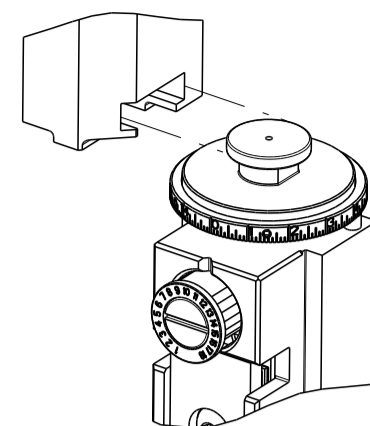


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--|-----------|
| 2151954-2 | F | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 5-2151954-2 | F | SEAL STRIPPER CRIMPER TERMINATING UNIT | PNEUMATIC |
| 7-2151954-2 | F | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151954-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



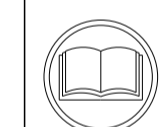
| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 3.25 mm [.128] | F |
| INSUL | 4.45 mm [.175] | O |

APPLICATOR INSTRUCTIONS
408-35042

| TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION | |
|---|------------------------------|
| TERMINAL NAME: MALE METRI-PACK 280 | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE |
| 4.90-5.28 mm [.193-.208 IN] | ∅2.45-3.25 mm [.096-.128 IN] |
| TERMINAL APPLICATION SPECIFICATION | DELPHI Rev - |
| | CODE LEGEND 1005 |

| TERMINALS APPLIED | | | | |
|-------------------|-----------------|-----------|-------------|--------------------------------|
| TE TERMINAL | DELPHI TERMINAL | TE SEAL | DELPHI SEAL | SEAL INSULATION DIAMETER RANGE |
| 286945-1 | 12129497 | 1572716-3 | 15324980 | ∅2.81-3.49mm |
| | | 1949807-1 | 15324982 | ∅2.03-2.85mm |
| | | 1949896-1 | 15324981 | ∅3.45-4.30mm |
| | | 286953-3 | 12015284 | ∅2.85-2.03mm |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 3.00mm2 | 1.90+/-0.05 [.075+/- .002] | 6.2 |
| 2.00mm2 | 1.65+/-0.05 [.065+/- .002] | 8.8 |



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- WIRE SIZE NOT RECOMMENDED FOR SEAL STRIPPER CRIMPER TERMINATING UNIT.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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)

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | DWN | APVD |
| | | D5 | | ECR-18-012060 | 27JUL2018 | VLA | CT |
| | | E | | ECR-19-009011 | 08JUN2019 | TB | TE |
| | | F | | ECR-22-129003 | 03MAR2022 | LG | TE |

| | | | | | | | |
|---|-----|-----|-----|-------------|-------------------------------------|--|-----|
| - | 1 | 1 | 1 | 1803945-4 | TONKER | | 300 |
| - | 1 | 1 | 1 | 22278-9 | SPRING, COMPRESSION | | 299 |
| - | 2 | 2 | 2 | 4-18032-3 | SCR, SET, FLT PNT, M3 X 6.0 | | 298 |
| - | 1 | 1 | 1 | 1803944-1 | SPACER, TONKER | | 297 |
| - | - | 1 | - | 2-1803583-1 | APPLICATOR BASIC ASSEMBLY, SF | | 292 |
| - | 1 | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | | 248 |
| - | 1 | 1 | 1 | 2119082-7 | CAM, SNAIL, INSULATION ADJUSTMENT | | 244 |
| - | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | | 243 |
| - | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | | 242 |
| - | 1 | 1 | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | | 241 |
| - | 1 | 1 | 1 | 2844940-1 | AIR FEED MODULE | | 238 |
| - | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | | 164 |
| - | 1 | 1 | 1 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | | 113 |
| - | 1 | 1 | 1 | 2844908-1 | SCREW, LOCKING | | 99 |
| - | 1 | 1 | 1 | 2844907-1 | POST, LOCKING | | 98 |
| - | 1 | 1 | 1 | 455888-4 | SPACER, CRIMPER | | 82 |
| - | 2 | 2 | 2 | 18024-6 | SCR, BTN SKT HD CAP (M4 X 8.0) | | 79 |
| - | 1 | 1 | 1 | 1803096-1 | EXTENSION PLATE | | 78 |
| - | 1 | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | | 71 |
| - | 1 | 1 | 1 | 2119791-5 | DEPRESSOR, WIRE | | 70 |
| - | 1 | 1 | 1 | 2119943-1 | WASHER, SPACER | | 69 |
| - | 1 | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | | 67 |
| - | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | | 66 |
| - | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | | 60 |
| - | 1 | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | | 59 |
| - | 1 | 1 | 1 | 985575-3 | SCR, FLT SKT HD CAP M3 X 10.0 | | 57 |
| - | 1 | 1 | 1 | 1338683-8 | FEED PAWL | | 56 |
| - | 4 | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | | 54 |
| - | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | | 53 |
| - | 1 | 1 | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | | 49 |
| - | 1 | - | 1 | 1803583-9 | APPLICATOR BASIC ASSEMBLY, SF | | 46 |
| - | 1 | 1 | 1 | 1803515-1 | RAM ASSEMBLY, SF ATLANTIC | | 44 |
| - | 1 | 1 | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | | 41 |
| - | 1 | 1 | 1 | 1752356-1 | SUPPORT, TERMINAL | | 34 |
| - | 2 | 2 | 2 | 2079383-8 | SCR, BHSC, RoHS (M4 X 16) | | 33 |
| - | 2 | 2 | 2 | 1-2844962-7 | SPACER, CYLINDRICAL, STRIP GUIDE | | 30 |
| - | 1 | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | | 29 |
| - | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | | 28 |
| - | 1 | 1 | 1 | 1320928-4 | STRIP GUIDE | | 24 |
| - | 1 | - | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | | 21 |
| - | 2 | 1 | 2 | 1-18028-2 | WASHER, FLAT, REG M4 | | 20 |
| - | 1 | - | 1 | 2119533-1 | STRIPPER, SIDE FEED | | 19 |
| - | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | | 13 |
| - | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | | 12 |
| - | 1 | 1 | 1 | 1-356885-4 | STOP, SHEAR | | 11 |
| - | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | | 10 |
| - | 1 | 1 | 1 | 1803095-1 | FLOATING SHEAR, FRONT | | 9 |
| 1 | 2 | 1 | 1 | 2-1633928-5 | ANVIL, COMBINATION | | 8 |
| - | 1 | 1 | 1 | 8-240641-5 | SPACER | | 7 |
| - | - | - | - | - | - | | 6 |
| - | 1 | 1 | 1 | 1-2119781-0 | DEPRESSOR, SHEAR | | 5 |
| - | 1 | 1 | 1 | 5-238011-5 | BLOCK, CRIMPER SPACER | | 4 |
| 1 | 2 | 1 | 1 | 5-1633965-9 | CRIMPER, INSULATION O PREMIUM | | 3 |
| - | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | | 2 |
| 1 | 2 | 1 | 1 | 3-1673600-2 | CRIMPER, WIRE | | 1 |

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

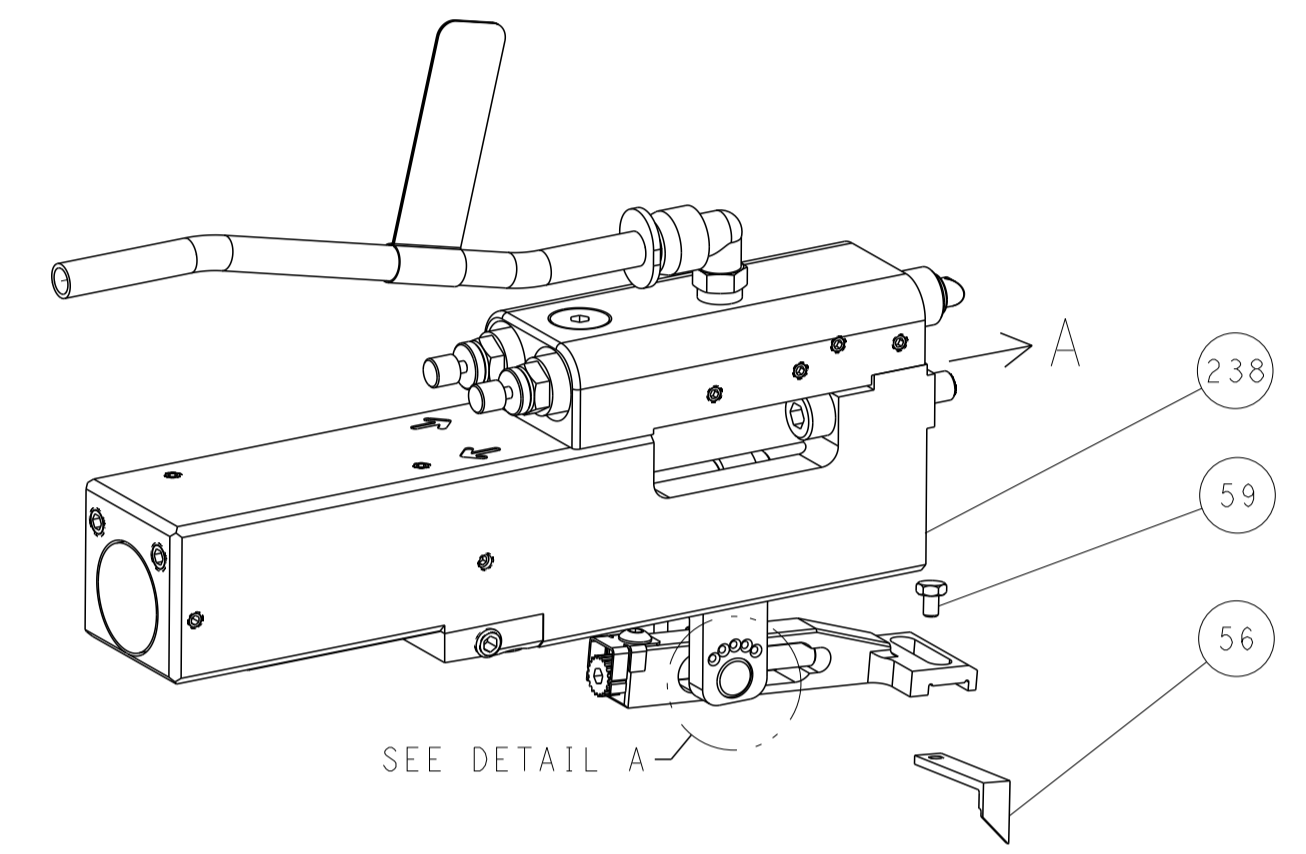
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| | | | |
|--|----------------------------|------------|---------------|
| OWN | HOFFNER | 30MAY2013 | |
| CHK | T. ELBIN | 31MAY2013 | |
| APVD | T. ELBIN | 31MAY2013 | |
| NAME | Ocean Side Feed Applicator | | |
| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| A1 | 00779 | 2151954 | |
| Customer Accessible Production Drawing | | | |

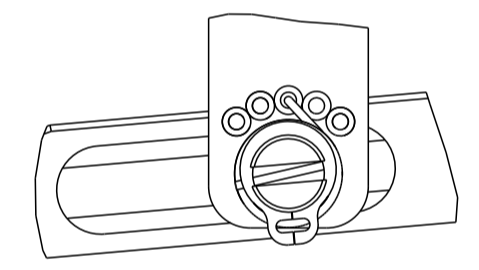
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|-----|------|-------------|------|-----|------|
| P | LTN | DESCRIPTION | DATE | OWN | APVD |
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| | | | | | |
| | | | | | |

FEED TYPE

PNEUMATIC

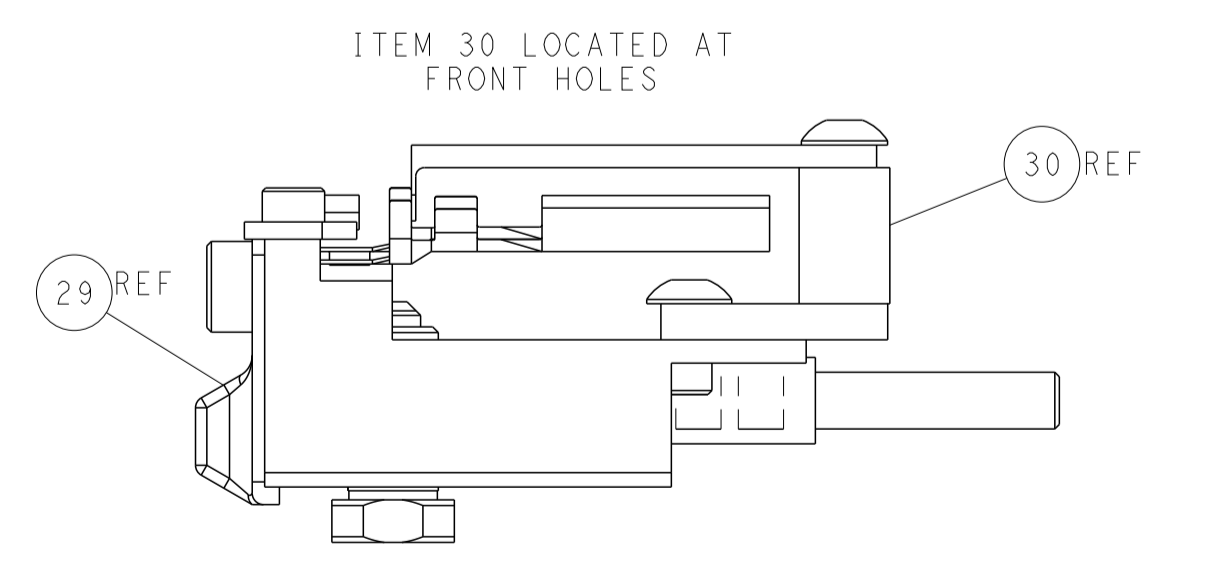
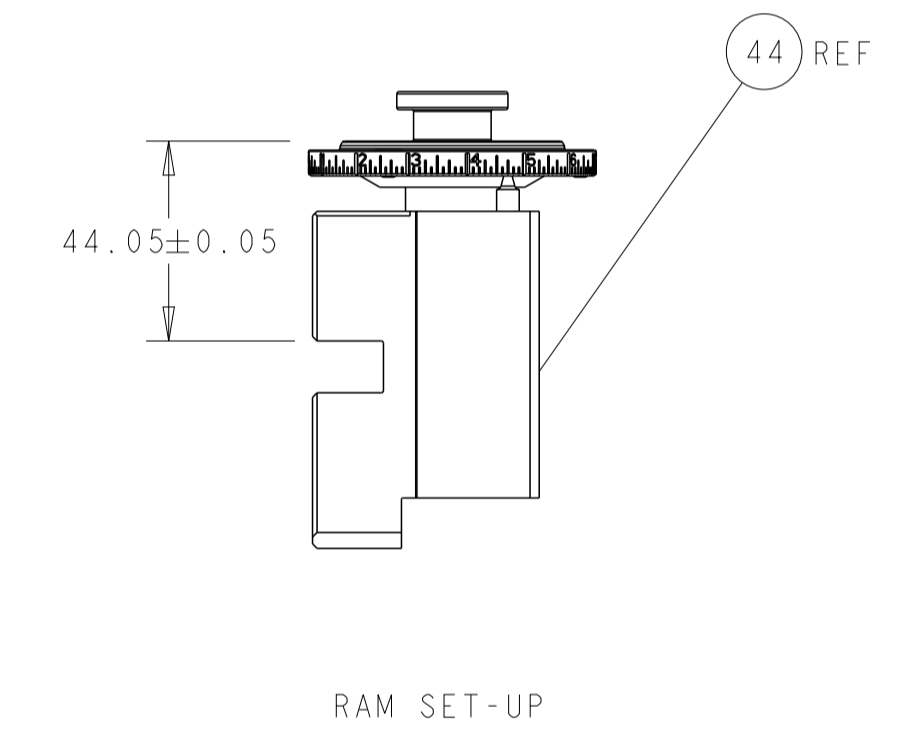
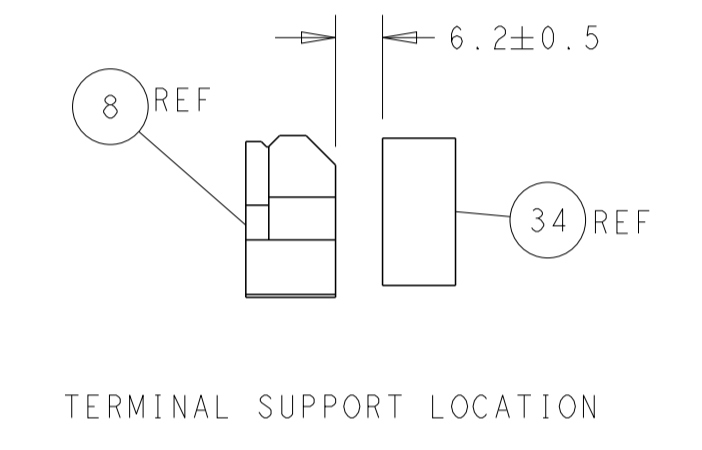
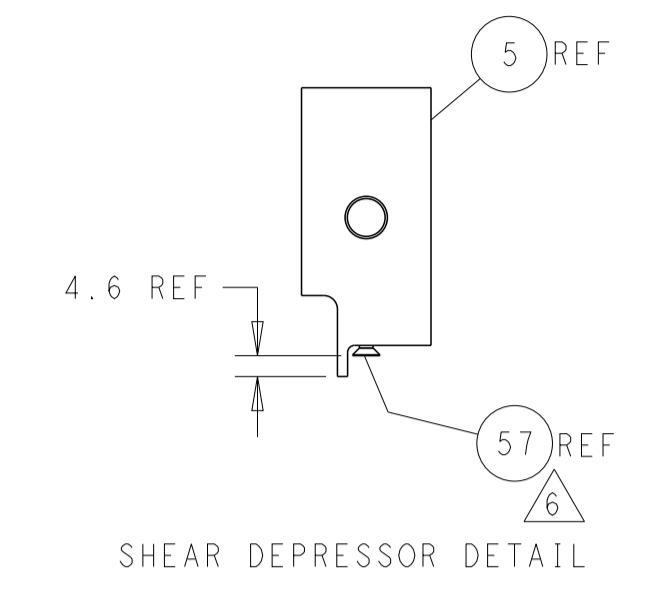
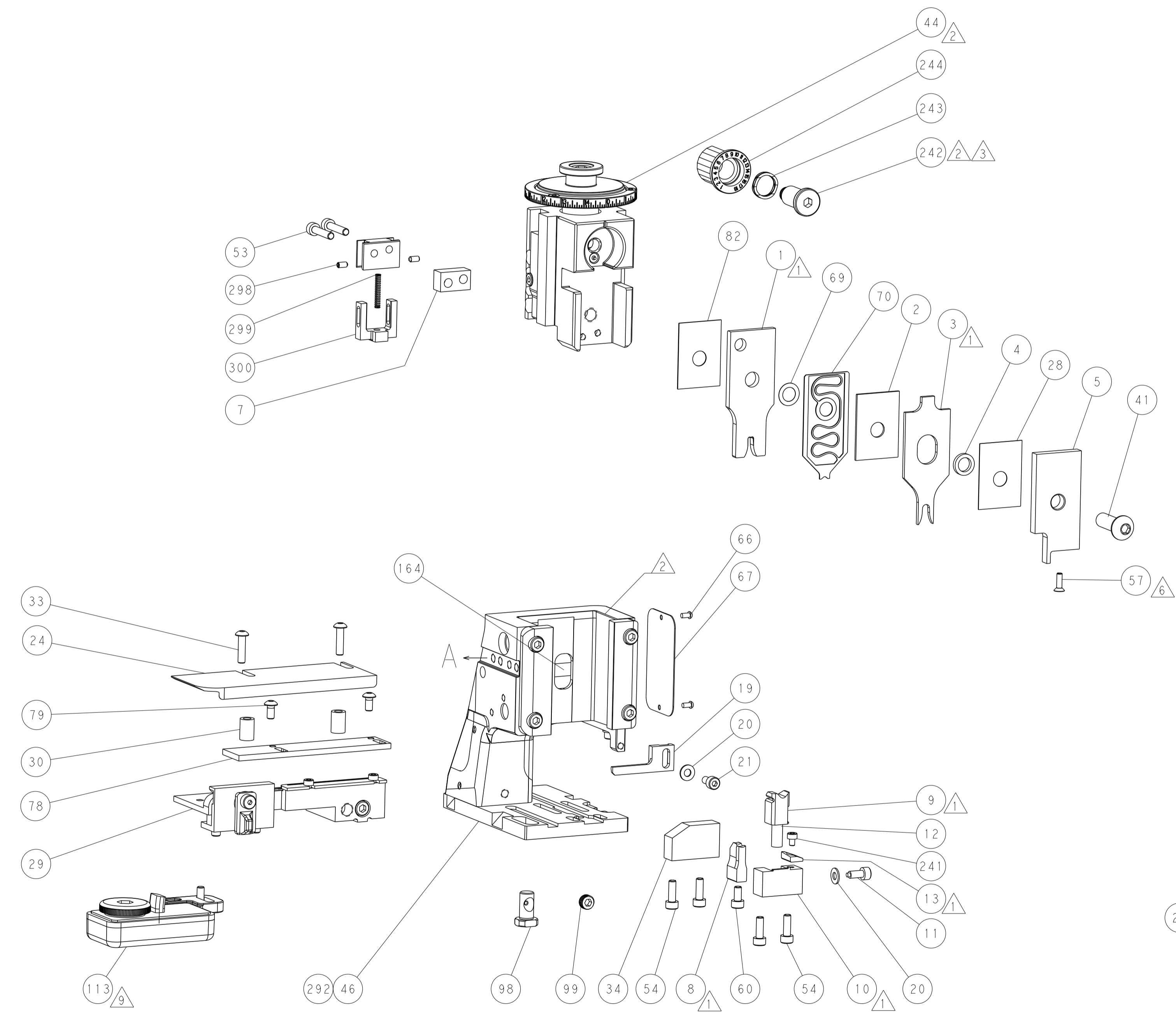
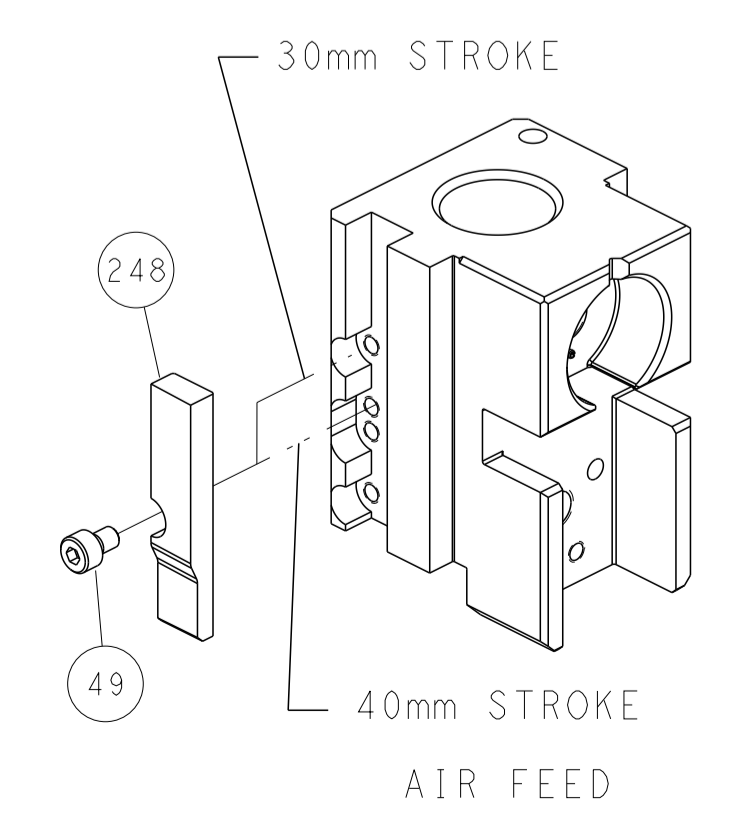


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITION



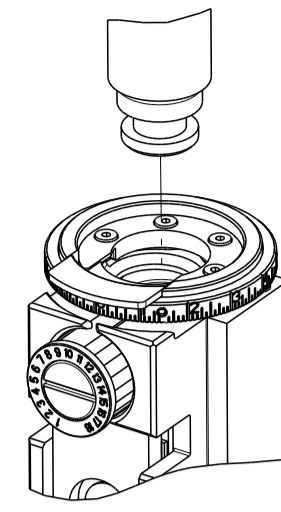
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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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| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | MATERIAL: - FINISH: - | RESTRICTED TO: - SCALE: 1:2 SHEET 2 OF 4 REV F | TE Connectivity Harrisburg, PA 17105-3608 |

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|--|--------------------------|--------------------------|-----------|
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| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
| 2-2151954-2 | F | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151954-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 3.25 mm [.128] | F |
| INSUL | 4.45 mm [.175] | O |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| | |
|--|--|
| TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION | |
| TERMINAL NAME: MALE METRI-PACK 280 | |
| WIRE STRIP LENGTH 4.90-5.28 mm [1.93-.208 IN] | INSULATION DIAMETER RANGE Ø 2.45-3.25 mm [0.96-.128 IN] |
| TERMINAL APPLICATION SPECIFICATION DELPHI Rev - CODE LEGEND 1005 | |

| TERMINALS APPLIED | | | | |
|-------------------|-----------------|-----------|-------------|--------------------------------|
| TE TERMINAL | DELPHI TERMINAL | TE SEAL | DELPHI SEAL | SEAL INSULATION DIAMETER RANGE |
| 286945-1 | 12129497 | 1572716-3 | 15324980 | Ø 2.81-3.49mm |
| | | 1949807-1 | 15324982 | Ø 2.03-2.85mm |
| | | 1949896-1 | 15324981 | Ø 3.45-4.30mm |
| | | 286953-3 | 12015284 | Ø 2.85-2.03mm |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 3.00mm2 | 1.90 +/- 0.05 [0.075 +/- .002] | 6.2 |
| 2.00mm2 | 1.65 +/- 0.05 [0.065 +/- .002] | 8.8 |

- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 APPLY TORO-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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 8 WIRE SIZE NOT RECOMMENDED FOR SEAL STRIPPER CRIMPER TERMINATING UNIT.
- 9 TERMINAL LUBRICANT IS RECOMMENDED.

***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)

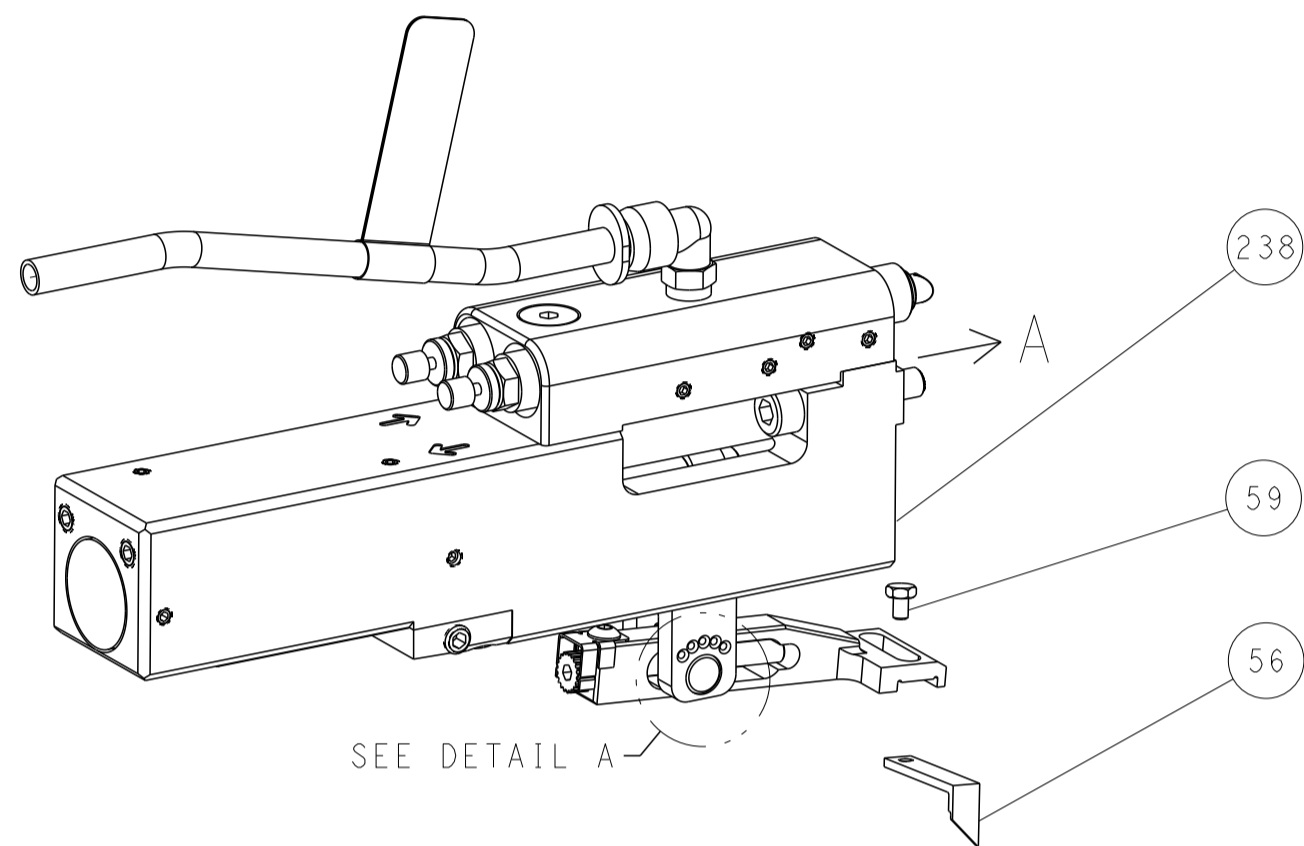
| LOC | DIST | REV | DATE | BY | APPD |
|-----|------|-----|------|----|------|
| A | 66 | | | | |

| REVISIONS | | | | | |
|-----------|------|-------------|------|-------------------------------------|------|
| REV | DATE | DESCRIPTION | DATE | BY | APPD |
| - | - | SEE SHEET 1 | - | - | - |
| - | 1 | 1803945-4 | | TONKER | 300 |
| - | 1 | 22278-9 | | SPRING, COMPRESSION | 299 |
| - | 2 | 4-18032-3 | | SCR, SET, FLT PNT, M3 X 6.0 | 298 |
| - | 1 | 1803944-1 | | SPACER, TONKER | 297 |
| - | 1 | 2119082-7 | | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 2079764-1 | | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 2119083-1 | | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 7-18023-7 | | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | 1 | 2844940-1 | | AIR FEED MODULE | 238 |
| - | REF | 994970-2 | | COUNTER, MAGNETIC | 164 |
| - | 1 | 2119641-2 | | FEED CAM, AIR FEED | 151 |
| - | 1 | 2168083-8 | | SCR, SKT HD CAP, RoHS, M4 X 16 | 144 |
| - | 4 | 2168083-9 | | SCR, SKT HD CAP, RoHS, M4 X 20 | 143 |
| - | 1 | 1-1803583-0 | | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1803516-1 | | RAM ASSEMBLY, SF PACIFIC | 140 |
| - | 1 | 2119955-1 | | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 2844908-1 | | SCREW, LOCKING | 99 |
| - | 1 | 2844907-1 | | POST, LOCKING | 98 |
| - | 1 | 455888-4 | | SPACER, CRIMPER | 82 |
| - | 2 | 18024-6 | | SCR, BTN SKT HD CAP (M4 X 8.0) | 79 |
| - | 1 | 1803096-1 | | EXTENSION PLATE | 78 |
| - | 1 | 1803607-3 | | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 2119791-5 | | DEPRESSOR, WIRE | 70 |
| - | 1 | 2119943-1 | | WASHER, SPACER | 69 |
| - | 1 | 2119740-1 | | TAG IDENTIFICATION | 67 |
| - | 2 | 2168078-1 | | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 5-18022-5 | | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 985575-3 | | SCR, FLT SKT HD CAP M3 X 10.0 | 57 |
| - | 1 | 1338683-8 | | FEED PAWL | 56 |
| - | 2 | 2168083-9 | | SCR, SKT HD CAP, RoHS, M4 X 20 | 53 |
| - | 1 | 18023-9 | | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1803602-1 | | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | 1752356-1 | | SUPPORT, TERMINAL | 34 |
| - | 2 | 2079383-8 | | SCR, BHSC, RoHS (M4 X 16) | 33 |
| - | 2 | 1-2844962-7 | | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 2844992-1 | | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 455888-3 | | SPACER, CRIMPER | 28 |
| - | 1 | 1320928-4 | | STRIP GUIDE | 24 |
| - | 1 | 2168083-2 | | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 2 | 1-18028-2 | | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 2119533-1 | | STRIPPER, SIDE FEED | 19 |
| - | 1 | 2119806-1 | | INSERT, SHEAR | 13 |
| - | 1 | 3-22280-3 | | SPRING, COMPRESSION | 12 |
| - | 1 | 1-356885-4 | | STOP, SHEAR | 11 |
| - | 1 | 2119805-1 | | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1803095-1 | | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 2-1633928-5 | | ANVIL, COMBINATION | 8 |
| - | 1 | 8-240641-5 | | SPACER | 7 |
| - | - | - | | - | 6 |
| - | 1 | 1-2119781-0 | | DEPRESSOR, SHEAR | 5 |
| - | 1 | 5-238011-5 | | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 5-1633965-9 | | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1-455888-0 | | SPACER, CRIMPER | 2 |
| 1 | 1 | 3-1673600-2 | | CRIMPER, WIRE | 1 |

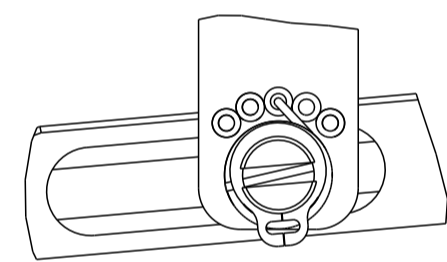
| | | | |
|--|--|---|---|
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| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151954 RESTRICTED TO: F |
| MATERIAL: | | APPLICATION SPEC: | WEIGHT: |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | SCALE: 1:2 | SHEET 3 OF 4 |

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

FEED TYPE PNEUMATIC

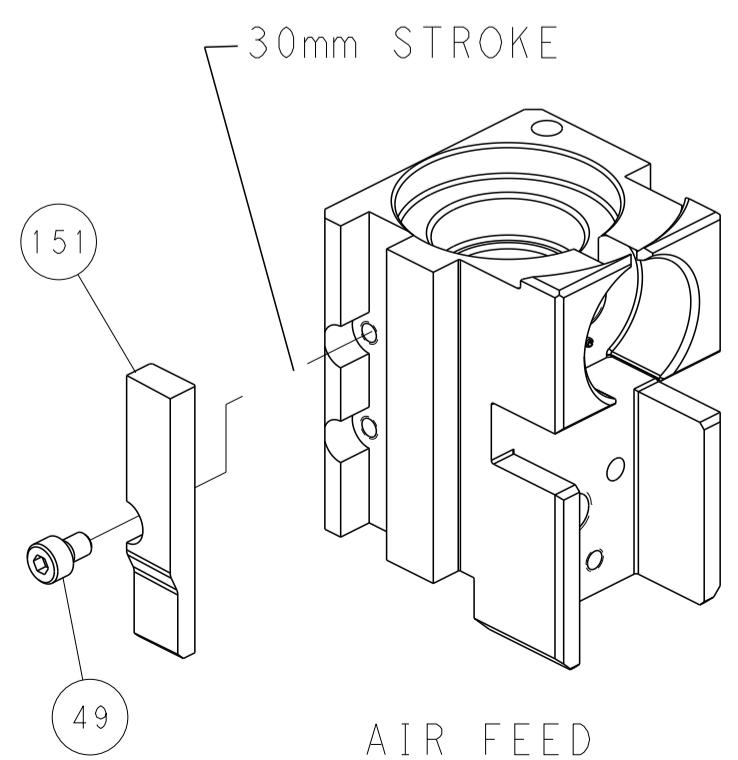


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

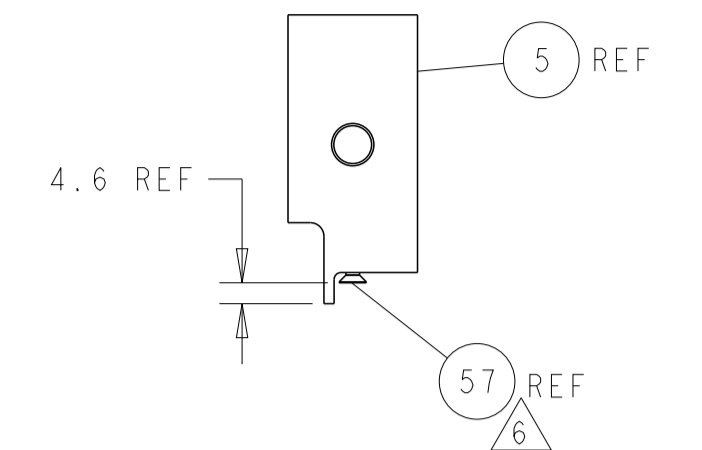
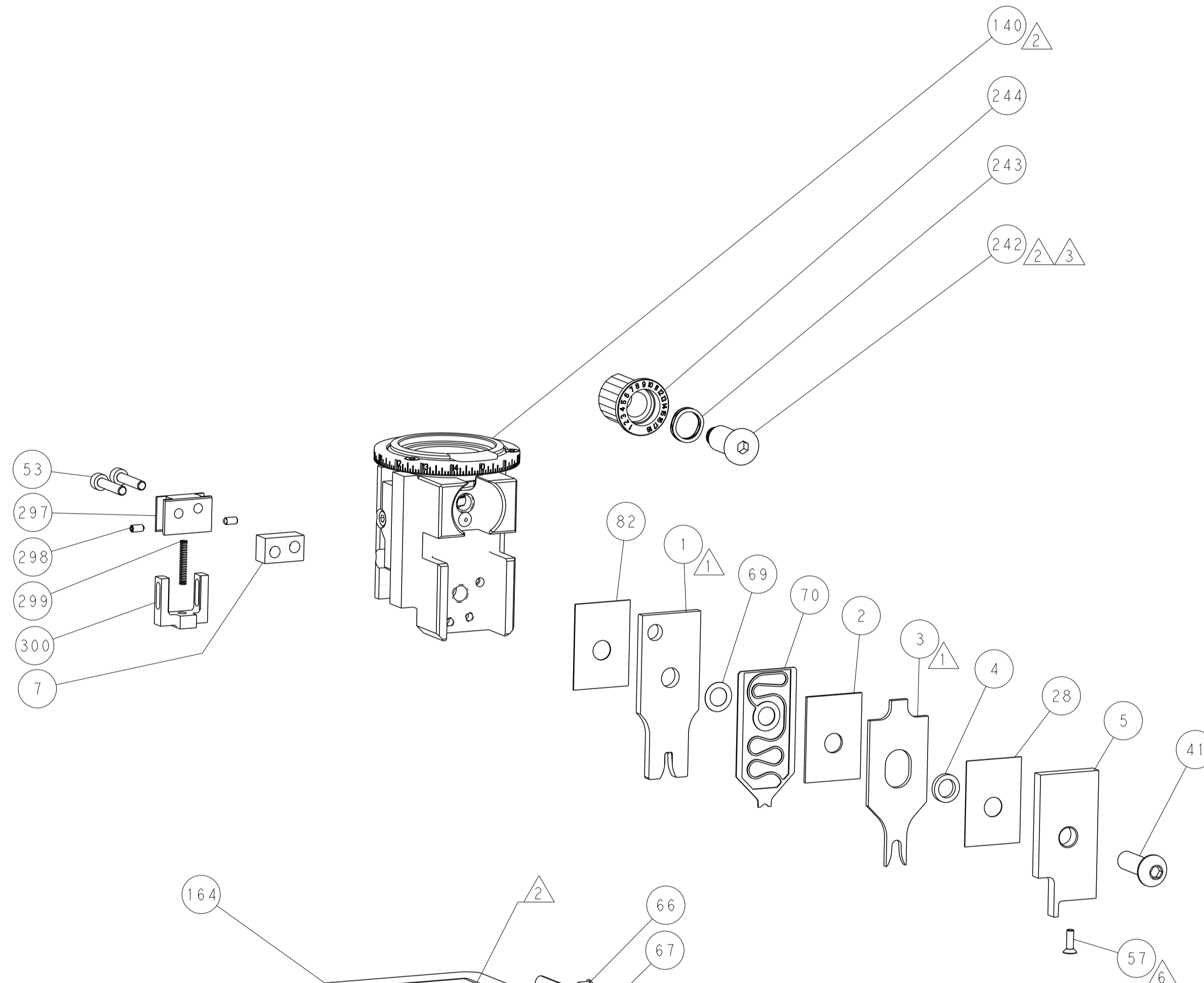


DETAIL A

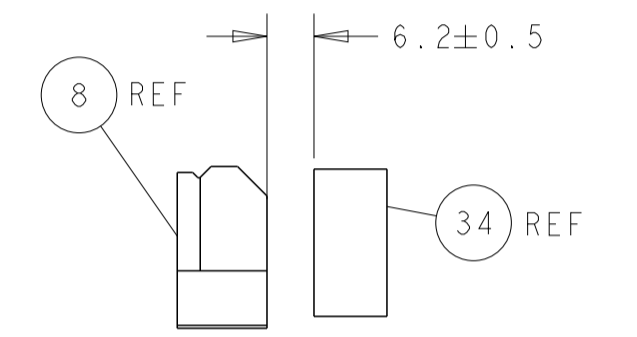
CAM POSITION



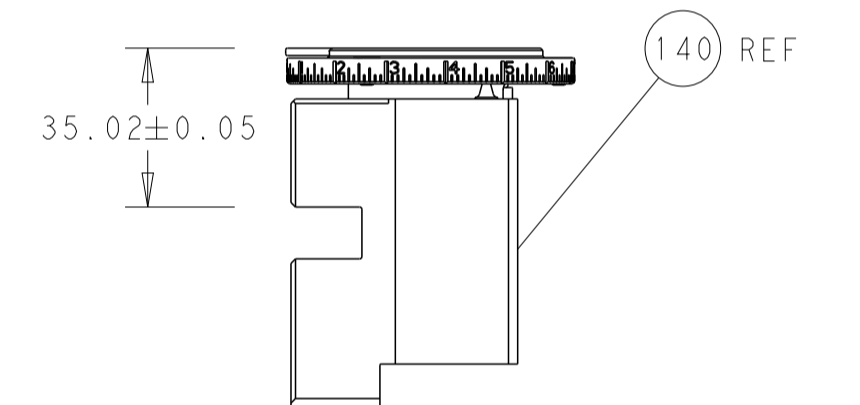
AIR FEED



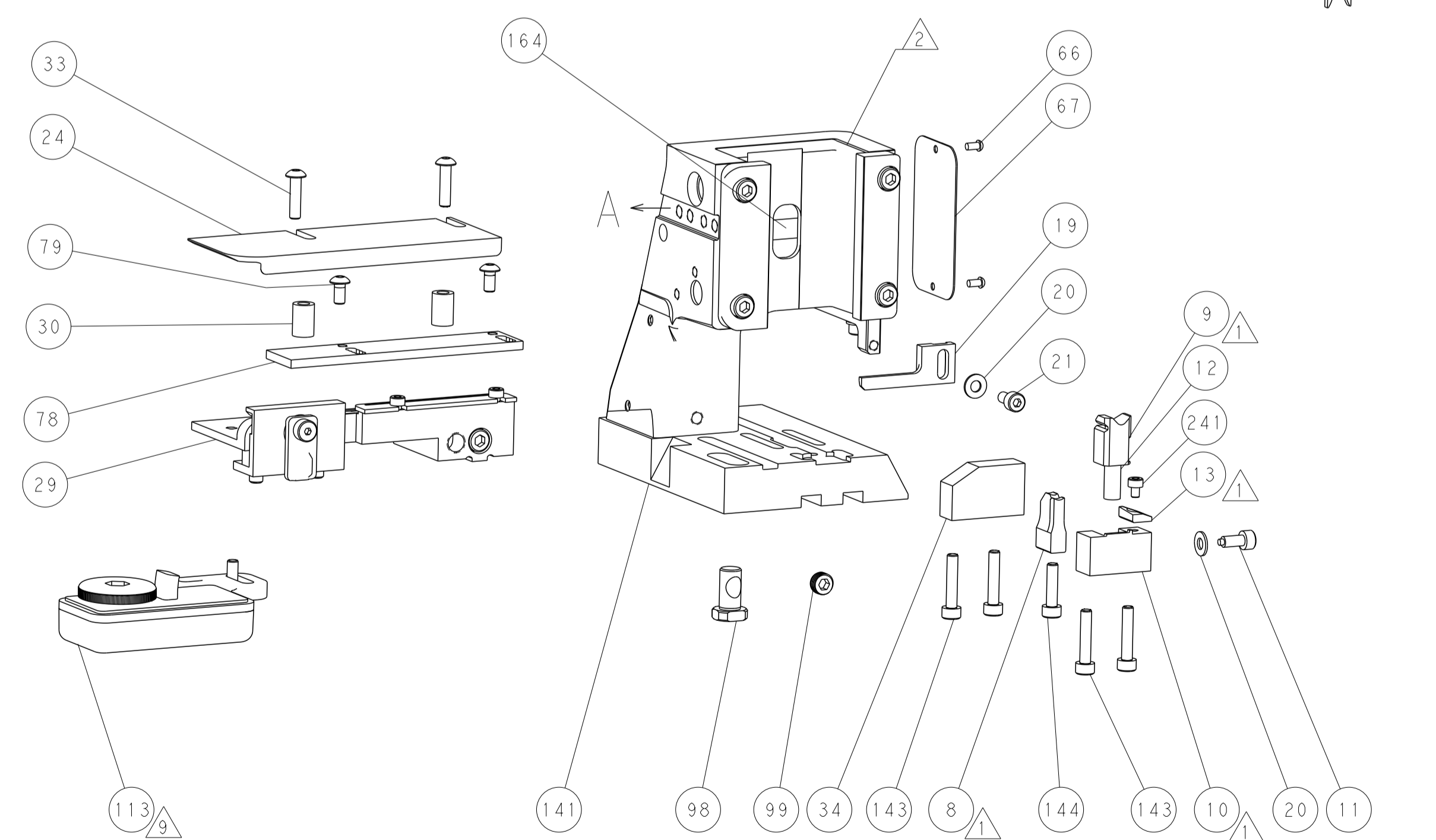
SHEAR DEPRESSOR DETAIL



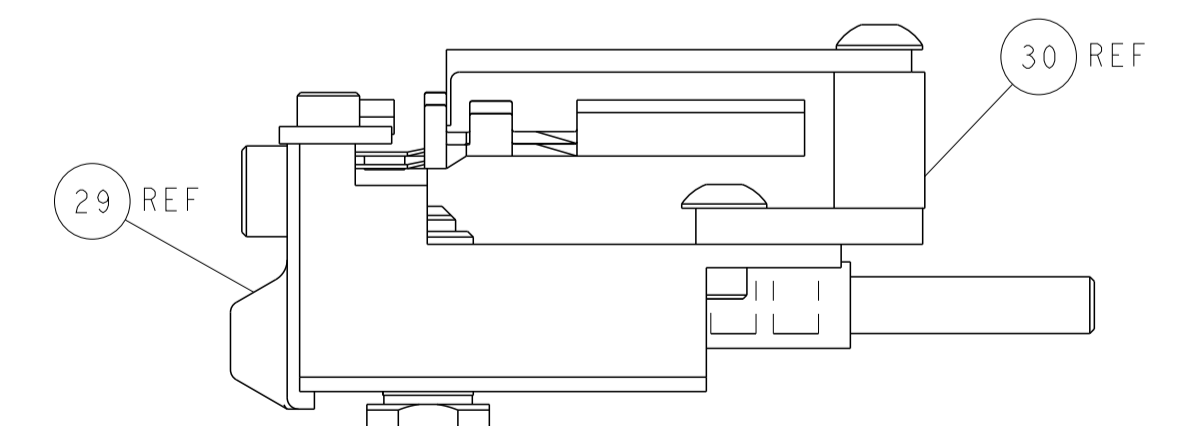
TERMINAL SUPPORT LOCATION



RAM SET-UP



ITEM 30 LOCATED AT
FRONT HOLES



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)

| | | | | | | | |
|--|---------|--|---------|-------------------------|---------|-----------------|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN HOFFNER 30MAY2013 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| ANGLES | FINISH | MATERIAL | | APVD T. ELBIN 31MAY2013 | | NAME | |
| Customer Accessible Production Drawing | | SCALE 1:2 | | SHEET 4 OF 4 | | REV F | |