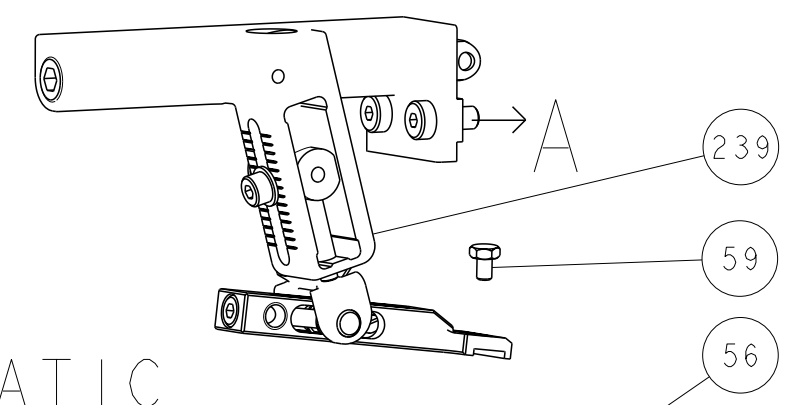
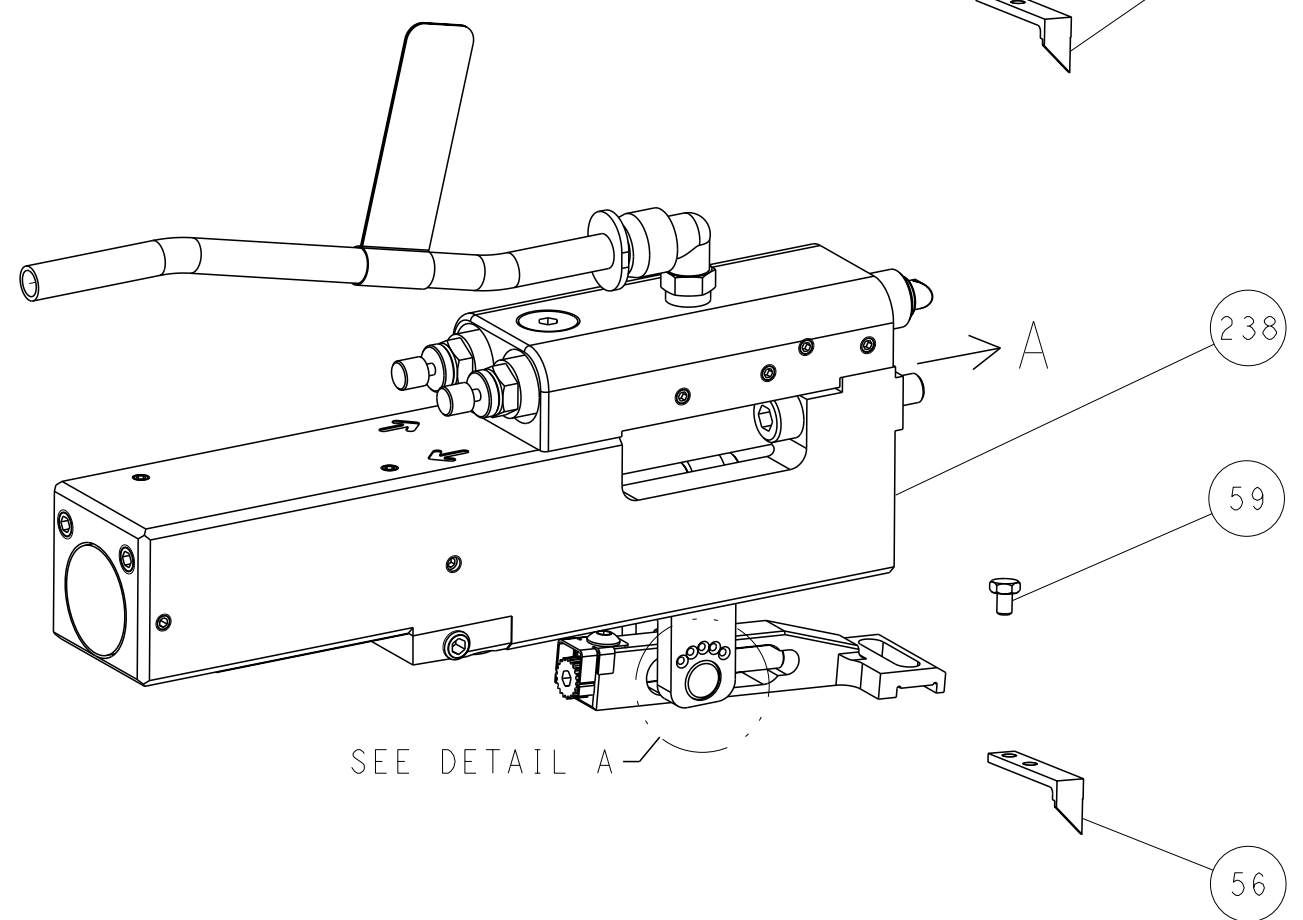


LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

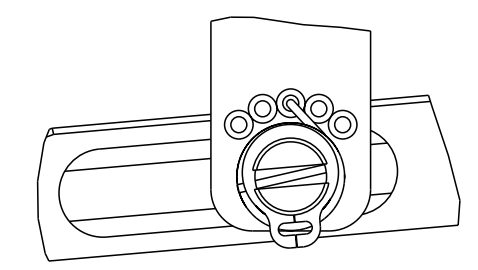
FEED TYPE MECHANICAL



PNEUMATIC

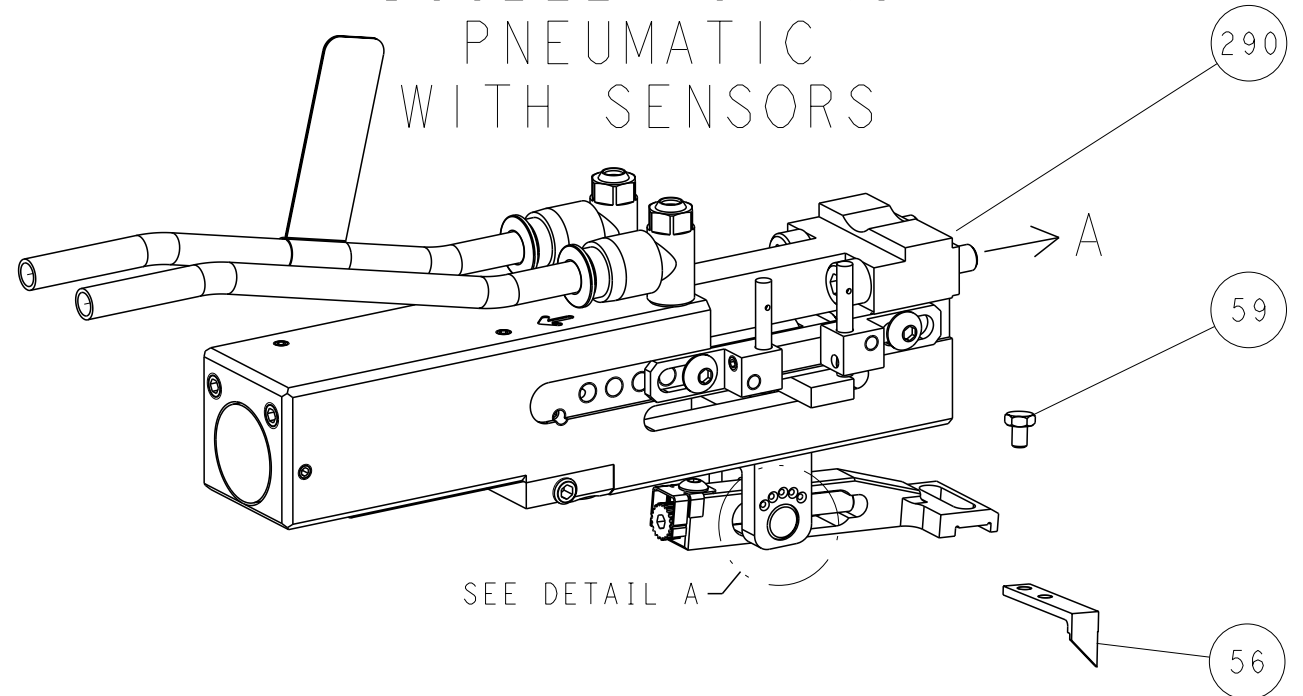


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

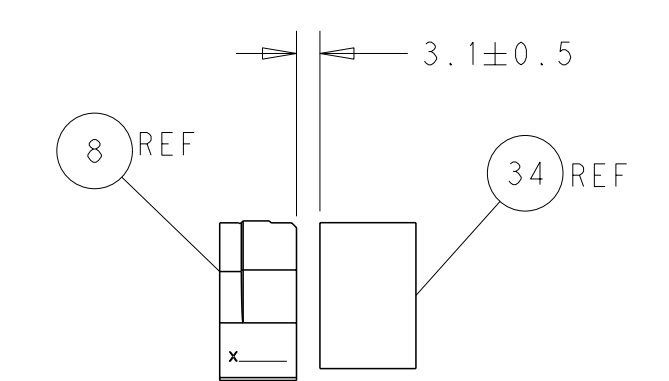
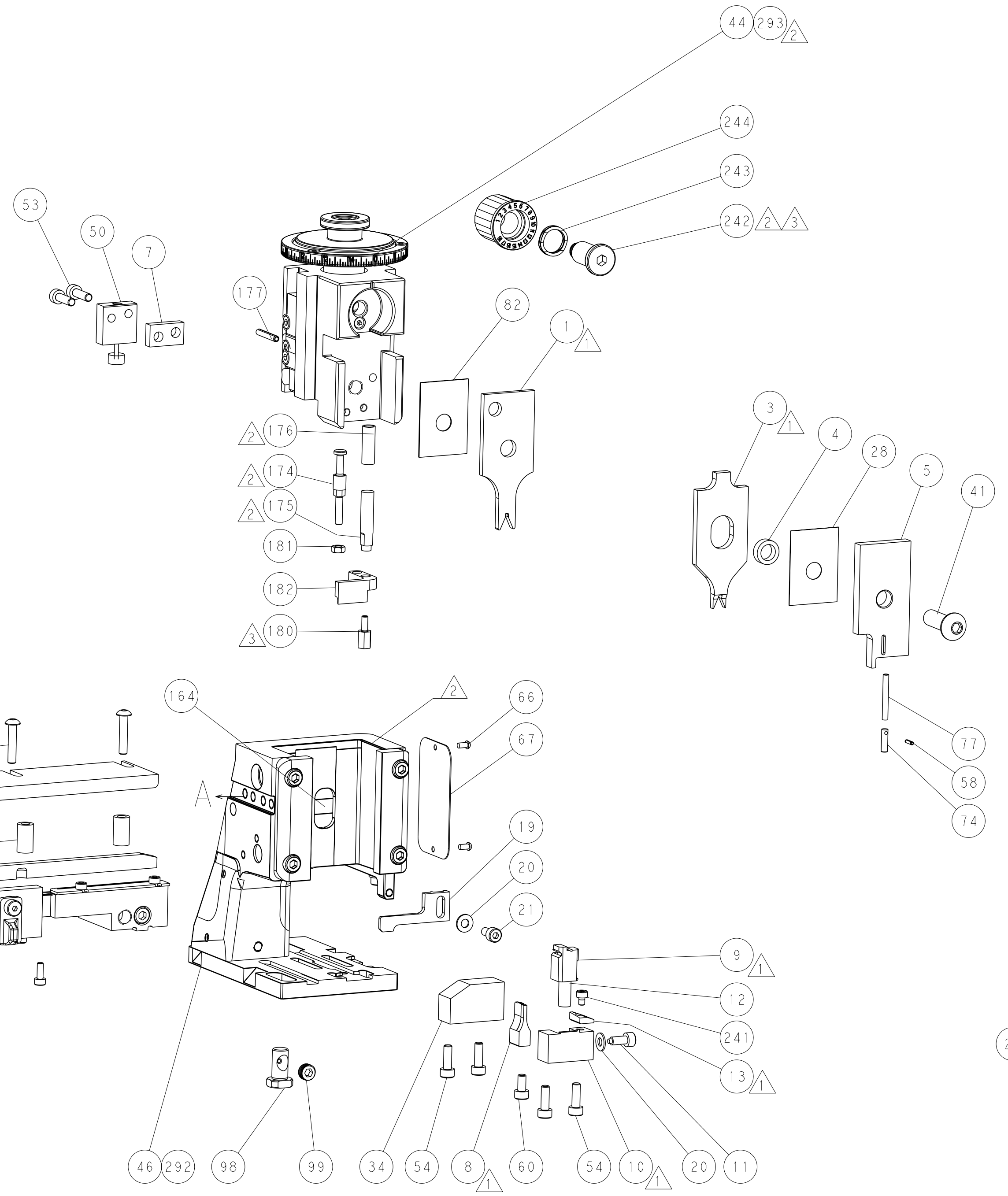
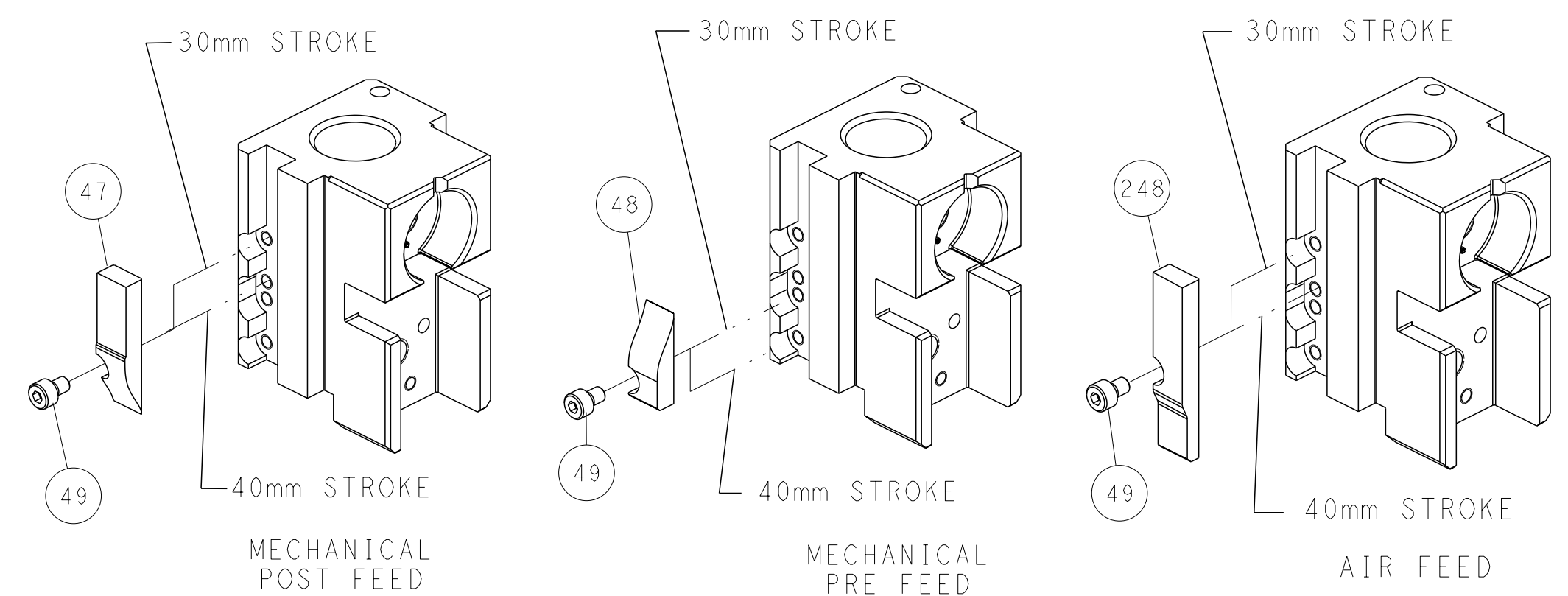


DETAIL A

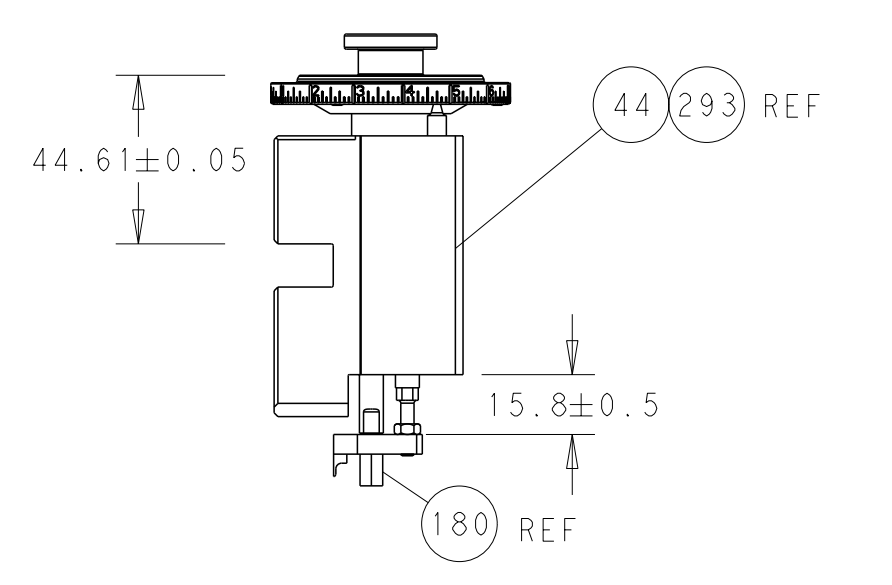
DOUBLE ACTING PNEUMATIC WITH SENSORS



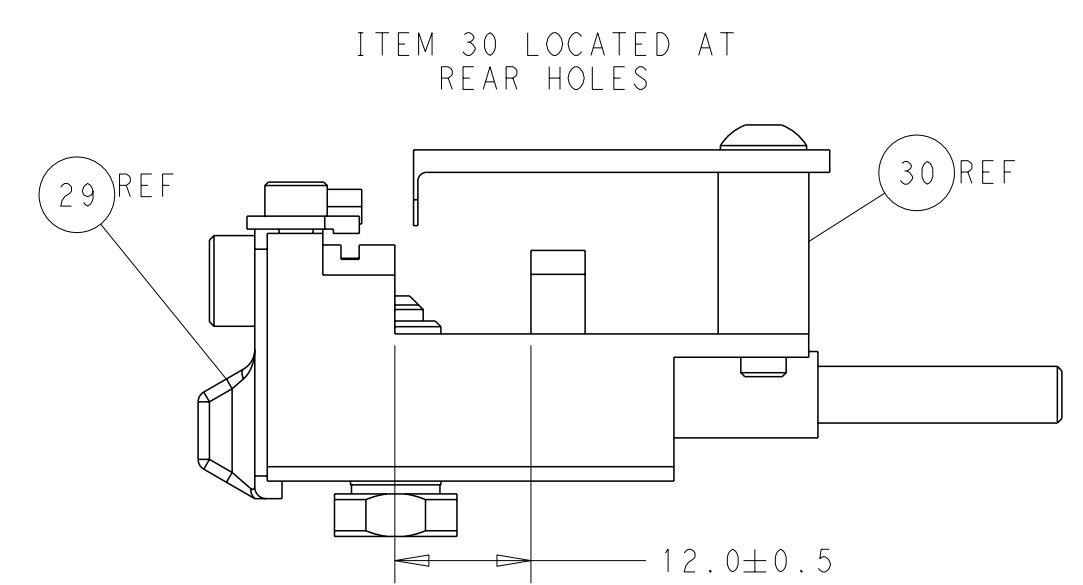
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLD-DOWN SET-UP



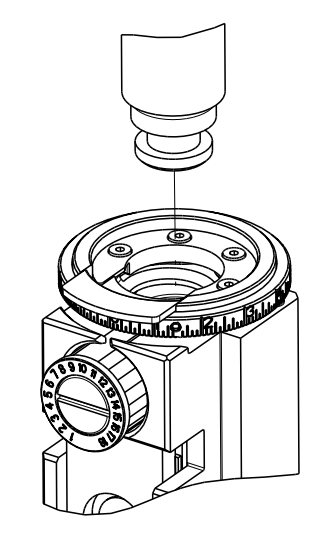
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: C. MOYER 24AUG2011 CHK: T. ELBIN 24AUG2011 APVD: T. ELBIN 24AUG2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151300	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: M	RESTRICTED TO: -	Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151300-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151300-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151300-2	M	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151300-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	SPECIAL
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2 MM			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.30-3.90 mm [.130-.154 IN]	Ø1.40-1.90 mm [.055-.075 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18464		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1418760-1	1418760-2	1418760-3	5-1418760-1
5-1418760-2	5-1418760-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.05+/-0.03 [.041+/-0.001]	6.7
0.5mm2 OR 20 AWG	0.93+/-0.03 [.037+/-0.001]	7.9

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	-	-	2844950-1	AIR FEED MODULE		290
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		269
-	1	1	1	1-1633782-1	FENCE		267
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	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	REF	994970-2	COUNTER, MAGNETIC		164
-	-	1	-	2119641-2	FEED CAM, AIR FEED		151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		143
-	-	-	1	2119653-2	FEED CAM, POST FEED		142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC		140
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	1	1	2844908-1	SCREW, LOCKING		99
-	1	1	1	2844907-1	POST, LOCKING		98
-	1	1	1	455888-5	SPACER, CRIMPER		82
-	1	1	1	5-547505-2	SPRING, COMPRESSION		77
-	1	1	1	854769-5	HOLDER, INS		74
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE		71
-	1	1	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250		58
-	1	1	1	1338685-1	PAWL, FEED		56
-	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14		53
-	1	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	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	1	1	1	1752356-3	SUPPORT, TERMINAL		34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE		29
-	1	1	1	455888-3	SPACER, CRIMPER		28
-	1	1	1	1320928-6	STRIP GUIDE		24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED		19
-	1	1	1	2119806-1	INSERT, SHEAR		13
-	1	1	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1	1	1-356885-4	STOP, SHEAR		11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	1	1	1633861-4	SHEAR, FLOATING		9
-	1	1	1	1333231-5	ANVIL, COMBINATION, SPECIAL		8
-	1	1	1	5-240641-0	SPACER		7
-	1	1	1	1-2119780-1	DEPRESSOR, SHEAR		5
-	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER		4
-	1	1	1	1633989-1	CRIMPER, INSULATION, SPECIAL		3
-	1	1	1	3-1633730-2	CRIMPER, WIRE		1

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

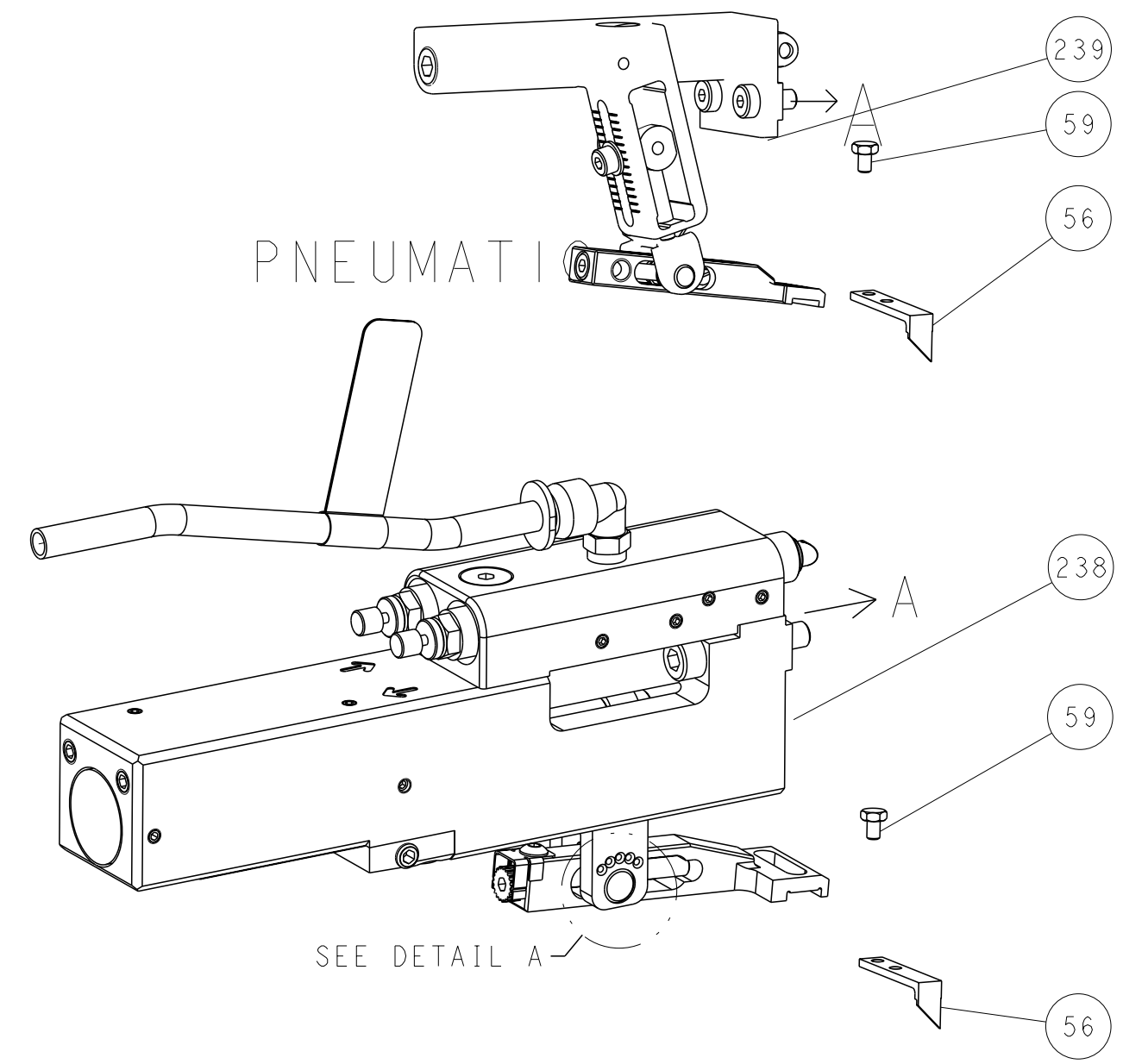
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN C. MOYER 24AUG2011 CHK T. ELBIN 24AUG2011 APVD T. ELBIN 24AUG2011 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151300 RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 3 OF 4 REV M	

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

FEED TYPE

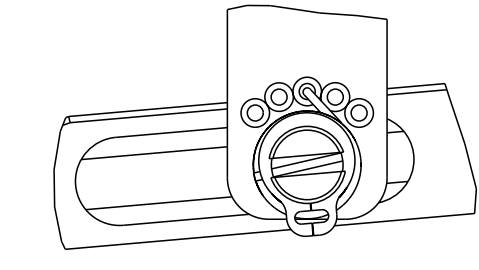
MECHANICAL

PNEUMATIC



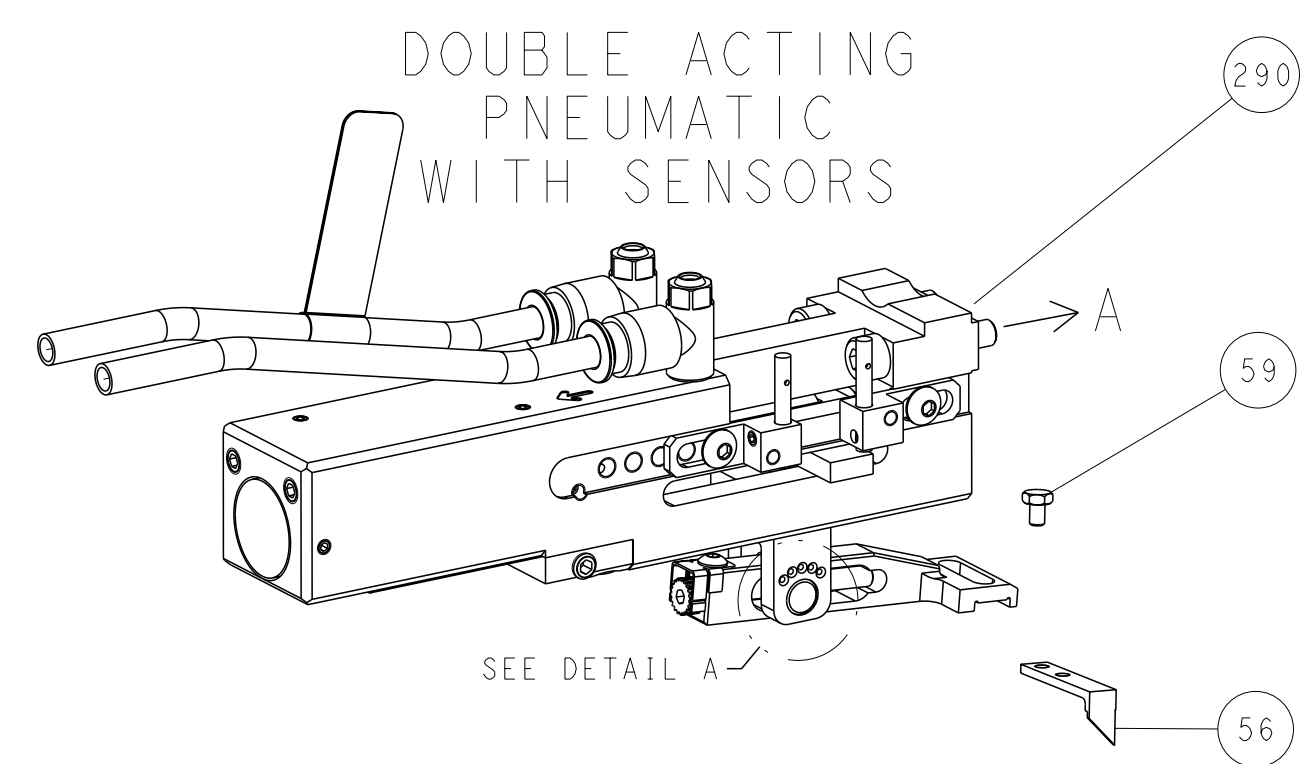
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



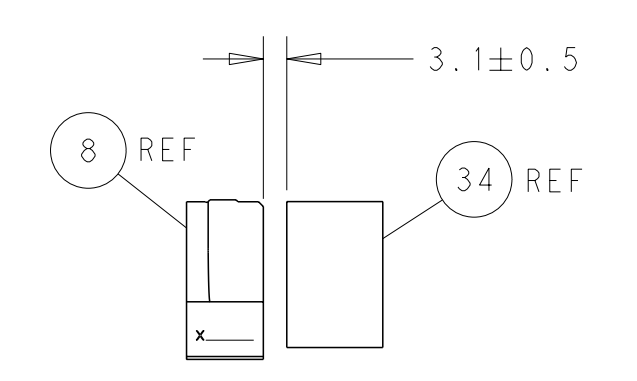
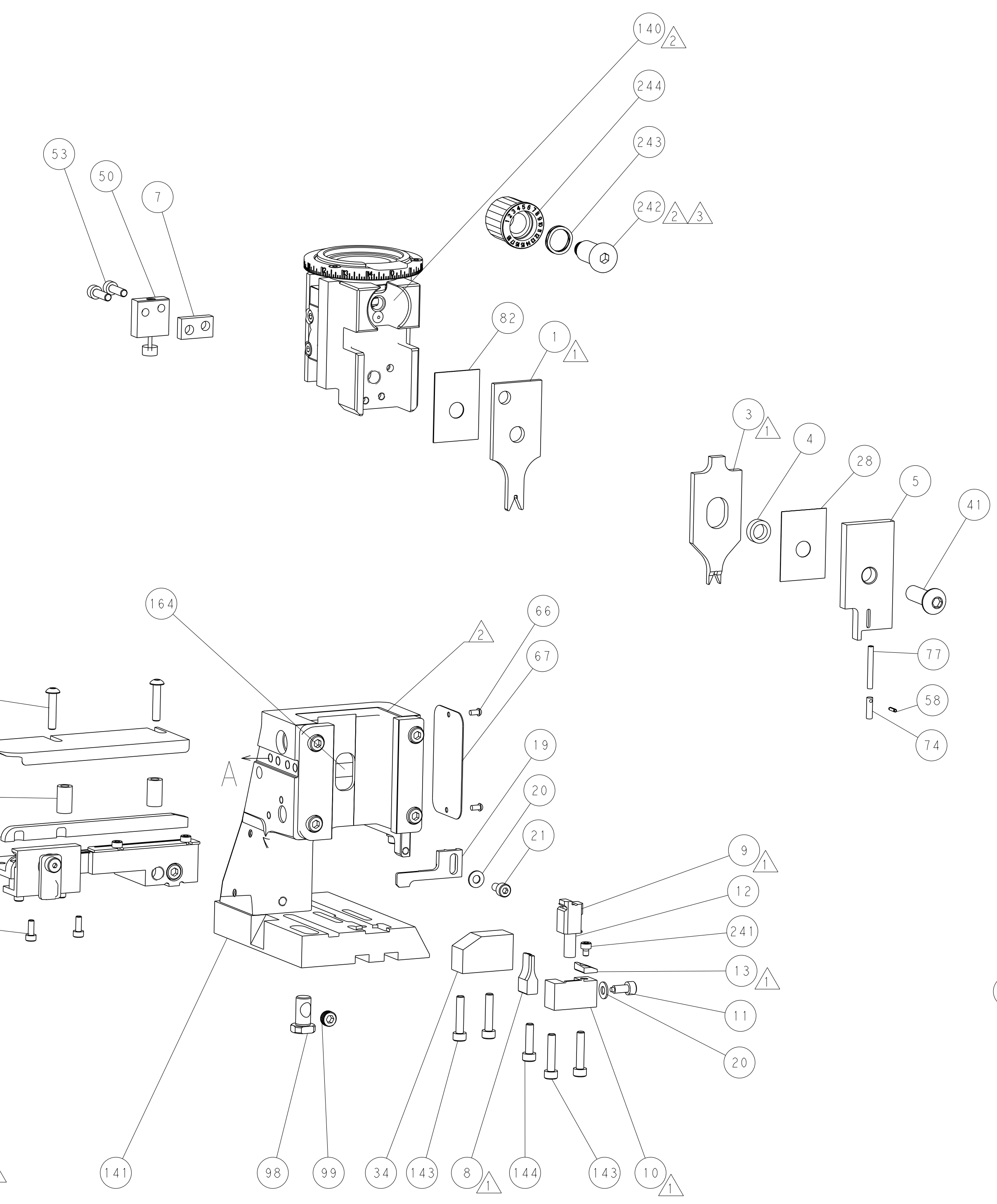
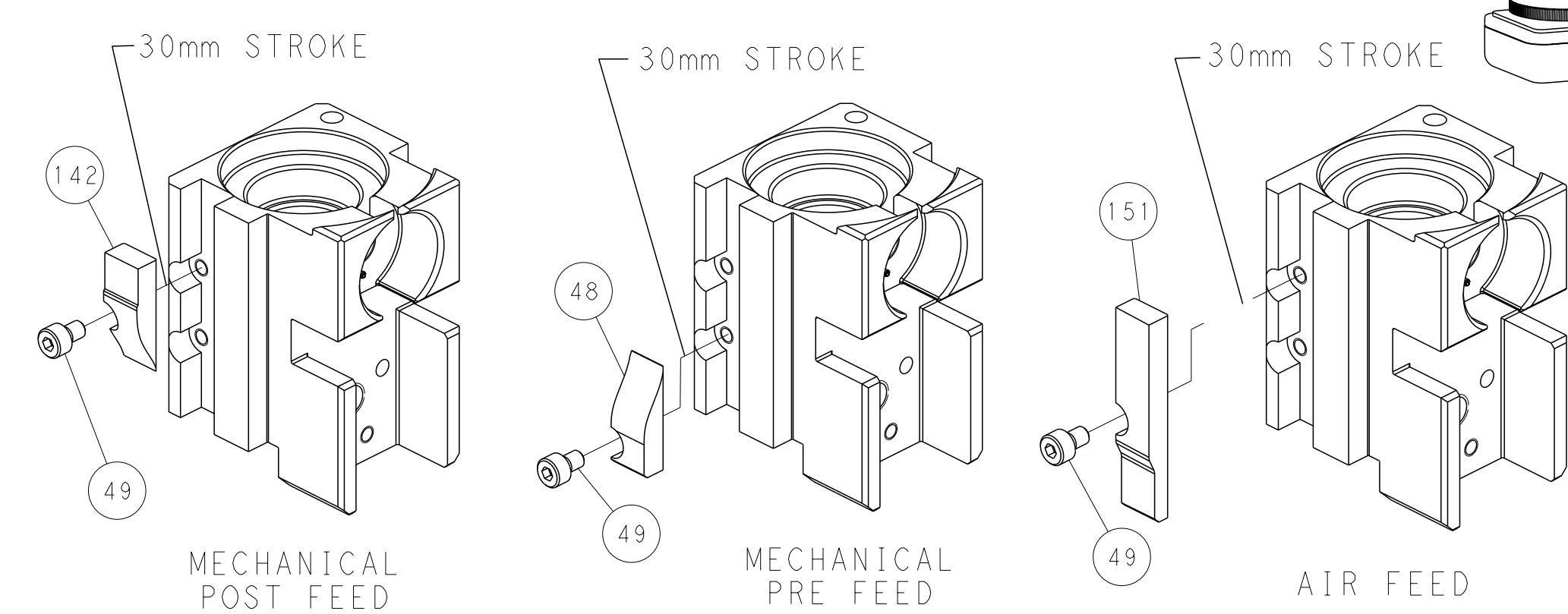
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

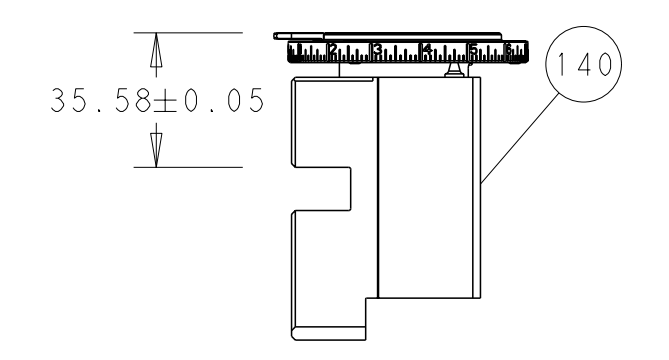


SEE DETAIL A

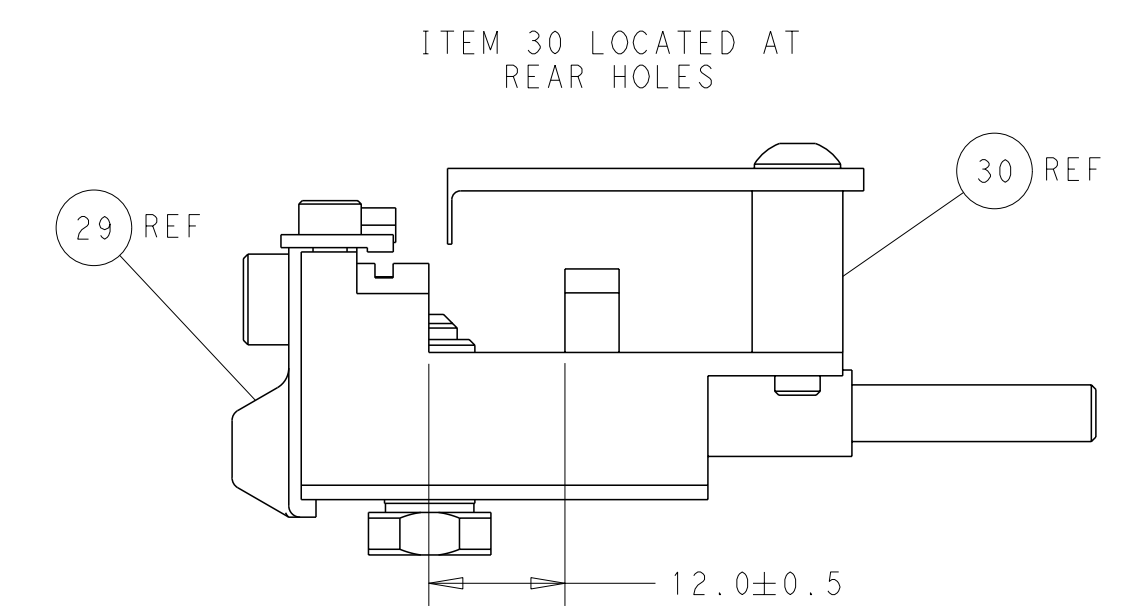
CAM POSITIONS



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 TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151300	RESTRICTED TO: M SHEET 4 OF 4