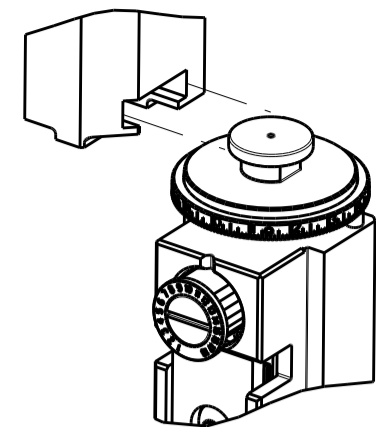


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151693-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151693-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151693-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



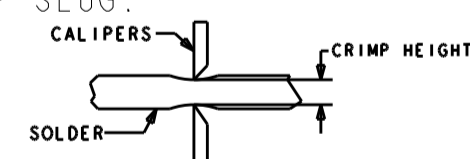
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.136 [3.45 mm]	D
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-35042

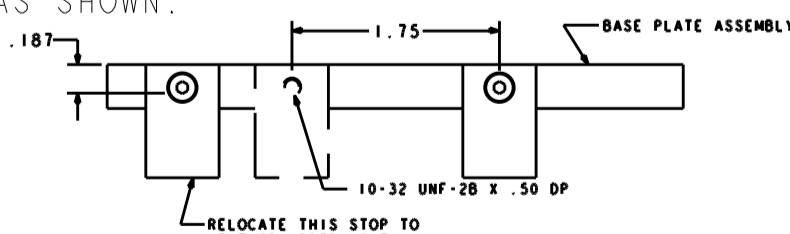
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.265-.297 IN [6.73-7.54 mm]		∅ .105 MAX	
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
7-520365-2			

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	REV	DATE	BY	APPV
		B	20APR2017	TB	GB
		C	30OCT2018	JAH	CT
		D	29JUL2019	FZ	TE
		E	18SEP2019	FZ	TE

	-	1	1	1-18023-1	SCR, SHC, M4x10	262
	-	1	1	803931-1	BRACKET, HOLD DOWN	261
	-	REF	REF	462992-7	GUARD ASSEMBLY	257
	-	REF	REF	679532-1	INSERT, GUARD	256
	-	1	1	189728-1	BRACKET, SPACER	255
	-	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	2844940-1	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:		APPROVED:		DATE:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APV	12JUN2012	TE Connectivity	Ocean Side Feed
	ANGLES	FINISH	WGT	SCALE	1:1	SHEET	1 OF 4	REV	E

