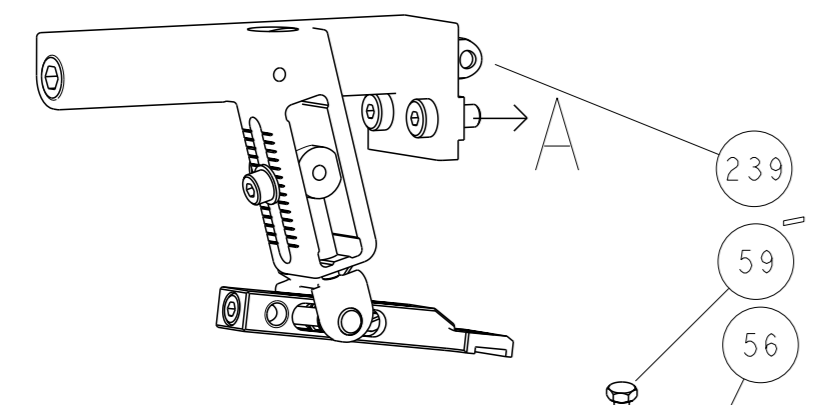
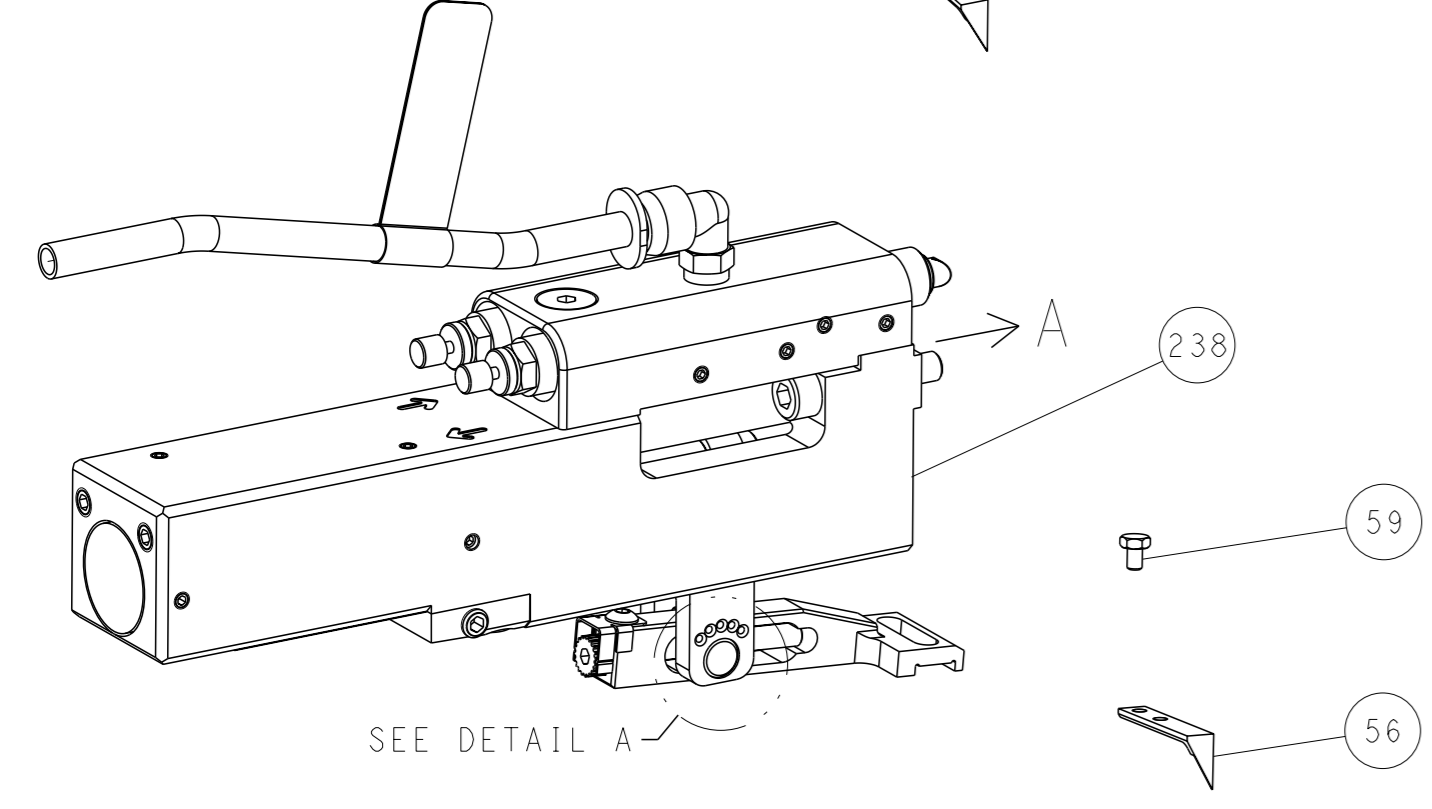


LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

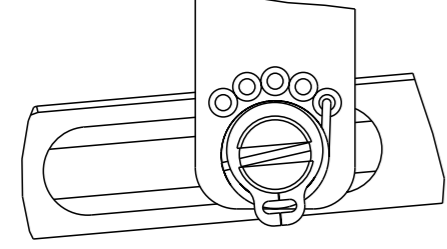
FEED TYPE MECHANICAL



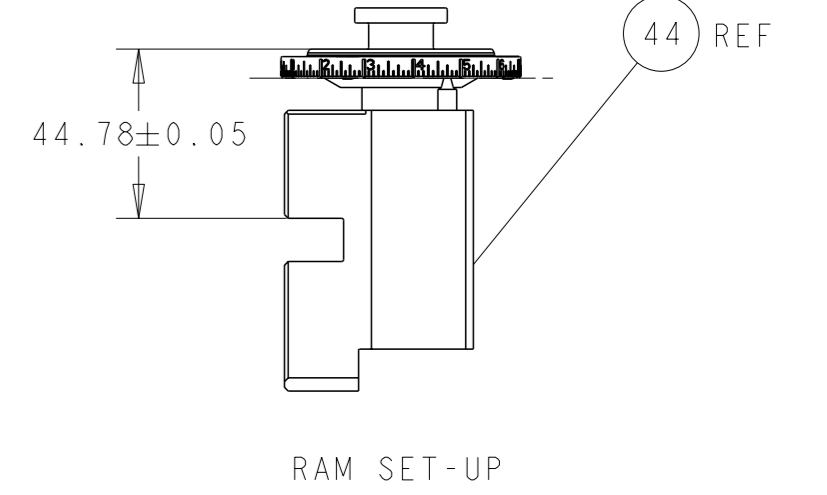
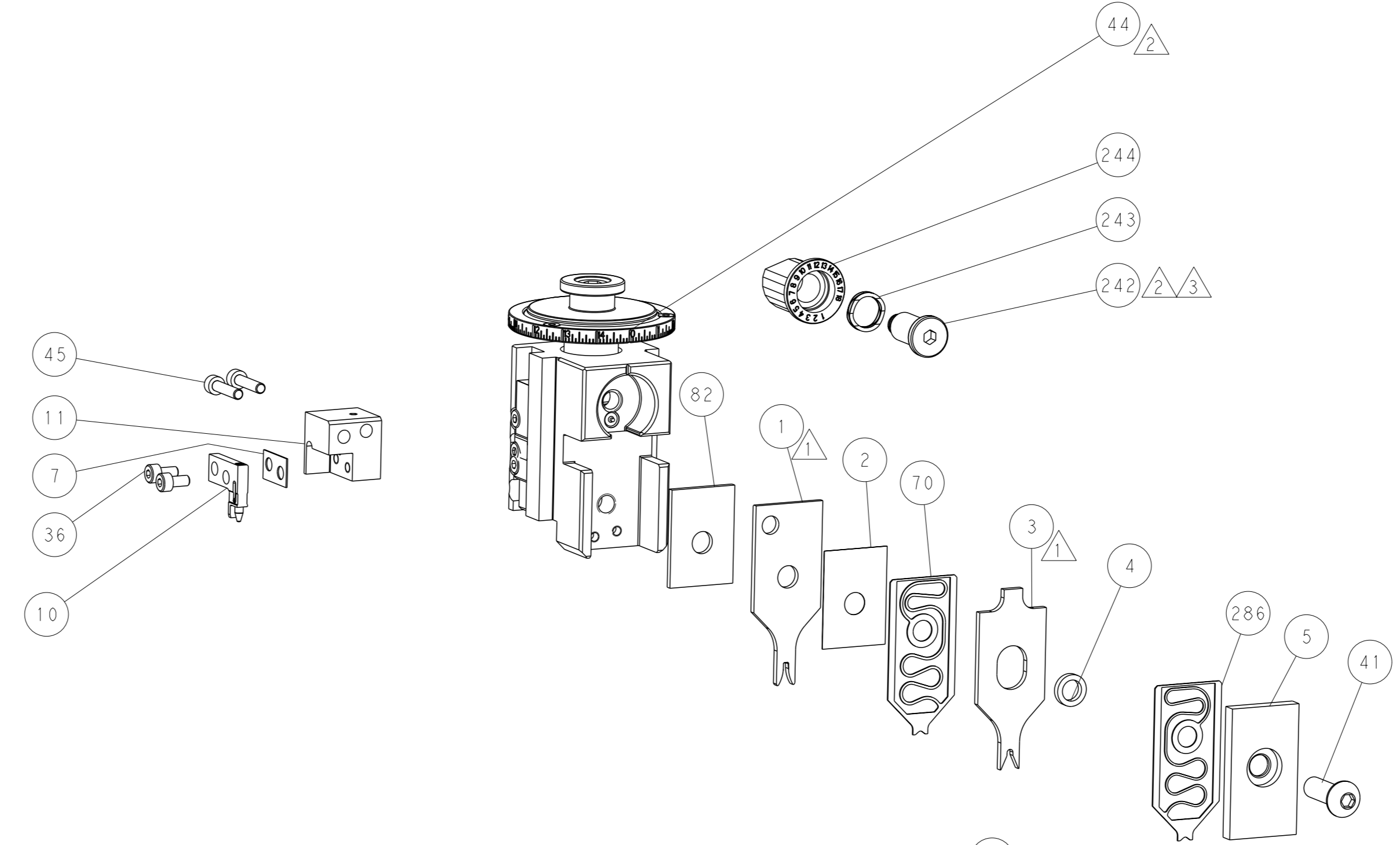
PNEUMATIC



