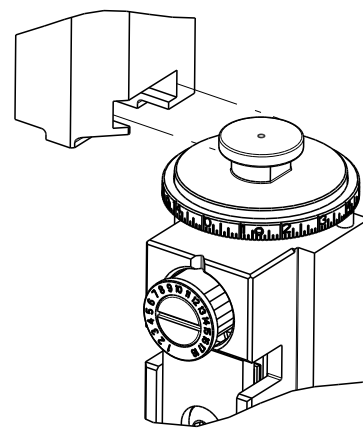


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION 20	
(C) COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151853-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151853-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151853-7	B	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	6.10 mm [.240]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: PRONER TERMINAL		PRONER CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 8mm NGI		CAPACITE 3 A 6mm	
WIRE STRIP LENGTH 5.95-5.97 mm [.234-.235 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION 	PRONER SPEC	-	-
	-	-	-

TERMINALS APPLIED				SEAL INSULATION
TE TERMINAL	PROMER TERMINAL	TE SEAL	PROMER SEAL	DIAMETER RANGE
1544227-1	2398-D-001	1544316-1		Ø 3.20-4.10

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
6.00mm2			3.10+/- 0.05 [.122+/- .002]		5.8
5.00mm2			3.00+/- 0.05 [.118+/- .002]		6.9
4.00mm2			2.72+/- 0.05 [.107+/- .002]		9.5
3.00mm2			2.54+/- 0.05 [.100+/- .002]		11.4



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ⑦ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- ⑧ GRIND TO LENGTH AT ASSEMBLY.

ATLANTIC VERSION

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

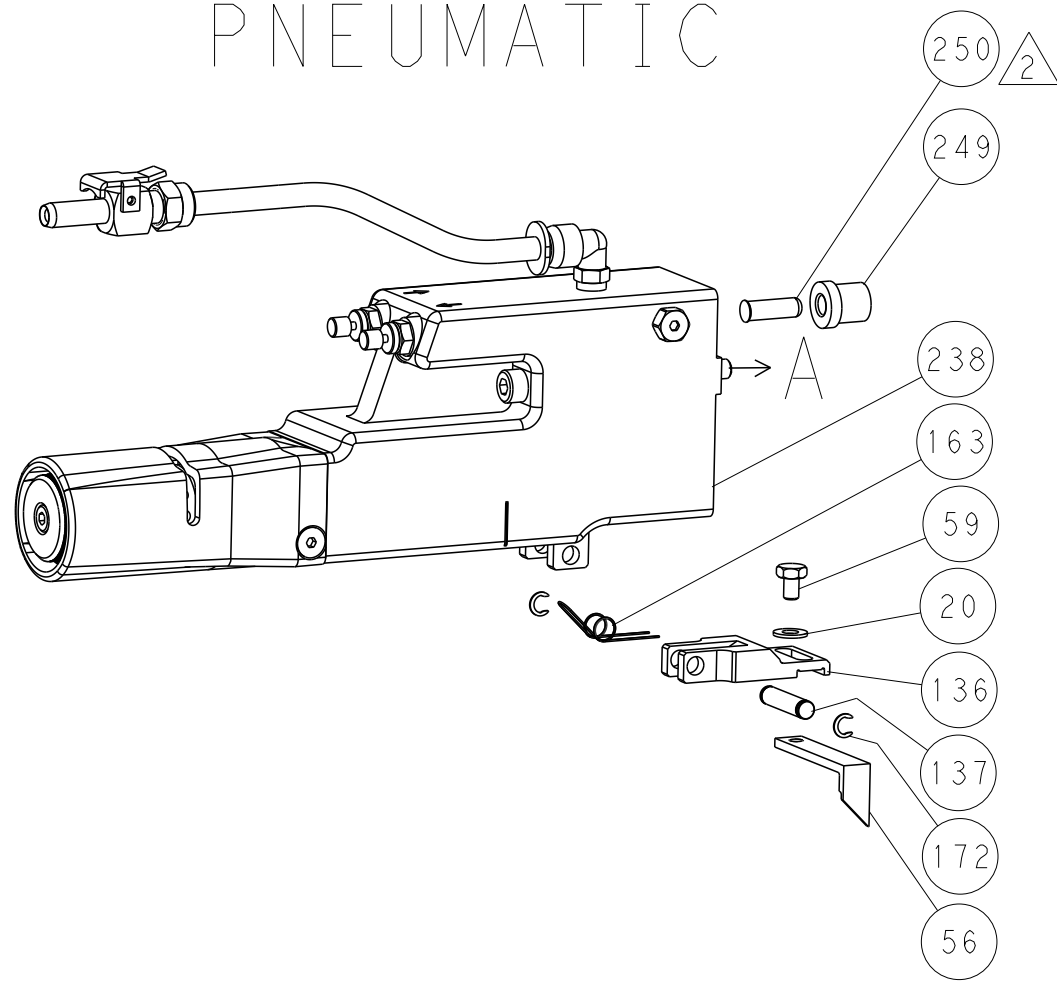
2				1			
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			B	ECR-15-016084	03NOV2015	MR	JDG
			C	ECR-17-003525	10MAR2017	MZ	KZ
			D	ECR-18-018045	16NOV2018	TB	CT

	-	1	1	1803078-1	SPACER, PRECISION	259
	-	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	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	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	1	2063440-2	AIR FEED MODULE	238
	-	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	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	1	1	318563-1	GUARD, FRONT CHIP	89
8	-	1	1	455888-8	SPACER, CRIMPER	82
	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
	-	1	1	1803096-1	EXTENSION PLATE	78
	-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-6	DEPRESSOR, WIRE	70
	-	1	1	2119943-1	WASHER, SPACER	69
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
7	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
	-	1	1	1338683-8	FEED PAWL	56
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
	-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1803583-3	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
	-	1	1	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-4	SPACER, CRIMPER	28
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1320928-4	STRIP GUIDE	24
	-	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	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	1-356885-4	STOP, SHEAR	11
	-	1	1	2119805-2	SHEAR HOLDER, FRONT	10
1	-	1	1	318059-4	FLOATING SHEAR, FRONT	9
	1	2	1	6-1633620-4	ANVIL, COMBINATION	8
1	-	1	1	240641-1	SPACER	7
	-	-	-	-	-	6
	-	1	1	2-2119781-7	DEPRESSOR, SHEAR	5
1	-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
	1	2	1	1803101-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
1	-	1	1	1-455888-7	SPACER, CRIMPER	2
	1	2	1	1-1633738-7	CRIMPER, WIRE	1

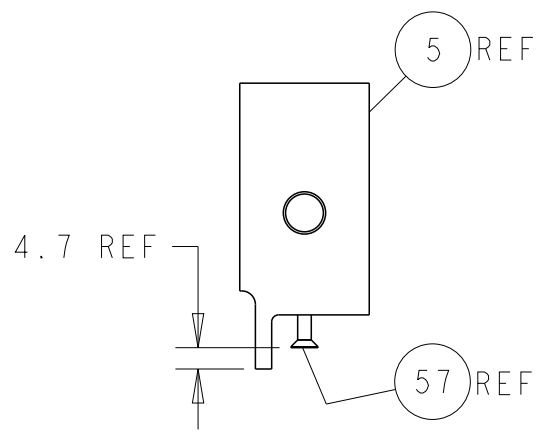
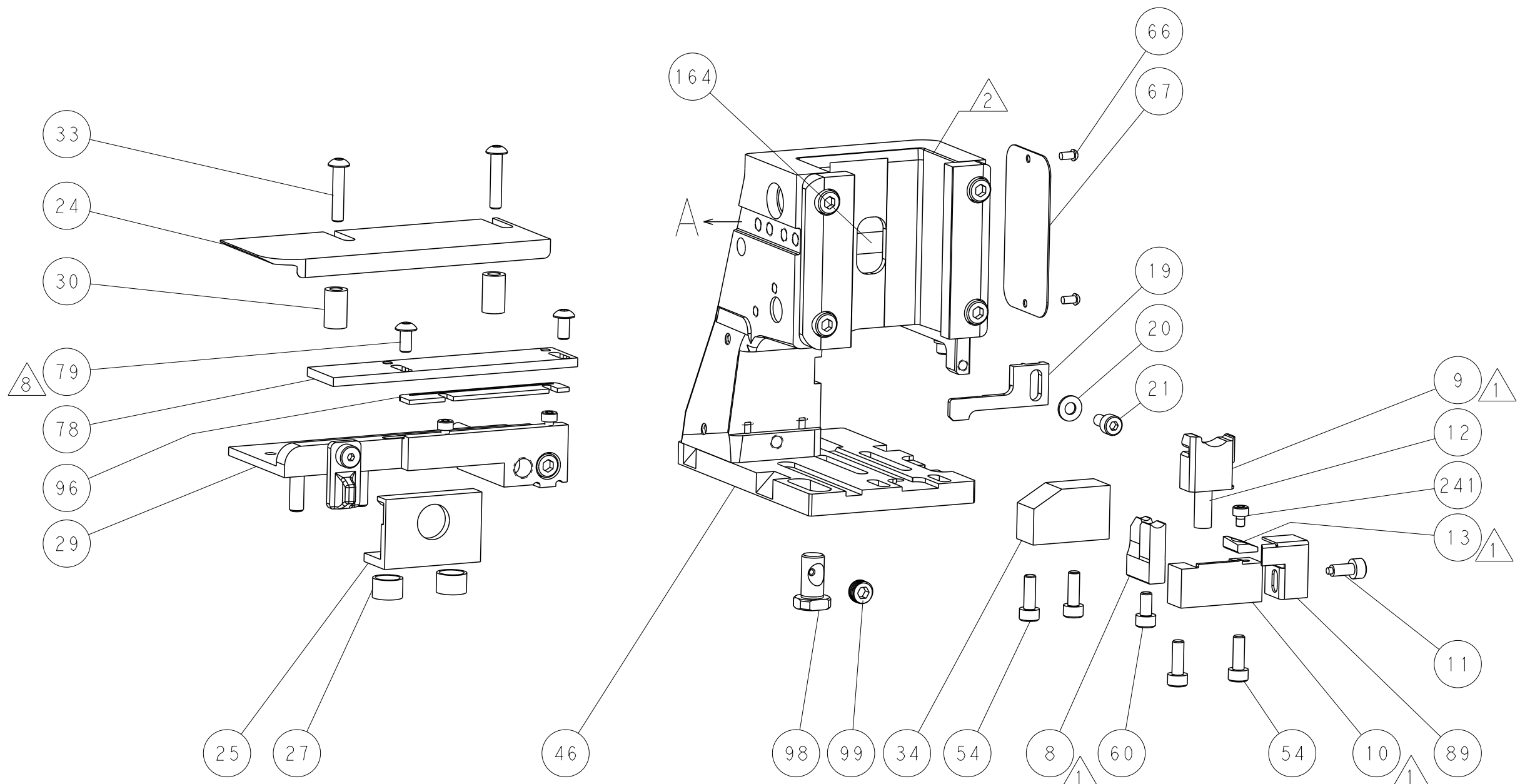
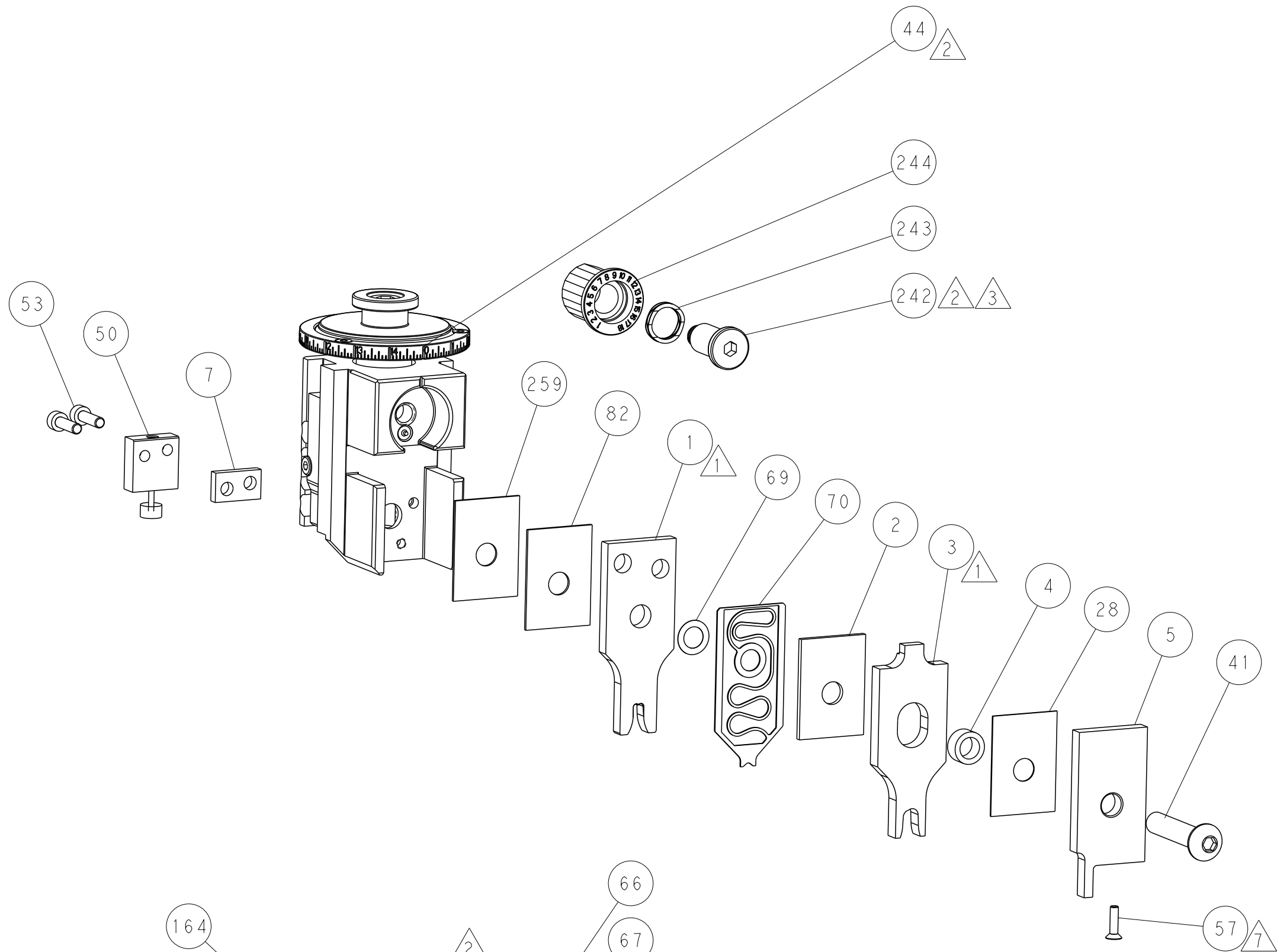
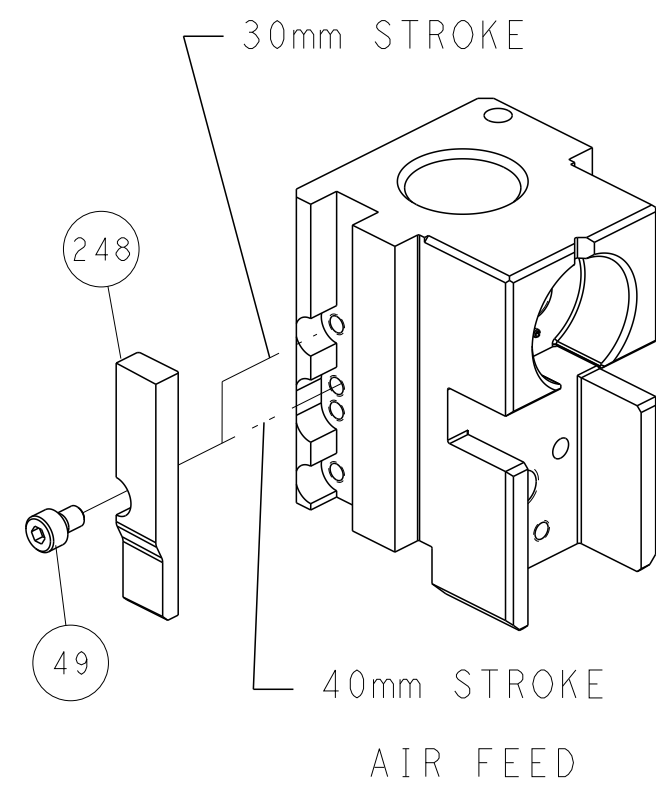
THIS DRAWING IS A CONTROLLED DOCUMENT AND NOT BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM THE COMPANY. ANY UNAUTHORIZED REPRODUCTION OR TRANSMISSION OF THIS DRAWING IS PROHIBITED. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		OWN 14JAN2013 BY T.YIN CHK 14JAN2013 G.BALEY APP 14JAN2013 S.XI		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	

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

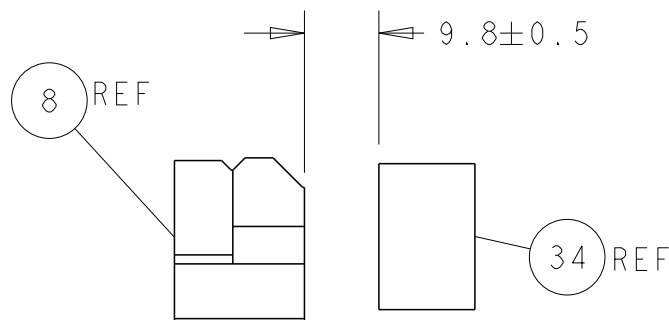
FEED TYPE PNEUMATIC



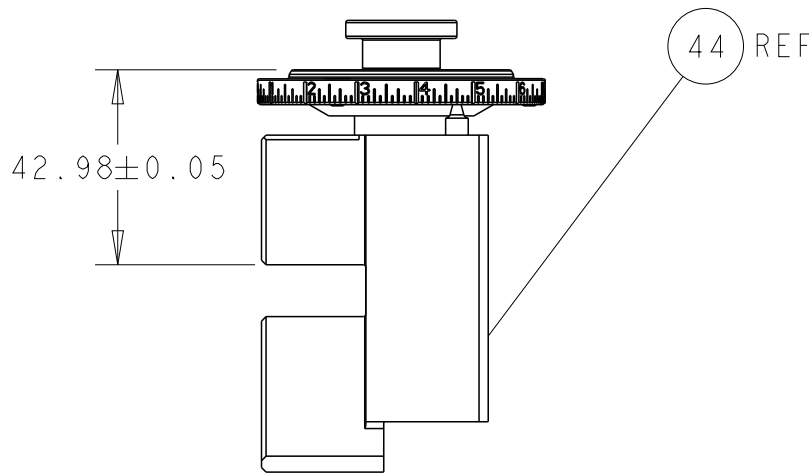
CAM POSITION



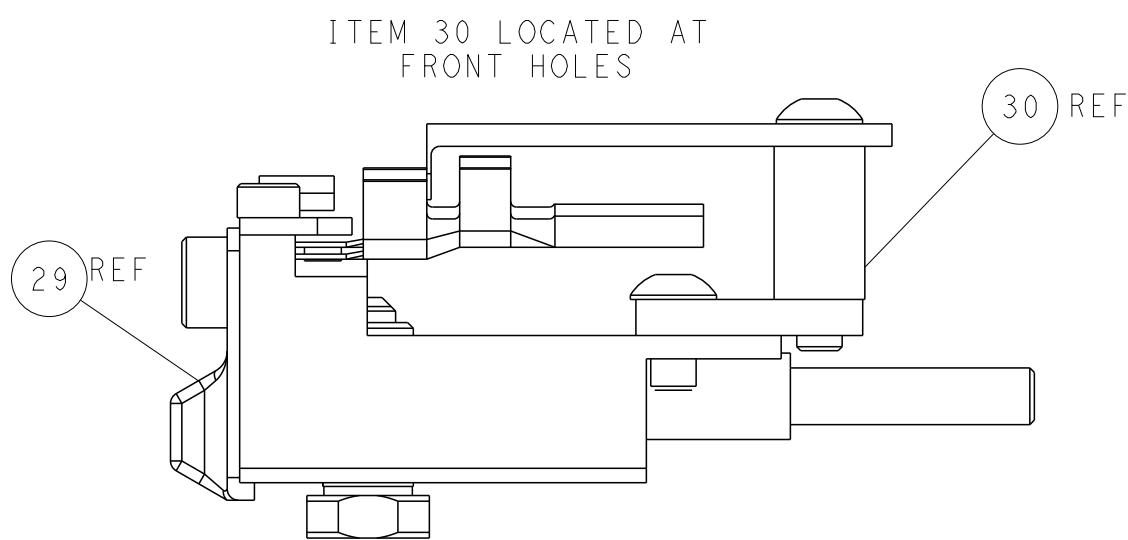
SHEAR DEPRESSOR DETAIL



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 WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN Y. YIN 14JAN2013	TE Connectivity Harrisburg, PA 17105-3608	
CHK G. BAILEY 14JAN2013				APVD S. XI 14JAN2013		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	NAME Ocean Side Feed Applicator	
		0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01 FINISH -		APPLICATION SPEC		
MATERIAL -		-		WEIGHT -	SIZE A1	CAGE CODE 00779
				Customer Accessible Production Drawing	SCALE 1:2	SHEET 2
					OF 4	REV D

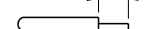
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8	7
THIS DRAWING IS UNPUBLISHED.	
RELEASED FOR PUBLICATION 20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION
DESCRIPTION	FEED TYPE
2-2151853-2	D
7-2151853-7	B
FINE CRIMP HEIGHT ADJUST	PNEUMATIC
CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	6.10 mm [.240]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: PRONER TERMINAL		PRONER CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 8mm NG1 CAPACITE 3 A 6mm			
WIRE STRIP LENGTH 5.95-5.97 mm [.234-.235 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION	PRONER SPEC	-	-
	-	-	-
TERMINALS APPLIED			
		SEAL INSULATION DIAMETER RANGE	
TE TERMINAL	PRONER TERMINAL	TE SEAL	PRONER SEAL
1544227-1	2398-D-001	1544316-1	
			Ø 3.20-4.10

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
6.00mm2		3.10+/-0.05 [.122+/- .002]		5.8
5.00mm2		3.00+/-0.05 [.118+/- .002]		6.9
4.00mm2		2.72+/-0.05 [.107+/- .002]		9.5
3.00mm2		2.54+/-0.05 [.100+/- .002]		11.4



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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
7. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
8. GRIND TO LENGTH AT ASSEMBLY.

*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	-

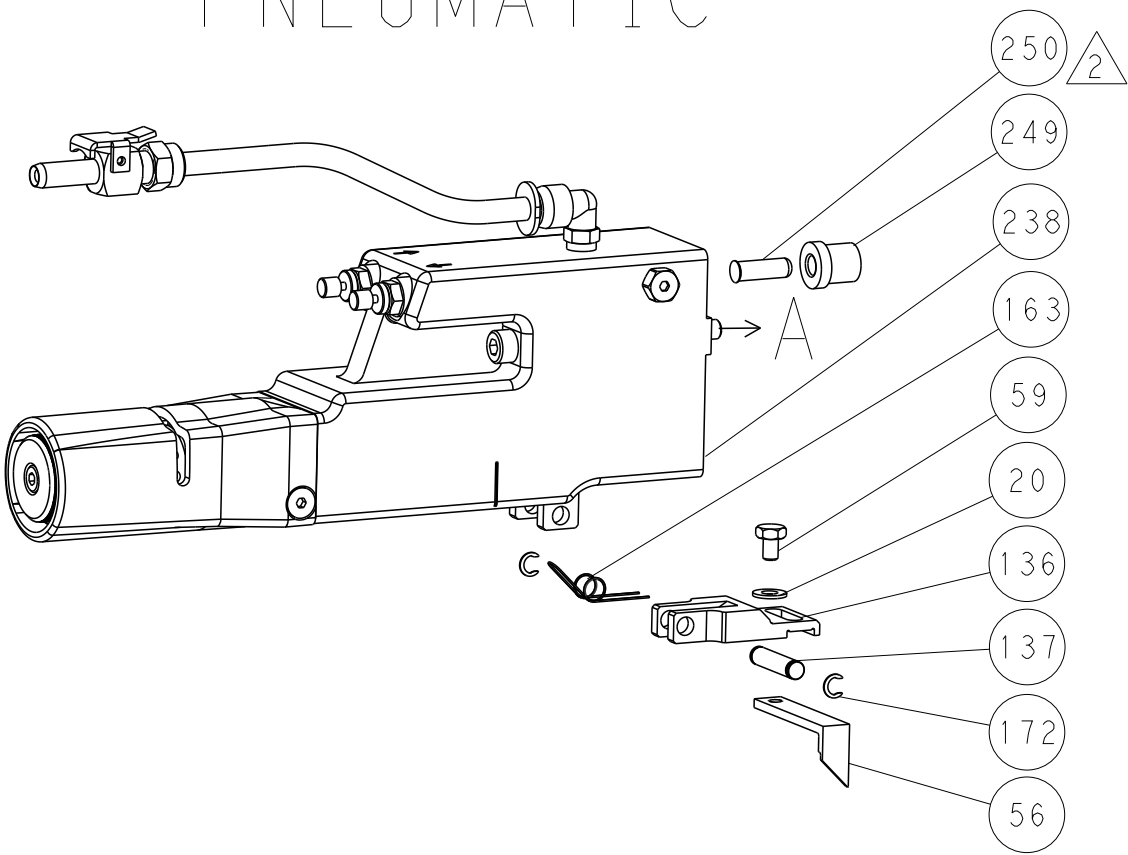
-	1	1803078-1	SPACER, PRECISION	259
-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2063440-2	AIR FEED MODULE	238
-	2	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	1803583-4	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-2	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	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	318563-1	GUARD, FRONT CHIP	89
-	1	455888-8	SPACER, CRIMPER	82
8	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1803096-1	EXTENSION PLATE	78
-	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	2119791-6	DEPRESSOR, WIRE	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
7	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
-	1	1338683-8	FEED PAWL	56
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	455888-4	SPACER, CRIMPER	28
-	2	22283-1	SPRING, COMPRESSION	27
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-4	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
1	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
1	1	2119805-2	SHEAR HOLDER, FRONT	10
1	1	318059-4	FLOATING SHEAR, FRONT	9
1	1	6-1633620-4	ANVIL, COMBINATION	8
-	1	240641-1	SPACER	7
-	-	-	-	6
-	1	2-2119781-7	DEPRESSOR, SHEAR	5
-	1	4-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1803101-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1-455888-7	SPACER, CRIMPER	2
1	1	1-1633738-7	CRIMPER, WIRE	1
-77	-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS CONTROLLED DOCUMENT FOR THE CUSTOMER'S INFORMATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		OWN Y. YIN CHK G. BAILEY APVD S. XI	14JAN2013 14JAN2013 14JAN2013	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	
		PRODUCT SPEC APPLICATION SPEC		SIZE 00779	
MATERIAL -		WEIGHT -		DRAWING NO C=2151853	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 3 OF 4	
				REV D	

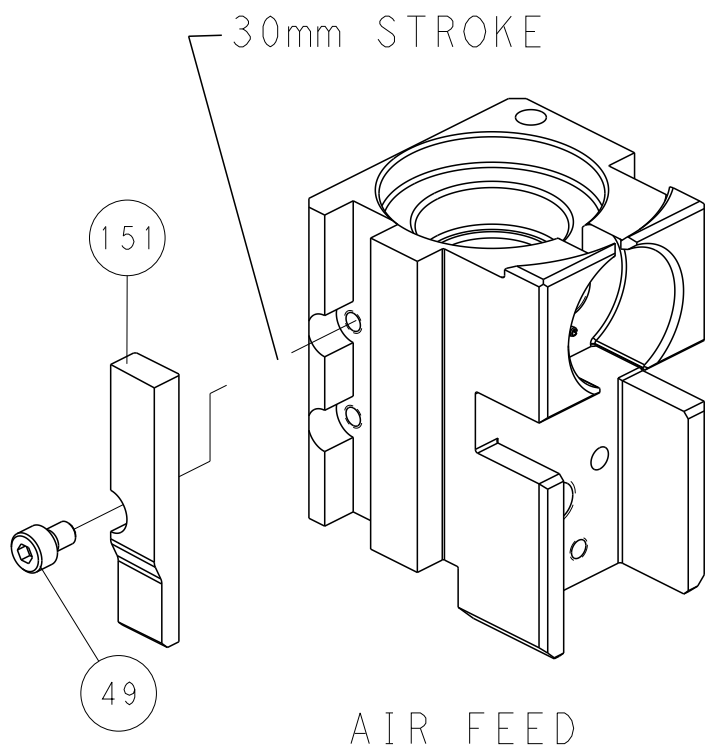
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

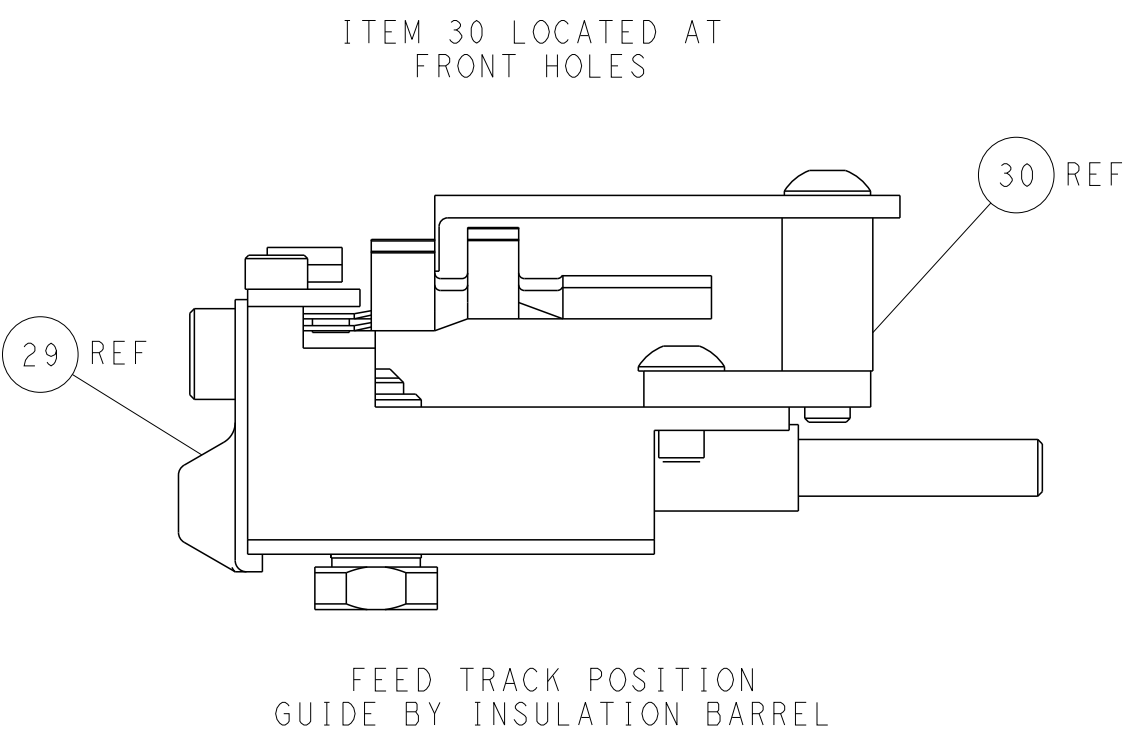
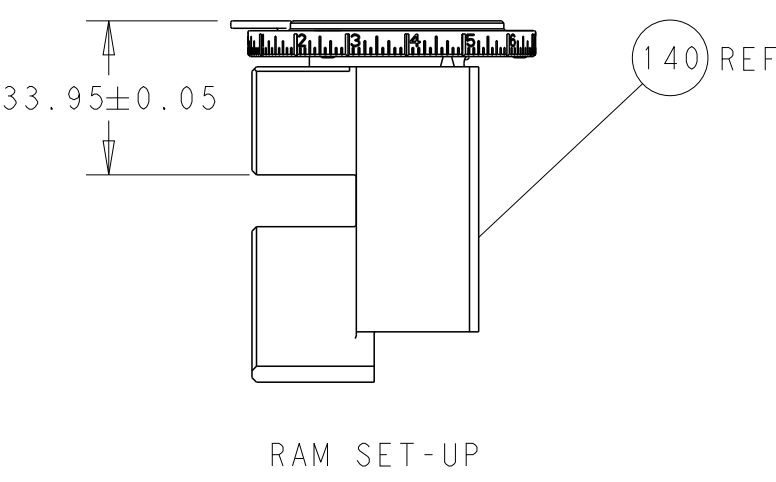
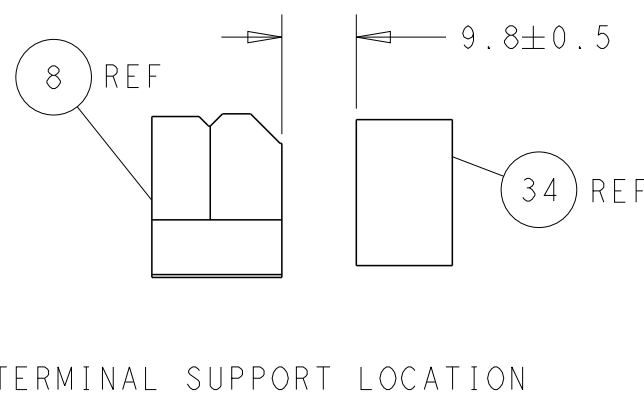
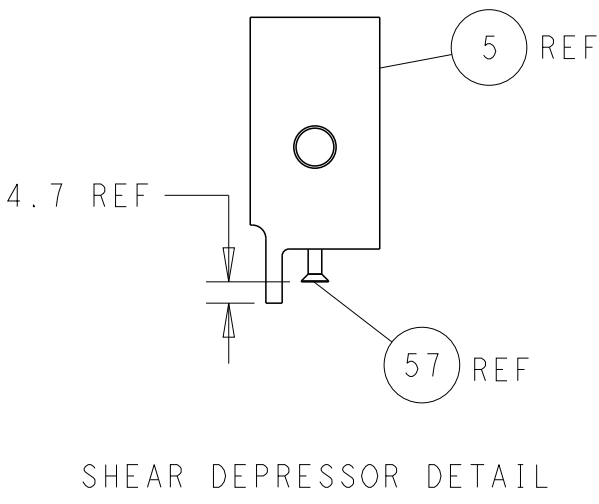
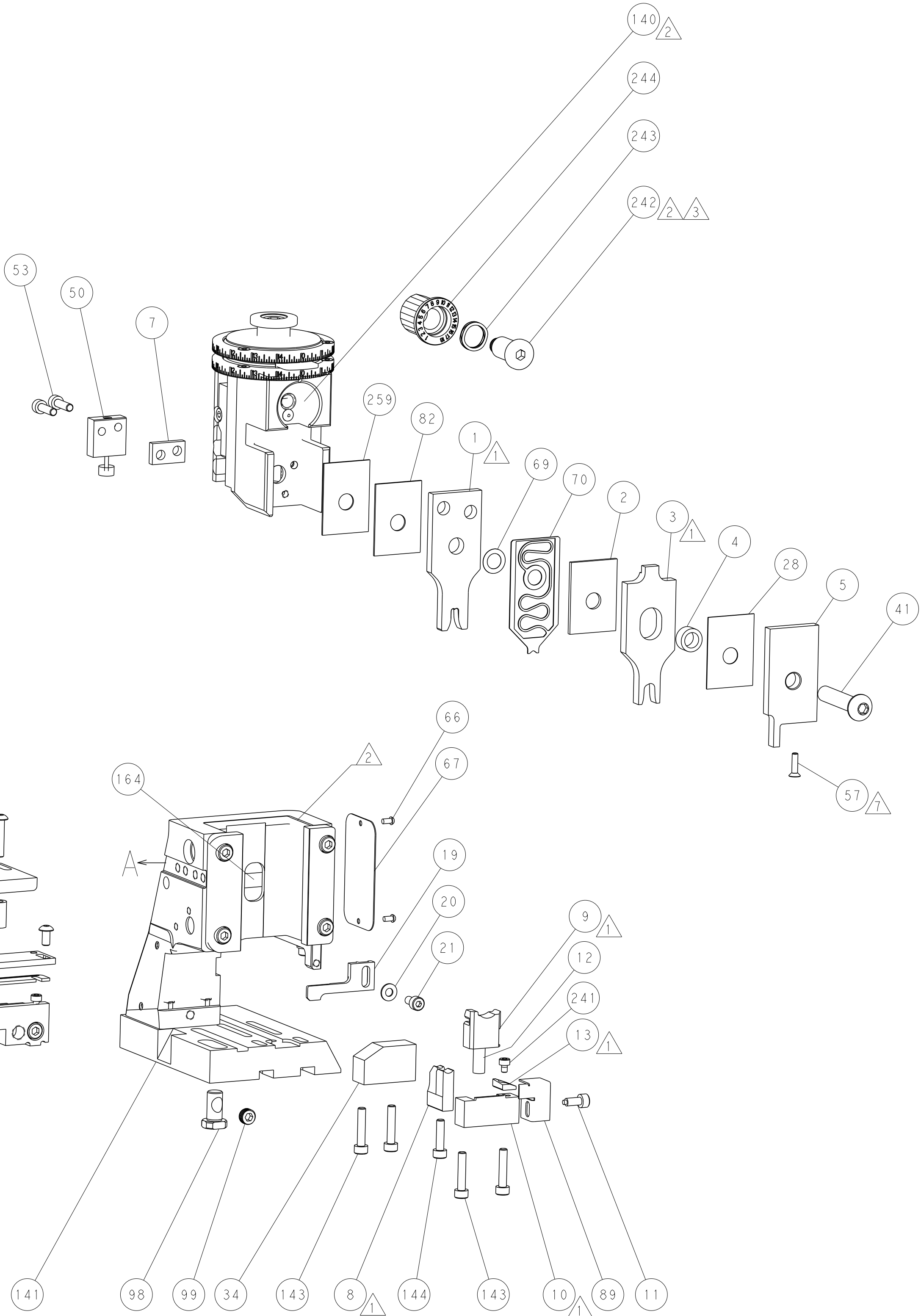
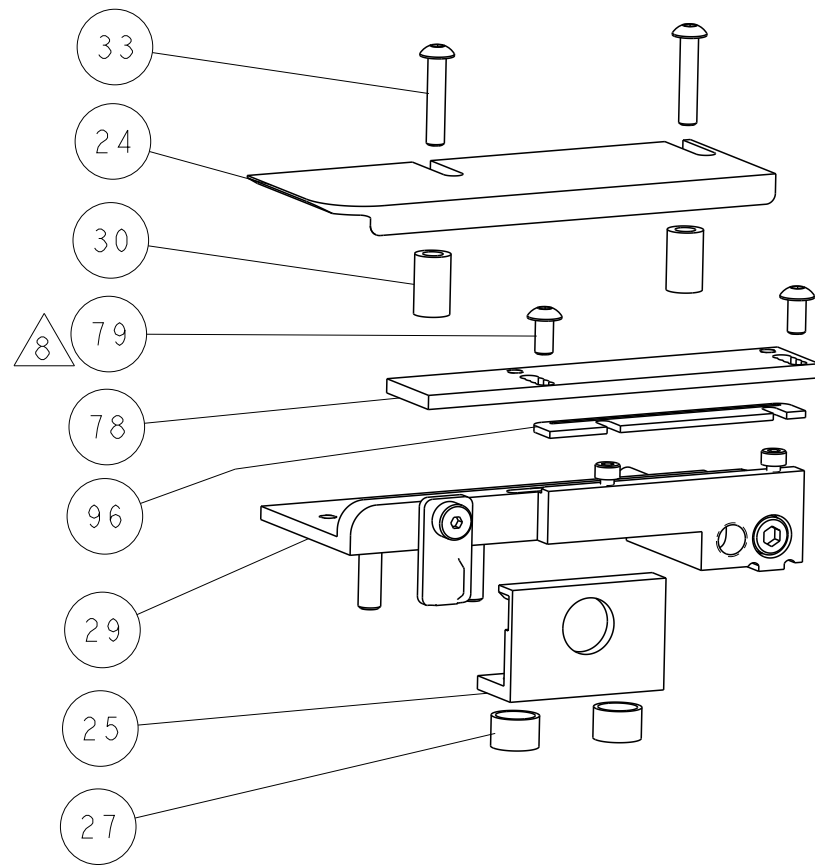
FEED TYPE
PNEUMATIC



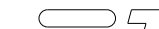
CAM POSITION



AIR FEED



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 TYCO ELECTRONICS CORPORATION (IT IS SUBJECT TO CHANGE WITHOUT NOTICE. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. WITHOUT PERMISSION IN WRITING FROM TYCO ELECTRONICS CORPORATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.)										DWN Y. YIN 14JAN2013		 TE Connectivity Harrisburg, PA 17105-3608									
										CHK G. BAILEY 14JAN2013											
										APVD S. XI 14JAN2013											
DIMENSIONS:										TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator -							
mm																					
										0 PLC ±											
										1 PLC ±											
										2 PLC ±											
										3 PLC ±											
4 PLC ±																					
ANGLES										±											
FINISH														SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
MATERIAL														A		00779		C=2151853			