

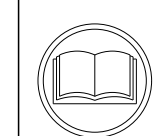
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2266815-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2266815-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2266815-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>
	2266815-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>
	2266815-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2266815-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.58 mm [.141]	F
INSUL	5.05 mm [.199]	F

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION			
TERMINAL NAME: TAXI TERMINAL FEMALE M/P/280			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.80-5.56 mm [.189-.219 IN]		Ø3.49-5.24 mm [.137-.206 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)12015858 PAGE 7 OF 31 Rev 10-29-13	-	
	(B)12129425 PAGE 7 OF 27 Rev 10-30-13	-	
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
(A) 1949181-1	(A) 12015858	(B) 1949022-1	(B) 12129425

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG OR 5.00mm2	2.35+/-0.05 [.093+/- .002]	3.9
12 AWG OR 3.00mm2	2.15+/-0.05 [.085+/- .002]	5.1



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266815-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266815-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266815-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266815-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> 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.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.45.

\*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.

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	1	1	1	1	1803078-3	SPACER, PRECISION	259
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

REVISED	DATE	BY	APP'D	REASON
1	09JUN2015	GH	TE	ORIGINAL
A	30JUL2015	GH	GB	RELEASED

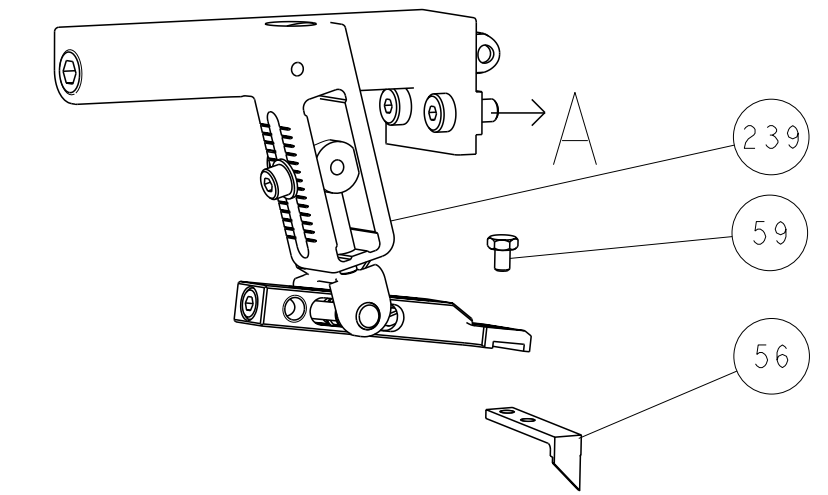
#	QTY	DESCRIPTION	DATE	OWN	APP'D
-	1	O-RING, .676 ID, .070 DIA, MAT.			252
-	-	PUSH ROD, AIR FEED			250
-	-	BUSHING, LCH5-12, MISUMI			249
-	-	FEED CAM, AIR FEED			248
-	1	DETENT PIN			247
-	1	SPRING, COMPRESSION			246
-	-	RAM, STEPPED, ATLANTIC, SF, NON-ADJ			245
-	1	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	WASHER, WAVE SPRING, CREST-TO-CREST			243
-	1	RETAINER, INSULATION DIAL			242
-	1	SCR, SKT HD CAP M3 X 4.0			241
-	-	SHCS, LOW HEAD, RoHS, M5 X 16			240
-	-	MECHANICAL FEED ASSEMBLY			239
-	-	AIR FEED MODULE			238
-	-	TAG, IDENTIFICATION			213
-	-	SPACER, FEEDER			198
-	-	RING, RETAIN, EXTERN, 3/16 CRESCENT			172
-	1	MAGNET, RARE EARTH HIGH ENERGY			166
-	REF	COUNTER, MAGNETIC			164
-	-	SPRING, FEED FINGER			163
-	-	PIN, RETAIN, GRVD, 3/16 X .854			137
-	-	HOLDER, FEED FINGER, AF			136
-	-	MEMORY CHIP, PROGRAMMED			135
-	-	SERVO FEED LATCH ASM			133
-	-	FEED FINGER ASSEMBLY, SF			117
-	1	SPACER, CRIMPER			82
-	1	DOCUMENTATION PACKAGE			71
-	2	DEPRESSOR, WIRE			70
-	1	TAG, IDENTIFICATION			67
-	2	SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	1	LIMITER, ADJUSTMENT BOLT			63
-	3	SCR, SET, SOC, CONE POINT, M3 X 4.0			62
-	1	SCR, BHSC, RoHS (M4 X 8)			60
-	-	SCR, HEX HD CAP, M4 X 6.0			59
-	-	PAWL, FEED			56
-	4	SHCS, LOW HEAD, RoHS, M4 X 12			54
-	2	SCR, SKT HD CAP, RoHS, M4 X 10			53
-	1	NUT, HEX, REG, RoHS, M3			52
-	1	BUMPER, HOLD DOWN			51
-	1	SPACER, TONKER			50
-	-	SCR, SKT HD CAP M4 X 6.0			49
-	-	FEED CAM, PRE FEED			48
-	-	FEED CAM, POST FEED			47
-	1	APPLICATOR BASIC ASSEMBLY, SF			46
-	1	RAM, STEPPED, AMP STYLE, SIDE FEED			44
-	1	SCR, BHSC, RoHS (M8 X 40)			41
-	1	DISC, NUMBERED FA WIRE ADJUSTMENT			40
-	1	APPLICATOR SHIM PACK			39
-	1	RAM WASHER, PRECISION			38
-	1	FA HEAD, ATLANTIC STYLE			37
-	1	BOLT, ADJUSTMENT			35
-	1	SUPPORT, TERMINAL			34
-	2	SCR, BHSC, RoHS (M4 X 20)			33
-	1	HEX HEAD, FLANGED, M5 X 8mm LONG			32
-	1	SPACER, STRIP GUIDE			30
-	1	ASSEMBLY, STRIP GUIDE			29
-	1	STRIP GUIDE			24
-	1	SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	2	WASHER, FLAT, REG M4			20
-	1	STRIPPER, SIDE FEED			19
-	1	INSERT, SHEAR			13
-	1	SPRING, COMPRESSION			12
-	1	STOP, SHEAR			11
-	1	SHEAR HOLDER, FRONT			10
-	1	FLOATING SHEAR, FRONT			9
-	1	ANVIL, COMBINATION			8
-	-	-			7
-	-	-			6
-	1	DEPRESSOR, SHEAR			5
-	1	BLOCK, CRIMPER SPACER			4
-	1	CRIMPER, INSULATION F			3
-	1	SPACER, CRIMPER			2
-	1	CRIMPER, WIRE			1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	BY	APP'D	NAME
mm	0 PLC ±.5 1 PLC ±.3 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1	09JUNE2015	HOFFNER	T. ELBIN	T. ELBIN
		10JUNE2015			
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SHEET:	REV:
			1:2	1 OF 4	A

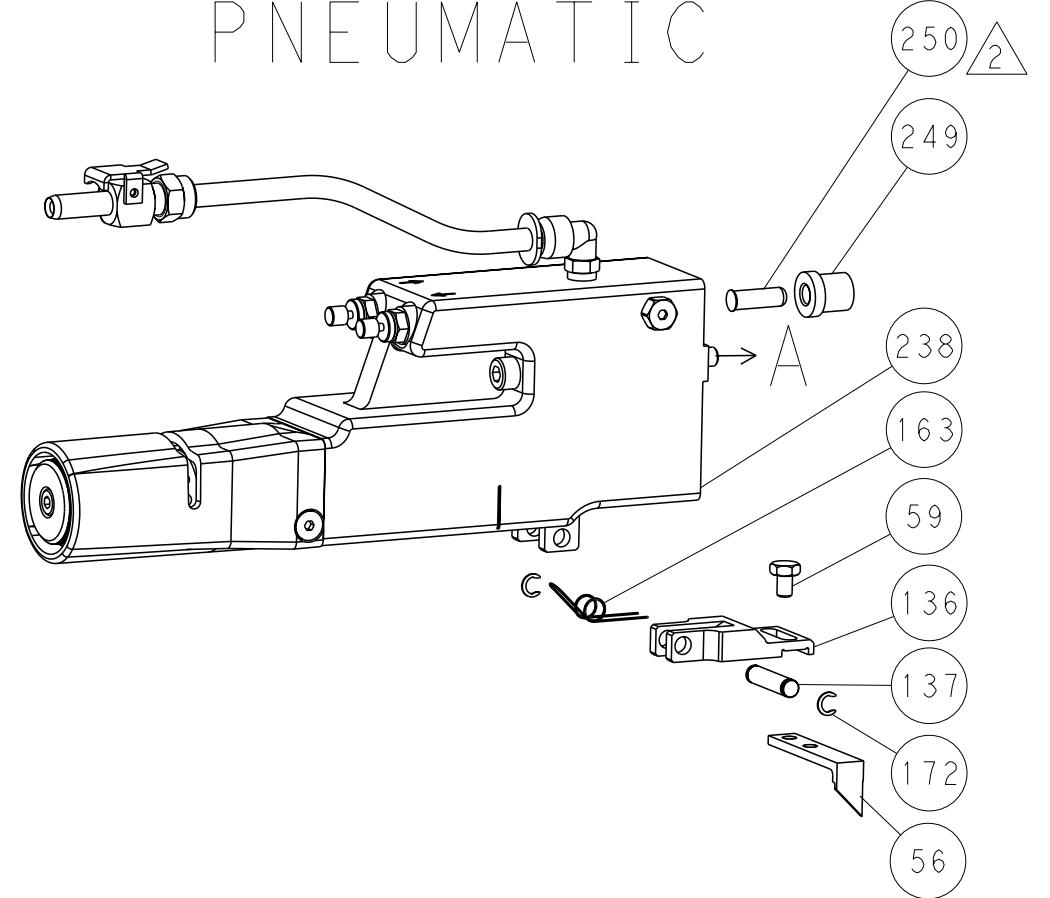
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

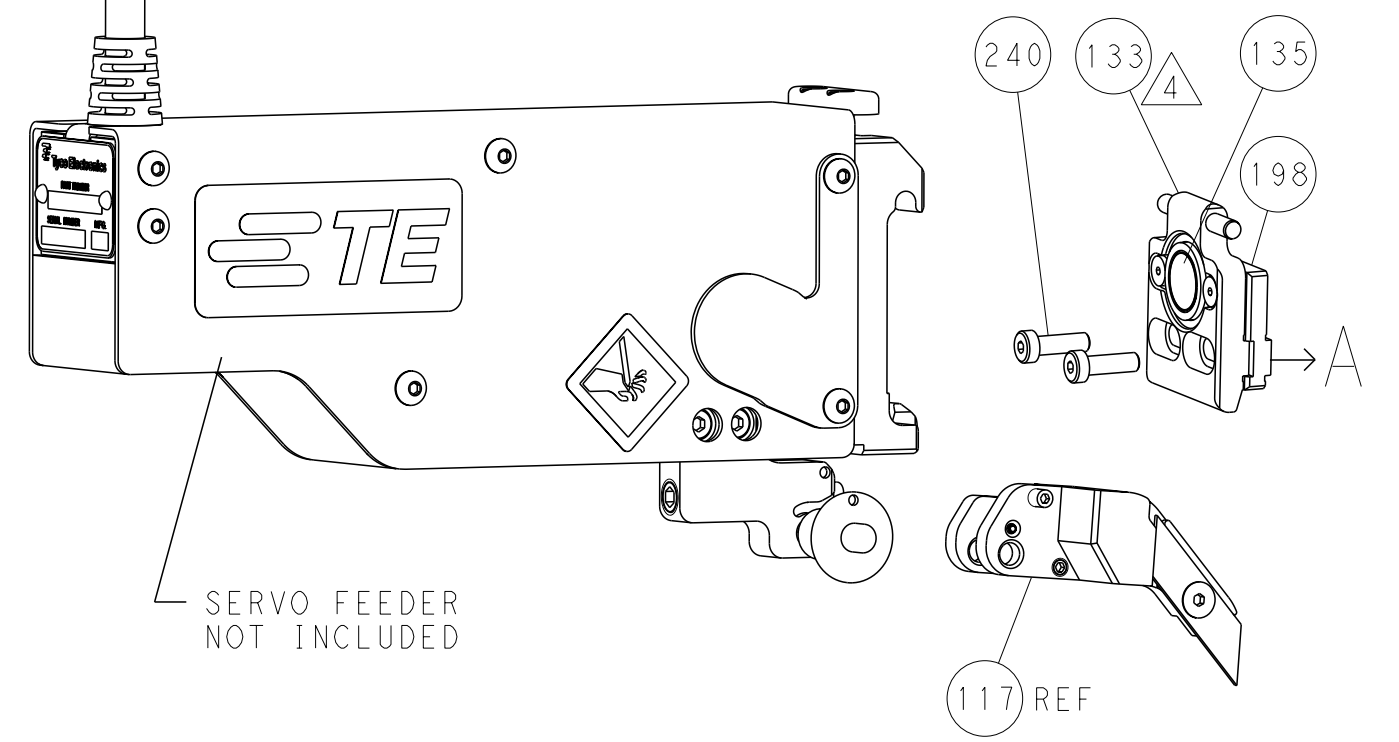
### FEED TYPE MECHANICAL



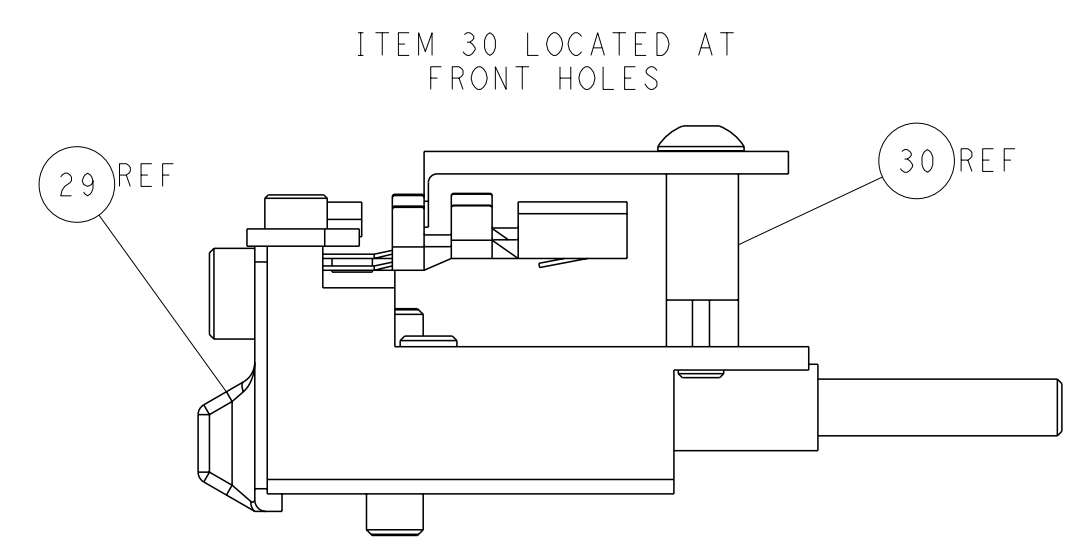
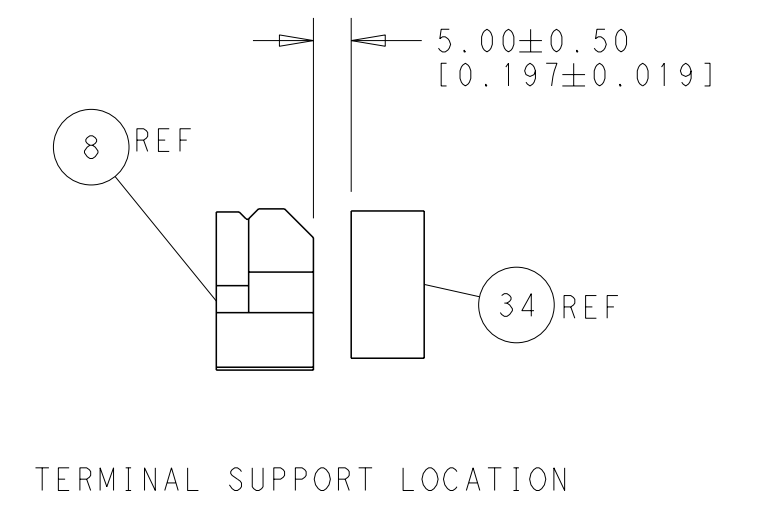
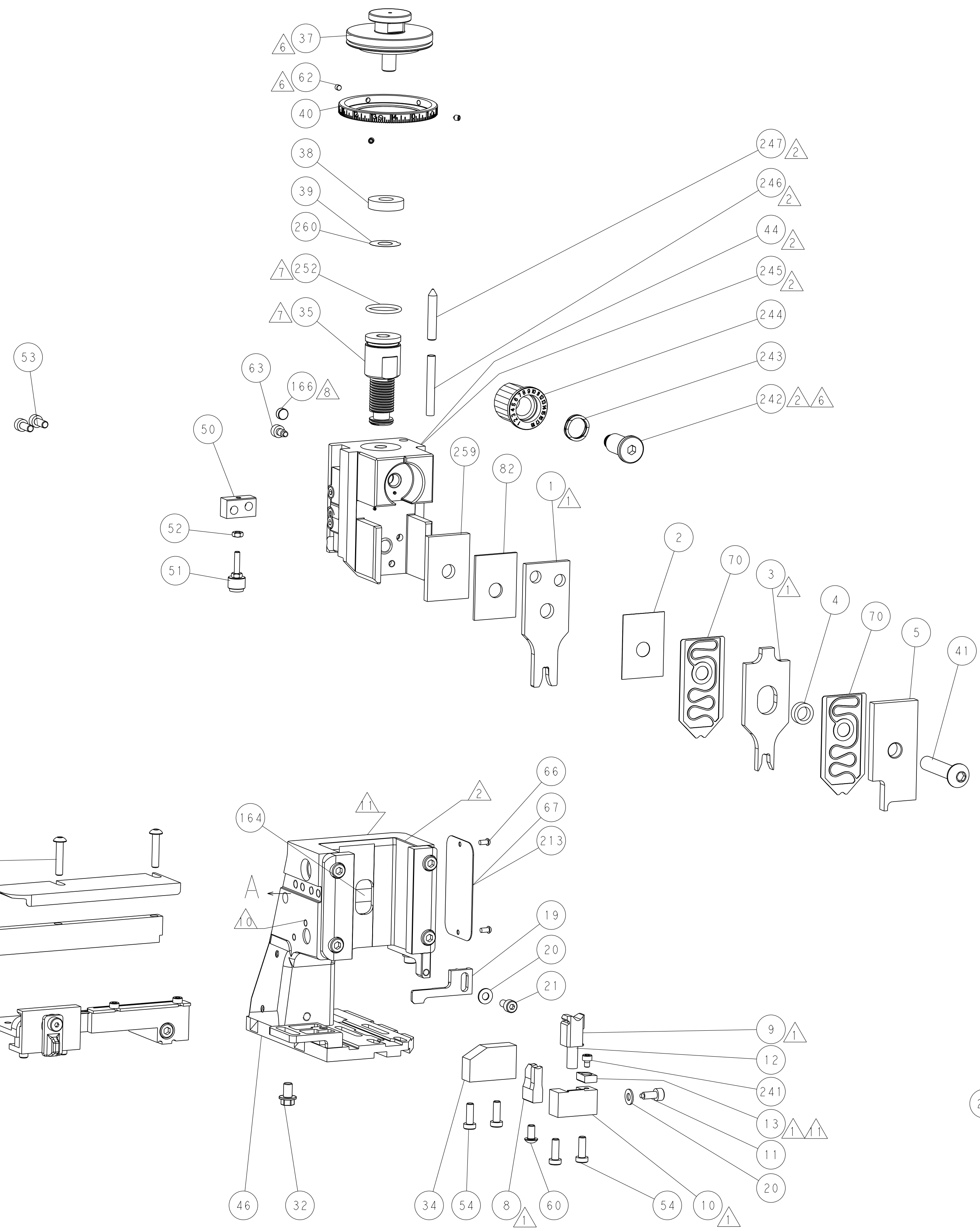
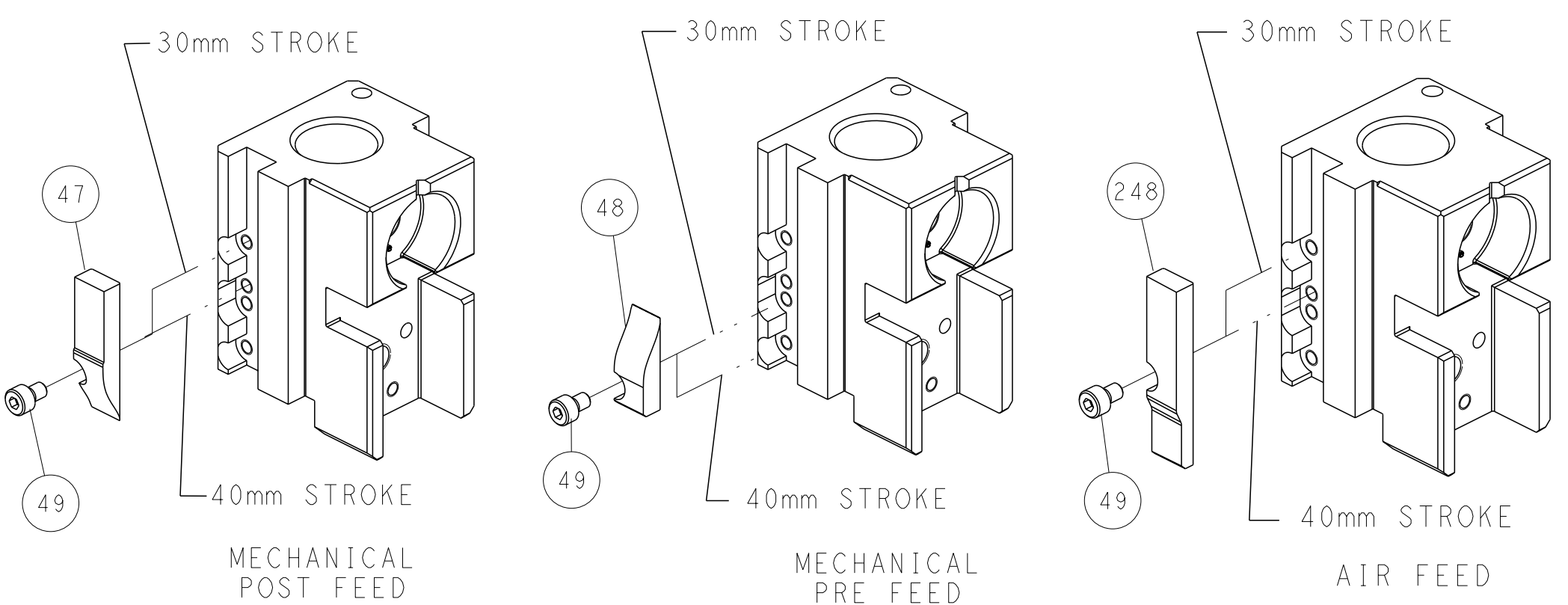
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



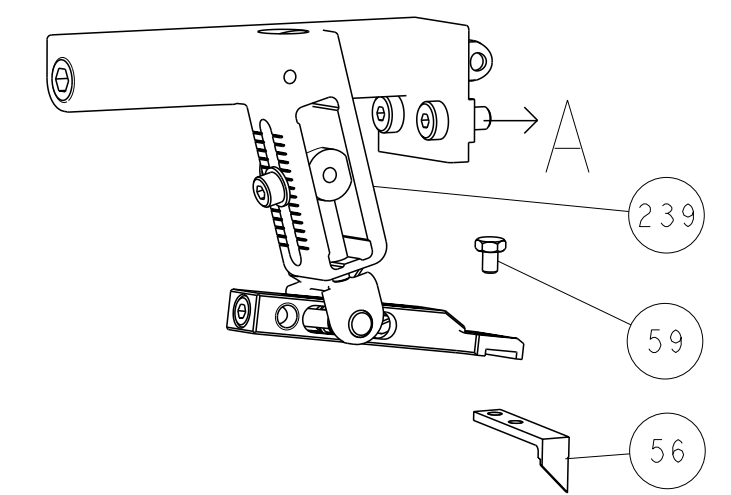
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: HOFFNER 09JUNE2015 CBY: T.ELBIN 10JUNE2015 APVD: T.ELBIN 10JUNE2015	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2266815	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: A
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±0.0001	MATERIAL: - FINISH: -	WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608	

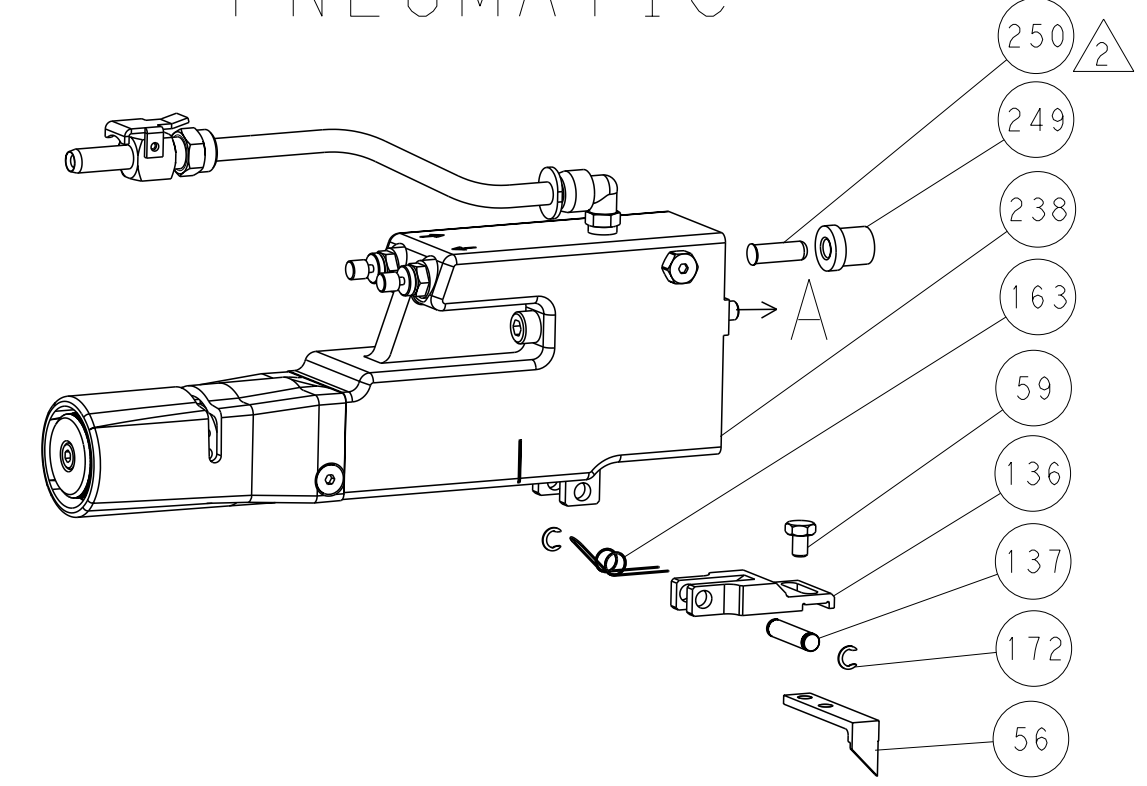


REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LYR			
		DESCRIPTION		
		SEE SHEET 1		

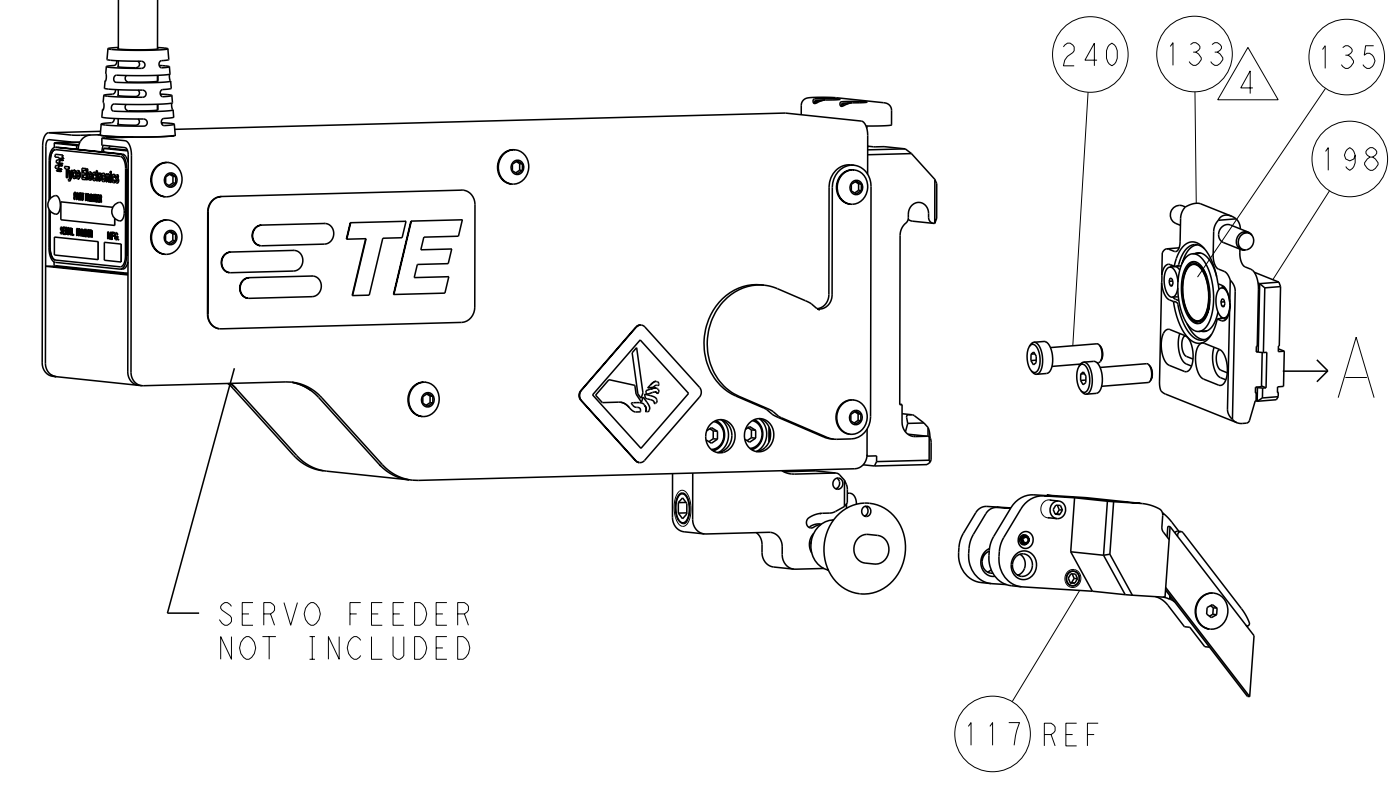
# FEED TYPE MECHANICAL



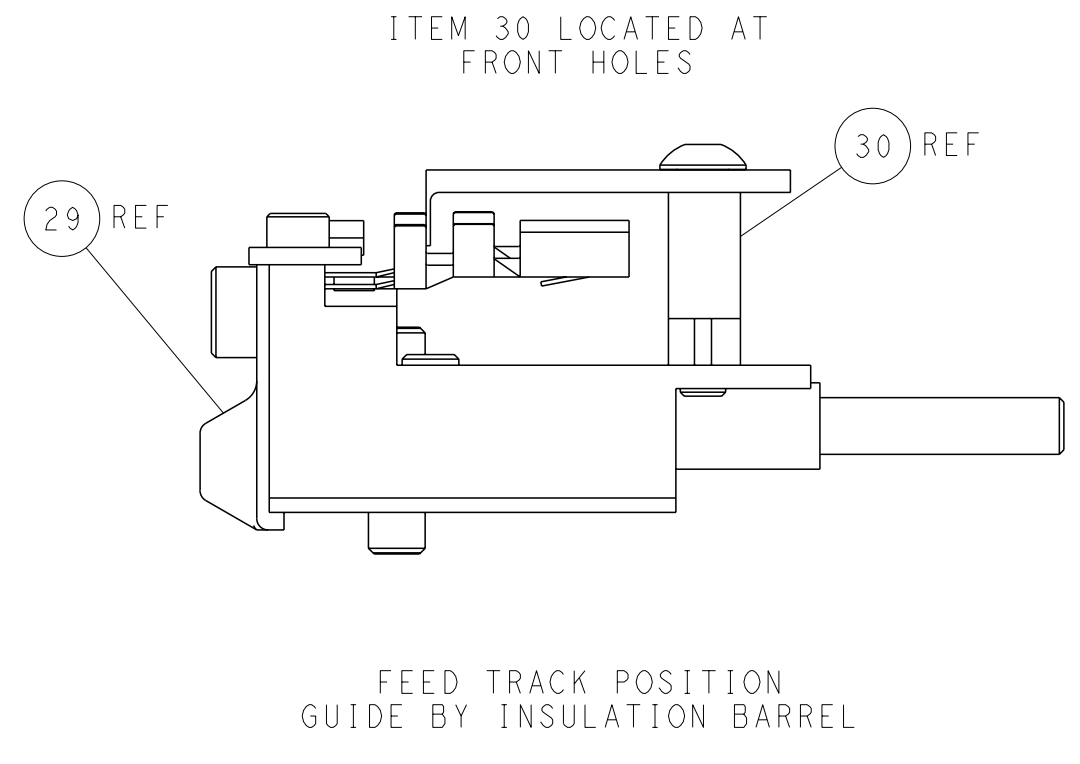
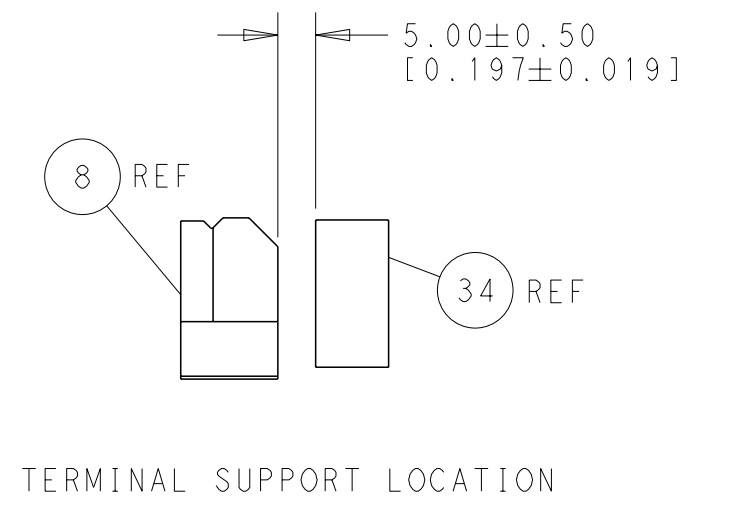
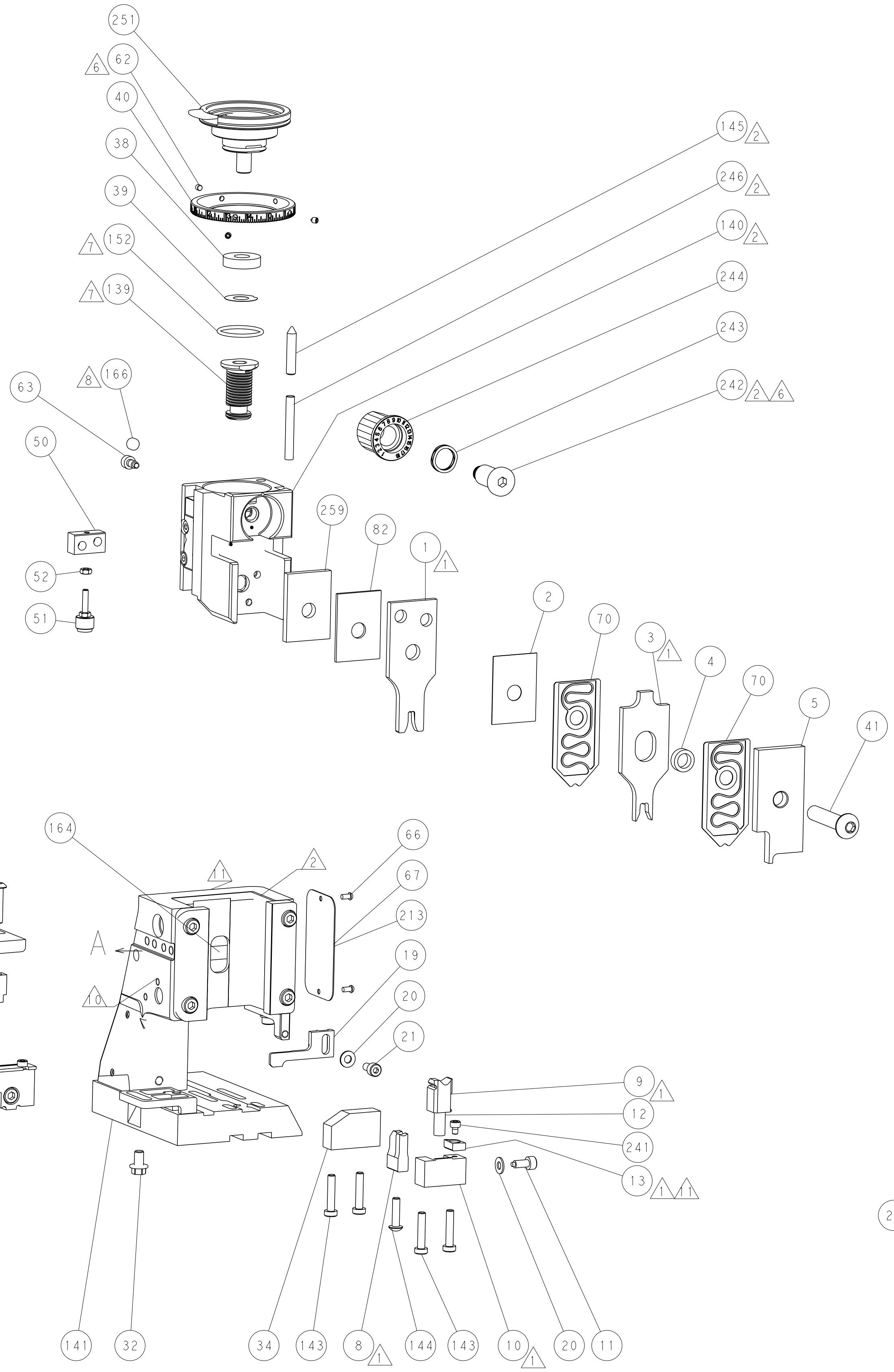
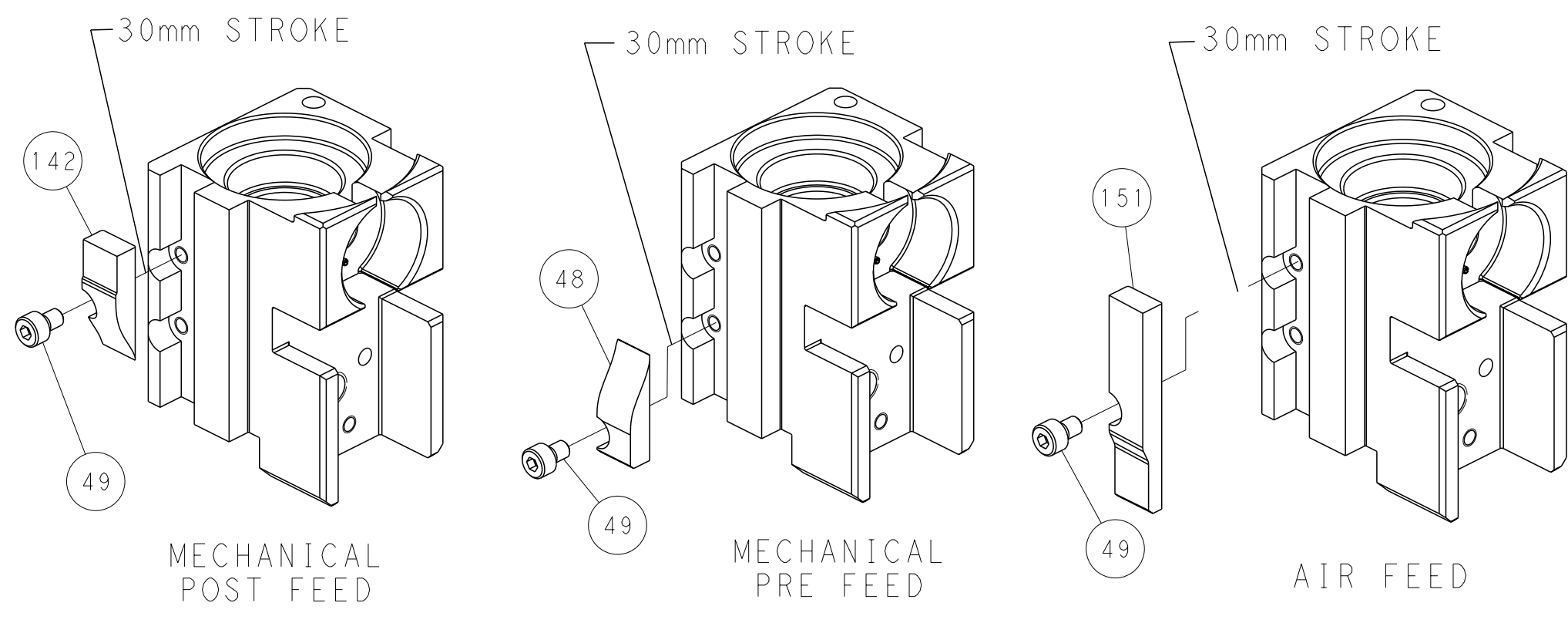
# PNEUMATIC



# 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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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH: *	MATERIAL: - FINISH: -	WEIGHT: - APPLICATION SPEC: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608	