

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151154-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151154-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151154-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151154-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151154-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151154-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151154-7	A	CRIMP TOOLING KIT	-

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

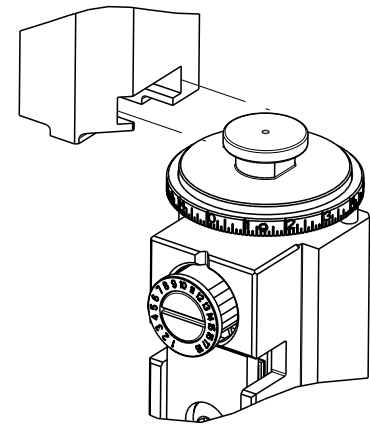
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR POWER TIMER CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60 mm [.157-.181 IN]		Ø2.10-3.10 mm [.083-.122 IN]	
TERMINAL APPLICATION SPECIFICATION		114-18050	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927768-1	927768-9	963884-2	963973-1
927768-2	1-927768-1	965899-1	963973-3
927768-3	2-927768-1	965899-2	1-963973-1
927768-6	963884-1	9-965899-1	2-963973-1
927768-8			

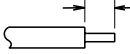
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.77+/-0.05 [.070+/- .002]	8.0
2.00mm2	1.64+/-0.05 [.065+/- .002]	9.5
1.50mm2	1.51+/-0.05 [.059+/- .002]	10.7



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 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.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR POWER TIMER CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.00-4.60 mm [.157-.181 IN]			Ø1.90-2.10 mm [.075-.083 IN]
TERMINAL APPLICATION SPECIFICATION		114-18050	- -
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927768-1	927768-9	963884-2	963973-1
927768-2	1-927768-1	965899-1	963973-3
927768-3	2-927768-1	965899-2	1-963973-1
927768-6	963884-1	9-965899-1	2-963973-1
927768-8			

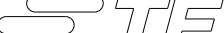
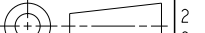
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2X1.00mm2	1.58+/-0.05 [.062+/- .002]	10.1
2X 0.75mm2	1.51+/-0.05 [.059+/- .002]	10.7
0.75 + 0.50mm2	1.40+/-0.05 [.055+/- .002]	11.5

*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.

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

2				1			
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		B		ECR-14-002307	11FEB2014	XZ	JG
		C		ECR-18-008830	08JUN2018	JAH	TE
		C1		ECR-18-019124	07DEC2018	MZ	TE
		C2		ECR-19-007942	17MAY2019	LG	TE

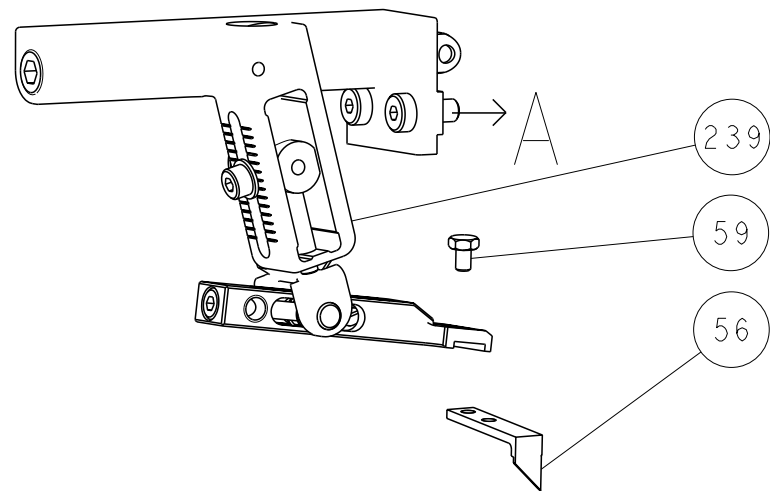
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	2-1752354-4	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	2	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	3-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	3-1333207-9	ANVIL, COMBINATION .110	8
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1-2119785-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	1	455888-2	SPACER, CRIMPER	2
1	2	2	1	1	1	1	456408-2	CRIMPER, WIRE PREMIUM	1

-77 -72 -71 -52 -51 -2 -1							PART NO		DESCRIPTION				ITEM NO		
THIS DRAWING IS A CONTROLLED DOCUMENT FOR ETO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO BE OBTAINED FOR THE LATEST REVISION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.							DWN	30AUG2011	 TE Connectivity Harrisburg, PA 17105-3608						
							L. GROSS	30AUG2011							
							CHK	G. BAILEY						30AUG2011	
							APVD	J. CRUZ						30AUG2011	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:							NAME	Ocean Side Feed Applicator -					
mm									PRODUCT SPEC						
		0 PLC ±							APPLICATION SPEC						
		1 PLC ±													
		2 PLC ±													
		3 PLC ±													
		4 PLC ±													
		ANGLES ±													
MATERIAL		FINISH					WEIGHT		-	A1 00779 ©=2151154				RESTRICTED TO	
														-	
Customer Accessible Production Drawing							SCALE		1:2	SHEET	1	OF	4	REV	C2

