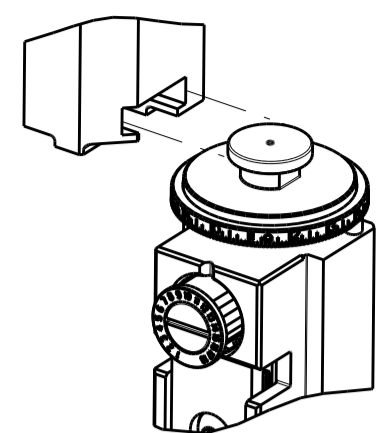


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151264-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151264-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151264-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.70-3.30 mm [.106-.130 IN]		Ø2.00-2.70 mm [.079-.106 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18079	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927863-1	927863-2	927863-3	927863-4

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.70-3.30 mm [.106-.130 IN]		Ø2.00-3.30 mm [.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18080	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927865-1	927865-2	927865-3	927865-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36+/-0.05 [.054+/- .002]	5.1
0.75mm2	1.27+/-0.05 [.050+/- .002]	6.0
0.50mm2	1.18+/-0.05 [.046+/- .002]	7.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36+/-0.05 [.054+/- .002]	5.1
0.75mm2	1.27+/-0.05 [.050+/- .002]	6.0
0.50mm2	1.18+/-0.05 [.046+/- .002]	7.1

- 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.
- 6. 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			
		REV	DATE	BY	APPV
A	66	1	03OCT2014	GH	TE
		A	11NOV2014	GH	TE
		B	23DEC2019	FZ	TE

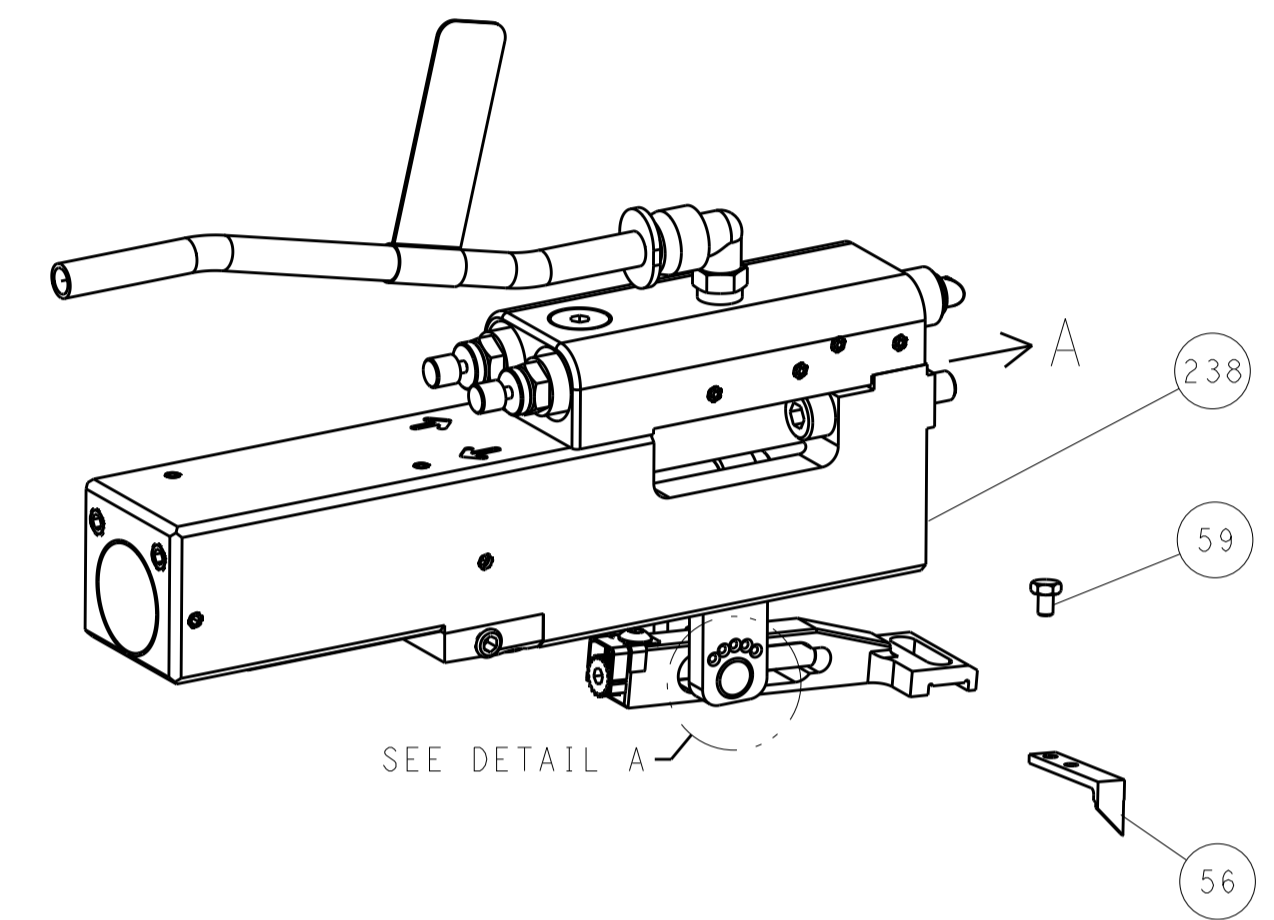
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	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	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	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	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-1	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	1-1633920-0	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	2	1-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	1-456405-6	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	
DWN: HOFFNER 02OCT2014		CHK: T. ELBIN 03OCT2014		APVD: T. ELBIN 03OCT2014		NAME: Ocean Side Feed Applicator	
SIZE: A1		CAGE CODE: 00779		DRAWING NO: 2151264		RESTRICTED TO: B	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET: 1 of 4		REV: B	

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

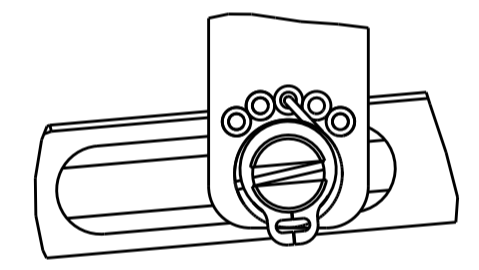
FEED TYPE

PNEUMATIC



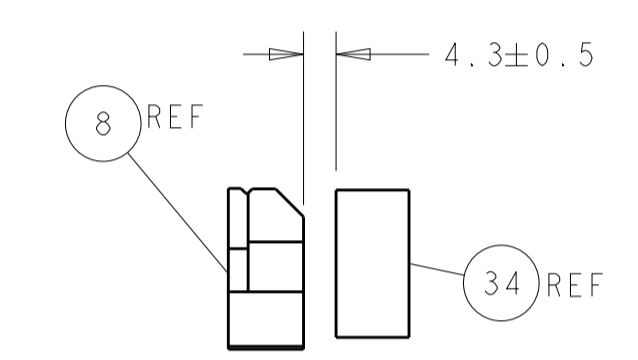
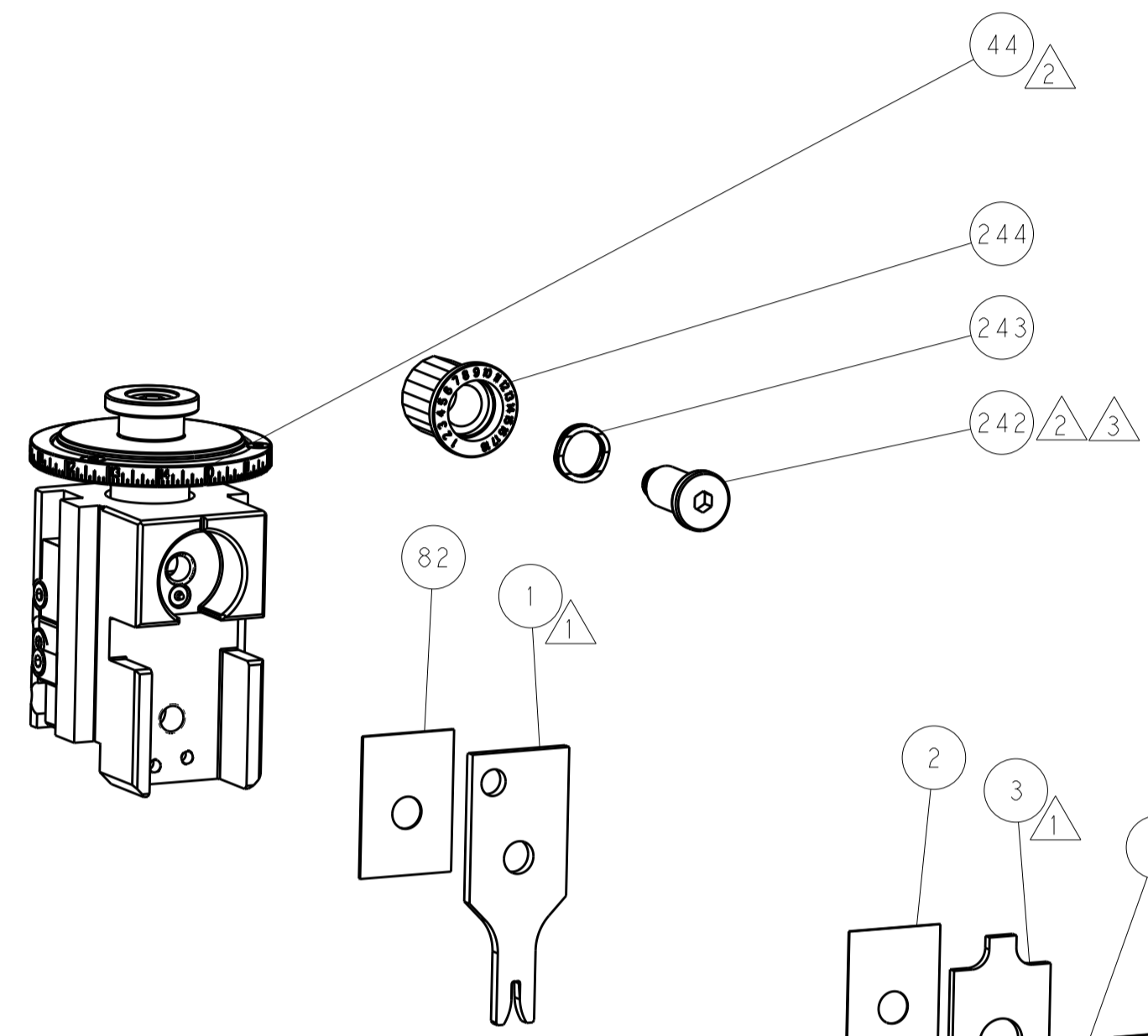
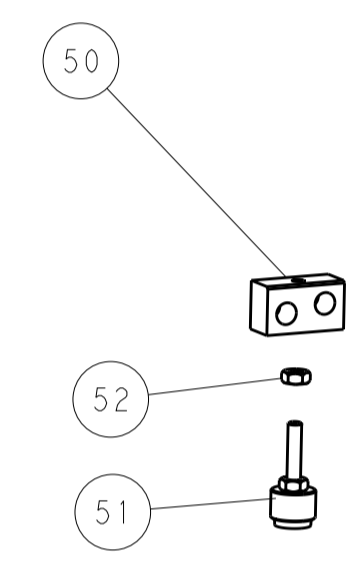
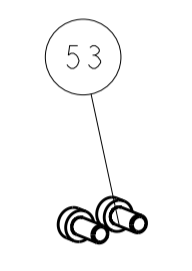
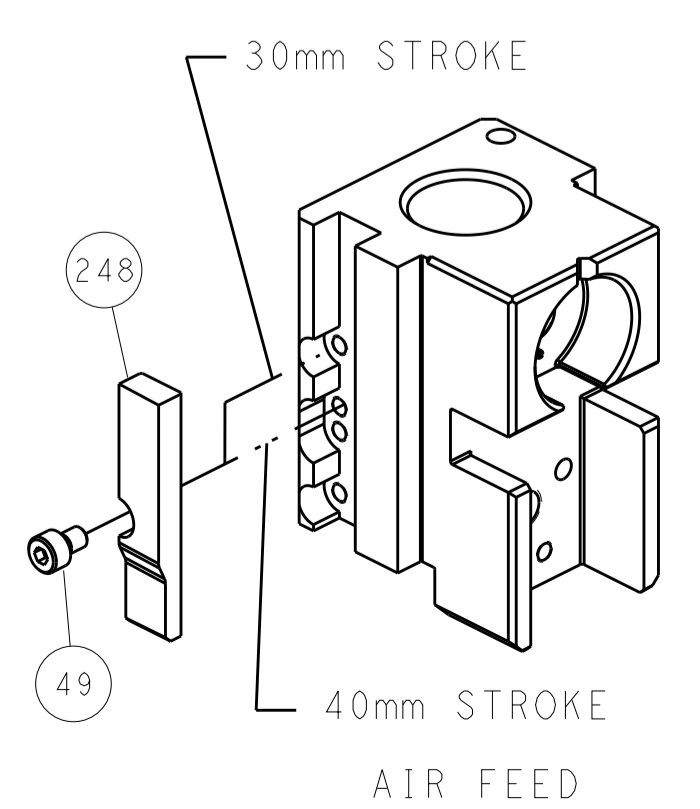
SEE DETAIL A

FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

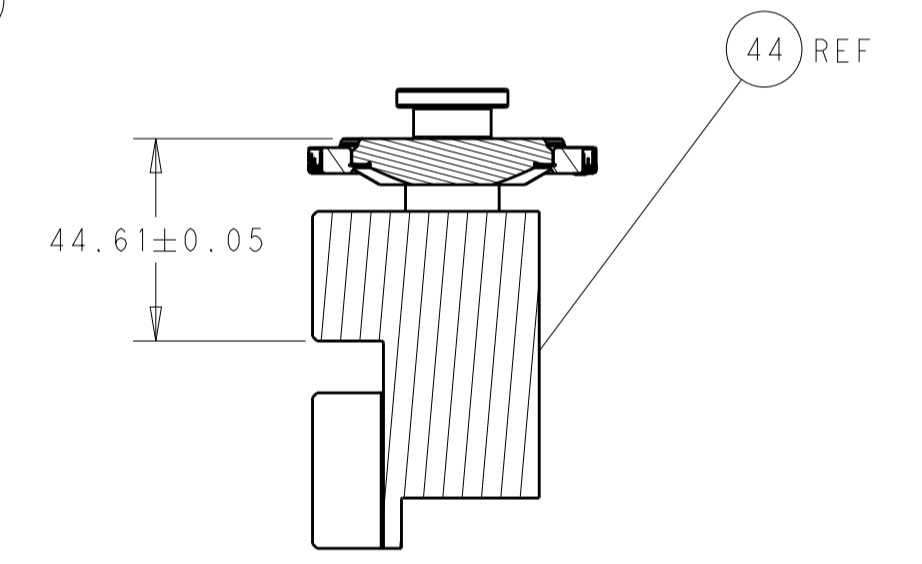


DETAIL A

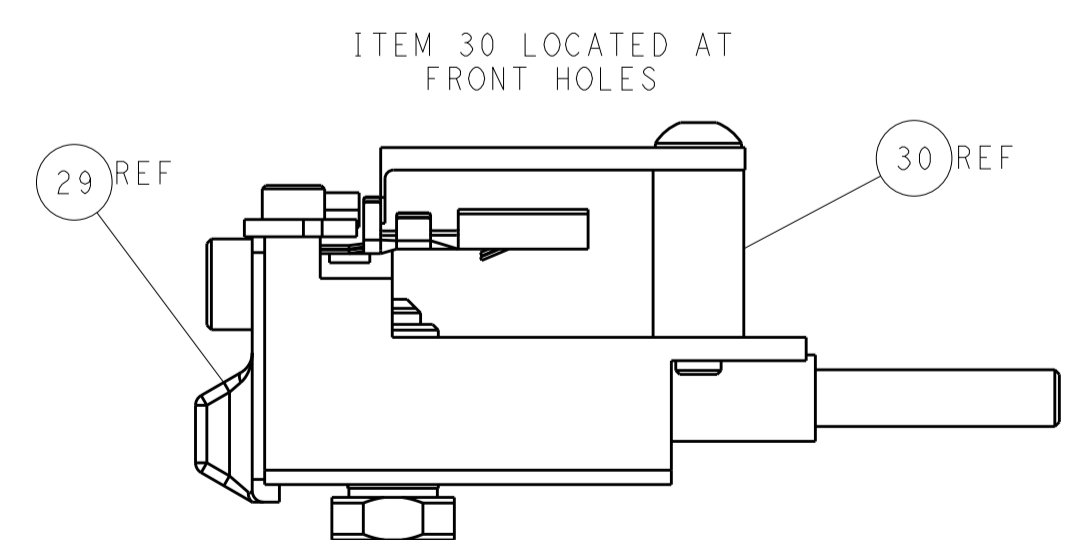
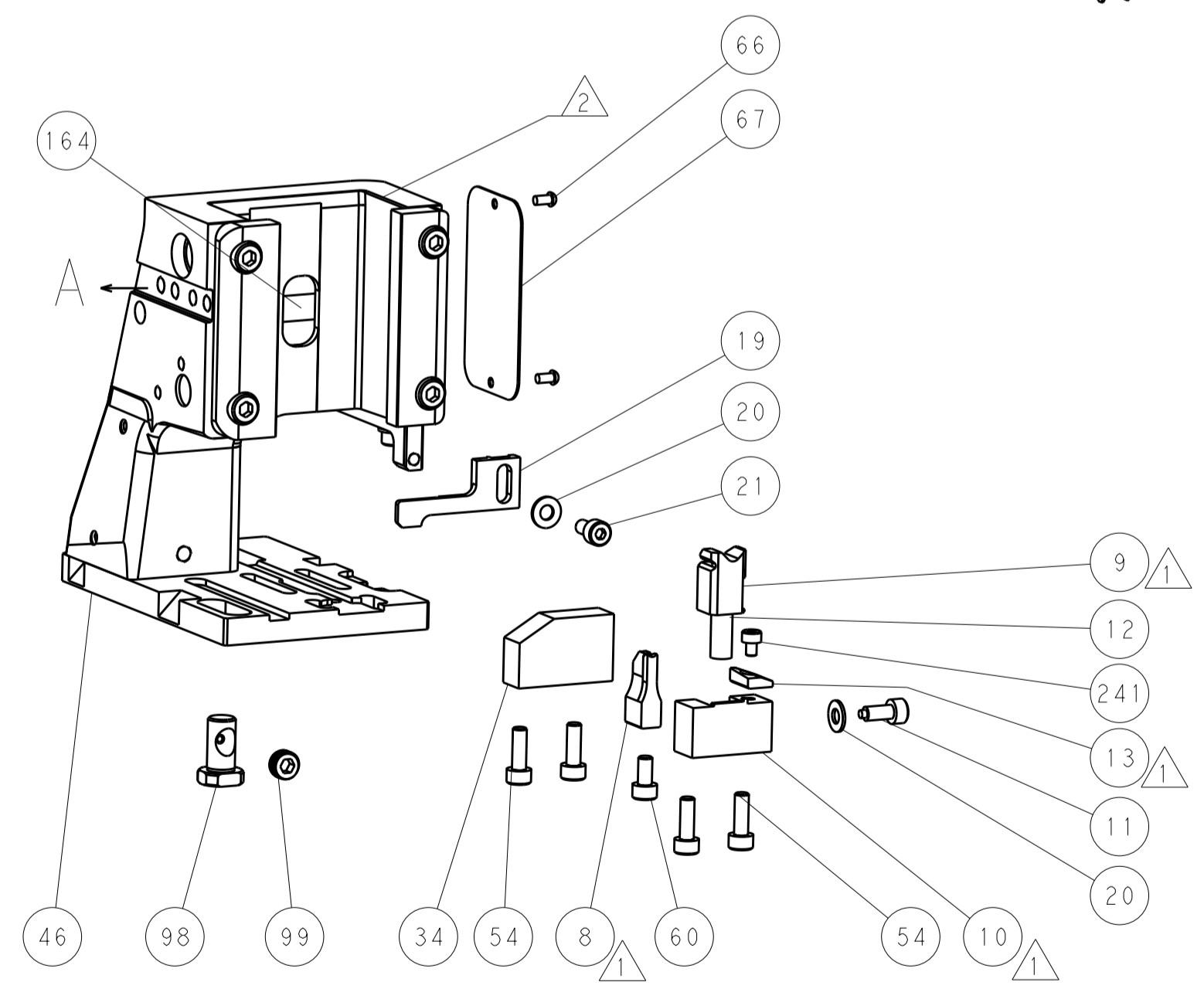
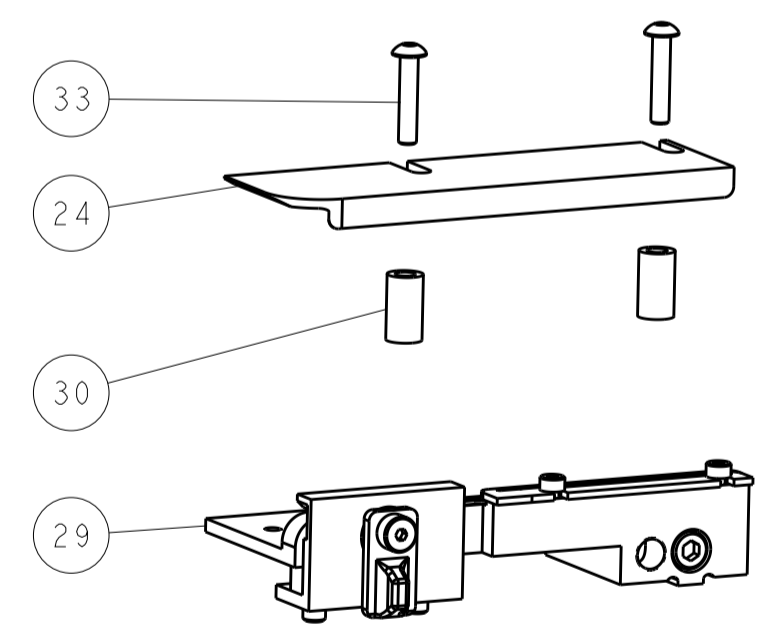
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM 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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> <small>IT IS THE BUYER'S RESPONSIBILITY TO CONTACT THE SUPPLIER FOR THE LATEST REVISIONS. THE BUYER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST REVISIONS.</small>		DWN HOFFNER 02OCT2014 CHK T. ELBIN 03OCT2014 APVD T. ELBIN 03OCT2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151264	RESTRICTED TO: Customer Accessible Production Drawing SCALE: 1:2 SHEET: 2 OF 4 REV: B

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151264-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151264-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.70-3.30 mm [.106-.130 IN]		∅2.00-2.70 mm [.079-.106 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18079	-	-
TERMINALS APPLIED ⁵			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927863-1	927863-2	927863-3	927863-4

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.70-3.30 mm [.106-.130 IN]		∅2.00-3.30 mm [.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18080	-	-
TERMINALS APPLIED ⁵			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927865-1	927865-2	927865-3	927865-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁴
1.00mm2	1.36+/-0.05 [.054+/- .002]	5.1
0.75mm2	1.27+/-0.05 [.050+/- .002]	6.0
0.50mm2	1.18+/-0.05 [.046+/- .002]	7.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁴
1.00mm2	1.36+/-0.05 [.054+/- .002]	5.1
0.75mm2	1.27+/-0.05 [.050+/- .002]	6.0
0.50mm2	1.18+/-0.05 [.046+/- .002]	7.1

- 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.
- 6. 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	APPV
A	66	-	-	-	-

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-

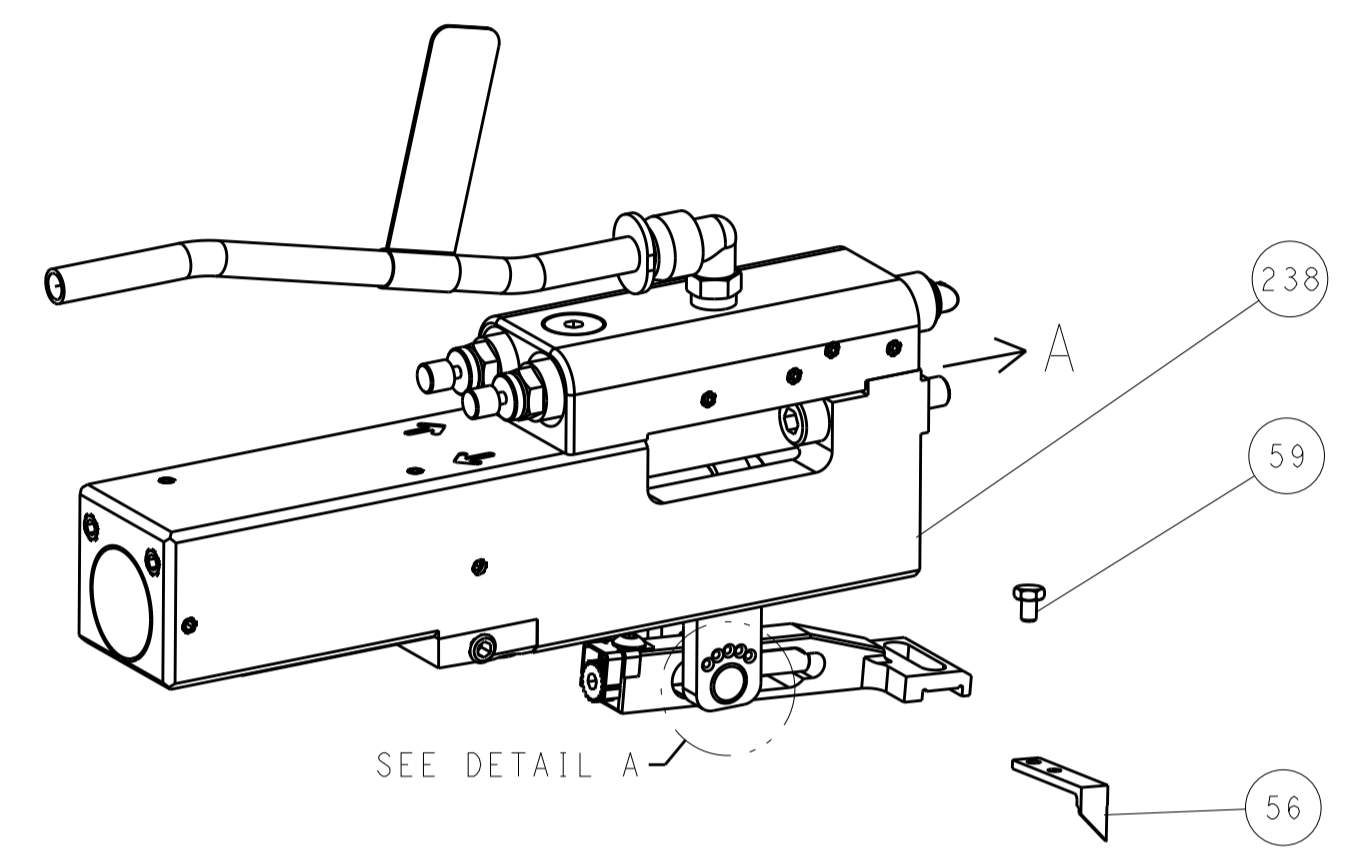
-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	2844940-1	AIR FEED MODULE	238	
-	REF	994970-2	COUNTER, MAGNETIC	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	
-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	455888-5	SPACER, CRIMPER	82	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	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	1338685-1	PAWL, FEED	56	
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	690753-2	SPACER, TONKER	50	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	2119652-1	FEED CAM, PRE FEED	48	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1752356-1	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-3	SPACER, CRIMPER	28	
-	1	1320928-2	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	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	4-1633920-0	ANVIL, COMBINATION	8	
-	-	-	-	7	
-	-	-	-	6	
-	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
-	1	1-1633961-5	CRIMPER, INSULATION F PREMIUM	3	
-	1	455888-3	SPACER, CRIMPER	2	
-	1	1-456405-6	CRIMPER, WIRE PREMIUM	1	
-	77	22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: HOFFNER 02OCT2014		CHK: T. ELBIN 03OCT2014		APVD: T. ELBIN 03OCT2014		NAME: Ocean Side Feed Applicator	
0 PLC	±	0.00	±	0.00	±	0.00	±	0.00	±	0.00	±
1 PLC	±	0.01	±	0.01	±	0.01	±	0.01	±	0.01	±
2 PLC	±	0.02	±	0.02	±	0.02	±	0.02	±	0.02	±
3 PLC	±	0.03	±	0.03	±	0.03	±	0.03	±	0.03	±
4 PLC	±	0.04	±	0.04	±	0.04	±	0.04	±	0.04	±
ANGLES	±	0.01	±	0.01	±	0.01	±	0.01	±	0.01	±
MATERIAL	-	FINISH	-	WEIGHT	-	SCALE	1:2	SHEET	3	OF	4
Customer Accessible Production Drawing				REV B		SIZE		CAGE CODE		DRAWING NO	
A1				00779		C=2151264		RESTRICTED TO		-	

LOC		DIST		REVISIONS			
A		66		REV	DATE	BY	APP'D
-				SEE SHEET 1	-	-	-

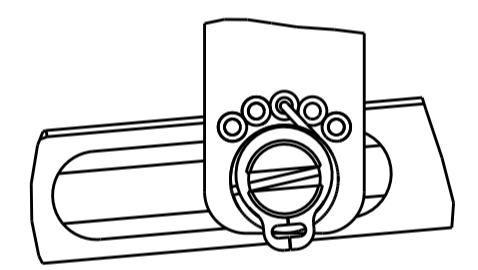
FEED TYPE

PNEUMATIC



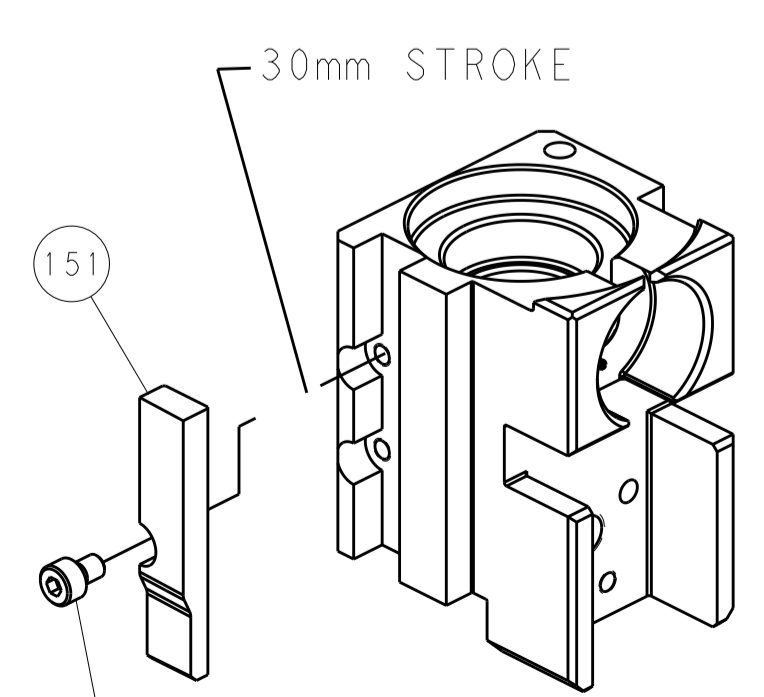
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

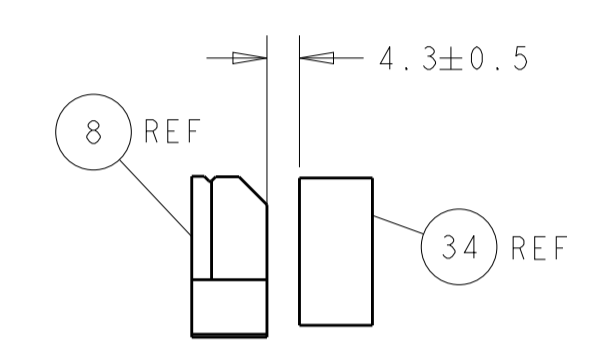
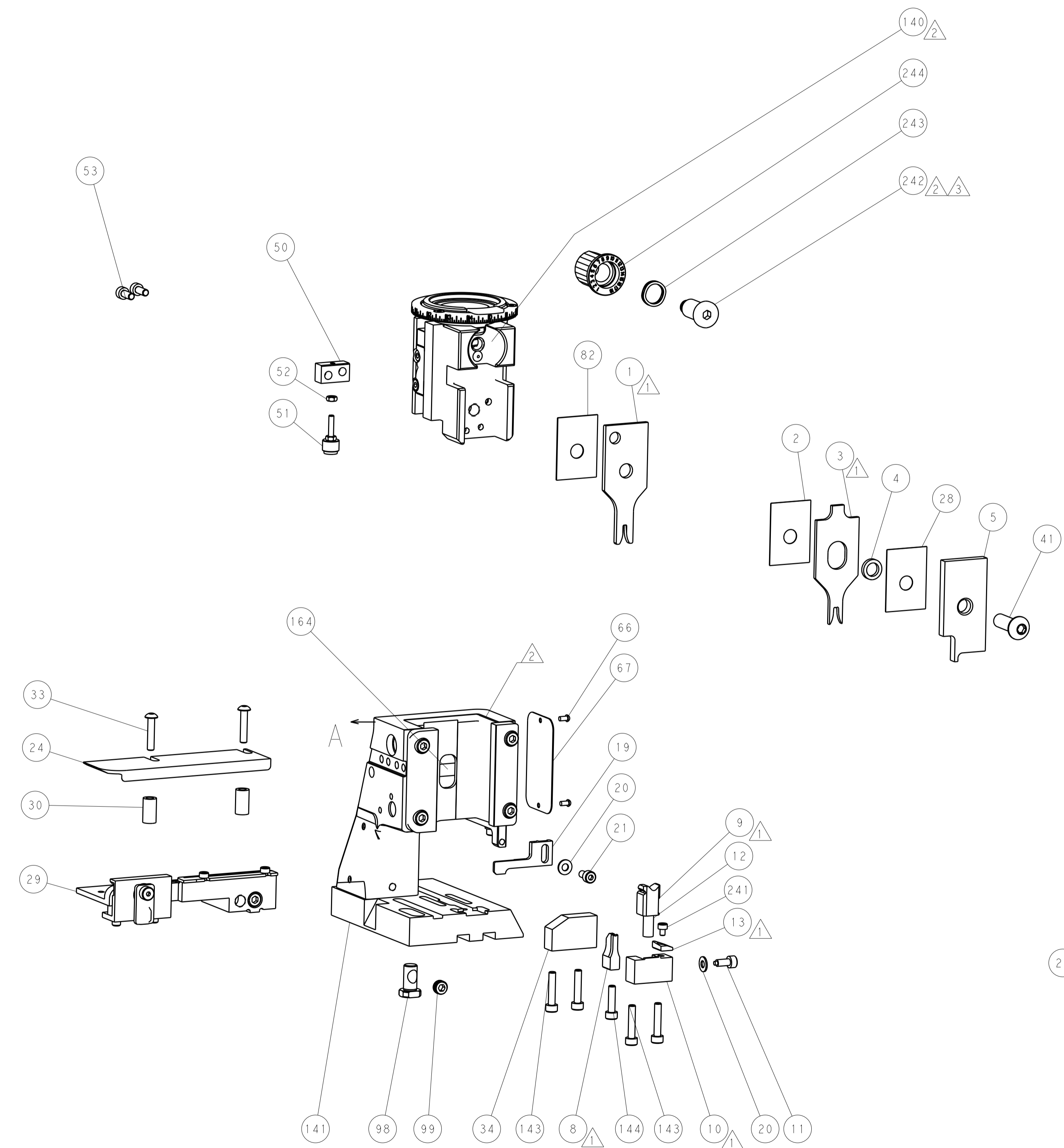


DETAIL A

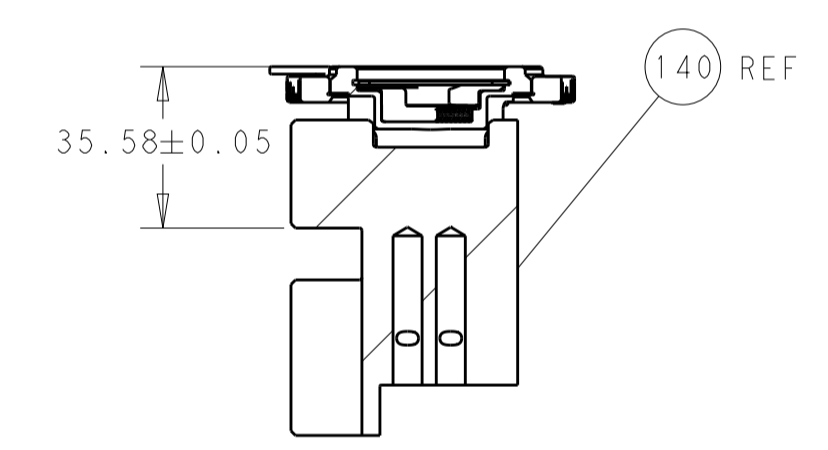
CAM POSITION



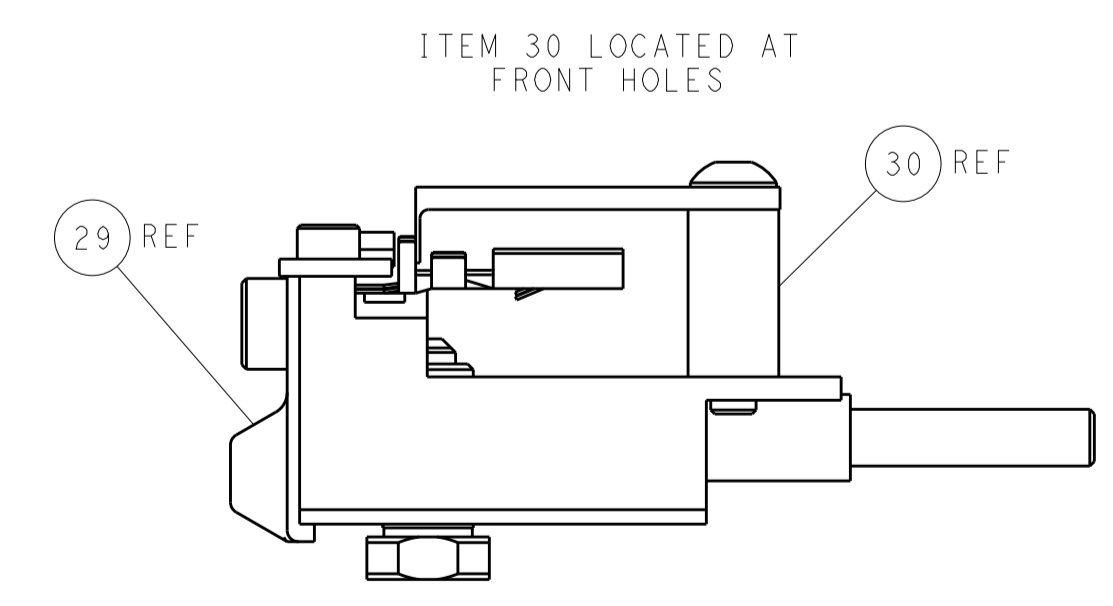
AIR FEED



TERMINAL SUPPORT LOCATION



RAM 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)

<small>THE DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: HOFFNER 02OCT2014 CHK: TELBIN 03OCT2014 APVD: TELBIN 03OCT2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151264 SCALE: 1:2 SHEET: 4 OF 4 REV: B