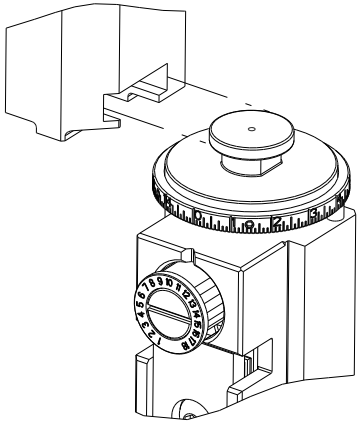


|                                                                      |          |                                  |            |
|----------------------------------------------------------------------|----------|----------------------------------|------------|
| 8                                                                    |          | 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| THIS DRAWING IS UNPUBLISHED.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  |
| 2151835-1                                                            | D        | FINE CRIMP HEIGHT ADJUST         | MECHANICAL |
| 2151835-2                                                            | E        | FINE CRIMP HEIGHT ADJUST         | PNEUMATIC  |
| 7-2151835-1                                                          | D        | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2151835-2                                                          | E        | PNEUMATIC AND CRIMP TOOLING KIT  | PNEUMATIC  |
| 7-2151835-7                                                          | B        | CRIMP TOOLING KIT                | -          |

ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.40 mm [.055] | F    |
| INSUL                                | 1.78 mm [.070] | O    |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                |      |

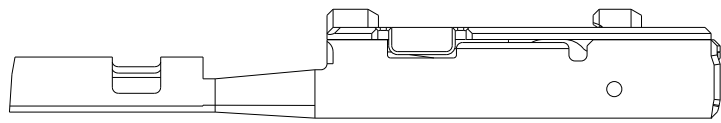
|                                                                                                     |             |                                                                                   |                                                           |
|-----------------------------------------------------------------------------------------------------|-------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                          |             | TE CRIMP SPECIFICATION                                                            |                                                           |
| TERMINAL NAME: RECEPTACLE CONTACT, Au, SEALED TYPE, 0.5 SERIES                                      |             |                                                                                   |                                                           |
| WIRE STRIP LENGTH<br>4.80-5.30 mm [.189-.209 IN]                                                    |             |  | INSULATION DIAMETER RANGE<br>Ø1.40-1.70 mm [.055-.067 IN] |
| TERMINAL APPLICATION SPECIFICATION<br>114-5400                                                      |             | -                                                                                 | -                                                         |
|                    |             | -                                                                                 | -                                                         |
| TERMINALS APPLIED  |             |                                                                                   |                                                           |
| TE TERMINAL                                                                                         | TE TERMINAL | TE TERMINAL                                                                       | TE TERMINAL                                               |
| 1939349-1                                                                                           |             |                                                                                   |                                                           |

|           |                            |                                |
|-----------|----------------------------|--------------------------------|
| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
| 0.50mm2   | 0.88+/-0.03 [.035+/- .001] | 8.6                            |
| 0.30mm2   | 0.79+/-0.03 [.031+/- .001] | 9.6                            |



- 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 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
- 6 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

\*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.



BARREL FRONT  
POINT HEIGHT  
1.09 MAX

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

| LOC | DIST | REVISIONS |     |               |           |     |
|-----|------|-----------|-----|---------------|-----------|-----|
|     |      | P         | LTR | DESCRIPTION   | DATE      | DWN |
| A   | 66   |           | B4  | ECR-16-005380 | 13APR2016 | JH  |
|     |      |           | C   | ECR-18-008456 | 01JUN2018 | VLA |
|     |      |           | D   | ECR-18-013225 | 20AUG2018 | FZ  |
|     |      |           | E   | ECR-22-138021 | 05MAY2022 | FJ  |

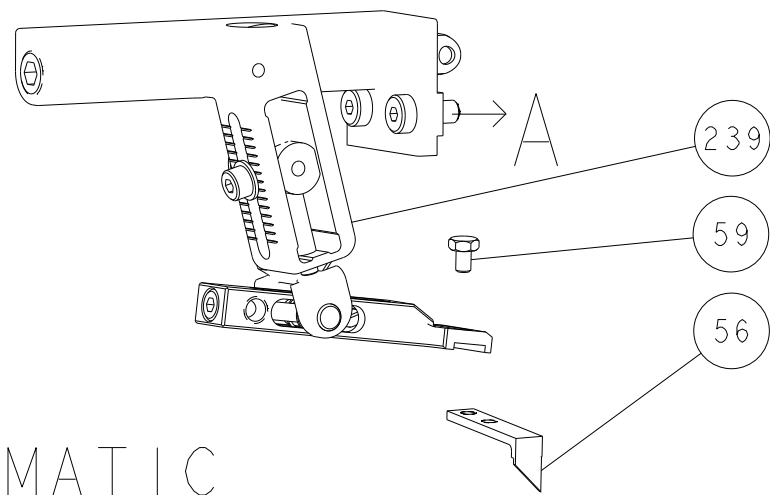
|   |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
| - | 1   | 1   | 1   | 1   | 2119082-9   | 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   | 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   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| - | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 60  |
| - | 1   | 1   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | 1   | 1   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 4   | 4   | 4   | 4   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 54  |
| - | 2   | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53  |
| - | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
| - | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
| - | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 50  |
| - | 1   | 2   | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | -   | 1   | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48  |
| - | -   | 1   | -   | 1   | 2119653-1   | FEED CAM, POST FEED                 | 47  |
| - | 1   | 1   | 1   | 1   | 1803583-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46  |
| - | 1   | 1   | 1   | 1   | 1803515-1   | RAM ASSEMBLY, SF ATLANTIC           | 44  |
| - | 1   | 1   | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | 1   | 1   | 1   | 1752356-3   | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 2   | 2   | 2   | 2   | 2-2844962-4 | 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   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1   | 1   | 1803095-1   | FLOATING SHEAR, FRONT               | 9   |
| 1 | 2   | 2   | 1   | 1   | 2-1633917-8 | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 238011-4    | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 2   | 2   | 1   | 1   | 1633965-8   | CRIMPER, INSULATION O PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2   |
| 1 | 2   | 2   | 1   | 1   | 1803179-2   | CRIMPER, WIRE PREMIUM               | 1   |

|                                                                                                                            |  |                                                     |                                     |                                                  |
|----------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------|-------------------------------------|--------------------------------------------------|
| THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHOULD BE CONTACTED FOR THE LATEST EDITION. |  | DWN<br>L. ZHANG<br>CHK<br>L. ZHANG<br>APVD<br>S. XI | 20NOV2012<br>20NOV2012<br>20NOV2012 | 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>FINISH                                                              |  | ±<br>±<br>±<br>±<br>±<br>±                          |                                     | SIZE<br>CAGE CODE<br>DRAWING NO<br>RESTRICTED TO |
| MATERIAL<br>-                                                                                                              |  | WEIGHT<br>-                                         |                                     | 100779<br>C=2151835                              |
| Customer Accessible Production Drawing                                                                                     |  | SCALE<br>8:1                                        |                                     | SHEET<br>1 OF 4<br>REV<br>E                      |