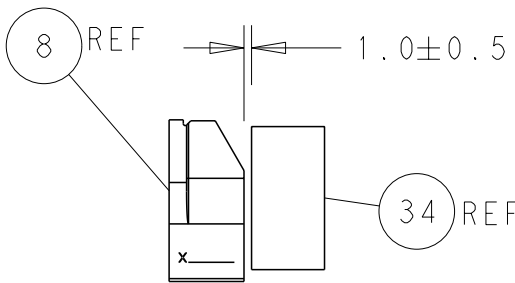
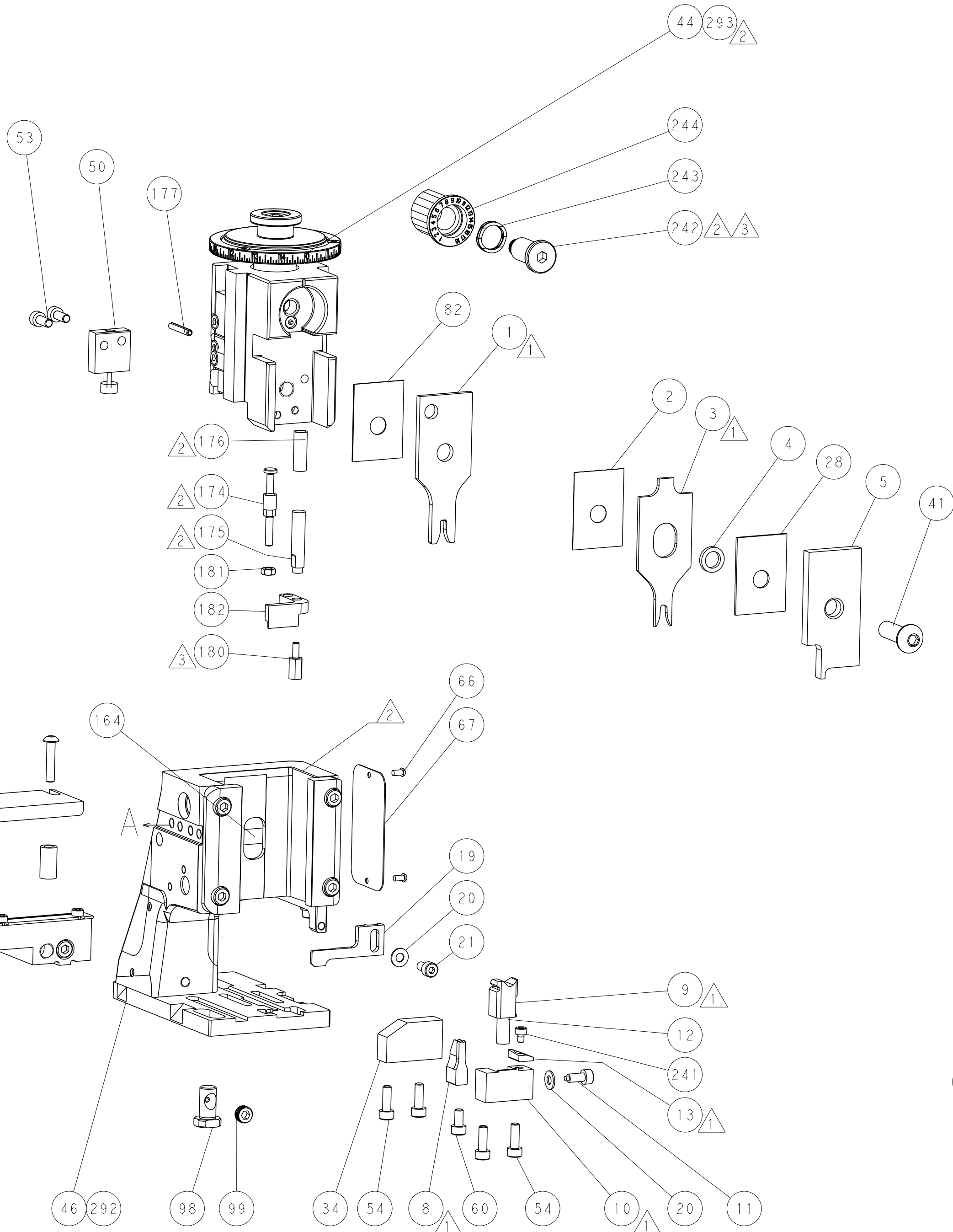
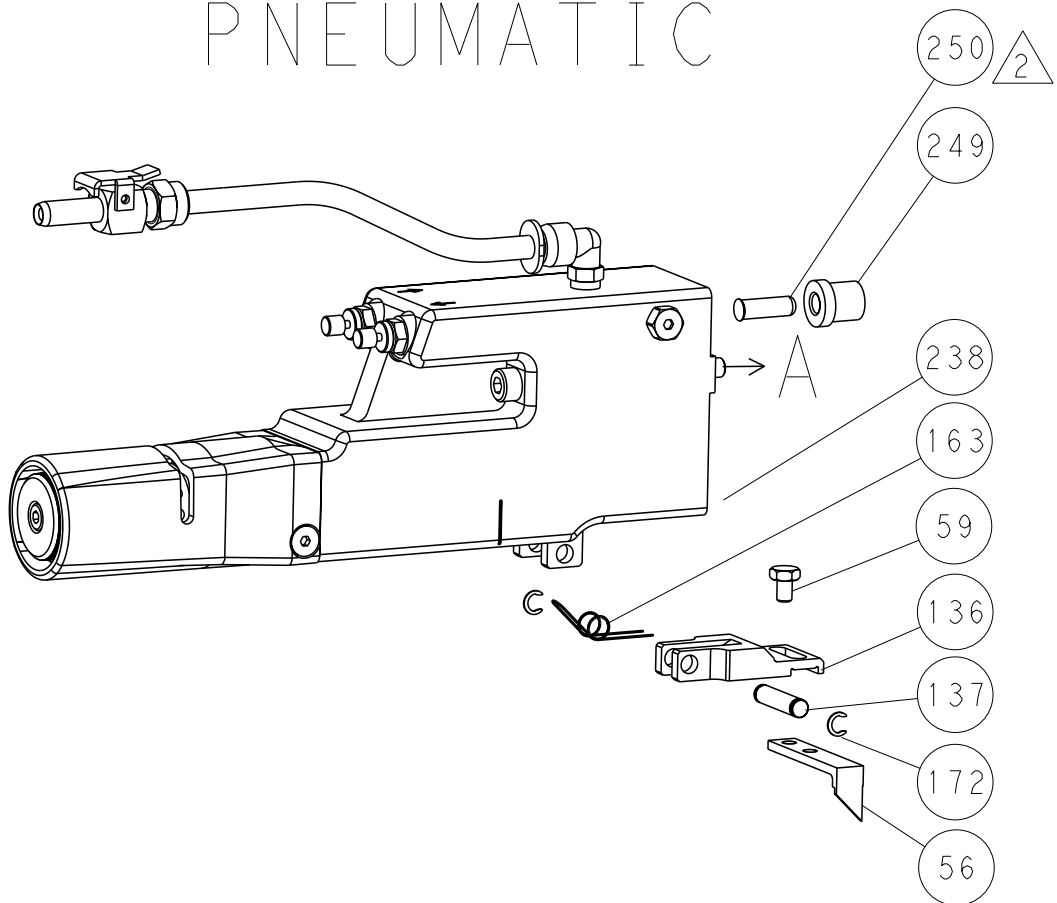
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

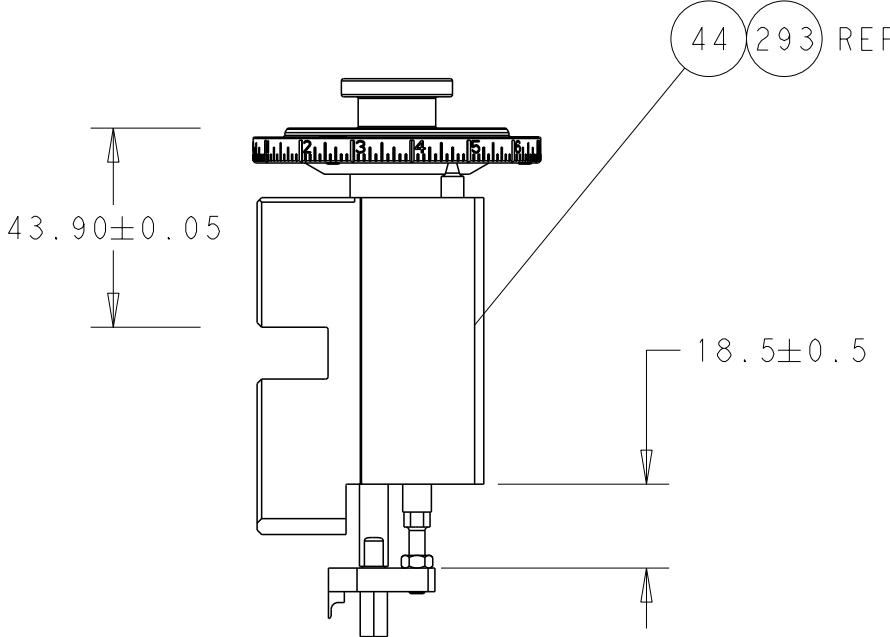
FEED TYPE
MECHANICAL



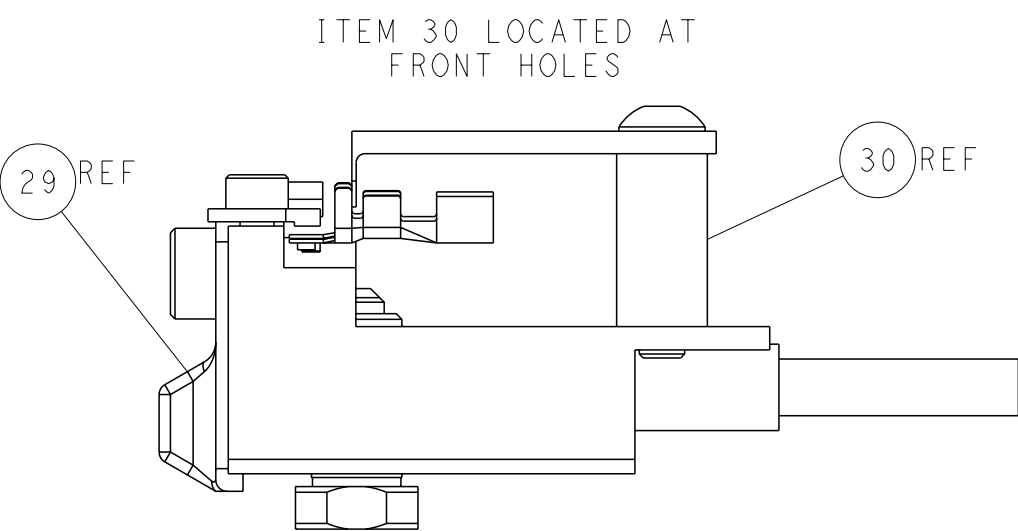
PNEUMATIC



TERMINAL SUPPORT LOCATION

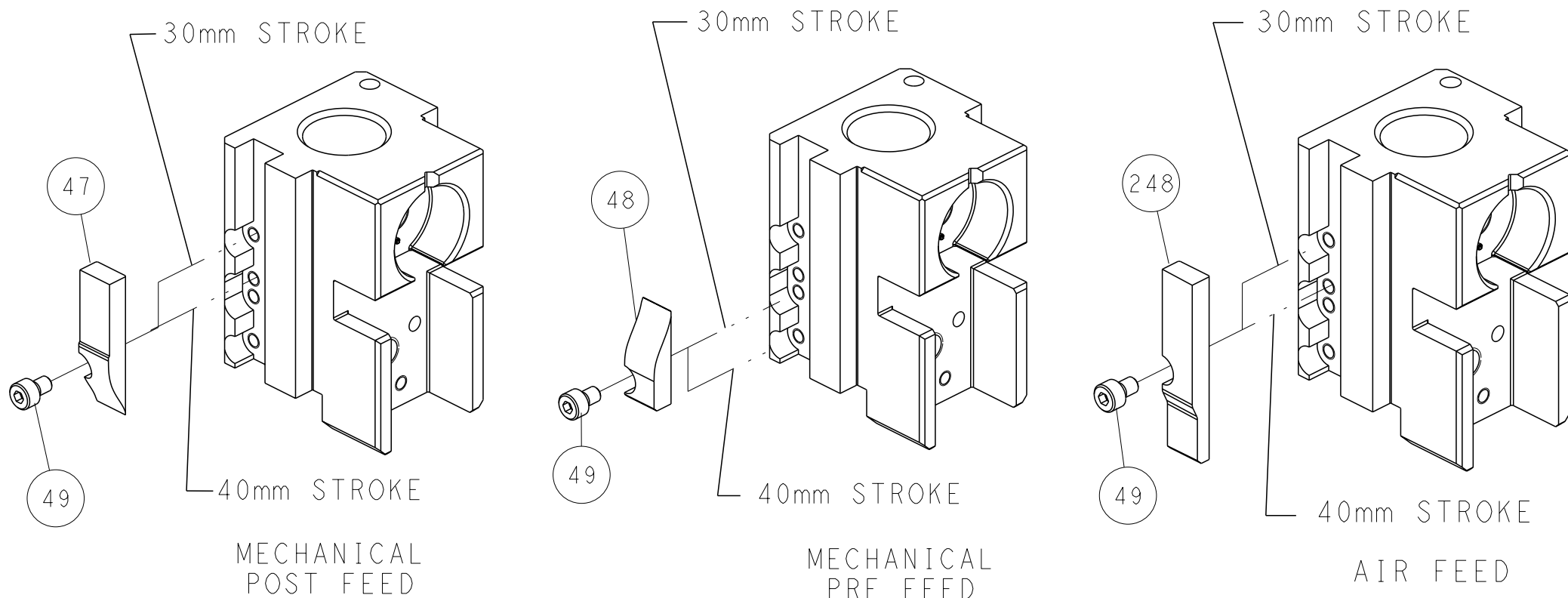


RAM AND HOLDDOWN SET-UP



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)

THIS IS A STANDARD 3D MODEL OF A CUSTOMER SPECIFIED PART. IT IS NOT A REPRESENTATION OF THE ACTUAL PART. THE ACTUAL PART MAY VARY FROM THE MODEL DUE TO MANUFACTURING TOLERANCES AND VARIATIONS IN MATERIALS. THE MODEL IS PROVIDED FOR INFORMATIONAL PURPOSES ONLY. THE ACTUAL PART SHOULD BE USED FOR DIMENSIONING AND TOLERANCING. THE ACTUAL PART SHOULD BE USED FOR DIMENSIONING AND TOLERANCING.				DWN		30AUG2011				TE Connectivity	
				CHK		30AUG2011				Harrisburg, PA 17105-3608	
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME		Ocean Side Feed Applicator	
mm								I. CRUZ			
				0 PLC ±				PRODUCT SPEC			
				1 PLC ±				APPLICATION SPEC			
				2 PLC ±							
				3 PLC ±							
				4 PLC ±							
ANGLES				±				SIZE		CASE CODE	
FINISH								DRAWING NO		RESTRICTED TO	
MATERIAL								WEIGHT			
								A1 00779		C=2151154	
								Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV C2	

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1

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PART NUMBER

REVISION

DESCRIPTION

FEED TYPE

2-2151154-1

C

FINE CRIMP HEIGHT ADJUST

MECHANICAL

2-2151154-2

C

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

7-2151154-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.79 mm [.110]

F

INSUL

3.56 mm [.140]

OV

APPLICATOR INSTRUCTIONS

408-35042

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: JUNIOR POWER TIMER CONTACT

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.00-4.60 mm [.157-.181 IN]

Ø2.10-3.10 mm [.083-.122 IN]

TERMINAL APPLICATION SPECIFICATION

114-18050

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

927768-1

927768-9

963884-2

963973-1

927768-2

1-927768-1

965899-1

963973-3

927768-3

2-927768-1

965899-2

1-963973-1

927768-6

963884-1

9-965899-1

2-963973-1

927768-8

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: JUNIOR POWER TIMER CONTACT

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.00-4.60 mm [.157-.181 IN]

Ø1.90-2.10 mm [.075-.083 IN]

TERMINAL APPLICATION SPECIFICATION

114-18050

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

927768-1

927768-9

963884-2

963973-1

927768-2

1-927768-1

965899-1

963973-3

927768-3

2-927768-1

965899-2

1-963973-1

927768-6

963884-1

9-965899-1

2-963973-1

927768-8

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

2.50mm2

1.77+/-0.05 [.070+/- .002]

8.0

2.00mm2

1.64+/-0.05 [.065+/- .002]

9.5

1.50mm2

1.51+/-0.05 [.059+/- .002]

10.7

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

2X1.00mm2

1.58+/-0.05 [.062+/- .002]

10.1

2X 0.75mm2

1.51+/-0.05 [.059+/- .002]

10.7

0.75 + 0.50mm2

1.40+/-0.05 [.055+/- .002]

11.5

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.

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

6

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.

LOC

DIST

REV

DATE

OWN

APVD

A

66

DESCRIPTION

DATE

OWN

APVD

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-

1

-

1803259-1

BUSHING, FLANGED

249

-

1

1

2119082-9

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

-

2063440-1

AIR FEED MODULE

238

-

2

-

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

-

REF

REF

994970-2

COUNTER, MAGNETIC

164

-

1

-

240638-1

SPRING, FEED FINGER

163

-

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

-

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

-

1

-

2119799-1

HOLDER,FEED FINGER, AF

136

-

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

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

3-1752356-3

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

1320928-2

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

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

3-1333207-9

ANVIL, COMBINATION .110

8

-

1

1

2119757-8

DEPRESSOR, SHEAR

5

-

1

1

2-238011-2

BLOCK, CRIMPER SPACER

4

-

1

1

1

1-2119785-1

CRIMPER, INSULATION OVERLAP PREMIUM

3

-

1

1

455888-2

SPACER, CRIMPER

2

-

1

1

1

456408-2

CRIMPER, WIRE PREMIUM

1

-77

-22

-21

PART NO

DESCRIPTION

ITEM NO

1

2

3

4

1

2

3

4

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.79 mm [.110]

F

INSUL

3.56 mm [.140]

OV

APPLICATOR INSTRUCTIONS

408-35042

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: JUNIOR POWER TIMER CONTACT

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.00-4.60 mm [.157-.181 IN]

Ø2.10-3.10 mm [.083-.122 IN]

TERMINAL APPLICATION SPECIFICATION

114-18050

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

927768-1

927768-9

963884-2

963973-1

927768-2

1-927768-1

965899-1

963973-3

927768-3

2-927768-1

965899-2

1-963973-1

927768-6

963884-1

9-965899-1

2-963973-1

927768-8

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

2.50mm2

1.77+/-0.05 [.070+/- .002]

8.0

2.00mm2

1.64+/-0.05 [.065+/- .002]

9.5

1.50mm2

1.51+/-0.05 [.059+/- .002]

10.7

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

2X1.00mm2

1.58+/-0.05 [.062+/- .002]

10.1

2X 0.75mm2

1.51+/-0.05 [.059+/- .002]

10.7

0.75 + 0.50mm2

1.40+/-0.05 [.055+/- .002]

11.5

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.

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

6

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.

LOC

DIST

REV

DATE

OWN

APVD

A

66

DESCRIPTION

DATE

OWN

APVD

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-

1

-

1803259-1

BUSHING, FLANGED

249

-

1

1

2119082-9

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

-

2063440-1

AIR FEED MODULE

238

-

2

-

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

-

REF

REF

994970-2

COUNTER, MAGNETIC

164

-

1

-

240638-1

SPRING, FEED FINGER

163

-

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

-

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

-

1

-

2119799-1

HOLDER,FEED FINGER, AF

136

-

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

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

3-1752356-3

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

1320928-2

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

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

1

1803095-1

FLOATING SHEAR, FRONT

9

-

1

1

1

3-1333207-9

ANVIL, COMBINATION .110

8

-

1

1

2119757-8

DEPRESSOR, SHEAR

5

-

1

1

2-238011-2

BLOCK, CRIMPER SPACER

4

-

1

1

1

1-2119785-1

CRIMPER, INSULATION OVERLAP PREMIUM

3

-

1

1

455888-2

SPACER, CRIMPER

2

-

1

1

1

456408-2

CRIMPER, WIRE PREMIUM

1

-77

-22

-21

PART NO

DESCRIPTION

ITEM NO

1

2

3

4

1

2

3

4

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.79 mm [.110]

F

INSUL

3.56 mm [.140]

OV

APPLICATOR INSTRUCTIONS

408-35042

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: JUNIOR POWER TIMER CONTACT

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.00-4.60 mm [.157-.181 IN]

Ø2.10-3.10 mm [.083-.122 IN]

TERMINAL APPLICATION SPECIFICATION

114-18050

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

927768-1

927768-9

963884-2

963973-1

927768-2

1-927768-1

965899-1

963973-3

927768-3

2-927768-1

965899-2

1-963973-1

927768-6

963884-1

9-965899-1

2-963973-1

927768-8

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

2.50mm2

1.77+/-0.05 [.070+/- .002]

8.0

2.00mm2

1.64+/-0.05 [.065+/- .002]

9.5

1.50mm2

1.51+/-0.05 [.059+/- .002]

10.7

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

2X1.00mm2

1.58+/-0.05 [.062+/- .002]

10.1

2X 0.75mm2

1.51+/-0.05 [.059+/- .002]

10.7

0.75 + 0.50mm2

1.40+/-0.05 [.055+/- .002]

11.5

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.

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LOC

DIST

REV

DATE

OWN

APVD

A

66

DESCRIPTION

DATE

OWN

APVD

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-

1

-

1803259-1

BUSHING, FLANGED

249

-

1

1

2119082-9

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

-

2063440-1

AIR FEED MODULE

238

-

2

-

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

-

REF

REF

994970-2

COUNTER, MAGNETIC

164

-

1

-

240638-1

SPRING, FEED FINGER

163

-

1

-

2119641-2

FEED CAM, AIR FEED

151

-

1

1

2168083-8

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

D

C

B

A

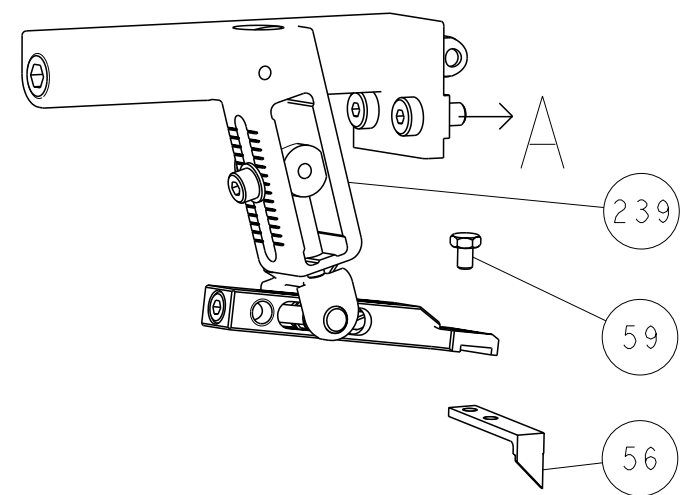
D

C

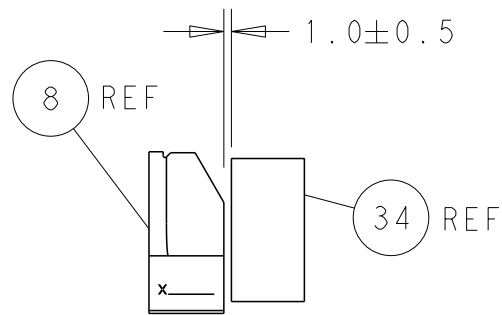
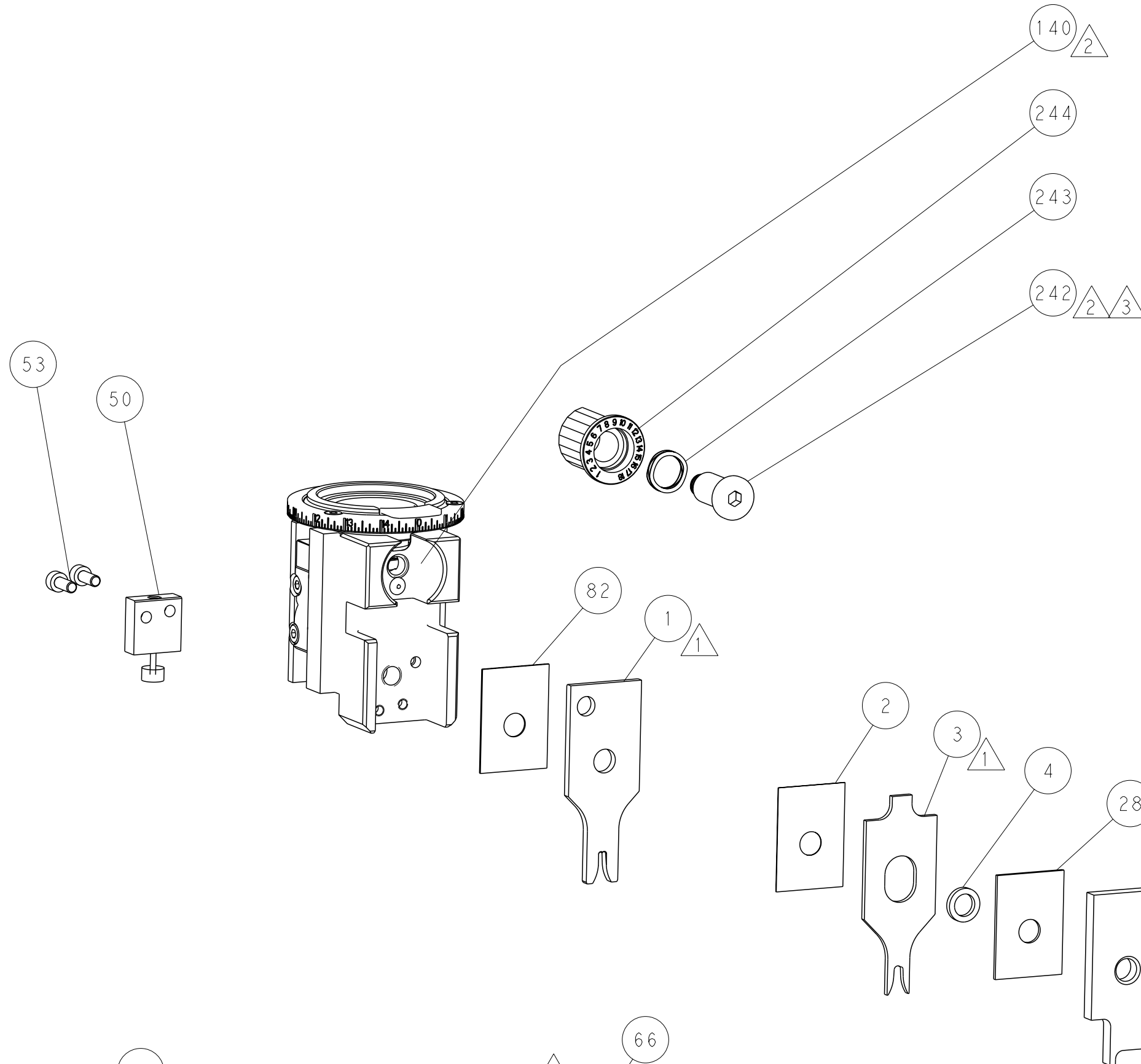
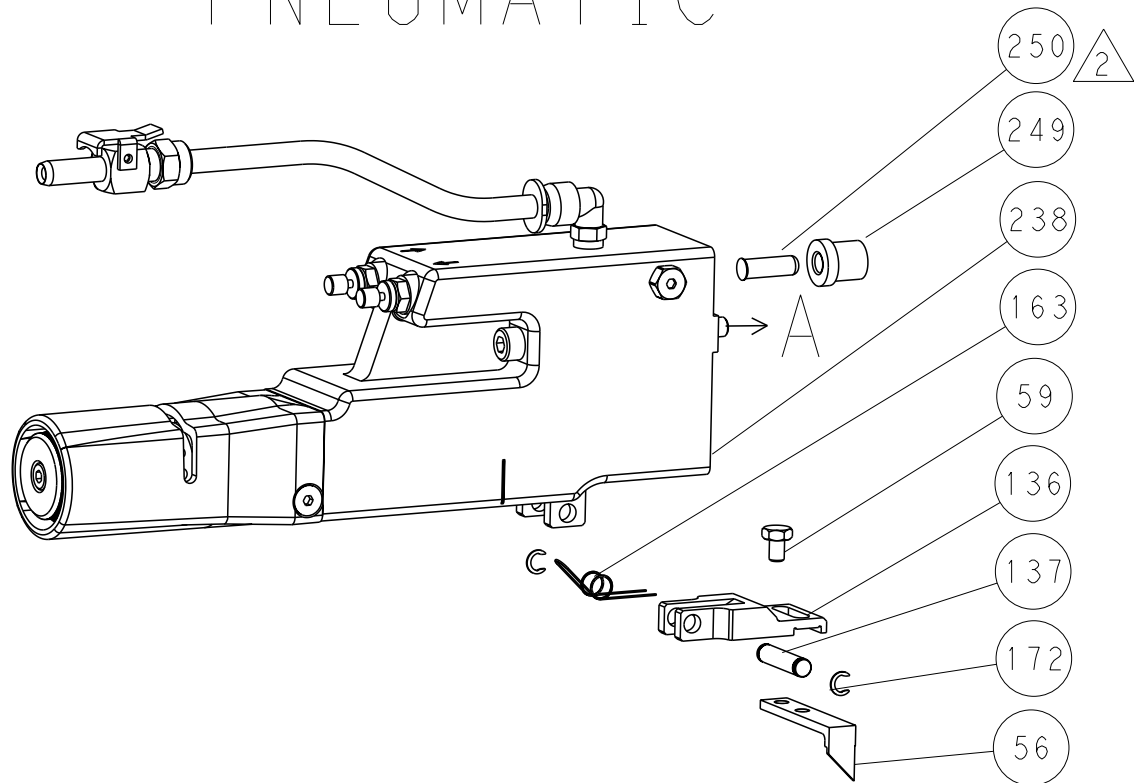
B

A

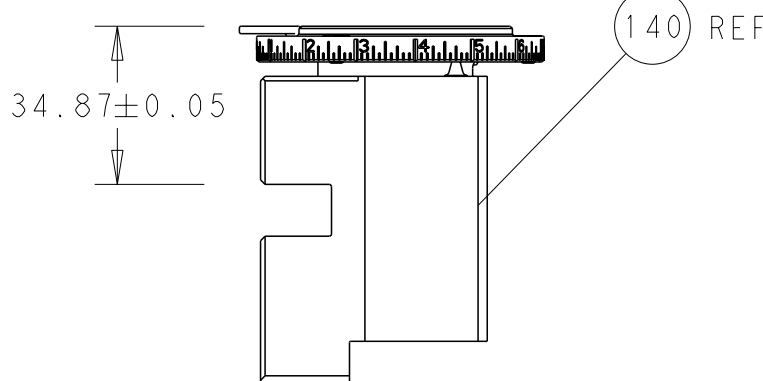
FEED TYPE MECHANICAL



PNEUMATIC

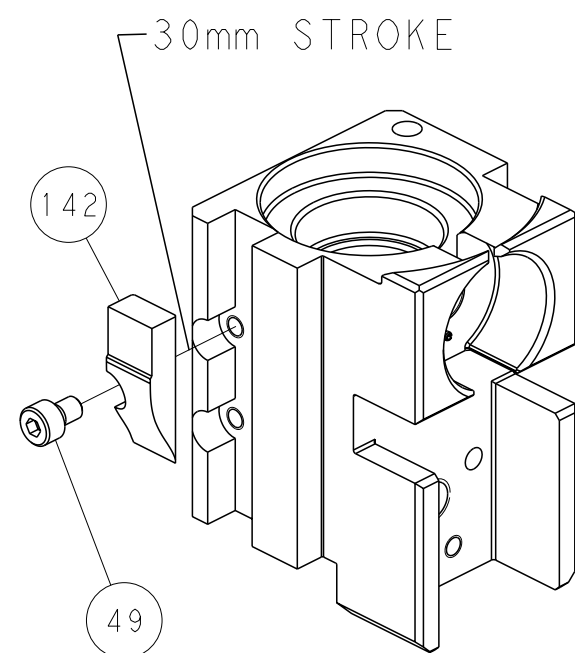


TERMINAL SUPPORT LOCATION

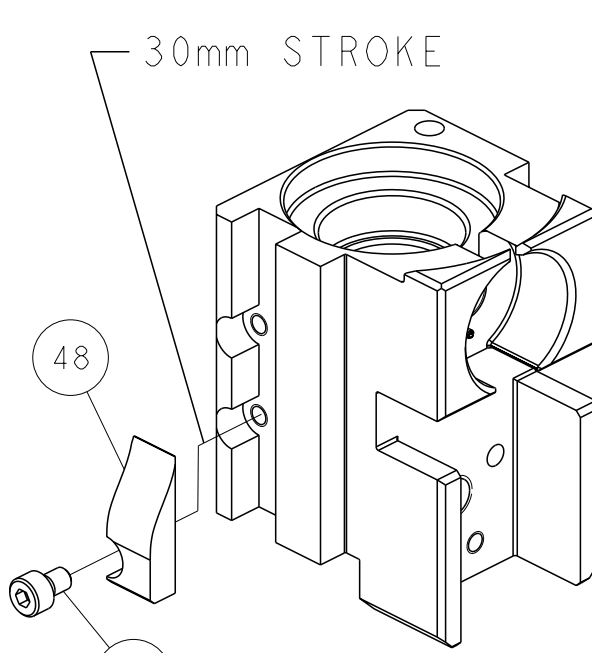


RAM SET-UP

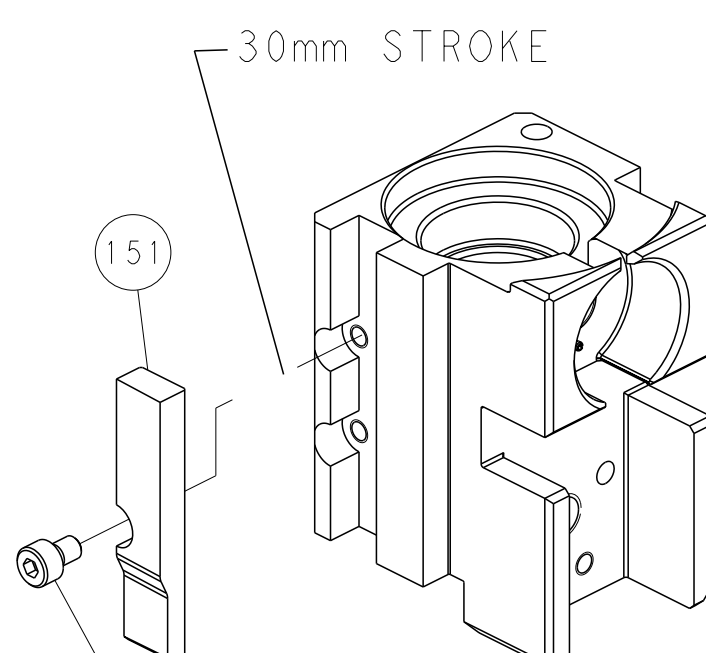
CAM POSITIONS



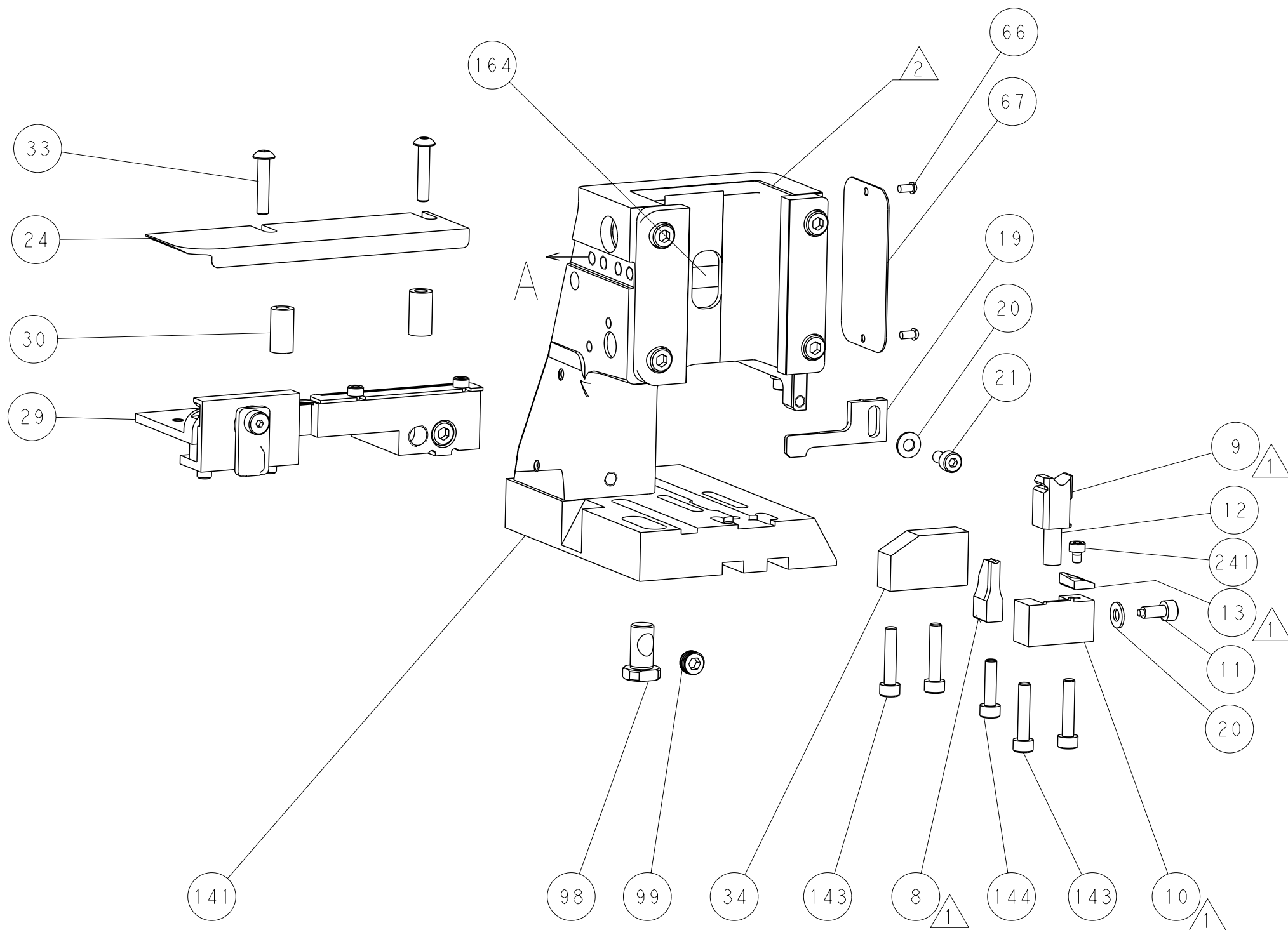
MECHANICAL
POST FEED



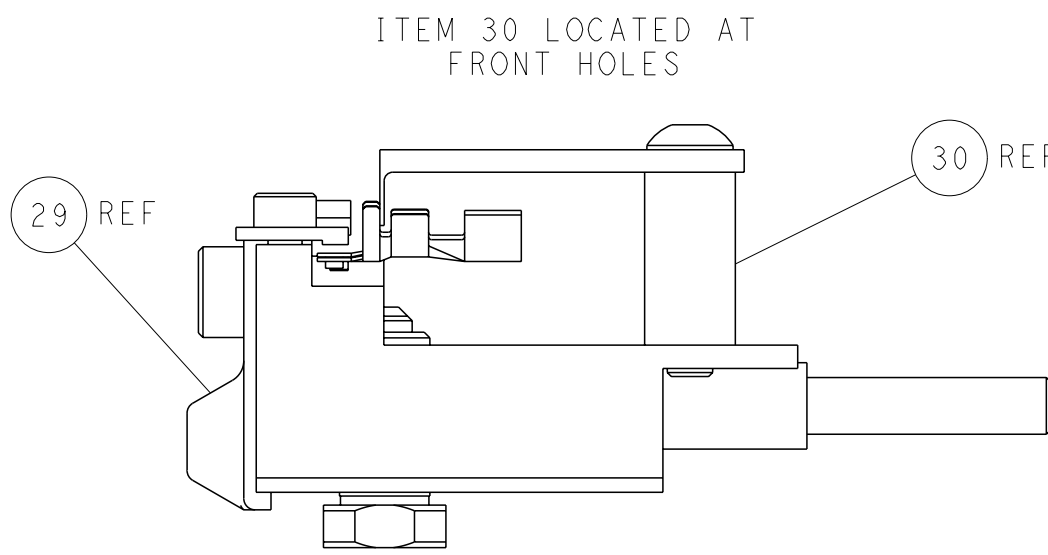
MECHANICAL
PRE FEED



AIR FEED



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



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN L. GROSS 30AUG2011	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 30AUG2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD J. CRUZ 30AUG2011	NAME Ocean Side Feed Applicator	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
		APPLICATION SPEC -	CAGE CODE 00779	
		WEIGHT -	DRAWING NO C=2151154	
		Customer Accessible Production Drawing	SCALE 1:2	SHEET 4
			OF 4	REV C2

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION