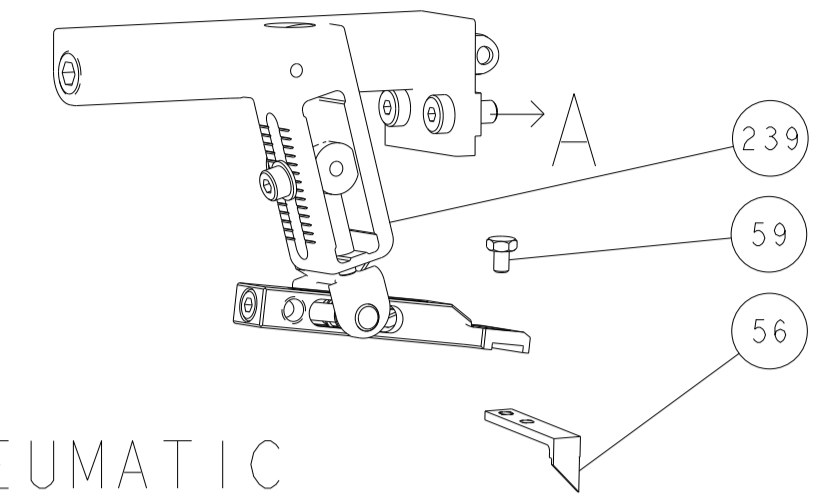


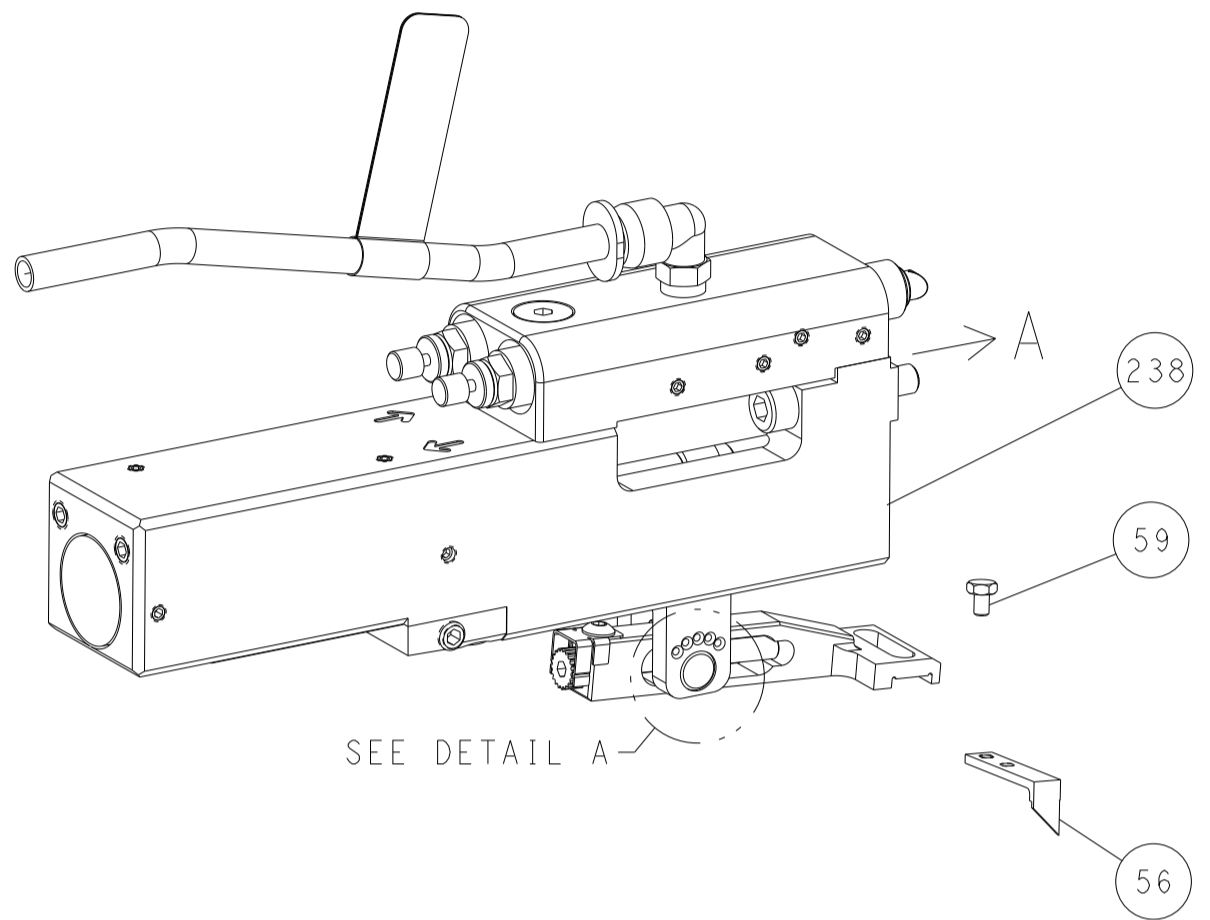


LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

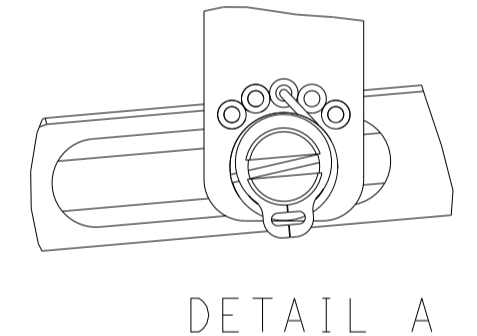
# FEED TYPE MECHANICAL



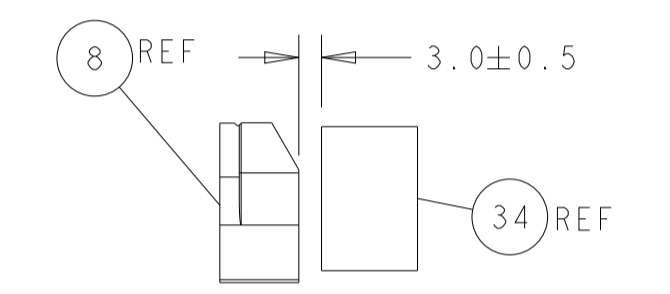
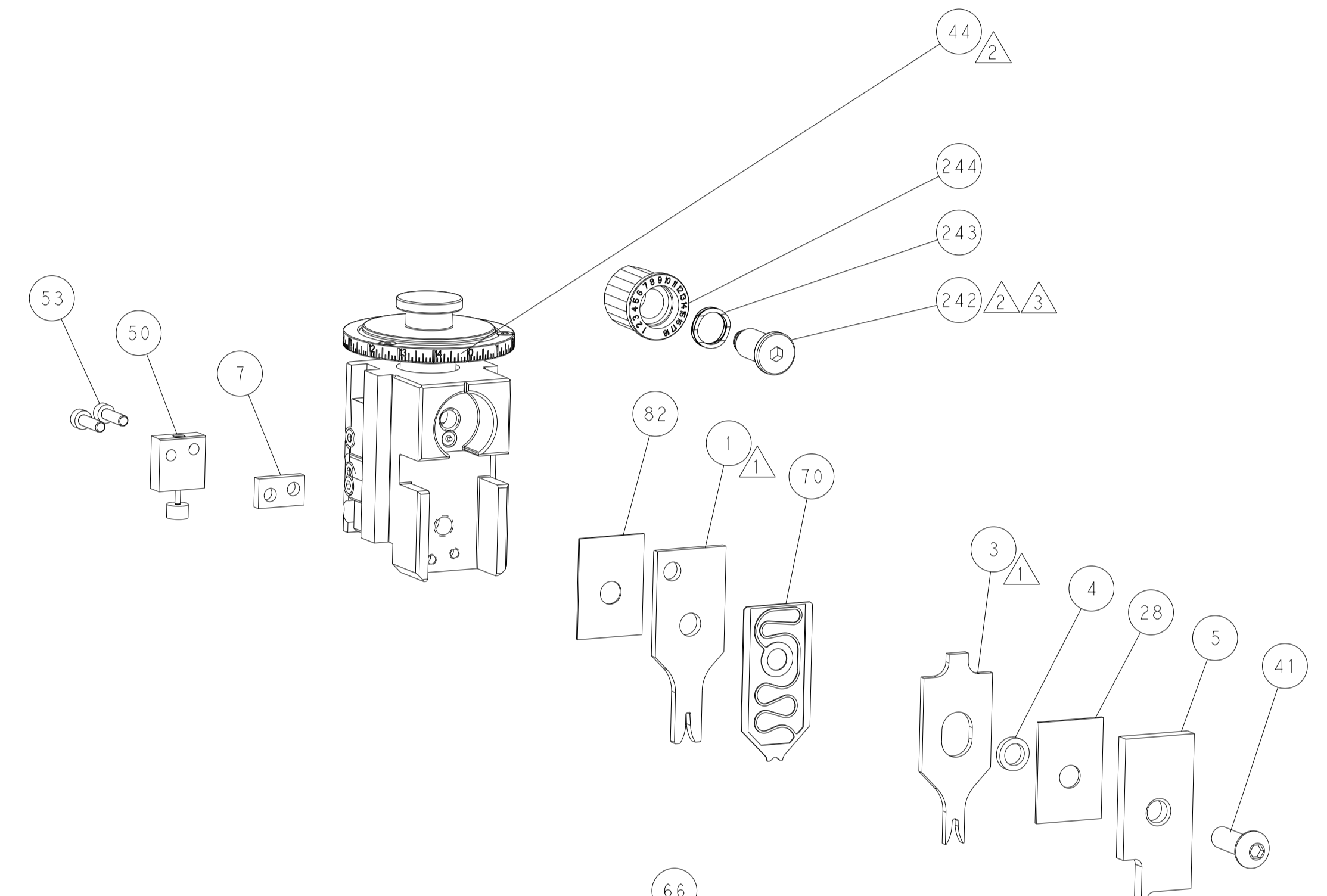
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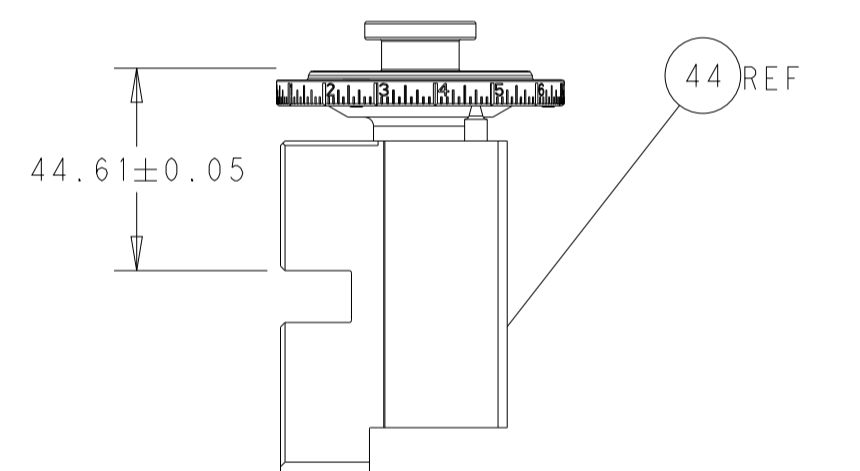
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



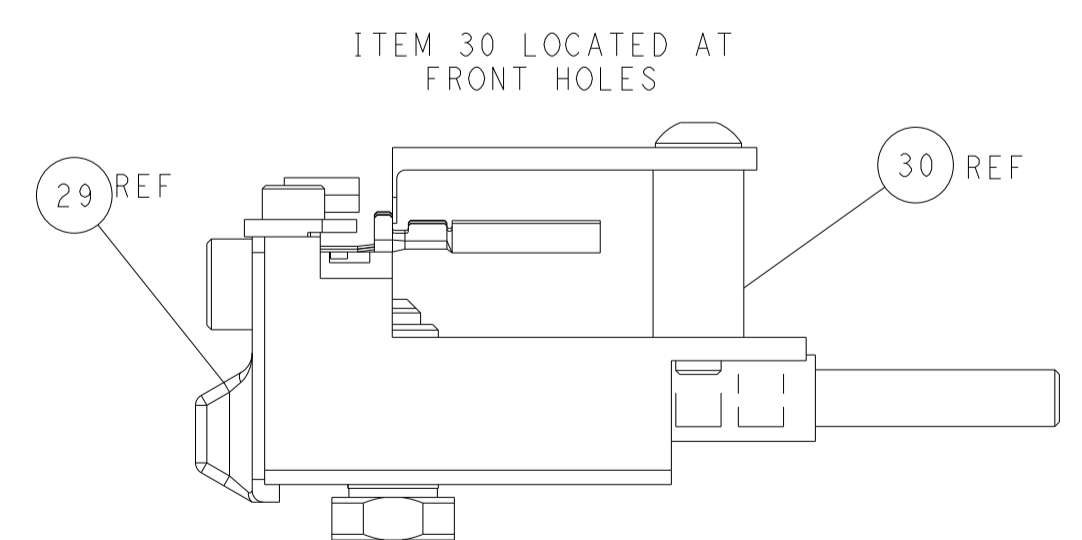
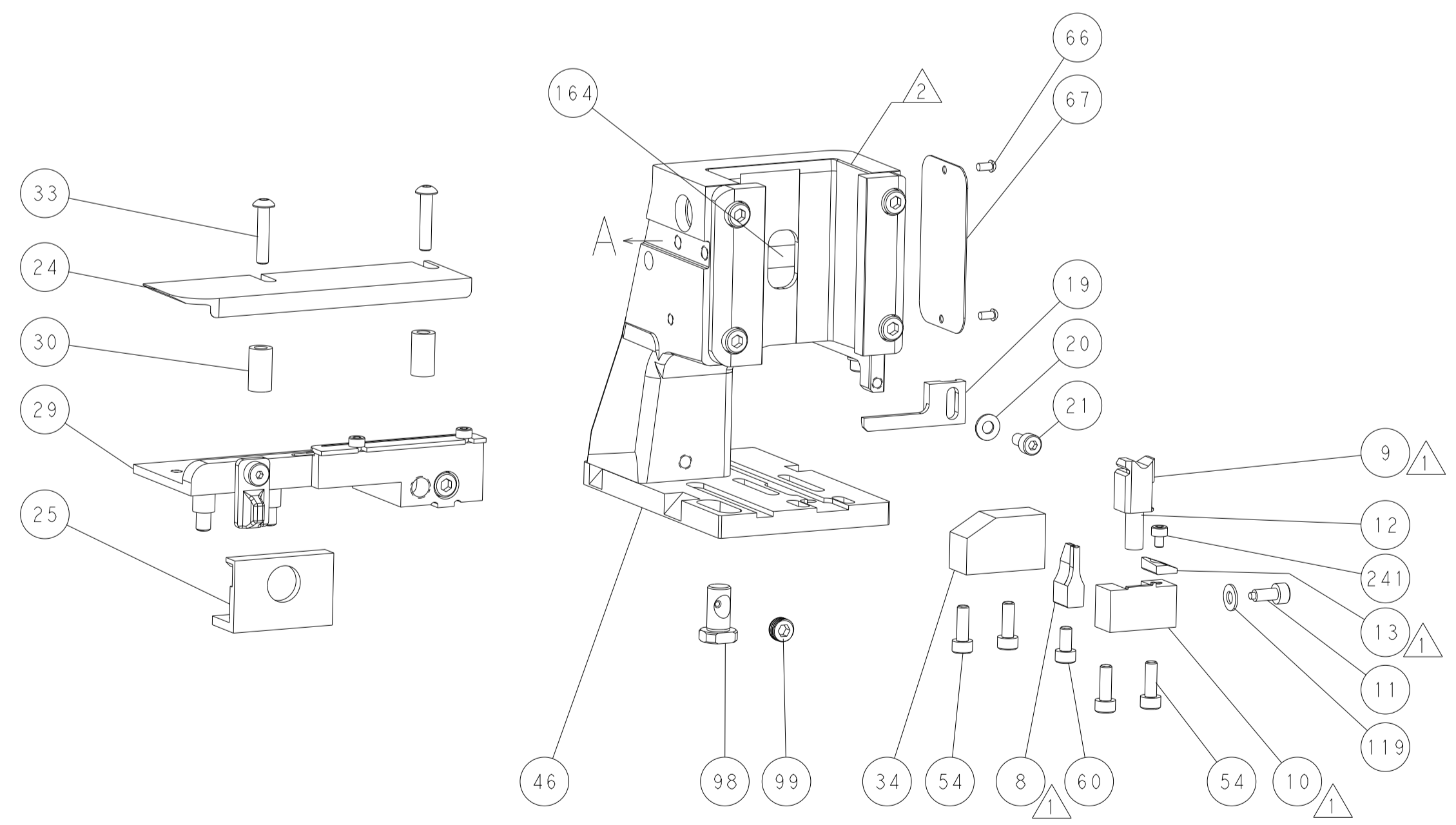
DETAIL A



TERMINAL SUPPORT LOCATION

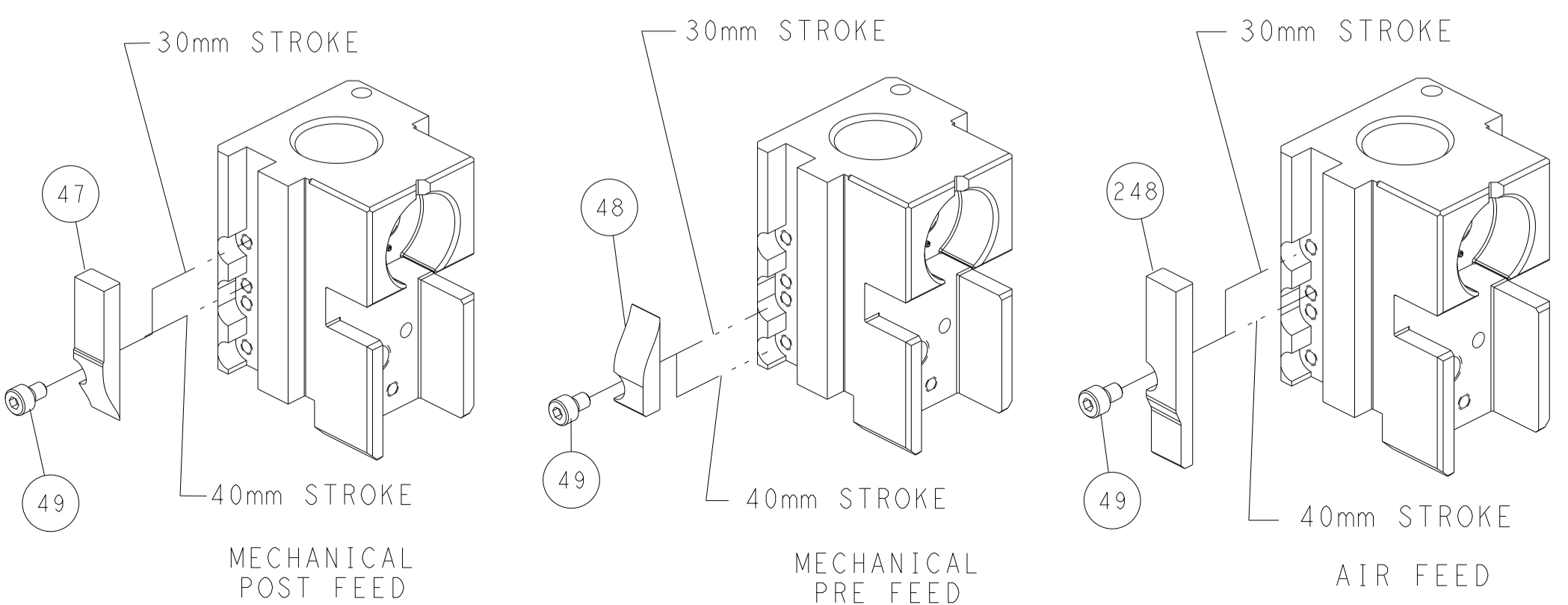


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

# 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:		DWG		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	DATE	NAME	Harrisburg, PA 17105-3608
	3 PLC ±	4 PLC ±	5 PLC ±	G. BAILEY	04MAR2013		
	6 PLC ±	7 PLC ±	8 PLC ±	U. GUO	04MAR2013	Ocean Side Feed Applicator	
	9 PLC ±	10 PLC ±	11 PLC ±				
	12 PLC ±	13 PLC ±	14 PLC ±				
	15 PLC ±	16 PLC ±	17 PLC ±				
	18 PLC ±	19 PLC ±	20 PLC ±				
	21 PLC ±	22 PLC ±	23 PLC ±				
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	36 PLC ±	37 PLC ±	38 PLC ±				
	39 PLC ±	40 PLC ±	41 PLC ±				
	42 PLC ±	43 PLC ±	44 PLC ±				
	45 PLC ±	46 PLC ±	47 PLC ±				
	48 PLC ±	49 PLC ±	50 PLC ±				
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	78 PLC ±	79 PLC ±	80 PLC ±				
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	87 PLC ±	88 PLC ±	89 PLC ±				
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	495 PLC ±	496 PLC ±	497 PLC ±				
	498 PLC ±	499 PLC ±	500				

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151420-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151420-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151420-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.48 mm [.098]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: 1.5 X 0.8 FEMALE TERMINAL			
WIRE STRIP LENGTH 4.30-4.70 mm [1.69-.185 IN]		INSULATION DIAMETER RANGE Ø1.30-2.10 mm [.051-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	211FT0463	-	-
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1572993-2	211CC2S1150P	1572993-5	211CC2S1190P
1572993-1	211CC2S1160P	1572993-3/2278049-1	211CC2S1460P

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35+0.35	1.24+/-0.04 [.049+/-0.0016]	4.4
0.50mm2	1.17+/-0.04 [.046+/-0.0016]	5.1
0.35mm2	1.09+/-0.04 [.043+/-0.0016]	6.0

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- 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	REV	DATE	BY	APPD
A	66	-	-	-	-

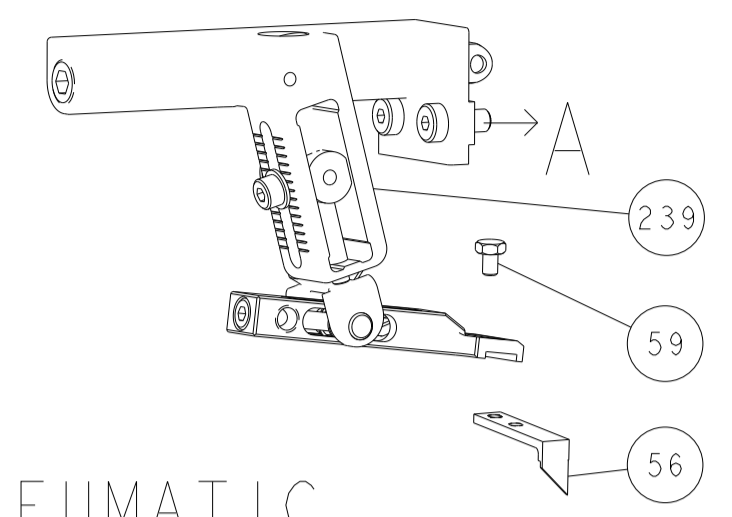
REV	DATE	DESCRIPTION	DATE	BY	APPD
-	1 1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1 1	2119083-1	RETAINER, INSULATION DIAL	242
-	1 1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1 -	2844940-1	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	
-	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	455888-6	SPACER, CRIMPER	82	
-	1 1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1 1	2119791-9	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	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	2844992-4	ASSEMBLY, STRIP GUIDE	29	
-	1 1	1-455888-0	SPACER, CRIMPER	28	
-	1 1	240792-1	DRAG, TERMINAL	25	
-	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	2119805-1	SHEAR HOLDER, FRONT	10	
-	1 1	1803095-1	FLOATING SHEAR, FRONT	9	
1	1 1	1-1633918-1	ANVIL, COMBINATION	8	
-	1 1	240641-1	SPACER	7	
-	-	-	-	6	
-	1 1	1-2119757-1	DEPRESSOR, SHEAR	5	
-	1 1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1 1	3-2119785-7	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	-	-	-	2	
1	1 1	5-456403-1	CRIMPER, WIRE PREMIUM	1	

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

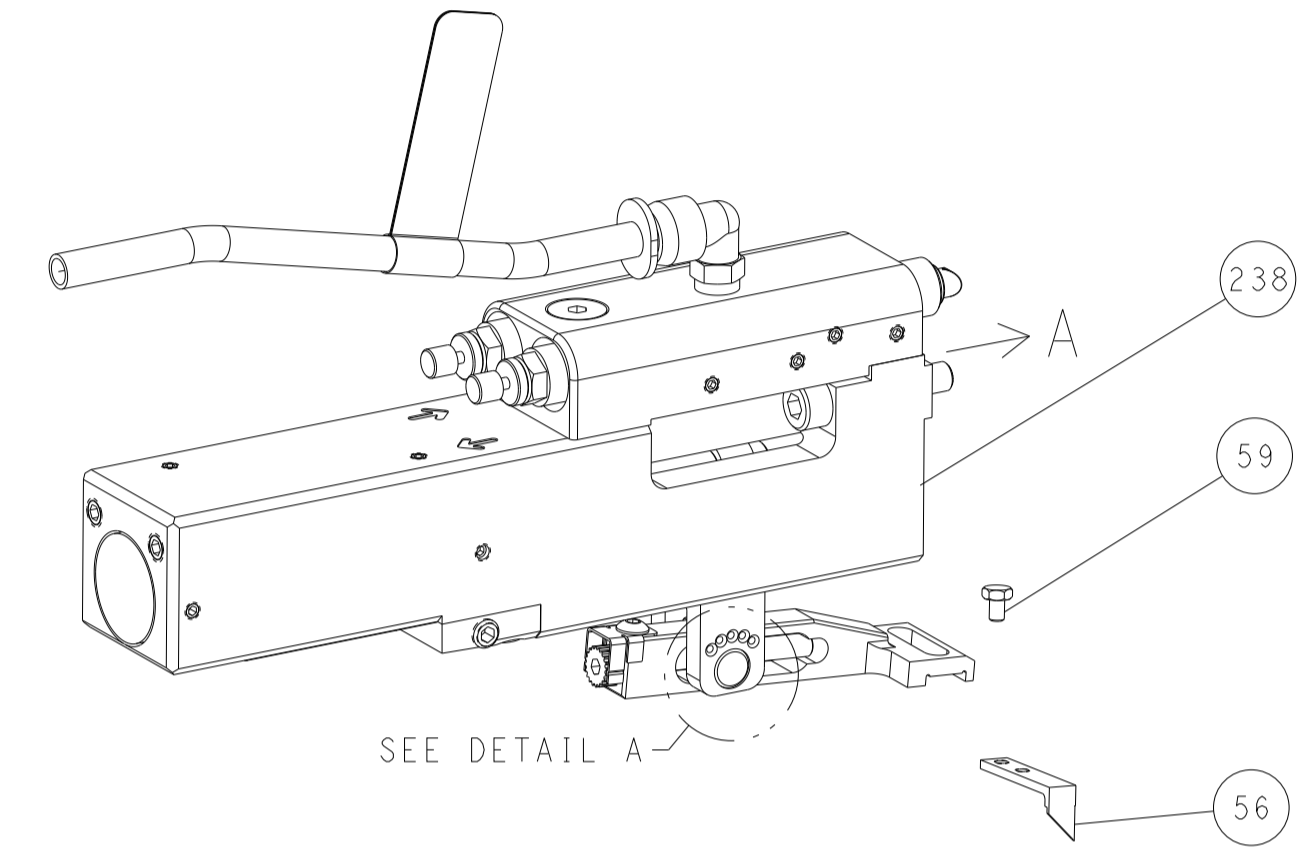
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG Y. YIN 04MAR2013		CHK G. BAILEY 04MAR2013		NAME U. GUO 04MAR2013		APPLICATOR	
0 PLC	±	1 PLC	±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	Customer Accessible Production Drawing			
2 PLC	±	3 PLC	±	SCALE	1:2	SHEET 3 OF 4	REV D1				
4 PLC	±	ANGLES	±	WEIGHT	00779	©=2151420					
FINISH	±										

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPROV
-	SEE SHEET 1	-	-	-	-

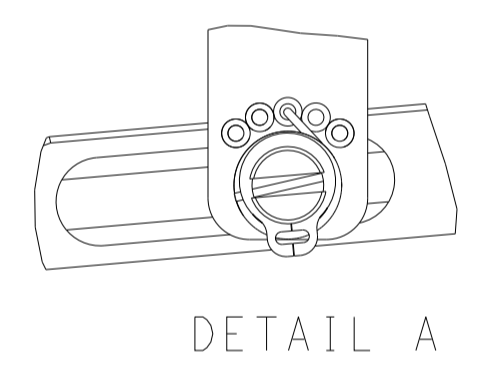
# FEED TYPE MECHANICAL



## PNEUMATIC

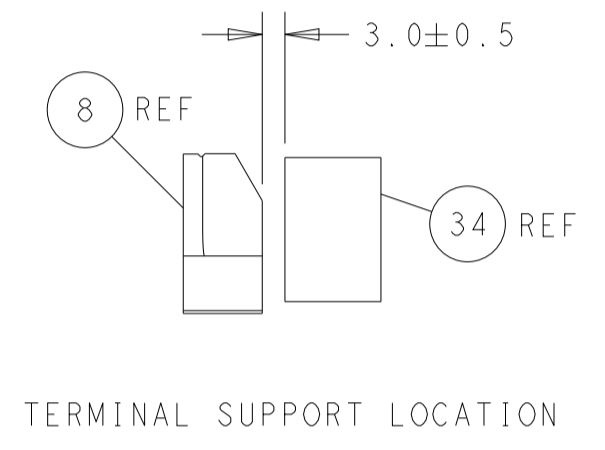
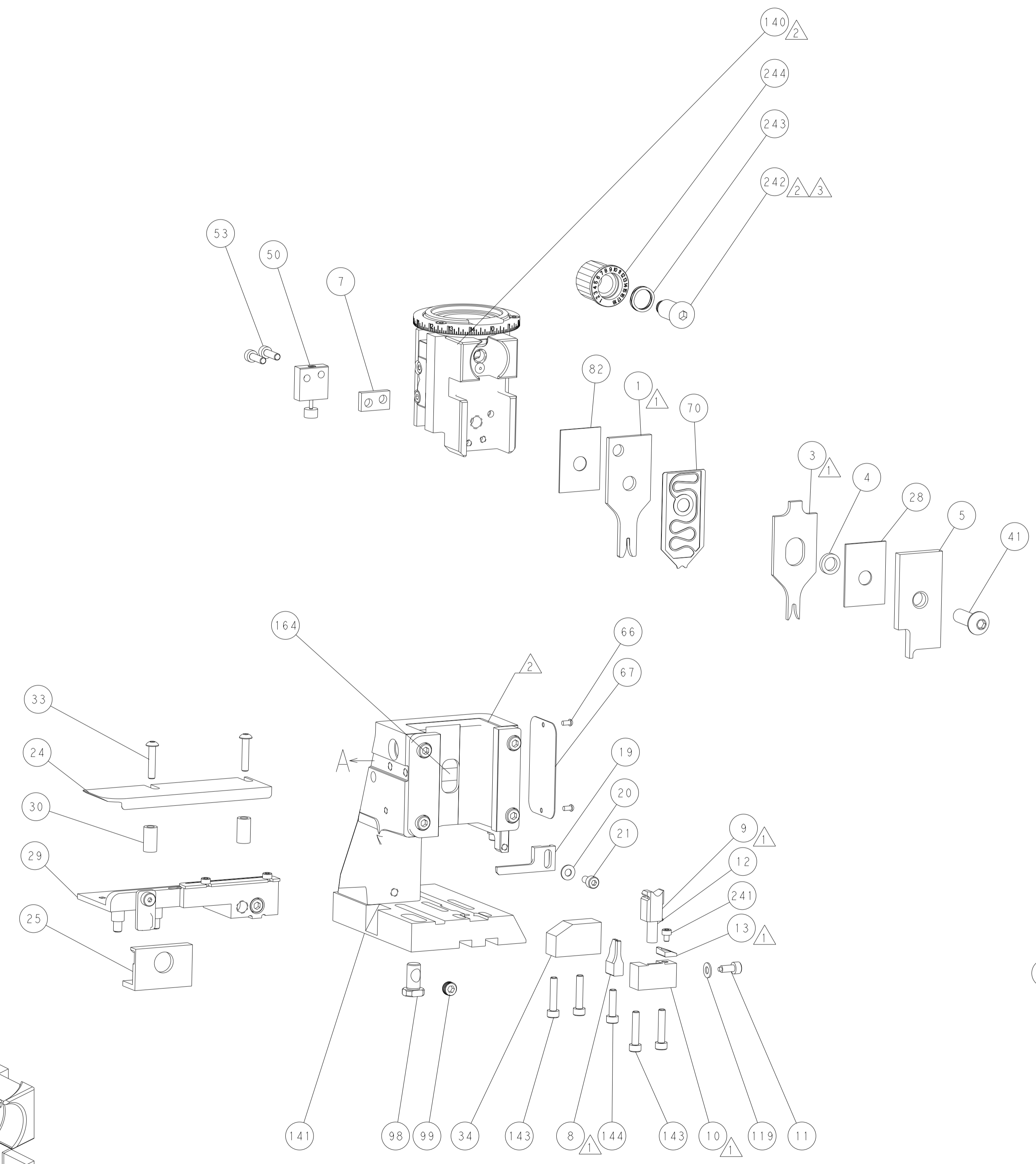
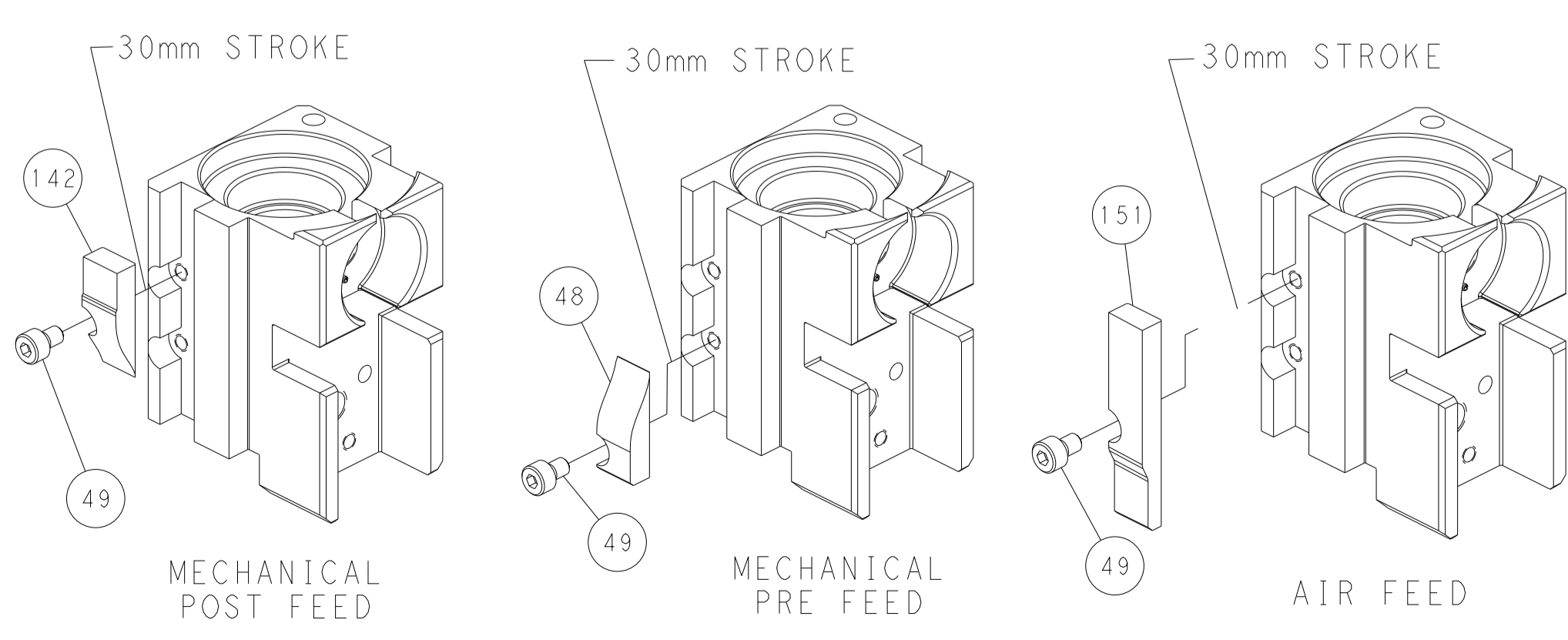


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

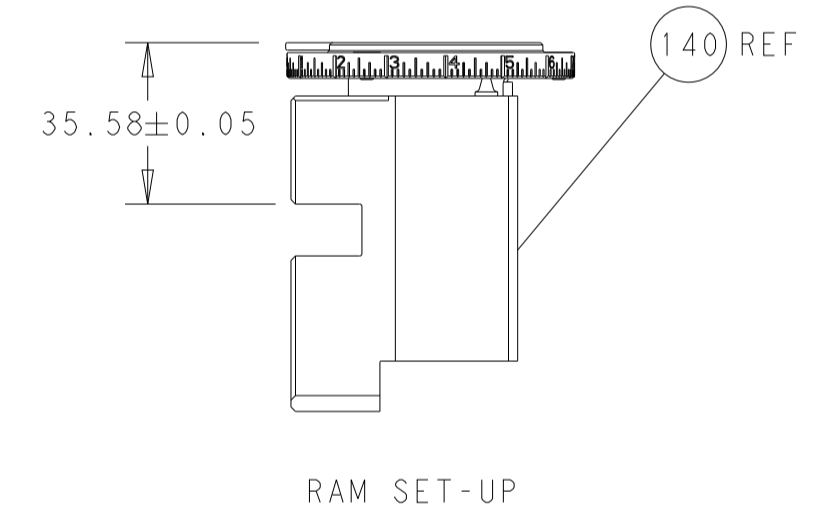


DETAIL A

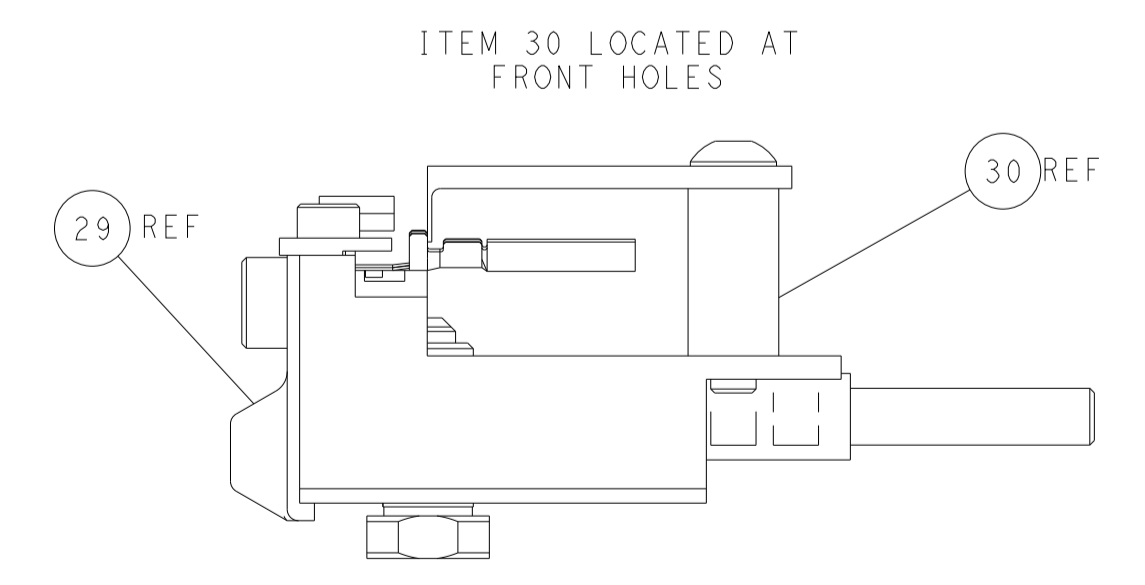
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF COMPANY AND CONTAINS PROPRIETARY INFORMATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED BY THE COMPANY. IT IS NOT TO BE REPRODUCED, COPIED, OR DISCLOSED TO ANY OTHER PERSON OR ORGANIZATION WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN Y. YIN 04MAR2013 CHK G. BAILEY 04MAR2013 APVD U. GUO 04MAR2013	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	RESTRICTED TO
MATERIAL	WEIGHT	SIZE CAGE CODE DRAWING NO A1 00779 C=2151420	SCALE 1:2 SHEET 4 OF 4 REV D1
Customer Accessible Production Drawing		Customer Accessible Production Drawing	