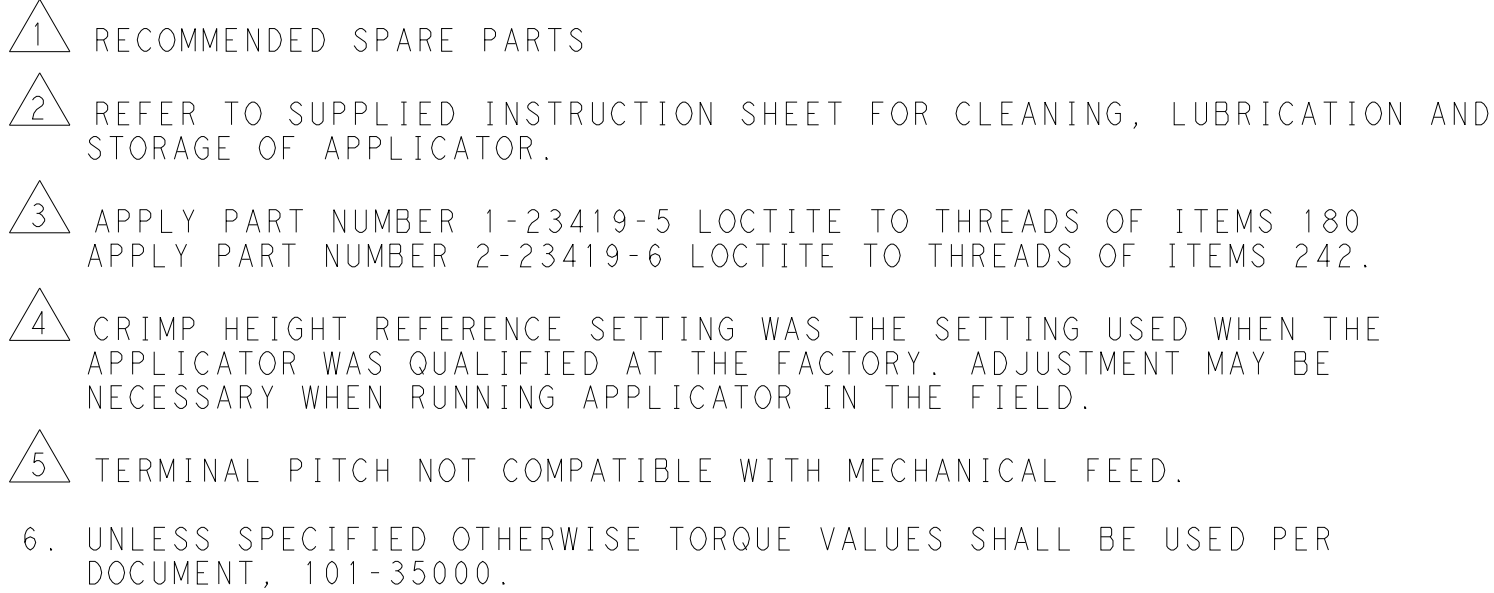


WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		2.57+/-0.05 [.101+/- .002]		6.2
2.00mm2		2.43+/-0.05 [.096+/- .002]		7.8
1.50mm2		2.33+/-0.05 [.092+/- .002]		8.9



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.

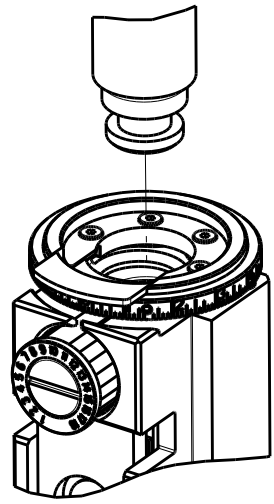
	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	1	2063440-2	AIR FEED MODULE	238
	-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
3	-	1	1	2-1752354-0	STANDOFF, HOLD-DOWN	180
	-	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	240638-1	SPRING, FEED FINGER	163
	-	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	1	2119799-1	HOLDER, FEED FINGER, AF	136
	-	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	1-690438-0	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	1633782-3	FENCE	78
	-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1338683-8	FEED PAWL	56
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1901681-2	HOLDDOWN, TERMINAL	51
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
	-	2	2	4-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1-455888-0	SPACER, CRIMPER	28
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	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
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	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	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	2	1	1-1633932-9	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	1-2119757-3	DEPRESSOR, SHEAR	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	1	2-1633961-7	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-8	SPACER, CRIMPER	2
1	1	2	1	2-456411-9	CRIMPER, WIRE PREMIUM	1
-77-72	-72	-2	PART NO	DESCRIPTION	ITEM NO	

TE CONNECTIVITY IS A REGISTERED TRADEMARK OF TE CONNECTIVITY CORPORATION TE CONNECTIVITY IS A REGISTERED TRADEMARK OF TE CONNECTIVITY CORPORATION TE CONNECTIVITY IS A REGISTERED TRADEMARK OF TE CONNECTIVITY CORPORATION		DWN A HUANG 13DEC2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: mm		NAME Ocean Side Feed Applicator	
		0 PLC ±.1 1 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		FINISH -		SIZE CAGE CODE DRAWING NO A 1 00779 C-2151811	
WEIGHT -		RESTRICTED TO -		SCALE 1:2 SHEET 1 OF 4 REV D	
Customer Accessible Product Drawing					

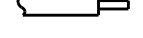
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151811-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151811-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE TERMINAL M4			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.50-6.00 mm [.217-.236 IN]			Ø3.10-4.20 mm [.122-.165 IN]
TERMINAL APPLICATION SPECIFICATION	114-101016	-	-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2050216-1	2050216-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.57+/-0.05 [.101+/- .002]	6.2
2.00mm2	2.43+/-0.05 [.096+/- .002]	7.8
1.50mm2	2.33+/-0.05 [.092+/- .002]	8.9



1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. 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	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2063440-2	AIR FEED MODULE	238
-	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
-	1	2-1752354-0	STANDOFF,HOLD-DOWN	180
-	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	240638-1	SPRING, FEED FINGER	163
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	455888-4	SPACER, CRIMPER	82
-	1	1633782-3	FENCE	78
-	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	2119791-5	DEPRESSOR, WIRE	70
-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1338683-8	FEED PAWL	56
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1901681-2	HOLDDOWN, TERMINAL	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1752356-3	SUPPORT, TERMINAL	34
-	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	2	4-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1-455888-0	SPACER, CRIMPER	28
-	2	22283-1	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-2	STRIP GUIDE	24
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-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1-1633932-9	ANVIL, COMBINATION	8
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-	1	1-2119757-3	DEPRESSOR, SHEAR	5
-	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2-1633961-7	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-8	SPACER, CRIMPER	2
1	1	2-456411-9	CRIMPER, WIRE PREMIUM	1
-	77	-22	PART NO	ITEM NO

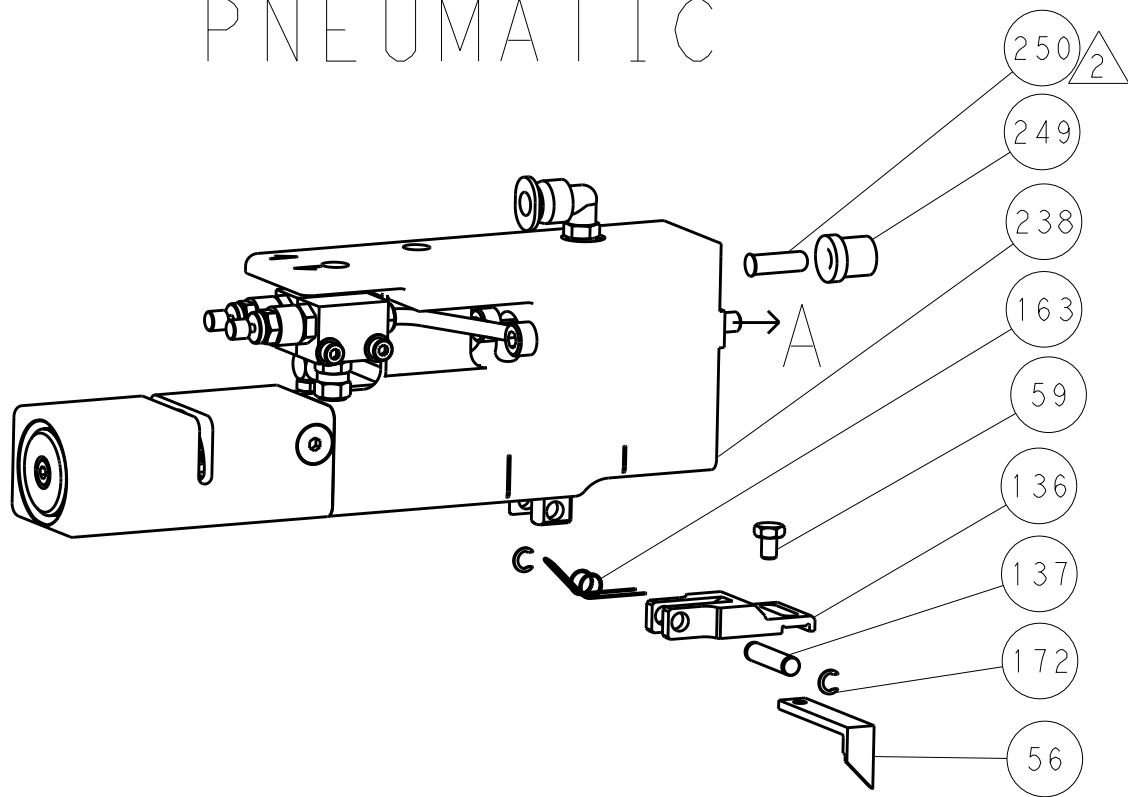
THIS DOCUMENT IS CONTROLLED DOCUMENT FOR THE CUSTOMER'S INFORMATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE CUSTOMER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		OWN A. HUANG CHK S. XI APVD S. XI	13DEC2012 13DEC2012 13DEC2012	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator	
MATERIAL -		WEIGHT -		SIZE A	
		Customer Accessible Production Drawing		SCALE 1:2	
				SHEET 3	
				OF 4	
				REV D	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

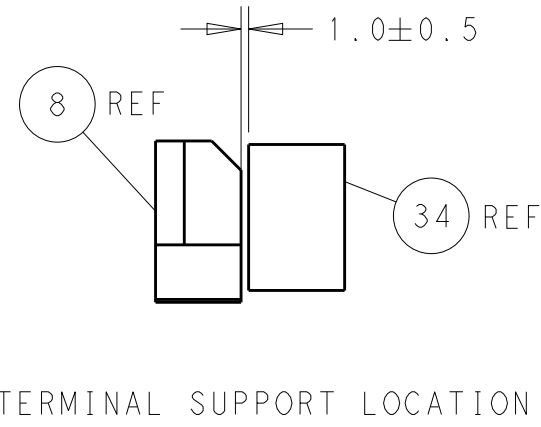
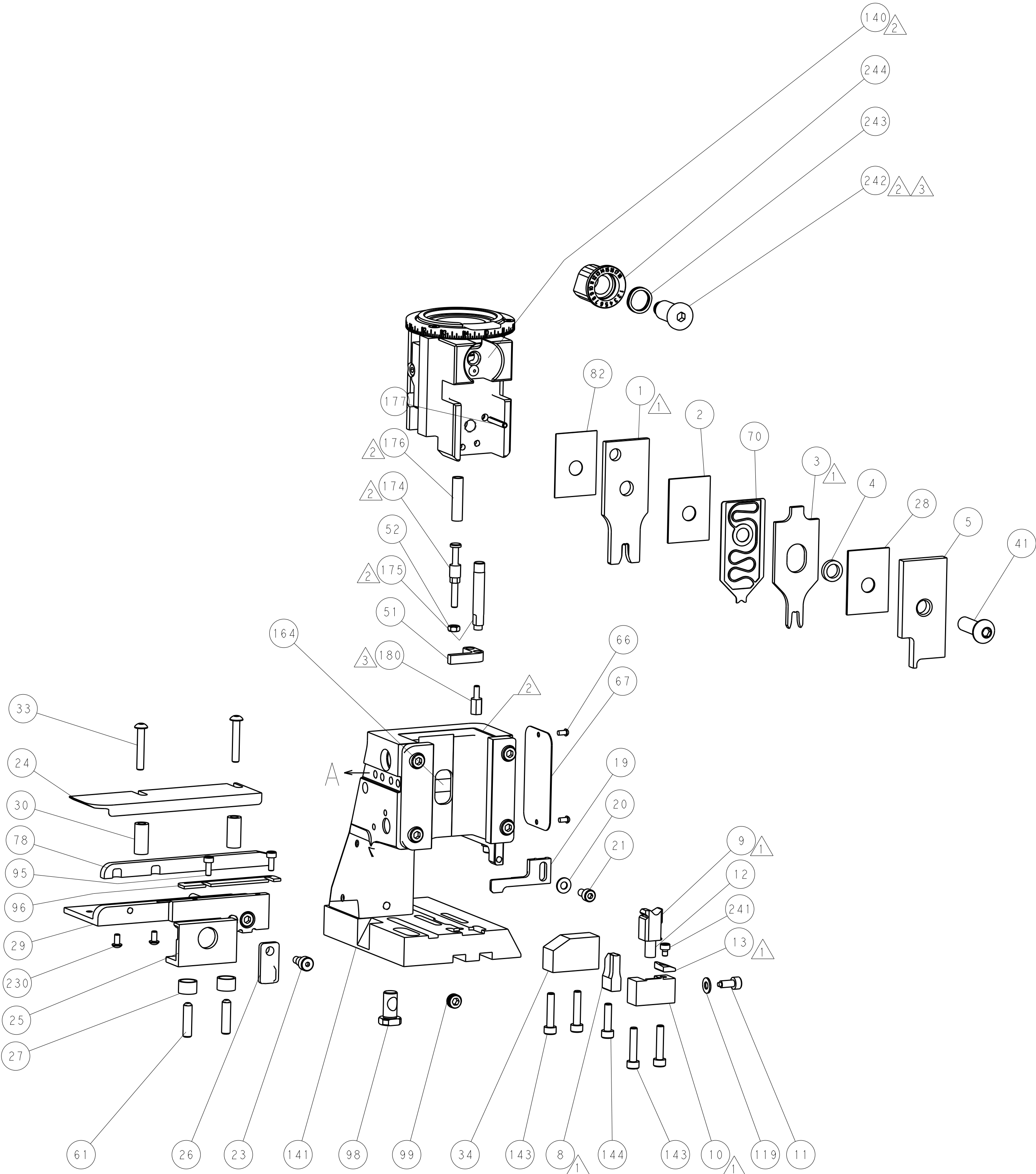
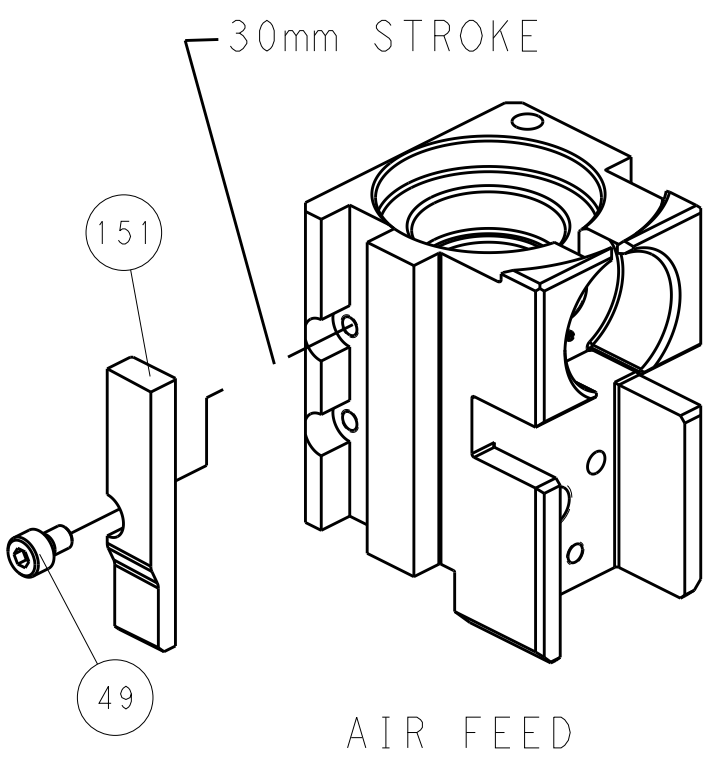
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

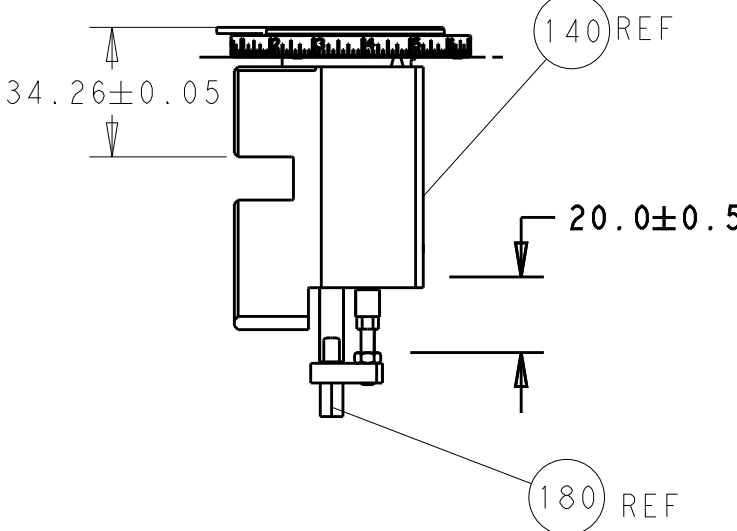
PNEUMATIC



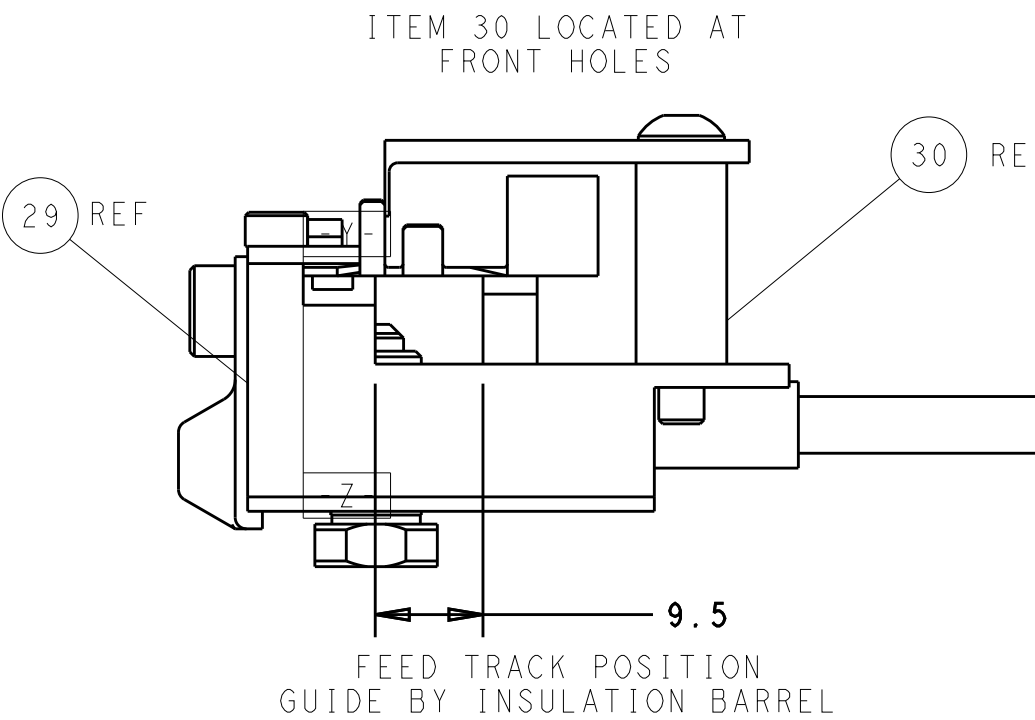
CAM POSITION



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		NAME Ocean Side Feed Applicator	
MATERIAL		PRODUCT SPEC APPLICATION SPEC		SIZE A1	
		WEIGHT		CAGE CODE 00779	
		Customer Accessible Production Drawing		SCALE 1:2	
				SHEET 4	
				REV D	