

| WIRE<br>SIZE |  | CRIMP HEIGHT<br>mm [INCH]    |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|--------------|-------------------------------------------------------------------------------------|------------------------------|-------------------------------------------------------------------------------------|-----------------------------------|
| 1.00mm2      |                                                                                     | 1.43+/- 0.05 [0.056+/- .002] |                                                                                     | 4.8                               |
| 0.75mm2      |                                                                                     | 1.33+/- 0.05 [0.052+/- .002] |                                                                                     | 5.9                               |
| 0.50mm2      |                                                                                     | 1.23+/- 0.05 [0.048+/- .002] |                                                                                     | 7.0                               |



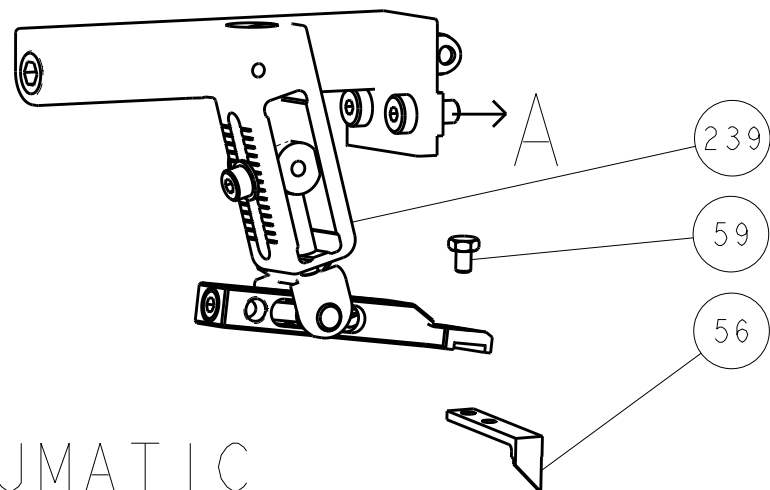
|   |   |     |     |     |     |             |                                     |     |
|---|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
|   | - | 1   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
|   | - | 1   | 1   | 1   | 1   | 2119082-8   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
|   | - | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| 3 | - | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
|   | - | 1   | 1   | 1   | 1   | 18023-1     | SCR, SKT HD CAP M3 X 5.0            | 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   | 455888-4    | SPACER, CRIMPER                     | 122 |
|   | - | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| 5 | - | 1   | 1   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113 |
|   | - | 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   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
|   | - | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
|   | - | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69  |
|   | - | 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   | 2-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 18      | 53  |
|   | - | 1   | 1   | 1   | 1   | 1803382-6   | HOLD DOWN, SPRING LOADED            | 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   | 1-1752356-3 | SUPPORT, TERMINAL                   | 34  |
|   | - | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
|   | - | 2   | 2   | 2   | 2   | 2-2844962-8 | 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   | 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   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| 1 | - | 1   | 1   | 1   | 1   | 454276-5    | FLOATING SHEAR, FRONT               | 9   |
| 1 | 1 | 2   | 2   | 1   | 1   | 2-1333204-2 | ANVIL, COMBINATION                  | 8   |
|   | - | 1   | 1   | 1   | 1   | 7-240641-2  | SPACER                              | 7   |
|   | - | 1   | 1   | 1   | 1   | 2119757-4   | DEPRESSOR, SHEAR                    | 5   |
|   | - | 1   | 1   | 1   | 1   | 2-238011-2  | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 1 | 2   | 2   | 1   | 1   | 2-2119582-1 | CRIMPER, INSULATION F PREMIUM       | 3   |
|   | - | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2   |
| 1 | 1 | 2   | 2   | 1   | 1   | 2-456405-7  | CRIMPER, WIRE PREMIUM               | 1   |

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

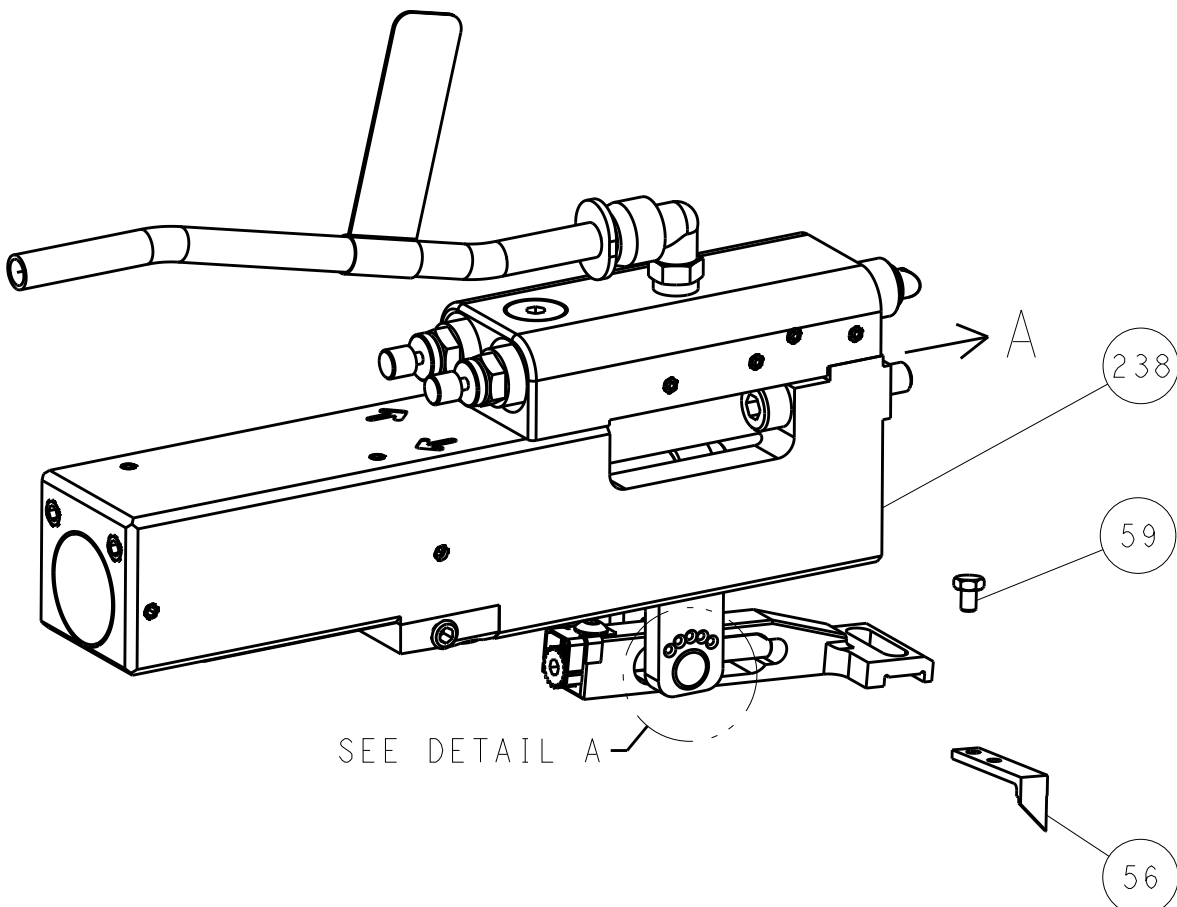
|                                                                                                                                                                      |  |  |  |                                        |  |                                                                                                                                    |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|----------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|
| <small>(NOT SCALE) IS A COMPUTER GENERATED DRAWING OF AN ELECTRICAL CONNECTION<br/>SHOWN FOR CONSTRUCTION PURPOSES ONLY. THE USER MUST VERIFY ALL DIMENSIONS</small> |  |  |  | DRAWN: MOYER 100C21011                 |  |  TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
|                                                                                                                                                                      |  |  |  | CHECKED: G. BAILEY 100C21011           |  |                                                                                                                                    |  |
| DIMENSIONS:                                                                                                                                                          |  |  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | NAME: Ocean Side Feed Applicator                                                                                                   |  |
| mm                                                                                                                                                                   |  |  |  |                                        |  | PRODUCT SPEC                                                                                                                       |  |
|                                                                                 |  |  |  | 0 PLC ±                                |  | APPLICATION SPEC                                                                                                                   |  |
|                                                                                                                                                                      |  |  |  | 1 PLC ±                                |  |                                                                                                                                    |  |
|                                                                                                                                                                      |  |  |  | 2 PLC ±                                |  |                                                                                                                                    |  |
|                                                                                                                                                                      |  |  |  | 4 PLC ±                                |  |                                                                                                                                    |  |
| ANGLES ±°                                                                                                                                                            |  |  |  |                                        |  |                                                                                                                                    |  |
| MATERIAL: -                                                                                                                                                          |  |  |  | FINISH: -                              |  | SIZE CAGE CODE DRAWING NO. RESTRICTED TO                                                                                           |  |
|                                                                                                                                                                      |  |  |  | WEIGHT: -                              |  | A   00779 C=2151276 -                                                                                                              |  |
| Customer Accessible Production Drawing                                                                                                                               |  |  |  |                                        |  | SCALE 1:2 SHEET 1 OF 4 REV E                                                                                                       |  |

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

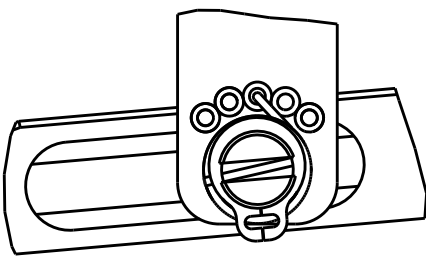
# FEED TYPE MECHANICAL



# PNEUMATIC

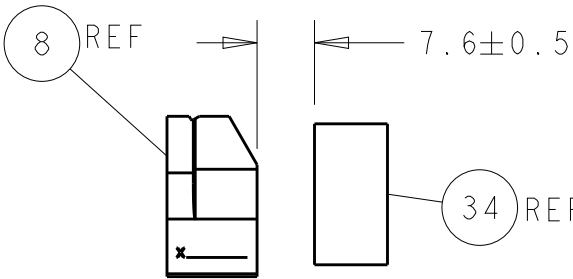
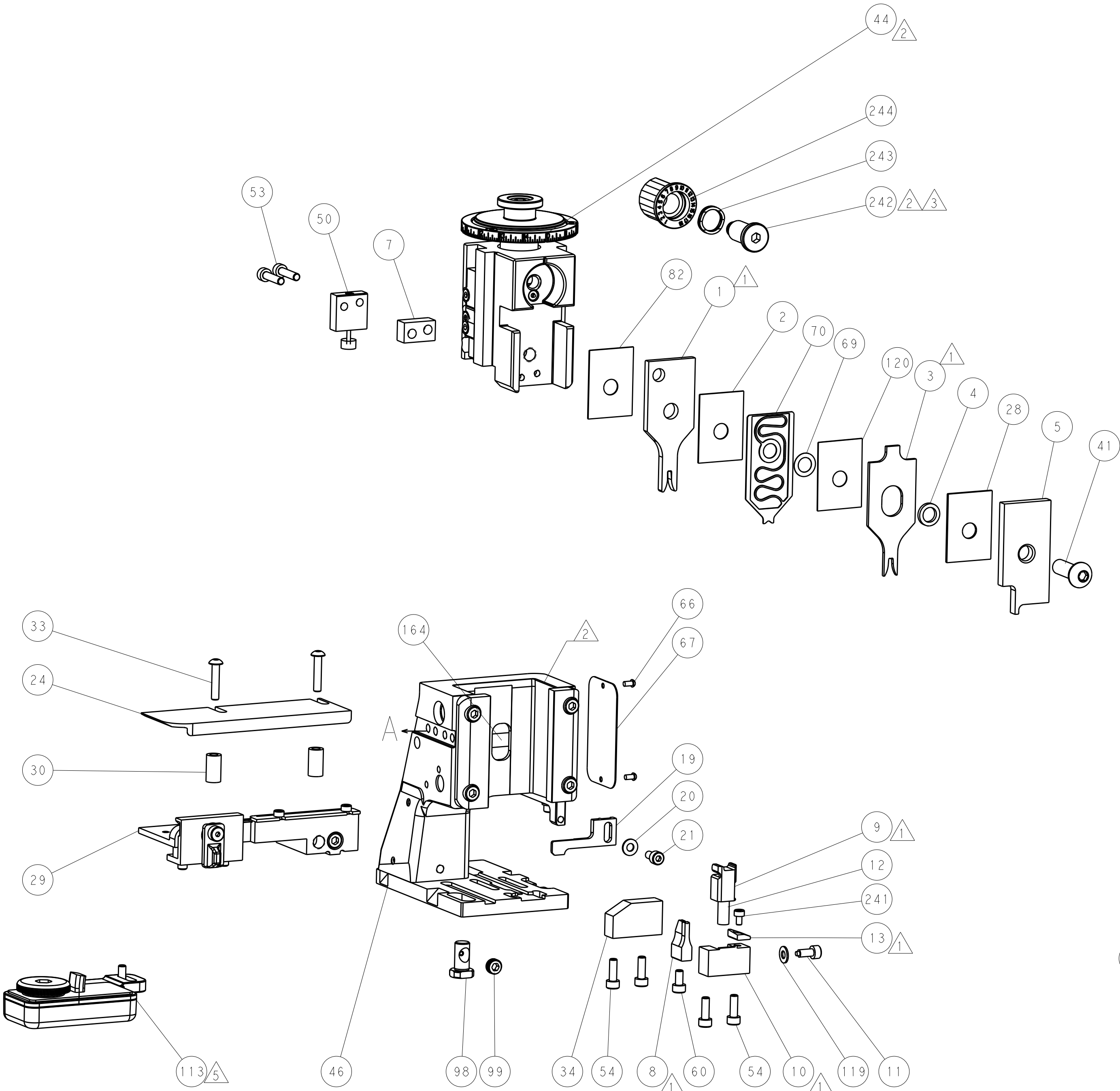
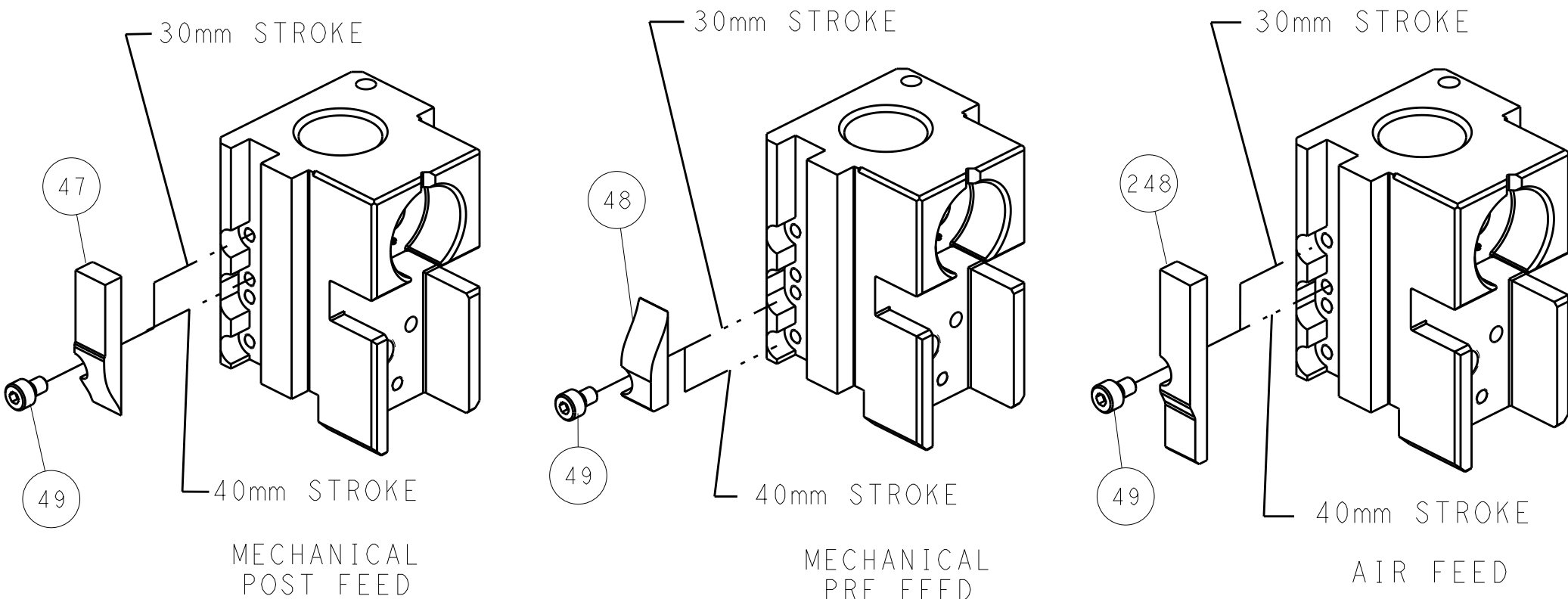


# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

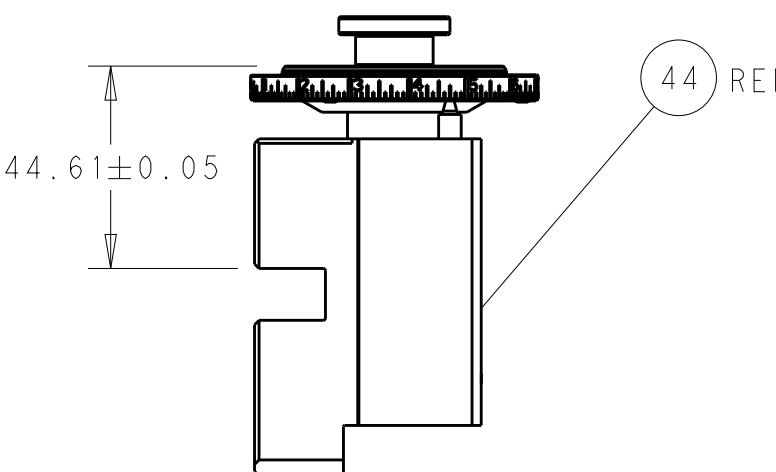


DETAIL A

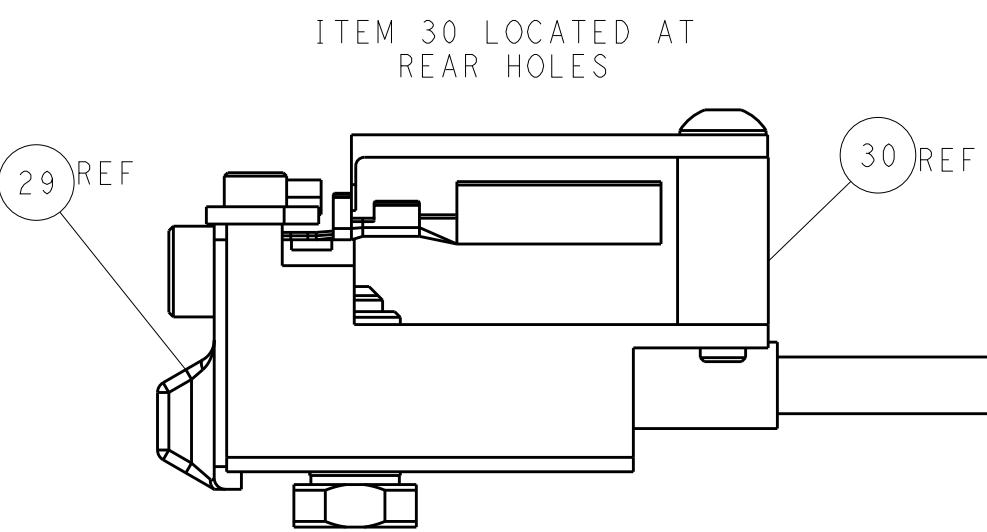
# CAM POSITIONS



TERMINAL SUPPORT LOCATION

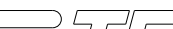


RAM SET-UP



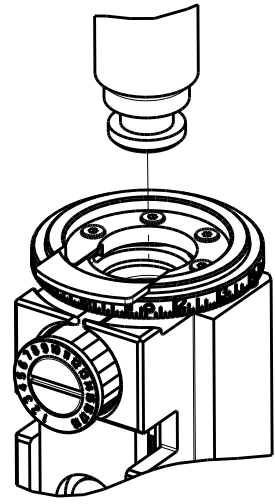
FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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

|                                                                                                                               |  |  |  |                                        |  |                                                                                                                                    |  |
|-------------------------------------------------------------------------------------------------------------------------------|--|--|--|----------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|
| (1) UNLESS NOTED OTHERWISE, DIMENSIONS ARE TO BE GIVEN IN DECIMAL INCHES, FRACTIONS OF AN INCH, OR MILLIMETERS, AS SPECIFIED. |  |  |  | DWN<br>C. MOYER 10OCT2011              |  |  TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
|                                                                                                                               |  |  |  | CHK<br>G. BAILEY 10OCT2011             |  |                                                                                                                                    |  |
| DIMENSIONS:                                                                                                                   |  |  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | NAME                                                                                                                               |  |
| mm                                                                                                                            |  |  |  |                                        |  | Ocean Side Feed<br>Applicator                                                                                                      |  |
|                                          |  |  |  |                                        |  | PRODUCT SPEC                                                                                                                       |  |
|                                                                                                                               |  |  |  |                                        |  | APPLICATION SPEC                                                                                                                   |  |
| MATERIAL                                                                                                                      |  |  |  | FINISH                                 |  | SIZE                                                                                                                               |  |
| -                                                                                                                             |  |  |  | -                                      |  | A   00779 C=2151276                                                                                                                |  |
|                                                                                                                               |  |  |  |                                        |  | RESTRICTED TO                                                                                                                      |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  | -                                                                                                                                  |  |
|                                                                                                                               |  |  |  |                                        |  |                                                                                                                                    |  |

|                                                                      |          |                          |            |
|----------------------------------------------------------------------|----------|--------------------------|------------|
| 8                                                                    |          | 7                        |            |
| THIS DRAWING IS UNPUBLISHED.                                         |          | RELEASED FOR PUBLICATION |            |
| 20                                                                   |          | 20                       |            |
| © COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. |          |                          |            |
| PART NUMBER                                                          | REVISION | DESCRIPTION              | FEED TYPE  |
| 2-2151276-1                                                          | D        | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151276-2                                                          | E        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC  |
| 7-2151276-7                                                          | A        | CRIMP TOOLING KIT        | -          |

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.03 mm [.080] | F    |
| INSUL                                | 2.79 mm [.110] | F    |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                |      |

|                                                                                                     |                                                                                                               |                                                                                     |                                                                                                                    |
|-----------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                          |                                                                                                               | TE CRIMP SPECIFICATION                                                              |                                                                                                                    |
| TERMINAL NAME: 2.5 MM SYST CONTACT PIN                                                              |                                                                                                               |                                                                                     |                                                                                                                    |
| WIRE STRIP LENGTH<br>5.20-5.80 mm [.205-.228 IN]                                                    |                                                                                                               |    | INSULATION DIAMETER RANGE<br>Ø1.40-2.30 mm [.055-.091 IN]                                                          |
| TERMINAL APPLICATION SPECIFICATION                                                                  |                                                                                                               | 114-18031-1                                                                         |                                                                                                                    |
| TERMINALS APPLIED  |                                                                                                               |                                                                                     |                                                                                                                    |
| TE TERMINAL                                                                                         | TE TERMINAL                                                                                                   | TE TERMINAL                                                                         | TE TERMINAL                                                                                                        |
| 927784-2                                                                                            | 927786-2                                                                                                      | 2-927786-3                                                                          | 927798-2                                                                                                           |
| 927784-3                                                                                            | 927786-3                                                                                                      | 927796-2                                                                            | 927798-3                                                                                                           |
| 927784-4                                                                                            | 927786-4                                                                                                      | 927796-4                                                                            | 927798-4                                                                                                           |
| 927784-5                                                                                            | 2-927786-2                                                                                                    | 927796-5                                                                            |                                                                                                                    |
| WIRE SIZE                                                                                           |  CRIMP HEIGHT<br>mm [INCH] |  | CRIMP HEIGHT REFERENCE SETTING  |
| 1.00mm2                                                                                             | 1.43+/- 0.05 [.056+/- .002]                                                                                   |                                                                                     | 4.8                                                                                                                |
| 0.75mm2                                                                                             | 1.33+/- 0.05 [.052+/- .002]                                                                                   |                                                                                     | 5.9                                                                                                                |
| 0.50mm2                                                                                             | 1.23+/- 0.05 [.048+/- .002]                                                                                   |                                                                                     | 7.0                                                                                                                |



- 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 LUBRICANT IS RECOMMENDED.
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.

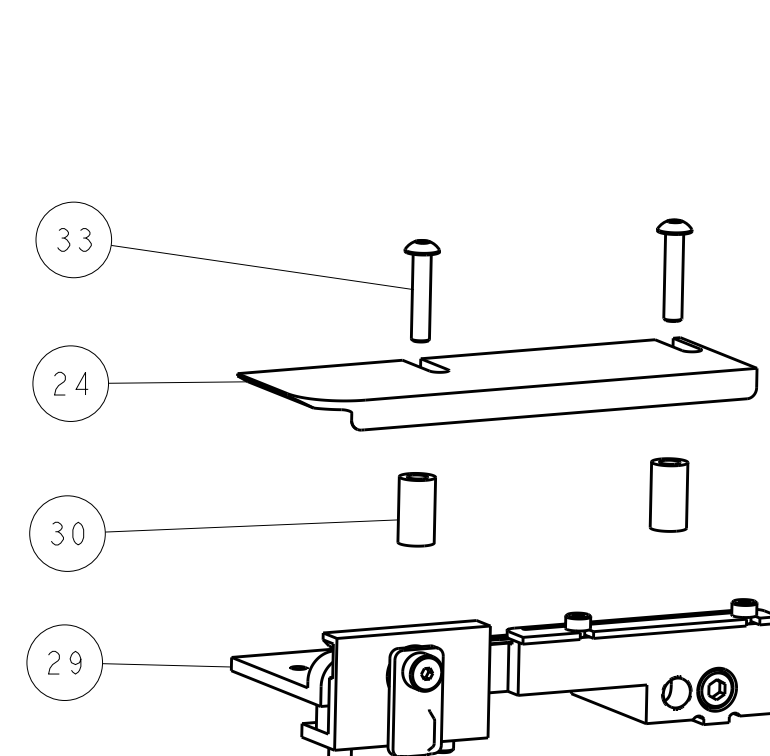
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

| LOC | DIST | REVISIONS |     |             |      |     |
|-----|------|-----------|-----|-------------|------|-----|
|     |      | P         | LTR | DESCRIPTION | DATE | OWN |
| A   | 66   | -         | -   | SEE SHEET 1 | -    | -   |
|     |      |           |     |             |      |     |
|     |      |           |     |             |      |     |

|     |     |     |             |                                     |         |
|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 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   | 18023-1     | SCR, SKT HD CAP M3 X 5.0            | 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   | 455888-4    | SPACER, CRIMPER                     | 120     |
| -   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
| -   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113     |
| -   | 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   | 2119791-5   | DEPRESSOR, WIRE                     | 70      |
| -   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69      |
| -   | 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   | 2-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 18      | 53      |
| -   | 1   | 1   | 1803382-6   | HOLD DOWN, SPRING LOADED            | 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   | 1-1752356-3 | 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   | 454276-5    | FLOATING SHEAR, FRONT               | 9       |
| 1   | 1   | 1   | 2-1333204-2 | ANVIL, COMBINATION                  | 8       |
| -   | 1   | 1   | 7-240641-2  | SPACER                              | 7       |
| -   | 1   | 1   | 2119757-4   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 2-238011-2  | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 2-2119582-1 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2       |
| 1   | 1   | 1   | 2-456405-7  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -22 | -21 | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                                            |  |                                                          |                                     |                                              |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------------------------|-------------------------------------|----------------------------------------------|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY ORGANIZATION THAT IS SUBJECT TO CHANGE WITHOUT NOTICE SHOULD BE CONTACTED FOR THE LATEST EDITION. |  | OWN<br>G. MOYER<br>CHK<br>G. BAILEY<br>APVD<br>G. BAILEY | 10OCT2011<br>10OCT2011<br>10OCT2011 | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:<br>mm                                                                                                                                                          |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                   |                                     | NAME<br>Ocean Side Feed<br>Applicator        |  |
| 0 PLC<br>1 PLC<br>2 PLC<br>3 PLC<br>4 PLC<br>ANGLES                                                                                                                        |  | ±<br>±<br>±<br>±<br>±<br>±                               |                                     | PRODUCT SPEC                                 |  |
| MATERIAL                                                                                                                                                                   |  | FINISH                                                   |                                     | APPLICATION SPEC                             |  |
| -                                                                                                                                                                          |  | -                                                        |                                     | WEIGHT                                       |  |
| -                                                                                                                                                                          |  | -                                                        |                                     | Customer Accessible Production Drawing       |  |
| -                                                                                                                                                                          |  | -                                                        |                                     | SCALE 1:2                                    |  |
| -                                                                                                                                                                          |  | -                                                        |                                     | SHEET 3 OF 4                                 |  |
| -                                                                                                                                                                          |  | -                                                        |                                     | REV E                                        |  |

Diagram illustrating the front view of the machine, showing the front plate (56) and the front plate screw (59). The front plate screw cap (239) is also shown.



30mm STROKE

1.42

49

MECHANICAL POST FEED

30mm STROKE

48

49

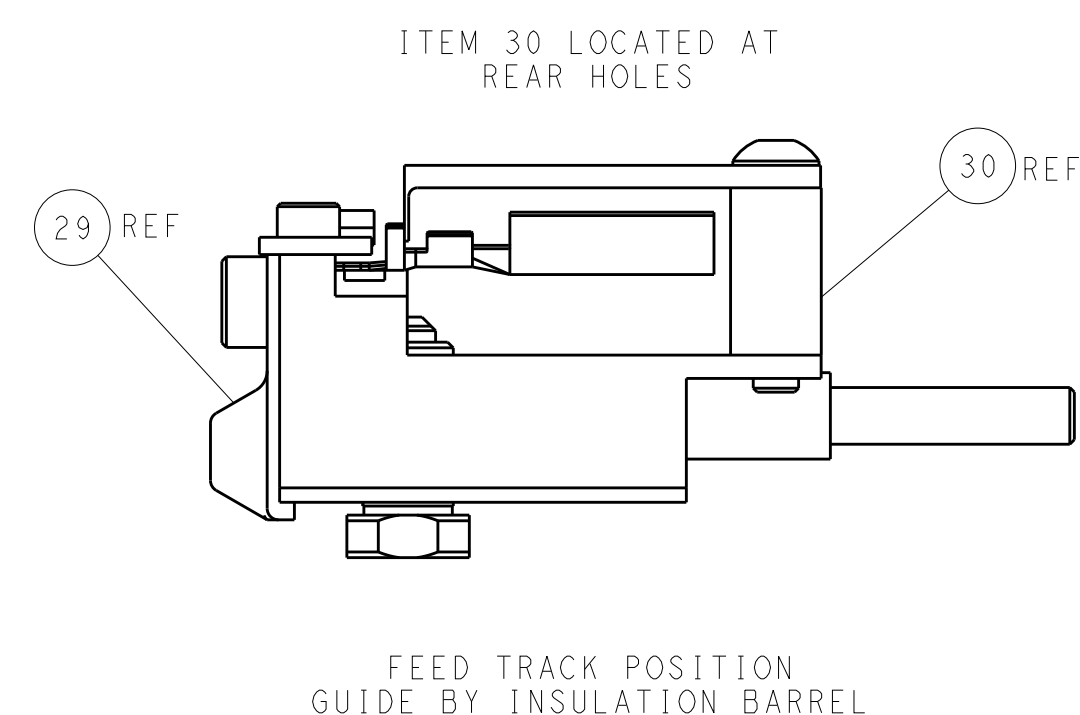
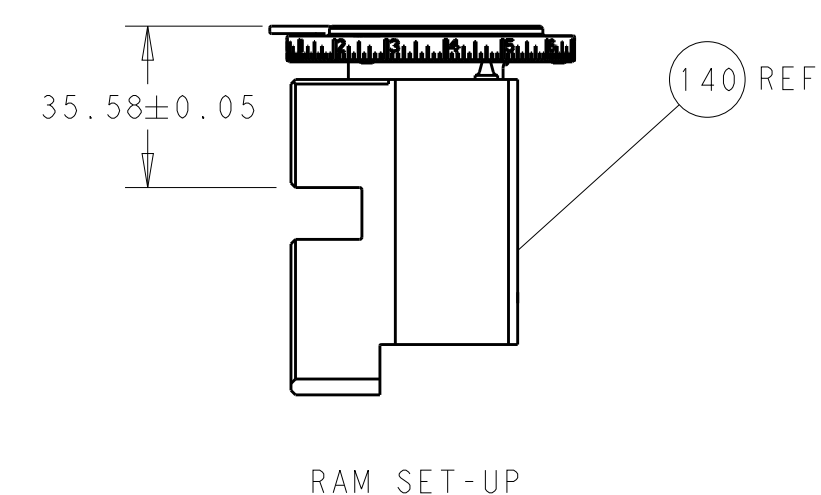
MECHANICAL PRE FEED

30mm STROKE

151

49

AIR FEED

[illegible]

|                                                                                                                                                                                                |             |                                                      |                         |                            |                                                     |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|------------------------------------------------------|-------------------------|----------------------------|-----------------------------------------------------|
| THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION<br>IT IS SUBJECT TO THE PROPERTIES OF THE MATERIALS AND THE ORGANIZATION<br>SHOULD BE CONTACTED FOR THE LATEST REVISION. |             | DWG<br><b>C MOYER</b>                                | 100C12011               |                            |                                                     |
|                                                                                                                                                                                                |             | CHK<br><b>G BAILEY</b>                               | 100CT2011               |                            |                                                     |
| DIMENSIONS:<br>mm                                                                                                                                                                              |             | TOLERANCES UNLESS OTHERWISE SPECIFIED:               | APVD<br><b>G BAILEY</b> | NAME                       | <b>TE Connectivity</b><br>Harrisburg, PA 17105-3608 |
|                                                                                                           |             | 0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>4 PLC ±<br>ANGLES ± | PRODUCT SPEC<br>-       | Ocean Side Feed Applicator | -                                                   |
| MATERIAL<br>-                                                                                                                                                                                  | FINISH<br>- | WEIGHT<br>-                                          | SIZE<br><b>A1</b>       | CAGE CODE<br><b>00779</b>  | DRAWING NO.<br><b>C2151276</b>                      |
| Customer Accessible Production Drawing                                                                                                                                                         |             |                                                      | SCALE<br>1:1            | SHEET<br>4                 | OF<br>4 REV<br>F                                    |