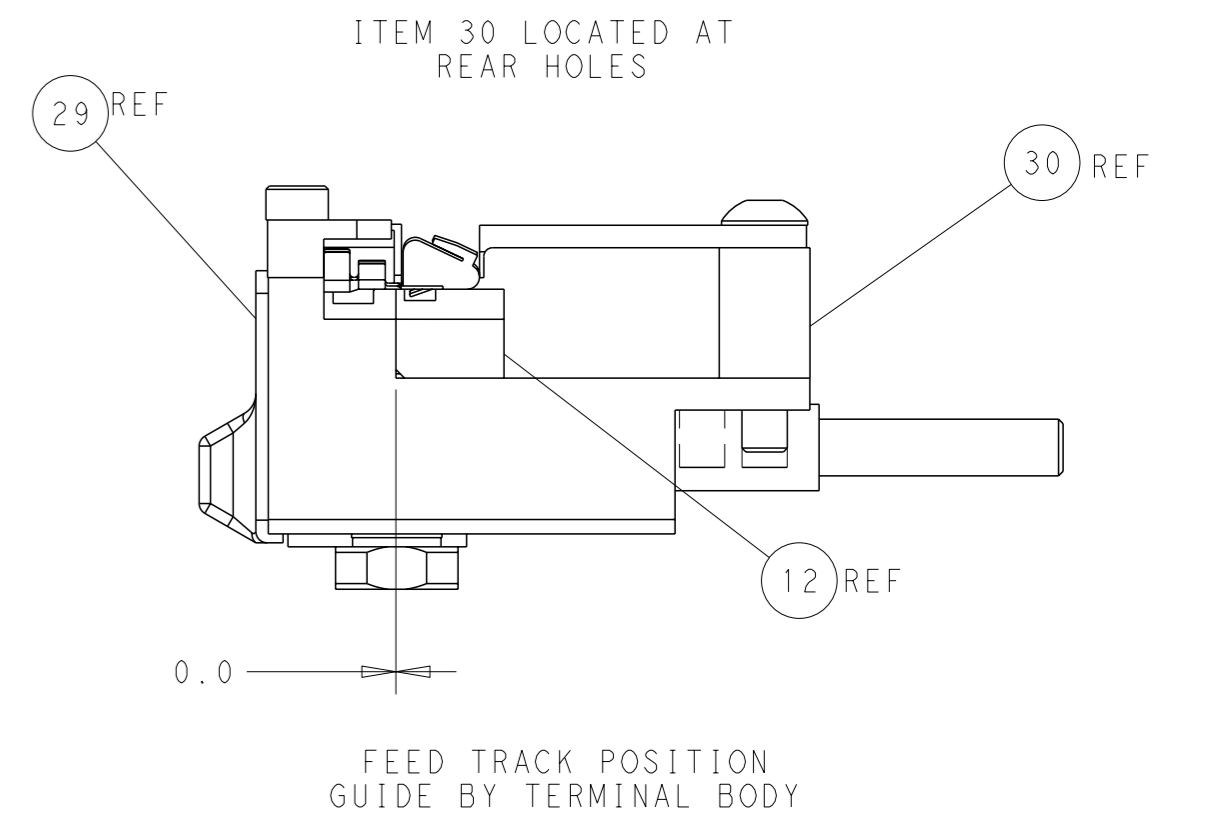
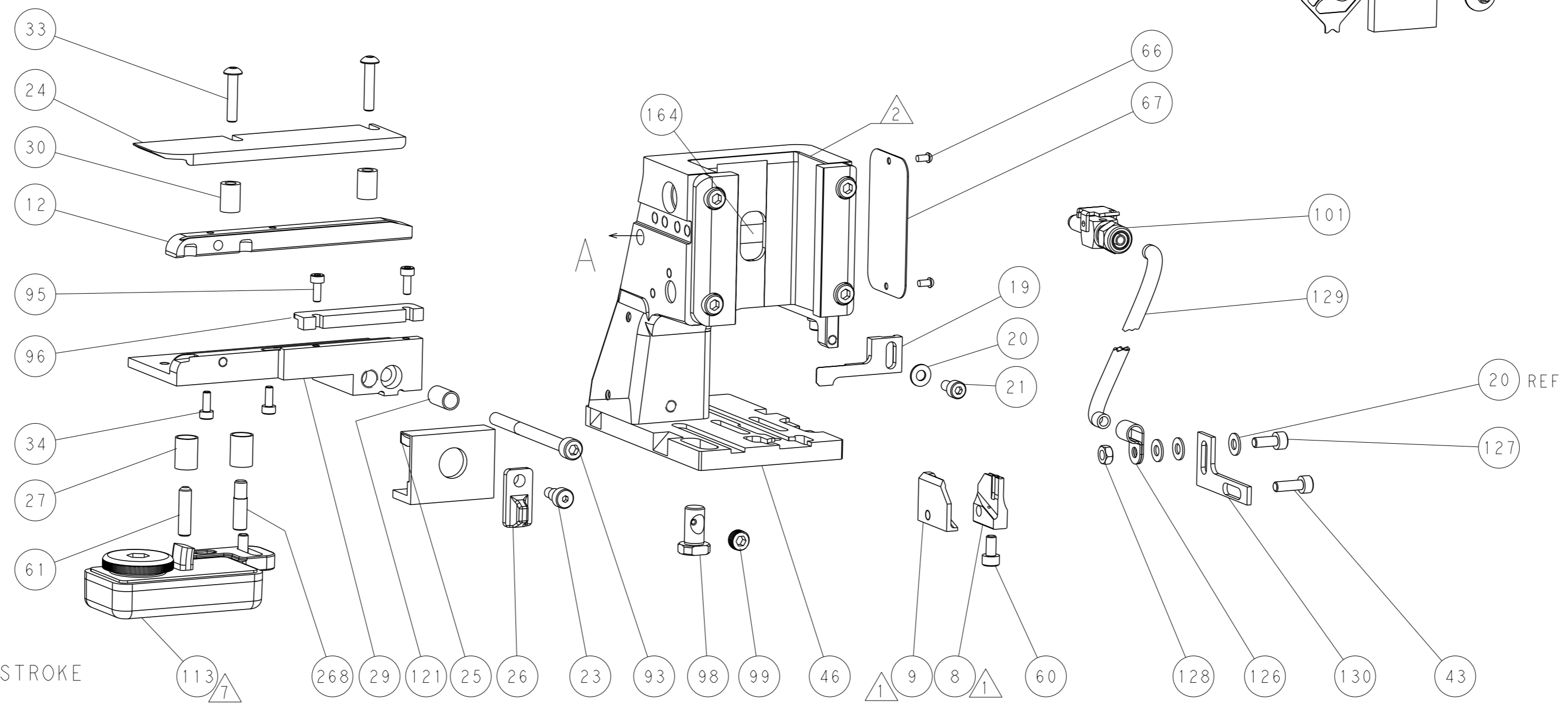
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

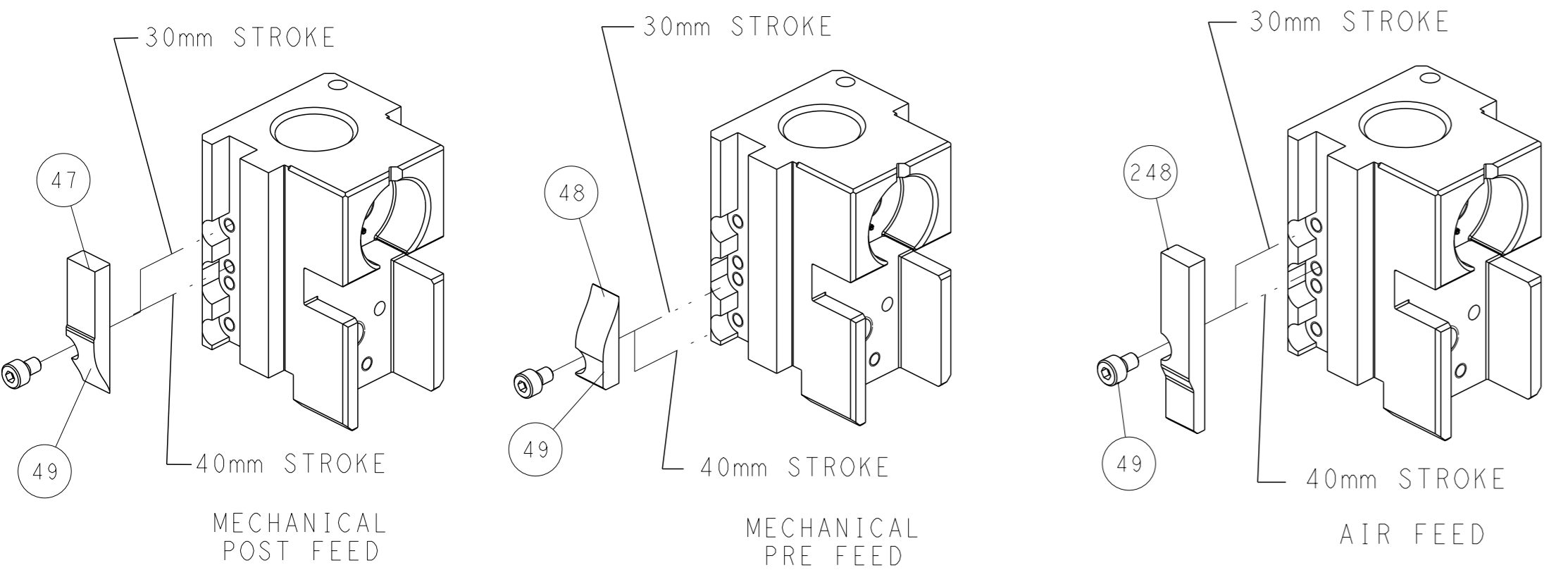


RAM SET-UP



FEED TRACK POSITION
GUIDE BY TERMINAL BODY

CAM POSITION

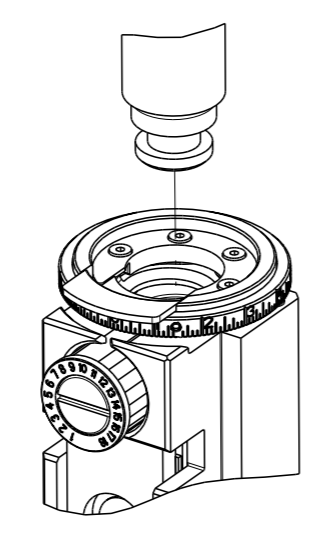


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: R. O. WILSON 30MAY2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: T. ELBIN 18JUN2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
				SIZE: A1		CAGE CODE: 00779	
				DRAWING NO: 2151433		SCALE: 1:2	
				WEIGHT:		SHEET 2 of 4	
				Customer Accessible Production Drawing		REV J1	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151433-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151433-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151433-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	2.49 mm [.098]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MOLEX TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: KK CRIMP TERMINAL, 3.96mm PITCH			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.108-.123 IN [2.74-3.12 mm]		Ø.000-.110 IN [0.00-2.79 mm]	
TERMINAL APPLICATION SPECIFICATION	ATS-639007200		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572397-1	08-50-0105	1-1572397-1	08-53-0811
1572397-2	08-52-0071	1-1572397-2	08-55-0133
1572397-3	08-58-0121	1-1572397-3	08-58-0103
1572397-4	08-56-0105	1-1572397-4	08-58-0114
1572397-5	08-65-0114	1-1572397-5	39-00-0286
1572397-6	08-55-0103	1-1572397-6	39-00-0347
1572397-7	08-50-0015	1-1572397-7	40-01-1118
1572397-8	08-50-0119	1-1572397-8	50-29-1689
1572397-9	08-50-0281	1-1572397-9	50-29-1768
1-1572397-0	08-52-0811		

TERMINAL DATA: MOLEX TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: KK CRIMP TERMINAL, 3.96mm PITCH			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.108-.123 IN [2.74-3.12 mm]		Ø.000-.110 IN [0.00-2.79 mm]	
TERMINAL APPLICATION SPECIFICATION	ATS-639007200		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
286984-1	08-58-0110	286984-6	08-50-0024
286984-2	08-58-0187	286984-7	08-58-0105
286984-3	08-50-0187	286984-8	08-58-0118
286984-4	08-52-0112		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.80mm2	1.12+/-0.025 [.044+/-0.001]	3.9
20 AWG OR 0.50mm2	1.06+/-0.025 [.042+/-0.001]	4.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.81mm2	1.12+/-0.05 [.044+/-0.002]	5.6
18 AWG OR 0.80mm2	1.12+/-0.025 [.044+/-0.001]	5.9
20 AWG OR 0.50mm2	1.06+/-0.025 [.042+/-0.001]	6.5
22 AWG OR 0.35mm2	1.00+/-0.025 [.039+/-0.001]	6.8
24 AWG OR 0.20mm2	0.94+/-0.03 [.037+/-0.001]	7.3

- 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.
- SPECIAL APPLICATION FOR USE WITH 18AWG UL1015, 16 STRAND (.010") [.254mm²] ONLY.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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)

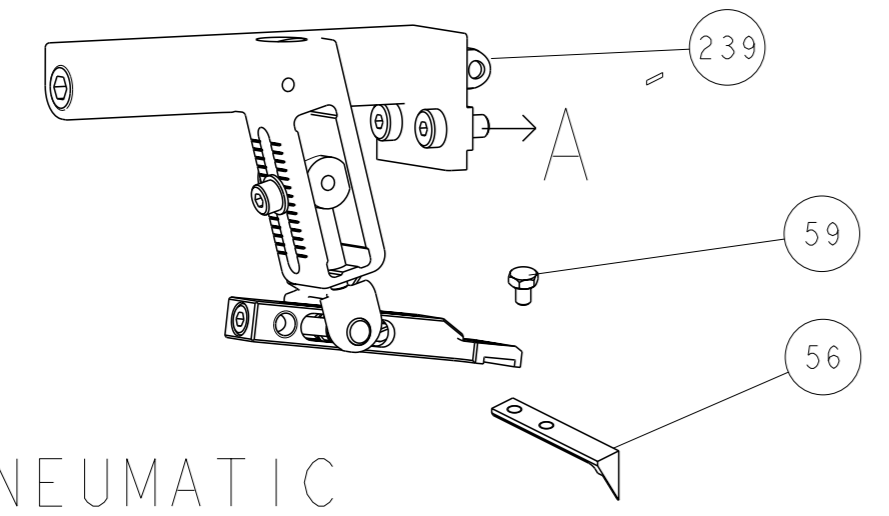
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	1	2-1722335-1	Thread bolt Gewindebolzen	268
-	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	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
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1803583-2	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	2217068-1	BRACKET, AIR BLAST	130
-	1	1	2030758-3	TUBING, POLYURETHANE	129
-	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127
-	1	1	986220-3	CLAMP, CABLE, BLACK	126
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	23238-1	INSERT, COUPLING	101
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	4-690487-4	GUIDE, FRONT STRIP	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 6.5	93
-	1	1	1-455888-9	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-6	DEPRESSOR, WIRE	70
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	45
-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	43
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	36
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2-2844938-7	PLATE, STRIP GUIDE	29
-	2	2	22282-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1803899-1	DRAG, TERMINAL	25
-	1	1	1-1320928-0	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
-	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-4	STRIPPER, SIDE FEED	19
-	1	1	2-2119928-0	FENCE	12
-	1	1	2119830-8	HOLDER, SLUG BLADE	11
-	1	1	1803916-1	ASSEMBLY, SHEAR BLADE AND LOCATOR	10
-	1	1	1633578-3	PLATE, REAR SHEAR	9
-	1	1	1633576-4	ANVIL, SPECIAL	8
-	1	1	2-240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	5-1633966-3	CRIMPER, INSULATION O	3
-	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	6-1633609-6	CRIMPER, WIRE	1

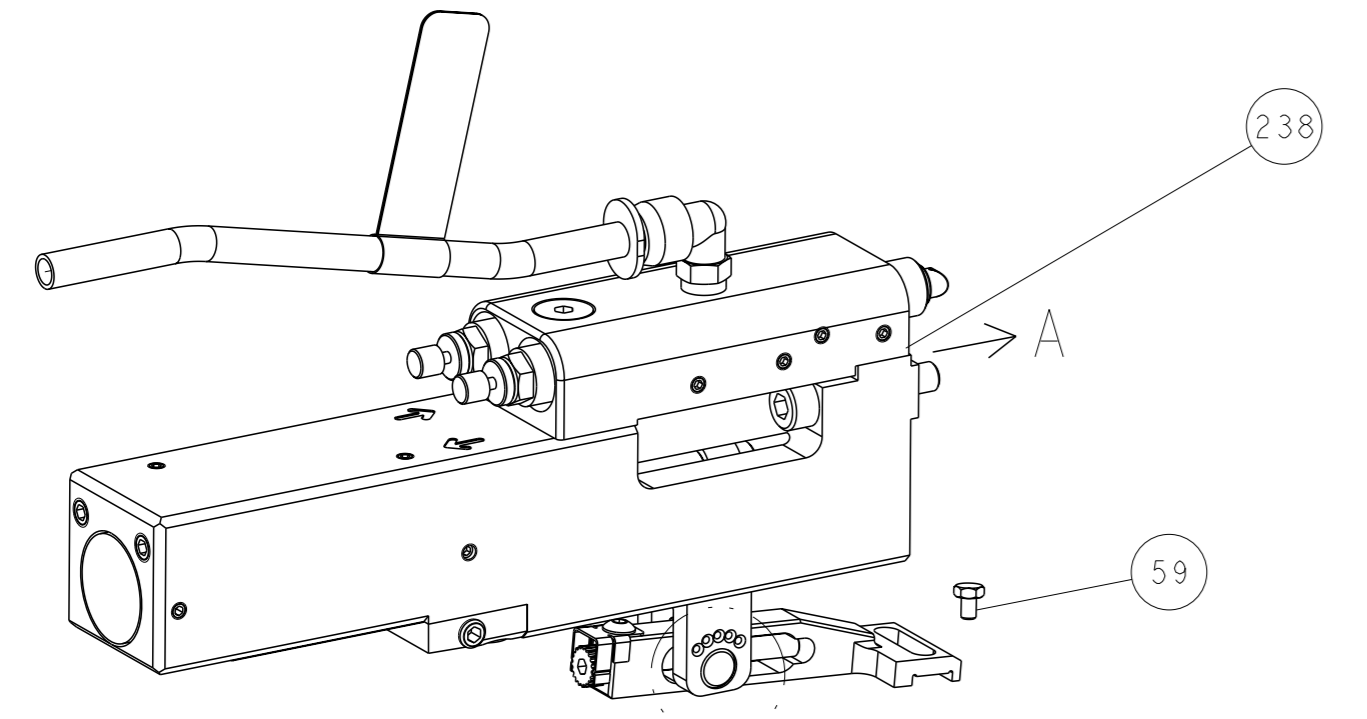
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	ANGLES	FINISH					
MATERIAL				WEIGHT		SIZE	
						A1 00779 ©=2151433	
						Customer Accessible Production Drawing	
						SCALE 1:2 SHEET 3 of 4 REV J1	

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

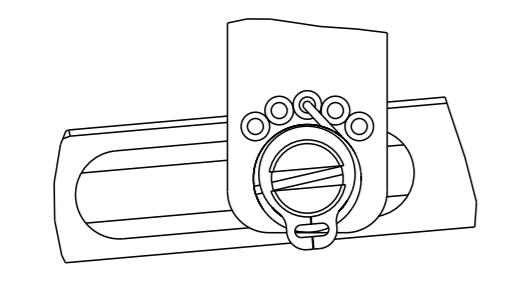
FEED TYPE MECHANICAL



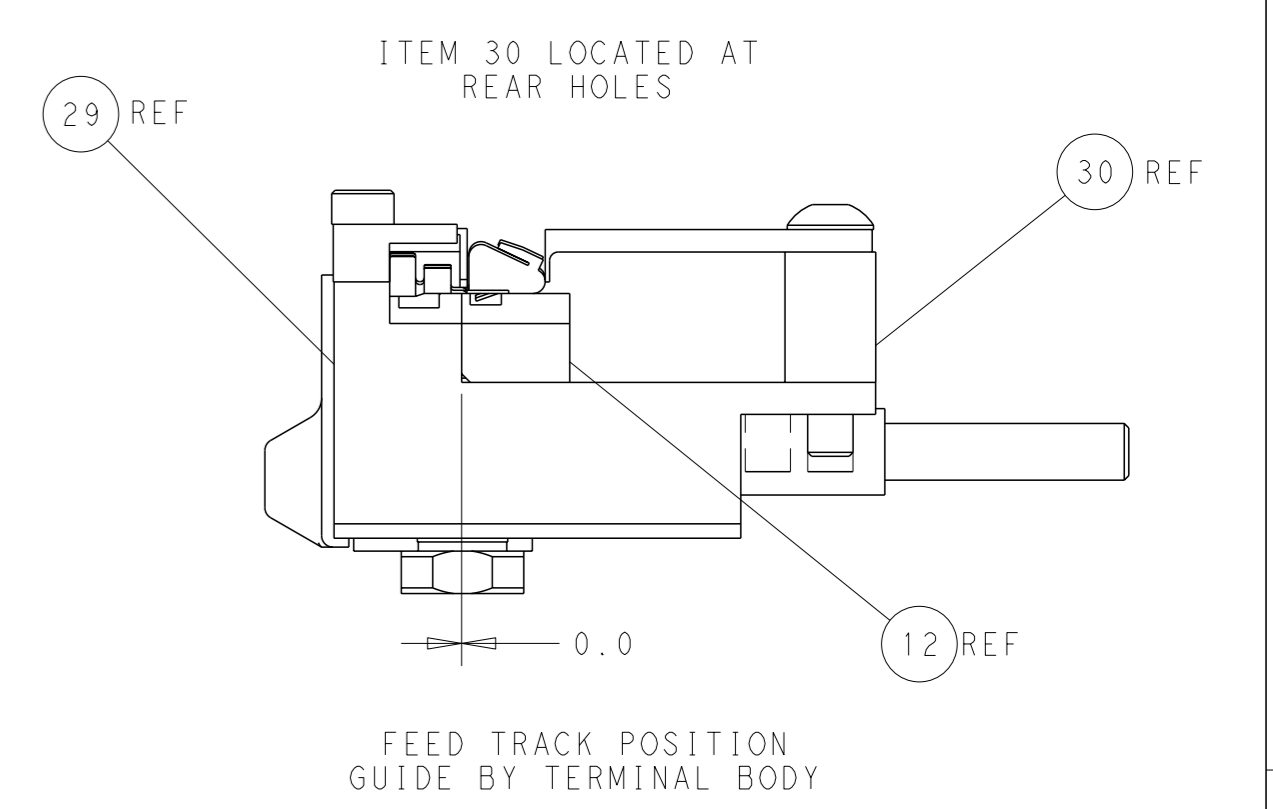
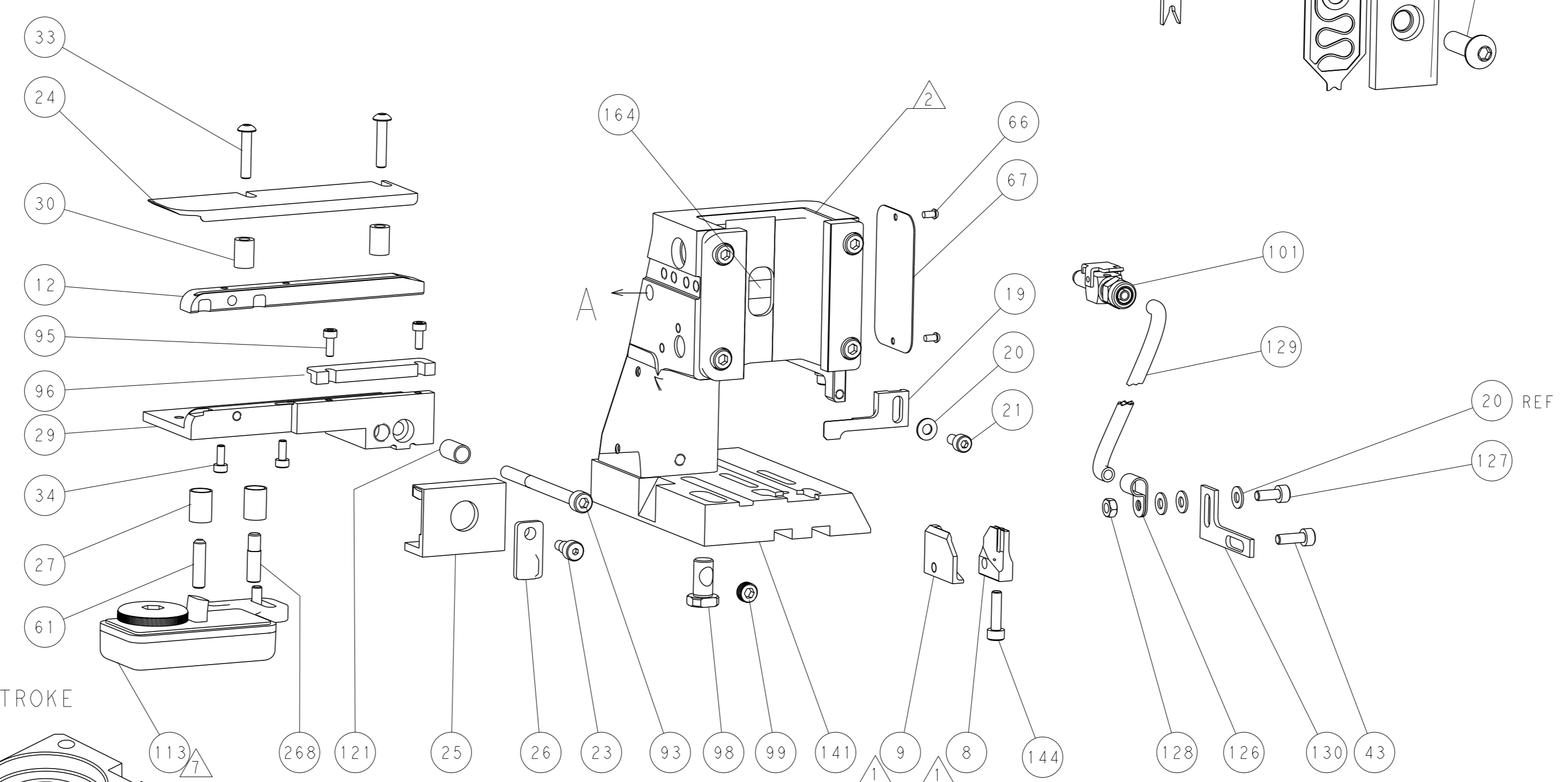
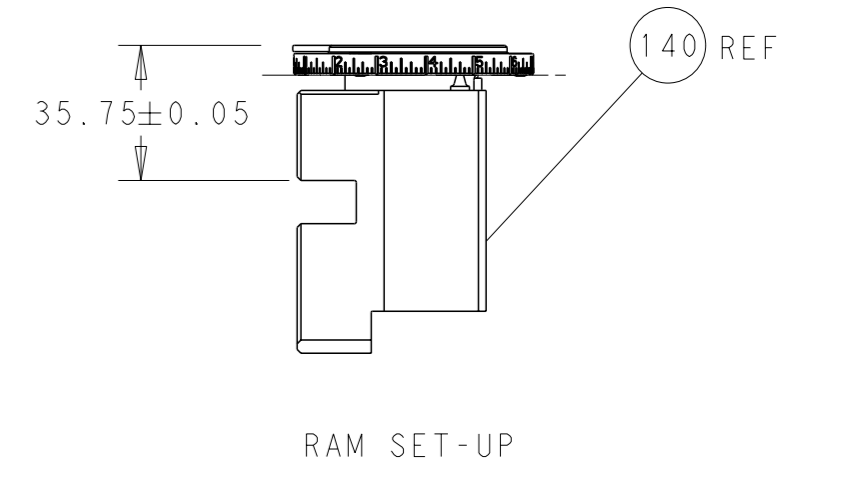
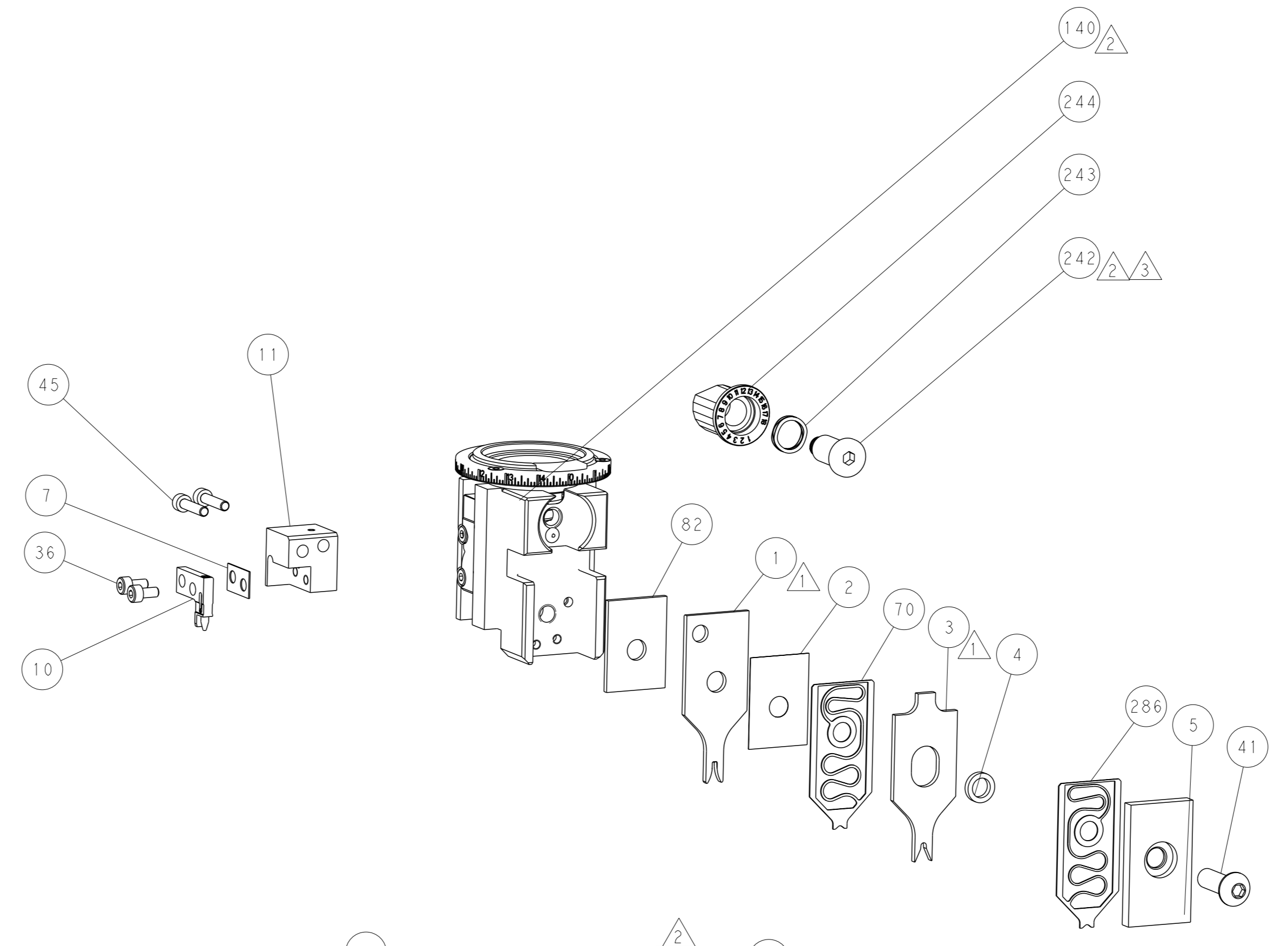
PNEUMATIC



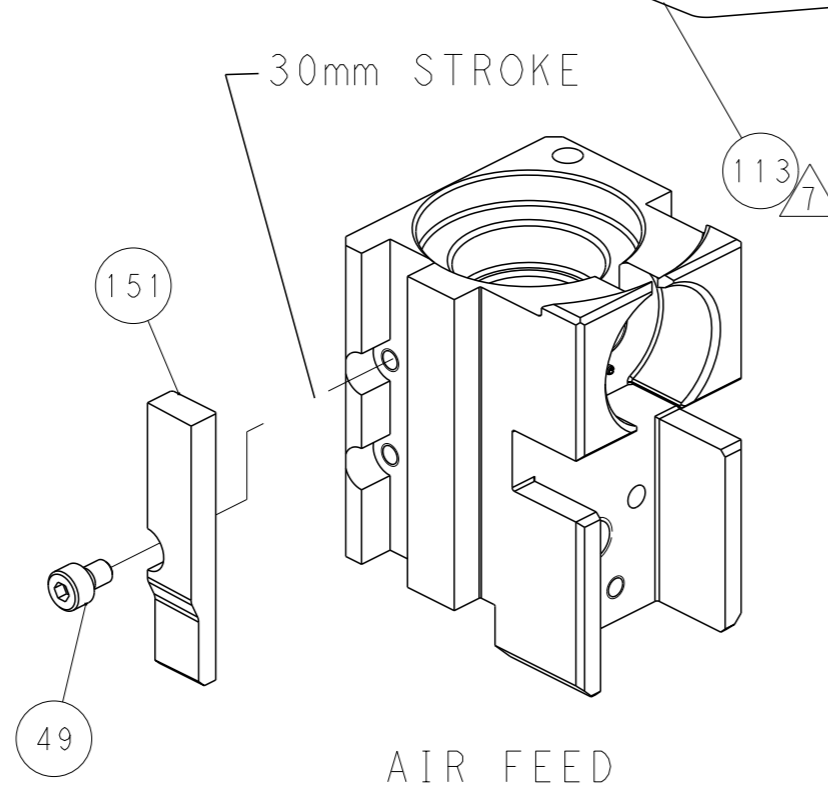
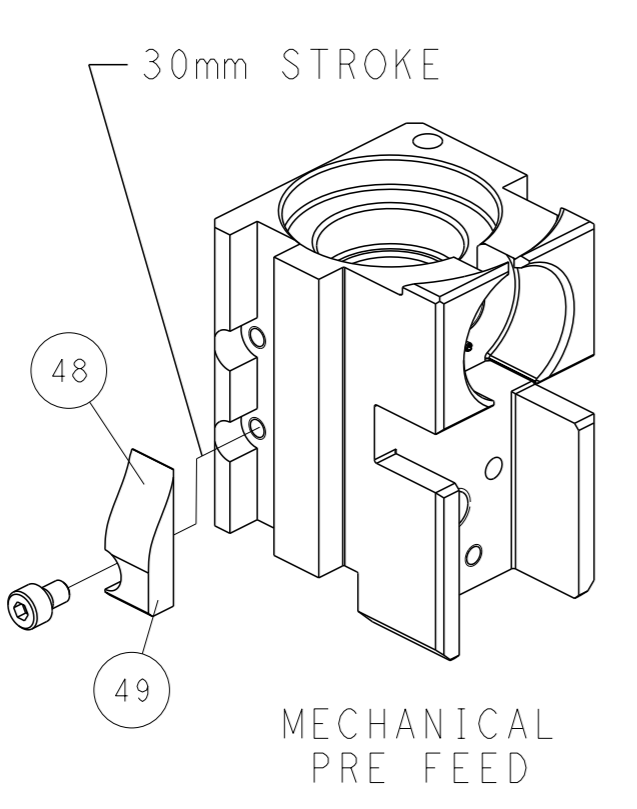
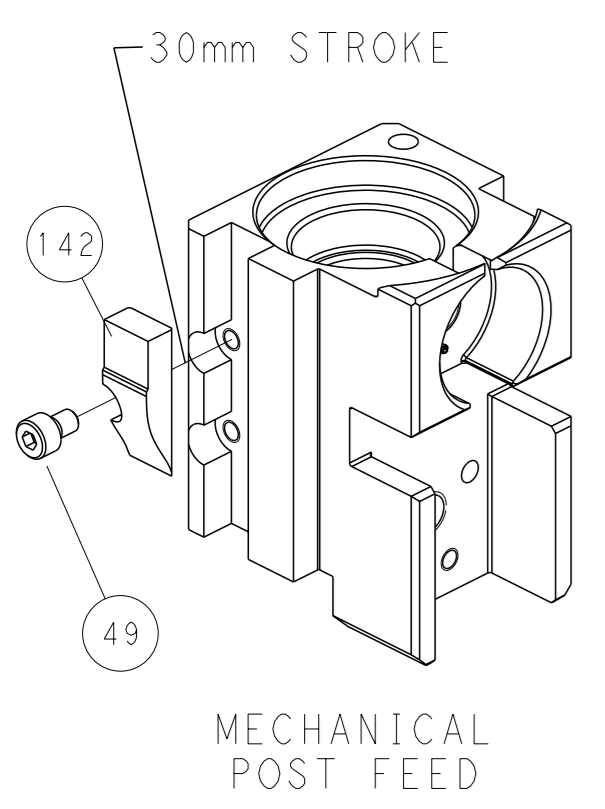
SEE DETAIL A
 FEED SPRING SETTING POSITION
 (SHOWN FROM REAR SIDE)



DETAIL A



CAM POSITION



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 CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. O. WILSON CHK: K. J. STAKEM APVD: T. ELBIN	DATE: 30MAY2012 DATE: 15JUN2012 DATE: 18JUN2012	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: C-2151433 SCALE: 1:2 SHEET: 4 of 4 REV: J1		RESTRICTED TO:
MATERIAL:		WEIGHT:		Customer Accessible Production Drawing