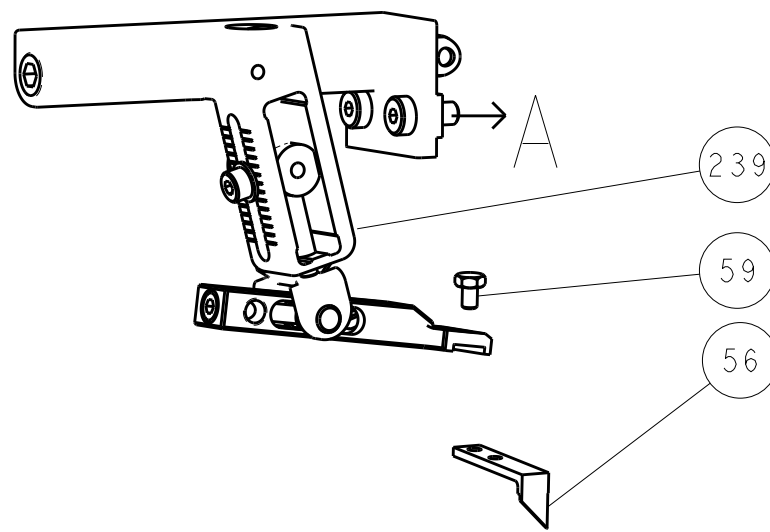
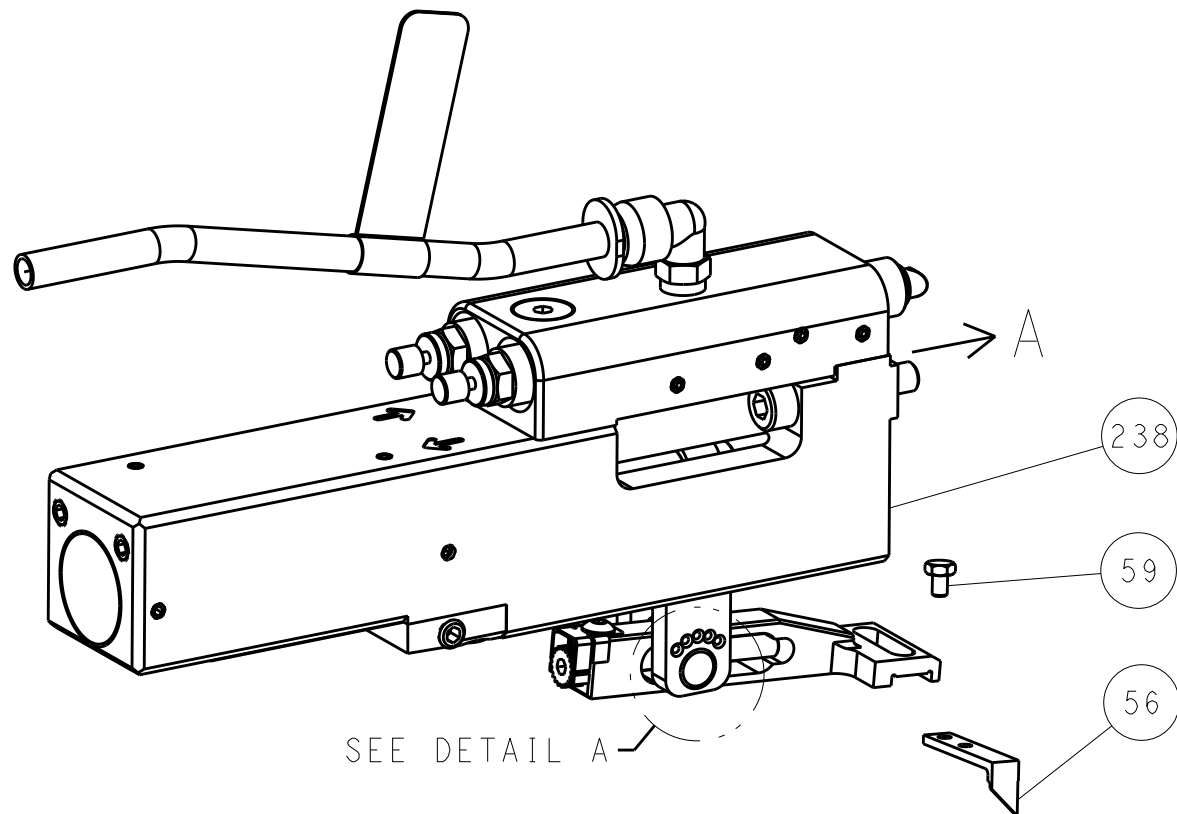


LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

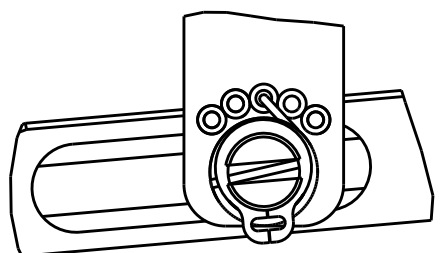
FEED TYPE
MECHANICAL



PNEUMATIC

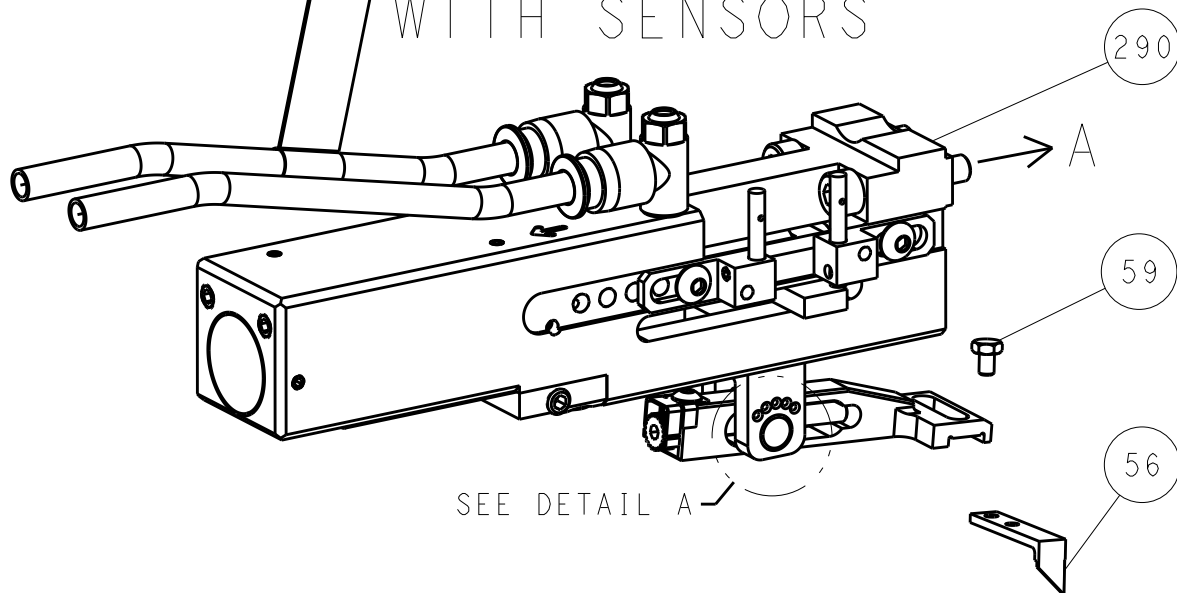


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

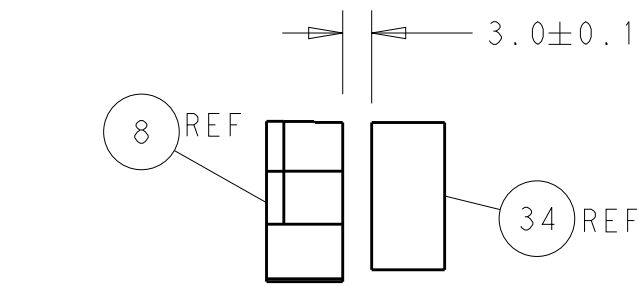
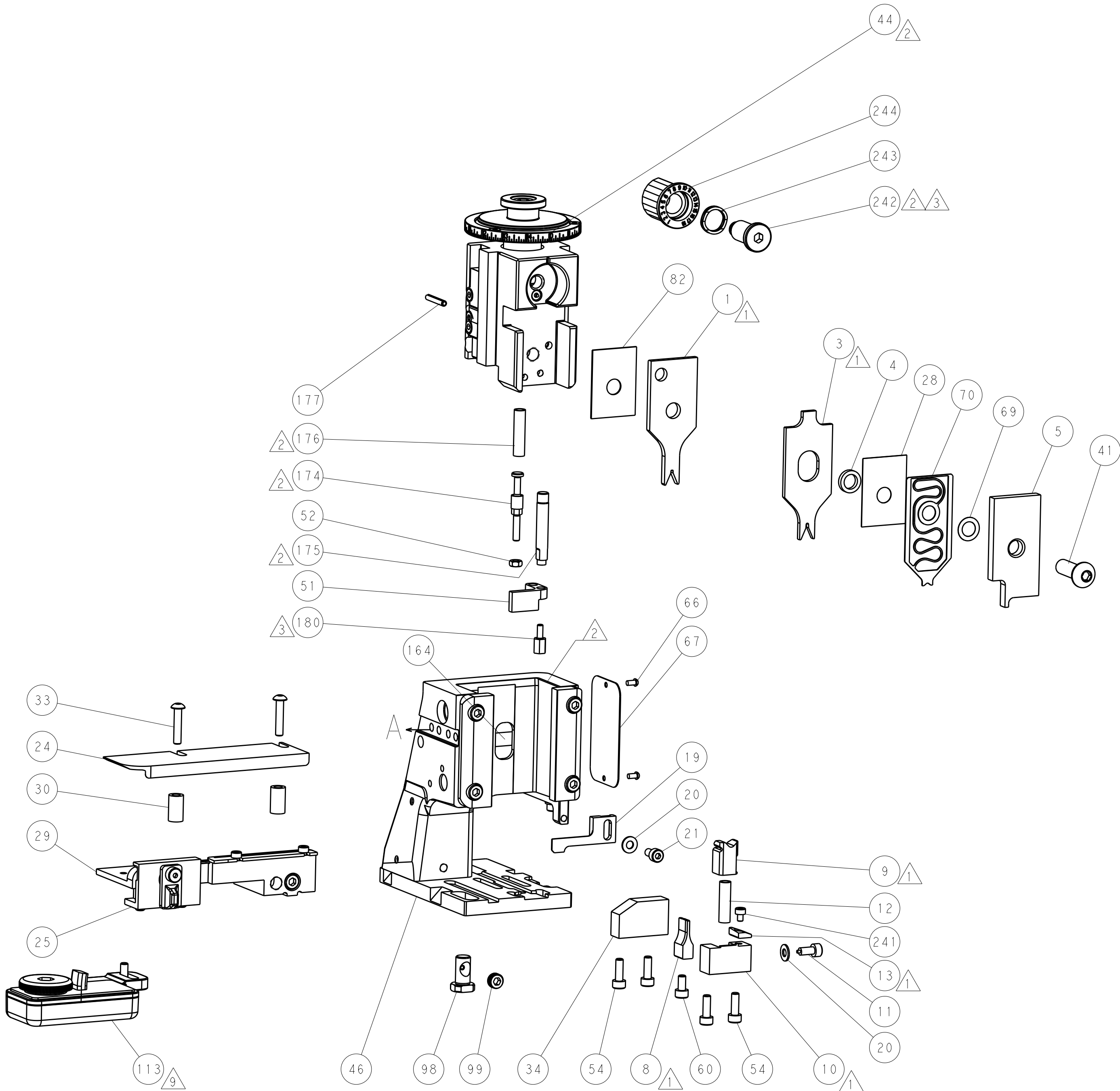
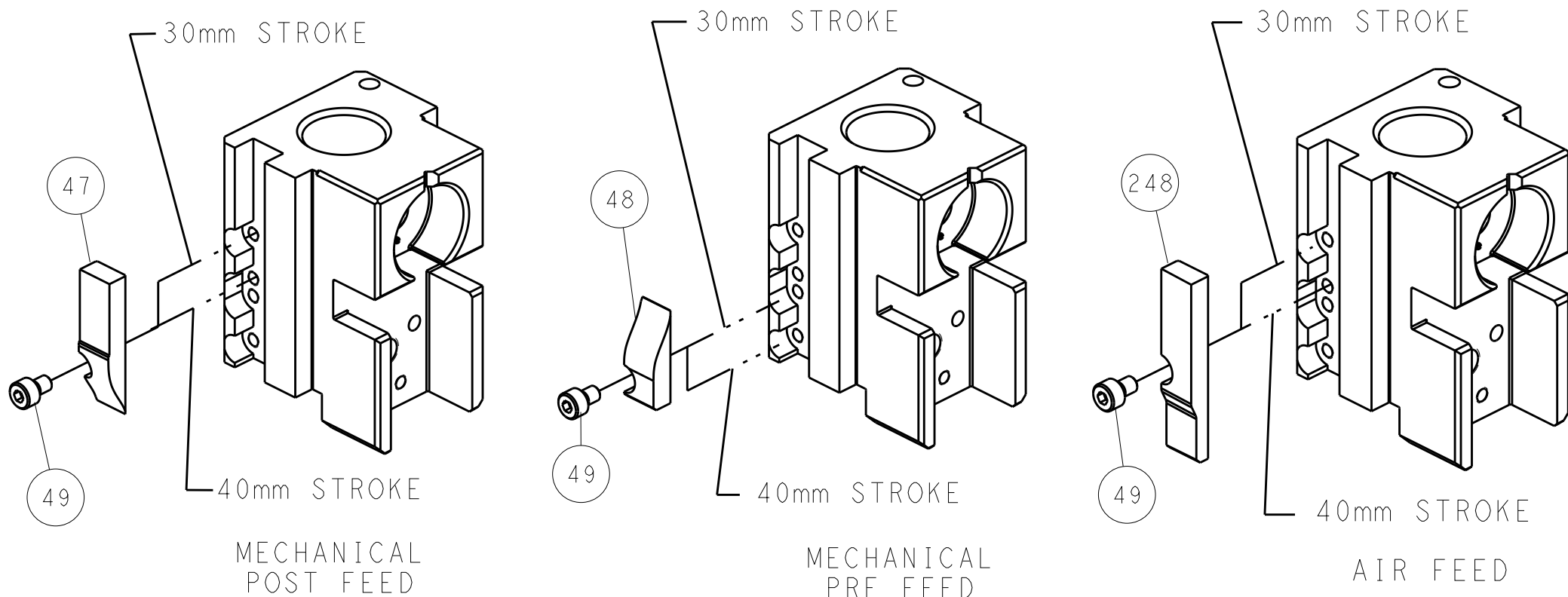


DETAIL A

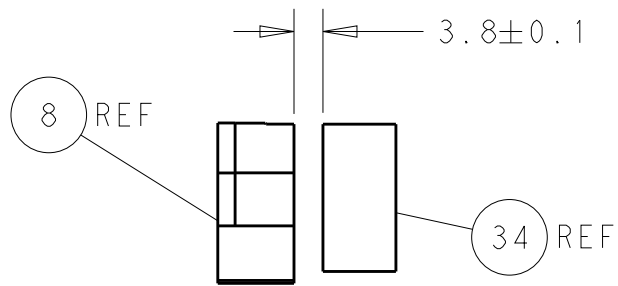
DOUBLE ACTING
PNEUMATIC
WITH SENSORS



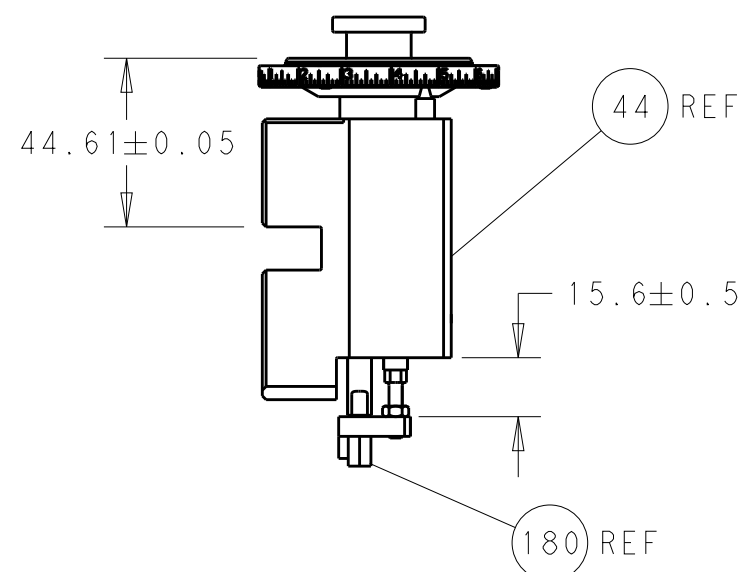
CAM POSITIONS



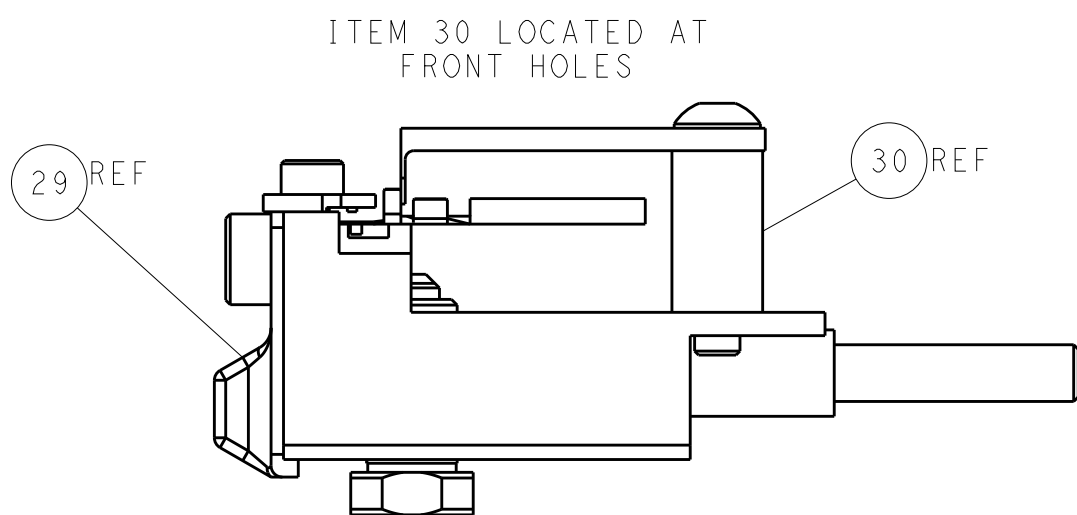
7 TERMINAL SUPPORT LOCATION



8 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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN C. MOYER 31JUL2012	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm				CHK T. ELBIN 31JUL2012	NAME Ocean Side Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED:				APVD T. ELBIN 31JUL2012	SIZE A1		
0 PLC ±.1				PRODUCT SPEC	CAGE CODE 00779		
1 PLC ±.1				APPLICATION SPEC	DRAWING NO 2151725		
2 PLC ±.1				WEIGHT	RESTRICTED TO		
3 PLC ±.1				CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:2		
4 PLC ±.1				SCALE 1:2	SHEET 2 of 4		
ANGLES FINISH				REV U1			

8

7

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

20

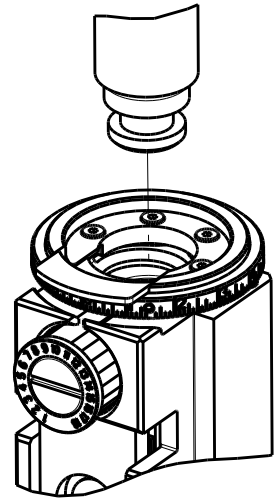
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151725-1	T	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151725-2	U	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151725-2	U	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151725-7	N	CRIMP TOOLING KIT	-

6

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.35 mm [.053]	F
INSUL	1.55 mm [.061]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GENERATION Y, 0.64 STYLE TERMINAL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.00-4.50 mm [.157-.177 IN]		Ø	1.50-1.85 mm [.059-.073 IN]
TERMINAL APPLICATION SPECIFICATION		114-13183	-
		-	-

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1438616-3	1642772-1	1924968-3	2098165-1
1438616-7	1642948-1	1949674-1	2098753-1
1456574-3	1924775-3	2035124-1	2098762-1
1-1456574-3	1924727-1	2035170-1	2138699-1
1-1456841-3	1-1924727-1	1-2035170-1	1-2138699-1
1456968-3	1924955-3	2035334-3	2312100-3
1-1456968-3	1-1924955-3		2312102-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	0.95+/-0.05 [.037+/- .002]	7.7
22 AWG OR 0.35mm2	0.90+/-0.05 [.035+/- .002]	8.3



1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. TE TERMINAL YAZAKI TERMINAL
1642772-1 7114-4618-02
1642948-1 7116-4618-02
1949674-1 7116-5231-08
6. THIS APPLICATOR IS EQUIPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
7. USE TERMINAL SUPPORT LOCATION SPECIFIED FOR FEMALE TERMINALS.
8. USE TERMINAL SUPPORT LOCATION SPECIFIED FOR MALE TERMINALS.
9. TERMINAL LUBRICANT IS RECOMMENDED.
10. 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
		-		SEE SHEET 1	-

-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119082-8	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	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
-	1	1	1	1-1752354-6	STANDOFF,HOLD-DOWN	180
-	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	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	455888-6	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338685-1	PAWL, FEED	56
-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-2	SPACER, CRIMPER	28
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1320928-2	STRIP GUIDE	24
-	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	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1803095-6	FLOATING SHEAR, FRONT -	9
-	1	1	1	1803537-7	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1	1-1803019-2	CRIMPER, INSULATION O	3
-	-	-	-	-	-	2
-	1	1	1	1803364-3	CRIMPER, WIRE PREMIUM	1
-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN C. MOYER 31JUL2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN 31JUL2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01		APVD T. ELBIN 31JUL2012	PRODUCT SPEC	
MATERIAL		FINISH	APPLICATION SPEC	
-		-	WEIGHT	
-		-	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
-		-	SCALE 1:2	
-		-	SHEET 3 OF 4	
-		-	REV U1	

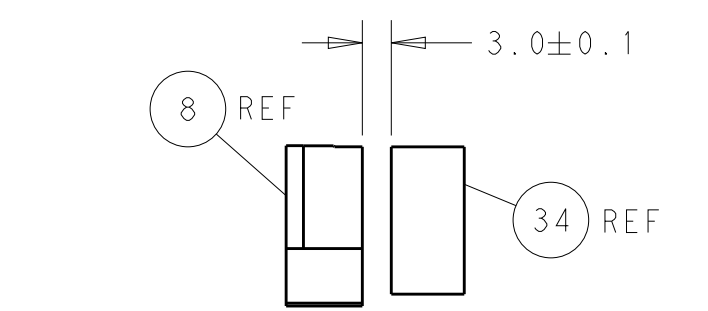
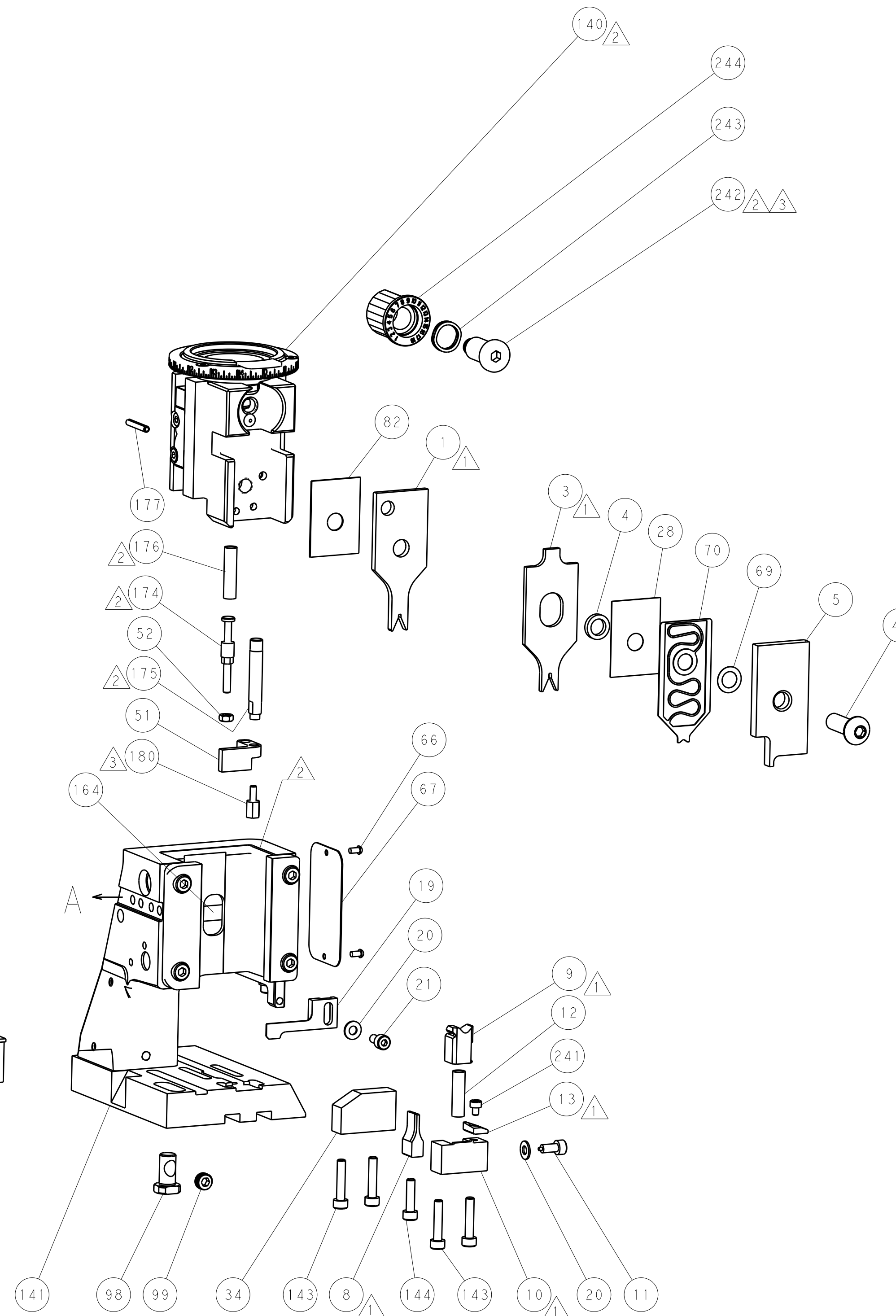
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Diagram illustrating the front view of the machine assembly, showing the main body, handle, and various fasteners. Callouts include 238 for the handle, 59 for a screw, and 56 for a bracket. An arrow points to "SEE DETAIL A".

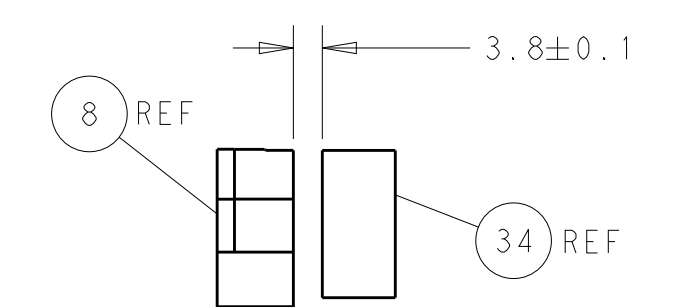
DETAIL A

The diagrams illustrate the installation of the 30mm STROKE feed mechanism for three different configurations:

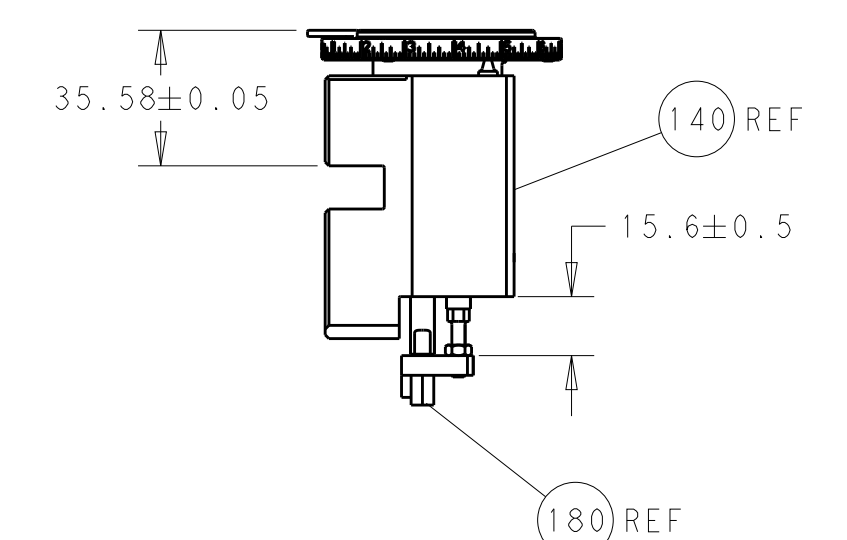
- MECHANICAL POST FEED:** Shows the installation of the 30mm STROKE mechanism. Callout 142 points to the stroke arm, and callout 49 points to the stroke pin.
- MECHANICAL PRE FEED:** Shows the installation of the 30mm STROKE mechanism. Callout 48 points to the stroke arm, and callout 49 points to the stroke pin.
- AIR FEED:** Shows the installation of the 30mm STROKE mechanism. Callout 151 points to the stroke arm, and callout 49 points to the stroke pin.



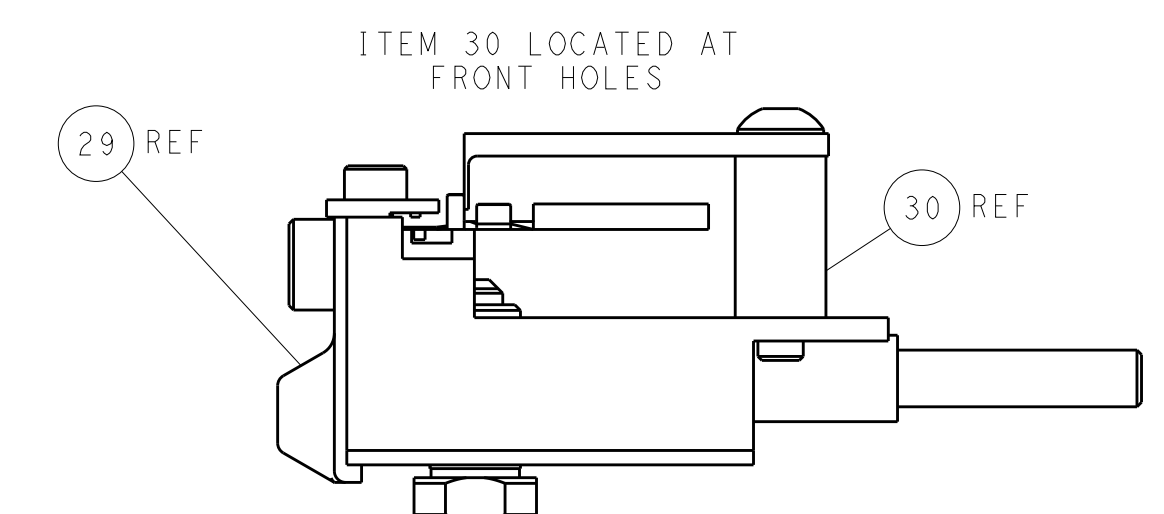
 TERMINAL SUPPORT LOCATION



 TERMINAL SUPPORT LOCATION

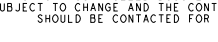


RAM AND HOLDDOWN SET-UP



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TONY IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONSULTED FOR THE LATEST REVISION						DWN S MOYER 31JUL2012				
						CHK ELBIN 31JUL2012	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T ELBIN 31JUL2012		NAME Ocean Side Feed Applicator				
		0. PLC ±. 1. PLC ±. 2. PLC ±. 3. PLC ±. 4. PLC ±. ANGLES ±. FINISH		PRODUCT SPEC - APPLICATION SPEC - WEIGHT -		SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO
						A1		00779	C=2151725	-
MATERIAL - FINISH - -										