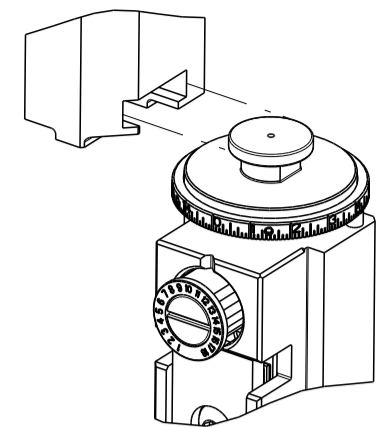


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151699-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151699-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151699-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



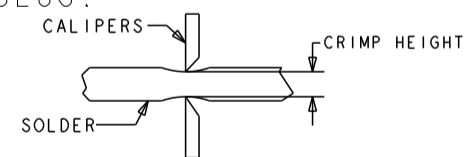
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.205 [5.21 mm]	D
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CONNECTIVITY CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON	
WIRE STRIP LENGTH .296-.328 IN [7.52-8.33 mm]	INSULATION DIAMETER RANGE Ø .320 IN [8.13 mm] MAX
TERMINAL APPLICATION SPECIFICATION 114-2123 Rev G	
TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL
3-520370-2	

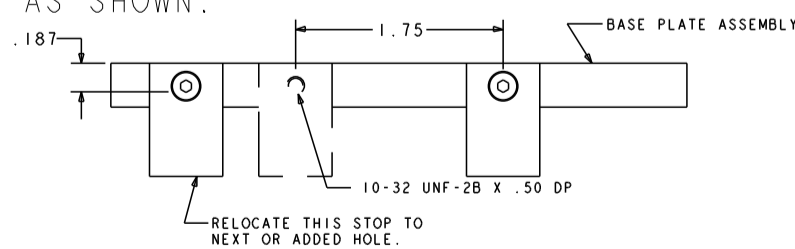
WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14	0.075+/-0.002 [1.91+/-0.05]	5.6	.19 IN [4.83mm]
16	0.070+/-0.002 [1.78+/-0.05]	7.0	.19 IN [4.83mm]

***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.

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- 5 ITEM 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- 6 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø .19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



7 IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.



8 ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.

9 ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.

10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

11. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		C		ECR-18-016781	25OCT2018	JAH	CT
		C1		ECR-18-017084	29OCT2018	JAH	TE
		D		ECR-20-016470	19NOV2020	FJ	TE
		E		ECR-22-155203	11OCT2022	ROY	JAH

1	-	1	1	2280441-1	INSERT, SHEAR	282
9	-	REF	REF	462992-7	GUARD ASSEMBLY	257
9	-	REF	REF	679532-1	INSERT, GUARD	256
8	-	1	1	189728-1	BRACKET, SPACER	255
8	-	1	1	568681-1	SPACER, BASE PLATE	253
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	1	2844940-2	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	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
	-	4	4	18023-4	SCR, SKT HD CAP M3 X 10.0	94
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	240641-9	SPACER	81
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2161332-4	DEPRESSOR, WIRE FUNNEL	70
	-	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
	-	2	2	1-18028-4	WASHER, FLAT, REG M3	68
	-	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	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	462427-2	FINGER, FEED	56
	-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1-1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
5	-	1	1	462433-7	SUPPORT, INSULATION	42
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	2	2	5-22278-1	SPRING, COMPRESSION	33
	-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
	-	1	1	2161336-2	PLATE, REAR STRIP GUIDE	29
	-	2	2	22281-9	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	684042-4	GUIDE, STRIP, FRONT	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	463460-2	HOLD DOWN, TERMINAL	18
1	-	1	1	469542-3	REAR FLOATING SHEAR	17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
1	-	1	1	2161335-2	SHEAR PLATE, REAR	15
	-	1	1	2119862-2	SHEAR HOLDER, REAR	14
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-4	STOP, SHEAR	11
	-	-	-	-	-	10
5	-	1	1	462843-6	TERMINAL SUPPORT	9
1	1	2	1	464282-2	ANVIL, SAND-BLASTED 16-14	8
4	-	1	1	803925-2	GUIDE, CARRIER SCRAP	7
	-	1	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
5	-	1	1	462431-5	WIRE FUNNEL	5
	-	1	1	238011-1	BLOCK, CRIMPER SPACER	4
	-	-	-	-	-	3
	-	-	-	-	-	2
1	1	2	1	464281-1	CRIMPER, SEMI FLAT 16-14	1

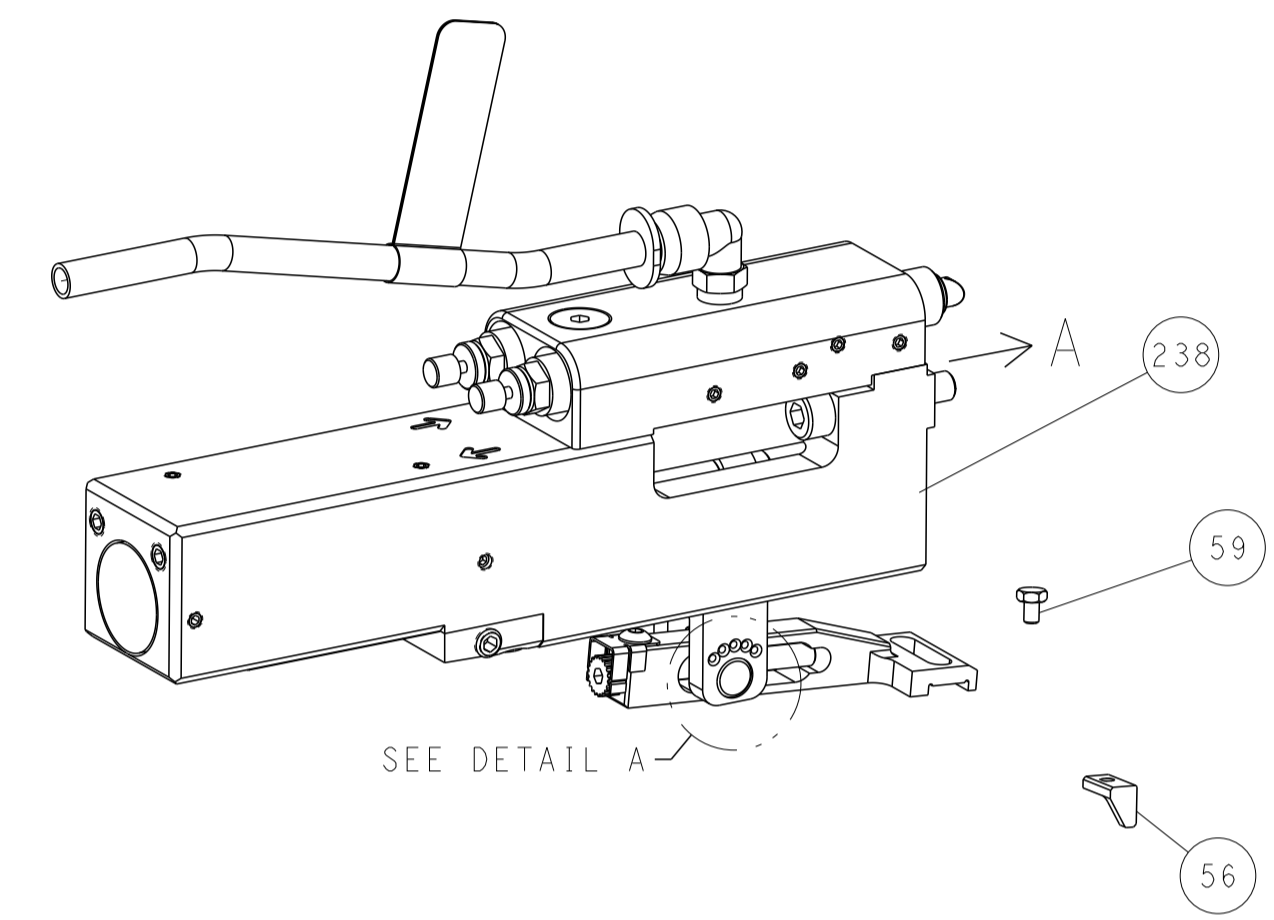
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WT	SCALE	SHEET	REV
										1	E

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			
P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

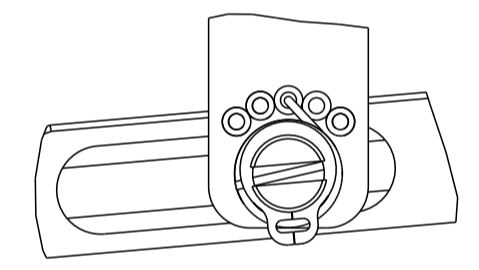
FEED TYPE

PNEUMATIC



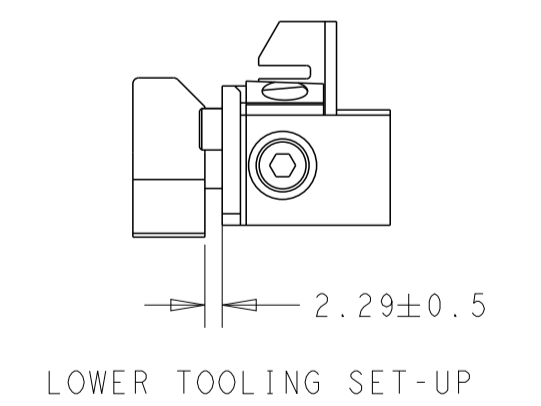
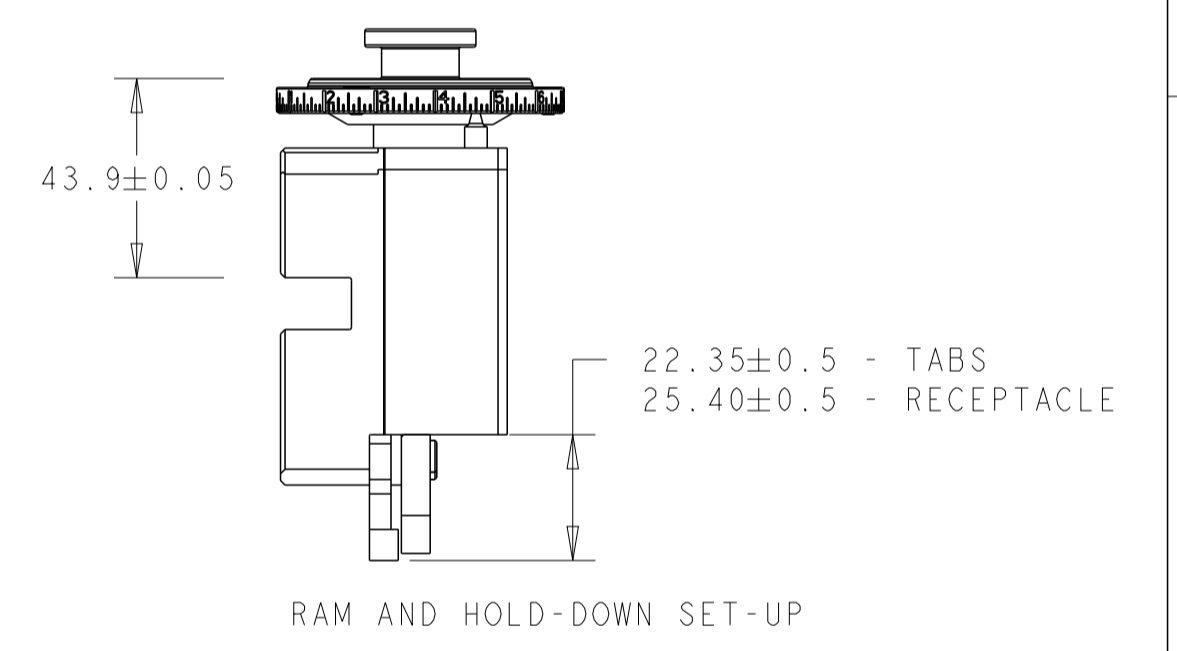
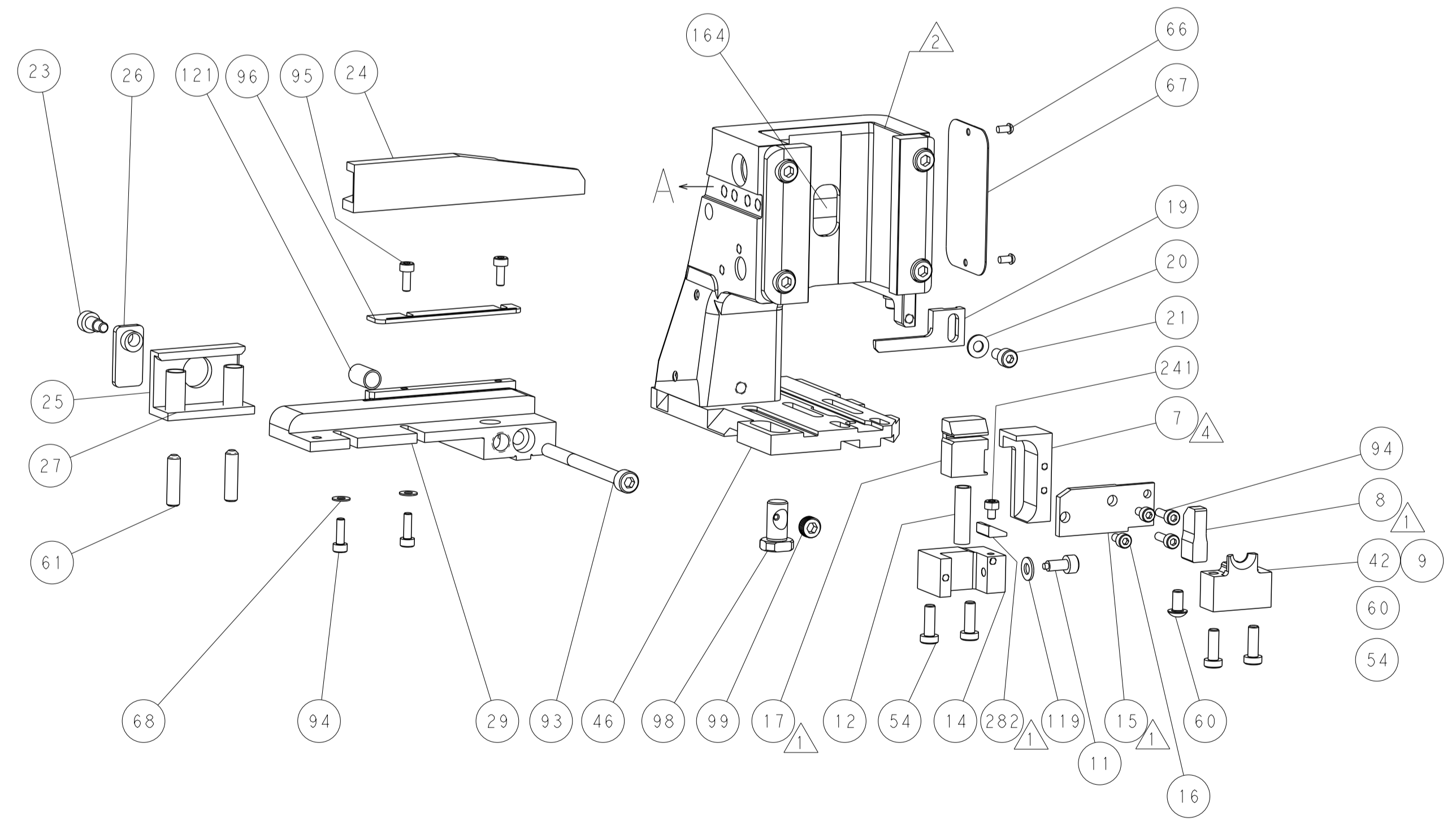
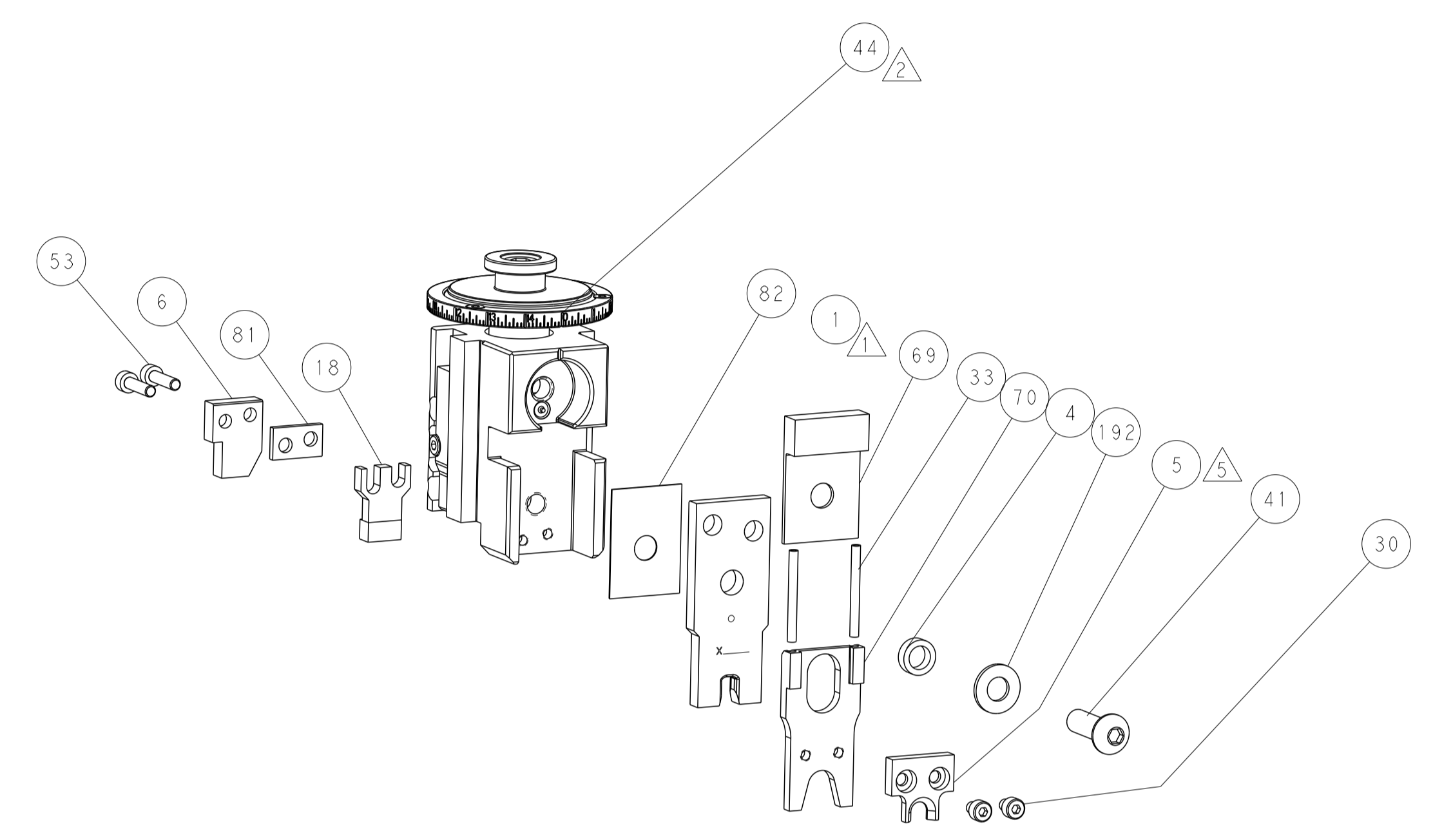
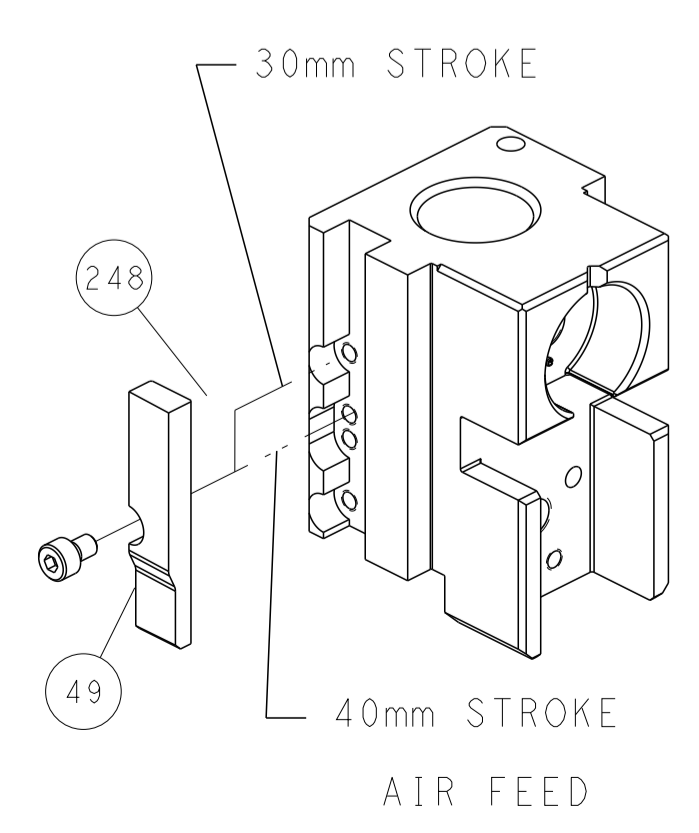
SEE DETAIL A

FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS



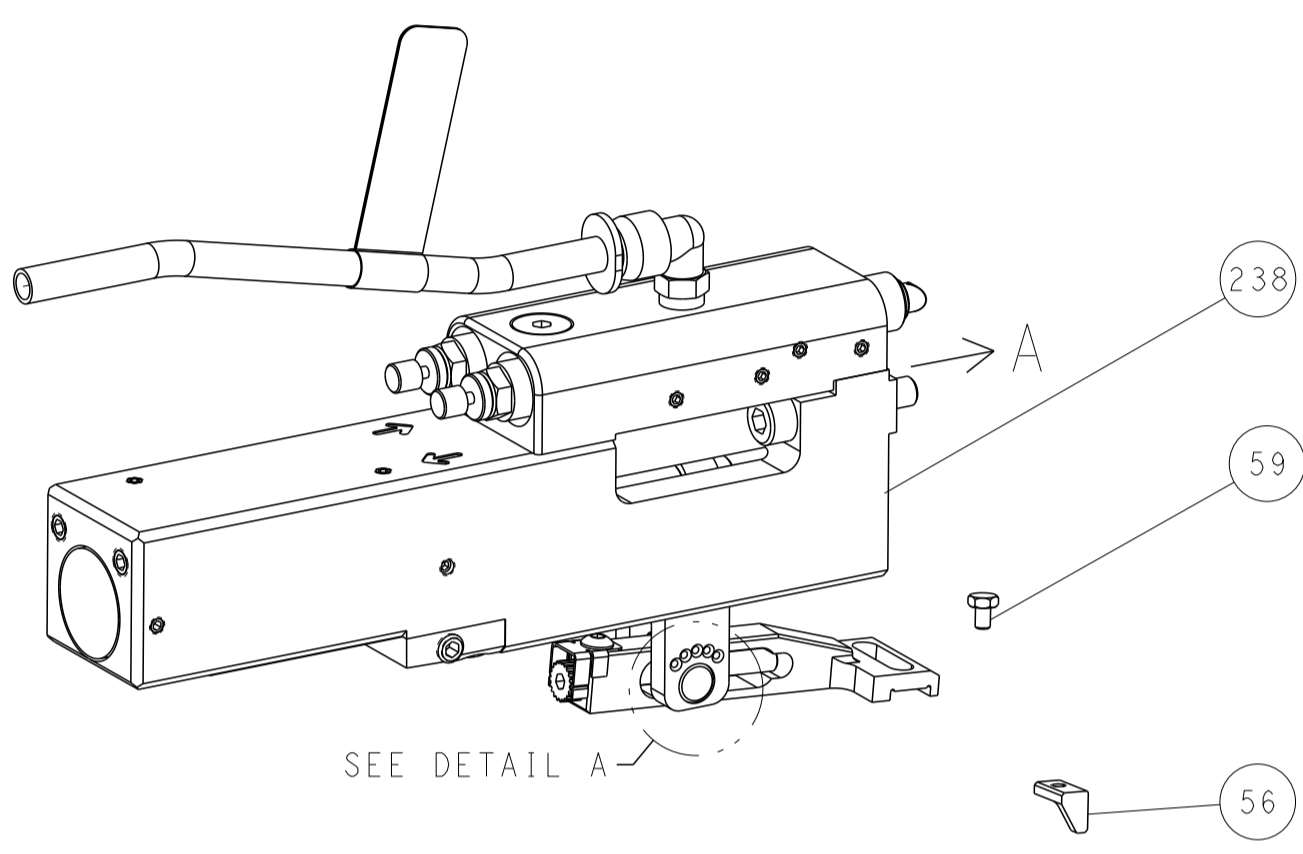
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2012 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN B. WEAVER 18JUN2012 CHK G. HOFFNER 18JUN2012 APVD T. ELBIN 18JUN2012	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 CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2151699	WEIGHT SCALE 1:1 SHEET 2 OF 4 REV E
MATERIAL:		Customer Accessible Production Drawing	

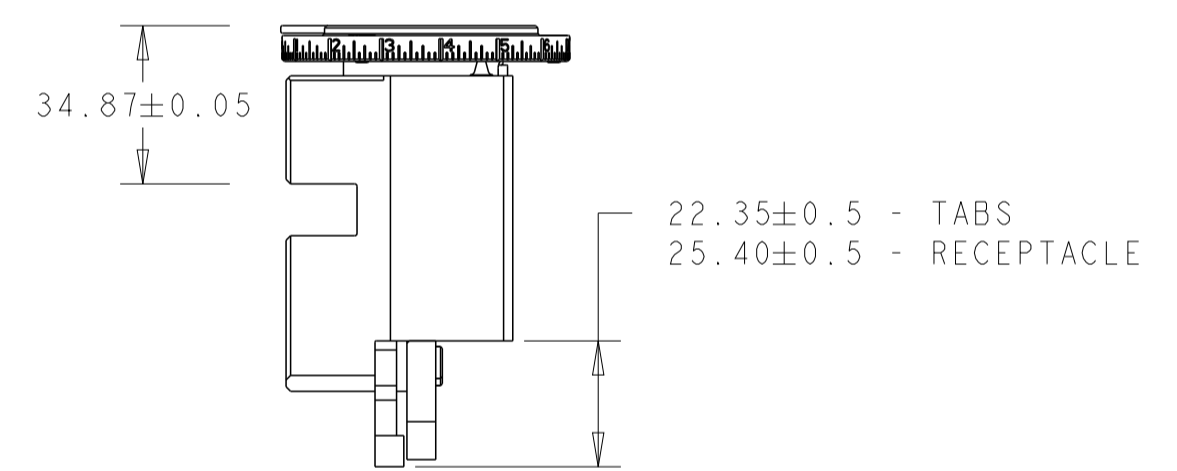
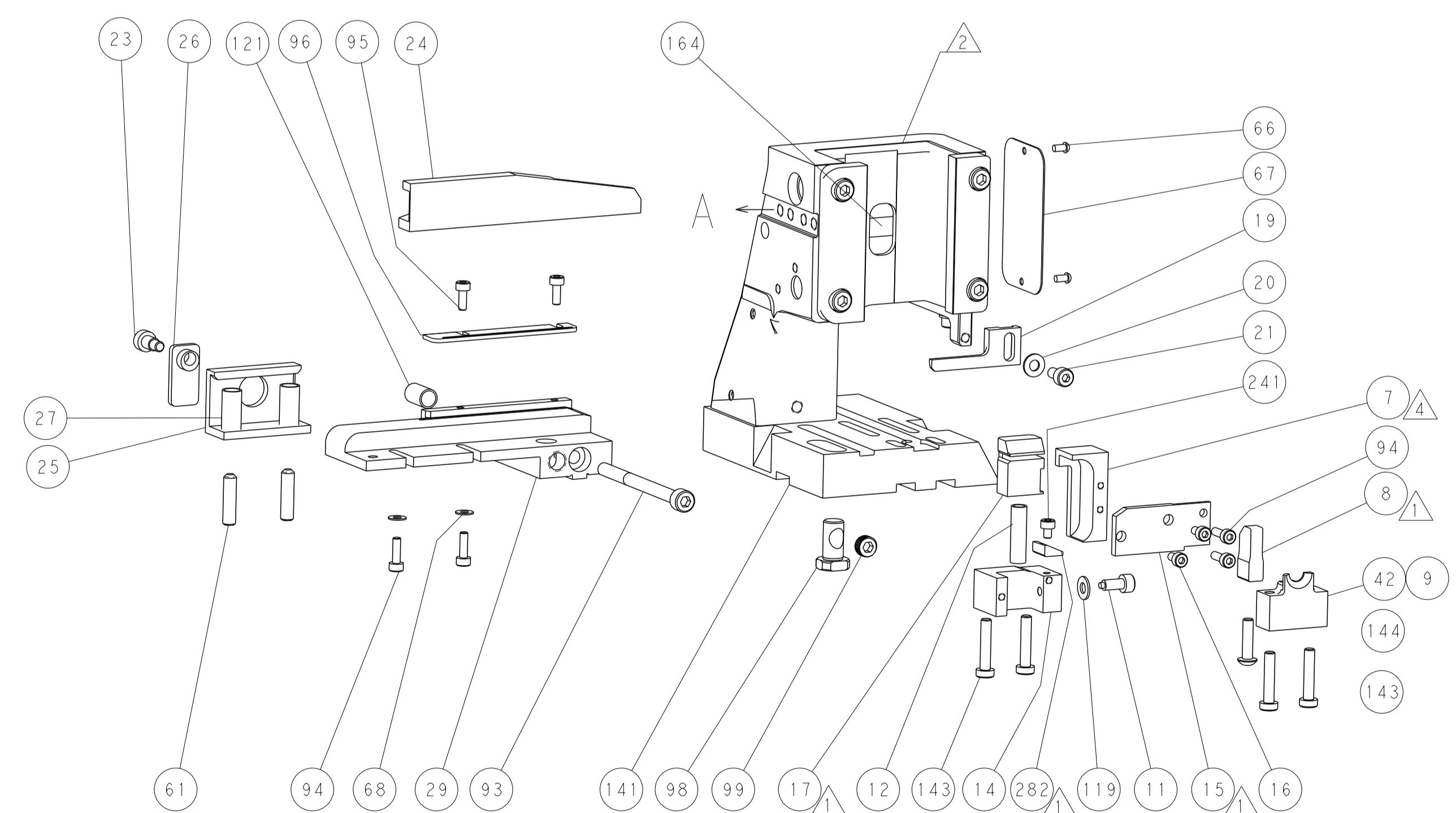
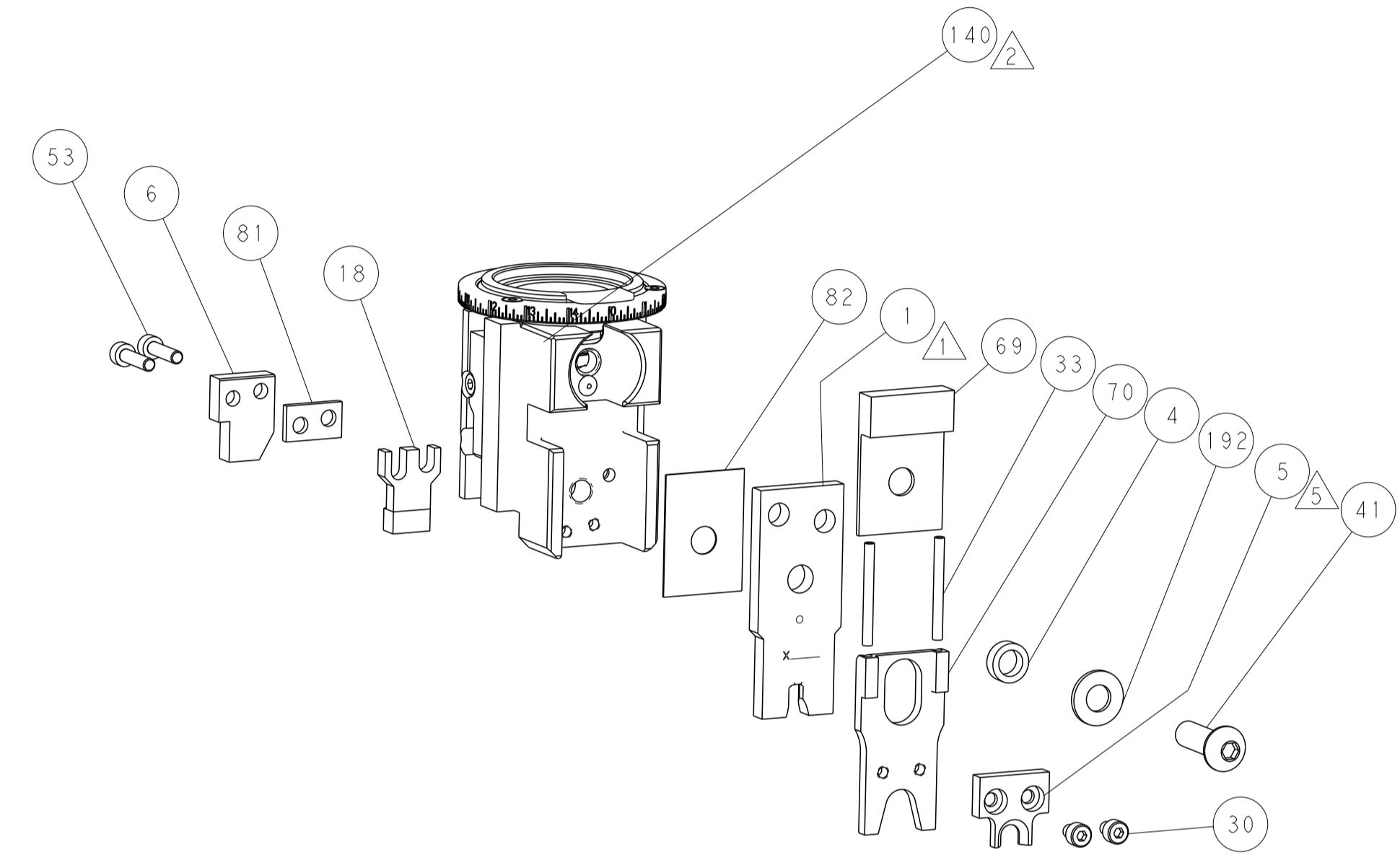
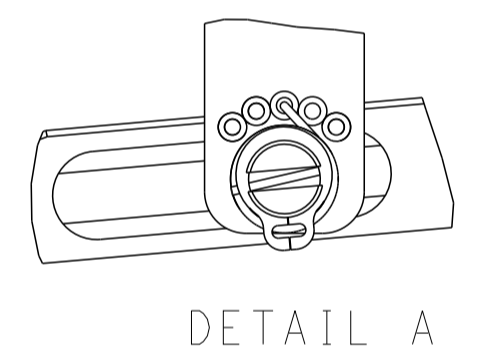
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

FEED TYPE

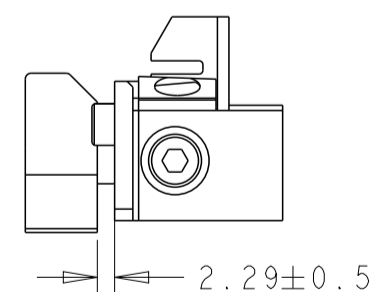
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

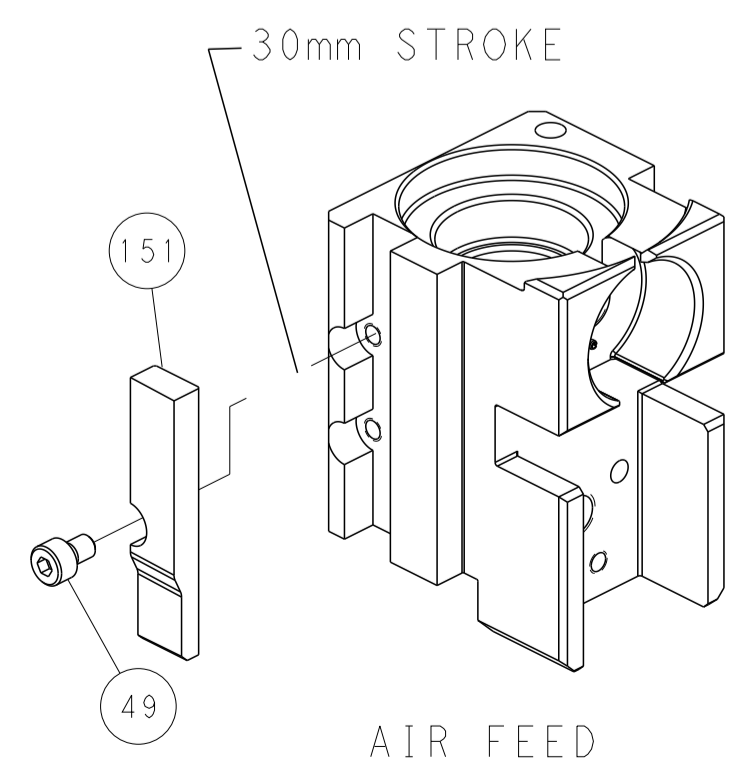


RAM AND HOLD-DOWN SET-UP



LOWER TOOLING SET-UP

CAM POSITION



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 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±. FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	RESTRICTED TO SIZE CAGE CODE DRAWING NO A1 00779 C=2151699 SHEET 4 OF 4 REV E