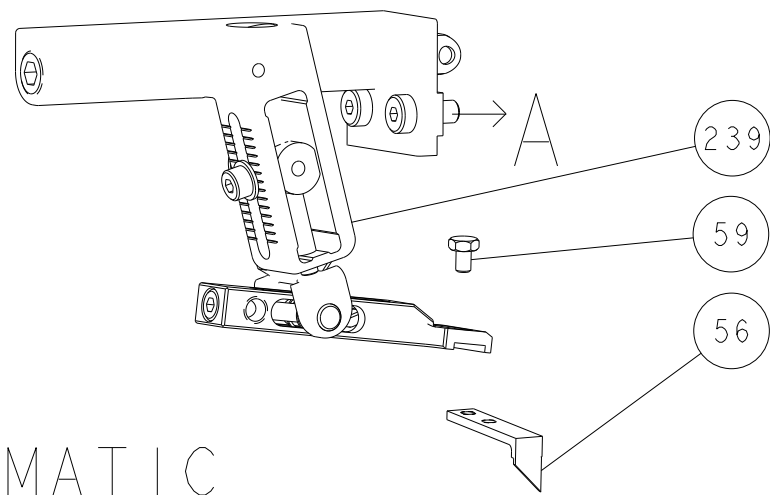


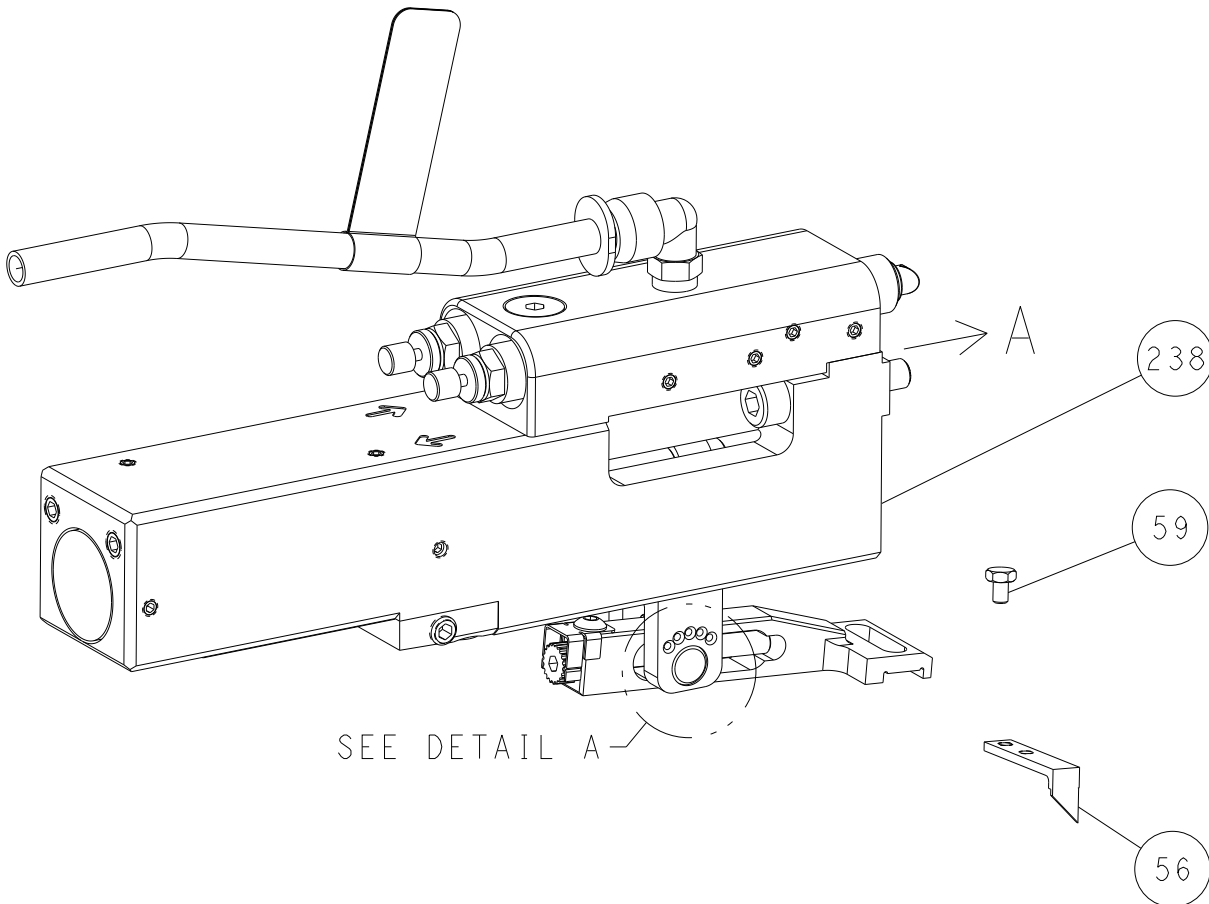
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LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

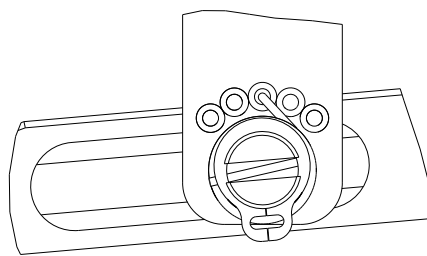
FEED TYPE MECHANICAL



PNEUMATIC

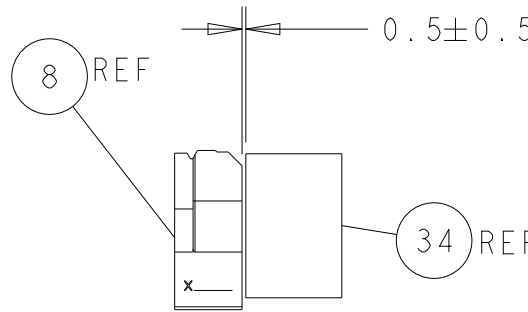
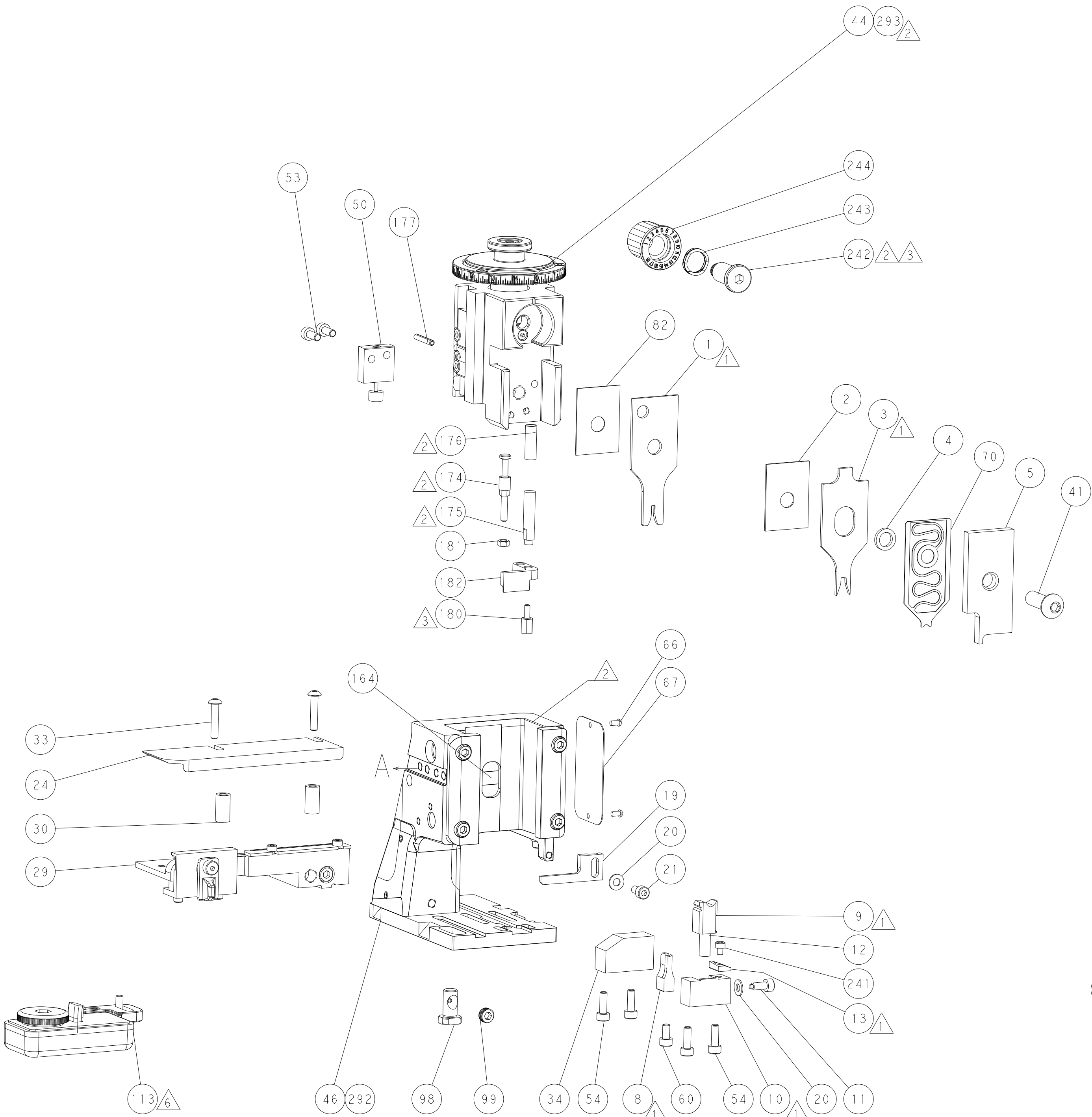
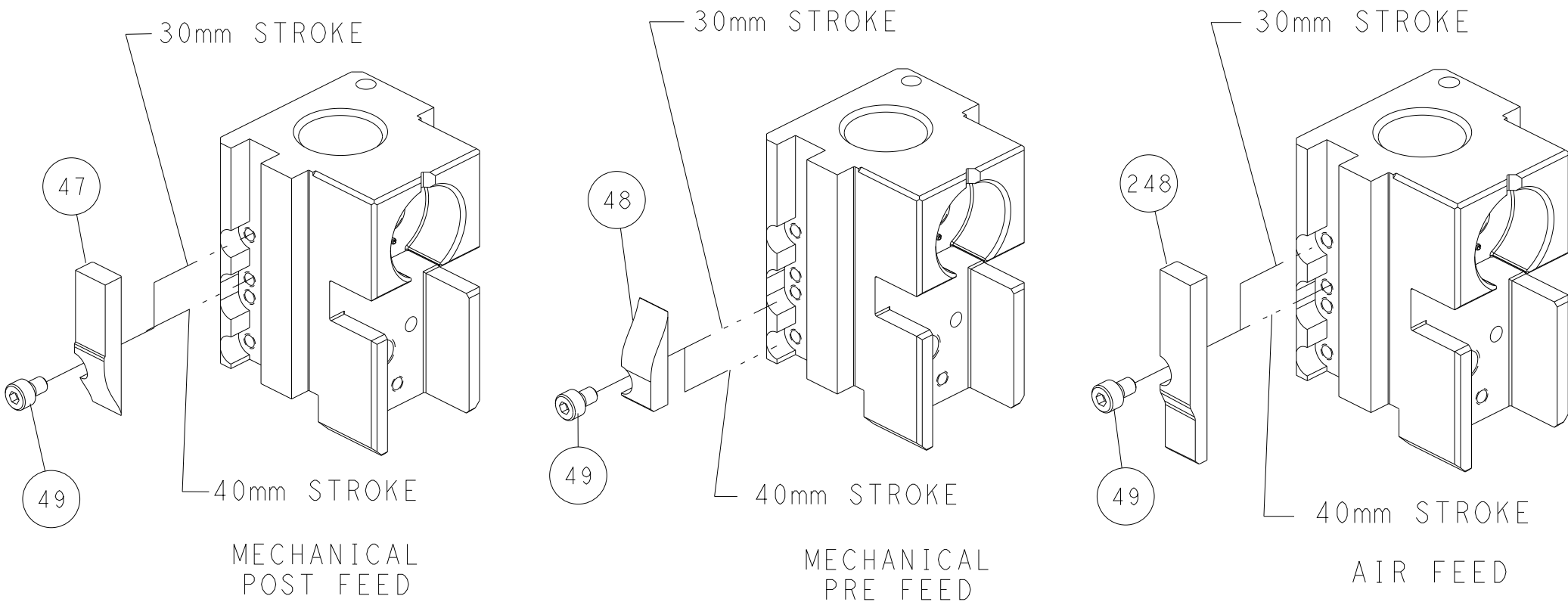


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

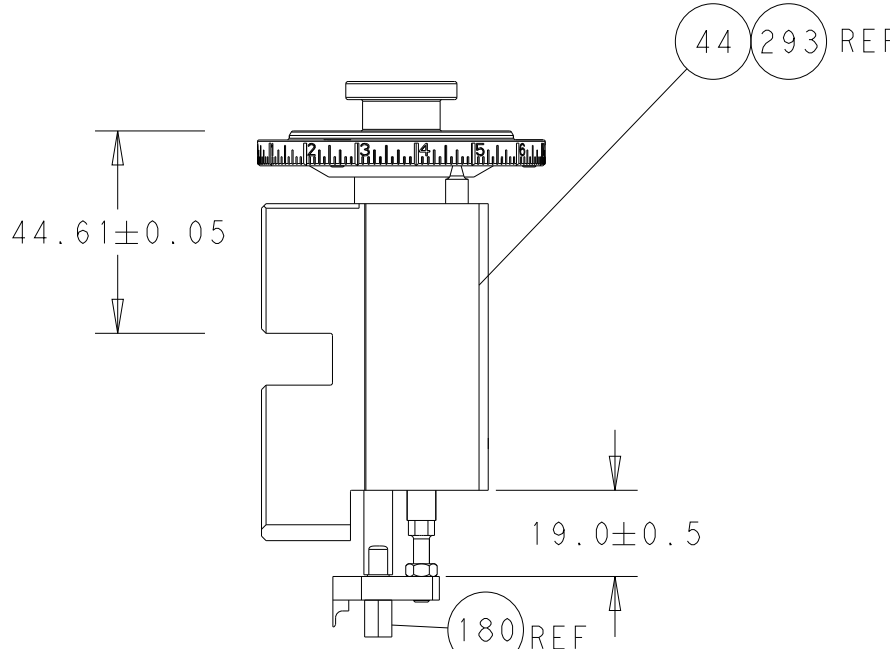


DETAIL A

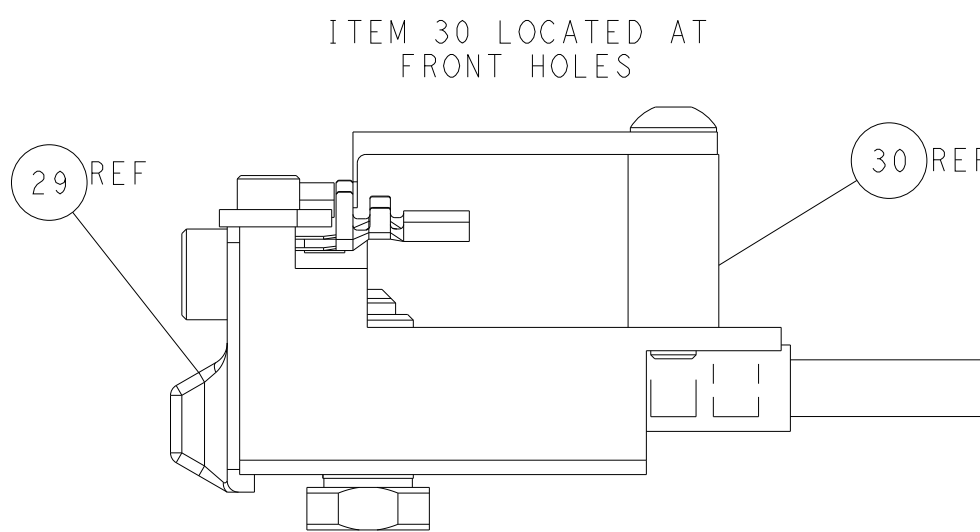
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

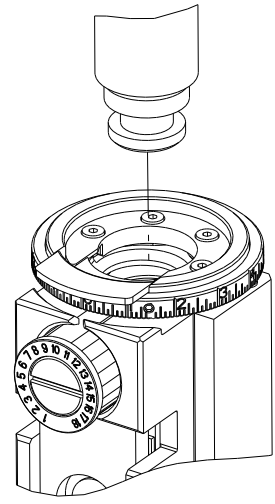
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm		CHK S. XI	01SEP2011	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC		SIZE A	
MATERIAL		APPLICATION SPEC		CAGE CODE 00779	
		WEIGHT		DRAWING NO C-2151087	
		Customer Accessible Production Drawing		RESTRICTED TO -	
		SCALE 1:2		SHEET 2 of 4	
				REV J	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

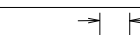
8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151087-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151087-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151087-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP UNIVERSAL POWER CONNECTOR TAB CONTACT			
WIRE STRIP LENGTH 2.70-3.70 mm [.106-.146 IN]		INSULATION DIAMETER RANGE Ø1.70-3.30 mm [.067-.130 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-5142		-	-
TERMINALS APPLIED△ ₆			
TE TERMINAL (A)175150-1	TE TERMINAL (A)175150-2	TE TERMINAL (A)175152-1	TE TERMINAL (A)175152-2
(A)175152-4			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP UNIVERSAL POWER CONNECTOR TAB CONTACT			
WIRE STRIP LENGTH 2.70-3.70 mm [.106-.146 IN]			INSULATION DIAMETER RANGE Ø2.00-3.30 mm [.079-.130 IN]
TERMINAL APPLICATION SPECIFICATION	(A)114-5142	-	-
	(B)114-5147	-	-
TERMINALS APPLIED 			
TE TERMINAL (B) 176758-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.27mm2	1.25+/-0.05 [.049+/- .002]	4.4
0.50mm2+0.75mm2	1.25+/-0.05 [.049+/- .002]	4.4
18 AWG OR 0.89mm2	1.25+/-0.05 [.049+/- .002]	4.4
20 AWG OR 0.50mm2	1.06+/-0.05 [.042+/- .002]	6.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.27mm2	1.25+/-0.05 [.049+/- .002]	4.4
18 AWG OR 0.89mm2	1.25+/-0.05 [.049+/- .002]	4.4
20 AWG OR 0.50mm2	1.06+/-0.05 [.042+/- .002]	6.2



- 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.
- 3 COMBINED INSULATION DIAMETER 3.30mm MAX.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

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		REVISONS				
A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD	
		-		SEE SHEET 1	-	-	-	

-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	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
6	-	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	2119791-6	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	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	4-1333203-7	ANVIL, COMBINATION	8
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1803260-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
1	1	1	3-456404-6	CRIMPER, WIRE PREMIUM	1

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DIMENSIONS: mm		CHK S. XI	01SEP2011	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC APPLICATION SPEC	SIZE CAGE CODE DRAWING NO	RESTRICTED TO	
MATERIAL		WEIGHT	00779	©=2151087	
Customer Accessible Production Drawing		SCALE	1:2	SHEET	3 of 4
		REV	J		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

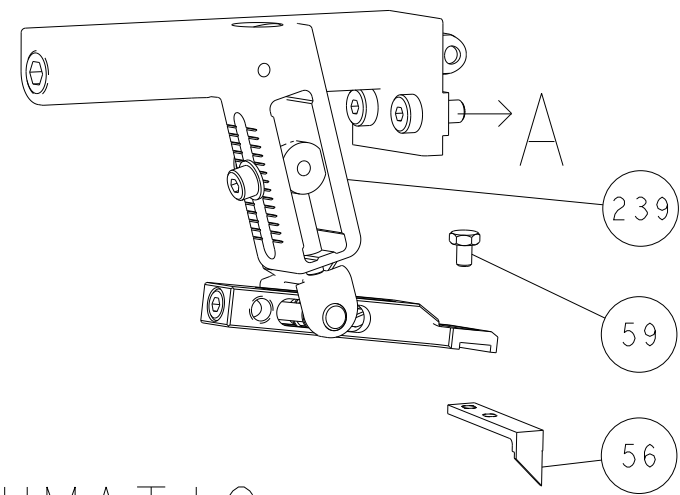
D

C

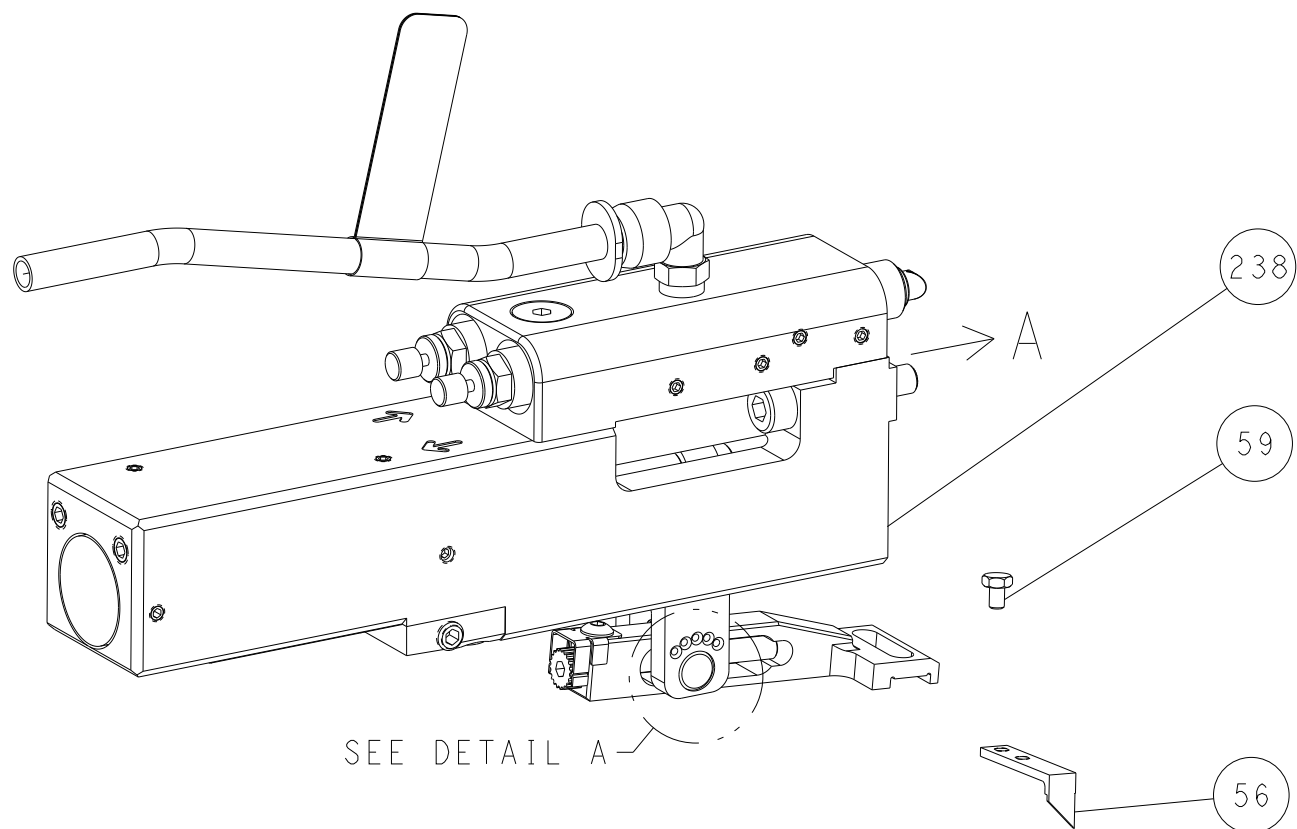
B

A

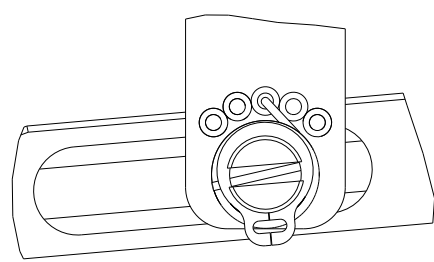
FEED TYPE MECHANICAL



PNEUMATIC

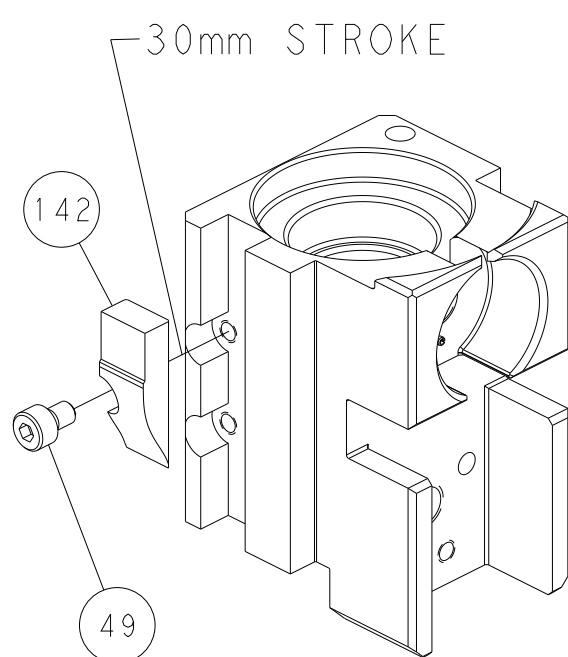


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

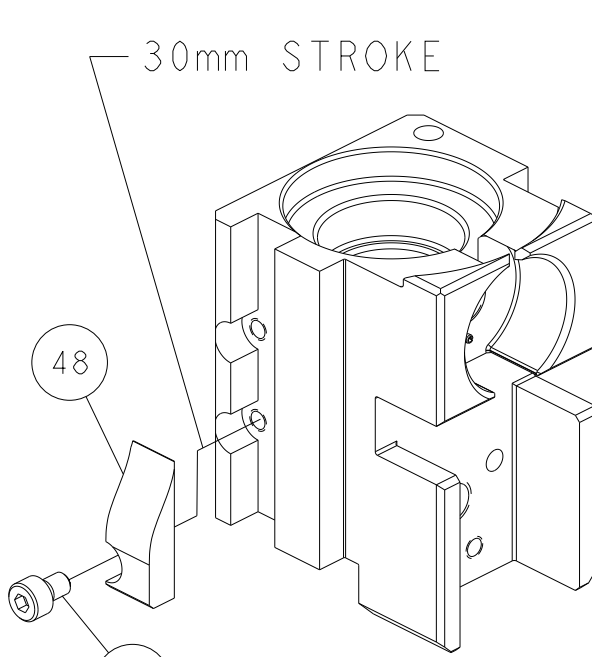


DETAIL A

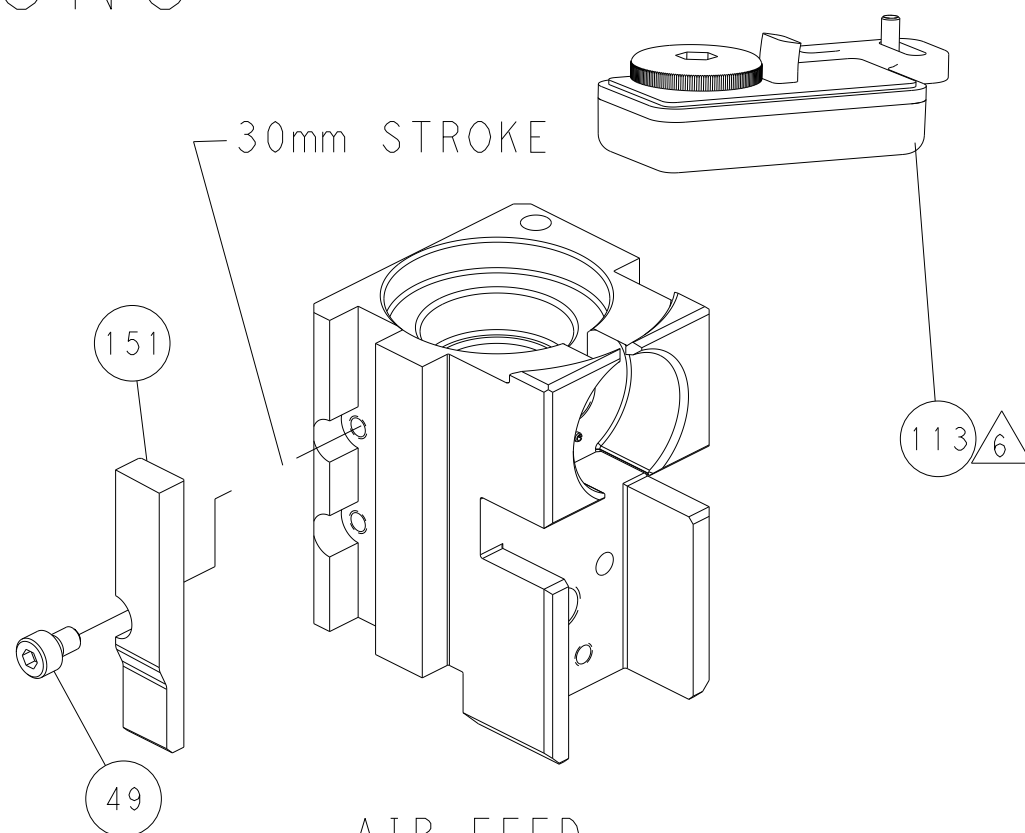
CAM POSITIONS



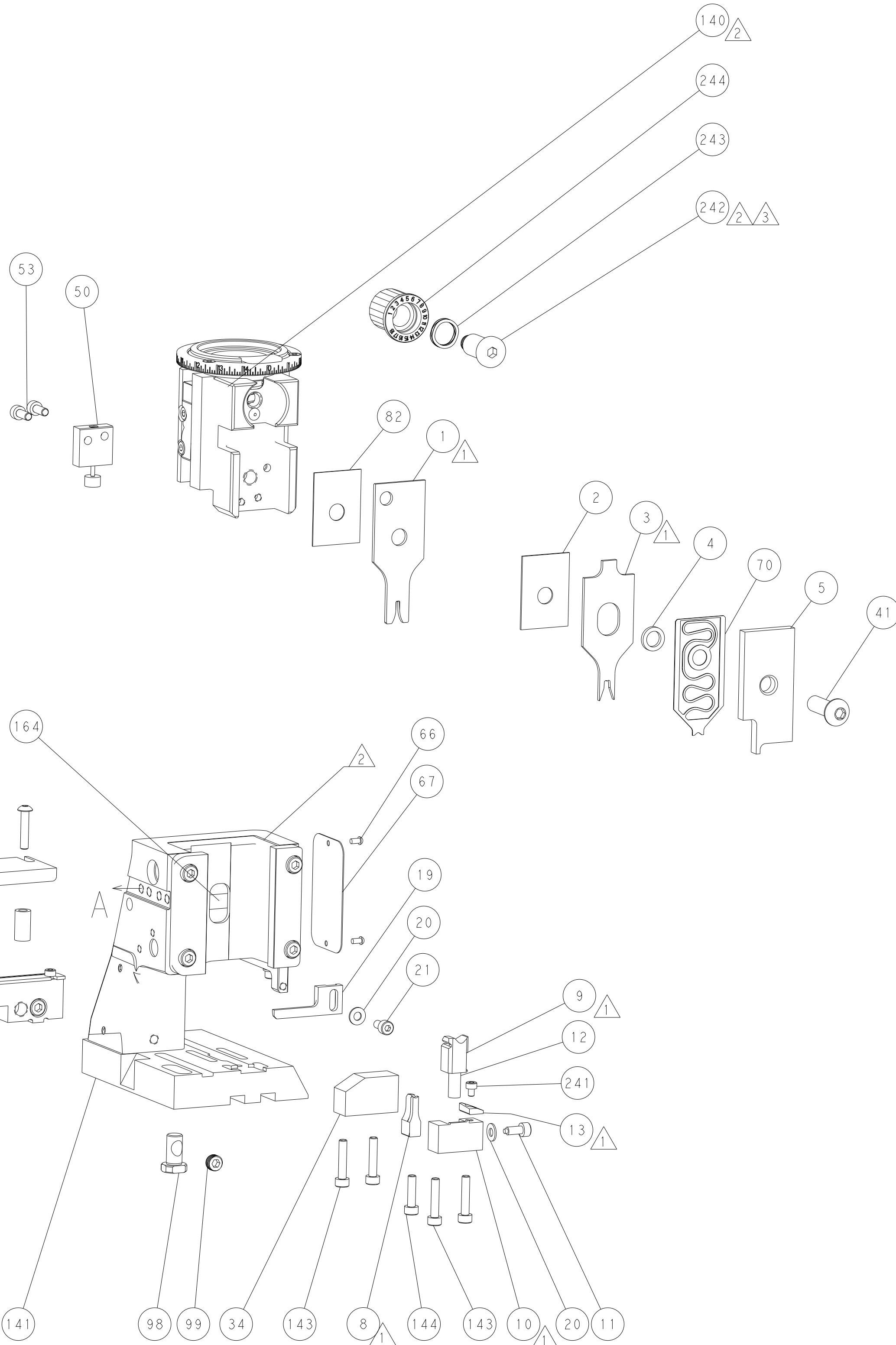
MECHANICAL
POST FEED



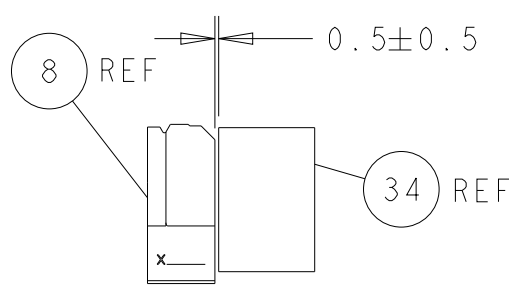
MECHANICAL
PRE FEED



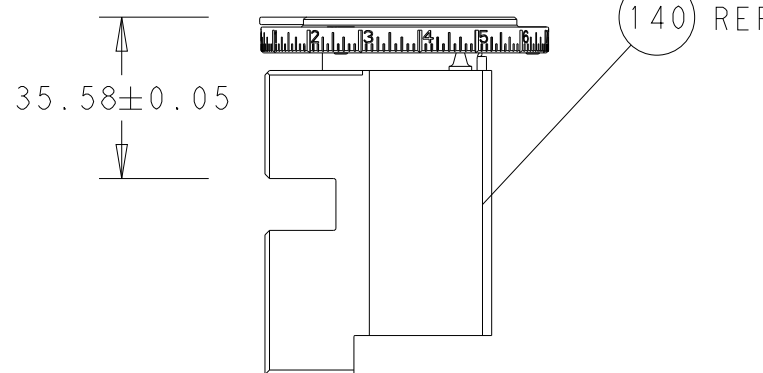
AIR FEED



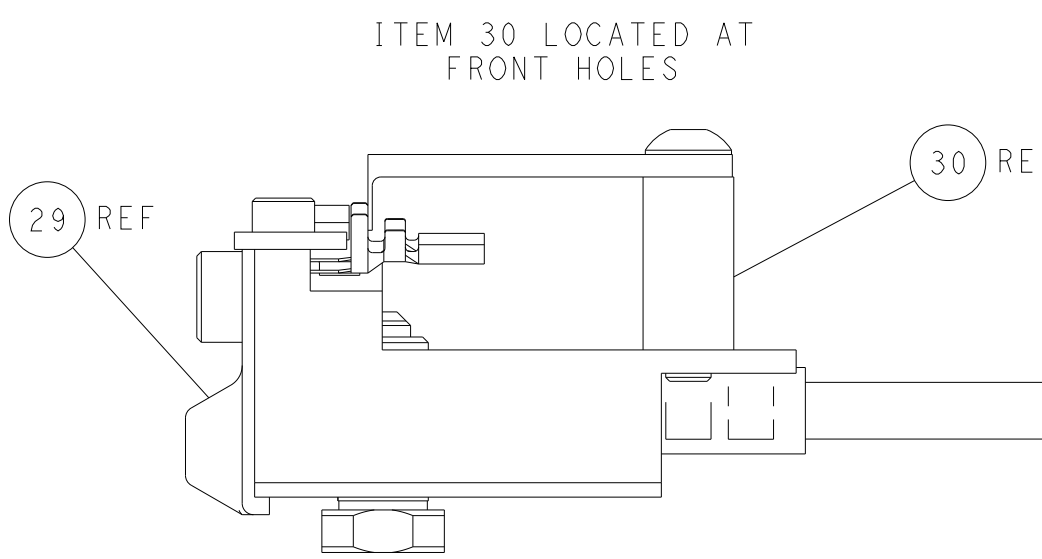
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS:		CHK S. XI	01SEP2011	NAME Ocean Side Feed Applicator	
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 C=2151087	
		FINISH		Customer Accessible Production Drawing	
MATERIAL		WEIGHT		SCALE 1:2	
				SHEET 4 of 4	
				REV J	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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