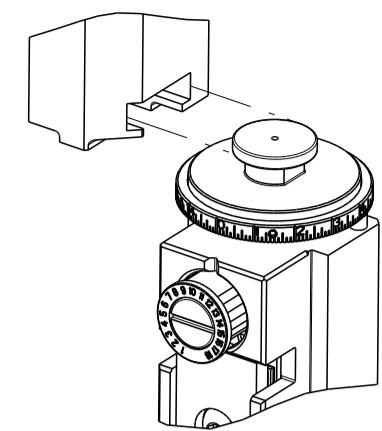


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151349-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151349-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151349-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.10 mm [.083]	F
INSUL	2.50 mm [.098]	OV

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, 2.8mm SICMA-2			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.08-4.09 mm [.160-.161 IN]		Ø1.30-2.10 mm [.051-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	FCI SPEC		
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1572406-1	211CC3S1120	1752406-2	211CC3S1220

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.22 +/- 0.04 [.048 +/- .002]	4.7
0.35+0.35	1.21 +/- 0.04 [.048 +/- .002]	4.8
0.60mm2	1.19 +/- 0.04 [.047 +/- .002]	5.1
0.50mm2	1.18 +/- 0.04 [.046 +/- .002]	5.2
0.35mm2	1.15 +/- 0.04 [.045 +/- .002]	5.7

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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
		1		DEVELOPMENT	19JUL2012	YY	SX
		A		RELEASED	21MAR2013	YY	UG
		B		ECR-22-132939	18MAR2022	JWC	RK

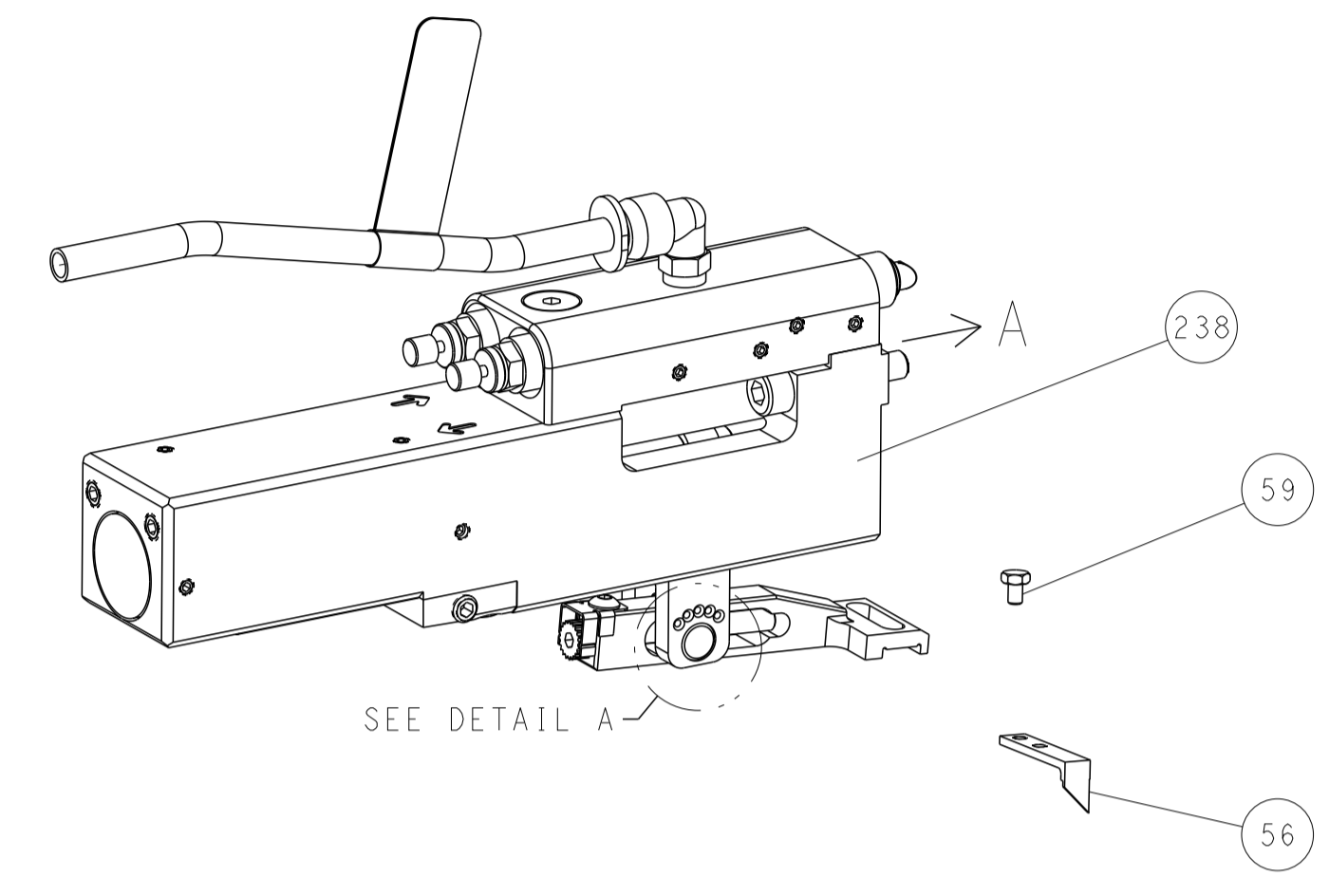
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-1	AIR FEED MODULE	238
3	-	1	2-1752354-3	STANDOFF, HOLD-DOWN	180
-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	318563-1	GUARD, FRONT CHIP	89
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-4	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	2	1	3-1633138-8	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119780-7	DEPRESSOR, SHEAR	5
-	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
1	2	1	1633964-5	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
1	2	1	8-1633305-5	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	DATE
	ANGLES	FINISH		Y. YIN	19JUL2012	G. BAILEY	19JUL2012
MATERIAL				S. XI	19JUL2012		
				PRODUCT SPEC			
				APPLICATION SPEC			
				WEIGHT			
				SCALE	1:2	SHEET	1 OF 4
				REV	B		

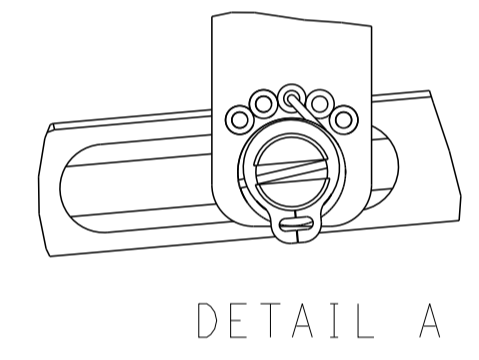
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

FEED TYPE

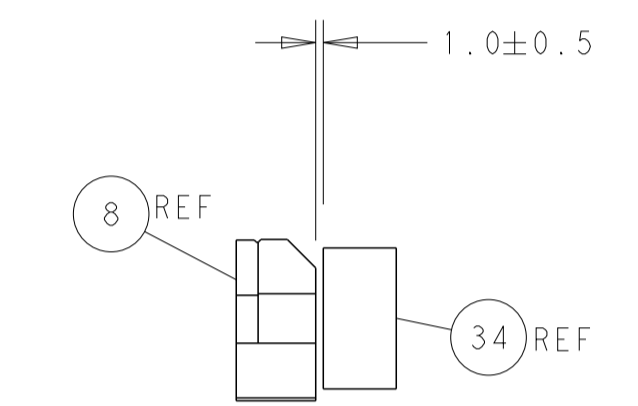
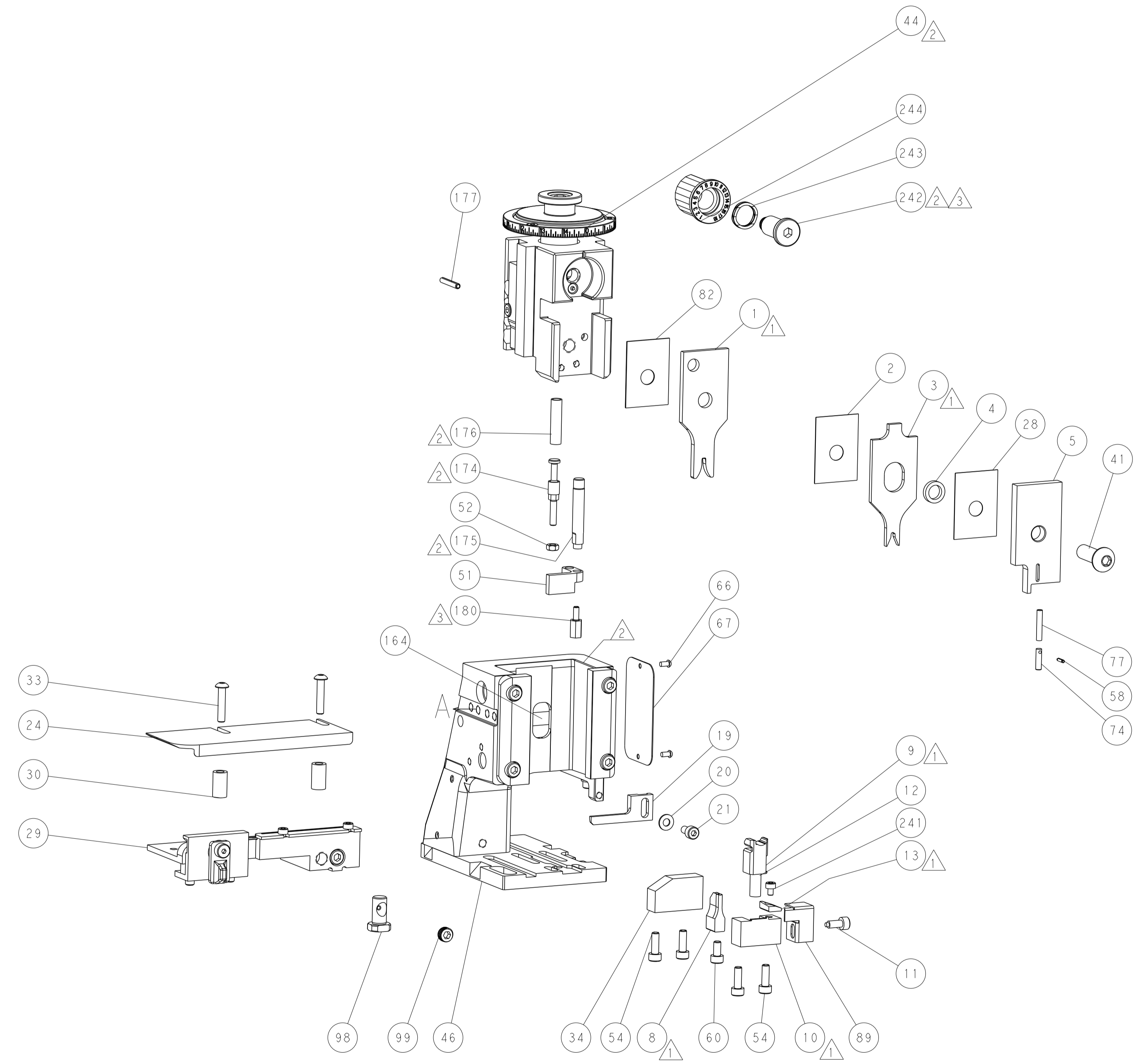
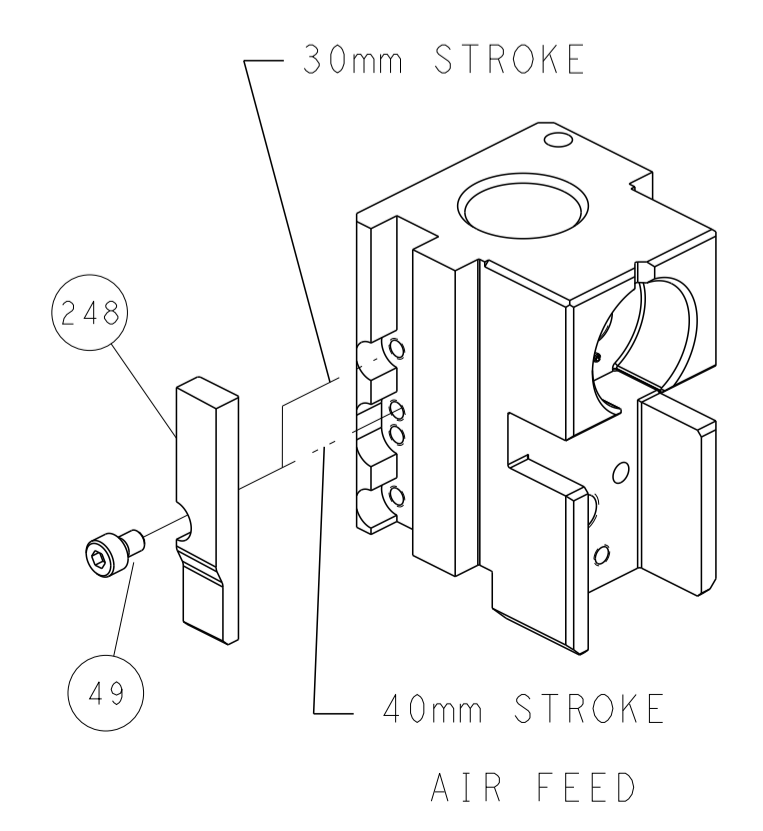
PNEUMATIC



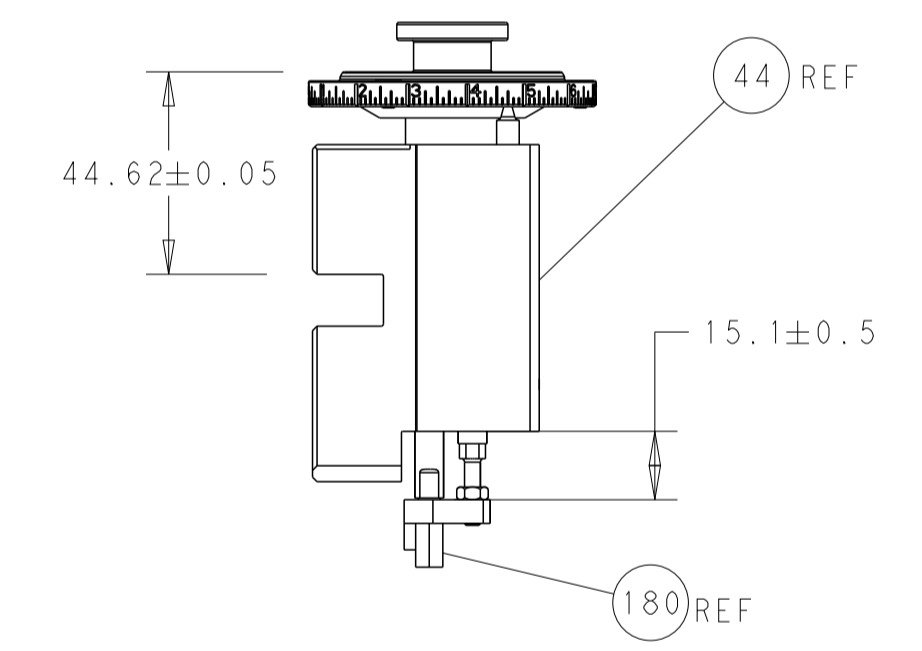
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



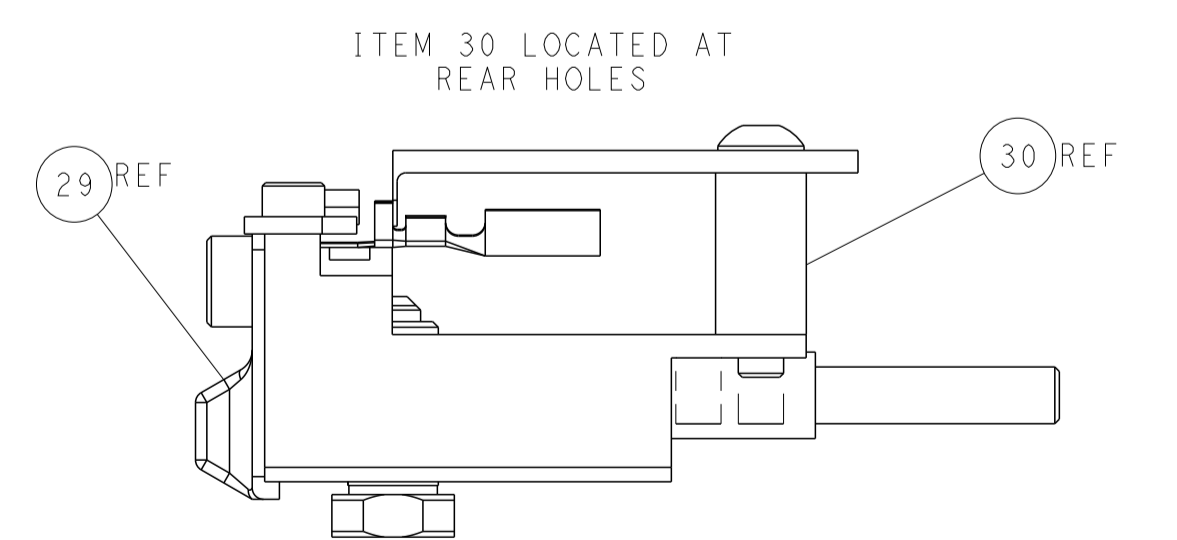
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



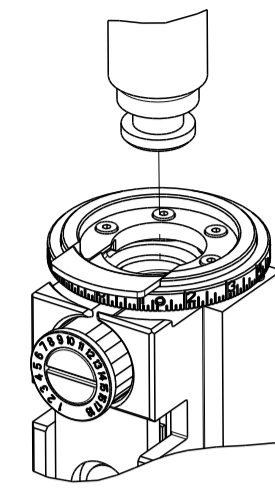
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG Y. YIN 19JUL2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
	ANGLES ±			CHK G. BAILEY 19JUL2012	NAME		
MATERIAL		FINISH		APVD S. XI 19JUL2012	Ocean Side Feed Applicator		
				PRODUCT SPEC	RESTRICTED TO		
				APPLICATION SPEC	SIZE CAGE CODE DRAWING NO		
				WEIGHT	A1 00779 ©=2151349		
				Customer Accessible Production Drawing		SCALE 1:2	SHEET 2 OF 4 REV B

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151349-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151349-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.10 mm [.083]	F
INSUL	2.50 mm [.098]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, 2.8mm SICMA-2			
WIRE STRIP LENGTH 4.08-4.09 mm [1.60-1.61 IN]		INSULATION DIAMETER RANGE Ø1.30-2.10 mm [.051-.083 IN]	
TERMINAL APPLICATION SPECIFICATION		FCI SPEC	
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1572406-1	211CC3S1120	1752406-2	211CC3S1220

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm ²	1.22+/-0.04 [.048+/-0.002]	4.7
0.35+0.35	1.21+/-0.04 [.048+/-0.002]	4.8
0.60mm ²	1.19+/-0.04 [.047+/-0.002]	5.1
0.50mm ²	1.18+/-0.04 [.046+/-0.002]	5.2
0.35mm ²	1.15+/-0.04 [.045+/-0.002]	5.7



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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)

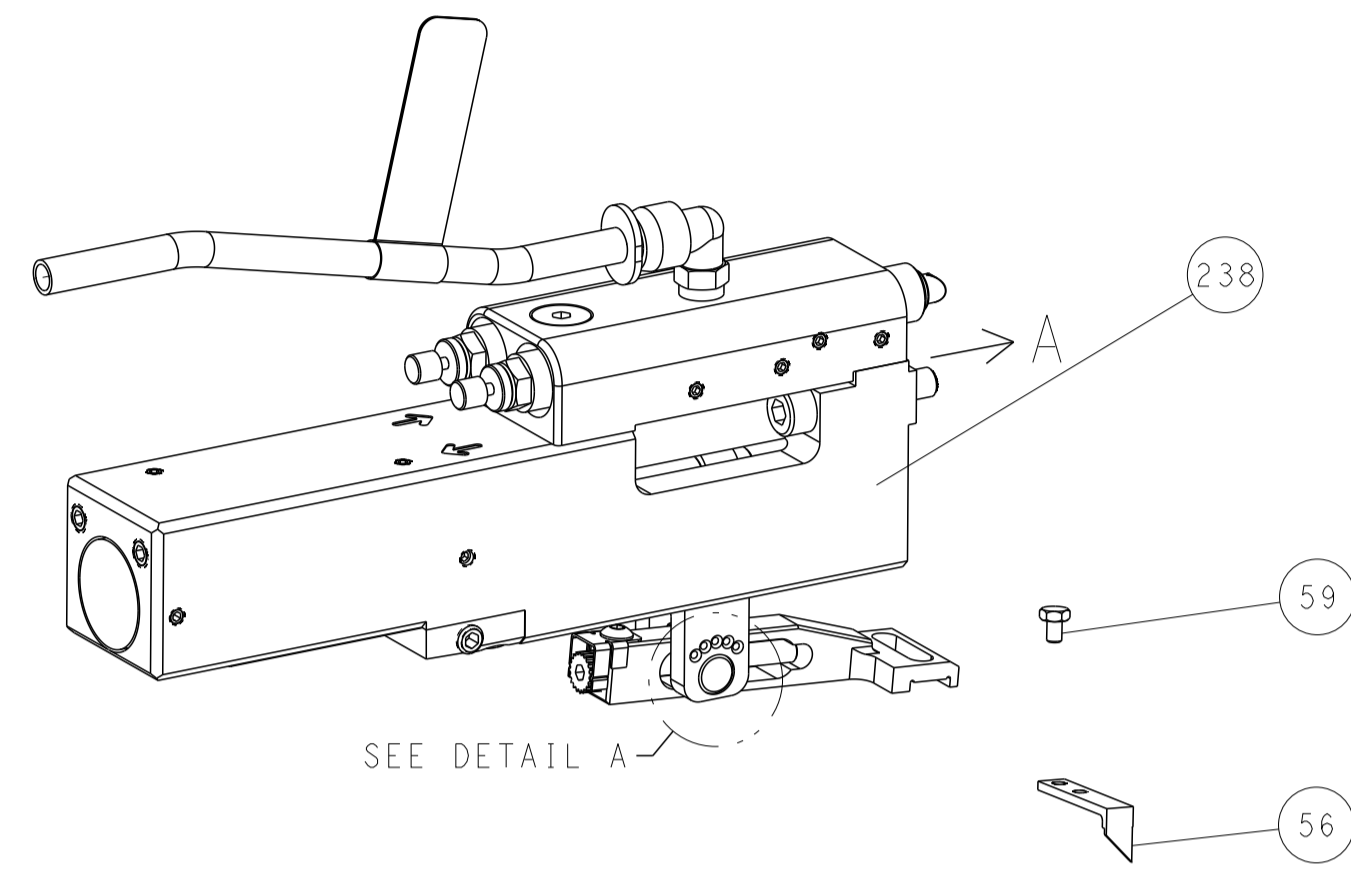
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242		
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241		
-	1	1	2844940-1	AIR FEED MODULE	238		
3	-	1	2-1752354-3	STANDOFF,HOLD-DOWN	180		
-	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177		
-	1	1	8-22280-7	SPRING, COMPRESSION	176		
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175		
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174		
-	REF	1	994970-2	COUNTER, MAGNETIC	164		
-	1	1	2119641-2	FEED CAM, AIR FEED	151		
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144		
-	4	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143		
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141		
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140		
-	1	1	2844908-1	SCREW, LOCKING	99		
-	1	1	2844907-1	POST, LOCKING	98		
-	1	1	318563-1	GUARD, FRONT CHIP	89		
-	1	1	455888-5	SPACER, CRIMPER	82		
-	1	1	22278-8	SPRING, COMPRESSION	77		
-	1	1	854769-4	HOLDER, INS	74		
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71		
-	1	1	2119740-1	TAG,IDENTIFICATION	67		
-	2	1	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58		
-	1	1	1338685-1	PAWL, FEED	56		
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52		
-	1	1	1901681-1	HOLDDOWN, TERMINAL	51		
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41		
-	1	1	1-1752356-3	SUPPORT, TERMINAL	34		
-	2	1	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33		
-	2	1	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30		
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29		
-	1	1	455888-3	SPACER, CRIMPER	28		
-	1	1	1320928-4	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	1	3-1633138-8	ANVIL, COMBINATION	8		
-	-	-	-	-	7		
-	-	-	-	-	6		
-	1	1	2119780-7	DEPRESSOR, SHEAR	5		
-	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4		
1	1	1	1633964-5	CRIMPER, INSULATION OVERLAP PREMIUM	3		
-	1	1	455888-3	SPACER, CRIMPER	2		
1	1	1	8-1633305-5	CRIMPER, WIRE PREMIUM	1		
-77	-22		PART NO	DESCRIPTION	ITEM NO		

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 19JUL2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean Side Feed Applicator	
MATERIAL		FINISH		APVD S. XI 19JUL2012		SIZE A1	
				WEIGHT		SCALE 1:2	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 3 OF 4	

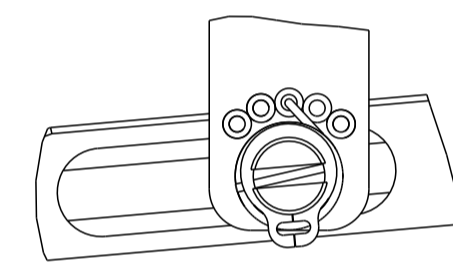
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

FEED TYPE

PNEUMATIC

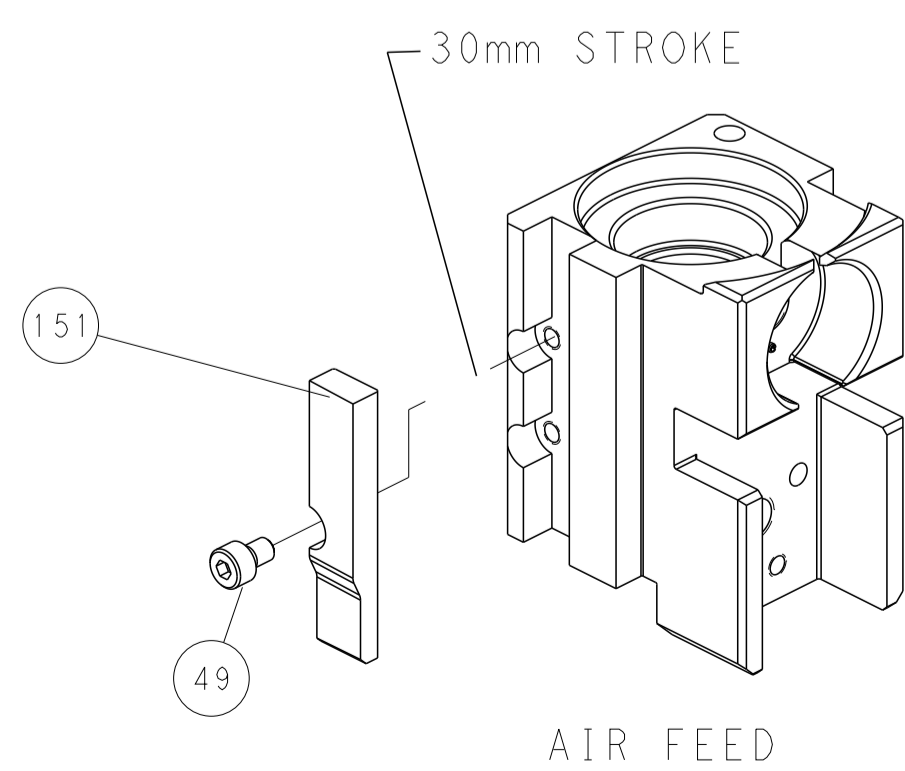


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

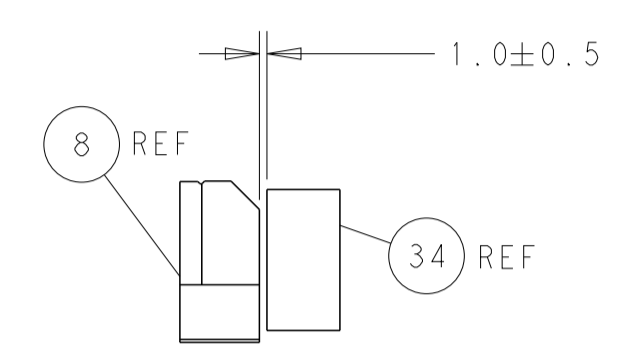
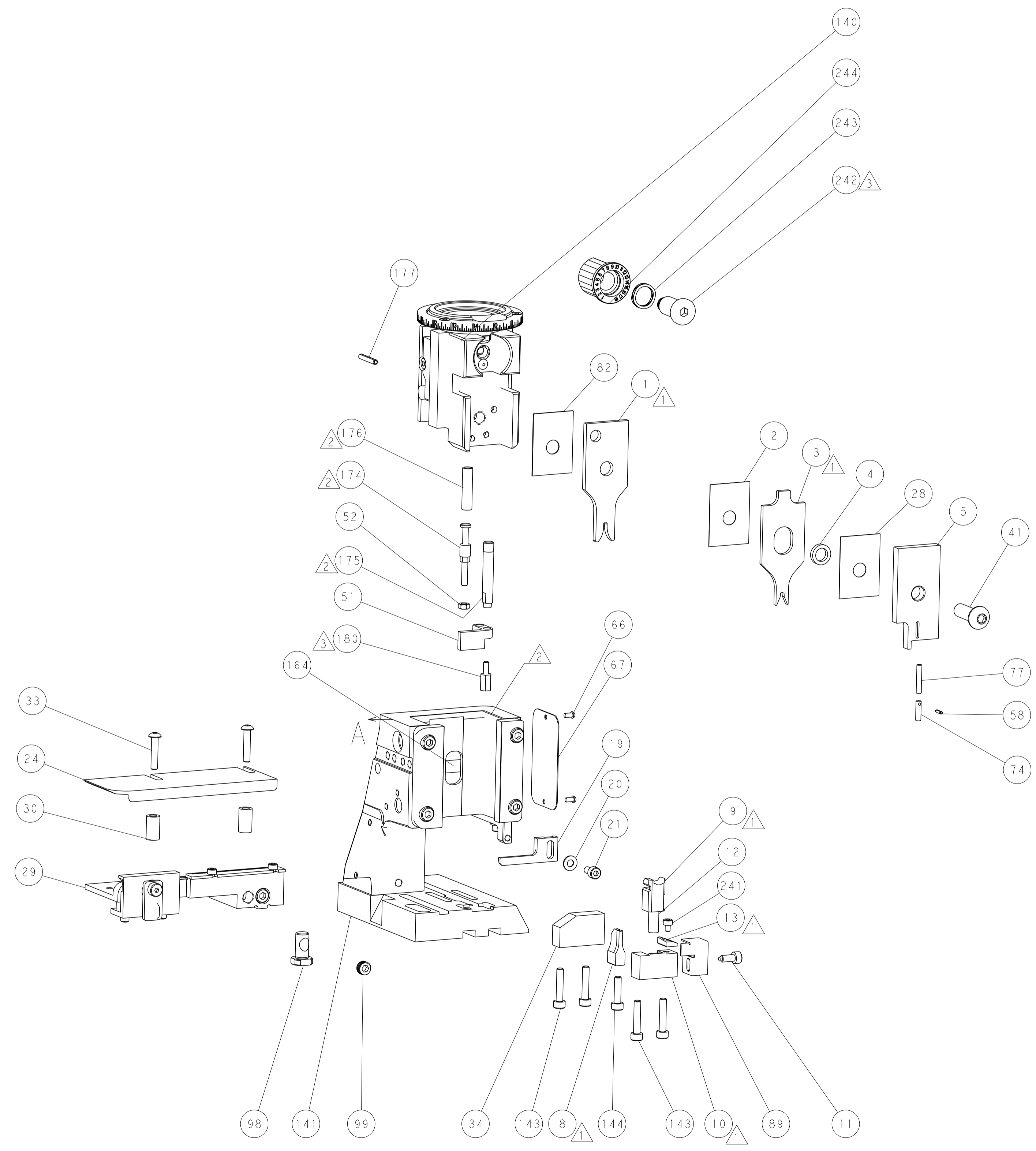


DETAIL A

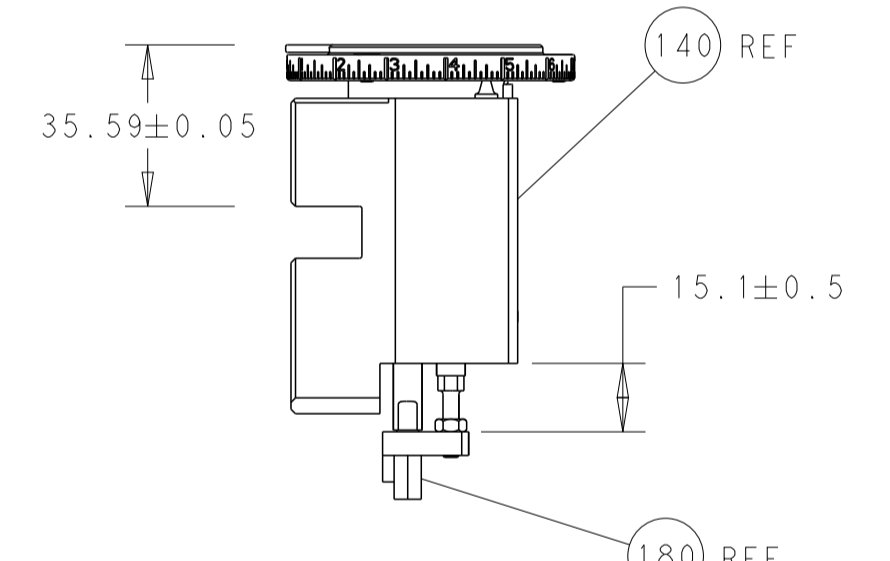
CAM POSITION



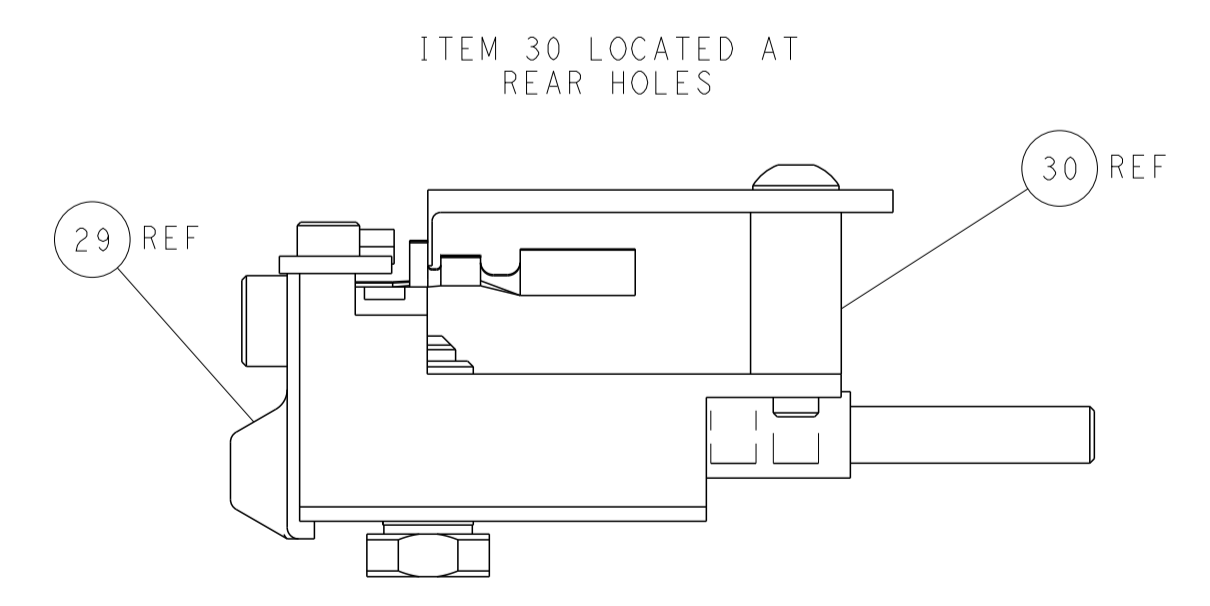
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



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)

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	CHK G. BAILEY 19JUL2012
MATERIAL:		APVD S. XI 19JUL2012	SCALE 1:2
WEIGHT:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEET 4 OF 4 REV B