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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2266475-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266475-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266475-4	-	-	-
	2266475-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266475-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266475-4	-	-	-
	2266475-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
				PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
					-	-	-	-	-	-	-
2266475-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	-	-	-	-	-	-	-
				SMART APPLICATOR	-	-	-	-	-	-	-
2266475-7	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	NONE	-	-	-	-	-	-	-
				CRIMP TOOLING KIT	-	-	-	-	-	-	-
					-	-	-	-	-	-	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	0.84 mm [.033]	F
INSUL	0.84 mm [.033]	F

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: JAE TERMINAL JAE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH 1.50-1.90 mm [.059-.075 IN] INSULATION DIAMETER RANGE Ø0.50-1.00 mm [.020-.039 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
1949363-1	IL-Z-C3-A-15000	1949363-2	IL-Z-C3-15000

WIRE SIZE

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG	0.58+/-0.02 [.023+/-0.008]	8.9
30 AWG	0.54+/-0.02 [.021+/-0.008]	9.3
32 AWG	0.54+/-0.02 [.021+/-0.008]	9.3

- RECOMMENDED SPARE PARTS
- 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: 8-2266475-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266475-5  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266475-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266475-6
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 5.22.

\*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.

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

LOC A DIST 66

A	RELEASED	DATE	MR	GB
B	ECR-15-009302	19JUN2015	JH	TE

REVISIONS

REV	DATE	DESCRIPTION	MR	GB
1	31DEC2014	O-RING, .676 ID, .070 DIA. MAT.		
2		PUSH ROD, AIR FEED		
3		BUSHING, LCH5-12, MISUMI		
4		FEED CAM, AIR FEED		
5		DETENT PIN		
6		SPRING, COMPRESSION		
7		RAM, AMP STYLE, SIDE FEED, NON-ADJ.		
8		CAM, SNAIL, INSULATION ADJUSTMENT		
9		WASHER, WAVE SPRING, CREST-TO-CREST		
10		RETAINER, INSULATION DIAL		
11		SCR, SKT HD CAP M3 X 4.0		
12		SHCS, LOW HEAD, RoHS, M5 X 16		
13		MECHANICAL FEED ASSEMBLY		
14		AIR FEED MODULE		
15		TAG IDENTIFICATION		
16		SPACER, FEEDER		
17		RING, RETAIN, EXTERN, 3/16 CRESCENT		
18		MAGNET, RARE EARTH HIGH ENERGY		
19		COUNTER, MAGNETIC		
20		SPRING, FEED FINGER		
21		PIN, RETAIN, GRVD, 3/16 X .854		
22		HOLDER, FEED FINGER, AF		
23		MEMORY CHIP, PROGRAMMED		
24		SERVO FEED LATCH ASM		
25		FEED FINGER ASSEMBLY, SF		
26		SPACER, CRIMPER		
27		DOCUMENTATION PACKAGE		
28		DEPRESSOR, WIRE		
29		TAG IDENTIFICATION		
30		SCREW, DRIVE, RH, RoHS, 2 x .188		
31		LIMITER, ADJUSTMENT BOLT		
32		SCR, SET, SOC, CONE POINT, M3 X 4.0		
33		SCR, BHSC, RoHS (M4 X 8)		
34		SCR, HEX HD CAP, M4 X 6.0		
35		PAWL, FEED		
36		SHCS, LOW HEAD, RoHS, M4 X 12		
37		SCR, SKT HD CAP M4 X 6.0		
38		FEED CAM, PRE FEED		
39		FEED CAM, POST FEED		
40		APPLICATOR BASIC ASSEMBLY, SF		
41		RAM, AMP STYLE, SIDE FEED		
42		SCR, BHSC, RoHS (M8 X 25)		
43		DISC, NUMBERED FA WIRE ADJUSTMENT		
44		APPLICATOR SHIM PACK		
45		RAM WASHER, PRECISION		
46		FA HEAD, ATLANTIC STYLE		
47		BOLT, ADJUSTMENT		
48		SUPPORT, TERMINAL		
49		SCR, BHSC, RoHS (M4 X 20)		
50		HEX HEAD, FLANGED, M5 x 8mm LONG		
51		SPACER, STRIP GUIDE		
52		ASSEMBLY, STRIP GUIDE		
53		STRIP GUIDE		
54		SCR, SKT HD CAP, RoHS, M4 X 8.0		
55		WASHER, FLAT, REG M4		
56		STRIPPER, SIDE FEED		
57		INSERT, SHEAR		
58		SPRING, COMPRESSION		
59		STOP, SHEAR		
60		SHEAR HOLDER, FRONT		
61		FLOATING SHEAR, FRONT		
62		ANVIL, COMBINATION		
63		-		
64		-		
65		DEPRESSOR, SHEAR		
66		BLOCK, CRIMPER SPACER		
67		CRIMPER, INSULATION F PREMIUM		
68		SPACER, CRIMPER		
69		CRIMPER, WIRE		
70		-		
71		-		
72		-		
73		-		
74		-		
75		-		
76		-		
77		-		

TE Connectivity  
Harrisburg, PA 17105-3608

Ocean Side Feed Applicator

APPLICATOR DATA

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC	±
1 PLC	±0.5
2 PLC	±0.13
3 PLC	±0.013
4 PLC	±0.0001
ANGLES	±0.0001

Customer Accessible Production Drawing

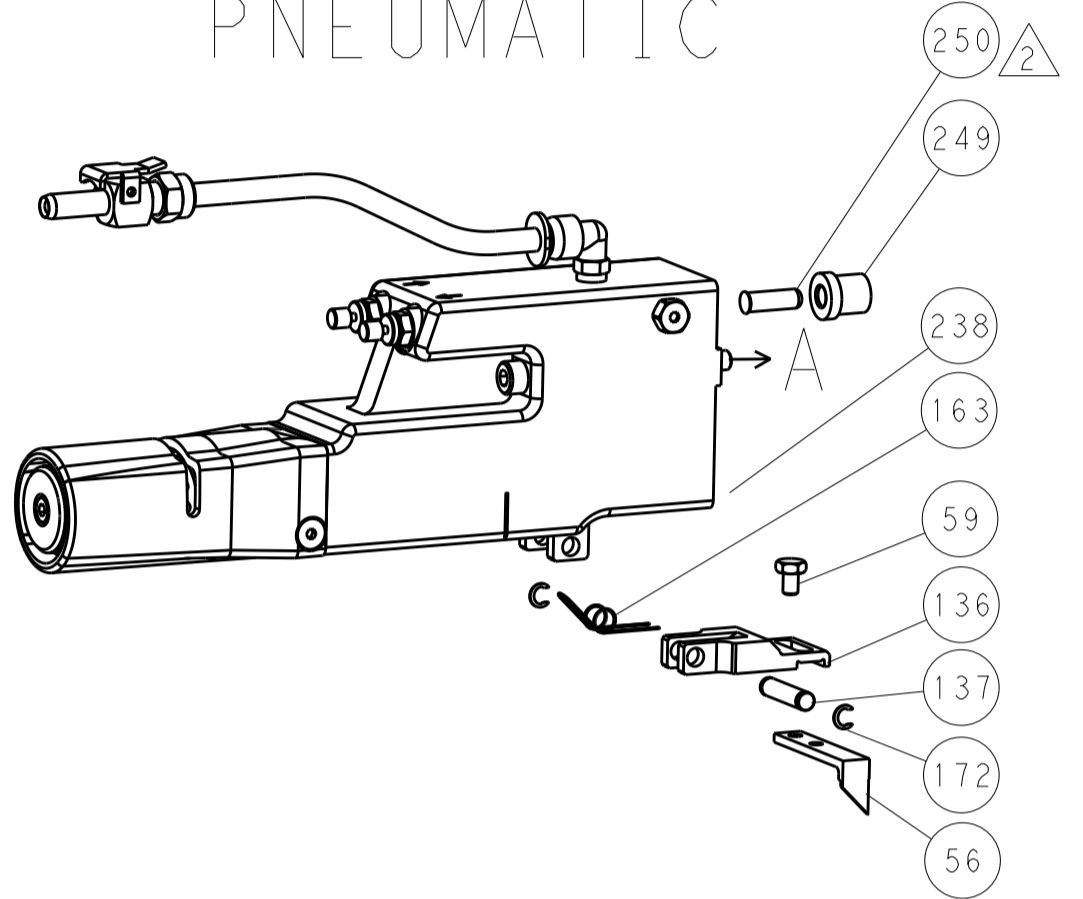
SCALE 1:2 SHEET 1 OF 4 REV B

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

### FEED TYPE MECHANICAL



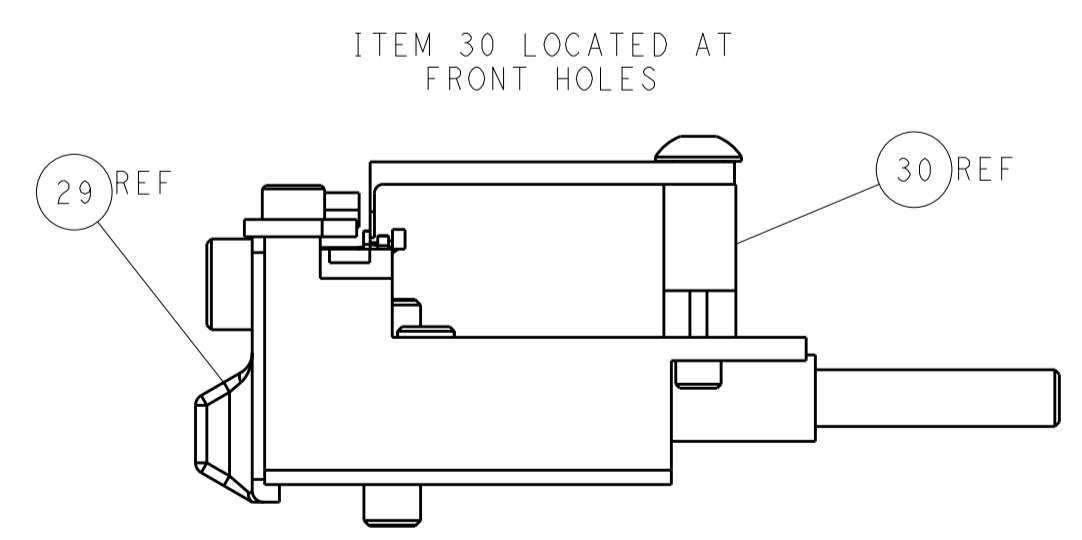
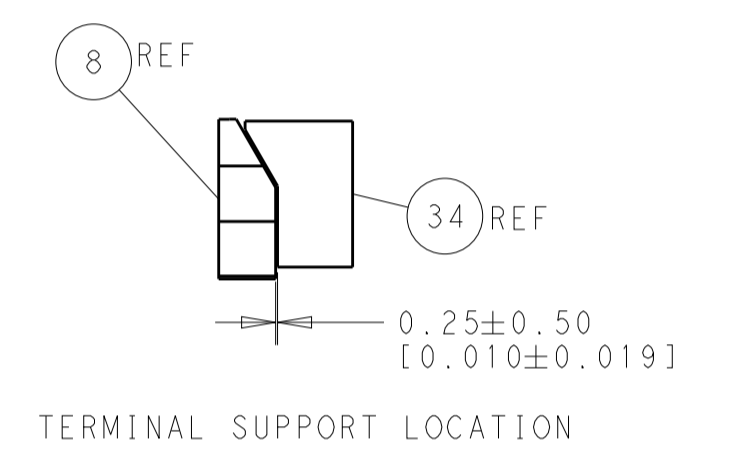
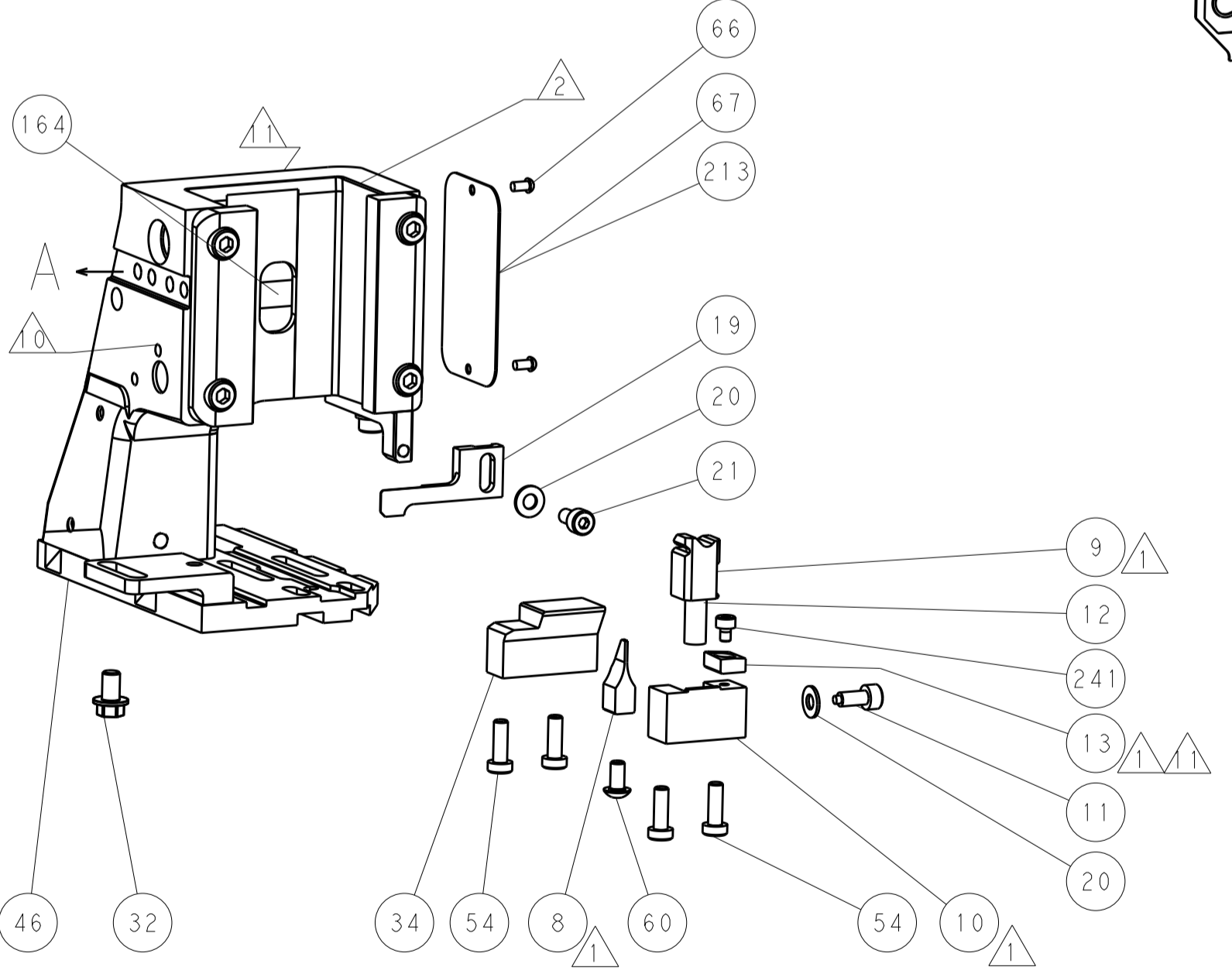
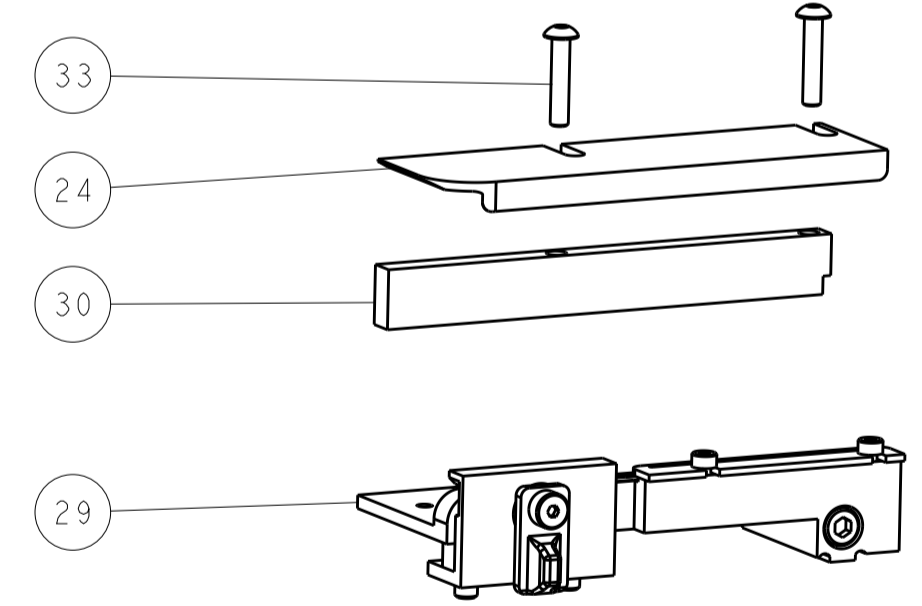
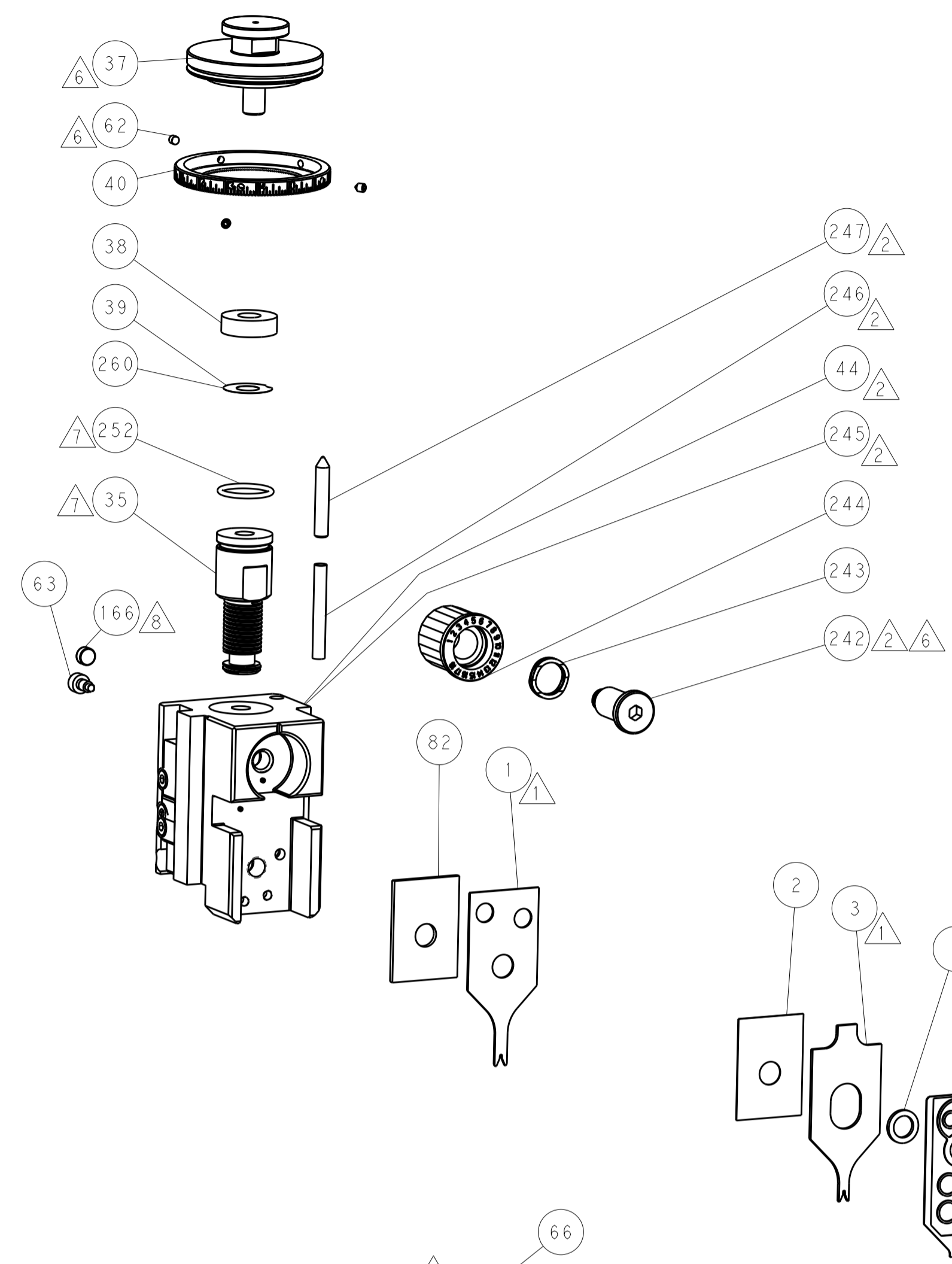
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



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: J.HOU 22AUGUST2014		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0001	APVD: Y.YIN 22AUGUST2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
				SIZE: A1		CAGE CODE: 00779	
				DRAWING NO: 2266475		SCALE: 1:2	
				SHEET: 2 OF 4		REV: B	

REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Row 1: SEE SHEET 1.

APPLICATOR STYLE CONVERSION CHART 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: JAE TERMINAL JAE CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, and TERMINALS APPLIED table.

WIRE SIZE table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP 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.

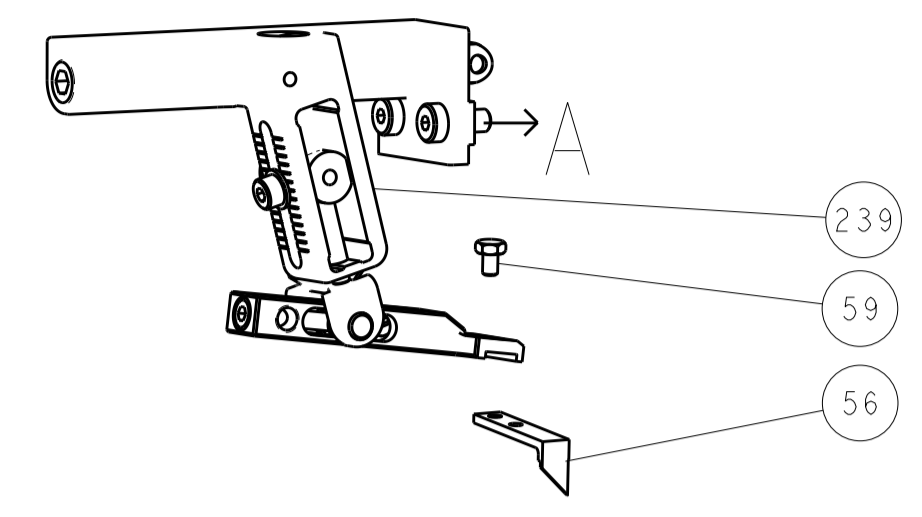
PACIFIC VERSION Shown on sheets 3 of 4 & 4 of 4 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

Large table listing various components with columns: QTY, PART NO, DESCRIPTION, ITEM NO. Includes items like PUSH ROD, AIR FEED, BUSHING, WAVE SPRING, etc.