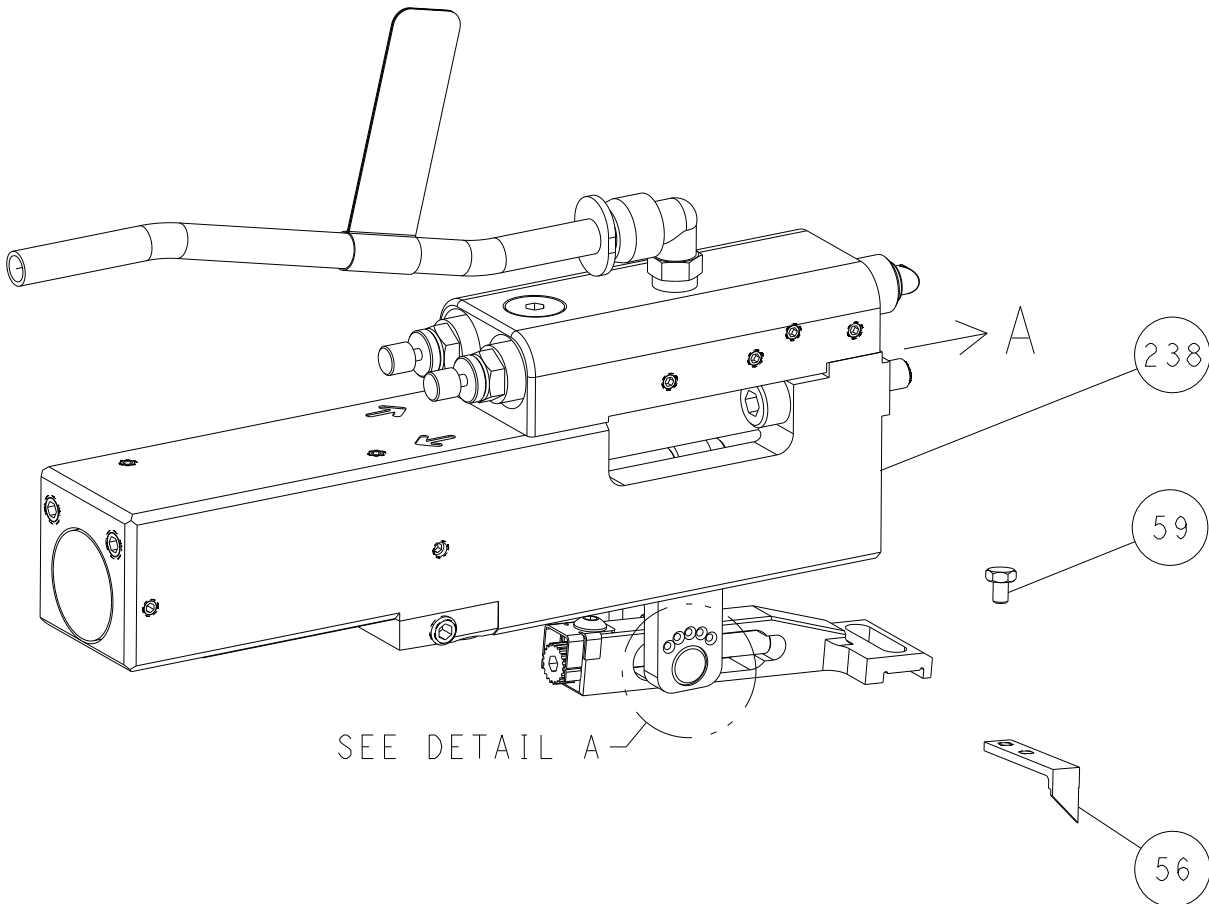
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

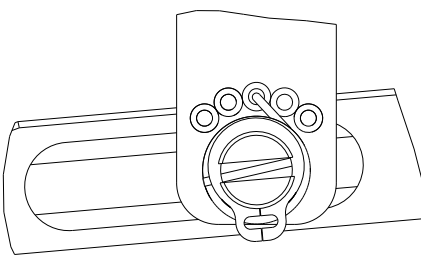
# FEED TYPE MECHANICAL



# PNEUMATIC

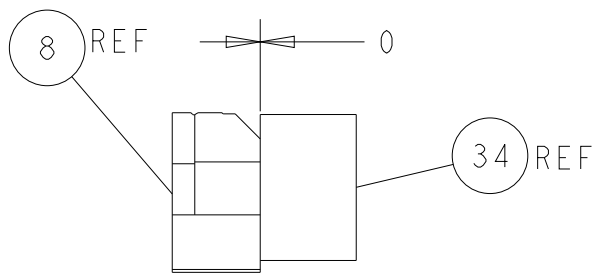
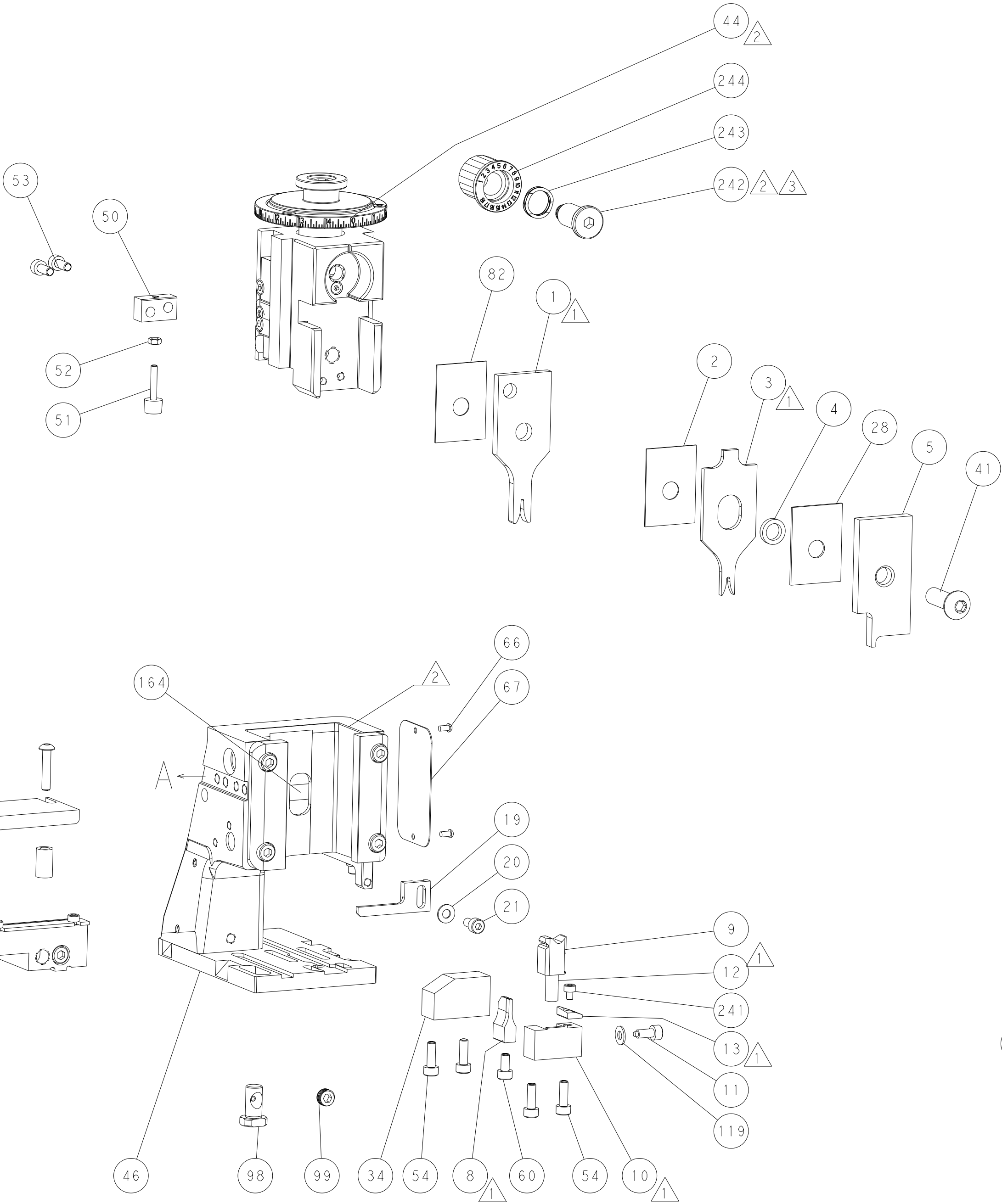
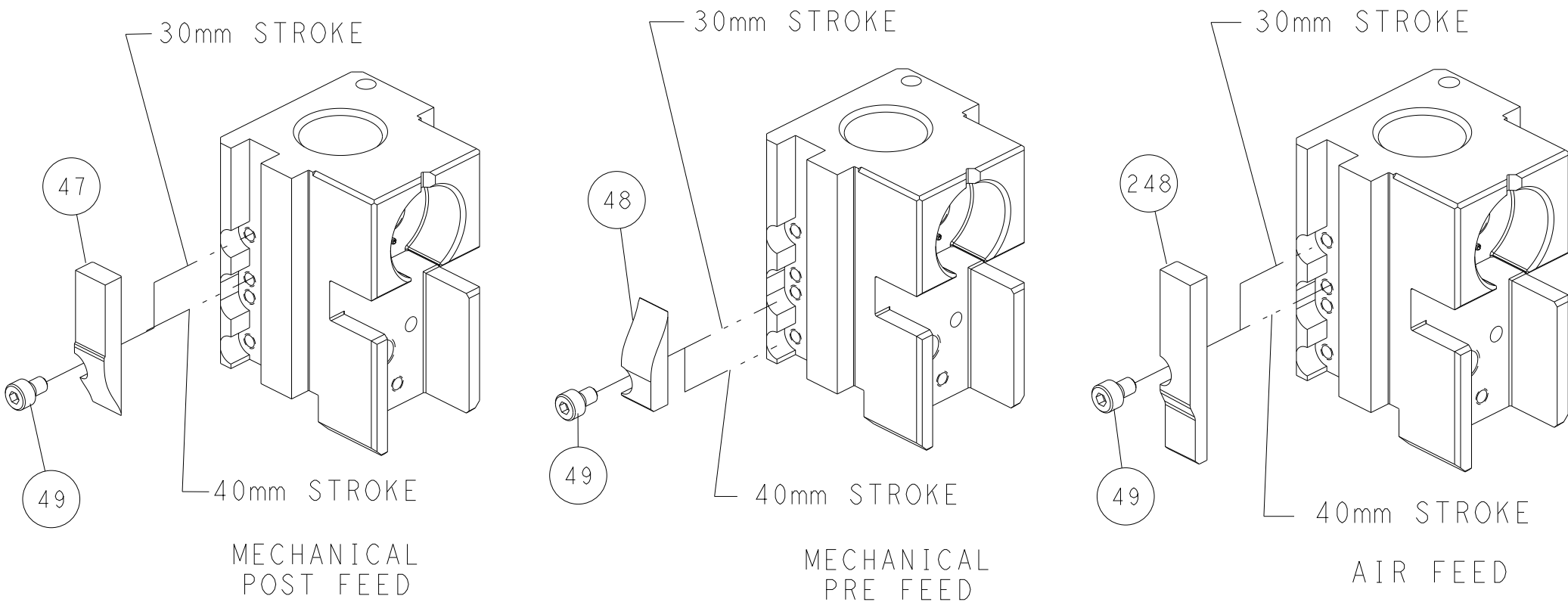


# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

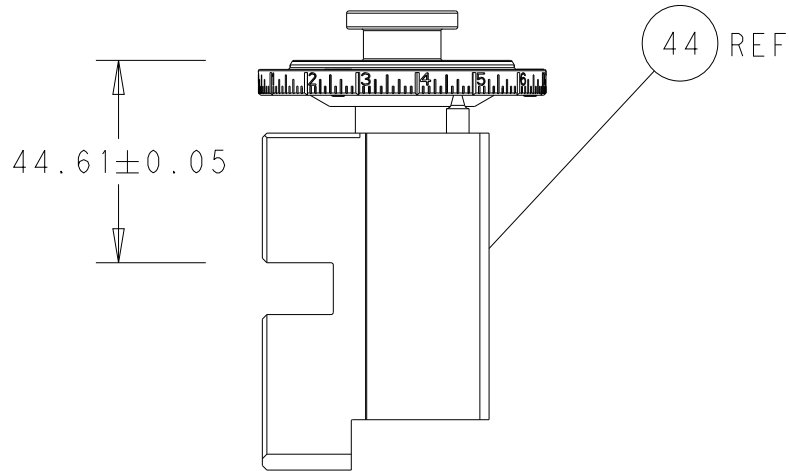


DETAIL A

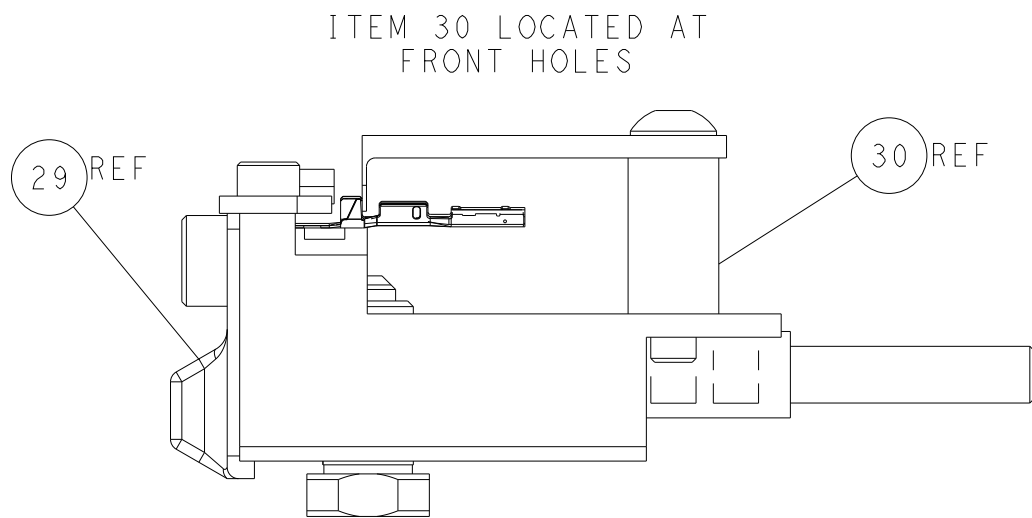
# CAM POSITIONS



TERMINAL SUPPORT LOCATION

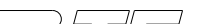


RAM SET-UP



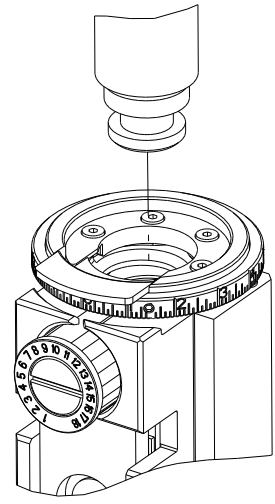
FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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

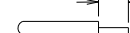
|                                                                                                                                                                                        |  |  |  |                                        |          |           |                                                                                                                                    |  |           |            |               |     |       |   |    |   |     |   |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|----------------------------------------|----------|-----------|------------------------------------------------------------------------------------------------------------------------------------|--|-----------|------------|---------------|-----|-------|---|----|---|-----|---|
| THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION.<br>IT IS SUBJECT TO COMPANY CONTROL AND INSPECTING ORGANIZATION<br>SHOULD BE CONTACTED FOR THE LATEST VERSION. |  |  |  | DWN                                    | L. ZHANG | 20NOV2012 |  TE Connectivity<br>Harrisburg, PA 17105-3608 |  |           |            |               |     |       |   |    |   |     |   |
|                                                                                                                                                                                        |  |  |  | CHK                                    | L. ZHANG | 20NOV2012 |                                                                                                                                    |  |           |            |               |     |       |   |    |   |     |   |
|                                                                                                                                                                                        |  |  |  | APVD                                   | S. XI    | 20NOV2012 | NAME                                                                                                                               |  |           |            |               |     |       |   |    |   |     |   |
|                                                                                                                                                                                        |  |  |  | PRODUCT SPEC                           |          |           | Ocean Side Feed<br>Applicator                                                                                                      |  |           |            |               |     |       |   |    |   |     |   |
|                                                                                                                                                                                        |  |  |  | APPLICATION SPEC                       |          |           |                                                                                                                                    |  |           |            |               |     |       |   |    |   |     |   |
|                                                                                                                                                                                        |  |  |  | WEIGHT                                 |          |           | SIZE                                                                                                                               |  | CAGE CODE | DRAWING NO | RESTRICTED TO |     |       |   |    |   |     |   |
|                                                                                                                                                                                        |  |  |  | -                                      |          |           | A1                                                                                                                                 |  | 00779     | C=2151835  | -             |     |       |   |    |   |     |   |
|                                                                                                                                                                                        |  |  |  | Customer Accessible Production Drawing |          |           |                                                                                                                                    |  |           |            | SCALE         | 8:1 | SHEET | 2 | OF | 4 | REV | E |

| 8                            |          | 7                                                     |            |
|------------------------------|----------|-------------------------------------------------------|------------|
| THIS DRAWING IS UNPUBLISHED. |          | RELEASED FOR PUBLICATION                              |            |
| © COPYRIGHT 20               |          | BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. |            |
| PART NUMBER                  | REVISION | DESCRIPTION                                           | FEED TYPE  |
| 2-2151835-1                  | D        | FINE CRIMP HEIGHT ADJUST                              | MECHANICAL |
| 2-2151835-2                  | E        | FINE CRIMP HEIGHT ADJUST                              | PNEUMATIC  |
| 7-2151835-7                  | B        | CRIMP TOOLING KIT                                     | -          |

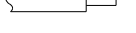
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.40 mm [.055] | F    |
| INSUL                                | 1.78 mm [.070] | O    |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                |      |

|                                                                                                     |             |                                                                                   |                                                           |
|-----------------------------------------------------------------------------------------------------|-------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                          |             | TE CRIMP SPECIFICATION                                                            |                                                           |
| TERMINAL NAME: RECEPTACLE CONTACT, Au, SEALED TYPE, 0.5 SERIES                                      |             |                                                                                   |                                                           |
| WIRE STRIP LENGTH<br>4.80-5.30 mm [.189-.209 IN]                                                    |             |  | INSULATION DIAMETER RANGE<br>Ø1.40-1.70 mm [.055-.067 IN] |
| TERMINAL APPLICATION SPECIFICATION                                                                  | 114-5400    | -                                                                                 | -                                                         |
|                    | -           | -                                                                                 | -                                                         |
| TERMINALS APPLIED  |             |                                                                                   |                                                           |
| TE TERMINAL                                                                                         | TE TERMINAL | TE TERMINAL                                                                       | TE TERMINAL                                               |
| 1939349-1                                                                                           |             |                                                                                   |                                                           |

|                                                                                                     |                                                                                   |                                                                                    |                                                           |
|-----------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                          |                                                                                   | TE CRIMP SPECIFICATION                                                             |                                                           |
| TERMINAL NAME: RECEPTACLE CONTACT, Au, SEALED TYPE, 0.5 SERIES                                      |                                                                                   |                                                                                    |                                                           |
| WIRE STRIP LENGTH<br>4.80-5.30 mm [.189-.209 IN]                                                    |                                                                                   |  | INSULATION DIAMETER RANGE<br>Ø1.40-1.70 mm [.055-.067 IN] |
| 114-5400                                                                                            |                                                                                   | -                                                                                  | -                                                         |
| TERMINAL APPLICATION SPECIFICATION                                                                  |  | -                                                                                  | -                                                         |
| TERMINALS APPLIED  |                                                                                   |                                                                                    |                                                           |
| TE TERMINAL                                                                                         | TE TERMINAL                                                                       | TE TERMINAL                                                                        | TE TERMINAL                                               |
| (A)1939350-1                                                                                        | (B)2069401-1                                                                      |                                                                                    |                                                           |

|                                                                                                       |                                                                                     |                                                                                     |                                                           |
|-------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                            |                                                                                     | TE CRIMP SPECIFICATION                                                              |                                                           |
| TERMINAL NAME: RECEPTACLE CONTACT, Au, SEALED TYPE, 0.5 SERIES                                        |                                                                                     |                                                                                     |                                                           |
| WIRE STRIP LENGTH<br>4.80-5.30 mm [.189-.209 IN]                                                      |                                                                                     |  | INSULATION DIAMETER RANGE<br>Ø1.40-1.70 mm [.055-.067 IN] |
| TERMINAL APPLICATION SPECIFICATION                                                                    |  |  | -                                                         |
|                                                                                                       | -                                                                                   | -                                                                                   | -                                                         |
| TERMINALS APPLIED  |                                                                                     |                                                                                     |                                                           |
| TE TERMINAL                                                                                           | TE TERMINAL                                                                         | TE TERMINAL                                                                         | TE TERMINAL                                               |
| 1939349-1                                                                                             |                                                                                     |                                                                                     |                                                           |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 0.50mm2   | 0.88+/-0.03 [.035+/- .001] | 8.6                            |
| 0.30mm2   | 0.79+/-0.03 [.031+/- .001] | 9.6                            |

| WIRE SIZE  | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|------------|----------------------------|--------------------------------|
| (B)0.50mm2 | 0.91+/-0.03 [.036+/- .001] | 8.3                            |
| (A)0.30mm2 | 0.79+/-0.03 [.031+/- .001] | 9.6                            |

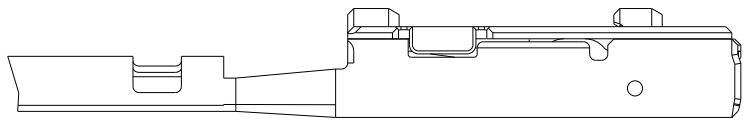
| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 0.35mm2   | 0.81+/-0.03 [.032+/- .001] | 9.4                            |
| -         | -                          | -                              |



- 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 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079(TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

7 TERMINAL LUBRICANT IS RECOMMENDED.



BARREL FRONT  
POINT HEIGHT  
1.09 MAX

\*WARNING  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

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

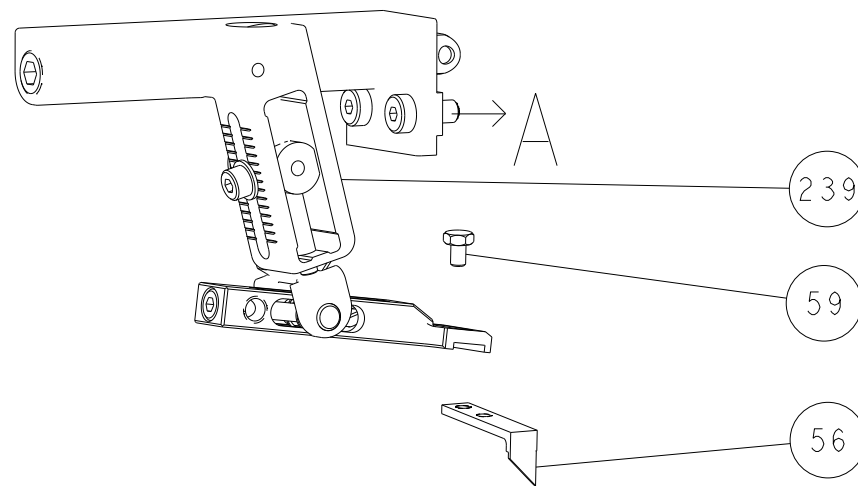
|   |     |     |             |                                     |     |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 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   | 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   | 2119740-1   | TAG,IDENTIFICATION                  | 67  |
| - | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53  |
| - | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
| - | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
| - | 1   | 1   | 690753-2    | SPACER, TONKER                      | 50  |
| - | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48  |
| - | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | 1   | 1752356-3   | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 2   | 2   | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30  |
| - | 1   | 1   | 2844992-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1803095-1   | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1-1633917-8 | ANVIL, COMBINATION                  | 8   |
| - | -   | -   | -           | -                                   | 7   |
| - | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 238011-4    | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1633965-8   | CRIMPER, INSULATION O PREMIUM       | 3   |
| - | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1803179-2   | CRIMPER, WIRE PREMIUM               | 1   |



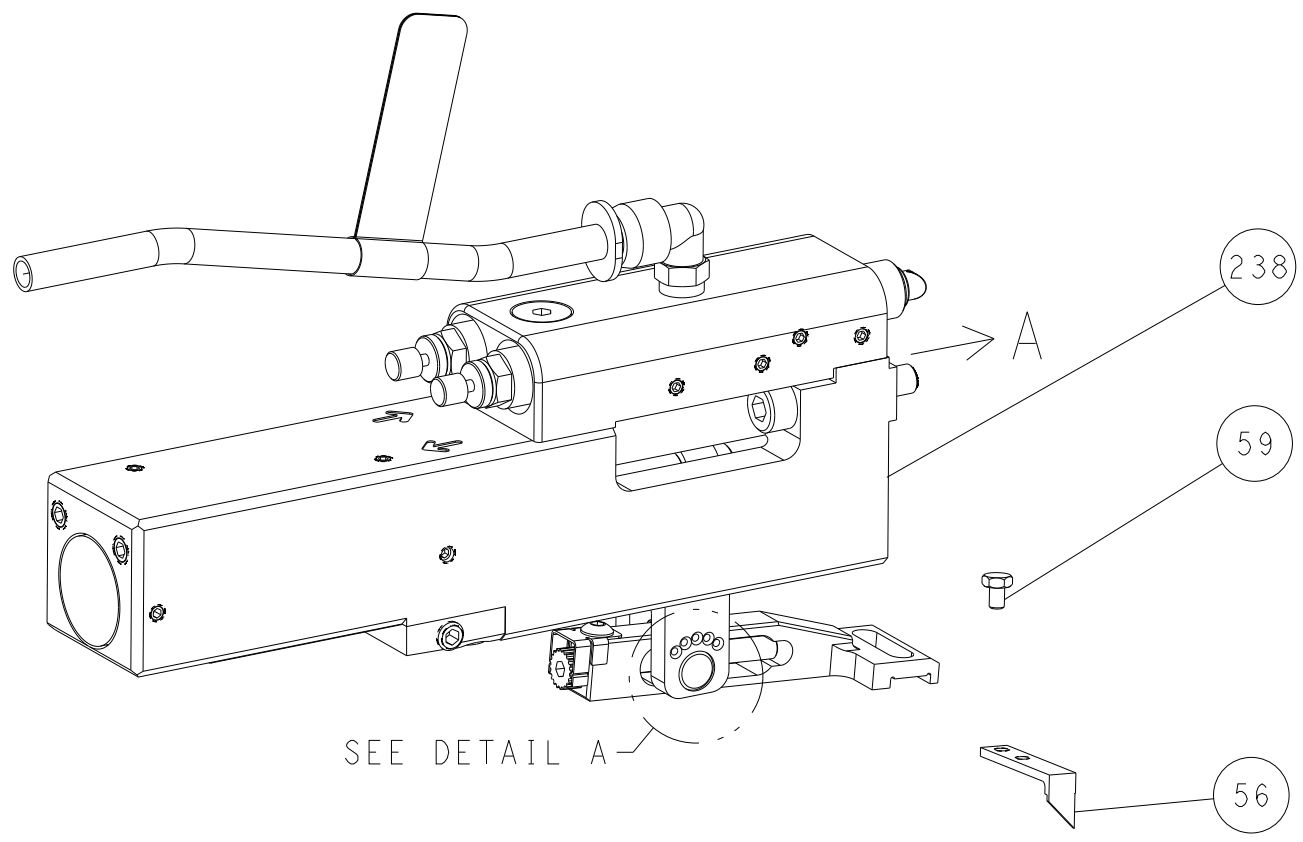
|                                                                                                                                                                                |  |                             |              |                                        |                               |            |         |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------|--------------|----------------------------------------|-------------------------------|------------|---------|
| THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE CUSTOMER'S INFORMATION. IT IS SUBJECT TO CONTROLLED DOCUMENT MANAGEMENT ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION. |  | DWN<br>L.ZHANG<br>20NOV2012 | PART NO      |                                        | DESCRIPTION                   |            | ITEM NO |
| DIMENSIONS:                                                                                                                                                                    |  | CHK<br>L.ZHANG<br>20NOV2012 | NAME         |                                        | Ocean Side Feed<br>Applicator |            |         |
| mm                                                                                                                                                                             |  | APVD<br>S.XI<br>20NOV2012   | PRODUCT SPEC |                                        | SIZE                          |            |         |
|                                                                                                                                                                                |  | APPLICATION SPEC            |              | CAGE CODE                              |                               | DRAWING NO |         |
|                                                                                                                                                                                |  |                             |              | 00779                                  |                               | 2151835    |         |
| MATERIAL                                                                                                                                                                       |  | WEIGHT                      |              | RESTRICTED TO                          |                               |            |         |
|                                                                                                                                                                                |  |                             |              | Customer Accessible Production Drawing |                               | SCALE      |         |
|                                                                                                                                                                                |  |                             |              | 8:1                                    |                               | SHEET      |         |
|                                                                                                                                                                                |  |                             |              | 3                                      |                               | OF         |         |
|                                                                                                                                                                                |  |                             |              | 4                                      |                               | REV        |         |
|                                                                                                                                                                                |  |                             |              |                                        |                               | E          |         |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

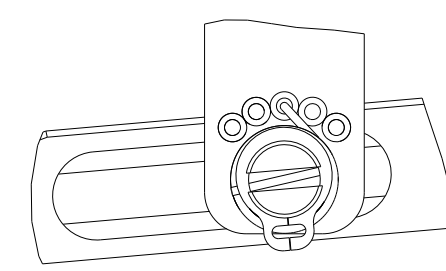
# FEED TYPE MECHANICAL



## PNEUMATIC

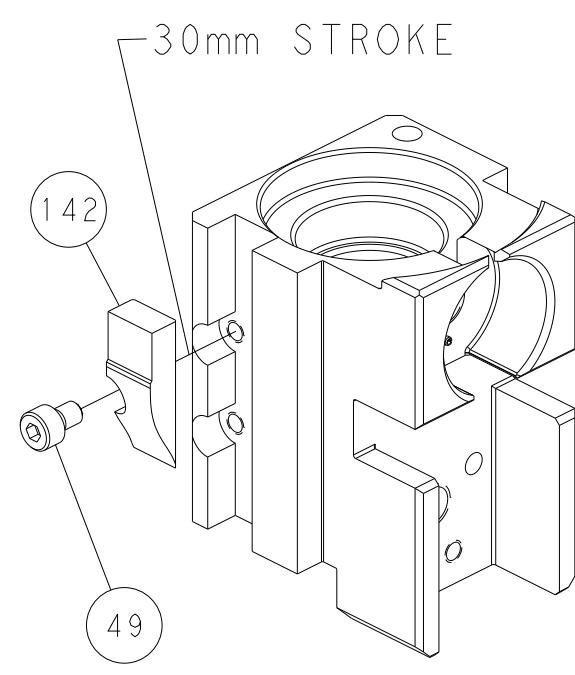


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

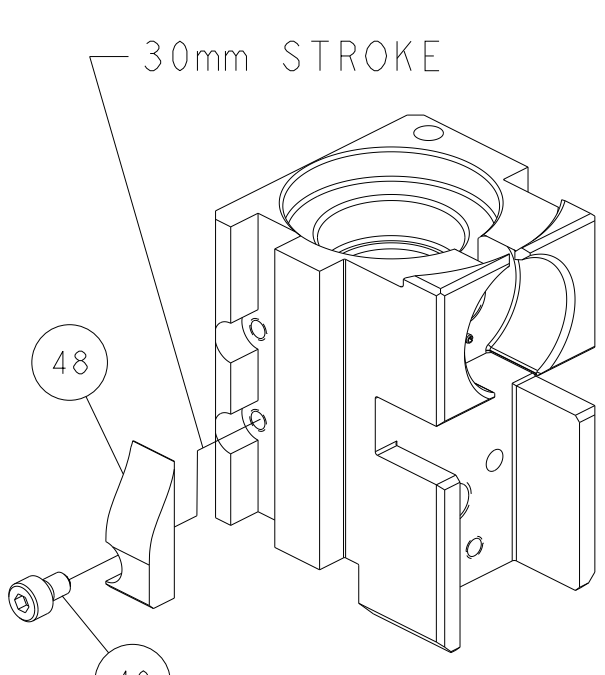


DETAIL A

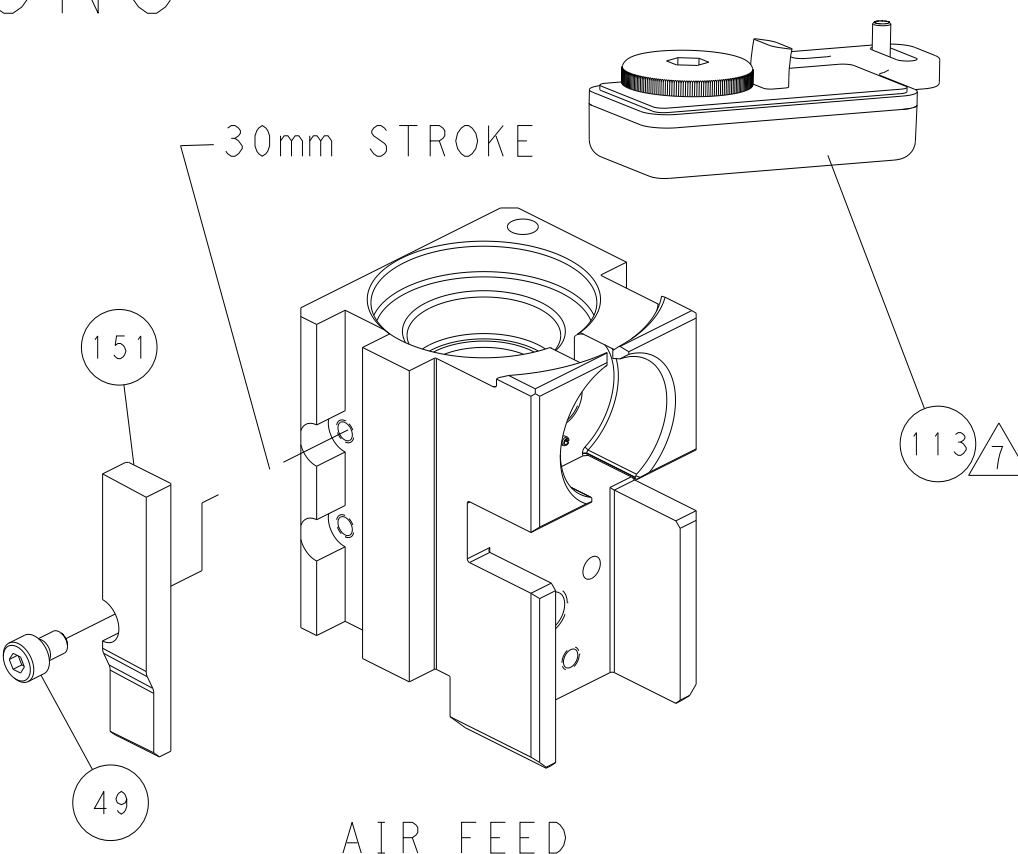
# CAM POSITIONS



MECHANICAL  
POST FEED



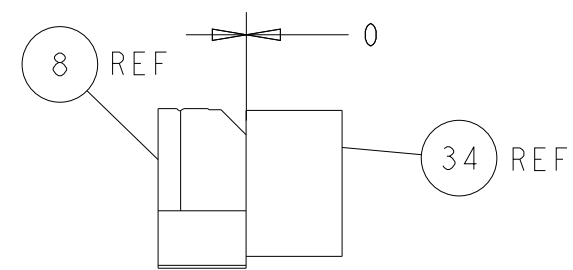
MECHANICAL  
PRE FEED



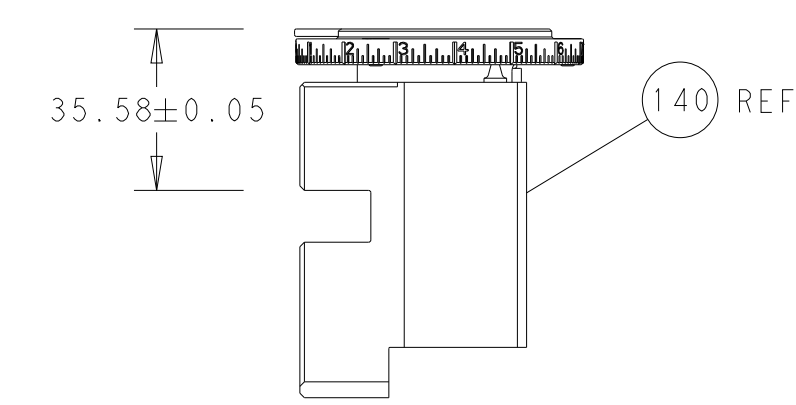
AIR FEED

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

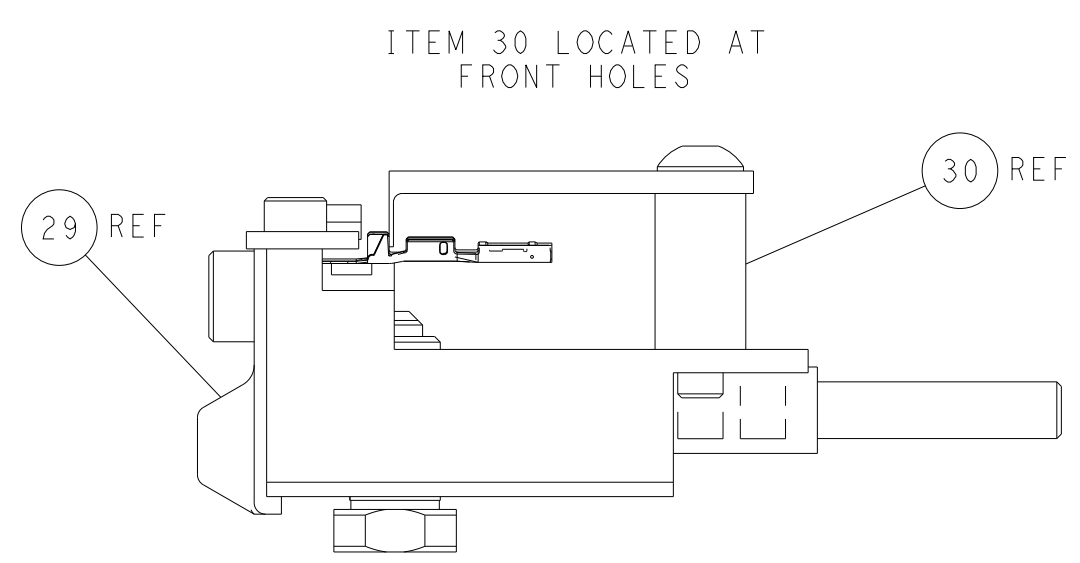
| LOC |     | DIST        |  | REVISIONS |     |      |   |
|-----|-----|-------------|--|-----------|-----|------|---|
| P   | LYR | DESCRIPTION |  | DATE      | DWN | APPD |   |
| -   | -   | SEE SHEET 1 |  | -         | -   | -    | - |
|     |     |             |  |           |     |      |   |
|     |     |             |  |           |     |      |   |



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

|                                                                                                                                                                                        |  |      |          |           |                                                  |  |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------|----------|-----------|--------------------------------------------------|--|--|
| THE DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION. |  | DWN  | L. ZHANG | 20NOV2012 | STE TE Connectivity<br>Harrisburg, PA 17105-3608 |  |  |
|                                                                                                                                                                                        |  | CHK  | L. ZHANG | 20NOV2012 |                                                  |  |  |
|                                                                                                                                                                                        |  | APVD | S. XI    | 20NOV2012 | NAME                                             |  |  |
|                                                                                                                                                                                        |  |      |          |           | Ocean Side Feed<br>Applicator                    |  |  |
|                                                                                                                                                                                        |  |      |          |           | -                                                |  |  |
|                                                                                                                                                                                        |  |      |          |           | SIZE                                             |  |  |
|                                                                                                                                                                                        |  |      |          |           | A1                                               |  |  |
|                                                                                                                                                                                        |  |      |          |           | CAGE CODE                                        |  |  |
|                                                                                                                                                                                        |  |      |          |           | 00779                                            |  |  |
|                                                                                                                                                                                        |  |      |          |           | DRAWING NO                                       |  |  |
|                                                                                                                                                                                        |  |      |          |           | C-2151835                                        |  |  |
|                                                                                                                                                                                        |  |      |          |           | RESTRICTED TO                                    |  |  |
|                                                                                                                                                                                        |  |      |          |           | -                                                |  |  |
|                                                                                                                                                                                        |  |      |          |           | Customer Accessible Production Drawing           |  |  |
|                                                                                                                                                                                        |  |      |          |           | SCALE                                            |  |  |
|                                                                                                                                                                                        |  |      |          |           | 8:1                                              |  |  |
|                                                                                                                                                                                        |  |      |          |           | SHEET                                            |  |  |
|                                                                                                                                                                                        |  |      |          |           | 4                                                |  |  |
|                                                                                                                                                                                        |  |      |          |           | OF                                               |  |  |
|                                                                                                                                                                                        |  |      |          |           | 4                                                |  |  |
|                                                                                                                                                                                        |  |      |          |           | REV                                              |  |  |
|                                                                                                                                                                                        |  |      |          |           | E                                                |  |  |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION