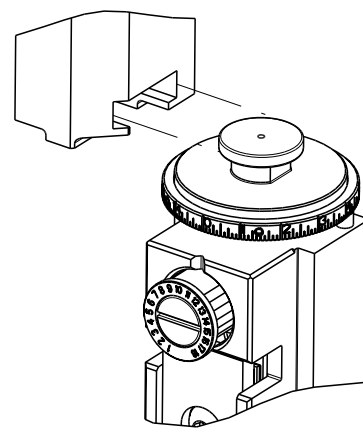


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151562-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151562-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151562-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 4.8 mm TAB WITH DOUBLE LL			
WIRE STRIP LENGTH 4.80-5.60 mm [.189-.220 IN]		INSULATION DIAMETER RANGE Ø2.10-3.00 mm [.083-.118 IN]	
TERMINAL APPLICATION 		114-18022	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
962904-1	962904-2	962884-1	962884-2

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
2.50mm2			1.97+/-0.05 [0.078+/-0.002]		5.8
2.00mm2			1.83+/-0.05 [0.072+/-0.002]		7.3
1.50mm2			1.69+/-0.05 [0.067+/-0.002]		8.9



 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

6 FEED ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

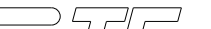
ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

ATLANTIC VERSION

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

2				I			
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD
			2	DEVELOPMENT	27MAR2013	KH	UG
			A	RELEASED	07AUG2013	BH	TE
			B	ECR-19-000440	10JAN2019	JAH	TE

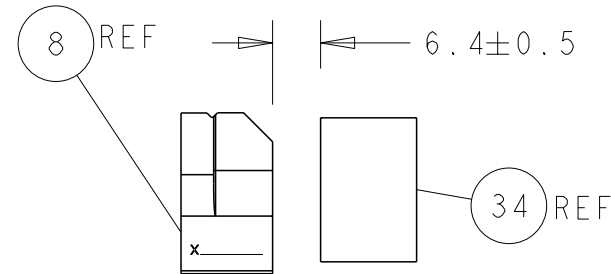
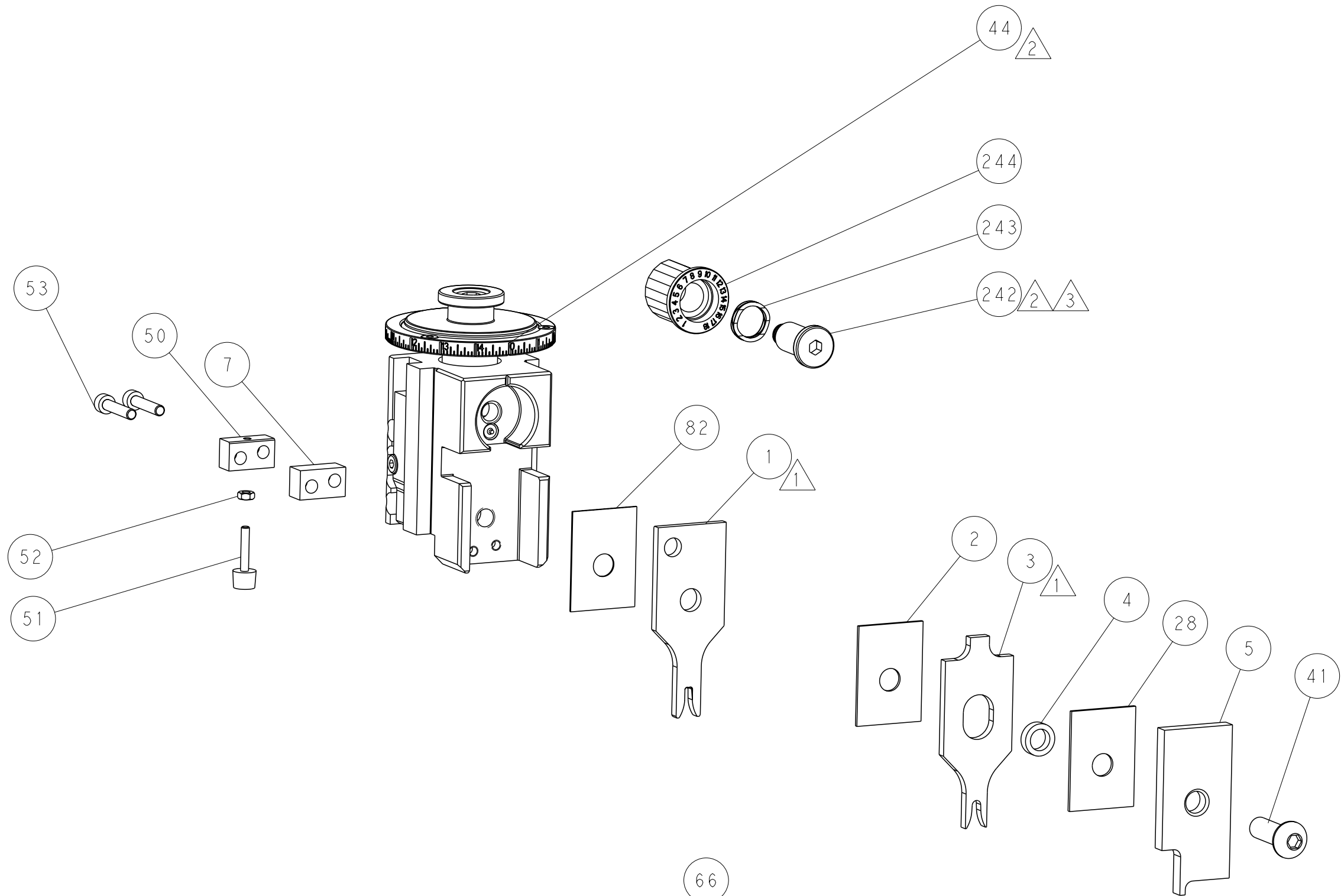
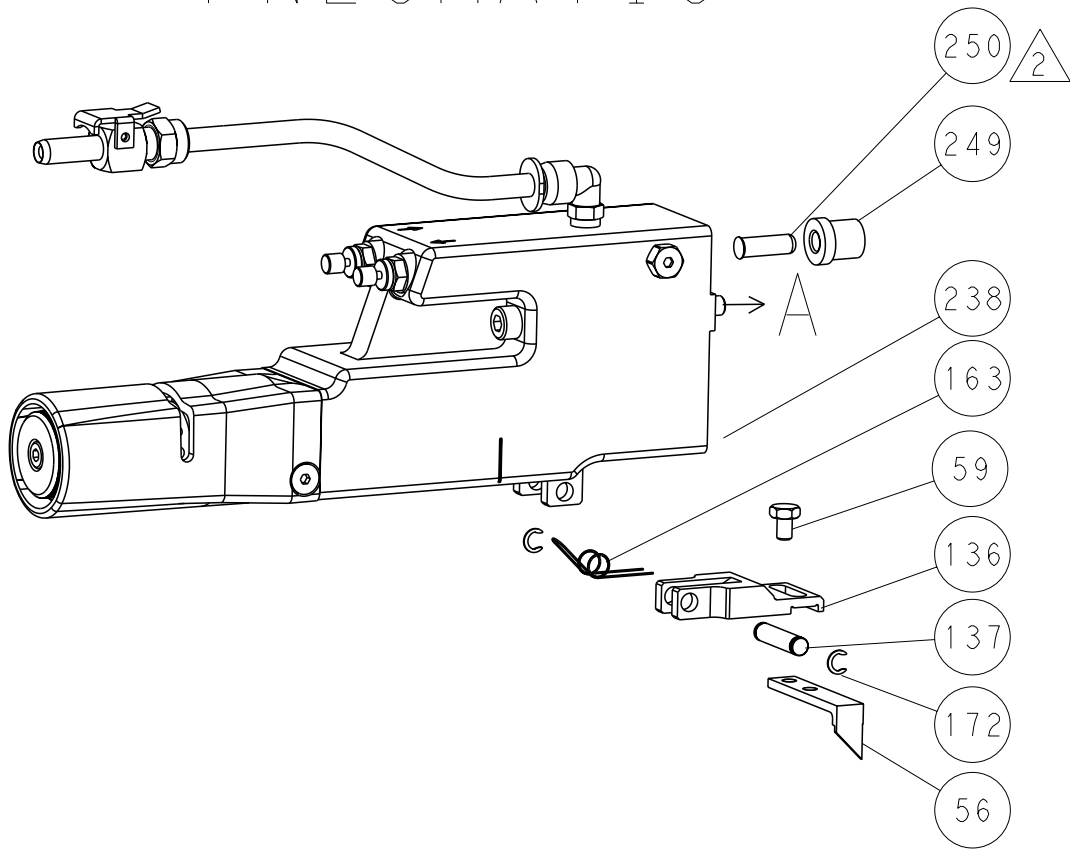
	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	1	2063440-1	AIR FEED MODULE	238
	-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	163
	-	1	1	240638-1	SPRING, FEED FINGER	163
	-	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	1	2119799-1	HOLDER, FEED FINGER, AF	136
	-	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	1803607-1	DOCUMENTATION PACKAGE	71
	-	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
	-	-	-	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
	-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	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	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1-455888-0	SPACER, CRIMPER	28
	-	1	1	1320928-6	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	1	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	1	2	1	1333207-7	ANVIL, COMBINATION .110	8
	-	1	1	8-240641-5	SPACER	7
	-	-	-	-	-	6
	-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
	-	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	1	1633965-9	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-9	SPACER, CRIMPER	2
1	1	2	1	2-456408-0	CRIMPER, WIRE PREMIUM	1

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC COMPONENTS DIVISION OF TE CONNECTIVITY. ANY CHANGES, REVISIONS, OR CANCELLATIONS OF THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN K. HUANG 19JUN2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD S. XI 19JUN2012	
		PRODUCT SPEC -		Ocean Side Feed Applicator -	
		APPLICATION SPEC -		SIZE CAGE CODE DRAWING	
MATERIAL -		FINISH -		A1 00779 C=2151562	
		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 1 OF 4 REV B	

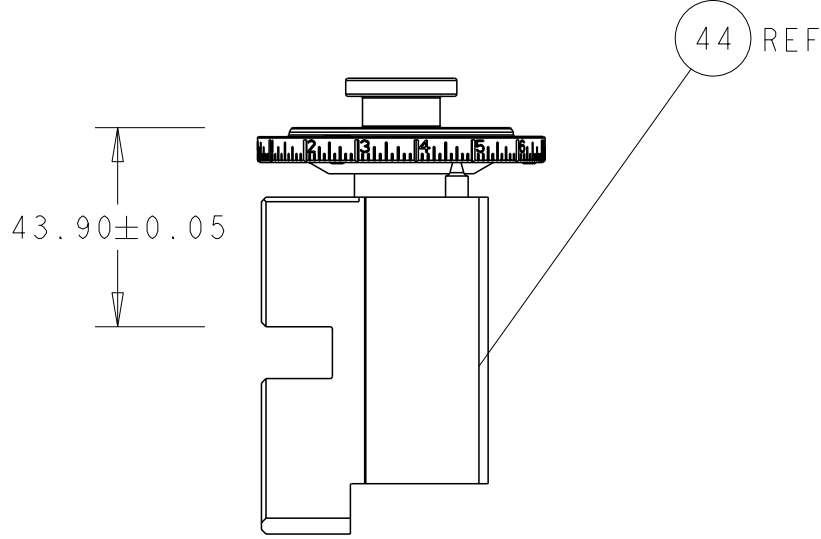
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

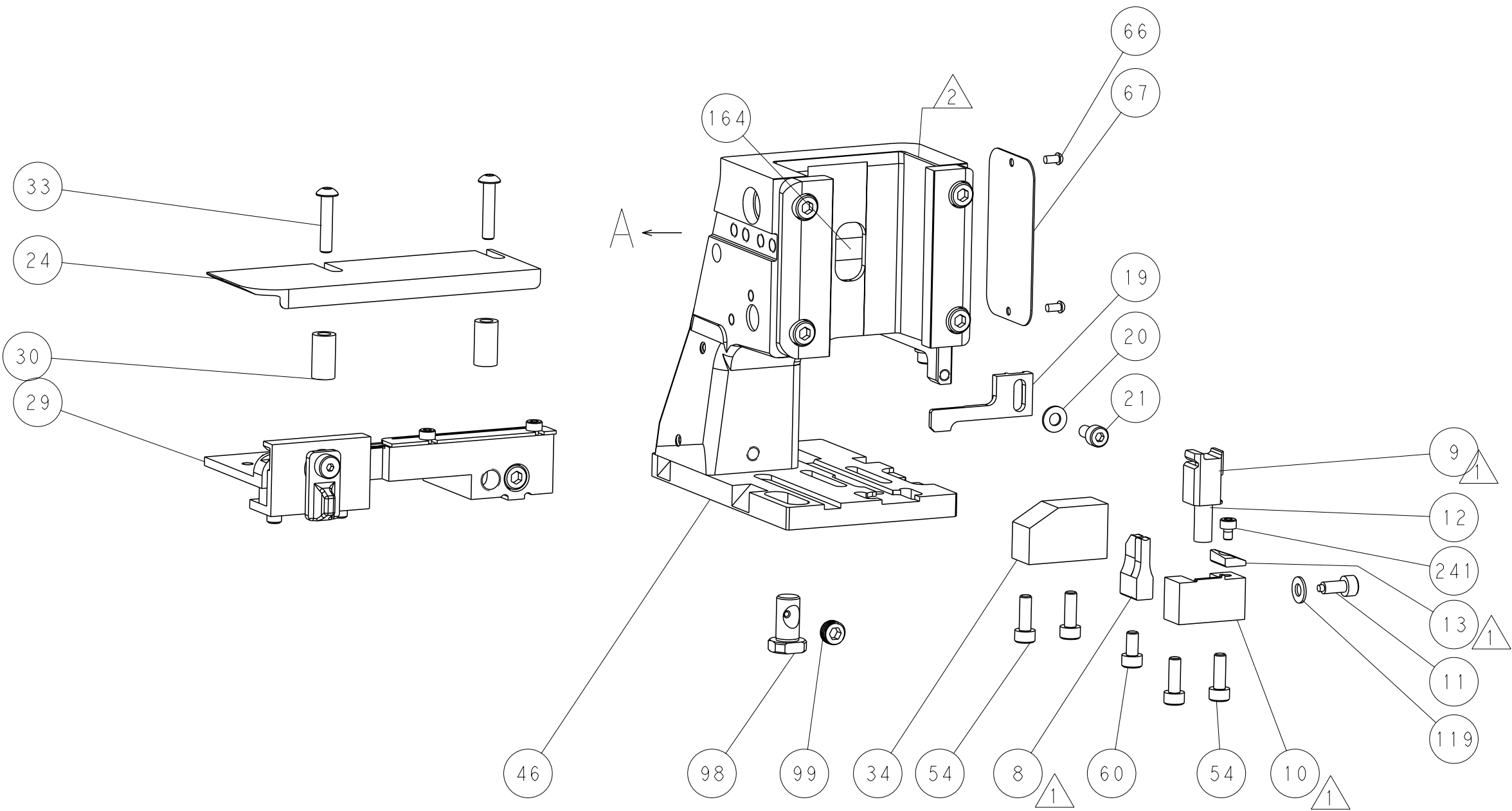
PNEUMATIC



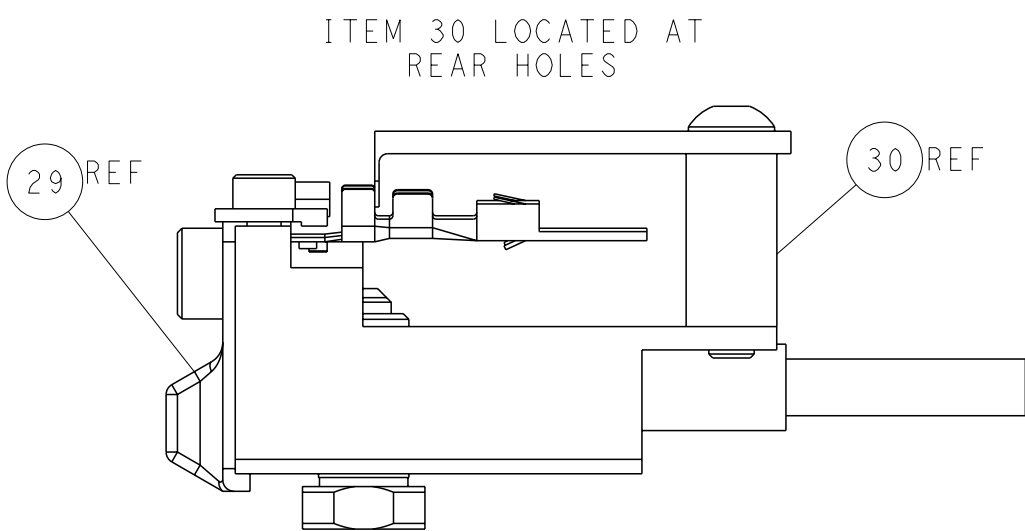
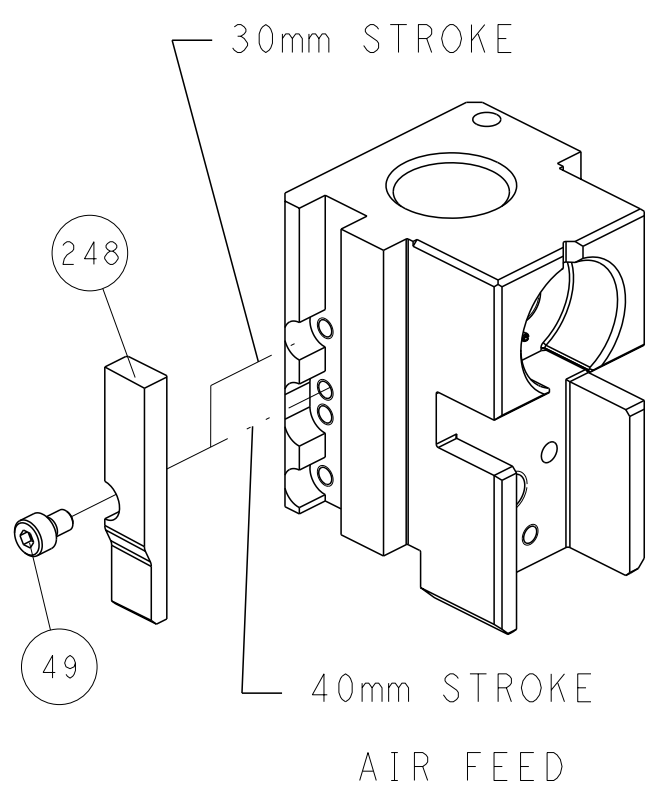
TERMINAL SUPPORT LOCATION



RAM SET-UP



CAM POSITION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

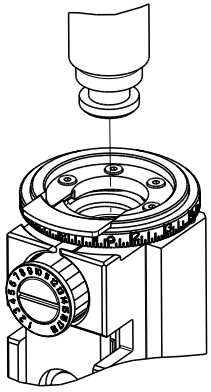
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN K. HUANG 19JUN2012	TE Connectivity Harrisburg, PA 17105-3608	
CHK S. XI 19JUN2012		NAME		
APVD S. XI 19JUN2012		PRODUCT SPEC	Ocean Side Feed Applicator	
APPLICATION SPEC		SIZE	A1 00779 ©=2151562	
MATERIAL		WEIGHT		
FINISH		SCALE	1:2	
Customer Accessible Production Drawing		SHEET	2 of 4	
		REV	B	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8				7			
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20				20			
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PART NUMBER		REVISION		DESCRIPTION		FEED TYPE	
2-2151562-2		B		FINE CRIMP HEIGHT ADJUST		PNEUMATIC	
7-2151562-7		A		CRIMP TOOLING KIT		-	

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 4.8 mm TAB WITH DOUBLE LL			
WIRE STRIP LENGTH 4.80-5.60 mm [.189-.220 IN]			INSULATION DIAMETER RANGE Ø2.10-3.00 mm [.083-.118 IN]
TERMINAL APPLICATION SPECIFICATION		114-18022	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
962904-1	962904-2	962884-1	962884-2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
2.50mm2		1.97+/-0.05 [.078+/- .002]		5.8	
2.00mm2		1.83+/-0.05 [.072+/- .002]		7.3	
1.50mm2		1.69+/-0.05 [.067+/- .002]		8.9	



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 FEED ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.
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.

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

LOC	DIST	REVISIONS				
		P	LYR	DESCRIPTION	DATE	DWN
		-	-	SEE SHEET 1	-	-

-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2063440-1	AIR FEED MODULE	238
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	240638-1	SPRING, FEED FINGER	163
-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-1	DOCUMENTATION PACKAGE	71
-	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
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	811242-5	BUMPER, HOLD DOWN	51
-	1	690753-2	SPACER, TONKER	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1-455888-0	SPACER, CRIMPER	28
-	1	1320928-6	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	462006-6	FLOATING SHEAR, FRONT	9
-	1	1333207-7	ANVIL, COMBINATION .110	8
-	1	8-240641-5	SPACER	7
-	-	-	-	6
-	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	3-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1633965-9	CRIMPER, INSULATION O PREMIUM	3
-	1	455888-9	SPACER, CRIMPER	2
-	1	2-456408-0	CRIMPER, WIRE PREMIUM	1
-	77	-22	PART NO	ITEM NO

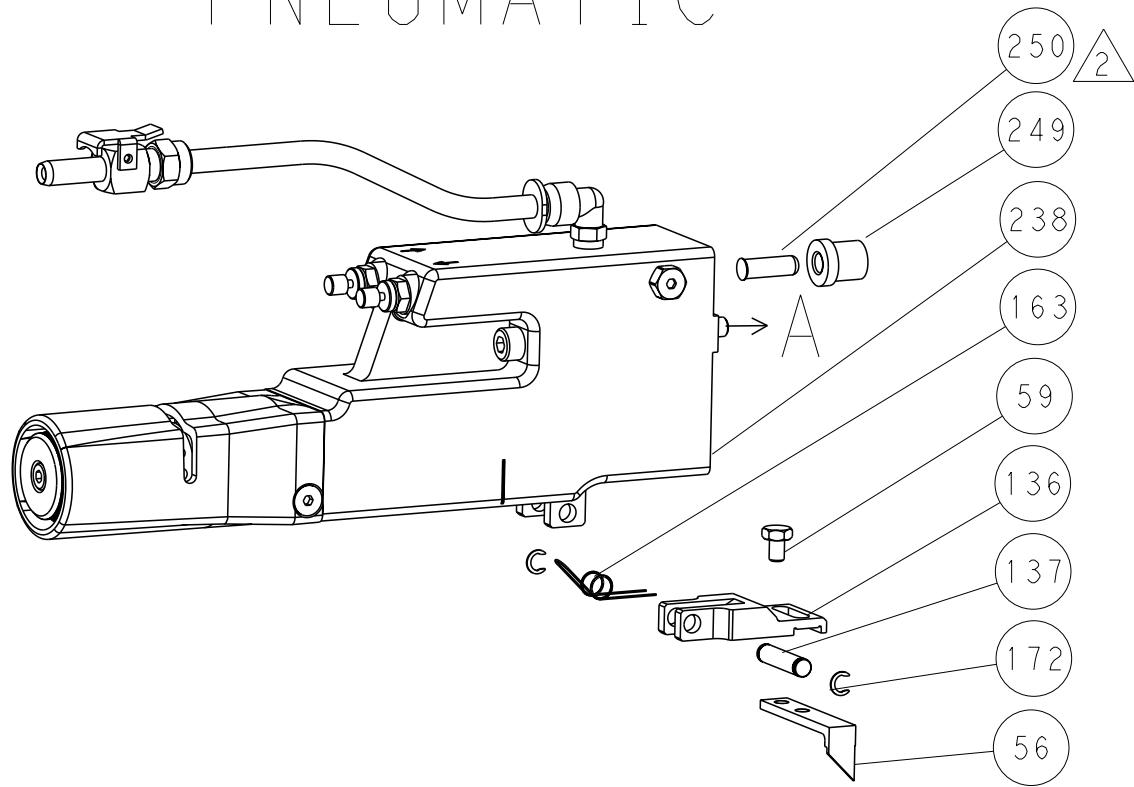
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DIMENSIONS:				CHK S. XI 19JUN2012	NAME			
mm				APVD S. XI 19JUN2012	Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC	SIZE			
0 PLC ±				APPLICATION SPEC	CAGE CODE			
1 PLC ±					DRAWING NO			
2 PLC ±					RESTRICTED TO			
3 PLC ±					A1 00779			
4 PLC ±					©=2151562			
ANGLES				FINISH	WEIGHT			
-				-	-			
MATERIAL				-	Customer Accessible Production Drawing			
-				-	SCALE 1:2			
					SHEET 3 OF 4			
					REV B			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

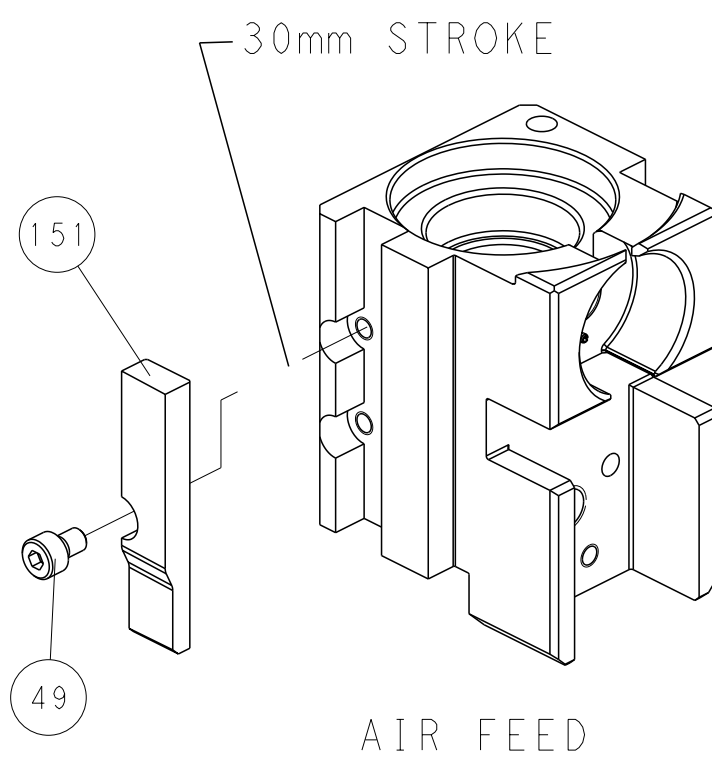
LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	DWN	APVD
A	66		-	SEE SHEET 1	-	-	-

FEED TYPE

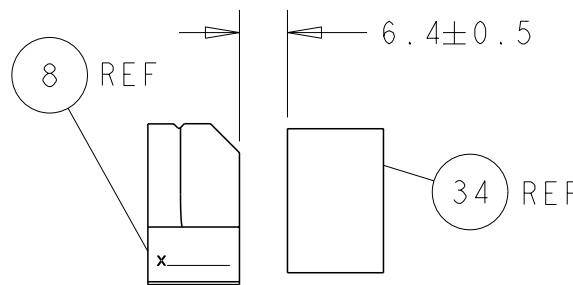
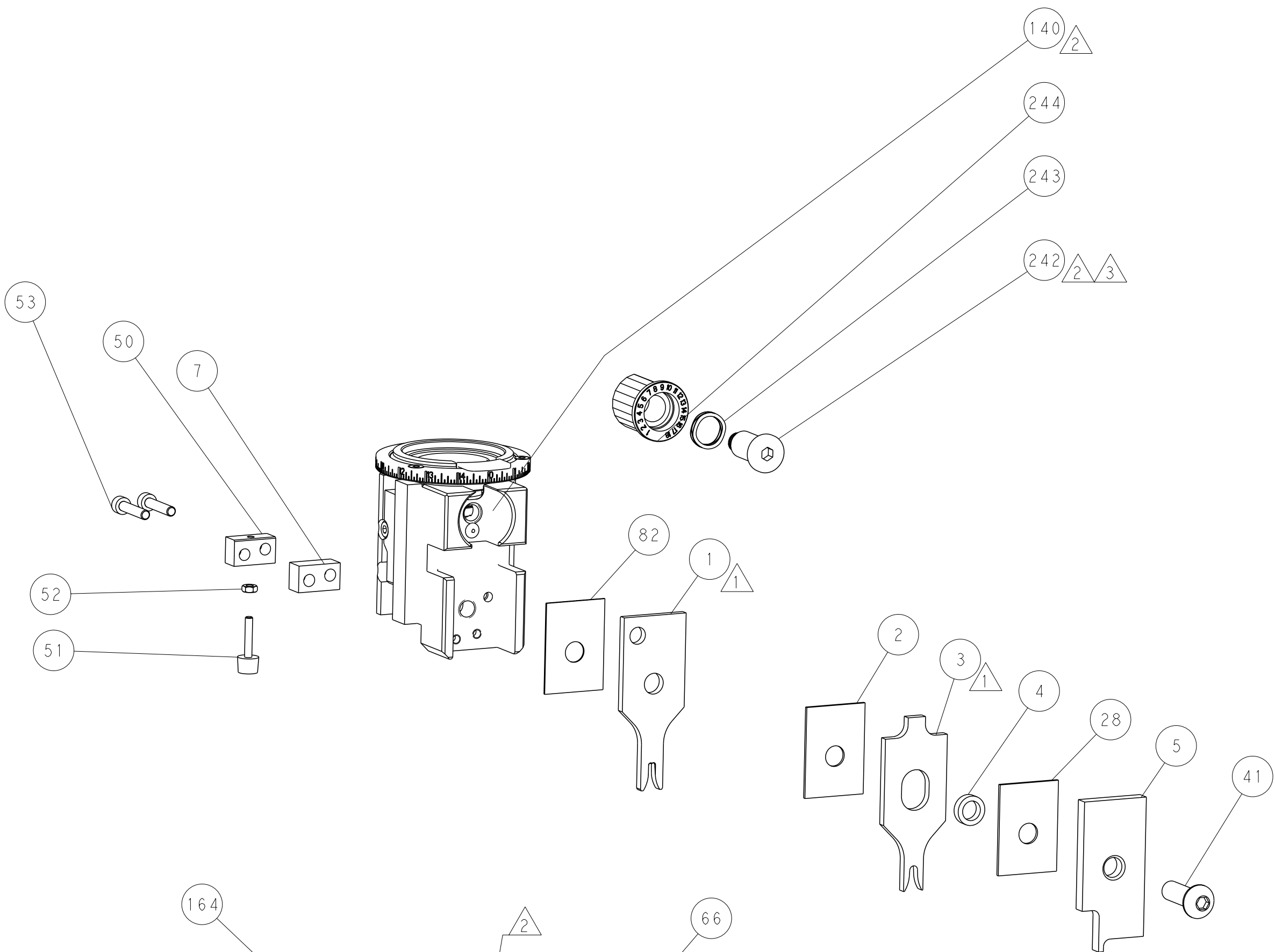
PNEUMATIC



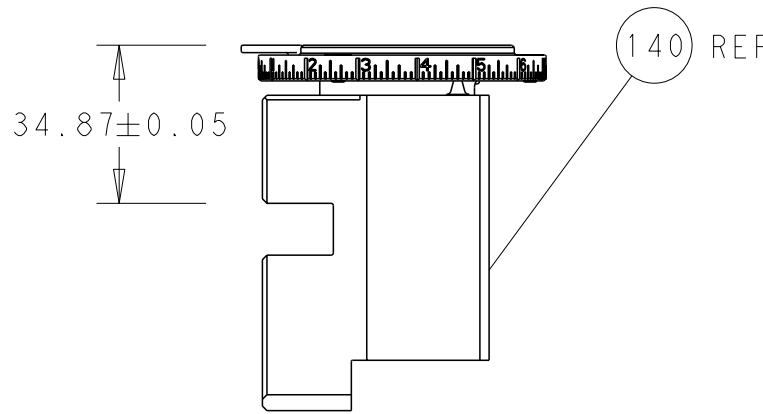
CAM POSITION



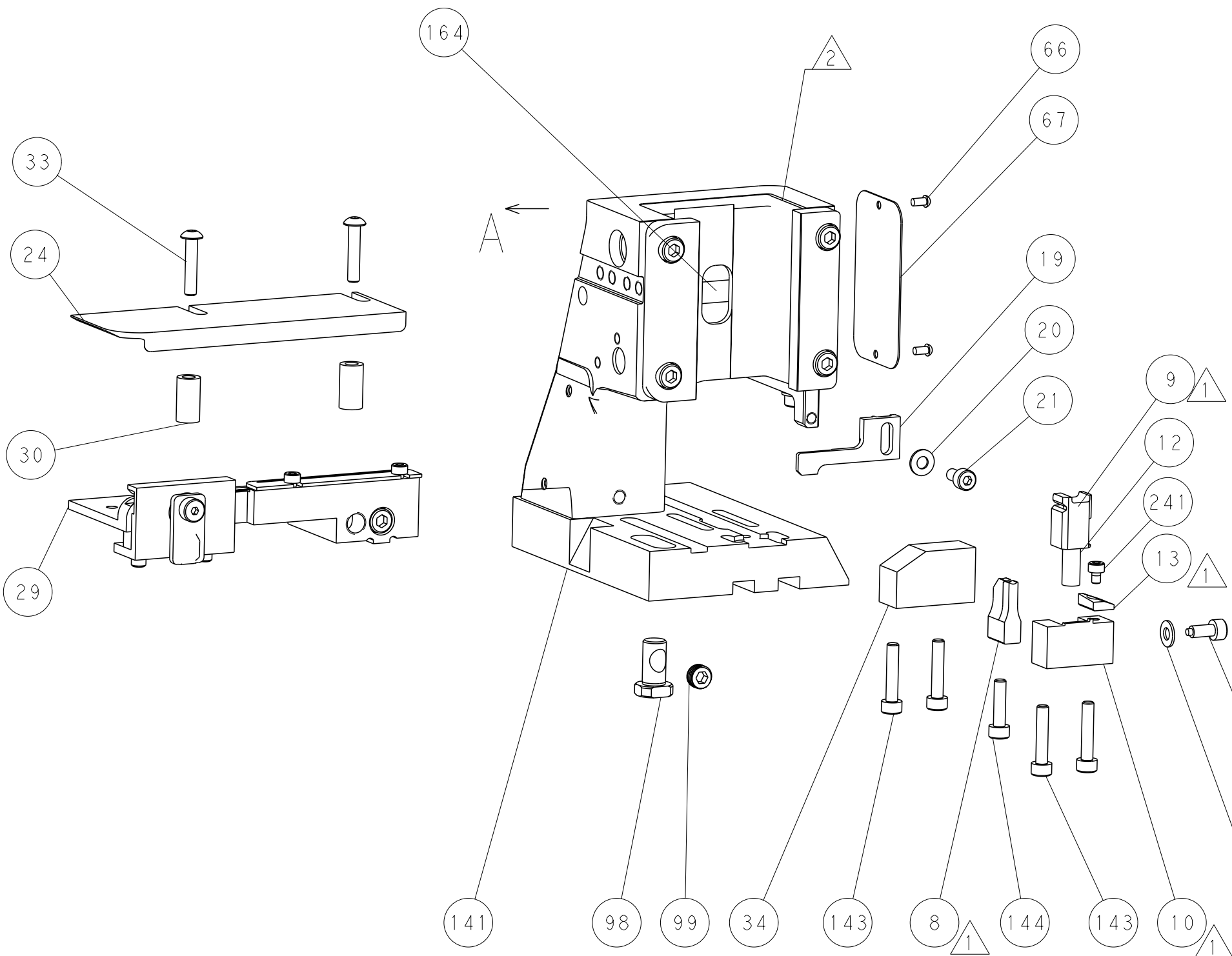
AIR FEED



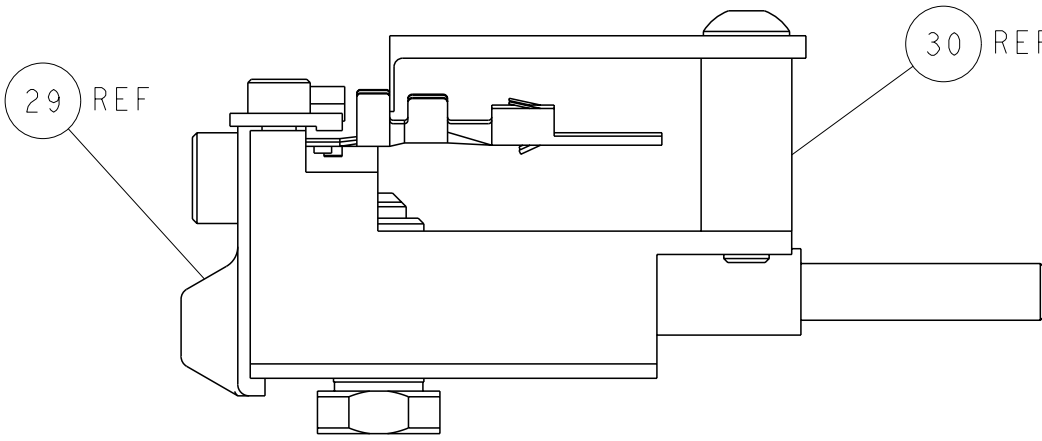
TERMINAL SUPPORT LOCATION



RAM SET-UP



ITEM 30 LOCATED AT REAR HOLES



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN K. HUANG	19JUN2012	TE Connectivity Harrisburg, PA 17105-3608		
		CHK S. XI	19JUN2012			
		APVD S. XI	19JUN2012	NAME Ocean Side Feed Applicator		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		
		0 PLC ±		APPLICATION SPEC		
		1 PLC ±		SIZE		
		2 PLC ±		CAGE CODE		
		3 PLC ±		DRAWING NO		
		4 PLC ±		RESTRICTED TO		
		ANGLES		A 00779 ©=2151562		
MATERIAL		FINISH		WEIGHT		
-		-		Customer Accessible Production Drawing		
				SCALE 1:2		
				SHEET 4 OF 4		
				REV B		