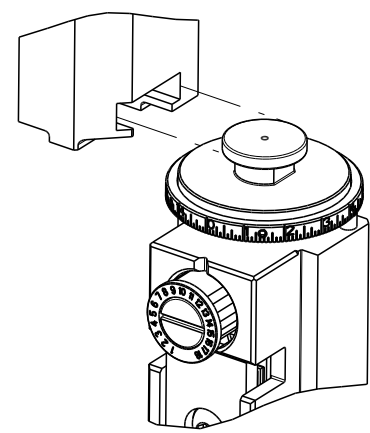




APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.54 mm [.100]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO TIMER 2 CONTACT			
WIRE STRIP LENGTH 4.00-4.60 mm [.157-.181 IN]		INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION 		-	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 962943-1	(A) 962943-5		
(A) 962943-2	(A) 962943-6		
(A) 962943-3	(A) 968052-1		
(A) 962943-4			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.20+/-0.05 [1.047+/- .002]		5.6
0.75mm2		1.18+/-0.05 [1.046+/- .002]		5.8
0.50mm2		1.15+/-0.05 [1.045+/- .002]		6.1



- 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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 LUBRICANT IS RECOMMENDED.

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

TERMINAL DATA: 1E TERMINAL		1E CRIMP SPECIFICATION	
TERMINAL NAME: MICRO TIMER 2 CONTACT			
WIRE STRIP LENGTH 4.00-4.60 mm [.157-.181 IN]		INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	(B)114-18082	-	-
TERMINALS APPLIED 			
(B)962948-1	(B)962900-3		
(B)962948-2	(B)962900-4		
(B)963900-1			
(B)962900-2			

WIRE SIZE		CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.38+/-0.05 [0.054+/-0.002]	3.8
0.75mm2		1.29+/-0.05 [0.051+/-0.002]	4.6
0.50mm2		1.20+/-0.05 [0.047+/-0.002]	5.6

* 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)

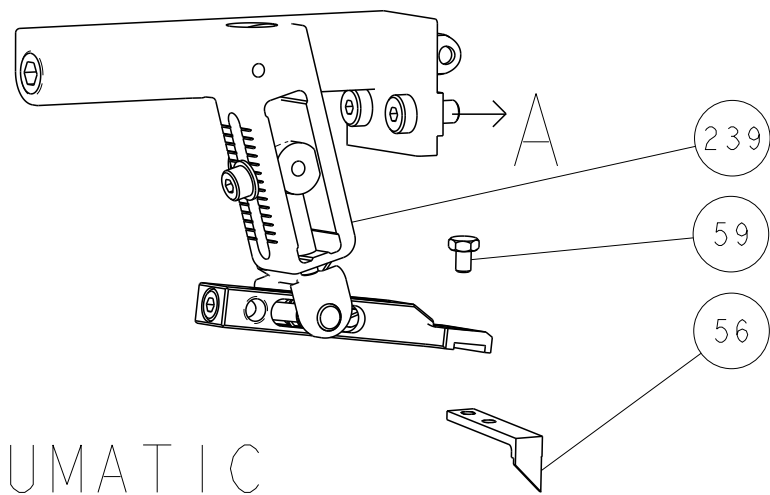
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			E	ECR-18-013630	27AUG2018	TB	TE	
			E1	ECR-18-019154	01DEC2018	JAH	GB	
			F	ECR-19-009410	15JUN2019	TB	TE	

	-	-	-	1	-	-	-	1803515-9	RAM ASSEMBLY, SF ATLANTIC	293
	-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
	-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	2844940-1	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
3	-	-	-	1	1	-	-	1-1752354-9	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
	-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	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	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
	-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-1752356-8	SUPPORT, TERMINAL	34
	-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2	2	2-2844962-8	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	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	1	1	1-1333204-5	ANVIL, COMBINATION	8
	-	1	1	1	1	1	1	240641-9	SPACER	7
	-	-	-	-	-	-	-	-	-	6
	-	1	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	1	4-2119784-0	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	1	2	2	1	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1

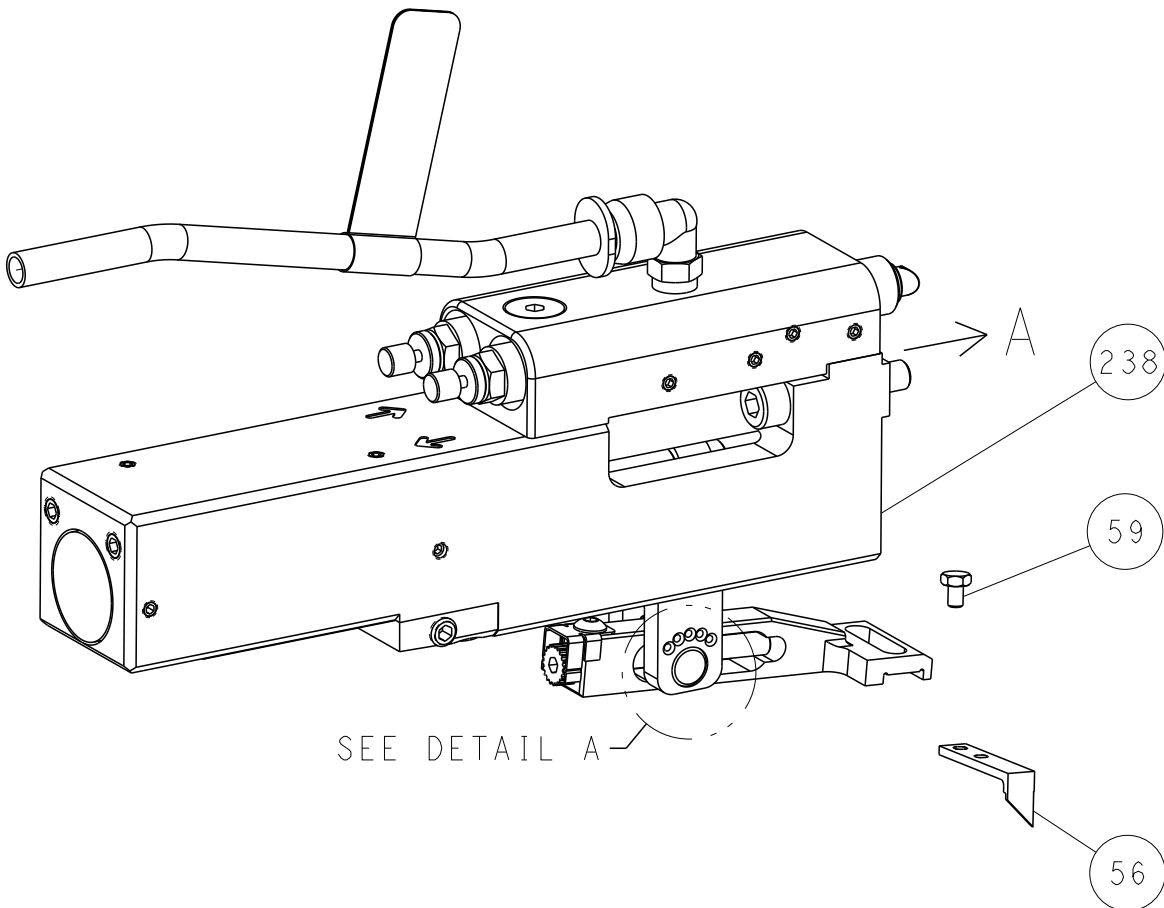
THIS DRAWING IS THE PROPERTY OF TE CONNECTIVITY. IT IS TO BE USED FOR THE MANUFACTURE OF THE PRODUCT SPECIFIED. IT IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF TE CONNECTIVITY. IT IS TO BE DESTROYED WHEN THE PRODUCT IS NO LONGER IN USE.				OWN 09DEC2011 CHK J.HUANG 09DEC2011 S-XI AP1 CRU7 09DEC2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		OCEAN SIDE FEED APPLICATOR	

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

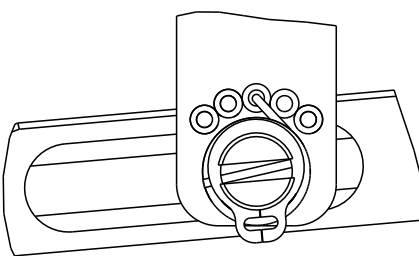
FEED TYPE MECHANICAL



PNEUMATIC

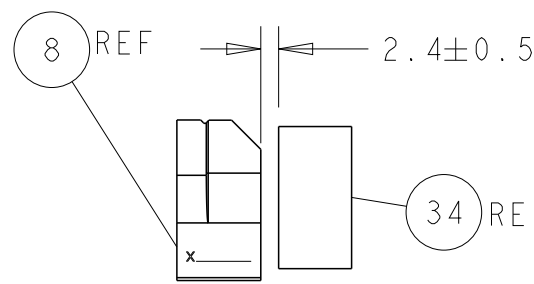
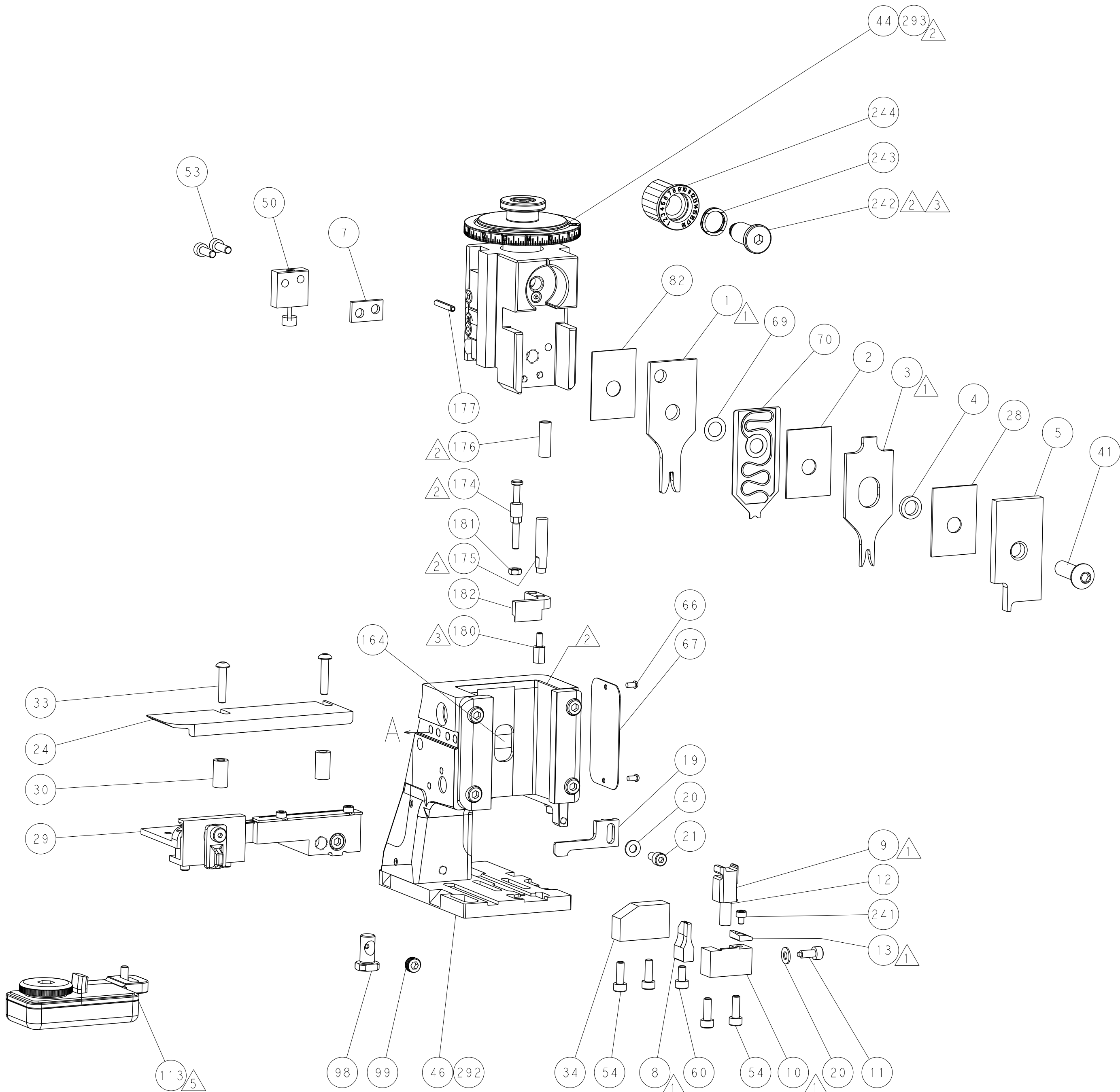
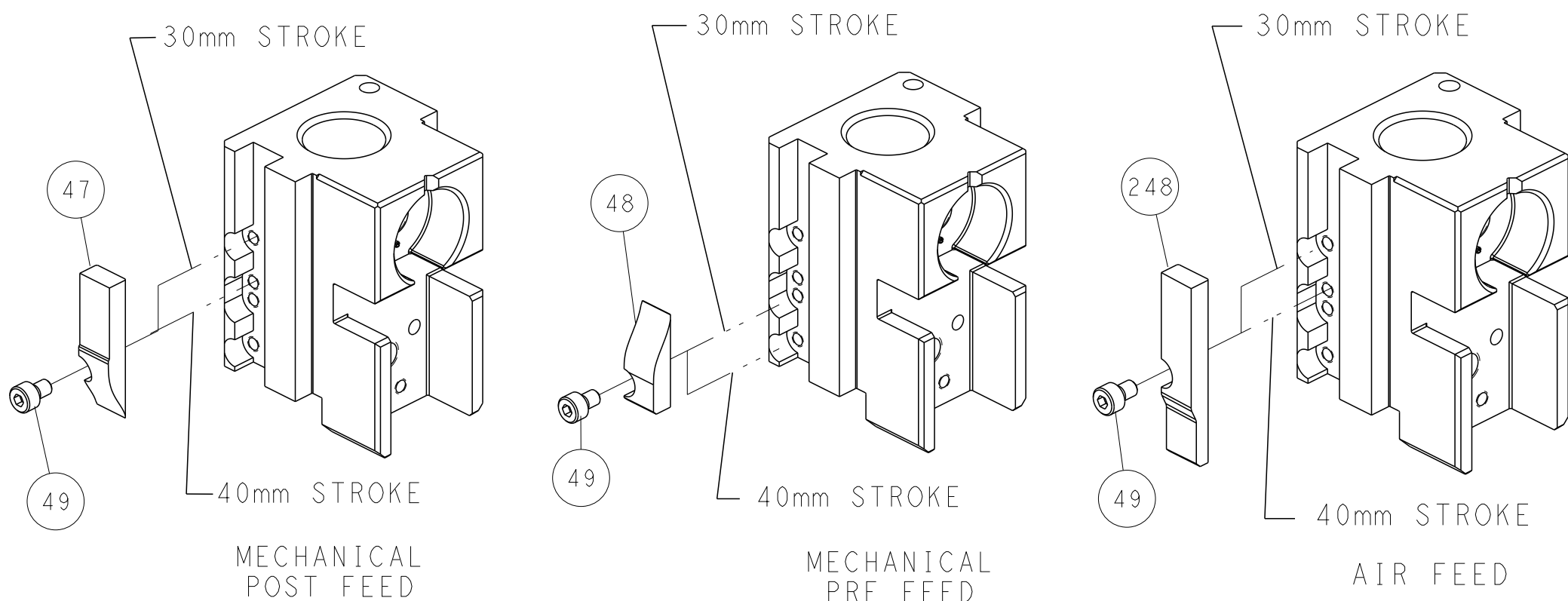


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

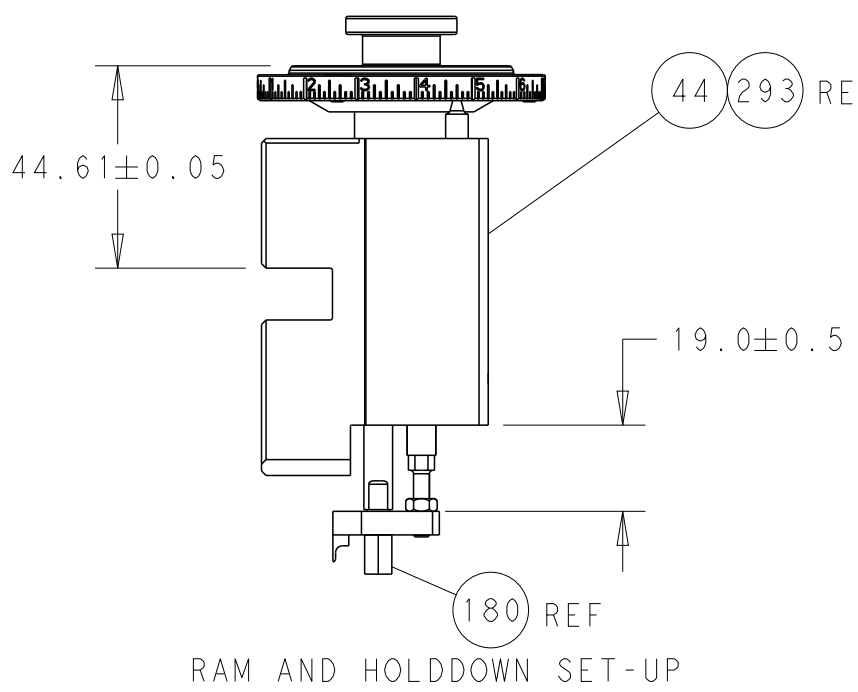


DETAIL A

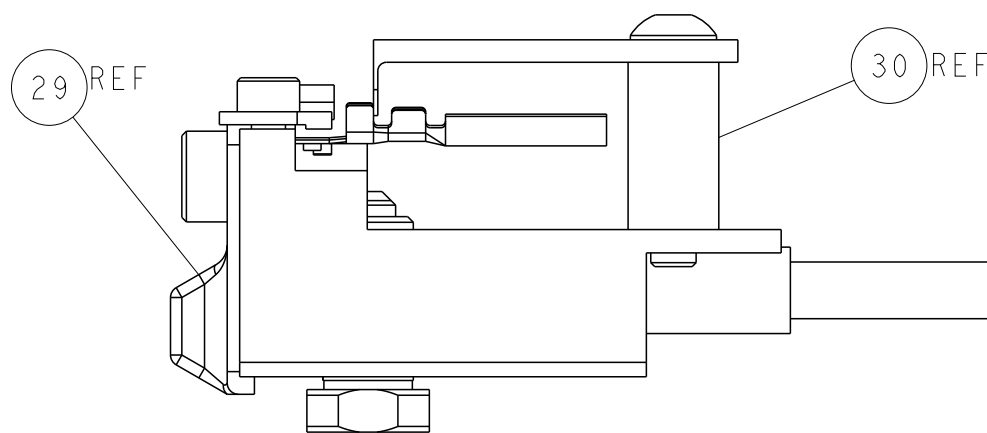
CAM POSITIONS



TERMINAL SUPPORT LOCATION

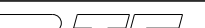
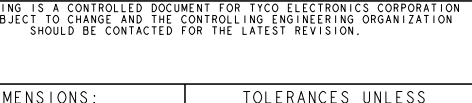


ITEM 30 LOCATED AT
FRONT HOLES



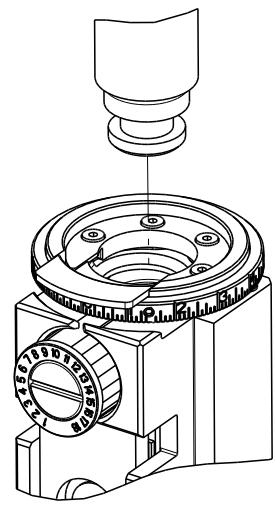
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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										CHK		S. XI		09DEC2011		Harrisburg, PA 17105-3608							
										PRODUCT SPEC										NAME			
										APPLICATION SPEC													
MATERIAL										SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO							
FINISH										A1		00779		C=2151279		-							
Customer Accessible Production Drawing										SCALE		1:2		SHEET		2 of 4		REV					
																		F					

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151279-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151279-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151279-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.54 mm [.100]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO TIMER 2 CONTACT			
WIRE STRIP LENGTH 4.00-4.60 mm [.157-.181 IN]		INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION 		(A) 114-18081	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 962943-1	(A) 962943-5		
(A) 962943-2	(A) 962943-6		
(A) 962943-3	(A) 968052-1		
(A) 962943-4			

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2			1.20+/-0.05 [0.047+/-0.002]		5.6
0.75mm2			1.18+/-0.05 [0.046+/-0.002]		5.8
0.50mm2			1.15+/-0.05 [0.045+/-0.002]		6.1



- 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 TERMINAL LUBRICANT IS RECOMMENDED.

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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO TIMER 2 CONTACT			
WIRE STRIP LENGTH 4.00-4.60 mm [.157-.181 IN]		INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	(B)114-18082	-	-
TERMINALS APPLIED 			
(B)962948-1	(B)962900-3		
(B)962948-2	(B)962900-4		
(B)963900-1			
(B)962900-2			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT ⁴⁾ REFERENCE SETTING
1.00mm2		1.38+/-0.05 [0.054+/-0.002]		3.8
0.75mm2		1.29+/-0.05 [0.051+/-0.002]		4.6
0.50mm2		1.20+/-0.05 [0.047+/-0.002]		5.6

*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)

[illegible]

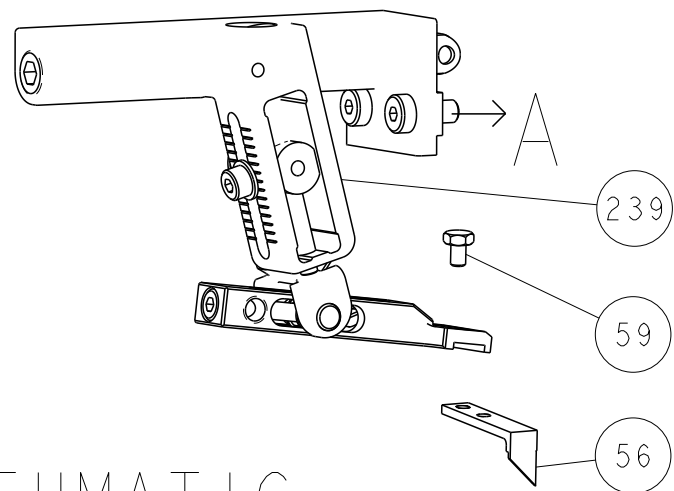
	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	242
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	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	144
	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1-1803533-0	APPLICATOR BASIC ASSEMBLY, SF	141
5	-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	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	2119791-5	DEPRESSOR, WIRE	70
	-	1	1	2119943-1	WASHER, SPACER	69
	-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-1752356-8	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-8	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	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	454276-5	FLOATING SHEAR, FRONT	9
1	1	1	1	1-1333204-5	ANVIL, COMBINATION	8
	-	1	1	240641-9	SPACER	7
	-	-	-	-	-	6
	-	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	4-2119784-0	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
	-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± ANGLES ± FINISH		NAME OCEAN SIDE FEED APPLICATOR	
		PRODUCT SPEC		-	
		APPLICATION SPEC		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
MATERIAL		WEIGHT		A 00779 C=2151279 -	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV F	

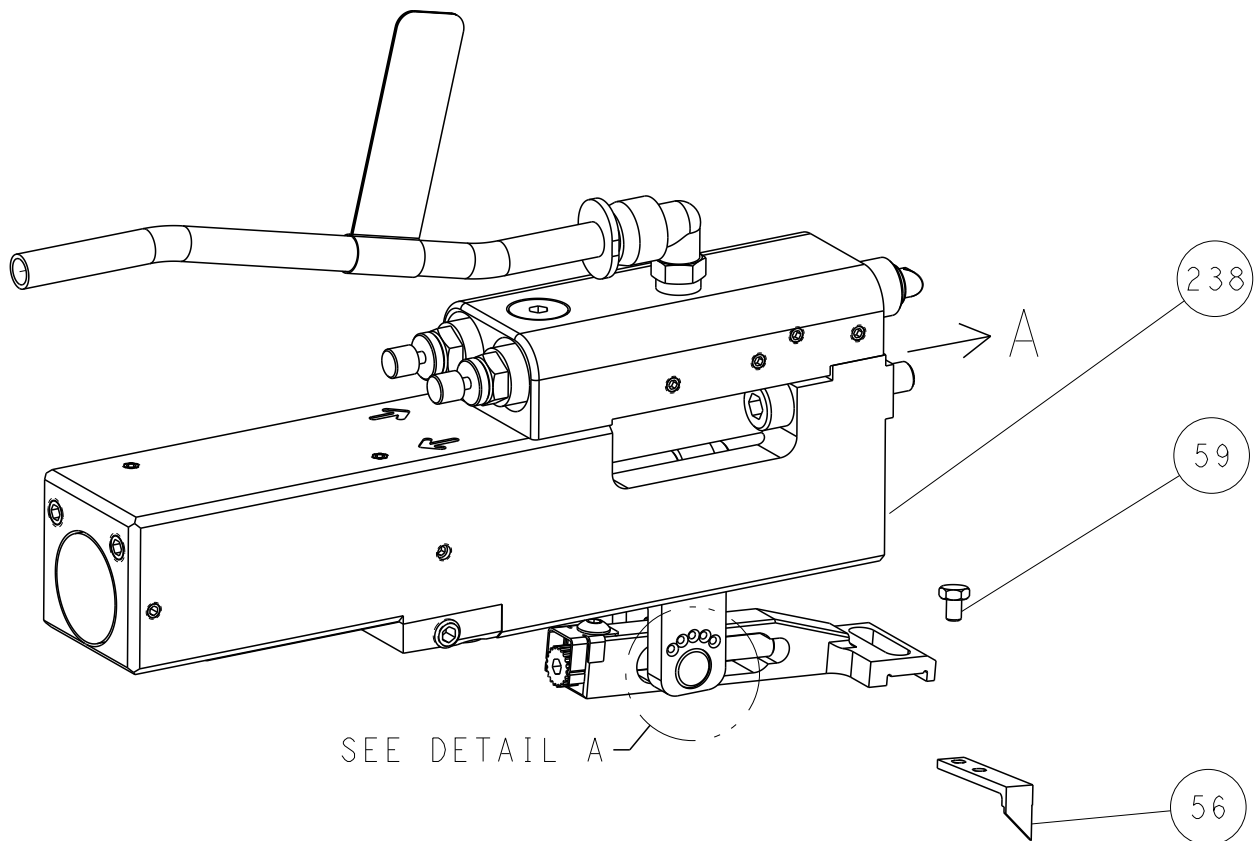
LOC		DIST		REVISIONS				
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
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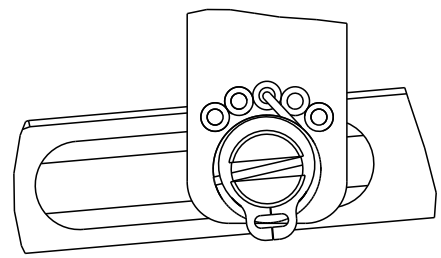
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PNEUMATIC

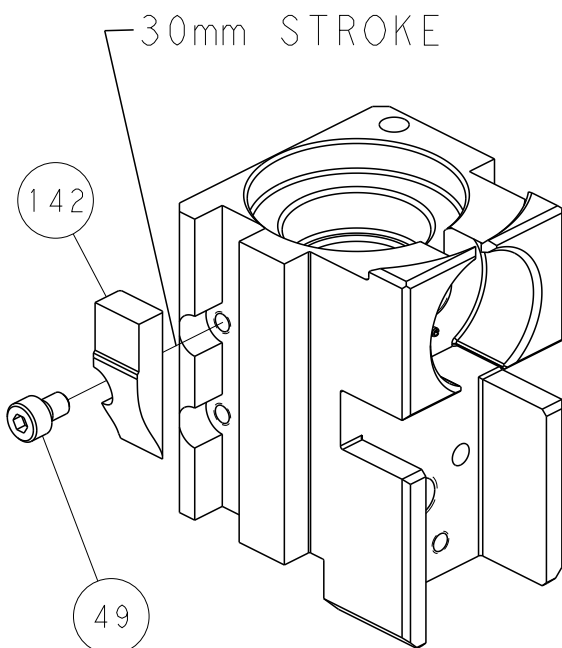


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

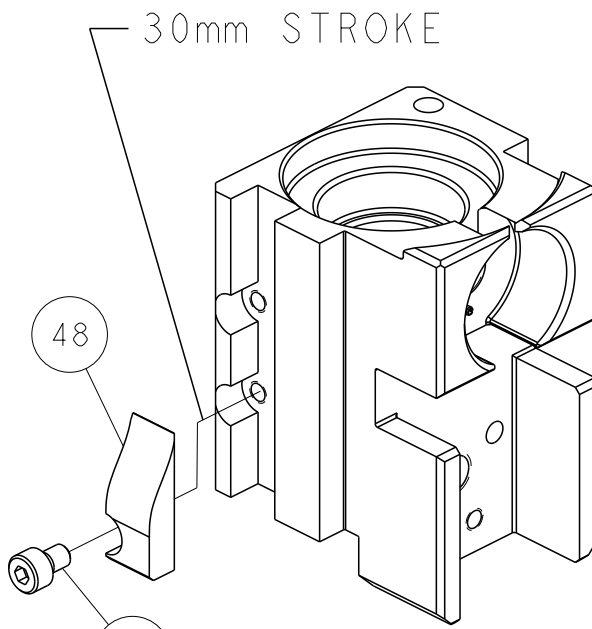


DETAIL A

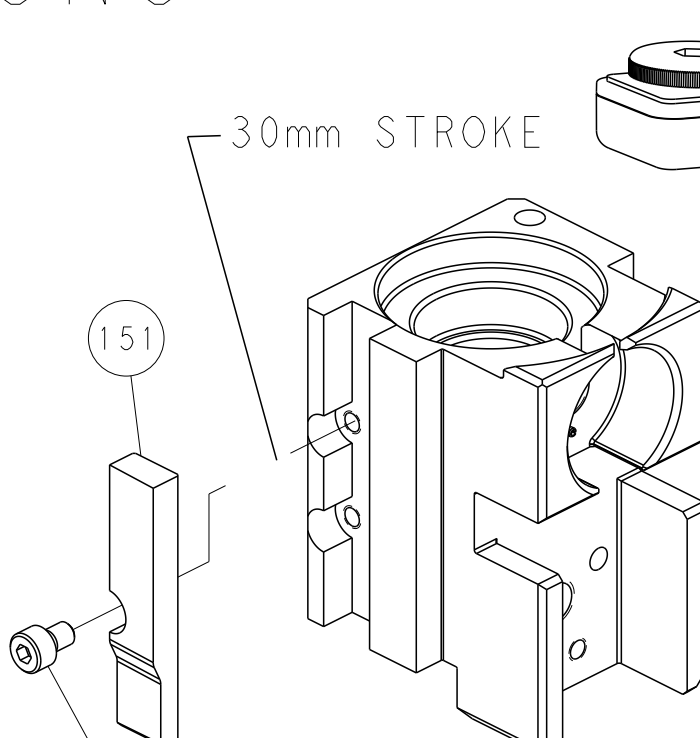
CAM POSITIONS



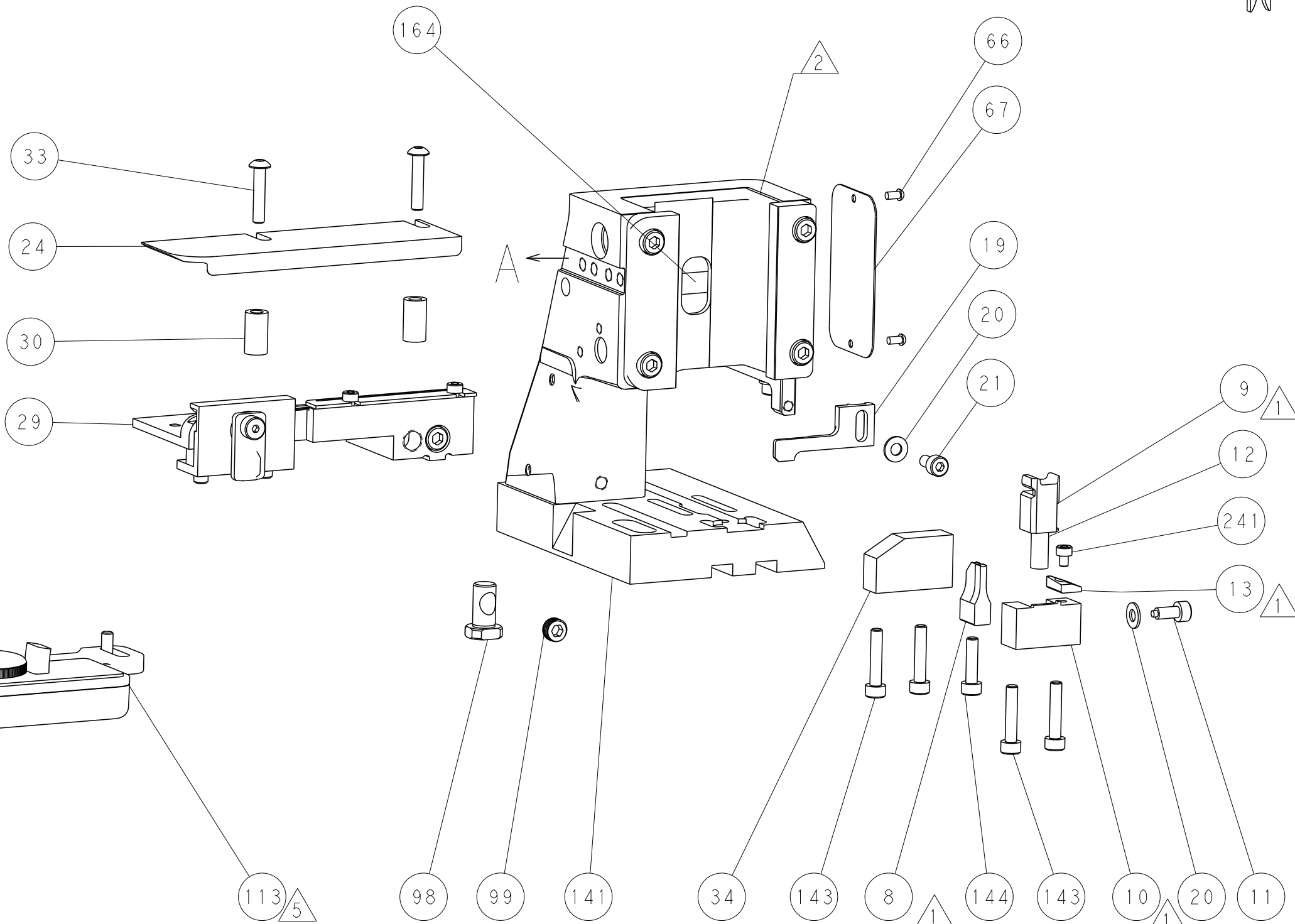
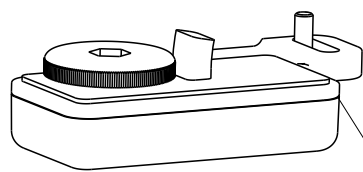
MECHANICAL
POST FEED



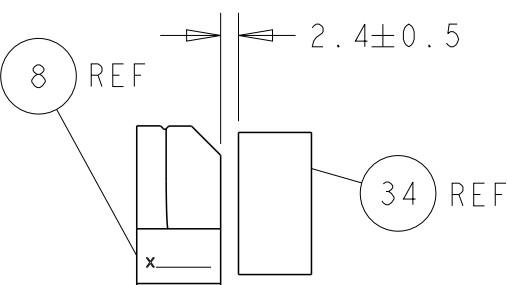
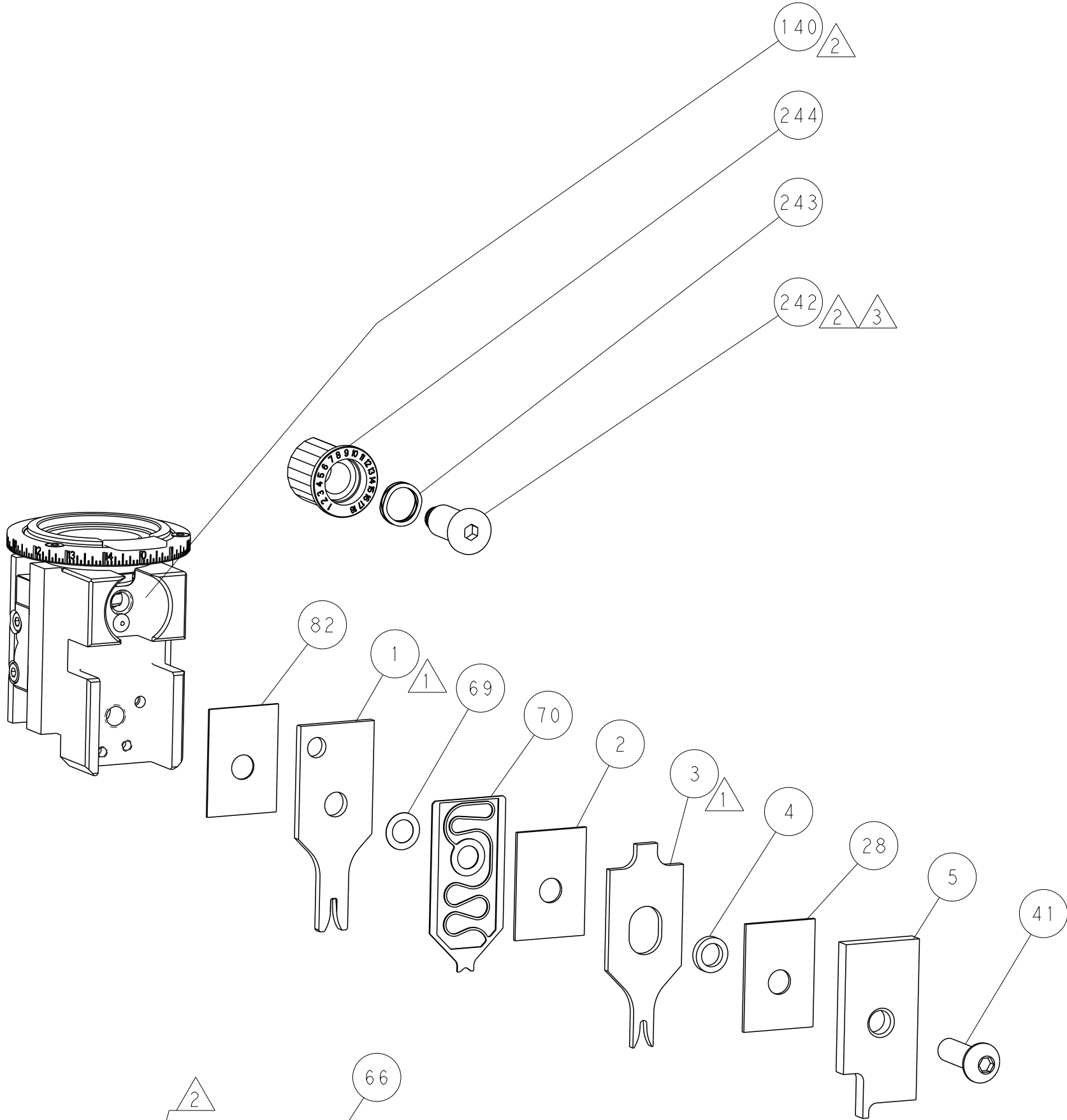
MECHANICAL
PRE FEED



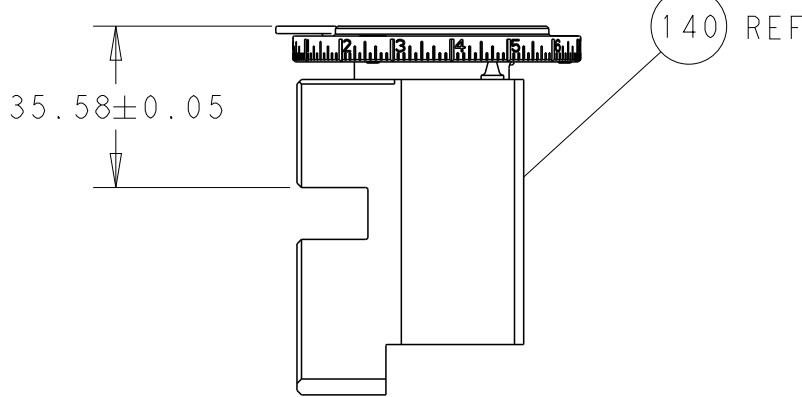
AIR FEED



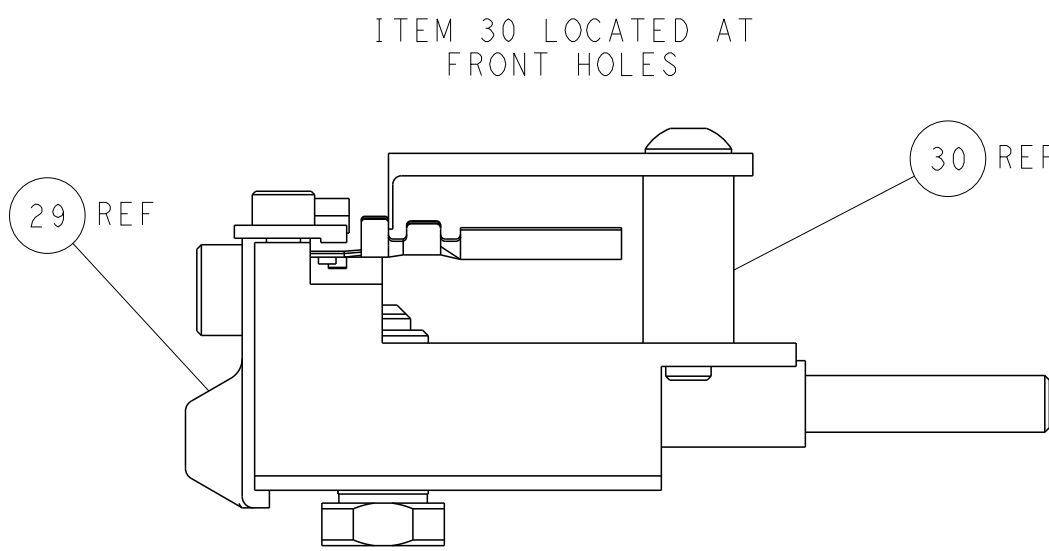
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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				CHK S. XI	09DEC2011			
				APVD J. CRUZ	09DEC2011	NAME OCEAN SIDE FEED APPLICATOR		
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		
mm				0 PLC ±		APPLICATION SPEC		
				1 PLC ±				
				2 PLC ±				
				3 PLC ±				
				4 PLC ±				
				ANGLES ±				
				FINISH ±				
MATERIAL				WEIGHT		SIZE A1		
						CAGE CODE 00779		
						DRAWING NO C=2151279		
						RESTRICTED TO		
						Customer Accessible Production Drawing		
						SCALE 1:2		
						SHEET 4		
						OF 4		
						REV F		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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