

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151268-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151268-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151268-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151268-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151268-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.94 mm [.155]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR POWER TIMER CONTACT			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.90-4.50 mm [.154-.177 IN]		∅ 3.40 mm MAX [.134 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18050		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
929941-1	929941-3	828904-1	828904-2	1.2- 2.1mm
929941-6	929941-7	828904-3		1.2- 2.1mm
1-929941-1	2-929941-1			
927772-1	927772-3			
1-927772-1				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.12 +/- 0.03 [.044 +/- .001]	5.0
0.35mm2	1.05 +/- 0.03 [.041 +/- .001]	5.9
0.25mm2	1.00 +/- 0.03 [.039 +/- .001]	6.4
0.2mm2 or 0.22mm2	0.98 +/- 0.03 [.039 +/- .001]	6.7

- 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 APPLY TORO-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.
- 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.

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					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASE	24APR2012	XZ	SX
		B		ECR-13-006390	15APR2013	BH	BH
		C		ECR-18-005882	03MAY2018	FZ	KZ
		D		ECR-20-016359	17NOV2020	TB	RK

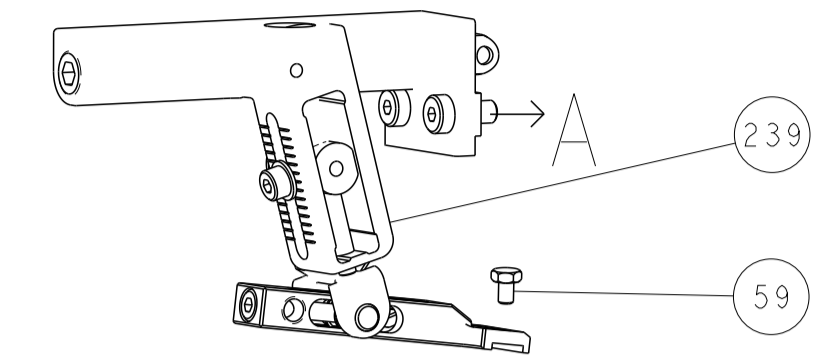
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	2119740-1	TAG IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1333202-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	2	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

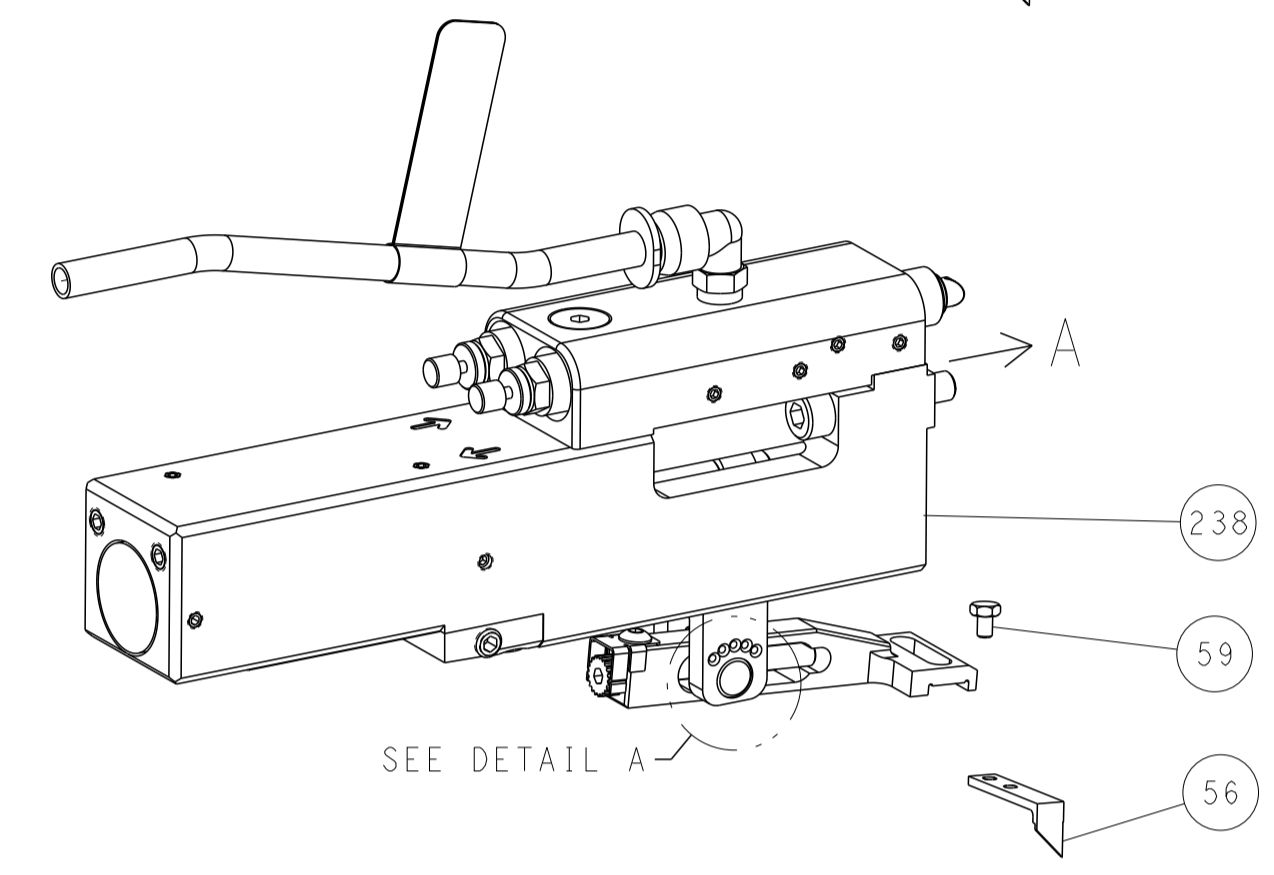
OWN	X. ZHAO	07MAR2012
CHK	T. ELBIN	07MAR2012
APVD	S. XI	07MAR2012
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151268
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	D	

LOC	DIST	REV	DESCRIPTION	DATE	DWN	APVD
A	66	-	SEE SHEET 1	-	-	-

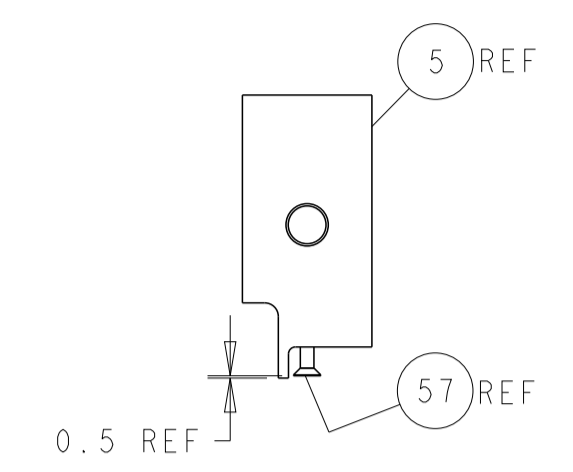
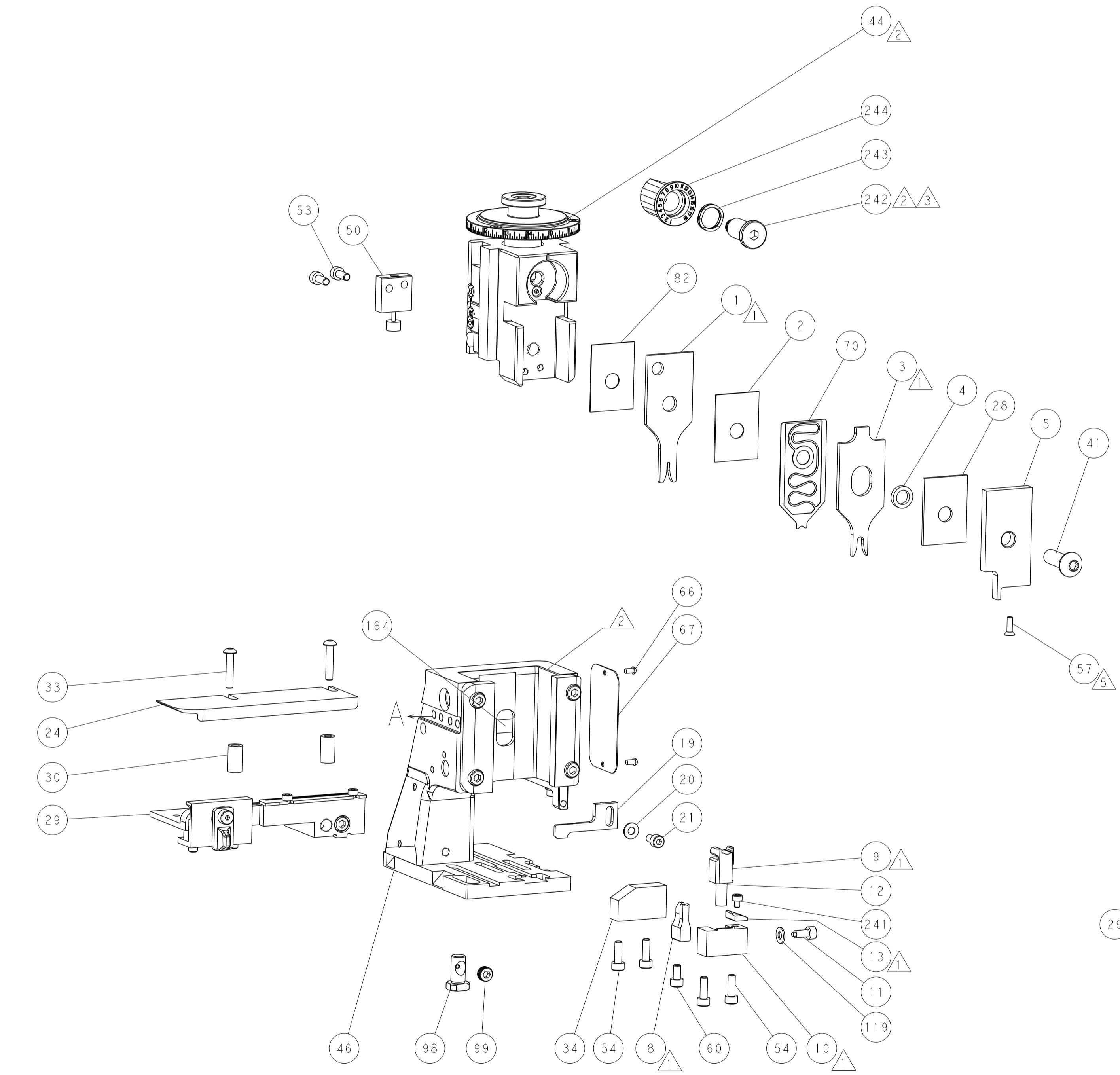
FEED TYPE MECHANICAL



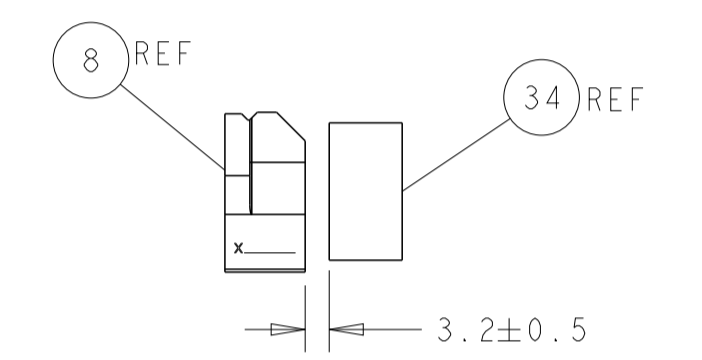
PNEUMATIC



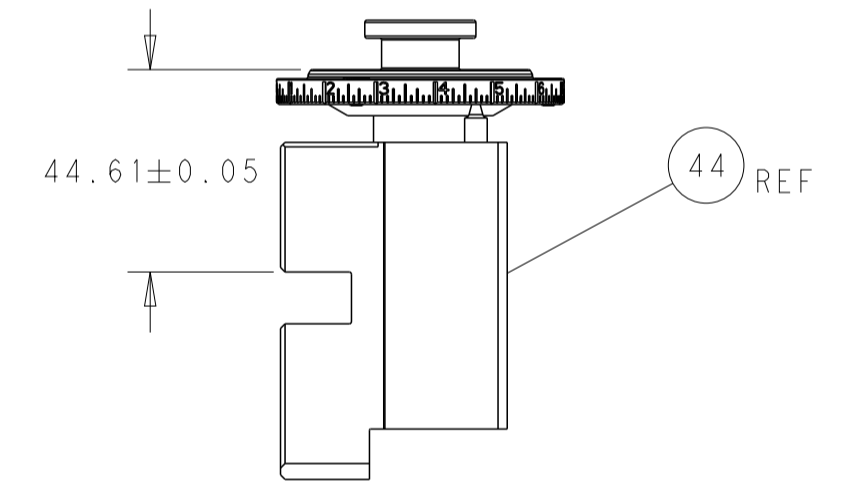
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



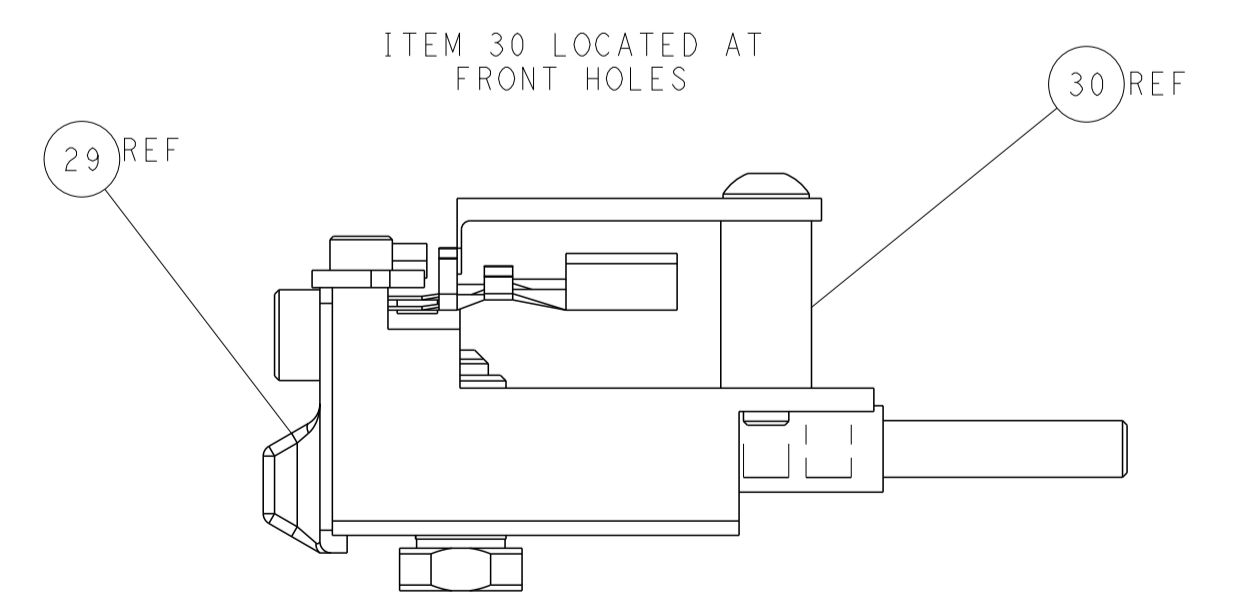
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

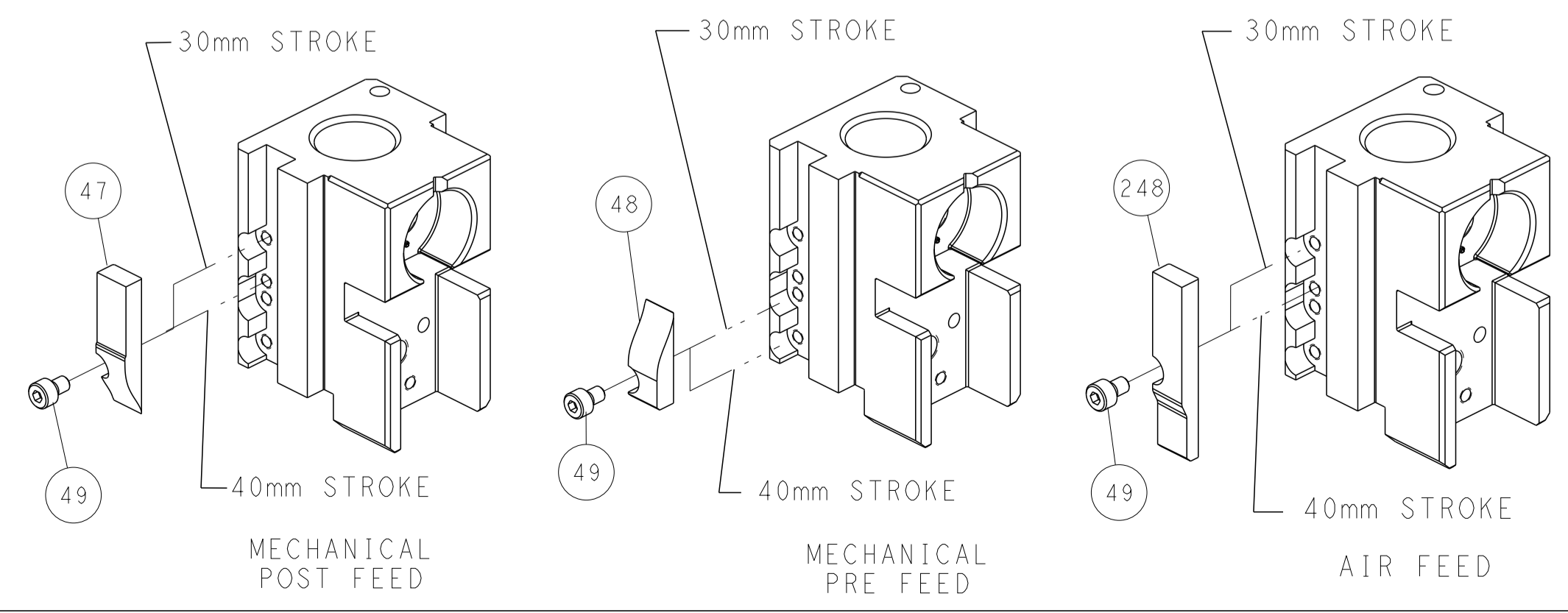


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN X.ZHAO 07MAR2012 CHK T.ELBIN 07MAR2012 APVD S.XI 07MAR2012 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2151268 RESTRICTED TO SHEET 2 OF 4 REV D
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151268-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151268-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151268-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.94 mm [.155]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION
TERMINAL NAME: JUNIOR POWER TIMER CONTACT

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
3.90-4.50 mm [.154-.177 IN]	3.40 mm MAX [.134 IN]

TERMINAL APPLICATION SPECIFICATION	114-18050

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
929941-1	929941-3	828904-1	828904-2	1.2- 2.1mm
929941-6	929941-7	828904-3		1.2- 2.1mm
1-929941-1	2-929941-1			
927772-1	927772-3			
1-927772-1				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.12 +/- 0.03 [.044 +/- .001]	5.0
0.35mm2	1.05 +/- 0.03 [.041 +/- .001]	5.9
0.25mm2	1.00 +/- 0.03 [.039 +/- .001]	6.4
0.2mm2 or 0.22mm2	0.98 +/- 0.03 [.039 +/- .001]	6.7



- 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 APPLY TORO-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.
- 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	REV	DATE	BY	CHKD	APVD
A	66	-				

REV	DATE	DESCRIPTION	DATE	BY	CHKD	APVD
-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	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	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC		140
-	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	455888-5	SPACER, CRIMPER		82
-	1	1	1803607-3	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
5	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED		56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED		50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	1	1	1-1752356-6	SUPPORT, TERMINAL		34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE		29
-	1	1	1-455888-6	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1	1-356885-4	STOP, SHEAR		11
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1333202-9	ANVIL, COMBINATION	8
-	-	-	-	-		7
-	-	-	-	-		6
-	1	1	2119781-1	DEPRESSOR, SHEAR		5
-	1	1	238011-4	BLOCK, CRIMPER SPACER		4
1	1	1	2-2119784-9	CRIMPER, INSULATION O PREMIUM		3
-	1	1	455888-7	SPACER, CRIMPER		2
1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM		1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

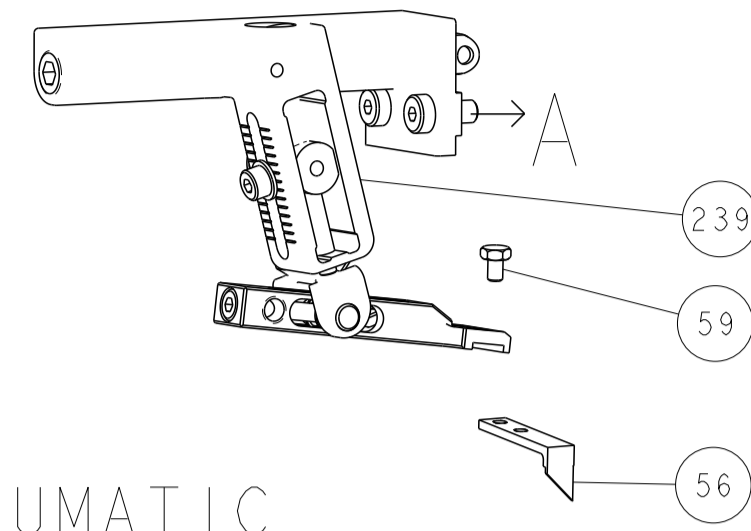
DATE	07MAR2012	CHKD	X. ZHAO
DATE	07MAR2012	CHKD	T. ELBIN
DATE	07MAR2012	CHKD	S. XI

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151268	

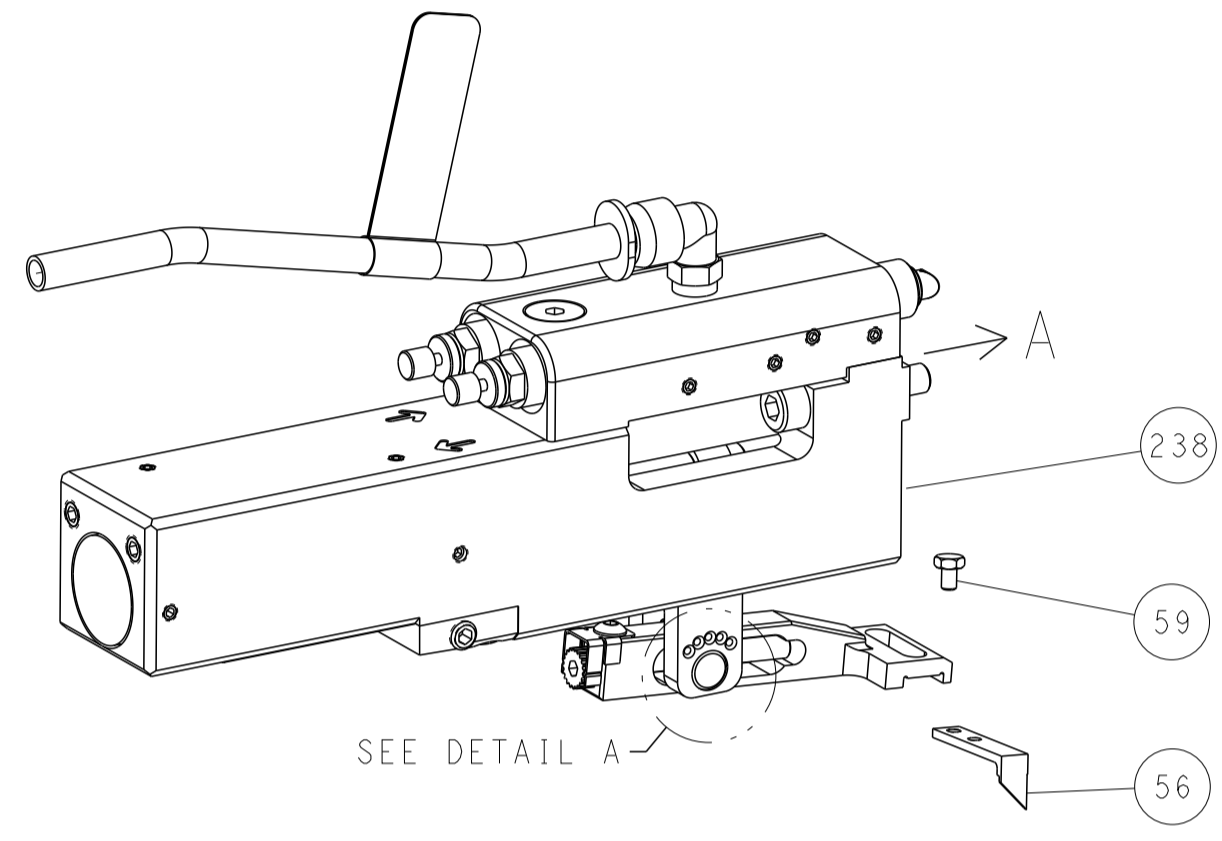
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV D

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

FEED TYPE MECHANICAL



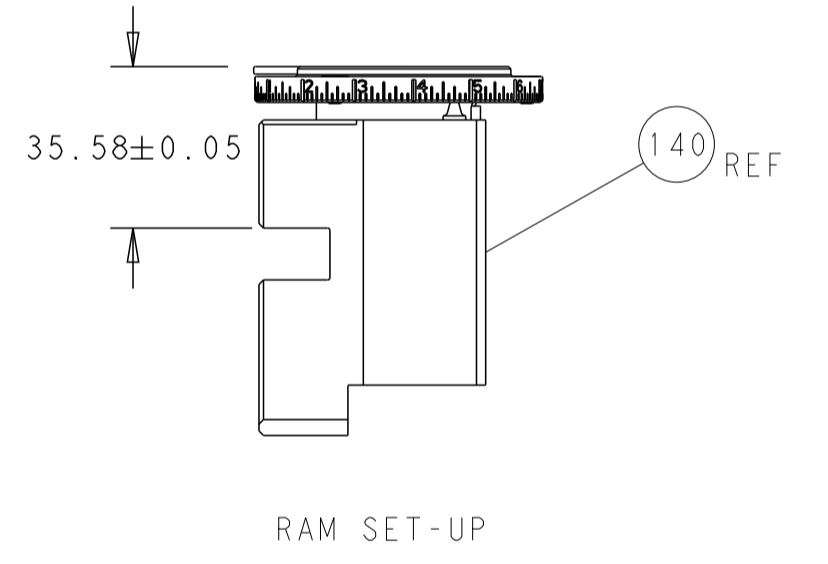
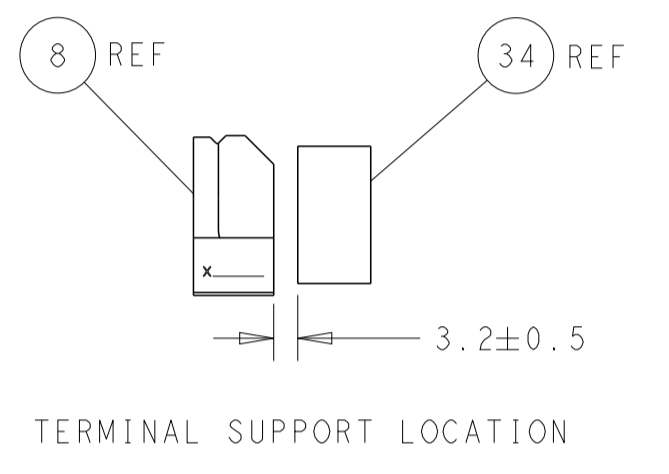
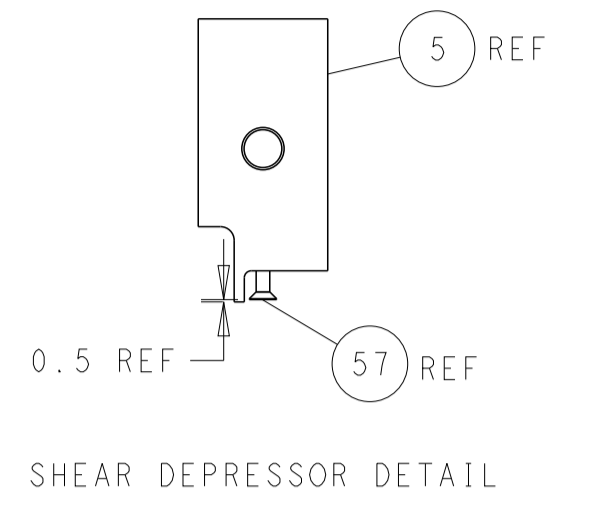
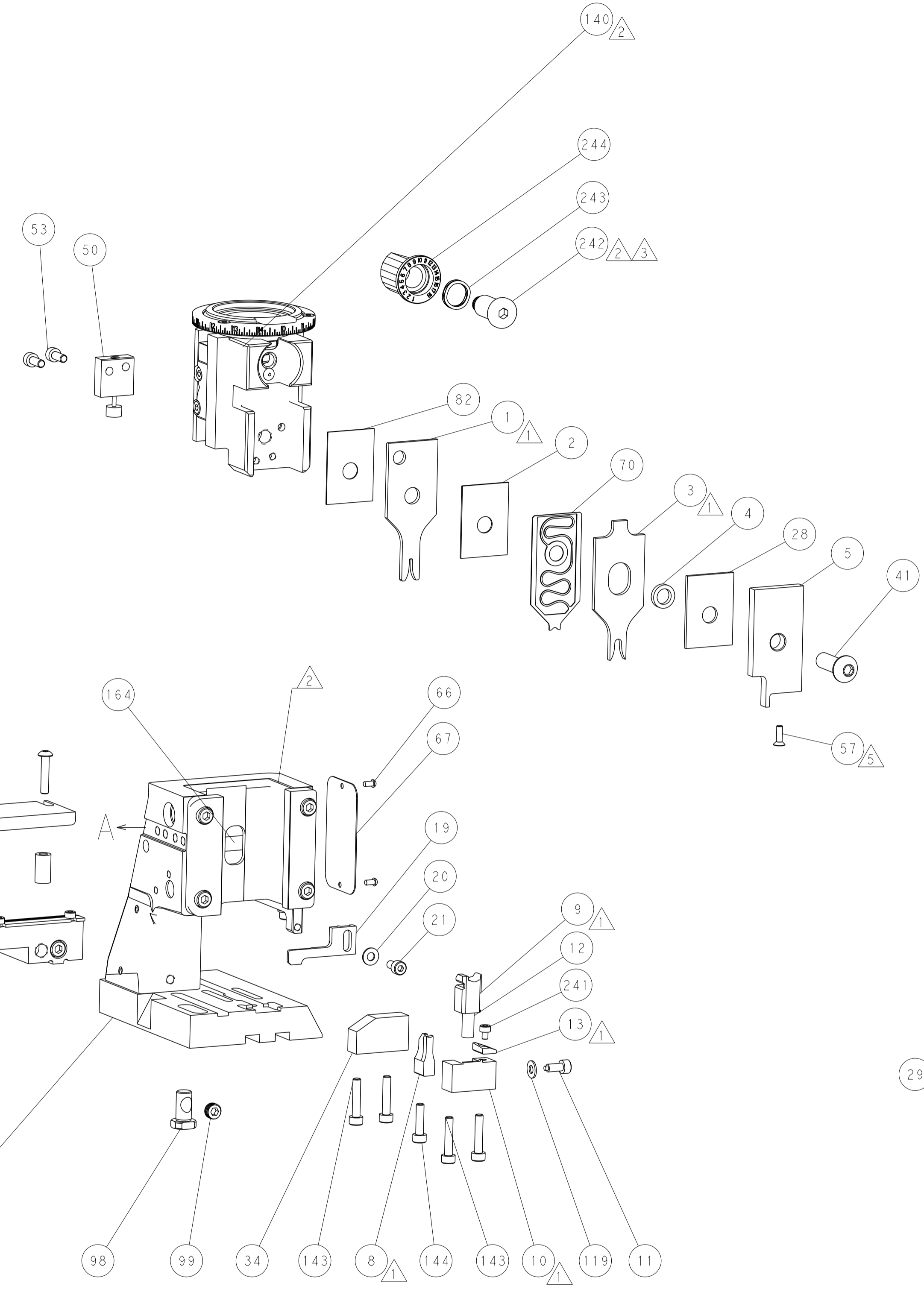
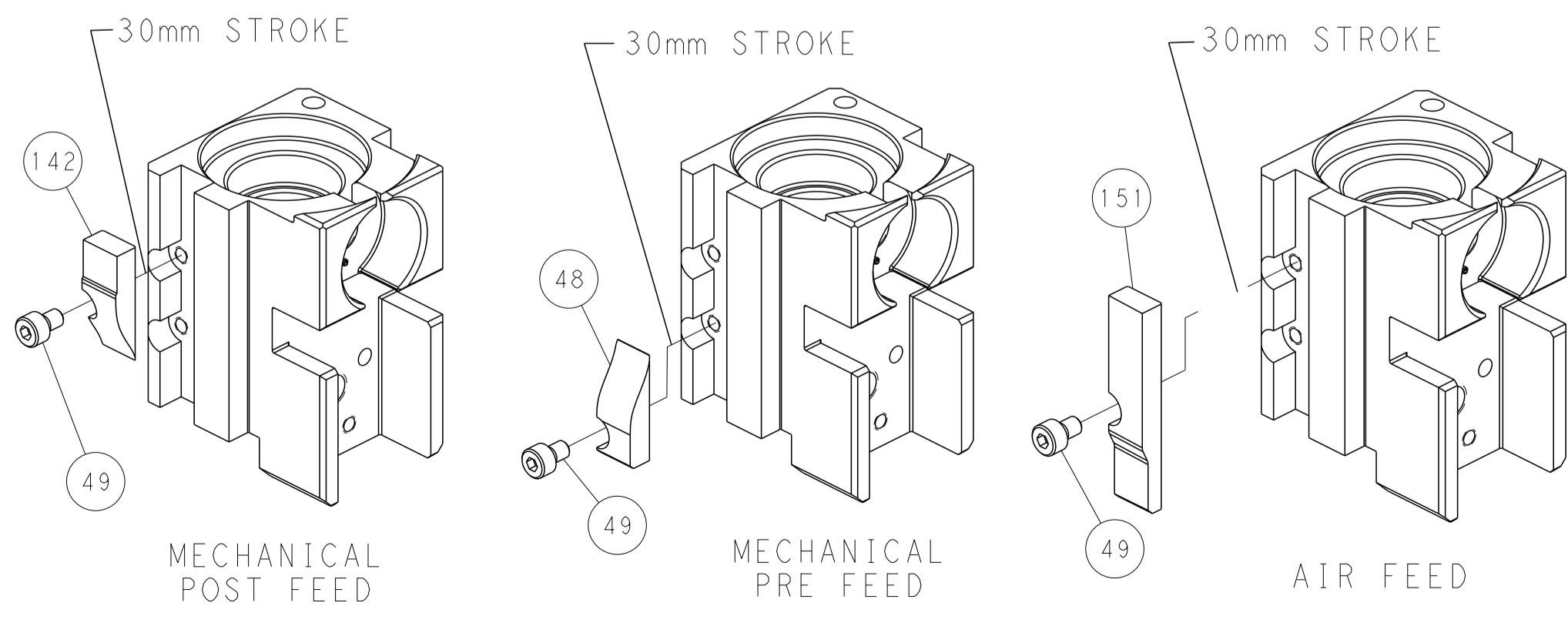
PNEUMATIC



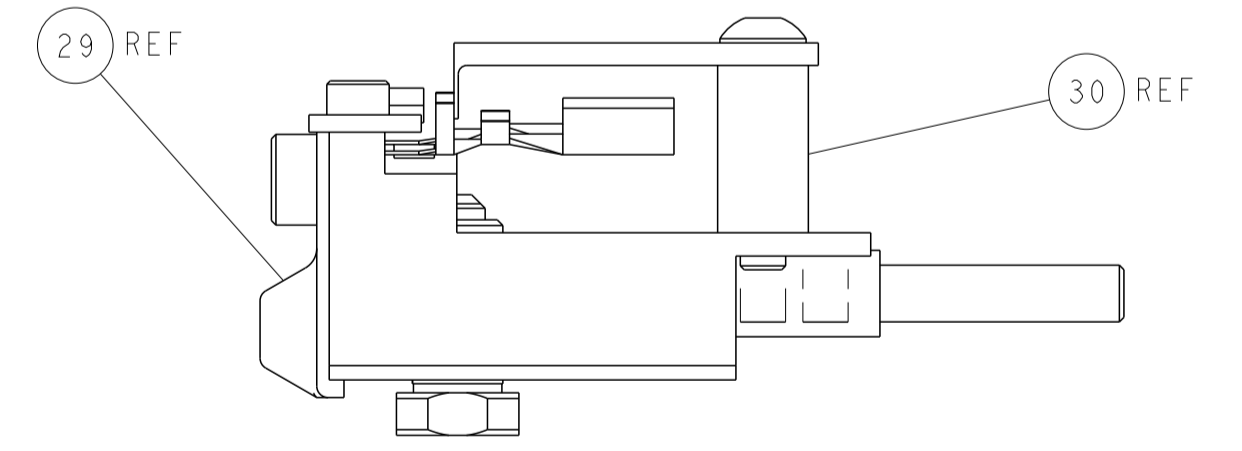
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



ITEM 30 LOCATED AT FRONT HOLES



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN X.ZHAO 07MAR2012 CHK T.ELBIN 07MAR2012 APVD S.XI 07MAR2012 PRODUCT SPEC APPLICATION SPEC		NAME Ocean Side Feed Applicator	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151268		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 4 OF 4 REV D	