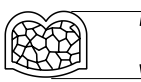


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151245-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151245-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151245-7	A	CRIMP TOOLING KIT	-

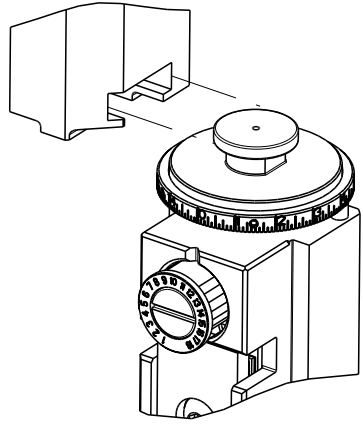
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.94 mm [.155]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD TIMER CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.20-4.80 mm [.165-.189 IN]			Ø2.40-3.70 mm [.094-.146 IN]
TERMINAL APPLICATION SPECIFICATION			
		(A)114-18079	-
		(B)114-18080	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 925595-1	(A) 925595-7	(B) 926006-1	(B) 964202-1
(A) 925595-2	(B) 925612-1	(B) 926006-2	(B) 964202-2
(A) 925595-3	(B) 925612-2	(B) 926006-3	(B) 964202-3
(A) 925595-4	(B) 925612-3	(B) 926973-1	(B) 964202-4
(A) 925595-5	(A) 925621-1	(B) 928805-3	
(A) 925595-6	(A) 925621-2	(B) 928805-5	
WIRE SIZE		CRIMP HEIGHT mm [INCH]	 CRIMP HEIGHT REFERENCE SETTING 
2.50mm2		1.70+/- .005 [.067+/- .002]	5.4
2.00mm2		1.58+/- .005 [.062+/- .002]	6.9
1.75mm2		1.52+/- .005 [.060+/- .002]	7.2
1.50mm2		1.45+/- .005 [.057+/- .002]	8.2
 1.25mm2		1.39+/- .005 [.055+/- .002]	8.7
 1.00mm2		1.32+/- .005 [.052+/- .002]	9.4



- 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 WIRE SIZES 1.25mm2 AND 1.00mm2 NOT COMPATIBLE WITH TERMINAL P/N 964202.
- 6 TERMINAL FEED NOT COMPATIBLE WITH MECHANICAL FEED.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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
			I	DEVELOPMENT			05SEP2012	L. Z	S. X
			A	RELEASED			03JAN2014	BH	GB
			A1	ECR-15-015347			200CT2015	YY	GB
			B	ECR-18-007947			23MAY2018	VLA	JDG

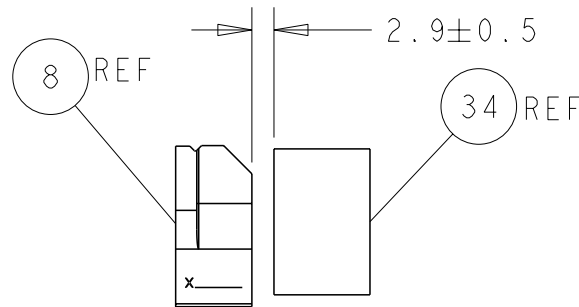
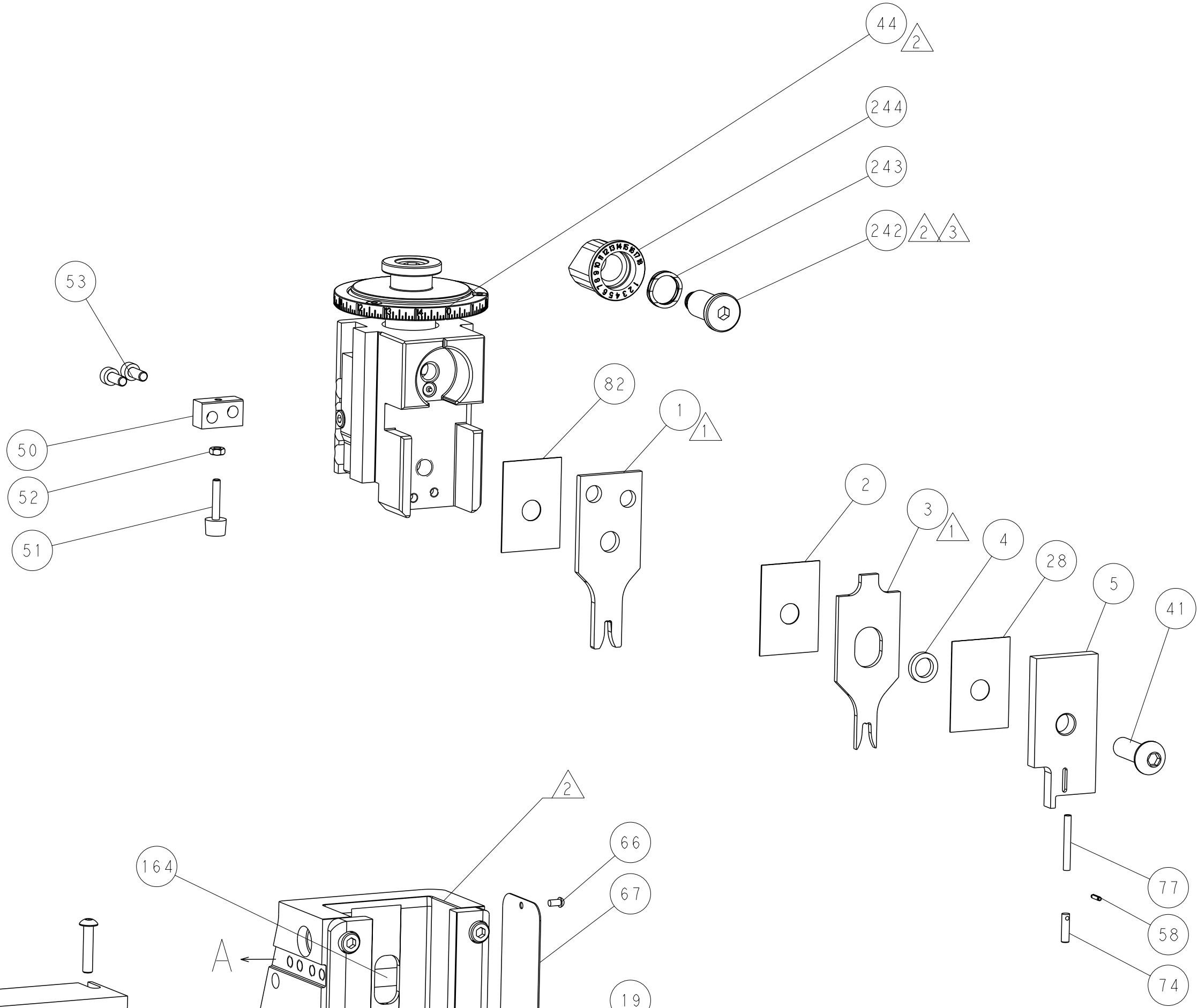
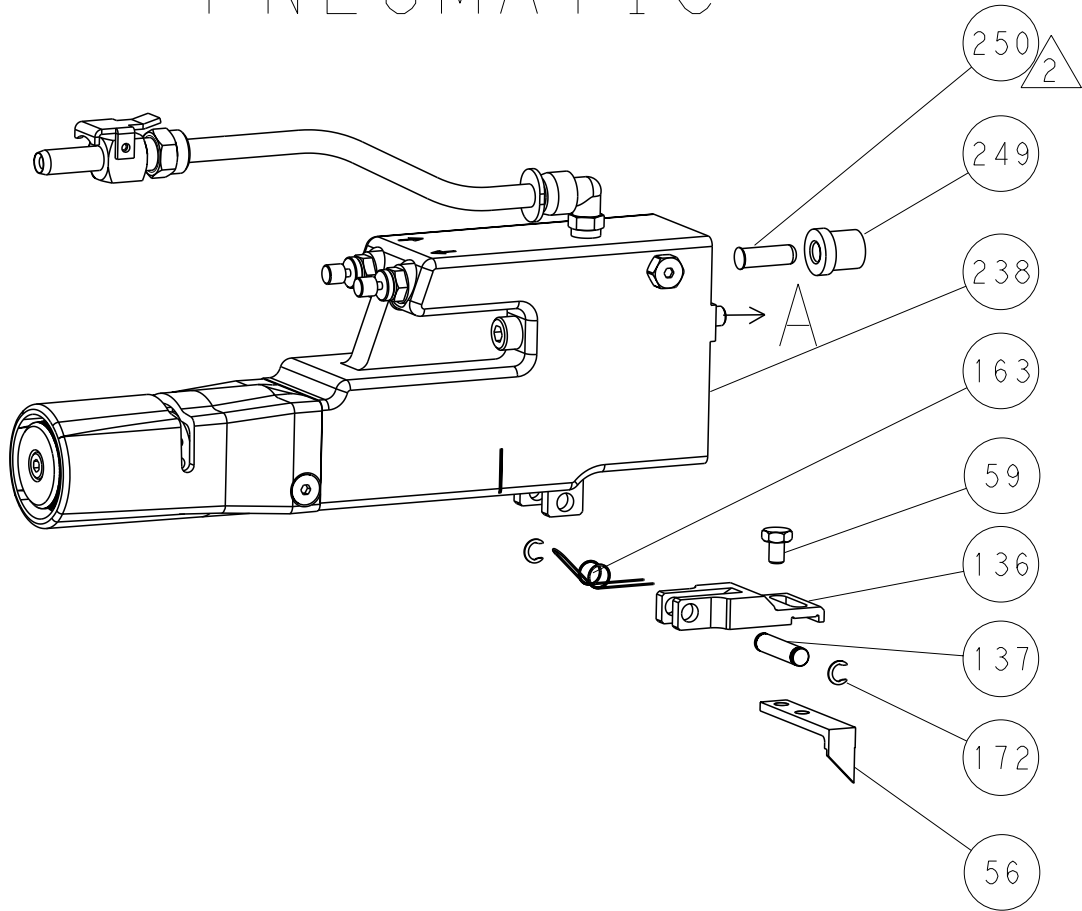
-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2063440-1	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	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
-	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
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	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	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	2119533-1	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	1803095-1	FLOATING SHEAR, FRONT	9
1	2	1	1333207-8	ANVIL, COMBINATION .110	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	2	1	2-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
1	2	1	456408-2	CRIMPER, WIRE PREMIUM	1

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 L. ZHANG 05SEP2012	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK L. ZHANG 05SEP2012	NAME Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD S. XI 05SEP2012	PRODUCT SPEC			
MATERIAL					APPLICATION SPEC			
					WEIGHT			
					CUSTOMER DRAWING			
					SCALE 1:2 SHEET 1 OF 4 REV B			

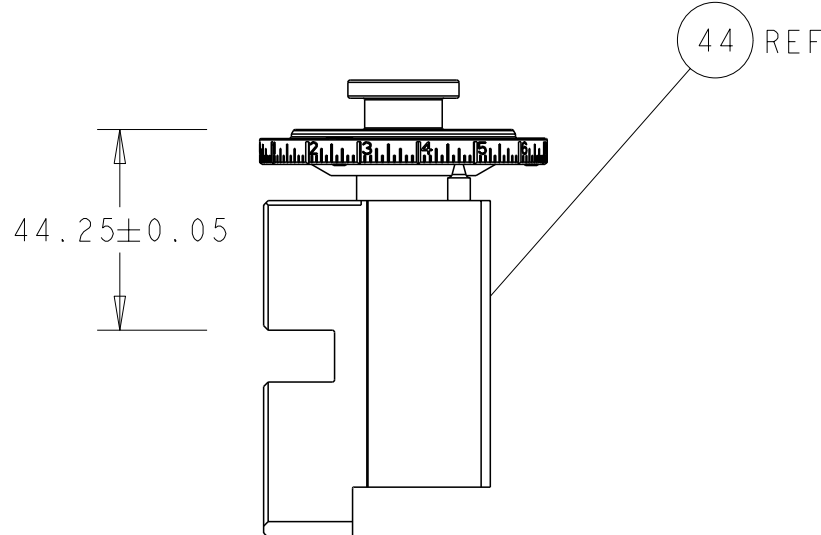
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

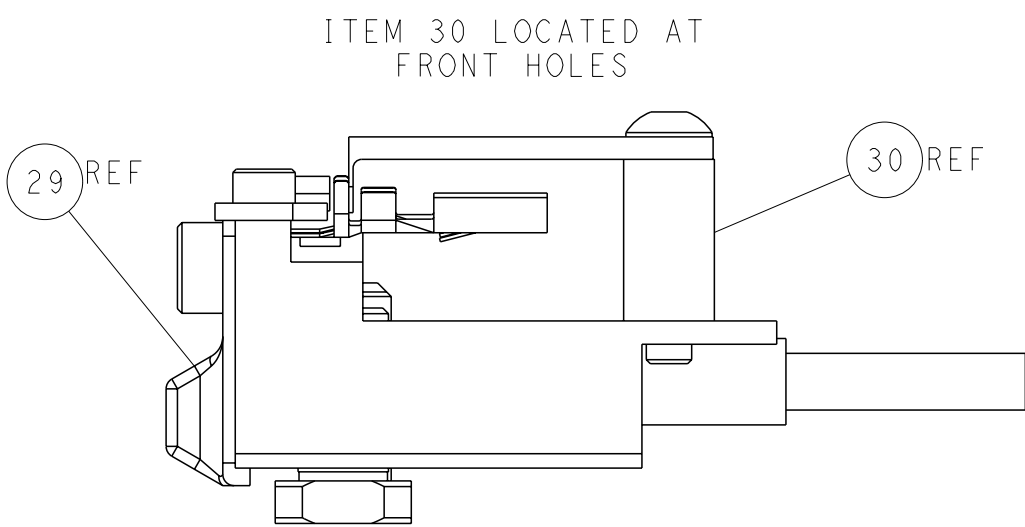
FEED TYPE
PNEUMATIC



TERMINAL SUPPORT LOCATION

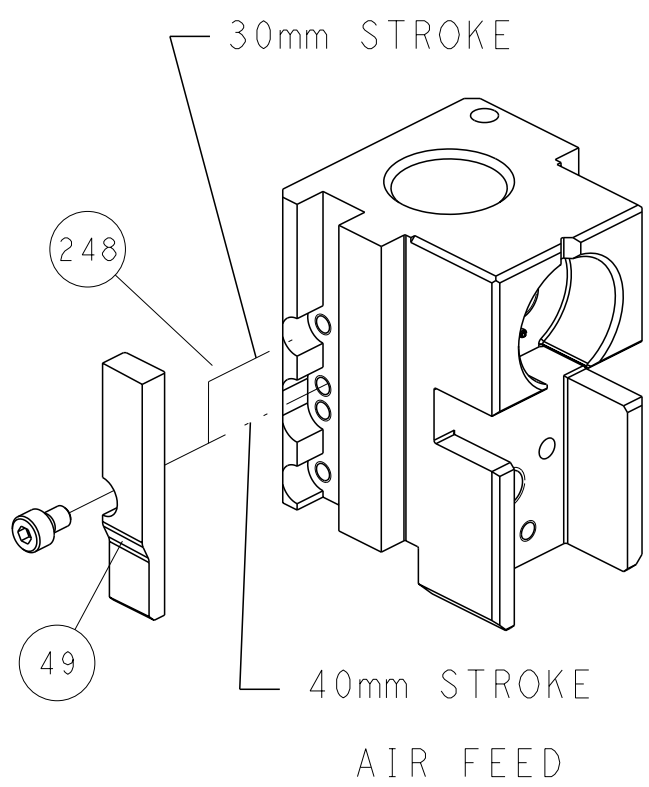


RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITION



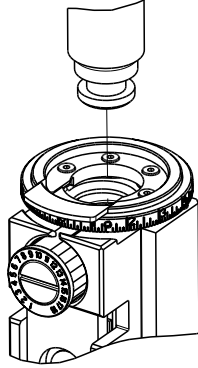
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CANCELLATION WITHOUT NOTICE SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN L. ZHANG 05SEP2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 05SEP2012		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD S. YI 05SEP2012	NAME Ocean Side Feed Applicator	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
		APPLICATION SPEC -	CAGE CODE DRAWING NO 00779 C=2151245	
		WEIGHT -	RESTRICTED TO -	
		CUSTOMER DRAWING	SCALE 1:2	
			SHEET 2 of 4	
			REV B	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151245-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151245-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.94 mm [.155]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD TIMER CONTACT			
WIRE STRIP LENGTH 4.20-4.80 mm [.165-.189 IN]		INSULATION DIAMETER RANGE Ø2.40-3.70 mm [.094-.146 IN]	
TERMINAL APPLICATION SPECIFICATION		(A)114-18079 - (B)114-18080 -	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 925595-1	(A) 925595-7	(B) 926006-1	(B) 964202-1
(A) 925595-2	(B) 925612-1	(B) 926006-2	(B) 964202-2
(A) 925595-3	(B) 925612-2	(B) 926006-3	(B) 964202-3
(A) 925595-4	(B) 925612-3	(B) 926973-1	(B) 964202-4
(A) 925595-5	(A) 925621-1	(B) 928805-3	
(A) 925595-6	(A) 925621-2	(B) 928805-5	
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
2.50mm2	1.70+/-0.05 [.067+/- .002]	5.4	
2.00mm2	1.58+/-0.05 [.062+/- .002]	6.9	
1.75mm2	1.52+/-0.05 [.060+/- .002]	7.2	
1.50mm2	1.45+/-0.05 [.057+/- .002]	8.2	
1.25mm2	1.39+/-0.05 [.055+/- .002]	8.7	
1.00mm2	1.32+/-0.05 [.052+/- .002]	9.4	



- 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 WIRE SIZES 1.25mm2 AND 1.00mm2 NOT COMPATIBLE WITH TERMINAL P/N 964202.
- 6 TERMINAL FEED NOT COMPATIBLE WITH MECHANICAL FEED.
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					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	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
3	-	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	2063440-1	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	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	455888-4	SPACER, CRIMPER	82
	-	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	854769-4	HOLDER, INS	74
	-	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	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
	-	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	1	1338685-1	PAWL, FEED	56
	-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	690753-2	SPACER, TONKER	50
	-	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	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	455888-3	SPACER, CRIMPER	28
	-	1	1320928-2	STRIP GUIDE	24
	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	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	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1803095-1	FLOATING SHEAR, FRONT -	9
	1	1	1333207-8	ANVIL, COMBINATION .110	8
	-	-	-	-	7
	-	-	-	-	6
	-	1	1-2119780-1	DEPRESSOR, SHEAR	5
	-	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	2-2119582-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-4	SPACER, CRIMPER	2
1	1	1	456408-2	CRIMPER, WIRE PREMIUM	1

3

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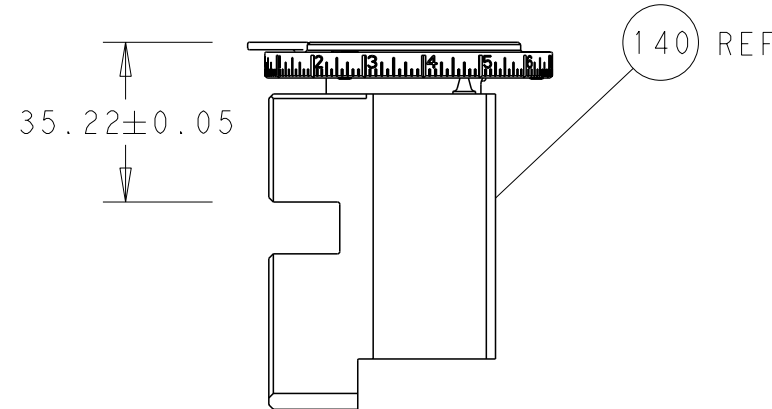
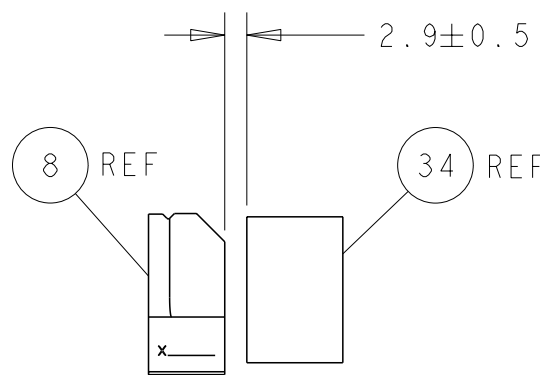
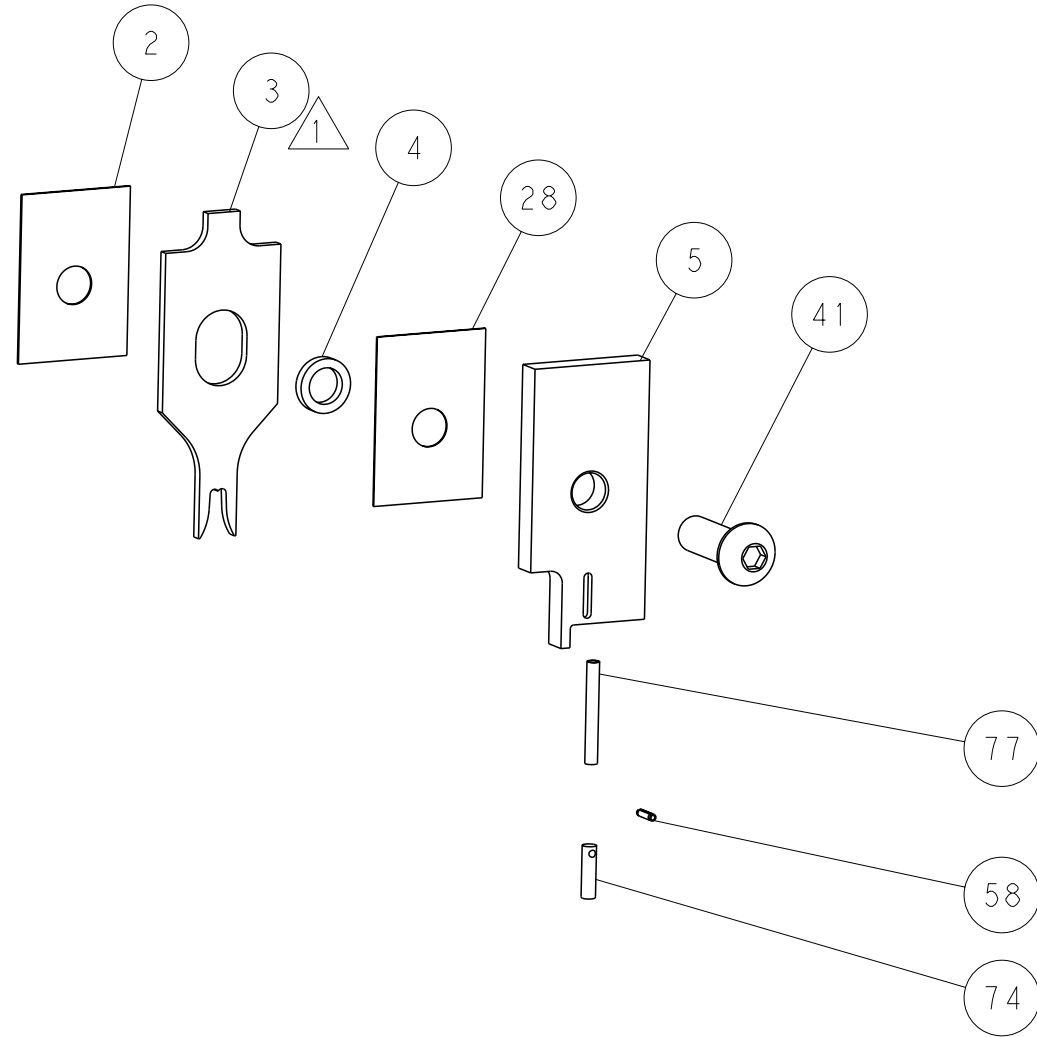
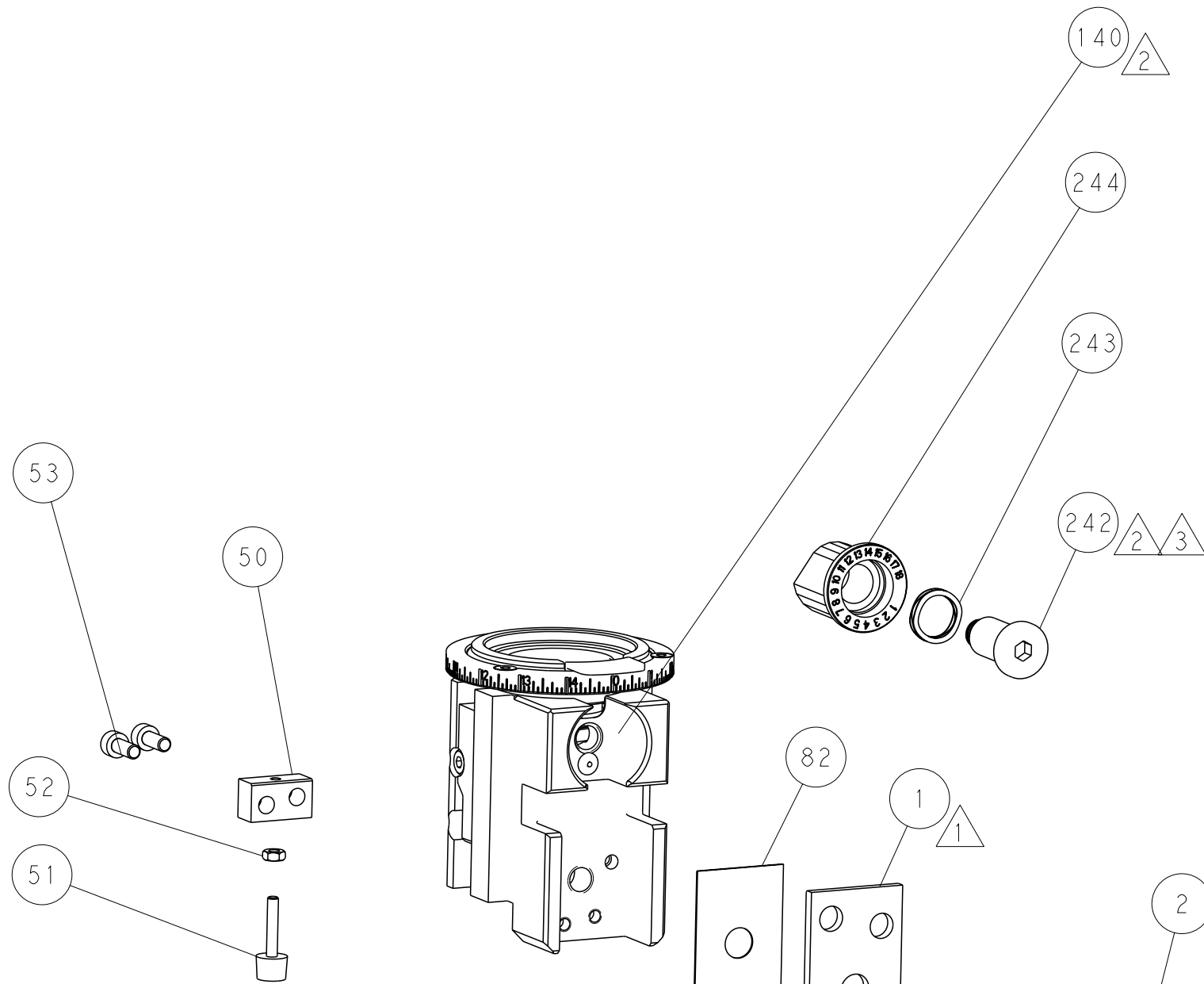
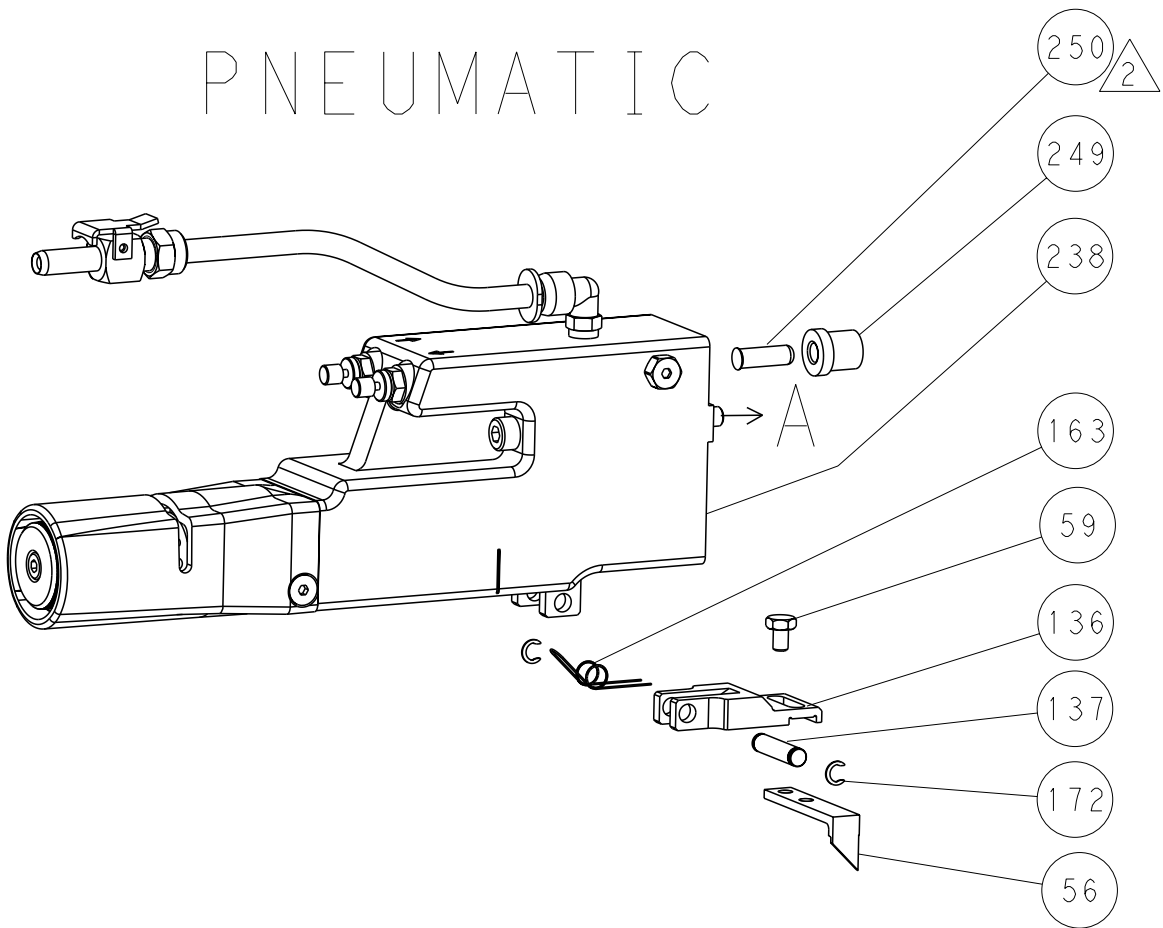
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SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

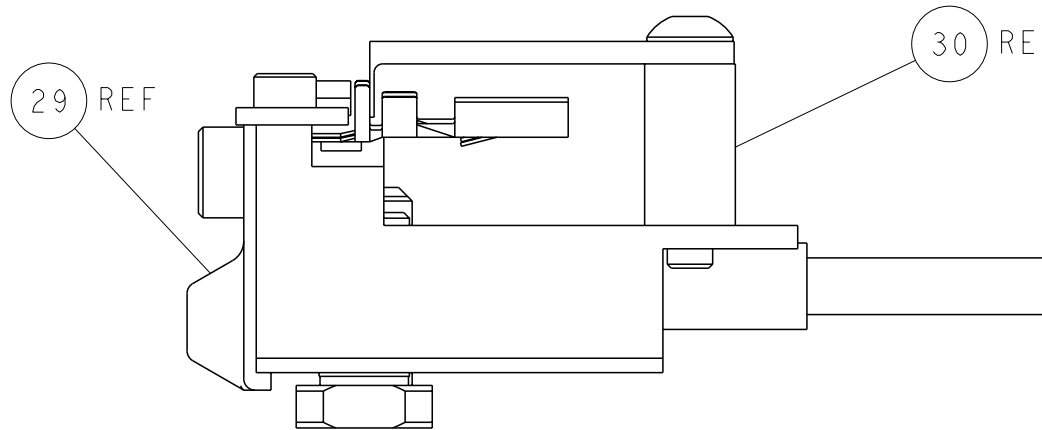
THIS DRAWING IS A CONTROLLED DOCUMENT FOR YOUR PROTECTION AND CONFIDENTIALITY. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN L. ZHANG 05SEP2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 05SEP2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD S. XI 05SEP2012	PRODUCT SPEC	
MATERIAL -		FINISH -	APPLICATION SPEC	
-		WEIGHT -	SIZE A1	
-		CUSTOMER DRAWING	SCALE 1:2	
-		REV B	SHEET 3	
-		OF 4	REV B	

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

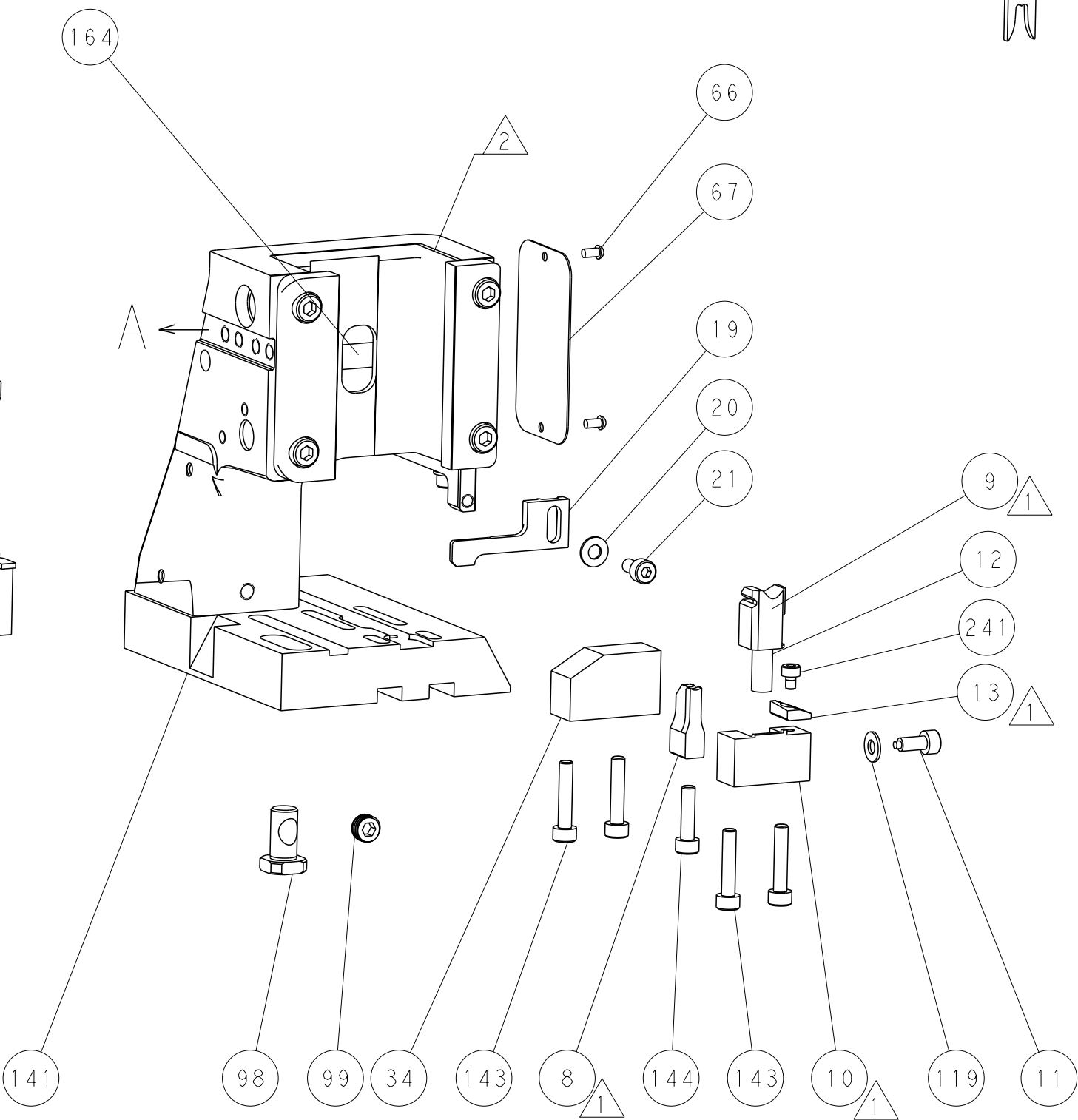
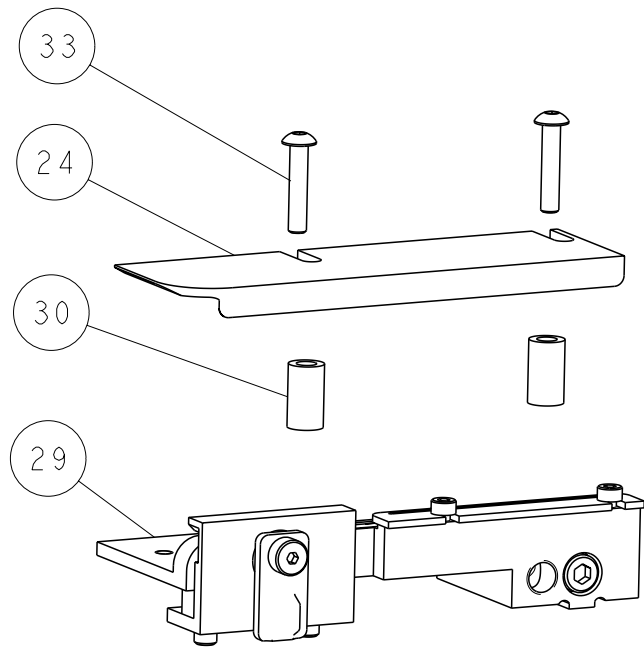
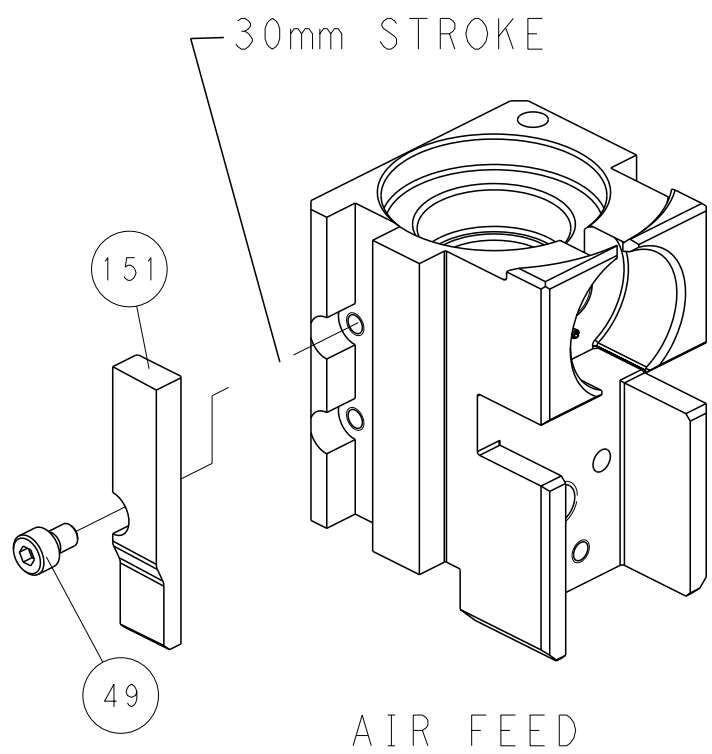
FEED TYPE
PNEUMATIC



ITEM 30 LOCATED AT
FRONT HOLES



CAM POSITION



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 AND TO CONTROL AND ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	L. ZHANG	05SEP2012	 TE Connectivity Harrisburg, PA 17105-3608		
				CHK	L. ZHANG	05SEP2012			
				APVD	S. YI	05SEP2012	NAME		
				PRODUCT SPEC			Ocean Side Feed Applicator		
				APPLICATION SPEC					
				WEIGHT			SIZE		
				CUSTOMER DRAWING			CAGE CODE		
							DRAWING NO		
							RESTRICTED TO		
							SCALE		
							SHEET		
							OF		
							REV		
							B		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION