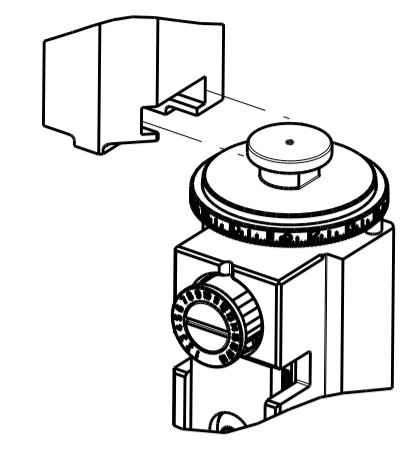


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151418-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151418-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151418-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151418-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151418-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.25 mm [.089]	F
INSUL	3.15 mm [.124]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, SICMA 3 1.5 X 0.8 RECEPT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-4.70 mm [.169-.185 IN]		Ø2.10-2.70 mm [.083-.106 IN]	
TERMINAL APPLICATION SPECIFICATION	FCI 211FT0463 Rev N		
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1949158-1	211 CC 2 S 2150 P	1949158-3	211 CC 2 S 2190 P
1949158-2	211 CC 2 S 2160 P	1949158-4	211 CC 2 S 2460 P

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.69+/-0.04 [.0665+/- .0016]	5.0
1.50mm2	1.59+/-0.04 [.0626+/- .0016]	5.7
1.00mm2	1.52+/-0.04 [.0598+/- .0016]	6.7

- 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.

***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	OWN	APVD
		A		RELEASED	06JAN2014	BH	GB
		A1		ECR-16-016693	24NOV2016	RS	LZ
		B		ECR-18-007330	15MAY2018	FZ	KZ
		B1		ECR-19-017886	26NOV2019	FJ	RK

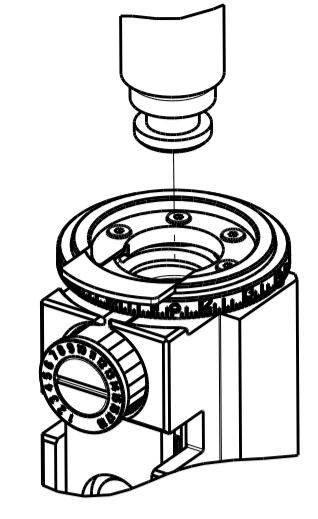
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250				
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249				
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248				
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244				
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243				
-	1	1	1	1	2119083-1	RETAINER, INSULATION 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	-	2063440-1	AIR FEED MODULE	238				
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172				
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164				
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163				
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137				
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136				
-	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	1803607-1	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				
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53				
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52				
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51				
-	1	1	1	1	690753-2	SPACER, TONKER	50				
-	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	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44				
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41				
-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34				
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33				
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30				
-	1	1	1	1	2844992-2	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	1803095-1	FLOATING SHEAR, FRONT	9				
-	1	2	2	1	1	2-1633138-2	ANVIL, COMBINATION	8			
-	1	1	1	1	240641-5	SPACER	7				
-	-	-	-	-	-	-	6				
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5				
-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4				
-	1	2	2	1	1	3-2119785-4	CRIMPER, INSULATION OVERLAP PREMIUM	3			
-	-	-	-	-	-	-	2				
-	1	2	2	1	1	4-1673600-0	CRIMPER, WIRE	1			
-	77	-	72	-	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

OWN	H. HUANG	12DEC2012
CHK	S. XI	12DEC2012
APVD	S. XI	12DEC2012
NAME	Ocean Side Feed Applicator	
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151418
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	B1	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151418-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151418-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151418-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.25 mm [.089]	F
INSUL	3.15 mm [.124]	OV

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, SICMA 3 1.5 X 0.8 RECEPT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.30-4.70 mm [1.69-.185 IN]	Ø2.10-2.70 mm [.083-.106 IN]		
TERMINAL APPLICATION SPECIFICATION	FCI 211FT0463 Rev N		
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1949158-1	211 CC 2 S 2150 P	1949158-3	211 CC 2 S 2190 P
1949158-2	211 CC 2 S 2160 P	1949158-4	211 CC 2 S 2460 P

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.69+/-0.04 [.0665+/- .0016]	5.0
1.50mm2	1.59+/-0.04 [.0626+/- .0016]	5.7
1.00mm2	1.52+/-0.04 [.0598+/- .0016]	6.7



- 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.
- 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	REV	DATE	BY	APPD
A	66				

REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-	1	-		2119640-1 PUSH ROD, AIR FEED	250
-	1	-		1803259-1 BUSHING, FLANGED	249
-	1	1		2119082-8 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	-		2063440-1 AIR FEED MODULE	238
-	2	-		21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF		994970-2 COUNTER, MAGNETIC	164
-	1	-		240638-1 SPRING, FEED FINGER	163
-	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	-		3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-		2119799-1 HOLDER, FEED FINGER, AF	136
-	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		455888-5 SPACER, CRIMPER	82
-	1	1		1803607-1 DOCUMENTATION PACKAGE	71
-	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		1338685-1 PAWL, FEED	56
-	2	2		1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1		5018030-1 NUT, HEX, REG, RoHS, M3	52
-	1	1		811242-5 BUMPER, HOLD DOWN	51
-	1	1		690753-2 SPACER, TONKER	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		1752356-3 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		2-2844962-6 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-2 ASSEMBLY, STRIP GUIDE	29
-	1	1		1-455888-0 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		1803095-1 FLOATING SHEAR, FRONT	9
-	1	1		2-1633138-2 ANVIL, COMBINATION	8
-	1	1		240641-5 SPACER	7
-	-	-		-	6
-	1	1		2119757-8 DEPRESSOR, SHEAR	5
-	1	1		238011-9 BLOCK, CRIMPER SPACER	4
-	1	1		3-2119785-4 CRIMPER, INSULATION OVERLAP PREMIUM	3
-	-	-		-	2
-	1	1		4-1673600-0 CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

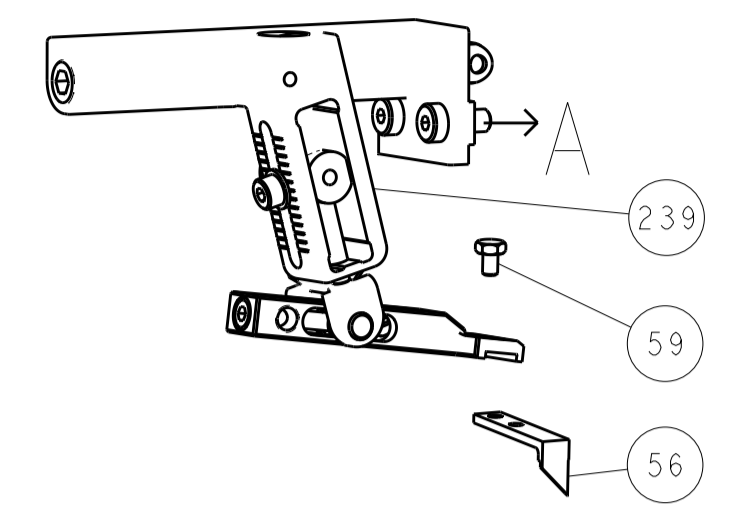
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DATE	12DEC2012	CHK	S. XI
DATE	12DEC2012	APPD	S. XI
DATE	12DEC2012	APPD	S. XI

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151418	

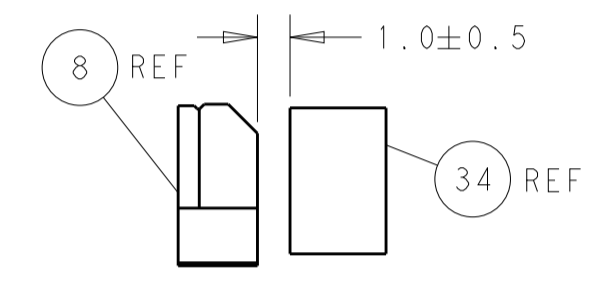
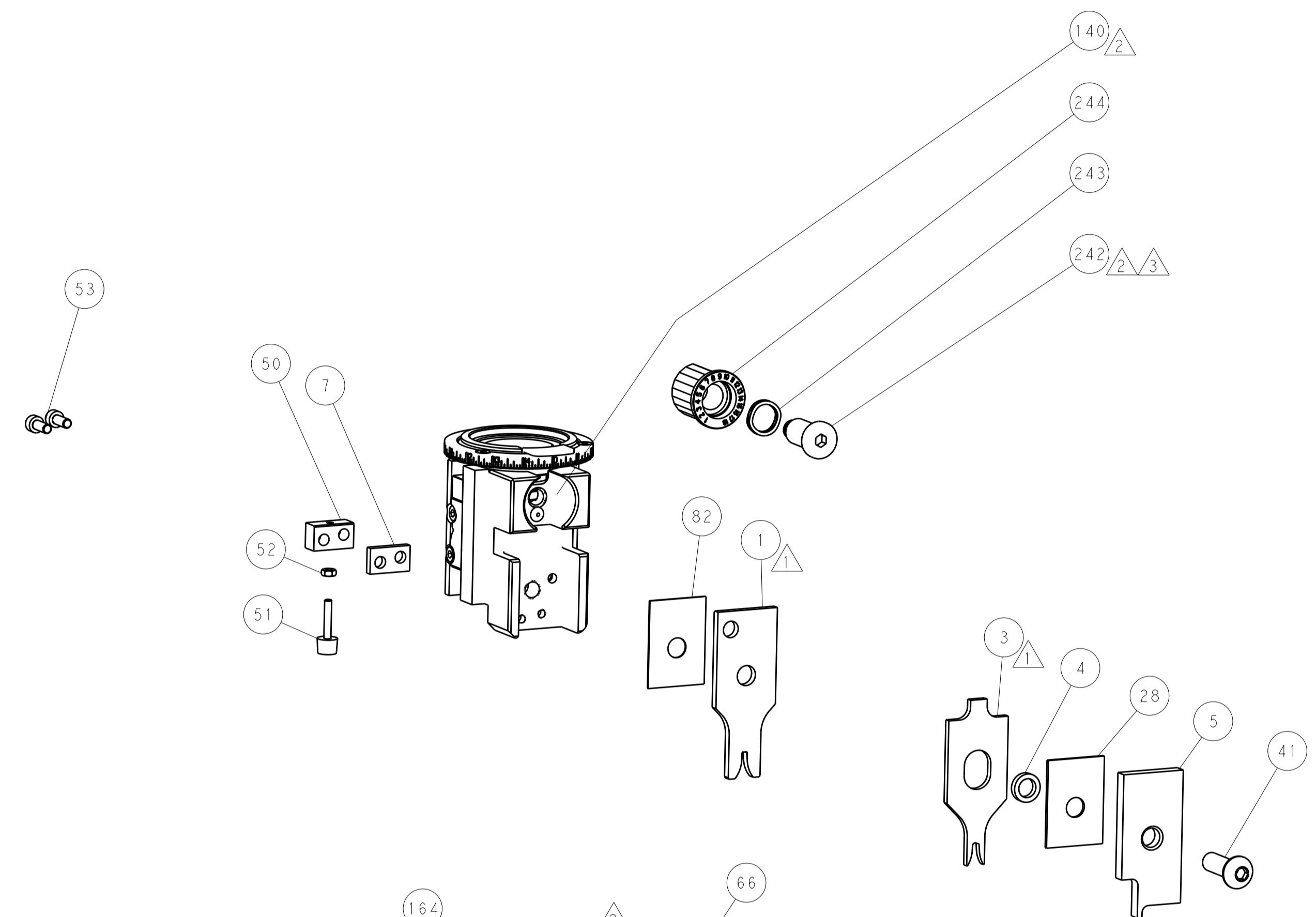
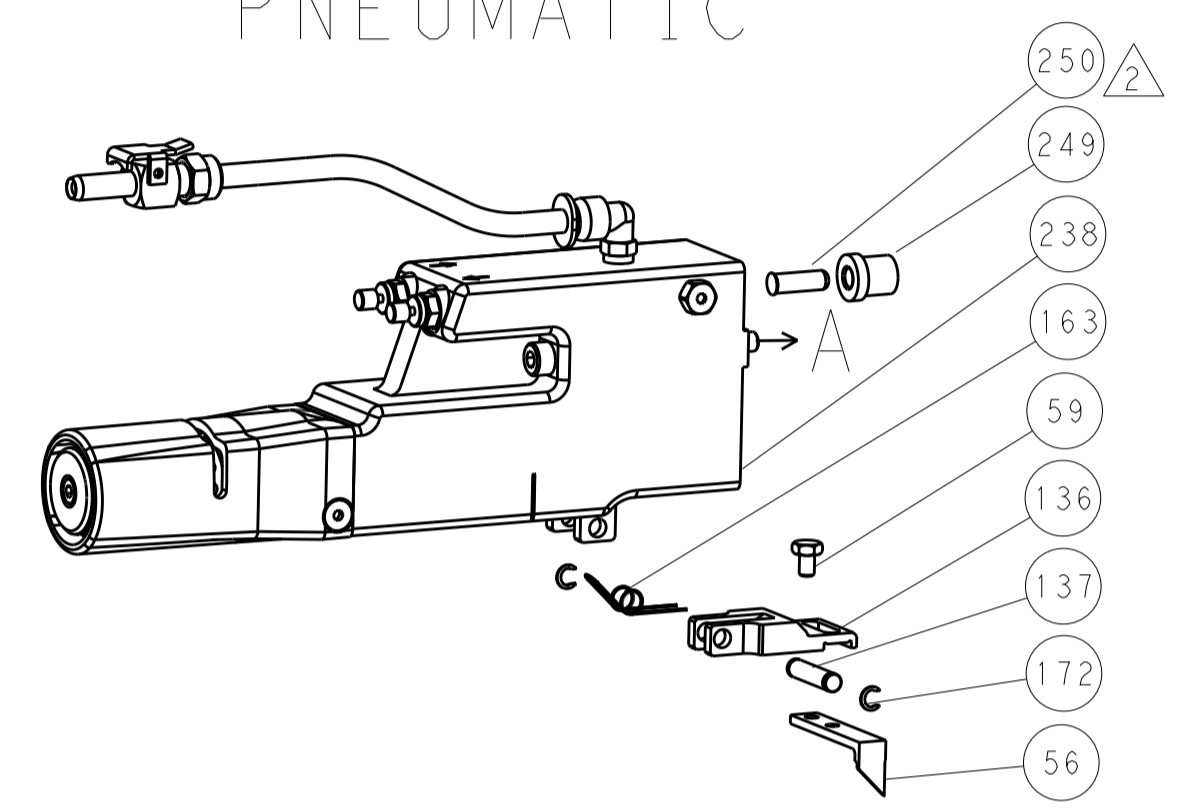
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B1

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

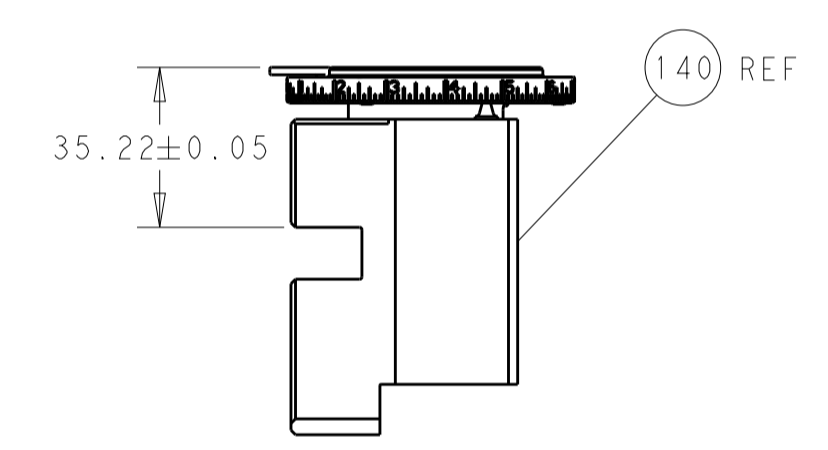
FEED TYPE MECHANICAL



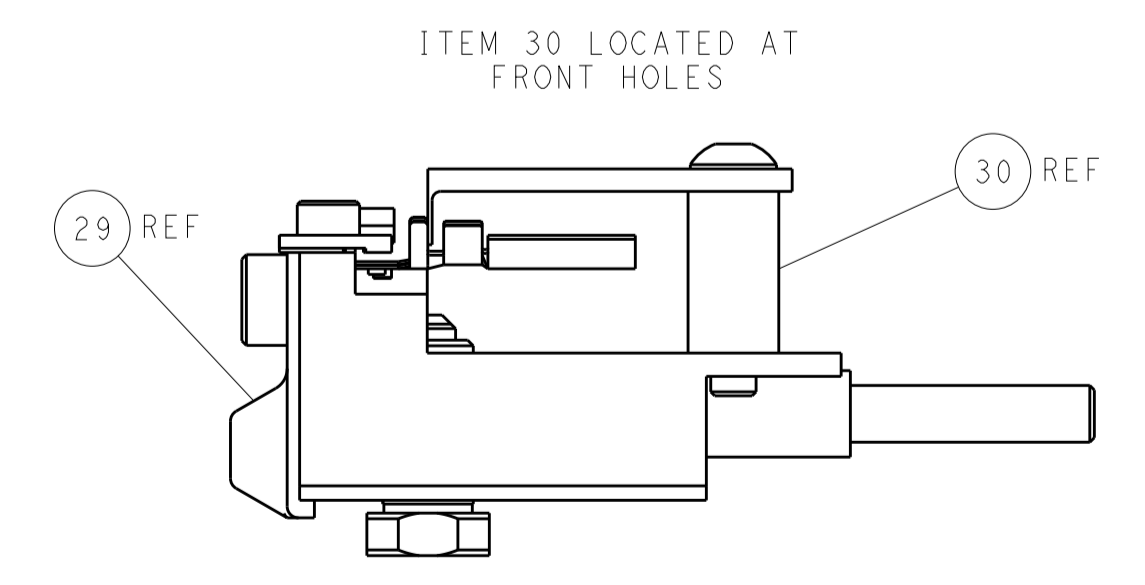
PNEUMATIC



TERMINAL SUPPORT LOCATION

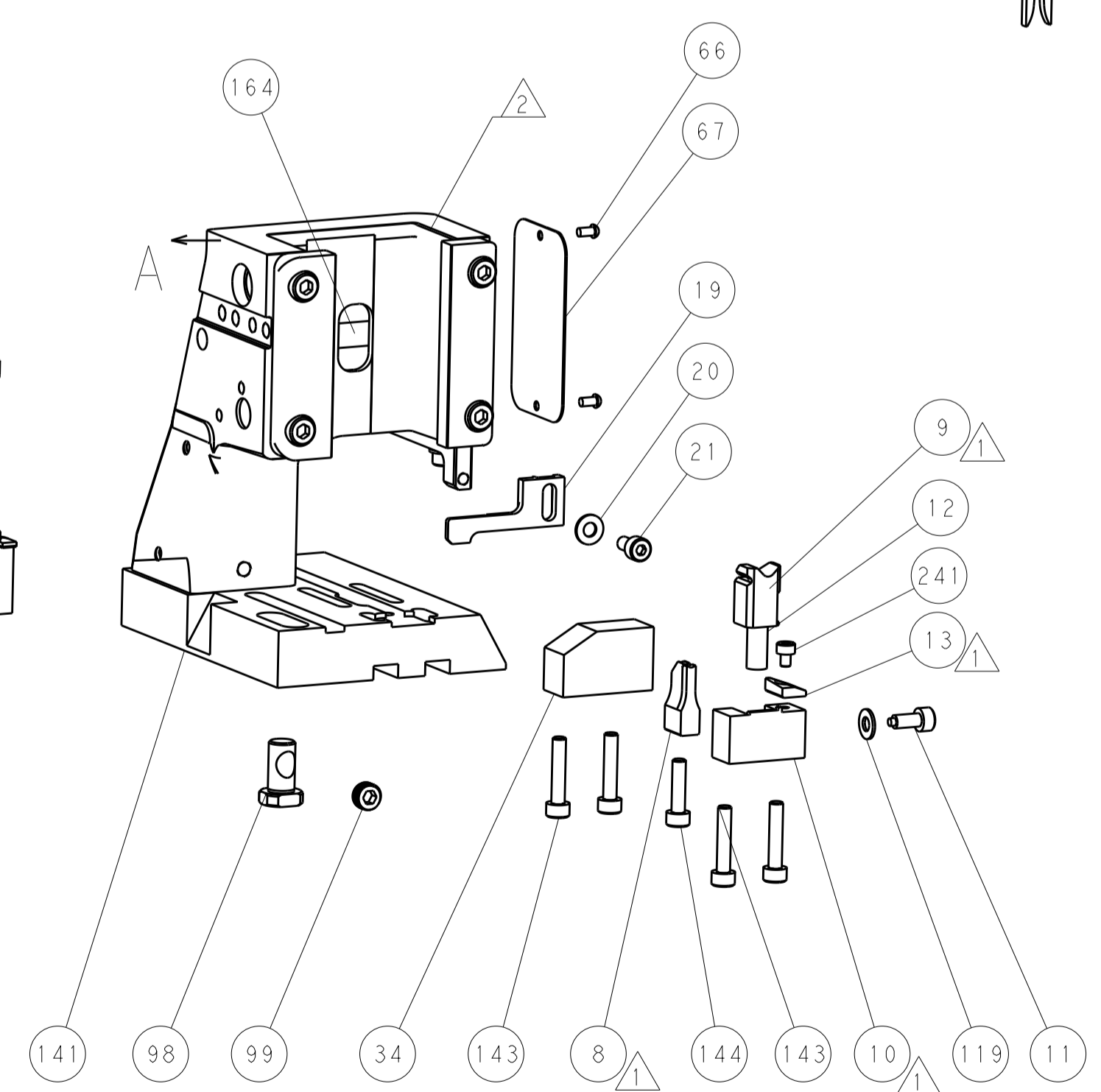
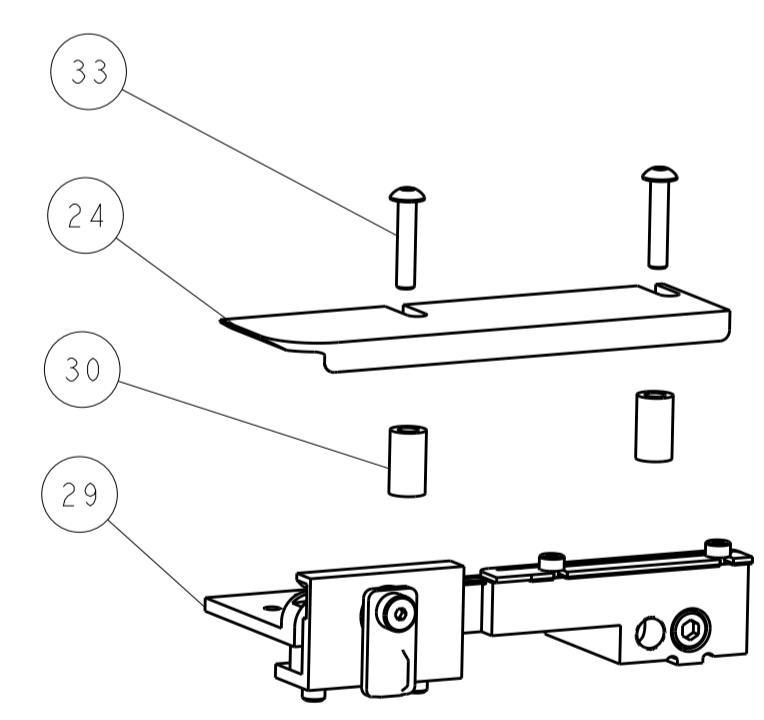
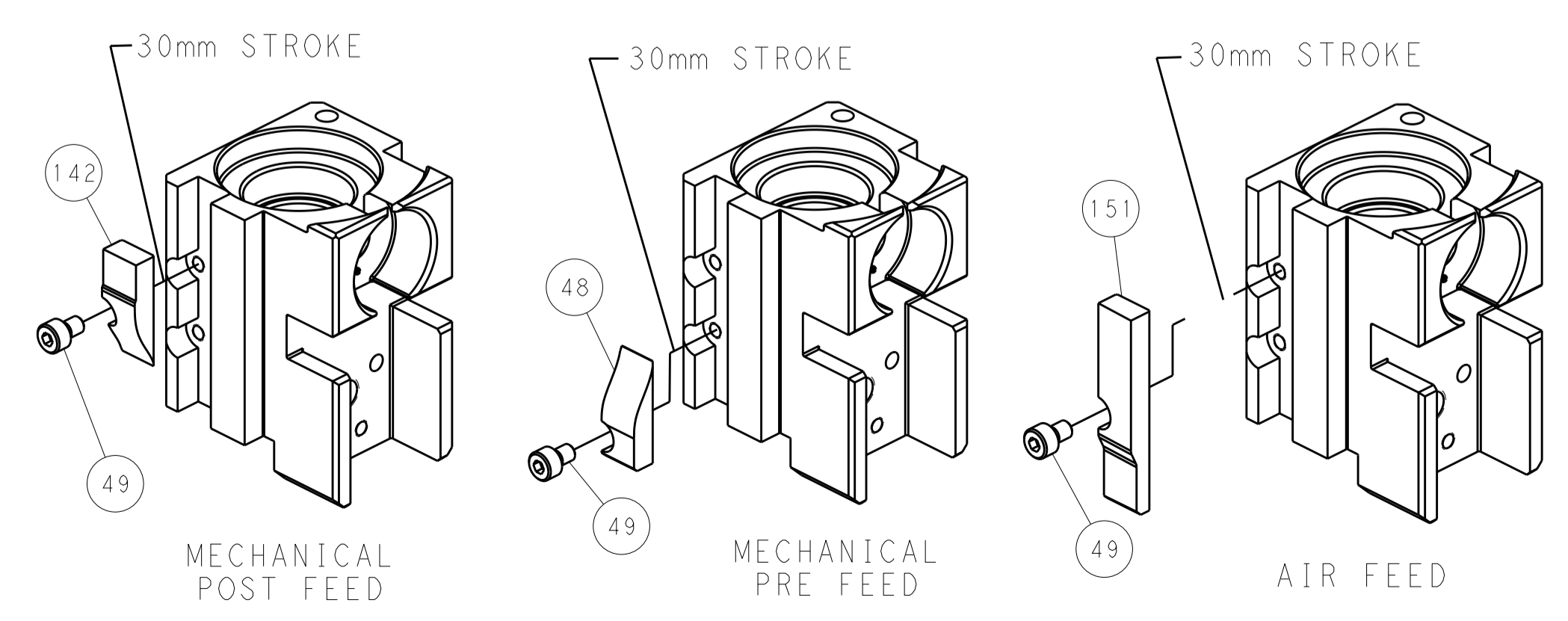


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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: R. HUANG 12DEC2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
			1:2	A1	00779	2151418	
Customer Accessible Production Drawing				SHEET 4 OF 4 REV B1			