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

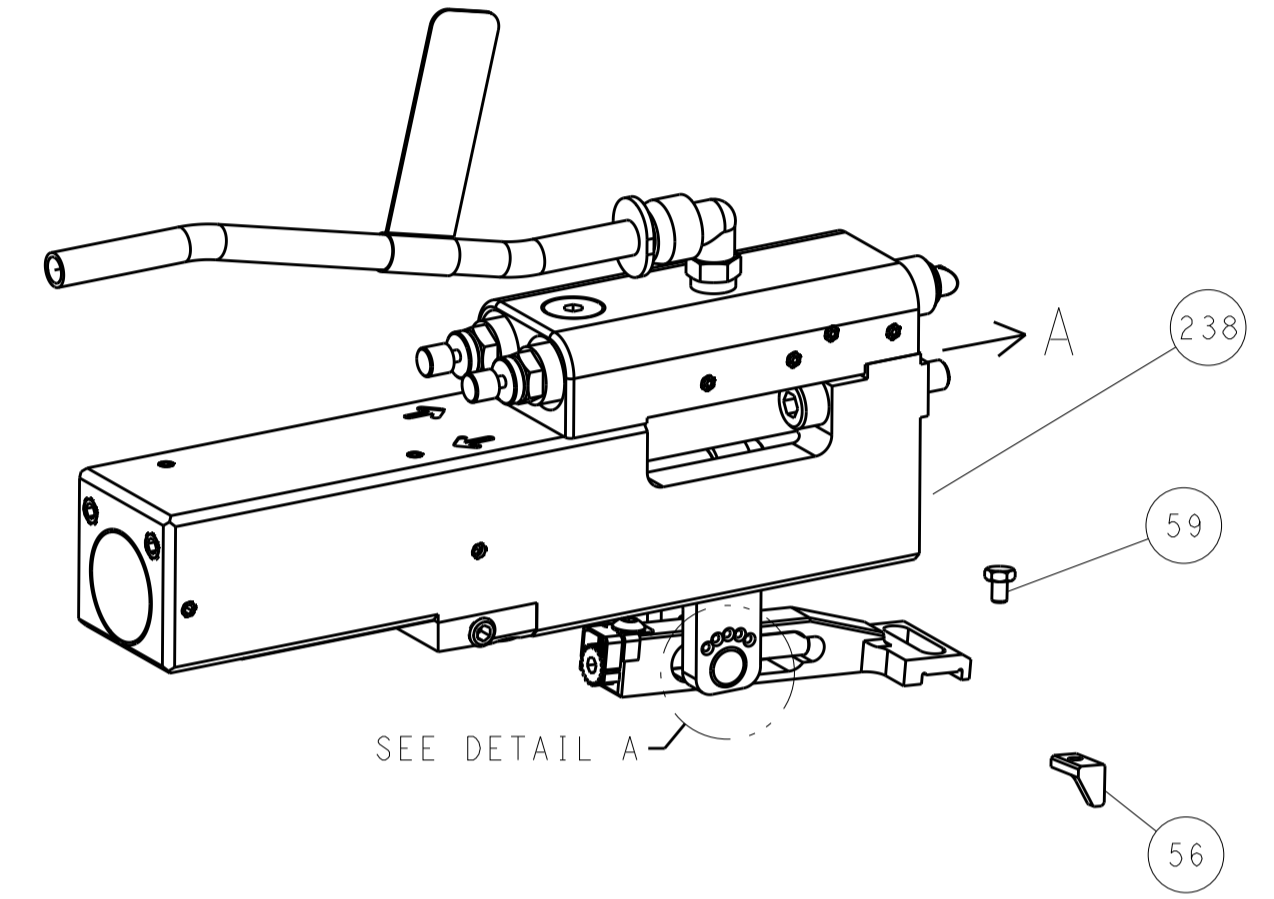
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-

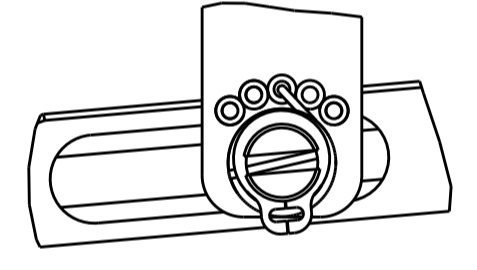
# FEED TYPE

## PNEUMATIC



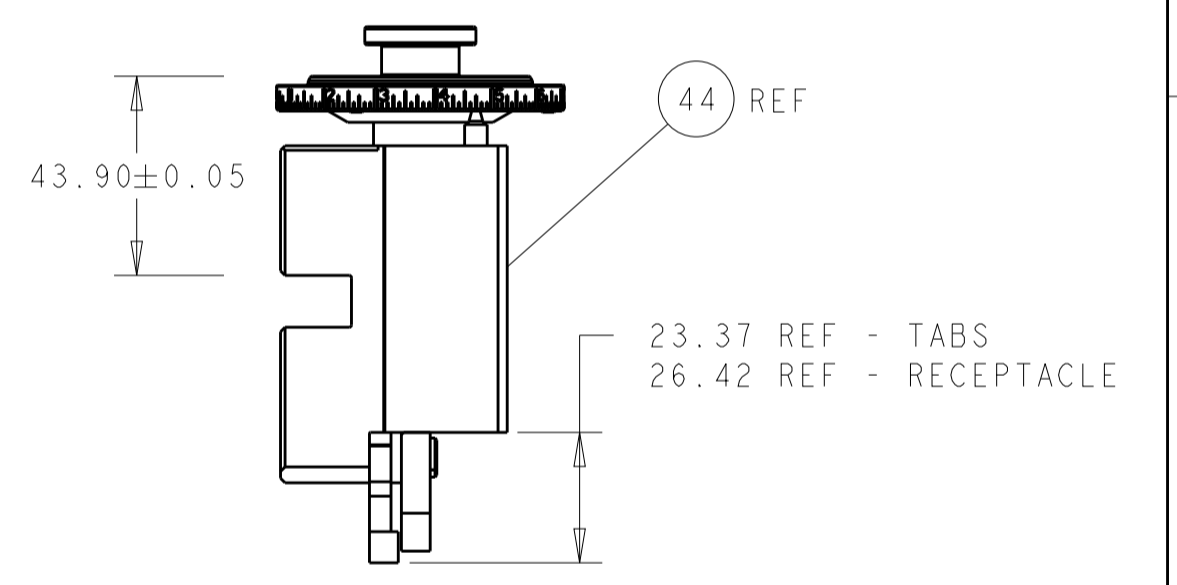
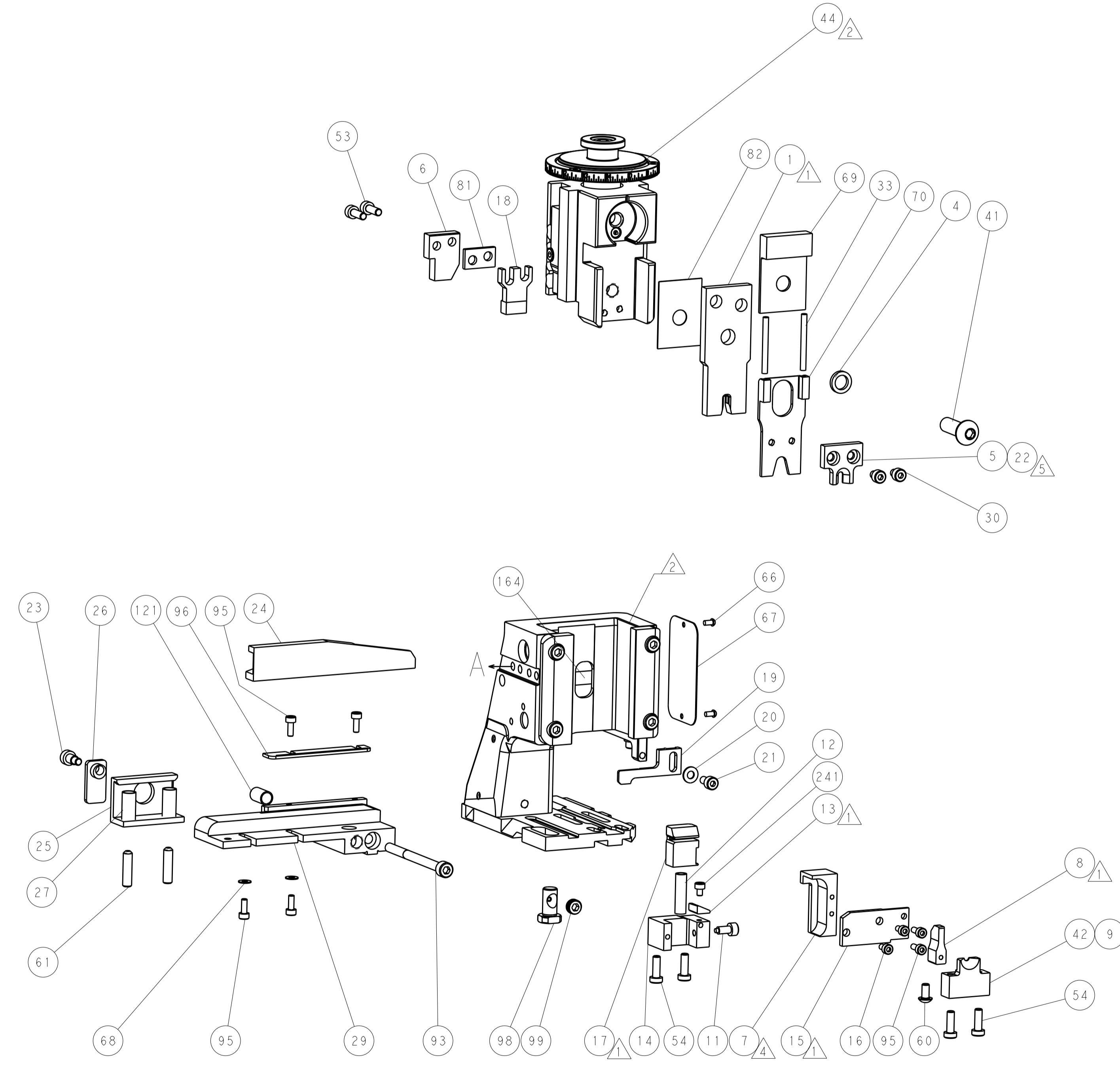
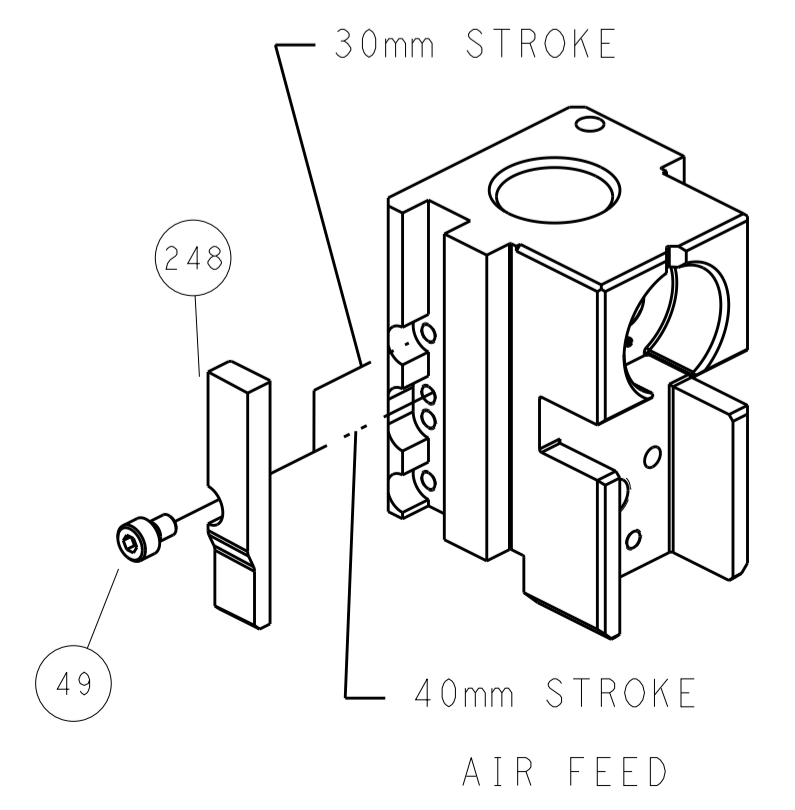
SEE DETAIL A

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

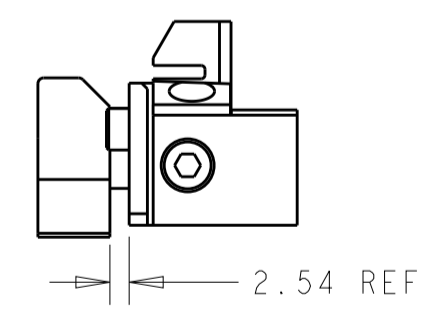


DETAIL A

# CAM POSITIONS



RAM SET-UP



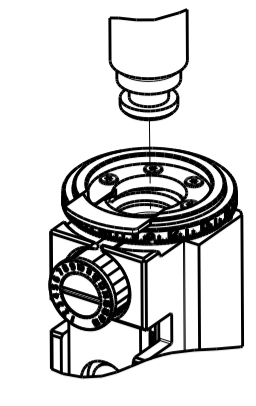
LOWER TOOLING SET-UP

**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. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED IN THE ORDER. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED.</small>		DWN: B. WEAVER 12JUN2012 CHK: G. HOFENER 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: C=2151693	RESTRICTED TO: SCALE: 1:1 SHEET: 2 OF 4 REV: E
MATERIAL: FINISH:		WEIGHT:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151693-2	E	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.
- 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
	-	REF	462992-7	GUARD ASSEMBLY	257
	-	REF	679532-1	INSERT, GUARD	256
	-	1	189728-1	BRACKET, SPACER	255
	-	1	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

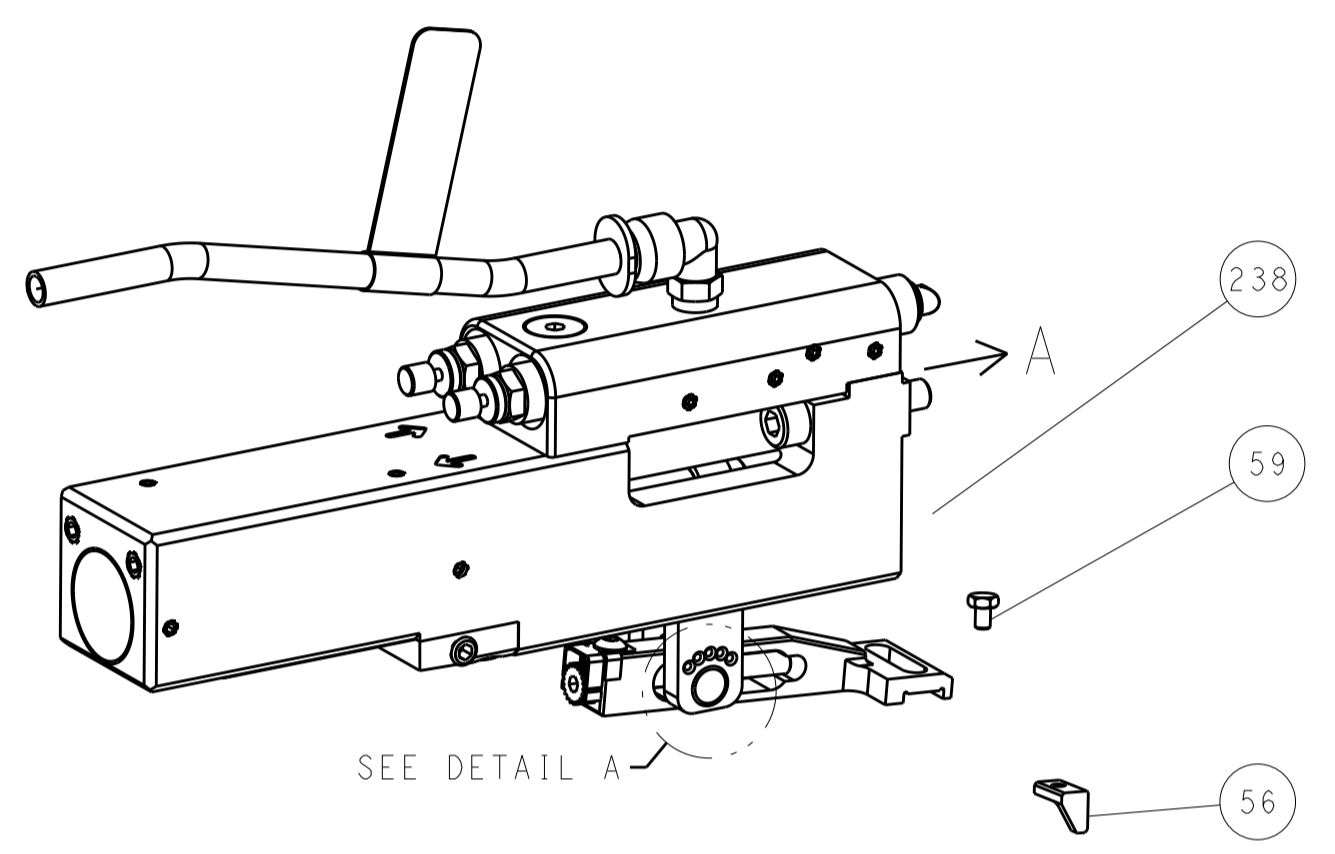
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: B. WEAVER 12JUN2012		CHK: G. HOFENER 12JUN2012		APVD: T. ELBIN 12JUN2012		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:1		SHEET: 3 of 4		REV: E	
MATERIAL		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:1		SHEET: 3 of 4		REV: E		PART NO: 400779	

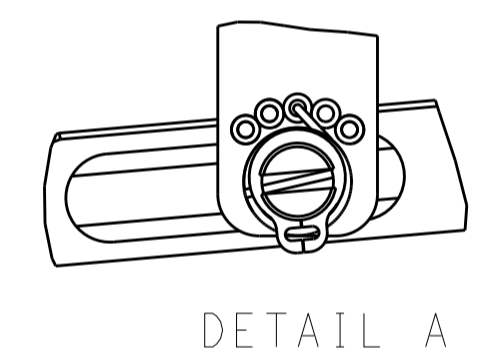
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

# FEED TYPE

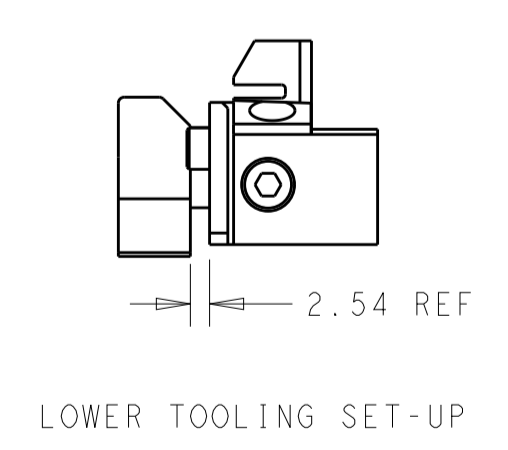
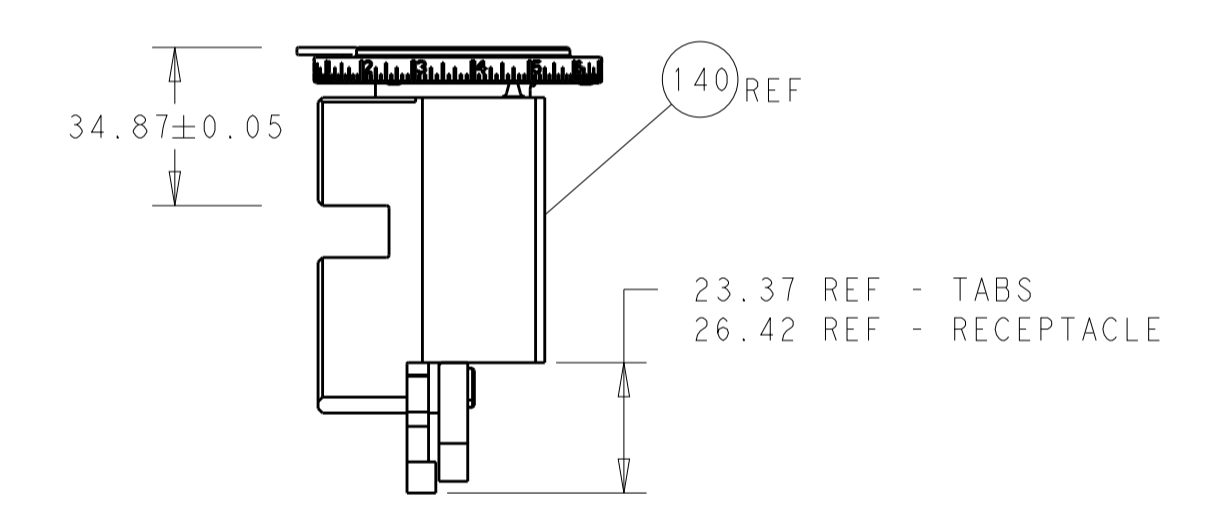
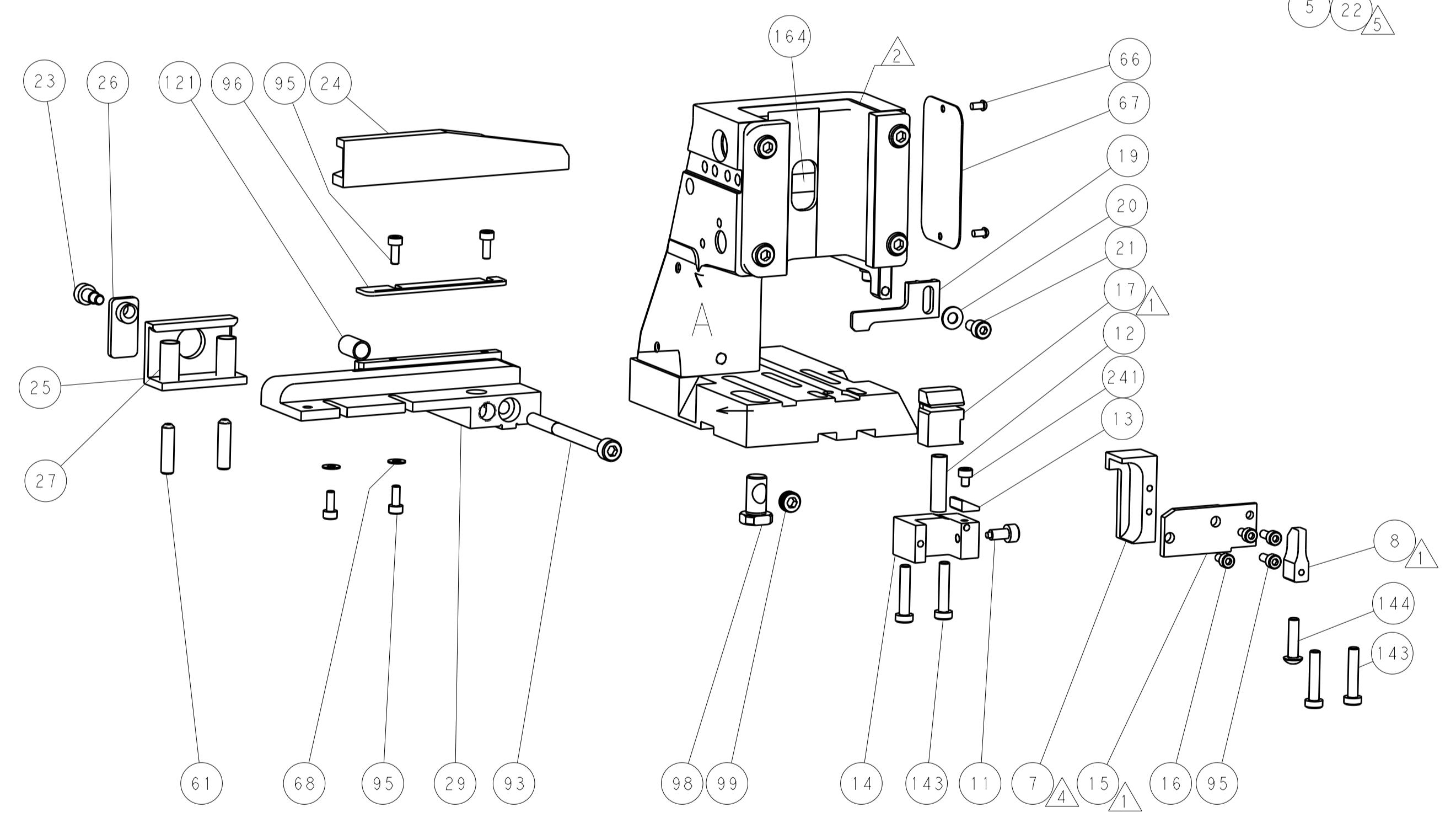
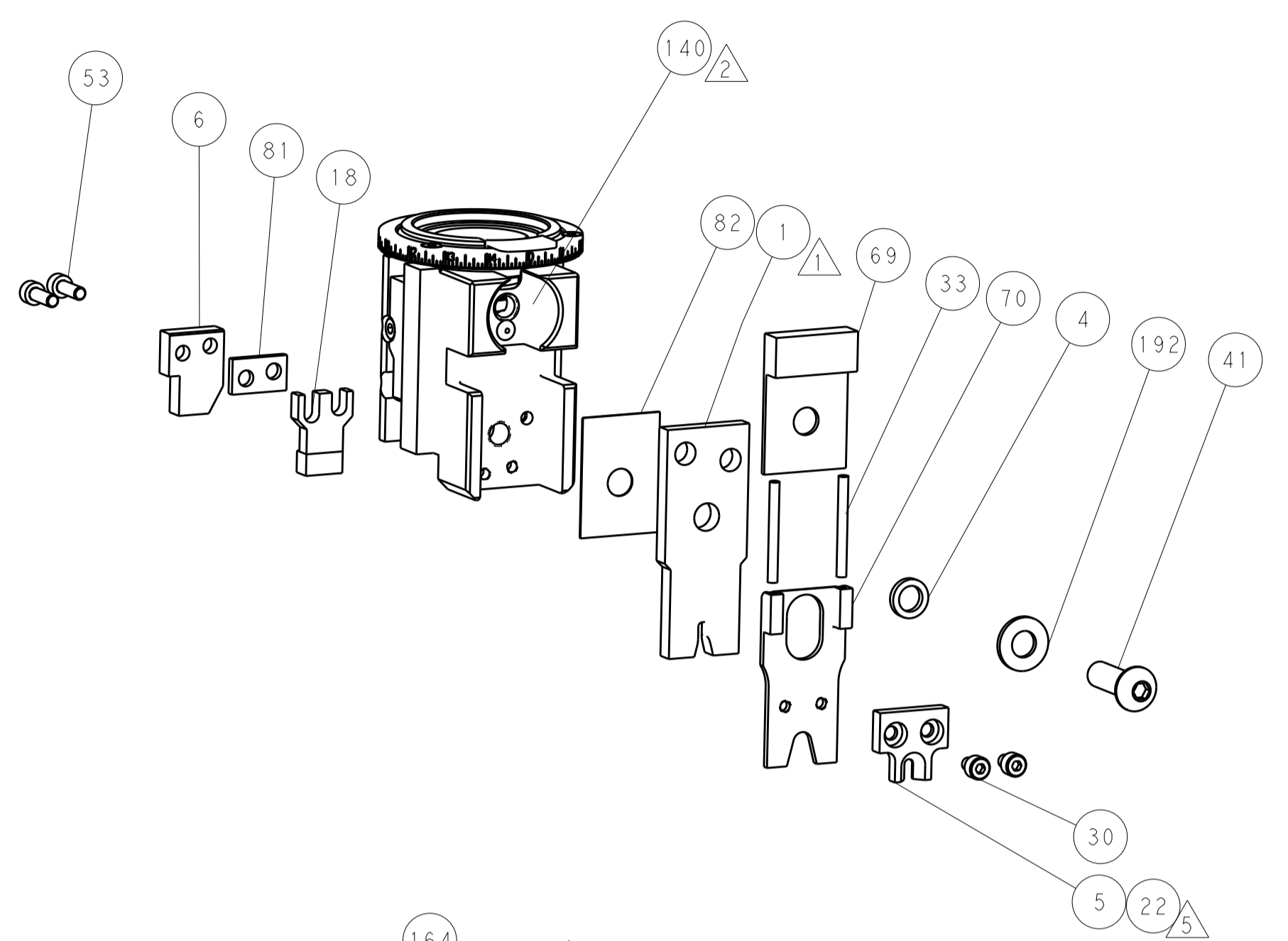
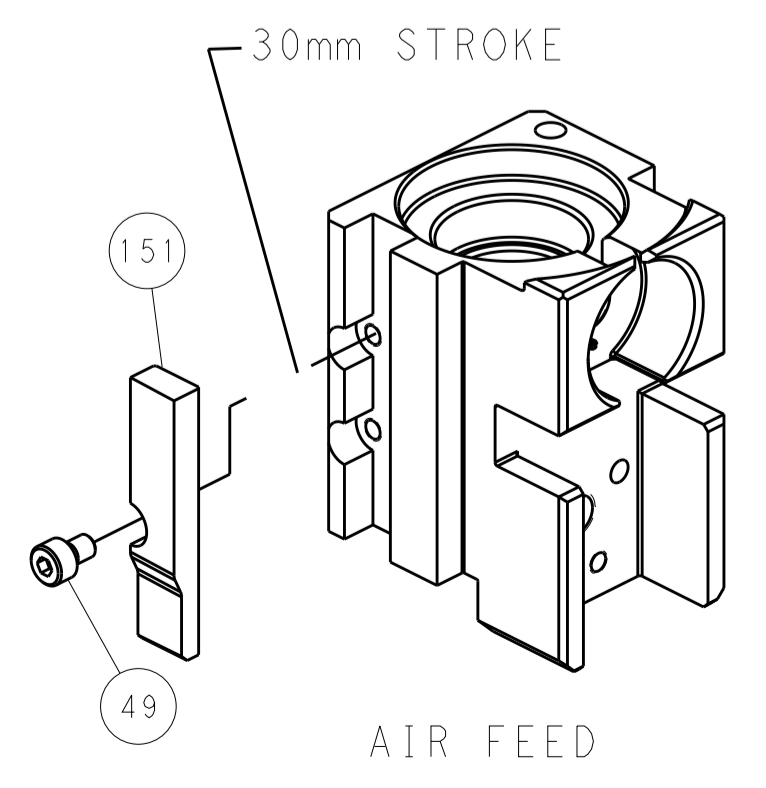
## PNEUMATIC



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



## CAM POSITION



**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 ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151693	RESTRICTED TO: E
MATERIAL: FINISH:		WEIGHT: CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:1 SHEET: 4 OF 4 REV: E	