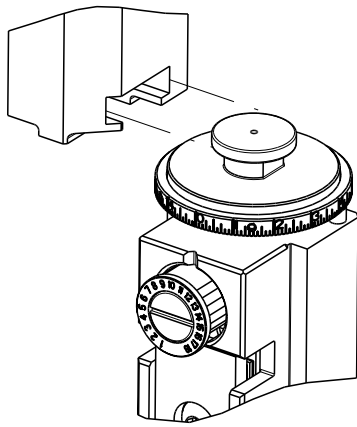
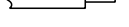


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151332-2	Y	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151332-2	Y	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151332-2	Y	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151332-7	Y	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.89 mm [.035]	F
INSUL	1.07 mm [.042]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO MQS TERMINAL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.25-3.55 mm [.128-.140 IN]			Ø0.85-1.10 mm [.033-.043 IN]
TERMINAL APPLICATION 		114-18858	-
SPECIFICATION		-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-1703930-1	1-1703930-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.17mm2		0.63+/-0.02 [.0248+/--.0008]		6.5
0.13mm2		0.59+/-0.02 [.0232+/--.0008]		7.0



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- 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

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

LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	DWN	APVD
A	66		U	ECR-18-013784	30AUG2018	YY	CT
			V	ECR-18-015581	01OCT2018	JAH	GB
			W	ECR-19-005393	03APR2019	JAH	CT
			Y	ECR-19-016655	25OCT2019	FJ	GB

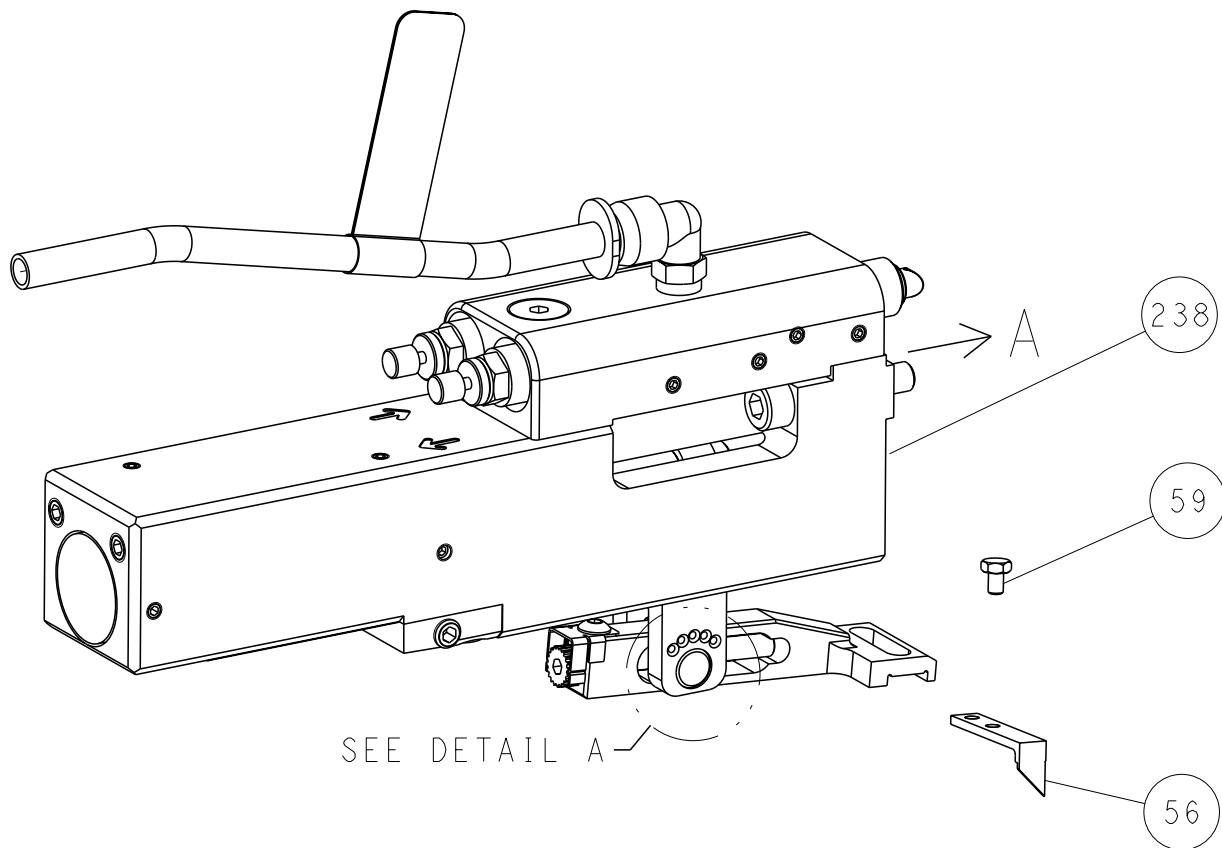
-	-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119791-9	DEPRESSOR, WIRE	286
-	1	1	1	1-22281-8	SPRING, COMPRESSION	262
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	261
-	1	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	-	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	64
-	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	61
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	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	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1803095-7	FLOATING SHEAR, FRONT	9
1	2	1	1	1633689-5	ANVIL, COMBINATION	8
-	1	1	1	240641-1	SPACER	7
-	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	2	1	1	4-1803019-7	CRIMPER, INSULATION O	3
-	-	-	-	-	-	2
1	2	1	1	1803697-2	CRIMPER, WIRE PREMIUM, STEPPED	1
-77	-72	-32	-2	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN C. CHEN CHK S. XI APVD J. CRUZ	05MAY2011 05MAY2011 05MAY2011	 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator			
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		PRODUCT SPEC		SIZE			
		ANGLES		APPLICATION SPEC		CAGE CODE		DRAWING NO	
MATERIAL		FINISH		WEIGHT		A 00779		C=2151332	
-		-		-		-		-	
Customer Accessible Production Drawing						SCALE		1:2	
						SHEET		1 of 4	
						REV		Y	

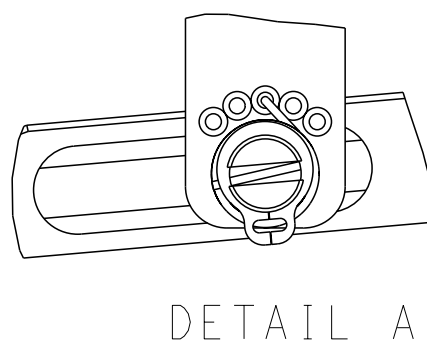
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

FEED TYPE PNEUMATIC

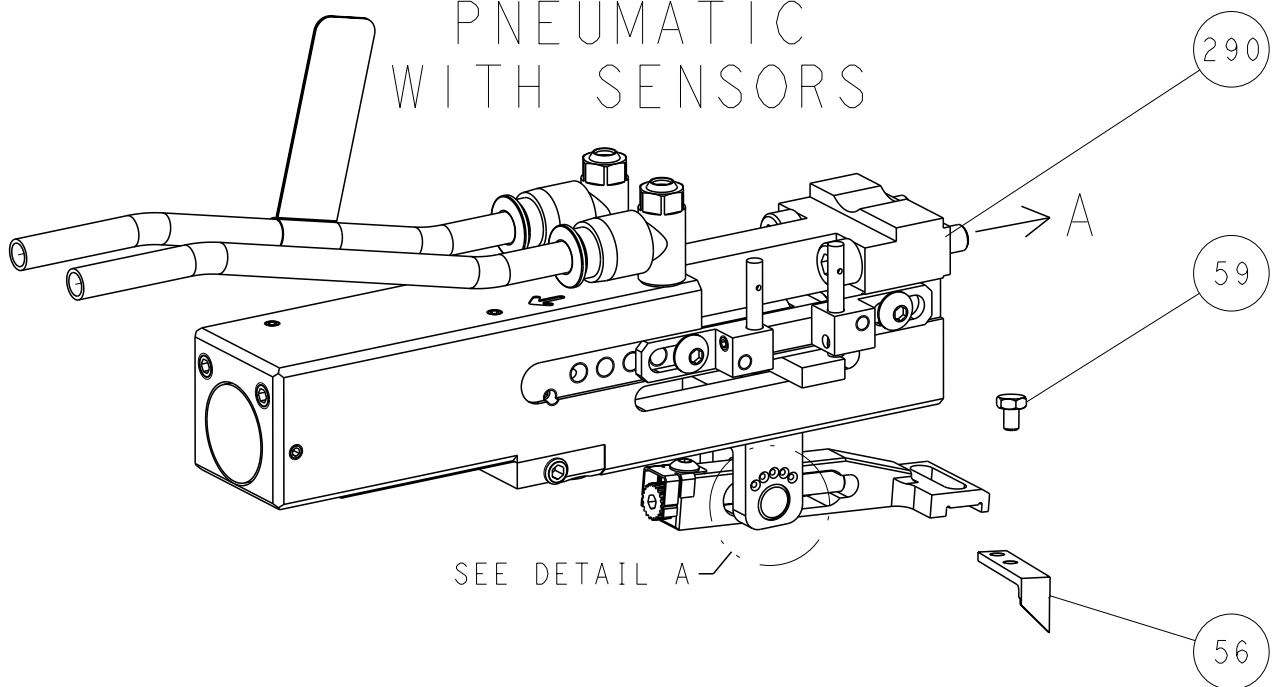


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

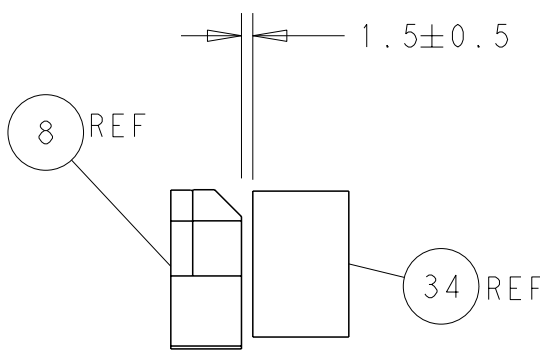
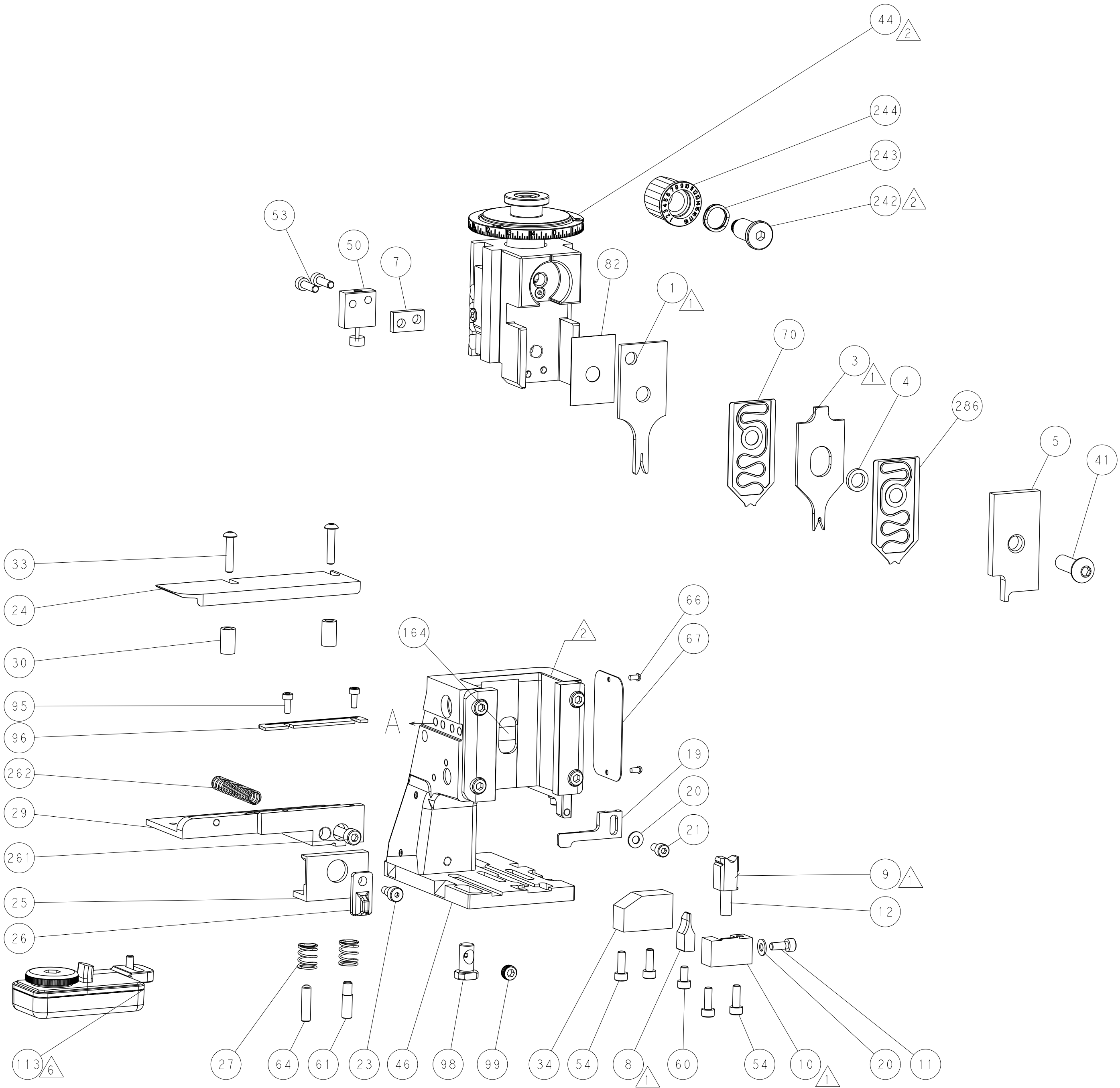
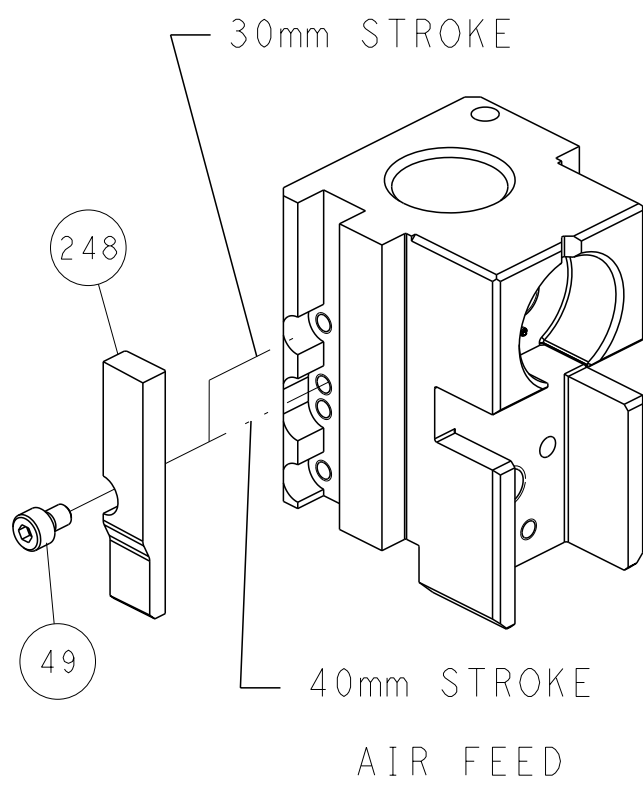


DETAIL A

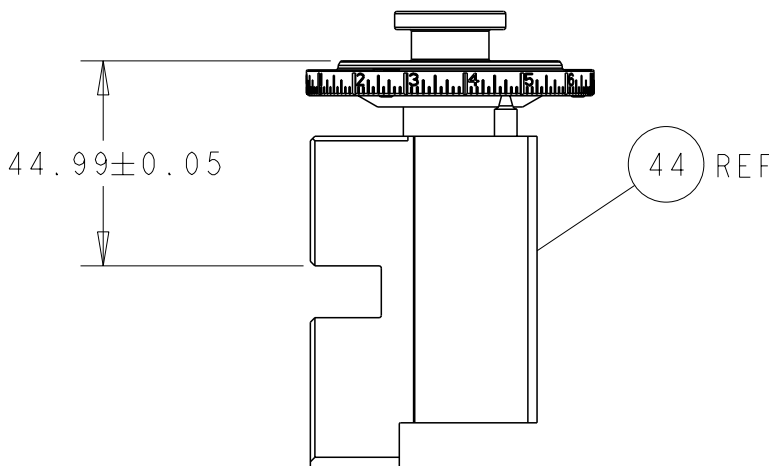
DOUBLE ACTING PNEUMATIC WITH SENSORS



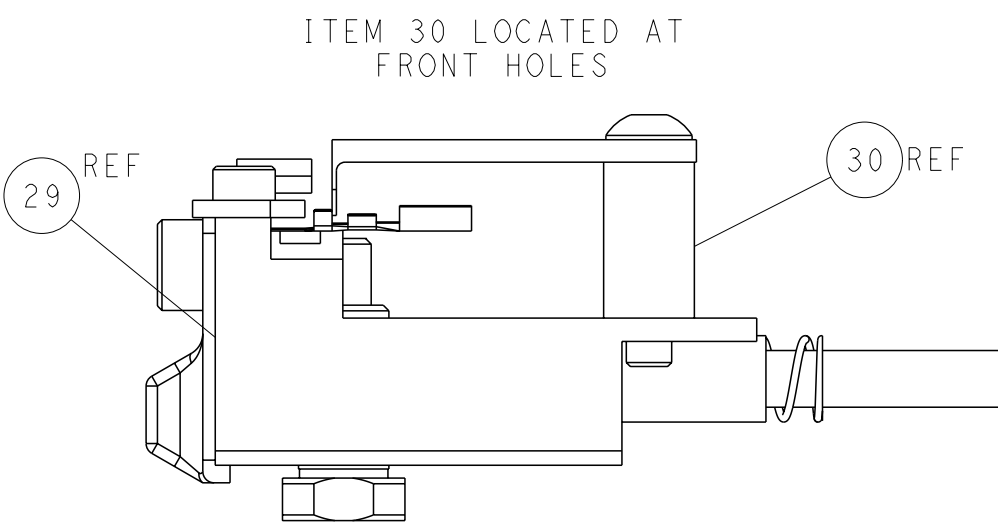
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

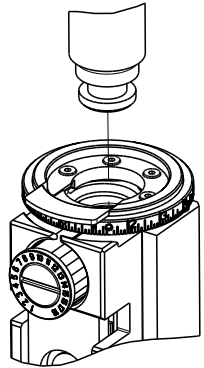
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION				DWN C. CHEN 05MAY2011	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm				CHK S. XI 05MAY2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED:				APVD J. CRUZ 05MAY2011	NAME Ocean Side Feed Applicator	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				PRODUCT SPEC	SIZE A1	
FINISH				APPLICATION SPEC	CAGE CODE 00779	
MATERIAL				WEIGHT	DRAWING NO 2151332	
				Customer Accessible Production Drawing	RESTRICTED TO -	
				SCALE 1:2	SHEET 2 of 4	
					REV Y	

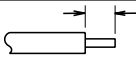
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151332-2	Y	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151332-2	Y	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151332-7	Y	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.89 mm [.035]	F
INSUL	1.07 mm [.042]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO MQS TERMINAL			
WIRE STRIP LENGTH 3.25-3.55 mm [.128-.140 IN]			INSULATION DIAMETER RANGE Ø0.85-1.10 mm [.033-.043 IN]
TERMINAL APPLICATION SPECIFICATION	114-18858	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-1703930-1	1-1703930-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.17mm2		0.63+/-0.02 [.0248+/- .0008]		6.5
0.13mm2		0.59+/-0.02 [.0232+/- .0008]		7.0



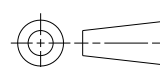
-  RECOMMENDED SPARE PARTS
-  REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
-  APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
-  CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
-  THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
-  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	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
			-	SEE SHEET 1	-	-	-

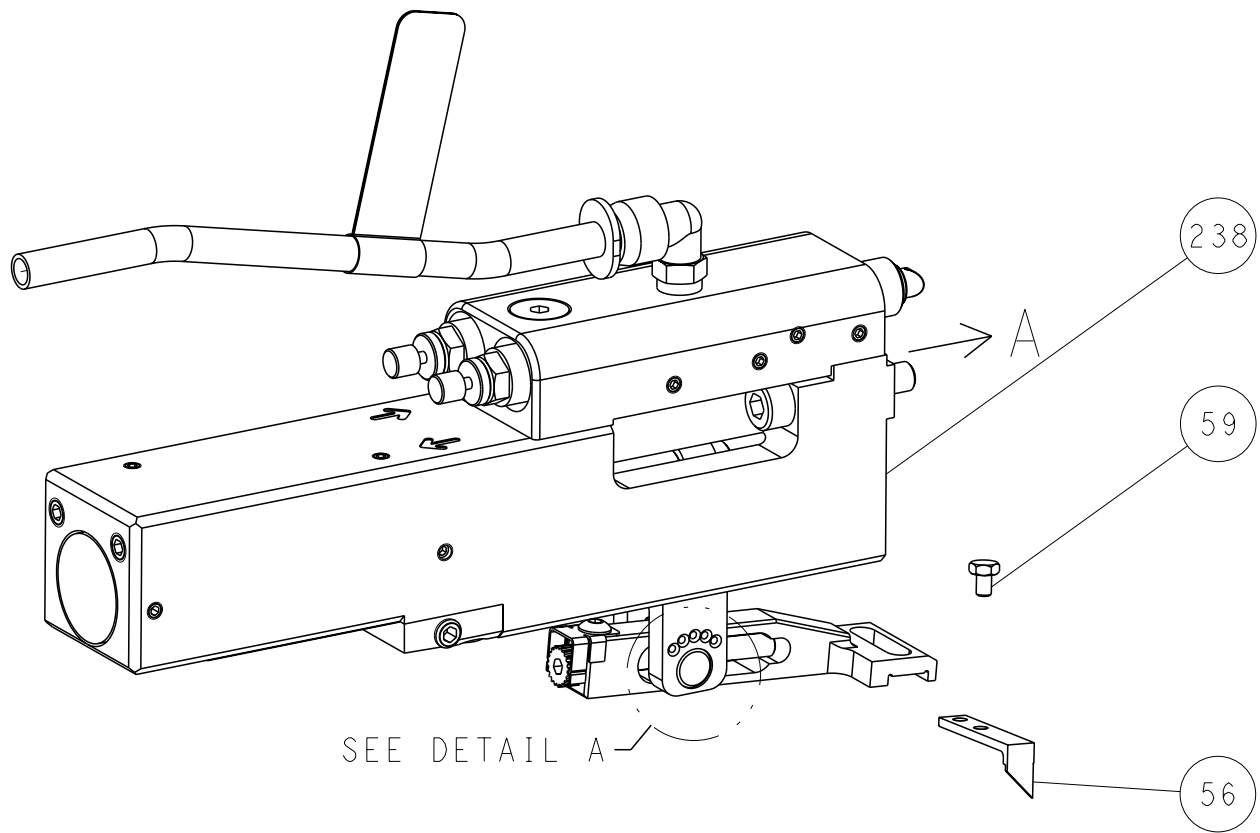
	-	1	-	2844950-1	AIR FEED MODULE	290
	-	1	1	2119791-9	DEPRESSOR, WIRE	286
	-	1	1	1-22281-8	SPRING, COMPRESSION	262
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	261
	-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	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	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
6	-	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	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	64
	-	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	61
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
	-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	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	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844938-1	PLATE, STRIP GUIDE	29
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1803142-1	DRAG, TERMINAL	25
	-	1	1	1320928-2	STRIP GUIDE	24
	-	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
	-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-7	FLOATING SHEAR, FRONT -	9
1	1	1	1	1633689-5	ANVIL, COMBINATION	8
	-	1	1	240641-1	SPACER	7
	-	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	4-1803019-7	CRIMPER, INSULATION O	3
	-	-	-	-	-	2
1	1	1	1	1803697-2	CRIMPER, WIRE PREMIUM, STEPPED	1
	-77	-42	-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS CONTROLLED DOCUMENT FOR THE EFFECTIVE DATE SHOWN. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. CHANGES SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN C. CHEN CHK S. XI APVD J. CRUZ	05MAY2011 05MAY2011 05MAY2011	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	
		APPLICATION SPEC		SIZE A1	
MATERIAL -		WEIGHT -		CAGE CODE 00779	
Customer Accessible Production Drawing		SCALE 1:2		DRAWING NO ©=2151332	
		RESTRICTED TO -		SHEET 3	
				OF 4	
				REV Y	

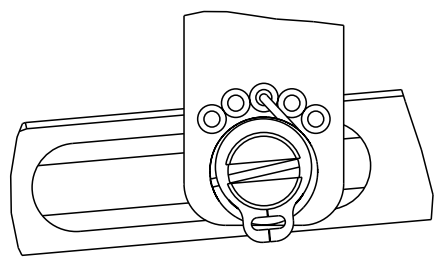
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE
PNEUMATIC

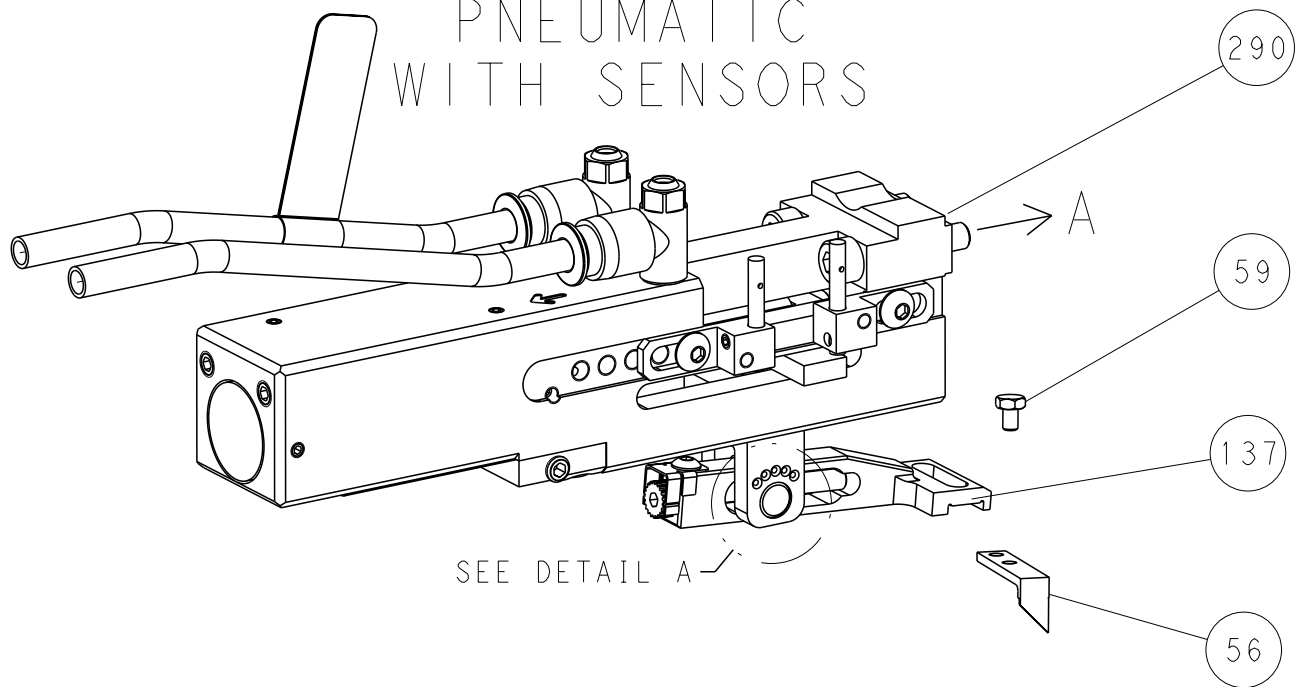


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

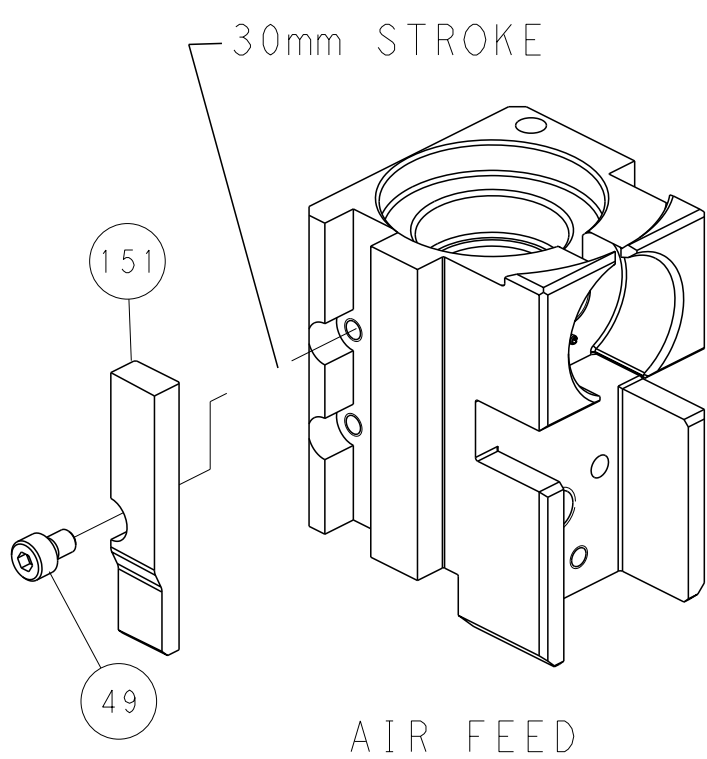


DETAIL A

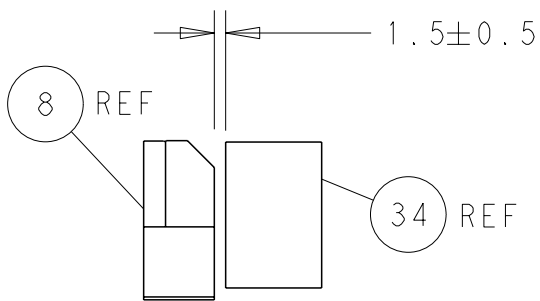
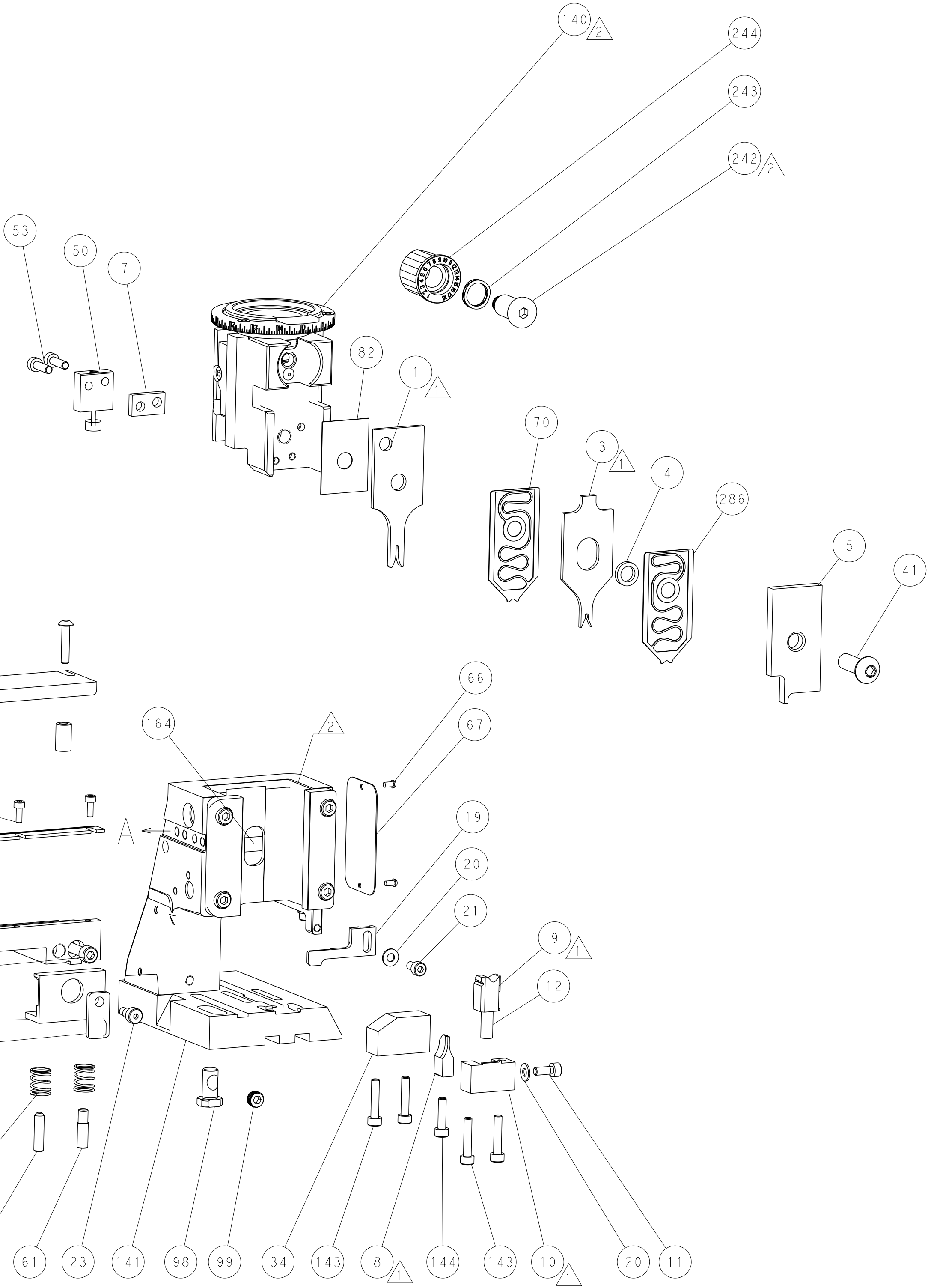
DOUBLE ACTING
PNEUMATIC
WITH SENSORS



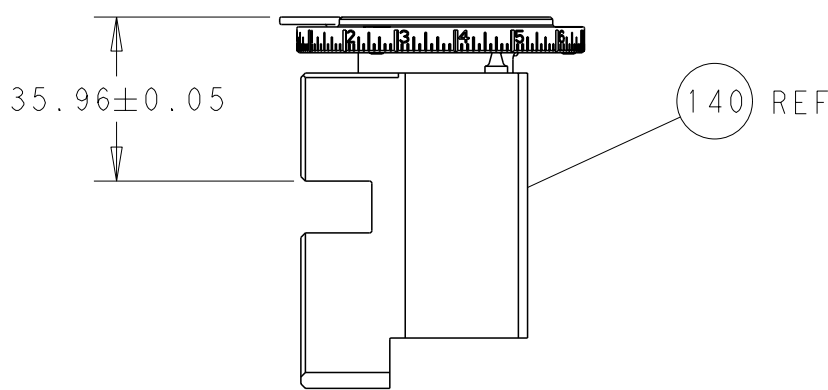
CAM POSITION



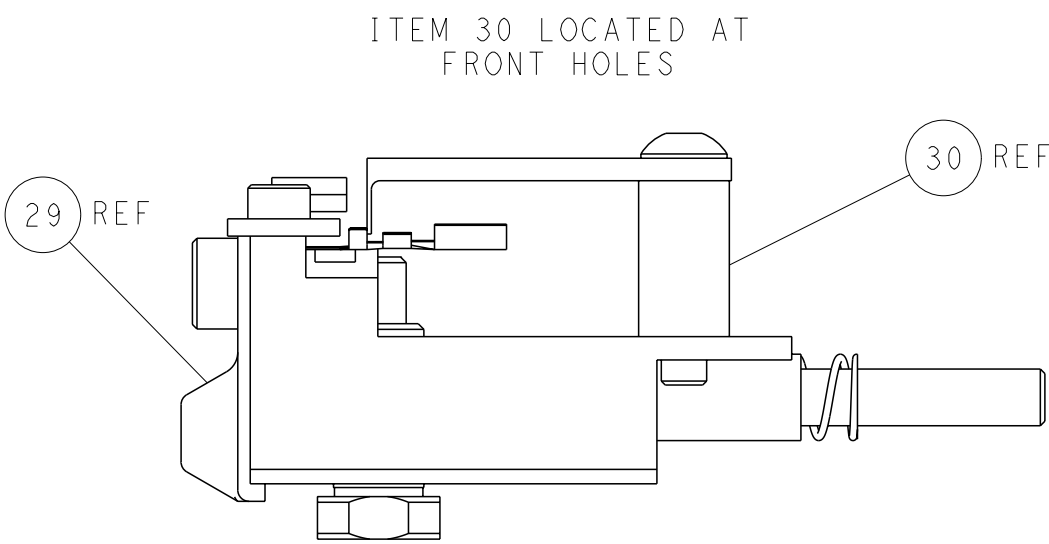
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. CHEN 05MAY2011		STE TE Connectivity	
mm		0 PLC ±		CHK S. XI 05MAY2011		Harrisburg, PA 17105-3608	
FINISH		1 PLC ±		APVD J. CRUZ 05MAY2011		NAME Ocean Side Feed Applicator	
MATERIAL		2 PLC ±		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
		3 PLC ±		APPLICATION SPEC		A1 00779 C=2151332	
		4 PLC ±		WEIGHT		RESTRICTED TO	
		ANGLES		Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV Y	
		FINISH					