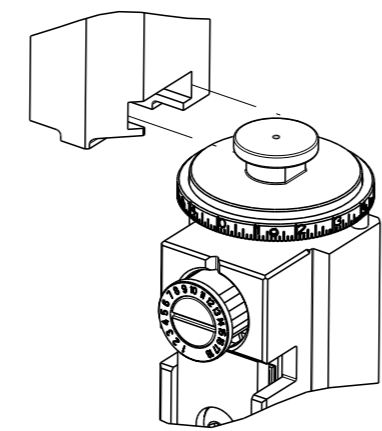


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266097-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266097-2	M	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266097-7	M	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.64 mm [.025]	F
INSUL	0.69 mm [.027]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: JAE TERMINAL		JAE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, CONTACT, 30-36 AWG CRIMP			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.30-1.70 mm [.051-.067 IN]		Ø0.45-0.75 mm [.018-.030 IN]	
TERMINAL APPLICATION SPECIFICATION	T703263-E Rev 6		
TERMINALS APPLIED			
TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
1949297-1	FI-XC3-1-15000	1835895-1	FI-XC3-1-15000
1949297-2	FI-XC3A-1-15000	1949297-5	FI-RC3-1B-15000
1949297-3	FI-AC3-1-15000	1949297-6	FI-XC3B-1-15000
1949297-4	FI-RC3-1A-15000	1949297-7	FI-RC3-1B-1E-15000
1949297-8	FI-RC3-1A-1E-15000		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
30 AWG	0.425+/- .025 [.0167+/- .0010]	6.8
32 AWG	0.400+/- .025 [.0157+/- .0010]	7.1

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- THIS APPLICATOR DOES NOT CUT CARRIER STRIP.

**\*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.

REVISIONS					
#	LY#	DESCRIPTION	DATE	OWN	APVD
K1		ECR-20-005046	03APR2020	TB	TE
L		ECR-20-005794	21APR2020	JAH	GB
M		ECR-20-006821	13MAY2020	TB	GB
M1		ECR-20-018050	22DEC2020	JWC	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-1	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	2844940-1	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1-2119791-4	DEPRESSOR, WIRE	70	
-	1	1	2119943-1	WASHER, SPACER	69	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1338685-1	PAWL, FEED	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	3-1752356-9	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-4	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	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1803095-3	FLOATING SHEAR, FRONT	9	
-	1	2	1	7-1803249-6	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	2-2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	4-238011-8	BLOCK, CRIMPER SPACER	4	
-	1	2	1	4-1803017-6	CRIMPER, INSULATION F	3
-	1	1	455888-4	SPACER, CRIMPER	2	
-	1	2	1	5-1803407-3	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

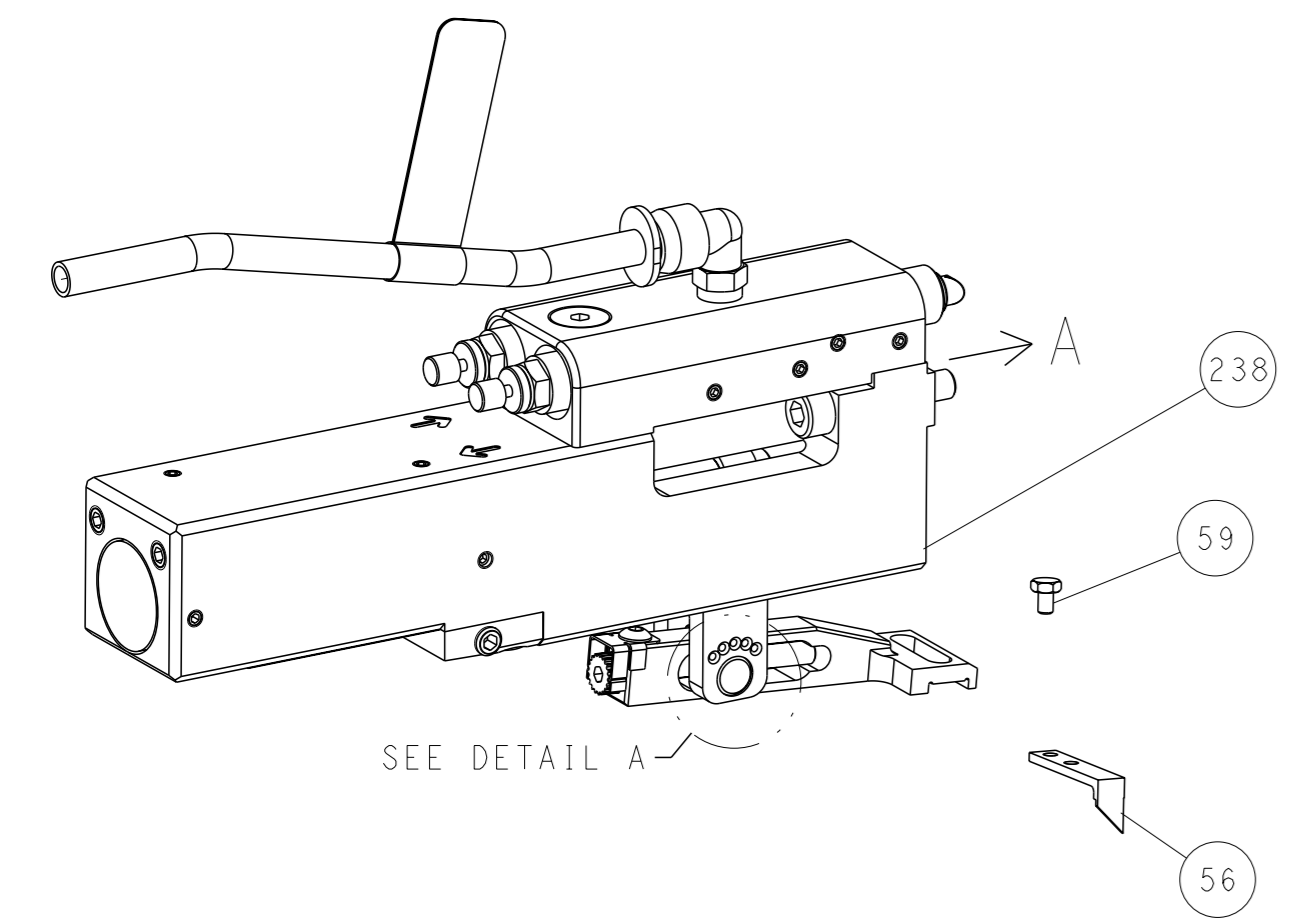
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN H. STAKEM 29OCT2013	TE Connectivity	
DIMENSIONS:		CHK G. BAILEY 29OCT2013	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T. ELBIN 29OCT2013	PRODUCT SPEC	
mm		APPLICATION SPEC		
0 PLC ±		SIZE		
1 PLC ±		CAGE CODE		
2 PLC ±		DRAWING NO		
3 PLC ±		RESTRICTED TO		
4 PLC ±		A100779C=2266097		
ANGLES FINISH		WEIGHT		
MATERIAL		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		
		SCALE 1:2 SHEET 1 OF 4 REV 1		

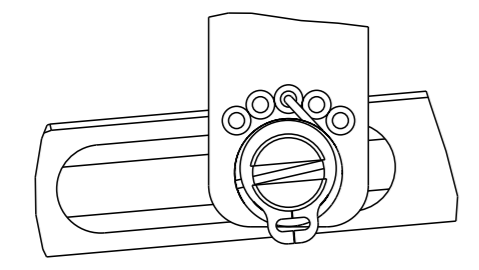
REVISIONS				
P	LY#	DESCRIPTION	DATE	OWN / APVD
-	-	SEE SHEET 1	-	-

# FEED TYPE

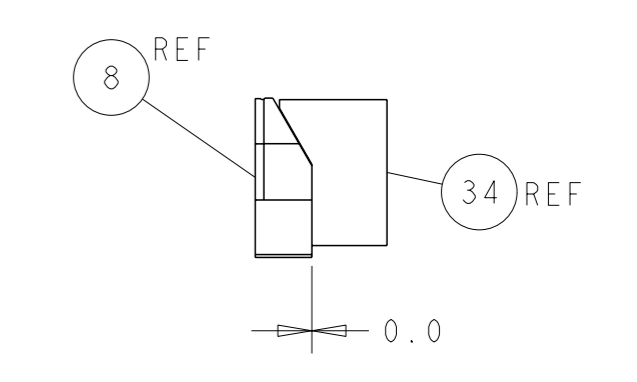
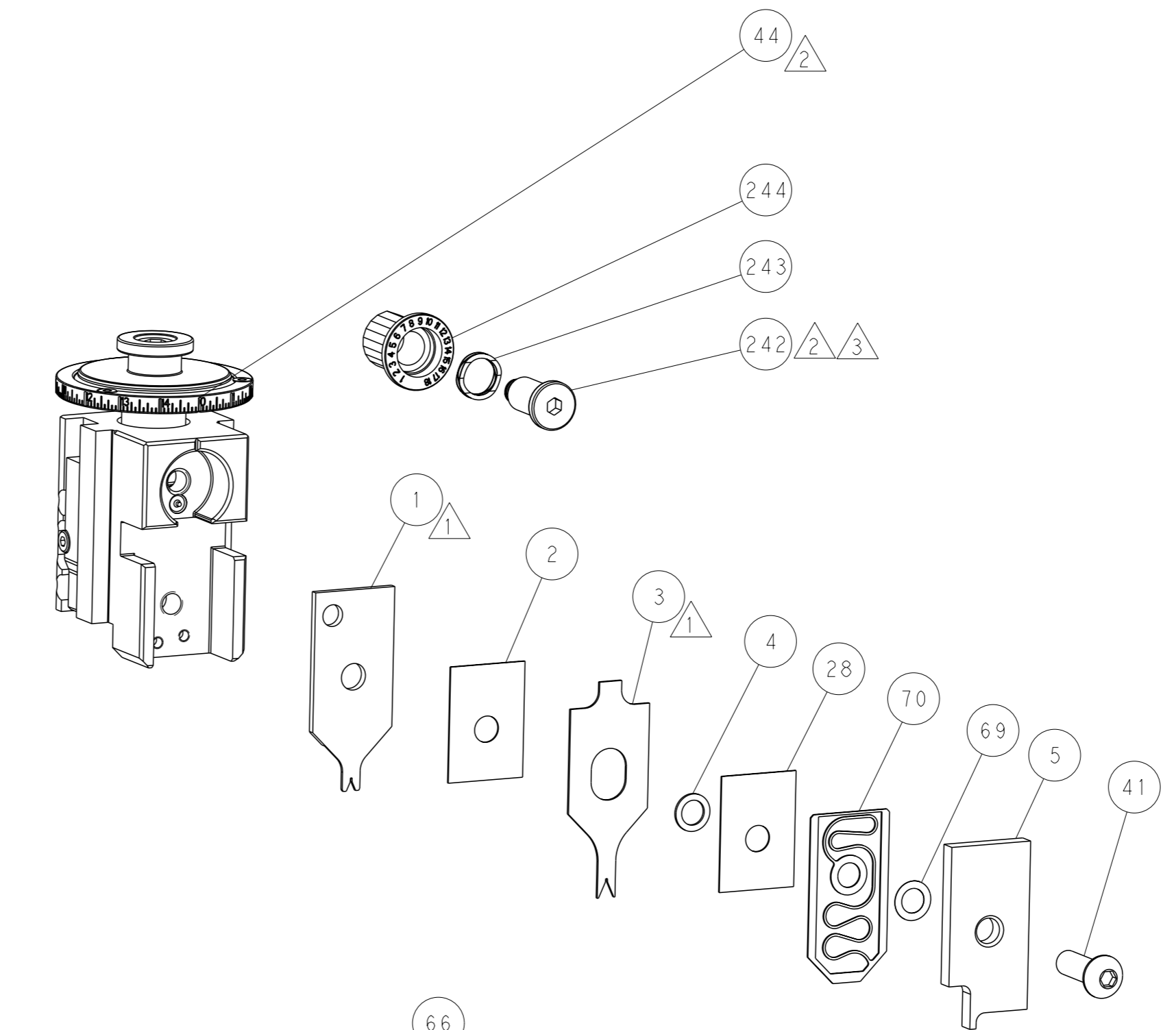
## PNEUMATIC



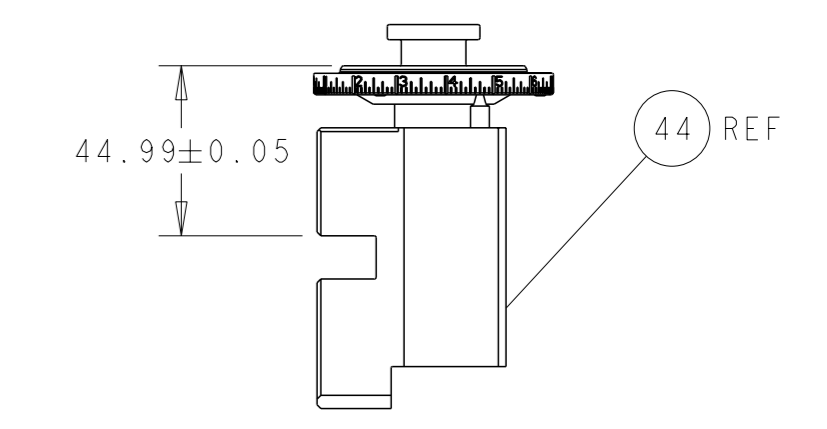
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



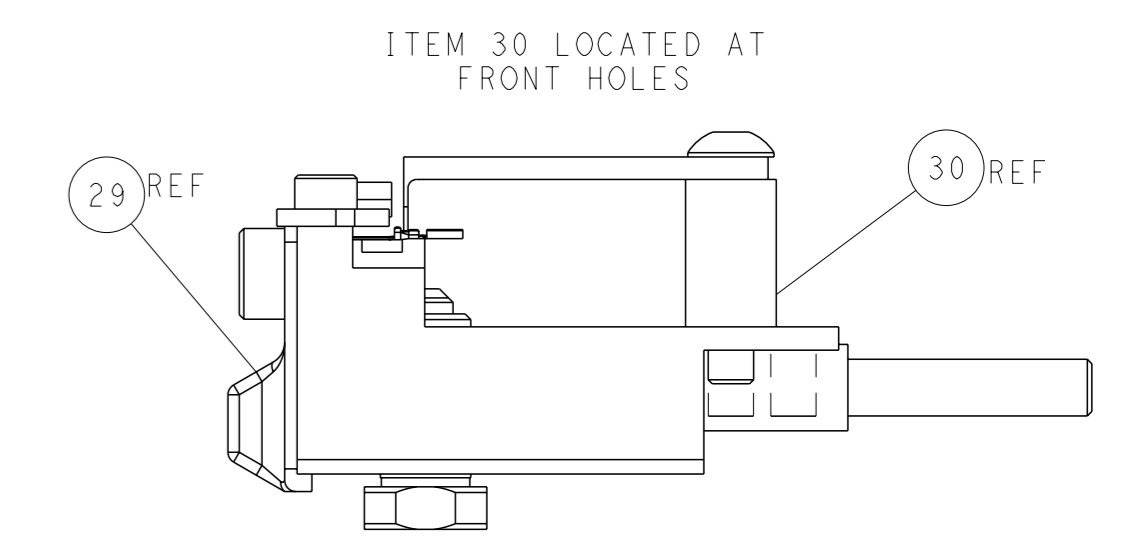
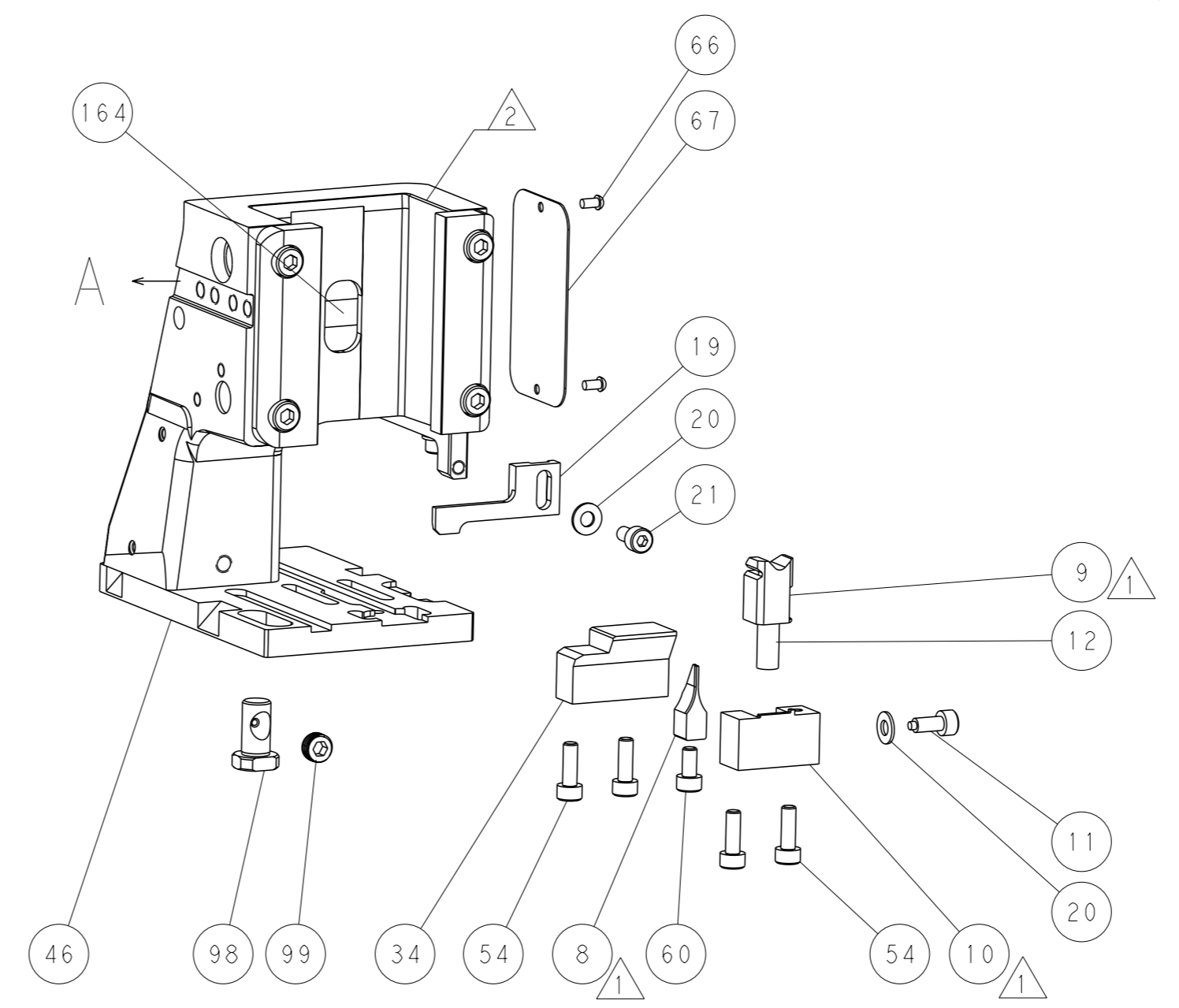
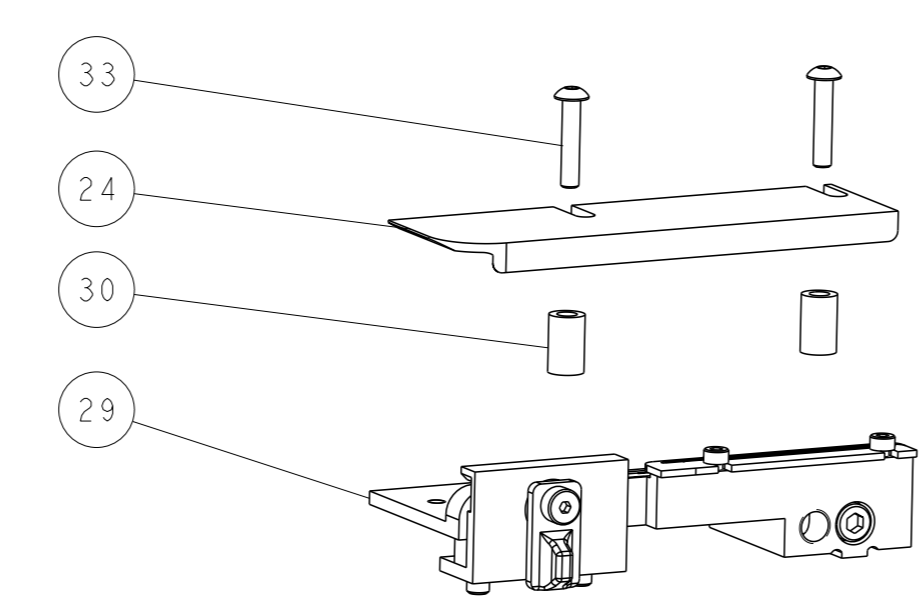
DETAIL A



TERMINAL SUPPORT LOCATION

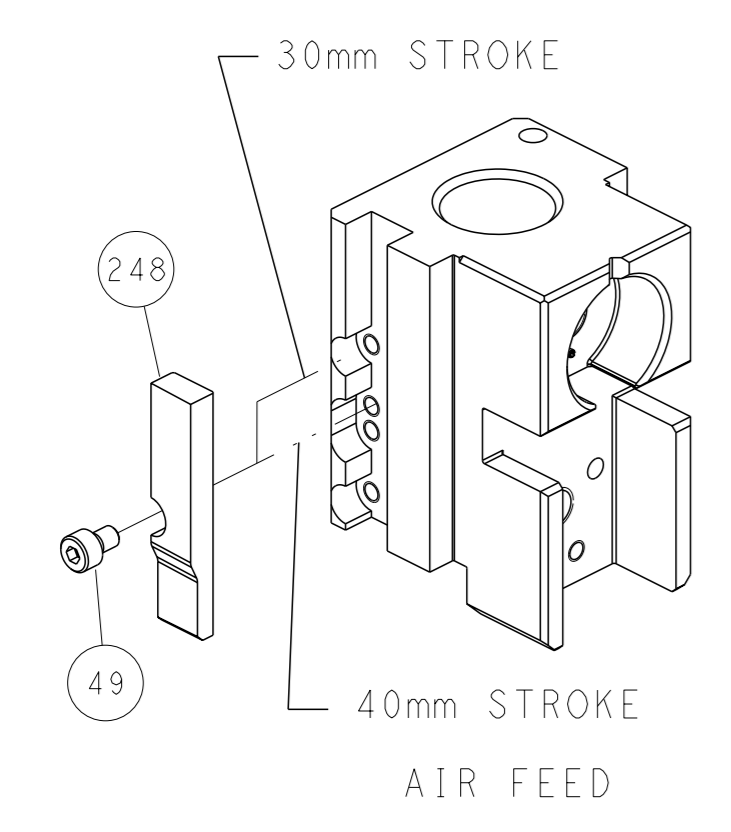


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

## CAM POSITION

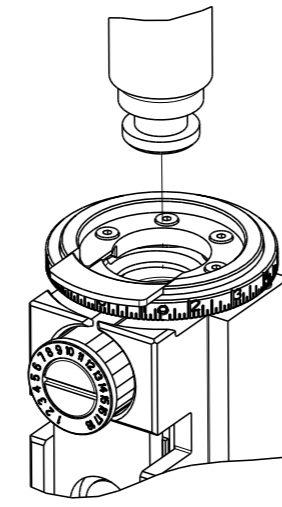


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: K. STAKEM 29OCT2013	TE Connectivity
DIMENSIONS: mm		CHK: G. BAILEY 29OCT2013	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: J. ELBIN 29OCT2013	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		NAME: Ocean Side Feed Applicator	
MATERIAL: -	WEIGHT: -	SIZE: A100779	RESTRICTED TO: -
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2	SHEET 2 of 4

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT 20		ALL RIGHTS RESERVED.					
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2266097-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2266097-7	M	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.64 mm [.025]	F
INSUL	0.69 mm [.027]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JAE TERMINAL JAE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, CONTACT, 30-36 AWG CRIMP

WIRE STRIP LENGTH 1.30-1.70 mm [.051-.067 IN]	INSULATION DIAMETER RANGE Ø0.45-0.75 mm [.018-.030 IN]
--	---

TERMINAL APPLICATION SPECIFICATION T703263-E Rev 6

TERMINALS APPLIED

TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
1949297-1	FI-XC3-1-15000	1835895-1	FI-XC3-1-15000
1949297-2	FI-XC3A-1-15000	1949297-5	FI-RC3-1B-15000
1949297-3	FI-AC3-1-15000	1949297-6	FI-XC3B-1-15000
1949297-4	FI-RC3-1A-15000	1949297-7	FI-RC3-1B-1E-15000
1949297-8	FI-RC3-1A-1E-15000		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
30 AWG	0.425+/- .025 [.0167+/- .0010]	6.8
32 AWG	0.400+/- .025 [.0157+/- .0010]	7.1

- △ 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.
- △ TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- △ THIS APPLICATOR DOES NOT CUT CARRIER STRIP.

**\*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.

REVISIONS				
#	LY#	DESCRIPTION	DATE	APPV
-	-	SEE SHEET 1	-	-

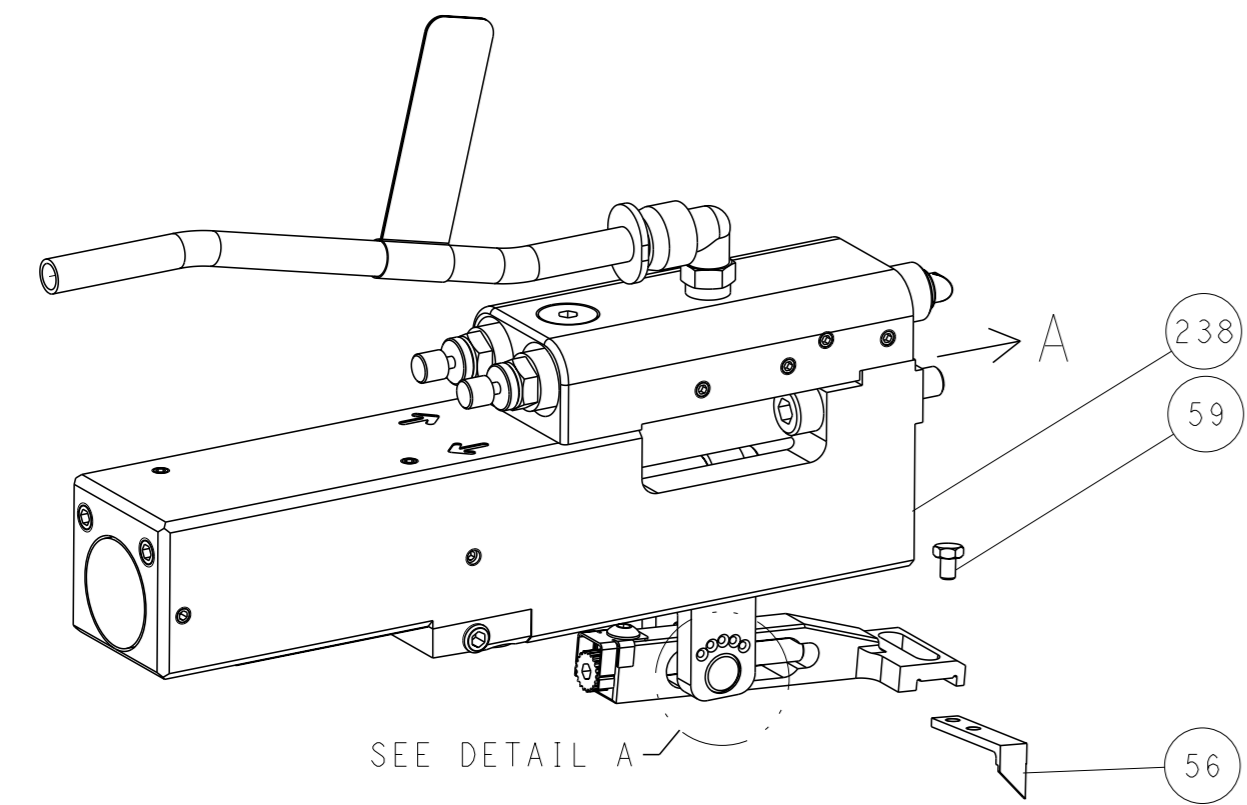
-	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	2844940-1	AIR FEED MODULE	238	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	151	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143	
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1-2119791-4	DEPRESSOR, WIRE	70	
-	1	2119943-1	WASHER, SPACER	69	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1338685-1	PAWL, FEED	56	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	3-1752356-9	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-4	SPACER, CRIMPER	28	
-	1	1320928-2	STRIP GUIDE	24	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1-356885-4	STOP, SHEAR	11	
-	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1803095-3	FLOATING SHEAR, FRONT	9	
-	1	7-1803249-6	ANVIL, COMBINATION	8	
-	-	-	-	7	
-	-	-	-	6	
-	1	2-2119757-4	DEPRESSOR, SHEAR	5	
-	1	4-238011-8	BLOCK, CRIMPER SPACER	4	
-	1	4-1803017-6	CRIMPER, INSULATION F	3	
-	1	455888-4	SPACER, CRIMPER	2	
-	1	5-1803407-3	CRIMPER, WIRE PREMIUM	1	
-	77	-22	PART NO	DESCRIPTION	ITEM NO

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

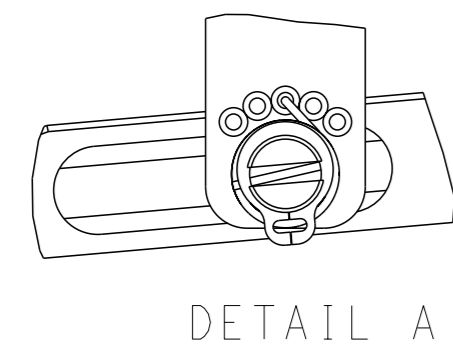
THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: H. STAKEM 29OCT2013	 TE Connectivity NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - SIZE: - CAGE CODE: - DRAWING NO: - RESTRICTED TO: - WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING
DIMENSIONS: mm		CHK: G. BAILEY 29OCT2013	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPV: J. ELBIN 29OCT2013	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±			
SCALE: 1:2		SHEET 3 of 4	

REVISIONS				
P	LY#	DESCRIPTION	DATE	OWN APVD
-	-	SEE SHEET 1	-	-

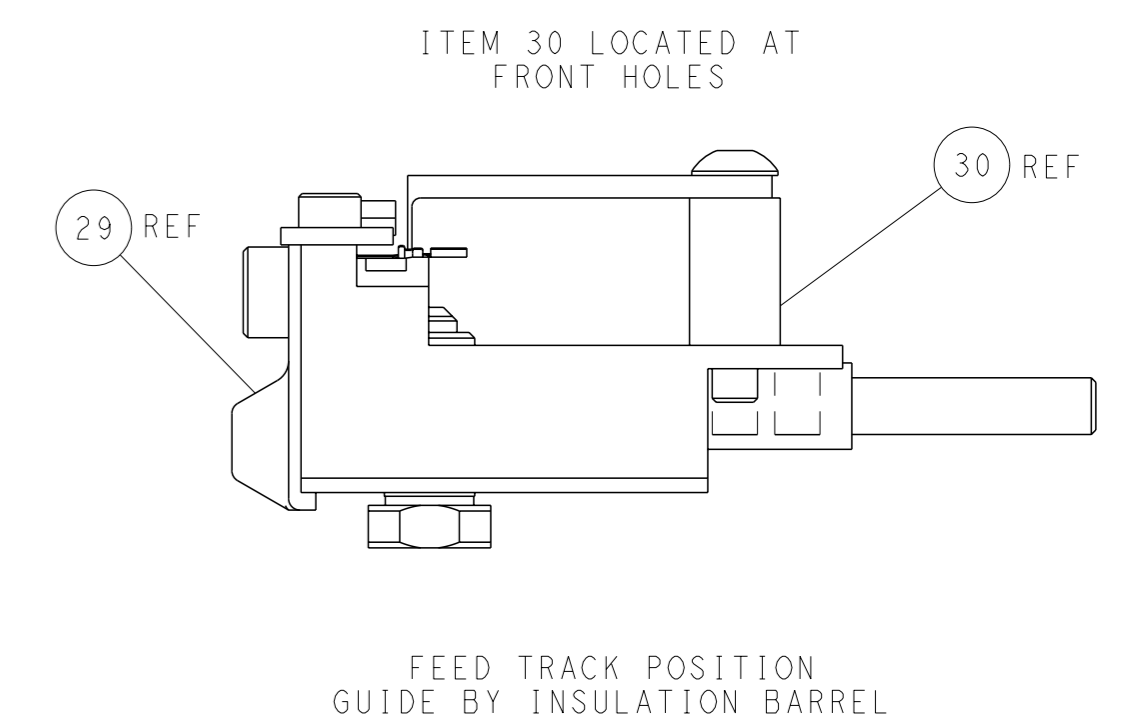
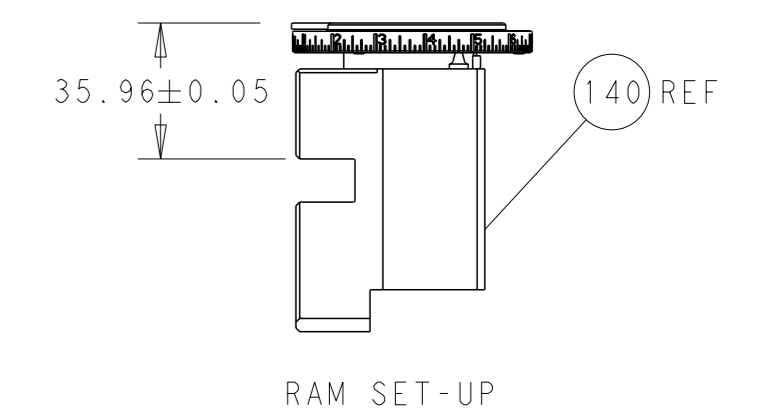
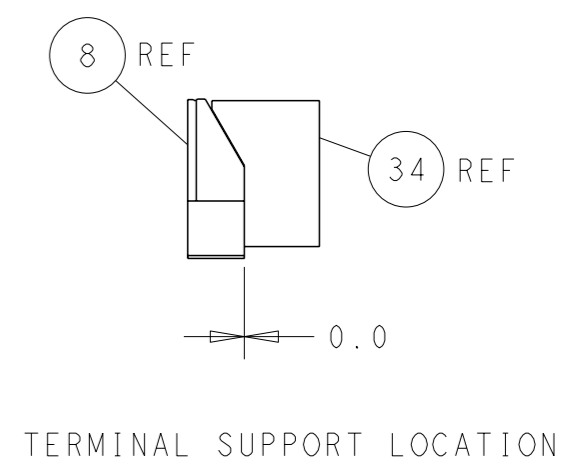
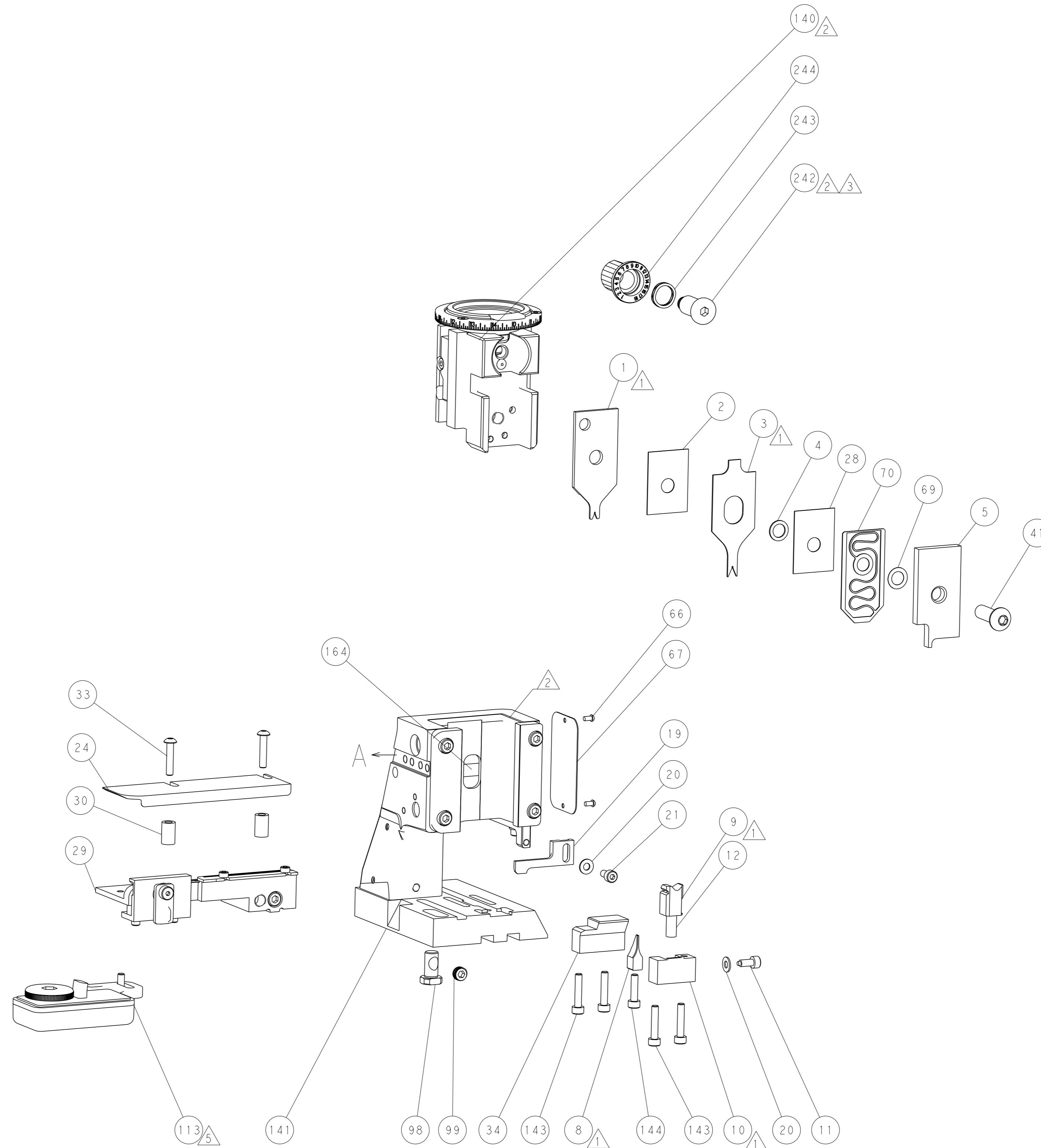
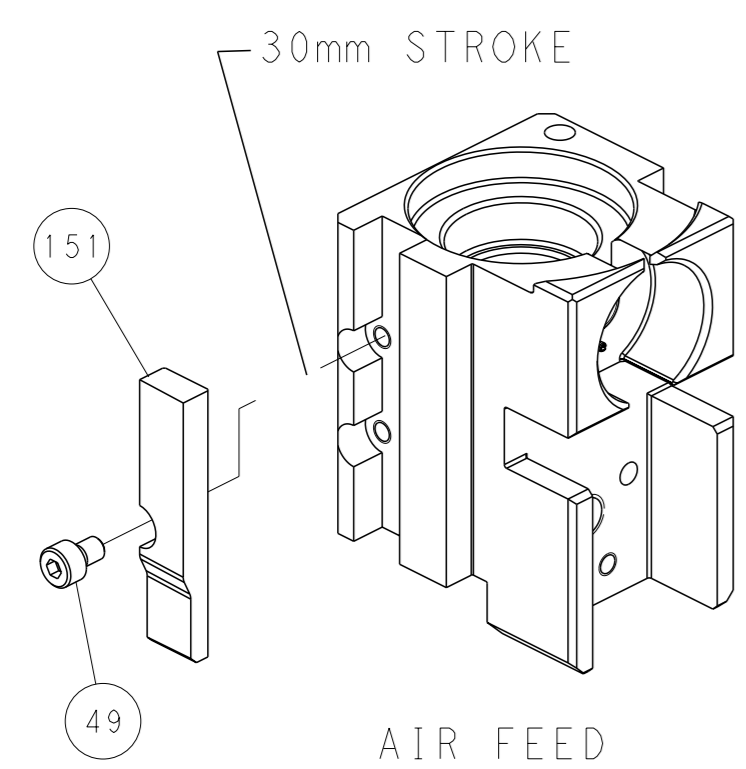
### FEED TYPE PNEUMATIC



### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



### CAM POSITION



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

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: K. STAKEM 29OCT2013	<b>STE</b> TE Connectivity
DIMENSIONS: mm		CHK: G. BAILEY 29OCT2013	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: T. ELBIN 29OCT2013	NAME: Ocean Side Feed Applicator
0 PLC ±		PRODUCT SPEC:	APPLICATION SPEC:
1 PLC ±		SIZE: A1	CAGE CODE: 2266097
2 PLC ±		WEIGHT:	SCALE: 1:2
3 PLC ±		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEET 4 OF 4
4 PLC ±		RESTRICTED TO:	REV: M1
ANGLES FINISH *		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	