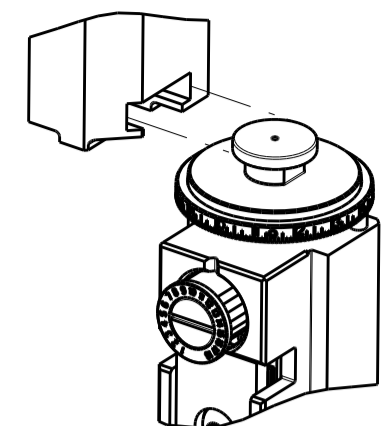


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151817-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151817-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151817-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

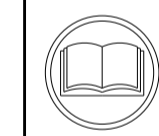


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.06 mm [.160]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPT LITEALUM CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.40-4.00 mm [.134-.157 IN]		Ø 3.56-3.74mm [.140-.147 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94204		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-1862001-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	1.90±0.04 [.0748±.0016]	8.2



- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

**\*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			
		REV	DATE	BY	APPV
A	66	D	14OCT2015	DJG	DS
		E	03MAR2016	JH	CT
		F	23SEP2016	JH	CT
		G	17DEC2019	FZ	TE

-	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	268
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-1	AIR FEED MODULE	238
-	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
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	455888-3	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2-1803583-3	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1-1752356-2	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1320928-2	STRIP GUIDE	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	690472-2	STRIPPER	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	2161316-2	ANVIL, COMBINATION	8
-	1	1	2-240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	1-1722335-0	SHEAR DEPRESSOR ASSEMBLY	5
-	1	1	5-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1722335-8	CRIMPER, INSULATION F	3
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-	1	2	2217302-2	CRIMPER, WIRE, CONICAL BLEND	1
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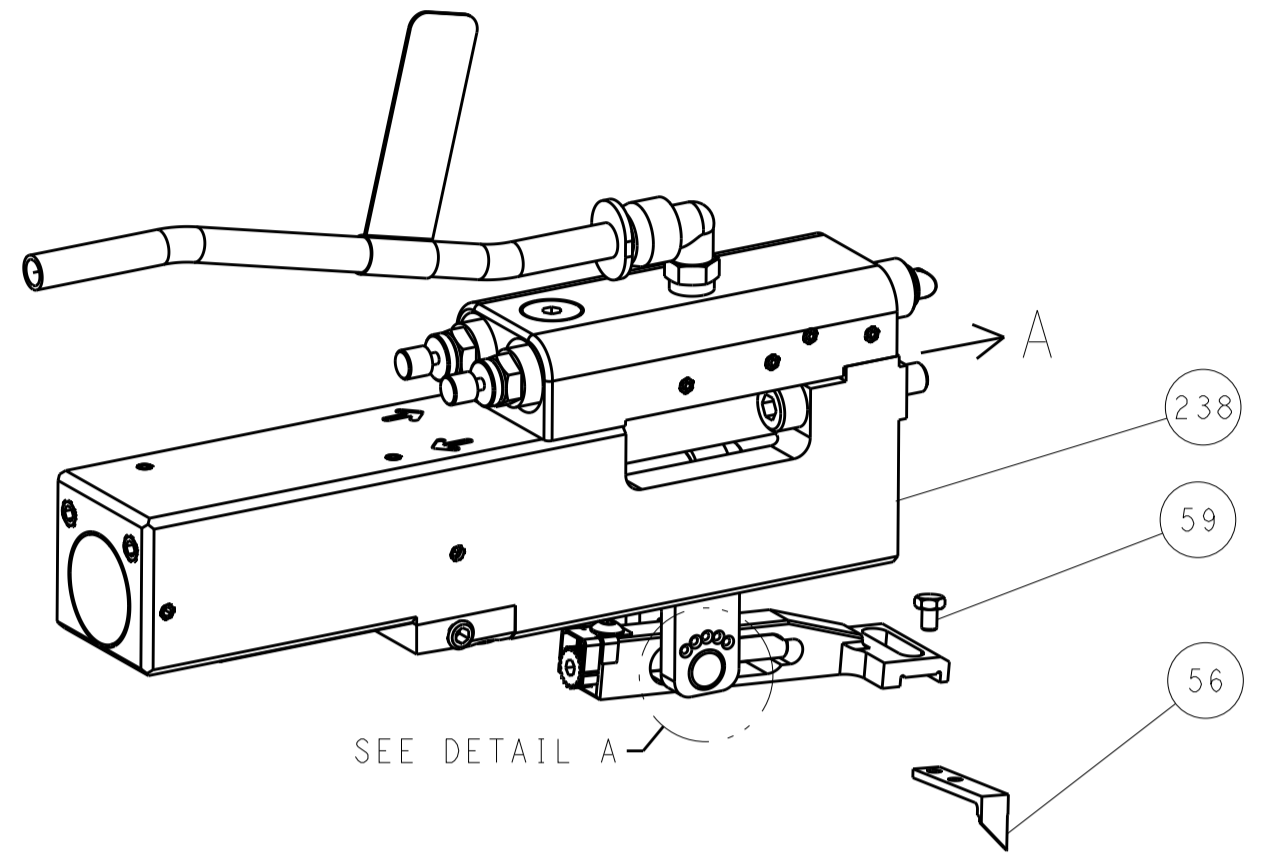
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		SCALE	
mm	PLC	mm	PLC	mm	PLC	mm	PLC
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4	PLC	±	PLC	00779	0	1:2	1 of 4
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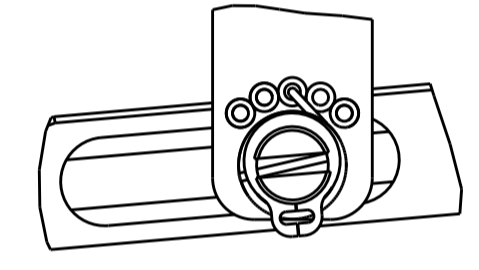
REVISONS		DATE	DWN	APVD			
LOC	DIST	P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

### FEED TYPE

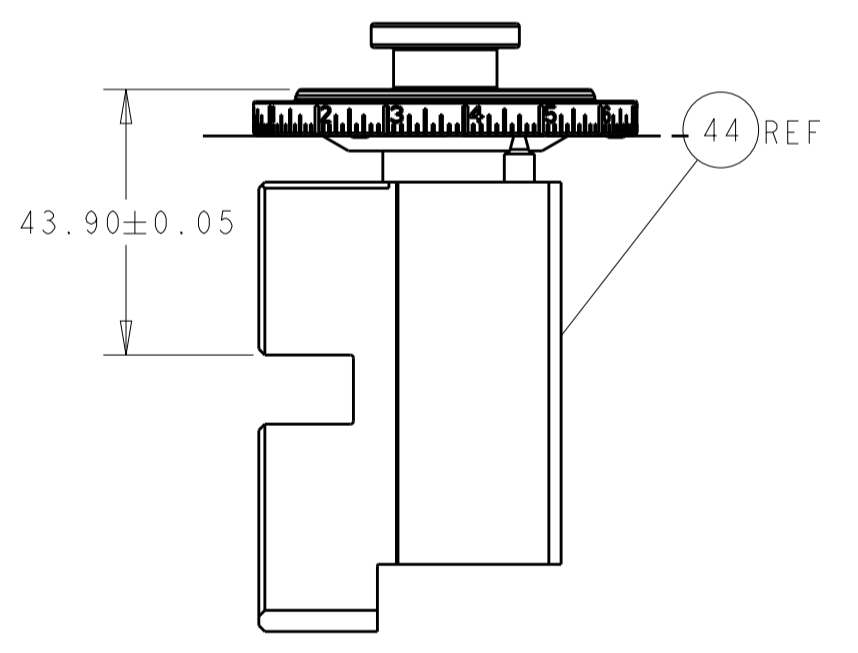
#### PNEUMATIC



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

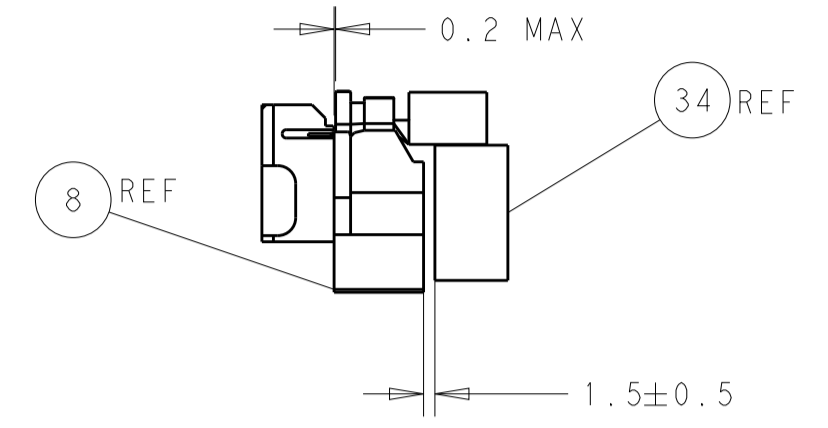
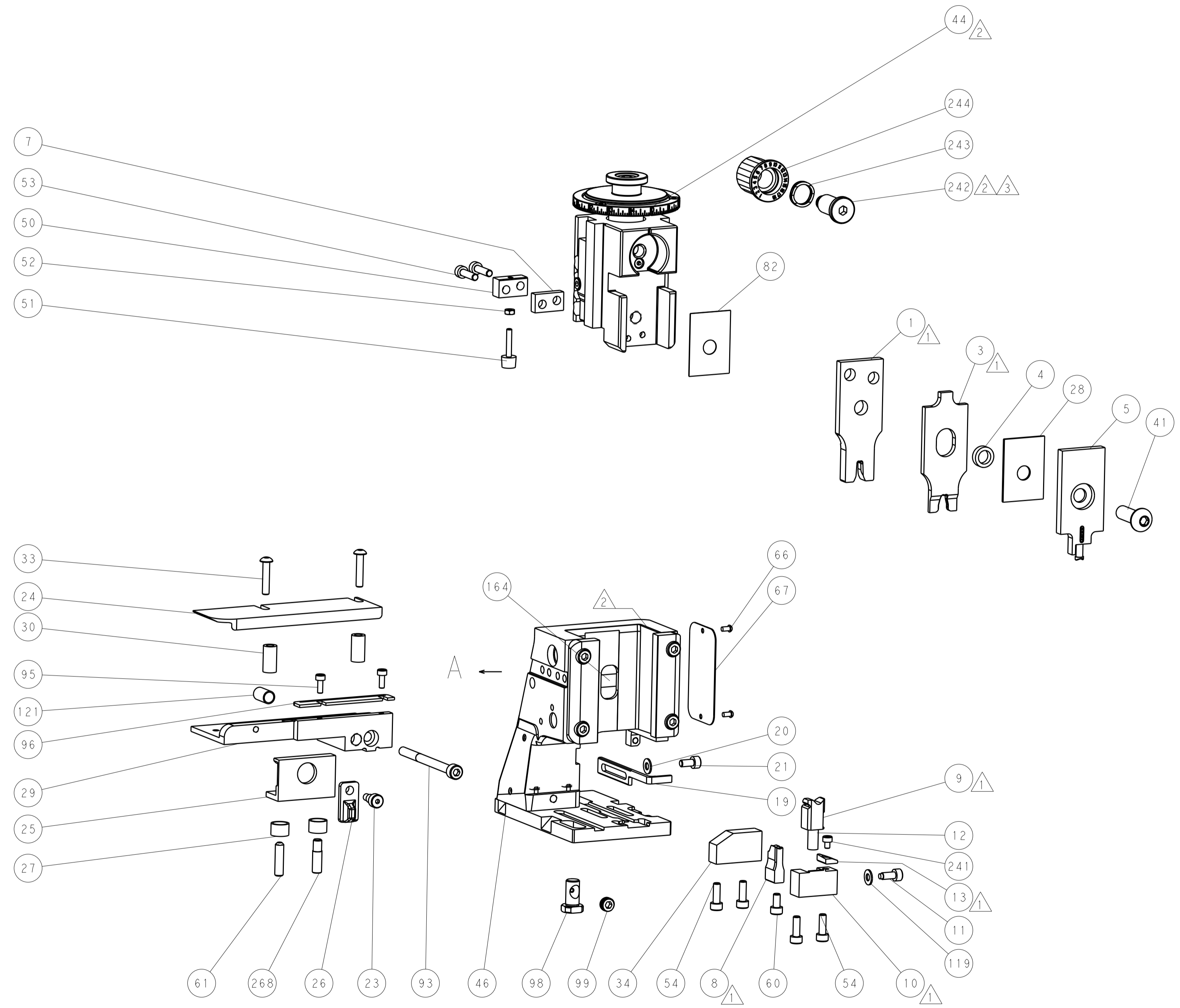
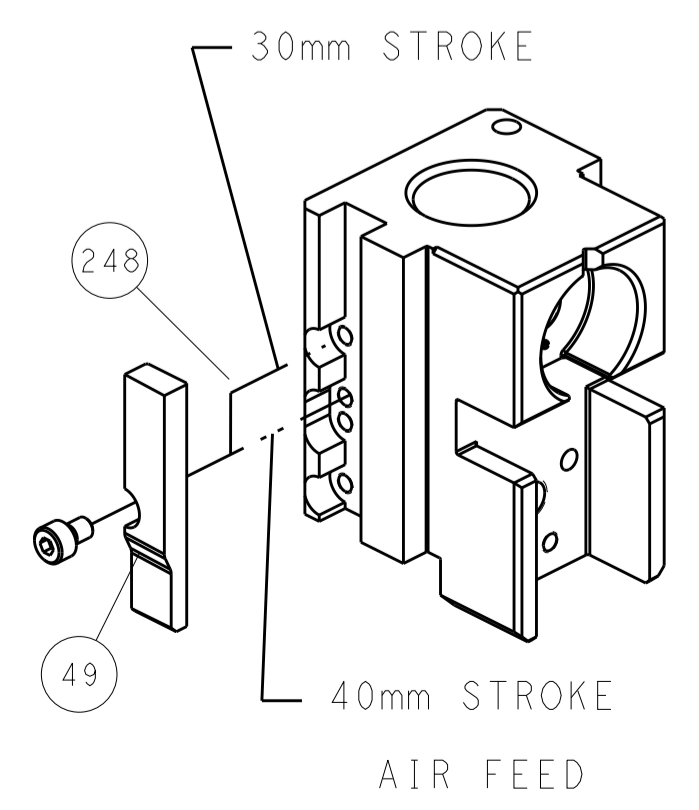


DETAIL A

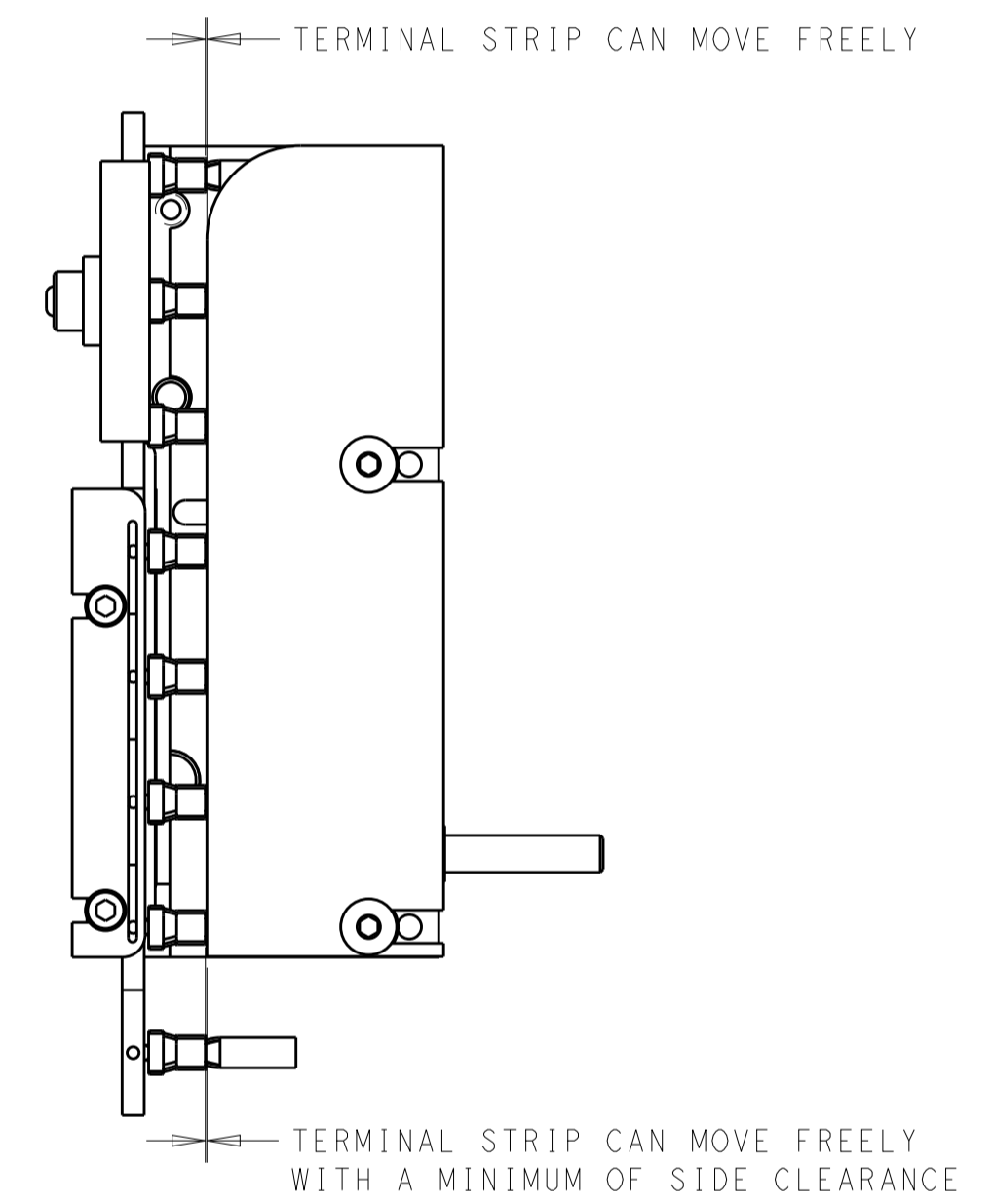


SCALE 4:5

### CAM POSITIONS

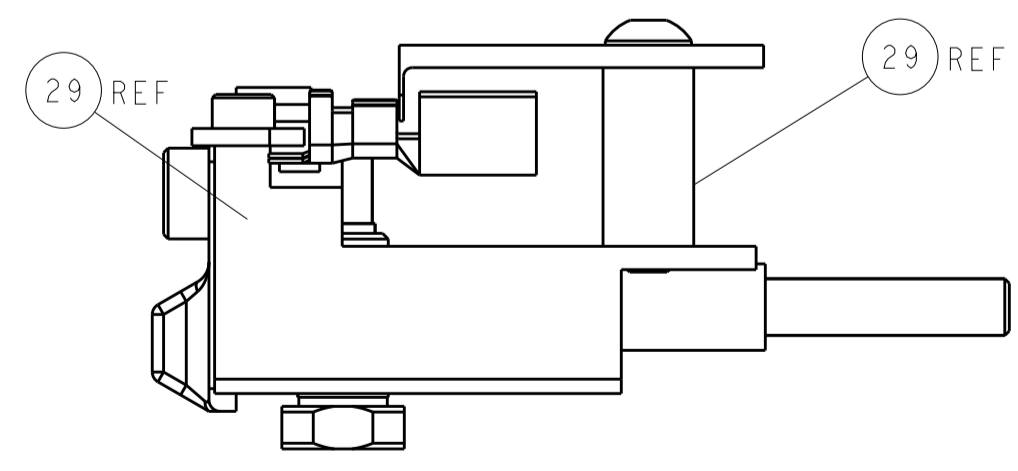


TERMINAL SUPPORT LOCATION



FEED TRACK POSITION

ITEM 30 LOCATED AT REAR HOLES



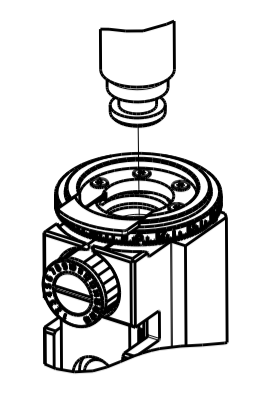
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

<small>THE DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRICAL CONNECTION          IT IS SUBJECT TO CHANGE AND TO CONTROL AND INSISTING ORGANIZATION          SHOULD BE CONTACTED FOR THE LATEST VERSION.</small>		DWN A. HUANG 07FEB2013 CHK S. XI 07FEB2013 APVD S. XI 07FEB2013 PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER DRAWING	NAME Ocean Side Feed Applicator SIZE A1 CAGE CODE 00779 DRAWING NO 2151817 SCALE 1:2 SHEET 2 OF 4 REV G	TE Connectivity Harrisburg, PA 17105-3608
---	--	--	---	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151817-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151817-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.06 mm [.160]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPT LITEALUM CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.40-4.00 mm [.134-.157 IN]		3.56-3.74mm [.140-.147 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94204		
TERMINALS APPLIED 6			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-1862001-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	1.90±0.04 [.0748±.0016]	8.2



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

**\*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	APPV
A	66				

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	2-1722335-1			268
-	1	2119082-4			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	7-18023-7			241
-	1	2844940-1			238
-	REF	994970-2			164
-	1	2119641-2			151
-	1	2168083-8			144
-	4	2168083-9			143
-	1	2-1803583-4			141
-	1	1803516-1			140
-	1	1-22281-8			121
-	1	1-18028-2			119
-	1	2844908-1			99
-	1	2844907-1			98
-	1	1-690438-0			96
-	2	2168083-1			95
-	1	2168083-6			93
-	1	455888-3			82
-	1	1803607-3			71
-	1	2119740-1			67
-	2	2168078-1			66
-	1	2-18032-5			61
-	1	5-18022-5			59
-	1	1338685-1			56
-	2	2168083-8			53
-	1	5018030-1			52
-	1	811242-5			51
-	1	690753-2			50
-	1	18023-9			49
-	1	1803602-1			41
-	1	1-1752356-2			34
-	2	2079383-5			33
-	2	3-2844962-2			30
-	1	2844938-1			29
-	1	1-455888-0			28
-	2	22283-1			27
-	1	356835-1			26
-	1	1803142-1			25
-	1	1320928-2			24
-	1	980371-4			23
-	1	2168083-2			21
-	1	1-18028-2			20
-	1	690472-2			19
-	1	2119806-1			13
-	1	3-22280-3			12
-	1	1-356885-5			11
-	1	2119805-1			10
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1	1	2161316-2			8
-	1	2-240641-9			7
-	-	-			6
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-	1	5-238011-2			4
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-	-	-			2
1	1	2217302-2			1
-77	-22	PART NO	DESCRIPTION	ITEM NO	

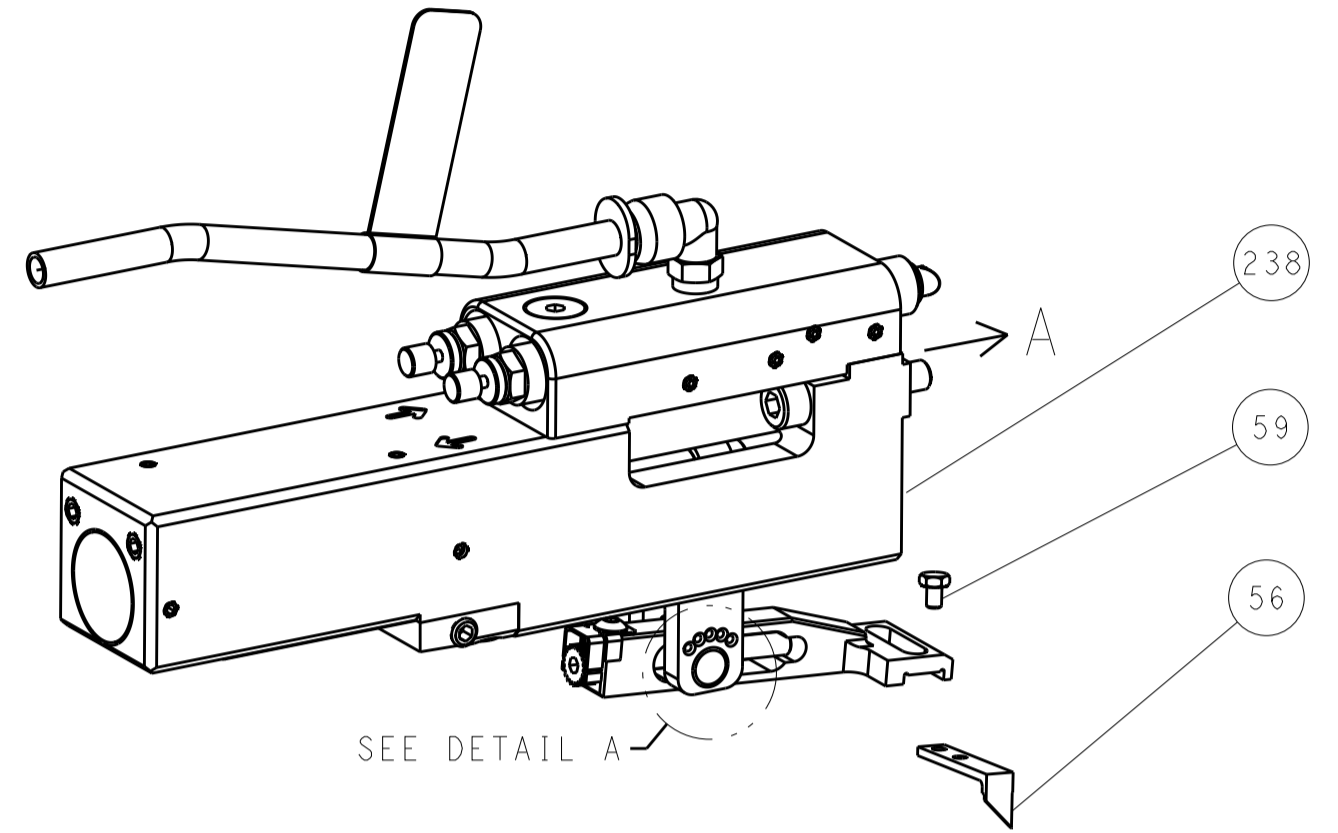
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		CUSTOMER DRAWING:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES					

CHK	H. HUANG	07FEB2013	DWN	H. HUANG	07FEB2013
APPV	S. XI	07FEB2013	NAME	Ocean Side Feed Applicator	
SIZE	A1	00779	SCALE	1:2	SHEET 3 OF 4
DRAWING NO	C=2151817		REV	G	

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

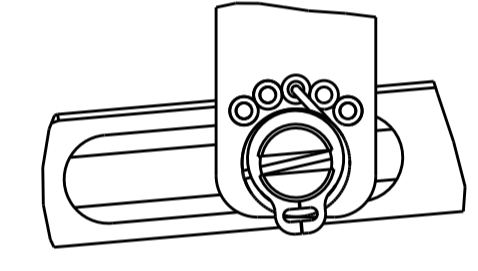
# FEED TYPE

## PNEUMATIC

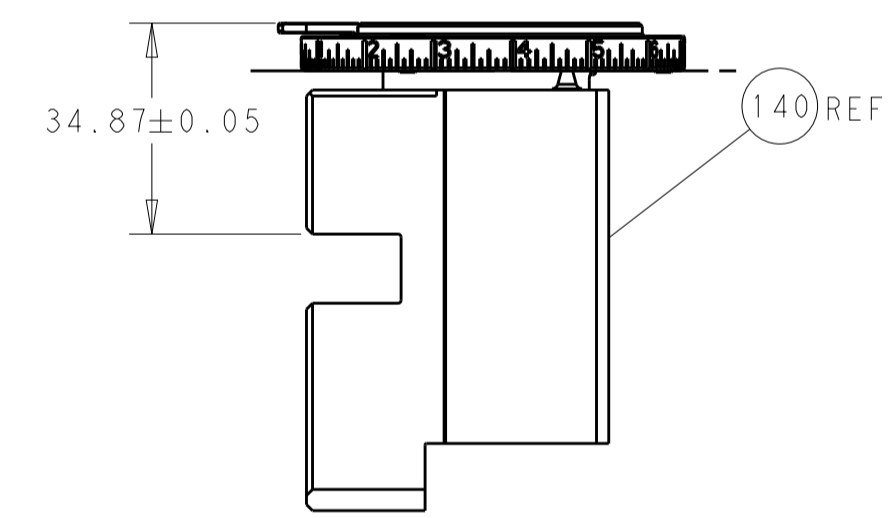


SEE DETAIL A

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

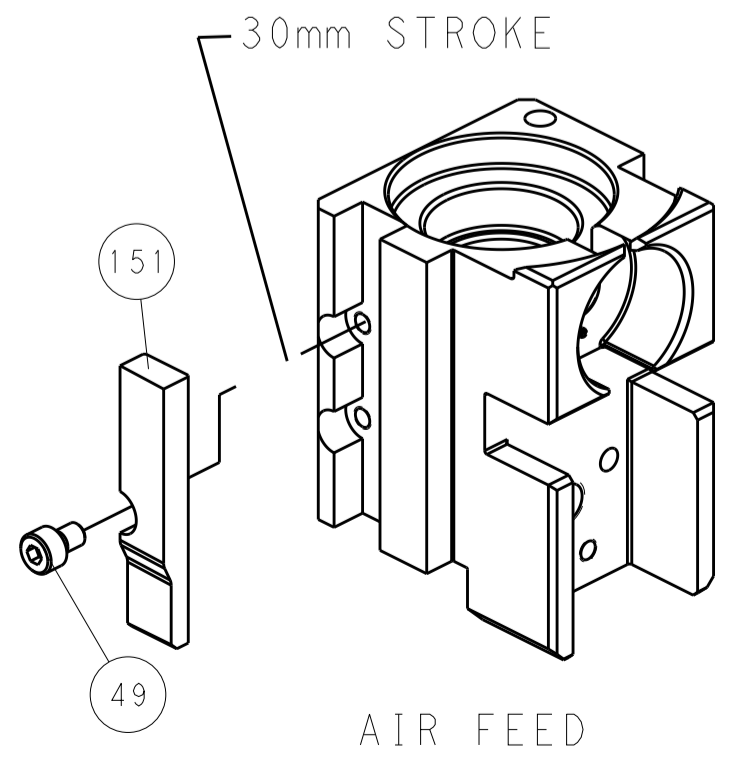


DETAIL A

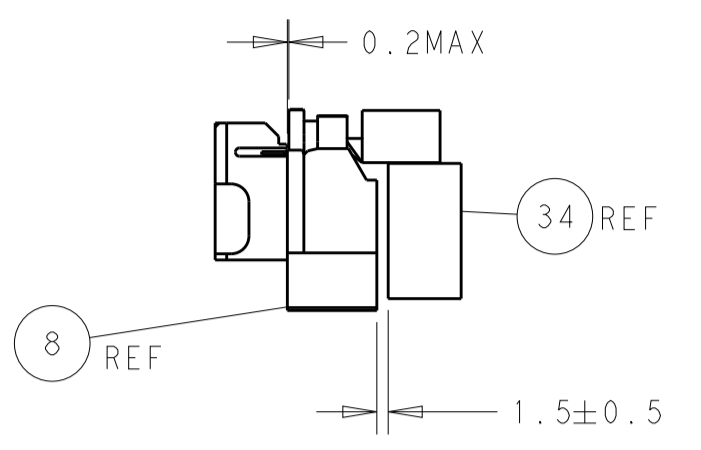
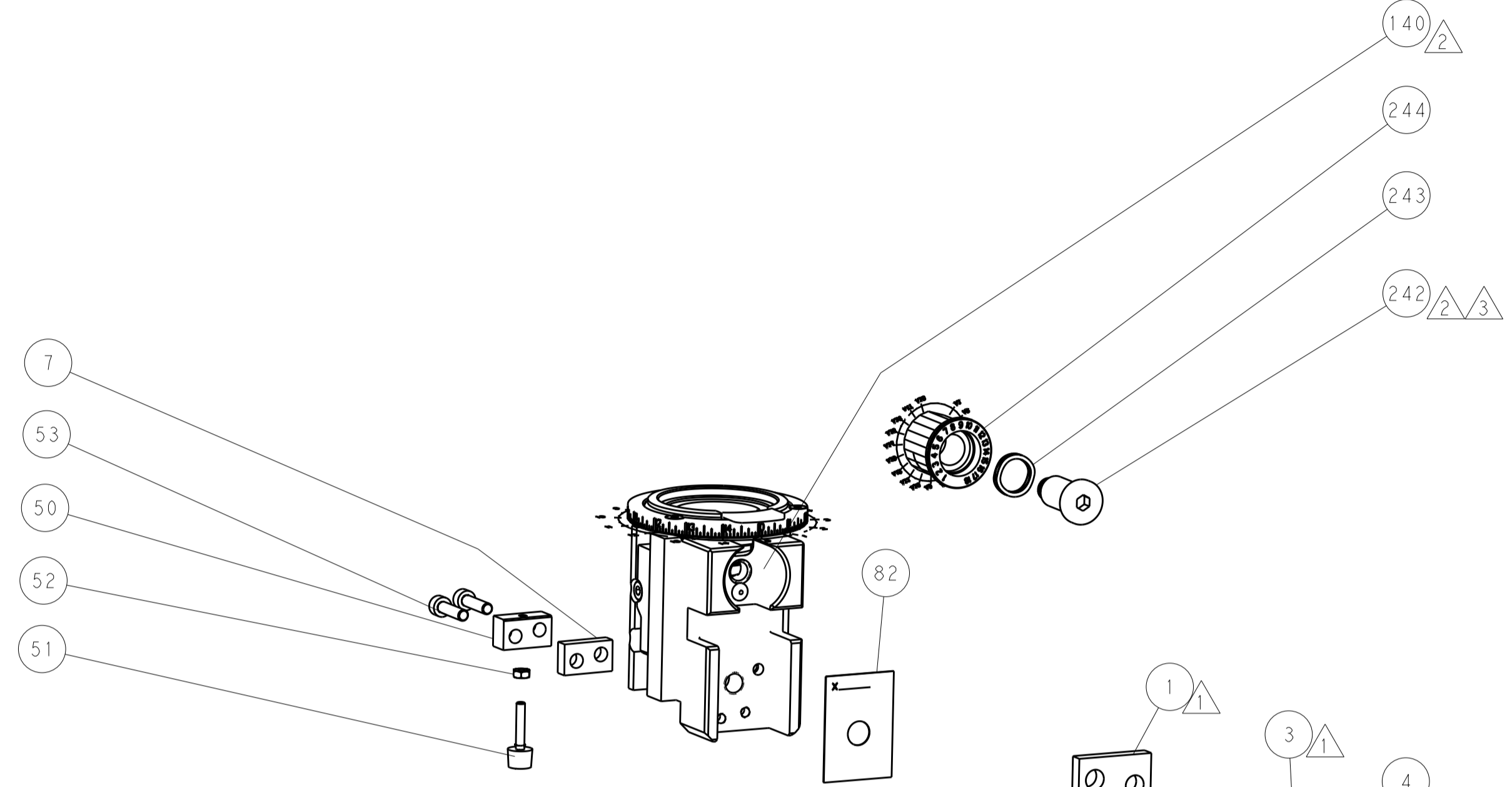


RAM SET-UP

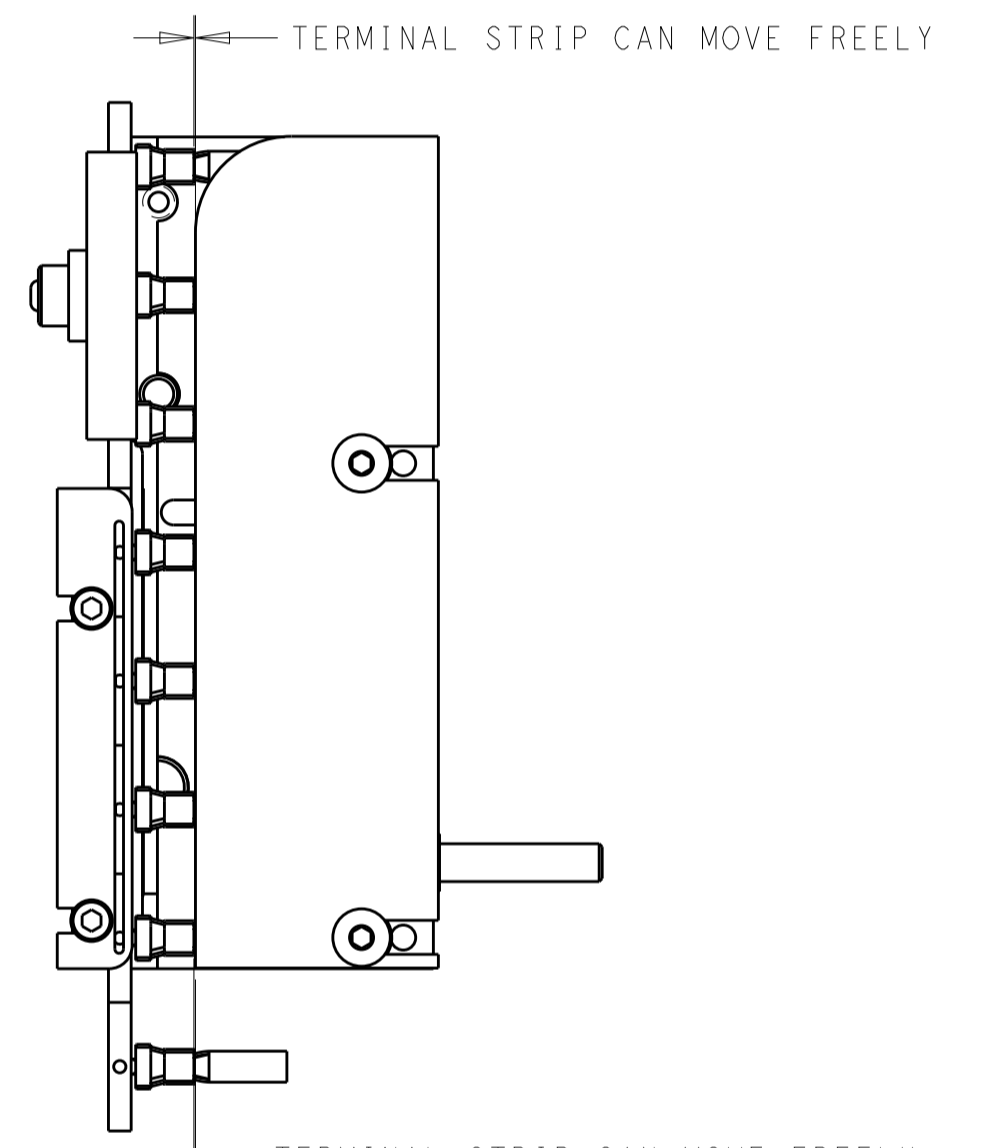
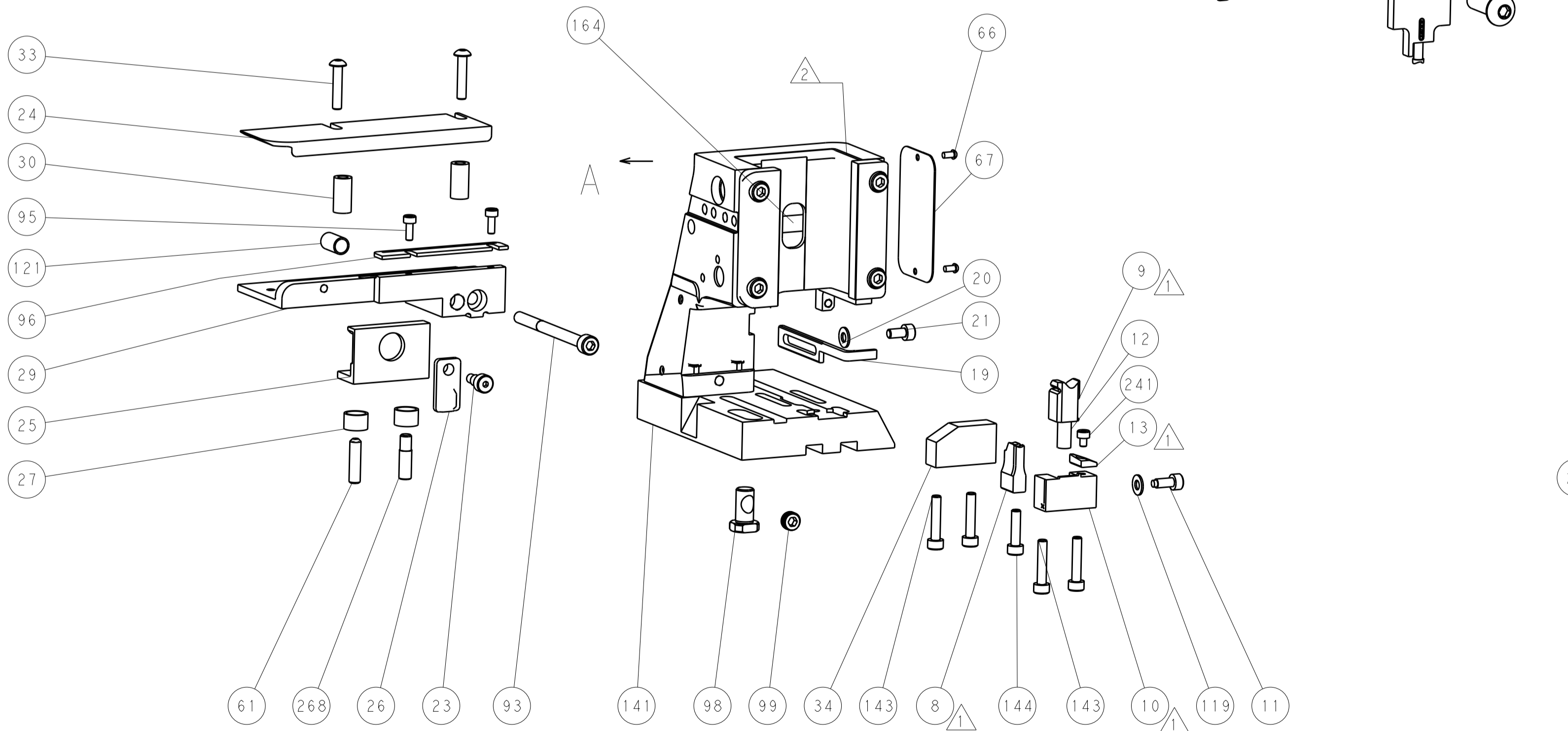
## CAM POSITIONS



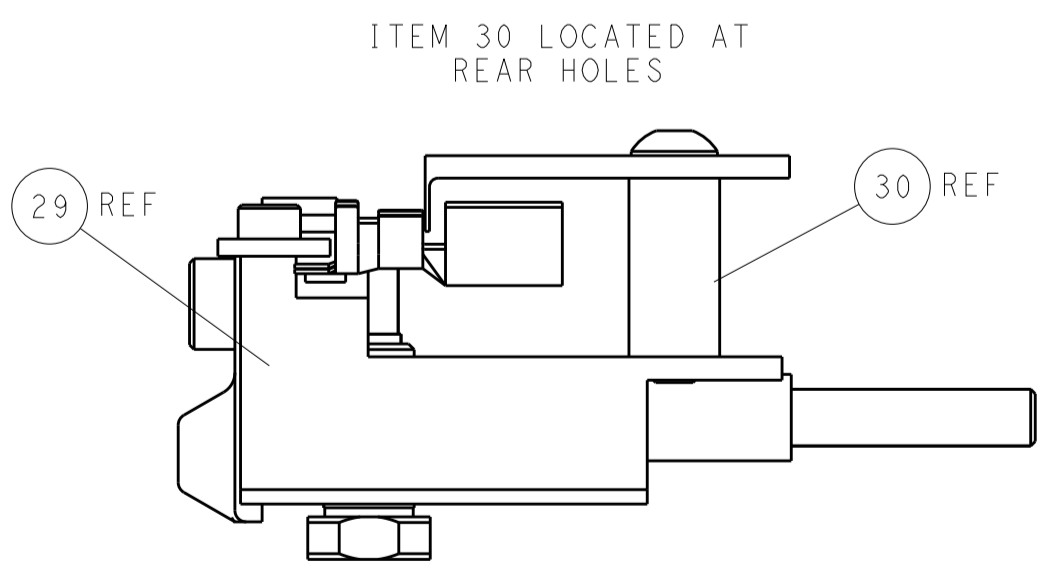
AIR FEED



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG 07FEB2013		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK S. XI 07FEB2013	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD S. XI 07FEB2013	PRODUCT SPEC	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
	2 PLC	±			APPLICATION SPEC	A1 00779 ©=2151817	
	3 PLC	±			WEIGHT	SCALE 1:2 SHEET 4 OF 4 REV G	
	4 PLC	±			CUSTOMER DRAWING		
	ANGLES	±					
MATERIAL	FINISH						