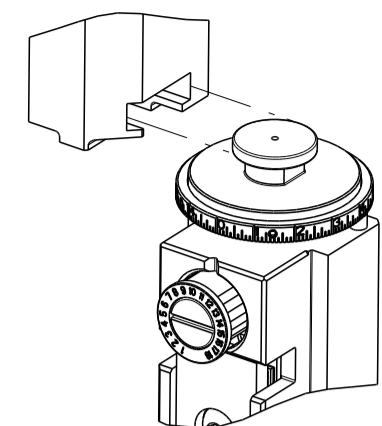


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151723-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151723-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151723-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

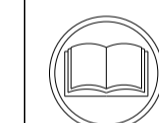


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.89 mm [.153]	F
INSUL	9.53 mm [.375]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: G&H TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MAK 8.0x0.8/9.5x1.2 Terminal			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.40-7.70 mm [.291-.303 IN]		Ø4.00-4.40 mm [.157-.173 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE SEAL	VW SEAL
1572996-1	28469.306.189	2113288-1	0211626A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.50+/-0.05 [.098+/- .002]	6.8



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 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.
- 8 CUT 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.

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		RELEASED	07MAY2013	LG	TE
		B		ECR-23-174150	03MAY2023	LG	RR

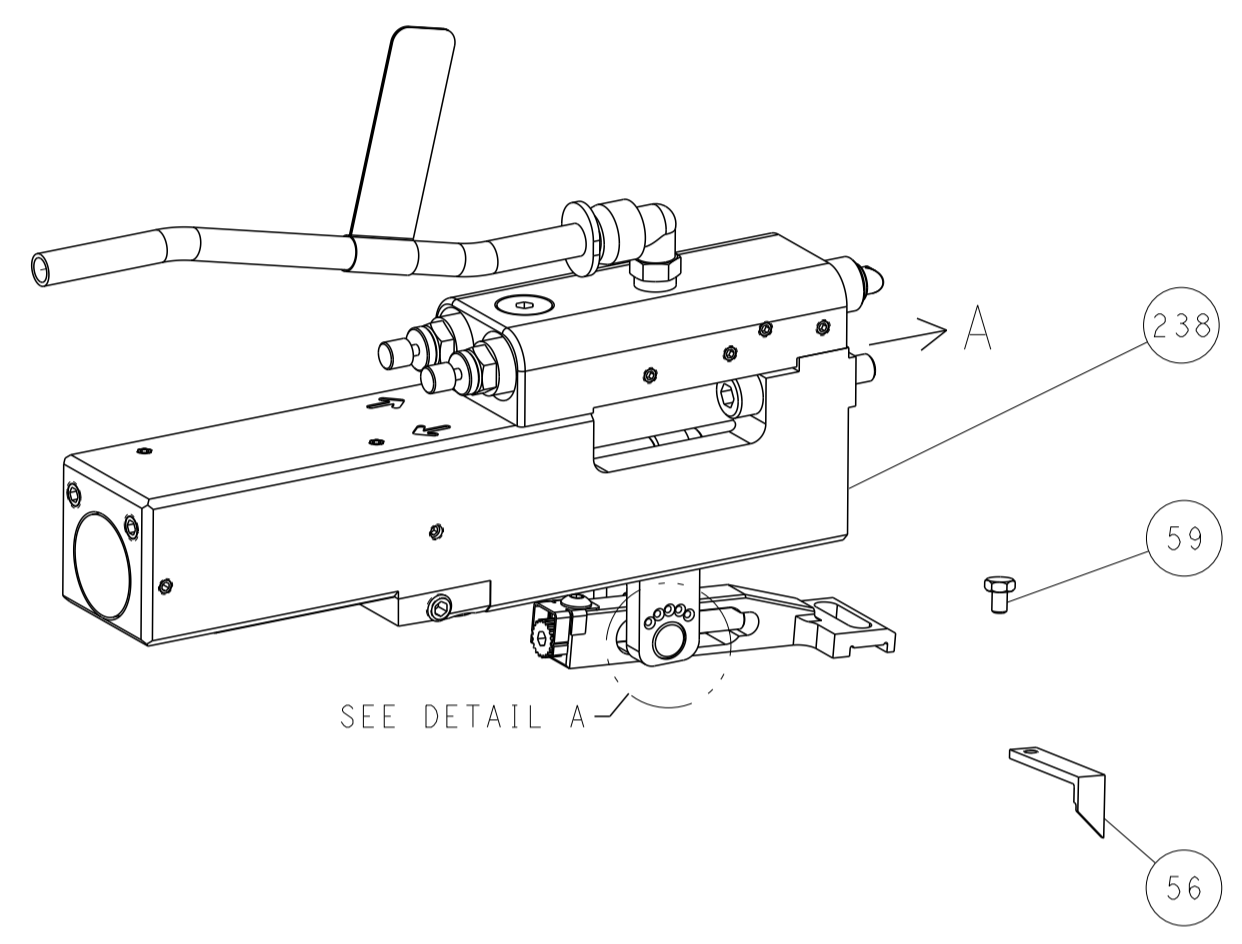
8	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1	1633782-3	FENCE	267
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	1	2844940-2	AIR FEED MODULE	238
3	-	1	1	2-1752354-6	STANDOFF, HOLD-DOWN	180
	-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	2-690438-2	FRONT STRIP GUIDE	96
	-	1	1	318563-1	GUARD, FRONT CHIP	89
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
	-	1	1	1803096-1	EXTENSION PLATE	78
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-9	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
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
△	-	1	1	985575-5	SCR, FLT SKT HD CAP M3 X 16.0	57
	-	1	1	1338683-8	FEED PAWL	56
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1901681-2	HOLDDOWN, TERMINAL	51
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1-1803583-7	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	1-1752356-1	SUPPORT, TERMINAL	34
	-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
	-	2	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	2	2	22281-8	SPRING, COMPRESSION	27
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1320928-8	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	1803013-1	STRIPPER, SIDE FEED	19
△	-	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-3	STOP, SHEAR	11
△	-	1	1	1-2119805-0	SHEAR HOLDER, FRONT	10
△	-	1	1	1-318059-0	FLOATING SHEAR, FRONT	9
△	1	2	1	1633930-9	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	1803080-1	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-7	BLOCK, CRIMPER SPACER	4
△	1	2	1	2-1633996-9	CRIMPER, INSULATION SPECIAL	3
	-	1	1	2-455888-5	SPACER, CRIMPER	2
△	1	2	1	7-1633609-2	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	01JAN2012	R. KNEPPER	01JAN2012	L. GROSS	01JAN2012	T. ELBIN
MATERIAL		FINISH		WEIGHT		CAGE CODE		DRAWING NO		RESTRICTED TO	
						A1		00779		C=2151723	
Customer Accessible Production Drawing						SCALE		SHEET		REV	
						1:2		1 OF 4		B	

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

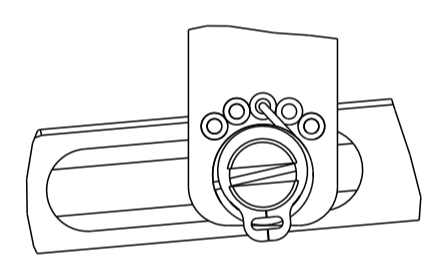
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PNEUMATIC



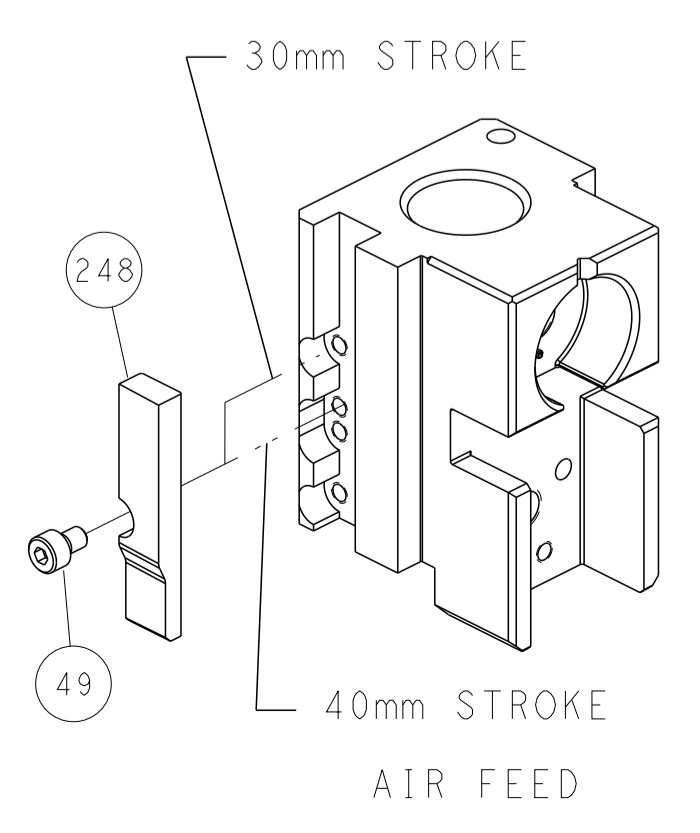
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

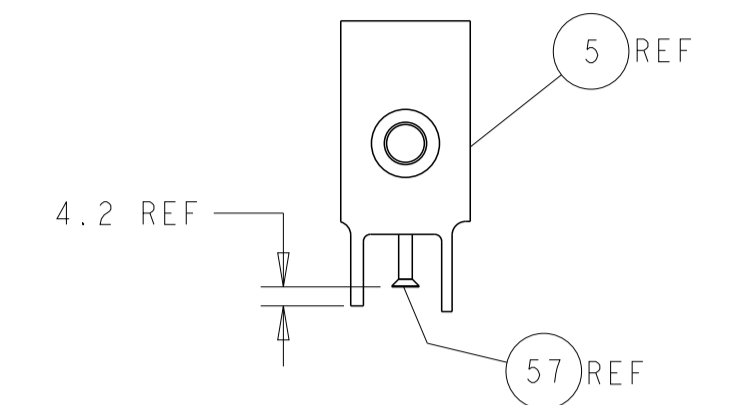
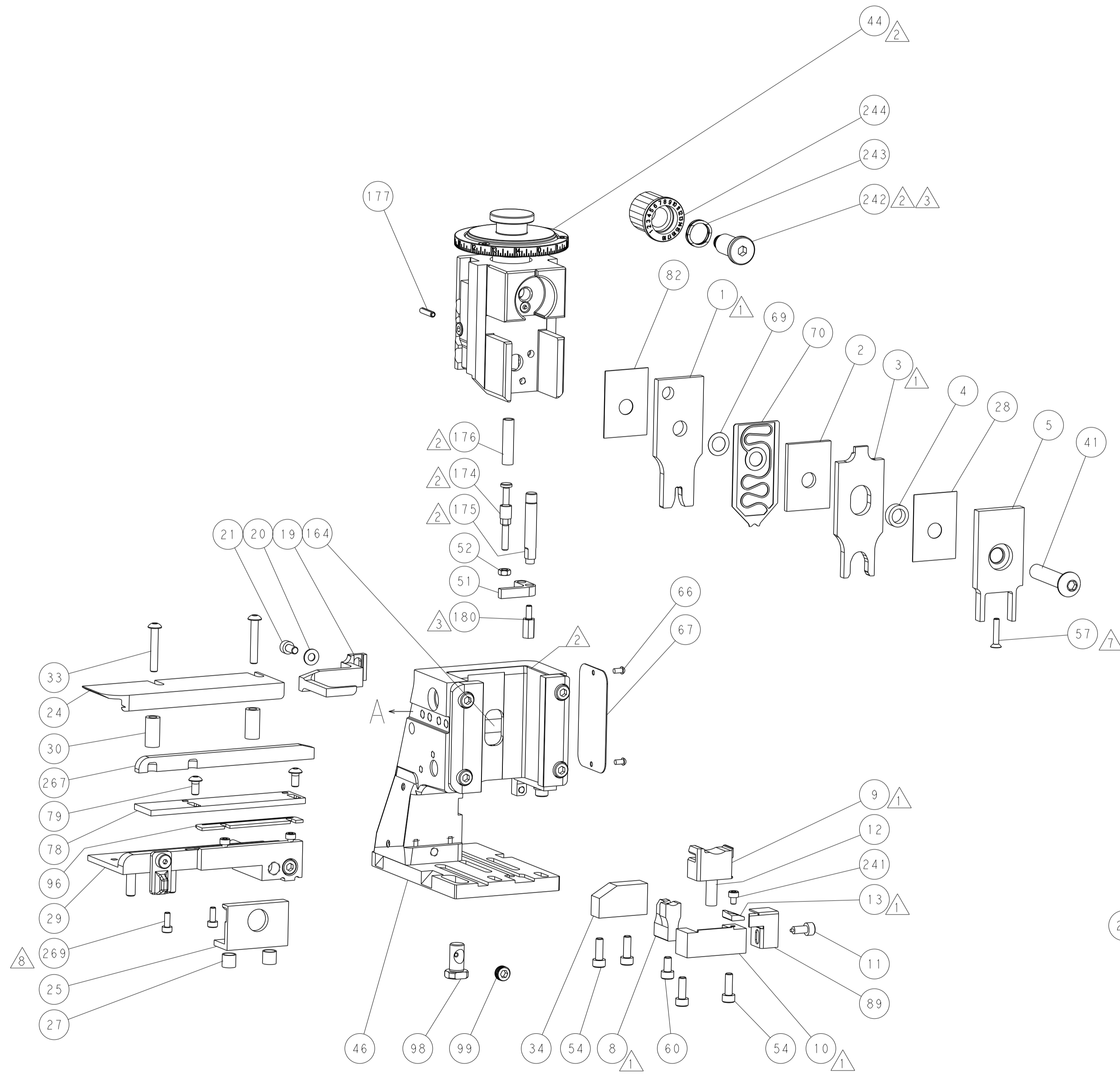


DETAIL A

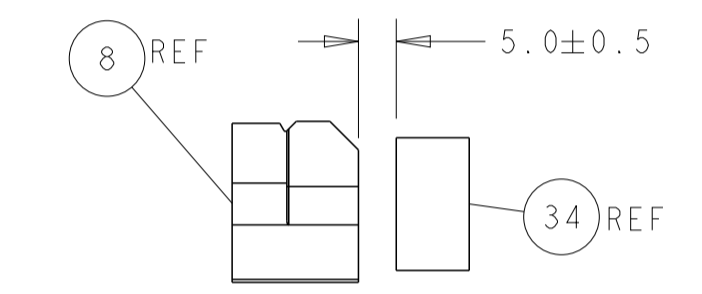
CAM POSITION



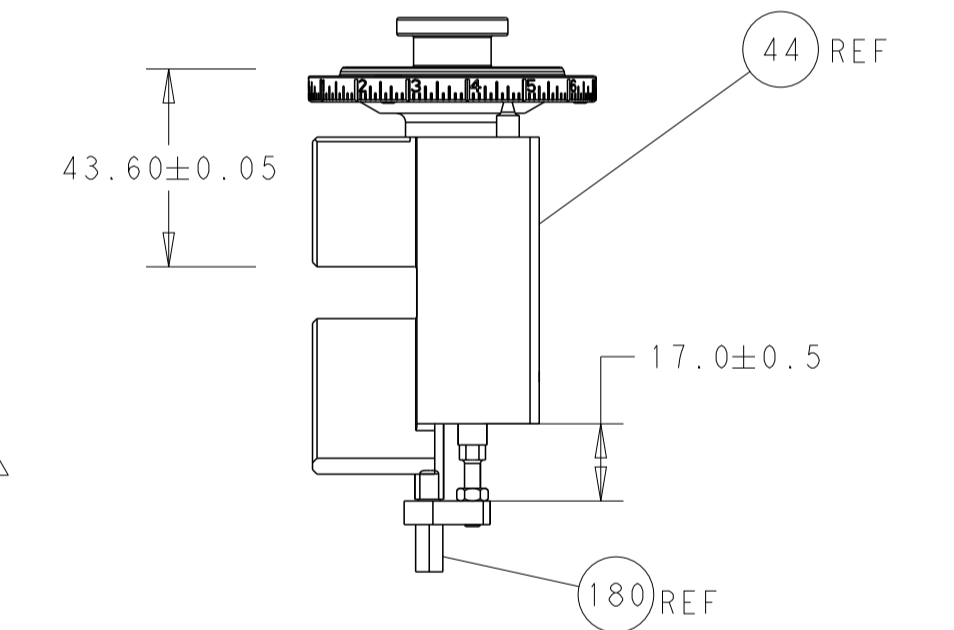
AIR FEED



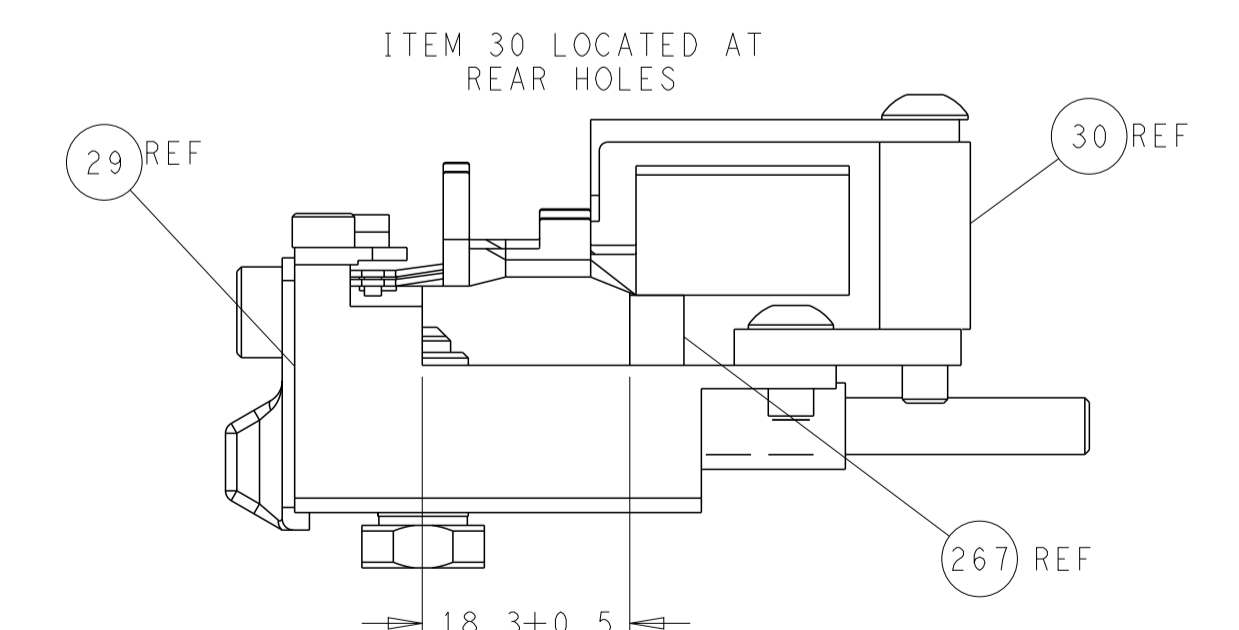
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



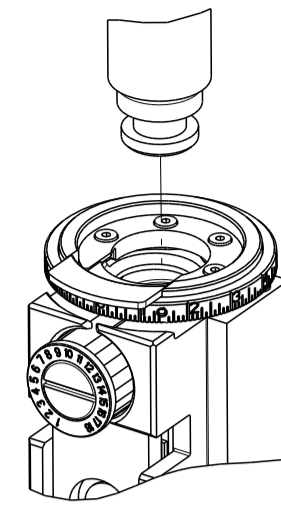
FEED TRACK POSITION GUIDE BY WIRE BARREL

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 R. KNEPPER 01JAN2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
ANGLES	FINISH	MATERIAL		CHK L. GROSS 01JAN2012		NAME	
				T. ELBIN 01JAN2012		Ocean Side Feed Applicator	
				APVD		SIZE CAGE CODE DRAWING NO	
				PRODUCT SPEC		RESTRICTED TO	
				APPLICATION SPEC		A1 00779 C=2151723	
				WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV B	
				Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151723-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151723-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.89 mm [1.53]	F
INSUL	9.53 mm [3.75]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: G&H TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MAK 8.0x0.8/9.5x1.2 Terminal			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.40-7.70 mm [1.291-.303 IN]		Ø4.00-4.40 mm [1.57-.173 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	G&H TERMINAL	TE SEAL	G&H SEAL
1572996-1	28469.306.189	2113288-1	0211626A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm ²	2.50+/-0.05 [1.098+/-0.02]	6.8



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 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.
- 8 CUT 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)

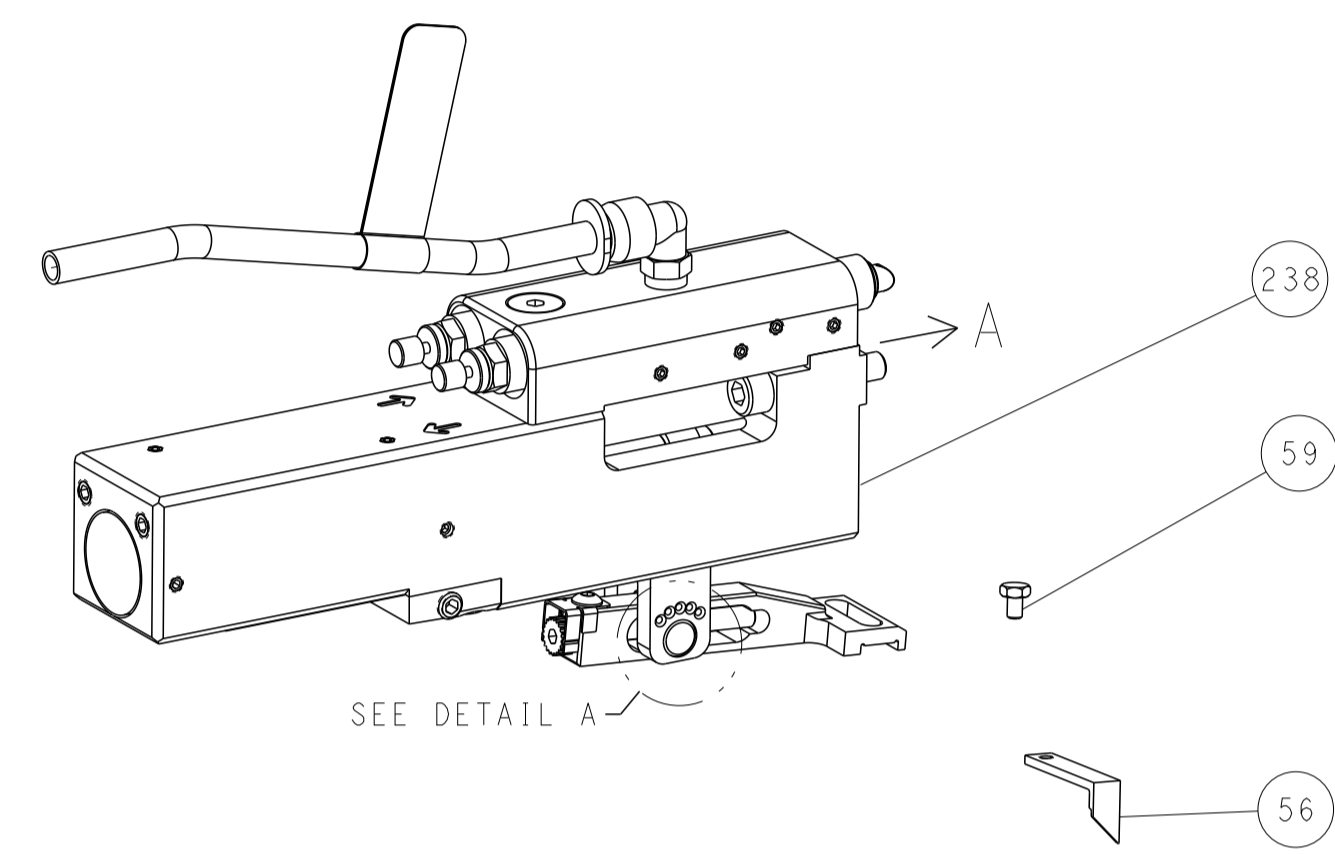
LOC	DIST	REV	DATE	BY	APPD
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPD
-	-	SEE SHEET 1	-	-	-
8	-	2 2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0			269
-	-	1 1633782-3 FENCE			267
-	-	1 2119082-9 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 2844940-2 AIR FEED MODULE			238
3	-	1 2-1752354-6 STANDOFF,HOLD-DOWN			180
-	-	1 6-993111-6 PIN, SLOTTED SPRING 3.0 X 14.0			177
-	-	1 8-22280-7 SPRING, COMPRESSION			176
-	-	1 1752353-2 GUIDE PIN,HOLDDOWN			175
-	-	1 1901680-2 GUIDE PIN,HOLDDOWN			174
-	REF	994970-2 COUNTER, MAGNETIC			164
-	-	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 1-1803583-8 APPLICATOR BASIC ASSEMBLY, SF			141
-	-	1 1803516-2 RAM ASSEMBLY, SF PACIFIC			140
-	-	1 2844908-1 SCREW, LOCKING			99
-	-	1 2844907-1 POST, LOCKING			98
-	-	1 2-690438-2 FRONT STRIP GUIDE			96
-	-	1 318563-1 GUARD, FRONT CHIP			89
-	-	1 455888-4 SPACER, CRIMPER			82
-	-	2 18024-6 SCR, BTN SKT HD CAP (M4 X 8.0)			79
-	-	1 1803096-1 EXTENSION PLATE			78
-	-	1 1803607-3 DOCUMENTATION PACKAGE			71
-	-	1 2119791-9 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 985575-5 SCR, FLT SKT HD CAP M3 X 16.0			57
-	-	1 1338683-8 FEED PAWL			56
-	-	1 1-5018030-0 NUT, HEX, REG, RoHS, M3.5			52
-	-	1 1901681-2 HOLDDOWN, TERMINAL			51
-	-	1 18023-9 SCR, SKT HD CAP M4 X 6.0			49
-	-	1 1803602-2 SCR, BHSC, RoHS (M8 X 40)			41
-	-	1 1-1752356-1 SUPPORT, TERMINAL			34
-	-	2 1-2079383-3 SCR, BHSC, RoHS (M4 X 25)			33
-	-	2 3-2844962-5 SPACER, CYLINDRICAL, STRIP GUIDE			30
-	-	1 2844992-5 ASSEMBLY, STRIP GUIDE			29
-	-	1 455888-3 SPACER, CRIMPER			28
-	-	2 22281-8 SPRING, COMPRESSION			27
-	-	1 240792-1 DRAG, TERMINAL			25
-	-	1 1320928-8 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 1803013-1 STRIPPER, SIDE FEED			19
1	-	1 2119806-1 INSERT, SHEAR			13
-	-	1 3-22280-3 SPRING, COMPRESSION			12
-	-	1 1-356885-3 STOP, SHEAR			11
1	-	1 1-2119805-0 SHEAR HOLDER, FRONT			10
1	-	1 1-318059-0 FLOATING SHEAR, FRONT			9
1	1	1 1633930-9 ANVIL, COMBINATION			8
-	-	-			7
-	-	-			6
-	-	1 1803080-1 DEPRESSOR, SHEAR			5
-	-	1 2-238011-7 BLOCK, CRIMPER SPACER			4
1	1	2-1633996-9 CRIMPER, INSULATION SPECIAL			3
-	-	1 2-455888-5 SPACER, CRIMPER			2
1	1	7-1633609-2 CRIMPER, WIRE			1

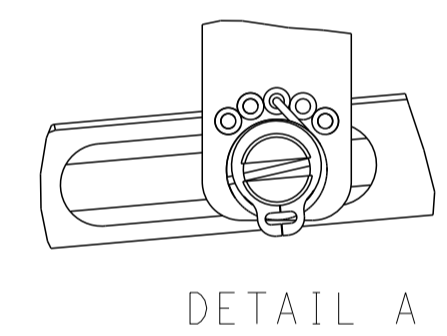
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R. KNEPPER 01JAN2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: L. GROSS 01JAN2012	NAME: Ocean Side Feed Applicator
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2 SHEET 3 OF 4 REV B	

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

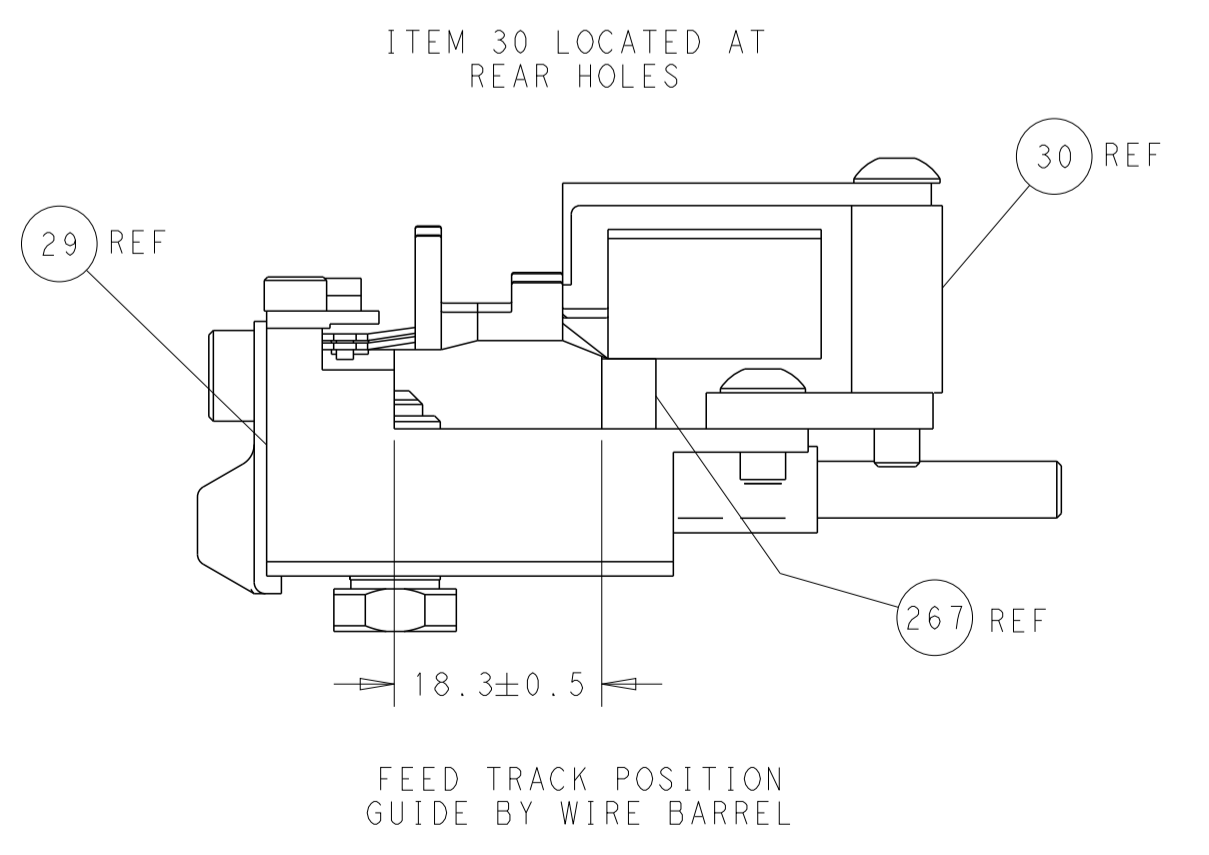
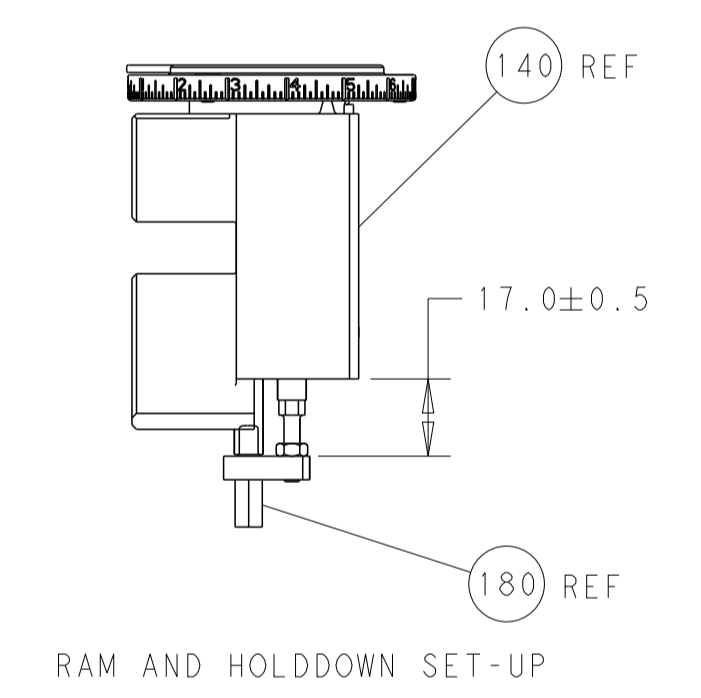
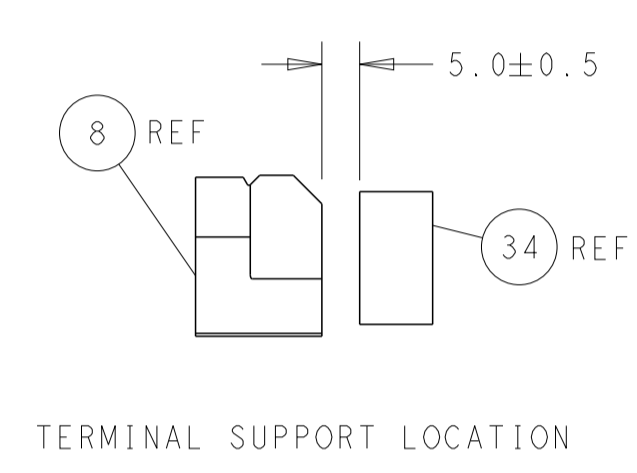
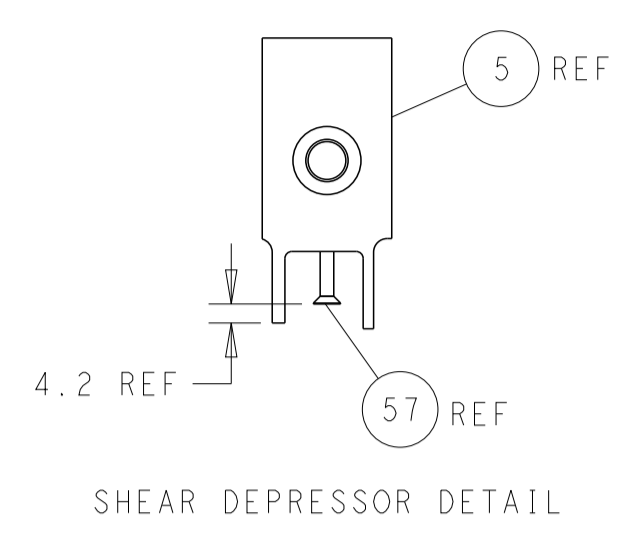
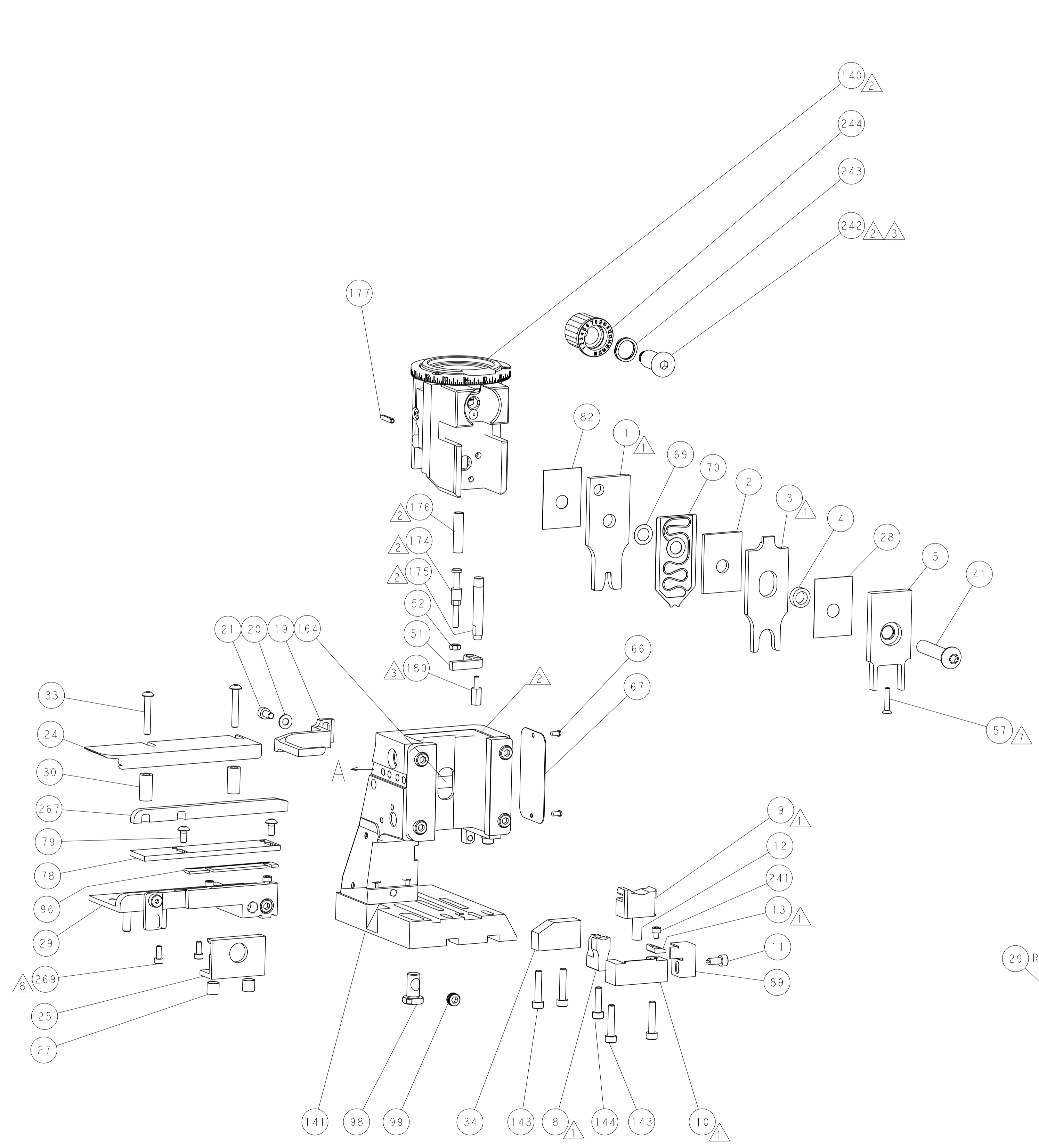
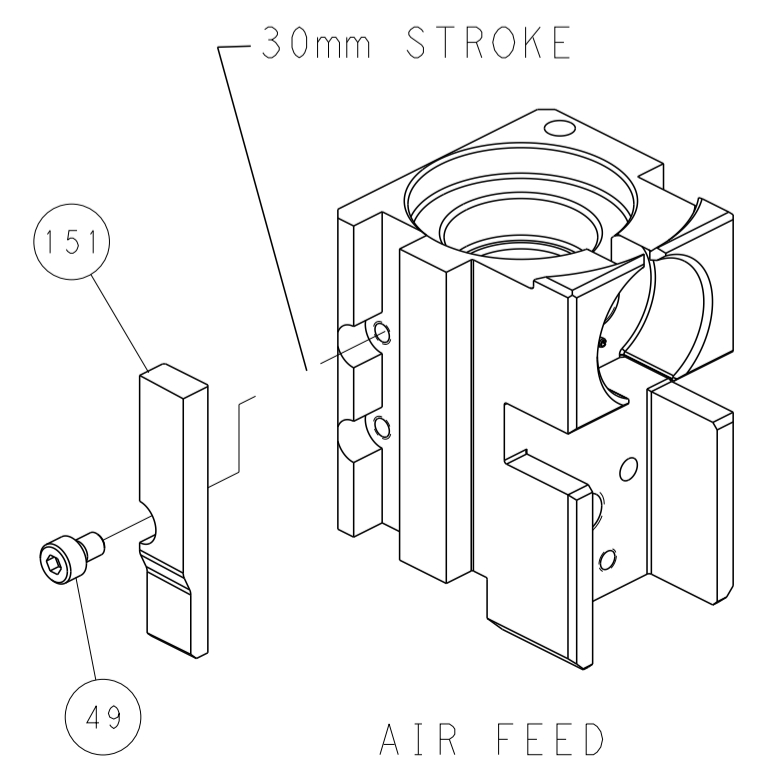
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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 ± MATERIAL: - FINISH: -	APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SHEET: 4 OF 4 REV: B	Customer Accessible Production Drawing	