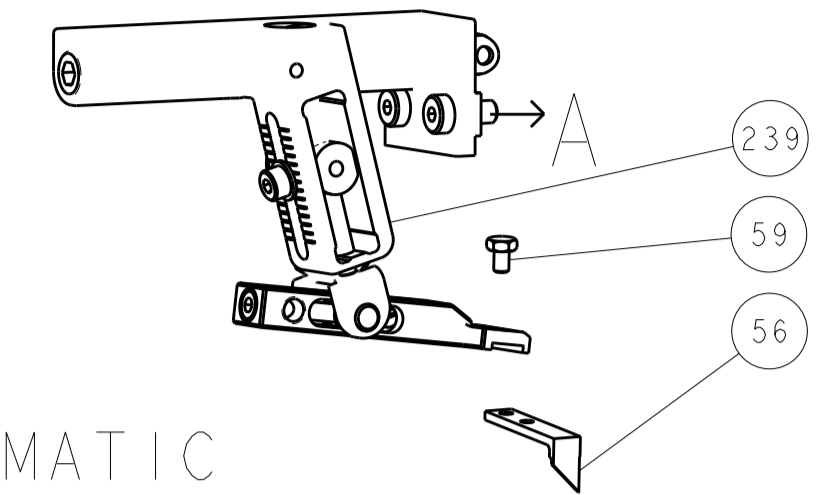


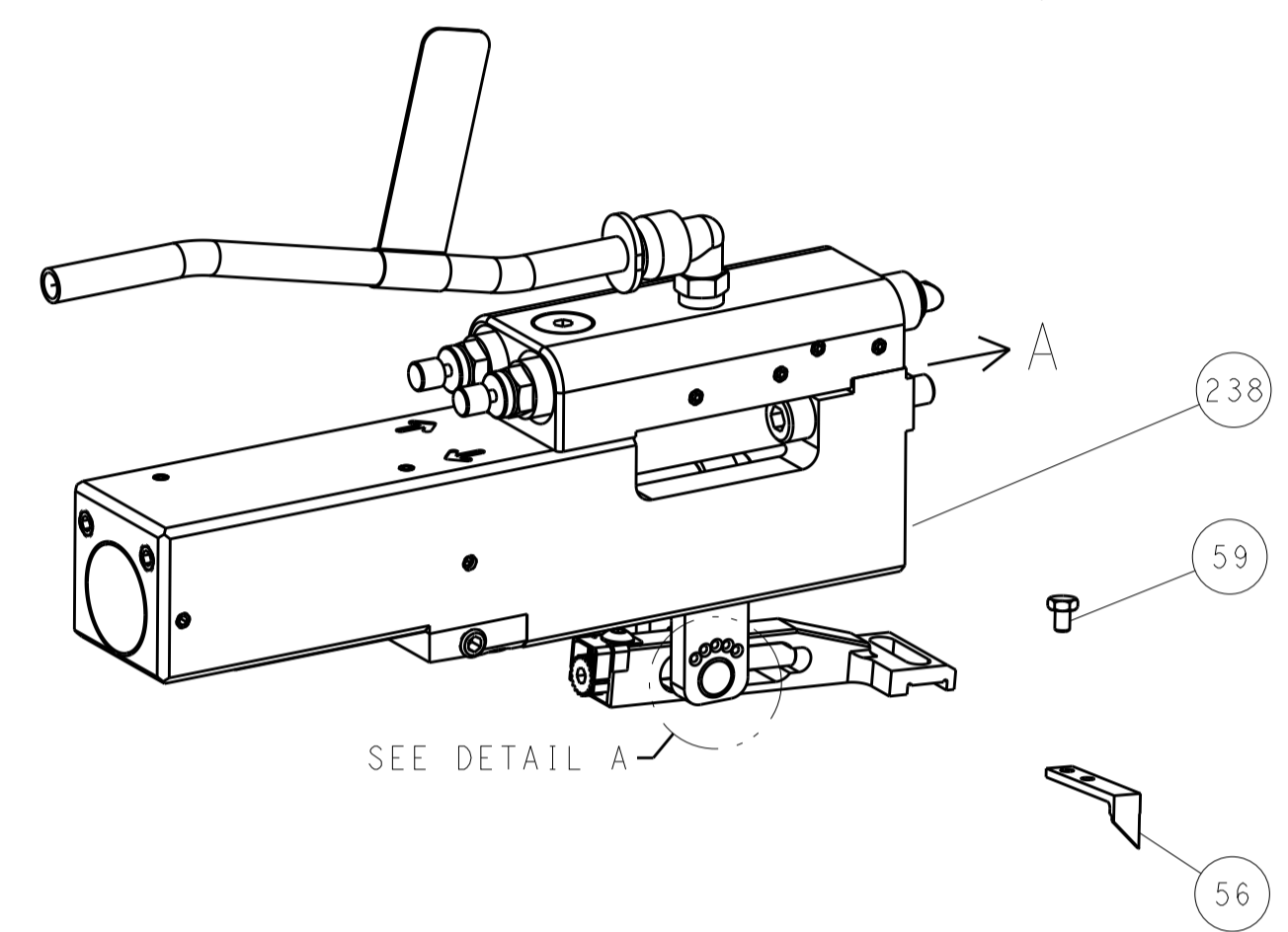


| LOC | DIST | REV | DATE | BY | APPV |
|-----|------|-----|------|----|------|
| A   | 66   |     |      |    |      |
|     |      |     |      |    |      |
|     |      |     |      |    |      |

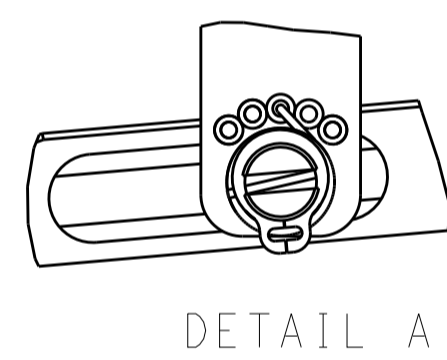
# FEED TYPE MECHANICAL



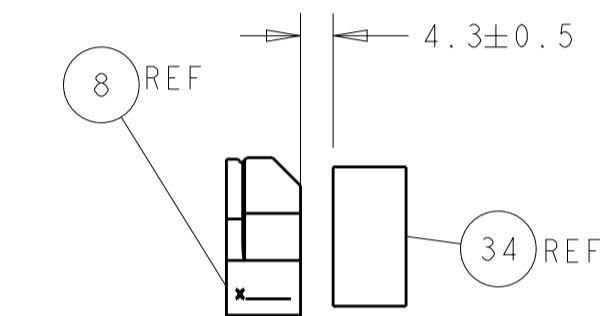
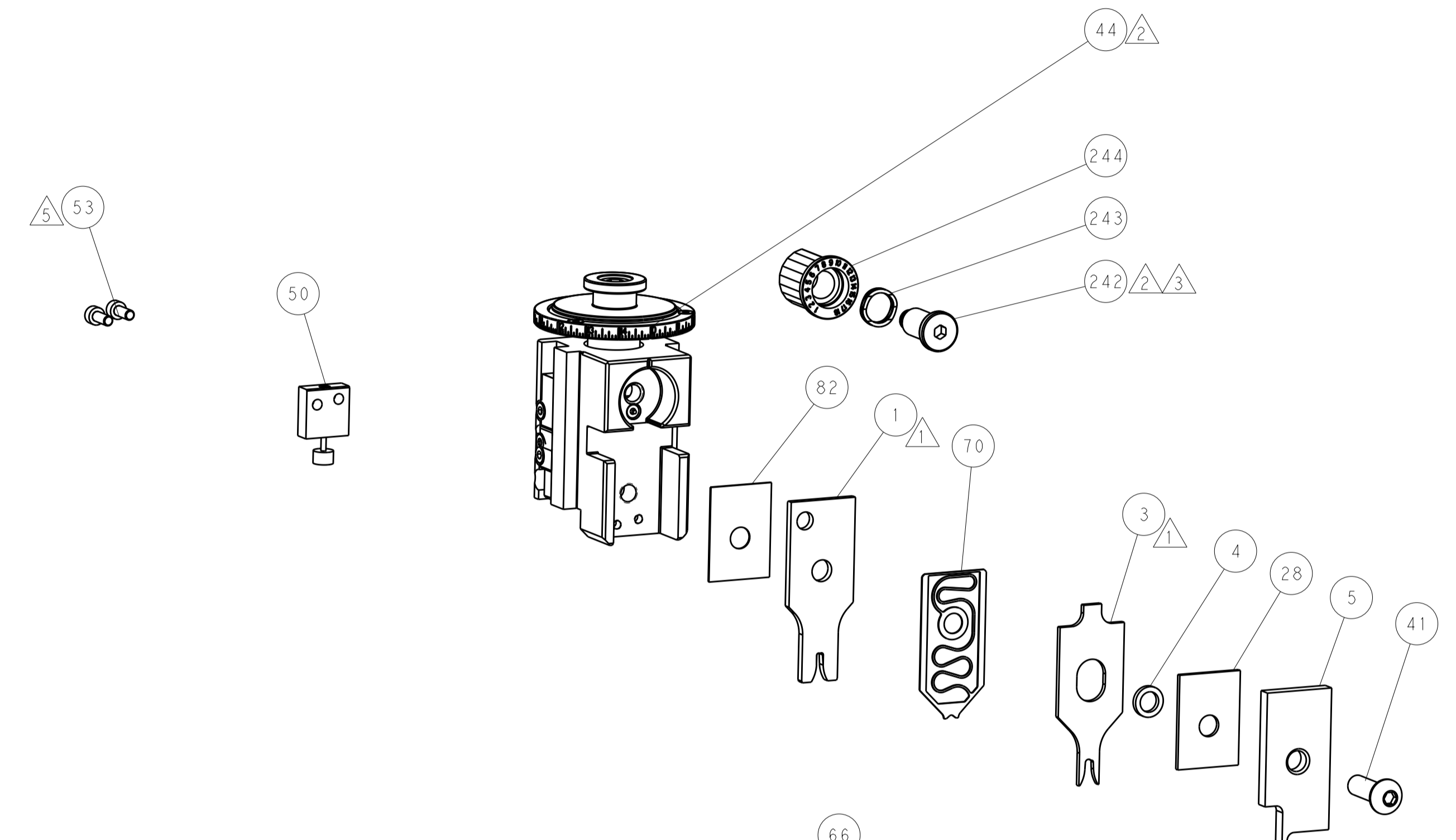
## PNEUMATIC



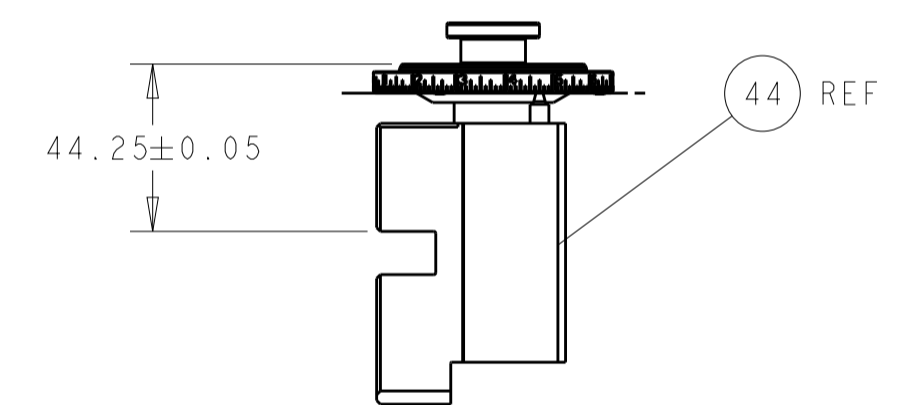
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



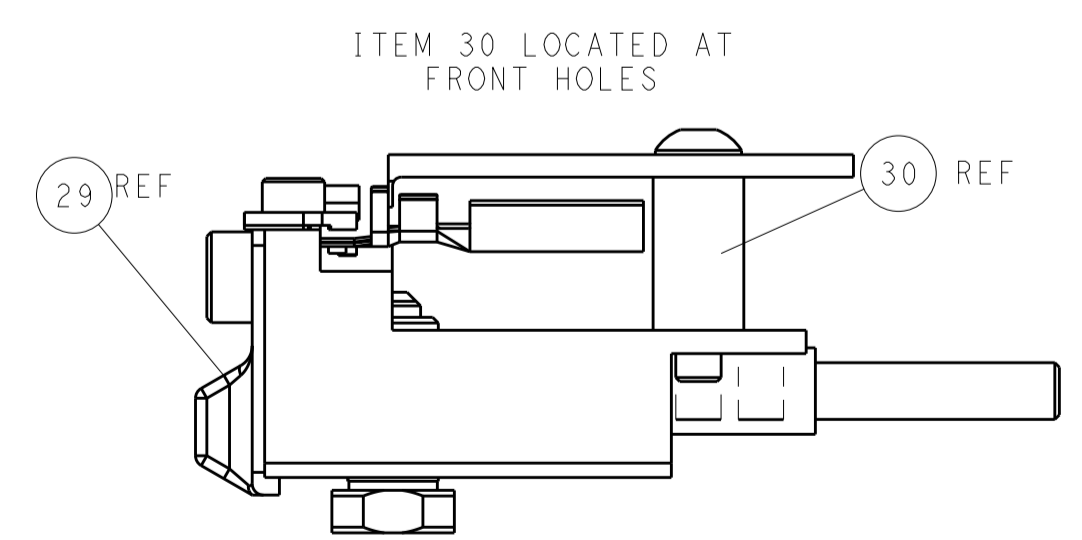
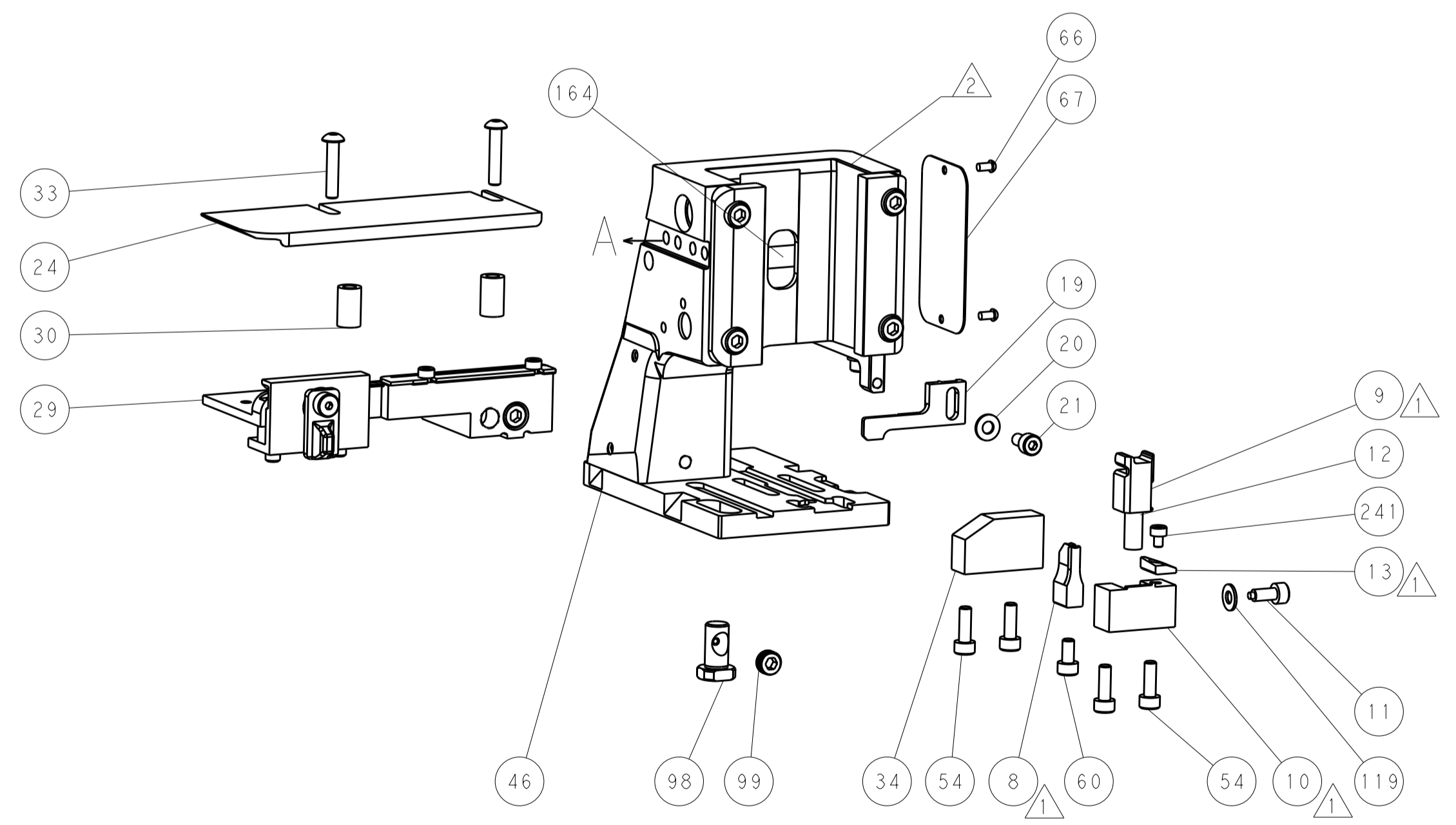
DETAIL A



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

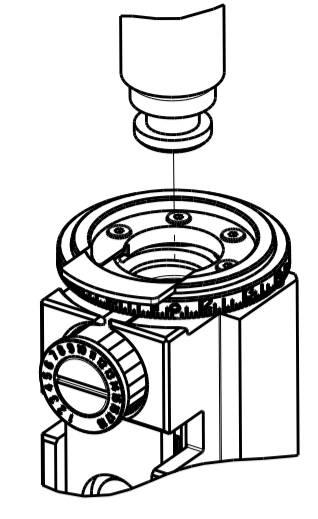


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

|  |         |  |               |                        |                                  |                     |                           |
|--|---------|--|---------------|------------------------|----------------------------------|---------------------|---------------------------|
| DIMENSIONS:                            |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |               | DWN: C. CHEN 15APR2011 |                                  | TE Connectivity     |                           |
| mm                                     | 0 PLC ± | 1 PLC ±                                | 2 PLC ±       | 3 PLC ±                | 4 PLC ±                          | 5 PLC ±             | Harrisburg, PA 17105-3608 |
|  | ANGLES  | FINISH                                 |               | CHK: S. XI 15APR2011   | NAME: Ocean Side Feed Applicator | RESTRICTED TO       |                           |
| MATERIAL:                              |         | APVD: J. CRUZ 15APR2011                | PRODUCT SPEC: | SIZE: A1               | CAGE CODE: 00779                 | DRAWING NO: 2151062 | REV: R                    |
| Customer Accessible Production Drawing |         |  |               | SCALE: 1:2             | SHEET: 2 of 4                    |                     |                           |

| PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE  |
|-------------|----------|--------------------------|------------|
| 2-2151062-1 | R        | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151062-2 | R        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC  |
| 7-2151062-7 | A        | CRIMP TOOLING KIT        | -          |

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.54 mm [.100] | F    |
| INSUL                                | 3.56 mm [.140] | OV   |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                |      |

| TERMINAL DATA: TE TERMINAL               |               | TE CRIMP SPECIFICATION       |             |
|--|---------------|------------------------------|-------------|
| TERMINAL NAME: JUNIOR POWER TIME CONTACT |               |                              |             |
| WIRE STRIP LENGTH                        |               | INSULATION DIAMETER RANGE    |             |
| 3.80-4.40 mm [.150-.173 IN]              |               | Ø1.90-3.00 mm [.075-.118 IN] |             |
| TERMINAL APPLICATION SPECIFICATION       | 114-18387     | -                            | -           |
| TERMINALS APPLIED                        |               |                              |             |
| TE TERMINAL                              | TE TERMINAL   | TE TERMINAL                  | TE TERMINAL |
| (A) 1241390-1                            | (A) 1241390-2 | (A) 1241390-3                |             |

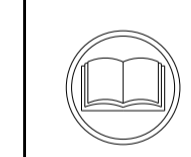
| TERMINAL DATA: TE TERMINAL               |             | TE CRIMP SPECIFICATION       |             |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: JUNIOR POWER TIME CONTACT |             |                              |             |
| WIRE STRIP LENGTH                        |             | INSULATION DIAMETER RANGE    |             |
| 4.00-4.60mm [.157-.181 IN]               |             | Ø1.90-3.00 mm [.075-.118 IN] |             |
| TERMINAL APPLICATION SPECIFICATION       | 114-18051   | -                            | -           |
| TERMINALS APPLIED                        |             |                              |             |
| TE TERMINAL                              | TE TERMINAL | TE TERMINAL                  | TE TERMINAL |
| 1-964296-3                               | 2-964296-1  | 2-964296-2                   |             |

| TERMINAL DATA: TE TERMINAL               |             | TE CRIMP SPECIFICATION       |             |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: JUNIOR POWER TIME CONTACT |             |                              |             |
| WIRE STRIP LENGTH                        |             | INSULATION DIAMETER RANGE    |             |
| 4.00-4.60mm [.157-.181 IN]               |             | Ø1.90-3.00 mm [.075-.118 IN] |             |
| TERMINAL APPLICATION SPECIFICATION       | 114-18050   | -                            | -           |
| TERMINALS APPLIED                        |             |                              |             |
| TE TERMINAL                              | TE TERMINAL | TE TERMINAL                  | TE TERMINAL |
| 965999-1                                 | 1-965999-1  | 1241870-1                    |             |
| 965999-2                                 | 2-965999-1  | 1241870-2                    |             |
| 965999-6                                 | 4-965999-1  | 4-1241870-1                  |             |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 2.50mm2   | 1.76+/-0.05 [.069+/- .002] | 8.0                            |
| 2.00mm2   | 1.70+/-0.05 [.067+/- .002] | 8.8                            |
| 1.50mm2   | 1.47+/-0.05 [.058+/- .002] | 10.9                           |
| 1.25mm2   | 1.42+/-0.05 [.056+/- .002] | 11.7                           |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 2.50mm2   | 1.76+/-0.05 [.069+/- .002] | 8.0                            |
| 2.00mm2   | 1.70+/-0.05 [.067+/- .002] | 8.8                            |
| 1.50mm2   | 1.47+/-0.05 [.058+/- .002] | 10.9                           |
| 1.25mm2   | 1.48+/-0.05 [.058+/- .002] | 10.9                           |

| WIRE SIZE    | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|--------------|----------------------------|--------------------------------|
| 2.50mm2      | 1.76+/-0.05 [.069+/- .002] | 8.0                            |
| 2.00mm2      | 1.70+/-0.05 [.067+/- .002] | 8.8                            |
| 1.50mm2      | 1.47+/-0.05 [.058+/- .002] | 10.9                           |
| 0.50+0.75mm2 | 1.42+/-0.05 [.056+/- .002] | 11.4                           |



- 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.
- CUT TO LENGTH AT ASSEMBLY.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

**\*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.

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

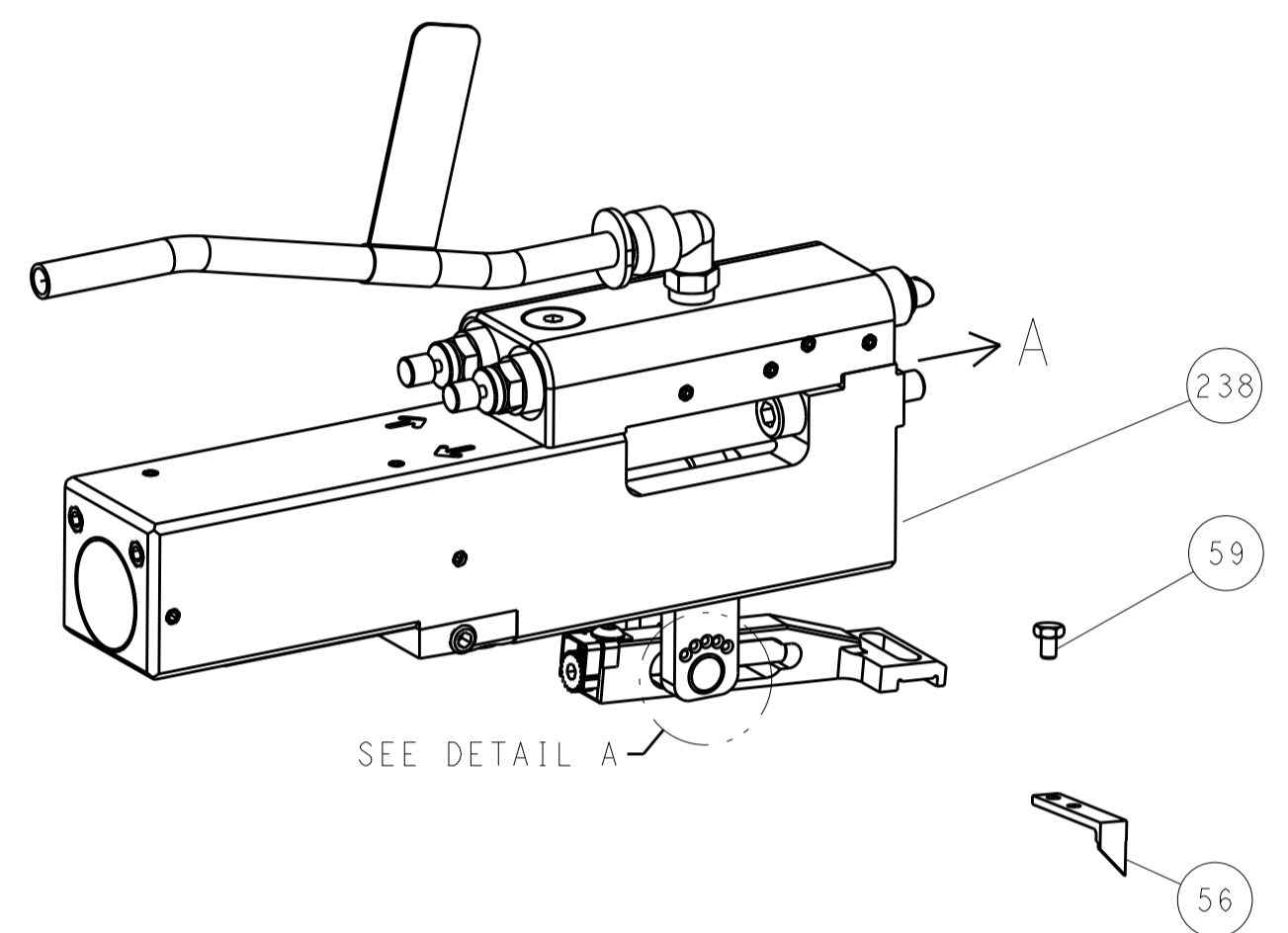
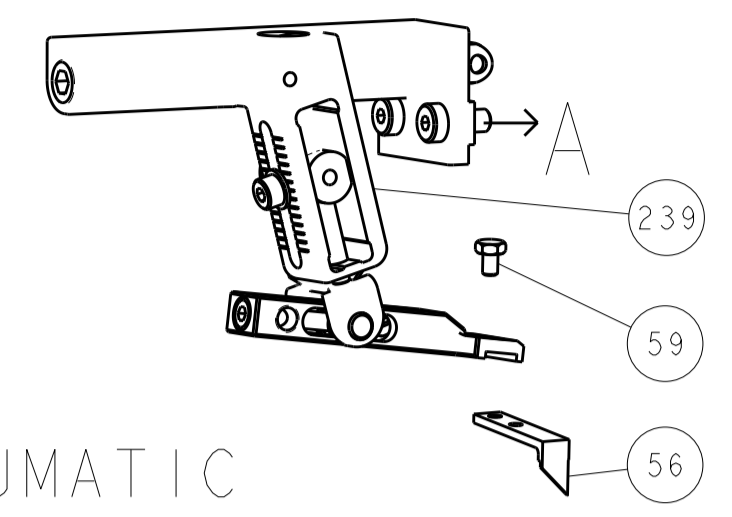
|   |     |     |             |                                     |     |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | 1   | 2119082-8   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241 |
| - | -   | 1   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239 |
| - | 1   | -   | 2844940-1   | AIR FEED MODULE                     | 238 |
| - | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | 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   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99  |
| - | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98  |
| - | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 2119791-9   | 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  |
| - | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53  |
| - | 1   | 1   | 1803382-6   | HOLD DOWN, SPRING LOADED            | 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   | 1-1752356-7 | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 2   | 2   | 2-2844962-3 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30  |
| - | 1   | 1   | 2844992-2   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1-455888-5  | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1320928-3   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 1   | 1   | 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   | 454276-5    | FLOATING SHEAR, FRONT               | 9   |
| 1 | 1   | 1   | 4-1333206-3 | ANVIL, COMBINATION .100             | 8   |
| - | 1   | 1   | 2119757-5   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 2-238011-2  | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 1   | 1   | 2119785-2   | CRIMPER, INSULATION OVERLAP PREMIUM | 3   |
| 1 | 1   | 1   | 1-456407-3  | CRIMPER, WIRE PREMIUM               | 1   |

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

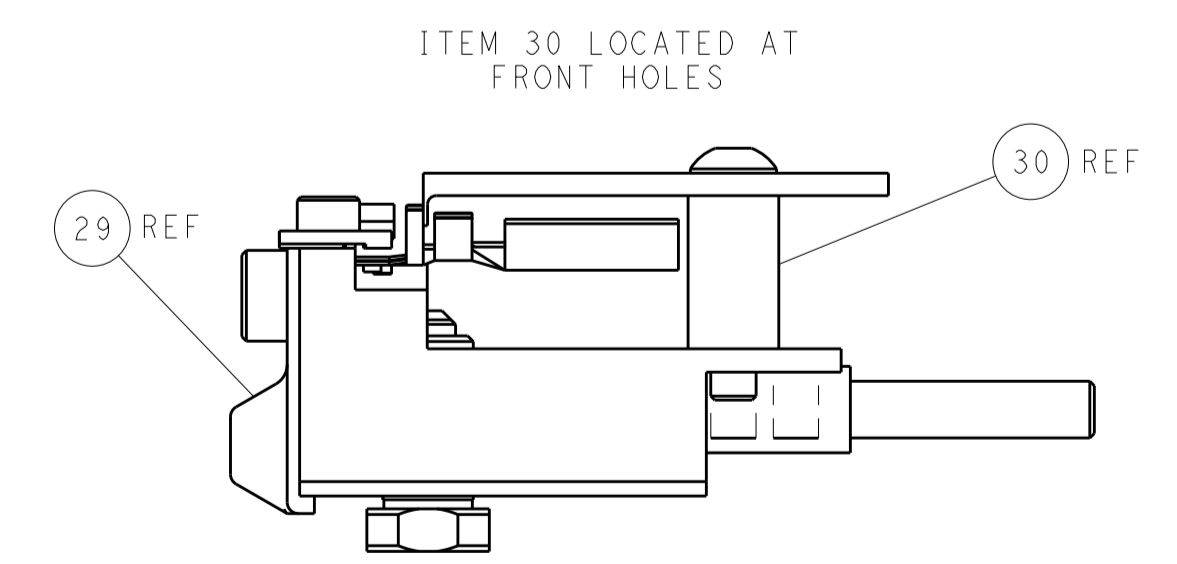
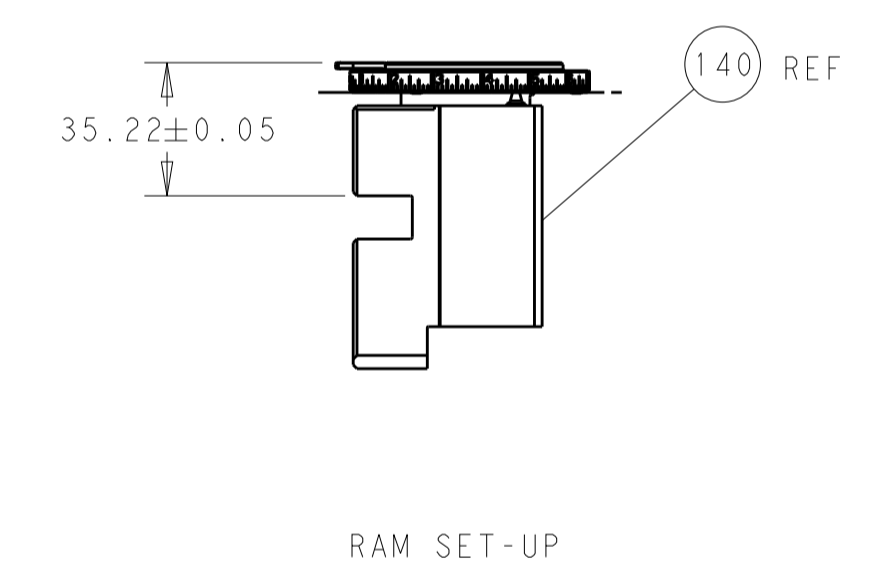
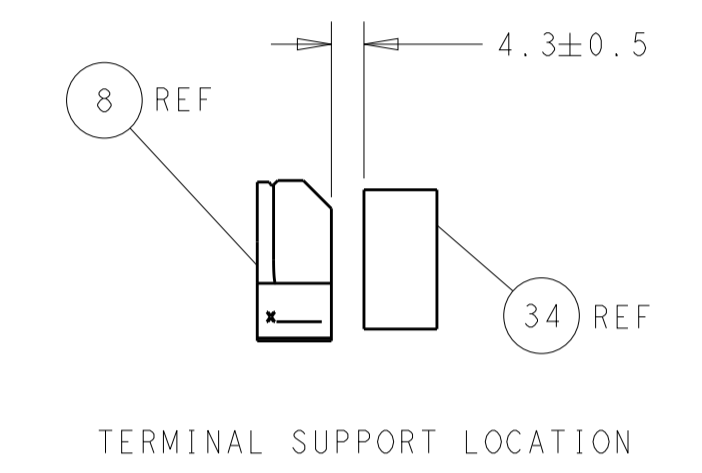
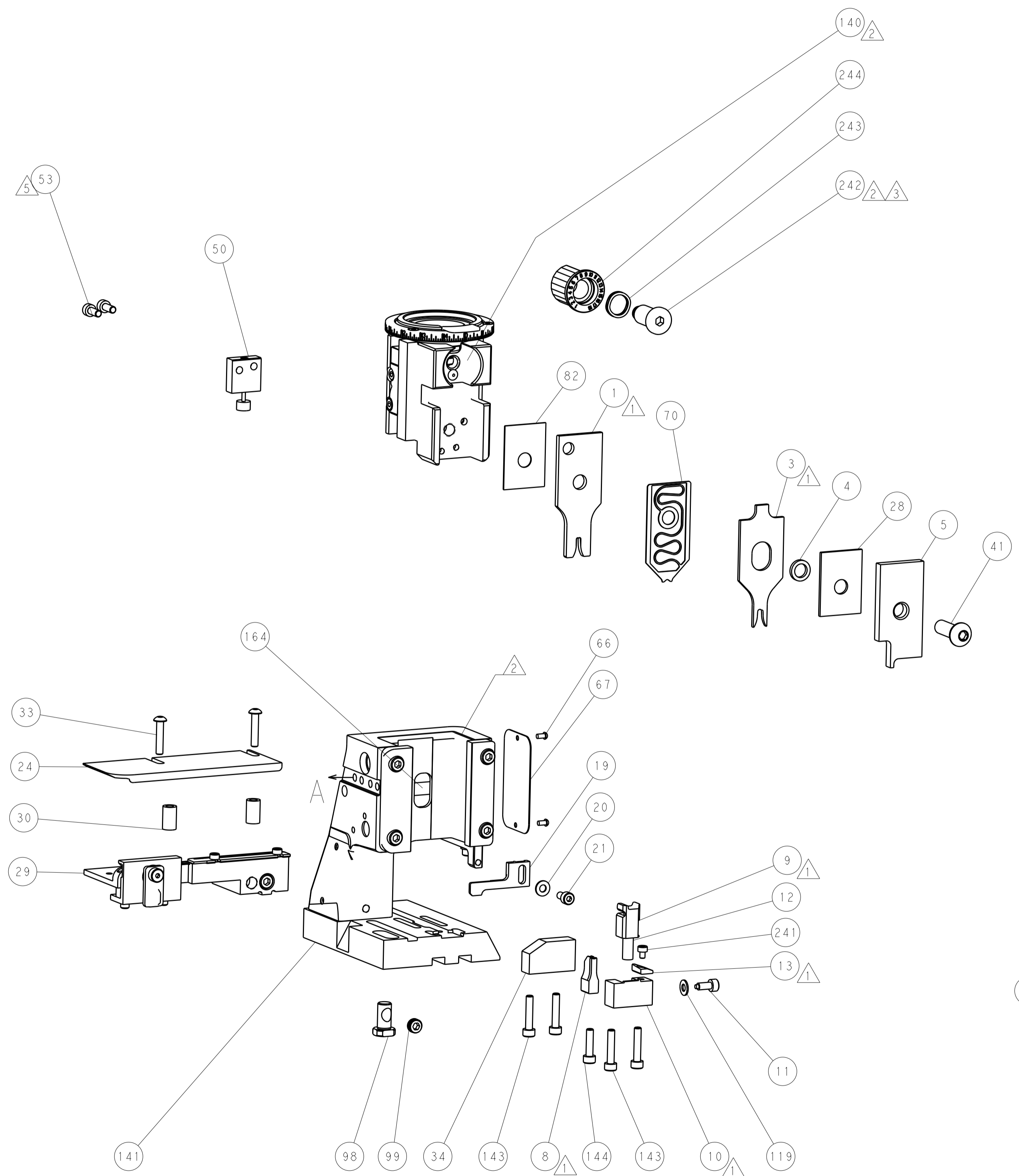
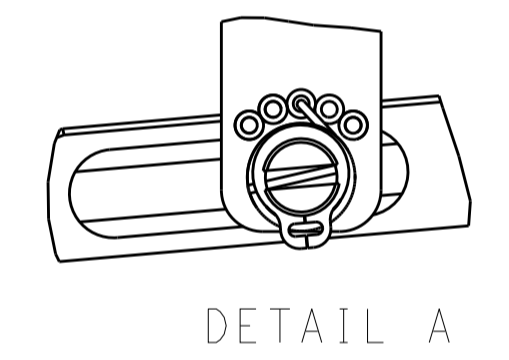
| DIMENSIONS:                            |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | MATERIAL:    |         | FINISH:  |        | WEIGHT: |  | SCALE: |  | SHEET: |  | REV: |  |
|--|---------|--|---------|--------------|---------|----------|--------|---------|--|--------|--|--------|--|------|--|
| mm                                     | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±      | 4 PLC ± | ANGLES ± | FINISH |         |  |        |  |        |  |      |  |
| Customer Accessible Production Drawing |         | SCALE 1:2                              |         | SHEET 3 OF 4 |         | REV R    |        |         |  |        |  |        |  |      |  |

