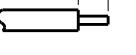


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151543-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151543-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151543-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151543-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151543-7	C	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.86 mm [.073]	O
APPLICATOR INSTRUCTIONS 408-35042		

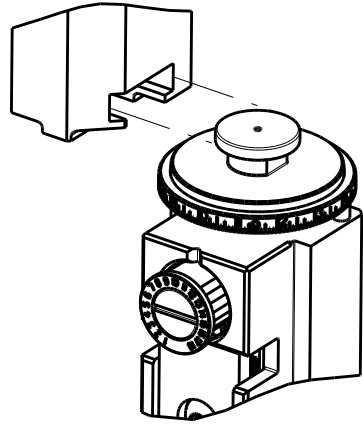
TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.70-5.60 mm [.185-.220 IN]			INSULATION DIAMETER RANGE Ø1.40-1.65 mm [.055-.065 IN]
TERMINAL APPLICATION SPECIFICATION	AS-33012-002	-	-
			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113245-1	33012-3003	2113245-5	33001-5003
2113245-2	33012-3023	2113245-6	33001-3023
2113245-3	34750-1003	2113245-7	33001-5023
2113245-4	33001-3005		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.10+/-0.05 [.043+/- .002]	7.8
22 AWG	1.00+/-0.05 [.039+/- .002]	8.6
0.35mm2	0.95+/-0.05 [.037+/- .002]	9.1



- 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.

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)

*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.

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			C1	ECR-14-010350	09JUL2014	RK	TE
			D	ECR-18-016887	26OCT2018	YY	CT
			E	ECR-18-018367	23NOV2018	FZ	KZ

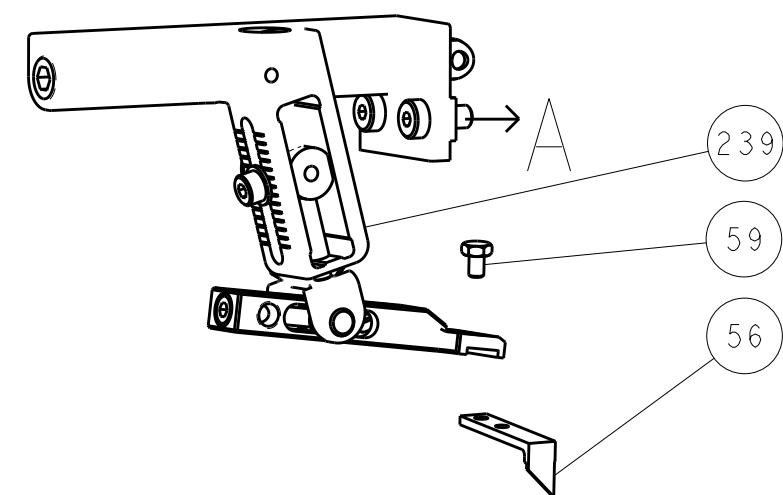
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	306
-	1	1	1	1	2-690438-2	FRONT STRIP GUIDE	305
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	304
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	303
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	302
-	1	1	1	1	240792-1	DRAG, TERMINAL	301
-	2	2	2	2	22283-1	SPRING, COMPRESSION	300
-	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	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	1-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1320928-1	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1633918-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1633966-8	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	2	1	3-456403-8	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	ITEM NO

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CHK G. BAILEY 21DEC2011		APVD S. XI 21DEC2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01		PRODUCT SPEC
MATERIAL -		FINISH -		APPLICATION SPEC
		WEIGHT -		SIZE A1
		Customer Accessible Production Drawing		SCALE 1:2
		SHEET 1		OF 4
		REV E		

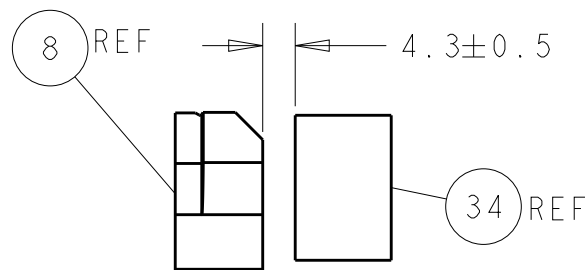
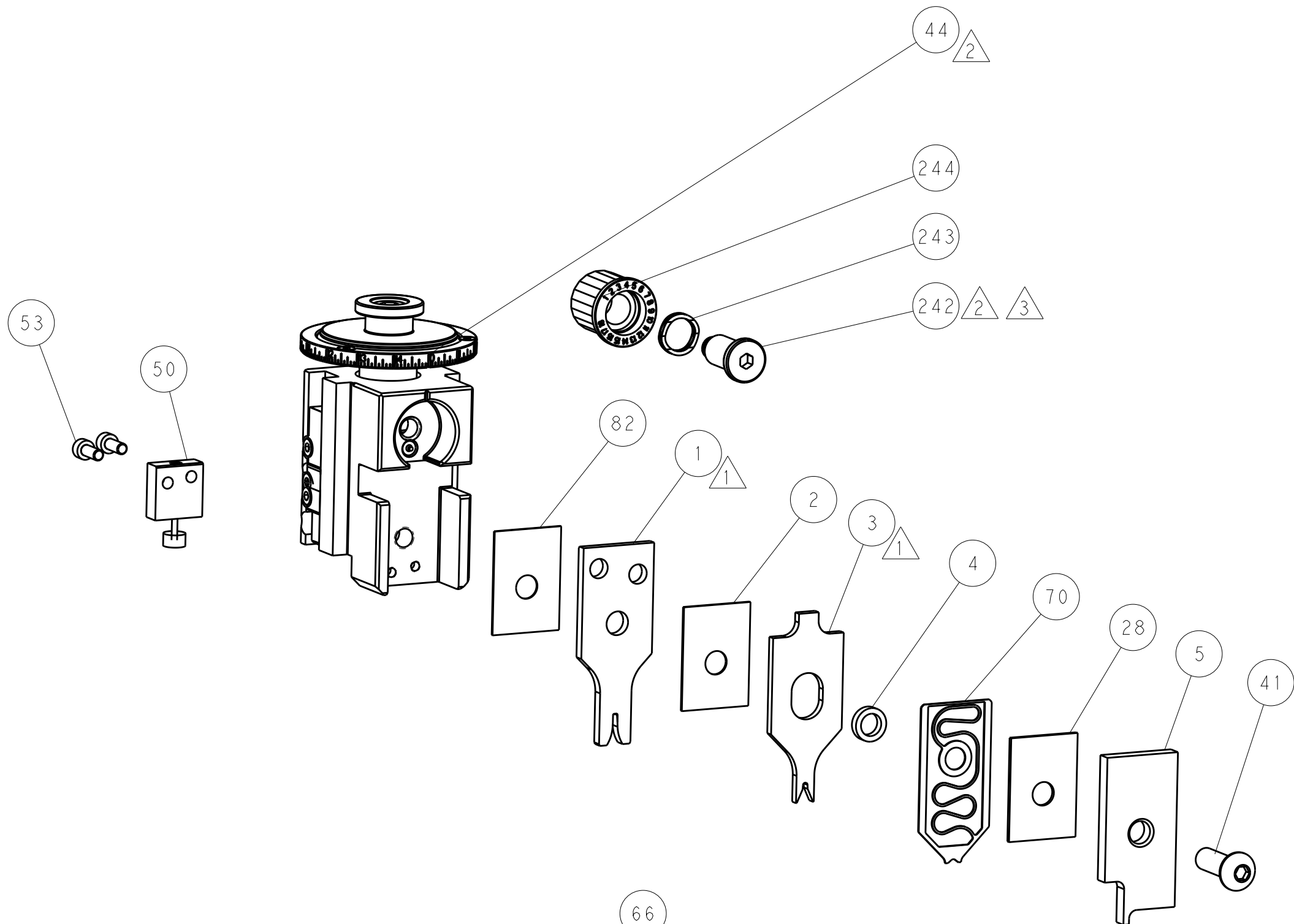
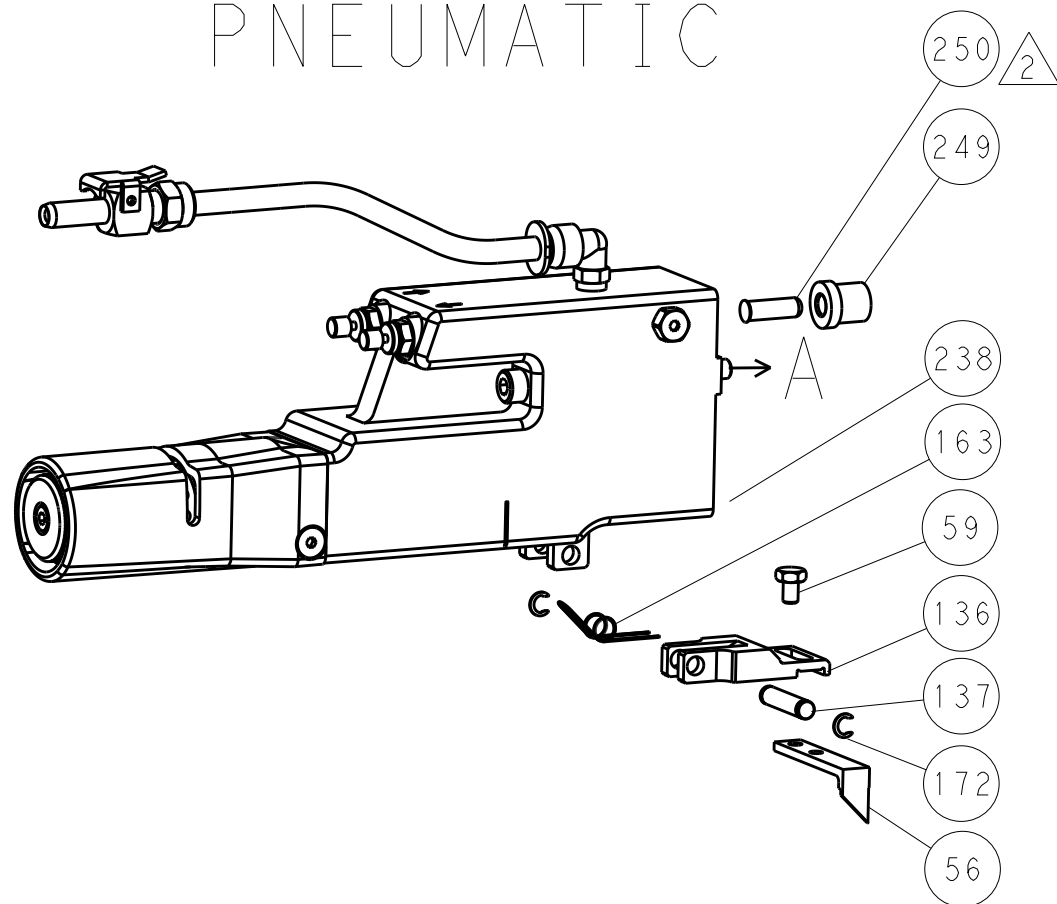
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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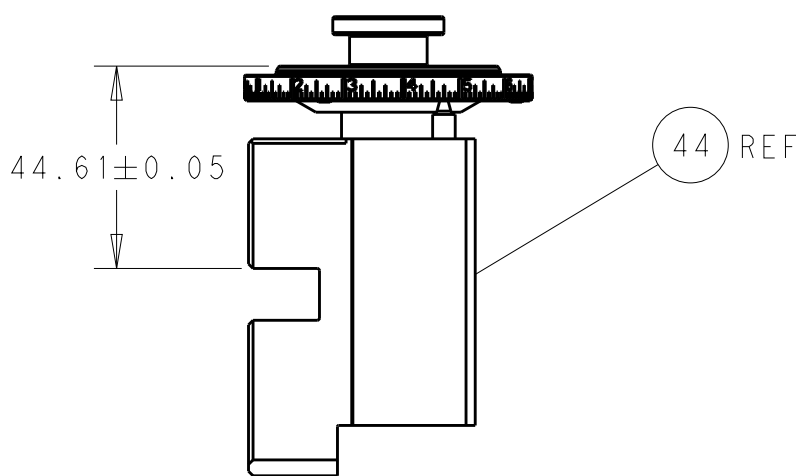
FEED TYPE
MECHANICAL



PNEUMATIC

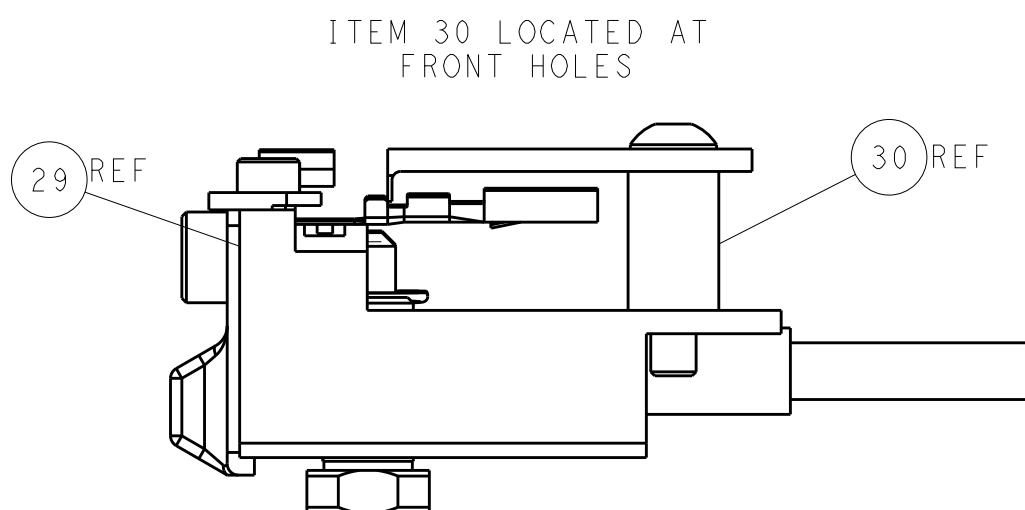
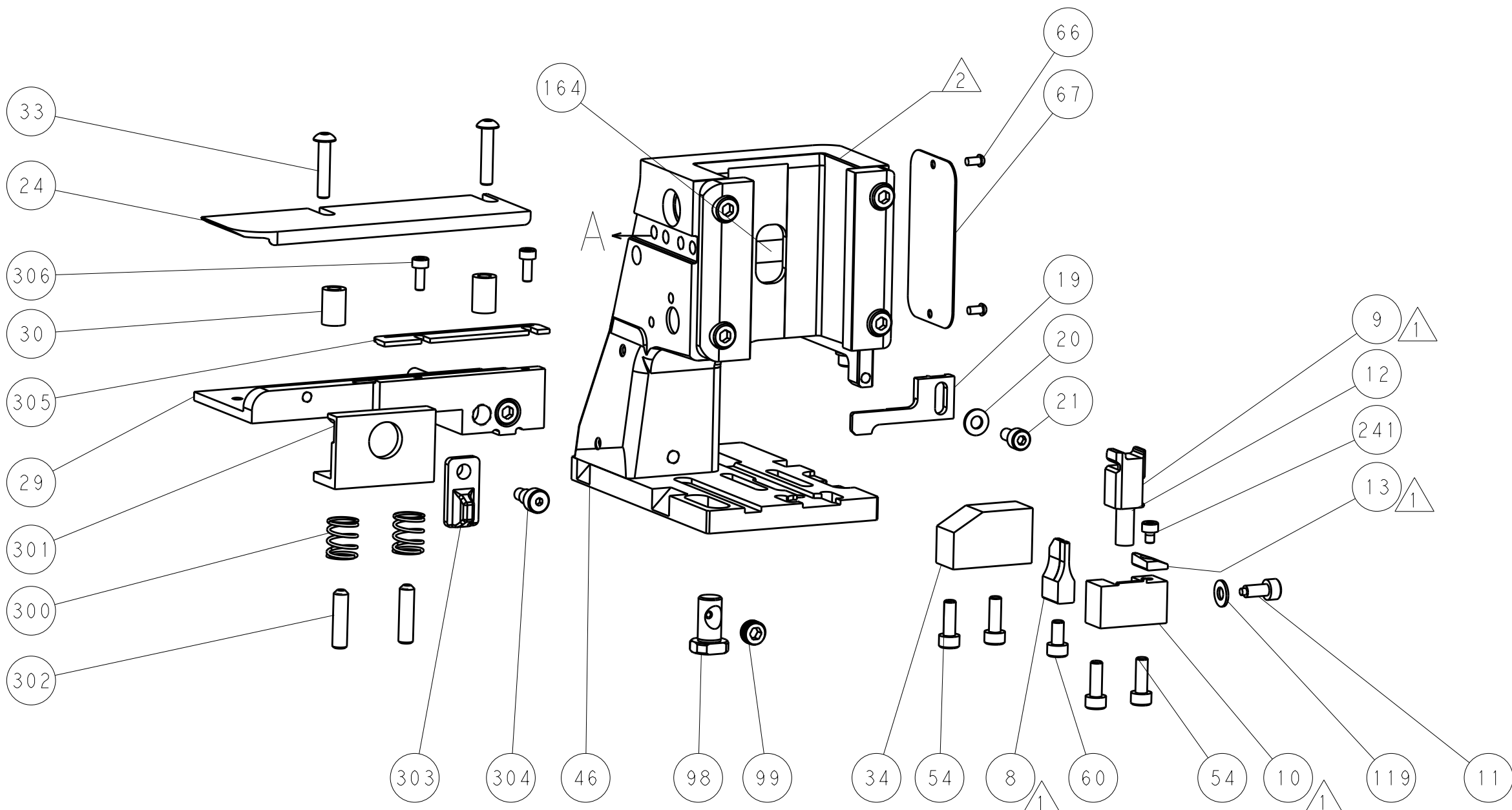
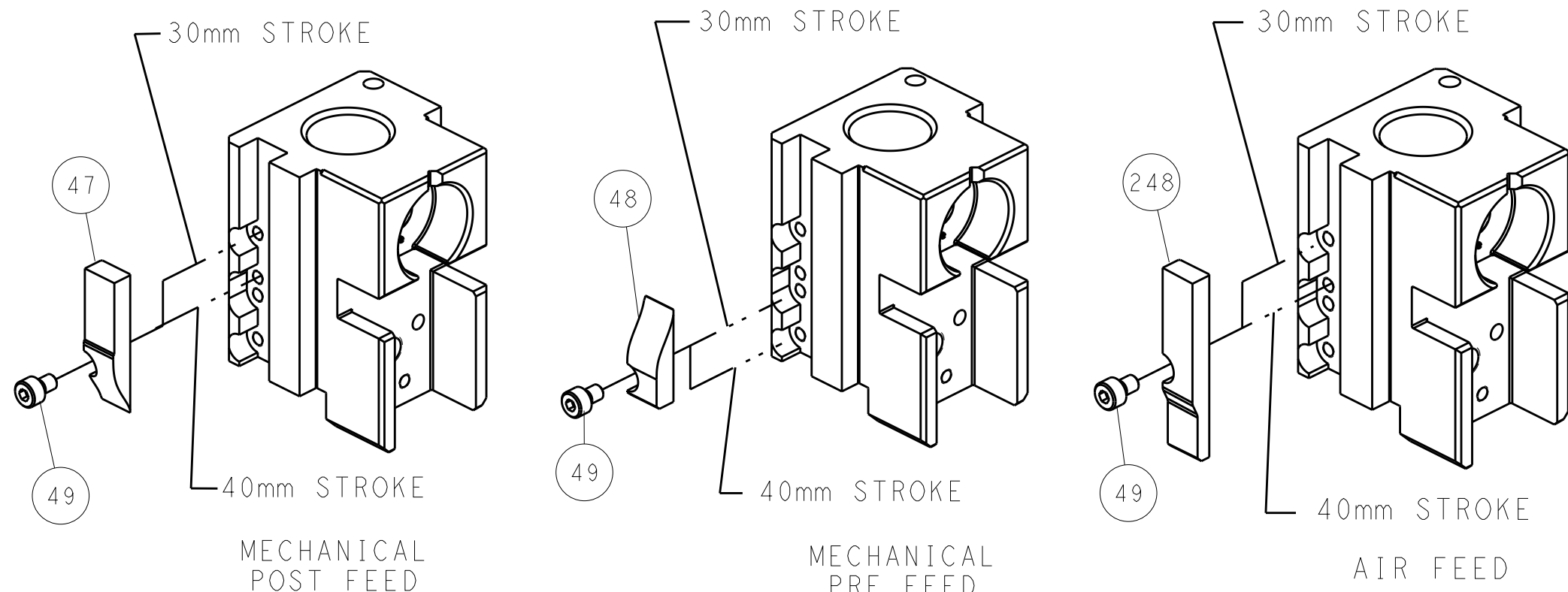


TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

CAM POSITIONS



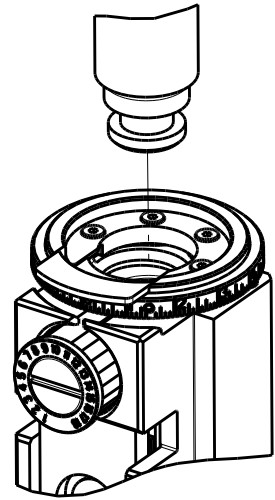
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 21DEC2011		TE Connectivity	
mm		0 PLC ±		CHK G. BAILEY 21DEC2011		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD S. XI 21DEC2011		NAME Ocean Side Feed Applicator	
		2 PLC ±		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
		3 PLC ±		APPLICATION SPEC		A1 00779 C=2151543	
		4 PLC ±		WEIGHT		RESTRICTED TO	
		ANGLES FINISH		Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV E	

8			7		
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PART NUMBER	REVISION	DESCRIPTION		FEED TYPE	
2-2151543-1	E	FINE CRIMP HEIGHT ADJUST		MECHANICAL	
2-2151543-2	E	FINE CRIMP HEIGHT ADJUST		PNEUMATIC	
7-2151543-7	C	CRIMP TOOLING KIT		-	

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.86 mm [.073]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.70-5.60 mm [.185-.220 IN]		INSULATION DIAMETER RANGE Ø1.40-1.65 mm [.055-.065 IN]	
TERMINAL APPLICATION SPECIFICATION	AS-33012-002	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113245-1	33012-3003	2113245-5	33001-5003
2113245-2	33012-3023	2113245-6	33001-3023
2113245-3	34750-1003	2113245-7	33001-5023
2113245-4	33001-3005		
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
0.50mm2	1.10+/-0.05 [.043+/-0.002]	7.8	
22 AWG	1.00+/-0.05 [.039+/-0.002]	8.6	
0.35mm2	0.95+/-0.05 [.037+/-0.002]	9.1	



- 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.

*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)

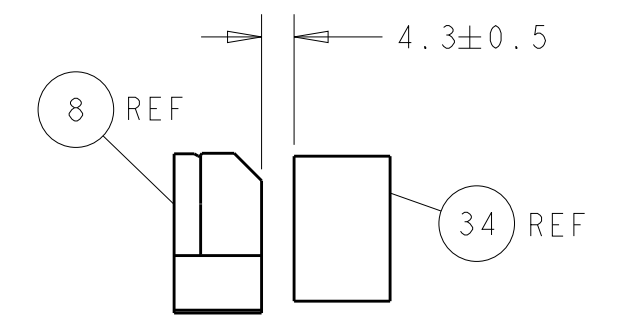
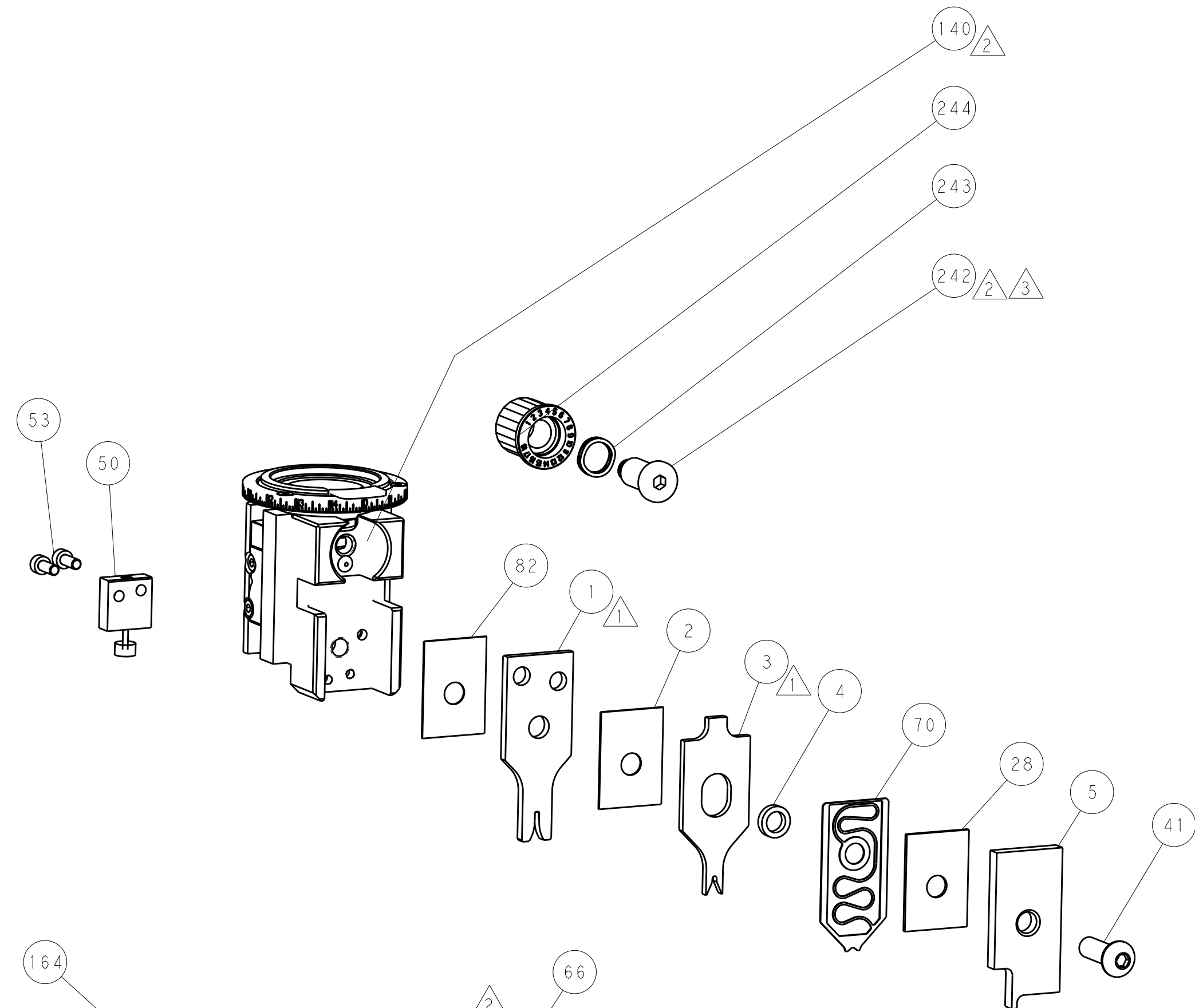
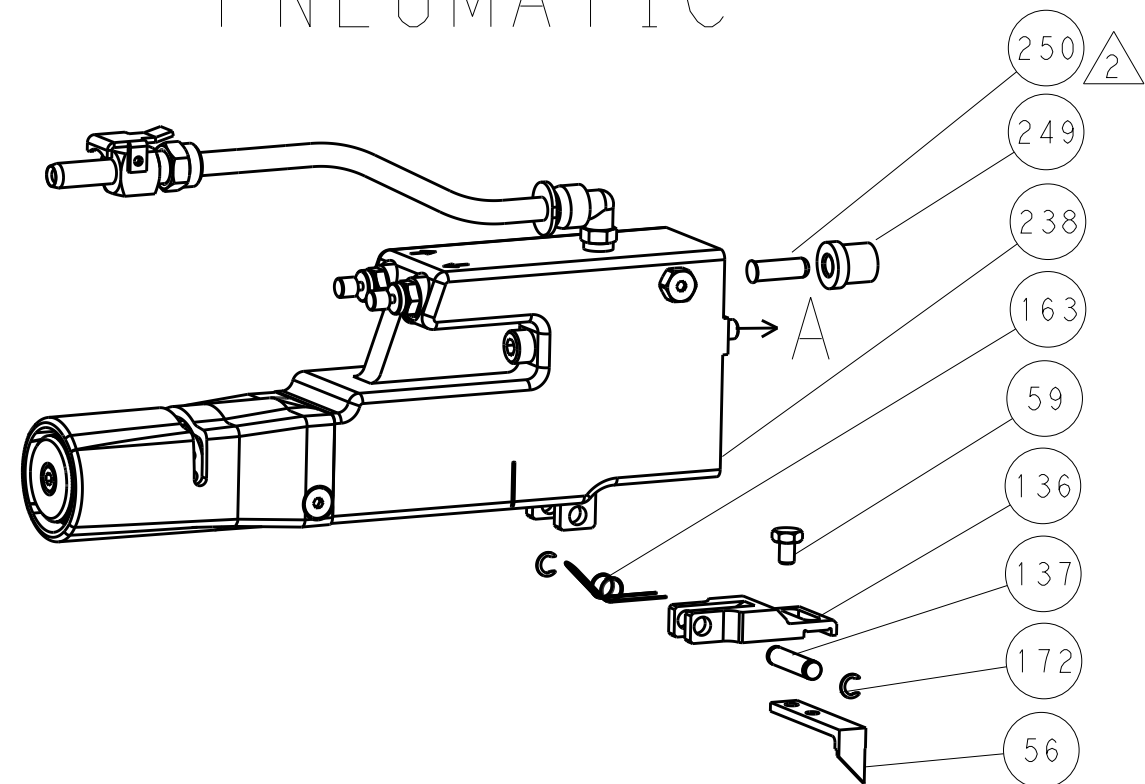
LOC	DIST	REVISIONS				
A	66	P	LTR	DESCRIPTION	DATE	OWN
		-		SEE SHEET 1	-	-

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	306
-	1	1	2-690438-2	FRONT STRIP GUIDE	305
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	304
-	1	1	356835-1	LEVER, DRAG RELEASE	303
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	302
-	1	1	240792-1	DRAG, TERMINAL	301
-	2	2	22283-1	SPRING, COMPRESSION	300
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	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	-	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	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	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	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-1	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	1633918-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	1633966-8	CRIMPER, INSULATION O	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	3-456403-8	CRIMPER, WIRE PREMIUM	1

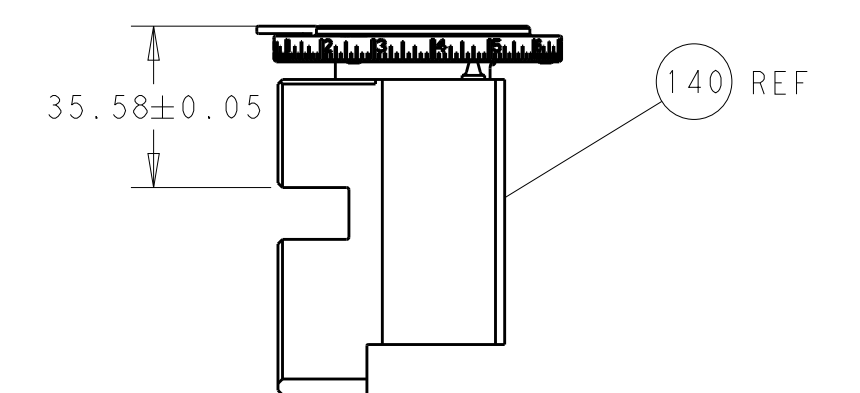
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			OWN Y. YIN CHK G. BAILEY APVD S. XI	21DEC2011 21DEC2011 21DEC2011	
			TE Connectivity Harrisburg, PA 17105-3608		
			NAME Ocean Side Feed Applicator		
			SIZE A1	CAGE CODE 00779	DRAWING NO C=2151543
			RESTRICTED TO		
			Customer Accessible Production Drawing	SCALE 1:2	SHEET 3 OF 4
			REV E		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

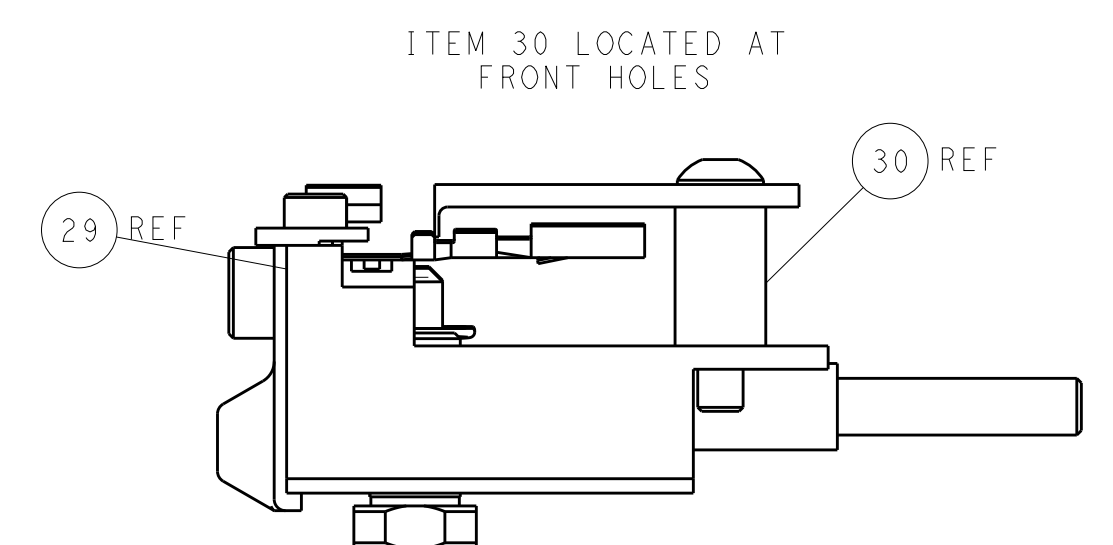
PNEUMATIC



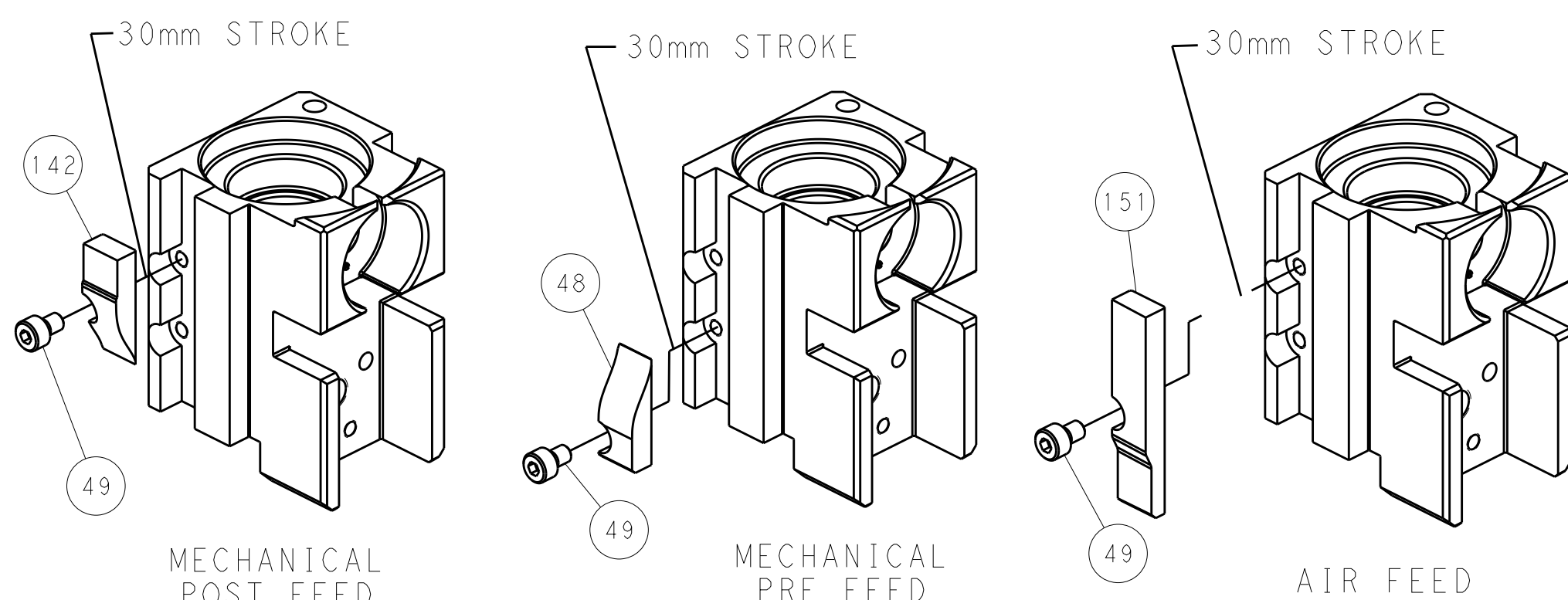
TERMINAL SUPPORT LOCATION



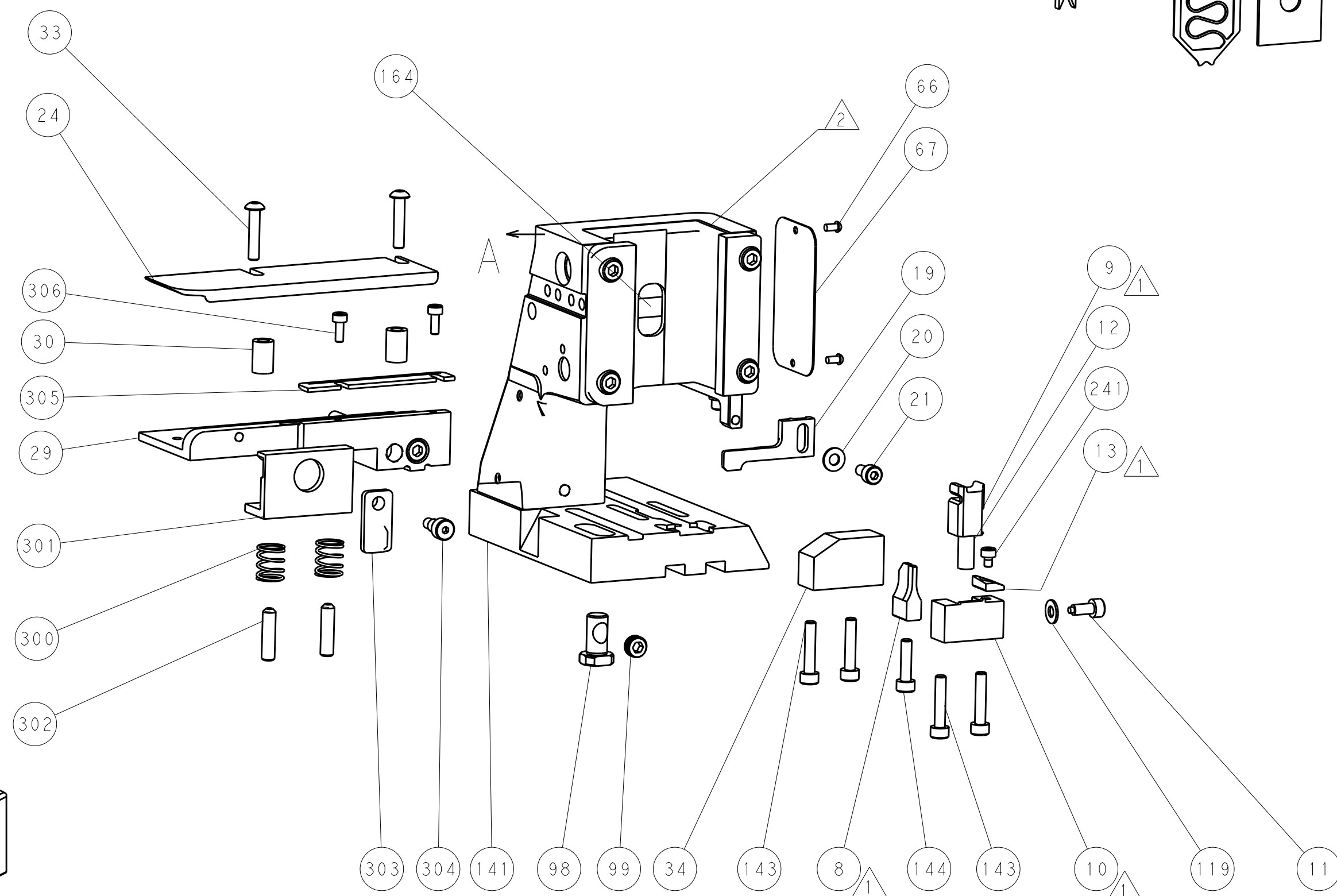
HOLDDOWN SET-UP



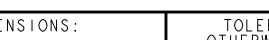
FEED TRACK POSITION
GUIDE BY WIRE BARREL



CAM POSITIONS



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 ISO 9001 CERTIFICATION COMPLIANCE. IF IT IS USED FOR PRODUCTION, IT MUST BE THE LATEST REVISION. FOR INFORMATION, YOU SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN Y YIN 21DEC2011		 IE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm		CDR G BAILEY 21DEC2011					
TOLERANCES UNLESS OTHERWISE SPECIFIED: 		NAME S XI		Ocean Side Feed Aplicator -			
		PRODUCT SPEC -					
		APPLICATION SPEC -		SIZE A1	CASE CODE 00779	DRAWING NO C-2151543	RESTRICTED TO -
MATERIAL -		FINISH -		WEIGHT -			
Customer Accessible Production Drawing							
				SCALE 1:2	SHEET 1	OF 1	REV F