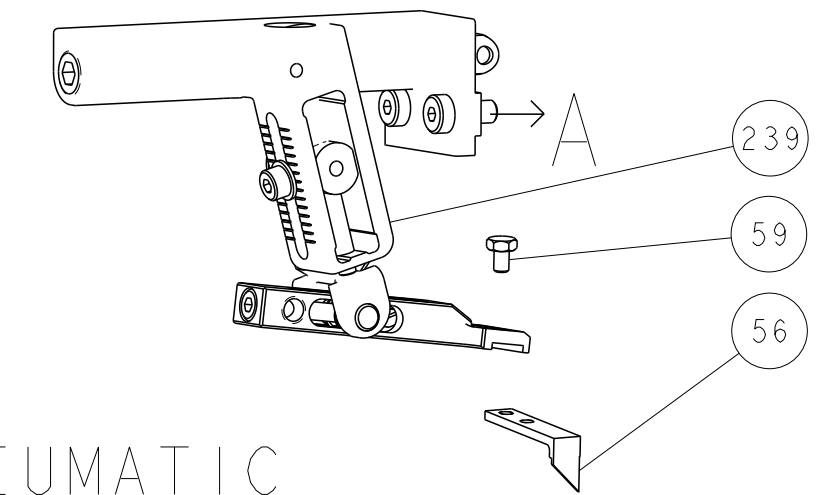


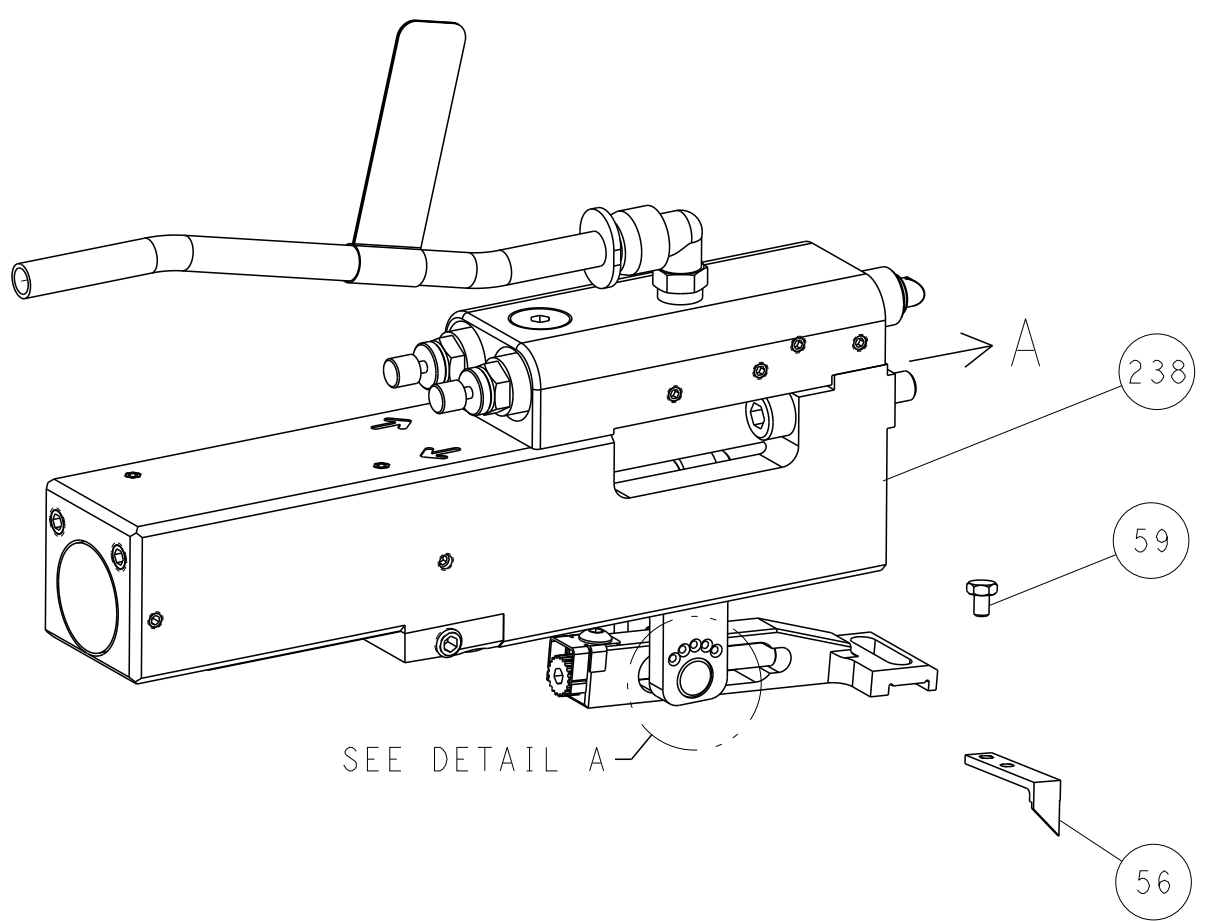


| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
| A   | 66   | P         | LYN | DESCRIPTION | DATE | DWN | APVD |
|     |      | -         |     | SEE SHEET 1 | -    | -   | -    |

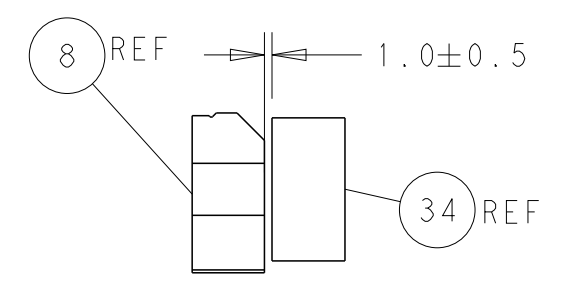
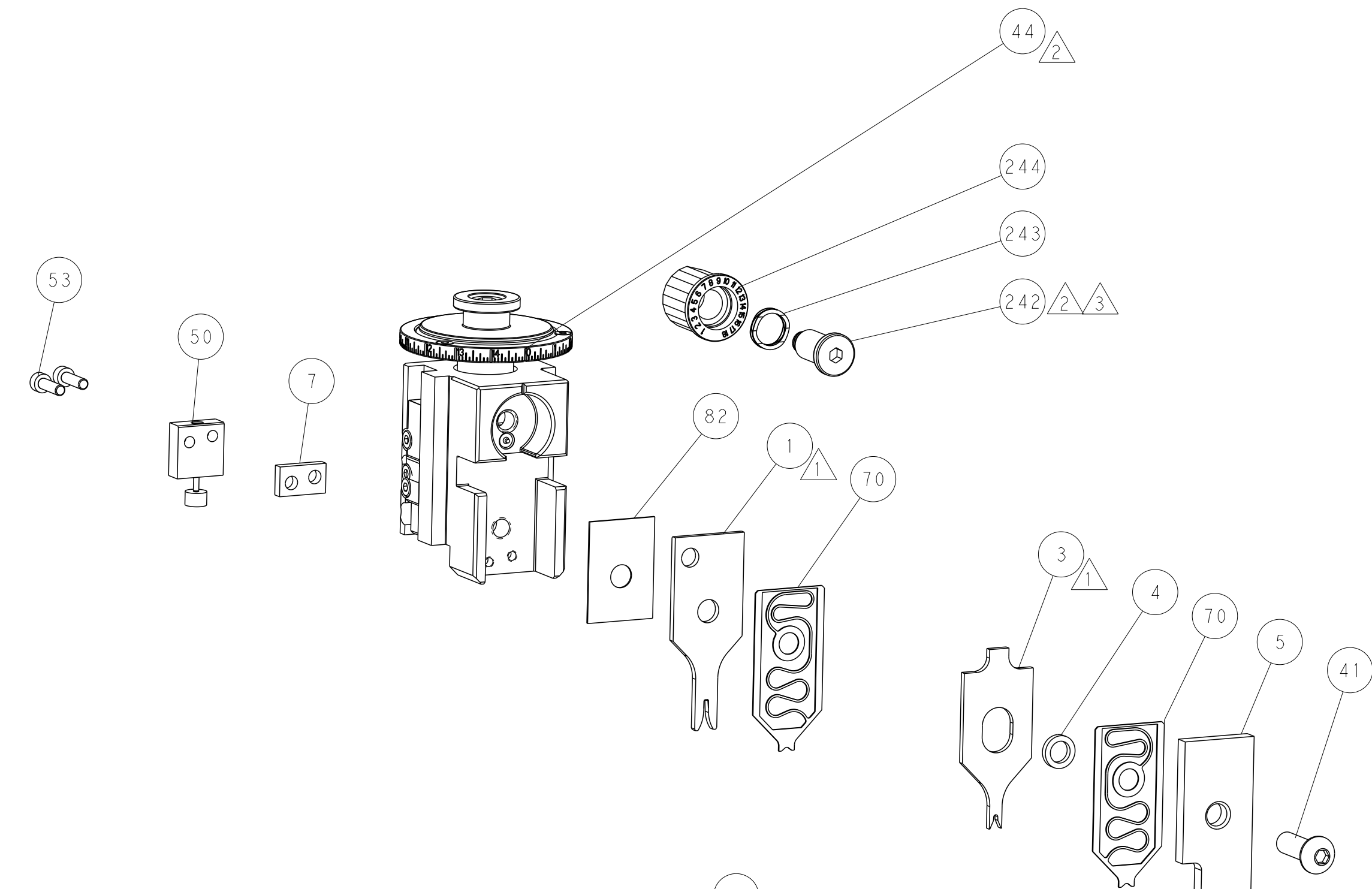
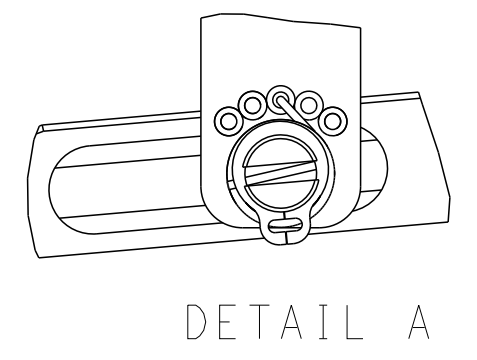
# FEED TYPE MECHANICAL



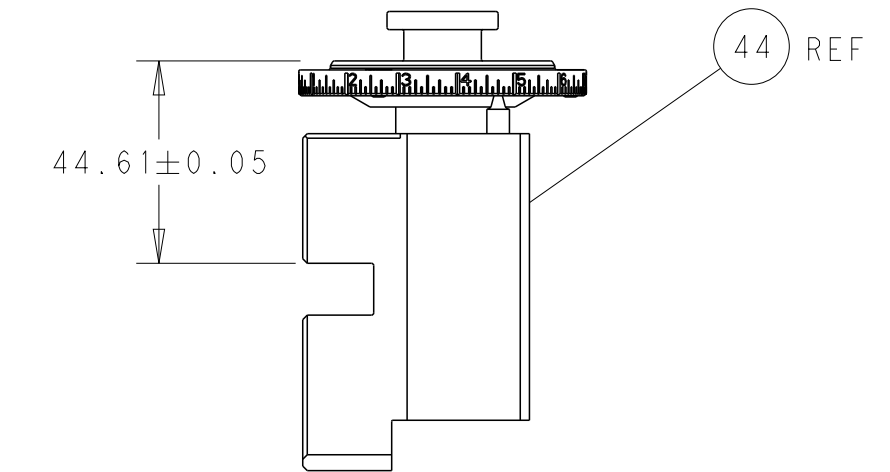
## PNEUMATIC



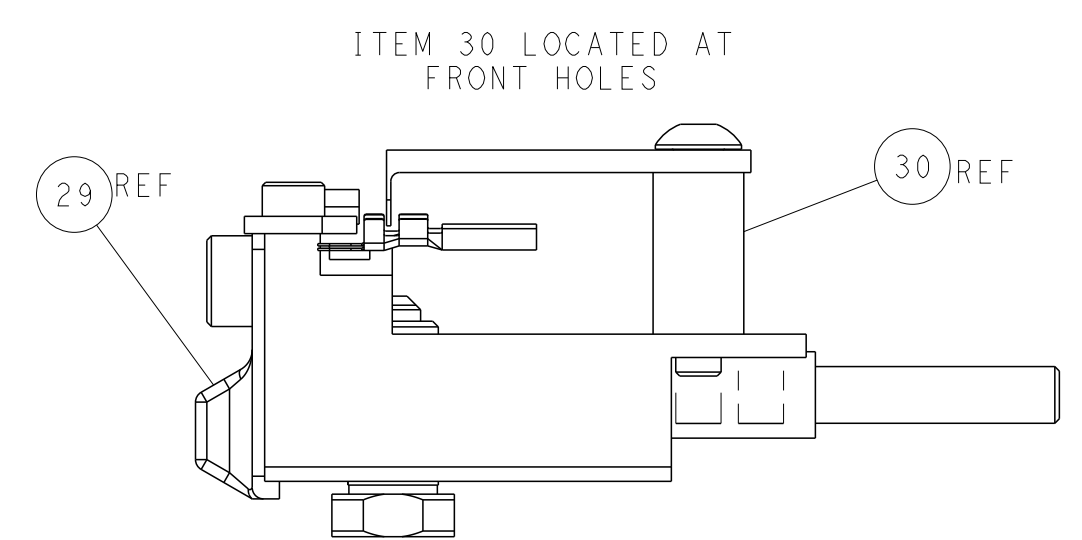
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

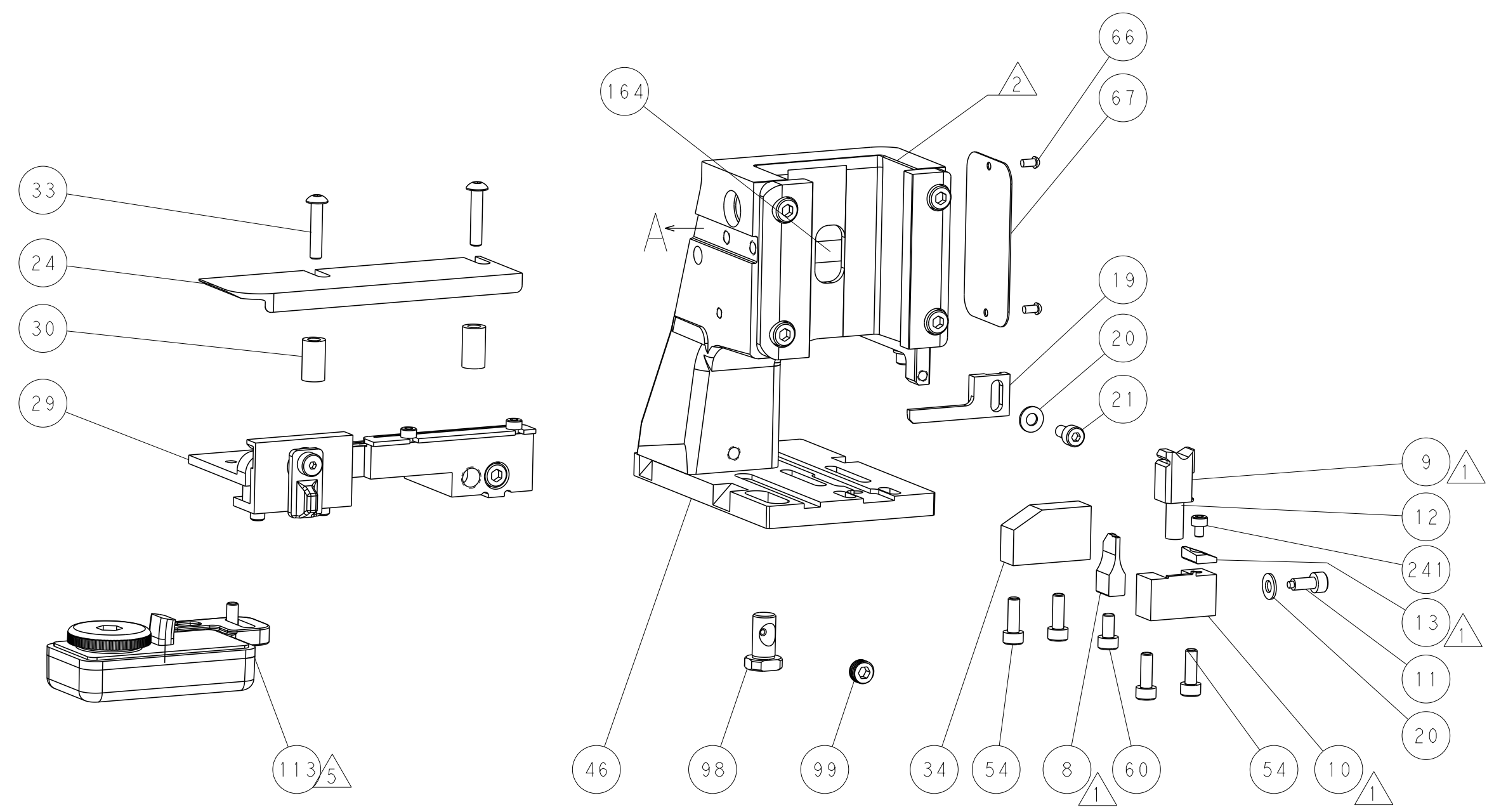
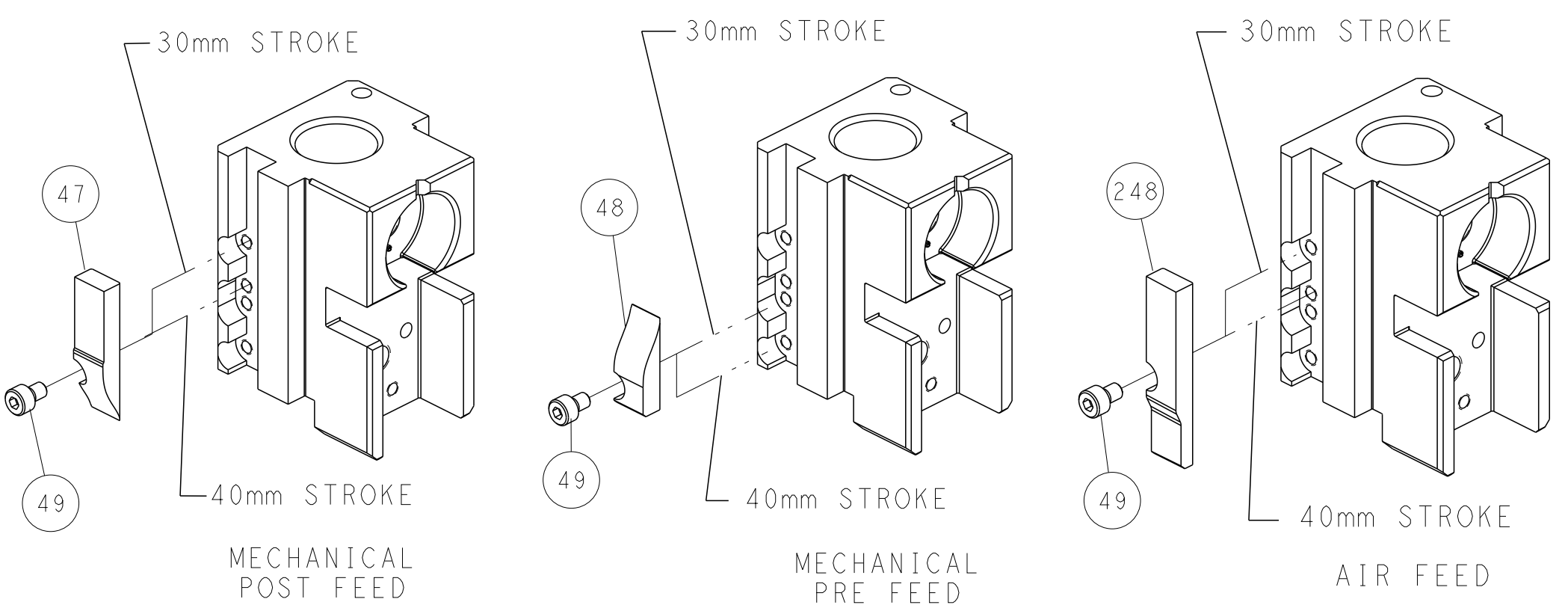


RAM SET-UP



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: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DWN<br>T. YIN<br>09AUG2012             |         | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                                | 4 PLC ± | NAME<br>Ocean Side Feed Applicator           |  |
| MATERIAL:   |         | FINISH:                                |         | APVD<br>S. XI<br>09AUG2012             |         | RESTRICTED TO                                |  |
|             |         |  |         | PRODUCT SPEC                           |         | SIZE<br>A1                                   |  |
|             |         |  |         | APPLICATION SPEC                       |         | CAGE CODE<br>00779                           |  |
|             |         |  |         | WEIGHT                                 |         | DRAWING NO<br>C=2151359                      |  |
|             |         |  |         | CUSTOMER ACCESSIBLE PRODUCTION DRAWING |         | SCALE<br>1:2                                 |  |
|             |         |  |         |  |         | SHEET<br>2 OF 4                              |  |
|             |         |  |         |  |         | REV<br>D                                     |  |

| PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE  |
|-------------|----------|--------------------------|------------|
| 2-2151359-1 | D        | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151359-2 | D        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC  |
| 7-2151359-7 | A        | CRIMP TOOLING KIT        | -          |

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.60 mm [.063] | F    |
| INSUL                                | 1.70 mm [.067] | O    |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                |      |

| TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION        |                               |             |                |
|--|-------------------------------|-------------|----------------|
| TERMINAL NAME: AUTOMOTIVE CONNECTOR                            |                               |             |                |
| WIRE STRIP LENGTH  | INSULATION DIAMETER RANGE     |             |                |
| 3.20-3.80 mm [1.26-.150 IN]                                    | ∅1.35-1.80 mm [0.053-.071 IN] |             |                |
| TERMINAL APPLICATION SPECIFICATION MOLEX SPEC 639022000, Rev B |                               |             |                |
| TERMINALS APPLIED  |                               |             |                |
| TE TERMINAL  | MOLEX TERMINAL                | TE TERMINAL | MOLEX TERMINAL |
| 1949356-1  | 98913-1029                    | 1949356-5   | 64322-1029     |
| 1949356-2  | 98913-1219                    | 1949356-6   | 64322-1219     |
| 1949356-3  | 98913-1319                    | 1949356-7   | 64322-1319     |
| 1949356-4  | 98913-1339                    | 1949356-8   | 64322-1339     |
|  |                               | 1949356-9   | 98913-3029     |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.75mm2   | 1.05 +/- 0.05 [.041 +/- .002] | 7.3                            |
| 0.60mm2   | 1.03 +/- 0.05 [.041 +/- .002] | 7.5                            |
| 0.50mm2   | 1.00 +/- 0.05 [.039 +/- .002] | 7.7                            |

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
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.

| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
| A   | 66   | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
|     |      | -         | -   | SEE SHEET 1 | -    | -   | -    |

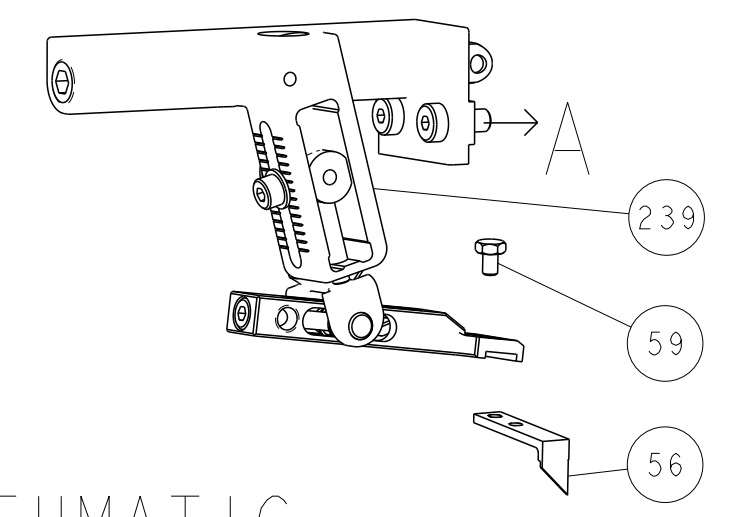
|   |     |     |             |                                     |                             |     |
|---|-----|-----|-------------|-------------------------------------|-----------------------------|-----|
| - | 1   | 1   | 2119082-5   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244                         |     |
| - | 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   | 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   | 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                         |     |
| 5 | -   | 1   | 1           | 2119955-1                           | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 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                          |     |
| - | 2   | 2   | 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                          |     |
| - | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56                          |     |
| - | 2   | 2   | 2-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 14      | 53                          |     |
| - | 1   | 1   | 1803382-6   | HOLD DOWN, SPRING LOADED            | 50                          |     |
| - | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49                          |     |
| - | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48                          |     |
| - | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41                          |     |
| - | 1   | 1   | 3-1752356-3 | 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   | 1320928-2   | 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   | 2119533-1   | STRIPPER, SIDE FEED                 | 19                          |     |
| 7 | -   | 1   | 1           | 2119806-1                           | INSERT, SHEAR               | 13  |
| - | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12                          |     |
| - | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11                          |     |
| 7 | -   | 1   | 1           | 2119805-1                           | SHEAR HOLDER, FRONT         | 10  |
| 7 | -   | 1   | 1           | 1803095-3                           | FLOATING SHEAR, FRONT       | 9   |
| 7 | 1   | 1   | 1           | 3-1803055-1                         | ANVIL, COMBINATION          | 8   |
| - | 1   | 1   | 2-240641-4  | SPACER                              | 7                           |     |
| - | -   | -   | -           | -                                   | 6                           |     |
| - | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5                           |     |
| - | 1   | 1   | 1-238011-0  | BLOCK, CRIMPER SPACER               | 4                           |     |
| 7 | 1   | 1   | 1           | 3-1633966-6                         | CRIMPER, INSULATION O       | 3   |
| - | -   | -   | -           | -                                   | 2                           |     |
| 7 | 1   | 1   | 1           | 8-1633588-1                         | CRIMPER, WIRE               | 1   |

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

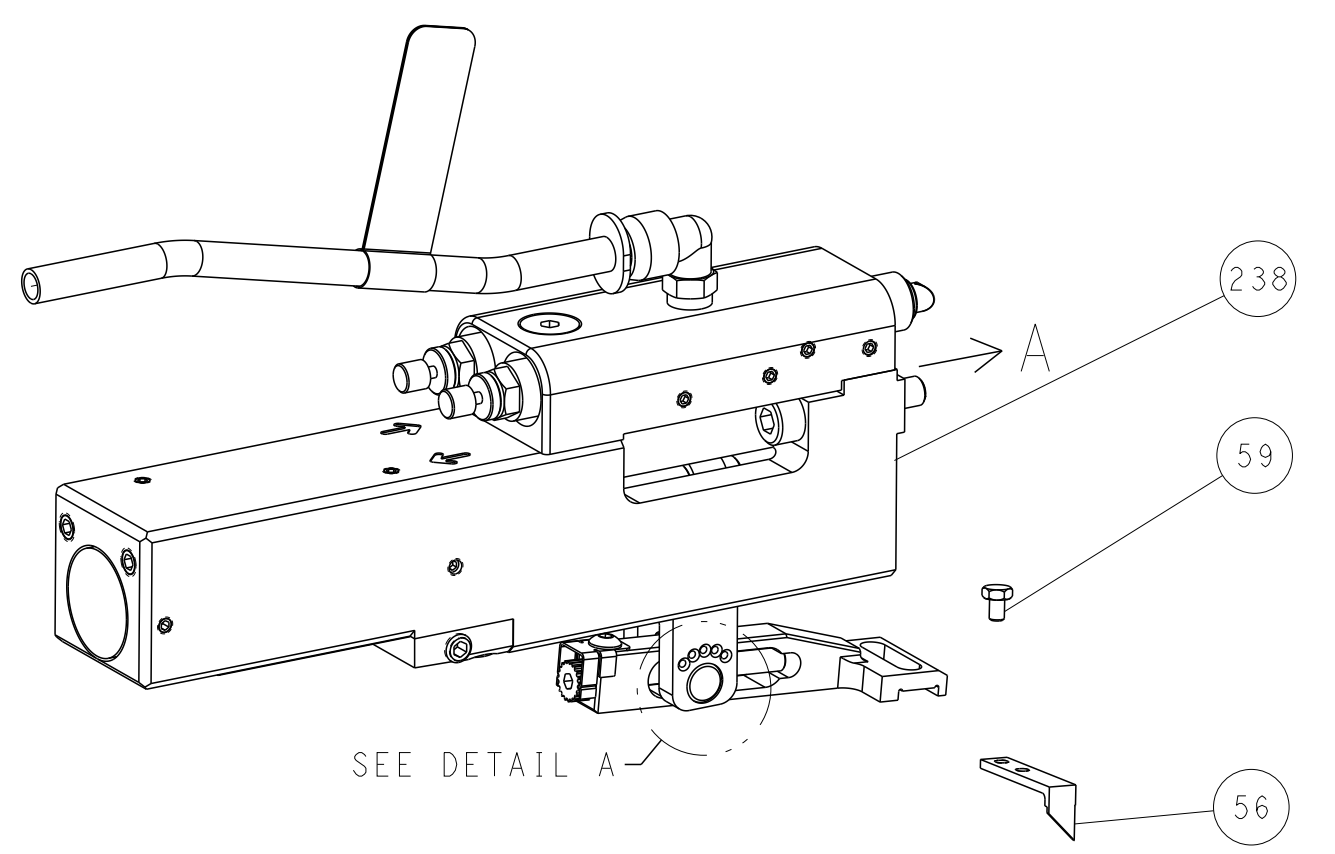
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|-------------|---------|--|---------|-----------|---------|---------|--------|---------|--|--------|-----|--------|----|------|---|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±   | 4 PLC ± | ANGLES  | FINISH |         |  | A      | 1:2 | 3      | OF | 4    | D |

| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    |     | SEE SHEET 1 |      |     |      |

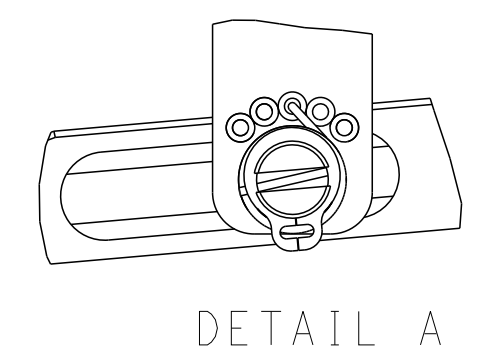
# FEED TYPE MECHANICAL



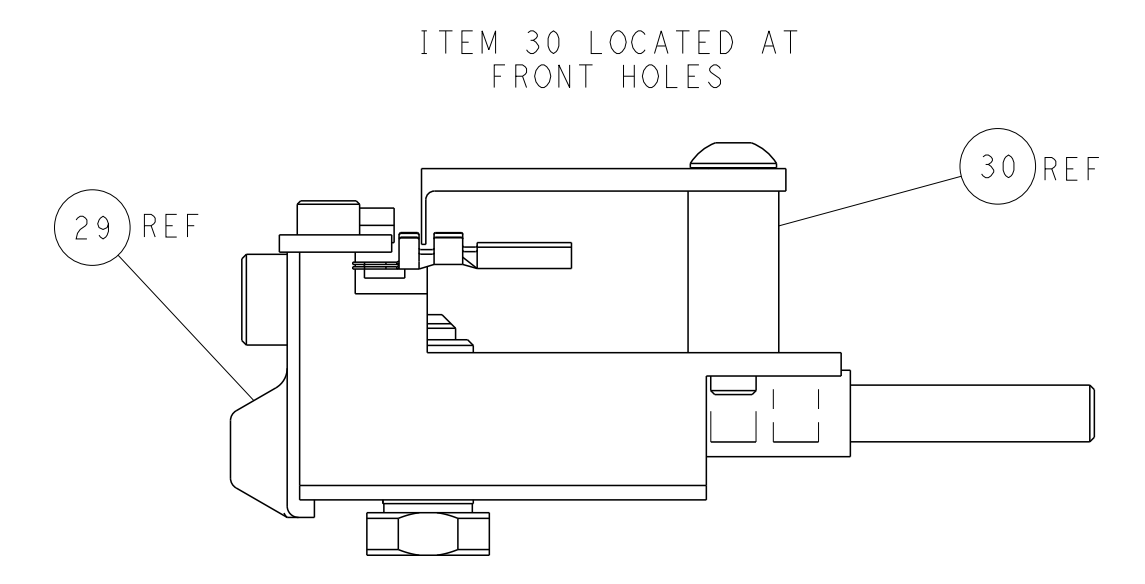
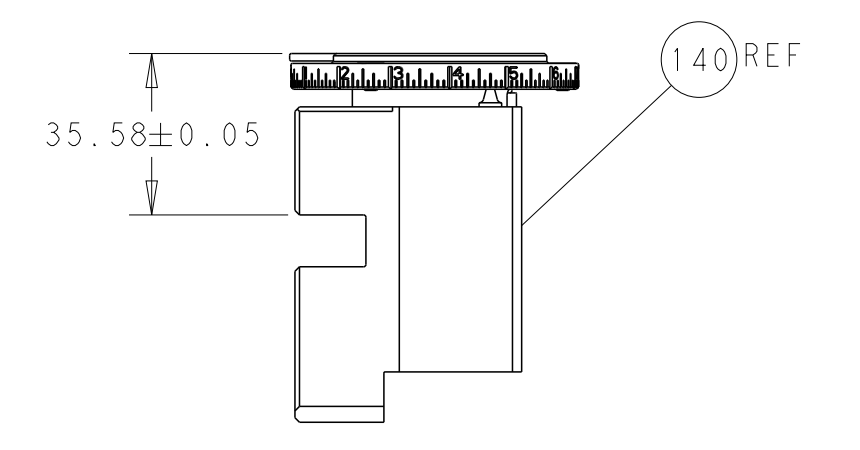
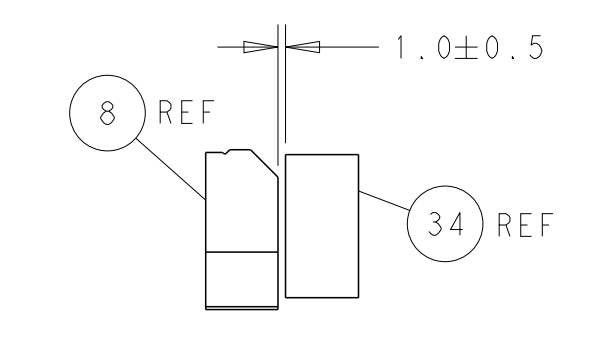
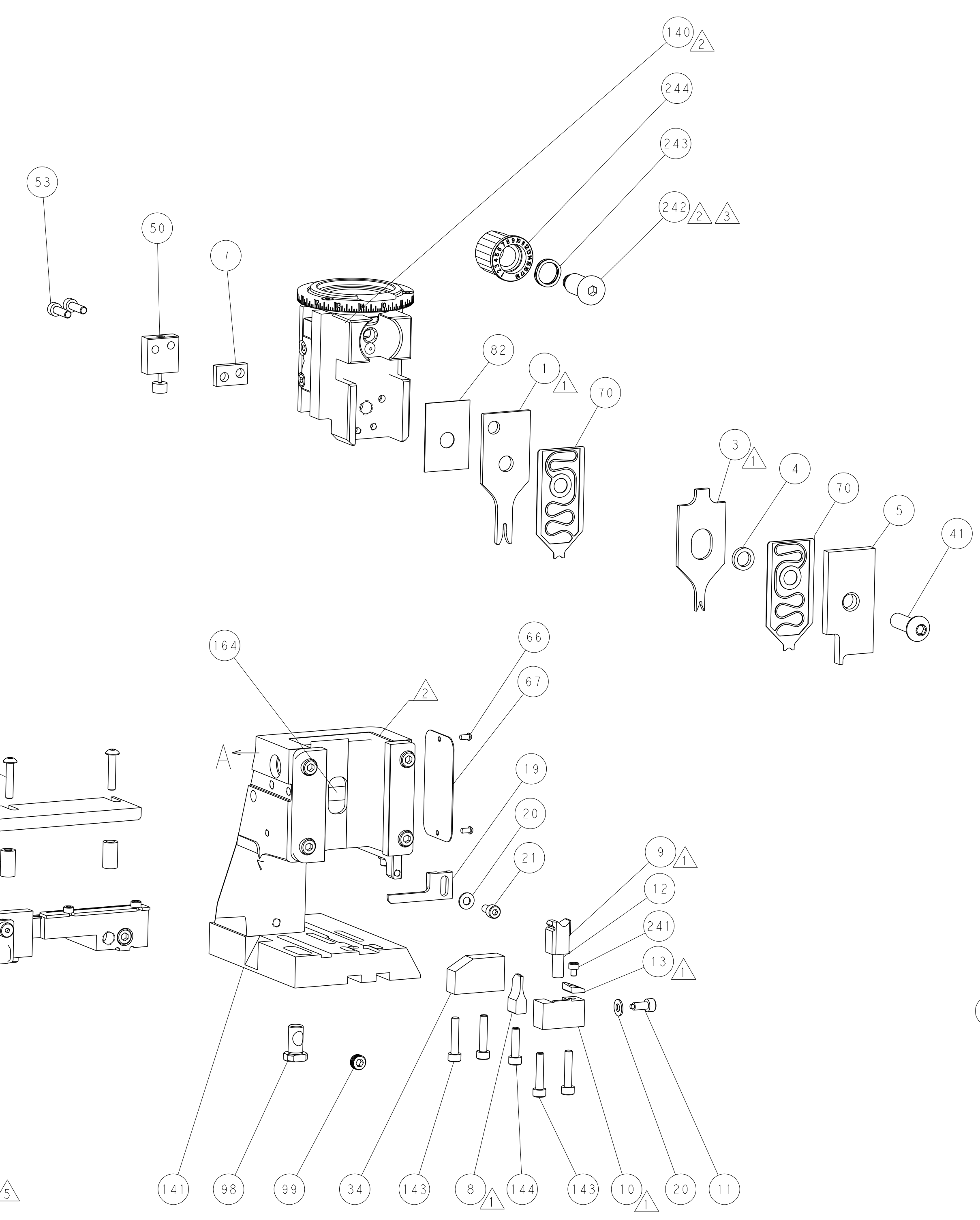
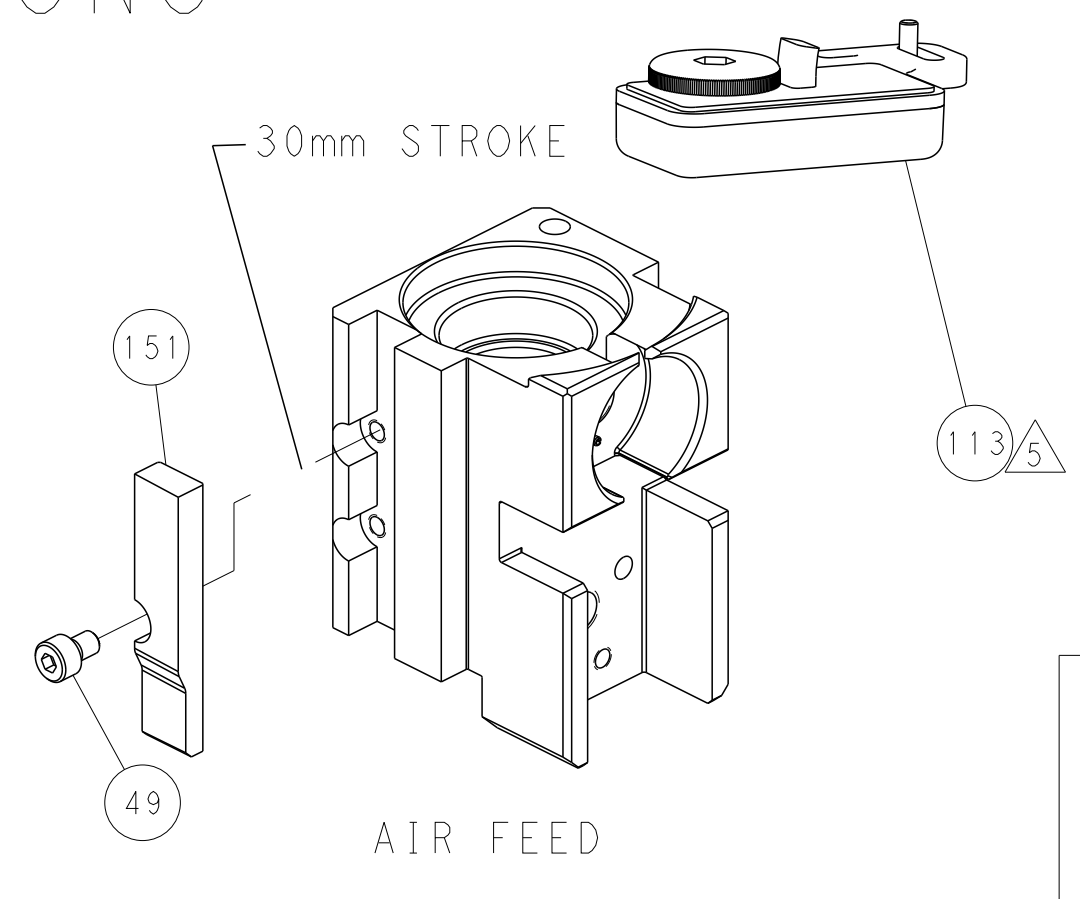
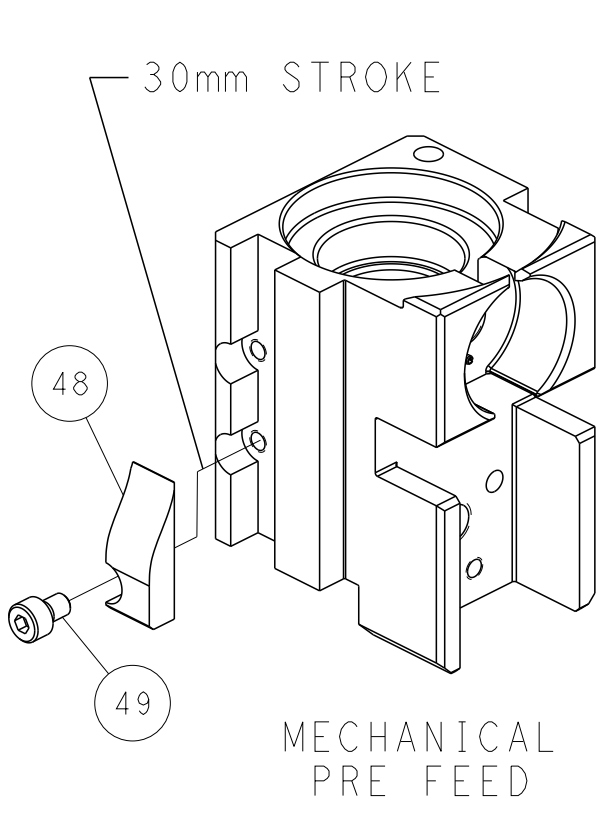
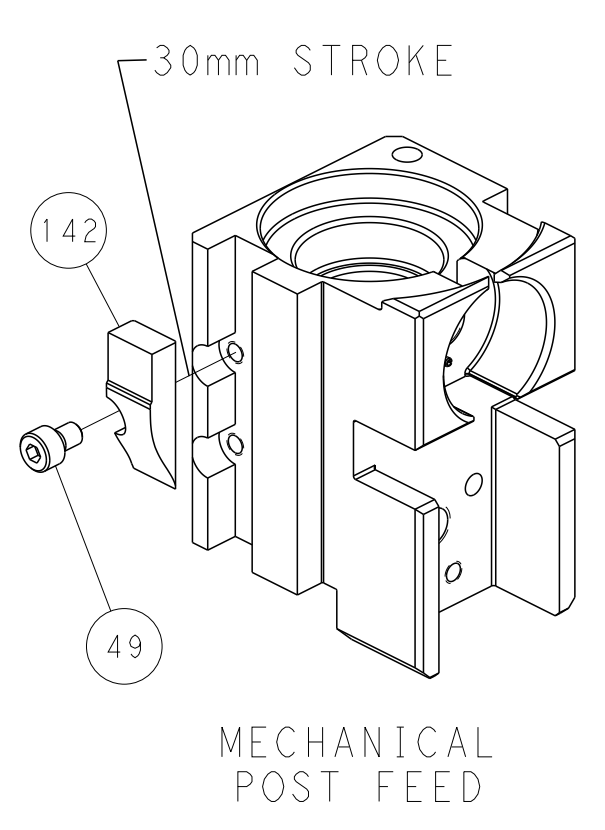
## PNEUMATIC



## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



# CAM POSITIONS



**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<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ±   |  | NAME: Ocean Side Feed Applicator<br>PRODUCT SPEC: -<br>APPLICATION SPEC: -<br>WEIGHT: -<br>MATERIAL: - | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151359<br>SCALE: 1:2<br>SHEET: 4 OF 4<br>REV: D |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING   |  | RESTRICTED TO:   |  |