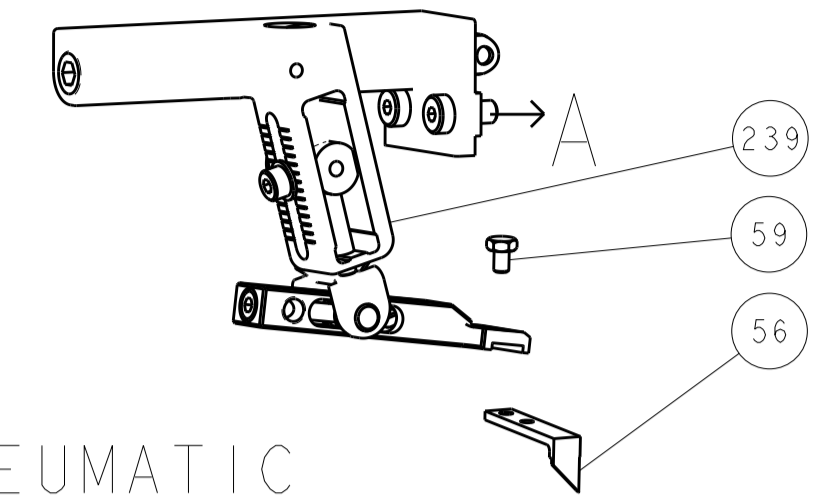


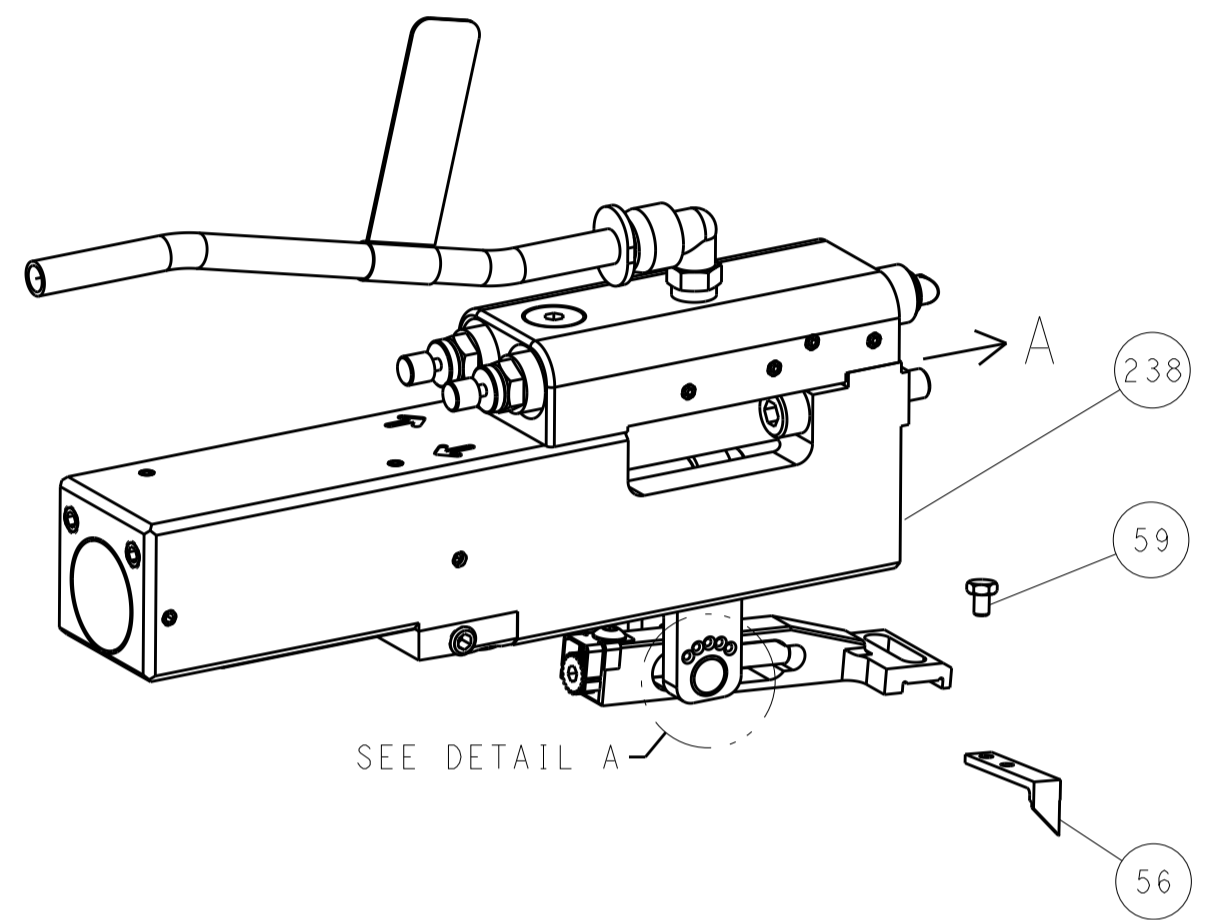


LOC		DIST		REVISIONS			
A	66	P	LYN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

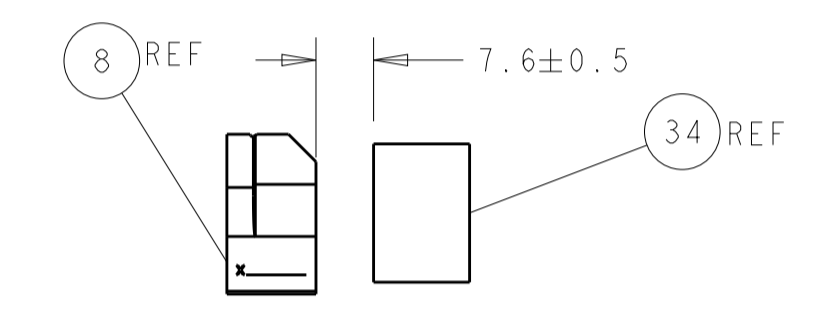
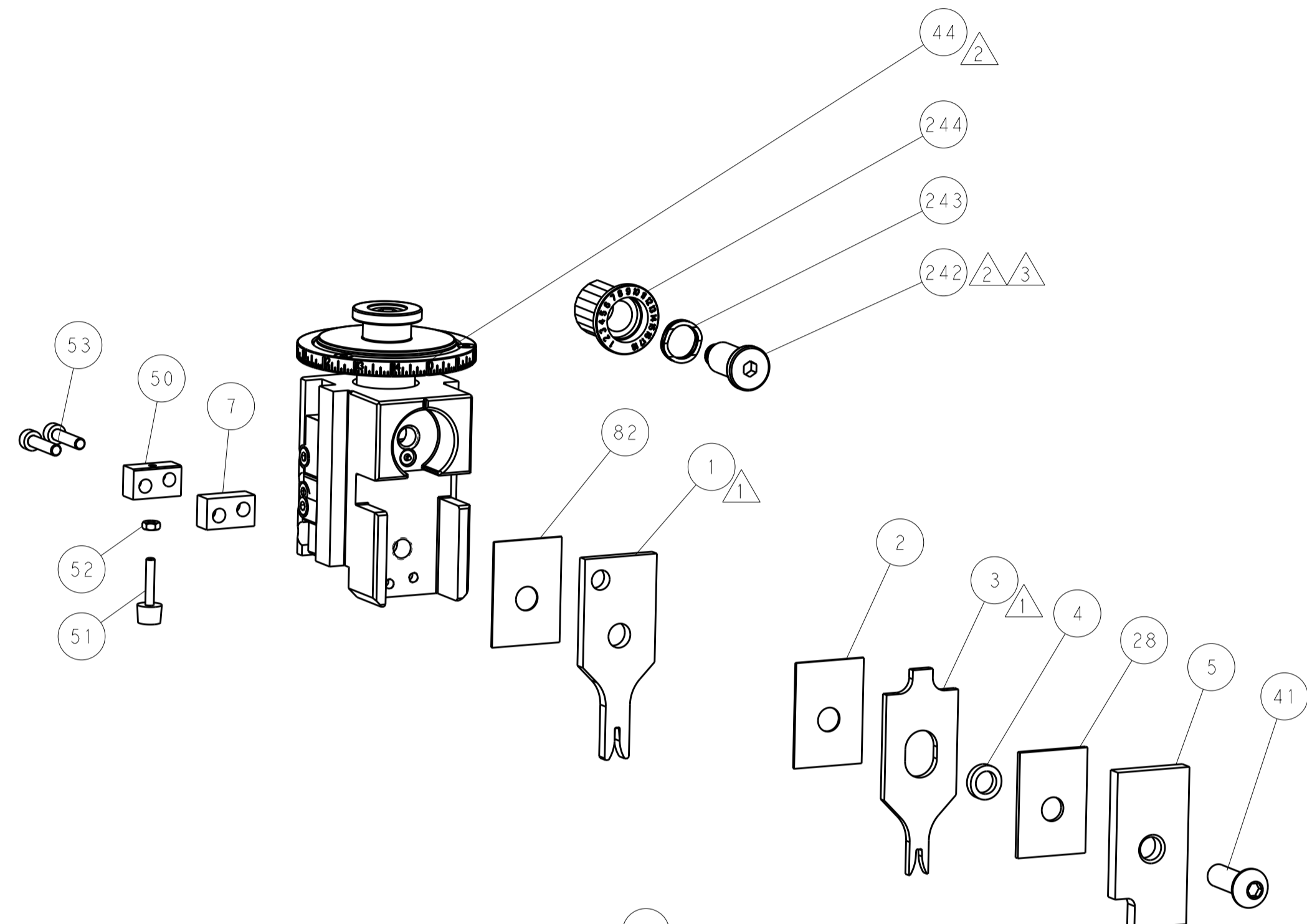
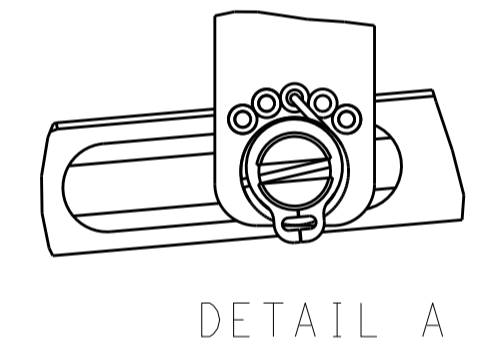
# FEED TYPE MECHANICAL



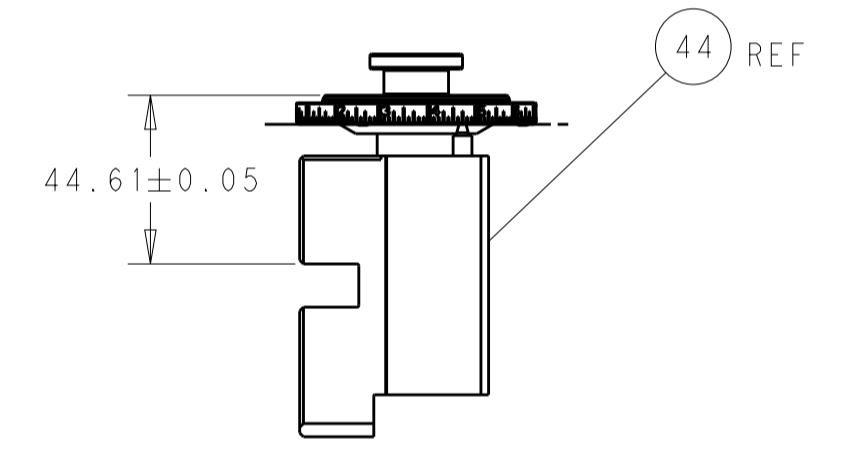
## PNEUMATIC



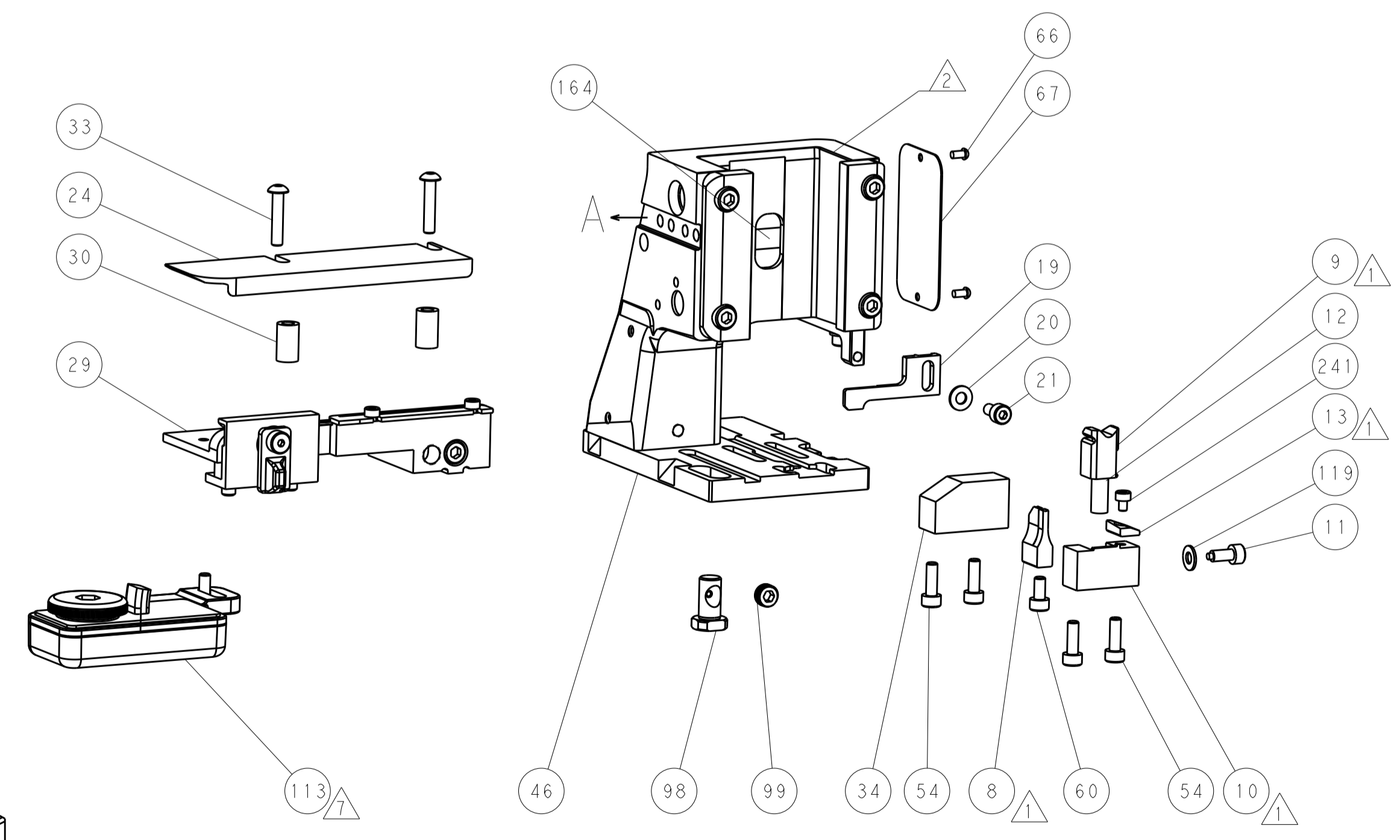
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



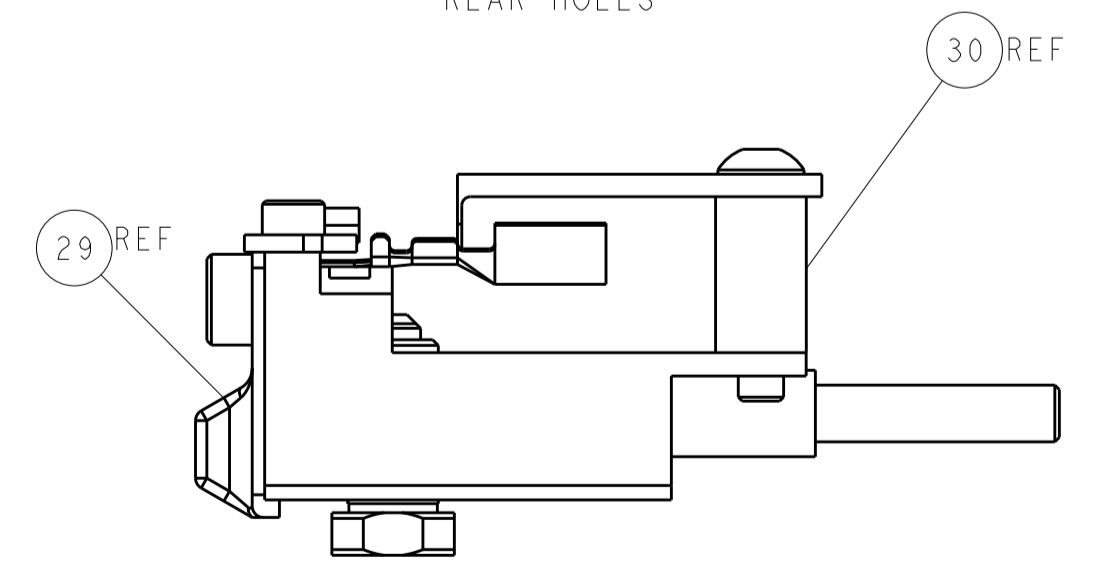
TERMINAL SUPPORT LOCATION



RAM SET-UP



ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE 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 R. HUANG 31 JUL 2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD S. XI 31 JUL 2012	NAME Ocean Side Feed Applicator
MATERIAL		FINISH		WEIGHT		SIZE A1 00779 ©=2151694	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151694-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151694-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151694-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DIA 2,5MM SYSTEM CONTACT SOCKET			
WIRE STRIP LENGTH 5.20-5.80 mm [1.205-.228 IN]		INSULATION DIAMETER RANGE Ø1.00-1.60 mm [1.039-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18031-1		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928972-2	928972-3	928972-4	928972-5
928973-2	928973-3	928973-4	2-928973-2
2-928973-3	928974-2	928974-4	928974-5
928975-2	928975-3	928975-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.11+/-0.03 [1.044+/-0.001]	6.5
0.25mm2	1.07+/-0.03 [1.042+/-0.001]	7.1
0.20mm2	1.05+/-0.03 [1.041+/-0.001]	7.4

- 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 INSULATION CRIMP HEIGHT SPECIFIED IN 114-18031-1 IS ONLY PERTINENT IF APPLICATION IS SPECIFIC FOR BMW. ALL OTHER APPLICATIONS SHOULD BE SET TO OPTIMUM INSULATION CRIMP HEIGHT RELATIVE TO INSULATION DIAMETER BEING USED.
- 6 CUT TO LENGTH AT ASSEMBLY.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-6	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	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	1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-5	SPACER, CRIMPER	28
-	1	1	1320928-2	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1-1333202-6	ANVIL, COMBINATION	8
-	1	1	6-240641-8	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	3-2119582-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	3-456403-7	CRIMPER, WIRE PREMIUM	1

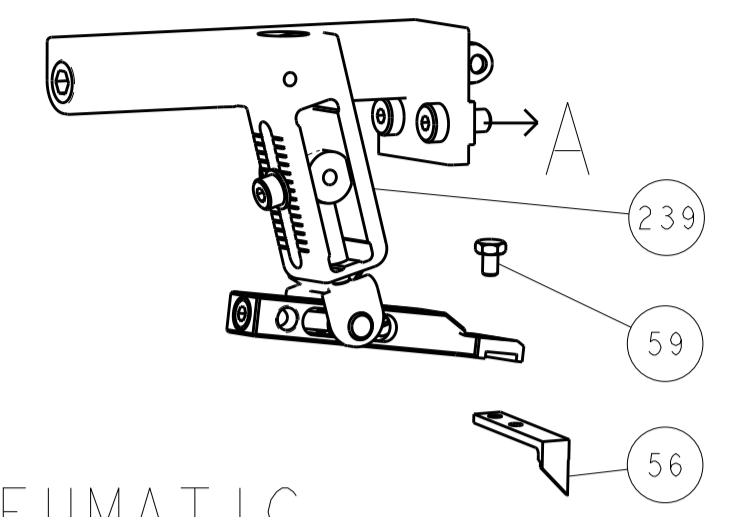
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN H. HUANG 31 JUL 2012		CHK S. XI 31 JUL 2012		APVD S. XI 31 JUL 2012		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	PRODUCT SPEC		APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
MATERIAL	FINISH	WEIGHT		SCALE		SHEET		OF		REV	
		A1 00779		C=2151694		3		4		D	

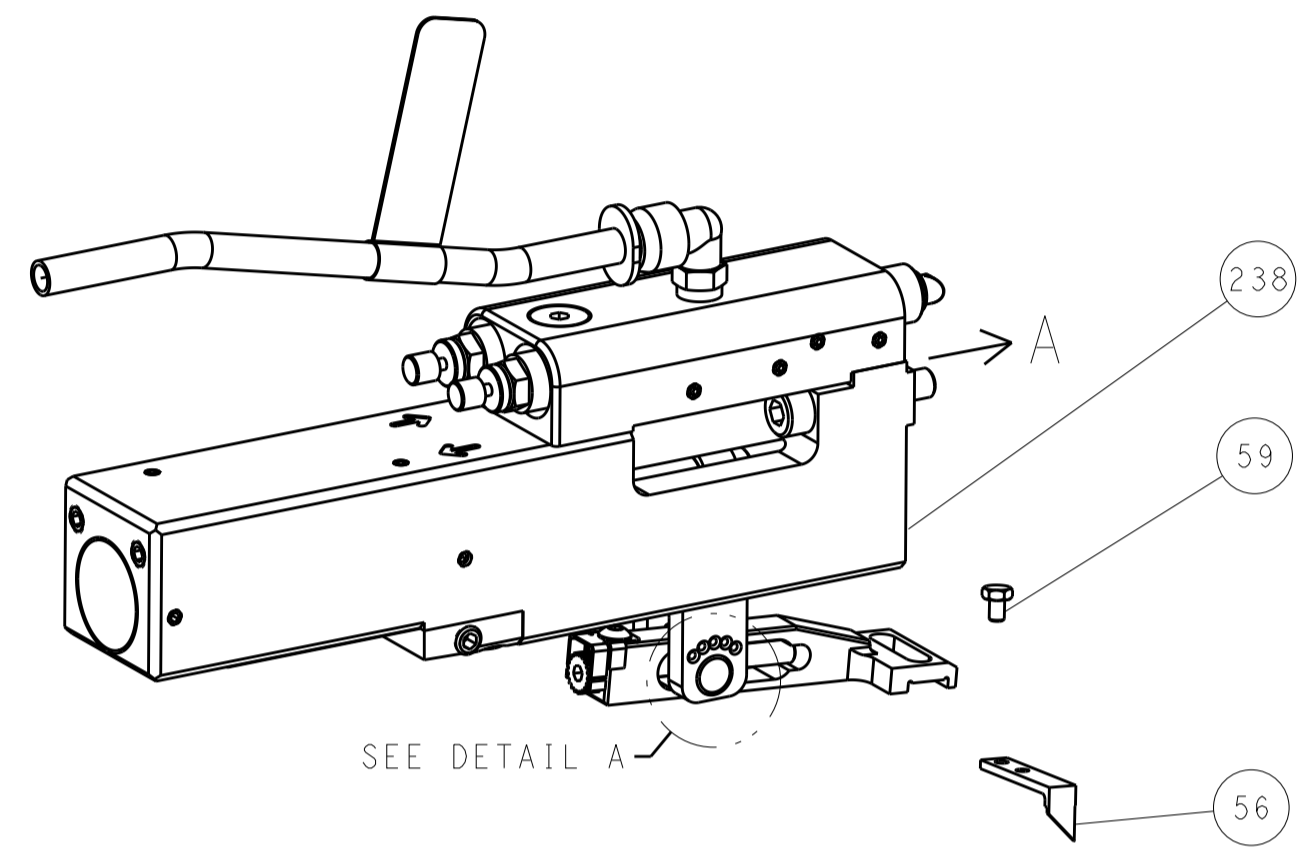
Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APPV
A	66				

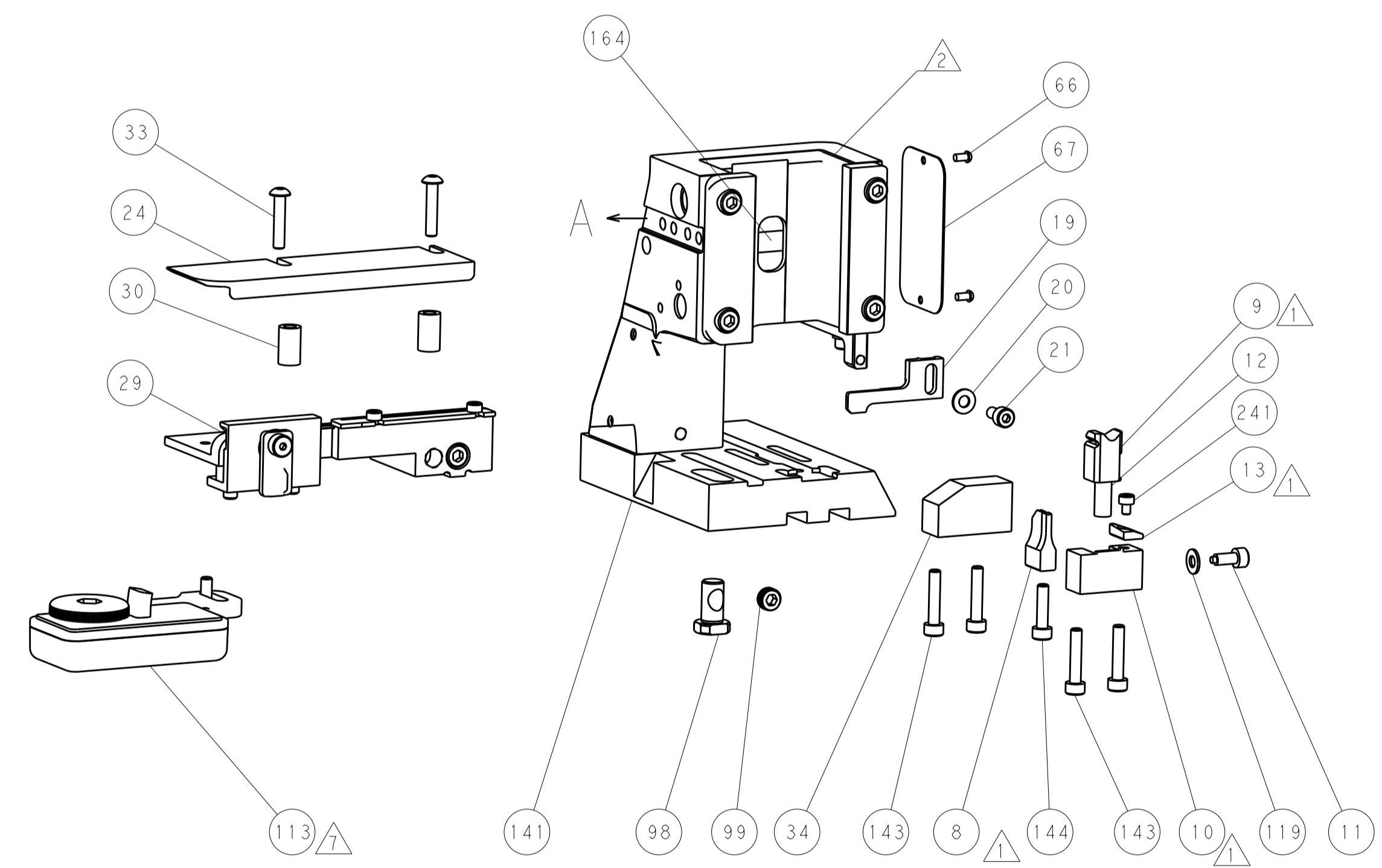
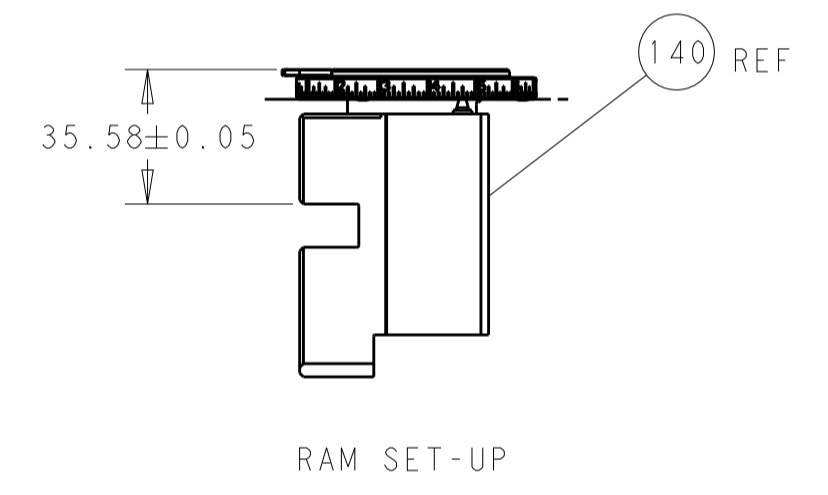
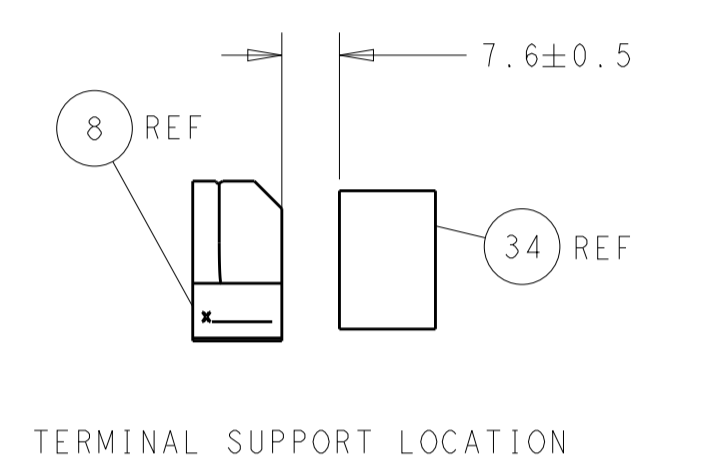
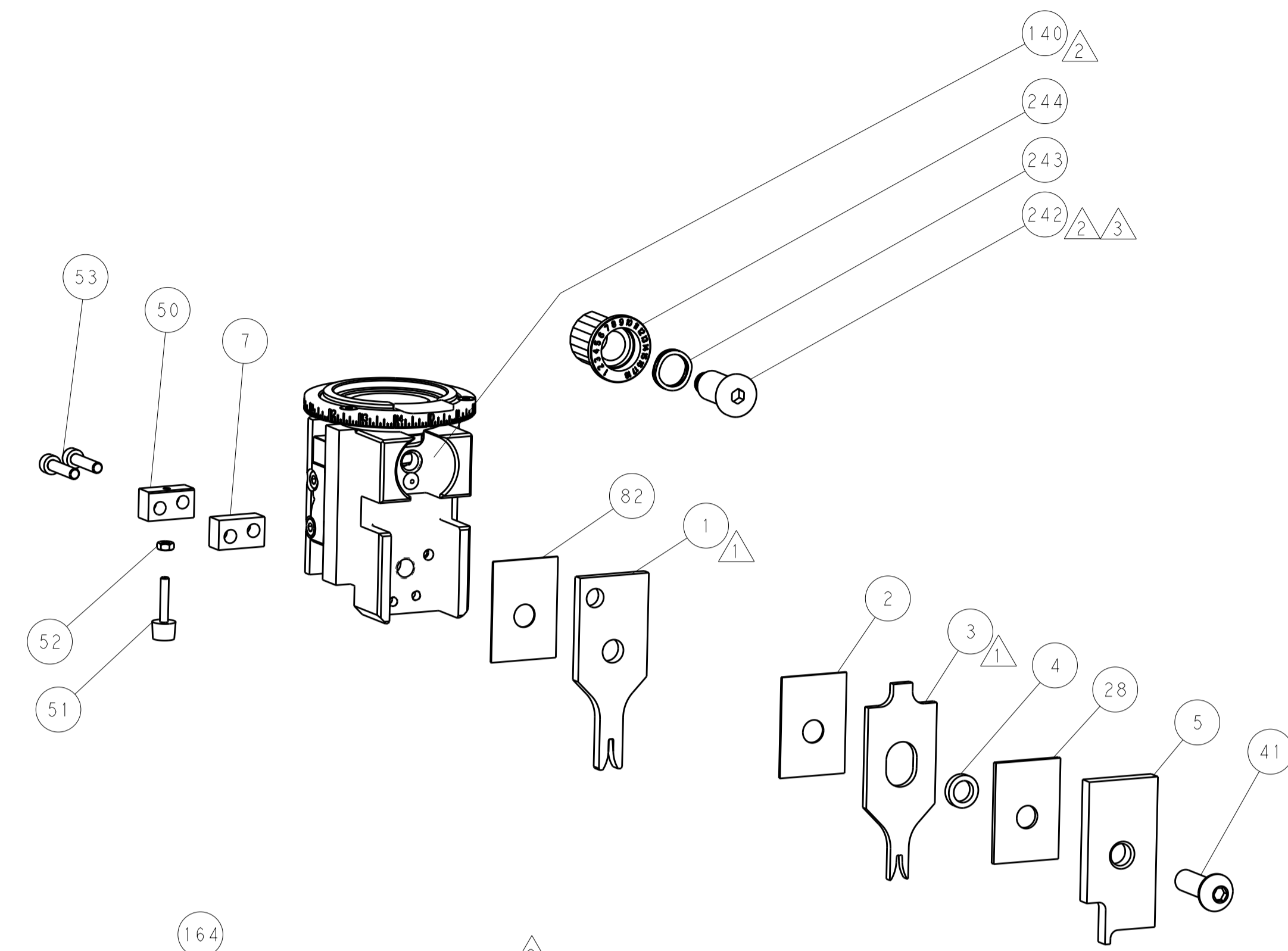
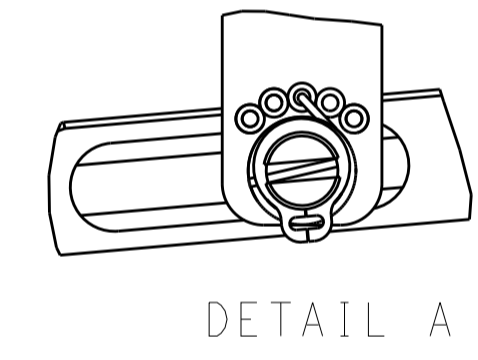
# FEED TYPE MECHANICAL



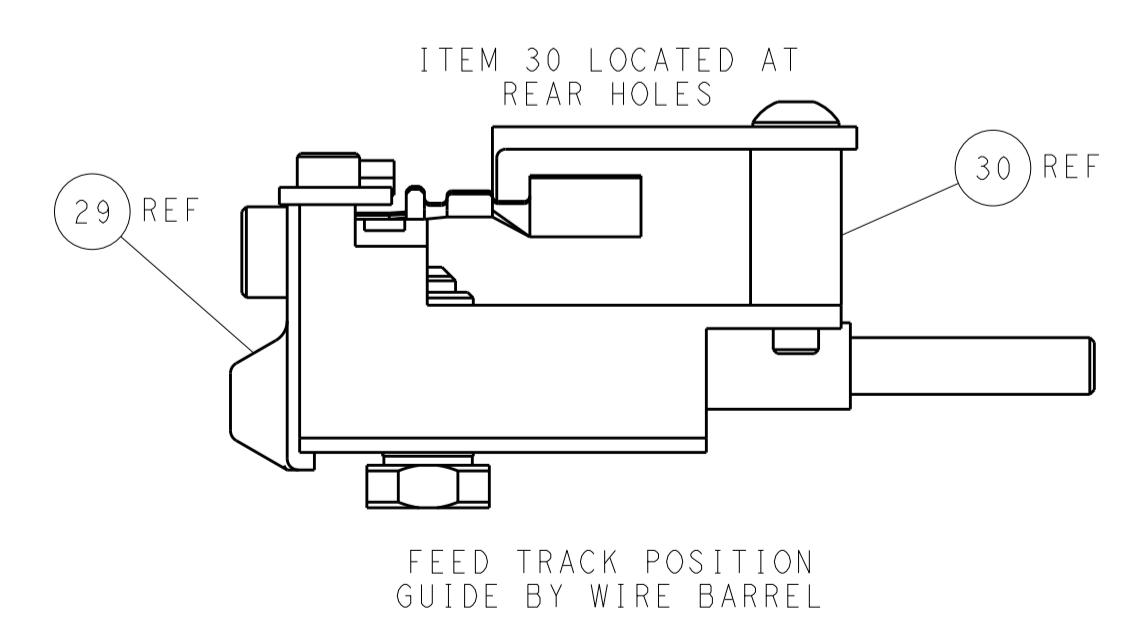
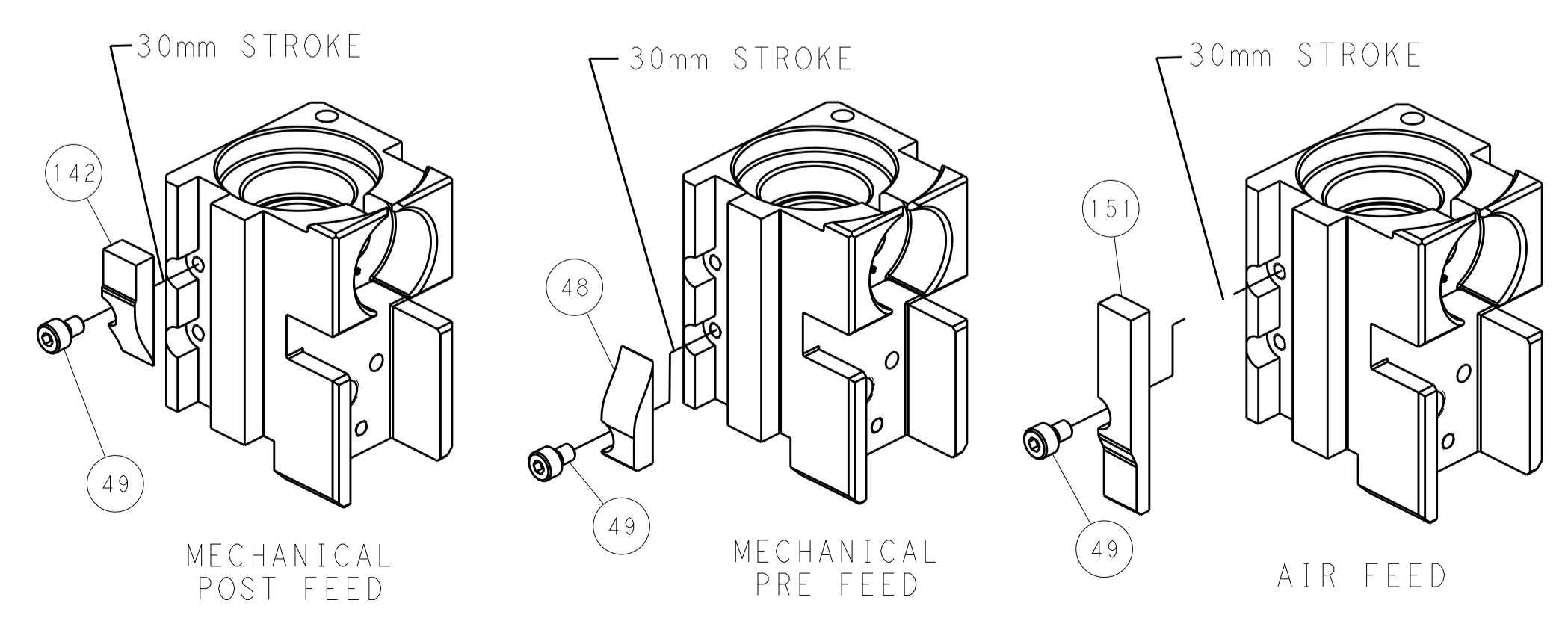
# PNEUMATIC



# 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: H. HUANG 31 JUL 2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK: S. XI 31 JUL 2012	NAME: Ocean Side Feed Applicator	SIZE: A1	CAGE CODE: 00779
	1 PLC	±		APPV: S. XI 31 JUL 2012	RESTRICTED TO:	SCALE: 1:2	SHEET 4 OF 4
	2 PLC	±		PRODUCT SPEC:			
	3 PLC	±		APPLICATION SPEC:			
	4 PLC	±		WEIGHT:			
	ANGLES	±		MATERIAL:			
	FINISH	±		Customer Accessible Production Drawing			