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

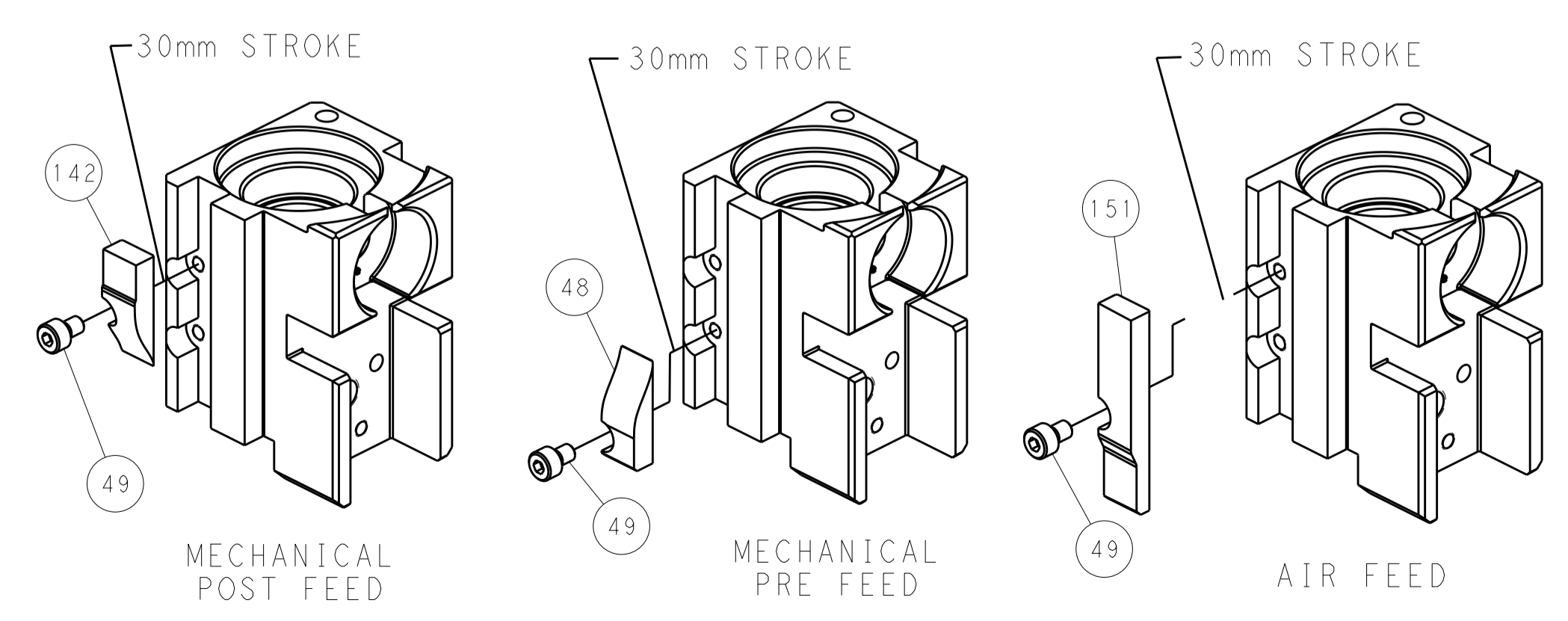
# FEED TYPE MECHANICAL



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



# CAM POSITIONS



**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: C. CHEN 15APR2011           |         | STE TE Connectivity   |                           |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                          | 4 PLC ± | APVD: S. XI 15APR2011 | Harrisburg, PA 17105-3608 |
| MATERIAL:   |         | FINISH:                                |         | NAME: Ocean Side Feed Applicator |         | RESTRICTED TO:        |                           |
|             |         |  |         | SIZE: A1                         |         | CAGE CODE: 00779      |                           |
|             |         |  |         | DRAWING NO: 2151062              |         | SCALE: 1:2            |                           |
|             |         |  |         | SHEET: 4                         |         | REV: R                |                           |