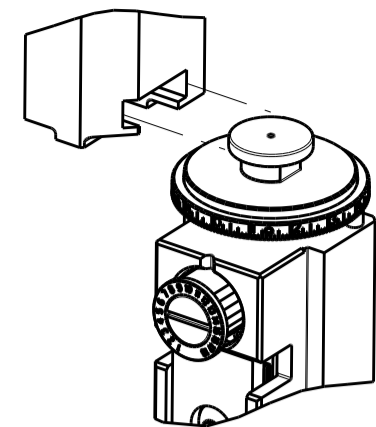


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151693-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151693-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151693-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



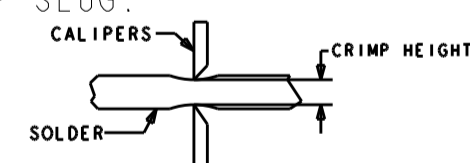
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.136 [3.45 mm]	D
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

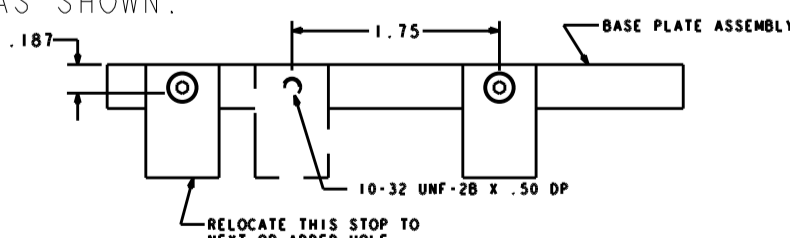
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.265-.297 IN [6.73-7.54 mm]		∅ .105 MAX	
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
7-520365-2			

WIRE SIZE		CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
22		0.065+/-0.002 [1.65+/-0.05]	6.0	.12 IN [3.05mm]
24 OR 26		0.060+/-0.002 [1.52+/-0.05]	7.4	.12 IN [3.05mm]

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- ITEM 5/22 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.12 IN [3.05mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



- 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.



- ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ITEMS NOT SHOWN.
- ITEM 261 REQUIRED WHEN APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN AMP-O-LECTRIC* TERMINATING UNIT.
- 13. 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
		A		RELEASED	11OCT2012	LG	MC
		B		ECR-17-005267	20APR2017	TB	GB
		C		ECR-18-016937	30OCT2018	JAH	CT
		D		ECR-19-011879	29JUL2019	FZ	TE

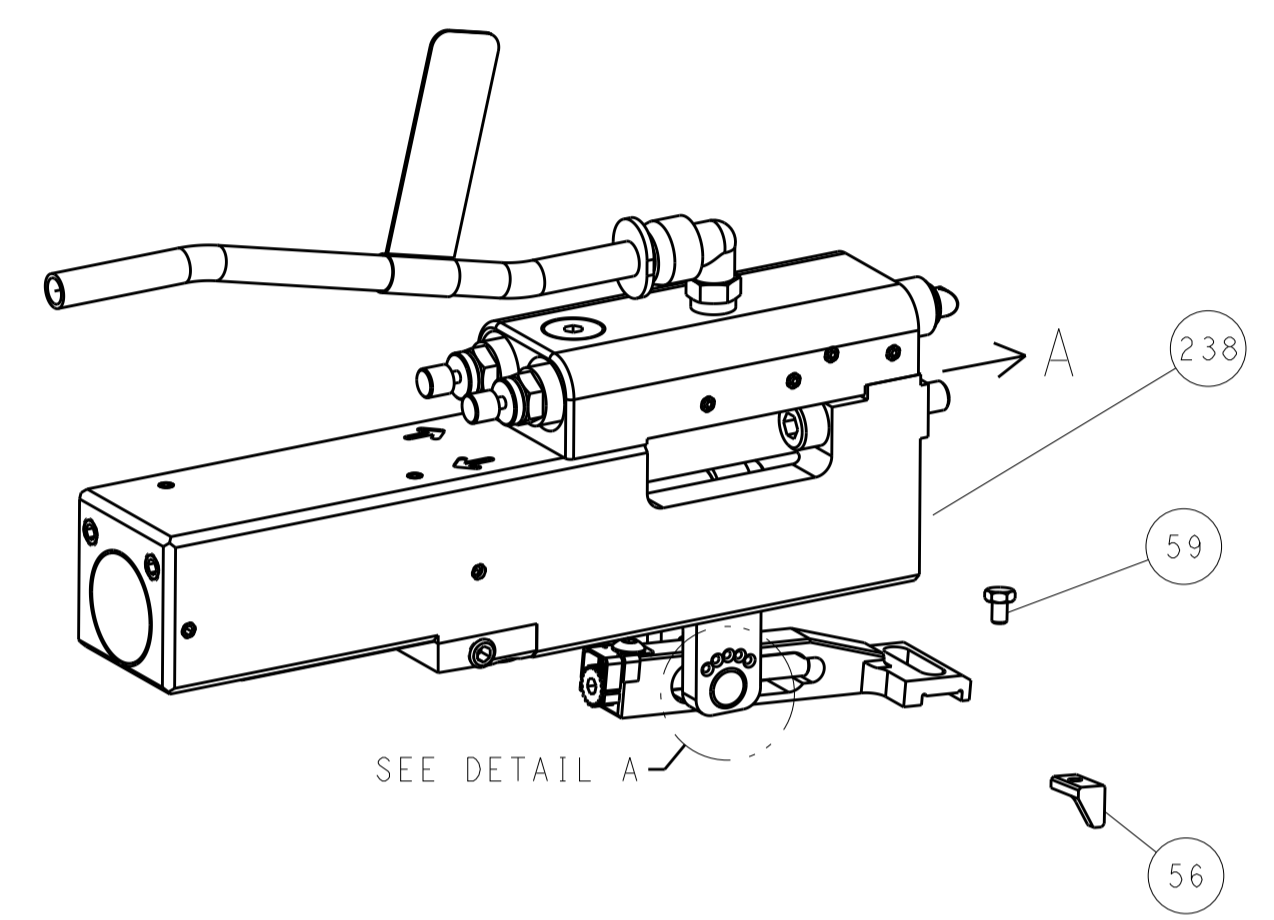
	-	1	1	1-18023-1	SCR, SHC, M4x10		262
	-	1	1	803931-1	BRACKET, HOLD DOWN		261
	-	1	1	462992-7	GUARD ASSEMBLY		257
	-	-	-	679532-1	INSERT, GUARD		256
	-	-	-	189728-1	BRACKET, SPACER		255
	-	-	-	568681-1	SPACER, BASE PLATE		253
	-	1	1	2119641-1	FEED CAM, AIR FEED		248
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
	-	1	1	2844940-1	AIR FEED MODULE		238
	-	REF	REF	994970-2	COUNTER, MAGNETIC		164
	-	1	1	1-22281-8	SPRING, COMPRESSION		121
	-	1	1	2844908-1	SCREW, LOCKING		99
	-	1	1	2844907-1	POST, LOCKING		98
	-	1	1	1-690438-0	FRONT STRIP GUIDE		96
	-	6	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
	-	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	2161332-3	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		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
	-	1	1	462433-9	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	462431-6	WIRE FUNNEL		22
	-	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	469542-3	REAR FLOATING SHEAR		17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6		16
	-	1	1	2161335-2	SHEAR PLATE, REAR		15
	-	1	1	2119862-2	SHEAR HOLDER, REAR		14
	-	1	1	2280441-1	INSERT, SHEAR		13
	-	1	1	3-22280-3	SPRING, COMPRESSION		12
	-	1	1	356885-4	STOP, SHEAR		11
	-	1	1	462843-8	TERMINAL SUPPORT		9
	1	2	1	464291-6	ANVIL, SAND-BLASTED 22-18		8
	-	1	1	803925-2	GUIDE, CARRIER SCRAP		7
	-	1	1	2-690468-5	DEPRESSOR SHEAR, REAR		6
	-	1	1	462431-3	WIRE FUNNEL		5
	-	1	1	2-238011-2	BLOCK, CRIMPER SPACER		4
	1	2	1	464290-2	CRIMPER, SEMI-FLAT 22-18		1

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

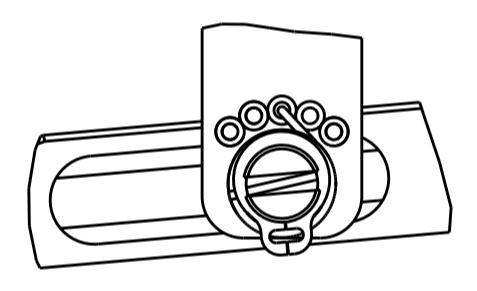
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

FEED TYPE PNEUMATIC

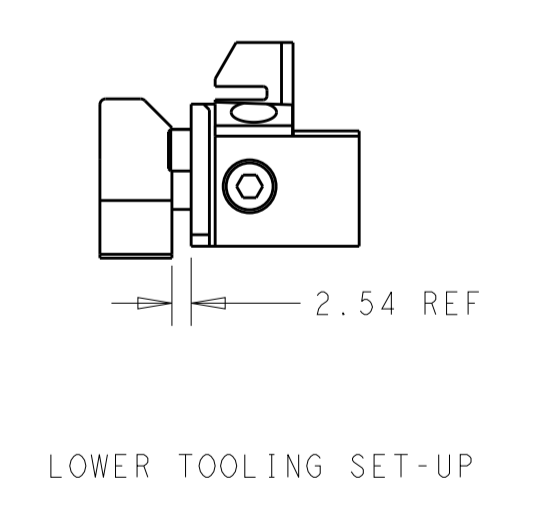
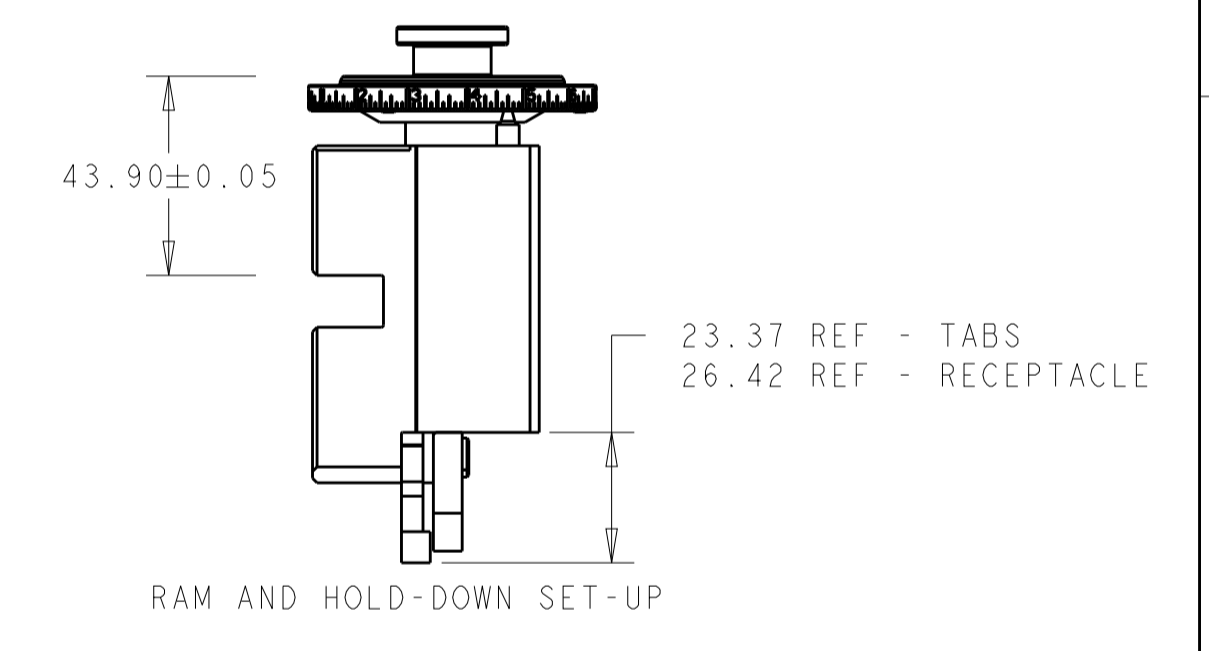
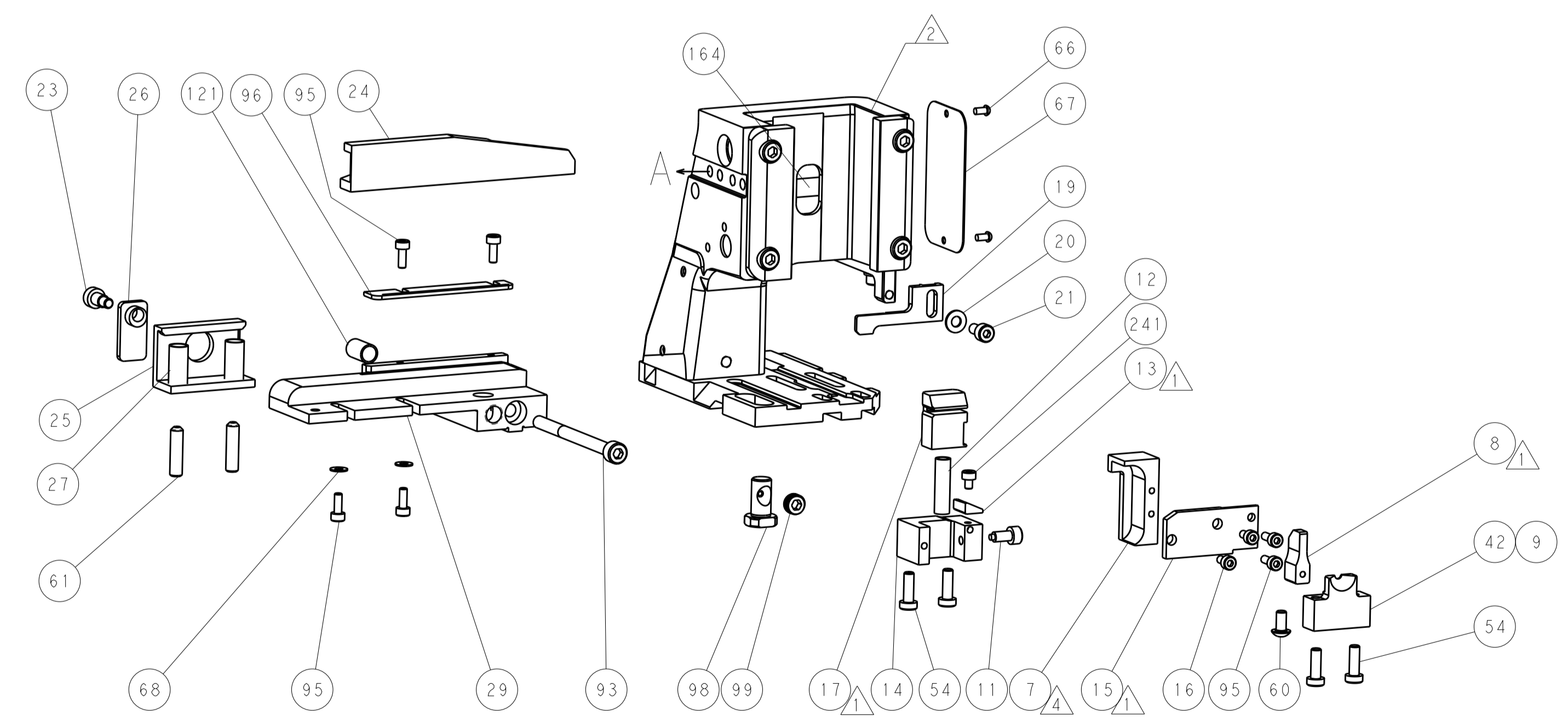
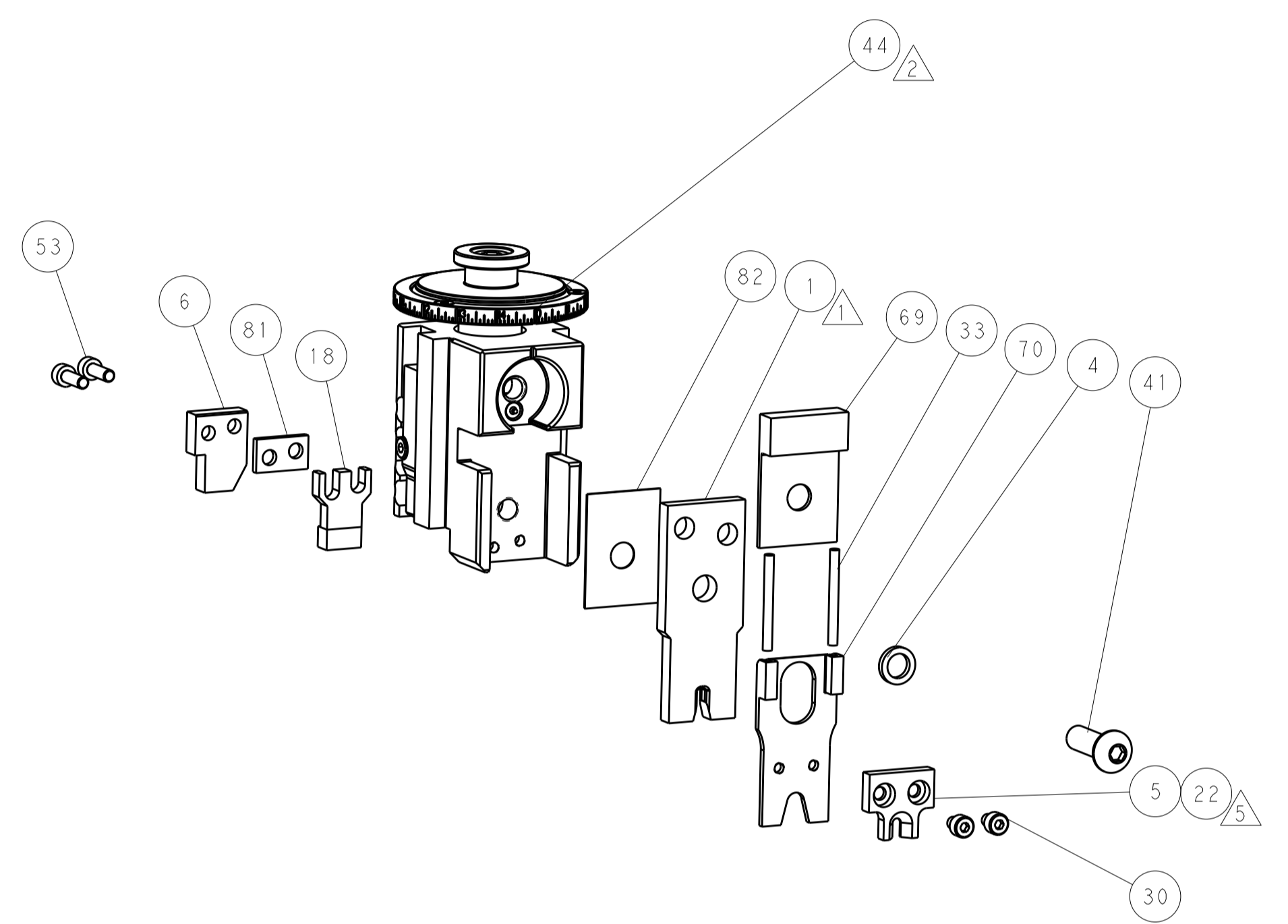
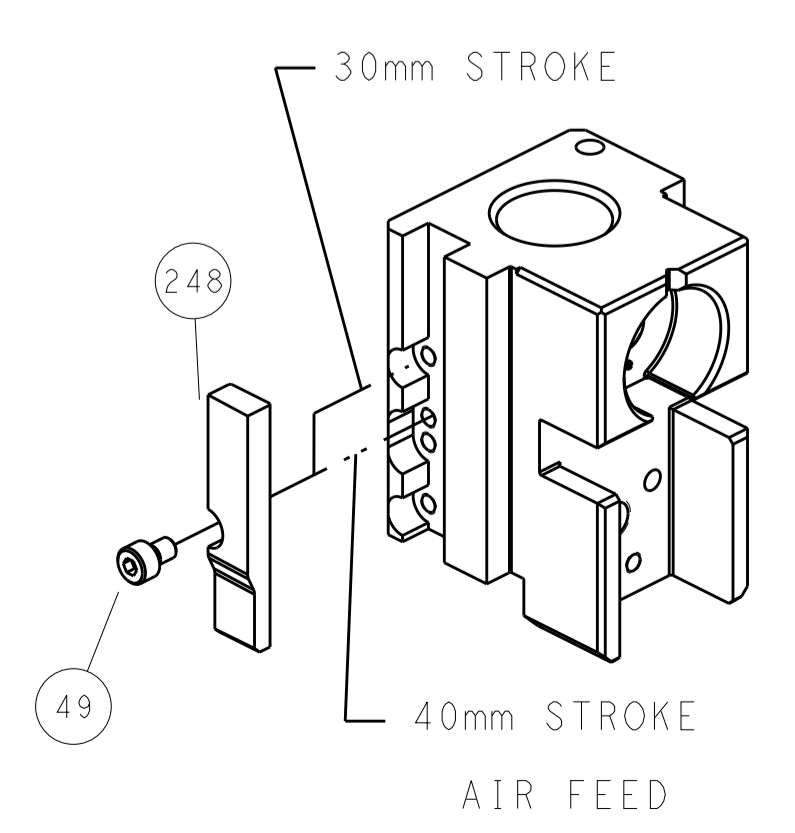


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS

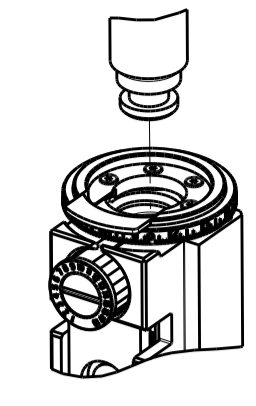


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN B. WEAVER 12JUN2012 CHK G. HOFFNER 12JUN2012 APVD T. ELBIN 12JUN2012		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151693		RESTRICTED TO: - SCALE: 1:1 SHEET: 2 OF 4 REV: D	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING					

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151693-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151693-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.136 [3.45 mm]	D
INSUL	-	-

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.265-.297 IN [6.73-7.54 mm]		∅ .105 MAX	
TERMINAL APPLICATION SPECIFICATION	114-2123		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
7-520365-2			

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
22	0.065+/-0.002 [1.65+/-0.05]	6.0	.12 IN [3.05mm]
24 OR 26	0.060+/-0.002 [1.52+/-0.05]	7.4	.12 IN [3.05mm]

- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - 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.
 - ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
 - ITEM 5/22 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
 - TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.12 IN [3.05mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
- Diagram illustrating crimp height measurement using calipers. The crimp height is measured from the top of the wire to the top of the solder. The base plate assembly includes a 10-32 hole for relocation.
- 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.
 - ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
 - 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.
 - TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - ITEMS NOT SHOWN.
 - ITEM 261 REQUIRED WHEN APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN AMP-O-LECTRIC™ TERMINATING UNIT.
13. 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	-	-	-

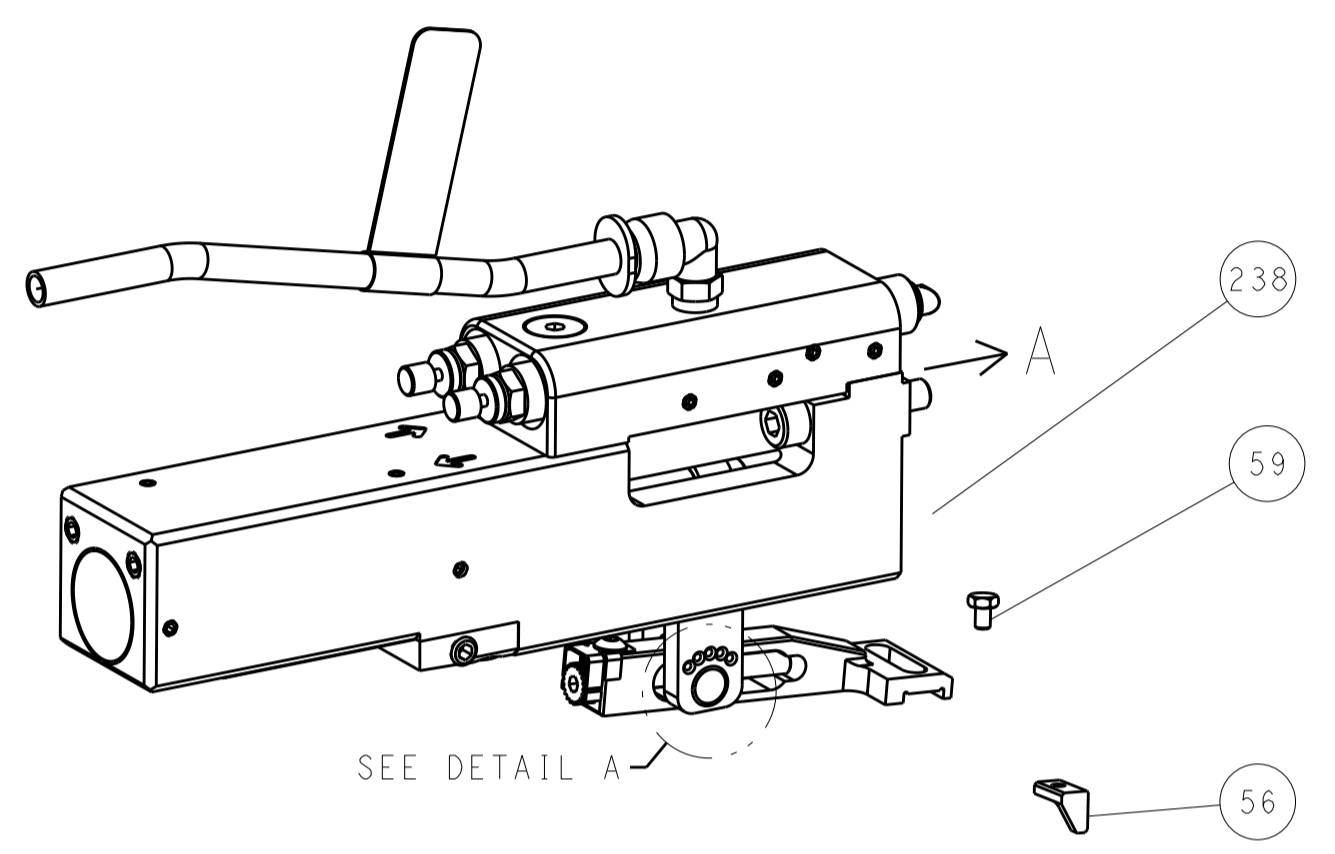
	-	1	1-18023-1	SCR, SHC, M4x10	262
	-	1	803931-1	BRACKET, HOLD DOWN	261
	-	1	462992-7	GUARD ASSEMBLY	257
	-	-	679532-1	INSERT, GUARD	256
	-	-	189728-1	BRACKET, SPACER	255
	-	-	568681-1	SPACER, BASE PLATE	253
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1		2844940-1	AIR FEED MODULE	238
-	1		1-18028-0	WASHER, FLAT, REG M8	192
-	REF		994970-2	COUNTER, MAGNETIC	164
-	1		2119641-2	FEED CAM, AIR FEED	151
-	1		2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4		2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1		2-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1		1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1		1-22281-8	SPRING, COMPRESSION	121
-	1		2844908-1	SCREW, LOCKING	99
-	1		2844907-1	POST, LOCKING	98
-	1		1-690438-0	FRONT STRIP GUIDE	96
-	6		2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1		2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1		455888-4	SPACER, CRIMPER	82
-	1		240641-9	SPACER	81
-	1		1803607-3	DOCUMENTATION PACKAGE	71
-	1		2161332-3	DEPRESSOR, WIRE FUNNEL	70
-	1		2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
-	2		1-18028-4	WASHER, FLAT, REG M3	68
-	1		2119740-1	TAG, IDENTIFICATION	67
-	2		2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2		2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1		5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1		462427-2	FINGER, FEED	56
-	2		2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1		18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	462433-9	SUPPORT, INSULATION	42
-	1		1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2		5-22278-1	SPRING, COMPRESSION	33
-	2		1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
-	1		2161336-2	PLATE, REAR STRIP GUIDE	29
-	2		22281-9	SPRING, COMPRESSION	27
-	1		356835-1	LEVER, DRAG RELEASE	26
-	1		240792-1	DRAG, TERMINAL	25
-	1		684042-4	GUIDE, STRIP, FRONT	24
-	1		980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	462431-6	WIRE FUNNEL	22
-	1		2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1		1-18028-2	WASHER, FLAT, REG M4	20
-	1		2119533-1	STRIPPER, SIDE FEED	19
-	1		463460-2	HOLD DOWN, TERMINAL	18
	-	1	469542-3	REAR FLOATING SHEAR	17
-	2		1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	-	1	2161335-2	SHEAR PLATE, REAR	15
-	1		2119862-2	SHEAR HOLDER, REAR	14
	-	1	2280441-1	INSERT, SHEAR	13
-	1		3-22280-3	SPRING, COMPRESSION	12
-	1		356885-4	STOP, SHEAR	11
	-	1	462843-8	TERMINAL SUPPORT	9
	1	1	464291-6	ANVIL, SAND-BLASTED 22-18	8
	-	1	803925-2	GUIDE, CARRIER SCRAP	7
-	1		2-690468-5	DEPRESSOR SHEAR, REAR	6
	-	1	462431-3	WIRE FUNNEL	5
-	1		2-238011-2	BLOCK, CRIMPER SPACER	4
	1	1	464290-2	CRIMPER, SEMI-FLAT 22-18	1

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

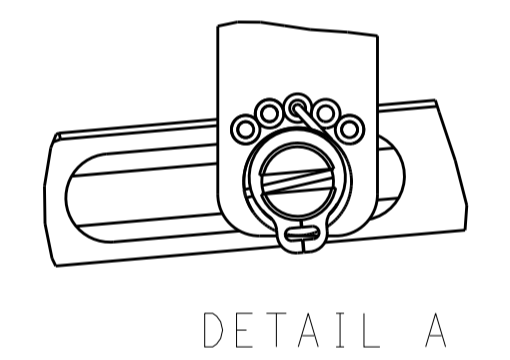
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN: B. WEAVER 12JUN2012 CHK: G. HOFENER APVD: T. ELBIN 12JUN2012		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151693		RESTRICTED TO: D	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		SHEET 3 OF 4	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION					

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

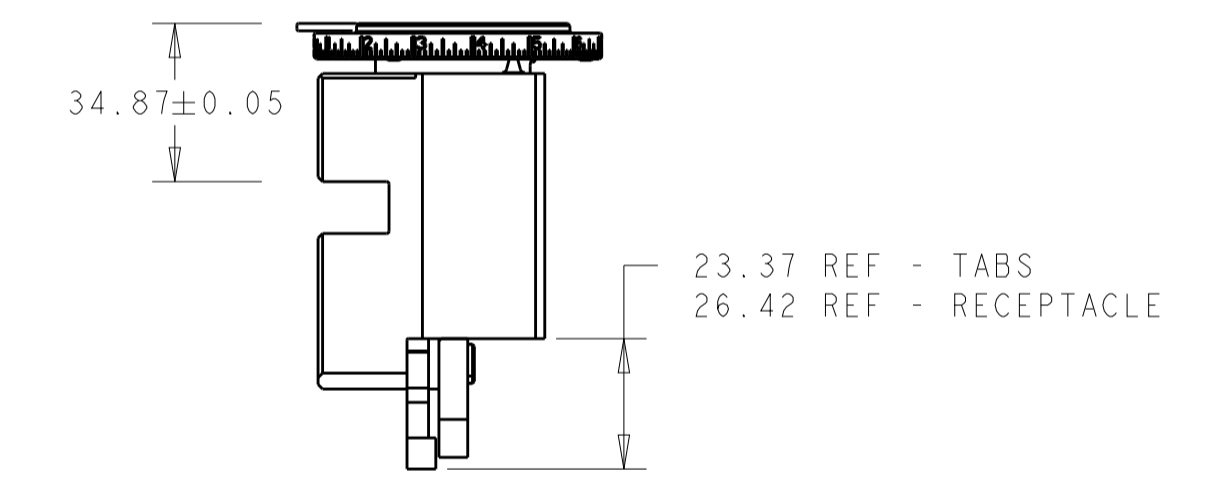
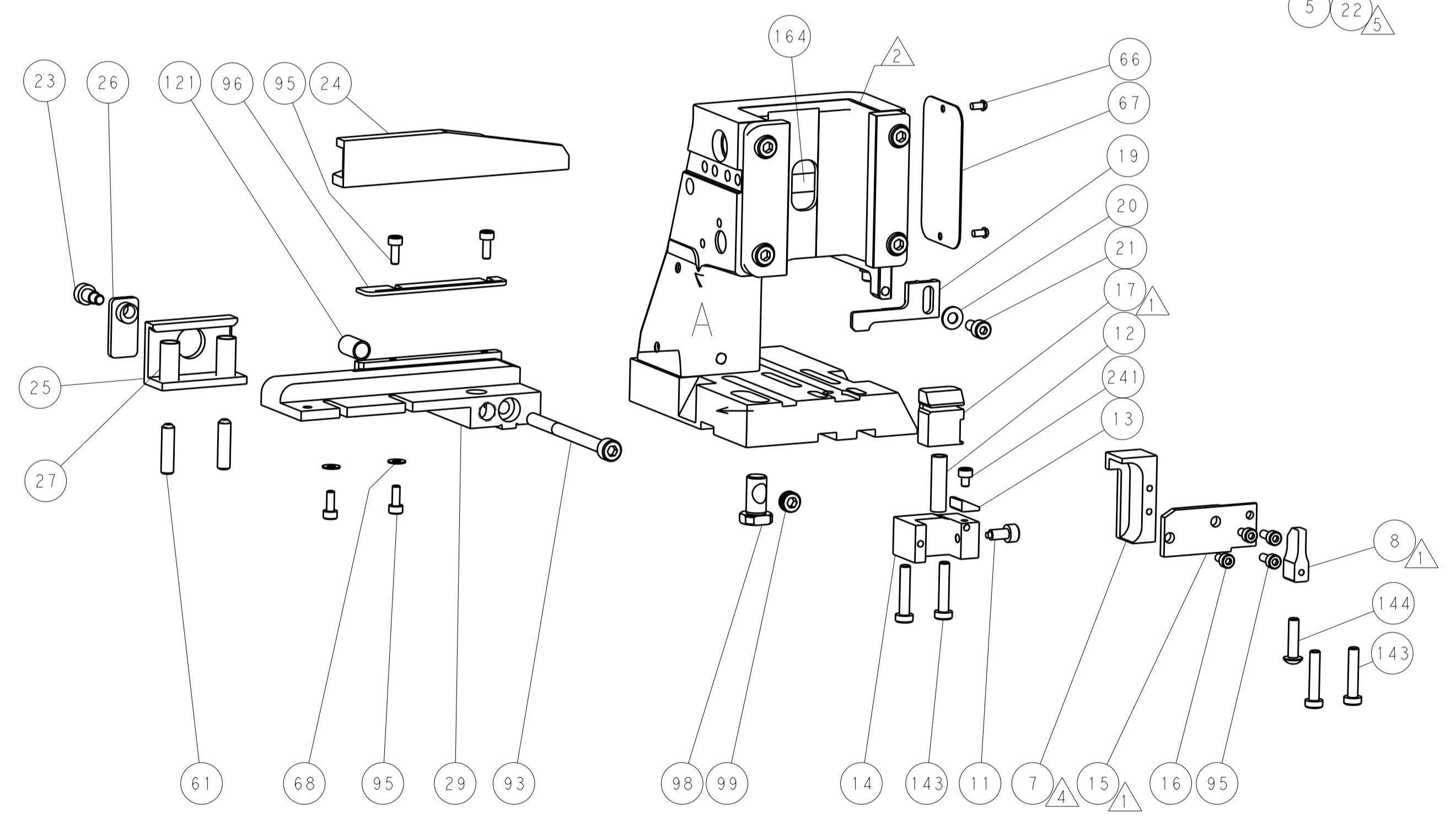
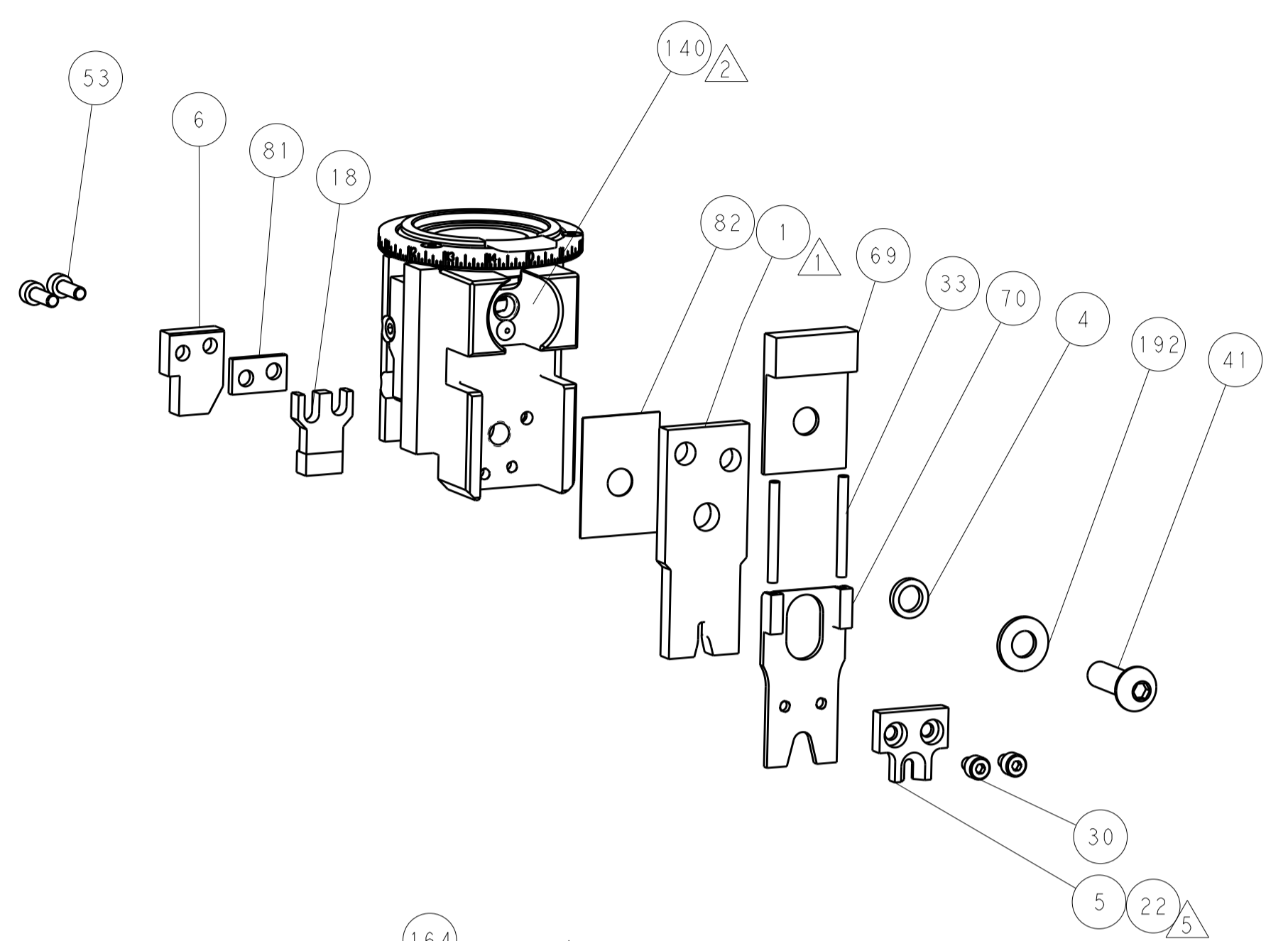
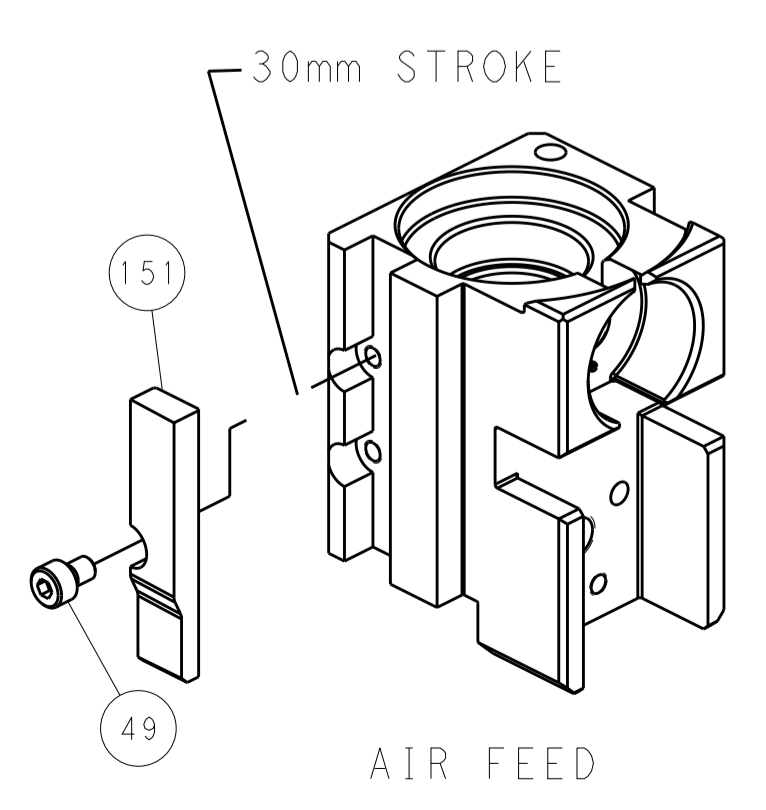
FEED TYPE PNEUMATIC



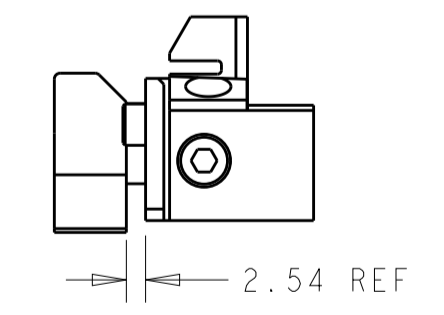
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



RAM AND HOLD-DOWN SET-UP



LOWER TOOLING SET-UP

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

<small>THE DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2012. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF ANY KIND. REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: B. WEAVER 12JUN2012 CHK: G. HOFFNER 12JUN2012 APVD: T. ELBIN 12JUN2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151693	RESTRICTED TO:
MATERIAL: FINISH:		WEIGHT: CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE: 1:1 SHEET 4 OF 4 REV D