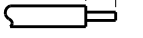


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266258-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2266258-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2266258-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2266258-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2266258-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2266258-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266258-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.39 mm [.094]	F
INSUL	4.09 mm [1.61]	O
APPLICATOR INSTRUCTIONS 408-35042		

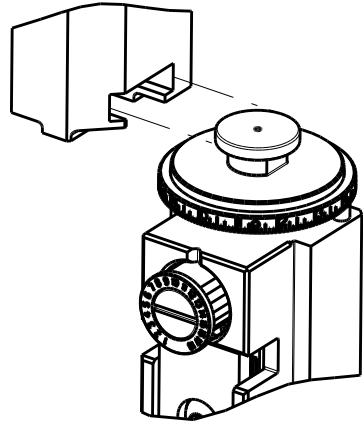
TERMINAL DATA: DELPHI TERMINAL					DELPHI CRIMP SPECIFICATION				
TERMINAL NAME: 150 MALE TERM									
WIRE STRIP LENGTH					TERMINAL INSULATION DIAMETER RANGE				
5.16-5.94 mm [.203-.234 IN]					Ø1.69-2.78 mm [.067-.109 IN]				
TERMINAL APPLICATION SPECIFICATION			DELPHI			-	-	-	-
-			-						
TERMINALS APPLIED									
TE TERMINAL		DELPHI TERMINAL			TE SEAL		DELPHI SEAL		SEAL INSULATION DIAMETER RANGE
2113458-1		12045773			1572277-2		15324974		1.2-1.7 mm
2113458-2		SCNK757473.040.01			1572194-3		12052924		2.0-2.9 mm
2113458-5		12177150			1949406-1		15324976		1.6-2.2 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.50+/-0.05 [.059+/- .002]	4.7
1.00mm2	1.35+/-0.05 [.053+/- .002]	6.2
0.75mm2	1.30+/-0.05 [.051+/- .002]	6.7
0.50mm2	1.25+/-0.05 [.049+/- .002]	7.3



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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 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.
- 7 DELPHI SPECIFICATION 12045773 CRIMP INFORMATION SHEET PAGE 40 OF 53 APPLIES TO 1.50mm2, 1.00mm2 & 0.75mm2. DELPHI SPECIFICATION 12045773 CRIMP INFORMATION SHEET PAGE 35 OF 53 APPLIES TO 0.50mm2.
- 8 DELPHI SPECIFICATION 12177150 CRIMP INFORMATION SHEET PAGE 1 OF 14 APPLIES TO 1.00mm2,0.80mm2,0.50mm2.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.40+/-0.05 [.055+/- .002]	5.7
0.80mm2	1.30+/-0.05 [.051+/- .002]	6.7
0.50mm2	1.25+/-0.05 [.049+/- .002]	7.3

*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.

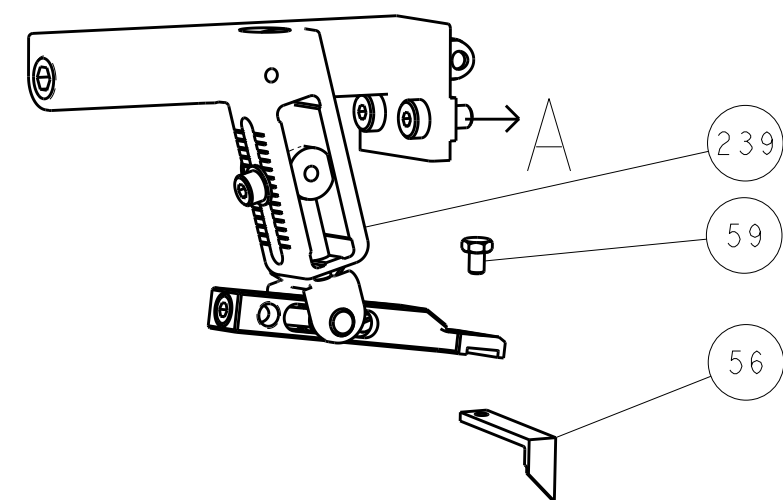
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
			D1	ECR-18-016408	16OCT2018	MZ	KZ	
			E	ECR-19-000525	11JAN2019	JAH	TE	
			F	ECR-19-003243	28FEB2019	JAH	GB	
			F1	ECR-19-012135	01AUG2019	FZ	TE	

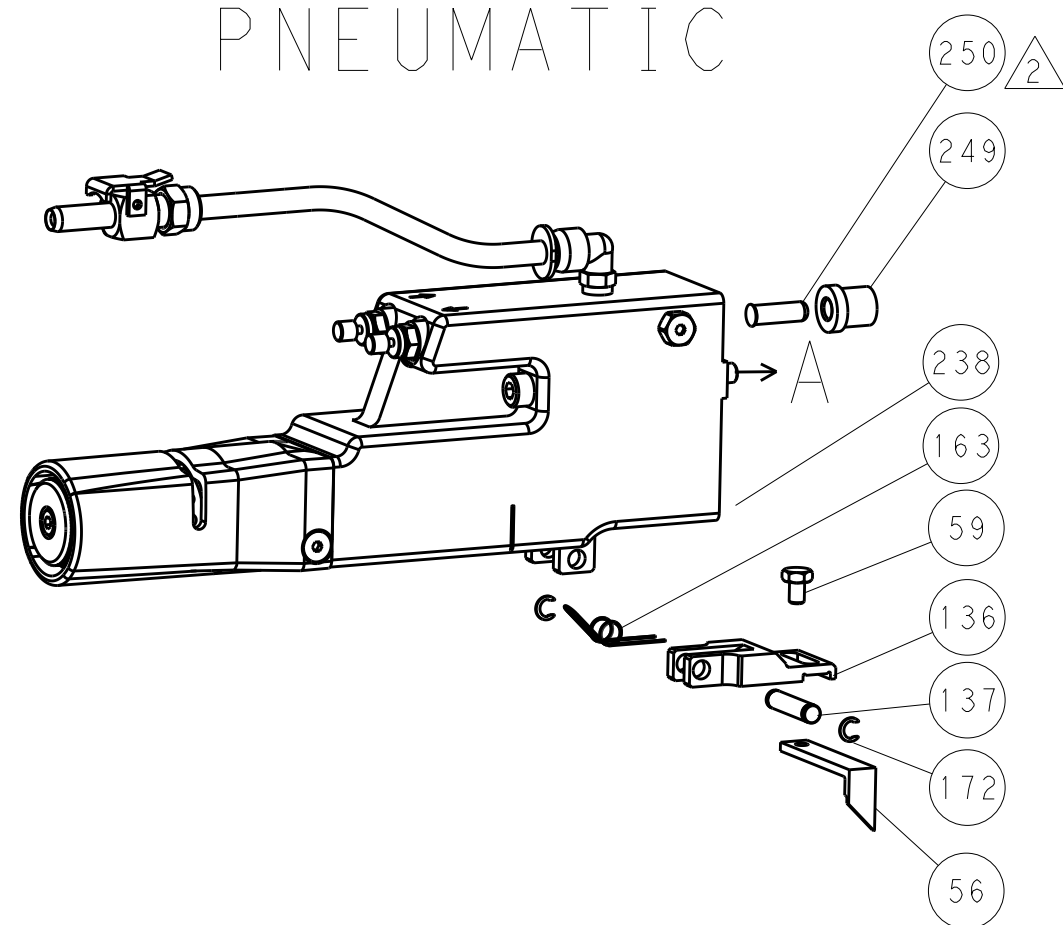
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
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-	1	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
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-	1	1	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
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-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
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-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
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-	1	-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
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-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338683-8	FEED PAWL	56
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-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
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-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
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-	1	1	-	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
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-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	28
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-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
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-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
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-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1	4-1803054-4	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	5-240641-9	SPACER	7
-	-	-	-	-	-	-	-	-	6
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-	1	2	2	1	1	1	3-1803018-6	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	2	1	1	1	1-1633305-7	CRIMPER, WIRE PREMIUM	1

-77 -72 -71 -52 -51 -2 -1						PART NO		DESCRIPTION				ITEM NO
THIS DRAWING IS A CONTROLLED DOCUMENT FOR VECO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. 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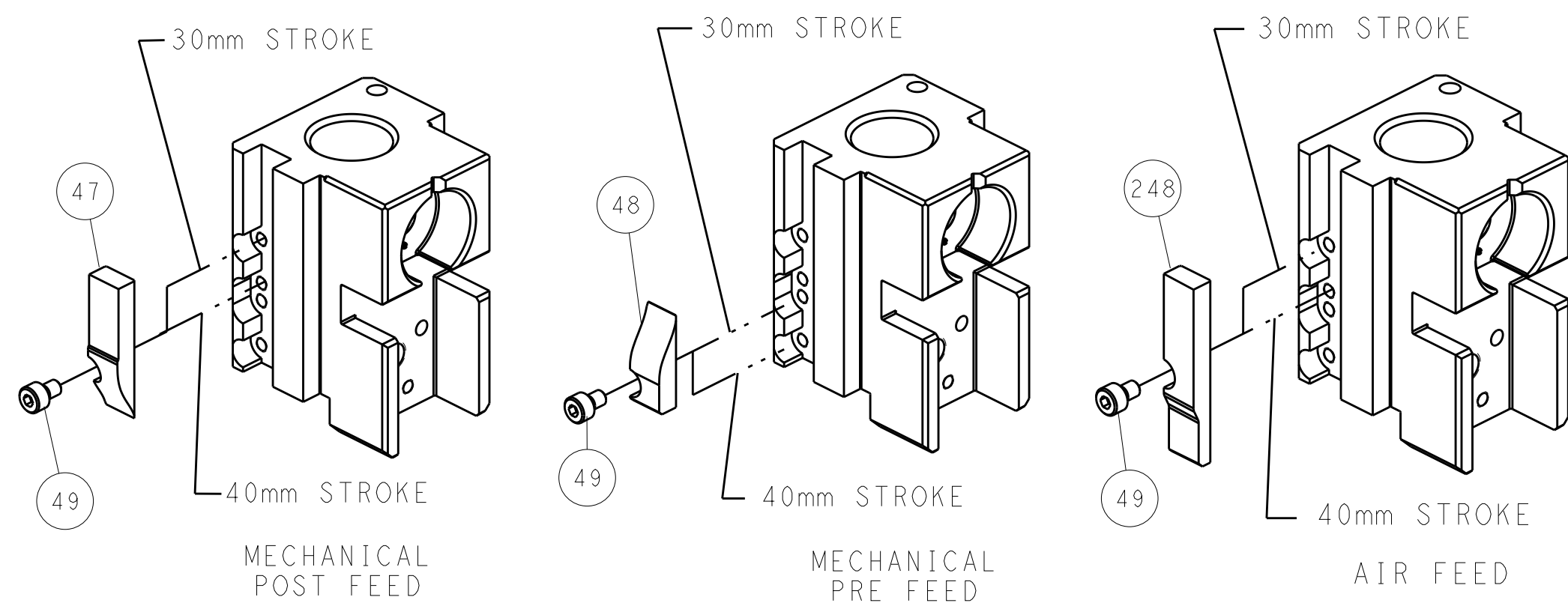
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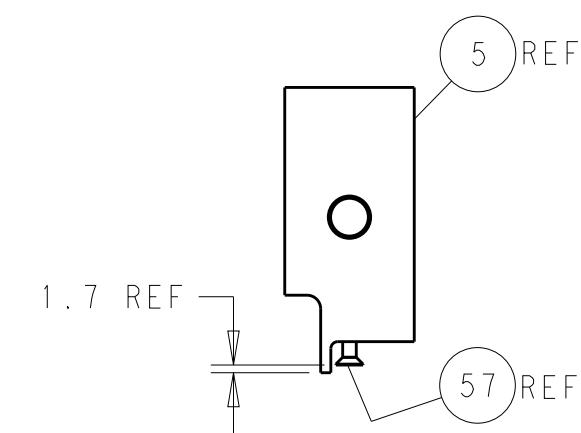


CAM POSITIONS

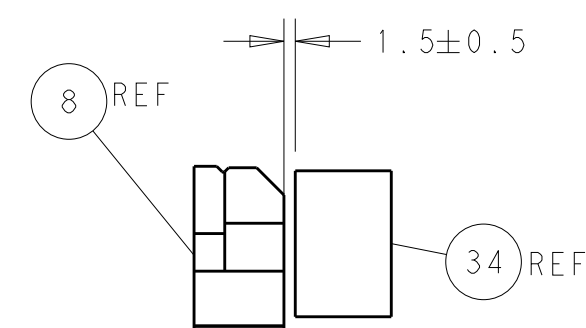


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

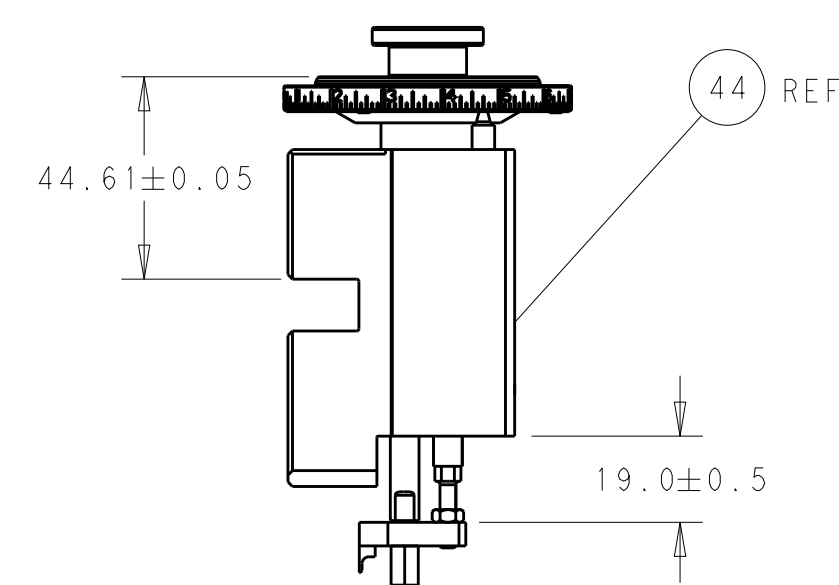
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
				-	-	SEE SHEET 1	-	-	-



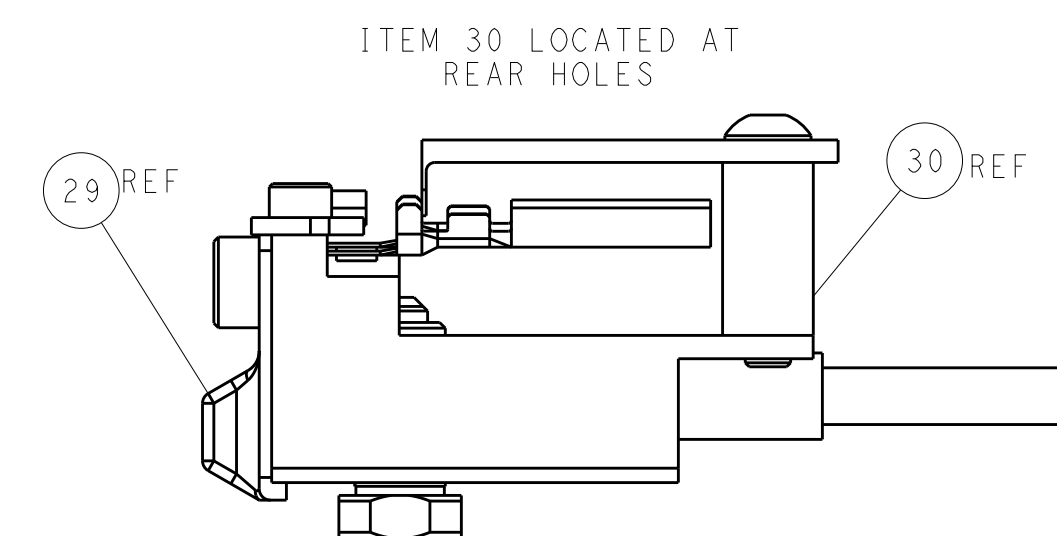
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		RESTRICTED TO	
0 PLC		±		SIZE	
1 PLC		±		CAGE CODE	
2 PLC		±		DRAWING NO	
3 PLC		±		00779	
4 PLC		±		C=2266258	
ANGLES		±		Customer Accessible Production Drawing	
FINISH		-		SCALE 1:2	
MATERIAL		-		SHEET 2 OF 4	
				REV F1	

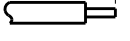
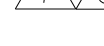
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266258-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266258-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266258-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.39 mm [.094]	F
INSUL	4.09 mm [.161]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL		DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: 150 MALE TERM			
WIRE STRIP LENGTH			TERMINAL INSULATION DIAMETER RANGE
5.16-5.94 mm [.203-.234 IN]			Ø1.69-2.78 mm [.067-.109 IN]
TERMINAL APPLICATION SPECIFICATION		DELPHI	
			
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL
2113458-1	12045773	1572277-2	15324974
2113458-2	SCNK757473.040.01	1572194-3	12052924
2113458-5	12177150	1949406-1	15324976

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.50+/-0.05 [.059+/- .002]	4.7
1.00mm2	1.35+/-0.05 [.053+/- .002]	6.2
0.75mm2	1.30+/-0.05 [.051+/- .002]	6.7
0.50mm2	1.25+/-0.05 [.049+/- .002]	7.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.40+/-0.05 [.055+/- .002]	5.7
0.80mm2	1.30+/-0.05 [.051+/- .002]	6.7
0.50mm2	1.25+/-0.05 [.049+/- .002]	7.3

-
- 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 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.

DELPHI SPECIFICATION CRIMP INFORMATION SHEET PAGE 40 OF 53 APPLIES TO 1.50mm2, 1.00mm2 & 0.75mm2.
DELPHI SPECIFICATION CRIMP INFORMATION SHEET PAGE 35 OF 53 APPLIES TO 0.50mm2.

DELPHI SPECIFICATION 12177150 CRIMP INFORMATION SHEET PAGE 1 OF 14 APPLIES TO 1.00mm2,0.80mm2,0.50mm2.

*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	REVISIONS			
		P	LTR	DESCRIPTION	DATE
A	66	-	-	SEE SHEET 1	-

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338683-8	FEED PAWL	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-6	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	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	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1320928-6	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	4-1803054-4	ANVIL, COMBINATION	8
-	1	1	5-240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	3-1803018-6	CRIMPER, INSULATION O	3
-	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1-1633305-7	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS:		CHK L.ZHANG	01APR2014	NAME	
mm		APVD T.FILBIN	01APR2014	Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE	
0 PLC ±		APPLICATION SPEC		CAGE CODE	
1 PLC ±		WEIGHT		DRAWING NO	
2 PLC ±		FINISH		00779	
3 PLC ±		MATERIAL		©=2266258	
4 PLC ±		Customer Accessible Production Drawing		SCALE	
ANGLES		1:2		SHEET 3 OF 4	
REV		F1		REV	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

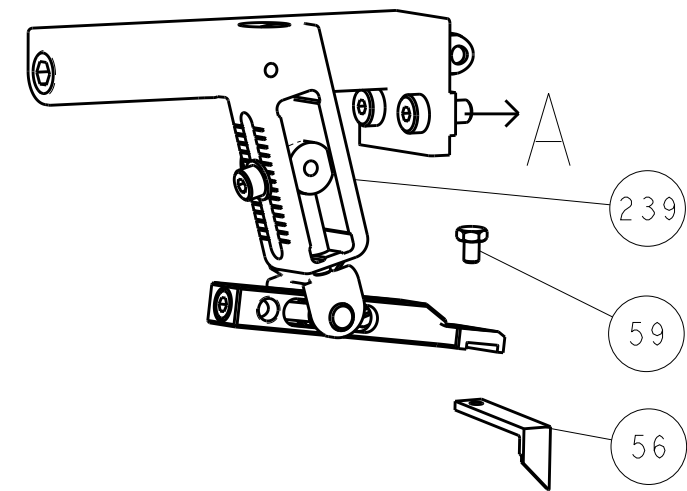
D

C

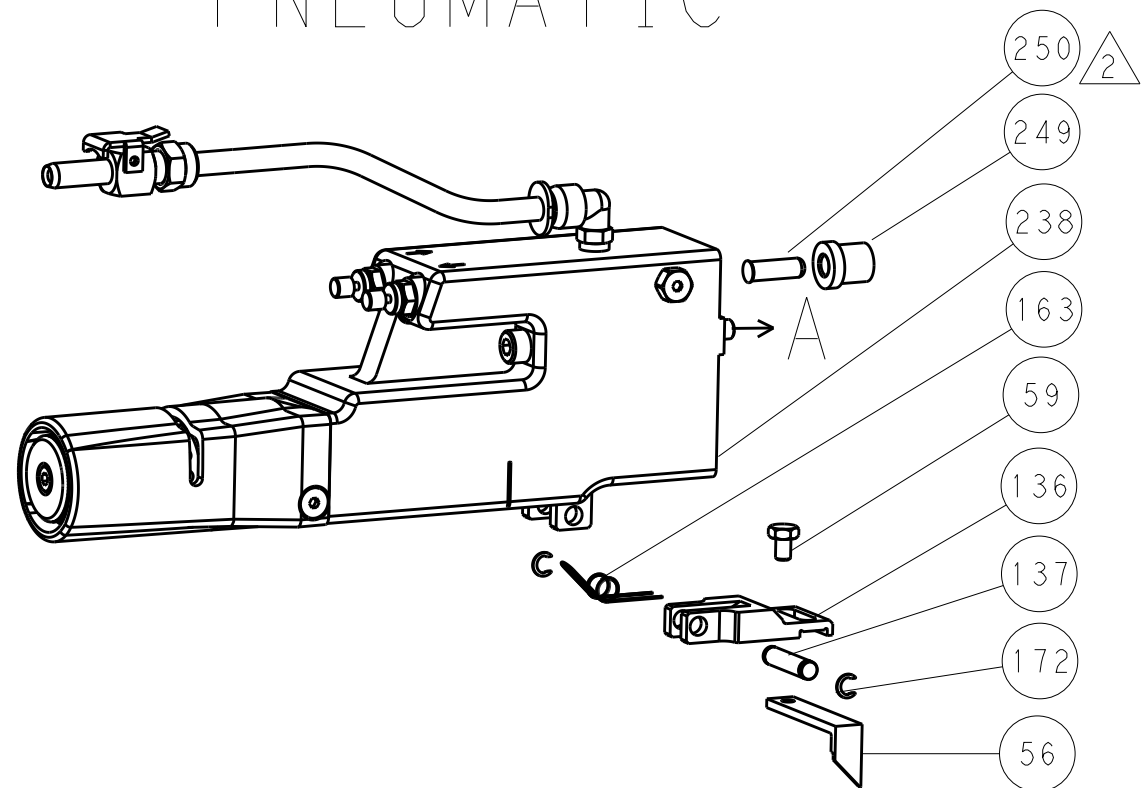
B

A

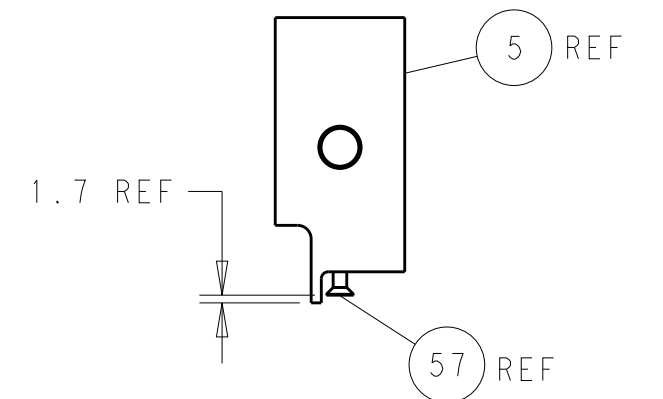
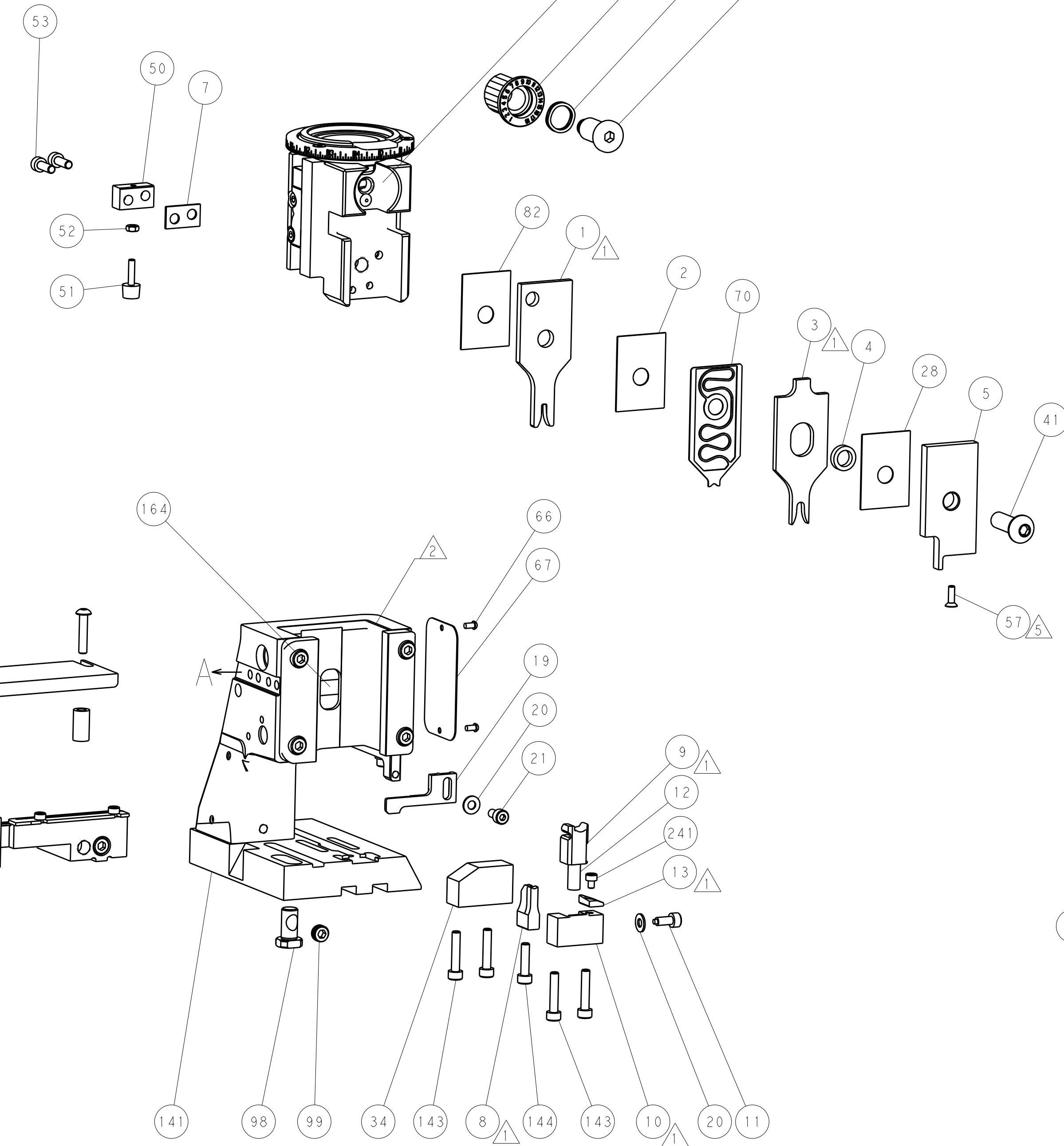
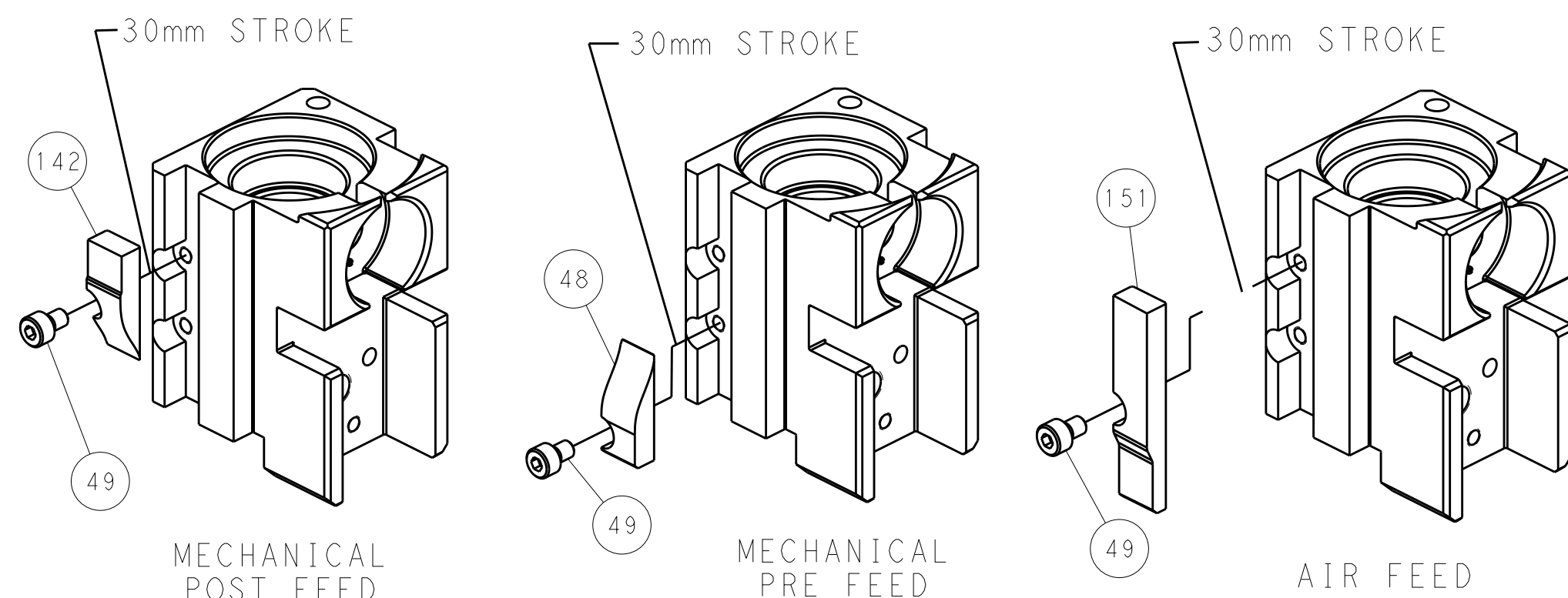
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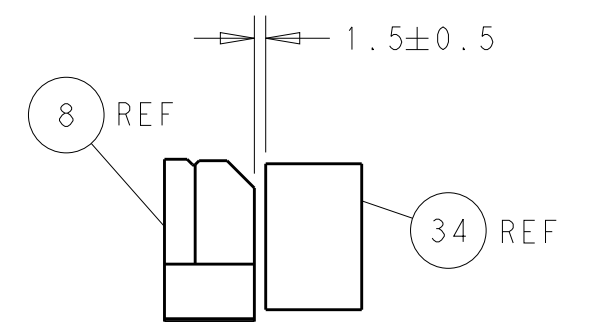
PNEUMATIC



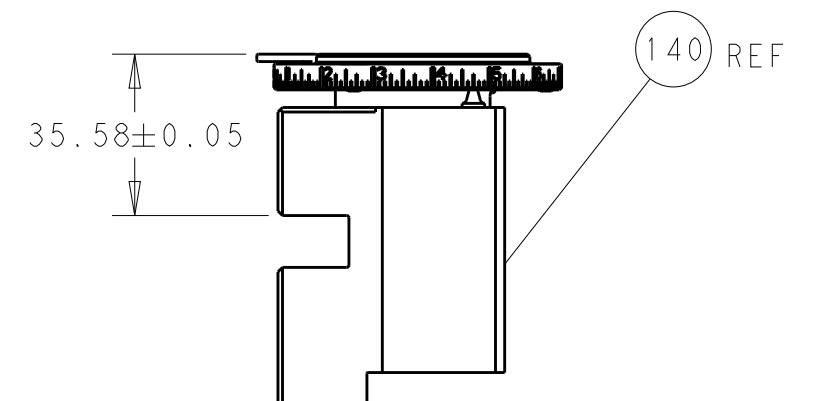
CAM POSITIONS



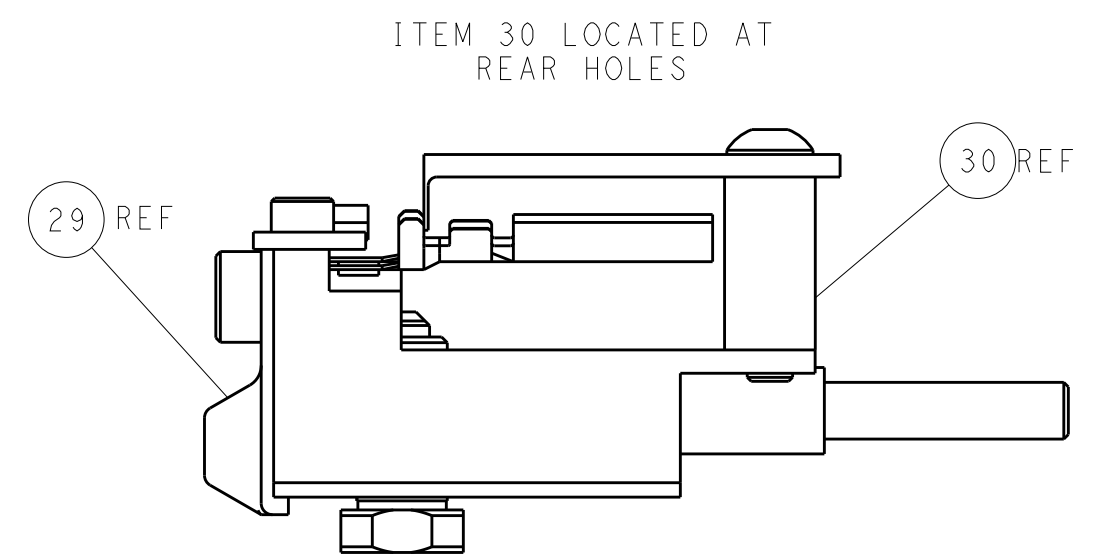
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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		CHK L. ZHANG 01APR2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T. ELBIN 01APR2014	SIZE CAGE CODE DRAWING NO	
0 PLC ±.00		PRODUCT SPEC	RESTRICTED TO	
1 PLC ±.00		APPLICATION SPEC	A1 00779 C=2266258	
2 PLC ±.00		WEIGHT	Customer Accessible Production Drawing	
3 PLC ±.00		SCALE	1:2	
4 PLC ±.00		REVISIONS	SHEET 4 OF 4	
ANGLES		REV	F1	
FINISH				

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