Technical drawing header and footer information including dimensions, tolerances, dimensions table, and drawing metadata like DWG, CHK, Y, YIN, APVD, DATE, PRODUCT SPEC, APPLICATION SPEC, MATERIAL, FINISH, WEIGHT, SCALE, SHEET 3 OF 4, REV B.

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

# FEED TYPE MECHANICAL



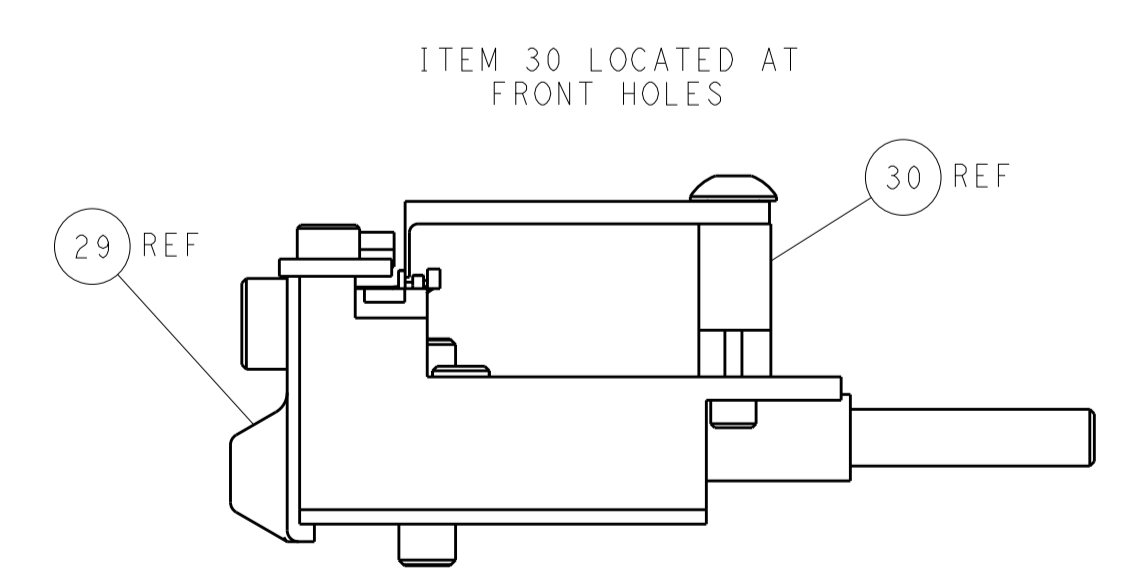
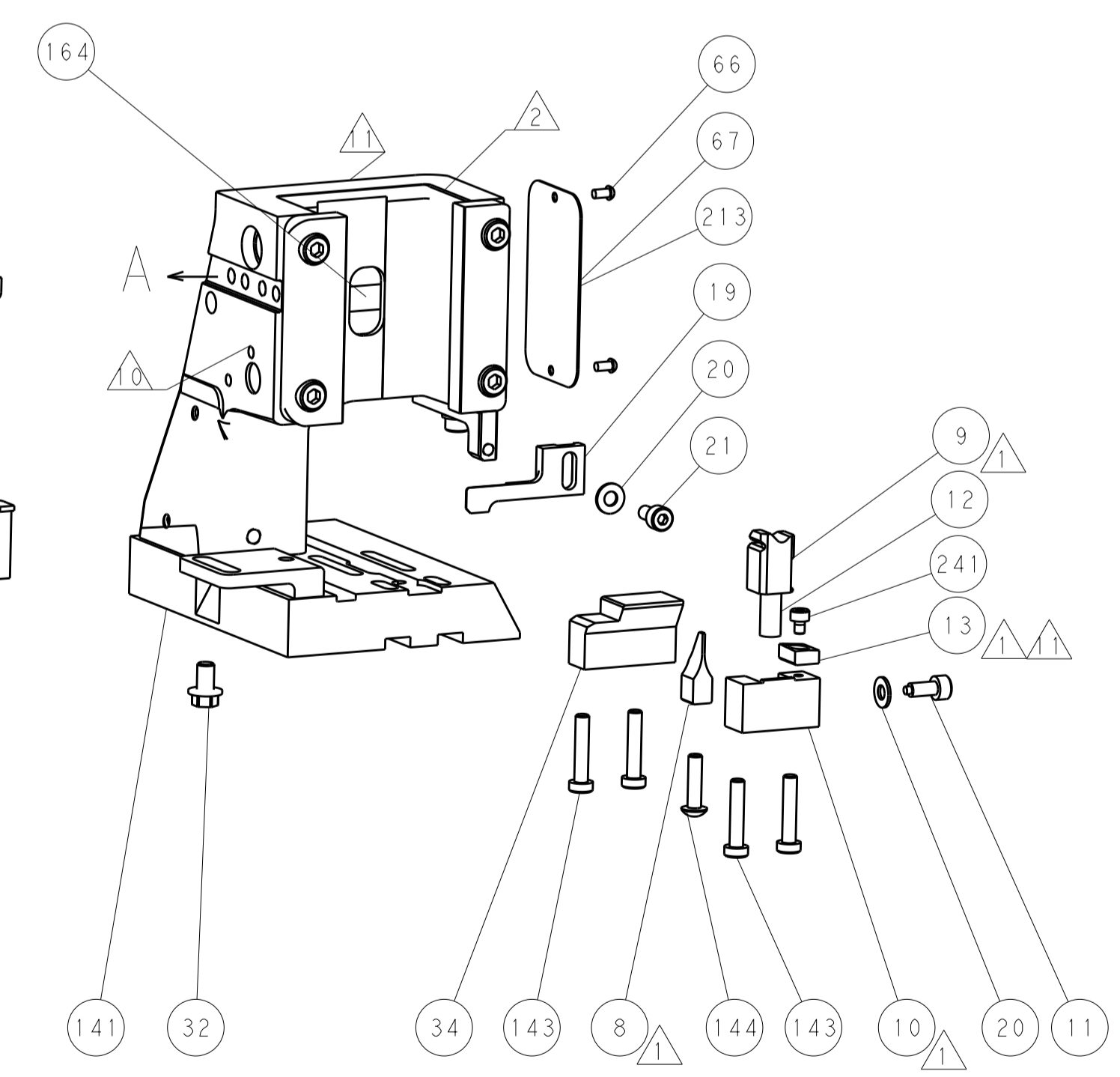
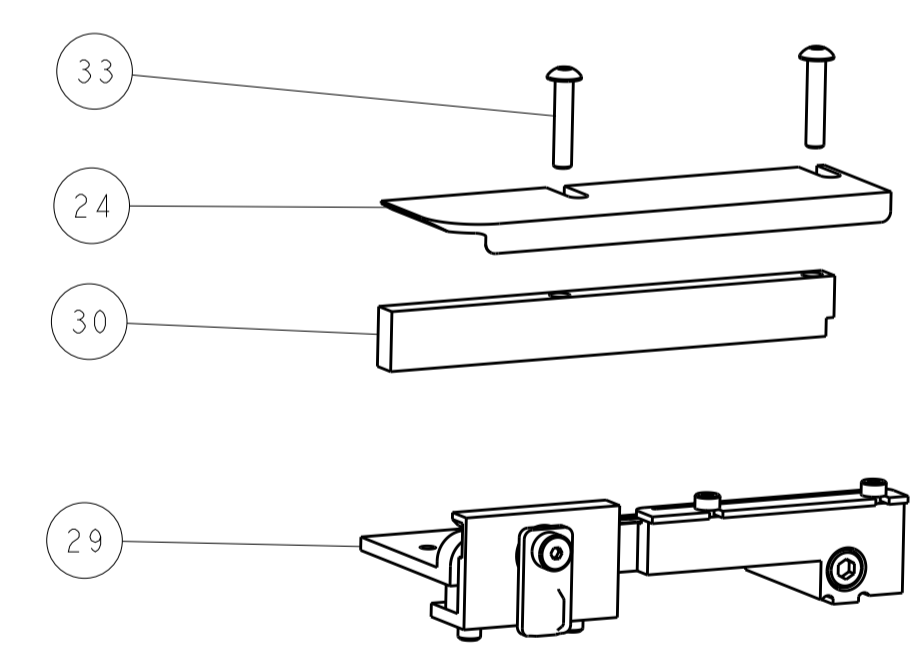
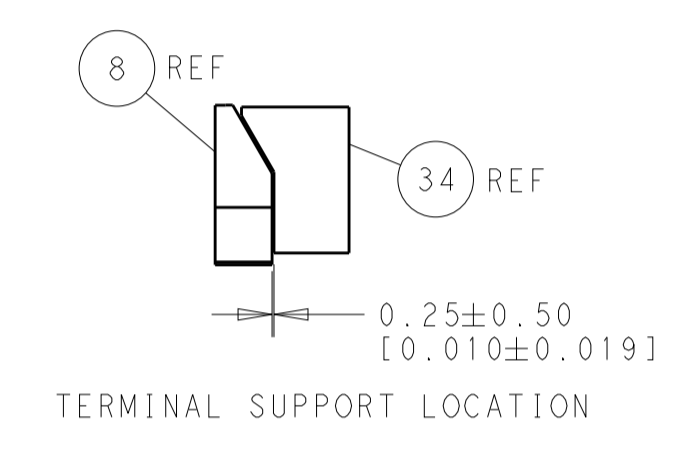
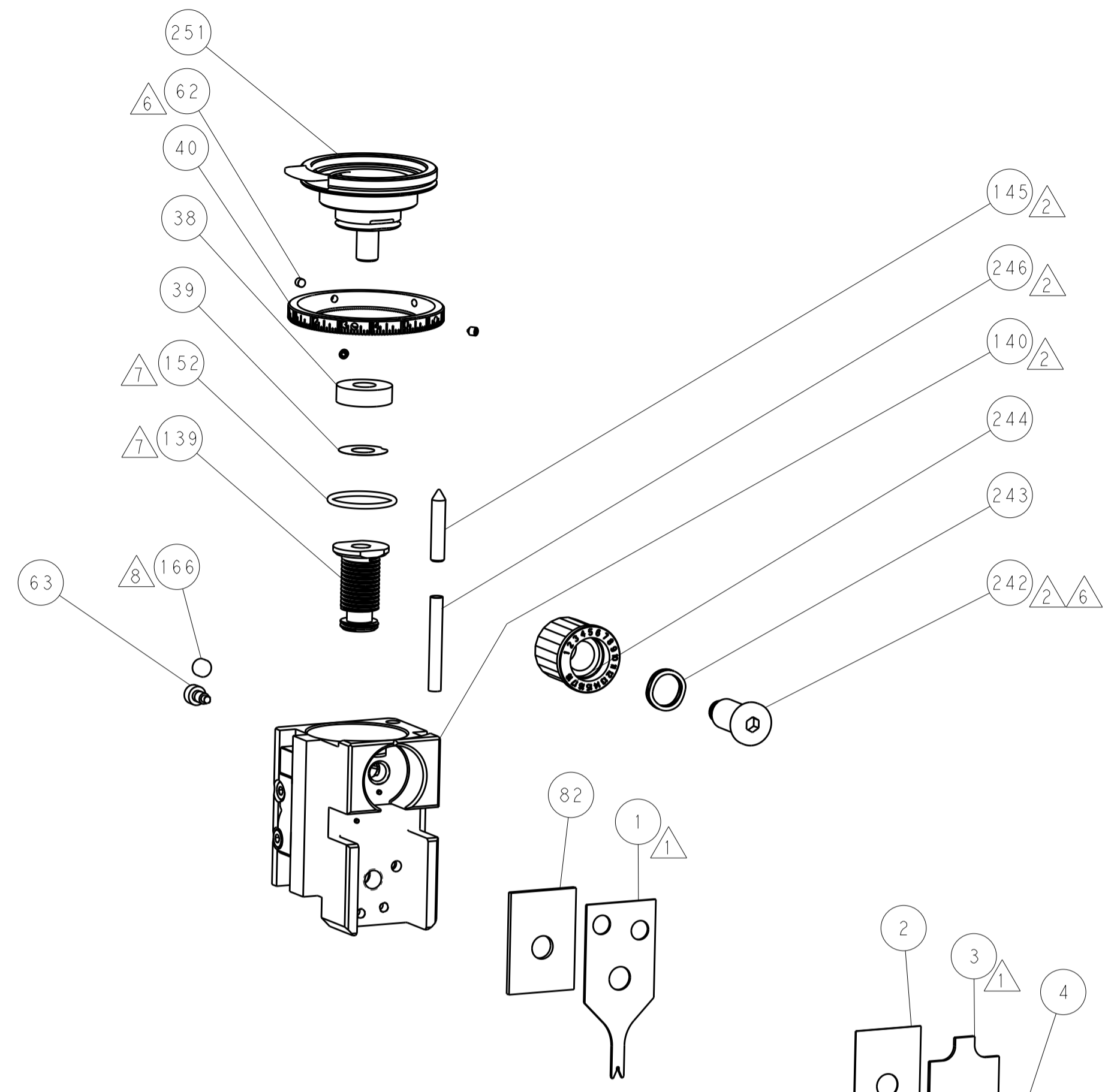
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J.HOU 22AUGUST2014		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD H.GUO 22AUGUST2014	NAME Ocean Side Feed Applicator
MATERIAL:		FINISH:		WEIGHT:		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				A 00779 C=2266475		Customer Accessible Production Drawing SCALE 1:2 SHEET 4 OF 4 REV B	