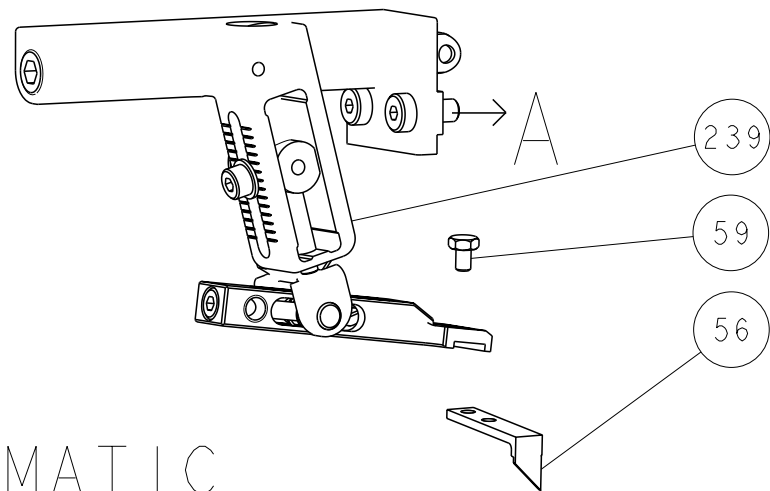
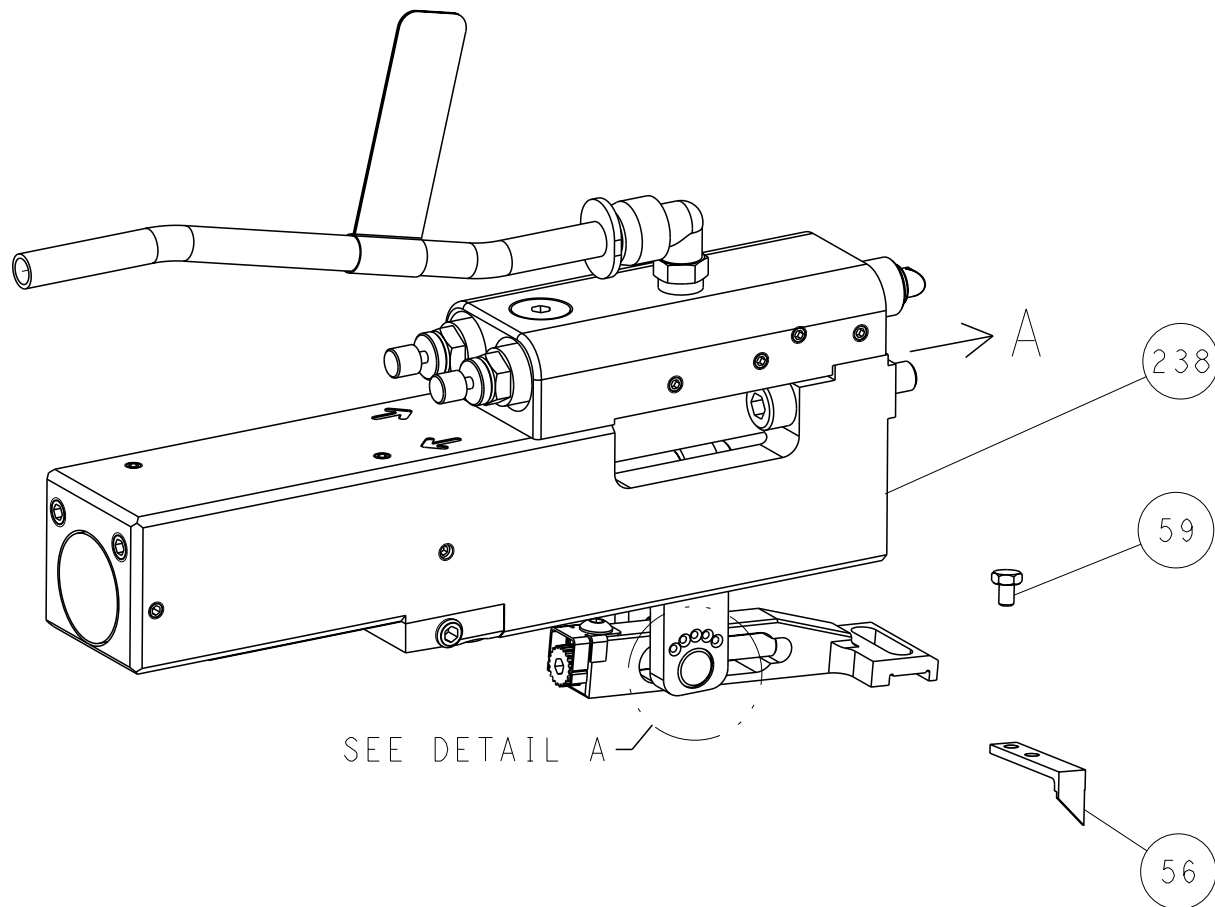


LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

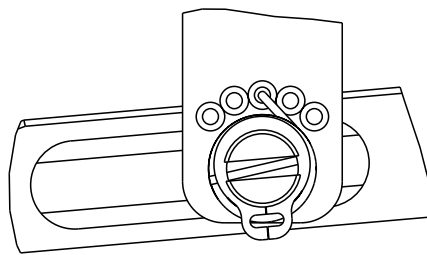
FEED TYPE MECHANICAL



PNEUMATIC

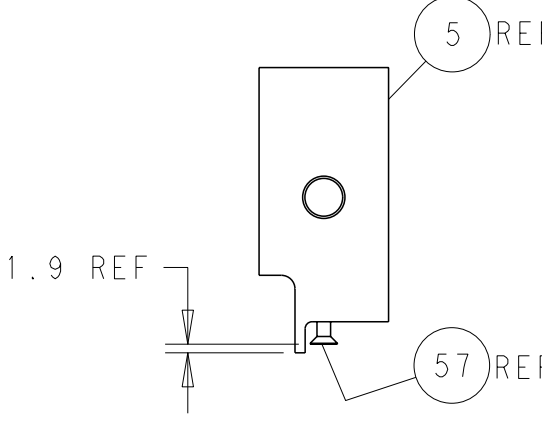
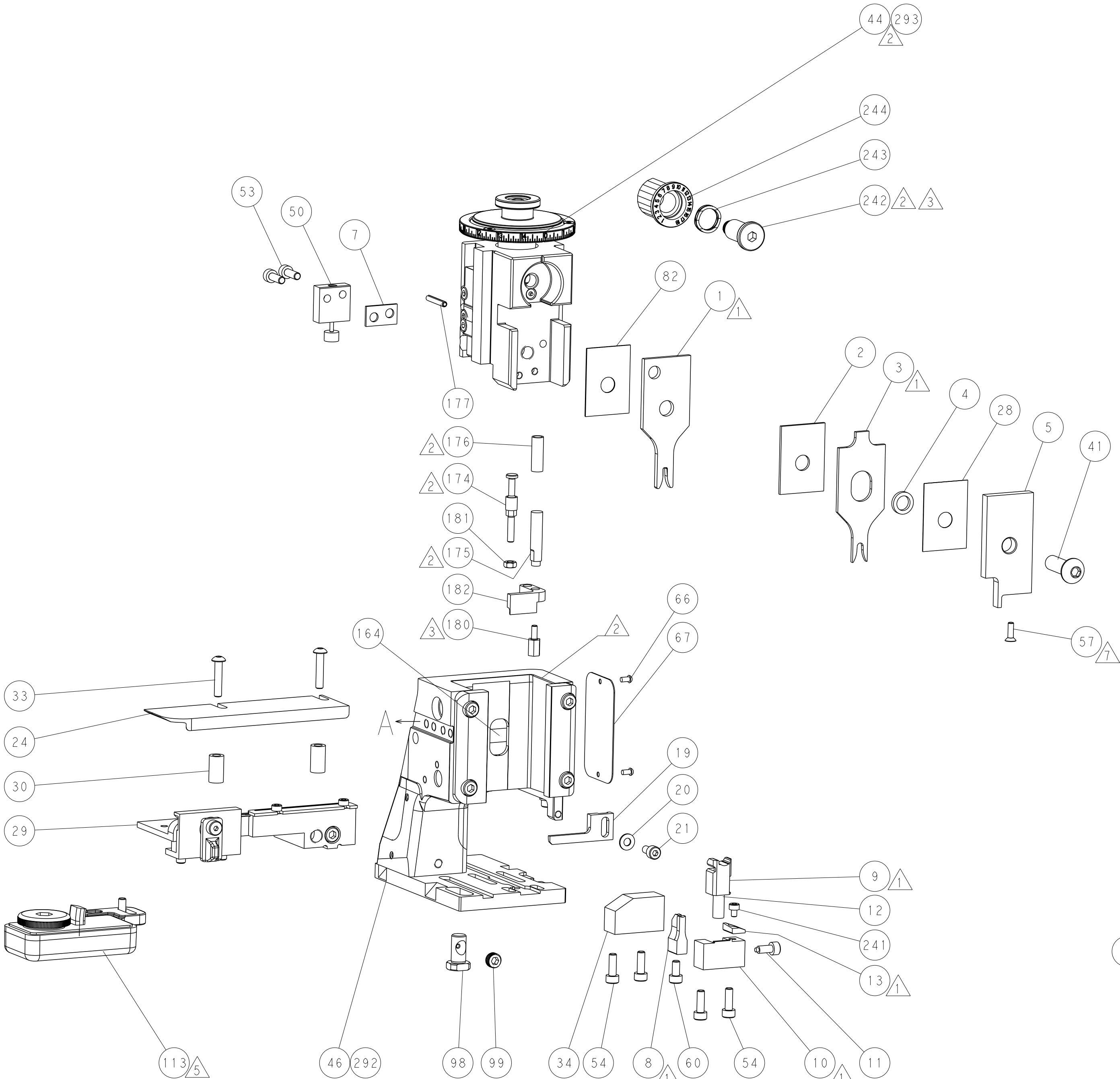
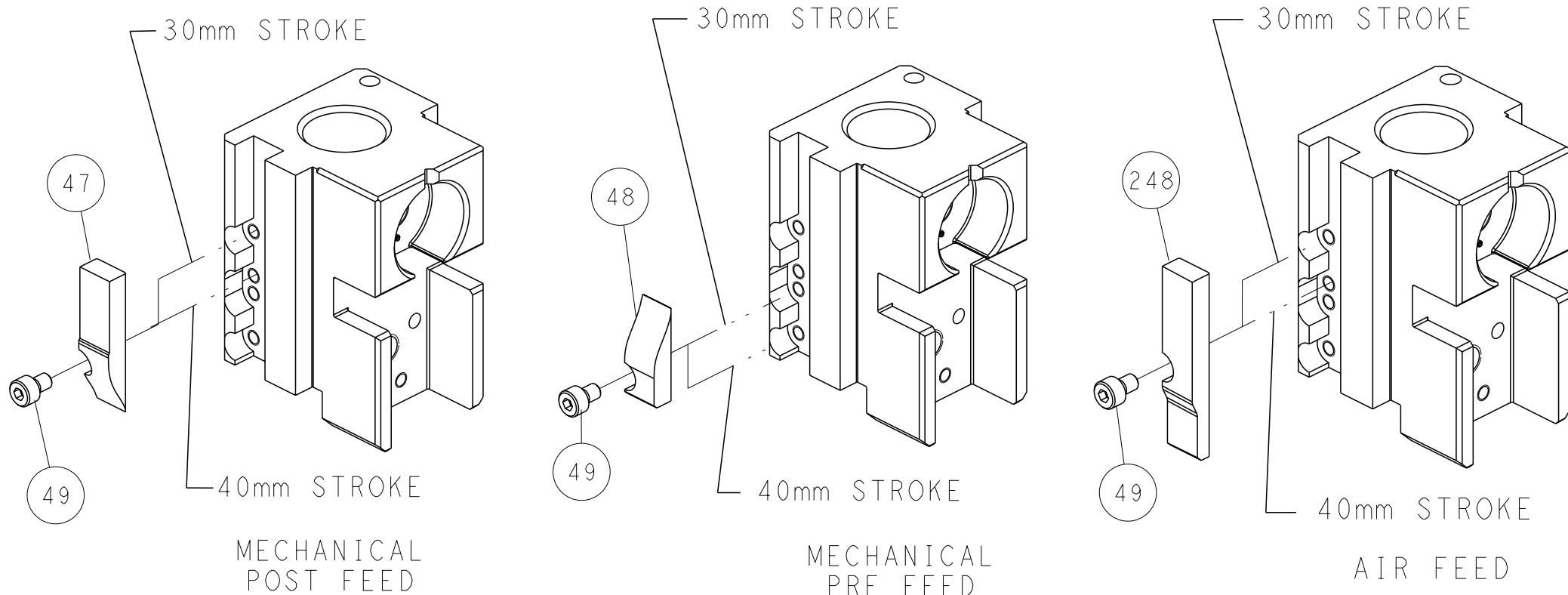


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

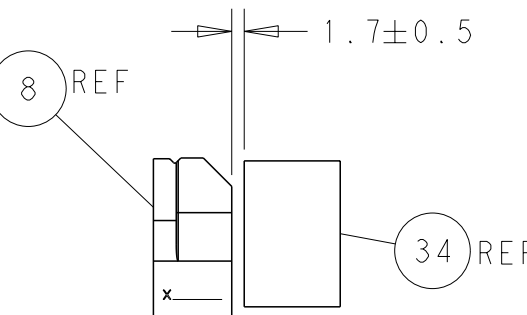


DETAIL A

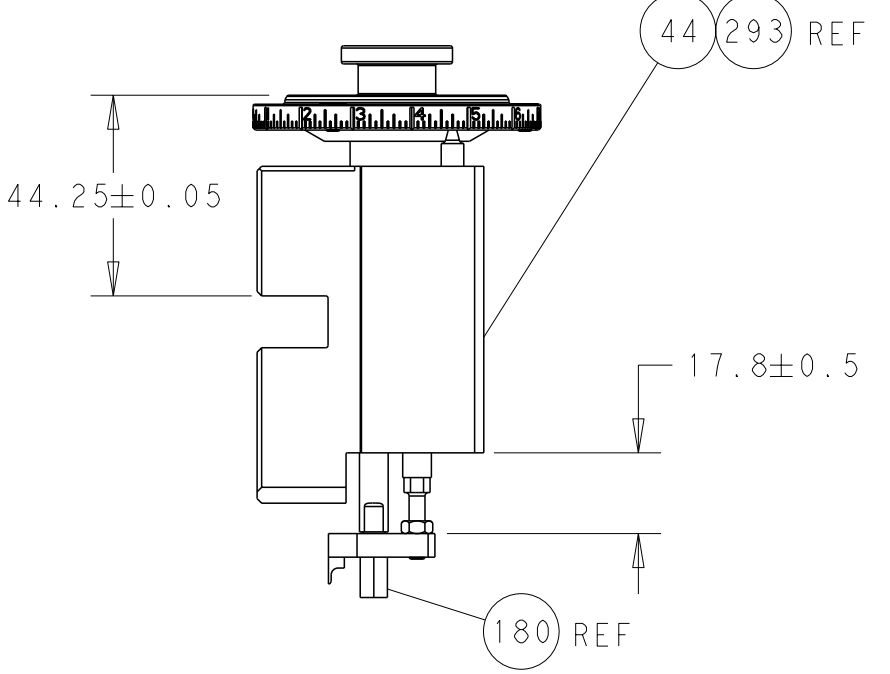
CAM POSITIONS



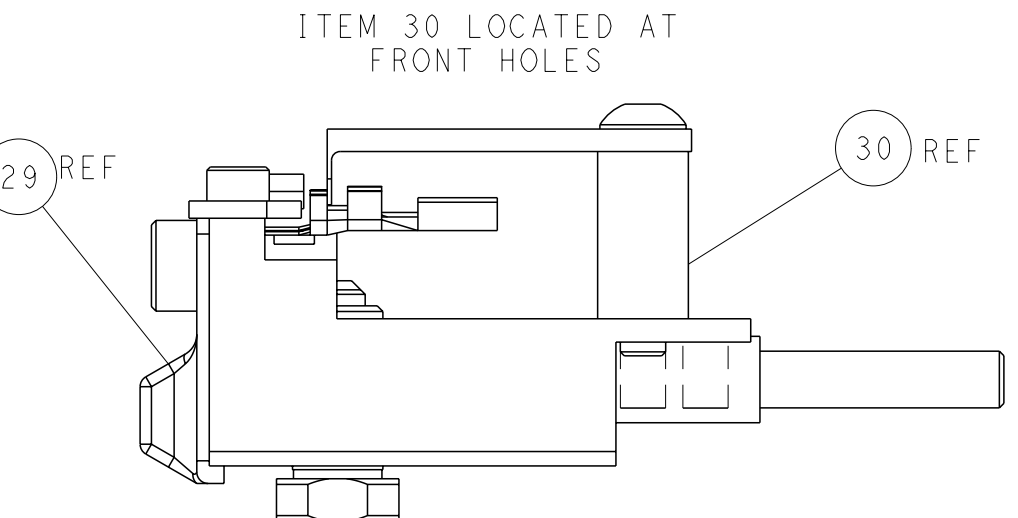
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



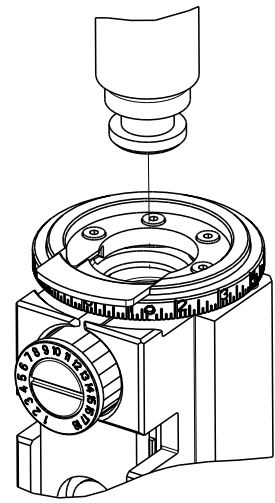
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

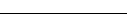
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		31MAY2011		TE Connectivity	
mm		0 PLC ±		X. ZHAO		31MAY2011		Harrisburg, PA 17105-3608	
FINISH		1 PLC ±		S. XI		31MAY2011		NAME	
MATERIAL		2 PLC ±		I. CRUZ		31MAY2011		Ocean Side Feed	
		3 PLC ±		PRODUCT SPEC				Applicator	
		4 PLC ±		APPLICATION SPEC					
		ANGLES		WEIGHT		SIZE		CAGE CODE	
		FINISH		Customer Accessible Production Drawing		A1		00779	
				SCALE		1:2		SHEET	
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THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151106-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151106-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151106-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.68 mm [.145]	O
APPLICATOR INSTRUCTIONS 114-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ECONOSEAL RECEPTACLE CONTACT .070 TYPE			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]			TERMINAL INSULATION DIAMETER RANGE Ø2.00-2.60 mm [.079-.102 IN]
TERMINAL APPLICATION SPECIFICATION	114-5082	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
171662-1		172888-1	172888-2	2.0-2.6
171662-4		172888-3	1-172888-3	2.0-2.6
171662-5			9-172888-2	2.0-2.6
175104-2			176886-2	1.8-2.6
			176886-4	1.8-2.6
			176886-5	1.8-2.6
			1-900325-9	2.0-2.3
			347874-1	1.6-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.52+/-0.05 [.060+/- .002]	6.7
0.85mm2	1.37+/-0.05 [.054+/- .002]	8.3
0.50mm2	1.24+/-0.05 [.049+/- .002]	9.8

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ECONOSEAL RECEPTACLE CONTACT .070 TYPE			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]			TERMINAL INSULATION DIAMETER RANGE Ø2.00-2.60 mm [.079-.102 IN]
TERMINAL APPLICATION SPECIFICATION 		-	-
		-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
171662-1		172888-1	172888-2	2.0-2.6
171662-4		172888-3	1-172888-3	2.0-2.6
171662-5			9-172888-2	2.0-2.6
			176886-2	1.8-2.6
			176886-4	1.8-2.6
			176886-5	1.8-2.6
			1-900325-9	2.0-2.3
			347874-1	1.6-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.32+/-0.05 [.052+/- .002]	8.8
0.75mm2	1.24+/-0.05 [.049+/- .002]	9.8

*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)

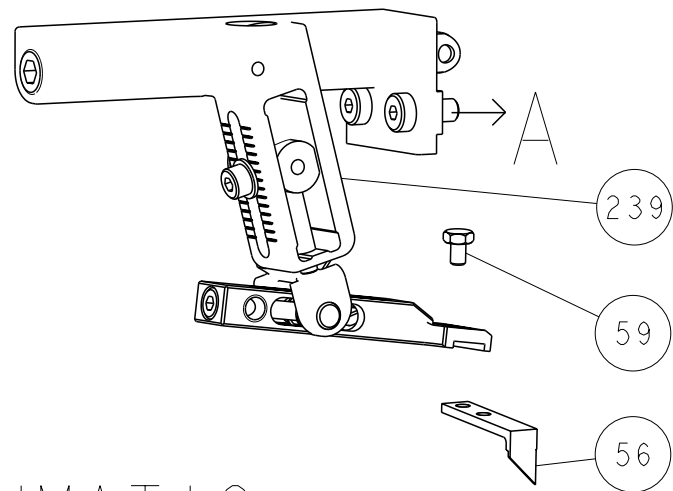
2				1			
LOC	DIST	REVISIONS					
A	66						
		P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

-	1	1	2119082-7	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	-	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
-	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	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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	1752356-3	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-2	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1333205-5	ANVIL, COMBINATION	8
-	1	1	3-240641-4	SPACER	7
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	3-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
1	1	1	4-456406-1	CRIMPER, WIRE PREMIUM	1

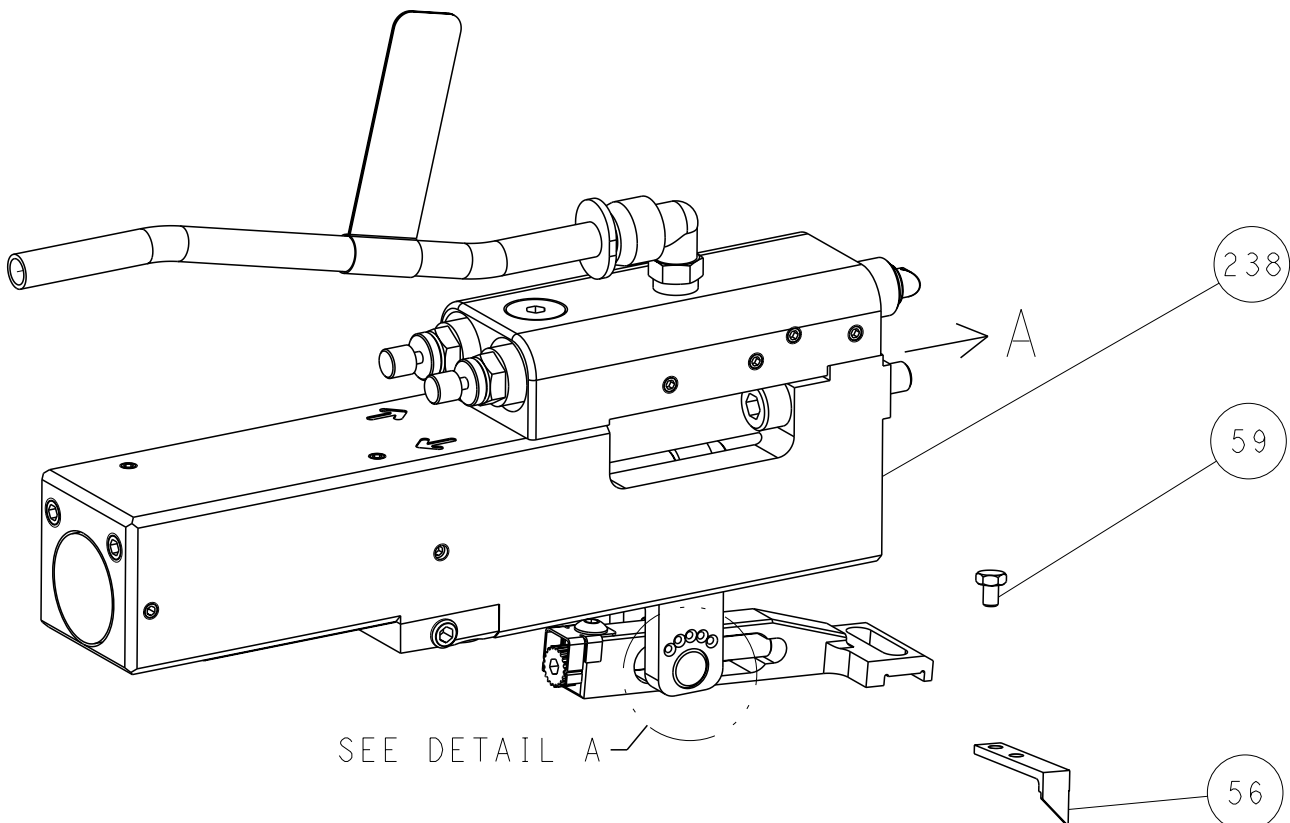
THIS DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRONIC COMPONENTS INDUSTRY. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN X.ZHAO 31MAY2011	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK S.XI 31MAY2011	NAME Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD J.CRUZ 31MAY2011	PRODUCT SPEC			
MATERIAL -				FINISH -	APPLICATION SPEC			
				WEIGHT -	SIZE CASE CODE DRAWING NO A1 00779 ©=2151106			
				Customer Accessible Production Drawing				RESTRICTED TO -
				SCALE 1:2 SHEET 3 OF 4 REV G				

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

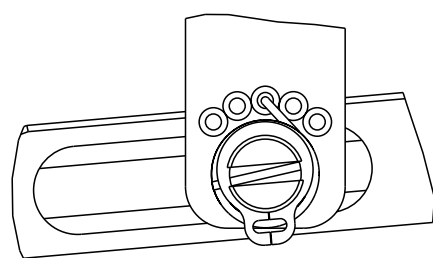
FEED TYPE MECHANICAL



PNEUMATIC

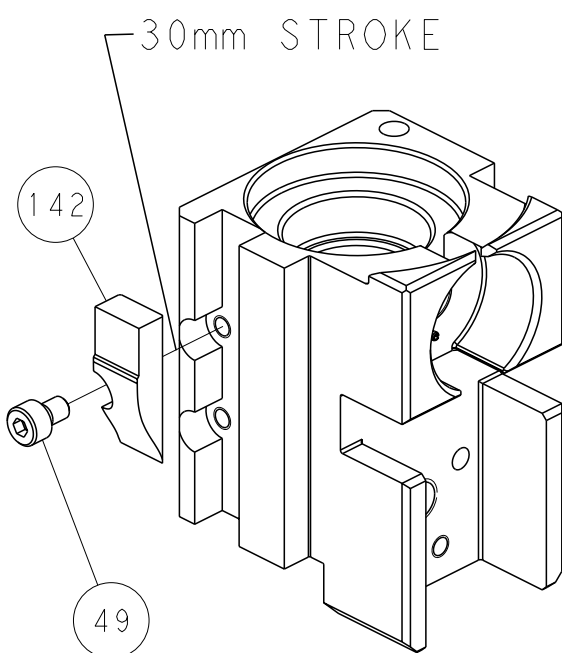


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

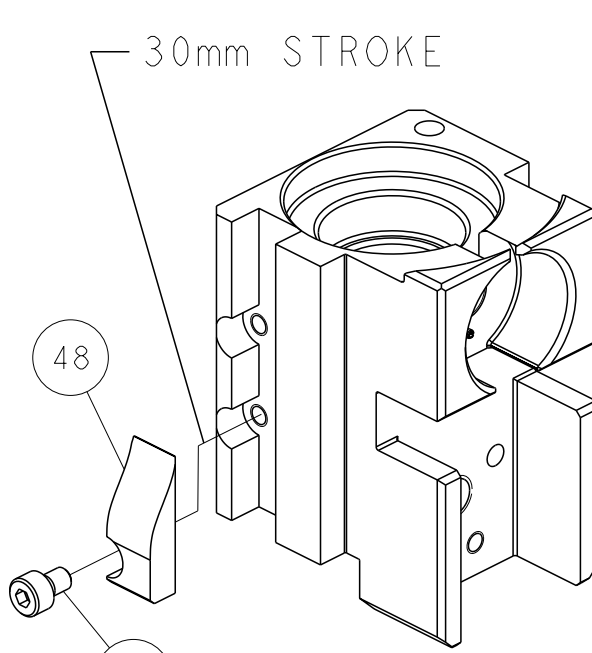


DETAIL A

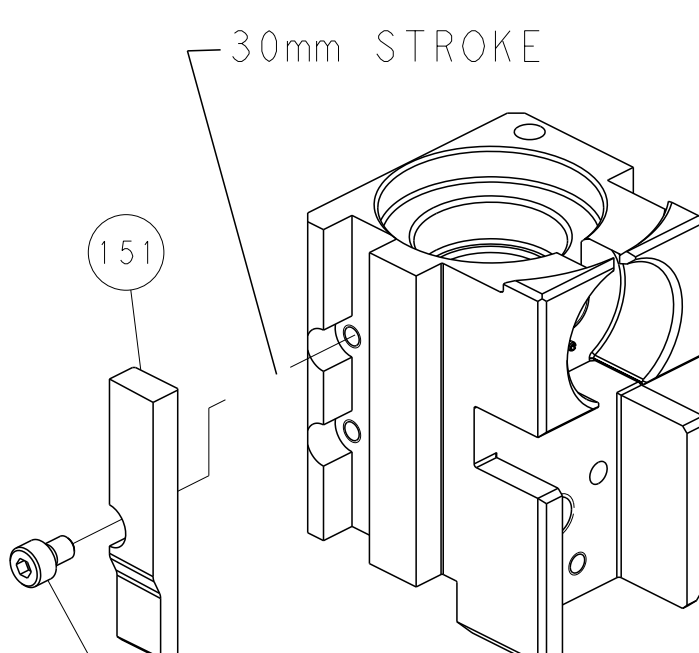
CAM POSITIONS



MECHANICAL
POST FEED

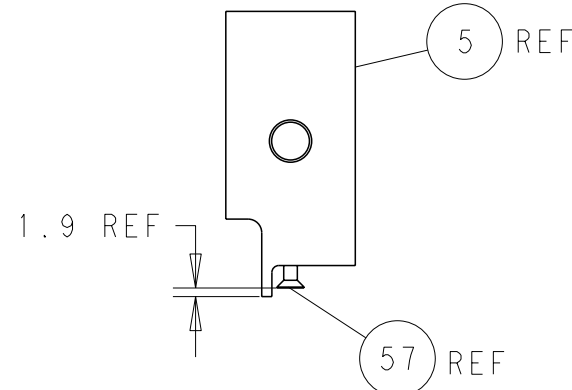


MECHANICAL
PRE FEED

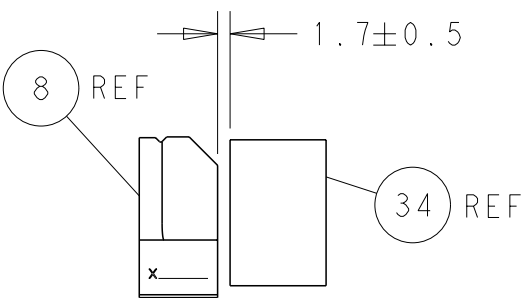


AIR FEED

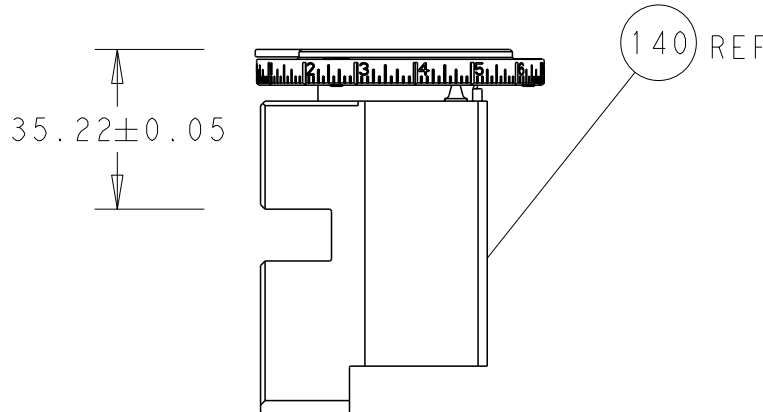
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



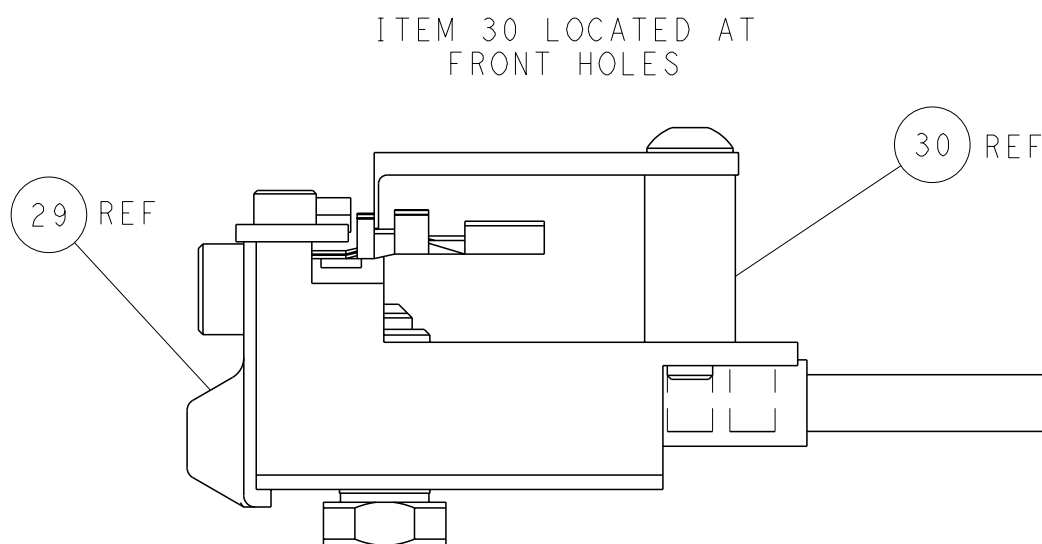
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS: mm		CHK S. XI 31MAY2011	31MAY2011	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J. CRUZ 31MAY2011	31MAY2011	SIZE A1	
0 PLC ±		PRODUCT SPEC		CAGE CODE 00779	
1 PLC ±		APPLICATION SPEC		DRAWING NO 2151106	
2 PLC ±				RESTRICTED TO	
3 PLC ±				Customer Accessible Production Drawing	
4 PLC ±				SCALE 1:2	
ANGLES FINISH		WEIGHT		SHEET 4	
-				OF 4	
				REV G	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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