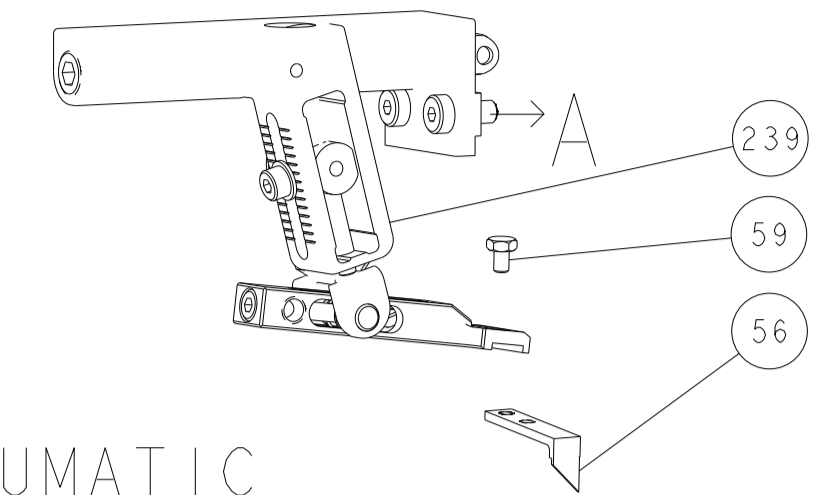


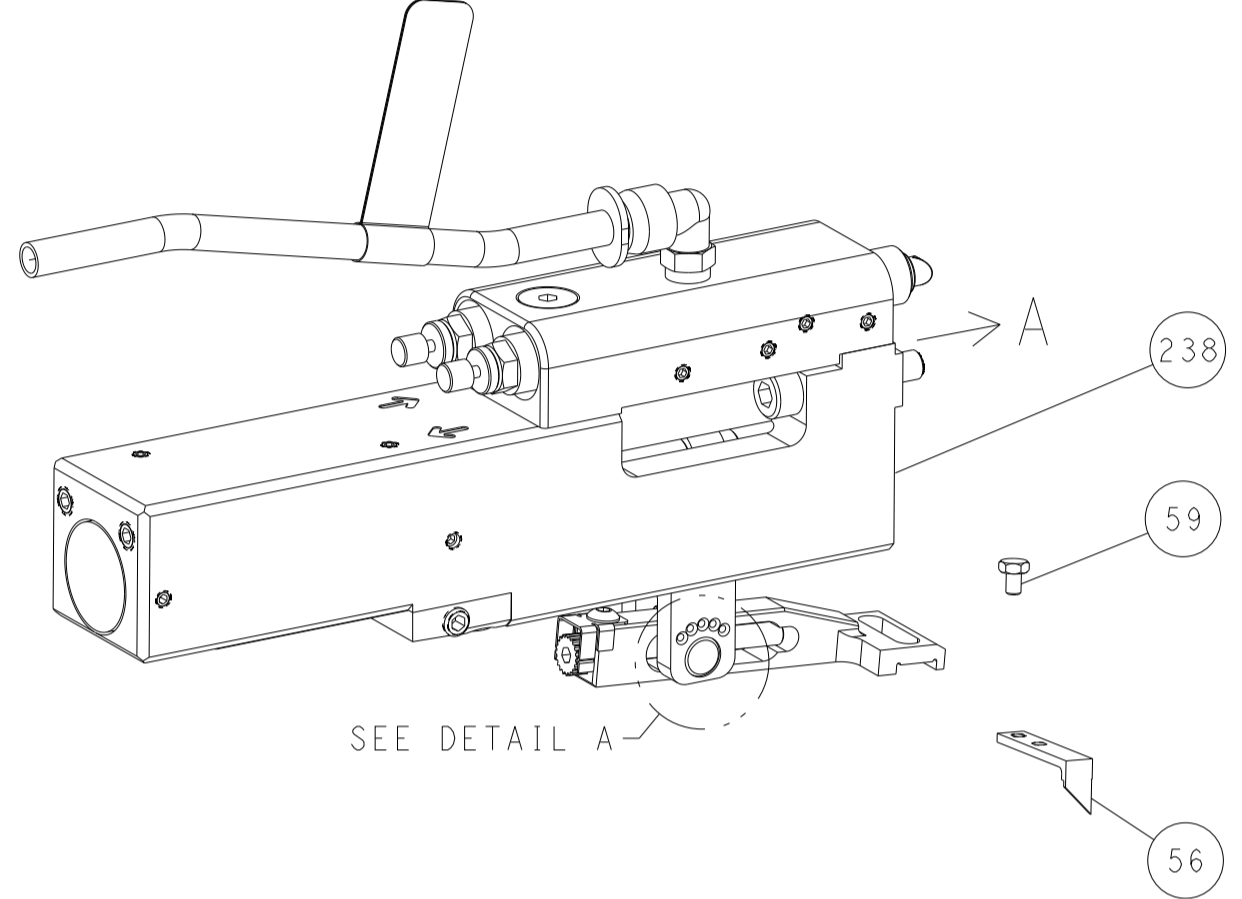


| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
|     |      | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
| A   | 66   | -         | -   | SEE SHEET 1 | -    | -   | -    |

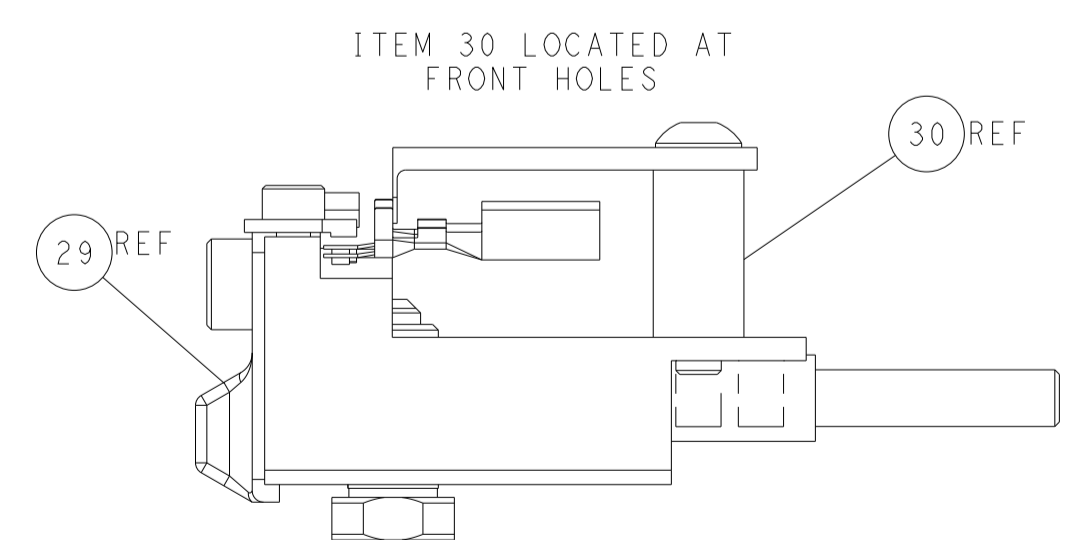
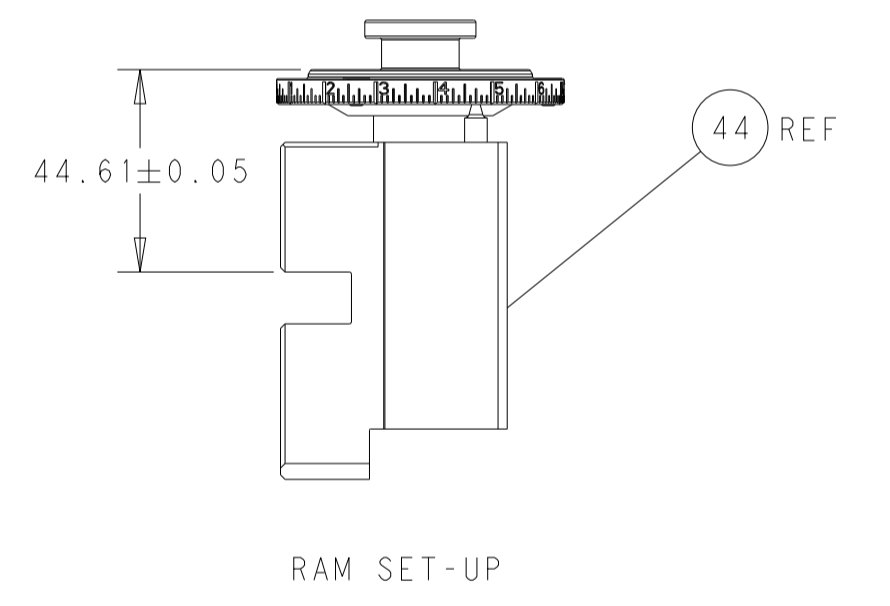
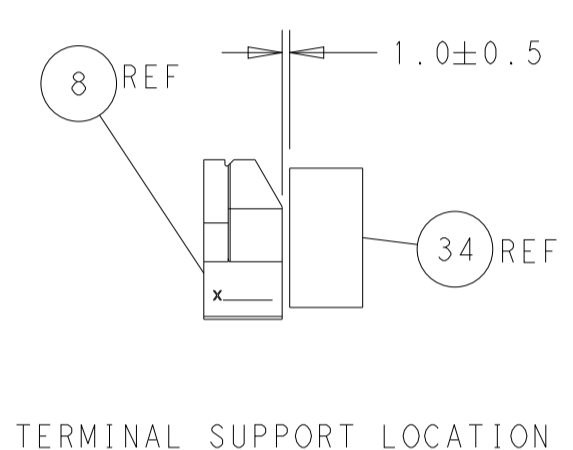
