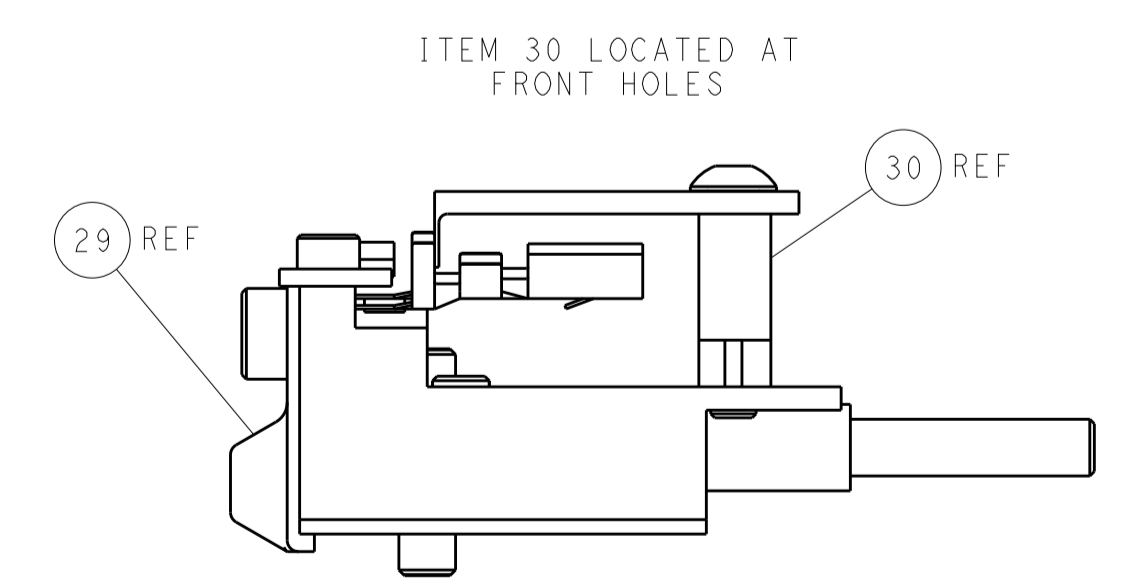
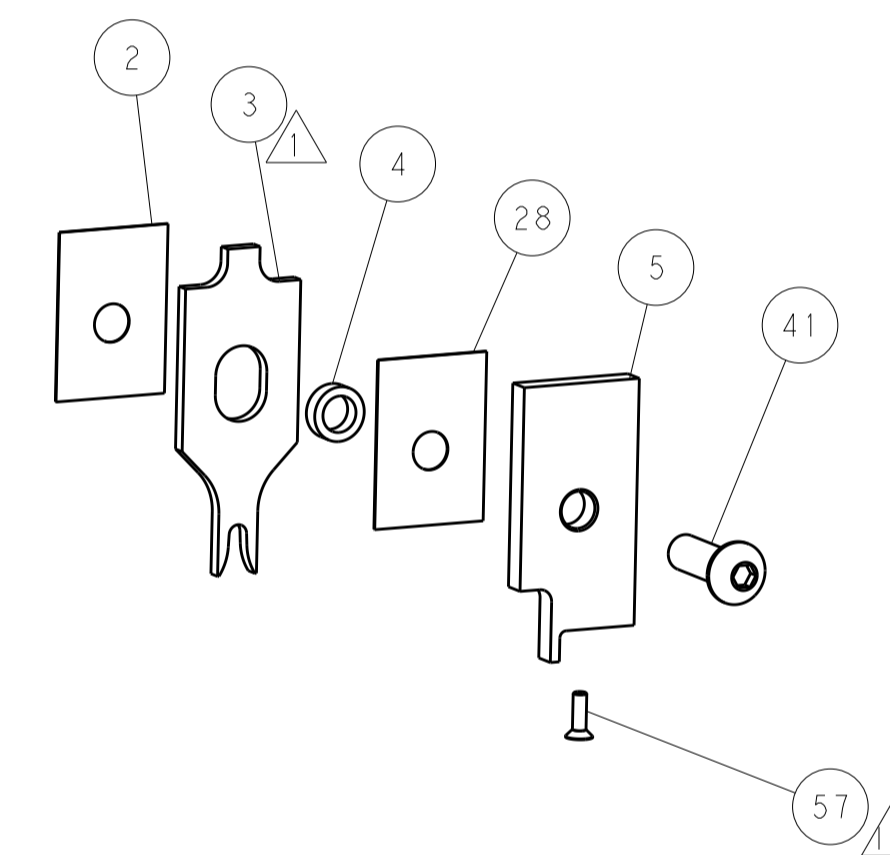
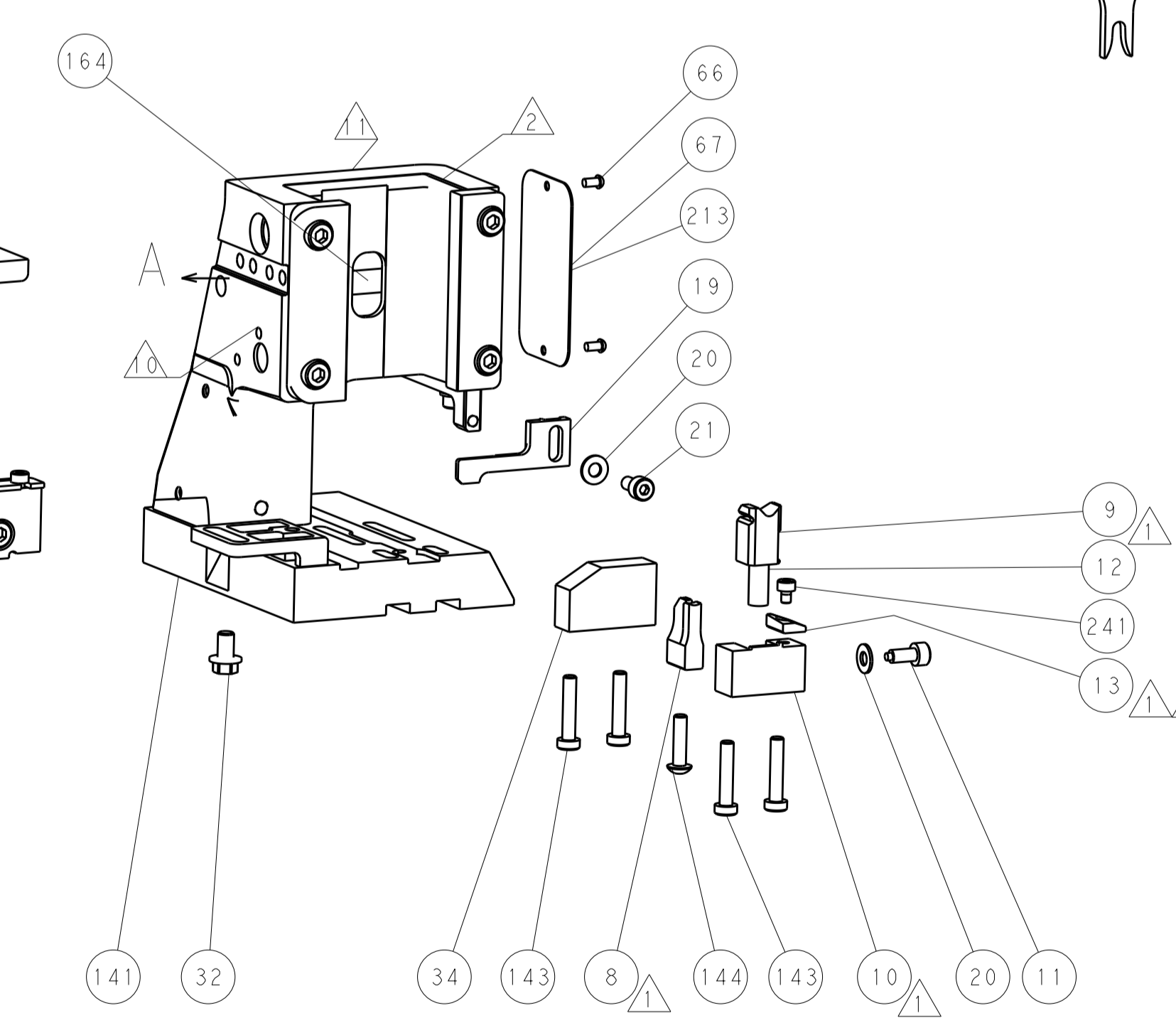
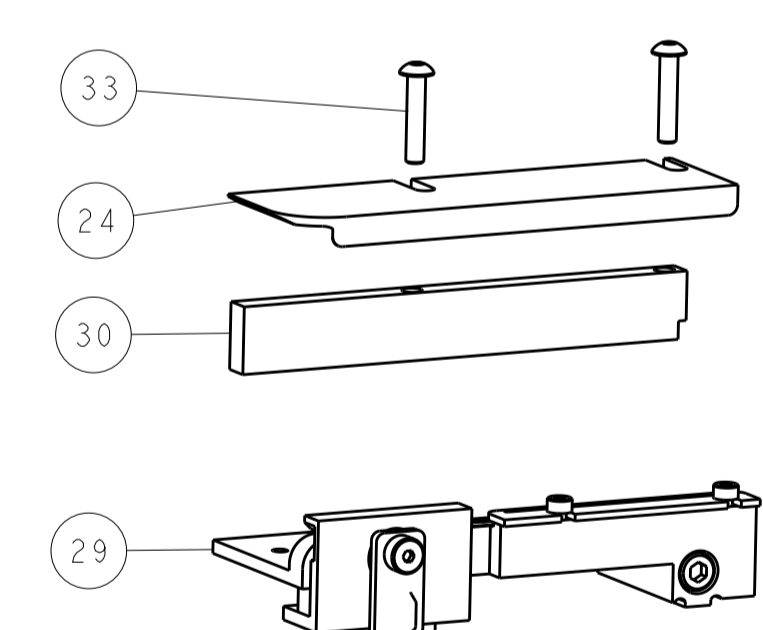
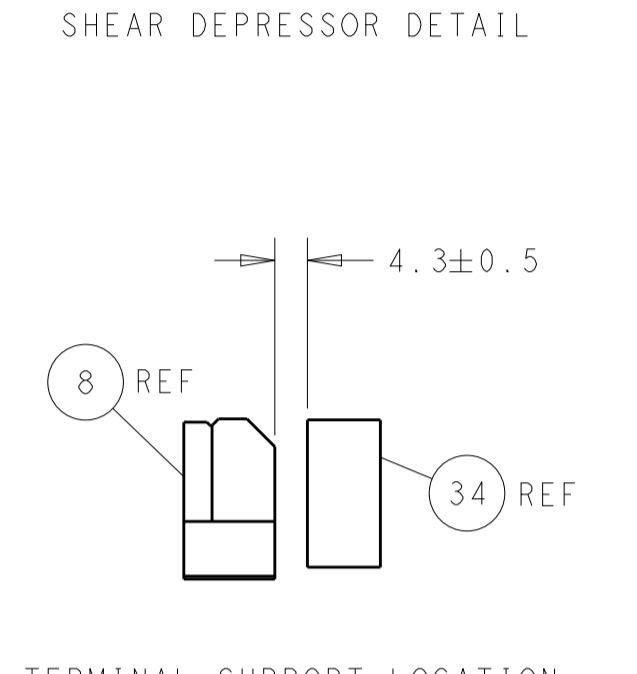
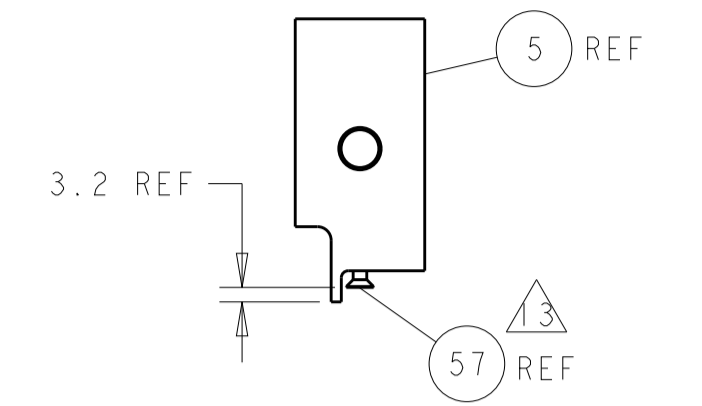
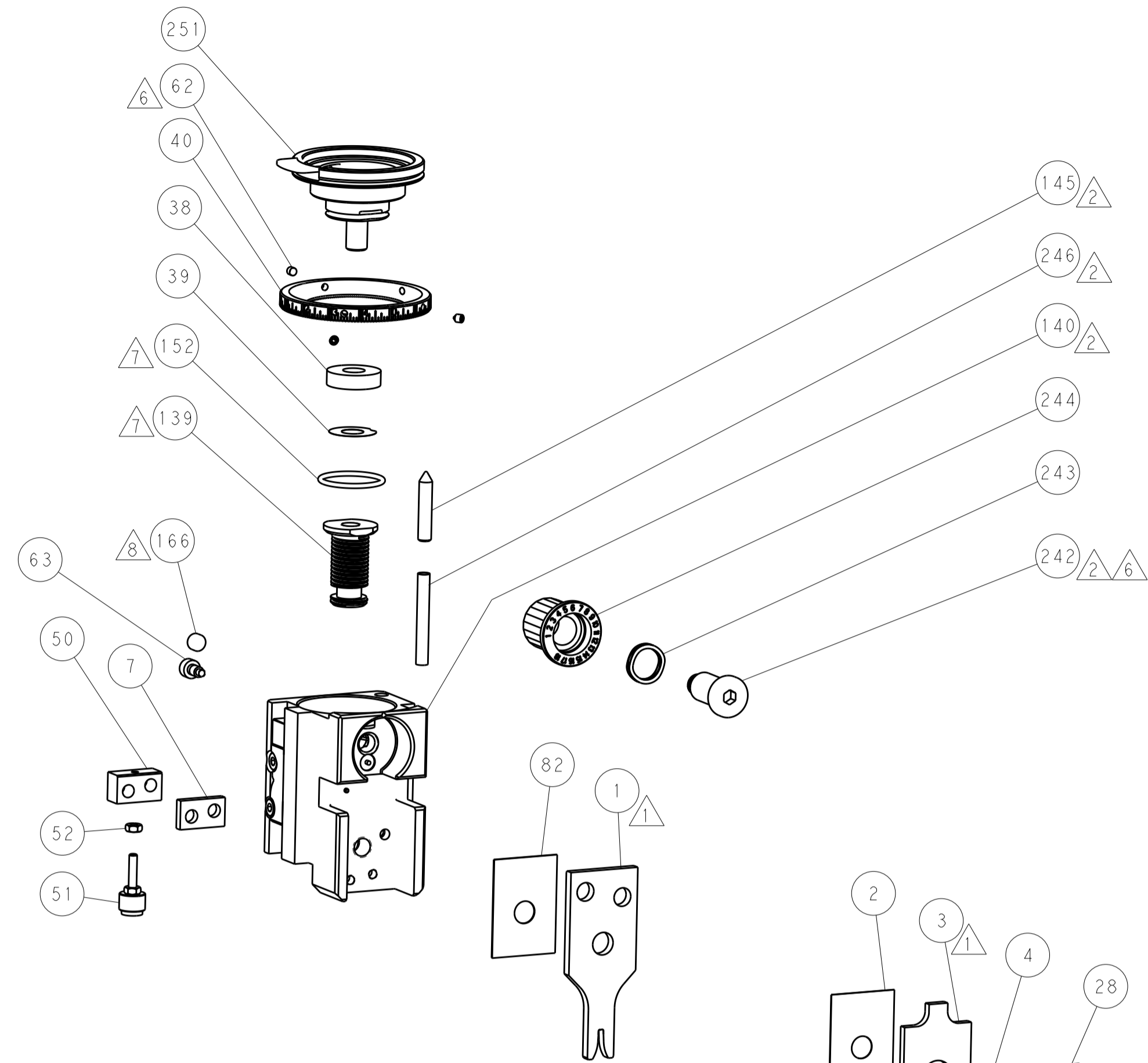
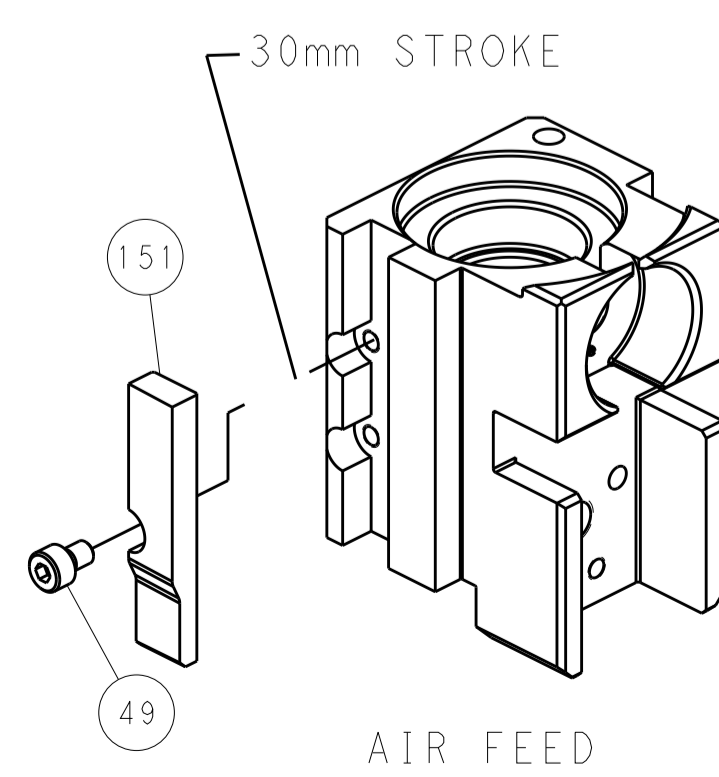
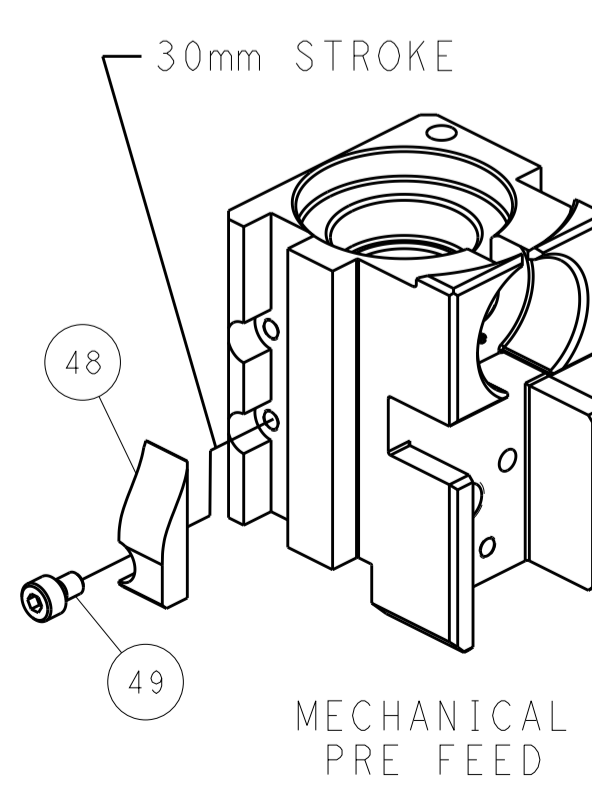
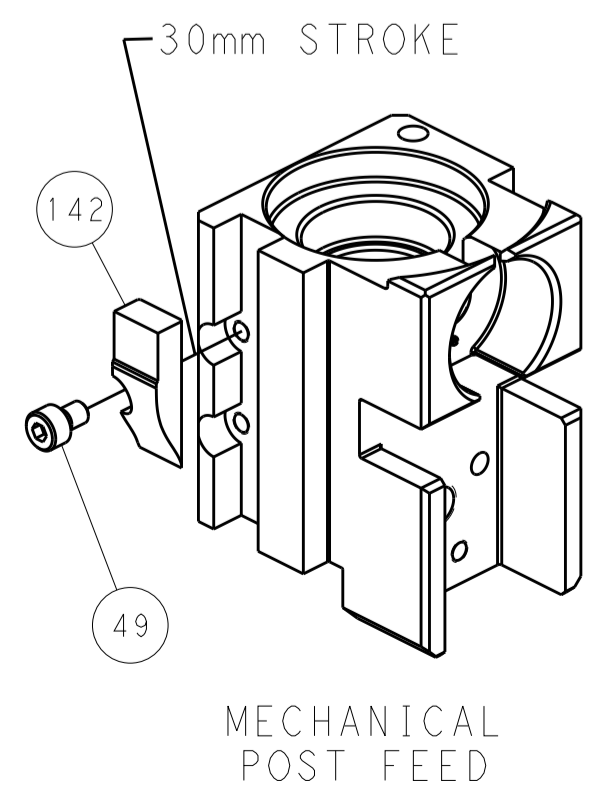
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



**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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LOC	DIST	REVISIONS										
A	66	P. LTR	DESCRIPTION							DATE	DWN	APVD
		-	SEE SHEET 1							-	-	-
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH										
MATERIAL:		DWN HOFFNER 2MAR2015 CHK T. ELBIN 3MAR2015 APVD T. ELBIN 3MAR2015			NAME Ocean Side Feed Applicator			SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2266700				
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2		SHEET 4 OF 4		REV A1		CUSTOMER ACCESSIBLE PRODUCTION DRAWING				