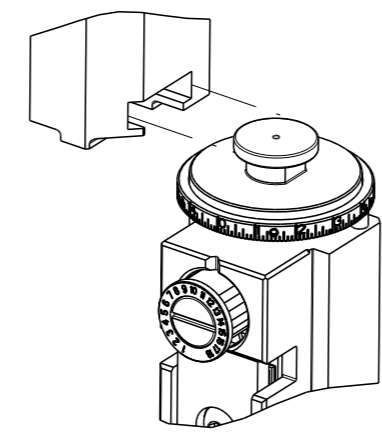


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151871-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151871-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151871-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151871-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151871-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.88 mm [.074]	F
INSUL	2.34 mm [.092]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL MINI F280			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.40 mm [.157-.173 IN]		∅ 2.08mm MAX [.082 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	BO-018.009A Rev 8		
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
2113318-1	1708330		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35+0.35mm2	1.25+/-0.05 [.049+/- .002]	5.4
0.75mm2	1.15+/-0.05 [.045+/- .002]	6.9
0.50mm2	1.10+/-0.05 [.043+/- .002]	7.4
0.35mm2	1.00+/-0.05 [.039+/- .002]	8.5

- 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.

***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)

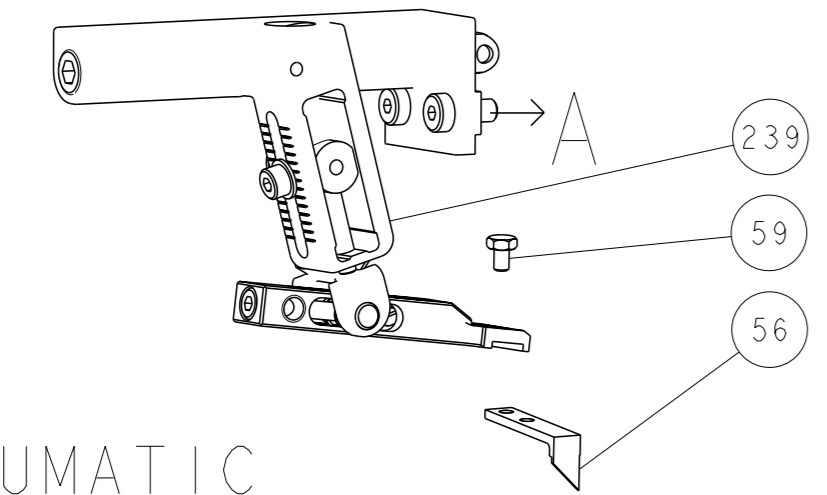
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		REV	DATE	BY	APPV
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		B	ECR-20-002396	19FEB2020	FZ TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
3	-	1	1	1	2-1752354-5	STANDOFF,HOLD-DOWN	180	
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
1	-	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1-356885-4	STOP, SHEAR	11	
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
1	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1803058-2	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-8	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1-1803017-1	CRIMPER, INSULATION F	3	
-	1	1	1	1	455888-8	SPACER, CRIMPER	2	
1	1	2	2	1	7-1633609-0	CRIMPER, WIRE	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

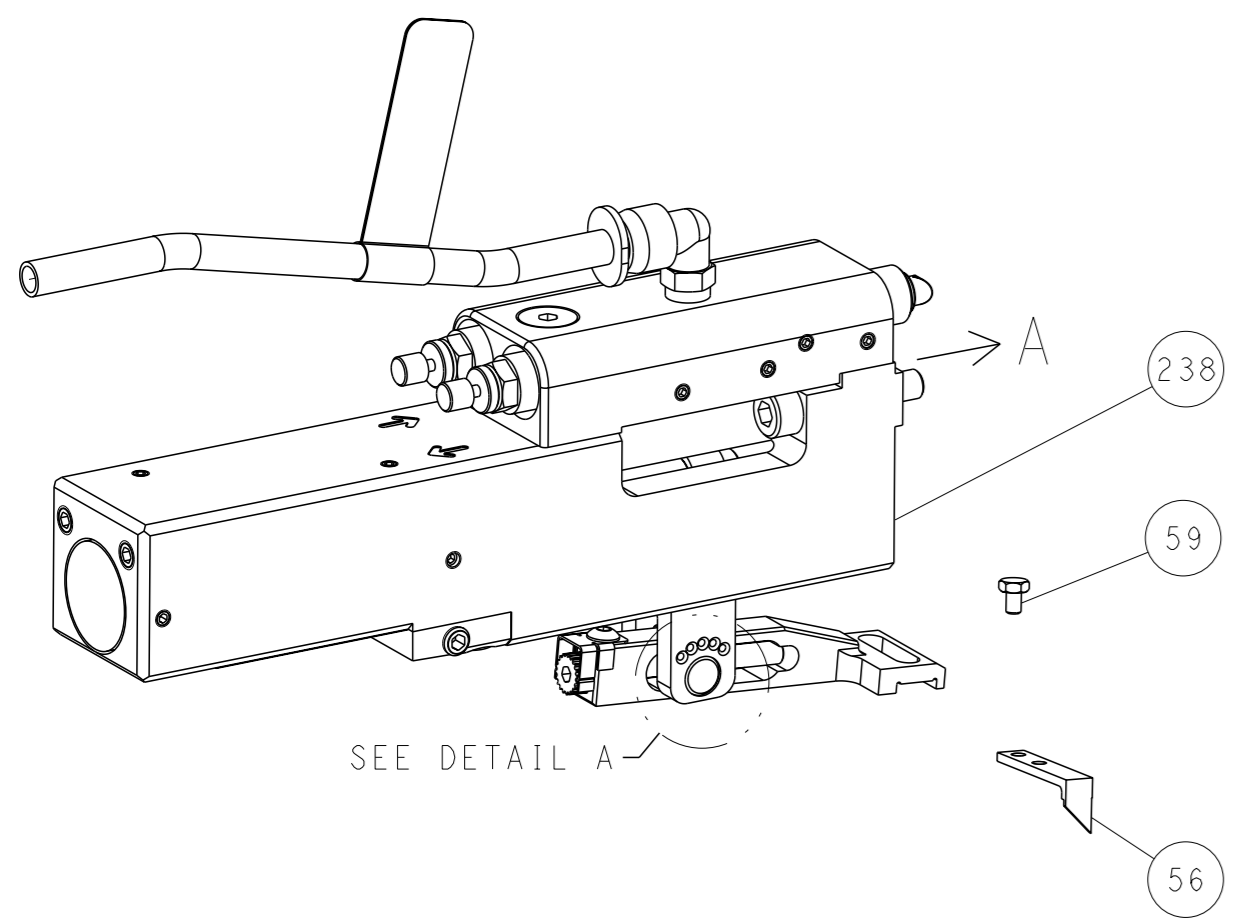
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		1 PLC ±		APVD	M. CLIFFORD	06FEB2013	NAME	
		2 PLC ±		PRODUCT SPEC		Ocean Side Feed		
		3 PLC ±		APPLICATION SPEC		Applicator		
		4 PLC ±		MATERIAL		SIZE CASE CODE DRAWING NO RESTRICTED TO		
		FINISH		WEIGHT		A1 00779 C=2151871		
				SCALE		Customer Accessible Production Drawing		
				SHEET		1 of 4		
				REV		B		

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

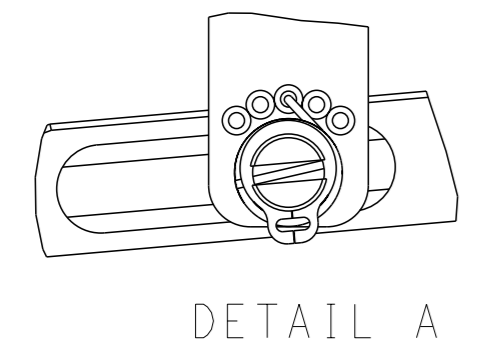
FEED TYPE MECHANICAL



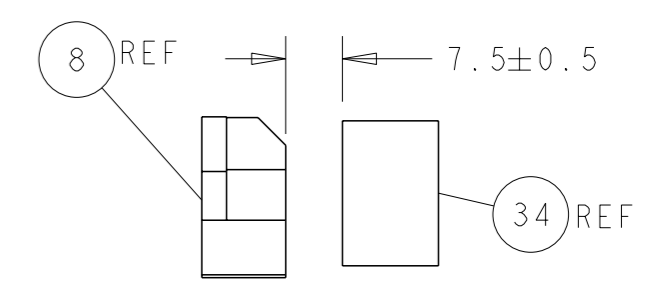
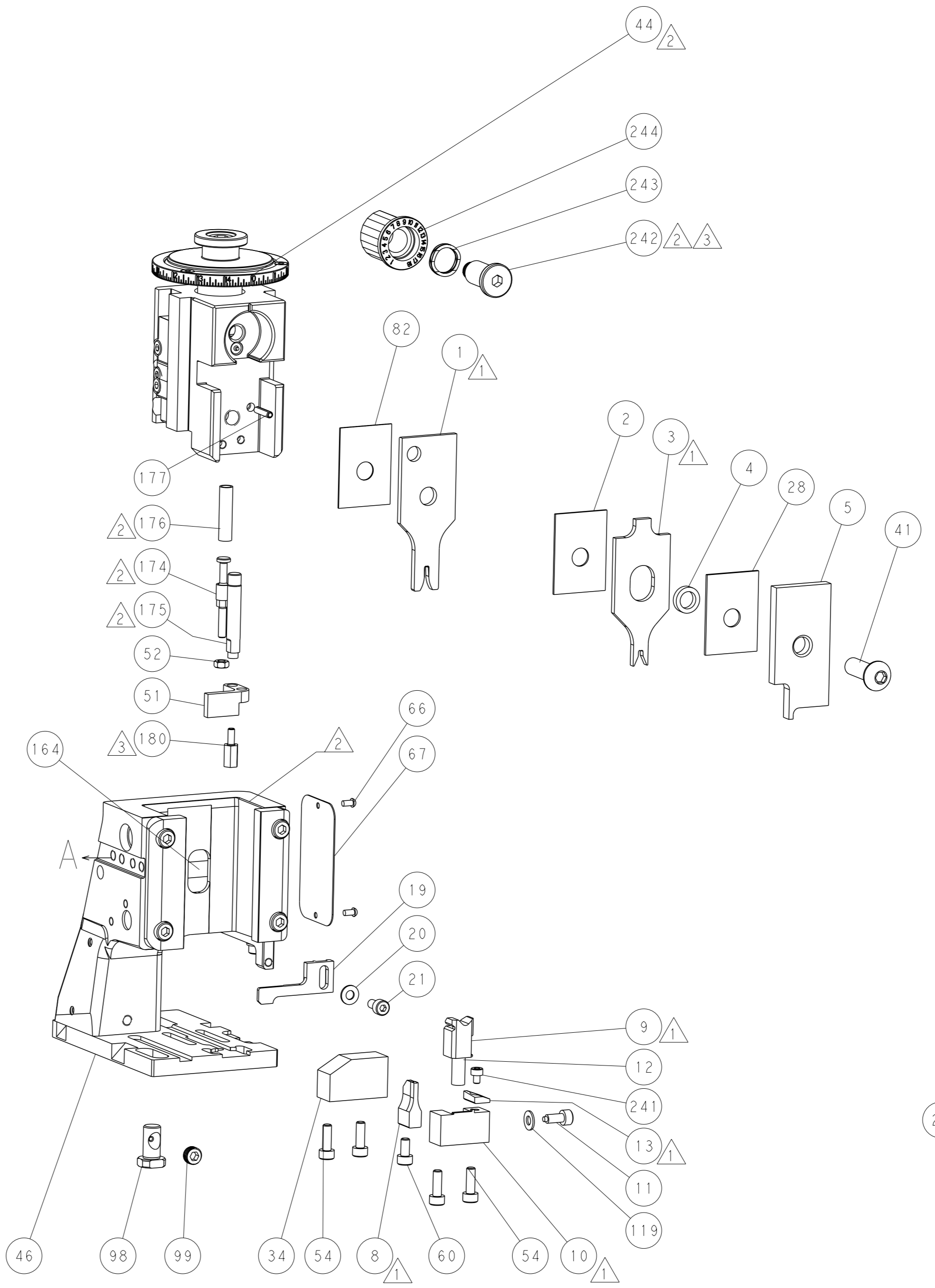
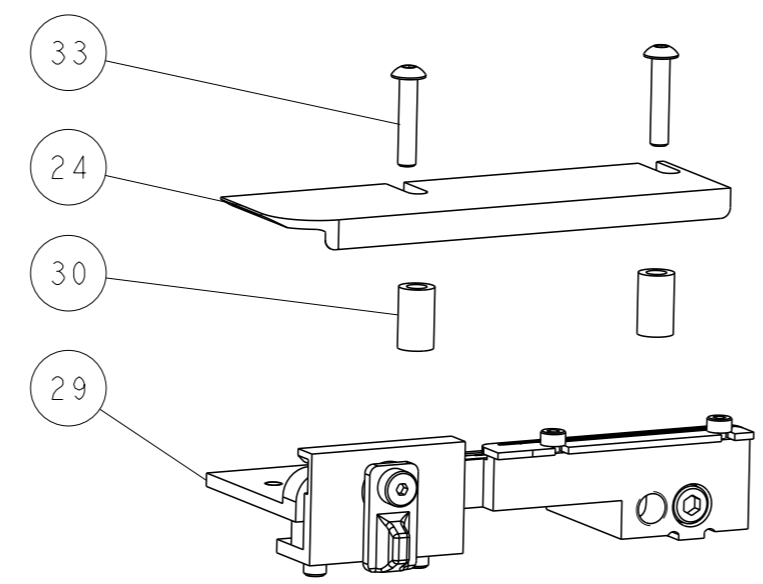
PNEUMATIC



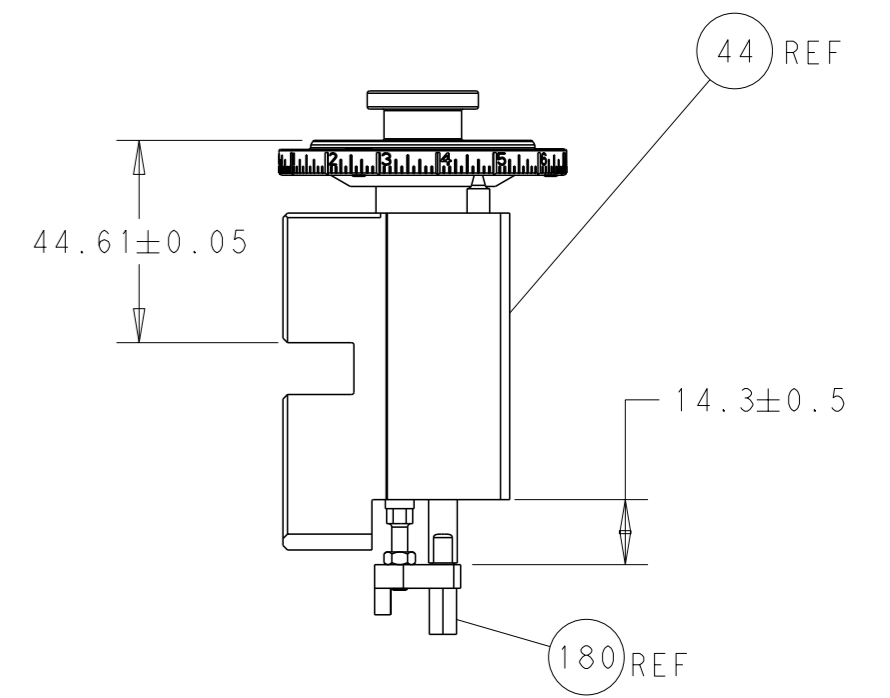
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



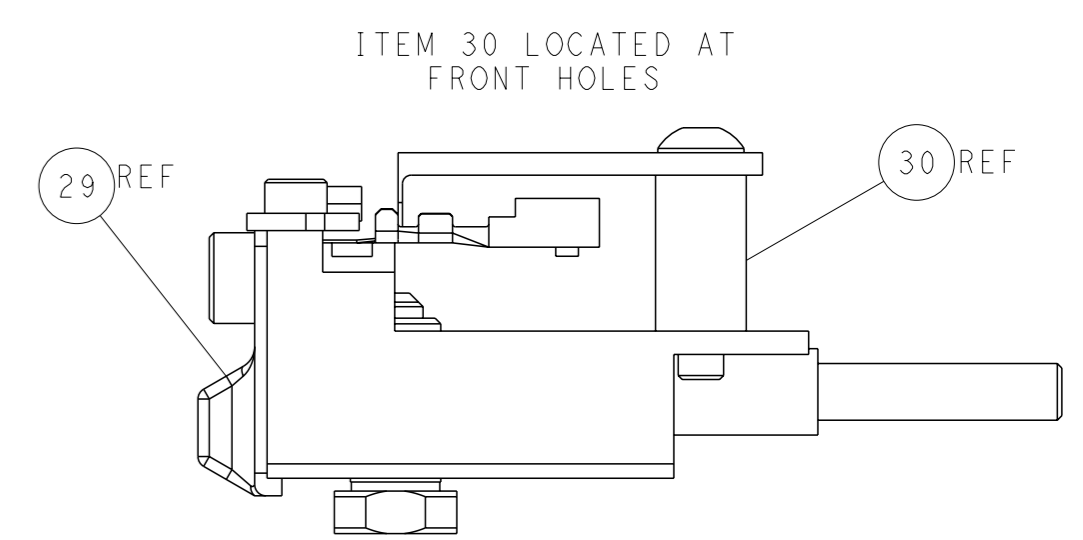
DETAIL A



TERMINAL SUPPORT LOCATION

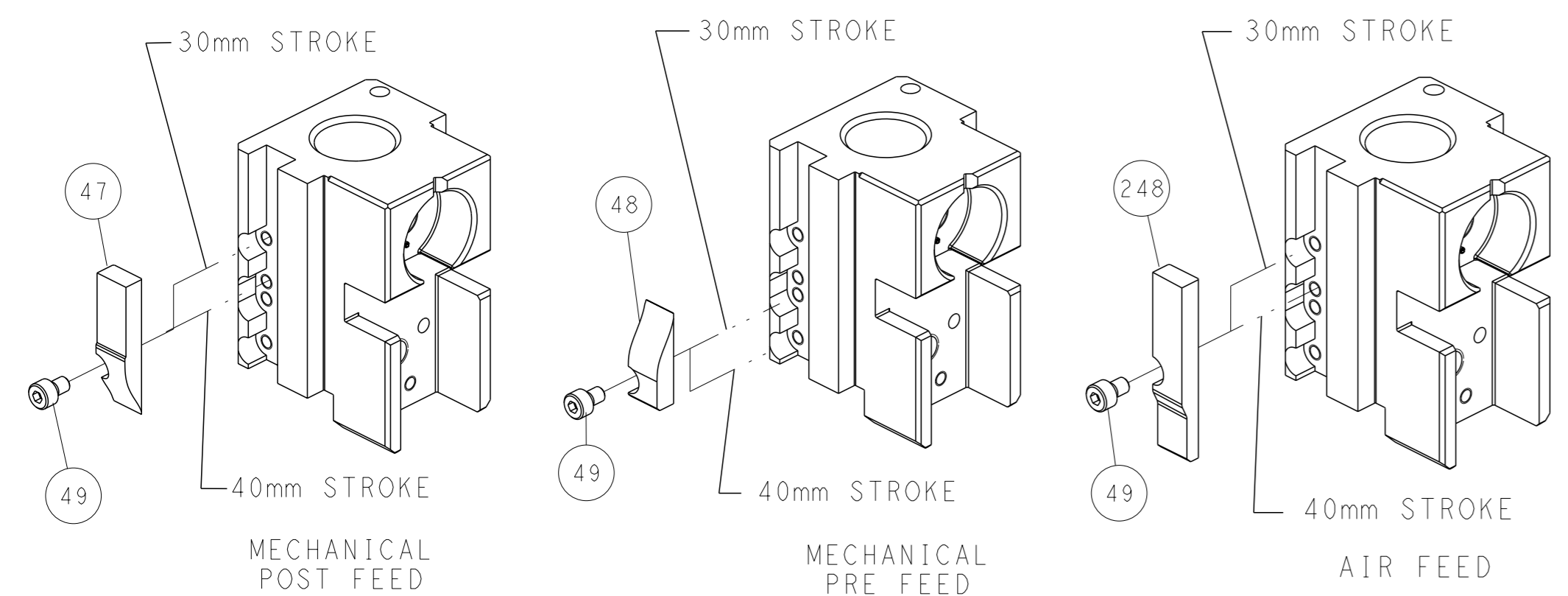


RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

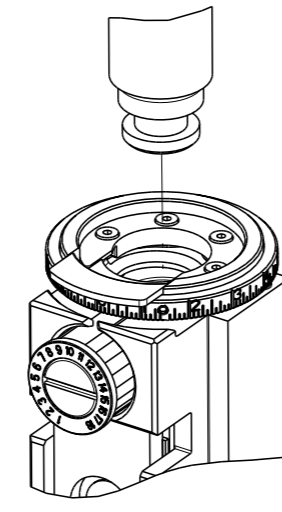


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ±		DWN L. GROSS 06FEB2013 CIL T. ELBIN 06FEB2013 APVD M. CLIFFORD 06FEB2013 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151871 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 of 4 REV B	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151871-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151871-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151871-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.88 mm [.074]	F
INSUL	2.34 mm [.092]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MTA TERMINAL		MTA CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL MINI F280			
WIRE STRIP LENGTH 4.00-4.40 mm [.157-.173 IN]		INSULATION DIAMETER RANGE Ø 2.08mm MAX [.082 IN MAX]	
TERMINAL APPLICATION SPECIFICATION BO-018.009A Rev 8			
TERMINALS APPLIED			
TE TERMINAL	MTA TERMINAL	TE TERMINAL	MTA TERMINAL
2113318-1	1708330		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35+0.35mm2	1.25+/-0.05 [.049+/-0.002]	5.4
0.75mm2	1.15+/-0.05 [.045+/-0.002]	6.9
0.50mm2	1.10+/-0.05 [.043+/-0.002]	7.4
0.35mm2	1.00+/-0.05 [.039+/-0.002]	8.5

- 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.

***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)

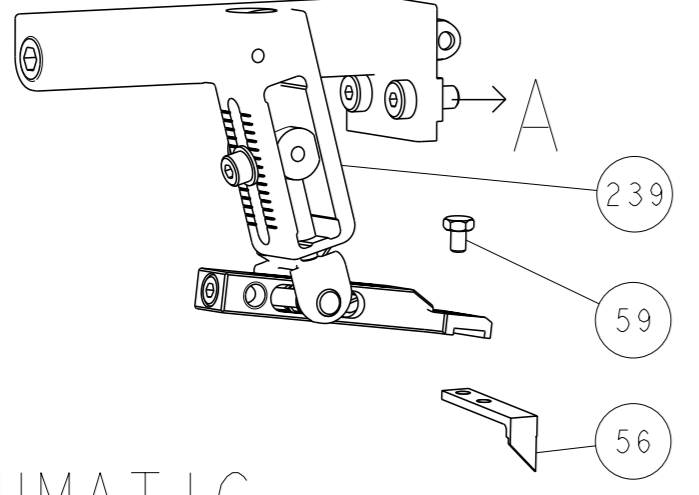
LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

				2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
				2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
				2119083-1	RETAINER, INSULATION DIAL	242
				7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
				2119580-1	MECHANICAL FEED ASSEMBLY	239
				2844940-1	AIR FEED MODULE	238
				2-1752354-5	STANDOFF, HOLD-DOWN	180
				6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
				8-22280-7	SPRING, COMPRESSION	176
				1752353-2	GUIDE PIN, HOLDDOWN	175
				1901680-2	GUIDE PIN, HOLDDOWN	174
				994970-2	COUNTER, MAGNETIC	164
				2119641-2	FEED CAM, AIR FEED	151
				2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
				2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
				2119653-2	FEED CAM, POST FEED	142
				1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
				1803516-1	RAM ASSEMBLY, SF PACIFIC	140
				1-18028-2	WASHER, FLAT, REG M4	119
				2844908-1	SCREW, LOCKING	99
				2844907-1	POST, LOCKING	98
				455888-5	SPACER, CRIMPER	82
				1803607-3	DOCUMENTATION PACKAGE	71
				2119740-1	TAG, IDENTIFICATION	67
				2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
				5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
				1338685-1	PAWL, FEED	56
				1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
				1901681-1	HOLDDOWN, TERMINAL	51
				18023-9	SCR, SKT HD CAP M4 X 6.0	49
				2119652-1	FEED CAM, PRE FEED	48
				1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
				2-1752356-0	SUPPORT, TERMINAL	34
				2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
				2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
				2844992-1	ASSEMBLY, STRIP GUIDE	29
				1-455888-0	SPACER, CRIMPER	28
				1320928-2	STRIP GUIDE	24
				2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
				1-18028-2	WASHER, FLAT, REG M4	20
				2119533-1	STRIPPER, SIDE FEED	19
				2119806-1	INSERT, SHEAR	13
				3-22280-3	SPRING, COMPRESSION	12
				1-356885-4	STOP, SHEAR	11
				2119805-1	SHEAR HOLDER, FRONT	10
				1803095-6	FLOATING SHEAR, FRONT	9
				1803058-2	ANVIL, COMBINATION	8
				-	-	7
				-	-	6
				2119757-8	DEPRESSOR, SHEAR	5
				1-238011-8	BLOCK, CRIMPER SPACER	4
				1-1803017-1	CRIMPER, INSULATION F	3
				455888-8	SPACER, CRIMPER	2
				7-1633609-0	CRIMPER, WIRE	1

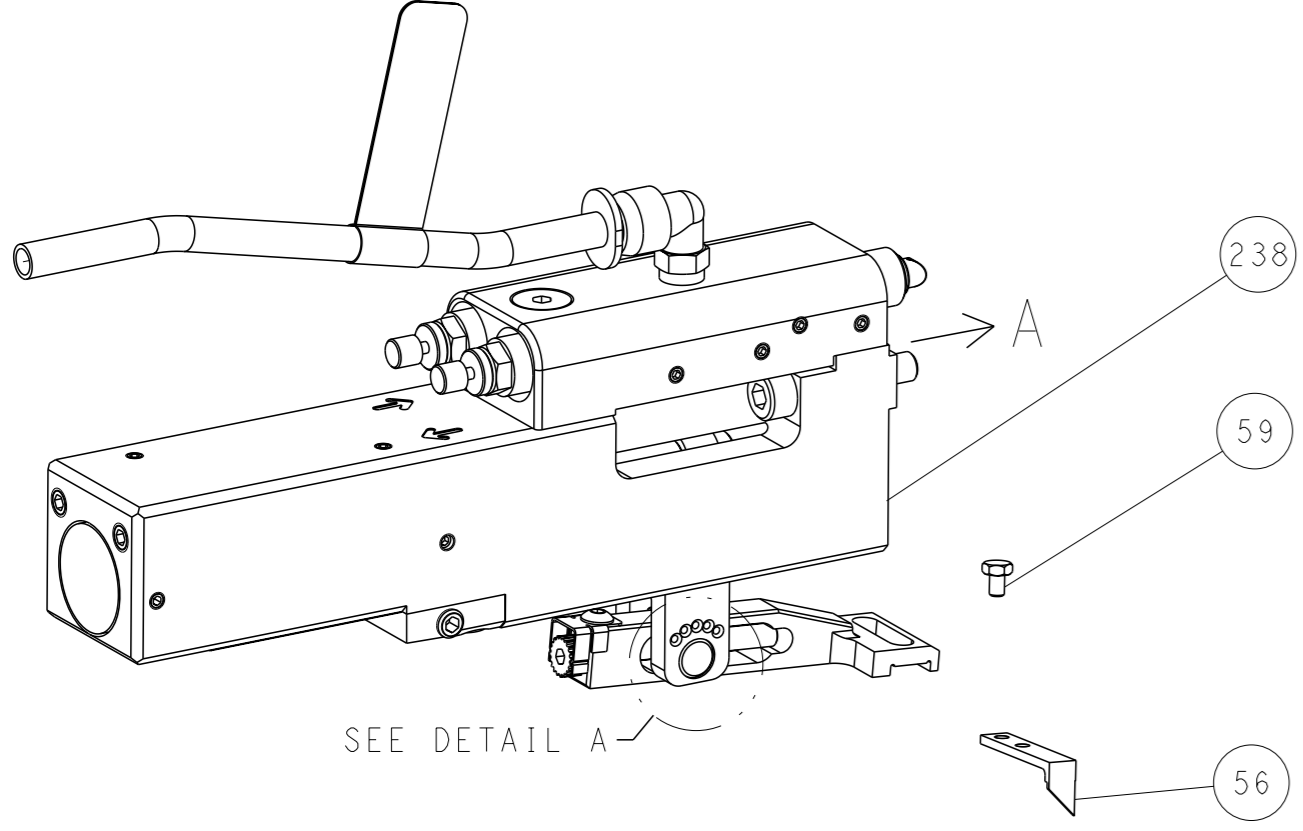
<small>THE DRAWING IS CONTROLLED DOCUMENT FOR THE PRODUCT. ANY CHANGES TO THE DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE PRODUCT MANAGER. THE DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: L. GROSS 06FEB2013 CHK: T. ELBIN 06FEB2013 APVD: M. CLIFFORD 06FEB2013	STE TE Connectivity 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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151871 SCALE: 1:2 SHEET: 3 of 4 REV: B	RESTRICTED TO: - Customer Accessible Production Drawing

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

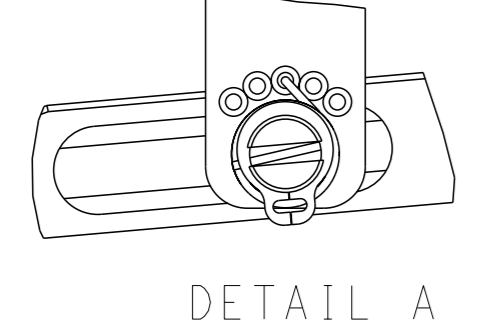
FEED TYPE MECHANICAL



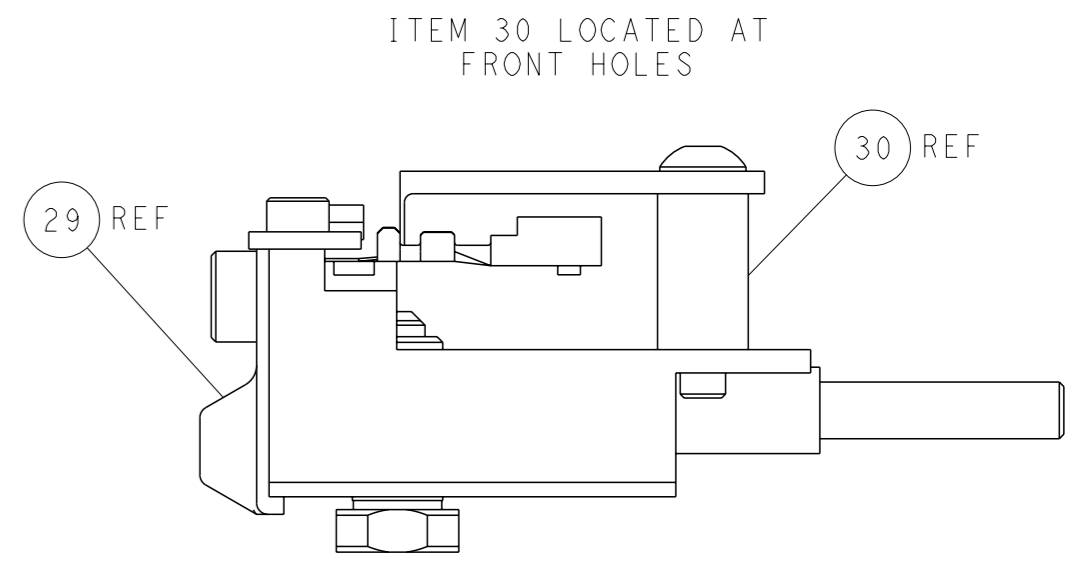
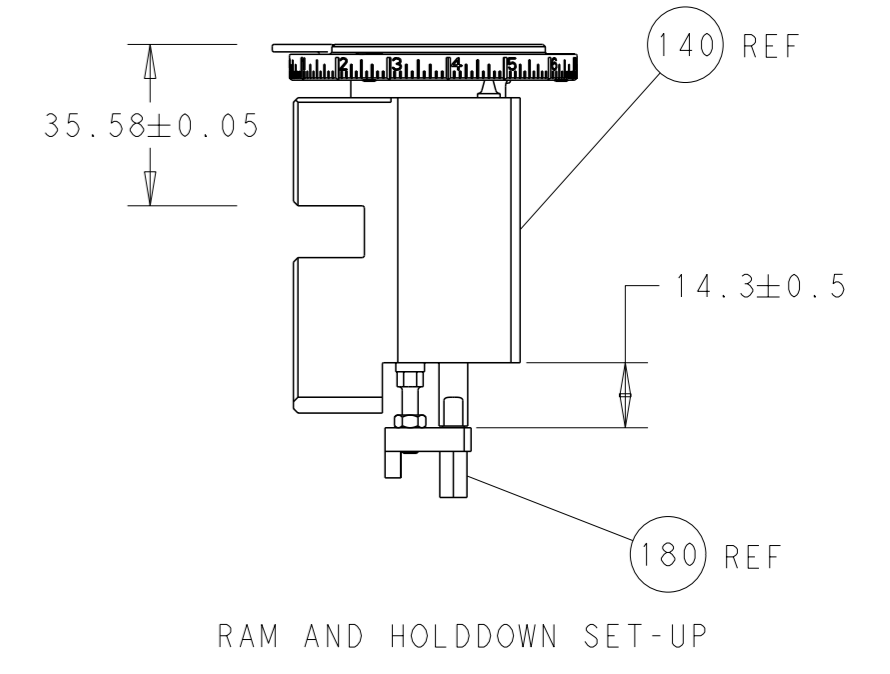
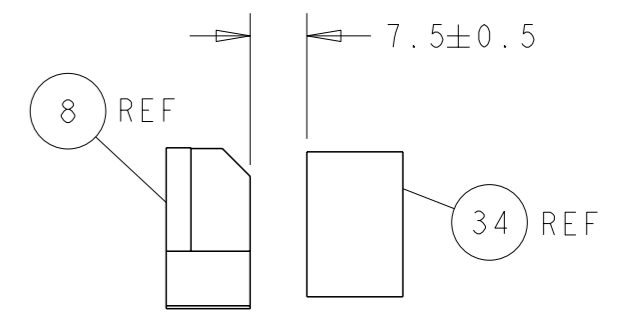
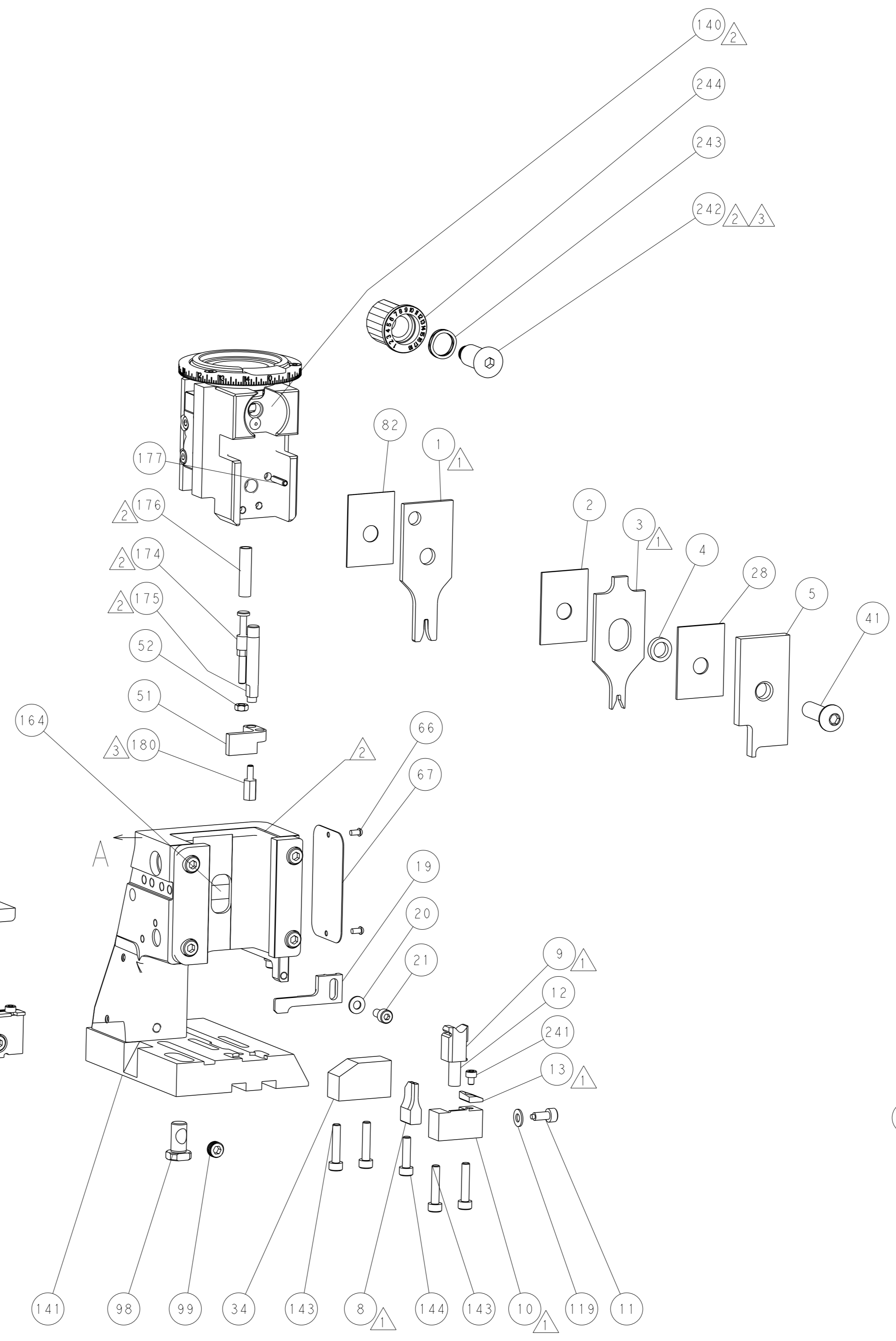
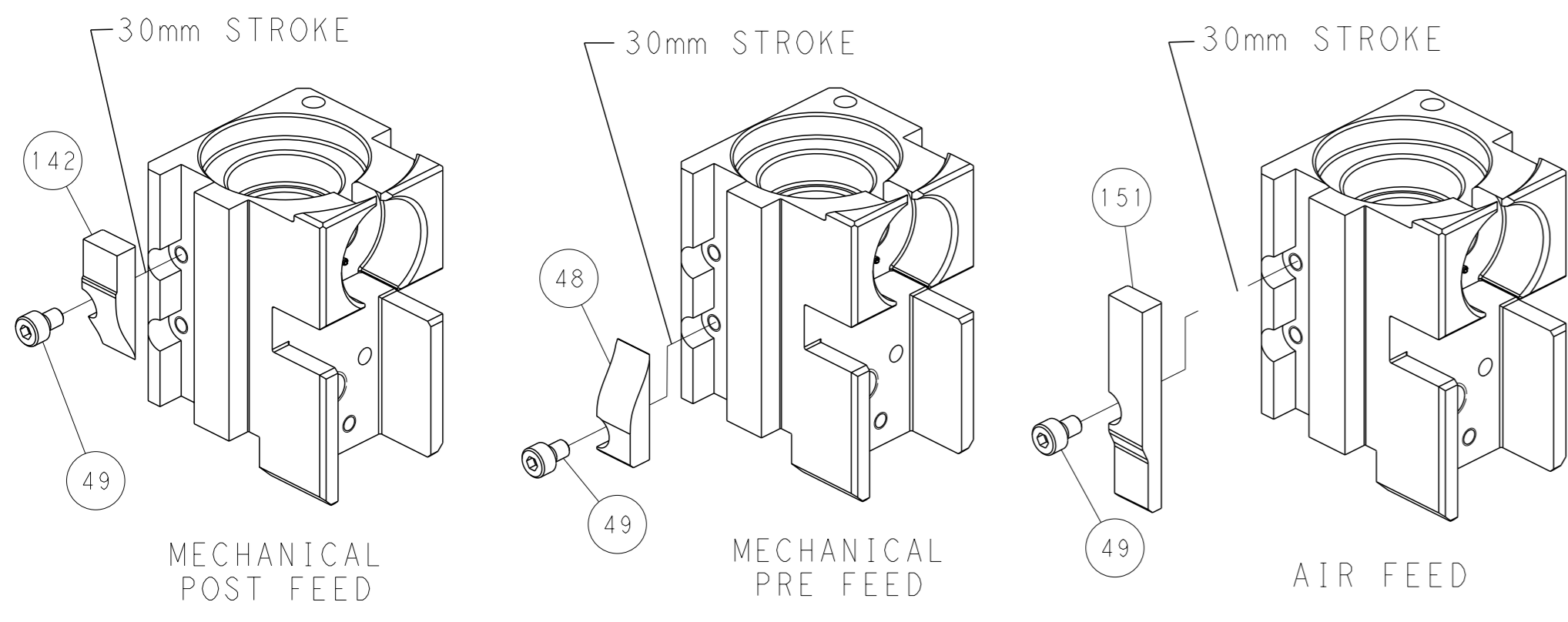
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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 SUBJECT TO CHANGE AND THE USER AND THE END USER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: L.GROSS 06FEB2013 CHK: T.ELBIN 06FEB2013 APVD: M.CLIFFORD 06FEB2013	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151871	RESTRICTED TO: - SHEET: 4 of 4 REV: B