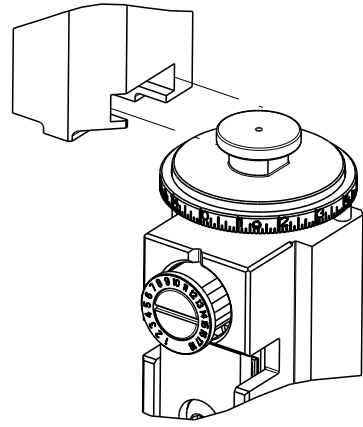


8	7
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RELEASED FOR PUBLICATION 2012	
© COPYRIGHT 2012 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION
2151699-2	D
7-2151699-2	D
7-2151699-7	A
DESCRIPTION	FEED TYPE
FINE CRIMP HEIGHT ADJUST	PNEUMATIC
PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



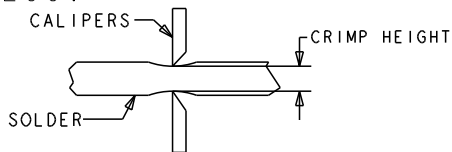
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.205 [5.21 mm]	D
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CONNECTIVITY CRIMP SPECIFICATION			
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH .296-.328 IN [7.52-8.33 mm]		INSULATION DIAMETER RANGE Ø .320 IN [8.13 mm] MAX	
TERMINAL APPLICATION SPECIFICATION 114-2123 Rev G	-	-	-
TERMINALS APPLIED			
TE TERMINAL 3-520370-2	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT INCH [mm]		CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14		0.075+/-0.002 [1.91+/-0.05]		5.6	.19 IN [4.83mm]
16		0.070+/-0.002 [1.78+/-0.05]		7.0	.19 IN [4.83mm]



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- 5 ITEM 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- 6 TO CHECK CRIMP HEIGHT. CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



- 7 IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
- 8 ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- 9 ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- 10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

11. 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.

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
A	66
REVISONS	
P	LYR
B	ECR-18-001327
C	ECR-18-016781
C1	ECR-18-017084
D	ECR-20-016470

9	-	1	1	2280441-1	INSERT, SHEAR	282	
	-	REF	REF	462992-7	GUARD ASSEMBLY	257	
9	-	REF	REF	679532-1	INSERT, GUARD	256	
8	-	1	1	189728-1	BRACKET, SPACER	255	
	-	1	1	568681-1	SPACER, BASE PLATE	253	
5	-	1	1	2119641-1	FEED CAM, AIR FEED	248	
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
	-	1	1	2844940-2	AIR FEED MODULE	238	
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	1	1	1-22281-8	SPRING, COMPRESSION	121	
	-	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	1-690438-0	FRONT STRIP GUIDE	96	
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
	-	4	4	18023-4	SCR, SKT HD CAP M3 X 10.0	94	
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
	-	1	1	455888-4	SPACER, CRIMPER	82	
	-	1	1	240641-9	SPACER	81	
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
	-	1	1	2161332-4	DEPRESSOR, WIRE FUNNEL	70	
	-	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69	
	-	2	2	1-18028-4	WASHER, FLAT, REG M3	68	
	-	1	1	2119740-1	TAG,IDENTIFICATION	67	
5	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	1	1	462427-2	FINGER, FEED	56	
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
	-	1	1	1-1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
	-	1	1	462433-7	SUPPORT, INSULATION	42	
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
	-	2	2	5-22278-1	SPRING, COMPRESSION	33	
	-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30	
	-	1	1	2161336-2	PLATE, REAR STRIP GUIDE	29	
	-	2	2	22281-9	SPRING, COMPRESSION	27	
	-	1	1	356835-1	LEVER, DRAG RELEASE	26	
	-	1	1	240792-1	DRAG, TERMINAL	25	
	-	1	1	684042-4	GUIDE, STRIP, FRONT	24	
	1	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-		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	463460-2	HOLD DOWN, TERMINAL	18	
-		1	1	469542-3	REAR FLOATING SHEAR	17	
-		2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-		1	1	2161335-2	SHEAR PLATE, REAR	15	
-		1	1	2119862-2	SHEAR HOLDER, REAR	14	
-		1	1	3-22280-3	SPRING, COMPRESSION	12	
-		1	1	1-356885-4	STOP, SHEAR	11	
-		-	-	-	-	10	
-		1	1	462843-6	TERMINAL SUPPORT	9	
1		2	1	464282-2	ANVIL, SAND-BLASTED 16-14	8	
4		-	1	803925-2	GUIDE, CARRIER SCRAP	7	
5		-	1	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
		-	1	1	462431-5	WIRE FUNNEL	5
		-	1	1	238011-1	BLOCK, CRIMPER SPACER	4
		-	-	-	-	-	3
1		-	-	-	-	-	2
	1	2	1	464281-1	CRIMPER, SEMI FLAT 16-14	1	
-77-72 2 PART NO				DESCRIPTION	ITEM NO		

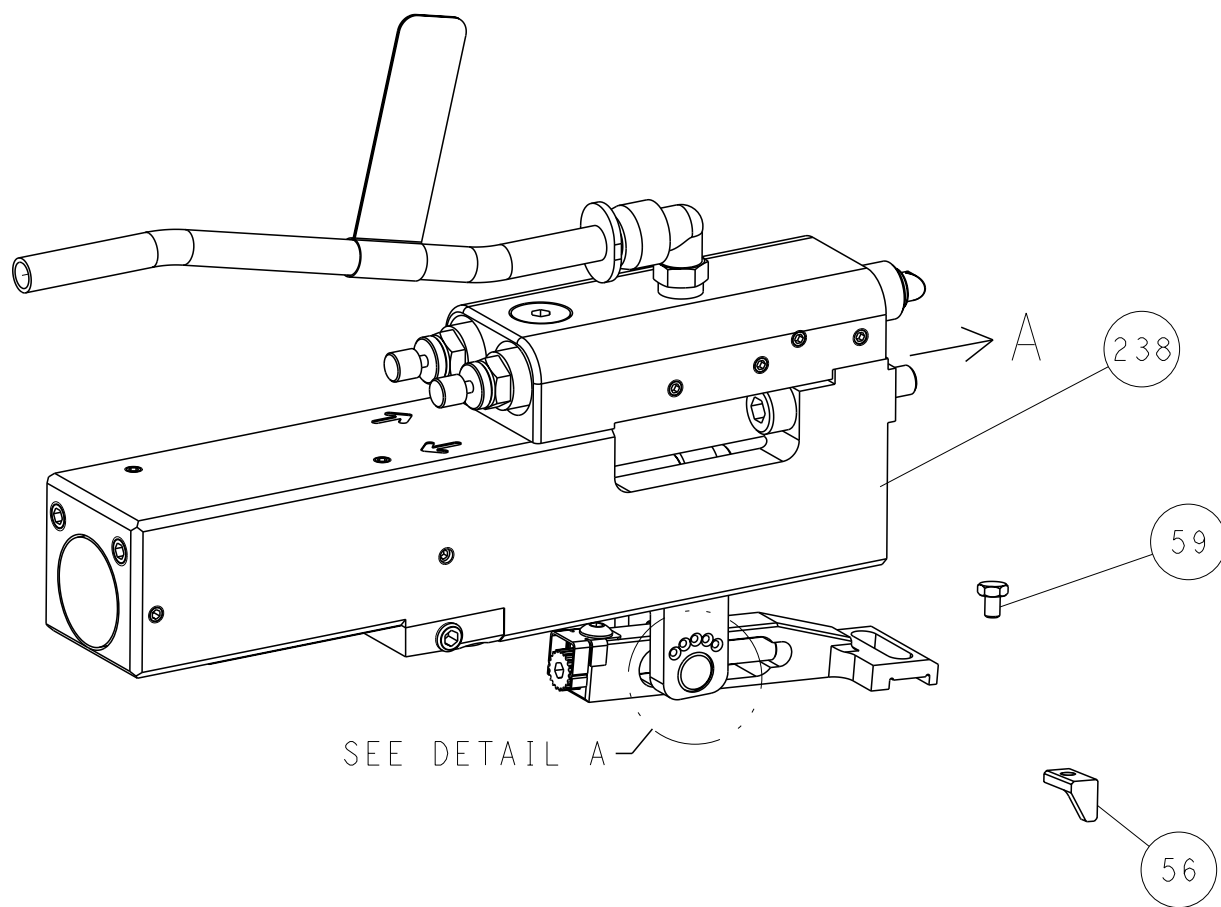
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE USED FOR THE LATEST REVISION. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN D. WEAVER CHK G. HOFENER APVD T. ELBIN	18JUN2012 18JUN2012 18JUN2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
MATERIAL -		FINISH -		SIZE A1	
				CAGE CODE 00779	
				DRAWING NO ©=2151699	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 1	
				OF 4	
				REV D	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

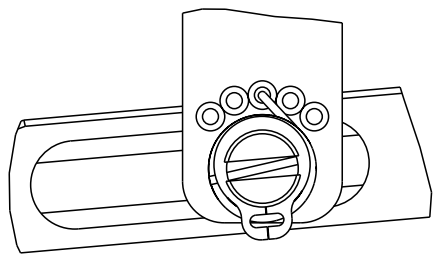
LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

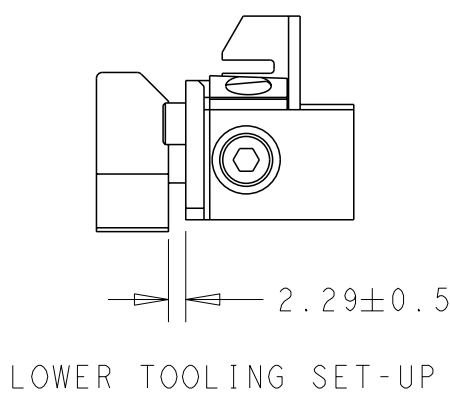
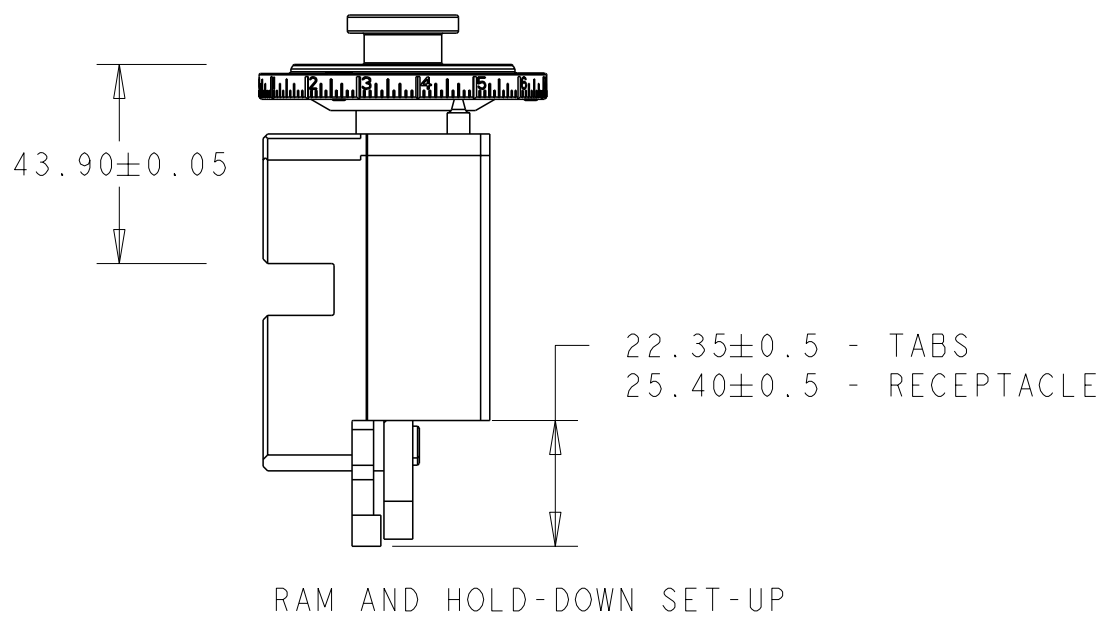
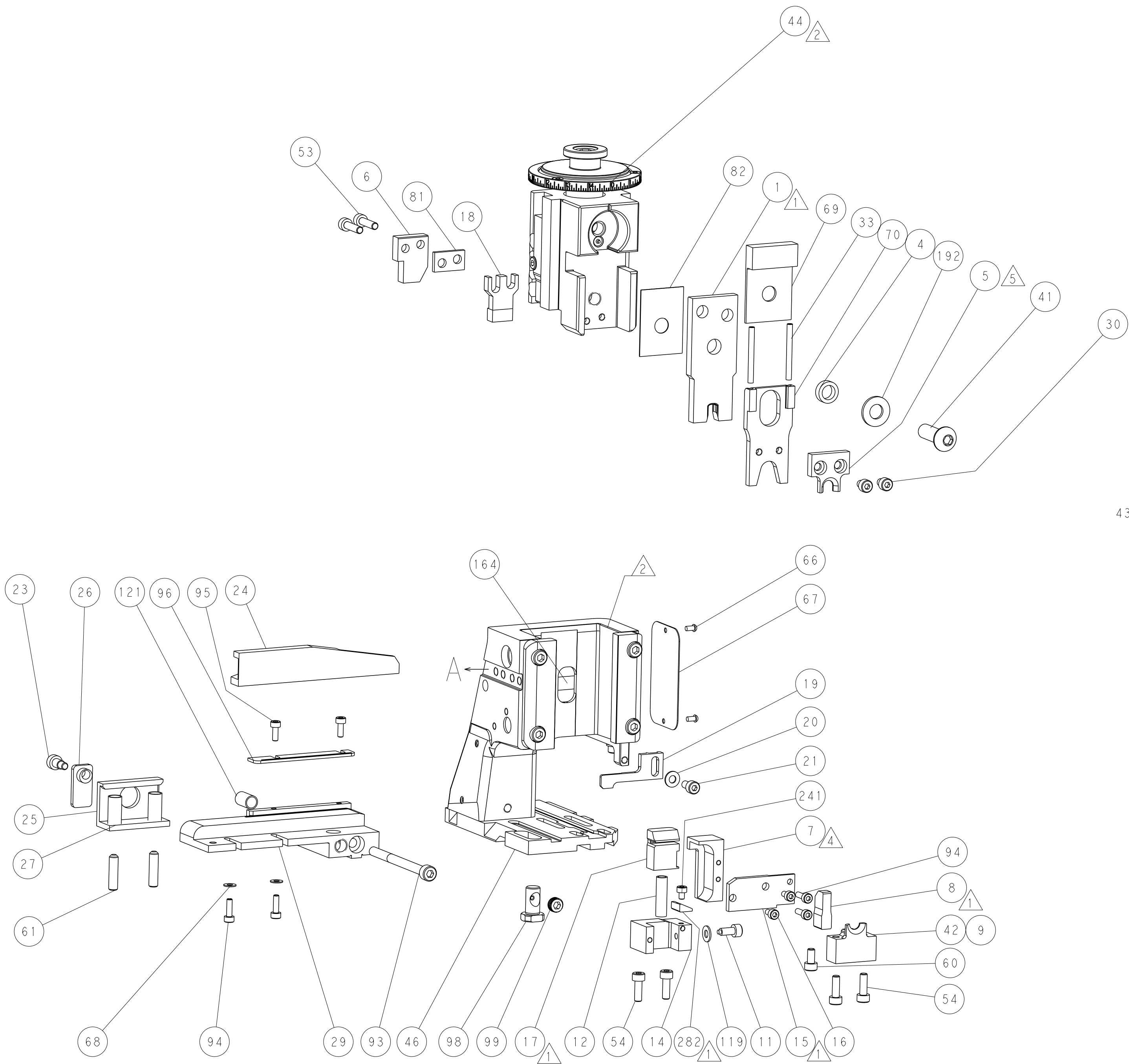
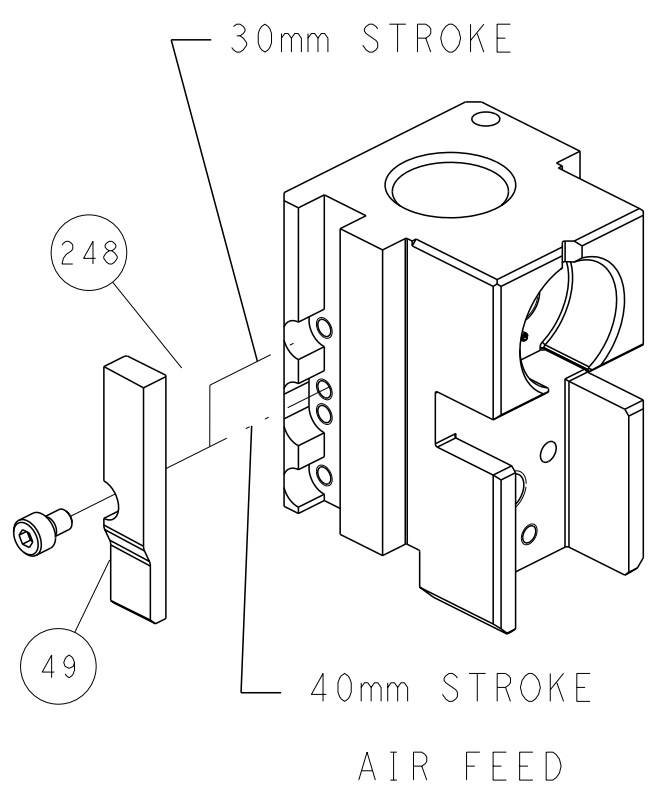


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS

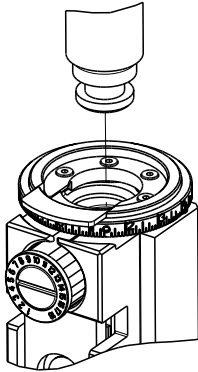


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1111 DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION SHALL BE CONTACTED FOR THE LATEST REVISION				DWN B. WEAVER 18JUN2012	TE Connectivity Harrisburg, PA 17105-3608	
				CHK G. HOFENER 18JUN2012		
				APVD T. ELBIN 18JUN2012	NAME Ocean Side Feed Applicator	
				PRODUCT SPEC		
				APPLICATION SPEC		
				WEIGHT		
				Customer Accessible Production Drawing		
				SCALE	1:1	SHEET 2 OF 4
				REV	D	

8		7	
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2012		2012	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151699-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151699-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



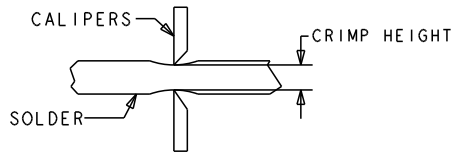
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.205 [5.21 mm]	D
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CONNECTIVITY CRIMP SPECIFICATION			
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH .296-.328 IN [7.52-8.33 mm]		INSULATION DIAMETER RANGE Ø .320 IN [8.13 mm] MAX	
TERMINAL APPLICATION SPECIFICATION	114-2123 Rev G	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-520370-2			

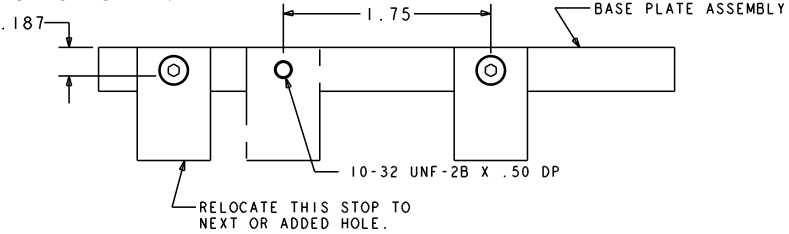
WIRE SIZE		CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14		0.075+/-0.002 [1.91+/-0.05]	5.6	.19 IN [4.83mm]
16		0.070+/-0.002 [1.78+/-0.05]	7.0	.19 IN [4.83mm]



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- ITEM 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- TO CHECK CRIMP HEIGHT. CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



- IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.



- ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD. ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

11. 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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

1	-	1	2280441-1	INSERT, SHEAR	282
9	-	REF	462992-7	GUARD ASSEMBLY	257
9	-	REF	679532-1	INSERT, GUARD	256
8	-	1	189728-1	BRACKET, SPACER	255
8	-	1	568681-1	SPACER, BASE PLATE	253
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2844940-2	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	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	2-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1-22281-8	SPRING, COMPRESSION	121
	-	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	4	18023-4	SCR, SKT HD CAP M3 X 10.0	94
	-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	455888-4	SPACER, CRIMPER	82
	-	1	240641-9	SPACER	81
	-	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	2161332-4	DEPRESSOR, WIRE FUNNEL	70
	-	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
	-	2	1-18028-4	WASHER, FLAT, REG M3	68
	-	1	2119740-1	TAG IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	462427-2	FINGER, FEED	56
	-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
5	-	1	462433-7	SUPPORT, INSULATION	42
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	2	5-22278-1	SPRING, COMPRESSION	33
	-	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
	-	1	2161336-2	PLATE, REAR STRIP GUIDE	29
	-	2	22281-9	SPRING, COMPRESSION	27
	-	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	240792-1	DRAG, TERMINAL	25
	-	1	684042-4	GUIDE, STRIP, FRONT	24
	-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	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	463460-2	HOLD DOWN, TERMINAL	18
1	-	1	469542-3	REAR FLOATING SHEAR	17
	-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
1	-	1	2161335-2	SHEAR PLATE, REAR	15
	-	1	2119862-2	SHEAR HOLDER, REAR	14
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-4	STOP, SHEAR	11
	-	-	-	-	10
5	-	1	462843-6	TERMINAL SUPPORT	9
1	1	1	464282-2	ANVIL, SAND-BLASTED 16-14	8
4	-	1	803925-2	GUIDE, CARRIER SCRAP	7
	-	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
5	-	1	462431-5	WIRE FUNNEL	5
	-	1	238011-1	BLOCK, CRIMPER SPACER	4
	-	-	-	-	3
	-	-	-	-	2
1	1	1	464281-1	CRIMPER, SEMI FLAT 16-14	1
-77 -22		PART NO		DESCRIPTION	ITEM NO

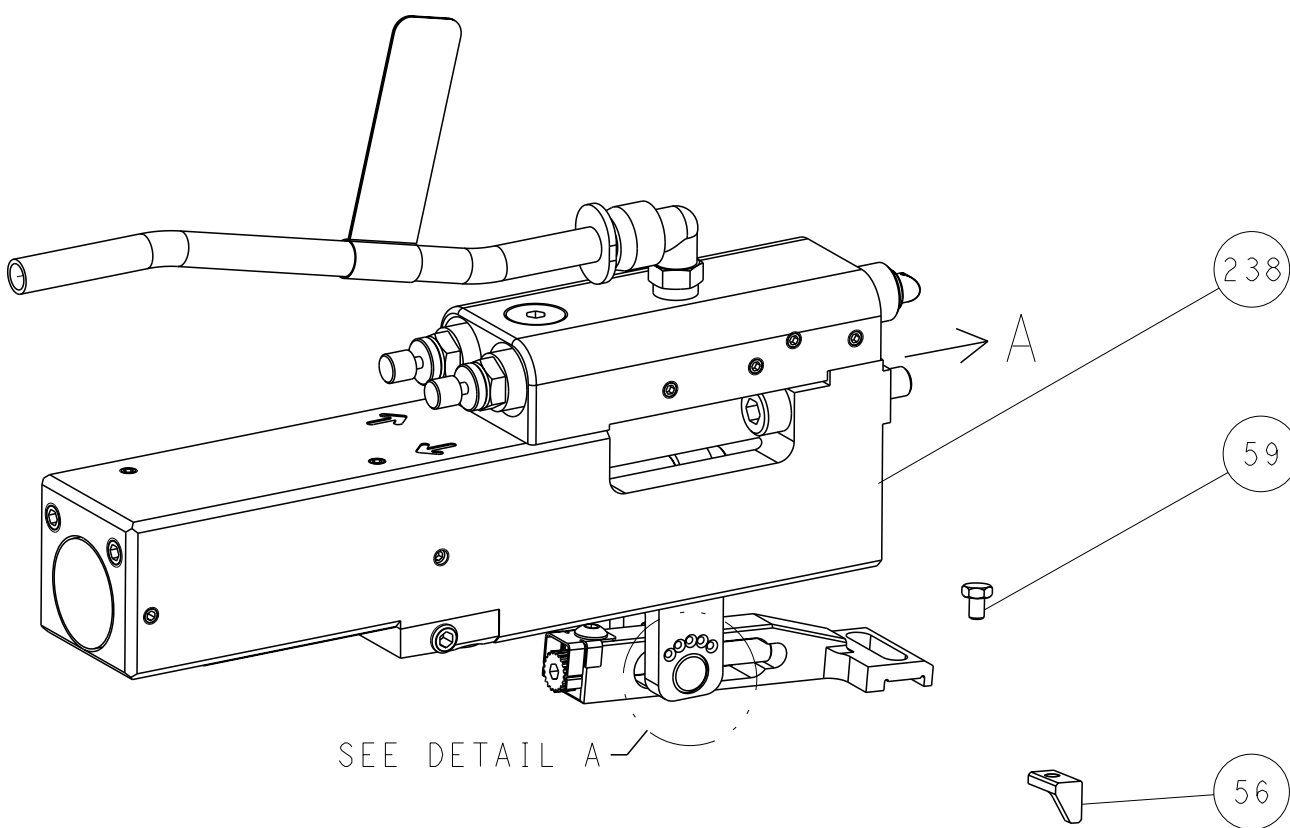
THIS DRAWING IS A CONTROLLED DOCUMENT FOR YOUR FACILITY. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN B. WEAVER 18JUN2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. HOFFNER 18JUN2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		APVD T. ELBIN 18JUN2012	PRODUCT SPEC	
MATERIAL -		FINISH -	APPLICATION SPEC	
-		WEIGHT -	SIZE A1	
-		SCALE 1:1	DRAWING NO 00779	
-		RESTRICTED TO -	REV D	
Customer Accessible Production Drawing		SCALE 1:1	SHEET 3	
-		REV D	REV D	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

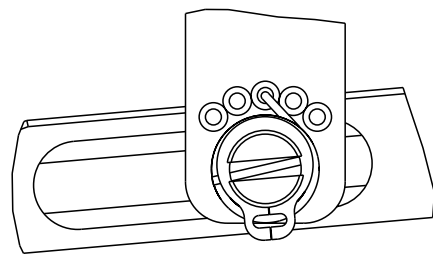
FEED TYPE

PNEUMATIC



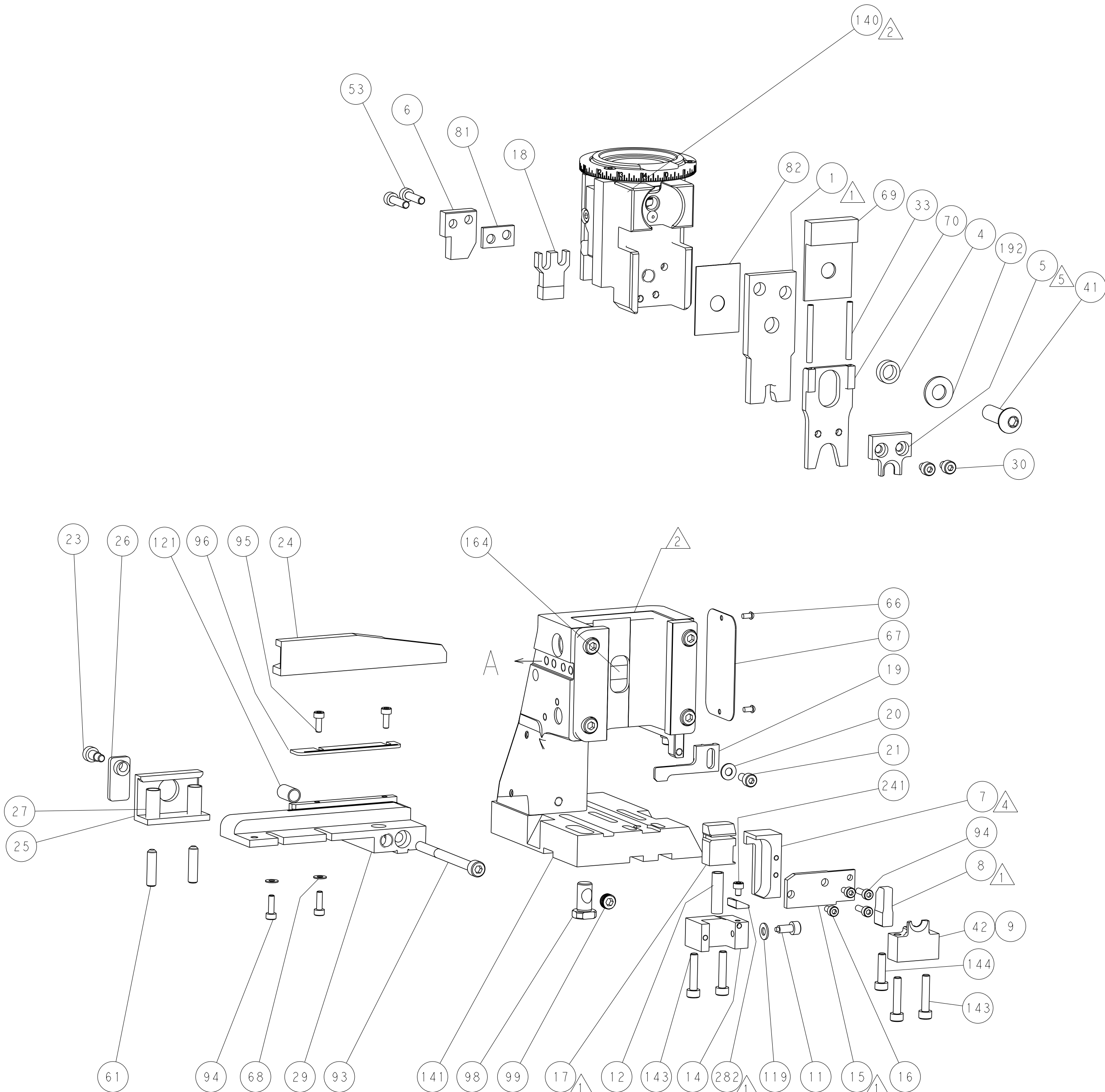
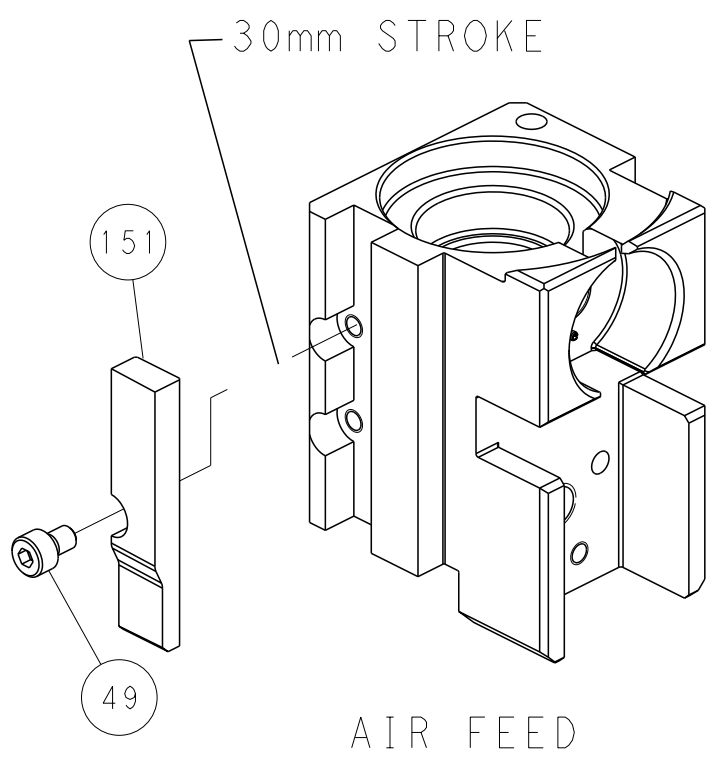
FEED SPRING SETTING POSITION

(SHOWN FROM REAR SIDE)



DETAIL A

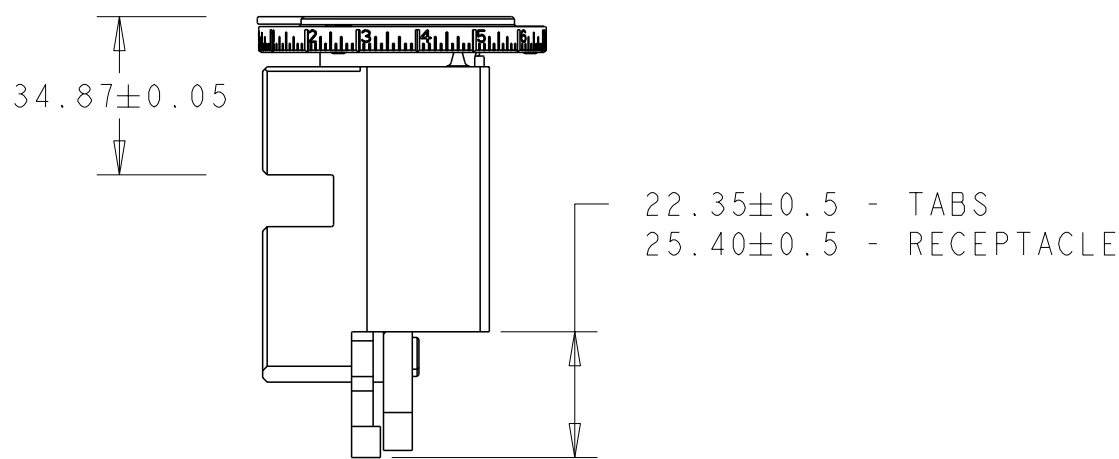
CAM POSITION



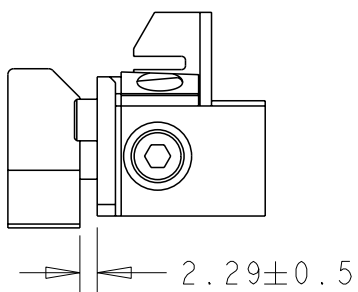
PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

(Atlantic version shown on sheets 1 of 4 & 2 of 4)



RAM AND HOLD-DOWN SET-UP



LOWER TOOLING SET-UP

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME		Ocean Side Feed Applicator					
mm		0 PLC ±.0 1 PLC ±.0 2 PLC ±.0 3 PLC ±.0 4 PLC ±.0 ANGLES ±.0		APPLICATION SPEC		SIZE		CAGE CODE		DRAWING NO			
		FINISH		WEIGHT		A 00779		C=2151699		RESTRICTED TO			
MATERIAL													
						Customer Accessible Production Drawing		SCALE		1:1			
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