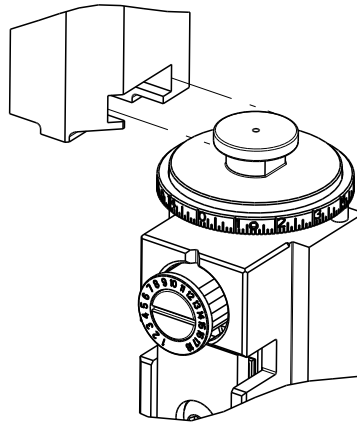
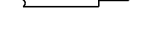


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151866-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151866-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151866-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151866-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151866-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.85 mm [.112]	F
INSUL	3.85 mm [.152]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: MALE 2.8 X 0.8 SICMA 2			
WIRE STRIP LENGTH 5.00-5.00 mm [.197-.197 IN]			INSULATION DIAMETER RANGE Ø2.00-3.00 mm [.079-.118 IN]
TERMINAL APPLICATION SPECIFICATION		211FT0013 Rev -	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1949376-1	211CL3S2120	1949376-2	211CL3S2220

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.88+/-0.04 [.074+/- .002]	6.7
2.00mm2	1.73+/-0.04 [.068+/- .002]	8.3
1.50mm2	1.67+/-0.04 [.066+/- .002]	8.8
1.00mm2	1.55+/-0.04 [.061+/- .002]	9.8



- 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. 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)

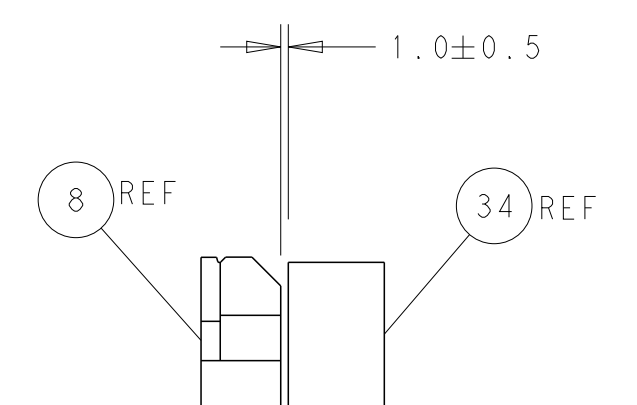
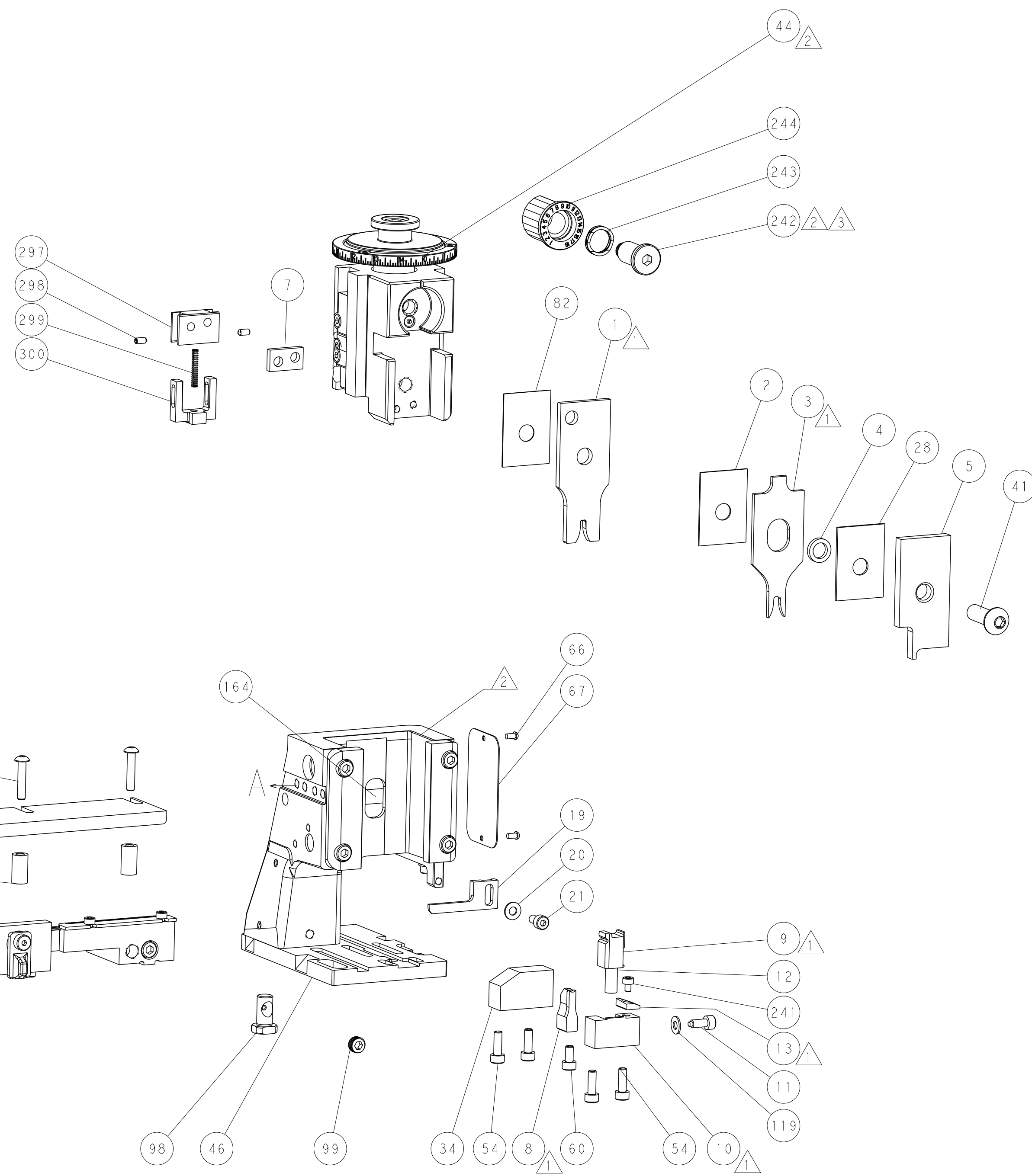
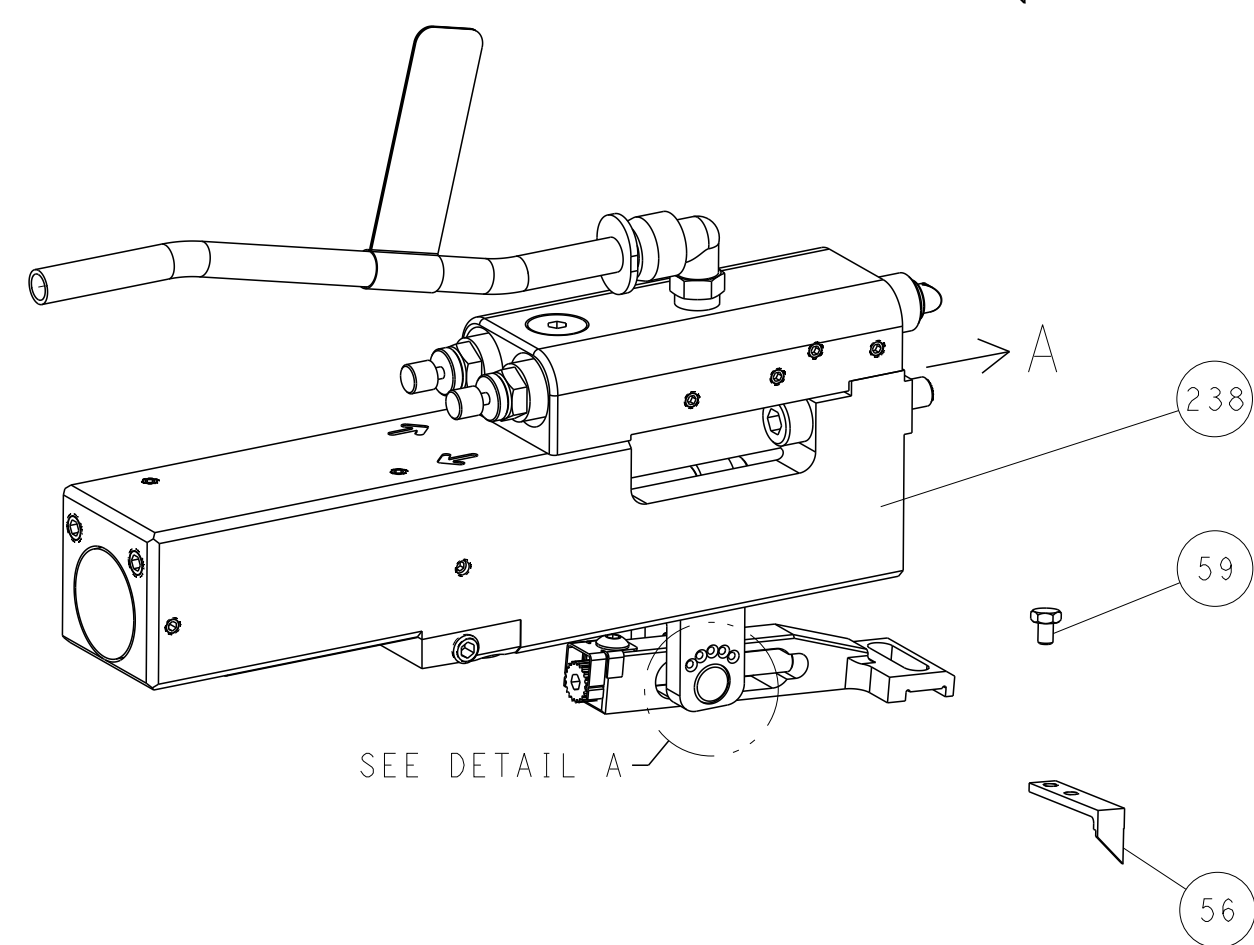
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A	66	P	LTR	DESCRIPTION	DATE
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		B		ECR-22-150684	29AUG2022

-	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1803944-1	SPACER, TONKER	297
-	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	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	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
-	1	1	1	1	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1320928-6	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	462006-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	7-1633138-3	ANVIL, COMBINATION	8
-	1	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2-2119785-4	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	2	1	9-1673600-0	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	ITEM NO
-	-	-	-	-	-	DESCRIPTION	

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST EDITION.				OWN L. ZHANG 24JAN2013	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS:				CHK L. ZHANG 24JAN2013	NAME Ocean Side Feed Applicator		
mm				APVD S. XI 24JAN2013	PRODUCT SPEC		
					APPLICATION SPEC		
					SIZE CASE CODE DRAWING NO		
					A1 00779 C=2151866		
MATERIAL					RESTRICTED TO		
					Customer Accessible Production Drawing		
					SCALE 1:2 SHEET 1 OF 4 REV B		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PNEUMATIC



Technical drawing of a mechanical part. A dimension line indicates a height of 43.9 ± 0.05 . A callout circle labeled "44 REF" points to a specific feature on the top surface of the part.

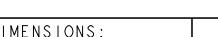
ITEM 30 LOCATED AT REAR HOLES

29 REF

30 REF

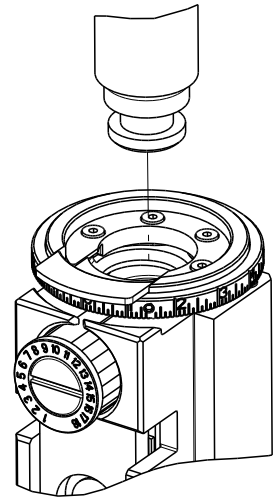
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FROM TFCO ELECTRONICS CORPORATION IT IS SUBJECT TO THE TERMS AND CONDITIONS OF THE ORGANIZATION'S POLICY AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 24JAN2013 L. ZHANG CHK 24JAN2013 L. ZHANG APVD 24JAN2013 S.XI PRODUCT SPEC APPLICATION SPEC		 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 -	
MATERIAL - - -		FINISH - - -		WEIGHT - - -	
		SIZE A1		CAGE CODE 00779	
		DRAWING NO C=2151866		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV B	

8	7	
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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		
PART NUMBER	REVISION	DESCRIPTION
2-2151866-1	B	FINE CRIMP HEIGHT ADJUST
2-2151866-2	B	FINE CRIMP HEIGHT ADJUST
7-2151866-7	A	CRIMP TOOLING KIT
		FEED TYPE
		MECHANICAL
		PNEUMATIC
		-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.85 mm [.112]	F
INSUL	3.85 mm [.152]	OV
APPLICATOR INSTRUCTIONS		
408-35042		

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: MALE 2.8 X 0.8 SICMA 2			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.00-5.00 mm [.197-.197 IN]			Ø2.00-3.00 mm [.079-.118 IN]
TERMINAL APPLICATION SPECIFICATION		211FT0013 Rev -	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1949376-1	211CL3S2120	1949376-2	211CL3S2220

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		1.88+/-0.04 [.074+/- .002]		6.7
2.00mm2		1.73+/-0.04 [.068+/- .002]		8.3
1.50mm2		1.67+/-0.04 [.066+/- .002]		8.8
1.00mm2		1.55+/-0.04 [.061+/- .002]		9.8



- 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. 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	REVISONS			
A	66	P	LTR	DESCRIPTION	DATE
			-	SEE SHEET 1	-

-	1	1	1803945-4	TONKER	300
-	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	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	-	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
-	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	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	455888-4	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	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	1752356-6	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	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-6	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	462006-6	FLOATING SHEAR, FRONT	9
-	1	1	7-1633138-3	ANVIL, COMBINATION	8
-	1	1	240641-5	SPACER	7
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	2-2119785-4	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	9-1673600-0	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
DWN L.ZHANG 24JAN2013			STE TE Connectivity Harrisburg, PA 17105-3608		
CHK L.ZHANG 24JAN2013			NAME Ocean Side Feed Applicator		
APVD S.XI 24JAN2013			SIZE CAGE CODE DRAWING NO RESTRICTED TO		
DIMENSIONS: mm			0 PLC ±" 1 PLC ±" 2 PLC ±" 3 PLC ±" 4 PLC ±" ANGLES FINISH		
MATERIAL			WEIGHT		
Customer Accessible Production Drawing			SCALE 1:2 SHEET 3 OF 4 REV B		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

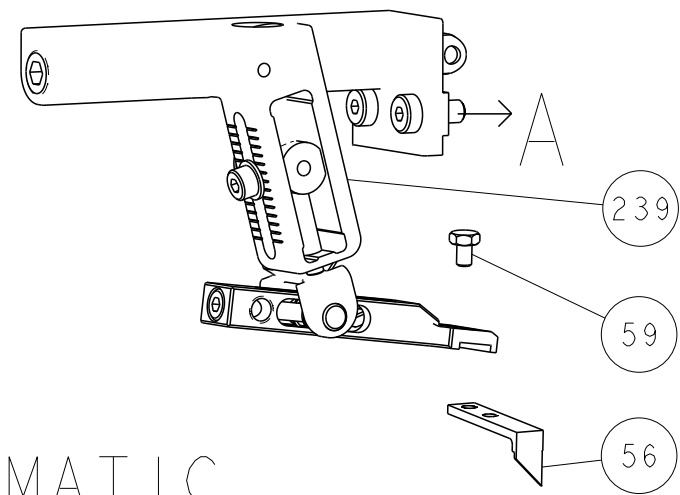
D

C

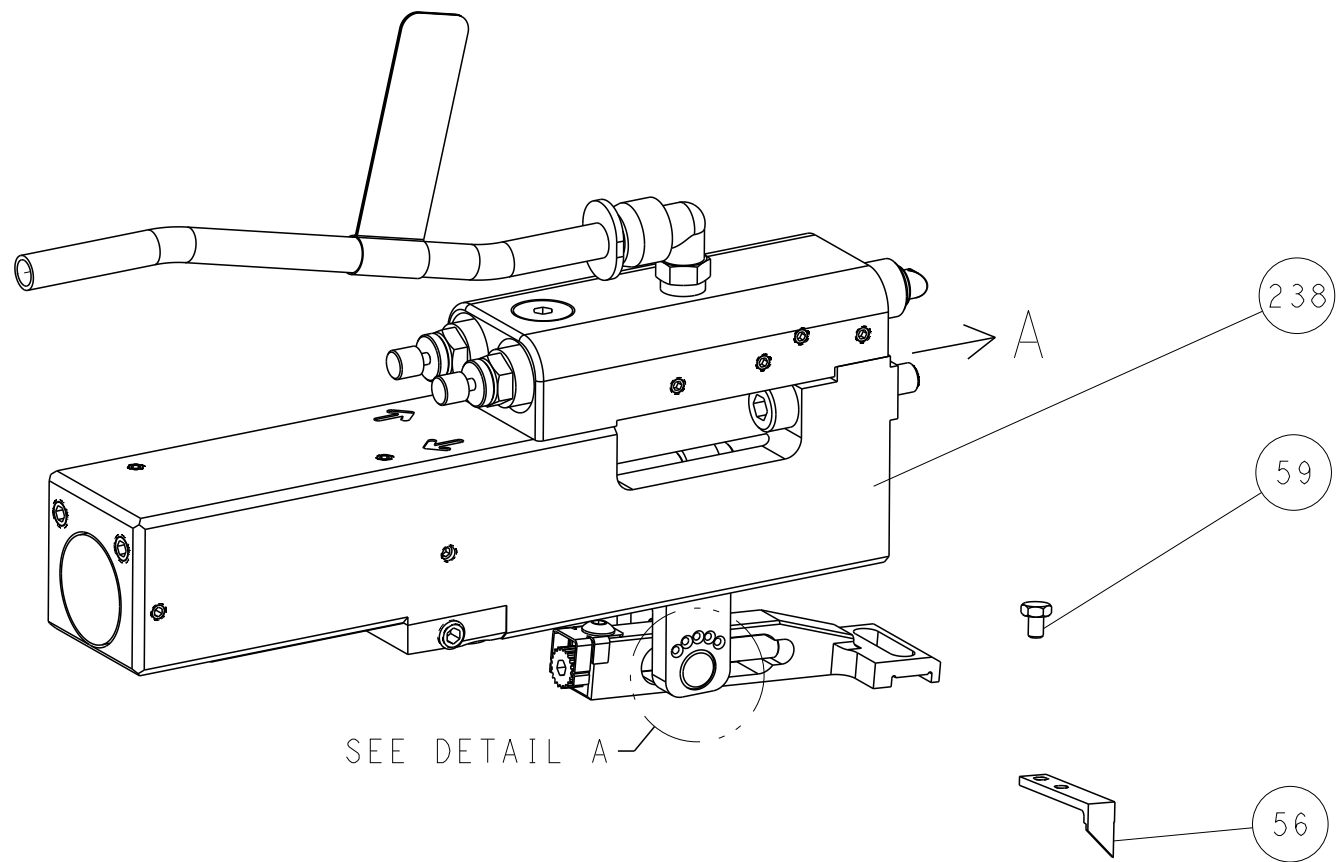
B

A

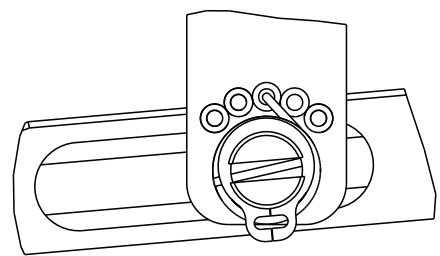
FEED TYPE MECHANICAL



PNEUMATIC

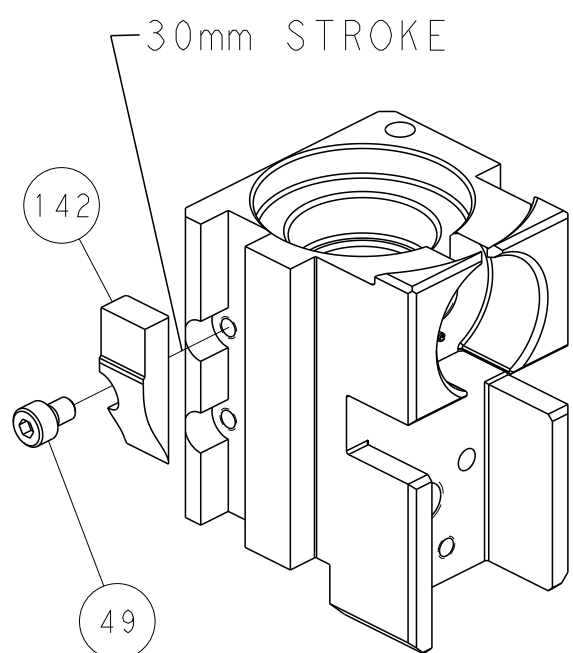


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

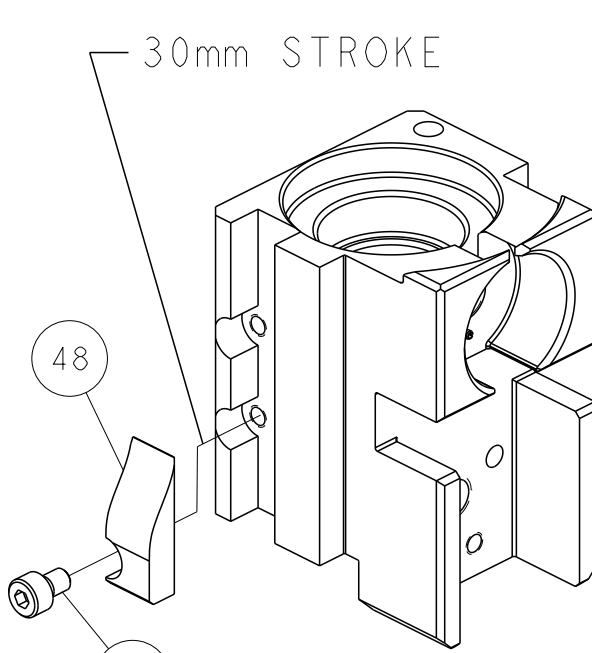


DETAIL A

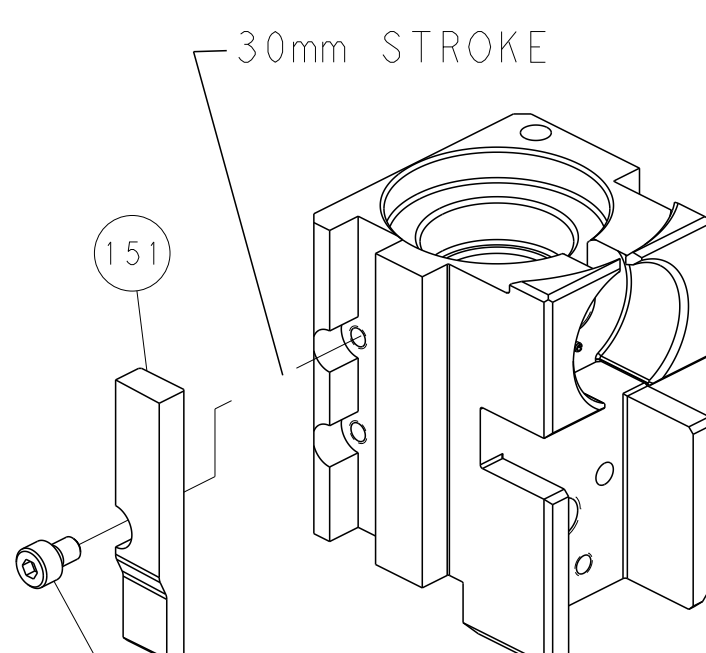
CAM POSITIONS



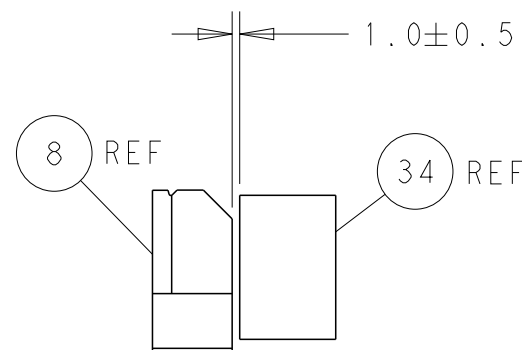
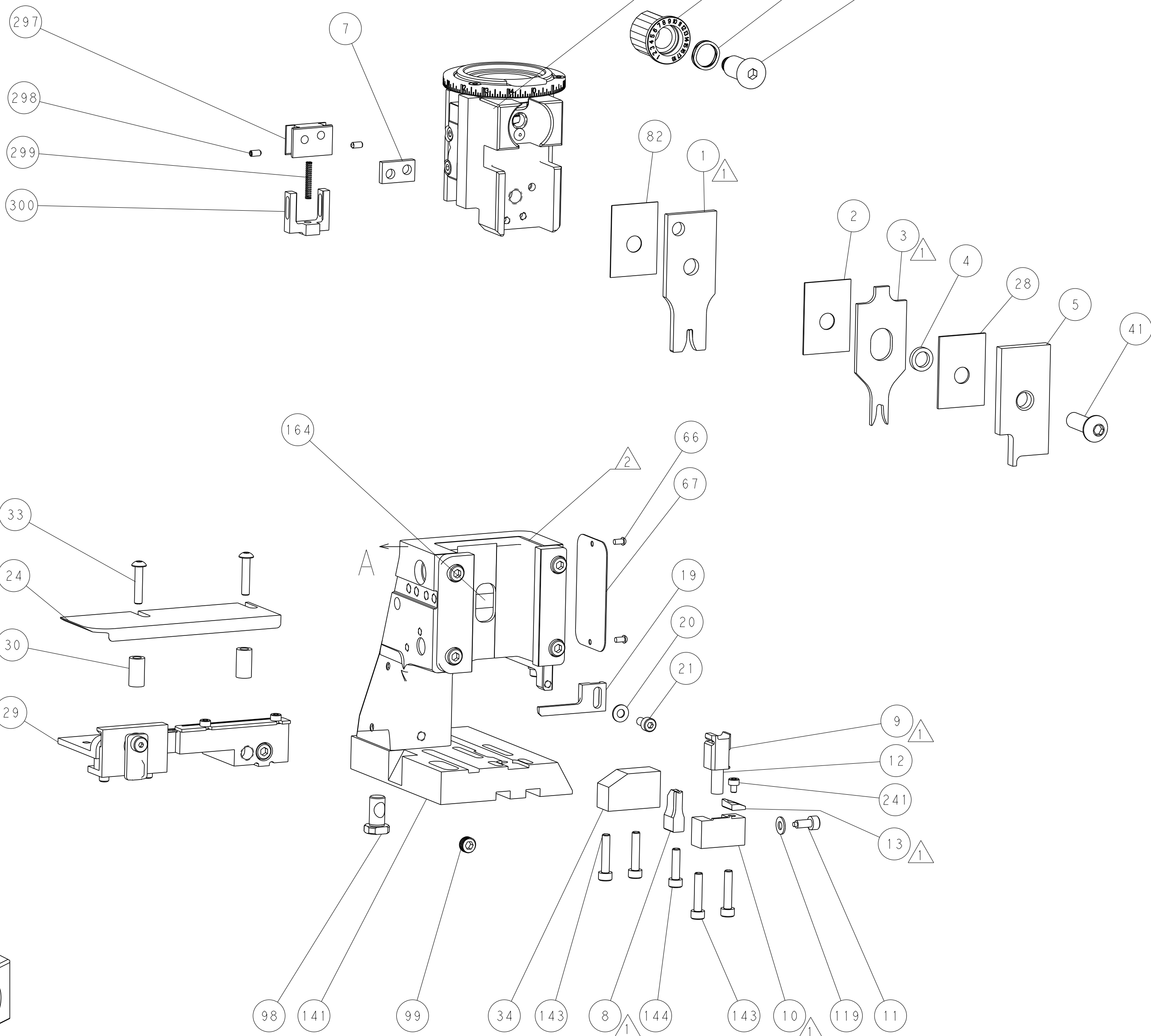
MECHANICAL
POST FEED



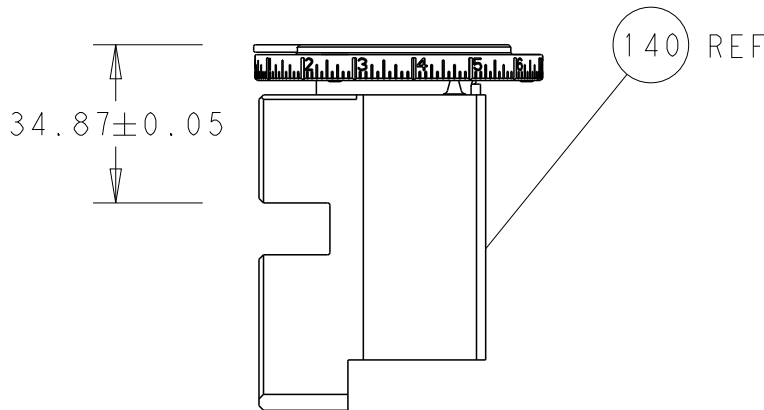
MECHANICAL
PRE FEED



AIR FEED

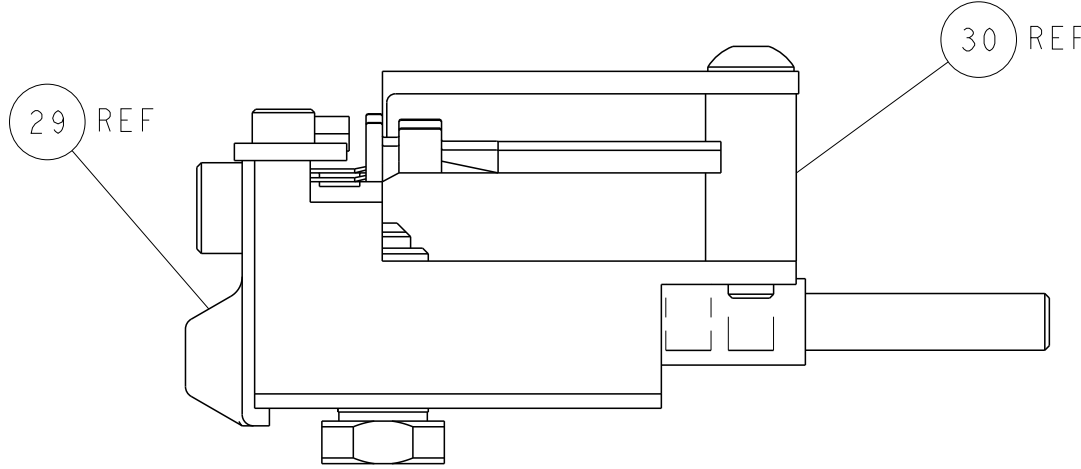


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
REAR 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)

NOT SCALE: IT IS CONTAINED DOCUMENT FOR 40% ELECTRICALS ADAPTATION ONLY. IT IS NOT TO BE USED FOR CONSTRUCTION OF CONTRACTS FOR THE BEST REASON.				DWN L. ZHANG 24JAN2013		 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK L. ZHANG 24JAN2013		NAME			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION