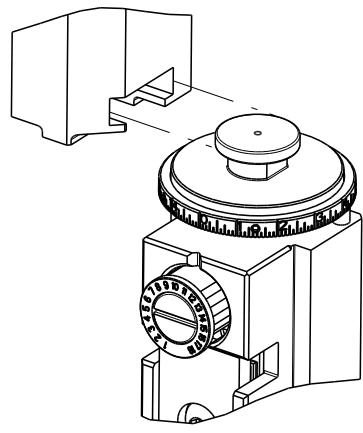


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151931-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151931-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151931-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151931-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151931-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.90 mm [.075]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: SXA 2.5mm JST			
WIRE STRIP LENGTH 1.73-2.11 mm [.068-.083 IN]		INSULATION DIAMETER RANGE Ø1.50-1.90 mm [.059-.075 IN]	
TERMINAL APPLICATION SPECIFICATION		XAXAD (W-W) CHM-1-170 Rev R3	
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572601-1	SXA-01T-P0.6	1572601-3	SXA-01GW-P0.6
1572601-2	SXAM-01T-P0.6	2113096-1	SXM-01T-P0.6

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
22 AWG OR 0.50mm2			0.90+/-0.05 [0.035+/- .002]		7.1
20 AWG OR 0.35mm2			0.80+/-0.05 [0.031+/- .002]		8.2
24 AWG OR 0.20mm2			0.75+/-0.05 [0.030+/- .002]		8.6

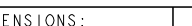


1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
6. TERMINAL SUPPORT LOCATION FOR TERMINAL PN 2113096-1.
7. TERMINAL SUPPORT LOCATION FOR TERMINAL PN 1572601-1, 1572601-2, AND 1572601-3

```
*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					
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			B1	ECR-17-017723	5DEC2017	RS	LZ
			C	ECR-18-006876	01MAY2018	FZ	KZ
			D	ECR-21-003205	15MAR2021	TB	GB

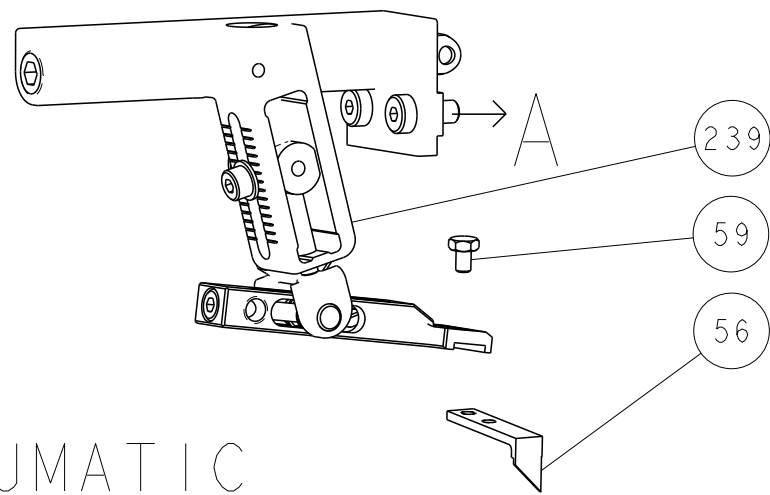
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	-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	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	1-455888-7	SPACER, CRIMPER	82
	-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	1	1	854769-4	HOLDER, INS	74
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	690753-2	SPACER, TONKER	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
7	-	1	1	1	1	2-1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-3	SPACER, CRIMPER	28
	-	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
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-3	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1633861-1	SHEAR, FLOATING	9
1	1	2	2	1	1	1-1633917-5	ANVIL, COMBINATION	8
	-	1	1	1	1	1-240641-6	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1-1633964-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	2	2	1	1	3-456402-4	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR FPD ELECTRONICS CORPORATION IT IS UNDESIRABLE TO HAVE THIS DOCUMENT AND ITS CONTENTS REPRODUCED SHOULD BE CONTACTED FOR THE LATEST REVISION.									
DIMENSIONS: mm			TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±°		DWN S. SALVES 05APR2013 CHG P. BARILETTA 05APR2013 APVD C. LIMA 05APR2013 PRODUCT SPEC - APPLICATION SPEC -		 TE Connectively Harrisburg, PA 17105-3608		
			Ocean Side Feed Applicator -		NAME		SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151931 -		
MATERIAL -			FINISH -		WEIGHT -		Customer Accessible Production Drawing		
					SCALE 1:2		SHEET 1 OF 4		REV D

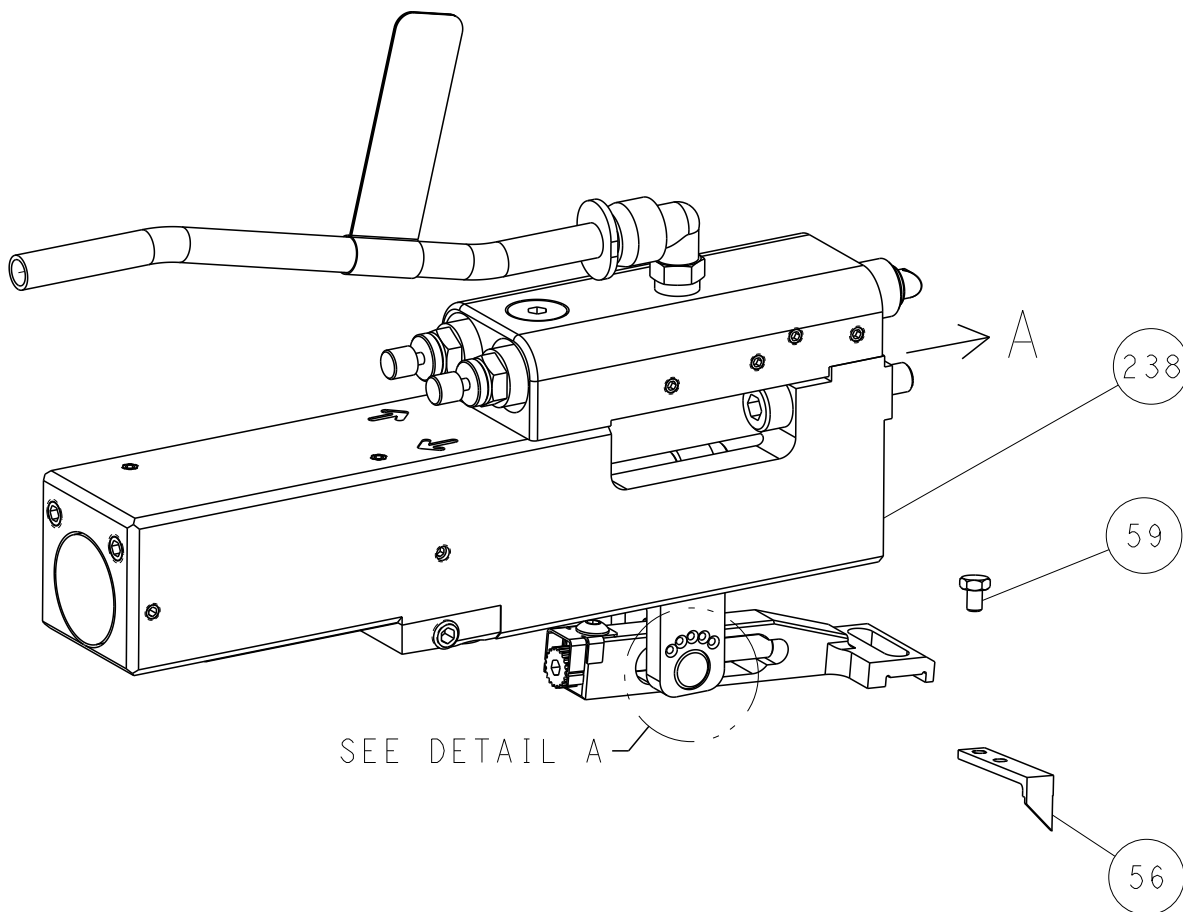
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC		DIST		REVISIONS				
A	66	P	LTR	DESCRIPTION		DATE	DWN	APVD
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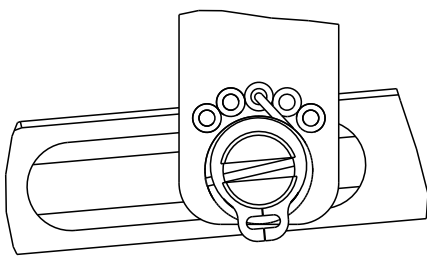
FEED TYPE MECHANICAL



PNEUMATIC

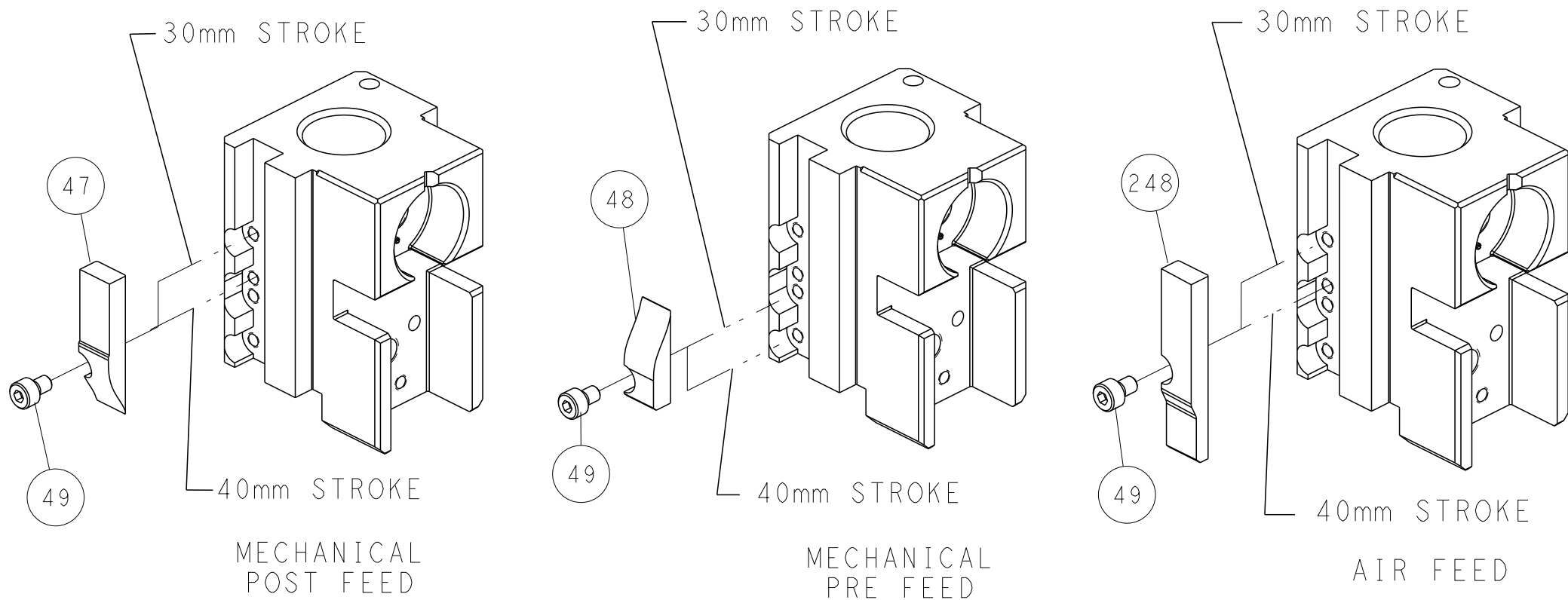


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

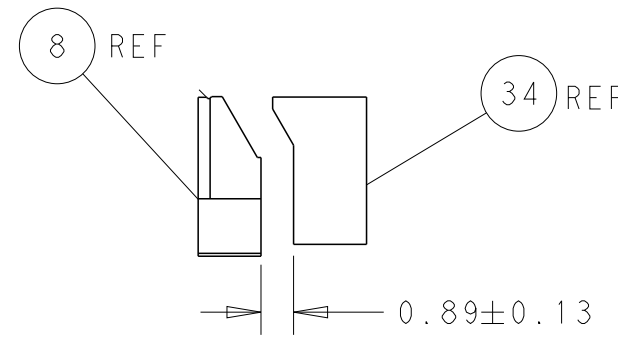
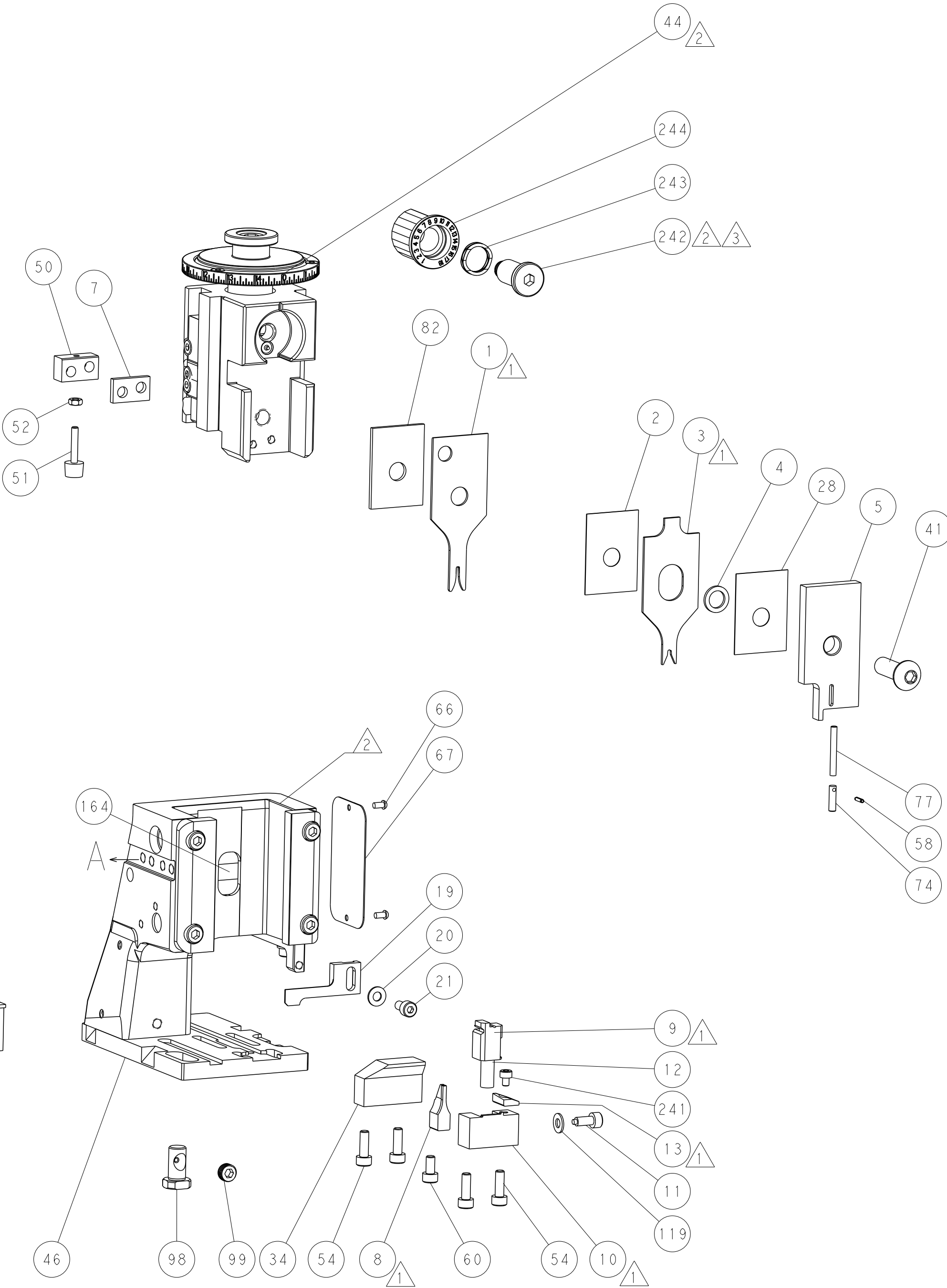


DETAIL A

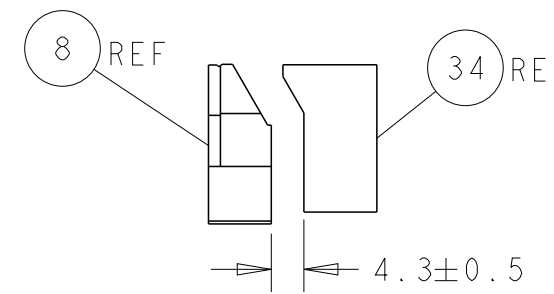
CAM POSITIONS



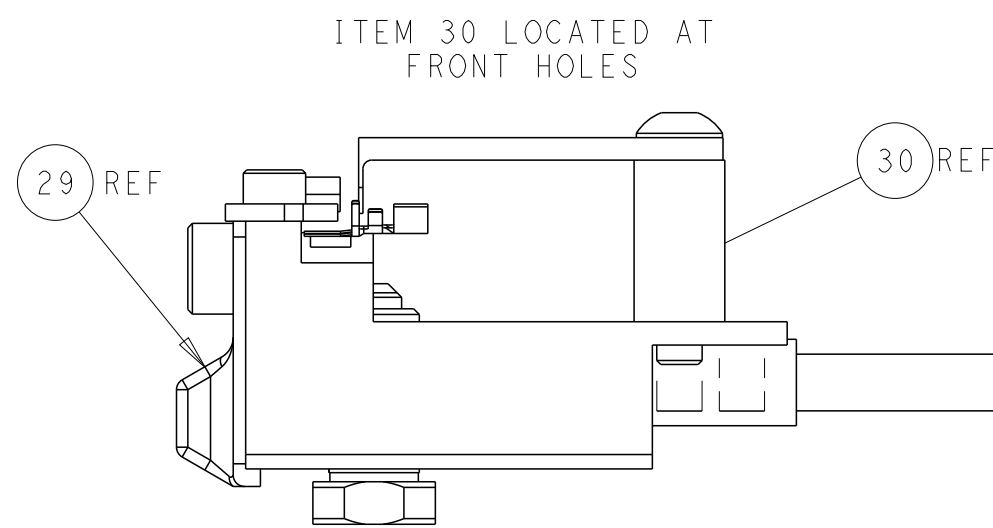
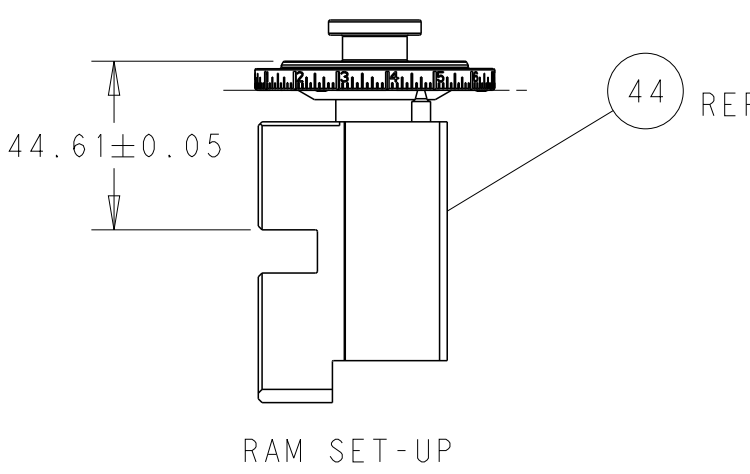
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



△ TERMINAL SUPPORT LOCATION FOR TERMINAL
PN 1572601-1, 1572601-2, AND 1572601-3



△ TERMINAL SUPPORT LOCATION
FOR TERMINAL PN 2113096-1.



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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CHK P. BARLETTA 05APR2013		NAME Ocean Side Feed Applicator	RESTRICTED TO	
APVD C. LIMA 05APR2013		SIZE A1	CAGE CODE 00779	DRAWING NO. C=2151931
PRODUCT SPEC		SCALE 1:2	SHEET 2	OF 4
APPLICATION SPEC		REV D		
MATERIAL -		WEIGHT -	Customer Accessible Production Drawing	

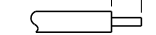
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151931-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151931-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151931-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.90 mm [.075]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: SXA 2.5mm JST			
WIRE STRIP LENGTH 1.73-2.11 mm [.068-.083 IN]			INSULATION DIAMETER RANGE Ø1.50-1.90 mm [.059-.075 IN]
TERMINAL APPLICATION SPECIFICATION		XA-XAD (W-W) CHM-1-170 Rev R3	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572601-1	SXA-01T-P0.6	1572601-3	SXA-01GW-P0.6
1572601-2	SXAM-01T-P0.6	2113096-1	SXM-01T-P0.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	0.90+/-0.05 [.035+/- .002]	7.1
22 AWG OR 0.35mm2	0.80+/-0.05 [.031+/- .002]	8.2
24 AWG OR 0.20mm2	0.75+/-0.05 [.030+/- .002]	8.6



- 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.
- 6 TERMINAL SUPPORT LOCATION FOR TERMINAL PN 2113096-1.
- 7 TERMINAL SUPPORT LOCATION FOR TERMINAL PN 1572601-1, 1572601-2, AND 1572601-3

*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)

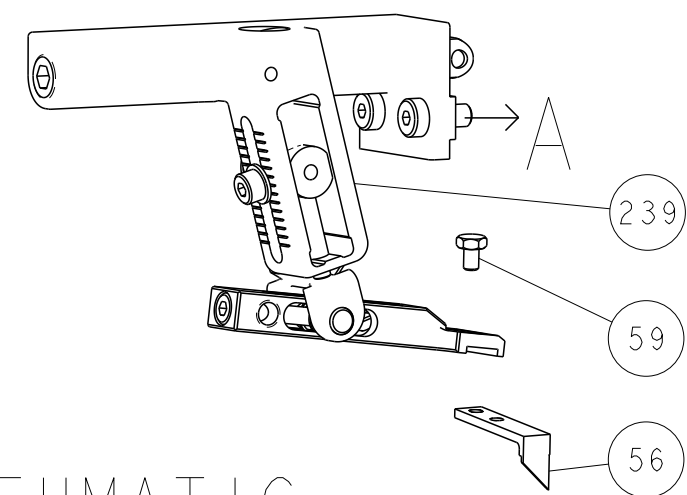
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		P	LTR	DESCRIPTION	DATE	DWN
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-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-7	SPACER, CRIMPER	82
-	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	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	2-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	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	2119533-3	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	1633861-1	SHEAR, FLOATING	9
-	1	1	1-1633917-5	ANVIL, COMBINATION	8
-	1	1	1-240641-6	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
-	1	1	1-1633964-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	3-456402-4	CRIMPER, WIRE PREMIUM	1

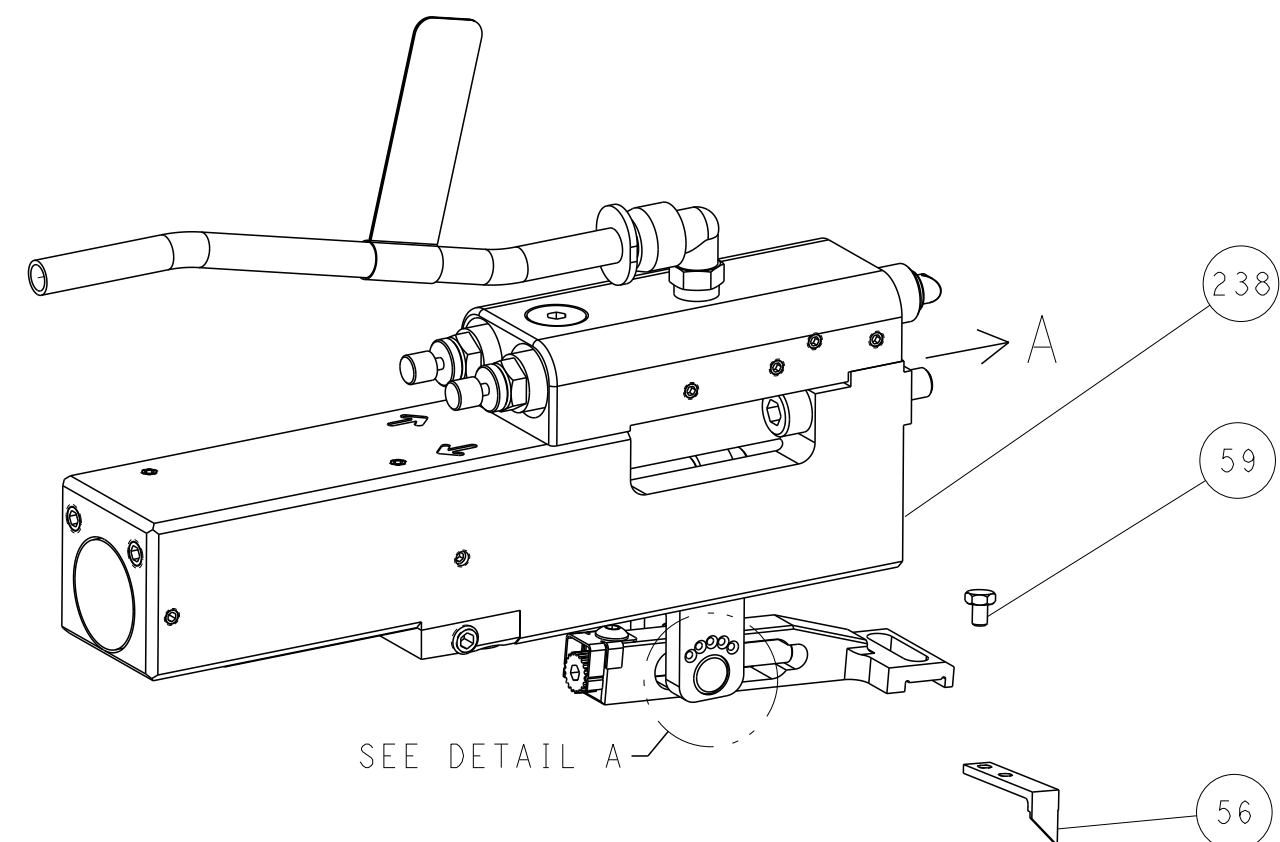
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			DWN S. ALVES 05APR2013	 TE Connectivity Harrisburg, PA 17105-3608	
			CHK P. BARLETTA 05APR2013		
			APVD C. LIMA 05APR2013		
			NAME Ocean Side Feed Applicator		
			PRODUCT SPEC	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
			APPLICATION SPEC		
			WEIGHT	A1 00779 ©=2151931	
			MATERIAL		
			Customer Accessible Production Drawing	SCALE 1:2	SHEET 3 OF 4
				REV D	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

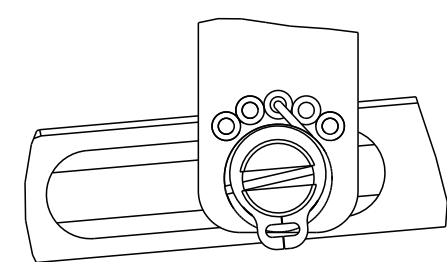
FEED TYPE MECHANICAL



PNEUMATIC

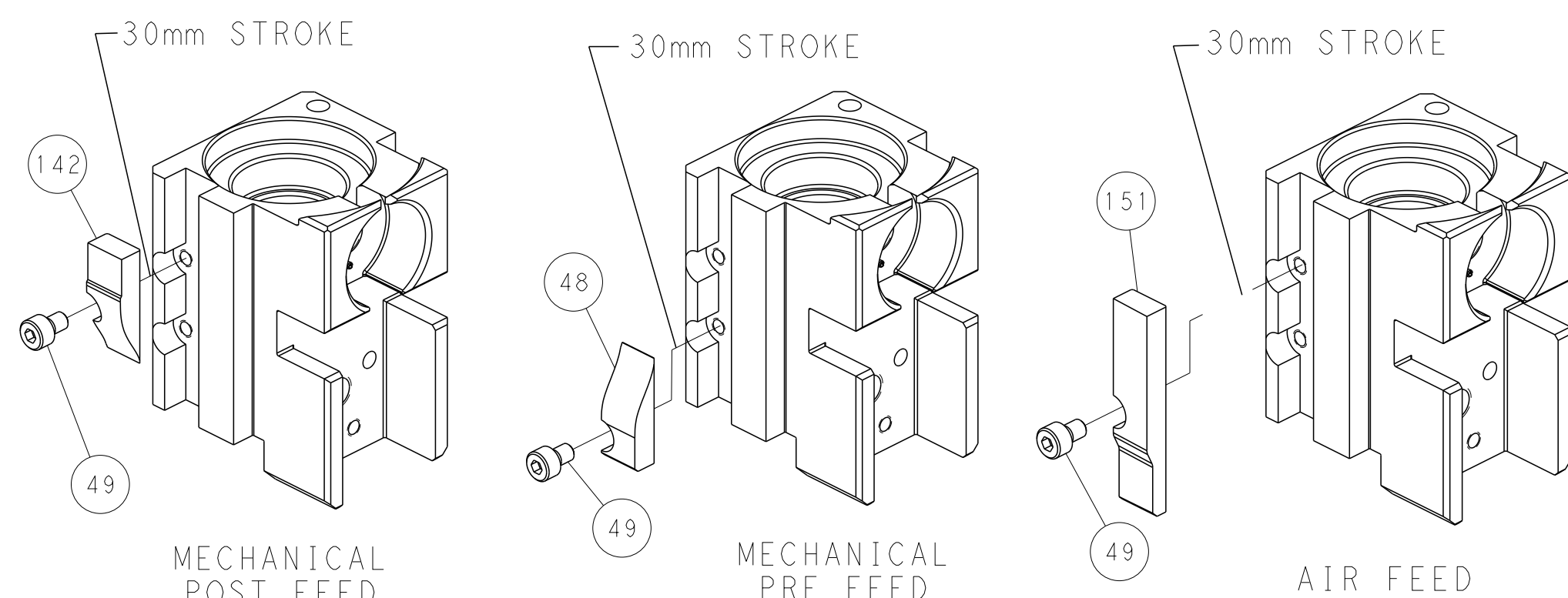


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



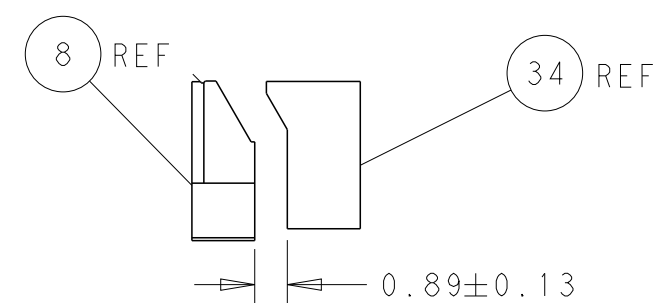
DETAIL A

CAM POSITIONS

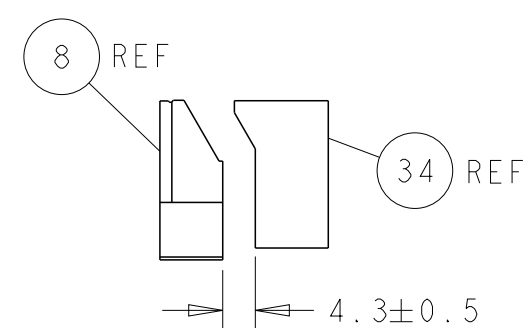


PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

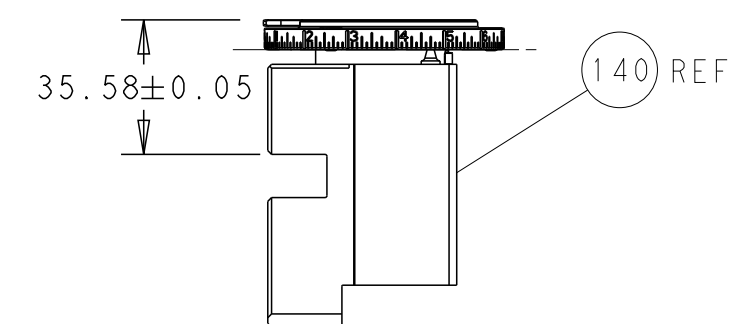
LOC		DIST		REVISIONS				
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	



△ TERMINAL SUPPORT LOCATION FOR TERMINAL
PN 1572601-1, 1572601-2, AND 1572601-3

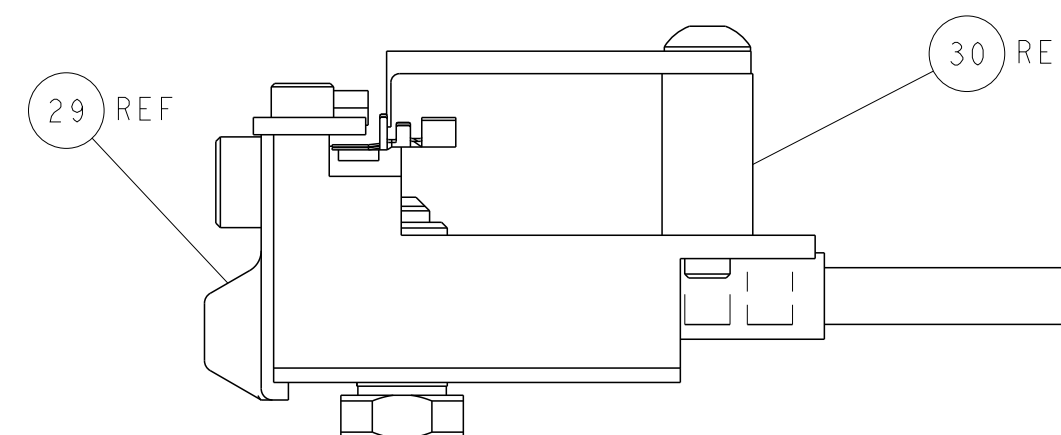


△ TERMINAL SUPPORT LOCATION
FOR TERMINAL PN 2113096-1.

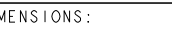


RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator							
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC									
		-		APPLICATION SPEC									
MATERIAL		-		SIZE CAGE CODE DRAWING NO						RESTRICTED TO			
-		-		WEIGHT						A1 00779 C=2151931			
Customer Accessible Production Drawing						SCALE		1:2		SHEET 4 of 4		REV D	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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