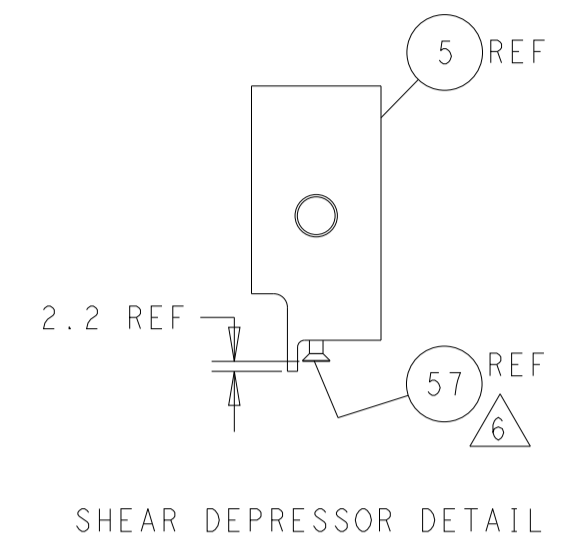
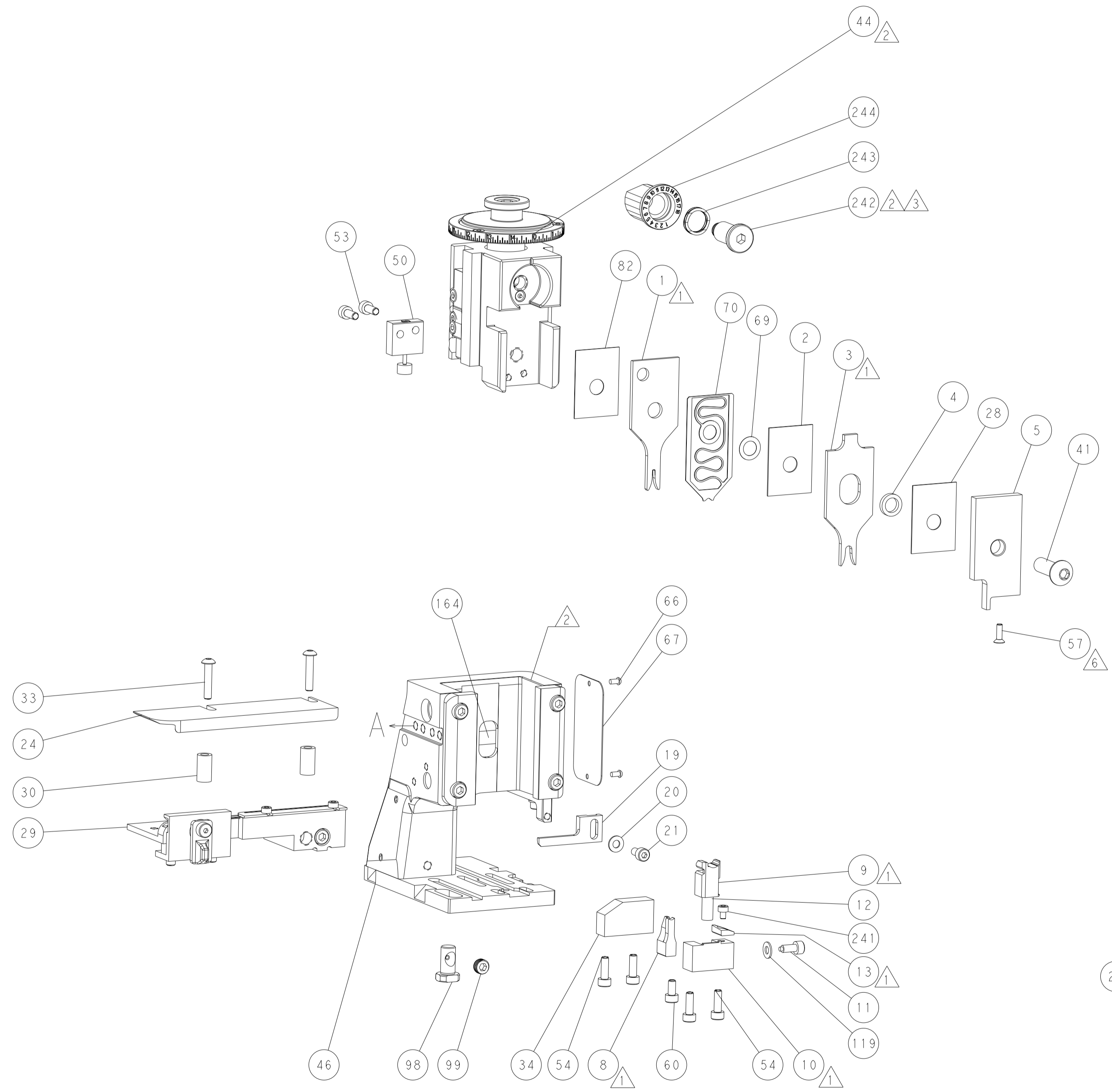
# FEED TYPE MECHANICAL



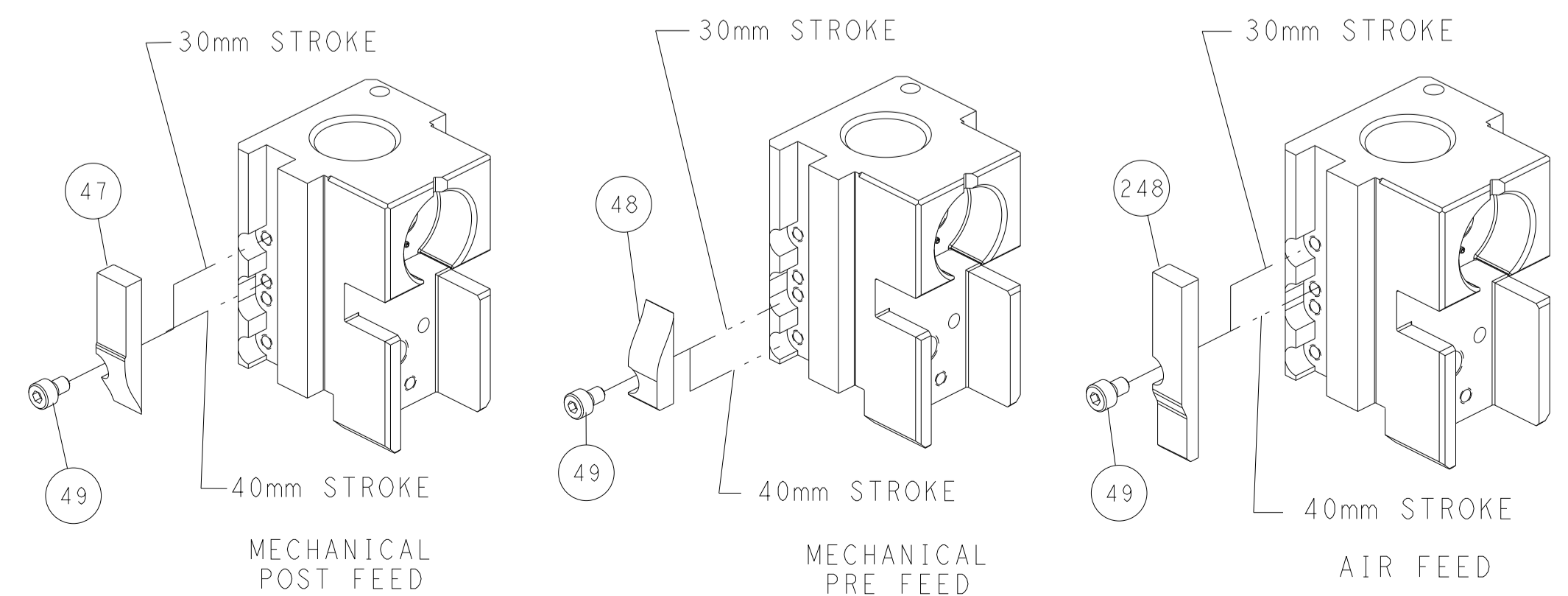
## PNEUMATIC



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



# CAM POSITIONS



**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THIS DRAWING IS UNPUBLISHED.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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>            |                          | DWN: C. CHEN 13MAR2012<br>CHK: S. XI 13MAR2012<br>APVD: J. CRUZ 13MAR2012 | NAME: Ocean Side Feed Applicator<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151564<br>SCALE: 1:2 | RESTRICTED TO: -<br>SHEET 2 OF 4<br>REV C1         |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH | WEIGHT: -<br>MATERIAL: - | CUSTOMER ACCESSIBLE PRODUCTION DRAWING                                    | TE Connectivity<br>Harrisburg, PA 17105-3608  | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION |

| PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE  |
|-------------|----------|--------------------------|------------|
| 2-2151564-1 | B        | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151564-2 | C        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC  |
| 7-2151564-7 | A        | CRIMP TOOLING KIT        | -          |

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.40 mm [.055] | F    |
| INSUL                                | 3.94 mm [.155] | O    |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                |      |

| TERMINAL DATA: TE TERMINAL                       |           | TE CRIMP SPECIFICATION                                   |   |
|--|-----------|--|---|
| TERMINAL NAME: AMP MCP2.8K FLAT TYPE RECEPTACLE  |           |  |   |
| WIRE STRIP LENGTH<br>3.40-4.00 mm [1.34-.157 IN] |           | INSULATION DIAMETER RANGE<br>Ø 1.1-1.5mm [1.043-.059 IN] |   |
| TERMINAL APPLICATION SPECIFICATION               | 114-18387 | -  | - |

| TERMINALS APPLIED |             |          |         | SEAL INSLATION DIAMETER RANGE |
|-------------------|-------------|----------|---------|-------------------------------|
| TE TERMINAL       | TE TERMINAL | TE SEAL  | TE SEAL |                               |
| 1241392-1         | 1241392-3   | 963294-1 |         | Ø 1.2-2.0mm                   |
| 1241392-2         |             |          |         | Ø 1.2-2.0mm                   |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 0.35mm2   | 1.03+/-0.03 [1.041+/-0.001] | 6.8                            |
| 0.25mm2   | 0.98+/-0.03 [1.039+/-0.001] | 7.4                            |
| 0.22mm2   | 0.96+/-0.03 [1.038+/-0.001] | 7.6                            |
| 0.20mm2   | 0.96+/-0.03 [1.038+/-0.001] | 7.6                            |

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 6 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 7 TERMINAL 1241392 IS REPLACED BY TERMINAL 1564984. IF USING TERMINING 1564984 PLEASE USE APPLICATOR 2151484.

**\*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 | DWN | APVD |
| -   | -    | -         | -   | SEE SHEET 1 | -    | -   | -    |

|   |     |     |             |                                     |     |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | 1   | 2119082-9   | 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   | 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   | 455888-4    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 2119791-9   | DEPRESSOR, WIRE                     | 70  |
| - | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69  |
| - | 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   | 985575-3    | SCR, FLT SKT HD CAP M3 X 10.0       | 57  |
| - | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53  |
| - | 1   | 1   | 1803382-2   | 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   | 1-1752356-7 | 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   | 2844992-2   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 28  |
| - | 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   | 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   | 318707-1    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 4-1333201-9 | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 2-2119781-4 | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 238011-4    | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 2-2119784-9 | CRIMPER, INSULATION O PREMIUM       | 3   |
| - | 1   | 1   | 455888-6    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 456402-1    | CRIMPER, WIRE PREMIUM               | 1   |

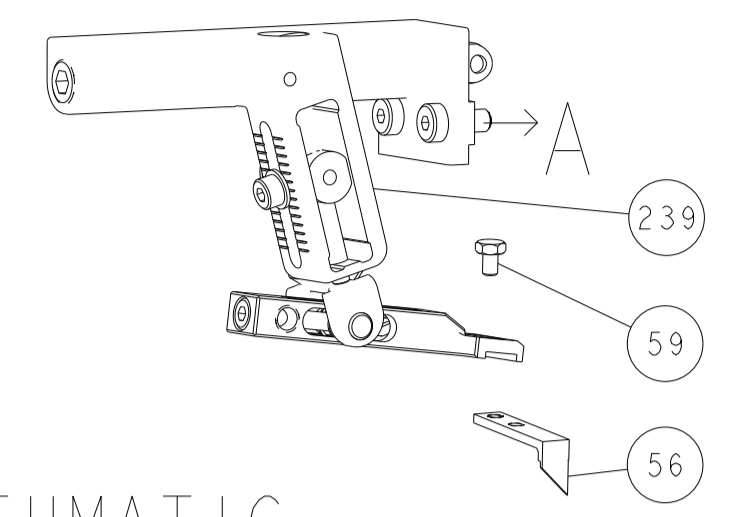
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

|                |  |  |  |                       |  |                     |  |                         |  |                                  |  |
|----------------|--|--|--|-----------------------|--|---------------------|--|-------------------------|--|----------------------------------|--|
| DIMENSIONS: mm |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DWG: C.CHEN 13MAR2012 |  | CHK: S.XI 13MAR2012 |  | APVD: J. CRUZ 13MAR2012 |  | NAME: Ocean Side Feed Applicator |  |
| MATERIAL: -    |  | FINISH: -                              |  | WEIGHT: -             |  | SCALE: 1:2          |  | SHEET: 3 OF 4           |  | REV: C1                          |  |

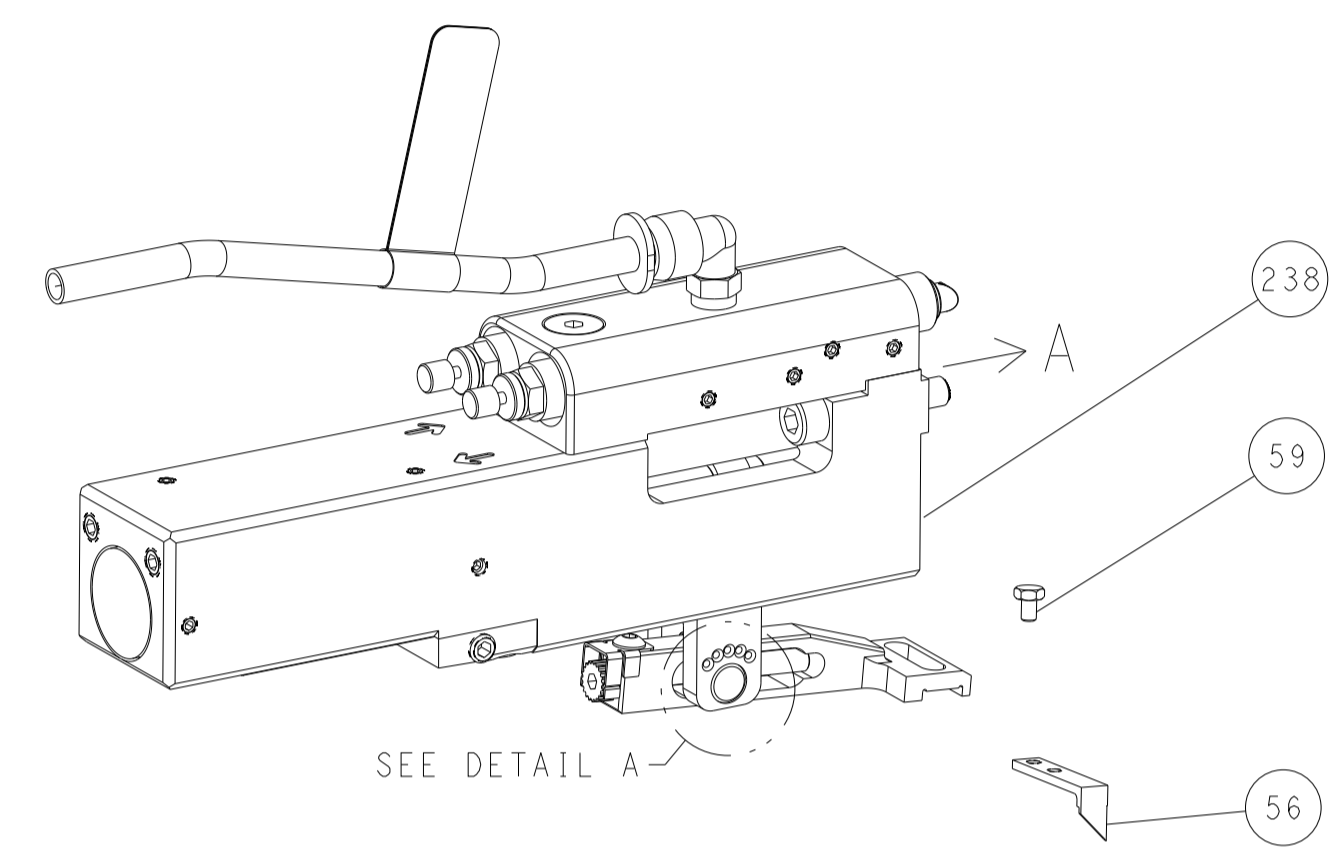
Customer Accessible Production Drawing

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

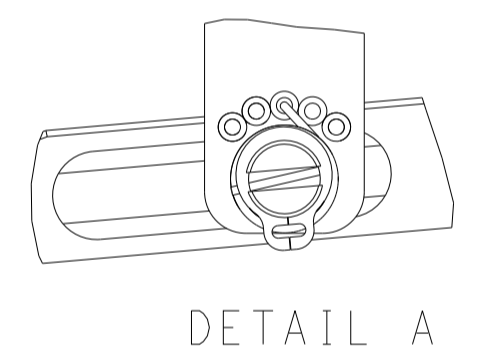
# FEED TYPE MECHANICAL



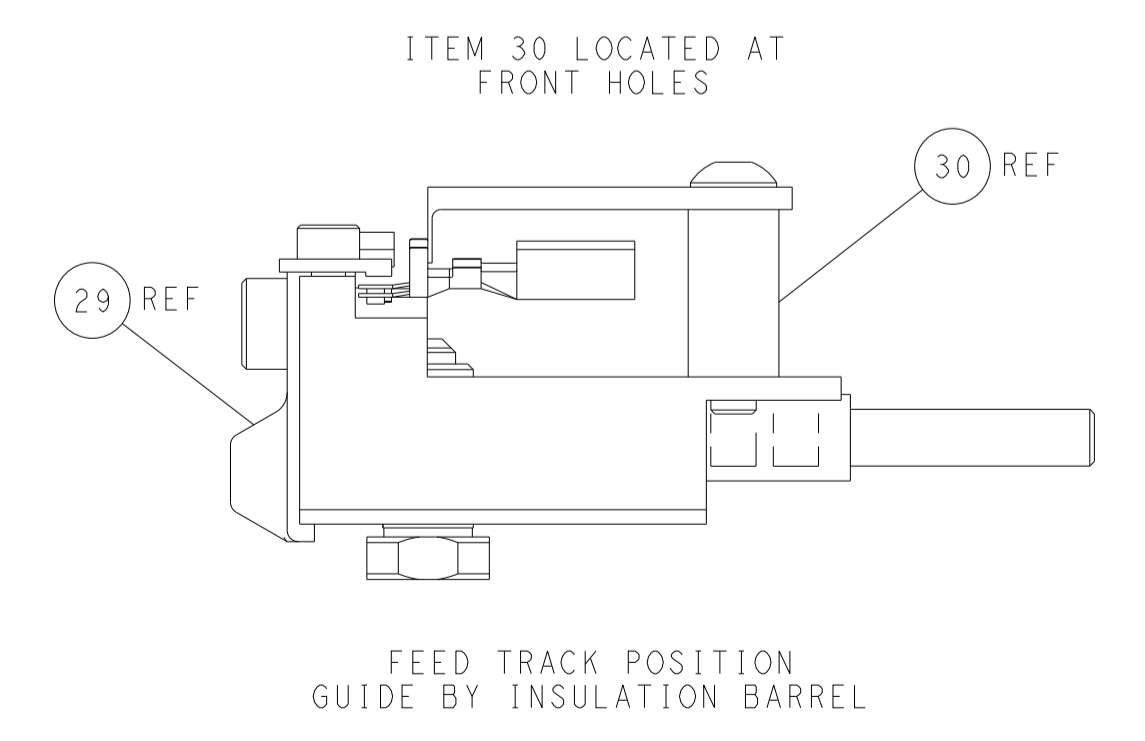
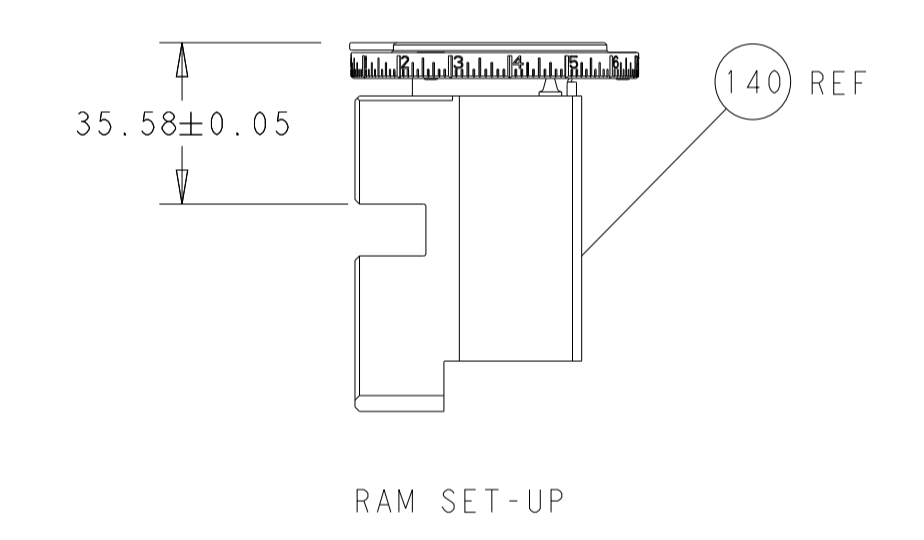
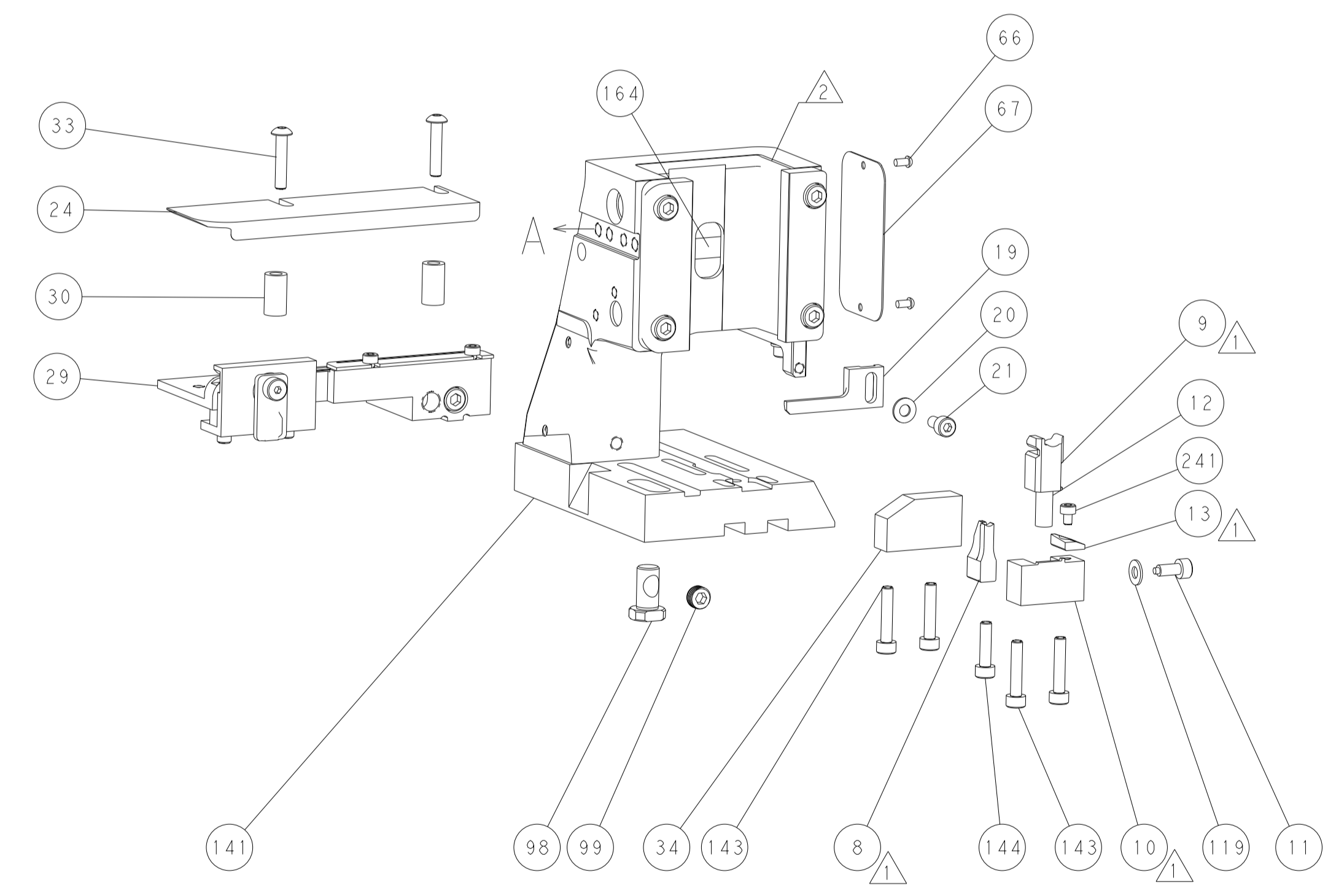
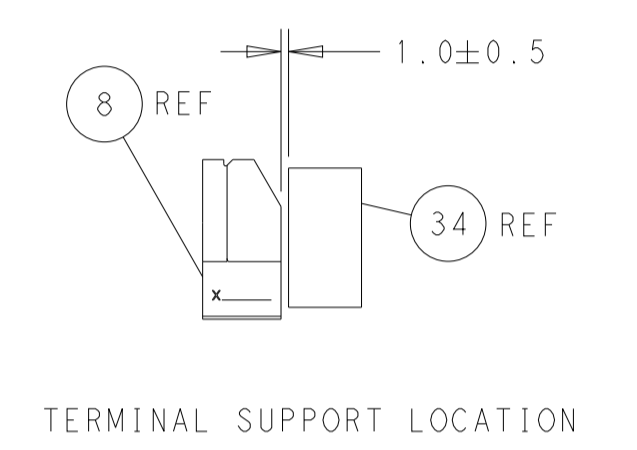
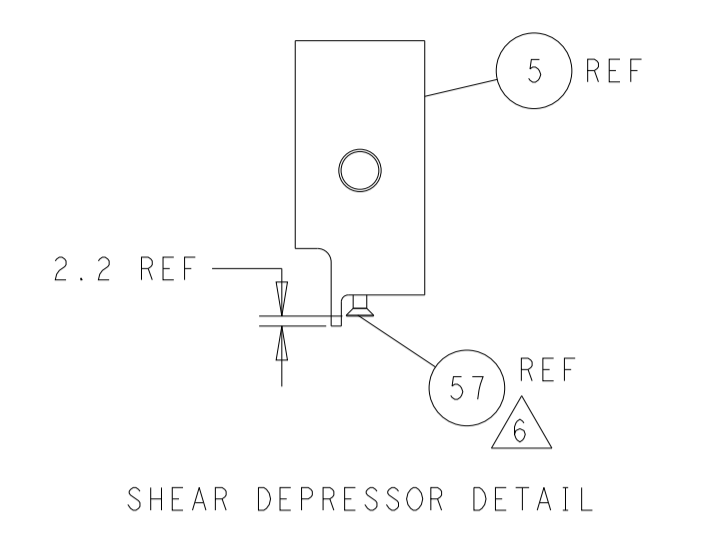
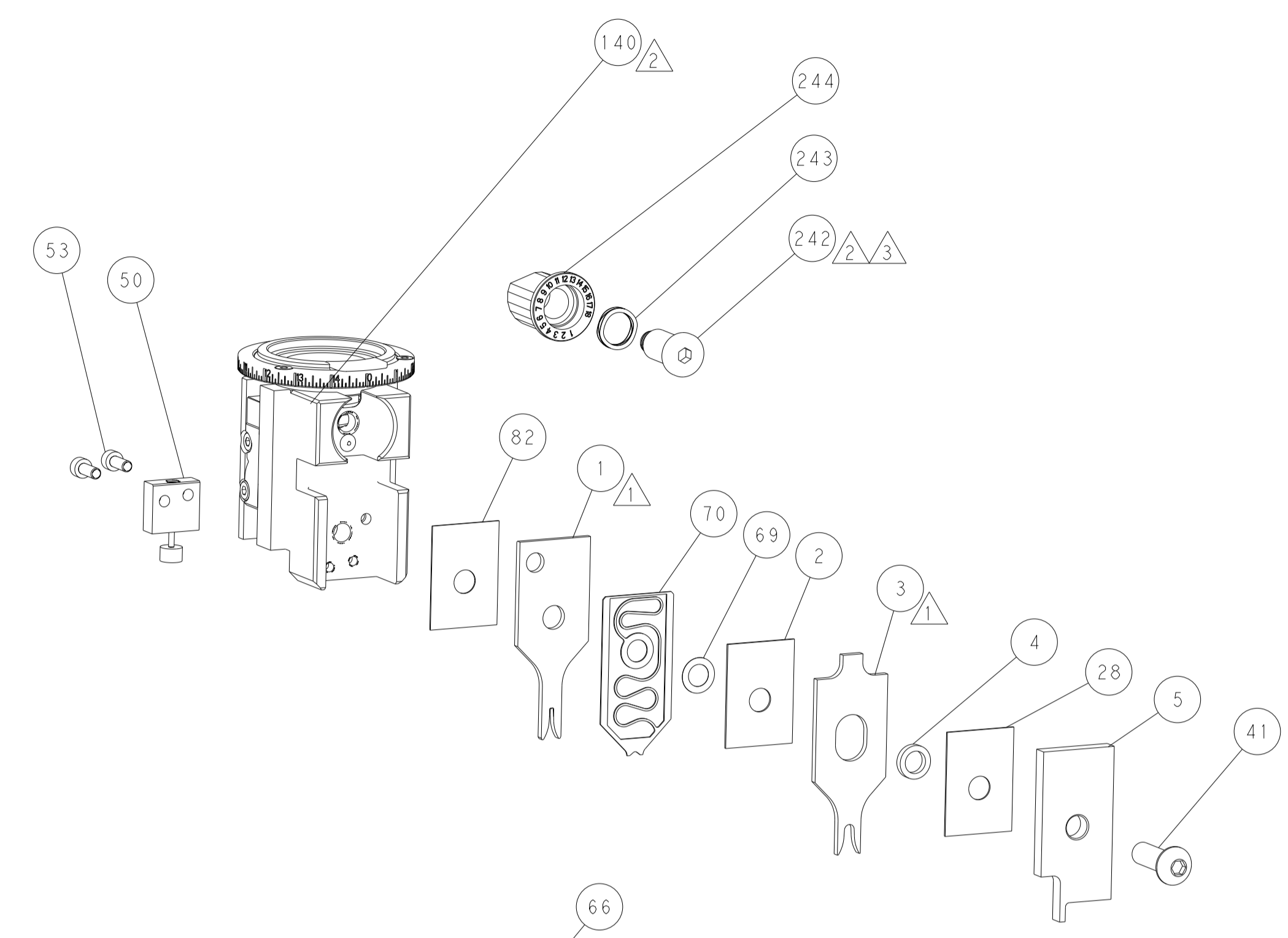
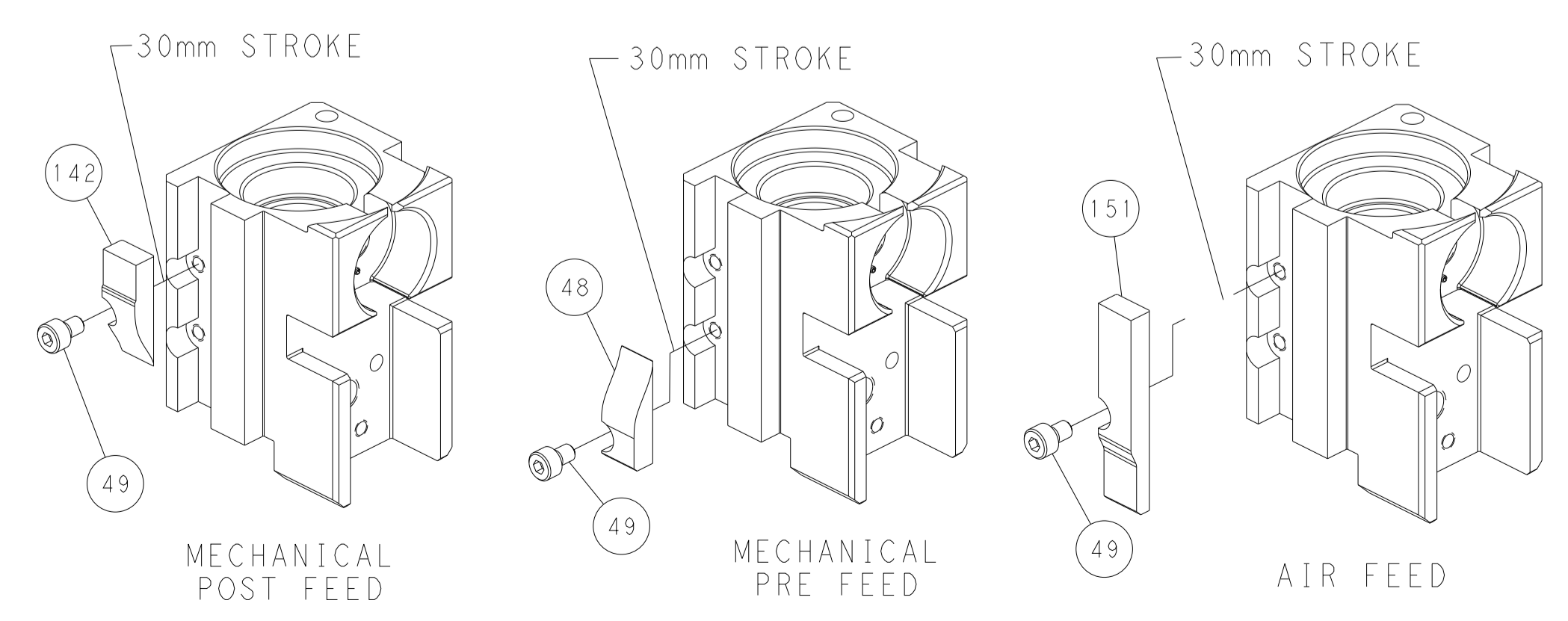
## PNEUMATIC



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



# CAM POSITIONS



**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<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ±   |  | NAME: Ocean Side Feed Applicator<br>APPLICATION SPEC: -<br>PRODUCT SPEC: -<br>WEIGHT: -<br>SCALE: 1:2 | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151564<br>SHEET 4 OF 4<br>REV C1 |
| MATERIAL: -<br>FINISH: -   |  | Customer Accessible Production Drawing  |   |